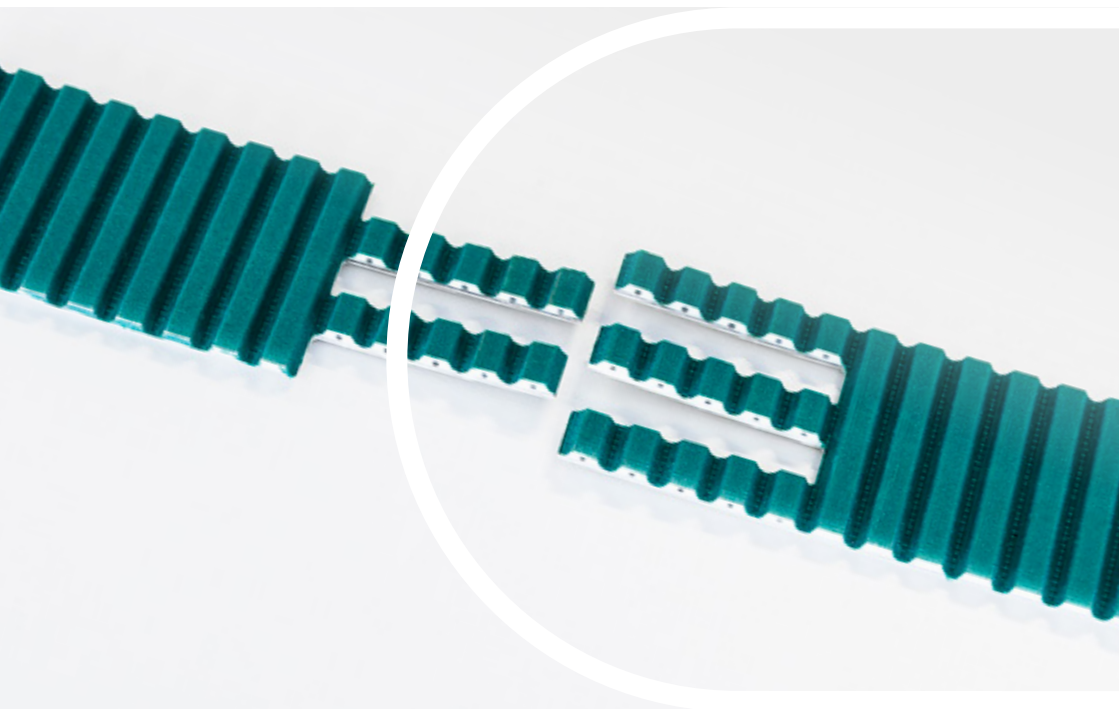


# Assembly Guide for Pin Joint



## For timing belt types: T10, AT10, H, HTD8M

### Threaded pin M2 for final fitting:

Length of threaded pin = TB-width + ~20mm

Pin joint 5 | 5 pcs

Pin joint 11 | 11 pcs

### Smooth pin $\varnothing 1,5\text{mm}$ for pre-installation:

Length of smooth pin = TB-width + ~20mm

Quantity 3 pcs

## For timing belt types: T20, AT20, HTD14M

### Threaded pin M3 for final fitting:

Length of threaded pin = TB-width + ~20mm

Pin joint 5 | 5 pcs

Pin joint 11 | 11 pcs

### Smooth pin $\varnothing 2,5\text{mm}$ for pre-installation:

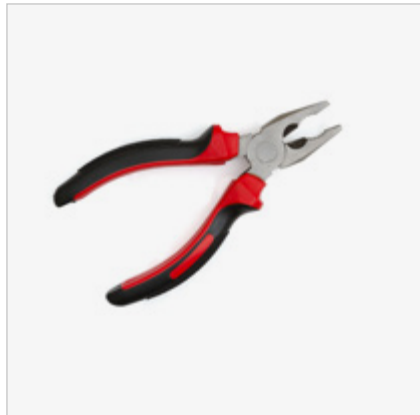
Length of smooth pin = TB-width + ~20mm

Quantity 3 pcs

## Cordless screwdriver



## Handheld cutting tool



**Examples of grinding tools for pins**



02

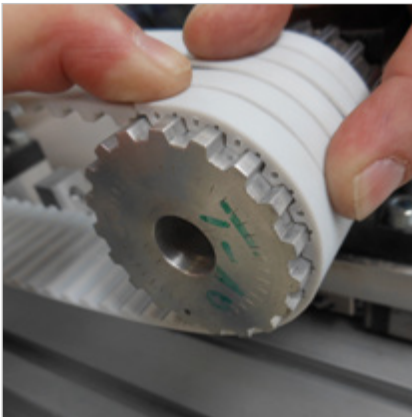
## Pulleys without flanges

For installation on pulleys with flanges go to step 3.

### 2.1

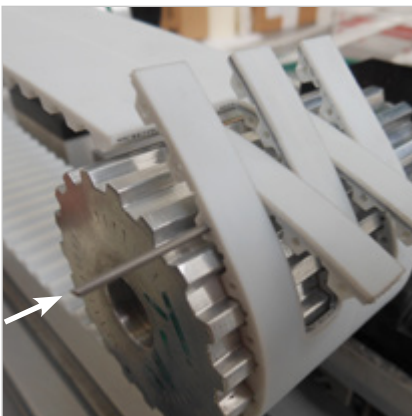
**First place the fingers of the pin joint around the pulley and hold them with your hands.**

To avoid any injuries we suggest you wear safety gloves during the whole installation process.



### 2.2

**Insert the smooth pin in the middle of the joint.**



## 03

## Pulleys with flanges

### 3.1

If you are installing the belt on pulleys with flanges, you won't be able to insert smooth pin in middle of joint on the pulley.

The easiest method is to carry out the installation in the middle of pulley center distance.

## 04

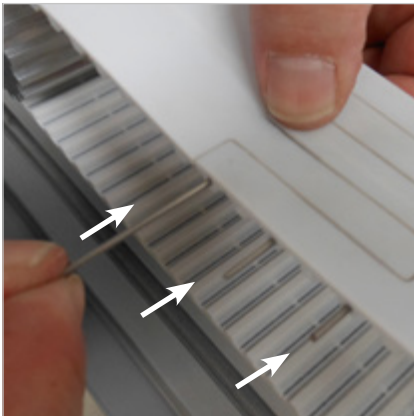
## Pre-assembly

### 4.1

Turn the timing belt (if not already done as described in step 3.) so that the pin-joint connection is in a position between the pulleys.

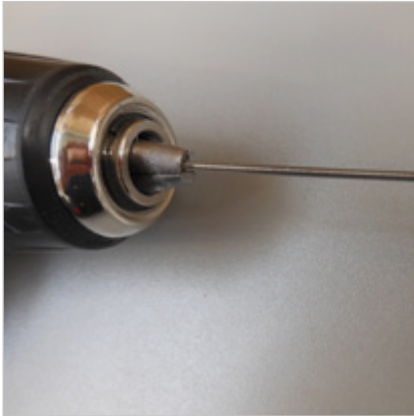
### 4.2

Now insert two remaining smooth pins in last left and last right hole of pin-joint connection.



### 5.1

Insert threaded pin in cordless screw driver so that the free length of pin is longer than the width of the belt.



## 6.1

---

**First the threaded pin has to be screwed in place without the smooth pin.**

Screw it through the whole belt width and let a few millimeters be visible on both sides.

## 6.2

---

**Now you can screw in other pins. Smooth pins have to be pushed out by screw pins while screwing.**

Screw the threaded pins trough the whole belt width and let a few millimeters be visible on both sides.

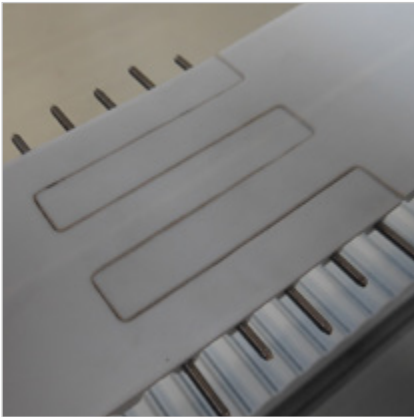


## 7.1

---

### Make sure that:

- all threaded pins are properly screwed in
- all threaded pins have a few mm visible on both ends
- all the gaps between the timing belt fingers are uniform.

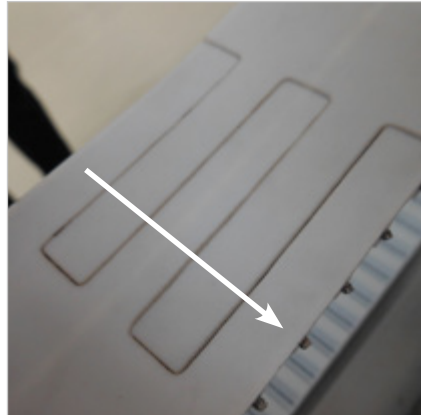
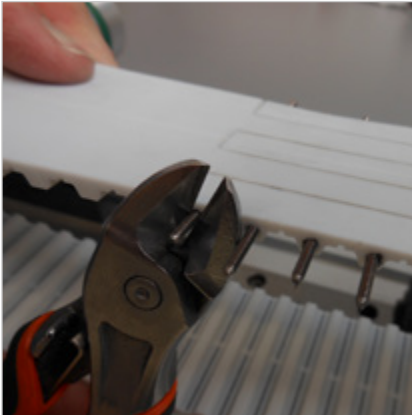


08

## Cutting the pins to final length

### 8.1

Please put on your safety glasses in order to avoid any injury. Using a handheld cutting tool, cut off the pins as close as possible to the belt edge on both belt sides of belt



## 9.1

### **Wear safety glasses and hearing protection while grinding.**

Grind off excess pin length on both sides of belt with the recommended tools mentioned on the first page.

#### **Take care:**

Make sure to leave no excess pin length on the sides. The timing belt edge must be smooth. Otherwise, the smooth running of the belt cannot be guaranteed.



### 10.1

---

**If you have completed all the steps correctly, you are done with the assembly at this point.**

Please start a short test run to ensure that the assembled timing belt is running properly.

# Contact us

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representatives and service partners all around  
the world, dedicated to supporting you whenever  
and wherever you need us.



## **Australia**

Habasisit Australia Pty Ltd.

Silverwater, Sydney

☎ +61 1300 945 455

🌐 [habasisit.com.au](http://habasisit.com.au)

## **Austria**

Habasisit GmbH, Wiener Neudorf

☎ +43 1 690 66

🌐 [habasisit.at](http://habasisit.at)

## **Belgium & Luxembourg**

Habasisit Belgium N.V., Zaventem

☎ +32 27 250 430

🌐 [habasisit.be](http://habasisit.be) | [habasisit.lu](http://habasisit.lu)

## **Brazil**

Habasisit do Brasil, Barueri - SP

☎ +55 11 4789 9022

🌐 [habasisit.com.br](http://habasisit.com.br)

## **Canada**

Habasisit Canada Ltd., Oakville

☎ +1 905 827 41 31

🌐 [habasisit.ca](http://habasisit.ca)

## **China**

Habasisit East Asia Ltd.

Fotan, Shatin, N.T., Hong Kong

☎ +852 2145 0150

🌐 [habasisit.com.hk](http://habasisit.com.hk)

Habasisit (Shanghai) Co. Ltd.

Shanghai

☎ +8621 5488 1218

🌐 [habasisit.com.cn](http://habasisit.com.cn)

## **France**

Habasisit France S.A.S., Mulhouse

☎ +33 3 89 33 89 03

🌐 [habasisit.fr](http://habasisit.fr)

## **Germany**

Habasisit GmbH, Eppertshausen

☎ +49 6071 969 0

🌐 [habasisit.de](http://habasisit.de)

## **India**

Habasisit India, Coimbatore

☎ +91 422 666 78 00

🌐 [habasisit.in](http://habasisit.in)

## **Italy**

Habasisit Italiana SpA

Customer Care: 0438 911333

For int. calls: +39 0438 911444

🌐 [habasisit.it](http://habasisit.it)

## **Japan**

Habasisit Nippon Co., Ltd, Tokyo

☎ +81 120 07 6339

🌐 [habasisit.co.jp](http://habasisit.co.jp)

## **Korea (Republic of)**

Habasisit Korea Ltd.,

Seongnam City

☎ +82 31 737 9370

🌐 [www.habasisit.co.kr](http://www.habasisit.co.kr)

## **Mexico**

Habasisit Rocua, Zapopan

☎ +52 33 3824 2358

🌐 [habasisitrocua.mx](http://habasisitrocua.mx)

## **Netherlands**

Habasisit Netherlands BV, Nijkerk

☎ +31 332 472 030

🌐 [habasisit.nl](http://habasisit.nl)

## **New Zealand**

Habasisit New Zealand Pty Ltd.

Auckland

☎ 0800 000 070

🌐 [habasisit.co.nz](http://habasisit.co.nz)

### **Nordic countries**

Habasit AB, Hindås, Sweden

☎ +46 301 226 00

🌐 [habasit.se](http://habasit.se)

### **Poland**

Habasit Polska Sp. z o.o.

Dąbrowa Górnicza

☎ +48 32 639 02 40

🌐 [habasit.pl](http://habasit.pl)

### **Romania**

Habasit Belting SRL

Timisoara

☎ +40 256 704 500

🌐 [habasit.ro](http://habasit.ro)

### **Russia**

OOO Habasit Ltd.

Moscow Region

☎ +7 495 966 1566

🌐 [habasit.ru](http://habasit.ru)

### **Singapore**

Habasit Far East Pte Ltd.

Singapore

☎ +65 6862 5566

🌐 [habasit.com.sg](http://habasit.com.sg)

### **South Africa**

Habasit South Africa Pty Ltd.

Gauteng

☎ +27 10 001 6770

🌐 [habasit.co.za](http://habasit.co.za)

### **Spain**

Habasit Hispánica S.A.

Barberá del Vallés

☎ +34 937 191 912

🌐 [habasit.es](http://habasit.es)

### **Switzerland**

Habasit GmbH, Reinach

☎ +41 61 577 51 00

🌐 [habasit.ch](http://habasit.ch)

### **Taiwan**

Habasit (Taiwan) Ltd.

New Taipei City

☎ +886 2 2267 0538

🌐 [habasit.com.tw](http://habasit.com.tw)

### **Turkey**

Habasit Kayis San.

Ve Tic. Ltd. Sti., Istanbul

☎ +90 444 70 43

🌐 [habasit.com.tr](http://habasit.com.tr)

### **Ukraine**

Habasit Ukraine LLC., Kyiv

☎ +38 044 290 88 99

🌐 [habasit.ua](http://habasit.ua)

### **United Kingdom & Ireland**

Habasit UK Ltd., Eiland

☎ +44 333 207 6570

🌐 [habasit.co.uk](http://habasit.co.uk)

### **USA**

Habasit America

Suwanee, Georgia

☎ +1 800 458 6431


🌐 [habasitamerica.com](http://habasitamerica.com)




## **Habasit International AG**

Römerstrasse 1

CH-4153 Reinach, Switzerland

 +41 61 715 15 15

 +41 61 715 15 55

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