Belt Splicing Recommendations

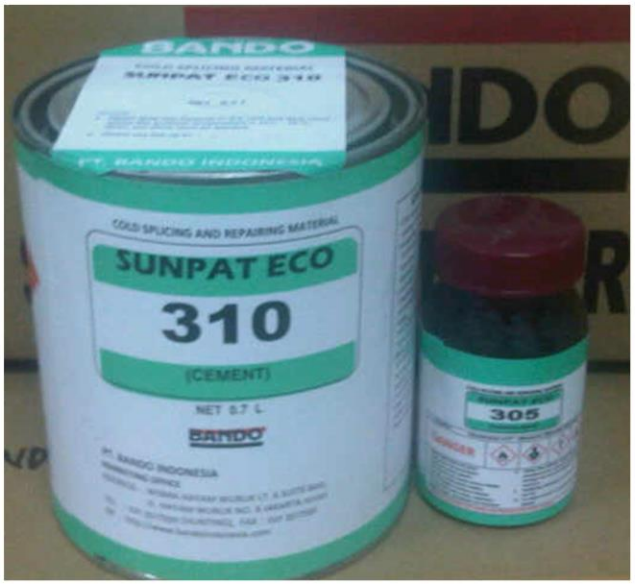
One ply strength	≤ 255 Kg/cm/ply	> 255 Kg/cm/ply
Total belt strength	≤ 1020 Kg/cm	> 1020 Kg/cm
Cover Rubber Thickness	0 ~ 6.5 mm	> 6.5 mm
Cover Rubber Grade General Use	Grade M, JIS-S, JIS-G, JIS-L QB	Grade M, JIS-S, JIS-G JIS-L QB, UIP, SAR
Oil Resistance	OR-210, OR-220	OR-210, OR-220
Heat Resistance	HC – 510, HC-513	HC-510, HC-513,HC-710
Fire Resistance	-	FR-300 T
Chemical Resistance	-	CR

TOOLS | **COLD SPLICING** | **HOT SPLICING**

9 Step Cold Splicing

1. Drawing
2. Cutting and Peeling
3. Grinding
4. Cleaning
5. Cementing
6. Joining
7. Rolling
8. Finishing
9. Checking

Material Cold Splicing

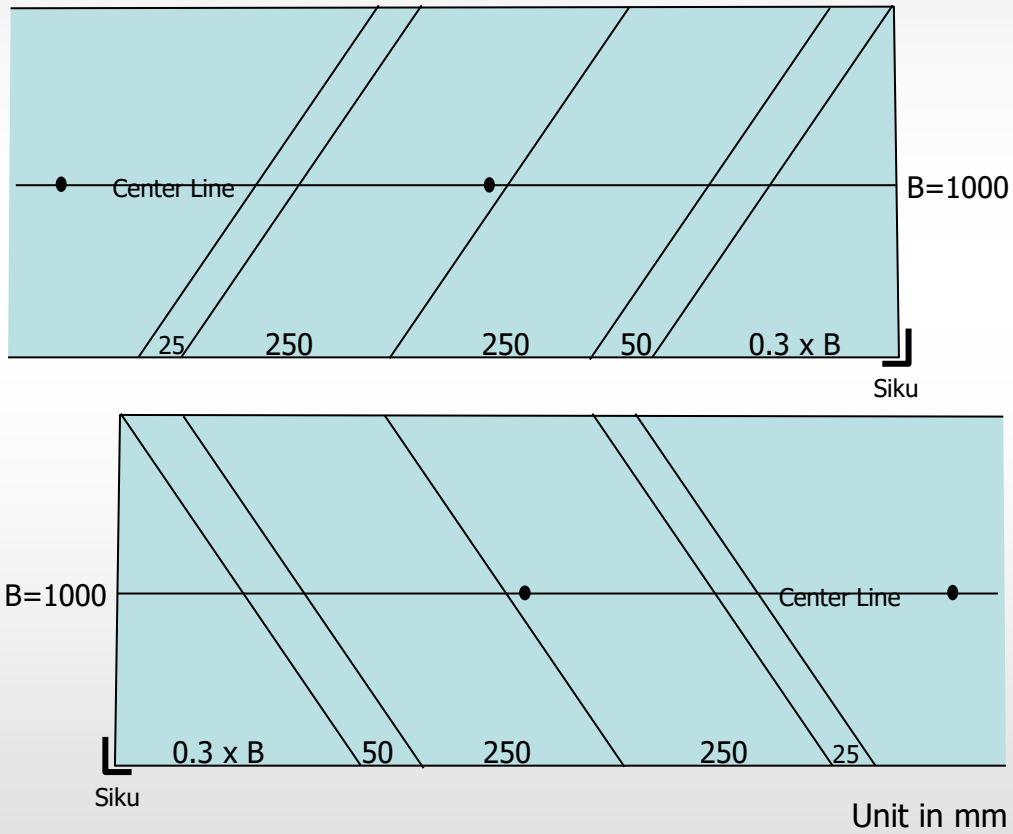


9 Step Cold Splicing

BACK

1. Drawing

Misal Spec. 1000mm x EP-200 x 3P



Cold Splicing Calculation

$$L = (0.3 \times B)+(S \times (n-1))+25+50$$

L = Splice Length [mm]
B = Belt Width (mm)
S = Step Length (mm)
n = Total Plies

Step Length Table

Fabric Strength (Kg/cm)	Step Length (mm)
50 – 120	150
121 – 150	200
151 – 200	250
201 – 250	300
251 – 350	350

9 Step Cold Splicing

BACK

2. Cutting And Peeling

- Cut and Peel Cover Rubber
- Cut Edge Gum
- Cut and Peel Canvas
- Cut and Smooth-down Canvas

9 Step Cold Splicing

BACK

3. Grinding

Grinder & Coarsening Surface of crosscut Cover Rubber

Coarsening the surface cover with scratch of brush

Do not hurt canvas when grinding

RUBBER CONVEYOR BELT

Sales Engineering

RUBBER CONVEYOR BELT

Sales Engineering

9 Step Cold Splicing

BACK

4. Cleaning

Cleaning Surface of Extension with Wire Brush

Cleaning Surface of Extension with Dust-Cloth Wetted with Cleaning Solvent

Dust-Cloth have to be clean

9 Step Cold Splicing

BACK

5. Cementing

First Step of Gluing:

Dab the BANDO Sunpat-ECO Glue till flatten, then wait momentarily around 10~20 Minute

During cementing cement brush has to be pressed, so glue can entering pores of canvas

Second Step of Gluing:

Dab again the BANDO Sunpat-ECO Glue till flatten

Touch the surface of glue with you nail to make sure that the glue have run dry and will not patch to your nail

9 Step Cold Splicing

BACK

6. Joining

Attach Plastic layer

Centering

Attach both sides of extension, by paralleling the center line mark

Joining Belt

Joint/ gumming both extension back part and discharged its plastic layer.

RUBBER CONVEYOR BELT

BANDO

BACK

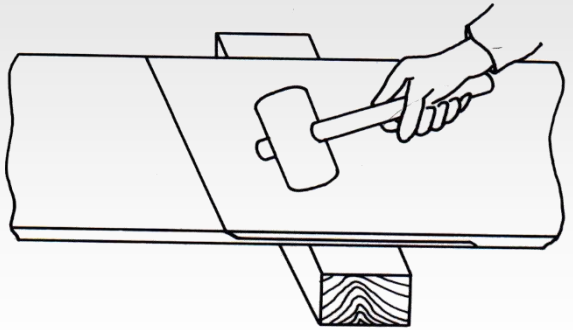
Sales Engineering

9 Step Cold Splicing

BACK

7. Rolling

Rolling must be conducted toward vertical and horizontal extension surface



9 Step Cold Splicing

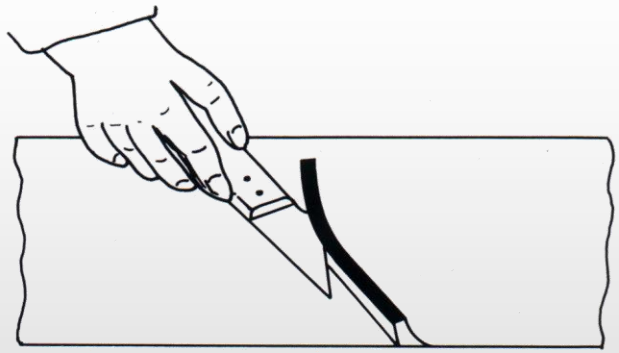
BACK

8. Finishing

Cut the remains tip of Cover Rubber

Buffing the joining surface

Neaten Edge Side Extension with Buffing machine

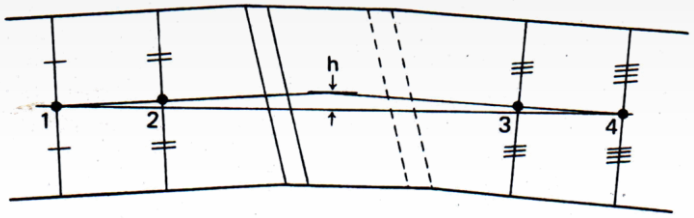


9 Step Cold Splicing

BACK

9. Checking

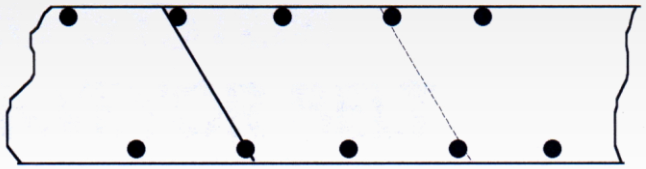
Straightness and Appearance Inspection



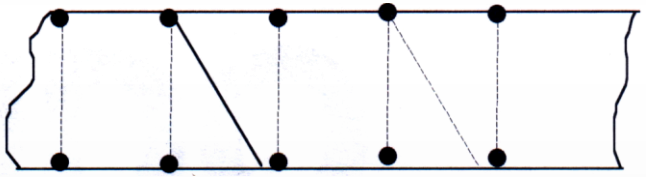
Standerd h = less than 0.1%

$$\left(\frac{h \text{ mm}}{\text{distance from 1 to 4 mm}} = 0.1\%\right)$$

Thick Inspection



Width Inspection



Length Inspection