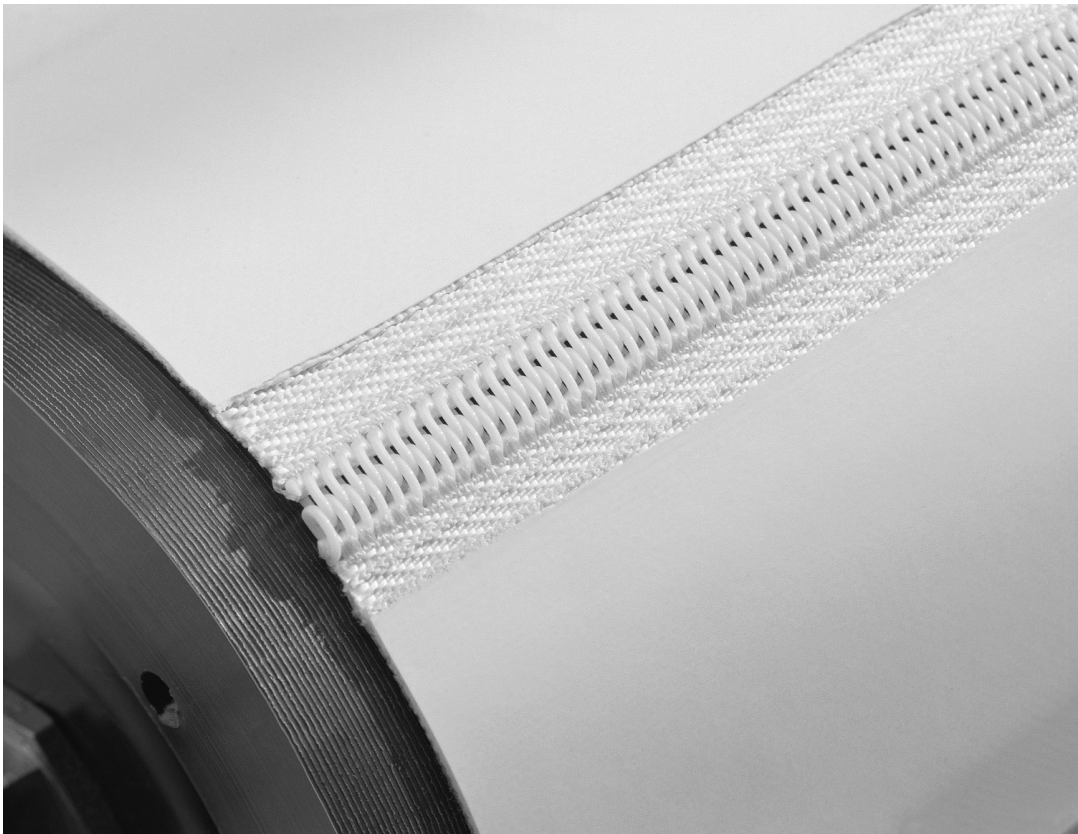




Alligator[®] Spiral Lacing

Installation Instructions



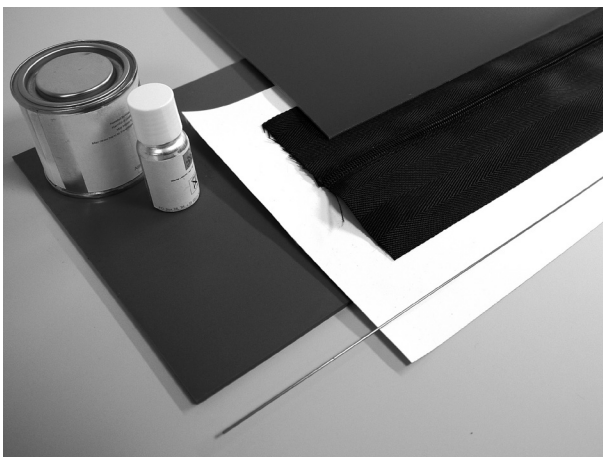
Alligator® Spiral Lacing

Required Tools



- Novitool® Ply 130™
- Novitool Aero™ Splicing Press
- Soldering Iron
- Carpenter's Square
- Pliers
- Side-cutting pliers
- Sanding Block / Sandpaper
- Small disposable cup
- Disposable application brush

Required Supplies



- Conveyor Belting, two (or more) fabric plies
- Alligator Spiral Lacing (ASL) – Single web construction
- 3 mm silicone pad
- 0.5 mm silicone cloth
- Metal pin
- Adhesive Primer

Alligator® Spiral Lacing



1. Cut belt ends square, yielding a belt length approximately 0.6" (15 mm) shorter than required finished length. Cut ASL to a length that is approximately 1.0" (25 mm) wider than belt width.



2. Using a Sanding Block / Sandpaper, lightly buff top and bottom surfaces of the fabric, raising a nap to improve mechanical bonding.



3. Mix / prepare adhesive primer per manufacturer's recommendations.

4. Using application brush, apply a thin coating of the prepared adhesive-primer to top and bottom ASL fabric. Apply adhesive primer up to stitch lines nearest spiral loop, keeping spiral loop area free from adhesive primer.

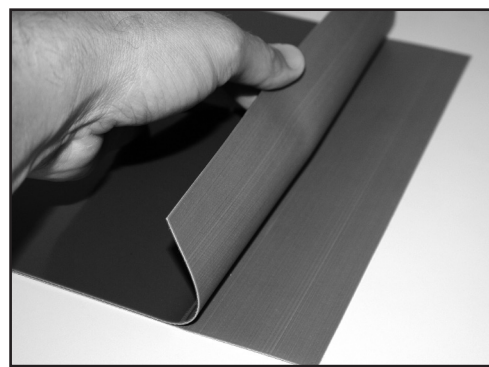
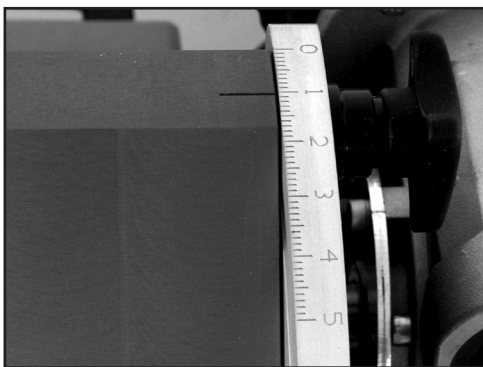
Alligator® Spiral Lacing

5. Follow adhesive-primer manufacturer's instructions regarding drying times and secondary coatings. Some drying of adhesive-primer is commonly recommended before being integrated with conveyor belt materials. It may be acceptable to accelerate the drying time using a hot air blower. Some manufacturers suggest multiple coatings of adhesive-primer.



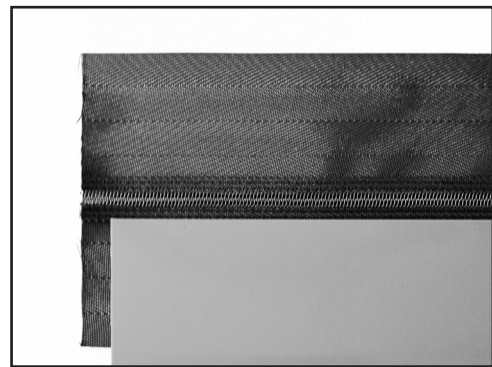
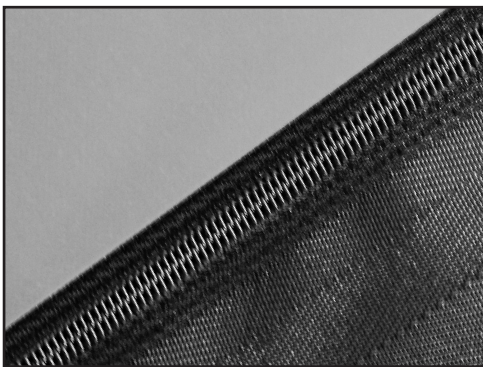
6. Using the Novitool Ply 130™ to prepare the belt ends, set the belt guide to the appropriate position as indicated in the below chart.

ASL Type	ASL50, ASLB50	ASL60, ASLB60	ASL90	ASLB90
Guide Position	1.75" (45 mm)	2.50" (63 mm)	2.25" (57 mm)	2.38" (60 mm)



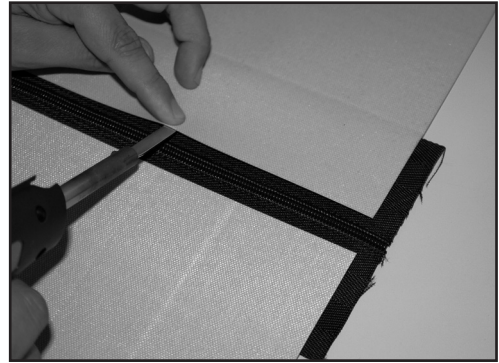
7. Using the Ply 130™, prepare belt ends. Position the Ply 130 adjustment to separate between two fabric plies of the belt. Residual of plastic inner-layer must remain on each plastic ply. Separation should be near center-plane of all fabric plies.

8. Separate belt ends.

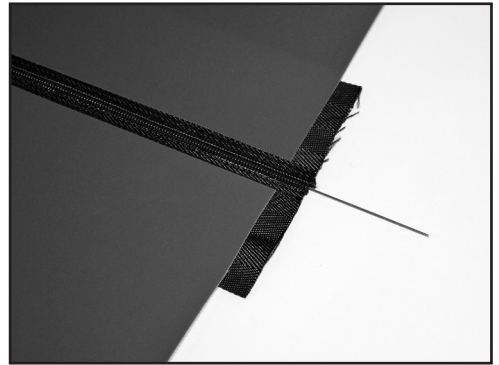
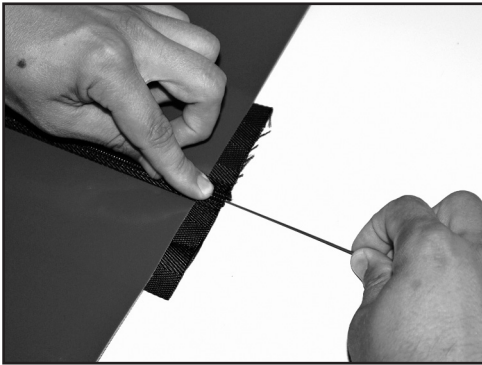


9. Insert the fabric side of the adhesive-primer coated ASL, between the separated fabric plies. ASL fabric overlap should be upwards, towards the conveying side. The ASL should extend somewhat past each side of the belt. Insertion should be to a depth where the belt ends extend to the ASL stitch line, furthest from the spiral loop.

Alligator® Spiral Lacing

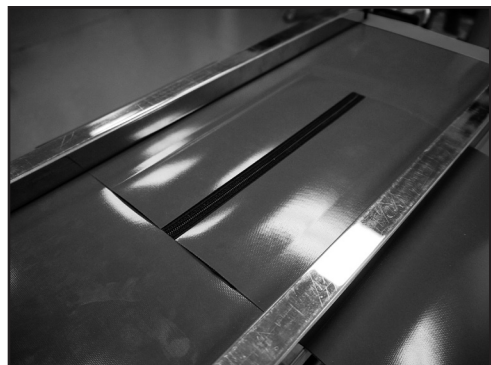
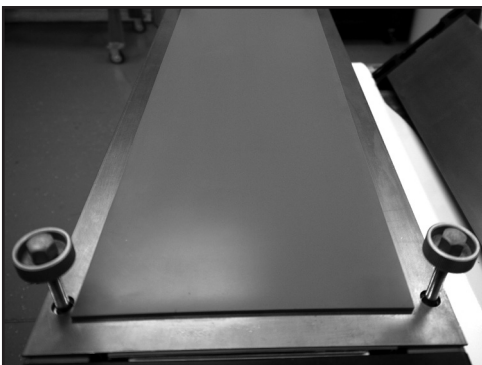


10. Using a soldering iron, fix ASL into belt at this position, fusing belt inner-layer to adhesive-primer on ASL. Belt end should follow stitch line across belt width, assuring a square splice. Sufficient fusing is required so that ASL does not disengage from belt during subsequent processing.



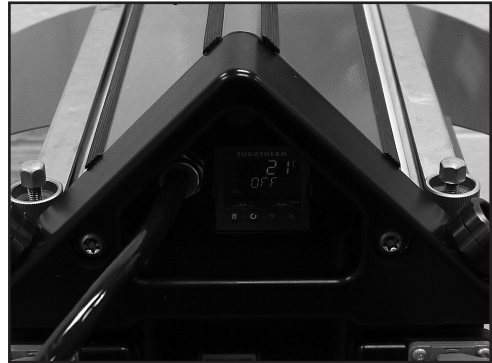
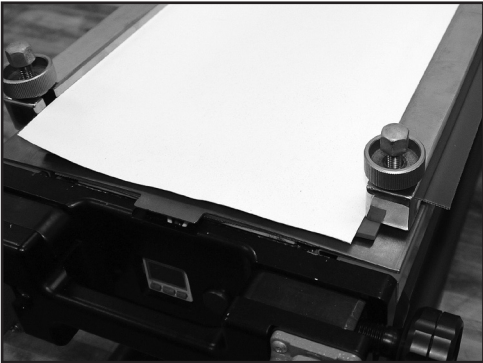
11. Insert a metal pin as a hinge pin, connecting the ASL spiral. Metal pin diameter should correspond with ASL type as indicated in the below chart. Pin should be minimally 4" (100 mm) longer than belt width.

ASL Type	ASL50, ASLB50, ASLBLUE50	ASL60, ASLB60, ASLBLUE60	ASL90, ASLB90, ASLBLUE90
Metal Pin Diameter	.040" (1.0 mm)	0.043" (1.1 mm)	0.054" (1.4 mm)

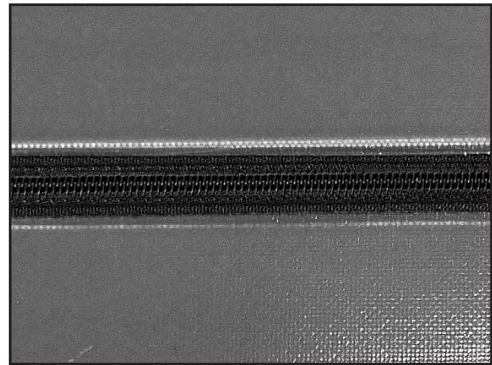
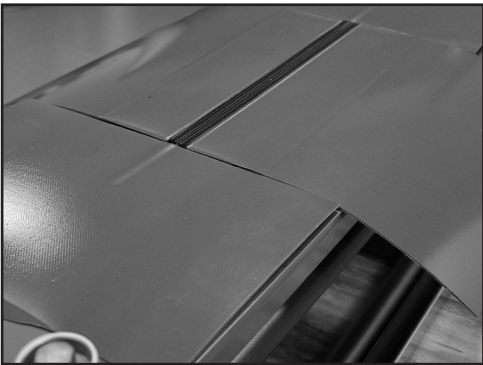


12. Place 3 mm silicone pad onto lower platen of Aero™ press. Trim ASL ends to be flush with belt edges. Place prepared ASL splice, conveying side upwards, onto 3 mm silicone pad. Fix belt in this position using Aero Belt Clamps. Fill balance of press width with belting.

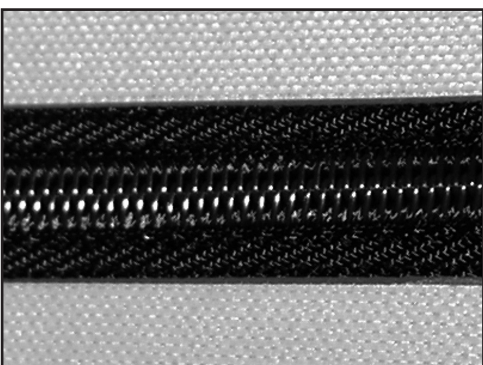
Alligator® Spiral Lacing



13. Place 0.5 mm silicone cloth (or silicone matrix pad) on top of prepared splice. Install Aero™ Press upper beam, attaching it to lower beam using connecting bolts.



14. Fuse ASL into belt using Aero™ Press. Splice parameters will be similar as with finger splicing. Belt inner-layer should melt, flowing slightly past belt ends, but not reaching spiral loops.

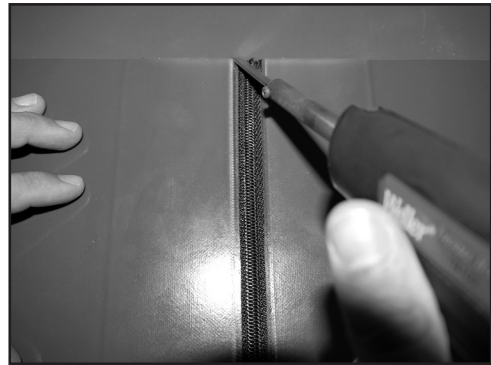


15. On the bottom side, belt inner-layer should melt, flowing slightly past belt ends, but not reaching spiral loops.

Alligator® Spiral Lacing



16. Remove belt from Aero™ press. Use pliers to remove metal pin from ASL. Using carpenters square and knife, remove excess belt material, yielding straight belt edges.



17. Use side-cutting pliers to remove a single spiral loop from outside edges of ASL. This will help prevent spiral loop from catching conveyor frame. Using soldering iron, cauterize ASL fabric at each belt edge to prevent fraying. Install plastic hinge pin.

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

©2012 Flexible Steel Lacing Company. Flexco® are registered trademarks. 01-02-24. X5502

