



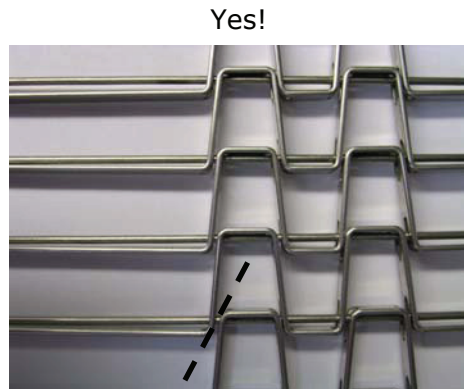
# DURAFLEX® Installation Instructions

## Removing the Belt

Should you need to remove belt from the unit simply cut the connecting rod.  
**BE CAREFUL NOT TO CUT THE STRIP!**

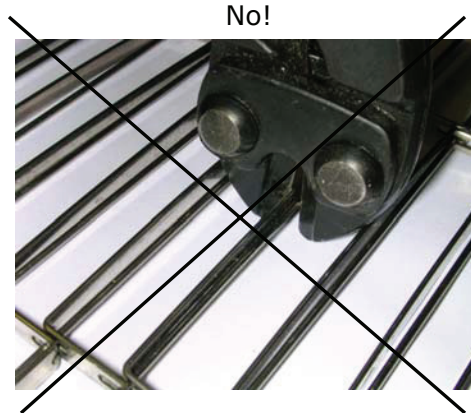
Or

You may twist the connecting rod back out of the openings



Yes!

Cut rod only



No!

## Troubleshooting

Problem	Suggestion
You see a pronounced gap in belt openings	Check to make sure belt is spliced properly and that connecting rod passes through all openings. See Making the Belt Endless #6 on previous page.
One edge of the belt is leading the other	Check to make sure belt has not jumped sprockets.
Rods are unhooked	Ensure proper handling during installation. See Making the Belt Endless #2 on previous page. Use pliers to re-engage the rods.
You notice edge damage on the belt	Check to make sure the belt path is free and clear of obstructions.
<b>You notice deflection across the width of the belt</b>	<b>Check to make sure the sprockets are properly aligned across the width of the belt or if using nosebar check to make sure diameter is sufficient.</b>

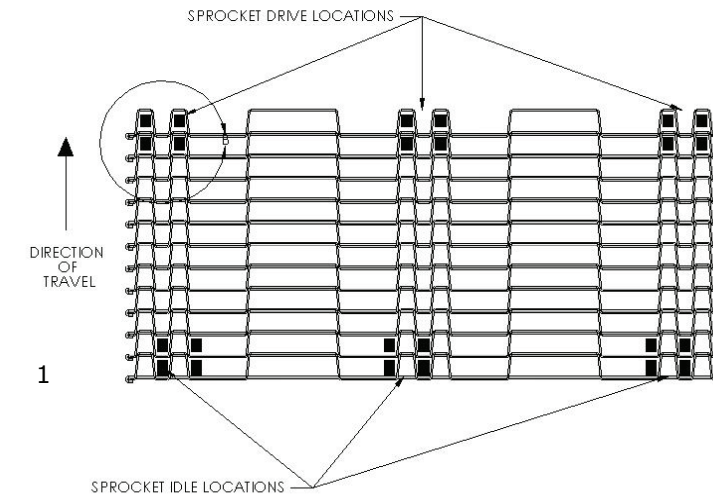
\*Patent pending  
\*\*US patent #7,721,877

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## DURAFLEX Belt



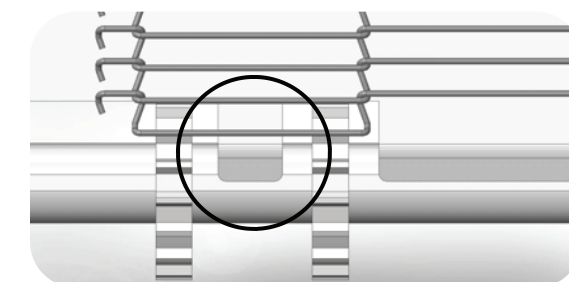
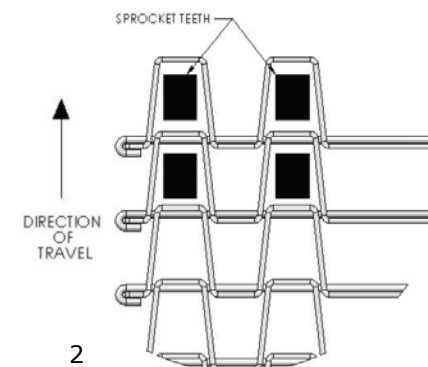
### **Critical information prior to beginning installation and start up**

- Insert pipe through center of roll to support belt. Do not lift/handle rolls of belting by the sides only.
- DURAFLEX\* works with existing slider pans, slider beds and support rails
- Try and make sure unit is as square as possible
- Belt path should be free of any obstructions
- There is no top or bottom to the belt
- Ensure sprockets are properly engaged in openings as explained in picture 1 and that they are engaged in the same openings across the full width of belt
- Make sure edges of belt are not rubbing on anything
- Run the system with minimum tension

### **Installing Sprockets & Nosebars**

#### A) Installing drive sprockets

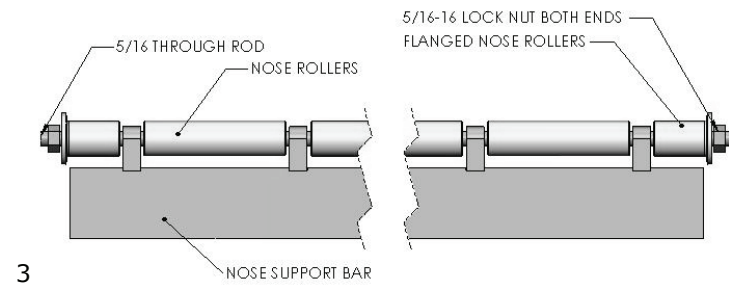
1. To set up drive sprockets use the belt as a template
2. Dual tooth sprockets engage in drive (smaller) openings of belt across width
3. Make sure sprocket teeth are engaged in same openings across full width of belt
4. Ensure sprocket teeth are driving against the connecting rods (not the strip)
5. The degree of wrap on sprockets should be no more than 180 degrees
6. Key sprockets down on the shaft



Bend or remove pan "tabs" as needed to correctly install sprockets

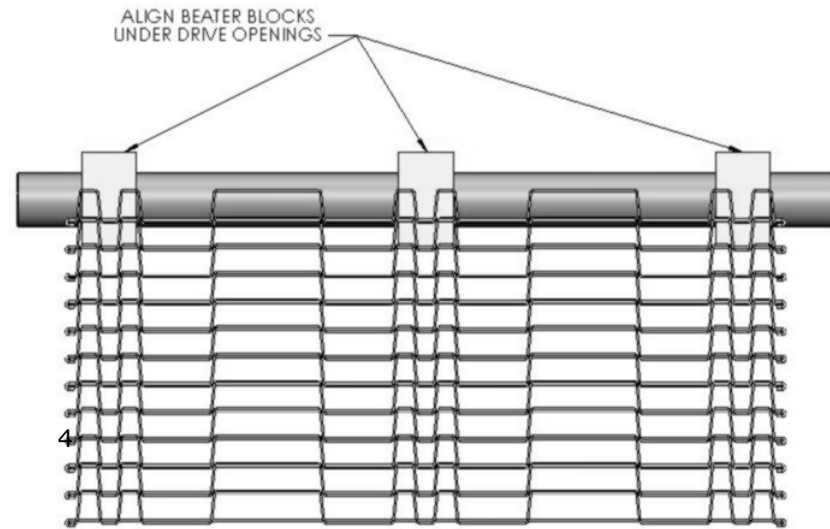
**\*IF USING NOSEBARS-MINIMUM DIAMETER IS 3/4" (0.75")**

\*\* SEE DRAWING 3 INDICATING NOSE ROLLER SUPPORT MODIFICATIONS FOR FINGERS



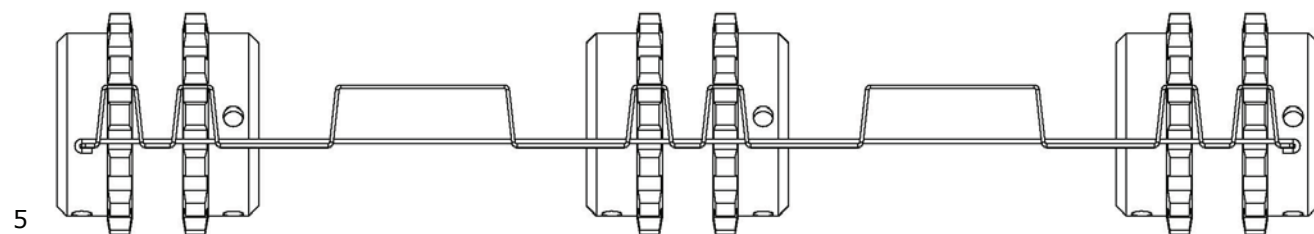
3 Cut flanged nose rollers to required length

**\*\*\* VERY IMPORTANT: IF USING BEATER BLOCKS (VIBRATORY BLOCKS) SEE DRAWING 4 INDICATING BEATER BLOCK PLACEMENT- THEY NEED TO BE LOCATED UNDERNEATH OF DRIVE OPENINGS (SMALL OPENINGS) IN ORDER TO CLEAR OUT MATERIAL BUILD UP AND DECREASE WEAR ON BEATER BLOCK**



**Installing Self-Cleaning sprockets**

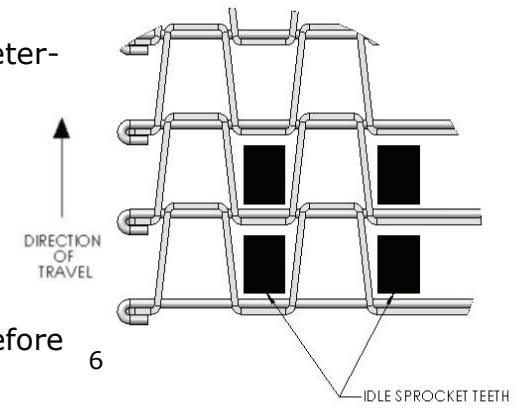
1. Self-cleaning sprockets are to be paired together with hubs facing out. See Drawing 5
2. Double check sprocket teeth are engaging against the rods to ensure proper placement.



5

**B) Installing Idle sprockets**

1. To set up idle sprockets use belt as template to determine sprocket placement
2. Place idle sprockets in one opening over from smaller openings so that 1 tooth is engaged in smaller opening and 1 tooth is engaged in longer opening. See drawing 6.
3. Ensure sprocket teeth are engaging against the connecting rods (not the strip), keep in mind that the belt engages the sprocket on idler shafts therefore the openings will be different than the drive
4. Key all idle sprockets down onto shaft



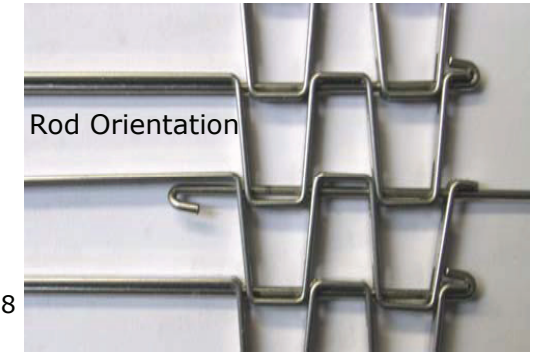
6

**Making the Belt Endless**

1. If take-up on the conveyor is adjustable, set to minimum for installation
2. Insert a pipe that is 2' longer than the belt width through the center of the roll to evenly support the belt at all times. Set belt on pipe in stands or crate to allow belt to free roll during installation, see picture 7. **Do not handle rolls of belting by the edges only.**
3. Orient belt for proper direction of travel, see picture 8
4. If installation under tension is required, pull ends so they mesh together and use wire ties to secure belt ends for rod insertion
5. Locate Kwik Connect\*\* hooked end rods supplied and orient as shown in picture



7



8

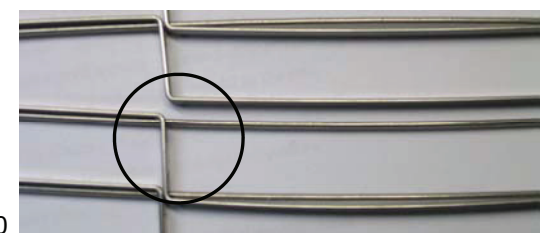
6. Take hooked connecting rod supplied with the belt and insert **being certain** to engage **all openings**, refer to pictures 9 and 10
7. When rod is approximately 1/2" from being fully inserted, orient it so the hook fits over the tab on insertion side
8. Lock hooked edge of rod around tab on opposite belt edge
9. Apply minimum amount of tension required

Correct



9

Incorrect



10

**When starting up the unit for the first time, make sure all rods are engaged at the edge of the belt. Run slowly to ensure smooth operation of belting and proper sprocket placement**