

# SURFACE VEHICLE STANDARD

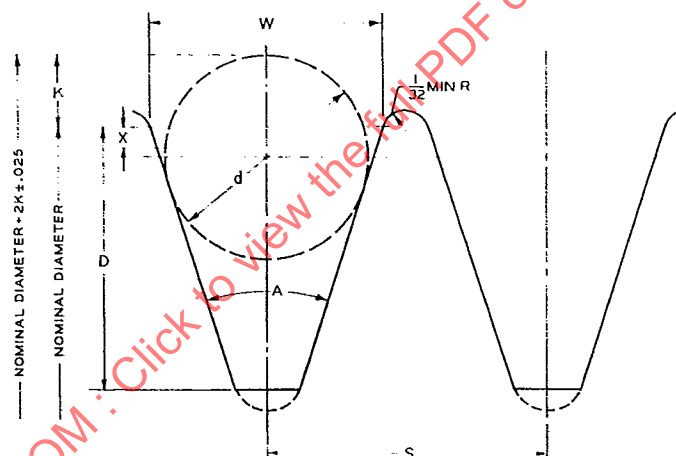
**SAE J636****REV.  
MAY92**Issued 1915-08  
Revised 1992-05-05

Superseding J636 FEB87

Submitted for recognition as an American National Standard

## (R) V-BELTS AND PULLEYS

1. **Scope**—This specification covers standard dimensions, tolerances, and methods of measurement of V-belts and pulleys for automotive V-belt drives.
2. **References**—There are no referenced publications specified herein.
3. **V-Belt Types**—Automotive V-belts are produced in a variety of constructions in a basic trapezoidal shape. The inside circumference of the V-belt can be a plain straight line or corrugated by means of cogs or notches for the purpose of increasing the belt(s) flexibility for use with pulleys in the lower proposed diameter. Belts are to be dimensioned in such a way that they are functional in pulleys dimensioned as described in subsequent sections.
4. **Pulleys**—Pulleys are to conform to requirements of Figure 1 and Tables 1 and 2.



- NOTES:
1. The sides of the groove are to be  $3.2 \mu\text{m}$  ( $125 \mu\text{in}$ ) A. A. maximum.
  2. Radial runout is not to exceed  $0.38 \text{ mm}$  ( $0.015 \text{ in}$ ) full indicator movement (FIM). Axial runout is not to exceed  $0.38 \text{ mm}$  ( $0.015 \text{ in}$ ) FIM. Runout in the two directions is measured separately with a ball mounted under spring pressure to follow the groove as the pulley is rotated. Diameter, load, and overhang conditions may require or permit variations in the above-specified runout limits.
  3. Bottom corner radii optional, but if used, it shall be below the depth,  $D$ .
  4. In pulleys for use with belts in multiple on common centers, the diameters over the ball gages are not to vary from groove to groove in the same pulley more than  $0.05 \text{ mm}/25 \text{ mm}$  ( $0.002 \text{ in/in}$ ) of diameter, with top limit of  $0.30 \text{ mm}$  ( $0.012 \text{ in}$ ) for diameters  $152 \text{ mm}$  ( $6 \text{ in}$ ) and above.
  5. Centerline of groove is to be  $90 \text{ degrees} \pm 2 \text{ degrees}$  with pulley axis.
  6. The  $X$  dimension is radial.  $2X$  is to be subtracted from the effective diameter to obtain "pitch diameter" for speed ratio calculations.

FIGURE 1—V-BELT PULLEY DIMENSIONS

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TABLE 1A—V-BELT PULLEY DIMENSIONS, mm

| SAE Size | Recommended <sup>1</sup> Min Effective Dia | A Groove Angle (deg) $\pm 0.5$ | W Effective Groove Width | D Groove Depth Min | d Ball or Rod Dia ( $\pm 0.013$ ) | 2K 2X Ball <sup>4</sup> Extension | 2X <sup>2</sup> | S Groove <sup>3</sup> Spacing ( $\pm 0.38$ ) |
|----------|--------------------------------------------|--------------------------------|--------------------------|--------------------|-----------------------------------|-----------------------------------|-----------------|----------------------------------------------|
| 6A       | 57                                         | 36                             | 6.3                      | 7                  | 5.558                             | 4.16                              | 1.0             | 8.00                                         |
| 8A       | 57                                         | 36                             | 8.0                      | 9                  | 7.142                             | 5.63                              | 1.3             | 10.49                                        |
| 10A      | 61                                         | 36                             | 9.7                      | 11                 | 7.938                             | 3.77                              | 1.5             | 13.74                                        |
| 11A      | 70                                         | 36                             | 11.2                     | 13                 | 9.525                             | 5.88                              | 1.8             | 15.01                                        |
| 13A      | 76                                         | 36                             | 12.7                     | 14                 | 11.113                            | 7.99                              | 2.0             | 16.79                                        |
| 15A      | 76                                         | 34                             |                          |                    |                                   | 6.42                              |                 |                                              |
|          | Over 102                                   | 36                             | 15.2                     | 14                 | 12.700                            | 7.02                              | 0               | 19.76                                        |
|          | Over 152                                   | 38                             |                          |                    |                                   | 7.56                              |                 |                                              |
| 17A      | 76                                         | 34                             |                          |                    |                                   | 8.21                              |                 |                                              |
|          | Over 102                                   | 36                             | 16.8                     | 15                 | 14.288                            | 8.82                              | 0.5             | 21.36                                        |
|          | Over 152                                   | 38                             |                          |                    |                                   | 9.38                              |                 |                                              |
| 20A      | 89                                         | 34                             |                          |                    |                                   | 11.77                             |                 |                                              |
|          | Over 114                                   | 36                             | 20.0                     | 18                 | 17.463                            | 12.42                             | 1.0             | 24.54                                        |
|          | Over 152                                   | 38                             |                          |                    |                                   | 13.02                             |                 |                                              |
| 23A      | 102                                        | 34                             |                          |                    |                                   | 15.67                             |                 |                                              |
|          | Over 152                                   | 36                             | 23.1                     | 21                 | 20.638                            | 16.33                             | 1.5             | 27.71                                        |
|          | Over 203                                   | 38                             |                          |                    |                                   | 16.94                             |                 |                                              |

<sup>1</sup> Pulley effective diameters below those recommended should be used with caution, because power transmission and belt life may be reduced.

<sup>2</sup> 2X is to be subtracted from the effective diameter to obtain "pitch diameter" for speed ratio calculation.

<sup>3</sup> These values are intended for adjacent grooves of the same effective width (W). Choice of pulley manufacture or belt design parameter may justify variance from these values. The S dimension shall be the same on all multiple groove pulleys in a drive using matched belts.

<sup>4</sup> 2K dimensions are calculated in millimeters.

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TABLE 1B—V-BELT PULLEY DIMENSIONS, In

| SAE Size      | Recommended <sup>1</sup> Min Effective Dia | A Groove Angle (deg) ±0.5 | W Effective Groove Width | D Groove Depth Min | d Ball or Rod Dia (±0.0005) | 2K 2X Ball Extension | 2X <sup>2</sup> | S Groove <sup>3</sup> Spacing (±0.015) |
|---------------|--------------------------------------------|---------------------------|--------------------------|--------------------|-----------------------------|----------------------|-----------------|----------------------------------------|
| 0.250         | 2.25                                       | 36                        | 0.248                    | 0.276              | 0.2188                      | 0.164                | 0.04            | 0.315                                  |
| 0.315         | 2.25                                       | 36                        | 0.315                    | 0.354              | 0.2812                      | 0.222                | 0.05            | 0.413                                  |
| 0.380         | 2.40                                       | 36                        | 0.380                    | 0.433              | 0.3125                      | 0.154                | 0.06            | 0.541                                  |
| 0.440         | 2.75                                       | 36                        | 0.441                    | 0.512              | 0.3750                      | 0.231                | 0.07            | 0.591                                  |
| 0.500         | 3.00                                       | 36                        | 0.500                    | 0.551              | 0.4375                      | 0.314                | 0.08            | 0.661                                  |
| 11/16 (0.600) | 3.00                                       | 34                        | 0.597                    | 0.551              | 0.500                       | 0.258                | 0.00            | 0.778                                  |
|               | Over 4.00                                  | 36                        |                          |                    |                             | 0.280                |                 |                                        |
|               | Over 6.00                                  | 38                        |                          |                    |                             | 0.302                |                 |                                        |
| 3/4 (0.660)   | 3.00                                       | 34                        | 0.660                    | 0.630              | 0.5625                      | 0.328                | 0.02            | 0.841                                  |
|               | Over 4.00                                  | 36                        |                          |                    |                             | 0.352                |                 |                                        |
|               | Over 6.00                                  | 38                        |                          |                    |                             | 0.374                |                 |                                        |
| 7/8 (0.790)   | 3.50                                       | 34                        | 0.785                    | 0.709              | 0.6875                      | 0.472                | 0.04            | 0.966                                  |
|               | Over 4.50                                  | 36                        |                          |                    |                             | 0.496                |                 |                                        |
|               | Over 6.00                                  | 38                        |                          |                    |                             | 0.520                |                 |                                        |
| 1 (0.910)     | 4.00                                       | 34                        | 0.910                    | 0.827              | 0.8125                      | 0.616                | 0.06            | 1.091                                  |
|               | Over 6.00                                  | 36                        |                          |                    |                             | 0.642                |                 |                                        |
|               | Over 8.00                                  | 38                        |                          |                    |                             | 0.666                |                 |                                        |

<sup>1</sup> Pulley effective diameters below those recommended should be used with caution, because power transmission and belt life may be reduced.

<sup>2</sup> 2X is to be subtracted from the effective diameter to obtain "pitch diameter" for speed ratio calculation.

<sup>3</sup> These values are intended for adjacent grooves of the same effective width (W). Choice of pulley manufacture or belt design parameter may justify variance from these values. The S dimension shall be the same on all multiple groove pulleys in a drive using matched belts.

TABLE 2A—MEASURING PULLEY DIMENSIONS, mm

| SAE Size | d <sub>1</sub> Effective Dia (±0.05) | Effective Pulley Circumference | A Groove Angle (deg) ±0.15 | W Effective Groove Width | D Groove Depth Min | d Ball or Rod Dia (±0.013) | d <sub>2</sub> Dia <sup>1</sup> Over Balls or Rods (±0.05) |
|----------|--------------------------------------|--------------------------------|----------------------------|--------------------------|--------------------|----------------------------|------------------------------------------------------------|
| 6A       | 97.03                                | 304.8                          | 36                         | 6.3                      | 7                  | 5.558                      | 101.18                                                     |
| 8A       | 97.03                                | 304.8                          | 36                         | 8.0                      | 9                  | 7.142                      | 102.66                                                     |
| 10A      | 97.03                                | 304.8                          | 36                         | 9.7                      | 11                 | 7.938                      | 100.80                                                     |
| 11A      | 97.03                                | 304.8                          | 36                         | 11.2                     | 13                 | 9.525                      | 102.91                                                     |
| 13A      | 97.03                                | 304.8                          | 36                         | 12.7                     | 14                 | 11.113                     | 105.02                                                     |
| 15A      | 97.03                                | 304.8                          | 34                         | 15.2                     | 14                 | 12.700                     | 103.45                                                     |
| 17A      | 97.03                                | 304.8                          | 34                         | 16.8                     | 16                 | 14.288                     | 105.24                                                     |
| 20A      | 121.29                               | 381.0                          | 34                         | 20.0                     | 18                 | 17.463                     | 133.06                                                     |
| 23A      | 121.29                               | 381.0                          | 34                         | 23.1                     | 21                 | 20.638                     | 136.96                                                     |

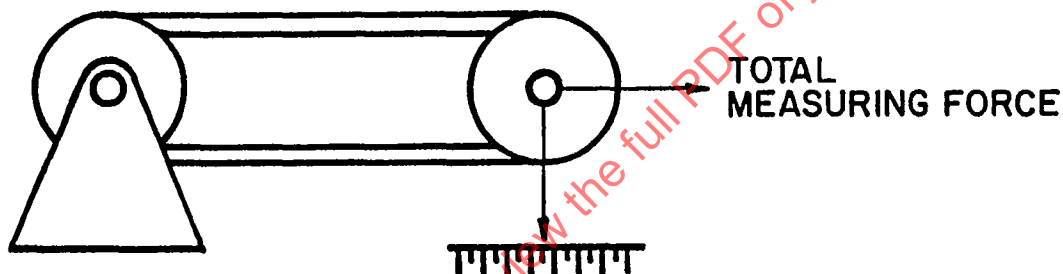
<sup>1</sup> d<sub>2</sub> dimensions are calculated in millimeters.

**5. V-Belt Measurement**—Belt length and SAE size are defined by using effective length and rideout as measured in standard pulleys. These are determined by use of a measuring fixture comprised of two pulleys of equal diameter, a method of applying force, and a means of measuring the center distance between the two pulleys. One of the two pulleys is fixed in position while the other is movable along a graduated scale. The fixture is shown schematically in Figure 2. Specifications for measuring pulley dimensions are given in Table 2 and Figure 3.

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TABLE 2B—MEASURING PULLEY DIMENSIONS, in

| SAE<br>Size<br>US | d <sub>1</sub><br>Effective<br>Dia<br>(±0.002) | Effective<br>Pulley<br>Circum-<br>ference | A<br>Groove<br>Angle<br>(deg)<br>±0.15 | W<br>Effective<br>Groove<br>Width | D<br>Groove<br>Depth<br>Min | d<br>Ball or<br>Rod Dia<br>(±0.0005) | d <sub>2</sub><br>Dia Over<br>Balls or Rods<br>(±0.002) |
|-------------------|------------------------------------------------|-------------------------------------------|----------------------------------------|-----------------------------------|-----------------------------|--------------------------------------|---------------------------------------------------------|
| 0.250             | 3.820                                          | 12.000                                    | 36                                     | 0.248                             | 0.276                       | 0.2188                               | 3.984                                                   |
| 0.315             | 3.820                                          | 12.000                                    | 36                                     | 0.315                             | 0.354                       | 0.2812                               | 4.042                                                   |
| 0.380             | 3.820                                          | 12.000                                    | 36                                     | 0.380                             | 0.433                       | 0.3125                               | 3.974                                                   |
| 0.440             | 3.820                                          | 12.000                                    | 36                                     | 0.441                             | 0.512                       | 0.3750                               | 4.051                                                   |
| 0.500             | 3.820                                          | 12.000                                    | 36                                     | 0.500                             | 0.551                       | 0.4375                               | 4.134                                                   |
| 11/16 (0.600)     | 3.820                                          | 12.000                                    | 34                                     | 0.597                             | 0.551                       | 0.5000                               | 4.078                                                   |
| 3/4 (0.660)       | 3.820                                          | 12.000                                    | 34                                     | 0.660                             | 0.630                       | 0.5625                               | 4.148                                                   |
| 7/8 (0.790)       | 4.775                                          | 15.000                                    | 34                                     | 0.785                             | 0.709                       | 0.6875                               | 5.247                                                   |
| 1 (0.910)         | 4.775                                          | 15.000                                    | 34                                     | 0.910                             | 0.827                       | 0.8125                               | 5.391                                                   |



NOTE—The outside diameter and the effective diameter on the measuring pulley are one and the same.

FIGURE 2—DIAGRAM OF A FIXTURE FOR MEASURING V-BELTS



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TABLE 3B—MEASURING CONDITIONS AND RIDEOUT, U.S. CUSTOMARY UNITS

| SAE Size<br>In | Total<br>Measuring<br>Force, lb | Rideout <sup>1</sup><br>In | Rideout <sup>1</sup><br>Tolerance<br>In |
|----------------|---------------------------------|----------------------------|-----------------------------------------|
| 0.250          | 50                              | 0.031                      | ±0.031                                  |
| 0.315          | 50                              | 0.031                      | ±0.031                                  |
| 0.380          | 60                              | 0.060                      | ±0.045                                  |
| 0.440          | 60                              | 0.040                      | ±0.045                                  |
| 0.500          | 60                              | 0.060                      | ±0.045                                  |
| 11/16 (0.600)  | 60                              | 0.090                      | ±0.045                                  |
| 3/4 (0.660)    | 80                              | 0.090                      | ±0.045                                  |
| 7/8 (0.790)    | 100                             | 0.090                      | ±0.045                                  |
| 1 (0.910)      | 120                             | 0.090                      | ±0.045                                  |

<sup>1</sup> The belt rideout, as measured along the circumference of the belt, must fall within the specified tolerance at all points with the exception of measurements at points of dimension variations inherent to the manufacturing process or product such as material splices, belt identifications, etc.

TABLE 4A—STANDARD BELT CENTER DISTANCE TOLERANCES, mm

| Belt Length           | Tolerance on Center Distance |
|-----------------------|------------------------------|
| 1270 and less         | ±3.0                         |
| Over 1270-1524, incl. | ±4.1                         |
| Over 1524-2032, incl. | ±4.8                         |
| Over 2032-2540, incl. | ±5.6                         |

TABLE 4B—STANDARD BELT CENTER DISTANCE TOLERANCES, In

| Belt Length        | Tolerance on Center Distance |
|--------------------|------------------------------|
| 50 and less        | ±0.12                        |
| Over 50-60, incl.  | ±0.16                        |
| Over 60-80, incl.  | ±0.19                        |
| Over 80-100, incl. | ±0.22                        |

**6.2 Rideout**—The rideout standard and rideout tolerance are shown in Table 3. The rideout of a belt section is determined by measuring from a straight edge across the top of the belt to the rim of the measuring pulley, as shown in Figure 4.

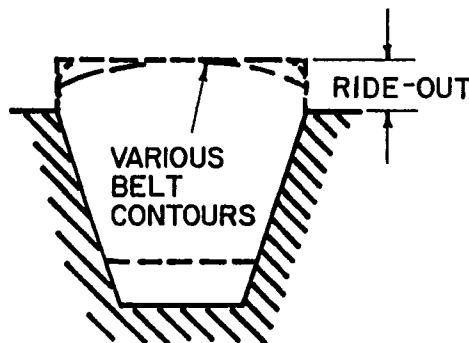


FIGURE 4—MEASURING BELT RIDE