

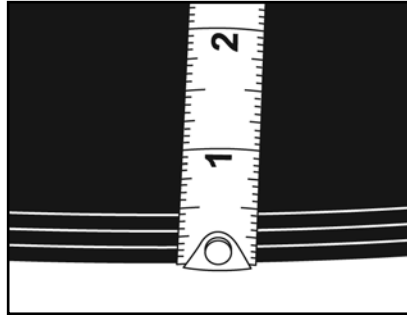
# Installing Flexco® R2J & R5J Kits

## Instructions for Installation

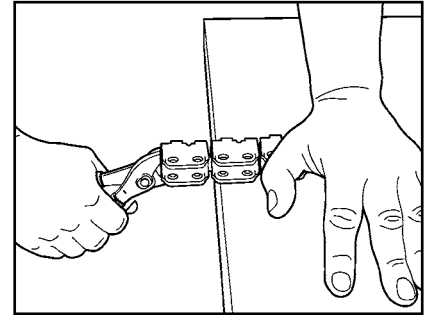
**NOTE: Illustrations shown represent R2J. The installation procedure is the same for R5J.**



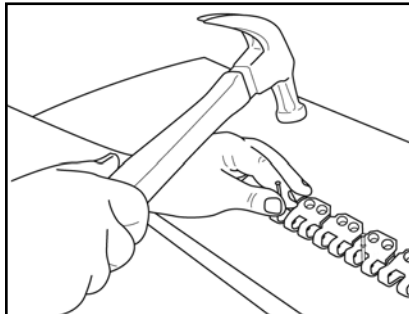
1. Square belt using centerline method. Cut belt 100 mm (4") behind old splice using a Flexco belt cutting tool. Skive belt when top cover permits.



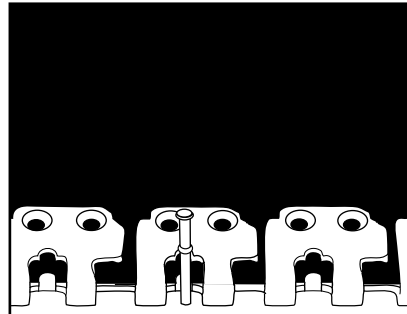
2. Measure belt thickness from cut edge using gauge or tape measure. Verify rivet size in J Kit according to belt thickness.



3. If a shorter strip is needed, break off extra plates by bending at the checkpoints with pliers. Do not use single plates.



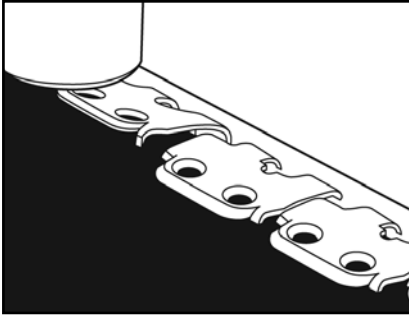
4. Hammer several nails into wooden board so they hold the fastener strip straight. The nails should be placed between the loop area at the belt stop. Flexco name should face up on the fasteners.



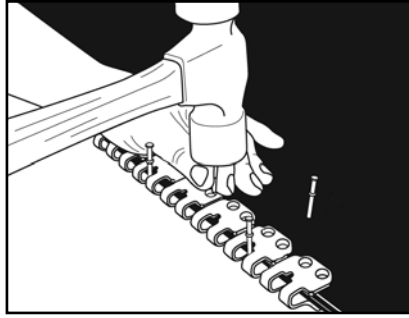
5. Center belt in fastener strip. Look through viewports, belt should be tight against belt stops.



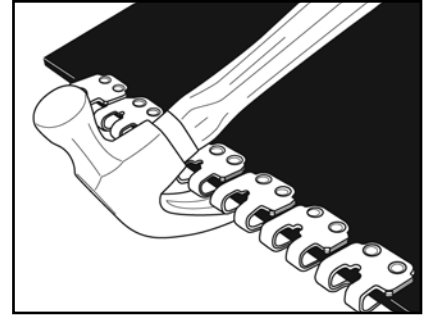
6. Secure belt in place over board with nails.



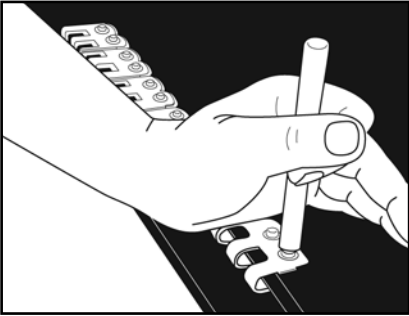
7. Using a 0.9 kg (1 lb.) hammer, set fastener top plates until teeth penetrate belt.



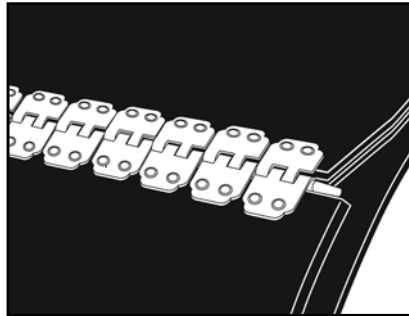
8. Using a 0.9 kg (1 lb.) hammer, first drive rivets in end plates, then drive remaining plates.



9. Pry belt off the board. Knock off remaining nails.



10. Flip belt over to expose uncurled rivets. Place a metal plate underneath the fastener strip. Curl rivets using the pointed end of the rivet set tool included in your kit with firm hammer blows until belt puckers around edges of fastener plates.



11. Repeat steps 1-10 on other belt end. Bring belt ends together and insert hinge pin. Notch trailing edge of belt only. Splice is complete.



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