

Preventative Maintenance Checklist

1. Low Tension Inspection

- Ensure belt setup (including catenary sag) is low tension -- NOT tensioned or pre-tensioned.
- Confirm that belt can be moved laterally on the drive/idle shaft.
- Confirm that belt has one or more areas for returnway accumulation (due to load or temperature).

2. Field/Factory Splices Inspection

- Look for cracks, voids, or signs of failure.
- Confirm that belt edges at splice are flush.
- Confirm that splice beads have been removed from edge and surface (top & bottom).

3. Surface and Belt Edge Wear Inspection

- Inspect surface for deformation, cracks, scratches or grooves.
- Inspect belt edge for shavings, blue dust or cracks.
- Inspect surface and edge for belt discoloration.
- If wear patterns are identified: Inspect the conveyor for catch points, sharp edges, etc.

4. Drive Bar Inspection

- Inspect drive bar for wear.

5. Drive Sprocket and Idle Support Wheel Inspection

- Inspect tooth profile and bore for wear.
- Ensure that all sprockets and support wheels are locked down and are maintaining recommended spacing.

6. Position Limiters Inspection

- Ensure that all limiters are in line with sprockets.
- Inspect limiters for proper clearance -- limiters should touch, but not pinch, the belt.
- Inspect limiters for wear or embedded foreign objects.
- Ensure that limiter fasteners do not come into contact with moving belt or accessories.

7. Flight Inspection

- Inspect flight base for cracks (across width and indent edge).
- Inspect flight tips for surface wear.
- Inspect vertical flight sides for surface wear.
- If wear patterns are identified: Inspect the conveyor for catch points, sharp edges, etc.

8. Belt Support Inspection

- Inspect belt supports for wear patterns or embedded foreign objects.
- Ensure that all wearstrips are still on the conveyor and are properly secure.

9. Removable Retaining Walls Inspection

- Ensure that flights are not dragging against the removable retaining walls.
- Ensure that there is proper clearance above the belt surface so that the belt is not being pinched.
- Inspect belt containment guides for proper clearance.

10. Belt Guide Inspection on Flat Flush Belt Conveyors

- Inspect belt containment guides for unusual wear patterns or dust.
- Ensure that the belt containment guides are properly secure and in place.
- Inspect belt containment guides for proper clearance.

11. Snag Point Inspection

- Look for any noticeable snags or catch points throughout the entire conveyor system.

NOTE: Run conveyor at production temperatures to ensure smooth belt operation. Refer to steps 1-11 if you identify vibration, clicking or sprocket disengagement.