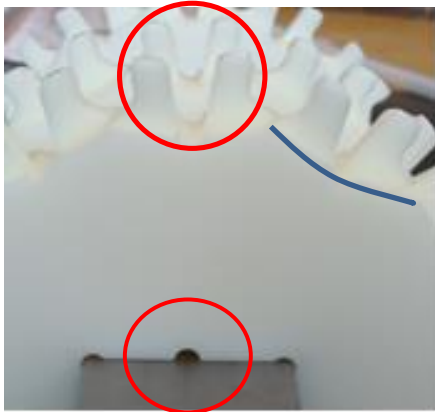


# HabasitLINK<sup>®</sup>

## Installation instructions for belt type M3398

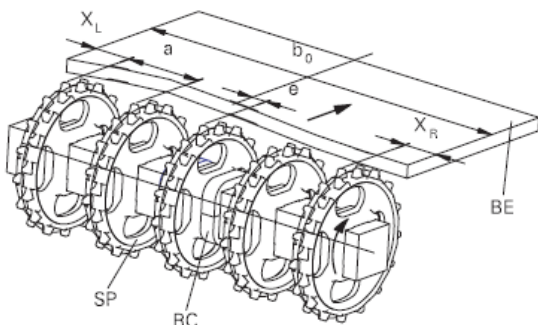
Please find full installation guide on [www.habasit.com](http://www.habasit.com)



Sprocket alignment on the shafts:

**Corresponding teeth axial aligned, check by tooth orientation and mark on shaft.**

Sprockets with concaved minor diameter can run on both belt top and bottom sides.



### Sprockets Positioning:

At belt edge place sprockets according  $X_L$  and  $X_R$  distances.

In belt center place sprockets between min. and max. spacing (a).

Offset (e) is given by shaft design.

Fix only the sprocket in the center with small clearance.

Ensure the engagement is not at the junction of two modules (check over two rows).

Sprocket distance for **standard drive** configuration, sprockets engage at bottom side of the belt:

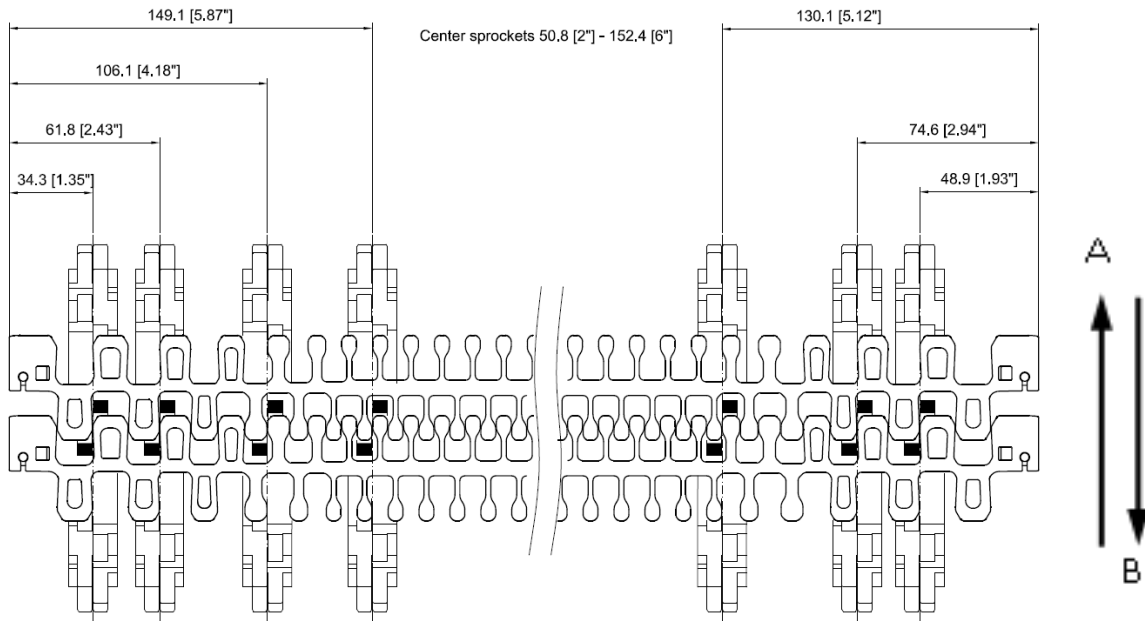
Belt type	Sprocket spacing a		Optional distances of the sprockets at belt edges						
	minimal	maximal	$X_L$ from belt edge				$X_R$ from belt edge		
	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>
M3398	50.8 2	152.4 6	*34.3 *1.35	*61.8 *2.43	106.1 4.18	149.3 5.88	*48.9 *1.93	*74.6 *2.94	130.1 5.12

$X_L$  and  $X_R$  are related to running direction A and are inverse for the running direction B

\*Always install the two first sprockets from belt edge.

Place sprocket in the center at a multiple of 12.7 mm (0.5").

**Sprocket positions and running direction for Standard drive:**



**Belt running direction:**

This belt can run in both directions but it might be given by the shaft design with fixed sprocket and offset (e). Install the belt whenever possible with rod head on the outside of the curve.

Preferred running direction for radius and spiral conveyors is direction A.

Respect edge distance  $X_L$  and  $X_R$  depending on running direction and drive option (top or bottom).



**Check proper sprocket engagement:**

The sprocket teeth must properly engage in the belt. Belt bottom side is in contact with the sprocket minor diameter. Check proper sprocket engagement from belt surface.

Sprocket distance for **Top side drive** configuration, sprockets engage at surface side of the belt:

Belt type	Sprocket spacing a		Optional distances of the sprockets at belt edges						
	minimal	maximal	$X_L$ from belt edge			$X_R$ from belt edge			
	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>	mm <i>inch</i>
M3398	50.8 2	152.4 6	*48.9 *1.93	*74.6 *2.94	130.1 5.12	*34.3 *1.35	*61.8 *2.43	106.1 4.18	149.3 5.88

$X_L$  and  $X_R$  are related to running direction A and are inverse for the running direction B

\*Always install the two first sprockets from belt edge.

### Rod installation (smart fit rod retention):

Rod Ø6mm (0.22") with octagonal shaped head must have a beveled end. Install the belt with **rod head on the outside of the curve**. In case of more curves with opposite direction install belt with rod head on outside at last curve (closer to head drive), for wide belts there might be two rods per row (S-curve).



Pull belt sections together



Insert rod, for easy rod installation, rod end must be beveled.



Check if rod head is fully embedded.  
Push in rod head

### Rod removal (smart fit rod retention):



#### Rod removal by Habasit Rod Puller.

The belt must not be under tension and rod has to be pushed in direction of arrow.



Apply rod puller at rod head from the next module (see picture). Push it below rod head and in direction of arrow- Pull it out by moving the handle towards the belt.

#### Disclaimer

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