

## PREVENTIVE MAINTENANCE CHECKLIST

**NOTE:** the information contained in this checklist is provided only as an aid to our customers. It is not intended to serve as a comprehensive list of preventive maintenance measures.

### ELONGATION INSPECTION

- Ensure the belt remains engaged with the sprockets while running.
- Ensure the proper amount of catenary sag in the returnway.
- If the belt does not remain engaged or the amount of catenary sag is larger than the recommended 6 in (152 mm) maximum depth, adjust the belt length.
  - Shorten the belt by removing rows in even numbers (2, 4, etc.) to maintain the proper bricklay pattern.
  - Remove the minimum number of rows needed to maintain the proper amount of catenary sag.
- If the belt does not remain engaged after adjustments, it may be worn past the pitch elongation limit and require belt sprocket replacement.

### BELT SURFACE AND EDGE WEAR INSPECTION

- Inspect the belt surface for deformation, cracks, scratches, or grooves.
- Inspect the belt edge for shavings, dust, or cracks.
- Inspect the belt for broken modules.
- Inspect the belt surface and edges for discoloration that cannot be attributed to the conveyed product.
- If wear patterns are identified, inspect the conveyor frame for catchpoints, sharp edges, locked shafts and rollers, or other objects that are rubbing against the belt.
- If stress cracking, brittleness or discoloration are present, confirm chemical compatibility.

### DRIVE SPROCKET AND IDLE SUPPORT WHEEL INSPECTION

- Inspect the drive sprocket profile and the bore for wear.
- Ensure all sprockets and support wheels are secured and proper spacing is maintained according to design recommendations.
- If sprocket disengagement occurs, inspect the timing of the sprocket teeth to ensure they are aligned across the belt width.

### FLIGHT INSPECTION

- Inspect flight bases for cracks across the width and indent edge.
- Inspect flight tips for wear.
- Inspect vertical flight sides for wear.
- If wear patterns are identified, inspect the conveyor frame for catchpoints, sharp edges, or other objects that are rubbing against the belt.

### WEARSTRIP INSPECTION

- Inspect wearstrips for uneven wear and embedded foreign debris.
- Ensure wearstrips are in place and properly secured along the length of the conveyor.
- Ensure leading and trailing wearstrip edges have a radius or chamfer.

### CATCHPOINT INSPECTION

- Inspect for snags or catchpoints throughout the entire system.

