After the belt has been installed in accordance with the “Installation Guidelines” then the following procedure for start-up & test running should be adopted:-

1) Cold Testing:
- Check that the edges of the belt are clear of any part of the oven conveyor structure and that there is no foreign material or debris present that would interfere with the running of the belt.
- Adjust the belt take-up mechanisms to action an even tension on the belt. Do not over tension the belt.
- Switch on conveyor and run at low speed (minimum) checking the drive drum end to ensure non-slip driving. If the belt is slipping on the drive drum gradually increase the belt tension until no slippage occurs.
- If the belt tracks off to one side at either the drive or infeed end then adjust the tracking support rollers by the method as shown in the “Tracking of Friction Driven Mesh Belts” document. In general it will take 2-3 complete belt circuit revolutions for the belt to settle in a position.
- Once the belt settles in to a true running position gradually increase speed until full operating speed is achieved. In this process constantly check for tracking and position throughout the full circuit belt length. Ensure the belt does not slip on the drive drum.
- Occasional belt vibration may occur. If present gradually increase the belt tension until it stops.

2) Hot Testing:
- When the belt is stabilised under cold running conditions gradually increase the operating temperature in steps of 50°C from 150°C until the operating temperature is achieved. Allow the belt to run for approximately 20 minutes at each temperature point. Do not exceed a rate of 170°C per hour in this hot testing belt running operation.
- During this operation constantly check for tracking and position throughout the full belt circuit. If adjustment is required then refer once again to the “Tracking of Friction Driven Mesh Belts” document.
3) Belt Cleaning:

- After the testing phases are complete leave the belt running for several hours periodically checking for belt tracking and drive.
- Then brush and wipe down the belt before starting tests under load.
- NB: If you intend to adopt belt cleaning by carburising of food deposits then continue this process until the carburisation temperature (~350°C) is achieved. Afterwards bring the belt down in the same steps and rate to the required operating temperature.

4) Starting the conveyor under load

- After completion of the above procedures the installation can then be started up under full load conditions.
- If during production there is sideways shift to the belt check that the oven heating is regular and even across the full belt width. Uneven heating can cause expansion of the belt on one side which will result in uneven tension across the width and a sideways movement of the belt.
- Side shift of the belt during operation can also be the result of abnormal load and distribution across the width.

NOTE:

a. If at any time during the above test running phases the belt tension adjuster extends to its maximum position then it may be necessary to shorten the belt to ensure correct non-slip drive. Refer to the “Installation Guidelines” and “Mesh Joining Instructions”.

b. Should the conveyor require increased friction drive then consider applying FERRODO (brake drum lining material) plates or similar to the drive roller.

c. If the oven conveyor is fitted with a lower return band scraper blade this must be fitted as close as possible to the drive roller and be across the full belt width without interfering with the belt edges. These in general should be of a suitable plastic, wood or material that will not damage the belt.