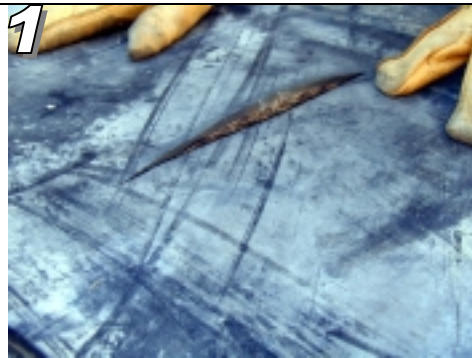
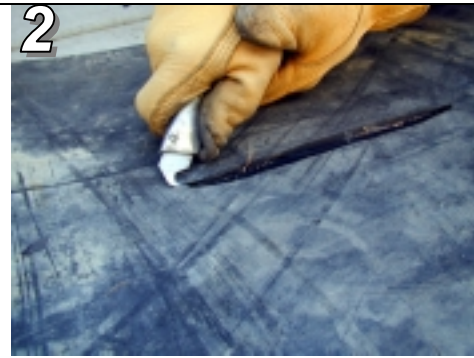


**Repairing a tear along the length of the belt – Longitudinal tear or cut.**

Rips that run along the length of the belt are a common type of belt damage. The longitudinal strength of the belt is not significantly altered however the weight of the material forces the tear open and material falls through. Rips and tears less than 36" can be easily and cost effectively repaired using only Eli-Flex FR909 conveyor belt repair resin. If the rip is longer than 36" insert a Flexco every 24". Make sure you recess / countersink mechanical fasteners down to the first layer of fabric carcass.



1 Damage running along the length of the belt has a minor effect on the belt strength. The material weight will cause the hole to open up and material will fall through



2 Open the tear/cut by skiving out the rubber at 45° using a sharp blade. A hook blade is ideal because it reduces the risk of carcass damage



3 The blade will leave a smooth shiny finish so the rubber needs to be or roughened to improve the bonding properties. Use a wire brush on the slowest grinder setting



4 If the tear has left a large hole it may be necessary to roughen the underside of the belt. If possible skive the bottom layer at 45° and roughen the surface



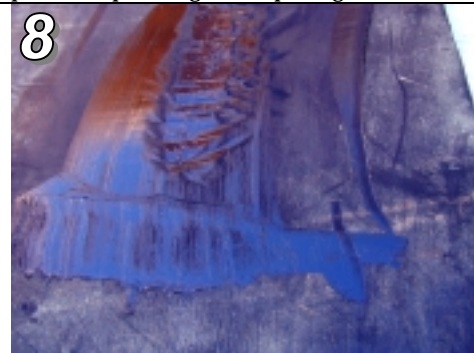
5 See "Six Easy Steps for Belt Repair" for instructions on mixing Eli-Flex. Apply to the underside of the belt. Force as much product up through the opening



6 Cover the underside of the belt with industrial tape to prevent the opening from being forced through the opening.



7 Apply Eli-Flex to the topside of the repair. Use a spatula or any straight edge tools to force the Eli-Flex into the repair opening. Recess the repair slightly to reduce contact with the belt cleaner



8 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



9 Re-use your spatula by storing it in the Eli-Flex silver liner. Once the Eli-Flex has set it can be easily cleaned and re-used. Clean your hands with any solvent before Eli-Flex dries