Solutions for your Conveying Applications

INSTRUCTIONS FOR: BELT REPLACEMENT, TENSIONING & TRACKING CENTER DRIVE CONVEYORS

Belt Removal & Replacement
⇒ Observe current tension on the belt before removing.
⇒ Remove the belt.
   1) Remove Nip and Tension Rollers from Center Drive (See Figure 1)
   2) On the entrance end of the conveyor loosen alignment blocks and idler holders, slide idler holders toward center of conveyor to shorten conveyor. (See Figure 2)
   3) On the exit end loosen idler holders, slide idler holder toward center of conveyor to shorten conveyor.
   3) Tip Conveyor to motor side and remove side rail brackets and leg stand brackets
   4) Slide old belt off.
   5) Install new belt on conveyor.
   6) Re-install the Nip & Tension Rollers
   5) Follow instructions for tensioning and tracking below.

Belt Tensioning
⇒ Tension the belt.
   1) Push idler holders out to set conveyor length and apply initial tension on belt.
   2) Retract tensioning screws in alignment blocks until end of screw is flush with end of block. Slide alignment blocks on both sides forward until they meet the idler holder.
   3) Tighten alignment blocks to extrusion.
   4) Turn tensioning screws clockwise (even distance) on both to keep both ends of the conveyor square.
   5) Adjust overall tension of the belt by adjusting the center tension roller. Turn tensioning screws clockwise (even distance) on both sides to adjust overall tension on the belt.

Belt Tracking
⇒ Tracking the belt.
   1) Turn conveyor on and belt may drift to one side.
   2) Adjust the center drive roll tensioning screws so the belt enters the drive centered.
   3) Move to the entrance end of the conveyor.
   3) Start tensioning the belt on the side the belt drifts to.
   4) Turn tensioning screw clockwise (1/4 turn increments) and observe belt movement.
   5) Let conveyor belt make several revolutions to determine the reaction to the adjustment.
   6) Continue to track belt from both sides until the belt remains in the center of the conveyor.
   7) Note slower speed conveyors will have a slower response to tracking. Note variable speed conveyors should be turned up to their highest speed when tracking.
   8) Once the belt is tracked tighten all fasteners.
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Figure 1

Belt Travel
Nip Roller
Entrance End
Center Alignment Block
Tension Roller

Figure 2

Entrance End
Idler Holder
Tension Screw
Alignment Block
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