





## 生产和检测设备

## PRODUCTION AND INSPECTION EQUIPMENTS



全自动称量系统  
Automatic weighting system



智能型全自动密炼生产线  
Automatic mixing center



Gk270 密炼机  
GK270Mixing machine



输送带生产线  
Belt product line

Zhejiang Tianji Rubber&Plastic Co., Ltd.(Established by Zhejiang Tianji Rubber Co., Ltd. Zhejiang Tianji Mixing Rubber Co., Ltd., and Zhejiang Tianji Trading Co., Ltd.) is located in the East of the National "AAAAA" Grade Scenery--The Tiantai Mountain, adjacent to Shangsang Highway and enjoys convenient transportation. Our company was established in 1998. It covers eighty thousand square meters and has one hundred thousand square meters of building parts. Zhejiang Tianji Rubber&Plastic Co., Ltd. Has eight sets of common conveyor belt production lines and three sets of steel cord conveyor belt production lines. Now, Zhejiang Tianji Rubber&Plastic Co., Ltd. Can produce the conveyor belt with 400mm--2800mm in width. Our main products include: Standard(Common)type; High strength type(NN, EP and steel cord); Chemical resistant type; Heat resistant type; High temperature resistant type; Cold resistant type; Anti-tear type and etc. Our company can produce 15 million square meters of rubber conveyor belts each year. We have two sets of domestic advanced automatic mixed rubber system Gk270 production line which can produce 50000 tones mixed rubber per year. Our company also has sets of Vee belt production lines. The annual production capability is thirty-eight million square meters.

Our company has abundant technology capability, complete equipments. And our company's production is under the National Standard strictly. The products performance is in better stabilization and quality. Our corporation has continuously been evaluated and awarded the enterprise with the title of top commercial credibility-- "AAA" for 8 years by the Governmental Agencies. We had obtained the certificate of ISO9001 Quality System in 2000. Our products not only sell well to thousands of Chinese clients, but also export to abroad including Southeast Asia, Western Europe, the United States and Canada. Our company's developing tenet is to keep better quality and better reputation.

Our company's developing aim is to create a popular brand, and increase the share of the international Market. We will always be honest and warm with our customers.







检测室 Inspection Room



磨耗试验机  
Abrasion testing machines



可塑性试验机  
Plasticity testing machines



电子拉力机  
Electronic tensile testing machines



智能硫化仪  
Automatic vulcanization instruments



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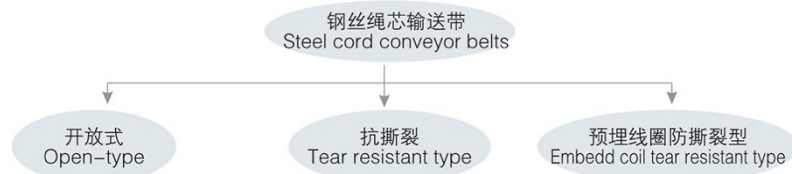
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# 钢丝绳芯输送带

## » STEEL CORD CONVEYOR BELT

### ▲ 分 类 Classification



### ▲ 用 途 Uses

可广泛应用于煤炭、矿山、港口、冶金、电力、化工等领域实现长距离、大运量、高速度输送物料。

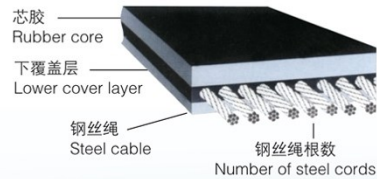
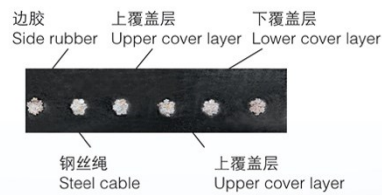
Extensive applications in coal, mining, port, metallurgy, power, chemical sectors for long-distance, large amount and high-speed conveying of materials.

### ▲ 结 构 Structure

由纵向均匀排列左、右交互捻的开放式镀锌钢丝绳与粘合性能优异的芯胶组成带芯，上、下边部覆以橡胶层，形成带体。

The longitudinally uniformly arranged and left-right twisted zincification steel cable and plastic core form the cord which is covered with rubber to form the belt.

### ▲ GX 系列 GX Series



## St 系列钢丝绳芯输送带主要技术参数

### ▲ Main technical index of ST series steel cord conveyor belt

带的强度规格 Strength of the belt specifications	ST 630	ST 800	ST 1000	ST 1250	ST 1600	ST 2000	ST 2500	ST 3150	ST 3500	ST 4000	ST 4500	ST 5000	ST 5400	ST 6300
技术要求项目 Items required														
纵向拉伸强度 N/mm Longitudinal tensile strength	630	800	1000	1250	1600	2000	2500	3150	3500	4000	4500	5000	5400	6300
钢丝绳最大公称直径 mm Maximal nominal diameter of the steel wire mm	3.0	3.5	4.0	4.5	5.0	6.0	7.2	8.1	8.6	8.9/9.1	9.7	10.9	11.3	12.3
钢丝绳间距 mm Space between cord	10	10	12	12	12	12	15	15	15	15/17	16	17	17	18
上覆盖层的厚度 mm Top cover thickness mm	5	5	6	6	6	8	8	8	8	8/8	8	8.5	9	10
下覆盖层的厚度 mm Bottom cover thickness mm	5	5	6	6	6	6	6	8	8	8/8	8	8.5	9	10
胶带参考质量 kg/m <sup>2</sup>	18	19.5	21.5	22.2	26.1	33.1	35.3	41.1	45	45/45	51	59	62	65

宽度规格 mm Width specifications mm	钢丝绳根数 Number of steel cords													
800	75	75	63	63	63	63	50	50						
1000	95	95	79	79	79	79	64	64	64	64/56	59	55	55	54
1200	113	113	94	94	94	94	76	76	77	77/68	71	66	66	63
1400	133	133	111	111	111	111	89	89	90	90/79	84	78	78	74
1600	151	151	126	126	126	126	101	101	104	104/91	96	90	90	85
1800		171	143	143	143	143	114	114	117	117/108	109	102	102	96
2000			159	159	159	159	128	128	130	130/114	121	113	113	107
2200						176	141	141	144	144/125	134	125	125	118
2400						193	155	155	157	157/137	146	137	137	129
2600						209	168	168	170	170/148	159	149	149	140
2800									184	184/160	171	161	161	151

说明：输送带单卷长度 100M-350M，受厚度、宽度、运输、安装等条件限制，卷长度由供需双方确定。

※ 胶带质量根据覆盖厚度、密度变化。

※※ St4000 有两种钢丝绳间距供用户选择。

NOTE: the length of the conveyor belt is 100 meters to 350 meters. The length is settled by the exporter and the importer in accordance with the thickness, width, transportation and installation.

※ Rubber belt quality based on the cover thickness and density change.

※※ St4000 provides two steel wire intervals for your alternative.



## GX 系列钢丝绳芯输送带主要技术参数

### ▲ Main technical index of GX series steel cord conveyor belt

带的规格 Strength of the belt specifications	GX 630	GX 800	GX 1000	GX 1250	GX 1600	GX 2000	GX 2500	GX 3000	GX 3500	GX 4000	GX 4500	GX 5000	GX 5500	GX 6000
带厚度 Items required	6+7+6	6+7+6	6+7+6	6+7+6	7+9+7	6+7+6	8+11+8	8+12+8	8+12+8	8+13+8	8+14+8	8+14+8	8+16+8	8+16+8
纵向拉伸强度 N/mm Longitudinal tensile strength	630	800	1000	1250	1600	2000	2500	3000	3500	4000	4500	5000	5500	6000
钢丝绳最大公称直径 mm Maximal nominal diameter of the steel wire mm	4.5	4.5	4.5	4.5	6.0	6.0	7.2	8.3	8.7	9.1	9.7	10.9	11.3	12.3
钢丝绳间距 mm Space between cord	20	17	13.5	11	20	16	17	18	18	17	16	17	17	18
胶带厚度 mm Stresgtg of the belt	19	19	19	19	23	23	27	28	28	29	30	30	32	32

宽度规格 mm Width specifications mm	钢丝绳根数 Number of steel cords													
800	38	45	56	69	38	47	44	43						
1000	48	56	70	87	48	60	56	53	53	56	60	56	56	54
1200		68	86	104	58	72	68	64	64	68	72	68	68	63
1400			100	122	66	84	78	74	74	79	84	79	79	74
1600			116	140	76	95	90	86	86	90	96	91	91	85
1800			127	157	86	108	102	96	96	101	107	103	103	96
2000			142	173	96	120	113	107	107	113	120	114	114	107
2200						132	125	118	118	125	133	125	125	118
2400						146	177	129	129	137	146	137	137	129
2600						158	148	140	140	148	158	148	148	151
2800						170	160	151	151	160	170	160	160	140

注：可以按照 DIN22131、AS1333、JISK6369 标准生产各种性能输送带

Attention: We can produce all kinds of performance conveyor belt under DIN22131, AS1333, JISK6369 standards and so on...

## 推荐使用的输送机最小辊筒直径

### ▲ Reco mmdend minimum roller diameter of the conveyor

#### ST 系列 Stseries

胶带型号 Rubber type	ST 630	ST 800	ST 1000	ST 1250	ST 1600	ST 2000	ST 2500	ST 3150	ST 3500	ST 4000	ST 4500	ST 5000	ST 5400	ST 6300
最小辊筒直径 Minimum roller diameter mm	500	500	630	800	1000	1000	1250	1400	1600	1600	1600	1800	1800	1800

#### GX 系列 Gxsertype

胶带型号 Rubber type	GX 630	GX 800	GX 1000	GX 1250	GX 1600	GX 2000	GX 2500	GX 3150	GX 3500	GX 4000	GX 4500	GX 5000	GX 5500	GX 6000
最小辊筒直径 Minimum roller diameter mm	800	800	800	800	1000	1000	1250	1400	1600	1600	1600	1800	2000	2000

## 抗撕裂型钢丝绳芯输送带

### » TEAR RESISTANT TYPE STEEL CORD CONVEYOR BELT

#### ▲ 结构 Structure

该种输送带在国外通常被称为横向增强型输送带，其结构为在钢丝绳芯的一面或两面，增设横向增强材料。

抗撕裂层可根据用户需求选择：

- ◎进口世界最大的帆布制造公司德国 OLBO 公司的线绳防撕裂网。
- ◎采用美国杜邦技术，引进美国杜邦公司 KEVLAR 纤维（芳纶）编制的芳纶线绳。
- ◎抗冲击能力较好的聚酯线绳。
- ◎进口比利时钢丝绳帘网。
- ◎抗撕裂钢丝绳。

This kind of conveyor belt is usually called horizontal enhanced conveyor belt featuring transversely reinforced materials on one or both sides of steel cord.

◎ Tear resistant web made by German OLBO, the world leading canvas manufacturer.

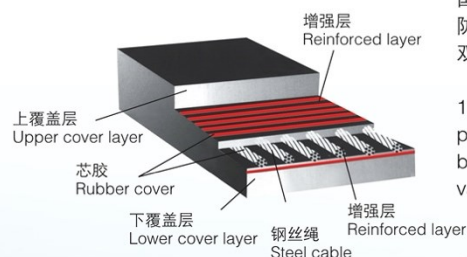
- ◎ Using wires made of Dupont's KEVLAR fabric.
- ◎ Polyester wires feature excellent impact-resistance.
- ◎ Steel wire cord made in Belgium.
- ◎ Tear-resistant steel wire.

#### ▲ 特点 Features

提高抗冲击性和防撕裂能力  
Increase the impact and tear resistance

执行标准：HG/T3646-1999（中国），DIN22129（德国、聚酯线绳增强防撕裂带），客户如有其他要求，供需双方可协商确定。

Executive Standard: HG/T3646-1999(China), DIN22129(German, polyester wire reinforced tear-resistant belt). Customized specification is variable.



## 预埋线圈防撕裂输送带

### » EMBEDDED COIL TEAR-RESISTANT CONVEYOR BELTS

#### ▲ 结构 Structure

在输送带覆盖胶和骨架层之间沿纵向按一定距离埋设移相传感器（线圈）。

Phase sensors (coil) are embedded in certain interval between the cover layer and skeleton of conveyor belt longitudinally.

#### ▲ 特点 Features

◎ 微机智能控制，具有记忆、显示线圈间距、线圈个数、断裂线圈位置的功能，通过检测控制装置，当输送带发生撕裂事故时，线圈断裂，检测控制装置发生声光报警信号，并发出停机命令停机，不使撕裂事故扩大，减少损失。

◎ 防止异常运行，发现运行异常如速度过快或过慢则自动停机，避免输送带打滑或其他事故发生，保护输送机。

◎ 防止跑偏，如果跑偏过大，则自动停机。

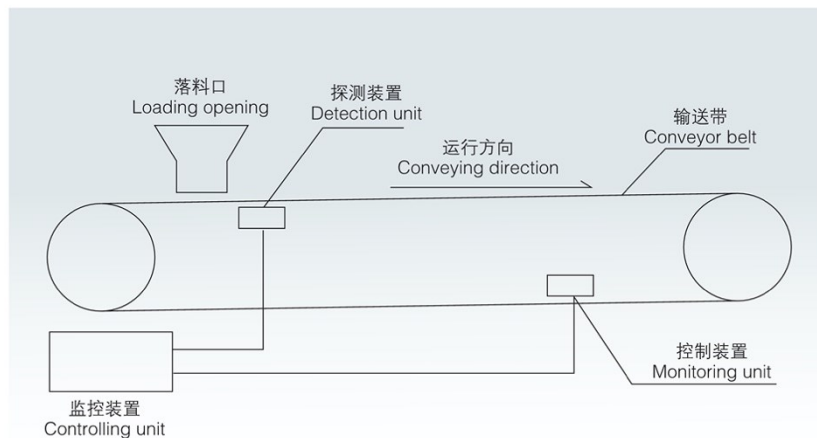
◎ 测量输送带运行速度，输送带长度，计量运行里程，工作时间等功能。

◎ Featuring micor-computer controlled, memory and indication of coil interval, number, and the position of broken coil. In case of breaking of belt, the coil will break and activate the detector to send sound / light alarm signal and give instruction to stop the machine, so as to prevent expanding of accident and reduce the loss.

◎ Prevent a abnormal running, In case of over or under speed, the unit will auto stop working to prevent wheel spin or other accident.

◎ Prevent off tracking, If tracking too much, it will stop automatically.

◎ Measure the running speed, operating time, total mileage and length of belt.





## 阻燃钢丝绳芯输送带

### » FIRE-RESISTANT STEEL CORD CONVEYOR BELT

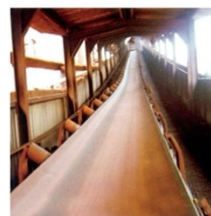
#### ▲ 特性及用途 Characteristics and uses

阻燃钢丝绳芯输送带具有钢丝绳芯输送带的高强度、长距离、大运量场合下输送物料的优点外，还具有阻燃、导静电性能，适合于阻燃、防爆场合下的物料输送，尤其适合在矿井下的物料输送。

Fire-resistant steel cord conveyor belt has the merits of conveying materials at the occasion of high strength, long distance, and large load as common steel cord conveyor belt. However, it also has the properties of fire-resistant and anti-static, and it is suitable for fire resistant and anti-explosion applications, especially suitable for conveying materials under coalmine wells.

#### ▲ 覆盖层性能及级别 Cover property and grade

拉伸强度	Tensile strength: $\geq 15\text{mpa}$
扯断伸长率	Elongation at break: $\geq 350\%$
老化试验	After aging( $70^{\circ}\text{C} \times 168\text{h}$ )
拉伸强度变化率	Change rate of tensile strength: $-25\sim+25\%$
拉伸伸长率变化率	Change rate of elongation at break: $-25\sim+25\%$
磨损量	Abrasion $\leq 200\text{mm}^3$



#### ▲ 安全性能 Safety property

项目 Items		指标 Indexes	
导静电 Anti-static property	带的上、下两面的电阻平均值 Average electrical resistance of both surfaces		
滚动摩擦 Drum friction	滚筒表面温度 Surface temperature of drum		
	试样无任何明焰与无焰燃烧 Any test piece shall not any sign of flame or glow		
酒精喷灯燃烧 (有焰或无焰燃烧) Burning on spirit burner (flame or glow)	完整覆盖层燃烧 Burning with cover rubber	6 个试样自熄时间平均值 Average duration of flame for six test pieces	≤ 3S
		任一 个试样自熄时间单个值 Duration of flame for any individual test piece	≤ 10S
	剥去覆盖层 Burning without cover rubber	6 个试样自熄时间平均值 Average duration of flame fox six test pieces	≤ 5S
		任一 试样自熄时间单个值 Duration of flame for any individual test piece	≤ 15S
丙烷燃烧器燃烧 Burning on propane burner	完全未烧坏长度 Length that is completely undamaged by flame		

其它技术指标按 MT668-1997 执行。  
Other technical indexes will follow specification MT668-1997.

## 耐高温输送带

### » HIGH TEMPERATURE RESISTANT CONVEYOR BELT

#### ▲ 产品特点 Characteristics

本产品带芯采用高模量、低收缩、扯断强度极高的聚酯帆布。覆盖胶选用耐高温性能很好的三元乙丙胶或氯化丁基橡胶，并配合耐高温材料进行复合成型、硫化等工序精制而成。

该产品带芯经过特殊浸渍定型处理后，粘合强度高，在 180℃以下正常使用条件下，伸长变形小，磨损性能优异。在短时间内可承受 250℃高温，适用于水泥、焦化、冶金、钢铁等工业使用。

The belt carcass is made of EP fabric which select high modulus, low shrink, and high breaking tensile strength canvas cover rubber of this product uses EPDM rubber or chlorobutadiene rubber that has very good high temperature resistance, The belt is made with mixing rubber with high temperature resistant materials after assembling and vulcanizing.

The carcass of this product has very high adhesion after the special treatment of coating and shaping, Under normal working temperature of below 180℃, the belt is low in elongation, excellent in anti-abrasion, and can bear 250℃ high temperature for a short time. The belt is suitable for use in cement, metallurgical and steel industry.



#### 耐高温输送带型号及规格

#### ▲ Types and specifications of high temperature-resistant conveyor belt

织物类型 Fabric type	织物型号 Fabric type	强度系列 (n/mm) Strength series					覆盖胶厚度 cover rubber thickness		宽度范围 Width mm	带长 Length m
		2层 2ply	3层 3ply	4层 4ply	5层 5ply	6层 6ply	上覆盖胶 upper	下覆盖胶 lower		
聚酯 Polyester (EP)	EP-80	160	240	320	400	480	4.5-10	0-4.5	400-2500	≤ 300
	EP-100	200	300	400	500	600				
	EP-150	300	450	600	750	900				
	EP-200	400	600	800	1000	1200				
	EP-250	500	750	1000	1250	1500				
	EP-300	600	900	1200	1500	1800				
	EP-400	800	1200	1600	2000	2400				
	EP-500	1000	1500	2000	2500	3000				

## 一般难燃输送带

### » COMMON FLAME RESISTANT CONVEYOR BELT

#### ▲ 特性及用途 Characteristics and uses

本产品由全棉帆布、尼龙帆布、聚酯帆布、经过压延、成型、硫化等工序精制而成、该产品适合于煤矿井上等易燃环境下输送非腐蚀性的无尖刺的块状、粒状、粉末状的多物料，如煤炭等散料或成件物品。

The product is made of cotton canvas, nylon canvas or EP canvas and finished through the processes of pressing, Shaping, vulcanizing and etc. It is suitable for conveying various non-corrosive and thornless materials in blocks, in grains, or in powder, such as coal in bulk or in bales, under the condition of easily burn or easily explosive environment above coal mine wells.



#### ▲ 覆盖层性能 Cover rubber's characteristics

拉伸强度 Tensile strength	拉断伸长率 Elongation at break%
Mpa $\geq 10$	$\geq 350$

#### ▲ 安全性能 Safety property

难燃性能 J Flame resistant Property	难燃且防静电性能 K Flame resistant and anti-static electricity property
三个纵向全厚度试样的火焰持续时间的平均值不大于 60S 且任何一个单次结果均无复燃现象。 Average value of duration of flame of three full thickness test pieces dose not exceed 60s and there is no reappearance of flame for any individual test result.	难燃性能要求同 J，防静电性能：不大于 $3 \times 10^8 \Omega$ The flame retardant property is the same as j, and anti-static property shall not exceed $3 \times 10^8 \Omega$



## 耐热输送带

### » HEAT RESISTANT CONVEYOR BELT

#### 产品特点 Characteristics

该产品带芯选用全棉帆布、聚酯帆布作骨架材料，覆盖胶和缓冲胶采用耐热性能好的丁苯橡胶或氯化丁基橡胶。该产品可在 120℃以下的温度下正常使用，适用于输送温度在 120℃以下的物料。广泛适用于水泥、焦化、冶金、钢铁等工业使用。

1. 规格同普通输送带。
2. 耐热输送带可分为三种型号：  
I 型：可耐不大于 100℃的试验温度，代号 T1  
II 型：可耐不大于 125℃的试验温度，代号 T2  
III 型：可耐不大于 150℃的试验温度，代号 T3  
IV 型：可耐不大于 175℃的试验温度，代号 T4

The carcass of the product selects cotton canvas or EP canvas as skeleton material. Cover rubber and cushion rubber is styrene-butadiene rubber or chlorobutadiene that has good heat-resistant. The product can work under the temperature of 120℃. Heat-resistant conveyor belt widely used in industries of metallurgy, cement, coking, steel, and etc.

1. Specification as same as common conveyor belt.
2. Heat-proof conveyor belts are categorized in three models.  
Mode I : able to withstand the test temperature of less 100℃ , code T1  
Mode II : able to withstand the test temperature of less 125℃ , code T2  
Mode III : able to withstand the test temperature of less 150℃ , code T3  
Mode IV : able to withstand the test temperature of less 175℃ , code T4

#### 覆盖胶耐热试验后的物理性能符合表中规定

The physical performance of cover rubber after heat-proof test conform to the specification in the table

项目 Index		型号 ( Mode )			
		I 型 (Mode I )	II 型 (Mode II )	III 型 (Mode III )	IV 型 (Mode IV )
		变化范围 ( variation range )			
硬度	老化后于老化前之差 ( IRHD ) Difference after and before aging ( IRHD )	20		± 20	± 20
	老化后的最大值 ( IRHD ) Maximum after aging ( IRHD )				
拉伸强度 Tensile strength	性能变化率降低% ≤ Decrease of performance variance rate% ≤	-25	-30	-40	-40
	老化后的最低值 Mpa Maximum after aging Mpa	12	10	5	5
拉断伸长率 Elongation at break	性能变化率% Performance variance rate%	-50		-55	-55
	老化后和最低值% Maximum after aging%	200		180	180

## ▲ 层间粘合强度 Adhesion of inter layer

指标项目 Index	布层间 Between faberic layers	覆盖层与带芯间 Between cover layer and belt core	
		覆盖层厚度 0.8-1.5mm cover layer thickness 0.8-1.5mm	覆盖层厚度 > 1.5mm cover layer thickness > 1.5mm
全部试样平均值, N/mm, 不小于 Average of all test samples, N/mm, no less than	3.0	2.2	2.6
全部试样最低峰值, N/mm, 不小于 The lowest data of all test samples, N/mm, no less than	2.0	1.6	2.0



## 耐油输送带

### » OIL RESISTANT CONVEYOR BELT

#### ▲ 产品特性及用途 Product characteristics and uses

本产品由全棉帆布、尼龙帆布、聚酯帆布，经过压延、成型、硫化等工序精制而成。该产品适用于输送油性物料。

The product is made of Cotton canvas, nylon canvas or EP canvas and finished through the processes of pressing, shaping, vulcanizing and etc. It is suitable for conveying oil materials.

#### ▲ 技术指标 Technical index

- 耐油输送带根据覆盖胶性能分为耐磨型 (D) 一般型 (L) 二种类型
- 耐油性性能分为 Y1 和 Y2 两种级别
  - Oil resistant conveyor belt have two types according to cover properties; Anti-abrasive type(D), and Ordinary type(L).
  - According to oil resistance, it have into two types of Y1 and Y2.

## 耐寒输送带

### » COLD-PROOF CONVEYOR BELT

#### 产品特点 Characteristics

选用棉帆布、尼龙帆布或聚酯布做带芯，覆盖胶采用天然橡胶与顺丁橡胶的并用胶，具有弹性高，耐冲击、耐寒等特点，能在零下 40℃ 的环境下正常使用。

Select cotton canvas, nylon canvas or polyester canvas as belt core, select natural and butadiene rubber combinations as cover rubber. It is characterized by high elasticity, impact-proof and cold-proof. It can work under the temperature of -40℃.

#### 用途 Uses

适用于寒冷地区露天或冷冻仓库等场合输送物料。

It is suitable for conveying materials outdoor or in freezing garage in cold regions.

#### 技术指标 Technical index

1. 耐寒输送带根据覆盖胶性能分为耐划裂型 (H)、耐磨损型 (D)、一般型 (L) 三种类型。

2. 根据耐寒性能分为 S1 和 S2 两种级别。

◎ 使用环境湿度为 -45℃ ~ +50℃    ◎ 使用环境湿度为 -60℃ ~ +50℃

1. Cold-proof conveyor belts have three types, named

(a) crack-resistant

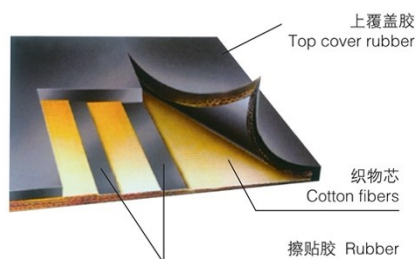
(b) abrasion-resistant

(c) common types according to the characteristics of cover rubber

2. According to cold-proof performance, this kind of belt is categorized into two grades S1 and S2.

◎ It can use under the temperature between -45℃ and +50℃ ;

◎ the ambient temperature is -60℃ -50℃ .





## 耐酸、耐碱输送带

### » ANTI-ACID AND ANTI-ALKALI CONVEYOR BELT

#### 产品特点 Characteristics

选用棉帆布、尼龙帆布或聚酯帆布做带芯带体弹性好、成槽性能好，使用伸长率小。  
 选用耐酸碱的材料加工制成覆盖胶，具有良好的抗化学腐蚀性能和良好的物理性能。  
 The belt core is made of cotton canvas, nylon canvas or polyester canvas, with good elastic belt body and good grooving performance and little elongation rate.  
 The cover rubber is made of acid and alkali resistant material, with erosion resistance and physical characteristics.

#### 用途 Uses

适用于化工厂、化肥厂、造纸厂等厂矿企业输送含有酸性或碱性等腐蚀性的物料。  
 It is suitable for conveying acid and alkali materials Used in chemical works, fertilizer and paper-making factories.



#### 技术指标 Technical index

	项目 Items	单位 unit	指标 Index
覆盖层性能 Performance of cover layer	拉伸强度 Tensile strength	Mpa	>14
	扯断伸长率 Elongation at break	%	>400
	磨耗量 Abrasion loss	mm <sup>3</sup>	≤ 250
	50%H <sub>2</sub> SO <sub>4</sub> 50°C × 96h		>0.7
粘合强度 Adhesion	覆盖层与布层间 Between cover layer and fabric layer	N/mm	>2.7
	布层间 Between fabric layers	N/mm	>2.7

## 管状输送带

### » PIPE CONVEYOR BELT

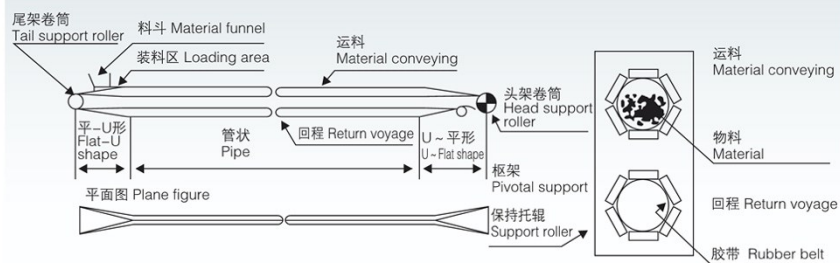
#### 产品特点 Characteristics

管状输送带是以芯体（聚酯帆布、钢丝绳等）为骨架，以高弹性、高耐磨、高强度橡胶为工作面组成的新型运输产品，主要用于输送粉状、颗粒状等易污染环境的物料。工作时胶带由平面渐变成U形，最后成为管状，将物料包住，实现封闭输送。

Pipe conveyor belt is a new type of conveying belt which selects belt carcass (EP fabric, steel cord, etc). As skeleton, selects high elastic, high anti-abrasion and high strength rubber as working surface. They are mainly used in conveying powdery and conveying powdery and easily pollute the environment. When working, the rubber belt changes its form flat to U shape and finally to pipe shape, fold the materials and realize the process of enclosed conveying.

#### 主要特点 Product characteristic

1. 密闭输送物料，物料环境双向保护。
2. 大倾角输送，输送倾角通常可达30度。
3. 输送线路可按空间曲线布置。
1. Enclosed convey materials, protect both the materials and the environment.
2. For conveying in a big angle, the angel usually can reach to 30° .
3. Convey line can be arranged according to the curve room.



## 花纹输送带

### » PATTERNED CONVEYOR BELT

#### ▲ 产品特点 Characteristics

倾角 0–45° 防止物料下滑，提高输送能力

1. 材质可选用棉帆布、尼龙帆布、涤棉帆布

2. 品种：人字型花纹、圆柱型花纹

3. 生产宽度：300–1000mm，层数 3–10 层

品种：根据覆盖胶性能不同分为普通、耐油、耐酸碱、耐热等。

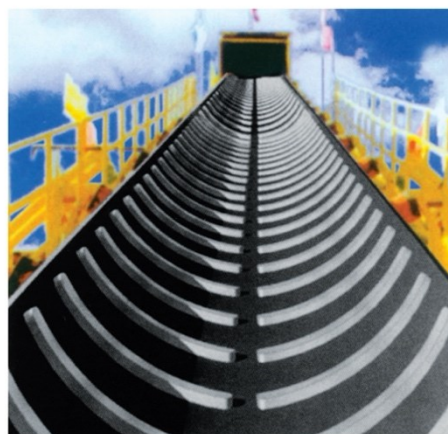
To slope 0–45° to prevent materials from falling off, and to improve the capability of the belt.

1. The material select cotton canvas, nylon canvas or polyester canvas.

2. Category: herringbone pattern, column pattern.

3. Production width: 300–1000mm, layers: 3–10 layers.

Category: there are common, heat-proof, acid and alkali resistant and oil-resistant belts, categorized according to the characteristics of cover rubber.



## 环形输送带

### » RING-TYPE CONVEYOR BELT



麻点花纹输送带  
Pattern endless conveyor belt

我公司生产环形输送带带芯采用单条骨架织物缠绕成型，整体无接头。定型硫化出的环形带，带体两端周长尺寸标准，无喇叭口，皮带上机不跑偏。覆盖胶采用高强度耐磨橡胶配方，使用寿命长，带体厚度均匀，平面光滑、运行平稳，计量准确。

Fabric: Twining, no joint.

Rubber cover: Abrasion Resistant Rubber Cover, Long-life.

Endless Belt: Clean and Smooth Surface, Accurate Measurement.

## 挡边输送带

### » CONVEYOR BELTS WITH CORRUGATED SIDEWALL

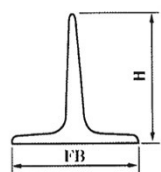
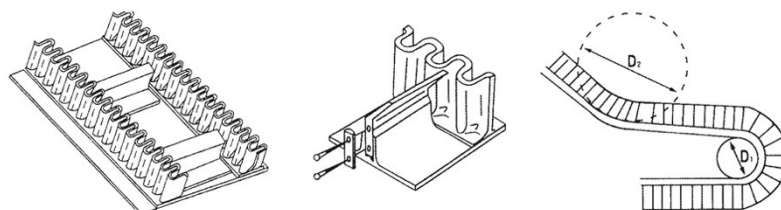
适用于倾角  $0^{\circ} \sim 90^{\circ}$  散装物料的输送，具有倾角大、使用范围广、占地面积小、输送量大等特点；解决了普通输送带和花纹输送带所不能达到的输送角度；基带：大倾角波状挡边输送带骨架材料采用涤棉浸胶帆布（EP 帆布、钢绳芯）和横向刚性加强层；在带体内加入横向刚性加强层，解决了大规格挡边输送带的塌带问题。基带、挡边、隔板的采用二次同步低温连续硫化的先进工艺，提高了粘合强度，并避免因多次高温硫化而老化基带。



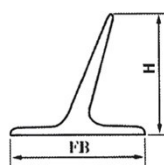
Applicable inclination  $0^{\circ} \sim 90^{\circ}$  conveying bulk materials, with a tilt angle, using a wide range of small footprint, transmission capacity and other characteristics; Get the delivery point which ordinary conveyor belt and pattern conveyor belt can not be achieved; Baseband: the frame materials of the conveyor belt with corrugated sidewall are polyester dipped canvas (EP canvas, steel cord) and lateral rigidity reinforcing layer which make the wall collapsed of large-sized not warped any more.



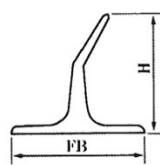
## ▲ 主要物理机械性能 Main physical and mechanical performance of the belt



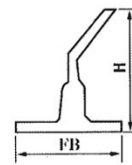
T 型



C 型



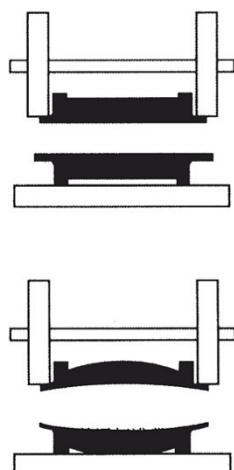
TC 型



TCS 型

## 挡边、横隔板规格尺寸及有关参数

### ▲ Dimensions of Side Wall and Cleat



参数 Reference data	型号 Type	S 60	S 80	S 120	S 160	S 200	S 240	S 300
项目 Items								
挡边高度 Side wall height	mm	60	80	120	160	200	240	300
挡边底宽 Bottom wide of side wall	mm	50	50	50	75	75	90	90
挡边波幅 Bottom wide of side wall	mm	35	44	44	68	68	84	84
挡边波距 Side wall pitch BW	mm	50	42	42	65	65	70	70
折平方米数 Length of side wall converted in m <sup>2</sup>	m <sup>2</sup> /M	0.67	0.83	1.86	2.95	3.88	5.20	7.73
配隔板高度 Cleat height	mm	55		110	145	180	220	280
隔板底宽 Bottom width of cleat	mm	TC 60	TC 75	TC 100	TC 145	TC 200	TC 200	TC 200
隔板折平方米数 Cleat converted in m <sup>2</sup>	m <sup>2</sup> /M	0.60	1.35	1.85	2.35	3.56	5.25	7.40
辊筒直径 Pulley diameter	mm	400	500	600	800	900	1000	1200
挡边压轮直径 Side roller diameter	mm	300	340	360	400	480	520	620
空边尺寸 Size of blank space	mm	60~300						

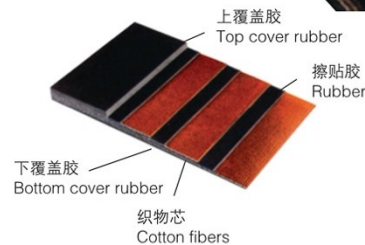
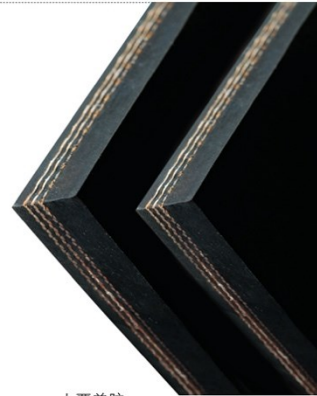
## 聚酯输送带

### » POLYESTER-POLYAMIDE CONVEYOR BELT

#### 产品特点 Characteristics

聚酯输送带又称 EP 输送带，其抗拉体为经向涤纶，纬向为涤纶交织而成的帆布，其性能特点是经向的低延伸率和纬向的优良成槽性能，耐水性好，湿态强度不下降，不发生霉变，聚酯的初始模量高，可取较低的安全系数，适用于中长距离较高载重、高速条件下输送物料。

Polyester conveyor belt also called EP conveyor belts, which tension resistant body is canvas that is woven by polyester in warp and polyamide in weft. The belts have the characteristics of low elongation in wrap and good trough ability in weft, good water proof, good wet strength, no mould, suitable for medium, long-distance and heavy-load transportation of materials. Because of the high initial modulus of polyester, the belts can choose a relative low safety factor.



#### 聚酯多层织物芯输送带的规格及技术参数

##### Specification and technical index of multi-ply EP conveyor belt

织物类型 Fabric type	织物构造 Fabric structure		织物 型号 Fabric type	胶布厚度 Fabric Thickness (mm/p)	强度系列 ( n/mm ) Strength series						覆盖胶厚度 cover rubber thickness		宽度范围 Width mm	带长 Length (m)
	经 Warp	纬 weft			2层 2ply	3层 3ply	4层 4ply	5层 5ply	6层 6ply	上覆 盖胶 upper	下覆 盖胶 lower			
聚酯 Polyester (EP)	聚酯 Polyester (E)	聚酯 Polyamide (P)	EP-80	0.60	160	240	320	400	480	2.0-8	0-4.5	400-2500	≤ 300	
			EP-100	0.75	200	300	400	500	600					
			EP-150	1.0	300	450	600	750	900					
			EP-200	1.1	400	600	800	1000	1200					
			EP-250	1.25	500	750	1000	1250	1500					
			EP-300	1.35	600	900	1200	1500	1800					
			EP-350	1.45		1050	1400	1750	2100					
			EP-400	1.55			1600	2000	2400					
			EP-500	1.70			2000	2500	3000					

### ▲ 粘合强度 / 延伸性能符合表 Adhesion and elongation of the belt

带芯材料 Belt carcass	粘合强度 Adhesion			延伸性能 Elongation	
	布层间 Between plies N/mm	覆盖层与布层间 N/mm Between rubber and carcass		全厚度纵向拉伸伸长率 Longitudinal elongation at break % ≥	全厚度纵向参考力伸长率 Longitudinal elongation rate at reference load % ≤
		覆盖层厚度 ≤ 1.5mm Rubber thickness ≤ 1.5mm	覆盖层厚度 ≤ 1.5mm Rubber thickness ≤ 1.5mm		
聚酯帆布 Ep canvas	≥ 4.50	≥ 3.15	≥ 3.50	10	1.5

### ▲ 胶带的覆盖层性能按下表分级 Cover rubber's characteristics of the belts

覆盖层级别 Cover grade	拉伸强度 Tensile strength	拉伸伸长率 Elongation at break	磨损率 Abrasion
	Mpa	%	mm <sup>3</sup>
H	24	450	120
D	18	400	100
L	15	400	250

注：H-强撕裂工作条件 D-强磨损工作条件 L-一般工作条件

同时可以按照AS1332-2000、JISK6322: 1999、DIN2212-1991标准生产各种性能输送带

Attention: H-High intensity working condition D-High abrasion working condition

L-Normal working condition

Our company also can produce all kinds of performance conveyor belt under

AS1332-2000、JISK6322: 1999、DIN2212-1991 standards and so on...



## 尼龙输送带

### » NYLON CONVEYOR BELT

#### 产品特点 Characteristics

尼龙是橡胶工业目前所用合成纤维中性能最好的品种之一，其结构经纬向均为锦纶纤维编织，用途最广的品种，它最突出的优点是耐磨性好，强度高，耐疲劳性好，尼龙帆布做成输送带具有带体薄，强力高，耐冲击，成槽性好，层间粘合力大，屈挠性优异及使用寿命长等特点，适用于中长距离，较高载量，高速条件下输送物料，广泛用于矿山、冶金、建筑、港口等部门。

Nylon is one of the best quality synthetic fibers in rubber industry now, The nylon canvas is woven by nylon fibers both in warp and in weft, it is the most widely used fabric in rubber industry, and its outstanding merits are its high abrasion resistance, high tensile strength and good fatigue resistance. Conveyor belts with nylon canvas inside have the characteristics of thin belt body, high tensile strength, good anti-shock, good trough ability, high adhesion between plies, splendid flexibility and long working life. Nylon conveyor belts are suitable for medium, long-distance and heavy-load transportation of materials, widely used in mining, metallurgical industry and architectural industry, ports and so on.





## 尼龙多层织物芯输送带的规格及技术参数

### Specification and technical index of multi-ply cotton/polyester cotton conveyor belt

织物类型 Fabric type	织物构造 Fabric structure		织物型号 Fabric type	胶布厚度 Fabric Thickness (mm/p)	强度系列 ( n/mm) Strength series						覆盖胶厚度 cover rubber thickness		宽度范围 Width mm	带长 Length (m)
	经 Warp	纬 weft			2层 2ply	3层 3ply	4层 4ply	5层 5ply	6层 6ply	上覆盖胶 upper	下覆盖胶 lower			
尼龙 Nylon(NN)	锦纶 Nylon-66	锦纶 Nylon-66	NN-100	0.75	200	300	400	500	600	1.5-8	0-4.5	400-2500	≤ 300	
			NN-150	0.80	300	450	600	750	900					
			NN-200	0.90	400	600	800	1000	1200					
			NN-250	1.15	500	750	1000	1250	1500			800-2500		
			NN-300	1.25		900	1200	1500	1800					
			NN-400	1.45			1600	2000	2400					
			NN-500	1.55			2000	2500	3000					

### 胶带的覆盖层性能按下表分级 Cover rubber's characteristics of the belts

覆盖层级别 Cover grade	拉伸强度 Tensile strength	拉伸伸长率 Elongation at break	磨损率 Abrasion
	Mpa	%	mm <sup>3</sup>
H	24	450	120
D	18	400	100
L	15	350	200



注：H-强撕裂工作条件 D-强磨损工作条件 L-一般工作条件

同时可以按照AS1332-2000、JISK6322: 1999、DIN2212-1991标准生产各种性能输送带

Attention: H-High intensity working condition D-High abrasion working condition

L-Normal working condition

Our company also can produce all kinds of performance conveyor belt under

AS1332-2000、JISK6322: 1999、DIN2212-1991 standards and so on...

### 粘合强度 / 延伸性能符合表 Adhesion and elongation of the belt

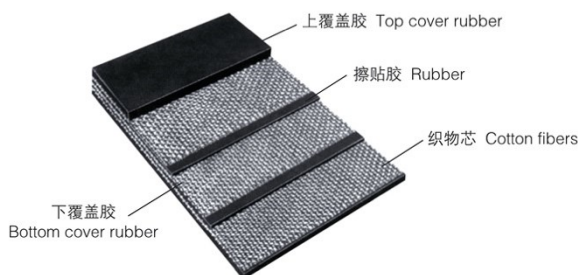
带芯材料 Belt carcass	粘合强度 Adhesion			延伸性能 Elongation	
	布层间 Between plies N/mm	覆盖层与布层间 N/mm Between rubber and carcass		全厚度纵向拉伸伸长率 Longitudinal elongation at break % ≥	全厚度纵向参考力伸长率 Longitudinal elongation rate at reference load % ≤
		覆盖层厚度 ≤ 1.5mm Rubber thickness ≤ 1.5mm	覆盖层厚度 > 1.5mm Rubber thickness > 1.5mm		
尼龙帆布 Nylon canvas	≥ 4.50	≥ 3.15	≥ 3.50	10	2.0

## 全棉、涤棉输送带 » COTTON, POLYESTER COTTON CONVEYOR BELT

### 产品特点 Characteristics

全棉帆布结构经向和纬向均采用棉纤维纺织而成，延伸率较低，机械卡接紧固性好，帆布与橡胶粘着性好。高温条件下变形较小，适合距离较短，输送物量较小的场合使用。涤棉输送带是全棉输送带质量升级产品，其抗拉体采用径向涤棉混纺纤维与纬向的棉纤维交织而成，综合物理机械性能明显优于全棉输送带，特别是带体更薄、更轻、抗冲击性能大大改善，所以具有更好的使用性能，并节能减耗，为用户创更佳的经济效益。适用中短距离，载量中等条件下输送物料。

Cotton canvas is woven by cotton fibers both in warp and in weft, Its elongation is relatively low, it is good in mechanical fastening and adhesion with rubber. Cotton conveyor belt has relatively little deformation under high temperature, suitable for short-distance and light-load transportation. Polyester cotton conveyor belt is the upgraded product of cotton conveyor belt. And its resistant tension body is woven by polyester cotton fibers in warp and cotton fibers in weft. Its comprehensive physical and mechanical characteristics are obviously better than those of cotton conveyor belt, especially the belt body is thinner and lighter, the belt has better anti-shock. Thus the belt has better use function can reduce energy and material consumption for users. It is suitable for medium, short-distance and moderate-load transportation of materials.



### 全棉 / 涤棉多层织物芯输送带的规格及技术参数

#### Specification and technical index of multi-ply cotton, polyester cotton conveyor belt

织物类型 Fabric type	织物构造 Fabric structure		织物型号 Fabric type	胶布厚度 Fabric Thickness (mm/p)	强度系列（n/mm） Strength series						覆盖胶厚度 Cover rubber thickness		宽度范围 Width mm	带长 Length (m)
	经 Warp	纬 weft			2层 2ply	3层 3ply	4层 4ply	5层 5ply	6层 6ply	上覆盖胶 upper	下覆盖胶 lower			
全棉 Cotton (Cc)	棉 Cotton (c)	棉 Cotton (c)	CC-56	1.10	112	168	224	280	336	2-8	0-4.5	400-2500	≤ 300	
涤棉 Polyester Cotton (Tc)	涤棉 Polyester Cotton (Tc)	棉 Cotton (c)	TC-70	1.0	140	210	280	350	420	1.5-8	0-4.5	400-2500	≤ 300	

### ▲ 胶带的覆盖层性能按下表分级 Cover rubber's characteristics of the belts

覆盖层级别 Cover grade	拉伸强度 Tensile strength	拉伸伸长率 Elongation at break	磨耗率 Abrasion
	Mpa	%	mm <sup>3</sup>
H	24	450	120
D	18	400	100
L	15	350	200

注：H—强撕裂工作条件 D—强磨损工作条件 L—一般工作条件

同时可以按照AS1332-2000、JISK6322: 1999、DIN2212-1991标准生产各种性能输送带

Attention: H—High intensity working condition D—High abrasion working condition

L—Normal working condition

Our company also can produce all kinds of performance conveyor belt under

AS1332-2000, JISK6322: 1999, DIN2212-1991 standards and so on...

### ▲ 粘合强度 / 延伸性能符合表 Adhesion and elongation of the belt

带芯材料 Belt carcass	粘合强度 Adhesion			延伸性能 Elongation	
	布层间 Between plies N/mm	覆盖层与布层间 N/mm Between rubber and carcass		全厚度纵向拉伸伸长率 Longitudinal elongation at break % ≥	全厚度纵向参考力伸长率 Longitudinal elongation rate at reference load % ≤
		覆盖层厚度 ≤ 1.5mm Rubber thickness ≤ 1.5mm	覆盖层厚度 > 1.5mm Rubber thickness > 1.5mm		
全棉帆布 Cotton canvas	≥ 2.70	≥ 2.4	≥ 2.7	10	2.0



## PVC PVG 阻燃抗静电织物整芯输送带

### » ANTI-STATIC ELECTRICITY AND ANTI-FIRE FABRICS CORD CONVEYOR BELT

#### ▲ 产品概述 Characteristics and usage

PVC 阻燃抗静电织物整芯输送带（简称 PSAF 输送带），是用高强度尼龙长丝和棉纱织成整体带芯，然后用阻燃的 PVC 糊料浸渍塑化而成。其生产技术，关键设备均从英国芬纳（FENNER）公司引进。PSAF 输送带具有不延燃、抗静电、强度高、整体性好、抗撕裂、耐潮湿，带体轻、寿命长等特点，是当今世界各国用于煤矿井下最理想的安全输送带。PVG 阻燃抗静电织物整芯输送带（简称 PVG 阻燃带）除具有 PVG 阻燃抗静电整芯输送带的强力高、整体性好、带体轻，阻燃抗静电性能好的特点外，还具有橡胶面输送带弹性好、抗湿滑性能好的特征，可以加大提升角度，并防止物料散落，提高运输效率。同时，由于覆盖层的增厚，使输送带寿命大大增加。

PVC anti-fire and anti static electricity conveyor belt often called PSAF. it select high-intensity nylon filament and yarn weave. as a whole core, and then use the PVC impregnated. Their technologies and key equipment are introduced from the United Kingdom, Specialization (Fenner) Corporation. PSAF have advantage of anti-static electricity, high-intensity, with light body, long life characteristics in the modern world. It is the best security for the coal mine belt. Otherwise with light body, anti-fire anti-static electricity characteristics. It also have good elastic body, good performance against Slippery Features can increase their perspective, and to prevent the material falling, improve transport efficiency. At the same time, because of the prolonged cover for transmission, It can Bring life significantly.

#### ▲ 规格型号 Specification models

1. 宽度规格 (mm) 400 500 650 800 1000 1200 1400 1600 1800 2000

2. 强度规格 (N/mm)

1. Width specifications (mm) 400 500 650 800 1000 1200 1400 1600 1800 2000

2. Intensity specifications (N/mm)

原用型号 Original standard No.	4	5	6	7	8	9	10	11	12	13	14	15	16
煤炭部标准 Coal-carbon government department standard	680S	800S	1000S	1250S	1400S	1600S	1800S	2000S	2240S	2500S	2800S	3100S	3400S





## 技术要求 Technical specification

一、产品标准 执行MT147-1995《煤矿用阻燃抗静电织物芯输送带》

一. product regulation carry on MT147-1995 《anti-static electrnicity and anti-flame fabrics cord transmission belt used in coal mine》

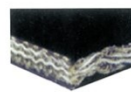
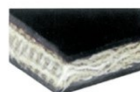
输送带型号		全厚度抗拉强度 KN/H		伸长率%		撕裂强度 最小值 KN	带厚度 最小值 mm	上下覆盖层 厚度最小值 mm
		纵向最小值	横向最小值	纵向最小值	横向最小值			
4	680S	680	265	15	18	1.09	8.0	0.80
5	800S	800	280	15	18	1.18	8.5	0.80
6	1000S	1000	350	15	18	1.18	9.0	0.80
7	1250S	1250	350	15	18	1.54	10.1	0.80
8	1400S	1400	350	15	18	1.54	10.5	0.75
9	1600S	1600		15	18		10.5	0.75
10	1800S	1800		15	18		10.5	0.75
11	2000S	2000		15	18		10.5	0.75
12	2240S	2240		15	18		10.5	0.75
13	2500S	2500		15	18		10.5	0.75
14	2800S	2800		15	18		10.5	0.75
15	3100S	3100		15	18		10.5	0.75
16	3400S	3400		15	18		10.5	0.75

二、覆盖胶性能：

邵尔A型硬度 橡胶面 $604 \pm 5$ 度

塑料面 $75 \pm 5$ 度

磨耗量 不得大于 $0.7\text{Gm}^3/1.61\text{km}$



二. Cover rubber's characteristics:

Shaoer A hardness rubber surface  $604 \pm 5^\circ$

plastic surface  $75 \pm 5^\circ$

Abrasion is no less than  $0.7\text{Gm}^3/1.61\text{Km}$

PVC

PVG

PVC 花纹

三、安全性能：

①酒精喷灯燃烧试验：6个全厚度试样的有焰和无焰燃烧时间的算术平均值不得大于3秒，单值不得大于10秒，对18块剥去复盖层试样的有焰和无焰燃烧时间的算术平均值不得大于5秒，单值不得大于15秒。

②表面电阻值试件上，下表面电阻不大于  $3 \times 10^9$  。

③辊筒磨擦试验，辊筒摩擦试验后辊筒表面温度不得大于 $325^\circ\text{C}$ ，其任何部位不得发生有焰燃烧和无焰燃烧现象。

④巷道丙烷燃烧试验。

三. Security functions:

① the arithmetic average time of six full-thickness samples on a special forms and non-flame burning should not passed 3 seconds, the single value can not be larger than 10 seconds, the arithmetic average time of 18 samples whose cover rubber had been stripped off on a special forms and non-flame burning should not passed 5 seconds, the single value can not be larger than 15 seconds.

② the value of the surface resistance test pieces. Surface resistance is not more than  $3 \times 10^9$  .

③ roller cylinders friction tests roller cylinders friction tests roller cylinders surface temperature should not exceed  $325^\circ\text{C}$ , any of its parts should not had a flame burning and no combustion phenomena.

④ Tunnel propane combustion tests.

## 提升输送带

### » LIFTING CONVEYOR BELT

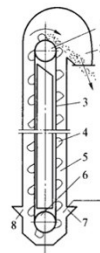


**用途：**提升式输送带用于垂直输送物料，广泛用于建材、矿山、化工、轻工、机械、电力、粮食部门。

**特点：**占地面积小、环境污染小、输送量大、对块状物料适应性良好。

**Purpose:** Transport materials vertically, widely used in building materials , mining, chemical industry , light industry, machinery, electricity, food sector .

**Features:** Small footprint , low environmental pollution, transport capacity, good adaptability of bulk materials.



- |          |                       |
|----------|-----------------------|
| 1. 驱动轮   | Driver wheels         |
| 2. 卸料口   | Material exit         |
| 3. 提升带   | Lifting conveyor belt |
| 4. 斗     | Bucket                |
| 5. 提升管   | The path              |
| 6. 张紧轮   | The tension wheel     |
| 7. 8物料入口 | Material enter        |