



MACHINERY AND EQUIPMENT

Conveyor belt, black

Skim compound, self extinguishing

70 Shore A, CR

Guide formulation of Bayer (now Arlanxeo)	T.I.B. 4.7.1
Baypren 230	100.0
Buna CB 11)*	10.0
Stearic acid	1.5
Scorchguard O	4.0
Rhenofit OCD	2.0
Vulkasil S	20.0
HAF N-330	20.0
SILLITIN N 82)**	80.0
Aluminum hydroxide	20.0
Chlorinated paraffin 70 %	27.0
Antimony oxide	10.0
Disflamoll DPK	10.0
Zinc oxide	5.0
Vulkacit D	1.0
Rhenogran TMTM-80	1.3
Sulfur	0.7
Total phr	312.5

)* No longer available. Recommended: Buna CB 24

)** No longer available. Recommended: SILLITIN N 75

Compound preparation

Premix in internal mixer GK 50, 20°C / volume load 70 % / rotor speed 20 rpm

Polymer and all components except half of stearic acid, accelerators and sulfur	min	2.5
Sweeping the shaft	min	2.0
Running time	min	4.5

Completion on open mill before skimming, cooling on full

Premix	min	5
Rest of stearic acid, cutting	min	5
Accelerators, sulfur	min	3



T.I.B. 4.7.1

Physical properties**Press cure 20 min @ 150°C**

Hardness	Shore A	approx. 70
Tensile strength	MPa	approx. 12
Elongation at break	%	approx. 500

Treatment notes for skimming

4-roller-F-calender

Length of rollers	mm	1650	
Diameter of rollers	mm	600	
Friction	roller 1 : roller 2	1 : 1.3	
	roller 2 : roller 3	1 : 1	
Speed	m/min	5	
Temperature of rollers	topside	°C	60
	centric	°C	60
	below	°C	80

As textile-ply a Pz-315-welft (dip CRP 031) was used.

1. and 2. welftside: cover thickness of approx. 1 to 1.2 mm can be applied perfectly with good liability.

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