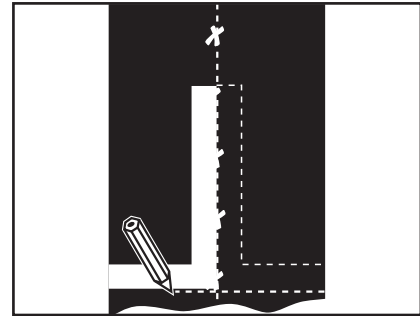
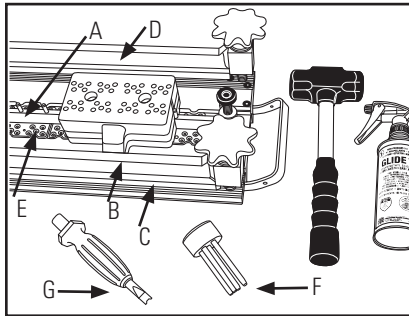
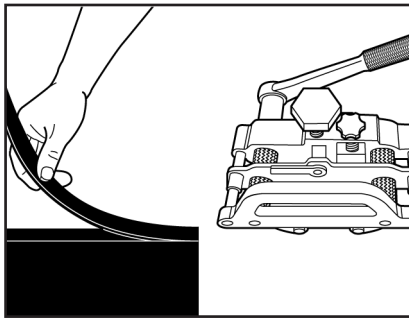


Installing Flexco® BR6 & BR10 Rivet Solid Plate Fasteners with MBRT-AL Tool

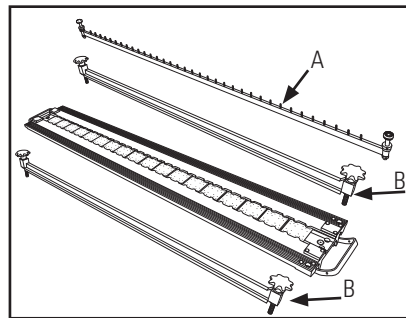
NOTE: Illustrations 2, 3, 4, and 6-16 represent BR10.



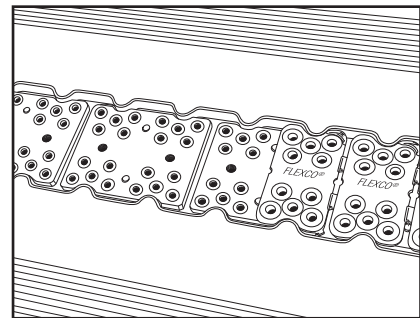
1. Square belt using centerline method. Cut belt at least 4" (100 mm) behind old splice using a Flexco belt cutting tool. Skive belt when top cover permits.



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

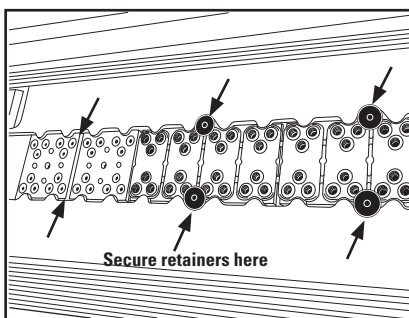


3. Remove alignment bar (A) and clamp bars (B).



4. Centering the fasteners on the tool, place proper number of fasteners on anvil plates with Flexco® facing up.

Secure fasteners with black retainers between fasteners and tool:

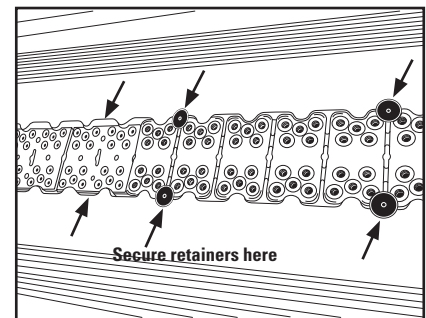


For BR6

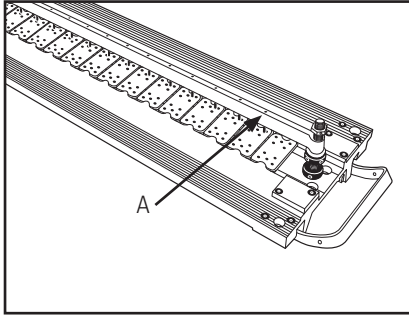
5A. Insert retainers between anvil plates, securing fasteners every four plates on top and bottom of splice.

For BR10

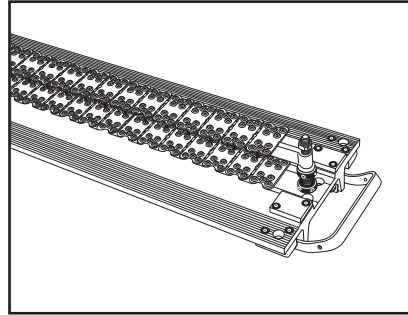
5B. Insert retainers at center of anvil plate, securing fasteners every four plates on top and bottom of splice.



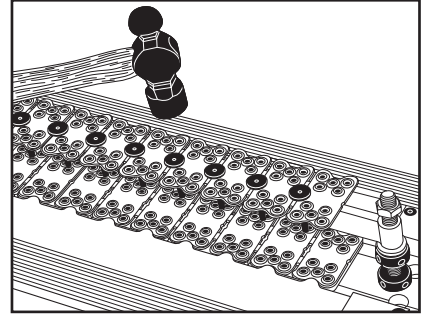
Installing Flexco® BR6 & BR10 Rivet Solid Plate Fasteners with MBRT-AL Tool



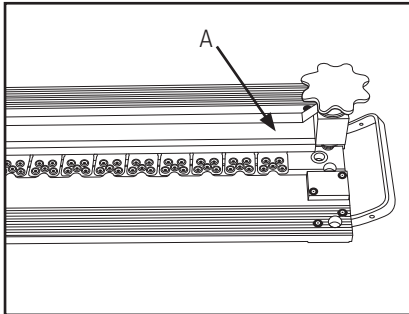
6. Place alignment bar (A) upside down on tool over bottom plates and tighten alignment bar screws.



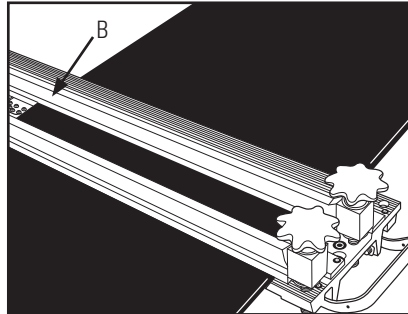
7. Place top plates on alignment bar, Flexco facing up, and align with bottom plates.



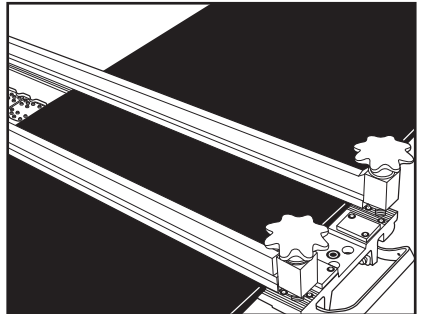
8. Insert black retainers between every plate and tap with hammer. Remove alignment bar and set to side.



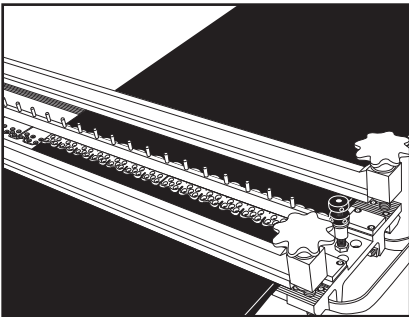
9. Place clamp bar (A) on tool so that one edge of the clamp bar is over the center of the fasteners strips.



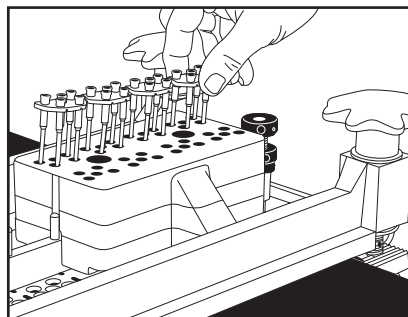
10. Square belt against centered clamp bar (B). Center belt over bottom plates. Place second clamp bar onto belt and tighten securely. Do not overtighten.



11. Remove centered clamp bar. Position loose belt end against secured belt end, alignment center lines. Clamp belt in place.



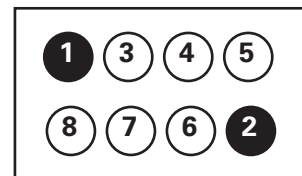
12. Insert alignment bar in ends of MBRT. Tighten top knurled nut. Tighten lower knurled nut to lower fasteners to belt surface. Do not overtighten.



13. Starting at edges of belt, place guide blocks onto alignment bar. Load rivets. Spray top of guide blocks with silicone spray. Using a 4 lb. (1.8 kg) hammer and driver, drive rivets in the sequence shown to the right:

Rivet Sequence:

1. Drive rivets in opposite corners. (1 & 2)
2. Drive top row of rivets working out from corner. (3, 4, & 5)
3. Drive bottom row of rivets working out from corner. (6, 7, & 8)

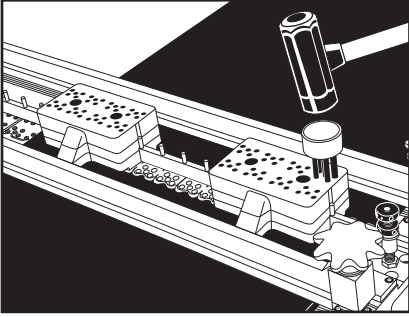


If installing SRH or longer rivets: Using SR-50 Single Rivet Driver and 2 lb (0.9 kg) hammer, drive rivets in each end and center of splice. Remove alignment bar. Drive remaining rivets. Skip step 11.

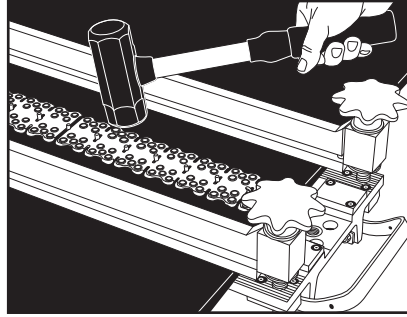
Flexco® Rivet Selection Gauge

Rivet Size	Belt Thickness Range			
	BR6		BR10	
	in.	mm	in.	mm
AA	3/16 - 9/32	5-7.5	N/A	N/A
A	1/4 - 11/32	6.5 - 9	7/32 - 5/16	6 - 8
B	5/16 - 13/32	8 - 10.5	9/32 - 3/8	7 - 9.5
C	3/8 - 15/32	9.5 - 12	11/32 - 7/16	9 - 11
C/D	7/16 - 17/32	11 - 13.5	13/32 - 1/2	10 - 13
D	1/2 - 19/32	13 - 15	15/32 - 9/16	12 - 14
E	9/16 - 21/32	14 - 17	17/32 - 5/8	13.5 - 16
F	N/A	N/A	19/32 - 11/16	15 - 17

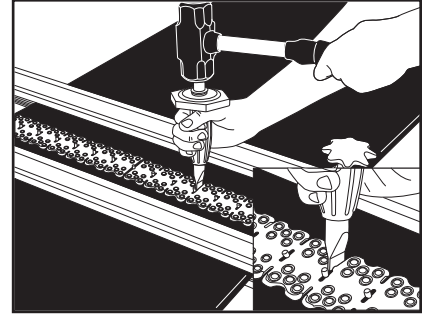
Installing Flexco® BR6 & BR10 Rivet Solid Plate Fasteners with MBRT-AL Tool



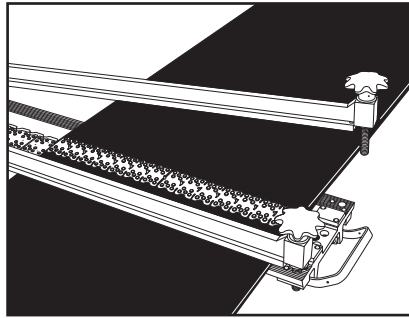
14. Move guide block(s) directly to right and/or left of belt edges and drive the next block(s) of rivets following the rivet sequence in Step 13. Drive remaining rivets working in a pattern from belt edges to center.



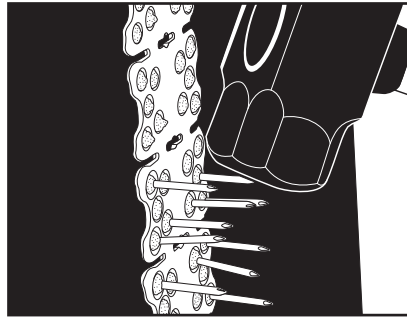
15. Remove alignment bar (A). Set rivets with firm hammer blows. Belt should pucker around fastener edges.



16. For easier troughing on belts up to 35° trough, remove bridges between plates in troughing area using bridge removal tool.



17. Remove clamp bars.



18. Remove MBRT-AL. Remove pilot nails with a hammer. If fasteners are 1" (25 mm) or more from edge of belt, notch belt. Remove nails from MBRT-AL.

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