

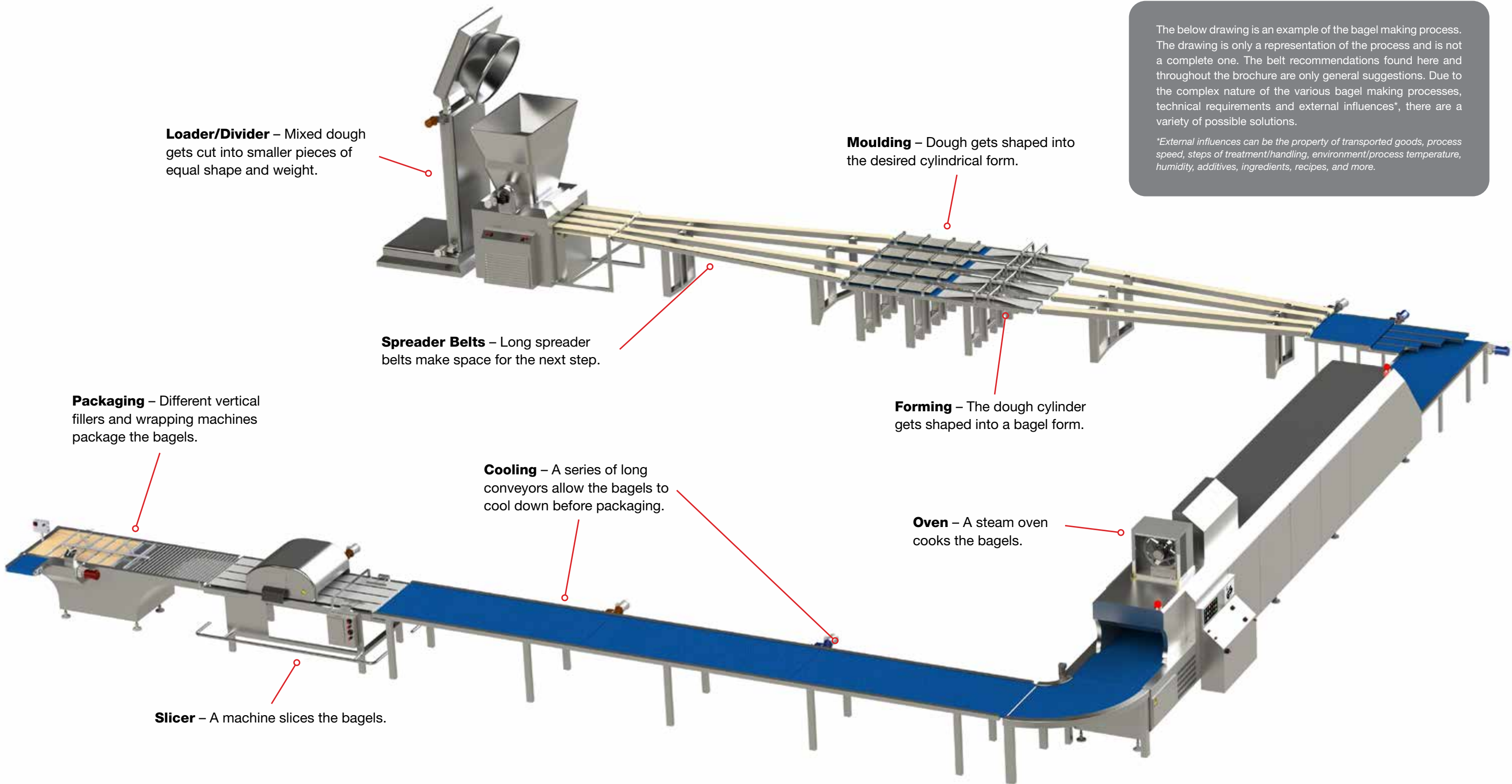


## **BELTS FOR BAGEL PRODUCTION**



# BAGEL PRODUCTION LINE

Standard layout of a bagel production line.



# BELT APPLICATIONS

Most common machines and conveyor belts.

## DOUGH LOADER & DIVIDER

The dough gets loaded into the hopper and using knives or rotary discs it gets cut into individual round pieces of the same weight that fall onto one or more conveyors.

**Recommended belts:** R14 BF, but also wool felts, solid woven cotton, F or R series could be used.



WOOL FELT

## DOUGH MOULDER

The dough moulder is a machine that has a belt running on the bottom and a fixed piece of plastic on the top. This way, the piece of dough rolls onto itself to form a cylinder.

**Recommended belts:** R19, R14 BF, solid woven cotton or wool felts because they have great release properties.



R19

## BAGEL FORMING

The dough forming machine has a very flexible belt going into a tube shaped conveyor, which forces the cylindrical dough into a ring.

**Recommended belts:** P19/B, R20, and R30 are conveyor belts specifically designed for bagel forming machines.



P19/B

## OVEN

The in-feed and out-feed belts need to be able to withstand the high heat coming from the oven.

**Recommended belts:** High temperature resistance thermoplastic belts like P9/A/PX and HY6/A.



P9/A/PX

## BAGEL SLICER

After the bread is cooled down it goes into the slicer. These machines normally have a belt on the bottom. Depending on the type of machine, they can also have the same belt on the sides to hold and compress the bagel. Other machines use timing belts.

**Recommended belts:** F10/M or a F20/T for the bottom belt (and side belt where applicable). We also offer timing belts if needed.



F20/T

## PACKAGING


There are a lot of different kinds of machines, depending on if the bagels are going to be wrapped in plastic or put into a box to be frozen.


**Recommended belts:** Timing belts with special covers for vertical fillers and wrapping machines. Any P or F series conveyor belt can be used for the in and out-feed of the machine.



LINATEX COVERED  
TIMING BELT

TECHNICAL INFORMATION

TECHNICAL INFORMATION																			Cover Material	Cover Finish	Plies	Interply Material	Fabric Material	Bottom Finish	Overall Thickness		Top Cover Thickness		Max Temp		Minimum Pulley		Pull per 1%		Color	Loader	Spreader	Moulder	Forming	Oven In/Out-feed	Slicer	Packaging	General Conveying
Product Code	mm	in	mm	in	C°	F°	mm	in	N/mm	Lbf/in																																	
P21/A TR	TD	PU	Smooth Matte	2	PU	Polyester	PU Impregnation	1.90	0.075	0.50	0.020	90	194	40	1.575	8	45	○	•	•								•															
P22/A TR	TD	PU	Smooth Matte	2	PU	Polyester	PU Impregnation	2.30	0.091	0.90	0.035	90	194	50	1.969	8	45	○	•	•								•															
P6/A	TD	PU	Smooth Matte	1	PU	Polyester	PU Impregnation	0.80	0.031	0.29	0.011	80	176	5	0.197	5	28	○●	•	•								•															
P7/Z	TD	PU	Inverted Pyramid	1	PU	Polyester	PU Impregnation	1.30	0.051	0.50	0.020	80	176	10	0.394	8	45	○			•							•															
P8/A	TD	PU	Smooth Matte	2	PU	Polyester	PU Impregnation	1.30	0.051	0.29	0.011	80	176	20	0.787	8	45	○●	•	•								•															
P8/Z	TD	PU	Inverted Pyramid	2	PU	Polyester	PU Impregnation	1.50	0.059	0.29	0.011	80	176	20	0.787	8	45	○●			•							•															
P9/A	TD	PU	Smooth Matte	2	PU	Polyester	PU Impregnation	1.30	0.051	0.29	0.011	80	176	10	0.394	6	34	○●	•	•								•															
P9/A PX	TD	PU	Smooth Matte	2	PU	Polyester	PU Impregnation	1.30	0.051	0.29	0.011	110	230	10	0.394	6	34	○	•	•			•					•															
P9/Z	TD	PU	Inverted Pyramid	2	PU	Polyester	PU Impregnation	1.50	0.059	0.29	0.011	80	176	10	0.394	6	34	○●			•							•															
P20/A	TD	PU	Smooth Matte	2	PU	Polyester	PU Impregnation	2.39	0.094	0.50	0.020	80	176	80	3.150	13	74	○●	•	•																							
P19/B	TD	PU	Mini Rough Top	2	PU	Polyester	PU Impregnation	2.30	0.091	0.90	0.035	90	194	30	1.181	6	34	○				•																					
HY6/A	-	Hytrel	Smooth Matte	1	Hytrel	Polyester	PU Impregnation	1.00	0.039	0.29	0.011	120	248	10	0.394	5	28	○					•																				
R13	TD	Bare Fabric	PU Impregnated	2	PU	Polyester	PU Impregnation	1.00	0.039	N/A	N/A	90	194	30	1.181	6	34	●○	•	•						•	•																
R14	TD	Bare Fabric	PU Impregnated	2	PU	Polyester	PU Skim	1.39	0.055	N/A	N/A	80	176	30	1.181	8	45	○●	•	•						•	•																
R14 BF	DI	Bare Fabric	PU Impregnated	2	PU	Spun Polyester	PU Skim	1.30	0.051	N/A	N/A	80	176	25	0.984	10	57	●	•	•	•							•															
R19	DI	Bare Fabric	Cotton/Polyester	2	PVC	Cotton/Polyester	Bare	2.39	0.094	N/A	N/A	90	194	50	1.969	5	28	●	•	•	•	•																					
R20	DI	Bare Fabric	Cotton/Polyester	2	PU	Cotton/Polyester	PU Impregnation	1.30	0.051	N/A	N/A	80	176	0	0.37	6	34	○	•	•	•	•						•															
R30	DI	Bare Fabric	Cotton/Polyester	3	PU	Cotton/Polyester	PU Impregnation	2.30	0.091	N/A	N/A	80	176	50	1.969	9	51	○	•	•	•	•						•															
SAM210	2M	Polyester Felt	Felt	2	PVC	Polyester	Bare	3.20	0.126	1.80	0.071	90	194	40	1.575	6	34	●	•	•								•															
F10	DI	PVC	Smooth Glossy	2	PVC	Polyester	PU Impregnation	2.00	0.079	0.50	0.020	80	176	30	1.181	8	45	○●								•	•																
F10/M	DI	PVC	Rough Top	2	PVC	Polyester	PU Impregnation	5.20	0.205	3.70	0.145	80	176	40	1.575	8	45	○							•	•	•																
F20/T	DI	PVC	Saw Tooth	2	PVC	Polyester	PU Impregnation	5.00	0.197	3.00	0.120	80	176	60	2.362	18	103	○●							•	•	•																
WOOL 503	-	No Cover	Felt	1	N/A	Wool	Felt	3.30	0.130	N/A	N/A	110	230	5	0.197	2	12	●	•									•															
WOOL 2400	-	No Cover	Felt	1	N/A	Wool	Bare	6.00	0.236	N/A	N/A	110	230	10	0.394	2	12	●	•									•															
WOOL 1500	-	No Cover	Felt	1	N/A	Polyester	Bare	3.00	0.118	N/A	N/A	110	230	5	0.197	32	183	●		•								•															
SWC 2PLY	-	No Cover	Cotton Fabric	2	N/A	Cotton	Cotton Fabric	2.50	0.098	N/A	N/A	107	225	25	0.984	9	51	●										•															
SWC 4PLY	-	No Cover	Cotton Fabric	4	N/A	Cotton	Cotton Fabric	4.70	0.185	N/A	N/A	107	225	76	2.992	18	103	●										•															

 **CB** All recommended belts are FDA approved for direct food contact.  
**WARNING:** This product can expose you to chemicals including carbon black, which is known to the State of California to cause cancer or birth defects or other reproductive harm. For more information visit [www.P65WARNINGS.ca.gov](http://www.P65WARNINGS.ca.gov)

 **TD** All recommended belts are FDA approved for direct food contact.  
**WARNING:** This product can expose you to chemicals including titanium dioxide, which is known to the State of California to cause cancer or birth defects or other reproductive harm. For more information visit [www.P65WARNINGS.ca.gov](http://www.P65WARNINGS.ca.gov)

 **DI** All recommended belts are FDA approved for direct food contact.  
**WARNING:** This product can expose you to chemicals including DINP, which is known to the State of California to cause cancer or birth defects or other reproductive harm. For more information visit [www.P65WARNINGS.ca.gov](http://www.P65WARNINGS.ca.gov)

 **2M** All recommended belts are FDA approved for direct food contact.  
**WARNING:** This product can expose you to chemicals including 2-Mercaptobenzthiazole, which is known to the State of California to cause cancer or birth defects or other reproductive harm. For more information visit [www.P65WARNINGS.ca.gov](http://www.P65WARNINGS.ca.gov)

GENERAL CONVEYING



Any **P**, **R**, **F**, **SAM**, **WF** or **SWC** series could be used for transfer conveyor belts. If the belt is on an incline Helvie can provide different embossing patterns on the covers to add more grip to the belt. For conveyor systems with knife edge we recommend using **P6/A** (one ply belt) or **P9/A** (two ply belt) both available in blue and white.

ROLLER COVERS



Some equipment uses rollers to compress the dough. In order to avoid the dough sticking to the roller, a wool felt cover is used. Helvie offers wool felt roller covers in both **solid** and **shrinking jacket**. Different thicknesses and diameters can be made per your specifications.

CUSTOM CONVEYOR BELT FABRICATION



Helvie has full fabrication capabilities to make your belt the way you need it. **V-guides**, **sidewall** and **cleats** can be vulcanized directly onto the belt, creating a strong and sanitary (no glue) bond. **Perforations** and **special covers** are also available.

If you need a custom order, please call +1 (585) 247-2841 or email [info@helvieinc.com](mailto:info@helvieinc.com)

## You'll enjoy doing business with Helvie!

We are a diversified local manufacturer and distributor of industrial products. We sell directly into the market, and through selective distribution and OEM.

### Field Services Offered:

#### Conveyor Belt Installations:

Specialized crews equipped with state of the art equipment install belts at your facility.

#### Full Facility Surveys & Analysis:

We'll complete a no obligation, full facility belting survey. Purchase Orders afterwards are always appreciated.

#### Expert Advice:

Unplanned downtime is costly. Helvie's technical sales representatives will assess your challenging applications to identify opportunities to improve, and put in place solutions specific to your application.

### Support your local manufacturers!

Proud member of:



**Andrew Carducci**  
Business Development Manager



C: (716) 290-9562  
E: [andrewc@helvieinc.com](mailto:andrewc@helvieinc.com)



11 Industrial Park Circle  
Rochester, New York 14624

