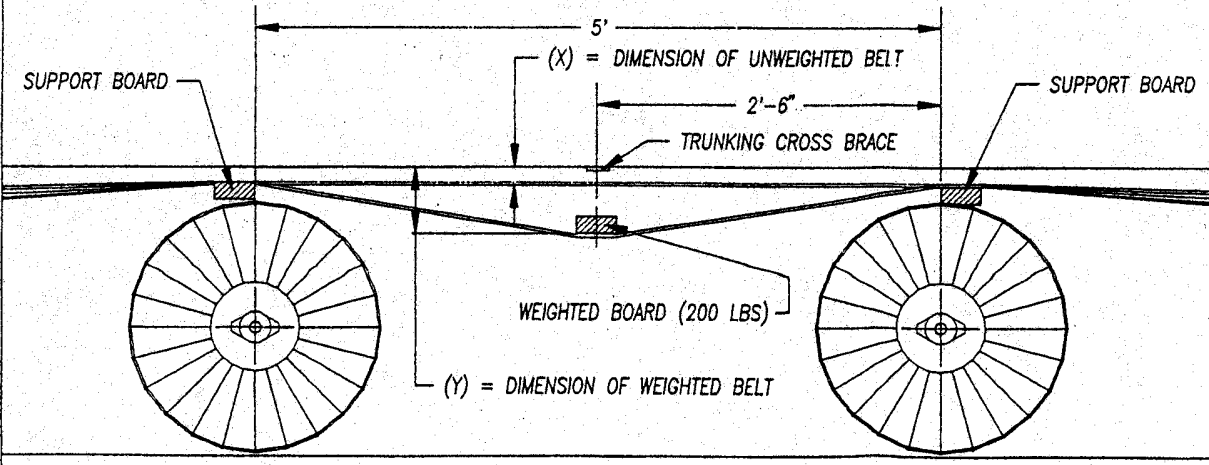


SERIAL #: \_\_\_\_\_  
 MODEL: \_\_\_\_\_  
 HORSEPOWER: \_\_\_\_\_  
 BELT SPEED: \_\_\_\_\_

CUTAWAY VIEW SHOWING BELT IN DEFLECTED POSITION FOR ILLUSTRATION PURPOSES ONLY

NOTE: AN UNDER TENSIONED BELT MAY CAUSE HEAD PULLEY SLIPPAGE AND INCREASED IDLER WEAR.  
 AN OVER TENSIONED BELT MAY CAUSE EXCESSIVE STRESS ON BEARINGS, SHAFTS, PULLEYS, BELTS & SPLICES.  
 USE THESE INSTRUCTIONS TO AVOID UNDER OR OVER TENSIONING.

SIDE VIEW - TEST AREA



BELT TENSION PROCEDURE  
 HI ROLLER ENCLOSED BELT CONVEYORS

**!! WARNING !! ALL LOCAL, STATE, AND FEDERAL "OSHA" SAFETY PROCEDURES MUST ALWAYS BE FOLLOWED.**

MATERIALS NEEDED: MODEL 26 & LARGER = 3 - 2X4 BOARDS JUST SHORTER THAN THE TRUSSING WIDTH. FOR MODELS 22 & SMALLER USE 1X4 BOARDS. 1 - SET OF 200 LBS. WEIGHTS, 1 - RULER/TAPE MEASURE NEEDED FOR ALL MODELS.

- REFER TO THE ILLUSTRATIONS SHOWN TO THE LEFT
1. THE BELT TENSION CAN BE MEASURED BETWEEN ANY TWO IDLERS BUT PREFERABLY AT LEAST 2 TO 3 IDLERS AWAY FROM THE HEAD AND TAIL SECTIONS.
  2. REMOVE THE COVERS FROM THE TEST AREA.
  3. PLACE ONE BOARD OVER EACH IDLER UNDER THE BELT WITH THE INSIDE EDGES CENTERED OVER THE IDLER SHAFTS.
  4. MEASURE THE DISTANCE BETWEEN THE NEAREST EDGES OF THE SUPPORT BOARDS. THIS SPAN SHOULD BE 5'-0" (60")
  5. MEASURE THE DISTANCE "X" FROM THE TOP OF THE TRUSSING TO THE UNWEIGHTED BELT.
  6. PLACE THE THIRD BOARD CENTERED BETWEEN THE SUPPORT BOARDS.
  7. PLACE 200 LBS. ON THE CENTER BOARD.
  8. MEASURE THE DISTANCE "Y" FROM THE TOP OF THE TRUSSING TO THE WEIGHTED BELT.
  9. COMPUTE BELT DEFLECTION = "Y" - "X"
  10. ADJUST BELT TENSION EQUALLY ON BOTH SIDES OF THE TAKE-UP UNTIL THE BELT DEFLECTION IS WITHIN THE GIVEN RANGE LISTED BELOW. THE MINIMUM AMOUNT OF BELT TENSION SHOULD PROVIDE GOOD OPERATION. HOWEVER, UNDER CERTAIN CONDITIONS, THE HEAD PULLEY MAY SLIP. IN THOSE INSTANCES, ADD TENSION UNTIL THE SLIPPAGE STOPS THEN MEASURE THE BELT DEFLECTION TO CONFIRM THAT IT IS STILL WITHIN THE SUGGESTED RANGE.

ALTERNATE METHOD FOR SHORT OR LIMITED ACCESS CONVEYORS:

1. LOCATE 2 IDLERS THAT ARE 60" APART. REMOVE COVER.
2. MEASURE THE DISTANCE "X" FROM THE TOP OF THE TRUSSING TO EITHER SIDE OF THE BELT.
3. CUT A BOARD THE SAME LENGTH AS THE CENTER HORIZONTAL TUBE OF THE IDLER. PLACE THIS BOARD ACROSS THE BELT IN THE CENTER OF THE SPAN & CENTER OF THE BELT. ADD 200 LBS. WEIGHT.
4. MEASURE THE DISTANCE "Y" FROM THE TOP OF THE TRUSSING TO THE SAME SIDE OF THE BELT AS PREVIOUSLY MEASURED. CONTINUE FROM #9 ABOVE.

DEFLECTION RANGE: \_\_\_\_\_ INCHES TO \_\_\_\_\_ INCHES  
 (LOWER TENSION) (HIGHER TENSION)