CAMBRIDGE INC
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INSTALLATION
For DuraLite™ Belting

Tools Required: *Wrench, Vise-Grips, Bolt Cutters, Hammer, Welder, Hacksaw, File or Grinder, Safety Shield*

CAUTION: Improper installation procedures can cause premature failures, damage to belt or conveyor, reduced performance, or unnecessary downtime.

SAFETY WARNING: Never attempt installation or maintenance on a moving conveyor belt. Conveyor must be "off" with the power source locked out. Always wear proper safety equipment when performing installation or maintenance. Keep clear of moving conveyor belts at all times.

Procedure

1. DuraLite Belting is normally shipped in 50-foot rolls. In order to make the belt endless, connect one or more sections of belting together. Connecting rods and nuts are supplied.

a. The belt should be placed on the conveyor with proper orientation to the direction of travel *(Figure 1)*.
b. The threaded connector rods must be installed with the nuts located on the outside belt edge to prevent damage to the conveyor inside radius wear surface.
c. Insert threaded connector rod and attach nut. Insure that the nut does not protrude farther than adjacent rod button heads *(Figure 2)*.
d. Remove excess threaded length with a hacksaw or hand grinder.

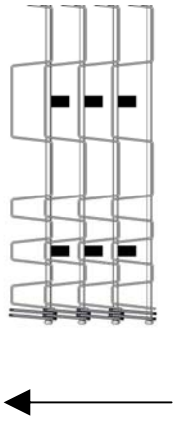


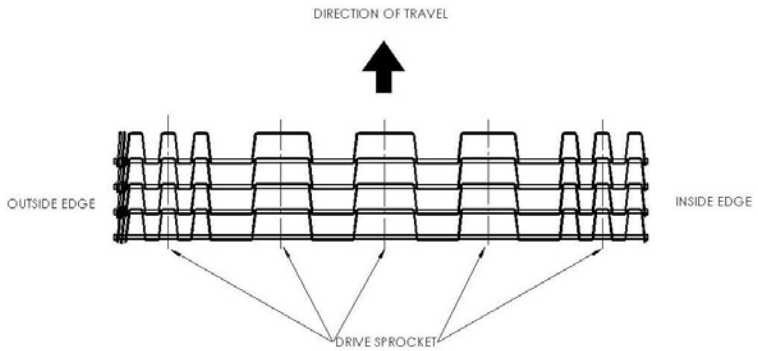
Figure 1

Figure 2

e. Fix nut from rotating by very lightly tack weld or solder nut to rod. (Do not weld nut or rod to reinforcing bars.)
f. Deburr sharp protrusions, so that the result is smooth and uniform with the adjacent rod welds.

2. Drive Shaft Sprockets:

   a. The first sprocket from each edge should be located at the third wicket opening. Sprockets should be placed approximately 6" apart and engaging the rod at odd numbered openings. NEVER PLACE SPROCKETS AT THE FIRST INSIDE WICKET OR FIRST OUTSIDE WICKET.
   b. Sprockets should be placed in the center of the opening with teeth engaging the rod.
   c. All drive sprockets are to be keyed and fixed to the shaft with a setscrew.



3. Tail Sprockets (if tail sprockets are used):

   a. The first sprocket from each edge should be located at the second wicket opening. Only one sprocket should be keyed. Sprockets should be spaced approximately 6" apart, and engaged in the even numbered openings.
   b. Install key, setscrew, and locking collars on one outside sprocket only.
   c. Other tail sprockets should be installed without keys or setscrews. Collars should be placed on both sides of each sprocket with 1/32" clearance between collar and sprocket.

MAINTENANCE for DuraLite™ Belting

The following are some general recommendations for achieving optimum performance from your DuraLite™Belting.

1. Periodically inspect belt for damage, excessive sag, or interference with the conveyor structure.
2. Operation of the belt with severely worn sprockets may result in abnormal belt wear. Sprockets should be periodically checked and replaced when worn.
3. DuraLite turn belts and spiral cage belts:
   Normally the outer edge of all turn belts will wear faster than the inner edge. Obvious "stretch" on one side of a belt in slack areas indicates the need to "flip" the belt side for side. Under normal conditions, belts should be flipped to equalize belt stress after 4,000 to 6,000 operating hours. In heavily loaded or high speed operations, the belt should be flipped every 6 months regardless of operating hours. *Note: Not all spiral system belts can be flipped. Edge construction must be the same on both sides to permit flipping. Tight radius and reduced radius belts can not be flipped.*
   CAUTION: Connector rod nuts must be reversed to outside of belt when flipping to avoid damaging inside radius wear surface.
4. Belt life is directly related to system cleanliness and lubrication. The belt should be kept clean and free from foreign objects. Under certain conditions wear strips should be lubricated on a periodic basis.

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