



SQUARING A BELT

The most common problem in our industry for belt failure is improperly "squared" off ends of belting. A belt that does not have square ends will not track accurately resulting in premature or immediate failure. Never assume — UNLESS YOU SPECIFICALLY ASK FOR IT — that the belt ends are square. Below are 3 methods used in our industry.

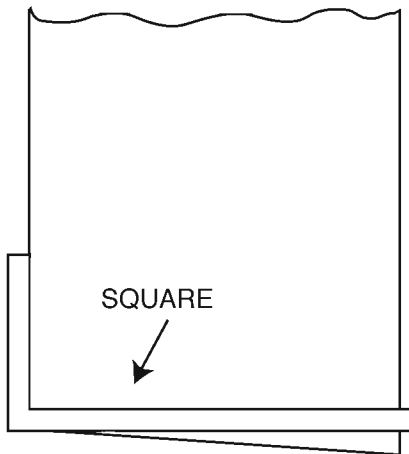


Fig.1

Edge Square Method
Most Common
(easiest & not precise)

Lay a square on belt edge. Make sure it is snug against the edge and does not move as you are cutting the belt. This method is acceptable in most cases where the belt is narrow (less than 24") the belt is new, good edges and the precise tracking is not critical.

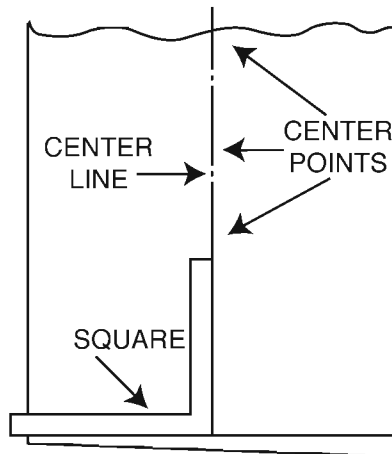


Fig.2

Center Point Method
More Accurate
(wide belts – precise)

When laying out belt ends make all measurements from centerline extending 15 to 20 ft. from each end of the belt. Instead of simply drawing a line with the belt edges as a guide, use the following method.

1. At intervals of 1 to 2 feet mark center points in belt width, using a light colored chalk or pencil. Use 4 to 5 markings.
2. Draw an average center line with these points as guides.
3. A large steel square is used to mark the transverse line at a point at which the belt is to be cut (see Fig. 2).

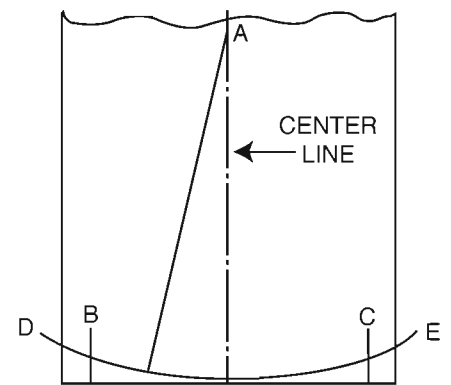


Fig.3

Arc Method
Alternative
(bad edges)

When the steel square method cannot be used follow this procedure.

1. Determine average center line as in Fig. 2.
2. At a distance from the belt end equal to about three times the belt width, drive an awl or small nail into the belt on the center line (Point A, Fig. 3).
3. Use this as a pivot for holding the end of the steel tape.
4. Mark two lines B & C equidistant from the center line.
5. Swing an arc D-E from A so that it will intersect B & C points equal from point A.
6. A line drawn between these points will be square with the center line.