CHIORINO®
1906

CONVEYOR AND PROCESS BELTS
TECHNICAL DATA SHEET

X-Motion™

CODE	NA-1204	TYPE	XM-3 E/U10 N

COMPOSITION

top side conveying surface coating

material	Polyurethane (TPU)	
thickness	1.0　mm	*0.039　in.*
surface pattern	Smooth	
colour	Black	
coeff. of friction	LF	

TRACTION CORE

material	PET layer　0.35 mm　*0.014 in.*

bottom side driving surface coating

material	Fabric with polyurethane (TPU)
surface pattern	Fabric
colour	Grey
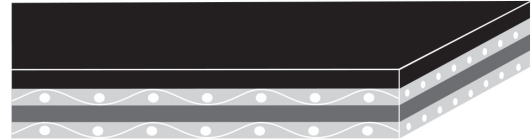
TECHNICAL SPECIFICATIONS

Total thickness	2.60 mm	*0.10　in.*
Weight	2.90 kg/m²	*0.59　lbs./sq.ft*
Elongation at 1%	20 N/mm	*114.0　lbs./in.*
Max. admissible pull	30 N/mm	*171.3　lbs./in.*
Temperature resistance [1]　min.	-20 °C	*-4　°F*
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	100 mm	*3.9　in.*
▪ counter-bending roller	180 mm	*7.1　in.*

[2] the above mentioned values depend on the type of CHIORINO joint recommended

Coefficient of friction on driving surface

▪ raw steel sheet	0.20 [-]
▪ laminated plastic/wood	0.25 [-]
▪ steel roller	0.20 [-]
▪ rubberized roller	0.30 [-]

Max. production width	2000 mm	*79　in.*

SUITABLE FOR

Ceramic: digital decoration
Textile: printing blankets
Printing and graphic: digital printing
Wood industry: digital printing

FEATURES

Humidity influence	no
Suitable to metal detector	yes
Permanent antistatic dynamically (UNI EN ISO 21179)	yes
Static conductivity (UNI EN ISO 284)	no
Conveying on skid bed	yes
Conveying on rollers	yes
Conveying on skid bed on top and return	no
Troughed conveying	no
Swan neck conveying	yes
Inclined conveying	no
Accumulators belts	yes
Curved conveyor	no
Chemical resistances link	5

COMPLIANCES

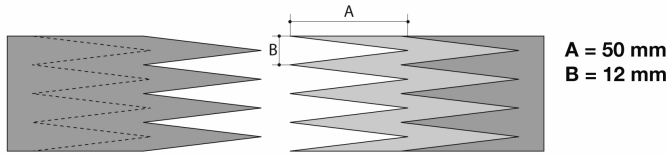REACH EC 1907/2006 Regulation and Amendments

NOTES

Recommended initial tension 0.2÷0.5%

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CONVEYOR AND PROCESS BELTS

JOINING TECHNICAL DATA SHEET

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Recommended joining procedure — DOUBLE Z

A = 50 mm
B = 12 mm

**Other joining methods can be used:**

DIAGONAL SINGLE Z
SINGLE Z

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

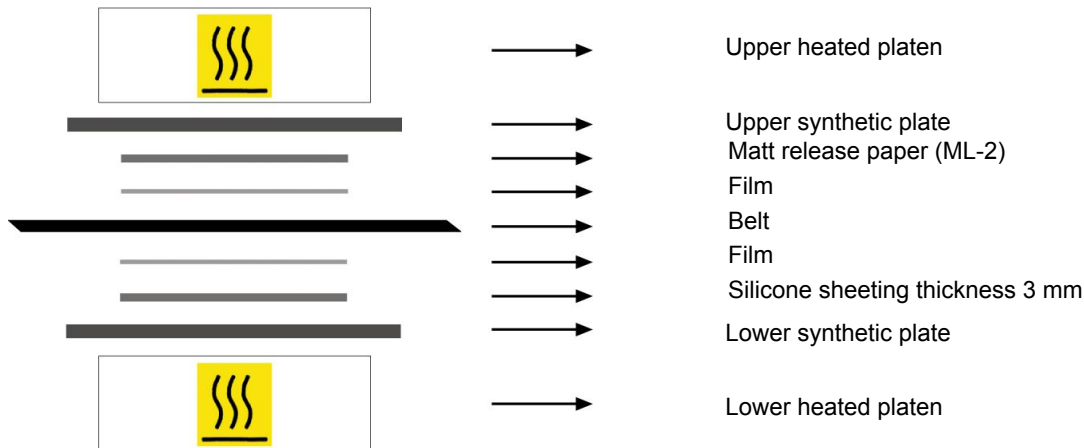## • Pressing

Heating press   **P \ PL \ PLS**

Press settings	
Upper platen temperature	160 °C
Lower platen temperature	120 °C
Temperature gauge setting	145 °C
Curing time in press	3 min.
Pressure	3 bar
Film	TC-67 - Black PU film
Cement	---

1. Use the KM330 thermometer to check the effective temperature inside the belt. Place the thermometer gauge as shown by the drawing at side.
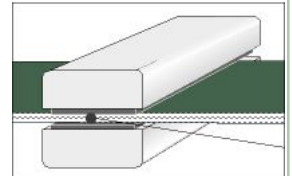
2. Allow the cooling cycle to be completed before removing the belt from the press.

3. A reliable strength of the joint is ensured, providing that temperatures reached by the press are those indicated in the table at side.
   A periodical inspection of the thermostats is recommended, to make sure they function correctly.

• Layout of components

Upper heated platen

Upper synthetic plate
Matt release paper (ML-2)
Film
Belt
Film
Silicone sheeting thickness 3 mm
Lower synthetic plate

Lower heated platen

• Notes

Driving side: one TS-109 gauze between the PU foil (TC-67) and the belt.

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