

A Guide To Rotary Moulder Belts

The
Technical
Textiles
Specialist



Arville

A specialist guide to Brayband[®] rotary moulder belts

What we do:

Brayband[®] is the original make of truly endless woven biscuit belting, first manufactured by us over 100 years ago.

Since then we have developed the product range into a leading name in the worldwide belting market as a trusted brand for specialist biscuit and bakery belting requirements.

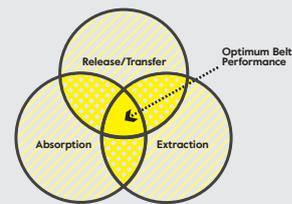
Our weaving expertise saw us innovating the use of man-made fibres to extend the running life of endless woven bakery belts, combining the natural extraction qualities of cotton fibres with polyester and nylon blends for extra durability and performance.

Today we offer a comprehensive range of specialist endless woven belts with handling characteristics designed for a wide range of dough types.

Which Belt Should I Use?

The performance characteristics of a rotary moulder belt are determined by a combination of several different factors.

Maximum extraction requires both a high absorption factor and the most appropriate weave pattern, the best release characteristics on the knife edge transfer call for a low absorption/grip factor. This means that for optimum performance an ideal balance needs to be found between good extraction and good release.



Extraction

The weave construction changes the characteristics of the belt, allowing them to be tailored for effective extraction and optimum belt life. The amount of surface area contact that the belt has with the dough is a key factor in the strength of the extraction pull.



Twill: increased contact area, improved extraction



Plain: standard weave type



Broken Twill: reduced contact area, easier release

Twill

Also known as 'Herringbone' due to the distinctive pattern made in the belt, a twill weave has more surface contact with the dough so that it can generate stronger extraction from the mould.

Plain

The most commonly used weave type, a plain weave gives a consistent performance making it universally suitable for many common applications.

Broken Twill

The design of a broken twill pattern allows for air pockets to form, reducing the contact area with the dough and enabling an easier release from the belt to the next part of the process line.



Absorption

Brayband® belts are made predominantly from natural fibres, using a high proportion of cotton which has been the traditional weaving yarn for biscuit webbing and is proven to be effective in extracting biscuit dough from the moulding roller. Cotton, as a natural fibre, has an innate high absorption level which is unmatched by man-made fibres. It is this ability of the belt to absorb which allows the dough to adhere.

More recently we have continued to enhance technical performance by developing belts where natural cotton/flax is combined and blended with modern man-made fibres to increase their operational life and effectiveness with different dough mixtures.



Cotton



Cotton/Nylon



Polyester/Cotton

Cotton

Whilst less durable, cotton fibres have a naturally high absorbency level which still out-performs man-made fibres for coping with moist, oily, high fat/grease content dough mixtures.

Cotton/Nylon Blend

The combination of cotton with nylon adds extra strength, further improving the run life. This improved durability can sometimes be a trade-off against the ability to effectively cope with high fat/sugar dough recipes.

Polyester/Cotton Blend

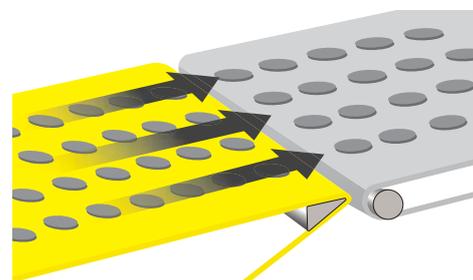
Polycotton yarn mixes give good abrasion resistance, offering improved belt life, usually doubling the run life compared to a 100% cotton belt.



Product Range - Technical specifications

Belt Type:	Brayband®
Machine Applications:	Rotary Moulder, Rotary Cutter, General Purpose Bakery
Product Code:	Please contact our Sales Team for product codes
Construction:	Truly Endless Woven - no joint or splice
Weave Pattern:	Plain, Twill or Broken Twill
Fabric Type	Cotton, Cotton/Nylon or Polyester/Cotton
Contact Side:	Natural woven, untreated
Non-Contact Side:	Polyurethane (PU) treated
Width:	150mm (min.) / 1,680mm (max.)
Length:	1,500mm (min.) / 13,000mm (max.)
Edges:	Woven selvedges - reinforced
Knife Edge Diameter Ø:	3-5mm
Thickness:	1.8mm - 2.9mm (nominal)
Food Approval:	European Regulation 1935-2004 (10/2011) Migration tested according to EN1186-1 2002 and EN1186-13 2002 (Method B)

Release/Transfer



Thinner belts are able to follow the shape of an acute knife edge more closely, which allows for good release of more delicate or thinner dough forms. The weave pattern and amount of air between the dough and the belt (effectively the amount of 'grip' that the belt has) also influences the dough release.

To discuss your belting requirements please contact our sales team by email: sales@rotarymoulderbelts.com or call us on +44 (0) 1937 582735





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