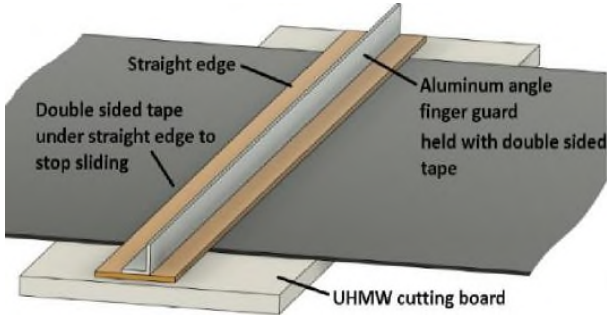




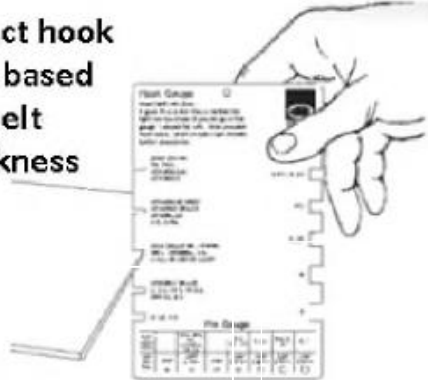
QUESTIONS? Please contact [mh@beltpower.com](mailto:mh@beltpower.com)



Corner prep before lacing for edge protection and pin housing.

Double sided tape to stop slip during cut

Select hook size based on belt thickness



Recommended Pin	Bias	Belt thickness				
		1/16"	3/32"	1/8"	5/32"	3/16"
		.063"	.093"	.125"	.156"	.188"
		upto 1.6 mm	upto 2.4 mm	upto 3.2 mm	upto 4.0 mm	upto 4.8 mm
DSS065-C	No	UX-1 SP (01184 / UX1SPS12)				
DLO65-C	Yes	1 SP (1SPHT12 / O2113)				
DSS065-C	No	1 SP (1SPHT12 / O2113)				
DLO65-C	Yes	Option to use #1 or the thicker wire of #2 for this group			UX-1 (01179 / UX1S12)	
DSS065-C	No				1 (02242 / #1HT12)	
DSS065-C	No				1 (02242 / #1HT12)	
DSS093-C	No				U2 SP (18851 / U2SPS12)	
DLO93-C	Yes				2SP (02173 / 2SPHT)	
DSS093-C	No				2SP (02173 / 2SPHT)	
DLO93-C	Yes				U2 (18400 / U2S12)	
DSS093-C	No				2 (02161 / 2HT)	
DSS093-C	No				2 (02161 / 2HT)	
User has Unibar preference (No Bias joints allowed)		Carded lace part numbers are for High tensile steel				
User has carded lace preference ( Pin changes for bias)		Unibar lace part numbers 430 Stainless (High tensile) steel				
User has carded lace preference (no bias lacing required)		Part numbers are for 12" long, other lengths on request.				

When cutting belt on a bias, only use cable pins (NCS or DL)

Connecting Pin Types	Code	Color	Wear	Speed	Composition	Bias
Nylosteel	NY	Blue	Good	< 120 ft/min	Nylon & music wire	No
Nylon-Covered SS Cable	NCS	Brown	Good	< 250 ft/min	Nylon & 300SS cable	Yes
Nylostainless	NYS	Brown	Good	< 250 ft/min	Nylon & 300SS spring wire	No
Duralink™	DL	White	Excellent	> 250 ft/min	Wear-resistant nylon, SS cable	Yes
DuraStainless™	DSS	White	Excellent	> 250 ft/min	Wear resistant nylon, SS wire	No



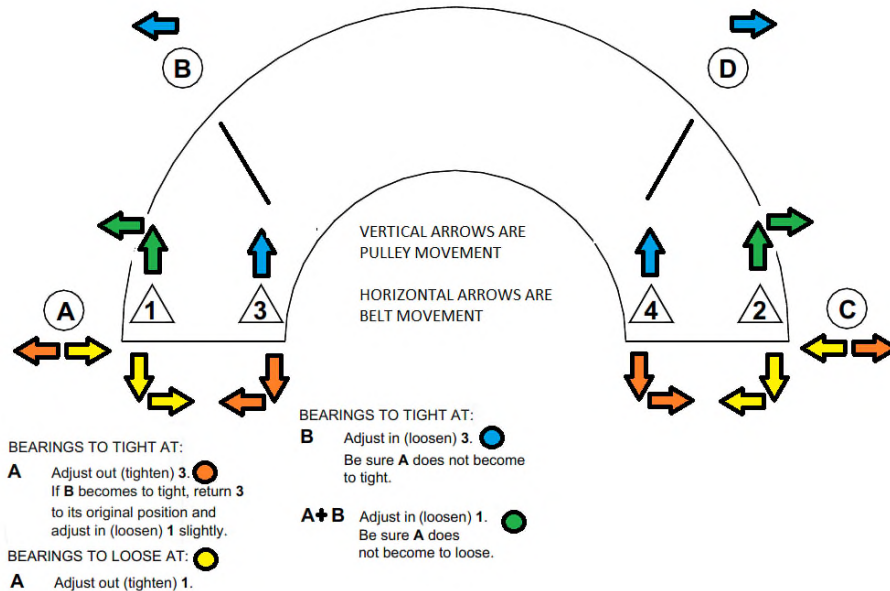
Taper on lacer wheels protects pin area of lace.

Adjust both upper and lower screws on head.

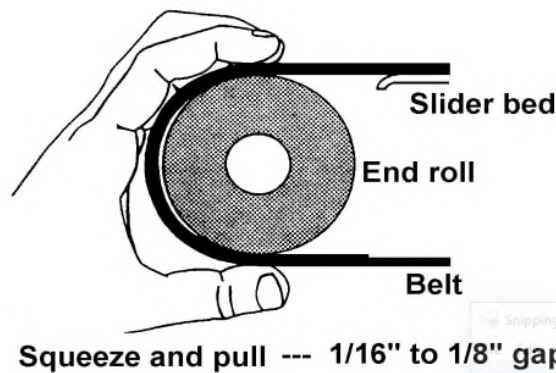
Wipe down with dry cloth, no lubricant.



**TRANSNORM CURVE BELT TENSION DIAGRAM.** Tension belt until belt slip does not occur under load.



**PORTEC & FLOWTURN CHAIN CURVE – Belt not under tension.** Remove almost all slack from belt until gap shown below is present.



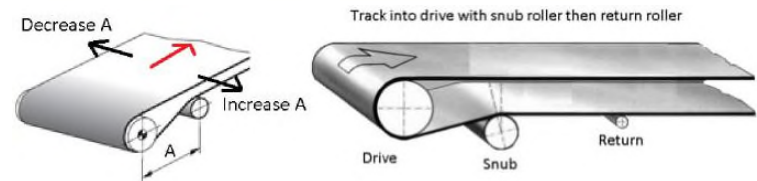
**BELT TENSION** – For all conveyors except merge, v-guided and powerturn.

1. Insert lace pin
2. Using straight edge, mark belt with two lines 100" apart
3. Tension belt with take-up until measurement is 100 1/2"
4. Run conveyor 2 full revolutions to equalize tension.
5. Measure distance between lines and tension belt again to 100 1/2"
6. Run conveyor and check lines are 100 7/16" – 100 1/2"

Length	Zero tension distance	At tension distance
Long belt	100"	100 1/2"
Short belt	50"	50 1/4"

100" / 50"  
Center line

IF USING A SHARPIE OR THICK PEN, MEASURE FROM ONE EDGE OF LINE FOR MORE ACCURATE MEASUREMENT. E.G. INSIDE OF BOTH LINES.



**CHAIN TENSION** - Adjust the chain tension by moving both end roll assemblies in equal amounts, using the adjustment nuts, until the chain deflection is 1/32 – 1/16"

Typical drive sprocket arrangement

