

ICS 53.040.20
CCS G 42



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

GB/T 9770-2013

Replacing GB/T 9770-2001

Steel cord conveyor belts for general use

普通用途钢丝绳芯输送带

(English Translation)

Issued on: December 17, 2013

Implemented on: October 1, 2014

Issued by: Standardization Administration of China

Table of Contents

Preface
1 Scope
2 Normative references
3 Structure
4 With type
5 Mark
6 2 Technical Requirements
7 Inspection
8 Signs, packaging, storage and transportation
Appendix A (normative) vulcanized joints of steel cord conveyor belt
Annex B (informative) useful information to be provided by the buyer
References

Foreword

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

This standard replaces GB/T 9770-2001 "General-purpose steel cord conveyor belt," compared with the GB/T 9770-2001, Technical Changes are as follows.

- Modify the normative references (see Chapter 2, Section 2 of the 2001 edition);
- Remove product category (see Chapter 3);
- Modify the product structure (see Chapter 3, 2001 edition 4.1);
- Increasing the banding pattern (see Table 1, 2001, edition of the Tables 1 and 2);
- Modify the labeling of products (see Chapter 5, 2001 edition 3.2);
- Modify the number of wire rope has a connector (see 6122, 2001 version 4.2.2.2...);
- Modify the deviation width (see 621, 2001 edition 4.3.1.);
- Remove the strip thickness deviation limit (see the 2001 edition of 4.3.3.1);
- Modify the limit deviation band length (see 627, 2001 edition 4.3.1.);
- Modified overlay performance requirements (see 631, 2001 version 4.4.1.);
- Modify the bond strength of the wire rope (see 65, 2001 version 4.4.4.);

- Revised inspection requirements (see Chapter 7, 2001 edition, Chapter 6);
- Remove the straight run of (see the 2001 edition of 4.4.6);
- Adds dynamic bond strength rope (see 6.7);
- Revised measurement methods rope spacing (see 734, 2001 edition Appendix A.);
- Revised test methods (see 73, Chapter 5 of the 2001 edition.);
- Increasing the defect determination rules (see 7.4);
- Modified steel cord conveyor belt vulcanization connector (see Appendix A, Chapter 8, 2001 edition);
- Buyer adds useful information to be provided (see Appendix B).

Appendix A of this standard is a normative appendix, Appendix B is an informative annex.

The standard reference method using redrafted International Standard ISO 15236-1:2005 "Steel cord conveyor belts - Part 1. General purpose input Belt design, dimensions and mechanical requirements for "the preparation, and ISO 15236-1:2005 is equivalent to the degree of non-conformity.

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. six Qingdao Rubber Group Co., Ltd. Zhejiang Double Arrow Rubber Co., Ltd., Zhejiang three-dimensional rubber products shares have Ltd., Shandong EVA rubber conveyor belt Co., Ltd. Qingdao giant aircraft tape, Qingdao Huaxia Rubber Industry Co., Ltd., Shandong Cheung Rubber Group Co., Ltd. Qingdao Shinkansen technology consulting.

1 Scope

This standard specifies the general-purpose steel cord conveyor belt (hereinafter referred to as "tape") structure, with type, marking, technical requirements, testing, marking, Packaging, storage, transport and vulcanized joints belt (see Appendix A).

This standard applies to the working environment temperature of steel cord conveyor belt of -20 °C ~ 40 °C.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 528 vulcanized rubber or thermoplastic rubber tensile stress strain properties (GB/T 528-2009, ISO 37:2005, IDT) GB/T 3512 vulcanized rubber or thermoplastic rubber hot air and heat accelerated aging test (GB/T 3512-2001, eqv ISO 188.

1998)

GB/T 5752 conveyor flag (GB/T 5752-2013, ISO 433:1991, MOD) GB/T 5753 Steel cord conveyor total thickness and cover thickness measurement method (GB/T 5753-2013, ISO 7590.

2009, IDT)

GB/T 5754.2 steel cord conveyor belt longitudinal tensile test - Part 2. Determination of tensile strength (GB/T 5754.2-2005, ISO 7622-2. 1984, IDT) by GB/T 5755 Steel cord conveyor belts with glue-coated test original state test (GB/T 5755- and after heat aging 2013, ISO 7623:1996, IDT) GB/T 7983 laterally flexible conveyor (troughability) test method (GB/T 7983-2013, ISO 703:2007, MOD) GB/T 9867-2008 Rubber, vulcanized or thermoplastic - Determination of abrasion resistance (abrasion rotating cylindrical drum machine method) (ISO 4649.

2002, IDT)

GB/T 17044 Steel cord conveyor belt cover layer and the core layer adhesion strength test (GB/T 17044-2013, ISO 8094.

1984, IDT)

GB 21352-2008 mine retardant conveyor belt with steel cord HG/T 3056 conveyor storage and handling General (HG/T 3056-2006, ISO 5285:2004, IDT) BSEN13827. Determination (Steelcordconveyor 2003 steel cord conveyor belt rope horizontal and vertical position belts-Determinationofthelateralandverticaldisplacementofsteelcords)

3 Structure

Steel cord conveyor belts covered by the upper layer, a lower cladding layer, and adhesive layer constituting the steel cord, shown in Figure 1.