

LADDER-TRACK BELT MAINTENANCE GUIDE

Maintenance procedures for ladder-track conveyor belts — cleaning, inspection, and component replacement.

1. Maintenance Schedule

FREQUENCY	TASK
Daily	Visual inspection, remove debris, check tracking
Weekly	Clean belt thoroughly, inspect connecting rods, check sprocket teeth
Monthly	Measure belt tension, inspect belt edges, check for wire breakage
Quarterly	Deep clean with appropriate cleaner, inspect all sprockets, check shaft alignment
Annually	Complete belt assessment, plan replacement

2. Cleaning Procedure

1. Stop conveyor and lock out
2. Remove loose debris with brush or compressed air
3. Apply food-grade cleaner (if food application) or appropriate solvent
4. Allow cleaner to dwell 5-10 minutes
5. Scrub belt surface — pay attention to cross-rod intersections
6. Rinse thoroughly with hot water (up to 80°C for stainless belts)
7. Allow belt to dry before restarting
8. Run unloaded 5 minutes to verify cleaning was complete

3. Wire Breakage Inspection

- ☐ Inspect all cross-rods — look for breaks or cracks
- ☐ Check longitudinal wires — no broken or bent sections
- ☐ Inspect weld points — no cracking or separation
- ☐ Check edge loops — not deformed or broken
- ☐ Count broken wires — if more than 5% of total, plan replacement

4. Connecting Rod Replacement

1. Identify damaged connecting rod
2. Remove end cap or straighten bent tab
3. Slide damaged rod out of belt edge loops
4. Insert new rod through edge loops
5. Secure with end cap or bend tab to lock in place



6. Verify rod is fully seated and secured

5. Wear Limits

COMPONENT	REPLACE AT
Cross-rod diameter	15% reduction from original
Wire diameter (any)	20% reduction
Sprocket teeth	When hooked or profile changed 20%
Belt elongation	3% total elongation
Broken wires	5% of total wire count
Weld failures	Any visible cracking at weld points

MAINTENANCE SUPPORT

Uniking Canada supplies replacement rods, sprockets, and complete belts.

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