

# JIS

JAPANESE  
INDUSTRIAL  
STANDARD

Translated and Published by  
Japanese Standards Association

---

---

**JIS K 6322** : 2018

(JBMA/JSA)

**Conveyor belts—Specification for  
rubber covered conveyor belts of  
textile construction**

---

ICS 53.040.20;83.140.99

Reference number : **JIS K 6322 : 2018 (E)**

K 6322 : 2018

Date of Establishment: 1953-05-25

Date of Revision: 2018-02-20

Date of Public Notice in Official Gazette: 2018-02-20

Investigated by: Japanese Industrial Standards Committee  
Standards Board for ISO area

---

JIS K 6322:2018, First English edition published in 2018-11

Translated and published by: Japanese Standards Association  
Mita MT Building, 3-13-12, Mita, Minato-ku, Tokyo, 108-0073 JAPAN

---

In the event of any doubts arising as to the contents,  
the original JIS is to be the final authority.

© JSA 2018

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 the publisher.

Printed in Japan

KK/AT

PROTECTED BY COPYRIGHT

## Contents

	Page
Introduction .....	1
1 Scope .....	1
2 Normative references .....	1
3 Terms and definitions .....	2
4 Symbols and units .....	3
5 Types .....	3
6 Construction .....	4
6.1 Construction of belt cross-section .....	4
6.2 Joint in adjacent textile constructions .....	4
7 Dimensions and dimensional tolerances .....	5
7.1 Width of belts and tolerances .....	5
7.2 Tolerances on length of belt .....	5
7.3 Thickness evenness of belt .....	6
7.4 Tolerances on thickness of cover rubber .....	6
8 Performances .....	6
8.1 Properties of cover rubbers .....	6
8.2 Properties of belts .....	7
8.3 Adhesion strength .....	7
8.4 Troughability .....	8
8.5 Deviation from straightness of belt .....	8
9 Sampling and measurement of dimensions .....	9
9.1 Sampling .....	9
9.2 Measurement of dimensions .....	9
10 Test methods .....	11
10.1 Tensile test of cover rubber .....	11
10.2 Ageing test of cover rubber .....	11
10.3 Abrasion test of cover rubber .....	12
10.4 Tensile test of belt .....	12
10.5 Adhesion test .....	15
10.6 Troughability test .....	16
10.7 Measurement of deviation from straightness of belt .....	17
11 Designation of product .....	18
12 Marking .....	19
12.1 Marking on product .....	19

12.2 Marking on packaging .....	19
Annex JA (informative) Comparison table between JIS and corresponding International Standard .....	20

## Foreword

This Japanese Industrial Standard has been revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard submitted by The Japan Belting Manufactures Association (JBMA)/Japanese Standards Association (JSA) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14. Consequently **JIS K 6322**:2011 is replaced with this Standard.

This **JIS** document is protected by the Copyright Law.

Attention is drawn to the possibility that some parts of this Standard may conflict with patent rights, applications for a patent after opening to the public or utility model rights. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying any of such patent rights, applications for a patent after opening to the public or utility model rights.

# Conveyor belts—Specification for rubber covered conveyor belts of textile construction

## Introduction

This Japanese Industrial Standard has been prepared based on **ISO 14890:2013**, Edition 2, with some modifications of the technical contents.

The vertical lines on both sides and dotted underlines indicate changes from the corresponding International Standard. A list of modifications with the explanations is given in Annex JA.

## 1 Scope

This Standard specifies the rubber covered conveyor belts of textile construction for general use having the smooth surface and the mono-ply or multi-ply textile carcasses (hereafter referred to as belts).

NOTE : The International Standard corresponding to this Standard and the symbol of degree of correspondence are as follows.

ISO 14890:2013 *Conveyor belts—Specification for rubber- or plastics-covered conveyor belts of textile construction for general use* (MOD)

In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and **JIS** are IDT (identical), MOD (modified), and NEQ (not equivalent) according to **ISO/IEC Guide 21-1**.

## 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

JIS B 7503 *Mechanical dial gauges*

JIS B 7507 *Vernier, dial and digital callipers*

JIS B 7512 *Steel tape measures*

JIS K 6200 *Rubber—Vocabulary*

JIS K 6250 *Rubber—General procedures for preparing and conditioning test pieces for physical test methods*

JIS K 6251 *Rubber, vulcanized or thermoplastic—Determination of tensile stress-strain properties*

NOTE : Corresponding International Standard: ISO 37 *Rubber, vulcanized or thermoplastic—Determination of tensile stress-strain properties*

JIS K 6257 *Rubber, vulcanized or thermoplastic—Determination of heat ageing properties*