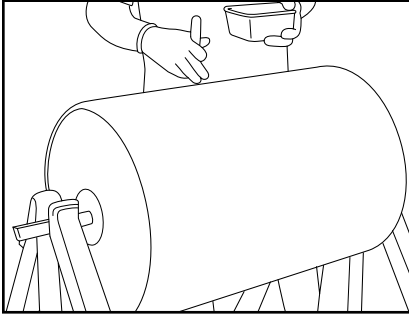


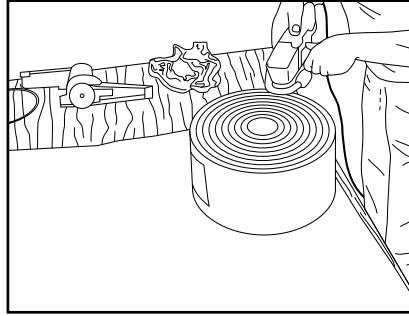
# Flex-Lag® Pulley Lagging

Installation Instructions for Flex-Lag® Natural Diamond Rubber,  
Flex-Lag® Natural Diamond Ceramic, and Flex-Lag® Ceramic Lagging

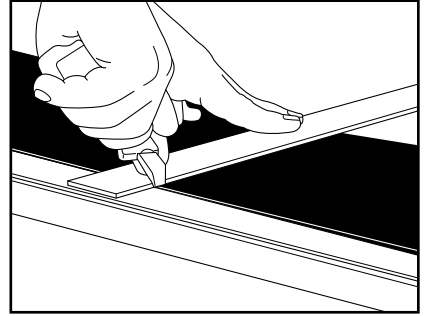
Flex-Lag® Pulley Lagging can be used with any brand of adhesive. The successful bonding of the lagging to the pulley depends on properly following the procedure set forth by the adhesive manufacturer.



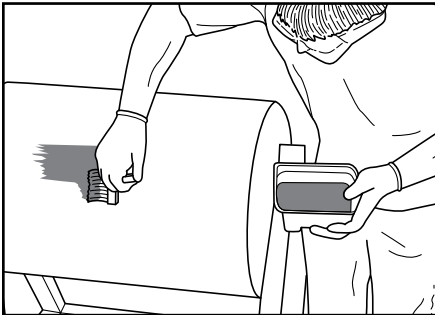
1. Prepare the pulley by removing the old lagging, paint, and primer. Sand blast the entire pulley (or use a grinding wheel) including the edges, and paint the pulley surface, including the edges, with metal primer recommended by the adhesive manufacturer. Allow to dry completely – follow adhesive manufacturer’s recommendation.



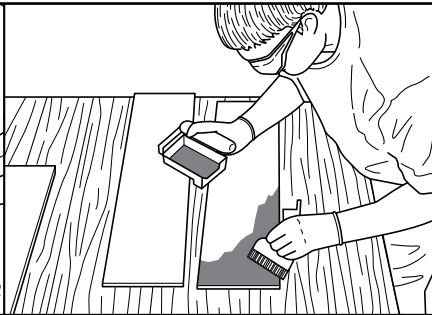
2. Use a grinding wheel (or variable speed buffer with a buffing disc) to buff the edges and bottom of the lagging.



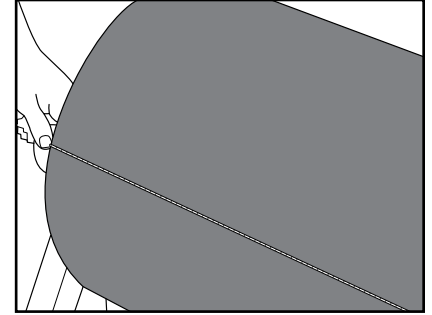
3. Use the strip selection chart (at the bottom of the page), to calculate the number of strips required for your pulley diameter. Lagging strips should be cut 4 inches (100 mm) longer than the pulley face width. **Note:** Do not allow ceramic tiles to sit at, or over, the edge of the pulley face.



4. After mixing the adhesive, according to the manufacturer’s instructions, immediately apply the first coat to the entire pulley surface and all strips of lagging.



Be sure to apply adhesive to the edges of the lagging as well. **Note:** temperature and humidity will effect the dry time.

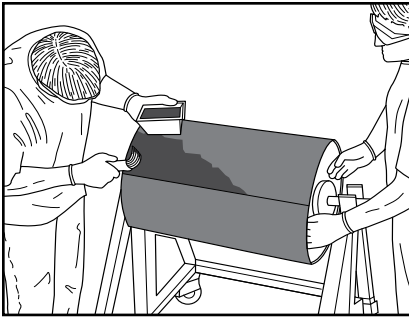


5. After the first coat of adhesive has dried completely, mark a line across the pulley face, parallel to the shaft’s centerline and square to the edge of the pulley.

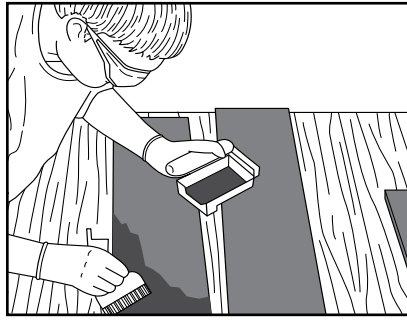
## STRIP SELECTION CHART

Pulley Diameter Inches (mm)	Number of Strips Required	Pulley Diameter Inches (mm)	Number of Strips Required	Pulley Diameter Inches (mm)	Number of Strips Required	Pulley Diameter Inches (mm)	Number of Strips Required	Pulley Diameter Inches (mm)	Number of Strips Required	Pulley Diameter Inches (mm)	Number of Strips Required
12.6-15.0 (320-381)	6	22.6-25.0 (574-636)	10	32.6-35.0 (828-891)	14	42.6-45.0 (1,083-1,145)	18	52.7-55.1 (1,339-1,400)	22	62.7-65.1 (1,593-1,654)	26
15.1-17.5 (382-445)	7	25.1-27.5 (637-700)	11	35.1-37.5 (892-955)	15	45.1-47.6 (1,146-1,210)	19	55.2-57.6 (1,403-1,463)	23	65.2-67.6 (1,656-1,717)	27
17.6-20.0 (446-510)	8	27.6-30.0 (701-764)	12	37.6-40.0 (956-1,018)	16	47.7-50.1 (1,212-1,273)	20	57.7-60.1 (1,466-1,527)	24	67.7-70.1 (1,720-1,781)	28
20.1-22.5 (511-573)	9	30.1-32.5 (765-827)	13	40.1-42.5 (1,019-1,082)	17	50.2-52.6 (1,275-1,336)	21	60.2-62.6 (1,529-1,590)	25	70.2-72.6 (1,783-1,744)	29

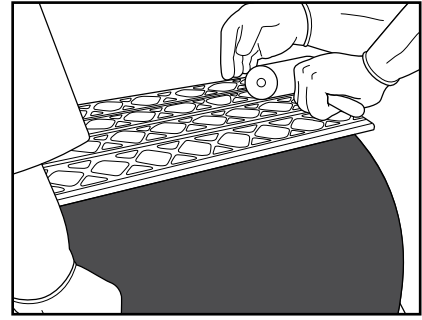




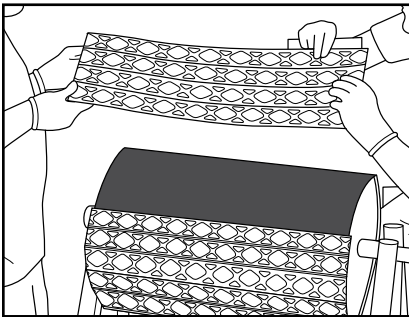
6. From the perpendicular line, apply a second coat of adhesive to an area slightly greater than two strips of lagging.



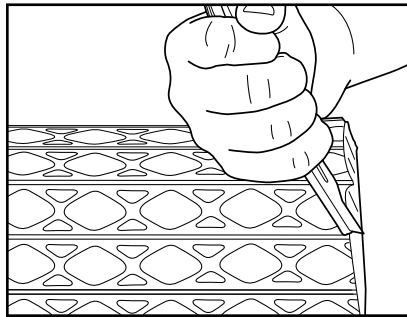
7. Apply a second coat of adhesive to two strips of lagging. Be sure to apply adhesive to the edges of the lagging as well.



8. After the second coat has reached the appropriate tackiness (follow adhesive manufacturer's recommendation) install one strip of lagging. Use the perpendicular line to assure that the strip is square to the pulley. Working out from the center of the strip, use a dead blow hammer or pneumatic sand rammer to remove air gaps. Repeat this process with a stitcher to remove air gaps from the drainage grooves.

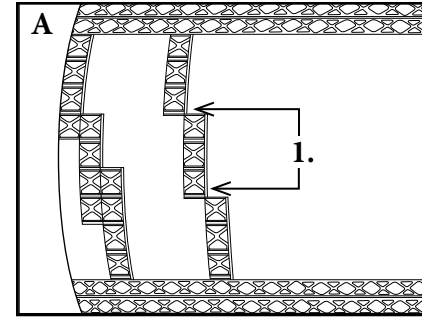


9. Place the second strip of lagging against the first taking care to ensure there are no gaps between the lagging. This may require additional stitching between strips to remove any gaps. Repeat the tamping and stitching process in step 8 to remove air gaps from the applied strip.

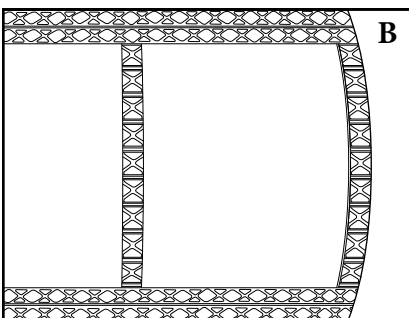


10. Trim the excess lagging from applied strips at the edge of the pulley. Trim lagging at an angle up and away from the pulley edge. Coat cut edge and joint area between lagging strips.

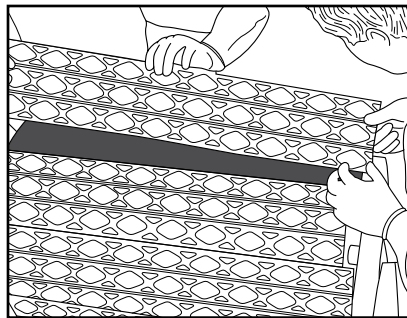
*Repeat steps 6 through 10 until only 3 or 4 strips of lagging remain.*



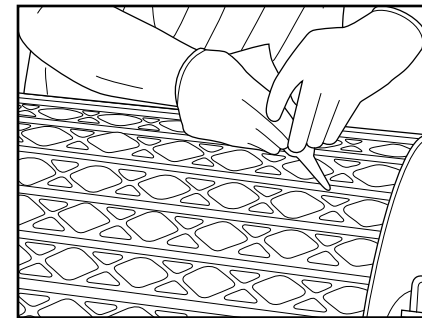
11(A). To lag the remainder of the pulley, position cut off pieces of lagging from step 10 and position in the unlagged portion of the pulley. Manipulate pieces to determine trim requirements (1.) Trim pieces at gutters as required for proper fit



11(B). Test fit sample pieces at both edges and at pulley center to ensure optimal fit. Use trimmed test fit pieces as templates for trimming the final strips of lagging.  
**Note:** Final strips of lagging should not consist of less than 3 rows.



12. Follow steps 6 through 10 to install remaining pieces. The final piece of lagging (the largest of the final pieces) should drop into position. You may want to check the fit of the last piece prior to applying the second coat of lagging.



13. Seal any gaps between the lagging strips with rubber sealer.



2525 Wisconsin Avenue • Downers Grove, IL 60515-4200 U.S.A.

Telephone: 1-630-971-0150 • Fax: 1-630-971-1180 • E-mail: info@flexco.com • Web: www.flexco.com

Australia: 61-2-9680-3322 • China: 86-21-33528388 • England: 44-1274-600-942  
Germany: 49-7428-9406-0 • Mexico: 52-55-5674-5326 • South Africa: 27-11-608-4180

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