Section III. Assembly & Installation Instructions

# Belt Tracking

Proper belt tracking is very important to the life of the belt. Even conveyors with V-guide have to be monitored for proper belt tracking. If a belt is left to run improperly tracked, the belt can rub against the frame causing damage to the edges of the belt, or cleats can rub against the side rails causing them to break or tear loose from the belt. Also, the V-guide on the back of the belt can be worn or torn from the belt due to improper tracking.

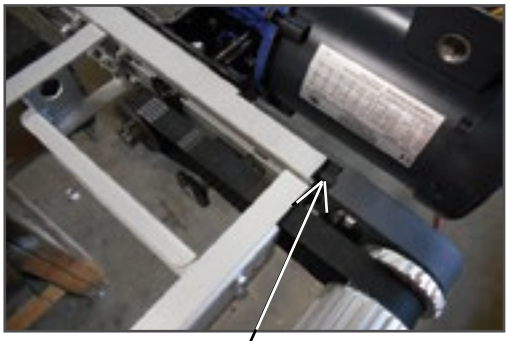
## ⚠ CAUTION

Do not leave foreign articles laying on the conveyor. They could cause injury by distracting or hitting the operator. They could cause the equipment to malfunction by shorting an electrical circuit or jamming the equipment.

## ⚠ WARNING

NEVER over-tighten the belt. Too much tension will damage conveyor components.

(Fig. D1)




(Fig. D2)

(Fig. D3)

1. Before turning the conveyor on, make sure it is cleared of anyone or anything that might be on the conveyor. Determine the adjustment points on your conveyor. Tracking on the drive end can be accomplished by either tightening or loosening the adjustment opposite the motor. (Fig. D1)

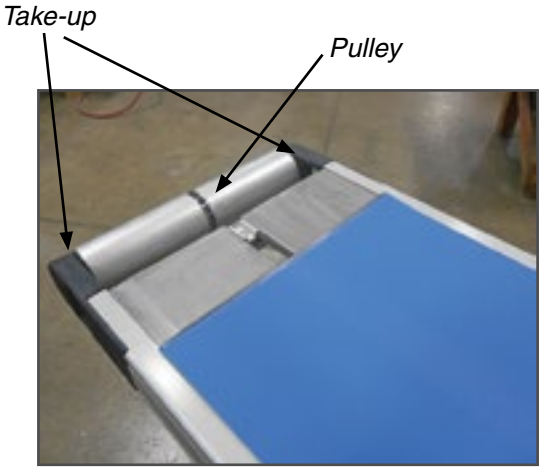
**This adjustment should be completed in moderation to avoid changes to internal drive belt.**

**NEVER use the motor side at the drive end for belt tracking. (Fig. D2)**

2. On the tail pulley end (pulley opposite drive end), the belt can be tracked from either side of the conveyor. Belt tension should determine if you track the belt by loosening or tightening the adjusting bolt at this end of the conveyor. Too much belt tension can damage conveyor components. If the belt is running off toward the motor on the drive end, loosen the adjusting bolt to let the belt track back over. If the belt is running toward the opposite side of the motor on the drive end, tighten the adjusting bolt to force the belt back over. (Fig. D3)

Section III. Assembly & Installation Instructions

## Belt Tracking




(Fig. D4)

3. ANY adjustment should be done GRADUALLY. If the belt is running off to one side at the tail end of the conveyor, you can either tighten the side that it is running toward to force the belt back over, or loosen the opposite side to let the belt track back over. Again, belt tension will determine which side to adjust. (Fig. D4)

4. The belt is properly tensioned when it will pull the load on the belt without slipping on the drive pulley.

Weight limits are based on model type:

EAF = 100lb max load

EAC = 100lb max load

EAR = 100lb max load

EAK = 50lb max load

EAZ = 50lb max load

| | |
|---|---|
| ***If Belt Tracks to the Left:*** *Tighten the left side or Loosen the right side* | *Make adjustments to the tail end of the conveyor* |
| ***If Belt Tracks to the Right:*** *Tighten the right side or Loosen the left side* | |

5. After any adjustments are made for tracking the belt, let the conveyor make 5 to 10 complete revolutions and check the belt again. Slight movement of the belt position is acceptable if there is no continued drift in one direction.

6. Belt tracking should be closely monitored for the first day of conveyor operation. Watch for any wear on the belt, such as lacing wearing from rubbing the side rails, or the V-guide trying to crawl up on the pulley. Also, check to make sure that the product you are conveying is compatible, such as; sticking to the belt, getting caught under the rails or between cleats and rails, or under the belt. Product getting caught in the conveyor will damage the belt and conveyor components.