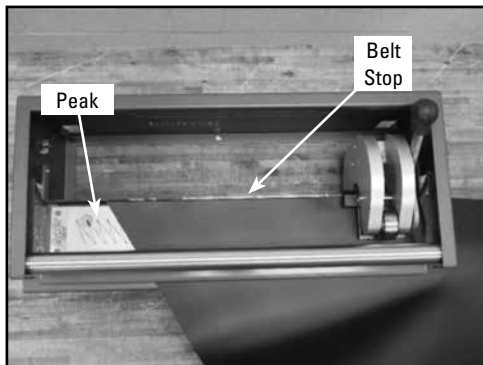


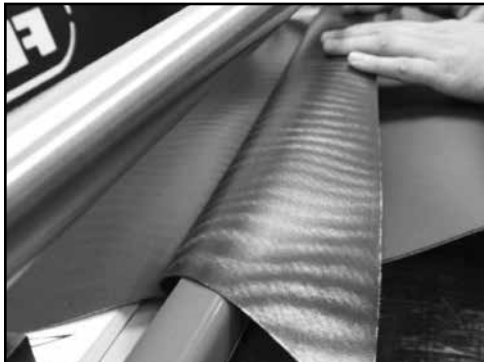
Continuous Finger-Over-Finger Bias Process

Instructions

1. Prepare both belt ends by calculating the 5:3 bias angle and ply separate with a Ply 130TM both belt ends to the required depth to accommodate selected finger length.



2. **(Belt End 1)** Position the leading belt edge up against the belt stop, aligning the left edge up with the peak of one of the punch board cutting blades.



3. With the edge of the bottom cover against the belt stop, fold back the top cover and clamp.



4. Begin punching bottom cover by following instructions beginning on pg.33 of the **PUN M™ Manual Finger Punch Safety and Operation Manual** until you've utilized the complete cutting surface of the punch board, then cut off excess.



Continuous Finger-Over-Finger Bias Process



5. Unclamp the clamp bar and shift belt to the left. Align punched fingers with cutting blades again on left side of punch board making sure leading belt edge is tight up against the belt stop. Re-clamp belt.



6. Repeat process until the entire width of belt has been punched.



7. Unclamp the belt, remove and then re-insert the belt into the PUN M™ with the leading edge of the top cover up against the belt stop and the left edge aligned with the peak of one of the punch board blades, then clamp.

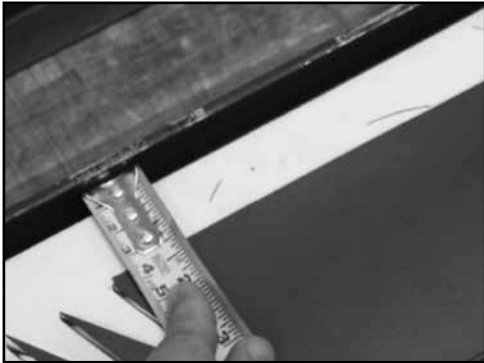


8. Unlock the belt tray clamps and slide the tray to the forward position.



9. Punch belt and cut away excess. **NOTE: Be sure none of the fingers are out of alignment underneath top cover prior to resuming punch process.**

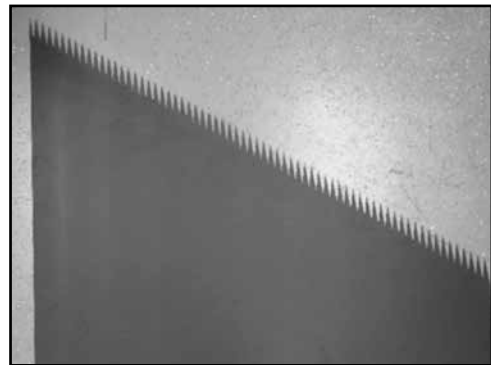
Continuous Finger-Over-Finger Bias Process



10. Prior to releasing the clamp bar and repositioning belt to the left, measure the distance from the leading edge of the belt end to the belt stop and record the measurement.



11. Unclamp the belt clamp and move the belt to the left, align fingers to the punch board blades confirming the distance from the leading edge of the belt end to the belt stop is correct.



12. Clamp and continue to punch. Repeat step 10 until entire width of belt has been punched.

Continuous Finger-Over-Finger Bias Process



13. (**Belt End 2**) Position the leading belt edge up against the belt stop, aligning the right edge up with the valley of one of the punch board cutting blades on the right side of the PUN M™. Fold the bottom cover under and clamp between the clamp bar.



14. Begin punching top cover by following instructions beginning on **pg.37 of the PUN M™ Manual Finger Punch Safety and Operation Manual** until you've utilized the complete cutting surface of the punch board, then cut off excess.

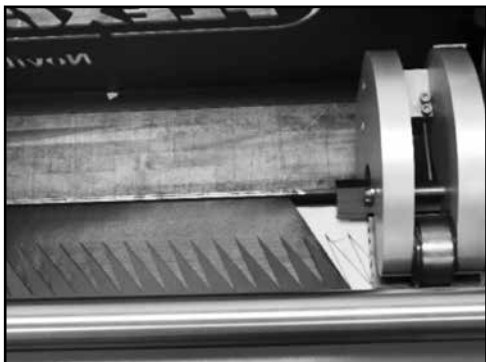


15. Unclamp the clamp bar and shift belt to the right. Align punched fingers with cutting blades on right side of punch board making sure leading belt edge is tight up against the belt stop. Re-clamp belt.



16. Repeat process until the entire width of belt has been punched then remove belt.

Continuous Finger-Over-Finger Bias Process



17. Unclamp the belt, remove and then re-insert the belt into the PUN M™ with the leading edge of the bottom cover up against the belt stop and the right edge aligned with the valley of one of the punch board blades, then clamp.



18. Unlock the belt tray clamps and slide the tray to the forward position.



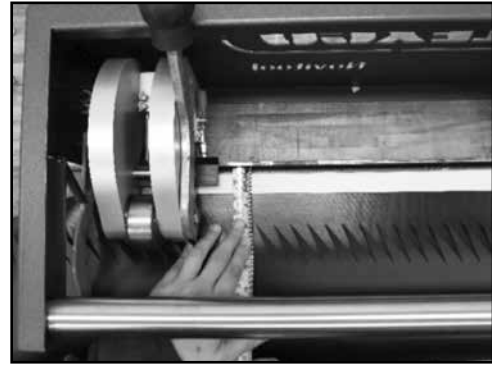
19. Measure the distance from the leading edge of the belt end to the belt stop and record the measurement.



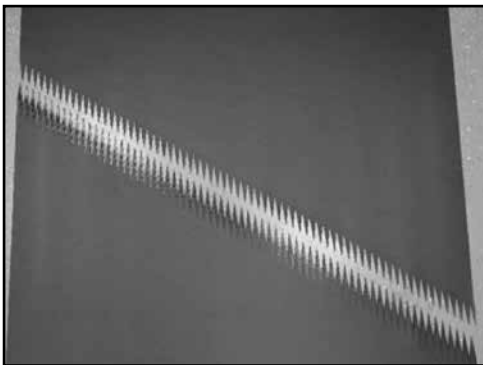
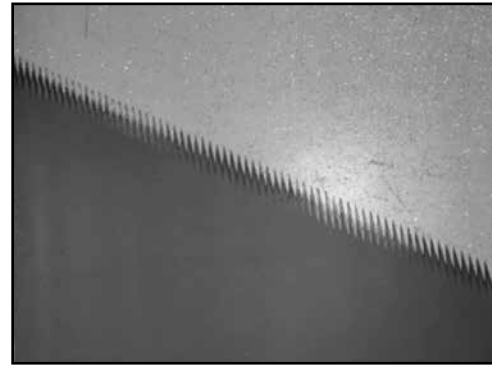
20. Punch belt and cut away excess. **NOTE: Be sure none of the top cover fingers are out of alignment underneath the punch block throughout punch process.**



Continuous Finger-Over-Finger Bias Process



21. Unclamp the belt clamp and move the belt to the right, align fingers to the punch board blades confirming the distance from the leading edge of the belt end to the belt stop is correct.



22. Clamp and continue to punch. Repeat step 3.21 until entire width of belt has been punched.



240 Macpherson Road • #02-01 • Singapore 348574
Tel: +65-6484-1533 • Fax: +65-6484-1531 • E-mail: asiasales@flexco.com

Visit www.flexco.com for other Flexco locations and products.

©2015 Flexible Steel Lacing Company. 06-18-19. For reorder: W639

