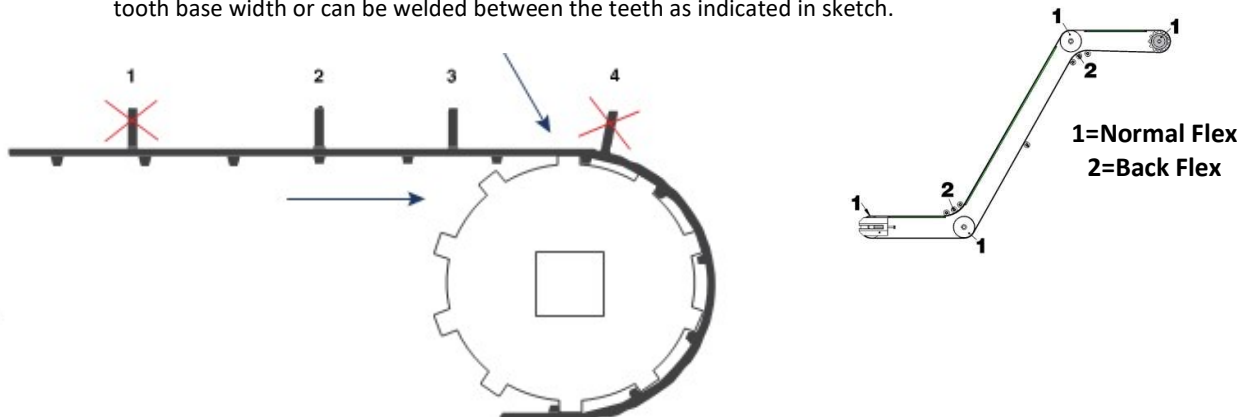


FDR & FEDR-SD - PULLEY GUIDELINES & FABRICATION OPTIONS

Belt Type	FDR-SD,FDR-SD-ITO50,FEDR-SD-ITM2,FEDR-SD-ITO50				FDR – 4- SD			
Belt Thickness	3mm				4mm			
MPD. Base Belt	80mm		3.15"		120mm		4.75"	
Minimum Pulley Diameter for V – Flights *								
Electrode	120mm		4.72"		160mm		6.3"	
VDR - 10	130mm		5.12"		170mm		6.7"	
VDR - 13	146mm		5.75"		186mm		7.32"	
VDR - 17	227mm		8.94"		273mm		10.75"	
Minimum Pulley Diameter for High Frequency welded flights								
App. Temperature	Temp ≥ 0° C / 32° F		Temp < 0° C / 32° F		Temp ≥ 0° C / 32° F		Temp < 0° C / 32° F	
Flight 3 – 5 mm	101mm	3.97"	151mm	5.94"	128mm	5.04"	180mm	7.09"
Flight 6 – 8 mm	128mm	5.04"	180mm	7.09"	143mm	5.63"	200mm	7.87"
Minimum Pulley Diameter for Baseless Sidewalls – 2 mm Thick *								
	Normal Flex		Back Flex		Normal Flex		Back Flex	
B-SW 30	80mm	3.15"	110mm	4.33"	120mm	4.72"	150mm	5.9"
B-SW 40	90mm	3.54"	120mm	4.72"	120mm	4.72"	150mm	5.9"
B-SW 50	100mm	3.94"	150mm	5.90"	120mm	4.72"	160mm	6.3"
B-SW 60	110mm	4.33"	180mm	7.10"	120mm	4.72"	190mm	7.48"
B-SW 80	130mm	5.12"	230mm	9.05"	130mm	5.12"	240mm	9.45"
B-SW 100	160mm	6.30"	300mm	11.81"	160mm	6.3"	310mm	12.2"
B-SW 130	210mm	8.27"	400mm	15.75"	210mm	8.27"	420mm	16.53"
B-SW 150	250mm	9.84"	450mm	17.72"	250mm	9.84"	470mm	18.5"
Minimum Pulley Diameter for Two Top Guides *								
Guide Type	Normal Flex		Back Flex		Normal Flex		Back Flex	
VDR - 10	139mm	5.46"	145mm	5.70"	178mm	7"	195mm	7.67"
VDR - 13	158mm	6.22"	160mm	6.30"	200mm	7.87"	210mm	8.26"
VDR - 17	197mm	7.75"	199mm	7.83"	237mm	9.33"	240mm	9.44"

* 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.) **Sidewalls & Guides** must be positioned at a minimum distance of 100mm from the belt teeth.
 4.) **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.