

MODULAR BELT INSTALLATION, MAINTENANCE AND TROUBLESHOOTING

Complete guide for installing, maintaining, and troubleshooting modular plastic conveyor belts.

INSTALLATION, MAINTENANCE & TROUBLESHOOTING MANUAL

1. Pre-Installation

- ☐ Verify belt dimensions match conveyor frame
- ☐ Inspect sprockets — correct pitch, tooth count, material
- ☐ Check wear strips — flat, properly spaced, correct material
- ☐ Confirm shaft alignment — parallel within 0.5mm
- ☐ Have connecting rods and tools ready

2. Installation Steps

- Place belt onto conveyor — start at tail (idler) end
- Engage belt with tail sprockets
- Run belt over wear strips to drive sprockets
- Engage belt with drive sprockets
- Bring belt ends together
- Insert connecting rod through hinge eyes
- Secure connecting rod — crimp ends or install end caps
- Set tension — remove slack only
- Install side guards and tracking guides
- Run unloaded 15 minutes — verify tracking

3. Maintenance Schedule

FREQUENCY	TASK
Daily	Visual inspection, remove debris, check for damage
Weekly	Clean belt surface, check sprocket engagement, verify tracking
Monthly	Inspect wear strips, check belt tension, clean sprockets
Quarterly	Remove belt for deep cleaning, inspect sprocket teeth, check shaft alignment
Annually	Complete belt assessment, sprocket replacement planning

4. Troubleshooting Guide

PROBLEM	CAUSE	SOLUTION
Belt tracks to one side	Sprocket misalignment, uneven wear, shaft not parallel	Re-align sprockets and shafts, replace worn wear strips
Belt tension too high	Over-tensioned, thermal expansion	Adjust take-up, leave slight slack
Excessive noise	Worn sprockets, dry wear strips, loose components	Replace sprockets, lubricate wear strips, tighten hardware
Premature wear	Wrong material, abrasive product, high load	Select harder material, install scraper, reduce load
Belt cracking	Cold temperature, UV exposure, aging	Switch to cold-rated material, replace belt
Product contamination	Belt wear particles, hinge debris	Switch to open-hinge or Positive-Drive belt
Sprocket teeth skipping	Worn sprockets, belt stretched	Replace sprockets, check belt elongation
Belt won't track straight	Clogged sprockets, buildup in hinge area	Clean sprockets and belt, install scraper

5. Belt Repair

1. Identify damaged section — assess if repair or replacement needed
2. Remove connecting rod at nearest joint to damage
3. Remove damaged section of belt
4. Replace with new section of same pitch and material
5. Re-install connecting rod
6. Verify sprocket engagement on repaired section
7. Run unloaded to verify smooth operation

MAINTENANCE SUPPORT

Uniking Canada supplies replacement belts, sprockets, and wear strips.

info@unikingcanada.com