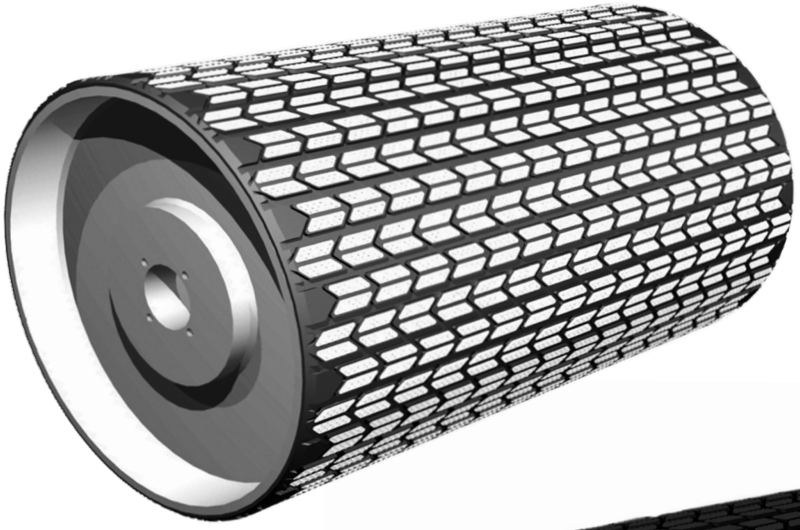
ARROWHEAD®
CERAMIC & RUBBER PULLEY LAGGING

INSTALLATION, OPERATION & MAINTENANCE INSTRUCTIONS



Arrowhead® Ceramic
Conveyor Pulley Lagging

Arrowhead® Rubber
Conveyor Pulley Lagging

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Important Safety Notice	Always observe the basic rules of safety when working with any conveyor system. To avoid injury and equipment damage, be sure that all controls to the conveyor are locked out and the power source is disconnected at all times during installation.

Purpose

The purpose of this procedure is to define the methods for the application of Pulley Lagging to Conveyor Pulley Shells using cold bonding technology.

Scope

This procedure is limited to the application of lagging using cold bonding processes only and should be read in conjunction with the specific instruction provided by the manufacturer of the Cement and Primers to be used.

Procedure

1. Sandblast the pulley shell to class 2.5. If sandblasting is not available, use an angle sander at low revs with a 36 grit sanding pad to get a fully roughened surface.

2. Prepare sufficient strips of lagging to cover the pulley face. Strips should be cut a minimum of 100mm (about 4") longer than the pulley face. This ensures that there is enough overhang to handle the lagging without contamination of the adhering surface. It is very important that the lagging strip ends are properly adhered.

3. Using a clean brush or cloth, wipe any dust or contaminate from the Pulley face and lagging. Do not use solvents unless there is the presence of oil or grease.

4. Apply an even coat of metal primer to the pulley face and allow it to dry in accordance with the manufacturers specifications.

5. Apply the first even coat of cement to the lagging and to the pulley shell and allow it to dry in accordance with the manufacturers recommendations.

6. Apply a second coat of cement to the pulley and lagging and allow it to dry until the surfaces are touch dry.

7. Using a chalk line, make a line on the pulley face parallel with the center line of the shaft/shell.

8. Apply the strip lagging to the pulley using the chalk line as a reference for the first strip edge. Apply each strip one at a time butting the edges against each other to ensure a good seal. Use a rubber mallet to hammer the lagging to the pulley shell.

9. Continue to apply strips until the last three strips. Using off-cuts of the lagging, lay them on the pulley and calculate where the strips need to be cut to form a perfect closing joint. The geometry of the strips allows for cutting in.

10. Finish by cutting all overhanging lagging from the pulley edge at a 30 degree angle. Then use the sander to finish off the edge sanding towards the steel shell.

ARROWHEAD® NAT CERAMIC DRIVE						
Part Number	Belt Width		Thickness	Inches Ceramic	Inches Rubber	Weight lb.
	in	mm				
ASG-10X24-CL	24	600	1/2"	24-7/8"	39-1/2"	9
ASG-10X30-CL	30	750	1/2"	31-1/4"	47"	11
ASG-10X36-CL	36	900	1/2"	36-1/4"	51-1/2"	13
ASG-10X42-CL	42	1050	1/2"	41-1/8"	56-1/2"	15
ASG-10X48-CL	48	1200	1/2"	48-1/2"	64-1/2"	17
ASG-10X54-CL	54	1350	1/2"	55-7/8"	71-1/4"	19
ASG-10X60-CL	60	1500	1/2"	60-3/4"	76"	21
ASG-10X72-CL	72	1800	1/2"	73-1/8"	89"	23

ARROWHEAD® MSHA CERAMIC DRIVE						
Part Number	Belt Width		Thickness	Inches Ceramic	Inches Rubber	Weight lb.
	in	mm				
ASG-10X24-MSHA-CL	24	600	1/2"	24.41	47.24	9
ASG-10X30-MSHA-CL	30	750	1/2"	30.71	53.15	11
ASG-10X36-MSHA-CL	36	900	1/2"	37.01	59.06	13
ASG-10X42-MSHA-CL	42	1050	1/2"	43.31	64.96	15
ASG-10X48-MSHA-CL	48	1200	1/2"	47.24	70.87	17
ASG-10X54-MSHA-CL	54	1350	1/2"	56.69	78.74	19
ASG-10X60-MSHA-CL	60	1500	1/2"	62.99	86.61	21
ASG-10X72-MSHA-CL	72	1800	1/2"	72.83	94.49	23
ASG-10X84-MSHA-CL	84	2100	1/2"	84	101	30
ASG-1-10X60-MSHA-CL-1	60	1500	1"	62.99	56.61	21
ASG-1-10X72-MSHA-CL-1	72	1800	1"	72.83	94.49	23
ASG-1-10X84-MSHA-CL-1	84	2100	1"	82.09	102.36	25

ARROWHEAD® RUBBER PULLEY LAGGING					
Part Number	Style	Durometer	Thickness	Width	Weight lb.
ASG-10X21.33-1/2-TRL	Drive	60	1/2"	10”	42
ASG-10X21.33-3/4-TRL	Drive	60	3/4"	10”	60
ASG-10X21.33-1/2-TRL-PLN	Smooth	60	1/2"	10”	48
ASG-10X21.33-1/2-TRL-SM	Smooth	45	1/2"	10”	52
ASG-10X278-1/2-TRL	Drive	60	1/2"	10”	626

ARROWHEAD® MSHA RUBBER LAGGING					
Part Number	Style	Durometer	Thickness	Width	Weight lb.
ASG-10X21.33-1/2-MSHA-TRL	Arrowhead	60	1/2"	10”	42
ASG-10X21.33-3/4-MSHA-TRL	Arrowhead	60	3/4"	10”	56
ASG-10X278-1/2-MSHA-TRL	Arrowhead	65	1/2"	10”	626
ASG-10X21.33-1/2-MSHA-PLN	Smooth	60	1/2"	10”	51