

Rolled Baking Band

Start-up & Test Running Instructions

After the belt has been installed in accordance with the 'Installation Guidelines' then the following procedures for start-up and test running should be adopted:

1. Cold Testing

- Check that the edges of the belt are clear of any part of the oven conveyor structure and that there is no foreign material or debris present that would interfere with the running of the belt.
- Adjust the belt take-up mechanisms to action an even tension on the belt. Do not over tension the belt.
- Switch on conveyor and run at low speed (minimum) checking the drive drum end to ensure non-slip driving. If the belt is slipping on the drive drum gradually increase the belt tension until no slippage occurs.
- If the belt tracks off to one side at either the drive or infeed end then adjust the tracking support rollers by the method as shown in the "Tracking of Friction Driven Mesh Belts" document. In general it will take 2-3 complete belt circuit revolutions for the belt to settle in a position.
- Once the belt settles in to a true running position gradually increase speed until full operating speed is achieved. In this process constantly check for tracking and position throughout the full circuit belt length. Ensure the belt does not slip on the drive drum.
- Occasional belt vibration may occur. If present gradually increase the belt tension until it stops.

2. Hot Testing

- When the belt is stabilised under cold running conditions gradually increase the operating temperature in steps of 50°C from 150°C until the operating temperature is achieved. Allow the belt to run for approximately 20 minutes at each temperature point. Do not exceed a rate of 170°C per hour in this hot testing belt running operation.
- During this operation constantly check for tracking and position throughout the full belt circuit. If adjustment is required then refer once again to the "Tracking of Friction Driven Mesh Belts" document.