

Hot Splicing of Steel Cable Conveyor Belt

Yala Green Power Project

By

Thai Conveyor Belt Co.,Ltd.

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General Conditions for Splicing Steel Cable Belts

1. Conveyor belt

Phoenix Belt ST500 Top 6mm. Bottom 4 mm.
Cord 3.6mm.

2. Equipment and tools Brand Nilos vulcanizer

3. Splicing products

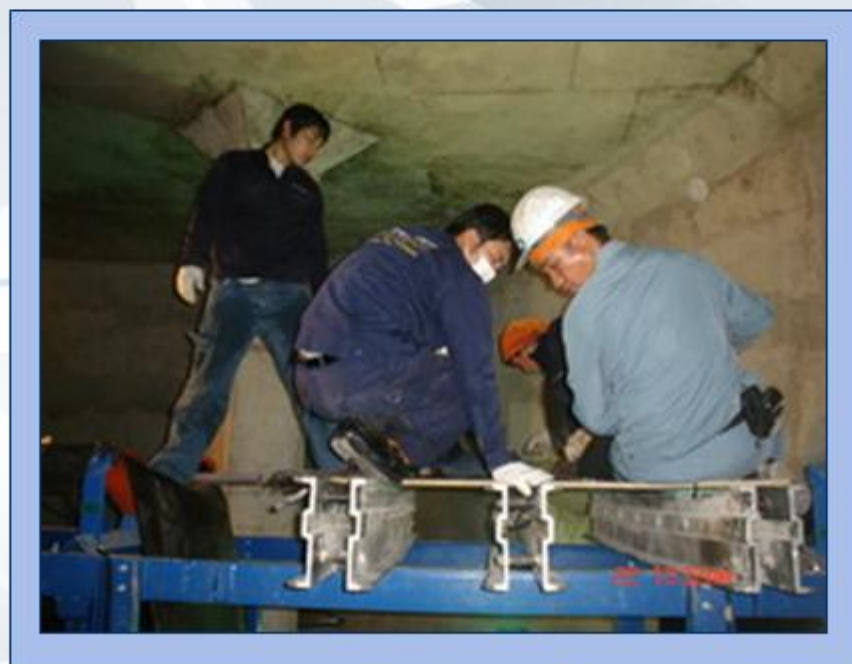
- 5381243 Heating Solution STL-RF
- 5380897 Uncured Intermediate Rubber 1 mm. (Tie Gum)
- 5380952 Uncured Intermediate Rubber Strips (Noodles)
- 5380471 Uncured Cover Rubber 4 mm.
- 5380495 Uncured Cover Rubber 6 mm.

Splicing of Steel Cable Belt

- Preparations for splicing
- Preparing the belt edges
- Assembly of cover and inner pads
- Preparing and placing the bottom cover pad
- Matching and laying the cables
- Placing the top cover pad
- Curing the splice
- Completing the splice

Preparations for splicing

- Prepare tools, equipment and splicing materials
install a work table and the vulcanizing press



Preparing the belt edges

1. On both belt ends establish and mark
 - the belt center line
 - the perpendicular reference lines and
 - the belt cover transition lines.
2. Cut off the rubber edges along the outer steel cables from belt transition lines to belt ends with a long knife
3. Bevel cut through top cover down to the steel cables along the belt transition line using a Don Carlos knife held at an angle of approx 30

Preparing the belt edges



4. Removing top and bottom cover and stripping of steel cables

Preparing the belt edges

5. Buffing the rubber embedded cables



Preparing the belt edges

6. Buffing the transition zones



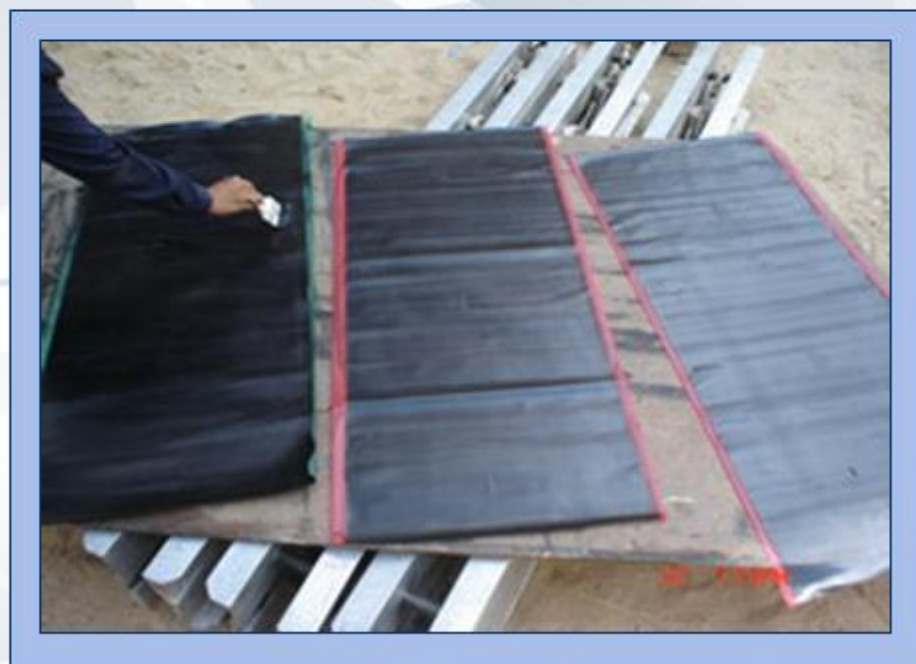
Preparing the belt edges

7. Removing the buffing dust
8. Applying heating solution
9. Aligning the belt ends



Assembly of cover and inner pads

1. Thickness of cover pad 6 mm.
2. Thickness of inner pad 1 mm.
3. Apply with Rema TipTop steel cord heating solution STL-RF



Preparing and placing the bottom cover pad

1. Thickness of bottom cover pad 4 mm.
2. Apply with Rema TipTop steel cord heating solution STL-RF



Matching and laying the cables

1. Laying the cables

This operation is always started at the center of the splice



Placing the top cover pad

1. Apply a generous coat of STL-RF heating solution.
2. When placing the top cover pad avoid trapping air.
3. Trim excess rubber in the transition zone and check the correct alignment of the belt center lines again



Curing the splice

1. Heating Temperature 145 C.
2. Curing time 3 minutes per mm. belt thickness, but not less than 30 minutes.
3. When curing is completed allow the heating platens to cool down to 60 C. before releasing the pressure.



THANKS FOR YOUR INTEREST AND CONSIDERATION

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