Conveyor Tensioning and Belt Change out Instructions

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A. Tensioning (procedure is identical but reverse for removing tension from the belt)

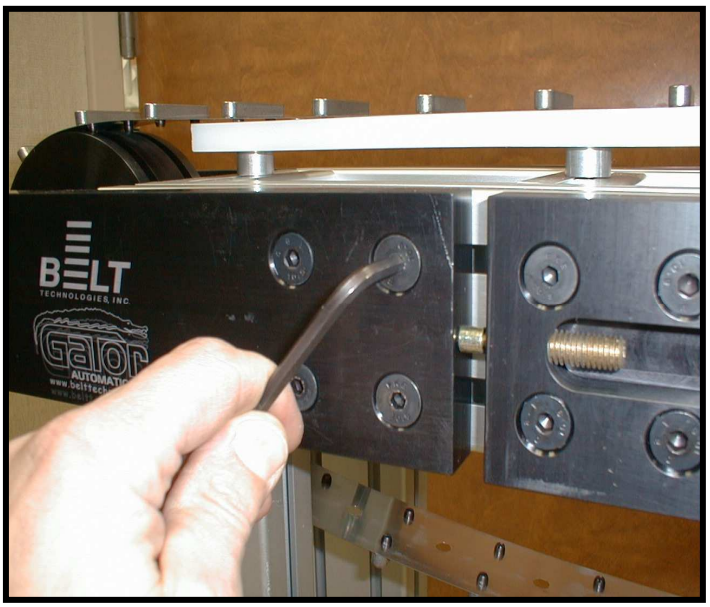


Figure 1

1. On the driven side of the conveyor, loosen the flathead screws on the shaft holder on both sides of the unit. This will allow the idler unit to move to change belt tension. See Figure 1 above.

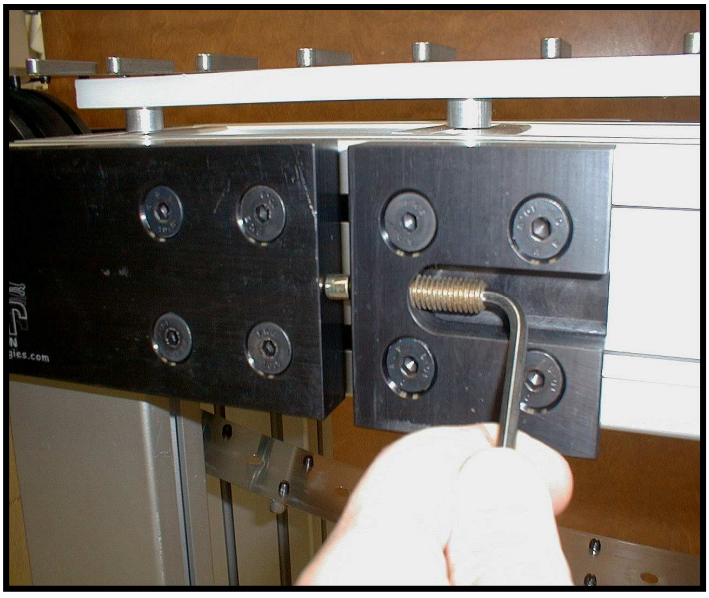


Figure 2

2. Increase (decrease) belt tension by adjusting the swivel head screw. See Figure 2 above. Accomplish this on both sides of the idler unit to maintain equal pressure on both shaft holders. Depending on the belt type installed on the conveyor, the tension value is as follows,

- Friction drive belt 2000 – 5000 psi per strand
- Timing drive belt 1000 - 2000 psi per strand
- Metrak belt 1000 - 2000 psi per strand
- Flanges used to Guide belt 1000 - 2000 psi per strand

B. Belt Tracking

1. Belt tracking is accomplished by increasing or decreasing the tension of one edge of the belt in relation to the other edge to steer the belt.

   The process of increasing or decreasing tension on one belt edge is similar to tensioning the belt as shown above. If the belt is off tracking to one side of the pulley, the side that the belt is moving towards is the side where tension is increased.

   Referring to Figures 1 and 2 above, loosen the flathead screws on the shaft holder where the belt is tracking towards. Increase tension by adjusting the swivel head screw in towards the shaft holder. Belt tracking should respond in the opposite direction of the increased tension side. You may need to make further adjustments to increase or decrease tension to stabilize the belt.

C. Belt Replacement

1. Regardless of whether the conveyor was supplied with legs or without legs for mounting, belt tension must first be removed after the unit has been powered down.

2. Remove tension from the belt on both shaft holders per the above procedure for belt tensioning.

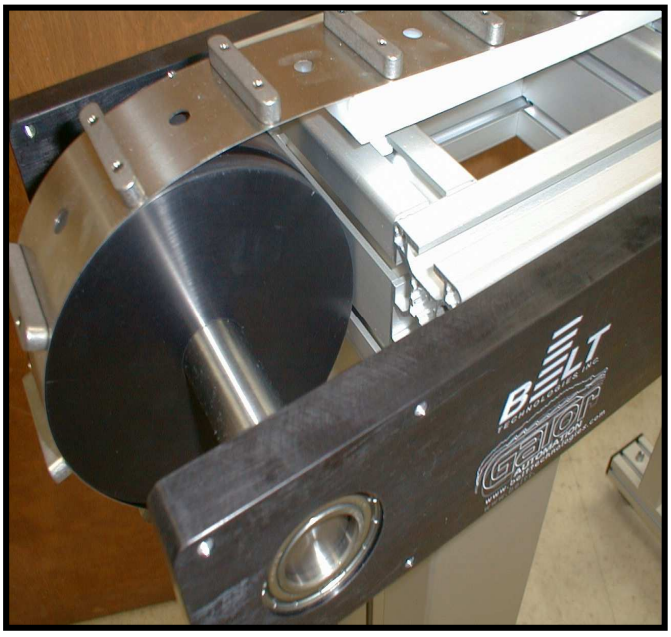


Figure 3

3. Refer to the Figure 3 above. On the drive end of the conveyor, loosen the flathead screws for both the shaft holder and tension block on both sides of the frame on the drive end of the conveyor. Move the driven assembly such that the idler pulley is in contact with the framing.

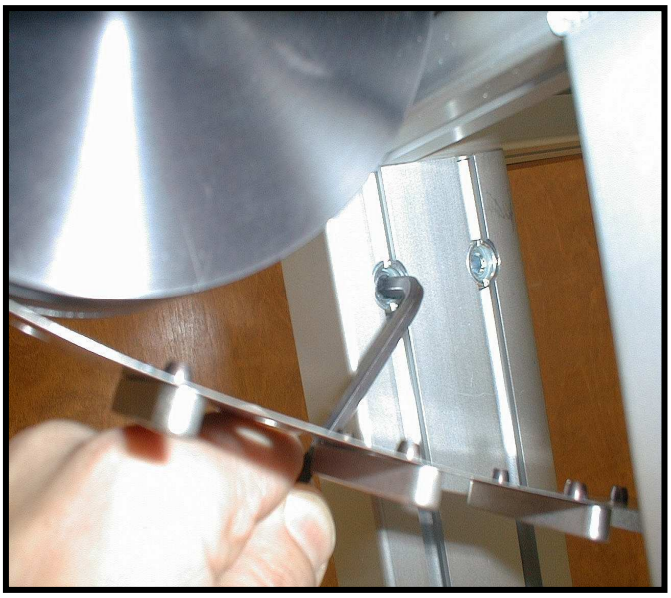


Figure 4

4. For conveyors with legs, refer to Figure 4 above. Loosen the setscrews on the universal connectors for one leg on the conveyor. Typically, there will be two connectors adjacent to the frame and two additional connectors at the bottom of the leg.

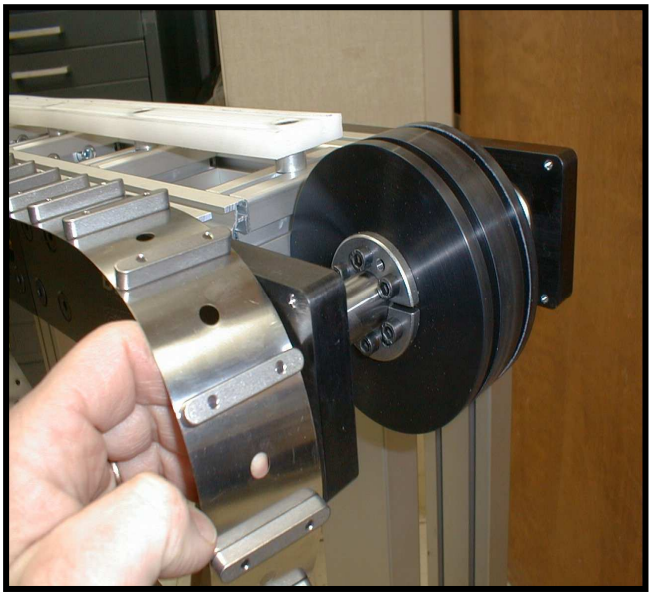
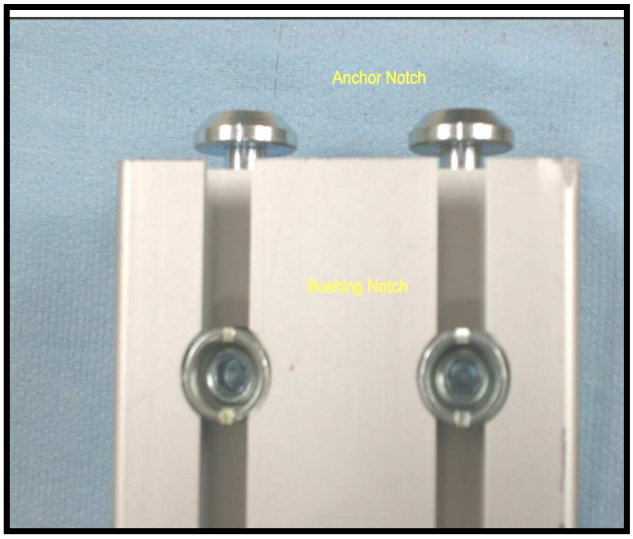


Figure 5

5. Referring to Figure 5 above, remove the leg and slip the belt off the idler pulley and around the shaft holder. Let the belt drape down and reinstall the leg on the driven side to provide rigidity so this procedure can be duplicated on the driver side of the conveyor.

6. Repeat step 4 on the same side driver end to completely remove the belt from the conveyor.



7. Refer to Figure 6 above. Prior to the reinstallation of the leg, insure the notch on the anchor is in line with the notch on the bushing.
8. Install the new belt on the drive side and re-install the leg on the framing. Tighten the set-screws for the universal connectors to reaffix the leg to the frame.

9. Remove the leg on the driven side and install the belt over the idler pulley. Reinstall the leg and tighten the setscrews on the universal connectors for the leg.

Figure 7

10. Remove the slack in the belt by moving the idler assembly outward and then tighten the flathead screws on the tension blocks on both sides of the frame.

11. Re-tension the belt per procedure A above.