

Trouble Shooting Guide

Problem	Possible Cause(s)	Solution(s)
Splice clips breaking	<ul style="list-style-type: none"> • European style sprocket arrangement used (sprockets in even spaces) • Belt improperly spliced • Clips and/or strands not straightened after splicing • Sprockets not properly installed/aligned • Uneven tension 	<ul style="list-style-type: none"> • Adjust to American style arrangement (sprockets in odd spaces) • Reinstall following splicing instructions • Straighten clips/strands with pliers • Check sprocket alignment and adjust if needed • Adjust tension so it is equal on both sides of frame
Belt surges	<ul style="list-style-type: none"> • Belt surges • Belt not supported on frame • Load too high • Uneven product loading • Wrong type of wear strips 	<ul style="list-style-type: none"> • Install supports on return path • Change to heavier mesh belt • Correct loading method • Change to different type / material / design / wear strip
Excessive wear strip wear	<ul style="list-style-type: none"> • Abrasive cleaner used • Load too high • Not enough wear strips • Wrong type of wear strips 	<ul style="list-style-type: none"> • Install spray wash on belt to reduce grit build up • Change to heavier mesh belt • Install more wear strips • Change to different type / material / design / wear strip
Damage to flights	<ul style="list-style-type: none"> • Product jamming on loader • Flights getting caught on frame support • Flights rubbing on return path 	<ul style="list-style-type: none"> • Check hopper/chute in-feed sides and correct jamming • Check for obstructions on frame and correct • Allow sufficient clearance with frame; indent flights
Belt edges curling up	<ul style="list-style-type: none"> • Belt edges curling up • High temperature • Too much tension • Belt joints unsupported • Load too high 	<ul style="list-style-type: none"> • High temperature • Too much tension • Belt joints unsupported • Load too high • Use crowned belts (a specialty belt); Call Technical Support at 800-922-2637 or 603-644-2500 for information and pricing • Adjust tension take-up • Adjust sprockets/blanks/rollers to within 3/16" of Z-bends • Change to heavier mesh belt
Belt not tracking properly	<ul style="list-style-type: none"> • Sprocket teeth misaligned • Conveyor frame not square • Support rolls not squarely aligned • Drive shaft not aligned • Uneven product loading • Belt improperly spliced • Belt is "wrong side up" 	<ul style="list-style-type: none"> • Check alignment and adjust • Realign conveyor frame • Realign support rolls • Realign following alignment instructions • Correct loading method • Reinstall following splicing instructions • Reinstall belt with smooth side up
Belt runs to one side	<ul style="list-style-type: none"> • Sprocket teeth misaligned • Conveyor frame not square • Support rolls not squarely aligned • Transfer roll not functioning properly • Drive shaft not aligned • Uneven product loading • Uneven tension • Belt improperly spliced 	<ul style="list-style-type: none"> • Check alignment and adjust • Realign conveyor frame • Realign support rolls • Change to grooved end roll • Realign following alignment instructions • Correct loading method • Adjust tension so it's equal on both sides of frame • Reinstall following splicing instructions



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Belt wears edges	<ul style="list-style-type: none"> • Not enough clearance • Conveyor frame not square • Shafts not locked down • Sprocket teeth misaligned • Belt expansion from high temperature 	<ul style="list-style-type: none"> • Adjust clearance between belt edge and on side rail • Realign conveyor frame • Use collars on outside of bearings to prevent lateral shifting • Check alignment and adjust • Adjust clearance between belt edge and side rail to allow for heat expansion
Belt slips on sprockets	<ul style="list-style-type: none"> • Insufficient tension • Sprockets not properly installed/aligned • Worn sprockets • Drive sprockets too small • Insufficient belt wrap 	<ul style="list-style-type: none"> • Adjust tension take-up • Check sprocket alignment; adjust if needed • Replace sprocket • Replace with larger diameter sprockets from Wire Belt, or increase wrap • Increase wrap around drive sprockets up to between 120° to 180°
Belt blackening	<ul style="list-style-type: none"> • Frozen/stuck roller • Too much tension • Load too high • Improper/inadequate cleaning 	<ul style="list-style-type: none"> • Free roller; reduce or eliminate steel-to-steel contact • Adjust tension take-up • Change to heavier mesh belt • Install continuous spray cleaning device on conveyor
Excessive belt wear or poor belt life	<ul style="list-style-type: none"> • Contact with other equipment • Support rolls not rotating • Too much tension • Uneven tension • End roll/reverse bend too small • Wrong type of wear strip • Abrasive cleaner used • Load too high • Speed too high • Belt improperly spliced • Frame not level 	<ul style="list-style-type: none"> • Eliminate contact • Check bearing and replace if needed • Adjust tension take-up • Adjust tension so it is equal on both sides of frame • Check chart pg. 4 for min. diameter • Change to a different type/material/design/wear strip • Install spray wash on belt to reduce grit build up • Change to a heavier mesh belt • Reduce running speed • Reinstall following splicing instructions • Correct affected area
Excessive sprocket wear	<ul style="list-style-type: none"> • Too much tension • Abrasive cleaner used • Sprocket teeth misaligned • Not enough drive sprockets • Sprockets not properly installed/aligned • Load too high • Belt speeds too high • Shaft(s) bent 	<ul style="list-style-type: none"> • Adjust tension take-up • Install spray wash on belt to reduce grit build-up • Check alignment and adjust • Add more sprockets • Check sprocket alignment and adjust if needed • Change to heavier mesh belt • Reduce speed • Check shafts and replace if needed
Belt jumps on sprockets	<ul style="list-style-type: none"> • Worn sprockets • Wrong size sprockets • Belt is "wrong side up" • Product build-up between belt and sprockets • Too much tension 	<ul style="list-style-type: none"> • Replace using Wire Belt sprockets • Replace with correct S.P.F. (strands per foot) and sprocket dimensions • Reinstall belt with smooth side up • Install wiper on return belt to prevent product getting trapped; install side guards on frame • Adjust tension take-up

