

30L×10P Finger Endless Manual



※ This manual applies to finger geometry of 30 mm long × 10 mm pitch, 2 mm or less in thickness and 50 mm or less in width.

◆ Required Tool

- ① Finger Puncher ; FP30-10-50N
- ② Heat Press ; NPS-3050H2
- ③ Cooling Press ; NPS-3050C
- ④ Pre-setter ; top plate, bottom plate, silicon sheet (Pre-setter is required for each belt width.)
- ⑤ Pre-setter clamps ; 2 pcs.



Other items needed; tape measure or ruler (to measure belt length), pen, anti-heat gloves (burn-preventive protection kits), stopwatch

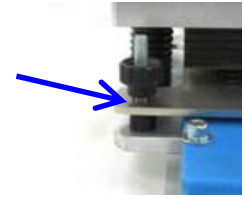
◆ Work Procedures

<p>1.Measurement of Belt Length</p> <ul style="list-style-type: none"> · Set the belt along a tape measure or a ruler. Make a first mark 200mm from the edge of the belt. Based on the first mark, make a second mark at the ending point of the required belt length. (Put both marks on the front side, i.e. on the operator side). See diagram to right. 	<p>The marking distance should be accurate. (In case final product length is 1000mm, the distance should be just 1000mm)</p>
<p>2. Adjustment of Eject Plate</p> <ul style="list-style-type: none"> · Adjust the clearance between the Eject Plate and the Cutting Sheet to be equal to the belt thickness + about 0.5 mm. Make adjustments by turning the four knobs. <p>※ The Eject Plate, when adjusted to the height suited to the belt, fulfills its functions.</p> <p>※ When processing belts with the same thickness, make an adjustment once before use; no further adjustment is necessary</p>	<p>※Clearance “Belt thickness + about 0.5 mm”</p>

thereafter.

- ※ Avoid any clearance between the knobs and the Eject Plate. When the Eject Plate is not adjusted to the proper height for the belt, the belt may sometimes get stuck on the Cutting Blade after punching.

Avoid clearance



3. Cutting Fingers Properly

- Insert the belt between the Eject Plate and the Cutting Sheet, and line up the first mark on the belt with the cutting guide indicator of the Finger Puncher.

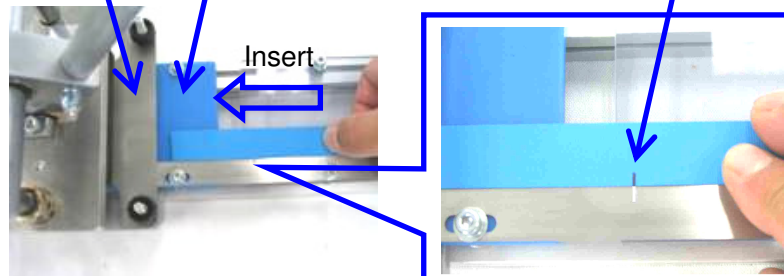
- ※ Insert the belt along the Belt Guide.

Eject Plate

Cutting Sheet

Insert

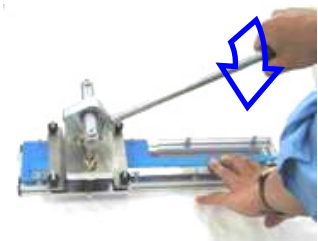
Fit the mark on the belt with the cutting guide indicator.



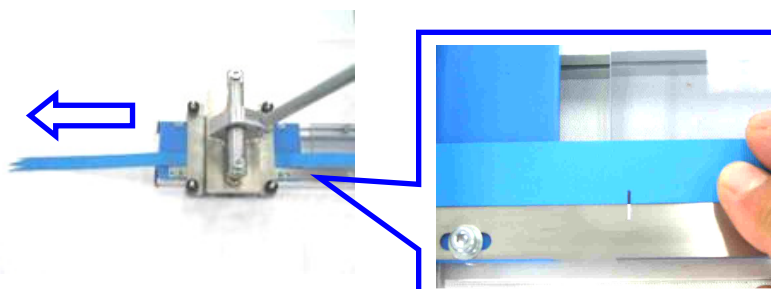
The accuracy of the fitting lines influences to final product length.

- Hold the Finger Puncher in place with one hand and push down the handle with the other hand to punch the belt.

- ※ Push down the handle of the Finger Puncher, and the Eject Plate also comes down and fixes the belt.



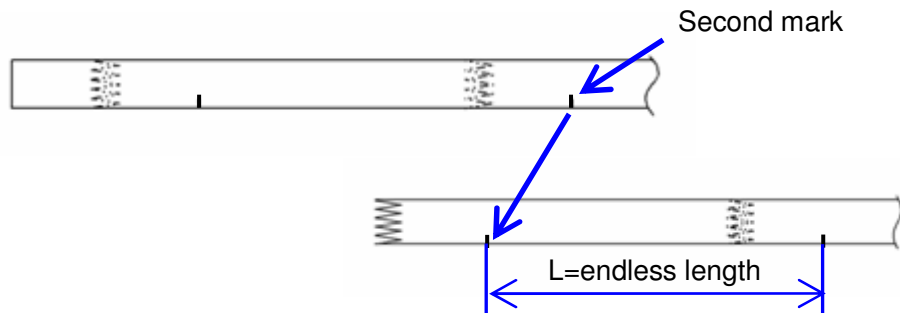
- Fit the second mark made on the belt with the cutting guide indicator of the Finger Puncher and punch out the belt to obtain the required endless length. (The belt from edge to edge will be endless length + 30 mm.)



- ※ When punching a long belt, you can insert the rear-edge of the belt from the other side of the Finger Puncher to avoid pulling the entire belt through the Finger Puncher.

- ※ When consecutively making endless belt, obtain the required belt length and from the second mark

made at the preceding finger joint, measure out the required belt length and make another mark. Repeat the above process. By doing this, punching can always be made at right position and there will be no waste of the belt.




4. Temperature Setting

- Connect the main plug to the socket outlet.



Be sure to connect an earth line to prevent electric shock.

- Confirm the set temperature. Set the temperature to match the belt type and the belt width.
- ※ The set temperature varies by the belt type and the belt width. Refer to the Endless Conditions Table.
- Push and hold  heat switch for about 2 seconds to activate the unit. Pre-heating will begin automatically and will reach set temperature in about 5 minutes.

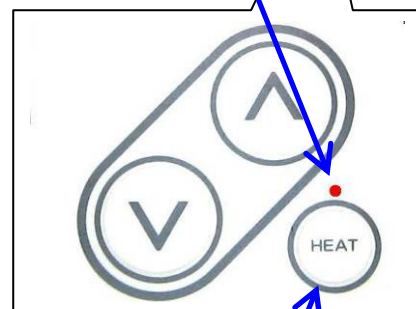
<How to set temperature>

- Connect the main plug to the socket outlet. The current temperature is indicated on the temperature indication display.
- You can change the set temperature while the heat switch is off and the in-operation lamp is also off.
- Push the temperature setting button once and the current set temperature is indicated for about 2 seconds.
- While the set temperature is indicated, push the button once and the temperature changes 1 °C

Temperature indication display
Temperature setting button (Up & Down)





In-operation lamp



Heat switch

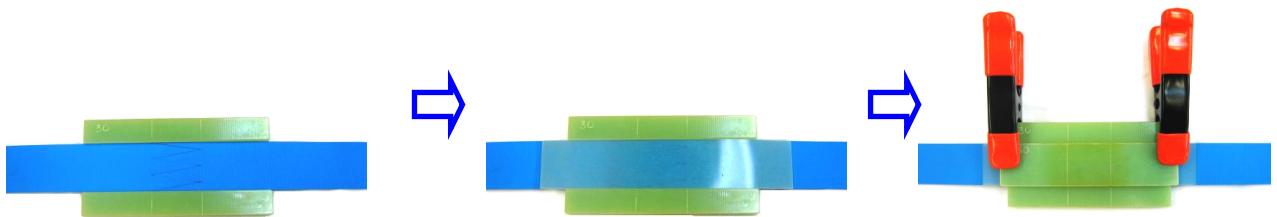
at a time. Push and hold the button and the temperature changes continuously.

(Push  button to raise the set temperature, push  button to lower the set temperature.)

※ If the temperature indication display indicates error [E-1, E-2], immediately disconnect the main plug and stop using the Heat Press.

5. Setting the Belt in the Pre-setter

- Set the belt in the Pre-setter.



① Set both edges of the belt on the bottom plate.

※ **Match both edges so that there is no gap in the joint sections.** Set the joint section within the marking lines on the Pre-setter.

② Set the silicon sheet on the belt.

※ Set the silicon sheet so that the matte surface faces the belt side.
 ※ Remove any dust or foreign object from the silicon sheet.

③ Place the top plate over the silicon sheet.

④ Fix the Pre-setters with the Pre-setter clamps.

If both edges have gap, the final belt length will get longer than required length.

※ Some belts must be placed in the Pre-setter with a particular side of the belt facing up. Please refer to the Endless Conditions Table for these instructions.

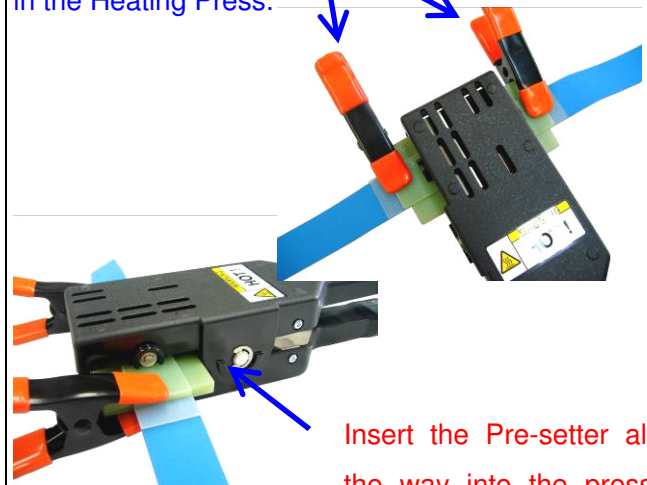
6. Heat Press



Be sure to wear anti-heat gloves in the following procedures.

- Grasp the press handles and open the mouth of the press. Position the Pre-setter centered in the Heat Press and insert the Pre-setter all the way into the press until it touches the hinge. Relax the handle applying pressure and heat for the specified time.

Center the Pre-setter in the Heating Press.



Insert the Pre-setter all the way into the press until it touches the hinge.

- ※ Insert the Pre-setter so that the top plate faces the topside of the press body. There is a label on the bottom of the press indicating “This side down.”. See image to right.
- Heat the press for the specified time for the belt type and the belt width. (Refer to the Endless Conditions Table.)



Immediately disconnect the main plug after the use of the press. Pay attention that others do not touch the press before it is cooled down to a safe temperature.



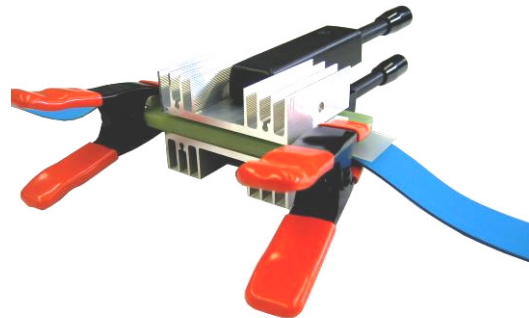
This side down.

7. Cooling Press

- Remove the Pre-setter from the Heat Press and move to the Cooling Press.
- Like the Heat Press, position the Pre-setter centered in the Cooling Press and insert the Pre-setter all the way in until it touches the back of the press. Relax the handles applying pressure, and cool for the specified time.



The Pre-setter is still at a high temperature after heating time. Remove the Pre-setter from the Heat Press and move to the Cooling Press by grasping the Pre-setter clamps.



8. Taking the Belt Out

- After cooling for the specified time, hold the clamps and remove the Pre-setter from the Cooling Press. Remove the belt from the Pre-setter in this order: clamps, Pre-setter top plate, silicon sheet, and the belt.



The Pre-setter is still at a high temperature after cooling time. Be careful to prevent burns when handling the Pre-setter.

- ※ The belt may be used once it reaches room temperature.