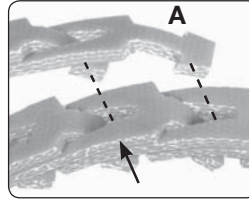


## English HOW TO MEASURE, ASSEMBLE & INSTALL

### How to Measure

To determine the "hand-tight length," route the belt along its intended path (Note: tabs ride in the groove of the sheave). Overlap the last two tabs of end (A) with two corresponding holes when pulled snug. Mark the hole corresponding to the second tab. Eliminate the extra links by starting the disassembly process (see Disassembly, 1. below) with the tab currently going through the marked hole (as shown in figure to the right). Count the number of links that remain and remove one link for every 24 of 3L, Z/10, A/4L, and B/5L sections, and one link for every 20 of C and D sections. This gives the correct installed belt length and will ensure proper belt tension while running. For multiple belt drives, ensure each belt has the same number of links.

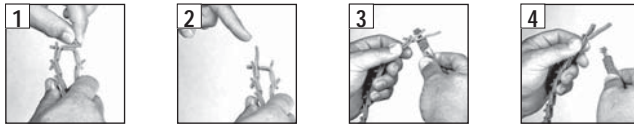


|   |   |
|---|---|
| For 3L, Z/10, A/4L, and B/5L sections:  | For C and D sections:   |
| $\frac{\text{Hand-tight length of belt (\# of links)}}{24} = \# \text{ of links to remove}$ | $\frac{\text{Hand-tight length of belt (\# of links)}}{20} = \# \text{ of links to remove}$ |
| For all sections, round number of links to be removed to the nearest whole number.          |   |

Note: Every tenth link is designated with an arrow (→) (3L, Z/10, A/4L and B/5L only).

### Disassembly

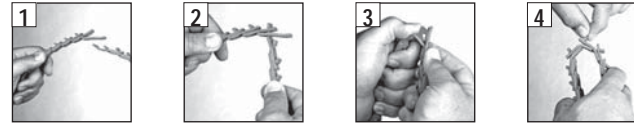
1. Hold belt as shown in figure. Bend back as far as possible; hold with one hand. Twist one tab 90° parallel with slot.
2. Pull end of link over tab.
3. Rotate belt end with tab 90° parallel with slot.
4. Pull end through two links.



**View the PowerTwist Standard installation video at:**  
[www.fennerdrives.com/videos](http://www.fennerdrives.com/videos)

### Assembly

1. Hold belt as shown in figure.
2. Place end tab through two links at once and twist tab into place.
3. Bend back and insert second tab through end link by twisting tab 90° with thumb.
4. Ensure tab returns to position across belt. Reverse belt so tabs run inside.



### Installation

1. Turn belt with tabs to the inside before installing.
2. Determine direction of drive rotation.
3. Belt must travel following the belt direction arrow (→) 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 ok; 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 the Alternative Installation Method.

### Alternative Installation Method

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

### Retensioning

Like all high performance V-belts, PowerTwist Standard V-Belts require the maintenance of correct drive tension to operate efficiently. Experience indicates that drive tension should be checked between 1/2 hour and 24 hours running at full load. A retension may be necessary depending on the application. Any initial belt stretch is then taken up. Subsequently, belt tension should be checked periodically and adjusted when necessary.