

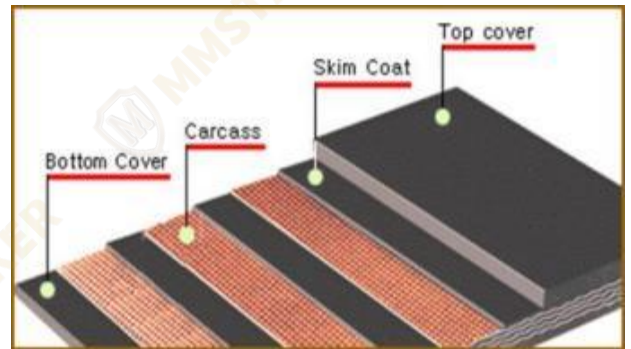
Multi-Ply Fabric Conveyor Belt



Construction

Multi-ply fabric conveyor belt consists of three parts:

- Cover Rubber: top & bottom cover rubber.
- Skim Coat: an extra layer compound between plies.
- Carcass — one or more plies EP or NN fabrics.



It is widely used in the fields of Mine, Ports, Electric Power Plant, Metallurgy, Cement Plant, etc.

Production Flow

Compounding



Calendering



Forming/Vulcanizing



Polyester (EP) Conveyor Belt

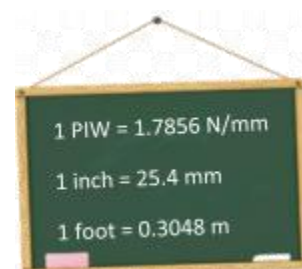
Fabric Type	Fabric Structure		Type	No. of ply	Cover Thickness (mm)		Belt Width
	Warp	Weft			Top	Bottom	
EP	Polyester	Nylon	EP80	2-6	1.5-30	1.5-20	450-5000
			EP100		1.5-30	1.5-20	
			EP125		1.5-30	1.5-20	
			EP150		1.5-30	1.5-20	
			EP200		1.5-30	1.5-20	
			EP250		1.5-30	1.5-20	
			EP300		2-30	2-20	
			EP350		2-30	2-20	
			EP400		2-30	2-20	
			EP500		2-30	2-20	
			EP630		2-30	2-20	

Nylon (NN) Conveyor Belt

Fabric Type	Fabric Structure		Type	No. of ply	Cover Thickness (mm)		Belt Width
	Warp	Weft			Top	Bottom	
NN	Nylon	Nylon	NN 80	2-6	1.5-30	1.5-20	450-5000
			NN 100		1.5-30	1.5-20	
			NN 125		1.5-30	1.5-20	
			NN 150		1.5-30	1.5-20	
			NN 200		1.5-30	1.5-20	
			NN 250		1.5-30	1.5-20	
			NN 300		2-30	2-20	
			NN 350		2-30	2-20	
			NN 400		2-30	2-20	
			NN 500		2-30	2-20	
			NN 630		2-30	2-20	

Recommend Minimum Drive Pulley Diameter

BELT TYPE	Ø DRIVE PULLEY Over 60% to 100% Tension (mm)	BELT TYPE	Ø DRIVE PULLEY Over 60% to 100% Tension (mm)
EP160/2 EP200/2 EP250/2 EP315/2	250	EP 800/3 EP 400/4 EP 500/4 EP 630/4	500
EP400/2	315	EP800/4 EP1000/4 EP800/5	630
EP250/3 EP315/3 EP400/3 EP480/3 EP500/3 EP600/3	400	EP1250/4 EP1000/5 EP1250/5	800



Standard of Cover Rubber

In accordance to international standards, such as DIN22102, RMA, AS1332, SABS 1173/2000, JISK6322, etc.

German Standard

Standard	Cover Rubber			Adhesion		
	Tensile Strength	Elongatio at Break	Abrasion Loss	Cover to Ply	Cover to Ply	Ply to Ply
DIN22102	MPa	%	mm3	N/mm ($\leq 1.5\text{mm}$)	N/mm ($> 1.5\text{mm}$)	N/mm
Z	15	350	250	3.5	4.5	5
Y	20	400	150	3.5	4.5	5
X	25	450	120	3.5	4.5	5
W	18	400	90	3.5	4.5	5

Australian Standard

Standard	Cover Rubber			Adhesion		
	Tensile Strength	Elongation at Break	Abrasion Loss	Cover to Ply	Cover to Ply	Ply to Ply
AS1332	MPa	%	mm3	N/mm ($\leq 1.9\text{mm}$)	N/mm ($> 1.9\text{mm}$)	N/mm
N	17	400	200	4	4.8	6
M	24	450	125	4	4.8	6
E	14	300	-	4	4.8	6
A	17	400	70	4	4.8	6

American Standard

Standard	Cover Rubber			Adhesion		
	Tensile Strength	Elongation at Break	Abrasion Loss	Cover to Ply	Cover to Ply	Ply to Ply
RMA	MPa	%	mm3	N/mm ($\leq 1.6\text{mm}$)	N/mm ($> 1.6\text{mm}$)	N/mm
RMA-I	17	400		3	4.4	4
RMA-II	14	400		3	4.4	4

South African Standard

Standard	Cover Rubber			Adhesion		
	Tensile Strength	Elongation at Break	Abrasion Loss	Cover to Ply	Cover to Ply	Ply to Ply
SANS 1173	MPa	%	mm3	N/mm	N/mm	N/mm
A	18	400	70	5	5	7
C	20	400	150	5	5	7
M	25	450	120	5	5	7
N	17	400	150	5	5	7