# TECHNICAL BULLETIN

ASSEMBLY INSTRUCTIONS

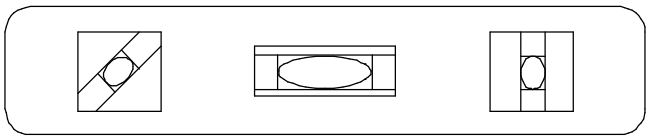
# CLEATRAC® BELT AND DRIVE SYSTEM

## BEFORE INSTALLING BELT

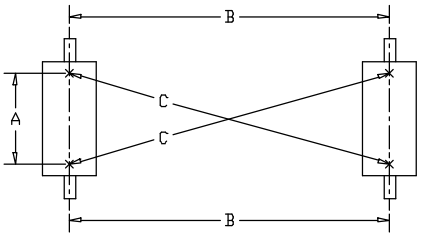
- Permanent belt damage can occur if terminals are cocked. See Ashworth bulletin “baking bands - installation, tracking, and maintenance” for conveyor alignment details.
- Use only flat faced pulleys. DO NOT use crowned pulleys, they will cause belt damage. Avoid flanged pulleys, they will not control side travel.
- Insure belt support surface is free from obstructions such as warped hearth plates or protruding framework. Insure intermediate belt support rollers, if used, are free turning.
- Make certain that the take-up mechanism is functioning properly.
- Insure no spirals are turned up and are free to hinge around crimped connectors as designed.
- All belt lengths end with a left-hand spiral (counter clockwise winding) and begin with a right and spiral (clockwise winding). Insure belt ends remain in this condition.

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

Level Belt Support Structure



Square and Level Terminal Shafts

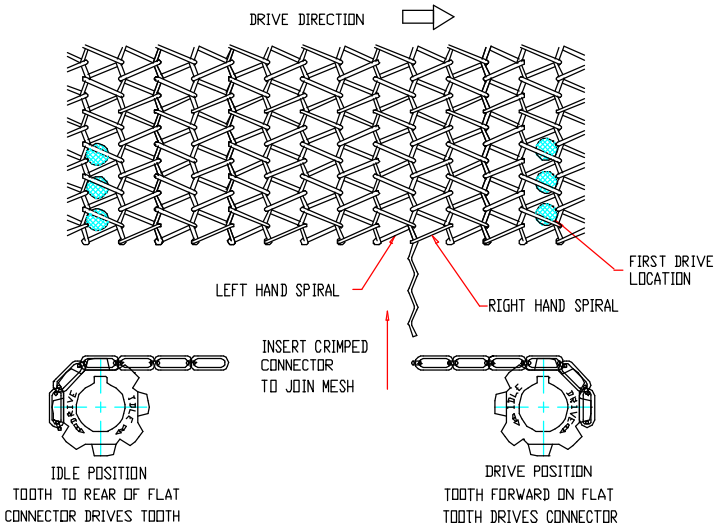



## INSTALLING DRIVE COMPONENTS

**SPACING**

| Mesh Type | Max. Spacing Between Sprockets |
|---|---|
| CTB 18 | 5” (125 mm) |
| CTB 30 | 3-1/4” (80mm) |
| CTB 42 | 3-1/2” (85 mm) |
| CTB 48 | 3-1/4” (83 mm) |
| CTB 60 | 3” (75 mm) |

- Do not exceed the maximum recommended spacing between sprockets. Insert filler rolls to support the mesh.
- See Ashworth bulletin “Cleatrac belt and drive system” for additional details.



**POSITIONING**

- Insure drive sprockets are placed on the drive shaft so that the sprocket tooth drives the connector (tooth is rear on flat).
- Space filler rolls and support bearings evenly along shaft.
- Position 1st full outside tooth in outboard sprockets in the 1st complete openings of mesh underside.
- Use a piece of the mesh as a template for locating the specific position of sprockets.

**SECURE**

If excessive heat or cold is present, suggest locking only the middle sprockets onto shaft as outer sprockets may need to "float" along the shaft to allow for expansion and contraction of the belt.

## INSTALLING BELT

- There is no top or bottom side to belt - either can be up.
- Direction of travel - insure the spiral leads the crimped connector to which it is welded.
- If replacing an old belt, splice leading spiral of new belt to trailing spiral of old belt. See **"SPLICING BELT ENDS TOGETHER"**.
- If there is no old belt on conveyor, pull belt through conveyor while maintaining even tension across belt's width.
- Before applying tension, insure all spirals are seated into the connectors and lie flat.

## SPLICING BELT ENDS TOGETHER

1. Bring the two ends together with the belt edges in line.
2. Mesh the end spirals together permitting insertion of crimped connecting wires. Insure spirals being joined are of opposite weave - one right hand, the other left hand.
3. Apply a simple fusion weld to fasten connector to end spirals.
4. Insert crimped connector and cut the connector such that approximately 1/16 inch [1.6 mm] overhangs the end spirals.

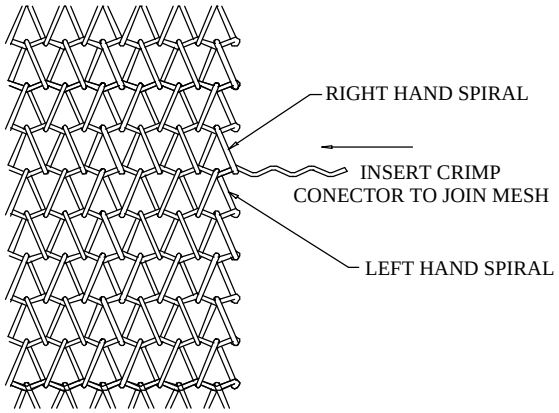
**<u>CAUTION:</u> Joining two spirals of the same hand will cause the mesh and/or sprockets to jump to one side each time this joint passes over the sprockets causing permanent mesh damage.**

# REMOVING STRETCH FROM BELTS

1. Belt length will need to be removed when the take-up mechanism is near its maximum stroke.
2. Identify a section of the belt to be removed are of opposite weave.
3. Remove as much belt as possible, however insure enough belt remains to easily splice ends together.
4. On one belt edge, cut at the weld junction leaving the weld on the crimped connector, On Other belt edge, cut at the weld junction leaving the weld on the end spiral. Remove the connector, pulling on the connector's edge containing the weld.
5. See **"SPLICING BELT ENDS TOGETHER"** to reattach belt.

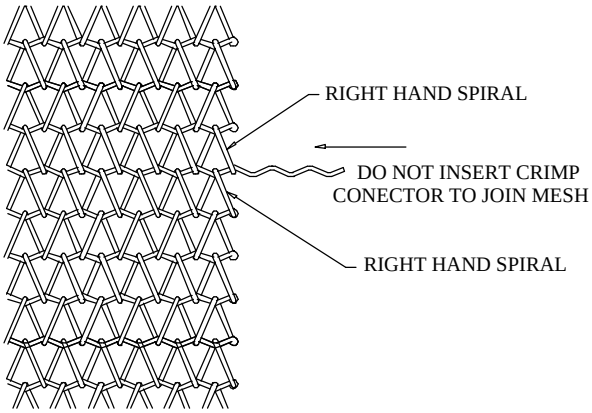


DO




SPLICE LEFT AND RIGHT HAND SPIRALS

DON'T




DO NOT SPLICE SPIRALS OF THE SAME HAND



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