

TABLE TOP CHAIN PREVENTATIVE MAINTENANCE GUIDE

Maintenance guide with engineering notes — inspection intervals, wear measurement, and chain tension procedures for table top chains.

With Engineering Notes

1. Maintenance Schedule

FREQUENCY	TASK	ENGINEERING NOTES
Daily	Visual inspection, remove debris, listen for noise	Unusual noise often indicates sprocket wear or debris in hinge
Weekly	Check chain tension, clean sprockets, inspect belt surface	Excessive tension causes premature wear; insufficient causes tracking issues
Monthly	Measure chain elongation, inspect wear strips, check sprocket teeth	Elongation >2% requires replacement planning
Quarterly	Deep clean belt and sprockets, check shaft alignment, inspect bearings	Misaligned shafts cause uneven sprocket wear – correct early
Annually	Complete system assessment, sprocket and wear strip replacement planning	Plan budget for replacement based on wear trend analysis

2. Chain Tension Procedure

1. Stop conveyor and lock out
2. Measure belt length between sprocket centers on the slack side
3. Lift belt at midpoint — deflection should be 10-15mm for every meter of span
4. If deflection is excessive, adjust take-up to reduce slack
5. If deflection is insufficient (belt too tight), loosen take-up
6. Verify belt can be lifted 5-10mm at any point (confirms not over-tensioned)
7. Re-check after 24 hours of operation — initial settling occurs

3. Sprocket Inspection

Visual Checks

- ☐ Teeth show even wear pattern — no one-sided wear
- ☐ No hooked or curled tooth tips
- ☐ No chipped or broken teeth
- ☐ Sprocket face is clean — no material buildup
- ☐ Sprocket is properly secured to shaft — no wobble

Measurement

CHECK	METHOD	REPLACE AT
Tooth profile	Compare to new sprocket or template	15% profile change
Tip wear	Measure tip thickness	20% reduction
Root depth	Measure root depth	10% increase
Bore wear	Measure bore diameter vs shaft	0.1mm clearance increase

4. Wear Strip Assessment

CONDITION	ACTION
Surface smooth, minor wear marks	Continue in service
Light groove (<0.5mm)	Monitor – plan replacement
Deep groove (0.5 – 1mm)	Replace at next maintenance window
Groove >1mm or stepped joints	Replace immediately
Heat discoloration	Replace and investigate friction cause

5. Common Engineering Issues

ISSUE	ENGINEERING EXPLANATION	FIX
Belt walks to one side	Uneven friction or sprocket offset	Align sprockets, check wear strip height
Belt surges or jerks	Stiff links or sprocket damage	Find and replace stiff link, inspect sprocket
Excessive wear at edges	Chain rubbing on guide or frame	Check clearance, adjust side guides
Product slides on belt	Wrong surface material or contamination	Switch to friction top, clean belt surface

MAINTENANCE SUPPORT

Uniking Canada provides maintenance planning and replacement parts.

info@unikingcanada.com