TROUBLE SHOOTING

Troubles	Causes	Countermeasures
Belt runs deviation to one side at a given section of the conveyor frame.	◎ Conveyor frame or structure crooked.	※ Check the affected area and adjust the straightness and levelness.
	◎ Idler stuck with materials.	※ Remove accumulation, install scrapers and other cleaning devices.
	◎ Idler poor running.	※ Improve maintenance and lubrication.
	◎ Idlers or pulleys out-of-square with center line.	※ Readjust the idlers in affected area.
	◎ Pulley center skews or sticks with materials.	※ Adjust the pulley center, install scrapers, and remove attachment.
	◎ Idlers in forepart of the affected area isn't perpendicular to the running direction of the belt.	※ Adjust it.
Particular section of the belt runs deviation at all parts of the conveyor frame.	◎ Belt joint crooked.	※ Cut off the joint section and resplice.
	◎ Insufficient straightness of the belt itself.	※ Install the automatic centering idler at the return section of the tail pulley.
Belt runs deviation for long distance or at entire length of the belt.	◎ Belt runs deviation near tail pulley within the carrying area.	※ Install the correcting idler in the front of the tail idler.
	◎ Materials are unevenly loaded on belt off center	※ Improve the loading position.
	◎ Idler stands not centered on belt.	※ Readjust the idler in the affected area.
	◎ Conveyor frame or structure crooked.	※ Check the affected area and adjust the straightness and levelness.

	◎ Belt sometimes runs deviation while sometimes not, which is often caused by the wind.	※ Install wind shelter and automatic centering idler.
	◎ Idlers on one side falls.	※ Make idlers level.
Belt runs deviation at tail pulley.	◎ Belt runs deviation around tail pulley through the loading area.	※ Install correcting idler prior to tail idler.
	◎ Material slippage or stacks.	※ Improve loading and transferring conditions, install cleaning devices and improve maintenance.
	◎ Idlers or pulleys out-of-square with center line.	※ Readjust the idlers in affected area.
Belt runs deviation at head pulley.	◎ Damages in coating rubber.	※ Replace pulley or recoat.
	◎ Material slippage or stacks.	※ Improve loading and transferring conditions, install cleaning devices and improve maintenance.
	◎ Idlers or pulleys out-of-square with center line.	※ Readjust the idlers in affected area.
	◎ Idler stands not centered on belt.	※ Readjust the idler in the affected area.
Belt slips.	◎ Insufficient traction pull between belt and pulley.	※ Thicken the coating rubber on the drive pulley and install cleaning devices.
	◎ Damages in coating rubber.	※ Replace pulley or recoat.
	◎ Counterweight too light.	※ Add counterweight or take-up pulley.
Scratch, cuts, stripping, or	◎ Insufficient length of	※ Adjust the length until the

abnormal wear on the top cover.	skirt board.	materials be stable on the belt.
	◎ Improper skirt materials or use used belt with the canvas exposed, getting in touch with the belt.	※ Select proper rubber skirt board.
	◎ The feeding speed of the material is inconsistence with belt running speed. The material slips at the moment of falling to the belt.	※ Adjust the feeding speed of material to be consistence with belt running speed.
	◎ Material stacks in or under chute.	※ Improve loading to reduce spillage and install chute with wider baffle.
	◎ Material impacts belt.	※ Improve the chute design to reduce impact and install impact idler or buffer-bed.
	◎ Return idler sticks with material.	※ Clean the accumulation or add cleaning devices.
	◎ Improper cover.	※ Replace with higher grade cover.
Scratch, tear, or abnormal wear on the bottom cover.	◎ Idler poor running.	※ Improve maintenance and lubrication
	◎ Belt slips on the drive pulley.	※ Fasten the stretching roller or add counterweight, increase contacting area.
	◎ Idler stuck with materials.	※ Remove accumulation, install scrapers and other cleaning devices.
	◎ Bolt protrudes the lagging.	※ Fasten the bolt, replace the lagging and better to use vulcanized lagging.
	◎ Material trapped between belt and pulley.	※ Install plows or scrapers on return side ahead the tail pulley.
	◎ Damages in coating rubber.	※ Replace pulley or recoat.

	◎ Carrier idler tilts forward excessively.	※ Lower the tilt angle to 2° less than the vertical direction.
Covers harden or crack.	◎ Heat or chemical damage.	※ Use belt designed for special conditions.
Bottom cover swells in spots or streaks.	◎ Idler oiling too much or sticking oil, grease from other parts of the belt frame.	※ Improve maintenance, use less lubrication oil and keep the oil seal in good condition.
Vulcanized joint separation.	◎ Improper splice. ◎ Pulleys too small. ◎ Material trapped between belt and pulley. ◎ Improper transition between belt and pulley.	※ Resplice in proper method according to DOUBE ARROW splice manual. ※ Use larger diameter pulleys. ※ Install plows or scrapers on return side ahead the tail pulley. ※ Adjust the transition area in accordance with DOUBLE ARRWO selection manual.
Excessive wear or break of the edge rubber.	◎ Off-center loading. ◎ Belt hitting conveyor structure. ◎ Belt crooked or insufficient straightness itself. ◎ Belt edge folded to the conveyor structure.	※ Adjust chute to make the load located at belt center, in the belt running direction and the unloading speed similar to belt running speed. ※ Install correcting idler at carrying and return side. ※ Install the automatic centering idler at the return section of the tail pulley. ※ Install limit switch.
Damages in carcass.	◎ Belt extruding frame due to off tracking which may cause longitudinal tear if severe. ◎ Due to the iron in feeding part.	※ Take measures to prevent the belt running deviation. ※ Remove the iron, use metal inspection or magnetic separator device at the place where such

		failures occur frequently
	◎ Material squeezed between belt and pulley, stab the belt.	※ Install scraper or cleaning device at the return side of tail pulley.
	◎ Belt impacted with large block material.	※ Improve the feeding device to reduce impact or use impact idler.
Carcass fatigue at idler junction.	◎ Carrier idler tilts forward excessively.	◎ Lower the tilt angle to 2° less than the vertical direction.
	◎ Insufficient transverse stiffness.	◎ Replace with proper belt.
	◎ Excessive sag between idlers.	◎ Increase tension and reduce idler spacing.
	◎ Improper design of convex arc section	◎ Increase curve radius or add idlers to make the belt transit stably.
	◎ Improper transition between belt and tail pulley in carrying section.	◎ Adjust transition length.
	◎ Excessive gap between idlers	◎ Replace idlers or use higher strength belt.