

INSTRUCTIONS FOR INSTALLING A NEW CONVEYOR BELT ON A DRYER



Not maintaining the proper tension (under and over tightening) on your conveyor belt will cause tearing, stretching, fraying or distortion. This warranty does not cover this problem.

G.P.I. conveyor belts are shipped after a five-point inspection to assure our quality standards.

CONVEYOR BELT INSTALLATION:

The top of the belt is on the outside of the rolled belt. Unroll the belt and lay it with the outside portion facing down. When installing the belt, the inside of the belt is always facing the conveyor rollers. Adjust dryer belt roller tension systems halfway in towards the dryer before starting to install the belt.



Before installing, you must check for belt squareness. If belt is used, no credit will be issued if found to be out of squareness. To check for squareness, measure diagonally from the upper right corner to the bottom left corner. Then measure diagonally from the upper left corner to the bottom right corner. If the lengths of both these diagonals is equal, then it is square.

Feed the dryer belt into the dryer exactly the way the dryer manufacturer recommends until the two belt ends meet. Connect the two (2) belt ends, making sure the belt ends interlock. Now thread the belt rod into the interlocked ends all the way across the belt.

TRACKING THE CONVEYOR BELT:

For proper belt tracking, rollers and conveyer must be parallel to each other. Adjust the conveyer to the desired height. Put a level on the rollers and the conveyer. Adjust the conveyer structure at the bottom of the legs. Make sure each roller is level. Do not turn on the conveyer until you have tightened the dryer belt roller tension system and the belt becomes slightly tight. **Do not over-tighten or allow the belt to slacken.**

(over)

For CONVEYORS, ROLLERS, DRIVES, EXTENSIONS and more,

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INSTRUCTIONS FOR INSTALLING A NEW CONVEYOR BELT ON A DRYER (continued)

Now turn on your dryer conveyor and carefully check the tension on both sides of the belt. The tension should be equal. If not equal, the belt will begin to track off the roller by shifting to the right or left. If this happens, slowly make adjustments as the belt is moving at the slowest speed with the least amount of tension. When the belt tracks to the left, you can either loosen the right adjustment or tighten the left roller adjustment. Make the adjustments on a fractional basis. Slowly add tension to the side that the belt is moving and release the tension from the other side. Over or under adjusting can cause the belt to shift too fast and become damaged. **Once the belt is tracking properly, continue to check the belt.** Turn on full heat in oven and continue to track belt by tension adjustment. Increase speed slowly to maximum. Run belt for time needed (usually 1-2 hours) until belt tracks with no further adjustments needed. Heat from the dryer may cause the belt to expand slightly. For now, check the belt one a week for three (3) weeks for full proper tracking tension. If this action is not taken, you may void your warranty.



If you over-tighten or under-tighten the belt, you will damage the belt. This damage is not covered under the warranty. PLEASE BE CAREFUL! Always maintain proper belt tension.

TO MAINTAIN CONVEYOR BELT FOR LONG LIFE:

Always turn the dryer heating element off and allow the conveyor belt to cool before stopping it. **Never leave a stationary conveyor in a hot dryer chamber.** Keep the roller bearings greased so they spin easily without binding. Do not stand on or place any objects other than those to be dried on the conveyor belt.

Check the conveyor belt on a regular basis for stretching, fraying, wearing, tearing or deterioration. Keep the belt stored in an upright position, covered in plastic and at room temperature when it is not on the dryer.



If you tear a hole in your belt, G.P.I. has Belt Repair Kits available. Don't wait too long to order as the kit is much less expensive than a new belt!

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