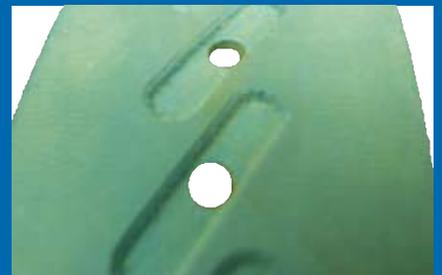


Special Fabrications



- » Cleats, guides and sidewalls
- » Amseal™ sealed belt edges
- » Special covers

General Information

Ammeraal Beltech has a variety of standard fabrications, cleats, guides, and specialty items available to meet your belt conveying needs. Please contact a factory representative to discuss these and any special application requirements that you have.

Footless cleats applied by the Hi-Frequency Welder offer the ultimate in flexibility and hygiene.



Hi-Frequency Welder

This advanced method of cleat and corrugated sidewall welding and specialty fabrication permits thermal welding of PVC and PU materials with excellent physical and cosmetic results. Cleats and sidewalls are thermally welded which makes a homogenous assembly free of unsightly burns or discoloration. Attachments essentially become an integral part of the belt material.

Corrugated cover profiles are also Hi-Frequency welded creating a corrugated cover or "loop" profile which is used in the poultry industry and other specialty applications. This eliminates the old-fashioned, traditional, stitched seams on these unique packaging belts.

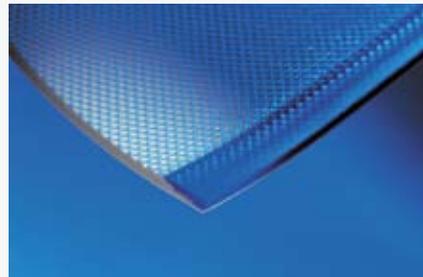
Mandrel-made belts



Corrugated sidewall machine

Corrugated Sidewall Machine

Assembly unit orients and assembles the corrugated sidewall to the base belting making the sidewall an extension of the belting cover. This provides for a containment wall with excellent flexibility having the same characteristics as the belting material.



Amseal™ type sealed edges provide superb durability while protecting edge hygiene and allowing totally encapsulated belt constructions.

Amseal™ Sealed Belt Edge

Belts can be edge sealed with a special Amseal™ machine. This unit provides a durable seal on the outer edges of the belt aiding in the prevention of bacteria buildup, edge fray, and other undesirable elements associated with open fabric edges.

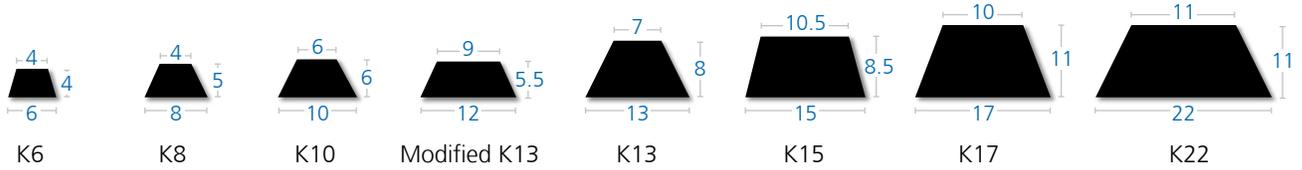
Other capabilities include:

- » Optical scanner belts with inlaid reference marks
- » Timing belts with various covers, attachments and perforations
- » Mandrel-made "seamless cover" feed belts

Cleats & V-Guides

PVC and PU - Profiles for Cleats or Guides

Dimensions are in millimeters unless otherwise indicated. Contact us for additional sizes and color availability.



Minimum Pulley Diameter (PVC/PU) When used as Cleats

1"/1.75"	2"/2.5"	2.5"/3.5"	3"/NA	3"/4.5"	3.5"/4.5"	4.5"/5.5"	6"/NA
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When used as **Guides (PVC/PU)** Note: For notched guides, reduce min. pulley diameter by 30%.

For guides subject to reverse bending, or mounted on the top surface of the belt, increase the min. pulley diameter by 45%.

1.5"/2.5"	2"/3.5"	2.75"/4"	3.5"/NA	3.5"/5.5"	4"/7"	5"/8"	6"/NA
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Standard PVC Color/Style Availability: B (black), G (dark green), W (white), N (notched style)

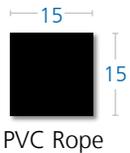
W	G·GN·W·WN	G·GN·W·WN	W·B	G·GN·W·WN	WN	G·W·WN	WN
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Standard PU Color/Style Availability: T (transparent), W (white), N (notched style), NA (not available)

W·WN	W	T·TN·W·WN	NA	T·TN·W·WN	W	TN·W	NA
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PVC - Specialty Profiles

Dimensions are in millimeters unless otherwise indicated.



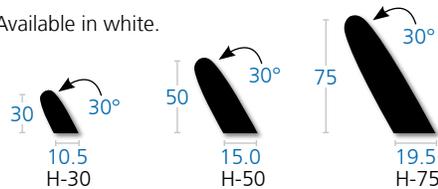
Available in white. (profile can be cut down to various dimensions)



Available in white.

PVC - Footless Cleats

Available in white.



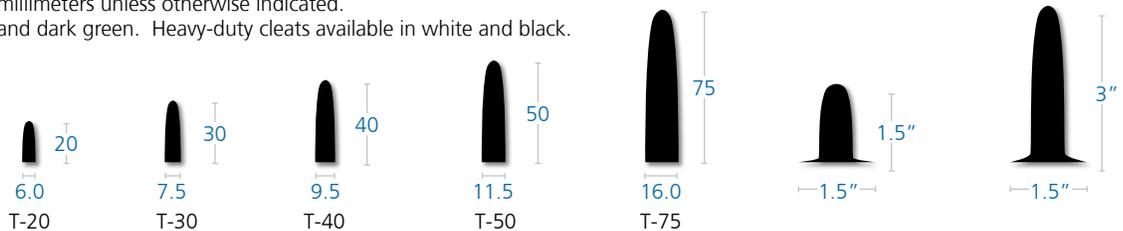
Minimum Pulley Diameter

7" (used as cleats)	3" (used as cleats/guides/edge flanges)	1.25"	2.0"	3"
12" (used as guides/edge flanges)				

PVC - Footless and Heavy-duty T-Cleats

Dimensions are in millimeters unless otherwise indicated.

Available in white and dark green. Heavy-duty cleats available in white and black.



Minimum Pulley Diameter

1"	1.25"	1.5"	2"	3"	6"	10"
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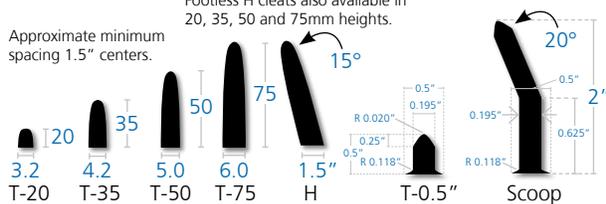
PU - Footless T and H, T and Scoop Cleats

Dimensions are in millimeters unless otherwise indicated.

Available in white.

Footless H cleats also available in 20, 35, 50 and 75mm heights.

Approximate minimum spacing 1.5" centers.



PU - Specialty Cleats

Available in natural.

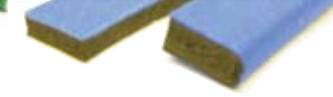
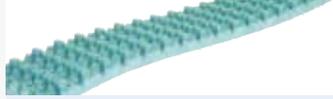


Minimum Pulley Diameter

T/H-20 (1")	T/H-35 (1.5")	T/H-50 (2")	T/H-75 (2.5")	1.313"	1.313"	1.313"	1.313"	1.75"	1.75"
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Note: Illustrations are not to scale.

Special Covers

PA 	FB/FB Folded 	NE Foam 	NI Foam 
<p>Low friction for accumulation or diverting.</p>	<p>For shock absorption, bottle orientation, packaging, labeling machines, etc...</p>	<p>General use for cushioning and compression. Without skin unless specified.</p>	<p>Fine cell, good elasticity, excellent compression recovery, cushioning for labeling, inspection, etc...</p>
NR Foam  <p>Fine Cell</p>	NR Foam + cover  <p>Fine Cell</p>	PU Foam 	CX P06 
<p>Highest possible compression recovery and abrasion resistance in a soft foam.</p>	<p>Combines the high compression of foam with the abrasion resistance of a solid cover. Provides best attributes of both materials.</p>	<p>Extreme abrasion and cut resistance for bottle labeling, feeding, etc...</p>	<p>Aggressive profile for surface bite with high wear resistance.</p>
PV P06 	PV P08 	PV P13 	PV P19 
<p>Soft compound with aggressive, high-grip profile.</p>	<p>High-grip rib structure for maximum contact with flat surfaces on inclines, etc...</p>	<p>Tooth profile for inclines and loose product transport. Reduces slip and rolling.</p>	<p>Raised stud profile for drying, drainage, feeding, inclines, etc...</p>
SR C37 	CL 	FE 	HY 
<p>High-grip, rough top profile. Good wearing for packaging lines, inclines, etc...</p>	<p>Oil and cut resistant surface for great wear. Good for non-marking parts transport.</p>	<p>Non-marking surface for soft handling and possible accumulation of delicate products.</p>	<p>Abrasion and wear resistant surface. Specify ground or smooth finish.</p>
NE Solid 	NP 	NR Solid 	NT 
<p>Oil and wear resistant, with medium to high grip, for cable pullers, extruders, capstans, etc...</p>	<p>Reinforced felt for impact and cut resistance.</p>	<p>Extreme abrasion resistance, high grip for feeders, indexers, inserters, etc...</p>	<p>Excellent oil and wear resistance for cable pullers, extruders, capstans, etc...</p>
PB 	PU 	PV 	
<p>Excellent oil and wear resistance with FDA qualities.</p>	<p>Excellent wear and cut resistance. Specify ground or smooth finish.</p>	<p>Excellent grip surface with cushioning effect. Specify ground or smooth finish.</p>	<p>Contact us for custom cover combinations and any of your other special cover fabrication needs.</p>

Special Covers

Type	Style	Description	Surface	Thickness Range [mm]	Standard Colors	Hardness Range	Degree of Friction	Abrasive Resistance
Fabric	PA	Polyamide Fabric	Fabric	1	Green	N/A	Low	Good
Foam	FB	Fabric Covered Neoprene Foam	Fabric	2-26	Blue	Medium	Low	Good
Foam	FB Folded	Fabric Covered Neoprene Foam (w/capped/folded edges)	Fabric Encapsulated	3-26	Blue	Medium	Low	Good
Foam	NE	Neoprene (Chloroprene)	Ground Medium Cell	2-26	Black	Medium	Medium	Fair
Foam	NI	Nitrile (Nitril-butadiene rubber)	Ground Fine Cell	2-26	Black	Medium	Medium	Fair
Foam	NR	Natural Rubber	Fine Cell	2-12	Red	Soft	Very High	Good
Layered	NR + Cover	Natural Rubber Fine Cell + Optional Cover Selection	Smooth or Ground	5-26	Red + Variable	Soft	Depends on cover choice	Depends on cover choice
Foam	PU	Polyurethane	Ground	2-6	Beige	40 Shore A	Good	Excellent
Profile	CX P06	Carboxylated Nitrile (Nitrile-butadiene rubber)	Rough Top	5	Blue, Orange	65 Shore A	Good	Excellent
Profile	PV P06	PVC (Polyvinylchloride)	Rough Top	5	Blue	30 Shore A	High	Good
Profile	PV P08	PVC (Polyvinylchloride)	Longitudinal Ribs	1	Blue, Black	25 Shore A	Very High	Good
Profile	PV P13	PVC (Polyvinylchloride)	Sawtooth	2	White, Green	55 Shore A	High	Good
Profile	PV P19	PVC (Polyvinylchloride)	Studs	1.5	White	65 Shore A	High	Good
Profile	SR C37	Synthetic Rubber (Butadiene/ styrene-butadiene rubber)	Rough Top	5	Tan	40 Shore A	High	Excellent
Solid	CL	Chrome Leather	Ground	1.5	Gray	85 Shore A	Medium	Excellent
Solid	FE	Felt	Soft Felt	1	Gray	65 Shore A	Medium	Good
Solid	HY	Hytrel (Polyester thermoplastic)	Ground, Smooth	2-5	Beige, Green, Blue	95 Shore A	Low	Excellent
Solid	HY	Hytrel (Polyester thermoplastic)	Ground, Smooth	2-4	Brown	80 Shore A	Low	Excellent
Solid	NE	Neoprene (Chloroprene)	Ground	2-26	Black	40-70 Shore A	High	Good - Excellent
Solid	NP	Polyester needle punched fabric	Fabric	2	Blue	65 Shore A	-	Excellent
Solid	NR	Natural Rubber	Ground	2-26	Red, Orange, Blue, Tan	37-60 Shore A	High	Good - Excellent
Solid	NR	Natural Rubber (FDA)	Ground	2-26	White	55 Shore A	High	Excellent
Solid	NT	Nitrile (Nitrile-butadiene rubber)	Ground	2-26	Green	70 Shore A	High	Good - Excellent
Solid	PB	Perbunan (FDA Nitrile-butadiene rubber)	Ground	2-8	White	55 Shore A	High	Excellent
Solid	PU	Polyurethane	Ground	2-6	White, Natural	85 Shore A	Medium	Excellent
Sprayed	PU	Ropan BS Polyurethane (Sprayed on coating)	Ground	2-26	Beige	70-90 Shore A	Medium	Excellent
Solid	PV	PVC (Polyvinylchloride)	Ground, Smooth	2-3	Blue	35 Shore A	Medium	Excellent
Solid	SI	Silicone	Ground	2-25	Blue, White	30, 50, 55 Shore A	Medium	Excellent

These are just some of our more common styles. Minimums may apply to certain items. Many special types are available to meet individual demands. Contact our Technical Department with your requirement for assistance in determining the correct selection for your needs.

Specialty Items

Amseal™ Sealed Edges

A wide range of standard belts can be fitted with Amseal™ edges and are available in FDA white or blue.

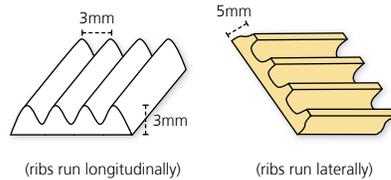


To produce Amseal™, we thermally fuse a homogeneous material to a specially prepared, stepped belt edge. This unique method leaves the entire belt cover intact and provides a robust edge much less susceptible to damage. This mechanical integrity is a main advantage over competitive products on the market.

Special Edge Guides

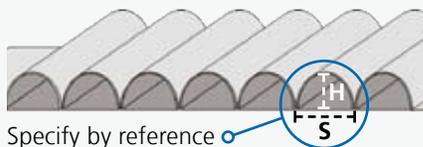
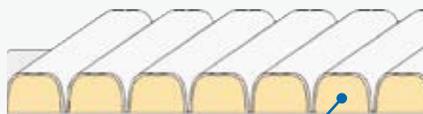
Special guides of various designs are available for difficult application demands.

Multi-Rib Edge Guide Amtel A11 Guide



- » White
- » up to 12 ribs
- » min. pulley: 0.5"
- » Beige
- » 30, 35 and 40mm wide
- » min. pulley: 2"

Corrugated Loop Profiles



Standard Corrugated Sidewalls



Corrugated sidewalls are designed allow small pulley diameters while maximizing product capacity.

PVC corrugated sidewalls can be applied to PVC styles with 0.5mm or greater cover thickness. Heights are 1" to 3" (25mm - 75mm). Minimum pulley diameter equals three times sidewall height. Available in white.

PU corrugated sidewalls can be applied to PU styles with 0.2mm or greater cover thickness. Heights are 25, 30, 35, 40, 45, 50 and 55mm. Minimum pulley diameter equals two times sidewall height. (Available in white or dark green) - Please check availability of other sizes.

Dimensions:

	Pitch	Width
PU	1.00"	0.87"
PVC	2.20"	1.89"

Mini Corrugated PU Sidewalls



When smaller minimum pulley diameters are required, mini-corrugated sidewalls are available up to 2 inches high.

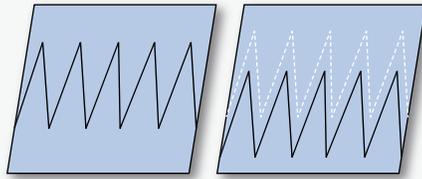
Minimum Pulley Diameters/Dimensions:

Wall Height	Minimum (std. flexing)	Minimum back-bend	Pitch	Width
1.00"	1.25"	10.00"	0.654"	1.00"
1.50"	1.25"	12.00"	0.654"	1.00"
2.00"	1.75"	14.00"	0.654"	1.00"

Note: These are minimum values. Greater diameters, where feasible, will increase the longevity of the belt in operation.

Standard Fabrications

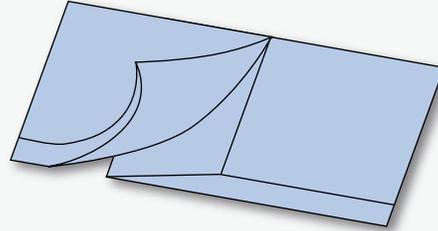
Finger Splicing



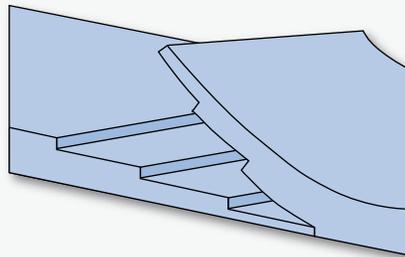
Standard

Double Finger

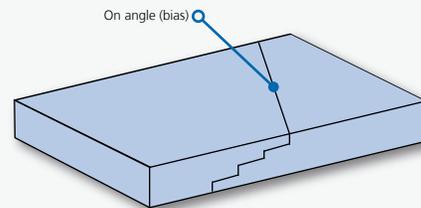
Skived Laps Prepared



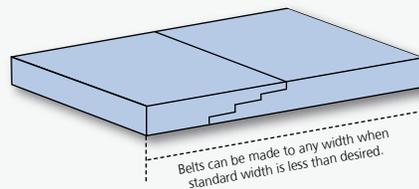
Step Laps Prepared



Endless Step Splice



Longitudinal Splicing



Belts can be made to any width when standard width is less than desired.

Lacing

Contact a factory representative for assistance in your selection.	Standard	Recessed
		Style #4
	Hidden	Hidden
	Style #0	Style #1
		Overflap
		Style #2 - Std. Flap
		Style #3 - Reinfcd. Flap

Spiral Plastic Lacing



Plastic Rivet Fasteners

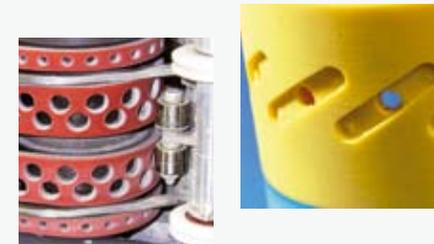


Grooving and Beveling



Grooves, slots and machined surfaces as found on cable pulling belts, packaging belts and other specialty applications.

Perforations



Virtually any perforation pattern, including slots, dual holes, staggered and straight patterns are available.

North American Service Network



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Fax 541 344 6837
Toll Free 866 778 9017

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6841 South 220th Street, Bldg. D
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Phone 253 872 7322
Fax 253 872 7410
Toll Free 866 778 9017

Ontario, Canada

290 Britannia Rd. E.
Mississauga, ON L4Z 1S6

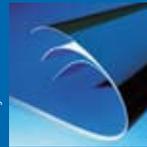
Phone 905 890 1311
Fax 905 890 3660
Toll Free 800 455 3337

Québec, Canada

4045 Rue Grand
Laval, QC H7L 5X5

Toll Free 800 455 3337

Conveyor belts



Timing belts



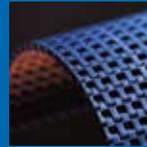
Seamless belts



Transmission belts



Modular belts



Fabrication & service

