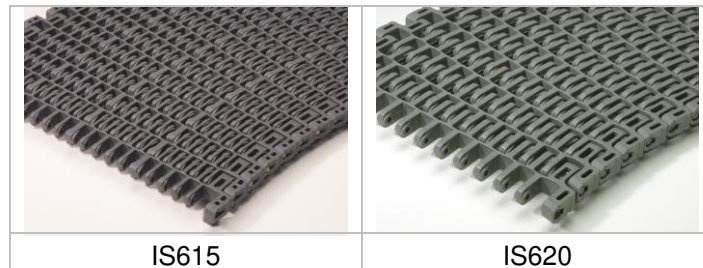


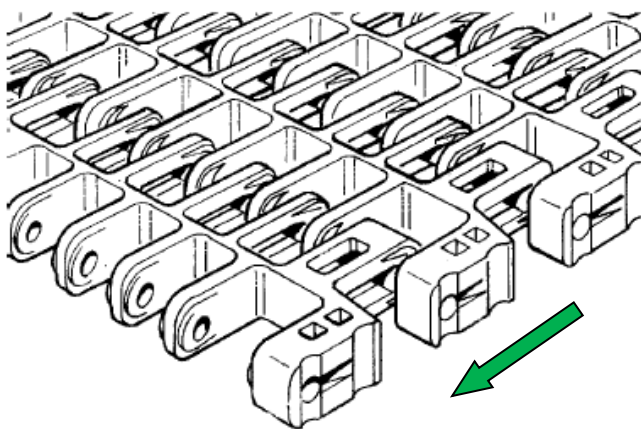
HabasitLINK®

Installation instructions for belt types IS615, IS620

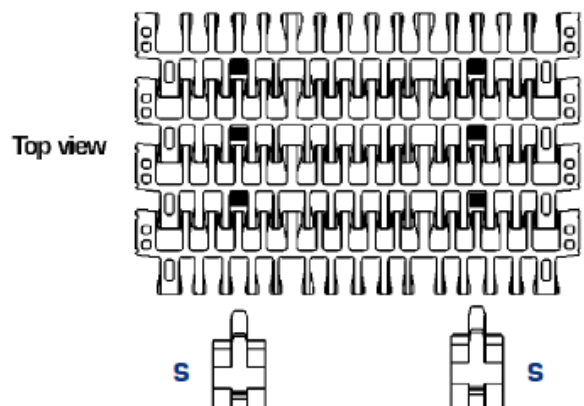


⚠ CAUTION: Acetal belts will burn with a flame that is nearly invisible

Preferred running direction and position of sprockets:



Belts are bidirectional



Maximum distance between sprockets is 6" (152mm)



Belt assembly:

Belt width ≤ 24" (610 mm)	Belt width > 24" (610 mm) and ≤ 48" (1220 mm)	Belt width > 48" (1220 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:



Retainer rings, behind the first finger.



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



Use a flat screwdriver to push the head partly out of the finger until the head is exposed.



Use a screwdriver to pull out the head of the rod completely. 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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