CONVEYOR AND PROCESS BELTS

TECHNICAL DATA SHEET

CODE NA-509 **TYPE** **1M6 U0-V3 N A**

COMPOSITION

Conveying surface	Material	PVC 70 Sh.A (±5)		
	Thickness	0.30 mm	*0.012*	*in.*
	Surface pattern	Smooth		
	Colour	Black		
	Coefficient of friction	LF		
Textile carcass	Material	Polyester (PET)		
	Plies no.	1		
	Weft type	Rigid		
Driving surface	Material	Fabric with polyurethane (TPU) impregnation		
	Thickness	--- mm	---	*in.*
	Surface pattern	Fabric		
	Colour	Black		

TECHNICAL SPECIFICATIONS

Total thickness		0.85 mm	*0.03*	*in.*
Weight		0.85 kg/m²	*0.17*	*lbs./sq.ft*
Elongation at 1%		6 N/mm	*34.0*	*lbs./in.*
Max. admissible pull		6 N/mm	*34.0*	*lbs./in.*
Temperature resistance (1)	min.	-10 °C	*14*	*°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	20 mm	*0.79*	*in.*
■ Counter-bending roller min. diameter	25 mm	*0.98*	*in.*

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

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 3500 mm *138* *in.*

SUITABLE FOR

Textile: nonwoven
Paper industry: tissue

FEATURES

Humidity influence	no
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	no
Troughed conveying	no
Swan neck conveying	no
Inclined conveying	no
Accumulators belts	yes
Curved conveyor	no
Chemical resistances link	2

COMPLIANCES

REACH EC 1907/2006 Regulation and Amendments

NOTES

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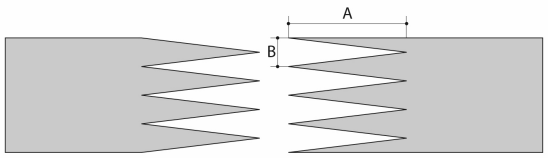
CONVEYOR AND PROCESS BELTS | **JOINING TECHNICAL DATA SHEET**

CODE NA-509 **TYPE** **1M6 U0-V3 A N**

Recommended joining procedure SINGLE Z



A = 80 mm
B = 10 mm

Other joining methods can be used:

DIAGONAL SINGLE Z

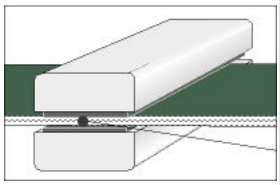
Check our general catalogue to get further info on CHIORINO joining methods.

• Pressing

Heating press **P \ PL \ PLS**

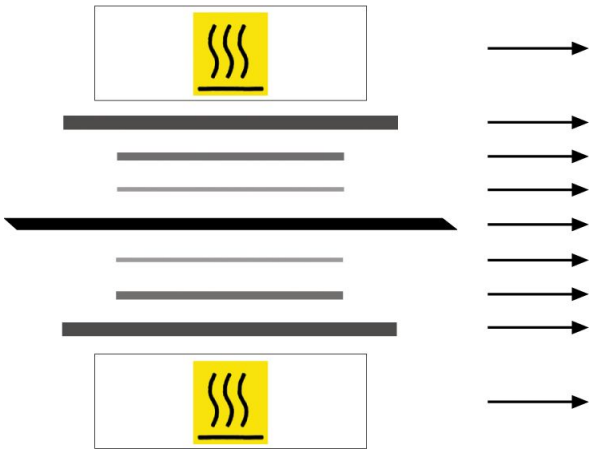
Press settings	
Upper platen temperature	180 °C
Lower platen temperature	180 °C
Temperature gauge setting	180 °C
Curing time in press	--- min.
Pressure	2 bar
Film	TC-28 - Black PVC film
Cement	---

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
Matt release paper (ML-2)
Film
Belt

Non-adhesive silicone fabric (TX-67)
Lower synthetic plate
Lower heated platen

• Notes

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