

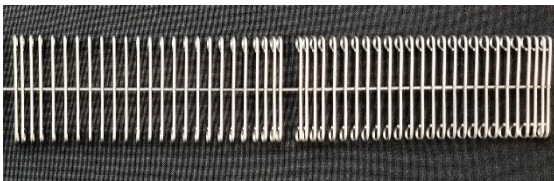
# METAL MODULAR: INSTALLATION INSTRUCTIONS

## ***SAFETY WARNING:***

Always utilize good Lock Out Tag Out procedures when performing work on any conveyor.

## ***BEFORE INSTALLATION:***

Carefully inspect all conveyor components for signs of wear and / or damage. Make any needed replacements or repairs prior to new belt installation.



Module



Re-bars



Splice Rods

1. Ensure conveyor alignment and adjust as needed such that the unit is square and parallel throughout the belt path.
2. If the installation is a retrofit from a different belt design, remove existing sprockets and replace with Metal Modular sprockets in the correct configuration for your belt design. If not a retrofit, proceed to step #5.
  - a. Metal Modular Sprockets:

- i. **Edge Sprockets:**



Used near both belt edges – placed in openings between re-bar rows in gaps of 1 ¼” or greater. Also, used across the belt width for Drum Motor Drives (sprockets frame the re-bar rows)

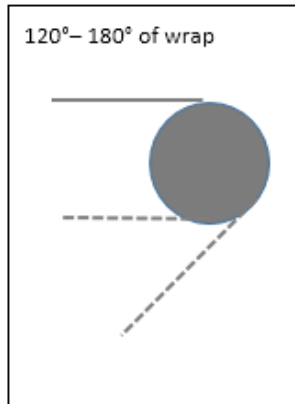
- ii. **Center Sprockets:**



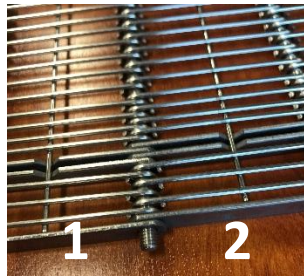
Used to frame rows of re-bars

*\*Also, Available for Drum Motor Drives with Edge Sprocket Configuration*

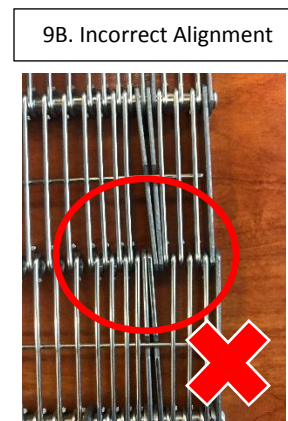
3. Ensure that the sprockets receive between 120 Degrees and 180 Degrees of wrap by the belting.



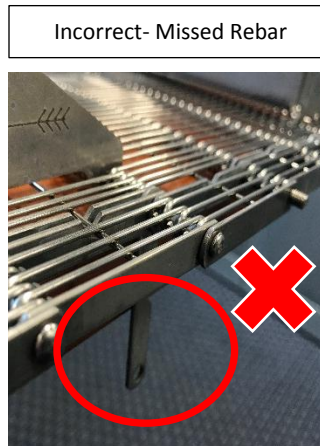
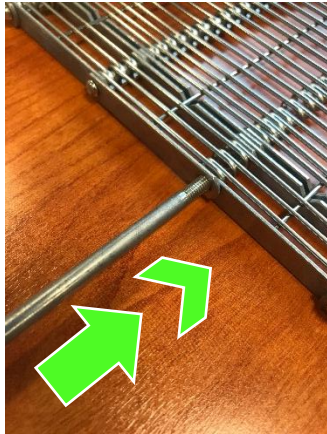
4. All sprockets should be keyed and set to the shaft.
5. Carefully pull the new belt through the conveyor belt path.
6. Tension belt only to the point to which the application requires. Lower tension generally equates to a longer belt life!
7. Modules must always be removed in groups of two (2) to maintain the proper pattern for the mesh!



8. Extra connecting rods are supplied with each belt that is supplied. One of these rods is needed to make the belt endless. The remaining rods are to be used for any additional splicing that may be needed later in the belt's life.
9. At a convenient location, align the belt ends together and overlap so the modules intersect in a consistent pattern to that of the rest of the belt. Ensure that ALL Reinforcing Bars also overlap in the correct pattern.



10. From one edge, insert the splice rod through the overlapped sections taking care to properly capture the reinforcing bars across the width.



11. After the threaded end of the connecting rod protrudes through the outside edge of the opposite side of the conveyor belt, tighten a nut (provided) onto the rod.



12. Tack weld the nut in place and grind / trim off any extra material if a clearance issue is present.
13. Be certain all tools and components are removed from the area.
14. Remove lock out / tag out tags and commence with a slow start up.
15. Inspect belt performance and ensure all areas of belting have adequate clearance from conveyor surfaces and projections.
16. Inspect the engagement of sprockets into the belting. This should be a smooth engagement and disengagement. If jumping is present, stop the conveyor immediately and inspect the sprocket positioning and conveyor alignment. If problem persists, contact your CES representative.
17. Once all components are operating correctly, the belting is ready for production.