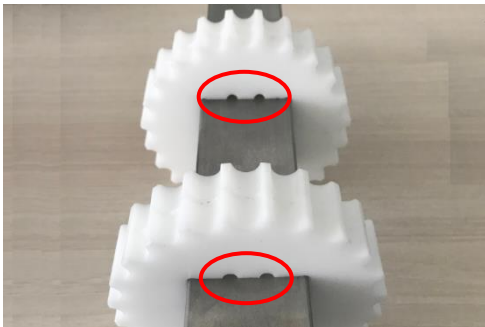


# HabasitLINK®

## Installation instructions for belt type M1065

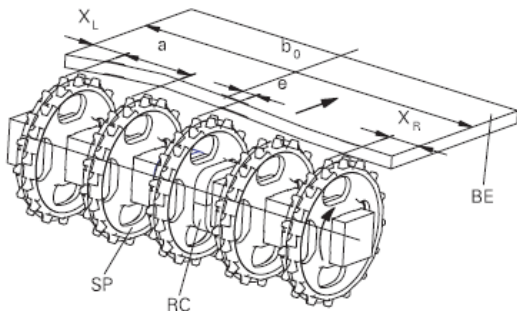
Please find full installation guide on [www.habasit.com](http://www.habasit.com)



### Installation of M1000 sprockets

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 center with small clearance.

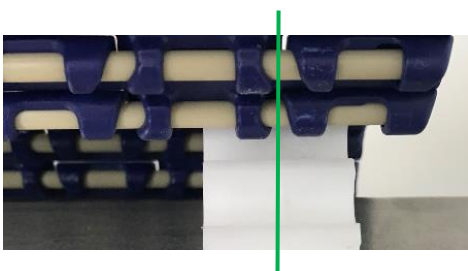
Belt type	Sprocket spacing a		Edge distance (minimal)	
	minimal mm inch	maximal mm inch	$X_L$ mm inch	$X_R$ mm inch
M1065	76.2 3	101.6 4	25.4 1	25.4 1



### Check proper sprocket engagement:

The sprocket teeth must properly engage in belt.

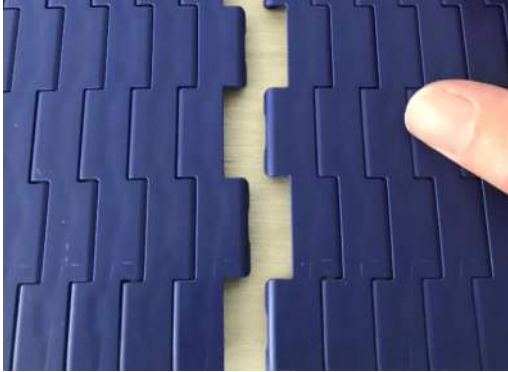
With M1000 sprockets bi-directional drive is possible.



For proper belt tracking the sprocket center rib must be placed between module hinges.

**Rod installation (smart fit headless rod retention):**

Rod Ø4.5mm (0.18”) without head must have a beveled end. For wide belts there may be more than one rod per row.

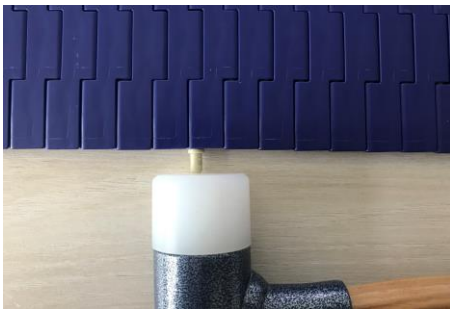


Pull belt sections together



Insert rod

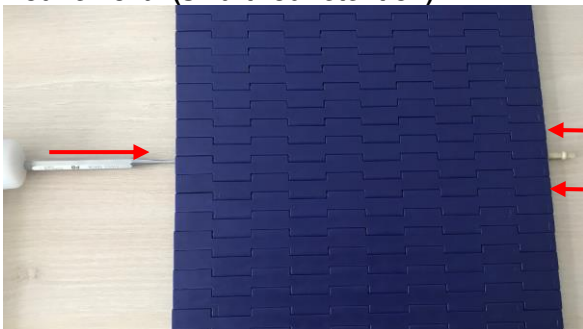
For easy rod installation, rod end must be beveled.



Push in the rod head

Check if rod head is fully embedded

**Rod removal (smart rod retention):**



**Rod removing by hammer and punch**

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

Hold back module edge at opposite side.

The belt must not be under tension.

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