

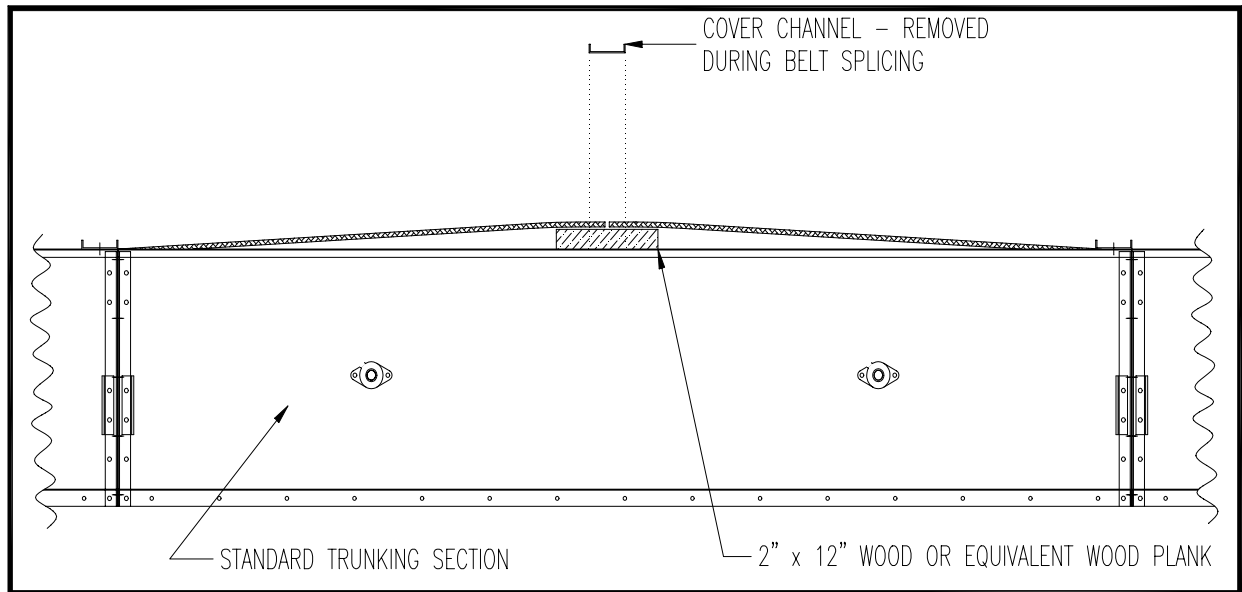


# EXHIBIT - BELT SPLICING

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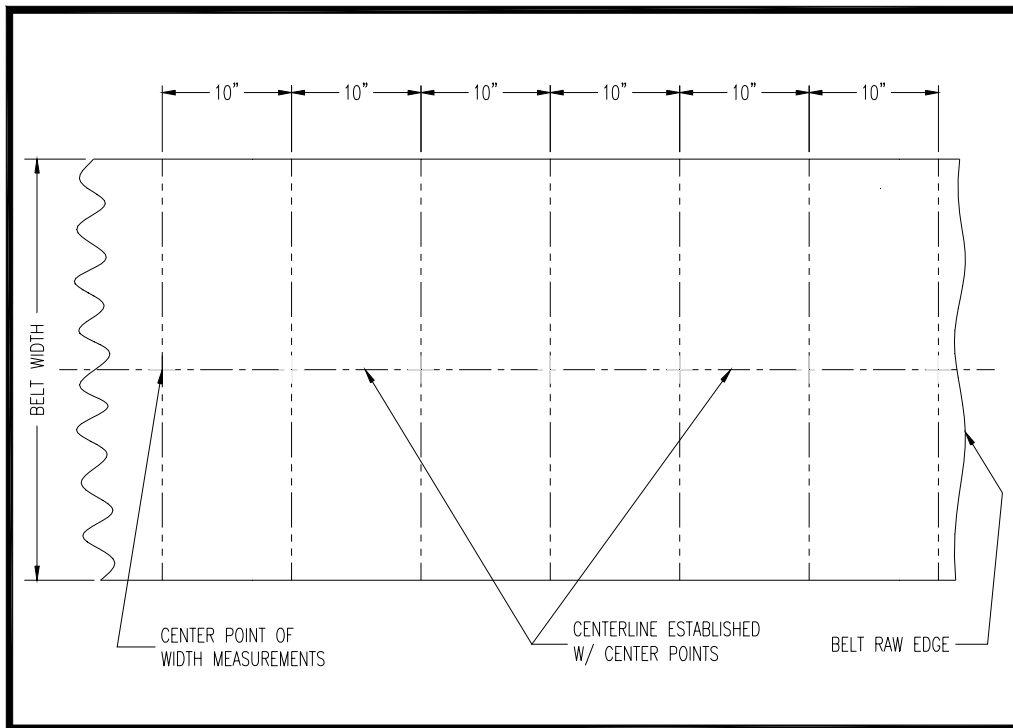
## BELT

Thread the Belt through the conveyor with the Tail Section fully retracted. A belt-pulling device must be attached to each end of the belt that will prevent damage to the belt. A 2" x 12" wood plank or equivalent is to be placed widthwise on the trunking section (shown below). The belt shall be brought together over the wood working surface that will be used for splicing. The belt splicing procedure can now begin.



## FINDING THE BELT CENTERLINE

The centerline can be found with the following procedure. The belt width must be measured at five points. The first measurement should be near the end of the belt. Then, measure the belt width in 10-inch intervals marking them. Each measurement must then be divided by two and marked on the belt. Then, draw a straight centerline using the points as a guide for the centerline as shown below.

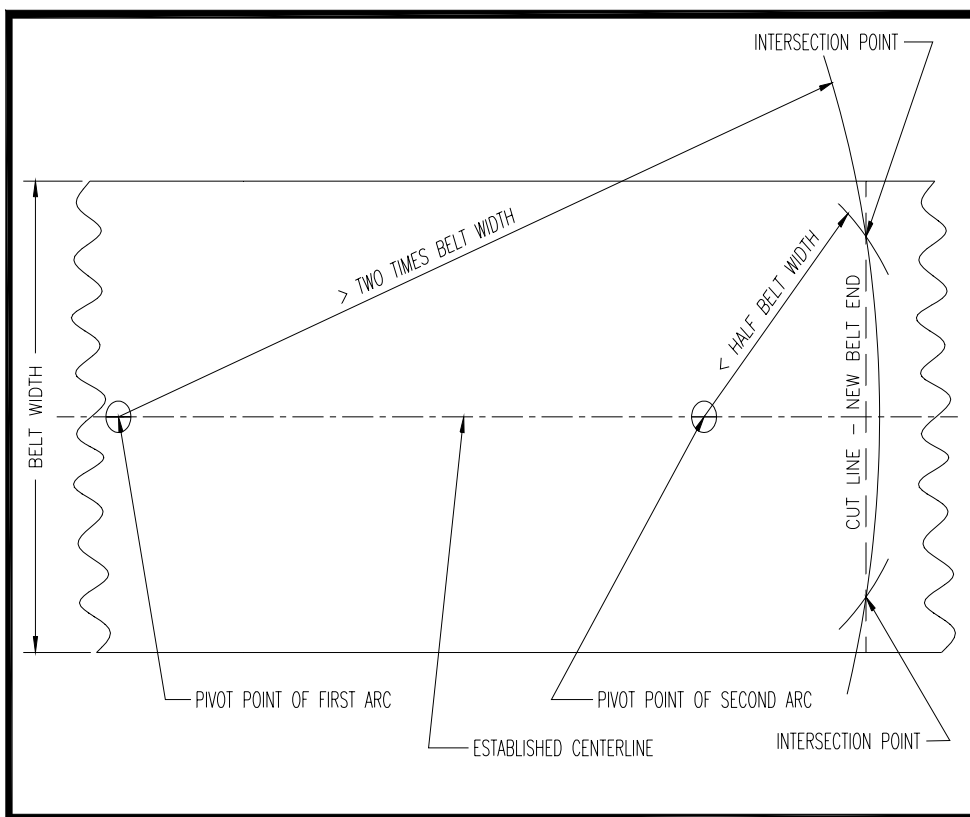


## SQUARING THE BELT ENDS

A double arc method must be used to establish a cut line on the belt. A centerline must be drawn by using the procedure on the following page. Then, pick a point on the centerline at least two times the belt width. From this point strike an arc across the width of the belt at the belt end. A nail may be used as a pivot point with good cord or twine used as the arm of the arc. A marking or chalk device should be used to mark the arc.

A second set of arcs must be struck with the pivot point of the arcs on the centerline and with a radius of slightly less than half of the belt width.

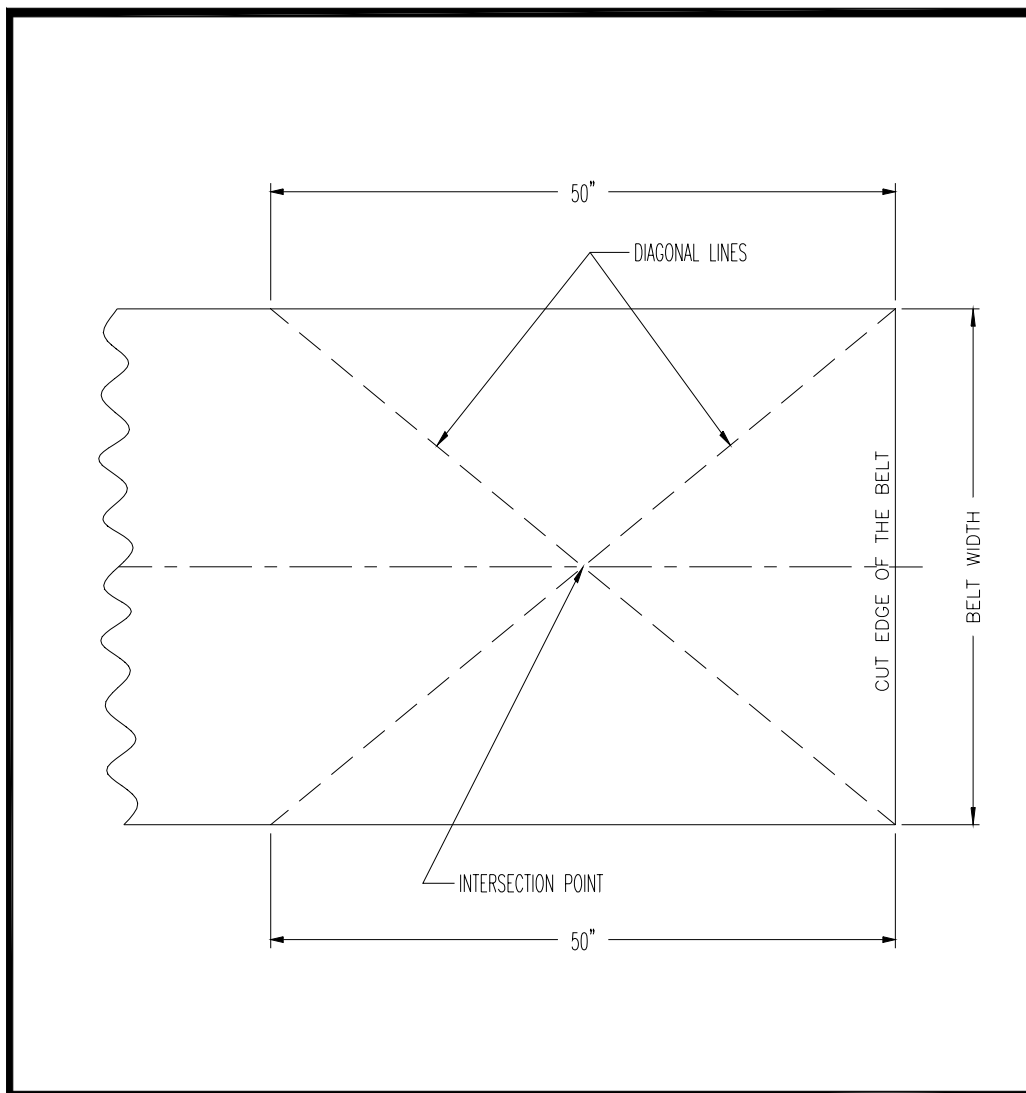
A cut line is drawn where the two arcs intersect each other as shown below.



## CHECKING THE SQUARENESS OF THE BELT CUT

Check the accuracy of the belt cut with the following method. Measure lengthwise 50 or more inches from each edge of the belt using the exact same measurement. Draw a line with a straight edge tool a diagonal line across the belt. This line must be drawn from the 50-inch point to the end corner on the opposite side of the belt as shown below. Draw another line using the same procedure from the opposite side of the belt to form an “X” as shown below.

The intersection point of the two lines that forms an “X” must be on the line that is the centerline of the belt.



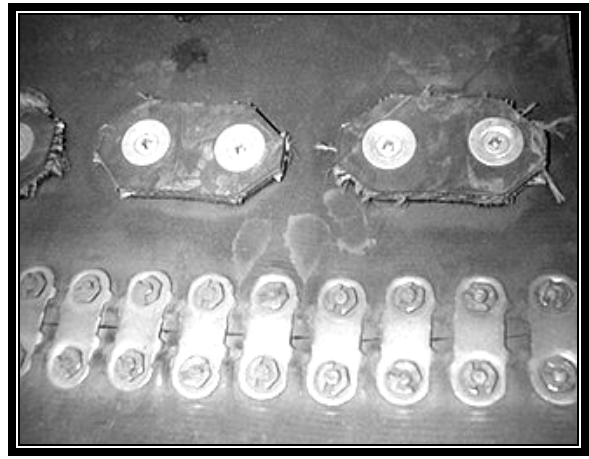
## **SPLICE PROTECTORS/WIPER CLEATS**

A drawing is included in the Exhibits of this manual that shows that specifications for installing the Splice Protectors/Wiper Cleats. The Splice Protectors/Wiper Cleats are extremely important to the proper operation the Hi Roller Conveyor. These cleats protect the splice from prematurely wearing out from sliding on the bottom return liner. The cleats also clean the bottom liner as the belt slides back to the Tail Section. Material is cleaned off the bottom and conveyed to the Tail Section. The cleats also do some reloading of the material as they go around the Tail Pulley. They are very important!

## **BELT TENSIONING**

The belt must be properly tensioned after the splice and splice protectors/wiper cleats have been installed. Also, all of the tools, wood planks, or any other materials must be removed from the conveyor. Then, the belt is ready to be tightened with the proper tension. Please follow the Belt Tension Procedure on a separate Exhibit in the manual. The belt is tightened with the Take-Up Rods that are on the centerline of the Tail Pulley. Adjust these rods evenly to prevent misalignment of the Tail Pulley. The belt must be tightened to the specification shown of the Belt Tension Procedure Exhibit. The belt tension will have to be checked daily for the first several days and then weekly until the belt tension has stabilized and adjustments are not

**Splice Protectors/Wiper Cleats MUST be installed on any type of splice, mechanical or vulcanized!!**



required. This may happen in a short time. But, normally it can take several months to have the belt tension stabilize.

NOTE: Take-Up Rods are only for Belt Tightening!! They should only be used for slight Belt Tracking adjustments!!

The top Leveling Rods must only be used to level the Tail Section.

