MAINTENANCE INFORMATION
CENTER DRIVEN FLAT BELT CONVEYOR

Wiring, Preparation and Maintenance of the Motor

Reference the supplied manufacturer's documentation for proper motor wiring instructions.

If motor operates on DC, a variable speed DC motor controller is required to run the motor.

Some gearmotors have a plastic plug sealing a vent for shipping. If your gearmotor has this plug, remove it prior to starting the conveyor. Reference the supplied manufacturer's documentation for specific maintenance information.

Belt Tension and Tracking Adjustment

Belt tension can be set by adjusting the take-up roller in the center drive module. Simply loosen the nuts on the adjustment screws on the front of the drive plates and turn the screws to adjust the tension. Be sure to tighten the nuts when adjustment is complete. Both sides of the take-up should be adjusted equally to assure proper tracking through the drive module.

Belt tracking can be adjusted by loosening the bolts securing the end blocks on either end of the conveyor, and moving the end blocks using the adjustment screws in the adjustment blocks.

After adjusting any end block, the following procedure should be performed prior to running the conveyor system:

1. Tighten the bolt securing the end block.
2. Back off the adjustment screws so their ends are recessed into the adjustment block.
3. Loosen the bolt securing the adjustment block, slide the adjustment block forward against the end block, and retighten the adjustment block bolt.
4. Secure the adjustment screws by screwing them into the adjustment block until they are tight against the end block.

Belt Change Procedure

To change an endless conveyor belt, the following procedure should be performed:

1. Turn the power to the conveyor off and disconnect the power supply.
2. Remove any peripheral equipment (mounting brackets, large side rails, etc.) that may inhibit belt removal.

3. Loosen the take-up roller adjustment screws enough to disengage the adjustment pins from the take-up shaft.
4. Remove the front, rear and bottom guard plates from the center drive module.
5. Remove the center drive side plate opposite the motor.
6. The old belt can now be removed, and the new belt put in place. Be sure to position the belt properly around the rollers.
7. Reinstall the side plate. Make sure the rollers are properly seated in the side plate.
8. Reinstall the guard plates.
9. Seat the adjustment pins in the take-up shaft, and tighten the take-up roller adjustment screws to correctly tension the belt. Initial tension should be .25%.
10. Reconnect the power, and run the conveyor to make sure the tracking and tension are set correctly. If not, adjust them accordingly.

If the conveyor belt is spliced by means of a mechanical fastener, the belt can be changed by removing the splice in the old belt, connecting the new belt to the old belt and pulling the old belt from the conveyor. This will properly lace the new belt around the pulleys and return rollers. Remove the old belt from the new, connect the ends of the new belt, and adjust tension and tracking as necessary.