

**GYPSUM FORMING BELT INSTALLATION QUESTIONNAIRE**

Please fill out and return questionnaire with service request

1. The scope of work:

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2. The Belt position, length, and width:

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3. Conveyor frame width and height:

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4. Access, height of ceiling, width of aisles, cross over conveyor pass, reject table:

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5. Take up length and type: screw or cable:

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6. The old belt: Wind or Discard?

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7. Can the old belt be pulled out to reject area?

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8. Conveyor Age & Condition:

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9. Scheduled activities other than belt change:

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10. Duration of outage:

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## **PLANT TO PROVIDE FOR SERVICE/INSTALLATION**

- 1. Hourly plan for outage**
- 2. Alignment of conveyor components (Oasis Alignment)**
- 3. Conveyor cleaning crews**
- 4. Electrical and equipment power up source- 440V, 3 Phase, 50  
AMP**
- 5. 15 Ton forklift with 7 FT fork 3" thick, or 20 Ton mobile deck  
crane with outriggers**
- 6. New belt wash crew & stearate**
- 7. Tracking points observation manpower**
- 8. Mechanical personnel for any work performed on conveyor  
and conveyor components.**

## **Time Required to Change Forming Belt**

1. Mobilization- dependent on distance & equipment required: 1-4 days
2. Pull old belt off of the conveyor: 2-3 hours
  - a. If the old belt is not intended for a spare, pull from the side of conveyor to winder, and/or pull by forklift through side roll updoor outside the building. (1 hour)
  - b. If the belt is in good shape and needs to be saved for a spare belt, position winder over the conveyor, wind in roll form, and remove the belt and winder by crane. (2-3 hours)
  - c. Position the winder in the reject area, drive the old belt through the wall and wind the belt. (2-3 hours)
3. New Belt Installation: 4-5 hours
  - a. Remove the protective slats off the belt spool
  - b. Position belt stand over conveyor
  - c. Charge belt stand with new belt spool
  - d. String cable winch around conveyor
  - e. Install pull plate on the belt end and pull new belt on bare conveyor
  - f. Remove belt stand and spool
  - g. Install bar clamps, overlap belt, and fold belt ends.

#### 4. Splice: 8-12 hours

- a. Build splice table
- b. Lay belt on table, center line both ends
- c. Square and make steps
- d. Strip one end, transfer marks to the other end and strip other end
- e. Align the center line on both ends, secure, fold trailing end
- f. Apply cement, lay new rubber, overlap splice ends
- g. Lift belt with lifters
- h. Assemble vulcanizer and cook splice

#### 5. Running of new belt

- a. Remove splice table
- b. Move take up and tension belt
- c. Run for ½ hour
- d. Stop, slide plywood under splice and sand/clean splice.
- e. Remove all from belt, wash with mild soap (Dawn) solution, dry belt and apply stearate.
- f. Run board, and inspect board.

#### 6. Demobilization: 2-3 hours

**Total time to install new belt and run product: 2 Days (minimum 24 hours labor)**