Illustration 1: Components of welder include press, toothed and top plates, and controls. A bonding agent is required for operation and is not sold by BRECOflex CO., L.L.C. – visit [www.brecoflex.com/fieldwelder](http://www.brecoflex.com/fieldwelder) for the bonding agent specifications and a list of vendors.

Illustration 2: Place the toothed plate with flanges on top of the base plate.
Illustration 3: Remove stray wires in the die-cut area of the timing belt.

NOTE: Avoid skin and eye contact with polyurethane adhesive. Do not inhale fumes. Observe the safety instructions of the adhesive manufacturer.
Illustration 5: Insert first half of timing belt after having applied the bonding agent.

Illustration 6: Insert second half of timing belt after having applied the bonding agent.
Illustration 7: Open flanges to facilitate placement of timing belt.

Illustration 8: Press timing belt sections into the welder by lightly tapping with a plastic part.
Illustration 9: Tighten screws of flange(s).

Illustration 10: Brush additional bonding agent onto the weld area.
Illustration 11: Position the pressure plate over the weld area of the timing belt.

Illustration 12: Flip top plate over pressure plate.
Illustration 13: Tighten top plate with wing nuts

Illustration 14: Tighten top plate with wing nuts
Illustration 15: Make sure that the power cord is plugged in. Switch on the heating element. The indicator will light for only the first few minutes of the cycle.

**NOTE: The welder will become very hot! Danger of burning!**

The heating element will automatically switch off after reaching the internal weld temperature of approximately 200°F. After a heating and cooling time of approximately 90 minutes, the timing belt can be removed from the welder.