

## **Belt Tensioning Instructions**

HTB, standard, and metric timing belts should be installed to fit pulleys snugly, neither too tight nor too loose. The belt's positive grip eliminates the need for high initial tension. When the belt is installed with a snug but not overly tight fit, longer belt life, less bearing wear, and much quieter operation will result. Overly tight belts can cause early failure and should be avoided. With a high torque, a loose belt may jump teeth upon startup. If such occurs, the tension should be increased gradually until satisfactory operation is achieved.

V-belt and multi-rib tensioning adjustment can be made using a tension meter or other type of spring scale, using the following procedure. After seating the belts in the groove and adjusting center distance so as to take up slack in the belts, further increase the tension until only a slight bow on the slack side is apparent while the drive is operating under load. To tell when the level is right, measure the distance between the centers of the drives. For every inch in that span will work out to 1/64" in slack.

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