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Operating Instructions
3781

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Cutting tool set A-2410

The cutting tool set A-2410 is suitable for the simple manual die-cutting of Flexproof fingers for Habasit thermoplastic conveyor belts up to a thickness of 5 mm and of unlimited width. It is the simplest tool for on-site preparation of conveyor belts.
Belt ends are positioned on top of each other and stuck with double sided adhesive. A tape with the finger pattern printed on is stuck on the joint and the fingers are cut on a robust support surface using hammer and chisel.

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1. General information

1.1 Application

The cutting tools set A-2410 was specifically designed for the rapid and safe preparation (die-cutting) of Habasit conveyor belts using the Flexproof procedure. The maximum belt thickness is 5 mm/*0.2 in.* - the width is unlimited.

The cutting tool set A-2410 was developed solely for the purposes described in the operating instructions. Improper use, or use for other applications than those described in the instructions, is not permissible. Habasit accepts no liability for the consequences of improper application.

These operating instructions imply that all assembly, maintenance, and repair work, as well as operation of the die-cutting device, be carried out by skilled personnel or monitored by responsible specialists.

For reasons of scope, these instructions cannot cover all possible aspects of operation, maintenance, or repair. The indications given herein refer to the use of the tools according to their designated purpose by skilled personnel.

In case of doubt or if further detailed information is required, please contact the manufacturer (Section 1.4)

1.2 Important safety terms

In these operating instructions, you will find the terms WARNING, CAUTION, and INDICATION. They signal dangers or special information to be borne in mind.

WARNING	If disregarded, there is a danger of severe injury, and/or severe material damage.
CAUTION	If disregarded, there is a danger of injury, and/or material damage may be caused.
INDICATION	Technical information is emphasized if it is important and not readily apparent, even for skilled personnel.

Please observe all indications for assembling, operating, and maintaining this device, as well as all technical data! This will prevent possible trouble and/or damage to people or materials.

Skilled personnel refers to persons authorized to perform the required work. These people have been sufficiently trained and introduced to their field of activity so that they are able to recognize and prevent dangers. They are aware of the pertinent provisions and safety regulations.

1.3 Scope of supply

Qty.	Item
1	Chisel (cutting tool)
1	Hammer 400 g / *14 oz.*
1	Knife
1	Pair of scissors
1	Roll of self-adhesive paper strip with preprinted zigzag pattern
1	Roll of double-sided adhesive tape, white, width 60 mm / *2.4 in.*
1	Operating instructions

1.3.1 Available accessories

1	Spare blade for chisel
1	Spare shaft for chisel
1	Spare blade for knife
1	Cutting support of medium hardness, width 150 mm / *6 in.* (length = belt width to be cut)
1	Intermediate support (scrap piece of belt), width 100 mm / *4 in.* (length = belt width to be cut)

1.4 Ordering of accessories/spare parts

Spare parts and accessories can be ordered directly from the manufacturer.

Address:

Habasit Austria GmbH
Hetmanekgasse 13
A-1230 Wien
Tel. ++43 16 90 66
Fax ++43 16 90 66 10

Please accurately describe the parts required.

WARNING	The use of parts by other manufacturers not meeting Habasit specifications is not admissible. Habasit declines all responsibility for the consequences if non-Habasit parts are used.

1.5 Warranty

All tools undergo a strict final inspection. On the assumption of correct handling, they are warranted against material and manufacturing defects for 2 years.

1.6 Technical advice

Our specialists will be pleased to advise you. For technical questions concerning function and condition of the Flexproof-Cutter, please contact the manufacturer (Section 1.4).

2. Mode of operation

The fingers for the Flexproof joining method are manufactured at the belt ends by means of a manual cutting operation with one blade – a chisel – and a hammer.

To achieve the required accuracy the belt ends are positioned on top of each other and stuck with double sided adhesive. A tape with the finger pattern printed on is stuck on the joint. The Flexproof fingers are then cut manually step by step on a robust support surface using hammer and chisel.

The max. belt thickness that can be cut is 5 mm/*0.2 in.,* the max. possible belt width is unlimited.

3. Initial start-up

- ❑ Check to make sure that the surface where the belts are to be cut is clean.
- ❑ Check sharpness of the cutting blade

4. Cutting of belt ends

Process: Flexproof guidelines and individual product datasheets

- ❑ In case belt ends have been preshrunk, cut off residual thermoplastic residues which possibly protrude from the cut belt ends.
- ❑ Trace mark (3) on cutting support (1) and place intermediate support (2), conveying side up, exactly on the marked area of the cutting support (1) (see illustration 1).
- ❑ Put first belt end (A) conveying side up flush with the mark (3) on the intermediate support (2). Fix it with the double-sided adhesive tape (4) (see illustration 2).
- ❑ Put second belt end (B) conveying side up congruently on the lower belt end (A) making them overlap. Both belt ends must now be superimposed exactly (see illustration 3).
- ❑ Cut self-adhesive paper strip with preprinted zigzag pattern (5) to the required belt width. Remove covering foil and stick on paper strip flush and parallel with the edge of the upper belt end (B) (see illustration 3).
- ❑ Cut zigzag line according to preprinted pattern with chisel and hammer, thus cutting both belt ends together.

INDICATION	The support for this cutting operation must be even, robust and non-resilient!

- ❑ Cautiously separate incompletely cut spots with sharp knife or scissors.
- ❑ Remove carefully cutting residues and coarse fibers on the cut fingers with knife or scissors.
- ❑ The cut belt ends are ready now to be joined in a hot-pressing device.

5. Service

5.1 Maintenance

- ❑ Keep the cutting support clean at all times. Clean it regularly and remove material residues.
- ❑ Check the cutting blade periodically for its cutting ability and replace with the correct type if necessary.

5.2 Replacement of cutting blade

- ❑ Remove the two screws.
- ❑ Pull out the cutting blade from the shaft.

WARNING	Handle cutting blade with special care. The blade can cause injury even if it is worn out.

- ❑ Insert new cutting blade and tighten the screws.

CAUTION	Be sure not to damage blade edge.

6. Illustrations

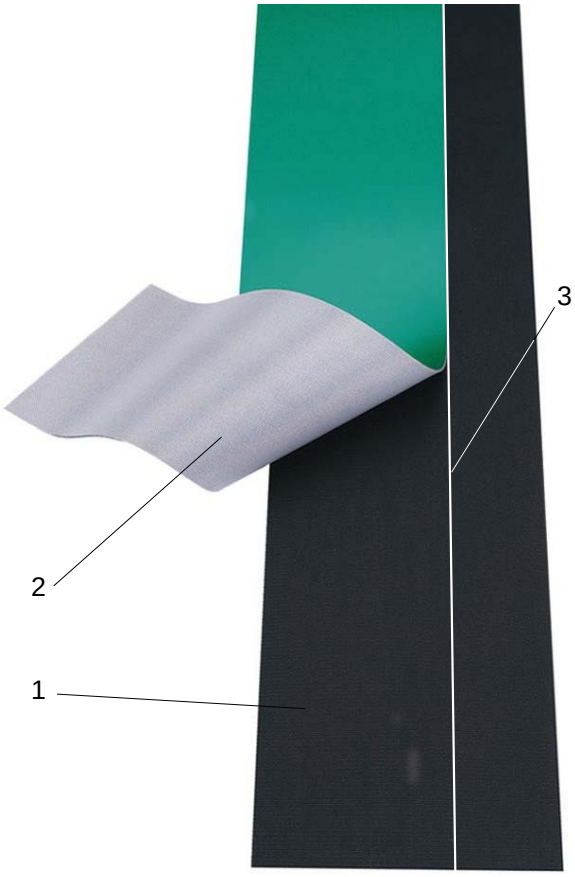

Illustration 1: Supporting layers

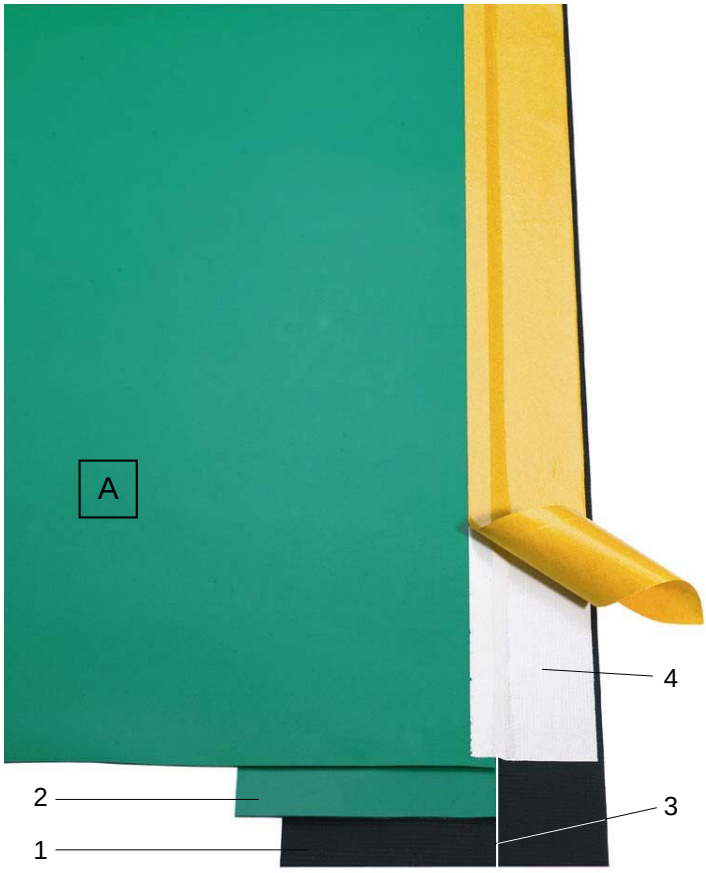

Illustration 2: First belt end

Legend:

1 Cutting support
2 Intermediate support
3 Mark
4 Double-sided self adhesive tape

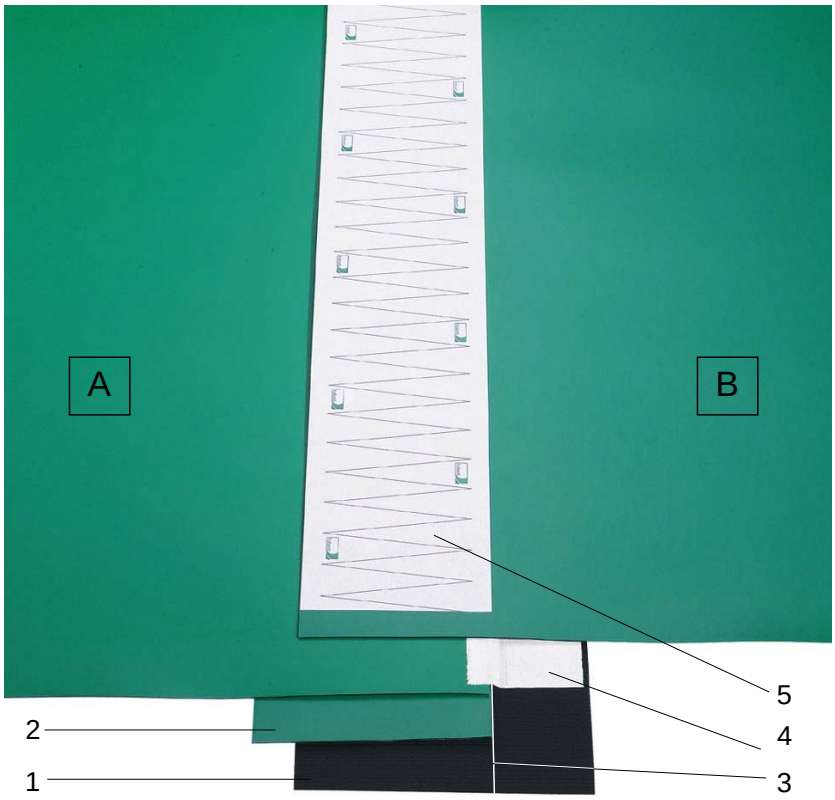

Illustration 3: Both belt ends prepared for cutting

Legend:

1 Cutting support
2 Intermediate support
3 Mark
4 Double-sided self adhesive tape
5 Paper strip with preprinted zigzag pattern

7. Technical data

Max. belt width [mm] *[in.]*	unlimited	
Max. belt thickness [mm] *[in.]*	5	*0.2*
Net weight [kg] *[lbs.]*	2.8	*6.2*

Product liability, application considerations

If the proper selection and application of Habasit products are not recommended by an authorized Habasit sales specialist, the selection and application of Habasit products, including the related area of product safety, are the responsibility of the customer.
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