

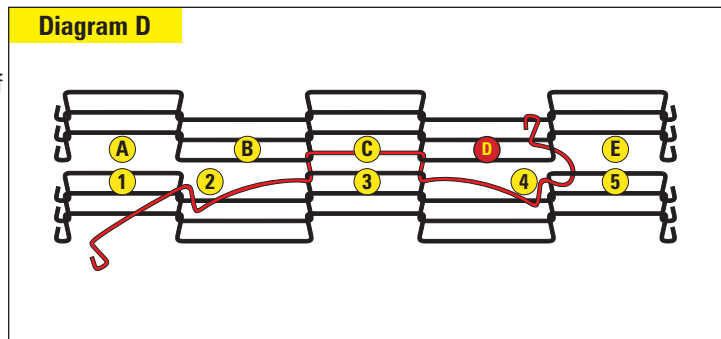
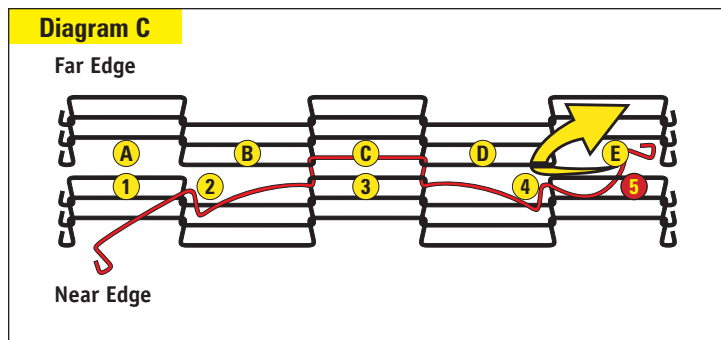
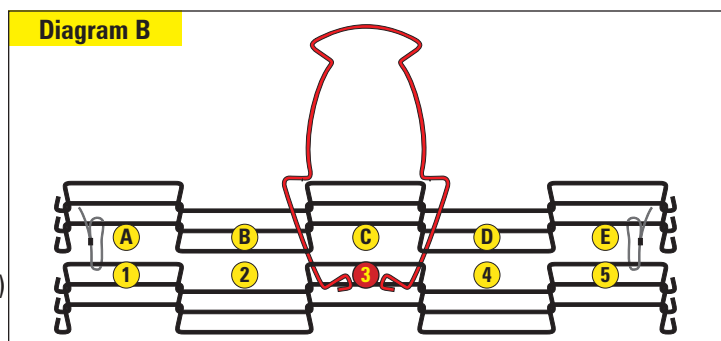
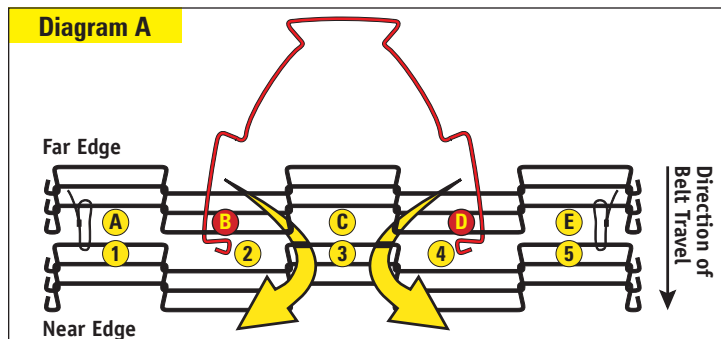
Splicing a Flat-Flex® Single Loop Edge

STEP 1 – BEGIN SPLICING IN THE CENTER

- Move the two ends of the belt to be spliced to the discharge end of the conveyor unit.
- Confirm that the edge loops are curving back away from the direction of belt travel (as shown in **Diagram A**). If not, check to be sure that the belt is not threaded backwards on the conveyor.
- Lay the strand down between the two belt edges and check to see that the edge loops are going in the same direction as the belt's edge loops. (The strand must also be "right side up" for it to lay flat. You will know immediately if you have installed the splice strand "wrong side up" and will have to start over.)
- BEND the strand from each side enough to INSERT the ends into the two spaces next to the center space (**Spaces B and D in Diagram A**)
- INSERT the strand ends into the center space of the opposite edge (**Space 3 in Diagram B**)
- Pull the ends of the strand through until the center space "locks" in place (You should be pulling the strands toward you)
- Use pliers or the Wire Belt Wire Straightening Tool to STRAIGHTEN the wire in the center space (Once the center is connected, you may remove the ties holding the belt edges together)

STEP 2 – WEAVE STRAND TO ONE SIDE

- BEND one end of the wire up and INSERT it around the Z-bend in the next space on the edge of the wire closest to you (**Space 5 on Diagram C**). Always try to avoid bending the wire at the Z-bend!
- BEND the wire toward the center and INSERT around the Z-bend next to the center space (**Space D on Diagram D**)
- Pull the strand wire through the mesh and STRAIGHTEN it with your pliers
- Repeat these three moves until you reach the side edge of the belt
- Using your pliers, connect the strand's edge loop to the belt's edge loop (on the far edge)
- Connect the edge loop on the near edge of the belt to the strand's edge loop
- STRAIGHTEN the strand with your pliers



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STEP 3 WEAVE STRAND TO THE OTHER SIDE

- Repeat the steps in #3, going in the opposite direction, weaving to the other side edge of the belt (**Diagrams C through G**)
- If you are installing a new belt, you are finished splicing

STEP 4 CHECK DRIVE SHAFT SPROCKET ALIGNMENT

- There should be a 3/16" clearance between all sprockets (and/or blanks) and the Z-bends next to them
- Check alignment of sprocket teeth with a straight edge (only necessary if the sprockets are not keyed to the Drive Shaft)

STEP 5 CHECK ENTIRE BELT CIRCUIT

- Z-bends should NOT come in contact with ANY conveyor component (including end rolls, wear strips, transfer support rails or nose bars, etc.)
- Adjust as needed

STEP 6 ADJUST TENSION

- Flat-Flex® is a low tension belt. Use minimal tension... only enough so that drive sprockets properly engage the belt
- Run conveyor and check to be sure it runs smoothly
- Note: Too much tension will cause premature belt failure!

Diagram E

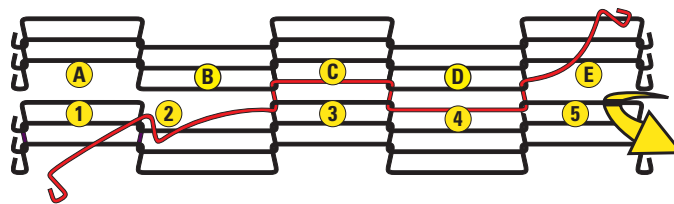


Diagram F

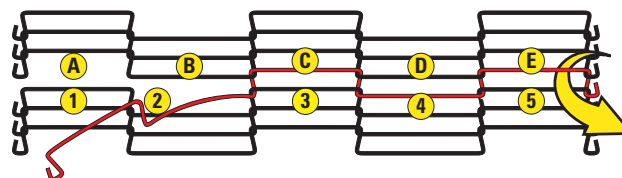


Diagram G

