

## Splicing Instructions

### New butt splice (30) for Fullsan Flat (FLT) and Flat Pro (FLT+)

Splicing procedure	Melt splices
Splice type (AdV)	New butt splice (30)
Splice pitch	
Splicing tool	SlimHeatingPress (SHP) air-cooled press (see the following operating instructions no.: 283)
Preparation tools	Fullsan belt cutter
Accessories	Safety knife, cut-resistant gloves, safety glasses, thickness sensor, thickness sensor, tape measure, extra material, flashlight, cloth (lint-free and colorless) inlays and separating media suitable for the product
Cleaning agents	Ethanol
Thickness allowance FLT	Belt thickness + $\pi$ (analogous to Transilon)
Splicing allowance	Fixing section + cutting position
Cut-off length	Required belt length + splicing allowance + thickness allowance
Info	Only applies if the belt is cut off at a 90° angle

**⚠ Caution:** These splicing instructions may only be used in conjunction with an up-to-date splice data sheet for the relevant belt type.  
The splicing procedure, splice type, splicing instructions and splicing tool must tally in both documents.

**⚠ Caution:** All the following instructions assume that the underside of the material is at the bottom and the top face is at the top.

**⚠ Caution:** Only use the tools, equipment and machinery listed as specified in the relevant operating instructions

**The splicing parameters were determined under standard conditions (23°C, 50% relative humidity) and can differ if other ambient conditions apply.  
Press used: Blizzard SHP 900 No. 06, 230 V, 2350 W**

**Please note:** We recommend making a trial splice before you make the actual splice.

**Please note:** If you're making a splice in humid conditions, we recommend drying the belt beforehand to prevent any blisters from forming. To do so, a belt is placed in the heating press according to the splicing instructions with the following parameters:  
Pre-dried: 150°C, x bar, 10 mins. The belt must not be cooled once the hold-down time has expired. Then start splicing with the parameters specified. Please make a trial splice before starting.

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## 1 Preparing/cutting

### Procedure

- Before starting, read through all the splicing instructions and prepare for each of the steps.
- Make sure you select the guide rails (inlays) correctly.
- Use the belt cutter to cut the belt to its final length (see the belt cutter's operating instructions)

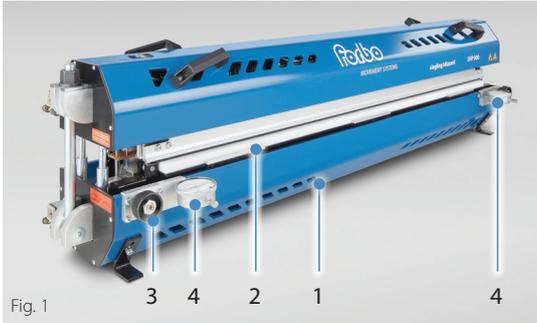
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## 2 Heating press assembly bottom

The instructions show how to use the heating press properly (see operating instructions no.: 283)

**Warning:** To prevent burns, don't touch the device's heating components (heating platens) and the conveyor belt until they have cooled down.

- Put the bottom half of the press (1) in position (ensuring it's in a stable position and at a height safe to work at, without a belt holder and inlays). (Fig. 1)
- Turn the two belt set screws (3) to put the infeed unit (2) in the starting position. (Turn them tightly towards Open until they go no further). (Fig. 1)
- Turn the two dial gauges (4) to zero. (Fig. 1)

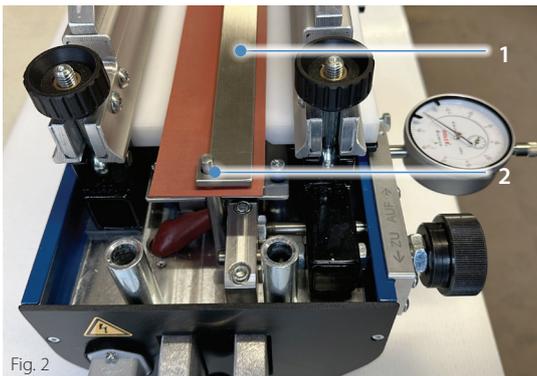


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## 3 Press layout bottom

**Caution:** Clean the ends of the belt you want to splice and all the components to be placed in the press. To do so, use a cloth soaked in ethanol. Allow the ethanol to evaporate from the components you have cleaned before they are used.

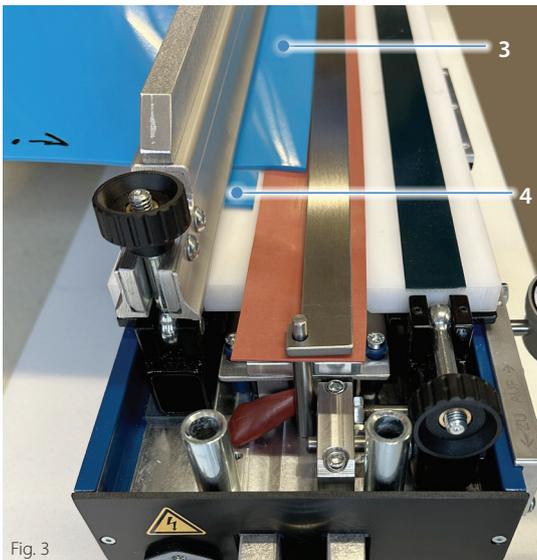
- Clean the top and bottom heating platens.
- Place the layers (except the belt material) to line the press (underside) on the bottom part of the heating press.  
Press layout >> see splice data sheet
- Clean the adjustment aid (1) and put it onto the centering bolts (2). (Fig. 2)



- Clean the first end of the belt (3) and center it over the width of the press. Affix it with the belt holder.

**Caution:** Shim the belt holder up to the edge of the press with belt material (4) if the belt is much narrower than the nominal width of the press. (Fig. 3)

- Now press the end of the belt against the edge of the adjustment aid. Make sure that the usable area of the heating width is not exceeded.
- Use the belt holder to affix the end of the belt.
- Remove the adjustment aid.



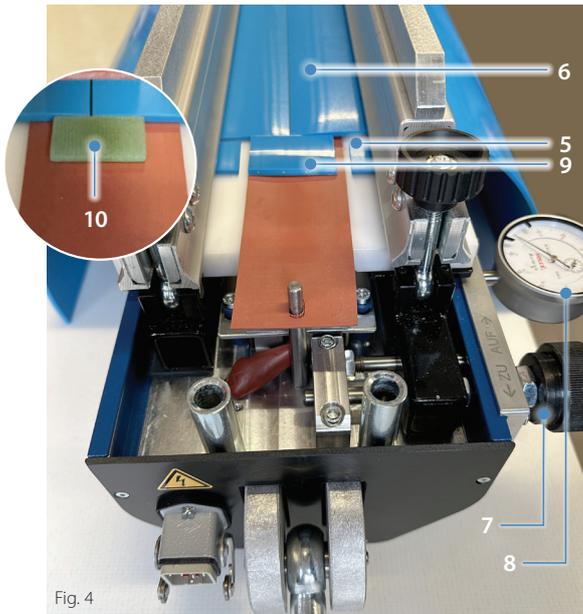


Fig. 4

- Clean the second end of the belt, place it flush with the first end of the belt and affix it with the second belt holder.  
**Caution:** Shim the second belt holder to the edge of the press with belt-  
 ing material (5) if the belt is much narrower than the nominal width of the  
 press. (Fig. 4)
- Press the second end of the belt (6) so that it touches the first end of the  
 belt and affix it. (Fig. 4)  
**Please note:** There must be no gap in the area where the two belts  
 touch each other. Use the infeed unit to close any gaps.
- Turn the belt set screw (7) to create even impact pressure until the two  
 ends of the belt touching one another lift up slightly. Turn both belt set  
 screws by the same value towards Closed. The dial gauge (8) shows the  
 value. (Fig. 4)
- Then clean the surface of the splice and line the whole area of the press  
 where heating takes place with extra material (9): Use the optional lami-  
 nated fabric shims (10) if the splice uses the whole nominal width of the  
 press. (Fig. 4)  
**Caution:** The extra material (9) must not be clamped by the belt holders  
 because the infeed unit will otherwise be blocked. (Fig. 4)

#### 4 Press layout top

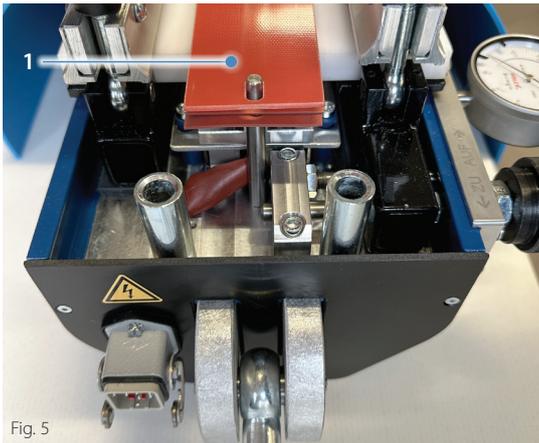


Fig. 5

- Place the layers required to line the press (top face) (1) onto the splice.  
 (Fig. 5)  
 Press layout >> see splice data sheet

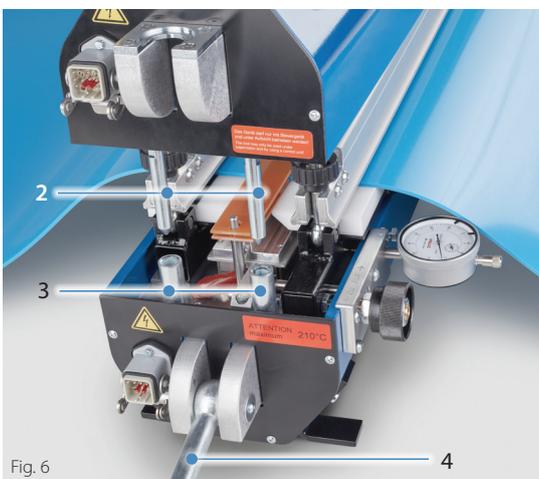


Fig. 6

- Place the top half of the press with the help of the centering bolts (2) into  
 the center hole (3) on the bottom part of the press. (Fig. 6)
- Tighten the eye bolts (4) and collar nuts by hand to join the top and  
 bottom part of the press with each other (no tools required). (Fig. 6)  
**Please note:** Ensure uniform contact pressure by alternately tightening  
 the clamping screws.

