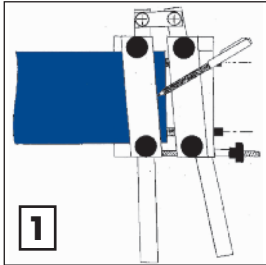


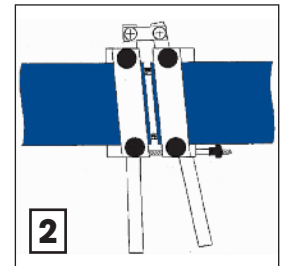
welding process for flat and conveyor belts



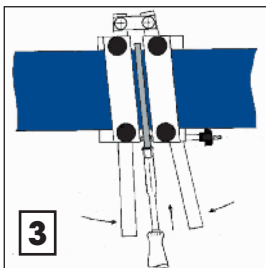
Plug the welding iron (**M50 to M400**)

As our welding iron includes a thermostate, you should plug the iron in at least 8 minutes before welding, 15mn if you use a **M200, M300 or M400**.

Draw and cut the belts ends, following the clamp angle (**J50 to J400** , depending on the belt's width).



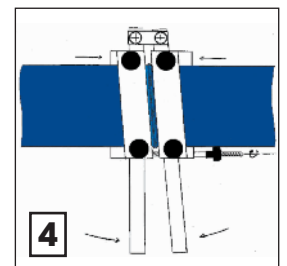
Insert the ends of the belt into the appropriate clamp (**J50 or J60**), allowing 5 mm of each end to protrude into the inside (If the belt to weld is a **DEL/ROC**, strongly tighten the top screws of the clamp).



Slide the blade in between both ends of the belt and make sure that the blade bears on the whole surface to weld.

Tighten slightly and leave the ends melt.

Wait until you get a good bead of melted material on each side.



Open the clamp, quickly remove the welding iron and re-close at once, tightening accordingly to the cross section of the belt (the bigger the belt, the more tightened the clamp).

Maintain the clamp closed using the side screw and let the belt cool (which should take between 2 and 5 minutes, depending on the size of the belt).

NB: DEL/ROC belts cool a lot faster than the other MAFDEL qualities. If you do weld a DEL/ROC belt, this step will have to be handled even faster.



Clean the welding point.

Check the alignment of the welding point, as well as its homogeneity (no bubble of air and solidity (by bending it).

Fit the belt on the machine.

NB: Always use a clean and very hot welding iron. Both ends of the belt to weld should be perfectly clean as well.

CLEAN THE BLADE OF THE WELDING IRON IMMEDIATELY

M51 or M101 welding iron:
wipe the blade with a clean 100% cotton cloth.

Other irons:
remove most of the melted material with the blade of a knife (without scraping the iron), and wipe the rest out with a clean 100% cotton cloth.

Do not use any cloth that may contain synthetic materials, which would melt in contact with the blade of the welding iron, and then contaminate the welding iron.

