



Applied Power Products - St. Paul, MN - 1-888-FOR-BELT
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Belting Best Practices
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Belting Best Practices

Ensure your bucket elevator and conveyors are:

- 1) Properly Belted
- 2) Stored Correctly
- 3) Properly installed, trained and maintained

Properly Belted

Calculate Tension Required - PIW

Minuteman Tension Calculator

Ensure belt has proper rubber compound for application

Grain requires High Oil Resistance, Static to OSHA standards
and Fire to MSHA standards

Stored Correctly

If possible, store in cool dry building away from sunlight

Rubber side down in factory packaging

If stored for long period of time, rotate 90 degrees every 6 months

Properly Installed, Trained and Maintained

Bucket elevator

Best practices indicate not exceeding bucket manufacturers'
bolt torque specs

Belts without back covers have lost their static
conductivity

Over torqueing of bolts can exacerbate pulley cover
delamination

When installing new belt ensure head pulley lagging isn't worn.

New belt = new lagging

Let belt hang for 24 hours with buckets to remove initial stretch

Bucket elevator and conveyor

Belt tension

Only tension a belt so that it doesn't slip

Tighter is NOT better

If blister has started in middle of bottom cover

Belt is too tight

Herringbone Wing Tail pulley has been shown to alleviate this problem

If bulges/blisters are starting at idler junction area

Belt doesn't have sufficient cross rigidity to span idler junction area. Stronger belt or a belt with more plies may be required. Idler Junction failure could also be transition distance issue. Transition distance is distance from last full troughed idler to head or tail pulley. General Rule of thumb is that transitions should be 2 x belt width.

Vulcanized Splices

Square Splice

Ensure manufacturer and compound of splice kit matches that of the belt

Ensure the splice kit is within parameters of expiration date

Mechanical Splice

Square splice

Ensure non-sparking AB or Everdur fasteners are used in any splice in grain application

Go to <http://www.veyance.com/BuLandingPage.aspx?id=44> for Conveyor Belt Installation, Maintenance and Trouble Shooting Guide
Contains 22 Common belting problems listed with their probable causes and solutions in order of likely occurrence.

Schedule your free belting assessment. Call Angela Field, Applied Power Products at 651-253-3682. We will look at your belts and provide a written report at no charge.