



QUALITY CONTROL

SAMPLE, BATCH AND 100% FINAL INSPECTION

Real drawings and measured values
from our orders

PROVEN · STABLE · VERIFIED



What we check, from wire to packed belt



1

Material

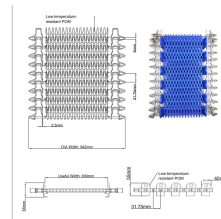
Spectral and hardness test on every incoming batch.



2

Wire and rod

Diameters measured against the drawing.



3

Drawing

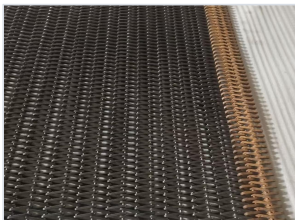
You approve it before anything is made.



4

First article

Measured and sent to you.



5

New with old

Joined to your old belt when needed.



6

Welding

Robot welding on spiral freezer belts; every weld checked.



7

Drum test

Spiral, self-stacking and side driven belts.



8

Final inspection

100% of the belt before packing.



9

Shipment

Only after you confirm.

Five quality questions — and where we answer them

Each answer is a measured value, a photo or a step you approve.

Your question	What we show you	Pages
Who decides when mass production starts?	You do — after photos, video, the drawing or a sample.	4
Is the material what you quoted?	Material tests on every incoming batch.	5–6
Will the batch match the drawing and sample?	Drawing values against measured values from real orders.	7–12
What is checked before shipment?	Drum test, welds, edges and 100% final inspection.	13–16
What records will I get?	Photos, videos and inspection values for your order.	17–18

How you can check: ask for the same records for your own order.

Nothing is mass-produced or shipped without your approval

Your concern: the factory goes ahead before you have seen the result.

#	Step	How you see it	Your decision
1	Drawing	Our drawing of your belt, in mm and in.	You approve the drawing
2	Trial production	Way A: photos and video of the trial piece, compared with the drawing. Way B: we also send the physical sample to you.	You approve by e-mail or message
3	Mass production	Starts only after your approval — never before.	—
4	Final inspection	Photos and video of the finished belt and its measured values.	You confirm before shipment
5	Shipment	Packing photos; the belt ships after your confirmation.	—

How you can check: photos, video and drawing comparison, or a physical sample as well — either way, mass production starts only after your reply.

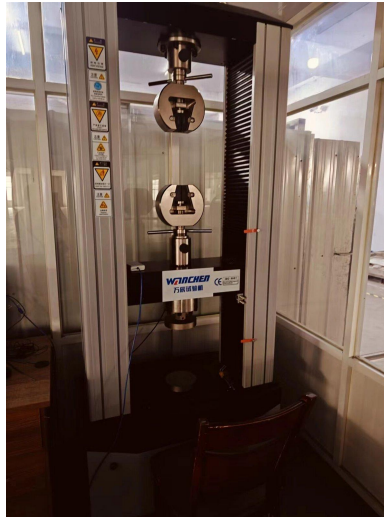
Every incoming batch is tested

Your concern: is the stainless steel really what the quotation says?

Each batch Steel mill documents, material verification, spectral analysis and hardness testing. Tensile testing is also used.



Spectral analysis



Tensile tester



Hardness tester

How you can check: ask for the mill documents of the material in your order.

Wire and rod diameters, measured

Your concern: a wire or rod that is thinner than the drawing.

What we do Wire and rods drawn in-house; diameters measured against the approved drawing before forming.



Wire drawing



Wire diameter



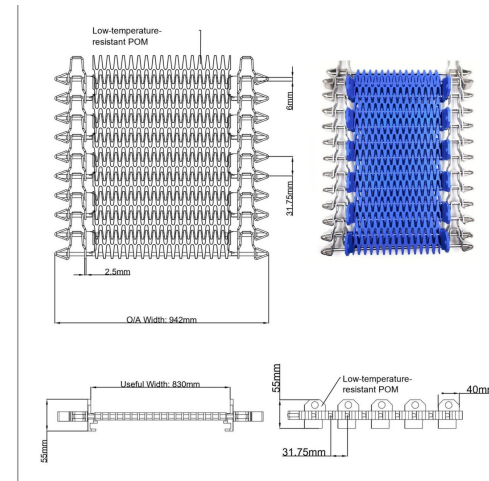
Rod diameter

How you can check: ask for diameter photos of the wire and rods in your belt.

Thailand: drawing values against the approved sample

Replacement side driven belt. Values from our inspection record of the sample the buyer approved.

Item	Drawing	Measured	Tool
Rod pitch	31.75 mm $\pm$ 0.02	31.75 mm	Caliper
Rod diameter	6 mm $\pm$ 0.02	5.99 mm	Caliper
Link thickness	2.5 mm $\pm$ 0.02	2.51 mm	Caliper
Link height	16 mm $\pm$ 0.02	15.98 mm	Caliper
Side guard width	40 mm $\pm$ 1	40.43 mm	Caliper
Side guard height	55 mm $\pm$ 1	54.82 mm	Caliper
Useful width	830 mm	830 mm	Tape
Overall width	942 mm +3/-4	942 mm	Tape
Weld points	Good	Pass	Visual



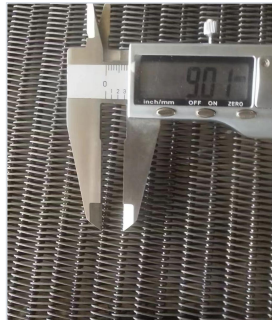
The approved drawing (revision 02)

How you can check: after the first sample inspection the buyer asked for a wider useful width; drawing revision 02 was approved before mass production.

Spain: carbon steel belt, drawing against first article

Bread line belt, 1,650 mm wide. A 300 mm sample was approved first; the first production piece was then measured.

Item	Drawing	First article	Tool
Rod pitch	9 mm	9.01 mm	Caliper
Spiral pitch	2.5 mm	2.50 mm	Caliper
Spiral wire	1.0 mm	1.00 mm	Caliper
Width	1,650 mm	1,650 mm	Tape



Rod pitch 9.01 mm



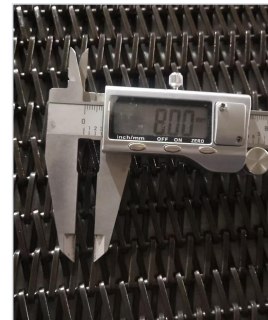
Spiral pitch 2.50 mm

How you can check: the repeat order was made to the same drawing and measured again.

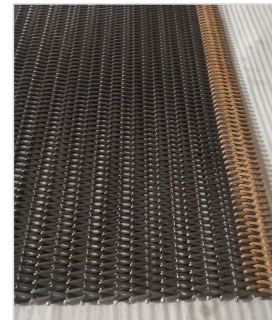
Spain: rusted sample → our drawing → first article

No drawing, only the buyer's old belt. We measured it, drew it, then measured the first article and joined it to the old sample.

Item	Our drawing	First article	Tool
Flat wire thickness	1.6 mm	1.61 mm	Caliper
Spiral pitch	8 mm	8.00 mm	Caliper
Width	3,400 mm	3,400 mm	Tape
Joining to old sample	Must connect	Joined, on video	Splicing test



Spiral pitch 8.00 mm



New belt joined to the old sample

How you can check: the splicing video was sent to the buyer before mass production.

Australia: belt and sprockets, drawing against measured

A wide carbon steel belt, and nylon sprockets made to drawing for another order.

Item	Drawing	Measured	Tool
Belt rod pitch	6.35 mm	6.35 mm	Caliper
Belt width	1,994 mm	1,994 mm	Tape
Sprocket bore	30 mm	30.02 mm	Caliper
Sprocket outside diameter	86.4 mm (approx.)	86.93 mm	Caliper
Sprocket thickness	25.6 mm	25.63 mm	Caliper
Belt on sprocket	Must engage	Checked by hand	Visual



Belt rod pitch 6.35 mm



Sprocket bore 30.02 mm

How you can check: ask for the measured values of your belt and sprockets.

Self-stacking belts: sample, first article and batch

Six orders. The same values are measured on the buyer's sample, on the first article and again on the batch or reorder.

Order	Item	Drawing	Buyer's sample	First article	Batch / reorder
Spain, 760 mm	Rod pitch	30 mm	29.92 mm	—	30.00 mm
Malaysia, 1,069 mm	Tier plate height	80 mm	80.12 mm	80.01 mm	—
Australia, 760 mm	Tier plate height	120 mm	—	120.01 mm	120.03 mm
Korea, 420 mm	Spiral pitch	9 mm	—	9.00 mm	—
Pakistan, 660 mm	Spiral pitch	13 mm	—	13.01 mm	—
New Zealand	Spiral pitch	9 mm	—	9.00 mm	9.00 mm (reorder)

How you can check: the buyer's worn sample is not the design value — we confirm the drawing value with you first.

The values above, as measured

Photos from the same orders: the buyer's sample, the first article and the batch.

What you see Tier plate height on the Malaysian sample, the 120 mm plate on the Australian batch, and the spiral pitch on the Pakistani first article.



Malaysia: sample plate 80.12 mm



Australia: batch plate 120.03 mm



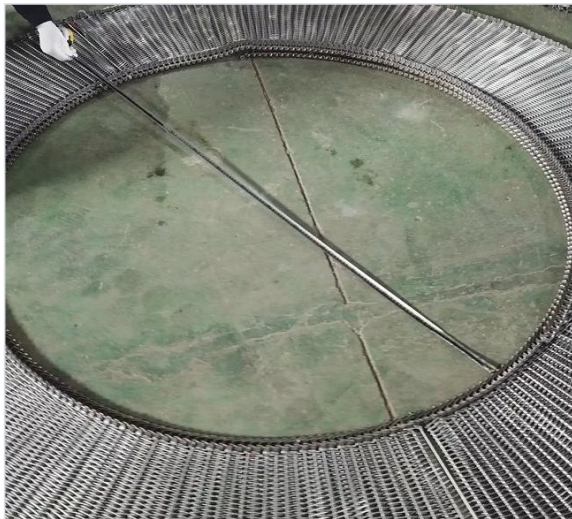
Pakistan: spiral pitch 13.01 mm

How you can check: the same photos are sent to you for your own order.

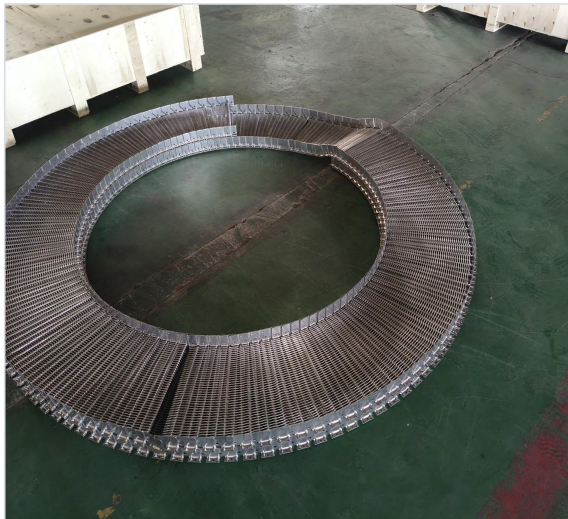
Drum test at the turning diameter

Your concern: a belt that will not turn on your drum.

Every order Spiral freezer, self-stacking and side driven belts are laid out at the turning diameter and measured before shipment.



Spiral belt



Self-stacking belt



Side driven belt

How you can check: ask for the drum-test photos and the measured diameter.

Welds and edges, checked one by one

Your concern: sharp or loose welds on site.

What we check Each weld pressed by hand; weld points smooth and rounded; edges free of burrs; arc residue removed.



Robot welding



Edge check



Edges and welds

How you can check: ask for close-up photos of the welds and edges on your belt.

100% final inspection before packing

Your concern: problems that only show up at installation.

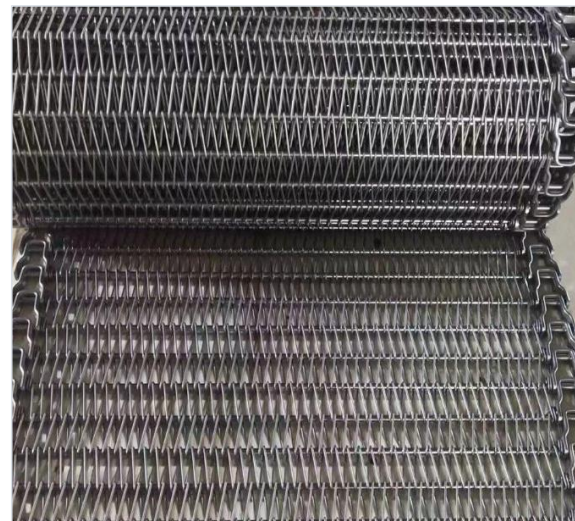
Every belt Pitch, width, length, flatness, welds, edges, cleanliness, appearance and packing condition — on the full belt, not a sample.



Width



Link pitch



Pitch along the belt

How you can check: final-inspection photos and video are sent for your confirmation before shipment.

9 problems we stop before your belt ships



1

Weld residue

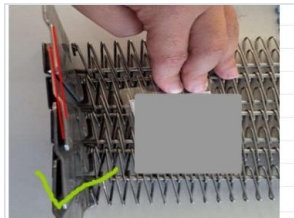
Removed with a weld-cleaning machine.



2

Uneven polish

Polished again before packing.



3

Side plates

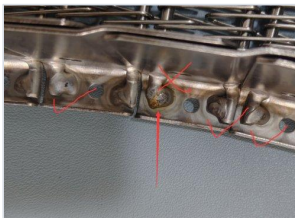
Parallel, small even gap.



4

Bent rods

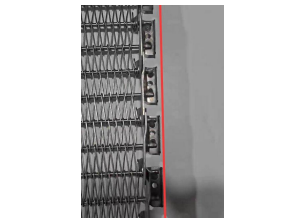
Every rod straight.



5

Loose welds

Each weld pressed by hand.



6

Width

Measured at five points or more.



7

Sprocket fit

Pitch matched to the belt.



8

Burrs

Removed from every tooth edge.



9

Oil film

Thin and even on carbon steel.

What you receive for your order

Your concern: "inspected" with nothing to show for it.

Stage	What you can receive
Drawing	The approved drawing and any revision
Material	Steel mill documents
Trial / first article	Photos and video with measured values, or the physical sample
Before shipment	Final-inspection and drum-test photos and video
Packing	Inner and outer packing photos, packing list

How you can check: tell us at the enquiry which records you need; we agree them before production.

What 100% final inspection does — and does not — mean

Your concern: a supplier who promises perfection.

It does not mean	What it does mean
Zero defects	Every belt is checked, and you see the photos before shipment.
One life for every belt	Life depends on your operating conditions.
A fit from a photo alone	Fit is confirmed on the drawing you approve.
No problems ever	If something goes wrong, we usually reply within 8 working hours (our usual practice, not a contractual deadline) and review the records.

How you can check: ask any supplier how they check — and what they will show you.



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Send your drawing or old-belt sample

- Belt type and application
- Width and length (mm / in)
- Material and operating conditions
- Records you need for your order
- Drawing, old belt or photos

Request a Drawing Review