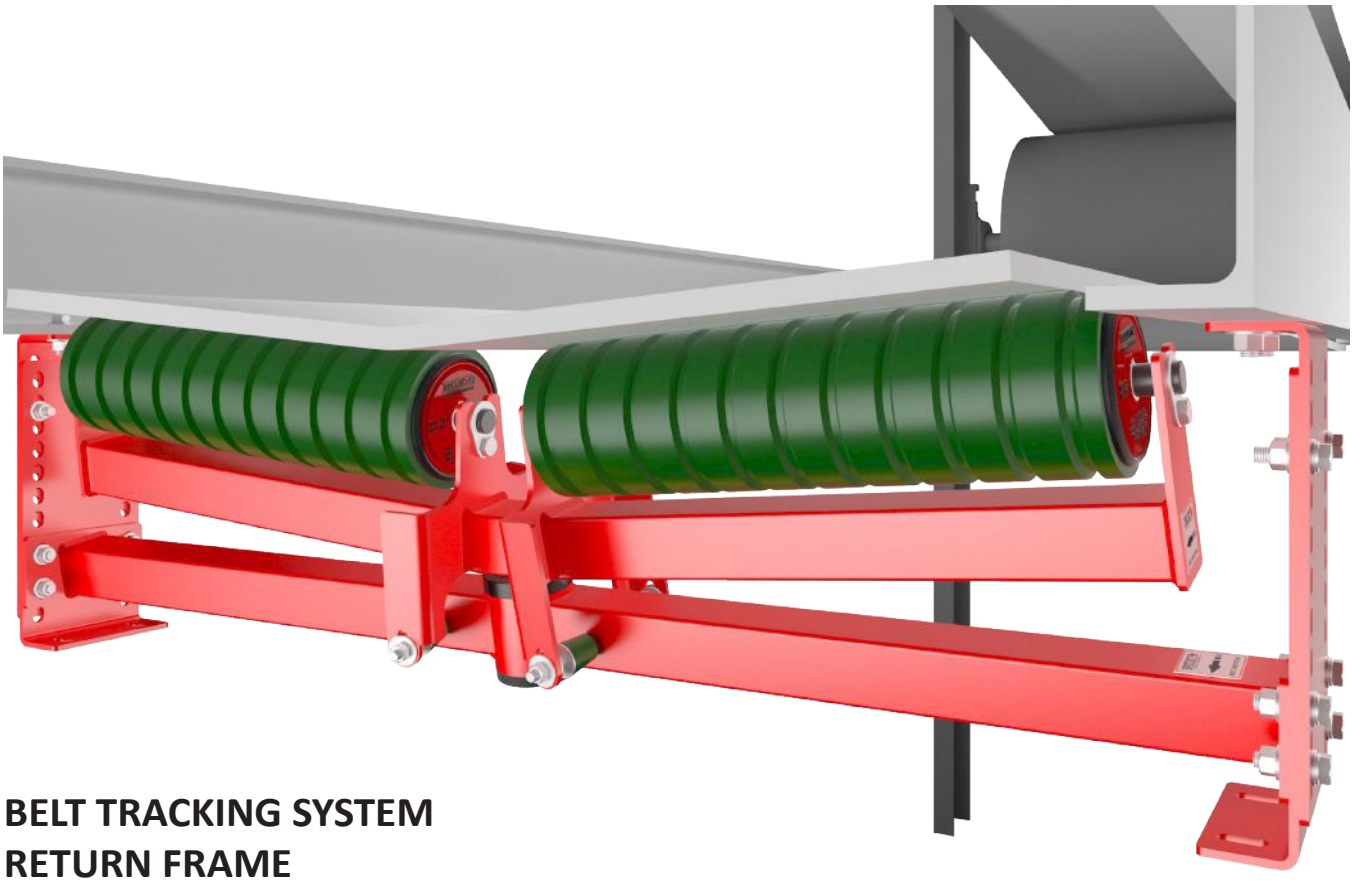
BRELKO®
CONVEYOR PRODUCTS

INSTALLATION, OPERATING & MAINTENANCE MANUAL



BELT TRACKING SYSTEM
RETURN FRAME

PATENTED

Project Name	:	.
Project Number	:	.
Order Number	:	.
	:	.
Model Number	:	.
Purchase Date	:	.
Purchased From	:	.
Installation Date	:	.
	:	.

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.

P.O. Box 62392 Marshalltown 2107 Tel: +27 11 013 4000 Fax: +27 11 013 4150 E-Mail: sales@brelko.com Web: www.brelko.com

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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	Danger: Immediate hazards that will result in severe personal injury or death.
⚠ WARNING	Warning: Hazards or unsafe practices that could result in personal injury.
⚠ CAUTION	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 Belt Tracking Systems are designed to operate with minimum maintenance. However, to maintain superior performance some service is required. When the Belt Tracking System is installed a regular maintenance program should be set up. This program will ensure that the Belt Tracking System operates at optimal efficiency and problems can be identified and fixed before the Belt Tracking System stops working. All safety procedures for inspection of equipment (stationary or operating) must be observed. Belt Tracking Systems operate along the length of the conveyor and are 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.

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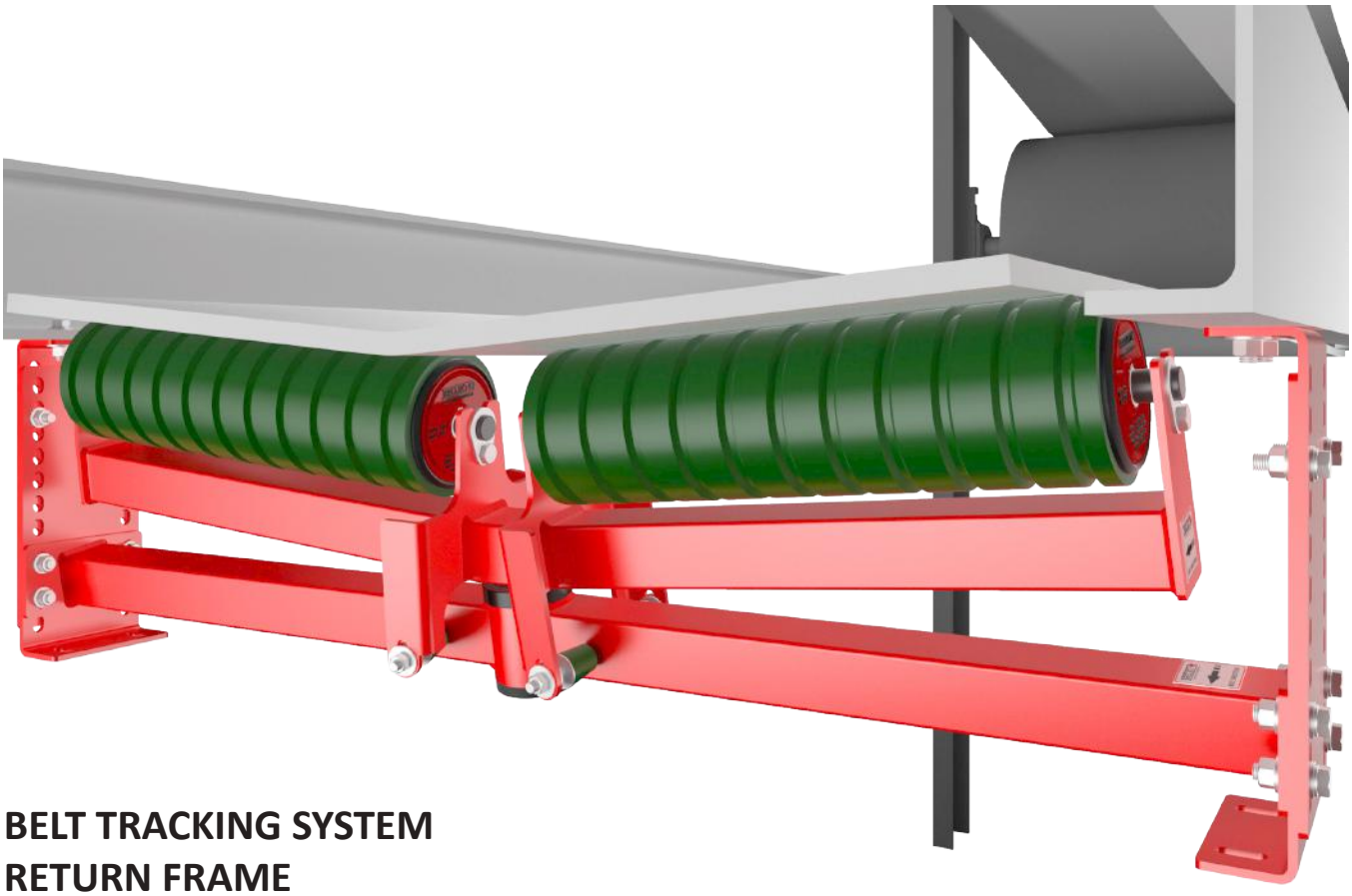

BELT TRACKING SYSTEM
RETURN FRAME

PATENTED

APPLICATIONS

- Install the Belt Tracking System on the return side of the belt to centralise a misaligned belt, prevent belt edge damage, prevent structural damage, decrease downtime, decrease maintenance and extend belt life.

FEATURES

- Easy installation.
- Low maintenance.
- Vibration free rolling action.
- Simple design.
- Operates in all conditions.
- Manufactured according to S.A.B.S. & PROK mounting standards, but can accommodate other standards on request.
- Fully sealed construction of bearing housing prevents ingress of material into the bearing unit.
- Robust construction for longer life.
- Proven polyurethane coated impact rolls, last up to 3 times longer than standard rubber lagged.

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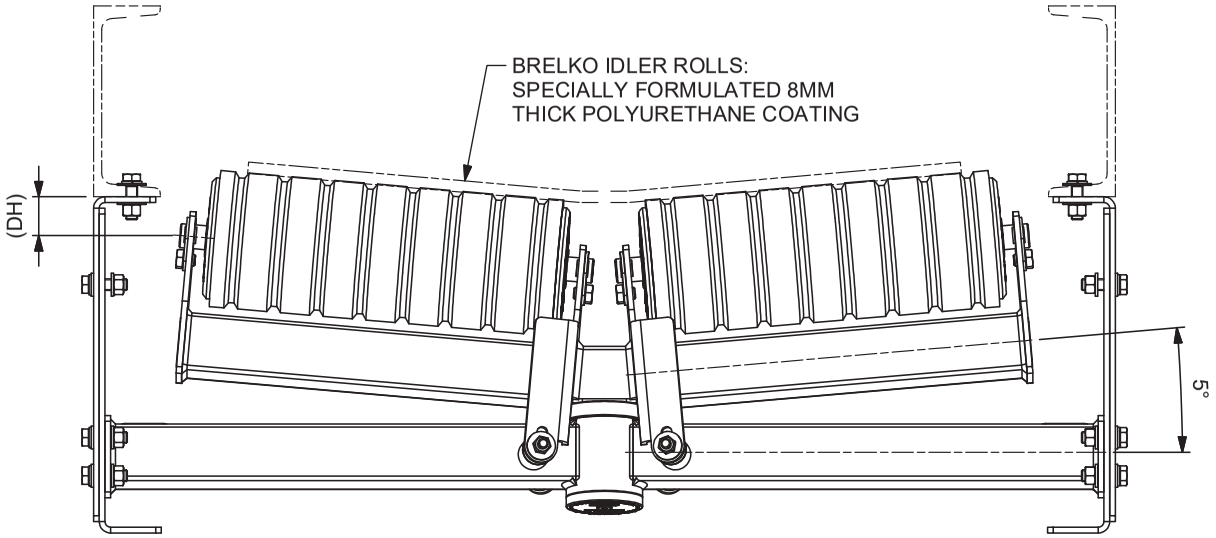
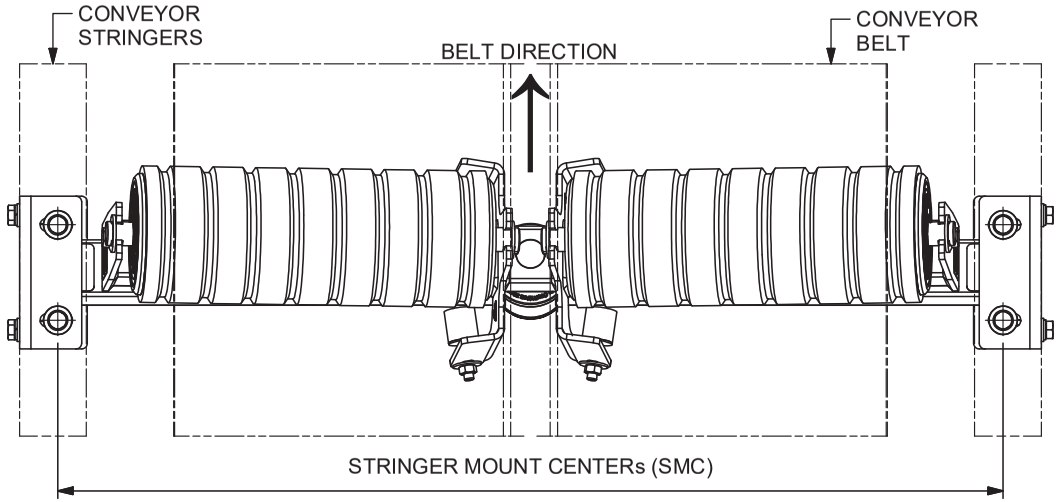
BELT TRACKING RETURN FRAME - 5°



STANDARD CONSTRUCTION & FINISHES FOR BELT WIDTHS FROM:

350 - 3000

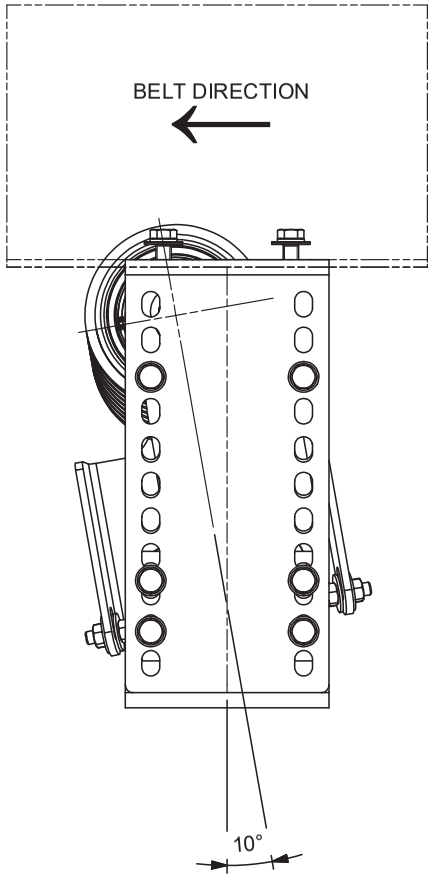


NOTE:
* DH = DROP HEIGHT

SIZE RANGE:
SIZE 1: 350 - 1200BW
SIZE 2: 900 - 3000BW
SIZE 3: 1350 - 3000BW

SIZE 1& 2 :

Size 3 (On Request Only)
MULTIPLE MOUNTING POSITIONs



STANDARD MOUNTING

FEATURES & OPTIONS: BELT TRACKING RETURN FRAME

DRW. No. BTR-006-FO - 5D

REV. 04

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CONVEYOR PRODUCTS

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.

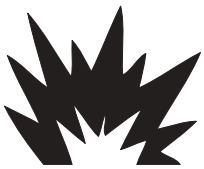
5.2. Work Safety

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.

⚠ WARNING

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.

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5.3. Handling

When Belt Tracking Systems 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

Belt Tracking Systems can be stored unpacked or in transportation package. Belt Tracking Systems 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

BELT TRACKING RETURN 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	PIPE WRENCH 650MM
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

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Recommended Tools List (continued...)

BELT TRACKING RETURN SYSTEMS	
QTY	**DESCRIPTION**
1	ANGLE FINDER
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

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6. Maintenance

Brelko Belt Tracking Systems are designed to operate with minimum maintenance. However, to maintain superior performance some service is required. When the Belt Tracking System(s) are installed a regular maintenance program should be set up. This program will ensure that the Belt Tracking System operates at optimal efficiency and problems can be identified and fixed before the Belt Tracking System stops working. All safety procedures for inspection of equipment (stationary or operating) must be observed. 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 Belt Tracking System has run for a few days a visual inspection should be made to ensure the Belt Tracking System is performing properly. Make adjustments as needed.

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

A visual inspection of the Belt Tracking System and belt can determine:

- If the mounts are adjusted at the correct height for optimal roller contact;
- If the rollers are worn and needs to be replaced;
- If there is damage to the bearing or other components; and,
- If fugitive material is built up on the Belt Tracking System.

If any of the above conditions exist, a determination should be made on when the conveyor can be stopped for Belt Tracking 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 Belt Tracking System performing the following tasks:

- Clean material build-up off of the Belt Tracking System.
- Closely inspect rollers for wear and any damage. Replace if needed.
- Ensure full roller to belt contact;
- Inspect the Belt Tracking System for damage;
- Inspect all fasteners for tightness and wear. Tighten or replace as needed.
- Replace any worn or damaged components i.e. bearings etc.
- Check the pressure of the Belt Tracking System on the belt. Adjust pressure if necessary.

When maintenance tasks are completed, test run the conveyor to ensure the Belt Tracking System is performing properly.

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PARTS LIST - REF. DRW. No.: BTR-007-PL-5D

ITEM No.	DESCRIPTION	SIZE (mm)	BELT WIDTH (mm)	CODE
A.	Transom - Consisting of Spacer, Bolts, Nuts and Washers	60.3 SQR 76.2 SQR	350-1200 900-3000	Size 1 - Specify belt width Size 2 & 3 - Specify belt width
B.	Idler Frame - Excluding Bearing Set.	60.3 SQR 76.2 SQR	350-1200 900-3000	Size 1 - Specify belt width Size 2 & 3 - Specify belt width
C	Bearing set - Consisting of Deep Grooved Ball Bearing, Trust Bearing and Bearing Seal.	DIA 80mm DIA 110mm	350-1200 900-3000	077-100-0003 077-100-0004
D	Idler Roll (Polyurethane)	Series 25 Series 30 Series 40	350-1200 900-3000 1350-3000	Specify belt width Specify belt width Specify belt width - On request only
E.	Mounting Bracket (LH & RH) including Bolts, Nuts, and Washers.	Size 1 Size 2 Size 3	350-1200 900-3000 1350-3000	077-545-0051 077-545-0061 077-545-0072
F.	Hardware kit consisting of Idler Roll Retaining washers complete with Locking Screws & Bottom Cap retaining Screw.	Series 25 Series 30 & 40	350-1200 900-3000	077-100-0015 077-100-0016
G.	Spacer & Bottom Cap Set	Series 25 Series 30	350-1200 900-3000	077-100-0007 077-100-0008

NOTE! Always quote belt width.

ASSEMBLY INSTRUCTIONS

1. Referring to the parts list, check that the correct parts and quantities have been supplied for the model and belt width of Belt Tracking System ordered.
2. Proceed with installation as per installation guide.

SURVEY

1. Before installing the Belt Tracking System, carefully inspect the entire length of the conveyor belt. Identify areas of conveyor belt misalignment. Contributing factors include concave pulleys, where the centre of the pulley has collapsed, and uneven rubber wear on pulleys.
2. Tell-tale marks indicate problem areas where a drifting conveyor belt has come into contact with the structure for instance, damaged drop brackets and structure.
3. Tail, head and take-up pulleys identify areas of greatest damage caused by badly aligned belts.

GUIDELINES

1. One correctly installed Belt Tracking System can control misalignment for about 30 metres of belt and need only be installed on areas where misalignment occurs.
2. Always install the Belt Tracking System ahead of the problem area.
3. To obtain maximum belt alignment, use the maximum face length of the Belt Tracking System. This ensures that you obtain the optimum working life from the Belt Tracking System.
4. Insufficient traction between the belt centralising idler frame set and the belt leads to severe rubber wear. Although the Belt Tracking System will kick in and control the belt, there won't be enough tension to successfully centre the belt on the Belt Tracking System. This results in chafing of the Belt Tracking System polyurethane lagged rollers. By increasing the tension; the Belt Tracking System will centralise the belt and return to a state of equilibrium.

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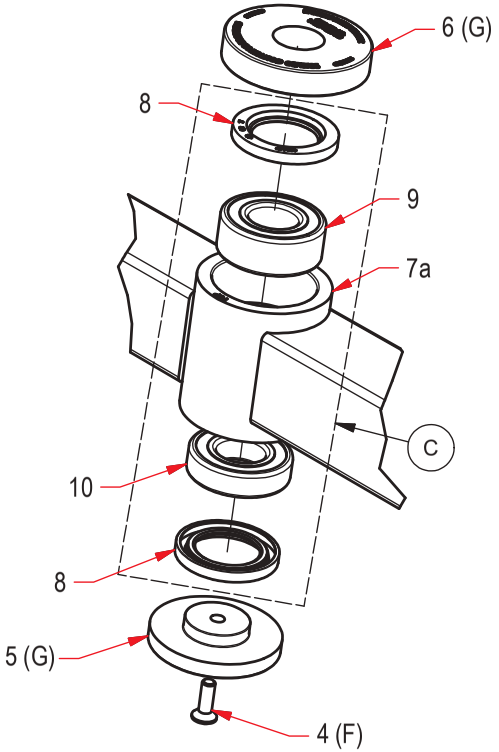
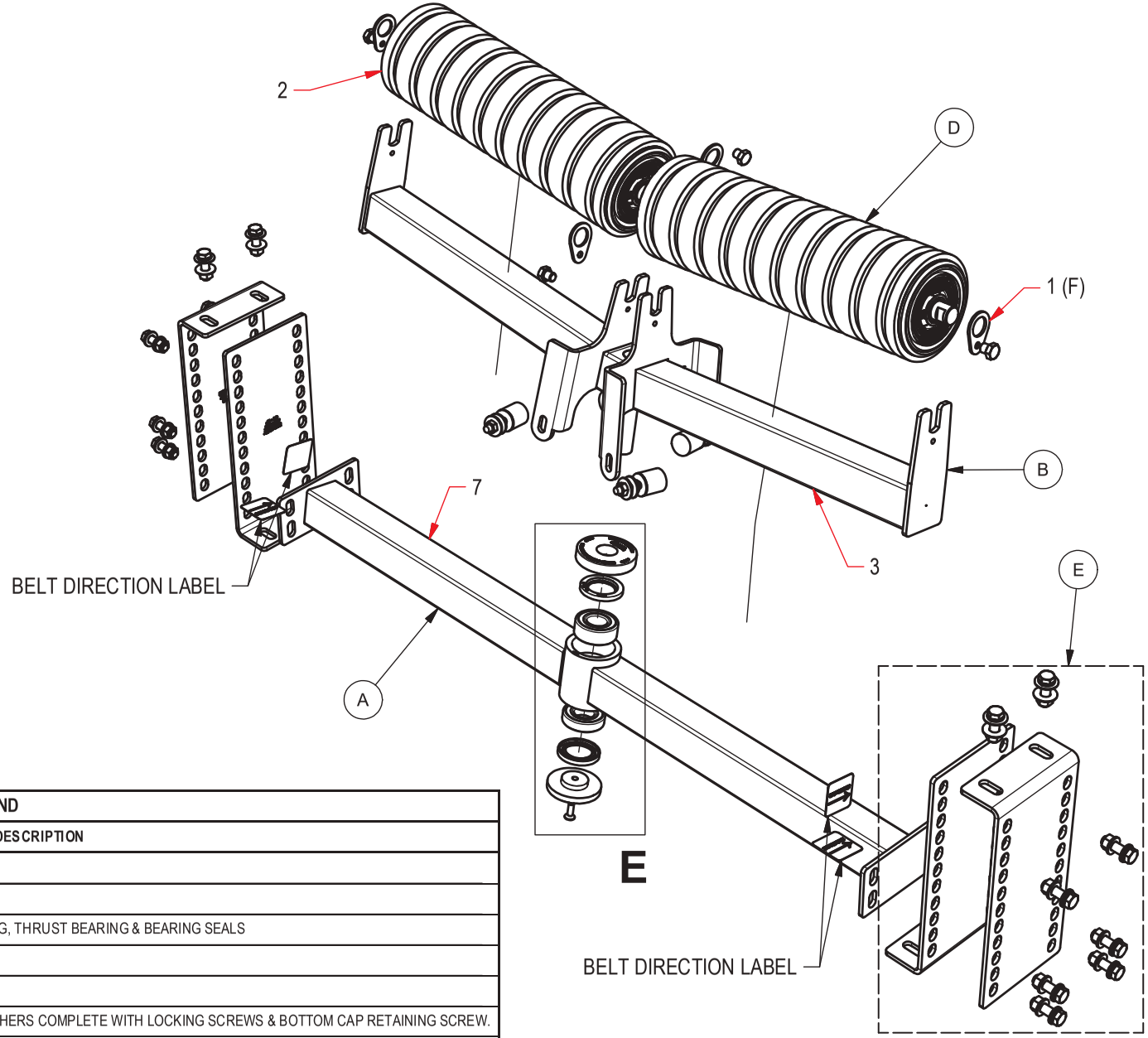
BELT TRACKING RETURN FRAME - 5°



DETAIL E



E

LEGEND	
COMPONENT ID	DESCRIPTION
A	TRANSOM ASSEMBLY
B	IDLER FRAME ASSEMBLY
C	BEARING SET - CONSISTING OF DEEP-GROOVED BALL BEARING, THRUST BEARING & BEARING SEALS
D	IDLER ROLL - POLYURETHANE MOULDED COVER
E	MOUNTING BRACKETs - INCLUDING BOLTS, NUTS & WASHERS
F	HARDWARE KIT - CONSISTING OF IDLER ROLL RETAINING WASHERS COMPLETE WITH LOCKING SCREWS & BOTTOM CAP RETAINING SCREW.
G	SPACER & BOTTOM CAP SET

PARTS LIST: BELT TRACKING RETURN FRAME

PLEASE SPECIFY BELT WIDTH WHEN ORDERING

DRW. No. BTR-007-PL - 5D

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INSTALLATION GUIDE - REF. DRW. No.: BTR-008-IN-5D

1. After identifying the problem area on the return side of the belt, prepare to install the Belt Tracking System ahead of the problem area, ensuring that it is installed ahead of the tail pulley.
2. Position the Belt Tracking System in place of an existing return idler set, before the problem area.
   - *Note:* - The Belt Tracking System is direction sensitive and therefore has to be installed correctly. Each Belt Tracking System has "Belt Direction Labels" on the frame.
3. Bolt the Belt Tracking System on to the structure. Before tightening, ensure the Belt Tracking System is perpendicular to the structure. Once completed, tighten all bolts.
   - *Note:* - Ensure all the rollers contact the belt.
   - *Note:* - Adjust the gap between the roller frame rubber stoppers (x) and transom (x) to +-5mm.
4. Installation is now complete, start the conveyor belt to test the Belt Tracking System.
   - *Note:* - If the desired steering is not achieved increase or decrease the gap between the roller frame rubber stoppers tansom (x) until the desired result is achieved.
5. If the problem still persists, knock the existing standard troughing frames perpendicular to the structure before and after the Belt Tracking System.
6. Remove any other tracking devices in front of or behind the Belt Tracking System, as they will reduce or interfere with the performance of the Belt Tracking System.

CAUTION!!!

This equipment should only be installed, operated & maintained by people competent and familiar with conveyor systems. Improper use or adjustment can result in serious personal injury or damage to equipment.

IF IN DOUBT ASK!!!

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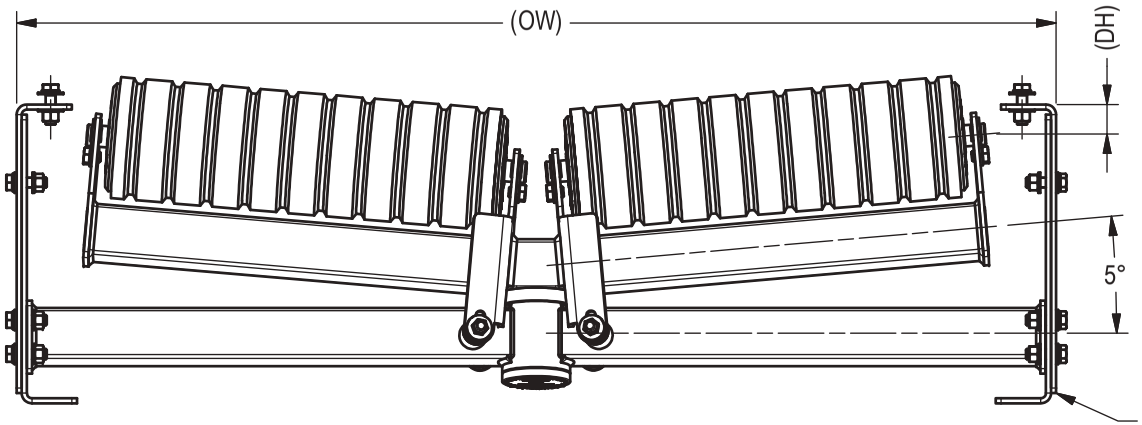
BELT TRACKING RETURN FRAME - 5°

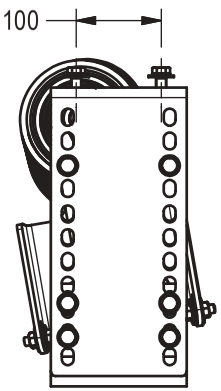


FRONT VIEW

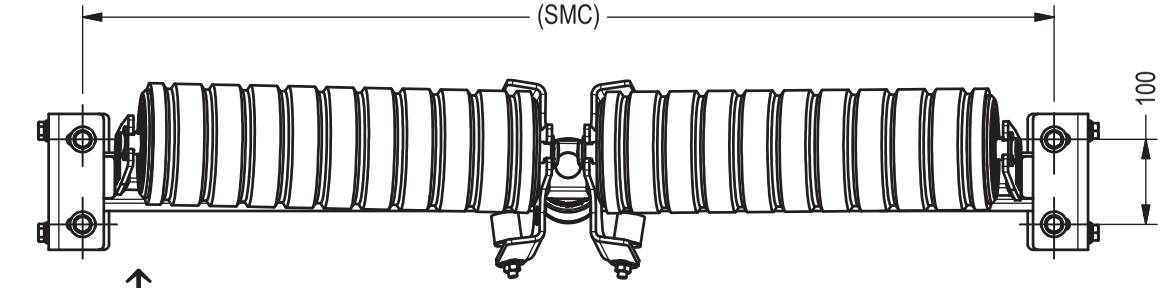
STD MNT ARGMNT FRM BRELKO
- SZ 1: 350 - 1200BW
- SZ 2: 900 - 3000BW
- SZ 3: 1350 - 3000BW *

*ON REQUEST ONLY

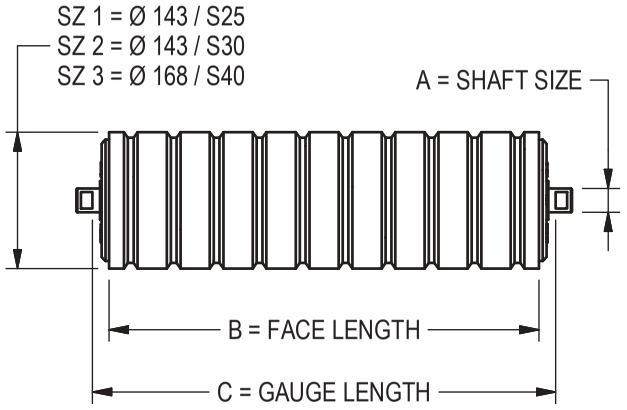
BELT DIRECTION



SIDE VIEW



TOP VIEW



IDLER ROLL
(BRELKO POLYURETHANE-COATED)

INSTALLATION DETAIL: BELT TRACKING RETURN FRAME

DRW. No.	BTR-008-IN - 5D	REV.	04

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BELT TRACKING RETURN FRAME - 5°

BELT TRACKING RETURN FRAME - SABS

BELT WIDTH	400	450	500	600	750	900	1050	1200	1350	1500	1650	1800	2000	2100	2200	2400
SIZE	1								OW = "OVERALL WIDTH"							
OW	714	766	816	918	1070	1224	1376	1528								
SMC	634	686	736	838	990	1144	1296	1448								
DH	* UP TO 150mm								SMC = "STRINGER MOUNTING CENTERs"							
A	Ø 25 (SHAFT SIZE)															
B	180	225	225	270	360	450	495	585								
C	210	250	260	310	400	485	546	620								
TRNSM	60.3 SQR								DH = "DROP HEIGHT"							
IDLR CAR	60.3 SQR															
SIZE						2			OW = "OVERALL WIDTH"							
OW						1224	1376	1528								
SMC						1144	1296	1448								
DH						* UP TO 150mm			SMC = "STRINGER MOUNTING CENTERs"							
A						Ø 30 (SHAFT SIZE)										
B						450	495	585								
C						485	546	620								
TRNSM						76.2 SQR			DH = "DROP HEIGHT"							
IDLR CAR						76.2 SQR										
SIZE	OW = "OVERALL WIDTH"								3							
OW									1680	1832	1984	2138	2340	2442	2544	2748
SMC									1600	1752	1904	2058	2260	2362	2464	2668
DH									* UP TO 150mm							
A	SMC = "STRINGER MOUNTING CENTERs"								Ø 40 (SHAFT SIZE)							
B									664	720	810	855	979	1035	1035	1170
C									698	775	850	895	1004	1085	1085	1195
TRNSM	DH = "DROP HEIGHT"								76.2 SQR							
IDLR CAR									76.2 SQR							

BELT TRACKING RETURN FRAME - PROK

BELT WIDTH	350	400	450	500	600	650	750	800	900	1000	1050	1200	1350	1400	1500	1600	1650	1800	2000	2100	2200	2400	2500	2600	2800	3000
SIZE	1												OW = "OVERALL WIDTH"													
OW	680	730	780	830	930	980	1080	1130	1230	1330	1380	1530														
SMC	600	650	700	750	850	900	1000	1050	1150	1250	1300	1450														
DH	* UP TO 150mm												SMC = "STRINGER MOUNTING CENTERs"													
A	Ø 25 (SHAFT SIZE)																									
B					349	349	405	405	484	540	540	630														
C					363	380	439	460	510	570	581	670														
TRNSM	60.3 SQR												DH = "DROP HEIGHT"													
IDLR CAR	60.3 SQR																									
SIZE									2				OW = "OVERALL WIDTH"													
OW									1230	1330	1380	1530														
SMC									1150	1250	1300	1450														
DH									* UP TO 150mm				SMC = "STRINGER MOUNTING CENTERs"													
A									Ø 30 (SHAFT SIZE)																	
B									484	540	540	630														
C									510	570	581	670														
TRNSM									76.2 SQR				DH = "DROP HEIGHT"													
IDLR CAR									76.2 SQR																	
SIZE	OW = "OVERALL WIDTH"												3													
OW													1730	1780	1880	2080	2130	2280	2480	2580	2680	2880	2980	3080	3280	3480
SMC													1650	1700	1800	2000	2050	2200	2400	2500	2600	2800	2900	3000	3200	3400
DH													* UP TO 150mm													
A	SMC = "STRINGER MOUNTING CENTERs"												Ø 40 (SHAFT SIZE)													
B													720	720	765	844		934	1035		1125	1215	1294	1339	1429	1530
C													750	763	810	863		959	1064		1163	1264	1323	1362	1460	1565
TRNSM	DH = "DROP HEIGHT"												76.2 SQR													
IDLR CAR													76.2 SQR													

INSTALLATION DETAIL: BELT TRACKING RETURN FRAME | DRW. No. BTR-008-IN - 5D | REV. 04

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7. Bearing Replacement Guide - REF. DRW. BTR-007

In order to replace the Bearing housing the following must be followed.

7.1. Remove the idler roller retaining washers (1) and the idler rollers (2) from the idler frame (3).

Note: This step must be done carefully to prevent misplacing or losing any components.

7.2. Remove the locking screw (4), top cap (6), idler frame (3) and bearing spacer (5) from the transom (7).

Note: This step must be done carefully to prevent misplacing or losing any components.

7.3. Remove the bearing seal (8), thrust bearing (9) and deep grooved ball bearing (10) from the bearing housing (7a).

7.4. Replace worn and/or damaged bearings and bearing seal with the new components.

7.5. Re-assemble the Belt Tracking System.

7.6. With reference to the installation guide continue with the installation.

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CUSTOMER: _____ CODE: [ ][ ][ ] - [ ][ ]

Nº: 25853

ATTENTION: _____ CONTACT TEL: _____

CONTRACT/ORDER No.: _____ DATE IN: _____

JOB CARD
SERVICE WAYBILL

BELT No.	BELT SIZE	EQUIPMENT TYPE	MOUNT TYPE	EQUIPMENT CONDITION (AVERAGE / GOOD / EXCELLENT)	INSPECTION FINDINGS: BELT SCRAPER / PRODUCT: PRODUCT LIFE REMAINING (LOW / MEDIUM / HIGH)	INSPECTION FINDINGS: BELT SCRAPER / PRODUCT: CLEANING (AVERAGE / GOOD / EXCELLENT)	INSPECTION FINDINGS: CONVEYOR BELT and CHUTE: TOP COVER: NEW / EVEN	TOP COVER: GROOVES / WORN / UNEVEN	TOP COVER: PROTRUSIONS (CLIPS / SPLICED / LOOSE PATCH)	BUILD-UP: EXCESSIVE	BUILD-UP: AVERAGE	BUILD-UP: LITTLE	WORK DONE or ACTION RECOMMENDED: SPARES FITTED Mine Spares = M / Brelko Spares = B: BLADES / HOLDERS	MOUNTS	CARRIER ASSEMBLY	SPINDLES	SKIRTING	OTHER SPARES	ADJUST SCRAPER SET	TIGHTEN LOOSE NUTS & BOLTS	FURTHER INVESTIGATION	CLEANED	IMPORTANT NOTES / COMMENTS

ALWAYS REFER THE ABOVE COMMENTS TELEPHONICALLY TO THE RELEVANT PERSON

FOR SPELLING REFER TO THE GENERAL AND CONVEYING TERMS SHEET' INCLUDED IN THE INDEX SECTION OF THIS WAYBILL BOOK.

CUSTOMER REPRESENTATIVE : _____ TIME IN: _____
(please print)

CUSTOMERS SIGNATURE : _____ TIME OUT: _____

BRELKO REPRESENTATIVE : _____

SAFETY : _____

ISO 9001:2008
ISO 14001:2004
OHSAS 18001:2007

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SERVICE EXCELLENCE OVER 30 YEARS

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BRELKO®
CONVEYOR PRODUCTS

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		Cover Strip:	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		No		
Adequate Tensioning:	Yes		No		All Caps, Denso Tape in place:					Yes		No		
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:													

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CONVEYOR PRODUCTS

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		State	
Mounting Arrangement	Std.				Offset							Other			
All bolts & nuts securely fastened:			Yes		No		Housekeeping:								
Comments:															

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CONVEYOR PRODUCTS

FEEDBOOTS

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

HI - IMPACT SYSTEM

Type of Hi - Impact system installed:											
Is the system correctly positioned: System to be positioned centrally to the load area.	Yes		No		Drop heights:						
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		Good	
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		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:												

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
Poor Tracking	Tracker belt contact pressure too low.	Increase belt contact pressure, refer to installation instructions.
	Tracker belt contact pressure too high.	Decrease belt contact pressure.
	Tracker installed in wrong direction.	Verify directional labels - refer to installation drawing.
	Tracker stoppers not correctly adjusted.	Adjust accordingly - refer to installation instructions.
	Belt not in contact with all idlers	Adjust Tracker to ensure all idlers are in full contact with the belt - refer to installation instructions.
Wear on Rollers / Roller failure	Belt not in contact with all idlers	Adjust Tracker to ensure all idlers are in full contact with the belt - refer to installation instructions.
	Belt contact pressure too high/low.	Adjust to correct pressure, refer to installation instructions.
No Frame Movement	Material build-up and ingress of material on frame or components.	Clean and remove.
	Bearing failure.	Repair or replace - refer installation instructions
	Belt contact pressure too high/low.	Adjust Tracker to ensure all idlers are in full contact with the belt - refer to installation instructions.

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