

Operating Instructions for **MÄRTENS – Finger punching device, movable**



- applicable for all belt widths
- easy handling (19 kg)
- for straight or diagonal finger splices (dependant from punching knife)

Constituents:

Movable finger punch
Punch knife beam

For special notice:

Finger punching device exclusively is allowed to be used for preparation of plastic conveyor belts and is not permitted to be employed for other applications.

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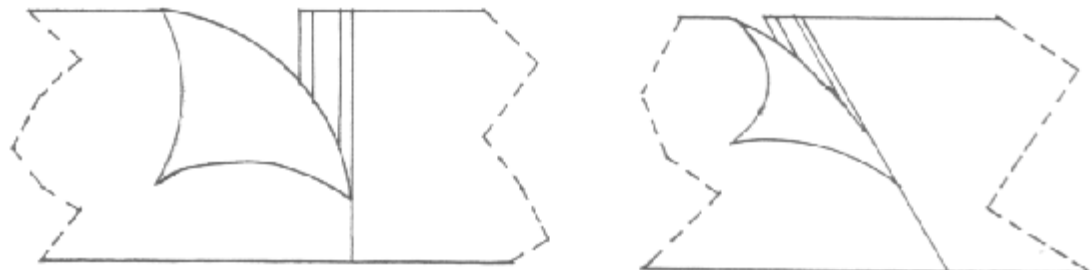
I) **Preparation works of Conveyor belt ends**

1.0 Fundamentally we recommend using a diagonal splice wherever possible. Only under unfavorable conditions a right-angled splice should be made.

1.1 **Required overlap area**

Cut belt length + 120 mm allowance.

2.0 Mark a line 120 mm from one belt end and affix 20 mm wide double-sided adhesive tape across the full width of belt between the line and the belt end.



Overlap the belt ends and secure with the adhesive tape.

MAKE SURE THAT THE BELT IS STRAIGHT AND ALIGNED IN RUNNING DIRECTION

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II) Handling of finger punching device

- 1.0 When the belt has been installed and punching procedure has to be effected within the machine, belt is to be fixed in sufficient distance from the operating area.

A wooden plate is to be installed beneath the punch area, which mainly at the starting area should project beyond the belt end, in order that the finger punch is supported, sufficiently.

- 2.0 Finger punching device will be inserted into the belt one-sided, and finger punching knife is to be adjusted under the belt, carefully.
- 3.0 The first punching procedure can be started, i.e. close turning valve and bring device to pressure by actuating the hydraulic pump.

Notice: IN THIS DEVICE A DETENT IS MOUNTED, I.E. PRESSURE CAN BE PROCURED UNTIL MATERIAL HAS BEEN PUNCHED THROUGH AUDIBLE:

- 4.0 After having finished punching procedure, the turning valve should be opened and the pressure beam will be lifted automatically. Finger punch is to be pushed for 1 further section into the belt, and punching procedure must be repeated.
- 5.0 As soon as belt edges touch the frame of punching device, the pre-punched fingers have to be drawn asunder (Zip-fastener system), in order that the belt can be pushed again into the punching device later-on for the next punching procedure.

Notice:
DURING THIS OPERATION STEP, CYLINDER OF PUNCH DEVICE HAS TO BE KEPT UNDER PRESSURE, IN ORDER THAT THE FINGERS WILL NOT BE DRAWN ASUNDER, TOO MUCH:

This procedure is to be repeated so often, until the other belt edge is reached.

- 6.0 Punching remainders and glue stripes are to be removed. Now the belt ends are prepared for fitting-out a finger splice, subsequently.