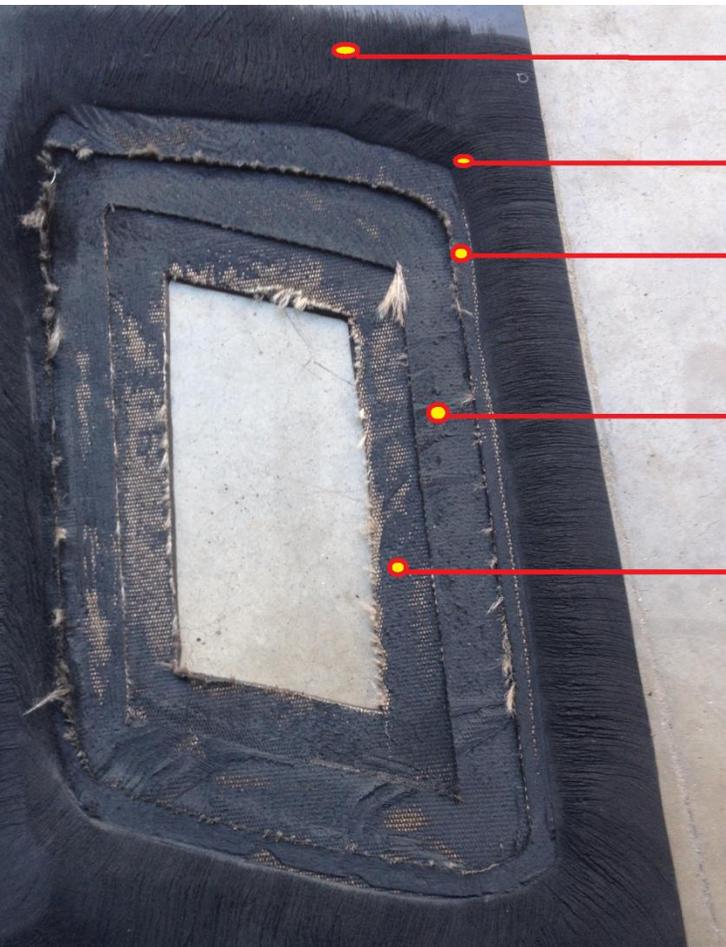




## BELT PREP:

This repair is being done on a ¼" top cover, 3-Ply Rubber Belt. The hole is 3" Width by 6" Length. You will see that the prepped area is roughly 4" outside the hole. This is to allow for maximum adhesion of Fourthane, and reduce the compression while the belt travels around the pulleys of the conveyor. This is the suggested standardized repair this type of belt damage.

1. Prepped area: the top cover should be buffed using low speeds to avoid burning the rubber. The area should be a minimum 2" outside the stepped down areas (shown in image to the left)
2. First Ply Step: step down the top cover using the standard 45 degree bevel cut, and removing only the top cover down to the first ply. Be sure to NOT cut the plies when removing the top cover. **Be sure to leave ½"+ width for adhesion.**
3. Second Ply Step: step down the first ply by carefully cutting and peeling the first ply layer. Note that there is rubber between each section of plies, and using a specially designed "422" ply tool will help make this process easier. **Be sure to leave 1"+ width for adhesion.**
4. Third Ply Step: step down the second ply by carefully cutting and peeling the second ply layer. Note that there is rubber between each section of plies, and using a specially designed "422" ply tool will help make this process easier. **Be sure to leave 1"+ width for adhesion.**
5. Finish by buffing each surface for a rough finish, ideal for adhesion.



2" Prepped Area

30-45 degree Bevel

First Ply Stepped Area

Second Ply Stepped Area

Third Ply Stepped Area



## FOURTHANE Installation:

1. Clean the prepped area with the Solvent (#1 Bottle) as usual. Solvent will flash and dry within 2 minutes. Do not apply Primer until surface is dry.
2. Apply the Primer (#2 bottle) to the entire prepped area. Do not add breaker fabric or Fourthane polymer until dry.
3. If needed, add backing or duct tape to return side of belt to prevent Fourthane polymer from running through. Fourthane will set in 3-5 minutes to solid state.
4. Apply the mesh breaker fabric to the first and second stepped areas before adding the Fourthane Polymer
5. Add Fourthane Polymer and let set until cured (approximately 1 hour)
6. Buff areas of Fourthane to remove high spots and picking points. Use sanding discs for best results.

NOTE: Using mesh breaker fabric will increase strength of repair and reduce stress at critical compression (bending) points. (See images of flexibility below)

