



Installation Instructions for Traxx-Rite Belting

1. Traxx-Rite belts must always be run in a straight line. These belts are not designed to take a horizontal turn of any degree.
2. Make sure that head and tail pulleys or shafts are parallel to each other and perpendicular to the direction of belt travel. Failure to align will result in belt damage.
3. Any roller must be flat faced. Crowned pulleys will damage the belt
4. **Make certain, before installing belt, that all spirals are seated and not turned. Some shifting of spirals may have occurred in shipping or storage.**
5. Make sure that the belt path is free from obstructions.
6. Check to be certain that any support and return rollers are turning freely.
7. When connecting the belt, make sure the edges line up.
8. The direction of travel is clearly tagged on every Wiremation belt. This direction must be adhered to for proper sprocket engagement.
9. When connecting the belt, a right-hand spiral (clockwise) and a left-hand spiral (counterclockwise) must be joined together and then joined with a crimped connector rod. The rod may then be welded to the spiral.
10. If two spirals of the same hand are joined together, the belt will not engage the sprocket and will be damaged.
11. Sprockets must be properly aligned on the shaft. All Traxx-Rite sprockets are keyed in-line and the shaft must be keyed to ensure accurate alignment.
12. It is helpful to use a piece of the belt as a guide to locate and align sprockets.
13. The sprocket tooth should drive on the crimped connecting rod.
14. It is recommended that sprockets should be positioned no more than 3" apart with filler rolls between.
15. Although the sprocket can engage the belt in either spiral, for consistency, it is recommended that the sprocket tooth engage the belt in a left-hand spiral.
16. It is often helpful to lock down (with set screws) only the center sprocket and allow the other sprockets to float. This will make installation easier and will also allow for slight changes in belt width over time or exposure to heat.
17. Traxx-Rite belts should be run with the lowest tension necessary to engage the sprockets. Over-tensioning will stretch the belt and elongate the belt pitch which will lead to improper sprocket engagement.
18. **Traxx-Rite belts require a catenary sag** after the drive to provide even drive tension. Catenary sag is an unsupported length of belt for absorbing belt length variation due to thermal expansion, load changes, and wear. The weight of the unsupported belt produces the tension necessary to keep the belt wrapped around the sprockets. The length of the sag should be 20" to 24". The sag depth should range from 2" to 4" (a max. arc of 30 degrees). Improper catenary sag length will behave like a spring. The spring action of the sag will have a negative effect. Belt surging, belt cupping and broken edge welds will occur if this rule is not followed. A proper catenary sag will greatly extend the life of the belt, sprockets, shaft, and shaft bearings.
19. As the Traxx-Rite belt breaks in and wears, there will be some belt elongation. A section of belt may need to be removed if the catenary sag depth exceeds 4" or has an arc greater than 30 degrees.

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