

# Feed Belt Replacement

---

**The tools that are required for this adjustment are a 6mm allen wrench and a 19mm open end wrench.**

**The following procedure should be followed:**

- Turn off the main power and switch off air supply
- First, loosen the rollers located on the left side of the feed belt assembly. Use the 19mm open end wrench to hold the outer nut. At the same time, use the 6mm allen wrench to loosen the inner 6mm bolt.
- After loosening the 6mm bolt, turn the outer (19mm) nut clockwise. This will release the tension to the feed belt.

# Feed Belt Replacement

---

- After loosening the 6mm bolt, turn the outer (19mm) nut clockwise. This will release the tension to the feed belt.
- Pull the feed belt off and install the new belt.
- After installing the new belt, apply tension by turning the outer (19mm) bolt counter-clockwise. Then tighten the 6mm screw. A guideline for proper tension is that after the belt is tightened, you should be able to take your thumb and forefinger and twist the belt approximately  $\frac{1}{4}$  of a turn.
- To adjust the belts, follow above steps except for step # 4.

**Note: Use caution when adjusting the tension on the drive belts. Too much tension could keep the belt drive from feeding properly. Always make sure the drive belt will turn manually before running in automatic or single step mode.**