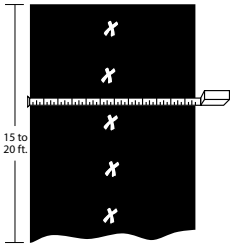
INSIGHTS™
Belt Conveyor Maintenance
TECHNICAL SOLUTIONS FOR BELT CONVEYOR PRODUCTIVITY

Benefits of a properly squared belt

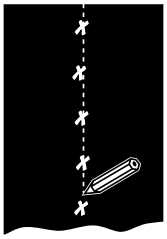
Squaring your belt ends is a job that requires only a few minutes of your time, but offers real paybacks in extending your belt splice life. A splice that is applied on a properly squared belt will have tension evenly distributed across the splice and will track properly. Improper squaring of a belt can lead to belts mistracking and splices catching on conveyor components, causing early failure.

How to square a belt using the centerline method

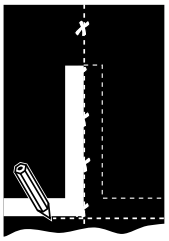
Step 1
Prior to any work on your conveyors, make certain that the power has been turned off and the belt is "locked out." Follow other safety precautions outlined in the operator's manual.



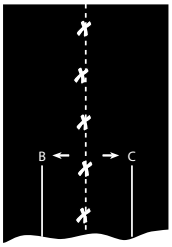
Step 2
Mark the actual center points in belt width at intervals of 3 to 5 feet, for a distance back from the intended splice area of 15 to 20 feet.



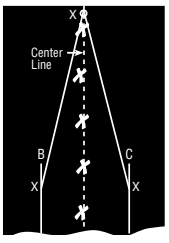
Step 3
Using either a steel rule or a chalk line, mark the average center line through the points measured from Step 2.



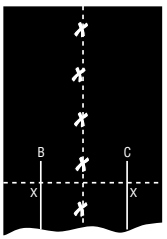
Step 4
Using a square, draw a line perpendicular to your average center line across the belt width.



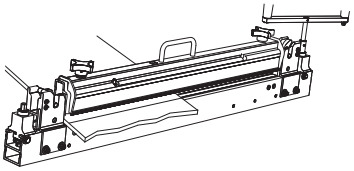
Step 5
For even greater accuracy in preparing your squaring line, after completion of Step 3, mark two lines (B&C) equal distance from the center line in the area where you are going to install the splice, running parallel to the center line.



Step 6
Measure back from the intended splice area a distance equal to approximately three times the belt width and mark this point. Then measure equal distances to lines B & C at the intended splice area and mark these points.



Step 7
Align a steel rule through these points across full width of the belt. The resulting line is the true square.



Step 8
Mark this line and cut your belt at this line using the 900 Belt Cutter.

Note: Preparing belt ends for a 45° splice

1. Find and mark center line of both belt ends.
2. Square one belt end as described above.
3. Cut squared end on 45° angle.
4. Lay 45° cut end over uncut end making sure center lines match and are straight.
5. Use 45° cut as guide for cutting other belt end.

A Safer Way to Cut a Belt

Flexco has a variety of tools that are not only safer, but cut the belt more quickly and efficiently. Available in both powered and manual versions, Flexco Belt Cutters minimize the danger of accidental injury during the belt cutting process.

Power Belt Cutters

Flexco Power Belt Cutters can handle all types of belting — from the softest of natural rubbers to the hardest constructed solid woven PVC and fabric-plied belts. A permanently-sealed gearbox provides for long lasting, maintenance-free operation. Available in both corded and cordless, they can cut up belts up to 2" (50mm) thick.

900 Series™ Belt Cutter

The 900 Series™ Belt Cutter minimizes the danger of accidental injury during the belt cutting process with a fully-enclosed blade that provides accurate cuts, while preventing on-the-job injuries. Users can safely and easily cut thick and/or hard carcass belts up to 1-1/2" (38 mm) thick due to advancements in blade technology.

840 Series Belt Cutter

The 840 Series aluminum belt cutter delivers the straightest cuts in an easy-to-use, lightweight, corrosion-resistant package. The chain-driven double-edged safety blade can be driven from either end, and cuts in both directions in a single pass. The tool produces improved clamping force for consistently straight cuts on rubber or PVC belt up to 1" (25mm) thick.

Clipper® 845LD Belt Cutter

The Clipper® 845 Belt Cutter is a sturdy, safe and portable tool that features a fully-enclosed flat-top blade design for cutting wide light-duty belts. The 845LD Belt Cutter delivers straighter, faster cuts with unsurpassed safety on belts up to ½" (13mm) thick.

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