

Rolled Baking Band

Installation Guidelines – New Oven



Belt Installation Procedure

Preparation and Conveyor Checks Prior to Belt Installation

Before installing a new belt, always check the conveyor structure:-

- Firstly ensure that the oven is switched and locked off and at ambient temperature. All temperature zones must be at ambient before installation & testing takes place.
- Shafts to be at 90° to direction of travel, and horizontal.
- Rollers to be free to rotate.
- Belt supporting surfaces are smooth and level with adequate belt edge clearance.
- Check that there are no parts of the structure that can catch the belt.
- If a take-up mechanism is fitted, ensure that it is functioning correctly and is set to its minimum position for maximum belt take-up in use.
- Remove any infeed and discharge product transfer plates.
- Check that any limit switches and photo-electric cells used for sensing the lateral position of the belt are working correctly.

Tools you will need:

- Safety glasses
- Flat end pliers
- Needle nose pliers
- Side cutting pliers
- Hammer
- Cable ties/soft wire
- Pulling rope or cable
- Belt end attachment bar
- Necessary tools for conveyor belt take up adjuster

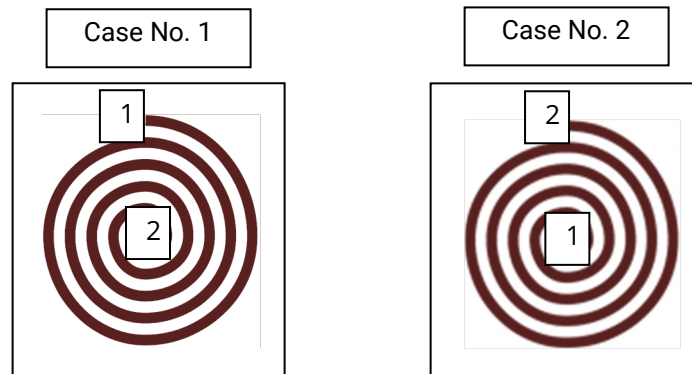
Supply of belt:

The belt is packaged in a wooden case. Depending on the length of the belt the order may be supplied in more than 1 case.

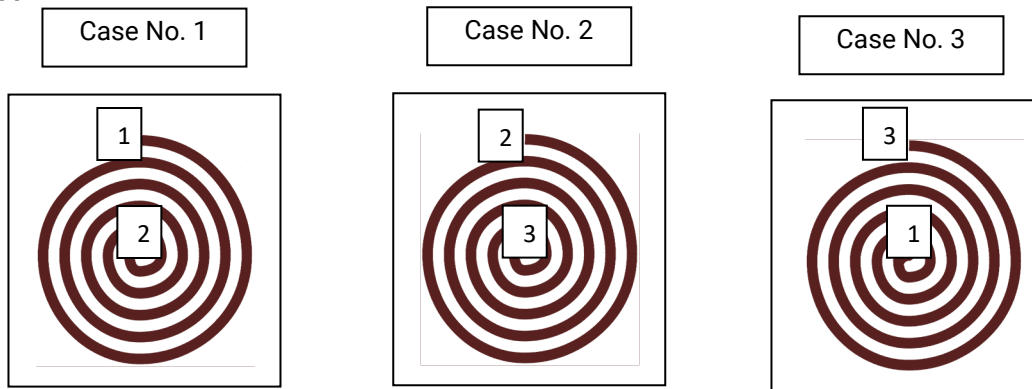
In the event of more than one case each case is marked in order of installation use. Within each case the belt is marked with the direction of running and the numbered matching belt connections to ensure that when installed all belt joins match.

Examples:

1. Belt supplied in 2 boxes



2. Belt Supplied in 3 boxes

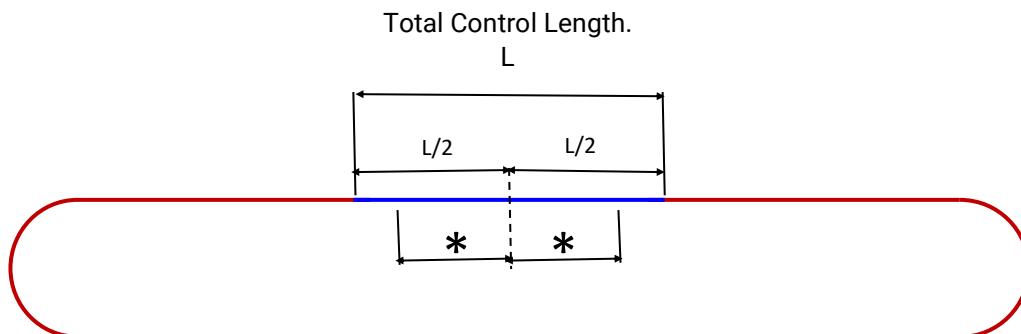


IMPORTANT NOTE: ONLY USE CASES IN THE NUMBERED ORDER.

The spare joining coils are always placed in the first case.

Important Notes:

- A single belt roll is supplied with a manufacturing control length on each end with a matching equal number of meshes in the width. The belt length can only be reduced by cutting back each end equally up to a maximum 75% of the control length. When the belt is supplied in more than one case (multiple cases) then this cutting control length is at the ends marked "1". Mark the join position at the control point clearly for future use.



* Maximum cutting length for belt shortening = 75% of length L/2.
Only shorten belt here upon installation and on any necessary future occasions.
When belt is supplied in multiple cases only shorten belt at final join ends marked "1".

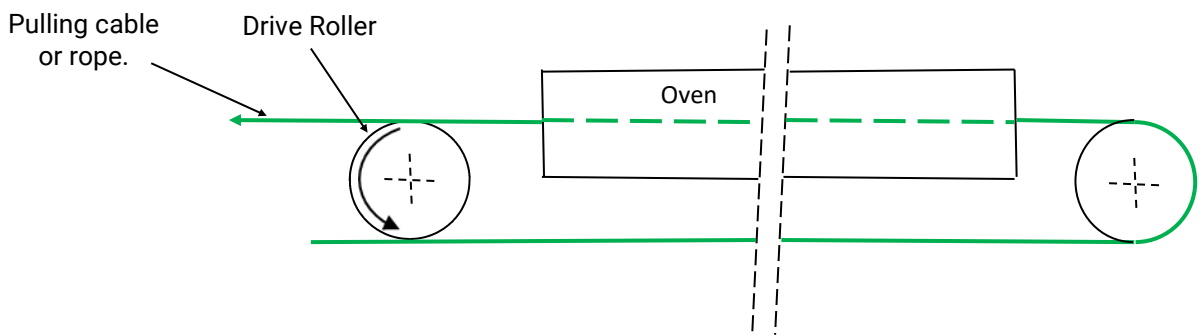
- Future belt shortening should only be made at the belt ends or where multiple roll lengths are supplied at the ends marked "1". Therefore the final belt join should be marked clearly for any future shortening of the belt.
- Do not add or replace sections of belting anywhere in the belt apart from at the final marked connection join and only if all parts of the mesh have the same number of meshes across the width.
- If possible always order the exact belt length to suit the oven, or as near as possible in order that any excess is limited.

Belt Installation:

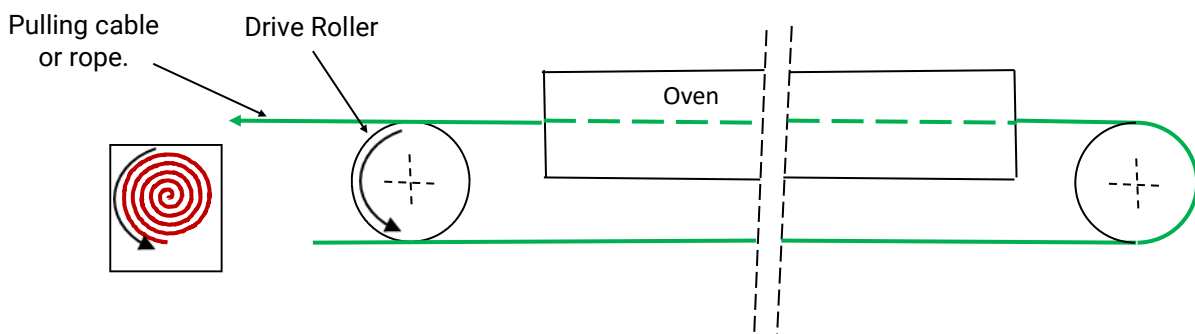
1. First ensure that the electrical supply to the conveyor is turned off and the power supply locked out.
2. Release any conveyor belt tension take up mechanism to allow maximum adjustment during use.
3. There is no top or bottom side to the belt (either side can be up), however when installed direct from the case(s) there is a pre-fixed upper surface.
4. The direction of travel is marked on the belt supplied.

New Equipment Belt Installation:

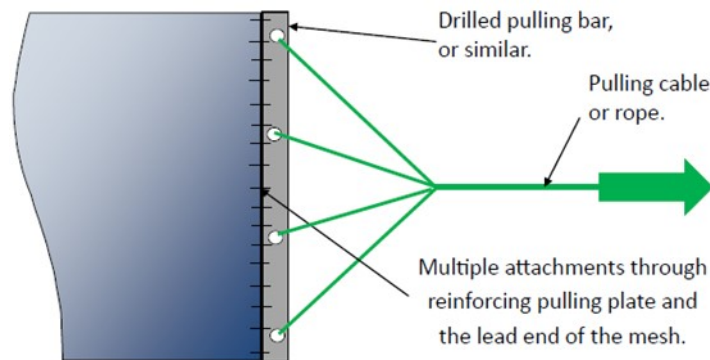
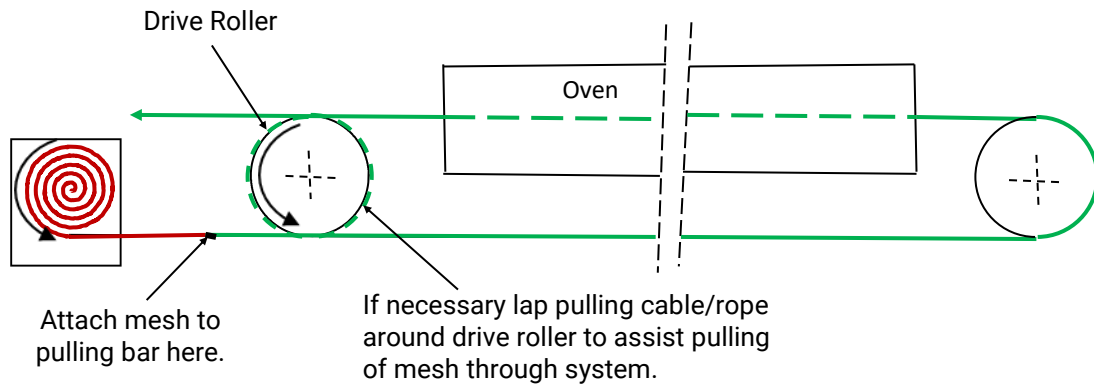
Firstly feed a rope or cable through complete belt circuit from the underside of the drive roller through to the infeed roller and then back to the drive roller at discharge.



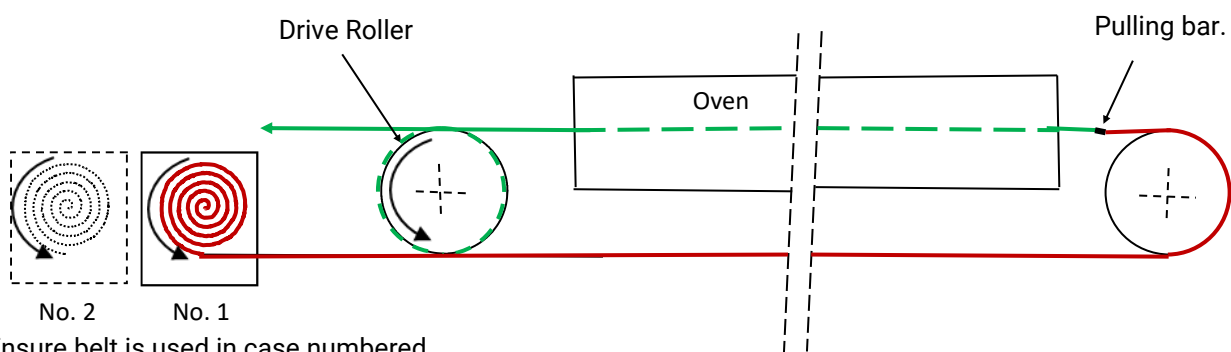
Then open the new belt case (or case no. 1 for multiple cases) to check the band running direction, as noted on a plastic label attached to the belt. Position the case at the drive discharge end of the conveyor as shown below.



Attach to the leading edge of the belt in multiple places across the width a reinforcing pulling bar. Then attach the pulling bar to the cable/rope as shown below.

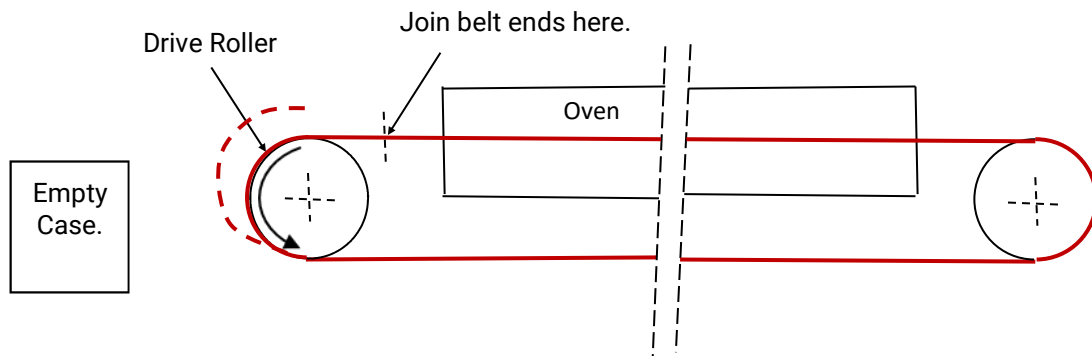


Then pull the belt through the circuit using the cable/rope. DO NOT allow the belt edges or lead of the belt to contact or catch on any part of the frame or system. If necessary guide the belt by hand. Irreparable damage to the belt will affect the correct belt running and may result in early failure.



Ensure belt is used in case numbered order, if belt is supplied in more than one case.

Once the pulling bar (with belt attached) exits the oven at the discharge, pull the remaining belt from the box and lap the trailing end up around the drive roller to meet the leading belt end. Remove the pulling bar from the belt and pull the two belt ends to meet. Pull and stretch the belt by hand with as much force as you can to remove any slack in the belt. If there is excess belt when pulled together then cut it off equally from each end. If the belt is supplied in more than one case only reduce length equally on the ends marked "1". Then join the 2 ends together as per the separate instructions.



Important Notes:

- Future belt shortening should only be made at the belt ends or where multiple roll lengths are supplied at the ends marked "1". Therefore the final belt join should be marked clearly for any future shortening of the belt.
- Do not add or replace sections of belting anywhere in the belt apart from at the final marked connection join and only if all parts of the mesh have the same number of meshes across the width.

After the belt has been fully joined (see "Mesh Joining Instructions") re-tension the belt to a point where no slippage occurs when the belt is driven. This tension can be applied gradually being careful not to over tension the belt. All tension belt take-up mechanisms should operate evenly on each belt edge to ensure that the roller stays at 90° to the direction of belt travel ensuring a square and parallel belt operating arrangement.

If at any time an offset at the belt join is noted then this should be corrected as per the "Straight Belt Adjustment" instructions.

See separate document for "Start-up and Test Run" instructions.

Replace any product transfer plates but ensure they are set clear of the belt particularly at the belt edges.

NOTE: The lifespan and smooth operation of a belt is in direct relation to the correct fitting of the belt. Utmost care should be taken to install the belt without damage or distortion.