



**Your business
is our business!**

Belts for the Bakery Industry

Bread and Bun Production

Ammeraal Beltech

- Synthetic
- Homogeneous
- Modular





Ammeraal Beltech is a leading global manufacturer of product handling belts for the bakery industry. Decades of materials and design development have enabled us to deliver application proven solutions. Our ever-expanding range of belt types has positioned Ammeraal Beltech as the go-to company for OEMS and users seeking the best quality hygienic and sanitary options for synthetic, modular, homogenous, elastic and endless woven belts used in the food industry.

This brochure provides a snapshot of specific applications found in bread and bun production, along with some of the most commonly used belts selected for these applications. Because our offering is so broad, not all belts can be presented in a snapshot version. We invite you to contact your nearest Ammeraal representative or one of Ammeraal's partner distributors to discuss your specific needs.



Our Full Product Offering:

- **Synthetic Belts** – a comprehensive range of process and conveyor belts
- **Elastomer Belts** – the widest range of high-quality rubber covers
- **ZipLink® Belts** – a handy solution to lost production time across all industrial sectors
- **Ultrasync Belts** – synchronized conveying and positioning for high-speed and high-load capacity
- **Endless Woven Belts** – seamless covers and profiles on endless woven fabric
- **Timing Belts** – positive-drive belts for transport and positioning in synchronized processes
- **Engineered Belts** – custom or specialized belts (such as pull-down belts or feeder belts) made by adding a cover, usually machined, to a base belt; for a wide range of specific applications
- **Flat Belts** – RAPPLON® high-performance belts for power transmission and high-speed conveying
- **Plastic Modular Belts** – uni-chains belt solutions, with both straight-running and side-flexing belts
- **Steel and Plastic Chains** – diverse solutions for a wide range of conveying applications
- **Homogeneous Belts** – tension and positive-driven ultra-hygienic belts with self-tracking features
- **V and Round Belts** – various colored Food Grade V & Round belts
- **UltraScreen Belts** – mesh belts for use in food washing/ drying applications
- **Peak Belts** – high-quality PTFE and silicone-coated belts for baking and cryogenic freezing application

Please visit www.ammeraalbeltech.com to see the PDF version of this brochure. Here you will find direct links to more detailed information for the belts referenced as well as belts that are used in metal-detectable and weigh scale applications.

Products recommended in this brochure are only a sub-set of our extensive product line-up, the widest in the business. Our experts can help you find the right belt.

1 Dough Handling

Wet dough applications determine size and shape to bakery products. We offer extensive experience for your needs in dough handling with dedicated solutions in molding, dividing and lamination.

Problems

- Dough tends to stick to belt
- Hygiene control
- Belt slippage and mistracking

Solutions

- Better release with non-stick material and surfaces
- Low maintenance belt surfaces
- Homogeneous belt material and positive drive self-tracking system
- HACCP Program

2 Proofing

Due to the efficacy of their high-volume capacity combined with compact dimensions, linear and radius turn conveyors are the preferred option for large industrial bakeries.

Challenges

- Difficult to maintain product stability
- Temperature and humidity levels must be controlled
- Limited space can lead to positioning problems in operational performance

Solutions

- High-performance belt designs ideal for conveying
- Open-surface belt design for low product-to-surface contact
- Tight radius options for curves

5 Cooling

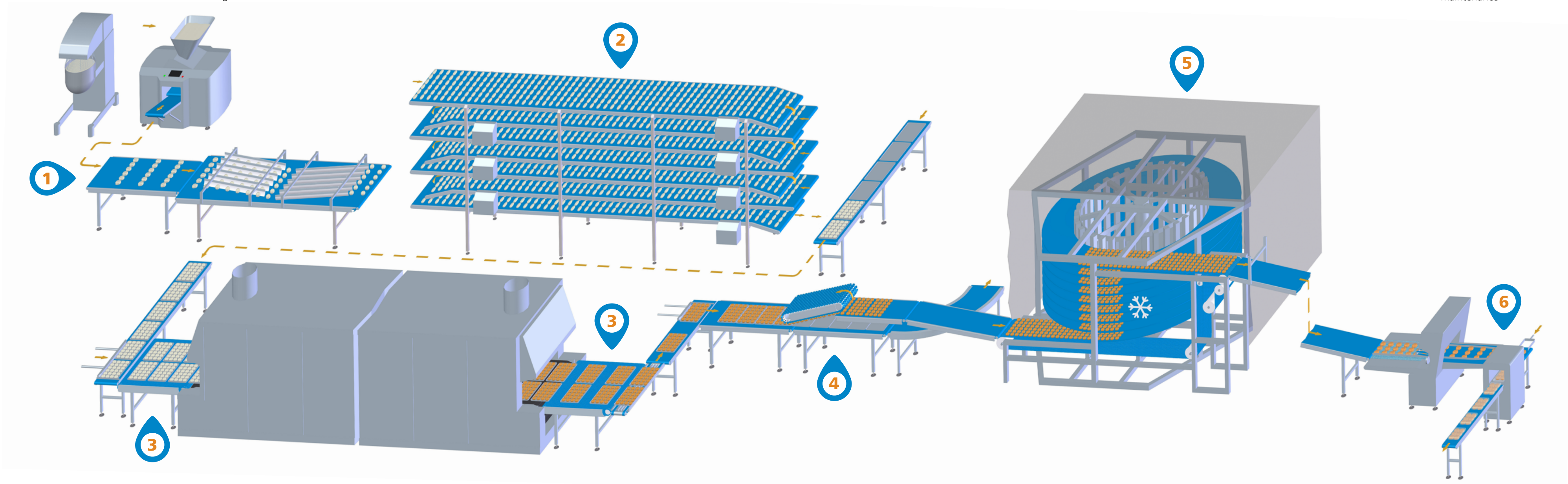
Bread must be cooled, allowing the right amount of moisture to evaporate before the loaves are ready for slicing and packaging.

Challenges

- Crumb retention reduces airflow and leads to potential mold formation
- Wire mesh belts can fragment and contaminate product
- Inconsistent quality

Solutions

- Crumb reducing belt design
- Large open-area belt surface and low product-to-surface contact ratio for air circulation and cooling
- Plastic modular belts increase lifetime while reducing maintenance



3 Infeeder & Take-Off Oven Belt

Our range of solutions, developed from our long industry experience, include belts designed for direct contact with dough as well as those made for conveying very heavy hot trays.

Challenges

- Dough tends to stick to belt
- Extreme operating conditions can lead to short lifetimes for belts/chains
- Repairs and maintenance can be time-consuming

Solutions

- High-performance belt designs ideal for conveying
- Open-surface belt design for low product-to-surface contact
- Modular belts with lockpins for easy assembly/disassembly

4 Depanning

Ammeraal is familiar with all of the challenges related to removing bread of different shapes and weights from baking trays.

Challenges

- Product damage during lift-out and deposit
- Broken suction cups can damage products
- Crumbs and oil can reduce operational efficiency

Solutions

- Customized belts for optimal performance and product life
- Range of Food Grade metal-detectable suction cups and retainer rings
- Heavy-duty Food Grade belts; resistant to oil and abrasion

6 Slicing & Packaging

The last stage of production involves slicing, bagging, sealing and conveying the finished product to the end of the production line. This is also where the final inspection, including metal detection and weighing, takes place.

Challenges

- Product slippage on belt
- Belt materials setting off metal detection
- Damaged product packaging, compromising Food Safety
- Downtime for maintenance and/or installation

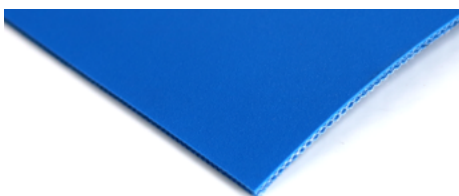
Solutions

- High-grip Food Grade belt material for secure conveying
- ZipLink® technology for quick and easy metal-free on-site splicing
- Metal-detectable Modular Belts to prevent contamination

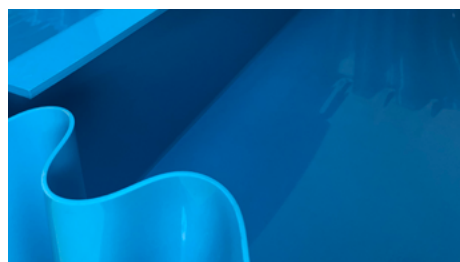
Suggested Product Information:

Product Number	Description	Dough Handling	Proofing	Infedder / Take-Off Oven Belt	Depanning	Cooling	Slicing & Packaging
SBFA046066	Fabric ESF 6/2 0+0 (PU) white FG	1					
SBFA460710	Fabric ESF 9/3 0+0 (PU) white FG	1					
SBNO573325	Nonex EM10/2 00+A54 white FG	1					
SBNO576050	Nonex EM 15/3 00+15 white FG				4		
ZLNI560121	Nitrile EZP 10/1 01+C37 brown						6
SBRY046046	Ropanyl EM 8/2 00+02 white AS FG	1					6
SBRY577041	Ropanyl EM 8/2 00+02 light blue M2 AS FG AM	1					
SBRY577982	Ropanyl EM 6/2 00+A21 light blue AS FG AM	1	2				
SBRY577952	Ropanyl EM 6/2 00+A21 white AS FG	1	2				
SBRY591120	Ropanyl ESM 6/1 F1+03 white FG NF	1					
SBMD000023	Ultranyl EM 6/2 00+03 white M1 AS FG	1		3			
SBRO595257	Ropanol ESM 8/2 00+00 (PU) light blue AS FG AM NF	1	2				
SBRO577710	Ropanol ESM 6/2 00+00 (PU) light blue AS FG AM NF	1	2				
HOMOGENEOUS	SFVB000162	FEMB-2 ITO-50	1				
	SFVB000067	FEMB-3 ITO-50		2			
	SFVB000154	FRLB-2.5 CEBB ITO-50	1				
	SFVB000004	FRLB-2 CEBB		2			
MODULAR	uni-chains	Flex ASB				5	6
	uni-chains	M-QNB C			4		
	uni-chains	M-QNB NS	1				
	uni-chains	M-TTB 37%		2			
	uni-chains	M-TTB 37% Rubber Top			4		6
	uni-chains	SNB M2 34% or 50%		2		5	6
	uni-chains	SS 815			3		
	uni-chains	Flex L-ASB R2.2			3	4	

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Synthetic Belts



Homogeneous Belts



Modular Belts

Haven't Found What You Are Looking For?

Ammeraal Beltech is your global supplier for the best baking belts in the business. Check out our other product families relating to baking & food applications at www.ammeraalbeltech.com or email us at info@ammeraalbeltech.com with your questions.

Our Belt Coding Explained...



	Ropanyl	EM	6 /	2	00+	A21		light blue	AS FG AM
	Fabric	ESF	6/	2	0+	0	(PU)	white	FG
1	Type of top cover								
2	Type of fabric								
3	Tension at 1% elongation								
4	Number of plies								
5	Bottom (cover) thickness or Profile style								
6	Top (cover) thickness or Profile style								
7	Innerlayer if Different from top cover								
8	Color of the top cover								
9	Additional								

Materials Breakdown

EM	E = polyester, M = monofilament
ESF	E = polyester, S = spun, F = flexible
EC	E = polyester, C = cotton ("EC" describes a cotton polyester blend)
ESM	E = polyester, S = spun on the bottom ply, M = monofilament in the upper ply

Other Codes

AS	Anti-Static	AM	AntiMicrobial
FG	Food Grade	NF	Non Fray
FA	Fabric	M1	Fine Matt Finish
CT	Cotton Texture	M2	Matt Finish



Ammeraal Beltech member European Hygienic Engineering & Design Group



Food Grade belts comply with EC 1935/2004 EU 10/2011 and FDA standards

Base Belt Properties

Nitrile	FDA belt made of thermoset rubber that offers excellent oil and fat resistance
Nonex	FDA PVC offering good resistance to oils and fats. White and Light blue available with smooth or profiled convey surfaces
Ropanol	Food compliant belt with thermoset polyurethane impregnation providing low friction top and bottom surface. Available in transparent, white and light blue
Ropanyl	An FDA belt with thermoplastic polyurethane coating offering very good resistance to abrasions, oils and fat. Available in light blue and white with smooth or profiled convey side
Ultranyl PU Con	An FDA special formulated belt design for use in application where hydrolysis can be found in application or the cleaning process



		PE	PP	M-QNB	NS	335	Blue
1	Belt Material						
2	Pin Material						
3	Belt Type						
4	Surface Opening or Surface Type						
5	Belt Width (mm)						
6	Belt Color						

Material Properties

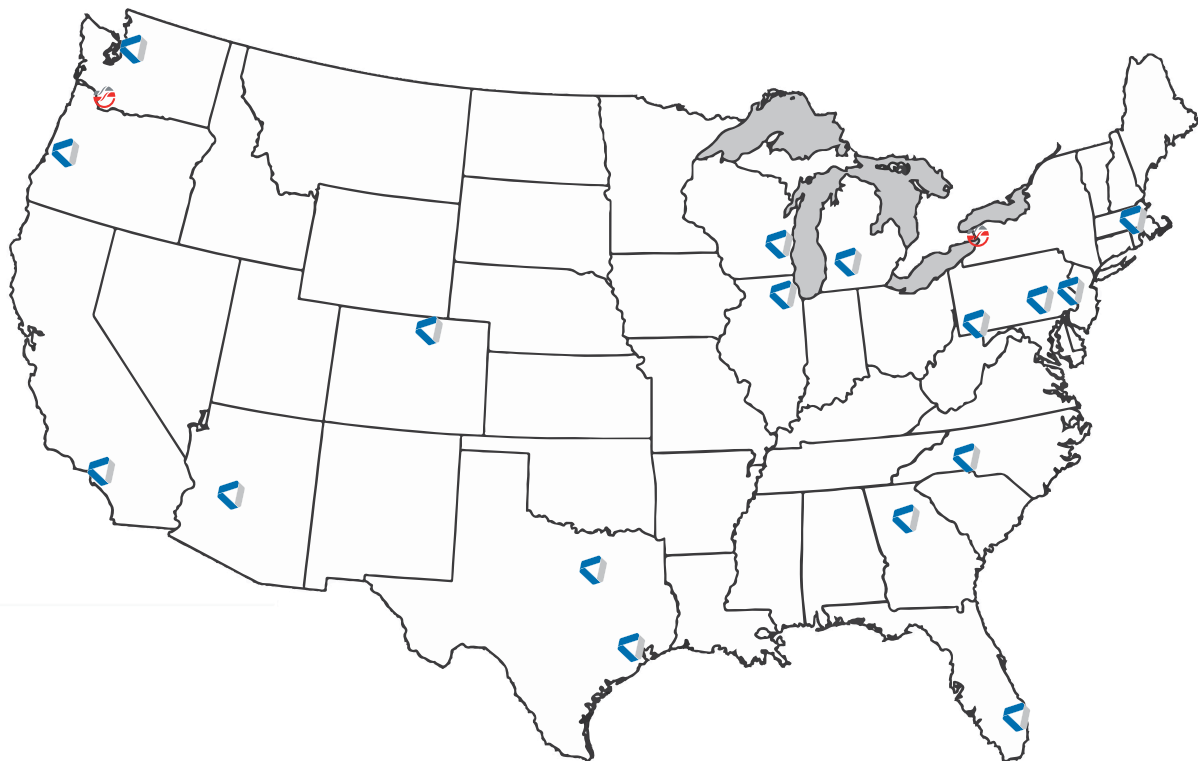
Acetal (POM):	POM is a thermoplastic material characterized by high tensile strength, stiffness, and wear resistance. Overall, it has very good mechanical and thermal properties
Polypropylene (PP):	PP is a cost-effective thermoplastic material for applications at warmer temperatures, operating at less demanding product loads and speeds
Polyethylene (PE):	PE is thermoplastic material that is a good alternative to POM for non-stick applications. It is a more cost-effective option for light product loads and low speeds
Stainless Steel:	AISI 304 SS

Series & Variant	Material Option 1	Material Option 2
M-QNB NS	POM SLF Blue	PE Blue
M-QNB C	POM SLF Blue	PP Blue
SNB M2 34%	POM D Blue	PP Blue
M-TTB 37%	POM D Blue	PP Blue
SS 815	AISI 304 Stainless Steel	-
Flex L-ASB R2.2	POM D Blue	PP Blue

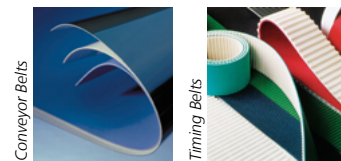
Want to know more? Contact us

Get in touch with your nearest Ammeraal Beltech sales office or visit www.ammeraalbeltech.com to locate your local contact. We'll be glad to help.

US Sales and Manufacturing Locations

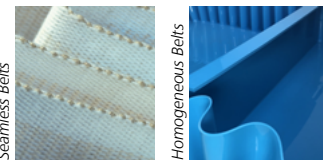


Expert advice and quality solutions
for all your belting needs.



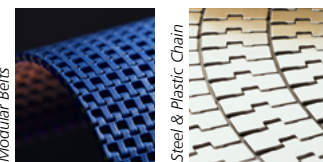
Conveyor Belts

Timing Belts



Seamless Belts

Homogeneous Belts



Modular Belts

Steel & Plastic Chain

SYNTHETIC & HOMOGENEOUS BELTS

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