CHIORINO 1906

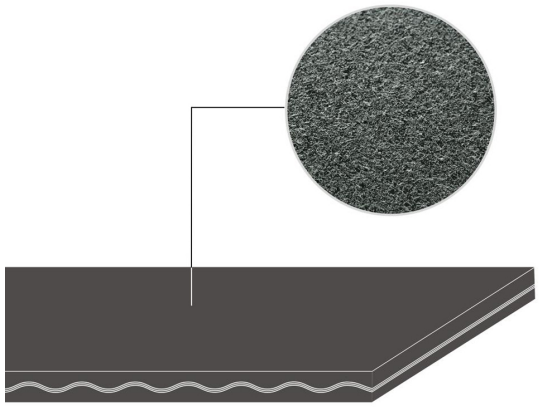
CONVEYOR AND PROCESS BELTS

TECHNICAL DATA SHEET

CODE NA-225 **TYPE** **SILON 25 HC**

COMPOSITION

Conveying surface	Material	Non-woven polyester (PET)
	Thickness	--- mm --- *in.*
	Surface pattern	Rough
	Colour	Anthracite
	Coefficient of friction	LF
Textile carcass	Material	Polyester (PET)
	Plies no.	3
	Weft type	Flexible
Driving surface	Material	Non-woven polyester (PET)
	Thickness	--- mm --- *in.*
	Surface pattern	Rough
	Colour	Anthracite



TECHNICAL SPECIFICATIONS

Total thickness	2.50	mm	*0.10*	*in.*
Weight	1.45	kg/m²	*0.30*	*lbs./sq.ft*
Elongation at 1%	10	N/mm	*57.0*	*lbs./in.*
Max. admissible pull	10	N/mm	*57.0*	*lbs./in.*
Temperature resistance (1)				
■ Min.	-20	°C	*-4*	*°F*
■ Max. - Single-z joint	100	°C	*212*	*°F*
■ Max. - Skived joint	120	°C	*248*	*°F*
Minimum roller diameter				
■ Knife edge	no			
■ Bending roller - Single-z joint	30	mm	*1.2*	*in.*
■ Bending roller - Skived joint	30	mm	*1.2*	*in.*
■ Counter-bending roller	50	mm	*2.0*	*in.*
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.*

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

COMPLIANCES

REACH EC 1907/2006 Regulation and Amendments

FEATURES

Humidity influence	yes
Suitable to metal detector	no
Permanent antistatic dynamically (UNI EN ISO 21179)	yes
Static conductivity (UNI EN ISO 284)	yes
Conveying on skid bed	yes
Conveying on rollers	yes
Conveying on skid bed on top and return	yes
Troughed conveying	yes
Swan neck conveying	no
Inclined conveying	no
Accumulators belts	yes
Curved conveyor	no
Chemical resistances link	11

SUITABLE FOR

Textile: automatic cutting
Wood industry
Box folding industry
Packaging
Corroierie
Cutting tables

NOTES

Static conductivity (UNI EN ISO 284)
Conveying surface 10^6 to 10^8 Ohm per Sqm
Driving surface 10^6 to 10^8 Ohm per Sqm
Due to the product structure, these data represents a guideline only and can be changed without notice.

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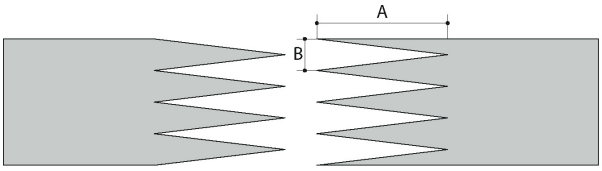
CONVEYOR AND PROCESS BELTS

JOINING TECHNICAL DATA SHEET

CODE NA-225 **TYPE** **SILON 25 HC**

Recommended joining procedure SINGLE Z



A	80 mm
B	20 mm

Other joining methods can be used:

DIAGONAL SINGLE Z
SKIVED JOINT '1'

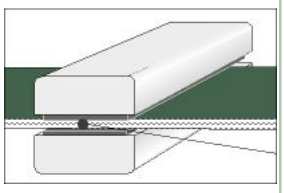
Check our general catalogue to get further info on CHIORINO joining methods.

• Pressing

Heating press **P \ PL \ PLS**

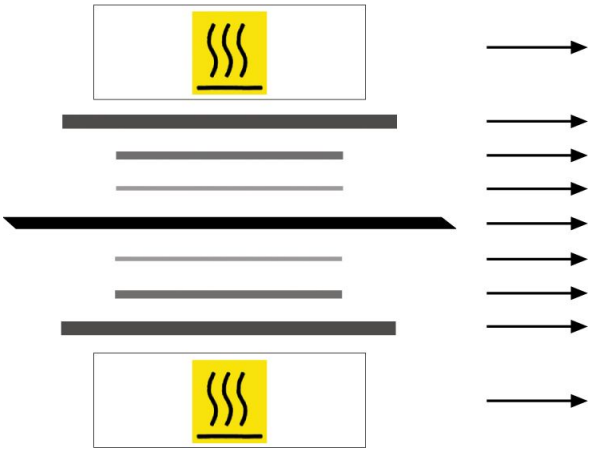
Press settings	
Upper platen temperature	165 °C
Lower platen temperature	165 °C
Temperature gauge setting	165 °C
Curing time in press	3 min.
Pressure	1,5 bar
Film	see notes
Cement	---

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
Non-adhesive silicone fabric (TX-67)

Belt
Film (no. 3 TC-67 and no. 1 TC-12)
FL silicone pad (IG-22)
Lower synthetic plate
Lower heated platen

• Notes

1. Apply in sequence 3 layers of TC-67 + 1 layer of TC-12 film. PU layer on contact with the belt.
2. Space out the ends of 3 mm.

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JOINING DATA SHEET

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• Recommended joining procedure

SKIVED JOINT '1'

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

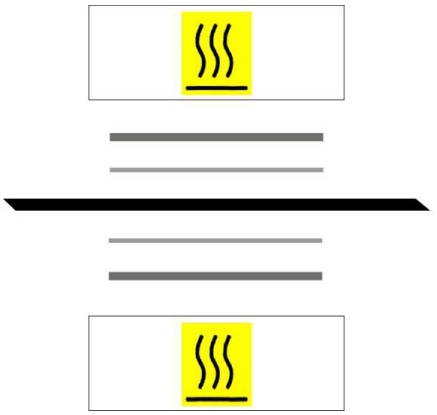
• Skiving instructions

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	2,5	40	Diagonal	1-10	15	5	18.95	---	---	---	---	---
B300 SA	---	---	---	---	---	---	---	---	---	---	---	---

• Guide to the use of adhesives

Pour the **I hardener** with the **R cement** (pot-life 2 hours).
Apply a thin layer of above mix on both splices.
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.
Kit: **SINTECOL**

• Layout of components



→ Upper heated platen
→ Upper synthetic plate
→ Matt release paper (ML-2)
→ Belt
→ Matt release paper (ML-2)
→ Lower synthetic plate
→ Lower heated platen

Press settings	
Upper platen temperature	100 °C
Lower platen temperature	100 °C
Curing time in press	15 min.
Driving torque	30 Nm
Cooling time: it is recommended to remove the belt from the press once a temperature of 60/70 degrees C is reached.	

• Notes

Issue: 30-09-2005 Last Update: 30-01-2014

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