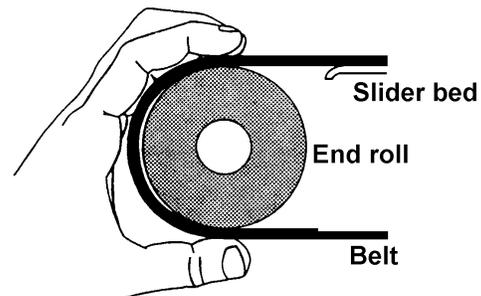


Checking and Adjusting Belt at Inside Radius of a Portec Power Curve

Check the belt tension for slack.

1. Rotate the belt assembly around until the laced belt seam and chain connecting link are on the top side, near the middle of the conveyor.
2. Check the belt slack on the end roll at the inside radius of both end rolls. Place your hand on top of the belt near the end roll and push the belt out towards the end roll (fig. 1). There should be a small amount of slack in the belt (approximately $\frac{1}{8}$ " of give between the belt and the end-roll). The belt slack at both end rolls should to be checked.



Squeeze and pull --- $\frac{1}{16}$ " to $\frac{1}{8}$ " gap
1.6 - 3.2 mm
(AT THE INSIDE RADIUS END OF THE END ROLL)

Figure 1

Check **both** end rolls for slack.

Belt Adjustment

If the belt is too tight or too loose, slack can be adjusted on the inside radius by moving the bearing housing of the end roll.

1. Loosen two of the three bearing housing fasteners on the inside radius end of the end roll (fig. 2). Leave one fastener snug to secure the bearing position.
2. Tighten (or loosen) the belt by tapping against the bearing housing with a rubber mallet.
3. Tighten the fasteners of the bearing housing.



Figure 2

Note: The belt should **never** be adjusted tight against the end roll. High belt tension is not required for optimum performance. It can cause damage or premature failure.

Safe practice requires that if the conveyor is to be opened for inspection, cleaning, maintenance or observation, the electric power to the motor driving the conveyor must be LOCKED OUT/TAGGED OUT in such a manner that the conveyor cannot be restarted by anyone; however remote from the area, until conveyor cover or guards and drive guards have been properly replaced.