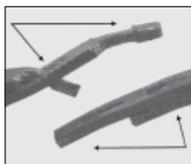


How to measure, assemble and install Twist Type Link V-Belts

I. HOW TO MEASURE

1. Pull belt tight around pulleys to check hand tight length, overlapping the last two tabs with two holes in matching links as shown at right.
2. Count the number of links and remove one link for every 24. This gives the correct installed belt length and will ensure optimum belt tension when running.
3. For multiple belt drives, ensure that each belt has the same number of links.



Important—Turn Belt Tab Side Out to Ensure Easy Disassembly and Assembly.

II. DISASSEMBLY



1. Hold belt upside down. Bend back as far as possible; hold with one hand. Twist one tab 90° parallel with slot.



2. Pull end of link over tab.



3. Rotate belt end with tab 90°.



4. Pull belt end through two links.

III. ASSEMBLY



1. Hold belt with tabs pointing outward.



2. Place end tab through two links at once.



3. Flex belt farther and insert second tab through end link by twisting tab with thumb.



4. Ensure tab returns to position across belt. Reverse belt so tabs run inside.

IV. INSTALLATION

1. Turn belt with tabs to the inside before installing.
2. Determine direction of drive rotation. Belt must travel with tabs trailing.
4. Fit belt in nearest groove of smaller pulley.
5. Roll belt onto larger pulley, turning the drive slowly. Belt may seem very tight; this is okay. **DO NOT JOG MOTOR.**
6. Check to see all tabs are still in their correct position and are not twisted out of alignment.
7. For multiple belt drives, work belt from groove to groove. On particularly wide drives, it may be easier to install half the belts from the inboard side and half from the outboard. Note: With drive ratios around 1:1, it may be necessary to add back one link to allow belts to be rolled on. This does not apply if using Installation Method V.



V. ALTERNATE INSTALLATION METHOD

1. Set motor to mid-position of adjustment range and mark base clearly.
2. Determine required belt length as in I.
3. Push motor forward to minimum center distance.
4. Install belts as in IV.
5. Pull motor back to previously marked mid-position.

VI. RETENSIONING

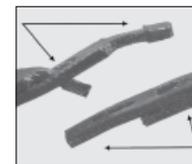
Like all V-belts, Twist Type Link V-Belts need to be tensioned properly to operate efficiently. Experience indicates that drive tension should be checked after running for 24 hours at full load. It may be necessary to retension the belt at that time to take up any initial belt stretch. Subsequently, belt tension should be checked periodically and adjusted when necessary.

LEGAL COMPLIANCE NOTICE:
This product contains a chemical [Bis (2-ethylhexyl)phthalate] known to the State of California to cause cancer and birth defects or other reproductive harm, and also categorized by REACH as a Substance of Very High Concern.

How to measure, assemble and install Twist Type Link V-Belts

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II. DISASSEMBLY



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2. Pull end of link over tab.



3. Rotate belt end with tab 90°.



4. Pull belt end through two links.

III. ASSEMBLY



1. Hold belt with tabs pointing outward.



2. Place end tab through two links at once.



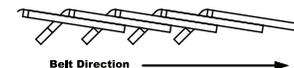
3. Flex belt farther and insert second tab through end link by twisting tab with thumb.



4. Ensure tab returns to position across belt. Reverse belt so tabs run inside.

IV. INSTALLATION

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2. Determine direction of drive rotation. Belt must travel with tabs trailing.
4. Fit belt in nearest groove of smaller pulley.
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V. ALTERNATE INSTALLATION METHOD

1. Set motor to mid-position of adjustment range and mark base clearly.
2. Determine required belt length as in I.
3. Push motor forward to minimum center distance.
4. Install belts as in IV.
5. Pull motor back to previously marked mid-position.

VI. RETENSIONING

Like all V-belts, Twist Type Link V-Belts need to be tensioned properly to operate efficiently. Experience indicates that drive tension should be checked after running for 24 hours at full load. It may be necessary to retension the belt at that time to take up any initial belt stretch. Subsequently, belt tension should be checked periodically and adjusted when necessary.

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