

ICS 53.040.20
CCS G 42



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

GB/T 28267.4-2015

Steel cord conveyor belts -- Part 4: Vulcanized belt joints

钢丝绳芯输送带 第4部分：带的硫化接头

(English Translation)

Issued on: December 31, 2015

Implemented on: July 1, 2016

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine**

Table of Contents

Foreword...	3
1 Scope...	4
2 Terms and definitions...	4
3 Symbols and units...	4
4 Types of joints...	4
5 Joint material...	9
6 Making the joint...	9
7 Marking the joint...	10

Foreword

GB/T 28267 consists of the following parts.

- Part 1. Design, dimensions and mechanical requirements for conveyor belts for general use;
- Part 2. Preferred belt types;
- Part 3. Special safety requirements for belts for use in underground installations;
- Part 4. Vulcanized belt joints.

This Part is the 4th part of GB/T 28267.

This Part was drafted in accordance with the rules given in GB/T 1.1-2009.

This Part uses translation method and identically adopts ISO 15236-4:2004

Steel cord conveyor belts - Part 4. Vulcanized belt joints.

This Part makes the following editorial modification.

- modified " ≥ 6.0 " in Table 2 to " ≤ 6.0 ".

This Part was proposed by China Petroleum and Chemical Industry Federation.

This Part shall be under the jurisdiction of National Technical Committee on Pulley and Belt of Standardization Administration of China (SAC/TC 428).

The drafting organizations of this Part. Zhejiang Double Arrow Rubber Co., Ltd.,

Shanxi Phoenix Tape Co., Ltd., Zhejiang Three-dimensional Rubber Products Co., Ltd., Shandong Dawn Tape Limited, Shenyang Taifeng Tape Manufacturing Co., Ltd., Yankuang Group Tangcun Industry Co., Ltd..
Main drafters of this Part. Zhuang Bingjian, Qu Wende, Zhang Guofang, Liu Shengping, Wang Bo, Sun Guimei.
Steel cord conveyor belts - Part 4.
Vulcanized belt joints

1 Scope

This Part of GB/T 28267 specifies design, dimensions, requirements and marking of vulcanized joints for steel cord conveyor belts.

2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

vulcanized joint

area within which the cords from two belt lengths are joined and vulcanized through the surrounding rubber

3 Symbols and units

For the purposes of this Part, the symbols and units given in Table 1 apply.

Table 1 Symbols and units

4.1 General

Figure 3 Part of a finger joint

NOTE 2 A loss of static strength in the splice is unavoidable, the extent of the loss being dependent on the construction of the splice.

5 Joint material

The joint material shall be chosen for the belt types to be joined, ensuring that the material will not be spoiled by ageing.

6 Making the joint

The heating platens shall be at least 150 mm larger than the joint on both sides in the longitudinal direction and shall at least cover the side irons in the transverse direction.

The heating platens shall be loaded evenly with a pressure of at least 1 MPa. Mechanical pressure equipment shall use a device to even out the applied pressure.

Unless otherwise agreed between the manufacturer and purchaser, when making the joint there shall be an equal thickness of the rubber between the cords.

When making joints the following general guidance shall be observed.

- ensure a large adhesion area by beveling the cover transition zones;
- leave a coat of adhesion rubber on the cord;
- carefully fill the space between the cords with a sufficient quality of adhesion rubber;
- use a material with a high adhesion.

In addition for interlaced stepped joints.

.....