

Bakery and Biscuit Habasit Conveyor and Processing Belts for the Production of Bakery Goods

Habasit–Solutions in motion



Innovation is a key word at Habasit

Industrial food processing requires a wide range of conveyor and processing belts. Habasit has developed an extensive variety of solutions that allow customers to choose the best product for their application.

Special focus of all developments is on the increasing hygiene standards within the food industry. Habasit’s food conveyor and processing belts feature outstanding surface quality due to the calender coating.

Industry know-how, a complete product range, the introduction of new coating materials and unique product construction enable Habasit to offer products that comply with HACCP principles and guarantee trouble-free and safe food production. Beyond this, to provide additional safety, Habasit has recently introduced unique

products such as **HyGUARD®** and **HabaGUARD®** conveyor belts containing antimicrobial additives and **Cleanline®** food belts coated with a modified polyolefine. Additional products like **HabasitLINK®** plastic modular belts and accessories like cleats, edge-sealing profiles and side-walls complete the range. Habasit is the only belt supplier to manufacture and offer the full package of fabric based and plastic modular belts.

More than 50 years of experience

With a comprehensive global network, Habasit is able to respond to any request that you may have with nothing less than an outstanding belting solution of highest quality, tailored to your specific needs.

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Focus on bakery and biscuit processing

Whether handling dough, cooling baked products, molding, cutting or packaging, Habasit offers a complete product range for the bakery and biscuit industry.

This includes all kind of fabric belts and modular belts, either raw or impregnated fabrics as well as different surface coatings. The products consist of polyester, cotton, polyamide or mixed yarns and every product has special features. Habasit applies several coatings in order to achieve a defined surface finish.

Customers can choose well known high quality TPU or cost efficient PVC belts or most modern materials, such as Habilene®, a modified polyolefine coating from the new Cleanline® range.

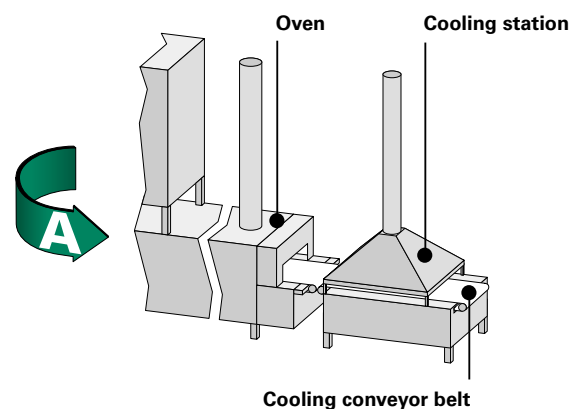
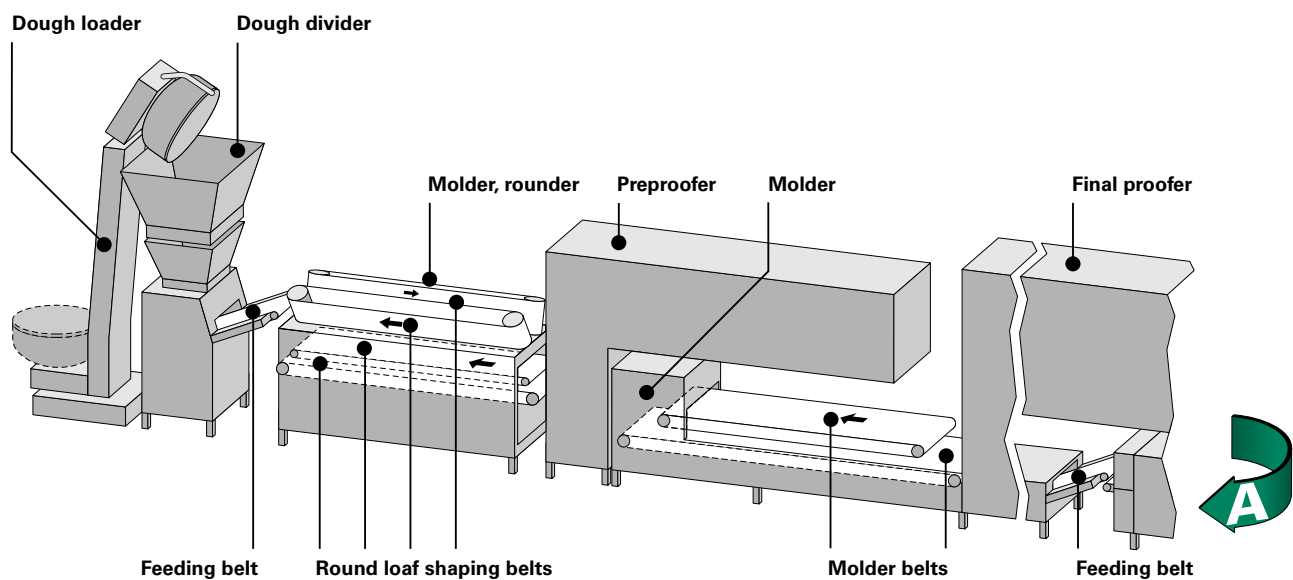
Your manufacturing processes

See the multiple uses of Habasit food conveyor and processing belts on:

- **Hearth bread processing**
- **Bread and bun processing**
- **Puff pastry dough processing**
- **Biscuit manufacturing**

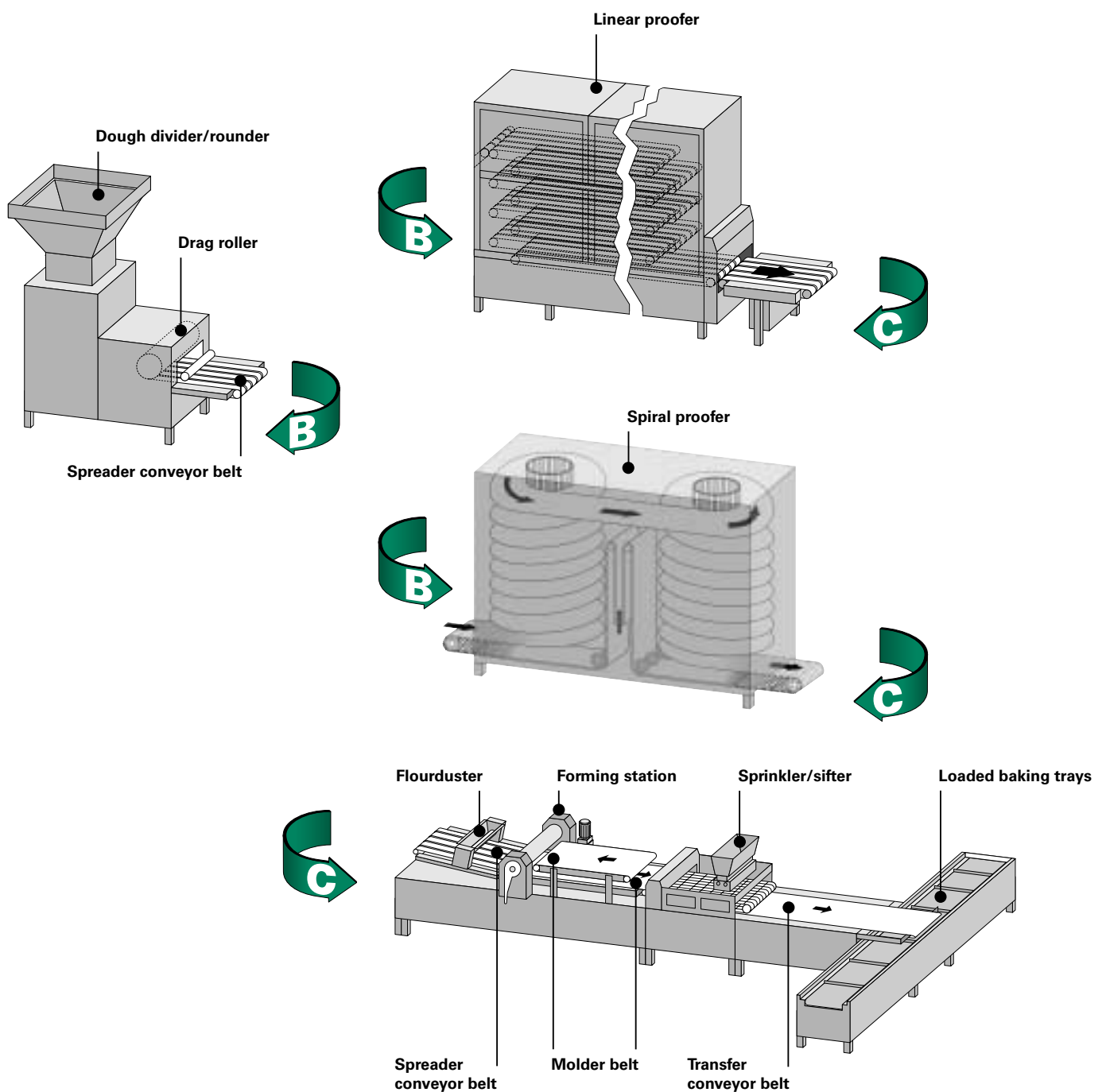
These processes are just samples – Habasit belts can be used in all kinds of baked goods manufacturing.

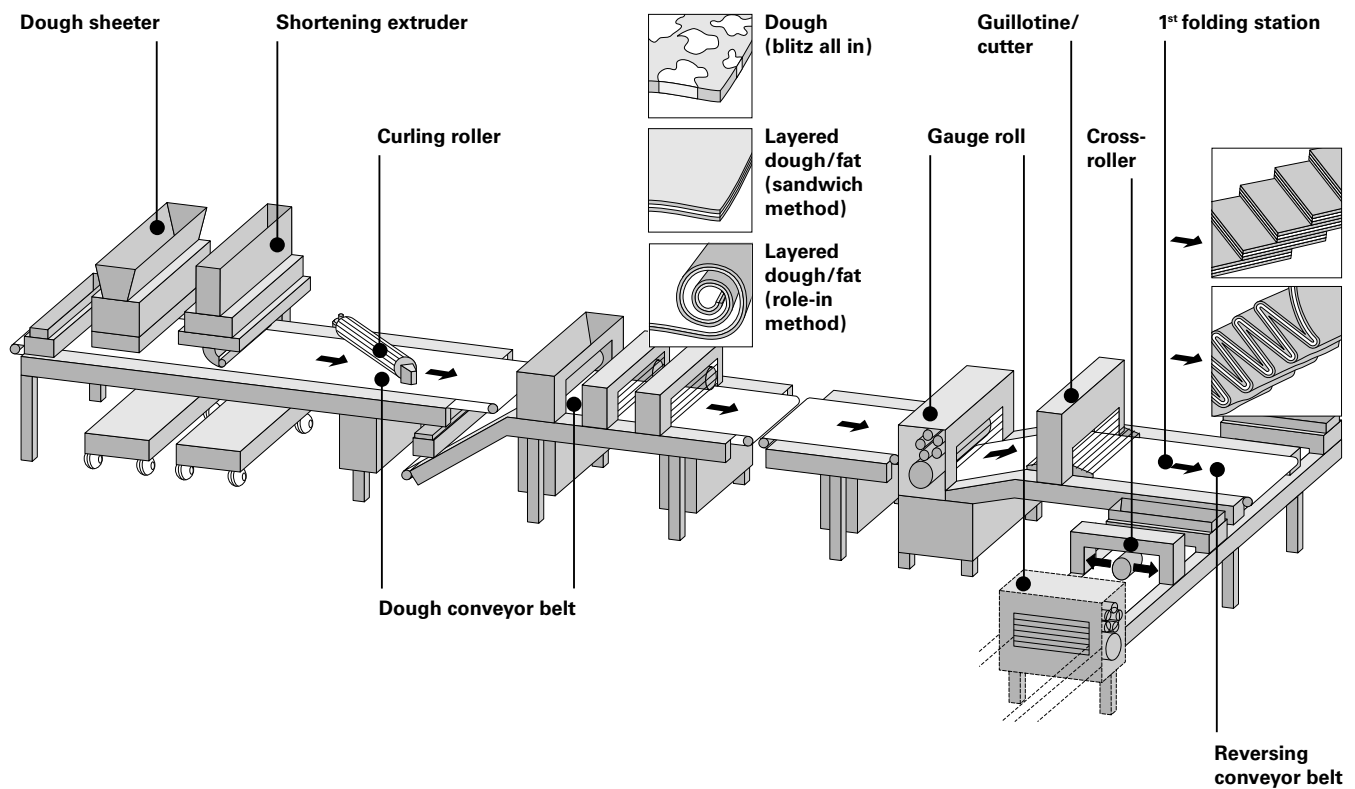




Remark

The drawings show schematic examples of selected applications. The drawings don't lay claim to completeness. The belt recommendations can only be considered as a general hint. Due to the complexity of the various process and technical requirements and the decisive external influences (e.g. humidity, environment or process temperature, additives, recipes, process speed, etc.) there is a large variety of solutions possible.



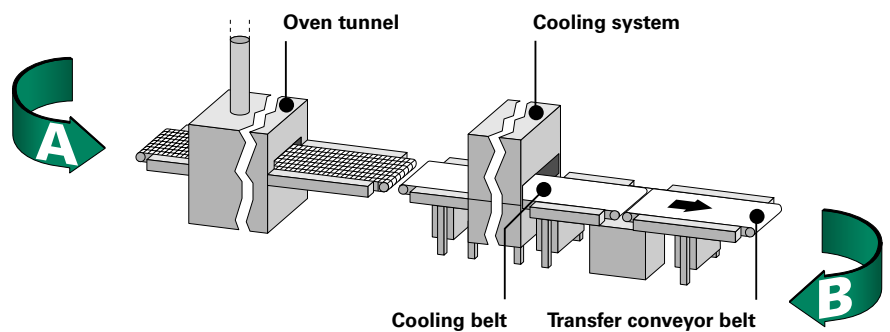
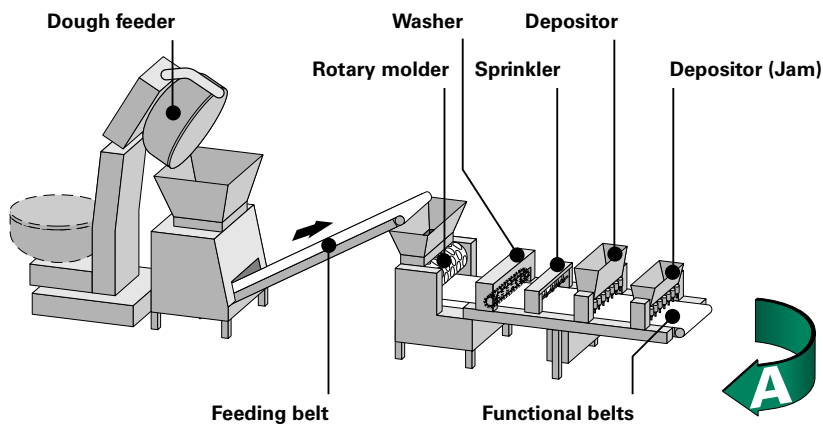


Remark

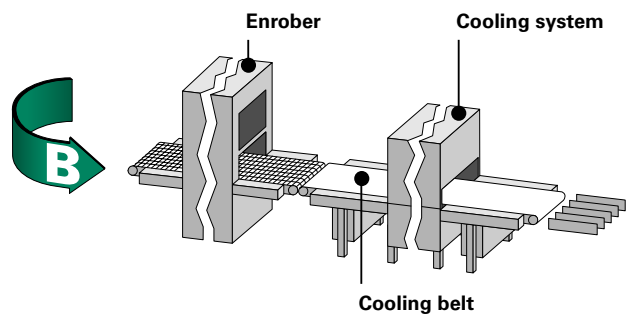
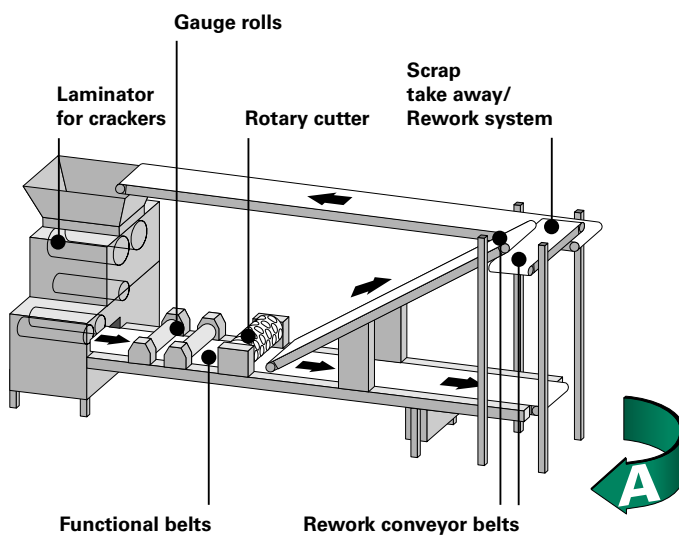
The drawings show schematic examples of selected applications. The drawings don't lay claim to completeness. The belt recommendations can only be considered as a general hint. Due to the complexity of the various process and technical requirements and the decisive external influences (e.g. humidity, environment or process temperature, additives, recipes, process speed, etc.) there is a large variety of solutions possible.



Biscuits



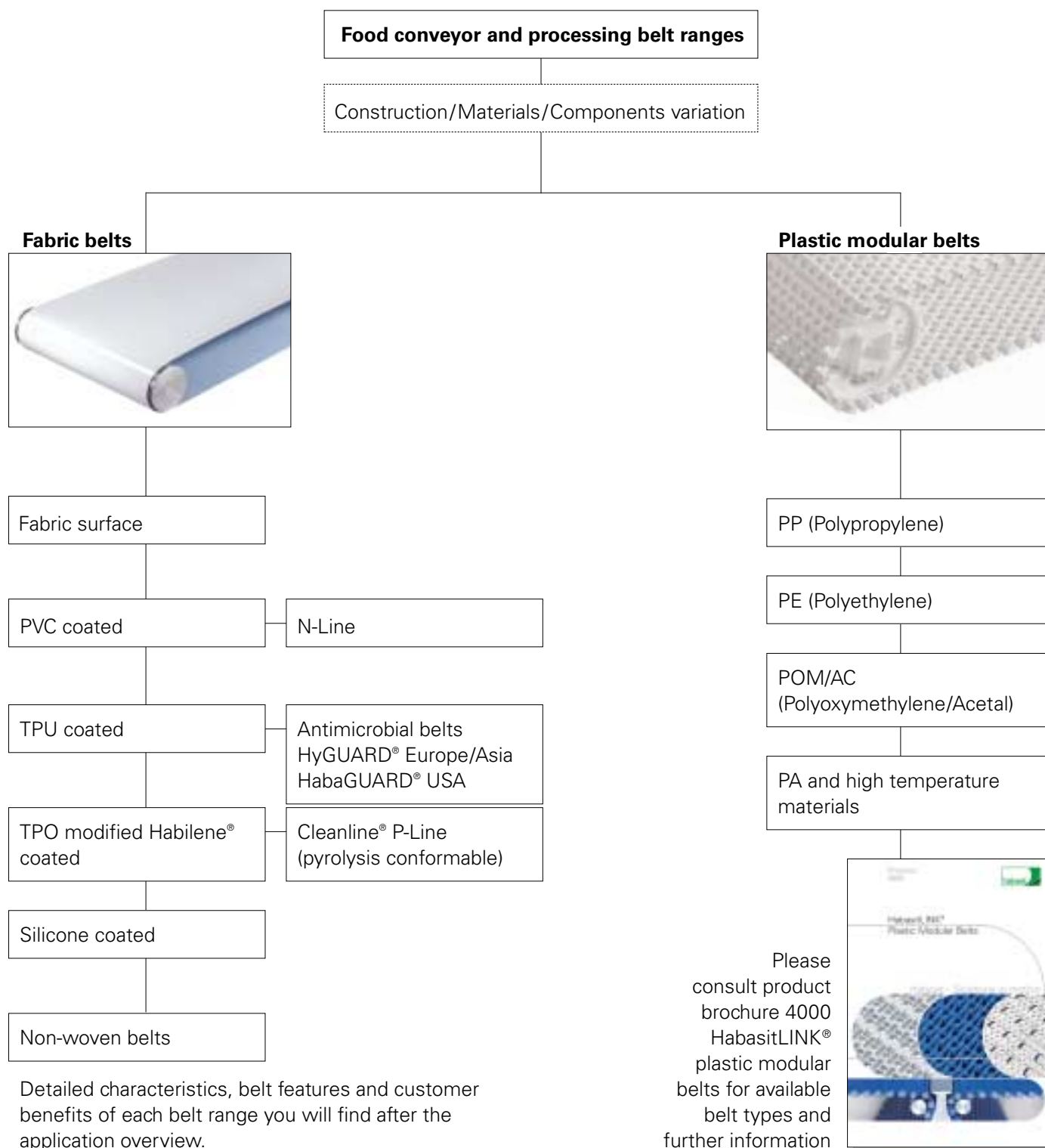
Crackers



The right choice

Habasit has developed an extensive variety of solutions that allow customers to choose the best product for their specific application.

Habasit is the only belt supplier to manufacture and offer the full package of fabric based and plastic modular belts.



Food conveyor belt surfaces

To fulfill a specific process step or a defined function the belt surface plays a key role. Based on surface structure and material inherent

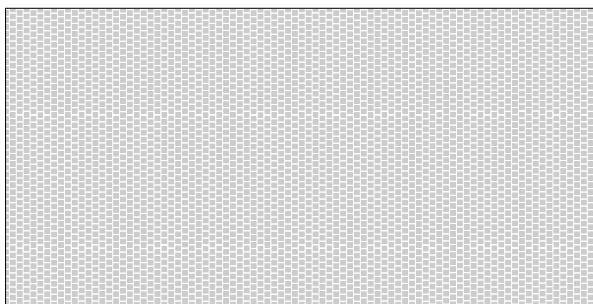
properties a multitude of function possibilities are given. See below some examples of the large variety of surface structures and properties.



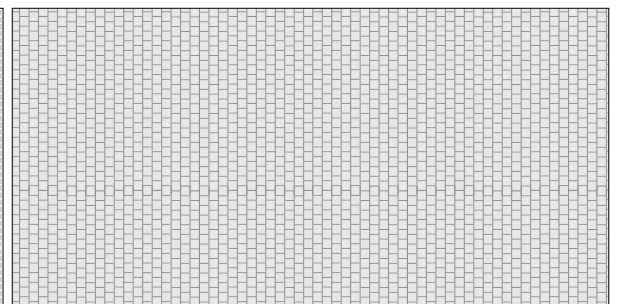
Blank surface (absolutely smooth)

Available belt surface properties

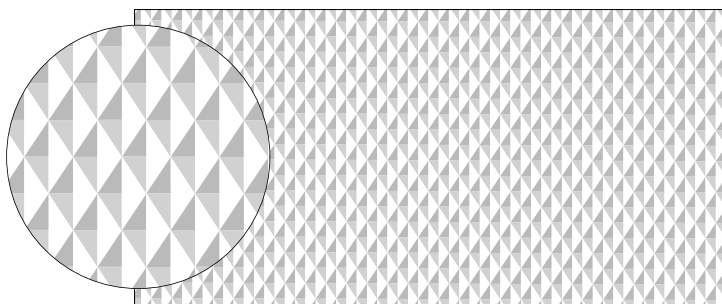
- **Super adhesive**
- **Adhesive**
- **Medium adhesive**
- **Non adhesive**



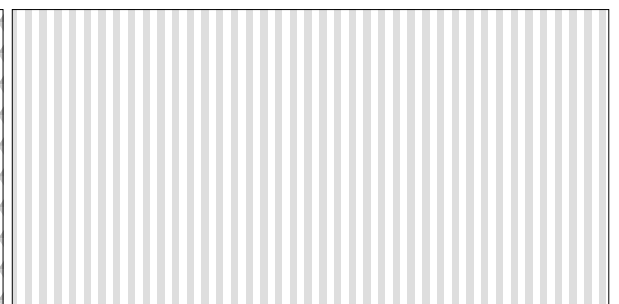
Fabric surface (fine structure)



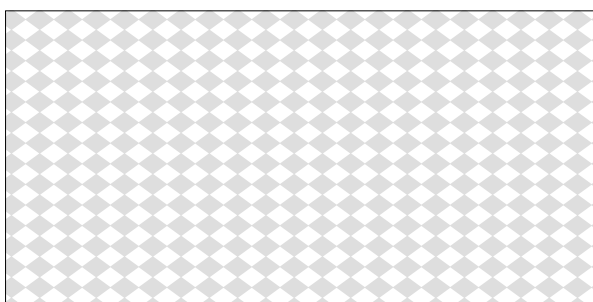
Fabric surface (rough structure)



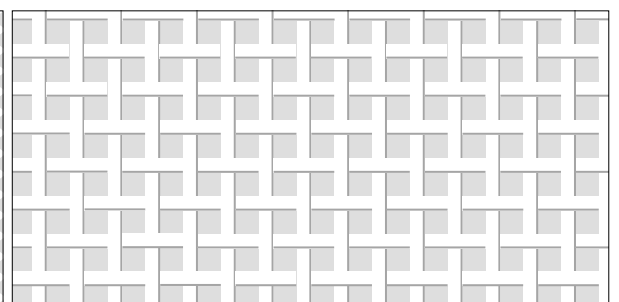
Waffle structure



Saw tooth profile structure



Diagonal rhomboid positive pattern/structure



Quadrillé (quadrangular) pattern/structure

Bakery application and possible belt types (selected types only)

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This application/belt matrix does not apply to be complete and shall serve as indication of potential solutions.

For detailed material and belt selections please contact your local Habasit partner.

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[illegible]

You will find the key data for most Habasit products on the Habasit website:

www.habasit.com

How to find (example)
www.habasit.com

- Worldwide
- Select continent (Europe)
- Select country (Great Britain)
- Products
- Conveyor belts
- Select product group
- Overview

Product code	Technical Data			Product Construction Details					Product Characteristics	
	Thickness (in)	Min. Pulley diameter (in)	Tensile force (lb-ft strength)	Covering Layer				Resistor installation	Assembled	
				Material	Surface	Property	Color			
CRB-100	0.12	1.80	97 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Adhesive	PSA-01	Yes		
CRB-20	0.05	0.5	23 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Adhesive	PSA-02	Yes		
CRB-200	0.03	0.0	17 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Medium adhesive	PSA-03	Yes		
CRB-50	0.05	0.0	20 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Adhesive	PSA-04	Yes		
CRB-2000	0.05	0.0	20 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Medium adhesive	PSA-05	Yes		
CRB-5000	0.05	0.0	20 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Adhesive	PSA-06	Yes		
CRB-500	0.05	0.0	20 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Adhesive	PSA-07	Yes		
CRB-50000	0.04	0.0	19 lbs ft	Stainless (SS)	Black finish	Super adhesive	PSA-08	Yes		
CRB-50	0.05	0.75	40 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Adhesive	PSA-09	No		
CRB-1000	0.12	1.80	97 lbs ft	Polysulfone thermoplastic (PSA)	Polysulfone structure	Adhesive	PSA-10	No		
CRB-500	0.05	1.0	40 lbs ft	Polysulfone thermoplastic (PSA)	Grainless profile structure	Adhesive	PSA-11	No		
CRB-50	0.05	0.0	34 lbs ft	Polysulfone thermoplastic (PSA)	marble structure	Adhesive	PSA-12	Yes		
CRB-50	0.05	1.20	20 lbs ft	Thermoplastic (TP)	Black finish	Ultra glossy finish, self-healing	PSA-13	No		
CRB-1000	0.05	1.0	40 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Medium adhesive	Thermoplastic (TP)	No		
CRB-2000	0.02	0.0	17 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Medium adhesive	Thermoplastic	Yes		
CRB-500000	0.05	0.00	20 lb lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Medium adhesive	PSA-14	No		
CRB-5000	0.05	0.0	97 lbs ft	Polysulfone thermoplastic (PSA)	Black finish	Medium adhesive	PSA-15	Yes		

Detailed technical data for each product/belt type

With one more click on the respective belt type, you will obtain a technical data overview, showing details such as:

- Product designation/features
- Product design/built-up
- Product characteristics
- Technical data etc.

Product Data Sheet CNW-5E					
Product Designation					
Product Group		Chlorine sanitizer and processing belts			
Sub Applications		Cooling loop belt, General conveying belt, Supermarket belt, Material/transportation belt, Packaging belt, Processing belt, Transfer belt, Weighing belt			
Main Industry Sectors		Bakery (bread/baking), Bakery (dried), Cheese, Chocolate/confectionery, Food processing, Food packaging, Meat, Poultry, vegetables			
Special Features		Easy cleanability, Easy release property, Hydrophobic treatment, Taste neutral			
Made in the Consequence		Manufactured in Korea			
Product Design (enlarged)					
					
Product Construction/Design					
1. Conveying Side (Material)		Synthetic (modified PVC)			
2. Conveying Side (Surface)		Smooth structure			
3. Conveying Side (Property)		Non-adhesive			
4. Conveying Side of steel		White			
5. Backing Layer (Material)		Polyurethane (PVC) with conductive fill			
Number of plating		2			
6. Backing Side/Pulley Side (Material)		Polyurethane (PVC) integrated with			
Product Characteristics					
Slitter test suitability		Yes			
Carrying surface suitability		Yes			
Carrying load suitability		No			
Power transmission suitability		No			
Resistant substances		No			
Permanently adhesive		Yes			
Metals detector suitability		Yes			
Flammability		No specific flammability prevention property			
Food suitability, risk confirmation		Yes			
Food suitability, which recommendations / standards to		Yes (directive 85/378/EEC)			
Food suitability, 6H confirmation		Yes (directive 85/378/EEC)			
Other confirmation approval		None			
All data are approximate values under standard climatic conditions: 23°C/77°F, 50% relative humidity (EN 50065:2010)					
Technical Data					
Thickness		1.9 mm			
Mass of belt (belt weight)		1.0 kg/m ²			
Residual flexion (point-to-point)		50A mm			
Pulley diameter (point-to-point)		50 mm			
Pulley diameter minimum with counter flexion		50 mm			
Tensile force for 1% elongation (1% static pull-out of width (reference standard EN 808))		40 N/mm			
Admissible force, force per unit of width		10 N/mm			
Operating temperature (admissible performance)		-40~+50 °C			
Coefficient of friction on driving pulley of steel		0.15 ~ 0.2			
Coefficient of friction on driving pulley with friction cover		0.30 ~ 0.4			
Coefficient of friction on slider belt of stainless steel sheet		0.20 ~ 0.3			
Coefficient of friction on slider belt of polished metal sheet		0.15 ~ 0.2			
Respective manufacturing width		2400 mm			
See separate offer: respective manufacturing width		No, yes			
All data are approximate values under standard climatic conditions: 23°C/77°F, 50% relative humidity (EN 50065:2010)					
Chemical Resistance					
Chemical Resistance Class		0 (No details are possible according to EN 12311-1)			
Resistance to acids		10% Hydrochloric acid			
Resistance to alkalis		10% Sodium hydroxide			
Resistance to organic solvents		10% Acetone			
Resistance to oils		10% Mineral oil			
Resistance to greases		10% Grease </			

Legend/remarks

PVC = Polyvinylchloride
TPO = Polyolefine thermoplastic
TPU = Polyurethane thermoplastic

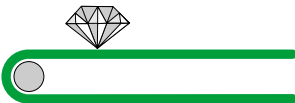
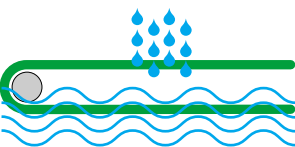

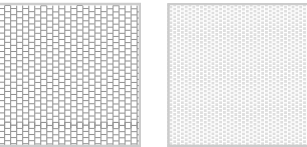

Features and benefits

Fabric based belts



Fabric surface

Food conveyor belts with fabric surfaces are often used in bakery applications. However, impregnated fabric belts can be also installed in other machines, for example checkweighers. Depending on the consistency of a respective kind of dough, Habasit is offering different product constructions, including belts made from felt-like Non-Woven material (PET-fibres, needled and buffed construction).

	Features	Benefits
	<ul style="list-style-type: none"> • High strength 	<ul style="list-style-type: none"> • Good wear/abrasion resistance • Long service life
	<ul style="list-style-type: none"> • Dimension stability in water (PET fabrics) 	<ul style="list-style-type: none"> • Water absorption, no elongation • Excellent tracking
	<ul style="list-style-type: none"> • Impregnated fabric 	<ul style="list-style-type: none"> • Less soiling • Reduced cleaning time/cost • Hygiene support
	<ul style="list-style-type: none"> • Rough or fine surface structure 	<ul style="list-style-type: none"> • Good release of raw dough
	<ul style="list-style-type: none"> • Mixed yarns 	<ul style="list-style-type: none"> • Different solutions available depending on consistency of dough (oil, fat, moisture)

PVC coating

PVC is widely used in food applications and is often a cost saving solution.



	Features	Benefits
	<ul style="list-style-type: none"> • General conveying 	<ul style="list-style-type: none"> • Products for a wide variety of applications available • Cost saving solution
	<ul style="list-style-type: none"> • Chemical resistance 	<ul style="list-style-type: none"> • Cleaning with chlorine containing detergents possible

TPU coating

TPU food conveyor belts combine many features that are supporting reliable and hygienic production processes. Habasit offers TPU belts in different constructions, different colors and different surface finishes.



	<ul style="list-style-type: none"> • Longitudinal flexibility 	<ul style="list-style-type: none"> • Smallest pulley diameters • Smooth and trouble free product transfer
	<ul style="list-style-type: none"> • Calendered coating 	<ul style="list-style-type: none"> • Closed, most homogeneous surfaces • Reduced soiling of conveyor belts • Good release properties • Increased hygiene
	<ul style="list-style-type: none"> • Oil and fat resistance 	<ul style="list-style-type: none"> • Reliable transport • Long service life
	<ul style="list-style-type: none"> • Temperature resistance 	<ul style="list-style-type: none"> • Usable in low temperature environment and warm conditions without changing its features • High temperature belts product up to 100 °C available
	<ul style="list-style-type: none"> • Non-fray fabrics 	<ul style="list-style-type: none"> • Reduced risk of product contamination • Increased service life

Features and benefits

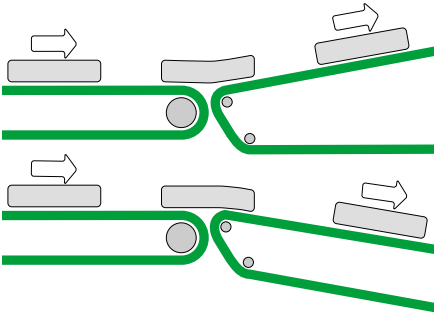
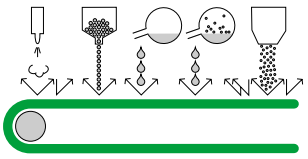

Fabric based belts



Habilene® coating

(Thermoplastic polyolefine = Habilene®)

Habilene® (a Habasit modified Polyolefine) is the newest development of Habasit which provides unique features among food conveyor belts.

Features	Benefits
 <ul style="list-style-type: none"> • Excellent release properties 	<ul style="list-style-type: none"> • Excellent release of sticky products • Less soiling • Increased hygiene and product quality • Reduction of waste
 <ul style="list-style-type: none"> • Very good chemical resistance 	<ul style="list-style-type: none"> • Cleaning with aggressive chemicals, such as chlorine, possible • No surface damage due to cleaning agents • Longer service life
 <ul style="list-style-type: none"> • Environmental friendly product construction 	<ul style="list-style-type: none"> • Belts contain no glues or toxic chemicals • HACCP support, reduced risk of contamination • Lower belt disposal costs

Features and benefits

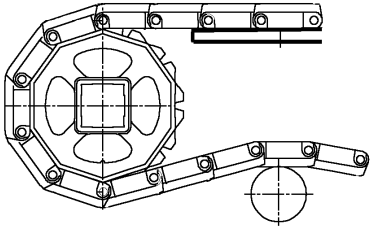
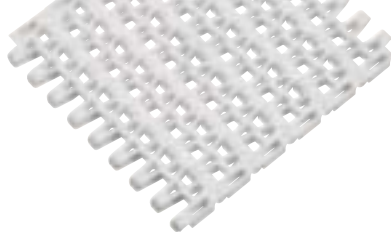

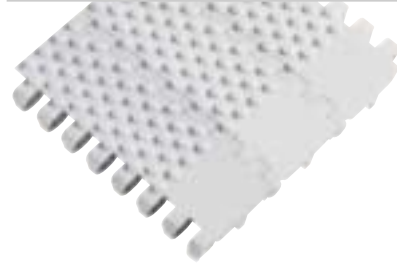
Modular belts

Plastic modular belts

Based on our comprehensive experience and our leadership position in fabric belting, Habasit has developed the HabasitLINK® modular belts range. Completely ejector mark free surfaces, rounded edges, smooth designs stand for state-of-the-art hygienic modular belting. Where downtime needs to be reduced to a minimum or where repairs are



difficult to access modular belts are becoming the preferred solution.

	Features	Benefits
	<ul style="list-style-type: none"> • Positive drive and tracking by positively engaged belt • Guided belt alignment 	<ul style="list-style-type: none"> • No need of tensioning devices • Reliable tracking • Elimination of belt edge damage • Simple system design
	<ul style="list-style-type: none"> • Various open area belt styles • Smooth rounded design 	<ul style="list-style-type: none"> • Uniform and fast cooling • Air and water permeability • Easy release of sticky goods • Support of cleaning and sanitation measures • Higher productivity/throughput
	<ul style="list-style-type: none"> • Radius and straight transport • Strong design 	<ul style="list-style-type: none"> • Longer runs without transfers • Less disorientation • Less product damage
<p>PP = Polypropylene PE = Polyethylene POM/AC = Polyoxymethylene/Acetal PA = Polyamide HT and ST = special Materials</p>	<ul style="list-style-type: none"> • Large variety of plastic materials available • High temperature materials available up to 240 ° C 	<ul style="list-style-type: none"> • Adaptation to process/application • Large temperature range suitable (pre oven, past oven applications) • PE = easy release • PE, PP = excellent chemical resistance
	<ul style="list-style-type: none"> • Rough and rugged application suitable (frozen food) 	<ul style="list-style-type: none"> • Heavy duty rod and belt material available • High lateral stiffness (e.g. for wide elevators)

Offering a comprehensive range of services is part of Habasit's belting solutions approach. We are committed partners of our customers, and we consider the sharing of knowledge and providing of support as an essential task. And this we offer:



Consulting and technical support

Habasit offers the best consulting and technical support on the belting market for fabric belts and plastic modular belts based on the experience and competence acquired in more than 50 years.

Belt selection and calculation

For our customers we select and calculate the most suitable belt for a specific application. However, customers may do it themselves thanks to the state-of-the-art Habasit selection and calculation programs "SeleCalc." For ordering these programs free of charge simply call the nearest Habasit partner or contact: info@habasit.com

CONVEY-SeleCalc = Fabric conveyor belt selection and calculation
LINK-SeleCalc = Plastic modular belt selection and calculation



Fabrication or installation

We join fabric belts or install modular belts at our locations or on-site directly on the machine or on the system.

Shortest lead times

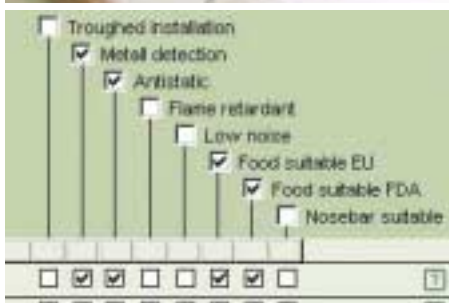
Habasit owns 25 Affiliated Companies located in North America, Europe, Japan and Asia, each with own inventory, fabrication, assembling and service facilities.

Together with our country managers, representative offices and a large number of qualified distributors we are in a position to react quickly, competently and reliably to customers' demands.



Installing service at hand

We are where the customers are, and our committed staff is always available for their specific needs. We offer on-site installation on an international scale.





Testing at customer's site

We are testing process functionality, alternative products, and variations of fabric belts or modular belts at the customer's site.

Legal and conformity check

We are supporting our customers with respect to declaration issues, conformity issues, conformance with national laws/authorities like FDA, USDA, EU, etc.



Process optimization proposals

We analyze processes together with the customer and submit proposals for optimization, e.g. added value for the machinery/process output, output increase.

Belt repair

We have developed sophisticated repair methods and equipments with proven effectiveness.



Special belt fabrication

We offer special fabrications, such as longitudinal joining, edge sealing, profile welding, guide profiles welding, hole punching, curve conveyor layout/cutting preparation, etc.

Joining tools and auxiliary equipment

Fabric belt joining (fabrication) tools and handling/process auxiliary equipment are available.



Education / Training

Habasit organizes programs and provides supporting tools to ensure optimal selection and use of our products and prolonging their life cycle. Fabrication, installing, assembling, maintenance and belt repair training is carried through at Habasit's or at customer's site.

Specific application knowledge transfer

Habasit provides application specific knowledge transfer for process specific issues to allow for optimal use of our products and to optimize machinery and processes (e.g. cleaning, hygiene/sanitation).





Designing the future “Partner in Design”

Habasit believes in partnership. For joint design developments our engineering team is looking for strong cooperation with the customer’s engineering team, preferably at a very early stage. We offer this cooperation to large customers.

Co-design: We work together for success.



Testing for customer

We offer our R & D expertise, laboratory and test equipment for the customer’s specific process needs like mechanical endurance testing, chemical or thermal testing.



Belt monitoring / inspection

A customizing Habasit service that includes maintenance, regular belt monitoring reports, regular review meetings with the responsible for process/production at customer’s site.



Customized service agreements

According to the specific needs of our customers we offer customized services like inventory, emergency service, belt exchange services or order/re-order management.

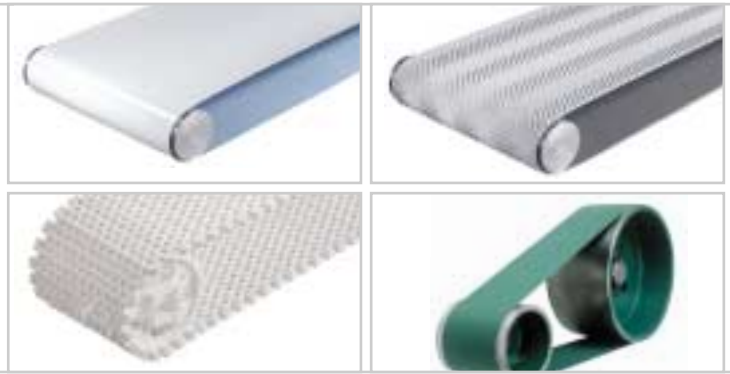
Project management

We are experienced partners for belting project co-ordination on an international scale for globally operating customers.



The Habasit Solution

**At Habasit, we listen. We innovate.
And we deliver integrated belting
solutions – right first time.**



Customer first

Habasit understands that our success depends on the success of our customers. That's why we offer solutions, not just products; partnership, not just sales. Our innovative belting solutions are tailored exactly to specific needs. We guarantee best value for money in every application. Since its foundation in 1946, Habasit has proven this understanding of customer needs for more than 50 years. That's why we are no. 1 in belting. Worldwide.

Product range

Habasit offers the largest selection of fabric and plastic modular belts in the industry. Our answer to any request is nothing less than a specific, tailor-made solution.

Fabric conveyor & processing belts

Plastic modular belts

Power transmission belts

Machine tapes

Seamless belts

Round belts

Timing belts

Auxiliaries (e.g. profiles, tools)



Innovation / R&D

Habasit is strongly committed to the continuous development of innovative, value-added solutions. More than 3 % of our staff is dedicated exclusively to R&D; the annual investment in this area exceeds 8 % of the turnover.



Global network

Facts & figures

Founded	1946
Turnover 2002	CHF 422 million
Sales to market	4 million m ²
Employees	2200
Production plants	12
Affiliated companies	25
Representatives	50 countries
Service centers	250 globally

Services & guarantees

Our extensive organization is prepared to support you anywhere in the world. Engineering and emergency assistance, quotes and order status are just a phone call away. Wherever you are. Whenever you need us.

Quality

Highest quality standards are found not only in products, but also in our employees' daily work process. Based on a worldwide TQM approach, Habasit started very early to implement a quality system and was certified already in 1987 according to ISO 9001 / EN 29001. In 1996 Habasit was certified according to ISO 9001:1994. Since then we undergo periodically quality audits performed by an independent certification body. In the year 2002 we achieved certification according to the revised standard ISO 9001:2000.



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