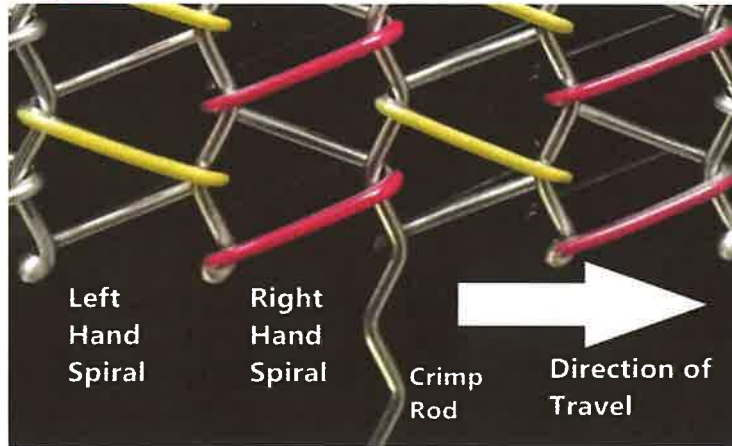


SPLICING INSTRUCTIONS



- 1) Remove old belt and release all tension on take-up.
- 2) Feed new belt into machine in proper direction of travel. (See photo)
- 3) Check that belt is seated on sprocket teeth with even gaps between belt edges and sidewall. (Belt centered on conveyor)
- 4) Pull belt ends together as tight as possible by hand to determine where to cut off excess belt for splicing. Must connect **LEFT** and **RIGHT** hand spirals. (See steps 7 and 8)
- 5) Ways to pull belt ends together: Multiple people pull by hand, Zip ties, Chain pullers.
- 6) Look at the spirals from the edge of the belt as shown above.
- 7) The red spirals (See photo) are going up to the right, so they are **right hand** spirals.
- 8) The yellow spirals (See photo) are going up to the left, so they are **left hand** spirals.
- 9) **Always** connect a **right hand spiral** to a **left hand spiral** with a crimped wire.
- 10) The edges of the two spirals to be connected must line up evenly with the rest of the belt edge.
- 11) Insert crimp wire from edge so it locks together the Left and Right hand spirals.
- 12) Once the crimp wire is inserted in the belt, cut it close to the end of the spiral. (Photo A)
- 13) Or, use the longer enclosed crimp, and bend it back on both edges. (Photo B)

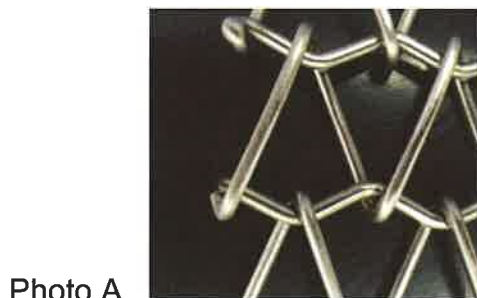


Photo A



Photo B