

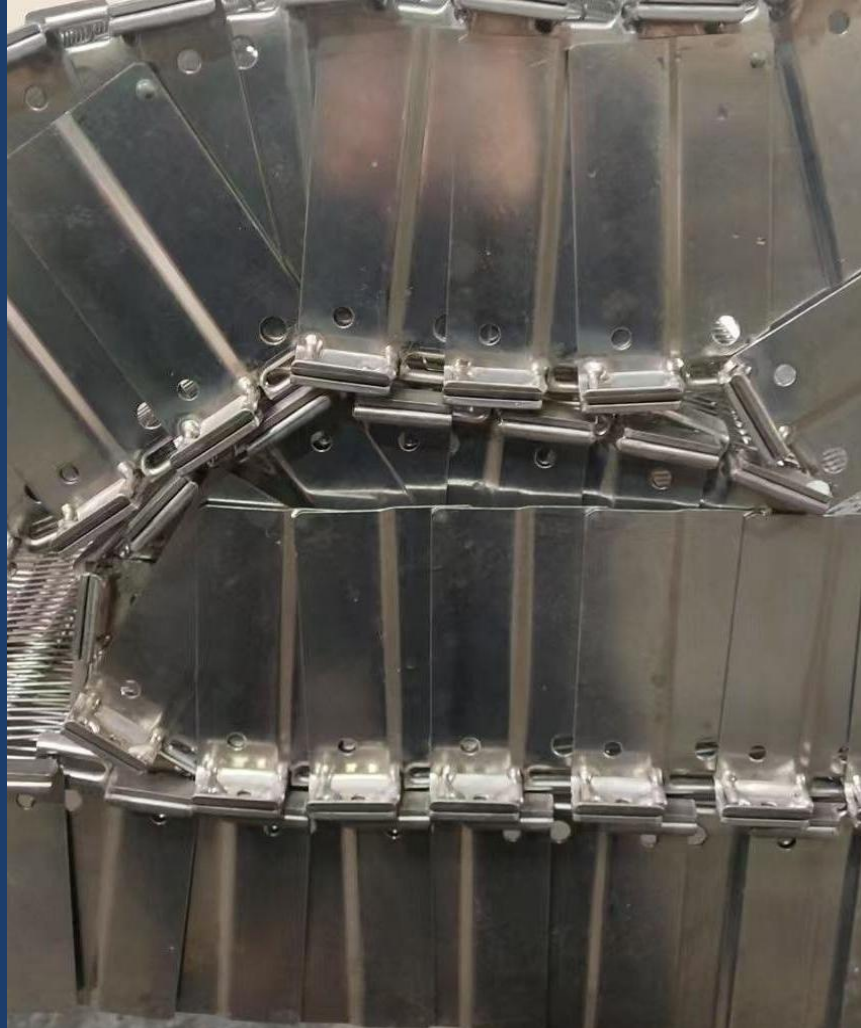


MANUFACTURING CASE STUDIES

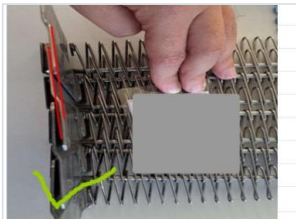
SELF-STACKING BELT

Made to your sample:
four replacement projects

PROVEN · STABLE · VERIFIED



9 checks on every self-stacking belt before it ships



1

Side plates

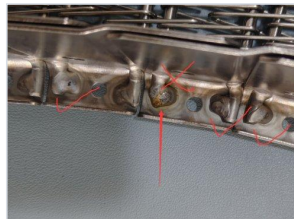
Parallel to the belt with a small, even gap, measured with the belt pulled tight.



2

Rods

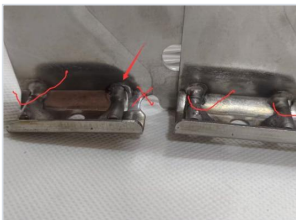
Every rod straight, so the tier plates stay vertical.



3

Weld points

Each weld pressed by hand; position centred, no loose points.



4

Flat-cap welds

Centred, smooth and firm on every link.



5

Tier plates

Vertical and in line along the full belt.



6

Rod to plate

Rod tight against the tier plate, no gap.



7

Inner slot

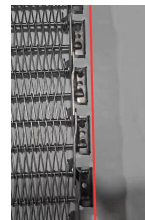
Slot width set to 5.5 mm so the rod slides freely.



8

Sprockets

Direction and pitch checked by turning by hand.



9

Width

Measured at five points or more against your drawing.

The questions buyers ask first

Each answer in this file is a photo, a drawing or a measured value from a real order.

Buyer question	What we show you	Pages
Can you copy my existing belt from a sample?	The buyer's sample measured, then our drawing.	6, 7, 11, 16
Will the new belt work with my old belt?	New belt running with the original sample; new belt beside the original on the buyer's spiral.	9, 23
Are small differences explained before production?	A written sample comparison sent to the buyer.	12
Will the tiers stack and turn?	First-article checks and the belt laid out at the turning diameter.	8, 17, 21
Will it arrive straight and undamaged?	Packing agreed with the buyer; wooden cases.	10, 14, 22

How you can check: ask for the same photos and values for your own order before it ships.

From your sample to a packed belt

You approve each stage before the next one starts.

#	Stage	What we do	What you receive or approve
1	Your sample	A short piece of your belt, or photos with key sizes.	Our written questions
2	Measurement	Rod pitch, wire, rod, spiral pitch, tier plate height and thickness.	Measurement photos
3	Drawing and tooling	Drawing in mm and in; tooling made for the tier plate if needed.	You approve the drawing
4	First article	First section measured against the drawing and your sample.	First-article photos
5	Turning check	Belt laid out at the turning diameter.	Photos of the turn
6	Mass production	Built to the approved drawing; sizes checked again.	Production photos
7	Final inspection	100% final inspection with the nine checks on page 2.	Inspection photos
8	Packing	Packing method agreed with you; wooden cases.	Packing photos

How you can check: every stage leaves a photo, a drawing or a measured value you can ask to see.

Spain, Europe: a self-stacking belt copied from the buyer's sample

The buyer's task: a new supplier for a belt already running on a self-stacking freezer.

REPLACEMENT PROJECT

Buyer Belt distributor.

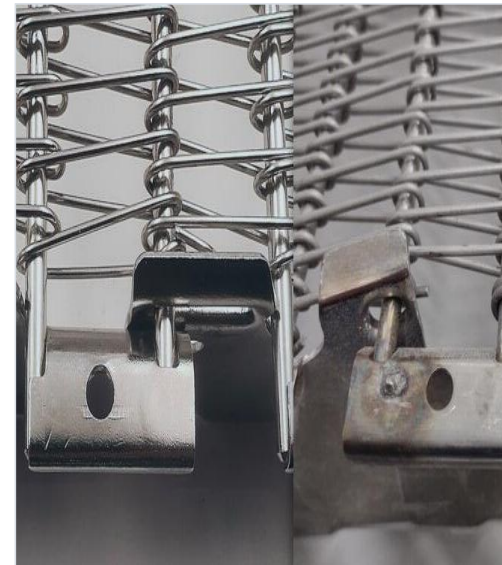
Start The buyer sent a section of the original belt. We measured it and made dedicated tooling for the tier plates.

First order 420 mm (16.54 in) wide, 50 m (164 ft).

Since then Repeat orders in 420 mm and 760 mm (29.92 in) widths, the largest 500 m (1,640 ft).



Original tier plate (brand marks blurred)

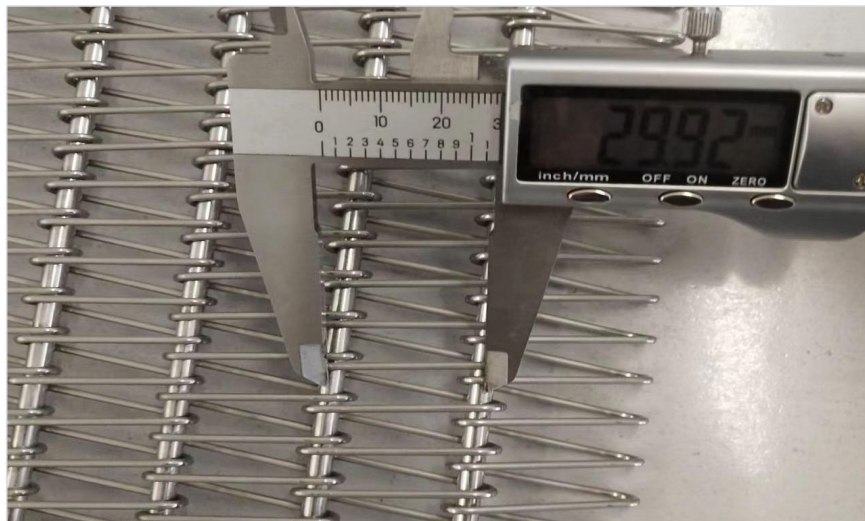


Original belt edge

The buyer's sample, measured

The buyer's concern: a copy that looks right but does not fit.

Measured Rod pitch, wire, rod, tier plate height and edge on the original section before drawing.



Rod pitch on the original sample



Tier plate and link on the original sample

How you can check: send a short section of your belt; we return measurement photos with our drawing.

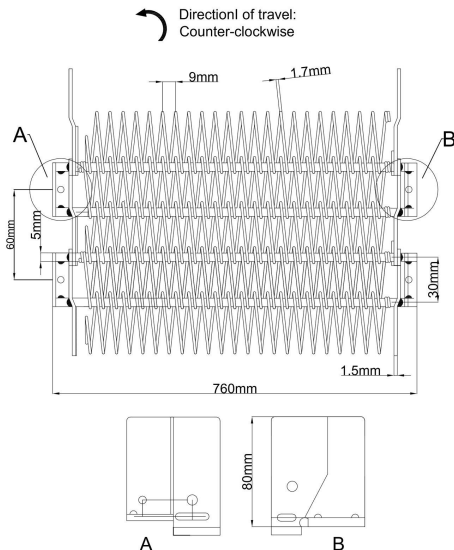
One drawing for every repeat order

The buyer's concern: repeat orders that drift from the first one.

Drawing Spiral pitch, rod pitch, wire, rod, tier plate thickness and height, direction of travel.

Shown The drawing used for the 760 mm repeat order: spiral pitch 9 mm, rod pitch 30 mm, wire 1.7 mm, rod 5 mm, tier plate 1.5×80 mm.

Repeat Each new order is checked against the approved drawing.



Our self-stacking belt drawing

How you can check: ask for our drawing of your belt before production starts.

First article checked against the sample

The buyer's concern: tier plates that do not stack the way the original does.

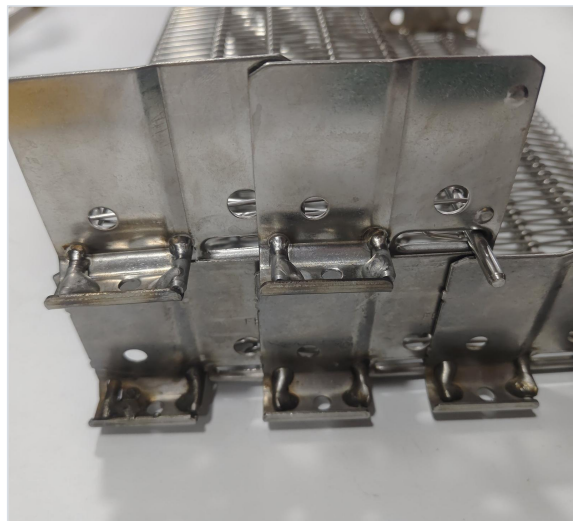
Checked Tier plate shape, height and the link joint on the first section, with a QA photo report sent to the buyer.



Link joint



Tier plate height



Tier plates stacked

How you can check: ask for the first-article photo report of your belt.

New belt running with the original sample

The buyer's concern: a new section that will not run with the belt already in use.

What we did Joined the original sample to the new belt and ran them together in the workshop; the video went to the buyer.



Running test (still from the video)



Tier plates in line

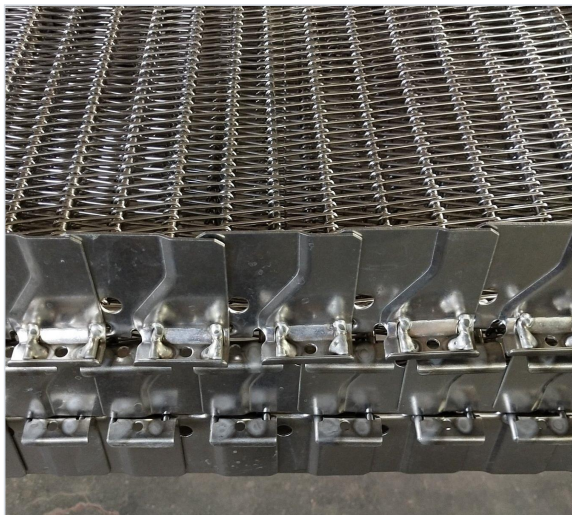
How you can check: send a section of your old belt; we can film it running with the new belt.

Final inspection and wooden cases

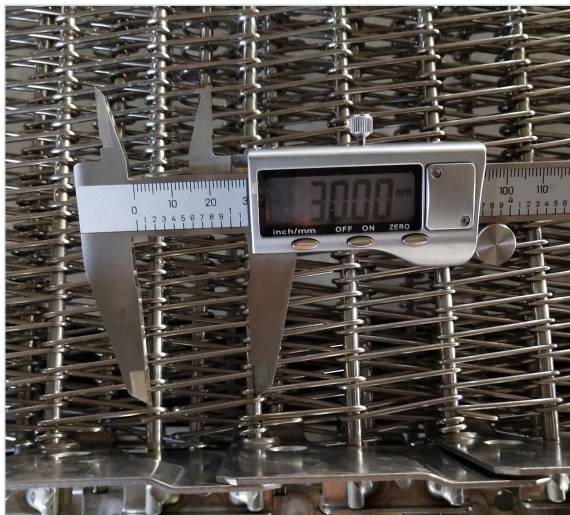
The buyer's concern: plates bent in transit.

Checked Rod pitch and tier plates measured again before packing.

Packed In wooden cases (labels blurred).



Finished belt



Rod pitch 30.00 mm



Wooden cases

How you can check: ask for final-inspection and packing photos before shipment.

Malaysia, Asia: a wide self-stacking belt from a sample

The buyer's task: match an original 1,069 mm wide belt from a short sample.

REPLACEMENT PROJECT

Buyer Belt distributor.

Belt SUS304 self-stacking belt, 1,069 mm (42.09 in) wide.

Measured on the sample Rod pitch 30 mm, tier plate height 80 mm, wire 1.7 mm and the link sizes.



Original sample (brand marks blurred)



Link size



Tier plate height

Small differences explained before production

The buyer's concern: finding a difference only after the belt arrives.

What we did Sent a written sample comparison: clip tab shape and weld seam length differ slightly from the original; fit and function are the same.

Difference 1 · Clip Tab Shape (Photo 1)

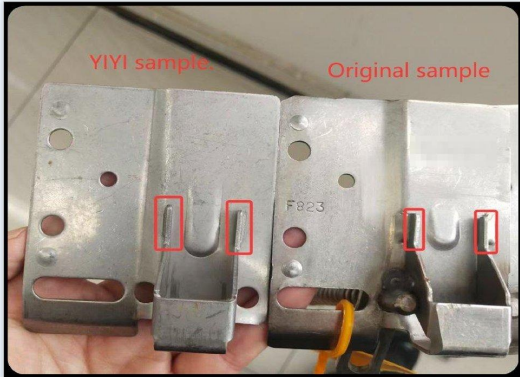


Original Sample
Round / oval raised tab (stamped protrusion)
YIYI Sample
Elongated slot-style tab (open slot form)
✓ No impact on fit or assembly. Both tab forms engage the same way. Compatible for production use.

Self-Stacking Belt Sample Comparison

Comparison 1: clip tab shape

Difference 2 · Weld Seam Length (Photo 2)



Original Sample
Standard weld seam length (shorter seam at clip joint)
YIYI Sample
Extended weld seam length (longer seam at clip joint)
Fit and function confirmed the same as the original; approved by the buyer.

Self-Stacking Belt Sample Comparison

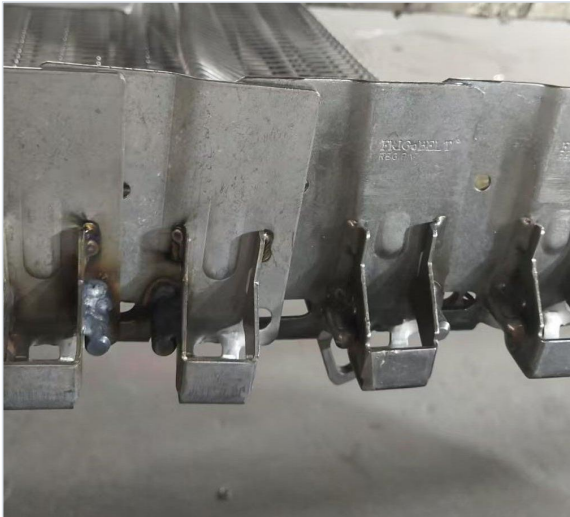
Comparison 2: weld seam length

How you can check: ask for a written comparison of our sample against your original.

First article measured

The buyer's concern: a wide belt that is not even across its width.

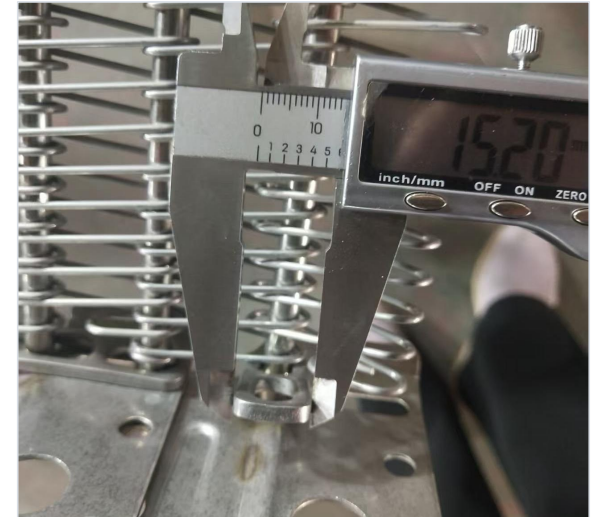
Checked Tier plates, rod pitch and width on the first section before mass production.



Tier plates



Plate measurement



Measuring a plate

How you can check: first-article photos are sent with the measured values.

Checked again, then cased

The buyer's concern: a 1-metre-wide belt damaged in transit.

Checked Tier plates and sizes measured again on the finished belt.

Packed Wooden cases (labels blurred).



Finished belt



Tier plate height



Wooden cases

How you can check: ask for final-inspection photos before shipment.

Australia, Oceania: a self-stacking belt with taller tier plates

The buyer's task: copy a belt with 120 mm tier plates, taller than our standard.

REPLACEMENT PROJECT

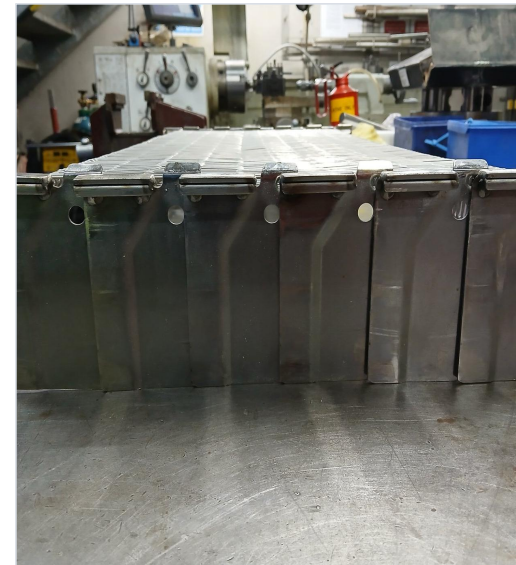
Buyer Belt distributor.

Belt SUS304, 760 mm (29.92 in) wide; tier plate 1.5×120 mm (0.06×4.72 in).

Tooling Dedicated tooling made for the taller tier plate.



Buyer's sample



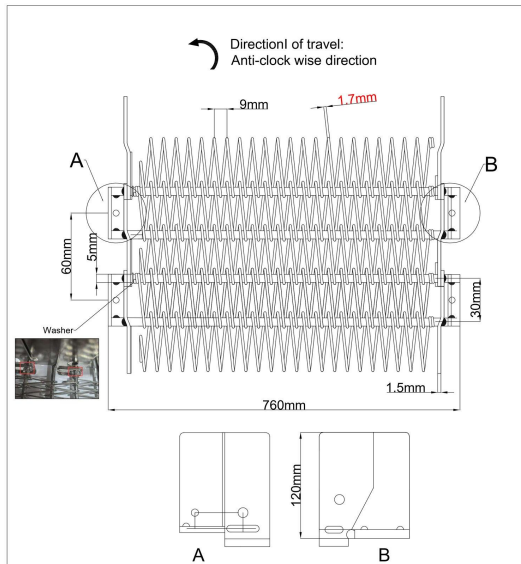
Tall tier plates on the sample

Drawing approved before tooling

The buyer's concern: paying for tooling that does not match.

Drawing Spiral pitch 9 mm, rod pitch 30 mm, wire 1.7 mm, rod 5 mm, tier plate 1.5 × 120 mm, anticlockwise travel.

Approved The buyer approved the drawing before the tooling was made.



Our drawing for the 120 mm tier plate

How you can check: ask for our drawing before any tooling is made.

The 120 mm tier plate, measured

The buyer's concern: a taller plate that does not stack.

Checked Tier plate height, shape and stacking on the first section.



Tier plate



Height 120 mm



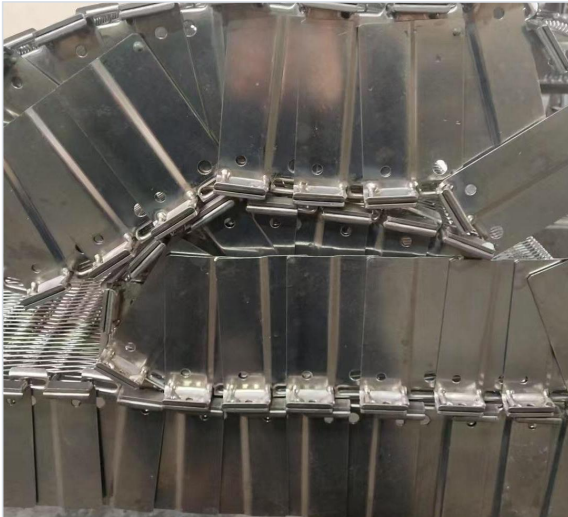
Stacking check

How you can check: first-article photos are sent before mass production.

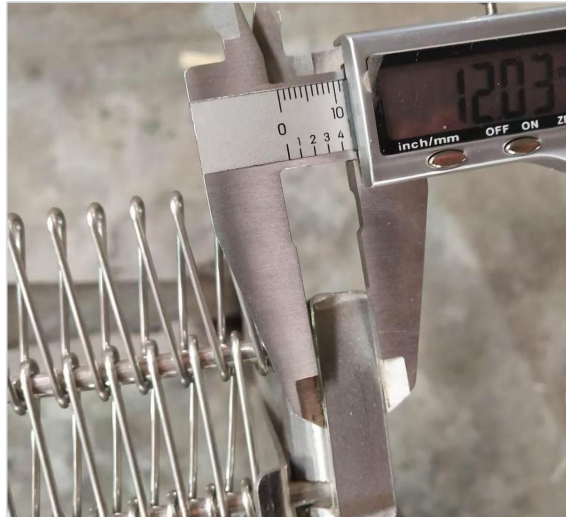
Stacking and height checked on the finished belt

The buyer's concern: tiers that do not nest after shipping.

Checked Tiers nested in a turn, tier plate height measured again before packing.



Tiers nested in a turn



Height 120 mm



Tier plates

How you can check: ask for photos of the belt in a turn before shipment.

Korea, Asia: a self-stacking belt for an existing spiral

The buyer's task: a replacement that runs next to the original belt on the same spiral.

REPLACEMENT PROJECT

Buyer Belt distributor.

Belt SUS304, 420 mm (16.54 in) wide; tier plate 1.5 × 60 mm; 220 m (722 ft).

Start The buyer sent a sample of the original belt; we measured it and drew it.



Buyer's sample



Tier plates on the sample



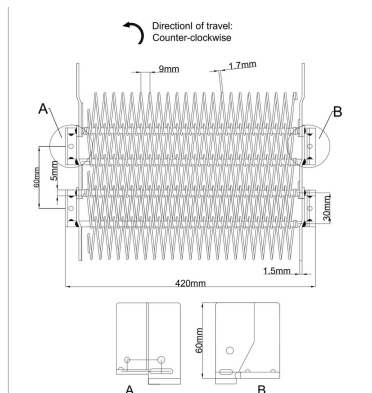
Rod pitch on the sample

Drawing, then the first section

The buyer's concern: a first section that differs from the sample.

Drawing Spiral pitch 9 mm, rod pitch 30 mm, wire 1.7 mm, rod 5 mm, tier plate 1.5×60 mm.

First article Measured against the drawing before mass production.



Our drawing



First section



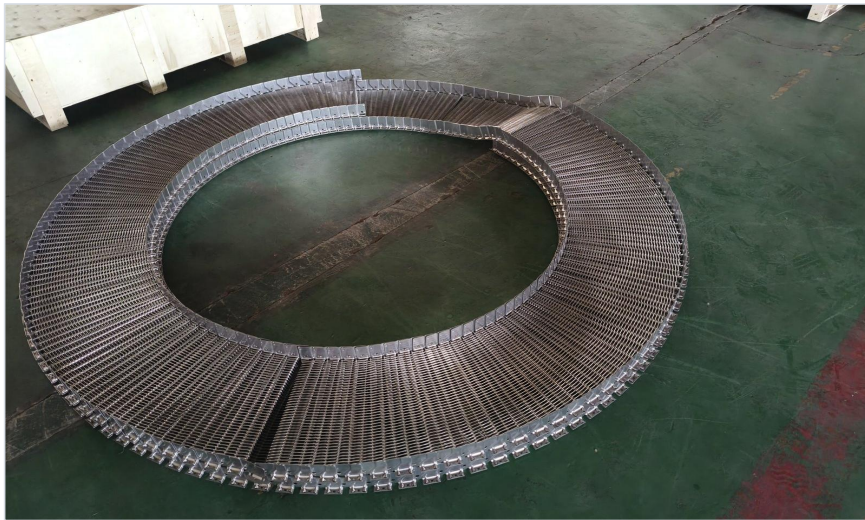
Rod pitch

How you can check: first-article photos are sent with the measured values.

Belt laid out at the turning diameter

The buyer's concern: a belt that does not turn on the spiral.

What we did Laid the finished belt out in a full circle on the workshop floor and measured the turn.



Belt in a full circle



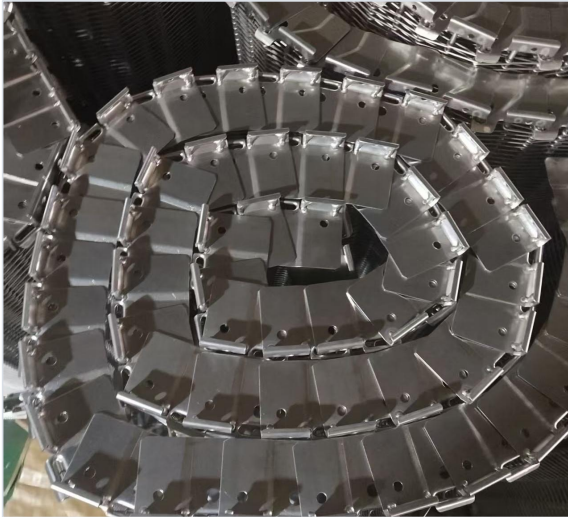
Measuring the turn

How you can check: every self-stacking belt order is checked at the turning diameter before shipment.

Packing agreed with the buyer

The buyer's concern: tier plates bent in the case.

What we did Shared our standard packing proposal; the belt was packed in the method agreed with the buyer, in wooden cases.



Belt coiled for packing



Inner packing



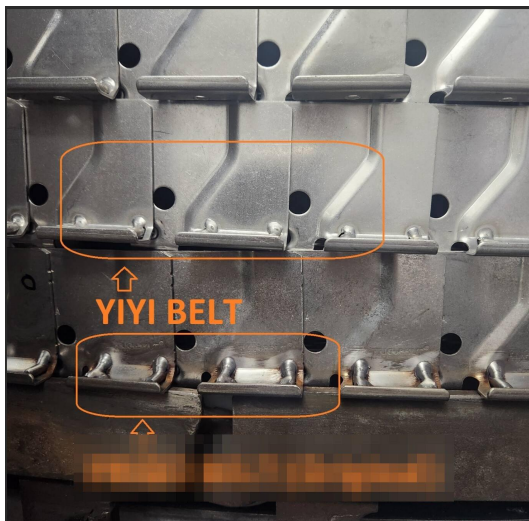
Wooden cases

How you can check: ask for our packing proposal for your belt before shipment.

New belt next to the original on the buyer's spiral

The buyer's concern: will the new belt run alongside the original?

On site Photos from the buyer's site: the new YIYI belt and the original belt running on the same spiral.



YIYI belt above, original belt below (names blurred)



Both belts on the spiral

How you can check: send photos of your spiral; we compare your belt with ours before quoting.



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Metal Conveyor Belt Manufacturer

for OEMs & Professional Distributors

Email: info@yiyimeshbelt.com

Phone / WhatsApp: +86 134 5177 3742

Website: www.yiyimeshbelt.com
www.yiyimeshbelts.com

Company: Ningjin Yiyi Mesh Belt Co., Ltd.

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Send your old belt sample or photos

- Belt width and length (mm / in)
- Tier plate height and thickness
- Drum diameter and turn direction
- Operating conditions
- A short section of your old belt

Request a Drawing Review