
**Conveyor belts — Adhesion between
constitutive elements — Test methods**

*Courroies transporteuses — Adhérence entre éléments constitutifs —
Méthodes d'essai*



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Foreword

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ISO 252 was prepared by Technical Committee ISO/TC 41, *Pulleys and belts (including veebelts)*, Subcommittee SC 3, *Conveyor belts*.

This third edition of ISO 252 cancels and replaces ISO 252-1:1999, of which it constitutes a technical revision. It also incorporates the Technical Corrigendum ISO 252-1:1999/Cor. 1:2006.

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Conveyor belts — Adhesion between constitutive elements — Test methods

1 Scope

This International Standard specifies two test methods, A and B, for determining the adhesion strength between constitutive elements of a conveyor belt, i.e. between plies and between covers and carcass. Basic test conditions are in conformity with ISO 36.

It is applicable to all types of construction of conveyor belting with the exception of belts containing steel cord reinforcement, and textile-reinforced belts with a full-thickness tensile strength of less than 160 N/mm. It is not suitable or valid for light conveyor belts as described in ISO 21183-1^[1].

NOTE Methods A and B are alternative options, but the mean adhesive force values calculated for the two methods can be different. Also, as both methods might not be equally suitable for all belt constructions, it is advisable that the advice of the belt manufacturer be sought.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 36, *Rubber, vulcanized or thermoplastic — Determination of adhesion to textile fabrics*

ISO 6133, *Rubber and plastics — Analysis of multi-peak traces obtained in determinations of tear strength and adhesion strength*

ISO 18573, *Conveyor belts — Test atmospheres and conditioning periods*

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, conforming to ISO 36.

5 Test pieces

5.1 Time between manufacture and test

The time between completion of production and the commencement of testing shall be not less than 24 h; this period shall include the conditioning periods given in 5.5.