

# Reverse Bends

Several of the typical conveyor layouts include one or more reverse bends. A reverse bend occurs when the belt flexes in the opposite direction from a transfer. Reverse bends are typically used to increase sprocket wrap or for take-ups.

It is good engineering practice to use the largest diameter possible for all changes of direction. This will decrease flexing of the wire strands and help prolong belt life. So, if a reverse bend must be used, we recommend the roll diameter be at least 10 times the belt pitch in inches. It is not necessary to groove these rolls because they contact the belt on its smooth side.

If your application requires you to drive the belts at a reverse bend, (we do not recommend this practice) special sprockets must be designed. The pitch of the belt changes in a reverse bend, so the belt mesh will not be properly engaged unless these special sprockets are used.

