

**FMB-3 DD LT - PULLEY GUIDELINES & FABRICATION OPTIONS**

Belt Type	FMB-3 DD LT			
MPD. Base Belt	80mm		3.15"	
Electrode : EVMB-LT	120mm		4.72"	
VLB-LT/VLC/VLB 10	130mm		5.12"	
VLB-LT/VLC/VLB 13	140mm		5.51"	
VLB-LT/VLC/VLB 17	155mm		6.10"	
<b>Minimum Pulley diameter for High frequency welded Flights</b>				
App. Temperature	Temp ≥ 0° C / 32° F		Temp < 0° C / 32° F	
Flight 3 – 5 mm	101mm	3.97"	151mm	5.94"
Flight 6 – 8 mm	128mm	5.04"	180mm	7.09"
<b>Minimum Pulley Diameter for Baseless Sidewalls – 2mm Thick</b>				
	Normal Flex		Back Flex	
B-SW 30	80mm	3.15"	110mm	4.33"
B-SW 40	90mm	3.54"	120mm	4.72"
B-SW 50	100mm	3.94"	150mm	5.90"
B-SW 60	110mm	4.33"	180mm	7.10"
B-SW 80	130mm	5.12"	230mm	9.05"
B-SW 100	160mm	6.30"	300mm	11.81"
B-SW 130	210mm	8.27"	400mm	15.75"
B-SW 150	250mm	9.84"	450mm	17.72"
<b>Minimum Pulley Diameter for Two Top Guides</b>				
Guide Type	Normal Flex		Back Flex	
VLB-LT/VLB/VLC 13	152mm	5.89"	157mm	6.18"
VLB-LT/VLB/VLC 17	178mm	7"	175mm	6.89"
CLB/CLC 13	130mm	5.11"	147mm	5.79"
CLB/CLC 17	146mm	5.74"	160mm	6.30"
VSB/VSC 13	132mm	5.19"	141mm	5.55"
VSB/VSC 17	145mm	5.70"	150mm	5.90"
CSB/CSC 13	116mm	4.57"	134mm	5.27"
CSB/CSC 17	124mm	4.88"	140mm	5.51"

All inch sizes have been converted from metric sizes.

**Guidelines and Suggested Materials for the Fabrication of DD LT belt**

**Sidewalls & Guides:** It is possible to weld Sidewalls from L material to the LT belts.

**Flights:** We recommend using LT material as preferred Flights material.

MB material is also acceptable but in this case, you should make sure that the temperature of your application does not exceed the regular MB LT materials limit. The flights should be welded with HF between the teeth as indicated in the DualDrive™ and Mini DualDrive™ Technical Manual.

**Electrodes:** We do not recommend using electrodes for welding flights on these belts.

The entire belt area around the welded electrode becomes rigid and we lose the belt flexibility advantage which characterizes our regular flat belts.

**Endless Making:** We suggest joining these LT belts with a Butt weld using the FBW Tool.

**Pulleys:** When choosing the pulley size must be equal or larger than the minimum pulley required.

