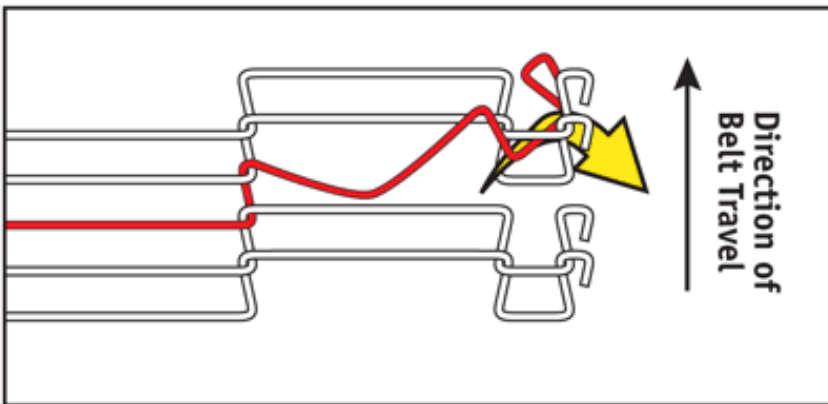


# Flat-Flex® double loop edge (DLE) using full strand joining method

## Tools you will need:

- Safety glasses
- Flat end pliers
- Needle nose pliers
- Cable ties/soft wire/string (optional)
- Cutting pliers
- Wire straightener (optional)
- Necessary tools for conveyor belt take up adjuster.

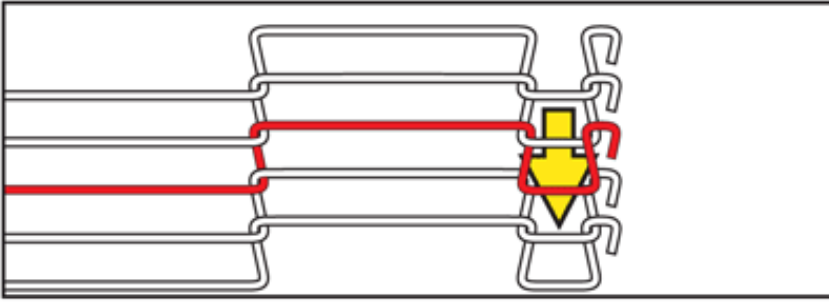
## 1 DIAGRAM A



- At the last space before the double loop edge, gently bend the joining strand in the center of the last space.
- Insert the end of the joining strand into the double loop edge (small space) on the near side. You will need to rotate the wire to feed the DLE through the space.

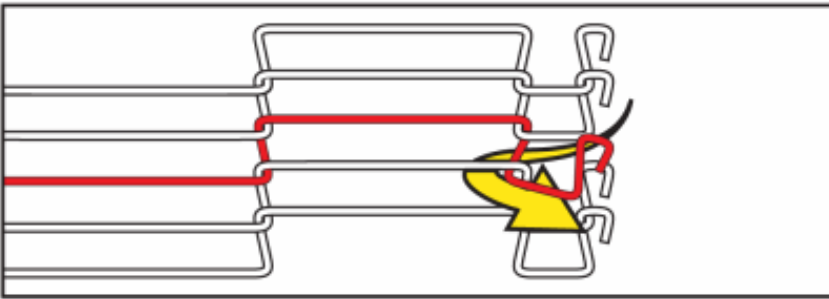
**NOTE: If you have difficulty with this process you may unhook the main belt near edge loop first and then re-connect this at the final stage of the process.**

## 2 DIAGRAM B



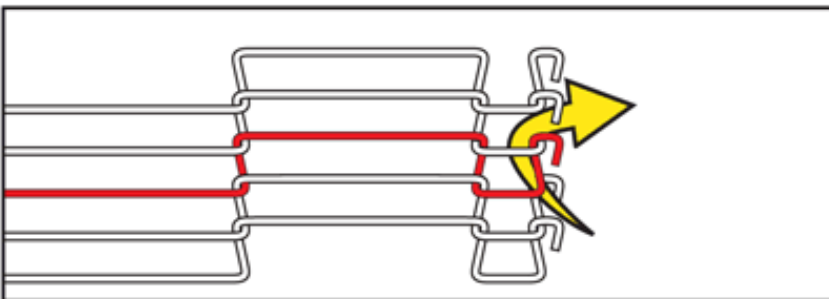
- Insert needle nose pliers from underneath, grab the center of DLE on strand and pull up into space.
- Straighten initial bend

## 3 DIAGRAM C



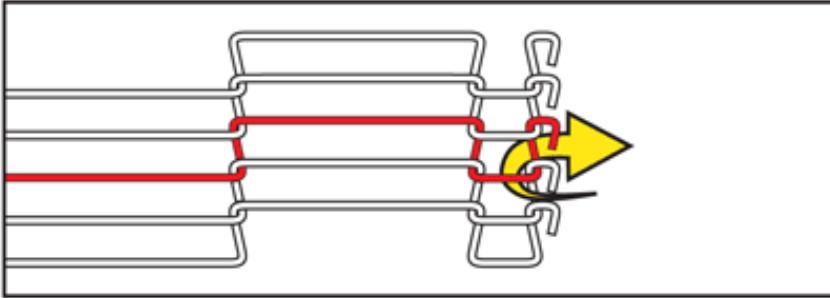
- Flex the belt by pushing down in center of last row of spaces on the near edge.
- Rotate joining strand so you can push the end up from underneath the last space on far edge.
- Hook DLE up over last large space Z-bend.
- Straighten any distortion to this connected Z-bend using needle nose pliers or the wire straightening tool.

## 4 DIAGRAM D



- Connect the splice strand edge hook to the near side loop edge using pliers hooking up under the near edge strand.

## 5 DIAGRAM E



- Connect the far side loop edge by hooking it into the splice strand using pliers.
- Connect the opposite edge of the belt in the same manner, only in mirror image.
- Straighten any bends in wire strands.

### IMPORTANT NOTES:

- Avoid permanent deformation of the 'Z' form links when joining. To assist it may be necessary to place a bend in the wire space adjacent to the space being woven; however you must ensure that this wire bend is straightened before continuing the joining operation. Re-straightening of wires at this stage or at the end of joining can be achieved using the flat end or needle nose pliers or wire straightener.
- Avoid any bending of the join strand wire in the vertical plane. Any necessary bending of the wire strand should take place in the horizontal plane.