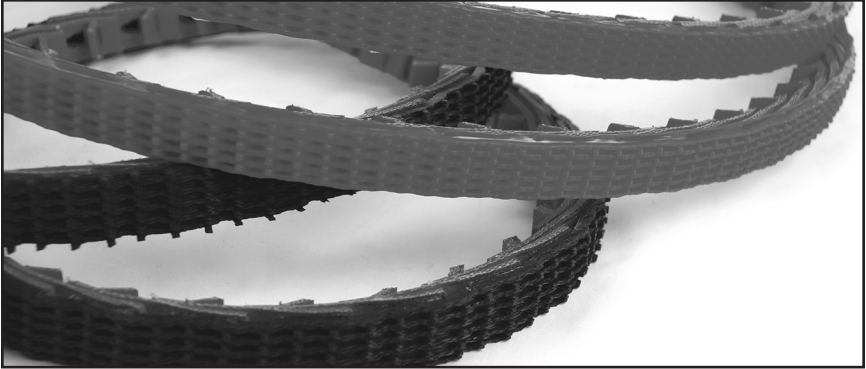


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## **Installation Instructions for PT MOVE SuperGrip Top PVC & PU**

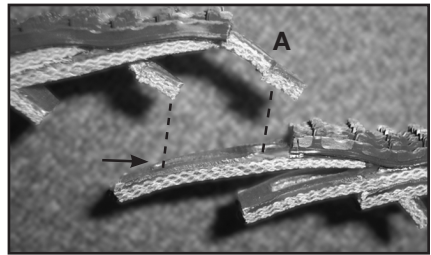
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### **How to Measure**

- 1** To determine the “hand-tight length,” route the belt along its intended path (Note: tabs ride in the groove of the pulley). Overlap the last two tabs of end (A) with two corresponding holes when pulled tight. Mark the hole corresponding to the second tab. Eliminate the extra links by starting the disassembly process (see 2 on next page) with the tab currently going through the marked hole (as shown in figure below). Remove approximately 1-2% of additional belt from the “hand tight length” to assure proper installation tension.



*Fig. 1*

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## Disassembly

- 2
- Using clippers or a utility knife, cut the PVC or PU layer of the belt. Do not cut into the base belt. See Fig. 2.
  - Twist the tab in front of the splice 90° parallel with the slot. Pull the end of the link over the tab. See Fig. 3.
  - Rotate the belt end with the tab and pull it through the two links.

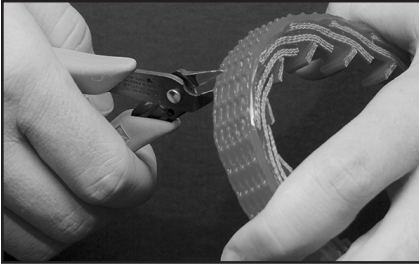


Fig. 2

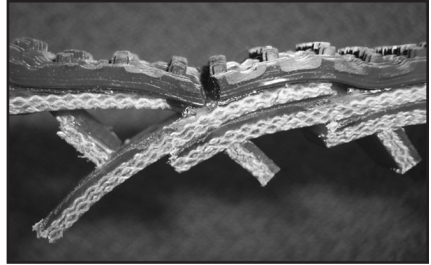


Fig. 3

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## Assembly

- 3
- Place the tab through two links at once. Flexing the link will enlarge the slot, making this easier. See Fig. 4.
  - Flex the belt further and insert the second tab through the end of the link. Twist 90° to secure. See Fig. 5.

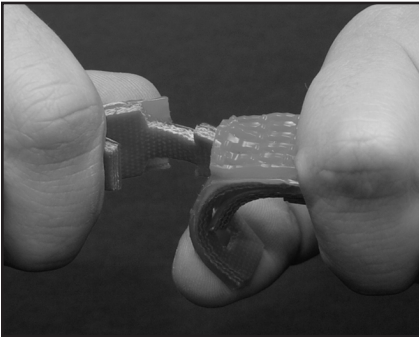


Fig. 4

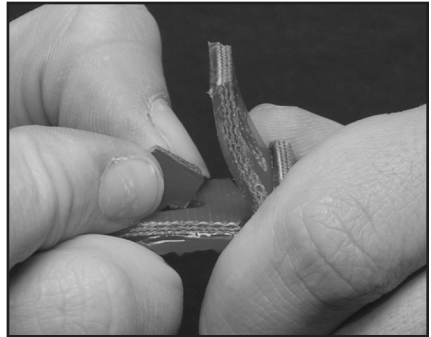


Fig. 5

## Splicing SuperGrip Top (optional)

- 4**
- Using a hot knife, the SuperGrip Top material can be fused together. Once the hot knife heats up, use it to melt the material adjacent to the splice and push it into the splice. See Fig. 6.
  - Next, use the hot knife to smooth the area. See Fig. 7.

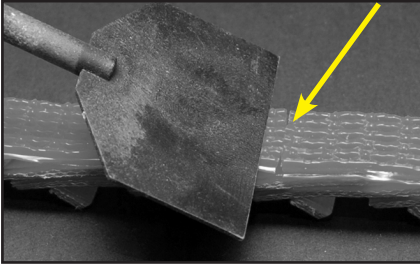


Fig. 6

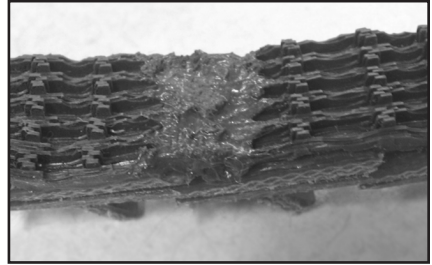


Fig. 7

## Installation

- 5**
- Make sure the tabs are facing the inside of the belt before installing.
  - Determine direction of the drive's rotation.
  - Align belt so that the tabs are trailing the direction the belt is running.
  - Set the take up mechanism to mid-position of adjustment range and mark base clearly.
  - Determine required belt length as in Step 1.
  - Adjust the take up mechanism to minimum center distance.
  - Install the belt. See Fig. 8.
  - Adjust the take up mechanism back to previously marked mid-position. See Fig. 9.
  - Check to see that all tabs are still correctly positioned and not twisted out of alignment.

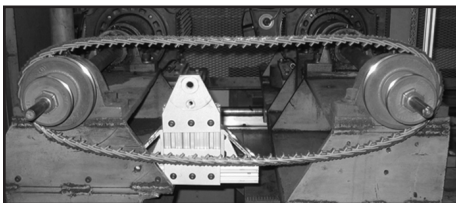
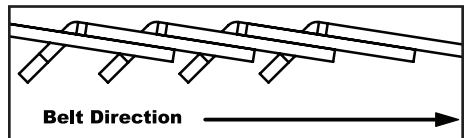


Fig. 8

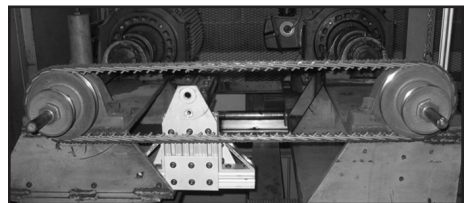
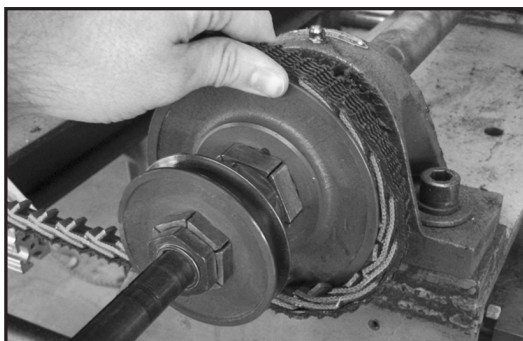


Fig. 9

## Alternate Installation Method

- 6**
- Turn the belt so that the tabs are on the inside of the belt before installing.
  - Determine direction of the drive's rotation.
  - Determine belt length as in Step 1.
  - Align belt so that the tabs are trailing the direction the belt is running.
  - Fit the belt in the groove of tail pulley and any take up pulleys.
  - Roll belt onto drive pulley, turning the drive slowly. If the belt is too tight to be rolled on add additional belt links as needed until the belt can be installed. See Fig. 10.
  - Check to see that all tabs are still correctly positioned and not twisted out of alignment.
  - Adjust take up as necessary.



*Fig. 10*

## Retensioning

- 7** PT MOVE Belting requires correct installation tension to operate efficiently. During the break-in period belt elongation of 2-3% can be expected. Belt tension should be checked periodically and adjusted when necessary by adjusting the take-up or removing belt links.

*US Patent 7,004,311 and 7,241,354*