DRIVE BAND JOINING GUIDE

Background:

This guide is designed to help train on the correct method of joining drive bands on site, or directly on conveyors. Dyno has a range of standard drive bands available, however we do understand that some breakdowns cannot wait, or it makes more sense to join the bands directly on the conveyor vs taking the conveyor apart.

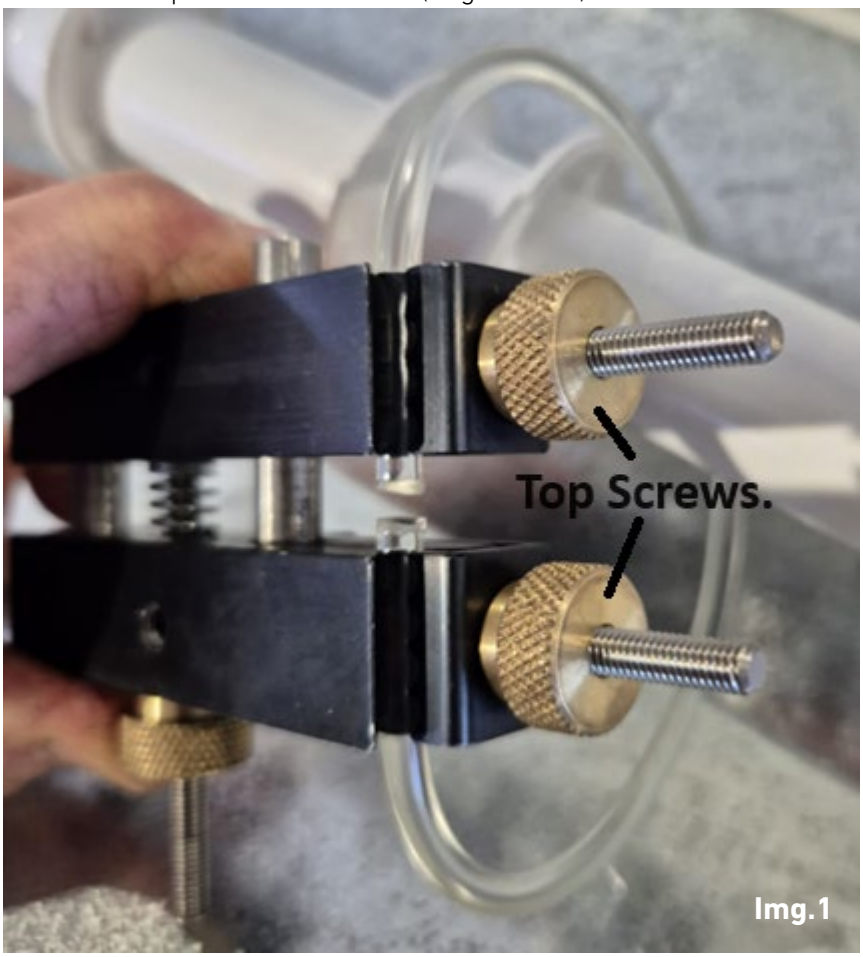
What are drive bands?

Drive bands are usually made from Urethane, and are used to drive rollers from a power source – Mostly either a Lineshaft or Motor Driven Roller (MDR). It is a safe and cost effective way to power a roller conveyor, and can be very reliable should they be maintained correctly (check our 'Tranzband Maintenance & Repair Guide'). There is a range of different strengths, colors, sizes and other properties, so check with the team at Dyno Conveyors for what is best suited for your application and conveyor type. You can reach them on:

- www.dyno-conveyors.com
- sales@dyno.co.nz
- 006432161440

Drive Band Joining Instructions:

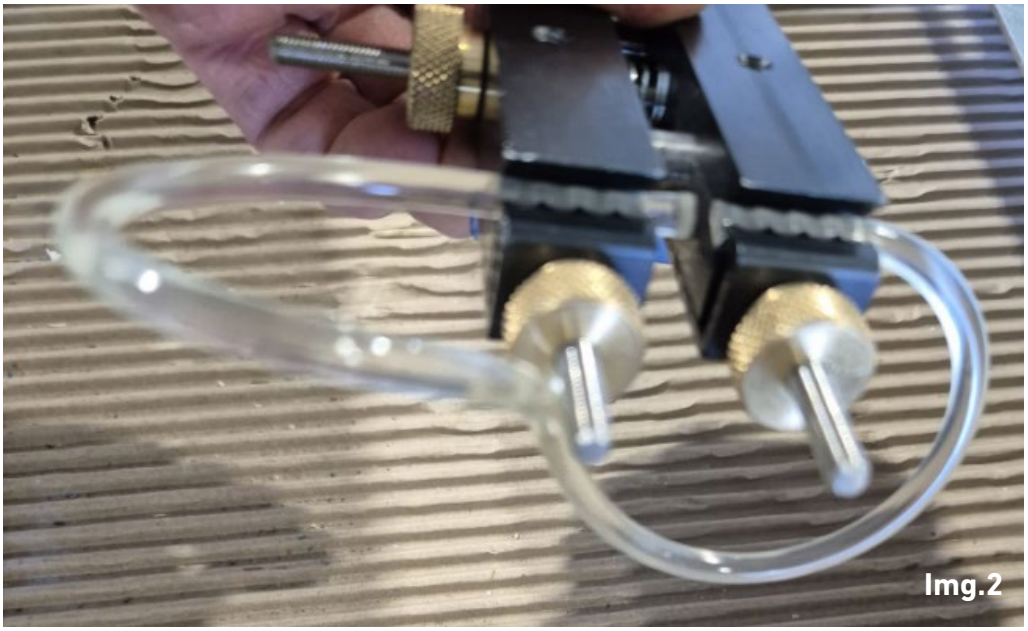
1. Cut band with sharp knife of special cutters. Ensure the cut is as square as possible.
    a. If repairing a Tranzband/Lineshaft conveyor without removing drive shaft, it is a good idea to cut a band off the conveyor, and use this as the template for cut length (Provided the band isn't old and stretched)
2. Clamp in provided holder with a maximum of the band Ø protruding inside welding clamp on each side. e.g. 5mm Ø band protrude max 5mm (Img.1 below).



Img.1

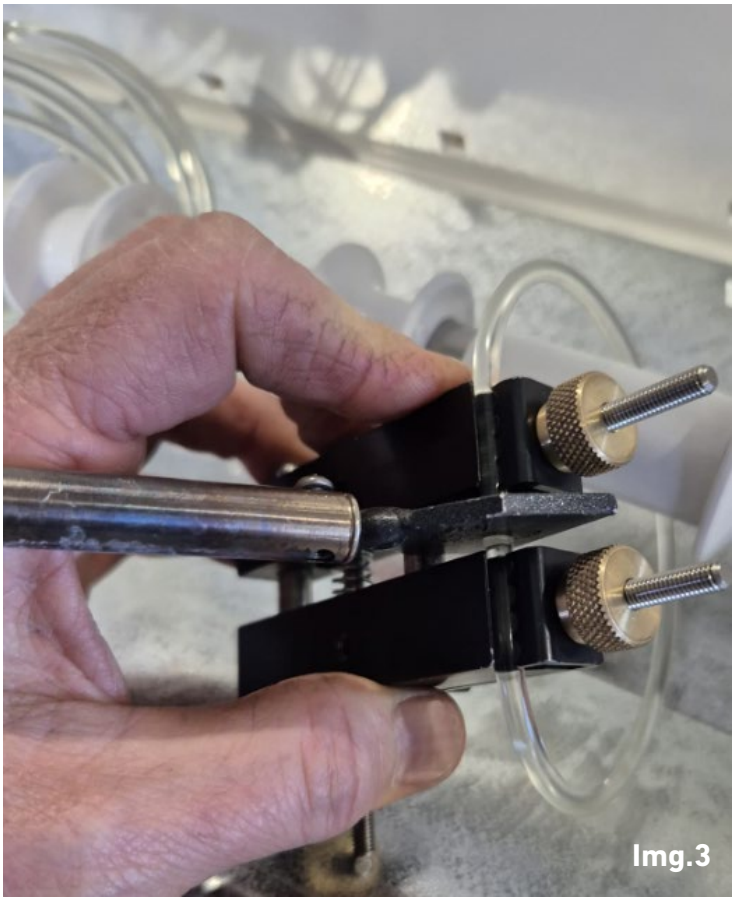
DRIVE BAND JOINING GUIDE

3. **Note:** Ensure band is not twisted (Img.2 below).



Img.2

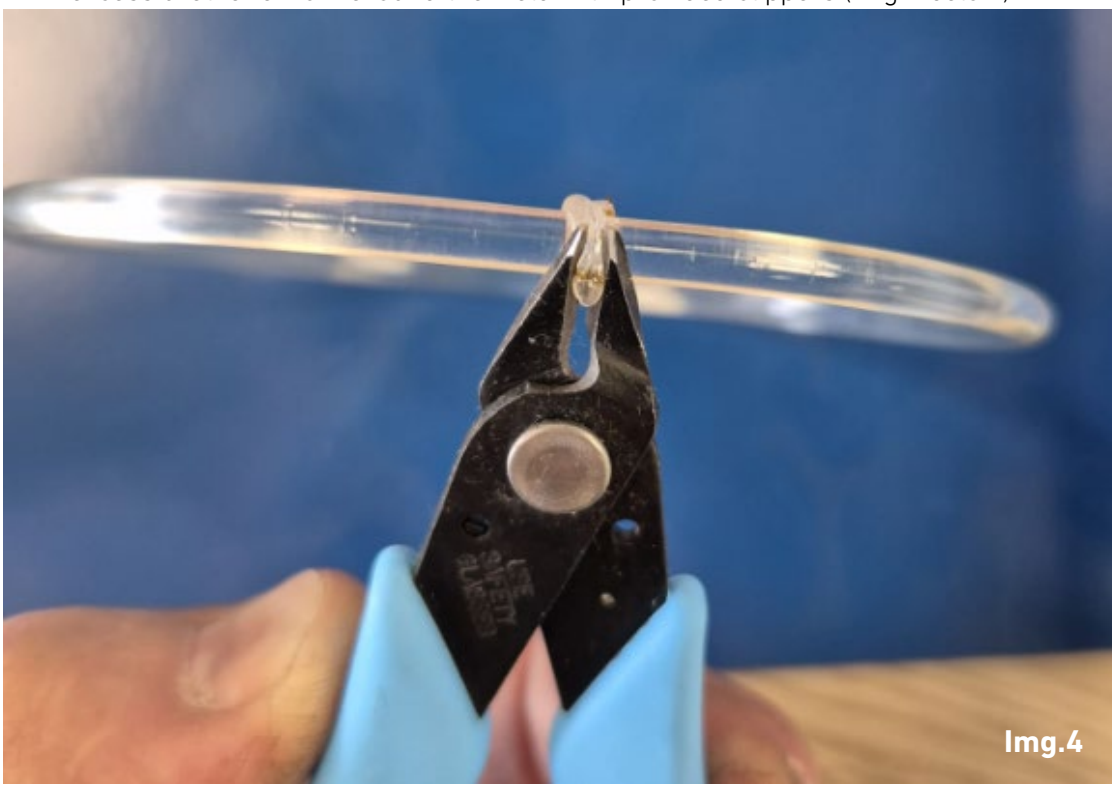
4. Tighten Screws on provided welding clamp.
5. Preheat the welding tool for a minimum of 10 minutes.
6. Insert preheated welding tool between the ends of bands and ensure it is perpendicular to the band (Img.3 below).



Img.3

DRIVE BAND JOINING GUIDE

7. Squeeze the end of bands gently onto the welding tool using the outside of the clamp (Warning, welding tool is HOT! Do not touch). Watch for the band to melt and start to curl. Ensure the full diameter of the band has curled over – this ensures the full face of the band has melted and will weld.
8. Give a quick, firm squeeze to expel any air and open the welding clamp.
9. Remove heating tool and quickly close welding clamp. Wind up lock nut with some pressure to hold the ends of the band together firmly while the weld cures.
   NOTE! We suggest you practice steps 6-9 on waste material first to learn the technique and test the welds.
10. IMPORTANT! Leave band clamped in welding clamp for a **minimum of 5 minutes** (use a timer) to ensure fully cooled and joint cured. If this step is skipped, the weld strength will be compromised and may fail prematurely.
11. Loosen nuts and take band out of welding clamp.
12. Trim excess urethane from around the weld with provided clippers (Img.4 below).



Img.4

Note: If you are having bands fail around the weld, check you have followed the above instructions correctly. If other parts of the band are failing (wearing flat spots, stretching etc.), please check our Tranzband Maintenance & Repair Guide.