

LIGHTWEIGHT CONVEYOR BELTING – PVC AND RUBBER



HBD/Thermoid[®], Inc.

SUBSIDIARY OF HBD INDUSTRIES, INC.

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General Application Use – Quick Reference Guide*

	Food Handling	Agriculture & Harvesting	Package Handling	Light Industrial & Automation
PVC Conveyor Belt Products				
Chevron™		•	•	
Cleated Incline		•	•	
Griptite™			•	
Griptop®		•	•	•
Korowhite™	•	•		•
Pack-EZ S/Weave			•	
Herringbone		•	•	
Rubber Conveyor Belt Products				
Big Red™ Silicone				•
Butyl (Hot'N Cold)	•			•
Caripack®			•	•
Cleat-Rite "OSM"				•
Diamond Incline		•	•	•
Gin Flashing		•		
Griptop® – Gum		•		
Griptop® – Nitrile	•	•		
Griptop® – Rubber				•
Hot Stock & Water			•	•
Nitrile – Black	•	•	•	•
Pack-EZ Prem			•	
Potato Belt		•		
Ribflex®				•
Ridgetop™	•	•		•
Sani-Brite™	•			•
SaniWhite®	•			•
Sheeting		•	•	
Slide-A-Pack®			•	•
Sliptop™			•	•
Teflon White	•			•
V-Cleat			•	•

* NOTE: For complete application use details on each conveyor belt, see pages 8 and 9 for general use details and/or refer to the individual conveyor belt product descriptions.

Selecting the correct conveyor belt product can be difficult. To help you determine the correct products for

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HBD/Thermoid®, Inc. ... THE LEADING EDGE IN LIGHTWEIGHT BELT TECHNOLOGY

HBD/Thermoid®, Inc. has been a leading innovator in lightweight belt technology for decades. Many improvements that have now become industry standards were pioneered in our research laboratories.

We were the first to use 100% polyester and 50-50 polyester-cotton blends for greater strength and moisture resistance in our lightweight fabrics...the first to use a nitrile rubber to dramatically improve the oil resistance in our food belts. We developed the special adhesive treatment for synthetic carcasses that helps keep plies from separating.

When it comes to conveyor belt technology, HBD/Thermoid never lets down, which is why so many customers look up to us for engineering excellence.



UP-TO-DATE MANUFACTURING CONDITIONS

The HBD/Thermoid plant in Oneida, Tennessee, has more than 300,000 square feet, and is a modern belt-making plant using state of the art equipment. We manufacture a full-line of lightweight rubber and PVC conveyor belting under the cleanest conditions. We've invested heavily in this lightweight belting plant because we intend to make our belts the very best available.

SPECIALLY DESIGNED FABRICS AND COVERS FOR CONVEYOR SERVICE

We don't have to rely on commercial fabrics. Instead, our textile engineers develop special weaves designed to handle a wide range of tensions, loads, pulley sizes and troughing angles. Our cover compounds are developed by our own experienced research chemists to cope with conditions like oil and grease, heat and cold, chemicals, acids, moisture and abrasion. So every Made-In-USA Thermoid belting is designed to give you maximum service for your dollar.



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PVC AND RUBBER BELTING

No other manufacturer offers both in such a complete range of tensions and a wide choice of textures.

When HBD/Thermoid recommends a belt, you can be sure we have nothing to gain by suggesting any one type over another. We manufacture both types: PVC and rubber. So you can trust us to recommend the belt that's really best for you.



world's leading laboratories, so they're easy on the eyes under all types of illumination. Plus we offer special surfaces from extra-smooth to deeply textured. So whatever your particular requirement, you can find a Thermoid lightweight belt to match. Here are the features that make our belts a better value.

FLEXIBILITY

Our Customers can be confident when using our belt products in all applications. Our lightweight belting offers lower cost plus endurance when used in shorter centers and smaller pulleys.

LIGHTWEIGHT CONSTRUCTION

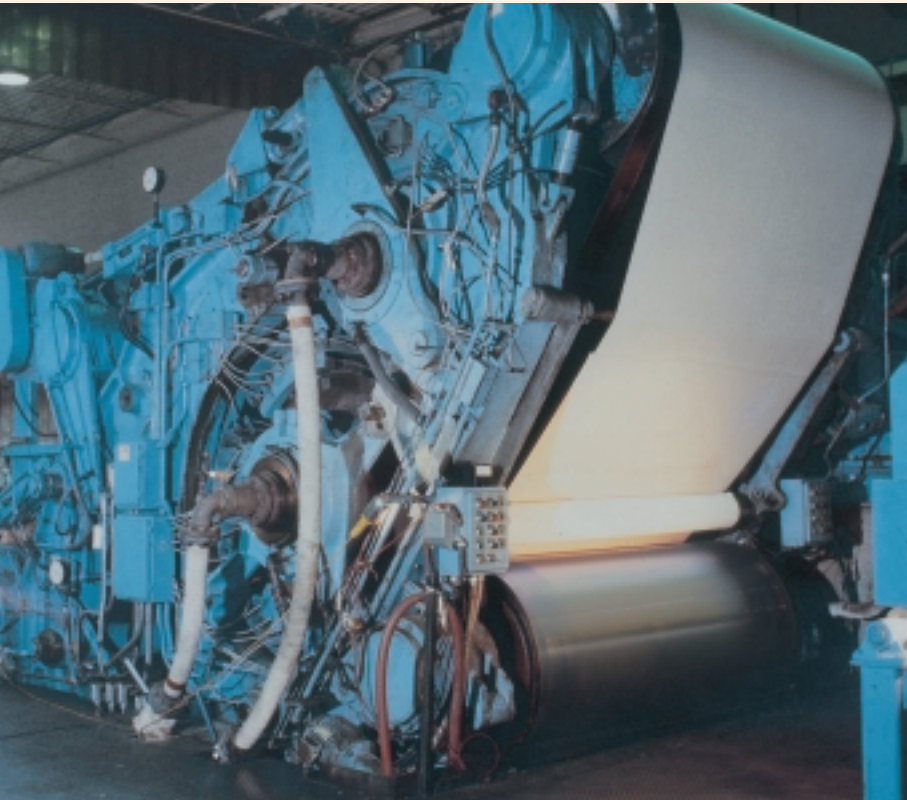
It takes less power to drive our belts. That can result in savings with today's high energy costs.

EXCELLENT DIMENSIONAL STABILITY

There's little need to take-up adjustments and few work stoppages. The drop in downtime means a rise in profitability.

HIGH STRENGTH AND ABRASION RESISTANCE

Adds up to a long, useful service life and a great return on your investment dollar.



Thermoid lightweight belting comes in a wide variety of tensions, fabrics and cover compounds. Each belt has two things in common: efficiency and economy. Our lightweight belting also features colors that are scientifically developed in one of the

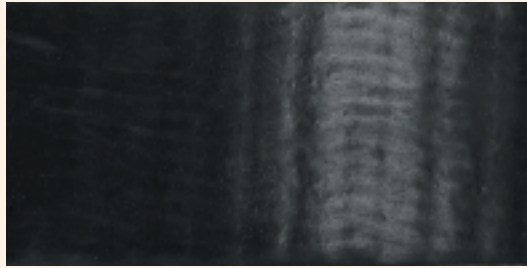
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SANIWHITE® & SANI-BRITE™ NITRILE – WHITE



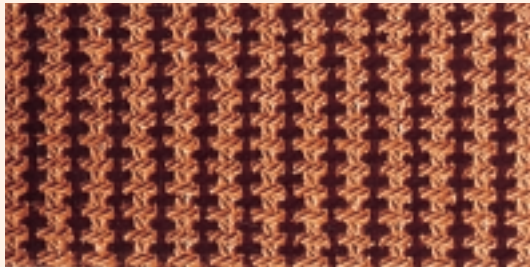
NYLOCK® COS



DIAMOND INCLINE – BLACK & TAN



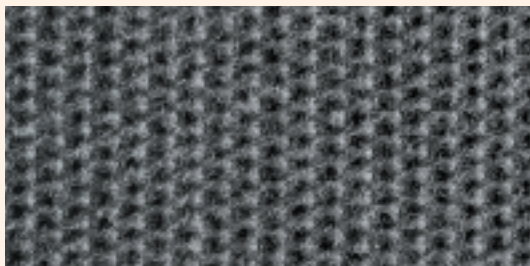
PVC HERRINGBONE



GRIPTOP®



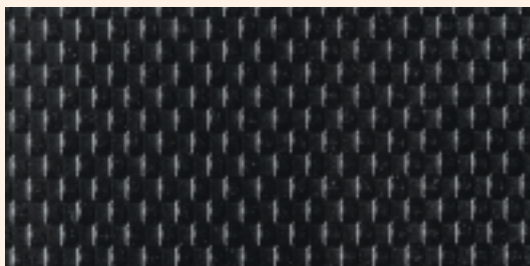
GRIPTOP® – BLUE & ORANGE, CARBOXYLATED



NYLOCK® – BLACK, SBXSB



SLIDE-A-PACK®



GRIP TITE™



BIG RED™ SILICONE

SUPERIOR FABRICS

Designed and woven specifically for our conveyor belting products.

SPECIAL TREATMENT FOR SYNTHETIC FABRICS

We apply a special adhesive treatment to most synthetic fabrics. This increases adhesion by 50%, so covers and plies resist separation far better than they would in an untreated belt. This improves service life and increases overall cost effectiveness. (Letter "T" in fabric name designates such treatment, as in APT35 or PNT50.)

POLYESTERS (AP, APT)

These polyester belts are the most dimensionally stable for wet service. Polyesters won't shrink, stretch, rot or mildew when exposed to moisture, which makes them especially effective where wetness is a problem. Strong and tough, these polyester belts will hold mechanical fasteners particularly well.

POLYESTER-NYLON (PN, PNT)

Polyester warp members running longitudinally give this fabric low elongation for minimum stretch. Resilient nylon filler members run transversely to hold fasteners tightly, especially where shock is involved. PN's perform well under frequent stop-and-go conditions or where products may jam.

SPECIAL COTTON-POLYESTER BLENDS (SCP)

A 50-50 blend, SCP's are 40-50% stronger than cotton belts and more dimensionally stable. They won't stretch or shrink in the presence of moisture like cotton or cotton-nylon belts and have little or no camber. These fabrics have more bulk than straight



polyesters for customers who prefer a heavier feel. SCP's can be used without a cover for a lower coefficient of friction.

POLYESTER-COTTON BLENDS (PCB)

A heavy-duty version of the SCP, better suited for heavier, textured surfaces; 50-50 blends of polyester and cotton run both longitudinally and transversely. PC's are stronger and tougher than cotton and cotton-nylon fabrics. They also hold fasteners better.

NYLOCK®

Designed exclusively by HBD/Thermoid, Nylock belting has a tough, interwoven single-ply polyester body, 20% lighter in relation to its strength than equally-rated fabrics. Polyester tension filaments are interlocked with 100% staple polyester fillers, then these are fully protected with 100% staple polyester face and back warps. Nylock belting has excellent resistance to impact, 6½ times more resistance to tear than belting with ordinary fabrics. It works well in the most demanding applications.

SUPERIOR COVERS

Compounded specially by the rubber and chemical experts at HBD/Thermoid.

PVC NYLOCK®

This is a proprietary premium PVC belting product. This belting has excellent resistance to chemicals and acids. It cleans easily, doesn't stain as readily as most other types. It's available in highly oil resistant tan and white, and is USDA-approved for carrying meat and poultry. It also meets all FDA requirements for food processing.



NITRILE RUBBER

Nitrile rubber belting is our most popular belting for food handling. Nitrile rubber has excellent oil resistance and withstands grease, fats and acids. It's USDA-approved for carrying meat and poultry, plus it meets all the requirements of the FDA. Nitrile rubber belting is available in white, tan, reddish brown and black (non FDA and USDA).

CARBOXYLATED NITRILE

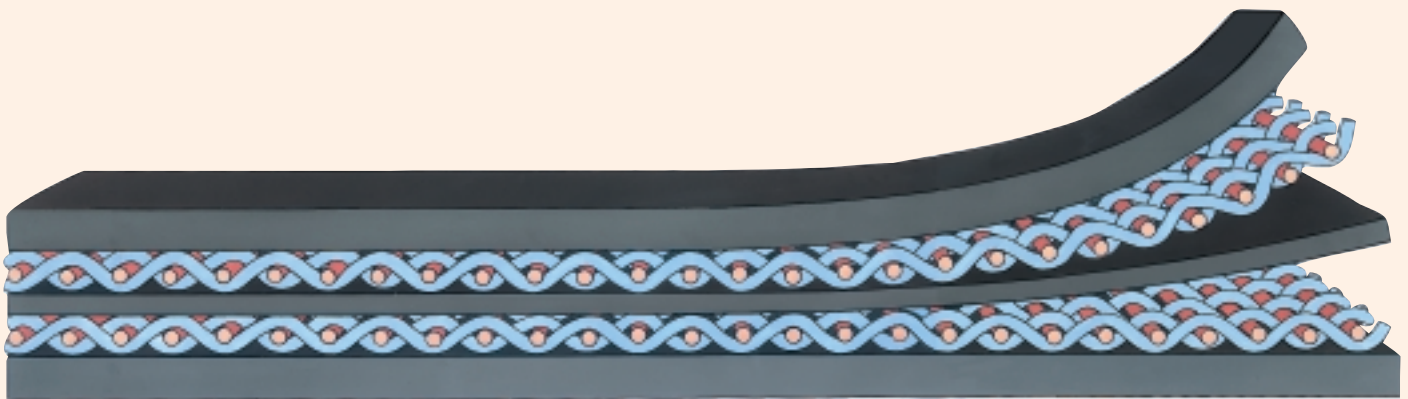
An abrasion resistant rubber that is used in our blue and orange Griptop® belts. This compound also offers good oil and chemical resistance.

RUBBER

HBD/Thermoid is one of the nation's most experienced rubber compounders. Rubber covers are especially useful for carrying frozen goods or in low-temperature environments. Our rubber covers meet FDA requirements and are available in white and tan.

BUTYL

This all-temperature belt compound is suitable for temperatures as high as 300°F and as low as -65°F. It is particularly suitable for food processing lines involving both cooking and freezing operations. Available in white.



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BELTING SELECTION GUIDE

A quick easy-to-read reference for matching our lightweight conveyor belts to your particular applications.

FOOD HANDLING

MEATS & POULTRY (USDA, FDA)

Saniwhite® & Sani-Brite™ nitrile rubber
(all fabrics)

Korowhite™ (125, SMC x F covers
& CHV x F)

Hot 'n Cold™ butyl (Polyester fabrics)

PVC (Polyester fabrics)

Ridgetop™ Nitrile

HOT, OILY FOODS (FDA)

Saniwhite® & Sani-Brite™ nitrile rubber
(all fabrics)

Butyl (Hot 'n Cold™)

Teflon



FRUIT & VEGETABLE PROCESSING (FDA)

Saniwhite® & Sani-Brite™ nitrile rubber
(all fabrics)

Rubber, if oil-resistance not required
(all fabrics)

Korowhite™ 125, 150

NUT PROCESSING (FDA)

Nitrile rubber (all fabrics)

PVC (Polyester fabrics)

AGRICULTURE

INCLINE SERVICE (FDA)

Griptop® for 35 degree inclines
(PCB, SCP, PNT fabrics. Tan rubber and reddish-brown nitrile)

Korowhite™ Chevron™ (USDA & FDA)

Korowhite™ Cleated Incline (USDA & FDA)

Ridgetop™ (USDA & FDA)

Korowhite™ Herringbone (USDA & FDA)
for up to 30 degree inclines

Korowhite™ Griptite

POTATO HARVESTING & UTILITY SERVICE

Potato (2-ply synthetic fabrics)

PVC Nylock®

HARVESTING EQUIPMENT

Potato

PVC Nylock® Chevron™

PVC Nylock® Cleated Incline

PVC Herringbone for 30 degree inclines
(USDA & FDA)



FROZEN FOODS (SUB-ZERO TEMPERATURES)

Butyl (Hot 'n Cold™)

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TUBE CONVEYOR AND BUNK FEEDER SYSTEMS

PVC Herringbone for 30 degree inclines
(USDA & FDA)

PVC Nylock® Chevron™

PVC Nylock® Cleated Incline

PVC Nylock® low-temp

Cotton processing equipment

Gin flashing material

PACKAGE HANDLING

BELTS FOR INCLINES⁽¹⁾

Griptop® — 35 degree inclines

Gripper™ — Light impression for up to
20 degree inclines

PVC Chevron™ and Cleated Incline —
Molded pattern helps move loose material
on moderate inclines to 35 degrees
depending on product

PVC Nylock® for up to 18 degree inclines
at normal temperatures; up to 15 degree
inclines at low temperatures

PVC Herringbone for up to 30 degree inclines

Griptite™ for up to 20 degree inclines



BELTS FOR STEEP INCLINES OF 45 DEGREES

Diamond Incline

V-Cleat

Ribflex

BELTS FOR HORIZONTAL SERVICE

Caripack®

Slide-A-Pack®

Sliptop®

Sheeting Belt

Hot Stock & Water



LIGHT INDUSTRIAL & AUTOMATION

BELTS WHEN OIL IS PRESENT

Saniwhite® & Sani-Brite™ nitrile rubber
(Polyester, PNT, SCP)

Griptop® (Nitrile & Carboxylated Nitrile) —
for 35 degree inclines

Sliptop®

Teflon

BELTS FOR OIL-FREE SERVICE

PVC Nylock® & Korowwhite™

Hot Stock & Water

Caripack®

Slide-A-Pack®

Potato (Utility)

SPECIAL APPLICATION BELTS

Big Red™ — Hot or Cold Tacky Material

Plywood processing — Tray

Lumber service — Lumber

Rubber processing — Hot Stock & Water

Cotton gins — Flashing material



(1) Smooth surface belts are generally satisfactory for

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FOOD HANDLING

From fruit to nuts to frozen fish. We can serve up a belt that's correct with any type of food you're processing.

Some foods are oily, greasy or wet. Some are carried frozen, some steaming hot. Many leave juices, acids or particles that can stain or contaminate. Some foods grind at a belt cover and wear it away.

Because different foods behave so differently, HBD/Thermoid offers a wide selection of lightweight carcasses and specially-compounded covers designed to deal with a variety of conditions. All meet the very latest FDA and USDA requirements for food, drugs and cosmetics, with the exception of black nitrile.



SANIWHITE® AND SANI-BRITE™ NITRILE RUBBER BELTS

Our most popular belting for general food handling.

Saniwhite® and Sani-Brite™ nitrile rubber belts are a truly all-around belting with



rubber belts stand up to temperatures from 20°F to 212°F. Their smooth cover finishes resist abrasion, chipping and pitting, and help make cleaning easy and fast.

Saniwhite and Sani-Brite nitrile rubber belts come with special white covers developed to lower eye strain on inspection lines. Customer can choose fabrics from polyesters, SCPs and PNs, plus ply and cover constructions for light or medium duty.

WHITE TEFLON BELT

For easy product release.

Our Teflon covered food belt will convey food and confectionary products during processing and prevent them from sticking to the belt. The easy release of hot or sticky materials from the belt makes it ideal for many light industrial applications as well.

KOROWHITE™ BELTS

The most effective combination of high strength and maximum resistance for your most demanding applications.

A tough, single-ply construction of interwoven polyester cords, fully protected by 100% staple polyester face and back warps. Korowhite belting is at least 20% lighter than equally-rated belts, yet it has greater impact resistance and up to 6½ times more tear resistance than ordinary belting. It has very low stretch and won't camber in service or in storage. Totally saturated with a white, premium PVC compound, it is oil resistant and has excellent resistance to moisture, chemicals and food acids. It's also stain resistant...the bright white, smooth cover cleans up easily.

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HOT'N COLD™ BELT

All-temperature belt for extreme hot and cold conditions.

White butyl belt is designed for hot service applications up to 300°F and freezing cold ones down to -65°F. Its 3-ply APT 35 polyester body has excellent fastener-holding power and resists effects of heat, cold and moisture.

Hot'N Cold is ideal for food processing plants, dairies or bakeries where extreme temperature conditions exist.

GRIPPER™ BELT

The economical belt for inclines up to 20°.

Gripper is an advanced HBD/Thermoid belt design manufactured in fabric impression. Its lightly-textured impression surface is excellent for carrying products or packaged goods up inclines up to 20°. It's normally constructed with white nitrile rubber with 2 or 3 plies of APT 35 fabric, and is also available in other carcass constructions.



CHEVRON™, CLEATED INCLINE, HERRINGBONE, PVC, AND RUBBER GRIPTOP® BELTS

For inclines of 30° and 35°.

Chevron has a molded chevron pattern in the PVC cover for handling inclines up to 30°, depending upon products carried. The chevrons help resist food material trapping and carrying back. They also drain off juices or liquids very easily. These belts conform well to either flat or troughed conveyors.

PVC Cleated Incline belt's bucket-shaped pattern provides a firmer grip, moving bulk or packaged materials up inclines as great as 35°, depending upon product carried. Flexing provides self-cleaning action and helps prevent carry-back.

Available in white food grade and in black. Herringbone has a molded herringbone cleat pattern in its PVC cover for handling product up to 20 degree inclines.

Griptop belting has a deeply-textured surface with thousands of tiny fingers that can cope with angles up to 35°. While not available with a white cover, Griptop belting does meet FDA requirements in tan rubber or reddish-brown nitrile for added oil resistance.

RIDGETOP™ BELT

The incline belt for meat and food products.

Ridgetop belting has a molded cleat 1/8" high on 1" centers running across the width of the belt. The Ridgetop cleat design enables the belt to carry meat and food products up 20-30° inclines. The cleat design also prevents wet or moist products from sticking to the belt by allowing the product's surface to rest on the cleats. Any suction effect between the product and the



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AGRICULTURE

Custom orders for the OEM. Replacement belts for the farmer. Either way, we work with customers closely to keep America's crops on the move.

HBD/Thermoid offers dependable, cost-saving lightweight belts for farm implements, harvesting equipment, and storage and retrieval systems.



designers to draft precise material and dimensional specs. Our sales staff will coordinate and follow through to be sure you get exactly what you order...on time and on budget.

In addition, your HBD/Thermoid Industrial Distributor is within easy reach, providing not only the lightweight belting you need, but important services like slitting, cleating, splicing and repair.

Your distributor usually carries a complete stock of the types of belting used around the farm. But if you have a special request, he'll be happy to order it for you.

NYLOCK® AND KOROWHITE™ BELTS

Great strength with moderate oil and excellent chemical resistance, for those tough applications that demand both.

Strong enough to measure up to harvesting equipment and other heavy-duty implements. Resistant enough for fertilizers, feed and any oily crops you may be handling. Both belts have a unique carcass...a special weave of polyester cords that provides greater strength for its weight, plus added resistance to impact and up to 6½ times the tear resistance of ordinary belting.

The PVC top and bottom covers provide superior resistance to chemicals, food acids and moisture. What's more, both belts are economical because they're reasonably priced and give long service life. Nylock comes with black covers; Korowhite with an easy-to-clean white cover. Either can have a molded chevron or cleated pattern added during manufacture for carrying up



OEM's can order through our Oneida location. We offer a broad range of fabrics, covers and special cover surfaces to meet nearly all field equipment and systems needs. We also offer products to meet USDA and FDA requirements.

If you need a specially-designed, made-to-order belt, our technical staff at Oneida is well equipped to handle your requirements

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CHEVRON™, HERRINGBONE AND CLEATED INCLINE BELTS

For bulk material and tube conveyor systems.

The molded chevron, herringbone or the bucket shaped pattern in the PVC cover helps move bulk materials like grain, feed and fertilizer efficiently up inclines as steep as 35°. The impressions resist the trapping or carry-back of material and readily drain off liquids. What's more, they're easy to clean. The covers have added abrasion resistance for longer service life with coarse materials. These belts are made with a thin, tough woven polyester carcass that can travel flat over head and tail pulleys, yet conform well to deep troughs and tubes to prevent the load from dusting and spilling.



POTATO BELTS

The economical belting made especially for potato harvesting.

Excellent for the harvesting, processing and storage conveyors that handle potatoes. Potato belts have two plies of synthetic fabrics with black, abrasion-resistant top and bottom covers. For slider beds, they're available with a rubber top cover and a treated duck bottom to reduce the drag over the slider bed surfaces. The perfect low-cost solution to this specialty application.

GIN FLASHING MATERIAL

The highest quality and most durable product available for gin flashing.

The body of this material is three strong plies of cotton fabric protected by a heat resistant cover compound. The all cotton fabric makes the material rigid enough for good seals and provides excellent bolt holding strength.

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PACKAGE HANDLING

We have a belt that can help you get a better grip on your business.

In every situation, it's important to weigh original cost against expected service life to determine which belt will be the most cost-effective. For these reasons, HBD/Thermoid gives you an ample range of fabrics, weights and textures.



Surface friction requirements and economics are the biggest factors in belt selection for package handling.

For sharp inclines and declines, specially-designed gripping surfaces are a must to keep loads from slipping. Even flat applications put specific demands on

a belt, depending on the amount of on-and-off loading and the nature of material handled.

PACKAGE HANDLING BELTS

Caripack®, Slide-A-Pack®, Sheeting and Sliptop® Belts.

These belts have good all-around properties for horizontal handling. The rubber friction surface helps keep even slippery packages moving along at belt speed. The black Caripack and tan Slide-A-Pack are good general purpose rubber belts for slider bed and live roller conveyors where there is no oil present. The reddish-brown nitrile sheeting belt is a good belt for those applications where oil is present. The Sliptop belt is manufactured with a treated nylon top ply to provide for easy package release or transfer from the belt. The tan nitrile compound gives the Sliptop belt excellent oil resistance as well.

SPECIALTY PACKAGE HANDLING PRODUCTS

Pack-EZ S/Weave belts are approved and preferred by all major, package handling companies. Especially

our rugged PVC, low stretch belts have a single ply carcass of special S/Weave interwoven polyester fabric. Built tough, these belts are designed to resist stretching and fire. Pack-EZ special S/Weave fabric comes in various operating tension ratings, including 120#, 150# and 200#.

HBD/Thermoid®, Inc. manufactures a wide variety of package handling belts. These belts are product engineered to meet your service requirements. Our Pack-EZ Prem PH belts are another very popular package handling product group. Constructed of rubber/monofilament fabrics, Pack-EZ Prem PH belts deliver solid performance while standing up to the rough, everyday demands required in package handling. These belts resist fire and stretching. The Pack-EZ Prem PH series is available in a wide range of product types to meet the many unique applications required in package handling. Choose from these options: 2 Ply 90#, 2 Ply 160#, 3 Ply 1354# and/or 3 Ply 200# with Bare X Bare or Light Impression X Bare.

GRIPTOP® INCLINE BELTS

The deep textured surface with raised rubber peaks grips each package and carries it up inclines as steep as 35°. Griptop belts are our most popular line of incline belts. They are available in black or non-marking tan rubber for general service and reddish-brown nitrile for applications where oil is present. Pure gum rubber works best where abrasion, tearing or gouging are problems with the general service Griptop belts. For the most severe abrasion applications choose blue or orange Griptop carboxylated nitrile belts.

STEEP INCLINE BELTS

Our full line of molded impression top, steep incline belts are ideal for carrying packages, cases, cartons, luggage and many products up inclines as steep as 45 degrees. The steep incline belts are available in the following three cover impressions: V-Cleat, Diamond Incline and Ribflex®. These belts are available in general service black rubber compounds, and some are stocked in non-marking tan or pure gum compounds. Our V-Cleat belt is also available in an oil resistant red/brown nitrile construction.

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LIGHT INDUSTRIAL USES

Where productivity adds up to profit, our belts can help you step up the pace.

More and more manufacturers of automated equipment are looking to conveyor belts as an integrated part of their systems and products. Today's belts must often resist attack by industrial oils, grease and chemicals. They often need to operate effectively in low or high temperatures. The covers must be built tough enough to stand up to persistent impact and abrasion from all sizes and shapes of small parts. HBD/Thermoid belts serve all of these needs.

On assembly lines, our belts can move things from station-to-station as fast or slow as the schedule demands. Soft but contrasting colors go easy on the eyes while improving the level of quality control at inspection stations. The belts can be slit narrow enough to carry a single part at a time cost-effectively, or we can make them wide enough to move whole masses of parts at a steady rate.

To satisfy a variety of industry's needs, we offer general purpose and specialty belts with plenty of options.



"BIG RED™" SILICONE COVERED HOT STOCK & WATER BELT

"BIG RED" silicone covered Hot Stock & Water is designed for conveying hot or cold tacky material such as rubber or plastic stock in various stages of manufacturing. This special silicone treatment allows the cover of the belt to withstand material in

excellent release characteristics. The silicone covered top ply enables materials to be conveyed on gradual inclines without slipping back and yet, releasing from the cover at the end. BIG RED has a proven track record of performing exceptionally well in difficult applications such as conveying tire and hose stock, and plastics and vinyl materials.

NITRILE RUBBER BELTS

For general utility.

Nitrile rubber belting offers a good combination of properties for a wide range of industrial uses. The cover offers superior resistance to oils, grease, alkalis, acids and moisture. It can withstand high surface temperatures up to 212°F. In the off-white color, it's well-suited for inspection lines and cleans up very easily. Also available in tan, green, black and reddish-brown. Carcass constructions can be chosen for light or medium duty from the polyesters, SCPs and PNs.

GRIPTOP® CARBOXYLATED NITRILE BELTS

For those applications where excellent abrasion, oil and chemical resistance is required. These belts are commonly used in the processing of paper and cardboard products, and some wood processing applications. The bright blue and orange colored impression covers allow for easy identification when color coding belts for certain applications in a plant.

HOT STOCK & WATER BELTS

Conveys the hot rubber stock while it's cooled with water in the various stages of rubber processing. The bare cotton, silver hard-duck top ply prevents the hot rubber stock from sticking to the belt. This belt is also ideal for other general service horizontal conveyors



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CONVEYOR BELTING AND DATA SPECIFICATION SHEET

Customer
 Location

Date
 *Conveyor

DATA AND SPECIFICATIONS

*Belt Width (inches)

*Length (ft.)...one of three required:
 Belt Length
 Conveyor Centers
 Horizontal Centers

Elevation
 Lift (ft.) or Drop (ft.)
 Slope (Degrees)

*Belt Speed (ft./min.)

Capacity (tons/hr.):
 Average
 Maximum

Pulley Diameters (inches):
 Head
 Drive Snub
 Tail
 Take-up
 Other

Belt Splice...Vulc (V) or Mech (M)

Drive Details:
 Type...Single (S), Tandem (T), Dual (D)
 **Motor Horsepower
 Pulley Surface...Bare (B) or Lagged (L)
 Belt Wrap (Degrees)
 Location from Head (ft.)

Material Info:
 Type
 Weight (PCF)
 Maximum Lump Size (inches)
 Temperature (Degrees F.)
 Oil...None (N), Some (S), Much (M)
 Drop to Belt (ft.)

Idlers:
 Degree Trough
 Roll Diameter (inches)
 Trough Spacing (ft.)

Take-up:
 Type...Auto (A) or Manual (M)
 Movement (ft.)
 Location from Head (ft.)

CALCULATIONS

Maximum Operating Tension (lbs.) _____ Load Support, Q (lb./ft.) _____
 Unit Operating Tension (PIW) _____ Wrap Factor, K _____
 Horsepower Required _____

COMMENTS

Previous Belt Spec...
 Previous Belt Failure...
 Other...

BELT RECOMMENDATIONS

BELT SPLICING

Either vulcanized splices or mechanical fasteners are recommended for HBD/Thermoid conveyor belts. The fastening method you select depends on the particular requirements of the conveyor system. Here are some reasons for and against each method—



VULCANIZED SPLICES

1. The belt surface is smooth, an important consideration in many applications where other equipment operates in conjunction with the belt.
2. If fine material is being handled, a vulcanized splice is necessary to prevent leakage at the joint.
3. Vulcanized splices allow the full rated working tension of the belt to be utilized.



AIR CURING CHEMICAL SPLICES

Chemical systems of splicing provide an

the need for a vulcanizer and can be made in areas that are not accessible with a vulcanizer.

One company offering cold splice materials and instructions is: REMA-TIP-TOP North America, 200 Paris Ave., Northvale, NJ. Phone: 201/768-8100.

MECHANICAL FASTENERS

1. Require the least amount of time for splicing.
2. The splice can be taken apart and rejoined if pin style fasteners are used. This should be considered if there is any possibility the belt or the system will be lengthened or shortened.



WIDTH TOLERANCES

Cut Edge Belts	Plus or Minus
Up to 24" inc.	1/8"
Over 24" to 36" incl.	3/16"
Over 36"	1/2 of 1%

THICKNESS TOLERANCES

Finished Belts	Plus or Minus
Overall Gauge	
Up to .094 (3/32)	.016
.095 to .156 (5/32)	.020
.157 to .344 (1 1/32)	.031
.345 to .500 (1 1/2)	.047

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TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
1. Fastener fails	Improper fastener or technique	Check with fastener manufacturer comparing tension, overall belt gauge, pulley size. Recalculate tension requirement.
2. Belt stretching	Underbelted	Recalculate tension requirement. Double-check peak loads.
3. Belt shrinking	Water absorption	Cotton belting shrinks when water-saturated.
	Heat memory of synthetic fabrics	All synthetic belting tends to show this characteristic. Check maximum temperature especially in cleaning and periodically adjust take-up.
4. Belt not training properly	Mechanical malfunction	Improper alignment of pulleys or conveyor frame.
	Crooked splice	Resplice. If mechanical splice, be sure ends are cut square.
	Off-center loading	Adjust loading conditions to permit center load.
5. Edge fraying and wearing	Material build-up	Redesign or adjust loading, scraper, plows and/or cleaning mechanisms.
6. Belt becoming too narrow	Underbelted	Recalculate tension requirement.
	Fabric instability	Consider improved fabric.
7. Belt slipping	Insufficient slack-side tension	Adjust take-up toward maximum stop and/or shorten belt.
8. Belt cracking across top of belt	Underbelted	Recalculate tension.
	Pulleys too small	Recalculate tension and check minimum pulley requirements.
	Ozone cracking	Check compound resistance.
	Heat; extreme cold	Check compound resistance and system design.
9. Belt cracking across bottom of belt	Underbelted	Recalculate tension.
	Slipping on drive pulley	Adjust take-up to maximum stop.
	Undersized pulley(s)	Check all pulley sizes – especially snub or reverse bend pulleys.
10. Belt fasteners pull out	Fasteners too large	Follow fastener manufacturer's recommendations based on belt thickness.
	Undersized pulleys	Use larger pulleys or thinner belts with strong synthetic fabrics.
	Belt too tight	Check tension. Consider vulcanized splice.
11. Excessive top cover wear	Skirt board/plow contact or material buildup	Adjust or redesign.
	Frozen return idlers or material buildup on return side	Replace or free idlers or check cleaning devices or procedures.
	Improper compound	Check with supplier.

PROBLEM	CAUSE	SOLUTION
12. Excessive bottom cover wear	Material buildup on idlers or pulleys	Check cleaning devices.
	Belt slipping on drive pulley	Increase tension adjustment.
	Frozen idlers or pulley	Replace.
	Rough or worn slider bed or material buildup on bed	Replace or clean. Check procedures.
13. Belting deteriorating in storage	Mildew and rot	Store in cool, dry, dark area, preferably on racks supported by rod through belt core.
	Compound and fabric	Change cotton and rayon fabric belts to polyester.
14. Belt running in jerks or stalls	Suction created by flat belting on slider bed in presence of moisture	Interrupt surface of bed by welding or adhering ¼ to ½ round rods.
15. Belt cover discoloration	Water impurity deposits	Improve or change water treatment procedure.
	Food stains	Change color to minimize. Check with manufacturer.
	Inadequate cleaning procedures	Daily cleaning with mild detergent and hot water usually sufficient. If additional cleaning is required mix a weak concentration of an oxidizing agent (Chlorox) with water and scrub belt. Rinse belt immediately after application.
16. Objectional taste or color	Inadequate cleaning	See #15.
	Particular customer standard	Check with manufacturer. FDA and MIS are concerned with toxicity. Taste and odor are subjective factors and standards are difficult to establish.
17. Cover becoming soft and tacky	Improper compound for service	Check with supplier.
18. Load slipping or sticking	Cover compound or type or surface not compatible with service	Check with supplier.

GENERAL RESISTANCE QUALITIES

Belt Specification	Resistance To				
	Acid	Alkali	Animal Oil	Vegetable Oil	Mineral Oil
Butyl	E	E	G	F	P
Nitrile	G	G	E	E	E
Natural – SBR	G	G	P	P	P
Korowhite™– Interwoven Single Ply	G	G	G	G	G

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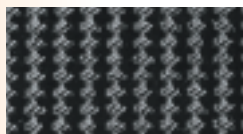
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PVC BELTING DATA



PVC Nylock® (COS x SB)



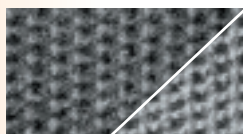
Griptop®



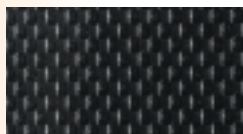
Chevron™



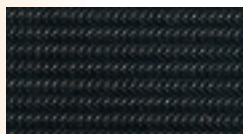
Cleated Incline



Package Handling



Griptite™



Pack-EZ PVC



Korowhite™



Chevron™



PVC Herringbone

Product	Color	PIW Tension Rating	Temperature Range °F	Nominal Thickness (Inches)			Min. Pulley Diameter
				CBS	COS x SB	SB x SB	
PVC Nylock							
Industrial Weight Belts							
KN 120	Black	120	0 to +180	5/32	9/64	1/8	3"
KN 150	Black	150	0 to +180	13/64	11/64	5/32	6"
KN 200	Black	200	0 to +180	16/64	7/32	7/32	8"
KN 120 Low Temp.	Black	120	-30 to +180	5/32	9/64		3"
Incline Belts							
KN 120 Griptop x SB	Black	120	0 to +180		17/64		3"
KN 150 Griptop x SB	Black	150	0 to +180		9/32		3"
KN 120 Chevron x SB	Black	120	0 to +180		7/32		3"
KN 120 Cleated Incline x SB	Black	120	0 to +180		1/4		3"
KN 120 Herringbone x SB	Black	120	0 to +180		1/4		3"
Package Handling Belts							
KN 120 SB x SB	Black	120	0 to +180		5/32	9/64	3"
KN 150 SB x SB	Black	150	0 to +180		3/16	11/64	6"
KN 120 Griptite x SB	Black	120	0 to +180		9/64		3"
Pack-EZ PVC S/Weave	Black	150	0 to +180			11/64	6"
Pack-EZ PVC S/Weave	Black	200	0 to +180			7/32	10"
Korowhite Belts							
KW 125 SMC x F	White	125	0 to +180		9/64		3"
Korowhite Incline Belts							
KW 125 Chevron x F	White	125	0 to +180		7/32		3"
KW 125 Cleated Incline x F	White	125	0 to +180		1/4		3"
KW 120 Herringbone x F	White	125	0 to +180		1/4		3"
KW 125 Griptite x F	White	125	0 to +180		9/64		3"

AS = Alligator Staple COS = Coat One Side
 AL = Alligator Lacing F = Friction Surface
 C = Clipper SB = Slider Bed
 CBS = Coat Both Sides SMC = Smooth Cover






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Approx. Wt. Per Sq. Ft. (Lbs.)			Meets FDA	Meets USDA	Suggested Mechanical Fasteners								
CBS	COS x SB	SB x SB			CBS			COS x SB			SB x SB		
					AS	AL	C	AS	AL	C	AS	AL	C
1.0	.9	.70	No	No	125	20	1	125	20	1, 2 SP	125	20	1
1.3	1.1	.80	No	No	187	25	3	187	25	3	187	25	1, 2 SP
1.7	1.4	1.00	No	No	187	27	4	187	27	4	187	27	3, 4
1.0	.9	.70	No	No				125	20	1, 2 SP			
	1.2		No	No				125	20	1, 2 SP			
	1.3		No	No				310	35	4			
	1.1		No	No				125	20	2 SP			
	1.1		No	No				125	20	1, 2 SP			
								125	20	1, 2 SP			
	.9	.70	No	No							125	20	1
	1.1	.80	No	No							187	25	1, 2
	.9		No	No				125	15	1A			
		1.02	No	No							187	25	1, 2
		1.17	No	No									4
	1.0		Yes	Yes				125	20	1, 2 SP			
	.9		Yes	Yes				125	20	2 SP			
	1.0		Yes	Yes				125	20	1, 2 SP			
			Yes	Yes				125	20	1, 2 SP			
	1.0		Applied For	Applied For				125	20	1, 2 SP			

RUBBER BELTING DATA

	Product	Color ⁽¹⁾	Standard Cover Gauge	Fabric	Standard Skim Coats	Nominal Overall Thickness	Approx. Wt. per Sq. Ft. (Lbs.)	
Food Handling	 SaniWhite® & Sani-Brite™ Nitrile White	2 Ply APT35 Nitrile	W, T, B	3/64 x FS	Treated Polyester	.060"	9/64"	1.010
		2 Ply APT35 Nitrile	W, T, B	3/64 x FS	Treated Polyester	.010"	3/32"	.684
		3 Ply APT35 Nitrile	W, T, B	3/64 x FS	Treated Polyester	.020"	9/64"	.949
		3 Ply APT35 Nitrile	W, T, B	3/64 x FS	Treated Polyester	.010"	1/8"	.882
		2 Ply PNT50 Nitrile	W, T, B	3/64 x FS	Treated Polyester/Nylon	.010"	7/64"	.738
		3 Ply PNT50 Nitrile	W, T, B	3/64 x FS	Treated Polyester/Nylon	.010"	5/32"	.980
		3 Ply SCP23 Nitrile	W, T, B	3/64 x FS	Cotton/Polyester	.010"	3/32"	.670
		2 Ply SCP23 Nitrile	W, T, B	3/64 x FS	Cotton/Polyester	.010"	7/64"	.755
		3 Ply SCP23 Nitrile	W, T, B	3/64 x FS	Cotton/Polyester	.010"	9/64"	.913
		4 Ply SCP23 Nitrile	W, T, B	3/64 x FS	Cotton/Polyester	.010"	11/64"	
	 Hot 'N Cold™-Butyl	3 Ply APT35 Butyl	W	1/32 x FS	Treated Polyester	.010"	7/64"	.750
	 Teflon White	2 Ply APT35 Teflon	W	.002 TEF x FS	Treated Polyester	.010"	1/16"	.372
		3 Ply APT35 Teflon	W	.002 TEF x FS	Treated Polyester	.010"	3/32"	.579
Food Handling (Incline Service)	 Gripper™-Fabric	3 Ply APT35 Nitrile	W	3/64 x FS	Treated Polyester	.010"	1/8"	.880
	 Ridgetop™	3 Ply PNT50 Nitrile	W	3/64 x FS	Treated Polyester/Nylon	.010"	9/64"	1.290

⁽¹⁾Color Code: B-Black, T-Tan, W-White

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Meets FDA Requirements	USDA Approval	Resistance to Oils	Temperature Range (°F)		Working Tension (Lbs./Inch/Ply)		Minimum Pulley Diameter	Suggested Mechanical Fastener ⁽²⁾		
			Min.	Max.	Vulc.	Mech.		Staple	Alligator Lacing	Clipper
W	W	Excellent	20	212	35	25	2"	62	7	1, 2 SP
W	W	Excellent	20	212	35	25	2"	62	7	1 A
W	W	Excellent	20	212	35	25	3"	125	7	1, 2 SP
W	W	Excellent	20	212	35	25	3"	125	7	1, 2 SP
W	W	Excellent	20	212	45	35	3"	125	7	1, 2 SP
W	W	Excellent	20	212	45	35	4"	125	25	2
W	W	Excellent	20	212	23	23	3"	62	7	1 A
W	W	Excellent	20	212	23	23	2"	62	7	1 A
W	W	Excellent	20	212	23	23	3"	125	7	1, 2 SP
W	W	Excellent	20	212	23	23	4"	125	15	
Yes	Yes	Fair	-65	300	35	25	2" (4" below 0°F)	62	7	1 A
Yes	Yes	Excellent	-65	300	35	25	2"	62	1	25, 25 LP
Yes	Yes	Excellent	-65	300	35	25	3"	62	7	1 A
Yes	No	Excellent	20	212	35	25	3"	125	7	1, 2 SP
Yes	Yes	Excellent	20	212	45	35	4"	125	25	2

⁽²⁾ Follow manufacturers' recommendations for size, depending on belt thickness and pulley diameter.

RUBBER BELTING DATA (Continued)

	Product	Color ⁽¹⁾	Standard Cover Gauge	Fabric	Standard Skim Coats	Nominal Overall Thickness	Approx. Wt. per Sq. Ft. (Lbs.)
 Sliptop™	3 Ply PN 50 Nitrile	T	Nylon TD x FS	Treated Polyester/Nylon	.010"	1/8"	.62
	4 Ply SCP23 Nitrile	T	Nylon TD x FS	Cotton/Polyester	.010"	1/8"	.74
 Sheeting	3 Ply SCP14 Nitrile	R/B	FS x FS	Cotton/Polyester	.008"	1/16"	.40
	5 Ply SCP14 Nitrile	R/B	FS x FS	Cotton/Polyester	.008"	7/64"	.71
	7 Ply SCP14 Nitrile	R/B	FS x FS	Cotton/Polyester	.008"	9/64"	1.00
 Slide-A-Pack®	3 Ply PCB35 Rubber	T	FS x FS	Cotton/Polyester	.008"	9/64"	.68
	4 Ply PCB35 Rubber	T	FS x FS	Cotton/Polyester	.008"	3/16"	.92
 Caripack®	3 Ply PCB35 Rubber	B	FS x FS	Cotton/Polyester	None	1/8"	.60
	4 Ply PCB35 Rubber	B	FS x FS	Cotton/Polyester	None	5/32"	.90
 Package Handling Rubber/Mono	Pack-EZ Prem-PH2-90▲	B	B x B	Polyester/Monofilament	.050"	7/64"	.49
	Pack-EZ Prem-PH2-160▲	B	B x B	Polyester/Monofilament	.050"	1/8"	.85
	Pack-EZ Prem-PH3-135▲	B	B x B	Polyester/Monofilament	.030"	1/8"	.81
	Pack-EZ Prem-PH3-200▲	B	B x B	Polyester/Monofilament	.040"	5/32"	.96
 Cleat-Rite "OSM"	2 Ply APT110	B	5/32 x 3/32	Polyester	.020"	NA	2.30
	3 Ply APT110	B	5/32 x 3/32	Polyester	.020"	NA	3.30

▲ All are available LI x B. Contact the Oneida Plant.

⁽¹⁾Color Code: B-Black, R-Red, T-Tan, W-White

Meets FDA Requirements	USDA Approval	Resistance to Oils	Temperature Range (°F)		Working Tension (Lbs./Inch/Ply)		Minimum Pulley Diameter	Suggested Mechanical Fastener ⁽²⁾		
			Min.	Max.	Vulc.	Mech.		Staple	Alligator Lacing	Clipper
No	No	Excellent	20	212	45	35	4"	125	7	1, 2 SP
No	No	Excellent	20	212	23	23	4"	125	7	1, 2 SP
No	No	Excellent	20	212	23	23	1 1/2"	62	1	25, 25 LP
No	No	Excellent	20	212	23	23	2 1/2"	62	7	1 A
No	No	Excellent	20	212	23	23	3 1/2"	125	7	1, 2 SP
Yes	No	Poor	-30	180	35	27	4"	125	15	1, 2 SP
Yes	No	Poor	-30	180	35	27	6"	125	25	2
No	No	Poor	-30	180	35	27	4"	125	15	1, 2 SP
No	No	Poor	-30	180	35	27	6"	125	25	1, 2
No	No	Poor	-20	180			2"	62		1 A
No	No	Poor	-20	180			4"	125		1
No	No	Poor	-20	180			4"	125		1
No	No	Poor	-20	180			6"	RS125S		3-1
No	No	Medium	-30	180			12"			
No	No	Medium	-30	180			14"			

⁽²⁾Follow manufacturers' recommendations for size, depending on belt thickness and pulley diameter.

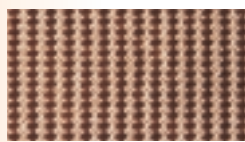
RUBBER BELTING DATA (Continued)

Package Handling (Incline Service up to 35°)



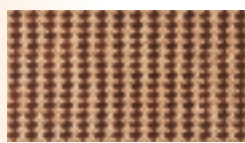
Griptop™-Nitrile

Product	Color ⁽¹⁾	Standard Cover Gauge	Fabric	Standard Skim Coats	Nominal Overall Thickness	Approx. Wt. per Sq. Ft. (Lbs.)
3 Ply PN 50 Nitrile	R/B	3/32 x FS	Treated Polyester/Nylon	.010"	5/16"	1.13



Griptop®-Pure Gum

3 Ply PCB35 Gum	A	3/32 x FS	Cotton/Polyester	None	21/64"	1.20
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Griptop®-Rubber

2 Ply APT75 Rubber	T, B	3/32 x TD	Treated Polyester	.030"	19/64"	1.20
3 Ply PCB35 Rubber	T, B	3/32 x FS	Cotton/Polyester	None	21/64"	1.10

Package Handling (Steep Incline Service up to 45°)



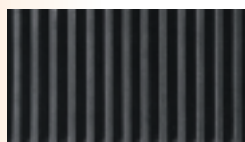
V-Cleat

3 Ply PCB35 Rubber	B	3/32 x FS	Cotton/Polyester	.010"	21/64"	1.26
3 Ply PNT50 Gum	A	3/32 x FS	Treated Polyester/Nylon	.010"	19/64"	1.07
3 Ply PNT50 Nitrile	R/B	3/32 x FS	Treated Polyester/Nylon	.010"	19/64"	1.14



Diamond Incline

2 Ply APT75 Rubber	B, T	3/32 x TD	Treated Polyester	.050"	9/32"	1.08
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Ribflex®

3 Ply PCB35 Rubber	B	9/64 x FS	Cotton/Polyester	None	9/32"	1.42
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⁽¹⁾ Color Code: A-Amber, B-Black, R/B-Reddish Brown, T-Tan, W-White

Meets FDA Requirements	USDA Approval	Resistance to Oils	Temperature Range (°F)		Working Tension (Lbs./Inch/Ply)		Minimum Pulley Diameter	Suggested Mechanical Fastener ⁽²⁾		
			Min.	Max.	Vulc.	Mech.		Staple	Alligator Lacing	Clipper
Yes	No	Good	20	212	45	35	3"	125	20	2
No	No	Poor	-30	180	35	27	4"	187	25	2
Tan	No	Poor	-30	180	75	75	4"	125	20	2
Tan	No	Poor	-30	180	35	27	4"	187	25	2
No	No	Poor	-30	180	35	27	4"	187	25	2
No	No	Poor	-30	180	45	35	4"	125	25	2
Yes	No	Excellent	20	212	45	35	4"	125	25	2
Tan	No	Poor	-30	180	60	60	4"	125	20	2
No	No	Poor	-30	180	35	27	4"	187	25	2

⁽²⁾Follow manufacturers' recommendations for size, depending on belt thickness and pulley diameter.

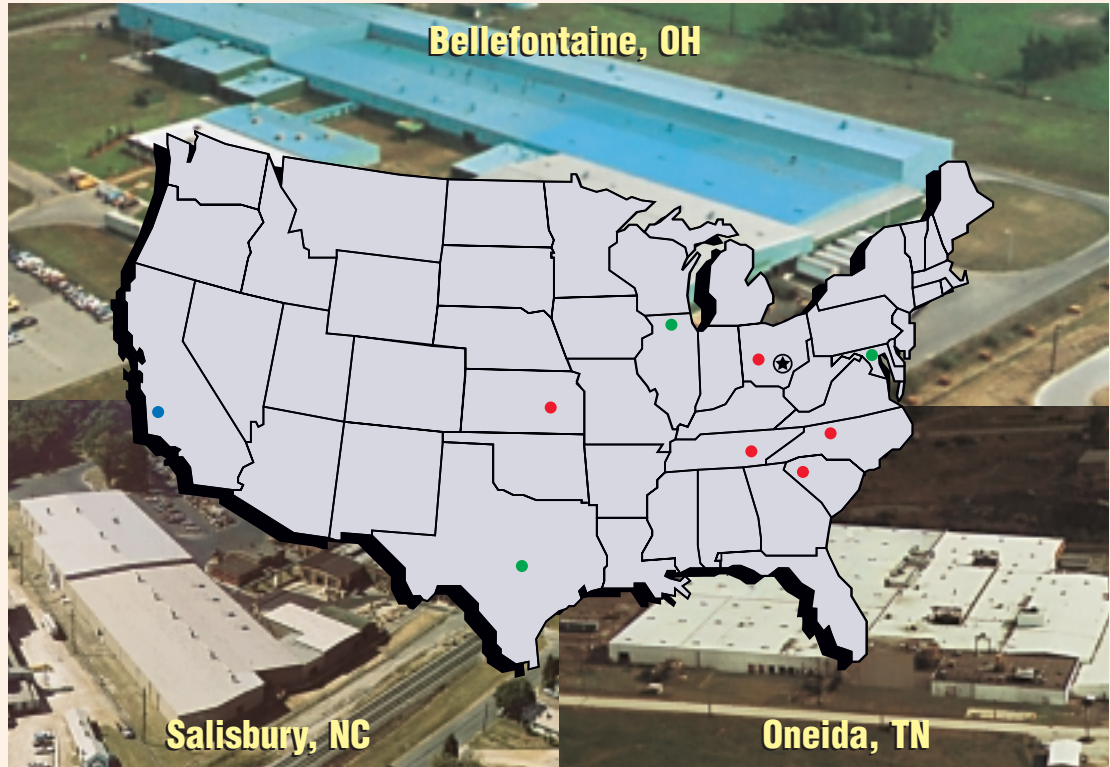
RUBBER BELTING DATA (Continued)

	Product	Color ⁽¹⁾	Standard Cover Gauge	Fabric	Standard Skim Coats	Nominal Overall Thickness	Approx. Wt. per Sq. Ft. (Lbs.)	
Agriculture	 Potato Belt 1/32 x 1/32	B	1/32 x 1/32	Treated Polyester	.040"	11/64"	1.10	
	 Potato Belt 1/32 x TD	B	1/32 x TD	Treated Polyester	.040"	9/64"	.81	
	 Gin Flashing	B	1/16 x 1/16	Cotton	.010"	5/16"	1.80	
Light Industrial	 Hot Stock & Water	B	Bare SHD x FS	Cotton/Polyester	.008"	9/64"	.71	
		B	Bare SHD x FS	Cotton/Polyester	.008"	3/16"	.96	
	 Nitrile-Black	2 Ply SCP23 Nitrile	B	3/64 x FS	Cotton/Polyester	.010"	7/64"	.69
		3 Ply SCP23 Nitrile	B	3/64 x FS	Cotton/Polyester	.010"	9/64"	.89
		4 Ply SCP23 Nitrile	B	3/64 x FS	Cotton/Polyester	.010"	11/64"	1.10
	 Griptop®-Blue, Carboxylated Nitrile	BL	3/32 x FS	Treated Polyester/Nylon	.030"	11/32"	1.38	
	 Griptop®-Orange, Carboxylated Nitrile	O	3/32 x FS	Treated Polyester/Nylon	.015"	5/16"	1.20	
	 Big Red™ Silicone Covered	3 Ply PCB35 Rubber	B (R-Cover)	Silicone Cover x FS	Cotton/Polyester	.008"	9/64"	.65
4 Ply PCB35 Rubber		B (R-Cover)	Silicone Cover x FS	Cotton/Polyester	.008"	3/16"	.91	

Meets FDA Requirements	USDA Approval	Resistance to Oils	Temperature Range (°F)		Working Tension (Lbs./Inch/Ply)		Minimum Pulley Diameter	Suggested Mechanical Fastener ⁽²⁾		
			Min.	Max.	Vulc.	Mech.		Staple	Alligator Lacing	Clipper
No	No	Poor	-30	180	75	75	4"	125	20	2
No	No	Poor	-30	180	75	75	4"	125	20	2
No	No	Poor	0	250						
No	No	Poor	-20	250	35	27	4"	125	15	2
No	No	Poor	-20	250	35	27	6"	187	25	3
No	No	Excellent	20	212	23	23	2"	62	7	1 A
No	No	Excellent	20	212	23	23	3"	125	7	1, 2 SP
No	No	Excellent	20	212	23	23	4"	125	15	
No	No	Excellent	20	212	45	35	4"	125	20	2
No	No	Excellent	20	212	45	35	4"	125	20	2
No	No	Poor	-20	250	35	27	4"	125	15	2
No	No	Poor	-20	250	35	27	6"	187	25	3

Industrial Rubber Products Delivered Where and When You Need Them

With nationally recognized distributors, strategically located product warehouse facilities and manufacturing plants, HBD/Thermoid® Inc. can deliver the products you require.



- HBD/Thermoid, Inc. Manufacturing Plants/Product Warehouses
- HBD/Thermoid, Inc. Product Warehouses – All Products
- HBD/Thermoid, Inc. Product Warehouses – Power Transmission Belts
- ⊙ HBD Industries, Inc. Headquarters

HBD/Thermoid®, Inc.

Our name is widely known and respected as a top-quality manufacturer of industrial rubber products, including air, automotive, aviation, bulk transfer, chemical, hand-built, marine, water, welding and multipurpose industrial hose. HBD/Thermoid, Inc. also produces a variety of other products such as industrial ducting, power transmission belts, conveyor belting, coated rubber fabrics, industrial rubber bands, rubber budding strips and rubber roll coverings. HBD/Thermoid, Inc. has always provided its customers with application engineered products that are technologically advanced in a personalized, customer friendly manner.

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All of the comprehensive and competitively priced products manufactured by HBD/Thermoid, Inc. are produced in environmentally safe manufacturing facilities that operate under the guidance of **ISO 9001 Quality Systems**. Our expert design and application engineering staff is available to assist and consult with customers, product design engineers and OEMs on new products or product systems. All **Thermoid** brand products are thoroughly tested and application engineered to ensure long-term performance and worker safety.

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Light Industrial/Automation



Allir/Multipurpose



Automotive



Marine



Chemical



Dock Loading



Food Industry



Material Handling



Petroleum



LP Gas



Special Applications



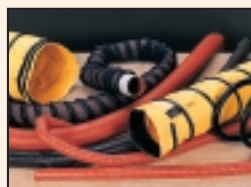
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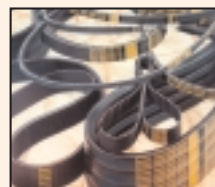
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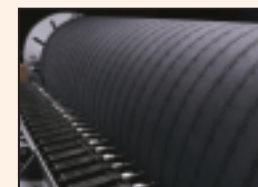
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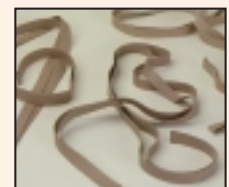
Ducting



Power Transmission Belts



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