

INSTALLATION

FOR LEADING EDGE® PERFORMANCE GRID BELTING

Tools Required: Welding torch, bolt cutters, hacksaw, hand grinder, portable welder or soldering rig, pliers, round file, safety shield, C-Clamp, Vise-Grips, screw driver

CAUTION: Improper installation procedures can cause premature failures, damage to belt or conveyor, reduced performance, or unnecessary downtime.

SAFETY WARNING: Never attempt installation or maintenance on a moving conveyor belt. Conveyor must be "off" with the power source locked out. Always wear proper safety equipment when performing installation or maintenance. Keep clear of moving conveyor belts at all times.

1. Leading Edge Performance Grid Belting is normally shipped in 50-foot rolls. In order to make the belt endless, connect one or more sections of belting together. To obtain optimum performance, it is recommended that the following procedure be used:

- a. The belt should be placed on the conveyor with proper orientation to the direction of travel (Figure 1).
- b. Insert the button headed rod through the links (and mesh, when present, ensuring that the pig tail and mesh wires of the adjacent spirals alternate). Ensure that the button headed edge is on the inside of the belt.
- c. Blast weld the end of the rod into the link making a dome shaped weld.
- d. Using filler material recommended for type 304 (306, 308) or silver solder, weld in the same fashion as the other links to achieve the same size and shape as the factory welds.
- e. Deburr welds to match adjacent welds, leaving no sharp edges to cut plastic drive bars.

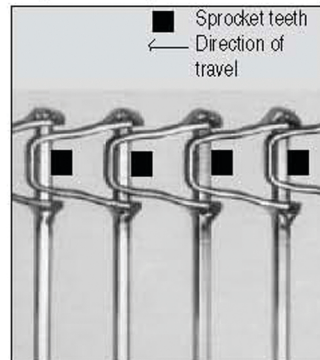


Figure 1



CAMBRIDGE

ENGINEERED SOLUTIONS

www.Cambridge-ES.com

2. Drive Shaft Sprockets:

- a. Sprockets are required on the drive shaft in line with the links. Both sprockets must be keyed.
- b. Intermediate support rollers or discs are required to support the belt between sprockets. Position on 6" centers.

3. Tail Sprockets (if tail sprockets are used):

- a. Install key, setscrew, and locking collars on one sprocket only.
- b. The other tail sprockets should be installed without key

MAINTENANCE

FOR LEADING EDGE® PERFORMANCE GRID BELTING

The following are some general recommendations for achieving optimum performance from your Leading Edge Performance Grid belting.

Procedure

1. Periodically inspect belt for damage, excessive sag, or interference with conveyor structure.

During the life of the belt, it may become necessary to replace a damaged belt section or shorten the belt. In such cases, the following procedure is recommended:

Separate the belt at a low tension area where it is convenient to work.



Figure1



Figure 2

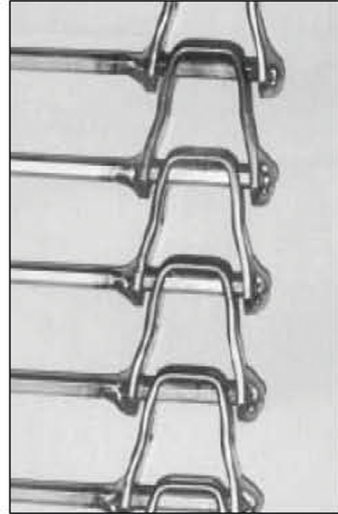
- a: Cut through rod on each side of a link between the joints of that link and a link either before or after the chosen link. Make another cut through the rod that is still connected to the link, as close to the link as possible. Separate as shown (Figure 1).
- b: Grind or saw outside welds (as shown in Figure 2). (Fix link with Vise Grip or screw driver, if possible). Grind or saw inside welds in similar fashion.
- c: Carefully grind or file excess welds.

CAMBRIDGE

ENGINEERED SOLUTIONS

www.Cambridge-ES.com

setscrew. Collars should be placed on both sides of each sprocket with 1/32" clearance between collar and sprocket.



d: Check link hole for excess material. May have to use file to smooth before inserting a new rod.

e: Insert the button headed rod through the links (and mesh, when present, insuring that the pig tail and mesh wires of the adjacent spirals alternate). Ensure that the button headed edge is on the inside of the belt.

f: Blast weld the end of the rod into the link making a dome shaped weld.

g: Using filler material recommended for type 304 (306, 308) or silver solder, weld in the same fashion as the other links to achieve the same size and shape as the factory welds.

h: Deburr welds to match adjacent welds, leaving no sharp edges to cut plastic drive bars.

2. Operation of the belt with severely worn sprockets may result in abnormal belt wear. Sprockets should be periodically checked and replaced when worn.

3. Leading Edge Performance Grid turn belts and spiral cage belts:

Normally the outer edge of all turn belts will wear faster than the inner edge. Obvious "stretch" on one side of a belt in slack areas indicates the need to "flip" the belt side for side. Under normal conditions, the belts should be flipped to equalize belt wear after 8,000 to 12,000 operating hours. If you wish to flip the belt, you may get an additional 30% service life.

NOTE: Not all spiral system belts can be flipped. Edge construction must be the same on both sides to permit flipping. Belts with lane