This data sheet interacts with
SBD Catalogue

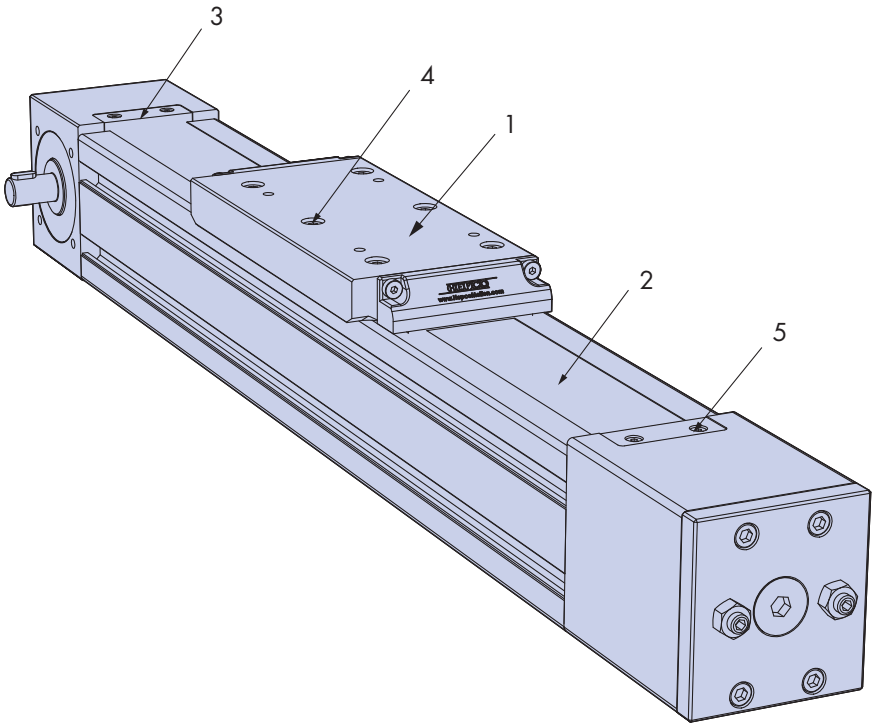
HepcoMotion®

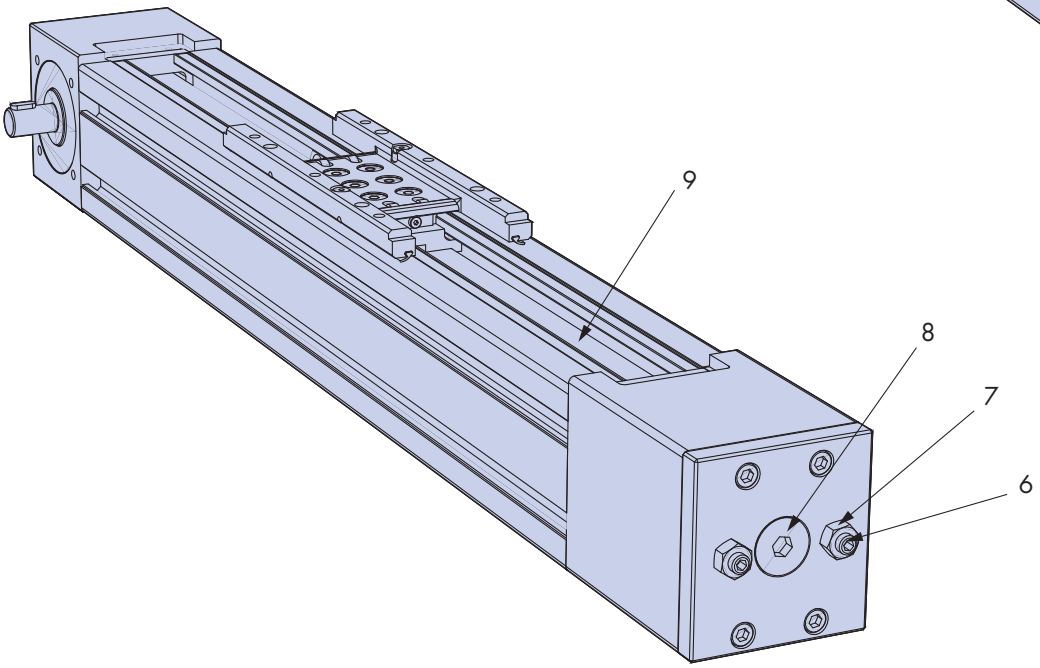
No. 6 SBD Belt Tensioning Procedure

It is important to have a suitable belt tension for the SBD unit. If tension is too low, the belt may jump out of mesh, or could suffer premature wear. If tension is too high, friction and noise will increase, and belt and bearing wear will be accelerated.

It is normal to remove the upper carriage plate (1) and the metal sealing band (2) before adjusting the belt tension, as this allows the drive belt (9) to be seen and its tension felt. This can be achieved by removing screws (4) and (5).

Item	Description
1	Upper carriage plate
2	Metal sealing band
3	Band retaining plate
4	Cap head screw
5	Cap head screw
6	Locking screw
7	Locking nut
8	Belt tensioning screw
9	Drive belt

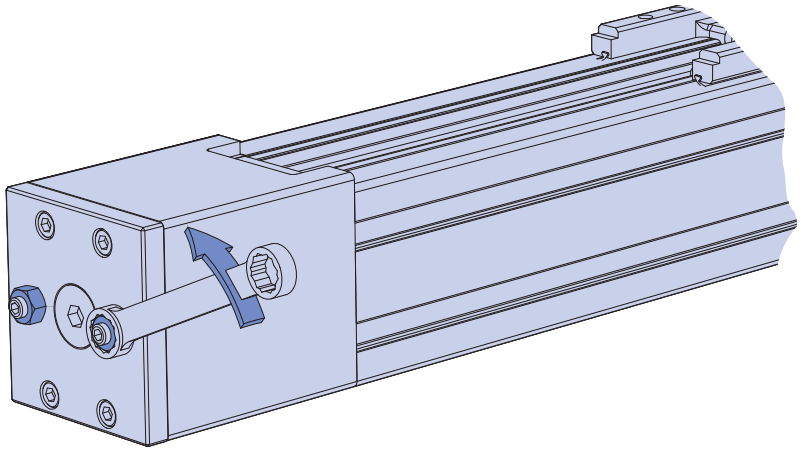




SBD Belt Tensioning Procedure

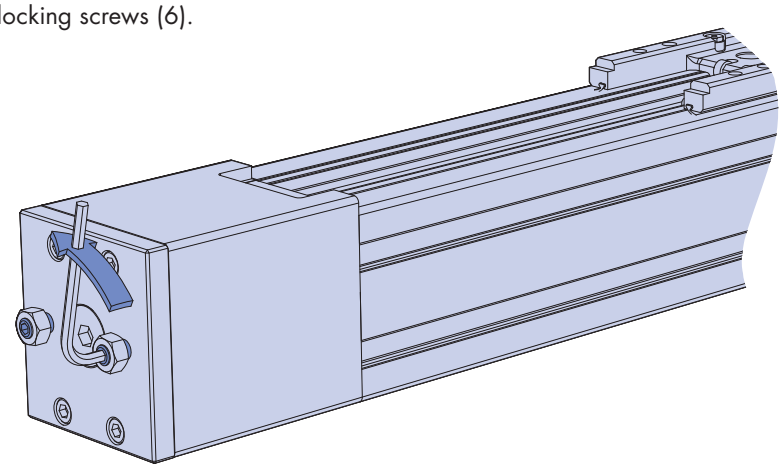
Stage 1

Undo the two locking nuts (7).



Stage 2

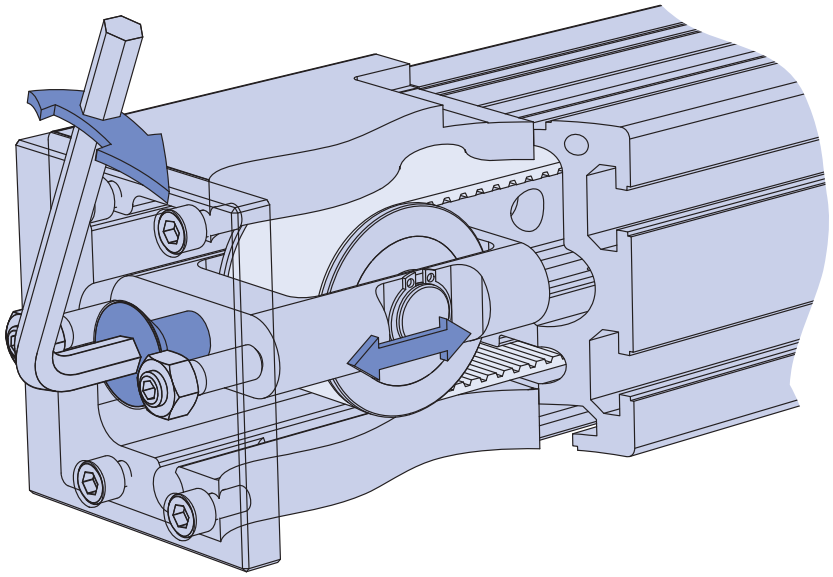
Loosen and back off the two locking screws (6).



Stage 3

Using a hexagon key, turn the belt tensioning screw (8) to adjust the tension in the belt. Turning the screw in a clockwise direction will cause the idle pulley assembly to slide inside the end box and increase belt tension. Turning the belt tensioning screw in an anti-clockwise direction will cause the idle pulley assembly to slide in the opposite direction and reduce belt tension.

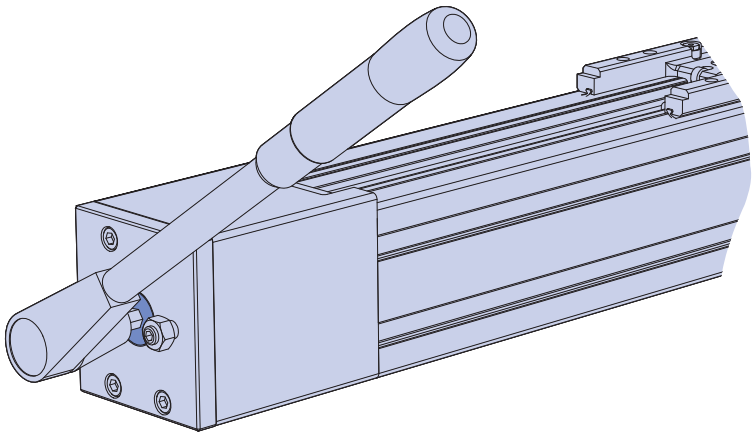
If tensioning the belt ensure that the locking screws (6) are still loose, and have not come into contact with the idle pulley assembly.



SBD Belt Tensioning Procedure

Stage 4

Using a suitable torque wrench and hexagon adaptor, apply the recommended torque for the unit size and length to the belt tensioning screw (8) this will apply the correct amount of tension to the belt. Recommended torque settings are given in the table below. Run the carriage the full length of the beam, check the torque setting again and adjust if necessary.

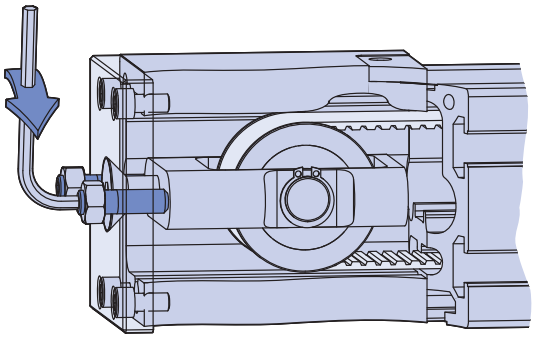


	Recommended Setting Torque					Alternative Setting Torque*				
	Belt Tensioning Screw (8)				Locking Screw (6)	Belt Tensioning Screw (8)				Locking Screw (6)
	Unit length (m)					Unit length (m				
Unit	**up to 2m**	**2-3m**	**3-6m**	**>6m**		**up to 2m**	**2-3m**	**3-6m**	**>6m**	
SBD 20-80	8Nm	10Nm	12Nm	Contact Hepco	8Nm	15Nm	20Nm	20Nm	Contact Hepco	10Nm
SBD 30-100	30Nm	35Nm	35Nm		12Nm	40Nm	45Nm	45Nm		14Nm

*Alternative torque setting figures should be used for more demanding applications. Applications can vary greatly, please discuss details with Hepco to determine which figures should be used.

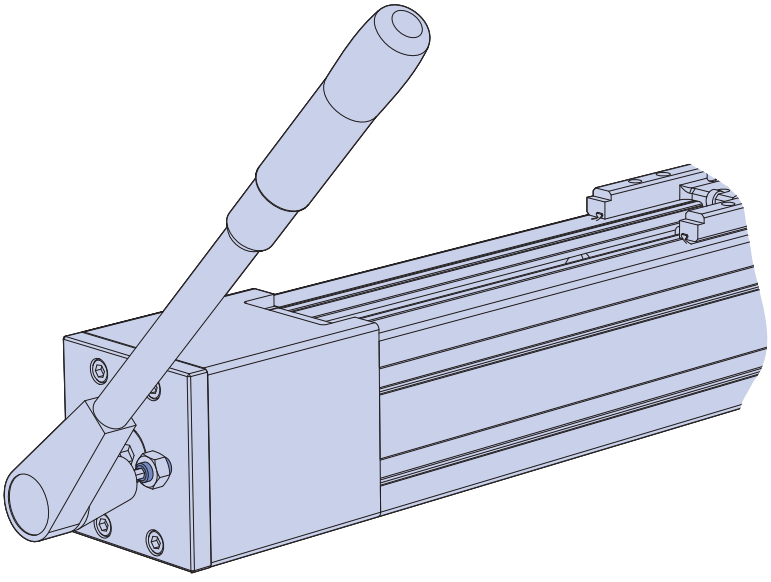
Stage 5

Using a suitable sized hexagon key, tighten the two locking screw (6) so that they just come in contact with the idle pulley assembly, alternate the adjustment between the two screws until tight. This ensures that the idle pulley assembly sits square and minimises the chances of belt tracking.



Stage 6

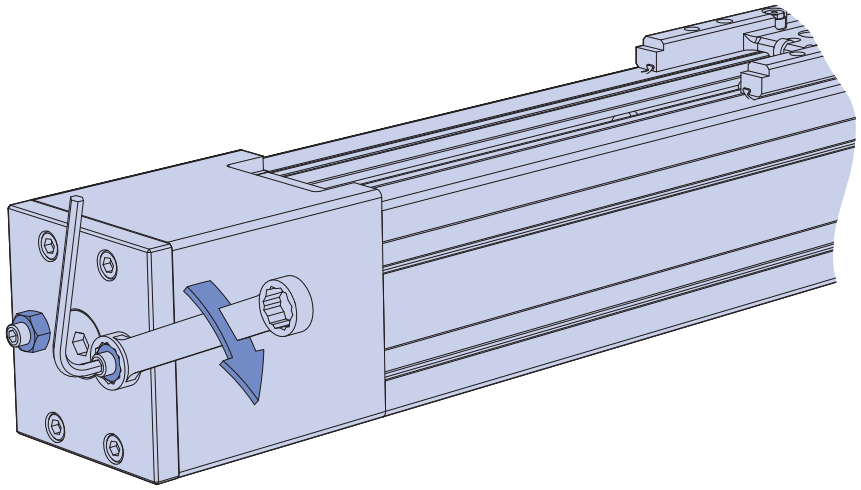
Using a suitable sized torque wrench and hexagon adaptor, apply the recommended torque to the two locking screws (6). This will ensure that the belt tensioning screw (8) can not come loose. Recommended torque settings are given in the table above.



SBD Belt Tensioning Procedure

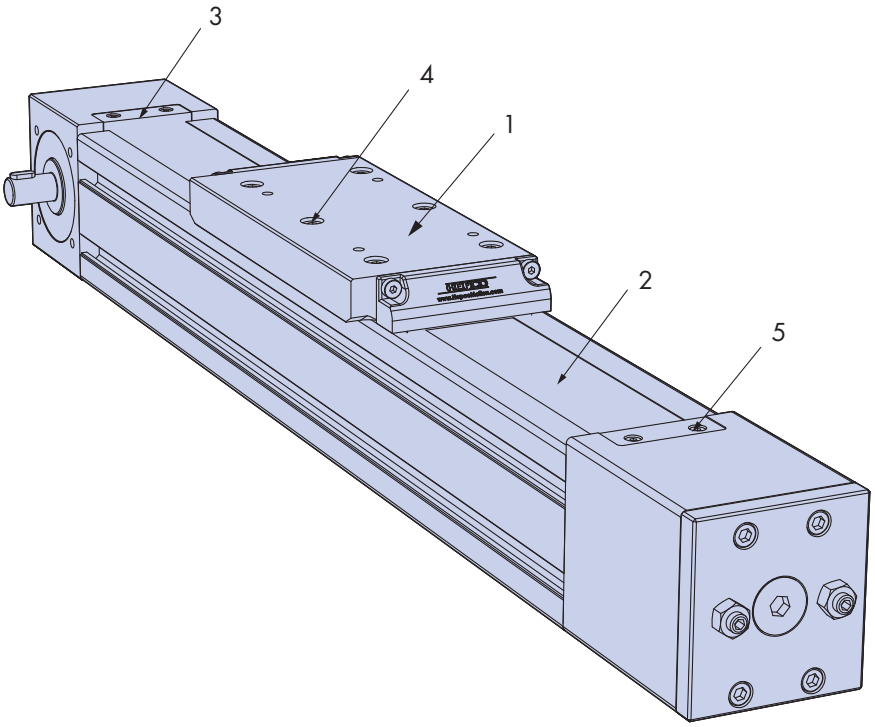
Stage 7

Whilst holding the locking screw (6) in place, tighten the two locking nuts (7). This will ensure that the locking screw cannot come loose.



Stage 8

Finally fit the metal sealing band (2) and re assemble the upper carriage plate (1).



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