Super-Screw®

TECHNICAL BOOKLET

FLEXIBLE SPlice TO SCREW

Super-Screw® 80
EP 800 Belt
Manganese Mine
GABON
AVANTAGES

Installation :
- without need of physical strength
- quick installation (saves downtime)
- under any weather conditions
- using battery or pneumatic operated screw driver, no need of electrical power
- no use/need of expensive equipment
- no need of highly skilled operator
- no drilling preparation, no template
- self tapping screws through the belt
- Wear and cut resistant
- High tensile strength
- Flexible
- Can be used for a bridge even with different belt carcass thickness
- Suitable for high-heat belt up to 200°C
- Compatible with small pulley diameter
- Compatible with conveyor scraper
- Perfect for tubular belt
- Leak proof
- Available on coil or «ready to use» cut lengths
- Many rubber versions available

The Super-Screw® significantly reduces downtime. It can bear service tensions up to 200 N/mm (belt breaking strength up to 2000 N/mm).

It is available in different rubber versions (see opposite page).

Simple and practical, the Super-Screw® is versatile!

TECHNICAL DATA

<table>
<thead>
<tr>
<th>SUPER-SCREW®</th>
<th>35</th>
<th>63</th>
<th>65</th>
<th>80</th>
<th>85</th>
<th>100</th>
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<th>180</th>
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<tr>
<td>Final belt thickness*, mm</td>
<td>4-11</td>
<td>4-13</td>
<td>4-13</td>
<td>4-15</td>
<td>5-15</td>
<td>6-15</td>
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<td>7-17.5</td>
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<tr>
<td>Maximum belt tension, N/mm</td>
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<td>63</td>
<td>80</td>
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<td>1800</td>
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<tr>
<td>Minimum pulley Ø, mm</td>
<td>160/200</td>
<td>220/300</td>
<td>250/300</td>
<td>250/350</td>
<td>270/400</td>
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<td>400/800</td>
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<tr>
<td>Thickness top plate (± 1 mm), mm</td>
<td>4.5</td>
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<td>6.5</td>
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<td>7.5</td>
<td>7.5</td>
<td>9</td>
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<td>Thickness bottom plate (± 1 mm), mm</td>
<td>3.7</td>
<td>4</td>
<td>4</td>
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</tr>
</tbody>
</table>

* Final belt thickness : Belt thickness once skived or not

INFORMATION

For anti-magnetic splice : use screws and inserts made of non magnetic stainless steel

Super-Screw® is available in bare back version = with textile on the bottom for sliding belts

M A D E I N F R A N C E

P A T E N T E D
Super-Screw® Version Rubber Color code

- A - abrasion resistant (regular)
- C - heat resistant 150°C (170°C flash)
- R - heat retardant 170°C (200°C flash)
- W - white FDA/USDA rubber cover with stainless steel inserts and screws - Maximum length : 1.2 Meter
- P - very low temperature down to -50°C
- G - oil resistant (120°C heat resistant)
- F - fire resistant and antistatic (DIN 20 340 & 20 284, MHSA, FRAS)

Super-Screw® Color code with inserts made of non magnetic stainless steel

Yellow line = stainless steel inserts

Super-Screw® «Ready to install» : the assembly spacers are pre installed. The top part matches the bottom part. It is delivered with screws and PZ bit. Maximum length : 3 Meters.

Super-Screw® roll is delivered in 2 rolls : the top roll and the bottom roll. You have to define the screw size and their quantity, same for spacers and PZ bit (PZ2, Ø 5 mm or PZ3, Ø 6.3 mm) - see page 4 - Maximum length : - 25 Meters for the Super-Screw® 35 to 105 - 15 Meters for Super-Screw® 125 to 205

To add

- Spacers
- Screws bucket
- PZ Bit

Best way for patch/repairs

Installation Tool

Battery, electric or pneumatic operated drill or screwdriver
For selecting the right Super-Screw® fastener you have to analyse the following points:

- **The belt tension** and the **strength of the belt**

  Note: on steel cord belt, please contact MLT staff or your distributor.

- **The final belt thickness**: belt thickness once skived or not

- **Rubber version**: wear resistant, oil resistant, heat resistant 150°C (170°C flash), heat retardant 170°C (200°C flash) fire resistant, white (FDA) or for very low temperature down to -50°C. Optional with textile on the bottom side or with a PU protection cover.

- **The belt width**: order a longer fastener of +10% minimum of the belt width to have a minimum inclination of 1/3 of the belt width.

- The possible **request of non magnetic splice**: select metallic inserts made of non-magnetic stainless steel and screws made of stainless steel.

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### TECHNICAL DATA

<table>
<thead>
<tr>
<th>SUPER-SCREW®</th>
<th>35</th>
<th>63</th>
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<th>105</th>
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<tr>
<td>Maximum belt tension, N/mm</td>
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<td>Minimum pulley Ø, mm</td>
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<td>400/800</td>
<td>500/800</td>
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<td>Skiving depth first screwed part, mm (± 0.5mm)</td>
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<tr>
<td>Qty of screws per meter</td>
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<td>254</td>
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### Specific data for rolls

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<td>PZ bags needed (25 bit per bag)</td>
<td>1 bag of PZ2</td>
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</table>

* Final belt thickness: Belt thickness once skived or not

These values are given for information only
Super-Screw® screws are engineered by MLT. They are self-drilling and self-tapping: they pass through the carcass threads without cutting them. For belts with specific technical characteristics: monoply or hard cover, use longer screws.

Screw sizes are given for information only, keep different assorted screw lengths.

**SCREWS AND SPACERS SELECTION CHART**

For belts with specific technical characteristics: monoply or hard cover, use longer screws.

<table>
<thead>
<tr>
<th>SUPER-SCREEN®</th>
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<tr>
<td>PZ bit needed</td>
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<td>8 - 10</td>
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<td>10 - 11.5</td>
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<tr>
<td>11.5 - 13</td>
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<tr>
<td>13 - 14.5</td>
<td>616</td>
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<tr>
<td>14.5 - 16</td>
<td>616</td>
</tr>
<tr>
<td>16 - 17.5</td>
<td>618</td>
</tr>
<tr>
<td>&gt; 17.5</td>
<td></td>
</tr>
</tbody>
</table>

Contact us

*Final belt thickness: Belt thickness once skived or not

It seems that you did not skive your belt enough. Properly skived off, your belt allows a flat repair or splice (no extra thickness).

* Final belt thickness: Belt thickness once skived or not
**Super-Screw® HOW TO INSTALL ?**

**WARNING**
- DO NOT USE AN IMPACT DRILL
- SLIDE A THICK BOARD UNDERNEATH THE SUPER-SCREW®
- DO NOT SCREW ON A DRUM
- TAKE APPROPRIATE SAFETY GEAR: PPE

**ASSEMBLY**

The rolls are delivered **identified in boxes** as top and bottom. A marking strip, on the Super-Screw’s® top and bottom covers, identifies the rubber version.

Unroll the rolls side by side, in the same direction. Measure the length required.

Cut the coils using the MLT cutting press for an easy and quality cut, or another cutting tool.

NOTE
- MLT manufactures adapted punches.

**EQUIPMENT REQUIRED**

- Appropriate Super-Screw®
- Quantity of screws needed
- MLT PZ bit
- MLT skiver
- Ruler/tape measure
- MLT stamp press or other cutting tool
- Belt marking pen
- Cutter
- Grinder
- Powerful electric drill
- Wooden board

**SUPER-SCREW® PROFILES**

Bottom part  |  Top part

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**INSTALLATION**

1. **Cut your belt with a 1/3 angle of the width of the belt. The other side of the belt should be cut with a bias in the opposite direction.**

2. **Skive down both top and bottom belt rubber covers (check «Useful info» chart) with the MLT skiver. Leave a thin rubber layer to protect the carcass (figure 1).**

3. **Chamfer both ends of the belt top and bottom as shown (if belt thickness ≥ 6 mm). Position Super-Screw® against the belt, ensuring that Super-Screw® is resting against the spacers (figure 2).**

4. **Move on the leading edge b, making sure the two edges of the belt are in alignment and butted against each other. Screw this the remaining side, using the same screwing pattern as before.**

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**NOTE**
- The arrows have to be pointing in the same direction. You may notice a small gap due to the elasticity of materials.
If needed, trim the Super-Screw® with a grinder along the edges of the belt.

Your Super-Screw® is installed!

The thin rubber cover over the metallic inserts will diminish over time. This has no consequence related to the Super-Screw®'s resistance, strength or longevity.

### USEFUL INFORMATION

<table>
<thead>
<tr>
<th>SUPER-SCREW®</th>
<th>35</th>
<th>63</th>
<th>65</th>
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<th>125</th>
<th>127</th>
<th>180</th>
<th>185</th>
<th>200</th>
<th>205</th>
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</thead>
<tbody>
<tr>
<td>Skiving depth trailing side A, mm (±0.5 mm)</td>
<td>24</td>
<td>50</td>
<td>72</td>
<td>126</td>
<td></td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Skiving depth leading side B, mm (±0.2 mm)</td>
<td>38</td>
<td>60</td>
<td>84</td>
<td>141</td>
<td></td>
<td></td>
<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>Thickness top plate (±1 mm), mm</td>
<td>4.5</td>
<td>5</td>
<td>6.5</td>
<td>6</td>
<td>7.5</td>
<td>7.5</td>
<td>9</td>
<td>6.5</td>
<td>8.5</td>
<td>6.5</td>
<td>8.5</td>
<td>8.5</td>
<td>10</td>
</tr>
<tr>
<td>Thickness bottom plate (±1 mm), mm</td>
<td>3.7</td>
<td>4</td>
<td>4</td>
<td>4.5</td>
<td>4.5</td>
<td>4.5</td>
<td>4.5</td>
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<td>6</td>
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</tbody>
</table>

These values are indicative.

Set the spacers in the first 2 holes of each side of the cut (Super-Screw® middle row), place screws in the center row every 3 holes.

Place the “top” cut length over the “bottom” cut length.

Insert screws through the spacers, starting with the first 2 from each end and then the center.

**Figure 1**
- Bad skiving
- Good skiving

**Figure 2**
- Screw is too long
- Screw is perfect

**Figure 3**
- Not enough tightening
- Too much tightening
- Good tightening

**Figure 4**
- Screw is too long
- Screw is too short

Start screwing on the trailing side A.

Follow the screwing pattern shown.

**Warning**: - tightening and screw size (figures 3 & 4).
- screw on a flat, thick wooden board.

Spread the screwing process.

**Figure 3**
- Not enough tightening
- Too much tightening
- Good tightening

**Figure 4**
- Screw is too long
- Screw is too short
- Screw is perfect

Useful Information

These values are indicative.
**For longitudinal repairs** on step 4 and 6: read the special instructions with this sign.

Fill large holes with suitable material to fill the gap.

1. Draw on the belt, an outline of the Super-Screw® around the tear. The outline should be significantly larger than the tear.

2. Make a slight cut on the outline. **Do not go through the fabric.**

3. Remove the rubber on the inside of the outline leaving a thin rubber layer. If needed: skive the bottom side outline.

4. Place the upper part of the Super-Screw® on the recessed surface. Screw the first 2 holes of 1 end with protruding screws.

5. Place the bottom part of the Super-Screw® on 2 protruding screws points. Replace protruding screws.

6. Screw extremities, middle and spread the screwing process.

**For longitudinal repairs**

- Place the Super-Screw® top side on the mark.
- With protruding screws: screw the 2 first holes of each extremity and repeat this every meter.

Your Super-Screw® patch is installed without extra thickness!
Both ends of the belt must be in contact against each other. IMPORTANT: remove the spacers.

It's important to install Super-Screw® in a bias, to minimise / soften scraper contact.

You must install Super-Screw® with the correct screw length, otherwise bottom inserts will twist around.

If the conveyor has a scraper: it is necessary to inbed the Super-Screw® into the belt by skiving off the top rubber cover of the belt.

Place a thick wooden board underneath the Super-Screw® for its installation.

Skive the belt, leaving a thin rubber layer.

On chevron belts: Super-Screw® bias has to follow the cleats angle (contact us for further assistance).

The technical content of this document is deemed for information only, and can be modified without preliminary notice.
Frequently asked QUESTIONS

**What are the Super-Screw® installation advantages compared to hot vulcanization?**

- fast and easy to install
- no need/use of expensive equipment
Installation regardless of the:
- configuration of the conveyor belt,
- access conditions,
- weather conditions,
- temperature.

**Super-Screw® match with scrapers?**

Yes: you need to skive the belt to integrate the splice.

**Why is Super-Screw® so successful?**

- screws are self-drilling and self-tapping: they spread the carcass threads without cutting them
- Super-Screw® carcass composition: similar to the belt composition
- Super-Screw® is flexible
- tightening Super-Screw® with the belt

**Why skive the belt?**

- to minimise/soften scraper impact
- for a better and progressive wrap around the pulleys
- better longevity
- avoid extra thickness
- aesthetic purpose

**Why you should leave a thin rubber layer on the belt when installing Super-Screw®?**

To protect textile from possible infiltrations (humidity, carried products...) and to spread tightening strength of the screw.

**Can Super-Screw® be matched with a metal detector?**

Some Super-Screw® versions are available with stainless steel non-magnetic screw and inserts/plates. To check the feasibility, lay some Super-Screw® with some screws out whilst passing them under the detector, and monitor the result of the detector.
**Super-Screw® Tools**

**Essentials to Have...**

- **Angle grinder** GWS 8-125
  Ref. 299 1466

- **Screwdriver 220 V**
  Ref. 299 1328

- **Belt skiver 220V**
  Ref. 299 1175

- **Blade for skiver for belt**
  Various versions

- **3 M measuring tape with blocker**
  Ref. 299 1551

- **White ink soft pen 8 ml**
  Ref. 299 1142

- **Light protection goggles**
  Ref. 299 1181

- **Work gloves** docker type
  Ref. 299 1119

- **Screwdriver 220 V**
  Ref. 299 1328

- **Driving bits PZ**
  1. PZ2 bit - for Super-Screw® 35 to 105
     Ref.: 299 1300
  2. PZ3 bit - for Super-Screw® 125 to 205
     Ref.: 299 1301

- **Belt clamps made of reinforced aluminium with hooks**
  Various size for belt wide: 500 to 2000 mm
  Ref. 299 1560 to 1568

- **Gauge belt 30 x 50 mm**
  Ref. 299 1548

- **Hand winch with lever (800 daN to 3200 daN)**
  Ref. 299 1130/1133/1134

- **Belt skiver 220V**
  Ref. 299 1175

- **Blade for skiver for belt**
  Various versions

- **Cutter** 25 mm 3 blades loader
  Ref. 299 1269

- **Hand winch with lever (800 daN to 3200 daN)**
  Ref. 299 1130/1133/1134

- **Light protection goggles**
  Ref. 299 1181

- **Work gloves** docker type
  Ref. 299 1119

- **3 M measuring tape with blocker**
  Ref. 299 1551

- **White ink soft pen 8 ml**
  Ref. 299 1142

- **Aluminium vulcanisation folding square**
  Angle 90° / 45° and 18,5° (1/3)
  Ref. 299 1572

* Other references and models available on our vulcanising tool price list

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Ask for our vulcanising tools price list!
MLT also produces Conveyor belt splicing systems, technical belts, tools, vulcanizing presses...

New Mine fastener
New ISC® splice
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