

SUGGESTED GUIDELINES FOR FINGER SPLICE WELDING OF VOLTA ARAMID CORD REINFORCED (ACR) FLAT BELTS.

Important Note: All the data contained in these instructions is a general guide only based on experience from service centers using a variety of equipment. We have found that the exact temperature of each bar and pressure varies from press to press as well as between use in a workshop and on site. It is therefore recommended to run a small set of trials to calibrate a given press and in any event every splice should be checked to ensure it is hermetically closed and free from bubbles and cracks.

When using 'L' material base belt:

- Switch on your vulcanizing unit and wait for both the top and bottom bars to reach 180°C.
- Cut the belt with an appropriate finger pattern. Cut away any protruding or excess fibers. There is no need to recess or drill out the ends of the tensioning members into the belt.
- Place belt in position on heated area.
- Place a piece of silicone on the top side of the belt which will impart a smooth texture or imprint an embossed one onto the belt during the splicing.
- Weld the belt under 2 Bar of pressure for 4 minutes.
- Wait for the belt to cool down (approx. 15 minutes) and then open the welding iron and release the spliced belt.

When using 'M' material base belt:

- Switch on your splicing unit and wait for it to reach 160°C on bottom iron and 180° on top iron.
- Cut the belt with an appropriate finger pattern. Cut away any protruding or excess fibers. There is no need to recess or drill out the ends of the tensioning members into the belt.
- Place belt in position on heated area.
- Place a piece of silicone on the top side of the belt which will imprint the embossed texture to the belt while splicing takes place.
- Weld the belt under 2.5 Bar of pressure for a period of 6-7 minutes.
- Wait for the belt to cool down (approx. 20 minutes) and then open the welding iron and release the spliced belt.

When using 'M' LT material base belt:

- Switch on your splicing unit and wait for it to reach 180°C on top and bottom iron.
- See inserted text above
- Place belt in position on heated area.
- Place a piece of silicone on the top side of the belt which will imprint the embossed texture to the belt while splicing takes place. See suggested changes above
- Weld the belt using 2.5 Bar of pressure for a period of 6-7 minutes.
- Wait for belt to cool down (approx. 20 minutes) and then open the welding iron and release the spliced belt.