

Ammeraal Beltech Standard Tolerances on Synthetic Cut Belts, Fabrication and Accessories



Introduction

The International standard EN ISO 15147 for Light conveyor belts specifies methods for the measurement of widths and lengths of cut belts as described in EN 873 and specifies the tolerances on the dimensions.

Ammeraal Beltech operating companies operate according to the internal Ammeraal Beltech standard, which generally define tighter tolerances than EN ISO 15147. Customer specific tolerances may be specified in the order, though there are limits due to the nature of synthetic material and the processes involved. The tolerances do not include changes in width or length which can arise after fabrication due to fluctuations in ambient conditions or other external factors.

Tolerances on belts

When measured in accordance with EN ISO 15147, the difference between the measured length, width and thickness, and the specified cut length, width and thickness shall not vary by more than the tolerance specified in the following table.

Tolerance	On Length		On Width		With Amseal
Open length 1)	+0.5% / - 0 Min. 10mm		<= 500mm	± 1mm	± 2mm
Prepared for splicing and endless spliced 2)	<= 2000mm	± 10mm	>= 501 and <= 2000mm	± 2mm	± 3mm
	>= 2001 <= 7000mm	± 20mm	>= 2001mm	± 3mm	± 4mm
	>= 7001mm	± 0.3%			
1) Length tolerance on full slab material +500mm / - 0 2) Tolerance on thickness in the splice area is 0.25mm; specific tolerances for belts on request					

Squareness left / right side

Open Length (90°) 3)	Maximum 5mm
Endless Spliced	
3) Squareness is measured at an angle of 90° and is only applicable where belts are specifically requested as "Cut Square"	

It is recommended that actual cut widths of belt should be specified in incremental steps of 50 mm for cut widths up to 1000mm, and incremental steps of 100 mm for cut widths over 1000mm. Dimensions are in mm and have to be measured with a calibrated tape ruler. The tolerances are defined by a material temperature of 20°C and a belt tension of 0 N/mm.

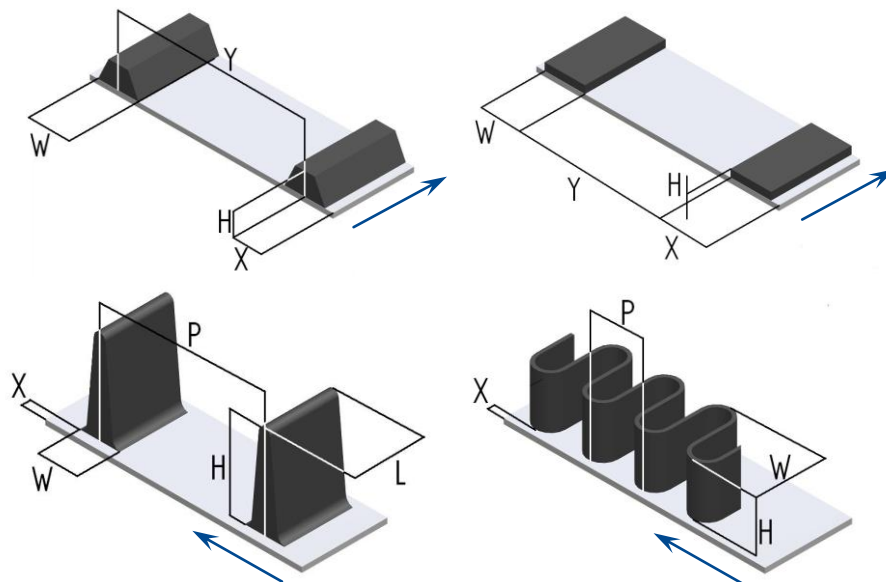
Ammeraal Beltech Standard Tolerances on Synthetic Cut Belts, Fabrication and Accessories



Tolerances on Accessories

When accessories are supplied loose the difference between the measured length, width and height shall not vary by more than the tolerance specified in the following table. The table also gives the tolerances of accessories fitted on the conveyor belt.

Tolerance on	Length	Width (W)	Height (H)	Pitch (Y) or (P)	From Edge (X)
All ropes, guides, cleats, Bordoflex					
Supplied loose	+ 100 mm / - 0	<i>Manufacturing tolerances</i>		N/A	N/A
Ropes – V, rectangular, square					
Fitted longitudinally	N/A	± 1mm	± 0.5mm	+ 2mm / - 0mm *	± 2mm
Fitted as carriers	+0 / - 5mm			± 5 mm	+ 5mm / - 0
<i>Straightness of Ropes</i>	N/A	N/A	N/A	N/A	± 1.5mm
*) <i>Two ropes mounted as tracking guide</i>					
Guide strips					
Fitted longitudinally	N/A	± 1mm	± 0.5mm	+ 4 / - 0mm *	± 2 mm
<i>Straightness of Guide Strip</i>	N/A	N/A	N/A	N/A	± 1.5mm
*) <i>Two strips mounted as tracking guide</i>					
Cleats					
Solid, fitted	± 5 mm	± 1mm	± 2mm	± 5mm	± 5mm
Reinforced, fitted		± 5mm	± 3mm		
Bordoflex					
Solid, fitted	N/A	± 0.5mm *	± 1mm	± 0.5mm	± 5mm
Reinforced, fitted	N/A	± 1.5mm *	± 2mm	± 2mm	
*) <i>Tolerance on the width of the Bordoflex wave</i>					



This information is given free of charge and subject to continuous development. Any claim as a result from misinterpretation of the information will be discharged. This information replaces previous versions.

Ammeraal Beltech Standard Tolerances on Synthetic Cut Belts, Fabrication and Accessories**Additional Fabrication Tolerances**

Punched Holes	Tolerance
Diameter	± 1mm
Position of first hole from belt edge	± 2mm
Hole to hole centres in Length direction	± 2mm
Hole to hole centres in width Direction	± 2mm

Curved Belts	Tolerance	
Belt Width	± 2mm	
Outer Radius	± 2mm	
Outer Length	<= 2000mm	± 10mm
	>= 2001 <=7000mm	± 20mm
	>= 7001mm	± 0.3%
Inner Radius	± 2mm	
Inner Length	<= 2000mm	± 10mm
	>= 2001 <=7000mm	± 20mm
	>= 7001mm	± 0.3%
Relationship Outer Length to Inner Length	Maximum 5mm	
Guide Roller / Strip Radius	± 2mm	
Hole / Guide Roller Pitch (Non positive drive)	± 20mm	
Hole / Guide Roller Pitch (Positive drive)	± 2mm from datum point	