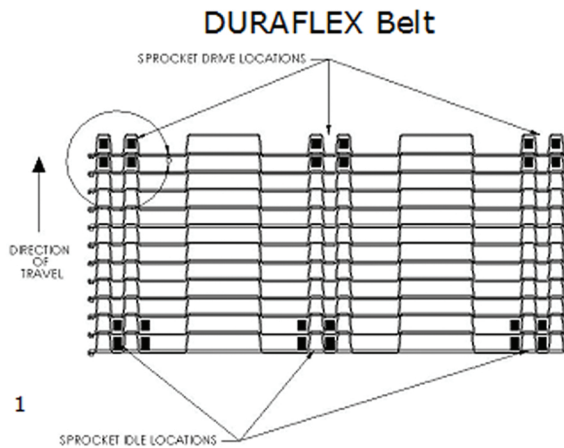


DURAFLEX Installation Instructions



Helpful hints prior to beginning installation and start up

DuraFlex* works with existing slider pans, slider beds and support rails

Try and make sure unit is as square as possible

Belt path should be free of any obstructions

There is no top or bottom to the belt

Ensure sprockets are properly engaged in openings as explained in picture 1 and that they are engaged in the same openings across the full width of belt

Make sure edges of belt are not rubbing on anything

Installing Sprockets & Nosebars

Installing drive sprockets

To set up drive sprockets use the belt as a template

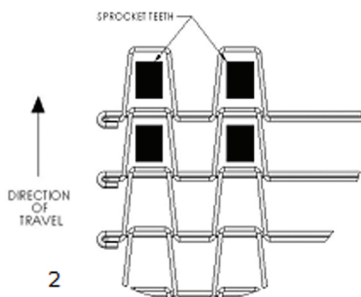
Dual tooth sprockets engage in drive (smaller) openings of belt across width

Make sure sprocket teeth are engaged in same openings across full width of belt

Ensure sprocket teeth are driving against the connecting rods (not the strip)

The degree of wrap on sprockets should be no more than 180 degrees

Key sprockets down on the shaft



Bend or remove pan "tabs" as needed to correctly install sprockets

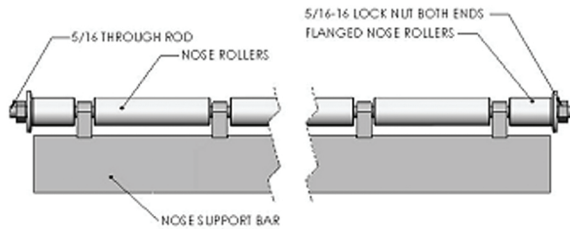
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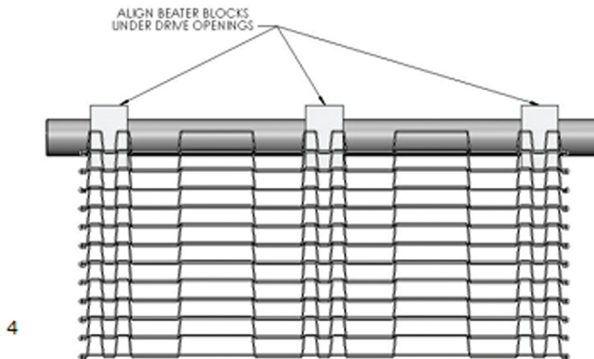
***IF USING NOSEBARS-MINIMUM DIAMETER IS 3/4" (0.75")**

**** SEE DRAWING 3 INDICATING NOSE ROLLER SUPPORT MODIFICATIONS FOR FINGERS**



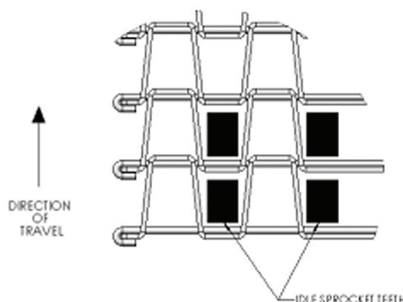
Cut flanged nose rollers to required length

***** IF USING BEATER BLOCKS (VIBRATORY BLOCKS) SEE DRAWING 4 INDICATING BEATER BLOCK PLACEMENT- THEY NEED TO BE LOCATED UNDERNEATH OF DRIVE OPENINGS (SMALL OPENINGS) IN ORDER TO CLEAR OUT MATERIAL BUILD UP AND DECREASE WEAR ON BEATER BLOCK**



B) Installing idle sprockets

To set up idle sprockets use belt as template to determine sprocket placement
Place idle sprockets in one opening over from smaller openings so that 1 tooth is engaged in smaller opening and 1 tooth is engaged in longer opening
Ensure sprocket teeth are engaging against the connecting rods (not the strip),
keep in mind that the belt engages the sprocket on idler shafts therefore the openings will be different than the drive
Key all idle sprockets down onto shaft



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Making the Belt Endless

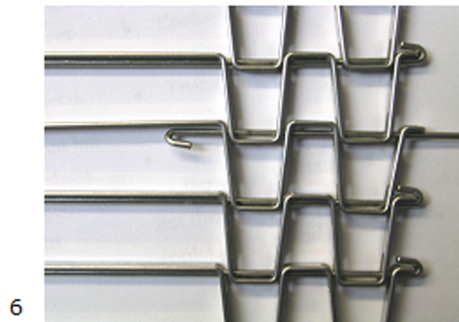
If take-up on the conveyor is adjustable, set to minimum for installation

Orient belt for proper direction of travel, see picture 6

If installation under tension is required, pull ends so they mesh together and use wire ties to secure belt ends for rod insertion

Locate hooked end connecting rods supplied with belting and orient as shown in picture 6

Rod Orientation



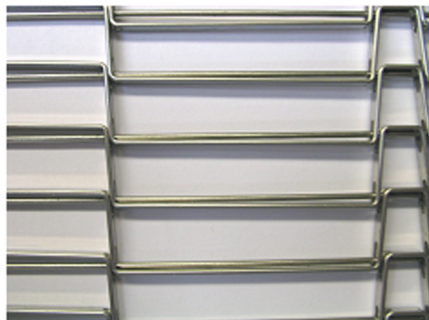
Take hooked connecting rod supplied with the belt and insert **being certain** to engage **all openings**, refer to pictures 7 & 8

When rod is approximately 1/2" from being fully inserted, orient it so the hook fits over the tab on insertion side

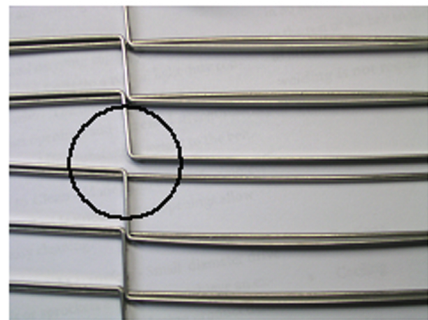
Lock hooked edge of rod around tab on opposite belt edge

Apply minimum amount of tension required

Correct



Incorrect



When starting up the unit for the first time, run slowly to ensure smooth operation of belting and proper sprocket placement

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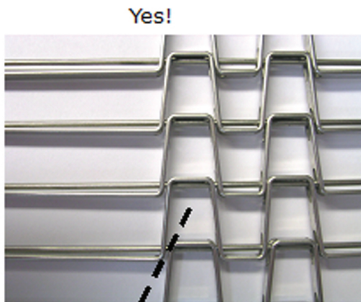
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Removing the Belt

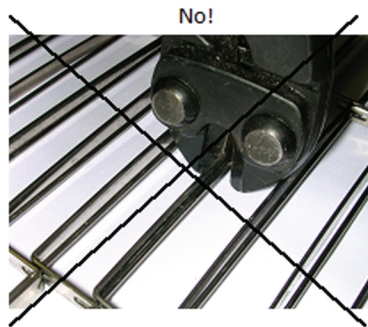
Should you need to remove belt from the unit simply cut the connecting rod.
BE CAREFUL NOT TO CUT THE STRIP!

Or

You may twist the connecting rod back out of the openings



Cut rod only



Troubleshooting

Problem	Suggestion
One edge of the belt is leading the other	Check to make sure belt has not jumped sprockets
You see a pronounced gap in belt openings	Check to make sure belt is spliced properly and that connecting rod passes through all openings
You notice edge damage on the belt	Check to make sure the belt path is free and clear of obstruction
You notice deflection across the width of the belt	Check to make sure the sprockets are properly aligned across the width of the belt or if using nosebar check to make sure diameter is sufficient