

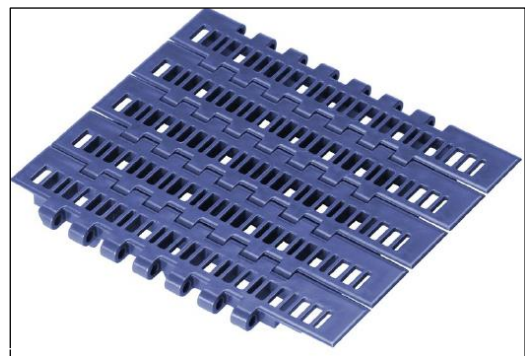
HabasitLINK[®]

Installation instructions for M2470L04 and M2480L04 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.



M2470L04

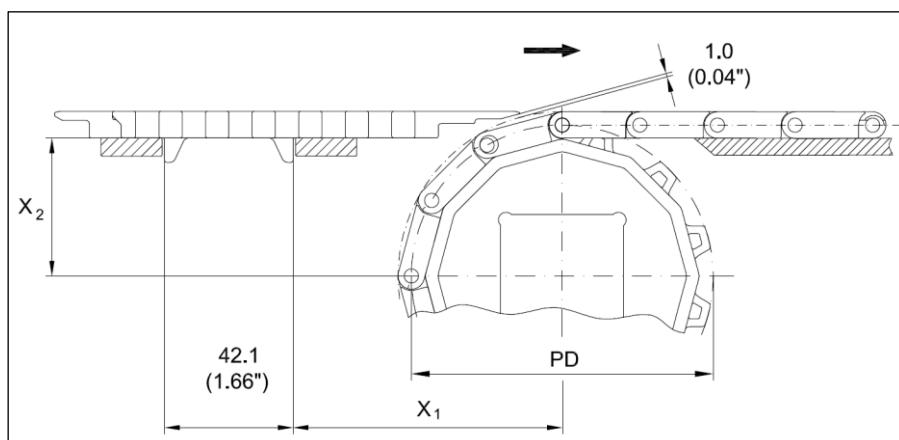


M2480L04

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

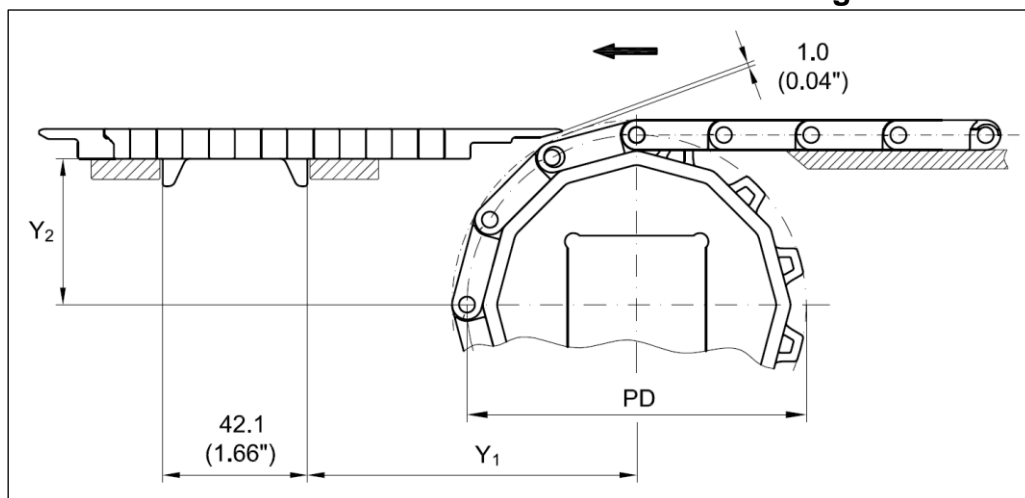
It is recommended to build the frame construction in a way that X_1 / Y_1 and X_2 / Y_2 can be adjusted within a range of some millimeters.

Product transfer from M2470/80L04 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
M2470L04 (8.7mm) or M2480L04 (8.7mm)	M1200 (8.7mm)	M12S10	41.2	1.6	83.6	3.29	16.3	0.64
		M12S15	62.4	2.5	85.5	3.37	26.7	1.05
		M12S24	99.2	3.9	88.1	3.47	45.1	1.78
		M12S28	116.5	4.6	89.2	3.51	53.8	2.12
	M1200 (10mm)	M12S36	149.8	5.9	91.2	3.59	70.5	2.78
		M12S10	41.2	1.6	83.7	3.30	17.5	0.69
		M12S15	62.4	2.5	85.6	3.37	27.9	1.10
		M12S24	99.2	3.9	88.2	3.47	46.3	1.82
		M12S28	116.5	4.6	89.3	3.52	55.0	2.17
	M2400 (8.7mm)	M12S36	149.8	5.9	91.3	3.59	71.7	2.82
		M24S12	99.1	3.9	88.1	3.47	45.2	1.78
		M24S15	123.4	4.9	89.5	3.52	57.4	2.26
		M24S18	147.7	5.8	91.0	3.58	69.6	2.74
	M2500 (10mm)	M24S20	164.0	6.5	92.4	3.64	77.6	3.06
		M25S12	98.6	3.9	88.2	3.47	45.6	1.80
		M25S16	130.8	5.1	90.2	3.55	61.7	2.43
M25S18		146.9	5.8	91.1	3.59	69.8	2.75	
M2600 (12.7mm)	M25S20	163.0	6.4	92.1	3.63	77.9	3.07	
	M26S12	99.1	3.9	88.3	3.48	47.2	1.86	
	M26S16	131.5	5.2	90.2	3.55	63.5	2.50	
	M26S18	147.7	5.8	91.3	3.59	71.6	2.82	
		M26S21	172.1	6.8	93.3	3.67	83.7	3.30

Product transfer from Belt to M2470/80L04 AxtivXchange:



Transfer from Belt Type (thickness)	to AxtivXchange (thickness)	Sprocket-type	Pitch Diameter Sprocket (PD)		Y1		Y2	
			mm	in	mm	in	mm	in
M1200 (8.7mm)	M2470L04 (8.7mm) or M2480L04 (8.7mm)	M12S10	41.2	1.6	85.8	3.38	15.3	0.60
		M12S15	62.4	2.5	88.2	3.47	25.7	1.01
		M12S24	99.2	3.9	91.3	3.59	42.4	1.67
		M12S28	116.5	4.6	92.8	3.65	52.8	2.08
		M12S36	149.8	5.9	95.3	3.75	69.4	2.73
M1200 (10mm)		M12S10	41.2	1.6	87.9	3.46	15.5	0.61
		M12S15	62.4	2.5	89.8	3.54	26.3	1.04
		M12S24	99.2	3.9	92.8	3.65	44.9	1.77
		M12S28	116.5	4.6	94.2	3.71	53.6	2.11
		M12S36	149.8	5.9	96.2	3.79	70.4	2.77
M2400 (8.7mm)	M24S12	99.1	3.9	95.9	3.78	42.5	1.67	
	M24S15	123.4	4.9	97.4	3.83	55.0	2.17	
	M24S18	147.7	5.8	98.8	3.89	67.4	2.65	
	M24S20	164.0	6.5	99.7	3.93	75.6	2.98	
M2500 (10mm)	M25S12	98.6	3.9	95.8	3.77	43.0	1.69	
	M25S16	130.8	5.1	97.9	3.85	59.4	2.34	
	M25S18	146.9	5.8	98.9	3.89	67.6	2.66	
	M25S20	163.0	6.4	99.7	3.93	75.8	2.98	
M2600 (12.7mm)	M26S12	99.1	3.9	96.3	3.79	44.5	1.75	
	M26S16	131.5	5.2	98.1	3.86	61.2	2.41	
	M26S18	147.7	5.8	99.1	3.90	69.4	2.73	
	M26S21	172.1	6.8	100.4	3.95	81.8	3.22	

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