

Manufacturing Tolerances



Roll



Length	
25 to 50 m	± 0,5 m
50 to 100 m	± 1 m
100 to 200 m	± 1,5 m
> 200 m	± 2 m

Width	
0 to 200 mm	± 1 mm
201 to 600 mm	± 2 mm
601 to 1000 mm	± 4 mm
1001 to 2000 mm	± 6 mm
2001 to 3000 mm	± 7 mm

Roll / Stock Piece "as is"



Length	
0 to 10 m	± 0,5m
10 to 25 m	± 1m
25 to 50 m	± 2m
> 50m	± 3m

Width	
0 to 200 mm	± 1 mm
201 to 600 mm	± 2 mm
601 to 1000 mm	± 4 mm
1001 to 2000 mm	± 6 mm
2001 to 3000 mm	± 7 mm

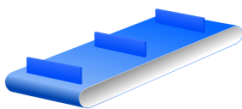
Open Belt



Length	
0 to 1 m	± 5 mm
1 to 3 m	± 10 mm
3 to 7 m	± 20 mm
> 7 m	± 0,3 %

Width	
0 to 200 mm	± 1 mm
201 to 600 mm	± 2 mm
601 to 1000 mm	± 4 mm
1001 to 2000 mm	± 6 mm
2001 to 3000 mm	± 7 mm

Fabricated Belt

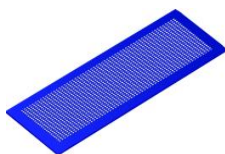


Length	Width	
	≤ 0,5 m	> 0,5 m
0 to 1 m	± 15 mm	± 10 mm
1 to 3 m	± 25 mm	± 20 mm
3 to 7 m	± 35 mm	± 30 mm
> 7 m	± 0,5 %	± 0,5 %

Width	without FPS (sealed edges)	with FPS
	0 to 200 mm	± 1 mm
201 to 600 mm	± 2 mm	-5 / +2 mm
601 to 1000 mm	± 4 mm	-6 / +2 mm
1001 to 2000 mm *	± 6 mm	-8 / +2 mm
2001 to 3000 mm	± 7 mm	-

* max. width of FPS belts: 1500 mm

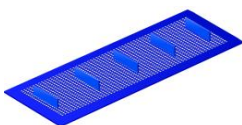
Mesh Belt



Length	
0 to 1 m	± 10 mm
1 to 3 m	± 20 mm
3 to 7 m	± 30 mm
> 7 m	± 0,5 %

Width	
0 to 200 mm	± 2 mm
201 to 600 mm	± 3 mm
601 to 1000 mm	± 6 mm
1001 to 2000 mm	± 8 mm
2001 to 3000 mm	± 10 mm

Fabricated Mesh Belt



Length	
0 to 1 m	± 10 mm
1 to 3 m	± 20 mm
3 to 7 m	± 40 mm
> 7 m	± 0,6 %

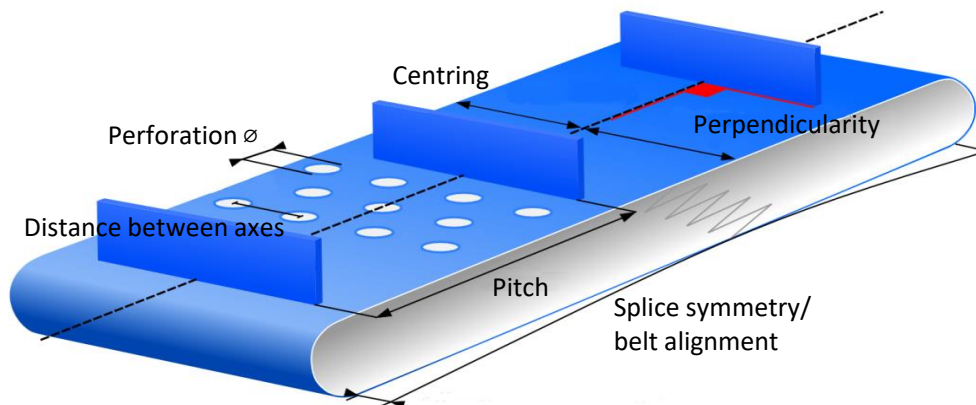
Width	
0 to 200 mm	± 2 mm
201 to 600 mm	± 4 mm
601 to 1000 mm	± 8 mm
1001 to 2000 mm	± 12 mm
2001 to 3000 mm	± 14 mm

General Tolerances for Belts

Total thickness	± 0,1 mm per ply
Weight	± 10 %
Coefficient of friction on steel slider bed	± 20 %
Breaking strength	-10% / +20%
k1% tensile force	-10% / +20%
Max. tensile force	-10% / +20%

Accessories and Fabrication

Pitch	± 2 mm (non-accumulative)
Perpendicularity	2 mm for widths ≤ 200 mm 1 % for widths > 200mm
Centring	± 2 mm
Distance between axes	± 2 mm (non-accumulative)
Length	± 2 mm
Height	± 10 %
Splice symmetry and belt misalignment	0,1 % of the length
Perforation diameter (except jointing area)	± 0,5 mm for $\varnothing \leq 20$ mm ± 1 mm for $\varnothing > 20$ mm



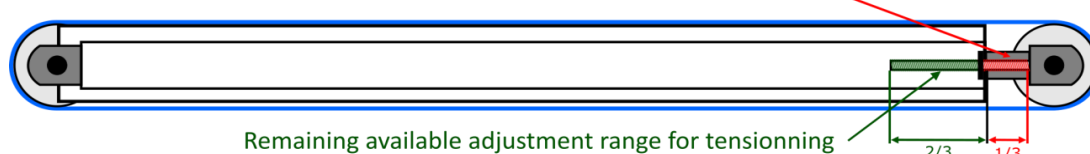
Determining the adjustment range for belt tensioning

The adjustment range on the conveyor must be at least 1,5% of the total length of the belt. Hence, for a belt with a total length of 10 m, the tensioning system of the conveyor must at least have an adjustment range of 150 mm.

Determining the length of a belt

The length of a belt must be measured with the tension system drawn out at 1/3. To fit the belt, the tension system must be completely retracted. Then there is still 2/3 of the adjustment range left in order to put tension on the belt.

The tension system must be pulled out to 1/3 of the total adjustment range



Taking into account the fabrication tolerances, it is essential to check the available adjustment range on the conveyor beforehand. If your adjustment range is less than 1,5 % of the belt length, please let us know.

Light Conveyor Belts & Belt Bend Conveyors

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