

MA APPROVAL NUMBER	MAC-SAL-00061
FORM NUMBER	N/A
REVISION NUMBER	01
REVISION DATE	18/06/2014
MD SIGNATURE	

INSTALLATION & START-UP PROCEDURES FOR OVEN BELTS

1. Once the belt to be replaced is removed, check all rollers for buildup of foreign matter (color pigment, yarn, adhesive, etc.) and thoroughly clean where necessary to ensure that all rollers are free of buildup.
2. Check limit switches, if present, to make sure they are functioning properly.
3. Test the edge sensors and tracking roller to ensure that they are in working order. A given movement of the edge sensor should produce the desired guide roller movement.
4. Align and level all rollers.
5. Inspect the belt prior to installation for damage that may have occurred in transit or handling.
6. If all rollers were initially clean, level and aligned, simply disconnect existing belt at its seam and connect one end to the end of the belt to be installed. Use the old belt to pull the new one through your oven. If it was necessary to remove the old belt, use a leader to pull the new belt through. A piece of greige goods will do. It can be sewn or stapled to the new belt, provided care is taken not to fracture the yarns of the new belt and the staples are removed from the belt once it is pulled through the oven.
7. Connect both ends of the new belt.
8. Apply only a sufficient amount of tension to the take-up rollers to take the slack out of the belt and eliminate slippage on the drive roller. The exact amount will vary from machine to machine. Experience will dictate established running tension. Remember, the less tension, the better.
9. With the automatic guide roller in a neutral (level and aligned with adjacent rollers) position and deactivated, start moving the belt at approximately 10 feet per minute, using any roller with 30° or 45° wrap to manually track the belt. Do not use a roller with more wrap since it will vary the path of the belt from one side to the other. Do not use more than one roller to manually track the belt. Auxiliary rollers should never be moved from their level/parallel position. Attempt to track the belt to within ± 1.2 ".
10. Gradually bring the oven up to operating temperature, constantly checking belt tracking. Adjust the roller you have selected to manually track the belt, as required. Changes in temperature will cause slight variation in belt tension, necessitating continued adjustment of the selected manual tracking roller. Again, bear in mind that auxiliary rollers should remain in their original level/parallel position.
11. With the oven up to maximum operating temperature and the belt tracking ± 1.2 ", activate the automatic guide roller. Monitor tracking for 10 minutes to ensure that the belt continues to track satisfactorily.
12. Check the belt tension. Increases in temperature may have caused it to shrink slightly, resulting in a tighter belt than required. Reduce the amount of tension equally on each end of the take-up roller so as to maintain the exact roller alignment present while the belt was tracking within tolerance (± 1.2 ").
13. Should your belt become damaged, repair kits are available at a nominal fee (if the belts were purchased from our company).
14. Refer to "Optimum Operating Conditions" bulletin overleaf for additional tips on how to get maximum life and efficiency from your Quadrant Chemplast oven belt. If you have any questions or require assistance, please contact us.

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