HIC International Co Inc

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UNIVERSAL

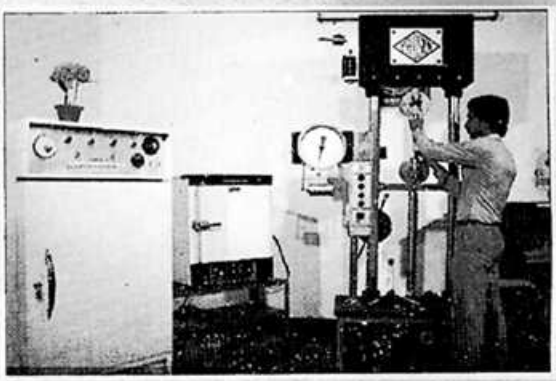
Looking toward tomorrow with fresh visions

Universal *HI-LIFE Polyester Cord V-Belts are the result of years of experience and practical exercise combining optimum strength and flexibility with marked resistance to wear.*

Right belts for the job are produced by studying the performance under actual operating conditions. **Universal** *H-LIFE has ben specially developed to cater to an ever increasing demand of quality conscious industries for higher and higher standards of working performance. Thus, this premium quality V-Belt that conforms to IS:2494 and International Specifications DIN 7753, has fostered many engineers and designers by providing answers to troublesome drive problems.*

Pulleys and couplings that are properly machined for easy installation.

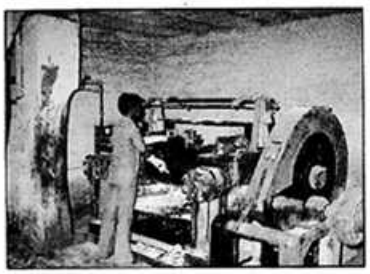
Anil Gupta
President



In-house evaluation of Finished Belt on Tensile Testing Machine in the Lab.

VEE - BELTS

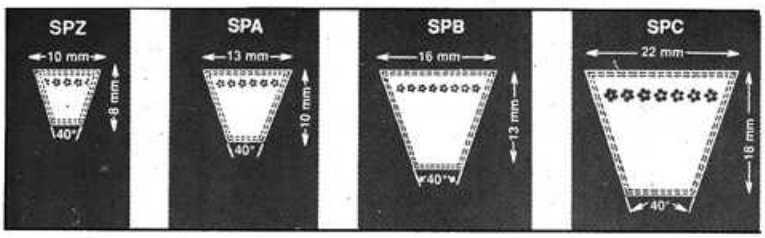
Vee Belts are used for motor to pulley power transmission in threshers, harvester combines, automobiles, rice mills, flour mills, textiles, sugar, fertilizer, cement, coal, thermal power plants, paper mills, ceramic industries, and other industrial applications and "Universal" offers polyester cord v-belts combining optimum strength and flexibility with marked resistance to wear.



Compound processing in mixing mill.

RANGE OF SECTION & SIZES (Conforming to IS : 2494, DIN 7753 and BS 3790)

SPACE SAVER WEDGE BELTS

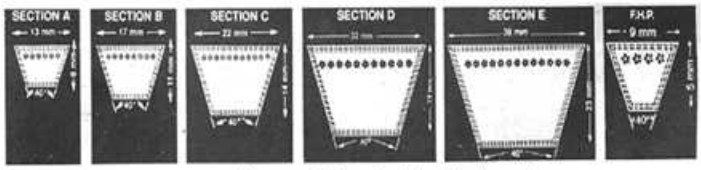


Range of Nominal Inside Length

mm	mm	mm	mm
630-3550	800-4500	1250-12000	2000-12000

Universal Wedge Belts are capable of transmitting more than twice as much power as traditional Vee belts, hence utilized in space-saving, narrower pulleys, reduced overhung and increased bearing life.

CLASSICAL



Range of Nominal Inside Length

Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm
16-180	406-4572	24-360	610-9144	36-600	916-15240	75-600	1905-15240	158-600	4013-15240		2170-2664

Section	Belt Pitch Length Exceeds Inside Length By (mm)	Pulley Outside Diameter Exceeds Pitch Diameter By (mm)
A	36	6.6
B	43	8.4
C	56	11.4
D	79	16.2
E	92	19.3
SPZ		4.0
SPA		6.0
SPB		7.0
SPC		9.6

Timing Belts are offered in various typez viz., 'XL', 'L', 'H', 'XH', 'XXH'.

Table 2 RECOMMENDED PULLEY PITCH DIAMETERS

V-Belt Section	Permissible Min. Pulley Pitch Diameter mm	inch	Recommended Min. Pulley Pitch Daimeter mm	inch
A	75	3	95	3.8
B	125	5	145	5.8
C	200	8	225	9
D	315	12.6	350	14
E	500	20	550	22
SPZ	-	-	63	2.5
SPA	-	-	90	3.6
SPB	-	-	160	6.4
SPC	-	-	224	9.0

DRIVE DESIGN FORMULAE

$$L = 2C + 1.57(D+d) + \frac{(D-d)^2}{4C}$$

$$C = A + \sqrt{(A^2 - B)}$$

where

$$A = \frac{L}{4} - 0.3925(D+d)$$

$$B = \frac{(D-d)^2}{8}$$

$$\text{Number of belts, } N = \frac{P \times Fs}{R \times Ri \times Fc}$$

where
L = Belt Pitch Length, mm
C = Centre Distance, mm
D = Pitch dia. of large pulley, mm
d = Pitch dia. of small pulley, mm
R = Power Rating per belt, KW
Ri = Belt Length Correction Factor
Fc = Arc of contact correction Factor
Fs = Service Factor
P = Drive Power in KW.

INFORMATION TO BE SUPPLIED WITH ENQUIRY OR ORDER

(i) Section
(ii) Size in inches or mm
(iii) Quantity in nos.

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Material Handling & HillDrive Hydraulics Solutions

Universal
CONVEYOR TRANSMISSION

Selecting a V-Belt Drive

Designing a V-belt drive basically includes factors like belt speed, H.P. rating, Service factor, sheave diameters and Arc of contact with small sheaves.

Step 1 **Determine Speed Ratio**

Calculate the *Speed Ratio* by dividing the *revolutions per minute* of the *faster shaft* (driving) by the *rev/min* of the *slower shaft* (driven). alternatively, *pitch diameter* of *larger pulley* divided by the *pitch dia* of *smaller pulley* will give speed ratio. Hence,

$$\text{Speed Ratio} = \frac{\text{RPM of faster shaft}}{\text{RPM of slower shaft}}$$

$$= \frac{\text{Pitch Diameter of Larger pulley}}{\text{Pitch Diameter of Smaller Pulley}}$$

Step 2 **Choose Belt Section**

Please select belt section most suitable for application from *Table 1.*

Step 3 **Correct H.P. for Service Factor**

This is essentially finding the *design power* i.e., the motor or prime mover power in H.P. or KW multiplied by the service factor for appropriate type of service taking into account the operational hours per day, for which please refer Table 4. Hence,

Design Power = **Prime Mover Power x Service Factor**

Step 4 **Choose Sheave or Pulley Diameter**

Please select right *pulley pitch diameters* from Table 2 as the recommended pulley pitch diameters are capable of transmitting the design power at given speed.

Step 5 **Calculate Belt Pitch Length**

The *pitch lengths* of belts corresponding to given pulley diameters and center distances may please be obtained from the following formula :

$$L_{(\text{in mm})} = 2C + 1.57\,(D + d) + \frac{(D-d)^2}{4C}$$

Where, C = Centre distance (mm)

D = pitch diameter of larger pulley (mm)

d = pitch diameter of smaller pulley (mm)

The inside length of belt, generally marked in inches as a practice, may then be calculated selecting the nearest size in the range taking into account difference between belt pitch length and inside length.

Step 6 **Calculate Centre Distance**

Following formula will give centre distance :

$$C = A + \sqrt{A^2 - B}$$

where, $A = \frac{L}{4} - 0.3925\,(D + d)$

$$B = \frac{(D - d)^2}{8}$$

Illustration

Design a proper V-belt drive to operate the countershaft of a belt conveyor at 200 R.P.M. from a squirrel cage high torque motor, rated 5 H.P. (3.73 KW) at 960 R.P.M. The centre distance is to be approximately 500 m. Operating hours shall be 20 hours per day.

(i) Speed Ratio $= \frac{960 \text{ R.P.M.}}{200 \text{ R.P.M.}}$

$= 4.8$

(ii) Table 1 indicates that V-belt of either section 'A' or 'B' be used. We still use ***'B' Section*** belts for the application as the speed ratio is rather large.

(iii) Design power = 5 H.P. x 1.3
= 6.5 H.P.
or ⇒ 3.73 KW x 1.3
= 4.85 KW

(Value 1.3 as service factor being taken from *Table 4* taking into account the operational hours/day for high torque motor).

(iv) From Table 2, we pick an average size of *145mm* (5.8") pulley dia sheave for the *driver*.

With a speed ratio of 4.8, we must then use a *696mm* pulley dia *driven* sheave. (145mm x 4.8)

(v) $L = 2 \times 500 + 1.57\,(696 + 145) + \frac{(696 - 145)^2}{4 \times 500}$

$= 1000 + 1320.37 +$
$= 1000 + 1320.27 + 151.80$
$= 2472.17$
$=$ say 2472 mm

Select the nearest belt size with a pitch length of 2472 mm. The nearest stock size is B96 with pitch length of 2482 mm (B96 implies 96" = 2438.4 mm inside length and pitch length of section B exceeds inside length by 43 mm meaning belt pitch length of 2481.4 say 2482 mm i.e. 2438.4 + 43).

Section	Belt Pitch Length exceeds Inside Length by (mm)
A	36
B	43
C	56
D	79
E	92

(vi) $A = \frac{2482}{4} - 0.3925\,(696 + 145)$

$= 620.5 - 330.09 = 290.41$

$B = \frac{(696 - 145)^2}{8}$

$= \frac{303601}{8} = 37950.12$

Selecting a V-Belt Drive

C = centre distance (mm)

L = pitch length of belt (mm)

D = pitch diameter of larger pulley (mm)

d = pitch diameter of smaller pulley (mm)

Step 7 **Determine Number of Belts Required**

With belt speed ratio, section and diameter of smaller pulley are established :

(i) Ascertain *power rating per belt* from Table 7 for 180° arc of contact between belt and smaller pulley.

(ii) Determine *Corrected power rating per belt* for an arc of contact less than 180° by multiplying listed H.P. and proper correction factor as shown in *Table 5.*

Thus, the number of belts required can be calculated by *dividing* the *correct H.P. for service factor* i.e., the total H.P. to be transmitted by belts or the design power, whatever nomenclature be understood as in Step 3 by *corrected power rating per belt* as in Step 7.

Illustration

Hence C = $290.41 + \sqrt{(290.41)^2 - 37950.12}$
$= 290.41 + 215.37$
$= 505.78$
$=$ 506 mm (say)

(vii) The power rtaing per belt is 2.82 KW with smaller pulley pitch dia of 150 mm with motor RPM of 960. Interpolating for 145 mm dia pulley, power rating per belt comes out to 2.73 KW and with additional power per belt for speed ratio of 4.8, i.e. 0.30 KW from *Table 7*, the power rating per belt comes out to 3.03 KW (4 H.P.).

The actual arc of contact $= 180° - \frac{57.3\,(D - d)}{C}$

$= 180° - \frac{57.3\,(696 - 145)}{506}$

$= 180° - \frac{31572.3}{506} = 120°$

For actual arc of contact on smaller pulley of 120°, we find a correction factor of 0.82 from *Table 5.* Consequently, the 4 H.P. power rating for 180° arc of contact is reduced to 3.28 H.P. per belt for an arc of contact of 120°.

i.e. *Corrected Power per belt* = 4 H.P. x 0.82 = 3.28 H.P.

Thus, number of belt required

$= \frac{\text{Correct H.P. for service factor or Design Power}}{\text{Corrected power per belt}}$

$= \frac{6.5 \text{ H.P.}}{3.28 \text{ H.P.}} = 1.98$ say 2 belts

i.e. 2 Nos. V-belts of B96/2482.

BELT SPEED

The linear belt speed can be established as stated below :

Belt Speed, (F.P.M., feet per minute) V = (Pitch Dia or Drive Sheave In Inches) x R.P.M. of Prime Mover x 0.262

OR

$$V_{(m/s)} = \frac{\pi \times \text{Pitch Dia of Drive Sheave In mm} \times \text{R.P.M. of Prime Mover}}{60 \times 1000}$$

Now, in above illustration,

Pitch Dia of Drive Sheave = 5.8" or 145 mm; R.P.M. of Prime Mover = 960

Hence V = 5.8 x 960 x 0.262 = 1458.8 feet per minute

or $V = \frac{\pi \times 145 \times 960}{60 \times 1000} = \frac{3.14 \times 145 \times 960}{60000} =$ 7.28 m/s.

Table 4 SERVICE FACTORS FOR TYPE OF DRIVEN MACHINES

To correct the horse power rating of the V-belt drive for the type of service on which is to be used, multiply the motor horse power transmitted by the power correction factor as given in the table, taking into account type of driven machine and the operational hours per day.

SPEED INCREASING DRIVES For Speed Increasing drives, Multiply Fs with 1.00 for speed Ratio 1.00 to 1.24 1.05 for speed Ratio 1.25 to 1.74 1.11 for speed Ratio 1.75 to 2.49 1.18 for speed Ratio 2.50 to 3.49 1.25 for speed Ratio 3.50 and Over		*TYPES OF PRIME MOVERS* **Soft Starts** Electric Motors (Normal Torque) : A.C. - Star-Delta Start D.C. - Shut wound I.C. Engines with 4 or more cylinder all prime movers fitted with centrifugal clutches, fluid or powder couplings			**Heavy Starts** Electric Motors (High Torque) : A.C. Direct on-line start D.C. - Series and compound wound I.C. Engines with less than 4 cylinders Line shafts, clutches.		
Types of Driven Machines		**Operational Hours per day**			**Operational Hours per day**		
		Upto 10 h	Over 10 to 16 h	Over 16 h	Upto 10 h	Over 10 to 16 h	Over 16 h
Light Duty	Agitators (Uniform density). Blowersm Exhausters, Centrifugal pumps and Compressors, Fans upto 7.5 kw and Belt conveyors (light duty).	1.0	1.1	1.2	1.1	1.2	1.3
Medium Duty	Agitators and Mixers (Vairable density), Blowers, Exhausters and fans and Dough mixers over 7.5 kw, positive displacement rotary pumps and compressors. Belt conveyers (Not uniformly loaded), Generators, line-shafts, Laundry machinery, Machine-tools, punches, presses and shears, Printing machinery, Revolving and Vibrating screens.	1.1	1.2	1.3	1.2	1.3	1.4
Heavy Duty	Brick machinery, Bucket elevators, Exciters, Reciprocating compressors and pumps, Conveyors (drag-pan-screw), Hammer mills, Paper mill beaters, Pulverizers, Saw mill and Wood working machinery, Textile machinery and Rubber machinery.	1.2	1.3	1.4	1.4	1.5	1.6
Extra Heavy Duty	Crushers (gyratory-jaw-roll), Mills (Bal-rod-tube), hoists, Rubber (calenders, extuders mills).	1.3	1.4	1.5	1.5	1.6	1.8

Table 5 ARC OF CONTACT CORRECTION FACTORS

$\frac{D-d}{C}$	Factor Fc	Arc of contact on smaller pulley, degrees	$\frac{D-d}{C}$	Factor Fc	Arc of contact on smaller pulley, degrees	$\frac{D-d}{C}$	Factor Fc	Arc of contact on smaller pulley, degrees
0.00	1.00	180	0.50	0.93	151	1.00	0.82	120
0.05	0.99	177	0.55	0.92	148	1.05	0.81	117
0.10	0.99	174	0.60	0.91	145	1.10	0.80	113
0.15	0.98	171	0.65	0.90	142	1.15	0.78	110
0.20	0.97	169	0.70	0.89	139	1.20	0.77	106
0.25	0.97	166	0.75	0.88	136	1.25	0.75	103
0.30	0.96	163	0.80	0.87	133	1.30	0.73	99
0.35	0.95	160	0.85	0.86	130	1.35	0.72	95
0.40	0.94	157	0.90	0.85	127	1.40	0.70	91
0.45	0.93	154	0.95	0.83	123	1.45	0.68	87

Arc of contact below 120° should not please be used unless complete drive details are submitted to HIC International Co. Inc., New Delhi for confirmation.

Table 6 CORRECTION FACTORS FOR BELT LENGTH

	Belt Length, mm								
Factor	SPZ	A	SPA	B	SPB	C	SPC	D	E
0.80	-	610	-	-	-	1295	-	-	-
0.81	-	660	-	889	-	-	-	-	-
0.82	-	711	800	-	-	1524	-	-	-
0.83	630	-	-	965	-	-	-	-	-
0.84	-	787	900	1016	-	-	-	-	-
0.85	710	813	-	1067	1250	1727	2000	3048	-
0.86	-	-	1000	-	-	-	-	3251	-
0.87	800	889	-	1168	1400	1905	2240	-	-
0.88	-	965	1120	-	1500	2057	-	3658	-
0.89	900	1016	-	1295	1600	2159	2500	-	-
0.90	-	1067	1250	-	-	2286	2800	4013	-
0.91	-	-	-	1473	1800	2458	-	-	-
0.92	1000	1168	1400	-	-	-	3150	4572	5334
0.93	-	-	-	1651	2000	2667	-	-	-
0.94	1140	1295	1600	1778	-	2845	3550	5334	6045
0.95	-	-	-	-	2240	-	-	-	-
0.96	1250	1397	1800	1905	2500	3048	4000	6045	6807
0.97	-	-	-	-	-	3251	4500	-	-
0.98	1400	1524	2000	2159	2800	-	-	6807	7569
0.99	-	-	-	2286	-	3658	5000	-	-
1.00	1600	1651	2240	-	3150	4013	-	8331	9093
1.01	-	1778	-	2464	-	-	5600	-	-
1.02	1800	1905	2500	2540	3550	4572	6300	9093	9855
1.03	-	-	-	2667	-	-	-	-	-
1.04	2000	2032	2800	2845	4000	5334	7100	9855	10617
1.05	-	-	-	-	-	-	-	-	-
1.06	2240	2286	3150	3048	4500	-	8000	10617	12141
1.07	-	-	-	3251	-	6807	-	-	-
1.08	2500	2438	3550	-	5000	-	9000	12141	13665
1.09	-	-	-	3658	-	-	10000	-	-
1.10	2800	2667	4000	-	5600	-	-	13665	15189
1.11	-	2845	-	4013	6300	-	11200	-	-
1.12	3150	-	4500	4115	-	9093	-	15189	-
1.13	-	3048	-	-	7100	-	12500	-	-
1.14	-	3251	-	4572	-	9855	-	-	-
1.15	3550	-	-	-	8000	10617	-	-	-
1.16	-	-	-	5334	-	-	-	-	-
1.17	-	-	-	-	-	-	-	-	-
1.18	-	-	-	-	-	-	-	-	-
1.19	-	-	-	-	-	-	-	-	-
1.20	-	-	-	-	-	-	-	-	-
1.21	-	-	-	-	-	-	-	-	-
1.22	-	-	-	-	-	-	-	-	-
1.23	-	-	-	-	-	-	-	-	-
1.24	-	-	-	-	-	-	-	-	-

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Table 7 (R) POWER RATING (KW) PER BELT FOR SMALL PULLEY PITCH DIAMETER

	RPM of smaller pulley	Smaller pulley pitch diameter, mm															1.02 to 1.05	1.06 to 1.11	1.12 to 1.18	1.19 to 1.26	1.27 to 1.38	1.39 to 1.57	1.58 to 1.94	1.95 to 3.38	3.39 and Over
		60	67	71	75	80	85	90	95	100	106	112	118	125	132	140									
SPZ	720	0.56	0.65	0.76	0.84	0.97	1.08	1.19	1.30	1.46	1.57	1.73	1.87	2.03	2.18	2.38	0.01	0.03	0.05	0.06	0.08	0.09	0.10	0.11	0.12
	960	0.70	0.83	0.95	1.08	1.24	1.40	1.57	1.73	1.89	2.05	2.27	2.43	2.65	2.86	3.08	0.01	0.04	0.06	0.08	0.10	0.12	0.13	0.15	0.15
	1440	0.97	1.13	1.35	1.51	1.73	1.94	2.16	2.43	2.61	2.88	3.14	3.40	3.73	4.00	4.34	0.02	0.05	0.09	0.13	0.15	0.18	0.20	0.22	0.23
	2880	1.57	1.89	2.21	2.54	2.97	3.40	3.78	4.21	4.59	5.02	5.51	5.94	6.48	6.99	7.56	0.04	0.11	0.18	0.25	0.30	0.36	0.40	0.44	0.45
		80	85	90	95	100	106	112	118	125	132	140	150	160	180	200									
		0.67	0.75	0.83	0.91	0.99	1.09	1.18	1.28	1.39	1.50	1.62	-	-	-	-	0.01	0.02	0.03	0.05	0.06	0.07	0.08	0.09	0.09
	720	-	-	1.24	1.46	1.67	1.92	2.17	2.42	2.70	3.00	3.32	3.73	4.13	4.93	5.12	0.02	0.07	0.12	0.16	0.20	0.23	0.26	0.28	0.30
		0.84	0.95	1.05	1.16	1.25	1.39	1.50	1.62	1.77	1.91	2.06	-	-	-	-	0.01	0.03	0.04	0.06	0.08	0.09	0.10	0.12	0.12
A	960	-	-	1.54	1.82	2.09	2.42	2.74	3.06	3.43	3.82	4.25	4.74	5.29	6.32	7.36	0.03	0.09	0.16	0.21	0.26	0.30	0.34	0.37	0.40
		1.14	1.28	1.43	1.59	1.73	1.91	2.08	2.26	2.46	2.66	2.88	-	-	-	-	0.02	0.04	0.06	0.10	0.12	0.14	0.16	0.17	0.17
SPA	1440	-	-	2.05	2.45	2.84	3.31	3.77	4.24	4.77	5.31	5.91	6.65	7.39	8.83	10.25	0.05	0.14	0.24	0.32	0.39	0.46	0.51	0.56	0.59
		1.83	2.10	2.35	2.60	2.84	3.10	3.39	3.61	3.95	4.25	4.58	-	-	-	-	0.04	0.08	0.12	0.18	0.23	0.27	0.31	0.35	0.35
	2880	-	-	3.11	3.79	4.49	5.32	6.15	6.94	7.87	8.77	9.78	11.01	12.20	14.43	-	0.10	0.27	0.47	0.64	0.78	0.91	1.03	1.12	1.19
		125	132	140	150	160	170	180	190	200	212	224	236	250	280	315									
		1.78	1.96	2.18	2.45	2.72	3.00	3.26	3.52	3.79	-	-	-	-	-	-	0.03	0.05	0.08	0.12	0.15	0.18	0.20	0.23	0.23
	720	-	-	-	-	5.01	5.62	6.25	6.88	7.49	8.24	8.97	9.70	10.54	12.33	14.37	0.05	0.14	0.25	0.33	0.41	0.48	0.54	0.59	0.62
		2.22	2.46	2.75	3.10	3.44	3.78	4.12	4.45	4.75	-	-	-	-	-	-	0.03	0.07	0.10	0.16	0.20	0.24	0.27	0.30	0.30
B	960	-	-	-	-	6.30	7.12	7.93	8.73	9.53	10.47	11.42	12.35	13.42	15.69	18.26	0.07	0.19	0.32	0.44	0.54	0.62	0.70	0.77	0.81
		3.03	3.33	3.72	4.20	4.68	5.14	5.59	6.05	6.49	-	-	-	-	-	-	0.05	0.10	0.15	0.23	0.30	0.36	0.41	0.46	0.46
SPB	1440	-	-	-	-	7.85	8.89	9.93	10.95	11.95	13.15	14.32	15.48	16.80	19.55	22.57	0.10	0.28	0.48	0.66	0.79	0.94	1.06	1.15	1.21
		4.35	4.88	5.44	6.10	6.72	7.28	7.78	8.22	-	-	-	-	-	-	-	0.10	0.20	0.30	0.46	0.61	0.71	0.81	0.91	0.91
	2880	-	-	-	-	13.24	15.05	16.78	18.44	-	-	-	-	-	-	-	0.20	0.56	0.97	1.32	1.60	1.88	2.11	2.31	2.44
		200	212	224	236	250	265	300	315	355	375	400	425	450	500	560									
		5.15	5.69	6.27	6.84	7.49	8.86	9.76	10.43	12.15	13.00	14.02	-	-	-	-	0.07	0.14	0.21	0.32	0.42	0.49	0.56	0.63	0.63
C	720	-	-	13.34	12.81	14.50	18.07	20.42	22.17	26.75	29.00	31.78	34.51	37.20	42.44	48.47	0.16	0.43	0.76	1.03	1.25	1.46	1.65	1.80	1.90
		6.35	7.05	7.78	8.49	9.30	11.00	12.08	12.89	14.93	15.90	17.06	-	-	-	-	0.09	0.19	0.28	0.45	0.56	0.66	0.75	0.85	0.85
SPC	960	-	-	14.07	15.94	18.09	22.62	25.59	27.77	33.48	36.25	39.64	42.95	46.15	52.30	59.15	0.21	0.58	1.01	1.37	1.67	1.95	2.20	2.40	2.54
		8.25	9.20	10.12	11.03	12.04	14.09	15.35	16.23	18.32	19.22	-	-	-	-	-	0.14	0.28	0.42	0.68	0.85	0.99	1.13	1.27	1.27
	1440	-	-	18.41	20.96	23.87	29.90	33.78	36.59	43.70	47.04	-	-	-	-	-	0.31	0.87	1.51	2.06	2.50	2.93	3.30	3.50	3.81
		315	330	340	350	355	390	465	540	620															
D	585	12.56	13.83	14.67	15.49	16.70	18.71	24.40	29.61	34.60							0.21	0.42	0.62	1.04	1.25	1.46	1.67	1.88	1.88
	720	14.90	16.15	17.00	17.84	18.80	21.02	27.35	33.12	38.61							0.25	0.50	0.75	1.25	1.50	1.75	2.00	2.25	2.25
	960	16.77	18.45	19.55	20.64	22.24	24.80	31.68	37.54	-							0.33	0.67	1.00	1.60	2.00	2.33	2.67	3.00	3.00
	1440	18.73	20.55	21.71	22.81	24.36	26.68	-	-	-							0.50	1.00	1.50	2.50	3.00	3.50	4.00	4.50	4.50
		500	530	560	570	580	600	610	635	660															
E	585	25.73	28.75	31.70	34.52	37.39	39.90	42.83	44.85	46.92							0.41	0.83	1.24	2.07	2.48	2.89	3.00	3.72	3.72
	720	28.68	32.01	35.18	38.31	41.30	44.13	46.85	49.44	51.86							0.50	0.99	1.49	2.48	2.98	3.51	3.98	4.48	4.48
	960	30.61	34.05	37.14	40.15	42.79	45.17	-	-	-							0.66	1.33	1.98	3.31	3.97	4.63	5.29	5.95	5.95

Belt Speed (feet per minute) = [Pitch Diameter of Drive Sheave in Inches] x R.P.M. of Prime Mover x 0.262