



ASHWORTH ENGINEERING

Committed to on-time delivery of defect-free products and services, fit for use, exactly as promised, every time.

TECHNICAL BULLETIN

TACK WELDING

Of Flat Wire Belts

Flat Wire belts, 60 inches [1524 mm] wide and wider, are subject to narrowing as a result of pitch elongation when operated under high tension or at high speeds. When this occurs, the flat wire pickets have a tendency to compress toward the center of the belt. For belts that have a buttonhead weld as the edge fixation, this narrowing can allow the rods to protrude from the belt edges. This can cause severe damage to the belt or the conveyor if the rods get caught in the conveyor frame.

For 1" pitch, standard weight flat wire belts, this problem can be eliminated by ordering a belt with a **safety clinched** edge construction. However, ½" pitch and heavy duty belts are not available with this edge treatment. Therefore, Ashworth Bros., Inc. uses "**tack welding**" on these or any flat wire belts, which have a buttonhead weld.

DEFINING CHARACTERISTICS

This feature consists of tack welding or brazing the flat wire picket to the connector rod in the second opening from each belt edge. For belt 60 inches through 144 inches, the belts are welded every third longitudinal pitch. For belts 144 inches or wider, the belts are welded every longitudinal pitch. This weld retards compression or belt narrowing and reduces the possibility of belt damage.

RECOMMENDATIONS

Ashworth Bros., Inc. tack welds or brazes all belts 60 inches [1524 mm] and wider unless specified by customer. Belts less than 60 inches [1524 mm] will not be tack welded or brazed unless specified by customer. For further information, contact Ashworth Bros., Inc. Product Engineering department.

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