

⚠️ WARNING

Always obey all applicable safety rules.

Be sure all power to the conveyor has been disconnected and controls are locked out.

Installation Tools Required:

- Torque wrench accurate in the 30-45 in-lb (3.4-5.1 Nm) range
- 5/16" or 8 mm socket
- 3" socket extension
- Tape measure
- Any application-specific tools needed to remove the pulley and relieve tension from the belt

Step 1: Release Conveyor Belt Tension

Remove tension from return side of conveyor belt.

Step 2: Remove Return Idler Roller

Remove return idler roller from conveyor.

Step 3: Clean Roller Surface

Clean off any residue on the roller.

Step 4: Position First Thumper on Roller

Slide the Thumper onto the roller and position it so that it is no closer than 4" from where the outside edge of the belt is contacting the end of the roller.

Step 5: Install Additional Thumpers per Roller Width

Per the chart above, add additional Thumpers based on the roller width, leaving approx. 10" between them.

Step 6: Align Clamp and Gear with Lobe

Once the Thumper is positioned on the roller, align the clamp so that the screw gear is under the Thumper lobe.

Step 7: Torque Clamp to Specification

Tighten the clamp by applying 30-45 in-lbs (3.4-5.1Nm) of torque to the clamp.

Step 8: Install and Time Adjacent Thumpers

Install next Thumper, and time the lobes so that they match the valley on the adjacent Thumpers, and position/torque clamp accordingly.

Step 9: Verify Final Thumper Inboard Offset

Ensure final Thumper installed is at least 4 inches inboard from where the outside of the belt is contacting the roller.

Step 10: Reinstall Idler Roller Assembly

Reinstall Idler onto conveyor system.

Step 11: Restart Conveyor and Verify Belt Tracking

After restarting the conveyor, verify the belt cannot wander off the outside Thumpers, as belt damage could occur. If belt wander exceeds 4 inches, increase the inboard offset.

Idler Diameter	Roller Width	Belt Thumpers
4"	21" - 27 3/8"	2
4"	30" - 39"	3
4"	40" - 52"	4
5"	27 3/8" - 29"	2
5"	30" - 39"	3
5"	39 3/8" - 57 3/8"	4
5"	58" - 63 3/8"	5

