

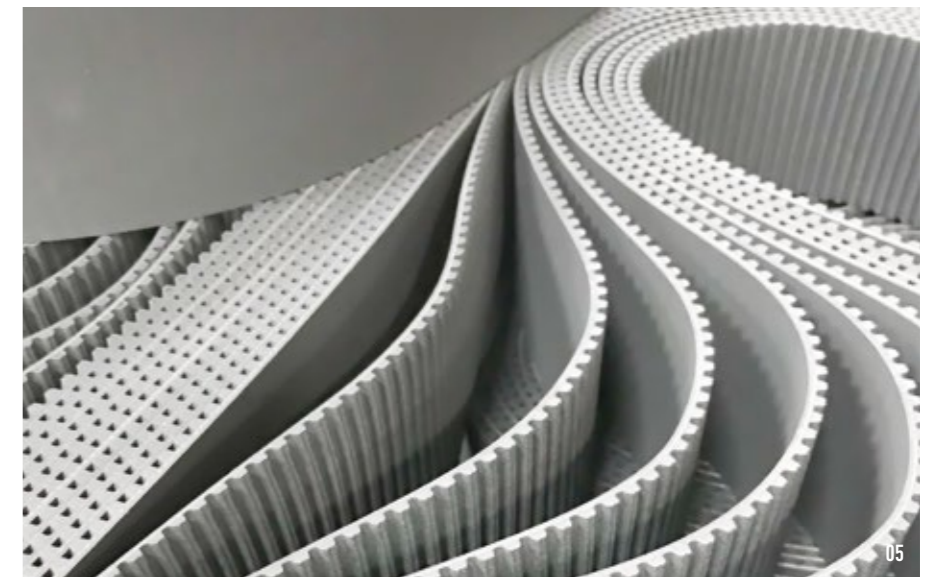
PVC AND PU CONVEYOR BELTS | FLAT BELTS



azeta gomma
S.p.A.

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01

INTRODUCTION

Since 2006, thanks to the important acquisition of **Nitra**, born in 1997 through a joint venture with the Japanese giant **Nitra**, **A Zeta Gomma** has been able to provide a range of **conveyor belts and flat belts with a high qualitative and technical content** in addition to its vast selection of traditional products, guaranteeing their widespread and timely distribution.

A Zeta Gomma was founded in 1973 in Sassuolo, in the heart of the most important ceramic district at national and international level, thanks to an intuition by Maurizio Pistoni. Today it is a reference player in the rubber and PVC transmission and conveyor belt sector, as well as being one of the most important and well-established production realities in Italy.

More than 20,000 m² divided between sales headquarters, two production units and a warehouse with 60,000 immediately available items, thanks to which it can always guarantee an effective and punctual distribution of the products.

A Zeta Gomma is synonymous with quality, service and efficiency at the disposal of companies, to meet the requirements of an increasingly attentive and demanding market. It is a production company where Italian "artisanal" quality plays a key role in the choice of materials and machinery for the processing and transformation of the products.

- 01 Sassuolo headquarters
- 02 PVC conveyor belts
- 03 M.E.C. Polbelt thermoweldable belts
- 04 Sassuolo headquarters mobile racking system warehouse
- 05 M.E.C. polyurethane timing belts

02

PVC AND PU CONVEYOR BELTS

A Zeta Gomma's range of PVC and PU conveyor belts includes products of high technical and qualitative content that guarantee excellent durability over time.



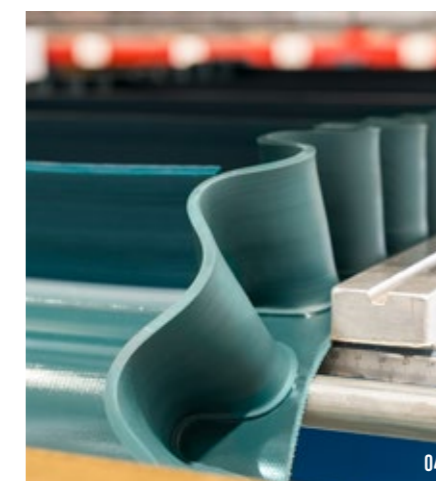
02



03



05



04

The workshop in Sassuolo is stocked with over 150 varieties of belts and with automatic cutting and punching systems, several vulcanization presses, machines for the application of guides and various high-frequency machines for the application of cleats, waves and flexible sidewalls.

Thanks to high-precision tools such as skivers, grinding and CNC machines, we are able to customize the product with holes, slots, and special milling to develop and produce new types of products dedicated to specific needs.

A Zeta Gomma also has a corporate division with qualified staff dedicated to technical advice, capable of optimizing processes to ensure the best performance, as well as a customer service dedicated exclusively to this type of products.

- 01 PVC and PU conveyor belts
- 02-03 Cutting and punching area
- 04 Flexible side walls
- 05 Applications on PVC and PU belts

01

CODE	TYPE (ID CODE)	MECHANICAL FEATURES						CONSTRUCTION				
		Total thickness (mm)	Weight (Kg/m ²)	180° bend (mm)	Reverse bend (mm)	Elongation 1% (N/mm)	Max permissible (N/mm)	Temperature resist.		Fabric insert		
								Min. (°C)	Max (°C)	No. Ply	Weft	Material
PV1008	1 LR 2704	1.7	1.6	20	40	4	8	-10	+80	1	rigid	PES
PV1002	1 LRF 2705	1	1.1	10	15	4	8	-10	+80	1	rigid	PES
PV1005	1 N 21	2	2.6	25	50	6	12	-10	+80	1	flexible	PES
PV1001	1 RWF 905 M	1	1.1	10	15	5	10	-10	+80	1	rigid	PES
PV1017	1 YF 2710 GP	3	2.9	35	55	20	40	-10	+80	1	rigid	PES
PV2001	2 LR 2704	2.7	3	50	75	8	16	-10	+80	2	rigid	PES
PV2008	2 LR 904	2.7	3	50	75	8	16	-10	+80	2	rigid	PES
PV2012	2 N 21	3.2	3.4	50	75	8	16	-10	+80	2	flexible	PES
PV2004	2 LRAF 2704	2.1	2.4	40	60	8	16	-10	+80	2	rigid	PES
PV2028	2 LRF 2704 H M	2.1	2.4	50	60	8	16	-10	+80	2	rigid	PES
PV2006	2 LRAF 271	2.5	2.7	50	75	8	16	-10	+80	2	rigid	PES
PV2047	2 LRWF 271	2.6	2.8	50	75	10	20	-10	+80	2	rigid	PES
PV2064	2 LRAF 2715	3.1	3.4	60	80	12	24	-10	+80	2	rigid	PES
PV20020	2 LRF 201/201	2	2.4	25	25	8	16	-10	+80	2	rigid	PES
PV2007	2 RWF 901	2.3	2.1	50	50	10	18	-15	+80	2	rigid	PES
PV2009	2 LRWF 904 M	2	2.3	40	60	10	20	-10	+80	2	rigid	PES
PV2016	2 LRAWF 906 M FR	2.1	2.6	60	80	12	24	-10	+80	2	rigid	PES
PV2019	2 NF 2706	2.5	2.8	50	75	12	24	-10	+80	2	flexible	PES
PV2020	2 LR 272 RT	6	5	50	90	8	16	-10	+80	2	rigid	PES
PV2026	2 LR 92 RT	6	5	50	90	8	16	-10	+80	2	rigid	PES
PV2007	2 LRWF 272 RT	5	4.6	50	75	10	20	-10	+80	2	rigid	PES
PV2060	2 LRWF 909 RB	3.1	3	50	80	10	20	-10	+80	2	rigid	PES
PV2044	2 LRAWF 905 OT	1.8	1.6	30	50	8	16	-10	+80	2	rigid	PES
PV2003	2 LRF 105 LD	2.2	2.6	40	60	8	16	-10	+80	2	rigid	PES
PV2005	2 LRF 2705 GP	2.2	2.5	40	60	8	16	-10	+80	2	rigid	PES
PV2027	2 LRF 2716 WT	4.3	3.6	40	60	8	16	-10	+80	2	rigid	PES
PV2029	2 RF 273 TP	8.8	5.9	50	75	8	16	-10	+80	2	rigid	PES
PV2048	2 LRF 2704 FP	2.3	2.4	40	60	8	16	-10	+80	2	rigid	PES
PV3010	3 RF 201/201	3.5	3.4	90	90	16	32	-10	+90	3	rigid	PES
PV3001	3 LRAF 271	3.8	4.9	100	120	16	32	-10	+80	3	rigid	PES
PV3003	3 RF 282 H	5	5.8	150	275	15	30	-10	+80	3	rigid	PES

GRINDING AND CUTTING	CODE	TYPE (ID CODE)	Total thickness (mm)	Weight (Kg/m ²)	180° bend (mm)	Reverse bend (mm)	Elongation 1% (N/mm)	Max permissible (N/mm)	Min. (°C)	Max (°C)	No. Ply	Weft	Material
PB2037	2 MF 272 NP	5.2	5.7	150	/	40	60	-10	+80	2	rigid	PES	
EE3005	3 R NEROGUM	10	11	280	/	15	30	-10	+80	3	rigid	PES	
PV3012	3 MF 273 NP	7	8.2	350	400	55	75	-10	+80	3	flexible	PES	
PB4001	4 MF 273 OT	9	10	450	500	70	100	-10	+80	4	rigid	PES	

CONSTRUCTION						GENERAL FEATURES		
Conveying surface			Driving surface			Comparative friction coeff.	Antistatic	F.D.A.
Material	Colour	Structure	Material	Colour	Structure			
PVC	green	polished	PVC	green	SQ	M	NO	NO
PVC	green	polished	-	grey	fabric	M	NO	NO
PVC	apple green	polished	PVC	apple green	SQ	M	NO	NO
PVC	black	matt	-	grey	noise-reduction layer	M	NO	NO
PVC	green	GP	-	grey	fabric	H	YES	NO
PVC	green	polished	PVC	green	SQ	M	NO	NO
PVC	black	polished	PVC	black	SQ	M	NO	NO
PVC	apple green	polished	PVC	apple green	SQ	M	NO	NO
PVC	green	polished	-	grey	fabric	M	YES	NO
PVC	green	matt	-	grey	fabric	L	NO	NO
PVC	green	polished	-	grey	fabric	M	YES	NO
PVC	green	polished	-	grey	noise-reduction layer	M	YES	NO
PVC	green	polished	-	grey	fabric	M	YES	NO
-	apple green	fabric	-	apple green	fabric	L	NO	NO
Impreg. PVC	black	fabric	-	grey	noise-reduction layer	L	YES	NO
PVC	black	matt	-	grey	noise-reduction layer	L	NO	NO
PVC	black	matt	-	grey	noise-reduction layer	M	YES	NO
PVC	green	polished	-	grey	fabric	M	NO	NO
PVC	green	RT	PVC	green	SQ	H	NO	NO
PVC	black	RT	PVC	black	SQ	H	NO	NO
PVC	green	RT	-	grey	fabric	H	NO	NO
PVC	black	RB	-	grey	noise-reduction layer	H	NO	NO
PVC	black	OT	-	grey	noise-reduction layer	L	NO	NO
PVC	grey	LD	-	grey	fabric	H	NO	NO
PVC	green	GP	-	grey	fabric	H	NO	NO
PVC	green	WT	-	grey	fabric	H	NO	NO
PVC	green	TP	-	grey	fabric	H	NO	NO
PVC	green	FP	-	grey	fabric	L	NO	NO
Impreg. PU	apple green	fabric	Imp. PVC	apple green	fabric	L	NO	NO
PVC	green	polished	-	grey	fabric	M	YES	NO
PVC	green	polished	-	grey	fabric	L	NO	NO

PVC	blue	LD	-	grey	fabric	H	Yes	NO
PVC	green	NP	-	yellow	fabric	H	NO	NO
RUBBER	black	FP	-	yellow	fabric	H	NO	NO
PVC	green	NP	-	grey	fabric	H	NO	NO
PVC	green	OT	-	yellow	fabric	H	NO	NO

CODE	TYPE (ID CODE)	MECHANICAL FEATURES						CONSTRUCTION					
		Total thickness (mm)	Weight (Kg/m ²)	Minimum diameter*		Tensile load		Temperature resist.		Fabric insert			
				180° bend (mm)	Reverse bend (mm)	1% elongation (N/mm)	Max permissible (N/mm)	Min. (°C)	Max (°C)	No. Ply	Weft	Material	
PVC FDA	PB1008	1 LRAF 3705	1	1.1	10	20	4	8	-10	+80	1	rigid	PES
	PB2006	2 LRAF	1.7	1.8	20	20	8	16	-10	+80	2	rigid	PES
	PB2005	2 LR 3704	2.7	3	50	75	8	16	-10	+80	2	rigid	PES
	PB2029	2 LRF 3704/001	2	2.5	25	50	8	16	-10	+80	2	rigid	PES
	PB2001	2 LR 704	2.7	3	50	75	8	16	-10	+80	2	rigid	PES
	PB2018	2 LRF 704/001	2.2	2.4	40	60	8	16	-10	+80	2	rigid	PES
	PB2019	2 LRF 712/001	3	3.2	50	100	8	16	-10	+80	2	rigid	PES
	PB2011	2 N 71	3.1	3.5	50	75	12	24	-10	+80	2	flexible	PES
	PB2009	2 NF 704	2.2	2.4	40	60	12	24	-10	+80	2	flexible	PES
	PB2008	2 LRF 705 SQ	2.3	2.4	40	60	8	16	-10	+80	2	rigid	PES
	PB2027	2 LRF 707 NP	2.5	2.4	40	60	8	16	-10	+80	2	rigid	PES
	PB2036	2 LRF 705 LD	2.2	2.6	40	60	8	16	-10	+80	2	rigid	PES
	PB3003	3 LR 710	4.8	5.4	100	150	12	24	-10	+80	3	rigid	PES
	PB3001	3 LRF 710	4.2	4.8	80	120	12	24	-10	+80	3	rigid	PES
	ELEVATORS	PB3009	2 N 72 F	4.2	5	150	150	20	200	-10	+80	2	flexible
PB3010		3 N 72 F	6.1	7.6	200	250	30	300	-10	+80	3	flexible	PES
PB3012		3 N 72 F ATEX	6.1	7.6	200	250	30	300	-10	+80	3	flexible	PES
PB3006		4 N 45 F	7.4	9.2	300	350	35	400	-10	+80	4	flexible	PES
PB3011		4 N 45 ATEX	7.4	9.2	300	350	35	400	-10	+80	4	flexible	PES
PU FDA	UB1001	1 LRAFP W M	0.8	0.85	r5	15	4	8	-20	+100	1	rigid	PES
	UB1008	1 LRFP 02 W3 SQ IM	1	0.85	r5	15	4	8	-20	+100	1	rigid	PES
	UB1015	1 RFP 03/V2	1	0.8	10	15	4	8	-20	+80	1	rigid	PES
	UB2006	2 LRAFP 02 W M 1.3	1.3	1.4	r5	15	8	16	-20	+100	2	rigid	PES
	UB2012	2 LRAFP 03 W M 1.5	1.5	1.8	20	40	8	20	-20	+100	2	rigid	PES
	UL2013	2 LRAFP 02 LB IM M 1.4	1.4	1.8	20	40	8	20	-20	+100	2	rigid	PES
	PV3029	2 LRAFP IM 1.1	1.1	1.4	r8	15	8	16	-20	+100	2	rigid	PES
	UB2013	2 NFP 18 T	4	4.6	130	180	13	25	-20	+100	2	rigid	PES
	UB2010	2 LRFP BLU	1.5	1.35	10	15	4	8	-20	+80	2	rigid	PES
	UB1016	2 CFP W	1.4	1.25	10	10	7	10	-15	+90	2	flexible	PES/cotton
	UB2014	2 LRAFP 02 W3 SQ	1.7	1.9	20	30	8	16	-20	+100	2	rigid	PES
	PU	UV1001	1 LRAFP 02 G	0.8	0.85	r5	15	4	8	-20	+100	1	rigid
UV2011		2 LRAFP 02 G M 1.3	1.3	1.4	r5	15	8	16	-20	+100	2	rigid	PES
UV2011P		2 LRAFP 03 G M 1.5	1.5	1.8	20	40	8	20	-20	+100	2	rigid	PES
UV2010B		2 LRAFP 03 BLK M 1.5	1.5	1.8	20	40	8	20	-20	+100	2	rigid	PES
UV2014		2 XRF 02 PG2 M 1.9	1.9	2	20	50	10	20	-20	+100	2	extra rigid	PES
UV2020		2 NFP 02 G2 M	1.8	2	25	40	12	24	-20	+100	2	flexible	PES

CONSTRUCTION						GENERAL FEATURES			
Conveying surface			Driving surface			Comparative friction coeff.	Antistatic	F.D.A.	
Material	Colour	Structure	Material	Colour	Structure				
PVC	blue	polished	-	white	fabric	M	YES	YES	
-	white	fabric	-	white	fabric	L	YES	YES	
PVC	blue	polished	PVC	blue	SQ	M	NO	YES	
PVC	blue	polished	-	white	fabric	M	NO	YES	
PVC	white	polished	PVC	white	SQ	M	NO	YES	
PVC	white	polished	-	white	fabric	M	NO	YES	
PVC	white	polished	-	white	fabric	M	NO	YES	
PVC	white	polished	-	white	SQ	M	NO	YES	
PVC	white	polished	-	white	fabric	M	NO	YES	
PVC	white	SQ	-	white	fabric	M	NO	YES	
PVC	white	NP	-	white	fabric	H	NO	YES	
PVC	white	LD	-	grey	fabric	H	NO	YES	
PVC	white	polished	PVC	white	SQ	M	NO	YES	
PVC	white	polished	-	white	fabric	M	NO	YES	
PVC	white	polished	PVC	white	polished	H	YES	YES	
PVC	white	polished	PVC	white	polished	H	YES	YES	
PVC	white	polished	PVC	white	polished	H	YES	YES	
PVC	white	polished	PVC	white	polished	H	YES	YES	
PVC	white	polished	PVC	white	polished	H	YES	YES	
PU	white	polished	-	white	fabric	M	YES	YES	
PU	white	SQ	-	white	fabric	L	NO	YES	
felt	white	felt	-	white	fabric	L	NO	YES	
PU	white	matt	-	white	fabric	L	YES	YES	
PU	white	matt	-	white	fabric	L	YES	YES	
PU	blue	matt	-	white	fabric	L	YES	YES	
-	white	fabric	-	white	fabric	L	YES	YES	
PU	transparent	matt	-	white	fabric	L	NO	YES	
cotton	hemp	fabric	-	blue	fabric	L	NO	YES	
cotton/PES	white	fabric	cotton/PES	white	fabric	L	NO	YES	
PU	white	SQ	-	white	fabric	M	YES	YES	
PU	green	polished	-	white	fabric	M	YES	NO	
PU	green	matt	-	white	fabric	L	YES	NO	
PU	green	matt	-	white	fabric	L	YES	NO	
PU	black	matt	-	white	fabric	L	YES	NO	
PU	green	matt	-	white	fabric	L	NO	NO	
PU	green	matt	-	white	fabric	L	NO	NO	

	CODE	TYPE (ID CODE)	MECHANICAL FEATURES							CONSTRUCTION			
			Total thickness (mm)	Weight (Kg/m ²)	Bend 180° (mm)	Reverse bend (mm)	1% elongation (N/mm)	Max permissible (N/mm)	Temperature resist.		Fabric insert		
									Min. (°C)	Max (°C)	No. Ply	Weft	Material
ELASTOMER	EE2001	GH-15 GREEN	1.5	1.8	30	60	5	-	-20	+100	-	-	nylon
	EE2005	GH-20 GREEN	2	2.1	50	100	8	-	-20	+100	2	rigid	PES
	EE3004	GH-30 GREEN	3	3.4	60	120	8	-	-20	+100	2	rigid	PES
	EE2007	RT 25 HG	6.8	5.6	50	100	12	25	-20	+100	2	flexible	PES
	EE2018	RT 8	5.5	4.5	80	120	8	25	-20	+100	2	rigid	PES
FELT	FE1002	PNP 25 A	2.5	1.4	30	45	8	8	-10	+120	1	flexible	PES
	FE1003	PNP 40 A	4	2.2	60	100	8	8	-10	+120	1	flexible	PES
	FE1004	PNP 55 A	5.5	3.1	90	150	8	8	-10	+120	1	flexible	PES
	FE1005	2 LRF PNP 3	3.0	2.3	80	140	8	15	-10	+100	2	rigid	PES
	UB1015	1 RFP 03/V2	1	0.8	10	15	4	4	-20	+80	1	rigid	PES
SILICONE	SB2002	SVC-12AK	1.8	2	50	75	4	8	-10	+80	2	rigid	PES
		SI 2 FG	1.1	1.3	30	50	5	7	-5	+200	1	flexible	glass fibre
POLYOLEFIN	PE2002	2 MFA PE	2.5	2.4	60	80	12	20	-15	+45	2	flexible	PES
	PE2003	2 LRF PE	2.5	2.4	60	80	13	22	-15	+45	2	rigid	PES
	PE3001	3 LRAF PE	3.6	3.4	150	200	18	32	-15	+45	3	rigid	PES
ANTIBACTERIAL	UL2017	AZ4 AS HACCP	0.7	0.7	r5	20	4	4	-30	+100	1	rigid	PES
	UL2014	AZ5 AS HACCP	1.2	1.2	r5	20	5	8	-30	+100	2	rigid	PES
TEFLON		GUF 6 AK	0.8	0.8	30	60	2	2	-20	+80	1	rigid	PES
		GUF 12 AK	1.3	1.3	50	100	4	8	-20	+80	2	rigid	PES

CONSTRUCTION						GENERAL FEATURES		
Conveying surface			Driving surface			Comparative friction coeff.	Antistatic	F.D.A.
Material	Colour	Structure	Material	Colour	Structure			
elastomer	green	Z	-	black	fabric	H	NO	NO
elastomer	green	Z	-	grey	fabric	H	YES	NO
elastomer	green	Z	-	grey	fabric	H	YES	NO
elastomer	green	RT	-	brick red	fabric	H	YES	NO
elastomer	green	RT	-	grey	fabric	H	YES	NO
FELT	grey	felt	felt	grey	felt	L	YES	NO
felt	grey	felt	felt	grey	felt	L	YES	NO
felt	grey	felt	felt	grey	felt	L	YES	NO
felt	grey	felt	-	white	fabric	L	NO	NO
felt	white	felt	-	white	fabric	L	NO	YES
silicone	white	polished	-	white	fabric	H	NO	YES
silicone	white	polished	glass fibre	white	fabric	H	NO	YES
PE	transparent	matt	-	white	fabric	L	YES	YES
PE	transparent	matt	-	white	fabric	L	YES	YES
PE	transparent	matt	-	white	fabric	L	YES	YES
PU	blue	matt	-	white	fabric	L	YES	YES
PU	blue	matt	-	white	fabric	L	YES	YES
Fluoroplastic	petroleum green	polished	-	white	fabric	L	NO	YES
fluoroplastic	petroleum green	polished	-	white	fabric	L	NO	YES

02. CONVEYOR BELTS PVC AND PU CONVEYOR BELTS

GUIDE TO READING THE CODE

TOP COVER PROFILES

BELTS WITH PVC COATING

example: 2 LRF 272 RT

2 Number of plies

LR Type of fabric

F Bottom cover fabric

27 Colour and type of coating

2 Top cover thickness in tenths of a millimeter

RT Top cover structure

PVC COLOUR

1 Grey

2 Apple green

7 White

9 Black

27 Petroleum green

37 Blue

PU BELTS

example: 2 LRAFP 02 W M 1.3

2 Number of plies

LRA Type of fabric

F Bottom fabric

P PU top cover

02 PU top cover thickness

W Colour

M Matt

1.3 Total belt thickness

PU COLOUR

W White

G green

LB Blue

BLK Black

TYPES OF FABRIC

C Cotton

LR Standard

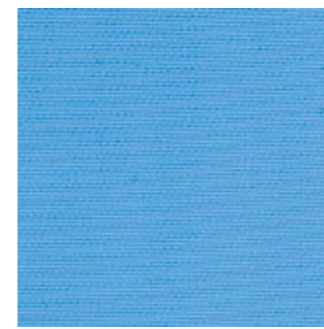
R rigid

XR extra rigid

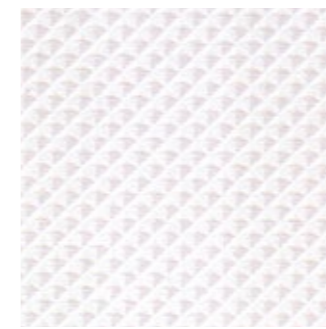
N Flexible

A Antistatic

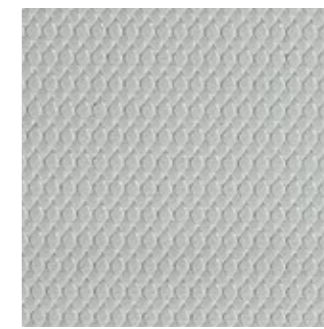
W Anti-noise



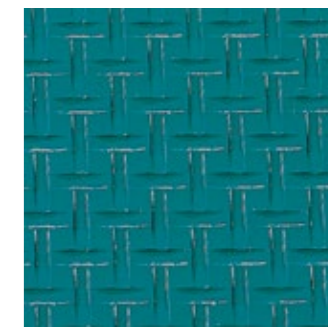
Z



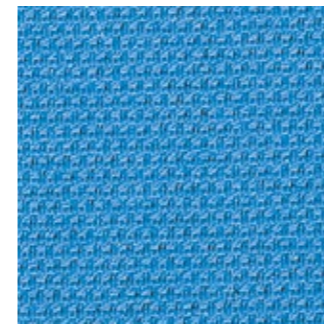
SQ



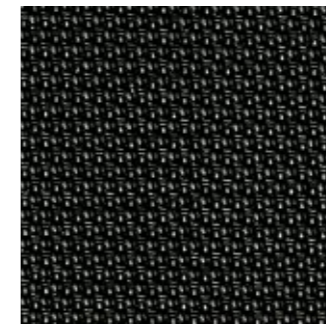
LD



GP



TW



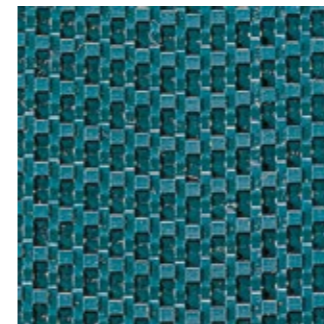
OT



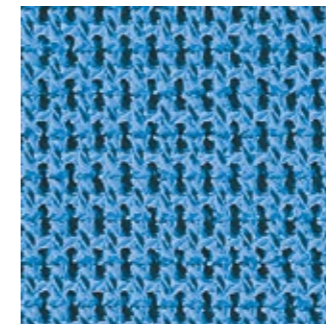
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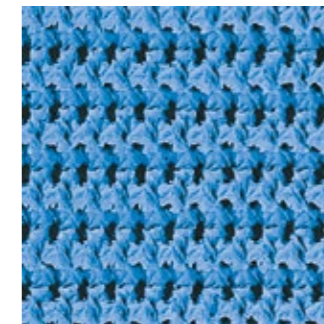
RB



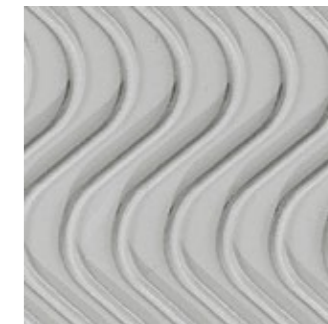
WT



RT



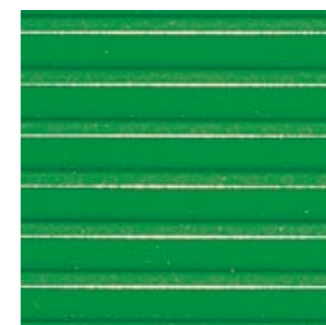
RT.NF



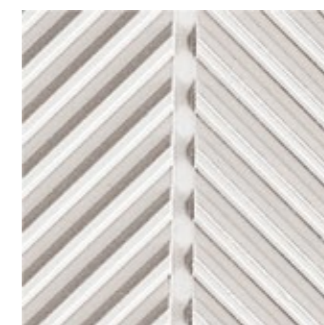
CG



ST



CR



FB



GNP

03. JOINT SYSTEMS

The properties of new materials and the continuous technological evolution in conveyor belt applications has led to the development of **various specific joining systems**.



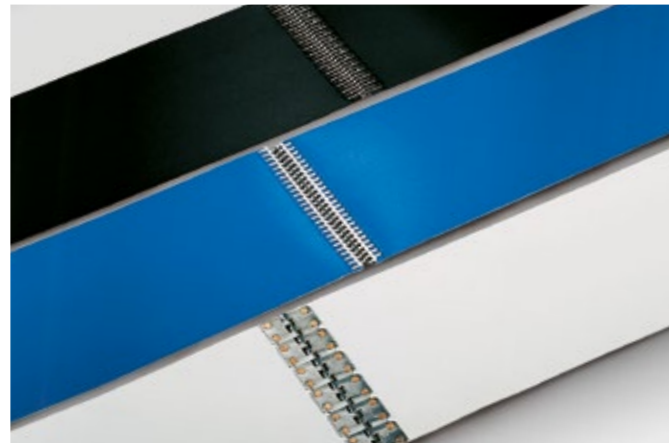
FINGER JOINTS

Characterized by high flexibility, they ensure top performance in high-speed or reverse bend conditions, with special milling to suit a range of application possibilities.



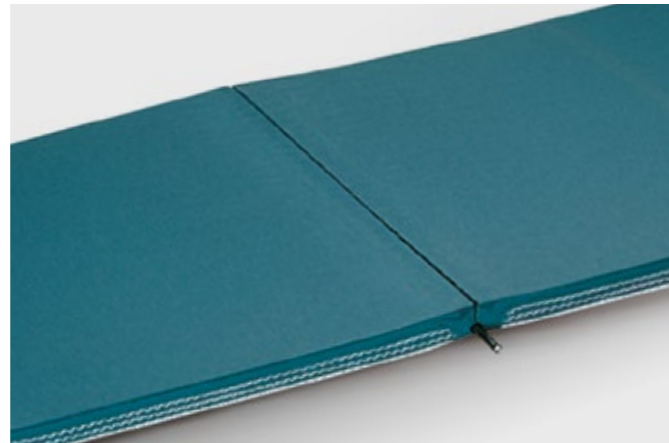
OVERLAP JOINTS

Suitable for applications of products that tend to interpose between the drums and the belt, thus creating stress in the junction area.



METAL BELT JOINTS

They allow very short belt replacement times. They are available in different types and in stainless or galvanized steel versions.



EMBEDDED JOINTS

The belt coating material is reconstructed in the joint area to increase the flatness or continuity of the conveyor surface.

04. MANUFACTURING TOLERANCES

WIDTHS (MM)			LENGTHS (MM)			
from 0	from 501	from 1001	from 0	from 2501	from 5001	over
to 500	to 1000	to 3000	to 2500	to 5000	to 10000	10000
± 1.0%	± 0.8%	± 0.5%	± 0.5%	± 0.4%	± 0.3%	± 0.2%

05. BELT TENSIONING

In order to function properly, **the conveyor belt must be suitably "tensioned"**.

Tensioning percentages, however, are difficult to standardize as they depend on multiple factors, including: number of layers, weight of goods carried and operating speed, without neglecting the dynamic conditions of the drive mechanism.

Here are some examples of standard tensions for single, two and three-ply belts.

Single ply belts: from 0.3% to max. 0.5%

2-ply belts: from 0.5% to max. 1%

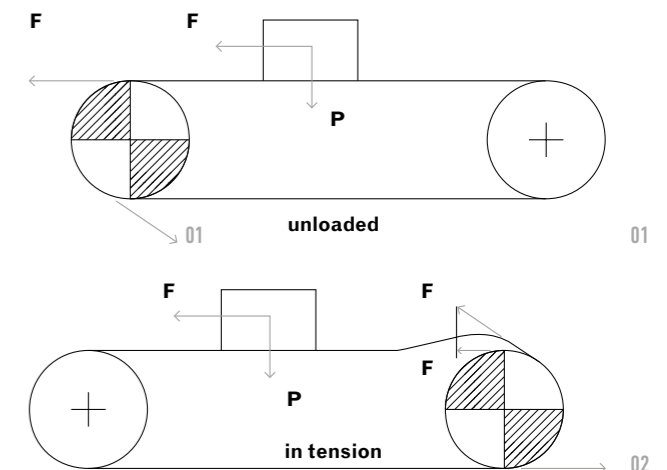
3-ply belts: from 0.6% to max. 1.2%

Based on the above considerations on elongation percentages, it is understood that, during the design of a conveyor belt, the stroke of the tensioner must be at least 1%; a valid condition if the tensioner moves a drum that puts two belt branches into tension simultaneously. The actual tension obtained on the layers will therefore be twice the stroke of the tensioner.

06. DRUM CONSTRUCTION AND POSITIONING

The drive drum should be positioned, if possible, in the same direction as the conveyed product; in this way, the belt will have a self-centring effect.

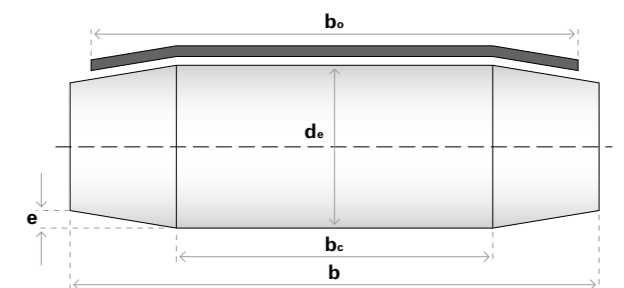
The tensioned side of the belt remains on the support surface and so the weight of the goods promotes the distribution of the tensile load on the motor drum (Figure 01).



On the contrary, if the motor is pushing, the tangential force that can be used for the thrust is reduced by a significant percentage, the weight of the conveyed product favors the reduction of tension on the unloaded side and, as a result, the belt tends to skid more easily (Figure 02).

The surface of the drums can be smooth, rubberized or coated with a special structured rubber roller covering. To calculate the proper construction of the drums, you are recommended to follow the calculation method below:

- Key
- b = drum width
 - b_c = width of indicated cylindrical section
 - b_o = belt width
 - d_e = external diameter
 - e = conicity
- 01 Calculation of drum width:
 $b = 1.1 \cdot b_o + 10$ (mm)
 - 02 Calculation of conicity:
 $e = \frac{d_e + 100}{500}$ (mm)
 - 03 Calculation of the cylindrical section in relation to the total width of the drum:
 $b_c = \frac{b}{2}$ (mm)



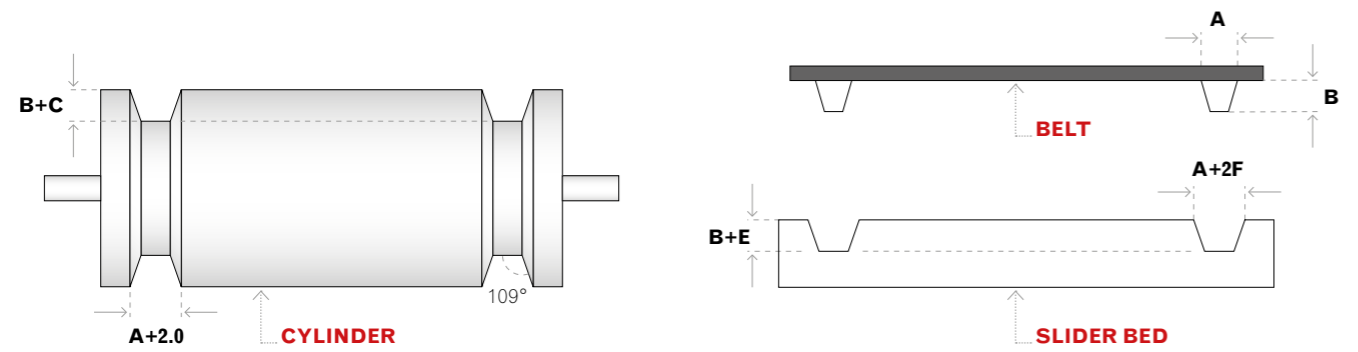
In order to avoid opposing centring actions, in the case of a two-directional drive with central motorization on the return section, for distances of a few metres and reduced belt widths, the main return cylinder must also be convex with a trapezoidal section.

07. GUIDE SLOTS

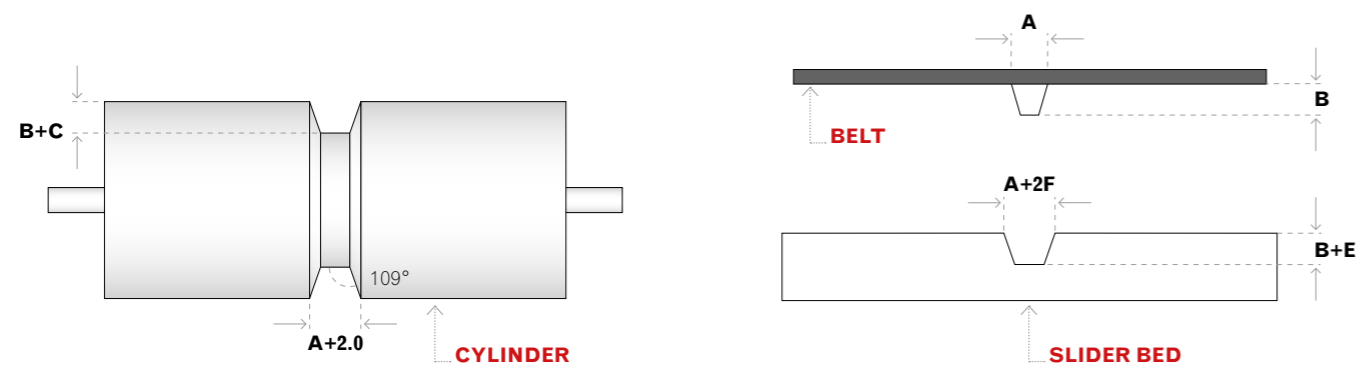
The application of longitudinal guide profiles, which slide in special slots constructed on both the drums and the slider beds, aids longitudinal linearity and avoids strong transversal skidding.

Longitudinal guides are also used successfully in all cases where the belt is subjected to surface "accumulation" and/or deviation of the product.

Below are the specifications for creating the guide slots on the cylinders and on the slider bed; if the support is made up of rollers, these must be equipped with the respective slots which mirror the type of guide chosen for the belt.



BELT	BELT DIMENSIONS			ADDITIONAL DIMENSIONS OF THE TRAPEZOIDAL SLOTS			
	A	B	C	Cylindrical		Slider beds	
X	6	4	0.5	3	1.5	2	
Y	8	5	0.75	3.25	1.5	2	
Z	10	6	1	3.5	2.5	2.25	
A	13	8	1.25	4	3	2.5	
B	17	11	1.5	4.25	3.5	2.75	
C	22	14	2	4.5	4	2.75	



BELT TYPE	BELT DIMENSIONS			ADDITIONAL DIMENSIONS OF THE TRAPEZOIDAL SLOTS			
	A	B	C	Cylindrical		Slider beds	
X	6	4	0.5	1.5	1.5	0.5	
Y	8	5	0.75	1.75	1.5	0.5	
Z	10	6	1	2	2.5	0.75	
A	13	8	1.25	2.5	3	1	
B	17	11	1.5	2.75	3.5	1.25	
C	22	14	2	3	4	1.25	

08. FLEXIBLE SIDE WALLS

The lateral containment system with flexible side walls is characterized by its high reliability and reduced belt wrapping diameters.

All flexible side walls are applied without base, using high-frequency technology.

TYPE OF SIDE WALL	COLOUR	APPLICATION	SPECIFICATIONS
Flexible PVC side wall thickness 1.7 mm with flexible polyester reinforcement without base	White Green	PVC Belts	
Flexible PU side wall thickness 1.7 mm without base	White Green	PU Belts	
Flexible PVC side wall thickness 4 mm without base	White Green	PVC Belts	
Flexible PVC/PU side wall thickness 4 mm without base	White Green	PU Belts	

FLEX SIDE WALLS



09. BELT CURVES

One of the most significant applications of flexible weft is the creation of **curved belt conveyors**.

Rigid fabrics cannot be used on a curve as the constructive cut is made following an arc of circumference and not in a straight line (parallel to the warp) as with all other types of belts.

For example, if the curve to be made is 90 degrees, the material will be cut for a double angle (180 degrees), plus an additional increase, necessary to create the overlap of the joint and compensate for the curvature radii of the drums. This latter increase varies depending on whether the drums are cylindrical or conical.

The conveyor belt made with two conical rollers is the most

precise technical solution in terms of the ease of tensioning and installation.

For diameters of a few tens of millimetres, with cylindrical rollers, one of which will be the tensioner, the cut is often successfully made by simply doubling the angle and merely adding the extra piece necessary for the overlap during welding.

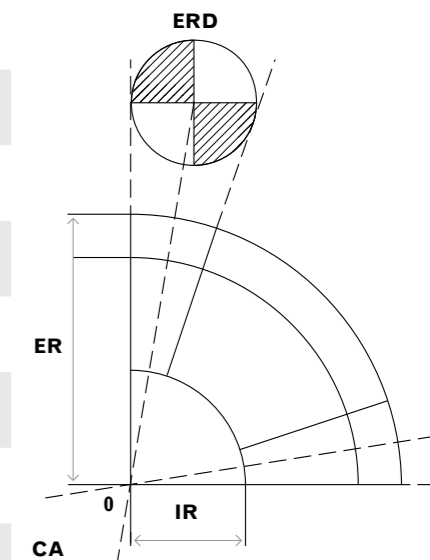


In our production plant we make belt curves using a waterjet cutter, with a 3x5 m cutting table.

This procedure allows precise machining, repeatable over time with the same characteristics, which guarantees the performance of the product even with wear.

Reference table for creating a curved belt:

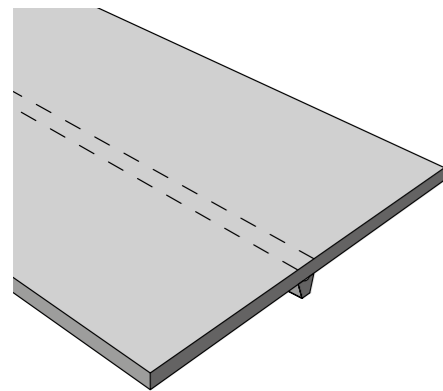
DATA	ABBREVIATION	UNITS OF MEASUREMENT	TYPE	NOTES
BELT	PVC / PU			
Conical or cylindrical rollers		CON / CYL		
External radius	ER	mm		In the case of CYL, curve seen from above
Internal radius	IR	mm		In the case of CYL, curve seen from above
Hole arc radius	HR	mm		Radius of the arc on which the holes are made
Curve angle	CA	degrees		Angle of the un-extended curve **
Roller diam. on int. length	IRD	mm		Diameter at the internal circumference
Roller diam. on ext. length	ERD	mm		Diameter at the external circumference
Hole diameter	HD	mm		
Number of holes	NH			



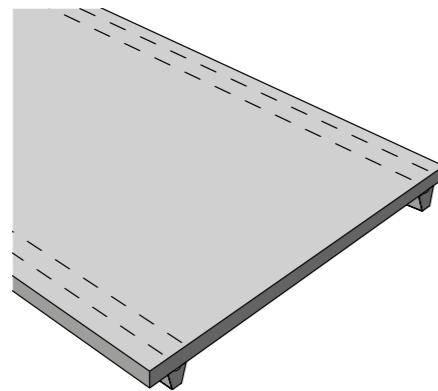
In the request stage, it is important to specify whether the curve angle has been determined based on the angle formed by the tangents to the rollers or by their interaxle spacing.



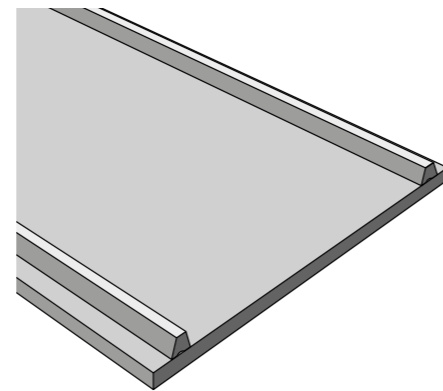
SECTION	ID CODE		SIZES (MM)		MINIMUM DIAMETER (MM)	
	PVC	PU	Base	Height	Longitudinal	Section
KL	KL 6	KL 6 U	6	3	30	X
	KL 8	KL 8 U	8	5	60	Y
	KL 10	KL 10 U	10	6	80	Z
	KL 13	KL 13 U	13	8	100	A
	KL 17	KL 17 U	17	11	140	B
	KL 22		22	14	180	C
KD	KD 8	KD 8 U	8	5	40	Y DENT
	KD 10	KD 10 U	10	6	60	Z DENT
	KD 13	KD 13 U	13	8	80	A DENT
	KD 17		17	11	120	B DENT
S	S 8	S 8 U	8	8	100	\\
	S 10	S 10 U	10	10	140	\\
	S 12		12	12	160	\\
	S 15		20	15	200	\\
	S 20		16	20	300	\\



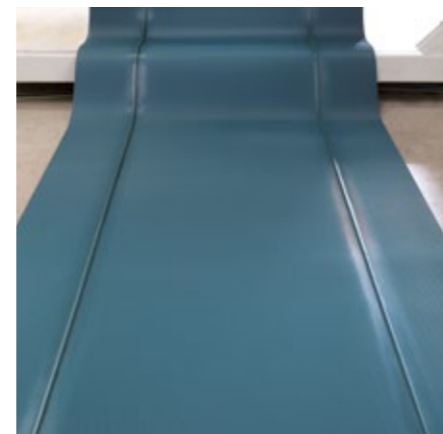
Internal central guide for belt centring



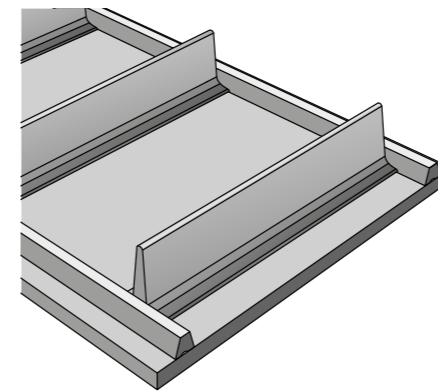
Double internal guide on bottom



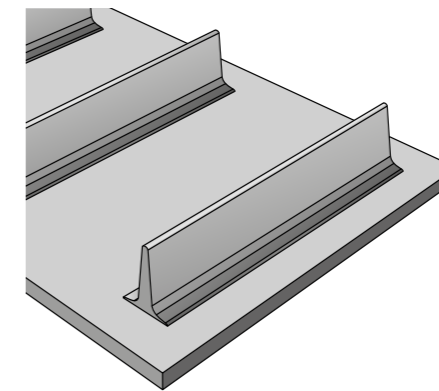
Double internal guide on bottom



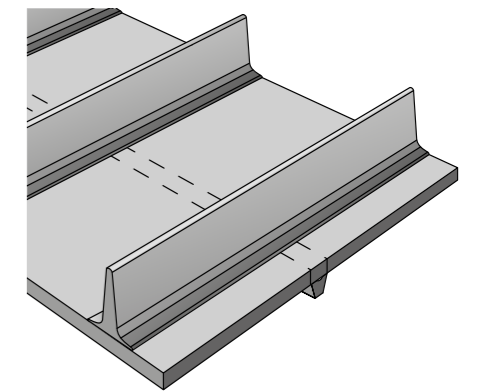
SECTION	ID CODE		SIZES (MM)		MINIMUM DIAMETER (MM)		
	PVC	PU	Base	Height	Transversal	Section	
S	S 8	S 8 U	8	8	50	\\	
	S 10	S 10 U	10	10	60	\\	
	S 12		12	12	70	\\	
	S 15		20	15	140	\\	
	S 20		16	20	120	\\	
	T	T 20		22	20	80	\\
		T 30		22	30	80	\\
		T 40		22	40	80	\\
		T 50		22	50	80	\\
		T 60		22	60	80	\\
T 80			22	80	80	\\	
L		L 20		22	20	80	\\
		L 30		22	30	80	\\
	L 40		22	40	80	\\	
	L 50		22	50	80	\\	
	L 60		22	60	80	\\	
	L 80		22	80	80	\\	
	TP	TP 10		12	10	40	\\
		TP 20		12	20	40	\\
TP 30			12	30	40	\\	
TP 40			12	40	40	\\	
TP 50			12	50	40	\\	
TP 60			12	60	40	\\	



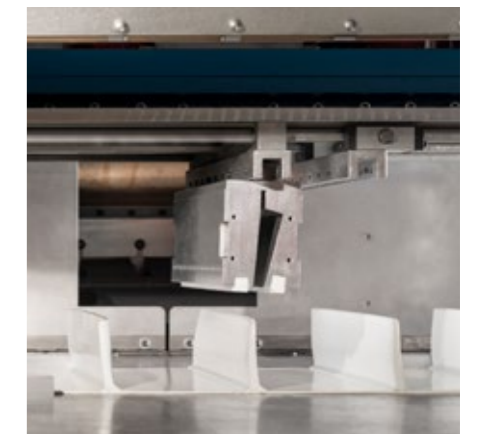
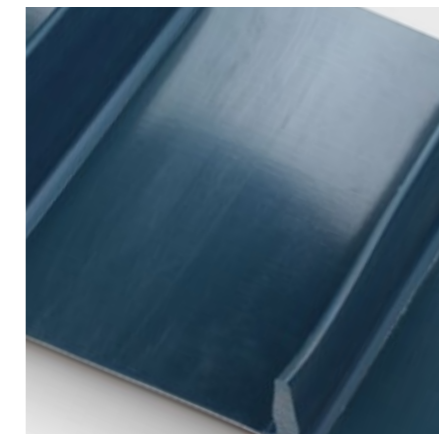
Conveyor side edges for gradient changes plus central slat



Transversal slat with free edges



Transversal slat with central internal guide

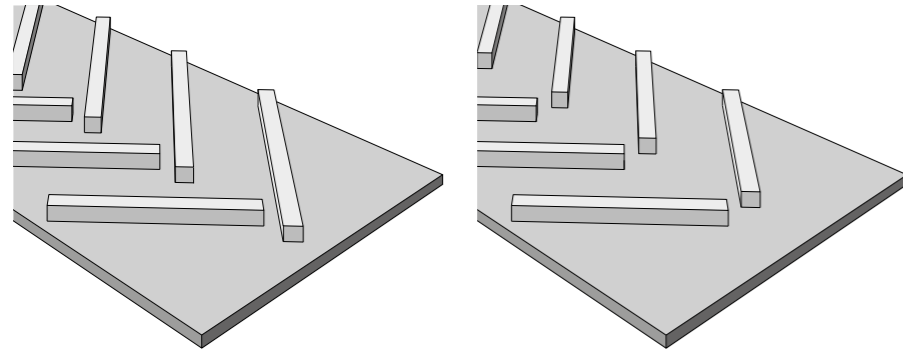


10. PROFILES, GUIDES AND CLEATS

FISHBONE PROFILES

The application of slats in a herringbone pattern provides an ideal solution for the inclined conveyance of loose products.

- Various fishbone applications can be made: open vertex, closed vertex and Y.
- The standard tilt angle between the slats is always set at 74°.
- It is important to specify whether the belt works flat or in a hollow, as in this case a flexible weft belt must be used.



REINFORCED SLATS

PVC cleats reinforced with polyester plies.

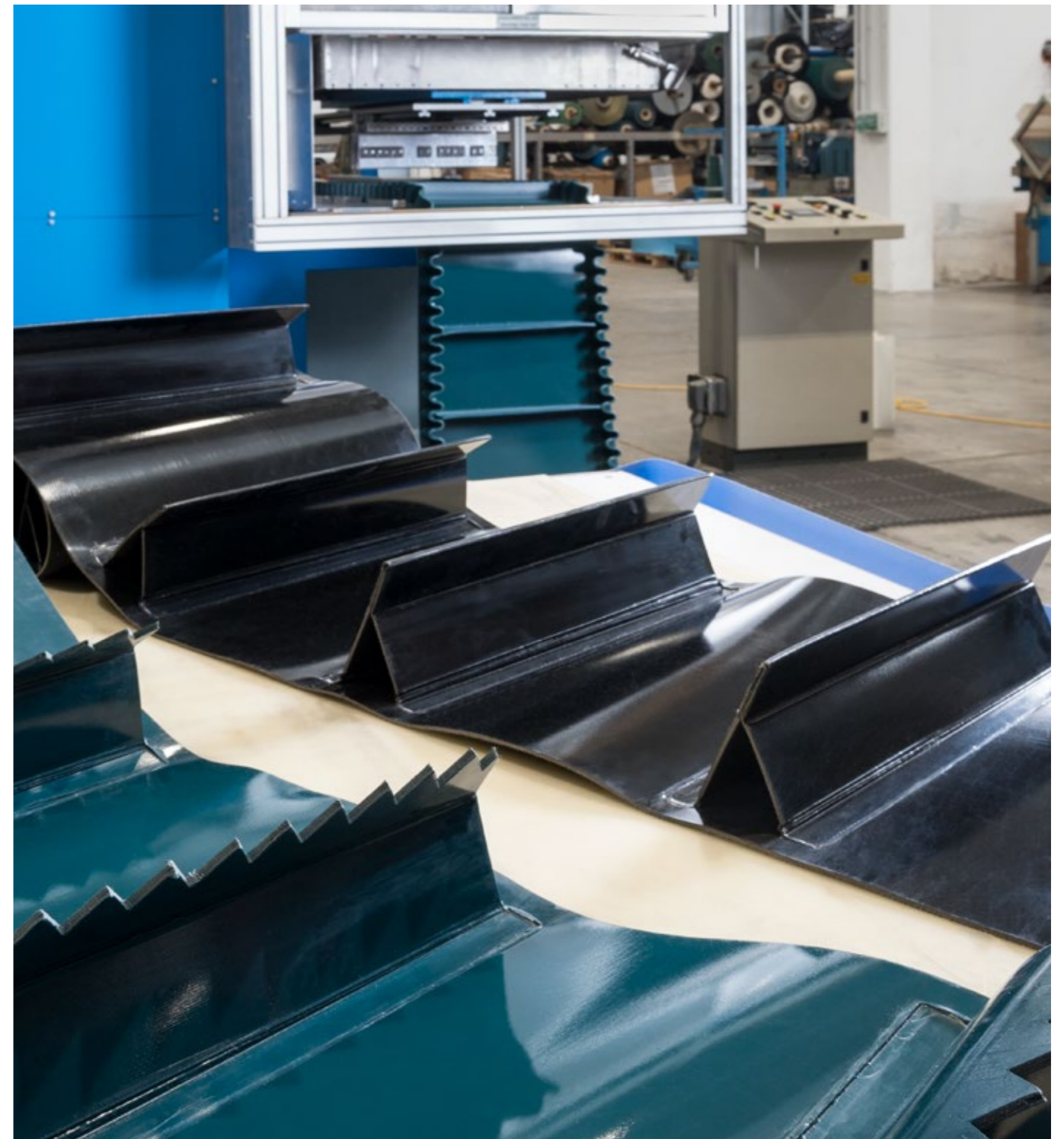
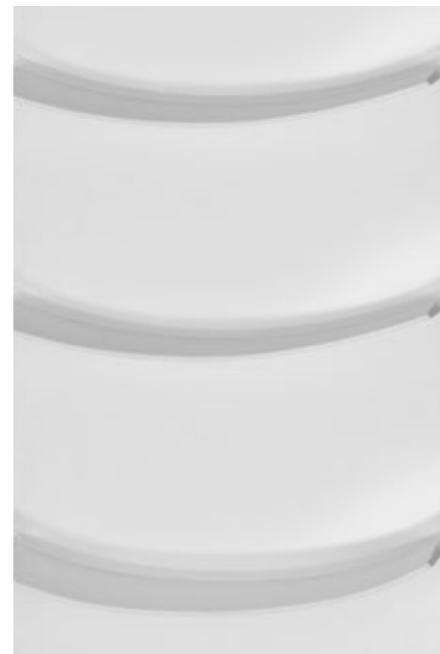
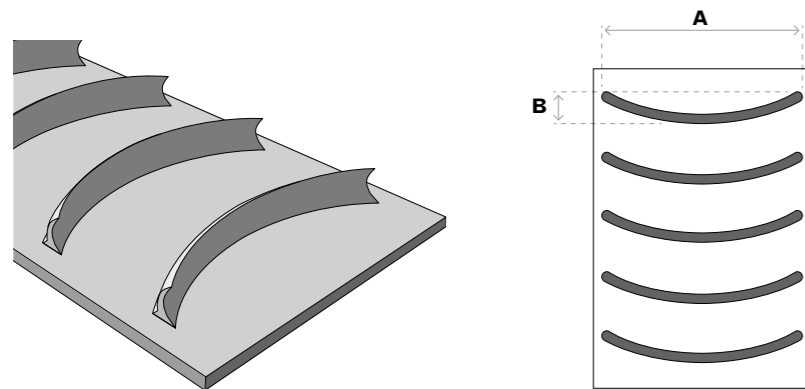
Different shapes and heights are available on request. The cleats, thanks to their reinforcing plies, provide great mechanical strength and excellent adhesion to the belt, due to the full compatibility of the material.



ARCHED SLATS

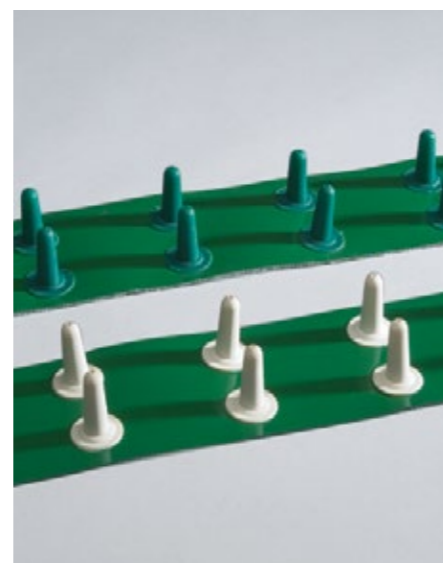
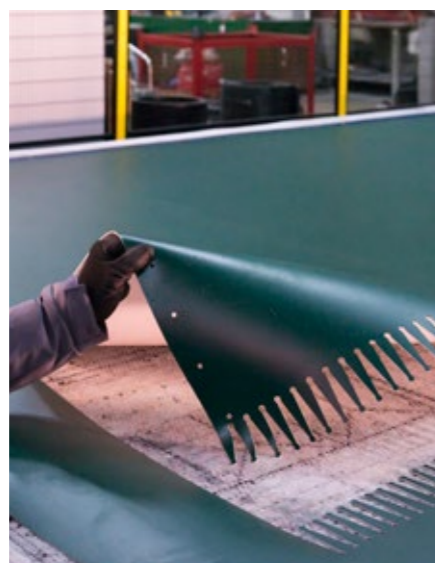
Arched cleats are mainly used for inclined transport of products, as their particular application allows to increase the carrying capacity.

They are particularly suitable for small sized products and in the presence of modest quantities of liquid.



11. SPECIAL APPLICATIONS AND BELTS

A Zeta Gomma is capable of making **special profiles with different sections and materials** or developing and producing new types dedicated to each specific need.



BELTS FOR CUTTING MACHINES

A Zeta Gomma exclusively offers the **3 R 12 LD belt**, specifically designed for use in tile cutting machines.

The 3-ply belt with a thermoplastic rubber coating offers numerous advantages over traditional PVC belts, with red and black rubber coating.

- **NO GRINDING:** no grinding is necessary as the belt is already originally manufactured with a constant thickness.
- **NO GLUING:** the belt coating forms a single body with the core, thus, no gluing is performed, avoiding the potential problem of a double tension between the belt and the rubber.
- **MAXIMUM WIDTH: 2000 mm.**
- **HOTVULCANIZED JOINT:** no visible sign of the joint on the surface of the belt.
- **FAST DELIVERY:** in urgent cases, we can produce the belt in 4 hours.
- **LESS DISC WEAR:** empirical tests have shown that the belt, if properly used, reduces disc wear.



BELTS FOR GRAPE HARVESTERS

A Zeta Gomma is capable of producing **special belts for the most widely used commercial** grape harvesting machines.

Our belts are produced to FDA standards, with arched slats and lateral guides designed specifically for this type of application



12.

FLAT BELTS

A Zeta Gomma's **flat belts** are designed using the most **advanced industrial techniques** to satisfy any request for customization.

They are manufactured in our main production plant with **high precision machines**, such as skiving machines, grinding and CNC machines, for the creation of holes, slots and special milling.



02



03

They consist of a special nylon layer coated with rubber to ensure resistance to abrasion and absolute linearity of movement.

They are used for large and medium power transmissions with low energy consumption and in conveyor and automation systems with high technological content.

Main features:

- High resistance to abrasion
- They can be driven by mechanisms with smaller winding diameters
- Excellent resistance to oils and chemical products
- Very stable friction coefficient, even with aging
- Good resistance to temperature variations
- Anti-static treatment

SERIES	GENERAL FEATURES	APPLICATIONS
TT	Polyamide traction layer, with polyamide fabric on both sides	Packing machines - Accumulation conveyors U.V. ovens - Woodworking machines
SG	Polyamide traction layer, with polyamide fabric impregnated with an elastomer on both sides	Printing machines Machines for bookbinding, folding, etc. Packaging machines - Light conveyors
L	Polyamide traction layer, with fine thickness elastomer on both sides	Paper processing machines Woodworking machines - High speed drives Light roller conveyor drives
M	Polyamide traction layer, with medium thickness elastomer on both sides	Corrugated cardboard processing machines Woodworking machines - Power drives
H	Polyamide traction layer, with high thickness elastomer on both sides	Cardboard tube production machines Power transmissions
MH	Polyamide traction layers for heavy loads, with high thickness elastomer on both sides	High power controls
XH	Polyamide traction layer, with high friction coefficient elastomer on both sides	Folding and gluing machines - Machines for processing corrugated cardboard - Loading chambers - Machines for manufacturing cardboard tubes - Packaging machines
TF	High-resistance polyamide traction layer, with high friction coefficient elastomer on one side and medium on the other	Tangential drives Tangential drive for conveyor rollers
LT	Polyamide traction layer, with polyamide fabric on one side and leather on the other	Mill systems - Paper mill pulpers Power transmission - Paper conveying and processing - Conveying of sharp products
LL	Polyamide traction layer, with leather on both sides	Mill systems - Paper mill pulpers Power transmission - Paper conveying and processing - Folding and gluing machines

- 01 Flat belts
- 02 Flat belt processing department
- 03 CNC skiver

		FEATURES										
		Total thickness (mm)	Weight (Kg/m ²)	Minimum diameter (mm)	Traction at 1% elong. (N/mm)	Tensile strength (N/mm)	Heat resistance (Max °C)	Top cover (Colour, Material, Friction coeff. (2))	Bottom cover (Colour, Material, Friction coeff. (2))			
TT	TTA 250 N	1	0.9	25	1.5	60	+80	blue nylon layer 0.25	blue nylon layer 0.25			
	TTA 500 N	1.3	1.2	40	3.8	150	+80	blue nylon layer 0.25	blue nylon layer 0.25			
SG	SG 250	0.8	0.8	20	1.5	60	+80	green elastomer 0.35	black elastomer 0.35			
	SG 500	1.1	1.1	50	3.8	150	+80	green elastomer 0.35	black elastomer 0.35			
	SG 1000	1.6	1.7	100	7.5	300	+80	green elastomer 0.35	black elastomer 0.35			
	SGL 500	1.3	1.4	50	3.8	150	+80	green elastomer 0.35	black elastomer 0.35			
L	L 250	1.25	1.4	25	1.5	60	+80	blue elastomer 0.55	black elastomer 0.55			
	L 500	1.55	1.8	50	3.8	150	+80	blue elastomer 0.55	black elastomer 0.55			
	L 750	2.2	2.5	75	5.6	225	+80	blue elastomer 0.55	black elastomer 0.55			
	L 1000	2.45	2.8	100	7.5	300	+80	blue elastomer 0.55	black elastomer 0.55			
M	M 1000	3	3.3	100	7.5	300	+80	blue elastomer 0.55	black elastomer 0.55			
	M 1500	3.5	4	150	11.3	450	+80	blue elastomer 0.55	black elastomer 0.55			
H	H 500	3.5	3.8	50	3.8	150	+80	blue elastomer 0.55	black elastomer 0.55			
	H 1000	4	4.4	100	7.5	300	+80	blue elastomer 0.55	black elastomer 0.55			
MH	MH 3000	5.5	6.5	300	22.5	900	+80	blue elastomer 0.55	black elastomer 0.55			
	MH 4000	6.5	7.6	400	30	1200	+80	blue elastomer 0.55	black elastomer 0.55			
XH	XH 500-3	3	3.4	40	3.8	150	+80	blue elastomer 0.65	blue elastomer 0.65			
	XH 500-4	4	4.3	50	3.8	150	+80	blue elastomer 0.65	blue elastomer 0.65			
	XH 500-5	5	5.5	60	3.8	150	+80	blue elastomer 0.65	blue elastomer 0.65			
	XH 500-6	6	6.6	70	3.8	150	+80	blue elastomer 0.65	blue elastomer 0.65			
	XH 750-3	3	3.3	60	5.6	225	+80	blue elastomer 0.65	blue elastomer 0.65			
	XH 750-6	6	6.6	80	5.6	225	+80	blue elastomer 0.65	blue elastomer 0.65			
	XH 1000-4	4	4.4	75	7.5	300	+80	blue elastomer 0.65	blue elastomer 0.65			
TF	TFL 6 S	2.2	2.4	60	5.8	230	+80	blue elastomer 0.55	grey elastomer 0.55			
	TFL 7 S	2.4	2.6	75	7.5	300	+80	blue elastomer 0.55	grey elastomer 0.55			
	TFL 10 S	2.6	2.8	100	9.8	390	+80	blue elastomer 0.55	grey elastomer 0.55			
	TFL 15 S	3.1	3.4	150	15	600	+80	blue elastomer 0.55	grey elastomer 0.55			
	TFL 18 S	3.35	3.7	175	17	680	+80	blue elastomer 0.55	grey elastomer 0.55			
	TFM 10 S	3.2	3.5	100	9.8	390	+80	blue elastomer 0.55	grey elastomer 0.55			
	TFM 15 S	3.7	4.1	150	15	600	+80	blue elastomer 0.55	grey elastomer 0.55			

		FEATURES										
		Total thickness (mm)	Weight (Kg/m ²)	Minimum diameter (mm)	Traction at 1% elong. (N/mm)	Tensile strength (N/mm)	Heat resistance (Max °C)	Top cover (Colour, Material, Friction coeff. (2))	Bottom cover (Colour, Material, Friction coeff. (2))			
LT	LT 05	2.8	2.5	50	5	100	+80	leather leather 0.45	- fabric 0.25			
	LT 07	3	2.9	70	7	140	+80	leather leather 0.45	- fabric 0.25			
	LT 10	3.3	3.7	100	10	200	+80	leather leather 0.45	- fabric 0.25			
	LT 14	3.5	4.2	120	14	280	+80	leather leather 0.45	- fabric 0.25			
	LT 20	4.3	5.1	280	20	400	+80	leather leather 0.45	- fabric 0.25			
	LT 27	5.2	6.4	380	27	540	+80	leather leather 0.45	- fabric 0.25			
	LT 40	6.7	8.2	560	40	800	+80	leather leather 0.45	- fabric 0.25			
LL	LL 05	4.5	3.2	50	5	100	+80	leather leather 0.45	leather leather 0.45			
	LL 07	4.5	4.1	60	7	140	+80	leather leather 0.45	leather leather 0.45			
	LL 10	4.6	4.9	90	10	200	+80	leather leather 0.45	leather leather 0.45			
	LL 14	5.3	6	140	14	280	+80	leather leather 0.45	leather leather 0.45			
	LL 20	6	6.8	280	20	400	+80	leather leather 0.45	leather leather 0.45			
HONEYCOMB	NRT-0	5.5	4.8	50	1.3	130	+80	blue elastomer -	white PES layer 0.25			
	NRT-100	4.5	3.6	50	6	150	+80	blue elastomer -	white PES layer 0.25			
	NRT-300	6.5	6.5	100	6	290	+80	blue elastomer -	white PES layer 0.25			
	NRT-500	6	5.6	90	7.5	150	+80	blue elastomer -	black elastomer 0.55			
	RT 15 NF	6.6	4.9	50	14	350	+120	blue elastomer -	white fabric 0.2			
ELASTOMER	GT 500 TX6	6	6.9	70	5	-	+80	blue elastomer -	blue nylon layer 0.25			
	GT 1000 TX6	6	7	80	10	-	+80	blue elastomer -	blue nylon layer 0.25			
	GG 500 TX6	6	6.9	70	7	-	+80	blue elastomer -	blue elastomer 0.65			
	GT 1000	2	2.5	70	10	-	+80	green elastomer -	black nylon layer 0.25			

Approximate values, variable in relation to speed.

(2) Friction coefficient on dry steel.

You can find the full range of the various belt series in our catalogues for specific application sectors and also request special, non-standard samples of our production.

FEATURES

ID CODE	Colour	Total thickness (mm)	Traction at 1% of elongation (N/mm)	Friction coefficient	
SE	SE-A-FWN	white / white	from 2 to 15	7.5	2.5

ID CODE	Total thickness (mm)	Weight (Kg/m ²)	Minimum diameter* (mm)	Tension (N/mm)	Recommended pre-tension (%)
TA 09	0.9	0.9	20	0.5 (5%)	5
TA 12	1.2	1.1	25	0.7 (5%)	5
R-6S	0.9	1	25	0.7 (5%)	5
R-S4G4	1.3	1.4	25	0.6 (2%)	2
NTA	1	0.9	25	0.5 (5%)	5
TC	1.4	1.5	40	0.8 (5%)	5
STC-10	1.35	1.3	25	0.5 (5%)	5
R-N	1	1.1	25	1.0 (2%)	2
TD-N	1	1.1	40	1.5 (2%)	2
W-4E14	1.4	1.4	25	4.0 (1%)	1
DB-4E14	1.4	1.4	25	4.0 (1%)	1
LA-4E14	1.4	1.5	25	4.0 (1%)	1
SLA-8E14	1.4	1.7	25	8.0 (1%)	1
LA-15E20	2	2.2	40	15.0 (1%)	1

PULLEY CONSTRUCTION SHAPE

1. Pulley width B: $B = 1.1 W + 10$ (mm), where W = belt width.
2. Select the height h of the crown from table 4 in relation to the pulley width B.
3. Pulley surface curvature radius R

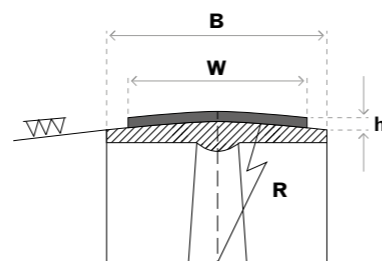
$$R = \frac{B^2}{8h} \text{ (mm)}$$

4. The surface of the pulley must be between 1.5 - S ~ 6 - S
5. Belt Speed and Pulley Material:

BELT SPEED	Less than: 30 m/sec.	Between: 30/50 m/sec.	More than: 50 m/sec.
PULLEY MATERIAL	Cast iron or Aluminium	Cast iron or Aluminium	Aluminium

Table 4. Standard crown height h (mm)

PULLEY MATERIAL	30-150	151-300	301-700	701-1000	1001-1500	over 1500
30-150	0.8	1.2	1.3	1.7	2.0	2.5
126-260	1.0	1.3	1.5	2.0	2.3	2.8
261-400	1.1	1.4	1.6	2.2	2.5	3.0



WIDTHS (MM)

from 0	from 50 mm	from 200 mm	from 400 mm
to 50 mm	to 200 mm	to 400 mm	to 600 mm
± 1 mm	± 1.5 mm	± 2 mm	± 3 mm

LENGTHS (MM)**

from 0	from 5 m.	from 10 m.	from 30 m.
to 5 m.	to 10 m.	to 30 m.	to 50 m.
± 10 mm	± 20 mm	± 30 mm	± 100 mm

** Endless belts length refers to the neutral axis and not the internal length; in summary, the given measure is the cutting length with the belt measured extended on a flat surface.

** For Nittra belts with a polyamide layer, an additional tolerance of 0.5% to 1% must be allowed for due to the conditions of humidity in the work area.

TENSIONING OF FLAT BELTS

The flat belts must be tensioned to a percentage that allows transmission of the necessary power, i.e. that required by the transmission system being studied.

The elongation percentage values vary depending on the circumstances, from a minimum of 1.3% to a maximum of 2.7%. A limit value of 3% may be reached, with a high risk of compromise of joint duration.

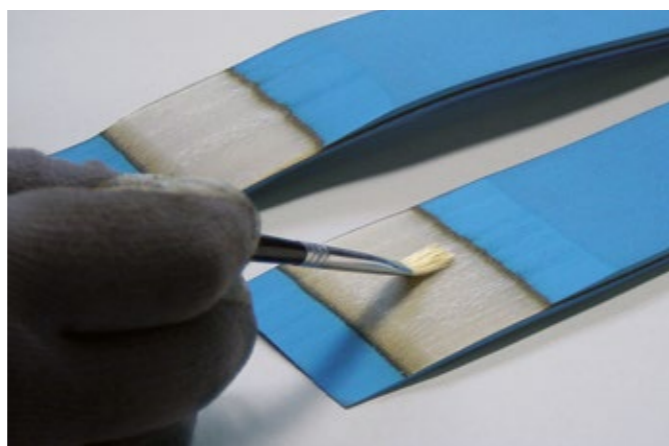
For tensions greater than 2%, you must ensure that the diameter of the smallest pulley is at least 20% larger than the minimum required in the specific tables.



13. ADHESIVES AND JOINING PROCEDURES

JOINING RUBBER/NYLON BELTS

1. Apply polibond A on the nylon and fabric parts on both ends of the belt gradually and uniformly with a clean brush (avoid excessive amounts of polibond A).
Once the glue has been applied, leave it to activate on the two ends of the sanded belt for about 5 minutes at room temperature.
2. After the spreading, apply a thin layer of polibond adhesive E on the rubber layers of both sanded ends of the belt.
3. Apply a second coat of polibond E on the rubber. Immediately afterwards, insert one end of the belt in the centre of the press and secure it in place with the clamping tool.
4. With one end of the belt firmly held in the press, overlap the second end on the first and secure it with the other tool. Insert two sheets of glass-teflon above and below the two overlapping ends of the belt respectively, to prevent the belt from sticking to the walls of the press when it heats up.

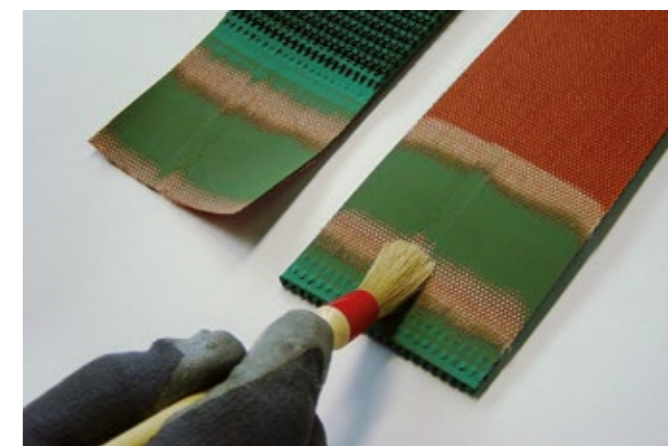


BELT TYPE	GLUE	PRESS TEMPERATURE °C	TIME (MIN.)
TTA 250 N	A	110 - 120	10 min
SG 250	A	110 - 120	10 min
SG 500	A	110 - 120	10 min
L250	A+E	110 - 120	10 min
L500	A+E	110 - 120	10 min
GT 350 B	A+E	110 - 120	10 min
TFL 10 S	A+E	110 - 120	25 min
TFL 15 S	A+E	110 - 120	25 min
NRT -500	A+E	110 - 120	20 min
TFL 6 S	A+E	110 - 120	20 min
TFL 7 S	A+E	110 - 120	20 min
XH 500-3	A+E	110 - 120	20 min
XH 500-4	A+E	110 - 120	20 min
XH 500-5	A+E	110 - 120	20 min
XH 500-6	A+E	110 - 120	20 min
XH 750-6	A+E	110 - 120	20 min
GT 500 TX6	A+E+PU	110 - 120	20 min
GT 1000 TX6	A+E+PU	110 - 120	20 min
GG 500 TX6	A+E+PU	110 - 120	20 min

N.B. Wait until the plates are at least lukewarm before opening the press.

JOINING RUBBER/FABRIC BELTS

1. Vigorously mix the hardener Hr with the PU Bond glue.
2. Apply the glue with a brush on the previously sanded ends of the belt.
3. The glue must be spread both on the rubber and on the fabric.
4. Wait for about 5 minutes, or the time necessary for the glue to dry completely.
5. Re-apply the glue on both ends of the belt.
6. Immediately overlap the two ends and insert them in the press, taking care to align them properly. Insert two sheets of glass-teflon above and below the two overlapping ends of the belt respectively, to prevent the belt from sticking to the walls of the press when it heats up.
7. Hold the belt still using the clamping arms and then tighten them well with the knob.



BELT TYPE	GLUE	PRESS TEMPERATURE °C	TIME (MIN.)
NRT-0	PU+HR	110 - 120	20 min
NRT -100	PU+HR	110 - 120	20 min
RT 25 HG	PU+HR	110 - 120	20 min
PNP 25 A	PU+HR	110 - 120	20 min
PNP 40 A	PU+HR	110 - 120	20 min
PNP 55 A	PU+HR	110 - 120	20 min

N.B. Wait until the plates are at least lukewarm before opening the press.

14. METAL BELT JOINTS

The metal joints allow the belt to be changed in very short times and without having to dismantle the machinery.

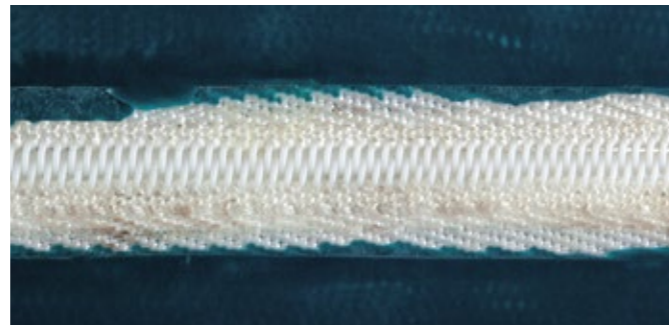
The use of the metal joint is recommended where vulcanized joints cannot be used or where it is not necessary to maintain surface continuity.



Example of a press for staples



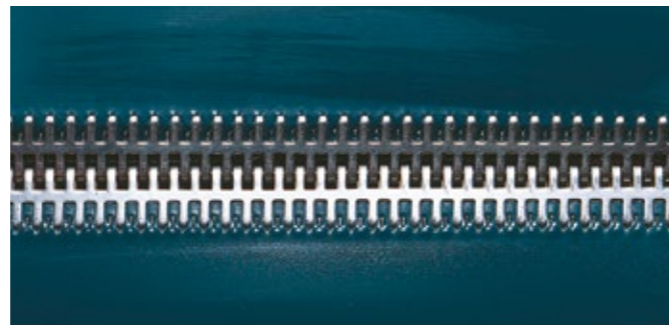
Plastic joints



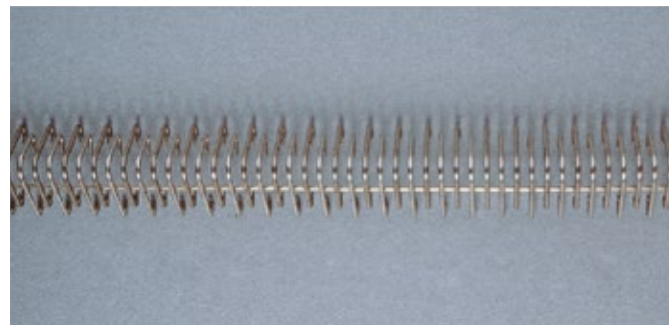
Example of a plastic joint



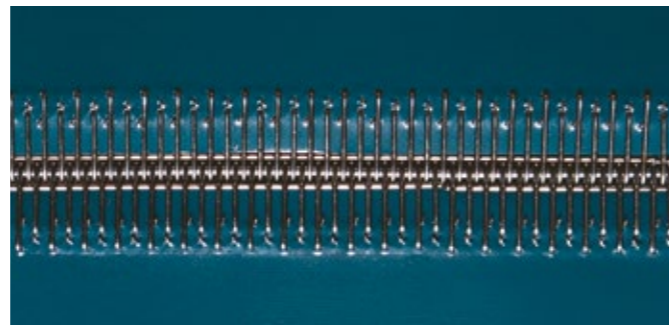
MG-type joint



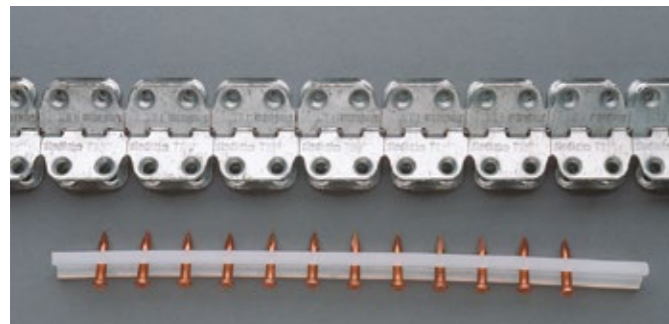
Example of a MG joint



SW-type joint



Example of a SW joint



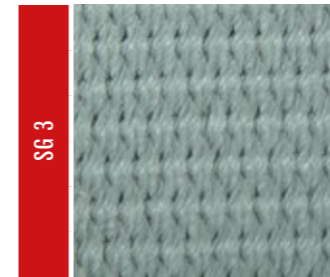
Stainless steel nail joint



Example of a stainless steel nail joint

15. COVERINGS FOR ROLLERS AND BELTS

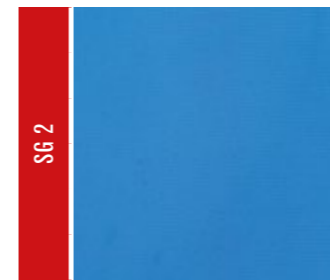
COVERINGS FOR ROLLERS



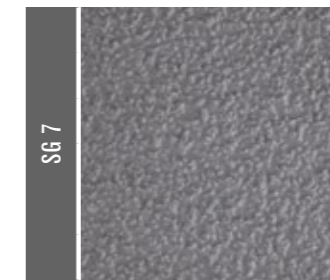
Thickness	1.8 mm
Weight	1.7 kg/m ²
Colour	Grey
Surface	NBR
Support	PET
Max. temperature	100



Thickness	4.2 mm
Weight	2.8 kg/m ²
Colour	Black
Surface	NBR
Support	PET
Max. temperature	100



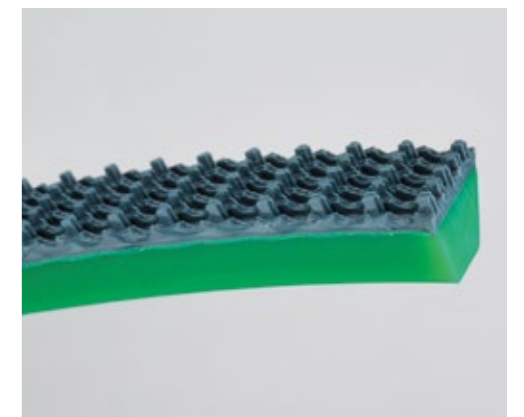
Thickness	1.9 mm
Weight	2.0 kg/m ²
Colour	Blue
Surface	NBR
Support	PET
Max. temperature	100



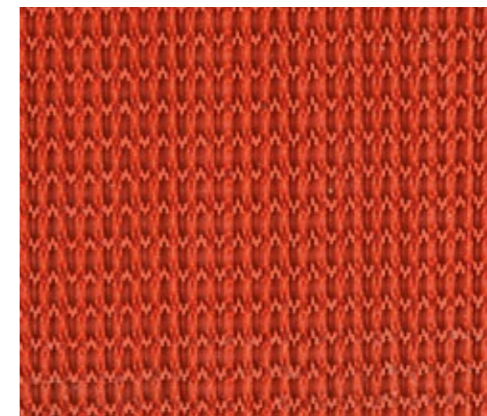
Thickness	2.1 mm
Weight	2.2 kg/m ²
Colour	Grey/White
Surface	NBR
Support	PET
Max. temperature	100

COVERINGS FOR BELTS

1 LRF 272 RT OH
Green rough top PVC belt, with removable lower fabric



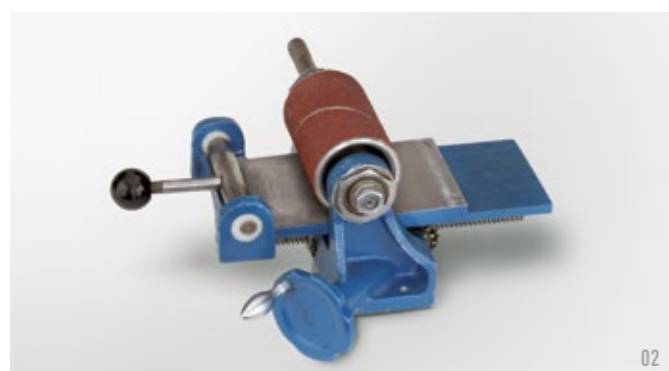
1 LRF 402 RT OH
Brick red rough top thermoplastic rubber belt, with removable lower fabric



Thanks to constant research, A Zeta Gomma has developed and patented **tools for the pressing, welding and joining of belts**, to meet all its customers' needs and resolve any issues concerning applications.

This includes: **M.E.C. Splicing Machine**, an integrated system for die-cutting and welding any type of polyurethane toothed belts and **M.E.C. Welder**, quick welder for polyurethane belts.

In addition, **A Zeta Gomma** offers its customers **skivers and presses** to ensure the best processing of the products it supplies.



02



03



04



01



05

- 01 M.E.C. Splicing Machine
- 02 Portable skiver
- 03 Portable press
- 04 M.E.C. Welder®
- 05 Portable press

Each purchase order by the customer is subject to the "General Conditions of Sale", whose terms, provisions and general regulations govern the supply, unless otherwise agreed by the parties, which must be in written form or else shall be null and void, and must be stated on the orders and the order confirmation.

Some important parts of the general conditions of sale are set out below (the full document is available on www.azetagomma.com), with the purchaser referred to also as the "buyer" and A Zeta Gomma also as the "seller" or "supplier".

PRICES:

Unless otherwise agreed in writing, the sales prices applied shall be those in force at the time of the order and order confirmation, understood as covering goods delivered ex-warehouse A Zeta Gomma S.p.A., with packaging costs borne by the customer.

TRANSPORT COST AND RISK:

The costs and liability for transport shall be borne by the customer. The goods are always shipped entirely at the buyer's own risk, even if the sale is negotiated with carriage paid through special agreements.

DELIVERY TERMS:

The delivery terms, when written, must be considered purely indicative and never binding. The seller shall in any case remain exempt and excluded from any liability for alleged loss or damage related or attributed to total or partial advanced or delayed delivery. In the case of delays attributable to the Seller, claims for compensation may only be considered for supply CONTRACTS in which a penalty clause has been expressly agreed; in each case, the amount of compensation cannot be greater than the value of the supply. The customer must collect the ordered products even in the case of late delivery.

PRODUCT CONFORMITY:

A Zeta Gomma S.p.A. guarantees the 'conformity' of the supplied products, meaning that they must correspond in terms of quantity, quality and type to what is specified in the contract, understood as an order that is accepted with a conforming order confirmation.

TOLERANCES:

The above provisions regarding product conformity must nevertheless allow for the acceptance of tolerances of use due to manufacturing requirements.

REPORTING DEFECTS AND COMPLAINTS:

Any supply non-conformity noticed by the buyer must be promptly reported in writing, under penalty of loss of rights, in order to allow A Zeta Gomma S.p.A. to quickly intervene and/or seek a prompt solution to the complaint, if substantiated.

LIABILITY:

The goods supplied must be used and employed in accordance with the product usage specifications as no liability can be attributed or compensation claimed from the supplier, for any reason, for damage caused by improper and unsuitable use of the supplied goods.

RETURNS:

Returned goods will not be accepted without previous written agreements. Any requests for replacement of the material supplied, without prejudice to proven non-conformity issues, will be accepted only under the following conditions:

1. That the material supplied is of a standard type, without particular construction, processing or procurement features specific to that supply requested by the customer.
2. That communication of the return request is received by the supplier within two months of delivery of the materials. When the return is authorized, the goods must be accompanied by the relevant delivery note, with indication of the details of the sales delivery note, and must arrive carriage free and in good condition. Acceptance of the return will be at the discretion of A Zeta Gomma S.p.A. For each accepted return request, A Zeta Gomma S.p.A. shall issue a credit note to the value of the supply, less 15% of the amount as a flat-rate expense reimbursement.

PAYMENTS:

Forms and modes. Payments and other amounts due for any reason to A Zeta Gomma S.p.A. must be made in the agreed modes and terms and are understood as net to the supplier's domicile. Any direct payments or remittances made to agents, representatives or auxiliaries of A Zeta Gomma S.p.A., will not be understood or deemed made until the time they become directly available to A Zeta Gomma S.p.A., in accordance with the terms agreed in the order.

Times. Delay or irregularity of any due payment, even partial, shall grant the supplier the right, upon written notice, to suspend deliveries or to terminate current contracts for various new supplies, even if the payments relate to other sales. This is without prejudice to compensation for further damages. Late payment, through failure to comply with the agreed terms, shall automatically result in the application of commercial interest pursuant to and by effect of Law 231/2002. A customer with overdue payments cannot claim exceptions with regard to the supplier without first making all the payments that are owed, with a possible right of remuneration in the case of dispute or controversy. Compensation with credits is not permitted, no matter how they may arise or be claimed by A Zeta Gomma S.p.A.

RETENTION OF TITLE:

The products delivered remain the property of A Zeta Gomma S.p.A. until full payment of the price has been made, at the time payment is due, in whole or in part, after the delivery. In cases of dispute and/or failure to pay even part of the price, A Zeta Gomma S.p.A. is entitled to have the sold goods or products returned to its registered office upon written request by registered letter or certified email. The return must be made within 10 days of receiving the request. APPLICABLE LAW and PLACE OF JURISDICTION:

The supply contract is governed by Italian law. For any dispute, the court of law with exclusive jurisdiction is that of A Zeta Gomma S.p.A., which alone, however, maintains the right to take action through the buyer's court of law.

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