

## G-32: Adjust and Train Belts

### SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.
- The lock and tag is not used when adjusting the belt, this task requires that the conveyor be powered and operating.
- Conveyor equipment is often located in areas with low lighting, and a dusty atmosphere that requires a respirator.
- Some conveyors are overhead, and service requires ladders/scaffolds or special equipment such as a manlift and safety harness.
- Gloves are necessary for the many pinch points and other hand hazards typical of conveyor and conveyor service equipment.

### EQUIPMENT

- air drive impact or air ratchet (3/4-inch or larger)
- Maintenance Mechanics hand tools
- 2-inch socket for adjusting the tailpulley
- chalk or paint stick

### RESOURCES

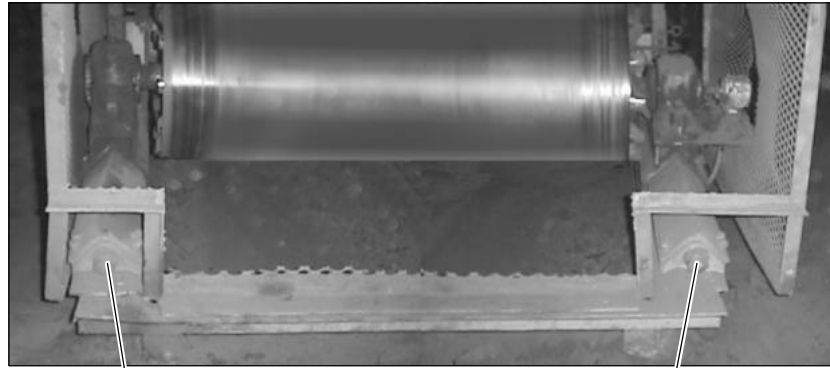
- Repair Ticket (Service Order)
- belt location map



## Adjust and Train Belts

Note: The procedure was analyzed with the assumption that the belt is tracking to the left.

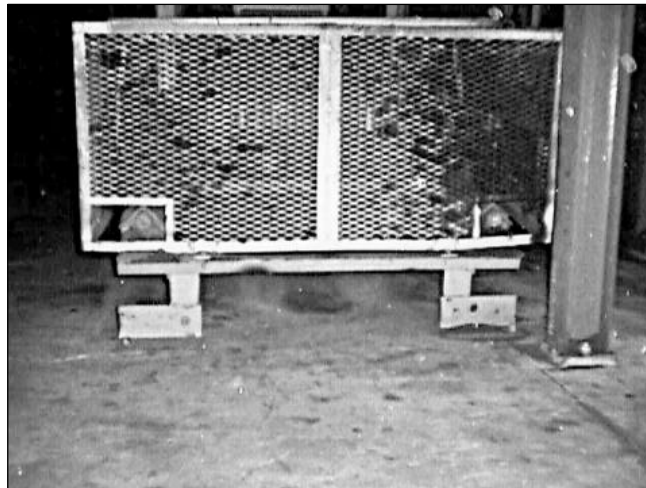
1. Open the back cover to perform this task, as shown below.



Left Take-up Nut

Right Take-up Nut

Note: Some covers have a cutout for easier access to insert the socket, as shown below.

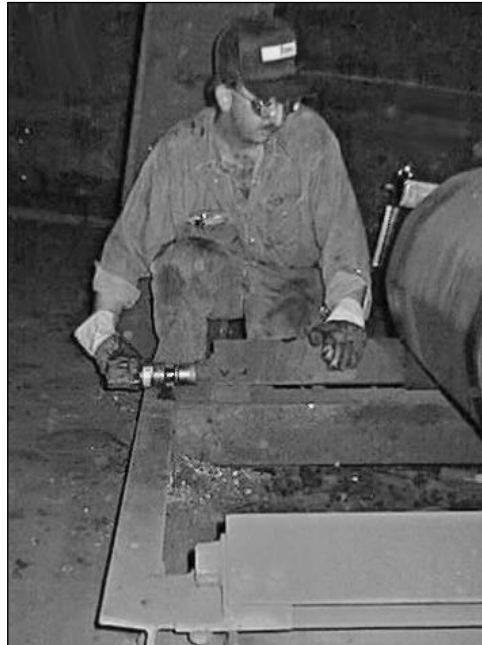


2. Observe the way the belt tracks.

Note: If the belt has been trained without a load, it must be observed with a load. It will change. Observe the tailpulley and note how the belt rests on the tailpulley. Higher speed belts have rubber skirting on the sides of the belt. There must be rubber showing on both sides. Visually check all areas for any evidences rubbing on other structures or the bearing blocks.

3. Tighten the opposite side takeup, in small increments, of the way the belt should move. Small increment means one revolution of the socket.

Note: If the belt is way out of adjustment, several turns on the socket would be okay.



**Warning:** Avoid turning the takeup too much and causing the belt to track too far to the right. You can damage the belt or other equipment. Don't over adjust one takeup, causing it to misalign the tailpulley and applying undue stress on the tailpulley bearings. Undue stress can possibly damage the bearing.

4. Observe the belt tracking and adjust as necessary.

Note: This task requires the Mechanic to tighten the bolt, watch the belt, tighten the bolt, and watch the belt until adjusted. Let the belt make a complete rotation between adjustments. The closer the belt gets to proper adjustment, the more rotations are needed to be observed. If the belt is not visibly connected, mark the belt to observe the rotation.

5. Close the cover, if one was open, when the task is complete.

