

**KNOWLEDGE BASE**Article Type: **Instructions****V and Round (VAR) Belt, Splicing,
Welding Installation, Instructions****Description:**

Instructions on “How to” properly splice, weld, and install V and Round (VAR) Belting. Splice kit part # - vendor VOS32/D-GT, colmac # 428487, Belting part # vendor VOS22/CGT, colmac # 428488.

WARNING

Never work on, clean or service this unit, control panel or any machine or open or remove any protective cover, guard, grate, door, or maintenance panel until the power or energy sources has been turned off, locked out / tagged out, and all moving parts have come to a complete stop and or blocked to prevent movement. Machinery is dangerous - avoid personal injury and or death by following manufacture, Local, and OSHA safety procedures. Contact Columbia Machine for safety decals, guards, horns and beacons.

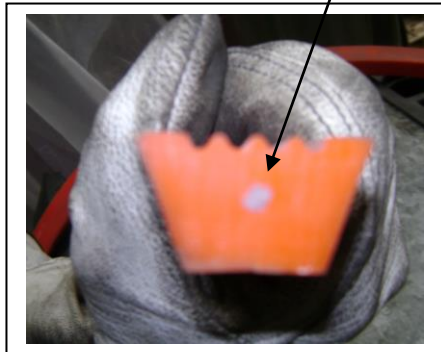
V and Round (VAR) BELT, SPLICING, WELDING, INSTALLATION, INSTRUCTIONS, and PHOTOS.

The following pictures show the splicing process. Use the instructions on (pages 4 & 5), please follow them along with the photos below. Splice kit part# vendor-VOS32/D-GT, colmac #428487, Belt part # vendor – VOS22/C-GT, Colmac #428488

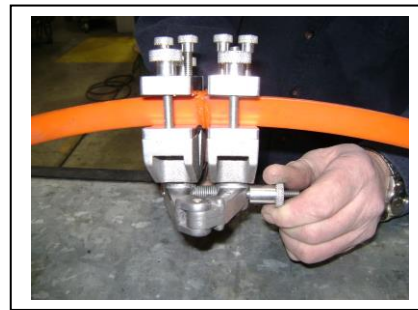
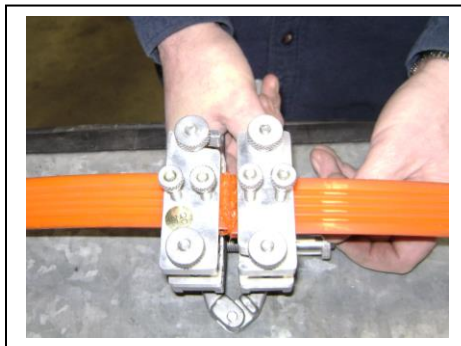
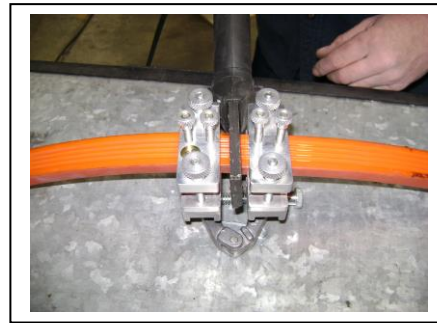
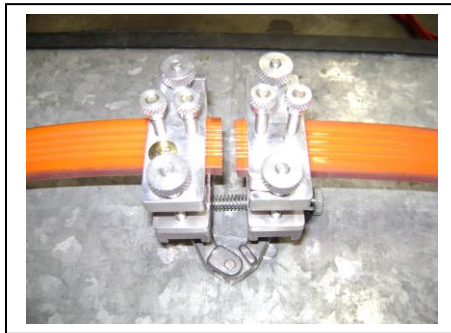
1. Using the cutting tool make sure you position the belt so that you get a square cut on both ends you are going to bond. (See photo below).



2. Notice the nylon cord in the pictures below. After cutting the belt make sure you have some gloves on when drilling out the nylon cord on both ends of the belt. (See photo below). Again using the VAR welding instructions and for non-reinforced VAR Belting skip to step 10 on the instruction sheet. If you have the cord, follow steps 3 through 9 of the instructions.

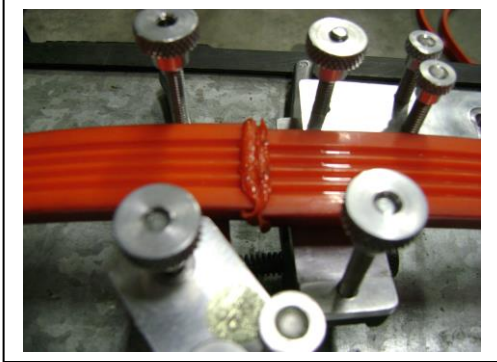


3. Open pliers by loosening bolts. Remove flat plates if using F51 plier when welding "V" or round belting. Next loosen thumb bolt so plier is in open position. Place belt ends in plier leaving approximately 1/4 "inch protruding from outer side of plier. Tighten all top bolts. Squeeze handles together to ensure that belt ends meet evenly. If not, adjust by either tightening or loosening top bolts. With plier open, inset heated wand making sure wand is clean from any previously melted belt material. Squeeze handles together to melt back approximately 1/8" inch from each end. Open plier, remove wand quickly, and lightly squeeze belt ends together. Tighten thumb bolt.



4. After you have removed the heated wand and tightened the thumb bolt let stand for approximately 5 minutes before removing from pliers. Continue to allow cooling for another 10 minutes.

5. Clean any melted belt material from heated wand. Unplug and allow wand to cool before storing. Clean belt flash with trim tool. Polish with sandpaper if desired.



If you have any questions regarding the VAR belt splicing instruction or photos, please call CP Service 1-800-628-4065.