

Tolerances on cut belts 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 AB 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.

International standard

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

Width in mm		For belts containing materials with low moisture absorption (e.g. polyester)	For belts with higher moisture absorption (e.g. cotton or polyamide)
Over	Up to and including		
-	200	+/- 1 mm	+/- 2 mm
200	600	+/- 2 mm	+/- 3 mm
600	1000	+/- 4 mm	+/- 5 mm
1000	2000	+/- 6 mm	+/- 6 mm
2000	4000	+/- 7 mm	+/- 0.3% of width
4000	-	+/- 8 mm	+/- 0.3% of width

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

Length in m		Tolerance
Over	Up to and including	
-	2	+/- 10 mm
2	7	+/- 20 mm
7	-	+/- 0.3%

Note: It is recommended that actual cut widths of belt should be specified in incremental steps of 50 mm for cut widths up to 1 m, and incremental steps of 100 mm for cut widths over 1 m.

Internal standard AB

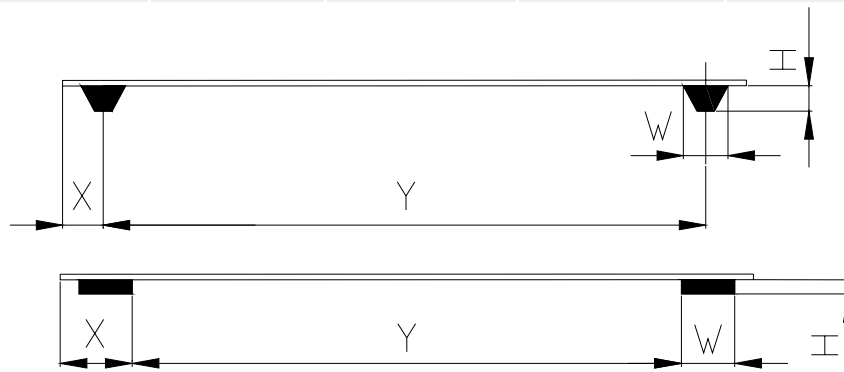
Dimensions are in mm and have to be measured with a calibrated tape ruler. The tolerances are defined by a material temperature of 20°C and a belt tension of 0 N/mm. Tolerances of accessories are for fitted accessories on conveyor belts.

Width in mm		For open or endless length belts containing materials with low moisture absorption	For endless length belts with Amseal containing materials with low moisture absorption
Over	Up to and including		
-	500	+/- 1 mm	+/- 2 mm
500	2000	+/- 2 mm	+/- 2 mm
2000	-	+/- 3 mm	+/- 3 mm

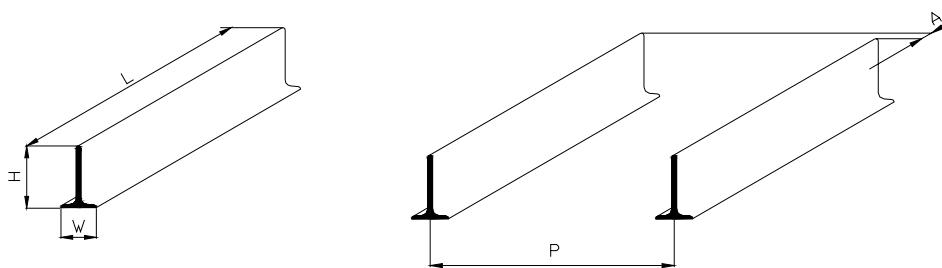
Tolerances on fabricated synthetic belts



Longitudinal profiles	Dimensions				
	W	H	X	Y	Straightness
V-guides / ropes	+/- 1 mm	+/- 1 mm	+/- 2 mm	+/- 2 mm	+/- 1 mm
Guide strips	+/- 1 mm	+/- 0.5 mm	+/- 2 mm	+/- 4 mm	+/- 1 mm



Carriers	Dimensions				
	L	H	W	P	A
Solid material	+/- 2 mm	+/- 1 mm	+/- 0.5 mm	+/- 5 mm	+/- 2 mm
Fabric reinforced carriers	+/- 2 mm	+/- 3 mm	+/- 5 mm	+/- 5 mm	+/- 2 mm
Ropes used as carriers	+/- 2 mm	+/- 1 mm	+/- 0.5 mm	+/- 5 mm	+/- 2 mm



Bordoflex	Dimensions			
	W	H	P	X
Solid and fabric reinforced	+/- 1.5 mm	+/- 2 mm	+/- 2 mm	+/- 5 mm

