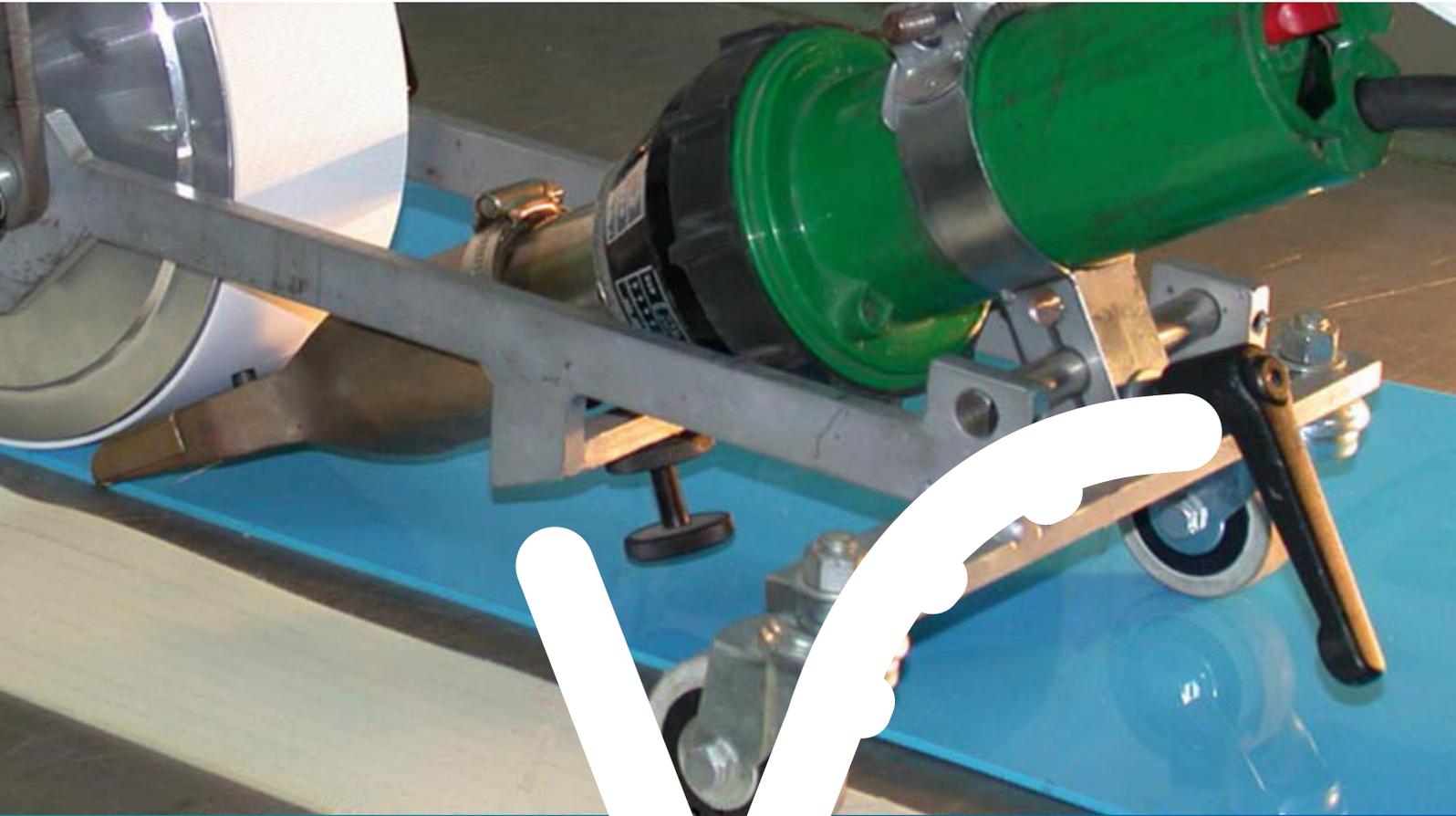




The Next Step in Belting



Sidewall Trolley

Instruction Manual

Instructions for Use of VOLTA Sidewall Trolley

These instructions are for welding VOLTA Sidewall strips to VOLTA and other Flat belts using the VOLTA Sidewall Trolley and Leister Hot Air Gun (Fig. 1) and appropriate adapters (Fig. 2). The VOLTA Sidewall Trolley is also used to weld other strips (SuperGrip, MultiGrip, HighGrip) to VOLTA Flat belts.

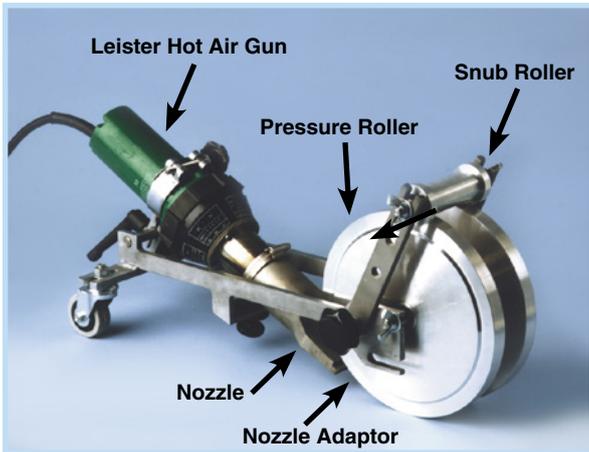


Fig. 1

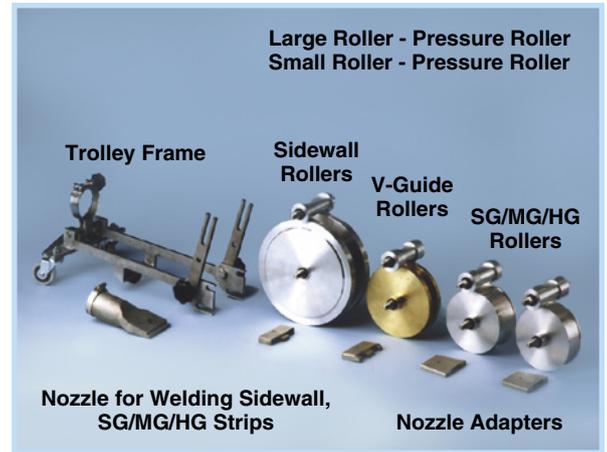


Fig. 2

The following recommendations must be performed to ensure high quality welds:

- Two technicians should work together to weld Sidewall/Strips to the Flat belt.
- The welding operation should be performed on a clean, straight and level surface that is as long as possible.
- The Trolley must be properly balanced (Fig. 3). It is important to ensure that the wheels are adjusted so that the pressure roller applies an even pressure on both sides of the strip.

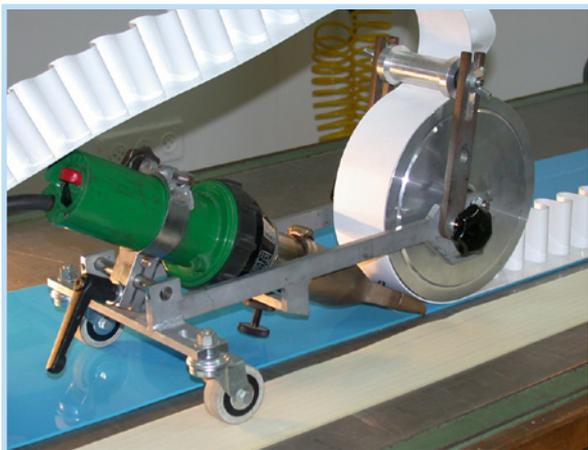


Fig. 3

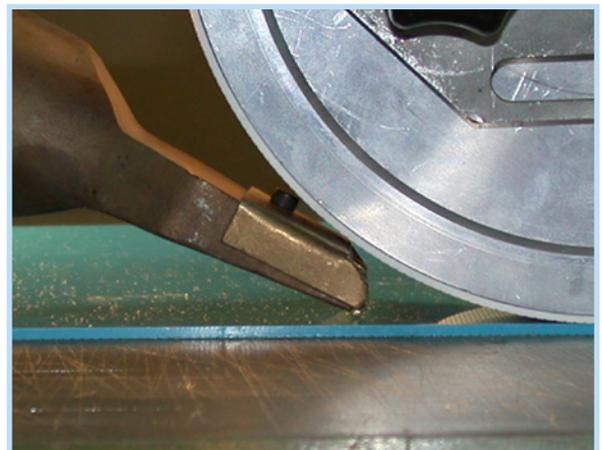


Fig. 4

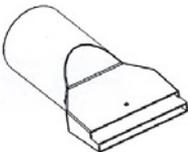
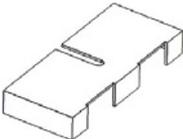
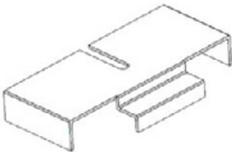
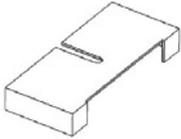
- The Leister nozzle must be adjusted to be as close as possible and parallel to the base belt and the Sidewall/Strip (Fig. 4). It is important to melt both the base belt and the bottom of the Sidewall /Strip equally.
- Technicians that are new to this procedure should first weld a test strip on a second piece of identical VOLTA material to first get the feel for the operation.

Preparation of the belt and the sidewall.

1. Prepare the belt ends according to the intended final weld (90° for homogeneous belts and less than 90° for reinforced belts).
2. Lay the belt on the working surface. Place a piece of belt material of the same thickness alongside the belt on the side you will be welding (Fig. 3). This material will provide a surface for the outside wheel of the sidewall Trolley to ride on. Without this material the Trolley will not ride level and the pressure roller will not be able to apply even pressure on the sidewall base.
3. Clean the belt according to standard VOLTA welding recommendations.
4. Mark the beginning and end of the weld. Leave a little space at either end of the belt to be used in splicing the base belt.
5. To hold the belt in place and prevent it from moving during the welding process, place a piece of double-sided tape on the workbench. Secure the end of the belt to the tape. The opposite end of the belt must be left free to allow for the belt's movement during the welding process. Do the same for the piece of material under the Trolley wheel.
6. Cut a piece of sidewall to the required length (approximately 20 cm longer than the intended belt length) depending on the type of belt closing to be used.

Preparation of the Sidewall Trolley

1. Mount the appropriate airflow head on the Leister.

			
Nozzle	Adapter for 20 - 40 mm sidewall strips	Adapter for 50 - 100 mm sidewall strips	Adapter for SG/ MG / HG strips

2. Mount the pressure and snub rollers (see figure 1 on page 1).
3. Align the parts of the sidewall Trolley (Leister, pressure roller and snub roller). Check the levelness of the Trolley by placing the Trolley on a flat, level surface. The two rear wheels of the Trolley can be adjusted (Fig. 5) to ensure that the pressure roller is pressing evenly on the belt. Adjust the height of the Leister nozzle using the adjusting screw. (Fig. 5).

**Wheel Height Adjustments-
2 places**

**Leister Position Adjustment –
2 places**

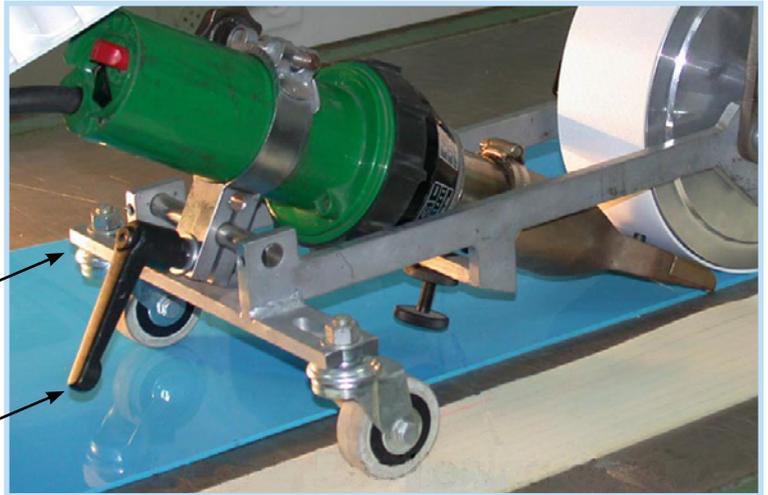


Fig. 5

Welding

1. Turn the Leister Hot Air Gun on and lay the Trolley on its side to preheat for at least one minute. The Leister must be at the highest heat setting.
2. Turn the Leister off and thread the sidewall/strip through the rollers (Fig. 6). To thread the sidewall between the roller and the Leister nozzle, use a long shaft, flathead screwdriver.

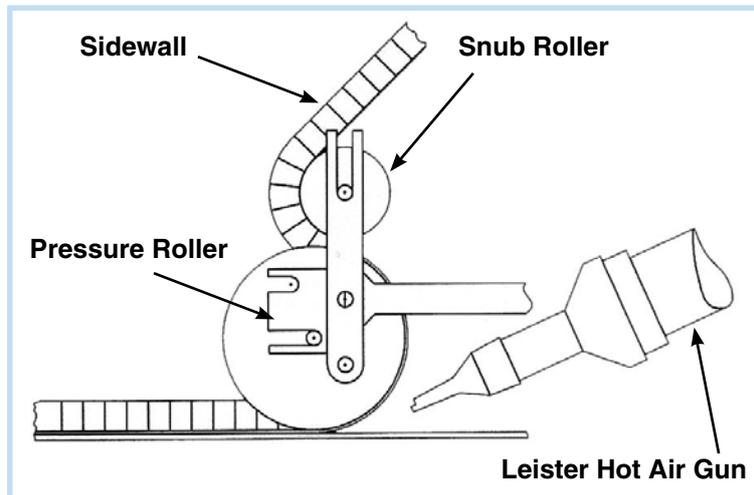


Fig. 6



The neck of the Leister Hot Air Gun is extremely hot even after it has been turned off. Be extra careful in this area to avoid burns.

3. Set the sidewall Trolley on the starting mark (see Preparation of the Belt paragraph 4). Turn on the Leister Hot Air Gun. The actions from the time the Leister is turned off until it is turned on again must be done quickly in order to maintain the preheating performed in step 1.
4. Begin a series of back and forth movements with the Trolley to develop the correct heat level on the belt and the sidewall base. If you allow the Trolley to remain in one position, the belt and sidewall will overheat and melt.
5. When the belt shows signs of welding, begin moving the Trolley in a smooth and consistent rate in the direction of the sidewall weld. The rate of movement must be suitable to the rate of welding. Watch the two sides of the sidewall base for consistent and even flow of material.
The second technician holds sidewall and feeds it to the sidewall Trolley. He can also help to guide the Trolley. When you reach the mark for the end of the weld, quickly pull the sidewall Trolley off the end of the sidewall.
6. Let the material rest and cool before splicing the belt.

What to do with a belt that is longer than the work surface

If the belt is longer than the work surface, you will need to stop the welding process and move and advance the belt to a point where you can continue to weld. This action must be done carefully but quickly to prevent overheating and melting of the belt and sidewall.

1. Prepare an air pressure nozzle close at hand in advance of starting the welding process.
2. When you reach to point on the belt where you must stop welding and move the belt, turn off the Leister and direct a flow of air over the welded area's and the Leister nozzle, including the neck of the welder.
3. Reposition the belt, Trolley and sidewall material to the new position. While repositioning, ensure that the belt and sidewall material to not touch the Leister neck or nozzle.
4. Place the Trolley at the point where the welding process is to continue and perform the preheating process by moving the Trolley back and forth until the belt and sidewall show signs of welding.
5. Begin the welding process as before using a slow consistent movement.