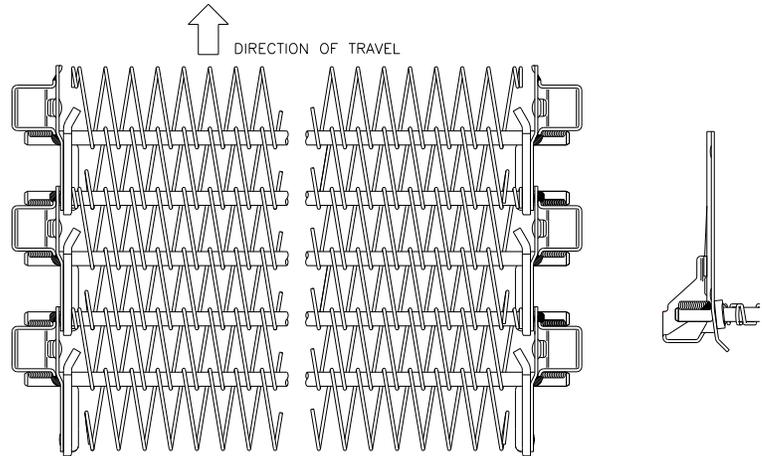




PRODUCT TECHNICAL BULLETIN

ExactaStack XE

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DESCRIPTION

ExactaStack XE is a stainless steel, self-stacking belt designed to be a drop-in replacement belt for popular heavy-duty stacker systems where increased load capacity is required. It is available in 930mm [36.61"], and 1070mm [42.13"] widths and all standard tier heights. It works with OEM drive systems and can be spliced directly to OEM belts, allowing replacement of small sections of damaged belt or the entire belt with no modification to the system.

SPECIFICATIONS

- **Material**
Stainless steel links, rods, and mesh.
- **Rod Size**
7mm [.276"]
- **Pitch**
Longitudinal pitch is 60mm [2.36"] per link. The intermediate rod is spaced at 30mm [1.18"].
- **Tier Height**
Nominal tier heights of 80mm [3.15"], 100mm [3.94"], 120mm [4.72"], 150mm [5.90"], 180mm [7.09"], and 220mm [8.66"] are available.
- **Belt Width**
Belt is offered in widths to fit pre-engineered systems.
Available widths are 930mm [36.61"] and 1070mm [42.13"].
- **Conveying Surface**
Useable width is approximately 55mm [2.17"] less than belt width.

- **Open Area**
6mm Mesh: 35% straight, 21% turn
9mm Mesh: 51% straight, 40% turn
13mm Mesh: 61% straight, 52% turn
20mm Mesh: 69% straight, 62% turn
- **Turn Capability**
Belt is designed to turn in one direction only. Inside edge links are supplied with ventilation holes for compatibility with existing systems. Either right hand (CW) or left hand (CCW) turn direction must be specified.
- **Turn Ratio**
Turn ratio (turn radius ÷ belt width) is 1.90:1
- **Belt Weight**
Select the belt weight from the table below.

Belt Weight (lbs/ft)

Belt Width	Link Height	Pitch Wire	6mm		9mm		13mm		20mm	
			1.6mm	1.8mm	1.6mm	1.8mm	1.6mm	1.8mm	1.6mm	1.8mm
930mm	80mm		13.12	14.33	11.62	12.43	10.69	11.25	9.98	10.35
	100mm		13.50	14.71	12.01	12.82	11.07	11.63	10.36	10.74
	120mm		13.89	15.10	12.39	13.21	11.46	12.02	10.75	11.13
	150mm		14.47	15.68	12.97	13.78	12.04	12.60	11.33	11.70
	180mm		15.05	16.26	13.55	14.36	12.62	13.18	11.91	12.28
	220mm		15.82	17.03	14.32	15.14	13.39	13.95	12.68	13.06
1070mm	80mm		14.83	16.24	13.05	13.99	11.99	12.65	11.17	11.60
	100mm		15.22	16.63	13.44	14.37	12.38	13.03	11.55	11.99
	120mm		15.60	17.01	13.82	14.76	12.76	13.42	11.94	12.38
	150mm		16.18	17.59	14.40	15.34	13.34	14.00	12.52	12.95
	180mm		16.76	18.17	14.98	15.92	13.92	14.58	13.10	13.53
	220mm		17.53	18.94	15.75	16.69	14.69	15.35	13.87	14.31

OPERATING RATINGS

- **Allowable Tension**
Belt strength is not rated. Belts are designed for replacement use in zero-tension self-stacking systems, where tensions do not typically exceed 100 lbs [45.5kg]. Belts will carry the maximum load specified by the system manufacturer for an equivalent belt.
- **Belt Speed**
100 ft/min (30 m/min) maximum recommended
- **Temperature Rating**
-50°F [-45°C] to 400°F [204°C]

For applications that do not comply with these rating limits, please consult Ashworth engineering.

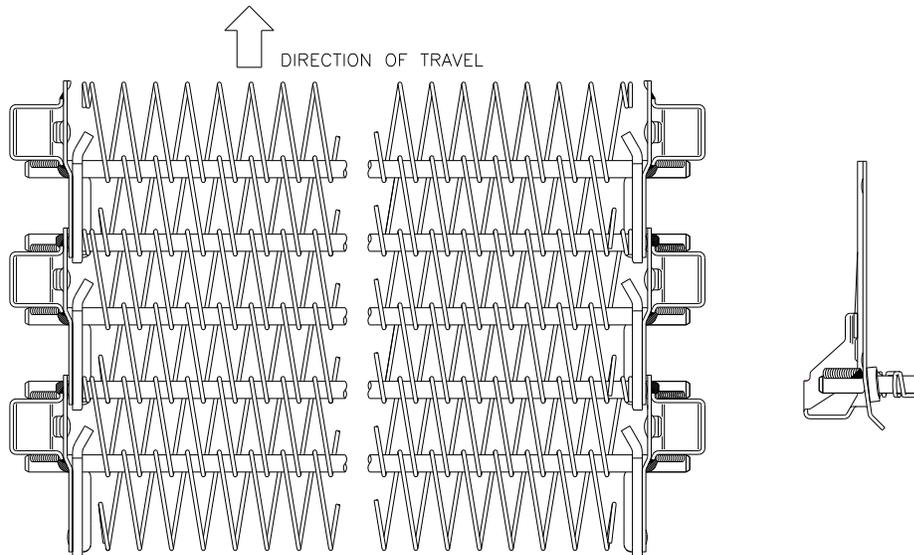
BELT OPTIONS

- **Wire Mesh Overlays**

Mesh is specified using the standard designation for existing systems, X-Y-Z, as shown below.

X = Belt Width	Y = Pitch	Z = Wire Dia.
92 = 920 mm	6 mm	1.6 mm
106 = 1060 mm	9 mm	1.8 mm
	13 mm	
	20 mm	

Standard mesh overlay for ExactaStack is a right-hand wind, unilateral weave (see illustration below) comprised of two mating spirals. The first terminates with round pigtails on the leading side of the spiral. The second terminates with oval pigtails on the trailing side of the spiral and has one less loop across the width of the belt such that the oval pigtails are nested within the round pigtails on the adjacent spiral. The pigtails of both spirals are installed on the connecting rod joining the links. Tension links are installed between the links and the spirals on both sides of the belt.



- **Special Wire Mesh Overlays**

Typically, special mesh configurations can be made to match existing belts with non-standard mesh overlay. Please consult Ashworth engineering.

BELT OPERATION

General Guidelines To Reduce Belt Tension and Wear:

- Clean and lubricate guides and supports.
- Replace plastic wear coverings on guides and supports when worn.
- Clean ice and product debris from the belt, sprockets, and idlers to prevent belt damage.
- Observe the effect of temperature on the coefficient of friction between the supports and the belt. Products may leave a slick residue at room temperature that can become viscous or sticky as the temperature decreases. At freezing temperatures, the debris may become slick again or leave a rough surface depending upon its consistency.
- Remove extra weight from the take-up loop.
- Align sprockets properly and ensure that they do not migrate on the shaft.
- Do not overload the belt.
- Decrease belt speed.

Lubrication

Lubrication is not required under normal operating conditions. However, lubrication will enhance belt performance, particularly at higher belt speeds or when conveying heavy product loads. Make sure any lubricant used is compatible with your belt material and product. SPIRALUBE Belt Oil from Ashworth Factory Service is recommended.

Application Method

- Brush, fed from a drip reservoir, applied onto the belt's underside in the return path, so that the belt coats the loaded path rails with the lubricant
- Install and activate the lubricator for either a predetermined application interval or when the drive motor amperage indicates excessive belt tension.

Reference: Product Technical Bulletin "Conveyor Design Guidelines".

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