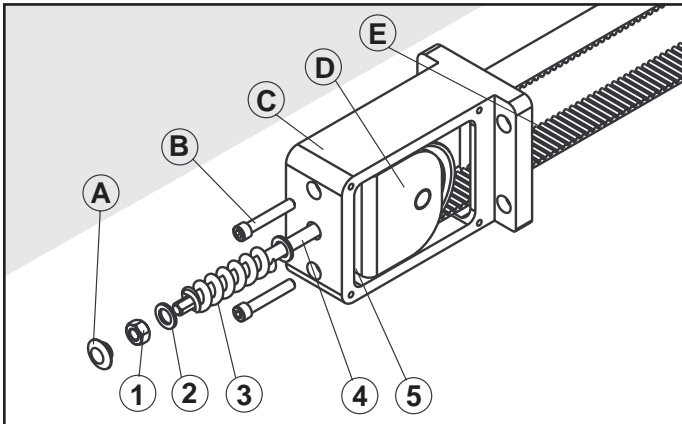




Belt-Tension Kit

PAS10, PAS15



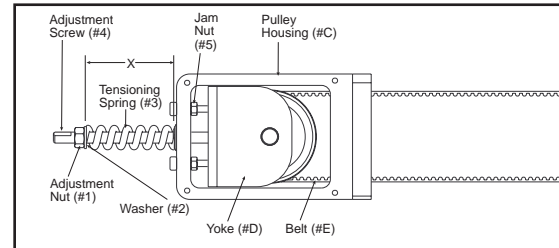
* NOTE: Kits include items 1-4 only. Parts are not sold individually. Grey items are not included in these kits. These products are on existing actuator.

List of Parts

Item	Part No.	Description	PAS10	PAS15
	3410-9314	PAS10 Kit (items 1-4)	x	
	3415-9322	PAS15 Kit (items 1-4)		x
1.	0701-1059	Adjustment Nut	1	1
2.	0720-1007	Washer	2	
	2410-1135	Washer		2
3.	3410-1092	Spring	1	
	3415-2007	Spring		1
4.	3410-1091	Adjustment Screw	1	
	3415-1774	Adjustment Screw		1
5.	2307-1007	Jam Nut	2	
	2406-1027	Jam Nut		2
A.	3410-1750	Cap Plug	1	
	3415-1750	Cap Plug		1
B.	3025-1028	SHCS, #10-32 x 1.06	1	
	0915-1173	SHCS, 1/4-20 x 1.50		2
C.	3410-1705	Pulley Housing	1	
	3415-1732	Pulley Housing		1
D.	3410-1718	Yoke, Tensioning	1	
	3415-1736	Yoke, Tensioning		1
E.	3410-1744	Belt, Mach., PAS10	1	
	3415-1744	Belt, Mach., PAS15		1

ADJUSTING BELT TENSION USING THE BELT TENSION KIT

To adjust belt tension using the belt tension kit, follow these instructions.



1. Preparation

- Remove the protective cap (#A) from idler pulley housing (#C). Note the idler pulley side of the actuator is on the opposite side than the brake.
- Remove one cover from the side of the pulley housing. This allows you to see what is going on better.
- Loosen jam nuts (F) that are tightened against the Yoke (D). Back them off about 1/2" from the Yoke. They will be tightened later after proper belt tension has been achieved.

2. Attach belt tension kit to pulley housing:

- Thread the adjusting nut (#1) onto the adjusting screw (#4). Screw the nut on from the end of the adjusting screw that has the flats on it.
- Place washer (#2), spring (#3), and the other washer onto the adjusting screw.
- Insert the adjusting screw into the pulley housing, and thread the adjusting screw into the tensioning yoke about 4 turns.

3. Apply tension to the belt.

- Tighten the adjustment nut (#1) up against the washer and compress the spring against the other washer and the pulley housing until dimension 'X' is achieved. You may need to use a wrench to achieve the proper tension. Note: (Dim. 'X' is shown in the adjustment table below) The table is for actuators that are shorter than 90" of stroke, and for longer than 90" of stroke. A longer stroke requires more belt tension due to belt stretch.

Model	'X' dimension (inches) stroke < 90"	'X' dimension (inches) stroke > 90"
PAS10	1.31"	1.08"
PAS15	1.49"	1.16"

4. Tighten Yoke and Verify Belt Tension

- If the 2 socket head screws are not already started into the yoke, do so at this time.
- While viewing the tensioning yoke from the side, tighten each socket head screw slowly. Do this until you see the yoke move slightly. Repeat this for the other screw. The belt is now properly tensioned!
- Tighten each jam nut (F) down against the yoke. This will keep the screws from loosening over time. The belt is now properly tensioned!
- Move the carrier on the actuator back and forth. Verify that the belt is tensioned, and is not cogging (skipping teeth). If it is cogging, it is not tight enough, consult the factory at this time.



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