

Therefore, CEMA recommends for critical applications the correct transition distance should be calculated under all expected tensions based on the belt manufacturer's recommendations. One method for calculating the transition distance is given in ISO5293-2008. Charts 7.27 and 7.29 are provided for reference.

#### CEMA Recommendation

- Always use metal rollers of the proper load rating for transition idlers.
- Never loaded on a transition, start loading after at least one full troughing idler.
- The full transition arrangement is the CEMA preferred arrangement for transitions before loading.
- The one third transition is the CEMA preferred arrangement for transitions at the discharge.

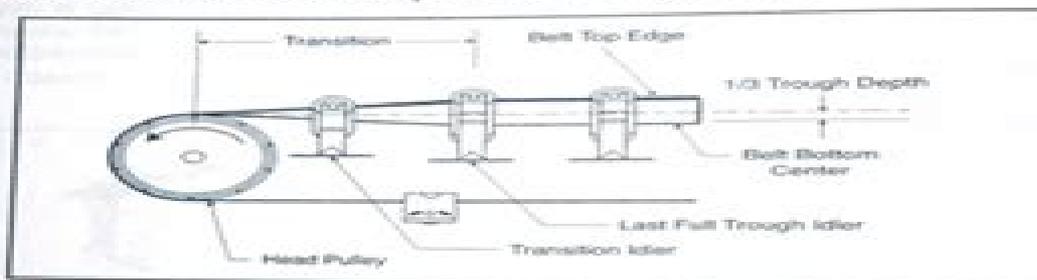


Figure 7.26

One third trough transition from last fully troughed idler to pulley

Idler Trough Angle	% Rated Belt Tension	Transition Distance = Factor × Belt Width (BW)	
		Fabric Belts	Steel Cord Belts
20°	> 90%	1.2	2.7
	60% to 90%	0.9	2.1
	< 60%	0.6	1.3
35°	> 90%	2.1	4.5
	60% to 90%	1.4	3.5
	< 60%	1.2	2.4
45°	> 90%	2.6	5.3
	60% to 90%	2.0	4.3
	< 60%	1.6	3.1

Table 7.27

One third trough minimum transition distance ratios

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