CHIORINO 1906

CONVEYOR AND PROCESS BELTS **TECHNICAL DATA SHEET**

DG1/45 MF

COMPOSITION

Conveying surface	Material	Natural elastomer		
	Thickness	3.10 mm	*0.122*	*in.*
	Surface pattern	Fabric		
	Colour	Red		
	Coefficient of friction	HF		
Textile carcass	Material	Polyamide (PA)		
	Plies no.	---		
	Weft type	---		
Driving surface	Material	Synthetic elastomer		
	Thickness	0.30 mm	*0.012*	*in.*
	Surface pattern	Fabric		
	Colour	Green		

MF™

TECHNICAL SPECIFICATIONS

Total thickness	4.50 mm	*0.18*	*in.*
Weight	5.10 kg/m²	*1.04*	*lbs./sq.ft*
Elongation at 1%	5.0 N/mm	*29.0*	*lbs./in.*
Max. admissible pull	10 N/mm	*57.1*	*lbs./in.*
Temperature resistance (1) min.	0 °C	*32*	*°F*
Temperature resistance (1) max.	100 °C	*212*	*°F*

(1) use of the belt with limit values may reduce its life

Minimum roller diameter (2)

Knife edge	no		
Bending roller	50 mm	*2.0*	*in.*
Counter-bending roller	70 mm	*2.8*	*in.*

(2) The above mentioned values depend on the type of CHIORINO joint recommended

Coefficient of friction on driving surface

Raw steel sheet	--- [-]
Laminated plastic/wood	--- [-]
Steel roller	0.70 [-]
Rubberized roller	0.90 [-]

Max. production width	500 mm	*20*	*in.*

SUITABLE FOR

Corrugated carton: feeder
Corrugated carton: stacking & transfer
Printing and graphic: insertion cassettes wind./unwinding

FEATURES

Humidity influence	yes
Suitable to metal detector	no
Permanent antistatic dynamically (UNI EN ISO 21179)	yes
Static conductivity (UNI EN ISO 284)	no
Conveying on skid bed	no
Conveying on rollers	yes
Conveying on skid bed on top and return	no
Troughed conveying	no
Swan neck conveying	no
Inclined conveying	yes
Accumulators belts	no
Curved conveyor	no
Chemical resistances link	8

COMPLIANCES

REACH EC 1907/2006 Regulation and Amendments

NOTES

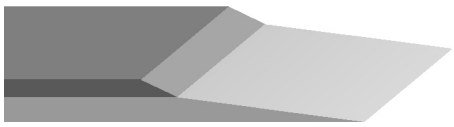
PRODUCT CODE CG215 Last Update: 24-10-2019

CONVEYOR AND PROCESS BELTS **JOINING DATA SHEET**

DG1/45 MF

• Recommended joining procedure

SKIVED JOINT '4'



Check our general catalogue to get further info on CHIORINO joining methods.

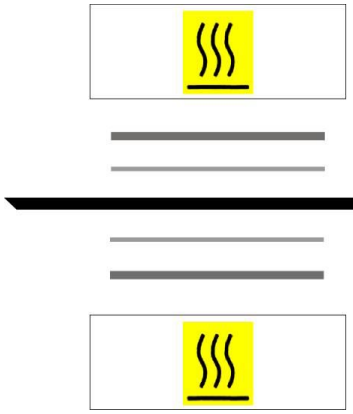
• Skiving instructions

Skiver	Belt thickness mm	Length mm	Straight/ diagonal cut	Cam/ wedge number	Pulley				Top cover			
					T mm	B mm	Thickness adjustment	End stop switch of working plate	T mm	B mm	Thickness adjustment	End stop switch of working plate
B600 A	4,5	50	Diagonal	1.5-14	---	0	18,30	90	---	16	13,25	107
B300 SA	4,5	50	Diagonal	1.5-14	27	1	11-11	B(2)	27	20	07-07	A(1)

• Guide to the use of adhesives

Apply the **K cement** on the polyamide part of the splices and let dry for 5 minutes.
Apply **CLEANER I** primer to the splices of the top cover.
Mix the **NE486 cement** with the **BOSTIKURE D.40 hardener** (pot-life 3 hours) with the following weight proportions: 100 g / 6 g.
Apply the mixture to the splices of the top cover.
Let dry for 5 minutes, then match the belt ends, paying attention to align properly.
Press according to the instructions shown.
To ensure best joint life it is advisable not to run or tension the belt for 24 hours.

• Layout of components



→ Upper heated platen
→ Upper synthetic plate
→ Silicone sheeting thickness 3 mm
→ Belt
→ Glossy non-adhesive fabric (ML58)
→ Lower synthetic plate
→ Lower heated platen

Press settings	
Upper platen temperature	100 °C
Lower platen temperature	100 °C
Curing time in press	20 min.
Driving torque	30

Cooling time:
it is recommended to remove the belt from the press once a temperature of 60/70 degrees C is reached.

• Notes

A(1) Do not overcome the block - **B**(2) Overcome the block until 50 mm total length is reached. Before skiving the top cover, make sure to increase by 2mm the thickness of the area where the part to be skived will be rested. This extra thickness can be achieved using any thickening material (ex. a belt)

PRODUCT CODE CG215 Last Update: 13-03-2024