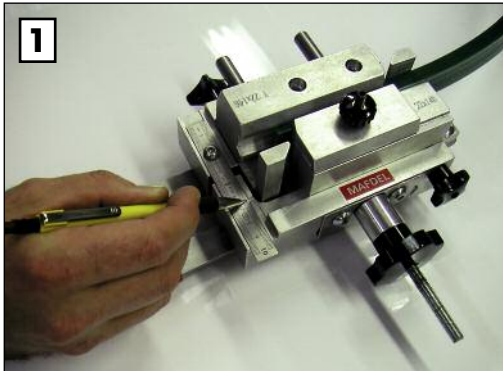
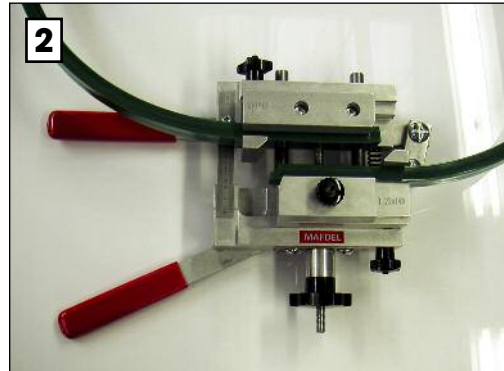


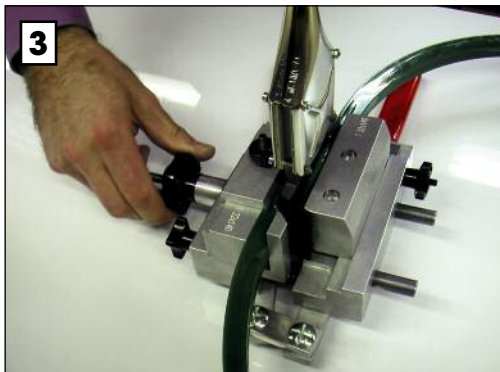
## OVERLAP welding process



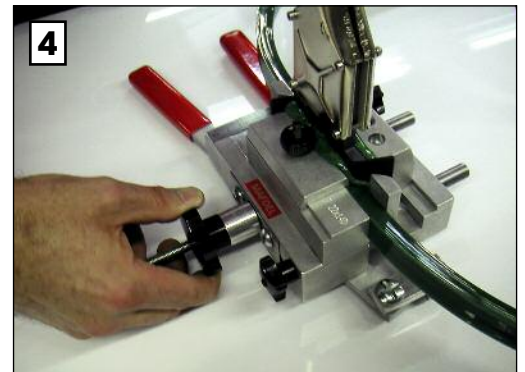
**1**  
Cut the belt 70 mm longer than its theoretical length. Put the top end of the belt into the corresponding die of the clamp and close it. Read the X measure at the right of the reference pin, on the small side ruler.



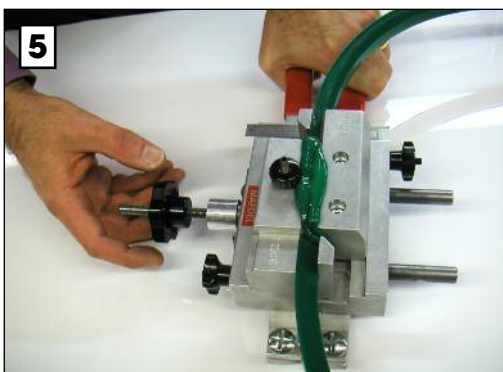
**2**  
Open the clamp and place the second end in.



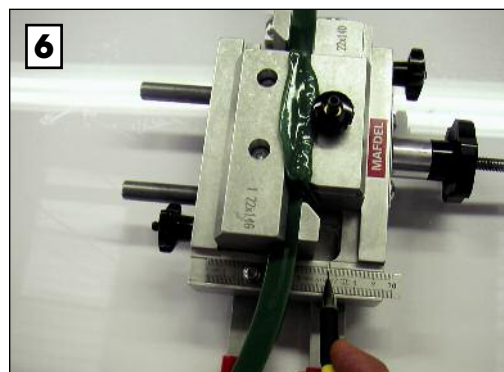
**3**  
When the **M150** iron is warm enough, insert it between both ends of the belt.



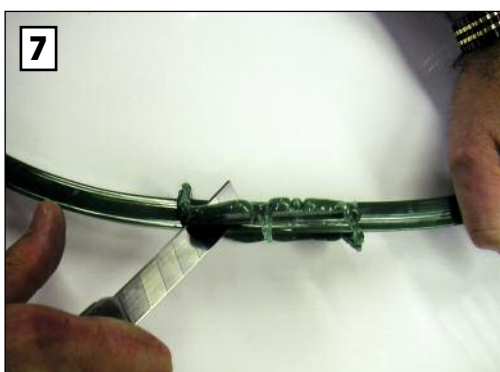
**4**  
Tighten little by little the side screw, until the previously noted X measure gets to the left of the reference pin .



**5**  
Loosen the side screw with your right hand, keeping the clamp closed with your left hand. Then, quickly, open the clamp, remove the welding iron, and close the clamp again. Both fused ends will get in contact and weld.



**6**  
Keep the clamp closed with the side screw, and let the belt cool 5 to 10 mn. The right side of the reference pin should then show the X measure on the small ruler.



**7**  
Remove the belt and clean the welding point.



**8**  
The belt is ready to work.