

## Repairing a tear along the width of the belt – Lateral 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 the belt strength is reduced by 30%. 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.



1 A lateral tear in the belt needs to be repaired as soon as possible. Serious injury may result if a belt breaks.



2 Skive out the rubber around the rip or tear. Be careful not to damage the carcass of the belt with the blade



3 You should skive back the rubber in order to countersink mechanical fasteners.



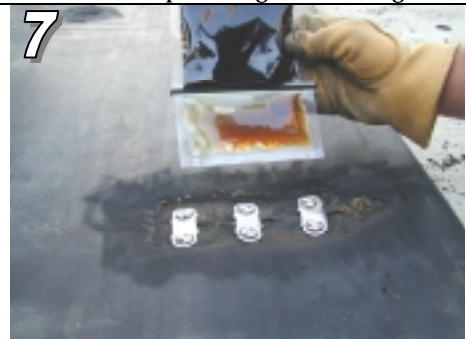
4 The blade will leave a shiny finish so the rubber needs to be buffed or roughened to improve the bonding properties. Use a wire brush or rubber grinding disk attachment on the slowest possible grinder setting



5 Insert the metal clips according to the instructions provided by the manufacturer. Grind the fasteners to roughen the surface of the metal. Clean fasteners with solvent that does not leave any residue



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 +/- (15minutes).



7 Use Eli-Flex 909 if the ratio of rubber to metal is 60/40 or greater. If you are unsure, contact support@epoxypol.com. See "Six Easy Steps to Belt Repair" for instructions on mixing Eli-Flex909 & 1510



8 Apply Eli-Flex to the topside of the repair. Use your spatula to force the Eli-Flex into the gaps. Gloves are not required but are recommended. Recess the repair slightly below the level of the belt



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