

Therefore, CEMA recommends for critical applications the correct transition distance should be calculated under all expected tensions based on the belt manufacturer's recommendations. One method for calculating the transition distance is given in ISO5293-2008. Charts 7.27 and 7.29 are provided for reference.

#### CEMA Recommendation

- Always use metal rollers of the proper load rating for transition idlers.
- Never loaded on a transition, start loading after at least one full troughing idler.
- The full transition arrangement is the CEMA preferred arrangement for transitions before loading.
- The one third transition is the CEMA preferred arrangement for transitions at the discharge.

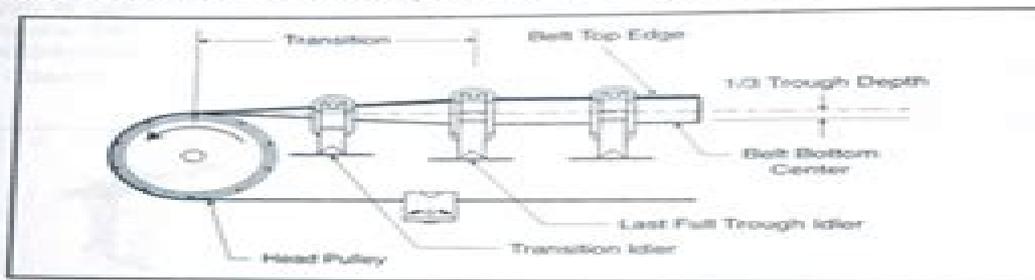


Figure 7.26

One third trough transition from last fully troughed idler to pulley

Idler Trough Angle	% Rated Belt Tension	Transition Distance = Factor × Belt Width (BW)	
		Fabric Belts	Steel Cord Belts
20°	> 90%	1.2	2.7
	60% to 90%	0.9	2.1
	< 60%	0.6	1.3
35°	> 90%	2.1	4.5
	60% to 90%	1.4	3.5
	< 60%	1.2	2.4
45°	> 90%	2.6	5.3
	60% to 90%	2.0	4.3
	< 60%	1.6	3.1

Table 7.27

One third trough minimum transition distance ratios

# Cema 7th Edition

**ML Morrison**



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## **Table of Contents Cema 7th Edition**

1. Understanding the eBook Cema 7th Edition
  - The Rise of Digital Reading Cema 7th Edition
  - Advantages of eBooks Over Traditional Books
2. Identifying Cema 7th Edition
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Cema 7th Edition
  - User-Friendly Interface
4. Exploring eBook Recommendations from Cema 7th Edition
  - Personalized Recommendations
  - Cema 7th Edition User Reviews and Ratings
  - Cema 7th Edition and Bestseller Lists
5. Accessing Cema 7th Edition Free and Paid eBooks
  - Cema 7th Edition Public Domain eBooks
  - Cema 7th Edition eBook Subscription Services
  - Cema 7th Edition Budget-Friendly Options
6. Navigating Cema 7th Edition eBook Formats

- ePub, PDF, MOBI, and More
  - Cema 7th Edition Compatibility with Devices
  - Cema 7th Edition Enhanced eBook Features
7. Enhancing Your Reading Experience
    - Adjustable Fonts and Text Sizes of Cema 7th Edition
    - Highlighting and Note-Taking Cema 7th Edition
    - Interactive Elements Cema 7th Edition
  8. Staying Engaged with Cema 7th Edition
    - Joining Online Reading Communities
    - Participating in Virtual Book Clubs
    - Following Authors and Publishers Cema 7th Edition
  9. Balancing eBooks and Physical Books Cema 7th Edition
    - Benefits of a Digital Library
    - Creating a Diverse Reading Collection Cema 7th Edition
  10. Overcoming Reading Challenges
    - Dealing with Digital Eye Strain
    - Minimizing Distractions
    - Managing Screen Time
  11. Cultivating a Reading Routine Cema 7th Edition
    - Setting Reading Goals Cema 7th Edition
    - Carving Out Dedicated Reading Time
  12. Sourcing Reliable Information of Cema 7th Edition
    - Fact-Checking eBook Content of Cema 7th Edition
    - Distinguishing Credible Sources
  13. Promoting Lifelong Learning
    - Utilizing eBooks for Skill Development
    - Exploring Educational eBooks
  14. Embracing eBook Trends
    - Integration of Multimedia Elements
    - Interactive and Gamified eBooks

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