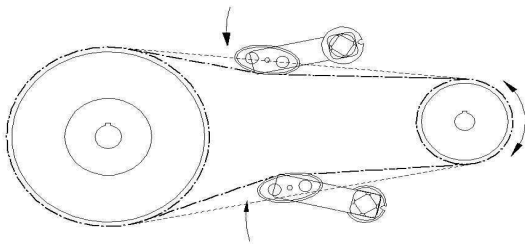
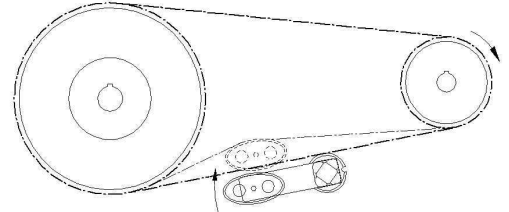


### General Mounting Guidelines

#### Chain Drives

- ◆ Use a Chain Rider if possible for drives running 300 ft/min. (1.5m/sec.) or slower.
- ◆ Always mount Tensioner on the SLACK side of the chain drive.
- ◆ Mount Tensioner as close to the biggest sprocket in the drive as possible.
- ◆ Mount the Tensioner with the arm as parallel as possible to the chain.
- ◆ The Mounting surface must be strong, flat and large enough for the entire tensioner base.

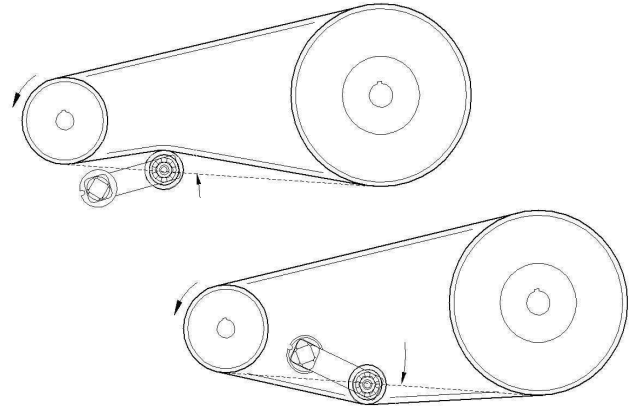


#### Reversible Chain Drives

- ◆ Use a Chain Rider if possible for drives running less than 59 in/sec. (1.5m/sec.).
- ◆ Always mount a Tensioner on BOTH SIDES of the chain drive.
- ◆ Mount Tensioners as close to the biggest sprocket in the drive as possible.
- ◆ Mount the Tensioners with the arm as parallel as possible to the chain.
- ◆ The Mounting surface must be strong, flat and large enough for the entire diameter of the tensioner base.
- ◆ Shorten chain as much as possible, reducing the slack to the very minimum.

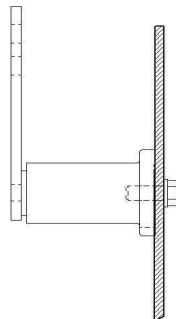
#### V-Belt & Flat Belt Drives

- ◆ Use a Roller or V-Belt Pulley with a bearing.
- ◆ Always mount Tensioner on the SLACK SIDE of the belt drive.
- ◆ Mount Tensioners as close to the drive pulley as possible when using a back-side idler roller.
- ◆ Mount Tensioner as close to the driven pulley as possible when using a grooved pulley on the inside of the belt.
- ◆ Mount the Tensioners with the arm as parallel as possible to the belt.
- ◆ The Mounting surface must be strong, flat and large enough for the entire diameter of the tensioner base.



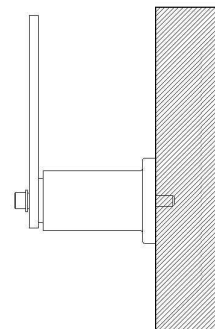
#### Standard (back) Mounted

- ◆ Requires access to the mounting bolt from behind the equipment
- ◆ Mounting bolt passes through mounting plate from behind and screws into the tensioner base.



#### Front Mounted

- ◆ Does Not require access from behind the equipment.
- ◆ Mounting bolt threads into a tapped hole on the front face of the equipment.



### Mounting Instructions

#### ⚠ WARNING

Failure to observe the following warnings could create a risk of death or serious injury.

Follow all appropriate Lock-Out/Tag-Out procedures.

It is recommended that the chain or belt guards be installed before making a test run.

1. Hold the tensioner against the mounting surface to determine the optimal position/location per the above General Mounting Guidelines.
2. Mark where the hole needs to be drilled.
3. **STANDARD MOUNTING** — Drill the mounting hole to the correct size for the Tensioner per Table 1.  
**FRONT MOUNTING** — Drill & Tap mounting hole to the correct size per Table 2.
4. Mount the tensioner, however, do not fully tighten the mounting bolt. Tensioner should be snug but still able to be rotated.
5. Install the mounting bolt into one of the two holes in the tensioner arm. The hole farthest out on the arm is the NORMAL position. The hole closest to the tensioner housing is the HARD position.
6. Install the appropriate accessory (sprocket, chain glide, roller) for the type of drive being tensioned.
7. Align the tensioning accessory with the belt or chain and lock in place using the supplied jam nuts on each side of the accessory.
8. With a large open end wrench or pipe wrench, turn the outer housing of the tensioner until the belt or chain begins to tension.
9. Continue turning the outer housing to pre-tension the drive until the proper amount of tension has been applied, using the pretension angle markings located on the corner of the outer housing as a reference. **DO NOT EXCEED 30 DEGREES of pre-tension!**

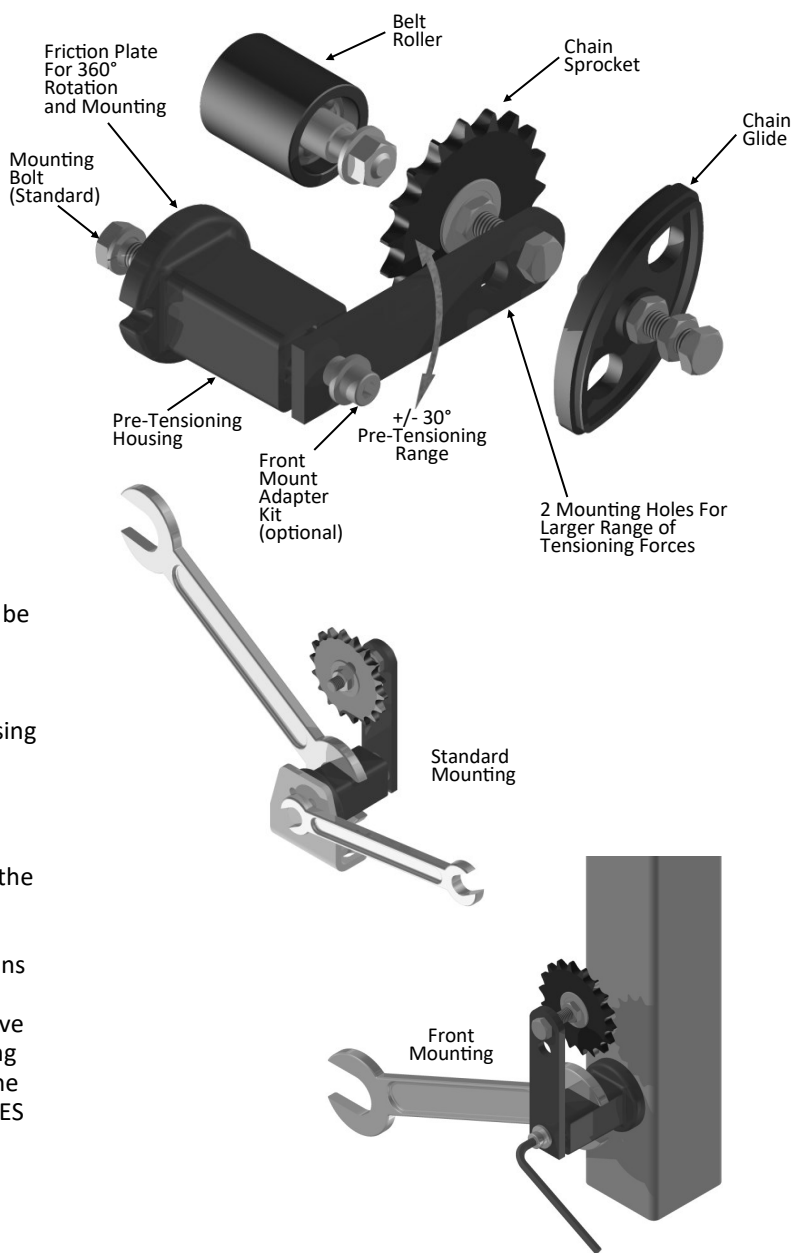


Table 1: Mounting Information

Tensioner Size	Mounting Bolt Size		Hole Size		Bolt Torque in/lbs	
	Standard	Front	Standard	Front	Standard	Front
RT11	M6X20	N/A	1/4"	N/A	89	N/A
RT15	M8X20	M6	5/16"	M6X1	221	89
RT18	M10X30	M8	7/16"	M8X1.25	434	221
RT27	M12X40	M10	1/2"	M10X1.5	761	434
RT38	M16X40	M12	5/8"	M12X1.75	1859	761
RT45	M20X50	M16	13/16"	M16X2	3629	1859
RT50	M24X60	M20	1"	M20X2.5	6638	3629

