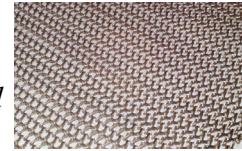




**ASHWORTH ENGINEERING**  
*Committed to on-time delivery of defect-free products and services, fit for use, exactly as promised, every time.*



**T E C H N I C A L B U L L E T I N**

**A S S E M B L Y I N S T R U C T I O N S**

**CONVENTIONAL WEAVE BELTS**

*Ashworth Bros., Inc. guarantees quality of workmanship and the material used in the fabrication of the belt to be as specified. Belts are rigidly inspected before shipment. The care used in the installation of the new belt and the observance of good operating practices are insurance of long life and low maintenance cost. The following suggestions are offered for your guidance:*

**GENERAL**

Friction driven Woven Wire Belts are designed for operation over *straight faced* terminal pulleys. Flanged pulleys will not control side travel and are not recommended, nor should crowned pulleys be used. Belt tension beyond that required to move the loaded belt should be avoided. Where conditions permit, the drive pulley should be lagged. Snub rolls, pressure or pinch rolls effectively reduce belt tension and are in general use on Wire Belt installations.

Terminal pulleys should be adjustable--check for proper alignment. *To correct side travel, increase the center distance of the terminal pulleys on the side toward which the belt is traveling.*

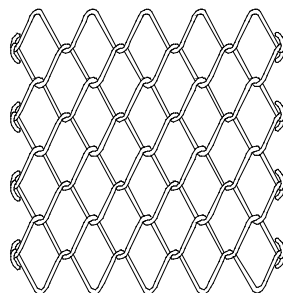
Supporting rolls must be level and at right angles to the conveyor center line. Belt path should be checked for freedom from obstructions such as warped hearth plates or protruding framework, which might cause belt impingement. Check the belt take-up mechanism to make certain it is functioning properly.

Before installing the new belt make sure none of the spirals have been turned during shipment and that all spirals are flat and free to turn on their proper axis.

**TO MAKE CONVENTIONAL WEAVE BELTS ENDLESS (Refer to Sketch on Reverse Side)**

For ease of handling, most belts, because of their length and weight, are shipped in two or more sections. Normal care should be used in uncrating to prevent damage to the fabric.

Belts of one hand weave may be either right hand (clockwise winding), or left hand (counterclockwise winding). The same method of joining the sections applies to making the belts endless. Our practice is standard whether the belt is shipped in one continuous length or is made up if two or more sections. All belt lengths, when shipped, end with a loose spiral except in the case of belts of staggered knuckling. On such belts, both end spirals are closed or knuckled at one edge or side of the belt. (Refer to Sketch.) Extra connecting spirals are included with every belt shipped. The spirals have a long end loop to facilitate knuckling.



Conventional Weave  
Knuckled Edge

**CONVENTIONAL-ONE HAND WEAVE BELTS**

To Make Endless-bring the two sections together with the edges of the belt in line, a loose spiral adjacent to a fixed spiral. Turn in the connecting spiral and close or knuckle the open ends. Note: DO NOT knuckle the connecting spiral to any other than the open-end spiral. (Refer to sketches.)

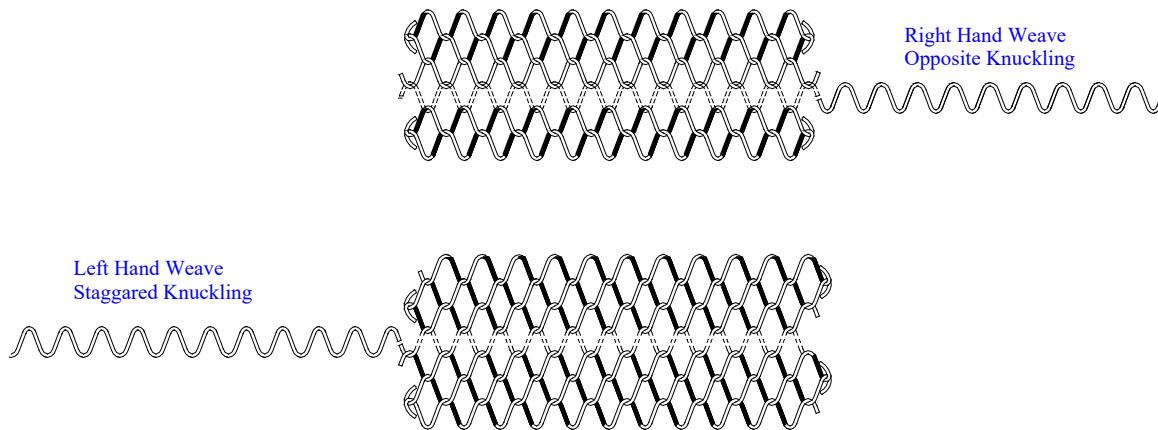
Belts having a turned up Guard Edge are made endless by the method described with the exception that the connection spiral is turned into the bottom of the belt only, and secured by closing or knuckling the open ends. The opening in the turned up edge may readily be closed by turning in a short section of a connecting spiral cut to the required length and secured by knuckling at the top of the turned up section.

*Extra spirals are supplied with each shipment.*

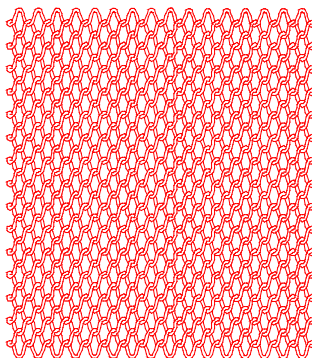
**CONVENTIONAL SECTIONAL OR REVERSE WEAVE BELTS**

Sectional or Reverse Weave Belts made up of right and left hand sections are made endless by means of a straight wire connector. (With certain mesh and gauge combinations a crimped connector is used--however, the procedure is identical.)

To Make Endless--having determined that the two sections to be joined are of opposite weave, line up belt edges, a loose spiral adjacent to a fixed spiral, mesh the end spirals together and insert the straight or crimped connector furnished. Bend back the connector rod to hold it in place and trim off any excess. Extra connectors are supplied with each shipment.



**REMEMBER TO WATCH FOR UNSEATED SPIRALS (See Technical Bulletin Uncrating Woven Belts 003).**



Conventional Weave Welded Edge

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Conventional Weave Belts

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