

# **Precision Belting for Demanding Environments**

Green Belting Industries belting products are engineered to endure the demanding environments in a wide range of industries, from food production and packaging, to industrial manufacturing. In most of these environments, heat, pressure, chemical exposure and abrasion are typical challenges that all of our belts handle with relative ease. Various belt sizes, thicknesses, textures, strength, stability, and splice / edge / tracking options all factor into the level of customization and overall performance specifications to best meet your needs.











#### **Baking Oven Belts**

Flat breads and tortillas are baked in press ovens that use PTFE coated conveyor belts to transport uncooked dough to the press area where a heat platen is applied, simultaneously pressing and cooking the product to its desired temperature and texture. The belts and fabrics used must be able to endure the high cooking temperatures and the abrasiveness of the doughs, many which contain coarse grains. The non-stick surface is key to maintaining a clean cooking surface.

While belt specifications may vary, depending on the type of machinery used, we often recommend either 100-10 or DXL-10 fabric, fabricated with castellated Aramid joints with a stainless steel pin.

#### **Lamination Belts**

Across the wide spectrum of laminated materials, rigid composites to flexible textiles, PTFE coated belts are used to convey constituent materials, glues and resins through the heated pressure zone where the constituent materials are heated, pressed, and fused together. Within these environments, the belts must be able to withstand the heat, pressure, compression, and abrasion through repeated use while resisting adhesion of the glue and any other chemicals used in the process.

Depending on demands of the process being used, suitable fabrics may range from 100-10 PR, DXL-10, and 100-12PR SP for lighter belting requirements, to 100-27 SP50 for heavier applications.

#### Side Seal Belts

A packaging process commonly used in the rolled paper products industry involves wrapping and sealing the finished product in a polyfilm package. After product is encapsulated in a polyfilm sleeve, the ends are heated and sealed as they are guided through the heat-seal units by PTFE / Glass belts running in tandem on either side of the product. The belts also provide a protective, non-stick barrier between the heat-seal elements, allowing the heat to transfer through to melt and seal the film wrapping, while preventing the molten film from sticking to the elements.

Side Seal Belts are generally fabricated from 100-6, 100-8, and 100-10 Standard Grade fabrics. For greater longevity, 100-6 TR, 100-10 TR (Tear Resistant), and DXL-10 fabrics are recommended.

#### Heat Seal

There are many forms of heat-seal packaging. The image to the left shows a top-seal process where flexible polyfilm pouches are guided between hot elements by two PTFE coated Glass belts. As the packages pass through, the heat from the elements passes through the belts to the top of the pouch and melts the two layers of film together to form the seal. The 2-ply PTFE / Glass fabric belts also prevent any melted polyfilm from adhering to the heat elements.

Depending on the application, we recommend 2-ply (double layer) belts made with 100-3, 100-5, or 100-6 PTFE / Glass Fabric.

#### **Rubber Extrusion**

Rubber polymer material is heated and then forced, at high pressure, through a shaped opening. The extruded product is then carried on a PTFE or Silicone coated Fiberglass conveyor belt as it passes through the curing oven and then cools. In some cases, fabrics with more prominent surface texture are used to convey the extruded material in order to create an intentional imprint on the freshly extruded material. Belt fabrics should be selected for best performance as belt life is reduced when temperatures exceed 287°C / 550°F for PTFE, and 250°C / 480°F for Silicone.

We recommend 100-10, 100-14, 100-20 and 100-27 SP50 Premium, PTFE coated Glass, or Open Mesh, for more pronounced pattern imprint.

# Standard Grade A good all-purpose, high-strength material with excellent release properties, used in a wide range of cooking applications. Premium (PR) Grade Enhanced premium coating make this fabric ideal for conveying of rubber extrusions and other products that require controlled surface texture and exceptional release. DXL

**Fabric Options** 

Specially reinforced PTFE coating gives DXL fabrics added abrasion resistance for handling more abrasive materials such as coarse-grain flat breads and tortillas.

#### Tear-Resistant Grade

Special coating and Glass substrate make this fabric a tough, tear-resistant and flexible conveyor belting material for demanding applications.



#### Specialty Grade

With very smooth surface texture and excellent release properties, this fabric is well suited for heat-seal packaging applications.





Anti-static PTFE coating on Fiberglass substrates makes this fabric suitable for powder coating applications and handling of sensitive electronics components.





**PTFE / Aramid** Our strongest fabric (stronger than steel by weight) resists cuts, flex fatigue, moisture, and shrinkage. Best suited for more demanding and high-moisture belting applications.

#### Silicone / Glass

Excellent strength, flexibility, release, and tear resistance make this fabric suitable for various food handling and packaging operations. Available with coating on one or both sides.

### **Physical Properties**

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Product	Max	Width	Nom. T	hickness	Nom.	Weight
	(in)	(mil)	(mil)	(mm)	(oz/yd²)	(g/m²)
		S	tandard			
100-3	60	1500	3	0.08	4	136
100-5	60	1500	5	0.13	8	258
100-6	60	1500	6	0.15	9	298
100-8 SW	40	1000	8	0.20	10	332
100-10	60	1500	10	0.25	14	488
100-10 SW	89	2200	9	0.23	10	332
100-14	89	2200	14	0.36	17	576
100-20	38	950	20	0.51	27	902
100-27	50	1270	27	0.69	31	1058
100-27 SP50	89	220	27	0.69	32	1085
		Р	remium			
100-3 PR	60	1500	3	0.08	4	146
100-5 PR	60	1500	6	0.05	•	275
100-5 PR	60	1500	6	0.15	0	2/3
100-0 PK	40	1000	0	0.15	11	309
100-8 SW PK	40	1000	8	0.20	11	38/
100-10 PK	60	1500	10	0.25	15	515
100-10 128	89	2200	10	0.25	15	492
100-12 PR SP	89	2200	12	0.30	18	593
100-14 PR	89	2200	14	0.36	22	/32
100-20 PR	60	1500	20	0.51	31	1051
100-27 SP50 PR	89	2200	27	0.69	38	1289
	1	ſ	DXL	ſ		r
DXL-3	40	1000	3	0.08	4	136
DXL-5	40	1000	5	0.13	8	258
DXL-6	40	1000	6	0.15	9	298
DXL-10	60	1500	10	0.25	15	522
		Me	echanical			
100-3 ME	40	1000	3	0.08	3	109
100-5 ME	40	1000	5	0.13	6	203
100-6 ME	40	1000	6	0.15	9	298
			Porous			
100-3 POR	60	1500	3	0.08	2	61
100-5 POR	40	1000	5	0.13	3	109
100-22 POR	60	1500	22	0.56	22	729
		Тер	-Resistant			
100.2TP	40	1000	2	0.09	4	120
100-3 IR	40	054	5	0.08	4	107
100-4 TR	30	954	4	0.10	0	197
100-5TR	40	1000	5	0.15	0	204
100-018	40	2200	10	0.15	3	230
100-106	69	2200	10	0.25	14	400
	1	S	pecialty			
100-5 SP05	40	1000	5	0.13	5	153
		Antis	static Black			
100-10 AS	89	2200	10	0.25	14	482
100-14 AS	89	2200	14	0.36	21	699
		PTFE Coate	d Aramid F	abrics		
KEV 5 PR	50	1250	5	0.13	4	146
KEV 17	63	1600	17	0.43	18	610
		Silicone	Coated Gla	355		I
SW-7 SP1	40	1000	7	0.10	0	200
SW-7 SP1	40	1000	10	0.18	10	200
SW-10	40	1000	10	0.25	10	342
SW-23 COSO*	38	954	23	0.58	20	6/5
SK-23 COSO*	38	954	23	0.58	20	6/5
SW-25	38	954	25	0.64	27	909
SR-25	38	954	25	0.64	27	909
SW-35	38	954	35	0.89	33	1131

Product data is subject to change. Contact your representative for more details. \*COSO = Coated One Side Only.

The product images shown in this document are for illustration purposes only and may not be an exact representation of the product. Products and specifications subject to change without notice.

## **Fabric Options**

**Alligator Splice** 

**Fabric Pin Splice** 

imade (PAI) pin.

**Finger Splice** 

**Heat Sealed Overlap** 

and then heat sealed together.

An exceptionally strong splice, metal lacing is joined with a metal pin. May include

Castellated loops on belt ends are joined together with a Fiberglass or polyamide-

A standard splice for most applications.

Belt ends are overlapped by 0.5 - 2 inches,

a protective cover flap (shown).

#### Splices

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#### **Clipper Splice**

Individual metal hooks are installed in the ends of the belt and held together by a metal pin.



#### PEEK Spiral Splice

Temperature resistant plastic spiral lacing joins the ends which allows for airflow throughout the splice area.



#### Scarf Splice

Ends are tapered and overlapped by 1'', then heat sealed.



#### Heat Sealed Butt

Silicone Bead

Ends are butted together and a reinforcing fabric layer is heat-sealed beneath the joint.

The enclosed bead, stitched into PTFE / Glass edge, runs outside the edge of the roller to keep the belt aligned.

A raised Silicone bead, with flange, is de-

signed for grooved roller tracking systems.

#### Tracking

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Die-cut fingers are inter-joined, reinforced,

and heat sealed into place providing a flat,

#### Grommets (Eyelets)

continuous release surface.

Metal reinforced openings are installed to mate with belt tracking systems that use chains and springs.



Domes

PTFE Film Edge

Sealed Only

Raised metal rivet-like domes mate with grooved roller tracking systems.

PTFE film, heat-sealed to the outer edges prevents fraying, but does not provide any additional strength or support.

PTFE / Glass fabric, heat-sealed to the belt

edges, provides protecting against fraying while and adds support to the belt.

## Edge Options

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Silicone Bead & Flange

#### **PTFE Sewn Only**

PTFE / Glass fabric, fastened to belt edge with two rows of stitching, provides a cost effective edging option.



PTFE / Glass Fabric, Sewn & Sealed Our most commonly used edge option, 6 mil Glass fabric is sewn & sealed for reinforcement.

# The Green Belting Advantage

At Green Belting Industries, our approach to producing quality performance materials contemplates the vast range of unique applications and possibilities, from routine to complex, and from harsh to extreme. Our line of PTFE, Silicone, and Aramid fabrics meets a diverse range of barrier, release, belting, gasket, and other specialized demands. Customers experience a dramatic increase in performance and process efficiency while reducing turnaround time. Our ever-increasing Knowledge Base of resources offers tips, techniques, and examples to provide support to our customers and end users.











#### **GREEN BELTING INDUSTRIES**

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#### Strength and Performance - Fabrics, Belts, Tapes, and more...

Green Belting Industries offers the highest quality PTFE and Silicone coated fabrics, tapes, belts, and compounds for a multitude of applications ranging from baking sheets to thermal spray masking for jet engine turbine blades. Kev performance attributes:

- Resistance to extreme temperatures and abrasion
- Non-stick surfaces resist adhesion and chemical bonding
- Excellent strength and dimensional stability
- Engineered adhesives provide exceptional grip and easy, clean release (leave no residue)
- Excellent heat transfer and dielectric properties (depending on material)
- Food-contact approved (chemically inert, nontoxic).

#### **Research and Testing**

Our goal is to provide the fabric, tape, or belt you need, when you need it. Our R & D teams are constantly testing the performance of existing products and researching new and different substrates, coating resins and manufacturing technologies in response to new and emerging applications. We are always striving to get better at what we do. Whether it's helping you find a resolution to a tough technical problem or simply getting your order out on time, Green Belting Industries is committed to providing you the most costeffective, best performing and widest choice of engineered performance materials in the marketplace.

#### Manufacturing Excellence

As an ISO 9001 Quality Registered company, Green Belting Industries strives for continuous improvement and is committed to providing products and service of the highest guality. We draw from over 50 years of manufacturing excellence to design and build our own specialized equipment that delivers the highest quality engineered fabrics, tapes, & belts to the marketplace. This emphasis on quality and performance enables our customers to benefit from enhanced production efficiencies, higher output quality, and time and cost savings.

#### **Friendly Expert Service**

We know that we can only be as good as our people so Green Belting Industries thrives on individual initiative, teamwork, and superior service to our customers. Our knowledgeable Customer Service teams regularly receive hands-on, cross-departmental training which includes assembling product in one of the fabrication facilities. This approach has made our associates among the most industry-savvy in the business. With Customer Service teams based in all of our operating countries (Canada and the UK), beginning with your initial contact Green Belting Industries is with you every step of the way.

#### **Efficient Global Distribution**

With two plant and office locations in Canada and the UK, Green Belting Industries customers benefit from quick and efficient global distribution. Bringing the resources of these locations together translates to distinct advantages for our customers, including manufacturing and fabricating efficiencies and improved inventory management, delivery, and customer service. All facilities are within major population centers, assuring that the majority of our customers will experience fast product delivery.





www.greenbelting.com

As an ISO 9001 Quality Registered Company, our ongoing procedure for quality assurance starts with thorough inspection of all raw materials to ensure compliance with our required specifications. All manufacturing processes are closely monitored, and finished product is tested against our high internal standards and customer specifications. This assures that we always deliver consistently high quality products.