Welding Guidelines

Novitool® Amigo™ Splice Press

Table of Contents

Cautions

Overall Safety Rules

To Avoid Severe Personal Injury or Property Damage, Read Carefully and Understand the Following Safety Precautions.

⚠ DANGER
Terminate electrical hazards by removing power cord from wall receptacle or machine base inlet.

⚠ CAUTION
Avoid temperature related hazards by handling press components and belt once safely cooled.

Belt Preparation

PPE:
- ☐ **Goggles**
- ☐ **Cut Resistant Gloves**
- ☐ **Heat Resistant Gloves**

Tools:
- ☐ **Measuring Tape**
- ☐ **Clippers**
- ☐ **Masking Tape**
- ☐ **Marker**
- ☐ **Belt Level Check Tool**
- ☐ **Skive Tool**

CAUTION, WEAR PROTECTIVE GLOVES!

1. Determine belt length
   A. Measure enough rollstock and add two extra teeth
   B. Place tape over the next tooth on the outside of this marked tooth (Figure 1) to identify the tooth that will be replaced.

Figure 1

2. Welder Setup for cutting the belt
   A. Open the safety guard and remove the front and back clamp bars
   B. Insert the appropriate Flexco insert
      - PC10 / PC20 / FC12: Use 08597 Amigo-1000-TMPLT–GCNTRD
      - CC40: Use 08596 Amigo-1000-TMPLT-GCLND
   C. Verify that the lever is in the “Cut/Load” position and that the pin is locked (Figure 2)
   D. Insert the crank handle onto the shaft and crank counterclockwise to position the cutting blade to the far left side
   E. Install belt with one tooth on the scrap side and securely tighten front clamp bar (Figure 3)
   F. Install back clamp bar and lightly hand tighten

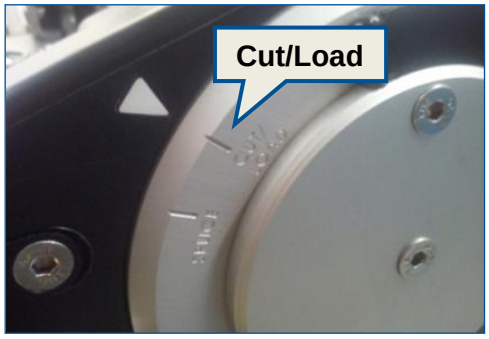

Figure 2

3. Cutting
   A. Crank handles clockwise to advance the cutting blade across the belt material until the blade locks into the housing at the far right of the welder
      1) Be sure to use a consistent pace when cutting
   B. Remove back belt and discard as scrap
   C. Repeat for other side

Figure 3

Welder Assembly and Operation

1. Verify that the height of both belt ends are the same by running a level check tool across the same the full width of the belt
    1) If it is not level, the bottom plate must be adjusted before continuing
        a) Adjustment screws are on side at plate end and top of back bottom plates (Figure 4)

Figure 4

2. Welding
    A. Remove the hand crank handles and release the locking pin
    B. Pull lever back to raise the heating element
    C. Close safety guard, verify interlocks are engaged and the guard is secured by the magnetic locks
    D. Turn on the power outlet switch
    E. Verify that the thermal switch is set to “Splice”
    F. Set the preheat time for 300 seconds and the dwell time for 55 seconds (Figure 5)
        1) Note that this setting is different when welding belt end to belt end

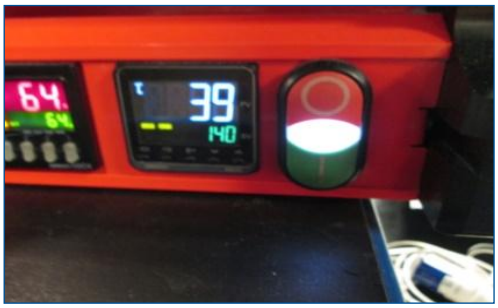

Figure 5

    G. Press the Start button to initialize the welding cycle
    H. At the end of the cycle, alarm will sound
    I. Immediately push the lever slowly and evenly to the “splice” position
        1) The key to preventing cord exposure (typically on the tooth side) is by controlling the size of the weld bead
            a) Swing the safety guard open as you begin pushing the lever and watch the weld bead develop
                (i) Push the lever far enough to create a bead .006” wide but no wider
                (ii) If the bead becomes 0.008” or greater, it is likely that the cord ends will be pushed downward exposing the cords when/if the tooth side bead is trimmed off
        2) One option is to lift the safety guard and watch the flash develop as the two belt ends meet so as to not create too much flash (and risk exposing cord)
    J. Keep the unit in this position until 40° C is displayed and the white light comes on
3. Finish
    A. Open the safety guard and remove belt
    B. Lay flat
    C. Using skiving tool, remove the weld build in one fluid motion (Figure 6)
    Tip: Heat skiving tool with a Leister hot-air gun to easily trim bead.

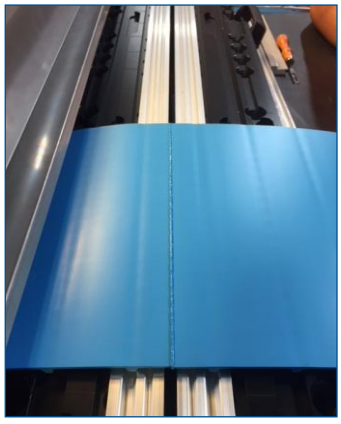

Figure 6

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