



Pos-A-Seal Skirtboard

Installation Guide

1. DCI Protector Plate must be installed prior to installation of the Pos-A-Seal Skirtboard.
2. All existing Skirtboard Brackets and rubber seal should be removed. Any rough edges or material left on the chute that may interfere with the installation of the new bracket should be ground smooth.
3. The installation of the DCI Skirtboard bracket should start from the tail end. The best means to determine the proper location of the bracket is to cut a sample piece of rubber and place it in the bracket to be installed. Hold the bracket approximately 8" up to the chute extension side and when the proper fit, as outlined below, is reached make a chalk mark along the top of the bracket on the chute extension. Then measure from the conveyor belt up to the chalk mark, making sure the measurement is taken above an idler. Using this measurement make a chalk line the full length of the skirting to be installed. Note: If the conveyor angle changes during the run the chalk line will have to change accordingly. Weld the first bracket in place. The next bracket piece to be installed should butt up against the first bracket making sure the breaks in the metal match as close as possible. The sample rubber should be used periodically to make sure the proper fit is maintained throughout the length of the installation.

Bracket Guidelines:

1. The bracket should be held at an angle to the chute and adjusted up or down to obtain a minimum one inch gap between the protector plate and the skirtboard rubber. *The gap is called the clean out area. Also, the bracket location should allow approximately one and a half to two inches of the surface to surface contact between the skirtboard rubber and the conveyor belt. When this position is obtained tack weld the bracket in place and position the next bracket in place and tack.
2. The larger the clean out area the better the system will operate. Preferably one and a half inches or more but make sure the proper seal between the skirtboard rubber and the belt is maintained.
3. When all brackets are located correctly finish welding to the chute using approximately a three inch stitch weld centered between each pin holder. Weld the brackets together at the butt seam with a three inch weld measuring from the top down.

4. Repeat the above steps for the remaining brackets.
5. After all the brackets are welded in place run a bead of high grade silicone sealant, preferably 100 percent silicone, along the skirtboard bracket where there are no welds to prevent any dust from escaping.
6. After all brackets have been welded and silicone applied the rubber can be installed. Remove the rod holders from each bracket and slide the rubber into place along the belt. The bulb on one side of the rubber is considered the top of the rubber and this bulb should face toward the bracket. Starting from the tail end, hold the rubber in place and insert the rod holder and pin in place. Pull all slack out of the rubber as installation progresses. Leave the pin lock rings in the up position. Locking them down will cause the pins to work out of the hole. Repeat this process for each rod holder until all rubber installed. After all rubber is in place take a rubber mallet and beat the rubber down along the top into the skirtboard rod to ensure a tight fit. This will help prevent the rubber from sliding up the conveyor.
7. Pieces of foam rubber are placed in the ends of the brackets at the tail section to prevent dust from escaping during operation.

Note: These are typical installation guidelines and should be followed. However, these guidelines may have to be modified at times to allow for the variances in chute designs. Each job has to be examined to determine the appropriate installation guidelines.