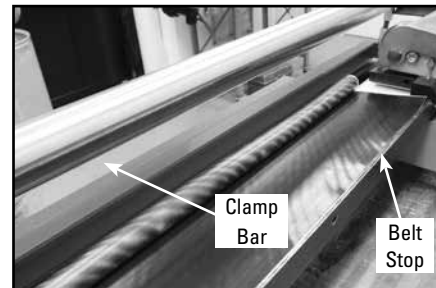
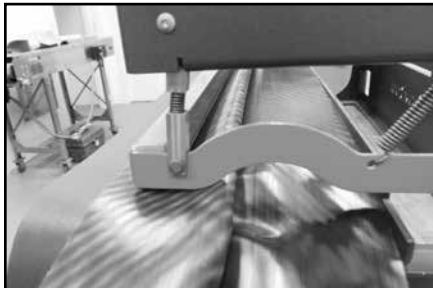


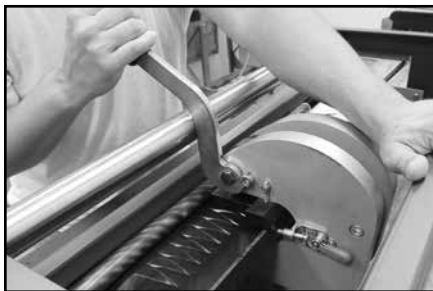
Continuous Finger-Over-Finger Punch Process

Instructions

1. Prepare both belt ends by squaring and ply separating with the Ply 130™ separator to the appropriate depth to accommodate selected finger length.



2. **(Belt End 1)** With the edge of the bottom cover against the c-clamp tray belt stop, fold top cover back clamping it between the clamp bar.

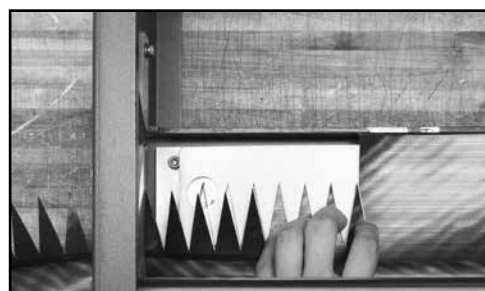


3. Begin punching bottom cover by following instructions starting on pg. 20 of the PUN M™ Manual Finger Punch Safety and Operation Manual until you've utilized the complete cutting surface of the punch board.



4. While clamp bar is still locked, cut off excess belt from first section of punched fingers, unclamp, and shift the belt to the left.

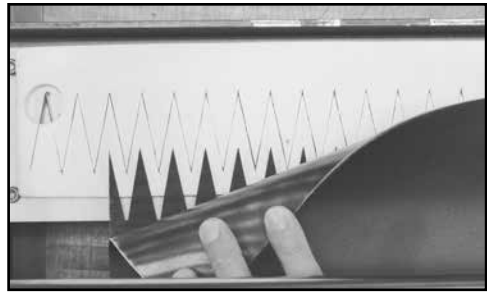
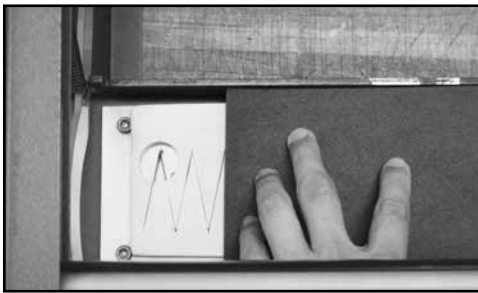
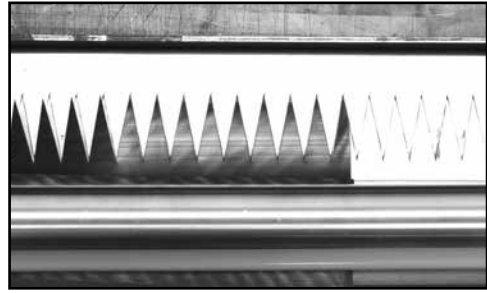
5. Utilize punched fingers on left side to align with punch blades to ensure correct finger spacing prior to re-clamping and resuming the punch process. **NOTE: Be sure un-punched belt end is up against belt stop.**



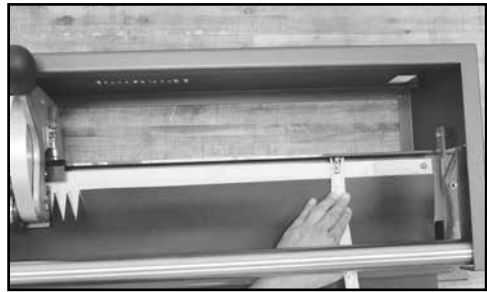
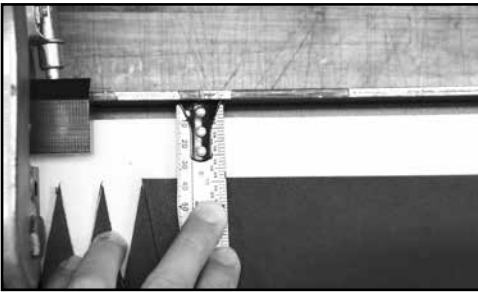
Continuous Finger-Over-Finger Punch Process



6. Repeat step 3.5 until the entire width of the belt has been punched.

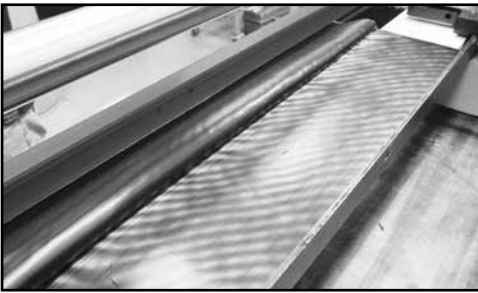


7. Prior to punching the top cover, release the clamp bar allowing the top cover to lay over the already punched fingers. Line up the left edge of the top cover with the peak on the left side of the punch board making sure the front edge of the top cover is up against the c-clamp tray belt stop and lock in place. Slide and lock the PUN M™ tray in the back position and resume the punch process until you've utilized the complete cutting surface of the punch board.



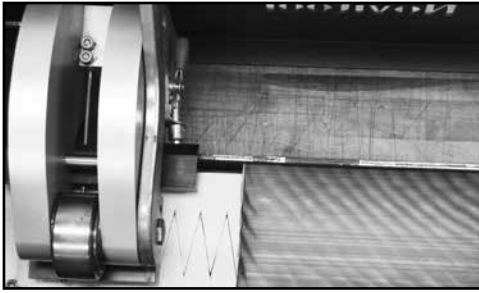
8. Unclamp belt and slide it over to the left, again utilizing punched fingers on the left side to align with punch blades to ensure correct finger spacing. Prior to re-clamping and resuming punch process, measure the distance between the leading belt edge and the c-clamp tray stop on the left and be sure the distance measures the same on the right of leading belt edge prior to clamping and resuming punch process. Repeat process until the entire belt end has been punched.

NOTE: Be sure none of the fingers are out of alignment underneath the top cover prior to resuming punch process.



9. (Belt End 2) With the edge of top cover against the c-clamp tray belt stop, fold bottom cover back clamping it between the clamp bar.

Continuous Finger-Over-Finger Punch Process

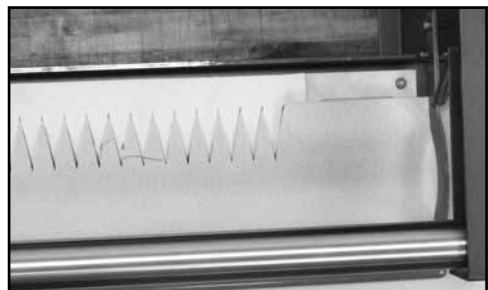


10. Begin punching the top cover by following instructions starting on pg.19 of the PUN M™ Manual Finger Punch Safety and Operation Manual until you've utilized the complete cutting surface of the punch board.



11. While clamp bar is still locked, cut off excess belt from first section of punched fingers, unclamp, and shift the belt to the left. Utilize punched fingers on left side to align with punch blades to ensure correct finger spacing prior to re-clamping and resuming punch process.

12. Repeat step 3.11 until the entire width of the belt has been punched.

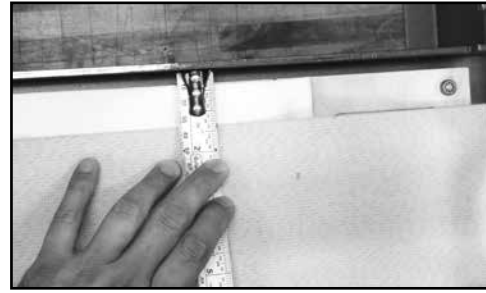
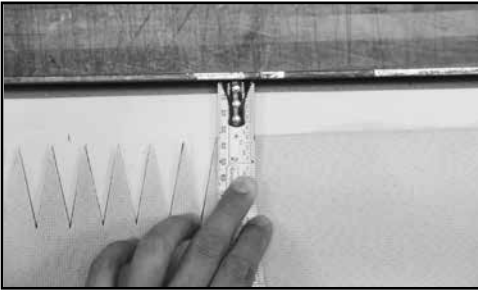


13. Prior to punching bottom cover, release the clamp bar allowing the bottom cover to lay over the already punched fingers. Line up the left edge of the bottom cover with the valley on the left side of the punch board making sure the front edge of the bottom cover is up against the c-clamp tray belt stop and lock in place. Slide and lock the PUN M™ tray in the back position. Resume punch process

14. Unclamp belt and slide it over to the left, again utilizing punched fingers on the left side to align with punch blades to ensure correct finger spacing.



Continuous Finger-Over-Finger Punch Process



15. Prior to re-clamping and resuming punch process, measure the distance between the leading belt edge and the c-clamp tray stop on the left, and be sure the distance measures the same on the right leading belt edge prior to clamping and resuming punch process. Repeat process until the entire belt end has been punched.

NOTE: Be sure none of the fingers are out of alignment underneath top cover prior to resuming punch process.



16. Belt ends are now ready to splice.