

## Operating Instructions for Conveyor Pulley Assemblies

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1. All pulleys should be checked for tightness on their shafts. For the first month of operation, inspect the bushings for proper seating and bolts for correct bolt torque at least once a week and thereafter during periodic shutdowns.
2. The pulley lagging should be checked for wear, cracks, and tightness. Changes in coefficient of friction between the drive pulleys and belt could result in belt slippage.
3. The ends of the pulleys should be inspected for cracks or other signs of stress or fatigue. The pulley should not be operated if a crack develops.
4. Take-up pulleys and belt tensioning devices should function normally. Excessive belt tension could fail pulleys, bearings and shafts.
5. Pulleys should be checked for vertical and lateral alignment. Misalignment can result in belt tracking problems and pulley wear.
6. Bearings should be checked for excessive shaft movement in the bearing during operation.
7. All bearings should be checked for alignment, lubrication, and tightness of locking devices.
8. Conveyor pulleys should not be cleaned during operation. It is extremely dangerous to be near the nip point when the pulley is in operation.