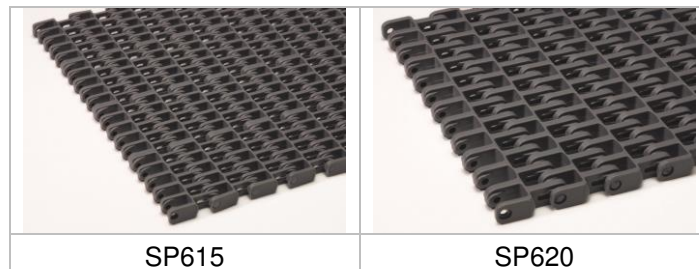


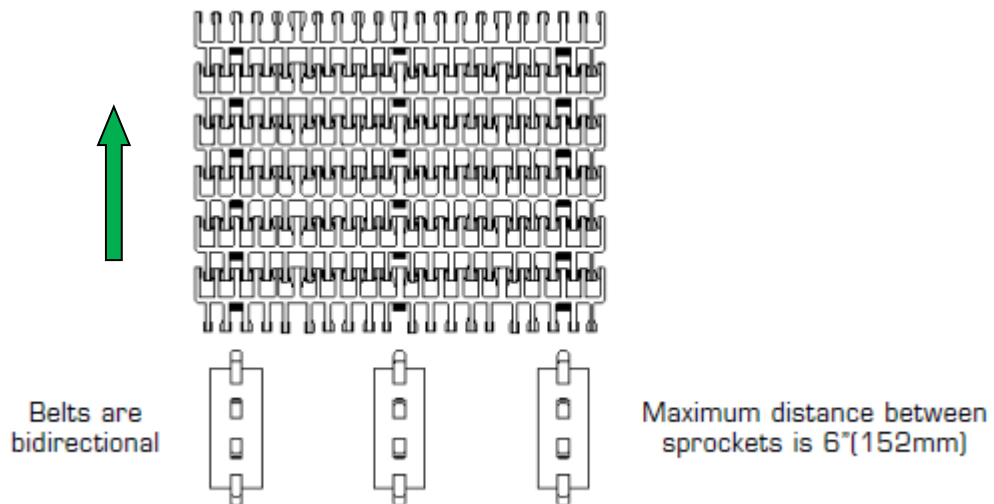
# HabasitLINK®

## Installation instructions for belt types SP615, SP620



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

Preferred running direction and position of sprockets:



**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:**



Cut both sides of retainer ring.



Support shoulder with open cutters and...



tap rod through from other side.

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

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