

## Splice Inspection Guide

The first step to achieve optimal performance of a Clipper\* splice is to select the correct fastener based on the belt thickness, minimum pulley diameter, and application conditions. The next step is to ensure that the fastener is properly installed; one of the most important factors is to embed the wire diameter one-half to one-third into the belt. To measure/inspect the splice for proper embedment, follow these simple directions:

Step 1: Measure the belt thickness.

**Step 2:** Install the fasteners into the belt.

**Step 3:** Using a micrometer or caliper, measure the finished splice. Be sure to capture both the short leg knuckle and the adjacent long leg in one reading. See picture.

**Step 4:** Your finished splice should be within the range of the initial belt thickness plus one-half to one-third of the wire diameter.

## Example:

Belt thickness = .100" Hook size = 1 (.040" wire diameter) Finished splice thickness should measure .140"- .153" (.100"+ .040" to .053").

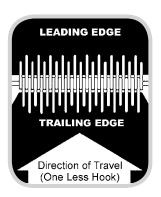


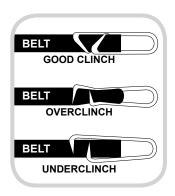
Hook Size	Wire Diameter	1/2 Wire Diameter Embedded	1/3 Wire Diameter Embedded
25	.025	.025	.033
30	.030	.030	.040
36, UCM36	.027	.027	.036
1, UX1	.040	.040	.053
UA2, UA3	.047"	.047	.062
2-7, U2-U7	.054	.054	.071
4-1/2 RHTX	.062	.062	.082

## Other Critical Elements of a Good Splice:

- 1. Hook points should slightly penetrate the opposite side.
- 2. Hook legs should be parallel when installed. The knuckles of the hooks should not be higher than the legs.
- 3. Do not lace entire width. Leave  $\frac{1}{4}$ "  $\frac{1}{2}$ " on each edge unlaced.
- 4. Use one more hook on leading edge than on trailing edge.
- 5. Chamfer/notch trailing edge.
- 6. Belt edges should line up when laced ends are connected.







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