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

GB/T 6759-2013

Replacing GB/T 6759-2002

**Conveyor belts -- Adhesion between constitutive elements --
Test methods**

输送带 层间粘合强度 试验方法

(English Translation)

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Foreword

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

This standard replaces GB/T 6759-2002 "between the conveyor belt fabric layer adhesion strength test method" and GB/T 6759-2002 phase Ratio, the main technical changes are as follows.

- Modify the standard name (see cover);
- Modify the scope (see Chapter 1, 2002 edition of the Chapter 1);
- Increasing the normative references ISO 18573 "conveyor test environment and conditioning time" (see Chapter 2);
- Modified as described in Figure 1 (see Figure 1, 2002 edition of the FIG. 1);
- Modify the number of samples (see 53, 2002 version 5.3.);
- Modify the state regulator (see 55, Chapter 6 of the 2002 edition.);
- Modify the test procedure in Method A and Method B (see 6.1 and 62, 2002 edition of 7.1 and 7.2.);
- Modify the results are shown (see Chapter 7, Chapter 8, 2002 edition);
- Increased by reference.

This standard uses the translation method identical with ISO 252:2007 "Standard Test Method for strength adhesive layer between the conveyor belt." Correspondence between the consistency of the standards of international documents and normative references of the following documents.

- GB/T 532-2008 vulcanized rubber or thermoplastic rubber and fabric adhesive strength measurement (ISO 36:2005, IDT);
- GB/T 12833-2006 Rubber and plastics tear strength and adhesion strength

measurement of a multimodal curve points Analysis (ISO 6133:1998, IDT).

For ease of use, this standard made the following editorial changes.

--- "This International Standard" be replaced by "this standard";

--- Delete international standards foreword.

The standard proposed by China Petroleum and Chemical Industry Association.

This standard by the National Standardization Technical Committee pulley and the belt conveyor Technical Committee (SAC/TC428/SC1) centralized.

This standard was drafted. Zhejiang Double Arrow Rubber Co., Ltd., Wuxi Bao Tong with Industry Co., Ltd., Zhejiang three rubber stocks Parts Co., Ltd. Qingdao Shinkansen technology consulting, Qingdao University of Science and Technology.

Drafters of this standard. people will Shen, Wu Jianguo, Zhang Fang, Lvgui Qin, Cheng Cheng Li, Zhu Hanhua.

This standard replaces the standards previously issued as follows.

--- GB/T 6759-1986, GB/T 6759-2002.

Strength test interlayer adhesion between the conveyor belt

1 Scope

This standard specifies two test measured between the belt layer structure, that is, between the fabric layers, the adhesive strength of the tape core and the cover layer between the method (A method and B method). The basic test conditions, see ISO 36.

This standard applies to all kinds of conveyor structure, does not apply to steel cord conveyor belt, Full thickness tensile strength of less than 160N/mm of Conveyor belts, ISO 21183-1 [1] Light conveyor specified in the standard.

Note: A method and the B method can choose any one test method, but two ways to calculate the average value of adhesion may be different, and the two methods in the scope of all the belt structure is not completely overlap, which test method with specific choices available to producers for comments.

2 Normative references

The following documents for the application of this document is essential. For cited documents with dates, only the dated edition applies to this document.

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

ISO 36 Rubber, vulcanized or thermoplastic rubber and fabric adhesive strength

measurement (Rubber, vulcanized or thermoplastic-Determination of adhesion to textile fabrics)
ISO 6133 Rubber and plastics tear strength and adhesion strength measurement of
multimodal curve analysis

(Rubber and plastics-Analysis of multi-peak traces obtained in determination of tear strength and adhesion strength) ISO 18573 conveyor test environment and conditioning time
(Conveyor belts-Test atmospheres and conditioning periods) Principle 3 Using tensile testing machine at a constant speed with the fabric cover layer delamination and each fabric layer adjacent fabric layers peeled determination required the average peel force wanted.

4 Device

Tensile testing machine with appropriate power, its parameters meet the requirements of ISO 36.

5 Sample

5.1

The conveyor is made from the beginning to the test interval from the start of the conveyor belt is made to the test interval should be not less than 24h. The time period should be included in the 5.5 state regulation time.

5.2

The shape and size the specimen shall have a rectangular cross-section, the cutting surface should be neat. Sample width (25 ± 0.5) mm, length not less than 200mm. can Stripping length should be not less than 100mm. When necessary and possible, it may be appropriate to reduce the thickness of the sample, in order to ensure as far as possible in line with the peel test