

Conveyor Belt Group

CONTI®
Round Baler Belts
for hay, straw and
silage presses



CONTI® round baler belts are highly resilient and low-stretch. A patented production process guarantees long service life.

Conveyor Belt Group CONTI® round baler compressor belts

In 1972, the first round balers were produced and sold. Today they are the most commonly used type of balers. The grass baled is rolled up inside, with a variable chamber making use of rubberized belts and a fixed chamber employing steel rollers. Once the bale attains a predetermined size, it is wrapped with netting or twine. The baler then opens in the rear to discharge the bale.

We at the Conveyor Belt Group (CBG) started producing the first round baler belts for variable chamber presses in the early eighties. The original belts were lacer belts cut into narrow sizes on a roll. In other words, we have been gathering experience in the production of round baler belts for nearly 25 years.

In collaboration with leading European press manufacturers, we develop new technologies both for the press mechanics and for the composition of the belts. We supply most European bale press OEMs our agriculture belts for new equipment.

We can likewise satisfy requests for replacement parts in compliance with or surpassing original equipment specifications. Variable presses are commonly available in two sizes. We service these applications with belts made of rubber and reinforced with fabric in lengths of approx. 10 m and 13 m.

The width depends on the design of the machine: Narrow belts make necessary more belts per machine than wider ones. Press producers are chiefly interested in minimizing the number of belts. Most want just one belt with a width of approx. 1200 mm. Generally, the belt widths of big-name baler press OEMs vary between approx. 180 mm and 600 mm.



Baler presses break down into fixed and variable baler presses.

- Fixed-chamber baler presses do not use rubber belts. They make bales with metal rollers, plungers or the like.
- Variable baler presses are equipped with chains or rubber belts.

Endless wrapped belts

In 1998, CBG began exploring the possibility of developing production of “really” endless baler belts, employing a special endless wrapping manufacturing process in Germany. In 2001, a major baler press OEM was supplied for the first time with an industrially manufactured endless wrapped belt.

So far, we are the only manufacturer with a patented a process for producing endless wrapped belts. This is our force and special expertise.

As their chief advantage, endless belts boast extremely high tear resistance and thus long service life. The variable press seems to be gaining the upper hand.

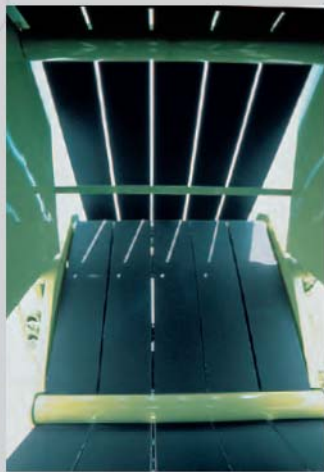
This is because it makes possible a broad range of bale sizes.

The switch from lacer belts to endless (wrapped) belts provides other benefits for the customer. These include longer wear as well as better and easier baler wrapping. Both are important because farmers are mainly interested in high baler output.

The first machines produced had up to 8 lacer belts per machine. By contrast, a standard machine nowadays is generally supplied with just four to two endless wrapped belts!

Type of construction

Type	RCP 43 GS/GS	HEP X 503-60MF/FS	PEEPE-L-GS60/GL	EP X31D-GS73/GS	PEP X-GS60/GS
Tension member	P and EP spezial fabric	P and EP spezial fabric	PE and E spezial fabric	EP spezial fabric	PE and E spezial fabric
Number of plies	3	3	3	1	3
Breaking strength (N/mm)	> 400	> 500	> 400	> 315	> 400
Elongation at break (%)	> 10	> 10	> 10	> 10	> 10
Shore hardness (Shore A)	57	60	60	73	60
Pattern					
top cover (mm)	coarse cloth impression	coarse duck impression	coarse cloth impression	coarse cloth impression	coarse cloth impression
bottom cover (mm)	coarse cloth impression	fine cloth impression	smooth finish	coarse cloth impression	coarse cloth impression
Belt thickness (approx. mm)	5.4	6.5	6.0	6.0	6.0
Maximum belt width (mm)	1320	1300	1300	1320	1300
Bale chamber system	variable	variable	variable	variable	variable
Available belt width (mm)	100 - 1300	100 - 1300	100 - 1300	100 - 1320	100 - 1300
Splicing system	Hook fastener	Hook fastener	Hook fastener	Hook fastener	Hook fastener
Splicing type	Clipper HAT 4½ RT or MATO U24B	Clipper HAT 4½ RT or MATO U24B	MATO U24BS	MATO U24BS	MATO U24BS
Pictures					



ContiTech supplies baler belts with the following basic and visible differences:

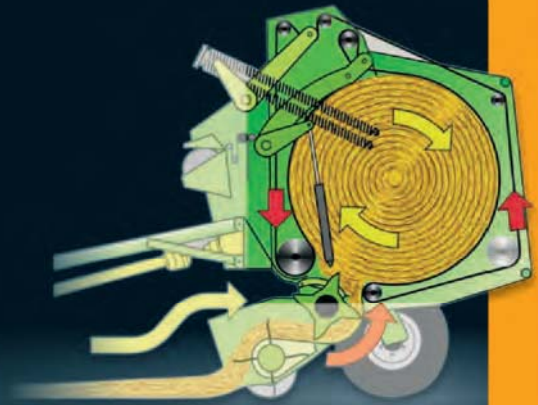
- ▶ Different types and compounds
- ▶ Different fabrics used together
- ▶ Different number of plies
- ▶ Different profiles for top and bottom cover
- ▶ Different splices:
 - Endless wrapped
 - Endless hot-spliced
 - Spliced with hook fasteners
 - Endless cold-spliced

PEP5-73DR/GLATT	EP X42-GS60/GS-EGW	PE-X GS60/GS	EP X 52-GS60/GS-EGW
PE and E spezial fabric	EP spezial fabric	EP spezial fabric	EP spezial fabric
3	2	1 or 3	2
> 400	> 400	> 400	> 500
> 10	> 10	> 10	> 10
73	60	60	60
rhombical step profile	coarse cloth impression	coarse cloth impression	coarse cloth impression
smooth finish	coarse cloth impression	coarse cloth impression	coarse cloth impression
9.5	7.4	5.0	7.2
1246	1300	1300	1300
variable	variable	variable	variable
100 - 1246	100 - 1300	100 - 1300	100 - 1300
Hook fastener	endless wrapped	Hook fastener	endless wrapped
MATO U24BS	endless	MATO U24BS	endless
			



Benefits of ENDLESS WRAPPED CONTI® round baler compressor belts

- ▶ Provide steady and settled operation in the bale chamber
- ▶ Are not prone to belt reversion
- ▶ Fasteners do not cause any annoying guide disturbance
- ▶ Extremely high tensioning strength assures highly compressed density
- ▶ Belts' ultra long life assures high baler output
- ▶ No destruction of hooks during mesh winding
- ▶ Five times higher productivity in comparison to hook-fastened belts (measured in quantity of bales produced)



ContiTech Conveyor Belt Group

As manufacturers of textile and steel cable conveyor belts, special products, and service material, we aim to satisfy the requirements in mining, machine and plant engineering, and many other branches of industry.

At our plant in Northeim, Germany – one of the most modern production facilities anywhere in the world – we turn out a complete range for all conveyor jobs. Our comprehensive service offering caters to the needs of retailers, primary equippers and operators.

www.contitech.de
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Conveyor Belt Group

Market segment
Engineered Products

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The ContiTech division of the Continental Corporation is a development partner and original equipment supplier to numerous industries for high-quality functional parts, components and systems. With its know-how in rubber and plastics technology, ContiTech contributes significantly to industrial progress and mobility that is safe, comfortable and eco-friendly.

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