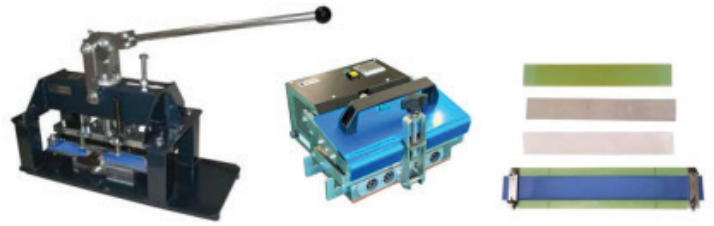


TOOLS AND MATERIALS REQUIRED

- LVR-60 or CFTG60N belting material
- Steel ruler and pen (for marking)
- Scissors or clippers (for cutting belt and trimming fingers)
- Finger Puncher FP-200R (includes T-wrench)
- 45mm-wide pre-setter (PS-CF-ES-45) LVR-60/CFTG60N (includes upper mold and lower mold), plus impression fabric (see "Splicing Conditions" below)
- Heating/Cooling Press NPS-2005RA



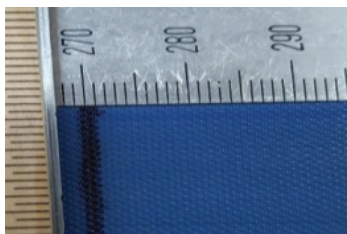
Note: For detailed instructions on how to use the FP-200R finger puncher and NPS-2005RA press, please consult their Operation Manuals.

Splicing Conditions

Belt Type	Finger Shape	Setting (Upper Plate Side / Belt / Bottom Plate Side)	Heating Temp.*	Heating Time*	Cooling Temp*
LVR-60 (45mm wide)	10 x 200	impression fabric / polyurethane side of belt / fabric side of belt	185°C	300 sec.	80°C
CFTG60N (45mm wide)	10 x 200	silicone sheet (matte side down) / impression fabric / "textured" side of belt / "taffeta" side of belt	185°C	300 sec.	80°C

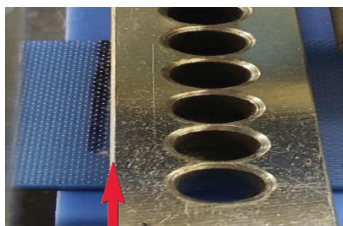
* Please note: Heating temperature and time are fixed at 185°C and 300 seconds for the NPS-2005RA press.

PART I – PREPARING FINGER ENDS USING FP-200R



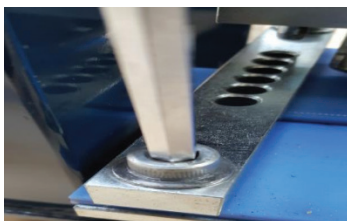
STEP 1

CUT BELT TO LENGTH NEEDED PLUS 270MM, THEN MAKE 270MM MARK ON EACH END: When measuring belt length, add 270mm to allow for the finger joint. Using scissors or clippers, cut belt to length needed plus 270mm, then mark 270mm in from each end on the blue urethane side for LVR-60 or CFTG60N.



STEP 2

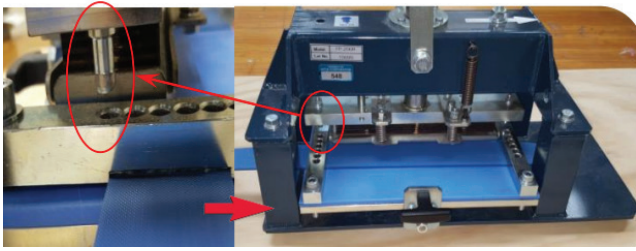
FEED BELT INTO PUNCHER, ALIGNING MARK ON BELT WITH OUTSIDE EDGE OF CLAMP: Loosen clamping bars and insert one end of belt, blue urethane side up, for LVR-60 or CFTG60N. 270mm mark should be placed to the outside of clamp.



STEP 3

FASTEN CLAMPS: Fasten bolts on both clamps with T-wrench

Endless Procedure for LVR-60 and CFTG60N, Using FP-200R and NPS-2005RA

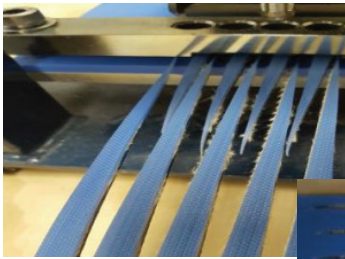


STEP 4

NOTE DIRECTION OF BELT, THEN PUNCH BELT:

Be sure to note direction of belt in puncher. Position blade support table so that guide pin **is aligned with** hold down bar holes on either of the clamps. Push handle all the way down

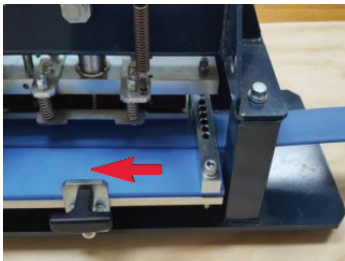
to punch belt. Return handle to original position. Move support table to next hole, and repeat process until belt is fully punched.



STEP 5

REMOVE BELT AND REMNANT:

Loosen clamping bars and remove punched end of belt from finger puncher, followed by remnant from punching. Comparing the punched end of the belt with the remnant, note that the puncher produces interlocking fingers with the opposite side.



STEP 6

FEED OTHER END OF BELT INTO OTHER END OF PUNCHER, THEN PUNCH BELT:

Feed other end of belt blue urethane side up for LVR-60 or CFTG60N into puncher in **opposite direction** from Step 2, clamping into place as shown in Steps 2 through 4. Then, punch end of belt following instructions in Step 5.



STEP 7

REMOVE BELT AND REMNANT:

Loosen clamping bars and remove punched end of belt from finger puncher, followed by remnant from punching.



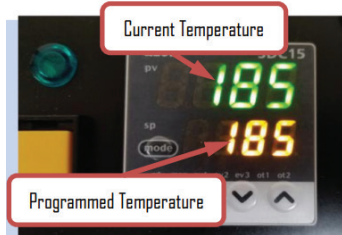
STEP 8

TRIM TIPS OF FINGERS ON EACH END OF BELT:

Using scissors or clippers, cut 5 to 10mm off the tips of each finger on both ends of the belt. This will help when matching the belt ends in the pre-setter to ensure a good splice.

Endless Procedure for LVR-60 and CFTG60N, Using FP-200R and NPS-2005RA

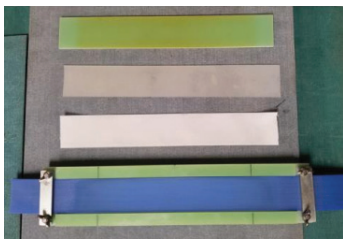
PART II – MAKING ENDLESS BELT USING NPS-2005RA



STEP 1

PRE-HEAT PRESS:

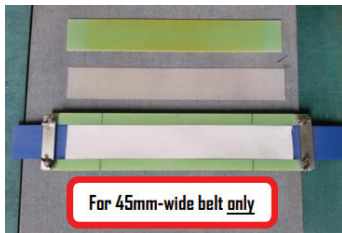
Make sure press is closed, and then plug it in to pre-heat it. After running a diagnostic check for about 6 seconds, the press will begin to pre-heat to its programmed temperature of 185°C. Pre-heating will take about 10 to 15 minutes.



STEP 2

PLACE BELT ENDS IN LOWER MOLD OF PRE-SETTER:

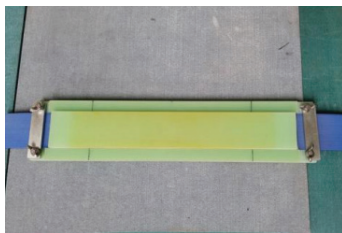
Loosen clamps on lower mold of pre-setter and slide finger-prepared ends in, **fabric side down for LVR-60** or **"taffeta" side down for CFTG60N**. Push ends together at center of mold (between marks on mold). Use a thin metal edge (such as steel ruler or screwdriver) to push tips of fingers or aramid fibers back between fingers if needed. Fasten clamps to hold belt in place.



STEP 3

IF JOINING 45MM-WIDE MATERIAL, COVER BELT WITH IMPRESSION FABRIC:

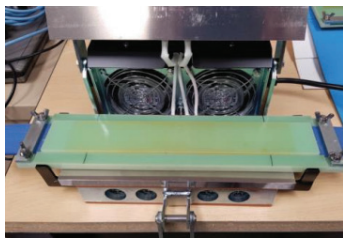
For joining 45mm-wide material, cover top of belt material with impression fabric.



STEP 4

COVER ALL WITH UPPER MOLD OF PRE-SETTER:

Place upper mold of pre-setter on top of impression fabric centering over splice area.



STEP 5

ONCE PRESS IS PRE-HEATED, PLACE MOLD IN PRESS:

Once press is pre-heated to 185°C, open press and insert mold with belt. Make sure the mold is placed between the metal position guides and that the marks on the mold are located within the heating plate.

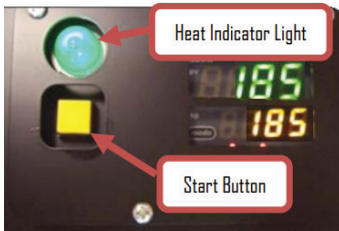
Endless Procedure for LVR-60 and CFTG60N, Using FP-200R and NPS-2005RA



STEP 6

CLAMP PRESS SHUT AND TIGHTEN:

Close press. Fasten hook and **turn torque limiter clockwise until it slips.**



STEP 7

PUSH START BUTTON TO ACTIVATE PRESS CYCLE AND JOIN BELT ENDS:

Push the start button to initiate the press cycle. Make sure the green heating indicator light above the start button is turned on. The heating cycle will finish after 10 minutes, and then the cooling fans will turn on. Let the cooling fans run until current temperature drops below 80°C (about 15 minutes).



STEP 8

ONCE PRESS COOLS, REMOVE BELT AND INSPECT:

Once current temperature is below 80°C, disconnect press. Turn knob counter clockwise, release clamp, and open press. Remove mold from press, then loosen clamps and remove belt from mold. Inspect belt to be sure there are no large bubbles on surface, cord filaments sticking out, or cracks or grooves between fingers. If all is okay, trim any excess polyurethane material from edge using scissors.