

# Synchronous Belt Installation Tips for Large Diameter Pulleys

## How to Install Synchronous Belts :

- › Lock out/tag out machine.
- › Adjust the drive to the shortest position possible.
- › Never force a belt onto a sprocket using a pry bar as this may damage the tensile cords, or yourself.
- › Before tensioning, make sure teeth are engaged in the sprocket teeth if possible. With large diameter sprockets the belt may not engage into all the teeth, see 5 or 5 rule below.
- › Make sure the belt profile is compatible with the sprocket profile.
- › Tension the belt using the blow 5 or 5 rule.

## 5 or 5 rule:

1. Install belt at the 3 o'clock position, work the belt into the teeth towards the 12 o'clock position, and finally 6 o'clock. Note: Large diameter pulleys may make this impossible.
2. Next install the belt on the small diameter pulley. Note: the belt **may not** engage the teeth at the 6 & 12 o'clock positions of the pulley. This is normal and the teeth will engage once the belt is properly tensioned.
3. Tension the belt to the installed tension per MaximizerPro (obtain from Continental Applications group). Note: While tensioning the belt, keeps hands/fingers away from the pulleys, as the belt engages into the pulley, it happens quickly and forcefully. This is normal, do not try to guide the belt on.
4. Run drive for 5 minutes or rotate by hand 5 belt revolutions.
5. Make final tension adjustment to proper installation tension value.
6. Recheck tension after 8 to 24 hours of operation, tension will be lower but should not be below the used belt value, obtained from MaximizerPro.

