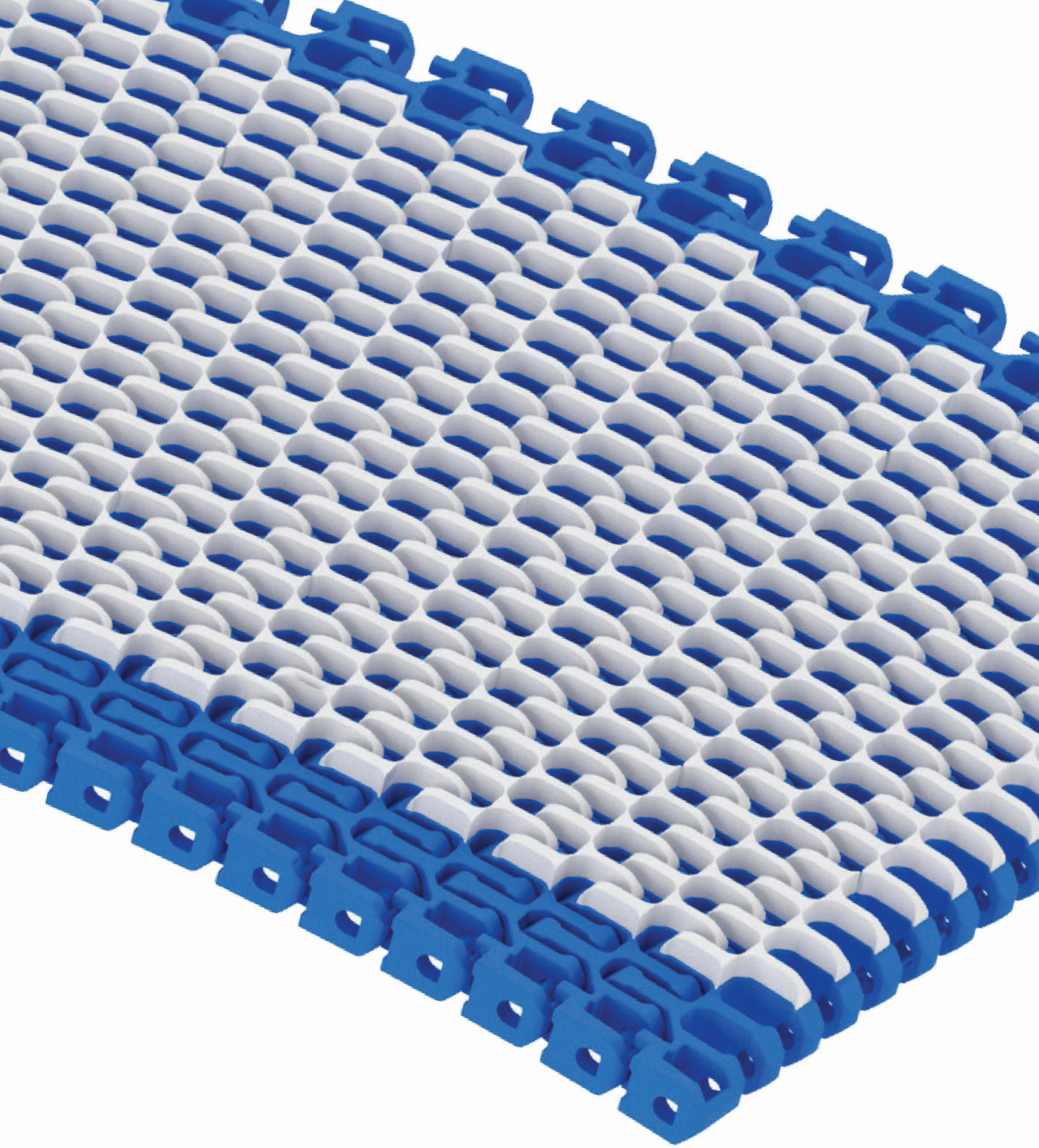




HC254 R-GT

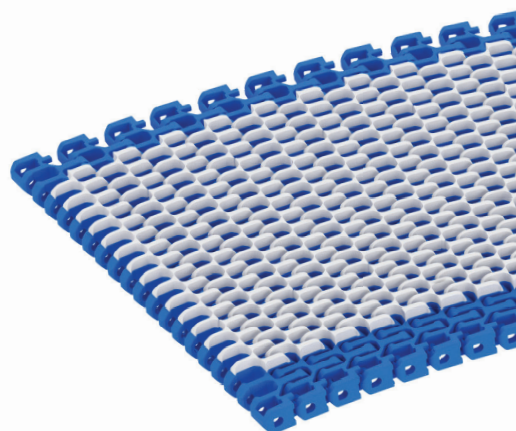
Modular Belt Series



MODUTECH®
Movement Technologies

HC254 R-GT

Pitch:	25,4 mm / 1 inch
Belt Surface:	Open, Friction Top Surface
Minimum Width:	203,2 mm / 8 inch
Open Area (%):	42%. (Biggest opening 8,30 x 4,70 mm)
Product Contact Area (%):	25%
Flight:	No
Sidewall:	No
Pin:	Ø4,6 mm / 0.181 inch
Approved:	FDA and EU
Curve:	Yes
Color:	Blue / White / Gray
Cleanability:	Excellent
Application:	Straight and side flexing
Collapse Factor:	2.22 (Please check HC254R Collapse Factors-Width Table)
Belt Thickness:	17,8 mm / 0.7 inch

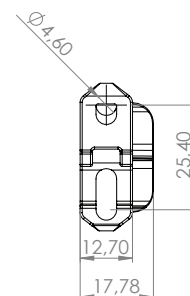
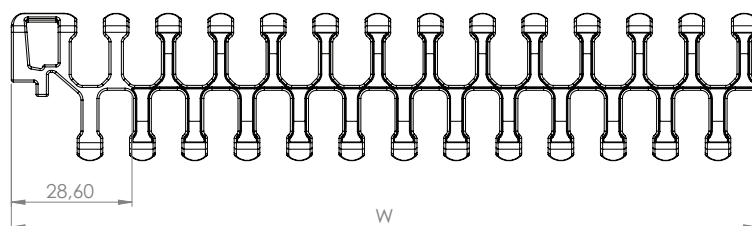


HC254 R-GT Technical Information

Belt Material		PP	PP
Rubber Material		TPE	
Pin Material		PA	POM
Belt Strength	N/m lb/ft	18000 - 1233	18000 - 1233
Belt Strength (Curve)	N lb	1225 - 275	1225 - 275
Temperature	°C °F	+5 / +60 -40 / +140	+5 / +60 -40 / +140
Belt Weight	kg/m² lb/sqft²	7,5 / 1.53	7,6 / 1.57

Diameter of idling rollers (min.)		Diameter of support rollers (min.)		Diameter for gravity take up center drive rollers (min.)		Backbending radius for elevators without side guards or hold down devices (min.)		Backbending radius for elevators with side guards or hold down devices (min.)	
mm	inch	mm	inch	mm	inch	mm	inch	mm	inch
50	2	50	2	100	4	150	6	-	-

Belt Width (mm)	203,2	254,0	304,8	355,6	406,4	457,2	508,0	558,8	609,6	660,4	711,2	762,0	812,8	863,6	914,4	965,2	1016,0	1066,8	1117,6
Belt Width (inch)	8.00	10.00	12.00	14.00	16.00	18.00	20.00	22.00	24.00	26.00	28.00	30.00	32.00	34.00	36.00	38.00	40.00	42.00	44.00
Belt Width (mm)	1168,4	1219,2																	
Belt Width (inch)	46.00	48.00																	



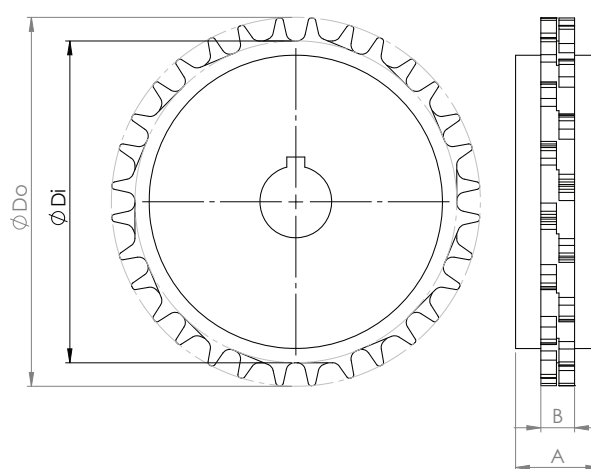
Product Features and Functional Benefits

- Designed for straight and radius conveyors.
- Offers optimal open area for drainage and airflow.
- The unique belt edge provides more uniform load distribution and minimizes fatigue-related failures throughout the belt. Increases belt life.
- High temperature and wear resistance.

Important Notes

- Standard belt increments 12,7 mm.
- Indent for rubber surface is 28,6 mm (1.125 inch).
- Please contact with customer service for precise belt measurements.
- Special raw materials and additional colors available.
- Belt widths bigger than 1200 mm (48") are not recommended. For further information, please contact Modutech Representatives.
- Physical belt widths are generally 0.1% to 0.3% smaller.
- For PP 750 mm (30") -3 mm to 0 mm and -0.4% to 0% for wider belts.

Sprockets and Technical Specifications



NO.TEETH	Di	Do	A	B	Square Bore (Q)		Round Bore (R)		PRODUCT CODE	
	mm/inch	mm/inch	mm/inch	mm/inch	mm/inch		mm/inch		Square Type (Q)	Round Type (R)
Z12	81,7 / 3,21	98,5 / 3,87	30 / 1,18	12 / 0,47	25 to 40	1 to 1,5	25 to 40	1 to 1,5	HC254RSQZ12-POM	HC254RSRKZ12-POM
Z16	114,6 / 4,51	131,4 / 5,17	30 / 1,18	12 / 0,47	25 to 40	1 to 1,5	25 to 40	1 to 1,5	HC254RSQZ16-POM	HC254RSRKZ16-POM
Z20	147,3 / 5,79	164,1 / 6,46	30 / 1,18	12 / 0,47	25 to 60	1,5 to 2,5	25 to 40	1 to 1,5	HC254RSQZ20-POM	HC254RSRKZ20-POM

*Machined Split Sprockets are available.

HC254 R Series

Accessories and Technical Specifications

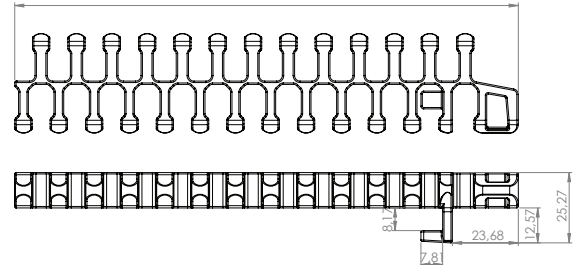
HC254 R Series / TAB - Technical Specifications

TAB-M

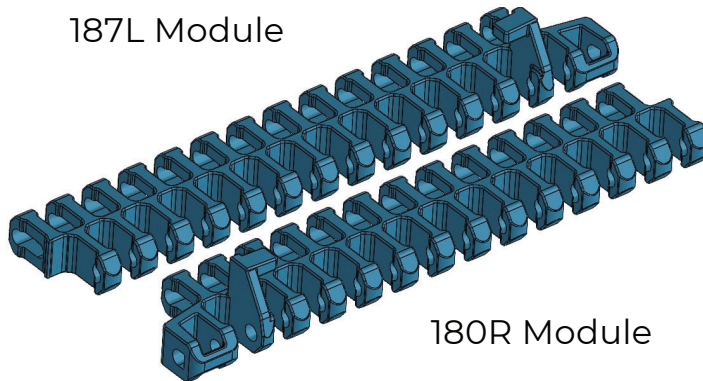


Upside Down View

Technical Drawings



187L Module



180R Module

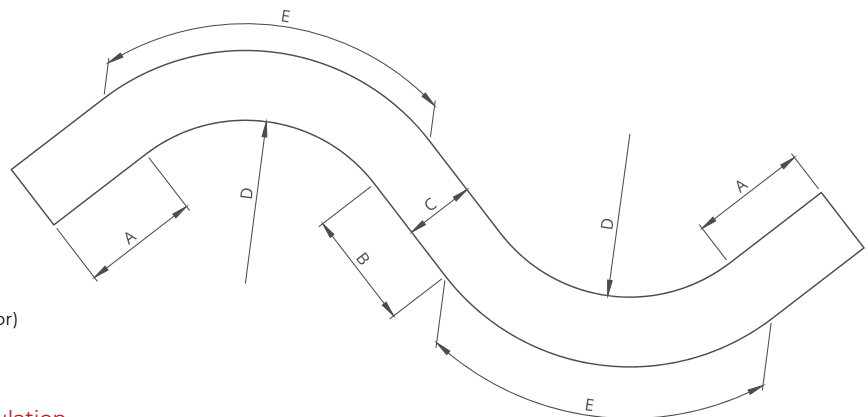
Important Notes:

*Please consider the distance between shaft and bottom edge of TAB during the conveyor design.

*TAB-M edge modules are available only with the standard edge design. Load-distributing edge designs are not available for this yet.

Radius Belt Example 90° S-Curve

Note: There is no minimum straight section (B) required between turns that are in the same direction. (U-turn conveyor)



HC254 R Series / Radius Belt Calculation

A: Straight run pull and $n = \min. 1,5 \times \text{belt width recommended}$

B: Straight run between 2 curves = $\min. 2 \times \text{belt width}$

C: Belt width

D: Minimum inner radius

E: Curve length

$$\text{Collapse Factor} = \frac{\text{Min. inner radius}}{\text{Belt width}}$$

Minimum inner radius = Collapse Factor x Belt width

CALCULATION EXAMPLE

C: 508 mm (Belt width)

Collapse Factor: 2.24

D: $508 \text{ mm} \times 2.24 = 1137,92 \text{ mm}$

A: 508 (min.)

B: $2 \times 508 \text{ mm} = 1016 \text{ mm (min.)}$

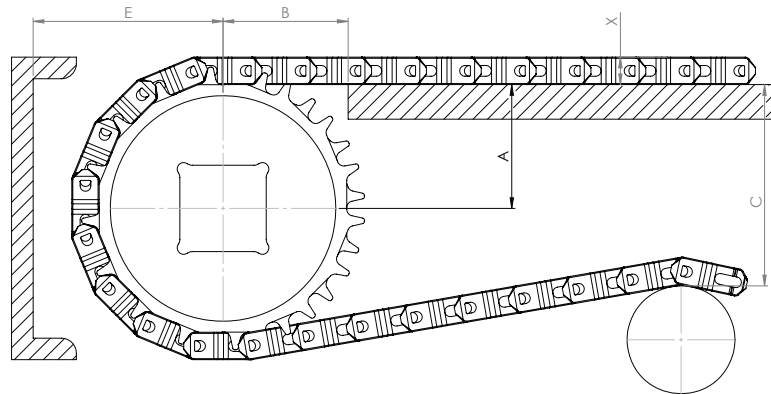
E: $\frac{2 \times (C+D) \times 3.14}{4} = 2584,1 \text{ mm}$

Total conveyor length = $(2 \times A) + B + (2 \times E) = 7200,2 \text{ mm}$

HC254 R Series

Engineering Information

A: $\pm 0,031"$ (1mm)
B: $\pm 0,125"$ (1mm)
C: $\pm$ (Max.)
B: $\pm$ (Min.)



HC254 R Series / Conveyor Frame Dimensions

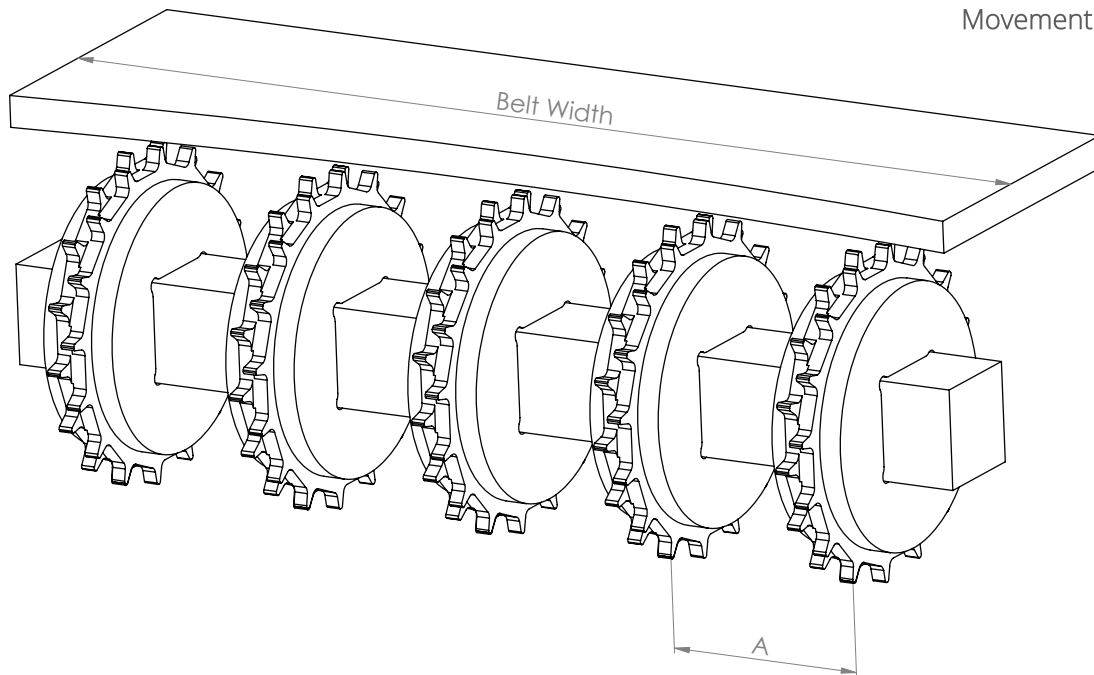
Sprockets Description			A		B		C		E		X	
Pitch Diameter		No.Teeth	Range (Bottom to Top)		inch	mm	inch	mm	inch	mm	inch	mm
inch	mm		inch	mm								
HC254 R, HC254 R-LS												
3,75	95,3	12	1,65	42	1,85	47	3,86	98	2,24	57	0,50	12,7
5,12	130,1	16	2,28	58	2,13	54	5,12	130	2,87	73	0,50	12,7
6,33	160,7	20	2,95	75	2,32	59	6,38	162	3,50	89	0,50	12,7
HC254 R-HID												
3,75	95,3	12	1,65	42	1,85	47	4,25	108	2,64	67	1,13	28,6
5,12	130,1	16	2,28	58	2,13	54	5,51	140	3,27	83	1,13	28,6
6,33	160,7	20	2,95	75	2,32	59	6,77	172	3,90	99	1,13	28,6
HC254 R-TAB-M												
3,75	95,3	12	1,65	42	1,85	47	3,86	98	2,24	57	0,50	12,7
5,12	130,1	16	2,28	58	2,13	54	5,12	130	2,87	73	0,50	12,7
6,33	160,7	20	2,95	75	2,32	59	6,38	162	3,50	89	0,50	12,7
HC254 R-GT												
3,75	95,3	12	1,65	42	1,85	47	4,06	103	2,44	62	0,70	17,78
5,12	130,1	16	2,28	58	2,13	54	5,31	135	3,07	78	0,70	17,78
6,33	160,7	20	2,95	75	2,32	59	6,57	167	3,70	94	0,70	17,78

HC254 R Series

Engineering Information



MODUTECH[®]
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HC254 R Series / Sprocket & Wearstrip Arrangements

Standard Belt Width		Number of sprockets per shaft	Number of wearstrips		A (mm/inch)	
mm	inch		Carryway	Returnway	Min.	Max.
203,2	8	2	2	2	50 / 2	127 / 5
254,0	10	2	3	2	50 / 2	127 / 5
304,8	12	3	3	2	50 / 2	127 / 5
355,6	14	3	3	3	50 / 2	127 / 5
406,4	16	5	3	3	50 / 2	127 / 5
457,2	18	5	3	3	50 / 2	127 / 5
508,0	20	5	3	3	50 / 2	127 / 5
558,8	22	5	4	3	50 / 2	127 / 5
609,6	24	5	4	3	50 / 2	127 / 5
660,4	26	7	4	3	50 / 2	127 / 5
711,2	28	7	5	4	50 / 2	127 / 5
762,0	30	7	5	4	50 / 2	127 / 5
812,8	32	7	5	4	50 / 2	127 / 5
863,6	34	7	5	4	50 / 2	127 / 5
914,4	36	7	5	4	50 / 2	127 / 5
965,2	38	9	6	4	50 / 2	127 / 5
1016,0	40	9	6	5	50 / 2	127 / 5
1066,8	42	9	6	5	50 / 2	127 / 5
1117,6	44	9	7	5	50 / 2	127 / 5
1168,4	46	11	7	5	50 / 2	127 / 5
1219,2	48	11	7	5	50 / 2	127 / 5

Note:

*The number of sprockets and wearstrips may vary depending on the load.

*For wider belt widths, central distance of sprockets should be minimum 152,4mm (6").

*For wider belts, central distance of carryway wearstrips 228,6mm (9"), returnway wearstrips 304,8mm (12").

HC254 R Series / Collapse Factors per belt width

Nom. Belt Width (mm)	203,2	254,0	304,8	355,6	406,4	457,2	508,0	558,8	609,6	660,4	711,2	762,0	812,8	863,6	914,4	965,2	1016,0	1066,8	1117,6	1168,4	1219,2
Nom. Belt Width (inch)	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40	42	44	46	48
Collapse Factor	2,18	2,18	2,18	2,20	2,20	2,22	2,24	2,24	2,26	2,26	2,30	2,30	2,32	2,32	2,34	2,34	2,36	2,36	2,38	2,38	2,40
Min. Inner Radius (mm)	443,0	553,7	664,5	782,3	894,1	1015,0	1137,9	1251,7	1377,7	1492,5	1635,8	1752,6	1885,7	2003,6	2139,7	2258,6	2397,8	2517,6	2659,9	2780,8	2926,1
Min. Inner Radius (inch)	17,44	21,80	26,16	30,80	35,20	39,96	44,80	49,28	54,24	58,76	64,40	69,00	74,24	78,88	84,24	88,92	94,40	99,12	104,72	109,48	115,20

*Standard range of belt width and collapse factor (Min. Inner radius = Collapse factor x Standard belt width)