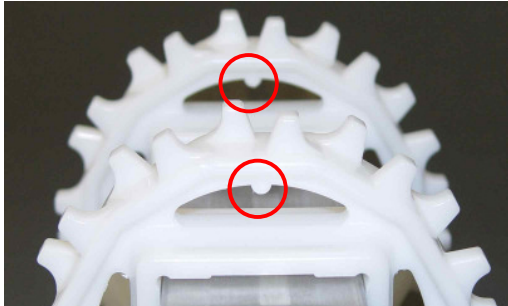


HabasitLINK[®]

Installation instructions for belt types: M2520, M2527, M2531, M2533

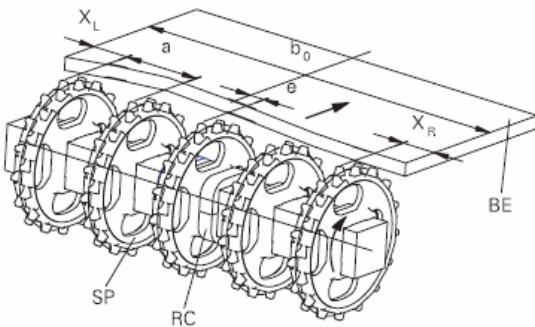
Please find full installation guide on www.habasitlink.com



Sprocket alignment on the shafts:

Corresponding teeth axial aligned, check by alignment mark.

If the bore is square and the number of teeth can be divided by 4, there may be no mark.



Sprockets Positioning:

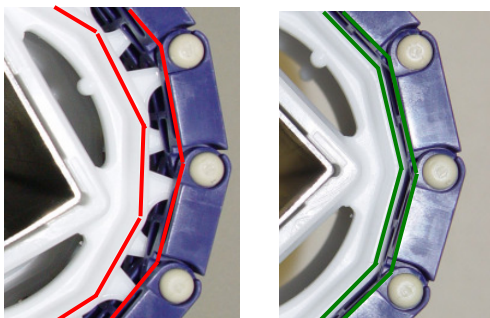
Place sprockets between min. and max. spacing (a).

Respect edge distance X_L and X_R .

Offset (e) given by shaft design.

Fix only the sprocket in the middle with small clearance.

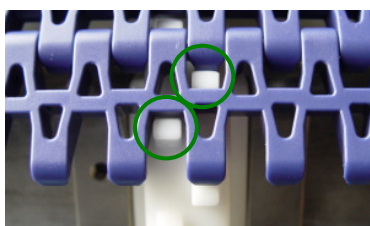
Belt type	Sprocket spacing a		Edge distance (minimal)	
	minimal mm inch	maximal mm inch	X_L mm inch	X_R mm inch
M2500	50 2	100 4	25 1	25 1



Check proper sprocket engagement:

The sprocket teeth must properly engage in the belt.

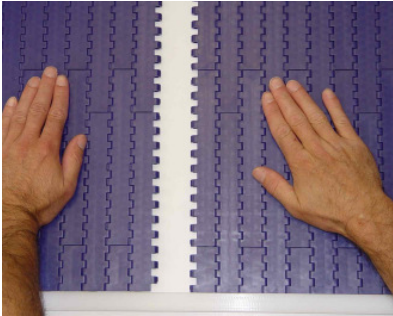
Belt reverse side is in contact with the sprocket rim.



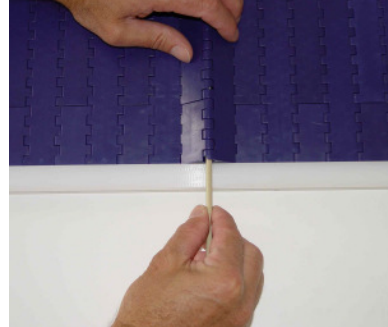
With Flush Grid belts check proper sprocket engagement from belt surface.

Rod installation (snap fit rod retention):

Rod Ø5mm (0.2") with round shaped head must have a beveled end. If the belt is delivered in sections, join the sections with alternating rod head orientation e.g. on one section all rod heads on the left hand side and the following section all rod heads on the right hand side.

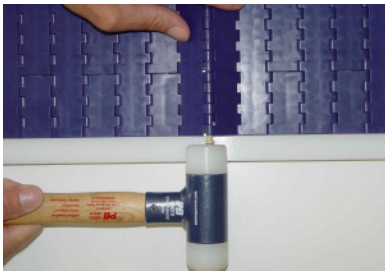


Pull belt sections together



Insert rod

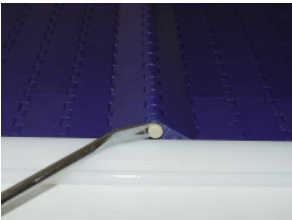
For easy rod installation, rod end must be beveled.



Hammer in rod head

Check if rod head is fully embedded.

Rod removal:



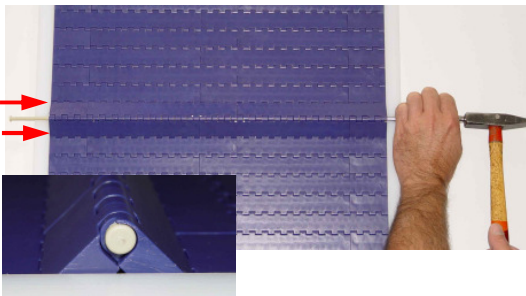
Leverage rod head out



Rod removal by Habasit rod removal tool (rod puller) or side cutter.

Do not cut off rod head.

The belt must not be under tension.



Rod removal (by hammer and punch)

Punch out of retaining head by striking rod end opposite to retaining head.

Hold back module edge on the opposite side.

The belt must not be under tension.

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