



Belt Conveyor for Injection Machine

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Liftable conveyor Belt

Description

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2. Lifting adjustable movable tripod (pre-embedded nuts and screws required for fixing have been placed)
3. Crossbeam (the corner pieces, embedded nuts and screws needed for fixing have been placed)

Common problems and solutions for conveyor lines

A. The conveyor belt runs unilaterally at a certain part of the equipment

- (1) Due to the bending of the conveying frame, check the bending part and adjust the straightness and levelness.
- (2) The running direction of the rollers before the deviation part is not perpendicular to the running direction of the conveyor belt and should be adjusted.
- (3) There are massive attachments on the supporting roller. Scrapers and other cleaning devices must be installed in time.
- (4) The rollers are poorly transported and need to be maintained and lubricated.
- (5) If the center of the roller is offset or there are materials sticking to it, adjust the center of the roller, install a scraper, and remove the block attachments.

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(6) The position of the feeding device is inappropriate, and the position of the feeding device needs to be corrected.

B. The specific part of the conveyor belt runs off the full length of the body

(1) If the conveyor belt joint is bent, the joint should be repaired to improve the straightness of the belt body near the joint.

(2) The straightness of the conveyor belt itself is insufficient, so use an automatic centering roller (some minor straightness is insufficient in the load revolution for a few days).

It can self-calibrate after adaptation. In a few cases, it needs to be corrected or repaired.) It is installed near the return side of the tail wheel so that the material can be carried in the center.

C. The entire conveyor belt runs off

(1) If the conveyor frame is bent, the straightness and levelness of the overall length of the conveyor should be checked and adjusted.

(2) The material loading position is not correct, that is, the material blocks are uneven on the left and right sides of the conveyor belt, and the weight is unbalanced. The feeding position should be improved.

(3) Sometimes it runs off-track, sometimes it does not run off-track. Generally, it is caused by wind. A windshield and self-adjusting center roller should be installed.

(4) Caused by the falling of one side of the supporting roller. The left and right rollers should be adjusted to a height.

D. Conveyor belt running unevenly (unfixed deviation)

Conveyor belts are relatively hard, and poor groove formation at the beginning of use can lead to deviations. Generally, it can be used after a few days; if this phenomenon persists after a long period of use, an automatic centering roller should be installed, and the conveyor should be replaced when the timing is not adjustable. band.

E. Scratches, tears, peeling, abnormal abrasion and other phenomena of the upper cover rubber.

(1) Due to the insufficient length of the baffle, the length of the baffle should be adjusted and extended until the material on the conveyor belt is stable.

(2) Due to improper opening of the baffle. The opening of the baffle should be 2/3 to 3/4 of the width of the conveyor belt, and it should be narrower for bulk materials. The baffle is fan-shaped (the opening follows the running direction), and the opening size can be adjusted.

(3) The interval between the conveyor belt and the baffle is inappropriate. First, the side of the conveyor belt of the baffle is in contact with the conveyor belt, and then the interval is slowly increased to an appropriate position to reduce the abrasion of the conveyor belt by the baffle.

(4) The material of the baffle is inappropriate. The material of the baffle is too hard, or the canvas is exposed when the old conveyor belt is used, so that it is in direct contact with the conveyor belt, a suitable rubber baffle should be selected.

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(5) The feeding direction is improper, that is, the direction in which the material falls is different from the running direction of the conveyor belt, so that lateral force is generated, which makes the conveyor belt deviate or suffer aggravation. The direction of the material should be adjusted.

(6) The material's blanking angle and drop are improper. The angle should be reduced so that the material does not bounce on the conveyor belt. When the drop is large and the conveyor belt is greatly impacted, measures should be taken to reduce the feeding speed.

(7) The falling speed of the material is not correct. Due to the poor adjustment of the falling speed of the material and the speed of the conveyor belt, the material will slip instantly when it falls on the conveyor belt. Therefore, when the cover rubber is worn out, adjust the falling speed. The speed of the material is consistent with the speed of the conveyor belt.

(8) There is something stuck on the lower roller, does not rotate or is not adjusted properly, and the upper cover rubber is abnormally worn. The following methods should be adopted: install a cleaner, clean the conveyor belt, install a rubber sleeve on the return roller, repair or Replace the return roller.

F. Serious wear of the rubber attached to the non-working surface

(1) Due to the poor surface condition of the idler and roller. The rollers and rollers are damaged and have attachments and need to be repaired. If necessary, install a baffle to eliminate attachments.

(2) If the idler rotates poorly, it should be repaired and lubricated.

(3) The trough-forming roller is too inclined. Should be adjusted so that it is perpendicular to the conveyor belt, the error does not exceed 2 degrees.

(4) The conveyor belt slips on the driving roller. Check whether the tension is normal, and increase the tension appropriately. In addition, in order to prevent slippage, the drive roller is covered with rubber or a pinch roller is used to increase the wrap angle.

G. Edge damage of conveyor belt

(1) The side rubber of the conveyor belt is caused by excessive friction or bending on the roller or frame. Check whether the conveyor belt is off-track and repair it.

(2) The slotted roller in front of the head roller is too close to or too high from the head roller, and the position of the roller needs to be adjusted.

H. The conveyor belt stretches too long, which is caused by excessive tension

(1) Minimize the tension load as much as possible;

(2) Use rubber rollers or increase the wrap angle to improve drive efficiency and reduce tension.

(3) Make the idler rotate well and minimize the load when the conveyor belt is running

(4) Use the same speed, but reduce the delivery volume.

(5) Increase the conveyor belt speed without changing the conveying volume;

Ordinary conveyor line

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Common problems and solutions for conveyor lines

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- (3) There are massive attachments on the supporting roller. Scrapers and other cleaning devices must be installed in time.
- (4) The rollers are poorly transported and need to be well maintained and lubricated.
- (5) If the center of the roller is offset or there are materials sticking to it, adjust the center of the roller, install a scraper, and remove the block attachments.
- (6) The position of the feeding device is inappropriate, and the position of the feeding device needs to be corrected.

B. The specific part of the conveyor belt runs off the full length of the body

- (1) If the conveyor belt joint is bent, the joint should be repaired to improve the straightness of the belt body near the joint.
- (2) The conveyor belt itself is insufficient in straightness, use an automatic centering roller (some minor straightness insufficiency can be calibrated after the load is adapted to the number of days, and in a few cases, it needs to be corrected or repaired), installed near the tail wheel to return One side, so that the material is carried in the central part.

C. The entire conveyor belt runs off

- (1) If the conveyor frame is bent, the straightness and levelness of the overall length of the conveyor should be checked and adjusted.
- (2) The material loading position is not correct, that is, the material blocks are uneven on the left and right sides of the conveyor belt, and the weight is unbalanced. The feeding position should be improved.
- (3) Sometimes it runs off-track, sometimes it does not run off-track. Generally, it is caused by wind. A windshield and self-adjusting center roller should be installed.
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Conveyor belts are relatively hard, and poor groove formation at the beginning of use can lead to deviations. Generally, it can be used after a few days; if this phenomenon persists

after a long period of use, an automatic centering roller should be installed, and the conveyor should be replaced when the timing is not adjustable. band.

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The baffle is fan-shaped (the opening follows the running direction), and the opening size can be adjusted.

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Slippery, wrap rubber on the drive roller or use a compression roller to increase the wrap angle.

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