

## Tensioning the Frame Machine Drive Chains

The chain tension should be checked monthly.

If the chains are jumping or making a slapping sound you should check the tension immediately.

1. Remove the strip from the machine.  
**Note:** If the strip is left in the machine it will prevent the rollers from moving and the chains won't be tensioned correctly.
2. Turn off the machine and depress the E-Stop button.
3. Remove the side covers.
4. Examine the chains there should be some movement in the chains between the motor sprocket and the first roller. Approximately 20mm of movement. (insert Picture)
5. If the chain is loose. Using the supplied tensioner spanner and an Allen key. Loosen the locking bolt on the outside of the machine and turn the tensioner. (The sprocket is mounted on an eccentric shaft and will tighten or loosen the chains depending on the direction it is turned.)

**NOTE:** If you cannot achieve the required tension the chain may be stretched and in this case should be replaced.

The chain used on the Howick Frame Machine is standard 5/8" inch pitch. If the chain is not over sized then it will be a case of fitting a half link to reduce the chain length.

6. Repeated the process for the other chain if required.
7. Replace the covers.

**N.B.** Once the machine has been running for a short while after tensioning the chains check that the tension is correct.