

All cleaning and disinfecting procedures must be re-examined periodically to confirm that the required hygiene level is maintained. Evaluation and inspection procedures should be carried out in order to verify that long term compliance with procedures is observed and specific local regulations and requirements are met.

必须定期重新检查所有清洁和消毒程序，以确认保持所需的卫生水平。应执行评估和检查程序以验证长期遵守程序的情况，并符合具体的当地法规和要求。

As for any other plant operation, cleaning and disinfecting should be equally documented. If a HACCP concept is applied, these procedures should be treated as Critical Control Points (CCPs). If a Quality System like ISO is in operation, they should be integrated in the System.

与任何其他工厂操作一样，清洁和消毒也应同样记录在案。如果应用HACCP概念，这些程序应被视为关键控制点（CCPs）。如果像ISO这样的质量体系正在运行，则应将它们集成到系统中。

It is vital that all cleaning procedures consider the following critical factors that could affect hygiene levels and influence the longevity of the belt itself.

至关重要的是，所有清洁程序都要考虑以下可能影响卫生水平并影响输送带本身使用寿命的关键因素。

- ◎ The amount of time the belt is exposed to the cleaning/disinfecting substance.  
输送带在清洁/消毒物质中所接触的时间。
- ◎ The concentration of the cleaning/disinfecting chemicals.  
清洁/消毒化学品的浓度。
- ◎ The ambient temperature.  
环境温度。
- ◎ The conveyor construction.  
输送机结构。

### General Information: (基本信息)

- ◎ Safety is a primary concern; you should observe any local health and safety regulation and use commonsense when dealing with any machinery. Particular care should be taken in the machine around the area of the pulleys or rollers which can easily trap body parts and cause serious injuries.

安全是首要关注的问题；在处理任何机器时，您应该在利用常识并且遵守任何当地的健康和安全法规的前提下。在机器的皮带轮或滚轮周围区域应特别小心，这些区域很容易卡住身体部位并造成严重伤害。

- ◎ Most large Detergents and Cleaning Solvent manufacturers have tested their solvent's effects on Volta belts and can therefore recommend the best solution for your application.  
大多数大型洗涤剂 and 清洁溶剂制造商已经测试了他们的溶剂对Volta皮带的影响，因此可以为您的应用推荐最佳解决方案。
- ◎ When converting from modular belt to Volta Positive Drive belts the cleaning procedure can be simplified and the use of highly concentrated harsh chemicals can be reduced. You are advised to re-evaluate your procedure in order to save time, use less water and use less chemicals.  
By re-evaluating the procedure you can also reduce costs and increase belt life.  
当从模块化皮带转换为Volta正传动皮带时，可以简化清洁程序，并减少使用高浓度的刺激性化学品。建议您重新评估您的程序，以节省时间，少用水，少用化学品。通过重新评估该过程，您还可以降低成本并延长皮带寿命。
- ◎ We do not recommend that you remove Volta belts for soaking. This procedure was developed in order to combat the low hygiene level of modular belts and is generally not necessary once Volta Positive Drive Belts have been fitted, in which case you are advised to re-evaluate your cleaning procedure. If you still feel the need to perform the soaking stage, Volta can offer you a lace solution which enables frequent belt removal. We suggest that you contact your nearest Volta representative to evaluate the effect this could have on the belt.  
我们不建议您取下Volta皮带进行浸泡。该程序是为了解决模块化皮带的低卫生水平而开发的，一旦安装了Volta正传动带，通常就不需要这样做，在这种情况下，建议您重新评估您的清洁程序。如果您仍然觉得需要执行浸泡阶段，Volta可以为您提供一种简易解决方案，可以经常拆卸皮带。我们建议您联系离您最近的 Volta 代表，评估这对输送带的影响。
- ◎ One of the most important recommendations regarding the belt cleaning procedure is for you to make sure that the belt is left as dry as possible at the end of the process; any leftover "pools" of water will reduce the belt life.  
关于皮带清洁程序的最重要的建议之一是确保您在过程结束时皮带尽可能保持干燥；任何残留的“积水”都会降低皮带的使用寿命。

## Cleaning Procedure Tips (清洁程序提示)

### 1、 Completely stop and disconnect any electrical flow to the conveyor.

完全停止并断开输送机上的任何电流。

### 2、 Release the quick tension unit.

松开快速张紧装置。

### 3、 Removal of Bulky Product Residue.

We advise you not to use any sharp tools or harsh metal brushes/Wire wool to remove stuck

material;a flat low friction tool or soft cloth should be used to loosen remains if necessary.

**去除输送带上的大块产品残留物。**

我们建议您不要使用任何锋利的工具或粗糙的金属刷/金属丝球来清除卡住的残留物材料;如有必要, 应使用扁平的低摩擦工具或软布来松开残留物。

#### **4、 Pre-Rinse**

In order to remove any food residue remaining on the belt surface should be thoroughly rinsed by using low pressure water at 130°F/54°C to 160°F/71°C. Water pressure used should be at 10 to 15 Bar. A thorough pre-rinse can reduce the amount of chemicals required in the cleaning process. You should avoid rinsing of belt surface closely with high pressure water jet.

##### **预冲洗**

为了清除皮带表面残留的任何食品残留物, 应使用130°F ( 54°C) 至160°F ( 71°C) 的低压水彻底冲洗。使用的水压应为10至15Bar。彻底的预冲洗可以减少清洁过程中所需的化学品量。应避免用高压水射流直接冲洗皮带表面。

#### **5、 Foaming**

Selecting the detergent type most suitable will depend on the character of the product being conveyed. We recommend that you consult with your detergent supplier for best cleaning results and minimal possible harm to the belt surface.

Commonly used Mild Alkaline Foam Cleaner, Acidic Foam Cleaner, or Chlorinated Alkaline Foam cleaner with concentration of 2~3% and applying time of around 15 minutes are safe to use on all Volta belts.

##### **泡沫清洗**

选择最合适的洗涤剂类型将取决于所输送产品的特性。我们建议您咨询您的洗涤剂供应商, 以获得最佳清洁效果和对输送带表面的伤害降至最低。

常用的低刺激碱性泡沫清洁剂、酸性泡沫清洁剂或氯化碱性泡沫清洁剂, 浓度为 2-3%, 施用时间约为 15 分钟, 可在所有 Volta 传送带上安全使用。

#### **6、 Post-Rinse**

The post rinse process is to ensure that all pieces of remaining product wastage will be removed from the equipment. During this process it is also important to make sure that all chemical residues are thoroughly removed. A low pressure wash with warm water is best for this stage of the process. Water temperature should not exceed 130°F/54°C to 160°F/71°C. Any residual chemicals could cause damage to the conveyor belt and reduce its life span.

##### **后冲洗**

后冲洗过程是为了确保所有剩余的产品残渣都将从设备中清除。在此过程中, 确保彻底清除所有化学洗剂残留物也很重要。用温水进行低压清洗最适合该过程的这一阶段。水温不应超过 130°F (54°C) 至 160°F (71°C) 。任何残留的化学品都可能对传送带造成损坏并缩短其使用寿命。

## 7、 Additional Sanitizing.

It is highly important to make sure that your belt has been meticulously cleaned before beginning the sanitation process. Sanitation chemicals will not have any effect on a surface that is not completely clean.

### 追加消毒

在开始卫生过程之前，确保您的皮带已经过仔细清洁过，这一点非常重要。卫生化学品不会对不完全清洁的表面产生任何影响。

As for the foaming stage, selecting the detergent type most suitable will depend on the character of the product being conveyed. We recommend that you consult with your detergent supplier for best cleaning results and minimal possible damage to the belt surface.

至于发泡阶段，选择最合适的洗涤剂类型将取决于被输送产品的特性。我们建议您咨询您的洗涤剂供应商，以获得最佳清洁效果，并将对输送带表面的损坏降至最低。

Commonly used Neutral Foaming Disinfection, Per-Acetic Acid and Alkaline Disinfections with concentration of 1-2% and applying time of around 15 minutes are safe to use on all Volta belts.

Various types of chemical disinfectants act differently on certain groups of bacteria and under certain pH-ranges. In order to achieve the maximum disinfecting effect, you are recommended to periodically alternate the type of the chemical disinfectant applied. If using Chlorine at this stage it is not recommended to exceed 200ppm, Ozone can be used according to local health and safety regulation.

常用的中性发泡消毒、过醋酸和碱性消毒，浓度为1-2%，施用时间约为15分钟，可在所有 Volta皮带上安全使用。

各种类型的化学消毒剂对某些细菌群和某些pH值范围的作用不同。为了达到最大的消毒效果，建议您定期更换所应用的化学消毒剂的类型。如果在此阶段使用次氯酸钠，则不建议超过 200ppm，臭氧可根据当地健康安全法规内使用。

## Check list after cleaning procedure:

(清洁程序后的检查清单)

- 1、 It is most important that all harsh chemical residues are rinsed off the surface of the belt.  
最重要的是，所有刺激性化学残留物都要从传送带表面冲洗干净。
- 2、 Make sure that the belt is left dry as possible at the end of the process; any leftover "pools" of water will reduce the belt life. Run the conveyor or lift the belt to drain the excess water.  
确保皮带在清洁过程结束时尽可能保持干燥;任何剩余的“积水”都会降低皮带的使用寿命。  
运行输送机或抬起传送带以排出多余的水。

## Check list before activating your production line:

(在重启生产线之前的检查清单)

- 1、 Chemical residues have been rinsed of the belt.  
皮带上的化学残留物已被冲洗干净。
- 2、 Tension (if necessary) was restored to the correct measure.  
张力 (如有必要) 恢复到合适的程度。
- 3、 Belt tracking is restored.  
皮带运转恢复正常。
- 4、 There are no obstructions along the conveyor construction that could prevent the belt from running smoothly.  
输送机结构上没有障碍物, 可能会阻止输送带平稳运行。
- 5、 Belt is not vacuumed pinned to the conveyor.  
皮带没有悬浮在输送机之上。

## Conveyor Constructions Tips : (must comply with local health and safety regulations)

输送机结构提示 (必须符合当地健康和法规)

- 1、 All plant equipment should be designed to be adequately cleanable.  
所有工厂设备应设计为可充分清洁型的。
- 2、 Open Side-Guards should be fitted-or removable sides for easy access to internal wash down.  
应安装开放式侧护罩或可拆卸侧面, 以便于内部冲洗。
- 3、 Create a natural flow design - avoid any dirt traps and fluid accumulation points.  
创建自然流动设计 - 避免任何污垢死角和流体积聚点。
- 4、 Include a quick tension unit-allows for easy tension release and belt lifting for internal wash down.  
包括一个快速张紧装置 - 允许轻松释放张力和皮带提升以便内部冲洗。
- 5、 Open-Side conveyor - a possible solution for easy endless belt removing and refitting.  
开式侧输送机 - 易于拆卸和改装无尽皮带的可能解决方案。



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