

TURBOCHEF TECHNOLOGIES, INC.

# Conveyor Belt Splicing for the HhC 2020

There are two accepted methods to use when repairing a conveyor belt:

1. Replace a strand using a single loop edge (instructions below)
2. Create and install splice clips (instructions begin on page 3)

**⚠ IMPORTANT:** If a belt has damage in more than one place on account of fatigue, do not try to repair it. Install a new belt. Also, never save old belts to use for repairs because they have already been weakened from use. Use the new belt provided with this service kit for all repairs.

## Replacing a Strand using a Single Loop Edge

**⚠ CAUTION:** Ensure that the oven has finished cooling down, and then remove power from the oven.

Tools Required: Pliers

Step 1: Begin splicing in the center

1. Move the two ends of the belt to be spliced to the discharge end of the conveyor unit.
2. Confirm that the edge loops are curving back away from the direction of belt travel (as shown in Figure 1). If not, check to be sure that the belt is not threaded backwards on the conveyor.
3. Lay the strand down between the two belt edges and check to see that the edge loops are going in the same direction as the belt's edge loops. (The strand must also be "right side up" for it to lay flat. You will know immediately if you have installed the splice strand "wrong side up" and will have to start over.)
4. To hold the belt steady, use ties to connect the two belt edges (as shown in Figure 1, spaces A and E).
4. Bend the strand from each side enough to insert the ends into the two spaces next to the center space (Spaces B and D in Figure 1).
5. Insert the strand ends into the center space of the opposite edge (Space 3 in Figure 2).
6. Pull the ends of the strand through until the center space "locks" in place (You should be pulling the strands toward you).
7. Use pliers to straighten the wire in the center space (Once the center is connected, you may remove the ties holding the belt edges together).

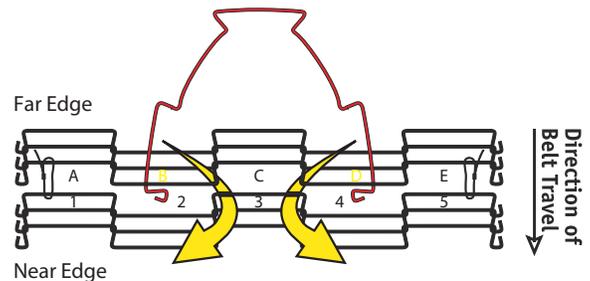


Figure 1

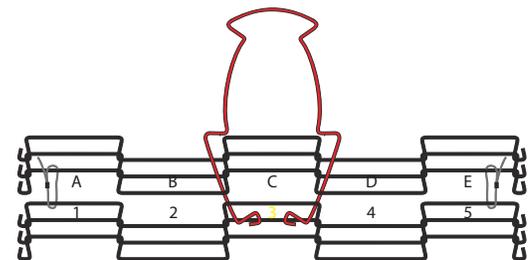


Figure 2

- INSTRUCTIONS CONTINUED ON NEXT PAGE -

## Step 2: Weave strand to one side

1. Bend one end of the wire up and insert it around the Z-bend in the next space on the edge of the wire closest to you (Space 5 on Figure 3). Always try to avoid bending the wire at the Z-bend!
2. Bend the wire toward the center and insert around the Z-bend next to the center space (Space D on Figure 4).
3. Pull the strand wire through the mesh and straighten it with your pliers.
4. Repeat these three moves until you reach the side edge of the belt.
5. Using your pliers, connect the strand's edge loop to the belt's edge loop (on the far edge).
6. Connect the edge loop on the near edge of the belt to the strand's edge loop.
7. Straighten the strand with your pliers.

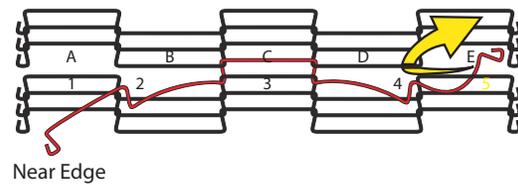


Figure 3

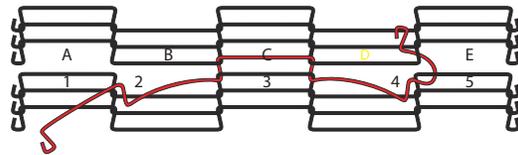


Figure 4

# Creating Splice Clips

**⚠ CAUTION:** Ensure that the oven has finished cooling down, and then remove power from the oven.

Tools Required: 2 Sets of Pliers, Wire Cutters

## Step 1: Make Splice Clips

1. Refer to the adjacent chart to determine the number and types of clips you will need for your belt. Follow steps 1 - 5 below to make the clips.

# of Belt Spaces	Single Clips	Single + 3-Space Clips
3	2	0 + 1
5	3	1 + 1
7	4	0 + 2

NOTE: Splice clips come in two varieties: 1-space and 3-space clips. The 3-space clip is stronger because its center space is woven into the belt as in the full strand splice method. These two types of clips should be used together, whenever possible to create a stronger splice and to help minimize the spacing gaps in the belt.

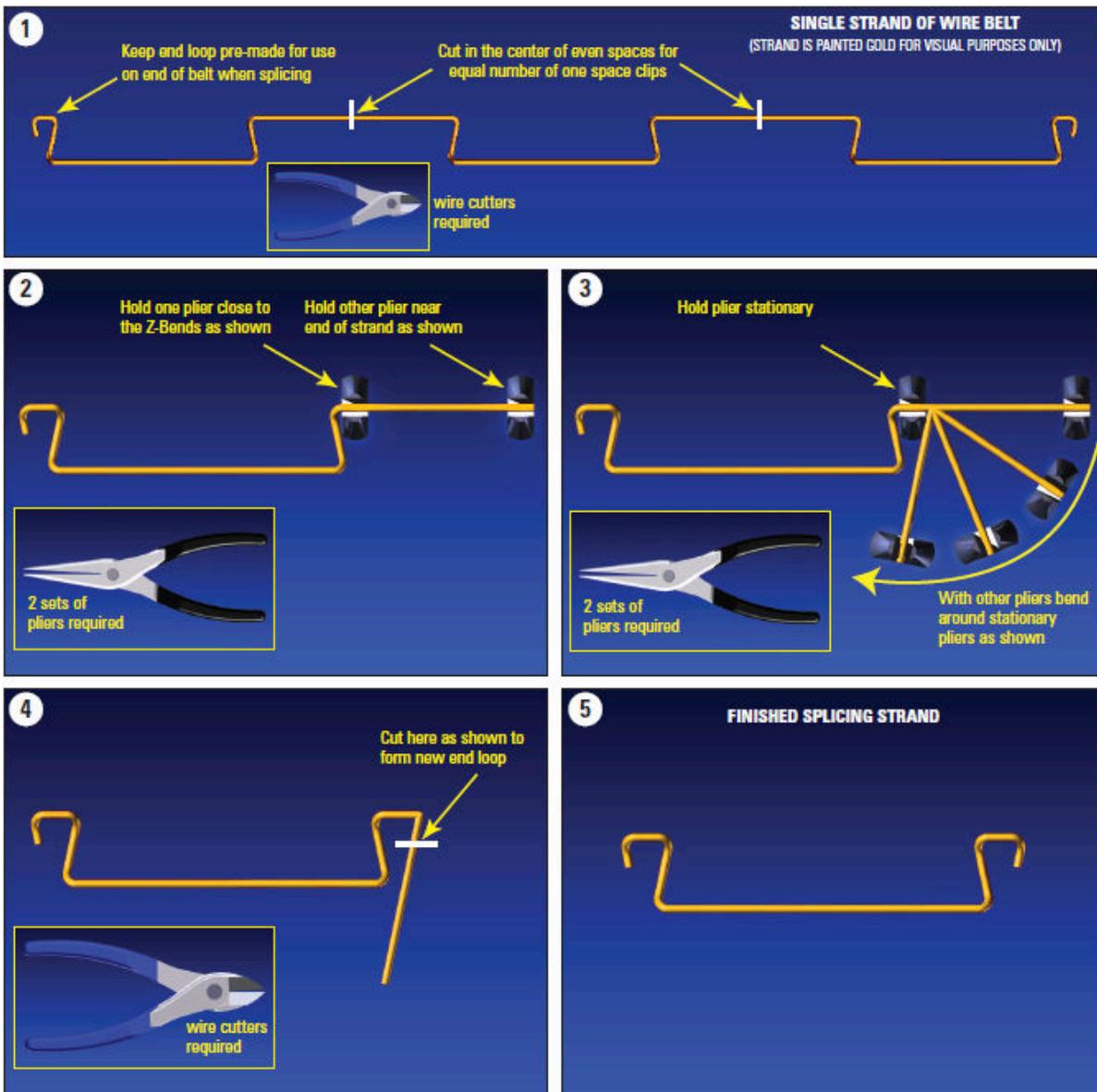


Figure 5

# Installing Splice Clips

NOTE: Two different end loops from adjacent clips cannot be attached to the same Z-bend. Only one splice clip end loop per Z-bend is allowed.

## Step 1: Remove belt

1. Move the two ends of the belt to be spliced to the discharge end of the conveyor unit.

## Step 2: Install clips

To install single clips:

1. Use needle nose pliers to grip the splice clip, and hook the two ends around the Z-bends on either side of the center space (see Figure 6)
2. Repeat above step to install remaining splice clips.
3. Straighten the wires with pliers.

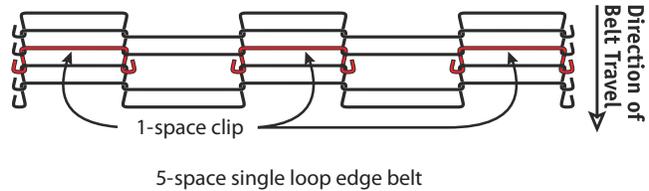


Figure 6

To install 3-space clips:

1. Bend the clip in the center and insert the two ends into the two spaces next to the center space (spaces A and C on Figure 7).
2. Insert the ends into the center space of the opposite edge and pull through until the center "locks" into place.
3. Use needle nose pliers to grip the end loop, bend the wire up and hook it around the Z-bend on the opposite edge of the belt. Repeat for other end loop.
4. Repeat the steps above to install the remaining splice clip.
5. Straighten the wires with pliers.

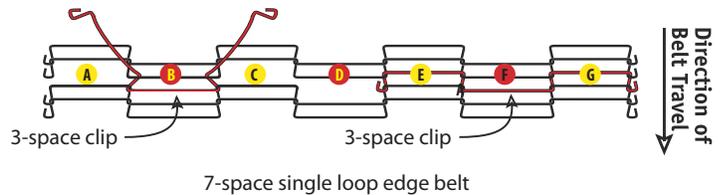


Figure 7