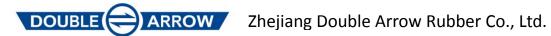
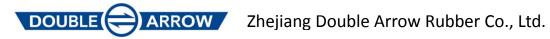


# **TROUBLE SHOOTING**

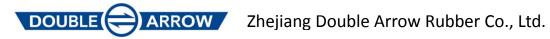
Troubles	Causes	Countermeasures
	© Conveyor frame or structure crooked.	Check the affected area and adjust the straightness and levelness.
Belt runs deviation to one side at a given section of the conveyor frame.	O Idler stuck with materials.	Remove accumulation, install scrapers and other cleaning devices.
	O Idler poor running.	Improve maintenance and lubrication.
	<ul><li>Idlers or pulleys out-of-square with center line.</li></ul>	※ Readjust the idlers in affected area.
	© Dullay agatas alyaya as	Y Adinat the mulley contain install
	Pulley center skews or sticks with materials.	Adjust the pulley center, install scrapers, and remove attachment.
	<ul> <li>Idlers in forepart of the affected area isn't perpendicular to the</li> </ul>	※ Adjust it.
	running direction of the belt.	
Particular section of the belt runs deviation at all parts of	Belt joint crooked.	Cut off the joint section and resplice.
the conveyor frame.	O Insufficient straightness of the belt itself.	Install the automatic centering idler at the return section of the tail pulley.
Belt runs deviation for long distance or at entire length of the belt.	<ul><li>Belt runs deviation near tail pulley within the carrying area.</li></ul>	Install the correcting idler in the front of the tail idler.
	<ul><li>Materials are unevenly loaded on belt off center</li></ul>	Improve the loading position.
	<ul><li>Idler stands not centered on belt.</li></ul>	Readjust the idler in the affected area.
	<ul><li>Conveyor frame or structure crooked.</li></ul>	Check the affected area and adjust the straightness and levelness.



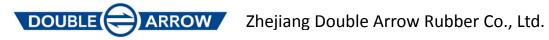
	<ul> <li>Belt sometimes runs deviation while sometimes not, which is often caused by the wind.</li> <li>Belt sometimes runs centering idler.</li> <li>Install wind shelter and automatic centering idler.</li> </ul>
	O Idlers on one side falls.
	<ul> <li>Belt runs deviation around tail pulley through the loading area.</li> <li>Install correcting idler prior to tail idler.</li> </ul>
Belt runs deviation at tail pulley.	<ul> <li>Material slippage or stacks.</li> <li>Material slippage or conditions, install cleaning devices and improve maintenance.</li> </ul>
	<ul> <li>Idlers or pulleys</li> <li>out-of-square with</li> <li>center line.</li> <li>** Readjust the idlers in affected</li> <li>area.</li> </ul>
	Damages in coating
Belt runs deviation at head pulley.	<ul> <li>Material slippage or stacks.</li> <li>Material slippage or stacks.</li> <li>Improve loading and transferring conditions, install cleaning devices and improve maintenance.</li> </ul>
	<ul> <li>Idlers or pulleys out-of-square with center line.</li> <li>Readjust the idlers in affected area.</li> </ul>
	<ul><li>Idler stands not centered on belt.</li><li>Readjust the idler in the affected area.</li></ul>
Belt slips.	<ul> <li>Insufficient traction pull between belt and pulley.</li> <li>Thicken the coating rubber on the drive pulley and install cleaning devices.</li> </ul>
	<ul><li>Damages in coating rubber.</li><li>Replace pulley or recoat.</li></ul>
Corotob outo atripping	Counterweight too light.       Add counterweight or take-up pulley.      Adjust the length until the
Scratch, cuts, stripping, or	□ Insufficient length of ※ Adjust the length until the



abnormal wear on the top cover.		skirt board.		materials be stable on the belt.	
cover.	0	Improper skirt materials or use used belt with the canvas exposed, getting in touch with the belt.	*	Select proper rubber skirt board.	
	0	The feeding speed of the material is inconsistence with belt	*	Adjust the feeding speed of material to be consistence with belt running speed.	
		running speed. The material slips at the			
		moment of falling to the belt.			
	0	Material stacks in or under chute.	*	Improve loading to reduce spillage and install chute with wider baffle.	
	0	Material impacts belt.	*	Improve the chute design to	
				reduce impact and install impact idler or buffer-bed.	
	0	Return idler sticks with material.	*	Clean the accumulation or add cleaning devices.	
	0	Improper cover.	*	Replace with higher grade cover.	
	0	Idler poor running.	*	Improve maintenance and lubrication	
Scratch, tear, or abnormal	0	Belt slips on the drive pulley.	*	Fasten the stretching roller or add counterweight, increase contacting area.	
wear on the bottom cover.	0	Idler stuck with materials.	*	Remove accumulation, install scrapers and other cleaning devices.	
	0	Bolt protrudes the lagging.	*	Fasten the bolt, replace the lagging and better to use	
				vulcanized lagging.	
	0	Material trapped between belt and pulley.	*	Install plows or scrapers on return side ahead the tail pulley.	
	0	Damages in coating rubber.	*	Replace pulley or recoat.	



	Carrier idler tilts forward	Lower the tilt angle to 2° less than
	excessively.	the vertical direction.
Covers harden or crack.	Heat or chemical damage.	W Use belt designed for special conditions.
Bottom cover swells in spots or streaks.	<ul> <li>Idler oiling too much or sticking oil, grease from other parts of the belt</li> </ul>	Improve maintenance, use less     lubrication oil and keep the oil     seal in good condition.
	frame.	
	© Improper splice.	Resplice in proper method according to DOUBE ARROW splice manual.
Vulgarized is interpreting	O Pulleys too small.	W Use larger diameter pulleys.
Vulcanized joint separation.	<ul><li>Material trapped between belt and pulley.</li></ul>	Install plows or scrapers on return side ahead the tail pulley.
	<ul><li>Improper transition between belt and pulley.</li></ul>	<ul><li>Adjust the transition area in accordance with DOUBLE ARRWO selection manual.</li></ul>
	Off-center loading.	Adjust chute to make the load located at belt center, in the belt running direction and the
		unloading speed similar to belt running speed.
Excessive wear or break of the edge rubber.	Belt hitting conveyor structure.	Install correcting idler at carrying and return side.
	<ul><li>Belt crooked or insufficient straightness itself.</li></ul>	Install the automatic centering idler at the return section of the tail pulley.
	Belt edge folded to the conveyor structure.	Install limit switch.
	<ul> <li>Belt extruding frame</li> <li>due to off tracking which</li> </ul>	X Take measures to prevent the belt running deviation.
Damages in carcass.	may cause longitudinal tear if severe.	Tarming deviation.
	Due to the iron in feeding part.	Remove the iron, use metal inspection or magnetic separator device at the place where such



		failures occur frequently
	<ul> <li>Material squeezed between belt and pulley, stab the belt.</li> </ul>	Install scraper or cleaning device at the return side of tail pulley.
	<ul><li>Belt impacted with large block material.</li></ul>	Improve the feeding device to reduce impact or use impact idler.
	<ul><li>Carrier idler tilts forward excessively.</li></ul>	O Lower the tilt angle to 2° less than the vertical direction.
	<ul><li>Insufficient transverse stiffness.</li></ul>	Replace with proper belt.
	© Excessive sag between idlers.	<ul><li>Increase tension and reduce idler spacing.</li></ul>
Carcass fatigue at idler junction.	<ul><li>Improper design of convex arc section</li></ul>	<ul> <li>Increase curve radius or add idlers to make the belt transit</li> </ul>
		stably.
	O Improper transition	Adjust transition length.
	between belt and tail pulley in carrying section.	
	<ul><li>Excessive gap between idlers</li></ul>	<ul> <li>Replace idlers or use higher strength belt.</li> </ul>