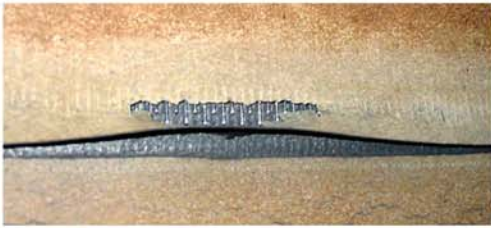
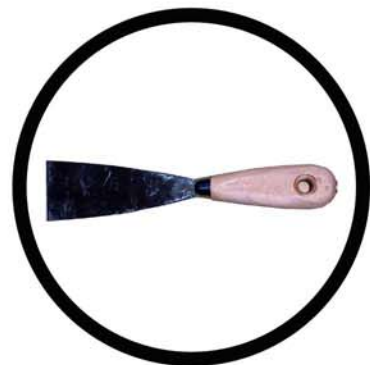


***FLAP
REPLACEMENT
INSTRUCTIONS***

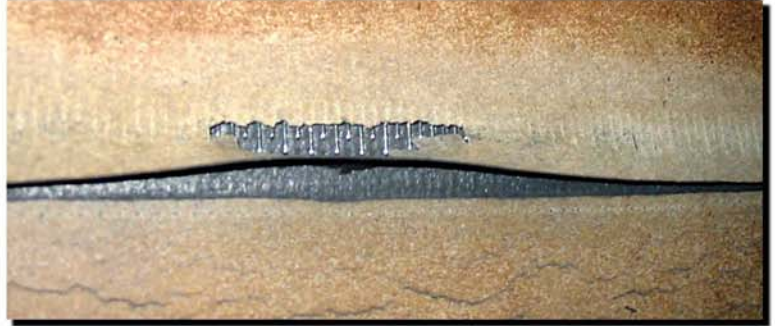
To replace a damaged flap the following materials are required:



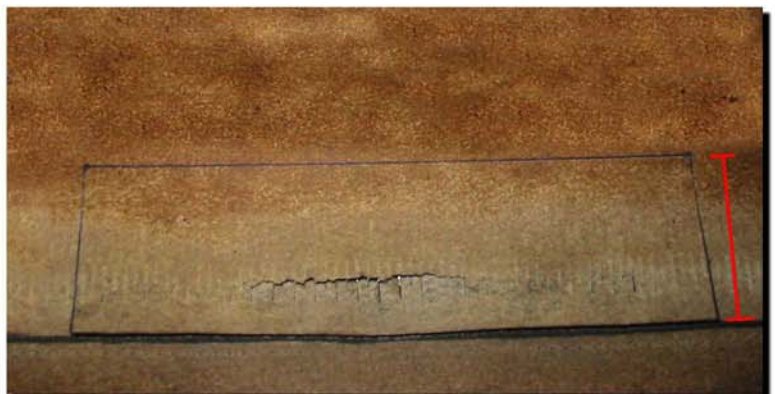
- flap material
- 3M Scotch-Grip 847 (1236) glue or similar
(normally one tube is enough)
- razor knife
- straightedge
- felt-tip pen
- scissors
- gloves
- putty knife
- hammer
- adhesive tape
- vice
- sandpaper



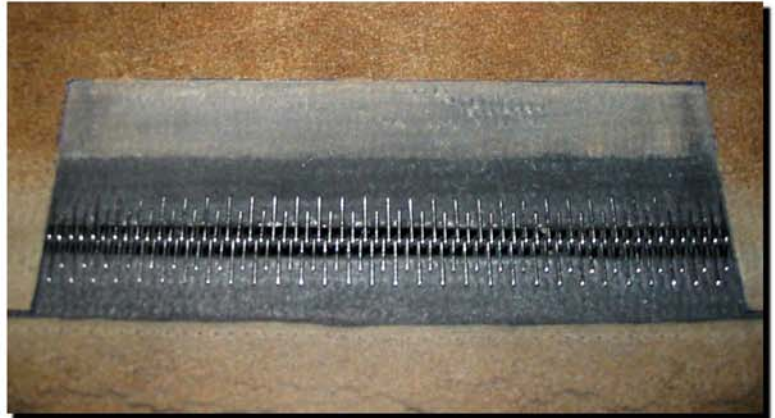
If possible dismount the belt off the machine, otherwise carry the seam in position easy to access and comfortable to work.



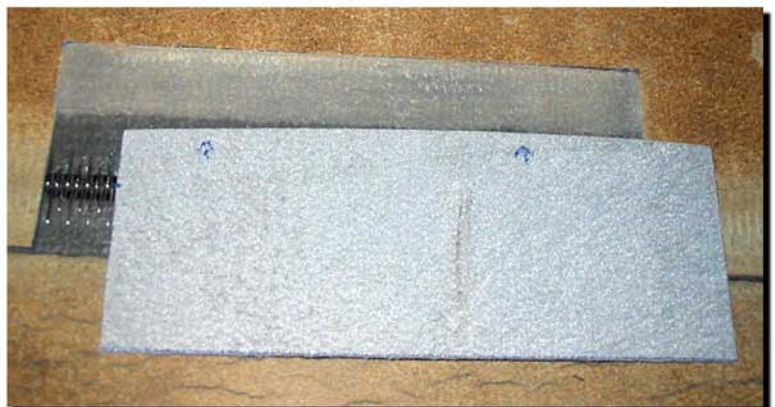
Once detected the piece of damaged flap to replace, draw a zone around it of the proper size. Before deciding the size of the flap to remove check the size of the spare flap and leave 2 or 3 cm of safety margin.



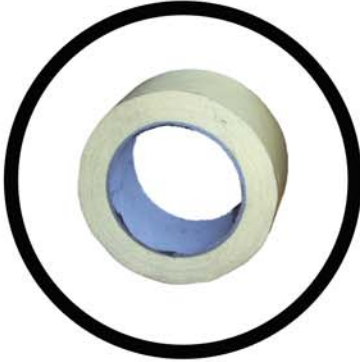
Using a razor knife carefully cut underneath the flap in the damage area back to the line drawn earlier. Pay attention to not cut the base fabric. Then clear the bonding area using sandpaper.



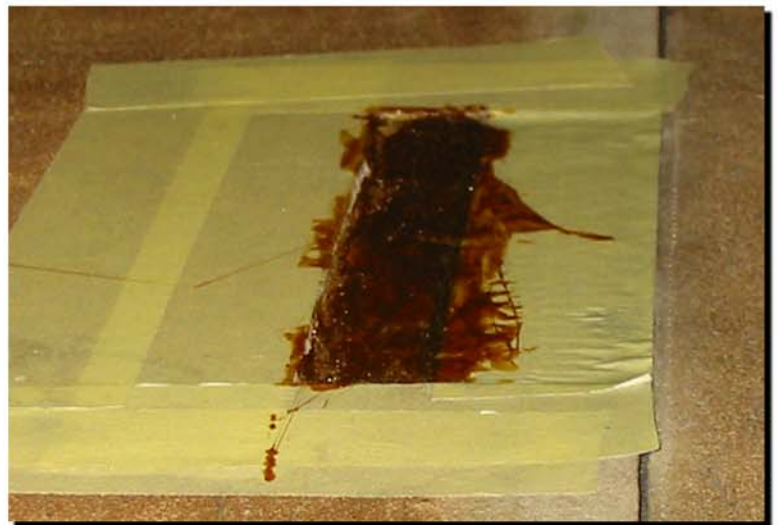
Cut from the spare flap material a piece with the right dimension. If necessary reduce its thick using the razor knife or the sand paper. The thickness of the flap material must be so that it will not create steps once glued.



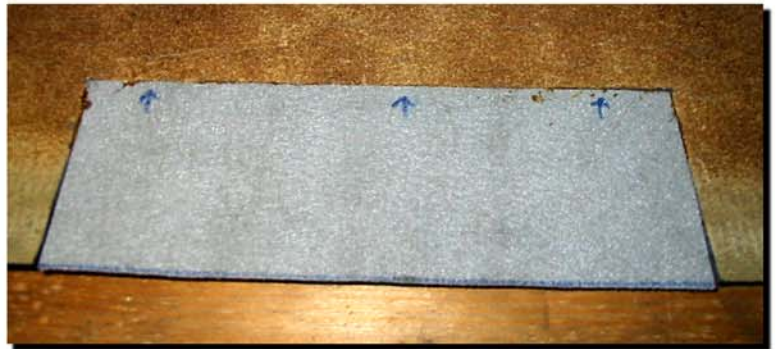
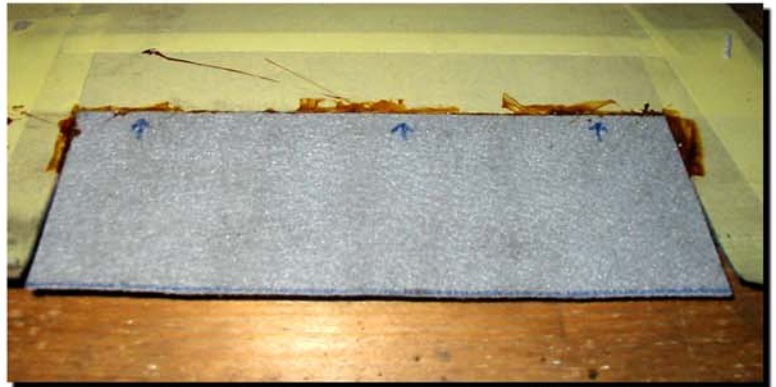
Using the adhesive tape create a mask around the bonding area. Create the same mask on the flap material on the inside.



With the putty knife apply a primer coat of glue to both the flap replacement material and the bonding area. Let it dry for approximately 15 minutes. Once primer coat is dry apply a second bonding coat to both surfaces and wait until it becomes aggressively tacky (normally after 5/8 minutes), then put the flap material in place.



Roll evenly the flap material to ensure a perfect bond, use the hammer if necessary. Then remove the masking tape.



Using a vise and two wooden tables clamp the belt strongly. Leave the belt in this condition for about 8/9 hours. Before running the machine again remove any glue spots that may remain on the belt.

