

INTERNATIONAL STANDARD

ISO 432

Second edition
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Ply type conveyor belts — Characteristics of construction

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ISO 432:1989

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 432 was prepared by Technical Committee ISO/TC 41, *Pulleys and belts (including veebelts)*.

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This second edition cancels and replaces the first edition (ISO 432 : 1975), of which it constitutes a technical revision.

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International Organization for Standardization

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Ply type conveyor belts — Characteristics of construction

1 Scope

This International Standard specifies the most important characteristics of construction of ply type conveyor belts.

It specifies

- the number and position of longitudinal joints;
- the number and position of transverse joints.

It does not, however specify the width of the cover edges, as it has been decided that this would not be a subject of an International Standard.

It is not applicable to belts with a metal carcass or to fire-retardant belts.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard listed below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 251 : 1987, *Conveyor belts — Widths and lengths*.

3 Longitudinal joints

3.1 Number

The maximum number of longitudinal joints is given in table 1.

3.2 Position

3.2.1 Unless otherwise specified (as may be necessitated by peculiarities of construction or peculiarities of the idler assembly), longitudinal joints shall be at least 100 mm from the edge of the carcass.

3.2.2 Each longitudinal joint shall be at least 100 mm from the joints in the other plies.

NOTE — This condition may lead to a limitation of the number of plies with one joint.

3.2.3 The longitudinal joints, in one ply of any belt, shall be separated by at least 300 mm in those cases where the standard width of the belt permits two joints in the same ply.

4 Transverse joints

4.1 Transverse joints shall be at an angle of between 45° and 70° to the centre line of the belt.

4.2 Neither outer ply shall have more than one transverse joint per 100 m length of belt.

4.3 No inner ply shall have more than two transverse joints per 100 m length of belt.

4.4 Transverse joints in the different plies shall be separated by at least twice the belt width.

4.5 Transverse joints in the same ply shall be at least 5 m apart.

Table 1

Belt width ¹⁾ mm	Maximum number of longitudinal joints	
	per outer ply	per inner ply ²⁾
300, 400, 500, 600 and 650	0	0
800, 1 000 and 1 200	2	2
1 400, 1 600 and 1 800	3	2
2 000, 2 200, 2 400, 2 600, 2 800, 3 000 and 3 200	4	3

1) In accordance with ISO 251.
2) This number may be doubled if there are no longitudinal joints in both outer plies of the belt.

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