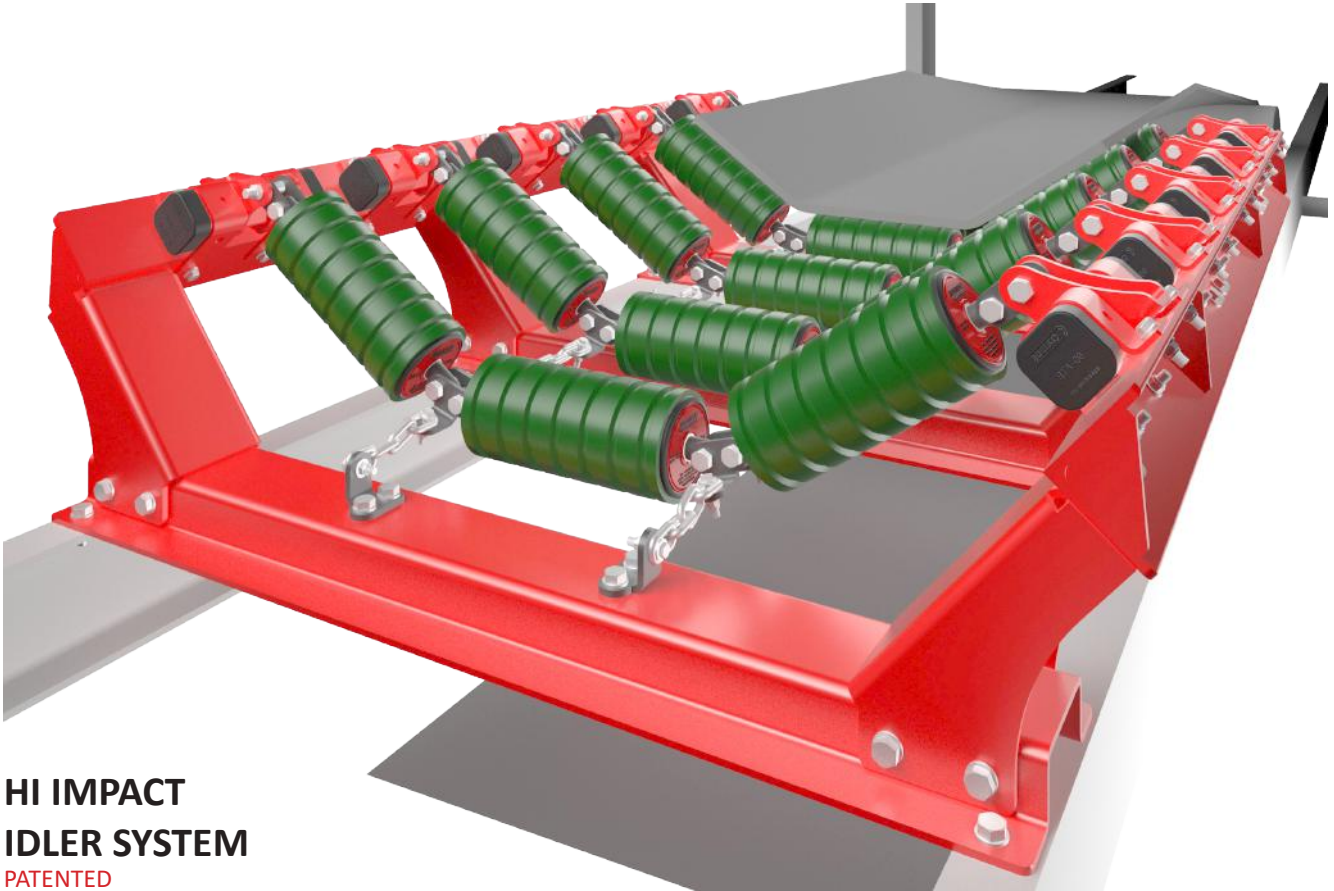


## INSTALLATION, OPERATING & MAINTENANCE MANUAL



**HI IMPACT  
IDLER SYSTEM**  
PATENTED

<b>Project Name</b>	:	.
<b>Project Number</b>	:	.
<b>Order Number</b>	:	.
	:	.
<b>Model Number</b>	:	.
<b>Purchase Date</b>	:	.
<b>Purchased From</b>	:	.
<b>Installation Date</b>	:	.
	:	.

Model number information can be found on the Label found on the scraper carton.  
This information will be helpful for any future inquiries or questions about belt scraper replacement parts, specifications or troubleshooting.

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## 1. Disclaimer

Brelko conveyor products (Pty) Ltd hereby disclaims any liability for: damage due to contamination of the material; user's failure to inspect, maintain and take reasonable care of the equipment; injuries or damage resulting from use or application of this product contrary to instructions and specifications contained herein. Brelko's liability shall be limited to repair or replacement of equipment shown to be defective.

## 2. Safety Note

Observe all safety rules given herein along with owner and Government standards and regulations. Know and understand lockout/tag-out procedures as defined by National Standards Institutes, National Standard for Personnel Protection - Lockout/Tag-out of Energy Sources - Minimum Safety Requirements and Occupational Health and Safety.

## 3. The following symbols may be used in this manual:



Danger: Immediate hazards that will result in severe personal injury or death.



Warning: Hazards or unsafe practices that could result in personal injury.



Caution: Hazards or unsafe practices that could result in product or property damages.

Important:

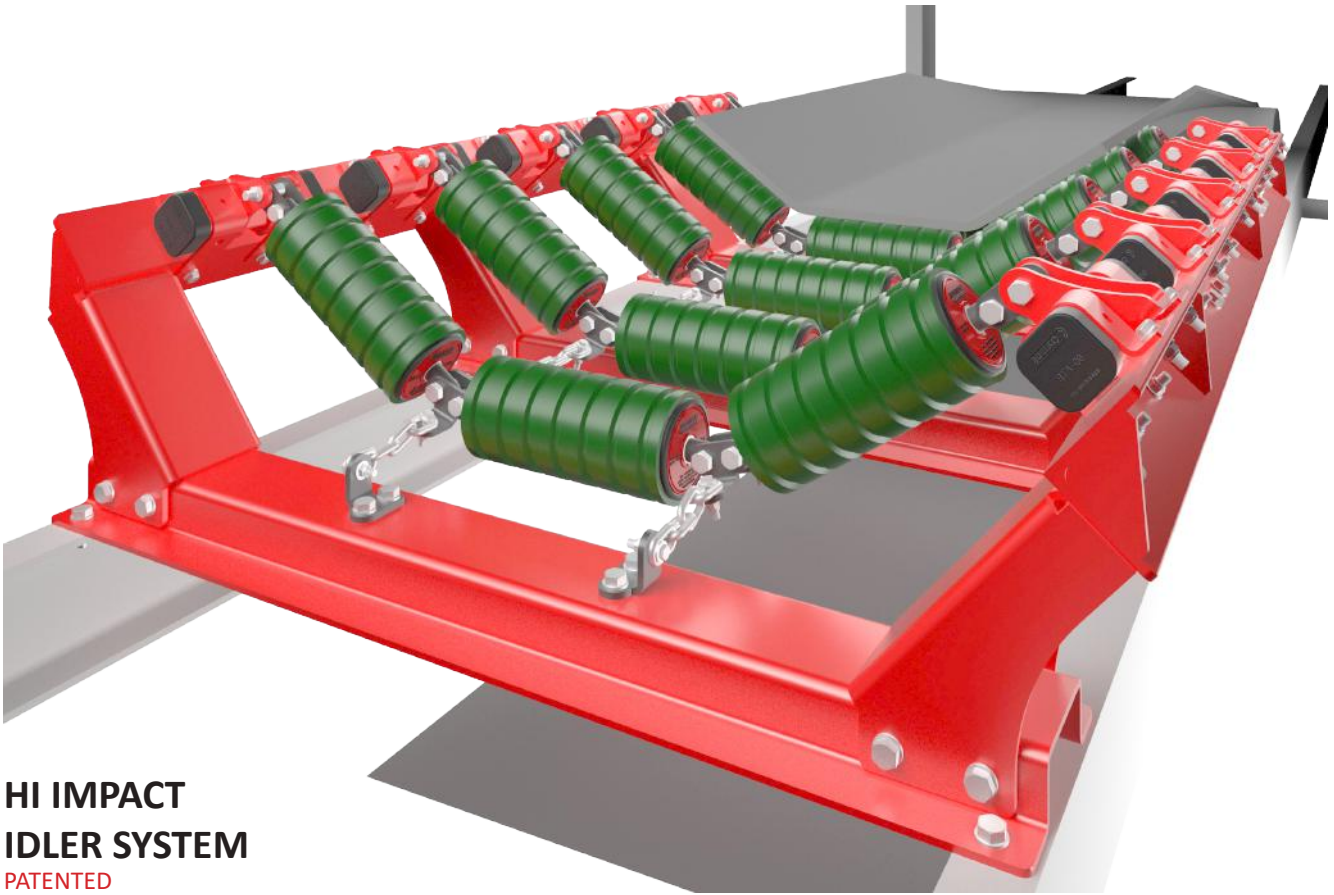
Important: Instructions that must be followed to ensure proper installation/operation of equipment.

Note:

Note: General statements to assist the reader.

## 4. General Information

Brelko Hi-impact Systems are designed to operate with minimum maintenance. However, to maintain superior performance some service is required. When the Hi-impact System is installed a regular maintenance program should be set up. This program will ensure that the Hi-impact System operates at optimal efficiency and problems can be identified and fixed before the Hi-impact System stops working. All safety procedures for inspection of equipment (stationary or operating) must be observed. Hi-impact Systems operate at the transfer load point of the conveyor and is in direct contact with the moving belt. Only visual observations can be made while the belt is running. Service tasks can be done only with the conveyor stopped and by observing the correct lockout/tag-out procedures.



## HI IMPACT IDLER SYSTEM

PATENTED

### APPLICATIONS

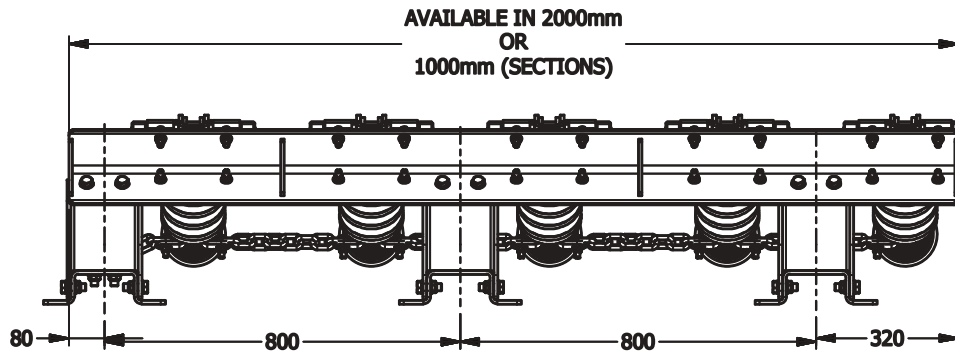
- A load point belt support system designed to offer maximum impact absorbing capabilities.
- Suitable for all belt conveyors where large particle size and severe impact load conditions occur.

### FEATURES

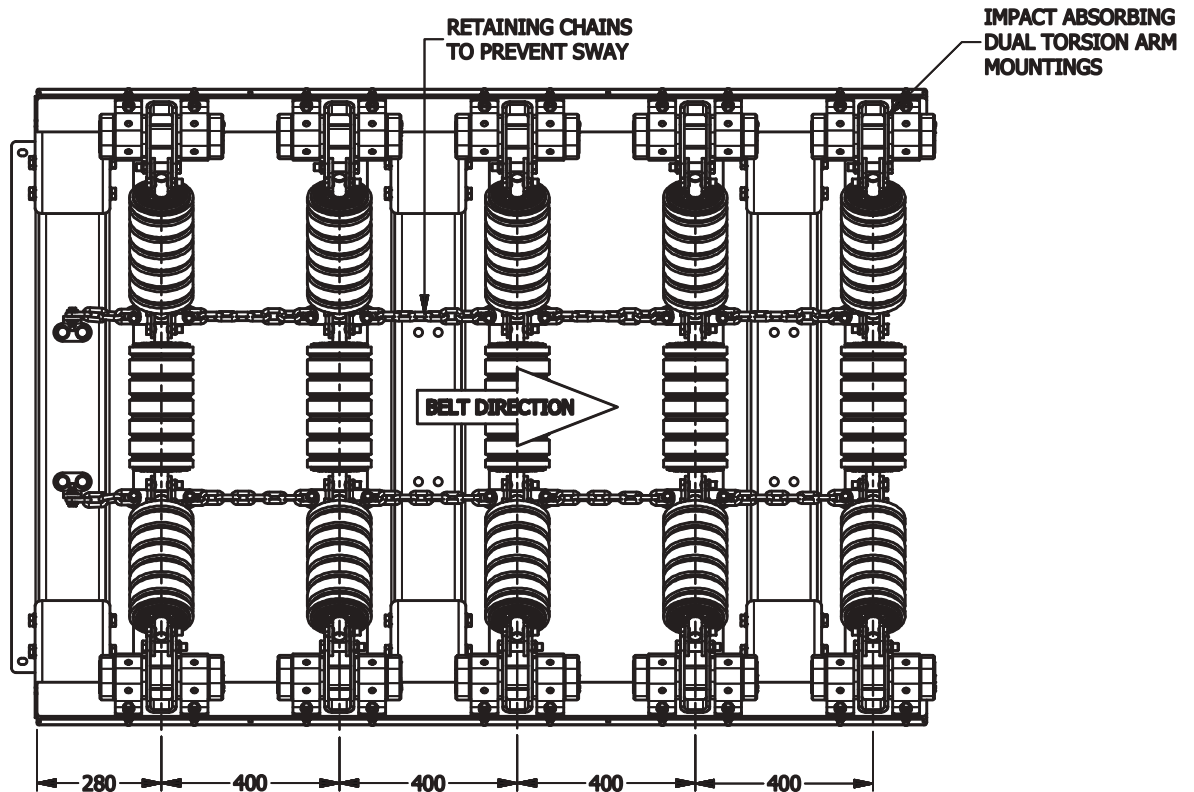
- Unique torsion arm mountings absorb impact loads and are self damping.
- Polyurethane impact rolls help to extend belt life.
- Proven polyurethane coated impact rolls, last up to 3 times longer than standard rubber lagged.
- Support frame is available in standard 2000mm length and fitted with 5 strings of idler rolls.
- Support frame is designed to replace existing roller cradles and fixed to conveyor stringers.
- Open construction makes clean up of spillage and roll replacement very easy.
- Polyurethane idler roll arrangement promotes correct belt tracking.

## HI-IMPACT IDLER SYSTEM WITH IMPACT ABSORBING DUAL TORSION ARM MOUNTINGS

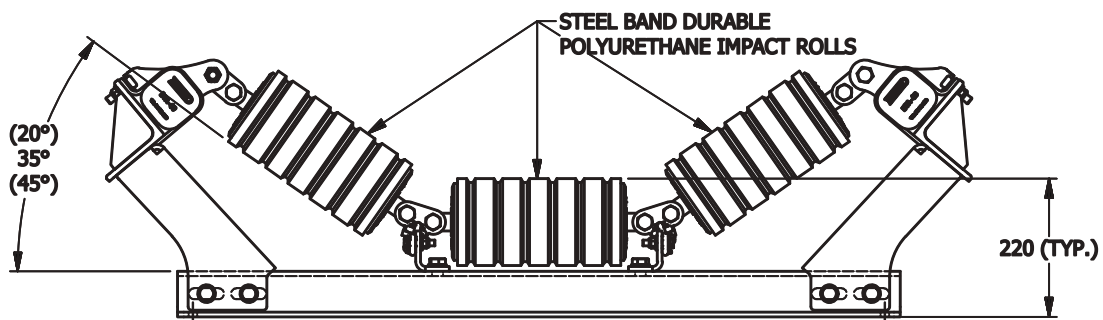
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**SIDE VIEW**



**PLAN VIEW**



**ALL DIMENSIONS  
ARE IN mm**

**STANDARD CONSTRUCTION & FINISHES FOR BELT WIDTHS FROM  
600mm TO 2400mm**

**NOTE: FEATURES & OPTIONS SHOWN:  
PLEASE REFER TO DETAILED MANUAL FOR INSTALLATION INSTRUCTIONS, MAINTENANCE & SPARE  
PARTS**

**DRW. BTA-022  
No.  
REV. E**

## 5. Handling

### 5.1. Receiving the goods

Check that the shipment contains all the items specified on the delivery note. If this does not match the delivery note or if the items show any transportation damage, **list it on the freight bill**. Describe the damage and the number of incorrect or faulty items and **contact your supplier immediately**.

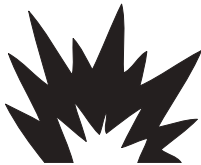
**Defective parts should not be used under any circumstances.** Claims must be made within 8 days from the arrival of goods. Brelko do not cover claims or exchange of product if installation was not carried out according to installation instructions.

### 5.2. Work Safety

Always use protective gloves and clothing. Always use a lifeline and soft-sole footwear when work will be carried out on raised platforms. Before you move a scraper or plough, check that it is securely attached to the lifting equipment. Always observe local safety regulations.



Before removing/installing equipment, lock out/tag out energy source to conveyor, and/or conveyor accessories.



Turn off and lock out/tag out energy source according to local standards.

If equipment will be installed in an enclosed area, test gas level or duct content before using a cutting torch or welding. Using a cutting torch or welding in an area with gas or dust may cause an explosion.

If using a cutting torch or welding machine, test atmosphere for gas level or dust content.



### 5.3. Handling

When scrapers are unloaded from the transportation vehicle onto customer's platform, place them on boards spaced max 1m apart at a minimum of 5cm from the ground.

### 5.4. Storage

Scrapers can be stored unpacked or in transportation package. Scrapers must not be stored on top of one another, protect the scrapers by storing them in a cool dry area on a flat surface.

### 5.5. Preparations for installing Belt Scrapers

Before installation, check all measurements and any of the other geometric design

### 5.6. Recommended Tools List

HI-IMPACT SYSTEMS	
QTY	DESCRIPTION
2	EXTENSION CORD (30m MINIMUM)
1	PORT-A-PACK (OXY-ACETYLENE)
1	FLINT LIGHTER
1	ARC WELDER (INVERTER) 200AMP
1	CHIPPING HAMMER
1	ANGLE GRINDER
1	BABY GRINDER
1	5M TAPE MEASURE
1	NOZZLE CLEANER
1	SHIFTING SPANNER
1 SET	SOCKET SET 8MM TO 32MM
1	SOFT FACE HAMMER
2	SAFETY HARNESS
2	G-CLAMPS
1	JIMMY LEVER
1	TORCH (LED)
1 SET	SCREW DRIVER SET
1	CHALK LINE
1	SCRIBER
1	CENTRE PUNCH
1	HACK SAW
1	STANLEY KNIFE
1	4PD HAMMER
1	ANGLE FINDER

**Recommended Tools List (continued...)**

HI-IMPACT SYSTEMS	
QTY	DESCRIPTION
1	ELECTRIC DRILL
1 SET	ELECTRIC DRILL BITS
1	WELDING HELMET
1	FIRE EXTINGUISHER 9KG
1 SET	WELDING SPATS
1	WELDING APRON
1	FIRE BLANKET
1	SMALL BLUE TOOL BOX
1	MAGNETIC BASE DRILL
1 SET	12, 14, 18 SLUGGER BITS
2	FLAT RING SPANNER 13"
2	FLAT RING SPANNER 17"
2	FLAT RING SPANNER 19"
2	FLAT RING SPANNER 24"
2	FLAT RING SPANNER 30"
1	LONG NOSE PLIERS
1	PLIERS
1	BELT LIFTER
2	1 TON LEVER HOIST
4	1M NYLON SLING



## **6. Maintenance**

Brelko Hi-impact Systems are designed to operate with minimum maintenance. However, to maintain superior performance some service is required. When the Hi-impact System is installed a regular maintenance program should be set up. This program will ensure that the Hi-impact System operates at optimal efficiency and problems can be identified and fixed before the Hi-impact System stops working. All safety procedures for inspection of equipment (stationary or operating) must be observed. The Hi-impact System operates at the transfer load point of the conveyor and is in direct contact with the moving belt. Only visual observations can be made while the belt is running. Service tasks can be done only with the conveyor stopped and by observing the correct lockout/tag-out procedures.

### **6.1. New Installation**

After the new Hi-impact System has run for a few days a visual inspection should be made to ensure the Hi-impact System is performing properly. Make adjustments as needed.

### **6.2. Routine Visual Inspection (every 2~4 weeks)**

A visual inspection of the Hi-impact System and belt can determine:

- Check that the Hi-impact System is positioned correctly
- If there is damage to the polyurethane impact idlers or other Hi-impact System components.
- Check that the “t-links” are orientated correctly, facing down.
- Wear on mounting bolts and other Hi-impact System mounting components.
- If fugitive material is built up on the Hi-impact System or under the transfer area.
- Is the conveyor belt in full contact with the Hi-impact System polyurethane impact idlers.
- If there is cover damage to the belt.
- If any of the above conditions exist, a decision should be made on when the conveyor can be stopped for Hi-impact System maintenance.

### **6.3. Routine Physical Inspection (every 6~8 weeks)**

When the conveyor is not in operation and properly locked and tagged out perform a physical inspection of the Hi-impact System performing the following tasks:

- Clean material build-up off of the Hi-impact Systems frame and other components.
- Closely inspect the mounting components for wear and any damage. Replace if needed.
- Check that the “t-links” are orientated correctly, facing down. Repair if needed.
- Check the polyurethane impact idlers for wear and any damage. Replace if needed.
- Check that the Hi-impact System is positioned correctly. Reposition if needed.
- Ensure the conveyor belt is in full contact with the Hi-impact System polyurethane impact idlers.
- Inspect all fasteners for tightness and wear. Tighten or replace as needed.
- Replace any worn or damaged components.

When maintenance tasks are completed, test run the conveyor to ensure the Hi-impact System is performing properly.

## PARTS LIST - REF. DRW. No.: BTA-023

ITEM No.	DESCRIPTION	CODE
1.	SUPPORT BEAM (LH or RH)	SPECIFY BELT WIDTH
2.	BTA MOUNTS - SIZE 5 BTA MOUNTS - SIZE 6 SPECIFY 3 OR 5 ROLL SYSTEM, AND SERIES 30 OR 40.	6-MNT5 6-MNT6
3	CONE BUFFER	4-C-BUFFER
4	POLYURETHANE IDLER ROLL SPECIFY 3 OR 5 ROLL SYSTEM, AND SERIES 30 OR 40.	SPECIFY BELT WIDTH
5	UPRIGHT SPECIFY 3 OR 5 ROLL SYSTEM.	SPECIFY BELT WIDTH
6	FLAT LINK	ITEMS 6,7,8 & 9 SOLD AS A SET
7	"T"- LINK	6-3R-HDW5
8	CHAIN LINK	(3 ROLL SYSTEM)
9	RESTRAINT CHAIN	6-5R-HDW5 (5 ROLL SYSTEM)
10	TRANSOM	SPECIFY BELT WIDTH

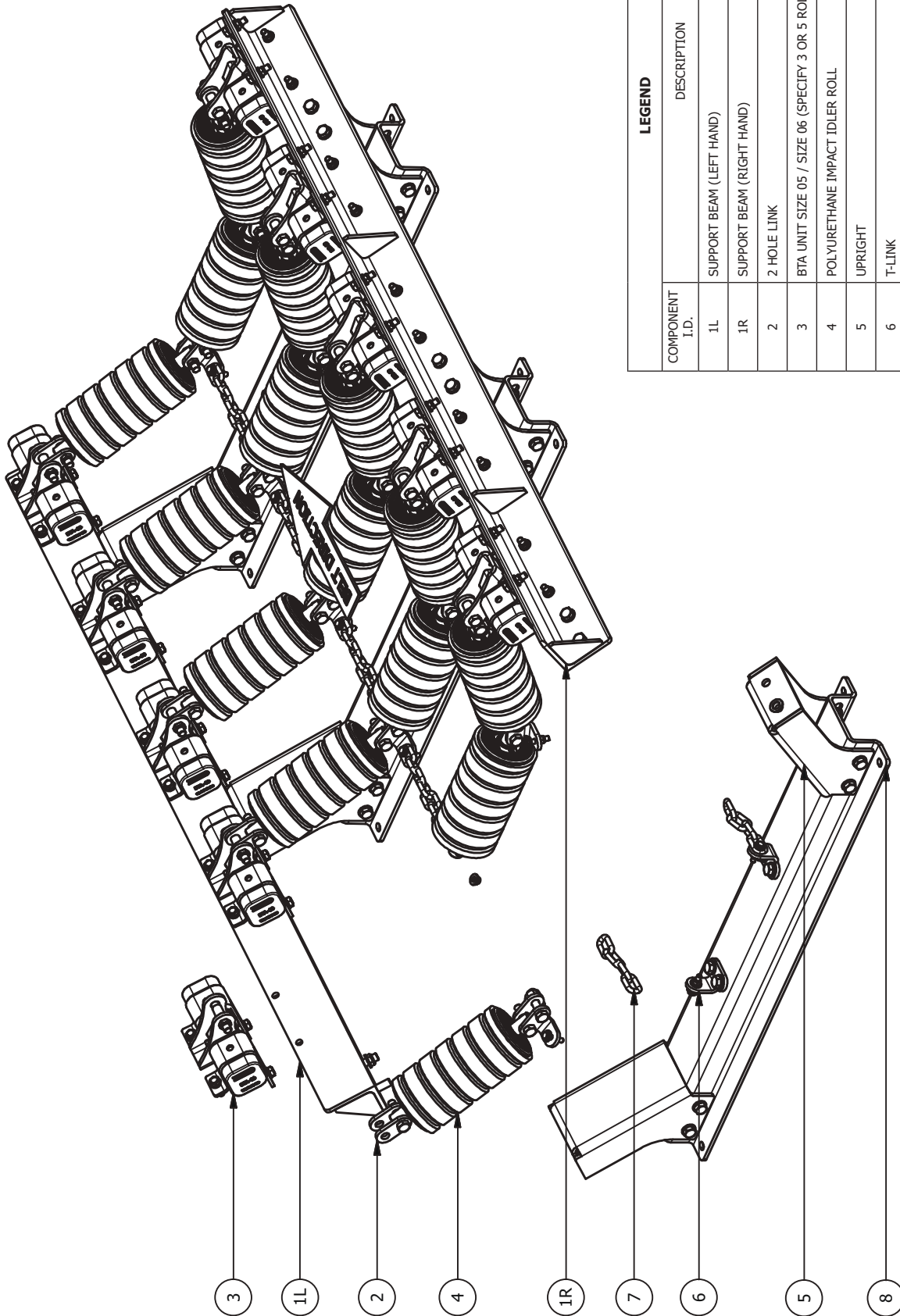
***NOTE! Always quote belt width.***

### ASSEMBLY INSTRUCTIONS

1. Referring to the parts list DRW. No.: BTA-023 check that the correct parts and quantities have been supplied for belt width, troughing angle and number of rolls ordered.
2. Attach uprights (5) to transoms (10).
3. Bolt left and right hand support beams (1) to uprights (5).
  - *Note:* - Left and Right units relative to belt direction.
4. Bolt BTA mounts (2) to support beams (1).
  - *Note:* - Left and Right units, and belt direction.
5. Assemble polyurethane idler strings by connecting rolls (4) using links (6) and (7).
  - *Note:* - Use "T" links (7) on centre rolls.
6. Attach polyurethane idler strings to BTA mounts using M16 bolts supplied. Securely fasten bolts and nuts.
7. Attach restraining chains (9) using chain links (8) with nyloc nuts.
8. Chain (9) is connected to "T" links (7) which is bolted to transoms (10).
  - *Note:* - Belt direction.

HI-IMPACT IDLER SYSTEM WITH IMPACT ABSORBING DUAL TORSION ARM MOUNTING

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LEGEND	
COMPONENT I.D.	DESCRIPTION
1L	SUPPORT BEAM (LEFT HAND)
1R	SUPPORT BEAM (RIGHT HAND)
2	2 HOLE LINK
3	BTA UNIT SIZE 05 / SIZE 06 (SPECIFY 3 OR 5 ROLL & SERIES)
4	POLYURETHANE IMPACT IDLER ROLL
5	UPRIGHT
6	T-LINK
7	RESTRAINT CHAIN
8	TRANSOM

PARTS LIST: FOR STANDARD SUPPLY

PLEASE SPECIFY BELT WIDTH WHEN ORDERING

DRW. BTA-023  
No.

REV. E

## INSTALLATION GUIDE - REF. DRW. No.: BTA-024

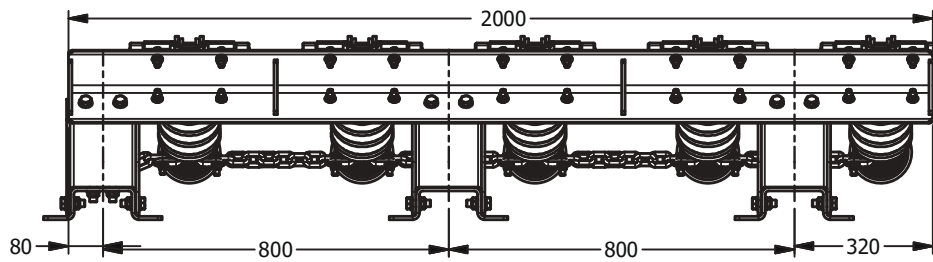
1. If not assembled refer to assembly instructions and DRW. No.: BTA-023. Check that all necessary parts have been supplied for belt width, troughing angle and number of rolls ordered.
2. Remove existing idlers and rolls from conveyor structure in the area where the system is to be installed.
3. If assembled remove polyurethane idler strings, and the support beam (1) with uprights (5).
4. Check direction of belt travel and slide unit under conveyor belt from one side.
  - *Note:* - For larger sizes lifting equipment may be required.
5. Position unit in impact zone and align centrally to belt.
6. Attach support beam (1) with uprights (5) to transoms (10).
7. Attach polyurethane idler strings to BTA mounts (2) with M16 bolts supplied. Securely fasten bolts and nuts.
8. Attach retaining chains (9) using chain links (8) with nyloc nuts.
9. Chain (9) connected to "T" link (7) which is bolted to transoms (10).
  - *Note:* - Belt direction.
10. Check centre roll height, the belt should just be in contact. If necessary add spacers under the transom ends. Or if the unit needs to be lowered notch the transom ends and re-weld hold down plates.
11. Securely fasten system to conveyor stringers.
12. Check that polyurethane idler strings do not catch on transoms and that there is freedom of movement of the polyurethane idler strings in a vertical direction.
13. Check chute sealing to the conveyor belt, preferably fit BRELKO KEYSKIRT to contain any spillage.

***Note: - Standard units are for installation in a horizontal position only.***

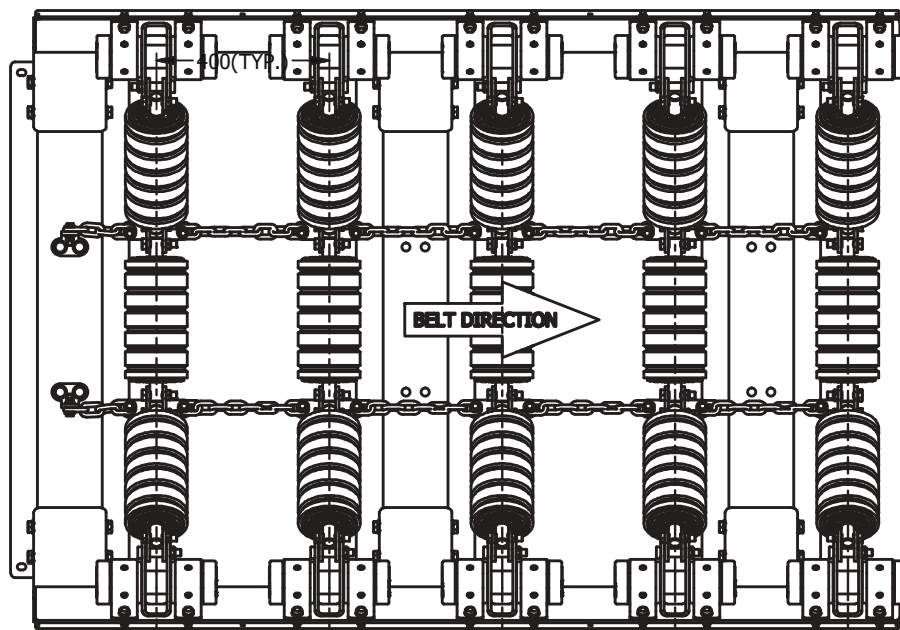
***For inclines etc... refer to the Brelko Design Dept.***

## HI-IMPACT IDLER SYSTEM WITH IMPACT ABSORBING DUAL TORSION ARM MOUNTING

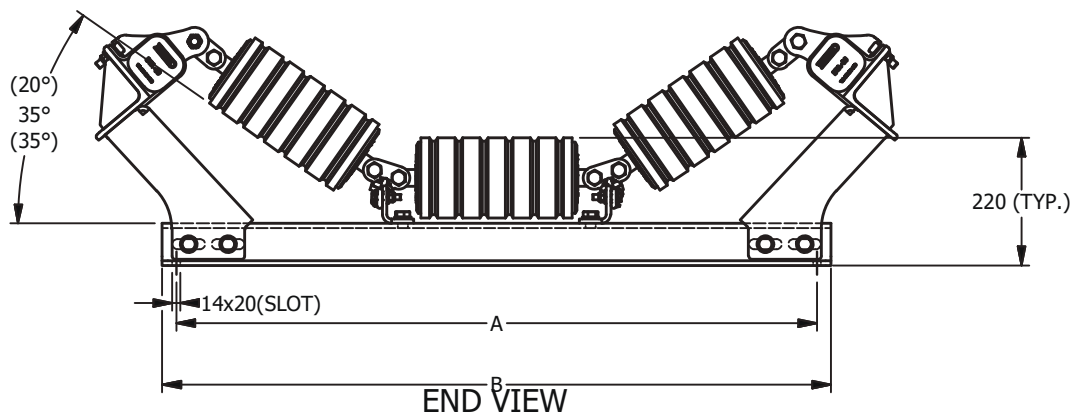
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SIDE VIEW



PLAN VIEW



END VIEW

DIMENSION TABLE (mm)											
BELT WIDTH	600	750	900	1050	1200	1350	1500	1650	1800	2100	2400
A	838	990	1144	1296	1448	1600	1752	1904	2058	2362	2668
B	918	1070	1224	1376	1528	1680	1832	1984	2138	2442	2748
C (AT 35°)	604	757	870	1017	1154	1301	1467	1584	1705	1960	2245

STANDARD CONSTRUCTION & FINISHES FOR BELT WIDTHS FROM  
600mm TO 2400mm

NOTE: INSTALLATION DETAILS: STANDARD SUPPLY

PLEASE SPECIFY BELT WIDTH  
WHEN ORDERING

DRW.  
No. BTA-024

REV. E

## 7. Procedure for Replacing/Repairing Hi-impact Systems

Repair/replace Hi-impact System components when, general maintenance tasks are preformed. Hi-impact System damage due to over loading, blocked chutes etc.

- 7.1. Request permit to work from an authorised person, who will isolate and lock out the belt.
- 7.2. Remove existing idlers and rolls from conveyor structure in the area where the system is to be installed.
- 7.3. If assembled remove polyurethane idler strings, and the support beam (1) with uprights (5).
- 7.4. Check direction of belt travel and slide unit under conveyor belt from one side.

**Note:** For larger sizes lifting equipment may be required.

- 7.5. Position unit in impact zone and align centrally to belt.
- 7.6. Attach support beam (1) with uprights (5) to transoms (10).
- 7.7. Attach polyurethane idler strings to BTA mounts (2) with M16 bolts supplied. Securely fasten bolts and nuts.
- 7.8. Attach retaining chains (9) using chain links (8) with nyloc nuts.
- 7.9. Chain (9) connected to "T" link (7) which is bolted to transoms (10).  
**Note:** Belt direction.
- 7.10. Check centre roll height, the belt should just be in contact. If necessary add spacers under the transom ends. Or if the unit needs to be lowered notch the transom ends and re-weld hold down plates.
- 7.11. Securely fasten system to conveyor stringers.
- 7.12. Check that polyurethane idler strings do not catch on transoms and that there is freedom of movement of the polyurethane idler strings in a vertical direction.
- 7.13. Check chute sealing to the conveyor belt, preferably fit BRELKO KEYSKIRT to contain any spillage.





## CONVEYOR BELT & EQUIPMENT CHECK LIST / QCP

### CUSTOMER DETAILS

Customer Name:		Contact Number:	
Attention:		Date of Inspection	
Inspected By		Brelko Representative	

### CONVEYOR DIMENSIONS

Belt Number:		Material Carried:		Belt Speed:	
Belt Length:		Belt Width:		Troughing Angle:	
Top Cover Condition:				Bottom Cover Condition:	
Splice:	Yes	No	Clip Joint:	Yes	No
Conveyor Running	Yes	No	Inspection Tags:	Yes	No
Edge Damage:	Yes	No			
Comments:					

### HEAD END / HEAD CHUTE

Chute Condition:		Head Pulley Lagging:	
Snub Pulley Lagging:		Build up:	
Belt Movement:			
Comments:			

### IDLER CHECK

Trough Idler Condition:		Return Idler Condition:	
Troughing Frame Condition:		Return Frame Condition:	
Comments:			

### PRIMARY SCRAPER

Position Correct:	Yes	No	Type of Primary Scraper installed:	
(Contact of Scraper Blade must be between 10 to 30 degrees, under the pulley horizontal line.)				
Mounts firmly mounted:	Yes	No	All bolts, nuts tightened:	Yes
Adequate Tensioning:	Yes	No	All Caps, Denso Tape in place:	Yes
Housekeeping:				
Chute Material build up:				
Blade Wear:	Low	Medium	High	Cleaning:
				Poor
				Fair
				Good
Comments:				

### SECONDARY SCRAPER #1

Type / Model of Secondary Scraper Installed:										
Positioning Correct:										
(Scraper blade must preferably be a minimum 100mm from pulley tangent.)										
All Caps, Denso Tape in Place:	Yes	No	Mounts firmly mounted:	Yes	No					
All Bolts & Nuts Tightened:	Yes	No	Adequate tension/adjustment:	Yes	No					
Angle Correct Set:	Yes	No	Carrier Frame cut to size	Yes	No					
Angle of scraper must be 90 degrees to the conveyor belt, dependant on conditions.										
Chute / Material build up:	Yes	No	Housekeeping:							
Blade wear:	Low	Medium	High	Cleaning:	Poor					
					Fair					
					Good					
Comments:										

### SECONDARY SCRAPER #2

Type / Model of Secondary Scraper Installed:											
Positioning Correct:											
Scraper blade must preferably be a minimum 100mm from pulley tangent.											
All Caps, Denso Tape in Place:	Yes		No		Mounts firmly mounted:	Yes		No			
All Bolts & Nuts Tightened:	Yes		No		Adequate tension/adjustment:	Yes		No			
Angle Correct Set:	Yes		No		Carrier Frame cut to size	Yes		No			
Angle of scraper must be 90 degrees to the conveyor belt, dependant on conditions.											
Chute / Material build up:	Yes		No		Housekeeping:						
Blade wear:	Low		Medium		High	Cleaning:	Poor		Fair		Good
Comments:											

### TAKE UP PULLEYS / COUNTERWEIGHT / PLOUGH

Type / Model of Plough Installed:											
Are Flat Return Idlers Installed:	(In front)	Yes		No		(Behind)	Yes		No		
Any excessive belt movement:	Yes		No		Adequate space for material to fall off of conveyor belt	Yes		No			
Is the Plough firmly mounted:	Yes		No		Is the Safety Chain firmly mounted and correctly adjusted:	Yes		No			
Is the Plough Free moving:	Yes		No		Is the entire Blade / Nose Piece in contact with the conveyor belt:	Yes		No			
Housekeeping:											
Comments:											

### CONVEYOR BELT TRACKING / ALIGNMENT

Is the Belt Tracking centre:	Yes		No		Are there any Tracking Systems installed:	Troughing		Return	
Is there any visible damage to structure caused by poor belt tracking:	Yes				No				
Conveyor belt length:					Are the tracking systems correctly positioned:	Yes		No	
Are the tracking systems firmly mounted:	Yes		No		Are all bolts & nuts tightened:	Yes		No	
Are all Idlers in contact with the Belt - Adequate Tension on the system:	Yes				No				Housekeeping:
Comments:									

### LOADING / TRANSFER CHUTE

Chute Condition:	Poor		Fair		Good		Material loading in centre of conveyor belt:			
Dead Boxes:	Yes		No		Deflector Plates:	Yes		No		Drop Heights:
Tail Pulley Condition	Good			Fair		Poor				
Comments:										

### KEYSKIRTING®

Size of Keyskirt®:	1		2		3		4		Length of Keyskirt® Installed :			
Positioning of Keyskirt® :									Other Product used as Skirting	Yes		No
Mounting Arrangement	Std.						Offset			Other		
All bolts & nuts securely fastened:	Yes			No		Housekeeping:						
Comments:												

### FEEDBOOTS

Type of Feedboot installed:	Universal		Combination		Is the system correctly positioned:	Yes		No	
					(System to be positioned centrally to the load area.)				
Drop Height:					Is the system securely mounted:	Yes		No	
All Bolts & Nuts tightened:	Yes		No		Condition of Idlers:	Poor		Fair	
Lead in and lead out Idlers in place:	Yes		No		Condition of UHMW Liners:	Low		Medium	
Housekeeping:									
Comments:									

### HI - IMPACT SYSTEM

Type of Hi - Impact system installed:									
Is the system correctly positioned:	Yes		No		Drop heights:				
System to be positioned centrally to the load area.									
Is the system securely mounted:	Yes		No		All bolts & nuts tightened:	Yes		No	
Are all Idlers in contact with the belt:	Yes		No		Idler condition:	Poor		Fair	
BTA Condition:	Poor		Fair		Good	Are chains / D shackles in place & securely fastened:	Yes		No
All Hardware in Good Condition:	Yes		No		Housekeeping:				
Comments:									

### AIR CANNONS

Size of Air Cannon Installed:	5ltr		Quantity		10ltr		Quantity	
	25ltr		Quantity		50ltr		Quantity	
	100ltr		Quantity		200ltr		Quantity	
Is the Air Cannon securely fastened onto the structure:	Yes		No		Is an Air Lance installed:	Yes		No
Size of the Air Lance:					Are the Air Cannons correctly positioned:	Yes		No
Power supply:					Air supply:			
Operating system:	Single timer		PLC		Manual push button		Sequential	
All Bolts & Nuts securely tightened:	Yes		No		All components in good order:	Yes		No
Distance between Air Cannon & Solenoid Valve:					Any Air Leaks in the Pipe Work:	No		
Is a Water Trap Installed:	Yes		No		Is a Lubricator installed:	Yes		No
Distance from Air Cannon:					Distance from Air Cannon:			
Are the safety / warning signs in place and visible:	Yes		No		Housekeeping:			
Comments:								

### TAIL PULLEY / PLOUGH

Type / Model of Plough Installed:								
Are Flat Return Idlers installed:	(In front)	Yes		No		(Behind)	Yes	
Any excessive belt movement:	Yes		No		Adequate space for material to fall off of conveyor belt:	Yes		No
Is the Plough firmly mounted:	Yes		No		Is the Safety Chain firmly mounted and correctly adjusted:	Yes		No
Is the Plough free moving:	Yes		No		Is the entire Blade / Nose Piece in contact with the conveyor belt:	Yes		No
Housekeeping:								
Comments:								

Brelko Supervisor

Name: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_

Customer

Name: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_



ISO 9001:2015  
ISO 14001:2015  
ISO 45001:2018

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## 10. Trouble Shooting

Problem	Possible Cause	Possible Solution
Belt Damage	Polyurethane idlers roll not in full contact with the conveyor belt.	Adjust to correct height - refer installation instructions
Polyurethane Idler Roll Damage	Hi-impact System in incorrect position.	Reposition Hi-impact System so that the load is evenly distributed across the full length of the Hi-impact System.
	Broken or loose polyurethane idler roller retaining chains.	Repair or replace retaining chains.
	Incorrect selection of equipment.	Consult your Brelko Conveyor Product representative or alternatively contact Brelko's Technical Department