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.

Open the clamp and place the second end in.

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

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

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.

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

Remove the belt and clean the welding point.