Ladder-Track™ Maintenance Guide

Straight Running Belts

The following is a general guide to help prevent downtime during production and maximizing the life of the belting.

Daily Check (Visual):

- Inspect drive shaft to make sure that the belt is engaging in the drive sprocket teeth and that no belt slip is occurring.

- Check all Idle shafts to ensure belt is locating correctly in the conveyor center.

- Check there is adequate clearance between the edge links and the side faces of the sprockets & blanks.

- Check that the belt is not over tensioned. There should be a catenary slack loop or gravity weighted take up showing low tension. Tension should only be enough to ensure correct belt & sprocket engagement at the drive without slipping under product loading conditions.

- Check that any adjacent conveyors are not interfering with the ladder belt operation.

- Check for any debris build up on sprockets, blanks, belting or conveyor frame and remove as necessary.

- Excessive product loading

Weekly Check:

- Check condition of all wear strips and replace any that are damaged or worn.

- If there are free rotating blanks or sprockets on any fixed shaft in circuit ensure that they are free rotating and not sticking.

- Check condition of belt and replace any sections that are damaged, worn or distorted.

Monthly Check:

- Check sprockets and rollers are in the original set up position and adjust if necessary.

· Check condition of all sprockets and rollers for wear. Replace as necessary. If sprocket teeth are badly worn causing belt slip replace immediately.

· Check all conveyor bearings are free rotating. Replace ceased or damaged bearings immediately.

· Check and re-grease all conveyor bearings as required.

· Check any chain drive arrangement from geared motor to belt drive shaft and adjust tension if necessary.

· Check that the belt take-up mechanism is working correctly.

· Check belt speed is operating at the minimum to obtain required production.

· Check condition of conveyor frame to ensure belt edge is not rubbing.