

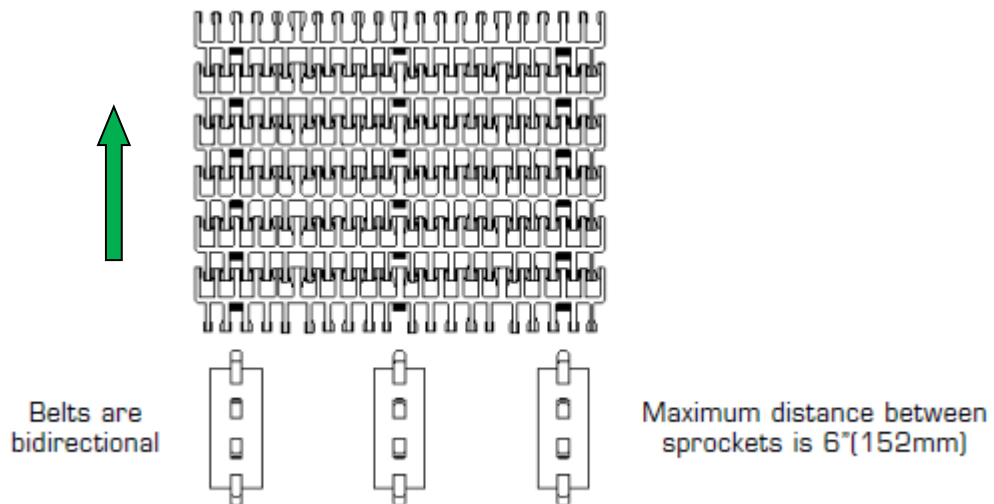
# HabasitLINK<sup>®</sup>

## Installation instructions for belt types SP615, SP620



**⚠ CAUTION: Acetal belts will burn with a flame that is nearly invisible**

Preferred running direction and position of sprockets:



**Belt assembly:**

| Belt width ≤ 50" (1270 mm)   | Belt width > 50" (1270 mm) and ≤ 98" (2490 mm)   | Belt width > 98" (2490 mm)   |
|--|--|--|
| Align the modules to be connected  | Align the modules to be connected  | Align the modules to be connected  |
| Insert the new rod   | Cut rods between ¼" to ½" shorter than the width of the belt, cutting one short one and one long one                                 | Cut rods and/or floaters to the right belt width, leave ¼" to ½" between these for expansion. Cut a long and a short rod             |
| Use a small plastic tipped hammer to tap the rod while supporting the outer knuckle until the head of the rod is flush with the belt | Insert rods from both sides, alternating short and long rod every pitch  | Insert rod from one side and the floater and rod from the other side alternating short and long rod every pitch                      |
| Trim off excess rod opposite head flush with the side of the belt  | Use a small plastic tipped hammer to tap the rod while supporting the outer knuckle until the head of the rod is flush with the belt | Use a small plastic tipped hammer to tap the rod while supporting the outer knuckle until the head of the rod is flush with the belt |

**Belt disassembly:**



Cut both sides of retainer ring.



Support shoulder with open cutters and...



tap rod through from other side.

Replace all removed rods as they will be damaged during disassembly.

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