

Tobacco Industry Habasit Conveyor and Processing Belts for the Cigarettes Manufacturing

Habasit – Solutions in motion



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Product liability, application considerations

If the proper selection and application of Habasit products are NOT recommended by an authorized Habasit sales specialist, the selection and application of Habasit products, including the related area of product safety, are the responsibility of the customer.

All indications / information are recommendations and believed to be reliable, but no representations, guarantees, or warranties of any kind are made as to their accuracy or suitability for particular applications. The data provided herein are based on laboratory work with small-scale test equipment, running at standard conditions, and do not necessarily match product performance in industrial use. New knowledge and experiences can lead to modifications and changes within a short time without prior notice.

BECAUSE CONDITIONS OF USE ARE OUTSIDE OF HABASIT'S AND ITS AFFILIATED COMPANIES CONTROL, WE CANNOT ASSUME ANY LIABILITY CONCERNING THE SUITABILITY AND PROCESS ABILITY OF THE PRODUCTS MENTIONED HEREIN. THIS ALSO APPLIES TO PROCESS RESULTS / OUTPUT / MANUFACTURING GOODS AS WELL AS TO POSSIBLE DEFECTS, DAMAGES, CONSEQUENTIAL DAMAGES, AND FURTHER-REACHING CONSEQUENCES.



Conveyor and processing belts for green leaf processing, primary processing, secondary manufacturing and logistic equipment.

Tobacco processing requires a wide range of conveyor and processing belts. They are key machine elements which assure an efficient and trouble free flow of materials literally through all different manufacturing stages. 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 safety standards within the tobacco industry therefore our P-Line products are pyrolysis conform and comply with FDA guidelines.

P-Line:

A comprehensive product range of polyolefine coated belts for the tobacco industry – now extended by products with a new thermoplastic polyester elastomer coating. "P" implies:

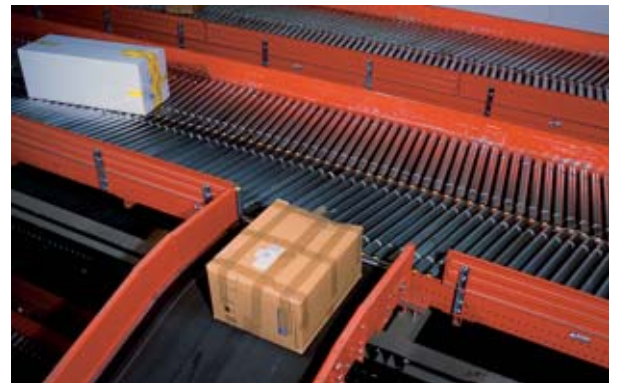
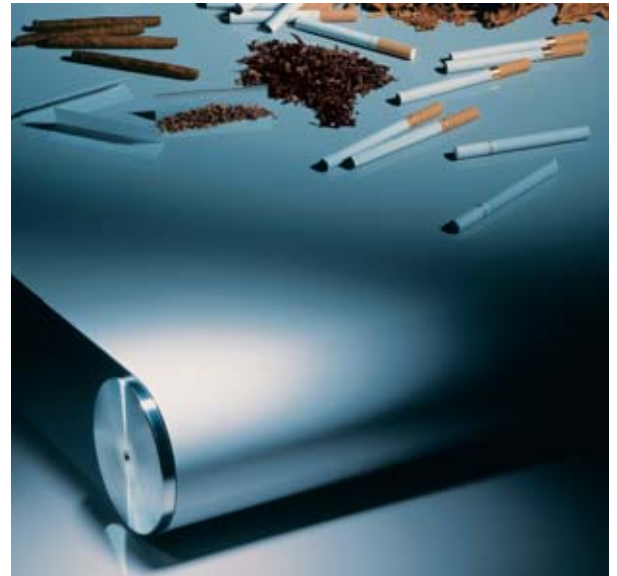
- **P**olyolefine and
- **P**olyester, the raw materials used
- **P**yrolysis conformable
- **P**hysiologically safe
- **P**ure, a pure coating and product construction.
No bonding layers or adhesives, so when burning no dangerous substances are set free – environmental friendly approach.
- **P**olyvalent, a product which can be used in a wide variety of applications, besides tobacco.

Innovation is a key word at Habasit

The extensive variety of solutions enables our customers to choose the best product for their application.

Competence and experience

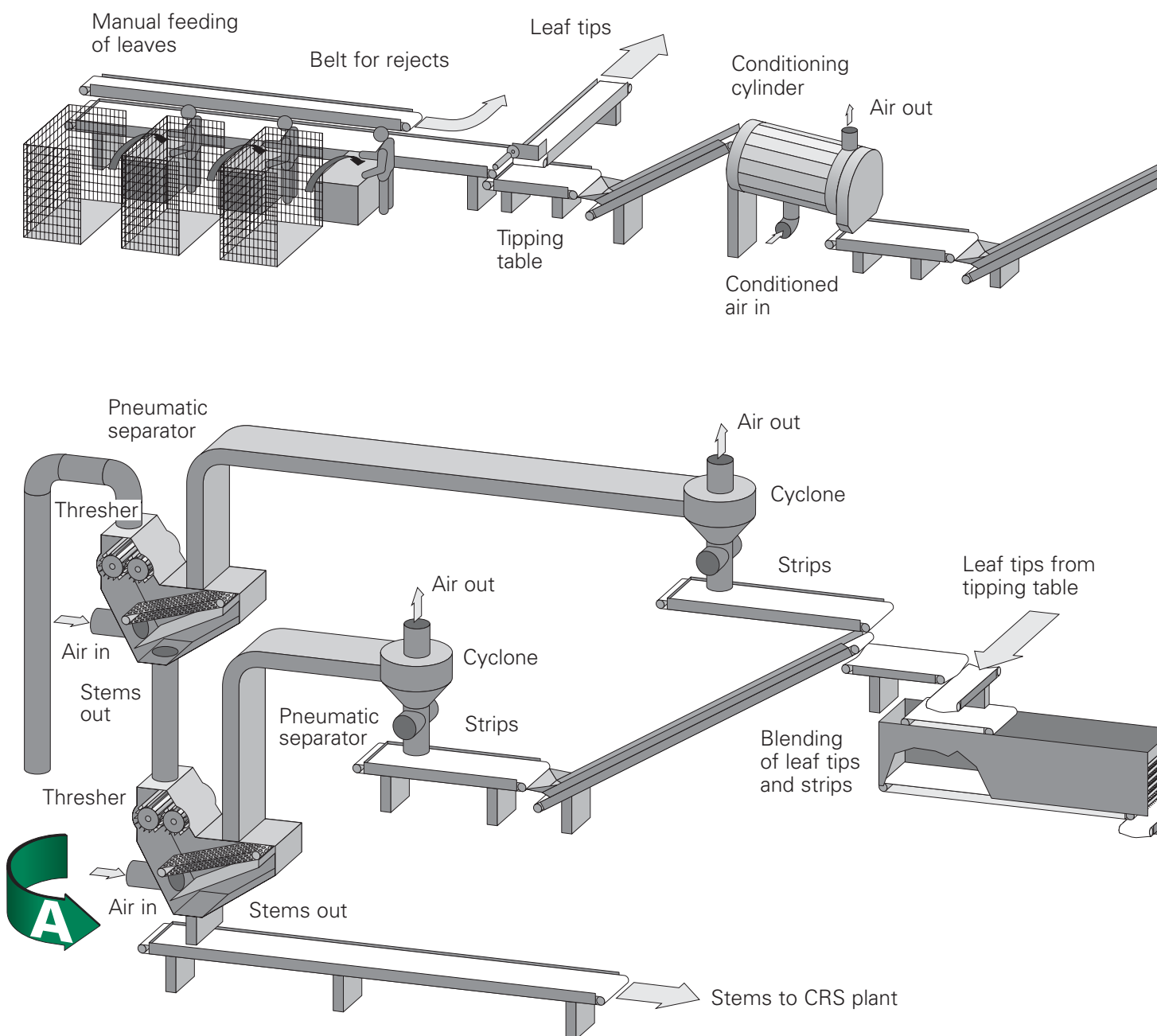
Habasit application engineers, technicians and joining specialists are at your disposal to provide professional consulting, superb customer service and excellent support. Since its foundation in 1946, Habasit has proven this understanding of customer needs for more than 60 years. With a comprehensive global network, Habasit is able to respond to any request that you may have with nothing less than outstanding belting solutions of highest quality, tailored to your specific needs.



Green Leaf Processing

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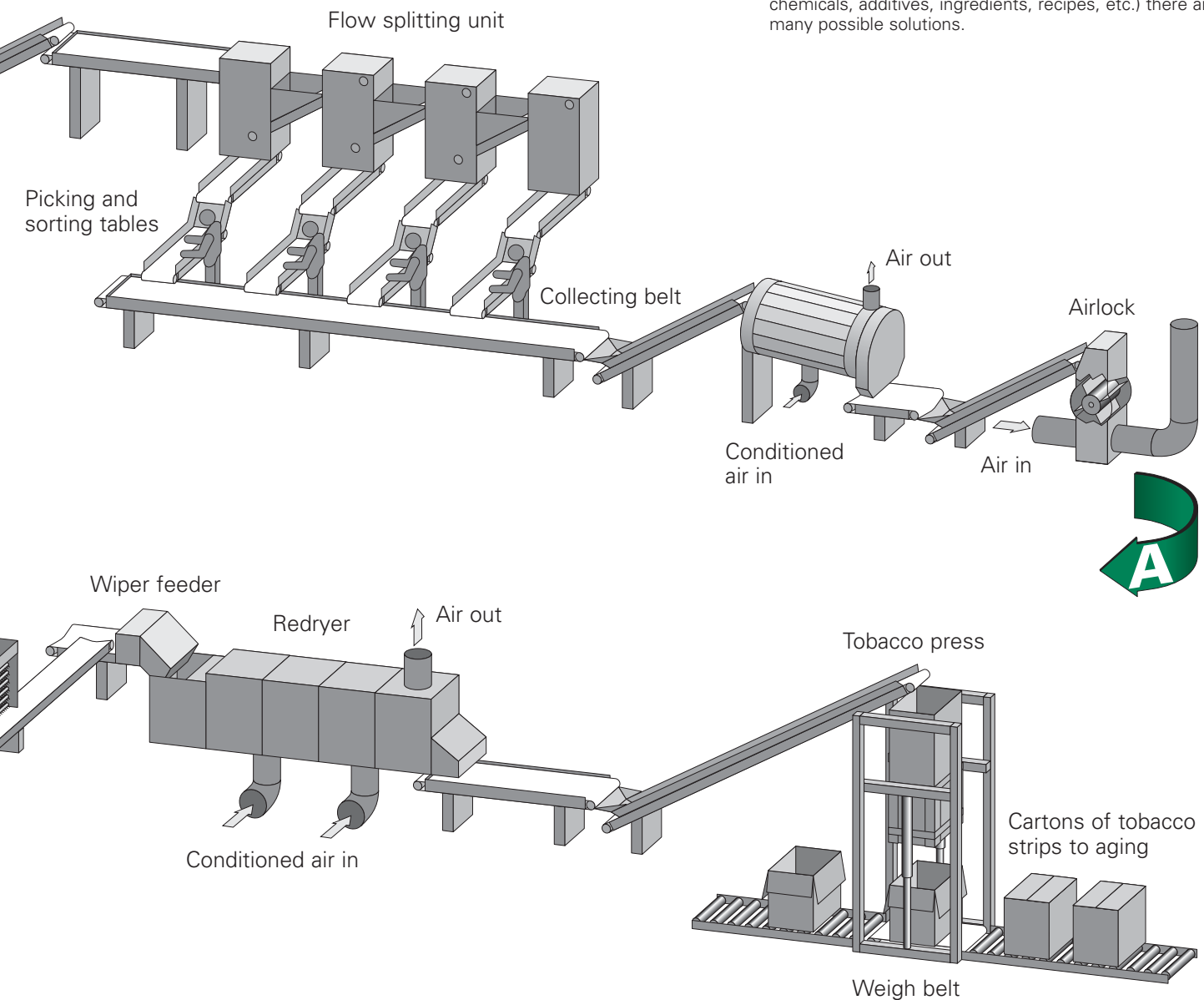
Picking and Sorting of Leaf Bundles → Threshing → Baling →

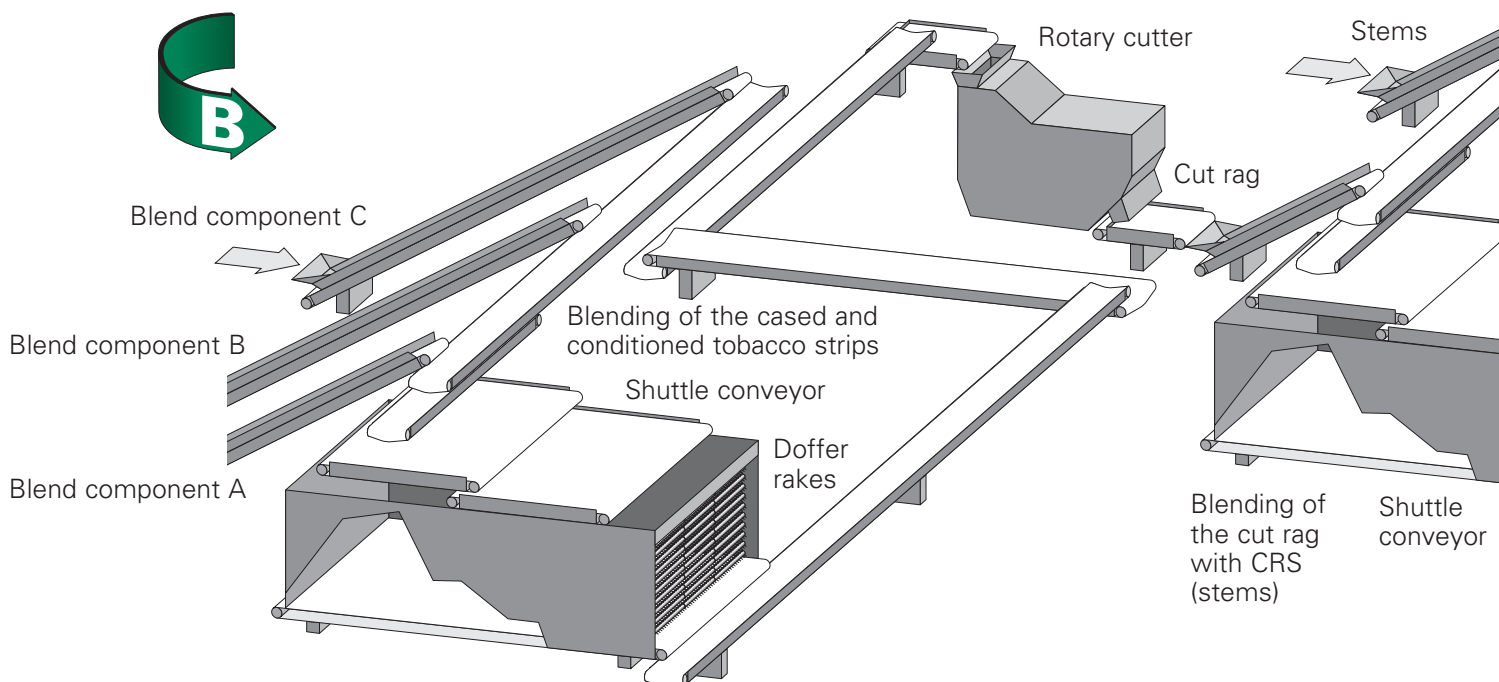
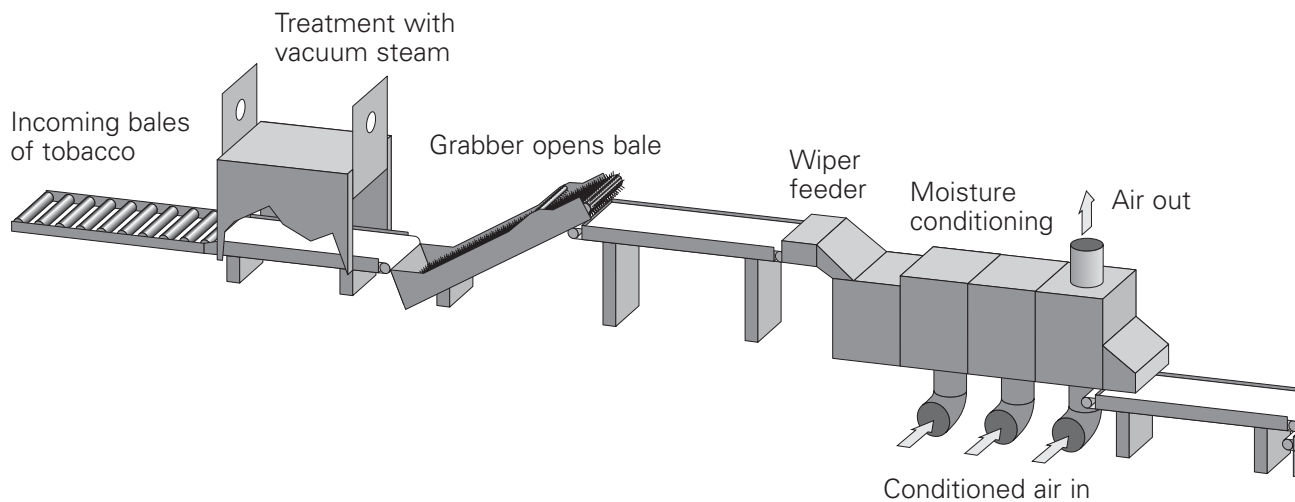
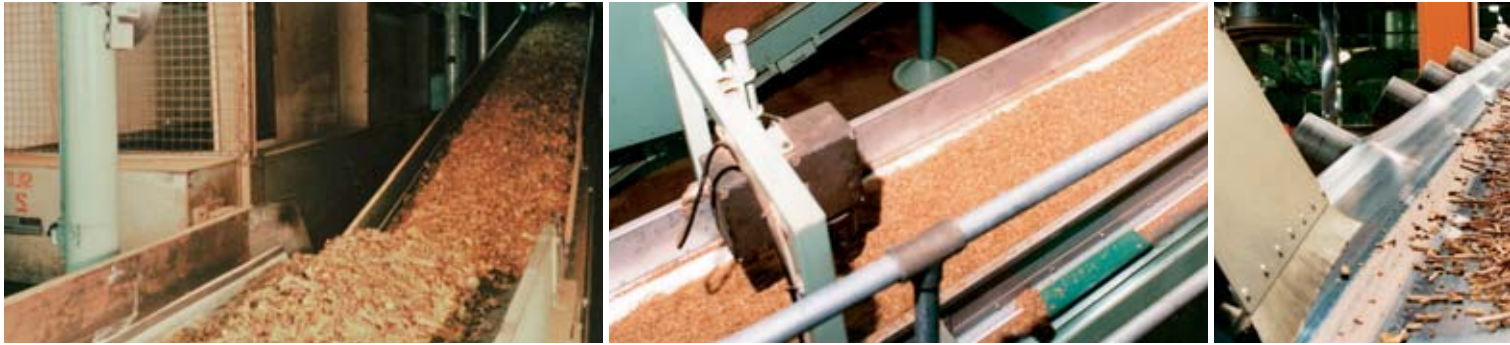


Aging



Remark: The drawings are schematic examples of selected applications / processes. The drawings do not claim completeness. The belt recommendations (use / application / layout) are only general suggestions. Due to the complexity of various processes, technical requirements and decisive external influences (e.g. nature or property of transported goods, process speed, steps of treatment / handling, environment or process temperature, humidity, chemicals, additives, ingredients, recipes, etc.) there are many possible solutions.

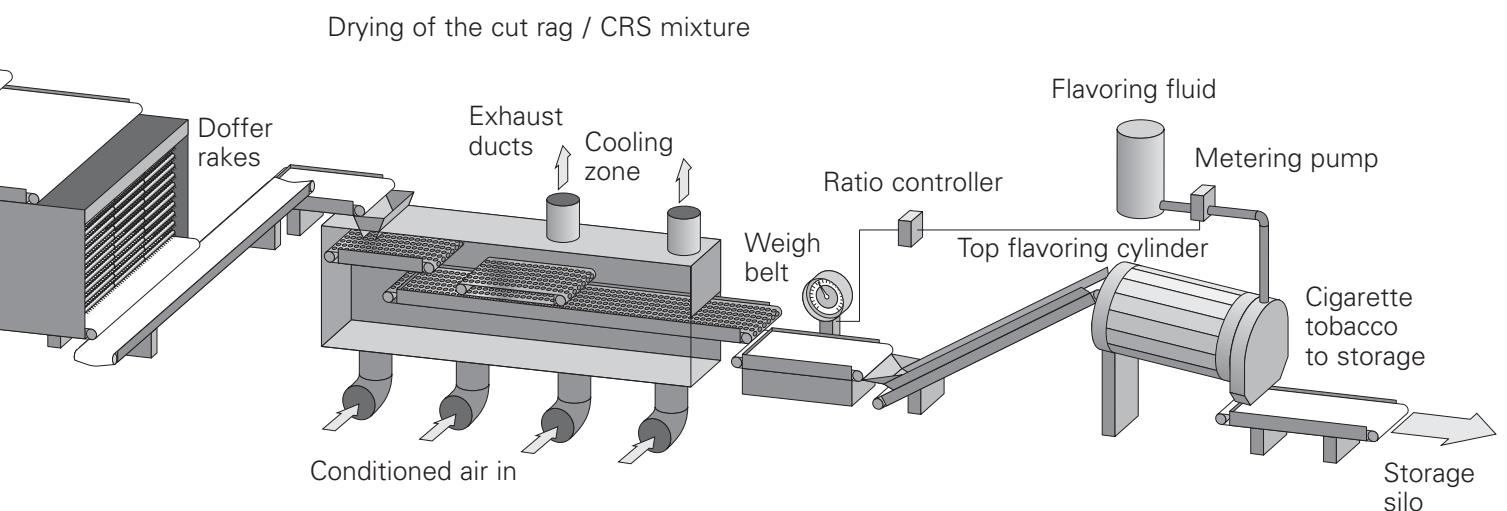
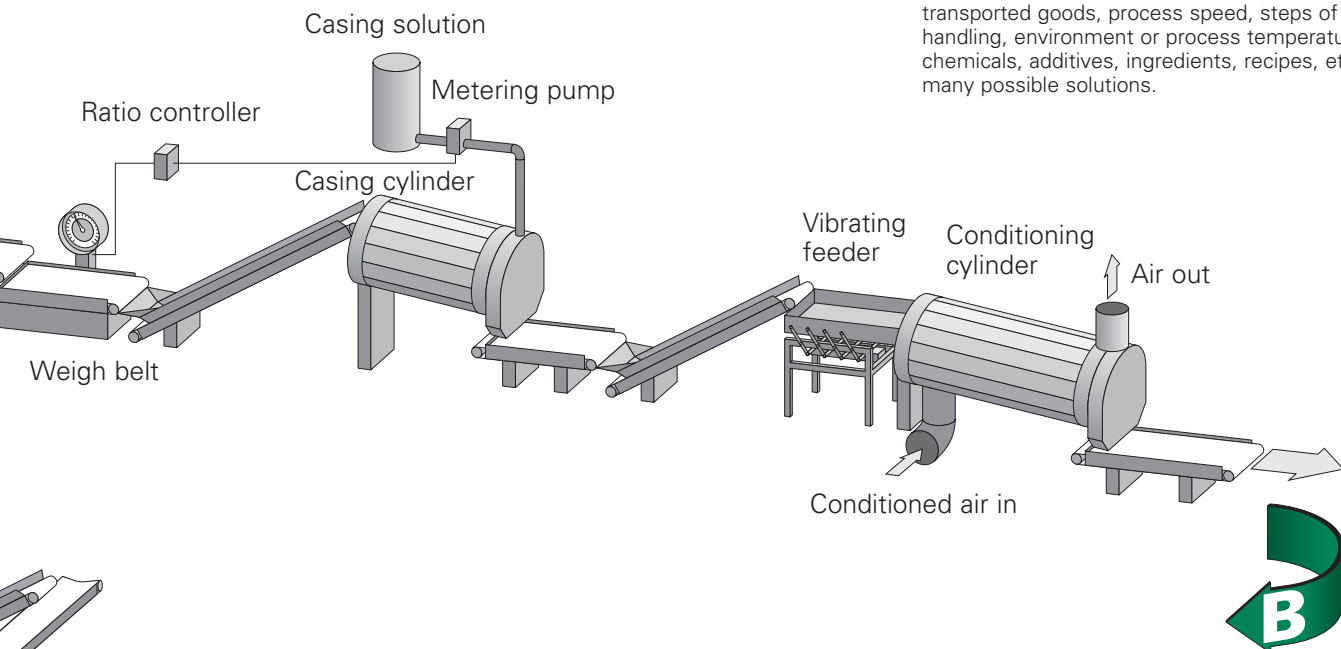




of Tobacco



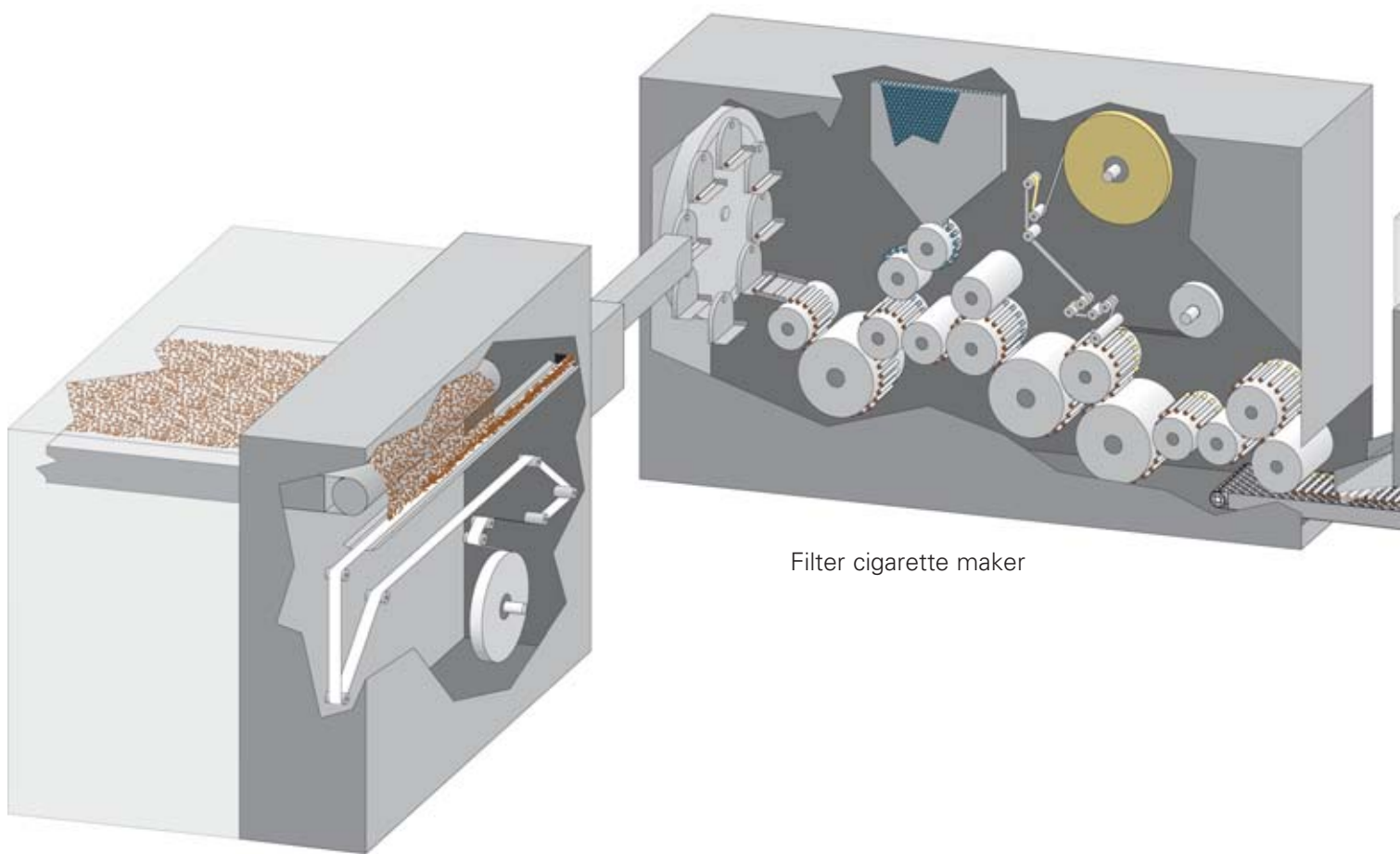
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Secondary Manufacturing

Cigarette Manufacturing and Packaging

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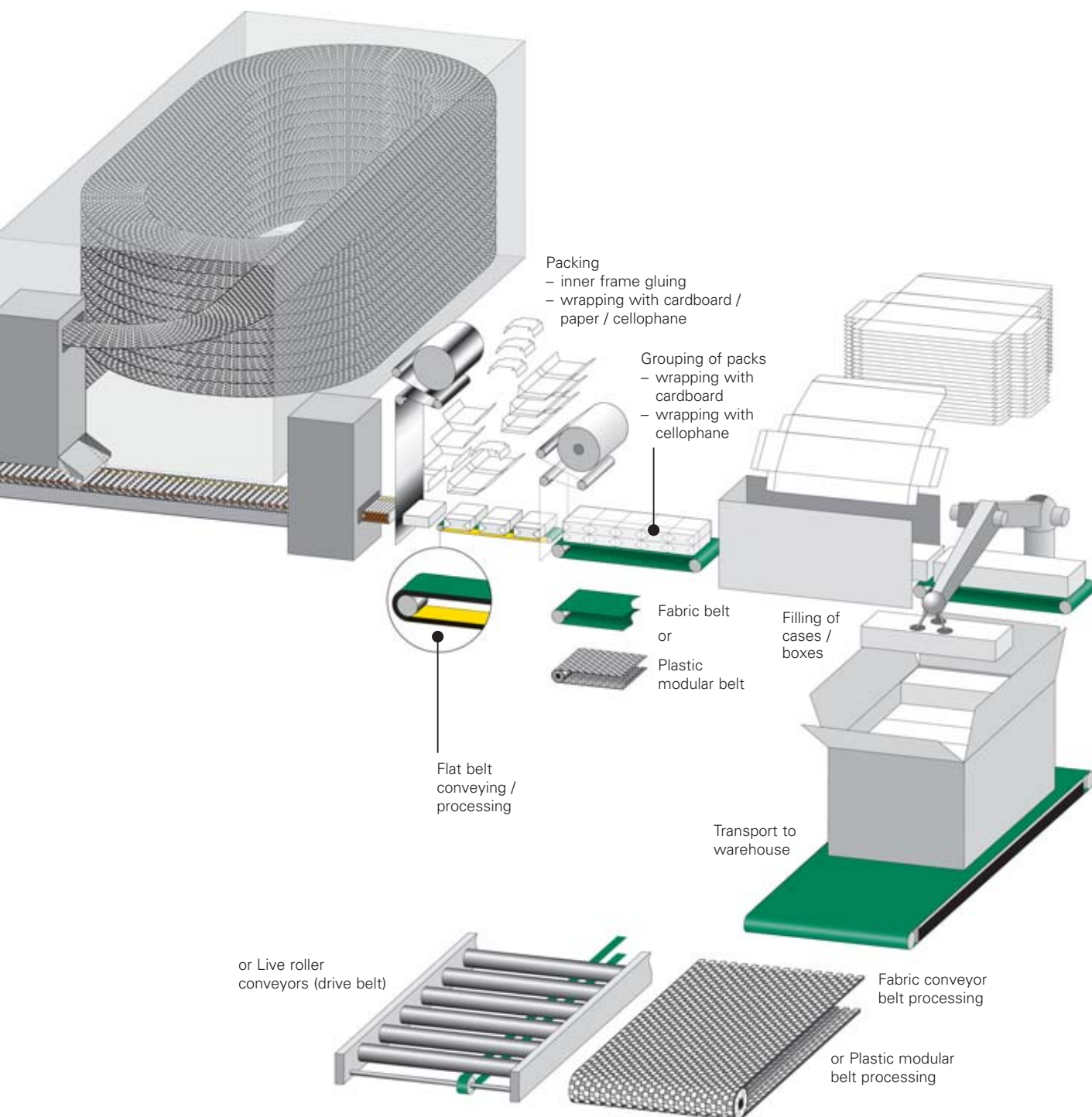


Tobacco infeed

Filter cigarette maker

Remark: The drawings are schematic examples of selected applications / processes. The drawings do not claim completeness. The belt recommendations (use / application / layout) are only general suggestions. Due to the complexity of various processes, technical requirements and decisive external influences (e.g. nature or property of transported goods, process speed, steps of treatment / handling, environment or process temperature, humidity, chemicals, additives, ingredients, recipes, etc.) there are many possible solutions.

Mass buffer system



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.

Conveyor and processing belt ranges

Construction / Materials / Components variation

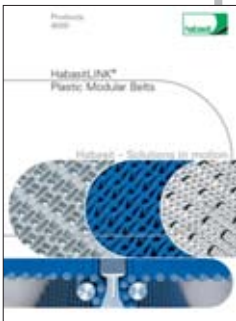
HabasitLINK® Plastic modular belts and KVP plastic spiral belts



PP
(Polypropylene)

PE
(Polyethylene)

POM/AC
(Polyoxymethylene/Acetal)



Please consult product brochure 4000 HabasitLINK®, plastic modular belts for details / further information

HabaCHAIN® Slat Top chains, Knuckle chains, Conveyor chains



POM (Polyoxymethylene)

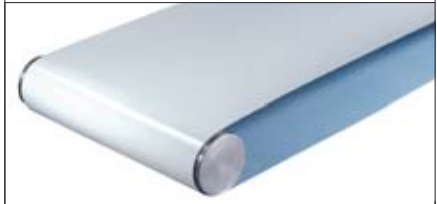
Glass reinforced PP

Special materials



Please consult product brochure 4122 HabaCHAIN®

HabaFLOW® Fabric belts



TPO coated

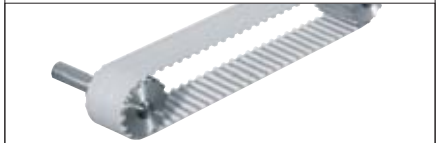
TPEE coated

Special materials

HabaDRIVE® Power Transmission belts and Machine tapes



HabaSYNC® Timing belts



Polyurethane with steel cord tensile member

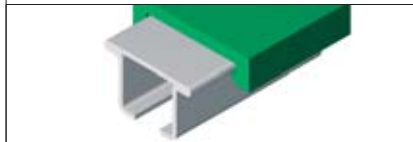
Polyurethane with aramide tensile member

Gear motors



For further information please consult www.rossi-group.com

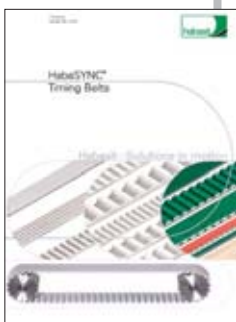
HabiPLAST®



Guides for roller chains and belts



For details and further information please consult product brochure 4097 HabiPLAST®



For details and further information please consult product brochure 4107 HabaSYNC®

Variety of belt surface structures

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 following some of the variety of belt surface structures and properties.



Impregnated fabric
Non adhesive



Blank / smooth surface
Non adhesive



Tear drop structure
Adhesive



Blank / smooth surface
Adhesive



Knob structure
Adhesive

Tobacco Applications and Possible Belt Types (selected Types only)

Belt Type	Primary Processing																Accessories	Secondary Manu- facturing		
	Application	Green Leaf processing	Depacking, Bale opening	Slicing	Conditioning	Casing	Blending, Storing	Cutting	Expanding	Drying	Cooling	Metering	Flavouring	Weighing	General Conveying	Side skirt		Packaging	Logistic, Warehouse	Product conveying
Fabric impregnated belts																				
ONI-5EI					•															
TPO coated belts																				
PNB-5EYWX (Side skirt)														•						
PNB-5EVWX (Side skirt)														•						
PNB-10EYWO	•	•	•	•	•	•	•	•	•	•	•	•	•							
PNB-10EIWO	•	•	•	•	•	•	•	•	•	•	•	•	•							
PNB-10EVWW	•	•	•	•	•	•	•	•	•	•	•	•	•							
PNB-14EYWO	•	•		•	•	•	•	•	•	•	•		•							
PAB-10EYWO	•	•			•	•				•	•									
TPO coated belts with surface structure																				
PAK-10EYWO				•	•	•					•		•							
PAK-10EIWO				•	•	•					•		•							
PAP-10EYWO				•	•	•	•	•	•		•		•							
PAP-10EIWO				•	•	•	•	•	•		•		•							
TPEE coated belts																				
PNB-12EIWD	•	•	•	•	•	•	•	•	•	•	•	•	•							
PNB-14EIWD	•	•		•	•	•	•	•	•	•	•		•							
PAP-12EIWD				•	•	•	•	•	•		•									
NVT-457														•						
PNB-12EICD	•	•	•		•	•	•	•	•	•	•	•	•							
PP coated belt																				
TT124/AS/PP			•	•		•					•		•							
PVC coated belts																				
NHB-10EKBV																		•		
NAB-10ELBV																		•		
NAJ-8EEBV																		•		
NSL-10ELBV																		•		
NBR coated belts																				
HAT-8P																	•			
HAT-12P																	•			
NBR double side coated belts																				
S-10 / 15																	•			
S-18 / 20																	•			
Plastic modular belts																				
M2520																		•		
M2540																		•		
HabaCHAIN																				
C7100																			•	

P-Line conveyor and processing belts

TPO coated

TPO coated	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
ONI-5EI	PET	Fabric	Non-adhesive	Off-white	No	0.7	0.03	15	0.6	55	−15	131	5
PAB-10EYWO	TPO	Smooth	Adhesive	Transparent	Yes	3	0.12	50	2	70	−20	158	−4
PAK-10EIWO	TPO	Knob Structure	Non-adhesive	Transparent	Condit.	6.1	0.24	150	5.9	70	−20	158	−4
PAK-10EYWO	TPO	Knob Structure	Non-adhesive	Transparent	Condit.	6.1	0.24	150	5.9	70	−20	158	−4
PAP-10EIWO	TPO	Tear Drop Structure	Non-adhesive	Transparent	Yes	4.3	0.17	80	3.1	70	−20	158	−4
PAP-10EYWO	TPO	Tear Drop Structure	Non-adhesive	Transparent	Yes	4.3	0.17	80	3.1	70	−20	158	−4
PNB-5EVWX	TPO	Smooth	Non-adhesive	Transparent	Yes	1	0.04	NA	NA	70	−20	158	−4
PNB-5EYWX	TPO	Matt	Non-adhesive	Transparent	Yes	0.9	0.04	80	3.1	70	−20	158	−4
PNB-10EIWO	TPO	Matt	Non-adhesive	Transparent	Yes	2.3	0.09	50	2	70	−20	158	−4
PNB-10EVWW	TPO	Matt	Non-adhesive	Transparent	No	2.9	0.11	150	5.9	70	−20	158	−4
PNB-10EYWO	TPO	Matt	Non-adhesive	Transparent	Yes	2.3	0.09	50	2	70	−20	158	−4
PNB-14EYWO	TPO	Matt	Non-adhesive	Transparent	No	3.5	0.14	150	5.9	70	−20	158	−4

P-Line conveyor and processing belts

TPEE coated

TPEE coated	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
PNB-12EIWD	TPEE	Matt	Non-adhesive	Off-white	Yes	1.7	0.067	40	1.57	100	-30	212	-22
PNB-14EIWD	TPEE	Matt	Non-adhesive	Off-white	Yes	1.8	0.070	40	1.96	100	-30	212	-22
PAP-12EIWD	TPEE	Tear Drop Structure	Non-adhesive	Off-white	Yes	4.5	0.177	96	3.78	100	-30	212	-22
NVT-457	TPEE	Matt	Non-adhesive	Off-white	–	1.2	0.047	–	–	100	-30	212	-22
PNB-12EICD	TPEE	Matt	Non-adhesive	Cobalt blue	Yes	1.7	0.067	40	1.60	100	-30	212	-22

PP coated belt

PP coated belt	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
TT124/AS/PP	PP	Smooth	Hard/Non-adh	White	Yes	1.5	0.06	60	2.4	120	0	248	32

PVC coated belts

PVC coated belts	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
NAB-10ELBV	PVC	Blank/Smooth	Adhesive	Black	No	2.1	0.08	40	1.6	70	−10	158	14
NAJ-8EEBV	PVC	Jink Wave	Adhesive	Black	No	5.3	0.21	60	2.4	70	−10	158	14
NHB-10EKBV	PVC	Matt	Hard/Non-adh	Black	No	2.1	0.08	30	1.2	70	0	158	32
NSL-10ELBV	PVC	Longit. Groove Struc.	Super-adhesive	Black	No	2.3	0.09	40	1.6	60	−20	140	−4

NBR coated belts

NBR coated belts	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
HAT-8P	NBR	Rough Textile Struc.	Adhesive	Green	No	2	0.08	25	1	100	0	212	32
HAT-12P	NBR	Rough Textile Struc.	Adhesive	Green	No	3	0.12	50	2	100	0	212	32

NBR double side coated belts

NBR double side coated belts	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
S-10 / 15	NBR	Rough Structure	Adhesive	Yellow	No	1.5	0.06	25	1	100	−20	212	−4
S-18 / 20	NBR	Rough Structure	Adhesive	Yellow	No	2	0.8	60	2.4	100	−20	212	−4

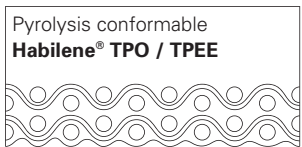
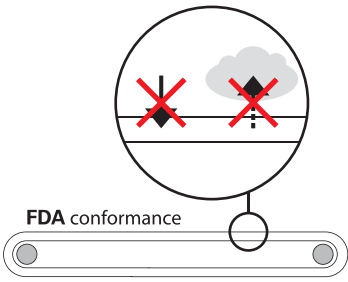
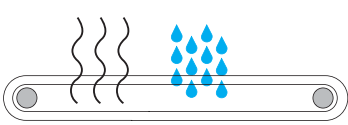
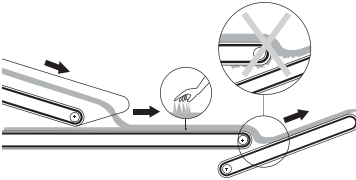
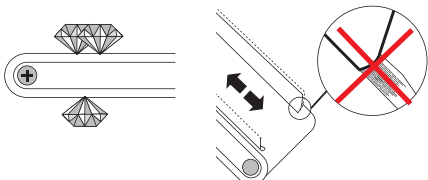
Plastic modular belts

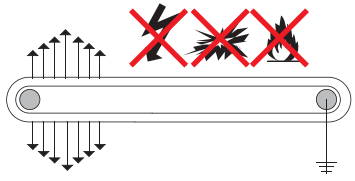
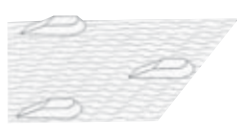
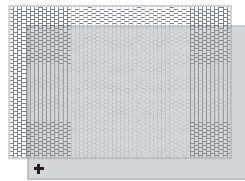
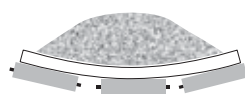
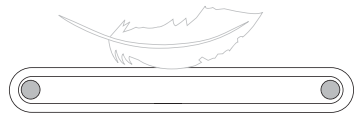
Plastic modular belts	Product construction/design				Technical key data								
	Conveying side				Troughed	Thickness		Pulley Ø minimum		Operational temp.			
Product / belt code	Material	Surface	Property	Color		[mm]	[in]	[mm]	[in]	max °C	min °C	max °F	min °F
M2520	POM/PP	For detailed selection of plastic modular belt, please contact your local Habasit partner.											
M2540	POM/PP												

Product key data overview: You will find the detailed key data (Product Data Sheets) also on the Habasit Website (instruction see page 9b).

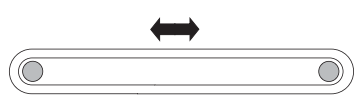
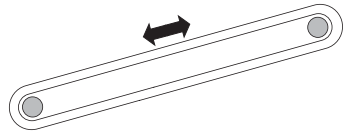
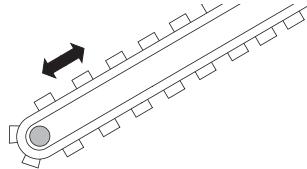
P-Line, specifically developed for the tobacco industry using the unique features of TPO and TPEE coating. Read about its features and the customer benefits.



	Features	Benefits
 Pyrolysis conformable Habilene® TPO / TPEE	• High grade Polyolefine (TPO) and Thermoplastic Polyester Elastomer (TPEE) coating	• Non-toxic • Non-absorbent • Pyrolysis conformable → Belts fulfil industry requirements → No product contamination → Safety
	• High temperature resistance • Excellent abrasion resistance • Lateral stability	• Up to 100°C • Better performance, longer service life • Reliable conveying
 FDA conformance	• FDA conformable • Pore-free belt surface • Hygienic • Taste neutral • Physiologically safe (FDA = Food and Drug Administration, USA)	• Admissible for bulk foodstuffs / direct contact with tobacco • Meeting food safety and sanitary requirements • Absolutely smooth belt surface → Safe production → No odor absorption → No nutrient medium for bacteria → Easy to clean
	• Hydrolysis resistant • Insensitive to humidity and temperature fluctuations	• Conveyance of humid tobacco suitable • No layer separation in wet / humid conditions • No elongation → Trouble-free production → Long belt service life
	• Excellent release properties	• No sticking, no adhesion • Tobacco-repellent → Easy to clean → Constant material flow → Efficient production output
	• Wear and tear resistance (Especially with TPEE coating)	• Reduced belt abrasion – no belt residue in the tobacco • Constant belt surface properties → Less maintenance → Long belt service life

	Features	Benefits
	• Permanently antistatic • Integrated conductive threads / layers	• Avoidance of electrical charge • Reduction of dust / dirt accumulation → No interruption of flow processes → High process reliability and safety
	• New tear drop design • No sharp edges • No blind spot / area • Repellent function	• Excellent incline / decline conveyance • Easy release of tobacco • No residues of tobacco → Easy to clean → No brushing shadow
	• Impregnated reverse side (running side)	• Less soiling • Hygiene support → Reduced cleaning time → Cost reduction
	• Laterally flexible fabric traction layers and at the same time high transversal stability	• Troughed application suitable • A single belt type for different applications (troughed or flat) → Less belt product variants → Simplified stock-keeping
	• Light weight construction / design • Low belt mass (belt weight)	• Belts are easy to install → Low energy consumption → Economic production

Surface structure variations

	• Non-adhesive	• Easy release of bulk goods (sticky or non-sticky) → Broad selection (need / process adaptable)
	• Adhesive	• Excellent grip, constant, reliable conveyance (slight incline / decline) → Broad selection (need / process adaptable)
	• Structured (embossed)	• Inclined or declined conveyance → Broad selection (need / process adaptable)

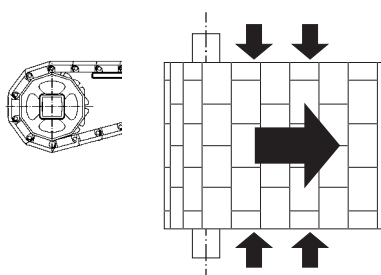
Plastic modular belts HabasitLINK®

Based on our comprehensive experience and our leadership position in traditional fabric-based belting, Habasit has developed the HabasitLINK® modular belt range. This state-of-the-art product line completes our offer as a single source supplier and partner for your success. Plastic modular belts are used successfully in a wide range of industries.



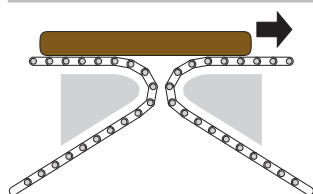
Features

Benefits



- **Positive drive and tracking by belt engaged with sprockets**
- **Guided belt alignment**

- **Straight running, even under influence of transversal forces**
- **Exact positioning of goods**
- **No need for tensioning devices**
- **No re-adjustments, no downtimes**
- **Reliable tracking**
- **Elimination of belt edge damages**
- **Simple system design**



- **Very small transfer due to improved modular belt design**

- **Smooth transfer between conveyors (radius = 8 mm / 0.31 in.)**
- **Efficient and safe product handling**

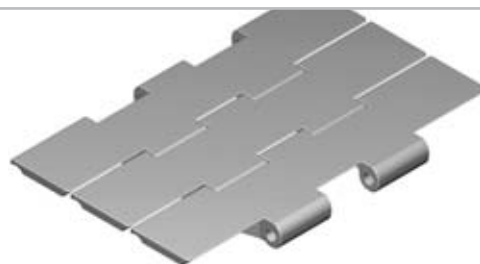
PP = Polypropylene
PE = Polyethylene

- **Large variety of plastic materials and colors available**

- **Optimum adaptation to needs of an application**
- **Tailor-made solutions**
- **The best solution for most applications**
- **High lateral stiffness design**
- **Direct Tobacco contact possible**

Plastic chains

HabaCHAIN® is a high-quality range of new slat- and flat chain products from Habasit. HabaCHAIN® products are suitable for a wide range of applications in beverage, bakeries, packaging and many other industries.



Features

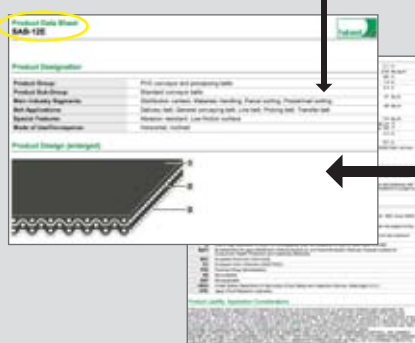
Benefits



- **Suitable for linear and curve conveying on aluminum modular structure**
- **Grip Top types available**
- **Wear resistance**
- **Less noise generation**
- **Precision of molds**

- **Retrofit on existing systems possible**
- **In general for light weight transport of goods**
- **Available in Pyrolysis-proof materials**

www.habasit.com or www.habasitlink.com



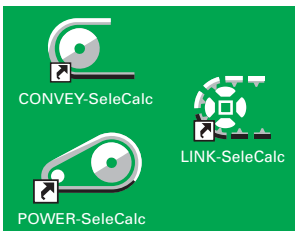
Comprehensive services are central to Habasit's belting solution approach.

As committed partners to our customers, we are dedicated to sharing our knowledge and to providing full support.



Consulting and technical support

Habasit offers the best consulting and technical support on the belting market. Everything revolves around our customers. Each affiliate has its own belting experts. The Habasit team proudly provides the highest levels of support and top-quality products enjoyed by the global market for over 60 years.



Assistance with belt selection and calculation

We will select and calculate the most suitable belt for your specific application. You also may do this yourself with our state-of-the-art Habasit selection and calculation program "SeleCalc". To order this program free of charge, simply call your nearest Habasit partner or contact: info@habasit.com.



Fabrication, assembly and local installation services for quick reaction times

We make belts endless or assemble modular belts or chains, either at our own locations or on-site directly on your machine or system. Habasit operates 33 affiliated companies worldwide, each with its own inventory, fabrication, assembly and service facilities. Together with our representative offices and numerous qualified distributors, we can react quickly, competently and reliably to satisfy all your demands.



Customer training programs

Habasit offers training programs and provides support tools to ensure optimal use of our products and to prolong their lifecycles. Training on fabrication, installation, assembly, maintenance and belt repair takes place at Habasit sites or at your location.



Belt monitoring, inspections, analyses and process optimization proposals

We organize and handle belt maintenance, inspections, analyses and surveys for your locations. On request we will also work with you to develop optimization proposals, e.g. to achieve added value from the machinery or process output.



Design assistance for customized solutions

Habasit believes in partnership. Our engineering team will work closely with your engineers on joint design developments, preferably from a very early stage. We particularly recommend this for projects involving new technologies or large-scale modifications and adaptations.

At Habasit, we listen to our customers, innovate continuously and deliver reliable solutions to meet your every need.

Customers come first

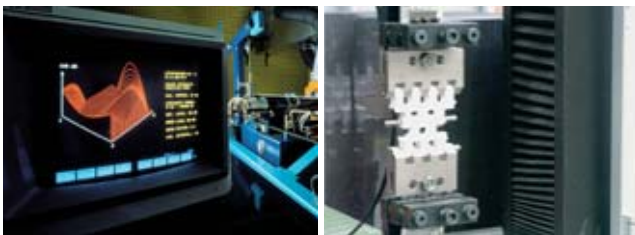
At Habasit we understand that our success depends on your success. Which is why we offer solutions, not just products; partnership, not just sales.

Since our foundation in 1946, Habasit has brought this understanding of customer needs to life every day and for every application. That's why we're the No. 1 in belting today. Worldwide.



Committed to innovation

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



Certified for quality

We deliver the highest quality standards not only in our products and solutions, but also in our employees' daily work processes. Habasit is certified according to ISO 9001:2000.



Worldwide leading product range

Habasit offers the largest selection of belting, conveying, processing and complementary products in the industry. Our response to any request is nothing less than a specific, tailor-made solution.

A selection of our product ranges:



HabaFLOW®
Fabric based
conveyor and
processing belts



HabasitLINK® + KVP
Plastic modular
belts



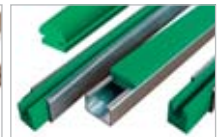
HabaDRIVE®
Power
transmission
belts



HabaSYNC®
Timing belts



HabaCHAIN®
Chains (slat and
conveyor chains)



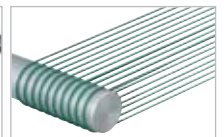
HabiPLAST®
Profiles
Guides
Wear strips



Machine tapes



Seamless belts



Round belts



Fabrication tools
(joining tools)



Gear reducers
Gearmotors
Motion control



Electric motors

Worldwide support

Our extensive organization is ready 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.

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