

## EA TIMING BELT AND CONVEYOR BELT TENSION SETTING PROCEDURE

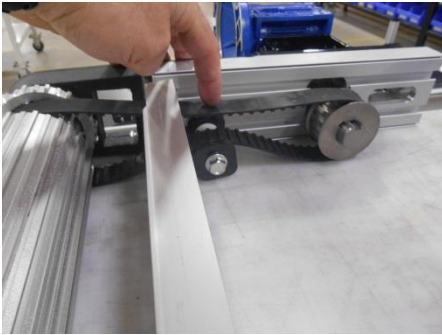


Fig. 1



Fig. 2



Fig. 3



Fig. 4

1. After installing new timing belt adjust tension with the take up bolts. Tension should be set to have  $\frac{1}{4}$ " deflection in the center of the non idler side. (Fig. 1)
2. After the tension is set, run the unit to insure the timing belt tracks correctly in both the drive pulley and the conveyor drive pulley. Tracking of this belt can be adjusted by use of the take up bolts in the same fashion as you would track the conveyor belt or sliding the drive pulley on the shaft. (Fig. 2)
3. Once the tension and tracking are set lock the jam nuts in the take ups. Measure between the machined surface of the take up and frame end. These dimensions should be  $\frac{5}{8}$ " to  $\frac{3}{4}$ " on both sides. **(DO NOT ADJUST THE TAKE UPS AFTER THE TIMING BELT IS SET)** (Fig. 3)
4. Finish re-installation of the slide trays, belt, rails, etc.
5. The conveyor belt tensioning will be set/adjusted at the tail end of the conveyor. (Fig. 4)



Fig. 5



Fig. 6

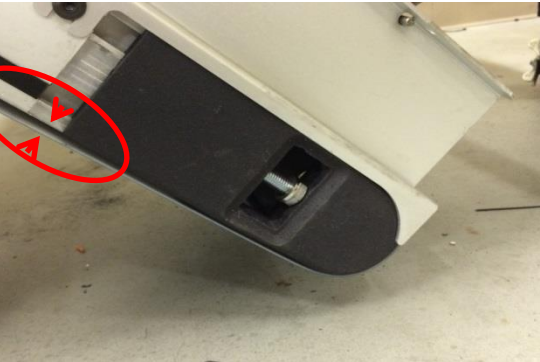


Fig. 7

6. The EA conveyor may be ran in a self adjusting conveyor belt tension mode for some models.

7. Loosen the previously tightened tail take ups until tension is applied to the conveyor belt. Continue to rotate the bolt out until it is set midway in the take up window. **(THIS HAS THE BELT IN A SELF TENSIONING MODE)** (Fig. 5)

8. If the conveyor belt slips when the machine is turned on or when product is applied it will be necessary to override the auto adjust and set the machine in a manual mode.

9. Manual mode is set by continuing to adjust the take up bolts out until they contact the window side and then continue adjusting out to apply an outward pressure to the take up. (Fig. 6)

10. The belt should be tightened to achieve belt movement when product is applied. **USE CAUTION NOT TO OVERTIGHTEN THE CONVEYOR BELT. FAILURE TO DO SO WILL CAUSE PREMATURE BEARING, SHAFT, AND BELT FAILURE.**

11. The belt will sag or appear loose on the bottom side. This is normal. (Fig. 7)