

输送带说明书

CONVEYOR BELT

INSTRUCTIONS

如果您在使用过程中有任何疑问或建议意见请拨打
If you have any questions or suggestions during use, please call

400 155 8080



无锡百年通工业输送有限公司

WUXI BRILLIANT BOTON CONVEYOR SERVICES CO., LTD.

中国 · 江苏省 无锡市 新吴区里河东路 88 号

88 Lihe East Road, Xinwu District, Wuxi, Jiangsu, China

无锡百年通工业输送有限公司，为无锡宝通科技股份有限公司全资子公司，是全国重点输送带生产企业。公司专业生产各类输送带产品，年生产能力达 3000 万平方米。

公司注册商标“宝通 BOTON”为中国驰名商标，所生产的各类高强力橡胶输送带被评为中国名牌产品。1998 年公司通过 ISO 9001 质量管理体系认证，2006 年、2007 年在行业内率先通过 ISO 14001 环境管理体系认证、OHSAS 18001 职业健康安全管理体系认证和 ISO 10012 测量管理体系认证。2017 年通过 CNAS 实验室认证。生产流程采用 ERP、MES、WMS 等信息化管理，生产现场推行 6S、精益管理。稳定的产品质量、良好的企业荣誉，完善的售后服务使“宝通”牌输送带在全球近 600 家大型直供用户中深受欢迎，产品畅销六十余个国家和地区。

**感谢您选用
宝通公司
系列产品**

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输送带产品执行标准

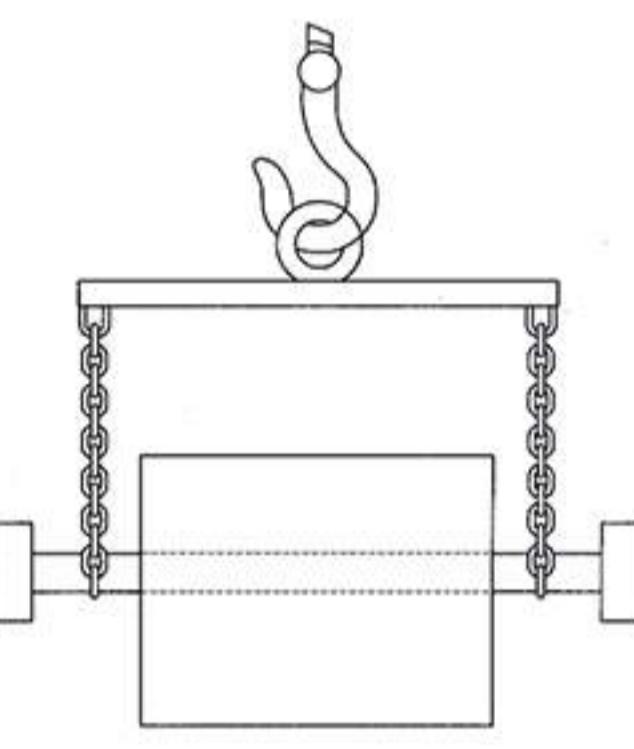
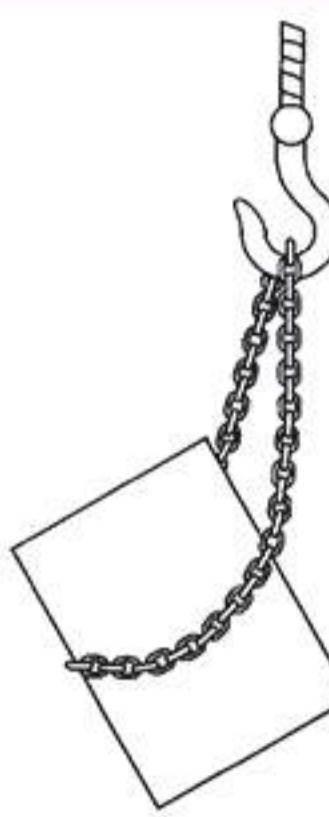
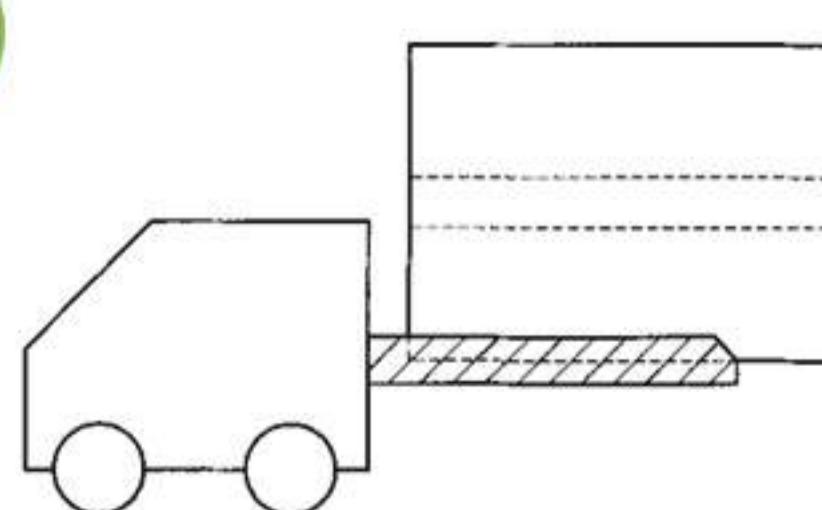
产品类型	执行标准
普通帆布带	GB/T 7984 普通用途织物芯输送带
普通钢丝带	GB/T 9770 普通用途钢丝绳芯输送带
一般阻燃帆布带	GB/T 10822 一般用途织物芯阻燃输送带
一般阻燃钢丝带	HG/T 3973 一般用途钢丝绳芯阻燃输送带
煤矿用阻燃帆布带	MT/T 914 煤矿用织物芯阻燃输送带
煤矿用阻燃钢丝带	MT/T 668 煤矿用钢丝绳芯阻燃输送带
耐热输送带	GB/T 20021 帆布芯耐热输送带
输送带外观质量	HG/T 3046 织物芯输送带外观质量规定
橡胶制品贮存指南	GB/T 20739 橡胶制品贮存指南
输送带贮存与搬运	HG/T 3056 输送带 贮存和搬运指南



输送带的贮存

- 输送带贮存,应保持清洁,避免直接接触臭氧、强光、高温、酸、碱、油、有机溶剂、铜、锰等影响橡胶质量的物质,避免直接受到雨、雪、积水的侵蚀。
- 输送带贮存,应成卷放置,不得折叠,中心轴心呈水平方向,放置带卷的地面应平整、干燥,带卷两侧底下垫木楔子固定位置。
- 输送带贮存温度范围为 -10~40°C, 低于 0°C 贮存, 橡胶变硬, 使用前应于 10°C 以上调节 24h, 改善柔韧性, 避免输送带机械性损伤。
- 输送带贮存期建议不超过 1 年。

输送带的搬运

吊车搬运	
允许的起吊方式 钢棒穿过带卷中心孔, 通过悬杆、钢丝绳起吊 钢丝绳两端距离大于带宽 避免钢丝绳刮、碰、直接接触输送带	 
禁止的起吊方式 禁止采用强度足够的绳索起吊 避免绳索刮、碰、直接接触输送带	 
禁止的起吊方式 禁止钢丝绳在输送带带卷外周起吊 避免发生输送带侧滑、脱落、砸伤人员	 
叉车搬运	
可以使用具有足够承受能力的叉车搬运 操作时注意不能损坏外圈带体 严禁从汽车上直接将输送带推落到地面	 

输送带的选用

输送带品种、规格、强度、安全系数

应根据输送环境、物料性质、输送机长度、倾角、过渡段、转弯、转速等参数,综合选择

输送带品种	适用工况
普通输送带	用于密度小、磨损性小的物料输送
强力型输送带NN,EP	用于大中小型矿石、原煤块等冲击力大、磨损大的物料和输送距离长、输送量大的输送线
耐热型输送带	工作环境: $T_2 < 125^{\circ}\text{C}$; $T_3 < 150^{\circ}\text{C}$; $T_4 < 180^{\circ}\text{C}$ 其他温度咨询工程师
超耐磨输送带	用于磨蚀性、堆积密度、物料块度较大的工作环境
耐高温输送带	用于输送不超过50T°C的块状物料或不过300°C的粉状物料
管状输送带	用于水泥、钢铁、港口、电厂等工业领域圆管式输送机
钢丝绳芯输送带	用于长途, 超大功率运输
煤矿用阻燃钢丝绳芯输送带	煤矿井下物料的输送
煤矿用织物叠层阻燃输送带	煤矿井下物料的输送
IW钢网输送带	适用于有撕裂隐患, 或者物料温度较高的工况
芳纶输送带	替代钢丝带、聚酯带, 适用于长距离、大功率, 运输块状、尖锐物料
防粘附输送带	适用于运输粉状、湿粘等易粘附的物料 协助客户改善物料清扫问题, 提高物料运输效率

输送带的安装与维护

安装作业中,需检查并确认下挡皮与皮带间的间隙,确保其符合规范要求,避免因间隙过小刮伤皮带表面。

接头时,请区分工作面(上覆盖胶)与非工作面(下覆盖胶),一般情况上覆盖胶厚,上覆盖胶朝上,其中钢丝绳输送带白胶一面为工作面。

接头时应保持输送带体商标位于线路同一侧,钢丝绳输送带带白胶一侧为商标侧。

不同品种、规格的输送带,一般不能安装在一起使用。

- 靠近输送机滚筒的回程段表面应设置清扫装置, 倾斜段输送带尾部滚筒前应设置挡料、清扫装置,与胶带接触的部分应采用刚度适合的橡胶板
- 输送带表面不得沾有油污,使用过程中不允许出现打滑现象
- 使用过程中,接头方向应顺着运转方向
- 托辊表面应清洁,不能沾有物料,防止造成回转不灵
- 张紧装置张力大小应适中,保证输送带运转平稳
- 环形输送带安装时,运转方向与标志方向应一致
- 输送机应空机开动,停机前应将物料卸完。由多台输送机组成的输送开机顺序为先开最后一台输送机,然后按顺序向前开,最后开受料输送机,停机时顺序相反
- 输送机应符合 GB/T10595《带式输送机》,带式输送机的使用、维护应符合 GB14784《带式输送机安全规范》要求

安装与接头

Wuxi Brilliant Boton Conveyor Services Co., Ltd, is a subsidiary of Wuxi Boton Technology Co., Ltd, which is a national key manufacturer of conveyor belts. The company specializes in the production of various types of conveyor belts, with an annual production capacity of 30 million square meters of conveyor belts.

The company's registered trademark 'BOTON' is a well-known trademark in China. The various types of high-strength rubber conveyor belts produced are rated as China Famous Brand Products. In 1998, the company passed the ISO 9001 quality management system certification. In 2006 and 2007, it took the lead in the industry to pass the ISO 14001 environmental management system certification, OHSAS 18001 occupational health and safety management system certification and ISO 10012 test management system. In 2017, Boton was awarded as CNAS laboratories. The production process applies with ERP, MES, WMS and other information management systems with 6S and lean management to ensure products quality control management. Good corporate reputation and perfect after-sales service make the 'Boton' brand conveyor belt popular among nearly 200 large-scale direct supply users across the country, and its products are sold in more than 60 countries and regions.

**Thanks for
Choosing
Boton Products**

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Conveyor Belt Product Execution Standards

Conveyor belts	Standards
Fabric belts for general use	GB/T 7984 Conveyor belts of textile construction for general use
Steel cord belts for general use	GB/T 9770 Steel cord conveyor belts for general use
FR fabric belts for general use	GB/T 10822 Flame retardant conveyor belts of textile construction for general use
FR steel cord belts for general use	GB/T 3973 Flame retardant conveyor belts of steel cord construction for general use
FR fabric belts for coalmine	MT/T 914 Textile fire resistant conveyor belting for coalmine
FR steel cord belts for coalmine	MT/T 668 Steel cord fire resistant conveyor belting for coalmine
Heat Resistant fabric belts	GB/T 20021 Heat resistant conveyor belts of duck construction
Conveyor belts appearance quality	HG/T 3046 Conveyor belts with a textile carcass Specification for appearance quality
Rubber products storage	GB/T 20739 Rubber products—Guidelines for storage
Belts storage and handling	HG/T 3056 Conveyor belts Guidelines for storage and handling

输送带的选用

输送带品种、规格、强度、安全系数

应根据输送环境、物料性质、输送机长度、倾角、过渡段、转弯、转速等参数,综合选择

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耐热型输送带	工作环境: $T_2 < 125^{\circ}\text{C}$; $T_3 < 150^{\circ}\text{C}$; $T_4 < 180^{\circ}\text{C}$ 其他温度咨询工程师
超耐磨输送带	用于磨蚀性、堆积密度、物料块度较大的工作环境
耐高温输送带	用于输送不超过50T°C的块状物料或不过300°C的粉状物料
管状输送带	用于水泥、钢铁、港口、电厂等工业领域圆管式输送机
钢丝绳芯输送带	用于长途, 超大功率运输
煤矿用阻燃钢丝绳芯输送带	煤矿井下物料的输送
煤矿用织物叠层阻燃输送带	煤矿井下物料的输送
IW钢网输送带	适用于有撕裂隐患, 或者物料温度较高的工况
芳纶输送带	替代钢丝带、聚酯带, 适用于长距离、大功率, 运输块状、尖锐物料
防粘附输送带	适用于运输粉状、湿粘等易粘附的物料 协助客户改善物料清扫问题, 提高物料运输效率

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接头时应保持输送带体商标位于线路同一侧,钢丝绳输送带带白胶一侧为商标侧。

不同品种、规格的输送带,一般不能安装在一起使用。

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- 输送带表面不得沾有油污,使用过程中不允许出现打滑现象
- 使用过程中,接头方向应顺着运转方向
- 托辊表面应清洁,不能沾有物料,防止造成回转不灵
- 张紧装置张力大小应适中,保证输送带运转平稳
- 环形输送带安装时,运转方向与标志方向应一致
- 输送机应空机开动,停机前应将物料卸完。由多台输送机组成的输送开机顺序为先开最后一台输送机,然后按顺序向前开,最后开受料输送机,停机时顺序相反
- 输送机应符合 GB/T10595《带式输送机》,带式输送机的使用、维护应符合 GB14784《带式输送机安全规范》要求

安装与接头

Selection of Conveyor Belts

Conveyor belt types, specifications, strength and safety factor

Should be based on the conveying environment, material properties, conveyor length, inclination, transition section, turning, speed and other parameters, comprehensive selection

Type	Proper application
Normal conveyor belt	Transport materials with low density and little abrasion
High strength conveyor belt	Used for large and medium-sized ore, raw coal etc. with large impact force, worn materials and long conveying distance, large conveying line
Heat resistant conveyor belt	T2: <125°C; T3: <150°C; T4: <180°C
Super anti-abrasion belt	Used in working environment with abrasiveness, bulk density and large material mass
High heat resistant belt	Bulk material <500°C or powder material <300°C
Pipe belt	Used for pipe conveyor in cement and steel industries
Steel cord belt	Used for long distance, superpower transportation
FR steel cord belt for coalmine	Used for coalmine underground transportation
FR fabric belt for coalmine	Used for coalmine underground transportation
IW steel mesh conveyor belt	Used in the working condition with hidden tear or high material temperature
Aramid belt	Instead of steel cord / EP belt, used for long-distance, high power, massive, sharp material transportation
Antiadhesion conveyor belt	Suitable for powdery or wet materials, reduce carry backs and improve efficiency

Installation and Maintenance of Conveyor Belts

During installation operations, the gap between the lower idler and the belt must be checked and confirmed to ensure it meets the specification requirements, preventing the belt surface from being scratched due to an excessively small gap.

When splicing, please distinguish between the working surface and the non-working surface. Generally, the thicker side is the working surface (the white rubber side of the steel cord conveyor belt is the working surface).

When splicing, the trademark of the conveyor belt body should be kept on the same side of the line, and the white rubber side of the steel rope conveyor belt should be the trademark side.

Different varieties, specifications of the conveyor belt, generally can't be installed together.

INSTALLATION

- A cleaning device should be installed on the surface of the return section close to the conveyor roller, and a material blocking and cleaning device should be installed in front of the roller at the tail of the conveyor belt at the inclined section. The part in contact with the tape should use a rubber plate with suitable stiffness.
- The surface of the conveyor belt must not be stained with oil, and slippage is not allowed during use.
- During use, the direction of the joint follows the direction of operation.
- The surface of the idler should be clean, and must not be stained with materials to prevent the rotation from malfunctioning.
- The tension of the tensioning device should be moderate to ensure the smooth operation of the conveyor belt.
- When the endless conveyor belt is installed, the running direction should be consistent with the sign direction.
- The conveyor should start empty, and the materials should be unloaded before stopping. The startup sequence of the conveyor consisting of multiple conveyors is to open the last conveyor first, then forward in sequence, and finally open the receiving conveyor. The sequence is reversed when the machine is stopped.
- The conveyor should meet the requirements of GB/T10595 Belt conveyors, and the use and maintenance of the belt conveyor should meet the requirements of GB14784- Safety regulations of belt conveyor specification.

MAINTENANCE