

BUTT WELDING INSTRUCTIONS

A proper butt weld will yield 100% of the non-reinforced belt's ultimate tensile strength. Note: A clean environment is necessary for a good weld. Make sure the area is well ventilated and free of dirt, dust and draft.

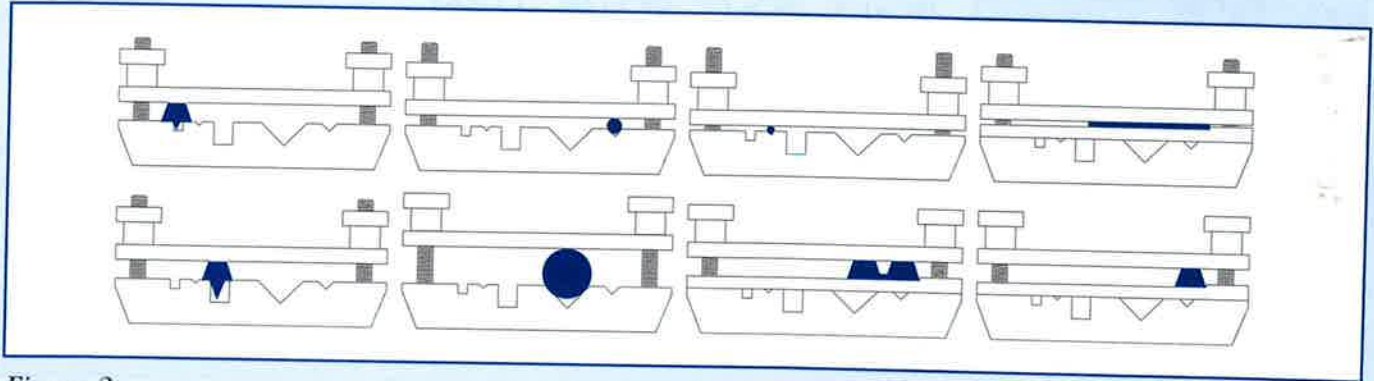


Figure 2

Cross Section		Use V-Groove
3/32" – 1/8"	2mm – 3mm	Small
3/16" – 5/16"	4mm – 8mm	Medium
3/8" – 3/4"	10mm – 15mm	Large

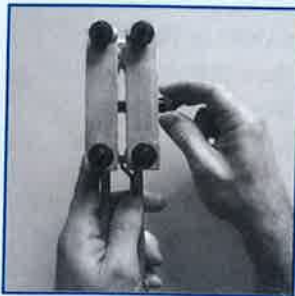


Figure 1

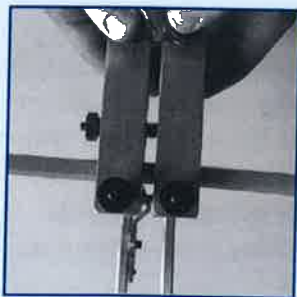


Figure 3

1. Examine the coated hot knife blade for scratches. A damaged hot knife can negatively affect weld results.
 2. Plug the hot knife into 110/120v outlet and preheat for approximately ten minutes. Once hot, use a clean, dry cloth and gently remove any residue on the blade from previous welding. Warning: Do not use a hard object to scrape polyurethane from hot knife blade.
 3. Using the cutting shears provided, cut each end of the belt perfectly square. Under certain circumstances it may be necessary to butt weld a reinforced belt. In these situations the reinforcement at each cut end must be drilled back 5mm - 7mm prior to welding. The butt welding clamp can be used to hold the belt while drilling back the reinforcement. See Table 1 to determine the appropriate drill bit. If unclear about the circumstances that would require butt welding a reinforced belt, please contact Fenner Drives Applications Engineering. Note: Contact Fenner Drives for instructions on determining correct belt length.
 4. Refer to Figure 1. Using the Hand Clamp, slide the spacer toward the mounting clamps, squeeze the handles closed, and finger tighten the thumb nut located to the right of the right side mounting clamp.
- Continued on other side...*

Cross Section	Use Drill Bit
1/4"-5/16", 6mm-8mm, Z/10-A/13	5/64", 2mm
3/8"-1/2", 10mm-12mm, B/17	9/64", 3.5mm
9/16"-3/4", 15mm-18mm, C/22	13/64", 5mm

Table 1



Figure 4

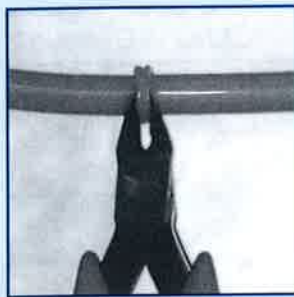


Figure 5

Cross Section	Estimated Heating Time
3/32"–1/4", 2mm – 6mm, .055" Thick Flats	<10 sec
5/16", 7mm – 9mm, all 3L, .06"x.75", .06"x1.5", .08"x.75", .09"x1.00", .13"x.63"	10-20 sec
3/8", 10mm, all A (except Hi-Ridge Top), .06"x1.75", .06"x2.00", .09"x1.25", .09"x1.50", .13"x1.00", .25"x.63"	21-30 sec
1/2" – 9/16", 12mm – 15mm, all Twin, A Hi-Ridge Top, all B, .06"x3.00", .09"x2.00"	31-50 sec
5/8" – 3/4", C, D	>50 sec

Table 2

5. Figure 2 illustrates possible belt clamp mounting positions. Starting on one side, loosen the clamp nuts and place belt in desired clamping position. Slide belt in clamp so that the end is halfway between the two mounting clamps. Tighten clamp nuts. Note: For round and ridge top profiles, remove bottom plate.
6. On the opposite clamp, loosen nuts and place belt in the same clamping position. **Warning:** Make sure there are no twists in the belt. Slide belt in clamp until the two belt ends butt together. Make sure that ends are properly aligned on all sides; see Fig. 3. Tighten clamp nuts. Note: Try to keep both clamping plates parallel to the grooved base blocks.
7. Loosen thumb nut on right approx. 1½ turns and allow the handles to open. With your left thumb, hold the spacer forward and with your right hand, insert the hot knife blade between belt ends and squeeze handles together. Refer to Figure 4.
8. As the belt ends begin to melt, the handles will contact the spacer. Hold handles tight against the spacer. After the appropriate time (refer to Table 2), quickly release the handles, slide the spacer toward yourself, withdraw the hot knife blade, and squeeze the handles together.
9. Tighten the thumb nut on the right and allow the welded joint to cure. Small cross section belts should be left in the clamp for a minimum of one minute to allow for initial cooling. Belt cross sections over ¼" (6mm) wide should be left in the clamp a minimum of three minutes. **Warning:** Allow the belt to cure for a minimum of ½ hour prior to installing, tensioning, or straining the belt weld. Note: While the belt is cooling, use a clean, dry cloth to remove any residue from the hot knife blade.
10. Loosen clamp nuts and remove belt from clamp. Using the flash cutters, remove the bead from the splice; see Fig. 5.

*If you have any questions, just call us at 1-800-243-3374.
One of our Customer Service Specialists will be happy to assist you.*

Fenner Drives accepts no responsibility for damage or injury caused by the misuse of this equipment.



311 West Stiegel Street
Manheim, PA 17545-1010

TEL: 800.243.3374

TEL: 717.665.2421

FAX: 717.665.2679

www.fennerdrives.com