

MINIMUM PULLEY GUIDELINES FOR FABRICATED  
VOLTA FDR-DD BELTS

Belt Type	FDR-3-DD	
MPD Base Belt	80mm	3¼"

**Minimum Pulley Diameter for V-Cleat \***

Electrode	120mm	4.72"
VDR - 10	130mm	5.12"
VDR - 13	146mm	5.75"
VDR - 17	227mm	8.94"

**Minimum Pulley Diameter for Flat High Frequency Flights**

App. Temperature	Temp ≥ 0° C / 32° F		Temp < 0° C / 32° F	
Flight 3 – 5 mm	101mm	3.97"	151mm	5.94"
Flight 6 – 8 mm	128mm	5.04"	180mm	7.09"

**Minimum Pulley Diameter for Baseless Sidewalls\***

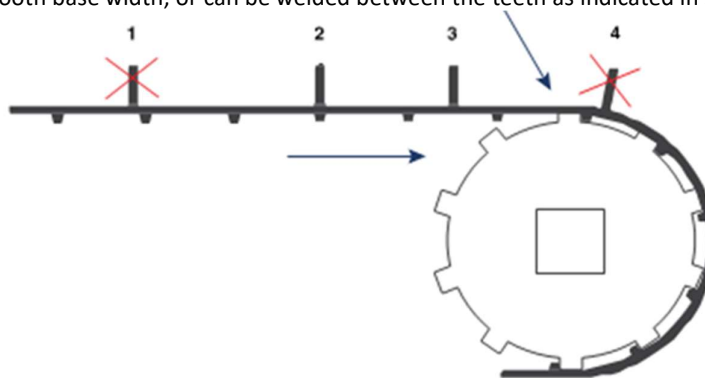
	Normal Flex		Back Flex	
B-SW 30 : 1.6mm Thick	80mm	3.15"	110mm	4.33"
B-SW 40 : 1.6mm Thick	90mm	3.54"	120mm	4.72"
B-SW 50 : 1.6mm Thick	100mm	3.94"	150mm	5.9"
B-SW 60 : 1.6mm Thick	110mm	4.33"	180mm	7.1"
B-SW 80 : 1.6mm Thick	130mm	5.12"	230mm	9.05"
B-SW 100 : 1.6mm Thick	160mm	6.3"	300mm	11.81"
B-SW 130 : 2mm Thick	210mm	8.27"	400mm	15.75"
B-SW 150 : 2mm Thick	250mm	9.84"	450mm	17.72"

**Minimum Pulley Diameter for Two Top Guides \***

Guide Type	Normal Flex		Back Flex	
VDR - 10	146mm	5.75"	153mm	6"
VDR - 13	166mm	6.54"	168mm	6.6"
VDR - 17	197mm	7.75"	199mm	7.83"

\* Wait two hours before you check the welding quality of all welding types that done with hot air.  
Liestor Set up : Welding Speed ~ 0.5 m/min ; Power: 7.5 - 8.5

- Notes:** 1.) **NR:** Not Recommended  
2.) All Inch sizes have been converted from Metric.  
3.) **HF Welded Flights** - we recommend welding the Flights above the teeth location and not to exceed the tooth base width, or can be welded between the teeth as indicated in sketch.



When choosing the pulley size, it must be equal or larger than the minimum pulley required.

1=Normal Flex  
2=Back Flex

