

# Multi-Ply Fabric Conveyor Belt



## Construction

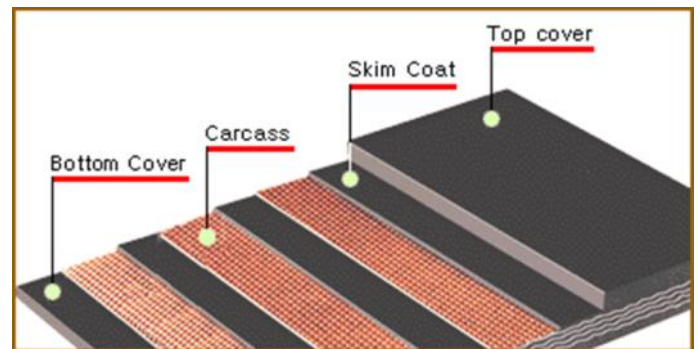
Multi-ply fabric conveyor belt consists of three parts:

**Cover Rubber** — top & bottom cover rubber,

**Skim Coat** — an extra layer compound between plies,

**Carcass** — one or more plies EP or NN fabrics.

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

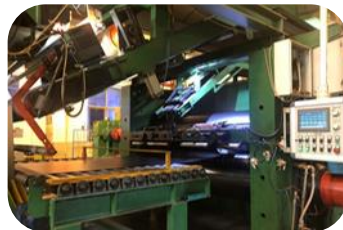


## Production Flow

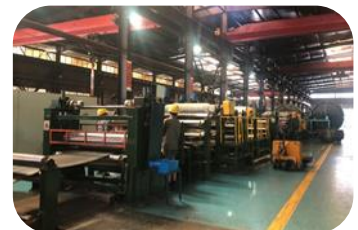
Compounding



Calendering



Forming/Vulcanizing



## Polyester (EP) Conveyor Belt

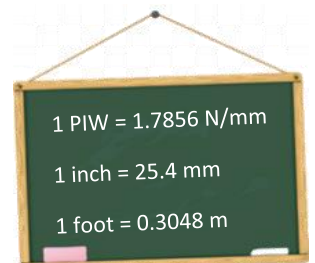
Fabric Type	Fabric Structure		Type	No. of ply	Cover Thickness (mm)		Belt Width
	Warp	Weft			Top	Bottom	
EP	Polyester	Nylon	EP 80	2-6	1.5-30	1.5-20	450-5000
			EP 100		1.5-30	1.5-20	
			EP 125		1.5-30	1.5-20	
			EP 150		1.5-30	1.5-20	
			EP 200		1.5-30	1.5-20	
			EP 250		1.5-30	1.5-20	
			EP 300		2-30	2-20	
			EP 350		2-30	2-20	
			EP 400		2-30	2-20	
			EP 500		2-30	2-20	
			EP 630		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)
EP 160/2 EP 200/2 EP 250/2 EP 315/2	250	EP 800/3 EP 400/4 EP 500/4 EP 630/4	500
EP 400/2	315	EP 800/4 EP 1000/4 EP 800/5	630
EP 250/3 EP 315/3 EP 400/3 EP 480/3 EP 500/3 EP 600/3	400	EP 1250/4 EP 1000/5 EP 1250/5	800



## Standard of Cover Rubber

In accordance to international standards, such as DIN22102, RMA, AS 1332, SABS 1173/2000, JISK6322, etc.

### German Standard

Standard	Cover Rubber			Adhesion		
	Tensile Strength	Elongation at Break	Abrasion Loss	Cover to Ply	Cover to Ply	Ply to Ply
<b>DIN22102</b>	MPa	%	mm <sup>3</sup>	N/mm (≤1.5mm)	N/mm (>1.5mm)	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
<b>AS1332</b>	MPa	%	mm <sup>3</sup>	N/mm (≤1.9mm)	N/mm (>1.9mm)	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
<b>RMA</b>	MPa	%	mm <sup>3</sup>	N/mm (≤1.6mm)	N/mm (>1.6mm)	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
<b>SANS 1173</b>	MPa	%	mm <sup>3</sup>	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