

WE KEEP IT MOVING®

Engineering & Dimensions

**UNIT HANDLING,
WAREHOUSING,
DISTRIBUTION, BAGGAGE**

PULLEYS & ROLLERS



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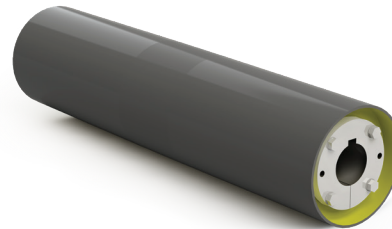
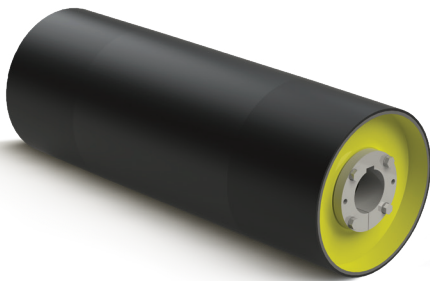
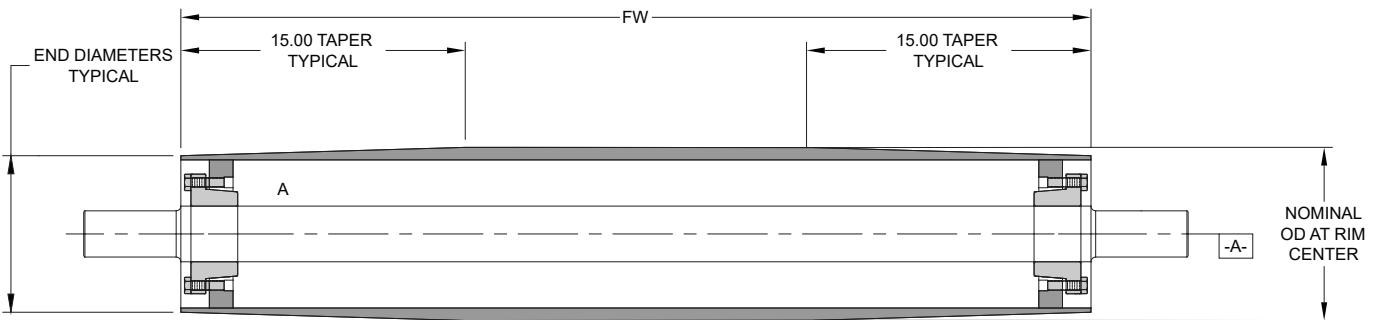
SPECIALTY PRODUCTS

- 12** HUSH ROLL
- 13** DEAD-END ROLLERS
- 14** WEIGHTED TAKE-UP PULLEYS
- 15** CUSTOM PRODUCTS

STANDARD PARCEL PULLEYS

STANDARD PARCEL PULLEY FEATURES

- Meets FedEx® and UPS® pulley standards
- Ends will be painted safety yellow
- Pulley static balance will be guaranteed to ISO 1940/1 - G100
- Pulleys are machined to full cleanup for 0.020" TIR or better
- Diameter tolerance for shaft journals is +0.000/-0.002"
- Pulleys face width 30" and below shall be full crown



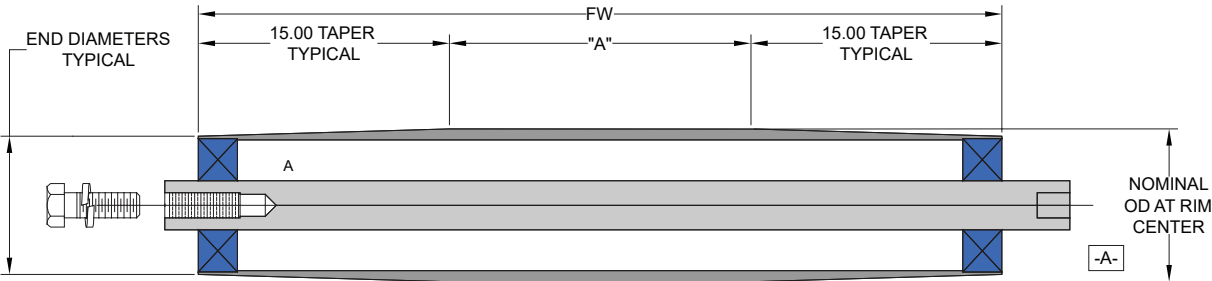
DRIVE PULLEYS	
LAGGED	
DIAMETER	PARCEL CROSSOVER
6 5/8"	PUL-20L
8 5/8"	PUL-23
12"	PUL-12
16"	PUL-06
NON-LAGGED	
DIAMETER	PARCEL CROSSOVER
6 5/8"	PUL-20
8 5/8"	PUL-25

NON-DRIVE PULLEYS	
DIAMETER	PARCEL CROSSOVER
6"	PUL-36 (Stub Shafts)
8 5/8"	PUL-24 (2 7/16" Shaft)
8 5/8"	PUL-08 (2 15/16" Shaft)
SOLID SHAFTS	
DIAMETER	PARCEL CROSSOVER
3 1/2"	PUL-22
4"	PUL-27
4 1/2"	PUL-28 (1 15/16" Turndowns)
4 1/2"	PUL-21 (2 7/16" Turndowns)

STANDARD PARCEL ROLLERS

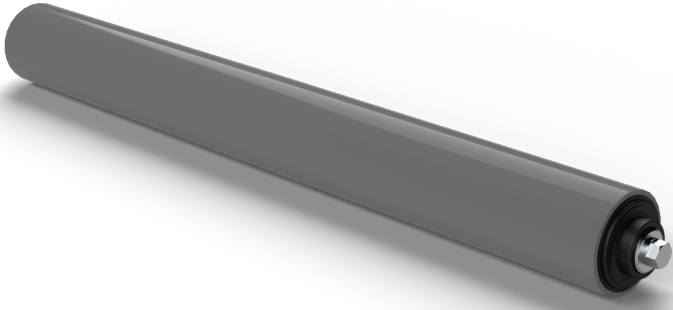
STANDARD ROLLER FEATURES

- Rollers are machined to full cleanup for 0.030" TIR or better
- 15" Standard taper length
 - Face widths 30" and under will have a full crown
- Drill & Tap, grooves, and flat spots available. Please see page 16



STANDARD PARCEL ROLLERS

PARCEL CROSSOVER	DIAMETER	BELT WIDTHS
ROL-01	2.125"	18" to 60"
ROL-02	2.75"	
ROL-04	3.50"	
ROL-06	2.125"	
ROL-07	4.50"	
ROL-07S	4"	
ROL-07SX	4"	

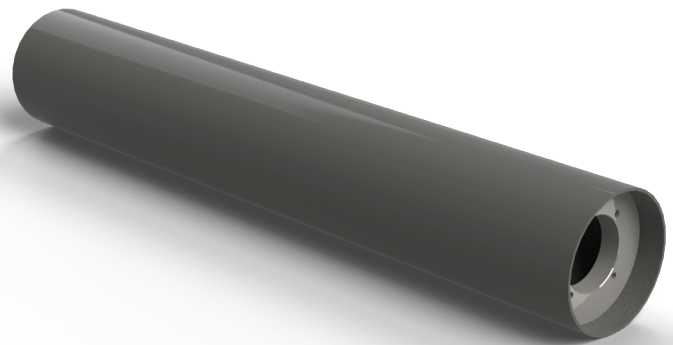


GAUGE WALL PULLEYS

PPI® also offers a gauge wall pulley line that is ideally suited to most standard and medium duty applications. Rims are constructed of gauge wall tubing from 14 gauge (.083") to 7 gauge (.180").

Crowned profiles are created by forming the metal rather than machining. This forming process provides maximum strength from the tubing since material thickness is not decreased by machining the crowned profile.

In addition to the great strength provided by the formed crown process, it is also an efficient and economical method for manufacturing pulleys. The result is a dependable pulley that provides outstanding value.



FEATURES AND BENEFITS:

- Diameters 2" to 12"
- Rims are not machined due to material thickness
- Available in crowned or flat faced
- Variety of hub styles available
- Low TIR product options for precision applications

STANDARD ROLLER BEARINGS

PPI has a large selection of deep groove ball bearings for your unit handling roller needs. Our 6300 series deep groove ball bearing line provides premium load carrying ability compared to a typical ER ball bearing, while our spherical roller bearing offerings are ideal for those extra heavy duty applications.



DIAMETER	BEARING	BORE	TUBE THICKNESS	PART NUMBER
2.125	ER-12	0.75	0.15625	SPR202001
2.25	p204	0.75	0.25	SPR204002
	ER-12	0.75	0.25	SPR204003
2.5	6304	20mm	0.3125	SPR208001
2.75	ER-19	1.1875	0.25	SPR212001
3	6305	30mm	0.375	SPR300001
	22206	30mm	0.375	SPR300002
3.25	ER-23	1.4375	0.25	SPR304003
	6306	1.3125	0.25	SPR304002
	22207 (Solid Oil)	35mm	0.25	SPR304001
3.5	ER-23	1.4375	0.375	SPR308003
	6307	35mm	0.375	SPR308002
	22207 (Solid Oil)	35mm	0.375	SPR308001
4	6308	40mm	0.3125	SPR400001
	21308	40mm	0.3125	SPR400002
6	6312	60mm	0.375	SPR600001
	22216 (Solid Oil)	80mm	0.375	SPR600002
8	6312	60mm	0.375	SPR800001
	22216 (Solid Oil)	80mm	0.375	SPR800002



BEARING SHIELDS AVAILABLE

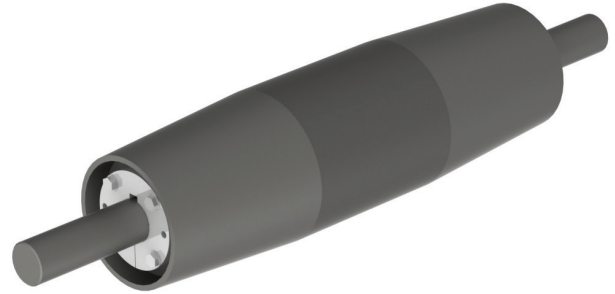
STEEL SHIELD – set screw mounted to the shaft outside of bearings to keep foreign objects and debris from damaging bearing

NYLON SHIELD – held in place by a push-nut, this shield will help deter foreign objects and debris from getting to the bearing.

CROWNING/SHAFTING/SOLID PULLEYS

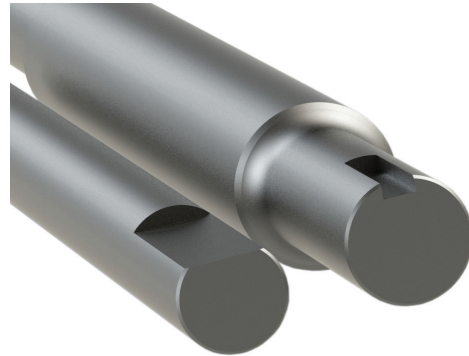
CROWNING

- Edge or End Crown: This is a partial crown, commonly used on machined face tube pulleys, where the pulley crown is machined only on the edges at the standard crown rate. The center of the pulley is left unmachined.
- Trap or Trapezoidal Crown: This is a partial crown, used when specified on tube pulleys. For a trap crown the entire face of the pulley is machined for better TIR throughout before crowning the ends at the standard crown rate.
- Flat face: can be machined for low TIR or left as standard tube finish.



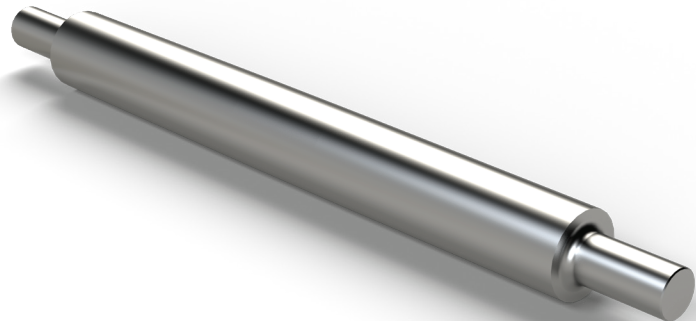
SHAFTING

- Standard Shaft Materials: 1018, 1045, CD, T&P, TG&P
- Shaft end detail available: Flat spots, "D"ends, Drill & Tap, pin hole, etc.
- For more information, go to www.ppi-global.com/resources/product-forms



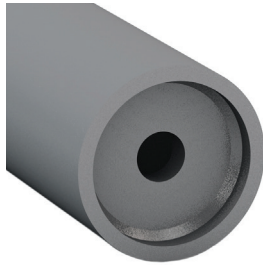
SOLID PULLEYS

- Standard Shaft Materials: 1018, 1045
- Fully machined belt contact surface in flat or crowned face
- Shaft end detail available: Flat spots, "D"ends, Drill & Tap, pin hole, etc.



WELD-IN/FIXED BORE/ADAPTER TYPE

PPI offers several shaft attachment types to fit your particular needs. These include, but are not limited to, Adapter Type (compression-style hub and bushing, such as XT or QD), Press Fit (interference fit with keyway), Fixed Bore (solid bore, clearance fit with keyway and setscrews), and Weld-in (no hub, welded to the shaft). For more information on these and other means of attaching a pulley to a shaft, contact your local PPI representative.



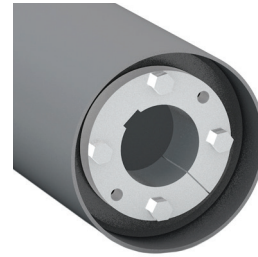
WELD-IN

End discs are bored to allow for the customer to weld-in a through shaft.



FIXED BORE

Removable shaft extends through the pulley and is held in place with set screws and driven through a keyway.

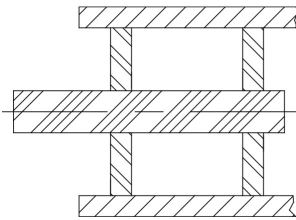


ADAPTER TYPE

A compression style hub with a through shaft is affixed by use of a tapered bushing. XT®, QD® and TaperLock® styles are available.

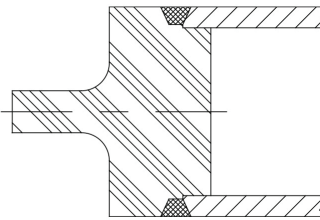
WELD-IN STUB SHAFTS

Weld-in stub shafts are commonly used where the stresses in a standard pulley shaft would be too great and the weight of the solid shaft/pulley is undesirable. The cyclical bending of an undersized pulley shaft over time can cause fatigue failures. Stub shaft pulleys can be offered with or without a crown and low TIR if required.



PLUG-WELDED SHAFT

- High through put option
- More widely used



TW STYLE SHAFT END

- Stronger design
- Can be used on pulleys where OD and shaft ID are close in size
- 6" pulley meets UPS spec

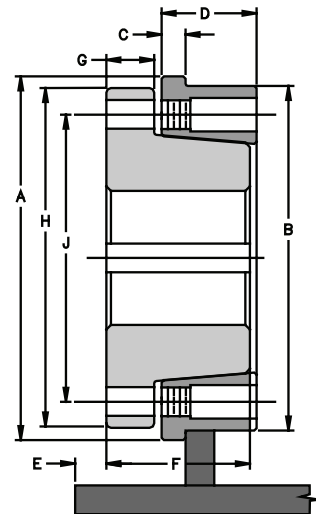
XT HUBS & BUSHINGS

XT Hubs & Bushings were computer-designed and specifically developed for conveyor pulley applications. This design utilizes a tapered bore bushing that provides all the holding power you'll ever need for conveyor pulleys and allows easier installation and removal than other bushing types. PPI has found that the XT taper and heavy barrel are best suited to our design philosophy and recommends them for pulley hub usages.

- 2" per foot taper
- Self-seating – no need to hammer bushing in
- Less axial movement – reduces end disc stress and seats quicker
- High clamping force eliminates need for keyway on non-drives
- Flange deflection stores up capscrew torque for seating while running
- Easy removal
- PPI offers the XT with larger hub diameters and longer hubs for greater load capacity.
- For metric key sizes, please go to www.ppi-global.com/resources/catalogs and scroll down to XT and QD Hubs.

HUB	BORE RANGE	KEYWAY		KEYSTOCK
		Shaft	Bushing	
XT15	1/2-9/16	1/8 x 1/16	1/8 x 1/16	1/8 x 1/8
	5/8-7/8	3/16 x 3/32	3/16 x 3/32	3/16 x 3/16
	15/16 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 1/2	3/8 x 3/16	3/8 x 1/8	3/8 x 5/16
XT20	3/4-7/8	3/16 x 3/32	3/16 x 3/32	3/16 x 3/16
	15/16 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 3/4	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 13/16 - 2	1/2 x 1/4	1/2 x 3/16	1/2 x 7/16
XT25	1 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 3/4	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 13/16 - 2 1/4	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
	2 5/16 - 2 1/2	5/8 x 5/16	5/8 x 1/8	5/8 x 7/16
XT30	1 7/16 - 1 3/4	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 13/16 - 2 1/4	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
	2 5/16 - 2 3/4	5/8 x 5/16	5/8 x 5/16	5/8 x 5/8
	2 13/16 - 3	3/4 x 3/8	3/4 x 3/16	3/4 x 9/16
	1 15/16 - 2 1/4	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
XT35	2 5/16 - 2 3/4	5/8 x 5/16	5/8 x 5/16	5/8 x 5/8
	2 13/16 - 3 1/4	3/4 x 3/8	3/4 x 3/8	3/4 x 3/4
	3 5/16 - 3 3/8	7/8 x 7/16	7/8 x 7/16	7/8 x 7/8
	3 7/16 - 3 1/2	7/8 x 7/16	7/8 x 5/16	7/8 x 3/4

Shaded lines are NOT full depth keys



X250207

XT Bushing Type Shaft Size in sixteenths of an inch

XT Bushing Size Shaft Size in inches

15, 20, 25, 30, 35, 40, 45, 50, 60, 70, 80,
10 for 100, 12 for 120

HUB	MAX BORE	HUB DIMENSION				BUSHING DIMENSION							
		Outside Diameter (A)	Minor Outside Diameter (B)	Flange Thickness (C)	Length (D)	Bushing Inset (E)	Length (F)	Flange Thickness (G)	Flange Outside Diameter (H)	Bolt Circle (J)	# Bolts	Bolt diameter	Torque (in lbs)
XT15	1.5	3 1/4	2 7/8	1/4	3/4	7/16	1 1/8	3/8	2 7/8	2 7/16	4	1/4	95
XT20	2	4 1/8	3 3/4	1/4	7/8	9/16	1 1/2	15/32	3 3/4	3 3/16	4	5/16	200
XT25	2.5	4 3/4	4 1/2	5/16	1 1/4	3/8	1 7/8	5/8	4 7/16	3 3/4	4	3/8	350
XT30	3	6	5 3/4	3/8	1 1/2	7/16	2 1/16	11/16	5 5/16	4 9/16	4	7/16	550
XT35	3.5	6 3/4	6 1/2	3/8	1 3/4	9/16	2 1/2	25/32	6 5/16	5 7/16	4	1/2	840

QD HUBS & BUSHINGS

HUB	BORE RANGE	KEYWAY		KEYSTOCK
		Shaft	Bushing	
SH	1/2-9/16	1/8 x 1/16	1/8 x 1/16	1/8 x 1/8
	5/8-7/8	3/16 x 3/32	3/16 x 3/32	3/16 x 3/16
	15/16 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 5/8	3/8 x 3/16	3/8 x 1/16	3/8 x 1/4
	1 11/16	NONE	NONE	NONE
SDS	1/2-9/16	1/8 x 1/16	1/8 x 1/16	1/8 x 1/8
	5/8-7/8	3/16 x 3/32	3/16 x 3/32	3/16 x 3/16
	15/16 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 5/8	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 11/16 - 1 3/4	3/8 x 3/16	3/8 x 1/8	3/8 x 5/16
	1 13/16 - 2	NONE	NONE	NONE
SK	1/2-9/16	1/8 x 1/16	1/8 x 1/16	1/8 x 1/8
	5/8-7/8	3/16 x 3/32	3/16 x 3/32	3/16 x 3/16
	15/16 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 3/4	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 13/16 - 2 1/8	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
	2 3/16 - 2 1/4	1/2 x 1/4	1/2 x 1/8	1/2 x 3/8
	2 5/16 - 2 1/2	5/8 x 5/16	5/8 x 1/16	5/8 x 3/8
	2 9/16 - 2 5/8	NONE	NONE	NONE
SF	15/16 - 1 1/4	1/4 x 1/8	1/4 x 1/8	1/4 x 1/4
	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 3/4	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 13/16 - 2 1/4	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
	2 5/16	5/8 x 5/16	5/8 x 5/16	5/8 x 5/8
	2 3/8 - 2 1/2	5/8 x 5/16	5/8 x 3/16	5/8 x 1/2
	2 9/16 - 2 3/4	5/8 x 5/16	5/8 x 1/16	5/8 x 3/8
	2 13/16 - 2 15/16	NONE	NONE	NONE
E	1 5/16 - 1 3/8	5/16 x 5/32	5/16 x 5/32	5/16 x 5/16
	1 7/16 - 1 3/4	3/8 x 3/16	3/8 x 3/16	3/8 x 3/8
	1 13/16 - 2 1/4	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
	2 5/16 - 2 3/4	5/8 x 5/16	5/8 x 5/16	5/8 x 5/8
	2 13/16 - 2 7/8	3/4 x 3/8	3/4 x 3/8	3/4 x 3/4
	2 15/16 - 3 1/4	3/4 x 3/8	3/4 x 1/8	3/4 x 1/2
	3 5/16 - 3 1/2	NONE	NONE	NONE
F	1 13/16 - 2 1/4	1/2 x 1/4	1/2 x 1/4	1/2 x 1/2
	2 5/16 - 2 3/4	5/8 x 5/16	5/8 x 5/16	5/8 x 5/8
	2 13/16 - 3 1/4	3/4 x 3/8	3/4 x 3/8	3/4 x 3/4
	3 5/16 - 3 3/4	7/8 x 7/16	7/8 x 3/16	7/8 x 5/8
	3 13/16 - 4	NONE	NONE	NONE

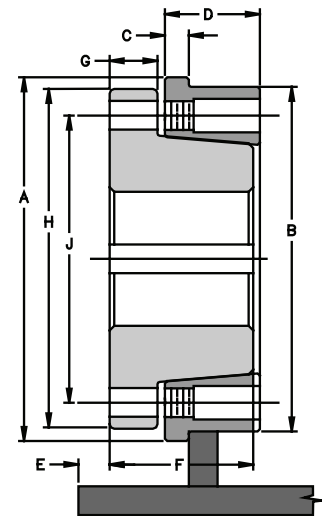
Shaded lines are NOT full depth keys

HUB	MAX BORE*	HUB DIMENSION				BUSHING DIMENSION							
		Outside Diameter (A)	Minor Outside Diameter (B)	Flange Thickness (C)	Length (D)	Bushing Inset (E)	Length (F)	Flange Thickness (G)	Flange Outside Diameter (H)	Bolt Circle (J)	# Bolts	Bolt Diameter	Torque (in lbs)
SH	1.44	3	2 7/8	1/4	7/8	9/16	1 5/16	7/16	2 5/8	2 1/4	3	1/4	108
SDS	2.00	3 1/2	3 1/4	1/4	3/4	9/16	1 5/16	7/16	3 1/8	2 11/16	3	1/4	108
SK	2.25	4 1/2	4 3/8	3/8	1 1/4	3/8	1 15/16	9/16	3 7/8	3 5/16	3	5/16	200
SF	2.50	4 3/4	4 1/2	5/16	1 1/4	1/2	2 1/16	5/8	4 5/8	3 7/8	3	3/8	360
E	3.00	6	5 3/4	3/8	1 1/2	7/16	2 3/4	7/8	6	5	3	1/2	720
F	3.50	6 3/4	6 1/2	3/8	1 3/4	3/4	3 3/4	1	6 5/8	5 5/8	3	9/16	900

Max bore of QD hubs is the maximum recommended for 2 hub assemblies, such as conveyor pulleys.

QD has a primary benefit of bushing interchangeability with other shaft mounted components. Its shallow taper provides a high mechanical advantage to assure dependable clamping to the shaft.

- Designed for a wide variety of applications
- 3/4" per foot taper - self-seating
- High clamping force eliminates need for keyway on non-drives
- Flange deflection stores up capscrew torque for seating while running
- For metric key sizes, please go to www.ppi-global.com/resources/catalogs and scroll down to XT and QD Hubs.



QSF0207

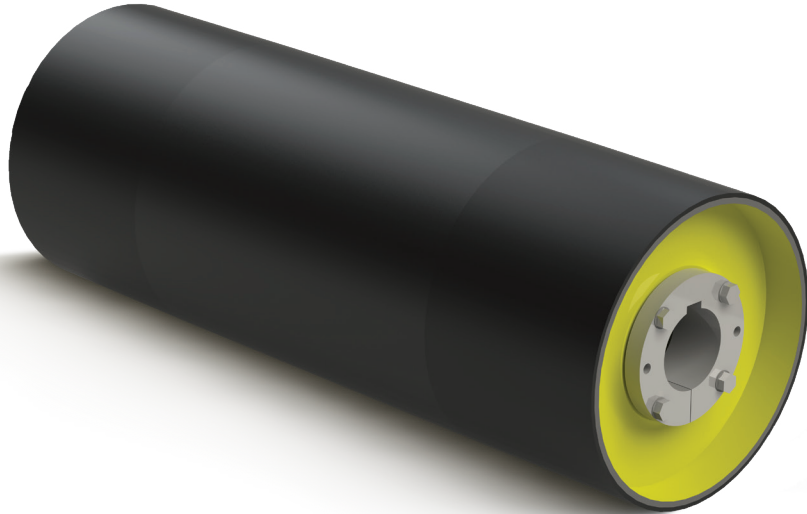
QD Bushing Type ———— QSF
 QD Bushing Size ———— SF, E, F, JS, MS, NS, PS, WS, SS, ZS
 Shaft Size in sixteenths of an inch
 Shaft size in inches

STANDARD LAGGING OPTIONS

NEOPRENE 85 DUROMETER

BENEFITS:

- Cost effective
- Improved belt traction
- Favorable wear characteristics
- Readily available
- Easily vulcanized
- Phthalate Resistant*
- Accepted industry wide



OTHER COMPOUNDS AVAILABLE:

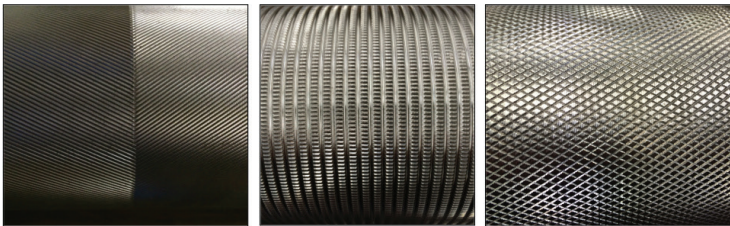
There are many lagging options available to meet chemical and environmental challenges.

- Millable Urethane 85 Durometer
- Natural Rubber 60 Durometer
- Carboxylated Nitrile

*Phthalates (plasticizers) leaching from PVC based belting common to the unit handling industry have been observed to cause some rubber compounds to breakdown losing their effectiveness. 85 durometer neoprene lagging has been proven to withstand the effects of the phthalates - while maintaining a workable hardness.

KNURLING – Many options exist when it comes to the belt contact surface. These are generally intended to increase the traction between the pulley and belt or to extend the life of the pulley.

PPI can perform knurling in a multitude of designs and depths to give the level of belt engagement desired, from mild to aggressive.



V-GROOVE PULLEY

For applications where belt tracking requires a V-guide in the surface of the pulley, use a PPI V-groove pulley. Available in all hub types.

STEEL

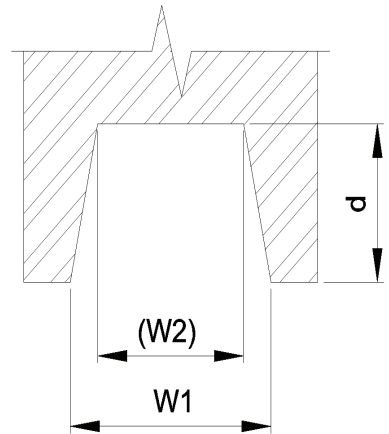


LAGGING



V-GROOVE DETAIL CHART

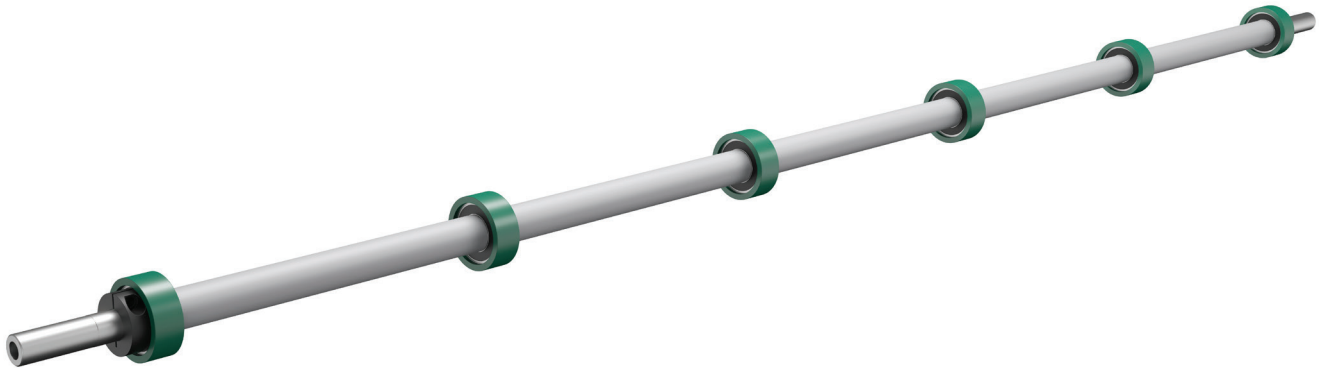
PPI Standard Size	V-BELT		GROOVE			PULLEY
	Fits	European Size	Width (W1)	Base (W2)	Height (d)	MIN OD
O	000, Z, 2L, 3L	K6, K8, K10	1/2	(0.281)	0.337	2.5
A	4L, 3V	K13, SPZ	5/8	(0.366)	0.399	3
B	5L	K15, K17, SPA	3/4	(0.410)	0.524	5
C	5V	K22, SPB	1	(0.599)	0.618	6
D	N/A	K30	1 3/8	(0.831)	0.836	8
8V	N/A	SPC	1 1/8	(0.475)	1.000	10



STANDARD V-GROOVE TUBE PULLEY SIZES

SECTION	PULLEY OD												
	3.5	4	4.5	5	5.5625	6	6.625	8	8.625	10	10.75	12	12.75
O	X	X	X	X	X	X	X	X	X	X	X	X	X
A	X	X	X	X	X	X	X	X	X	X	X	X	X
B	X	X	X	X	X	X	X	X	X	X	X	X	X
C	-	-	-	-	-	X	X	X	X	X	X	X	X
D	-	-	-	-	-	-	-	X	X	X	X	X	X

HUSH ROLL



Current one-piece steel return rolls operate with the belt running over a tube at high speeds creating a vibration. This causes the tube to act as a tuning fork resulting in very loud working conditions.

PPI has developed the Hush Roll as a solution to quieter working conditions and to improve overall workplace safety. This design features bearings at multiple, independent contact points able to grip the belt at high speeds and eliminates the vibration reducing the noise. These contact points also isolate objects caught between the belt and roll. This safer design can be used in some cases to eliminate costly guards which then reduces the overall conveyor cost. This design is ready to bolt in place of the standard 2.125" return roll.

FEATURES AND BENEFITS

- Emits $\frac{1}{4}$ the amount of sound produced by a typical roll
- The quietest return roll available in the market
- Safer by design – Multiple independent belt contact points eliminates the need for extra guarding reducing conveyor cost
- Drop in ready for all common 2.125" return roll
- Recommended to be installed on 150 fpm and faster conveyors
- PVC/Phthalate resistant bearing coating
- Approved for use in parcel applications

DEAD-END ROLLERS



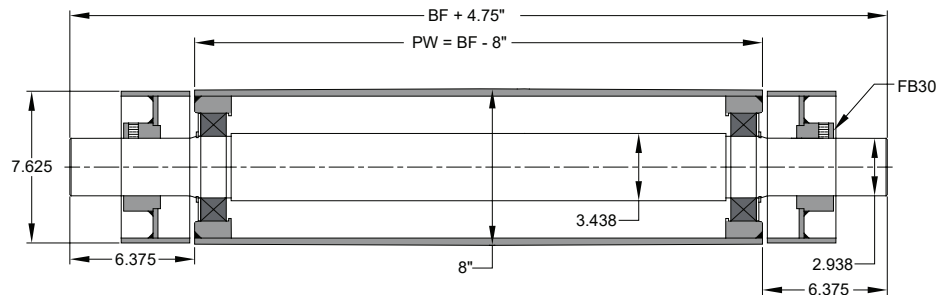
PPI Dead-End Rollers provide a safe, reliable solution to exposed work zones. They are designed to eliminate the potential pinch point caused between a rotating roller and the moving conveyor belt. Entanglement of Foreign Objects and Debris (FOD) is also reduced as a result of stationary roller ends.

FEATURES AND BENEFITS

- Static end design eliminates pinch points between belt and roller
- Sealed deep groove ball bearings or solid oil filled double row spherical roller bearings do not require re-lubing
- Bolts on to many present systems
- Many shaft end details available, contact your PPI representative for details
- Tube may be machined to stringent tolerances minimizing runout

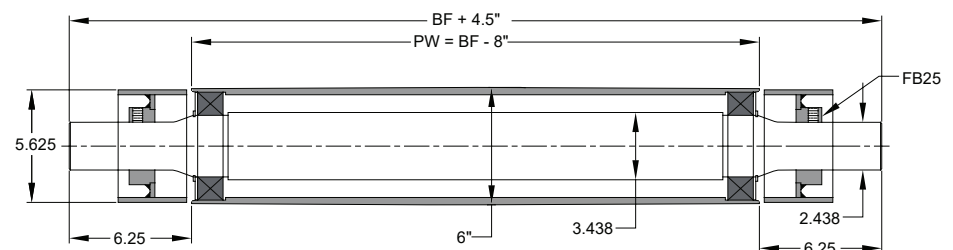
8" Roller - Dead End 24#

BETWEEN FRAMES (inches)	PULLEY WIDTH (inches)
37	29
43	35
49	41
61.5	53.5



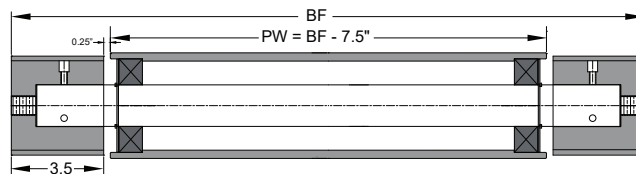
6" Roller - Dead End 14#

BETWEEN FRAMES (inches)	PULLEY WIDTH (inches)
37	29
43	35
49	41
61.5	53.5



4" and Under Roller

PULLEY DIAMETER (inches)
2.25
3.00
3.25
3.50
4.00



Additional sizes available upon request, contact your PPI representative.

WEIGHTED TAKE-UP PULLEYS

WEIGHTED TAKE-UP PULLEYS

PPI offers weighted take-up pulleys in all sizes required for you parcel conveyor applications.

Pulleys are filled with steel shot to attain the weight required to properly tension your belt.

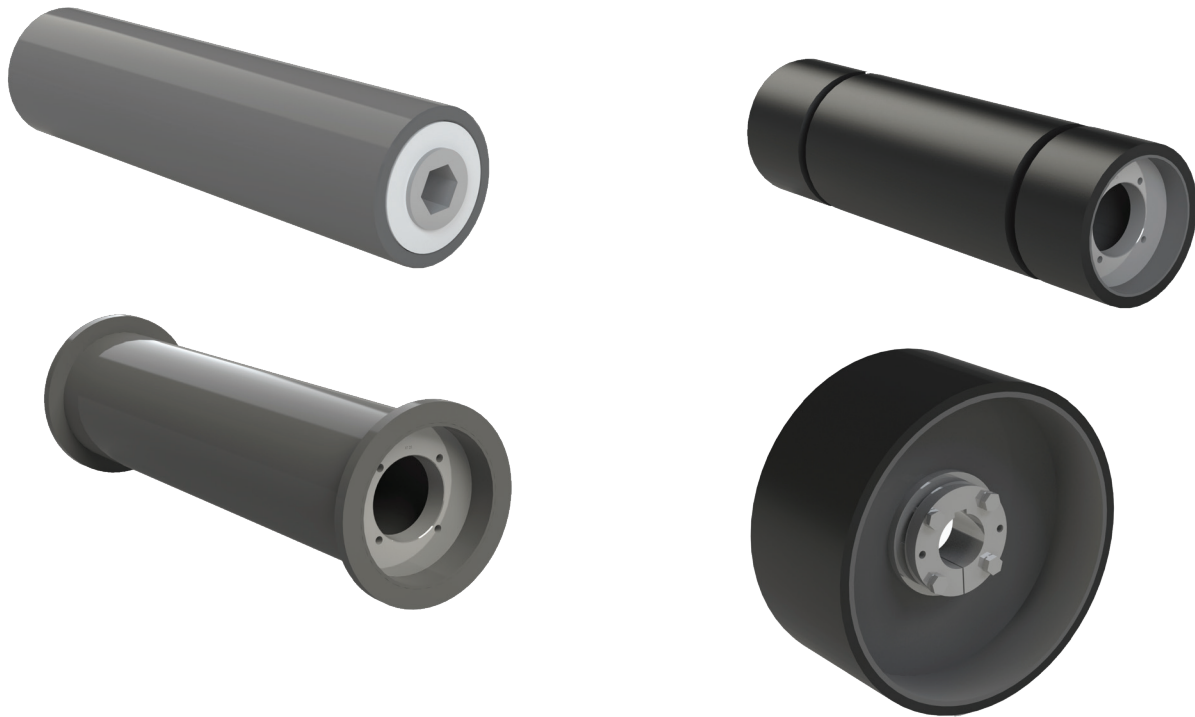


PULLEY OUTSIDE DIAMETER	12.75"	16"	18"	20"	24"	
	WALL THICKNESS	0.375"	0.500"	0.500"	0.594"	0.688"
BELT WIDTH	36"	840 lbs	1305 lbs	1635 lbs	2005 lbs	-
	42"	985 lbs	1530 lbs	1920 lbs	2325 lbs	-
	48"	1130 lbs	1755 lbs	2205 lbs	2670 lbs	-
	60"	1420 lbs	2210 lbs	2775 lbs	3360 lbs	4880 lbs

CUSTOM PRODUCTS

PPI has over 40 years of pulley manufacturing experience. Custom built pulley products have always been an important part of our business and it will continue to be in the future.

PPI welcomes inquiries for unusual designs and features. We will do our best to meet your needs either through a custom built product or by possibly introducing you to a current product that can perform the desired function.





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