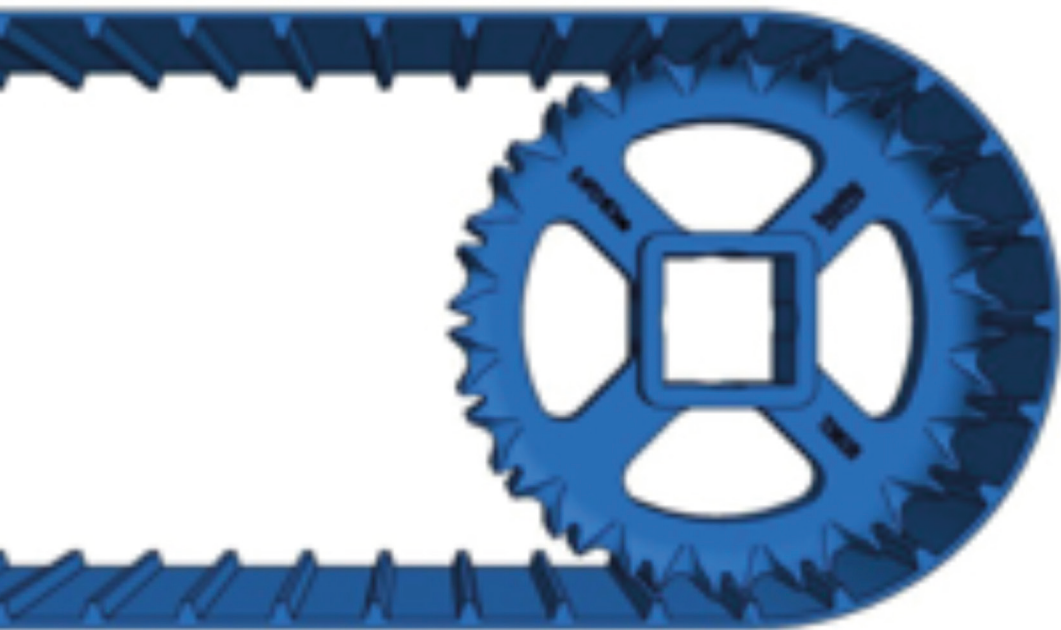




Trouble Shooting

ThermoDrive Belt



Problem	Possible Cause	Solution
Belt not running straight	Belt is running under tension	Remove tensioning device and run the belt loose.
	Belt is insufficiently contained	Check that removable retaining walls are properly seated. On flat conveyors, make sure belt is running under belt containment guides
	Conveyor frame and/or components are not level or square	Adjust conveyor frame. Check shaft alignment after any adjustment of frame.
	Sprockets are not aligned correctly on the shaft	Check sprocket alignment by laying straight edge parallel to the shaft at the base of any tooth on the sprocket to make sure that all sprockets are in the same position across the belt.
	Return rollers are not level or square to conveyor frame	Inspect and correct any return roller that is not level or square with conveyor frame.
Belt not engaging with drive sprockets	Position limiters are not installed, or are installed with too large of a gap	Install limiters in the correct position, maintaining the proper gap between the seated belt and the limiter.
	Belt is running under tension	Remove tensioning device and run the belt loose.
	Sprockets are not aligned correctly on the shaft	Check sprocket alignment by referencing the alignment nub located inside one gullet of the molded sprockets, or by laying straight edge parallel to the shaft at the base of any tooth in the sprocket to make sure that all sprockets are in the same position across the belt.
Excessive belt wear	Belt is running under tension	Remove tensioning device and run the belt loose.
	Belt is too wide for the conveyor dimensions	Replace with a belt that has been trimmed to the correct dimensions (typically 0.25 in (6 mm) trimmed from each side of the belt.
	Binding of belt in conveyor frame	Check conveyor frame to ensure it is level and square. Other considerations 1) Frame/sidewall warpage 2) Removable retaining walls are seated properly 3) Belt is running under belt containment guides on flat conveyor 4) Belt too wide
Sprockets move laterally to center or edge of belt	Retainer rings are not properly utilized or are missing	Replace missing rings and/or add rings as necessary.



Problem	Possible Cause	Solution
Flight wear or damage	Flights contacting obstructions on conveyor frame, returnway or adjacent equipment	Eliminate obstructions to the flight travel. Check the conveyor frame to ensure it is level and square. Correct any conditions causing belt to rub or bind. Inspect for proper belt containment. Flights should never be used to contain lateral belt movement. Check for proper belt containment and clearance at the position limiter.
	High impact in infeed area	Reduce or eliminate impact on belt by adding an "impact plate" above belt to absorb initial shock. Mount plate at an angle that will direct impacting piece gently onto the belt. Other solutions include using short flights, adding full sliderbed support at the point of impact and chamfering the flight edges.
	Improper flight support on returnway	Flighted belts should be supported on each side of belt (on the "indent") and as needed across the belt width. It is recommended that flighted belts should be supported with continuous rails on the belt indents. A center support may be required depending on the width of the belt and size of application.
Failed splice	Incorrect installation of lacing rod	Lace the belting together ensuring proper alignment. Flex the rod retention feature upward using your thumb while inserting the rod into the lace with your other hand. Insert the rod into the lace. Continue to push the rod into the lace until it goes no further. Proper rod retention is achieved by flexing the retention feature downward, so that it blocks the rod.
	Belt is running under tension	Adjust the tailstock plates to achieve catenary sag(s) in designated area(s).

Important Notes

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