

### FMB,FMW-SD/FEMB-SD-ITM2 - PULLEY GUIDELINES & FABRICATION OPTIONS

Belt Type	FMB-SD, FMW-SD, FMB-SD-ITE, FMB-SD-ITO50, FEMB-SD-ITM2		FMB-SD, FMW-SD, FEMB-SD-ITM2	
Belt Thickness	3mm		4mm	
MPD. Base Belt	80mm	3.15"	120mm	4.72"

**Minimum Pulley Diameter for V-Flights**

Electrode	120mm	4.72"	150mm	5.90"
VLC/VLB 10	130mm	5.12"	170mm	6.70"
VLC/VLB 13	140mm	5.51"	180mm	7.08"
VLC/VLB 17	155mm	6.10"	195mm	7.68"

**Minimum Pulley Diameter for Electrode Welded Flights**

Single Electrode 7	125mm	4.92"	150mm	5.90"
Single Electrode 9	140mm	5.51"	165mm	6.50"
Double Electrode 7	165mm	6.50"	190mm	7.48"
Double Electrode 9	NR		NR	

**Minimum Pulley Diameter for High Frequency Welded Flights**

App. Temperature	Temp ≥ 0° C / 32° F		Temp < 0° C / 32° F		Temp ≥ 0° C / 32° F		Temp < 0° C / 32° F	
Flight 3 – 5 mm	101mm	3.97"	151mm	5.94"	128mm	5.04"	180mm	7.09"
Flight 6 – 8 mm	128mm	5.04"	180mm	7.09"	143mm	5.63"	200mm	7.87"

**Minimum Pulley Diameter for Based Sidewalls – (working temp.range -20°C to 35°C / 4°F to 95°F)**

	Normal Flex		Back Flex		Normal Flex		Back Flex	
	Sww 20	105 mm	4.13"	110 mm	4.33"	120 mm	4.72"	120 mm
Sww 30	105 mm	4.13"	125 mm	4.92"	120 mm	4.72"	125 mm	4.92"
Sww 40	115 mm	4.53"	150 mm	5.90"	130 mm	5.12"	150 mm	5.90"
Sww 50	125 mm	4.92"	175 mm	6.89"	130 mm	5.12"	175 mm	6.89"
Sww 60	130 mm	5.12"	200 mm	7.87"	135 mm	5.31"	200 mm	7.87"
Sww 80	150 mm	5.90"	250 mm	9.84"	150 mm	5.90"	250 mm	9.84"
Sww 100	200 mm	7.87"	300 mm	11.81"	200 mm	7.87"	300 mm	11.81"

**Minimum Pulley Diameter for Baseless Sidewalls – 2mm Thick**

	Normal Flex		Back Flex		Normal Flex		Back Flex	
	B-SW 30	80mm	3.15"	110mm	4.33"	120mm	4.72"	150mm
B-SW 40	90mm	3.54"	120mm	4.72"	120mm	4.72"	150mm	5.90"
B-SW 50	100mm	3.94"	150mm	5.90"	120mm	4.72"	160mm	6.30"
B-SW 60	110mm	4.33"	180mm	7.10"	120mm	4.72"	190mm	7.48"
B-SW 80	130mm	5.12"	230mm	9.05"	130mm	5.12"	240mm	9.45"
B-SW 100	160mm	6.30"	300mm	11.81"	160mm	6.30"	310mm	12.20"
B-SW 130	210mm	8.27"	400mm	15.75"	210mm	8.27"	420mm	16.53"
B-SW 150	250mm	9.84"	450mm	17.72"	250mm	9.84"	470mm	18.50"

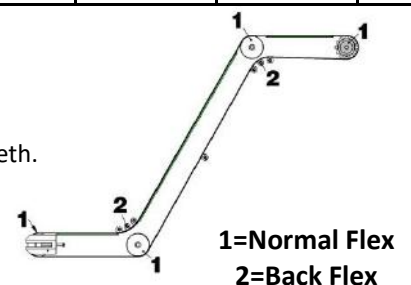
**Minimum Pulley Diameter for Two Top Guides**

Guide Type	Normal Flex		Back Flex		Normal Flex		Back Flex	
	VLB/VLC 13	145mm	5.70"	150mm	5.90"	185mm	7.28"	200mm
VLB/VLC 17	177.5mm	6.99"	175mm	6.89"	217.5mm	8.56"	225mm	8.85"
CLB/CLC 13	124mm	4.88"	140mm	5.51"	164mm	6.45"	190mm	7.48"
CLB/CLC 17	146mm	5.74"	160mm	6.30"	186mm	7.32"	210mm	8.26"
VSB/VSC 13	125.5mm	4.94"	135mm	5.31"	165.5mm	6.52"	185mm	7.28"
VSB/VSC 17	145mm	5.70"	150mm	5.90"	185mm	7.28"	200mm	7.87"
CSB/CSC 13	110.8mm	4.36"	128mm	5.04"	150.8mm	5.93"	178mm	7"
CSB/CSC 17	124mm	4.88"	140mm	5.51"	164mm	6.45"	190mm	7.48"

NR: Not Recommended.

All Inch sizes have been converted from Metric.

- For **Electrode Welded Flights** we recommend welding the Flights above the teeth location and not to exceed the tooth base width.
- Sidewalls & Guides** must be positioned at a minimum distance of 100mm from the belt teeth. **Flights** can be welded between the teeth as indicated in the SuperDrive™ and Mini SuperDrive™ Technical Manual



When choosing the pulley size, it must be equal or larger than the minimum pulley required.