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

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**Textile conveyor belts -- Determination of the net length of an
endless (spliced) conveyor belt**

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Foreword

This standard is drafted in accordance with the rules given in GB/T 1.1-2009.

This standard uses the translation method equivalent to the international standard ISO 16851..2012 "fabric core conveyor belt conveyor belt (splicing) net length

Of the determination "(English version).

This standard is proposed by the China Petroleum and Chemical Industry Association.

This standard is nationalized by the National Technical Committee on Conveyor Belt with Standardized Technical Committee (SAC/TC428/SC1).

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1 Scope

This standard specifies the method of determining the net length of the endless conveyor belt (splice).

This standard applies to all conveyor belts other than steel wire reinforcement.

This standard does not apply to light conveyor belts specified in ISO 21183-1 [3].

2.1 steel tape measurement, marked with a millimeter scale.

In order to ensure the accuracy of the measurement, the tape should be calibrated or measured.

3 procedures

Expand the endless conveyor belt so that it is flat and free from tension.

As shown in Fig. 1, only a flat portion of the belt is used to draw a point (i.e., point A) on one side of the inner wall as a measurement starting point.

Follow the steps below to mark the point B along the flat portion of the tape.

a) For bands with a circumference of not more than 30 m, except that the length of the last measurement may be less than $\frac{1}{4}$ of the circumference,

Should be between the quarter $\frac{1}{3}$ and $\frac{1}{3}$.

b) For bands with a circumference greater than 30 m, except that the length of the last measurement may be less than 7.5 m, each measurement shall be at 7.5 m

And between the circumference of $\frac{1}{3}$.

Measure and record the distance between two points A and B AB.

The rolling belt is continuously measured only along the inner wall of the flat portion of the belt. Each measurement result is denoted as AB, BC, CD, etc., and finally

Always measured XA.

In the event of a dispute, when the supplier and the customer reach an agreement, the measurement should be in accordance with ISO 18573 [2] in a standard environment get on.

Figure 1 Measurement of the length of the endless conveyor belt

4 calculations and results representations

The formula for calculating the net length l_e of the endless conveyor is as follows.