

Lectra® Topspin Belt Installation Instructions

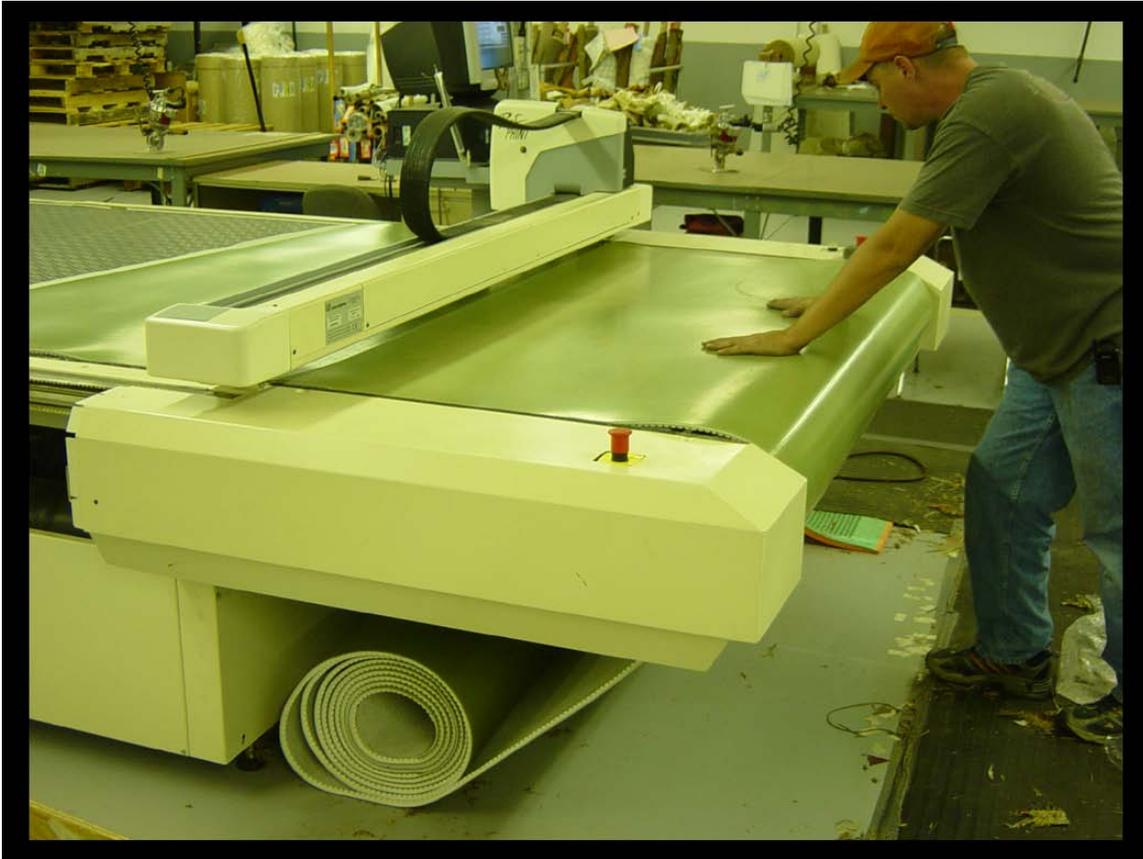
1. Remove plastic strips along edge of belt, remove all side covers by first removing E-stop switch covers, remove old belt, clean debris/fabric buildup from all rollers and from vacuum grid. Clean vacuum screen on input side of vacuum fan if fitted.



2. Remove the conveyor encoder with its bracket, mark location of take-up roller, then move roller to forward position. Move the cut gantry to the input side of the cut zone.

NOTE: The Automated Solutions conveyor belt has a pre-prepared joint for an accurate cut on your cutting 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.

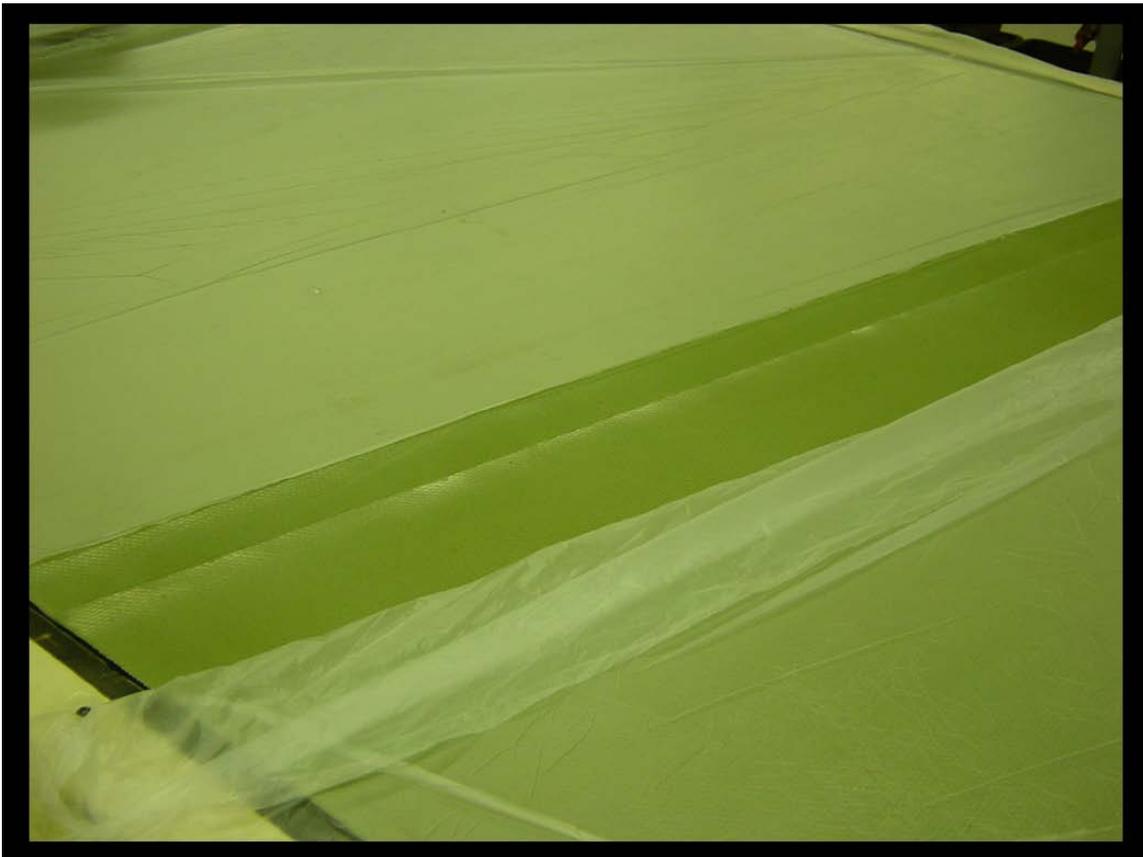
3. Place conveyor belt on floor at off-load end and start feeding belt across top of machine.



4. Continue feeding belt across vacuum grid, around take-up roller, and underneath machine being sure to go across the top of the idler rollers. Align joint in center of vacuum zone.



5. Test fit joint: V-guides should be in the guide slots; joint should fit evenly across belt leaving approximately 1/16" gap on the belt face; belt should be parallel to X-axis; 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 (the vacuum clamps the belt in place); apply masking tape to each edge of the joint to keep glue of the belt face. Using small bar clamps, clamp both sides of belt to vacuum grid at the input and output ends of vacuum grid.



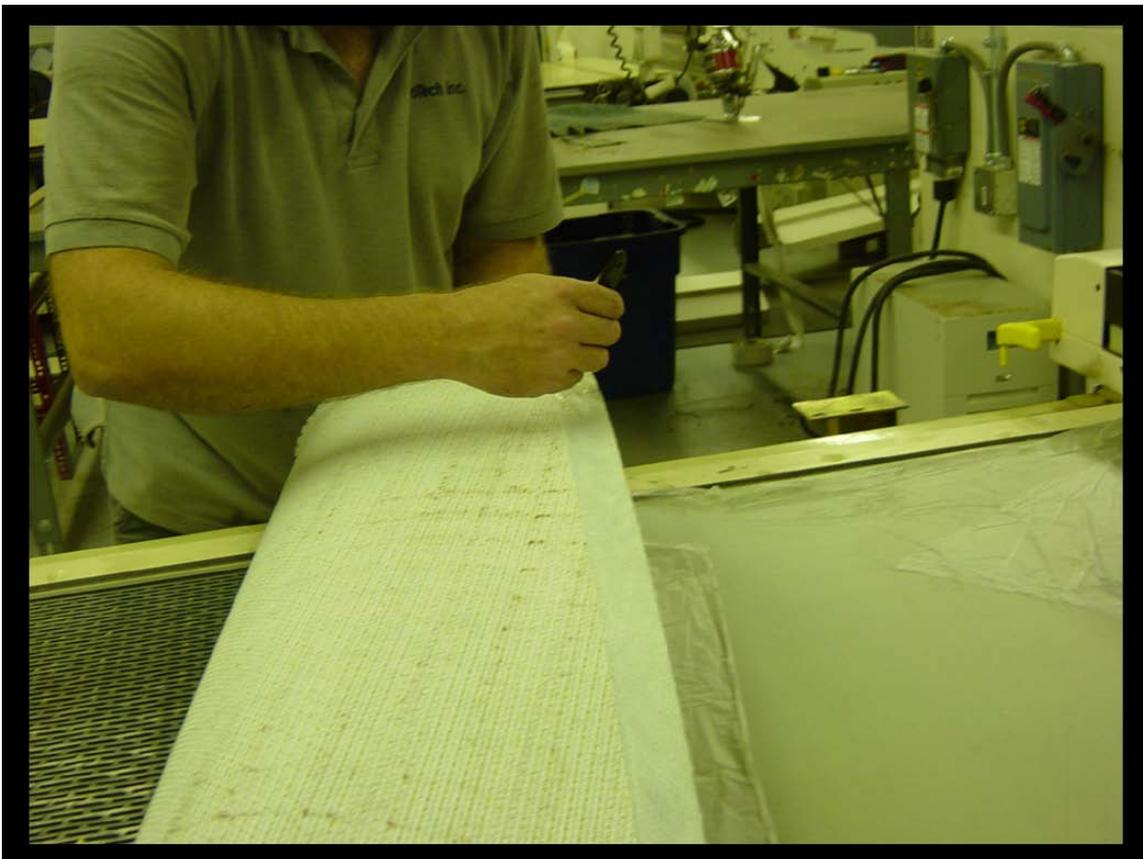
6. Mix glue: Add entire contents of hardener to can of glue and mix thoroughly.

7. Hold back the top flap end of belt and apply one 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, confirm that the belt is still parallel to the X-axis, turn vacuum of if needed, then turn the vacuum back on when joint is aligned.



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



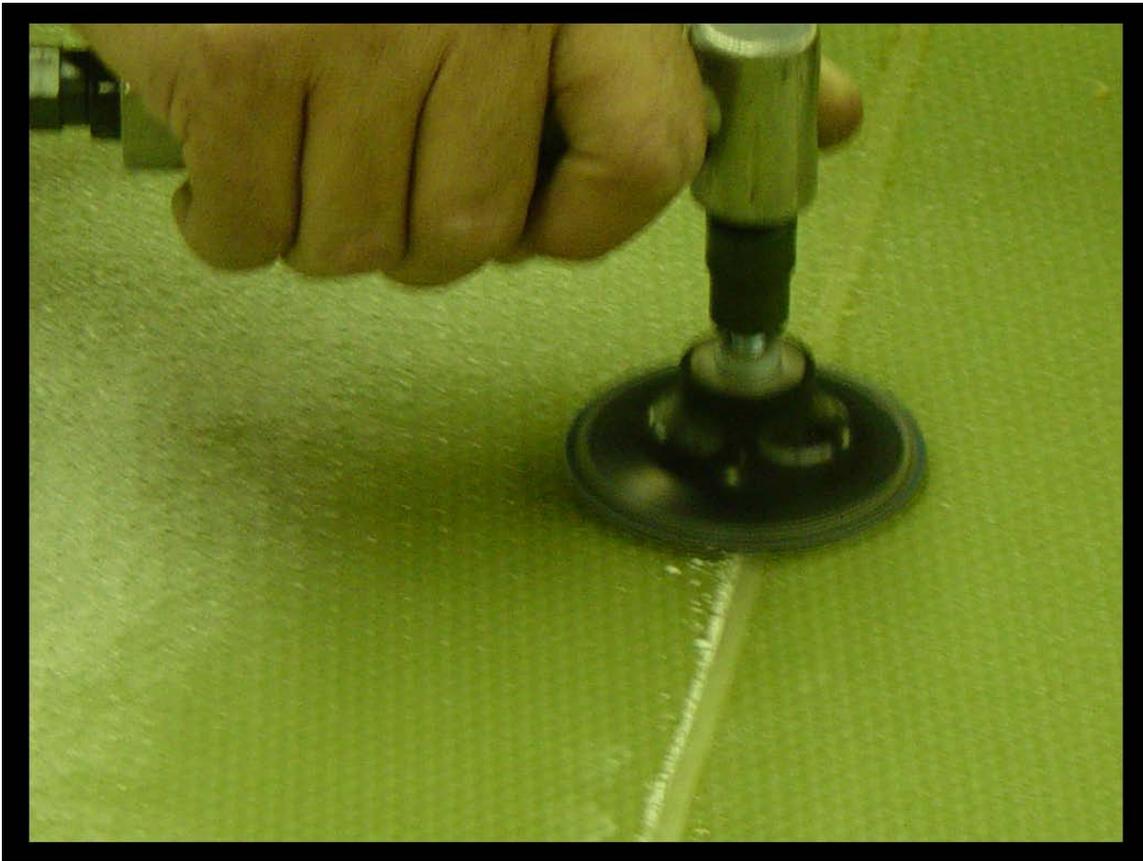
11. Bond the joint together by applying downward pressure with a roller or the face of a hammer, be thorough and go over the entire joint at least twice.



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 belt and the bottom of the welding rod fuses together by adjusting your application speed. It is not necessary to completely melt the welding rod flush with the belt surface, the excess weld will be removed in the next step.



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

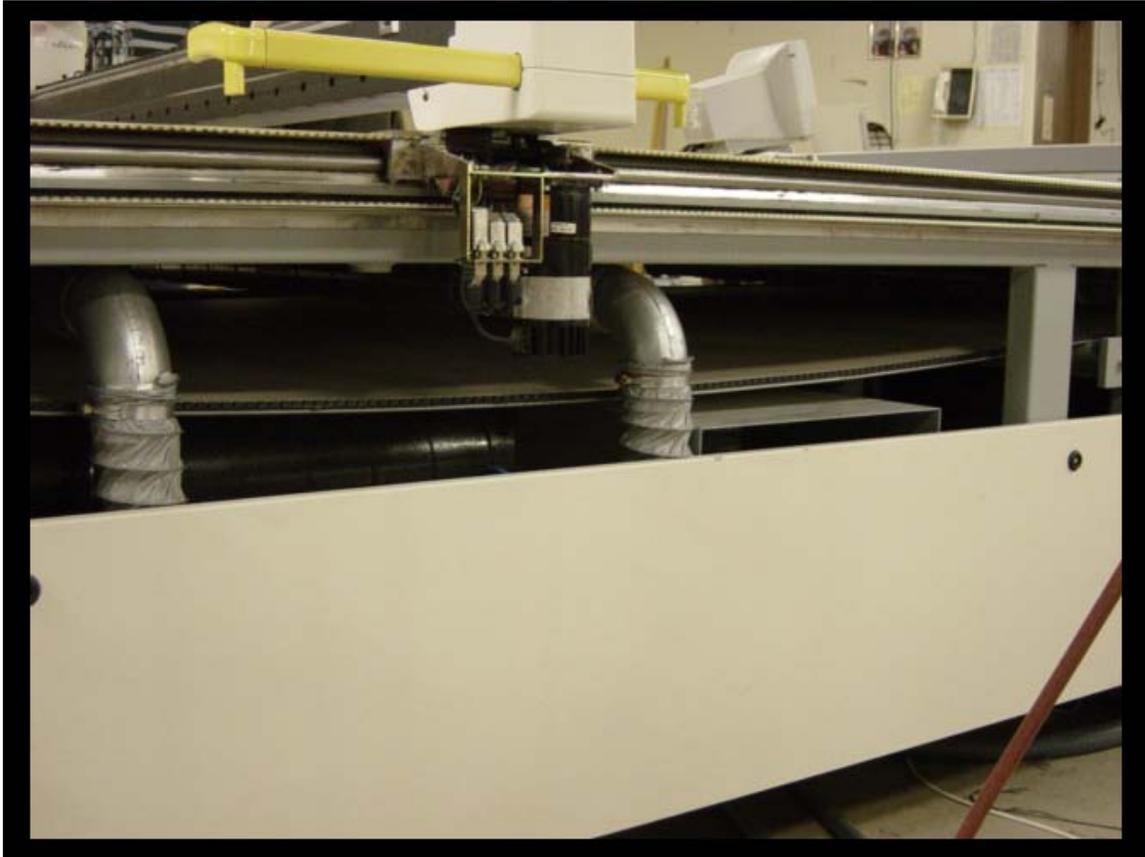


- Heat guns and nozzles are available from mcmaster.com for approximately \$300:

Heat Gun #3422K88
Reduction Nozzle #3422K29
Welding Nozzle #3422K41

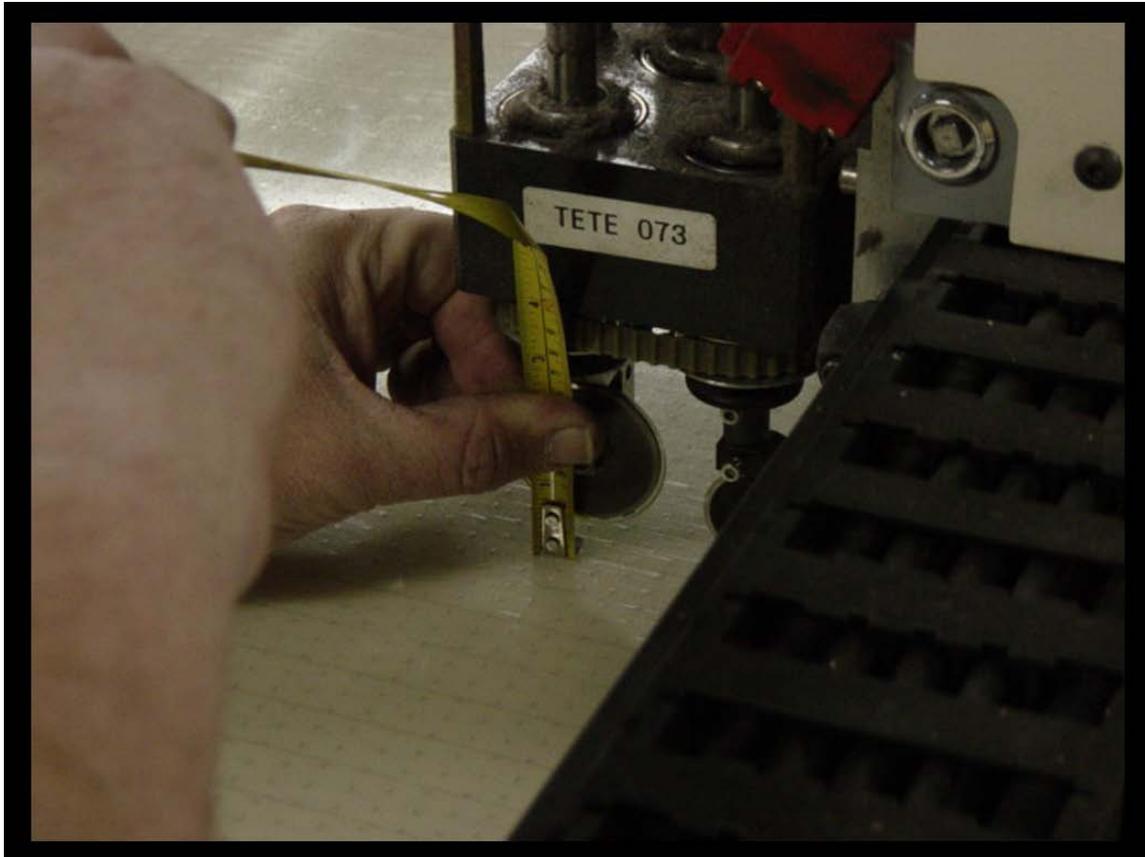
14. While leaving the vacuum turned on, lay the plastic film back over the entire vacuum zone of the belt. Let the adhesive cure for approximately 45 minutes before tensioning belt.

15. After the 45 minute cure time, turn of the vacuum and tension the belt evenly on each side. Use your prior reference marks for the initial adjustment. The take-up roll will be about centered in its adjustment slot when the tension is correct. To test for slippage, cover entire belt in the vacuum zone with film and jog conveyor, if there is no slippage on the drive roll, the tension is satisfactory.



16. Set conveyor calibration, repeat test several times to verify that the calibration is correct.

17. Set blade height: The bottom of the blade should be 12-13mm above the belt. If the vacuum surface has low spots, adjust the blade at the low spot, but note that this will cause the blade to cut deep at the high spots.



18. Verify that the cutter heads are aligned, install a new blade, validate blade change.
19. Use reasonable cutter tool air pressure, typically starting at 2.0 bar and maximum 3.5 bar.
20. Replace the side covers and the e-stop switch covers.

The installation is now complete

NOTE: The blade 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 blade height too low may cause excessive belt wear. For installation help, please call 828-396-9900.