

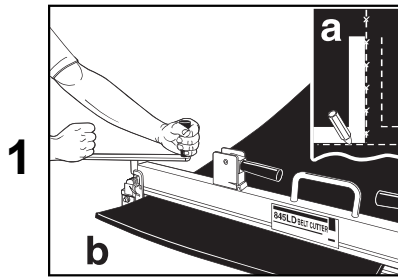
Assembly instruction Alligator belt joints on belts



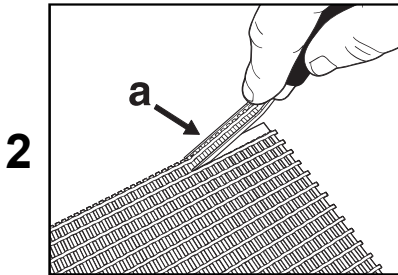
Joining must be performed by qualified personnel using original FLEXCO tools.

Please contact TKS to requisition tools (TKS no. 273649)

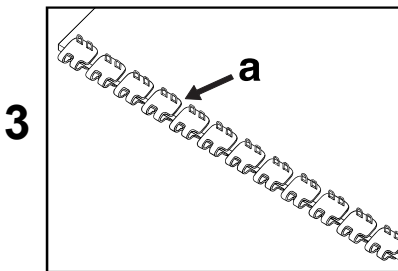
You can view the assembly video on YouTube by using the QR code



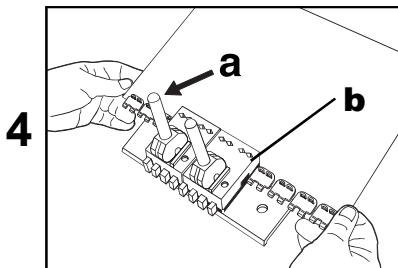
- Mark the cut line on the belt by angling the centre line on both sides (a)
- Cut the belt with a fine and straight cut.
- It is useful to use a tool to cut the belt (TKS no. 273652) (b)



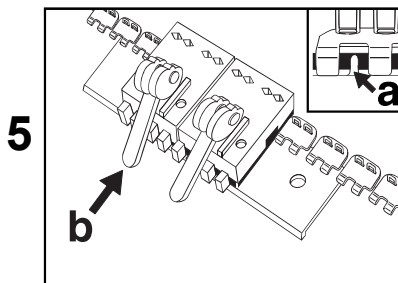
- Adjust the belt joint to the width of the belt
- 600 mm belt = 24 jaws.
- 500 mm belt = 20 jaws. Break off 4 jaws.
- The belt joint must always consist of continuous jaws.
- The location of the belt joint must be where the belt is 4 mm thick and has a minimum width of 20 mm.
- Pare off thick belts on the underside with a paring tool or use the belt grinder on a drill (a)



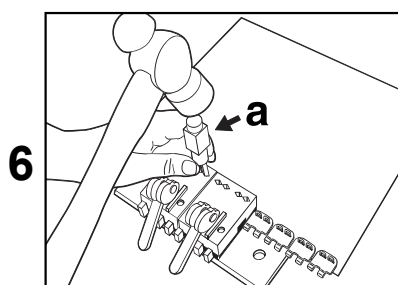
- Place the belt on a sturdy surface.
- Centre the belt joint (RS 125 S) to the belt so that there is an equal distance to the edges.
- The pins must be on the upper side (a)



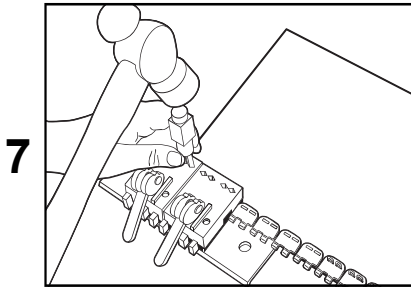
- Check that the tool has the block for 125 fitted
- Put the stamp tool in the centre of the belt
- The handles must point upwards (a)



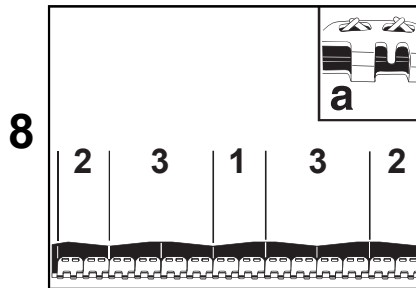
- The belt end must be pressed into the tags on the belt joint (a) and the belt joint must fit snugly into the tool before the handles are pressed down (b)



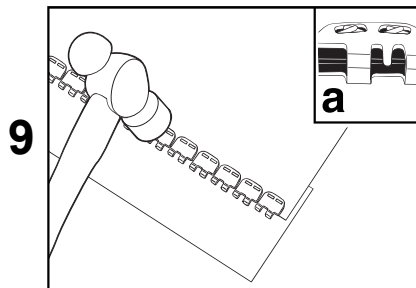
- Start by hammering the centre pin first (a)
- Use a 0.5 kg hammer
- The pins must be hammered down to the joint



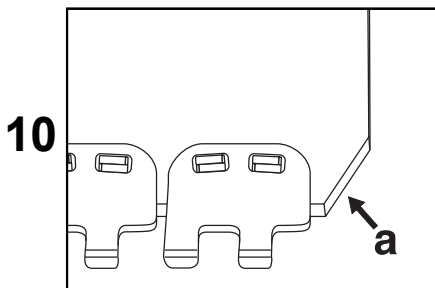
- Hammer the outer side afterwards
- Release the handles and move the tool
- Repeat point 6



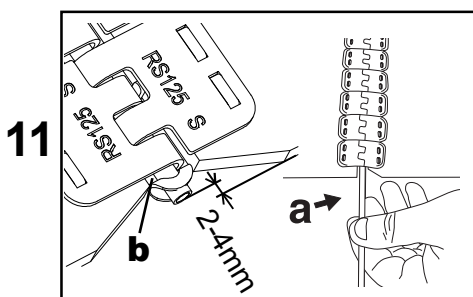
- Follow the procedure shown in the figure to hammer all of the pins
- The pins are half bent (**a**)



- Place the enclosed plate marked ST-28 under the belt.
- Hammer the pins down into the belt joint with solid blows of the hammer to lock the pins at the rear.
- Hit the pins backwards and forwards until all of the pins are completely bent down into the slot
- Avoid touching the end loops on the belt joint
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- Use pliers and clip off the edge of the belt end (**a**)
- Perform actions 1–10 on the other end of the belt



- Join together the ends of the belt and insert the lock wire
- Affix the lock washer and pinch together just as you did on the other end
- There must be no slack between the washers and the belt joint (**b**)
- Cut away any surplus wire
- The length of the wire must be 2–4 mm narrower than the belt

See the documentation about FLEXCO at:
www.flexco.com/products/alligator_ready_set