

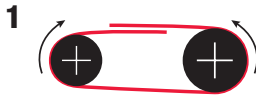
# POWER TWIST DRIVE

## INSTALLATION INSTRUCTIONS

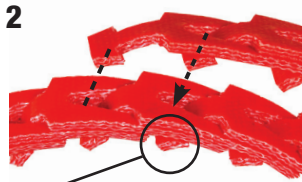
View the PT Drive install video at: [www.fennerdrives.com/videos](http://www.fennerdrives.com/videos)

### SIZING THE BELT

#### HAND-TIGHT LENGTH



Route the belt so it is "hand-tight" around the intended pulleys.



With the belt pulled snug, mark the tab that is straight down from the second overlapping tab (circled).



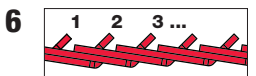
With one hand bend belt into an upside down "U". With the other hand twist the marked tab 90°.



Pull link end over tab.

Rotate end tab 90°. Pull belt end through two links to separate.

#### MAKE TO FINISHED LENGTH



Count remaining links or measure belt length tip to tip.

**Note:** For best results, count # of links, then check final tension with force deflection gauge after installation.



**IMPORTANT:** Using charts at right, find the range corresponding to the number found in Step 6. Remove additional # of links to achieve proper installation tension.

**Note:** For drives with multiple belts, make sure each belt has matching number of links.

### LINK REMOVAL GUIDELINES

#### 3L Section

Hand Tight # of Links	Belt Length (in)*	# of Links to Remove
18 - 35	12.6 - 23.8	1
36 - 55	23.9 - 36.7	2
56 - 79	36.8 - 52.0	3
80 - 101	52.1 - 66.1	4
102 - 127	66.2 - 82.7	5
128 - 150	82.8 - 97.5	6

#### A Section

Hand Tight # of Links	Belt Length (in)*	# of Links to Remove
25 - 34	20.2 - 27.3	1
35 - 58	27.4 - 45.2	2
59 - 82	45.3 - 63.1	3
83 - 105	63.2 - 80.3	4
106 - 129	80.4 - 98.2	5
130 - 153	98.3 - 116.1	6
154 - 176	116.2 - 133.3	7
177 - 200	133.4 - 151.2	8
201 - 224	151.3 - 169.1	9
225 - 247	169.2 - 186.3	10
248 - 271	186.4 - 204.2	11
272 - 295	204.3 - 222.1	12

#### B Section

Hand Tight # of Links	Belt Length (in)*	# of Links to Remove
29 - 34	29.6 - 34.9	1
35 - 58	35.0 - 58.0	2
59 - 81	58.1 - 80.2	3
82 - 105	80.3 - 103.3	4
106 - 128	103.4 - 125.4	5
129 - 152	125.5 - 148.6	6
153 - 175	148.7 - 170.7	7
176 - 199	170.8 - 193.8	8
200 - 223	193.9 - 217.0	9
224 - 246	217.1 - 239.1	10
247 - 270	239.2 - 262.3	11
271 - 293	262.4 - 284.4	12
294 - 317	284.5 - 307.1	13

#### C Section

Hand Tight # of Links	Belt Length (in)*	# of Links to Remove
48 - 67	40.2 - 55.5	3
68 - 86	55.6 - 70.4	4
87 - 105	70.5 - 85.3	5
106 - 125	85.4 - 101.0	6
126 - 144	101.1 - 115.9	7
145 - 164	116.0 - 131.5	8
165 - 183	131.6 - 146.4	9
184 - 202	146.5 - 161.3	10
203 - 222	161.4 - 177.0	11
223 - 241	177.1 - 191.9	12
242 - 260	192.0 - 206.8	13
261 - 280	206.9 - 222.5	14
281 - 299	222.6 - 237.4	15

\*Belt length is measured open-ended from belt tip to tip

### INSTALLATION

#### MAKE BELT ENDLESS



Holding belt with tabs to the outside push end tab through two links. Twist tab 90° into place.



With your thumb twist second tab 90°. Push belt end down over tab with your opposite hand.

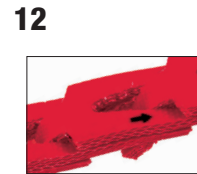


Ensure both tabs are fully turned and across the belt

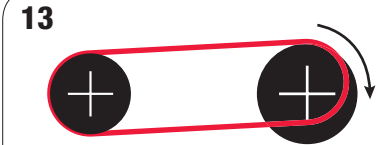


Rotate assembled belt so tabs are inside (facing down into the pulley groove).

#### INSTALL ON DRIVE



Determine direction of drive rotation. Belt must travel in the same direction as the direction arrow. Tabs will trail.



Fit belt in closest groove of the smaller pulley. Roll belt onto larger pulley by turning the drive slowly. The belt should feel tight. DO NOT JOG MOTOR. Once installed check to make sure all tabs are in position and the belt is not twisted.



Using a force deflection gauge, check Installation Tension and confirm it meets the requirement shown at right.

#### FORCE DEFLECTION GUIDELINES

Force Required to Deflect the Belt 1/64" per 1" Center Distance		
Belt Section	Installation Tension (lbs.)	Minimum Running Tension (lbs.)
3L	4 - 4.5	2.5
A	4 - 5	3
B	7 - 8	6
C	13 - 15	10

**Note:** If belt tension drops below Minimum Running Tension, remove links until belt is back to Installation Tension.

**Note:** If the installation tension with the recommended # of links makes it too difficult to roll the belt on the drive, links can be added to reduce the tension. In that case the belt may have to be re-tensioned by removing the extra links between ½ hour and 24 hours running at full load. Alternatively the take-up system on the drive can be utilized to install the belt at proper length and tension.

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