

Vulcanized Splicing Procedures

**Goldline & Goldline HP
Solid Woven Conveyor Belt**

Using PVC Bonded Finger Joints

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Scope

These instructions refer to the materials and techniques involved in finger splicing solid woven PVC impregnated conveyor belt and must be strictly adhered to. Fenner Dunlop cannot be held responsible for any modification or shortcut in the operation of this procedure. ¹

The procedure employs PVC paste as the bonding medium and is suitable for all **Fenner Dunlop Goldline & Goldline HP** belt types up to and including 15,000 lb/in (2500 kN/m).

¹ **Note:** All recommendations for the use of any product or products described herein and all other data or information set forth in this document, whether concerning such products or otherwise, are furnished without any guarantee, warranty, representation or inducement of any kind, whether express or implied, including, but not limited to, implied warranties of merchantability and fitness for a particular purpose, and Fenner Dunlop expressly disclaims liability under any theory including, without limitation, contract or negligence, misrepresentation or breach of any obligation relating to the recommendation, data or information set forth herein. Readers and customers are encouraged to conduct their own tests. Before using any product, read its label and all related instructions.

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1. Health and Safety

The following instructions and procedures shall be observed at all times during the preparation and manufacture of Fenner Dunlop spliced joints in PVC Solid Woven Conveyor Belt.

- 1.1 All equipment used in the splicing of solid woven conveyor belt must comply with site regulations relating to the use of electrical equipment.
- 1.2 Only the materials listed in 3.1 are to be used.
- 1.3 None of the substances used in the PVC splicing paste are classified as dangerous substances. However, the following precautions should be taken when handling the paste to ensure maximum safety. MSDS Sheets are available on request.
 - a) The work area should be adequately ventilated.
 - b) PVC or rubber gloves should be worn at all times.
 - c) Eye contact and ingestion should be prevented.
 - d) Skin contact should be avoided.
 - e) Accidental spillages should be cleared immediately. The application of any absorbent dry powder such as sepiolite sand will help to remove stickiness and facilitate removal of the spillage.
 - f) Empty and/or unused tins are not to be left underground and should be disposed of in an approved method.
- 1.4 First Aid procedures to be followed in treating persons affected by the mishandling of PVC paste are as follows:
 - a) Eye Contact
Give prolonged irrigation with water to the affected eye and get medical attention.
 - b) Ingestion
If any of the PVC paste gets into the mouth, rinse the mouth with water.

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If any of the PVC paste has been swallowed, drink plenty of water and get medical attention.

c) Skin Contact

Wash the affected area with soap and water until all material is removed.

- 1.5 Make sure the conveyor belt is properly tagged out, de-energized and secured prior to initiating any work on the system.

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2. Tools and Equipment

2.1 A heated press capable of curing the whole area of the splice in one cure and can be heated up to 310° - 320°F (150°- 160°C) and held there at curing temperature. The press must have a method of measuring platen temperatures. This can normally be achieved by the use of Rotatherm thermometers but in certain cases it is advisable to use thermocouples between the platen surface and the vulcanized joint

The press must be capable of holding an even pressure over the whole splice area of a minimum of 50 lb/in² (0.34 MPa).

Presses for use underground must comply with the safety regulations of the relevant authority.

Recommended Press Platen sizes (Total Vulcanizing Area)

In all cases minimum platen width is calculated by adding 4” (100mm) to the belts’ width, i.e., 36” (900mm) wide belt needs a minimum platen width of 40” (1000mm).

The minimum platen length required is shown on Table 1 below.

Table 1

	Belt Type	Platen Length
Up To	6500 lb/in. (1100 kN/m)	51" (1300mm)
	9000 lb/in. (1600 kN/m)	55" (1400mm)
	10000 lb/in. (1800 kN/m)	59" (1500mm)
	15000 lb/in. (2500 kN/m)	75" (1900mm)

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It should be reiterated that the above dimensions are the minimum possible for any belt type or width. Longer platens are always beneficial to the joint by allowing longer finger lengths to be accommodated.

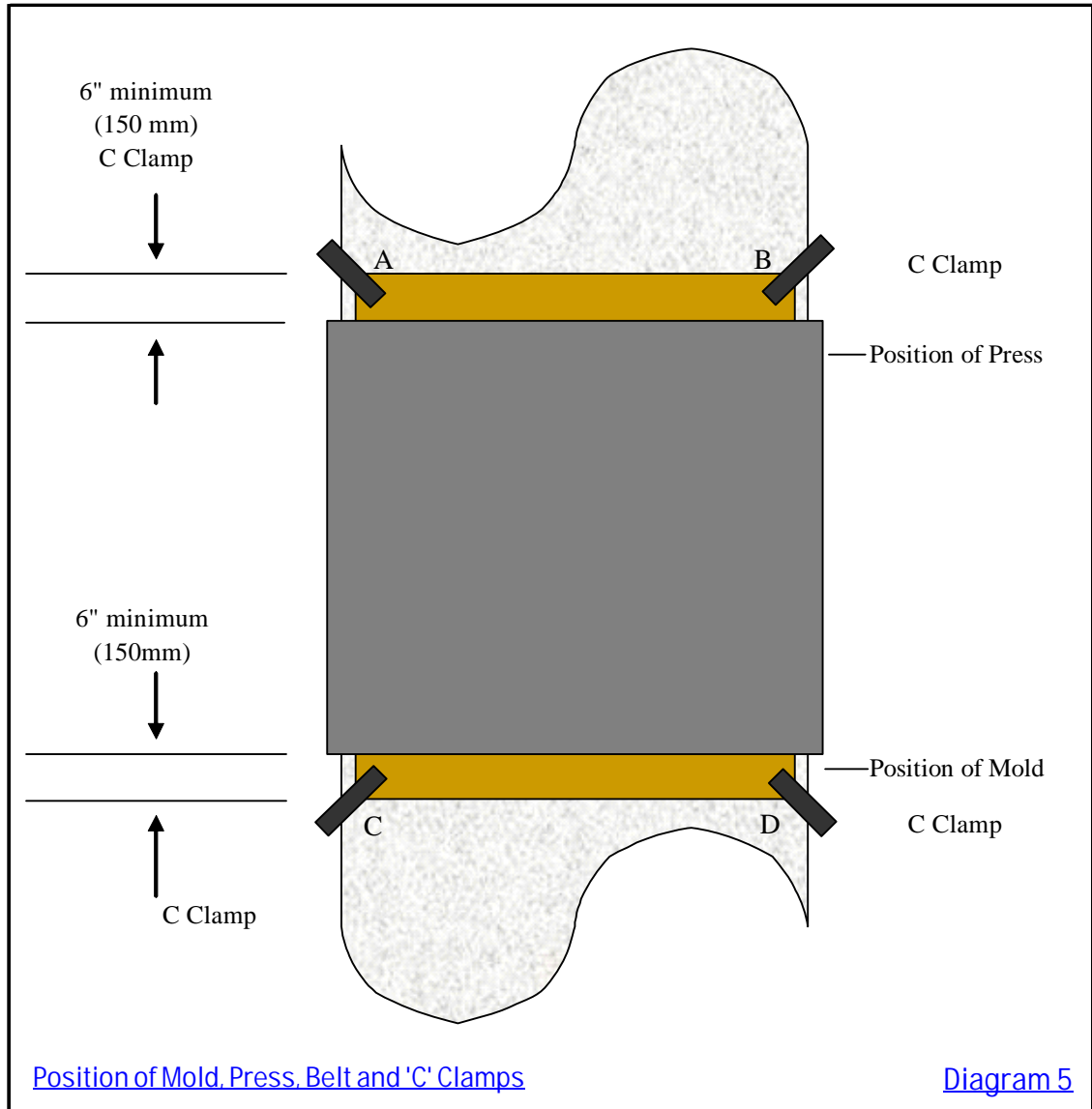
2.2 A steel mold of Type A or B to match the belt width and extending a minimum of 6” (150mm) beyond each end of the press is required. The mold must be the same width as the platen with a permissible tolerance of +0 and -1” (+0mm and -25mm).

A 1/8” (3.0mm) thick steel mold top plate.

4 ‘C’ clamps with a minimum throat length of 6” (150mm)

See Diagram 5 below.

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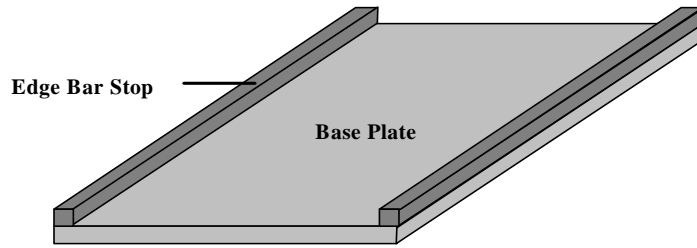
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2.2.1 Mold Type 'A' (see diagrams 6 & 7 below)

Type 'A' mold comprises a 1/8" steel (3.0mm) mold base plate with fixed edge bar stops. The mold together with edge bars, which are not fixed to the base plate, is not more than 1/4" (5.0mm) thick and not less than 1" (25mm) wide.

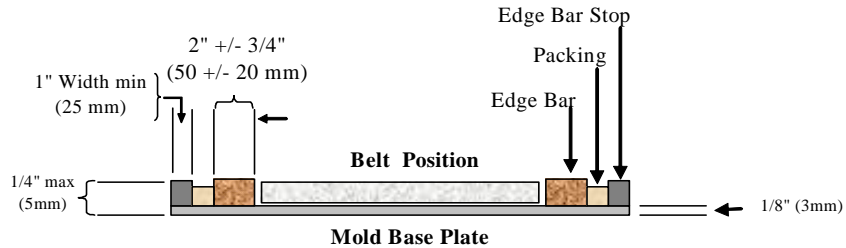
(See "Selection of Mold Edge Bars" below ².)



Mold Type A

Mold Base Plate and Fixed Edge Bar Stops

Diagram 6



Mold Type A

Mold Base Plate, Edge Bars, Stops, Packing & Belt

Diagram 7

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²

Selection of Molded Edge Bars

The molded edge bars should be 0.02" – 0.04" (0.5mm-1mm) less than the belt thickness, have a width of 2" +/- 0.75" (50mm +/- 20 mm) and a length not less than that of the mold plate. The edge bars should also be straight and true.

Notes

- A. The mean thickness is determined by measuring the thickness (before removing covers from the fingers) at eight equidistant points across the width of the belt, excluding any obvious imperfections in the belt surface. Thicknesses should be measured to the nearest 0.01" (0.25mm).
- B. Where the thicknesses of the belts to be joined differ, the edge bar is to be determined on the basis of the thinner of the two belts.
- C. For the splicing of belts where difference in thickness is greater than 0.1" (2mm), advice should be sought from the Splice Department.

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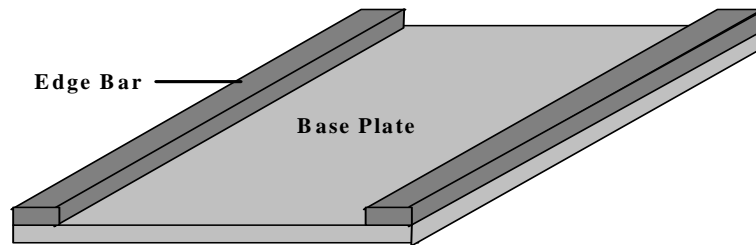
2.2.2 Mold Type 'B' (see diagrams 8 & 9 below)

Type 'B' mold comprises a 1/8" (3.0mm) steel mold base plate without edge bar stops but with edge bars welded to the base plate. (See "Selection of Mold Edge Bars".) It is necessary to use this type of mold when the nominal belt width is less than 4" (100mm) narrower than the platen width, e.g., when a 42" belt is to be spliced on a 46" (1150mm) wide press.

In these circumstances the Type A mold cannot be used, since there is insufficient space between the mold base plate stops and the edges of the belt in which to insert the edge bars.

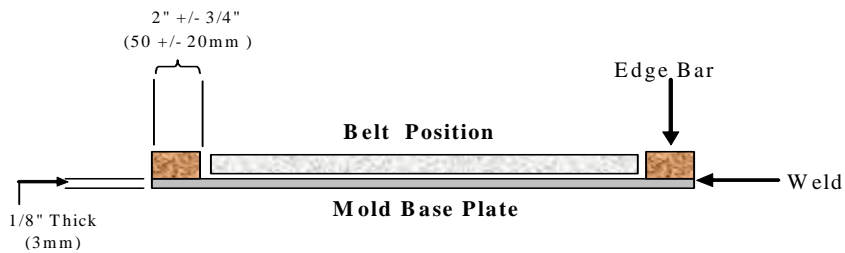
The edge bars of a Type B mold base plate must be fixed at a distance apart which is equal to the nominal width of the belt to be spliced, less 1%. This type of plate is suitable for splicing all actual belt widths that might be encountered about a particular nominal width.

A belt to be spliced using mold Type B and having a width in excess of this fixed distance will have to undergo edge trimming to attain a compatible belt width.



Mold Type B
 Mold Base Plate and Welded Edge Bar

[Diagram 8](#)



Mold Type B
 Mold Base Plate, Edge Bars & Belt

[Diagram 9](#)

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- 2.3 Suitable belt clamps, pull lifts and chain slings for belt handling and to take the tension in the belt away from the area to be spliced.
- 2.4 Suitable level working surface on which to prepare the belt ends for splicing and protection from the environment if outside.
- 2.5 Straight edge, soft light colored pencil and tape or ruler for measuring and marking out the splice fingers.
- 2.6 Utility knife, spare blades, jack plane, surform, cover removal tool and carding comb for cutting, preparation and roughening of fingers.
- 2.7 PVC or rubber gloves and goggles.
- 2.8 Metal scrapers 3" – 6" wide (75mm-150mm) for handling and spreading PVC paste.
- 2.9 Micrometer for measurement of belt thickness.
- 2.10 Absorbent dry powder such as sepiolite sand to facilitate removal of any spillage.
- 2.11 Thermocouples and temperature recording device.

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3. Materials

3.1 The materials required are:

PVC Splice Materials & Kits		
Part Number	Description	Dimension / Unit
8503-0919	SC20B Nitrile Cover Stock - Black (200 and greater)	.075 x 22" x 10'
8503-0907	Open Mesh Fabric - White (200 and greater)	.025 x 22" x 10'
8503-0909	PVC Paste - Black (200 and greater)	Gallon
8503-0910	PVC Paste - White (200 and greater)	Gallon
8503-0915	PVC Black 8lb Kit - w/ open mesh & release	8 Lb Kit - Complete
8503-0916	PVC White 8lb Kit - w/ open mesh & release	8 Lb Kit - Complete
8503-0600	Double Release Paper	62" x 100'

3.2 Storage and shelf life of materials

3.21 The PVC Plastisol should be stored at room temperature and protected from frost. Elevated temperatures {85°F (+30°C)} will lead to pre-gelation and thickening of the paste rendering it unsuitable and difficult to spread.

3.22 The nitrile rubber sheeting should be stored at room temperature or below to prevent pre-vulcanization.

If the above conditions are met a shelf life of 6 months should be obtainable.

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4.0 Procedures for Cutting to Correct Belt Width

(Ensuring the Belt Edges are Parallel and Constructing Datum Lines)

Pre-heating

The belt is pre-heated for **Fenner Dunlop Goldline & Goldline HP** standard polyester construction or has exposed carcass as follows:

After obtaining the two belt ends but before commencing to trim the belt in any way, each belt should be laid between the press platens. The press should then be heated to a temperature of 210° - 230° F (100° - 110° C) and held at this temperature for at least 20 minutes. This process will serve to pre-shrink the belt prior to vulcanizing and also drive off any surface moisture that may be present on any exposed belt textile.

4.1 Cutting to Width and Ensuring the Belt Edges are Parallel

The method to be used is one of three, given below, under 4.1.1, 4.1.2 and 4.1.3. The method used depends on the condition of the belt edges (i.e., sound or unsound) and on the type of mold plate to be used (i.e., Type A or B).

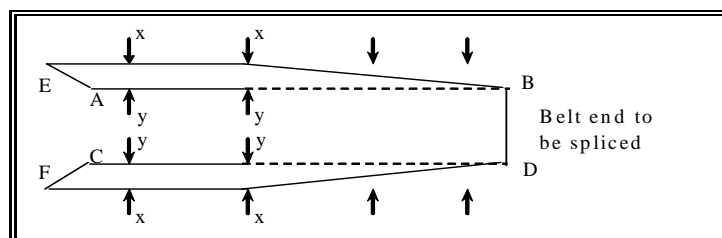
4.1.1 Belt with Sound Edges Mold Type A

4.1.1.1 Trimming the belt will **not** be necessary **unless** one belt end is wider than the other belt end to be joined. If one end is wider, cut the wider belt to the same width as the narrower belt, cutting off equal amounts from both sides of the belt. *However, it can be advantageous to make the joint slightly narrower than the parent belt to reduce the risk of edge damage.*

4.1.1.2 Construct the datum line as detailed in paragraph 4.2.

4.1.2 Belt with Unsound Edges Mold Type A

4.1.2.1 Refer to Diagram 1 and proceed as follows:



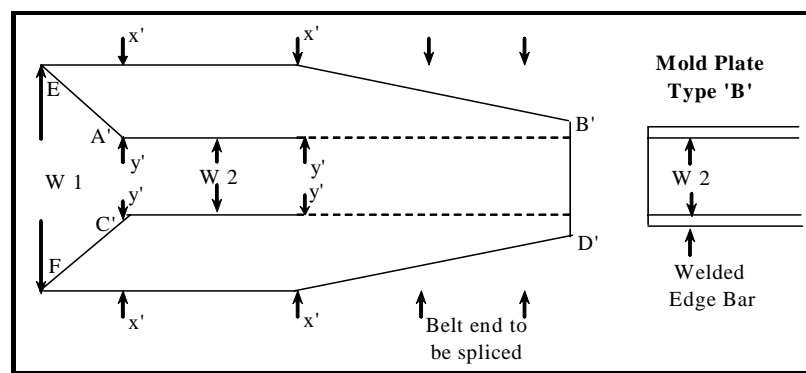
[Diagram 1](#)

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- 4.1.2.2 Measure the belt width at regular intervals of 12" (300mm) working back from the end to be spliced until the belt width is constant at consecutive intervals – xx.
- 4.1.2.3 Measure towards the center of the belt xy a distance sufficient to allow the most worn edge to be removed from the splice area. Make sure the distance is sufficient to reduce the belt width to that of the other belt end. Project a line, AB, forward to the splice area.
- 4.1.2.4 Repeat the procedure at the other edge of the belt ensuring that the distance xy at each side of the belt is equal. Draw in line CD.
- 4.1.2.5 Use lines AB and CD to trim the belt edges parallel at the splice area.
- 4.1.2.6 To avoid "steps" in the belt edges at A and C, trim small amounts off at both edges back up the belt along AE and CF, if needed, to achieve a tapered edge.
- 4.1.2.7 Construct the datum lines as detailed in paragraph 4.2.

4.1.3 Belt with Sound or Unsound Edges Mold Type B

Refer to Diagram 2 and proceed as follows:



[Diagram 2](#)

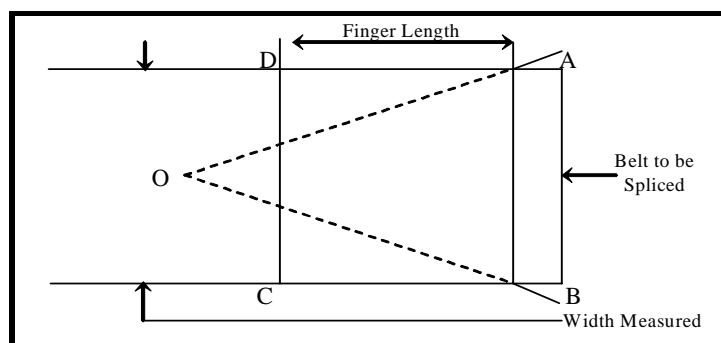
- 4.1.3.1 Measure the belt width at regular intervals of 12" (300mm) working back from the end to be spliced until the belt width is constant at consecutive intervals – xx.

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- 4.1.3.2 Measure and record the width of the belt (W1).
- 4.1.3.3 Note the distance between the welded edge bars of the mold plate (W2).
- 4.1.3.4 Measure towards the center of the belt x'y' a distance equal to $(W1 - W2) / 2$ in preparation for reducing the belt width to suit the width of the mold plate. Draw in the line A'B'.
- 4.1.3.5 Repeat procedure at other edge of belt ensuring that the distance x'y' at each side of the belt is equal, draw in the line C'D'.³
- 4.1.3.6 Cut along the lines A'B' and C'D', ensuring that the belt will be at the required width and has parallel edges at the splice area.
- 4.1.3.7 To avoid 'steps' in the belt edges at A' and C', trim additional small amounts off at both edges up the belt along A'E' and C'F' to achieve a tapered edge.
- 4.1.3.8 Construct the datum lines as detailed in paragraph 4.2.

4.2 Constructing Datum Lines

4.2.1 Refer to Diagram 3 and proceed as follows:



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[Diagram 3](#)

³ If, after drawing in lines A'B' and C'D' there are worn belt edges along these lines, then Mold Type B cannot be used. In this case, the worn edges would have to be cut out and the belt becomes too narrow for Mold Type B. In this eventuality, Mold Type A would have to be used and procedures followed from 4.1.2.

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4.2.2 Measure the width of the belt a convenient distance back from the belt end [finger length plus 3" (75mm)], halve the width and mark the mid-point O. With center O, mark the belt edge at the position where the end of the first finger is to be located as A.

Using the same measurement and center O, mark the opposite belt edge as B. Join A and B.

4.2.3 Measure back from A, along the belt edge a distance equal to the finger length and mark the position as D.

Measure back from B, along the belt edge, a distance equal to the finger length and mark the position as C. Join C and D.

4.2.4 CD is the datum for the base line of the finger and AB the datum line for the tips of the fingers.

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5.0 Marking and Cutting Belt End

Current finger dimensions for belt types up to 15000 lb/in (2500 kN/m) are shown below. The above figures are minimum lengths. If longer presses are available, it is sometimes advisable to utilize the increased length by making a longer joint. (Consult Fenner Dunlop for recommendations.)

Table 2

	Belt Type	Finger Dimensions
Up To	6500 lb/in. (1100 kN/m)	40" x 2" (1000 x 50mm)
	9000 lb/in. (1600 kN/m)	44" x 2" (1100 x 50mm)
	10000 lb/in. (1800 kN/m)	48" x 2" (1200 x 50mm)
	15000 lb/in. (2500 kN/m)	65" x 2" (1650 x 50mm)

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5.1 Marking Out

5.1.1 For finger lengths of 40" (1000mm), the datum line CD will have been drawn across the belt at 40" (1000mm) from the squared end (see diagram in Part 4.2) to indicate the position of the bases of the fingers. Draw a further line at 42" (1050mm). The 42" (1050mm) mark indicates the extent to which the belt cover is removed. The markings for belts up to and including 15000 lb/in (2500kN/m) are shown in Diagram 4 and Table 3.

Table 3

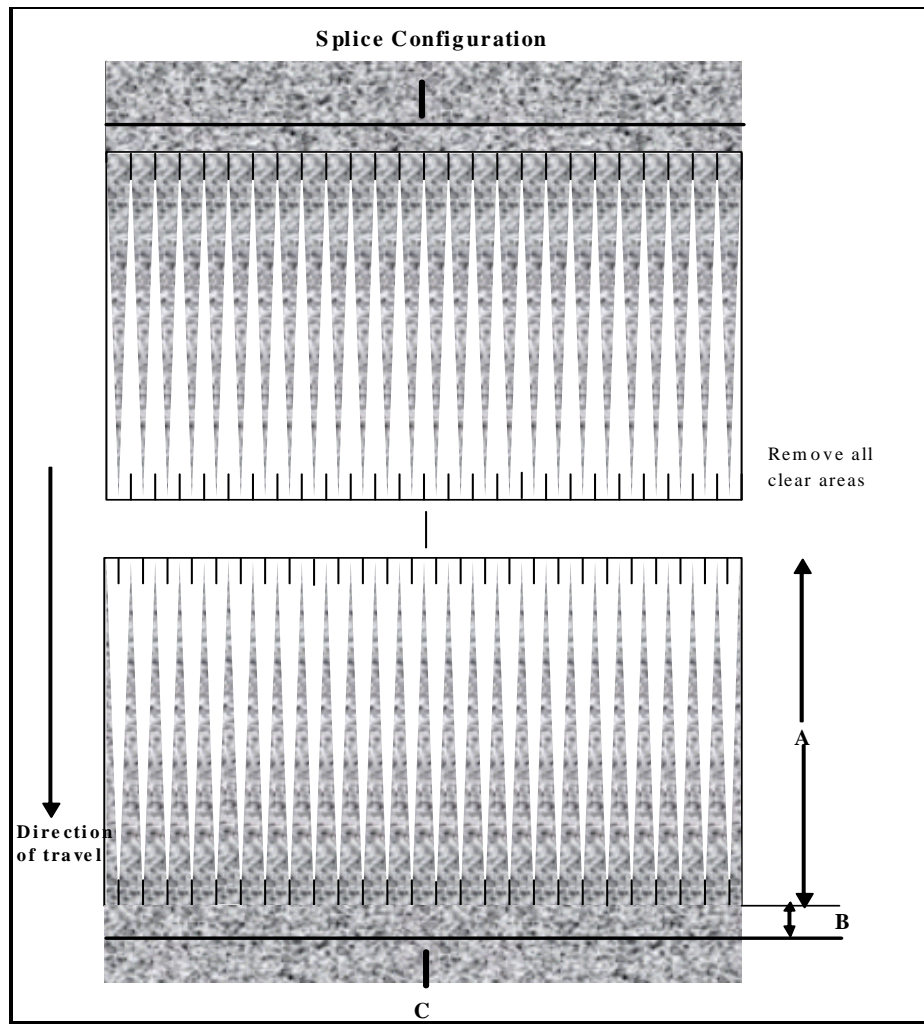
Dimension	Up To (1100 kN/m) 6,500 lb/in	Up To (1600 kN/m) 9,000 lb/in	Up To (1800 kN/m) 10,000 lb/in	Up To (2500 kN/m) 15,000 lb/in
A	40" (1000mm)	44" (1100mm)	48" (1200mm)	65" (1650mm)
A + B	42" (1050mm)	46" (1150mm)	50" (1250mm)	68" (1725mm)
C	2" (50mm)	2" (50mm)	2" (50mm)	2" (50mm)

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5.1.2 Mark the centerline of the belt ends perpendicular to the lines already drawn and the squared belt ends. These lines are used to lay the joint correctly and ensure that the joint is square and should be drawn at least 12" (300mm) beyond the parallel lines.

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5.1.3 Start with the belt that will be on the leading part of the joint when running. It will be obvious, from studying Diagram 4, that one end of the belt will be divided into ‘half cut fingers at the edges of the belt. THESE HALF FINGERS MUST BE MARKED AND CUT ON THE LEADING PART OF THE JOINT IN ORDER TO PREVENT EDGE DAMAGE. From the measured belt width, calculate the number of fingers necessary to give an edge finger of not less than 1” (25mm) in width.⁴



Q :R:S:D/D10-4

[Diagram 4](#)

⁴ Dependent on the belt width the centerline from 5.1.3 will either fall between two fingers or divide the central finger.

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The fingers are marked off 2” (50mm) wide across the 40” (1000mm) line commencing either 1” (25mm) or 2” (50mm) from each side of the centerline, i.e., for even number of ‘whole’ fingers commence 1” (25mm) from this line.

The tips of the fingers are marked on the belt end at points in between the previous markings, again working outwards from the centerline.

- 5.1.4 The other (trailing) part of the joint is then marked out so that the fingers will mate with the first part. This part of the joint will have ‘whole’ fingers, but the other two may be wider than 2” (50mm) to accommodate the actual belt width. This is illustrated in Diagram 4.

5.2 Cutting

Using a utility knife and a straight edge, cut from point to point as marked in 5.1 giving 40” (1000mm) long fingers. Care should be taken to ensure that the cut is perpendicular to the belt surface.

A useful check on correct marking and cutting is that the tip of a finger on either the leading or trailing side of the joint, should always coincide exactly with the center line of the joint.

6.0 Belt Preparation

After marking and cutting the fingers as above, proceed as follows.

6.1 New Belt

For all belting where the covers are intact, remove the cover from both surfaces of the fingers to a line 2” – 3” (50mm-75mm) beyond the base of the fingers until knuckles of the weave are just visible.⁵

Two techniques of cover removal are available as follows:

1. Standard PVC up to .04” (1mm). (See paragraph 6.1.1.)
2. Thick PVC (see paragraph 6.1.2).

⁵ **DO NOT** under any circumstances score across this line with a knife to facilitate clean removal of covers. The cover should always be cut off holding the blade horizontally to avoid damage to the belt carcass. This technique is particularly suitable when using the cover remove tool (crt). See 6.1.2.

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- 6.1.1 The top layer of PVC is removed with a jackplane. This is achieved, by laying the splice fingers on a flat surface. The operator draws the plane towards himself over one finger at a time assisted by a second operator pushing the plane from the base end of the fingers.⁶
- 6.1.2 Removal of the thick PVC cover can also be achieved by use of a sharp knife or cover removal tool supplied by Fenner Dunlop. This is essentially a flat bladed instrument that cuts away the cover in one piece. This is a two-man operation.
- 6.1.3 Where necessary further cover should be removed using a surform.
- 6.1.4 Lift the fingers individually and roughen the finger edges along their whole length.
- 6.1.5 On completion of finger preparation remove all loose material from the splice area.

6.2 **Worn Belt**

Where the textile is visible or has been exposed, the advice of the belt manufacturer must be obtained.

⁶ On standard cover belts it can be advantageous to feather the top and bottom PVC surfaces for approximately 1" (25mm) outside of the normal preparation area. This facilitates bonding of excess PVC paste in this area producing a more durable joint.

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7.0 Splicing Procedure ⁷

7.1 Ensure that sufficient PVC paste is available to complete the splice.

Approximate amounts of paste are required as follows:

Table 4

Amount of Paste	Belt Widths	Belt Type
3 Quarts	Up To and including 36" (900mm)	Up To 9000 lb/in-1 (Type 1600K)
1 Gallon	42" - 48" (1050 - 1200mm)	
1-1/4 Gallon	54" - 60" (1350 - 1500mm)	
1-1/2 Gallon	70" - 78" (1800 - 2000mm)	

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For types 10000 and above increase these factors by 2x.

- 7.2 Wherever possible the splice should be made up on a level surface to prevent the PVC paste flowing away from the splice area during the building process.
- 7.3 Prepare the fingers as instructed in Sections 5.0 and 6.0.
- 7.4 Locate the mold and edge bars on the bottom of the press, which must be at 85°F (30°C) or less and cover with release paper. The thickness of the edge bars is selected as in Section 2.0 and related notes.

Place the edge bars against the edge of the belt. Adjust any distance between the edge bar and the retaining stop with packing bars to prevent the edge bars from slipping. Any packing bars used must be of uniform width and no thicker than the edge bar.

- 7.5 Mark out on the release paper or on the edge bars the boundaries of the prepared areas of the splice, plus an amount to allow for sufficient 'pull-out' to ensure the correct finger gap in the final splice. The amount of 'pull-out' is critical to ensure a good glue-line and can vary slightly from splice to splice depending on the exact manner of cutting and roughing of the fingers. The approximate 'pull-out' for 40" (1000mm) wide belt is 2" (50mm). The ideal 'pull-out' is best estimated as detailed in paragraph 7.5.1.

⁷ **NOTE:** Throughout the splicing procedure wear protective clothing and follow the advice laid down in Section 1.2.

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7.5.1 Clamp the ends of to the mold plate using the “C” clamps allowing for the approximate ‘pull-out’ shown in the table below. Lay the prepared belt ends together and observe the appearance.

If the fingers are tight and any lifting or distortion of the splice area is apparent, then the glue-line will be too small and further ‘pull-out’ is required.

If the fingers are slack and gaps between the fingers are visible, then the glue-line will be too wide and less ‘pull-out’ is required.

7.5.2 The approximate ‘pull-out’ for each belt type is as follows:

Table 5

	Belt Type	Pull-Out
Up To	6500 lb/in. (1100 kN/m)	2" (50mm)
	9000 lb/in. (1600 kN/m)	2-1/2" (60mm)
	10000 lb/in. (1800 kN/m)	2-3/4" (50mm)
	15000 lb/in. (2500 kN/m)	3" (80mm)

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7.6 Locate the belt fingers on the mold ensuring the boundaries of the prepared splice are lined up with the marks as defined in 7.5. Ensure the splice is square by measuring the two edges from the base line of each set of fingers.

If the measurements are of equal length, then the splice is square. Clamp each end of the belt in the mold to ensure lateral movement between the fingers, which is essential to allow adequate penetration of the PVC paste. If this movement is not apparent, unclamp, adjust accordingly and re-clamp.

Mark on the belt surface two reference lines AB and CD (see Diagram 5) across the belt directly above the two ends of the mold base plate. Pull back the fingers ensuring that the marks are visible and hold the fingers in this position either manually or by tying back while the bottom surface of the splice is built.

7.7 Lay the replacement nitrile rubber sheet on the silicone paper on the bottom of the mold ensuring that thermocouples are positioned under the paper (next to the mold plate). Note this sheet should be the same width as the splice and slightly 1/2” – 3/4” (10mm-15mm) shorter.

7.8 Using a metal spreader, cover with a thin even layer of PVC paste.

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- 7.9 Lay the breaker fabric onto the PVC paste with no folds or creases ensuring that the fabric is completely coated with paste so that subsequent placement of the fingers gives adequate contact with the PVC paste.
- 7.10 Carefully place the fingers in their final positions and then apply light pressure with the hands to ensure that the lower surfaces are completely coated.
- 7.11 Cover the top of the splice with a thin layer of PVC paste and with a scraper ensure that all the exposed cut finger edges are thoroughly wetted out. If necessary, this can be achieved by lifting the individual fingers and working the paste onto the cut finger edges. Ensure all surfaces are thoroughly coated with PVC paste.
- 7.12 Fold the breaker fabric across the top of the splice ensuring a 2" – 4" (50mm – 100mm) overlap is obtained. This should be in a slightly bias configuration to avoid a line of double fabric in line with the finger gap.
- 7.13 Cover the breaker fabric with more PVC paste.
- 7.14 Finally cover the top of the splice with the replacement cover and smooth down ensuring total contact with the PVC paste.
- 7.15 Place release paper over the top of the splice and position thermocouples as necessary.
- 7.16 Temporarily remove the 'C' clamps. ⁸

At this stage check that each of the two ends of the top mold plate lie directly above the two reference lines AB and CD marked on the belt surface in 7.6. ⁹

- 7.17 Place the top platen of the press and the pressure system into position on the top mold plate.

⁸ While these clamps are being removed, take care not to stand on the belt or subject the belt to any stress that may cause the two belt ends to draw apart. Cover the splice with the top mold plate. Clamp the top mold plate to the mold using the four 'C' clamps, one at each corner.

⁹ If the lines are outside the ends of the top mold plate, then this indicates that the two belt ends have drawn apart and that the fingers are slack. In this eventuality the splice is UNACCEPTABLE and the splice should be REMADE commencing at stage 7.4 of the procedure.
Drawing apart of the belt ends as described above, should not occur if all stages of the procedure are correctly followed, particularly the instruction in the Footnote in 7.1.6 above.

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At this stage, apply approximately 10% of the final pressure to ensure contact between the paste and the belt.

- 7.18 Heat the press to 140° - 180°F (60° - 80°C) and then apply a minimum pressure of 50 lb/in⁻² (0.34 MPa), maximum of 70 - 100 lb/in⁻² (0.47 - 0.68 MPa).
- 7.19 Increase the temperature to 310° - 320°F (155° - 160°C) and hold for 15 minutes before switching off the power supply. As previously mentioned it is imperative that accurate monitoring of this vulcanizing temperature is carried out. This is best achieved by inserting thermocouples into the joint surface (in between the press platen and the silicone paper).
- 7.20 The press is to remain closed and under pressure until the temperature of the platens has dropped below 160°F (70°C). Water cooling can be used.
- 7.21 Open the press. Remove the splice from the mold and trim the 'flash' from the edges of the splice. An absence of flash indicates insufficient PVC paste has been used and the splice may not give satisfactory service. Cool the splice to ambient temperature before the belt is put into service. Dousing with cold water is acceptable.