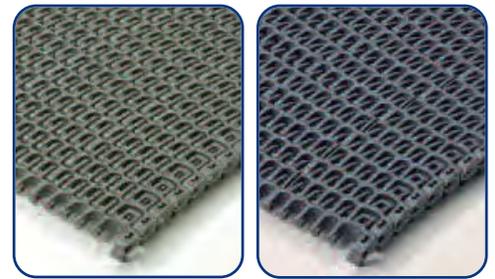




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IS61000

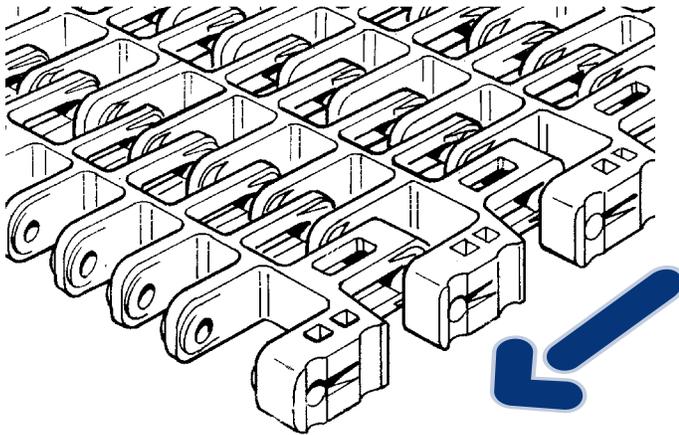
CT61000

KVP Belt Assembly and Disassembly:

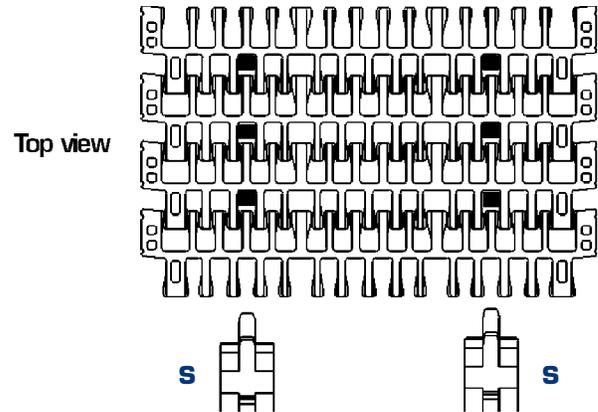
IS61000 (HDT)
CT61000 (HDT)

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

Preferred Running Direction/Position of Sprockets



Belts are bidirectional



Maximum distance between sprockets is 6"(152mm)

Assembly

Belt Width ≤ 24"(610mm)	Belt Width > 24"(610mm) & ≤ 48"(1220mm)	Belt Width > 48"(1220mm)
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 1/4" to 1/2" inch shorter than the width of the belt, cutting one short one and one long one	Cut rods and/or floater to the right belt width, leave 1/4" to 1/2" inch 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 a rod on 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

Disassembly



Use a small gate cutter to cut the end rod on both sides of the retainer ring, just inside the first finger. (First cut the "inner side," and then cut the "outer finger" side.)



Bending the belt at the hinge will make it easier to cut the retainer ring (if possible).



Cutters can be used to pry out the headed rod. After this, use a pin to push out the remaining rod.

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

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