# Field Service Guide for Belting

## TRACKING PROBLEMS

**Belt runs to one side along given point on machine.**

1. Idler or idlers that immediately precede trouble point are not at right angles to longitudinal axis of Advance the end of the idler to which the belt has shifted in the direction of belt travel. Check for belt end squareness to belt centerline.
2. Frozen and sticking idlers
   Lubrication poor, improve general maintenance.
3. Frame of conveyor crooked or idler stand not centered.
   Determine extent of misalignment, then square.
4. Material building up on idlers.
   Check installation of scrapers, or other cleaning devices. Improve general maintenance.

**A single section of the belt tends to run to one side along the machine.**

1. Crooked splice.
   Belt needs re-splicing with ends squared with belt centerline.
2. Crooked end of belt at fasteners, or fasteners not joined squarely.
   Belt should be re-spliced, if possible, using new fasteners.
3. Bow in belt.
   New belt may straighten out as it becomes broken in.

**Wandering Belt**

1. Belt too heavy or stiff for drive rollers.
   Replace with a more flexible belt.
2. Poor loading or off-center loading.
   Change loading procedures.

## WEARING PROBLEMS

**Damaging wear on drive roller side of belt.**

1. Drive roller is slipping.
   Increase take-up, lag drive or increase arc of contact on drive roller with snubber oil.
2. Loading end of belt has buildup of material which is being ground between belt and drive roller.
   Improve belt loading procedures. Install plows or scrapers in front of drive roller on return run. If leakage through fasteners, use belt with flap or vulcanized splice.
3. Idlers are sticking.
   Increase maintenance and lubrication.
4. bolt heads protruding above lagging.
   Replace worn lagging on pulley. Tighten bolts. Cement lagging to pulley.

**Excessive edge wear.**

1. Folding of belt edge on edge guard or frame.
   Consider using more stable construction. Provide more clearance. Smooth any rough areas on
2. Side loading.
   Load in direction of belt travel.
3. Buildup of material on drive roller.
   Install scrapers to eliminate buildup from pushing belt against frame.

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**Top Cover Wear**

1. Return idlers dirty, frozen or misaligned.
   Clean belt; clean and lubricate idlers .. Improve maintenance. May need cleaning device installed. Check alignment of return idlers.
2. Poor loading conditions.
   Correct to feed onto center of belt in same direction as belt runs. Material falling down from delivery chute should be at about same speed as conveyor belt.
3. Sags in belt letting load shift as it passes over idlers.
   Increase belt tension and/or reduce idler spacing.

**Top cover grooved and gouged.**

1. Skirt boards are pressing against belt. Skirt boards are too hard.
   Redesign skirt board to permit material to work out, not in. Change to softer material for skirt board. Do not use reinforced rubber for skirt boards.
2. Space between belt and skirt seals is too great.
   Adjust to minimum clearance and angle to belt to allow material to work itself out.
3. Material jammed at chute.
   Redesign chute.
4. Metal side of chute or skirts too close to belt.
   Adjust so gap between metal and belt increases in direction of travel to avoid jamming.

## BREAKING PROBLEMS

**Breaks in belt parallel to belt edge or star breaks in belts.**

1. Heavy lumps falling on belt or falling from too great a height.
   Reduce impact of material by redesigning loading area.
2. Material lodged between belt and pulley or stuck to back.
   Return run should have scrapers ahead of tail pulley. Check loading design to reduce material

**Breaks in belt parallel to belt edge or star breaks in belts.**

Belt fasteners too large for drive roller size being used.
Replace with manufacturer's recommended fasteners.

**Transverse breaks at belt edge.**

1. Folding up of belt edges.
   Improve tracking. Increase lateral clearance. Redesign of belt construction may be required.
2. Belt is mildewed.
   Use belt with polyester or nylon fabrics and mildew inhibitor in rubber compounds. All WCCO belting have synthetic fabrics and contain mildew inhibitors.
3. Idler next to drive roller is located too high.
   Reposition final idler in line with drive roller and previous idler.

**Fasteners pulling out, tearing belt.**

1. Fasteners wrong size or not tight.
   Replace fasteners and inspect regularly. Consider fasteners with longer reach.
2. Belt too tight.
   Correct belt tension.

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**Fasteners let go.**

1. Fasteners not clinched tightly.
   Replace fasteners and clinch tightly.
2. Fasteners wrong size.
   Replace with proper size fasteners.
3. Fasteners too weak.
   Replace with higher strength fasteners.

**Fasteners on edge pull through belt.**

1. Fasteners too close to edge.
   Check fastener to edge distance, leave 1/4 inch between last fastener and belt edge.
2. Pin improperly installed.
   Replace pin.

## STRETCHING AND SHRINKING PROBLEMS

**Stretching**

1. Belt too tight.
   Reduce take-up tension.
2. Belt not heavy enough for desired application.
   Switch to a higher grade belt.
3. Frozen idlers or buildup of material on drive rollers and idlers.
   Improve maintenance and clean-up. Lube or replace frozen idlers.

**Shrinking**

1. Bad edge on belt due to rubbing.
   Improve alignment of idlers, drive rollers and tracking of belt. Consider narrower belt.
2. Damage by abrasives, chemicals, mildew, acid heat and oil.
   Specify belt with proper resistance for material being handled. Check maintenance procedures.
3. Improper adhesion.

**Cracking covers**

1. Abrasion, chemical, acid or rot damage.
   Specify belt with proper rubber compounds for material being handled.
2. Belt too tight.
   East tension on belt and use some type of compensating take-up. Consider lagging drive and using snub oil.

## If you have other problems

**Call WCCO Belting, Inc., toll free at (800) 342-4887 for answers to problems that we have not listed above. Skilled WCCO service personnel will work to get you out of the shop and into the field.**