

### FEZ-SD-ITM2 - PULLEY GUIDELINES & FABRICATION OPTIONS

Belt Type	FEZ-3-SD-ITM2		FEZ-4-SD-ITM2	
MPD. Base Belt	80mm	3.15"	120mm	4.72

#### Minimum Pulley Diameter for V-Flights

	FEZ-3-SD-ITM2	FEZ-4-SD-ITM2
Electrode	120mm	150mm
VLC/VLB 10	130mm	170mm
VLC/VLB 13	140mm	180mm
VLC/VLB 17	155mm	195mm

#### Minimum Pulley Diameter for Electrode Welded Flights

	FEZ-3-SD-ITM2	FEZ-4-SD-ITM2
Single Electrode 7	125mm	150mm
Single Electrode 9	140mm	165mm
Double Electrode 7	165mm	190mm
Double Electrode 9	N.R.	N.R.

#### 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
Flight 6 – 8 mm	128mm	5.04"	180mm	7.09"	143mm	5.63"	200mm	7.87"

#### Minimum Pulley Diameter for Based Sidewalls – (working temp.range -20°C to 35°C / 4°F to 95°F)

	Normal Flex		Back Flex		Normal Flex		Back Flex	
	Sw 20	105 mm	4.13"	110 mm	4.33"	120 mm	4.72"	120 mm
Sw 30	105 mm	4.13"	125 mm	4.92"	120 mm	4.72"	125 mm	4.92"
Sw 40	115 mm	4.53"	150 mm	5.90"	130 mm	5.12"	150 mm	5.90"
Sw 50	125 mm	4.92"	175 mm	6.89"	130 mm	5.12"	175 mm	6.89"
Sw 60	130 mm	5.12"	200 mm	7.87"	135 mm	5.31"	200 mm	7.87"
Sw 80	150 mm	5.90"	250 mm	9.84"	150 mm	5.90"	250 mm	9.84"
Sw 100	200 mm	7.87"	300 mm	11.81"	200 mm	7.87"	300 mm	11.81"

#### Minimum Pulley Diameter for Baseless Sidewalls – 2mm Thick

	Normal Flex		Back Flex		Normal Flex		Back Flex	
	B-SW 30 /1"	80mm	3.15"	110mm	4.33"	120mm	4.72"	150mm
B-SW 40 /1.5"	90mm	3.54"	120mm	4.72"	120mm	4.72"	150mm	5.90"
B-SW 50 /2"	100mm	3.94"	150mm	5.90"	120mm	4.72"	160mm	6.30"
B-SW 60 /2.5"	110mm	4.33"	180mm	7.10"	120mm	4.72"	190mm	7.48"
B-SW 80 /3"	130mm	5.12"	230mm	9.05"	130mm	5.12"	240mm	9.45"
B-SW 100 /4"	160mm	6.30"	300mm	11.81"	160mm	6.30"	310mm	12.20"
B-SW 130 /5"	210mm	8.27"	400mm	15.75"	210mm	8.27"	420mm	16.53"
B-SW 150 /6"	250mm	9.84"	450mm	17.72"	250mm	9.84"	470mm	18.50"

#### Minimum Pulley Diameter for Two Top Guides

Guide Type	Normal Flex		Back Flex		Normal Flex		Back Flex	
	VL/VLB/VLC 13	145mm	5.70"	150mm	5.90"	185mm	7.28"	200mm
VL/VLB/VLC 17	177.5mm	6.99"	175mm	6.89"	217.5mm	8.56"	225mm	8.85"
CL/CLB/CLC 13	124mm	4.88"	140mm	5.51"	164mm	6.45"	190mm	7.48"
CL/CLB/CLC 17	146mm	5.74"	160mm	6.30"	186mm	7.32"	210mm	8.26"
VSB/VSC 13	125.5mm	4.94"	135mm	5.31"	165.5mm	6.52"	185mm	7.28"
VSB/VSC 17	145mm	5.70"	150mm	5.90"	185mm	7.28"	200mm	7.87"
CSB/CSC 13	110.8mm	4.36"	128mm	5.04"	150.8mm	5.93"	178mm	7"
CSB/CSC 17	124mm	4.88"	140mm	5.51"	164mm	6.45"	190mm	7.48"

NR: Not Recommended.

- For electrode welded cleats we recommend welding the cleats above the teeth location and not to exceed the tooth base width.
- Sidewalls must be positioned at a minimum distance of 100mm from the belt teeth.
- Flights can be welded on top of a tooth on condition that they do not exceed the width of the tooth or between teeth but and not in the area where pulley teeth make contact with the belt when driving it.

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

