

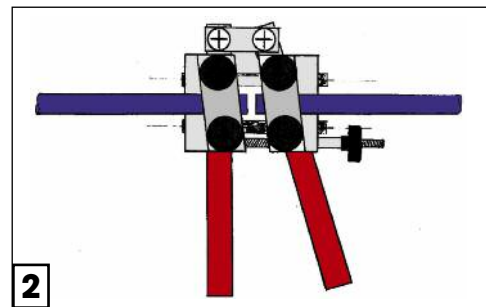
1

Plug the **M50** or **M51** welding iron in.

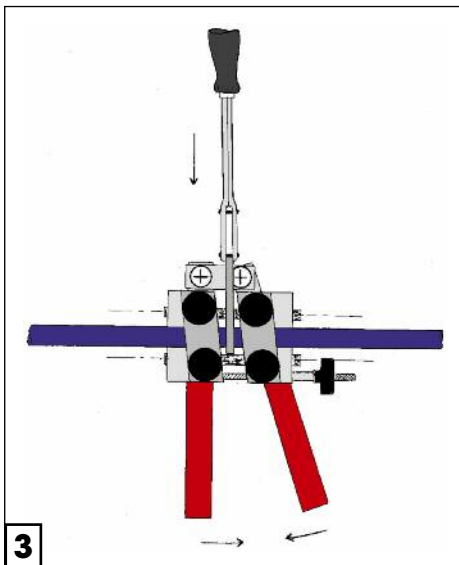
As our welding iron includes a thermostat, you should plug the iron in at least 8 minutes before welding.

Cut both ends of the belt, in a sharp 90° angle, with **S135** graduated cutter.

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).



2



3

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

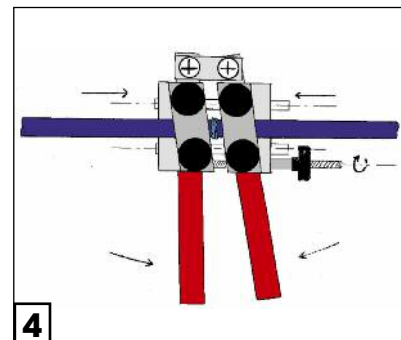
Tighten slightly and leave the ends melt.

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).

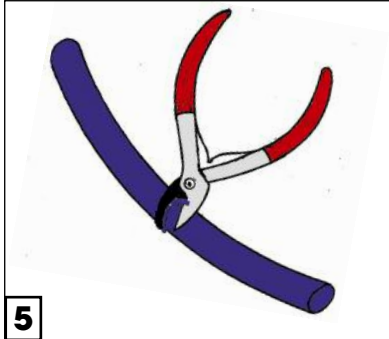
Maintain the clamp close using the side screw and let the belt cool (which should take between 2 and 5 minutes, depending on the size of the belt).

**If you do weld a DEL/ROC belt, this step will have to be handled even faster.**



4

## and V belts



Clean the welding point.

Check the alignment of the welding point out, 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 welding iron :

Wipe the blade with a clean 100% cotton cloth.

#### Fer M50 :

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.***

### For V belts only :

If you use a **J25** welding clamp, cut both ends of the belt with a 45° angle, using our **S135** cutter.

Insert the ends of the belt into the **J25** clamp, allowing 5 mm of each end to protrude into the inside .

The two dies of our **J25** welding are not in the same horizontal line (1 mm difference for small belts, 2 mm for bigger belts), to compensate for the slippage of the belts' ends due to melting when brought together for welding. The exerted pressure on the handles during the melting will bring both ends back in the same alignment.

