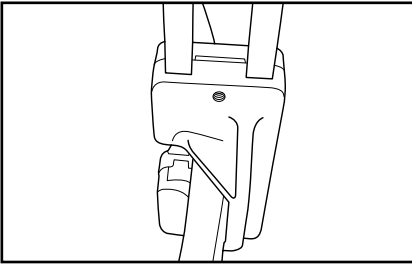
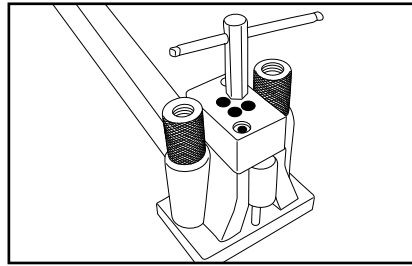


# Alligator® V-Belt Fastener Application

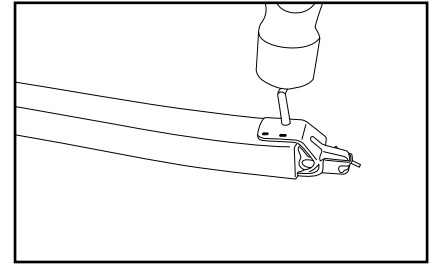
## Instructions



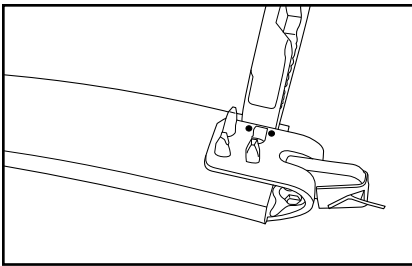
1. Square belt end with Alligator® V-belt cutter. Read “Belt Length” guidelines on reverse side before cutting belt to correct length.



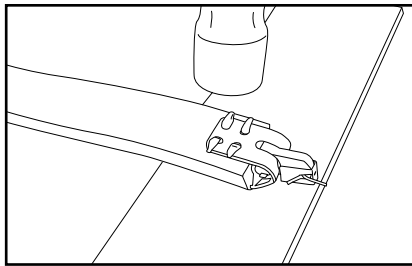
2. Clamp belt against Stop in Piercing Tool. Drive the punch into shoulder and STOP. Repeat for each hole. The punch never goes all the way through the belt.



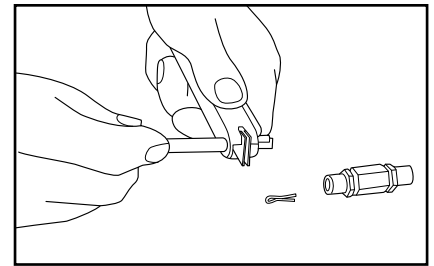
3. Fit assembled unit with links on one end of belt. Place on soft wood block. Drive nails through fastener and belt into soft wood block. Be careful not to distort belt by pounding fastener.



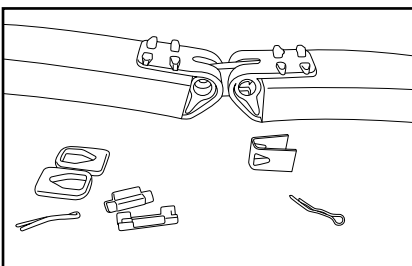
4. Start clinching of nails with slotted end of alignment pin, then complete with pliers. Do not crush fastener. Repeat above operations on opposite end of belt using unit with assembly clip.



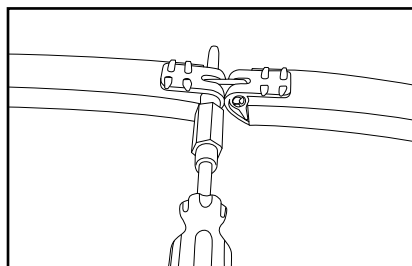
5. Use hammer to flatten nails.



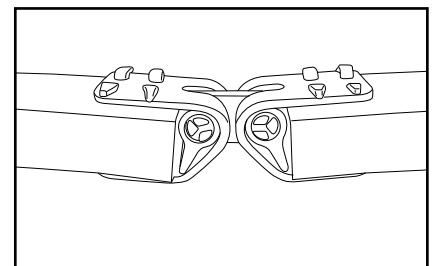
6. When ready to join ends remove both cotter pins. (1 cotter pin in each half fastener.) Discard cotter pins. To remove assembly clip, use the rocker pin tool. Give rocker pin one-half turn, then push out.



7. Fastener ready for assembly. Note aligning pin, two piece rocker pin, and flat-sided hole in link which fits into seat in rocker pin.



8. Assemble rocker in tool, rocker pin and aligning pin in sleeve as shown. Then push through fastener and twist. Rocker pin will push out alignment pin. Turn rocker pin until seat locks into position in link.



9. Important—Make sure both rocker pins are locked into link in the correct position. The screwdriver slot in the large section must be parallel with the length of belt and away from the belt as shown. When centered and in this position, the rocker pin locks automatically.

## Belt Length

The charts on this page tell the length to cut Open-End V-Belting when replacing standard endless V Belts.

If a standard endless V-Belt has not been used on the drive or if the drive is an odd length, use the following method in determining proper length to cut Open-End V-Belting: Put belting in sheaves and measure outside circumference length of drive. From this length, to convert to pitch length \* and allow for fastener opening, subtract 1-3/16" for "A" sections belting, 2" for "B", 2-3/4" for "C", and 3-1/2" for "D". Also, to take care of initial stretch, for each foot of belt, subtract 3/32" for "A" section belting, 3/16" for "B", 3/16" for "C", and 1/8" for "D".

## Pitch Length

\*The pitch length of a drive and the neutral axis length of a V-Belt are the same. The outside of a V-Belt stretches when it goes around the pulley—the inside contracts. This neutral axis in between the outside and inside does not stretch nor shrink. The pitch length is also the laid out flat length of Open-End V-Belting.

## Replacement Charts

FOR "A" SECTION		FOR "B" SECTION		FOR "C" SECTION		FOR "D" SECTION	
Endless V-Belt No.	Cut Your Open-End V-Belting	Endless V-Belt No.	Cut Your Open-End V-Belting	Endless V-Belt No.	Cut Your Open-End V-Belting	Endless V-Belt No.	Cut Your Open-End V-Belting
A-26	26-1/2"	B-35	35-3/16"	C-51	51-3/16"	D-120	120-1/4"
A-31	31-7/16"	B-38	38-1/8"	C-60	60-1/16"	D-128	128-1/4"
A-33	33-7/16"	B-42	42-1/16"	C-68	67-15/16"	D-144	144"
A-35	35-7/16"	B-46	46"	C-75	74-13/16"	D-158	157-7/8"
A-38	38-3/8"	B-48	48"	C-81	80-3/4"	D-162	161-3/4"
A-42	42-3/8"	B-51	50-15/16"	C-85	84-11/16"	D-173	172-5/8"
A-43	43-3/8"	B-53	52-15/16"	C-90	89-9/16"	D-180	179-5/8"
A-46	46-5/16"	B-55	54-7/8"	C-96	95-1/2"	D-195	194-1/2"
A-48	48-5/16"	B-56	55-7/8"	C-105	104-5/8"	D-210	209-1/4"
A-51	51-5/16"	B-60	59-13/16"	C-112	111-1/4"	D-225	221-5/8"
A-53	53-1/4"	B-62	61-3/4"	C-120	119-1/8"	D-240	236-1/2"
A-55	55-1/4"	B-64	63-3/4"	C-128	127"	D-255	251-3/8"
A-56	56-1/4"	B-65	64-3/4"	C-136	134-7/8"	D-270	266-1/8"
A-60	60-3/16"	B-66	65-11/16"	C-144	142-3/4"	D-285	281"
A-62	62-3/16"	B-68	67-11/16"	C-158	156-1/2"	D-300	295-7/8"
A-64	64-3/16"	B-71	70-5/8"	C-162	160-7/16"	D-315	310-3/4"
A-66	66-3/16"	B-75	74-9/16"	C-173	171-5/16"	D-330	325-1/2"
A-68	68-3/16"	B-78	77-1/2"	C-180	178-3/16"	D-345	340-3/8"
A-70	70-1/8"	B-81	80-1/2"	C-195	192-15/16"	D-360	355-1/4"
A-71	71-1/8"	B-83	82-7/16"	C-210	207-11/16"	D-390	385"
A-75	75-1/8"	B-85	84-7/16"	C-225	220-1/2"	D-420	414-5/8"
A-78	78-1/16"	B-90	89-5/16"	C-240	235-1/4"	D-480	474"
A-80	80-1/16"	B-93	92-5/16"	C-255	250"	D-540	533-3/8"
A-85	85"	B-97	96-3/16"	C-270	264-13/16"	D-600	592-3/4"
A-90	90"	B-100	99-3/16"	C-285	279-9/16"		
A-96	95-15/16"	B-103	102-1/8"	C-300	294-5/16"		
A-105	104-7/8"	B-105	104-1/16"	C-315	309-1/16"		
A-112	111-13/16"	B-108	107-1/16"	C-330	323-7/8"		
A-120	119-3/4"	B-112	111"	C-345	338-5/8"		
A-128	127-11/16"	B-120	118-7/8"	C-360	353-3/8"		
A-136	135-5/8"	B-124	122-13/16"	C-390	382-15/16"		
A-144	143-9/16"	B-128	126-3/4"	C-420	412-7/16"		
		B-133	131-11/16"				
		B-136	134-5/8"				
		B-144	142-1/2"				
		B-158	156-1/4"				
		B-162	160-3/16"				
		B-173	171"				
		B-180	177-15/16"				
		B-195	192-11/16"				
		B-210	207-7/16"				
		B-225	220-3/4"				
		B-240	235-1/2"				
		B-255	250-1/4"				
		B-270	265"				
		B-285	279-13/16"				
		B-300	294-9/16"				

No. A180 Flex V-Fastener is recommended for joining "A" section Open-End V-Belting

No. C531 Alligator® V-Belt Fastener is recommended for joining 17/32" thick "C" section Open-End V-Belting

No. D750 Alligator® V-Belt Fastener is recommended for joining "D" section Open-End V-Belting

There are several numbering systems used by V-Belting manufacturers. All the numbers in each column identify the same length belts.

## Manufacturers' Numbering Systems

A-26	B35	C51	D120
26A	35B	51C	120D
2A6	3B5	5C1	1D20
2A8	3B7	5C4	1D23

## Correction Chart

Belt Size	A	B	C	D
Correction deduction converting from outside circumference length to pitch length	7/8"	1-1/4"	1-3/4"	2-1/2"
Fastener Openings	5/16"	3/4"	1"	1"
TOTAL OF ABOVE	1-3/16"	2"	2-3/4"	3-1/2"
Initial Belt Stretch PER FOOT	3/32"	3/16"	3/16"	1/8"

Example:

If you have a "B" section drive with outside circumference of 140", deduct 2" for conversion to pitch length and for fastener opening. This leaves 138" from which you must deduct the allowance for initial stretch—3/16" times 11-1/2" (138")—or approximately 2-1/8". You should cut your Open-End V-Belting 135-7/8" (138-2-1/8") when laid out flat and straight.



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