



DRIVE
SOLUTIONS

SIT S.P.A., SINGLE-MEMBER COMPANY

VIALE A. VOLTA, 2 – 20047 CUSAGO (MI)

Instruction Manual

EMF-Assembly Tool



Operating instructions for EMF assembly tool

Instruction Manual

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Included in the basic set:

- 1x C-grip pliers
- 1x Combination pliers
- 1x Ratchet screwdriver with interchangeable bit and bit magazine
- 2x Universal adapter (pre-assembled)
- 1x Case

Additionally included by configuration:

Profiled clamping plates according to choice

Smooth clamping plates according to choice



Hinweise und Erweiterungsoptionen

1. the EMF mounting set can be used universally. Any type of toothed belt that is available with an EMF connector can be mounted with this tool.

Available standard profiles:

Profil	20	25	30	32	50
8M	✓	✓	✓	×	✓
14M	✓	✓	✓	×	✓
T10	×	✓	×	✓	✓
T20	×	✓	×	✓	✓
AT10	×	✓	×	✓	✓
AT20	×	✓	×	✓	✓
Glatt	✓	✓	✓	✓	✓

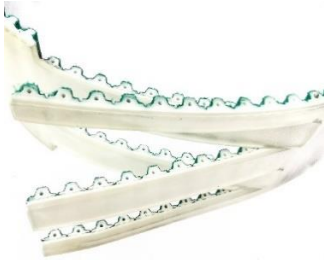
2. connectors over 50 mm wide can optionally be mounted with a 50 mm wide universal adapter. 2 clamping plates can be attached to this adapter to mount e.g. 75 mm wide belts (25 + 50 clamping plate). Other widths, from 16 mm to 100 mm, may be available on request.
3. a basic set can be configured with two sets of different clamping plates according to customer requirements. Further clamping plate types to extend the existing basic set can be ordered separately. Smooth clamping plates can be used universally as counter holders.



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4. Usage

1. Open the prefabricated connection part of the toothed belt and remove all the pins inserted as assembly locks.



2. Open the C-grip pliers by pressing the yellow lever. (Figure shows closed state)



3. Slide the clamping plates compatible with the toothed belt onto the trapezoidal guide of the adapter pieces premounted on the C-grip pliers. Note: This can be somewhat difficult to do. Make sure that the components do not tilt.

4. Close the C-grip pliers by pressing the two handles together. You can use the eyebolt to roughly preset the clamping position so that the C-grip pliers can close without pressure but completely. When the clamping plates lie on top of each other without pressure when the C-grip pliers are closed, the C-grip pliers are opened again.



5. Place the toothed belt in the slackened installation and join the belt ends by hand.



6. Place the loose, joined ends on the profiled clamping plate and press the smooth clamping plate onto it by hand. Make sure that the entire joint is on the clamping plate. You can push the outer tongues in sideways if necessary.

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7. Close the C-grip pliers as soon as all outer edges of the toothed belt are clearly inside the clamping plates. If a clearly perceptible resistance is overcome during closing, the C-grip pliers are correctly closed.
- The pressure can be increased or reduced at any time via the eyebolt.



8. provide the junction with the EMF pins by first inserting them manually to a depth of approx. 5 mm.



9. Push the EMF pins through the bore channels. Use the ratchet screwdriver with pin-Torx bit (PTX) to push the pins through.
- PTX 20 = for 1.5 mm pins
 - PTX 25 = for 2 mm pins
 - PTX 40 = for 3 mm pins

A bit magazine is located in the unscrewable, yellow cap of the ratchet screwdriver. This contains all the bits required.



10. Open the C-grip pliers by operating the yellow lever to remove the tool.

11. Use the combination pliers to press the approx. 3 mm protruding pin ends completely into the bore channel. If the entire belt flank is a flat surface, assembly is complete.

