

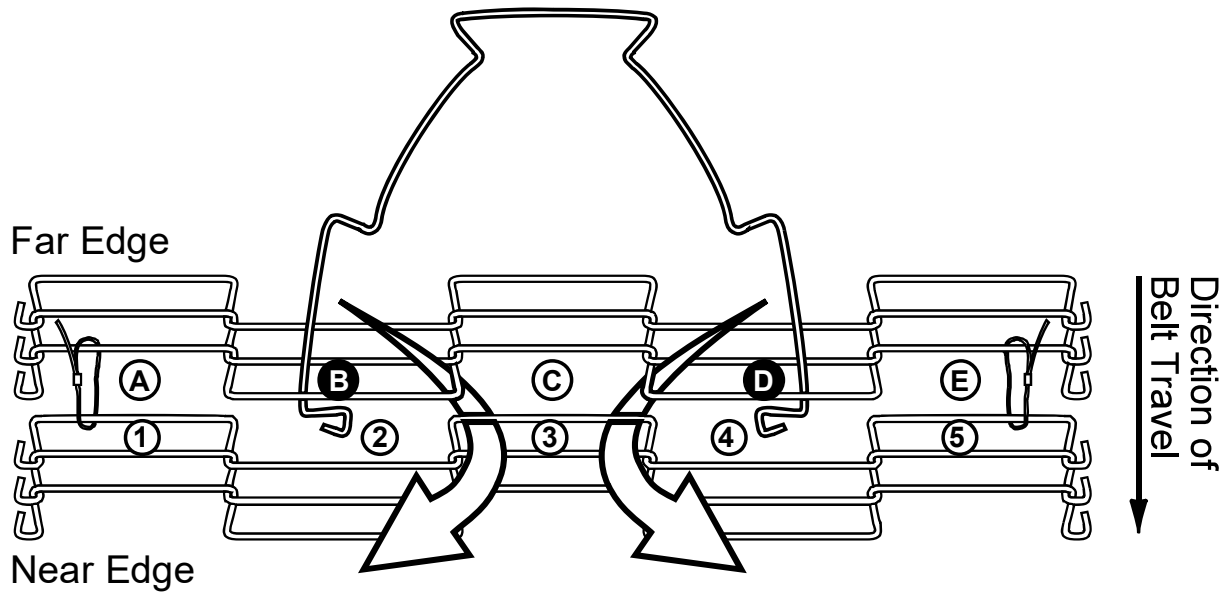
Before you begin splicing

- Release all belt tensioning mechanisms.
- If installing a new belt, thread the belt onto the conveyor.
 - Check to be sure that the smooth side is “up.”
 - Check to be sure that the edge loops curve back in the direction opposite the direction of belt travel.
 - Remove a strand or two from the new belt to keep in reserve to splice the belt or in case it may be needed to repair the belt in the future.
 - Tie both ends of the belt together with cord, twine, or wire ties.
- If repairing a belt
 - Tie two undamaged strands at the end to be spliced together with cord, twine, or wire ties.
 - Cut out the damaged wire(s) with a wire cutters — pick out and dispose of wire pieces *immediately*.

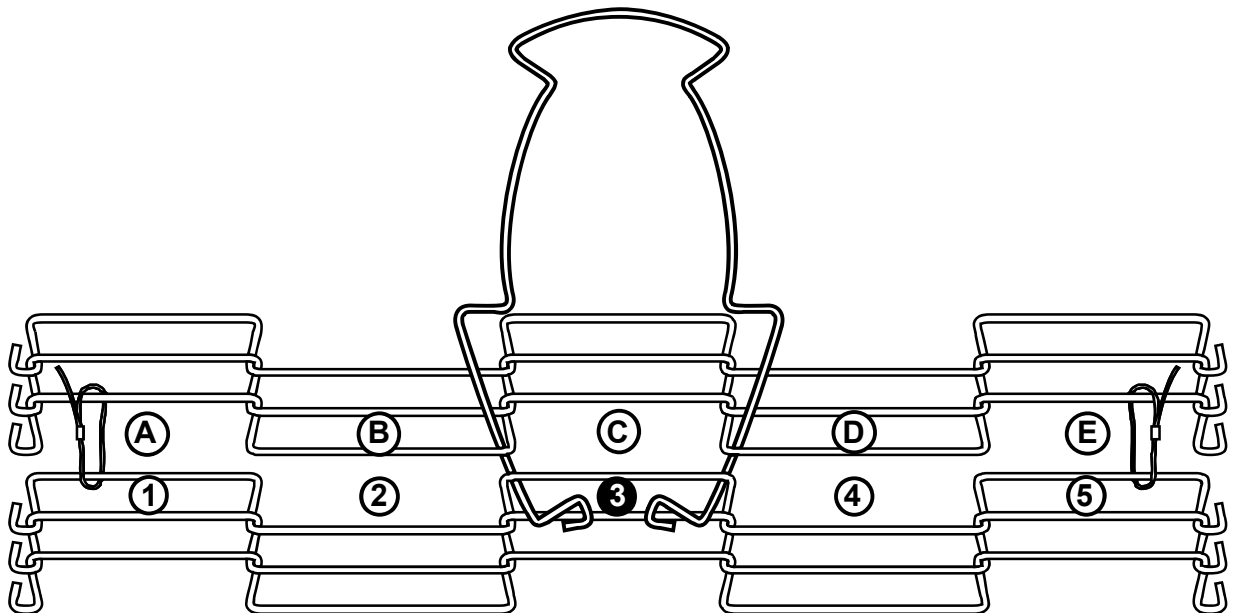
Important! If a belt has damage in more than one place or if the belt has been previously repaired, do not try to repair it. **Install a new belt.** Also, never save used belting to use for repairs because it has already been weakened by use. Purchase several extra feet of new belting to use exclusively for repairs.

Step 1 – Begin splicing in the center

1. Move the two ends of the belt to be spliced to the exit end of the conveyor.
2. Confirm that the edge loops curve back, away from the direction of belt travel as shown in the following illustration. If not, check to make sure that the belt is not positioned backwards on the conveyor.
3. Lay the strand down between the two belt ends and check to see that the edge loops are going in the same direction as the belt 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 you will need to start over.)
4. 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 the following illustration.)



5. Insert the strand ends into the center space of the opposite edge. (Space 3 in the illustration below.)

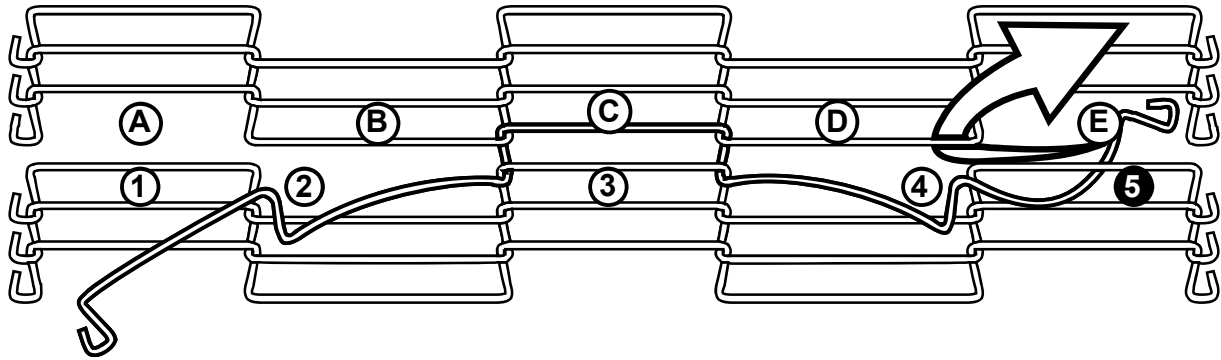


6. Pull the ends of the strand through until the center section “pops” or “locks” into place. (You should be pulling the strands toward you.)
7. Use pliers or the wire belt straightening tool to straighten the wire in the center space. (Once the center is connected, you may remove the ties holding the belt ends together.)

Step 2 – Weave the strand to one side

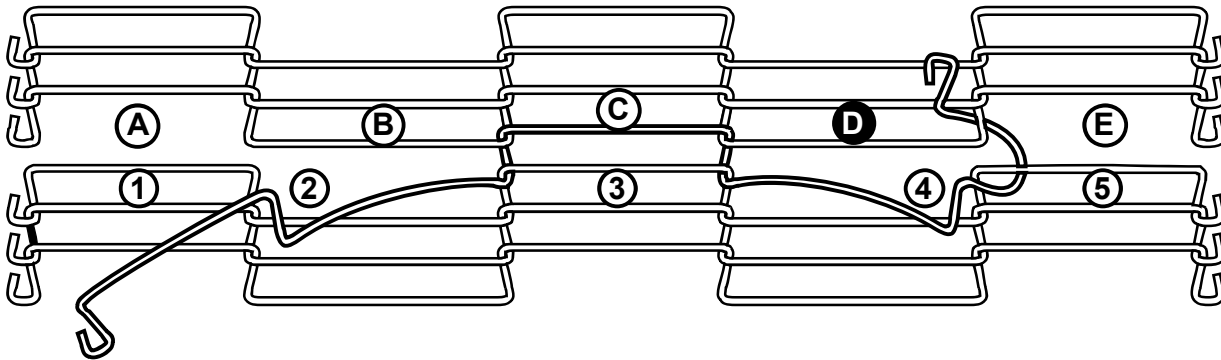
1. Bend one end of the wire up and insert it around the z-bend in the next space on the edge of the wire closest to you. (Space 5 in the following illustration.) Always try to avoid bending the wire in the z-bend.

Far Edge



Near Edge

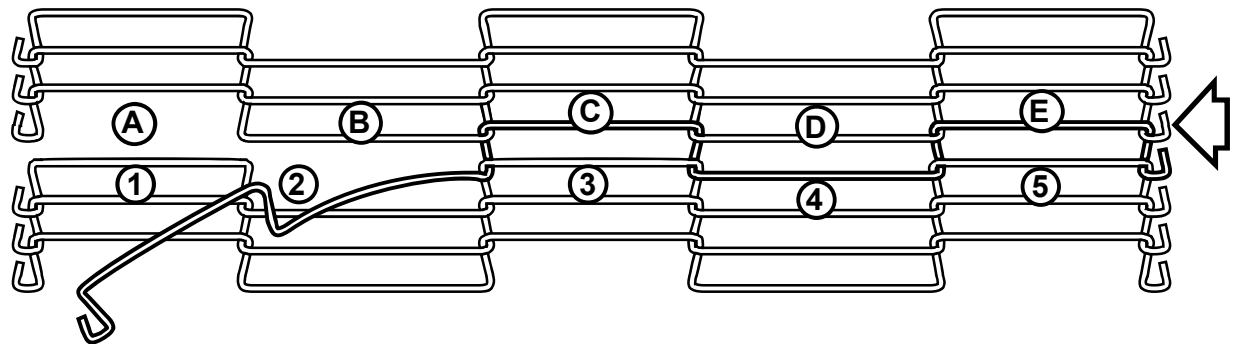
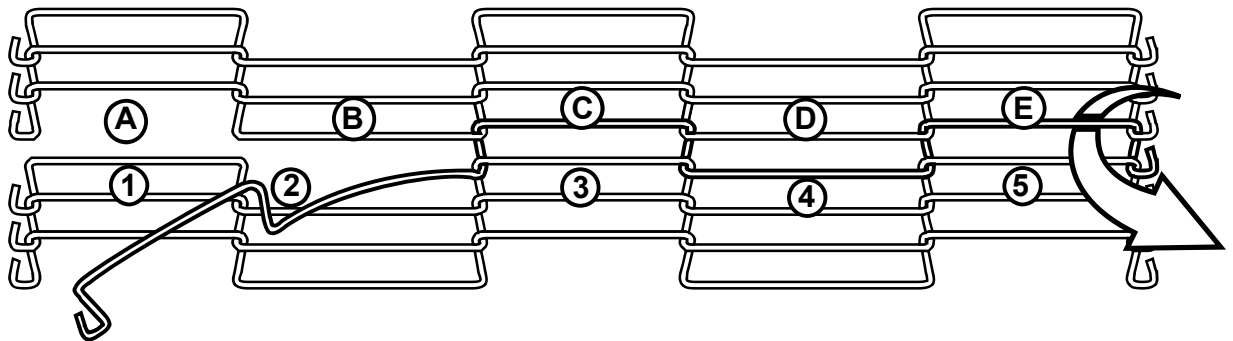
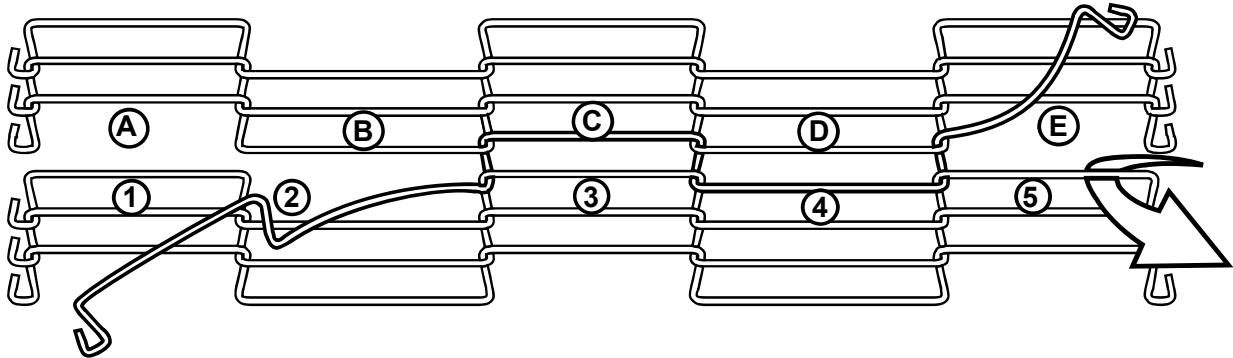
2. Bend the wire toward the center and insert it around the z-bend next to the center space. (Space D in the following illustration.)



3. Pull the strand wire through the mesh and straighten it with pliers.
4. Repeat the above three moves until you reach the side edge of the belt.
5. Using the pliers, connect the strand's edge loop to the belt's edge loop on the far edge.
6. Connect the edge loop on the near edge of the belt to the strand's edge loop.
7. Straighten the strand with the pliers.

Step 3 – Weave the strand to the other side

1. Repeat the steps in Step 2, going in the opposite direction, weaving to the other side edge of the belt as shown in the following illustrations.



2. If you are installing a new belt, you are finished splicing.

Step 4 – Check Drive Shaft Sprocket Alignment

- Check to ensure 3/16-inch 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.)