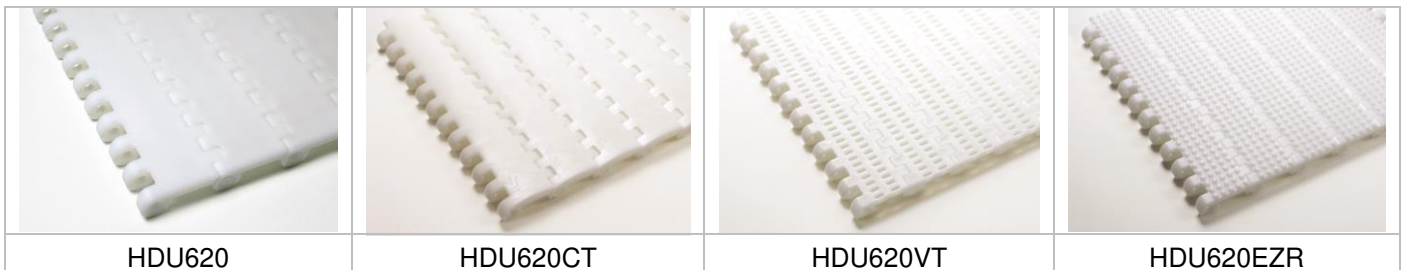


HabasitLINK[®]

Installation instructions for belt types HDU620, HDU620CT, HDU620VT, HDU620EZR



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

Preferred running direction and position of sprockets:



Belt will run the same in either direction

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:



Use a 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.)



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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