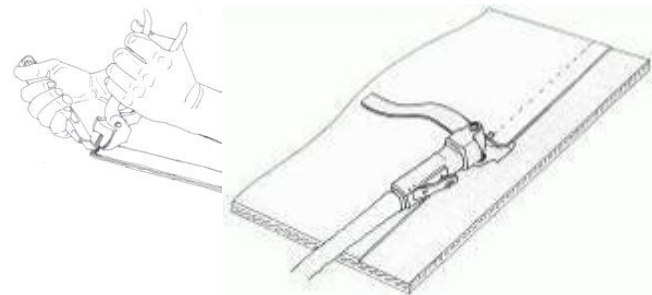
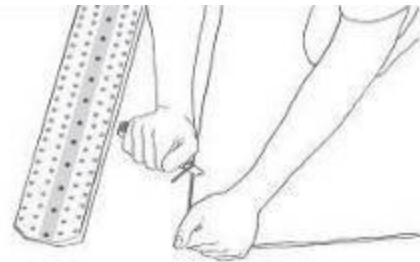
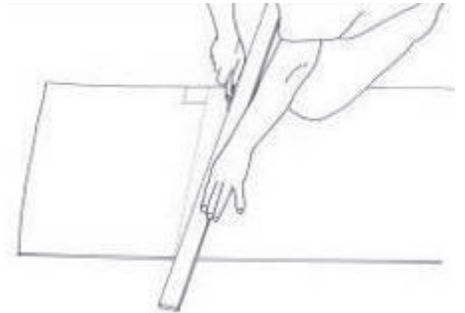
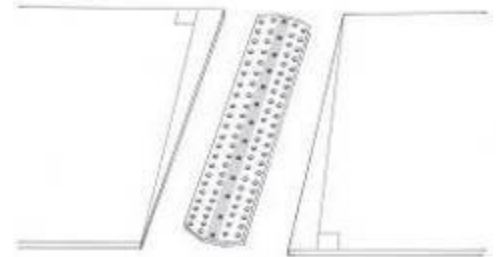


**Needed tools** : - T-square and ruler, use for straight cut; belt marking pen and utility knife - Calipers to measure belt thickness - Special tool in order to remove the rubber cover (Grinder, skiver or gripper with knife)

- Electric screw driver or pneumatic screw driver with 30 Nm torque (possible also with a hand brace) - Drive bit PZ 2 or PZ 3

## Installation mode :

- 1.) Carefully measure belt thickness in order to choice the right screw length and the right Super-Screw (see table in brochure or price list).
- 2.) Cut the belt in bias in order to run better over pulley and under scrapers. Trace a square line at Super-Screw location, then slide one side by approx. 10 % (10 cm for 1 m length) and cut. FIG 2 Opposite belt end should be inversely cut, as shown on FIG 2. Take care on belt reduced size.
- 3.) Chamfer the end of the belt as shown : - bevel the belt end in order to have a better pulley rolling up as indicated on FIG (A) if the conveyor is less than 100 m long. - or prepare a light step overlapping as on FIG (B). This option require to install a few screws on one side and disassemble the center part of the splice, which have to cover up the light step overlapping.
- 4.) Skive down or grind or remove with a gripper the rubber cover of the belt on both sides in order to avoid an over thickness, so that the Super-Screw lacing will be compatible with a scraper (obligatory for longer life time !).



5.) Position the Super-Screw against one belt side, ensuring that Super-Screw is resting against the central spacers.

6.) Place a wooden board under Super-Screw. Don't install Super-Screw on a pulley !

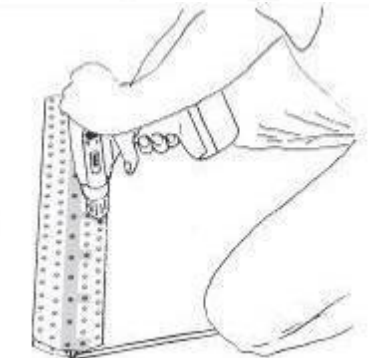
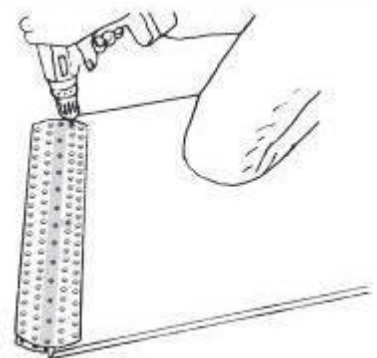
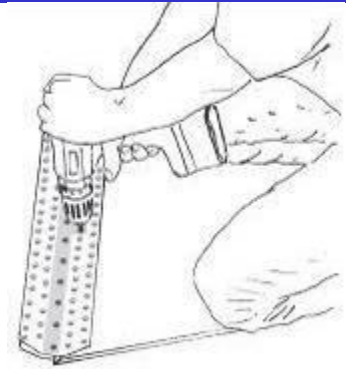
**Warning :**

- Super-Screw must lay on a flat and soft surface in which the screws can drill in, in case of over length.
- We recommend a professional powerful electric screw driver with 18 or 24 V or a powerful pneumatic screw driver (you need a torque 30 N/m soft !).
- Do not use an impact or percussion tool.

7.) Screwing The screws drill themselves through the belt. Start screwing by the centre, continue by one side, then the other without twisting Super-Screw. Keep screwing until the screws catches the underneath thread, and avoid to compress the belt to much. On a inclined plan, a second person posted on the side, can help to make sure that the screws are perpendicular.

Spread the screwing process over the whole of the surface, by first screwing one hole over four along the row. Repeat the operation over the two others rows. Then screw one hole over two and achieve the operation.

During screwing the screw driver must be **absolutely perpendicular to the belt surface** in order to ensure that the screws find the drafts in the fasteners metal pieces. Do not screws to much torque.



8.) In order to overlay both chamfered edges of the belt, unscrew the center parts and disassemble the thickness and alignment spacers (**absolutely obligatory for life time !**). Super-Screw will adapt automatically to the carcass thickness.

9.) Get into contact both belt ends, while ensuring the belt alignment.

10.) Resume screwing again the other half of Super-Screw as shown previously.

Then screw the centre part.

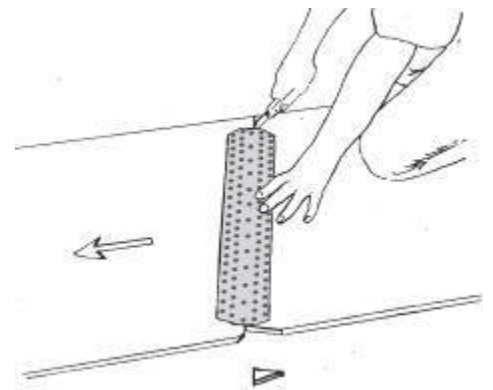
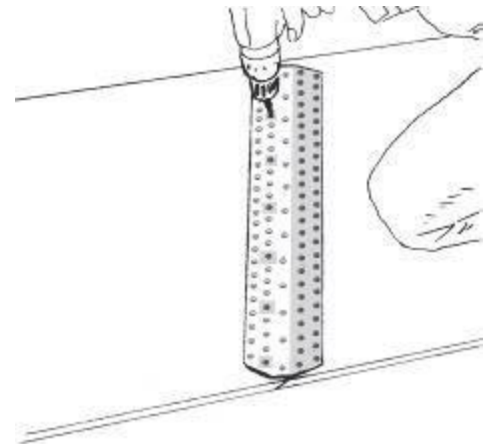
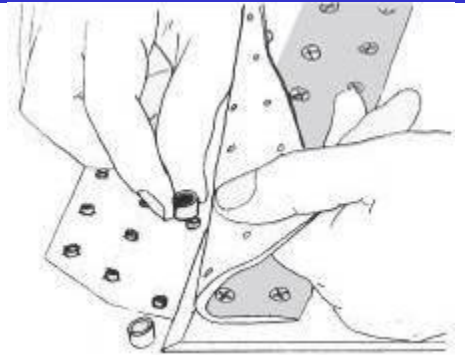
11.) Check all screws and if necessary tighten the screws and grind their points on the other side. The underneath part of Super-Screw must be in contact against the belt. Finally, if there is no belt continuity on Super-Screw side, cut the angles as shown.

If you want you can fill the gap between the cover of the belt and Super-Screw with filling glue or PU.

Now you can start the belt with full load without any restriction.

**Please take care :**

- The installation must be done on a flat surface - The screwing must be done with speed. If you do it slowly you should take some risks of pushing the metal inserts and to damage Super-Screw.
- If the screws are not tight enough unscrew them a little and screw them again with speed.
- The drive bits must be best quality, in order to accept the strong torque without damaging the screws.
- The screwing is good if you see a compression around the screws on the surface of Super-Screw (clamping effect) or when you can see a little the point of the screws on the bottom (but they don't have to come out !).



Compression through clamping Effect