

# Honeycomb Belting

## Trouble Shooting Guide

### Belt Tracks to One Side

Possible Cause	Solution
<ul style="list-style-type: none"><li>• Drive/Idler shafts misaligned</li></ul>	<ul style="list-style-type: none"><li>• Ensure that all shafts are horizontal, centrally aligned and perpendicular to the direction of belt travel</li></ul>
<ul style="list-style-type: none"><li>• Uneven loading of belt</li></ul>	<ul style="list-style-type: none"><li>• Adjust product distribution on belt</li></ul>

### Belt Damage

Possible Cause	Solution
<ul style="list-style-type: none"><li>• Belt damaged on edges</li></ul>	<ul style="list-style-type: none"><li>• Check if drive &amp; Idle shafts are misaligned. Check condition of sprockets for wear. Reset drive &amp; idle shafts. Inspect belt &amp; sprockets for damage and replace if necessary. Check belt circuit along edges for loose or worn parts that impinge on belt edge</li></ul>
<ul style="list-style-type: none"><li>• Belt surface or underside damaged</li></ul>	<ul style="list-style-type: none"><li>• Check belt circuit for worn or loose parts that impinge on the belt. Replace or repair parts as necessary. Also check that wear strips are set to the level of the sprocket root diameter</li></ul>
<ul style="list-style-type: none"><li>• Conveyor frame distorted or uneven</li></ul>	<ul style="list-style-type: none"><li>• Inspect conveyor structure and repair any distorted/uneven members</li></ul>
<ul style="list-style-type: none"><li>• Belt moving laterally over sprockets at non drive infeed</li></ul>	<ul style="list-style-type: none"><li>• Under certain conditions it is best to allow any idle shaft sprockets to free float on shaft. Care should be taken to ensure belt does not come into contact with conveyor frame structure</li></ul>

### Excessive Wear to Sprocket Teeth

Possible Cause	Solution
<ul style="list-style-type: none"><li>• Excessive tension</li></ul>	<ul style="list-style-type: none"><li>• Reduce belt loading - or replace with stronger specification (not applicable to Duplex Honeycomb)</li></ul>
<ul style="list-style-type: none"><li>• Belt mis-tracking (see above)</li></ul>	<ul style="list-style-type: none"><li>• Check for tracking issues and remedy if required</li></ul>
<ul style="list-style-type: none"><li>• Sprockets set-up incorrectly</li><li>• Insufficient sprockets</li><li>• Deflection in drive shaft</li></ul>	<ul style="list-style-type: none"><li>• Consult Technical Sales for advice on drive shaft layout</li></ul>
<ul style="list-style-type: none"><li>• Sprocket teeth misaligned across drive/idle shaft</li></ul>	<ul style="list-style-type: none"><li>• Check sprocket teeth are aligned across each shaft and reset as necessary</li></ul>
<ul style="list-style-type: none"><li>• Drive shaft and/or carry wear strips are not set horizontal</li></ul>	<ul style="list-style-type: none"><li>• Check level of carry way wear strips are set horizontal and adjust if necessary</li></ul>

## Belt Grows in Pitch

Possible Cause	Solution
<ul style="list-style-type: none"> <li>Belt material unsuitable for operating temperature</li> </ul>	<ul style="list-style-type: none"> <li>Consult Wire Belt Co. Technical Sales to determine best material for application</li> </ul>
<ul style="list-style-type: none"> <li>Excessive tension in belt circuit</li> </ul>	<ul style="list-style-type: none"> <li>Reduce belt loading - or replace with stronger specification (not applicable to Duplex Honeycomb)</li> </ul>

## Belt Slips on Sprockets

Possible Cause	Solution
<ul style="list-style-type: none"> <li>Insufficient belt tension</li> </ul>	<ul style="list-style-type: none"> <li>Increase tension gradually using belt take up until belt slip stops</li> </ul>
<ul style="list-style-type: none"> <li>Sprockets not properly installed or aligned or have moved out of position</li> </ul>	<ul style="list-style-type: none"> <li>Check sprocket positions. Drive sprockets pull belt against cross rod (positioned in the odd numbered spaces), idle infeed sprockets are driven by belt cross rod (positioned in even numbered spaces). All sprockets to be evenly spaced across belt width—see “Drive &amp; Idler Belt Support” document</li> </ul>
<ul style="list-style-type: none"> <li>Worn or damaged sprocket(s)</li> </ul>	<ul style="list-style-type: none"> <li>Replace &amp; reset sprockets in correct positions with teeth aligned</li> </ul>
<ul style="list-style-type: none"> <li>Insufficient sprockets</li> </ul>	<ul style="list-style-type: none"> <li>Contact Wire Belt Technical Sales for advice</li> </ul>
<ul style="list-style-type: none"> <li>Insufficient belt wrap around sprockets</li> </ul>	<ul style="list-style-type: none"> <li>Increase wrap around drive sprockets. A minimum wrap of 180° is recommended to allow belt to drive with the minimum of belt tension</li> </ul>
<ul style="list-style-type: none"> <li>Drive shaft sprockets too small for application</li> </ul>	<ul style="list-style-type: none"> <li>Replace with larger sprockets after consulting with Wire Belt Co. Technical Sales</li> </ul>
<ul style="list-style-type: none"> <li>Product debris build up on sprocket in the area of teeth and/or on sprocket belt support shrouds</li> </ul>	<ul style="list-style-type: none"> <li>Clear all debris build up from sprockets. If build up persists then consider wipers to act on sprocket belt support shroud areas and wiper/blower to act on belt in return way</li> </ul>

## Wear to Belt Edges

Possible Cause	Solution
<ul style="list-style-type: none"> <li>Not enough clearance between belt edge and conveyor frame</li> </ul>	<ul style="list-style-type: none"> <li>Reposition conveyor side frame to increase clearance or purchase replacement belt of a narrower width (reset sprocket position to suit)</li> </ul>
<ul style="list-style-type: none"> <li>Conveyor frame not square</li> </ul>	<ul style="list-style-type: none"> <li>Realign conveyor frame</li> </ul>
<ul style="list-style-type: none"> <li>Shafts not locked down to prevent sideways wander</li> </ul>	<ul style="list-style-type: none"> <li>Use additional collars on outside/inside of shaft bearings to prevent side float of shafts</li> </ul>
<ul style="list-style-type: none"> <li>Sprocket teeth misaligned—belt jumping across width</li> </ul>	<ul style="list-style-type: none"> <li>Check alignment of sprocket and adjust</li> </ul>