MAINTENANCE INFORMATION
END 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.

The motor should not be installed to drive the entrance end of the conveyor. We cannot guarantee the reliable operation of a conveyor with the motor installed in this manner.

Some gearmotors have a plastic plug sealing the 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 and tracking can be adjusted by loosening the bolts securing the end blocks on the idler end, and moving the end blocks with the adjustment screws in the adjustment blocks.

Belt tension and tracking should be adjusted at the idler end of the conveyor only. The end blocks on the drive end of the conveyor should not be moved. Both sides of the idler end may have to be adjusted in order to ensure proper tracking.

WARNING: DO NOT ADJUST THE DRIVE END OF THE CONVEYOR FOR TENSION OR TRACKING. This will cause improper alignment of the drive assembly, which may result in damage to the conveyor system.

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 mounting screws for the idler end blocks and adjustment blocks, and move the end blocks back as far as they will go.
4. The old belt can now be removed, and the new belt installed. To remove or install some belts, it may be necessary to remove the idler pulley. This may be done by removing either idler end block, and sliding the idler pulley out the side of the conveyor. Change belts and reinstall pulley and end block.
5. Adjust the idler end blocks to correctly tension the belt. Initial tension should be set at .25%.
6. Reinstall any peripheral equipment removed earlier.
7. 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.