

Baking Band Tracking, Conditioning, & Inspection

Inspection

The baking band, oven, and other associated components should be inspected at regular intervals for correct operation and possible equipment or processing defects according to the following checklist:

Band

- ☐ Contains no product debris
- ☐ Equal tension across its full width
- ☐ Equal edge sag on both sides of the band
- ☐ No broken welds
- ☐ No curl along belt edges
- ☐ No broken wires
- ☐ Not out of crimp
- ☐ Not discolored
- ☐ Product load is evenly distributed

Oven

- ☐ Produces equal heat distribution across full belt width
- ☐ All vents are operating properly to prevent "zonal" heat build-up
- ☐ All oven doors are shut; if doors must be opened, open an equal number of doors on both sides of oven

Band Path

- ☐ No obstructions
- ☐ Not contacting framework
- ☐ Not overhanging any rollers
- ☐ Not passing under any rollers
- ☐ Does not waver through oven
- ☐ Does not waver at terminal drums
- ☐ Light contact with the controls
- ☐ All limit switches are properly located
- ☐ Cleaning brush is not binding

Terminals & Major Rolls

- ☐ "Flat-faced" (not crowned)
- ☐ Parallel to each other and perpendicular to the belt
- ☐ No build-up of product debris
- ☐ Shaft is not broken
- ☐ No objects between belt and drum

Control Systems

- ☐ Free turning
- ☐ Bearings are in good condition
- ☐ Bearings have been lubricated (if applicable)
- ☐ Roll faces are in good condition
- ☐ Rolls are free-pivoting
- ☐ Proper clearance exists between controls and belt
- ☐ Controls are located in the proper location

Roller Supports

- ☐ Free turning
- ☐ Exhibit concentric rotation
- ☐ No flat spots
- ☐ Shaft is not broken
- ☐ Properly adjusted
- ☐ Level

Take-Up

- ☐ Air pressure setting is correct
- ☐ Equal air pressure in both cylinders
- ☐ Adequate free travel
- ☐ Equal travel on both sides
- ☐ Tracks are clean

Slider Supports

- ☐ Level
- ☐ Securely fastened to the frame
- ☐ Smooth transition between joints
- ☐ Not warped or damaged
- ☐ No product debris