

STANDARD MAINTENANCE PROCEDURE (SMP)

SMP NO:

ALLIGATOR STAPLE RS125 INSTALLATION

Equipment Type	Conveyor Belt	System:	
Equipment Name:		Date:	
Equipment No:		Aproved:	
Maintenance Type:	Insp Lub S&A Test Cal Rep O/H		
Frequency:	Daily Weekly Mth 3 Mth 6 Mth Annual		
Risk Assess No:			

Materials/Tools Required:

- | | |
|---|---|
| 1 | 1 Lb. Hammer |
| 2 | Flexco Alligator Ready Set Tool, RSC187, RSC187-4 or RSC187-6 |
| 3 | Lacing strip with Staples, #125 RS |
| 4 | Belt Nipper |
| 5 | Belt Skiver |
| 6 | Refer to video for further instructions |

Method:

- 1 Following SMP __XXX-XXXXX__, on belt measuring and cutting, place the belt end on a solid surface for proper support.
- 2 If the clips are to be a lower profile and flush with the top belt cover, a SKIVER can be used to remove the top cover. This procedure is applied when belt scrapers are in use.
- 3 With the fastener strip's word "Alligator" facing up, center the strip, with equal distance from the belt ends.



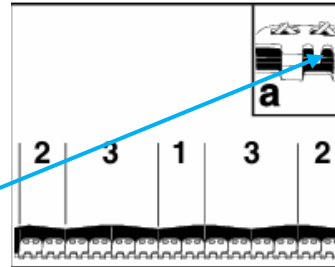
4 Place the Flexco Alligator Ready Set Tool RSC187, RSC187-4 or RSC187-6 on the center of the fastener strip.



5 The belt end must be tight against the fastener strip "Belt Stops"



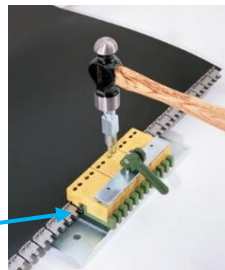
Belt Stop



The Fastener Strip must be tight against the tool.

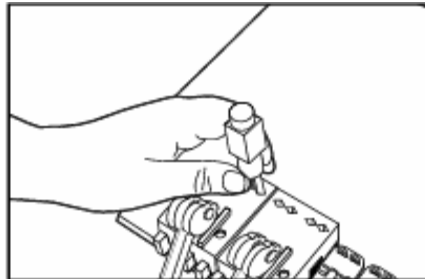
6

Belt strip tight against the tool



7 Depress the Flexco RSC187 tool cam lever.

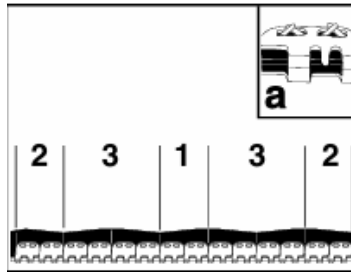
8 Position the staple driver in applicator, and push the staples down by hand until they contact the belt. Otherwise the staples can wander when driven by the hammer.



9 Set the fastener strip flat on a setting plate. It must be a solid steel plate. Strike the top-side of fasteners and staples with firm hammer blows. Avoid hitting the fastener loops. Starting at the center, strike the staple driver with a 1 lb. hammer. **It is very important to always start setting the staples at the center of the belt.** Do not overdrive the staples. Raise the cam lever(s) to remove the tool.

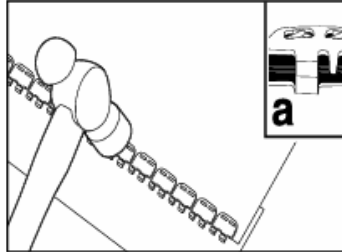


10 Follow the sequence shown below to drive all remaining fasteners, 1, 2 and 3.

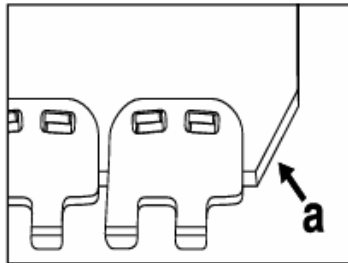


Staples will be partially clinched.

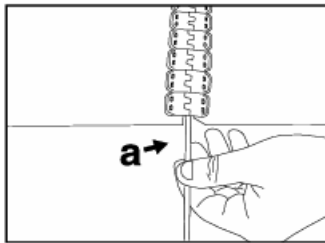
11 Set fastener strip flat on ST-28 setting plate. Strike top-side of fasteners and staples with firm hammer blows. Move back and forth across the fastener strip until the staples are clinch. Avoid hitting fastener loops. Repeat steps 1-11 on the other belt end



12 Using a Belt Nipper, notch the trailing edge of the belt only. Notch at an angle as per picture below.



13 Bring the belt ends together and insert a hinge pin A. The hinge pin should be the same length as the belt width.



14 Install a retaining washer at both ends and crimp them with pliers. The hinge pin should extend beyond the washer.



SAFETY, REPORT ANY ABNORMAL ITEMS TO DEPARTMENT OR SAFETY MANAGER