



FEEDCHAIN AND FEEDBELT REPLACEMENT GUIDE

NARROW BELT MODELS (500mm WIDE)

You will need :

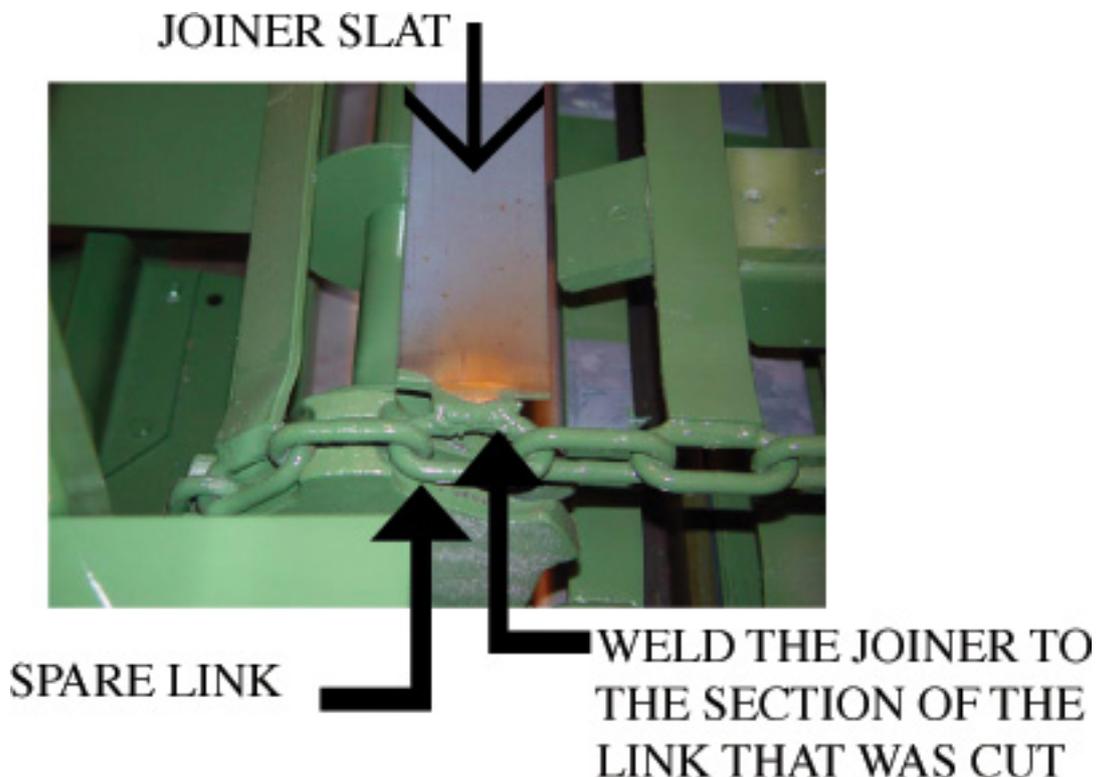
- 5 metres of belting (6m on BT5 Model)
- 60 to 66 stainless steel Tec Screws
- 60 TO 66 mudguard washers for belt join
- 5.5mm Drill Bit to pre-drill holes
- 4 ZP Flat Washers 8MM
- 4 1 1/4 X 1/4 CSK Bolt
- 4 1/4 Nyloc Nut
- 1 part pack SC2000 cement or similar
- 2 packs contact glue-metal to rubber

WIDE BELT MODELS (800mm WIDE)

- Belting
- 90 to 96 stainless steel tec screws
- 90 to 96 mudguard washers for belt join.
- 5.5mm Drill Bit to pre-drill holes
- 4 ZP Flat Washers 8mm
- 4 1 1/4 x 1/4 CSK Bolt
- 4 1/4 Nyloc Nut
- 1 part pack SC2000 cement or similar
- 2 packs contact glue-metal to rubber

REPLACING MULTISPREAD FEEDCHAIN

1. To replace your feedchain you must first remove the hopper from your machine. It is held to the chassis by 4-8 bolts.
2. With the hopper removed oxy cut a link which a slat is joined to, on both sides of the chain.
3. Remove the chain from the chassis. If you have access to a crane, lift the chain out from the top of the machine. If you don't have a crane or lifting device drag the chain toward the front of the machine to remove it. When removing the chain be careful not to damage the sprockets, shafts and the nylon runners the chain sits on.
4. With the old chain removed slacken the front idler shaft by using the slide bolts they run on.
5. The new chain will come rolled up. Put the chain toward the spinner end of the machine sitting it on the top nylon runners, keeping the chain rolled up.
6. Find each end of the chain and pull it around both the front idler shaft and the final drive shaft, making sure the chain is positioned in the sprockets correctly.
7. Where both ends meet you will need to position the joiner slat. (The slat is supplied loose when you purchase the chain, you will also have two spare chain links.) Use the spare links to join the chain ends together. Then weld the joiner to these spare links.



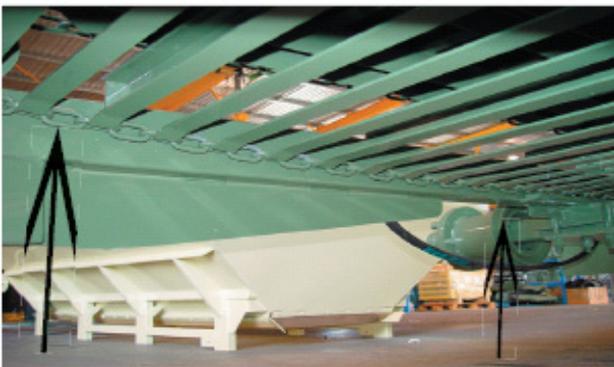
REPLACING MULTISPREAD FEEDCHAIN

8. Weld the joiner slat in position.

(see picture)



9. The next step is to tension the chain by using the two bolts located on the front idler shaft. Once the chain is tensioned ensure the slats are square by linking them up on top. The picture below shows the correct tensioning of the 825T and 840T models.



CHAIN

NYLON RUNNER

If the chain lifts above the bottom nylon runner this means it is over tensioned.
If chain drops below the chassis frame it is under tensioned.
This applies to models 825T and 840T only.

(see picture)



For 850T - 880T models tension chain to approximately 5mm above the front end of the nylon runner.

10. With the chain tensioned use a straight edge along the length of the chain to ensure the chain is correctly aligned. You may need to use a hammer to get the links running parallel.

See picture



REPLACING MULTISPREAD FEEDBELT

1. Turn feedchain so that the joiner slat is located at the spinner end of the machine.



2. Position the rubber so that one end is flush with the back edge of the joiner slat.



3. Ensure that the rubber is positioned centrally on the feedchain slats.



4. Clamp the feedchain to the joiner slat.



5. Also clamp the rubber to the feedchain at the front of the machine (As shown in the photo below).



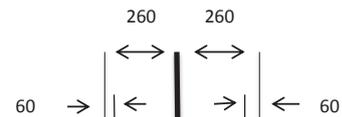
6. With the feed belt positioned square on the top side of the feedchain use a marker pen to mark where the tec screws are positioned depending upon the model of the feedchain. It is a good idea to use the old feedchain holes as a guide. However if you are replacing the **feedbelt only** use the alternative slats to avoid the existing holes in the feedchain.



500 SERIES PWB CHAIN

Tecs go in every third slat on PWB chain.

**measure from the side of the feedbelt



800 SERIES PWB CHAIN

Tecs go in every third slat on PWB chain.

**measure from the side of the feedbelt



REPLACING MULTISPREAD FEEDBELT

7. Pre drill the holes that have been marked out with a 5.5 drill bit.



8. After pre-drilling all the holes on the top side of the feedbelt install the stainless steel tec screws and 1/4" washers.

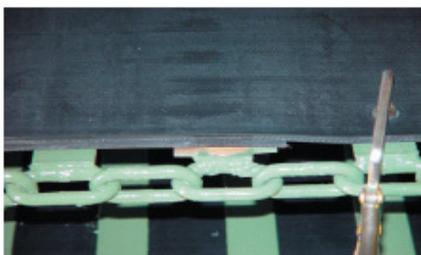


9. After installing the tec screws along the top side of the feedbelt unclamp the belt at the joiner slat and at the front of the machine. Turn the belt so that the section of the chain that has not had the rubber installed comes to the top of machine.



10. Once again clamp the section of the belt that will have the tecs now installed. Repeat steps 6-8.

11. At this stage you should have the tec screws in the entire belt and the two ends of the feedbelt so that they overlap on the centre of the joiner slats.



12. Next you will need to cut both ends of the feedbelt so that they join in the centre of the joiner slat. Use a marker pen and a straight edge to mark the middle of the joiner slat, mark and cut the top piece, the bottom piece and add 1mm before cutting.

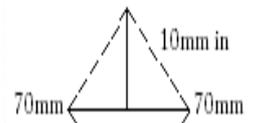


13. Once marked use a Stanley Knife to cut the belt along the centre line.



- 14.(a) Once cut, the two ends should meet up against each other in the centre of the joiner slat.

- 14.(b) On the edge of the join, mark 10mm in towards the centre of the belt join and cut each end of belt joined on an angle back 70mm each way. (see picture below)



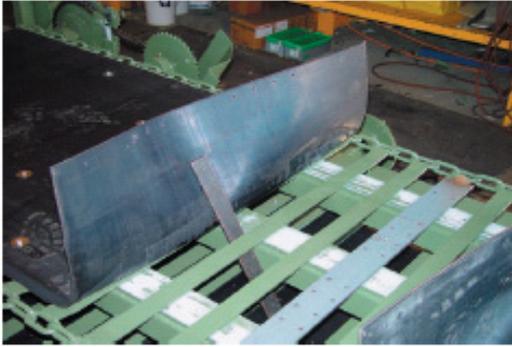
15. Clamp both ends down on the joiner and pre drill the holes using a 5.5 drill bit. Use your old joiner slat as a template marking these holes. Clean the area thoroughly.

Do not put the tecs in yet.



REPLACING MULTISPREAD FEEDBELT

16. Use two pieces of steel to lift the belt up as shown in picture below.



22. Put the hopper back on your machine.

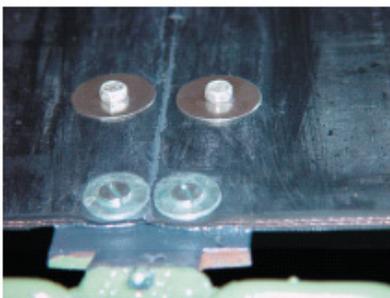
17. Use an angle grinder to rough up the underside edge of each end of the belt. The underside is where the glue will be applied.

18. Mix the glue contents and hardener. Stir thoroughly. Apply first coat to underside of both belt ends and the belt joiner slat.

19. Allow this coat to dry.

20. Apply second coat to the belt ends and joiner slat. Leave until **Touch Dry**. Then push both ends firmly down onto the belt joiner slat and lightly hit with a hammer.

21. Place the stainless steel tecs into pre-drilled holes in the joiner slat. In the tec and glue kit there are four gutter bolts with nylon nuts. Place these gutter bolts in the two outside holes of the joiner slat. If you use a tec screw in this position it will result in excess wear to the skirting rubber.



Cement SC 4000

Fields of application: CFC-Free, two-component-adhesive for bonding rubber to rubber, rubber to fabric, rubber to metal, fabric to fabric.

Application:

Preparing:

- Ambient and material temperature +5 °C up to +45 °C.
- Avoid direct sunlight, avoid the temperature falling below the dew point (formation of condensation water).
- **Bonding surfaces:** Dry free from chemicals, grease and oil.
- **Metal:** Derust and roughen metal surface preferably by grit blasting (DIN EN ISO 12944-4, SA 2,5) or by grinding- recommended depth : 30mm. Remove the grease from the cleaned surface area with TIP TOP cleaner R4, if necessary. Apply one coat of TIP TOP METAL PRIMER PR 200 or 400. Allow the coat to dry completely.
- **Rubber:** Buff thoroughly (no bright surfaces areas!) Remove dust without using any fluid.
- **Fabric:** Buff the rest of rubber until they are even and lightly buff the fabric with care (don't damage it). Remove buffing dust without using any fluid.

Mixing: Stir Cement SC 4000 thoroughly. Mix the required quantity of Cement SC 400 with hardener E-40 (4% of the total weight) by stirring thoroughly until homogeneous mixture is obtained. Use the mixture within 2 hours (potlife).

Applying the Coats: Apply 2 even and thin coats onto each bonding surface. Allow the first coat to dry completely (at least 30 minutes and at least 1 hour on metal). Let the second coat dry until it is still slightly tacky (check with the back of your finger). In case of overdrying, apply another coat.

Note: Only one coat is required for TIP TOP special rubber with CN bonding layer.

Bonding: Put the bonding surfaces on one another, avoiding air inclusions. Stitch on tightly or press on.

Caution: Observe the hazard information and safety advice on the tins or tubes.

Note: The above - mentioned information is the result of field trial. Because of the differences in materials and operating condition which are beyond our control, we recommend in any event that you conduct adequate tests of your own. No liability of any kind can be deduced from this information.