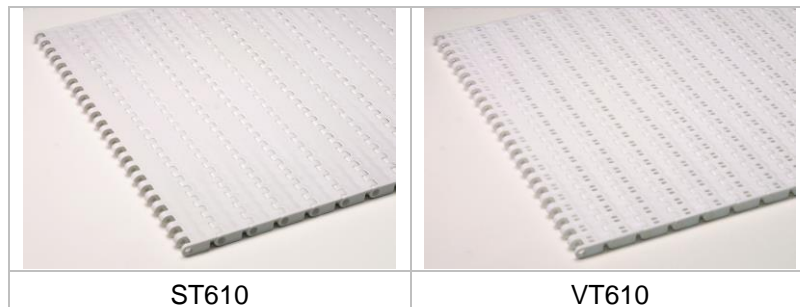


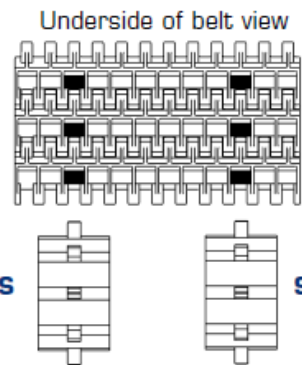
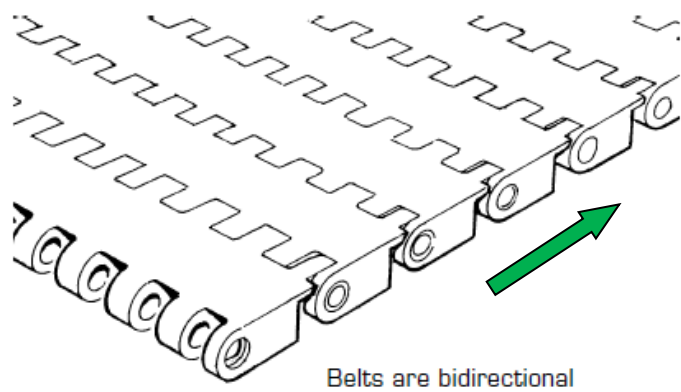
HabasitLINK[®]

Installation instructions for belt types ST610, VT610



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

Preferred running direction and position of sprockets:



Maximum distance between sprockets is 6" (152mm)



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:



Put a nail punch on the unheaded side of the rod and hit with a hammer.



The head will be exposed on the other side of the belt.

For Belt width over 25": Use a small chisel to cut away the retainer ring (positioned between second and third finger) on both sides of the belt from the underside of the belt. Be careful not to chisel through the belt. Remove remaining rod with a pin.

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

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