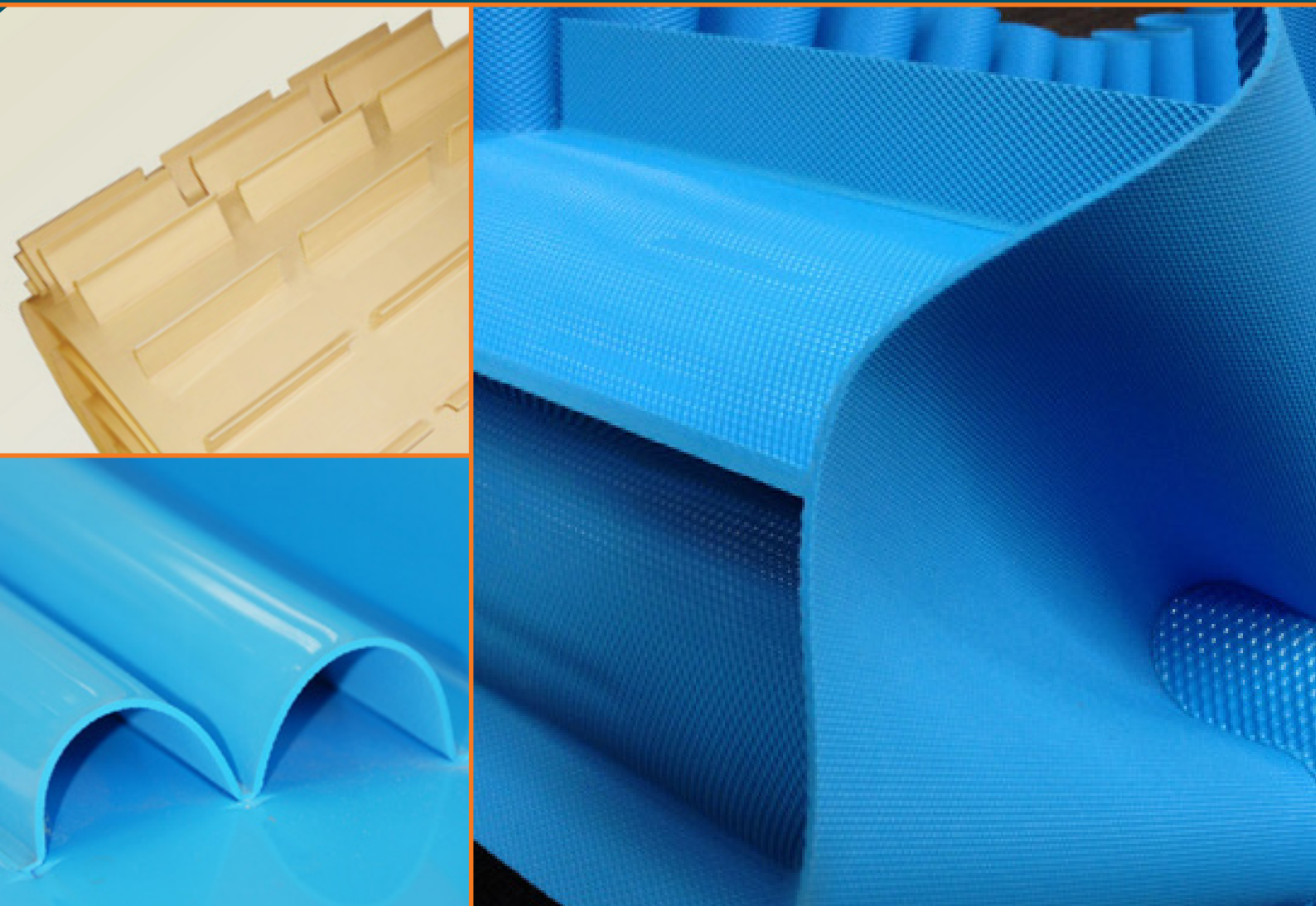


# ELLEGAARD.



## **VOLTA**

The art of fabrications

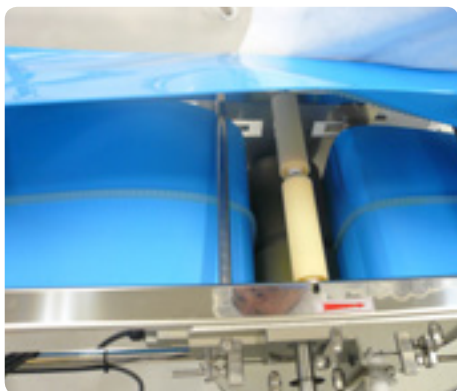
**FOOD**

Volta Belting has created a unique system including tooling to manufacture heat welded fabrications customized to individual needs.

## Guides

All Volta guides are heat welded, eliminating the use of adhesives. This prevents the guide detaching from the base belt. All Volta guides are durable and withstand abrasion, oils and general wear and tear as do Volta base belts.

Guides are generally seen in one of three configurations:



1. A single center guide on the underside of the belt used to prevent off-tracking.



2. Two parallel guides on, or close to the belt edges on the underside of the belt used on wider belts; common in vegetable processing.



3. Two parallel guides on the top side of the belt used in elevators to maintain belt rigidity.

Guides are made from L, M (LT,MD) and H material (for H belts only) as well as special soft guides from 65A Shore TPE which help reduce the MPD of the belt compared to a standard L or M guide.

A further reduction of MPD can be obtained by using cogged guides which are coded C in place of the standard V coding (e.g. CLC in place of VLC).

| Type                                     | CSB/<br>CSC    |      | VSB/<br>VSC    |      | CFB/<br>CFC*   |      | VLSB/<br>VLSC* |      | CLSC* |      | VL/VLC/<br>VLB       |      | CL/CLC/<br>CLB       |      | VM  |      | CM  |      | VW/<br>VWB     |      | CW/<br>CWB     |      |
|------------------------------------------|----------------|------|----------------|------|----------------|------|----------------|------|-------|------|----------------------|------|----------------------|------|-----|------|-----|------|----------------|------|----------------|------|
| Shore Hardness                           | 65A            |      | 65A            |      | 75A            |      | 80A            |      | 80A   |      | 80A                  |      | 80A                  |      | 90A |      | 90A |      | 40D            |      | 40D            |      |
| Color                                    | Blue/<br>Clear |      | Blue/<br>Clear |      | Blue/<br>Clear |      | Blue/<br>Clear |      | Clear |      | Brown/<br>Clear/Blue |      | Brown/<br>Clear/Blue |      | Red |      | Red |      | White/<br>Blue |      | White/<br>Blue |      |
| Cogged                                   | yes            |      | no             |      | yes            |      | no             |      | yes   |      | no                   |      | yes                  |      | no  |      | yes |      | no             |      | yes            |      |
| Add to Base Belt Minimum Pulley Diameter |                |      |                |      |                |      |                |      |       |      |                      |      |                      |      |     |      |     |      |                |      |                |      |
| Size(mm)<br>WxH                          | mm             | inch | mm             | inch | mm             | inch | mm             | inch | mm    | inch | mm                   | inch | mm                   | inch | mm  | inch | mm  | inch | mm             | inch | mm             | inch |
| 6x4                                      | NA             |      | 15             | 0.6  | NA             |      | NA             |      | NA    |      | 25                   | 1    | NA                   |      | NA  |      | NA  |      | NA             |      | NA             |      |
| 8x5.2                                    | NA             |      | 25             | 1    | NA             |      | NA             |      | NA    |      | 40                   | 1.5  | NA                   |      | 60  | 2.5  | NA  |      | NA             |      | NA             |      |
| 10x6                                     | 22             | 0.85 | 30             | 1.2  | 27             | 1.05 | 40             | 1.6  | 30    | 1.2  | 45                   | 1.75 | 35                   | 1.4  | 65  | 2.75 | 50  | 2    | 70             | 2.75 | 55             | 2.15 |
| 13x8                                     | 28             | 1.1  | 35             | 1.4  | 33             | 1.30 | 45             | 1.8  | 35    | 1.4  | 50                   | 2    | 40                   | 1.6  | 80  | 3.25 | 60  | 2.36 | 80             | 3.15 | 60             | 2.35 |
| 17x11.5                                  | 40             | 1.4  | 50             | 2    | 45             | 1.75 | 70             | 2.75 | NA    |      | 75                   | 3    | 60                   | 2.36 | 115 | 4.5  | 85  | 3.35 | 110            | 4.3  | 85             | 3.35 |
| 20x12.5                                  | NA             |      | NA             |      | NA             |      | NA             |      | NA    |      | 85                   | 3.5  | NA                   |      | 125 | 5    | NA  |      | NA             |      | NA             |      |
| 22x14.5                                  | NA             |      | 65             | 2.56 | NA             |      | NA             |      | NA    |      | 100                  | 4.25 | 75                   | 3    | 145 | 5.5  | 110 | 4.3  | 150            | 6    | 110            | 4.34 |

**Note:** \* Guides for Low Temperature (LT) belts. For Metal Detectable (MD) belts use VLB-MD guides.

NA-Not Available.

All guides can be ordered in rolls of 30m length.

# Sidewalls

The art of fabrication

Volta offers a classic “wavy” style sidewall in two versions: Based sidewall which can be delivered as a stand alone for fabrication by customer and Baseless sidewall which comes welded on the base belt from the factory. In addition, there is a Flat version welded by HF to the base belt.

## Based Sidewalls

| Type                                  | SW-20 |       | SW-30 |       | SW-40 |       | SW-50 |        | SW-60 |        | SW-80 |        | SW-100 |        |
|---------------------------------------|-------|-------|-------|-------|-------|-------|-------|--------|-------|--------|-------|--------|--------|--------|
| mm/inch                               | mm    | inch  | mm    | inch  | mm    | inch  | mm    | inch   | mm    | inch   | mm    | inch   | mm     | inch   |
| Height                                | 20    | 13/16 | 30    | 1 1/4 | 40    | 1 1/2 | 50    | 2      | 60    | 2 3/8  | 80    | 3 1/4  | 100    | 4      |
| Base Width                            | 40    | 1 1/2 | 40    | 1 1/2 | 40    | 1 1/2 | 70    | 2 3/4  | 70    | 2 3/4  | 70    | 2 3/4  | 70     | 2 3/4  |
| Wave Width                            | 18    | 5/7   | 18    | 5/7   | 18    | 5/7   | 34    | 1 5/16 | 34    | 1 5/16 | 34    | 1 5/16 | 34     | 1 5/16 |
| Minimum Pulley Diameter (Normal Flex) |       |       |       |       |       |       |       |        |       |        |       |        |        |        |
| Belt Thickness                        | mm    | inch  | mm    | inch  | mm    | inch  | mm    | inch   | mm    | inch   | mm    | inch   | mm     | inch   |
| 2                                     | 95    | 3 3/4 | 95    | 3 3/4 | 100   | 4     | NR    |        | NR    |        | NR    |        | NR     |        |
| 2.5                                   | 100   | 4     | 100   | 4     | 110   | 4 3/8 | NR    |        | NR    |        | NR    |        | NR     |        |
| 3                                     | 105   | 4 1/8 | 105   | 4 1/8 | 115   | 4 1/2 | 125   | 5      | 130   | 5 1/8  | 150   | 6      | 200    | 8      |
| 3.2                                   | 105   | 4 1/8 | 105   | 4 1/8 | 115   | 4 1/2 | 125   | 5      | 130   | 5 1/8  | 150   | 6      | 200    | 8      |
| 4                                     | 110   | 4 3/8 | 110   | 4 3/8 | 130   | 5 1/8 | 130   | 5 1/8  | 135   | 5 3/8  | 150   | 6      | 200    | 8      |
| 5                                     | 120   | 4 3/4 | 120   | 4 3/4 | 135   | 5 3/8 | 130   | 5 1/8  | 140   | 5 1/2  | 150   | 6      | 200    | 8      |

**Note:** NR - Not Recommended. All sidewalls can be ordered in rolls of 100 meter lengths for your in-house use.

## Baseless Sidewalls

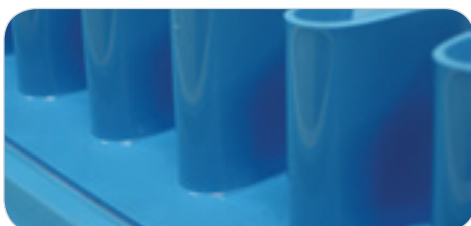
| Measurement                           | mm         | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch |  |
|---------------------------------------|------------|------|-----|------|-----|------|-----|------|-----|------|-----|------|-----|------|-----|------|--|
| Sidewall Height                       | 30         | 1¼   | 40  | 1½   | 50  | 2    | 60  | 2⅜   | 80  | 3⅛   | 100 | 4    | 130 | 5⅛   | 150 | 6    |  |
| Sidewall Thickness (mm)               | 1.6        |      | 1.6 |      | 1.6 |      | 1.6 |      | 1.6 |      | 1.6 |      | 2   |      | 2   |      |  |
| Wave Width                            | 48mm+/-2mm |      |     |      |     |      |     |      |     |      |     |      |     |      |     |      |  |
| Minimum Pulley Diameter (Normal Flex) |            |      |     |      |     |      |     |      |     |      |     |      |     |      |     |      |  |
| Belt Thickness                        | mm         | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch | mm  | inch |  |
| 2                                     | 80         | 3⅛   | 90  | 3¼   | 100 | 4    | 110 | 4¼   | NR  |      | NR  |      | NR  |      | NR  |      |  |
| 2.5                                   | 80         | 3⅛   | 90  | 3¼   | 100 | 4    | 110 | 4¼   | NR  |      | NR  |      | NR  |      | NR  |      |  |
| 3                                     | 80         | 3⅛   | 90  | 3¼   | 100 | 4    | 110 | 4¼   | 130 | 5⅛   | 160 | 6¼   | 210 | 8¼   | 250 | 10   |  |
| 4                                     | 80         | 3⅛   | 90  | 3¼   | 100 | 4    | 110 | 4¼   | 130 | 5⅛   | 160 | 6¼   | 210 | 8¼   | 250 | 10   |  |
| 5                                     | 100        | 4    | 100 | 4    | 110 | 4¼   | 120 | 4¾   | 150 | 6    | 180 | 7    | 230 | 9    | 280 | 11   |  |

**Note:** Minimum distance between sidewalls : 300mm/11.9" (center to center) Maximum distance between sidewalls : 2000mm/ 78.5" (center to center).  
For Reinforced belts add 10% to the table values. NR - Not Recommended

## Flat Sidewalls

| Material              | Volta MW, Beige or MB, Blue      | Volta LB, Blue                    |
|-----------------------|----------------------------------|-----------------------------------|
| Hardness              | 95A/46D                          | 80A                               |
| Sidewall Thickness    | 3; 4; 5mm                        | 5mm                               |
| Sidewall Height       | 40 - 100mm / 1 1/2" - 4"         | 40 - 100mm / 1 1/2" - 4"          |
| Add to Base Belt MPD* | 200mm / 8"                       | 175mm / 6 7/8"                    |
| Temp Range            | -5° C to 60° C / 23° F to 140° F | -10° C to 50° C / 15° F to 120° F |
| Certification         | FDA/USDA/EU                      |                                   |

**Note:** \* MPD (minimum pulley diameter) relates to flat sidewall applied with the HF technique. No back flex is possible.  
Flat Sidewall can be applied at a minimum distance of 5mm from the belt edges.



Based Sidewalls



Flat Sidewalls



Baseless Sidewalls

## Flights (Cleats)

Volta offers great flexibility and allows you to create the ideal flights to hold your product in place while moving along the production line. Flights increase the MPD of the base belts. Consult before selection.

### ➔ High Frequency (HF) Welded Flight:



#### Scoop

Act as a pocket to your produce on incline conveyors with the scoop section angled at 90° or 65°. Produced from 3mm to 8mm thick and max. 150mm high flat belt material. Scoops can be ordered individually for in-house use.



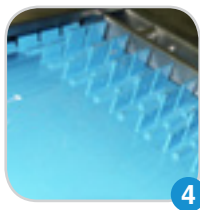
#### Gusset

Gussets are welded angles added to flights by HF or electrode welding to prevent flights from flexing under heavy loads. Gussets are made from thick material and their bases must be shaped to prevent pressure on the base belt in transition areas.



#### Angled

Welded at approx. 70° angle that suits your incline application. Produced from 3mm to 8mm thick and max. 150mm high flat belt material.



#### Spaced

Parallel rows of flights used to permit cutting of product and to allow for support on belt return.



#### Chevron Flights

'V' or round soft profile used to create flights in different patterns. Chevrons will routinely be made from V-profiles up to size 17mm and 10mm diameter for round.



#### Straight

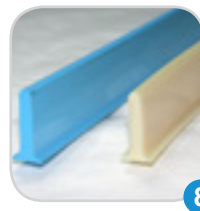
Flights produced from 3mm to 8mm thick and max. 150mm high flat belt material.

### ➔ Electrode Welded Flights

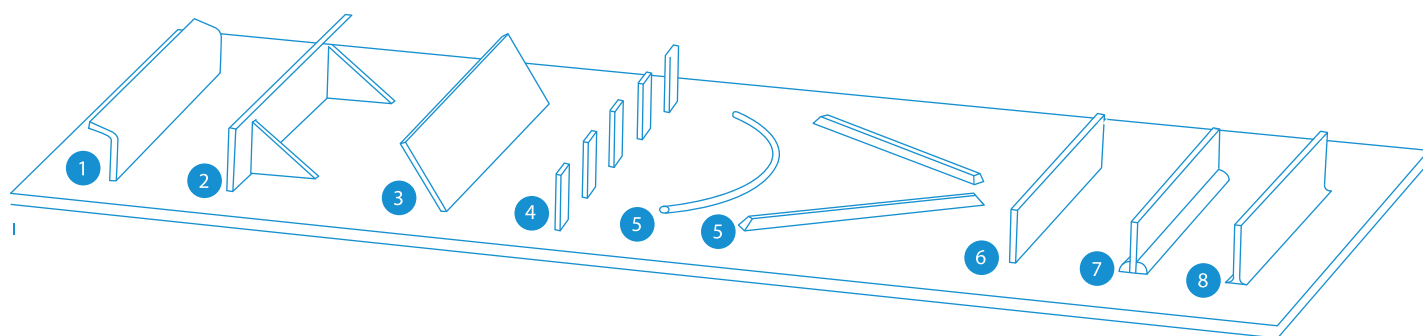


The original double or single electrode welded flights. Electrodes are available in 7mm and 9mm diameter and in various Shore hardness to match the base material being used.

### ➔ T-Cleats



Available for your in-house use. The T-shape foot is suited to hand welding with a Leister hot air gun and to correctly designed HF welding molds. Available in beige and blue at heights 25, 30, 40 and 50mm. T-cleats are 4mm thick and available in standard strips of 2.15 meters.



On request, all flights/cleats can be finished with rounded edges to avoid damaging delicate products on sharp corners.

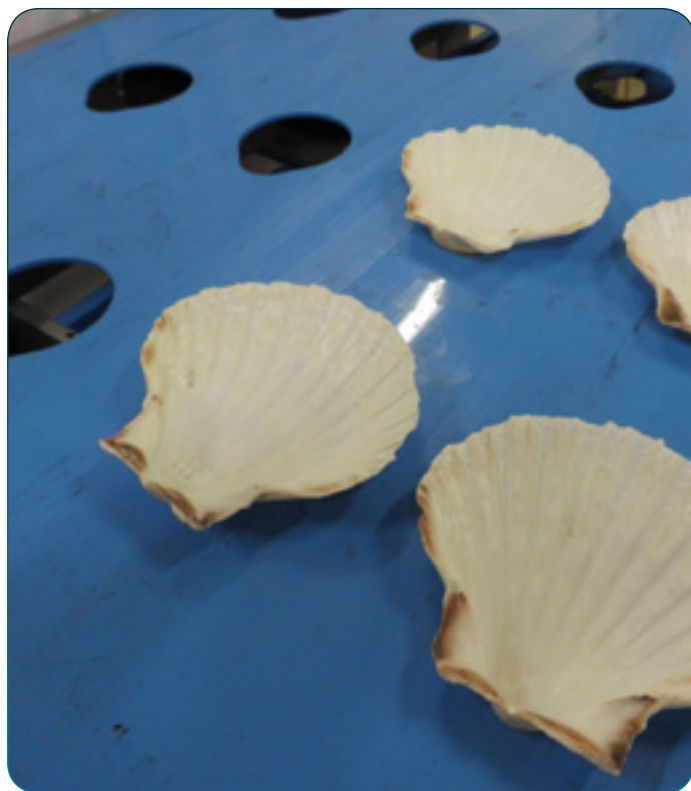
## ➔ Perforations

Volta is able to offer perforations in almost any pattern and with almost any shape of hole. Most perforations are simple round holes and Volta recommends to stagger alternate rows to avoid weak lines on the base belt.

For round holes, perforations must be Ø3.5mm or larger. Other shapes are subject to confirmation.

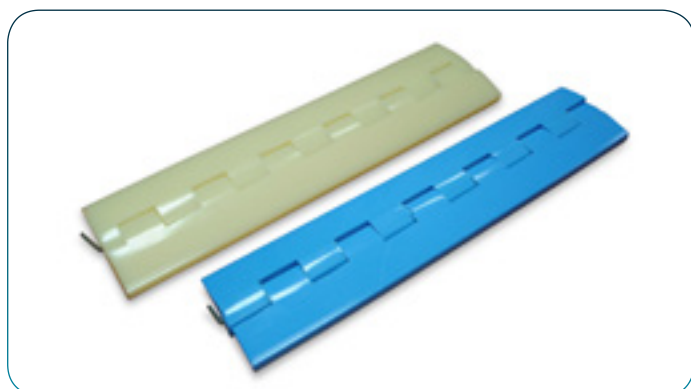
Hole size should be taken into account the product being conveyed and should be small enough to avoid product being trapped in the perforations.

Perforations should finish at a distance from the belt edges to maintain material strength and belt ends where the welding joint is located are also left free of perforations.



## ➔ Volta Lace Systems

The Volta Lace is a device that allows you to easily open and close the belt for cleaning or servicing of the conveyor. Our lace can also be used in applications where metal detectors are required and we can provide you with a polyester hinge pin upon request. Volta lace is compatible with Volta 'M' Family Flat Belts of 2.5 to 5 mm thickness. Specialized lace is available to suit the teeth spacing of the DD SP belts. All Volta flat belt material is easy to clean without removing from conveyor and therefore we only recommend lace when absolutely necessary.



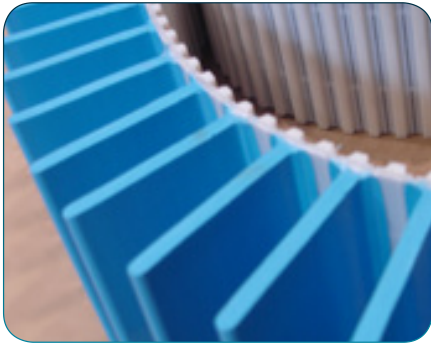
SD/DD Lace



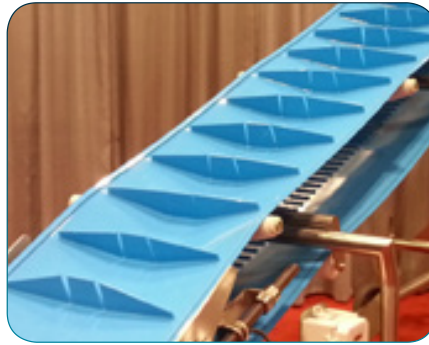
DD SP Lace

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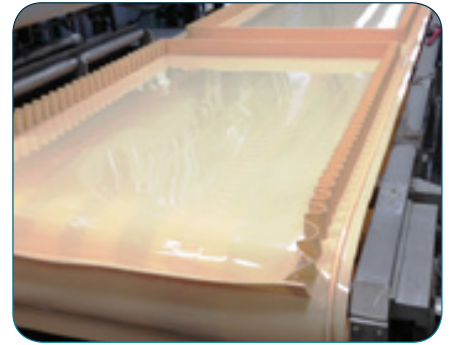
## Volta Fabrications – A Professional Solution



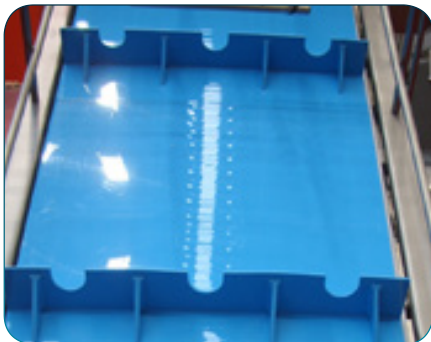
Timing belt with cleats



Special cleats on trough conveyor



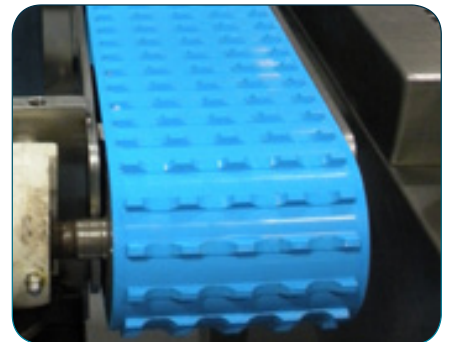
Organ meat compartments



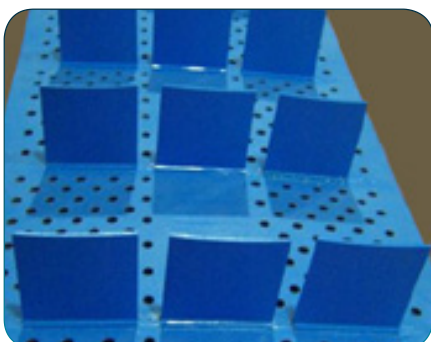
Gusset cleats



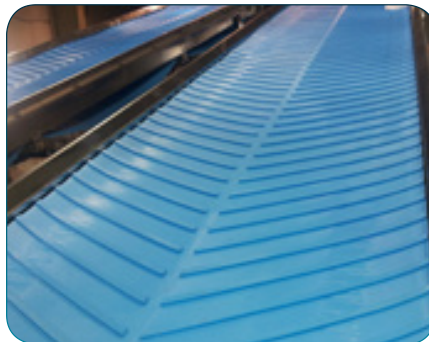
Baseless sidewalls



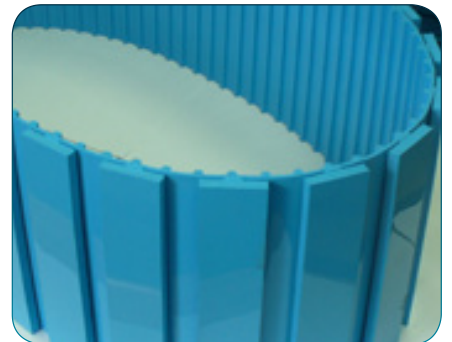
Surimi belt



Perforated SuperDrive™



Chevron cleats



Special fabrication on DDSP

**Roskilde**  
**Viborg**  
**Børkop**

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Vennershåbvej 4 • 8800 Viborg  
Industrivej 38 • 7080 Børkop