



sempertrans® 
A MEMBER OF THE SEMPERIT-GROUP

SPlicing OF STEEL CORD BELTS

SEMPERTRANS SEMPERCORD RANGE
1 TO 4 STEP CONSTRUCTION

YOUR GUIDELINE



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This guideline has been carefully prepared to advise our customers and partners. The information contained herein is intended for general use only. While every effort has been made to ensure the accuracy and completeness of this guideline, the advice herein may not apply in every circumstance and data is subject to change at any time. Accordingly, no liability is accepted for mistakes or printing errors, or for incorrect use or application of this guideline. Our Sempertrans experts will be happy to answer any questions you might have.



1 Introduction

This General Splicing Instruction (GSI) covers all relevant topics for the successful hot vulcanisation of Sempertrans Sempercord Steel Cord reinforced conveyor belts. Conforming to this procedure will ensure successful splicing. We cannot be held responsible for any splices that are not completed according to this procedure. Any dimensions quoted are based on meeting appropriate DIN standards. Splicing belts with hot curing produces splices with high technical and maintenance parameters.

2 Health & Safety

The following points should always be considered when performing a hot vulcanised splice on any conveyor belt.

- Ensure that any conveyor system being worked on is properly isolated.
- Consider other activities that are taking place in and around the area or other conveyor systems that are a part of the conveyor stream.
- Make sure all stored energy has been properly removed and appropriate rigging equipment utilised.
- Most sites require a site induction that will familiarise all workers with the operation they will be working on. In the absence of this, any technician or teams of technicians should familiarise themselves with the site so they know where to go for any activity on-site.
- Ensure the splice station is well set up so that people can move safely and freely around the area. Consider how power and utilities will be provided to the area safely.
- All electrical and mechanical equipment must conform to local applicable regulations and be fit for purpose. Use of such equipment must be in accordance with the OEM's operating instructions.
- Solutions are a necessary part of hot vulcanised splicing. Ensure that:
 - o the work area is well ventilated.
 - o all solutions are handled and used according to the instructions specified on either the labels or the safety data sheet. They should not be swallowed or inhaled and where necessary, appropriate personal protective equipment should be worn.
 - o any spill is reported and cleaned up appropriately.
 - o all empty tins are disposed of according to regulations.
 - o open flames are avoided, and there is a no-smoking rule in and around the splice station area.
- Numerous knives and cutting tools are used in the splicing process. It is expected that only people familiar with the safe use of such tools and equipment will be entrusted to use them. Remember, a blunt knife can often be a dangerous knife due to the extra effort required in using it. Keeping cutting blade sharp minimises this.
- Use correct lifting techniques whenever required. While manual handling is often the best method, do it correctly. If possible find mechanical ways to move and lift equipment.

3 Tools & Equipment

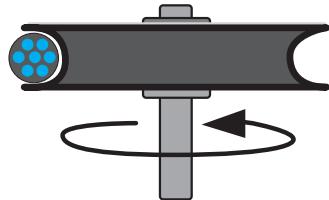
The following list shows the recommended tools and equipment needed to successfully complete a hot vulcanised splice on a steel cord belt. This is not an exhaustive list, as tools can slightly vary in style and name from country to country.

3.1 Hand Tools

- Hand winch / tirfor TU16 or TU32
- Curved knife (utility knife)
- Flat straight or offset knife (for trimming rubber)
- Fork or vee knife (for trimming excess skive or edge rubber)
- Stanley knife and replacement blades
- Awl (long pointed spike)
- Pincers/pliers (for stripping)
- Rubber hammer
- Chalk line
- Tape measure
- Stripping tongs/jaws (for attachment to winch/tirfor when stripping)
- Wide (40mm) flat wheel roller (for smoothing out skim/tiegum rubber)
- Narrow (4mm and 12mm) non-toothed wheel roller (for stitching tight and narrow areas of skim/tiegum)
- Wide (40mm) spiked roller
- Soft bristle hand brush (for brushing away dust and crumb rubber)
- Wire hand brush or scratcher (used at times when no electric brushing wheel is available)
- Tailor's scissors (large)
- Whetstone (for sharpening knives)
- Round bristle brush or flat (50mm) paintbrush (for application of solution)
- Steel 50mm x 10mm angle bar for marking and cutting (DO NOT USE ALUMINIUM)
- Set square 500x500mm

3.2 Portable Electric Tools

- Variable-speed rotary buffing machine
 - Stripping winch
 - U-Shape Grinding Wheels
- Electric drill
- Wire brush and adapter for electric drill
- Copper carbide sanding disc
- Coarse-grained sanding disc
- Fine-grained sanding disc



3.3 Tensioning Equipment

- 2 sets of belt clamps and 4 chain restraints (come along) suitably rated
- Hand winch / tirfor tu16 or tu32
- Small sling
- Large sling

3.4 Vulcanising Equipment

- Complete vulcanising press:
 - Heated area suitable for required splice length (bias or square) plus overhang
 - Heated area suitable for belt width plus edge bars
 - A means for constant, controlled and uniformed temperature
 - Ability to measure and deliver uniformed pressure
 - Fitted with restraining bars for safe operation
- 1 set of edge bars / irons to suit belt thickness of less than 1mm
- 2 tightening chains to secure/restrain edge bars of the vulcanising equipment
- 1 set of mould plates if multiple elements are being used
- Means to measure and check temperature separately
- Means to measure and check pressure separately

3.5 Miscellaneous Items

- Personal protective equipment required. Minimum: safety boots, goggles, gloves, hard-hat and face masks
 - Clean cloths/rags
-

4 Summary of Splice Materials

4.1 Form of Splice Materials

Splice materials for a Steel Cord belt will be supplied in kit form. The general components of a splice kit are as below. For the specific contents and dimensions of the splice kit a TDS-MFS should be requested from Sempertrans Sales or Customer Service.:

- Cover plates / panels (Top & Bottom) in roll form suitable to the cover grade of the belt. Note for thicker covers the panels can be supplied in two parts which are then laminated together to give the appropriate cover thickness.
- Core sheet in roll form suitable to the class of the belt:
- Interline strips / noodles in disc-roll form suitable to the class of belt
- Rubber Solution suitable to the class of the belt
- Fabric / silicon paper

4.2 Quantities of Materials in a Kit

This is determined by the width and specification of the belt. Any kit supplied by Sempertrans will be supplied with a positive tolerance and contain sufficient materials to complete one splice. For large projects, bulk materials can be considered. The specific dimensions of the belt splice are covered in section 6.0.

4.3 Splice Materials Identification

The materials are individually labelled and each component should be checked and verified prior to use. Any solutions can be identified by the label on the container. Material designation, thickness and shelf-life are clearly marked on each label.

4.4 Handling and Storage of Vulcanising Materials

The recommend expiry date for our uncured rubber products is shown on the stickers on the boxes with splicing kits. These are consistent with the Sempertrans recommended storage and handling procedure QP C TG 5318. It prescribes storage conditions that are out of direct sunlight / UV light, away from ozone-generating electrical items / motors, free from moisture, dust, grease and ideally in a closed or ventilated room kept at an ambient temperature of 20°C +/-5°C (or 68°F +/-9°F) and relative humidity of 40-70%. Additionally we also recommend that materials are kept in the packaging they were supplied in as this acts as another layer of protection.

If properly controlled and continued cold storage of uncured rubber materials can be maintained at +10°C +/-4°C (+50°F +/-7°F), then it is possible to double this shelf-life. We do not recommend freezing them.

5 Considerations for the Splice Station

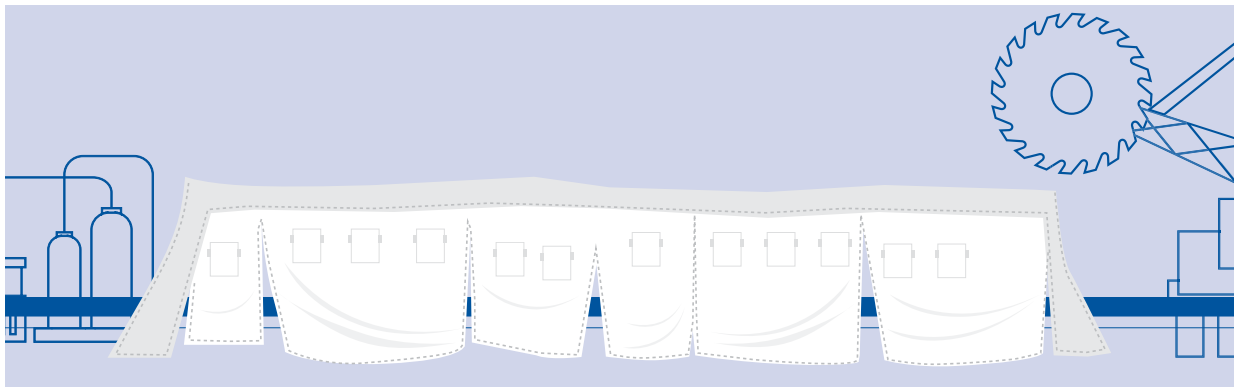
5.1 Cleanliness of Work

Cleanliness in the execution of splices largely determines the success of this work. 'Cleanliness' means the protection of belting, raw materials and tools against all types of dirt and pollution, i.e. against contact with any solid, liquid or gas liable to attack the rubber or the carcass and thus interfere with the proper bonding of the splice constituents during vulcanisation.

The only materials that will not have a damaging effect when brought into direct contact with the rubber or carcass are the following:

- Clean polyethylene sheeting – very useful for protecting work surfaces
- Clean, non-finished splice
- Non-oxidized or non-surface-treated metals

The length of the splice station should be at least three times the length of the splice. The entire working area then needs to be covered and sealed to protect the splice against wet weather and sun when working outside, and against dust in any location. The best method of protection is the use of a splice tent of some kind that covers the whole area so as to provide not only enough space for the splice to be prepared and built but also to house the vulcanising press and all necessary tools. In extreme temperatures the inside atmosphere of the tent will need to be controlled to prevent moisture and humidity from becoming an issue. An example of this is shown in the illustration below.



Whenever work is in progress, no cleaning, welding or other similar operations should be carried out near or above the splice area. Care must be taken to avoid the belt ends that are being worked on from trailing on the ground. During splicing, operatives must ensure that their hands are clean.

- ! Cleaning with solvent is only a makeshift solution as it may conceal the presence of dust. Excess solvent may impair splice resistance, so solvent use is not recommended
A brush and container should be kept solely for use with rubber solution. Empty solution cans or containers should be disposed of properly.

5.2 Construction of the Splice Station

In the splice area the working platform will ideally consist of three parts: trailing table, bottom section of the vulcanising press and leading table. As shown in the diagram below, the vulcanising press forms the central part of the splice station.

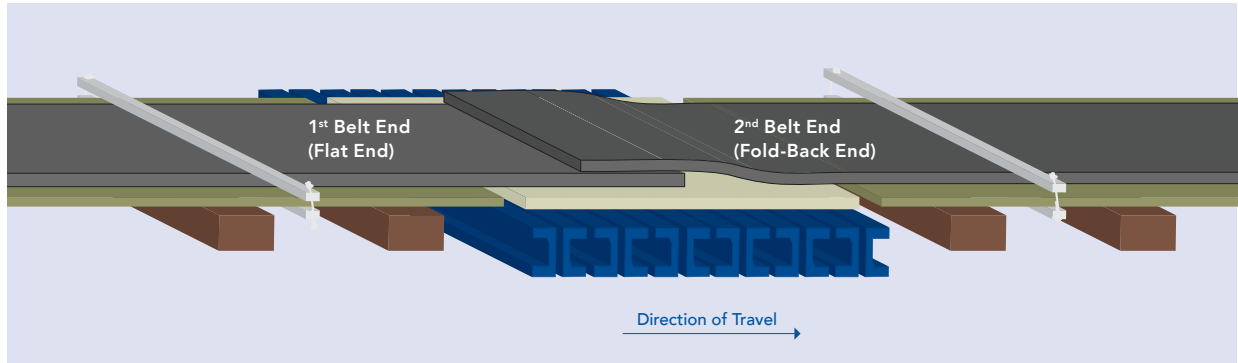



Fig. 5.2

The tables can be made from any materials and constructed in any way, as long as the table boards are level with the height of the press's bottom half. The tables on either side should be at least the length of the press itself. This will aid alignment of the splice. At either end of the splice station a clamp is needed so that once the belt ends are squared and the overlap is created, the belt ends can be aligned and fixed. The overlapping area has to be the length of the splice plus bias cut. Please note that the clamps on either end of the splice station might not be suitable as the primary means to clamp and hold the whole belt on the conveyor system. Therefore a system to fix the conveyor may have to be applied separately outside the splicing station or at another point in the conveyor system. This would be considered standard procedure when removing the tension from the belt.

6 Splicing Dimensions

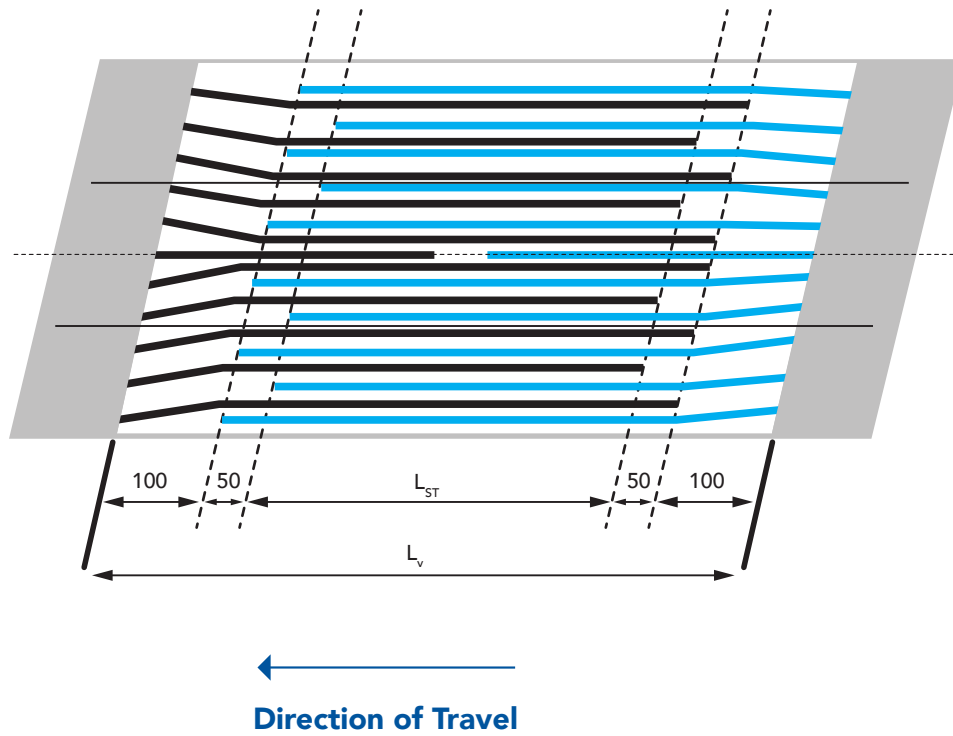
6.1 Standard splice dimensions

The table below shows the splice dimensions for belts of different strength. These values apply to Sempertrans standard belts according to DIN 22131. For splicing belts with a different construction, contact Sempertrans.

 Other dimensions for the splices and the way to lay out cables are shown in Figures 1-4. It is recommended to make the splice with a bias length of $0,4xW$ (Belt Width).

Minimum Standard Splice Dimensions			
Construction	No. of Steps	Minimum Splice Length L_v (mm)	Minimum Step Length L_{st} (mm)
ST 500	1	600	300
ST 630	1	600	300
ST 800	1	600	300
ST 1000	1	600	300
ST 1250	1	650	350
ST 1400	1	750	450
ST 1500	1	750	450
ST 1600	1	750	450
ST 1800	2	1150	400
ST 2000	2	1150	400
ST 2250	2	1350	500
ST 2500	2	1350	500
ST 3150	2	1650	650
ST 3500	3	2350	650
ST 4000	3	2650	650
ST 4500	3	2800	800
ST 5000	4	4050	900
ST 5400	4	4450	1000

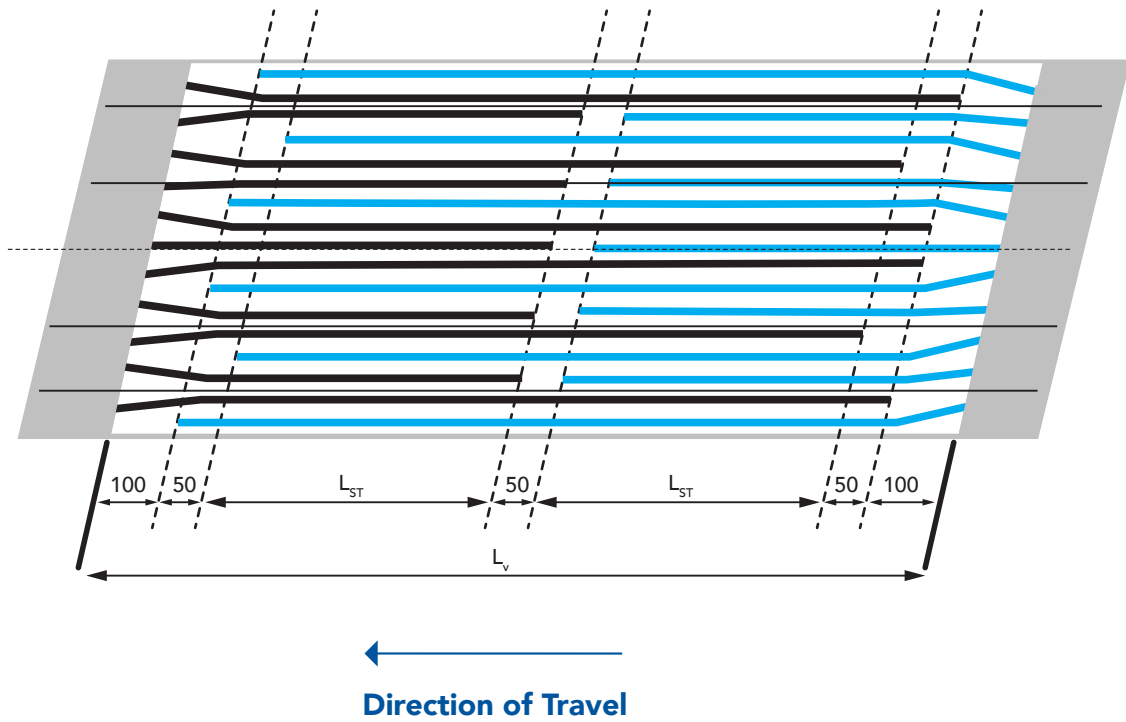
6.1.1 Diagram of cord layout for 1-Step Splice



Standard Step Lengths for 1-Step Splice

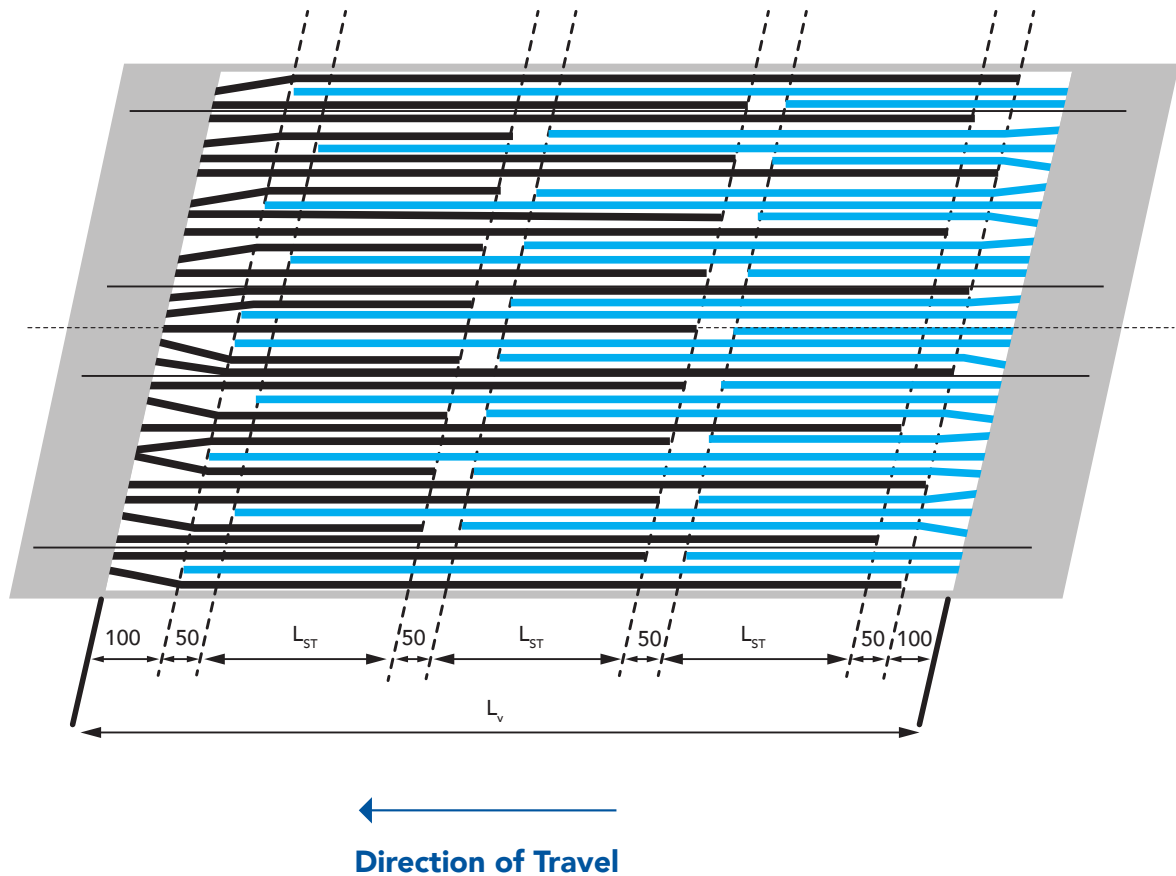
Construction	No. of Steps	Minimum Splice Length L_v (mm)	Minimum Step Length L_{st} (mm)
ST 500	1	600	300
ST 630	1	600	300
ST 800	1	600	300
ST 1000	1	600	300
ST 1250	1	650	350
ST 1400	1	750	450
ST 1500	1	750	450
ST 1600	1	750	450

6.1.2 Diagram of cord layout for 2-Step Splice



Standard Step Lengths for 2-Step Splice			
Construction	No. of Steps	Minimum Splice Length L_v (mm)	Minimum Step Length L_{st} (mm)
ST 1800	2	1150	400
ST 2000	2	1150	400
ST 2250	2	1350	500
ST 2500	2	1350	500
ST 3150	2	1650	650

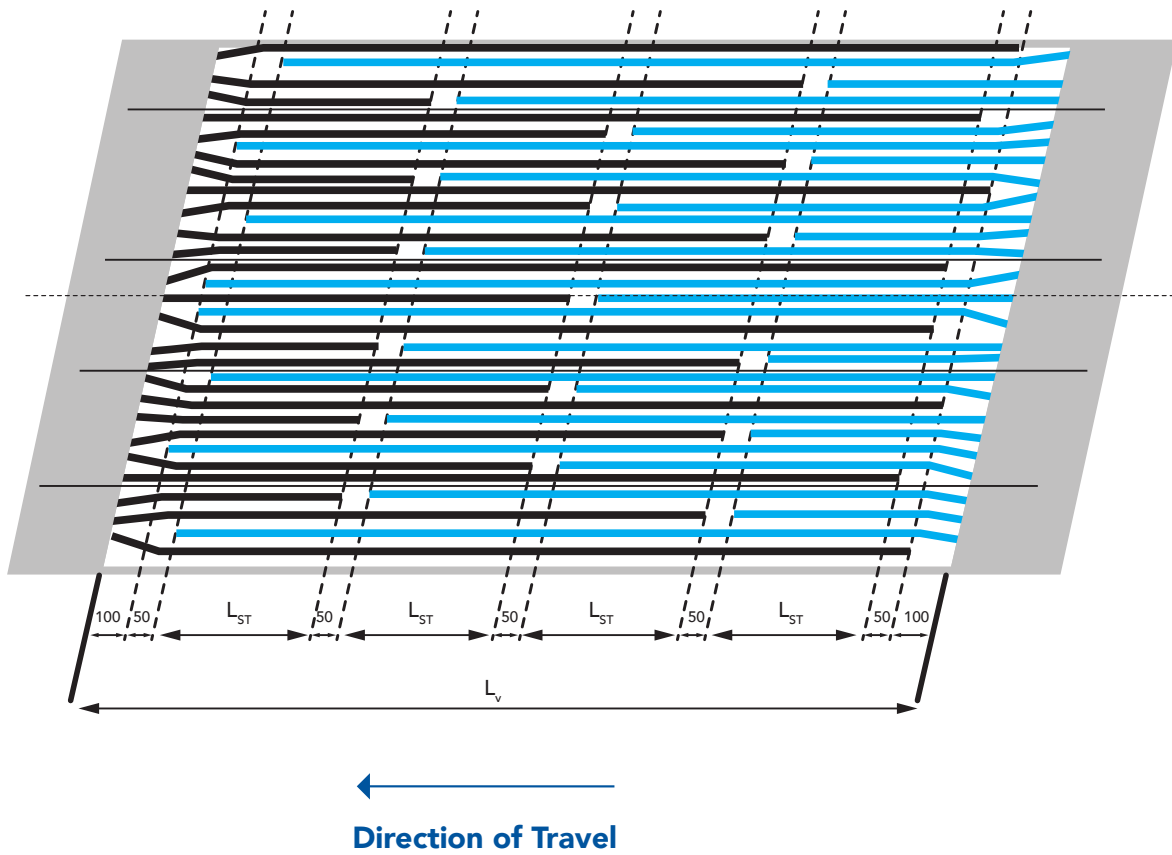
6.1.3 Diagram of cord layout for 3-Step Splice



Standard Step Lengths for 3-Step Splice

Construction	No. of Steps	Minimum Splice Length L_v (mm)	Minimum Step Length L_{st} (mm)
ST 3500	3	2350	650
ST 4000	3	2650	750
ST 4500	3	2800	800

6.1.4 Diagram of cord layout for 4-Step Splice



Standard Step Lengths for 4-Step Splice			
Construction	No. of Steps	Minimum Splice Length L_v (mm)	Minimum Step Length L_{st} (mm)
ST 5000	4	4050	900
ST 5400	4	4450	1000

7 Splicing Process

7.1 The first step is to square the belt ends, which requires creating a perpendicular line from the centre line. The easiest way to mark the centre line is to use two measures. Once three points are marked, join them together using a chalk line. If the belt is not new and the edges are damaged, do not measure from these areas. This is done to both ends. It is recommended that the centre lines outside the splice area be marked well enough to ensure they last for the whole splice process as these centre lines will be used to check the splice alignment.

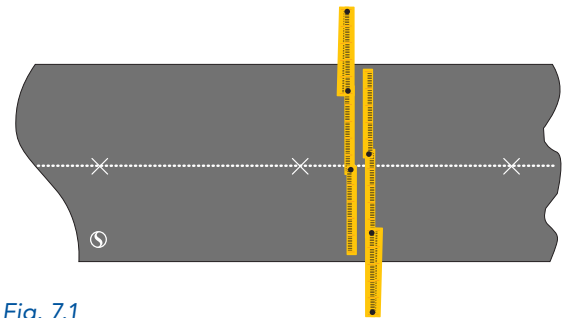


Fig. 7.1

7.2 There are two options for establishing a perpendicular line across the upper belt end.

On a narrow belt (750mm and below) the perpendicular line can be established by placing a metal set square along the centre line.

On belts above 750mm, it is recommended to use the compass method as follows:

Near the end of the belt that is to be squared off select a point A along the centre line. At equal distance from either side of point A, mark points B and C such that $AC=AB$. Then using a plumb line and pen, draw the arcs of two circles using points B and C as the centre of each circle. The radius of each circle should be long enough to cross the centre line beyond point A and short enough to stay on the belt as shown in fig. 7.2. The intersection points of these two arcs are labelled D and E.

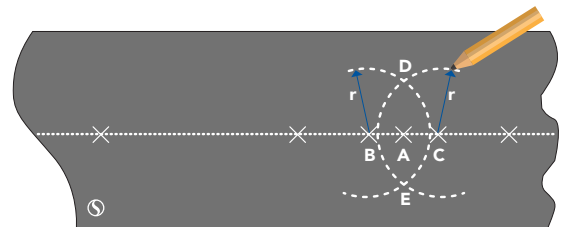


Fig. 7.2

7.3 A line drawn between points D and E will be at 90° to the centre line as shown in fig. 7.3. Once this line is extended across the full width of the belt, it will be used as the reference for future cutting and stripping the belt ends.

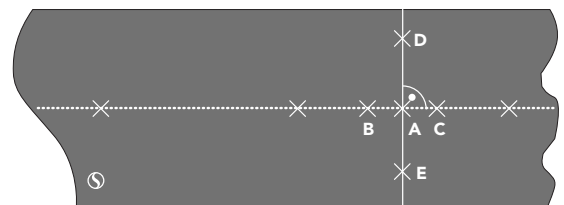


Fig. 7.3

7.4 Sempertrans recommends doing the splice on a 22° Bias. All cover and ply 'cut' lines should therefore follow a 22° bias angle.



22° bias angle equals $0.4 \times$ belt width (as measured from the square cut end).

7.5 With each belt end now having a visible centre line, create an overlap (relevant to the length of the splice plus minimum 0.5m), on the worktable so that both centre lines are aligned with each other. These centre lines must be visible as they are referenced many times through the splice process. Their proper alignment will assure a 'straight'-tracking final product.

7.6 Fold one belt end (referred to as the fold-back end) back on itself. The fold-back end will be the leading belt end if the splice is constructed along the carrying side of the conveyor. Refer to fig. 7.6 below.

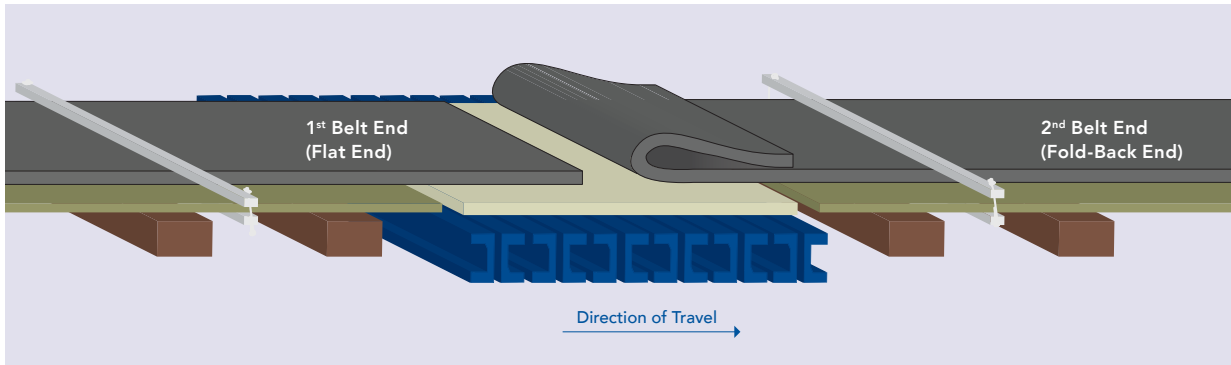


Fig. 7.6

7.7 The belt end remaining on the worktable (referred to as the 'flat end'), will already have a line drawn on it at 90° due to the steps in section 7.3. Cut across the belt at 90° to the centre line. See line 'A-A' in fig. 7.7.

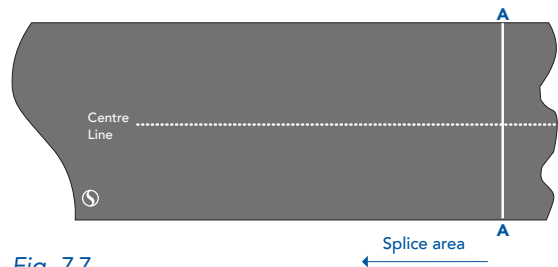


Fig. 7.7

7.8 Along one edge from the square cut end, measure the lead length $0.4 \times$ belt width (which equates to 22° bias) and mark as point B as shown in fig 7.8. Draw in the line A-B. From the line A-B measure back along each belt edge the overall splice length +100mm. Join both these points to create the line C-D. This line will be the trailing end skive line of the finished splice.

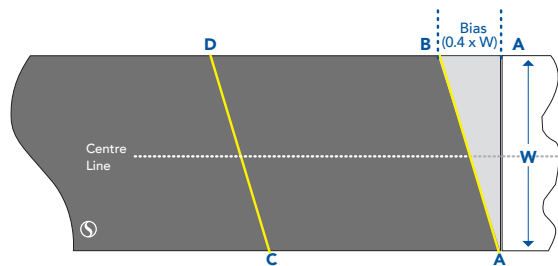


Fig. 7.8

7.9 Bring down the 2nd Fold-Back End so that it is laid over the 1st Flat-Belt End and using the centre line markings make sure the splice is aligned correctly to the marked centre lines. Secure the belt with splice station clamps. Now transfer the edge marks A, B, C and D to the 2nd Fold-back belt end edges and draw in the new bias skive lines A-B and C-D as shown in fig 7.9.

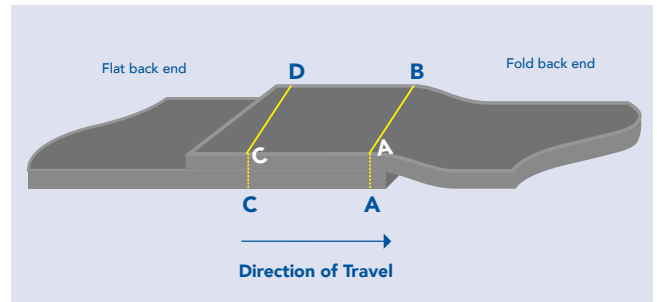


Fig. 7.9

7.10 Fold back out of the way 2nd Fold-Back end and secure. On 1st Flat-Belt end cut along the line C-D up to the cords with a knife inclined at 45° to the belt surface. Then cut out the moulded belt edges on the whole length of the 1st Flat-Belt End.

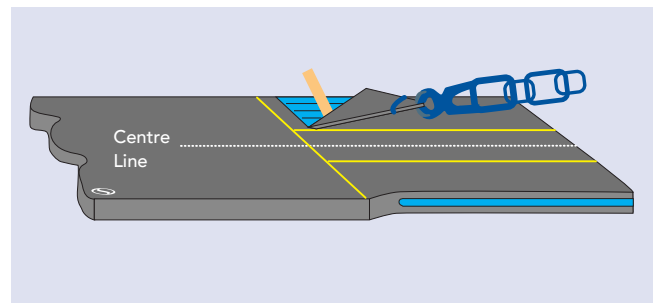


Fig. 7.10

7.11 Fold the 1st Flat-End Belt back when the top cover is removed.

7.12 Determine the contact lines on the bottom cover. Cut the covers along these lines up to the cords at an angle of 45° to the belt surface. Remove the bottom cover by cutting it with the knife just above the cords. While cutting/stripping, lightly stretch the cover with the use of a stripping winch.

7.13 Now with the flat-end folded back out of the way, Lay down the fold-back end and repeat steps 7.8 to 7.12

7.14 Remove the rubber between the cords on both ends by cutting it out with a knife, just along the sides of cords.

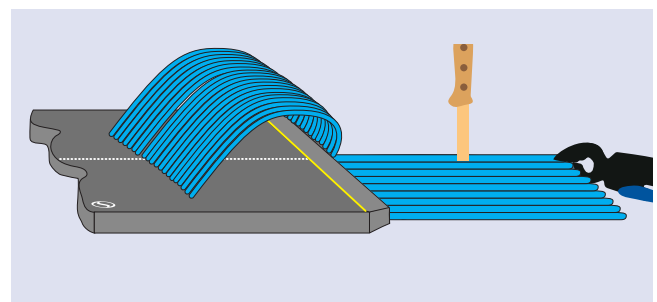


Fig. 7.14

7.15 Remove the rubber from the cord surface of both ends using the electric grinder and U-Shaped Buffing Wheels without damaging the zinc coating of the cords.

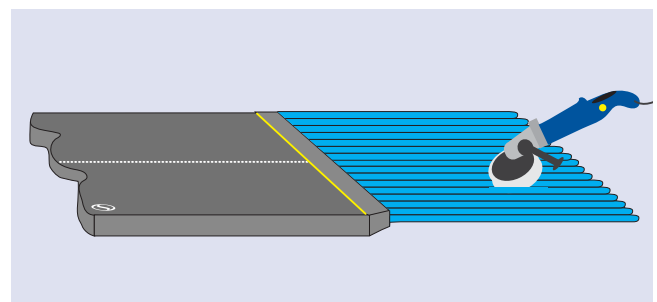


Fig. 7.15



- Cords should be prepared just before making the splice and should be protected from dust, moisture, etc.
- For a 1-Step Splice the rubber can remain on the cords but must be roughened.

7.16 Roughen the surface of the skived/beveled contacts and the 30 mm-wide belt area adjacent to it.

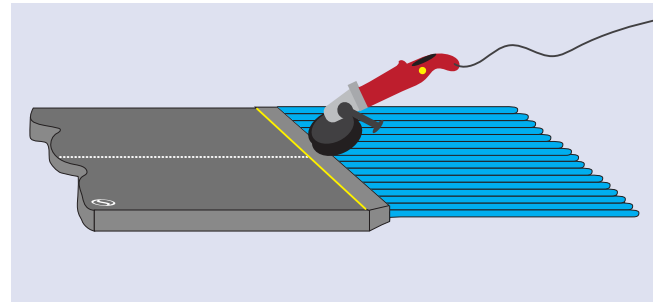


Fig. 7.16

7.17 Centre the belts ends to get one axis for both spliced belt ends. Check again the splice length and if it is correct then lay out the flat bars or clamps along the centered belts and fasten them to the splicing tables so that the belt ends cannot move. The belt ends should be dusted and cleaned thoroughly.

7.18 Clean the cord and the entire splice area to remove all dust and any possible things that may contaminate the integrity of the cords. Working on one belt end at a time the cords are to be given one coat of rubber solution. When the cords are dry they need to be wrapped and protected. For large belts this is often better done in small bunches. These can then be folded out of the way before we start to assemble the splice in section 8.



It is very important to allow the rubber solution to evaporate completely. Cords that haven't dried can lead to bubbles forming and weaken the splice. The cords, once dry, must be kept clean and contaminant free.

8 Assembling/Building the Splice

When applying any uncured splice components, the bonding surfaces should be clean and free of dust or possible contaminants. A soft brush can be used to remove any dust. The finished splice should physically mirror the parent belt. This can be achieved by maintaining proper gauge control when building the splice. If the splice is built light, it will likely become porous. If the splice is built heavy, it will bulge and distort, possibly encouraging damage and/or poor tension sharing. In either case, splice integrity is compromised.

8.1 If mould plates are being used then these are to be laid down in the correct position at this point. Then the silicon paper or nylon cloth can be laid either on the mould plates or the press platens should the splice be small enough. Mould plates are required for splices that require multiple sets of press platens as it avoids rubber flowing between gaps when the splice finally cured.

8.2 Double core and cover plates. If a metal reinforcement or fiber breaker is present in the belt, double them with cover and core plates, coating them previously with rubber solution, Dry well each time the surface of plates/reinforcement. The reinforcements shall be laid between the cover and core plate.

8.3 Trim to the belt size the rubber cover plate that has been doubled previously with the core plate. Make bevels on the belt ends at an angle of 45° to the surface of the belt ends. Lay it on the heating plates with the core rubber facing to the cords.

8.4 Coat the surface of skived/beveled belt and cords with rubber solution and dry them well. Then lower the ends of the belts and put the bevels of the belts together with the bevels of the plate lying on the shelves of the curing press. Clamp the bevels thoroughly (hammer them with a rubber mallet).

8.5 Determine the centre (belt axis) of the splice on the rubber plate laid on the bottom part of the press. Mark the lines with a clean blunt tool (e.g. with the blunt side of a knife blade). Cover the plate with foil except the centre part.

8.6 Using a brush coat the core rubber sheet, that will be under the cord that is about to be laid. This will create a slight tacky surface to help fix the cord in position.

8.7 Cut the cords according to the splicing diagram, starting from the belt axis. If the centre lines of the belts are aligned with the cords axes, then first lay the cords in the centre of the splice length. If the cords axes do not align with the centre line (belt axis), lay the cords in parallel to the centre line.

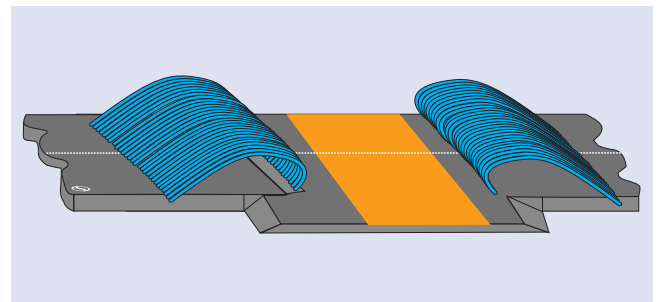


Fig. 8.3



It is very important to allow the rubber solution to evaporate completely.

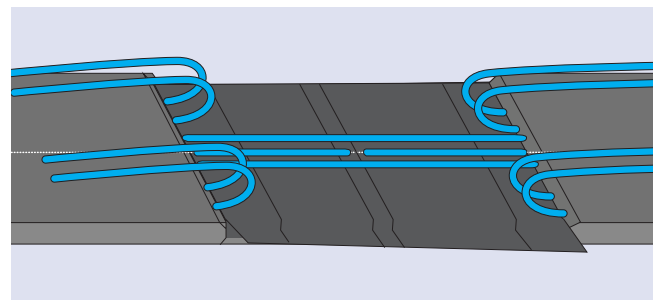


Fig. 8.7

8.8 Apply an intermediate rubber strip along the side of each laid cord and press it thoroughly. Clamp consecutive cords firmly in such a way that the cords and strips adhere each other. While laying the cords out, observe the rule that each cord of one belt end is connected with a corresponding cord of the other belt end at the length of step LST. The length between the cord ends that are laid opposite to each other shall be a minimum of: $4 \times d$; where d = cord diameter.

8.9 After laying out 5 to 7 cords, check their axial and parallel layout with reference to the belt axis. If parallel layout deviations are found, change the thickness of the intermediate rubber strips / stretch or double the strips.

8.10 Fill the free spaces between the cords with intermediate rubber strips.

8.11 When all the cords are laid out, fill the edges of the belt with a rubber plate to the height of the cord surface.

8.12 Lay the core rubber plate on the whole surface of the splice.

8.13 Trim to the belt size the rubber cover plate. Bevel the ends of the plate at an angle of 45° towards the plate surface.

8.14 Lay the cover plates so that beveled ends of cover plates should match beveled ends of belts,, paying attention not to trap in air. Clamp the contacts thoroughly (hammer them with rubber mallet).

8.15 Using a chalk line mark the edges of the splice in relation to the edges of the parent belts plus 4mm on each edge. Cut the surplus rubber at the edges so that the edges are uniform and square.

8.16 Final splice alignment should be checked at this point and splice confirmed to be square.

8.17 Lay out the edge bars so that they secure the nylon release fabric or silicon paper against the splice edge. If mould plates are being used then fit the top section of the mould plate(s).



- The length between the cord ends that are laid opposite to each other shall be a minimum: $4 \times d$; where d = cord diameter
- Add the strips perpendicularly to the core plate
- The strip thickness shall not be lower than $1,2 + (0,1 \times d)$, where d = cord diameter



A non-parallel cord layout with reference to the centre line or the curvature of the cords lowers the strength of the splice

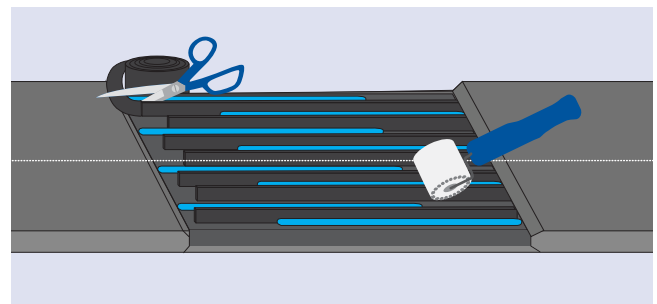


Fig. 8.10



Owing to a risk of bubble formation, do not recoat the cords with rubber solution

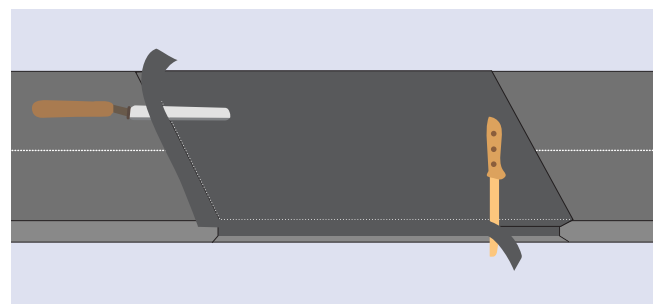


Fig. 8.13



Note for thicker covers the panels can be supplied in 2 parts which are then laminated together to give the appropriate cover thickness.

9 Vulcanisation/Curing

The splice curing process has three stages: heating, curing and cooling. Heating starts by exerting the required pressure and turning on the heating platens.

9.1 Position the edge bars firmly against the belt. The edge bars should be 1.0mm thinner than the parent belt. Use tightening-clamps/tie bars to maintain the seal between the belt and the edge bars. These should be checked as the curing temperature and pressure rise.

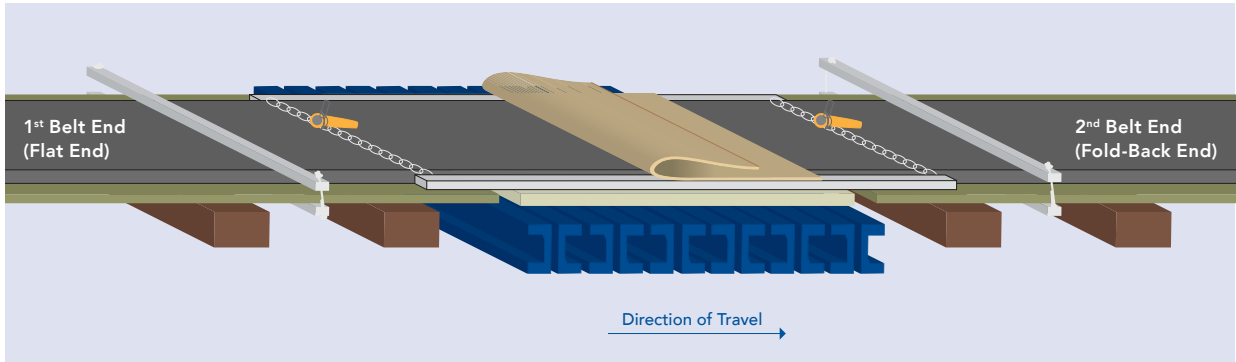


Fig. 9.1

9.2 Build the top half of the press as per manufacturer's instructions. With every part secured, switch on the press and start to apply heat and pressure.

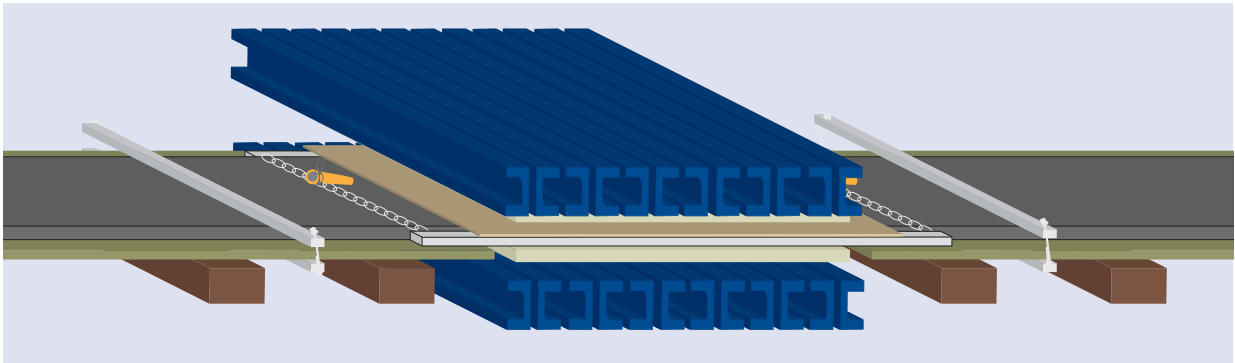


Fig. 9.2

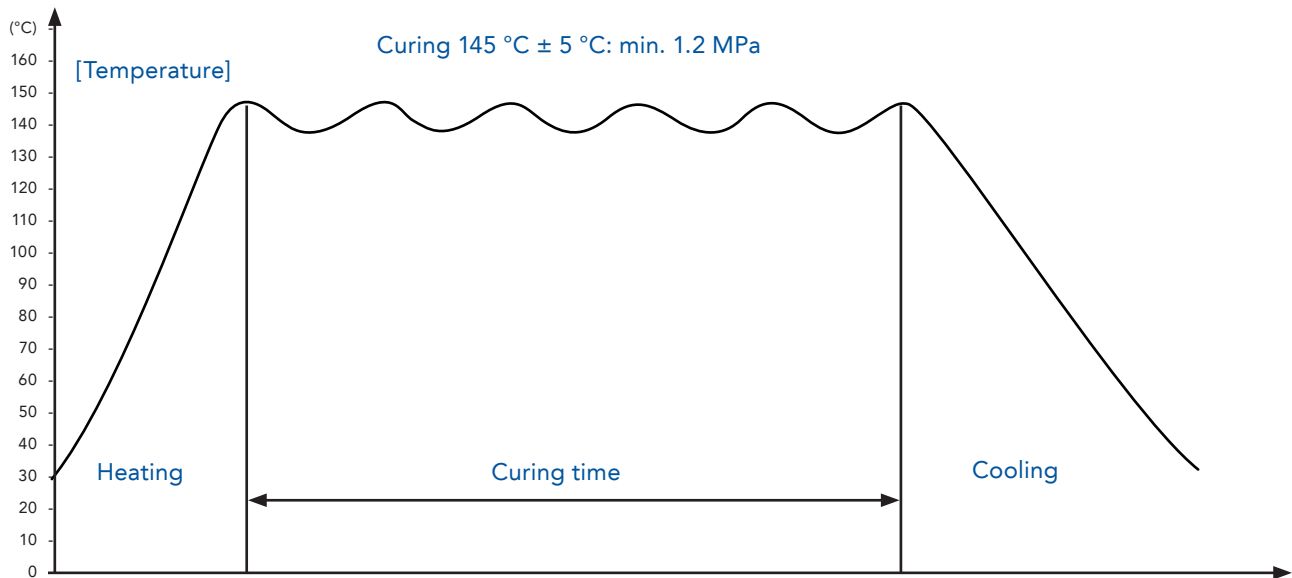
9.3 Cure the splices of rubber belts with steel cords applying. The following parameters are recommended:

- Curing temperature: 145 ± 5 °C
- Curing time: 3 minutes per 1 mm of belt thickness
- Unit pressure per splice of minimum 1.2 MPa (12 kg/cm²) or 176 psi.

9.4 The curing temperature depends on the grade of the cover rubber. When the platens reach 5°C below the required curing temperature, start counting the curing time and hold the temperature manually or automatically at the required level. Pressure should be checked regularly through the process to ensure there are no leaks. If there is no automatic setting, we recommend that the heating platens be periodically switched on and off to maintain the correct temperature.

This graph shows the process of curing the splice over time. The whole process consists of three stages: heating, curing and cooling. Measure the start time when all the heating plates of the curing press reach the set temperature. During the heating stage, the curing pressure should be as follows:

- 1/3 of the full cure pressure up to 50 °C temperature
- 2/3 of the full cure pressure from 50°C to 100 °C
- Above 100 °C the pressure should be raised to the full curing pressure



The required unit pressure per the surface area of the splice should be maintained by regulating the pressure of hydraulic fluid in the press. For presses with air/water bags, the hydraulic pressure roughly corresponds to the unit pressure. For presses with hydraulic actuators in the traverse beams, use the technical data given by the press manufacturer.

9.5 Once the required curing time is complete, shut down the heating completely and allow the splice to cool to 60-70°C. If forced (water) cooling is being used, keep the press closed until the temperature has reached 50°C as this will allow the centre of the belt to cool.

! DO NOT REDUCE PRESSURE DURING COOLING!

9.6 When sufficiently cooled, remove the pressure and disassemble the top half of the vulcanising press as per the manufacturer's instructions. The splice should be inspected and any 'flash/spew' rubber removed from the edges. Skives should be flush with the belt covers so as to avoid damage by the belts' installed cleaning systems.

9.7 Check splice alignment as per section 10.

9.8 Once cooled to ambient temperature the belt can be commissioned and put in to service.

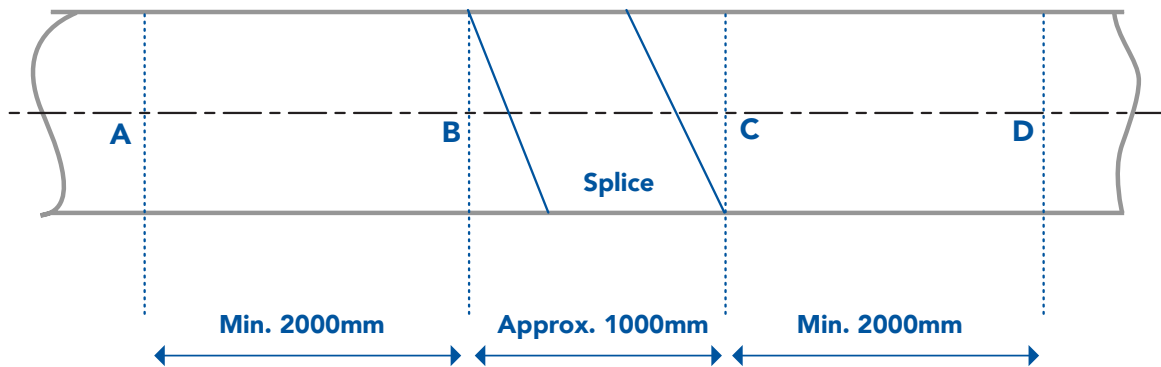
10 Checking of Splice Alignment

SPLICE ALIGNMENT (ONLY WHEN USING SPLICE TABLES)

Before Vulcanising:

Preparing and aligning the splice

The distance between centre points 'A-B' and 'C-D' should be 2000mm.



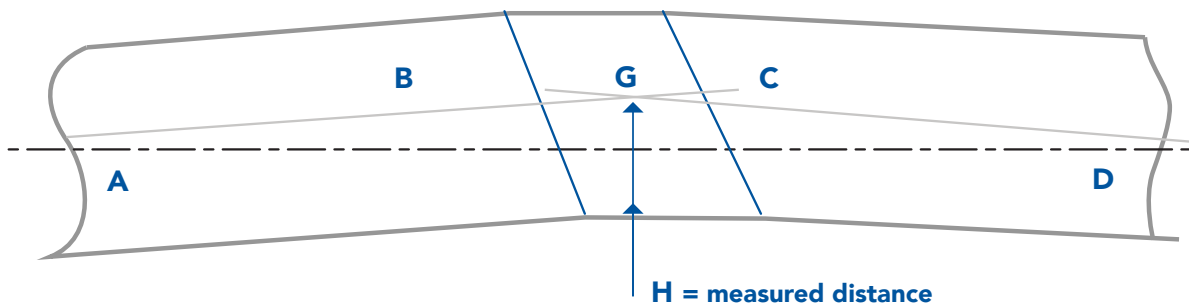
Post Vulcanising

Method of checking the straightness of the splice

Checking the straightness of the belt, at the spliced portion is performed in the following manner:

1. Draw a straight line from point 'A' to point 'D'
2. Draw an extension of the centre lines 'A-B' and 'C-D', into the vulcanised splice. The point where the two lines intersect is designated as point 'G'

Me Judgement Stand



$$\frac{H}{AD} \times 100 < 0.2 \quad \frac{\text{Distance measured between the straight-line 'A-D' and point 'G'}}{\text{Distance between point 'A' and point 'D'}} = \text{LESS THAN } 0.002$$

If the distance between point 'A' and point 'D' is 5000mm, the measured distance 'H' must be no more than 10mm.

3. Check the distance between the straight line 'A-D' and point 'G'

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