CONVEYOR BELT PREVENTIVE MAINTENANCE CHECKLIST

NOTE: The information contained in this checklist is provided only as an aid to our customers. It is not intended to serve as a comprehensive list of preventive maintenance measures.

GENERAL PREVENTIVE MAINTENANCE

The following checklist provides general preventive maintenance information to help ensure proper operation of conveyors equipped with Intralox belting.

ELONGATION INSPECTION

- Ensure the belt remains engaged with the sprockets while running.
- Ensure the proper amount of catenary sag in the returnway:
  - Modular plastic belts (MPB): 6 in (152 mm) or more of catenary sag depth.
    - Shorten the belt in even rows (2, 4, etc.) to maintain the proper belt pattern.
    - Remove the minimum number of rows needed to maintain the proper amount of catenary sag.
- If the belt does not remain engaged or the amount of catenary sag is larger than the recommended depth, adjust the belt length.

SURFACE AND BELT EDGE WEAR INSPECTION

- Inspect the belt surface for deformation, cracks, scratches, or grooves.
- Inspect the belt edge for shavings, dust, or cracks. For MPB, also inspect for broken modules.
- Inspect the belt surface and edges for discoloration that cannot be attributed to the conveyed product.
- If wear patterns are identified, inspect the conveyor frame for catchpoints, sharp edges, or other objects that are rubbing against the belt.

DRIVE SPROCKET AND IDLE SUPPORT WHEEL INSPECTION

- Inspect the drive sprocket profile and the bore for wear.
- Ensure all sprockets and support wheels are secured and proper spacing is maintained according to design recommendations.
- If sprocket disengagement occurs, inspect the timing of the sprocket teeth to ensure they are aligned across the belt width.

FLIGHT INSPECTION

- Inspect flight bases for cracks across the width and indent edge.
- Inspect flight tips for wear.
- Inspect vertical flight sides for wear.
- If wear patterns are identified, inspect the conveyor frame for catchpoints, sharp edges, or other objects that are rubbing against the belt.

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WEARSTRIP INSPECTION

- Inspect wearstrips for uneven wear and embedded foreign debris.
- Ensure wearstrips are in place and properly secured along the length of the conveyor.

SNAG POINT INSPECTION

- Inspect for snags or catchpoints throughout the entire system.

THERMODRIVE®-SPECIFIC PREVENTIVE MAINTENANCE

The following checklist provides ThermoDrive-specific preventive maintenance information to help ensure proper operation of conveyors equipped with ThermoDrive belting.

LOW TENSION INSPECTION

- Ensure belt setup (including catenary sag) is low tension—NOT tensioned or pretensioned.
- Ensure the belt has one or more areas for returnway accumulation and belt storage as needed based on the application.
- Ensure the belt is free to move laterally at the drive and idle shafts.

ELONGATION INSPECTION

- Ensure the belt remains engaged with the sprockets while running.
- Ensure the proper amount of catenary sag in the returnway:
  - ThermoDrive belts: 1.5 in per ft (38.1 mm per 305 mm) or more of catenary sag depth.
- If the belt does not remain engaged or the amount of catenary sag is larger than the recommended depth, adjust the belt length.

FLIGHT INSPECTION

- Inspect flight bases for cracks across the width and indent edge.
- Inspect flight tips for wear.
- Inspect vertical flight sides for wear.
- If wear patterns are identified, inspect the conveyor frame for catchpoints, sharp edges, or other objects that are rubbing against the belt.

SYNCHRONIZED SIDEWALL (SSW) INSPECTION

- Inspect SSW tips and sides for wear patterns.
  - Inspect the conveyor for catchpoints, sharp edges, or other objects that are rubbing against the belt.
- Inspect SSW base for separation.
  - If separation exists, contact Intralox Customer Service for assistance.

FIELD AND FACTORY SPLICES INSPECTION

- Inspect for cracks, voids, or signs of failure.

POSITION LIMITERS INSPECTION

- Ensure all position limiters are aligned with sprockets.
- Inspect position limiters for proper clearance. Position limiters will touch but not pinch the belt. Ensure 0.005–0.05 in (0.13–1.25 mm) spacing between the seated belt and the position limiters.
- Inspect position limiters for wear or embedded debris.
- Ensure the limiter fasteners do not contact the moving belt or accessories.
- Ensure all mounting hardware is countersunk.

CONTAINMENT BLOCK INSPECTION

- Inspect containment blocks for unusual wear patterns or blue dust from belt wear.
- Ensure mounting hardware is not rubbing against the belt.
- Ensure containment blocks are in place and properly secured.
- Inspect containment blocks for proper clearance.

CONTAINMENT RAIL INSPECTION

- Ensure flights are not dragging against the rails.
- Inspect containment rails for proper clearance. Containment rails will touch but not pinch the belt.

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