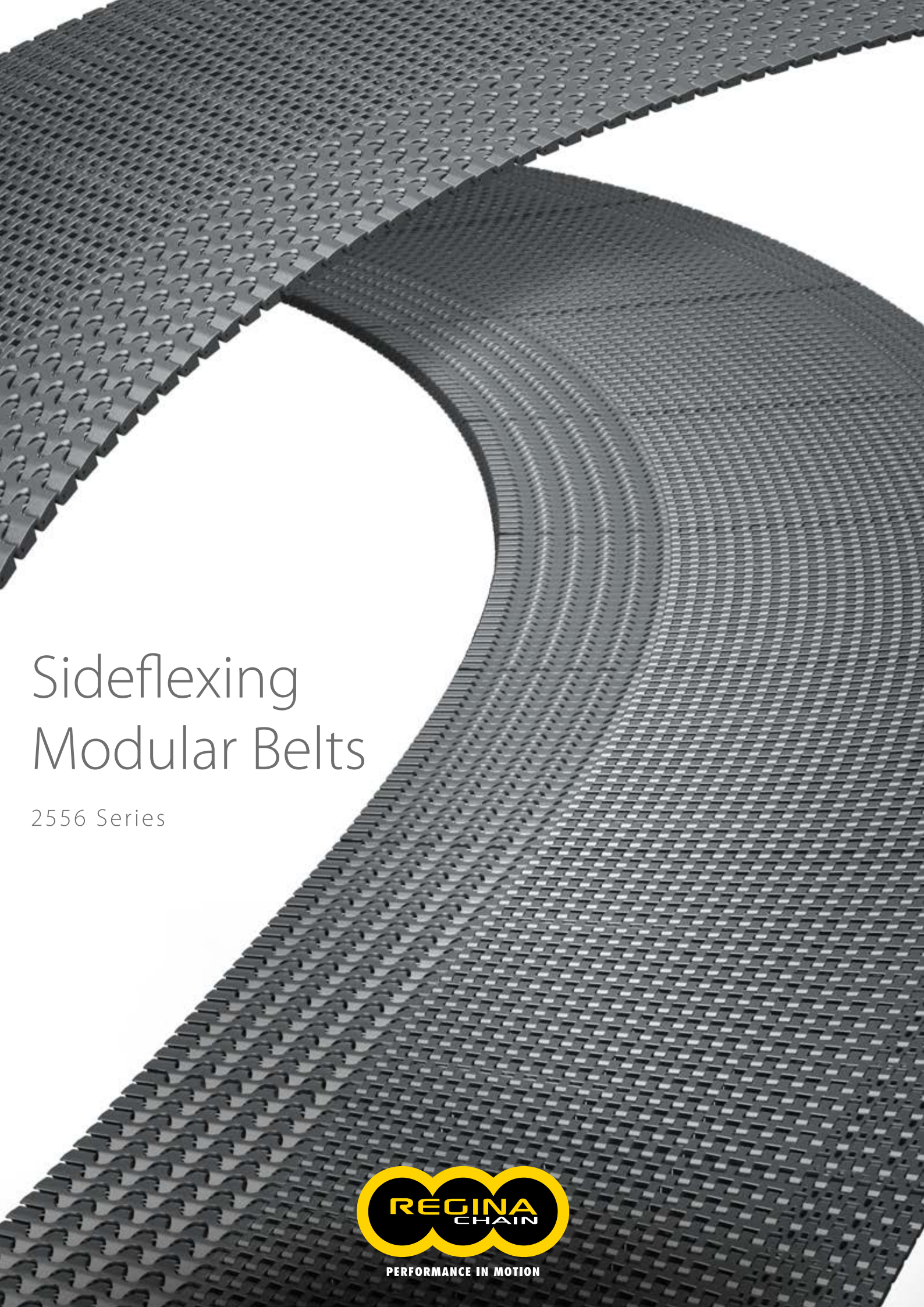




Sideflexing Modular Belts

2556 Series



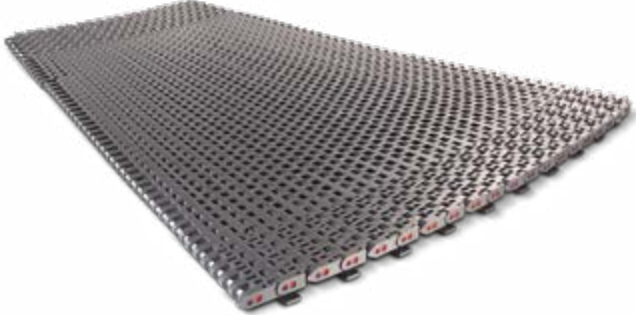
PERFORMANCE IN MOTION

Sideflexing belts 2556 Series

Regina 2556 sideflexing belts, including the 2556HTB and 2556HTB-SR Series, are an evolution of the 2555 sideflexing belts.

They are designed for the packaging industry's most demanding applications, requiring high speed and heavy loads around curves.

BELT FEATURES

 	
GUIDE SYSTEM	TAB + Stainless Steel Bearing (Waterproof)
PITCH	31,75 mm (1 ¼")
MODULE THICKNESS	12,7 mm (.50")
WIDTHS	from 255 mm to 850 mm in increments of 85 mm
RATIO BETWEEN INNER RADIUS & BELT WIDTH	Standard version (2556HTB): 1.8 Tight radius version (2556HTB-SR): 1.2
MODULE MATERIAL	 Ultra Performance POM
PIN MATERIAL	Wear resistant polyester (PBT)
PATH	Right - or left-handed curve in one direction only

FIELDS OF APPLICATION

INDUSTRIES:

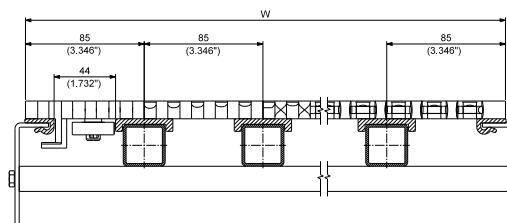
- BOTTLING AND CANNING
- FOOD FILLING
- PHARMACEUTICAL
- PAPER/CARDBOARD
- CONSUMER GOODS



Sideflexing belts 2556 Series

PECULIAR FEATURES

- Belt equipped with radial bearing
- Split guide system to prevent overturning and provide radial force resistance in sideflexing section
- Outer modules with reinforced hinges and larger cross-section
- Available in tight radius version (SR):
 - Reinforced design of the inner modules
 - Minimum ratio (1.2) between inner radius of the curve and belt width
- "Poka yoke" design of the outer hinges
- Guide system suitable for conveyors frame with 44 mm guide clearance



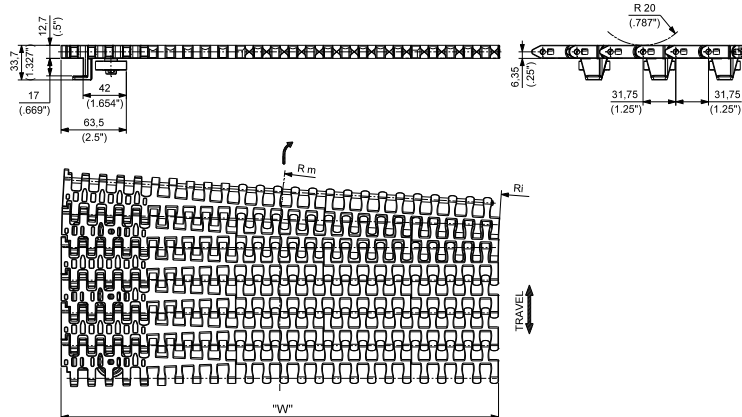
BENEFITS

- Drastic friction reduction in curve sections
- No curve overheating
 - Drastic wear and noise reduction
 - Smooth belt running
- No special material requirement for curve profile (UHMWPE standard)
 - Cost saving
- High conveying capability for the most demanding layouts:
 - 180° single curve
 - 2x90° curves
- Higher transversal and longitudinal stiffness
- More compact curves for reduced footprint layout
- Prevention of any assembling mistakes
- Wear strips standardization

Sideflexing belts 2556 Series

PRODUCTION RANGE

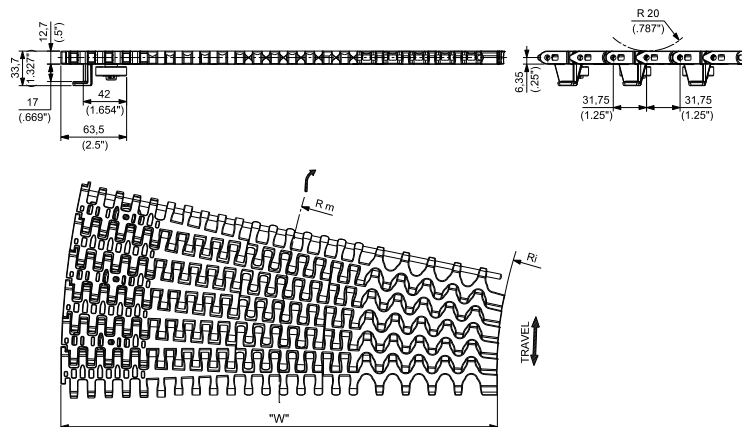
2556HTB Standard sideflexing radius



REGINA PART NUMBER	BELT WIDTH W		SIDEFLEXING RADIUS R				BELT WEIGHT		MATERIAL
	mm	inch	Inner Ri		Medium Rm		kg/m	lbs/ft	
2556HTB-UP0255	255	10.039	472,5	18.602	600	23.620	3,24	2.18	ULTRA PERFORMANCE ACETAL RESIN (UP)
2556HTB-UP0340	340	13.386	630,0	24.803	800	31.500	3,97	2.67	
2556HTB-UP0425	425	16.732	787,5	31.004	1000	39.370	4,70	3.16	
2556HTB-UP0510	510	20.079	945,0	37.205	1200	47.240	5,43	3.65	
2556HTB-UP0595	595	23.425	1102,5	43.406	1400	55.120	6,16	4.14	
2556HTB-UP0680	680	26.772	1260,0	49.606	1600	62.990	6,90	4.64	
2556HTB-UP0765	765	30.118	1417,5	55.807	1800	70.870	7,63	5.13	
2556HTB-UP0850	850	33.465	1575,0	62.008	2000	78.740	8,36	5.62	

Supplied in standard length of 1,524 m (5 feet)

2556HTB-SR Reduced sideflexing radius



REGINA PART NUMBER	BELT WIDTH W		SIDEFLEXING RADIUS R				BELT WEIGHT		MATERIAL
	mm	inch	Inner Ri		Medium Rm		kg/m	lbs/ft	
2556HTB-SRUP0340	340	13.386	330,0	12.992	500	31.500	3,91	2.63	ULTRA PERFORMANCE ACETAL RESIN (UP)
2556HTB-SRUP0425	425	16.732	387,5	15.256	600	39.370	4,70	3.16	
2556HTB-SRUP0510	510	20.079	545,0	21.457	800	47.240	5,43	3.65	
2556HTB-SRUP0595	595	23.425	702,5	27.657	1000	55.120	6,17	4.15	
2556HTB-SRUP0680	680	26.772	860,0	33.858	1200	62.990	6,90	4.64	
2556HTB-SRUP0765	765	30.118	1017,5	40.059	1400	70.870	7,63	5.13	
2556HTB-SRUP0850	850	33.465	1175,0	46.260	1600	78.740	8,36	5.62	

Supplied in standard length of 1,524 m (5 feet)

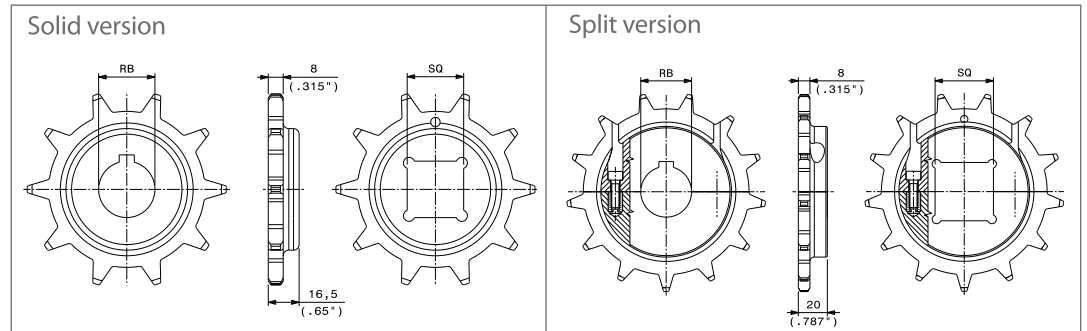
For technical assistance to evaluate your application, please contact Regina Application Engineering

Sprockets for sideflexing belts 2556 Series

SINGLE TOOTH SPROCKETS - PRODUCTION RANGE

Materials

- Machined cast polyamide (PA)
- Stainless steel screws, brass inserts (for split sprockets only)



Solid Drive and Idler Sprockets.

N. OF TEETH	PITCH DIAMETER		OUTSIDE DIAMETER		BORE SIZE		REGINA PART NUMBER			WEIGHT		MATERIAL
	mm	inch	mm	inch	mm	inch	SQUARE BORE SQ	ROUND BORE RB		kg	lbs	
8*	82,97	3.267	86,5	3.406	30			MPBAT25550830	MPBAF25550830	0,04	0.09	PA
					35			MPBAT25550835	MPBAF25550835	0,03	0.07	
					1			MPBAT255508254	MPBAF255508254	0,04	0.09	
					1 1/4			MPBAT255508317	MPBAF255508317	0,04	0.09	
10	102,75	4.045	106,5	4.193	30			MPBAT25551030	MPBAF25551030	0,08	0.18	PA
					35			MPBAT25551035	MPBAF25551035	0,07	0.15	
					40		MPBAQ25551040	MPBAT25551040	MPBAF25551040	0,06	0.13	
					1			MPBAT255510254	MPBAF255510254	0,08	0.18	
					1 1/4			MPBAT255510317	MPBAF255510317	0,07	0.15	
					1 1/2		MPBAQ255510381	MPBAT255510381	MPBAF255510381	0,07	0.15	

*For some shaft dimensions , the shaft needs to be properly machined down to avoid interference with the belt tabs. See page 9 for more details.

Split Drive and Idler Sprockets.

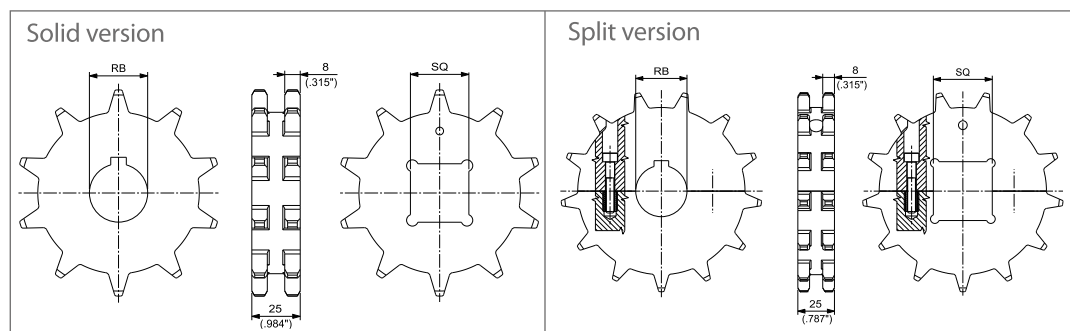
N. OF TEETH	PITCH DIAMETER		OUTSIDE DIAMETER		BORE SIZE		REGINA PART NUMBER			WEIGHT		MATERIAL
	mm	inch	mm	inch	mm	inch	SQUARE BORE SQ	ROUND BORE RB		kg	lbs	
13	132,67	5.223	137,5	5.413	30			MPBAST25551330	MPBASF25551330	0,19	0.42	PA
					35			MPBAST25551335	MPBASF25551335	0,18	0.40	
					40		MPBASQ25551340	MPBAST25551340	MPBASF25551340	0,17	0.37	
					1			MPBAST255513254	MPBASF255513254	0,20	0.44	
					1 1/4			MPBAST255513317	MPBASF255513317	0,19	0.42	
					1 1/2		MPBASQ255513381	MPBAST255513381	MPBASF255513381	0,19	0.42	
15	152,71	6.012	158,0	6.220	30			MPBAST25551530	MPBASF25551530	0,24	0.53	PA
					35			MPBAST25551535	MPBASF25551535	0,23	0.51	
					40		MPBASQ25551540	MPBAST25551540	MPBASF25551540	0,22	0.49	
					1			MPBAST255515254	MPBASF255515254	0,27	0.60	
					1 1/4			MPBAST255515317	MPBASF255515317	0,26	0.57	
					1 1/2		MPBASQ255515381	MPBAST255515381	MPBASF255515381	0,25	0.55	
16	162,75	6.407	168,0	6.614	30			MPBAST25551630	MPBASF25551630	0,27	0.60	PA
					35			MPBAST25551635	MPBASF25551635	0,26	0.57	
					40		MPBASQ25551640	MPBAST25551640	MPBASF25551640	0,25	0.55	
					1			MPBAST255516254	MPBASF255516254	0,29	0.64	
					1 1/4			MPBAST255516317	MPBASF255516317	0,28	0.62	
					1 1/2		MPBASQ255516381	MPBAST255516381	MPBASF255516381	0,27	0.60	

Sprockets for sideflexing belts 2556 Series

DOUBLE ROW SPROCKETS - PRODUCTION RANGE

Materials

- Machined cast polyamide (PA)
- Stainless steel screws, brass inserts (for split sprockets only)



Solid Drive and Idler Sprockets.

N. OF TEETH	PITCH DIAMETER		OUTSIDE DIAMETER		BORE SIZE		REGINA PART NUMBER			WEIGHT		MATERIAL
	mm	inch	mm	inch	mm	inch	SQUARE BORE SQ	ROUND BORE RB		kg	lbs	
8*	82,97	3.267	86,5	3.406	30			MPBAT255508D30	MPBAF255508D30	0,08	0.18	PA
					35			MPBAT255508D35	MPBAF255508D35	0,07	0.15	
						1		MPBAT255508D254	MPBAF255508D254	0,08	0.18	
						1 1/4		MPBAT255508D317	MPBAF255508D317	0,08	0.18	
10	102,75	4.045	106,5	4.193	30			MPBAT255510D30	MPBAF255510D30	0,15	0.33	PA
					35			MPBAT255510D35	MPBAF255510D35	0,14	0.31	
					40		MPBAQ255510D40	MPBAT255510D40	MPBAF255510D40	0,13	0.29	
						1		MPBAT255510D254	MPBAF255510D254	0,16	0.35	
						1 1/4		MPBAT255510D317	MPBAF255510D317	0,15	0.33	
						1 1/2	MPBAQ255510D381	MPBAT255510D381	MPBAF255510D381	0,14	0.31	

*For some shaft dimensions , the shaft needs to be properly machined down to avoid interference with the belt tabs. See page 9 for more details.

Split Drive and Idler Sprockets.

N. OF TEETH	PITCH DIAMETER		OUTSIDE DIAMETER		BORE SIZE		REGINA PART NUMBER			WEIGHT		MATERIAL
	mm	inch	mm	inch	mm	inch	SQUARE BORE SQ	ROUND BORE RB		kg	lbs	
13	132,67	5.223	137,5	5.413	30			MPBAST255513D30	MPBASF255513D30	0,30	0.66	PA
					35			MPBAST255513D35	MPBASF255513D35	0,29	0.64	
					40		MPBASQ255513D40	MPBAST255513D40	MPBASF255513D40	0,28	0.62	
						1		MPBAST255513D254	MPBASF255513D254	0,30	0.66	
						1 1/4		MPBAST255513D317	MPBASF255513D317	0,30	0.66	
						1 1/2	MPBASQ255513D381	MPBAST255513D381	MPBASF255513D381	0,29	0.64	
15	152,71	6.012	158,0	6.220	30			MPBAST255515D30	MPBASF255515D30	0,41	0.90	PA
					35			MPBAST255515D35	MPBASF255515D35	0,41	0.90	
					40		MPBASQ255515D40	MPBAST255515D40	MPBASF255515D40	0,40	0.88	
						1		MPBAST255515D254	MPBASF255515D254	0,42	0.93	
						1 1/4		MPBAST255515D317	MPBASF255515D317	0,41	0.90	
						1 1/2	MPBASQ255515D381	MPBAST255515D381	MPBASF255515D381	0,40	0.88	
16	162,75	6.407	168,0	6.614	30			MPBAST255516D30	MPBASF255516D30	0,48	1.06	PA
					35			MPBAST255516D35	MPBASF255516D35	0,47	1.04	
					40		MPBASQ255516D40	MPBAST255516D40	MPBASF255516D40	0,46	1.01	
						1		MPBAST255516D254	MPBASF255516D254	0,48	1.06	
						1 1/4		MPBAST255516D317	MPBASF255516D317	0,48	1.06	
						1 1/2	MPBASQ255516D381	MPBAST255516D381	MPBASF255516D381	0,47	1.04	

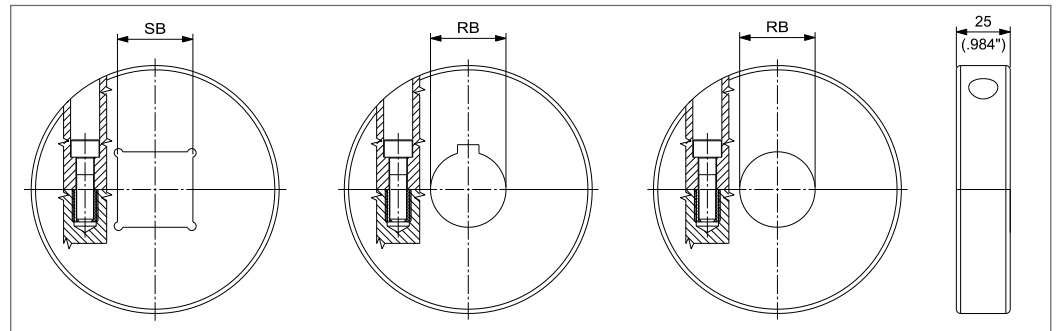
Supporting wheel for sideflexing belts 2556 Series

The 2556HTB-SR Series with reduced sideflexing radius requires a wheel supporting the inner side of the belt. The supporting wheel diameter and relative part numbers must be selected according to the sprockets number of teeth.

PRODUCTION RANGE

Materials

- Machined cast polyamide (PA)
- Stainless steel screws, brass inserts



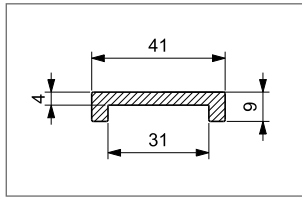
Split supporting wheels.

N. OF TEETH	OUTSIDE DIAMETER		BORE SIZE		REGINA PART NUMBER			WEIGHT		MATERIAL
	mm	inch	mm	inch	SQUARE BORE SQ	ROUND BORE RB		kg	lbs	
8	63	2.480	30			DRIVE	IDLER	0,10	0.23	PA
			35			CC255002	CC255030	0,10	0.21	
				1		CC255003	CC255031	0,11	0.24	
				1 1/4		CC255004	CC255032	0,10	0.22	
10	84	3.307	30			CC255005	CC255033	0,17	0.38	PA
			35			CC255006	CC255034	0,16	0.36	
			40		CC255057	CC255007	CC255035	0,16	0.34	
				1		CC255008	CC255036	0,18	0.39	
				1 1/4		CC255009	CC255037	0,17	0.37	
				1 1/2	CC255058	CC255010	CC255038	0,16	0.35	
13	115	4.528	30			CC255011	CC255039	0,31	0.68	PA
			35			CC255012	CC255040	0,30	0.67	
			40		CC255059	CC255013	CC255041	0,29	0.65	
				1		CC255014	CC255042	0,32	0.69	
				1 1/4		CC255015	CC255043	0,31	0.68	
				1 1/2	CC255060	CC255016	CC255044	0,30	0.66	
15	135	5.315	30			CC255017	CC255045	0,42	0.93	PA
			35			CC255018	CC255046	0,41	0.91	
			40		CC255061	CC255019	CC255047	0,41	0.89	
				1		CC255020	CC255048	0,43	0.94	
				1 1/4		CC255021	CC255049	0,42	0.92	
				1 1/2	CC255062	CC255022	CC255050	0,41	0.90	
16	145	5.709	30			CC255023	CC255051	0,48	1.07	PA
			35			CC255024	CC255052	0,48	1.05	
			40		CC255063	CC255025	CC255053	0,47	1.03	
				1		CC255026	CC255054	0,49	1.08	
				1 1/4		CC255027	CC255055	0,48	1.06	
				1 1/2	CC255064	CC255028	CC255056	0,47	1.04	

Straight upper and return wear strips

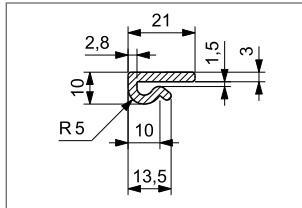
Regina recommends using the following profiles and rollers.

Upper central support: U-profile.



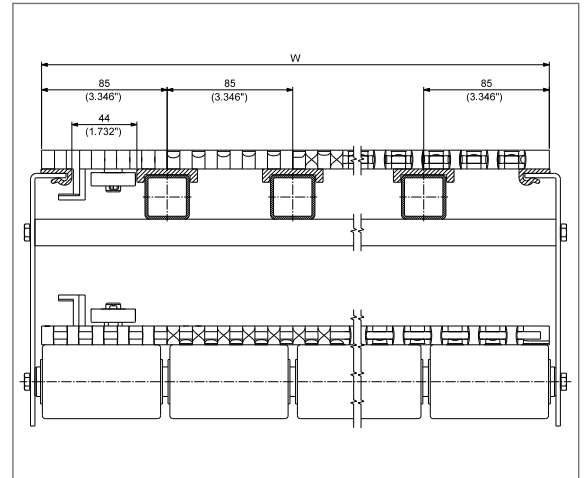
REGINA PART NUMBER	COLOR	SUPPLY CONDITIONS	MATERIAL
WS006GS	GREEN	3 MT BARS	UHMWPE
WS006GL		6 MT BARS	

Upper lateral support.

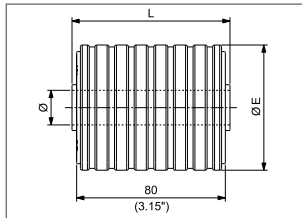


REGINA PART NUMBER	COLOR	SUPPLY CONDITIONS	MATERIAL
WS008GC	GREEN	60 MT COILS	UHMWPE

Application



Rubberized return roller.



EXTERNAL DIAMETER Ø E		LENGHT L		REGINA PART NUMBER FOR SHAFT DIAMETER Ø			
mm	inch	mm	inch	16 mm	18 mm	3/4"	20 mm
45	1.772	82,5	3.248	CC000078	CC000084	CC000090	CC000096
		84,5	3.327	CC000079	CC000085	CC000091	CC000097
57	2.244	82,5	3.248	CC000080	CC000086	CC000092	CC000098
		84,5	3.327	CC000081	CC000087	CC000093	CC000099
67	2.638	82,5	3.248	CC000082	CC000088	CC000094	CC000100
		84,5	3.327	CC000083	CC000089	CC000095	CC000101

Packaging: 50 pieces

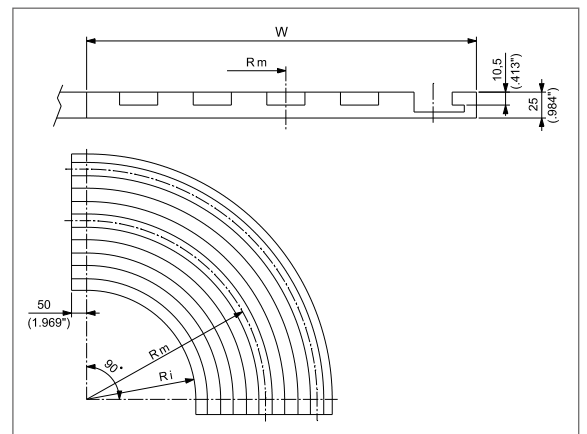
Corner track

Regina supplies 90° machined curves made of UHMWPE.

Part numbers and dimensions are shown below.

Each part number includes the upper part only.

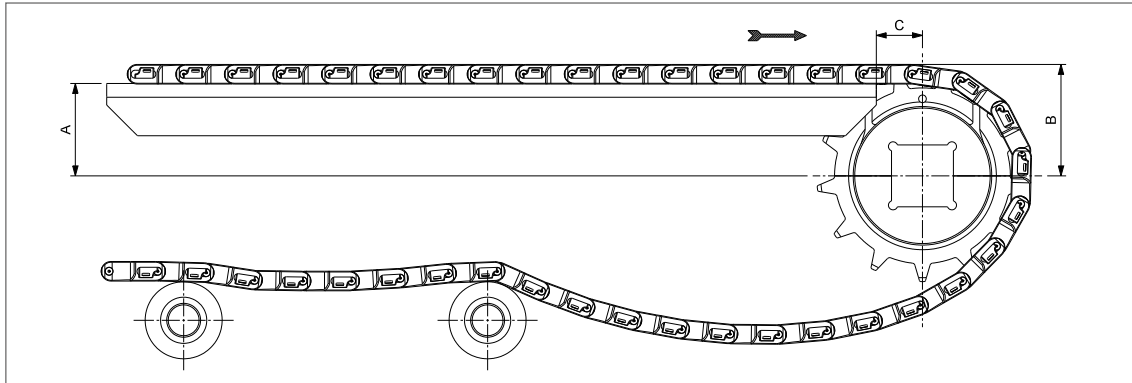
These curves may also be used for the return section.



BELT WIDTH		CURVE WIDTH W		CURVES FOR 2556HTB BELT SERIES					CURVES FOR 2556HTB-SR BELT SERIES				
				INNER RADIUS Ri		MEDIUM RADIUS Rm		REGINA PART NUMBER	INNER RADIUS Ri		MEDIUM RADIUS Rm		REGINA PART NUMBER
mm	inch	mm	inch	mm	inch	mm	inch		mm	inch	mm	inch	
255	10.039	281	11.063	459,5	18.091	600	23.622	T55HK0281/B10	-	-	-	-	-
340	13.386	366	14.409	617,0	24.291	800	31.496	T55HK0366/C10	317,0	12.480	500	19.685	T55HK0366/A10
425	16.732	451	17.756	774,5	30.492	1000	39.370	T55HK0451/D10	374,5	14.744	600	23.622	T55HK0451/B10
510	20.079	536	21.102	932,0	36.693	1200	47.244	T55HK0536/E10	532,0	20.945	800	31.496	T55HK0536/C10
595	23.425	621	24.449	1089,5	42.894	1400	55.118	T55HK0621/F10	689,5	27.146	1000	39.370	T55HK0621/D10
680	26.772	706	27.795	1247,0	49.094	1600	62.992	T55HK0706/G10	847,0	33.346	1200	47.244	T55HK0706/E10
765	30.118	791	31.142	1404,5	55.295	1800	70.866	T55HK0791/H10	1004,5	39.547	1400	55.118	T55HK0791/F10
850	33.465	876	34.488	1562,0	61.496	2000	78.740	T55HK0876/J10	1162,0	45.748	1600	62.992	T55HK0876/G10

Sprockets installation

Sprockets / wearstrips positioning.



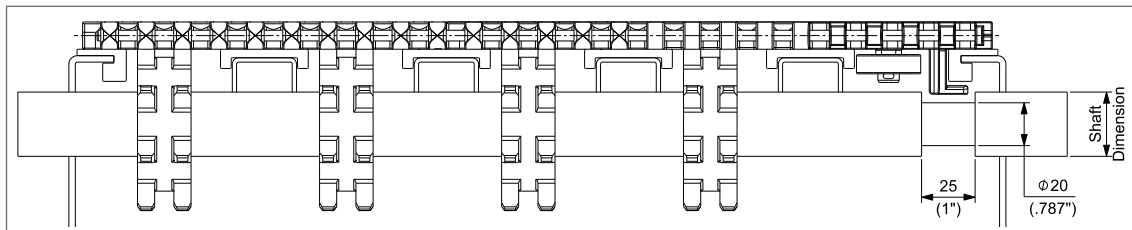
N. OF TEETH	PITCH DIAMETER		A		B		C	
	mm	inch	mm	inch	mm	inch	mm	inch
8	82,97	3.27	35,1	1.38	47,8	1.88	30 min	1.18 min
10	102,75	4.05	45,0	1.77	57,7	2.27		
13	132,67	5.22	60,0	2.36	72,7	2.86		
15	152,71	6.01	70,0	2.76	82,7	3.26		
16	162,75	6.41	75,0	2.95	87,7	3.45		

When using 8T sprockets with the following shaft dimensions:

- Square bore: ≥ 20 mm
- Round bore: $> 1"$

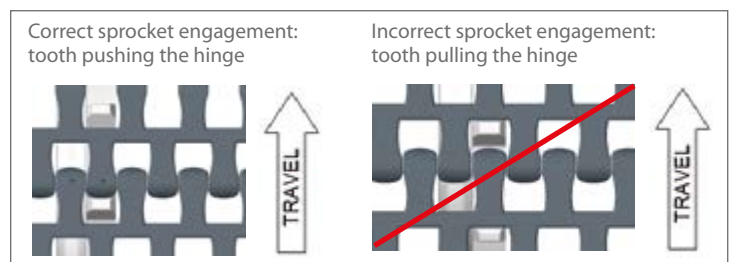
the shaft needs to be properly machined down to avoid interference with the belt tabs.

The drawing below shows the correct throat diameter and width to avoid any interference.



Sprockets axial positioning.

When installing the sprockets, make sure that the tooth is pushing, not pulling.



Charts showing the correct sprockets axial positioning for 850 mm (33.465") wide belts are reported in the next two pages. For narrower widths, please always keep the same positioning of sprockets at the belt's sides (circled in red), and decrease the number of sprockets in the middle. The table on the right shows the number of sprockets recommended per belt width.

BELT WIDTH		NUMBER OF SPROCKETS			
		2556HTB		2556HTB-SR	
mm	inch	drive	idler	drive	idler
255	10.039	2	2	-	-
340	13.386	3	3	2	2
425	16.732	4	4	3	3
510	20.079	5	5	4	4
595	23.425	6	6	5	5
680	26.772	7	7	6	6
765	30.118	8	8	7	7
850	33.465	9	9	8	8

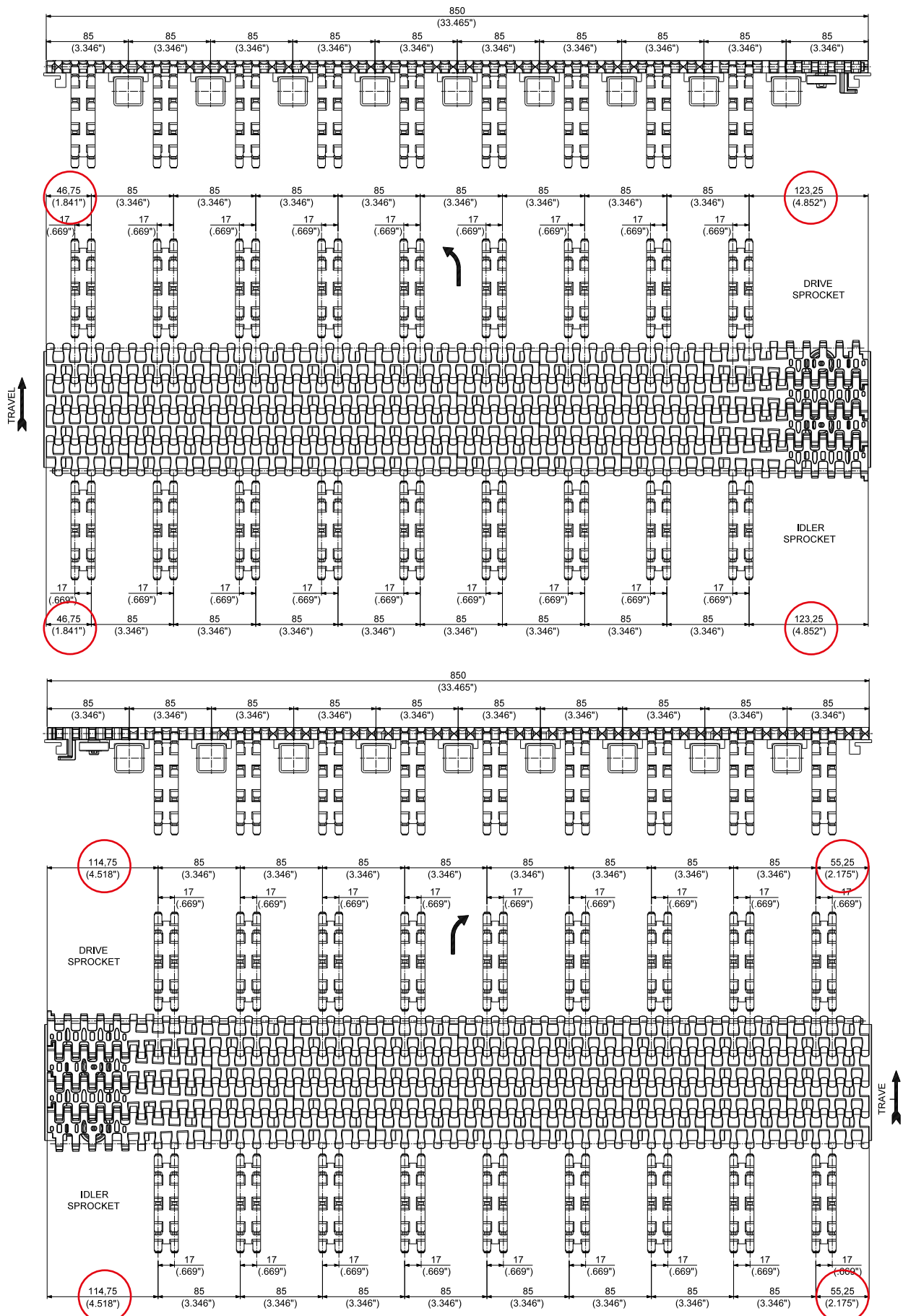
The 2556HTB-SR Series requires the wheel supporting the inner side of the belt.

The supporting wheel has to be considered in addition to the number of sprockets listed above.

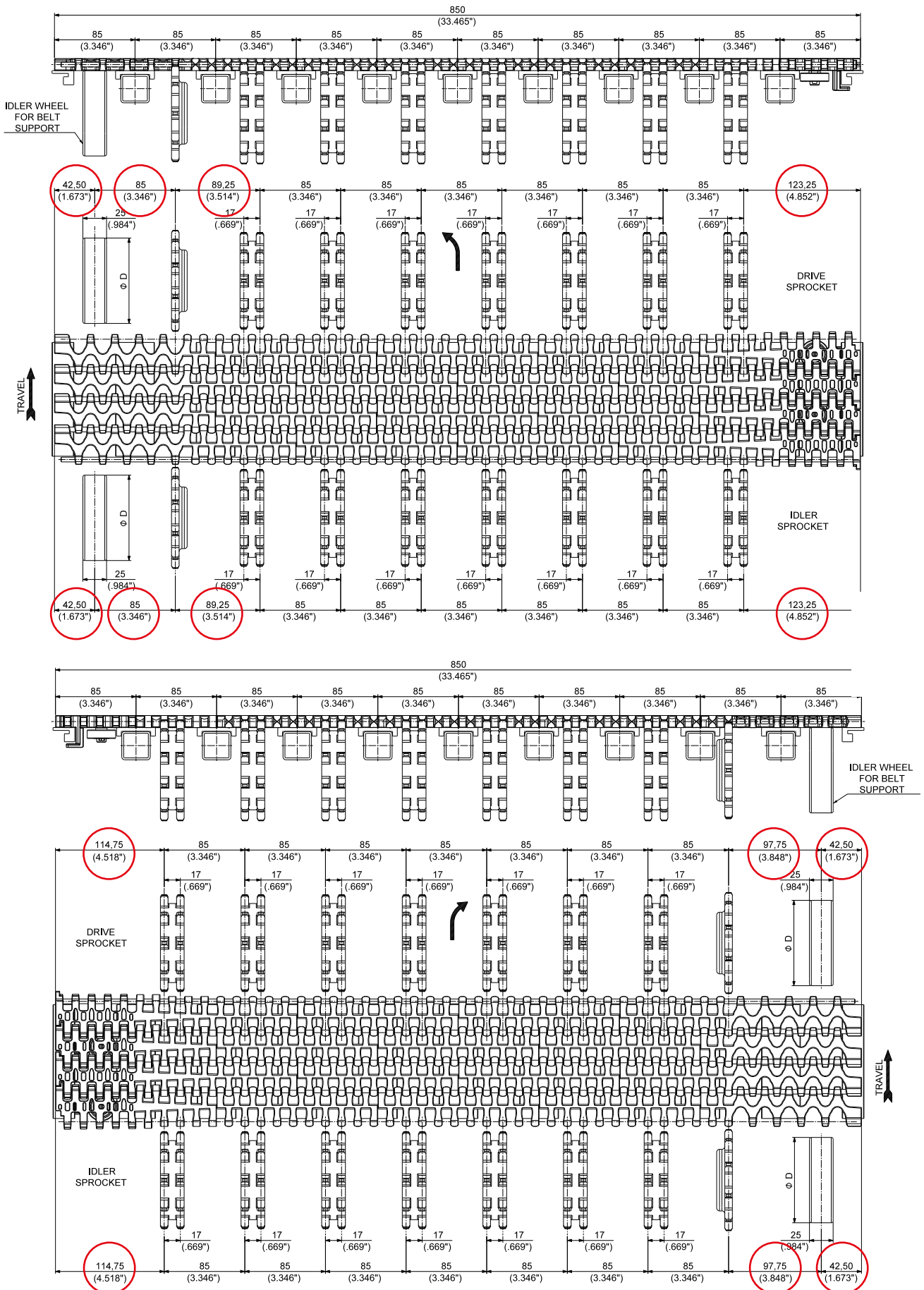
Sprockets installation

2556HTB

Standard sideflexing radius

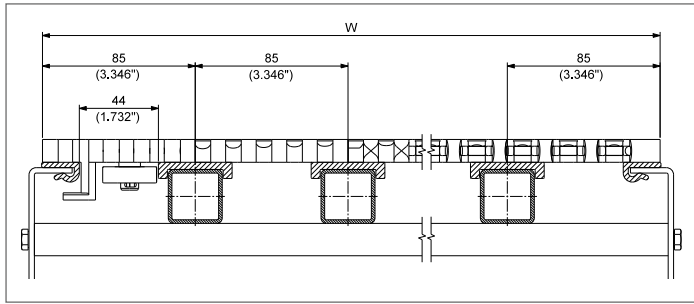


2556HTB-SR
Reduced sideflexing radius

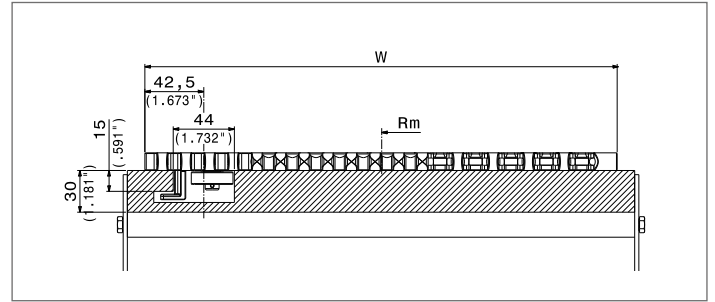


Carry section wear strips

Straight section configuration.



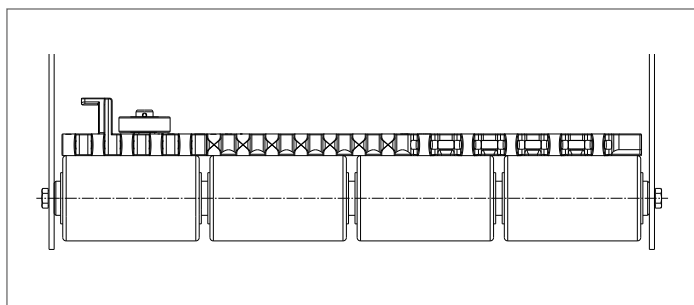
Corner section configuration.



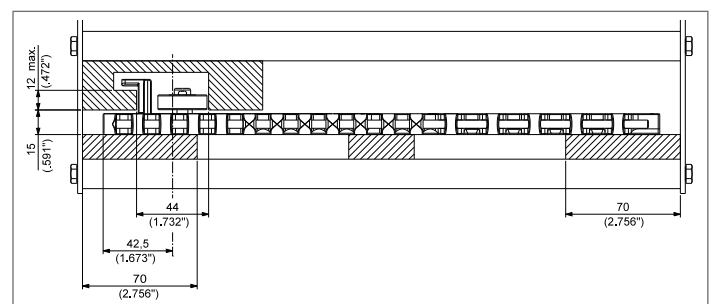
- Use conveyor frames with 44 mm (1.732") guide clearance.
- Use standard chain guide wear strips with 40 mm (1.575") width and 85 mm (3.346") spacing for straight sections.
- All sharp edges of wearstrips, including corner tracks, should be rounded to ensure smooth chain movement.
- Inside edges of straight and corner sections should contain a lead-in or chamfer for a smooth transition.
- The wearstrips under the belt must be levelled and even with each other.
- UHMWPE tracks are recommended.

Return section wearstrips

Straight section configuration.



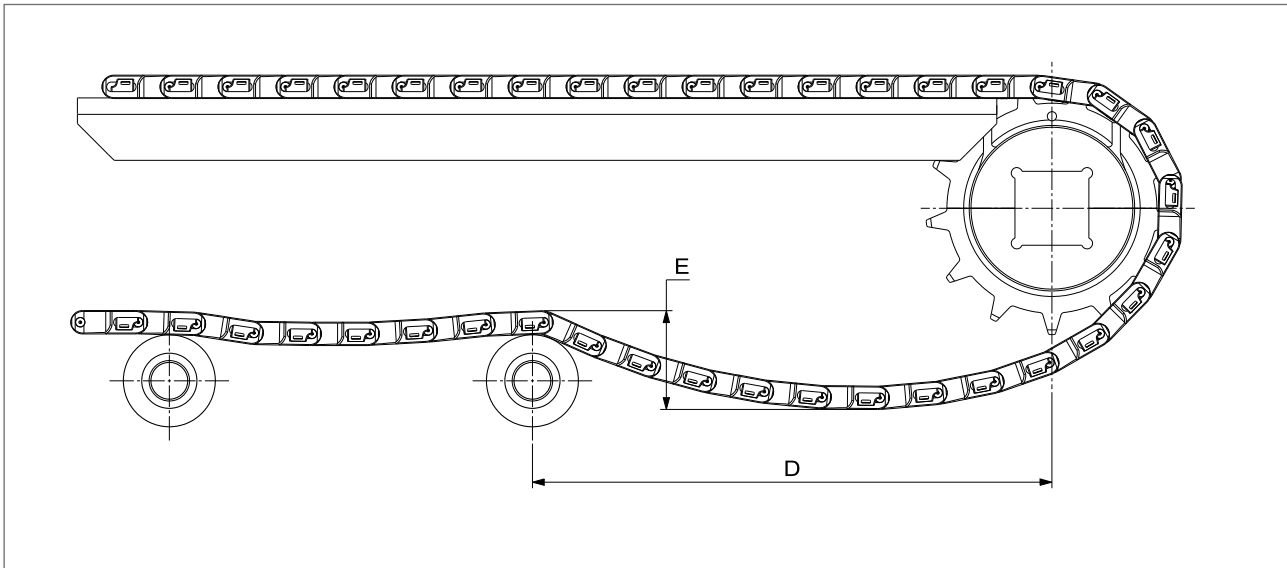
Corner section configuration.



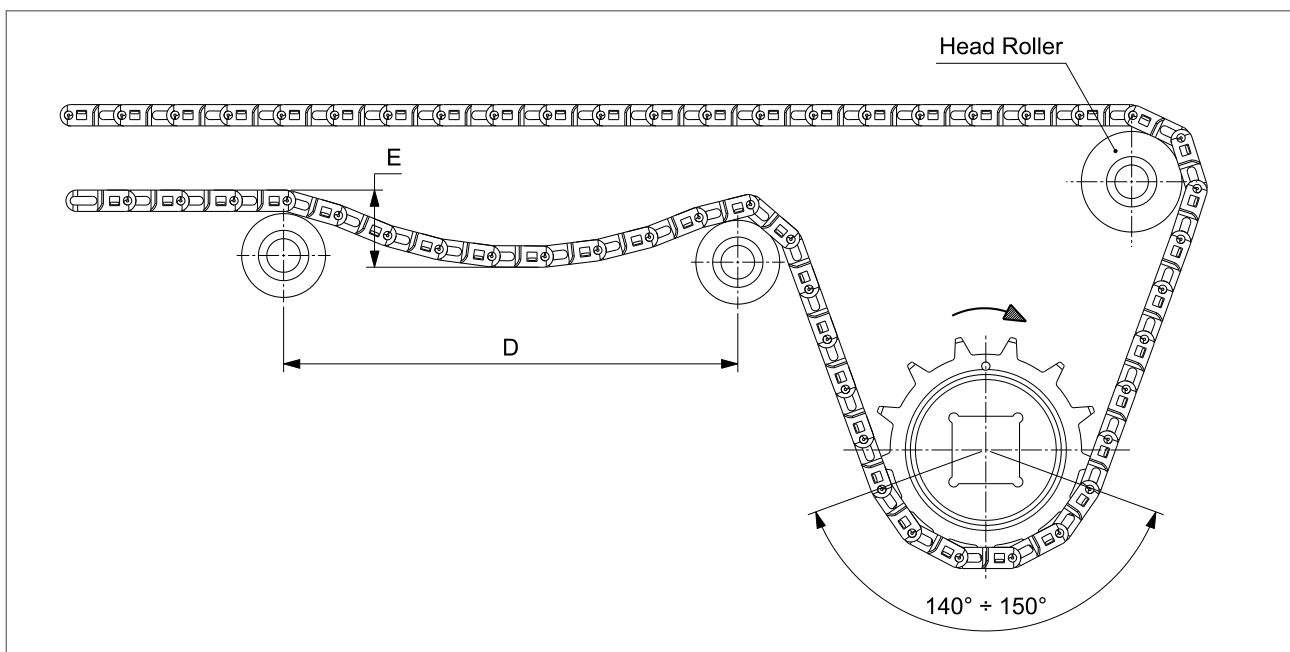
- Straight section: rubberized rollers with minimum diameter of 40 mm (1.575") are recommended to maximize chain's life.
- Corner tracks:
 - The bearing must always be guided
 - The minimum recommended width for side belt supports is 70 mm (2.756")
 - A center support is recommended for belts wider than 595 mm (23.425")
 - UHMWPE is recommended as material for guides and supports
- Serpentine are also suitable to provide uniform wear across the full width of the belt, maximizing chain life.
- All sharp edges of return tracks should be rounded, to ensure smooth chain movement.
- Inside edges of straight and corner sections should contain a lead-in or chamfer for a smooth transition.

Catenary sag

End drive configuration.



Tight transfer drive configuration.



- An horizontal span D of 600 mm (24") and a vertical sag E of 75 ÷ 125 mm (3" ÷ 5") are recommended.
- Generally, tensioners are NOT recommended. For a tight transfer drive configuration, in case of horizontal spans less than 600 mm (24"), a take-up installed on the catenary sag is advisable to reduce pulsations.
- The recommended head roller minimum diameter (tight transfer drive only) is 70 mm (2.756").
- Use return roller with a minimum diameter of 40 mm (1.575") to minimize back-flexing. The joint wear decreases and chain life increases.
- The recommended drive wrap angle is $140^\circ - 150^\circ$, to guarantee the correct sprockets engagement.

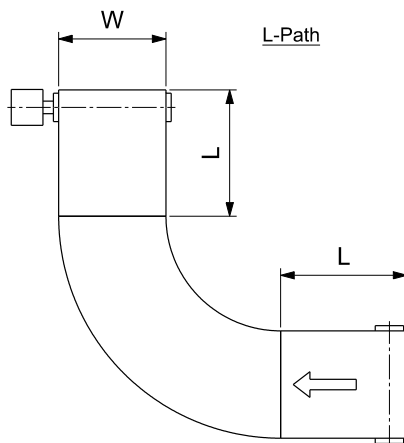
Layout guidelines and belt conveying capability

For each type of layout, minimum recommended straight sections L between:

- last curve and the drive shaft
- first curve and the idler shaft
- two consecutive curves

need to be: $L \geq W \times 1,4$. This is for the correct distribution of the belt pull over the entire belt width ensuring correct engagement with the sprockets.

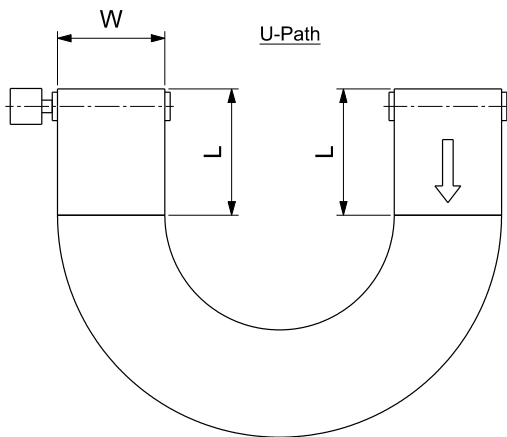
L-PATH



APPLICATION EXAMPLE 1

- Belt width W: 850 mm
- Straight section L: 1200 mm
- Curve radius: 1600 mm
- Speed: 30 m/min
- Load: N°32 shrink packs 3x2 1.5L PET in double track
- Total weight on the conveyor: 290 kg

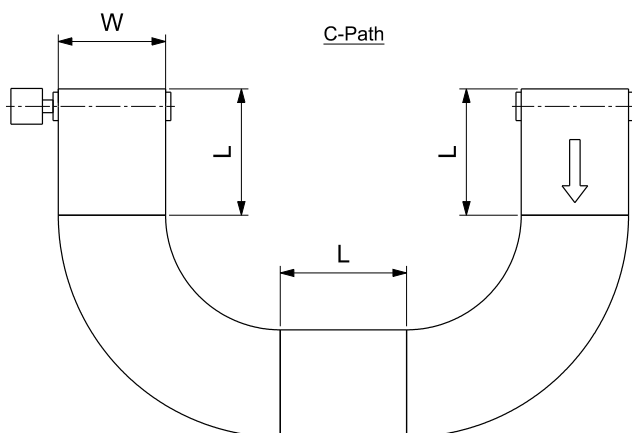
U-PATH



APPLICATION EXAMPLE 2

- Belt width W: 850 mm
- Straight section L: 1200 mm
- Curve radius: 1600 mm
- Speed: 30 m/min
- Load: N°45 shrink packs 3x2 1.5L PET in double track
- Total weight on the conveyor: 400 kg

C-PATH



APPLICATION EXAMPLE 3

- Belt width W: 850 mm
- Straight section L: 1200 mm
- Curve radius: 1600 mm
- Speed: 30 m/min
- Load: N°55 shrink packs 3x2 1L PET on double track
- Total weight on the conveyor: 330 kg
- N°1 drive only to link two curves

Belt assembly / disassembly

STEP 1

Bring one belt section close to the other



STEP 2

To remove the clip, insert a screwdriver into the clip and lift it



STEP 3

If the clip comes out from the belt pocket, put the clip back in the right position



STEP 4

In order to link the two sections, push the pin in until it touches the opposite side of the belt



STEP 5

Push the clip into the belt pocket by hand



STEP 6

Check that the belt can correctly collapse without interference



STEP 7

To disassemble the belt:



2556HTB version: repeat STEP 2 on both belt sides and push the plastic pin out of the belt by screwdriver

2556HTB-SR version: repeat STEP 2 and, from the opposite side of the belt, push the plastic pin out with a drift punch, or similar tool



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