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BB

**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

BB/T 0022-2017

Replacing BB/T 0022-2004

**Conveyer belt for corrugated cardboard
(English Translation)**

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Foreword

This standard is in accordance with the rules given in GB/T 1.1-2009 "Standardization Work Guide Part 1. Standard Structure and Writing Rules" Drafting.

This standard replaces BB/T 0022-2004 "corrugated cardboard conveyor belt". This standard is compared with BB/T 0022-2004, except for editorial repair the main technical changes changed are as follows.

- Modified the classification method (see Chapter 3, Chapter 3 of the 2004 edition);
- Revised the appearance requirements (see Table 1, Table 1 of the 2004 version);
- Increased the thickness difference between the interface surface of the double-sided machine belt and the belt (see 4.1.4);
- Revised dimensional deviation (see 4.2.1, 4.1.2 of the 2004 edition);
- Modified the quality deviation requirement per unit area. (See 4.2.2, 4.1.3 of the 2004 edition);
- Modified physical and mechanical properties (see 4.3, 2004 edition 4.2);
- Increased the reference force elongation test method (see 5.6);
- Revised the sample preparation method (see 5.6.1 and 5.7.1);
- Increased hygroscopicity test method (see 5.10);
- Increased the test method for moisture venting (see 5.11).

This standard was proposed by the China Packaging Federation.

This standard is under the jurisdiction of the National Packaging Standards Technical Committee (TC49).

This standard was drafted. China Packaging Research and Testing Center, Foshan Nanhai Fucheng Industrial Belt Co., Ltd., Huludao Yuansheng Industrial Belt Co., Ltd., China Packaging Research Institute Co., Ltd.

1 Scope

This standard specifies the classification, requirements, test methods, inspection rules and products of corrugated board conveyor belts (hereinafter referred to as conveyor belts).

Marking, packaging, transportation and storage.

This standard is applicable to conveyor belts suitable for corrugated board production lines, which are compounded with chemical fibers such as polyester, cotton yarn and high temperature resistant materials.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 3690-2009 Test method for full thickness tensile strength, elongation at break and reference strength elongation of fabric core conveyor belts GB/T 6388 transport packaging receipt and delivery mark GB/T 10006 Plastic film and sheet friction coefficient determination method

3 Classification

3.1

According to the processing method, the conveyor belt can be divided into two types. acupuncture type and woven type.

3.2

According to the product use, it is divided into two types. traction conveyor belt and dry shaping conveyor belt.

4.1 Appearance

See Table 1 for appearance requirements.

Table 1 Appearance requirements

Project requirements surface the needle-punched surface is flat and the color is uniform; there are no hard objects, holes, cracks, stains, etc.

Woven type

The surface is flat and the color is uniform; the texture of the warp and weft is clear, and the working surface cannot be broken; there are no hard objects, holes, Cracks, stains, etc.

edge

Needle-shaped edge is straight, no visible jagged edges Woven edge is straight, without obvious distortion and jagged edges the joint at the joint is closed, the joint should be flush and tight, and the joint buckle is neat and firm.

4.2.1 Dimensional deviation

The thickness of the traction conveyor belt is generally 5.0mm~6.0mm; the thickness of the drying and shaping conveyor belt is generally 7.0mm~10.0mm. other the thickness is determined by negotiation between the supplier and the buyer. The average thickness deviation is ± 0.3 mm.