

9 Make sure the rivets are completely through the holes in the link belt and locked in position. Cut the tag end off each rivet so it does not protrude past the tab on the link belt. See Figures 10 and 11.

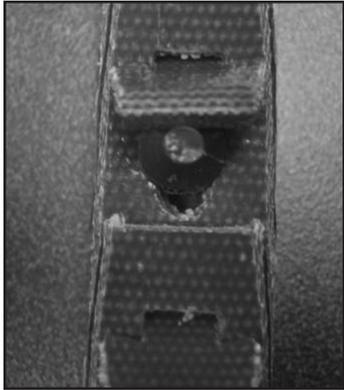


Fig. 10

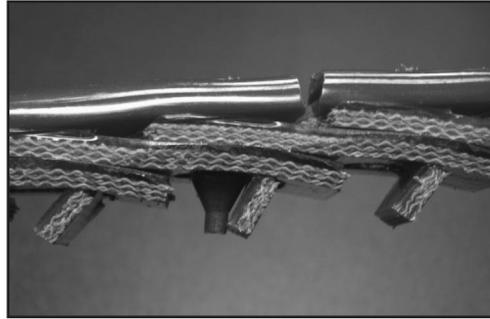


Fig. 11

10 A completed splice is shown in Figure 12.

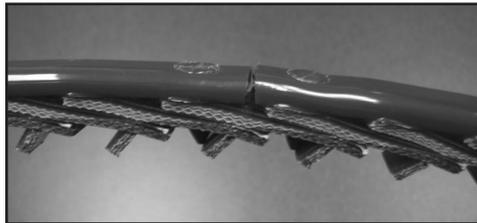
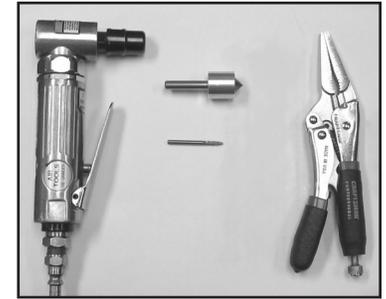


Fig. 12

Installation Instructions

The following tools are needed for the installation:

1. High speed (10,000 RPM minimum) rotary tool or die grinder that will accept a $\frac{1}{8}$ " and $\frac{1}{4}$ " shank
2. Needle nose pliers
3. Fenner Drives Tool Kit — consists of $\frac{1}{8}$ " and $\frac{1}{4}$ " burrs



Note: If you are not installing this on a straight or curved live roller conveyor, proceed to step 4.

1 Adjust the take-up idler(s) to the minimum travel position to accommodate, if necessary, later belt adjustment and retensioning. See Figure 1.

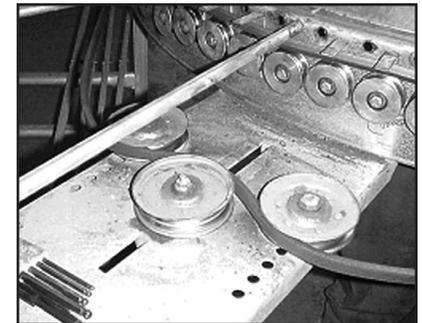


Fig. 1

2 Adjust the snubber pulleys to provide the maximum distance between the pulley and the roller and remove the rubber V belt. See Figure 1.

3 Remove at least two rollers at the drive end for ease of starting the belt between the snubber pulleys and rollers.

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- 4 Determine hand tight length by pulling belt tight around all pulleys, overlapping the last two tabs with two holes in matching links.
Determine installed length by counting the number of links and removing approximately 1–2%. Mark the desired length and then cut through only the cushion top and disassemble the link portion. To disassemble, hold belt upside down. Bend back as far as possible; hold with one hand. Twist one tab 90° parallel with slot. Pull end of link over tab. Rotate belt end with tab 90°. Pull belt end through two links.

- 5 Insert the $\frac{1}{8}$ " carbide bit into the high speed rotary tool and drill a pilot hole into the cushion portion of the belt. Start the hole from the link side of the belt, making sure the hole is centered in the cushion top. Use the same bit to clean out the hole from the cushion top side. Repeat on second endpiece. See Figures 2 and 3.

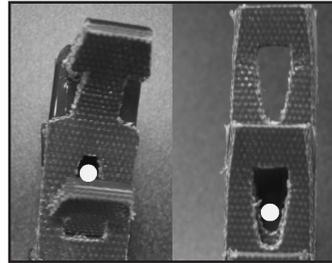


Fig. 2

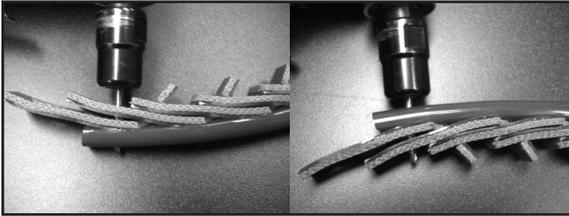


Fig. 3

- 6 Insert the $\frac{1}{4}$ " countersink burr into the high speed rotary tool. Place the countersink burr into the pilot hole in the cushion top to form the countersink. When the stop on the burr bottoms against the cushion top, quickly remove the burr as the countersink has now been formed. Repeat on second endpiece. See Figure 4.

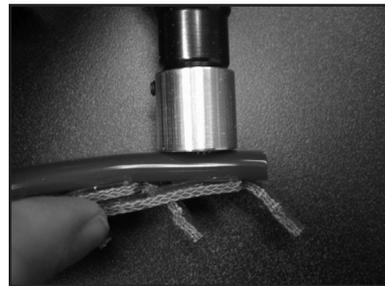


Fig. 4

Warning: Do not rock or rotate the burr. Doing so will elongate the countersink hole, resulting in possible rivet pull-out or cushion top cracking.

- 7 Place the belt on the pulleys in the drive. Assemble the belt by placing tab end through two links at once; see Figures 5, 6, and 7. Flex belt further and insert second tab through end link; twist 90° to secure.

Note: Needle nose pliers will help with twisting and securing the tab.



Fig. 5

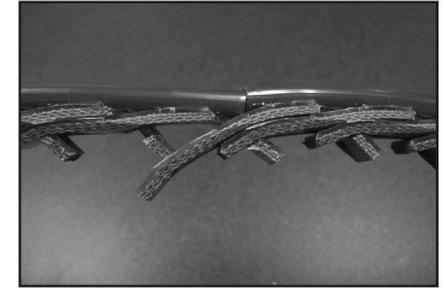


Fig. 6

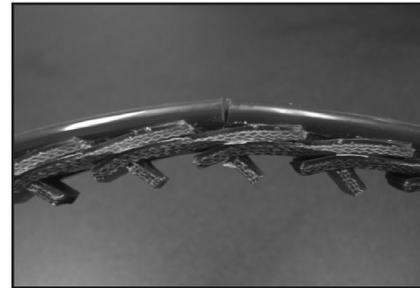


Fig. 7

- 8 Place rivet (see Figure 8) into the countersink hole in the cushion top and push in with thumb. When the tag end on rivet is through on link belt side, use the needle nose pliers to pull the rivet through while pushing with thumb. Repeat on other side. See Figure 9.



Fig. 8



Fig. 9