The first step to achieve optimal performance of a Clipper® splice is to select the correct fastener based on the belt thickness, minimum pulley diameter, and application conditions. The next step is to ensure that the fastener is properly installed; one of the most important factors is to embed the wire diameter one-half to one-third into the belt. To measure/inspect the splice for proper embedment, follow these simple directions:

Step 1: Measure the belt thickness.

Step 2: Install the fasteners into the belt.

Step 3: Using a micrometer or caliper, measure the finished splice. Be sure to capture both the short leg knuckle and the adjacent long leg in one reading. See picture.
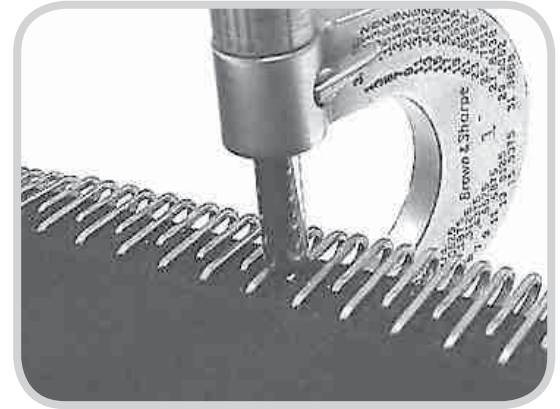
Step 4: Your finished splice should be within the range of the initial belt thickness plus one-half to one-third of the wire diameter.

Example:

Belt thickness = .100"
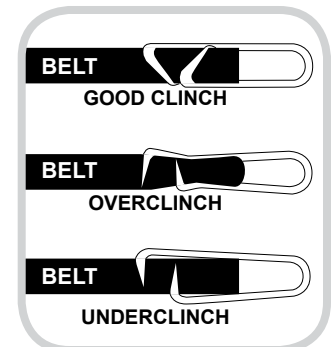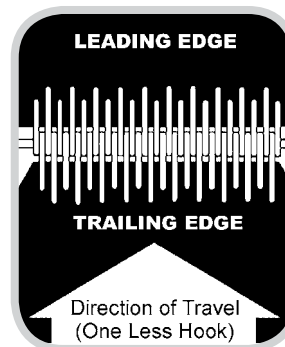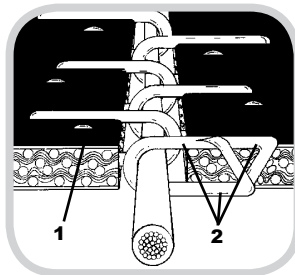Hook size = 1 (.040" wire diameter)
Finished splice thickness should measure
.140"- .153" (.100"+ .040" to .053").

Hook Size	Wire Diameter	1/2 Wire Diameter Embedded	1/3 Wire Diameter Embedded
25	.025	.025	.033
30	.030	.030	.040
36, UCM36	.027	.027	.036
1, UX1	.040	.040	.053
UA2, UA3	.047″	.047	.062
2-7, U2-U7	.054	.054	.071
4-1/2 RHTX	.062	.062	.082

Other Critical Elements of a Good Splice:

1. Hook points should slightly penetrate the opposite side.
2. Hook legs should be parallel when installed. The knuckles of the hooks should not be higher than the legs.
3. Do not lace entire width. Leave ¼"– ½" on each edge unlaced.
4. Use one more hook on leading edge than on trailing edge.
5. Chamfer/notch trailing edge.
6. Belt edges should line up when laced ends are connected.

LEADING EDGE

TRAILING EDGE

Direction of Travel
(One Less Hook)

BELT — GOOD CLINCH

BELT — OVERCLINCH

BELT — UNDERCLINCH

FLEXCO