



## 7 Helpful Tips to Keeping Your Conveyor Running Properly

Whether you're in the start-up process, or have had your systems running for some time, these 7 simple guidelines will reduce your chances of unscheduled down time, and keep your product on the shelves and in stock.

### In the Start-up Process:

#### 1. Have 10 Feet of Extra Chain

- If something is going to break it is usually during start-up. Keep some extra chain on hand to ensure that it is available if needed.

#### 2. Stock Extra Sensors

- Having a few backup sensors on hand can save thousand of dollars in lost productivity by being able to quickly address unforeseen control challenges.

#### 3. Have a Replacement Variable Frequency Drive

- If they are going to fail, most electronics fail at, or soon after start-up. We recommend a 2.0 H.P. drive as it can be programmed for small motors.

### Semi-Annual Inspection and Maintenance:

#### 4. Keep an Eye on Turn Wearstrips

- Generally, the inner turns are subject to wear and need to be monitored. Replace the wearstrip when the chain edge is within  $\frac{1}{32}$ " of the frame steel.

#### 5. Watch for Tabletop and Mat-Style Chain Wear and Stretching

- Tabletop chain shows wear through chain stretch and should not stretch past  $61 \frac{1}{2}$ " for 40 links. Mat-Style chain wear shows through hole elongation and rod/pin camming, when the rod wears before the chain and looks like a piano hinge. Also check thrust surface wear on the inside turn edge of the chain. The chain needs to be replaced before the rods are no longer contained.

#### 6. Have a Replacement Variable Frequency Drive

- When a chain stretches, the sprockets also wear to fit the stretched chain. If the chain is replaced and the sprockets are not, the old sprockets will cause the new chain to wear down and shorten its lifespan.

#### 7. Listen for Louder or Unfamiliar Sounds

- Other crucial pieces to inspect for routine maintenance are reducers, bearings and air cylinders. Listen for louder than normal sounds, clicking noises, oil and air leaks, or any scraping or grinding sounds which can all be indicators that something is not running as it should. Keep your ears open in order to catch anything before it causes unscheduled down time.

Keep in mind the speed at which the chain is running and the environment it is running in, both of which affect the lifespan of a conveyor. Routine inspections and extra parts are essential to keeping the conveyor system running at peak efficiency. Having a replacement part on site is the best solution to any maintenance issue.

**Nercon has an easy to use parts inquiry on our website, [www.nerconconveyors.com](http://www.nerconconveyors.com). To get a direct quote on a part, contact Kim Dunham, 844-293-2814.**