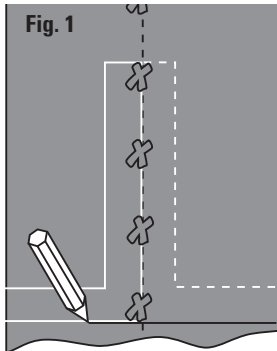
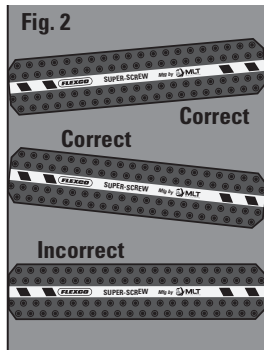


Installation Instructions

The following instructions are for Super-Screw® Primary installation. This splice will be installed on a 5° bias (or 1" bias per 12" of belt width).

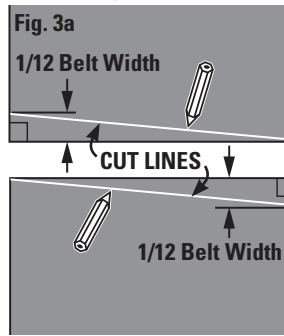


1. Square belt using centerline method and mark a perpendicular line across the belt. OR if installing on a pre-cut belt, ensure both ends are square.



2. Lay the splice face up on the belt to visualize the bias. This will help determine where to draw the bias and cut the belt. The face of the splice has circular indents in the rubber where the screws will be installed. Super-Screw Primary splices can be installed with the bias in either direction.

Joining 2 pre-cut belt ends

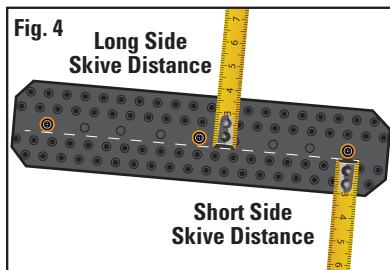
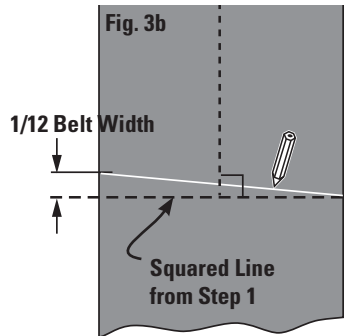


3a. To create the bias cut lines for pre-cut belt ends, measure up from the end of the belt 1/12 the width of the belt (1" for every 12" of belt width) and down the same distance on the opposite end of the belt so the ends will mate. Ensure the orientation of the lines is correct for the orientation of the splice (Fig. 3a) Draw the bias lines.

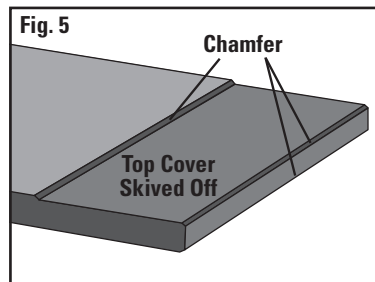
3b. If NOT installing on pre-cut belt ends, only ONE cut line is needed. Measure off one end of the squared line from Step 1. The drop distance must be equal to 1/12 of the belt width. Draw ONE bias cut line (Fig. 3b).

Cut the bias line(s) using a Flexco Belt Cutter or equivalent safe cutting method.

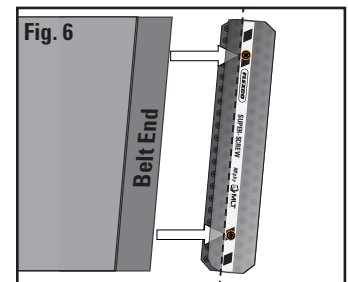
OR Installing in continuous belt



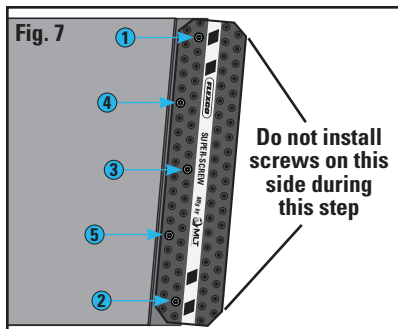
4. Using Table A on the back, or measuring from the spacers perpendicular to the edge of the strip, determine the distance to skive on each end of the belt. **Note:** The measurement will be different on each end of the belt. Skive off as much top cover rubber as possible without cutting into the plies of the belt. It is recommended to skive the bottom cover if it is greater than one eighth (1/8") of an inch.



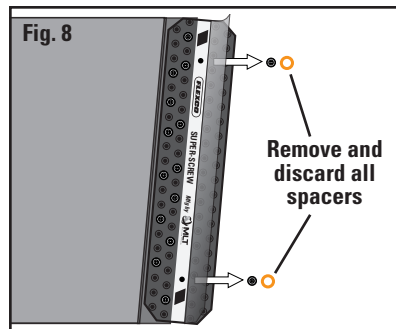
5. Chamfer the top cover on the trailing side of the belt. Then chamfer or bevel the top and bottom edges of both ends of the belt.



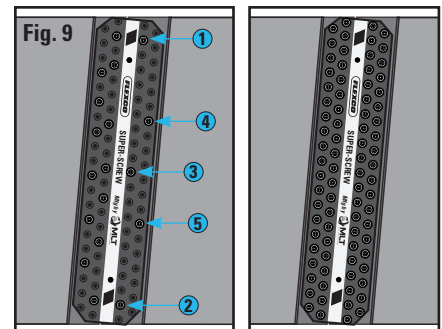
6. Centering the splice on the belt, slide the strip onto the end of the belt with the shorter skive reachback. Ensure belt is firm against all of the pre-inserted spacers.



7. Using an 18-volt (or greater) drill and the PZ bit provided, install the first several screws in the order shown in Fig. 7. After Screw 1, ensure the belt end has not moved away from the spacer before driving Screw 2. Once all 5 screws have been driven, install 10-20 screws alternating from side-to-side and row-to-row. Avoid installing the screws one after another along a single row, as this may cause the top and bottom portions of the splice to misalign. Do not install screws within the colored center stripe during this step.



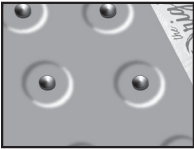
8. IMPORTANT: Remove all spacers from the splice and discard.



9. Center and insert the opposite belt end with the longer skive reachback into the splice so the two ends of the belt are in firm contact with each other. **DO NOT** leave a gap between the belt ends. Install 10-20 screws on this side of the splice using the same alternating screw pattern from step 7.

10. Then alternate from side to side, row to row, installing all remaining screws on **both sides of the splice**. Finish by installing the screws in the center colored stripe. Once all screws have been driven, check for any that have not been fully tightened or have missed the nut. Replace as necessary.

Installation Instructions



11. When complete, check the bottom of the Super-Screw splice to ensure the screws have fully engaged the nuts. The screw tips on the bottom will have a recessed ring around them in the rubber when the nuts are properly engaged.

Best Practices

Only install Super-Screw® on a completely flat surface.

Always install Super-Screw on the recommended bias.

Skiving and Screw Length – what do I need to know?

The skive distance from belt end depends on the series. Skive the appropriate distance (Table A) on each end of the belt.

A correct skive impacts screw selection and the ease of installation. Select screw length(s) based on belt thickness after the skive (Table B). We recommend you have a variety of screw lengths available for installation and for unintended skive variations. If you find your screw length is too long and is visible on the bottom of the splice by more than 1/8", you may grind it off or use a shorter length screw.



How tight do I set the screws? Tight enough so that there is belt pucker around the screw head.

How do I know if my screws are properly seated in the nuts? You can be sure every screw is seated into the nut with visual inspection of the top and bottom of the finished splice. Check that the rubber on the top of the splice puckers around each screw head and that the screw tips on the bottom have a recessed ring around them. A screw that is raised up is not properly seated. Also, if a screw continues to spin during installation it means the screw has not engaged with the nut in the bottom splice strip. As you continue to install screws, you will start to gauge how a properly seated screw feels to help with the process.

Table A

Super-Screw Series	35	63
Short Side Skive Distance from Belt Edge	1"	1-7/8"
Long Side Skive Distance from Belt Edge	1-1/2"	2-3/8"

Table B

Thickness After Skive			Screw Length	
in.	mm	mm Rounded Up	35	63
1/8	3.2	4	5 x 12	5 x 12
3/16	4.8	6	5 x 12	5 x 14
1/4	6.4	8	5 x 14	5 x 14
5/16	7.9	8	5 x 14	5 x 16
3/8	9.5	10	5 x 16	5 x 18
7/16	11.1	12	5 x 16	5 x 18
1/2	12.7	14	5 x 18	5 x 20
9/16	14.3	15	5 x 20	5 x 22
5/8	15.9	16	5 x 20	5 x 22

IMPORTANT:

Unfold for Installation Instructions

Fastener Part No. _____

Super-Screw® Primary Instruction Sheet

Visit www.flexco.com for other Flexco locations and products, or to find an authorized distributor.

