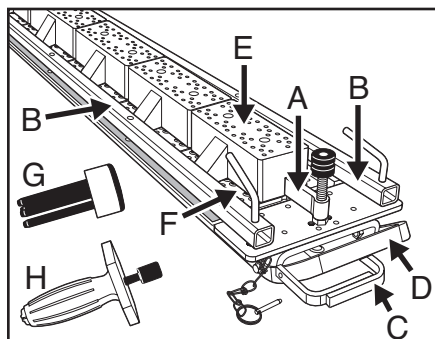
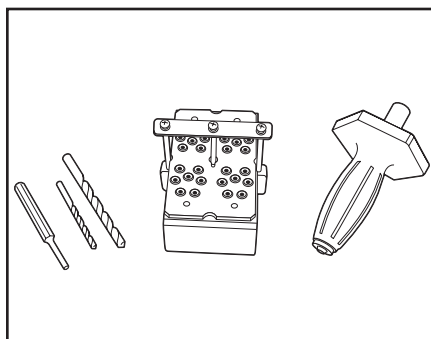


# Installing Flexco® BR10 Fasteners with the Flexco® Electric Powered Rivet Driver and the Standard MBRTA Installation Tool

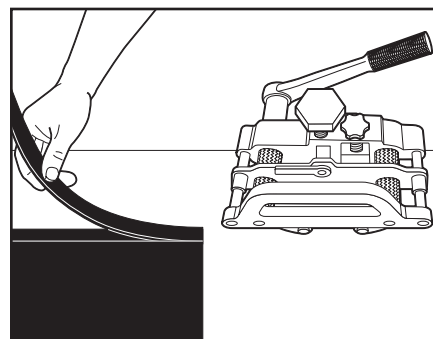
**Warning:** Follow all maintenance and safety precautions that are noted in the Hitachi H455R manual included in this kit. We recommend a trial drive prior to production installation. Use of this driver will vary with the length of the rivet and the type of belt you are using.



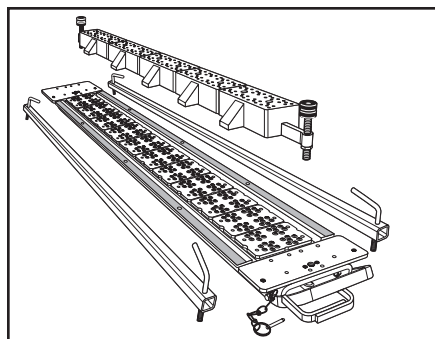
- A: Aligning Bar  
B: Clamp Bars  
C: Cam Rods  
D: Channel Base Handle  
E: Guide Blocks  
F: Anvil Plates  
G: SR759  
H: SR-50



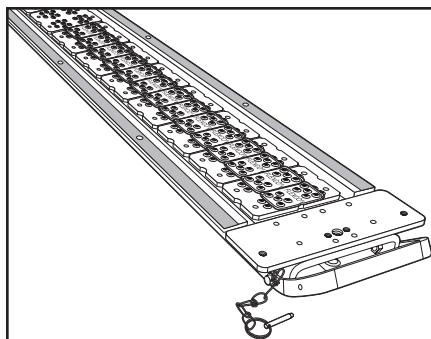
**NOTE:** MBRTA cannot be used to install single or double-plate BR-10 or BR-14 fasteners. Refer to RSP310.



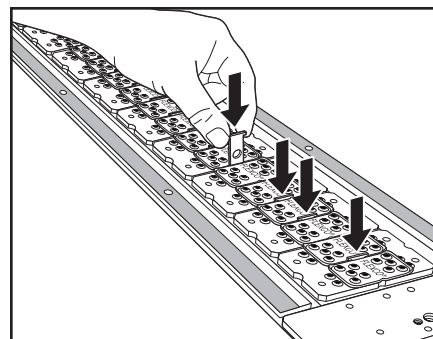
1. For belts with a top cover of 3/16" (4.8 mm) or more, skiving is recommended. Refer to FSK™ Belt Skiver instructions.



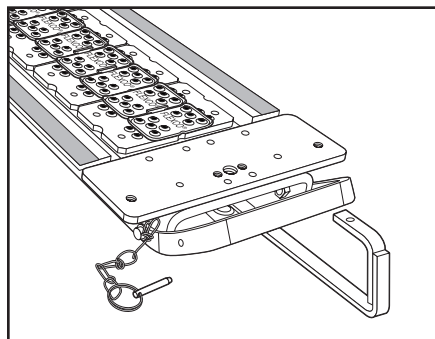
2. Remove aligning bar (A), clamp bars (B) and cam rods (C). Do not remove guide blocks (E) from aligning bar.



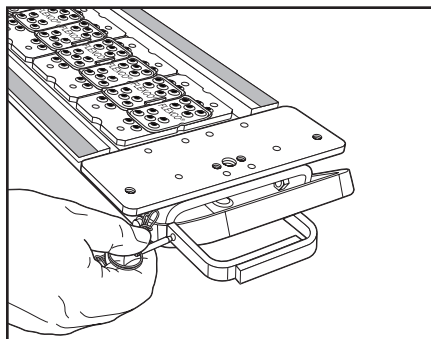
3. Starting at the right side of the tool, place proper number of fasteners on anvil plates (F) with Flexco® facing up.



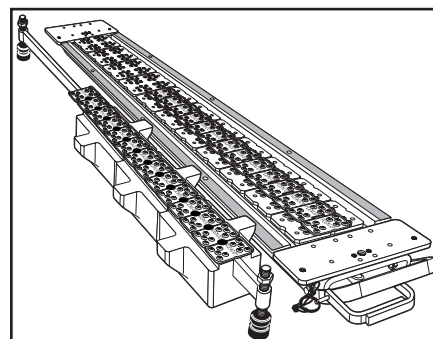
4. Insert a clip between first and second plates at each end of the fastener strips. Insert clips on both sides of center plate of each fastener strip.



5. Insert cam rods (C) through holes in clips across bottom of tool.

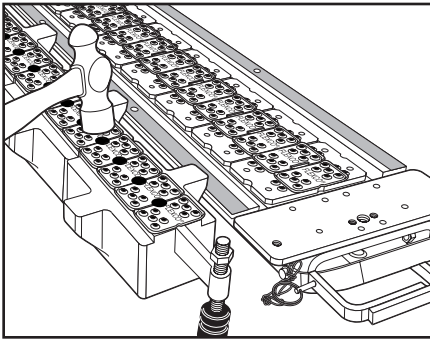


6. Turn cam rods (C) to lock fasteners in place. Secure cam rods (C) to channel base handle (D) with pin.

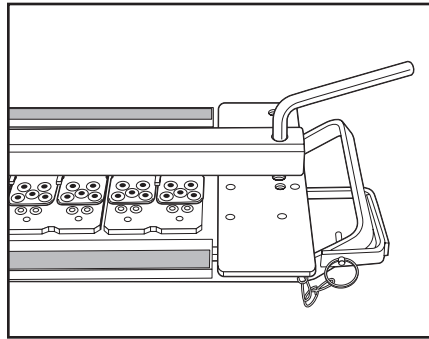


7. Turn over aligning bar (A) and align guide blocks with bottom plates. Place top plates on guide blocks, Flexco® facing up.

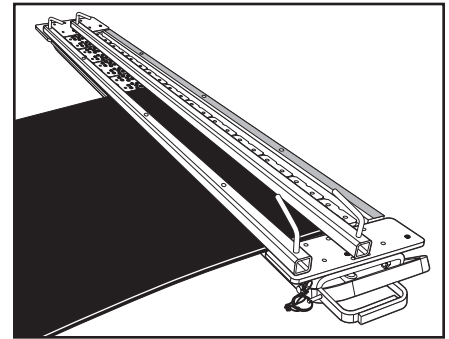
## Installing Flexco® BR10 Fasteners with the Electric Powered Rivet Driver



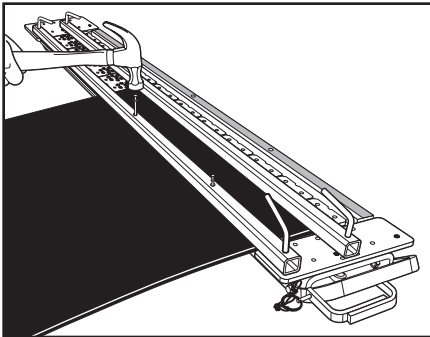
8. Insert black retainers between every plate and tap with hammer.



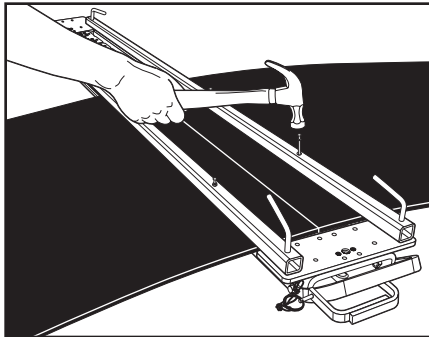
9. Attach clamp bar (B) to the tool so that one edge of the clamp bar is over the center of the fastener strips. Tighten clamp bar.



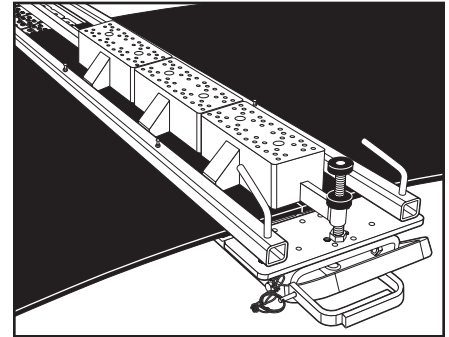
10. Place belt against clamp bar (B). Center belt over bottom plates. Clamp belt to tool with the other clamp bar (B), do not over-tighten.



11. Secure belt by driving double headed nails through holes in clamp bar and into the belt.

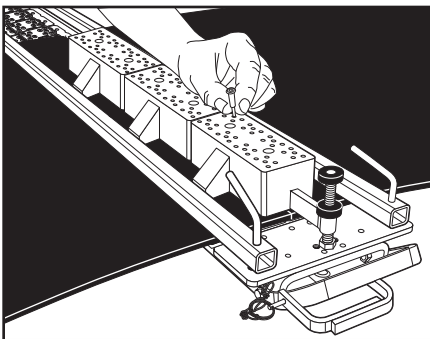


12. Remove center clamp bar. Position loose belt end against other belt end, aligning center lines. Clamp belt and nail in place.



13. Insert aligning bar in ends of MBRTA. Tighten top knurled nut. Tighten lower knurled nut to lower fasteners to belt surface.

**Note: Spray guide blocks with SL5 silicone.**



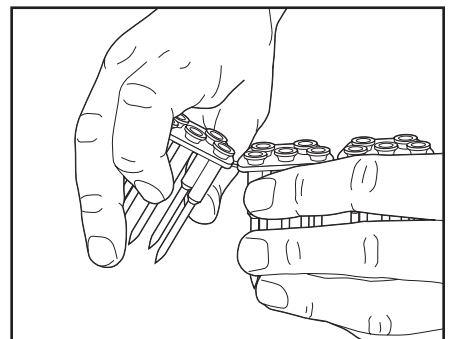
### Individual Rivets

14A. Load guide block with individual rivets. Reduce installation time by adding guide blocks across tool.

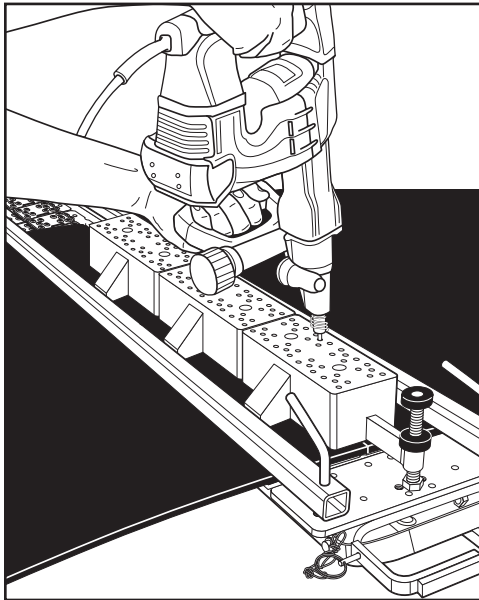
### Rapid Loader™ Collated Rivets

Reduce installation time using Rapid Loader™ Collated Rivet Strips.

14B. If a shorter strip is needed, break off extra plates by bending strip at checkpoints.



## Installing Flexco® BR10 Fasteners with the Electric Powered Rivet Driver

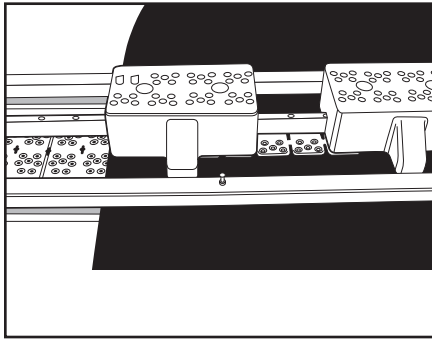


15. Adjust setting dial for rivet size – see chart below. Insert the punch directly into the BR500 Guide Block. Keeping the tool perpendicular to the base, pull the trigger to fire the driver. Push down on the driver slightly and maintain force on the driver until you feel the rivet set. This should take approximately 1 to 2 seconds per rivet depending on the length of the rivet and the type of belt.

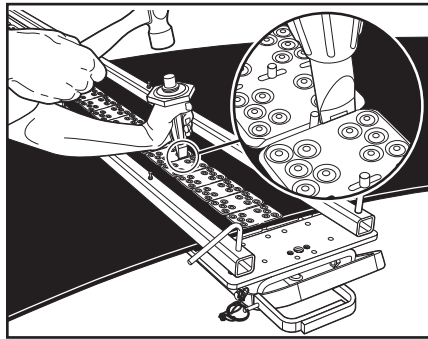
### Tool Setting Guidelines

Tool Setting	Rivet size range
2	A, B
3	A, B, C
4	C, C/D, D
5	D, E, F

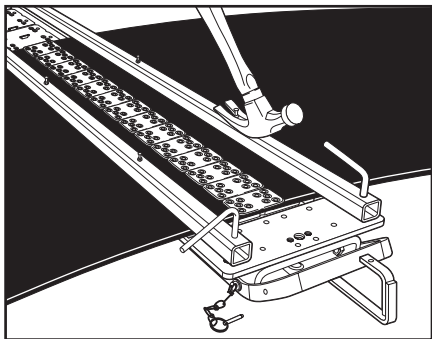
*Note: Tool settings will require adjustment for variations in belt thickness and construction.*



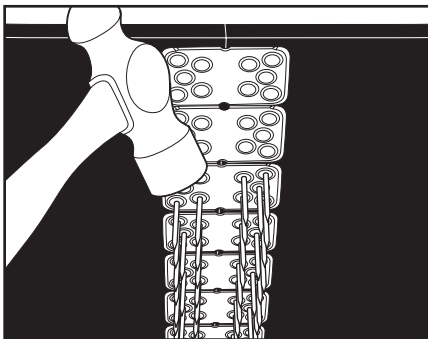
16. If all plates are not covered by guide blocks (E), move a guide block (E) to install remaining rivets.



17. For easier troughing on belts up to 35° trough, remove bridges between plates in troughing area using the BR151 Bridge Removal Tool.



18. Unlock and remove cam rods (C). Remove nails and clamp bars (B).



19. Remove MBRTA. Remove pilot nails and clips with a hammer. If fasteners are 1" (25mm) or more from edge of belt, notch belt. Remove nails from MBRTA.



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