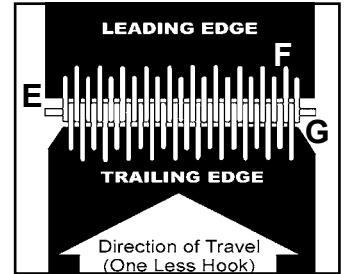
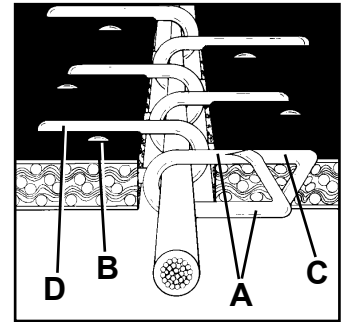




## Identifying a Properly Installed Splice

### The Hook is Properly Sized & Clinched When:

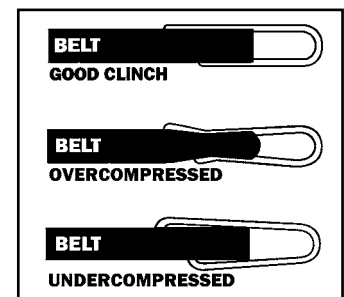
- A. Hook legs are parallel.
- B. Points slightly penetrate opposite side of the belt.
- C. 1/3 to 1/2 of the wire diameter is embedded into the belt.
- D. Hook knuckles are not higher than the legs when installed.
- E. 1/4" (6.4 mm) on each belt edge is left unlaced.
- F. One more hook is installed on the leading end than the trailing end of the belt.
- G. Trailing end of the splice is chamfered/notched.
- H. Edges of the belt line up.
- I. Hooks are secure in the belt.



**Good Clinch:** Legs are parallel, 1/2 of the wire diameter is embedded, points have penetrated opposite side.

**Over Clinch:** Functional, but not optimal.

**Under Clinch:** Embed further. Failure to do so will result in the hook opening up or in cracks in the knuckle area.



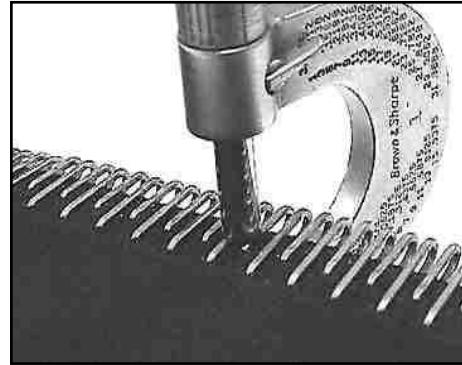


# Identifying a Properly Installed Splice

PROPERLY INSTALLED SPLICE

## Proper Technique to Measure a Splice:

Selecting the correct fastener based on the belt thickness, minimum pulley diameter, and application conditions is the first step to properly installing a Clipper® splice. The second, and most crucial factor, is ensuring that the leg of the hook is embedded 1/3 to 1/2 its thickness into the belt. It's easy to measure/inspect the splice for proper embedment; simply follow these four steps:



1. Measure the belt thickness.
2. Install the fasteners into the belt.
3. Use a micrometer or caliper to measure the finished splice. Be sure to capture both the short leg knuckle and the adjacent long leg in one reading. See picture.
4. If you have properly embedded the fasteners, your measurement should be between: 1) Original belt thickness plus the value in column C, and 2) Original belt thickness plus the value in column D. See the example and chart below.

### Example:

Belt thickness = .100"

Hook size = #1 (.040" wire diameter)

Finished splice thickness should measure .140" - .153" (.100" + .040" = .140" and .100" + .053" = .153").

	A	B	C	D
Hook Size	Wire Diameter	Plus: (1/2 Wire Diameter Embedded)	Plus: (1/3 Wire Diameter Embedded)	
25	.025"	.025"	.033"	
36, UCM36	.027"	.027"	.036"	
1, UX1	.040"	.040"	.053"	
2-7, U2-U7	.054"	.054"	.071"	
4-1/2 RHTX	.062"	.062"	.082"	

