

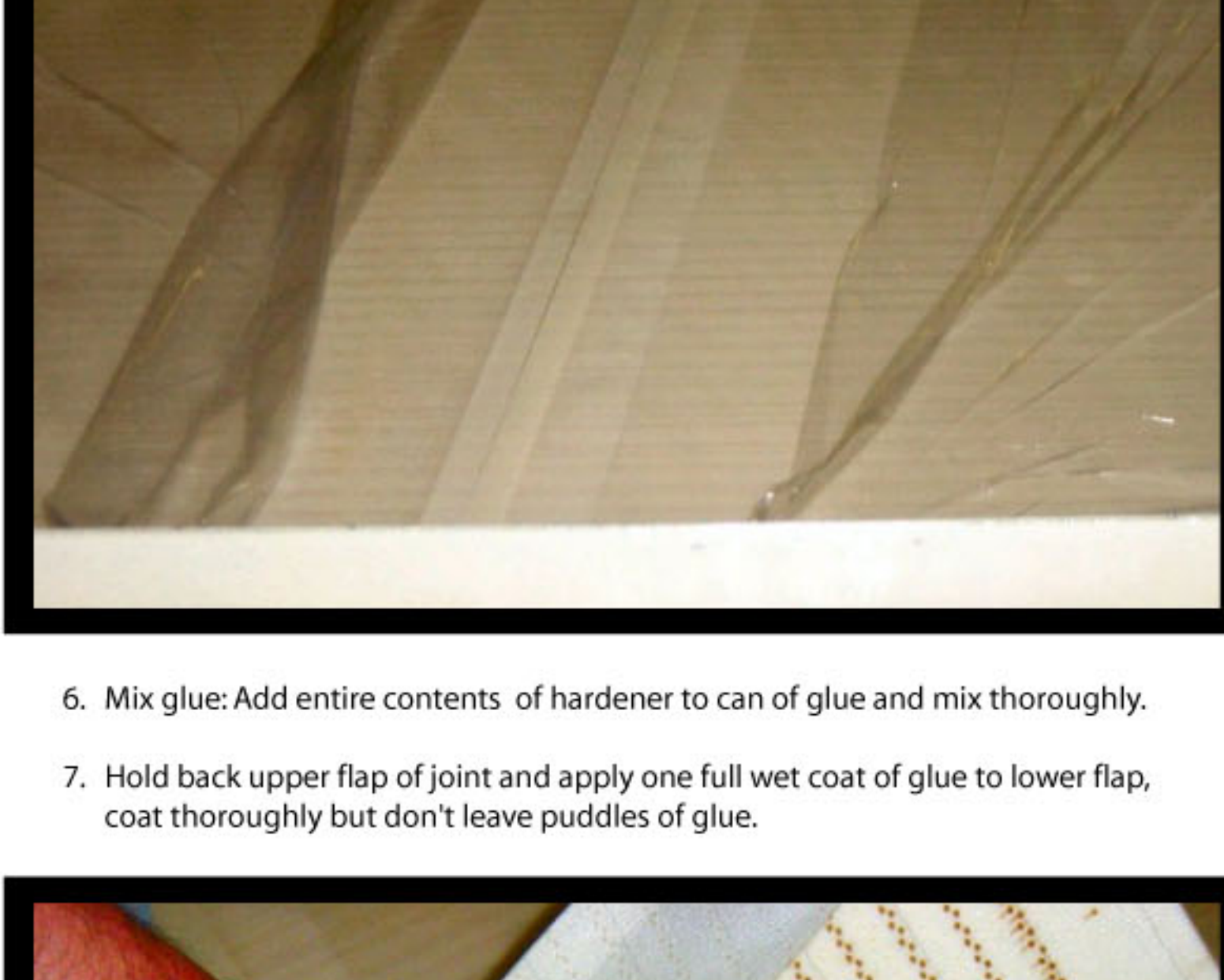


## Gerber® 3500 Belt Installation Instructions

1. Remove fabric feeder encoder from underneath belt at on-load end if fitted, remove old belt, blow off debris from vacuum grid, clean any buildup from rollers and frame members underneath machine, adjust take-up roller to forward position, move gantry to home position, remove cutter head, notcher, etc.

NOTE: The Automated Solutions conveyor belt has a pre-prepared joint for an accurate fit on your cutter machine without the need for the installer to modify the joint, one coat of glue has already been applied to the joint as a primer. The glue kit is located inside the rolled up belt and contains enough glue for the install plus some to spare.

2. Feed belt across top of machine starting from the off-load end, jog in reverse to help pull the belt, feed the belt under the machine being sure to go over the frame rails.
3. Position joint in center of vacuum grid.
4. If V-guide is used, position it in the vacuum grid guide slot and also in the roller guide slots.
5. Test fit joint: V-guide should be in the guide slot; joint should fit evenly across belt leaving approximately 1/16" gap on the belt face; turn vacuum on to hold belt in place; cut 2 pieces of plastic film approximately 80" x 60" and lay over the belt leaving a gap at the joint (this clamps the belt in place); apply masking tape to each edge of the joint to keep glue off the belt face.



6. Mix glue: Add entire contents of hardener to can of glue and mix thoroughly.

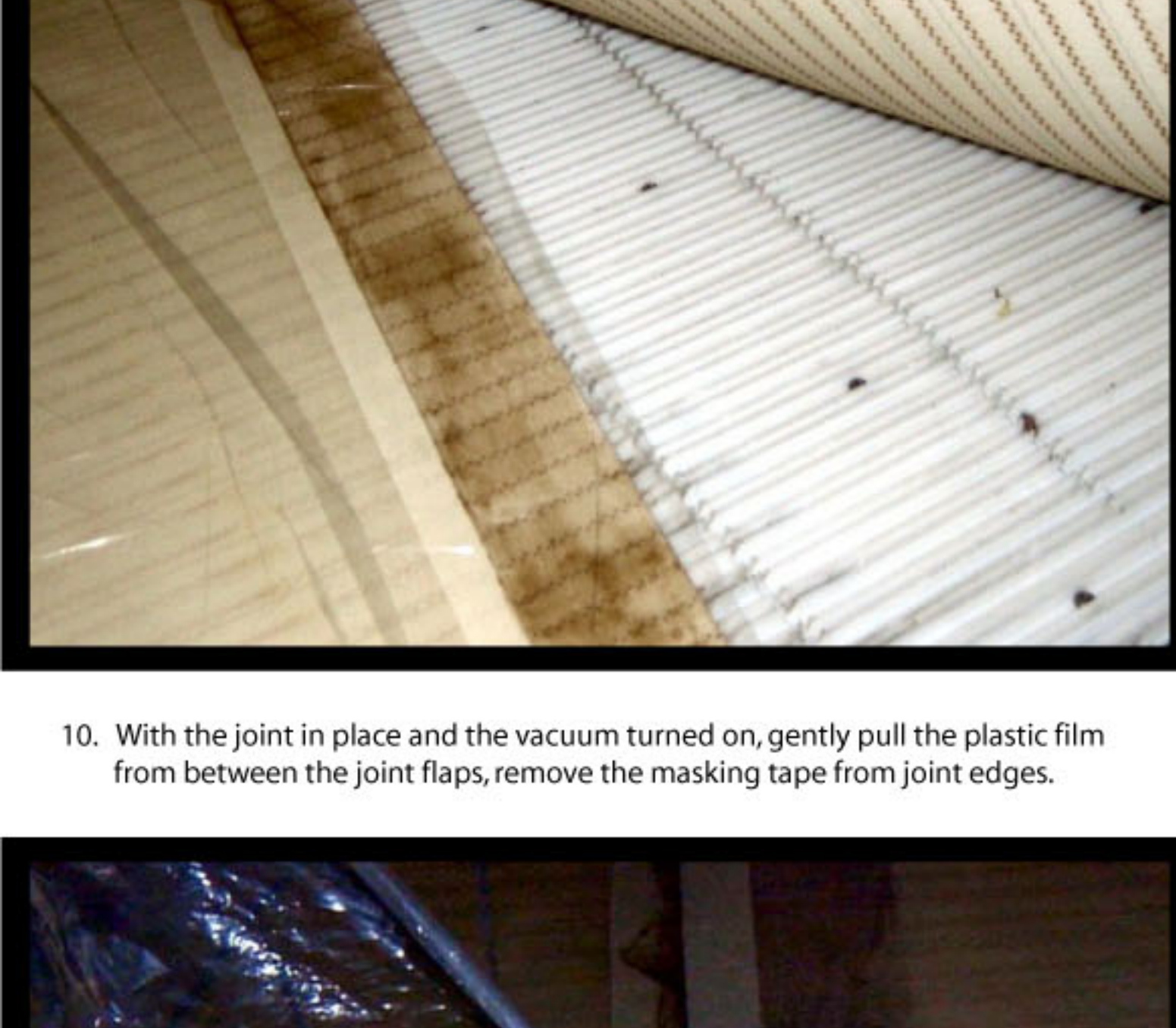
7. Hold back upper flap of joint and apply one full wet coat of glue to lower flap, coat thoroughly but don't leave puddles of glue.



8. Lay plastic film over the freshly glued lower flap. The glue is industrial grade contact cement and will bond the belt together instantaneously. The plastic film allows the two flaps of the freshly glued joint to be aligned before the joint is bonded together.



9. Apply one wet coat of glue to upper flap. While still leaving the plastic film over the lower flap, place upper flap in position, adjust joint so that a 1/16" gap exists on the belt face at joint, confirm that the V-guide is still in track and that the vacuum is turned on.



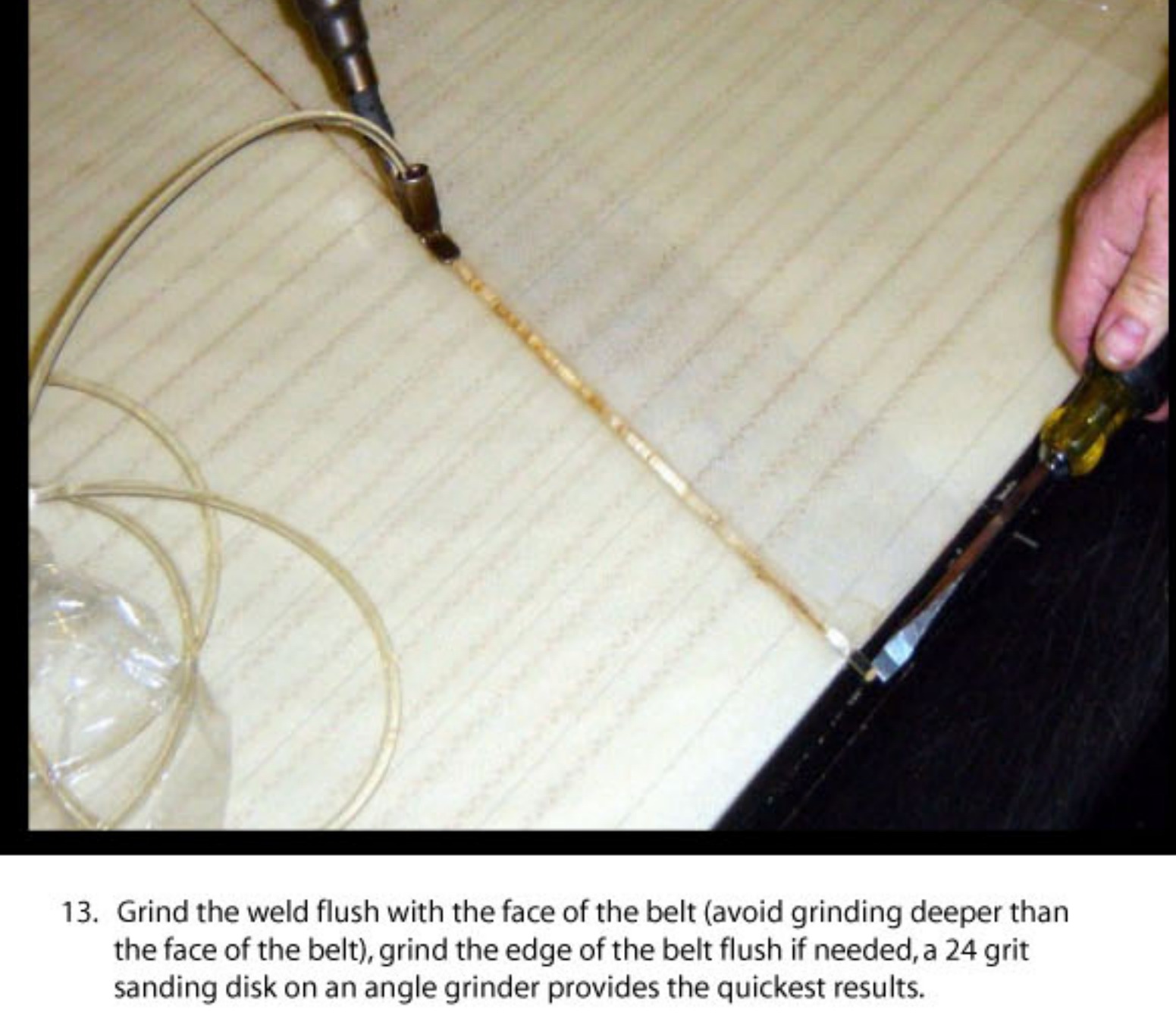
10. With the joint in place and the vacuum turned on, gently pull the plastic film from between the joint flaps, remove the masking tape from joint edges.



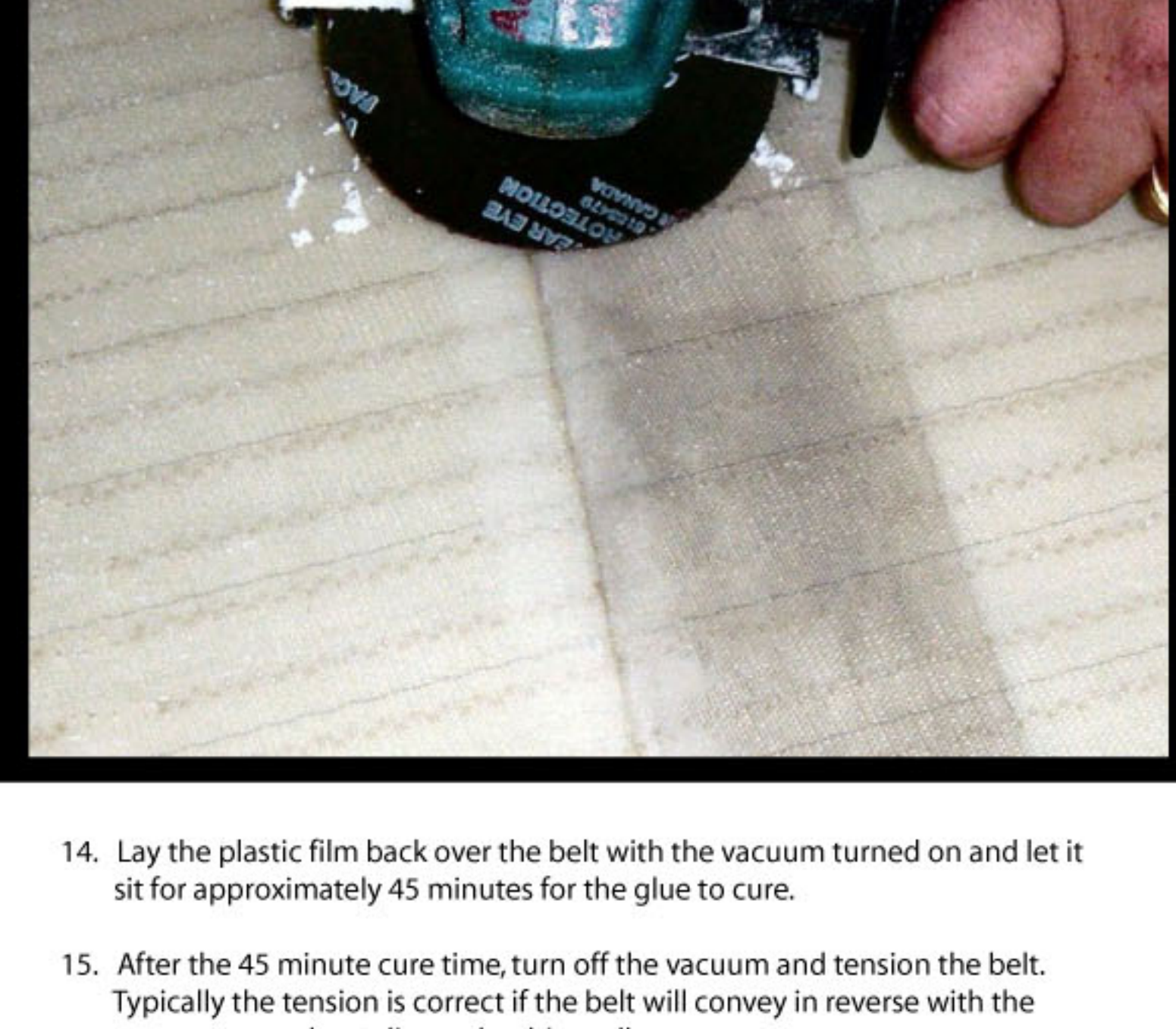
11. Bond the joint together by applying downward pressure with a roller or the face of a hammer, be thorough and go over the entire joint at least twice.



12. Apply the welding rod to the 1/16" gap in the joint using a heat gun with a welding rod applicator nozzle, set the temperature to approximately 1100 deg. F. Be sure the edges of the application and the bottom of the welding rod fuse together by adjusting your application speed. It is not necessary to melt the spine flush with the belt face. The excess weld will be removed in the next step. \*Heat guns and nozzles are available from <http://mcmaster.com> for approximately \$300: Heat gun #3433K88, Reduction nozzle #3433K29, Welding nozzle #3433K41.



13. Grind the weld flush with the face of the belt (avoid grinding deeper than the facing of the belt), grind the edge of the belt flush if needed, a 24 grit sanding disk on an angle grinder provides the quickest results.



14. Lay the plastic film back over the belt with the vacuum turned on and let it sit for approximately 45 minutes for the glue to cure.

15. After the 45 minute cure time, turn off the vacuum and tension the belt. Typically the tension is correct if the belt will convey in reverse with the vacuum on and not slip on the drive roll.

16. Replace the fabric feeder encoder.

17. Set belt scale factor, align the cutter head, and adjust the theta height according to GERBER maintenance manual.

18. Confirm that the vacuum regulator board is set to the standard setting 4-0-6 for maximum vacuum.

19. Routinely run the belt cleaning program according to the GERBER Maintenance Manual.

20. Use reasonable cutter tool air pressures, typically 15-32 PSI.

NOTE: The Theta height adjustment and the cutter tool air pressure are the most critical factors for successful cutting and for extended belt life. Setting the air pressure too high or setting the theta unit too low may cause excessive belt wear.

The installation is now complete.

For installation help, please call 828-327-8442