

**MINIMUM PULLEY GUIDELINES FOR FABRICATED VOLTA FDR BELTS**

	FDR-2		FDR-4	
	mm	inch	mm	inch
<b>Belt (a)</b>	40	1 5/8	80	3 1/8
<b>V - Guide (b) *</b>				
VDR - 10	85	3.35"	125	4.92"
VDR - 13	106	4.17"	140	5.5"
VDR - 17	NR	NR	170	6.7"
<b>V - Cleat (c) *</b>				
VDR -10	90	3.54"	130	5.12"
VDR - 13	100	4.17"	146	5.75"
VDR - 17	NR	NR	227	8.94"
<b>Flat High Frequency Flights</b>				
Flight 3-5mm, Temp ≥ 0°C / 32° F	NR	NR	130	5.11"
Flight 3-5mm, Temp < 0°C / 32° F	NR	NR	178	7"
Flight 6-8mm, Temp ≥ 0°C / 32° F	NR	NR	145	5.7"
Flight 6-8mm, Temp < 0°C / 32° F	NR	NR	207	8.15"
<b>Baseless Sidewalls (c) *</b>				
B-SW 30(Normal Flex)	80	3.15"	80	3.15"
B-SW 30 (BackFlex)	110	4.33"	110	4.33"
B-SW 40(Normal Flex)	90	3.54"	90	3.54"
B-SW 40 (BackFlex)	120	4.72"	130	4.72"
B-SW 50(Normal Flex)	100	3.94"	100	3.94"
B-SW 50 (BackFlex)	150	5.91"	150	5.91"
B-SW 60(Normal Flex)	110	4.33"	110	4.33"
B-SW 60 (BackFlex)	180	7.09"	190	7.84"
B-SW 80(Normal Flex)	NR	NR	130	5.12"
B-SW 80 (BackFlex)	NR	NR	240	9.45"
B-SW 100(Normal Flex)	NR	NR	160	3.3"
B-SW 100(Back Flex)	NR	NR	310	12.2"
B-SW 130(Back Flex)	NR	NR	210	8.27"
B-SW 130(Back Flex)	NR	NR	420	16.54"
B-SW 150(Back Flex)	NR	NR	250	9.84"
B-SW 150(Back Flex)	NR	NR	470	18.5"

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

- Notes:** 1) For belt fabrication where the guides are located below the Cleats or Sidewalls, add the V - Guide value (b) and the Cleat or Sidewall value (c) and subtract belt value (a). In the case where the Guide is not located below the Cleat or Sidewall, choose the higher of the values between the V-guide (b) and Cleat or Sidewall (c).  
 2) Dimensions have been converted from metric measurements.  
 3) **NR** =Not Recommended.