

TECHNICAL BULLETIN

ASSEMBLY INSTRUCTIONS

BALANCED WEAVE BELT

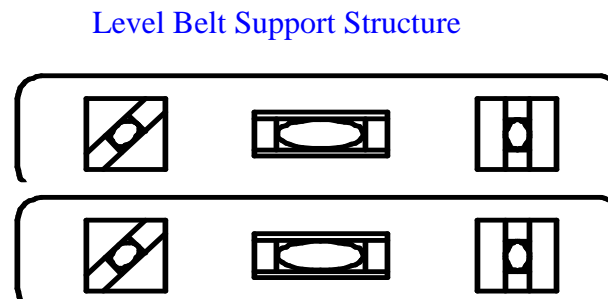
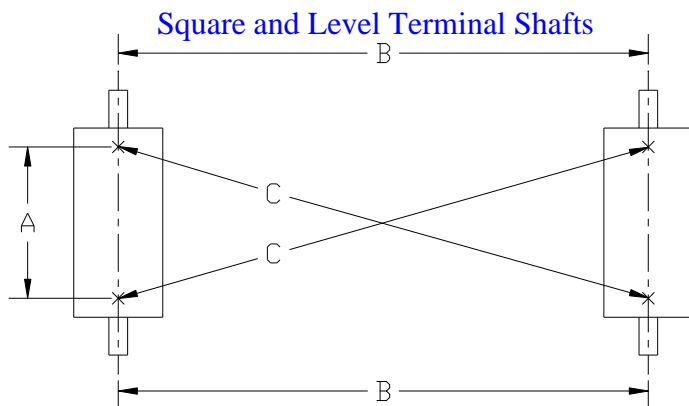
- ◆ Care should be used in uncrating to prevent damage. If damage occurs, remove affected spirals or crimped connectors from belt.
- ◆ Use only flat faced terminal pulleys. DO NOT use crowned pulleys, they will cause irreparable belt damage. Avoid flanged pulleys, they will not control side travel.
- ◆ Temperature permitting, drive pulleys should be lagged. Snub rolls, pressure or pinch rolls reduce belt tension and are in general use on wire belt installations.
- ◆ Avoid applying more tension to the belt than required to initiate movement.

IMPORTANT: Keep the belt under some tension when removing from package.
 Failure to do so may result in “flipped” or twisted spirals.

REMEMBER TO WATCH FOR UNSEATED SPIRALS (See Technical Bulletin 003).

BEFORE INSTALLING BELT

- ◆ Permanent belt damage can occur if terminals are cocked. See Ashworth bulletin “baking bands - installation, tracking, and maintenance” for conveyor alignment details.
- ◆ Insure belt support surface is free from obstructions such as warped hearth plates or protruding framework. Insure intermediate belt support rollers, if used, are free turning.
- ◆ Make certain that the take-up mechanism is functioning properly.
- ◆ Insure no spirals are turned up and are free to hinge around crimped connectors as designed.
- ◆ All belt lengths end with a left-hand spiral (counter clockwise winding) and begin with a right and spiral (clockwise winding). Insure belt ends remain in this condition.



INSTALLING BELT

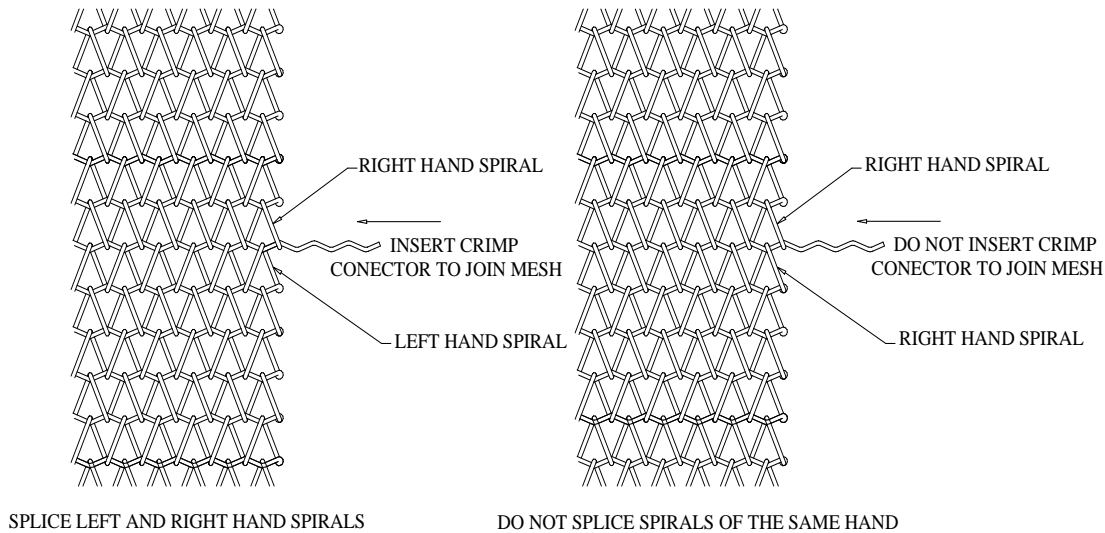
- ◆ There is no top or bottom side to belt - either can be up.
- ◆ Direction of travel - insure the spiral leads the crimped connector to which it is welded.
- ◆ If replacing an old belt, splice leading spiral of new belt to trailing spiral of old belt. See “SPLICING BELT ENDS TOGETHER”.
- ◆ If there is no old belt on conveyor, pull belt through conveyor while maintaining even tension across belt’s width.
- ◆ Before applying tension, insure all spirals are seated into the connectors and lie flat.

SPLICING BELT ENDS TOGETHER

1. Bring the two ends together with the belt edges in line.
2. Mesh the end spirals together permitting insertion of crimped connecting wires. Insure spirals being joined are of opposite weave - one right hand, the other left hand.
3. Insert crimped connector and cut the connector such that approximately 1/16 inch [1.6 mm] overhangs the end spirals.
4. Apply a simple weld to fasten connector to end spirals.

REMOVING STRETCH FROM BELTS

1. Belt length will need to be removed when the take-up mechanism is near its maximum stroke.
2. Identify a section of the belt to be removed. Insure end spirals of section to be removed are of opposite weave.
3. Remove as much belt as possible, however insure enough belt remains to easily splice ends together.
4. On one belt edge, cut at the weld junction leaving the weld on the crimped connector. On other belt edge, cut at the weld junction leaving the weld on the end spiral. Remove the connector, pulling on the connector’s end containing the weld.
5. See “SPLICING BELT ENDS TOGETHER” to reattach belt.



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