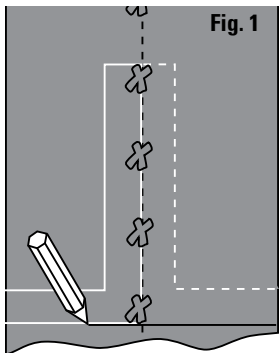
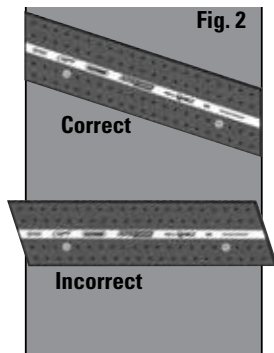


Installation Instructions

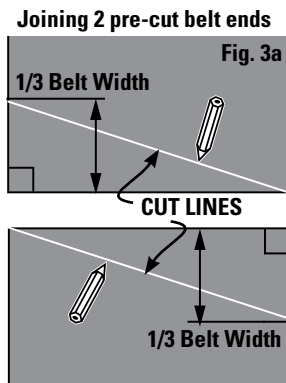
The following instructions are for Super-Screw® Evolution installation. This splice will be installed on an 18° bias.



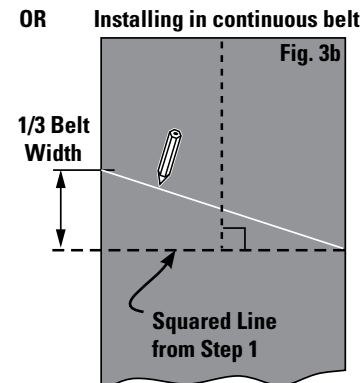
1. Square belt using centerline method and mark a perpendicular line across the belt. OR if installing on a pre-cut belt, ensure both ends are square.



2. Lay the splice face up on the belt to visualize the bias. This will help determine where to draw the bias and cut the belt. The face of the splice has circular indents in the rubber where the screws will be installed. Super-Screw Evolution splices are pre-cut for the bias to go in only one direction.

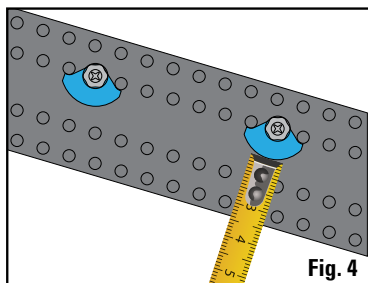


3a. To create the bias cut lines for pre-cut belt ends, measure up from the end of the belt 1/3 the width of the belt (4" for every 12" of belt width) and down the same distance on the opposite end of the belt so the ends will mate. Ensure the orientation of the lines is correct for the orientation of the splice (Fig. 3a) Draw the bias lines.

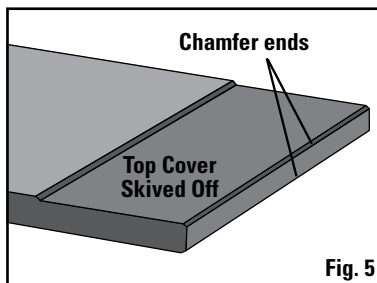


3b. If NOT installing on pre-cut belt ends, only ONE cut line is needed. Measure off one end of the squared line from Step 1, OR measure up and down off both ends of the squared line so the total drop distance is equal to 1/3 of the belt width. Draw ONE bias cut line (Fig. 3b).

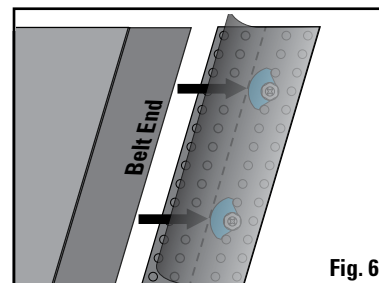
Cut the bias line(s) using a Flexco Belt Cutter or equivalent safe cutting method.



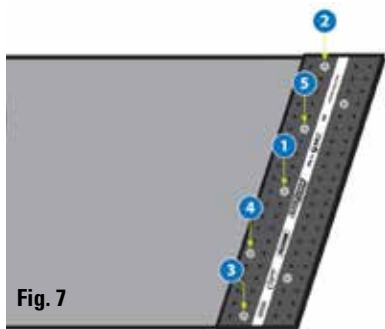
4. Using Table A on the back, or measuring from the spacer perpendicular to the edge of the strip, determine the distance to skive on each end of the belt. The measurement will be equal on both ends of the belt. Measure the top cover of the belt and skive to the appropriate depth. Do not cut into the plies of the belt.



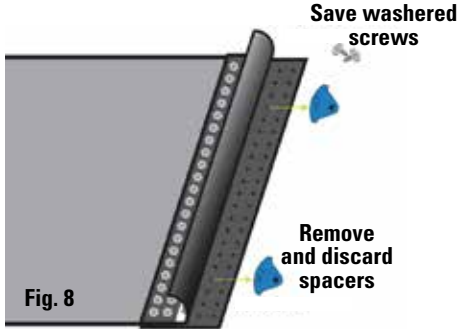
5. Slightly chamfer or bevel the top and bottom edge of both ends of the belt.



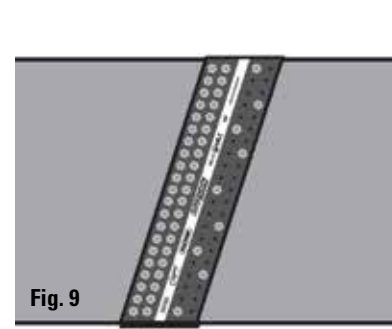
6. Centering the fastener strip on the belt, slide one side of strip onto belt end and ensure belt is firm against all of the pre-inserted spacers.



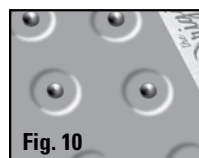
7. Using a heavy duty (18-volt or greater) drill and the PZ bit provided, install one screw in the center of the strip in the row closest to the spacers. Next, install one screw in each end of the splice. Then move to the middle and alternate screw installation from side to side and row to row. Avoid installing the screws one after another along a single row, as this may cause the top and bottom portions of the splice to misalign.



8. IMPORTANT: Remove spacers from the splice and discard, saving the screws. These can be used as spares if needed in the installation process.



9. Center and insert the other belt end into the splice so the two ends of the belt are in firm contact with each other. DO NOT leave a gap between the belt ends. Repeat the alternating screw pattern from Step 8 on this side of the strip.



10. When complete, check the bottom of the Super-Screw splice to ensure the screws have fully engaged the nuts. The screw tips on the bottom will have a recessed ring around them in the rubber when the nuts are properly engaged (Fig. 10).



Installation Instructions – Best Practices

Only install Super-Screw® on a completely flat surface.

Always install Super-Screw on the recommended bias.

Skiving and Screw Length – what do I need to know?

The skive distance from belt end depends on the series. Skive the appropriate distance (Table A) on each end of the belt.

A correct skive impacts screw selection and the ease of installation. Select screw length(s) based on belt thickness after the skive (Table B). We recommend you have a variety of screw lengths available for installation and for unintended skive variations. If you find your screw length is too long and is visible on the bottom of the splice by more than 1/8", you may grind it off or use a shorter length screw.

Table A

Super-Screw Series	35	63/65	80
Skive distance from belt edge (in)	1-3/8	2-5/16	3-3/16
Skive distance from belt edge (mm)	37	59	80

Table B

Thickness	SSE 35-63	SSE 65-80	SSE 85-100
3-4 mm	5 x 10	5 x 12	–
5-6 mm	5 x 12	5 x 14	5 x 16
7-8 mm	5 x 14	5 x 16	5 x 18
9-10 mm	5 x 16	5 x 18	5 x 20
11-12 mm	5 x 18	5 x 20	5 x 22
13-14 mm	Trim down	Trim down	5 x 24



How tight do I set the screws? Tight enough so that there is a small belt pucker around the washer. No over-torque; no under-torque.

How do I know if my screws are properly seated in the nuts? You can be sure every single screw is seated into the nut with visual inspection (see step 11) and by running your hand across the splice. A screw that is raised up is not properly seated. Also, if a screw continues to spin during installation it means the screw has not engaged with the nut in the bottom splice strip. As you continue to install screws, you will start to gauge how a properly seated screw feels to help with the process.

Super-Screw® Evolution Instruction Sheet

Fastener Part No. _____

Screw Size _____ mm Qty _____

Hot MSHA Stainless Steel (SS)

Sliding Bed/Bareback Mod Oil-Resistant (MOR) Abrasion Resistant (AR)



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