

REPLACING A MERGEPRO BELT WITH HELP OF THE LACE TOOL



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



2- Dismantle the following guard



3- Remove tension on the belt by pulling the handle



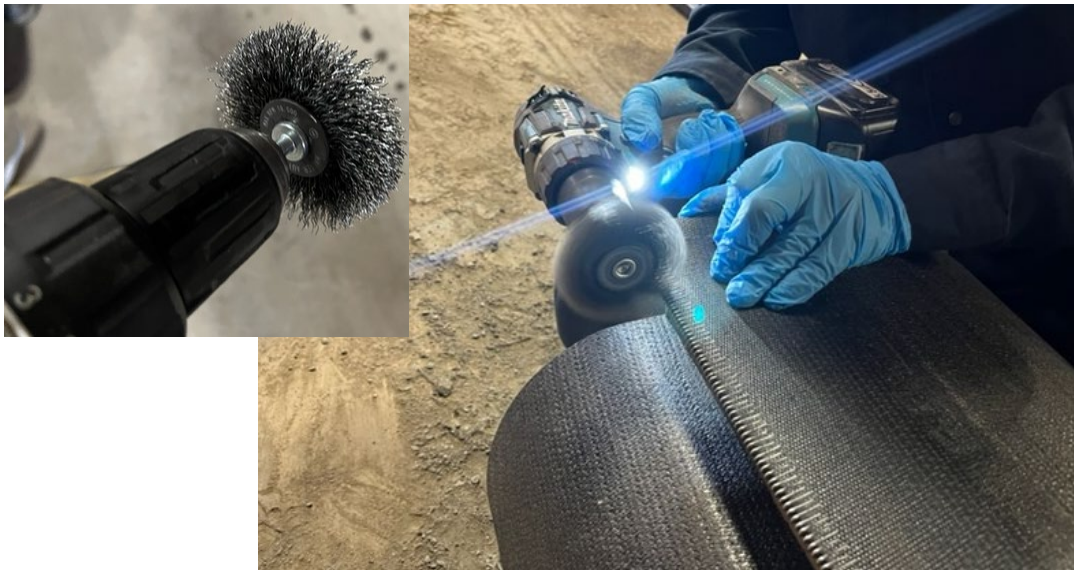
4- Pull the lace and remove the strap



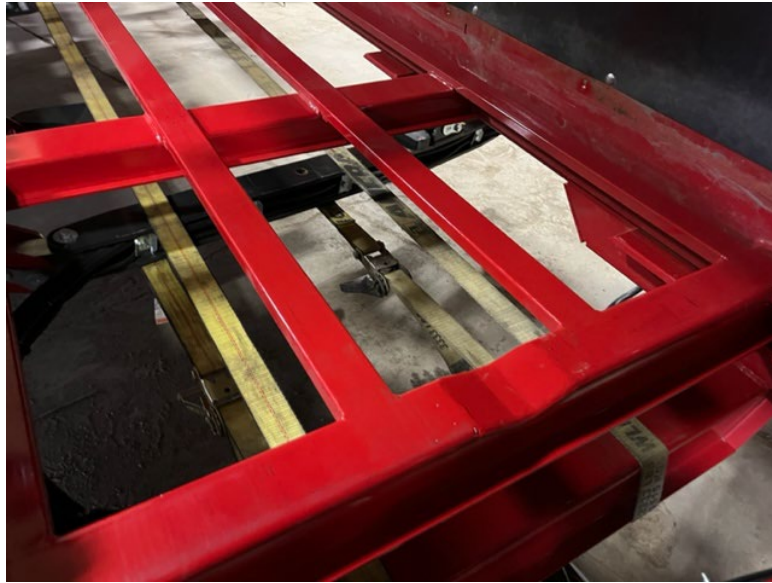
5- Push the traction roller as far inwards as possible. Remove the pin from the belt tensioner system to complete this step.



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.



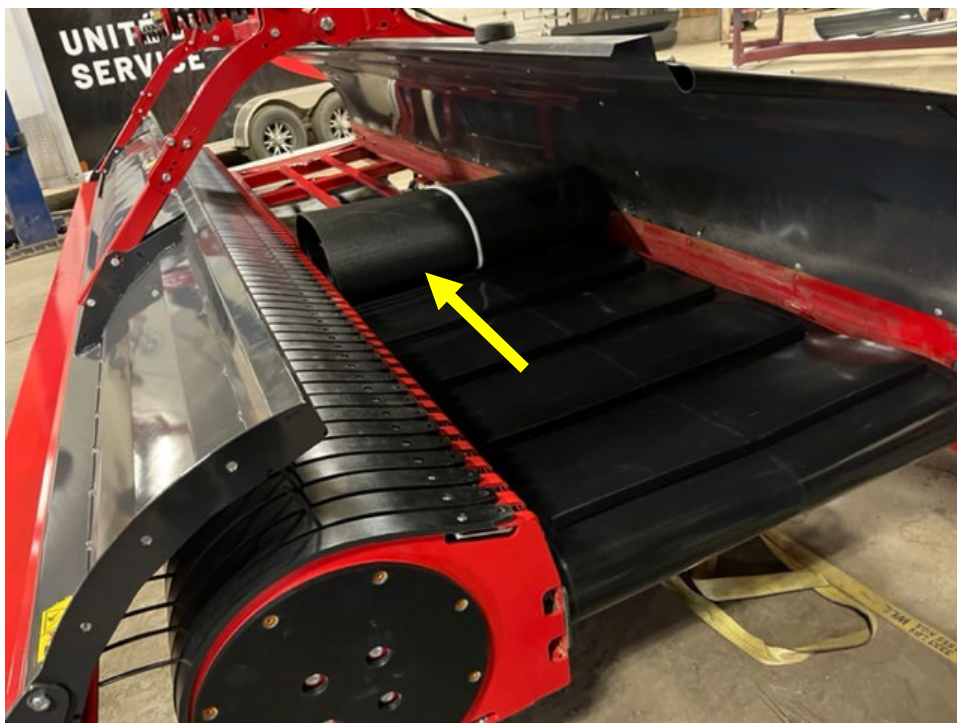
8- Slide the new belt over the two straps.



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 joint over the pulley on the belt adjustment side (outer side of the unit).



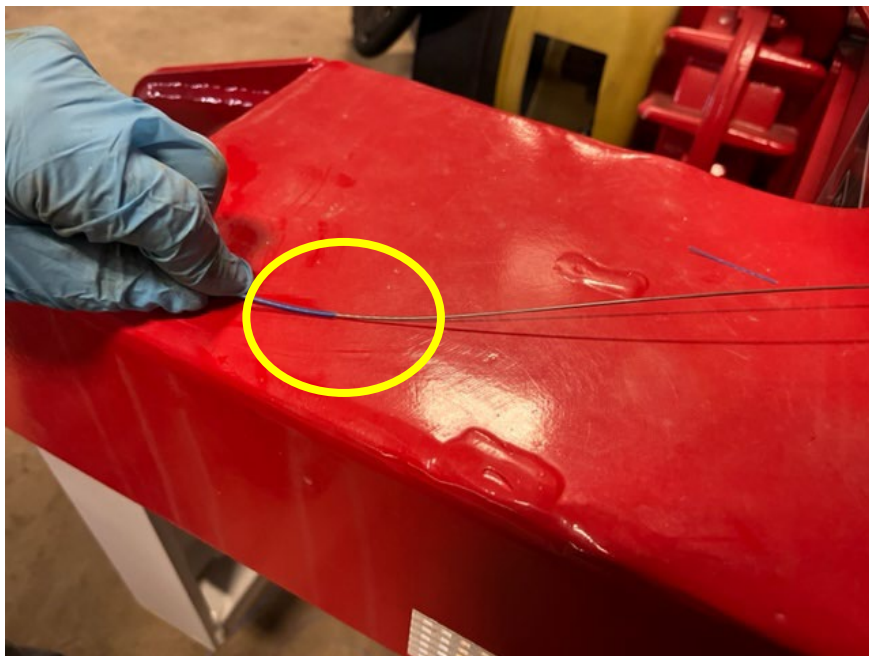
12- Make sure the new lace is at least twice the length required to cover the width of the belt.



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.



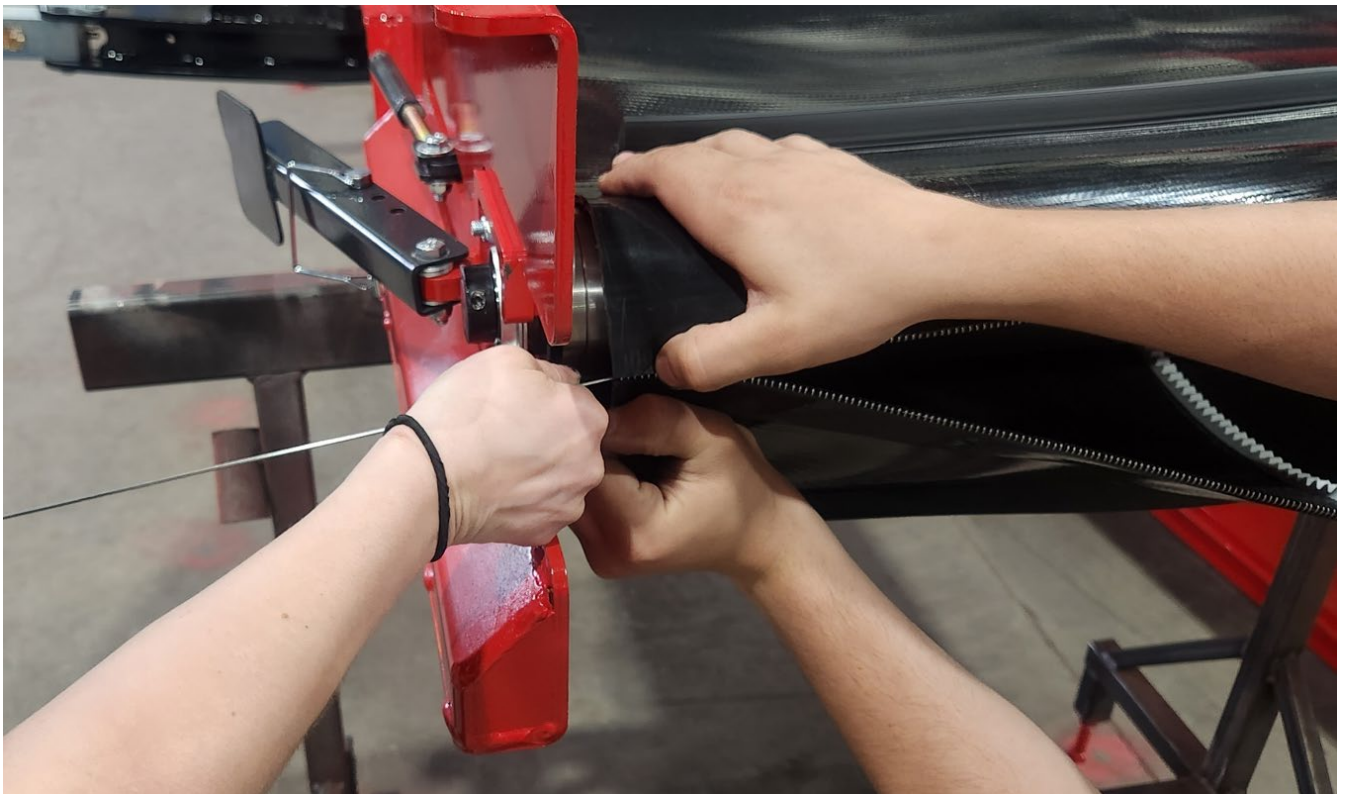
15- Install the passage wire (lace tool) on an electric drill



16- For the next steps it is necessary to be 2 person. Make sure that the belt joint is aligned on the pulley on the adjustment side.

Align the side of the belt.

Insert the wire (lace tool) in the the alligator clips at the same time as the other person align the belt.



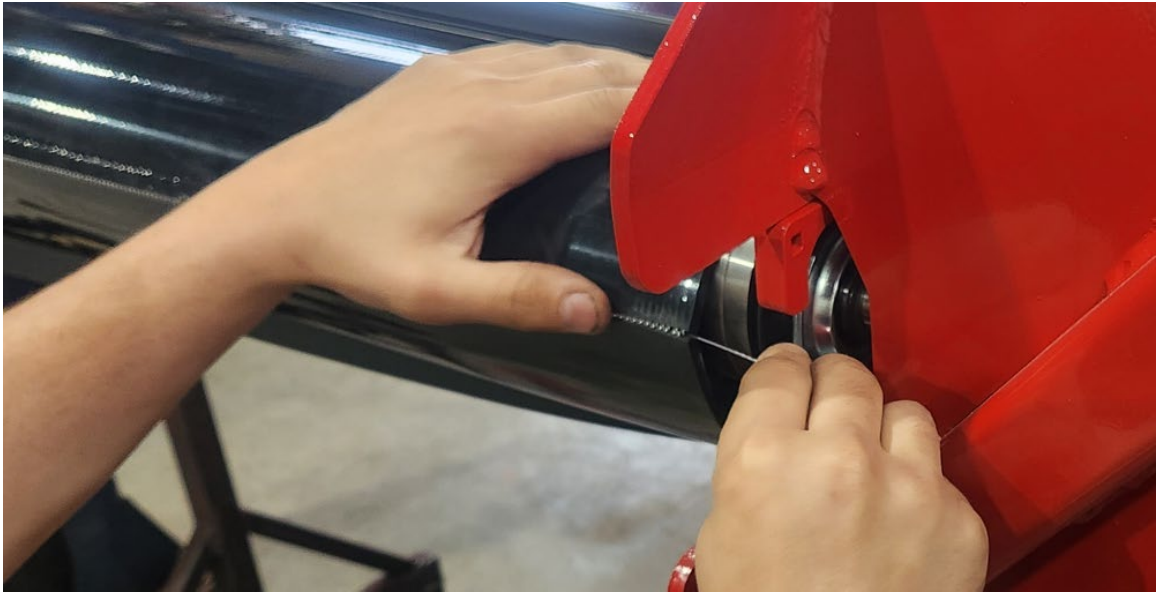
17- To facilitate the passage of the wire (lace tool), slowly rotate the drill while the other person continues to align the belt joint during the passage.



18- Enter the wire (lace tool) until it comes out the other end.



19- Enter the lace on the unsheathed side at the same time as the other person pulls on the wire (lace tool) to remove it. For efficient work, make sure the lace enters at the same speed as the wire (lace tool) exits.



20- If necessary, use pliers to push on the lace. Make sure it comes out the other side, being careful not to bend the lace.



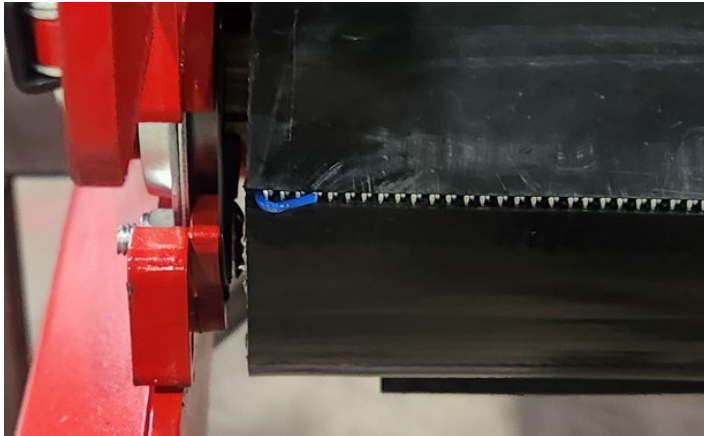
21- Lubricate the alligator seal in small amount.
Do not lubricate the section of the lace which is not yet entered. Your pliers may slip.



22- Use pliers to get a good grip on the lace, then pull to insert the sheathed part into the alligator clips. The person on the other side can help by pushing on the sheathed lace.



23- Cut the lace at each end at approximately $\frac{1}{2}$ inch, then bend the 2 ends of the lace.



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



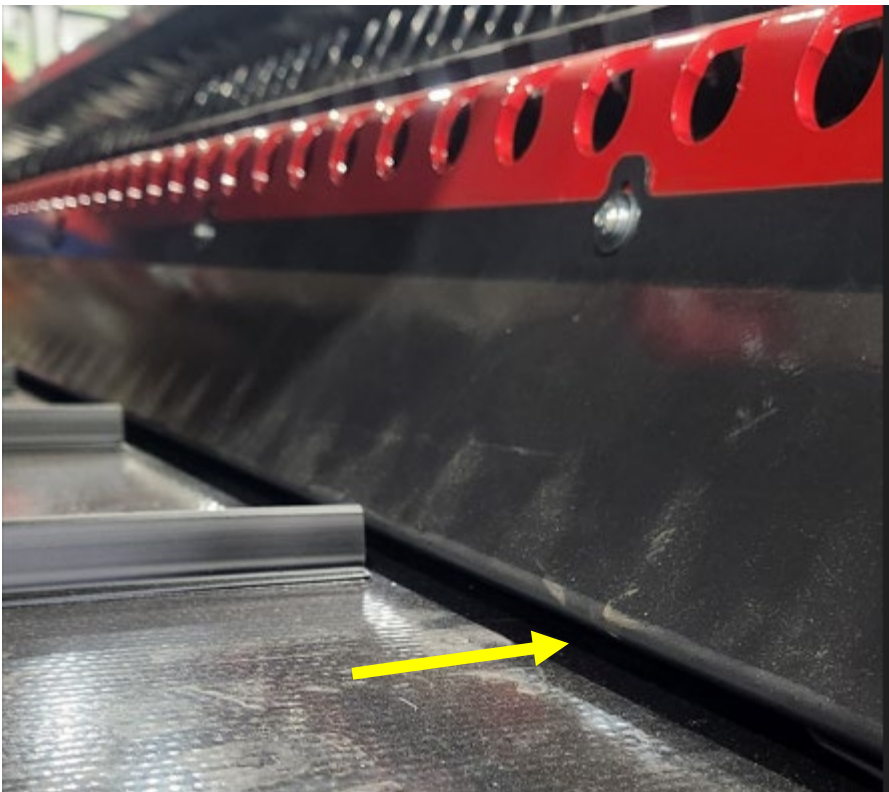
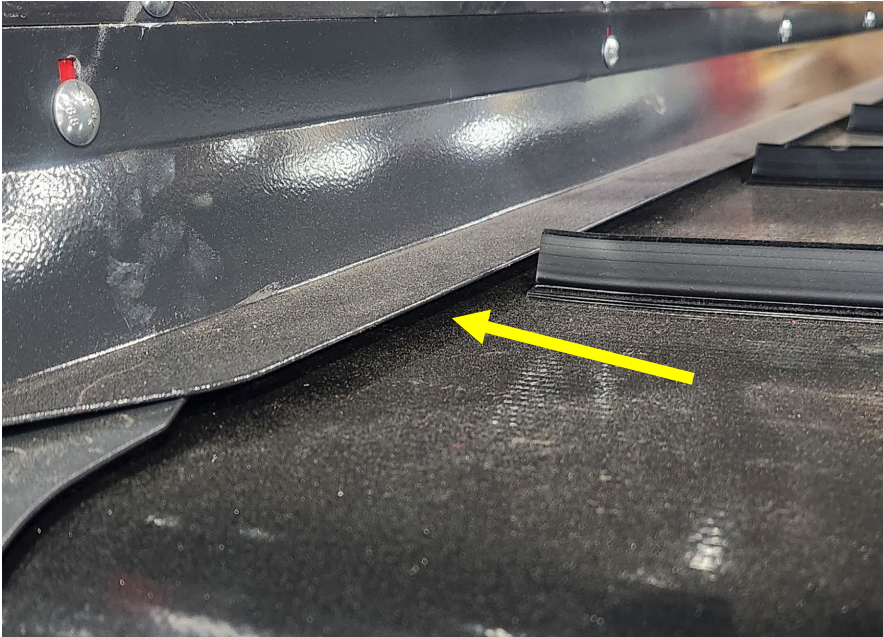
25- Reassemble the belt tensioner and adjust the tension of the belt.



26- Reinstall the guard below.



27- Adjust the plates so that there is a minimum of $\frac{1}{4}$ inch of space everywhere between the plates and the belt.



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



29- Replace the belt in its guides.

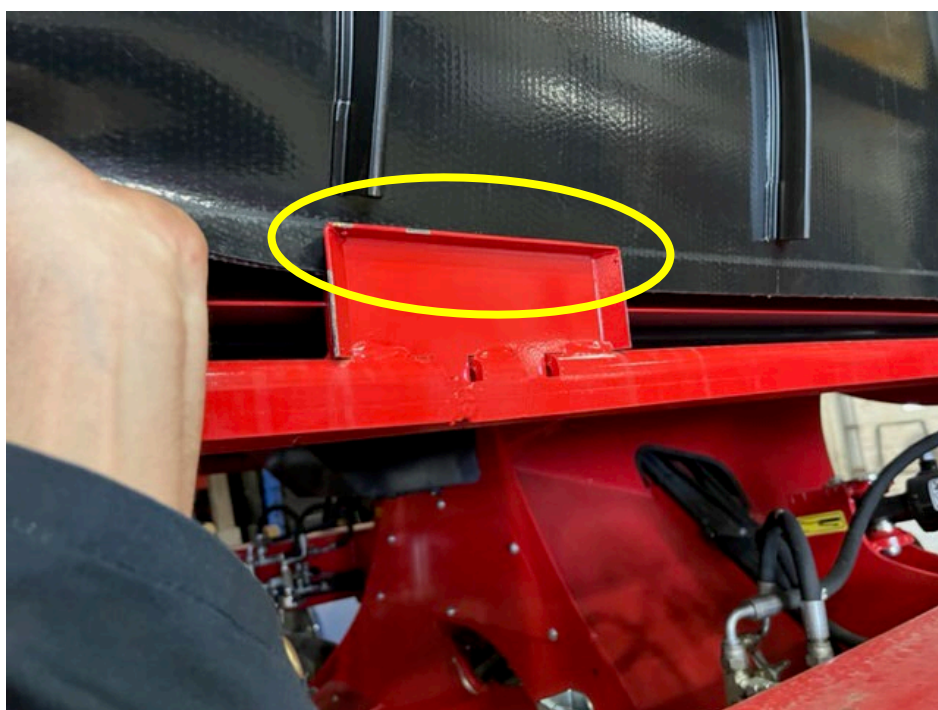


30- Belt outside its guide.



31- Belt inside its guide.

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



32- Lower the pickup unit

33- 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*****

34- 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 (step 29 to 31)