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**Flame retardant conveyor belts of textile construction for
general use**

一般用途织物芯阻燃输送带

(Including Amendment List 1 [2018XG1])

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Flame retardant conveyor belts of textile construction for general use

1 Scope

This Standard specifies the marking, technical requirements, inspection, marks, packaging, storage and transportation for flame retardant conveyor belts of textile construction for general use with rubber coverings (hereinafter referred to as belts).

This Standard applies to flame retardant conveyor belts of textile construction for general use used in chemical, coal, metallurgy and electric power industries.

This Standard applies to flame retardant conveyor belts of textile construction for general use with a working environment temperature of -20°C~45°C.

This Standard does not apply to flame retardant conveyor belts used in coal mines. It is also inapplicable to flame retardant conveyor belts with metal skeletons.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 528, *Rubber, vulcanized or thermoplastic - Determination of tensile stress-strain properties* (GB/T 528-2009, ISO 37:2005, IDT)

GB/T 3512, *Rubber, vulcanized or thermoplastic - Accelerated ageing and heat resistance tests - Air-oven method* (GB/T 3512-2001, eqv ISO188:1998)

GB/T 3684, *Conveyor belts - Electrical conductivity - Specification and test method* (GB/T 3684-2006, ISO 284:2003, IDT)

GB/T 3685, *Conveyor belts - Laboratory scale flammability characteristics - Test method* (GB/T 3685-2009, ISO 2340:2004, IDT)

GB/T 3690, *Textile conveyor belts - Full thickness tensile strength, elongation at break and elongation at the reference load - Test method* (GB/T 3690-2009, ISO 283:2007, IDT)

GB/T 4490, *Conveyor belts with textile carcass - Widths and lengths* (GB/T 4490-2009, ISO 251:2003, IDT)

GB/T 5752, *Conveyor belts - Marking* (GB/T 5752-2013, ISO 433:1991, MOD)

GB/T 6759-2013, *Conveyor belts - Adhesion between constitutive elements - Test methods* (ISO 252:2007, IDT)

GB/T 7983, *Conveyor belts - Transverse flexibility (troughability) - Test method* (GB/T 7983-2013, ISO 703:2007, MOD)

GB/T 9867-2008, *Rubber, vulcanized or thermoplastic - Determination of abrasion resistance using a rotating cylindrical drum device* (ISO 4649:2002, IDT)

HG/T 2194, *Canvas conveyor belt plies joint provision* (HG/T 2194-2006, ISO 432:1989, MOD)

HG/T 3046, *Conveyor belts with fabric carcass - Specification for appearance quality*

HG/T 3056, *Conveyor belts - Guidelines for storage and handling* (HG/T 3056-2006, ISO 5285:2004, IDT)

ISO 583, *Conveyor belts with a textile carcass - Total belt thickness and thickness of constitutive elements - Test methods*

ISO 16851, *Textile conveyor belts - Determination of the net length of an endless (spliced) conveyor belt*

3 Marking

3.1 Belt marking according to the following conveyor belt properties

- a) Refer to this Standard, namely GB/T 10822;
- b) Required length, in meters (m);
- c) Required width, in millimeters (mm);
- d) Fiber type of core warp and weft, for example, polyester (E) (warp) nylon (P) (weft), (EP);
- e) Through-thickness tensile strength, in Newtons per millimeter (N/mm) (see Table 3);
- f) Number of layers or type of conveyor belt;
- g) Thickness of the upper covering layer, in millimeters (mm);
- h) Thickness of the lower covering layer, in millimeters (mm);

For conveyor belts made of synthetic fiber fabrics, type B specimens shall be used. For conveyor belts containing natural fiber fabrics as belt cores, type C specimens shall be used.

5.9 The interlayer adhesive strength of the belt shall be tested according to the provisions of Method A in GB/T 6759-2013.

5.10 The combustion performance of the belt shall be tested according to the provisions of GB/T 3685.

5.11 The electrostatic conductivity of the belt shall be tested according to the provisions of GB/T 3684.

5.12 The troughability of the belt shall be tested according to the provisions of GB/T 7983.

5.13 Belt straightness measurement: Unfold the belt on a flat surface. Straighten a 7m long wire along any part of the belt edge, so that the ends of the wire are on the edge of the belt. The maximum vertical distance from the measured belt edge to the straight line is the straightness. Pull a 5m-long wire with a belt width not greater than 500mm or a belt length not greater than 20m.

6 Inspection rules

6.1 Inspection items

6.1.1 During the exit-factory inspection, the length, width, total thickness, entire thickness tensile strength and elongation of the belt, physical properties of the covering layer (excluding aging properties), interlayer bonding strength, straightness and safety performance shall be inspected.

6.1.2 Type inspection shall not be less than once a year during normal production. When major changes occur, type inspection shall be carried out. Inspect all technical requirements specified in Chapter 4 (except 4.10).

6.2 Sampling

The sampling quantity is shown in Table 9. The length of each sample is not less than 450mm. The width is the full width of the belt.

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