

**"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.

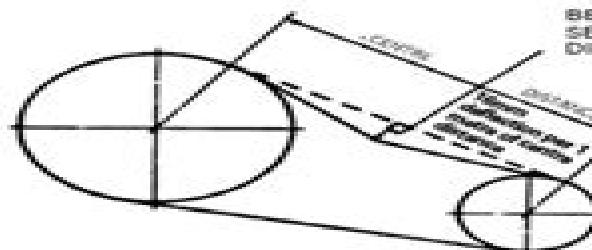
- Install the belts to be a snug fit around the pulleys.
- Spin the pulleys 3-4 revolutions to bed belts into the pulley grooves. (Note: If done manually, beware of finger entrapment between belts and pulleys).
- Tension the belts to the 1.25x setting forces from the table.
- Run the drive under load 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 tensioning 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 BeltTension 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.

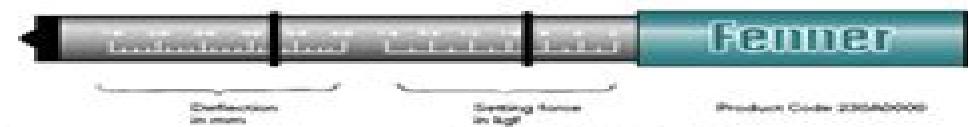


BELT TENSION INDICATOR APPLIES SETTING FORCE AT MID CENTRE DISTANCE

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](http://www.fptgroup.com)

**SETTING FORCES**

Belt Description	Setting force for deflected belt 16 mm per metre of span		
	Small pulley diameter (mm)	Basic setting forces, Newtons (kg) * Kilograms (kgf)	1.25 x setting forces Newtons (kg) Kilograms (kgf)
BPF	500 to 750	50	62.5
	750 to 900	50	62.5
XPF & XQPF	900 to 1250	50	62.5
	over 1250	50	62.5
XPA	500 to 1000	50	62.5
	1000 to 2000	50	62.5
XPA & XQPA	over 2000	40	50.0
	1125 to 1800	40	50.0
XPS	1750 to 2250	60	75.0
	2250 to 3000	60	75.0
XQPS & XQPS	over 3000	60	75.0
	2250 to 2500	70	87.5
BPC	2500 to 3000	80	100.0
	over 3000	100	125.0
BPF & XQPC	over 3000	100	125.0
	1125 to 1800	100	125.0
X	500 to 1000	10.0 to 12.5	12.5 to 15.6
	1000 to 1400	10 to 15	12.5 to 18.7
A (SIL/HAL Standard)	1400 to 2000	20 to 30	30 to 45.7
	2000 to 4000	40 to 60	60 to 90.7
B	2000 to 4000	30 to 50	45 to 75.0
	3000 to 6000	50 to 70	75 to 105.0

**FENNER BELT TENSION INDICATOR**

Deflection  
in mm

Setting force  
in kgf

Product Code 230000000

**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.

**TRROUBLE 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.

**Whirl 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.

# V Belt Tension Guide

**Trade Trade**

## V Belt Tension Guide:

**Field Manuals** United States. War Department,1978-07    *Reciprocating Compressors*: Heinz P. Bloch,John J. Hoefner,1996-10-08 Reciprocating compressors and their applications Design and materials of reciprocating compressor components Operation and maintenance of reciprocating compressors Overhaul and repair of reciprocating compressors Troubleshooting compressor problems Preventive maintenance of reciprocating compressors Safety in operation and maintenance Appendix Reciprocating compressor calculations Index    *Porsche 356 Owners Workshop Manual 1957-1965* Trade Trade,2014-08-08 This do it yourself Workshop Manual has been specially written for the owner who wishes to maintain his vehicle in first class condition and to carry out the bulk of his own servicing and repairs Considerable savings on garage charges can be made and one can drive in safety and confidence knowing the work has been done properly Comprehensive step by step instructions and illustrations are given on most dismantling overhauling and assembling operations Certain assemblies require the use of expensive special tools the purchase of which would be unjustified In these cases information is included but the reader is recommended to hand the unit to the agent for attention Throughout the Manual hints and tips are included which will be found invaluable and there is an easy to follow fault diagnosis at the end of each chapter Whilst every care has been taken to ensure correctness of information it is obviously not possible to guarantee complete freedom from errors or omissions or to accept liability arising from such errors or omissions Instructions may refer to the righthand or lefthand sides of the vehicle or the components These are the same as the righthand or lefthand of an observer standing behind the vehicle and looking forward    Soldier's Manual United States. Department of the Army,1980

**Fundamentals of Automotive Maintenance and Light Repair** Kirk VanGelder,2019-01-21 Designed to prepare new technicians for ASE G1 Certification Fundamentals of Automotive Maintenance and Light Repair Second Edition covers the foundational theory and skills necessary to prepare entry level technicians to maintain and repair today's light duty vehicles

Chilton Book Company Repair & Tune-up Guide ,1987    **Chilton's Guide to Air Conditioning Repair and Service** Chilton Book Company,1985 Provides maintenance troubleshooting and repair information for automotive air conditioning and related parts for domestic and import cars built between 1982-85    A Catalog of Performance Objectives, Criterion-referenced Measures and Performance Guides for Custom Garmentmaker ,1979    **Official Gazette of the United States Patent and Trademark Office** ,1986    **Chilton's Repair and Tune-Up Guide, Capri, 1970-1977**

Chilton Book Company. Automotive Editorial Department,1978    **Maintenance Engineering Handbook** Keith Mobley,Lindley Higgins,Darrin Wikoff,2008-04-20 Stay Up to Date on the Latest Issues in Maintenance Engineering The most comprehensive resource of its kind Maintenance Engineering Handbook has long been a staple for engineers managers and technicians seeking current advice on everything from tools and techniques to planning and scheduling This brand new edition brings you up to date on the most pertinent aspects of identifying and repairing faulty equipment such dated subjects

as sanitation and housekeeping have been removed Maintenance Engineering Handbook has been advising plant and facility professionals for more than 50 years Whether you're new to the profession or a practiced veteran this updated edition is an absolute necessity New and updated sections include Belt Drives provided by the Gates Corporation Repair and Maintenance Cost Estimation Ventilation Fans and Exhaust Systems 10 New Chapters on Maintenance of Mechanical Equipment Inside Organization and Management of the Maintenance Function Maintenance Practices Engineering and Analysis Tools Maintenance of Facilities and Equipment Maintenance of Mechanical Equipment Maintenance of Electrical Equipment Instrumentation and Reliability Tools Lubrication Maintenance Welding Chemical Corrosion Control and Cleaning

Compressed Air Operations Manual Brian Elliott,2006-05-09 Compressed air systems are the third most important utility to industry and are commonly the most misunderstood Written to appeal to operators mechanics and junior engineers this manual is designed to provide a solid understanding of common compression systems and operations techniques Using this book the users learn tips and techniques for creating a baseline of system performance determining the impact of different compressors and compressor control types for the job at hand and learning basic approaches to general maintenance

**Catalogue** Montgomery Ward,1941 *Patents for Inventions. Abridgments of Specifications* Great Britain. Patent Office,1903 *Standard Handbook of Plant Engineering* Robert C. Rosaler,James O'Neill Rice,1983 **Agricultural Power and Machinery** Clinton O. Jacobs,William R. Harrell,1983 An orientation to agricultural power and machinery The small internal combustion engine Power and power transmission components The agricultural tractor Soil preparation and crop production equipment Harvesting and handling agricultural products Agricultural power and machinery management

Guide to Energy Conservation for Grocery Stores United States. Office of Energy Conservation and Environment,1977 *Volvo 240 Service Manual 1983 Through 1993* Bentley Publishers,1993 Vehicle Maintenance *Chilton's Guide to Air Conditioning Repair and Service* ,1990 **Power Transmission Design** ,1973

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