

---

---

**Steel cord conveyor belts — Methods for  
the determination of total thickness and  
cover thickness**

*Courroies transporteuses à câbles d'acier — Méthodes de  
détermination de l'épaisseur totale et de l'épaisseur des revêtements*



Reference number  
ISO 7590:2009(E)

© ISO 2009

**PDF disclaimer**

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.



**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2009

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

## 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 2.

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

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

ISO 7590 was prepared by Technical Committee ISO/TC 41, *Pulleys and belts (including veebelts)*, Subcommittee SC 3, *Conveyor belts*.

This fifth edition cancels and replaces the fourth edition (ISO 7590:2001), which has been technically revised.



# Steel cord conveyor belts — Methods for the determination of total thickness and cover thickness

## 1 Scope

This International Standard specifies three methods for the measurement of total belt thickness and the thickness of covers of steel cord conveyor belts.

Methods A1 and A2 (micrometer methods) can be used for all steel cord conveyor belts for the measurement of both total belt thickness and cover thickness.

Method B (optical method) is recommended for the measurement of cover thickness only. It is not suitable if there is a textile or metal weft, nor if the ends of the steel cords become twisted when cut.

## 2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

### 2.1

#### **breaker**

reinforcement included in the cover

### 2.2

#### **weft**

transverse layer or layers included to reinforce the carcass of the belt and not regarded as part of the cover layer

## 3 Principle

The total thickness is measured using a micrometer at a number of specified points depending on belt width.

The cover thicknesses are measured either

- a) by removing the covers, taking further measurements at the same specified points and calculating each of the cover thicknesses by subtraction, or
- b) by direct measurement using an optical measuring instrument.

## 4 Apparatus

### 4.1 Dial gauge micrometer for methods A1 and A2

The instrument shall be graduated every 0,1 mm with flat feet and a circular foot of 10 mm in diameter that exerts a pressure of  $(22 \pm 5)$  kPa on the test specimen.

**4.2 Optical measuring instrument for method B**

The instrument shall comprises a hand-held magnifying glass with a scale divided in 0,1 mm steps. The magnification shall be at least 8 times.

**5 Procedure**

**5.1 General**

If the adhesion strength between cover and core layer is measured in accordance with ISO 8094, the same test pieces may be used for the determination of cover thickness described in method A1.

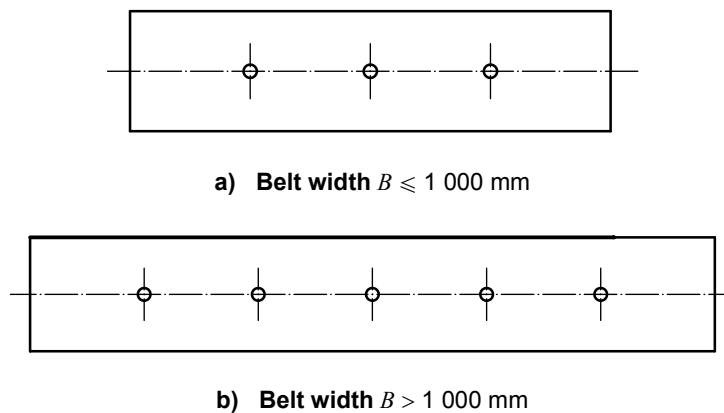
If the position of the steel cord is measured in accordance with EN 13827, the same test piece may be used for the determination of cover thickness described in method A2.

If the use of methods A1 and A2 is impractical, the visible belt end or the end of a laboratory sample of the belt may be used for the determination of cover thickness described in method B.

**5.2 Measurement points**

If the belt width,  $B$ , is less than or equal to 1 000 mm, measure the thickness at three points spaced equidistantly over the belt width [see Figure 1 a)].

If the belt width,  $B$ , is greater than 1 000 mm, measure the thickness at five points spaced equidistantly over the belt width [see Figure 1 b)].



**Figure 1 — Location of measurement points**

**5.3 Test pieces and test specimens**

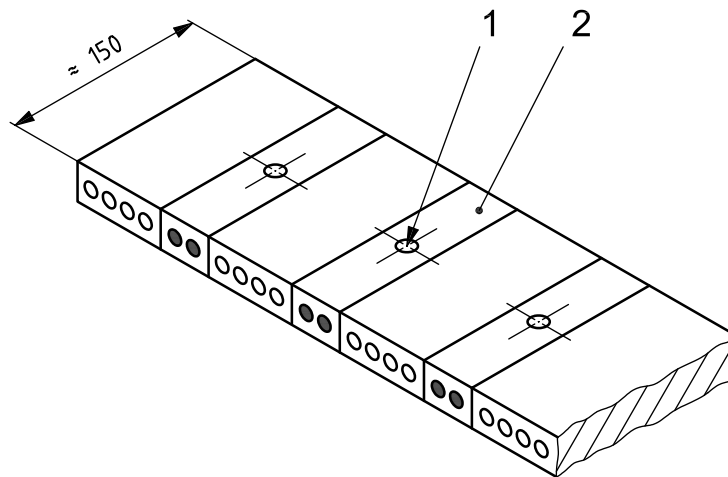
**5.3.1 General**

Cut a rectangular test piece across the full belt width, at 90° to the belt edge, with dimensions as specified in 5.3.2 to 5.3.4, as appropriate.

**5.3.2 Test pieces and test specimens for method A1**

The test piece shall be approximately 150 mm in length. As appropriate, cut three or five test specimens from the test piece at the measurement points specified in 5.2. Each test specimen shall be two cord pitches wide [i.e. of a width equal to the width that comprises two cords (see Figure 2)] and shall have a length of approximately 150 mm.

Dimensions in millimetres

**Key**

- 1 measurement point
- 2 test specimen

**Figure 2 — Test specimens taken at the measurement points and cut from a full-width belt sample**

### 5.3.3 Test specimens for method A2

The test specimen shall be not less than 50 mm in length with a width equal to the total width of the belt. Mark on the test specimen the measurement points specified in 5.2.

### 5.3.4 Test specimens for method B

The test shall be carried out either on the end of the conveyor belt *in situ*, or on a test specimen not less than 50 mm in length. In either case, the cut edge shall be at 90° to the surface of the belt and the cords shall be visible and free from contamination, the cord ends being cleaned, if necessary. Mark on the test specimen the measurement points specified in 5.2.

## 5.4 Measurement of thickness

### 5.4.1 Method A1

#### 5.4.1.1 Measurement of total thickness

Measure the total thickness,  $s_1$ , of the test specimen at each of the measurement points specified in 5.2.

#### 5.4.1.2 Measurement of top cover thickness

Remove the top cover down to the two cords (see Figure 3). Measure the dimension  $s_7$  at the measurement points shown in Figure 1. Take measurements directly above the cord, ensuring that the micrometer foot is in contact with either the surface of the cord [see Figure 3 a)] or the surface of the weft [see Figure 3 b)].

Calculate the thickness of the top cover,  $s_2$ , at each measurement point, using Equation (1):

$$s_2 = s_1 - s_7 \quad (1)$$

**5.4.1.3 Measurement of bottom cover thickness**

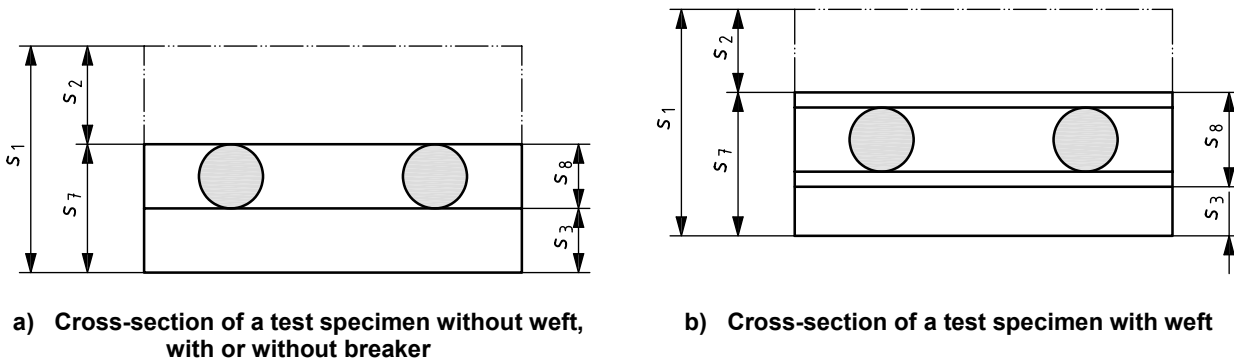
After carrying out the procedure described in 5.4.1.2, remove the bottom cover. Measure the dimension  $s_8$  as described in 5.4.1.2, ensuring that the measurement points are located over the cords.

Calculate the thickness of the bottom cover,  $s_3$ , at each measurement point, using Equation (2):

$$s_3 = s_7 - s_8 \tag{2}$$

**5.4.1.4 Calculation and expression of results**

Calculate the arithmetic mean of three or five thicknesses, as appropriate, for  $s_1$ ,  $s_2$  and  $s_3$ , as determined in 5.4.1.1, 5.4.1.2 and 5.4.1.3. Express the results in millimetres.



**Figure 3 — Test specimens for method A1**

**5.4.2 Method A2**

**5.4.2.1 Measurement of total thickness**

Measure the total thickness,  $s_1$ , of the test specimen at each of the measurement points specified in 5.2.

**5.4.2.2 Measurement of top cover thickness**

Remove a section of 20 mm in length from the top cover over the entire width of the test specimen (see Figure 4). Measure the thickness,  $s_7$ , at the same points as in 5.4.2.1. Take measurements directly above the cord, ensuring that the micrometer foot is in contact with either the surface of the cord [see Figure 4 a)] or the surface of the weft [see Figure 4 b)].

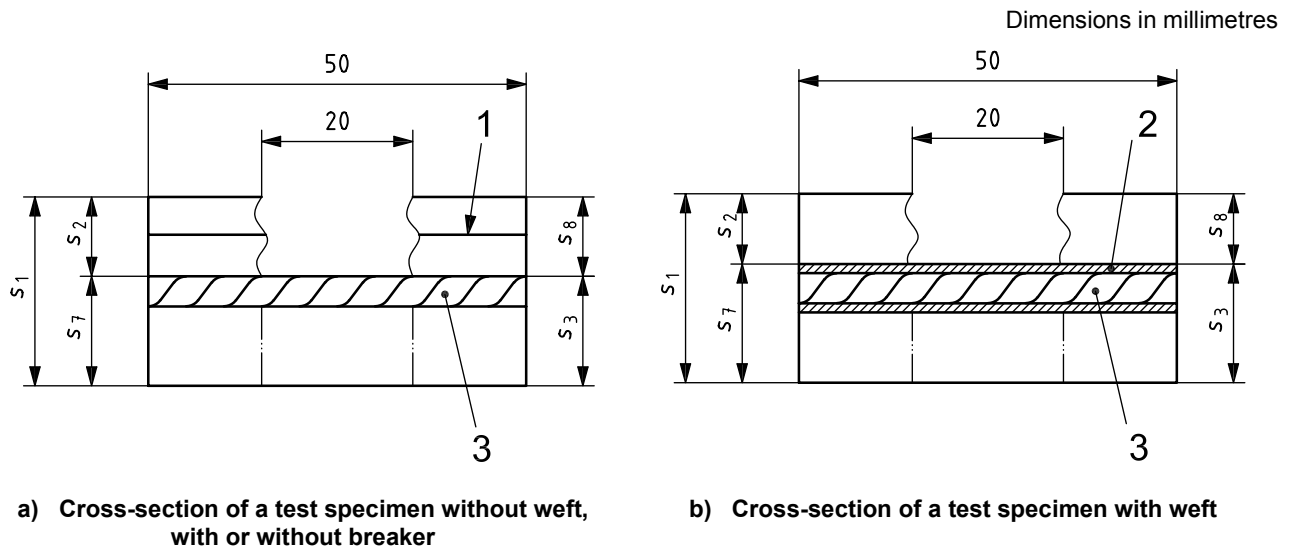
Calculate the thickness of the top cover,  $s_2$ , at each measurement point, using Equation (1).

**5.4.2.3 Measurement of bottom cover thickness**

After carrying out the procedure described in 5.4.2.2, remove the bottom cover. Measure the dimension  $s_8$  as described in 5.4.2.2, ensuring that the measurement points are located over the cords.

Calculate the thickness of the bottom cover,  $s_3$ , at each measurement point, using Equation (2).





### Key

- 1 breaker
- 2 weft
- 3 cord

Figure 4 — Test specimens for method A2

#### 5.4.2.4 Calculation and expression of results

Calculate the arithmetic mean of three or five thicknesses, as appropriate, for  $s_1$ ,  $s_2$  and  $s_3$ , as determined in 5.4.2.1, 5.4.2.2 and 5.4.2.3. Express the results in millimetres.

#### 5.4.3 Method B

##### 5.4.3.1 Measurement of top and bottom cover thicknesses

Using the optical measuring instrument (see 4.2), measure the distance between the top edge of the cord and the surface of the belt at each of the measurement points specified in 5.2, ensuring that the measuring scale is in physical contact with the belt. Record the thicknesses of the top cover,  $s_2$ , and bottom cover,  $s_3$ , at each measurement point.

##### 5.4.3.2 Calculation and expression of results

Calculate the arithmetic mean of three or five thicknesses, as appropriate, for  $s_2$  and  $s_3$ , as determined in 5.4.3.1. Express the results in millimetres.

## 6 Test report

The test report shall contain at least the following information:

- a) reference to this International Standard (ISO 7590:2008);
- b) method used, i.e. A1, A2 or B, as appropriate;
- c) identification of the conveyor belt tested;

## ISO 7590:2009(E)

- d) number of measurement points;
- e) test results, as given in 5.4.1.4, 5.4.2.4 or 5.4.3.2, as appropriate;
- f) date of the test.

## Bibliography

- [1] ISO 8094, *Steel cord conveyor belts — Adhesion strength test of the cover to the core layer*
- [2] EN 13827, *Steel cord conveyor belts — Determination of the lateral and vertical displacement of steel cords*

---

---

**ICS 53.040.20**

Price based on 7 pages