

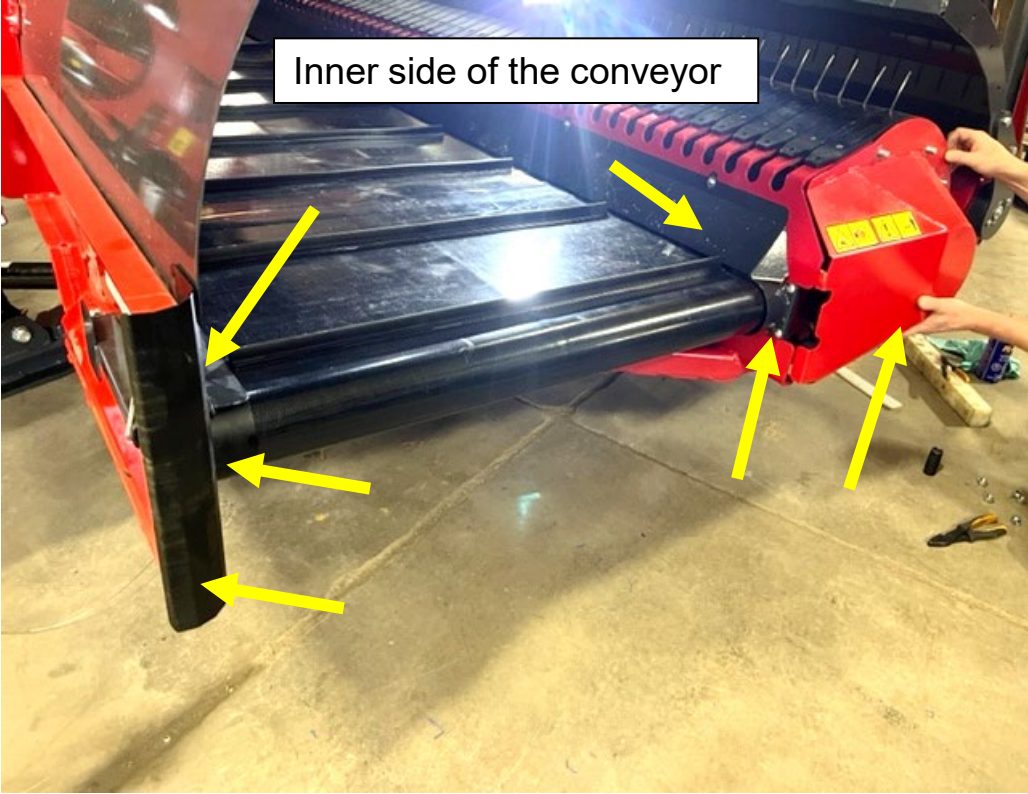
REPLACING A MERGEPRO BELT WITH HELP OF THE LACE TOOL

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

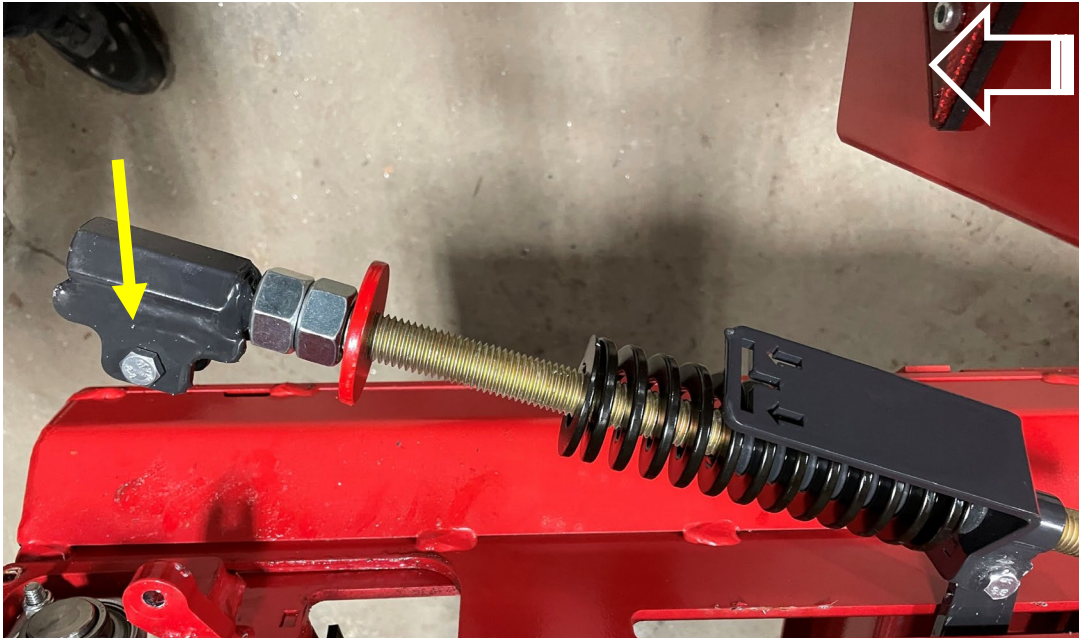
If there is no hole between the 2 welding pass, drill with a $\frac{1}{4}$ drill bit



2- Remove the following guards



3- Take off the tension of the belt by removing the bolt of the stretcher (yellow arrow) by pushing toward the inside of the conveyor (white arrow).



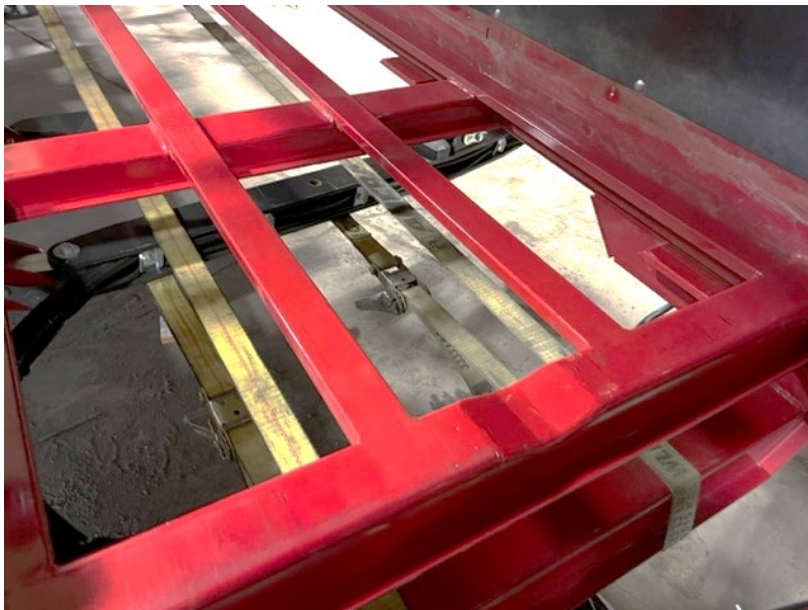
4- Remove the lace by gently pulling on the end toward the hole on the side frame.



5- 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.



6- Install two straps under the belt frame. These will serve as a support to slide the belt. See steps 26 for another view of the installation.



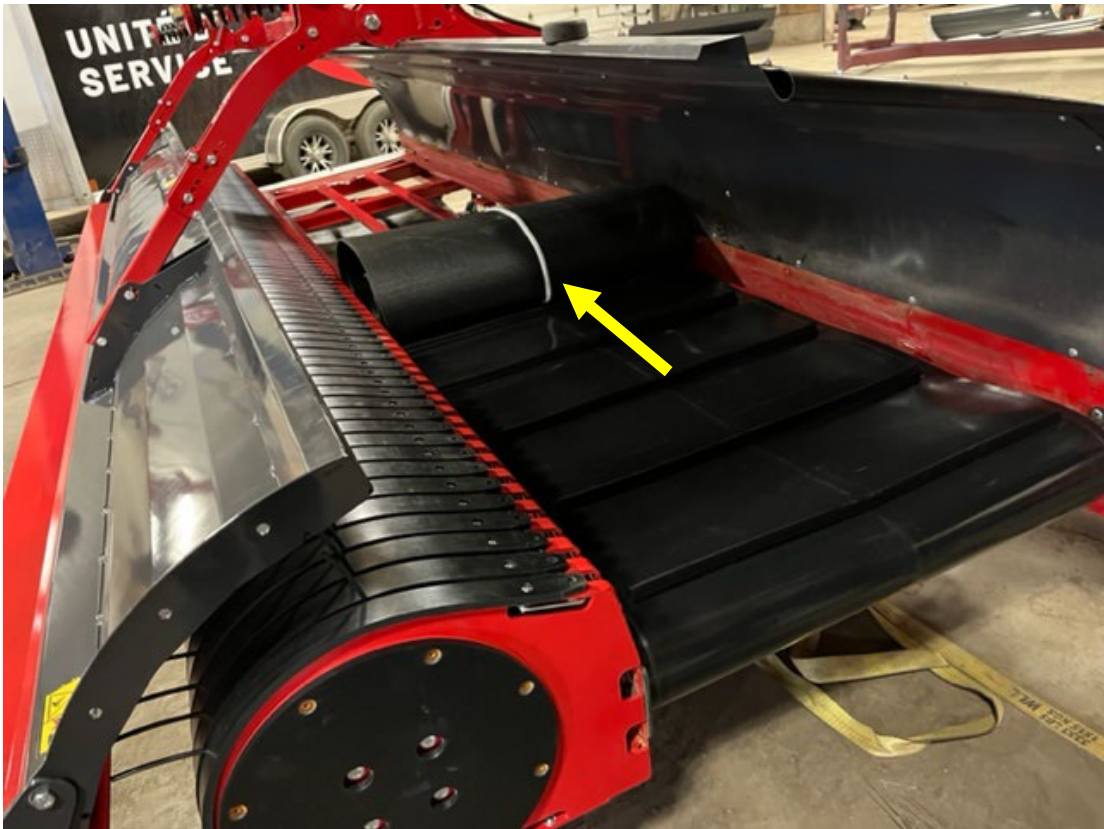
7- Slide the new belt over the two straps.



8- Pull the belt to the other end of the unit. This operation and the next are easier with two people.



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



10- 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.



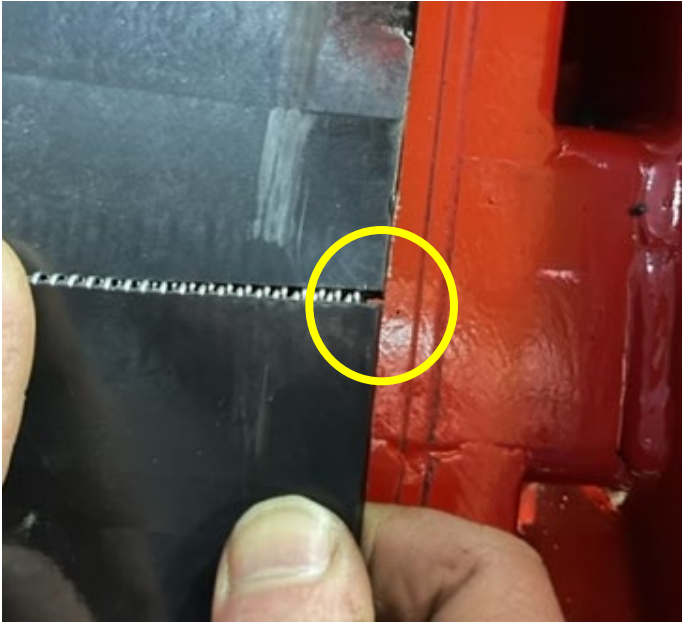
11- Make sure the new lace is at least twice the length required to cover the width of the belt.



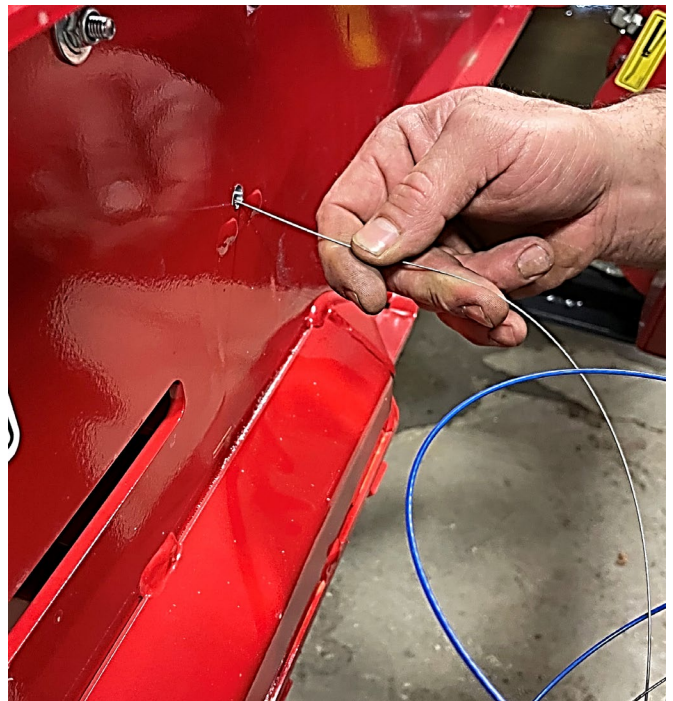
12- Install the provided broach to the drill chuck and set in the hole on the frame.



- 13- Align the 2 corners of the belt to insert the broach.
Turn the drill slowly while the second person continue to seam the joint during the insertion.



- 14- Once the broach is completely inserted, install the drill on the other end of the broach. Insert the bare lace in the hole then proceed as in the previous step to slip on the lace.



15- Push the lace inside the joint while properly removing the broach from the drill side.



16- 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.



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



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. A second man can help by pushing on the sheathed side.

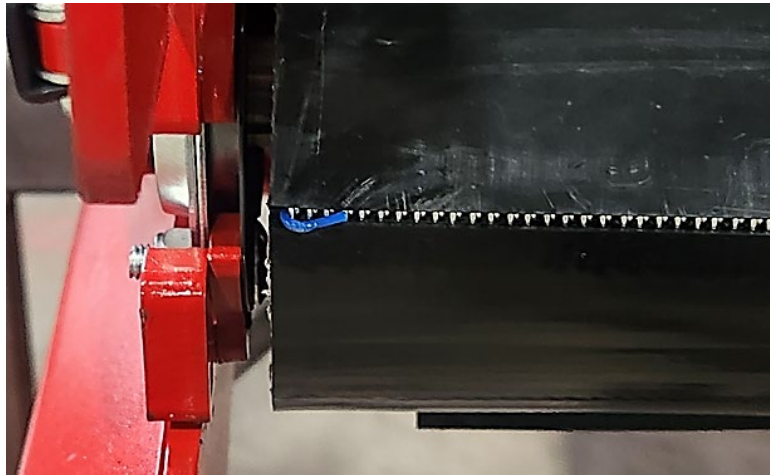


19- Stop pulling when the sheathed hook is at the edge of the belt.

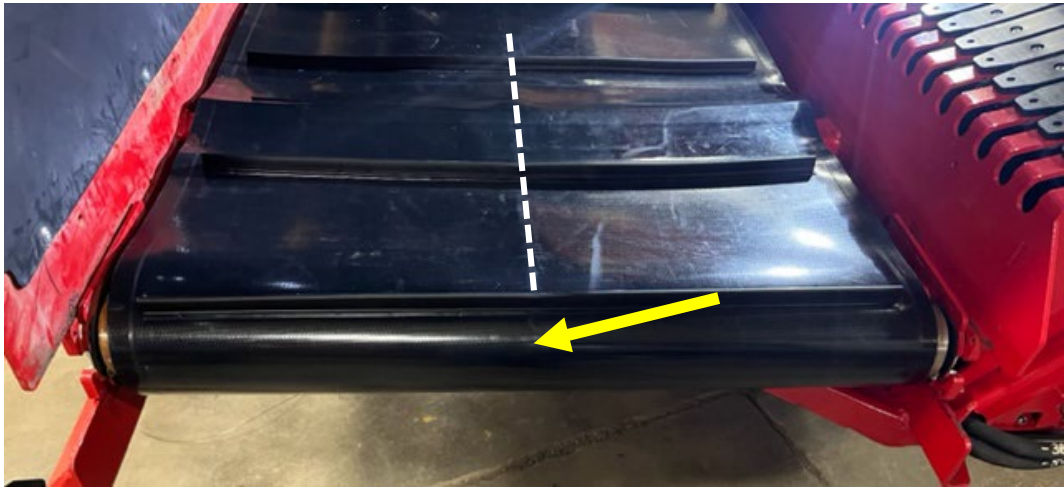
20- Cut the lace on the other side at about ½” long.



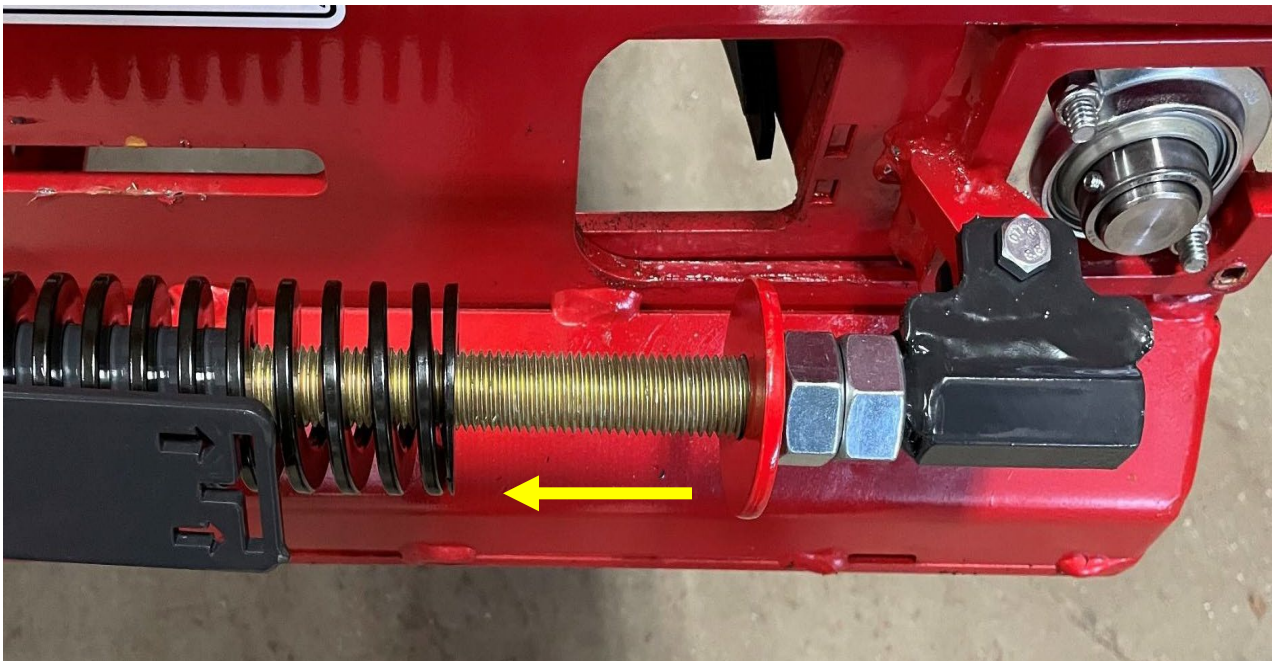
21- Make a hook on each side.



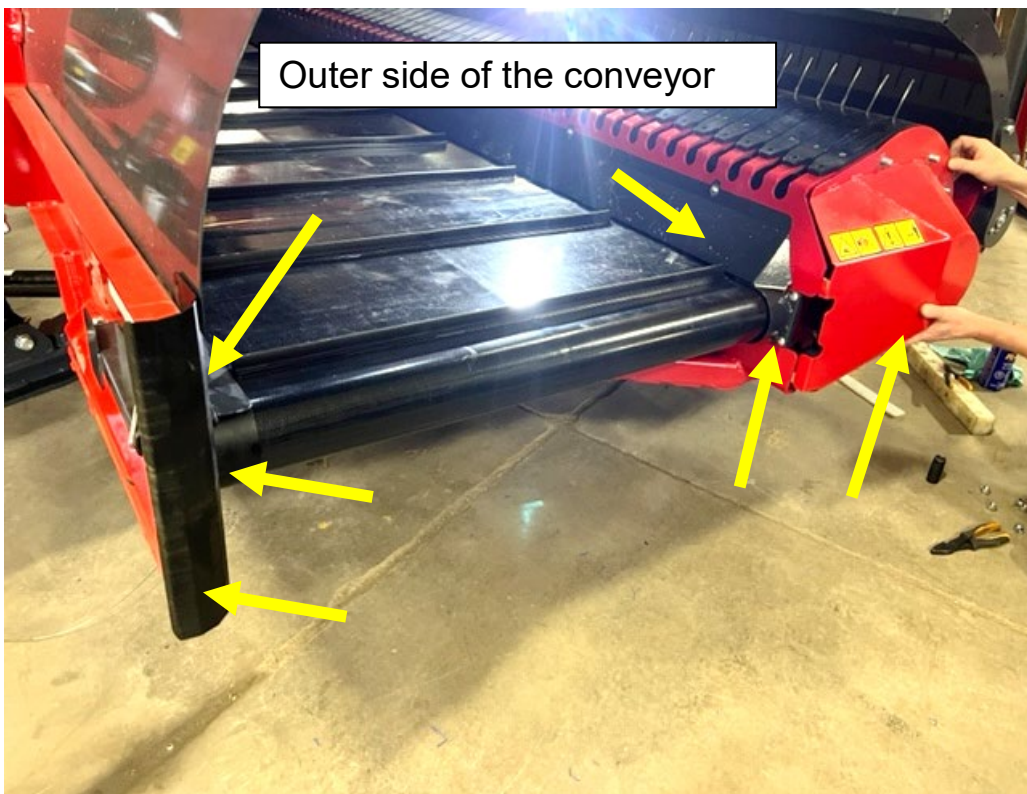
22- Align the guide under the belt in the center of each traction roller.



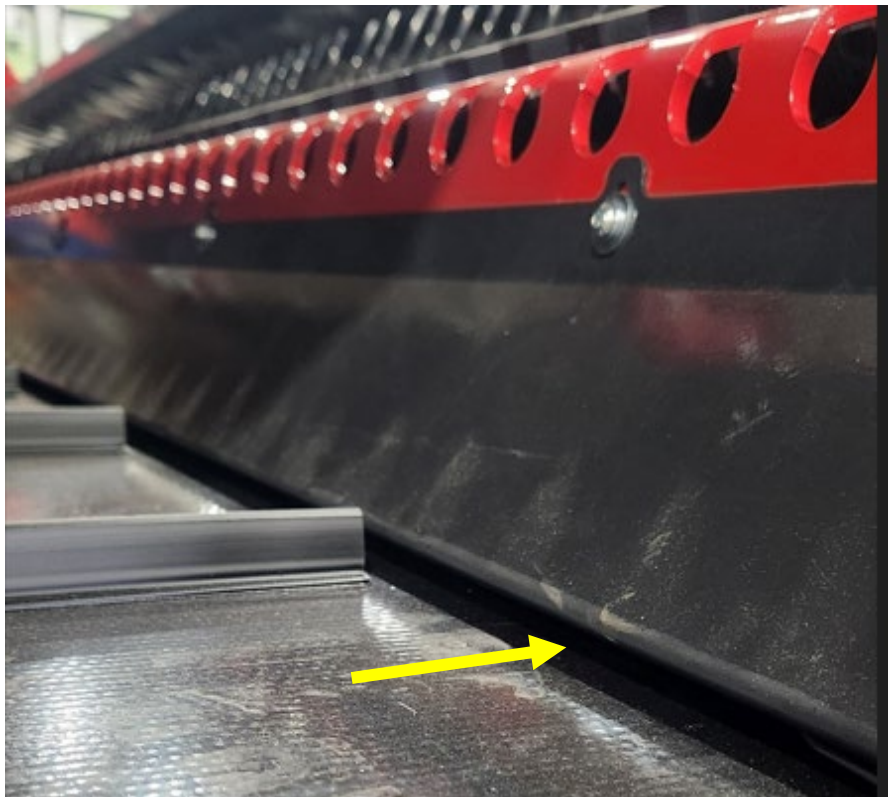
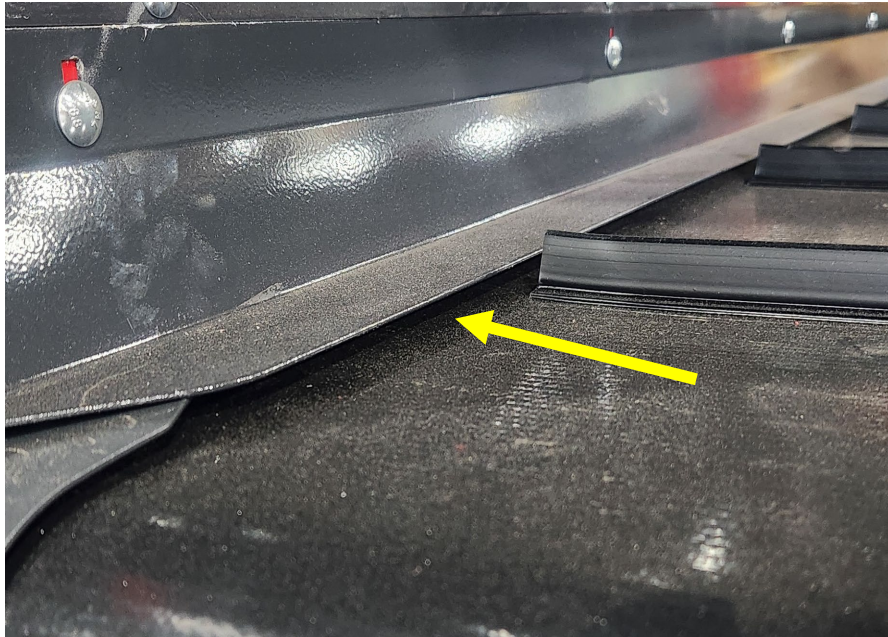
23- Reassemble the belt stretcher and set the tension with the 2 nuts as identify below.



24- Reinstall the following guards.



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



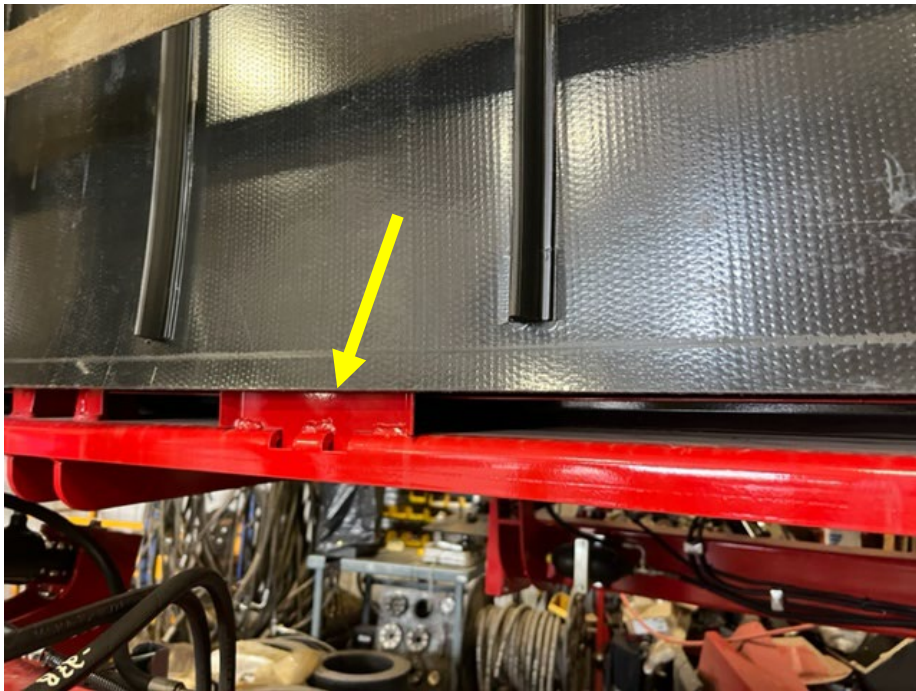
26- Fold the machine into transport position and remove the support strap.



27- Replace the belt in its guides.

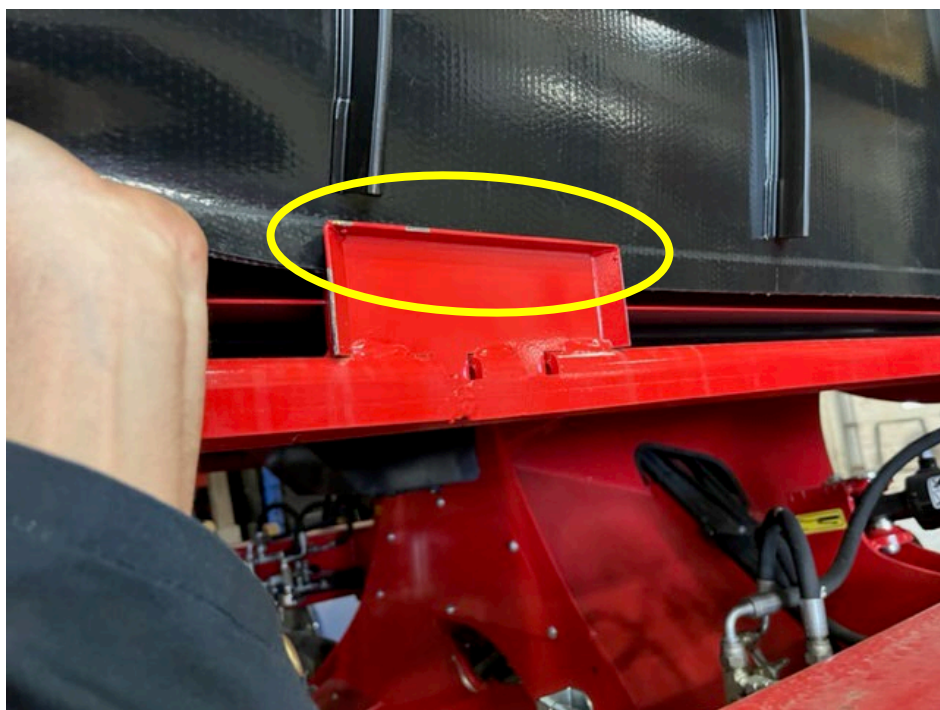


28- Belt outside its guide.



29- Belt inside its guide.

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



30- Lower the pickup unit.

31- 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*****

32- Stop rotation and check belt tension.

Note: If you change the tension, make sure that the belt is well placed in its guides after readjustment.