

"ONE SHOT" TENSIONING

Fenner **PB** belts are Precision Built to ensure inherent length stability and matching during storage and on the drive. Over many years, the principle of "one-shot" tensioning has been verified by successful drives the world over.

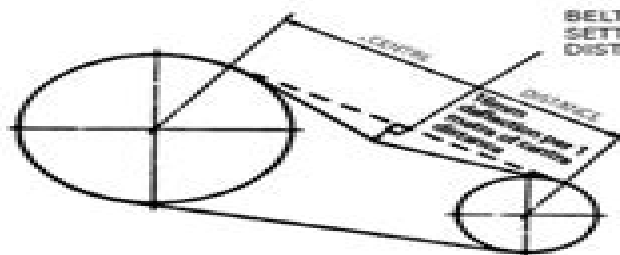
- Install the belts to be a snug fit around the pulleys.
- Spin the pulleys 3-4 revolutions to bed belts into the pulley grooves. (Note: if done manually, beware of finger entrapment between belts and pulleys)
- Tension the belts to the 1.25x setting forces from the table.
- Run the drive under load for 15-20 minutes.
- Stop the drive, check tension & reset to the basic value (standard V and wedge belts) if necessary. CRE Plus & Quattro Plus belts should be reset to the 1.25x value.

With a drive that is properly designed for the application there should be no need for further attention during the life of the belts.

For short centre distance drives where the deflection of the belt is too small to measure accurately it is recommended that both deflection and setting force be doubled.

Method of belt tensioning using Fenner Belt Tension Indicator

- Calculate the deflection in mm on a basis of 16mm per metre of centre distance. Centre distance (metres) x 16 = deflection (mm).
- Set the lower marker ring at the deflection distance required in mm on the lower scale.
- Set the upper marker ring against the bottom edge of the top tube.
- Place the belt tension indicator on top of the belt at the centre of span, and apply a force at right angles to the belt, deflecting it to the point where the lower marker ring is level with the top of an adjacent belt.
- Read off the setting force value indicated by the top edge of the upper marker ring.
- Compare this force to the kgf value shown in the table.
- If a Fenner Belt Tension Indicator is not available, a spring balance and rule will suffice.
- With banded belts (pages 68 and 69) use a bar across the band width to ensure even distribution of the force and **DIVIDE** the force measured by the number of belts in the band for comparison with the values in the table above. Alternatively, for the same deflection, use a setting force from the table above **MULTIPLIED** by the number of belts in the band.

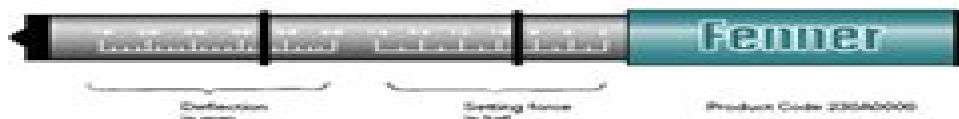


BELT TENSION INDICATOR APPLIES SETTING FORCE AT MID-CENTRE DISTANCE

The setting forces below are designed to cover a wide range of drives. A precise setting force for individual applications can be calculated. Please consult your local Authorised Distributor or use the 'Fenner Select' design software at www.fptgroup.com

SETTING FORCES

Belt Section	Setting force to deflect belt 16 mm per metre of span			
	Small pulley diameter (mm)	Basic setting forces Newtons (N) kilograms (kgf)	1.25 x setting forces Newtons (N) kilograms (kgf)	
SPZ	56 to 71	16	20	2.0
	75 to 90	18	22	2.2
	95 to 125	20	25	2.5
XSPZ & GXPZ	over 125	22	28	2.8
	80 to 100	22	28	2.8
SPA	105 to 140	20	25	2.5
	150 to 200	26	33	3.3
XSPA & GSPA	over 200	40	50	5.0
	110 to 180	40	50	5.0
SPB	120 to 224	50	62	6.2
	235 to 305	62	77	7.7
XSPB & GXPB	over 305	66	82	8.2
	224 to 250	70	87	8.7
SPC & GCPB	over 250	92	115	11.5
	over 375	135	168	16.8
EV	225 & above	190	237	23.7
A & HA (banded)	56 to 71	5 to 7.5	6.2 to 9.4	
	75 to 90	10 to 15	12.5 to 18.7	
	125 to 200	20 to 30	25 to 37.5	
B	200 to 400	40 to 60	50 to 75	
C	250 to 600	70 to 105	87 to 130.7	

FENNER BELT TENSION INDICATOR**NOTES:**

For single belt drives a straight edge should be placed across the two pulleys to act as a datum for measuring the amount of deflection.

If the measured force falls within the values given, the drive should be satisfactory. A measured force below the basic value indicates under-tensioning.

A new drive should be tensioned to the 1.25x value to allow for the normal drop in tension during the running-in period.

After the drive has been running for 15-20 minutes, under load the tension should be checked and re-adjusted, if necessary.

TROUBLE SHOOTING**Small radial cracks on belt side and base**

Generally caused by slippage due to insufficient belt tension, but excessive

heat and/or chemical fumes can also cause the same problem.

Belt swelling or softening

Caused by excessive contamination by oil, certain cutting fluids, water or rubber solvent.

Whip during running

Often caused by incorrect tensioning, particularly on long centre drives. If a slightly higher (or lower) tension does not cure the problem there may be a critical vibration frequency in the system which requires re-design or use of banded belts. Consult your local Authorised Distributor Technical Services.

Pulleys

Pulley groove wear can cause rapid belt failure. Check grooves for wear with a Fenner groove gauge.

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