

# THERMODRIVE THERMOLACE WITH HEAVY-DUTY EDGE INSTALLATION INSTRUCTIONS

## OVERVIEW

ThermoLace™ Heavy-Duty Edge (HDE) is a new patented joining method for ThermoDrive® belt Series 8050 and 8140. ThermoLace HDE has an unheaded rod retention system and allows for rod insertion from the bottom of the belt. Use the following information to ensure proper installation.



Figure 1: ThermoLace HDE

## COMPATIBLE BELTS/PARTS

ThermoLace HDE is available with Series 8050 and 8140.

## AVAILABLE THERMOLACE HDE MATERIALS

Material	Color	Description
Polyurethane	Blue	Flat Top ThermoLace with Heavy-Duty Edge blue polyurethane
Polyurethane	White	Flat Top ThermoLace with Heavy-Duty Edge white polyurethane
Polyurethane A23	Blue	Flat Top ThermoLace with Heavy-Duty Edge blue polyurethane A23
Polyurethane A23	White	Flat Top ThermoLace with Heavy-Duty Edge white polyurethane A23
Dura	Blue	Flat Top ThermoLace with Heavy-Duty Edge blue Dura

## AVAILABLE ROD MATERIALS

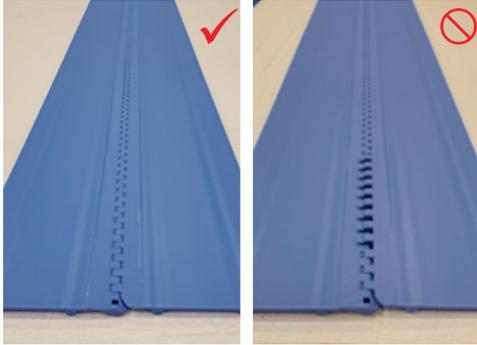
Material	Color	Description
Acetal	Blue	Acetal Blue
Acetal	White	Acetal White
PK	Blue	PK Blue

## TOOLS AND SUPPLIES NEEDED

- ThermoLace HDE for S8050 or S8140
- ThermoLace HDE rods
- Soft-jaw pliers
- Micro-serrated needle-nose pliers (removal)

# INSERTING THE ROD

1. Lace the belting together. Ensure opposing belt ends are aligned and flush without exposing teeth.



**Figure 2:** Ensure correct belt alignment

2. Identify the rod retention "double" captive link at the bottom of the belt.  
**NOTE:** This "double" end link has tailored geometry to allow clearance for rod installation.
3. Insert the rod into the clearance gap. Continue to push the rod into the lace until the rod can go no further. Soft-jaw pliers can be used to push the rod the last inch.



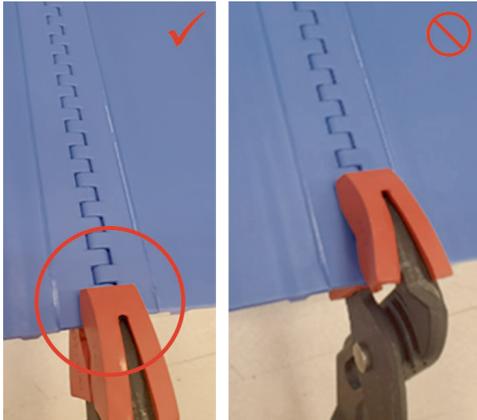
**Figure 3:** Insert rod into clearance gap

4. Ensure the rod end stops at approximately  $\frac{1}{8}$  in (3 mm) from the belt edge.



**Figure 4:** Ensure rod end stops  $\frac{1}{8}$  in from belt edge

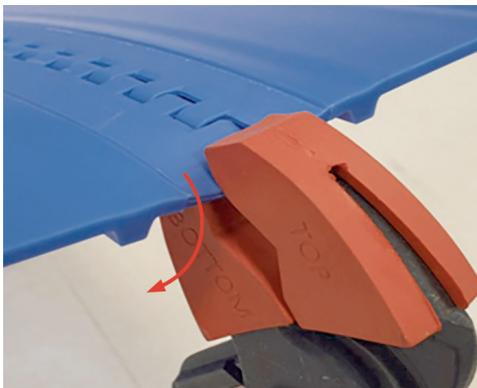
5. Place soft-jaw pliers on the captive link (perpendicular to the belt length), and clamp with moderate pressure.  
**NOTE:** Do not over clamp. The end of the plier jaws must roughly align with the inside edge of the captive link.



**Figure 5:** Clamp soft-jaw pliers on captive link

6. Using the soft-jaw pliers, flex the belt edge **downward** until the rod end is fully captured inside the captive link.

**NOTE:** An audible click may be heard indicating that the rod has snapped into place.



**Figure 6:** Flex belt edge downward to capture rod end

7. To check for correct rod insertion, use the viewing window on the top of the captive link. The rod end must be visible in the viewing window on each end of the lace.

**NOTE:** There is a viewing window on each end of the lace with a total of two (2).

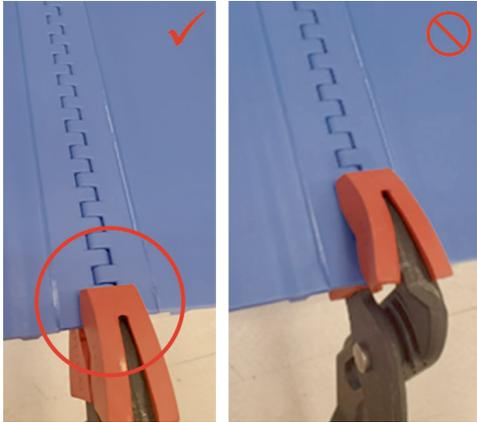


**Figure 7:** Ensure rod ends are visible in both viewing windows

# REMOVING THE ROD

1. Place soft-jaw pliers on the captive link (perpendicular to the belt length), and apply moderate pressure.

**NOTE:** Do not over clamp. The end of the plier jaws must roughly align with the inside edge of the captive link.



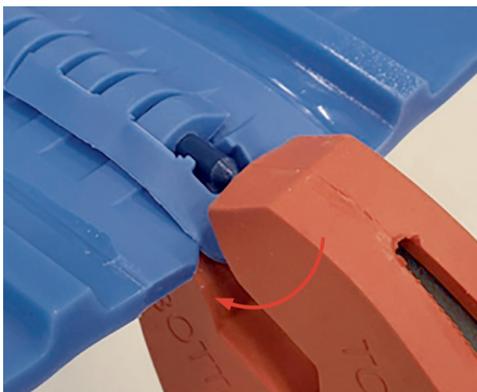
**Figure 8:** Clamp soft-jaw pliers on captive link

2. Using the soft-jaw pliers, flex the belt edge **upward** to disengage the rod end from the captive link.

**NOTE:** An audible click may be heard indicating that the rod has snapped into place.



**Figure 9:** Flex belt edge upward to capture rod end



**Figure 10:** Rod can also be removed with the bottom side of the ThermoLace facing up

3. The rod end is now outside of the captive link.

4. Use micro-serrated needle-nose pliers to place the tip of the pliers in the link cutouts, and clamp the rod with moderate pressure.

**NOTE:** The captive link contains cutouts on either side of the rod to allow clearance for the micro-serrated needle-nosed pliers used in rod removal.



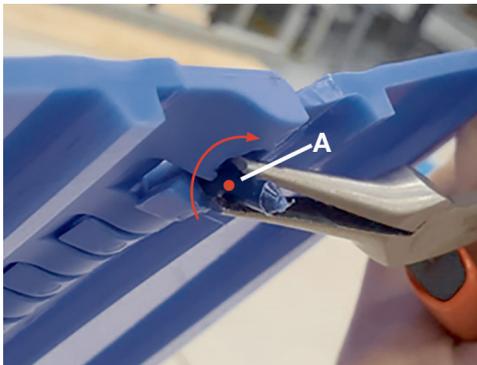
**Figure 11:** Use pliers to clamp rod

5. Twist the pliers counterclockwise (as viewed from the belt edge) and continue to hold the clamp with moderate pressure.



**Figure 12:** Twist pliers counterclockwise while maintaining pressure

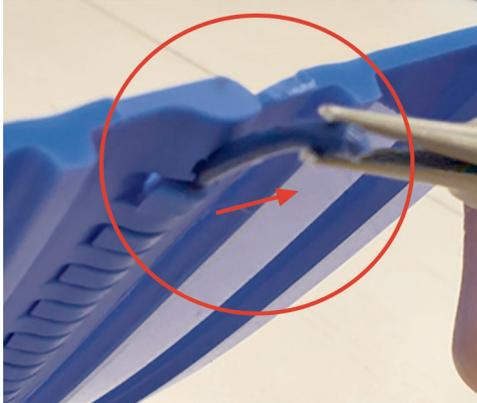
6. In this position, twist to flex the rod end downwards and away from the belt surface. Continue to hold the clamp with moderate pressure.



**Figure 13:** Twist to flex rod down and away from belt surface

**A:** Dot denotes the center of rotation

7. Pull the rod out and away from the belt.



**Figure 14:** Pull rod out and away from belt

8. Alternatively, the rod end can be grabbed by placing one plier jaw between the rod end and captive link. Pull the rod out completely.



**Figure 15:** Rod can also be pulled after using pliers between rod end and captive link

9. Remove any tools used, and separate the belt.

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# ADDITIONAL RESOURCES

Contact Intralox Customer Service for application-specific recommendations.

For additional belt and conveyor guidelines, see the *ThermoDrive Technology Engineering Manual* at [www.intralox.com](http://www.intralox.com).

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