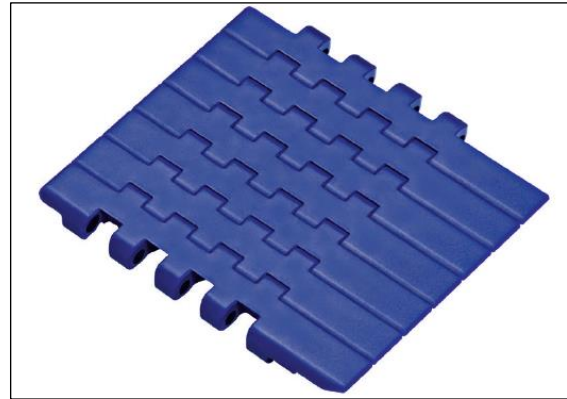


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Installation instructions for M1220L03 ActivXchange

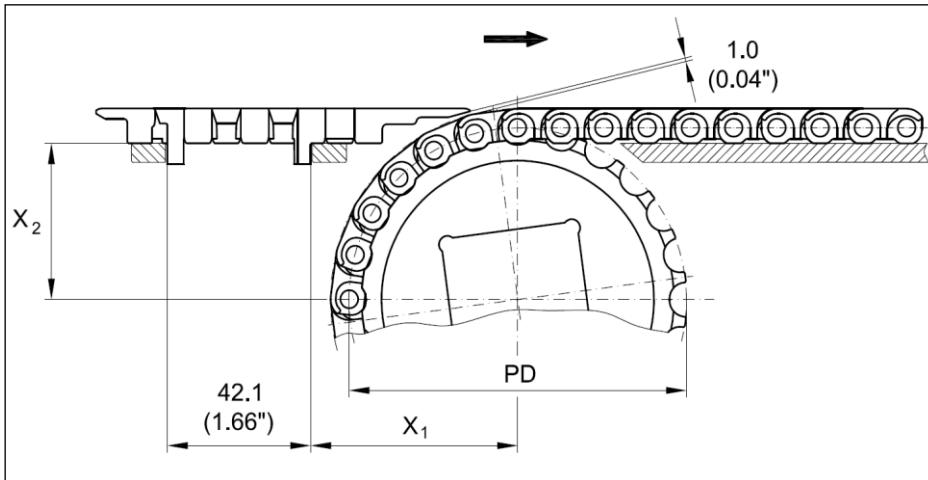
ActivXchange transfer modules allow a smooth 90° transfer without dead plates and a self-clearing transfer from one belt to the other. The module is provided with two tabs in order to guarantee an accurate position and tracking of the ActivXchange belt.



The exact installation dimensions are listed in the tables on the next pages.

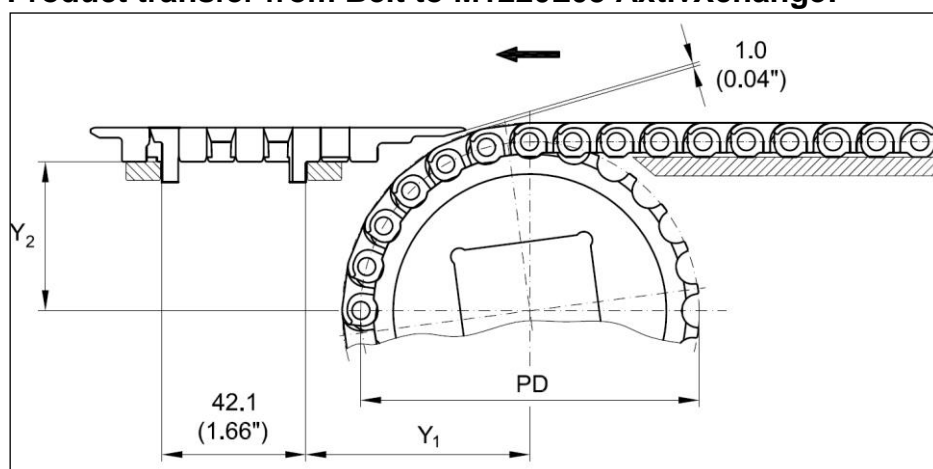
It is recommended to build the frame construction in a way that X_1 / Y_1 and X_2 / Y_2 can be adjusted within a range of some millimeters.

Product transfer from M1220L03 AxtivXchange to Belt:



transfer from ActivXchange (thickness)	to Belt Typ (thickness)	Sprocket- typ	Pitch Diameter Sprocket (PD)		X1		X2	
			mm	in	mm	in	mm	in
M1220L03 (10mm)	M1200 (8.7mm)	M12S10	41.2	1.6	56.1	2.21	15.0	0.59
		M12S15	62.4	2.5	58.1	2.29	25.4	1.00
		M12S24	99.2	3.9	60.7	2.39	43.8	1.72
		M12S28	116.5	4.6	61.8	2.43	52.5	2.07
		M12S36	149.8	5.9	63.7	2.51	69.2	2.72
	M1200 (10mm)	M12S10	41.2	1.6	56.3	2.22	16.2	0.64
		M12S15	62.4	2.5	58.2	2.29	26.6	1.05
		M12S24	99.2	3.9	60.8	2.39	45.0	1.77
		M12S28	116.5	4.6	61.9	2.44	53.7	2.11
		M12S36	149.8	5.9	64.2	2.53	70.3	2.77
	M2400 (8.7mm)	M24S12	99.1	3.9	60.6	2.39	43.9	1.73
		M24S15	123.4	4.9	62.1	2.44	56.1	2.21
		M24S18	147.7	5.8	63.6	2.50	68.3	2.69
		M24S20	164.0	6.5	65.0	2.56	76.3	3.00
	M2500 (10mm)	M25S12	98.6	3.9	60.8	2.39	44.3	1.74
		M25S16	130.8	5.1	62.8	2.47	60.4	2.38
		M25S18	146.9	5.8	63.7	2.51	68.5	2.70
		M25S20	163.0	6.4	65.0	2.56	76.5	3.01
	M2600 (12.7mm)	M26S12	99.1	3.9	60.9	2.40	45.9	1.81
		M26S16	131.5	5.2	63.2	2.49	62.2	2.45
M26S18		147.7	5.8	64.3	2.53	70.2	2.76	
M26S21		172.1	6.8	65.8	2.59	82.4	3.24	

Product transfer from Belt to M1220L03 AxtivXchange:



transfer from Belt Type (thickness)	to AxtivXchange (thickness)	Sprocket- typ	Pitch Diameter Sprocket (PD)		Y1		Y2	
			mm	in	mm	in	mm	in
M1200 (8.7mm)	M1220L03 (10mm)	M12S10	41.2	1.6	58.4	2.30	14.0	0.55
		M12S15	62.4	2.5	60.8	2.39	24.4	0.96
		M12S24	99.2	3.9	64.0	2.52	42.8	1.69
		M12S28	116.5	4.6	65.4	2.57	51.5	2.03
		M12S36	149.8	5.9	67.8	2.67	68.1	2.68
M1200 (10mm)	M1220L03 (10mm)	M12S10	41.2	1.6	60.7	2.39	14.1	0.56
		M12S15	62.4	2.5	62.4	2.46	25.0	0.98
		M12S24	99.2	3.9	65.4	2.57	43.6	1.72
		M12S28	116.5	4.6	66.6	2.62	52.4	2.06
		M12S36	149.8	5.9	68.7	2.70	69.1	2.72
M2400 (8.7mm)	M1220L03 (10mm)	M24S12	99.1	3.9	68.5	2.70	41.2	1.62
		M24S15	123.4	4.9	70.0	2.76	53.7	2.11
		M24S18	147.7	5.8	71.4	2.81	66.1	2.60
		M24S20	164.0	6.5	72.3	2.85	74.3	2.93
M2500 (10mm)	M1220L03 (10mm)	M25S12	98.6	3.9	68.4	2.69	41.7	1.64
		M25S16	130.8	5.1	70.6	2.78	58.1	2.29
		M25S18	146.9	5.8	71.1	2.80	66.4	2.61
		M25S20	163.0	6.4	72.4	2.85	74.5	2.93
M2600 (12.7mm)	M1220L03 (10mm)	M26S12	99.1	3.9	68.9	2.71	43.2	1.70
		M26S16	131.5	5.2	70.7	2.78	59.9	2.36
		M26S18	147.7	5.8	71.7	2.82	68.1	2.68
		M26S21	172.1	6.8	73.0	2.87	80.5	3.17

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