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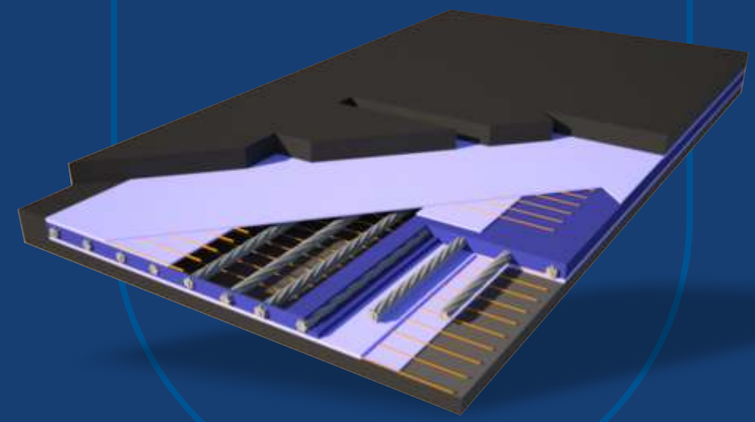


STEEL CORD CONVEYOR BELTING

FORECH INDIA PRIVATE LIMITED

FORECH INDIA PVT. LTD.

FORECH INDIA PRIVATE LIMITED has over four decades of experience servicing the global Mining, Mineral Processing and Construction sectors in the field of Bulk Material Handling; Wear and Corrosion Protection; Servicing and Maintaining Conveyor belt systems.

The Forech Story

1994: Forech takes over Hilton Rubbers Ltd.'s manufacturing plant in Sonepat, India; acquiring the world class production capability, processes and technology developed by Trelleborg AB of Sweden and bringing along all of Hilton's knowledge and experience since 1970.

1996: Forech ties up with TRS International GmbH of Germany to produce specialized rubber sheets with pre-coated bonding layers.

1997: Technical agreement with B.T.R. through Dunlop Enerka, Holland (The Netherlands) for Textile and Steel Cord Conveyor Belts.

2003: Forech expands its product portfolio again with a range of pulley lagging, repair material, impact bars and other wear resistant products.

2004: Forech sets up its second factory - a dedicated textile Conveyor Belt plant at Dhaturi, Haryana.

2007: Forech makes its first sidewall and cleated Conveyor Belt, suitable for inclines upto 90°.

2009: Forech sets up its Cheyyar Plant. This factory with 18000m^2 built-up area manufacturing sheet rubber, textile Conveyor Belts and starts production of Steel Cord Conveyor Belts.

CHEYYAR WORKS

2012 : Commissioned second steel cord line.

2016 : Commissioned third steel cord line for belt range from 1800mm to 2500mm belt width.

The Forech Advantage

- Close proximity to Chennai Port. We can have your order on a ship the day after we dispatch it from the factory.
- We moved hundreds of kilometres closer to our raw material suppliers and you benefit from improved turnaround time.
- Our 18000m^2 factory is large enough to carry out every manufacturing process and in-house testing so that Forech team can build a world-class belt for you.

- Our Steel Cord manufacturing technology is provided by Dunlop Belting Products, South Africa, so that you get a belt with a world-class heritage and pedigree.

Partnering with Dunlop

Due to the critical nature of the technology involved, very few companies worldwide have been able to successfully implement Steel Cord Conveyor manufacturing technology. One of these companies was the BTR Group, the owners of Dunlop Enerka, with its plant in Holland. As the BTR Group grew, it established its own Steel Cord belt plants in Europe, North America, Latin America, Africa and Australia and licensed its technology to other companies across the world, including two companies in India other than Forech.

After the BTR Group's reorganization, Dunlop SA emerged as a major independent player in Steel Cord Conveyor belts. Supplying belts for use in the harsh working environments of the South African mines, Dunlop SA reinforced the original BTR technology with its own R&D inputs. Dunlop SA has also licensed its technology and process knowledge to Mercurio, Brazil; which has been supplying Steel Cord belts to the Latin American market for over two decades.

Forech India Pvt. Ltd. is now licensed by Dunlop SA to manufacture Steel Cord belts in its new Cheyyar plant. The combination of Dunlop's proven technology, Forech's market knowledge and cost effectiveness will give you the same high-quality product and yet bring economy.

The Forech-Dunlop Advantage

- Dunlop SA license agreement includes product recipes, process control techniques, raw material evaluation guidelines, equipment specifications and product design software.
- Forech personnel trained by Dunlop SA for manufacturing, field support and product servicing and maintenance.
- BTR Group's technology used and proven all over the world and Dunlop SA's refinements proven in Africa and Latin America, including belts installed at the Anglo-American Group's mines.
- Forech's efficient and productive Cheyyar plant is geared to integrate Dunlop SA's existing technology and maintain its high quality and add to productivity levels.
- The combination of Dunlop's technology and Forech's application knowledge created a world-class product at economic price levels.

Current mining techniques demand that Conveyor Belts handle ever greater volumes with increased centre distances and high lifts, all of which necessitate stronger belts. The high strength of Steel Cord tension carrier is not the only reason why Steel Cord belts are increasingly being used as an economic alternative to other bulk material handling methods.

STEEL CORD BELT ADVANTAGES

1. **DELIVER EXTREMELY HIGH STRENGTHS**

   When operating tensions in excess of 2500 kN/m are required, belts reinforced with Steel Cord are the only alternative and today Steel Cord belts are being designed for ratings upto ST10000. Yet, due to its numerous advantages, Steel Cord belts are increasingly used even in ratings as low as ST 500/630.

2. **LONG LIFE EXPECTANCY**

   Conveyor Belts with Steel Cord reinforcement members are virtually maintenance-free and can be supplied with increasingly thicker rubber covers for the same rating. The carcass, having a minimal risk of failure, yields very long life without affecting the overall design, sometimes even lasting for the entire duration.

3. **LARGE CENTRE DISTANCES CAN BE PLANNED**

   Steel Cord Belts have very low elongation and consequently systems with large centre distances can be planned, without having to account for limitations of take-ups and transfer points.

4. **LOW PULLEY DIAMETERS CAN BE USED**

   For the same rating, the thickness of the tension member (carcass thickness) in Steel Cord belts is considerably lower than that in a fabric reinforced belt and hence is able to operate with lower pulley diameters. The superior dynamic modulus of the Steel Cords over the fabric carcass also ensures that flex fatigue sets in very slowly making the selection of lower pulley diameters technically viable.

   Again the safety factor requirements for Steel Cord Belts are 6.67 against 9 – 10 for Textile Conveyor Belts and therefore when compared with textile belts of equivalent rating, the difference in pulley diameters becomes even more striking.

5. **LOW ELONGATION, HIGH IMPACT RESISTANCE**

   The elongation of Steel Cord Belt is a function of elastic modulus of the steel and the amount of twist in the cord. The very low elongation of Steel Cord makes short take-ups a possibility. Typically elongation is down to 0.25% on total belt lengths.

   The geometry of a Steel Cord Belt provides for greater rubber per unit volume compared to fabric reinforced belts permitting a more effective absorption of impact energy.

   Consequently Steel Cord Belts allow discontinuous feed of heavy individual pieces without localized elongation.

6. **EXCELLENT TROUGHABILITY**

   Even the strongest Steel Cord Belts trough perfectly on deep troughed idler sites. This ensures easy belt training and the realisation of superior volumetric capacity of the belt, whereby the user can either convey more material at the same speed or employ narrower conveyor systems.

7. **LONG SPLICE LIFE AND STRENGTH**

   Properly provided Belt Splices can last as long as the Belt itself. They can also achieve spliced strength equivalent to almost 100% of the strength of the Belt.

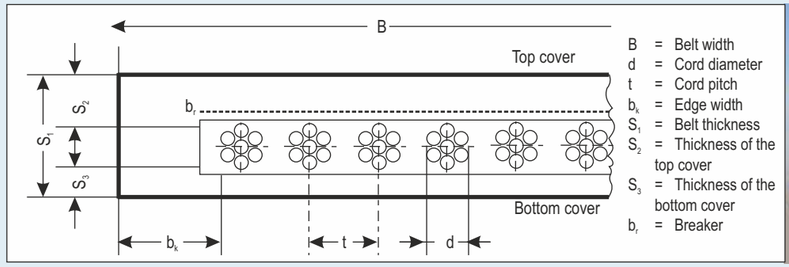
8. **EASILY RECONDITIONED AND RE-JUVENATED**

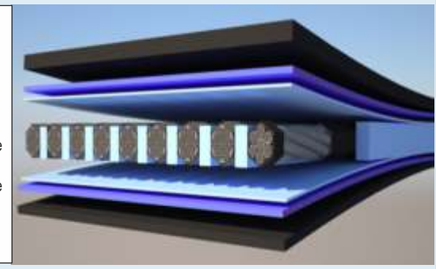
   Steel Cord Belts can be repaired with Hot or Cold vulcanization and the damaged edges can be restored to original width by hot repair. Worn out covers can be replaced with fresh rubber, durable enough to completely re-juvenate the belt, delivering yet greater economy for the customer.

STEEL CORD BELT : COMPONENTS

CONVEYOR BELT CROSS-SECTION

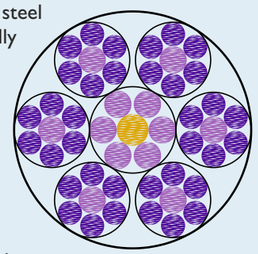
A Typical Steel Cord Conveyor belt has three distinct components and a fourth optional protective element. These are the steel cable, the bonder layer and the top and bottom covers. To prevent longitudinal rips, optional components such as sensor loops or breakers may be incorporated.



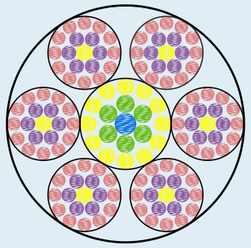


STEEL CORD

The 'building block' for the reinforcing Steel Cords are round steel wires. These Zinc/Brass coated high-carbon wires are laid helically with a uniform twist around a central core to form the 'Strand'. Strands so formed are, in turn, helically laid around a central strand to form the reinforcement 'Cord' of the Steel Cord belt. Forech sources Steel Cords only from globally established manufacturers and conducts periodic checks on the cords supplied to evaluate the Component Dimensions, Tensile Strength, Elongation (Static & Dynamic), Openness, Effectiveness of coating, Cord Pullout strength etc. Cord types 7x7 and 7x19 are most popular and can cover a large range of Steel Cord Belt ratings.



7x7



7x19

BONDER RUBBER

The function of the bonder rubber is to maintain a bond between the metallic cords and the rubber polymer in the Steel Cord Belt. The bonder rubber not only has to create the metal-rubber bond but – for optimal product performance – is also required to be viscous enough to flow into the air gaps/voids between individual filaments in each cord to offer additional protection against environmental threats as well as to protect adjacent filaments from chafing against each other.

COVER QUALITIES

Forech manufactures its entire range of Steel Cord Belts (in widths upto 2000mm and in ratings upto ST 10000) in General Purpose or Fire Resistant Grades(refer to chart below). For extreme applications, Heat Resistant and Oil Resistant Belts can be supplied.

All General Purpose Grade Belts and Fire Resistant Belts can also be supplied with a **low rolling resistance** compound for the back cover to optimize power consumption. For detailed technical specifications please refer to Forech.

Cover Grade	Reference Standards	Applications
X, Y, W H, D, L A, M, N M, N M, N, A	DIN 22131 EN ISO 15236 AS 1333 SABS 1366 IS 15427	X, M, H, D - are for toughest applications where very large abrasive lumps are handled. A, W are for handling of high abrasive material. N, L, Y are General purpose for handling of moderate abrasive materials.
K F	DIN 22131, EN ISO 15236 ISO 340, SABS 1366 & CAN-CSA-M422-M87	Very high Fire Resistant properties. Used for surface conveyor.
S FR-U FR-U	AS 4606 IS 15143 MSHA	Excellent self extinguishing properties used mainly for underground mining.

Standard Steel Cord Range (DIN 22131)

ST RATING (kN/m)	RECOMMENDED CORD DIA (mm)	PITCH (mm) ± 1.5	BELT WIDTH (mm)												MINIMUM RECOMMENDED PULLEY DIAMETERS (mm) FOR MAWT UTILISATION > 60 %		
			800	900	1000	1050	1200	1400	1500	1600	1800	2000	2200	2400	A	B	C
			NO. OF CORDS														
500	2.6	12	64	71	81	84	97	114	122	131	147	164	181	197	500	400	315
560	2.7	12	64	71	81	84	97	114	122	131	147	164	181	197	500	400	315
630	2.9	12	64	71	81	84	97	114	122	131	147	164	181	197	500	400	315
710	3.0	12	64	71	81	84	97	114	122	131	147	164	181	197	630	500	400
800	3.1	12	64	71	81	84	97	114	122	131	147	164	181	197	630	500	400
900	3.3	12	64	71	81	84	97	114	122	131	147	164	181	197	800	630	500
1000	3.5	12	64	71	81	84	97	114	122	131	147	164	181	197	800	630	500
1120	3.7	12	64	71	81	84	97	114	122	131	147	164	181	164	800	630	500
1250	4.2	14	55	61	69	72	84	98	104	112	127	141	155	169	800	630	500
1400	4.5	14	55	61	69	72	84	98	104	112	127	141	155	169	800	630	500
1600	5.0	15	50	57	64	67	77	90	97	104	117	130	144	157	1000	800	630
1800	5.4	15	50	57	64	67	77	90	97	104	117	130	144	157	1000	800	630
2000	6.0	15	50	57	64	67	77	90	97	104	117	130	144	157	1000	800	630
2250	6.2	15	50	57	64	67	77	90	97	104	117	130	144	157	1000	800	630
2500	6.6	15	50	57	64	67	77	90	97	104	117	130	144	157	1250	1000	800
2800	7.0	15	50	57	64	67	77	90	97	104	117	130	144	157	1250	1000	800
3150	7.4	15	50	57	64	67	77	90	97	104	117	130	144	157	1250	1000	800
3550	8.0	15	50	57	64	67	77	90	97	104	117	130	144	157	1400	1250	1000
4000	8.6	15	50	57	64	67	77	90	97	104	117	130	144	157	1400	1250	1000
4500	9.2	16	46	52	59	65	71	84	90	96	109	121	134	146	1400	1250	1000
5000	10.4	17	43	48	55	60	66	78	84	90	102	113	125	137	1600	1250	1000
5400	11.0	17	43	48	55	60	66	78	84	90	102	113	125	137	1600	1250	1000
6300	11.6	17	43	48	55	60	66	78	84	90	102	113	125	137	2000	1800	1600

Note : - Note:- The value provided are nominal and should consider for design purpose only.
- Forech deserves the right to change the parameters and value as per normal development of Technology without any notice.

Standard Steel Cord Range (AS 1333)

ST RATING (kN/m)	RECOMMENDED CORD DIA (mm)	PITCH (mm) ± 1.5	BELT WIDTH (mm)												MINIMUM RECOMMENDED PULLEY DIAMETERS (mm) FOR MAWT UTILISATION > 60 %		
			800	900	1000	1050	1200	1400	1500	1600	1800	2000	2200	2400	A	B	C
			NO. OF CORDS														
500	2.6	13.8	56	63	70	74	84	99	106	113	128	142	156	170	500	400	315
560	2.8	13.8	56	63	70	74	84	99	106	113	128	142	156	170	500	400	315
630	3.0	13.8	56	63	70	74	84	99	106	113	128	142	156	170	500	400	315
710	3.1	13.8	56	63	70	74	84	99	106	113	128	142	156	170	630	500	400
800	3.3	13.8	56	63	70	74	84	99	106	113	128	142	156	170	800	630	500
900	3.8	15.3	50	56	63	66	76	89	96	102	115	128	141	154	800	630	500
1000	4.0	15.3	50	56	63	66	76	89	96	102	115	128	141	154	800	630	500
1120	4.3	15.3	50	56	63	66	76	89	96	102	115	128	141	154	800	630	500
1250	4.5	15.3	50	56	63	66	76	89	96	102	115	128	141	154	800	630	500
1400	4.8	15.3	50	56	63	66	76	89	96	102	115	128	141	154	1000	800	630
1600	5.5	17.3	45	50	56	59	67	79	85	90	102	113	124	136	1000	800	630
1800	5.9	17.3	45	50	56	59	67	79	85	90	102	113	124	136	1000	800	630
2000	6.4	17.3	45	50	56	59	67	79	85	90	102	113	124	136	1000	800	630
2250	6.8	17.3	45	50	56	59	67	79	85	90	102	113	124	136	1250	1000	800
2500	7.4	19.4	40	45	50	52	60	70	75	81	91	101	111	121	1250	1000	800
2800	8.0	19.4	40	45	50	52	60	70	75	81	91	101	111	121	1400	1250	1000
3150	8.6	19.4	40	45	50	52	60	70	75	81	91	101	111	121	1400	1250	1000
3550	9.2	19.4	40	45	50	52	60	70	75	81	91	101	111	121	1400	1250	1000
4000	9.8	19.4	40	45	50	52	60	70	75	81	91	101	111	121	1600	1400	1250
4500	10.4	19.4	40	45	50	52	60	70	75	81	91	101	111	121	1600	1250	1000
5000	11.0	19.4		45	50	52	60	70	75	81	91	101	111	121	1600	1250	1000
5600	11.8	19.4		45	50	52	60	70	75	81	91	101	111	121	2000	1800	1600
6300	12.8	20		43	48	50	58	68	73	78	88	98	108	118	2000	1800	1600

Note : - The value provided are nominal and should consider for design purpose only.
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TESTING EQUIPMENTS

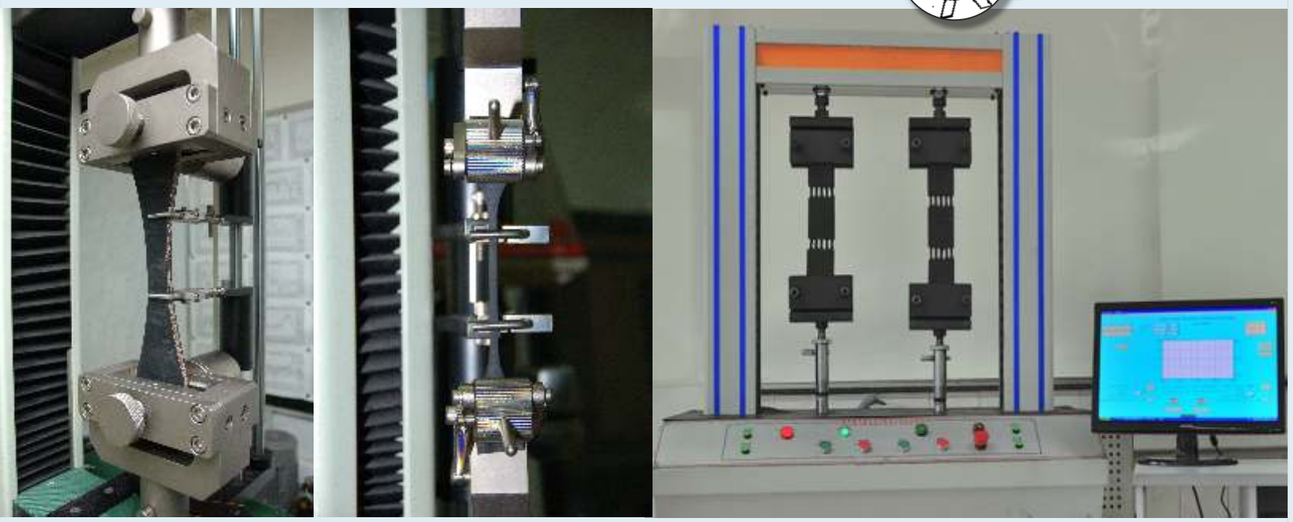
Forech Lab is equipped with most modern testing equipments which covers testing requirements as specified in all National and International standards for conveyor belts.

Forech Lab has also facility to do testing of all the raw materials used for manufacturing of Steel Cord conveyor belt.

Among the big list of Lab equipments most important are :

Rheometer, 5MT and 10MT Capacity universal testing machine, Abrasion Testing Machine, Multicell Ageing Oven, Dynamic cord Pull Out Test Machine, Torsion Bending Test Machine, Longitudinal Flexing Test Machine, Troughability Test Machine, Drum Friction Test Machine, Flame Test Cabinet, Air Permeability Test Machine etc.

NABL CERTIFIED



We have in-house testing facilities in labs approved by NABL

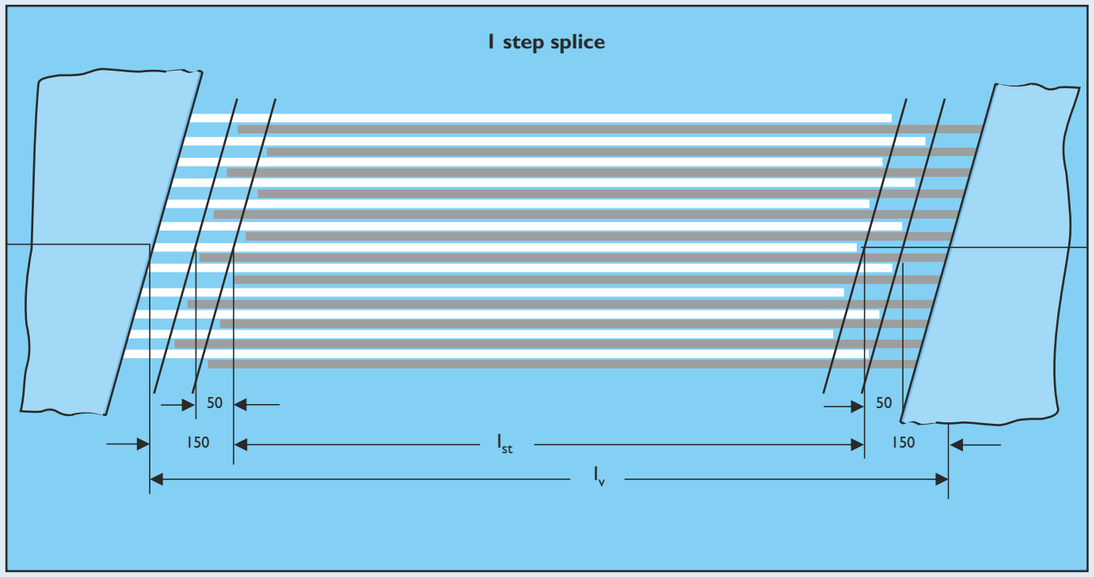
STEEL CORD BELT SPLICING

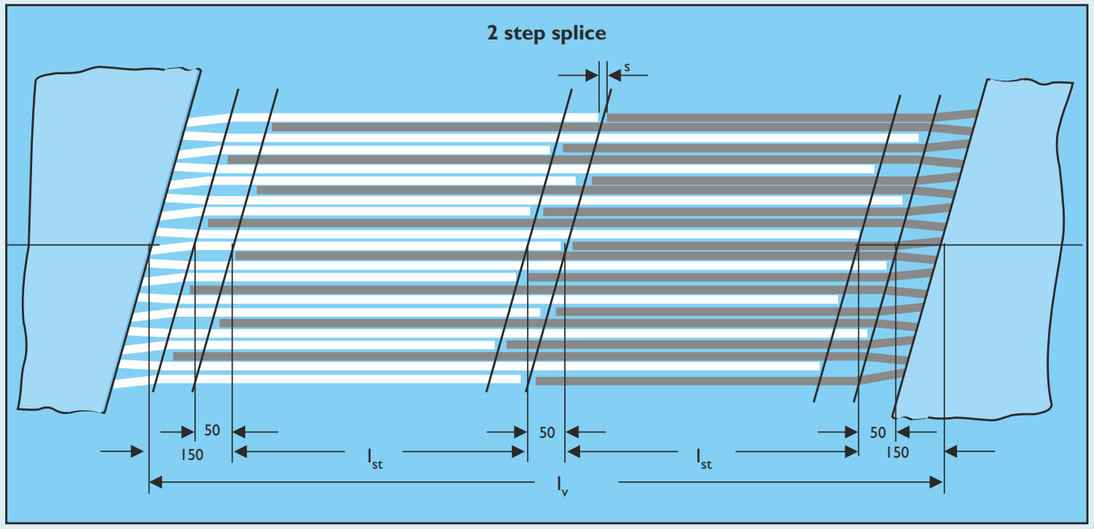
The most popular and effective means of splicing Steel Cord belts is with the FINGER SPLICE method where cords from the mating sections of the belt in opposing directions are brought together as shown below. Different splice making protocols are employed depending on the strength of the belt and these different types are referred to as Type I, Type II and so on up to Type V splice joints for very high strength belts.

Splice lengths and types:

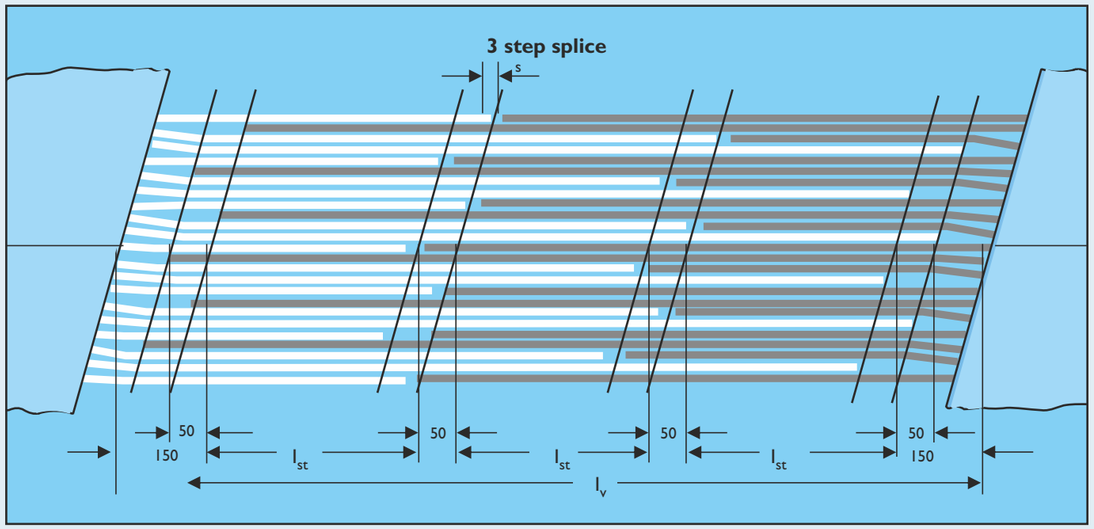
BELT TYPE	Number of Steps	Minimum step length (ls)	Splice length (lv)
ST-1250 and below	1	350	650
ST 1600	1	450	750
ST 2000	2	400	1150
ST 2500	2	500	1350
ST 3150	2	650	1650
ST 3500	3	650	2350
ST 4000	3	750	2650
ST 4500	3	800	2800

Splice lengths are related to standard constructions of Steel Cord Belts.
If constructions is changed, number of steps may vary.



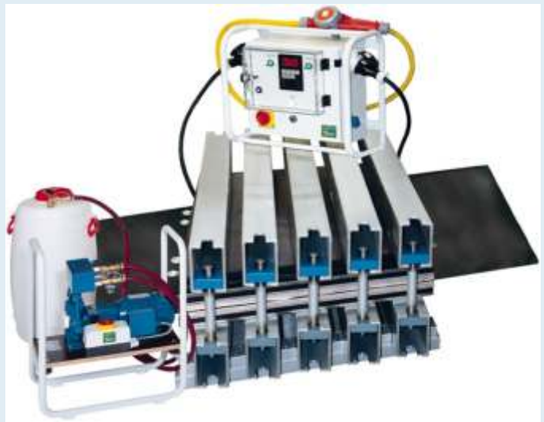


l_v = splice length . l_{st} = step length . s = min. 3 x cord diameter



The Steel Cord splicing kit is a vital component in the splicing operations and it is usually advisable to use splicing kits manufactured by the belt supplier only. Specially when making high strength splices or for special rubber cover grades like Fire Resistant, Heat Resistant and Oil Resistant grade.

For specialised applications such as Pipe Conveyor belts and high angle sidewall belts employing Steel Cord belting, it is always recommended that the splicing kit is procured from the belt manufacturer only to ensure optimal compatibility between the belt and the splicing compounds.



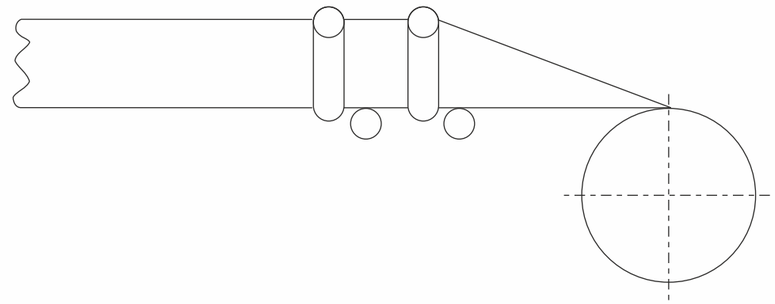
TRANSITION DISTANCE

Steel Cord reinforced belts require greater transition distance at the terminal ends to offset high stress build up at the edges and are therefore not recommended for troughed Conveyors with a centre to centre distance of less than 50 to 60 metres. The recommended minimum transition distance is given below.

The transition distance is dependant on the vertical position of the terminal pulley relative to the troughing idlers. The two most common configurations are :

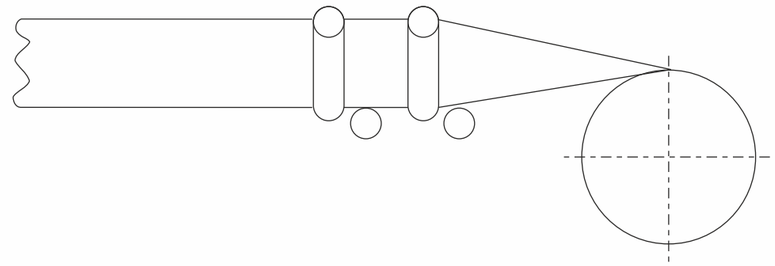
Case 1

Top of the terminal pulley in line with the centre roll of the troughing idlers



Case 2

Top of the terminal pulley at mid depth of the trough



RECOMMENDED MINIMUM TRANSITION DISTANCE

PERCENTAGE OF FULL RATED TENSION	CASE 1 TROUGHING ANGLE				CASE 2 TROUGHING ANGLE			
	20°	30°	35°	45°	20°	30°	35°	45°
Below 50	2.00w	3.30w	3.60w	4.50w	1.12w	1.60w	1.90w	2.40w
50 — 89	2.42w	3.50w	4.06w	5.00w	1.25w	1.80w	2.20w	2.70w
90 — 100	2.53w	3.70w	4.25w	5.20w	1.40w	2.00w	2.40w	3.00w
	'w' = width of the belt							

Special attention to transition distance calculation is required, so that there is no over-stressing on the edges or slackness at belt edges.

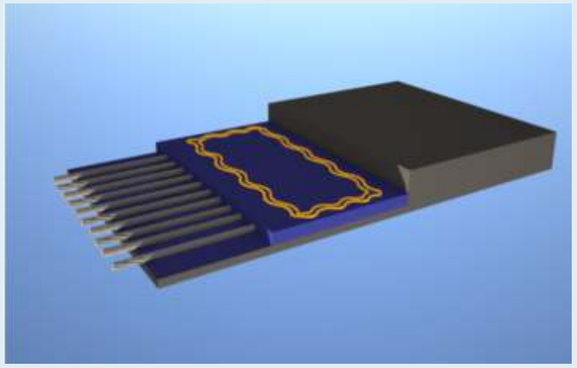
RIP PROTECTION AND SURVEILLANCE

Steel Cord Conveyor Belts do not have a weft reinforcement member and therefore rip easily if sharp foreign materials comes in contact. Forech offers Rip Stop fabric incorporated in the belting and the experience of our technology partner shows it to be an extremely successful method of protecting the belt from such rips even as it contributes to improving the dynamic performance of the belt by enhancing bond properties and Splice efficiency. Such Ripstop rot - proof fabric can be inserted in the covers across the belt width and along the length of the roll.

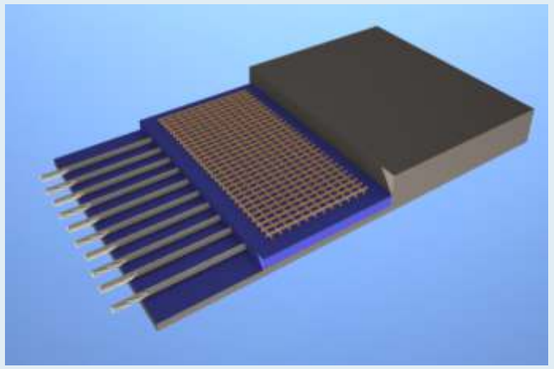
- Increased belt service life
- Increased rip and penetration resistance
- Increased cord protection against impact damage
- Perfect troughability
- Unchanged pulley diameters

- Easily spliced or repaired using standard materials
- Rot proof synthetic `Ripstop' fabric
- Perfect bonding between `Ripstop' fabric and rubber matrix.
- Superior mechanical deformation performance of `Ripstop' fabric.

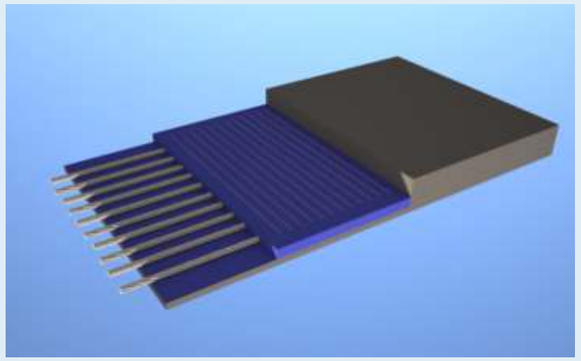
Forech also works along with leading global manufacturers like Coal Control to provide Sensor Loops which can be retro-fitted into the belts and electronically monitored to suit customer requirements. Such protection systems with appropriate site maintenance are emerging as fail safe rip detection systems for Steel Cord Belts worldwide.
Please ask Forech for further details.



Sensor loop inserted



Textile breaker inserted



Steel breaker inserted

Electronically monitored system

BELT PACKING, TRANSPORTATION & STORAGE

Packing of Steel Cord belts demand special attention not only because it is an expensive product that requires the best protection from damage in transit, but also because it is a product for application in high-tension Conveyors and is therefore best supplied in lengths as long as possible to minimise the number of splice joints.

Customers prefer packing in drums, often in steel drums where extended storage is likely. Some users insist on oblong type packing to maximise the roll length and some others specify cassette type packing.

On the other hand, there are numerous dimensional and weight constraints for material transportation – either by marine container or by road. These constraints need to be weighed in conjunction with handling capabilities available at the unloading point to decide on optimal supply roll lengths.

ROLL DIAMETER CALCULATIONS AND CHART

$D = \sqrt{\frac{4}{\pi} \times d \times L + K^2}$ (m)

D = Drum Diameter (m)

d = Belt Thickness (m)

L = Belt Length (m)

K = Reel Core Diameter (m)

(Forech Standard K = 0.5 m)

BELT LENGTH L (m)	BELT THICKNESS d (mm)															
	10	12	14	16	18	20	20	24	26	28	30	32	34	36	38	40
10	0.61	0.63	0..65	0.67	0.69	0.71	0.73	0.75	0.76	0.78	0.79	0.81	0.83	0.84	0.86	0.87
20	0.71	0.75	0.78	0.81	0.84	0.87	0.90	0.93	0.96	0.98	1.01	1.03	1.06	1.08	1.10	1.13
40	0.87	0.93	0.98	1.03	1.08	1.13	1.17	1.21	1.25	1.29	1.33	1.37	1.41	1.44	1.48	1.51
60	1.01	1.08	1.15	1.21	1.27	1.33	1.39	1.44	1.50	1.55	1.59	1.64	1.69	1.73	1.78	1.82
80	1.13	1.21	1.29	1.37	1.44	1.51	1.58	1.64	1.70	1.78	1.82	1.87	1.93	1.98	2.03	2.08
100	1.23	1.33	1.43	1.51	1.59	1.67	1.75	1.82	1.89	1.95	2.02	2.08	2.14	2.20	2.26	2.31
120	1.33	1.44	1.55	1.64	1.73	1.82	1.90	1.98	2.05	2.13	2.20	2.27	2.33	2.40	2.46	2.52
140	1.43	1.55	1.66	1.76	1.86	1.95	2.04	2.13	2.21	2.29	2.37	2.44	2.51	2.58	2.65	2.72
160	1.51	1.64	1.76	1.87	1.98	2.08	2.17	2.27	2.36	2.44	2.52	2.60	2.68	2.75	2.83	2.90
180	1.59	1.73	1.85	1.98	2.09	2.20	2.30	2.40	2.49	2.58	2.65	2.75	2.84	2.92	2.99	3.07
200	1.67	1.82	1.95	2.08	2.20	2.31	2.42	2.52	2.62	2.72	2.81	2.90	2.98	3.07	3.15	3.23
220	1.75	1.90	2.04	2.18	2.30	2.42	2.53	2.64	2.74	2.84	2.94	3.04	3.13	3.21	3.30	3.38
240	1.82	1.98	2.13	2.27	2.40	2.52	2.64	2.75	2.86	2.97	3.07	3.17	3.26	3.35	3.44	3.53
260	1.89	2.05	2.21	2.36	2.49	2.62	2.74	2.86	2.98	3.09	3.19	3.29	3.39	3.49	3.53	3.67
280	1.95	2.13	2.29	2.14	2.58	2.72	2.64	2.97	3.09	3.20	3.31	3.41	3.53	3.62	3.71	3.80
300	2.02	2.20	2.37	2.52	2.67	2.80	2.94	3.07	3.19	3.31	3.42	3.53	3.64	3.74	3.84	3.94
320	2.08	2.27	2.44	2.60	2.75	2.90	3.04	3.17	3.29	3.41	3.53	3.65	3.78	3.85	3.97	4.07
340	2.14	2.33	2.51	2.68	2.84	2.98	3.13	3.26	3.39	3.52	3.64	3.76	3.87	3.98	4.09	
360	2.20	2.40	2.58	2.75	2.92	3.07	3.21	3.35	3.49	3.62	3.74	3.86	3.98	4.09		
380	2.26	2.46	2.65	2.83	2.99	3.15	3.30	3.44	3.58	3.71	3.84	3.97	4.09			
400	2.31	2.52	2.72	2.90	3.07	3.23	3.38	3.53	3.67	3.81	3.94	4.07				
420	2.37	2.58	2.78	2.97	3.14	3/31	3.47	3.62	3.76	3.90	4.04					
440	2.42	2.64	2.84	3.04	3.21	3.38	3.55	3.70	3.85	3.99						
460	2.47	2.70	2.91	3.10	3.29	3.46	3.62	3.78	3.93	4.08						
480	2.52	2.75	2.97	3.17	3.35	3.53	3.70	3.86	4.02							

The effective durability of a Conveyor belt can be adversely affected by improper handling / storage and the user needs to consider this on priority. Ideally, movement of the belts should be by hoisting and not rolling. A transverse spreader bar is recommended for larger belt rolls in order to hold the lifting chains or cables away from the belt edges. Smaller / lighter belts can be rolled but in the direction the belt is wound.

Careless handling with a forklift can cause damage by rubbing against the forks and hence the roll should first be placed on a pallet. This also avoids damage to the belt because of sagging over the edges of the forks.

If the belt is stored for a year or more, it should be kept on the supplier's reel or hung into an A-frame or placed on a pallet. In any case the storage ground must be even and free from stones etc. The belt should not be exposed to direct contact with stagnant water, oil, grease or any other chemicals that react with rubber. Further protection is usually not necessary for Forech Steel Cord Belts, which are resistant to most environmental influences.