

TECHNICAL BULLETIN

Round Baler Belt Installation

Preparation – Before

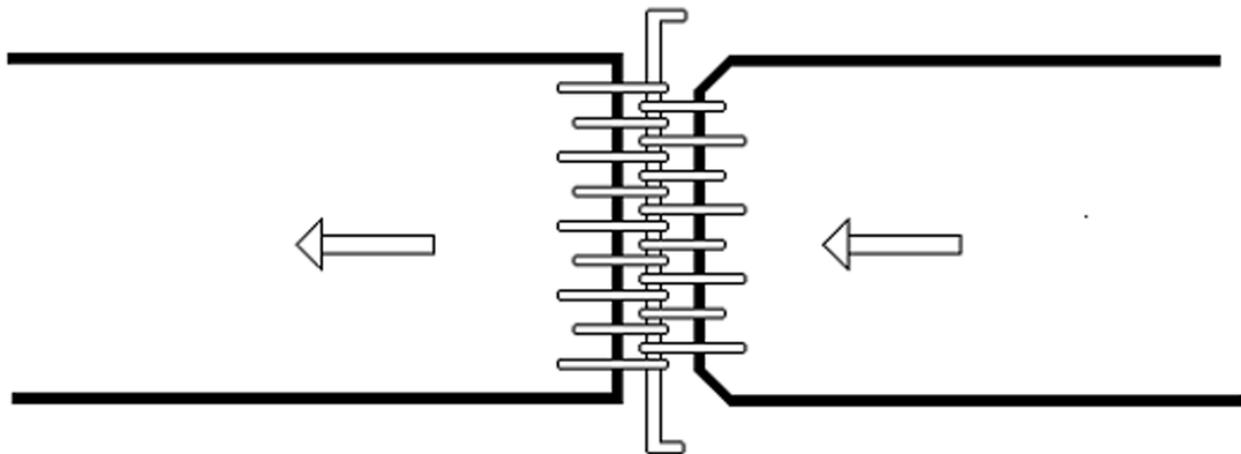
1. Always use the same ply construction for all belts. Two-ply and three-ply constructions do not react in the same manner under tension. Use of different ply constructions will create an unequal load situation and the baler will not perform properly.
2. Check all bearings for movement without drag or noise. Lubricate or replace as required.
3. Check for bent or broken rollers and replace as required. Free all rollers of rust and foreign material buildup.
4. Eliminate catch points; weld splatters and sharp metal edges.
5. Replace all worn belts at the same time.
6. Resize all belts, new and old, to equal lengths for maximum load distribution.
(NOTE: Resize all belts between each baling season.)

Maintenance – After

1. Take up roller adjustment to recommended tension. (Important: Check your baler's operating manual for proper tension adjustment. NOTE: It is especially important to leave the recommended slack in the belts on Vicon, McKee, New Idea and corresponding Case IH models. A belt adjusted too tight will have a shorter service life.)
2. Check your belts, belt lacing and pin occasionally during use. Make repairs or replacements as required. (Note: The lacing and connecting pin are your belts' weakest points. Proper maintenance is critical to your baler's overall performance.)
3. Resize all belts and replace as necessary between baling seasons. Check your baler thoroughly before starting your next baling season.
4. Remember, WCCO Baler Belts are specially designed for large round balers. Special materials and quality craftsmanship make WCCO Baler Belts excellent replacement products that meet or exceed O.E.M. requirement.

Installation - Upper Belts

1. Install belt following "Direction Of Travel" arrow. (End with 45-degree corners and the least number of hooks is the trailing end. End with square-cut corners is the leading end.)



BULLETIN - PLEASE READ!

2. After threading a belt through the machine, pull ends together. Insert connecting pin through the lacing hooks making sure the hooks on both end alternate. (Leading end should have hooks on both outside edges.)
3. After inserting the connecting pin completely, bend approximately $\frac{1}{4}$ inch of the straight end at a 90-degree angle to match the other end.

Lower Platform Aprons

1. Clean V-guide slot on pulleys. (Note: International Harvester models do not have V-guides.)
2. [Follow steps 1 & 2 from Upper Belts instructions above.]
3. If Clipper Lacing is used, insert leader wire attached to cable, through hooks. Do not jerk on leader wire or it will come off. After cable is in place, remove leader wire, attach retaining nut and crimp it. If Minet Lacing is used, install pin and bend approximately $\frac{1}{4}$ inch of straight end at a 90-degree angle.
4. Run baler momentarily to check for proper tracking, adjust as necessary.

Endless Belt Installation Tip:

After installing the new belts, decrease the belt tension to about 60-70% of the normal baling tension and run the PTO slowly (less than half normal speed). Watch the belts for tracking so that they don't run up against any belt guides. This will probably take some roller adjustments on the baler. Adjust the rollers according to the baler's Owner's Manual. Slowly increase the PTO speed while watching the belts for tracking. Slowly increase the belt tension to no more than 75% of the normal baling tension. If the belts are running properly you can go to the field for baling. Start baling at a reduced throttle speed to insure proper installation and tracking of the new belts. Do not increase the belt tension for increased bale density until you have run at least 25 bales. This will allow the belts to break-in and conform to your baler. Continue to monitor your belts daily and make adjustments when necessary.

NOTE: Belts, which are all replaced as a set, will generally fit better and last longer.