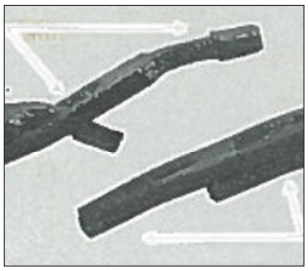
installing your **Power Twist V-belt**

I. HOW TO MEASURE



Pull belt tight around sheaves to check hand-tight length, overlapping the last two tabs with two holes on matching links as shown. Count the number of links and remove one link for every 24 of O/3L. A/4L and B/5L sections, or one link for every 20 of C and Dsections. This gives the correct installed belt length and will ensure optimum belt tension when running. Note: Every tenth link is designated with an arrow (➙). For multiple belt drives, ensure that each belt has the same number of links.

Important-turn belt tab side out to ensure easy assembly and disassembly

II. DISASSEMBLY

1. Hold belt upside down. Bend back as far as possible: hold with one hand. Twist one tab 90° parallel with slot. Pull end of link over tab

2. Rotate belt end with tab 90°.

3. Pull belt end through two links.

III ASSEMBLY

1. Hold belt with tabs pointing outward. Place end tab through two links at once and twist belt 90°.

2. Flex belt farther, twist tab 90° and insert tab through end link with thumb.

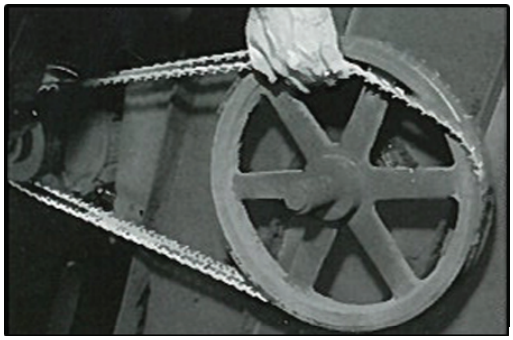
3. Twist tab 90° to ensure position across belt. Reverse belt so tabs run inside.

IV. INSTALLATION

1. Turn belt with tabs to the inside before installing.
2. Determine direction of drive rotation.
3. Align belt directional arrow (➙) with drive rotation.
4. Fit belt in nearest groove of smaller sheave.
5. Roll belt onto larger sheave, turning the drive slowly. Belt may seem very tight; this Is okay.
DO NOT JOG MOTOR.
6. Check to see all tabs are still in their correct position and are not twisted out of alignment.
7. For multiple belt drives, work belt from groove to groove. On particularly wide drives, it may be easier to install half the belts from the inboard side and half from the outboard.
Note: With drive ratios around 1:1, it may be necessary to add back one link to allow beltsto be rolled on. This does not apply if using Installation Method V.

V. ALTERNATE INSTALLATION METHOD

1. Set motor to mid-position of adjustment range and mark base clearly.
2. Determine required belt length as in I.
3. Push motor forward to minimum center distance.
4. Install belts as in IV.
5. Pull motor back to previously marked mid·position.



VI. RETENSIONING

Like all high performance V-belts, PowerTwist Plus V·Belts require the maintenance of correct drive tension to operate efficiently. Experience indicates that drive tension should be checked after 24 hours running at full load. A retension may be necessary depending on the severity of the drive. Any initial belt stretch is then taken up. Subsequently, belt tension should be checked periodically and adjusted when necessary. ***Important-Turn belt tab side out to ensure easy assembly and disassembly.***

CONTRACTOR SAW PERFORMANCE PACKAGE
IN-LINE INDUSTRIES 661 South Main Street Webster, MA 01570 (508) 949-2968

Performance Package Benefits

Contractor Saw Perfonnance Packages not only reduce vibration in your saw significantly, but also increase the saw's overall performance.

Pulley Size and Blade Speed

In some cases, the size(s) of the pulleys that we have provided may be different from the ones that came on your saw. Through years of experience (and feedback from our customers) we have found that the most efficent (and popular) blade speed is between 3800 RPM amd 4140 RPM. The pulleys in this Performance Package will fall in that RPM range for your saw based on a saw motor with 3450 RPM. Larger pulley installs on the motor and smaller pulley installs on the saw blade arbor.

DISCONNECT POWER berfore starting the procedure.

Replacing Pulleys: On most saws, (Except the Delta Contractors saws manufactured after 1988) replacing the pulleys require loosening a set screw, and sliding the pulleys off the shaft. The arbor pulley on the newer Delta requires a special procedure, which is described later.

To get clearance to easily change the arbor pulley. tilt the blade arbor to approximately 45 degrees.
On some saws, it is possible that the original pulley may be rusted in place on the shaft, or burrs may make it difficult to remove the pulley. After loosening the screw, if the pulley will not slide off the shaft, use a penetrating spray lubricant on the shaft. Try to slide the pulley back and forth on the shaft to remove it. DO NOT pound on the pulley shaft to remove it. You may damage the shaft or bearings. Use a small gear puller to remove stuck pulleys.

When the pulleys are removed, clean the shafts using a spray lubricant and a "Scotch Brite" type pad. Wipe the shafts with a clean rag. Re-apply spray lubricant to shafts and pulley bores. Align the pulley keyway with the key in the shaft. Slide the pulleys **onto the shafts**, and lightly tighten the set screws. If your pulley shaft keys are burred or bent replace them with new ones. (Keys not supplied with this package)

Removing the Delta Contractor Arbor Pulley

Cut a piece of 3/4" pine about 2 1/2" by 12" and drill a 5/8" hole on the centerline of the board about 3" from one end. Remove the saw blade. Dampen the area around the hole in the board with water (to make it sticky) and slide the hole onto the arbor shaft of the saw. the long end ofthe board should stick out the throat opening of the saw. Install the the blade washer and nut onto the arbor, and tighten the nut as if you were installing a dado set. Rotate the board so that it rests against the front (operator side) of the opening. Go to the rear of the saw, and spray the threads of the pulley nut with spray lubricant. Hang a 15/16" box end wrench on the arbor pulley nut at about 6:00 postion (hanging downward) and make sure the board is against the front of the throat opening. Give the wrench a quick "jerk" to break the pulley nut loose. Thread the nut off the shaft by hand.

Installing the Delta Contractor Arbor Pulley

Install the arbor pulley by placing the special key (provided with the Performance Package) into the arbor shaft. Locate the keyway in the new arbor pulley over the key, and slide the pulley onto the shaft. Install and tighten the pulley nut, and tighten the set screw in bottom of the pulley groove.

Assemble the Power-Twist Belt in accordance with the attached instructions, and match it to the length of the old belt. Install the belt on the pulleys, making sure you have the belt rotating in the direction shown by the arrows on the outside of the Power-Twist Belt. Align the pulleys by eye, using the belt as a reference, and tighten the set set screws in the arbor and motor pulleys.