

To ensure correct and safe usage of this product, please read carefully this manual first



# Chain conveyer

**TYPE: PLD O, PLD B, PLD H**



Instructions for shortening and connecting  
the belt

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This instruction serves as a recommended belt shortening and splicing procedure if the conveyor is not supplied with a fully installed belt.



Take extra care - risk of injury!

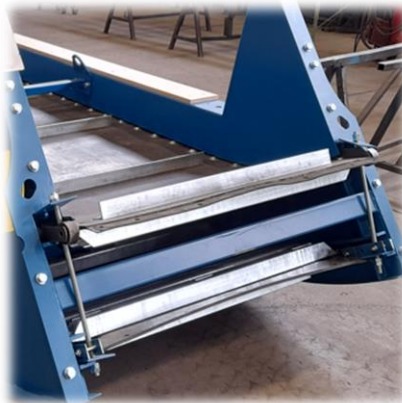


**Connecting the parts of the belt and installing the belt**

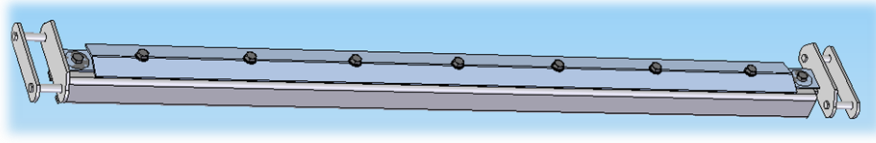
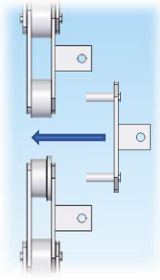
**[A]** The belt is delivered separately on pallets in several pieces (mostly in lengths of approx. 10 m + finishing measure)



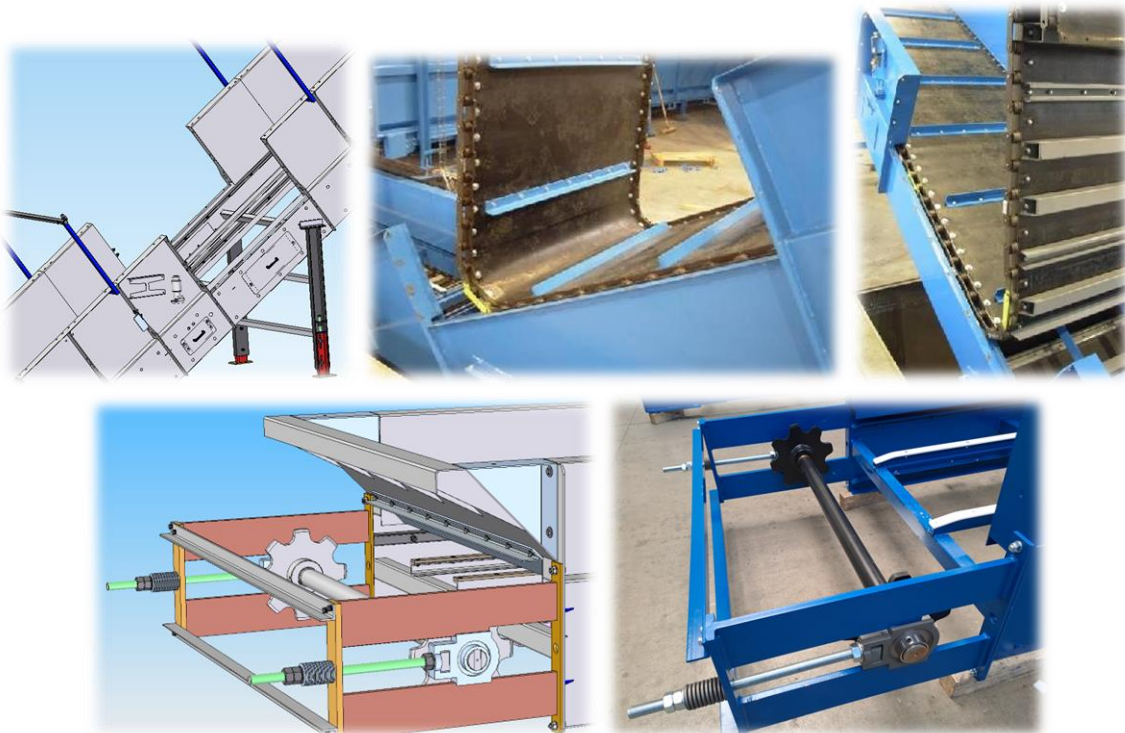
**[B]** or the belt is "pulled" in individual parts of the conveyor




**Ad[A]** The individual parts of the belt are connected into a whole before the actual assembly of the belt using a coupling that is supplied together with the belt.

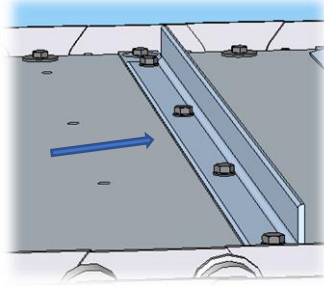



The belt begins to be installed in the area of the mounting side (upper route) and/or in the area of the tensioning head (lower or upper route). It always depends on the spatial possibilities of a specific installation.



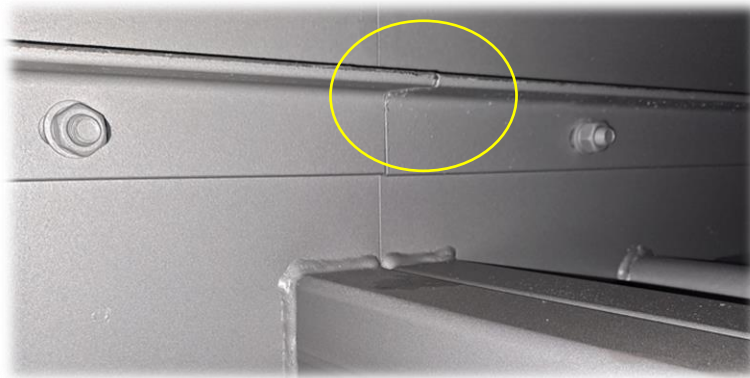



 Pay attention to the correct orientation of the belt for the belt with drivers (steel L profiles). The outer side of the drive must be in the direction of the conveyor.



 When installing the belt in the part of the drive head, pay attention to the verticality of the shaft and the belt (pay attention to the displacement of the chain on the teeth on one side).

**Ad[B]** Connect the belt first, then screw the section together. **Pay attention to the correct seating of the sections and the exact continuity of the rails.**

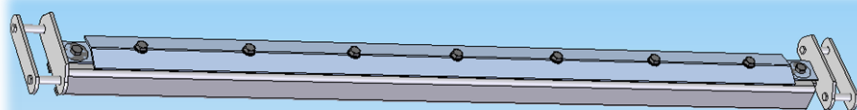
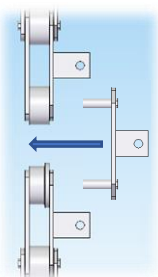


 Take extra care when handling the pulled belt. There is a risk of injury when the belt is pulled out of the section!



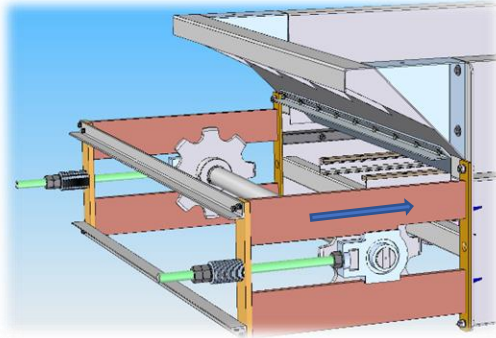
Threaded rods are used to secure the belt against movement during transport and handling, which must be removed before connecting the belt.

You connect the belt using the chain link supplied together with the belt.



## 2 Shortening and final connection of the belt

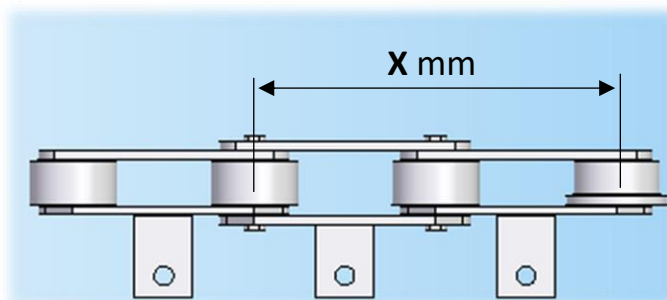
Move the tension head shaft to the minimum position as close to the conveyor section as possible.



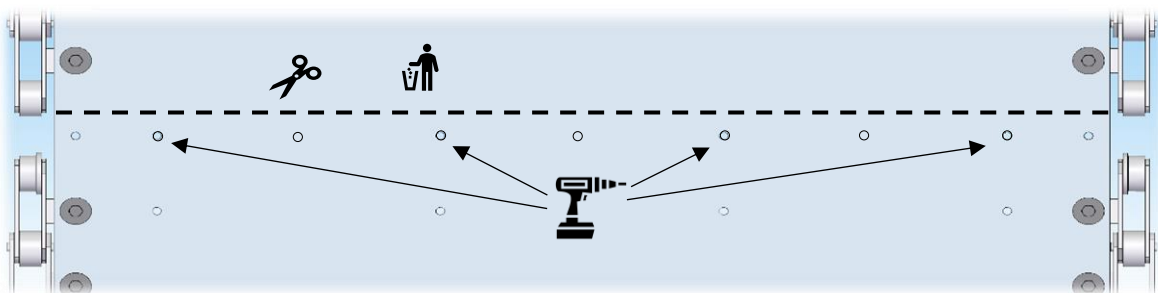
The belt is always delivered a few links longer and must be shortened for proper fit. The reason for this is the possibility of safely securing belts installed in sections.

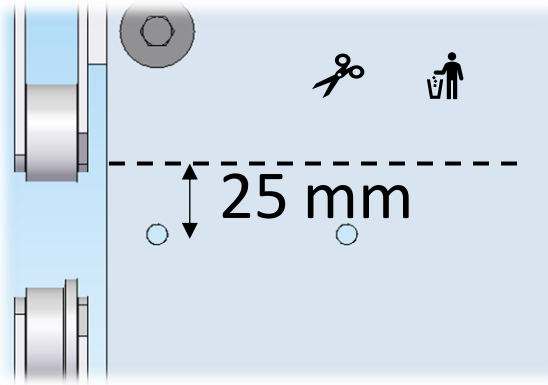
The chain can only be disconnected on the wider link (pins must be ground off), i.e. you must always shorten the belt by a multiple of the distance between the two chain links (X), e.g.:

- a) Version TR – type H => shorten by a multiple of the length of 250 mm
- b) Version LR – type O => shorten by a multiple of the length of 200 mm

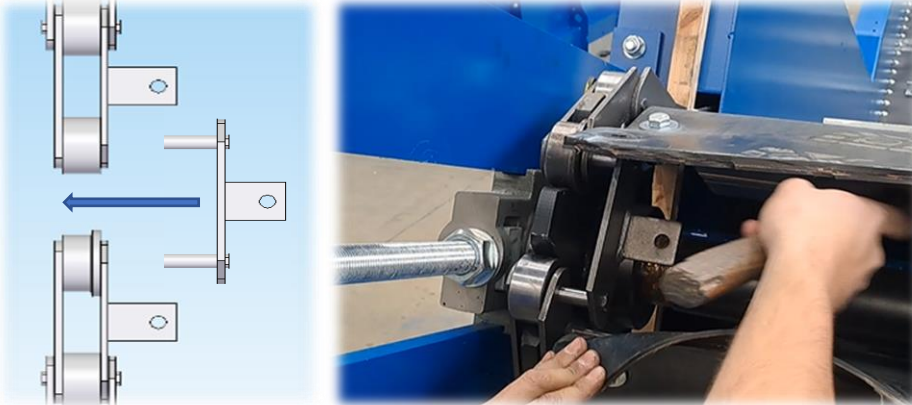


Drill the necessary holes according to the spacing of the belt-connection holes. The cut of the belt is made at a distance of 25 mm from the axis of the last hole for fastening the chain.

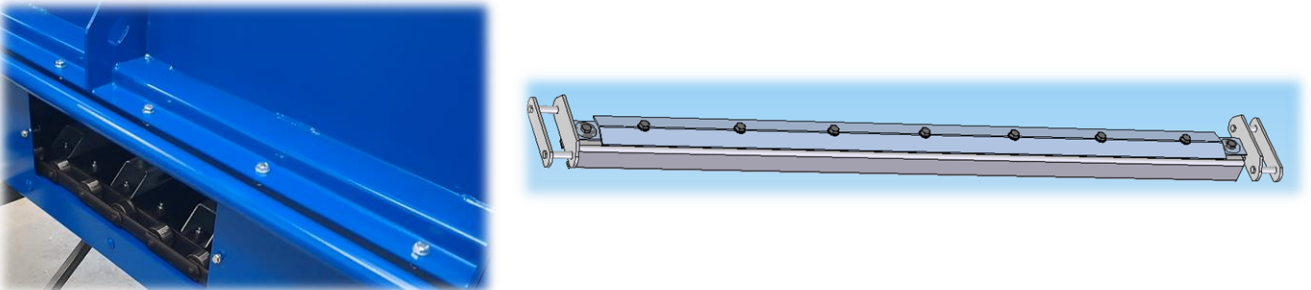




Connect the chain using the chain coupler. Now you can move the belt carefully.



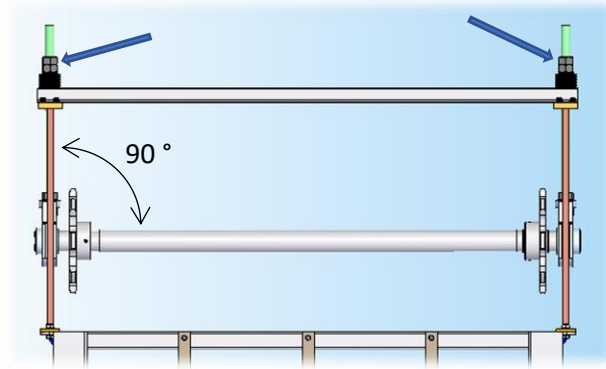
For better access to the screw joints, move the belt joint into the mounting window area and perform the final installation of the coupling.



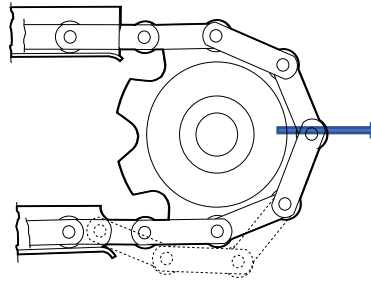
### 3

#### **Belt tensioning and adjustment**

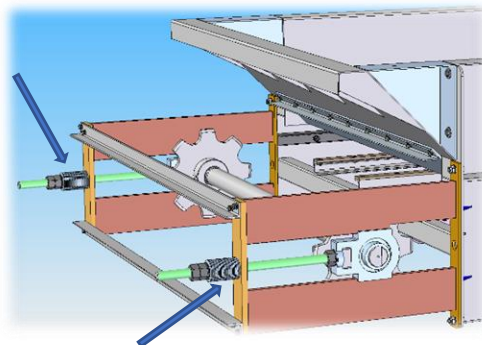
Belt tensioning is done using the clamping nut of the tensioning head. The shaft must always be perpendicular to the conveyor section. You can ensure this by stretching both sides by the same length (verify the same distance by measuring).



Tighten the belt until the belt no longer sags on the sprocket.



When correctly tensioned, the washers of the tensioning screw must not move freely, but at the same time they must still spring.



**i** **Note:** The required belt tension is different on each conveyor. It depends on many factors, such as the length of the belt, the characteristics of the transported product or the speed of the conveyor.

**!** The belt must be tensioned so that there is no risk of the chain jumping over the teeth of the chain. At the same time, the chain must not be too tight - this causes greater and faster wear of parts of the chain and chain tracks.

After tensioning the belt, let the conveyor run without load for several minutes. Observe the behavior of the belt. Then check the belt tension again, adjust the tension if necessary and repeat the process.