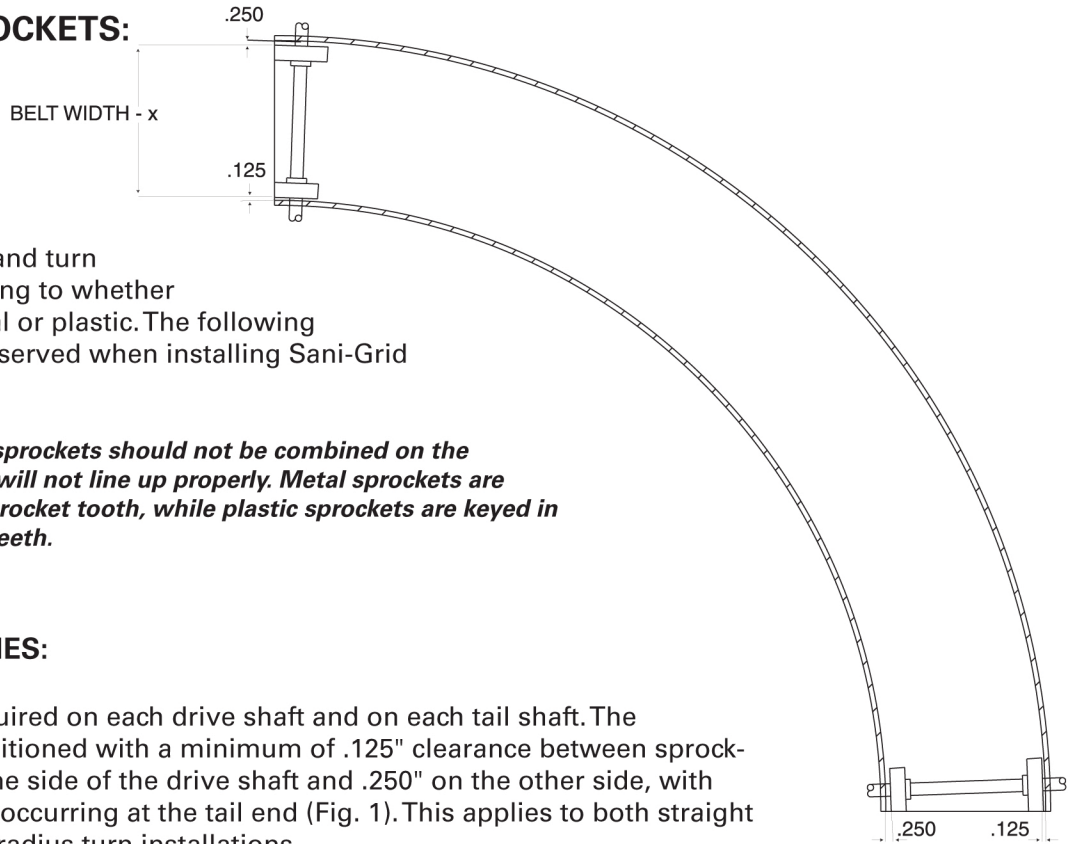


SANI-GRID® BELTING

INSTALLATION AND MAINTENANCE FOR TURN BELT CONVEYORS

SANI-GRID® SPROCKETS:

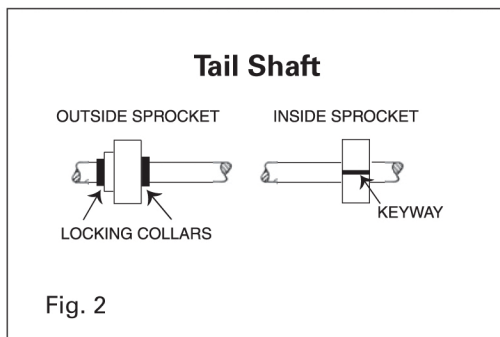
Questions about sprocket location for Sani-Grid Belts are frequent. Some installation guidelines differ for straight line and turn belts, and also according to whether the sprockets are metal or plastic. The following guidelines must be observed when installing Sani-Grid sprockets.



Note: Metal and plastic sprockets should not be combined on the same shaft as the teeth will not line up properly. Metal sprockets are keyed in line with the sprocket tooth, while plastic sprockets are keyed in the valley between the teeth.

GENERAL GUIDELINES:

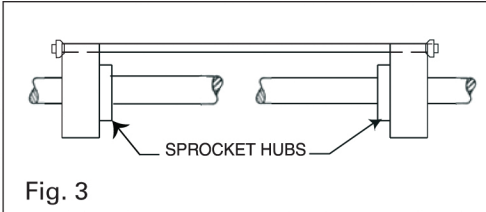
Two sprockets are required on each drive shaft and on each tail shaft. The sprockets must be positioned with a minimum of .125" clearance between sprockets and knuckles on one side of the drive shaft and .250" on the other side, with the opposite situation occurring at the tail end (Fig. 1). This applies to both straight running and constant radius turn installations.



On the drive shaft, both sprockets must be keyed. On the tail shaft, only one sprocket is keyed to the shaft. For turn belts, this must be the inside sprocket. The outside sprocket is to be allowed to float rotationally, but should be constrained from lateral movement by set screw locking collars on either side of the sprocket (Fig. 2).

SPROCKET ORIENTATION:

Metal Sprockets



Metal sprockets must be installed so that the hubs are **facing in toward the belt** (Fig. 3) regardless of whether the belt is a straight line or turn belt.

Plastic Sprockets

The two-piece UHMW sprocket is considered a plastic sprocket even though it has a stainless steel hub. When the two-piece plastic sprocket is used as the outside sprocket in a turn application, it must be installed such that the hub faces **toward the outside** of the unit (Fig. 4).

The inside sprocket for turn belts is of a one-piece construction, due to the smaller inside pitch of the belt. This sprocket is stamped on the minor diameter side, and is to be installed so the stamped side faces away from the belt, towards the inside radius of the conveyor.

The sprocket marked TCI is placed on the inside of the turn. The sprocket marked TC is on the outside. Plastic sprockets for turn belts will not operate properly unless they are installed as indicated (Fig. 4).

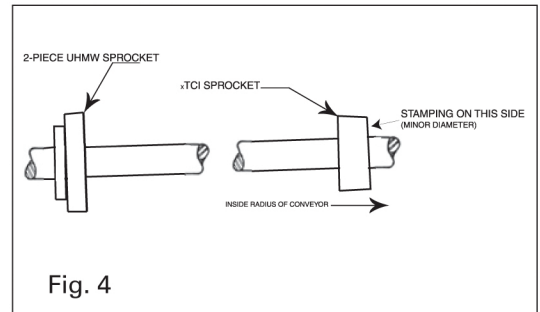


Fig. 4

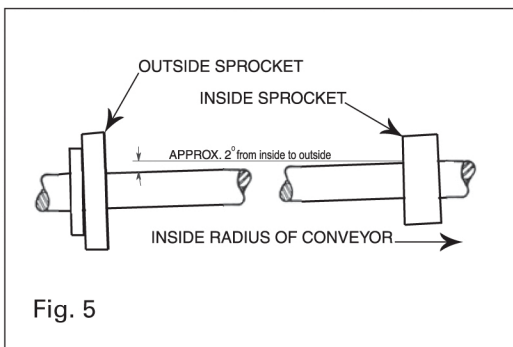


Fig. 5

Since Sani-Grid turn belts are constant radius turn belts, the inside sprockets are smaller than the outside sprockets because the inside pitch is less than the outside pitch. This requires the shafts to be installed at an angle so that a decline of approximately 2 degrees from inside to outside is achieved, in order to ensure a level belt carrying surface. (Fig. 5)