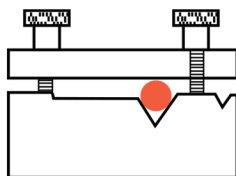


# WELDING THERMOPLASTIC PROFILE BELTING



## STEP 1

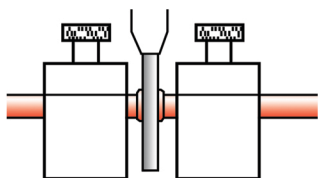
Cut belt to desired length. Clean belt surface to remove dirt and grease.  
Pre-heat welder at least 10 minutes.



## STEP 2

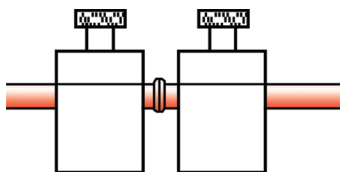
Allow adequate over-hang on each side of the clamp when installing belt into *Black-Max* bonding fixture.

Use *Auto-Spacer* prop to keep jaw faces apart allowing heatwand to be inserted between belt ends.



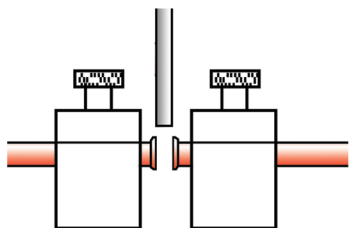
## STEP 3

Place the heated welder head between the belt ends and close bonder jaws lightly until the profile ends melt equally and form approximately a 1/16" bead.



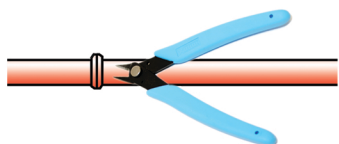
## STEP 4

Open the bonder and quickly pull welder away. Avoid dragging melted material out of joint area.



## STEP 5

Close bonder quickly allowing pre-set spring pressure to hold jaws firmly together or tighten thumb screw. Depending on belt diameter, wait 6-10 minutes for heated area to cool.



## STEP 6

Take welded belt out of belt bonder and remove welding flash from belt with trim cutters.

Belt is welded and ready for service!