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**Textile conveyor belts — Adhesive strength  
between constitutive elements —**

**Part 1:  
Methods of test**

*Courroies transporteuses à carcasse textile — Adhérence entre éléments  
constitutifs —*

*Partie 1: Méthodes d'essai*



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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to member bodies for voting. Publication as an International Standard requires approval by at least 75 % of member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 252 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 252-1 was prepared by the European Committee for Standardization (CEN) in collaboration with ISO Technical Committee TC 41, *Pulleys and belts (including veebelts)*, Subcommittee SC 3, *Conveyor belts*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Throughout the text of this standard, read "...this European Standard..." to mean "...this International Standard...".

This first edition of ISO 252-1 partially cancels and replaces ISO 252:1988, in particular the methods of test. The performances will be the subject of ISO 252-2, which will definitively cancel and replace ISO 252:1988.

ISO 252 consists of the following parts, under the general title *Textile conveyor belts — Adhesive strength between constitutive elements*:

- *Part 1: Methods of test*
- *Part 2: Performance values*

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## Foreword

The text of EN ISO 252-1:1999 has been prepared by Technical Committee CEN/TC 188 "Conveyor belts", the secretariat of which is held by BSI, in collaboration with Technical Committee ISO/TC 41 "Pulleys and belts(including veebelts)".

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2000, and conflicting national standards shall be withdrawn at the latest by January 2000.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.



## 1 Scope

This Standard specifies two test methods , A and B, for determining the adhesion strength between plies, and between covers and carcass, of conveyor belts. Basic test conditions are in conformity with ISO 36.

It applies to all types of construction of conveyor belting with the exception of belts containing steel cord reinforcement, and textile-reinforced belts with a tensile strength less than 160 N/mm. It is not suitable or valid for light conveyor belts described in EN 873.

Note 1. Method A and Method B are alternative options but the mean adhesion force values calculated for Method A and Method B may be different. Also as both methods may not be equally suitable for all belt constructions , it is advisable that the advice of the belt manufacturer should be sought.

## 2 Normative references

This European Standard incorporates by dated and undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

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|----------|---|
| ISO 36   | Rubber, vulcanized or thermoplastic - Determination of adhesion to textile fabric                                     |
| ISO 6133 | Rubber and plastics - Analysis of multi-peak traces obtained in determinations of tear strength and adhesion strength |

## 3 Principle

The mean force required to strip the covers from the carcass, and also each ply from the next, is determined using a constant rate of traverse machine.

## 4 Apparatus

Suitable power-driven tensile testing machine, complying with the requirements of ISO 36.