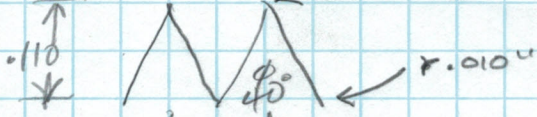


POLY-V "K" SPEC.

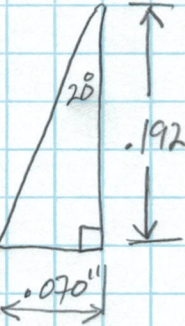
GIVEN:

03-10-16

PAGE 1 OF



SO,
*



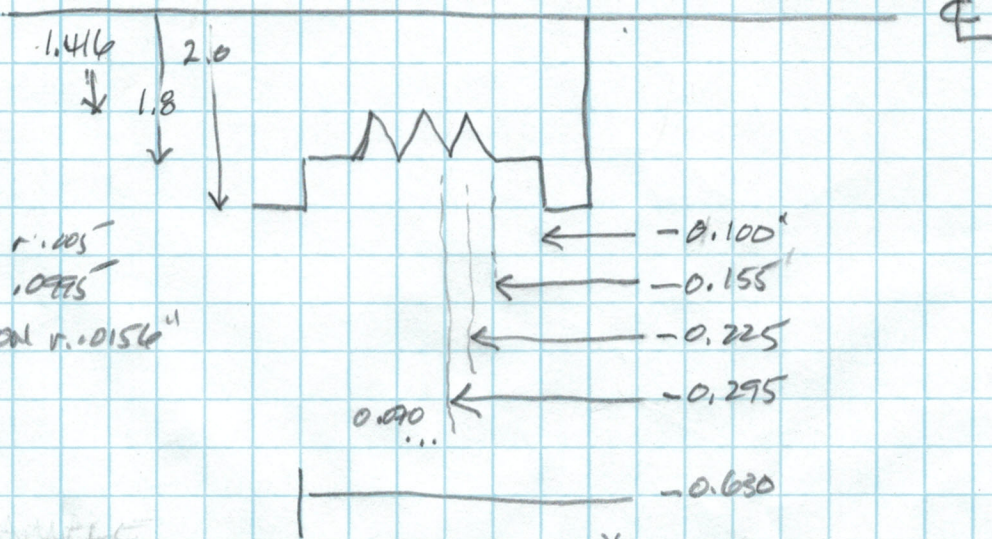
FROM MACHINERY'S HANDBOOK 25
PAGE 2313.

$$FACE\ WIDTH\ (F_w) = S_g (N_g - 1) + 2 S_e$$

WHERE S_e FOR "K" = 0.125"
 N_g IS NUMBER OF RIBS

SO, FOR 3 RIBS $F_w = .140(3-1) + 2(.125) = 0.530"$

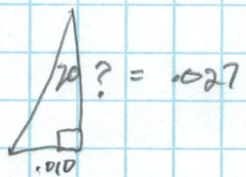
2" OD
EXAMPLE



US
S
Groove r. .025
W .0775
Bottom r. .0156"

"VERIFY" OK, "LOOK" OK, "TOOL PATH" * NOT OK.

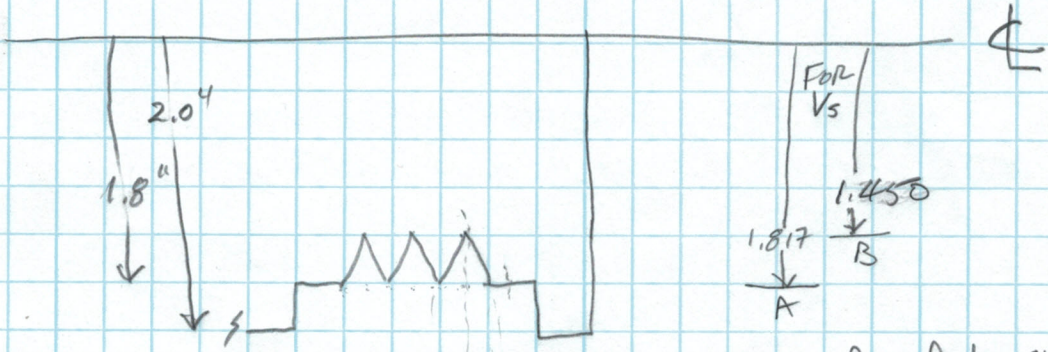
OUTER EDGE OF PULLEY



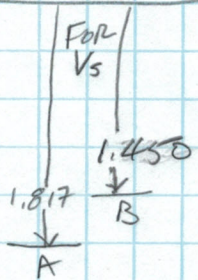
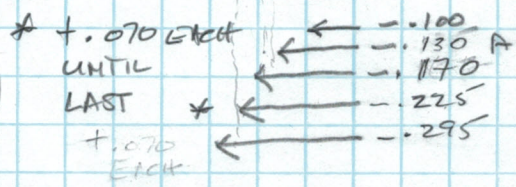
$$\frac{.027}{.017} = \text{CORRECTION FACTOR FOR PULLEY DIA.}$$

DEPTH AT .140" PITCH = .192"

EXAMPLE: DESIRED PULLEY DIA = 1.800"
 Prog: "POLYVXI"



FIRST, LAST V ADJ.



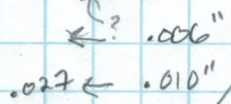
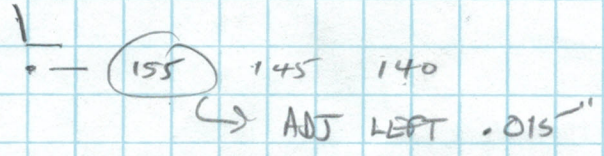
$$A = D + .017$$

$$B = D - 2(.192) + 2(.017)$$

$$B = 1.8 - .384 + .034$$

$$B = 1.450$$

A = MIN CLEARANCE FOR 35° DIAMOND SHAPE INSERT



GROOVE DEPTH =

1.834

1.477

$$\Delta = .357 / 2 = .1785 \text{ POINT TO POINT}$$

PROTRAK PROGRAMMING FOR POLY-V R SERIES PULLEY

DAL 03/13/16

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INNER
OUTER

$\Delta = .1785", .357"$ AT DIAMETER, POINT TO POINT

PITCH = .140", INCLUDED ANGLE IS 40°
 BOTTOM RADIUS = .020", TOP RADIUS = .010"
 FACE WIDTH = $P(R-1) + 2(E)$

WHERE $P = \text{PITCH} = .140"$

$R = \text{NUMBER OF RIBS}$

$E = .125" = \text{DISTANCE FROM EDGE TO } \phi \text{ OF FIRST/LAST GROOVE}$

$D = \text{PULLEY DIAMETER MEASURED AT TOP OF GROOVES}$

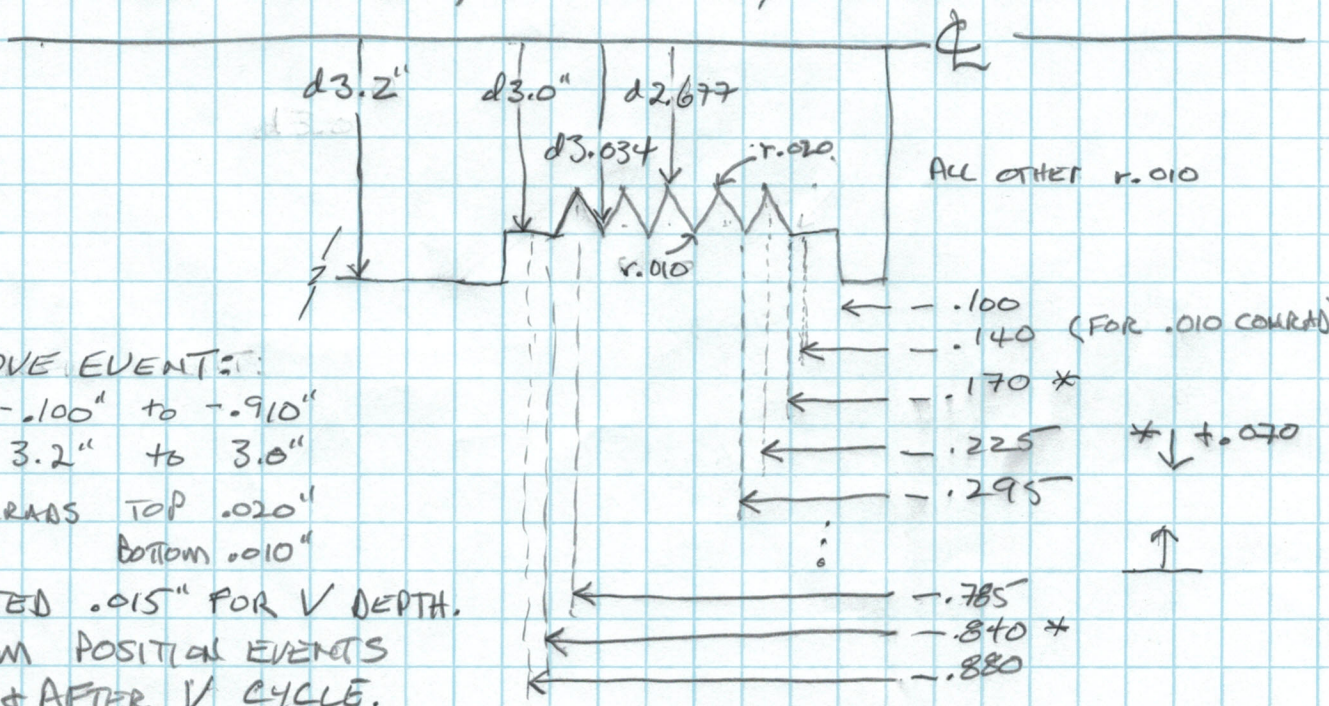
*ADJUSTMENTS FOR D FOR GROOVE PROGRAMMING

TOP OF GROOVES $D + .034"$
 BOTTOM OF GROOVES $D - .357 + .034 = D - .323"$

ADJUSTMENTS FOR Z

FIRST GROOVE START $-.015$
 LAST GROOVE STOP $+.015$

EXAMPLE: $D = 3"$, $R = 5$ w/.100 EDGE.



GROOVE EVENTS:

Z: $-.100"$ to $-.910"$

X: $3.2"$ to $3.0"$

CONRAD TOP $.020"$

BOTTOM $.010"$

*ADJUSTED $.015"$ FOR V DEPTH.

PROGRAM POSITIONAL EVENTS BEFORE & AFTER V CYCLE.