

Joining Flat-Flex® XT® belts with clips:

If joining Flat-Flex® XT® belts with 1-space joining clips only, use a 1-space clip per every XT space across the width of your belt. We do however recommend the use of 1-space and 3-space joining clips when applicable (See chart below).

The use of 1-space and 3-space joining clips together will make a stronger belt joint and minimize the number of gaps in the belt versus using 1-space clips only.

Number of joining clips required - if using 1-space and 3-space clips together:

Number of XT spaces in your belt:	1-space clips required:		3-space clips required:
3	1	+	1
4	0		2
5	1	+	2
6	0		3
7	1	+	3
8	0		4
9	1	+	4
10	0		5
11	1	+	5
12	0		6
13	1	+	6
14	0		7
15	1	+	7
16	0		8
17	1	+	8
18	0		9
19	1	+	9
20	0		10
21	1	+	10
22	0		11
23	1	+	11
24	0		12
25	1	+	12
26	0		13
27	1	+	13

Important Notes:

- 1-space clips are inserted into the XT (smaller) spaces only.
- Each 3-space clip is composed of two XT spaces and one wide space.
- A gap should appear in a wide space between each clip. A clip should be positioned in every XT space of the belt in order to engage with the drive sprockets.
- Always avoid bending clips at the Z-bend. Bend at the center of the clip's straight wire for optimal use.

Before you begin joining with clips:

- Plan out the number, type, and placement of splice clips by laying them in position across the belt.
- Ties can be used to hold belt ends together if needed.
- Make certain that no two end loops on the splice clip hook around the same Z-bend.
- All splice clip end loops should point in the same direction of the belt end loops, away from the direction of travel.

Begin installation at the center of the belt:

Using a 1-space clips only:

- Insert one end loop up and through the belt to connect. Use needle nose pliers to grip and hook the opposite end loop around the Z-bend joint to complete the splice.

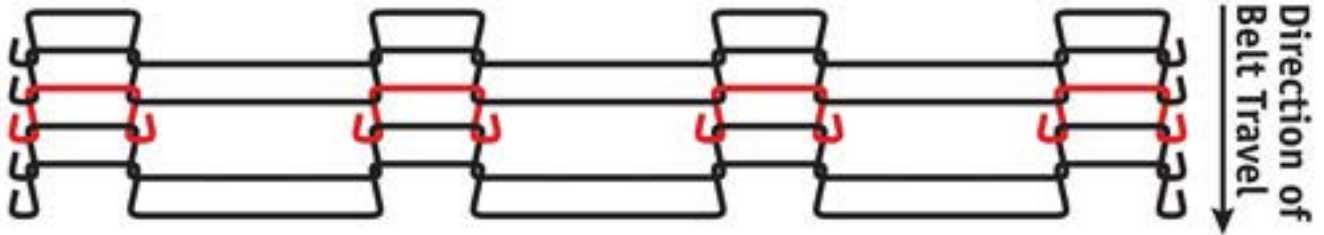
Using a 1-space and 3-space clips together:

- Bend 1 XT space in the center, opposite direction of travel.
- Insert the opposite XT space up and through the belt and use needle nose pliers to "lock" the space into place.
- Use needle nose pliers to grip and hook the bent XT space and weave through to complete splice.
- Straighten the wire with pliers or Wire Belt's straightening tool.

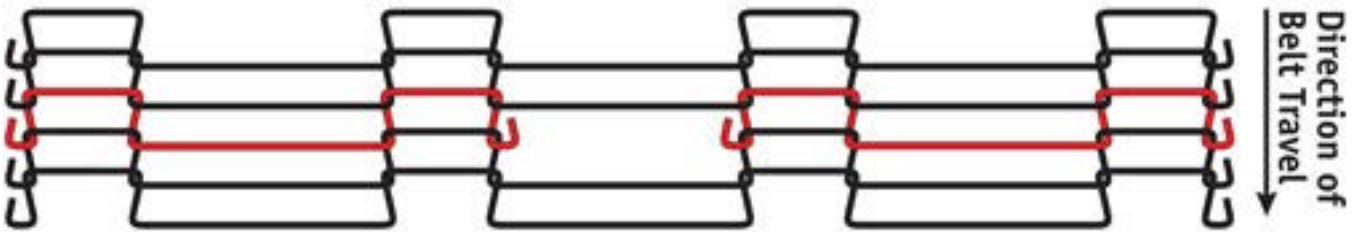
Install remaining splice clips:

- Continue splicing the remaining clips. There should be the same number and type of splice clips on each side of the center space.

7-space belt spliced with single space clips



7-space belt spliced with 3-space clips



9-space belt spliced with a combination of 1 and 3-space clips

