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

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Conveyor belts - Guidelines for storage and handling

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Foreword

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

The translation method used in this standard is equivalent to ISO 5285.2012 "Guidelines for Storage and Handling of Conveyor Belts".

The Chinese documents that have a consistent correspondence relationship with the normatively cited international documents in this standard are as follows.

-GB/T 20739-2006 Rubber Products Storage Guidelines (ISO 2230.2002, IDT).

This standard was proposed by the China Petroleum and Chemical Industry Federation.

This standard is under the jurisdiction of the National Belt Wheel and Belt Standardization Technical Committee Conveyor Belt Subcommittee (SAC/TC428/SC1).

Drafting organizations of this standard. Zhejiang Shuangjian Rubber Co., Ltd., Zhongnan Rubber Group Co., Ltd., Qingdao University of Science and Technology.

1 Scope

This standard specifies the guiding principles for the most suitable conditions for storage and handling of conveyor belts.

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

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this article

Pieces. For undated reference documents, the latest version (including all amendments) is

applicable to this document.

ISO 2230 Rubber products-Guidelinesforstorage (Rubberproducts-Guidelinesforstorage)

3.1 Rolling

The finished product conveyor belt is generally packaged in the form of rolls. The core is not necessary, but large and heavy conveyor belt rolls are expected to be stacked or stored.

Conveyor belt rolls for secondary handling (such as product export) should generally have a core and can bear the weight of the belt without being damaged. The core should be made of wood or steel.

There is a hole in the center for inserting the steel shaft. The diameter of the core and the side length of the square hole depend on the weight, width and physical properties of the belt. The middle section of the core

The surface is generally a square with a side length of 50mm, 100mm, 150mm or 200mm. The conveyor belt roll meets the following requirements.

- a) The conveyor belt should be rolled tightly enough to prevent unevenness in each layer during transportation and storage;
- b) Conveyor belt rolls should be rolled smoothly, that is, the outer band width line should be a straight line. The belt edges of each layer should be on the same plane and with the conveyor

The bandwidth is vertical.

3.2 Bundling

3.2.1 Conveyor belt rolls should be bundled with strapping strips made of fabric, plastic or steel. When a conveyor belt is divided into two non-disconnected

When the conveyor belt is rolled, the binding method should be shown in Figure 1.

3.2.2 It is not advisable to use fabric or plastic belts to bundle the conveyor belt rolls for underground flame-retardant conveyor belts, unless these belts have undergone a risk assessment

And get the buyer's permission.

3.2.3 It should be noted that the fabric is easy to stretch, and the conveyor belt roll bundled with fabric tape may gradually loosen; in case the conveyor belt roll falls, the fabric belt

The strip may snap off, causing it to fall apart. It is advisable to predict these situations in advance when choosing strapping straps.

3.2.4 The strapping strip should have sufficient tensile strength and be able to resist various

possible environmental degradation during the entire storage period; its width should be sufficient

It is wide enough to avoid strangulation on the belt surface.

3.3 Protection layer

3.3.1 The protective covering of the conveyor belt roll can be made of paper, sack cloth, plastic cloth, rubberized fabric or any other suitable material. For underground use

Before the flame-retardant belt is rolled and transported downhole by the conveyor belt, all combustible protective layers should be removed.

3.3.2 For heavy conveyor belt rolls or conveyor belt rolls that need to be transported remotely, they can be placed in a cage with wooden sides, especially steel wire ropes.

Core conveyor belt.

3.3.3 If the packaging completely covers the conveyor belt roll, all relevant information about the conveyor belt should be clearly written on the outermost packaging.