	Catalog Item Number	Working Tension Per Inch Width	Min. Pulley Diameter	Approximate Weight Pounds Per Inch Width	Coefficient of Friction	Antistatic	Elongation @1%	Temp-Resistance (Fahrenheit)	Splice/Lace	Clipper Lace
	120	NA	1/2"	.012 lbs.	.3 – .3	Yes	12 lbs.	0/215°F	Endless	NA
	121	NA	5/8"	.018 lbs.	.3 – .4	Yes	17 lbs.	0/215°F	UCM 36S x P	NA
	122	NA	1"	.04 lbs.	.3 – .4	Yes	20 lbs.	0/215°F	25 P	NA
	125	NA	1"	.027 lbs	.6 – .6	Yes	28.5 lbs.	0/215°F	Endless	NA
	126	NA	1-3/4"	.052 lbs.	.7 – .7	Yes	42.8 lbs.	0/215°F	Endless	NA
	127	NA	3"	.063 lbs.	.7 – .7	Yes	85.6 lbs.	0/215°F	Endless	NA
	128	NA	1-1/4"	.058 lbs.	.6 – .6	Yes	28.5 lbs.	0/215°F	Endless	NA
	128A	NA	1-5/8"	.078 lbs.	.6 – .6	Yes	28.5 lbs.	0/215°F	Endless	NA
	129	NA	1-7/8"	.107 lbs.	.6 – .6	Yes	42.8 lbs.	0/215°F	Endless	NA

CONVEYOR BELTING TROUBLE SHOOTING

Below are some conveyor belt problems, and some of their causes and solutions. Beltservice handles many questions regarding belting problems on a daily basis. If you are having a problem, give us a call, and we'll be happy to help.

Vulcanized splice delamination or failure

1. Pulley too small — check recommended minimum for belt
2. Belt running wrong direction — check for manufacturer's arrow or make sure leading edge of splice contacts pulley first
3. Reverse bend — use thinner belt
4. Too much tension for belt — use heavier construction

Belt does not track properly

1. Pulleys and/or idlers NOT squared
2. New belt not "run in" long enough
3. Uneven loading — load off center
4. Structure not square
5. Lacing or splice not square
6. Bow in belt

Cleats cracking at base

1. Pulleys too small

Cleat delamination

1. Pulleys too small — check minimums for cleat type
2. Return idlers hitting cleats
3. Material conveyed affecting bond (oils, acids, etc.)
4. Product overload
5. Poor tracking — cleat edges repeatedly hitting conveyor frame

Flange delamination or cracking

1. Pulley is too small — check minimum for flange height. Sipe, sipe and drill, or notch for small pulleys.

V-guide delamination or cracking

1. Pulley too small — notch for small pulleys
2. Severe misalignment
3. Wrong size cross section for pulley groove

Fastener pullout

1. Wrong size fastener
2. Fastener not installed properly
3. Obstruction touching splice area
4. Poor tracking — splice hitting conveyor frame

Severe edge wear

1. Pulleys, idlers or structure not square
2. Worn pulley lagging
3. Offset loading conditions
4. Load off center

Excessive belt stretch

1. Too much tension for belt being used — go to a stronger belt
2. Insufficient take-up
3. Overtightening of take-up

Excessive belt slip

1. Tighten take-up or pulley
2. Lag or replace worn lagging
3. Pulleys too small — not enough wrap — use lighter belt or larger pulley
4. Material spillage — lag pulleys and/or install cleaning devices

Elevator bolt pull-out

1. Bolt not tight — tighten monthly
2. Bucket hung up in boot
3. Belt tension too low causing elongation of holes
4. Adverse conditions — heat, oil, acids

HOW TO TRACK OR TRAIN A BELT

Before installing belt: ALL pulleys, snubs, idlers and structure must be square for proper belt alignment. All foreign material should be removed from pulleys and idlers. Replace lagging if needed.

Install belt: Operate under tension for a minimum of two (2) hours before making adjustments (Unless there is a severe problem). This will allow temporary mal-distribution of tension in belt to even itself out.

Adjust idlers only: Pulleys and snubs have very little positive effect in training. (Unless the problem is obvious.)

Train by knocking ahead (2° max) the end of the idler to which the belt rides. This should be done over a reasonable length of the conveyor preceding the problem area.

If the above method does not solve your problem – contact factory for further technical information.