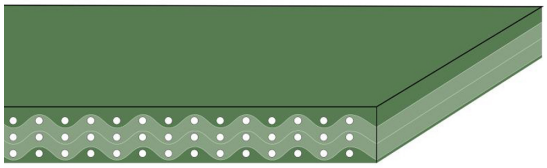
CHIORINO 1906

CONVEYOR AND PROCESS BELTS **TECHNICAL DATA SHEET**

3M15 V5-V10 AGR

COMPOSITION

Conveying surface	Material	PVC 60 Sh.A (±5)
	Thickness	1.00 mm *0.039 in.*
	Surface pattern	Smooth
	Colour	Green
	Coefficient of friction	MF
Textile carcass	Material	Polyester (PET)
	Plies no.	3
	Weft type	Rigid
Driving surface	Material	PVC 60 Sh.A (±5)
	Thickness	0.50 mm *0.020 in.*
	Surface pattern	PN
	Colour	Green



TECHNICAL SPECIFICATIONS

Total thickness		4.10 mm	*0.16*	*in.*
Weight		4.80 kg/m²	*0.98*	*lbs./sq.ft*
Elongation at 1%		15 N/mm	*86.0*	*lbs./in.*
Max. admissible pull		30 N/mm	*171.3*	*lbs./in.*
Temperature resistance (1)	min.	-15 °C	*5*	*°F*
	max.	60 °C	*140*	*°F*

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

Minimum radius / diameter (2)

Knife edge minimum radius	no		
Bending roller min. diameter	100 mm	*3.94*	*in.*
Counter-bending roller min. diameter	150 mm	*5.91*	*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	0.40 [-]
Rubberized roller	0.60 [-]

Max. production width	2000 mm	*79*	*in.*

SUITABLE FOR

Fruits and vegetables

FEATURES

Humidity influence	no
Suitable to metal detector	yes
Permanent antistatic dynamically (UNI EN ISO 21179)	no
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	no
Accumulators belts	no
Curved conveyor	no
Chemical resistances link	3

COMPLIANCES

REACH EC 1907/2006 Regulation and Amendments

NOTES

Better resistance to low temperatures than the standard PVC belts.

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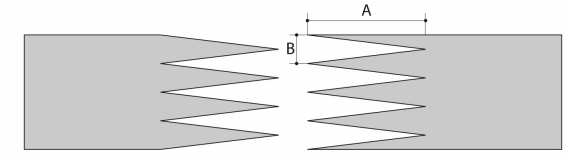
Recommended joining procedure SINGLE Z - 80 x 10 mm



A = 80 mm
B = 10 mm

Other joining methods can be used:

SINGLE Z - 80 x 10 mm
DOUBLE Z
SKIVED JOINT '2'
STEP

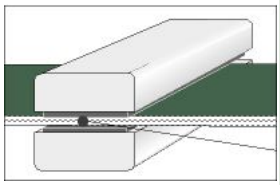
Check our general catalogue to get further info on CHIORINO joining methods.

• Pressing

Heating press **P \ PL \ PLS**

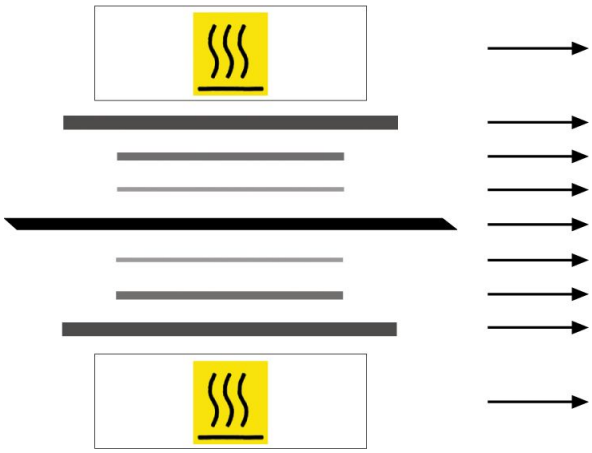
Press settings	
Upper platen temperature	170 °C
Lower platen temperature	170 °C
Temperature gauge setting	170 °C
Curing time in press	3 min.
Pressure	3 bar
Film	TC384 - Apple green PVC film
Cement	---

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
Glossy non-adhesive fabric (ML58)
Film
Transparent film (placed) between plies
PN silicone pad (IG11)
Glossy non-adhesive fabric (ML58)
Lower synthetic plate
Lower heated platen

• Notes

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