

Start-up and preventive-care essentials

Correct sprocket alignment, carryway support and controlled belt slack are central to reliable positive-drive performance.

Before start-up

1 · Verify components

Confirm belt type, width, running direction, sprockets, wear strips, rods and accessories against the project specification.

2 · Inspect the frame

Clean the conveyor and check shaft alignment, support spacing, transfer clearances and freedom from sharp edges.

3 · Align sprockets

Position and secure sprockets as specified while allowing the required lateral movement for thermal expansion.

4 · Join and check

Install the connecting rod correctly, secure retainers, verify catenary sag and rotate the unloaded belt by hand where safe.

Commissioning checks

- Jog at low speed and observe sprocket engagement, tracking, return support and transfer points.
- Increase speed and load gradually while monitoring noise, vibration, belt slack and product stability.
- Reinspect after the first production run and after the belt reaches operating temperature.

Routine maintenance

Record worn or damaged modules, rods, sprockets and wear strips; remove trapped debris; verify shaft and sprocket alignment; and investigate recurring edge wear, jumping or excessive slack before returning the conveyor to full service.

Safety: Lock out and isolate all energy sources before installation, cleaning, inspection or repair. Follow the conveyor manufacturer's instructions and the site's safety procedure.