

PART 1 · RECEIVING AND STORAGE

A belt's life starts before it is fitted

Most early belt failures are set up long before the belt runs: a roll left in the sun, dragged off a truck by its edge, or stored flat on wet ground. A few habits on arrival protect everything you paid for.



Check the tag

Designation, width, length and roll number match the order and the test certificate.



Look for damage

Cuts, crushed edges or a flattened roll. Photograph anything and tell us the same day.



Store it indoors

Cool, dry and dark, away from motors, welding, ozone and direct sunlight.



Keep it off the floor

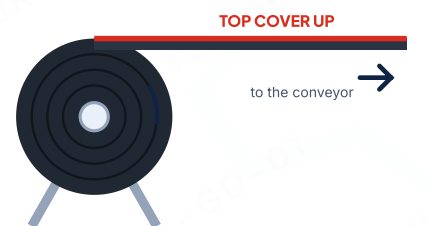
On its edge on a dry base, or hung on a bar through the core.

HANDLING A ROLL

- ✓ Lift with a steel bar through the core and a spreader beam, so the chains clear the belt edges.
- ✓ Roll it on its own circumference over smooth ground, in the direction that keeps it wound tight.
- ✓ Keep the roll's wrapping on until it reaches the conveyor.
- ✗ Never lift with slings or a forklift tine against the belt itself.
- ✗ Never drop a roll from the truck, even onto tyres or sand.
- ✗ Never drag the belt by its edge or stand the roll on wet earth.

STORING FOR MONTHS

- ✓ Store cool and dry, ideally below 25 °C, with the roll's wrapping left on.
- ✓ Turn a stored roll a quarter turn every month or so, so its weight does not settle on one side.
- ✓ Use older stock first. Note the roll number and date it arrived.
- ✗ Keep away from oils, solvents, acids and fuel stores.
- ✗ Keep away from electric motors, welding and anything that makes ozone.
- ✗ Do not cover with black plastic in the sun: it cooks the rubber.



Unrolling the right way round

Mount the roll on a shaft and stand at the conveyor. The belt must come off the roll with its **top cover facing up** on the carrying side. The top cover is the thicker one: check the marking or measure both faces at the roll end before you pull.

Brake the shaft lightly so the roll does not overrun and loosen as you pull.



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PART 2 · FITTING AND JOINTING

Fitting a new belt, step by step

- 1 **Get the structure right first**
Pulleys and idlers square to the centre line, every idler turning freely, scrapers and skirts set back. A new belt will not fix a crooked conveyor, it will only show it up.
- 2 **Set the take-up to its shortest**
Wind a screw take-up in, or lift and pin a gravity weight, so the new belt is fitted at the shortest length and has travel left to stretch into.
- 3 **Pull the belt on**
Fit a clamp across the full width of the belt end and pull from the clamp, never by a corner or one edge. Feed it over the carrying idlers top cover up.
- 4 **Make the joint**
Cut the ends square to the belt's centre line, not to its edge. Follow the joint maker's steps exactly, and let a hot or cold joint cure fully before load.
- 5 **Tension, then run empty**
Take up just enough tension that the drive does not slip under load. Run empty and watch the belt for several full turns before loading it.
- 6 **Train it, then load it**
Correct any running off (Part 3), then load gradually. Re-check tension and tracking after the first day, as a new belt beds in.

Before the first full load

- | | |
|---|--|
| ☐ Joint cured and inspected | ☐ Top cover facing up |
| ☐ Belt central on every pulley | ☐ Scrapers and skirts reset |
| ☐ Guards back in place | ☐ Take-up travel left |

CHOOSING THE JOINT

	Hot vulcanised	Cold bonded	Mechanical fasteners
Strength	Highest	Good	Lowest
Belt life	Longest	Long	Shorter
Time to make	Hours	Hours	Minutes
Needs a press	Yes	No	No
Seals fines	Yes	Yes	No
Best for	Main lines	Lighter duty	Short, portable

Order the right length

Open length = $2 \times \text{centres} + \pi \times (\text{D head} + \text{D tail}) \div 2$, with the take-up at its shortest. For a hot joint add the joint allowance: one step length for each ply less one, plus the bias across the width. The length tool on our website works it out.

Joint work is skilled work

A belt is only as strong as its joint. Use a trained jointing crew and the joint maker's materials, matched to the belt's cover grade.

Fasteners and pulleys

Choose fasteners rated for the belt's thickness and the smallest pulley on the conveyor, and fit them square across the width.



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PART 3 · RUNNING AND CARE

When the belt runs off, find the cause

What you see	Usual cause	What to do
Runs off at one place, always	An idler or pulley out of square there	Square that idler set or pulley to the centre line
One stretch of belt runs off, wherever it is	A joint not cut square, or a bowed belt	Check the joint is square, remake it if not
Runs off at the tail when loaded	Loading off centre	Centre the chute so material lands mid belt
Wanders on the return side	Material built up on return idlers or pulleys	Clean them, fit or set scrapers and ploughs
Slips at the drive	Too little tension, or a wet or worn drive pulley	Adjust take-up, lag the drive pulley
Edges wearing or folding	Rubbing the structure, or skirts too close	Find the contact point, reset skirts and guides

Every shift

- Walk the belt: tracking, spillage, noise
- Scrapers touching, skirts sealing
- Nothing stuck on pulleys

Every week

- Idlers turning, none seized
- Joint condition, fasteners tight
- Cuts or gouges in the top cover

Every month

- Take-up travel left
- Cover thickness at the worst spot
- Lagging on the drive pulley

MAKING IT LAST

- ✓ Load in the direction of travel and in the centre, with the drop kept low.
- ✓ Fit impact idlers or an impact bed under the loading point.
- ✓ Keep skirt rubber just clear of the belt, not pressed into it.
- ✓ Repair cuts early, before water and fines reach the fabric.
- ✓ Clean spillage before it builds up under the return side.
- ✗ Do not run a belt that is slipping: it glazes the drive and burns the cover.

When to plan a replacement

When the top cover at its thinnest point is down to the fabric in places, the fabric shows through cuts, or plies are separating at the edges. Order before the shutdown, not during it.

Gave less life than expected?

Send photos of the worn belt, the loading point and the joint, with the conveyor details. Our engineers find the cause with you and suggest a build that lasts longer.

Ordering the replacement?

Use our Conveyor Data Form (BR-FM-01). We reply with a quotation and datasheet the same working day.

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