

Repairing a tear along the edge of the belt – Side wall tear, rip or cut

A lateral tear/rip in the belt dramatically reduces the belt strength. For every 5% of the fabric carcass that is torn or ripped the belt strength is reduced by 20%. A mechanical fastener like Flexco, Goro, or Mato will be required to support the belt, however the metal clips should be covered to protect the belt cleaner and the metal clips from wear. In order to protect the belt cleaner you MUST recess/countersink mechanical fasteners as indicated below. If the ratio of metal to rubber exceeds 70/30 we recommend the use of Elite FR704 adhesion promoter to ensure Eli-Flex 909 bonds to the mechanical fastener.

<p>1 A lateral tear in the belt needs to be repaired as soon as possible. The small tear will easily rip further if not repaired. Serious injury may result from belt failure so prompt maintenance is required.</p>	<p>2 Skive out the rubber around the rip or tear at 45° using a sharp blade. All damaged and loose rubber must be removed. Be careful not to damage the carcass of the belt with the blade.</p>	<p>3 The blade will leave a shiny finish so the rubber needs to be roughened to improve the bonding properties. Use a wire brush or grinding attachment and set the grinder to the slowest possible setting</p>
<p>4 Insert the metal clips according to the instructions provided by the manufacturer. Grind the fasteners to roughen the surface of the metal</p>	<p>5 New fasteners are covered with silicon that must be removed. Clean fasteners with acetone. Let the solvent evaporate completely</p>	<p>6 Use adhesive promoter like Elite FR 704A, if multiple fasteners are being used. The adhesion promoter should be “dry” before Eli-Flex is applied (+/-15min)</p>
<p>7 Apply industrial tape to the side and underside of the repair to form a dam or a mold for the Eli-Flex. The viscosity of Eli-Flex is like peanut butter so it will not run, but the tape will assist in forming the repair</p>	<p>8 See “Six Easy Steps to Belt Repair” for instructions on mixing Eli-Flex. Use a spatula to apply Eli-Flex to the topside of the repair. Recess the repair slightly</p>	<p>9 Allow 60 minutes for every 1/16” depth of repair at 70° F for Eli-Flex to cure. Full hardness is reached after 10 hrs. See Technical Specifications for curing time at varying temperatures</p>