

## Instruction Manual

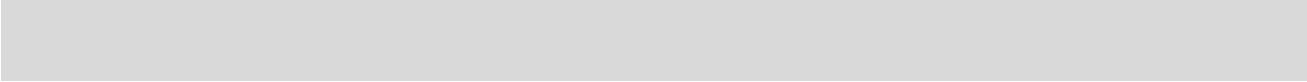
### NBC Full Welding Instruction with Nitta Blue Urethane Belt

Revision Date: January 01, 2026

Document Part Number: 1207439

FORTNA • 131 Griffin Way • Mt. Washington, KY 40047

©2018 - 2026



## DOCUMENT VERSION HISTORY

Revision Date	Description	Initial
9/13/2019	Add caution note to use only FORTNA conveyor welder equipment.	AB
06/27/2019	Changed belt overlap length. NBC-150-AT from 36" to 18" and added 500-AT to be 36".	AB
09/29/2021	Added FORTNA conveyor name, logo, and format.	AB, MD
01/24/2023	Updated weld belt overlap information and updated some pictures.	AB, MD
01/26/2024	Add additional information for the top & bottom of the Nitta belt.	AB, MD
01/01/2026	Update logo, safety and format	AB, MD

## TABLE OF CONTENTS

DOCUMENT VERSION HISTORY .....	3
TABLE OF CONTENTS .....	4
PREFACE .....	5
DISCLAIMER .....	5
LIMITATION OF LIABILITY .....	5
LINKS TO THIRD-PARTY SITES .....	5
COPYRIGHT INFORMATION .....	6
1 INTRODUCTION .....	7
1.1 PURPOSE .....	7
1.2 SCOPE .....	7
2 CONVEYOR SAFETY INFORMATION .....	8
2.1 WARNINGS AND SAFETY INSTRUCTIONS .....	8
2.2 CONVEYOR SAFETY RECOMMENDATION .....	13
3 NBC CONVEYOR PREPARATION .....	14
4 FINGER PUNCH PROCESS .....	19
5 NBC WELD INSTRUCTIONS .....	23
6 CONVEYOR KITS & REPLACEMENT PARTS .....	29
7 TROUBLESHOOTING – NITTA CORPORATION .....	31
7.1 AIR BUBBLES .....	31
7.2 IMPROPER BELT WELDING .....	34
WORKS CITED .....	35
GENERAL INFORMATION .....	36

## PREFACE

### DISCLAIMER

It is the Customer's and the system user's responsibility to ensure that the system is operated only in safe conditions and in accordance with this document and any other documentation or instructions provided by FORTNA or its representatives. THIS DOCUMENT CONTAINS IMPORTANT WARNINGS AND SAFETY REQUIREMENTS. This document must be available to and accessible by any users or anyone with access to the system so that it may be regularly consulted.

ANY PERSON TO USE OR ACCESS THE SYSTEM IN ANY WAY MUST CAREFULLY READ AND UNDERSTAND THIS DOCUMENT. VISITORS OF ANY KIND, AUTHORIZED AND UNAUTHORIZED GUESTS, CHILDREN, ANIMALS AND ANY OTHER PERSON WHO HAS NOT FULLY READ AND UNDERSTOOD THIS DOCUMENT MUST BE KEPT AT A SUITABLE AND SAFE DISTANCE FROM THE SYSTEM. PHYSICAL CONTACT WITH THE SYSTEM MUST BE AVOIDED AT ALL TIMES. SUITABLE WORK CLOTHING AND PROTECTIVE GEAR ARE REQUIRED.

All FORTNA warranties will be voided by any misuse of the system, failure to exercise care, inappropriate behavior, failure to comply with this document or other documentation or instructions supplied by FORTNA or its representatives, or unauthorized modification of the system. Please refer to the applicable FORTNA warranty document for other warranty limitations.

You must contact FORTNA at [usinfo@fortna-conveyor.com](mailto:usinfo@fortna-conveyor.com) or (231) 798-4547 immediately with any questions or concerns about this document or the system.

### LIMITATION OF LIABILITY

TO THE MAXIMUM EXTENT PERMITTED BY APPLICABLE LAW, FORTNA SHALL NOT BE LIABLE FOR ANY DAMAGES SUFFERED BECAUSE OF USING, MODIFYING, CONTRIBUTING, COPYING, DISTRIBUTING, OR DOWNLOADING THE MATERIALS IN THIS MANUAL.

IN NO EVENT SHALL FORTNA BE LIABLE FOR ANY INDIRECT, EXTRAORDINARY, EXEMPLARY, PUNITIVE, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PRODUCTION, REVENUE, PROFITS, USE OR OTHER ECONOMIC ADVANTAGE) HOWEVER ARISING, WHETHER BY BREACH OR IN TORT (INCLUDING NEGLIGENCE), EVEN IF FORTNA HAS BEEN PREVIOUSLY ADVISED OF THE POSSIBILITY OF SUCH DAMAGE. IN NO EVENT SHALL FORTNA BE LIABLE FOR ANY DAMAGES CAUSED BY MISUSE OF THE SYSTEM, FAILURE TO EXERCISE CARE, INAPPROPRIATE BEHAVIOR, FAILURE TO COMPLY WITH THIS DOCUMENT OR OTHER DOCUMENTATION OR INSTRUCTIONS SUPPLIED BY FORTNA OR ITS REPRESENTATIVES, OR UNAUTHORIZED MODIFICATION OF THE SYSTEM.

Customer agrees to sole responsibility for adequate protection and backup of data and equipment used in connection with the product and will not make a claim of any nature against FORTNA for inaccurate output, work delays or lost profits resulting from the use of the materials. Customer agrees to hold harmless from and covenant not to sue FORTNA or its affiliates, successors, or assigns for any claims related to FORTNA relating to the foregoing.

### LINKS TO THIRD-PARTY SITES

This user manual may contain links to third-party sites, however, FORTNA Inc. is not responsible for and cannot control these other sites. FORTNA Inc. makes no representations whatsoever about any other website accessed through this user manual. If accessing a non-FORTNA Inc. website, even one that may contain an FORTNA Inc. logo, it is independent from FORTNA Inc. and that FORTNA Inc. has no control over the content on that website. In addition, a link to a non-FORTNA Inc.

website does not mean FORTNA Inc. endorsed or accepts any responsibility for the content, or the use of such website. Take precautions for viruses, worms, Trojan horses, and other items of a destructive nature.

## COPYRIGHT INFORMATION

Information in this document is subject to change without notice. ©2025 FORTNA Inc. All rights reserved.

Trademarks or trade names may be used in the document to refer to either the entities claiming the marks and names or their products. FORTNA Inc. disclaims any proprietary interest in trademarks and brand names other than its own.

## 1 INTRODUCTION

### 1.1 PURPOSE

This manual contains the instructions to properly weld a Nitta belt for use with FORTNA Conveyor NBC flat belt conveyor. These instructions use the FORTNA Conveyor Nitta belt Finger Punch and Weld Press. FORTNA Conveyor recommends watching the enclosed flash drive video instruction along with all FORTNA Conveyor or Nitta manuals before repairs.

### CAUTION

- Use Only FORTNA Nitta belt welder and punch equipment for FORTNA Conveyor Nitta belt splice/welding.
- Non-FORTNA Nitta belt welding or punch equipment is not compatible with the FORTNA Nitta belt!

**Failure to follow these instructions can result in injury or equipment damage.**

### 1.2 SCOPE

The purpose is to obtain strong, consistent belt joints in a safe and efficient manner. To accomplish this, these instructions must be followed closely.

For more FORTNA Conveyor information:

Visit [FORTNA-conveyor.com](https://www.fortna-conveyor.com) for more maintenance videos and FORTNA Conveyor IOM manuals.


## 2 CONVEYOR SAFETY INFORMATION


### 2.1 WARNINGS AND SAFETY INSTRUCTIONS

Failure to follow the instructions and cautions throughout this manual and warning labels on the conveyor may result in injury to personnel or damage to the equipment.

Your FORTNA Conveyor is powered by a motor and can be stopped only by turning off electrical power to the motor. As with all powered machinery, the drive-related components – including sprockets, chains, shafts, universal joints, and pneumatic devices – can be dangerous. We have installed or provided guards to prevent accidental contact with these parts, along with warning labels to identify the hazards.

**Special attention must be paid to the following areas of this manual:**

 <b>DANGER</b>
<b>HAZARD OF ELECTRIC SHOCK</b>
<ul style="list-style-type: none"> <li>• Wear appropriate personal protective equipment (PPE) and use proper Lockout/Tagout procedures.</li> <li>• The equipment must be installed, operated, and serviced by properly trained and qualified personnel.</li> <li>• Turn off power supplying the equipment before working on or inside the equipment.</li> </ul>
<b>Failure to follow these directions will result in death or serious injury.</b>

 <b>WARNING</b>
<b>HAZARD TO EQUIPMENT OR PERSONNEL</b>
<ul style="list-style-type: none"> <li>• Do not eat food, drink, or smoke while operating or servicing the equipment/conveyor.</li> <li>• Do not operate or service the equipment/conveyor if under the influence of drugs, alcohol, sedatives, or any other medication whether prescribed by a doctor or not.</li> <li>• Do not operate or service the equipment/conveyor if sleep deprived or over fatigued.</li> </ul>
<b>Failure to follow these instructions can result in death, serious injury, or equipment damage.</b>

## **WARNING**

### **ELECTRICAL HAZARD**

- Installation must be performed by a certified and licensed electrician.
- Electrical service must conform to local and national electrical codes and regulations.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

## **WARNING**

### **ELECTRICAL HAZARD**

Electrical service must be performed by properly trained, qualified, and licensed personnel.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

## **WARNING**

### **HAZARD OF MOVING PARTS**

- Make sure all personnel are clear of moving parts before starting the equipment/conveyor.
- All starting and stopping devices, and all loading and unloading areas should be kept free of obstructions.
- Keep hair, clothes, hands, and jewelry away from moving parts.
- Do not operate the equipment/conveyor without all motor guards being in place.
- Never touch, walk, ride, or climb on a moving belt or conveyor equipment.
- Never clear jams while the equipment is running.
- Do not pull-on equipment parts, such as belts, pulleys, or shafts, to assist slow-starting equipment.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

## **WARNING**

### **HEAVY EQUIPMENT**

- Follow site safety procedures while moving equipment.
- Make sure to use moving equipment certified for the weight of the equipment.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

## **WARNING**

### **HAZARD TO PERSONNEL**

- Only qualified and trained personnel should operate this equipment.
- All operating procedures must be followed.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

## **WARNING**

### **HAZARD OF INJURY TO PERSONNEL**

- Do not remove or tamper with safety devices.
- Do not remove shields or panels, or bypass or otherwise disable interlocks while the unit is in operation.
- Pay attention to the safety instructions!
- Prior to working at or in the immediate vicinity of the system it is recommended that you make yourself familiar with the safety instructions included in the present document!
- FORTNA recommends reading all manuals supplied by FORTNA or Nitta Corporation. <https://www.nitta.com/>
- FORTNA recommends only trained and maintenance personnel for conveyor repairs.
- Do not use tools or equipment stated in this manual for other applications.
- Do not dismantle or remodel equipment or tools under any circumstances. Safety: Always lock out power sources and follow recommended safety procedures.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

## **CAUTION**

### **HAZARD OF INJURY TO PERSONNEL**

- Wear PPE when using compressed air.
- Do not direct compressed air toward yourself or another person.
- Do not use compressed air to clean yourself or clothing.
- Do not carry out practical jokes using compressed air.

**Failure to follow these instructions can result in injury or equipment damage.**

## CAUTION

### SHARP EDGES

- Never place hands or feet between the belt and guards.
- Remove sharp edges, protruding objects, and safely replace broken or worn parts promptly.

**Failure to follow these instructions can result in injury or equipment damage.**

## CAUTION

### HAZARD TO PERSONNEL AND EQUIPMENT

Follow site-specific safety guidelines.

**Failure to follow these instructions can result in injury or equipment damage.**

## CAUTION

### HAZARD TO PERSONNEL OR EQUIPMENT

Troubleshooting must be performed by qualified and trained personnel.

**Failure to follow these instructions can result in injury or equipment damage.**

## 2.2 CONVEYOR SAFETY RECOMMENDATION

FORTNA Conveyor agrees to the following safety instruction or guidelines listed within this manual. This is not to conflict with your state legal requirements.

FORTNA Conveyor Recommends for maintenance or repair purposes, to incorporate a lock out or tag procedure. To ensure all starting devices, prime movers, or powered accessories are off before attempting to maintenance or repair.

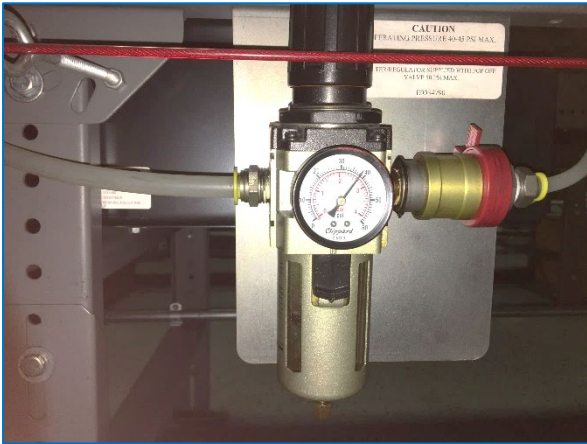
The procedures below are designed to protect everyone involved with the conveyor against an unexpected restart. To include understanding of potential hazard of stored energy, which can exist after the power source is locked out.

**For additional information, refer to the latest issue of ANSI Z244.1, American National Standard for Personnel Protection – Lockout/Tagout of Energy Sources– Minimum Safety Requirements.** <http://www.ansi.org/>

**OSHA 29CFR Part 1910.147 “Control of Hazardous Energy Sources (Lockout/Tagout)”**, which includes requirements for release of stored energy and OSHA Safety and Health Regulations for Construction 1926.555 Conveyors <https://www.osha.gov/>

## 3 NBC CONVEYOR PREPARATION

- 1) Make sure the main air regulator is at 40psi.



- 2) Before installing the belt, make sure the air is **OFF** to the **belt take-up**. This moves the take-up pulley to the retracted position which allows you to work with the maximum belt slack.



- 3) Turn off the power to the logic modules.

**Note:** If you can't find the power supply, you can disconnect the main power to the logic modules. This will allow air to flow through to the pressure pans and push the pressure pans down.



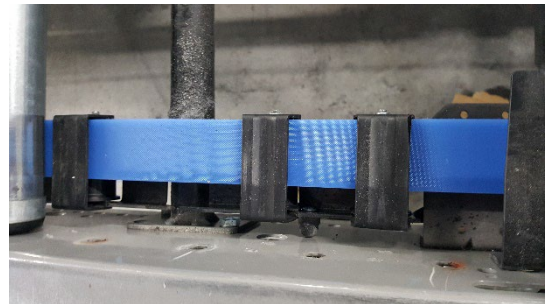
- 4) Remove rollers between two pressure pan supports in a 3' zone. Any zone can be selected, but it is easier to select one near the charge or discharge end of the conveyor.

**Note:** Pull the axles with pliers to protect the frame.



- 5) Remove any finger guards.

Depending on your work zone area, there may be three (3) different finger guards. Those between the pressure lift assemblies simply snap-in or out. Those over the pressure assemblies are removed by rotating a quarter turn clockwise and pulling out. If the belt splicing work area includes in crossmember, a different shape finger guard is used, which also snaps into place.

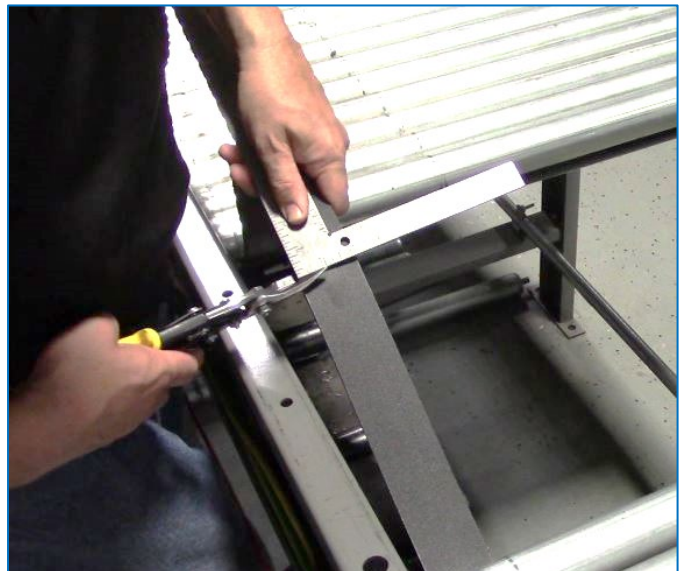


- 6) Un-coil the Nitta belt.



- 7) **Note:** If replacing an **existing belt**, cut the previous belt straight.

**Note:** For **new installation** use the NBC **threading tool** (located and attached under each drive from factory). NBC threading instructions are also in FORTNA Conveyor IOM Manual at [FORTNA-conveyor.com](http://FORTNA-conveyor.com)

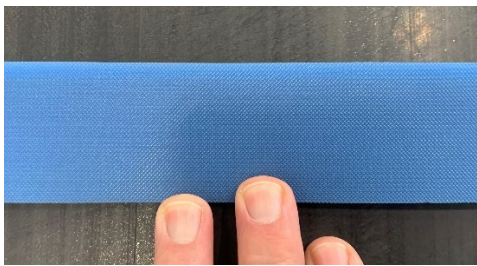


## ⚠ CAUTION

### HAZARD TO EQUIPMENT

- Before threading the belt. Make sure the thick polyurethane side is up and the thin material side is down.

**Failure to follow these instructions can result in injury or equipment damage.**



Top View

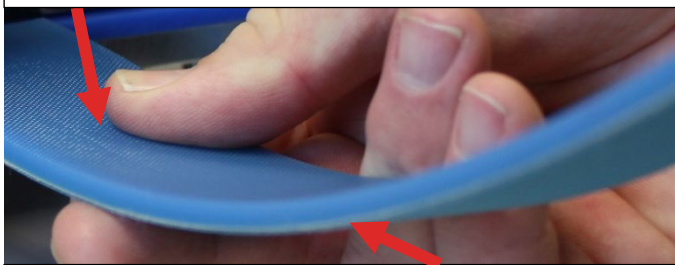
- Top of the Nitta polyurethane belt up (thick side) with slight texture.



Bottom View

- Bottom of the belt thin side is smooth.

Top of the polyurethane belt up (thick side) with slight texture.



Bottom of the belt thin side is smooth.

### Nitta belt routing:

- The top of the belt is the polyurethane side (thick side) should be facing up towards the ceiling from the top of the conveyor rollers.

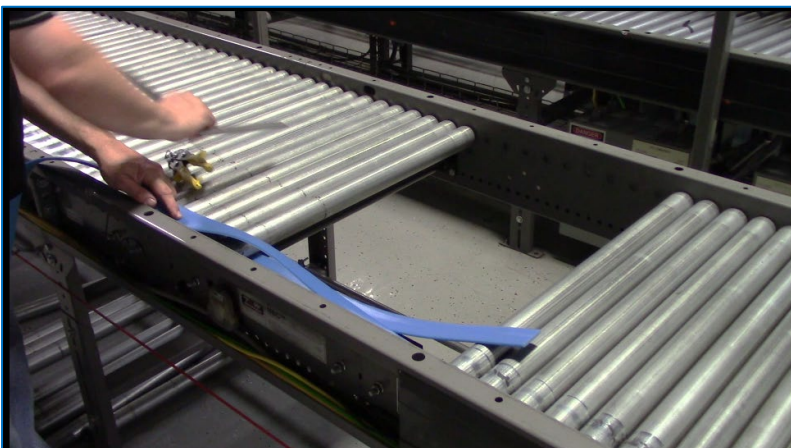
- 8) Duct tape the top and bottom of the old belt end to the new Nitta belt end (thick polyurethane side up) making sure to keep both belts are flat and straight, **do not** overlap the belts.



- 9) Pull the new Nitta belt through the conveyor. Make sure the Nitta belt is routed correctly over all the return pulleys underneath the conveyor. Remove the Duct tape.



- 10) Before cutting the belt to length, make sure there is 18" overlap for NBC 150-AT and 250-AT30. For NBC 500-AT 36" overlap is required. The overlap is to compensate for belt loss in the finger splice process. Both belt ends must be cut straight.



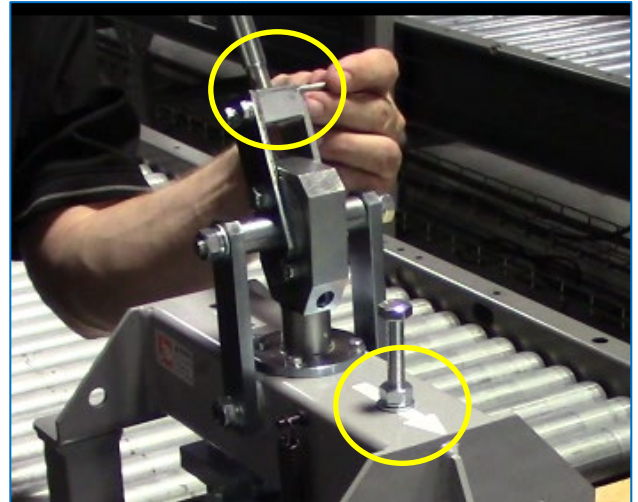
## 4 FINGER PUNCH PROCESS

- 1) Using the Nitta Finger Punch Press assemble the handle and place the press with the arrow sticker pointing in the belt flow direction.

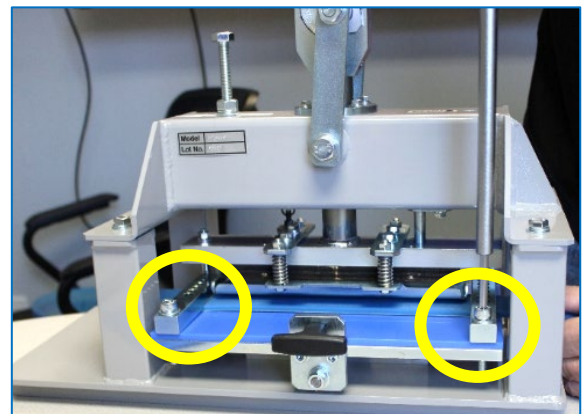
### CAUTION

- Use Only FORTNA Nitta belt welder and punch equipment for FORTNA Nitta belt splice/welding.
- Non-FORTNA Nitta belt welding or punch equipment is not compatible with the FORTNA Nitta belt!

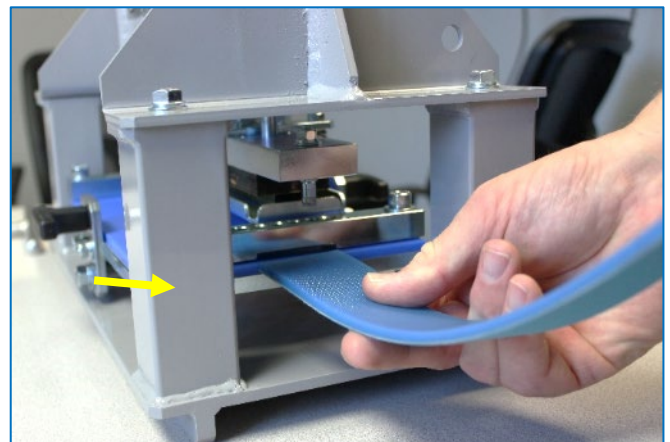
Failure to follow these instructions can result in injury or equipment damage.



Loosen the bolts to the hold-down plates.

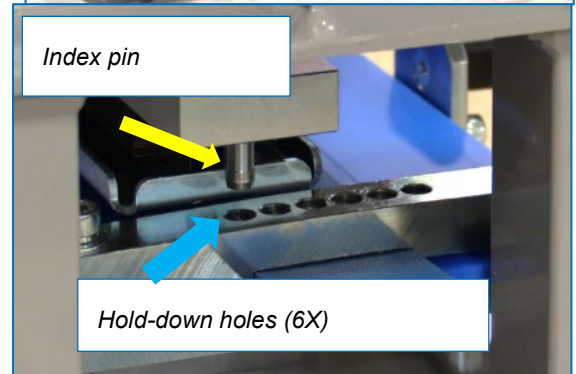
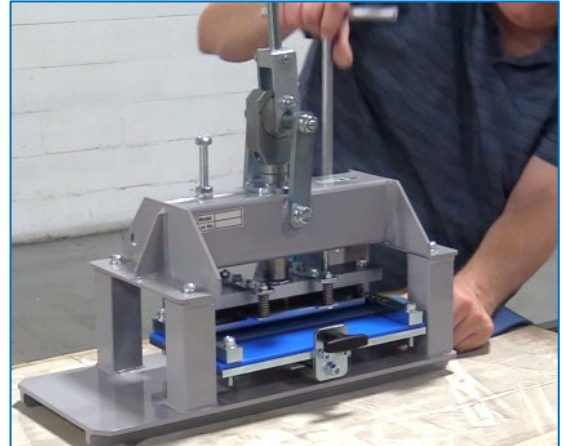


- 2) Insert one end of the belt, polyurethane side up, through the notched guide on the hold-down bar. Slide the belt all the way through to the other end of the press.



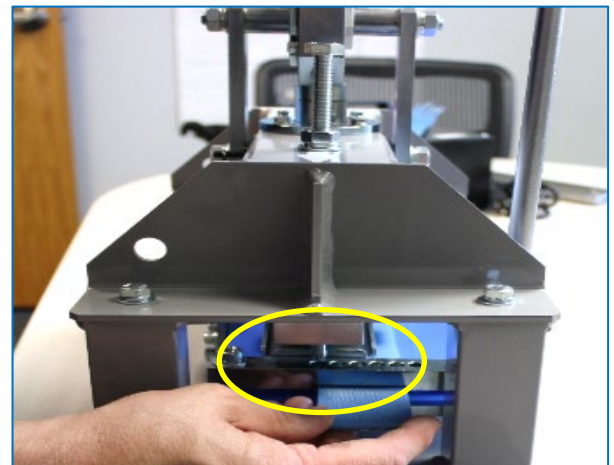
- 3) Hold the belt firmly while tightening the hold-down bars bolts in an alternating pattern.

- 4) Position the top index pin with the first outside hole on the hold-down plate.



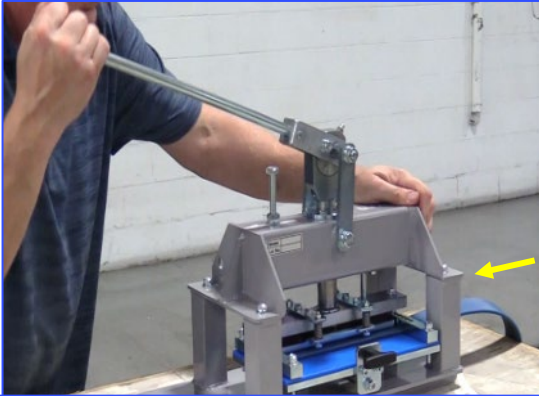
**WARNING:** Each hole must be punched in **PROPER SEQUENCE** and in **EVERY HOLE** (6x). Failure to do so will cut off one of the fingers making the belt unsliceable.

- 5) Starting at one end of the puncher, make sure the top pin is aligned with outside hole. Press the handle all the way down. This is the 1st punch of 6 needed for each belt end.

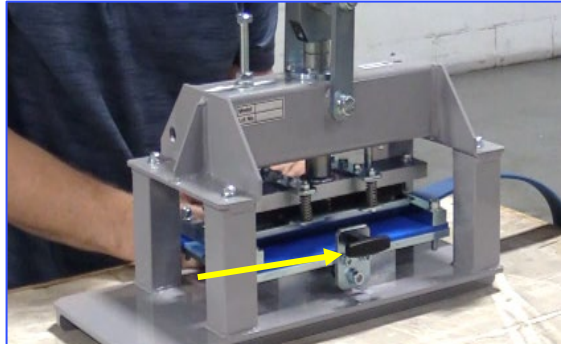


Move plate to align top index pin with the first hole

- 6) Return the handle to original position. Move the support plate to the next hole and repeat the process. When complete, loosen the hold-downs and remove the belt.



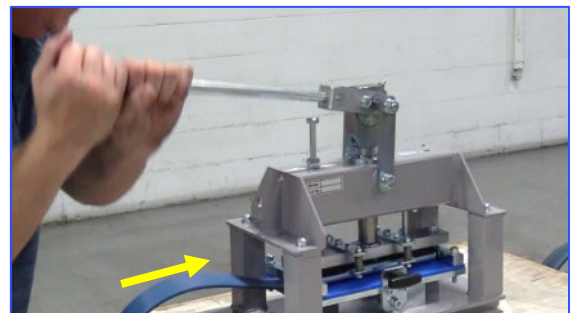
*Belt inserted from the left*



*Handle to slide the support plate*

- 7) Repeat process for other belt end. Thread the belt into the puncher from the opposite direction.

**WARNING: DO NOT ROTATE THE FINGER PUNCH PRESS!** The press must stay in the same orientation for the entire process.



*Belt inserted from the right*

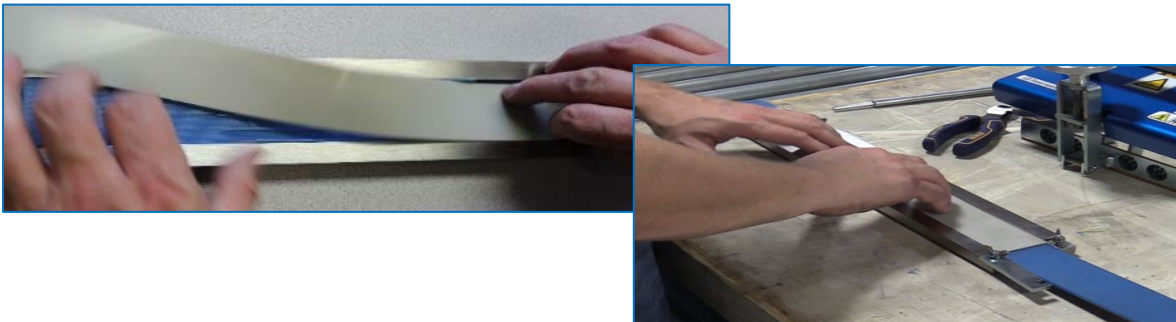
- 8) Trim about 0.25" off each fingertip. This will mate each finger in the pre-setter and to ensure a good splice.



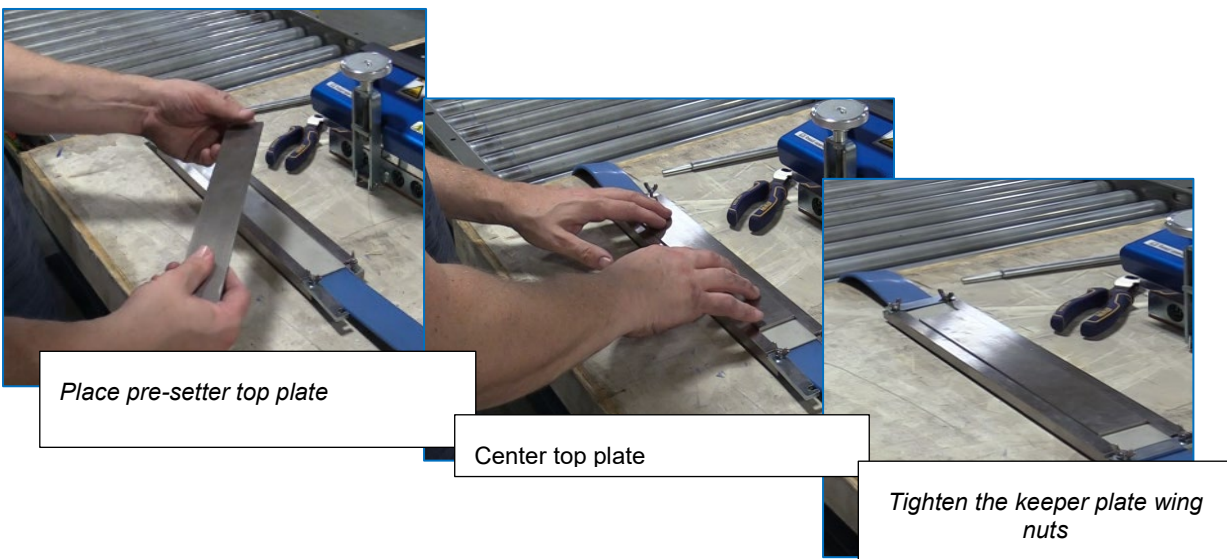
- 9) Install one end of the belt in the Pre-setter mold, making sure the belt fingers are centered in the pre-setter plate. Insert the other end of the belt and slide the fingers together, mating them with no overlaps or large gaps.



- 10) Install the silicone sheet, with textured side facing down on the belt finger spliced section.



- 11) Place the pre-setter top plate center over the finger spliced area. Once the top plate is centered, tighten the keeper plate wing nuts to keep the belt flat and secure.



## 5 NBC WELD INSTRUCTIONS

### CAUTION

#### EQUIPMENT DAMAGE

- Use Only FORTNA Nitta belt welder and punch equipment for FORTNA Nitta belt splice/welding.
- Non-FORTNA Nitta belt welding or punch equipment is not compatible with the FORTNA Nitta belt!

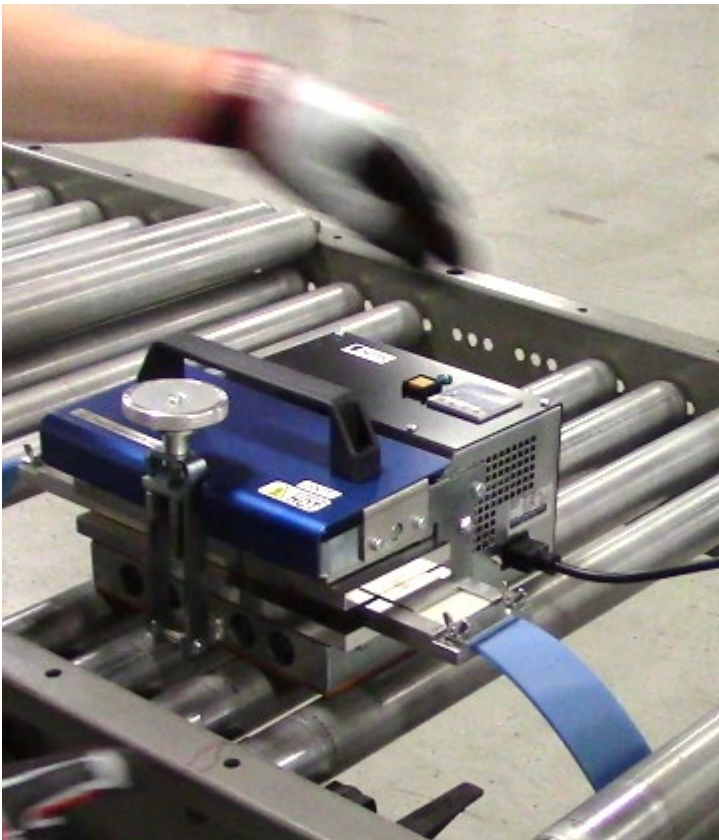
**Failure to follow these instructions can result in injury or equipment damage.**

12) Place the FORTNA Conveyor welder press on the conveyor and set the pre-setter mold **center** in the weld press. Clamp the press closed and turn the knob until it slips.

**CAUTION:** Be careful not to pull out the belt from the pre-setter as this may cause the finger splice to gap or overlap.



13) Plug in the FORTNA Conveyor welder cord then push the yellow button to start.



## **WARNING**

### **HAZARD TO PERSONNEL**

#### **WARNING! WELD PRESS IS HOT!**

- FORTNA Conveyor recommends to wear heat resistant gloves when operating the press.

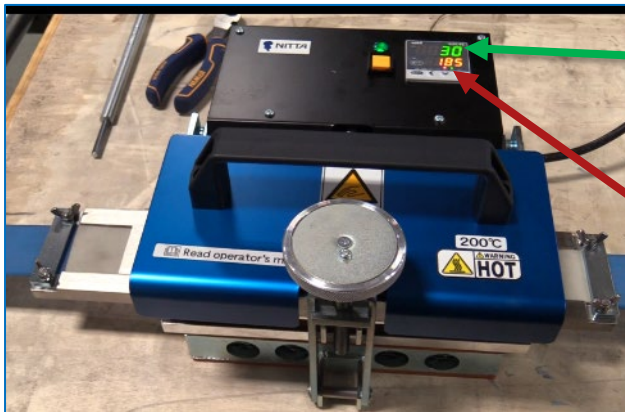
#### **WELD PRESS IS HOT!**

- Do not leave press unattended while in use. To prevent others people from touching the weld press. Failure to do so may cause others to touch the press and get burned.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

**Note:** The green light is the actual temperature reading. The amber light is the welder press pre-programmed temperature and should be set at 185 Degrees Celsius (185°C).

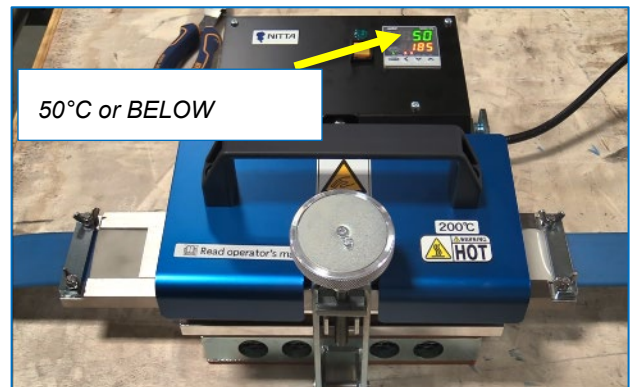
**Note:** When starting the FORTNA Conveyor welder press it will automatically run a diagnostic test for about 6 seconds then starts heating up to the preset temperature. After 10 minutes at full temperature, the press will automatically shut down the heaters and start the cooling fans. (Total weld time is approximately 60 minutes).



**GREEN LIGHT IS THE ACTUAL TEMPERATURE**

**AMBER LIGHT IS PRE-SET TEMPERATURE AT (185°C)**

**Note:** The weld cool down process is done when the actual temperature gage (green light) is 50°C or lower.



**REMOVE WELDER POWER CORD!**

## **⚠ WARNING**

### **HAZARDOUS TO PERSONNEL**

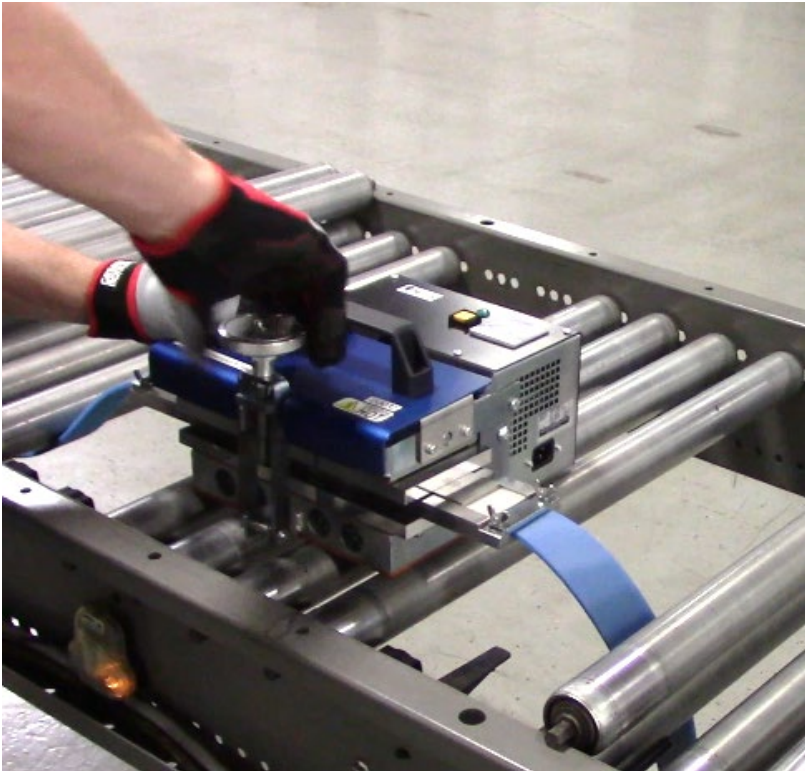
- Before opening the weld press remove the power cord to ensure the power is off.

### **WELDER PRESS IS HOT!**

- FORTNA Conveyor recommends wearing heat resistant gloves!

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

- 14) Only when the actual temperature (green light) is **50°C or lower** and when the welder press **power cord is unplugged** it's safe to open the FORTNA CONVEYOR welder press. Loosen the knob and pull the clamp down to open the press.



## **WARNING**

### **HAZARDOUS TO PERSONNEL**

#### **WARNING! WELD PRESS IS HOT!**

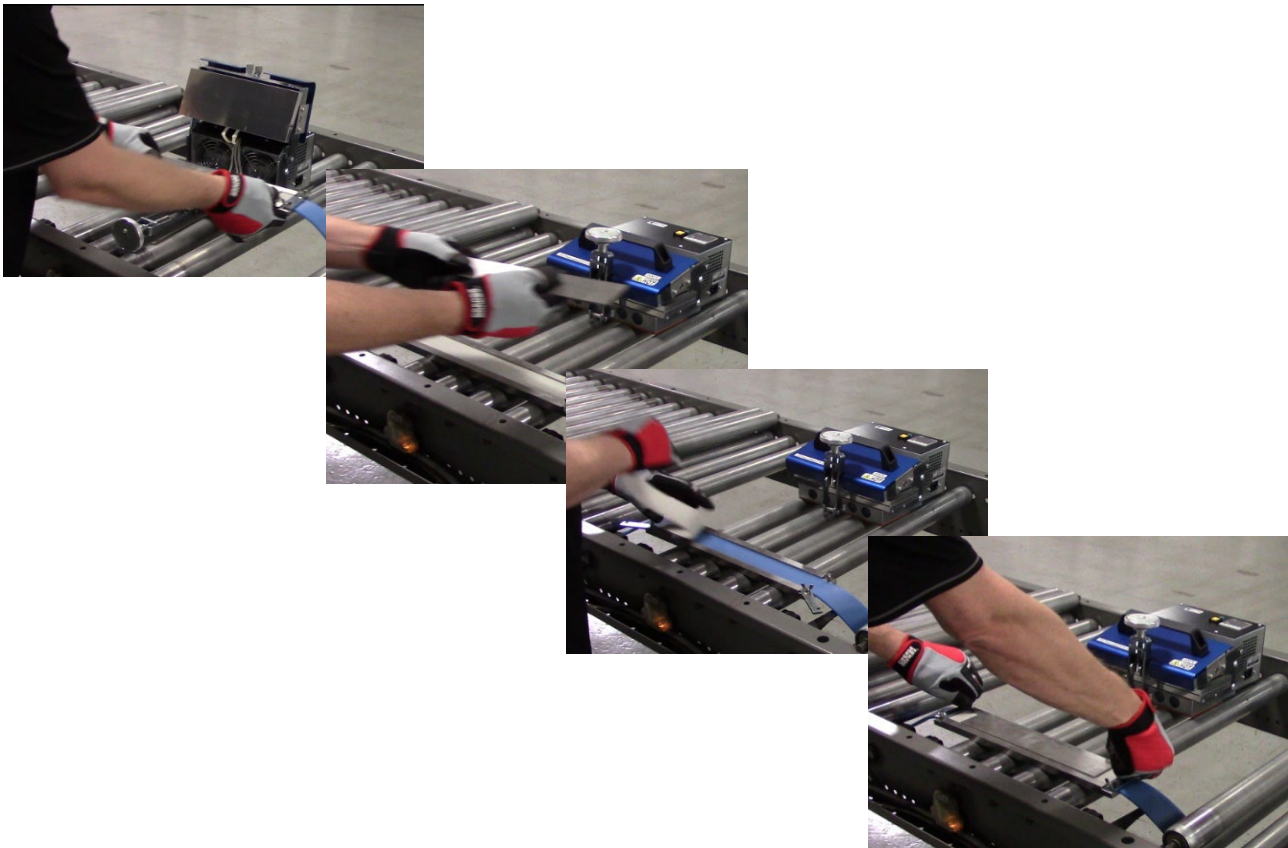
- FORTNA Conveyor recommends to wear heat resistant gloves when operating the press.

#### **WELD PRESS IS HOT!**

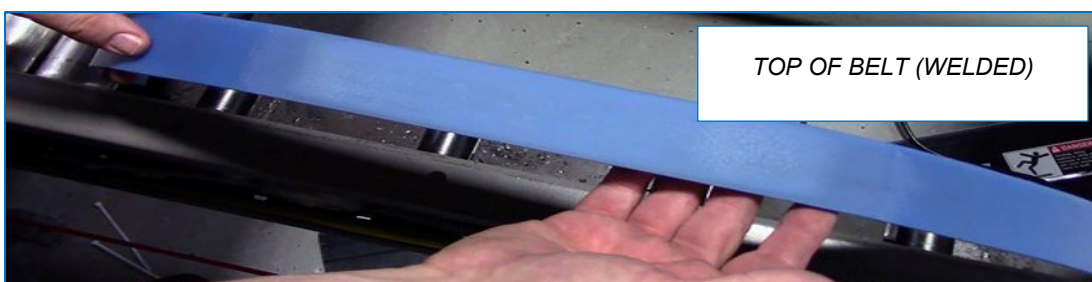
- Do not leave press unattended while in use. To prevent others people from touching the weld press. Failure to do so may cause others to touch the press and get burned.

**Failure to follow these instructions can result in death, serious injury, or equipment damage.**

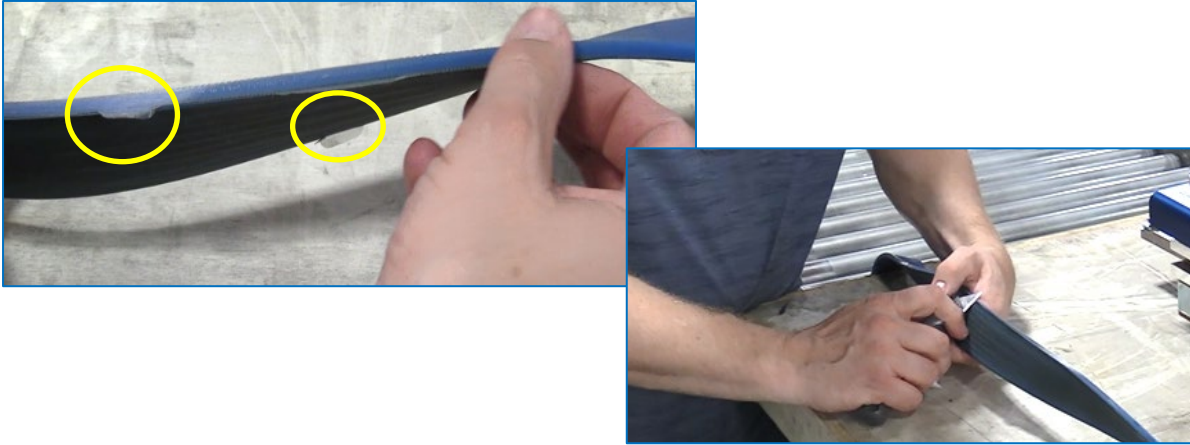
- 15) Remove the pre-setting mold, pre-setter top plate, silicone sheet, and loosen the keeper plate wing nuts to unlock the belt. Remove the belt from the pre-setter mold.



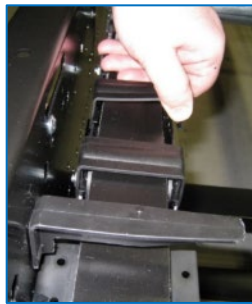
- 16) Inspect the top and bottom of the belt. Make sure the belt splice has smoothly joined even fingers with no bubbles, gaps, or overlaps. (See troubleshooting section for defect details.)



- 17) If excess material is present, carefully trim the excess material off the side edges of the belt.  
**Note:** Do not cut into the belt.



- 18) Reinstall the finger guards and rollers.



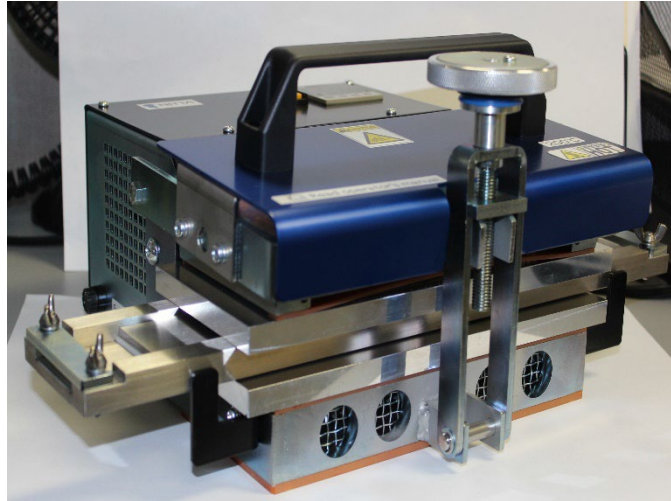
- 19) Turn on the air to the take up unit.



- 20) Restore power.



## 6 CONVEYOR KITS & REPLACEMENT PARTS



To rent or order parts contact FORTNA Lifecycle Performance Services at 231-798-4547.

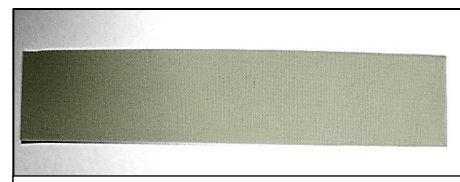
### NITTA BELT FULL WELD & PUNCH KITS (RENTAL KITS ONLY!)

Item #	Description
1207112	TOOL, NBC-NITTA-RENTAL-WELDER KIT-FULL
<p><b>Rental Kit Include: Finger Punch Press, T-wrench, Heated Weld Press, Pre-setter Mold, Silicone Sheet, Instruction Manuals, and Flash Drive with Instruction Video. Each Press Kit Is Shipped in a Hard Case.</b></p>	

NITTA BELT FULL WELD & PUNCH KITS (RENTAL KITS ONLY!)	
Item #	Description
1207112	TOOL, NBC-NITTA-RENTAL-WELDER KIT-FULL
<b>Rental Kit Include: Finger Punch Press, T-wrench, Heated Weld Press, Pre-setter Mold, Silicone Sheet, Instruction Manuals, and Flash Drive with Instruction Video. Each Press Kit Is Shipped in a Hard Case.</b>	
NITTA BELT WELDER AND PUNCH HARD CASE WITH SPECIAL MOBRIK FOAM	
Item #	Description
1211171	CASE, PELICAN 1560-000-110-BLACK CASE, W/ SPECIAL MOBRIK-FOAM #BW1560 (HOLDS THE WELDER & PRESETTER)
1211172	CASE, PELICAN 1620-020-110-BLACK CASE, W/ SPECIAL MOBRIK-FOAM #BW1620 (HOLDS THE PUNCHER)
NITTA BELT	
Item #	Description
1205548	BELT, NBC-1.75"W-CFTG-BLU-U-WLD
<b>(WELD ONLY!)</b>	
NBC NITTA BELT COMPLETE WELDER KIT (PURCHASE ONLY)	
Item #	Description
1207241	TOOL, NBC-NITTA-PURCHASE-WELDER KIT-FULL
<b>Include: Heated Weld Press and Nitta NPS-2005-1/2 Manual, Finger Punch Press, T-wrench &amp; Nitta FP-200T Manual, &amp; Pre-setter Mold with 1 Silicone Sheet</b>	
WELDING PRESS	
Item #	Description
1204524	TOOL, NBC-NITTA BELT-PRESS-HEATING/COOLING 110V
1204526	TOOL, NBC-NITTA-SILICONE SHEET-USE WITH PRE-SETTER
<b>Include: Heated Weld Press &amp; Nitta NPS-2005-1/2 Manual</b>	
REPLACEMENT PARTS - FOR WELDING PRESS	
Item #	Description
1207117	TOOL, NBC-NITTA BELT-PRE-SETTER-W/SILICONE SHEET-1.75"W
FINGER PUNCH PRESS	
Item #	Description
1204525	TOOL, NBC-NITTA BELT-PUNCHER-FINGER PUNCHER
<b>Include: Finger Punch Press, T-wrench &amp; Nitta FP-200T Manual</b>	
REPLACEMENT PARTS - FOR FINGER PUNCH PRESS	
Item #	Description
1207004	TOOL, CPART-NITTA-BLADE (2)-CUTTERS FOR USE WITH FP-200T
1207118	TOOL, NBC-NITTA-T-WRENCH-USE WITH PUNCH PRESS
1207119	TOOL, NBC-NITTA-CUTTING BOARD-USE WITH PUNCH PRESS
1215576	SCREW, HEX HEAD NITTA-NO2-FP200-A003-19
1215577	TABLE,ALGND NITTA-NO2-FP200-P011-E-RA



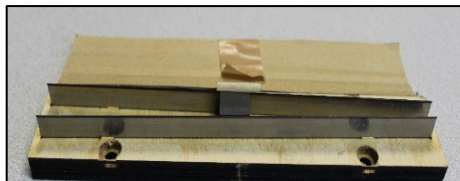
Part number 1204526: Pre-setter Mold & Silicone Sheet



Part number 1207117: Silicone Sheet



Part number 1207119: Cutting Board

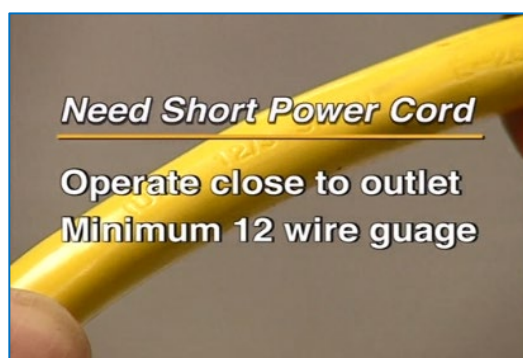


Part number 1207004: Cutting Blade

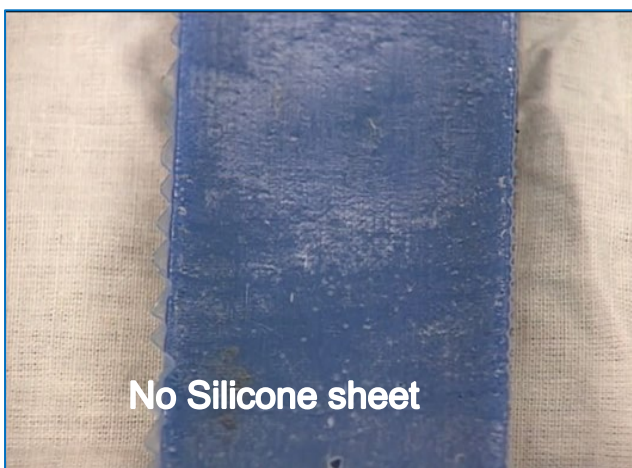
## 7 TROUBLESHOOTING – NITTA CORPORATION

### 7.1 AIR BUBBLES

Cold cook which may be caused by low or interrupted voltage to the welder press.



Forgetting to insert the Silicone sheet or sometimes known as the impression cloth.



Cooking the belt with the fingers too far apart.



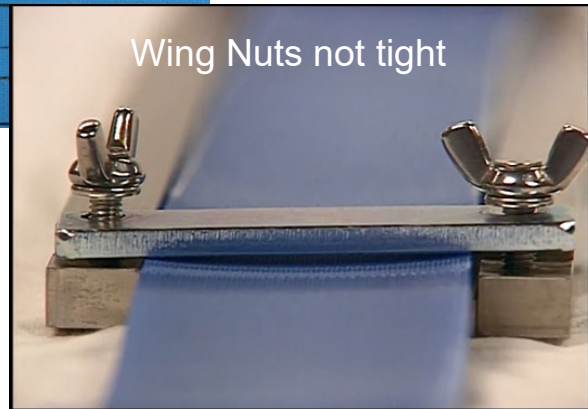
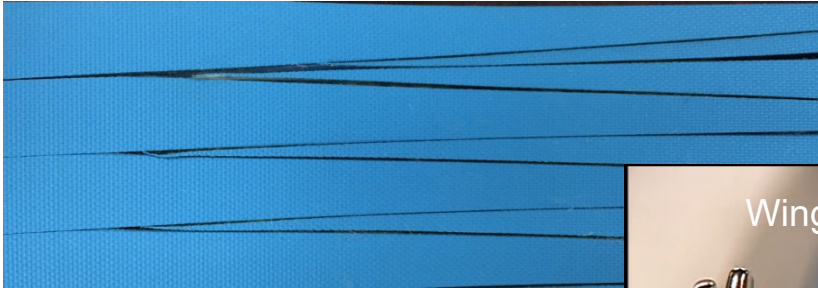
Cutting too much off the finger or not merging the fingers enough causing large gaps.



Belt fingers not trimmed properly, causing material to push under.



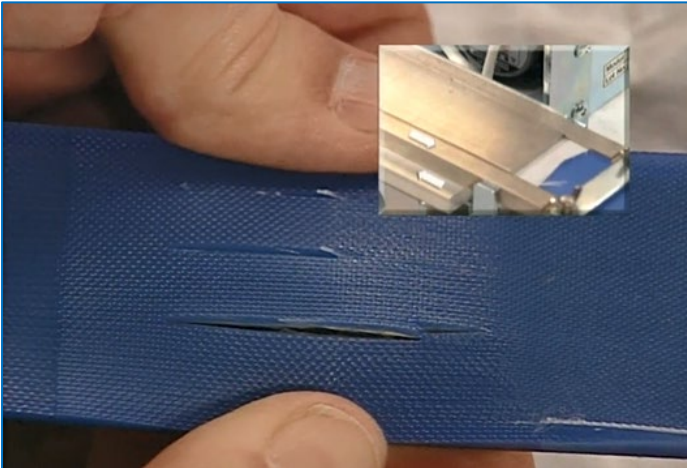
Mismatched or bending of the belt fingers caused by not securing the press-setter hold-downs.



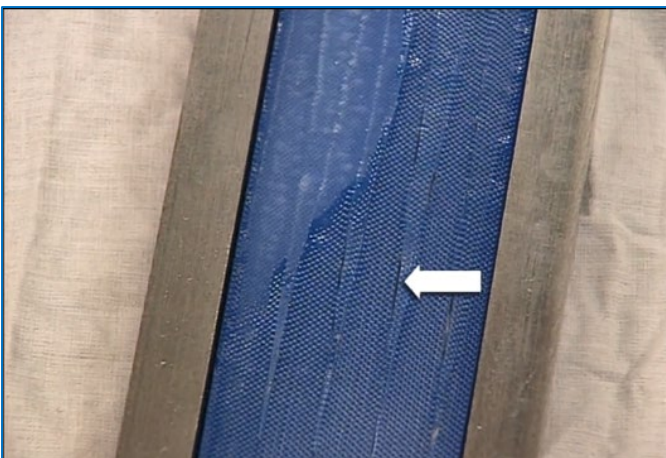
## 7.2 IMPROPER BELT WELDING

Placing the pre-setter mold centered in the heater press is important for the weld operation to keep the heat evenly dispersed over the entire spliced area. Failure to center the mold will cause an improper belt weld.

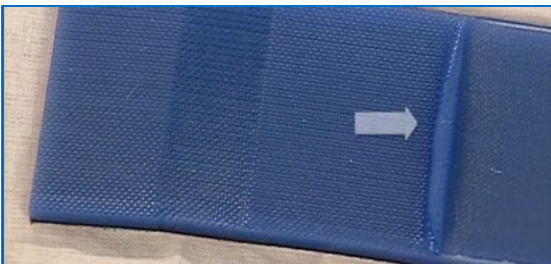
Pre-setter mold not centered in the weld press.



If the top pre-setter plate is not centered over the finger splice area this will cause one side of the splice not to fuse.



Buildup of urethane caused by the pre-setter mold not being centered in the weld press properly.



## WORKS CITED

- AISC. (2015). *American Institute of Steel Construction*. Retrieved 1 14, 2015, from <https://www.aisc.org/>
- ANSI. (2013-2014). *American National Standards Institute*. Retrieved 2014, from ANSI Standards Store: <http://www.ansi.org/>
- CEMA. (2014). *Conveyor Equipment Manufacturers Association*. Retrieved 2014, from Conveyor Equipment Manufacturers Association: <http://www.cemanet.org/>
- Nitta Corporation of America. (2018). *Nitta*. Retrieved from NITTA: <https://www.nitta.com/>
- OSHA. (2014). *Occupational Safety & Health Administration*. Retrieved 2014, from OSHA QuickTakes: <https://www.osha.gov/>

## GENERAL INFORMATION

**For additional manuals, videos, and other resources visit our website at:**

[www.fortna-conveyor.com](http://www.fortna-conveyor.com)

**FORTNA**

231.798.4547

Email : [usinfo@fortna-conveyor.com](mailto:usinfo@fortna-conveyor.com)

Web Site : [fortna-conveyor.com](http://fortna-conveyor.com)



**Manufacturing Location**

FORTNA Inc.

131 Griffin Way

Mt. Washington, KY 40047

As standards, specifications, and design change from time to time, please ask for confirmation of the information given in this publication.

©2026 FORTNA Inc. All rights reserved.