

Installation Instructions

WEDLOK[®] Splice

For conveyor and elevator belts

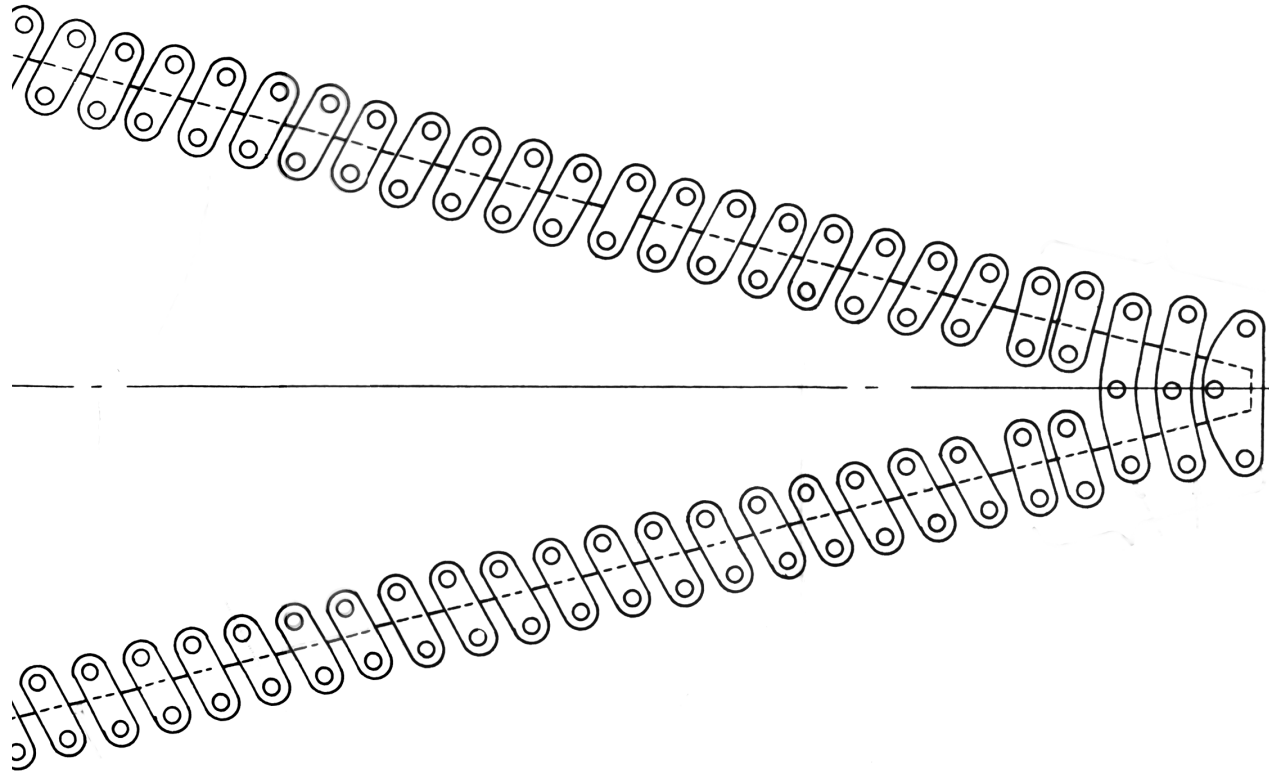


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WARNING

All items and tools required to make this splice are manufactured by Flexco.

This information and recommendation is offered to the best knowledge available from reliable laboratory and field installations and tests. It is offered as a guide for successful selection and application of the Wedlok® splice.

Actual results will depend on the quality of installer’s workmanship, condition and design of the belt, load conditions, and maintenance.

Flexco makes no guarantee of results and assumes no obligation or liability whatsoever in connection with this information.

Wedlok® Splice

Kit Contents

Wedlok® Splice Kit No. 2W

This kit contains the following specially designed material for making one splice. For extra durability, top plates are stainless steel; all other parts are steel.

- 1 set of tip fasteners
- 2 sets of chevron fasteners
- 4 sets of tail fasteners
- Required bolts (1^{13/16}" /46 mm)
- Nuts and clips
- Illustrated, step-by-step installation instructions.

Wedlok splice spare part kits

For replacement of worn tip and chevron plates on carrying side of the Wedlok splice, spare part kits are available.

- Leading End Kit—No. 2WL
 - 2 sets of tip fasteners
 - 4 sets of chevron fasteners
- Trailing End Kit—No. 2WT
 - 6 sets of tail fasteners

The Wedlok splice kit and standard No. 2 Flexco fasteners have 1^{3/16}" (30.2 mm) long bolts for belts up to 7/8" (22.3 mm) thickness.

For belts over 7/8" (22.3 mm) thick, 2-1/4" (57.2 mm) bolts may be ordered separately.

Data Table No. 1

APPLICATION & RATING		2 Lead Where belt pull per inch of width will not exceed 400 lbs. per inch or the approximate meter horsepower used per inch of belt width at 500 F.P.M. is 5 or less.				2½ Lead Where belt pull per inch of width will not exceed 500 lbs. per inch or the approximate meter horsepower used per inch of belt width at 500 F.P.M. is between 5 and 6.				3 Lead Where belt pull per inch of width will not exceed 700 lbs. per inch or the approximate meter horsepower used per inch of belt width at 500 F.P.M. is between 6 and 8.						
		Extra belt length req'd for splice		Number of No. 2 Flexco fasteners needed*	Distance "X" (see step 9, Fig. 9)		Extra belt length req'd for splice		Number of No. 2 Flexco fasteners needed*	Distance "X" (see step 9, Fig. 9)		Extra belt length req'd for splice		Number of No. 2 Flexco fasteners needed*	Distance "X" (see step 9, Fig. 9)	
in.	mm	in.	mm		in.	mm	in.	mm		in.	mm	in.	mm		in.	mm
18	450	—	—	—	—	—	—	—	—	—	—	54	1372	40	15%	396.88
24	600	48	1219	38	11¾	298.45	60	1524	48	13%	346.08	72	1829	62	15¼	387.35
30	750	60	1524	52	11¾	298.45	75	1905	64	14¼	361.95	90	2286	80	16	406.40
36	900	72	1800	66	12%	327.03	90	2286	82	14½	368.30	108	2743	102	14%	377.83
42	1050	84	2134	80	12	304.80	105	2667	100	14%	358.78	126	3200	122	15%	396.88
48	1200	96	2438	94	12%	307.98	120	3048	118	13%	346.08	144	3658	144	14%	371.48
54	1350	108	2743	108	12%	307.98	135	3429	136	13¼	336.55	162	4115	164	15%	403.23
60	1500	120	3048	122	11%	295.28	150	3810	152	14¾	374.65	180	4572	186	14½	368.30
72	1800	144	3658	150	12%	320.68	180	4572	188	13%	349.25	216	5486	226	15¼	400.05
Dist. T**		1½" (38 mm)				2¾" (70 mm)				2¾" (70 mm)						

* Figures indicate the number of No. 2 Flexco fasteners needed. Tip, Chevron, & Tail fasteners are not included and must be ordered separately. Each joint requires 1 set of tip fasteners, 2 sets of Chevron fasteners, and 4 sets of tail fasteners.

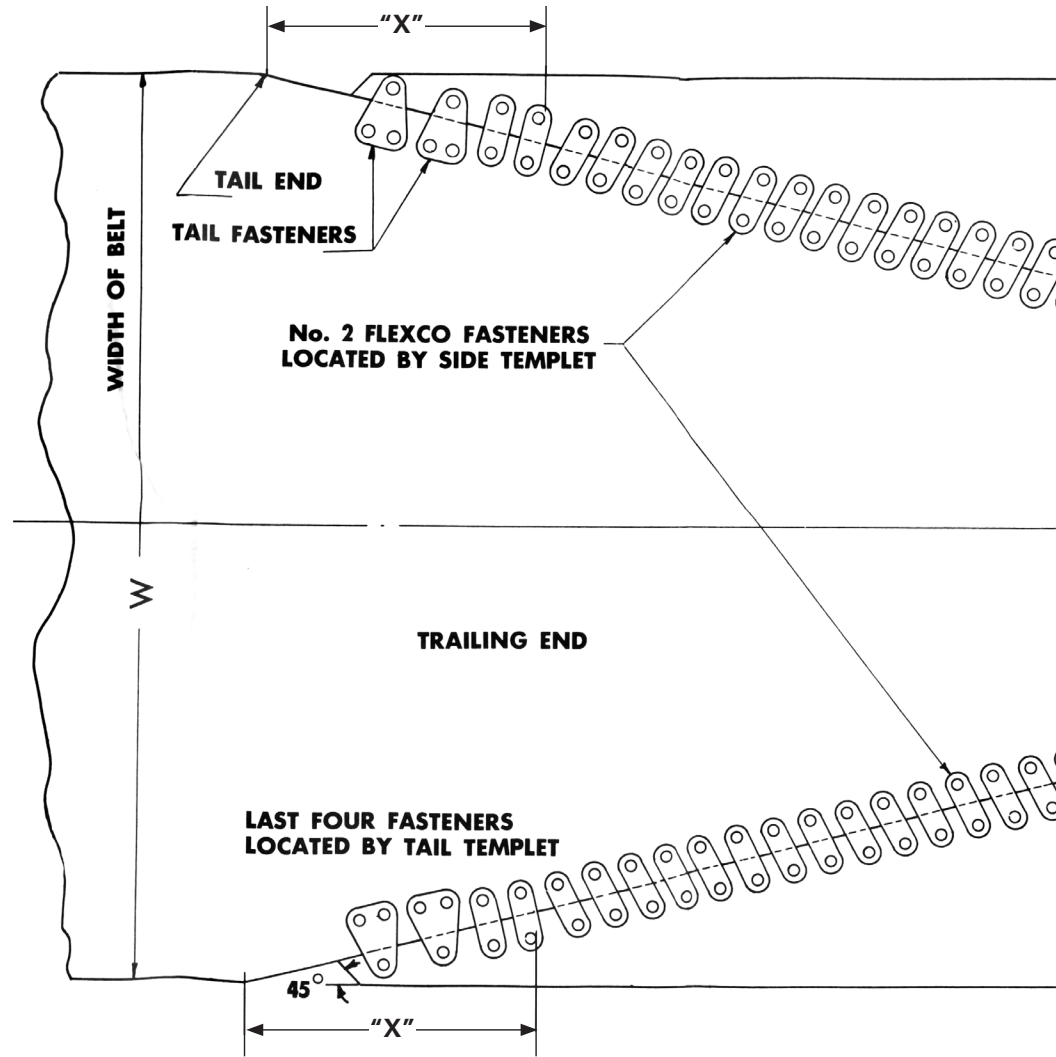
** Distance "T" is area not cut at point of V tip as shown in Fig. 4



Assembled Splice

DO NOT PUNCH ANY HOLES NEARER THAN "X" INCHES FROM TAIL END WITH SIDE TEMPLET.

SEE TABLE NO. 1 FOR DISTANCE "X".



Cutting Diagram for Trailing End

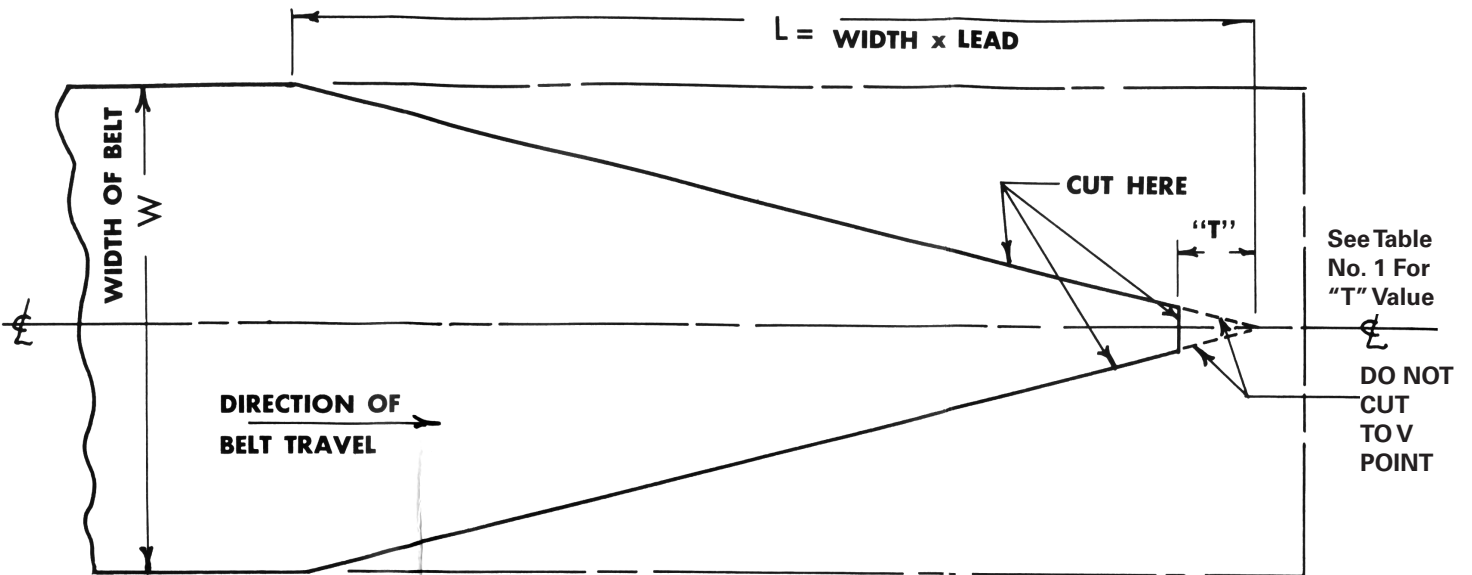


Fig. 2

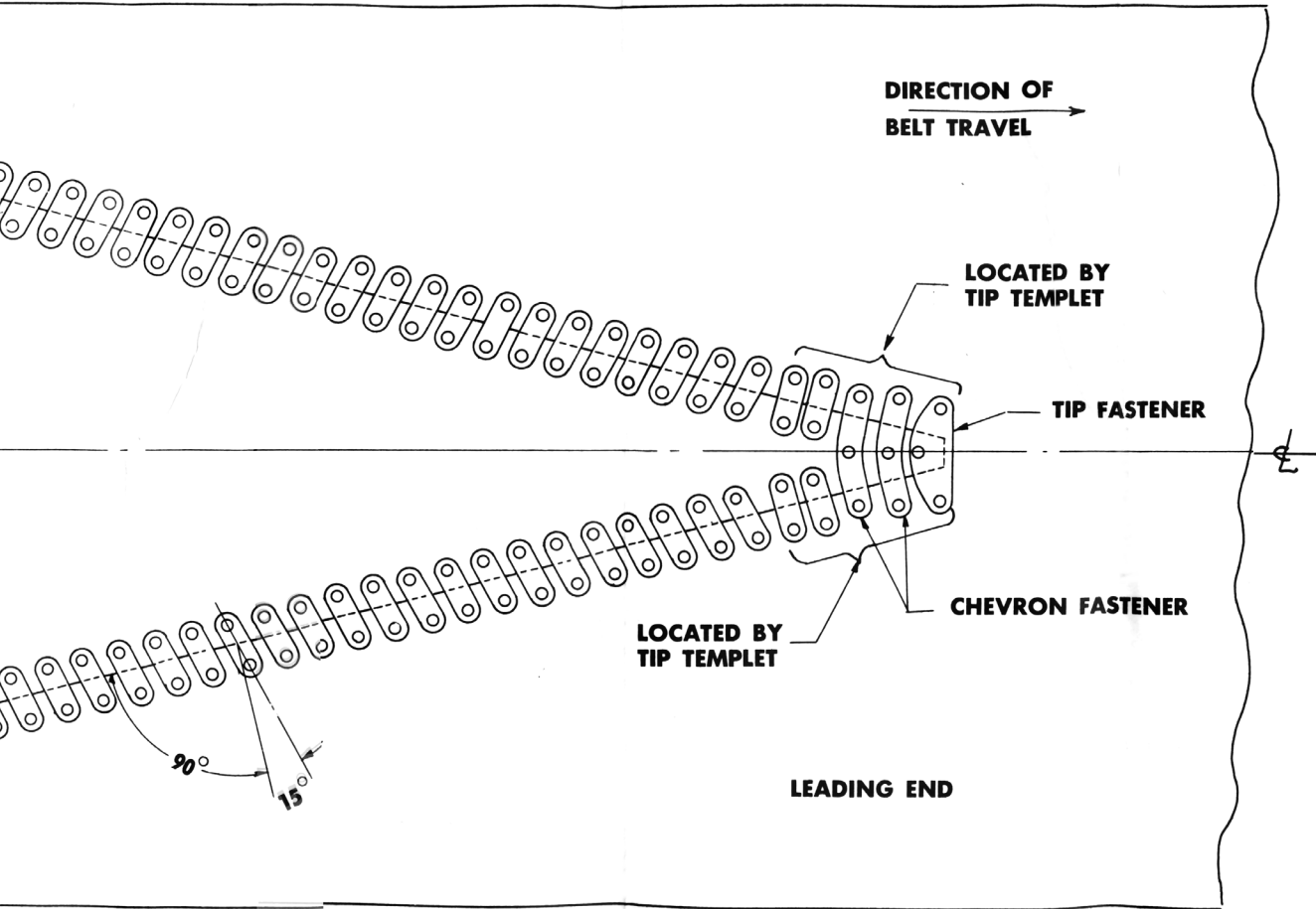


Fig. 1

Instructions

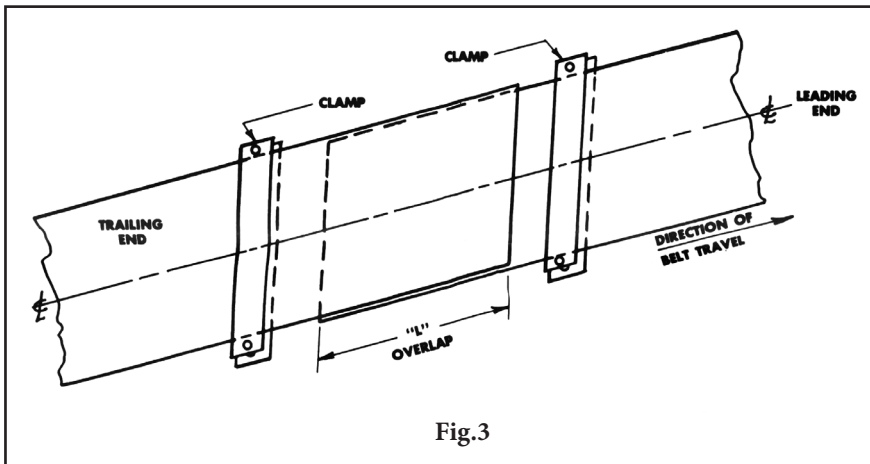


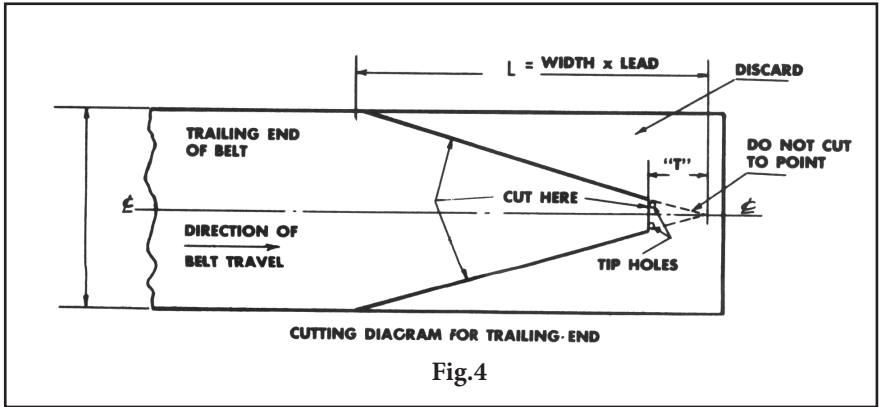
Fig.3

1. Choose lead, length "L", and number of fasteners needed for Wedlok® splice from Application Table No. 1.

2. Pull belt up to desired position around pulleys and clamp as shown in Fig. 3. Put clamps far enough apart allowing plenty of room for length "L" of V-shaped Wedlok splice. It is recommended that a wooden base plate, such as a piece of 3/4" (19 mm) plywood, be placed under the belting as a flat level bench on which to do all layout and cutting.

3. Draw centerline on both trailing and leading ends of belt between clamps.

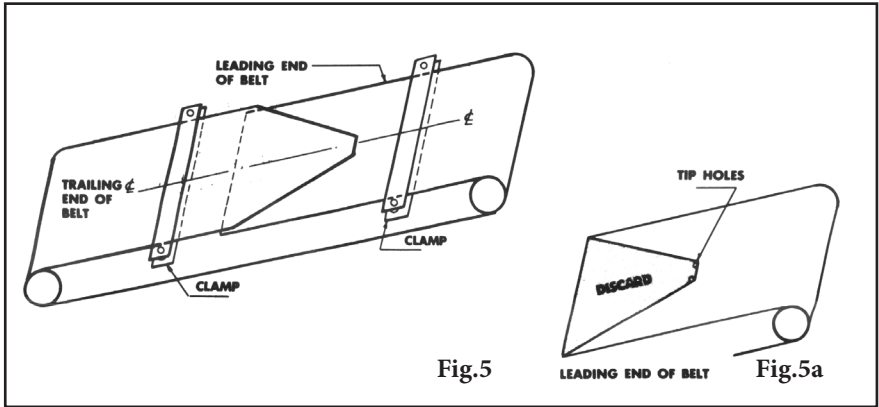
Instructions



DATA TABLE NO. 2

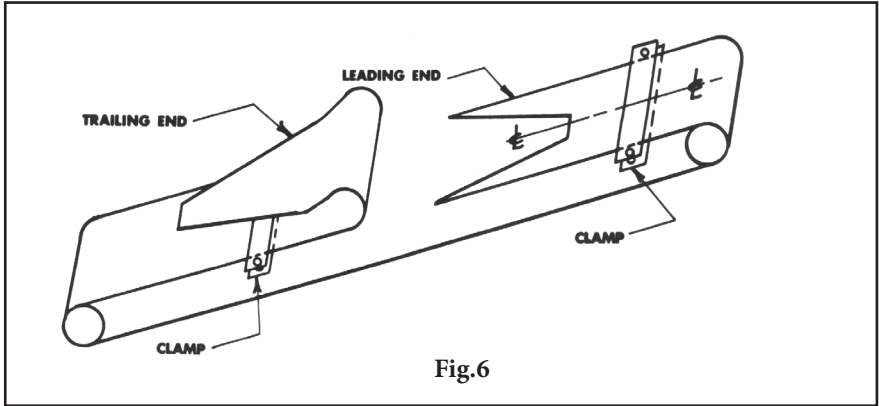
LEAD		T	
in.	mm	in.	mm
2	50	1½	38
2½	64	2¾	70
3	76	2¾	70

4. Layout and cut TRAILING END of belt into Wedlok Splice V-shape as per cutting diagrams, Fig. 4 and Fig. 2. Use a No. P2P Flexco punch for hand operation or an HP2 Flexco punch for power application and punch holes at corners of tip as shown. These holes facilitate in cutting the splice at the tip.

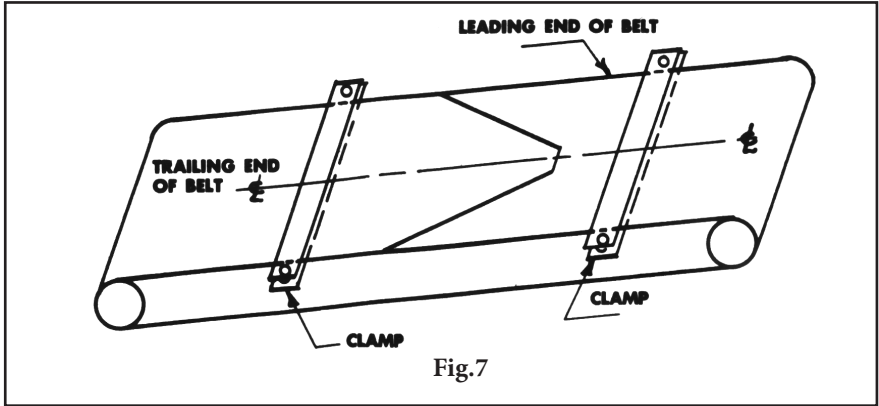


5. Lay already cut TRAILING END on top of leading end. Line up the centerlines of both ends and trace shape of TRAILING END on leading end as shown in Fig. 5. Use P2P Flexco punch and punch holes at corners of tip on leading end of belt as shown in Fig. 5a to facilitate cutting splice at tip.

6. Cut the marked shape of the leading end to exactly fit the "V" of the trailing end as shown in Fig. 6



7. Put the ends together as shown in Fig. 7 in a snug fit and hold in position by nailing to supporting wood panel.



8. Punch tip holes using tip templet as shown in Fig. 8. Position tip templet by placing templet centerline on top of belt centerline and lining Notch C of the templet with the end of the splice cut as shown in Fig. 8. Nail templet into position. Use a No. HP2 Flexco punch and punch holes in the belt. Do not remove the tip templet. The edge A-B is used for proper positioning of the side templet.

9. Punch side holes using side templet as shown in Fig. 9. Position side templet by placing lugs on the templet in the splice cut, the pointed end of the templet facing towards the tip end of the splice, and the arrows on the templet pointing in the direction of the edge of the belt. Butt the pointed end of the templet against the previously positioned tip templet. Nail in position and punch holes in the belt with a No. HP2 Flexco punch. Move side templet to finish remaining side holes being careful not to punch any pair of holes nearer than "X" inches from tail end. Use a Flexco bolt as a guide pin to locate new position of side templet. See Table No. 1 for values of "X" for lead and width of belt.

Instructions

Do not remove side templet after last pair of side holes have been punched closest to the "X" dimension. See Table No. 1.

The square end of the side templet G is used for the proper positioning of the tail templet, Fig. 10.

10. Punch tail holes using tail templet. Position tail templet by lining edge "H" (Fig. 10) of tail templet with edge of belt cover and the centerline of edge "G" of tail templet in line with the splice joint cut so that point "G" butts against the square edge of the side templet as shown in Fig. 10. Nail templet in place and punch holes through belt.

11. Repeat steps 9 and 10 complete the other side of the V splice.

12. At tip of V, fill crack with rubber cement.

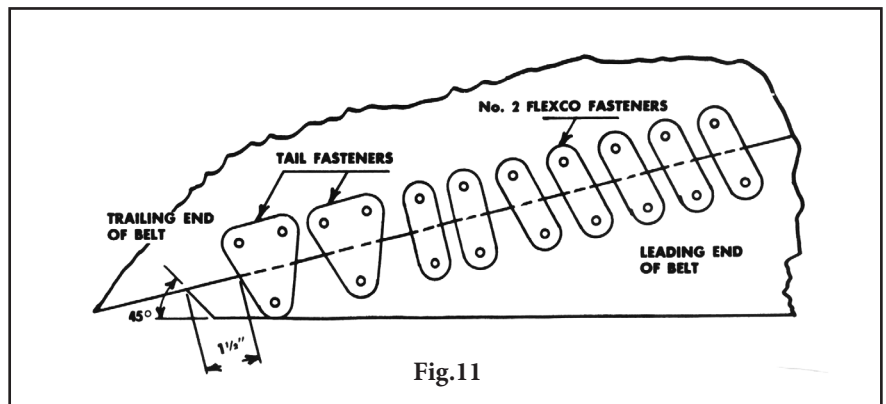
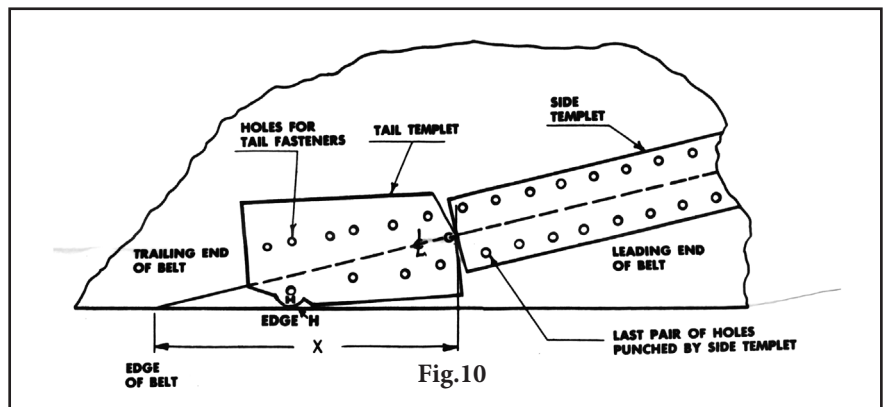
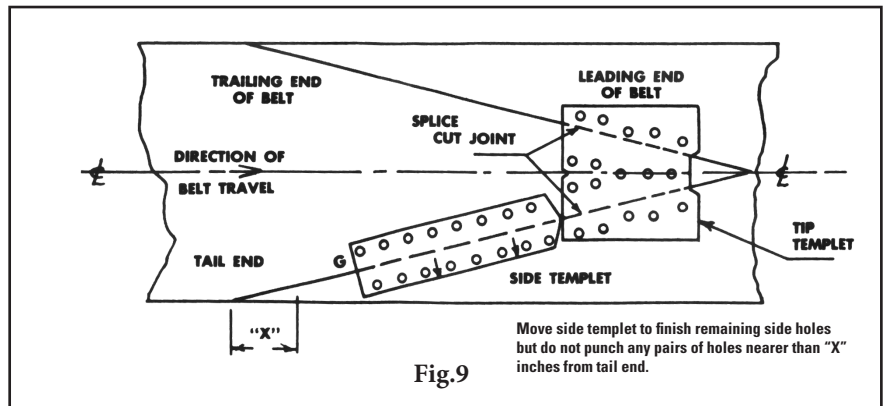
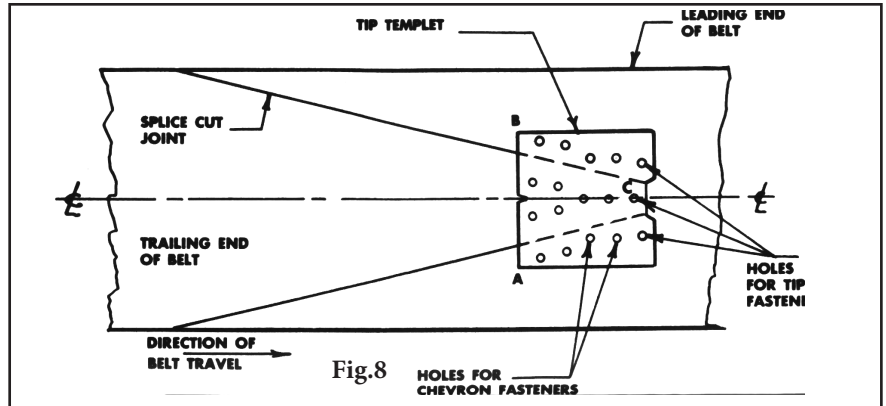
13. While installing all fasteners, including tail, tip, and chevron fasteners, extra care should be taken to have cut edges meet in a smooth level joint (no offset). Tighten by using a No. S2S Flexco wrench for hand operation or the HW2 Flexco wrench with air or electric impact tools. It is recommended that fastener bolts be tightened down to a max torque of 250 Lb-Ft (340 N-m). After all nuts have been tightened, break off the protruding ends of the bolts with two No. 112 Flexco bolt breakers. Peen or grind down any burrs.

14. Cut sharp trailing tip on leading end of belt 1-1/2" (38 mm) from last tail fastener and at a 45° angle as shown in Fig. 11.

15. After all bolts are tight, it may be desirable to rubber cement any exposed edges at leading and trailing ends.

16. Belt is ready to run as soon as clamps are removed and way is clear.

17. All Wedlok splices covered by these instructions can be made with a single set of Wedlok templets consisting of one each of tip, side, and tail templets. Only one size of Flexco fastener is required for all tension ratings and belt thicknesses 5/16" (8 mm) and over. No. 2 Flexco fasteners are available in boxes containing 25 sets. Top plates of stainless steel and bottom plates, bolts, and nuts of steel are recommended.



Wedlok® Splice



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