

The key to long, efficient trouble-free belt operation is proper tension. If belts are too loose, the result is slippage, rapid belt and sheave wear and excessive "down time."

Conversely, too much tension imposes excessive strain on belts, bearing and adjacent drive components, resulting in premature wear of one or all of the drive parts.

The proper tension is the lowest tension at which the belt(s) won't slip or "squeal" under peak load.

Tensioning Procedures

1. Measure the span length (L) in Fig. 1.
2. At the centre of the span (L) apply a force perpendicular to the belt measuring the need to deflect the belt $1/64"$ per inch of span length (L).
3. Compare the force required in step 2 to the recommended range(s) in the appropriate table(s). Tighten or loosen the belt tension to bring the tension into the recommended range.
4. For V-belts, run the drive for five (5) or ten (10) minutes to seat the belt and then recheck the tension.
5. For timing belts, the belt should fit snugly - neither too tight nor too loose. The "tooth grip" eliminates the need for high initial tension.

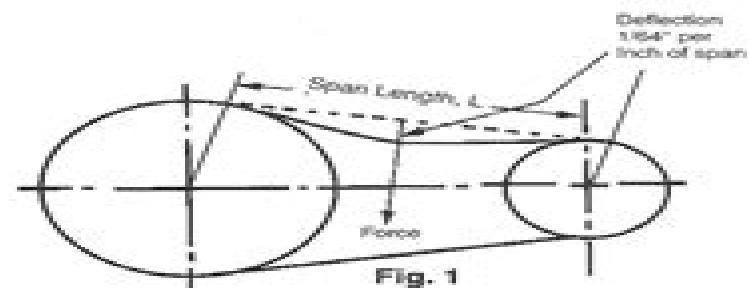


Fig. 1

V-BELT DRIVES

V Belt Cross Section	Small Sheave Diameter Range (Inches)	Recommended Deflection Force (Lbs./")			
		Initial Installation		Retensioning	
		Maximum	Minimum	Maximum	Minimum
A	-3.0	3.6	3.1	2.4	
	3.1-4.0	4.2	3.6	2.8	
	4.1-5.0	5.2	4.6	3.5	
	5.1-	6.1	5.3	4.1	
B	-4.6	7.3	6.4	4.9	
	4.7 - 5.6	8.7	7.5	5.8	
	5.7 - 7.0	9.3	8.1	6.2	
	7.1 -	10.0	8.8	6.8	
C	-7.0	12.6	10.7	8.2	
	7.1 - 9.0	15.0	13.0	10.0	
	9.1 - 12.0	18.0	16.3	12.5	
	12.1	19.5	16.9	13.0	
D	12.0 - 13.0	25.5*	22.1	17.0	
	13.1 - 15.5	30.0*	26.0*	20.0	
	15.6 - 22.0	32.0*	28.0*	21.5	
E	18.0 - 22.0	45.0*	39.0*	30.0*	
	22.1	52.5*	45.5*	35.0*	
3L	1.5 - 2.0	1.4	1.1	0.8	
	2.1 - 2.7	1.9	1.4	1.1	
	2.8 - 4.0	2.5	2.0	1.5	
4L	2.0 - 2.5	2.1	1.6	1.2	
	2.6 - 3.5	2.4	1.8	1.4	
	3.6 - 5.0	3.1	2.3	1.8	
5L	3.0 - 3.5	3.2	2.5	1.9	
	3.6 - 4.5	4.1	3.2	2.4	
	4.6 - 6.0	5.1	3.9	3.0	

V Belt Cross Section	Small Sheave Diameter Range (Inches)	Recommended Deflection Force (Lbs./")			
		Initial Installation		Retensioning	
		Maximum	Minimum	Maximum	Minimum
3V	2.65 - 3.35	4.6	4.0	3.1	
	3.65 - 4.50	5.5	4.8	3.7	
	4.75 - 6.0	6.4	5.6	4.3	
	6.5 - 10.6	7.3	6.4	4.9	
5V	7.1 - 10.3	16.5	14.3	11.0	
	10.9 - 11.8	19.5	16.9	13.0	
	12.5 - 16.0	21.0	18.2	14.0	
8V	12.5 - 16.0	39.0*	33.8*	26.0*	
	17.0 - 20.0	45.0*	39.0*	30.0*	
	21.2 - 24.4	51.0*	44.2*	34.0*	
3VX	2.2 - 2.5	4.8	4.2	3.2	
	2.65 - 4.75	5.7	4.9	3.8	
	5.0 - 6.5	7.2	6.2	4.8	
	6.9 -	8.7	7.5	5.8	
5VX	- 5.5	15.0	13.0	10.0	
	5.9 - 8.0	19.0	16.9	13.0	
	8.5 - 10.9	21.0	18.2	14.0	
	11.8 -	22.0	19.5	15.0	
AX	- 3.0	5.1	4.4	3.4	
	3.1 - 4.0	5.5	4.8	3.7	
	4.1 - 5.0	6.0	5.2	4.0	
	5.1 -	6.7	5.9	4.5	
BX	- 4.6	10.0	8.7	6.7	
	4.7 - 5.6	11.0	9.5	7.3	
	5.7 - 7.0	11.5	9.9	7.6	
	7.1 -	12.0	10.1	7.8	
CX	- 7.0	18.0	15.6	12.0	
	7.1 - 9.0	19.5	16.9	13.0	
	9.1 - 12.0	20.0	17.6	13.5	
	12.1	21.0	18.2	14.0	

V Belt Tension Guide

Heinz P. Bloch, John J. Hoefner

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