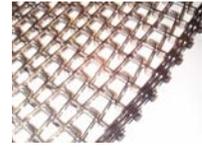




ASHWORTH ENGINEERING
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TECHNICAL BULLETIN

CLEANING TURN CURVE BELTS

Following are the general guidelines recommended by Ashworth Bros. for the cleaning and run-in of a new spiral belt.

Clean the belt

Initial cleaning should be done to the belt prior to beginning the run-in. By removing any debris that may have been deposited on the belt during shipping or installation, we hope to minimize any unnecessary internal wear of the belt components.

The belt needs to be cleaned with a mild soap and hot water. This needs to be followed by a clean water rinse. Particular attention should be given to the inside edge of the belt as any oils here would decrease the driving force of the belt and lead to high tension in the belt.

Clean the support rails

Attach rags or non-abrasive pads to the underside of the belt and run these through the system to clean the support rails. Remove the pads before they reach the drive sprockets.

Lubricate the belt

A light spray or application of silicon or other food grade lubricant needs to be applied to the belt. This allows the belt to polish the wear surfaces and prevent galling. The lubricant also acts as a film to separate the surfaces and minimize contact.

Run-in the belt

A run-in period of up to 200 hours (based on a belt speed of 60 feet per minute) may be needed to polish the wear surfaces. During the run-in period the belt should be washed periodically and re-lubricated. As a general guideline, wash and re-lubricate the belt every 48 hours of operation.

Additionally the following will aid in the removal of any debris that is created during run-in.

- Install strong bar magnets at the terminal rolls or the take-up. The addition of an air knife will assist in blowing the debris off the belt into the bar magnet.
- Insure that the belt is not insulated from ground. The belt will carry a small static electrical charge from the action of friction between the belt and wear strips, if this charge is not dissipated the charge will hold the debris to the belt surface.
- Periodically wash the walls, floor and ceiling along with the coils and fans with the mild soap solution. This will remove any debris that has become lodged on the enclosure surface from air born debris.
- Belt tension must be kept as low as possible to prevent hard rubbing of the metal surfaces. This can be obtained by increasing the overdrive or lubricating the rails (never the cage or inside edge).

* The soap solution that we customarily use is a mixture of 25% mild dish washing soap and water applied using a garden pump sprayer. We recommend the dishwashing soaps because they usually have a form of silicon added for the minimization of water spots. This silicon also acts as lubricant for the belt.

A caustic wash may be necessary due to health or other safety requirements. We do not recommend that caustic solutions be left on the belt or used any more or stronger than absolutely necessary to meet local regulations. Proper precautions must always be followed when using caustics and always follow the directions according to the manufacturer. When selecting a caustic cleaner consult your local chemical supplier to check for compatibility of the cleaner with the belt and support materials.

Caution: Caustics and harsh chemicals can soften the belt supports and cage drive components allowing contamination of the plastic with abrasive particles leading to belt damage.

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