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Tech Note

Technical Notes from the Technical Committee, NIBA – The Belting Association

#18 Arrangement of Edges when Belts to be Spliced Together are Cut from Wider Slabs

Belts that are slit from wider manufactured slabs may exhibit a systematic tracking characteristic of running to one side of the conveyor. Such condition is usually easily accommodated by normal training procedures. However, when two or more lengths of belts slit from wider slabs are spliced together to form longer belts, this systematic tracking phenomena may present a problem: the lengths of belts may track off to alternate sides, making training for a single condition impossible, and perhaps preventing effective training of the resulting belt.

The resolution to this problem is to have some of the rolls of slit-to-width belting rerolled so that when spliced together all original slab edges are on one side and all inside cut edges are on the other side.

Some belt manufacturers have programs specifically directed to this issue, while others endorse it but do not cover it in their literature. The condition can be attributed to several sources including:

- non-uniform belt thickness
- differential cooling in the original slab after curing in the factory
- moisture absorption in the edges while in storage (either at the manufacturer or the distributor)
- other that are less obvious, i.e., poor slitting and handling practices.

It is not to be implied that the condition described herein always exists. It may or may not. The belt manufacturer's instructions and/or the experience of the distributor should dictate any action to be taken. This information generally applies only to heavy conveyor belts, since only they (and not lightweight belts) are commonly spliced into longer lengths. If the condition is experienced on a continuing basis, it is the responsibility of the belt manufacturer and distributor involved to work together to resolve it.