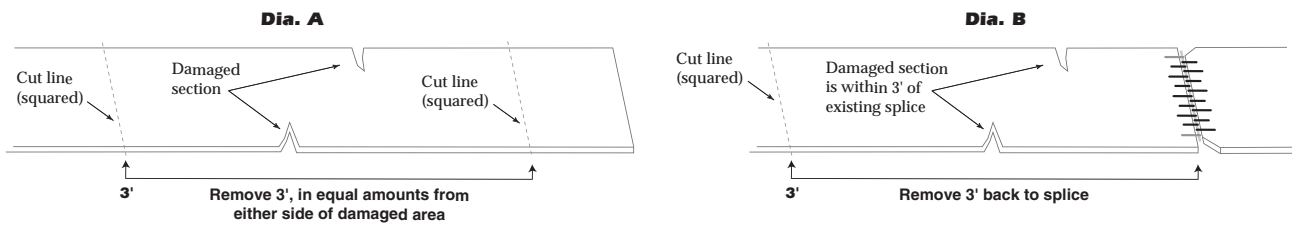


# Installation of Baler Belt Splice

## Pre cut 3' baler belt repair splices

Repair splice ends are pre squared (*and skived if necessary*) from the factory and ready to install. When preparing to install a belt splice, it is important to use the full 3' piece (**dia. A**). If the damaged area of the belt is within 3' of the existing splice, replace the damaged belt back to that splice (**dia. B**). It is recommended the repair splice be installed a minimum of 3' from other belt splice to reduce the possibility of damage from tension and travel over pulleys. The ends of the original belt should be squared by using the center line belt squaring method (see **How to square**). If original belt requires skiving use a skiving tool (see **how to skive**) to trim off any rough/impression top pattern on the belt so that it matches the pre-skived splice.

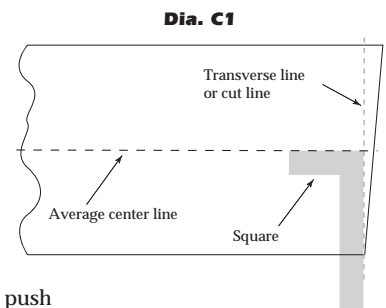
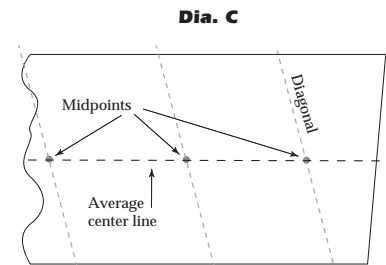


### Tools needed to square belt using the center line method:

- Measuring tape
- Steel square
- Belt skiver (*if installing rough/impression top belt*)
- Utility knife
- Light chalk or writing utensil that will mark on rubber belt

## How to square with the center line belt squaring method:

- Using a measurement wider than the belt width, draw a diagonal line (i.e. 10" for a 7" belt) and mark the midpoint points with a light chalk or pencil, (**dia.C**) repeat this step for three to five feet.
- Draw an average center line using the midpoints marked in step one as a guide (**dia.C**).
- Use the steel square to mark the transverse line at the point at which the belt is to be cut (**dia.C1**).
- Cut the belt with the utility knife using the square to keep the cut straight.



## How to skive an impression top belt:

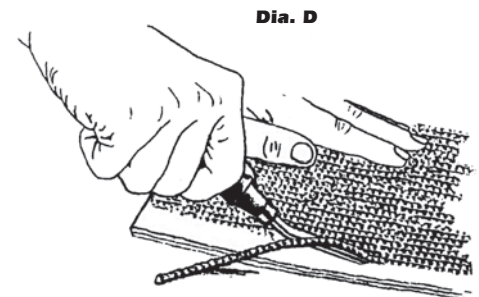
- Place belt on a firm surface and hold securely with free hand. *Note: Do not place free hand in front of the blade while using skiver and do not pull skiver towards body.*
- To remove rough/impression top, hold skiver at approximately a 20 degree angle to belt and push (**dia. D**) with the rough/impression top pattern, take caution not to cut into the belt carcass.
- Skive back far enough (*3/4" to 1"*) to allow for entire reachback of fastener and to allow clearance for the fastener installation tool.

### Skiving tips:

If the rough top is not easily removed, try the following:

- Change the cutting angle.
- Skive across the belt with a slight side-to-side wiggling motion.
- Apply soapy water or silicone spray to the skiving surface.
- Be sure the skiver has a sharp cutting surface.

Review rough top belt skiver instructions for proper skiving directions.



# Installation of Baler Belt Splice

## Proper lacing installation:

### Clipper® wire hooks:

1. Use belt hooks specifically designed for your round baler.
2. Square both ends of the belt that is being repaired, prior to installing hooks (see **How to square**, pg. 1).
3. If the belt requires skiving, use the belt skiver (*hand held tool*) to remove the cover impression approximately 3/4" to 1" from the edge of the belt, removing no more than the impression pattern or down to the base surface of the belt (see **how to skive**, pg. 1).



Review Vise lacer instructions for proper installation directions.

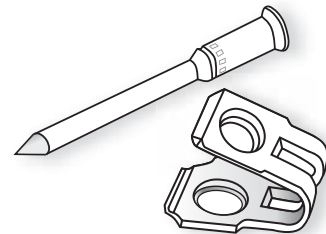
### Hook installation tips:

- Leave 1/4" on each edge of the belt unlaced. This helps to guard against end hooks being torn out by the belt guides.
- Always install one more hook (**dia. E, items a & b**) on the leading end (*pulling end*) of the belt than on the trailing end (*end being pulled*).
- Never use a hammer to finish clinching belt hooks. This tears belt fabric causing premature splice failure.
- When lacing belts with a vise lacer, always use the pressure plate provided to finish clinching belt hooks. (see **vise lacer instructions**).

### Alligator Rivet® fasteners:

- Square both ends of the belt that is being repaired.
- Use the belt skiver (*hand held tool*) to remove the cover impression approximately 3/4" to 1" from the end of the belt and no further down than to the cover. (see **how to skive**, pg. 1).

Review Alligator Rivet® lacer instructions for proper installation directions.



## Baler belt tips:

- Always use the same belt specification (*number of ply's and belt construction*) for your baler belt; this also applies when adding a repair splice. Two and three ply belts do not react the same under tension.

*Tip: After installing hooks, notch the corners of the belt only on the end being pulled. This allows the belt guide to slide past the belt without causing damage to the belt splice (dia. E, item c).*

- Check the length of all belts on the baler when installing a repair splice, all belts should be the same length for maximum baler performance. Apache recommends checking all belts at the end of the baling season to see if they will need resized or replaced prior to the beginning of the next season.
- Install the belt in the proper direction of travel (**dia. E**) making sure the splice leading end and notched trailing end are in the correct direction of travel. Direction of travel is always determined by the belt splice, not the belt.

