

REPLACING A MERGEPRO BELT

1- Rotate the belt to place the alligator seal on the outer roller ring



2- Dismantle the following guard



3- Remove tension on the belt by pulling the handle



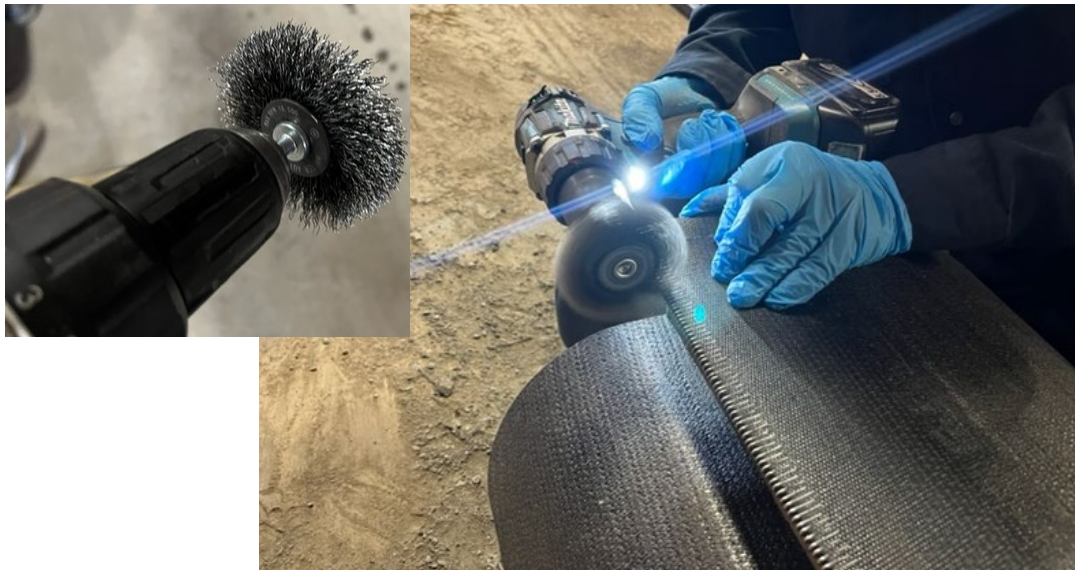
4- Pull the lace and remove the strap



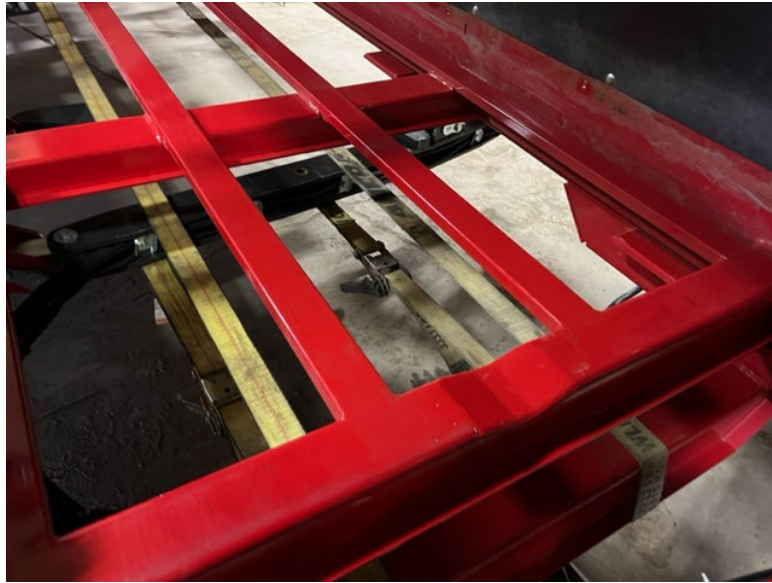
5- Push the traction roller as far inwards as possible. Remove the pin from the belt tensioner system to complete this step.



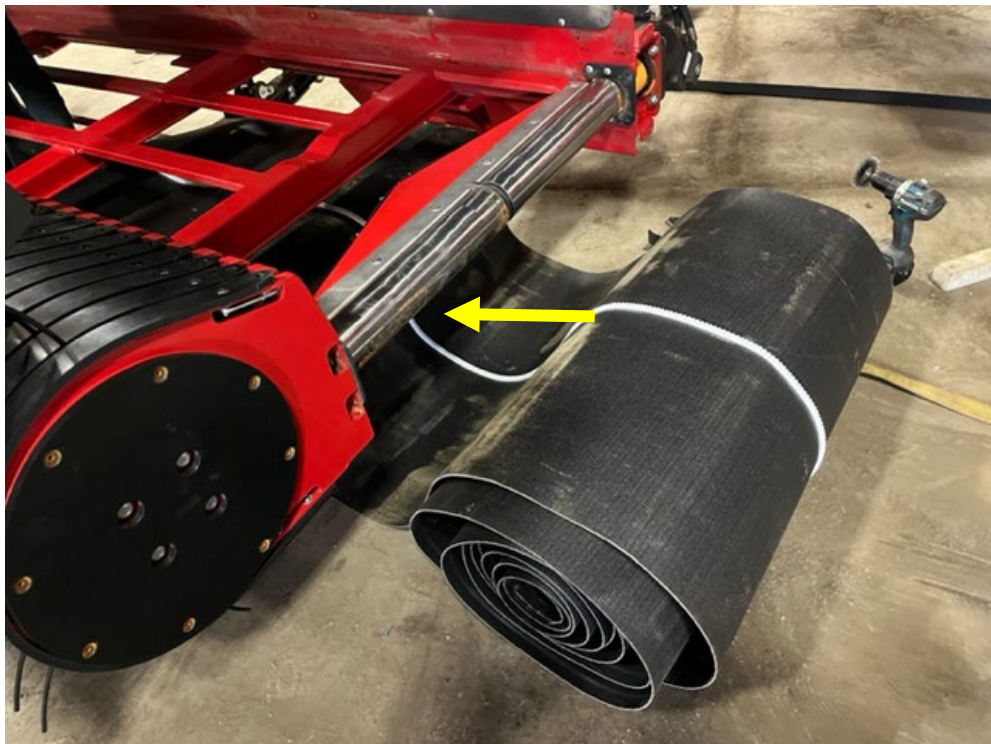
6- Clean the inside of the alligator clips using a soft steel brush. Apply only light pressure to the alligator clips if you overheat you will damage the belt.



7- Install two straps under the belt frame. These will serve as a support to slide the belt. See steps 29 for another view of the installation.



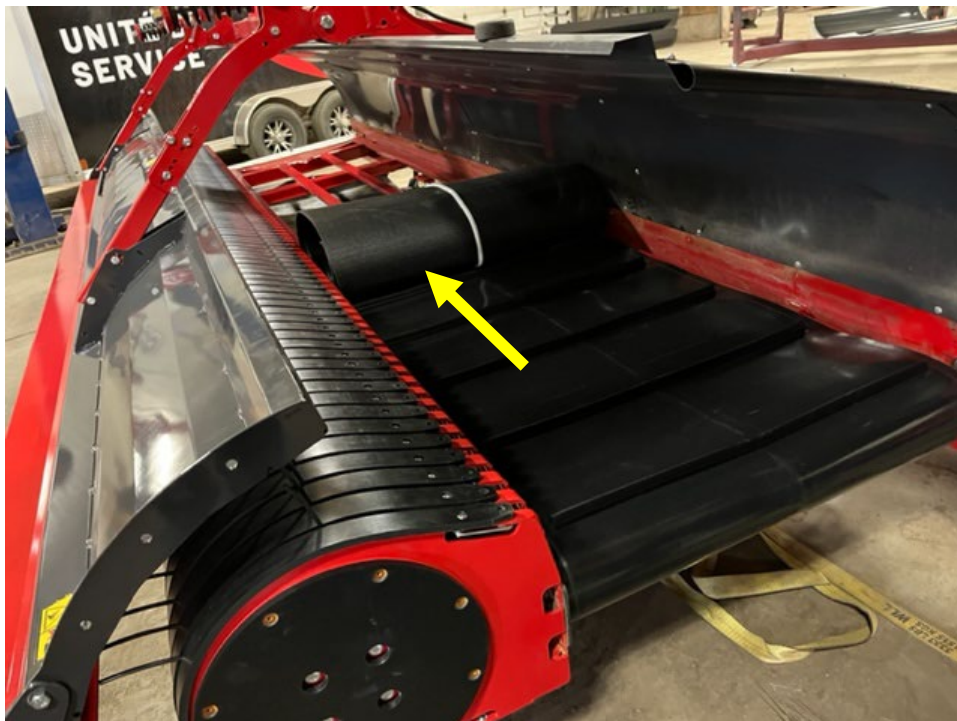
8- Slide the new belt over the two straps.



9- Pull the belt to the other end of the unit. This operation is easier with two people.



10- Take the other end of the belt and unroll it on the upper part of the unit.



11- Place the belt joints in the center of the transversal frame of the unit. We will use this one as a support to slide the lace into the alligator joints.



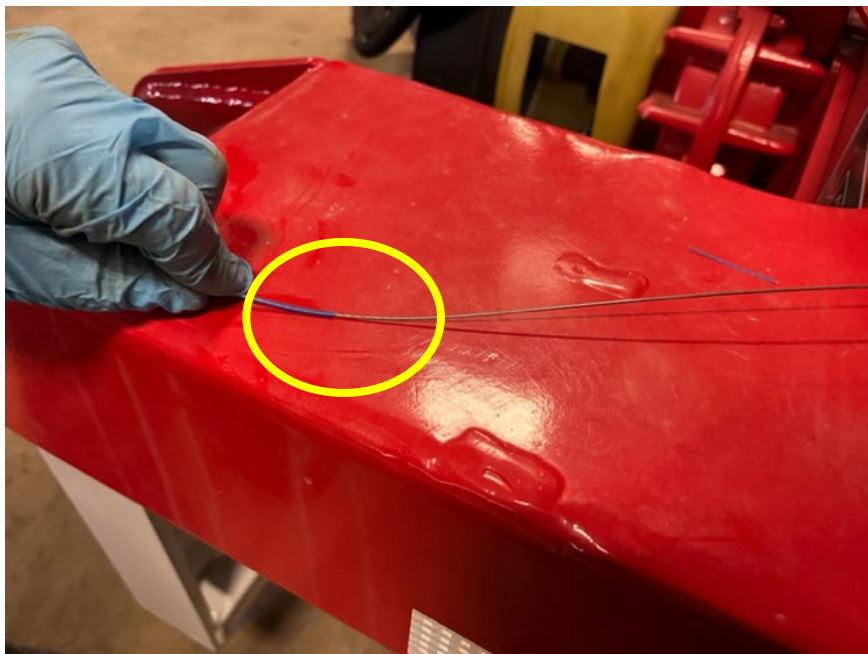
12- Make sure the new lace is at least twice the length required to cover the width of the belt.



13- Remove the lace sheath over half its length. Make sure that the unsheathed part will cover a little more than the entire width of the belt.



14- Make a clean cut in the sheath to avoid any fraying.



15- Align the two corners of the belt.



16- Insert the unsheathing part of the lace into the alligator clips.



17- Make sure the alligator seal is seated on the transversal frame. Align the joint clips of the belt and push the lace inside.



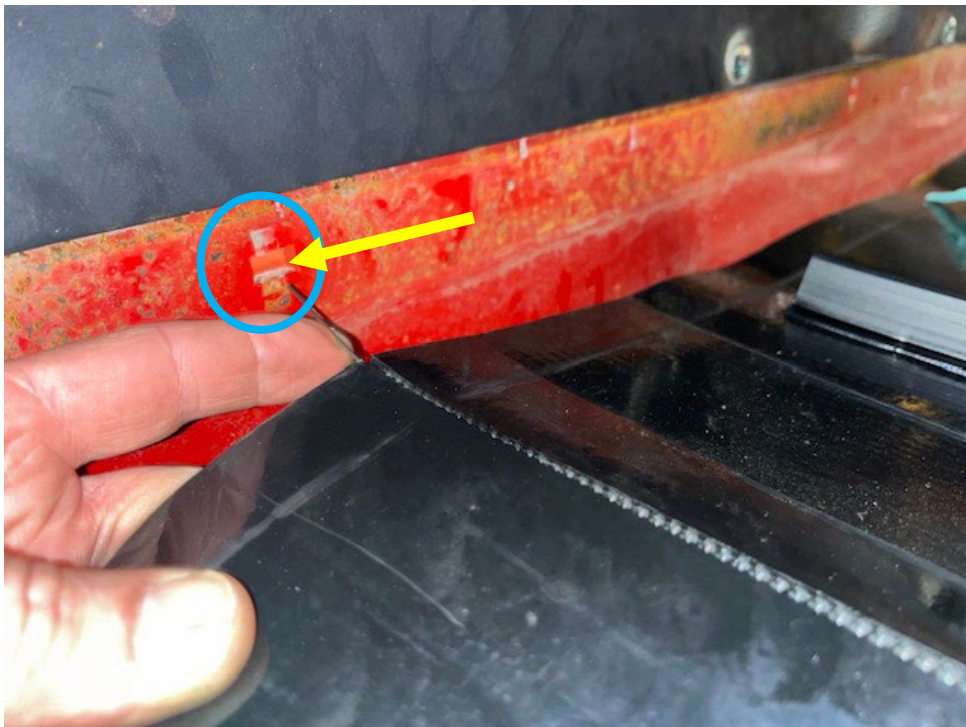
18- You can use pliers. Push the lace half an inch at the time. If you exceed this length, you risk bending the lace when pushing it.



19- Lubricate the alligator seal in a small amount. Do not lubricate the section of the lace which is not yet entered, you pliers may slip.



20- Align the lace into the hole in the back wall.



21- Make a curved hook on the other end of the lace that is sheathed.



22- Pull the unsheathed lace outside the wall. Use pliers to carry out this step.



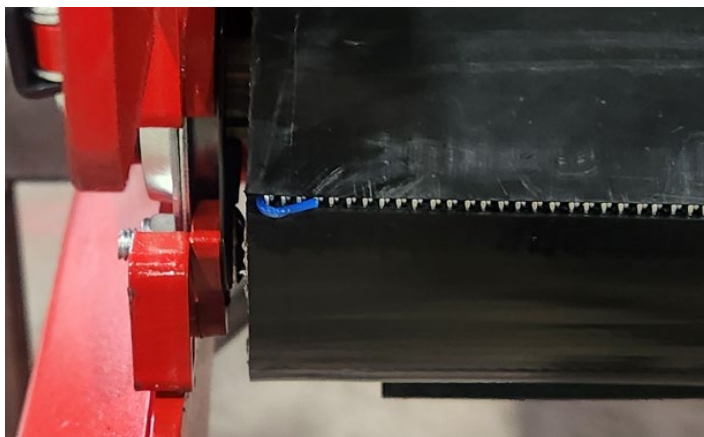
23- Stop pulling when the sheathed hook is at the edge of the belt.



24- Cut the lace on the other side at about 1/2" long.



25- Make a hook on each side.



26- Align the guide under the belt in the center of each traction roller.



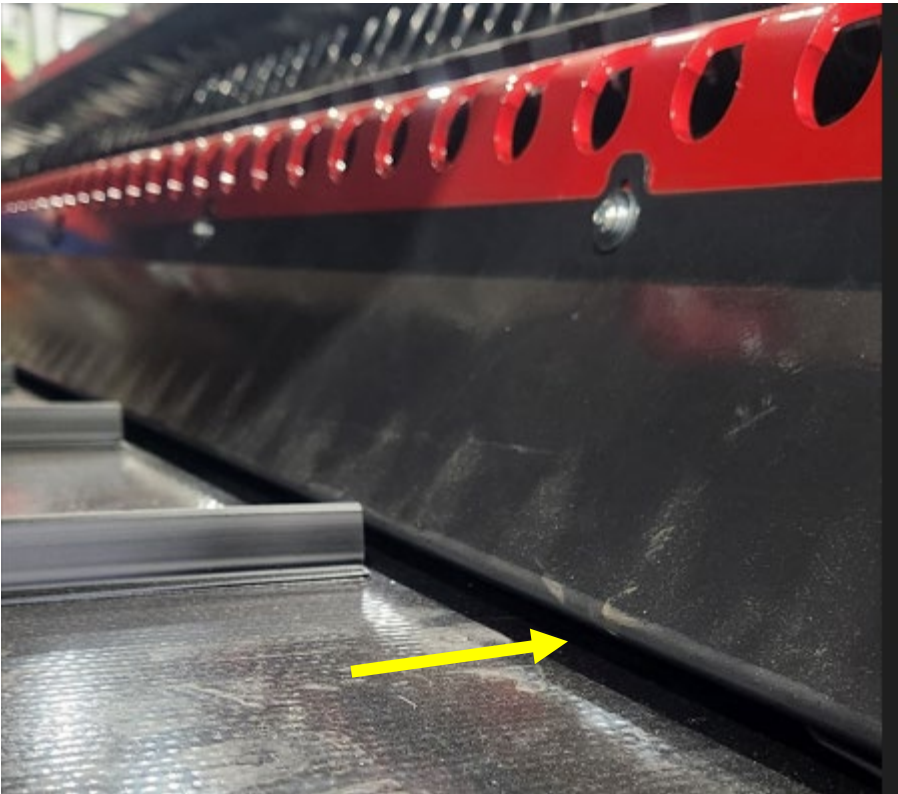
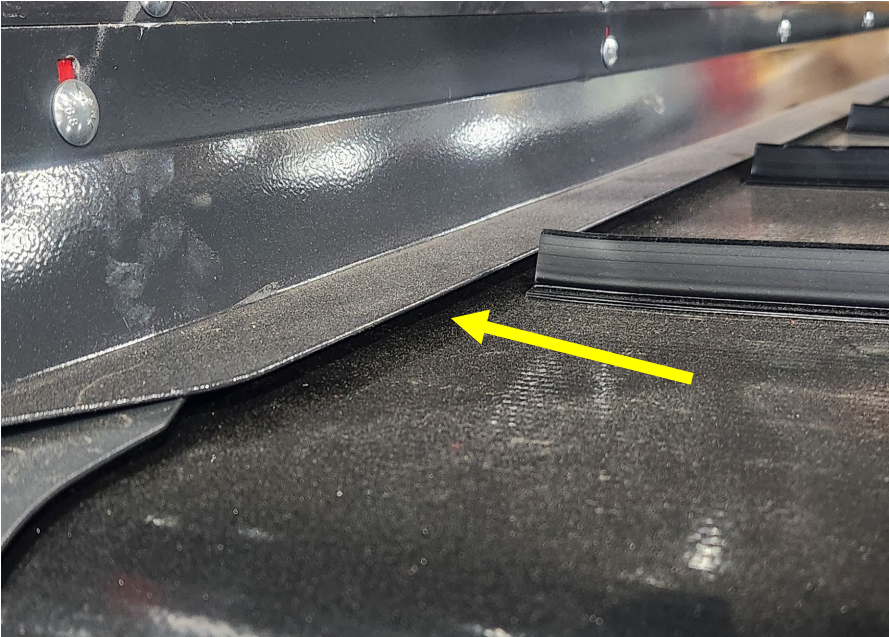
27- Reassemble the belt tensioner and adjust the tension of the belt.



28- Reinstall the guard below.



29- Adjust the plates to ensure there is at least ¼” of space everywhere between the plates and the belt.



30- Fold the machine into transport position and remove the support strap.



31- Replace the belt in its guides.

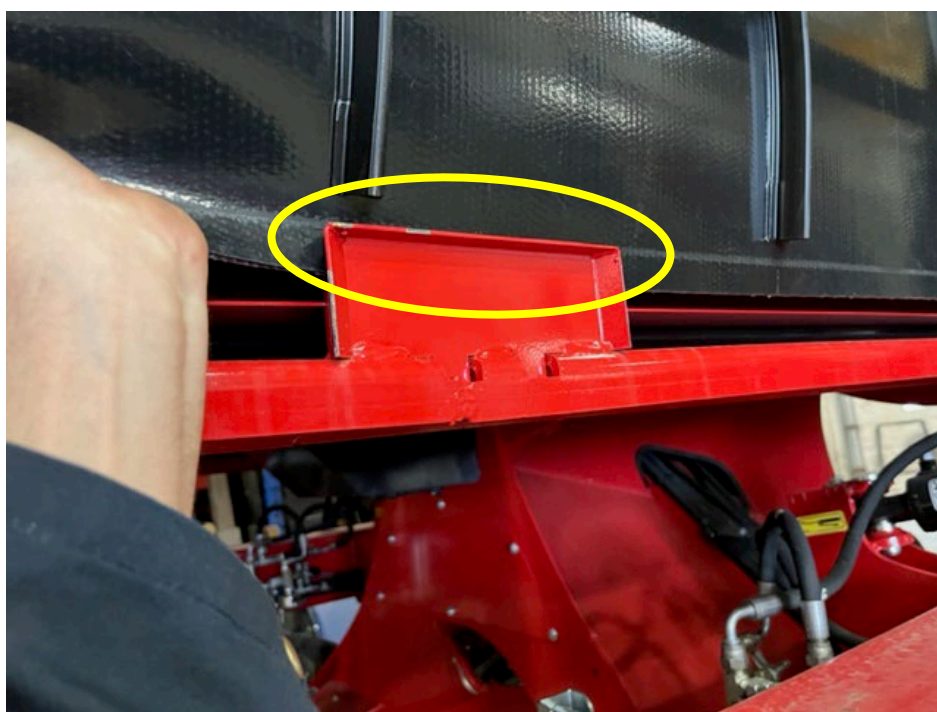


32- Belt outside its guide.



33- Belt inside its guide.

*****MAKE SURE TO REPLACE THE BELT IN ALL OF HIS GUIDES*****



34- Lower the pickup unit

35- Start the conveyor

Check the belt alignment.

Check if the belt guide under the belt remains in the traction roller cavity.



*****Stay away from the belt during inspection*****

*****Risk of serious injury*****

36- Stop rotation and check belt tension.

If you change the tension, make sure that the belt is nice and well in its guides after readjustment