

Production Tolerances

Plastic conveyor belts

Mentioned tolerances refer to manufacturing tolerances upon further processing by noltewerk. If semi-finished products are not further processed by noltewerk production, the manufacturing tolerances of semi-finished products may differ to noltewerk manufacturing tolerances.

In case of sub-measures (measuring chain) each individual tolerance is added to the overall measure (e.g. from ± 0.3 to ± 0.6 mm).

Limits for belt widths

Belt width [mm]	Tolerances [mm]
$\geq 220 - \leq 400$	$\pm 4,0$
$> 400 - \leq 800$	$\pm 5,0$
$> 800 - \leq 1.200$	$\pm 6,0$
$> 1.200 - \leq 1.600$	$\pm 7,0$
$> 1.600 - \leq 2.000$	$\pm 8,0$
$> 2.000 - \leq 4.000$	$\pm 10,0$

Limits for belt length (endless)**1

Centre length of belt [mm]	Tolerances [%]
$\geq 800 - \leq 1.500$	$\pm 1,15$
$> 1.500 - \leq 2.500$	$\pm 0,85$
$> 2.500 - \leq 5.000$	$\pm 0,75$
$> 5.000 - \leq 10.000$	$\pm 0,70$
> 10.000	$\pm 0,65$

Limits for belt length (open)**1

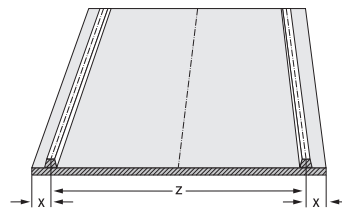
Tolerances [%]
$\pm 0,65$

¹ Lengths measured when slack. Limit applies to smooth belts; larger deviations may occur if the belts are sub-sequently mechanically or thermally treated, e.g. by applying cleats, V-ledges

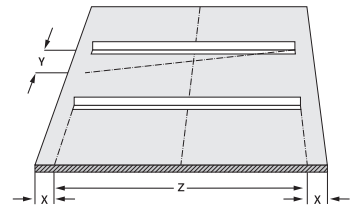
Limits for profile centre-to-centre distances

Belt width [mm]	Tolerances [mm]**2	
	x	z
≤ 500	$\pm 2,0$	$\pm 4,0$
$> 500 - \leq 1.500$	$\pm 3,0$	$\pm 6,0$
$> 1.500 - \leq 3.500$	$\pm 4,0$	$\pm 8,0$
$> 3.500 - \leq 4.000$	$\pm 5,0$	$\pm 10,0$
> 4.500	$\pm 6,0$	$\pm 12,0$

**2 Variations in tolerance possible on request



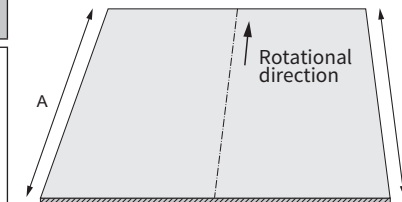
Belt width [mm]	Tolerance [mm]**2
	y
≤ 300	2
$> 300 - \leq 600$	3
$> 600 - \leq 1.000$	4
> 1.000	0,5 %



Limits of left and right edge of the belt**3

Centre length of belt [mm]	Tolerances [%]
Difference between left and right Edge of belt (both endless as well as open lengths)	max. $\pm 0,1$

**3 For lengths < 5 m = max. ± 5 mm



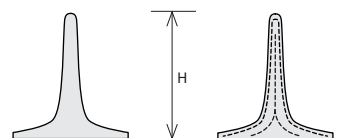
Lateral drift tracking **4 (following DIN EN ISO 14890)

Belt width [mm]	Belt width [mm]
≤ 800	± 40
> 800	$\pm 5\%$ (max. 75)

**4 Prerequisite is a correctly aligned system with centred load

Height tolerance cleats

Type	Tolerances [mm]
Solid material cleats	max. ± 2
Fabric-reinforced cleats	max. ± 5



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