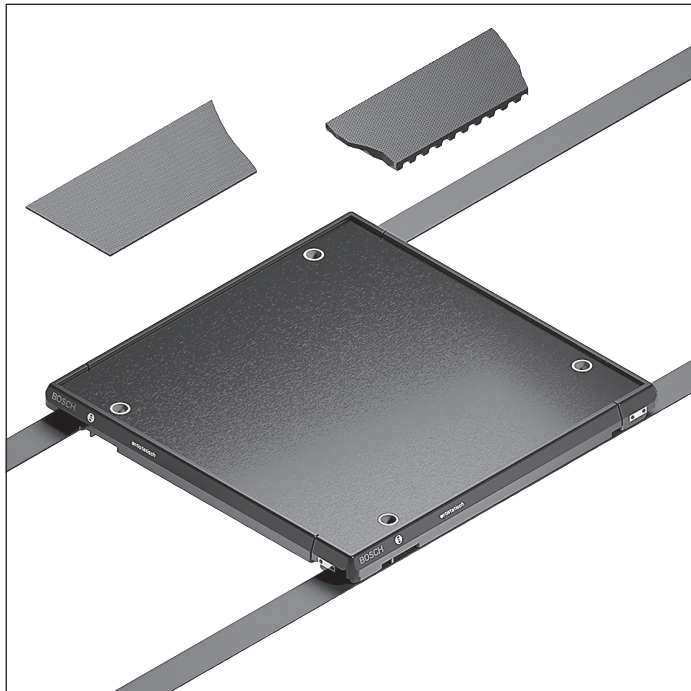


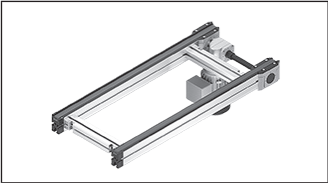
## Belt and toothed belt conveyor medium



The belt and toothed belt conveyor media are suitable for conveying small and medium-sized workpiece pallets in clean, dry environments. The high flexibility and flat design of the conveyor media allow for narrow conveyor trenches between section profiles.

Whereas the belt is an especially economical conveyor medium, primarily utilized on longer section segments, the toothed belt is suitable for shorter section segments and/or driving neighboring modules without their own drives.

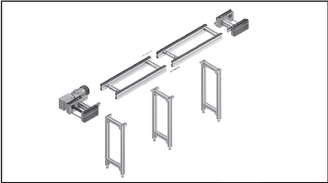
The conveyor media, or the modules equipped with these media, are used for assembly of lightweight products, e.g., electrical household appliances. Features such as a low risk of drawing-in and low profile construction height, as well as quiet operation, facilitate use at manual assembly stations. A surface load of up to 1 kg/cm is permissible on workpiece pallets with PA wear pads.



**BS 2 belt sections**



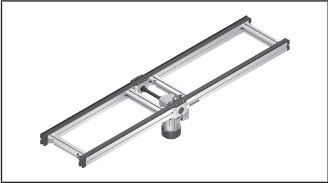
**3-6**



**Parts for AS 2, UM 2, ST 2  
conveyor units**



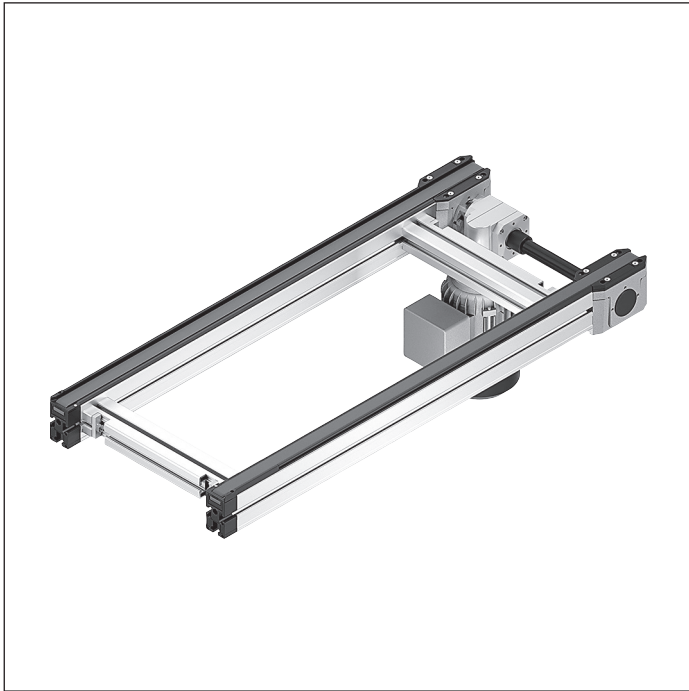
**3-16**



**Connection kits**

**3-236**

## BS 2 belt section



- ▶ Ready for operation conveyor section with own drive
- ▶ Accumulation operation possible
- ▶ Conveyor medium: Toothed belt (suitable for use in an EPA)
- ▶ Reversible operation possible
- ▶ Right, left or central motor mounting (central from track width of 240 mm)
- ▶ Motor connection: optionally with cable/plug or terminal box
- ▶ Special models on request

The belt section is a ready for operation conveyor section with own drive for the transportation of workpiece pallets in the longitudinal direction or for the transverse conveying

of the workpiece pallet between parallel conveyor sections in connection with two HQ 2 lift transverse units.

### Accessories

#### Recommended accessories

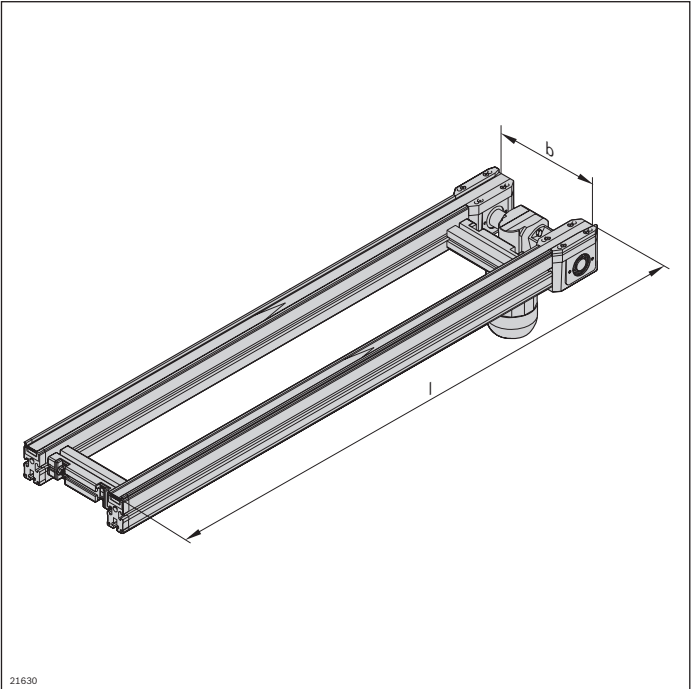
- ▶ Connection kit, see page 3-236
- ▶ SZ 2 leg sets, see page 6-2

### Delivery notes

#### Condition on delivery

- ▶ Fully assembled

Ordering information



Material number		3842999716
b (mm)	Track width in direction of transport	160; 240; 320; 400; 480; 640; 800; 1040; 1200 160 ... 1200 <sup>1)</sup>
l (mm)	Length	240 ... 6000 <sup>2)</sup>
v <sub>N</sub> (m/min)	Nominal speed	0 <sup>3)</sup> ; 6; 9; 12; 15; 18
U (V)	Voltage	See motor data, p. 11-24ff
f (Hz)	Frequency	See motor data, p. 11-24ff
AT	Motor connection S = cable/plug K = terminal box	S; K
MA	Motor mounting R = right L = left M = center	R; L; M <sup>4)</sup>

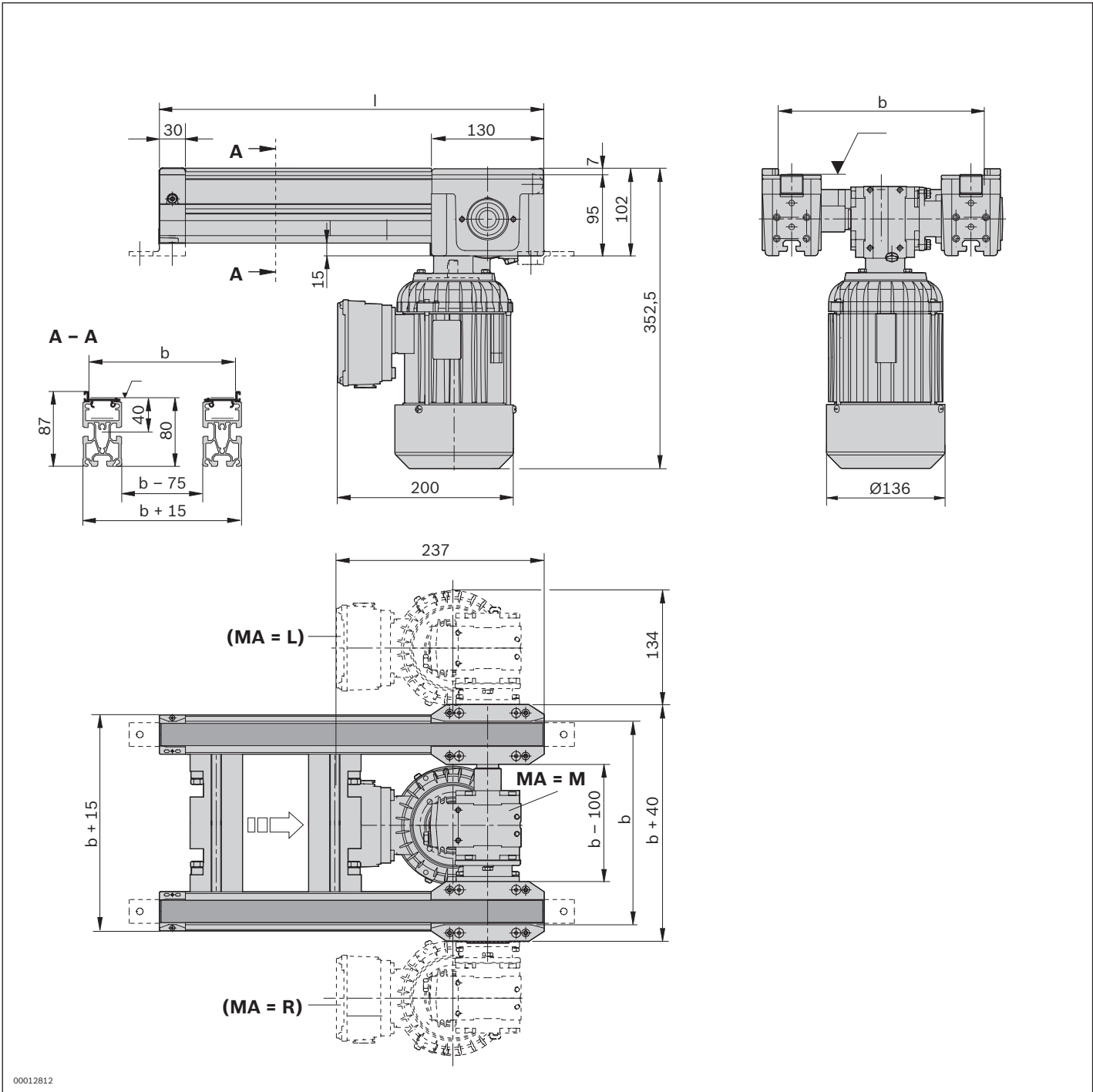
<sup>1)</sup> Individual width variants available  
<sup>2)</sup> l is rounded in accordance with the toothed belt pitch  
<sup>3)</sup> v<sub>N</sub> = 0: without motor or gear  
<sup>4)</sup> When MA = M and b = 160 mm, the max. section load is only 30 kg

Technical data

Material number		3842999716
Load		
Max. section load in accumulation operation	kg	60 <sup>5)</sup>
Features		
ESD		Yes
Material specification		Section profile: Aluminum, natural; anodized Guide profile: polyamide Glide profile: polyamide
Dimensions		
Length	l mm	240 ... 6000

<sup>5)</sup> When MA = M and b = 160 mm, the max. section load is only 30 kg

Dimensions



## BS 2/M belt section



- ▶ Functional operation conveyor complete with drive
- ▶ Accumulation operation possible
- ▶ Conveyor medium: Toothed belt (suitable for use in an EPA)
- ▶ Reversible operation possible
- ▶ Right, left or central motor mounting (central from track width of 240 mm)
- ▶ Motor connection: optionally with cable/plug or terminal box
- ▶ Special models on request

3

The belt section is a conveyor section that is ready for operation with own drive for the transportation of workpiece pallets. It is suitable for all installation situations

in which the motor cannot be fitted to the end of the belt section.

### Accessories

#### Recommended accessories

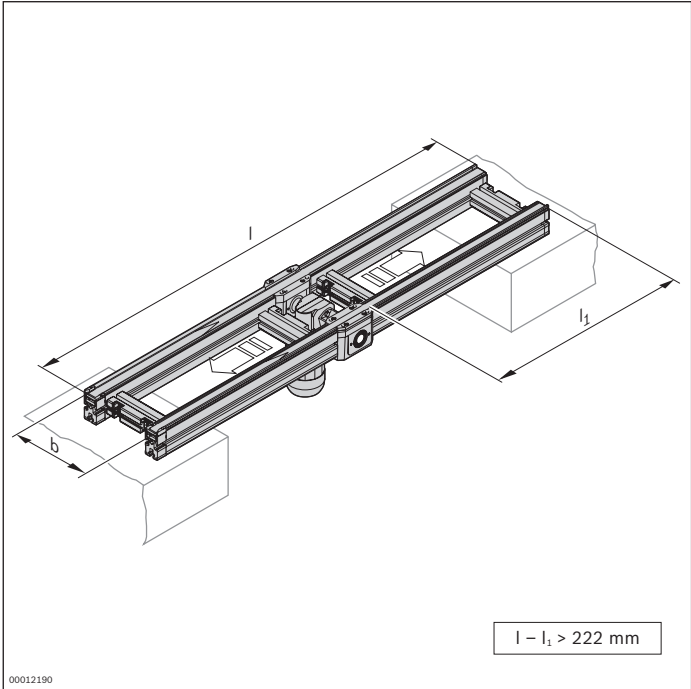
- ▶ Connection kit, see page 3-236
- ▶ SZ 2/... leg sets, see page 6-2

### Delivery notes

#### Condition on delivery

- ▶ Fully assembled

Ordering information



Material number		3842999717
b (mm)	Track width in direction of transport	160; 240; 320; 400; 480; 640; 800; 1040; 1200 160 ... 1200 <sup>1</sup>
l (mm)	Length	310 ... 6000 <sup>2</sup>
l <sub>1</sub> (mm)	Length	90 ... 5770
v <sub>N</sub> (m/min)	Nominal speed	0 <sup>3</sup> ; 6; 9; 12; 15; 18
U (V)	Voltage	See motor data, p. 11-24ff
f (Hz)	Frequency	See motor data, p. 11-24ff
AT	Motor connection S = cable/plug K = terminal box	S; K
MA	Motor mounting R = right L = left M = center	R; L; M <sup>4</sup>

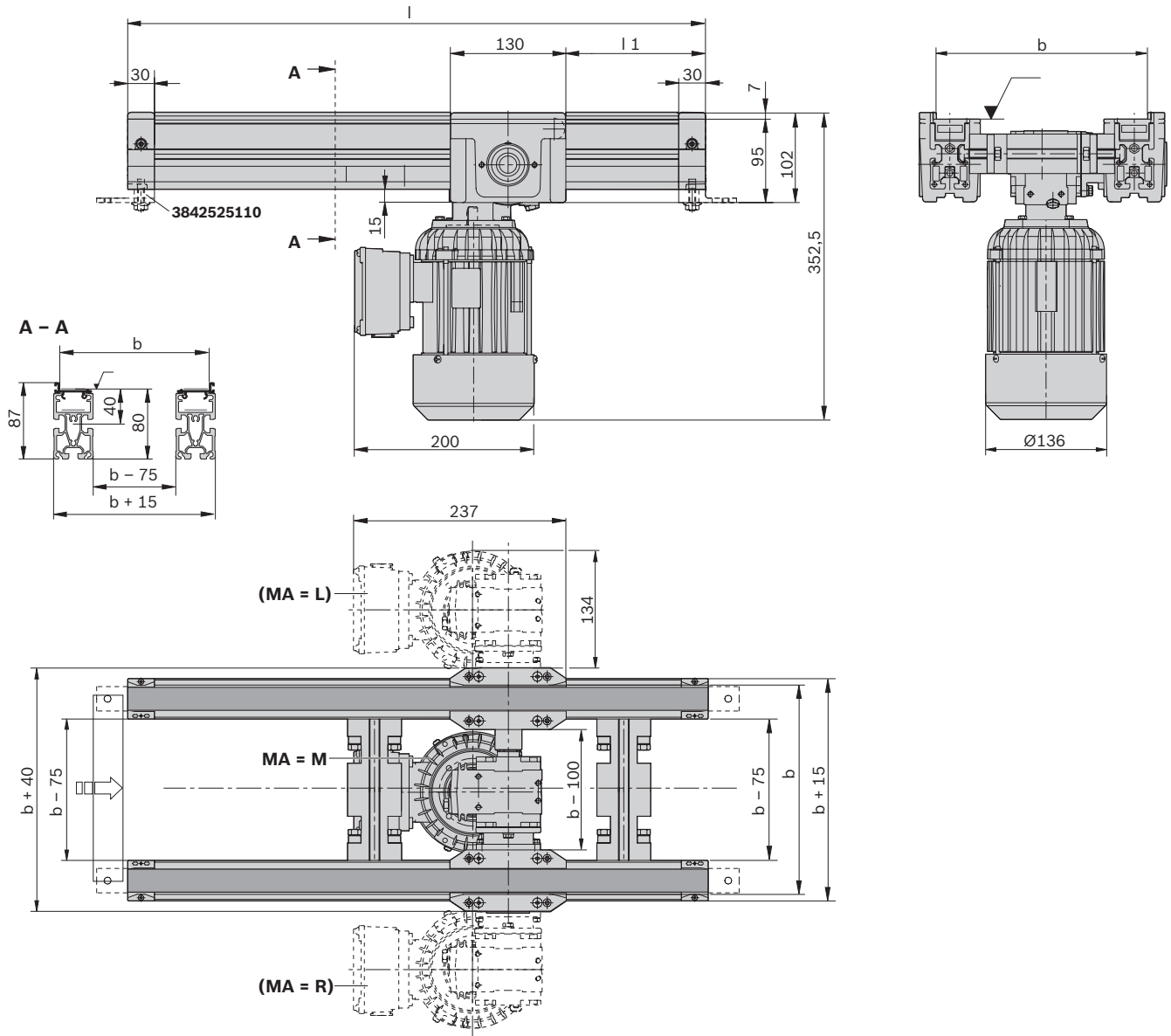
<sup>1)</sup> Individual width variants available  
<sup>2)</sup> l is rounded in accordance with the toothed belt pitch  
       l - l<sub>1</sub> > 222 mm  
<sup>3)</sup> v<sub>N</sub> = 0: without motor or gear  
<sup>4)</sup> When MA = M and b = 160 mm, the max. section load is only 30 kg

Technical data

Material number		3842999717
<b>Load</b>		
Max. section load in accumulation operation	kg	60 <sup>5</sup>
<b>Features</b>		
ESD		Yes
Material specification		Section profile: Aluminum, natural; anodized Guide profile: Polyamide Glide profile: Polyamide
<b>Dimensions</b>		
Length	l mm	310 ... 6000

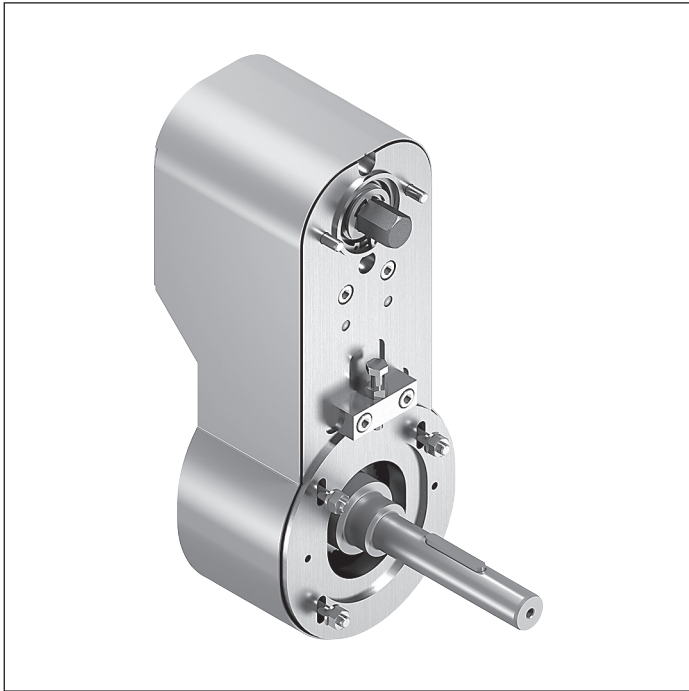
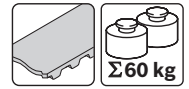
<sup>5</sup> When MA = M and b = 160 mm, the max. section load is only 30 kg

## Dimensions





## Transmission drive



- ▶ Timing belt side drive for gear motors that must be constructed set lower so that they can be driven over
- ▶ Suitable for flange mounted gears, flange diameter 120 mm (B5 version with worm gear) and hollow shaft, diameter 20 mm
- ▶ Designed for Spiroplan SEW, WAF20, WAF30 or WAF37 right-angle gear motors and SAF37 worm gear motors
- ▶ Reversible operation possible
- ▶ Suitable for mounting to BS 2 and BS 2/M belt sections
- ▶ Maximum transferable torque (on the gear output):  
 $m_{\max} = 12 \text{ Nm}$
- ▶ Only suspended mounting of the gear motor is permitted

For mounting larger third-party motors for the transmission of higher drive torques (maximum section loads of the belt section must not be exceeded).

### Accessories

#### Required accessories

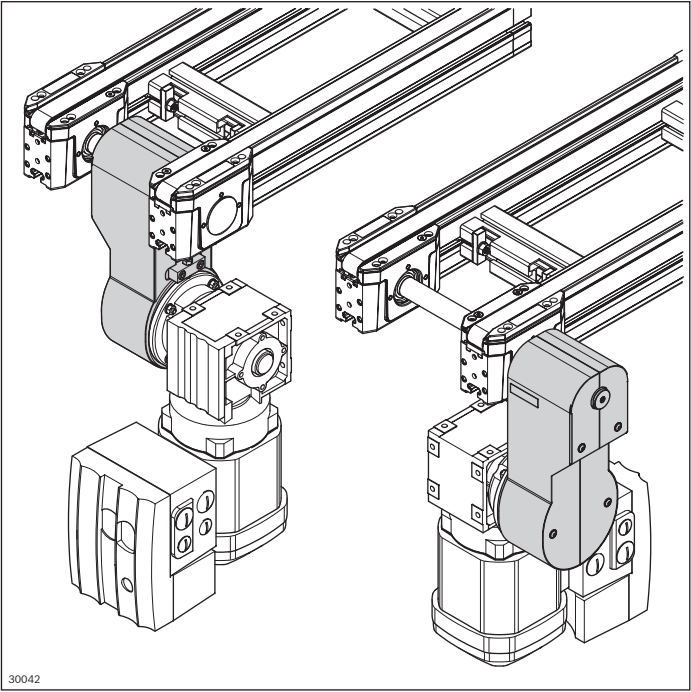
- ▶ BS 2 (see p. 3-6) or BS 2/M (see p. 3-9) belt section
- ▶ Gear motor
- ▶ Torque support (to be supplied by the operator)

### Delivery notes

#### Condition on delivery

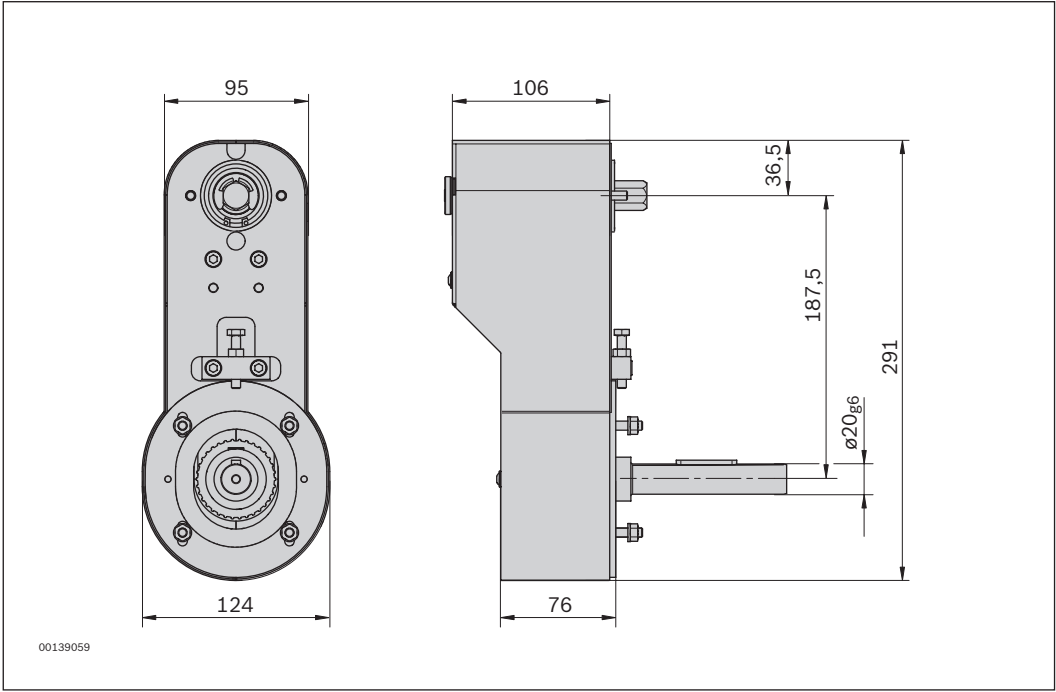
- ▶ Unassembled in parts
- ▶ Bearing already press-fitted
- ▶ Including adapter set and additional hexagonal shaft

Ordering information



Product designation		Material number
Transmission drive		3842542550
Technical data		
Material number		3842542550
Load		
Maximum transferable torque	Nm	12
Features		
ESD		Yes

**Dimensions**

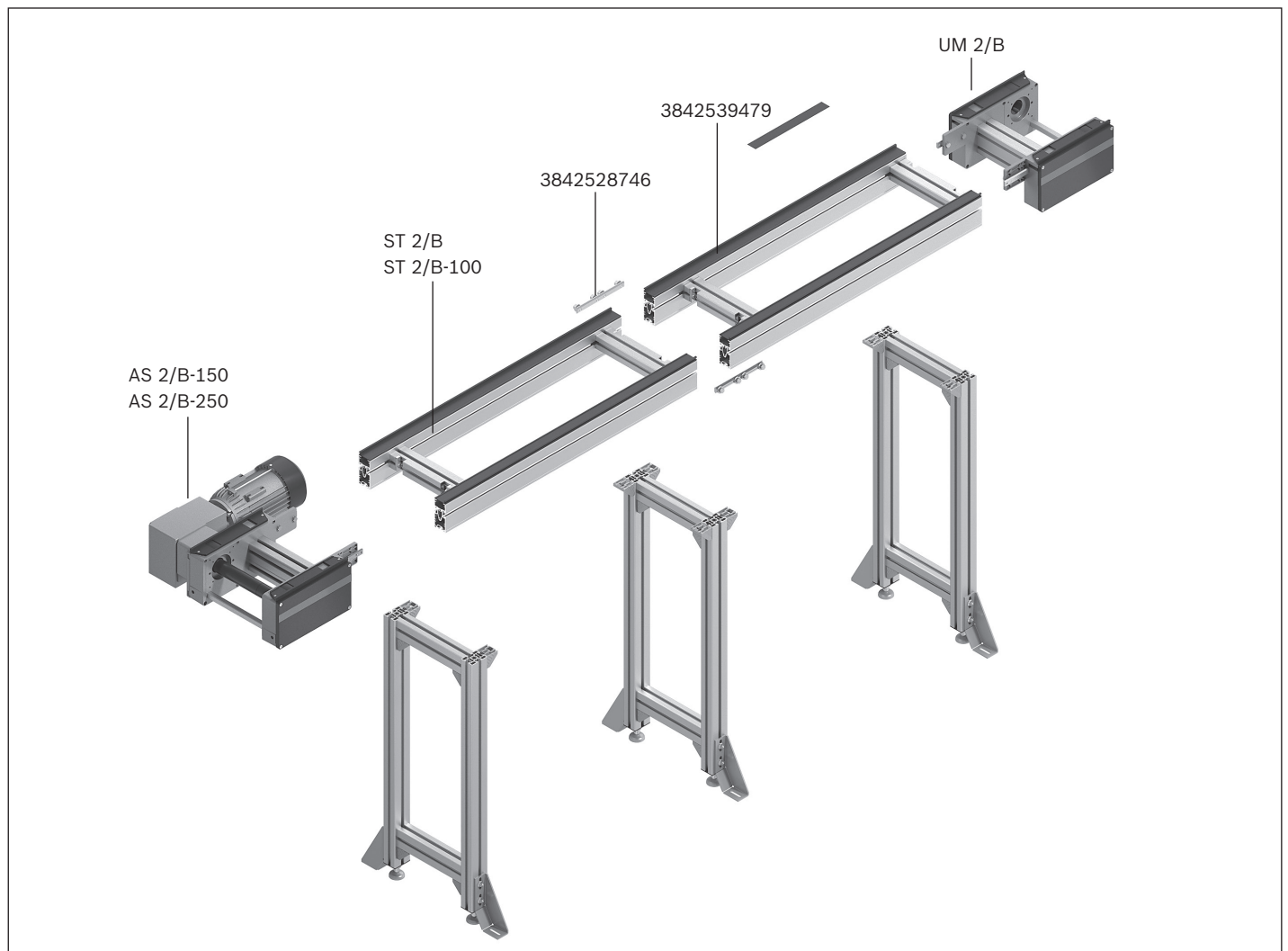






## Conveyor units

### Parts for belt conveyor medium

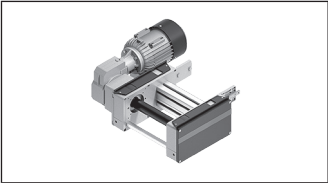


A conveyor unit is a complete unit used for linear conveying of workpiece pallets. It consists of:

- ▶ AS 2/B-... drive module, see p. 3-18
- ▶ UM 2/B return unit, see p. 3-24
- ▶ ST 2/... section, see p. 3-28
- ▶ SZ 2/... leg sets, see page 6-2

The UM 2/B and AS 2/B may be set up right next to each other, which allows for conveyor unit combinations.

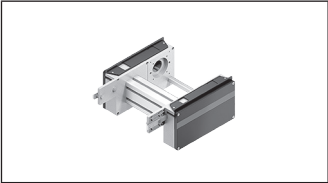
The drive module is designed for section loads up to  $m_G = 150$  kg or up to  $m_G = 250$  kg per conveyor unit.



**AS 2/B drive module**



**3-18**



**UM 2/B return unit**



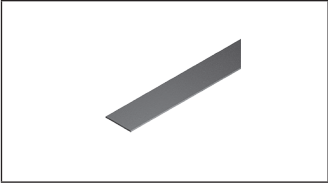
**3-24**



**ST 2/B section, components**



**3-28**

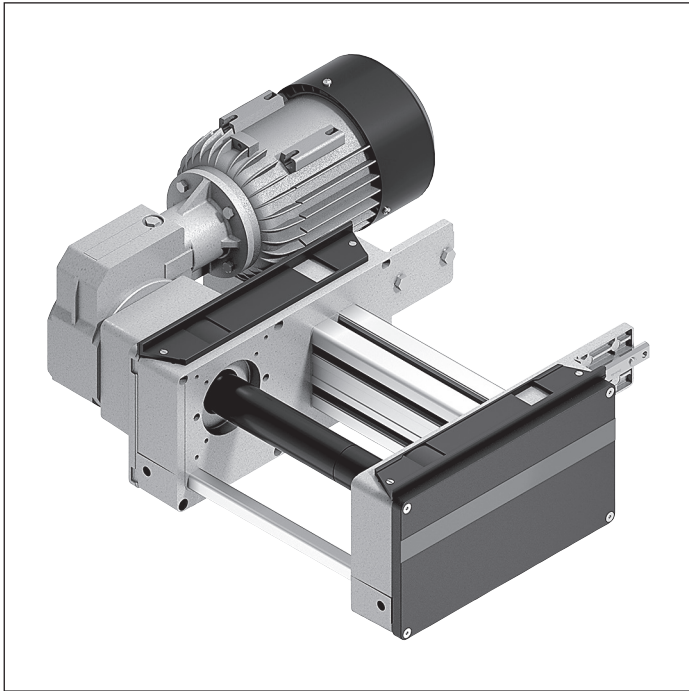


**Belt conveyor medium, accessories**



**3-45**

## AS 2/B-150 drive module



- Conveyor medium: Belt (suitable for use in an EPA)
- Motor connection: optionally with cable/plug or terminal box
- Special models on request
- Accumulation operation possible

The AS 2/B-... drive module drives the conveyor medium belt in self-built conveyor section elements with section,

return unit and conveyor belt or serves as a transverse section.

### Accessories

#### Required accessories

- RB 2 roller track (3842532822, see p. 3-27) with adjacent longitudinal sections and workpiece pallet lengths of < 320 mm
- RB 2/UM 2 roller track set (3842558657 see p. 5-88) for use in transverse sections with adjacent longitudinal sections

### Delivery notes

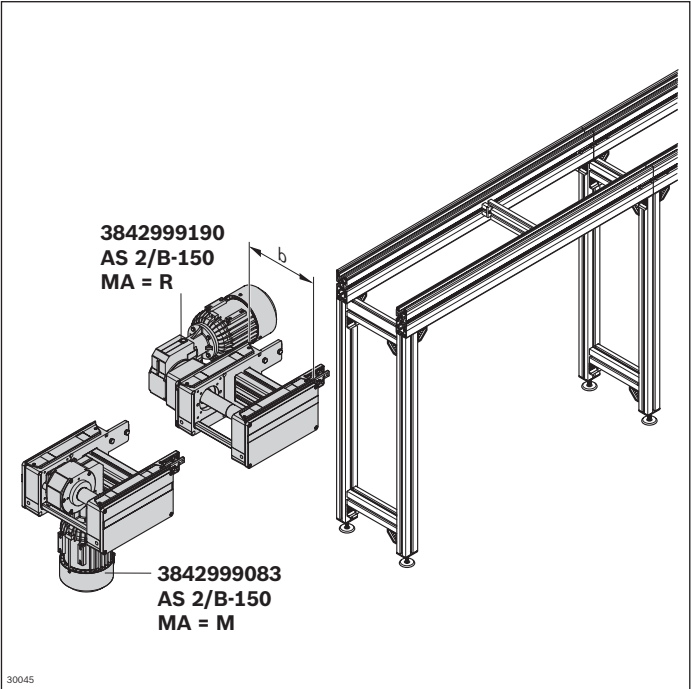
#### Scope of delivery

- AS 2/B-150 drive module
- Includes fastening material to mount on the ST 2 conveyor section, as well as to mount on an adjacent return unit.

#### Condition on delivery

- Fully assembled

Ordering information



Material number		3842999083	3842999190
b (mm)	Track width in direction of transport	160; 240; 320; 400; 480; 640; 800; 1040; 1200	160 ... 1200 <sup>1</sup>
v <sub>N</sub> (m/min)	Nominal speed	0 <sup>2</sup> ; 6; 9; 12; 15 <sup>3</sup> ; 18	
U (V)	Voltage	See motor data, p. 11-24ff	
f (Hz)	Frequency	See motor data, p. 11-24ff	
AT	Motor connection	S; K	
	S = cable/plug		
	K = terminal box		
MA	Motor mounting	R <sup>4</sup> ; L <sup>4</sup> ; M	
	R = right		
	L = left		
	M = center		

- <sup>1</sup>) Individual width variants available  
<sup>2</sup>) v<sub>N</sub> = 0: without motor or gear  
<sup>3</sup>) Not possible at f = 60 Hz  
<sup>4</sup>) The following applies to 3842999190: MA = R; L

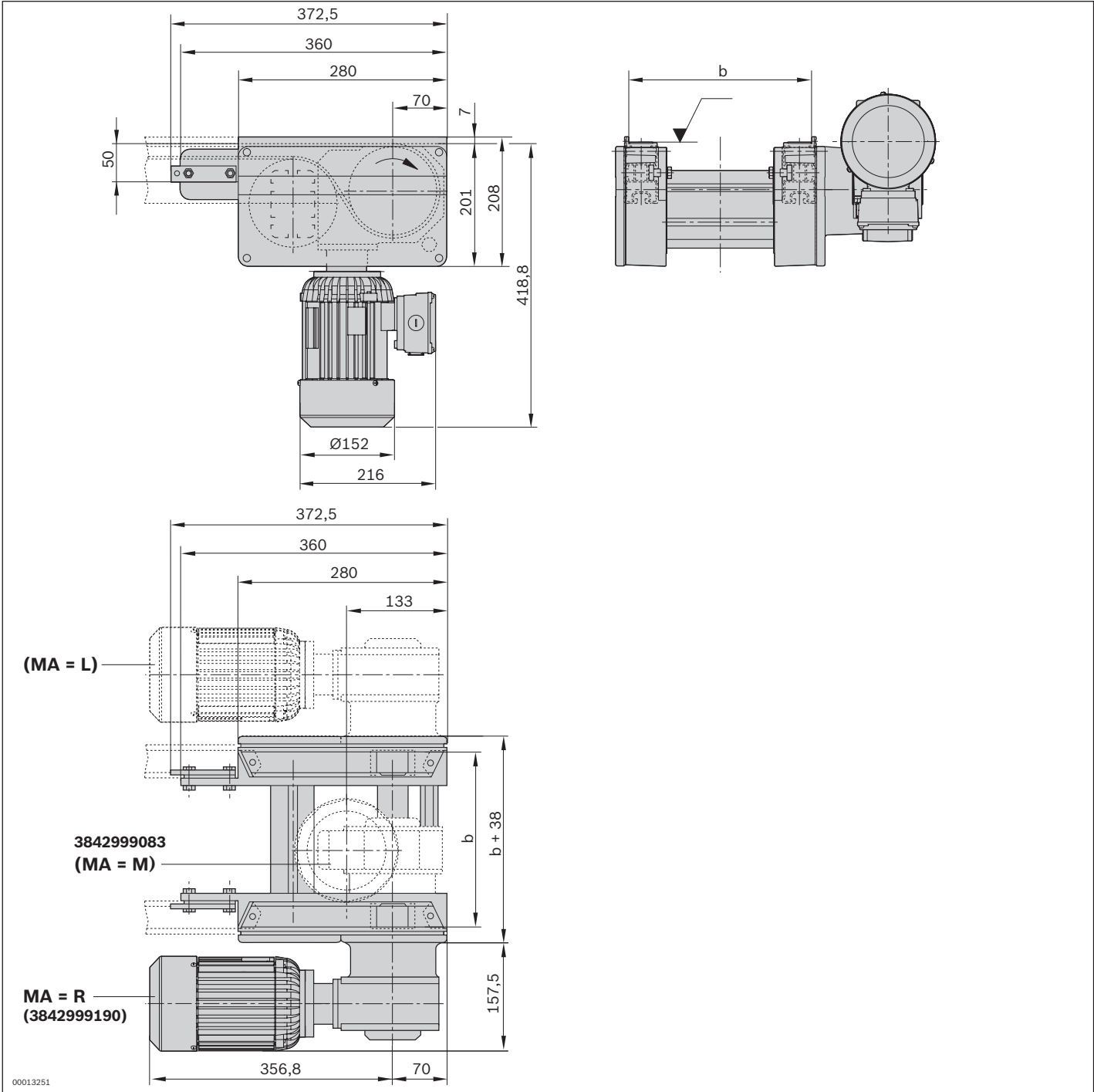
Technical data

Material number		3842999083	3842999190
Motor mounting		MA = M	MA = R, L
Load			
Max. section load in accumulation operation		150	150
Features			
ESD		Yes	Yes
Additional information			
Required conveyor medium length*	l <sub>AS</sub>	660	660

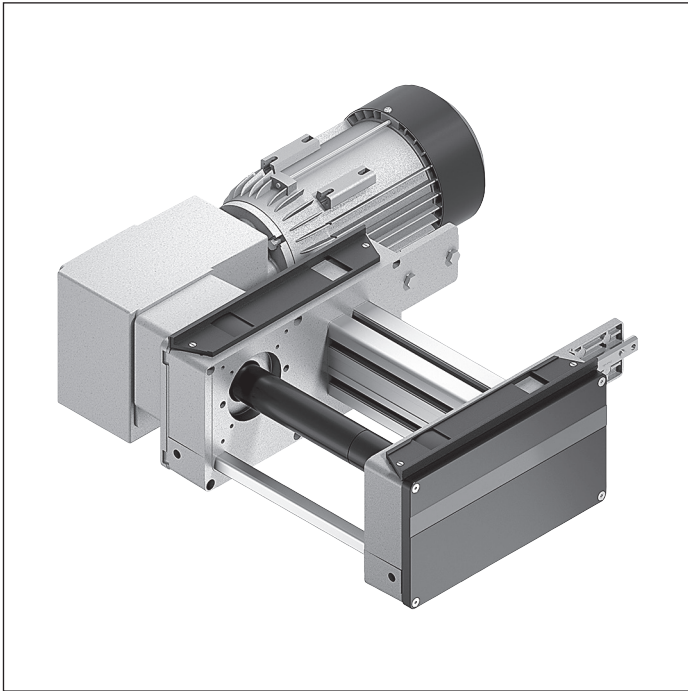
\* Formula for calculating the conveyor medium, see p. 3-46



Dimensions



## AS 2/B-250 drive module



- ▶ Conveyor medium: Belt (suitable for use in an EPA)
- ▶ Motor connection: optionally with cable/plug or terminal box
- ▶ Special models on request
- ▶ Accumulation operation possible

3

The AS 2/B-... drive module drives the conveyor medium belt in self-built conveyor section elements with section,

return unit and conveyor belt or serves as a transverse section.

### Accessories

#### Required accessories

- ▶ RB 2 roller track (3842532822, see p. 3-27) with adjacent longitudinal sections and workpiece pallet lengths of < 320 mm
- ▶ RB 2/UM 2 roller track set (3842558657 see p. 5-88) for use in transverse sections with adjacent longitudinal sections

### Delivery notes

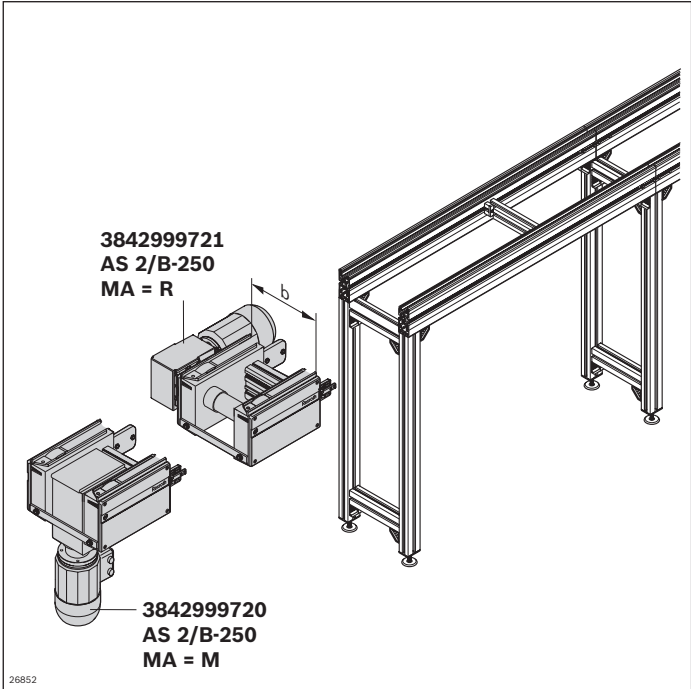
#### Scope of delivery

- ▶ AS 2/B-250 drive module
- ▶ Includes fastening material to mount on the ST 2 conveyor section, as well as to mount on an adjacent return unit.

#### Condition on delivery

- ▶ Fully assembled

Ordering information



Material number		3842999720	3842999721
b (mm)	Track width in direction of transport	160; 240 <sup>1)</sup> ; 320; 400; 480; 640; 800; 1040; 1200	240 ... 1200 <sup>2)</sup>
v <sub>N</sub> (m/min)	Nominal speed	0 <sup>3)</sup> ; 6; 9; 12; 15; 18	
U (V)	Voltage	See motor data, p. 11-24ff	
f (Hz)	Frequency	See motor data, p. 11-24ff	
AT	Motor connection S = cable/plug K = terminal box	S; K	
MA	Motor mounting R = right L = left M = center	R <sup>4)</sup> ; L <sup>4)</sup> ; M <sup>1)</sup>	

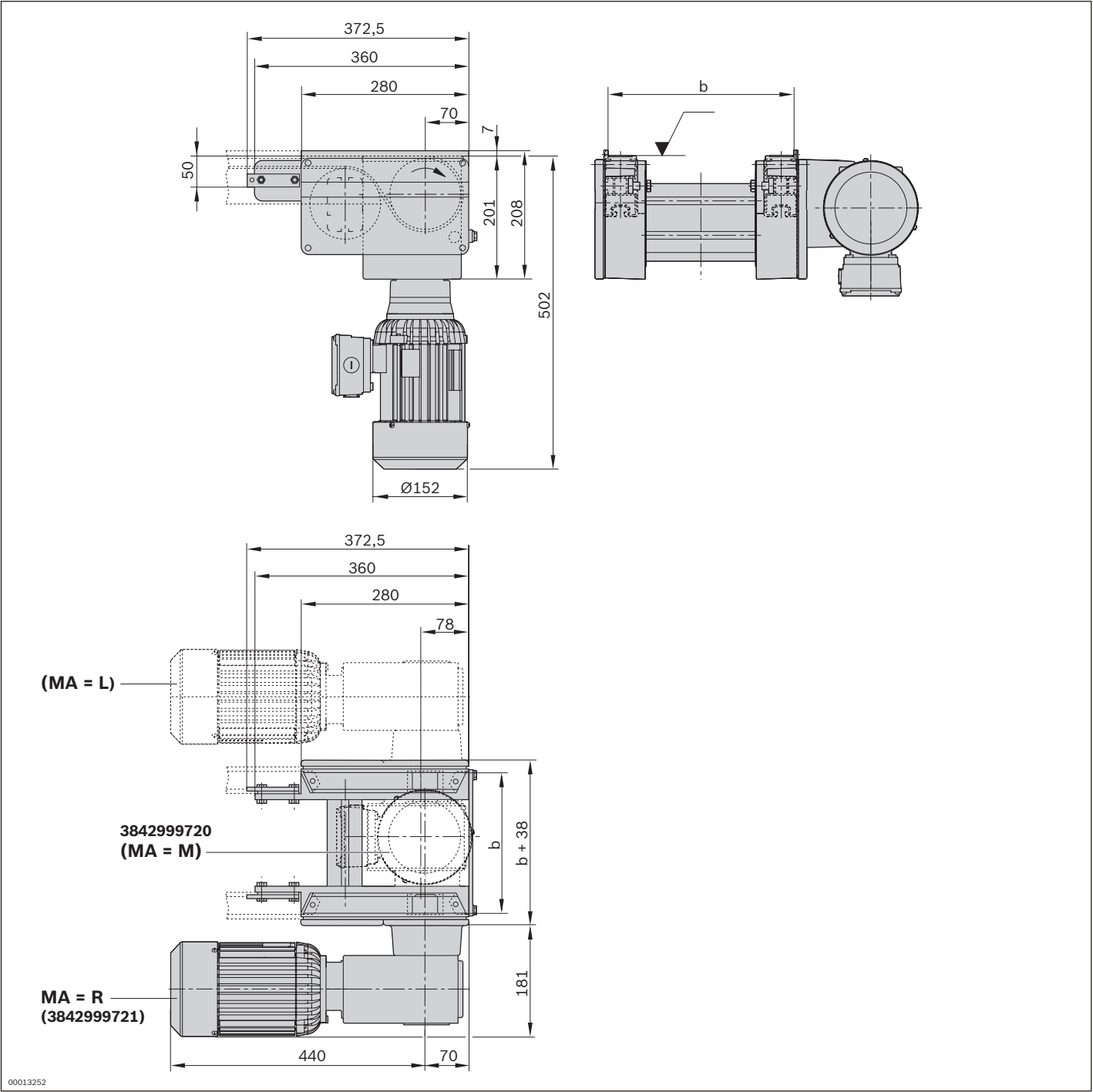
<sup>1)</sup> The following applies to 3842999720: MA = M and b ≥ 240 mm  
<sup>2)</sup> Individual width variants available  
<sup>3)</sup> v<sub>N</sub> = 0: without motor or gear  
<sup>4)</sup> The following applies to 3842999721: MA = R; L

Technical data

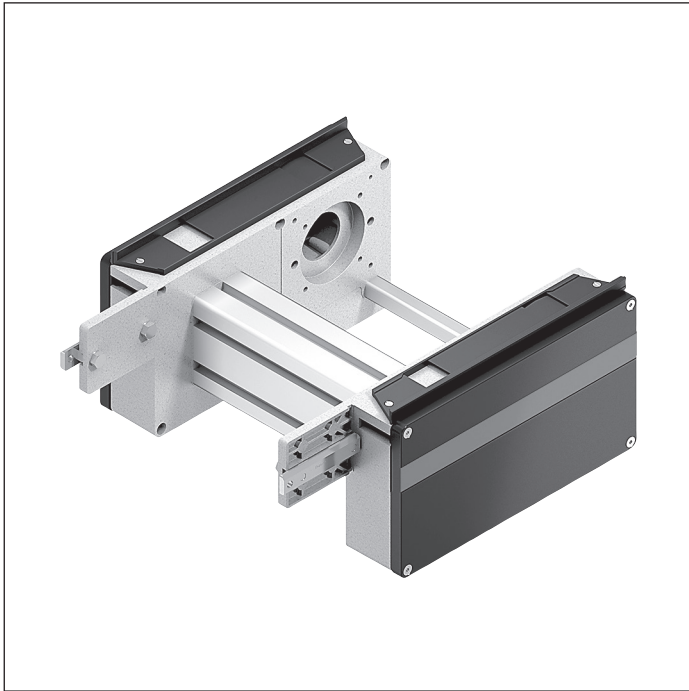
Material number		3842999720	3842999721
Motor mounting		MA = M for b ≥ 240 mm	MA = R, L
Load			
Max. section load in accumulation operation		250	250
Features			
ESD		Yes	Yes
Additional information			
Required conveyor medium length*	l <sub>AS</sub>	660	660

\* Formula for calculating the conveyor medium, see p. 3-46

Dimensions



## UM 2/B return unit



- Conveyor medium: Belt (suitable for use in an EPA)
- For use in conjunction with all AS 2/B drive modules
- Max. permissible section load up to 250 kg in accumulation operation per conveyor unit

The return unit is used for constructing conveyor units. It guides the conveyor medium at the end of the conveyor unit back to the drive module.

### Delivery notes

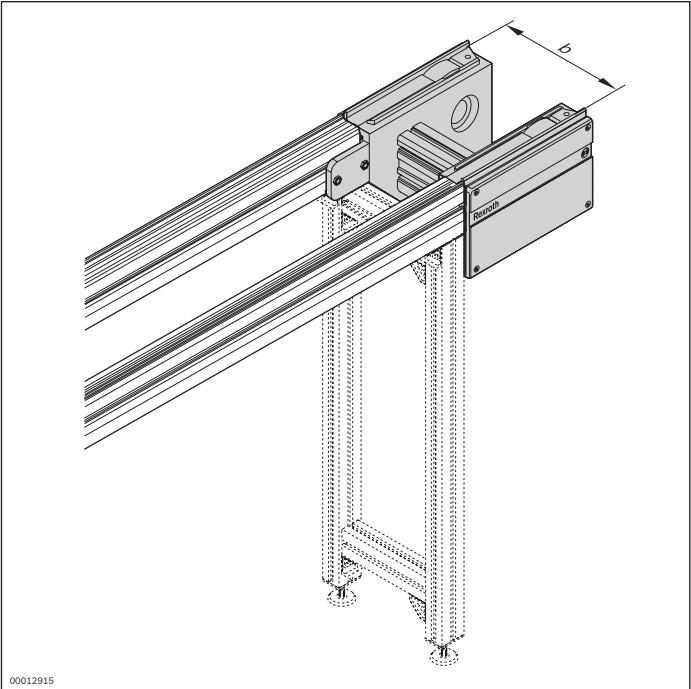
#### Scope of delivery

- Incl. all fastening material to mount on ST 2 conveyor section

#### Condition on delivery

- Fully assembled

Ordering information



Material number		3842999090
b (mm)	Track width in direction of transport	160; 240; 320; 400; 480; 640; 800; 1040; 1200
		160 ... 1200 <sup>1</sup>

<sup>1</sup> Individual width variants available

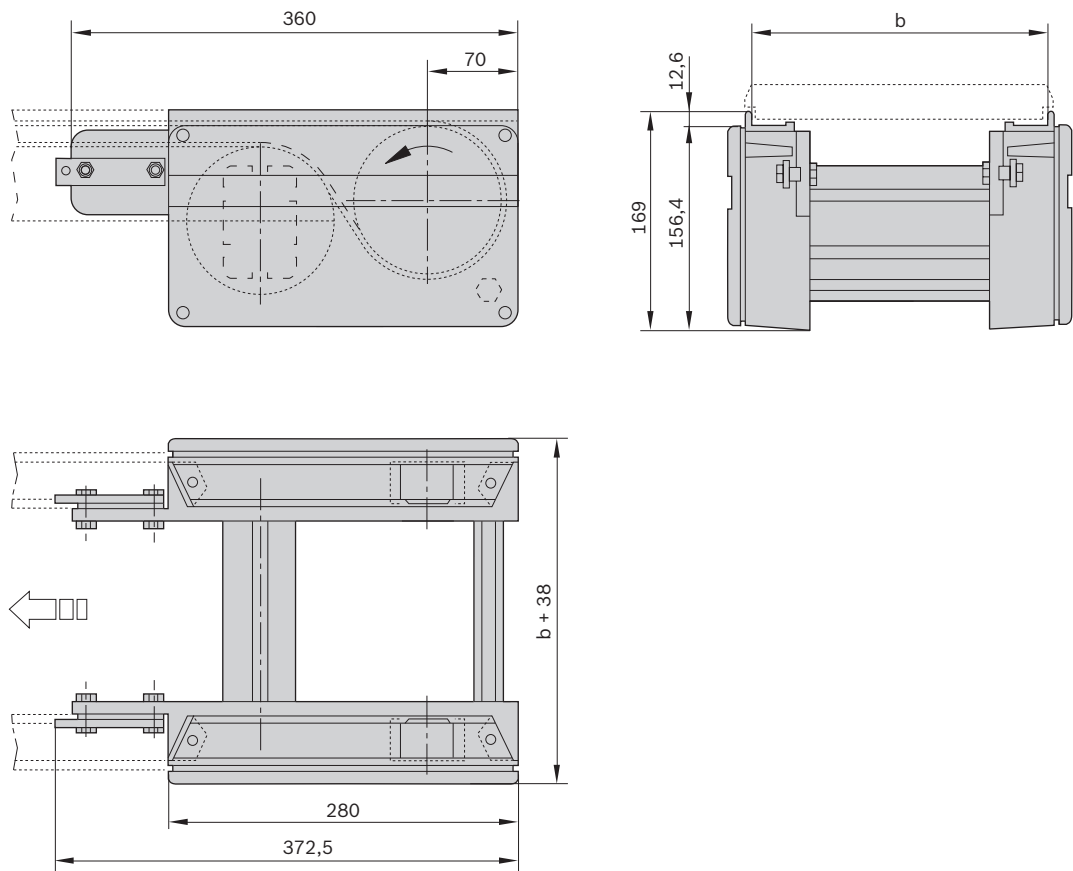
3

Technical data

Material number		3842999090
Features		
ESD		Yes
Additional information		
Required conveyor medium length*	$l_{UM}$	mm660

\* Formula for calculating the conveyor medium, see p. 3-46

Dimensions

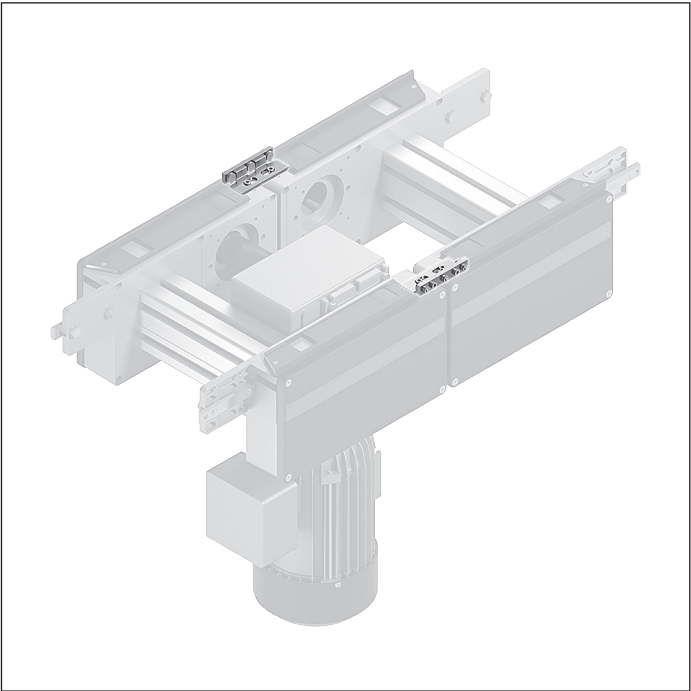


00013253

# RB 2 roller track



3



- It is used to support the workpiece pallets at the transition point between a conveyor unit and another adjacent conveyor unit. Necessary for workpiece pallets with  $l_{WT} < 320$  mm.
- Universal design

**Delivery notes**

**Scope of delivery**

- Incl. fastening material

**Condition on delivery**

- Fully assembled

**Ordering information**

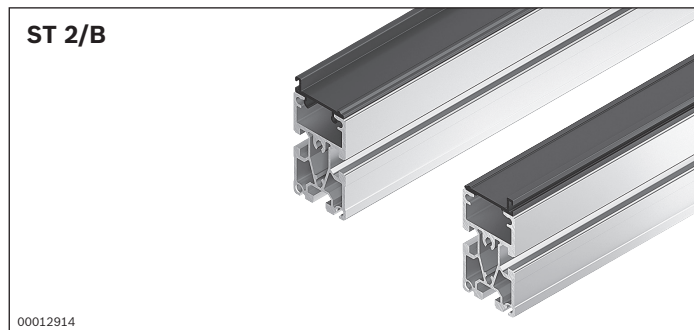
Product designation	Packaging unit	Material number
RB 2 roller track	2	3842532822

**Technical data**

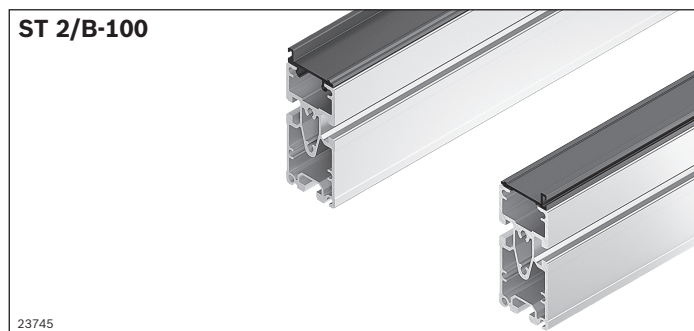
Material number	3842532822
Features	
ESD	Yes
Material specification	Roller carrier: Aluminum Rollers: Steel; hardened



## ST 2/B section, ST 2/B-100 section



- ▶ For conveyor unit self-assembly
- ▶ Easy insertion of the guide profile into the section profile
- ▶ Easily replaceable when worn out
- ▶ Conveyor medium: Belt (suitable for use in an EPA)



The section is used for self-construction of conveyor units in conjunction with the AS 2/B drive module and the UM 2/B return unit.

### Accessories

#### Recommended accessories

- ▶ SZ 2 leg sets, see page 6-2
- ▶ Profile connector, see p. 3-40
- ▶ Cross connector, see p. 3-41

### Delivery notes

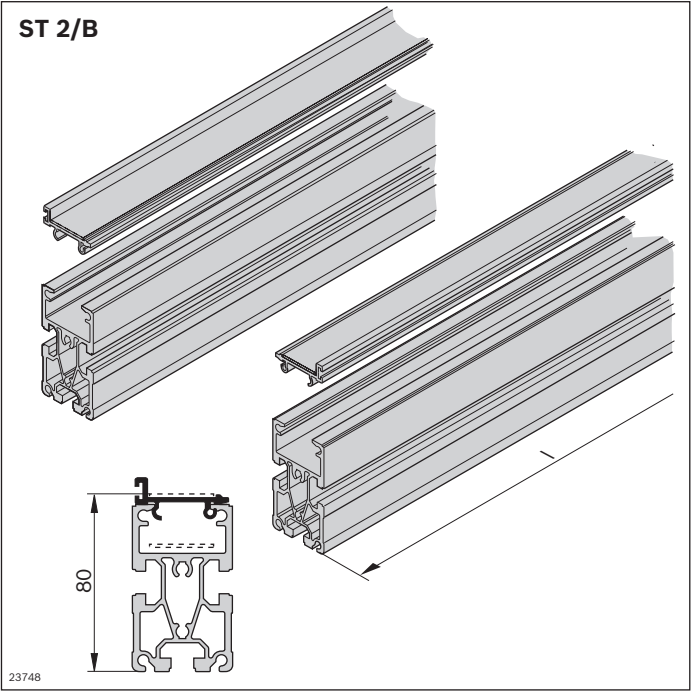
#### Scope of delivery

- ▶ ST 2/B: 2x SP 2/B section profile, 2x FP 2/B guide profile
- ▶ ST 2/B-100: 2x SP 2/B-100 section profile, 2x FP 2/B guide profile

#### Condition on delivery

- ▶ Not assembled

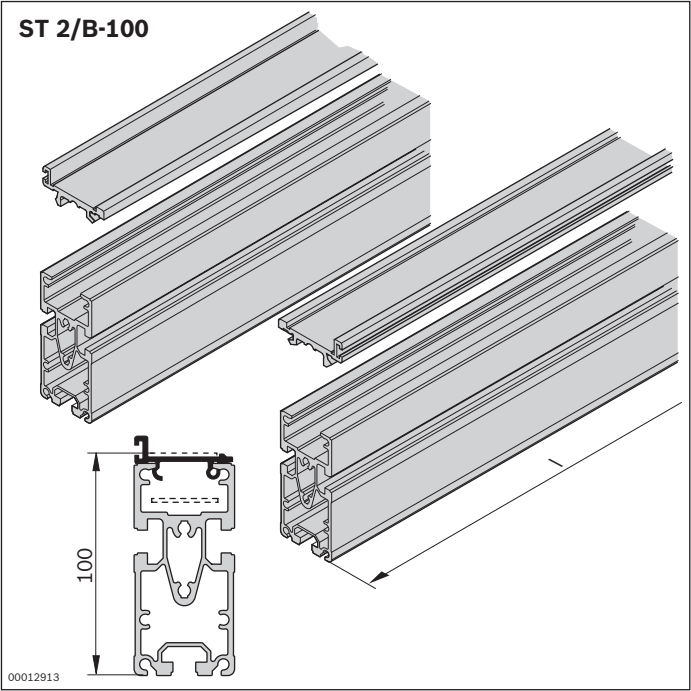
Ordering information



ST 2/B section

Material number		3842992650
l (mm)	Length	60 ... 6000
h (mm)	Height to conveying level	80

3



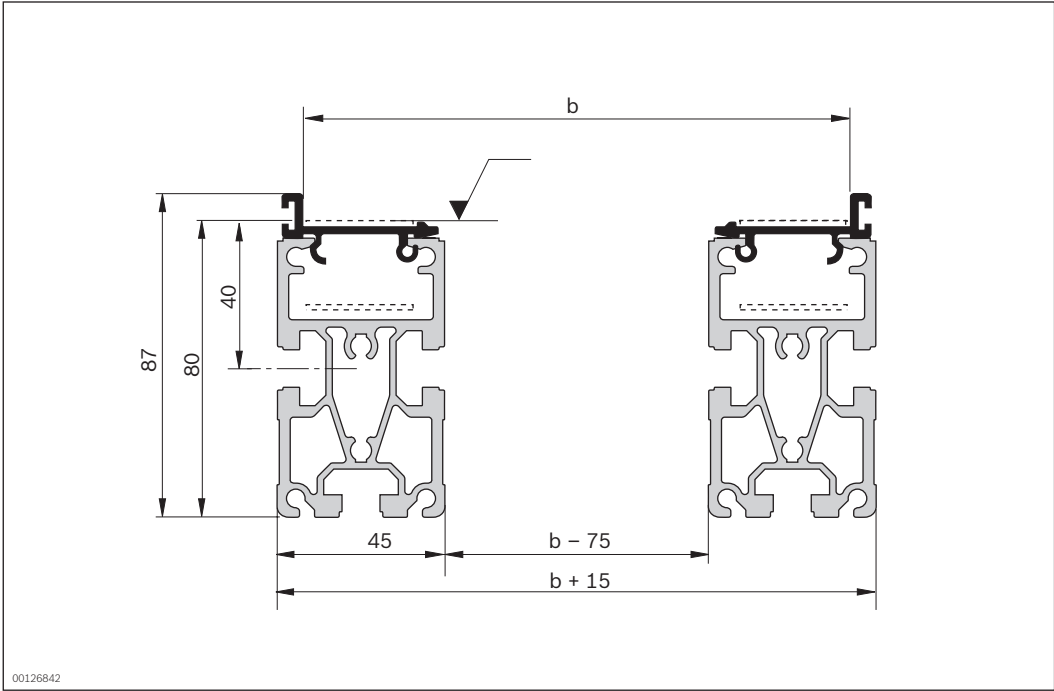
ST 2/B-100 section

Material number		3842994927
l (mm)	Length	60 ... 6000
h (mm)	Height to conveying level	100

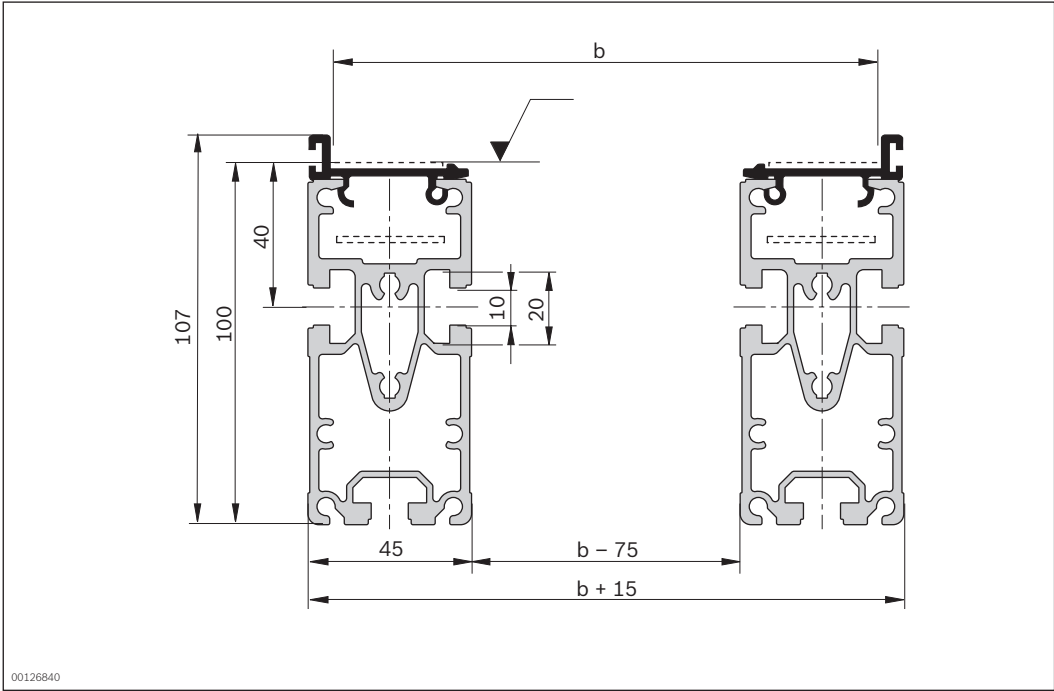
Technical data

Material number			3842992650	3842994927
Product designation			ST 2/B section	ST 2/B-100 section
Features				
ESD			Yes	Yes
Material specification			Section profile: Aluminum; anodized Guide profile: polyamide	Section profile: Aluminum; anodized Guide profile: polyamide
Dimensions				
Length	l	mm	60 ... 6000	60 ... 6000
Height to conveying level	h	mm	80	100

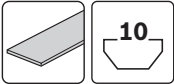
Dimensions  
ST 2/B



ST 2/B-100



# SP 2/B section profile



- ▶ Used for self-construction of low-profile conveyor units and the conveyor media belt
- ▶ For use in conjunction with all AS 2/B drive modules, UM 2/B return units and FP 2/B guide profiles
- ▶ Longitudinal grooves for easy mounting
- ▶ ST 2/B to be used in sections

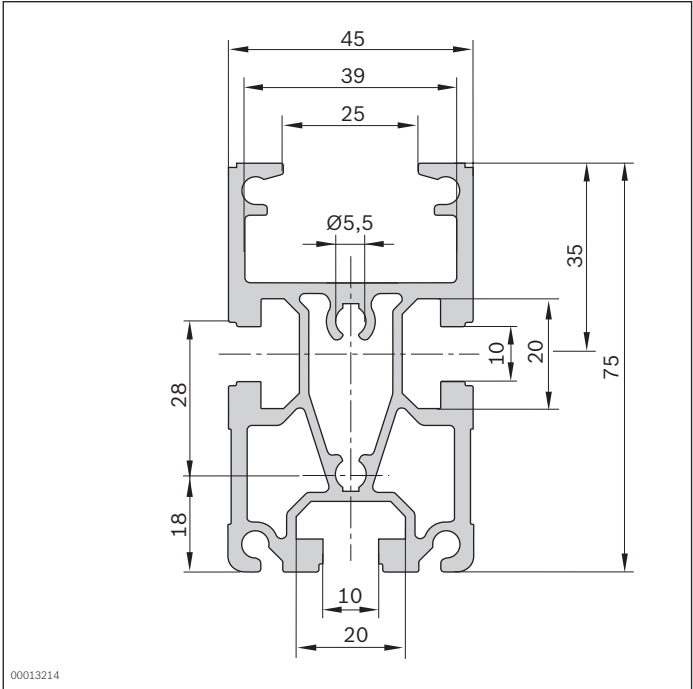
## Ordering information

Product designation	l (mm)	Delivery unit	Material number
SP 2/B 16 x 6070 mm section profile	6070	16	3842532695
SP 2/B section profile	60 ... 6000		3842992884

## Technical data

Material number			3842532695	3842992884
Load				
Moment of inertia	$I_x$	cm <sup>4</sup>	49.6	49.6
	$I_y$	cm <sup>4</sup>	25.8	25.8
Moment of resistance	$W_x$	cm <sup>3</sup>	12.1	12.1
	$W_y$	cm <sup>3</sup>	11.5	11.5
Features				
Material specification			Aluminum, natural; anodized	Aluminum, natural; anodized
Mass	m	kg/m	2.8	2.8
Dimensions				
Length	l	mm	6070	
Length	l	mm		60 ... 6000
Profile surface	A	cm <sup>2</sup>	10.4	10.4

Dimensions



# SP 2/B-50 section profile



- ▶ Used for self-construction of low-profile conveyor units and the conveyor media belt
- ▶ For use in conjunction with all AS 2/B drive modules, UM 2/B return units and FP 2/B guide profiles
- ▶ Longitudinal grooves for easy mounting
- ▶ Suitable for installation at manual workplaces

3

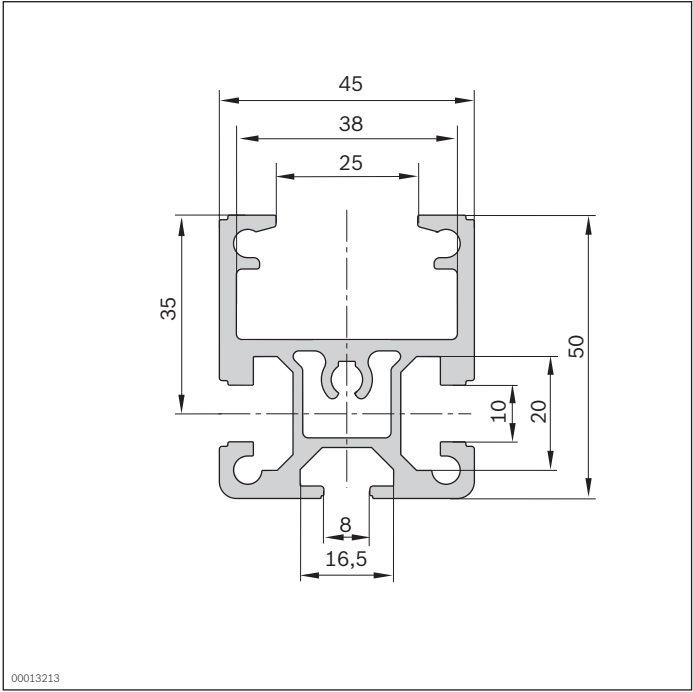
## Ordering information

Product designation	l (mm)	l (mm)	Delivery unit	Material number
SP 2/B-50 20 x 6070 mm section profile	6070		20	3842532697
SP 2/B-50 section profile		60 ... 6000		3842992903

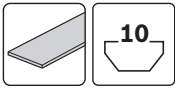
## Technical data

Material number			3842532697	3842992903
Load				
Moment of inertia	I <sub>x</sub>	cm <sup>4</sup>	46.2	46.2
	I <sub>y</sub>	cm <sup>4</sup>	16.9	16.9
Moment of resistance	W <sub>x</sub>	cm <sup>3</sup>	5.3	5.3
	W <sub>y</sub>	cm <sup>3</sup>	7.5	7.5
Features				
Material specification			Aluminum, natural; anodized	Aluminum, natural; anodized
Mass	m	kg/m	1.9	1.9
Dimensions				
Length	l	mm	6070	
Length	l	mm		60 ... 6000
Profile surface	A	cm <sup>2</sup>	6.9	6.9

**Dimensions**



# SP 2/BH section profile



- ▶ Used for self-construction of low-profile conveyor units and the conveyor media belt
- ▶ For use in conjunction with all AS 2/B drive modules, UM 2/B return units and FP 2/B guide profiles
- ▶ Longitudinal grooves for easy mounting
- ▶ In tough design

## Ordering information

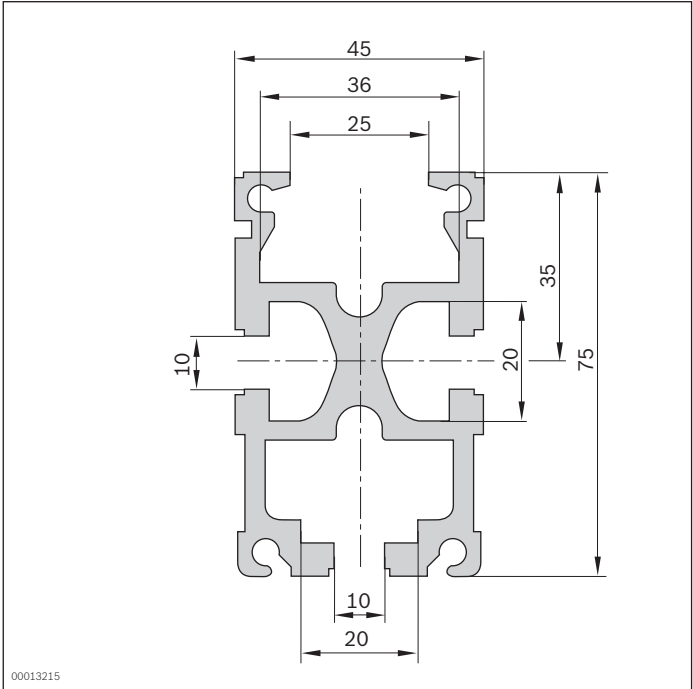
Product designation	l (mm)	l (mm)	Delivery unit	Material number
SP 2/BH 16 x 6070 mm section profile	6070		16	3842532696
SP 2/BH section profile		60 ... 6000		3842990409

## Technical data

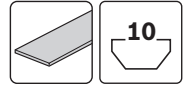
Material number			3842532696	3842990409
Load				
Moment of inertia	I <sub>x</sub>	cm <sup>4</sup>	53.7	53.7
	I <sub>y</sub>	cm <sup>4</sup>	28.6	28.6
Moment of resistance	W <sub>x</sub>	cm <sup>3</sup>	14.0	14.0
	W <sub>y</sub>	cm <sup>3</sup>	13.8	13.8
Features				
Material specification			Aluminum, natural; anodized	Aluminum, natural; anodized
Mass	m	kg/m	3.3	3.3
Dimensions				
Length	l	mm	6070	
Length	l	mm		60 ... 6000
Profile surface	A	cm <sup>2</sup>	12.4	12.4



Dimensions



## SP 2/B-100 section profile



- Used for self-construction of conveyor units with a height of 100 mm and the conveyor medium belt
- For use in conjunction with all AS 2/B drive modules, UM 2/B return units and FP 2/B guide profiles
- Longitudinal grooves for easy mounting
- For use in assembly systems with mixed conveyor media, e.g., belt and flat top chain

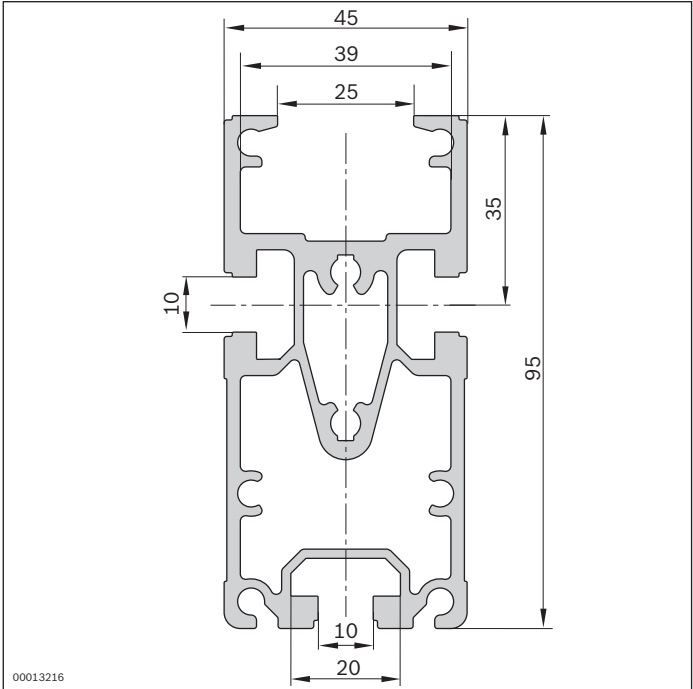
### Ordering information

Product designation	l (mm)	l (mm)	Delivery unit	Material number
SP 2/B-100 16 x 6070 mm section profile	6070		16	3842532608
SP 2/B-100 section profile		60 ... 6000		3842993259

### Technical data

Material number			3842532608	3842993259
Load				
Moment of inertia	I <sub>x</sub>	cm <sup>4</sup>	95.1	95.1
	I <sub>y</sub>	cm <sup>4</sup>	30.4	30.4
Moment of resistance	W <sub>x</sub>	cm <sup>3</sup>	20.0	20.0
	W <sub>y</sub>	cm <sup>3</sup>	13.5	13.5
Features				
Material specification			Aluminum, natural; anodized	Aluminum, natural; anodized
Mass	m	kg/m	3.2	3.2
Dimensions				
Length	l	mm	6070	
Length	l	mm		60 ... 6000
Profile surface	A	cm <sup>2</sup>	11.9	11.9

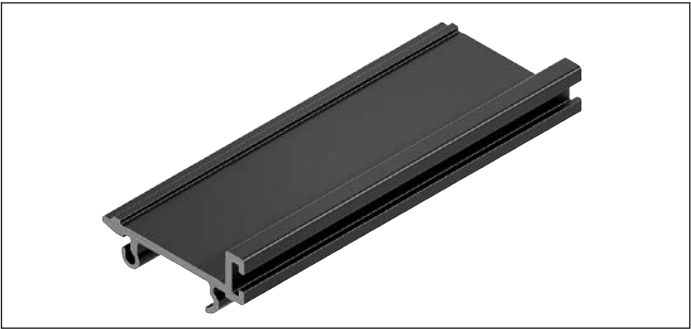
**Dimensions**



# FP 2/B guide profile



3



- For belt guide
- For clipping onto the SP 2/B section profiles

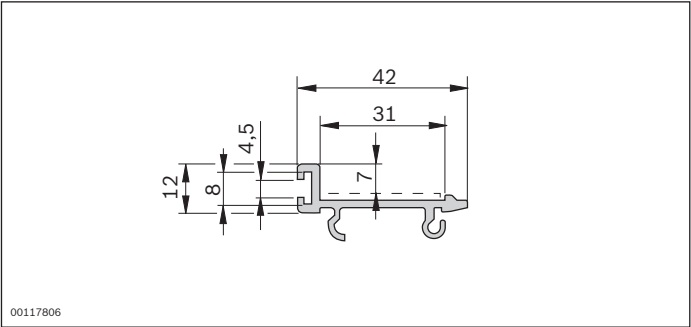
## Ordering information

Product designation	l (mm)	Delivery unit	Material number
FP 2/B guide profile	6000	16	3842532675

## Technical data

Material number			3842532675
Features			
ESD			Yes
Material specification			Plastic, PA (suitable for use in an EPA)
Dimensions			
Length	l	mm	6000

## Dimensions



# Profile connector



- ▶ For the end-to-end connecting of two profiles SP 2/...
- Two profile connectors are required for each profile joint
- ▶ For conveyor unit self-assembly
- ▶ For use in conjunction with all AS 2/B drive modules, UM 2/B return units and SP 2/B section profiles

## Delivery notes

### Scope of delivery

- ▶ Profile connector, screws

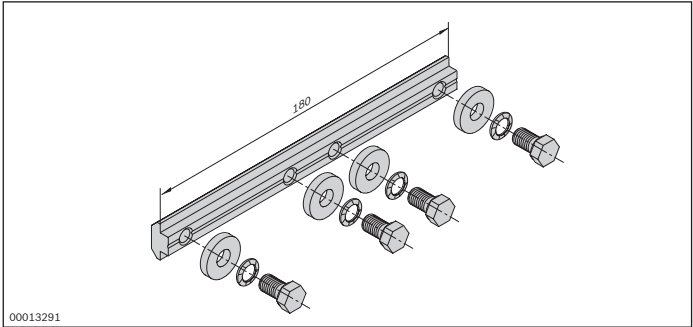
## Ordering information

Product designation	Material number
Profile connector	3842528746

## Technical data

Material number	3842528746
Features	
Material specification	Steel; galvanized

## Dimensions



## QV 2 cross connector



- ▶ For conveyor unit self-assembly
- ▶ For connecting section profiles and defining the track width
- ▶ Can be combined with all SP 2 section profiles

3

Formula for calculating the number of cross connectors needed

$$A_{QV} = (l/2000 \text{ mm}) + 1$$

$A_{QV}$  = Number of cross connectors

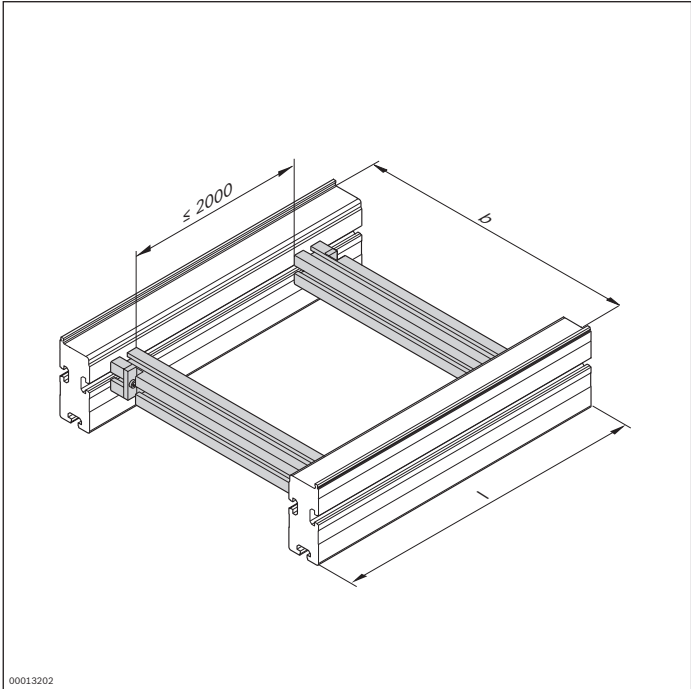
$l$  = section length

### Delivery notes

#### Scope of delivery

- ▶ 45x60 strut profile, finished
- ▶ 2x fastening material to mount on an ST 2 section

Ordering information



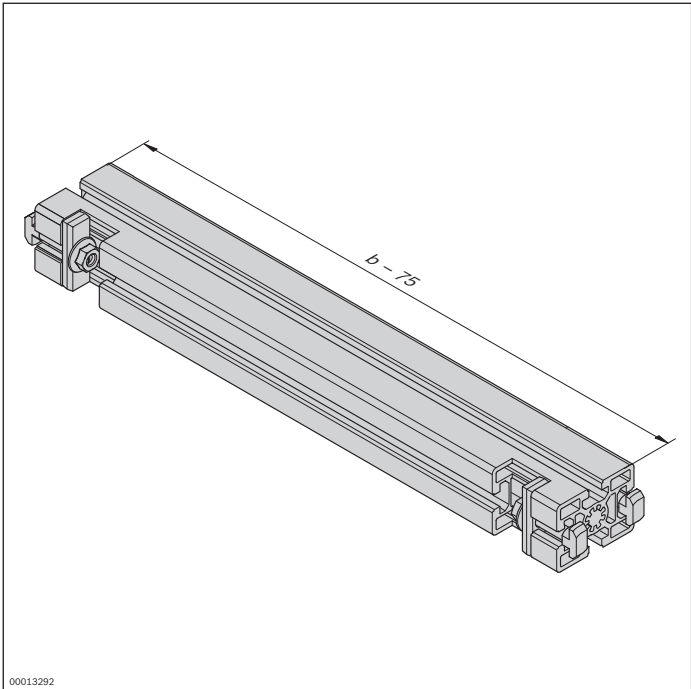
Material number		3842994635
b (mm)	Track width in direction of transport	160; 240; 320; 400; 480; 640; 800; 1040; 1200
		160 ... 1200 <sup>1</sup>

<sup>1</sup> Individual width variants available

Technical data

Material number	3842994635
Features	
Material specification	Aluminum, natural; anodized

Dimensions



# Scraper



3



- ▶ To scrape small parts from the conveyor medium
- ▶ For use with workpiece pallets with a minimum weight of 3 kg
- ▶ Conveyor media: Belt, toothed belt and flat top chain
- ▶ May be mounted on the right side (R) or left side (L)
- ▶ Reversible operation is not possible on sections with scrapers

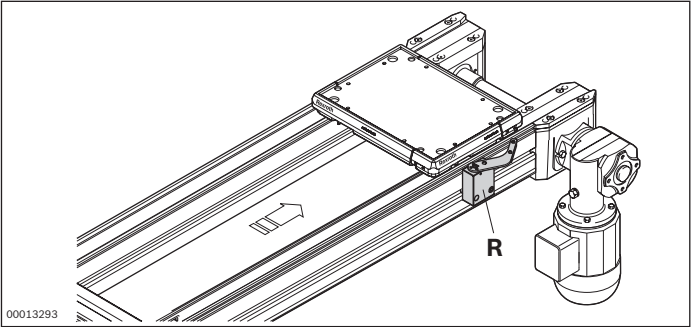
## Delivery notes

### Scope of delivery

- ▶ 1x scraper, right or left, including fastening material

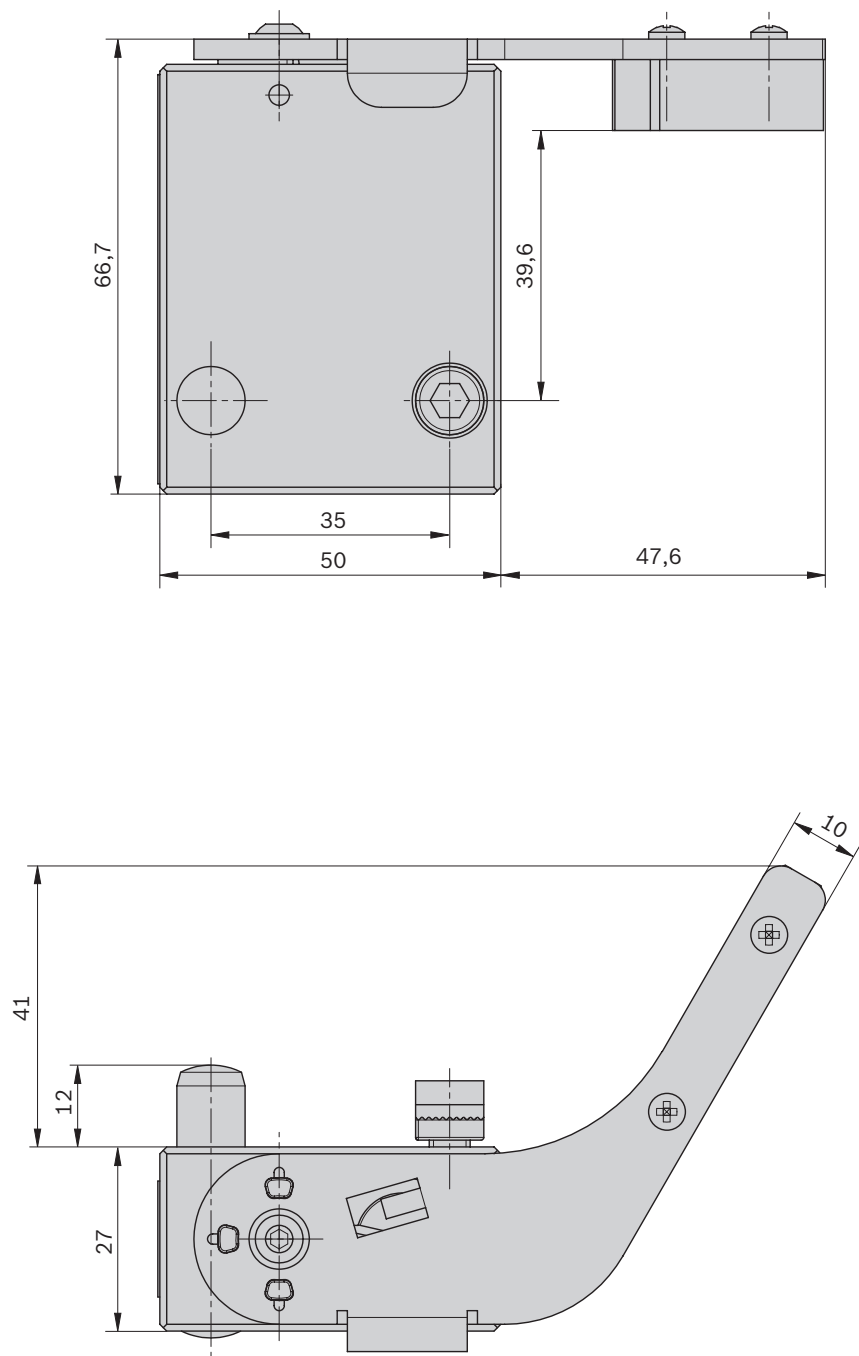
## Ordering information

Product designation	Material number
Scraper, right	3842532679
Scraper, left	3842532680





Dimensions



27630

# GT 2 belt



3



The belt used as a conveyor medium transports the workpiece pallets into the transfer system. The belts are pretensioned during installation and bonded to form a

continuous belt. A belt assembly tool kit is used for jointing, tensioning and bonding.

### Accessories

#### Required accessories

- ▶ Belt mounting tool kit, see p. 3-48
- ▶ Glue, see p. 3-47

### Ordering information

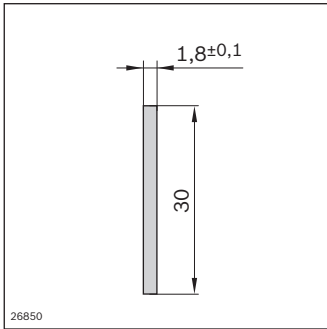
Product designation	l (m)	l (m)	Material number
GT 2 belt	250		3842539479
GT 2 belt		1 ... 250 <sup>1</sup>	3842992811

<sup>1</sup> Order and delivery are only possible up to the next full meter

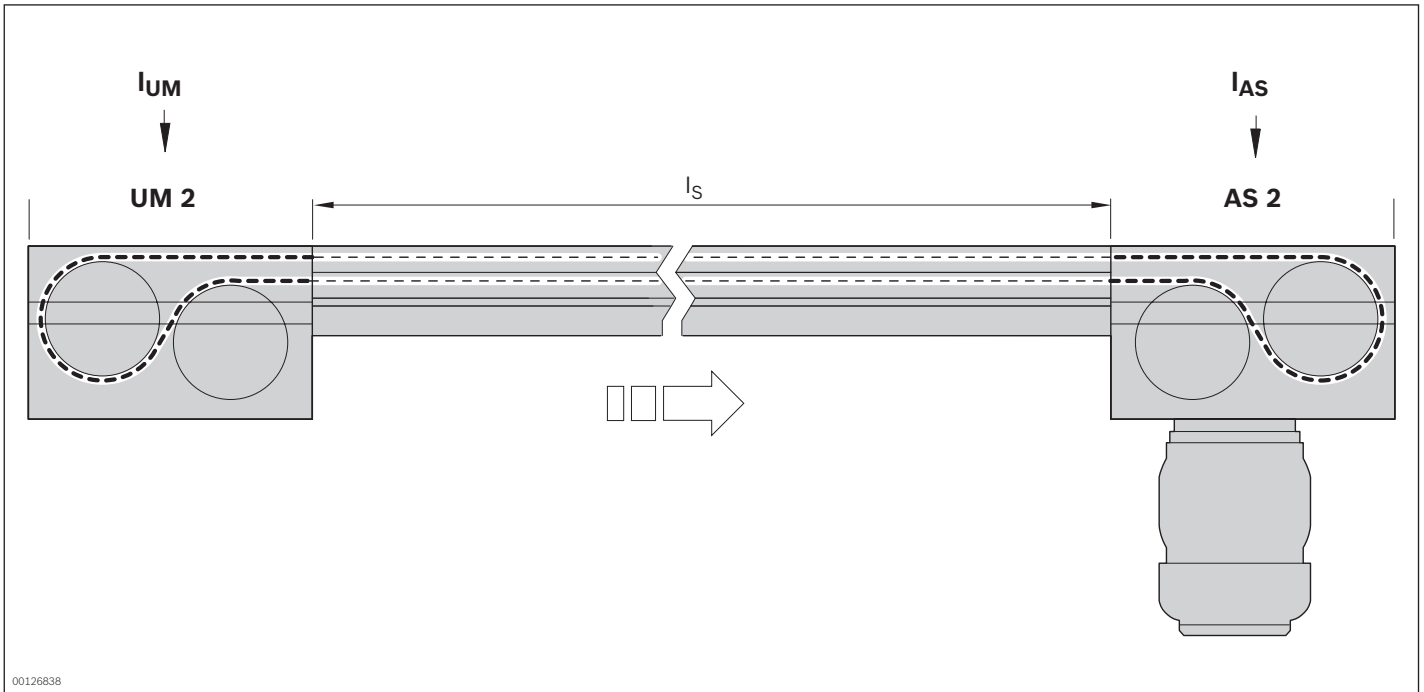
### Technical data

Material number		3842539479	3842992811
Features			
ESD		Yes	Yes
Material specification		Polyamide (PA)	Polyamide (PA)
Dimensions			
Length	l	m	250
Length	l	m	1 ... 250

## Dimensions



## Calculating the required length of the conveyor medium



The required belt length is determined using the following formula.

**Note:** A pretensioning factor  $F$  is required for the belt, see the "Pretensioning factor  $F$  for belts" overview.

$$l_B = ((2 \times l_s + l_{AS} + l_{UM}) \times F) + 60$$

$l_B$  = Length of belt

$l_s$  = Length of section

$l_{AS}$  = Length of the conveyor medium at the drive module

$l_{UM}$  = Length of the conveyor medium at the return unit

$F$  = pretensioning factor

### Pretensioning factor $F$ for belt

With BS 2, when  $l_s \leq 4000$  mm,  $F = 0.98$

With BS 2, when  $l_s > 4000$  mm,  $F = 0.975$

With AS 2/B-250,  $F = 0.965$

### Length of the conveyor medium for belt

$l_{UM} = 660$  mm

$l_{AS} = 660$  mm

### Belt expansion

at  $l_s \leq 4000$  mm, = 2%

at  $l_s > 4000$  mm = 2.5%

at AS 2/B-250, = 3,5%

# Glue



3

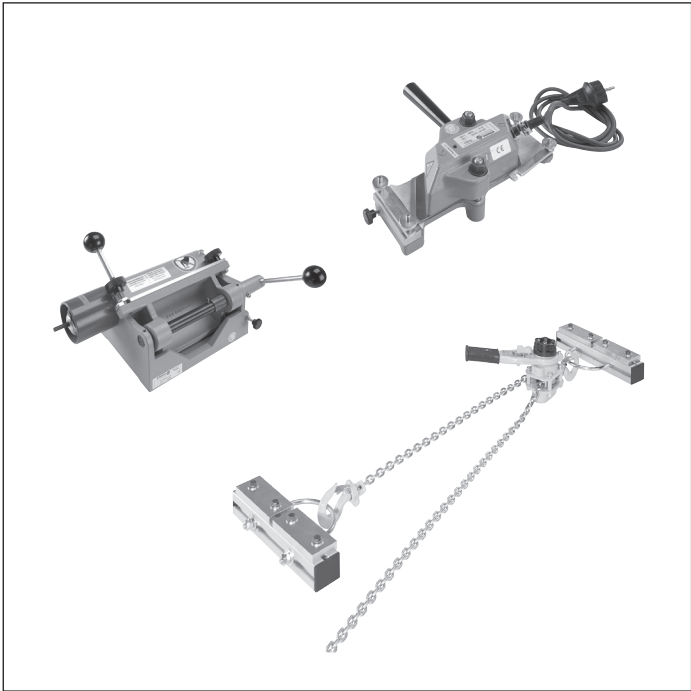


- ▶ Used for bonding belts
- ▶ For use in connection with the belt assembly tool kit
- ▶ For industrial use only
- ▶ Follow the safety instructions

## Ordering information

Product designation	Material number
Glue, 50 ml	3842315106

# Belt assembly tool



- ▶ Skiving device for reducing belts at connection points
- ▶ Heat press to glue the belt ends thermally
- ▶ Belt pretensioning device

The belt assembly tool is used to join the ends of belts for section lengths  $l > 2000$  mm.

## Accessories

### Required accessories

- ▶ Glue, see p. 3-47

### Delivery notes

#### Scope of delivery

- ▶ Skiving device
- ▶ Heating press
- ▶ Pretensioning device
- ▶ Abrasive belt
- ▶ Brush

### Recommended accessories

- ▶ Second heating press for the simultaneous bonding of adjacent belts

## Ordering information

Product designation	Material number
Heating press, single	3842315101
Belt mounting tool kit	3842532810