



together we create

LBS Product Standard V2023.1.0

Version V2023.1.0

The current, valid version of this document will be available on the LBS website.

Scope of this Product Standard

This Product Standard applies to all products that are sold, produced or supplied by LBS Conveyor Belts, to its customers.

This Product Standard can be regarded as leading for e.g. dimensions, tolerances and areas of application of our products.

If, for whichever reason, it is necessary to deviate from any information described in this Product Standard, then these deviations may only be made after discussion with the relevant manager within LBS Conveyor Belts. Any deviation from the information described in this Product Standard (such as tolerances or area of application) voids the product's warranty unless this deviation was approved by LBS Conveyor Belts.

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Legislation and regulations

Our products comply with the following standards / regulations.

REACH

All materials, semi-finished products and products comply with the EU regulation REACH (EC 1907/2006).

Food safety standards

Certain products comply with the food safety regulation EC 1935/2004. LBS sees this European regulation as the very basis of food safety.

Regulation (EC) 1935/2004, on materials and articles intended to come into contact with food and repealing Directives 80/590/EEC and 89/109/EEC

Additionally, we sometimes follow internationally recognized standards, such as the Food Safety Standards of the American FDA.

The United States Food and Drug Administration (FDA) is responsible for protecting and promoting public health through the control and supervision of food safety and quality in a very broad sense. It also controls and supervises blood transfusions, medical products and cosmetics.

Regulation (EC) 1935/2004 does not cover rubber compounds. For these, we refer to various national standards, fe. The German BfR (Bundesinstitut für Risikobewertung, BfR) recommendation. The relevant parties are responsible for determining which BfR standard they follow.

Warranty provisions

All LBS Conveyor Belts products come with a 12 month warranty on product and product-related characteristics, unless agreed upon differently in writing. This warranty excludes mechanical damage, chemical risks and improper use. Our warranty provisions are part of our general Terms & Conditions, which can be found on our website.

Warranty claims will only be considered if the products that were supplied by LBS Conveyor Belts, were used according to the intended use and purpose.

Any exception to this must be made in writing.

Complaints and warranty

1 A complaint regarding observable defects (in quality or quantity) must, under penalty of forfeiture of rights, be made immediately after discovery but no later than 8 (eight) days after delivery of the Product(s), by registered letter, and stating the reasons. Complaints regarding non-observable defects must, under penalty of forfeiture of rights, be made immediately after discovery but no later than 8 (eight) days, by registered letter, and stating the reasons.

2 Legal claims must be submitted within one (1) year after the valid complaint.

3 Without prejudice to the other restrictions included in the Conditions, the Supplier guarantees the soundness of its Product, the construction methods used by it and the quality of the materials used and/or supplied for this purpose, for a period of one (1) year after delivery, provided that the construction method and choice of materials were determined by the Supplier, and unless the product was produced by a third party, in which case the warranty is limited to the warranty that the third party issued to the Supplier.

4 In no event does the warranty cover Products that were not new at the time of delivery, nor defects that arose as a result of incorrect data provided by the Client, changes made to the Product by third parties, processing of the Product, incorrect operation, incorrect after-treatment or incorrect maintenance (including no after-treatment or no maintenance) of the Product including the material, improper use, other than normal use, incorrect storage, wear, negligence, overload, parts that were added or altered by anyone other than the Supplier before or after the Agreement, modifications, adjustments and additions to the Product, accidents, and any cause external to the Product itself.

5 The Client can not derive any rights from any information or advice given by the Supplier that does not directly apply to the Agreement or Product(s).

6 The Supplier can not be held liable for defects that arose due to improper use of the Product or due to modifications, assembly, repair, transport and/or any other actions performed on the Product(s) by any party other than the Supplier. Additionally, the Supplier can not be held liable for defects as a result of accidents, which can not be causally attributed to the Supplier.

7 The Supplier only guarantees that the Products comply with requirements and standards common to the industry for the use of the Products in the Netherlands. Only substantial deviations of the drawings, technical descriptions, images, colours, sizes, weights, materials, quantities, planning, actions, route descriptions and all else that were agreed upon in writing, can give rise for the Client

to file a complaint or request replacement, reimbursement or any other claim.

8 The Client recognizes that advice and simulations provided by the Supplier are based on assumptions and are, therefore, an approximation of the actual Product. The Supplier is not liable for damage as a result of differences between such assumptions and actual facts.

9 At his discretion, the Supplier shall, at no additional cost, either deliver a replacement Product (conditional upon the return of the defective Product(s)) or repair the defective Product(s), provided that a complaint was filed in accordance with this Product Standard and on valid grounds. The Supplier reserves the right to sell, produce or supply similar Products and/or using new and/or used parts. By fulfilling one of the aforementioned performances, the Supplier is fully discharged of its (warranty) obligations.

10 In the event of an unjustified complaint, any costs involved will be borne by the Client.

Rubber conveyor belts – Probelt®

LBS Conveyor Belts guarantees a straight belt run on the endless spliced belts it supplies, assuming that the installation has no technical defects and is built in accordance with the current state of technology and science and that the belt is used for its intended purpose.

LBS Conveyor Belts guarantees that its Hotcleat® and Ecocleat® products (cleats, longitudinal edges, guide ropes and Maxprotect) products will not come loose from the belt under normal use. In the event of overload, cleats will either be torn off or be torn from the belt. In the event of overload, no warranty claim can be made.

LBS Conveyor Belts guarantees the adhesion of rubber sidewalls. When used as intended, rubber sidewalls should not come off the belt.

Synthetic conveyor belts

LBS Conveyor Belts guarantees a straight belt run on the endless spliced belts it supplies. Assuming that the installation does not suffer any technical defects and was constructed according to the latest technology and scientific knowledge, and that it was used according to its intended purpose.

LBS Conveyor Belts guarantees the adhesion of all cleats, longitudinal edges, guide ropes and rubber sidewalls. These should not come loose from the belt under normal use. In the case of overload, the relevant profile will either be torn off or be torn from the belt, which will damage the integrity of the top coating of the fabric. In the event of overload, no warranty claim can be made.

Rubber belt specifications

Belt markings are structured as follows:

600/EP 400/3 4+2 Y

600	EP	400	3	4	2	Y
Belt width (mm)	Fabric type	Min.Tensile strength carcass (N/mm)	Number of fabric layers	Thickness top cover (mm)	Thickness bottom cover (mm)	Cover type

800/EP 400/3 3+1,5 L75 Y

800	EP	400	3	3	1.5	L75	Y
Belt width (mm)	Fabric type	Min.Tensile strength carcass (N/mm)	Number of fabric layers	Thickness top cover (mm)	Thickness bottom cover (mm)	Chevron profile type	Cover type

Descr. code materials

Letter	Fabric	Application
E	Polyamide multi filament	Chain / Impact
P	Polyester multi filament	Chain / Impact
B	Cotton	Chain / Impact
X	Polyester mono filament (cross stable)	Impact
ST	Steel breaker wire	Impact

Cover types

Cover type	Description
DIN W	Extra wear resistant
DIN X	Wear resistant
DIN Y	Standard
DIN K	Antistatic and flame retardant (fire retardant)
MOR	Middle Oil and Fat resistant*
FOR	Fully Oil and Fat resistant*
Y+ / SAR	Wear resistant
T150	Heat resistant up to 150°C*
T180	Heat resistant up to 180°C*
T200	Heat resistant up to 200°C*

*Exact specifications can be found on product specification sheets

Belt types and characteristics:

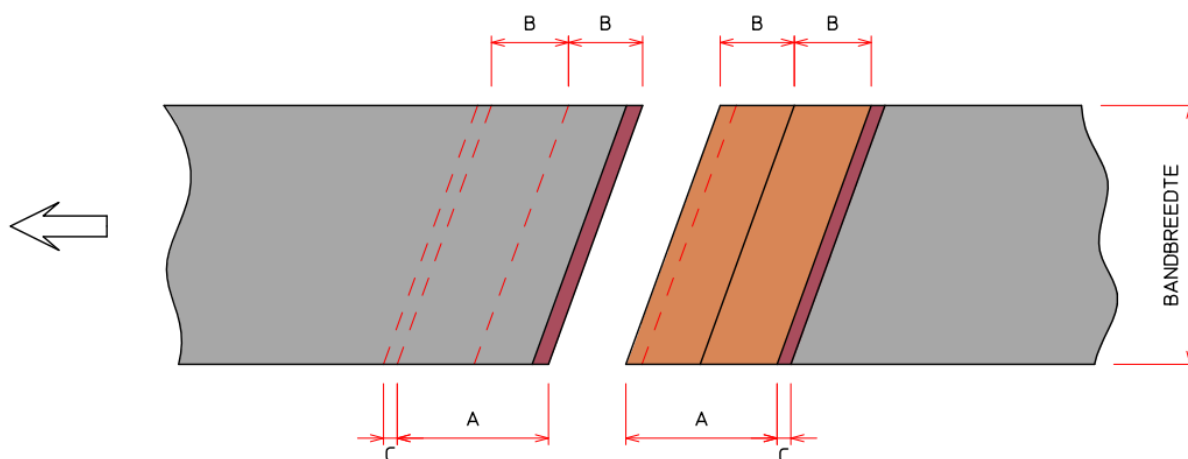
These can be found on Products' data sheets.

Rubber types Hotcleat®, Ecocleat®

Rubber quality	Description	Hardness (°Sh-A)	Application:
SB55	Standard Black 55	55 ±5	Longitudinal edges
SB65	Standard Black 65	65 ±5	Cleats, chevron profiles
SB72	Standard Black 72	72 ±5	Cleats magnet belts
MOR50	Oil and fat resistant 50	50 ±5	Longitudinal edges, oil and fat resistant
MOR62	Oil and fat resistant 62	62 ±5	Cleats, chevron profiles, oil and fat resistant.

Rubber belt splices

Angled step splice, hot vulcanized.



Number of fabric layers	A (mm)	B (mm)	C (mm)	Number of steps (B)
2	250	250	25	1
3	250	125	25	2
4	450	150	25	3
>4	By agreement			

In the case of an internal scraper, it may be better to have the inside of the splice run along with the scraper.

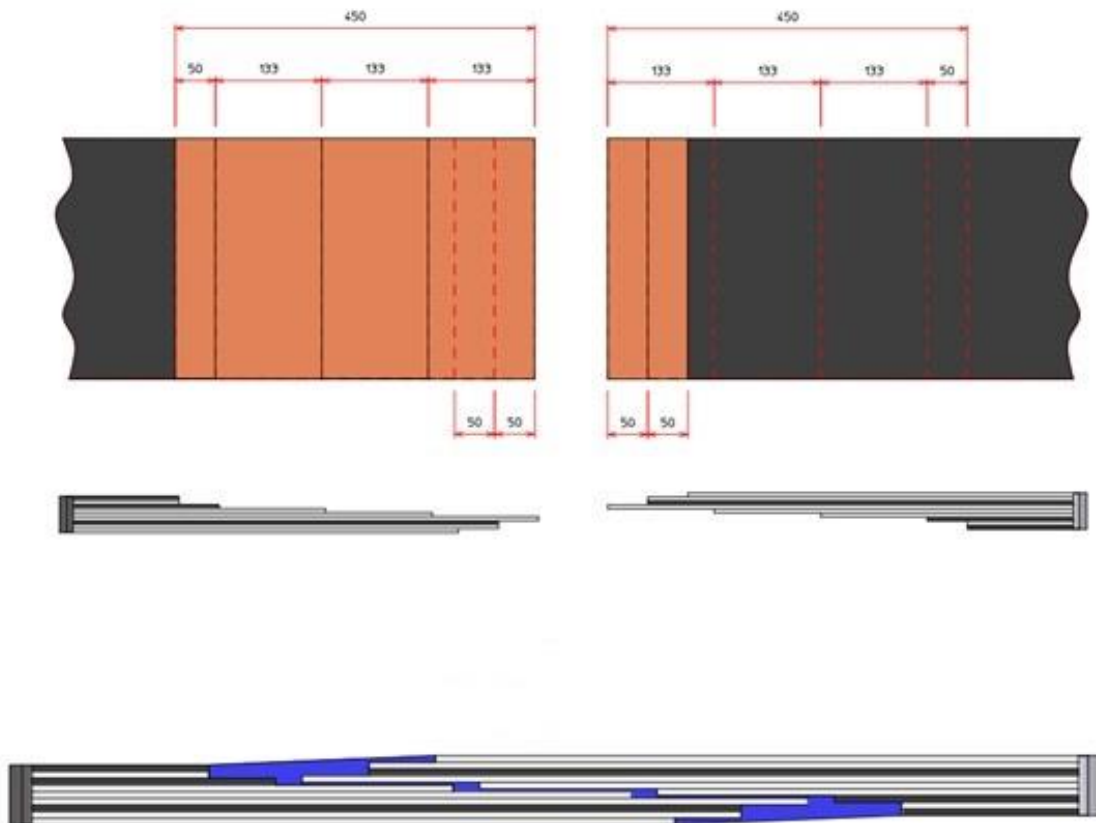
In certain circumstances, such as drive and reverse drums that are too small, it can be advantageous to let the belt run in such a direction that the inside of the splice runs along with the belt.

Cross stable belts are all spliced in the same way by default. However, not with an angled splice but with a 90° splice.

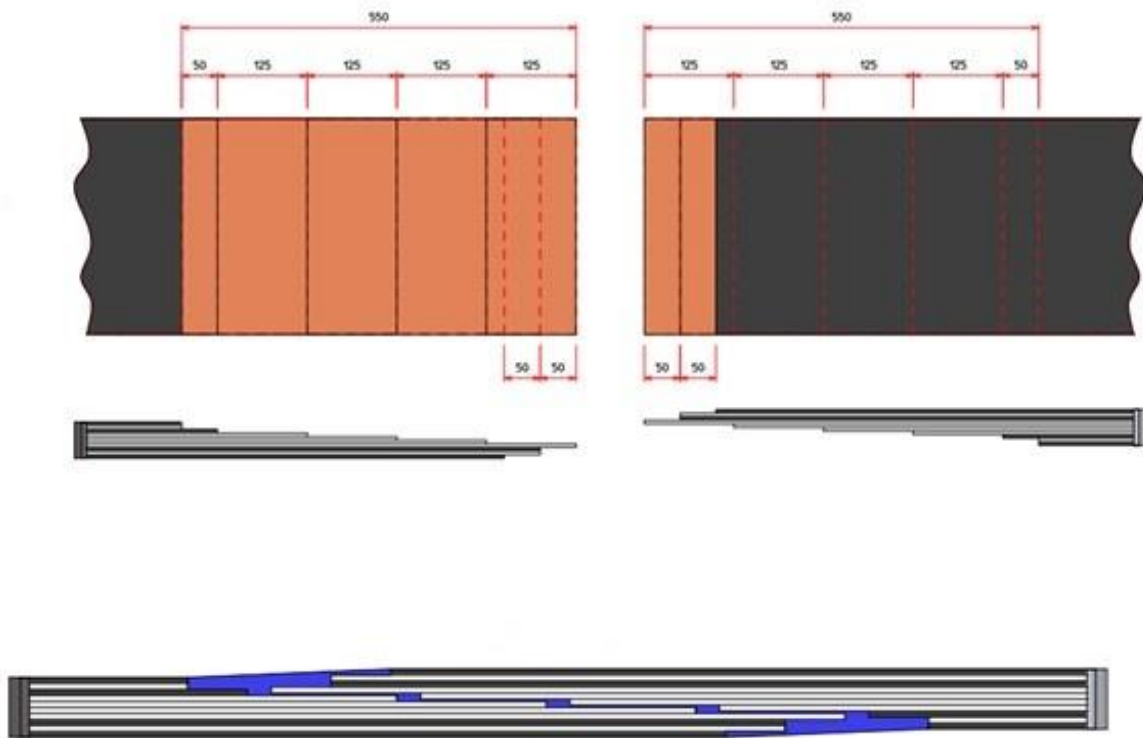
Splice width stable belts

This splice is used in all belts, width stable lanes with separate width stable and tensile fabrics:

The splice with three tensile fabrics and two transversely stable fabric layers

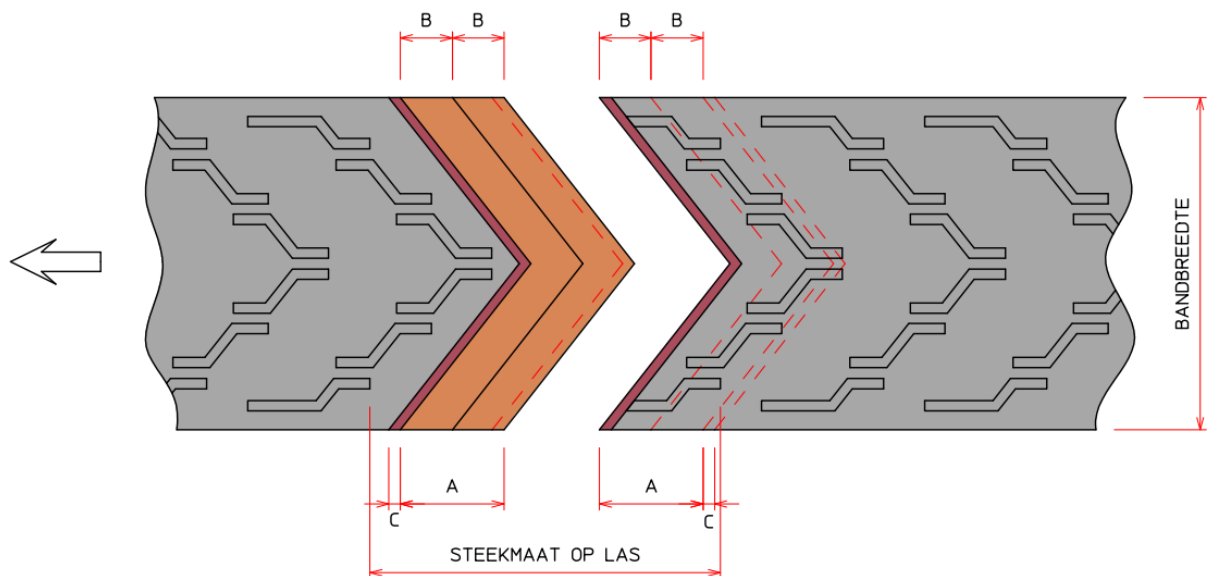


The splice with four tensile fabrics and two transversely stable fabric layers



For each additional tensile fabric, an extra step of 125 mm will be added, meaning that the splice will become 125 mm longer.

Splice chevron belts



LBS chevron belts are by default spliced with a spot splice and the underside in running direction. If possible, the splice is stitched within the tolerance of ± 50 mm. If this isn't possible, the belt will be custom fabricated, meaning that the profile distance relative to the splice can differ.

Number of fabric layers	Cleat distance profile	Splice length (mm)	Step length (mm)	Cover strip (mm)	Number of steps (B)
2	190	190	190	25	1
3	190	190		25	2
2	250	250	250	25	1
3	250	250	125	25	2
2	330	330	330	25	1
3	330	330	165	25	2
2	400	400	400	25	1
3	400	400	200	25	2
>3		By agreement			

With regard to the splice in the belt and the running direction of the belt, the default is as follows:

- Smooth belts: top running along
- Chevron belts and cleated belts: bottom running along.

This is applicable to both endless and prepared belts.

In the case of an internal scraper, it may be better to have the inside of the splice run along with the scraper.

In certain circumstances, such as drive and reverse drums that are too small, it can be advantageous to let the belt run in such a direction that the inside of the splice runs along with the belt.

Connectors

Mechanical connector for rubber conveyor belts			
Connector type	Material (connector / nail)	Fits belt thickness (mm)	Minimum drum diameter (mm)
RS 125 G	Galvanized steel	3.2 – 4.8	75
RS 125 SS	Stainless steel 1.4404	3.4 – 4.8	75
RS 187 G	Galvanized steel	4.8 – 6.4	100
RS 187 SS	Stainless steel 1.4404	4.8 – 6.4	100
U24 AS	Stainless steel / Stainless Chrome steel	4 – 5	75
U24 BS	Stainless steel / Stainless Chrome steel	5 – 6	75
U24 CS	Stainless steel / Stainless Chrome steel	6 – 7	75
H25 BS	Spring steel / Stainless steel	5 – 6	75
R 2	Galvanized steel	3.2 – 9.5	125
RS 2	Anti magnetic Stainless steel / Stainless steel	3.2 – 9.5	125
R 3	Galvanized steel	4.8 – 9.5	150
RS 3	Anti magnetic Stainless steel / Stainless steel	4.8 – 9.5	150
R 5	Galvanized steel	5.6 – 11.1	225
RLC 5	Stainless steel / Stainless Chrome steel	5.6 – 11.1	225
RS 5	Anti magnetic Stainless steel / Stainless steel	5.6 – 11.1	225
R 5½	C-Steel / Galvanized steel	9.5 – 15	300
RLC 5½	Stainless steel / Stainless Chrome steel	9.5 – 15	300
RC 5½	Stainless high chromium steel / Stainless steel	9.5 – 15	300
375X	Galvanized / Stainless steel	6 – 11	152 / 102*
550X	Galvanized / Stainless steel	6 – 16	230 / 178*
E35 A	C-Steel / Special steel	5 - 9	250
E35 B	C-Steel / Special steel	7 - 11	250
U35 A	Chrome steel / Spring steel	5 – 9	250
U35	Chrome steel / Spring steel	7 – 11	250
S35AS	Chrome steel / Stainless steel	5 – 9	250
S35BS	Chrome steel / Stainless steel	7 - 11	250
Superscrew 35	Steel and Stainless steel screw/clamp	At request	200
Superscrew 40	Steel and Stainless steel screw/clamp	At request	250
Superscrew 63	Steel and Stainless steel screw/clamp	At request	300

*at operating stress less than 75% of belt rating, a smaller drum can be used.

Dimensional tolerances rubber

Length tolerance open pieces (DIN EN ISO 14890:2013)

Delivery options	Maximum allowed deviation between delivered and ordered length
Full roll	+/-5%
Open length (cut)	+2,5% / -0
Open length (cut) with splicing preparation	+2.5% / -0

Length tolerance endless belts*

Belt type	Belt length (mm)	Tolerance
Flat belts	< 15 000	+/- 25 mm
	< 30 000	+/- 50 mm
	> 30 000	+/- 2,5%
Chevron belts	< 30 000	+/- 50 mm
	> 30 000	+/- 2,5%
Hotcleat belts	< 15 000	+/- 25 mm
	< 30 000	+/- 50 mm
	> 30 000	+/- 2,5%

*This includes belts with prepared splices

Belt width tolerance

From supplier (DIN EN ISO 14890:2013)

Nominal belt width (mm)	Belt width tolerance
< 500	+/- 5 mm
< 1 000	+/- 1%
< 2 000	+/- 1%
> 2 000	+/- 1%

After being cut in warehouse

Belt width (mm)	Belt width tolerance
< 500	+/- 2 mm
< 1 000	+/- 3 mm
< 2 000	+/- 4 mm
> 2 000	+/- 5 mm

Hotcleat tolerances

Cleat type	Cleat width* (mm)	Cleat height (mm)	Cleat thickness (mm)
Hotcleat® ≤ 60 mm	0 - 800 +/- 2 mm	+/- 1 mm	+/- 1 mm
	800 - 1 600 +/- 4 mm		
	1 600 - 2 200 +/- 5 mm		
Hotcleat® 60 - 140 mm	0 - 1 200 +/- 3 mm	+/- 2 mm	+/- 2 mm
	1 200 - 1 800 +/- 5 mm		
Hotcleat® ≥ 140 mm	0 - 1 200 +/- 3 mm	+/- 5 mm	+/- 2 mm
Ecocleat®	0 - 800 +/- 2 mm	+/- 1 mm	+/- 1 mm
	800 - 1 700 +/- 4 mm		

*Cleat width should be measured at its base, where it was vulcanized onto the belt.

Areas of application

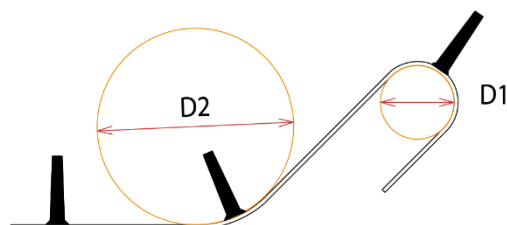
Transport belts

The product specifications and areas of application of our flat transport belts and chevron belts can be found on their product data sheets.

Hotcleat®



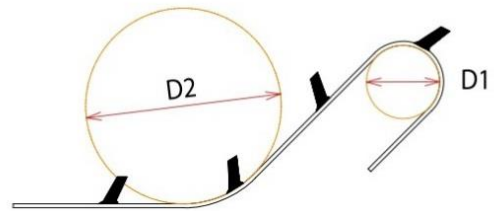
T-cleats



Minimum drum diameters*						
Type	10 mm thick		20 mm thick		30 mm thick	
	D1 min	D2 min	D1 min	D2 min	D1 min	D2 min
T10	160	200	-	-	-	-
T15	160	200	275	350	-	-
T20	160	200	275	350	-	-
T30	160	200	275	350	-	-
T40	160	200	275	350	315	400
T50	160	200	275	350	315	400
T60	160	200	275	350	315	400
T75	160	200	275	350	315	400
T90	160	200	275	350	315	400
T110	-	-	275	350	315	400
T140	-	-	275	350	315	400
T160	-	-	275	350	315	400
T180	-	-	275	350	315	400
T230	-	-	275	350	315	400

*Minimum drum diameter depends on the base belt and possible rubber sidewalls, guide ropes and longitudinal edges, among others.

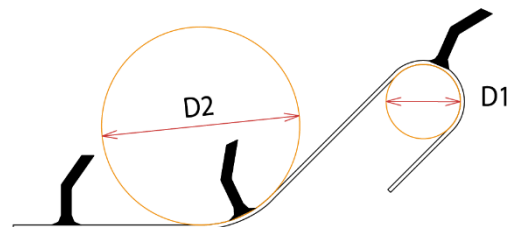
C-cleats



Minimum drum diameters*						
Type	10 mm thick		20 mm thick		30 mm thick	
	D1 min	D2 min	D1 min	D2 min	D1 min	D2 min
C35	160	200	-	-	-	-
C55	160	200	275	350	-	-
C75	160	200	275	350	315	400
C90	160	200	275	350	315	400
C110	-	-	275	350	315	400
C140	-	-	275	350	315	400

*Minimum drum diameter depends on the base belt and possible rubber sidewalls, guide ropes and longitudinal edges, among others.

TC-cleats



Minimum drum diameters*						
Type	15 mm thick		20 mm thick		30 mm thick	
	D1 min	D2 min	D1 min	D2 min	D1 min	D2 min
TC75	160	200	275	350	315	400
TC90	160	200	275	350	315	400
TC110	-	-	275	350	315	400
TC140	-	-	275	350	315	400
TC160	-	-	275	350	315	400
TC180	-	-	275	350	315	400
TC200	-	-	-	-	315	400
TC230	-	-	-	-	315	400

*Minimum drum diameter depends on the base belt and possible rubber sidewalls, guide ropes and longitudinal edges, among others.

Ecocleat®



Type	Height (mm)	Minimum drum diameter* (mm)	Minimum drum diameter counter-bend (mm)*
T40	40	110	160
T50	50	125	175
T60	60	150	200
T70	70	175	240

*Minimum drum diameter depends on the base belt and possible rubber sidewalls, guide ropes and longitudinal edges, among others.

Guide ropes hot vulcanized

Guide rope type	Material options:	Height (mm)	Width (mm)	Minimum drum diameter (mm)	Minimum drum diameter counter-bent (mm)*
V13x8	SB65/MOR62	13	8	160	200
V17x11	SB65/MOR62	17	11	200	250
V22x14	SB65/MOR62	22	14	250	300
V30x16	SB65/MOR62	30	16	300	350

*Minimum drum diameter depends on the base belt and possible rubber sidewalls, cleats, and guide ropes, among others.

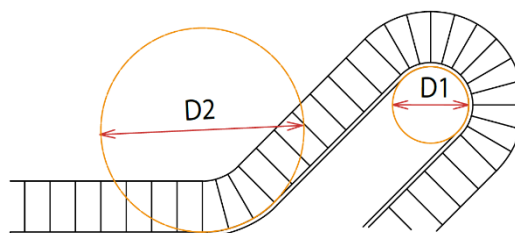
Longitudinal edges hot vulcanized

Longitudinal edge type	Material options:	Height (mm)	Width (mm)	Minimum drum diameter (mm)	Minimum drum diameter counter-bent (mm)*
T10/10	SB50/MOR50	10	10	160	200
T15/10	SB50/MOR50	15	10	300	350
T15/20	SB50/MOR50	15	20	300	350
T20/10	SB40/SB50/MOR50	20	10	325	375
T20/20	SB50/MOR50	20	20	325	375
T30/10	SB50/MOR50	30	10	350	400
T30/20	SB50/MOR50	30	20	350	400
V13x8	SB45	13	8	250	300
V17x11	SB45/SB65/MOR62	17	11	300	350
V22x14	SB45/SB65	22	14	325	375
V17x17	SB45	17	17	300	350
V20x17	SB45	20	17	325	375

V25x22	SB45	25	22	350	400
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*Minimum drum diameter depends on the base belt and possible rubber sidewalls, cleats, and guide ropes, among others.

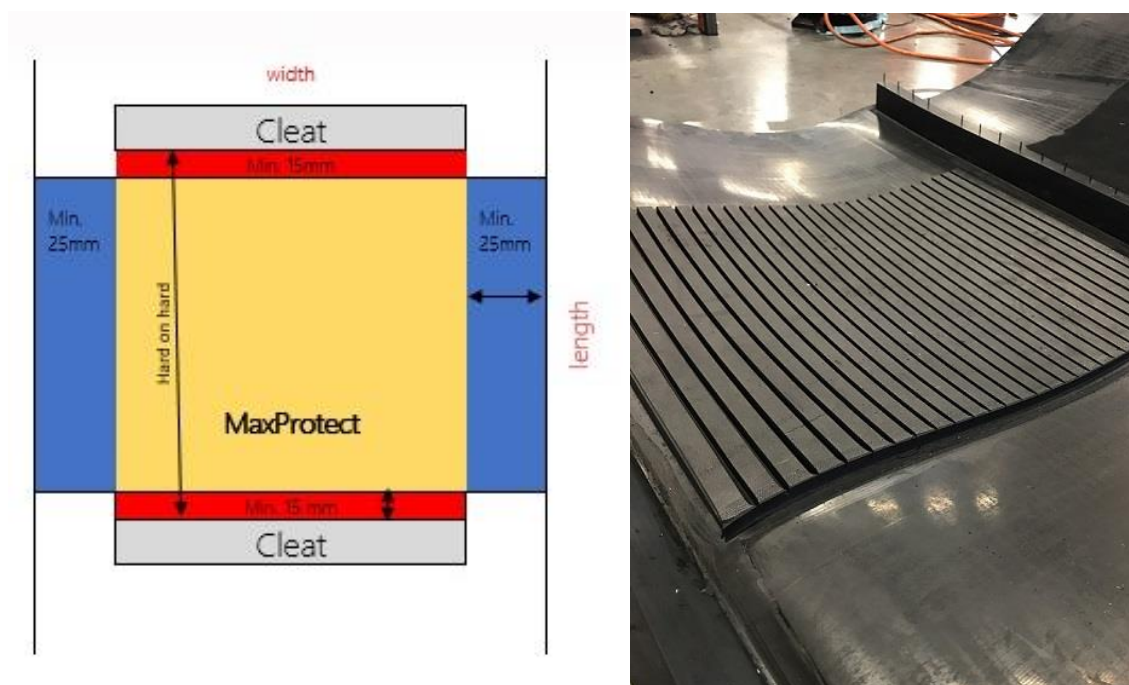
Wavy edges cold vulcanized



Wavy egde type	Wavy edge base width (mm)	Fabric reinforced (Y/N) (Y = EP125)	Cleat distance of the sidewall for sidelock (mm)	Minimum drum diameter (mm)*	Minimum drum diameter counter-bent (mm)*
L40/30	30	N	N/A	160	200
L60/50	50	N	50	180	250
L80/50	50	N	50	215	320
L100/50	50	N	50	250	400
L120/50	75	N	50	315	500
LW120/75	75	Y	60	315	500
LW160/75	75	Y	60	400	650
LW180/75	75	Y	60	450	700
LW200/75	75	Y	60	500	800
LW240/75	75	Y	60	600	1 000
LW280/75	75	Y	60	700	1 200
LW300/75	75	Y	60	650	1 200
LW300/110	110	Y	80	700	1 400
LW350/110	110	Y	80	700	1 400
LW400/110	110	Y	80	700	1 400

*Minimum drum diameter depends on the base belt and possible cleats, guide ropes and longitudinal edges, among others.

MaxProtect



Thickness (mm)	Distance between cleats (mm)	Minimum width (mm)	Max. width (mm)	Rubber type
4	Min. 200 Max. 720	1	1 200*	SB65
6				
8				
10				
12				
15				

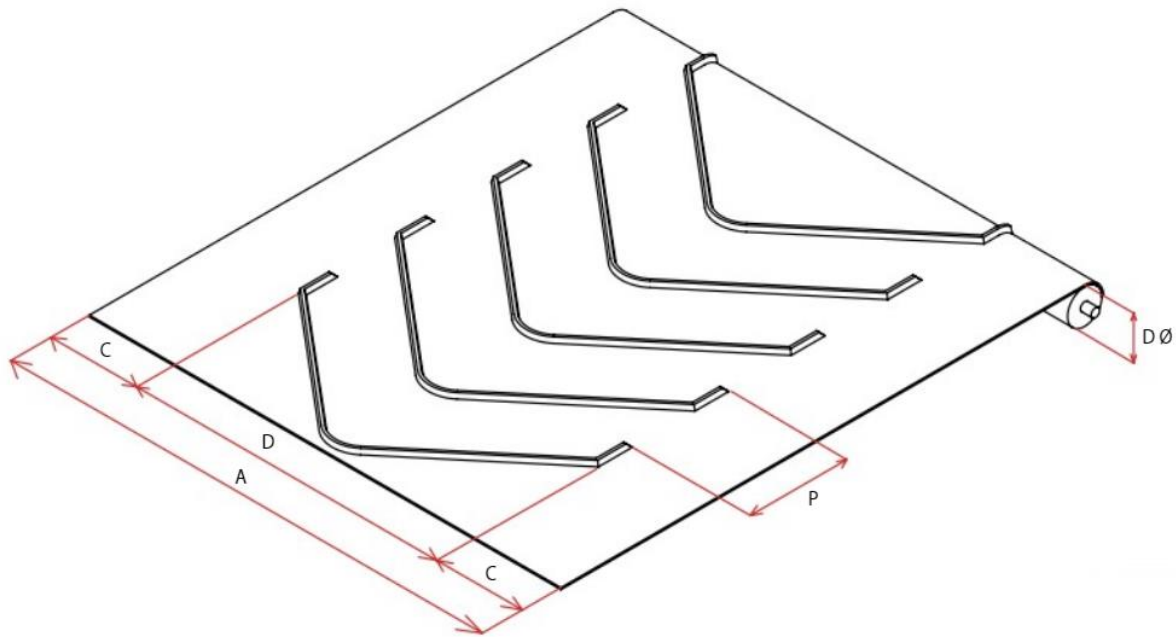
Belt width must always be 25 mm wider on both sides than the MaxProtect

At request, standard versions can be customized; with notches, for example.

Special chevron profiles vulcanized

We can vulcanize these chevron profiles onto all standard belt types in our own production facility. Prior to this process, we will roughen the entire belt over the width of the profile that the customer ordered. These profiles are available in various versions:

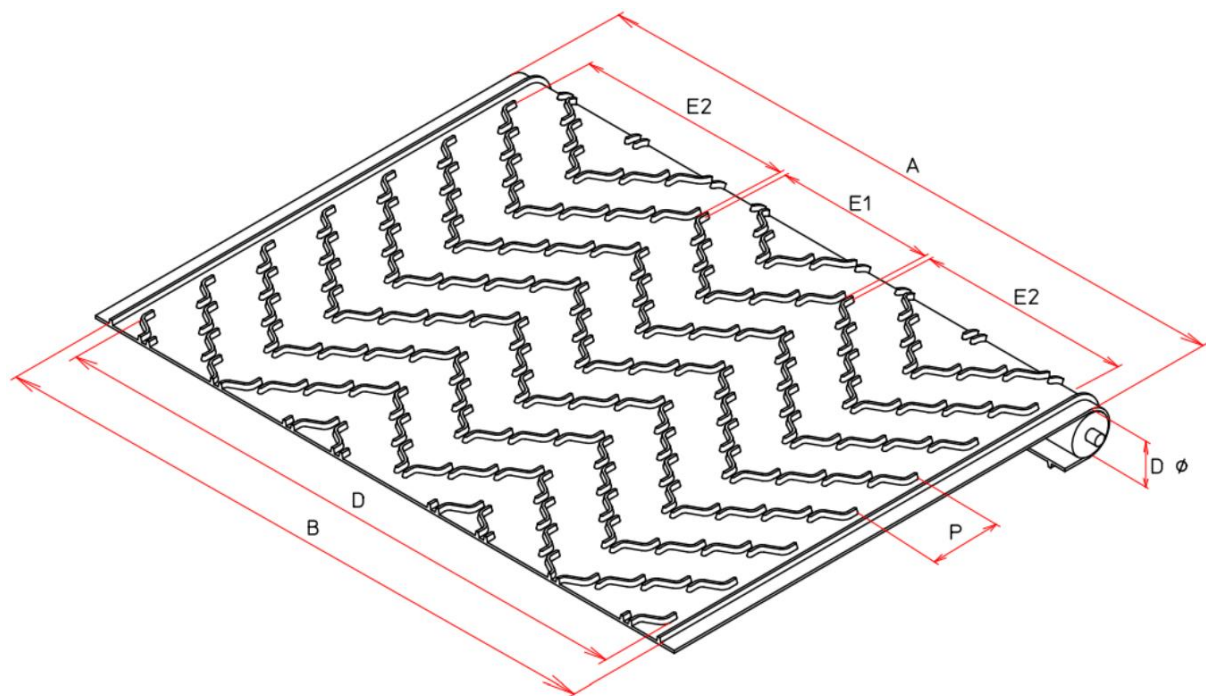
M1400



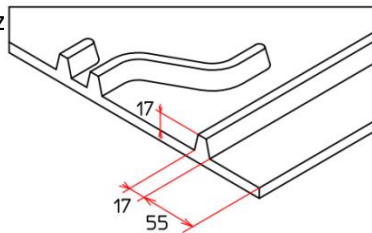
Available options M1400	
Size	(mm)
Profile height	22
A	1 800 – 2 400
C	200 - 500
D	1 400
P	400

DØ = minimum drum diameter. In this case, the determining factor is the minimum drum diameter of the type of belt.

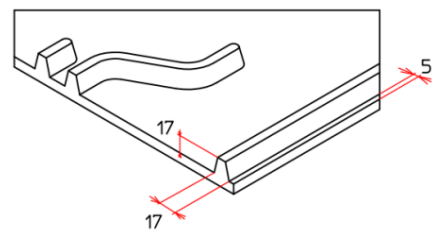
G2185



LI = Longitudinal edge 55 mm free zone
free zone



LO = Longitudinal edge 5mm



SV = Single V profile

DV = Double V profile

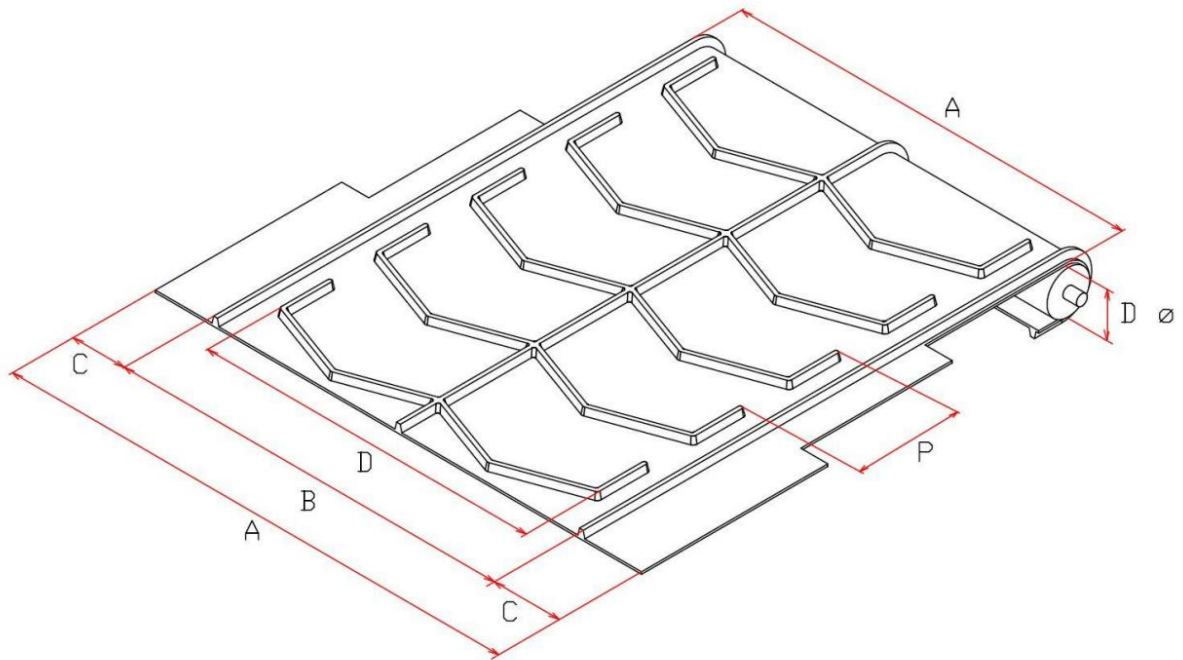
TV = Triple V profile

DØ = minimum drum diameter. In this case, the determining factor is the minimum drum diameter of the type of belt.

Available options G profile, width 400 – 2 400 mm					
Profile	Belt width available (mm)	Profile width with longitudinal edge (B) (mm)	Profile width without longitudinal edge (B) (mm)	Cleat distance profile (P) (mm)	Free zone (mm)
G385 SV	400 ~ 800	-	385	250	7.5 – 207.5
G385 SV LI	600	490	385	250	55
G385 SV LO	600	590	385	250	5
G585 SV	600 ~ 1 000	-	585	250	7.5 – 207.5
G585 SV LI	800	690	585	250	55

G585 SV LO	800	790	585	250	5
G785 SV	800 ~ 1 200	-	785	250	7.5 – 207.5
G785 SV LI	1 000	890	785	250	55
G785 SV LO	1 000	990	785	250	5
G985 SV	1 000 ~ 1 400	-	985	250	7.5 – 207.5
G985 SV LI	1 200	1 090	985	250	55
G985 SV LO	1 200	1 190	985	250	5
G1185 SV	1 200 ~ 1 600	-	1 185	250	7.5 – 207.5
G1185 SV LI	1 400	1 290	1 185	250	55
G1185 SV LO	1 400	1 390	1 185	250	5
G1185 DV	1 200 ~ 1 600	-	1 185	250	7.5 – 207.5
G1185 DV LI	1 400	1 290	1 185	250	55
G1185 DV LO	1 400	1 390	1 185	250	5
G1385 DV	1 400 ~ 1 800	-	1 385	250	7.5 – 207.5
G1385 DV LI	1 600	1 490	1 385	250	55
G1385 DV LO	1 600	1 590	1 385	250	5
G1585 DV	1 600 ~ 2 000	-	1 585	250	7.5 – 207.5
G1585 DV LI	1 800	1 690	1 585	250	55
G1585 DV LO	1 800	1 790	1 585	250	5
G1785 DV	1 800 ~ 2 200	-	1 785	250	7.5 – 207.5
G1785 DV LI	2 000	1 890	1 785	250	55
G1785 DV LO	2 000	1 990	1 785	250	5
G1985 DV	2 000 ~ 2 400	-	1 985	250	7.5 – 207.5
G1985 DV LI	2 200	2 090	1 985	250	55
G1985 DV LO	2 200	2 190	1 985	250	5
G1985 TV	2 000 ~ 2 400	-	1 985	250	7.5 – 207.5
G1985 TV LI	2 200	2 090	1 985	250	55
G1985 TV LO	2 200	2 190	1 985	250	5
G2185 TV	2 400	-	2 185	250	7.5 – 207.5
G2185 TV LI	2 400	2 290	2 185	250	55
G2185 TV LO	2 400	2 390	2 185	250	5

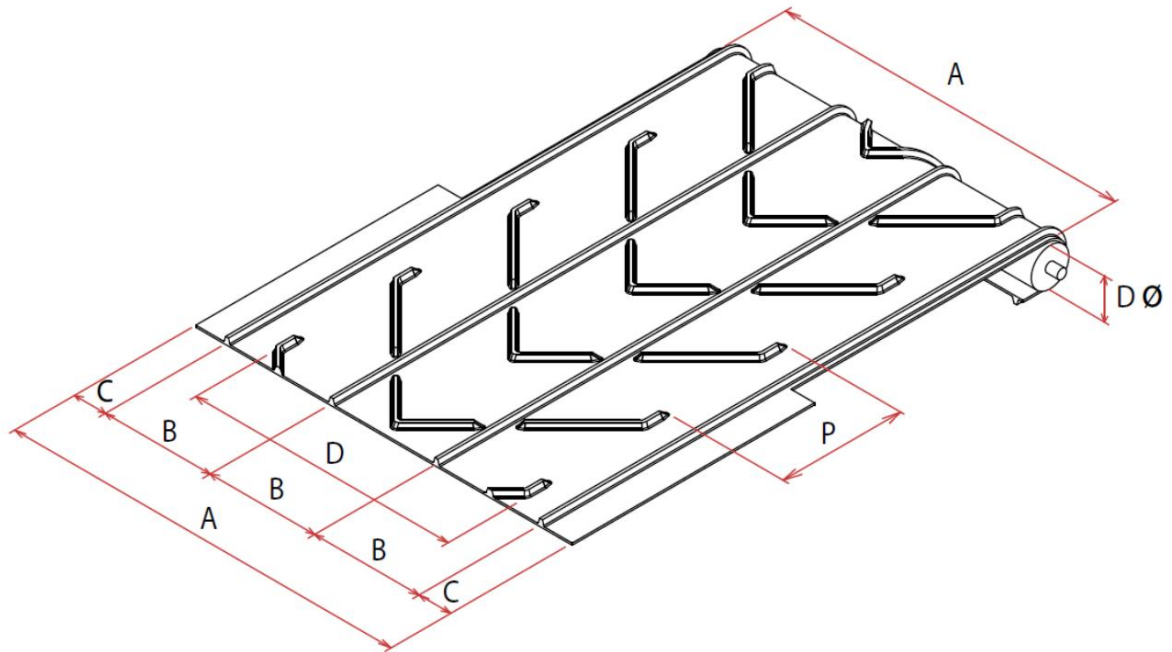
MC1380



Available options M1380	
Size	(mm)
Profile height	25
A	1 400 – 2 400
C	10 - 560
D	1 190
P	335

DØ = minimum drum diameter. In this case, the determining factor is the minimum drum diameter of the type of belt.

M1335



Available options M335	
Size	(mm)
Profile height	25
A	1 400 – 2 400
B	445
C	32.5 – 532.5
D	1 077
P	480

$D\varnothing$ = minimum drum diameter. In this case, the determining factor is the minimum drum diameter of the type of belt.

Synthetic belt specifications

Belt markings are structured as follows:

254 P26 a SU white

1	2*	3*	4*	5*	6*	7*
2	5	4	P26	a	SU	White
Number of fabric layers	Fabric type	Combination top and bottom covering	Profile type	Special belt characteristics	Belt material	Colour

*See below tables, which identifies components

2 Fabric type		
Code	Type	Additional description
0	No fabric	
1	Polyester multi filament	Not width stable
2	Polyester mono filament	Width stable
3	Polyester (chain) / Cotton (impact)	
4	2 x type 5 sewn together	
5	Polyester mono filament	Width stable, light version
6	Polyester multi filament	3x as heavy as type 1
7	Polyester mono filament	Extra width stable
8	Solid woven	

3 combination top and bottom covering			
Code	Remark	Top covering	Bottom covering
0		PVC 0.2 mm, smooth	PVC 0.8 mm, with diamond P1
1	Fabric type 1, 2, 6, 7	PVC 0.7 mm, smooth	PVC 0.8 mm, with diamond P1
	Fabric type 5	PVC 0.4 mm, smooth	PVC 0.8 mm, with diamond P1
		PU 0.2 or 0.3 mm, smooth	PU small diamond or other shallow profile
2		PVC 0.7 mm, smooth	PVC 0.7 mm, matt (P0)
3		PVC 2 mm, smooth	PVC 0.8 mm, with diamond P1
4	Fabric type 1, 2, 6, 7	PVC 0.7 mm, smooth	Fabric
	Fabric type 5	PVC 0.4 mm, smooth	Fabric
		PU 0.2 or 0.3 mm, smooth	Fabric, impregnated
5		PVC 1.5 mm, smooth	Fabric
	The bottom of white and blue PVC belts is impregnated by default.		
		PU 1.0 mm, smooth	Fabric, impregnated
6		PVC 2.0 mm, smooth	Fabric
	The bottom of white and blue PVC belts is impregnated by default.		
7		Fabric	Fabric
8		PVC 2.0 mm, smooth	PVC 1.0 mm, smooth, matt (P0)

9	PVC 1.0 mm smooth	Fabric
The bottom of white and blue belts is impregnated by default.		

4 Profile types

Code	Description	Code	Description
P0	Matt	P20	Cone profile
P1	Diamond 2 mm	P21	Fabric print
P2	Mini diamond 1 mm	P22	Tobacco studs
P3	Supergrip	P23	Staggered sawtooth
P4	Stud 1 mm	P24	
P5	Pipit	P25	Diamond 62 mm
P6	Sawtooth	P26	Diamond 1.5 mm
P7	Bar grip	P27	Diamond 20 mm
P8	Triangle	P28	
P9	½ Supergrip	P29	Crescent
P10	Rough matt	P30	Hollow oval
P11	Crossrib 8 mm	P31	Positive square (embossed)
P12	Crossrib 15 mm	P32	Twisted wire
P13	Herringbone closed	P33	Velvett Matt
P14	Herringbone open	P34	Rice grain
P15	Big stud		
P16	Sandblast		
P17	Wave		
P18	Harlequin		
P19	Longitudinal rib		

5 Special belt characteristics

Code	Description	Remark
10ht	1.0 mm Hytrel®	Extra top covering on the belt
10us	1.0 mm sprayed polyurethane	Extra top covering on the belt
12P	1.2 mm polyester felt with NBT impregnation	Extra top covering on the belt
a	Antistatic	
am	Antimicrobial	
d	Deviating thickness of intermediate layers	
fr	Frayless	Fabric doesn't fluff on side
h85	Hardness of top covering	85°Sh-A, in this case
hy	Increased water resistance	Especially with PU
i	Impregnated	
n	Oil and fat resistant	
r	Rubber supplement	Rubber mixed into compound
rf	Raw Food	Suitable for unprocessed foodstuffs
s55	Soft PVC top covering	Top covering 55°Sh-A, in this case
sp	Spun fabric	
t	Transparent intermediate layers	
v	Felt	

w	Whisper fabric	
wx	Wax impregnated / whisper fabric	
z	Black fabric	

6 Material		
Code	Description	Remark
None	PVC	PVC, in absence of code
HT	Hytrel®	
Pe	Polyethylene	
Si	Silicone	
Su85°Si	Polyurethane 85°/Silicone	PU 85°Sh-A with silicone top covering
Su	Polyurethane 86°	Soft PU 86°Sh-A
U	Polyurethane 92°	Standard PU 92°Sh-A

7. Colour index	
Code	Colour description
G	Green
W	White
B	Blue
Z	Black
T	Transparent
C	Off white
P	Petrol
	Grey

Splices synthetic belts

Splice type	Measurement finger or splice length (mm)	For belt type	Specific characteristic
V-splice 70/15	70 x 15	1-layer PU/PE/HT 2-layer PU/PE/HT	For belts that can't be spliced
VLV-splice 50/20	50 x 20	2-layer PVC	
VLVL-splice 50/20	50 x 20	3-layer PVC	
T-splice	70	2-layer PVC 3-layer PVC	Width stability maintained in splice

Connectors

Mechanical connectors suitable for synthetic conveyor belts			
Connector type	Material	Fits belt thickness (mm)	Minimum drum diameter (mm)
RS 62 G	Galvanized steel	1.5 – 3.2	Ø50
RS 62 SS	Stainless steel 304	1.5 – 3.2	Ø50
RS 125 G	Galvanized steel	3.2 – 4.8	Ø75
RS 125 SS	Stainless steel 304	3.2 – 4.8	Ø75
RS 187 G	Galvanized steel	4.8 – 6.4	Ø100
RS 187 SS	Stainless steel 304	4.8 – 6.4	Ø100
M61 SW SS	Stainless steel 304	0.8 – 1.6	Ø25
M61 NW SS	Stainless steel 304	2.4 – 3.2	Ø50
M62 SW SS	Stainless steel 304	1.6 – 2.4	Ø25
M62 NW SS	Stainless steel 304	2.4 – 3.2	Ø50
M63 SW SS	Stainless steel 304	1.6 – 2.4	Ø25
M63 NW SS	Stainless steel 304	2.4 – 3.2	Ø50
M63 LW SS	Stainless steel 304	3.2 – 4.0	Ø75
R72 NP S	Stainless steel 316	3 – 4	Ø50
M82 S	Stainless steel 304	3 – 4	Ø50
M83	Special steel wire "C"	4 – 5	Ø75
M83 S	Stainless steel 304	4 – 5	Ø75
M84	Special steel wire "C"	5 – 6	Ø100
M84 S		5 – 6	Ø100
M84 SS	Stainless steel 304	5 – 6	Ø100
Spiral connector VE-65-MO, white	Pet multi fil.	N/A	Ø30
Spiral connector VE-65-MGS, black	Pet Multi fil./Spun Mix	N/A	Ø30
Spiral connector VE-65-MGS, white	Pet Multi fil./Spun Mix	N/A	Ø30

Dimensional tolerances synthetic materials

Length tolerance open pieces (DIN EN ISO 14890:2013)

Delivery options	Maximum allowed deviation between delivered and ordered length
Full roll	+5% / -0%
Cut off length	+2,5% / -0
Open pieces with splice	+2.5% / -0

Length tolerance endless belts*

Belt type	Belt length (mm)	Tolerance
Flat belts	< 10,000	+/- 10 mm
	< 30 000	+/- 30 mm
	> 30 000	+/- 50 mm
Cleat / Sidewall belts	< 10,000	+/- 20 mm
	>10,000	+/- 50 mm
	< 30 000	+/- 50 mm
	> 30 000	+/- 2,5%

*This includes belts with prepared splices

Belt width tolerance

Full roll from supplier

Nominal belt width (mm)	Belt width tolerance
≤ 2 000	+/- 0,5%
> 2 000	+/- 1%

After being cut in warehouse

Belt width (mm)	Belt width tolerance
≤ 1 000	+/- 1 mm
≤ 2 000	+/- 2 mm
> 2 000	+/- 3 mm

Tolerances cleats

Cleat type	Cleat width (mm)	Cleat height (mm)
T-cleat, Full synthetic, ≤ 60 mm	0 - 1 200 +/- 1 mm	+0 mm / -2 mm
	1 200 - 3 000 +/- 2 mm	
T-cleat, Full synthetic, 60-100 mm	0 - 1 200 +/- 1 mm	+0 mm / -2 mm
	1 200 - 3 000 +/- 2 mm	
TC-cleat, Full synthetic, ≤ 60 mm	0 - 1 200 +/- 1 mm	+/- 1.5 mm
	1 200 - 3 000 +/- 2 mm	
TC-cleat, Full synthetic, 60-75 mm	0 - 1 200 +/- 2 mm	+/- 2 mm
	1 200 - 3 000 +/- 2 mm	
TC-cleat, Full synthetic, 100 mm	0 - 1 200 +/- 2 mm	+/- 4 mm
	1 200 X 3 000 +/- 2 mm	
Fabric reinforced ≤50mm	0 - 1 200 +/- 2 mm	+2 mm / -2 mm
	1 200 - 1 850 +/- 3 mm	
Fabric reinforced 50-100 mm	0 - 1 200 +/- 2 mm	+2 mm / -2 mm
	1 200 - 1 850 +/- 3 mm	

Areas of application

Belts

The areas of application and the specific product characteristics of smooth basic belts can be found in each product's data sheet.

Cleats

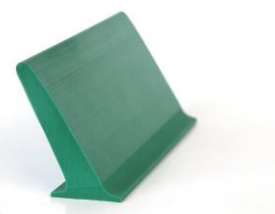
Full PVC cleats



T-cleat



TC-cleat



C-cleat

Full PVC cleats					
Height (mm)	Cleat type			Hardness (°Sh-A)	Min. Drum diameter (mm)**
	T	TC	C		
	Available colours*				
20	G/Z/W/B			60 +/- 3	50
30	G/Z/W/B	G/W/B	G/Z/W/B	60 +/- 3	75
40	G/Z/W/B	G/W/B	G/Z/W/B	60 +/- 3	100
50	G/Z/W/B	G/W/B	G/Z/W/B	60 +/- 3	125
60	G/Z/W/B	G/W/B	G/Z/W/B	60 +/- 3	150
70	G/Z/W/B			60 +/- 3	175
75	G/Z/W/B	G/W/B	G/Z/W/B	60 +/- 3	185
100		G/W/B		60 +/- 3	250

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

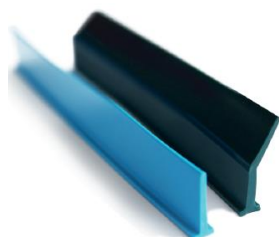
Height (mm)	Available colours***	Hardness (°Sh-A)	Minimum drum diameter (mm)**
20	G/Z/W/B	60 +/- 3	150
30	G/Z/W/B	60 +/- 3	250
40	G/Z/W/B	60 +/- 3	350
50	G/Z/W/B	60 +/- 3	450
60	G/Z/W/B	60 +/- 3	550
70	G/Z/W/B	60 +/- 3	650

*Custom versions might be available at request

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

*** Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

PU-cleats



Pu-cleats (high-frequent)			
Cleat type	Available colours*	Hardness (°Sh-A)	Minimum drum diameter (mm)**
TU 20	G/W/B/Z		40
TU 25	G/W/B/Z		40
TU 30	G/W/B/Z		45
TU 35	G/W/B/Z		45
TU 40	G/W/B/Z		50
TU 50	G/W/B/Z		55
TU 60	G/W/B/Z		60

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

PE-cleats



Cleat type	Available colours	Minimum drum diameter (mm)*
TE 20	T	50
TE 30	T	75
TE 40	T	100
TE 50	T	125

Suitable for unpackaged foodstuffs. Not all colours and types are in stock.

* Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

PVC block cleats

PVC block cleats				
Cleat type	Available colours*	Height (mm)	Width (mm)	Minimum drum diameter (mm)**
B 10x10	G/Z/W/B	10	10	100
B 15x15	G/Z/W/B	15	15	100
B 20x15	G/Z/W/B	20	15	100

* Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

PVC block cleats for V-profiles

Version and shape of V-profiles are always discussed.

Cleats for V-profiles				
Cleat type	Available colours*	Height (mm)	Width (mm)	Minimum drum diameter (mm)**
BG 10x10	G/Z/W/B	10	10	100
BG 15x15	G/Z/W/B	15	15	150
BG 20x15	G/Z/W/B	20	15	200
BG 25x15	G/Z/W/B	25	15	250
BG 30x15	G/Z/W/B	30	15	300

* Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

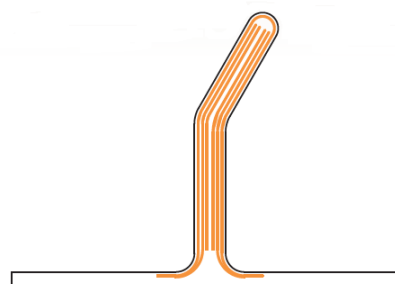
V-belt cleats (perpendicular to belt)

V-belt cleats				
Cleat type	Available colours*	Height (mm)	Width (mm)	Minimum drum diameter (mm)**
PVC				
V 6x4	G/Z/W/B	4	10	40
V 8x5	G/Z/W/B	5	18	50
V 10x6	G/Z/W/B	6	10	70
V 13x8	G/Z/W/B	8	13	90
V 17x11	G/Z/W/B	11	17	100
V 22x14	G/Z/W/B	14	22	150
V 30x16	G/Z/W/B	16	30	250
PU				
VU 6x4	W/T	4	6	40
VU 8x5	W/T	5	8	50
VU 10x6	W/T	6	10	70
VU 13x8	W/T	8	13	90
VU 17x11	W/T	11	17	110
PE				
VE 6x4	Transparent	4	6	50
VE 8x5	Transparent	5	8	60
VE 10x6	Transparent	6	10	80
VE 13x8	Transparent	8	13	90
VE 17x11	Transparent	11	17	100

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

Fabric reinforced cleats



Cleat type	Available colours*	Height (mm)	Cleat thickness (mm)	Minimum drum diameter (mm)**
TW 20	G/Z/W/B	20	9 ± 0.5	30
TW 30	G/Z/W/B	30	9 ± 0.5	40
TW 40	G/Z/W/B	40	9 ± 0.5	40
TW 50	G/Z/W/B	50	9 ± 0.5	50
TW 60	G/Z/W/B	60	9 ± 0.5	60
TW 70	G/Z/W/B	70	9 ± 0.5	70
TW 80	G/Z/W/B	80	9 ± 0.5	80
TW 90	G/Z/W/B	90	9 ± 0.5	90
TW 100	G/Z/W/B	100	9 ± 0.5	100
TCW 40	G/Z/W/B	40	9 ± 0.5	40
TCW 50	G/Z/W/B	50	9 ± 0.5	50
TCW 60	G/Z/W/B	60	9 ± 0.5	60
TCW 70	G/Z/W/B	70	9 ± 0.5	70
TCW 80	G/Z/W/B	80	9 ± 0.5	80
TCW 90	G/Z/W/B	90	9 ± 0.5	90
TCW 95	G/Z/W/B	95	9 ± 0.5	95

\$ Blue and white are suitable for unpackaged foodstuffs

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

*** Cleats longer than 1 200 mm can't be manufactured in one piece, and will have a transitional section.

V-belt synthetic(guide rope)

V-belt synthetic				
Type	Available colours*	Height (mm)	Width (mm)	Minimum drum diameter (mm)**
PVC				
V 6x4	G/Z/W/B	4	6	25
V 8x5	G/Z/W/B	5	8	30
V 10x6	G/Z/W/B	6	10	40
V 13x8	G/Z/W/B	8	13	50
V 17x11	G/Z/W/B	11	17	70
V 22x14	G/Z/W/B	14	22	85
V 30x16	G/Z/W/B	16	30	100
PU				
VU 8x5	W/T	5	8	60
VU 10x6	G/W/B/T	6	10	70
VU 13x8	G/W/B/T	8	13	90
VU 17x11	G/W/B/T	11	17	100
PE				
VE 6x4	T	4	5	50
VE 8x5	T	5	8	60
VE 10x6	T	6	10	70
VE 13x8	T	8	13	90
VE 17x11	T	11	17	100
PVC				
VK 8x5	G/Z/W/B	5	8	15
VK 10x6	G/Z/W/B	6	10	20
VK 13x8	G/Z/W/B	8	13	25
VK 17x11	G/Z/W/B	11	17	35
VK 22x14	G/Z/W/B	14	22	45
VK 30x16	G/Z/W/B	16	30	50

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

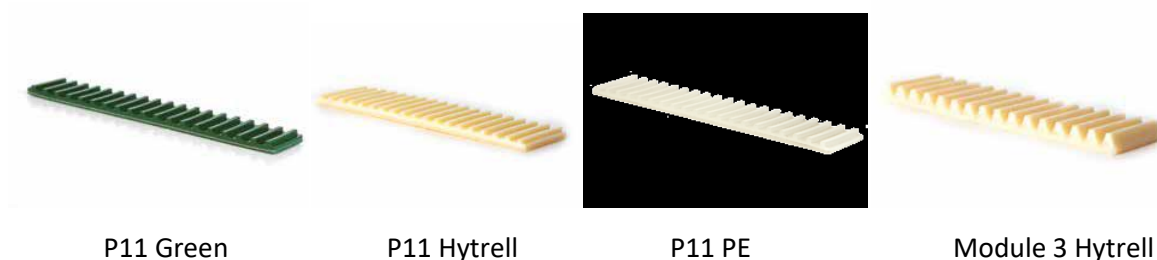
Block ropes PVC

Block rope PVC				
Type	Colour	Height (mm)	Width (mm)	Minimum drum diameter (mm)*
PVC				
B 10x10	G/Z/W/B	10	10	80
B 15x15	G/Z/W/B	15	15	120
BG55 10x10	G/Z/W/B	10	10	80
BG55 15x15	G/Z/W/B	15	15	120
BG55 20x15	G/Z/W/B	20	15	150
BK 15x20	G/Z/W/B	15	20	140

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

Guide strips



Block rope PVC				
Type	Colour*	Height (mm)	Width (mm)	Minimum drum diameter (mm)**
P11 - PVC	G/Z/W/B	5	At request	30
Smooth – PVC	G/Z/W/B	3,5	At request	20
P11 – Hytrel	G	6	9 - 60	40
P11 – PE	T	6	At request	40
Module 3 - Hytrel	G	9	9 - 60	40

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, guide ropes and longitudinal edges, among others.

Longitudinal edges PVC

Type	Colour*	Hardness (°Sh-A)	Height longitudinal edge (mm)	Width longitudinal edge (mm)	Minimum drum diameter (mm)
BG35 10x10	G/W/B/Z	35	10	10	100
BG35 15x15	G/W/B/Z	35	15	15	150
BG45 10x10	G/W/B/Z	45	10	10	100
BG45 15x15	G/W/B/Z	45	15	15	150
BG55 10x10	G/W/B/Z	55	10	10	100
BG55 15x15	G/W/B/Z	55	15	15	150
BG55 20x15	G/W/B/Z	55	20	15	200
BG55 25x15	G/W/B/Z	55	25	15	250
BG55 30x15	G/W/B/Z	55	30	15	300
T20	P/G	60	20	18	150

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, cleats, and guide ropes, among others.

Longitudinal edges PVC V-belt

V-belt synthetic				
Type	Available colours*	Height (mm)	Width (mm)	Minimum drum diameter (mm)**
PVC				
V 6x4	G/Z/W/B	4	6	50
V 8x5	G/Z/W/B	5	8	60
V 10x6	G/Z/W/B	6	10	80
V 13x8	G/Z/W/B	8	13	100
V 17x11	G/Z/W/B	11	17	120
PU				
VU 8x5	W/T	5	8	60
VU 10x6	G/W/B/T	6	10	80
VU 13x8	G/W/B/T	8	13	100
VU 17x11	G/W/B/T	11	17	140
PE				
VE 6x4	T	4	5	50
VE 8x5	T	5	8	60
VE 10x6	T	6	10	80
VE 13x8	T	8	13	100
VE 17x11	T	11	17	120

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible sidewalls, cleats, and guide ropes, among others.

sidewalls

Type	PVC		PU		Cleat distance sidewall (mm)	Min. drum diameter (mm)**
	Mat. Thickne ss / Width	Colours*	Mat. Thickness / Width	colours		
L20/32	4 / 32	G/W/B/Z	3 / 30	W/B	30	40
L30/32	4 / 32	G/W/B/Z	3 / 30	W/B	30	60
L40/32	4 / 32	G/W/B/Z	3 / 30	W/B	30	80
L50/32	4 / 32	G/W/B/Z	3 / 30	W/B	30	100
L50/32	4 / 32	G/W/B/Z	3 / 30	W/B	30	120
L60/32	4 / 32	G/W/B/Z	3 / 30	W/B	30	140
L20/50	5 / 50	G/W/B/Z	-	-	50	40
L30/50	5 / 50	G/W/B/Z	-	-	50	90
L40/50	5 / 50	G/W/B/Z	-	-	50	120
L50/50	5 / 50	G/W/B/Z	-	-	50	150
L60/50	5 / 50	G/W/B/Z	-	-	50	180
L70/50	5 / 50	G/W/B/Z	-	-	50	210
L80/50	5 / 50	G/W/B/Z	-	-	50	240
L100/50	5 / 50	G/W/B/Z	-	-	50	300
L100/50	5 / 50	G/W/B/Z	-	-	50	360

*Blue and white are suitable for unpackaged foodstuffs. Not all colours and types are in stock.

** Minimum drum diameter depends on the base belt and possible guide ropes, cleats and longitudinal edges, among others.

*** Maximum size depends on belt type and total weight, among others

Gauze conveyor belts

Mesh size	Wire thickness Ø (mm)	Thickness (mm)	Weight (kg/m ²)	Open (%)	Width longitudinal edge (mm)	Width cross- reinforcement (mm)
500 µ	0.3	0.62	± 0.26	39	20 - 60	20 - 60
1 000 µ	0.8	1.5	± 0.80	30	20 - 60	20 - 60
2 000 µ	1.0	1.8	± 0.80	44	20 - 60	20 - 60
3 000 µ	0.8	1.5	± 0.39	51	20 - 60	20 - 60
4 000 µ	1.0	1.9	± 0.46	59	20 - 60	20 - 60

In certain cases, gauze conveyor belts can be fitted with cleats and/or guide ropes. This must always be discussed with Manufacturing.

Tolerances technical rubbers and synthetic materials

Cut with Multicutter

Material thickness (mm):	Nominal size (mm)	Tolerance
0 < 5	Hole \emptyset	± 0.5 mm
	0 - 3 000	± 0.5 mm
	$\geq 3\ 000$	± 0.5 %
5 < 9	Hole \emptyset	± 0.5 mm
	0 - 3 000	± 1 mm
	$\geq 3\ 000$	± 0.5 %
9 – 25	Hole \emptyset	± 0.5 mm
	0 < 1,800	± 1 mm
	1 800 < 5 000	± 5 mm
	$\geq 5\ 000$	$\pm 0.5\%$ or 1%

Drum covering



Mini diamond red
diamond black



Mini diamond blue



Mini

Drum covering type	Available thicknesses (m)	Application	Hardness (°Sh-A)	Oil and fat resistant (Y/N)	Food safe (Y/N)	Temperature range (°C)
Mini diamond black	6, 8, 10, 15	Rubber conveyor belt	60 ± 5	N	N	-40 / 70
Mini diamond blue	8	Synthetic/ rubber conveyor belt	58 ± 5	Y	Y	-40 / 70
Mini diamond red	8	Low-tension belts, synthetic, forcing drums	40 ± 5	N	N	-40 / 70
F0, white	1.9	Synthetic conveyor belt	55	Y	Y	-10 / 110
F4, white	2.15	Synthetic conveyor belt	55	Y	Y	-20 / 80
F11, white		Synthetic conveyor belt	55	Y	Y	-20 / 80
F16, white	1.65	Synthetic conveyor belt	55	Y	Y	-20 / 80



F0, white
white



F4, white



F11, white



F16,