

# ZipLink Splicing Procedures

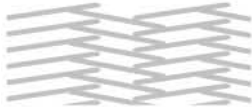


## TOOLS REQUIRED

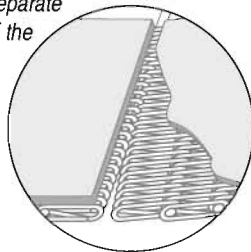
Utility Knife, Needle Nose Pliers, Hook, Spray Lubricant (Silicone for general purpose belts, Food Grade Silicone or cooking spray [i.e. Pam] for FDA belts).

## SPECIAL NOTES

The spiral base fabric consists of alternating left and right spirals. These are identified by the direction of "tilt". To correctly splice the fabric, a "left" spiral must always join with a "right" spiral.



Each time a pin is removed it will result in two different and separate edges. The edge that is on the side of the belt that will not be used will be called the "scrap side"; the piece that will be utilized for splicing will be called the "good side".



## Step 1.

**INITIAL SEPARATION:** First Prepared End

**TOOLS REQUIRED:** Utility Knife

- Place the belt on a flat surface with the bottom side facing up (this may be friction or bare).
- Using the utility knife, snip off the melted area of the heat-sealed outer edges on both sides, removing as little of the spiral fabric as possible.

## Step 2.

**REMOVAL OF MONOFILAMENT PIN WIRE**

**TOOLS REQUIRED:** Needle Nose Pliers, Utility Knife, Hook, Spray Lubricant

- Turn the belt back over so the bottom side is again facing up.
  - Spray a light coat of lubricant the length of the pin wire.
  - For narrow belts** - About 1/2" from the cut with the chevron that the spirals make facing towards you, insert the hook behind the pin wire and carefully work out the wire so that a short end protrudes from the row of spirals.
  - Grasp the protruding end (that you worked out with the hook) with the Needle-Nose pliers and pull slowly and steadily, keeping the wire as straight and level as possible. Hold the belt flat on a work surface while removing the wire.
  - Bend the belt back on the cover side and carefully cut the cover with a utility knife, leaving the spiral exposed.
- 2C. For wide belts** - At approximately the middle of the "good" side of the belt, use the utility knife to cut through the monofilament pin wire located inside of the row of spirals, being careful not to damage the surrounding

spirals. About 1/2" from the cut insert the hook behind the pin wire and carefully work out the wire so that a short end protrudes from the row of spirals. Repeat this process on the other side of the cut.

- Grasp one of the protruding ends (that you worked out with the hook) with the Needle-Nose pliers and pull slowly and steadily, keeping the wire as straight as possible. Hold the belt flat while removing the wire.
- Bend the belt back on the cover side and carefully cut the cover with a utility knife, leaving the spiral exposed.



## Step 3.

**REMOVE EXCESS COVER MATERIAL FROM SEAM EDGE**

**TOOLS REQUIRED:** Utility Knife

- Turn the belt over so the cover side is facing up.
- Line up the belt's edge with the edge of the table, as this will allow clearance necessary for the knife to achieve the proper angle to remove the excess covering.
- Run the knife along the edge where the cover meets the spiral fabric and remove only as much cover material as necessary to get a clean edge.



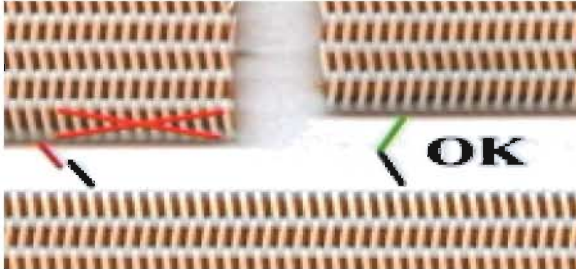
It is critical to keep the edge of the belt perfectly flat while trimming the excess covering to avoid miss-cutting and damaging a spiral necessary for seaming.

## Step 4.

### OPPOSITE END

**TOOLS REQUIRED:** Needle Nose Pliers, Utility Knife, Hook, Spray Lubricant

- A. Whether preparing the second end in the workshop or the field, the procedure followed is the same as Step's One and Two.



However, it is **critical** that in determining where to separate, the "good" edge on the second end must align with the "good" edge on the first end. If the spiral to be seamed on the first end points "left", the spiral to be seamed on the second end must point "right", and vice-versa. If the spirals are not properly aligned, you will not be able to make the seam.

## Step 5.

### JOINING THE BELT ENDS TOGETHER

**TOOLS REQUIRED:** Hook, Spray Lubricant

- A. Use the hook handle end as a tool for this procedure. With the cover side up, bring the ends of the belt together, begin at one edge, and overlap the spirals, pressing them together.



- B. Once started, you should be able to "zip" the seam together. A little additional spray lubricant can be used as necessary to ease the joining of the spirals.

## Step 6.

### LACING THE SEAM

**TOOLS REQUIRED:** Seam Lacing Cable, Spray Lubricant

- A. After the ends of the belt have been joined and the spirals area completely "zipped", insert the metal wire end of the seam lacing cable into either side of the joined spirals and push it through until it exits the other end.



- B. Grasp the end of the wire and continue pulling until the connector sleeve that joins the metal wire to the monofilament begins to enter the spirals. At this point it may be helpful to lightly lubricate the seam again.
- C. Pull the metal wire slowly until the connector sleeve and monofilament exits the other side.
- D. To finish the splicing process, tie off the monofilament on both sides of the belt, as close to the belt edge as possible.



*If available, use a soldering iron to seal each end of the pin.*



**PHONE: 1-800-259-6300**

**FAX: 1-201-337-6540**

**www.mulhernbelting.com**