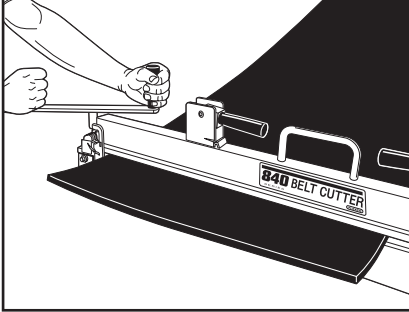
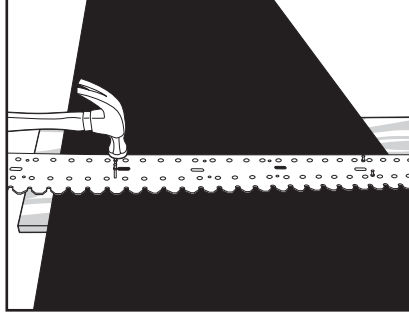


# Installing Flexco® VP Fastener System

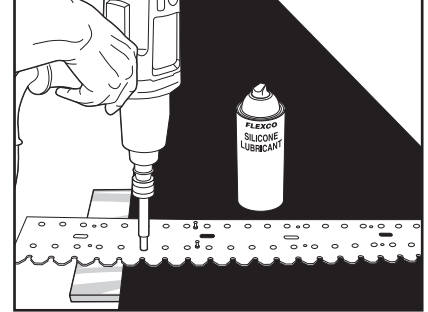
## Instructions for Installation



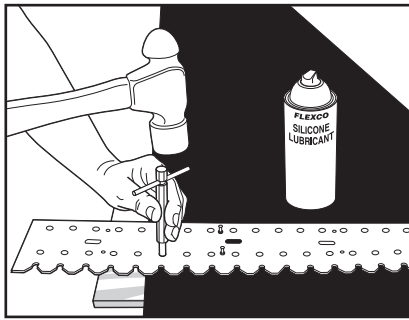
1. Square belt ends using centerline method. Cut belt ends using Flexco 840 Series Belt Cutter.



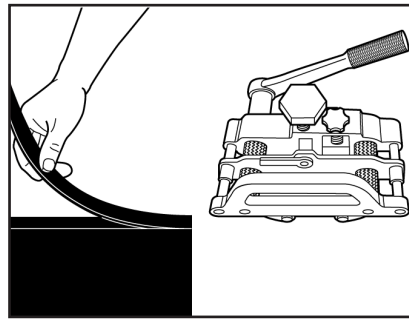
2. Support belt ends with a wood board. Align VP templet with belt end and align holes approximately 25mm (1") and equal distance from belt edges. Nail templet in position.



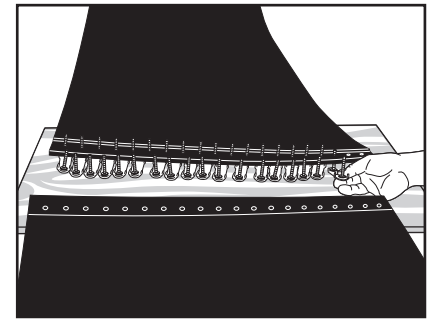
3. Spray templet holes with Flexco Silicone Lubricant. Bore bolt holes using an impact tool, quick change chuck, and power punch. Remove templet.



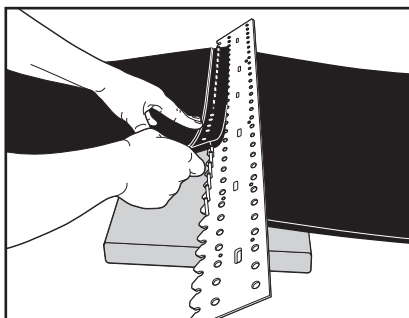
**NOTE:** The preferred method is to bore bolt holes using a power punch. A hammer and punch can also be used.



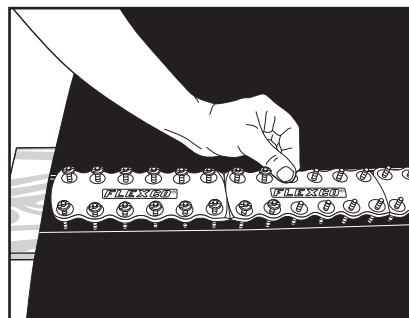
4. For belts with a top cover of 4.8 mm (3/16") or greater, skiving is highly recommended. Refer to the FSK™ Belt Skiver instructions.



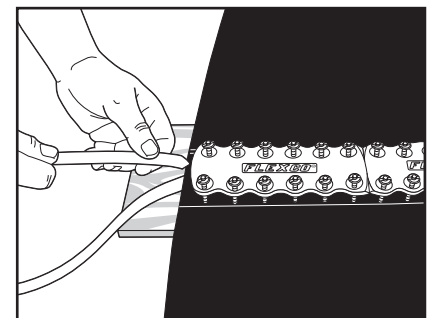
5. Insert bolts into holes in one belt end.



6. Align other bolts with templet teeth, then insert these bolts through holes in second belt end. Remove templet.

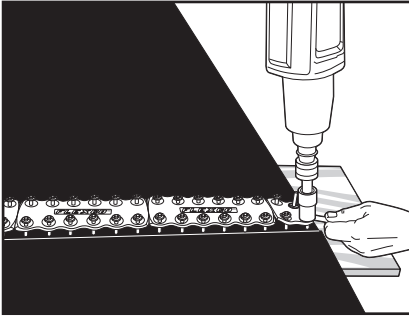


7. Place top plate strips over bolts using bolt horn. If shorter strips are needed, cut between plates with a utility knife. Start nuts on bolts.

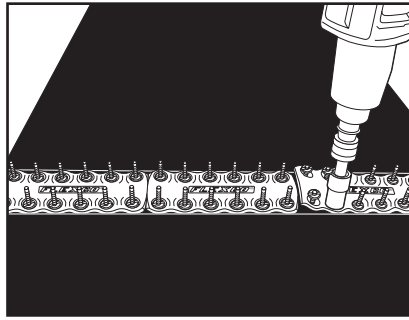


8. Cut Flexco-Lok® Tape 3-½ times the belt width. Feed tape under top plates, under bottom plates, then back under top plates.

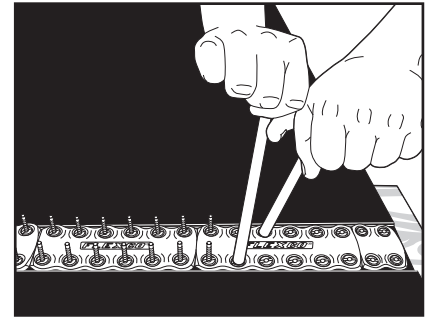




9. Pull tape tight and tighten nuts using Flexco wrench. **NOTE:** A Flexco Power Wrench and impact tool will speed this step. Max torque: 250 Lb-Ft (340 N-m).



10. Tighten all nuts from edges to center. Tighten uniformly. Trim excess Flexco-Lok Tape.



11. Break off excess bolt ends using Flexco Bolt Breaker.

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