

# CONVEYOR BELTING



**CONVEYOR BELTING PRODUCTS  
FOR ALL SEGMENTS OF INDUSTRY**

**COMPLETE BELT FABRICATION SERVICES**

**EQUIPMENT TO IMPROVE  
CONVEYOR PRODUCTIVITY**



## *“Complete Conveyor Solutions” to the world material handling industry*

ASGCO Conveyor Belt Division, founded in 1971, is known for manufacturing, and components, fabricating and supplying the highest quality, conveyor belts in the world. Our experience, organization and commitment enable us to offer the best service and the best quality. ASGCO has built a reputation for retaining and growing our customer base by solving complex problems using innovative products and 24 hour, 7 day a week service to improve conveying systems.

### DISTRIBUTOR PROGRAM

As a major supplier, your company requires a high quality product, great service and delivery at a low price. Our distributor program uses the latest technology to streamline and lower our customers' overall conveyor costs by implementing our streamlined distributor service and inventory program. Your company receives countless advantages over the normal belting distributor. Customer satisfaction is always number one and guaranteed.

### *ASGCO is focused on these three primary business principles:*

1. Always think and work in terms of solutions that are best for the customer in the long term.
2. Provide prompt, reliable service to every client, every time.
3. Develop and service products that satisfy the practical working needs of our customers.

*That's what we call the ASGCO Promise, and it applies to every client, every time.*



*Our Mission...  
To provide the world material  
handling industry with  
“Complete Conveyor Solutions”.*



# *“WE KEEP YOU RUNNING”*

# BELT STYLE SERIES



**A-SERIES** - Belts with embossed top cover specially suited for incline and decline conveyance. These are widely used in distribution facilities packaging applications that require the belts to pull or push the product being conveyed.



**D-SERIES** - PVC belts with a abrasion resistant cover, great loading capacity and are anti-static, resistant to abrasion, cutting and to mineral oils and greases. This series is used extensively in the brick, ceramic tile and recycling industries.



**P-SERIES** - Thermoplastic polyester belts, that are both food grade and tobacco approved. They offer a great release and work extremely well at high and low temperatures (intermittent -40 to +240F°), and are highly resistant to oils and abrasion.



**B-SERIES** - Belts with a high resistance to mineral oils, fats, and suitable for harsh conditions including high humidity, temperature, and abrasion. This series is used widely in the corrugated box, wood, stamping and any areas where the application demands high abrasion resistance.



**E-SERIES** - Belts that are FDA-USDA compliant with transverse flexibility for troughing and or elevator applications. All of them are anti-static, resistant to abrasion and to animal and vegetable oils and greases. Used in the sugar, salt and gypsum industries.



**V-SERIES** - Belts with polyolefin or transparent silicone top cover. All of them are resistant to animal and vegetable oils and greases, and most of them are anti-static. The silicone top cover is ideal for the conveyance of very sticky products. The polyolefin belts are also tobacco approved.



**C-SERIES** - Belts that are used in food applications with high resistance to animal and vegetable oils and fats, which also meet the strictest international standards for food contact (FDA-USDA). This series is used extensively in bakeries, snack foods, and handling fruits and vegetables.



**F-SERIES** - Belts for general applications in which products conveyed that do not require a special resistance to oils and greases. Many of these belts meet the ISO standards for the airline industry. This series of belts are also used extensively for the airline, insulation, gypsum and distribution industries.



**G-SERIES** - Belts for general applications in which products conveyed may require a more economical belt and can handle larger pulley diameters such as warehousing and distribution.

# INDUSTRIAL APPLICATIONS

ASGCO is constructed to provide a vast array of belting products to solve many types of industrial applications.

## CORRUGATED BOX



**B23CF**  
Incline Stacker

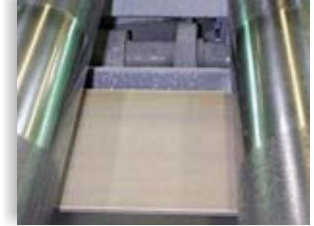


**B33CF**  
Folding Rails

## GYPSUM



**A30W2F**  
90 Degree Transfers



**E30CC**  
Live Roller Conveyors

## WOOD

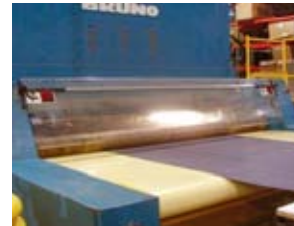


**A30W2F**  
Timesaver Sander



**C12FFAS**  
Tray Loader

## AUTOMOTIVE & STAMPING



**B22UF**  
Carpet Stamping



**B20UF**  
Metal Transfer

## PACKAGING & WAREHOUSING



**A12QF**  
Merge Conveyors



**F22FF**  
Telescoping Conveyors

## BRICK, CERAMIC TILE & RECYCLING



**D30CR**  
Tile Polishing



**D30CR**  
Recycling

## TOBACCO PROCESSING



**V18PF**  
Tobacco Transfers



**P18TF**  
Tobacco Incline

## INSULATION, ROOFING & BUILDING MATERIALS



**F10CF**  
Insulation Transfers



**D21CC**  
Transfer Conveyors

# FOOD GRADE APPLICATIONS

ASGCO offers our customers the highest quality of food grade belting products that can deliver optimum performance at every stage of operation.



## BAKERY



**C31CF**  
Depanner Belts



**C10UF**  
Model K Rounders

## COOKIES & CRACKERS



**P08AF**  
Oven Take-away



**P08EF**  
Oven Loader

## PASTRY



**C09UFMT**  
Rotary Cutter & Deposter



**C09UFMT**  
Croissant Sheeters & Laminators

## CANDY



**C08UFMT**  
Cooling Tunnel



**C07UF**  
Cooling Tunnel

## FRUITS & VEGETABLES



**C19CF**  
Sorting & Packaging



**C19CR**  
Cleated Incline

## SUGAR & SALT



**E21CC**  
Sugar Conveyor



**E30CC**  
Sugar Conveyor

## CEREAL & SNACK FOODS



**C10UF**  
Cereal Transfers



**C18FF**  
Pretzel Proofers

## MEAT, FISH, POULTRY & DAIRY



**C12UF**  
Fish Conveyor



**C10UF**  
Shredded Cheese  
Transfer w/Sealed Edges

# NON-FOOD GRADE BELTS

BELT STYLE	TOP COVER					BOTTOM COVER					FABRICS		MIN.PULLEY DIA.		TENSIONS		Max. Roll Width	
	Material	Color	Thickness	Surface	Shore	Material	Color	Thickness	Surface	Characteristics	Temp. (F)	# Piles	Wtft	Belt Thickness	Normal Flexing	Back Flexing		Breaking Load
A12GF	PVC	Green	.157	Pattern G	55	Natural	Natural	Textured	★	+23+176	2	Rigid	.201	1.969	3.150	685	51	78-¾
A12QF	PVC	Gray	.066	Pattern Q	50	Natural	Natural	Textured	★ ◆	+23+176	2	Rigid	.118	2.362	3.150	1142	80	118
A20AF	PVC	Green	.040	Pattern A	75	Natural	Natural	Textured	★ ✕	+23+176	2	Rigid	.118	2.362	3.150	1142	80	118
A20GF	PVC	Gray	.26	Pattern W2	55	Natural	Natural	Textured	★	+23+176	2	Rigid	.217	2.362	3.937	1142	80	78-¾
A30W2F	PVC	Green	.157	Pattern G	55	Natural	Natural	Textured	★	+23+176	3	Rigid	.37	4.72	7.09	1539	168	78-¾
A33QF	PVC	Green	.134	Pattern Q	45	Natural	Natural	Textured	★	+23+176	3	Rigid	.25	5.91	7.87	1710	168	78-¾
B10UF	PU	Green	.012	Smooth	93	Natural	Natural	Textured	FDA ★ ◆ ✕ ✕	+14+237	2	Rigid	.043	0.394	1.181	286	29	78-¾
B12UF	PU	Green	.012	Smooth	93	Natural	.004	Impregnated	FDA ◆	+14+176	2	Rigid	.090	2.36	3.15	1100	99	78-¾
B2014	PU	Trans.	.020	Smooth	86	Natural	Natural	Textile	◆	+14+176	2	Rigid	.055	.787	1.968	462	57	78-¾
B2015	PU	Trans.	.080	Matte	93	White	Hard PVC	Impregnated	◆	+14+176	2	Rigid	.180	7.09	9.85	1100	110	78-¾
B07CF	PVC	Green	.020	Smooth	82	Natural	Natural	Textured	FDA ★ ◆ ✕ ✕	+14+176	1	Rigid	.040	0.394	1.181	336	39	118
B12CF	PVC	Green	.020	Smooth	82	Natural	Natural	Textured	FDA ★ ◆ ✕ ✕	+14+176	2	Rigid	.083	1.575	2.362	672	67	118
B12CK	PVC	Green	.020	Smooth	82	Green	PVC	Pattern K	FDA ★ ◆ ✕ ✕	+14+176	2	Rigid	.094	2.362	2.362	672	67	78-¾
B20CF	PVC	Green	.039	Smooth	82	Natural	Natural	Textured	★ ✕ ✕	+14+176	2	Rigid	.118	2.362	3.149	1120	112	118
B22CF	PVC	Green	.079	Smooth	82	Natural	Natural	Textured	FDA ★ ◆ ✕ ✕	+14+176	2	Rigid	.157	3.150	3.150	1120	112	118
B23CF	PVC	Green	.118	Smooth	45	Natural	Natural	Textured	FDA ★ ◆ ✕ ✕	+14+176	2	Rigid	.189	2.758	3.940	1120	103	118
B25CF	PVC	Green	.020	Smooth	82	Natural	Natural	textured	FDA ★ ◆ ✕ ✕	+14+176	3	Rigid	.157	3.937	4.724	1680	135	118
B30CF	PVC	Green	.079	Smooth	82	Natural	Natural	Textured	FDA ★ ◆ ✕ ✕	+14+176	3	Rigid	.193	4.724	5.906	1680	168	118
B33CF	PVC	Green	.12	Smooth	45	Natural	Natural	Textured	★	+14+176	3	Rigid	.25	5.91	7.87	1710	168	118
D2001	PVC	Green	.080	Smooth	78	Green	PVC	Smooth	★ ◆ ✕ ✕	+4+176	2	Flexible	.200	5.905	7.874	1120	112	78-¾
D30CR	PVC	Green	.080	Smooth	78	Green	PVC	Impregnated	★ ◆ ✕ ✕	+4+176	2	Flexible	.213	7.087	7.874	1680	168	78-¾
F10CF	PVC	Green	.020	Smooth	78	Black	Black	Textured	★	+14+176	2	Rigid	.075	1.575	2.362	672	67	118
F22FF	PVC	Green	.020	Smooth	78	Black	Black	Textured	★ ◆ □	+14+176	2	Rigid	.075	1.575	2.362	672	67	118
F30RR	PVC	Trans.	.004	Impregnated		Trans.	PVC	Impregnated	★ ◆ □	+14+176	2	Flexible	.134	5.906	5.906	1680	168	118
G3BLRT	Carb. Nitrile	Blue		Pattern G		Black	Black	Friction		0-250	3	Rigid	.301	2.5	2.5	900	90	72
G2BLRT	Rubber	Black		Pattern G		Black	Black	Friction		0-250	2	Flexible	.250	32	2	1500	150	72
G3BNRT	NBR*	Brown		Pattern G		Tan	Tan	Friction	◆	0-250	3	Flexible	.277	2.5	2.5	510	91	72
G120BCOS	NBR*	Brown		Smooth		Black	Black	Friction	◆	20-180	1	Flexible	.145	3	3		120	72

\*NBR = Butadiene

## CHARACTERISTIC SYMBOLS

- FDA- Food Quality  
 ★ - Antistatic  
 ▲ - Resistant to oils & animal/vegetable fats  
 ▼ - Partially resistant to vegetable and animal oils & fats  
 ◆ - Resistant to vegetable oils and fats, and partially resistant to animal oils & fats  
 ● - Cut resistant
- ◆ - Resistant to mineral oils and fats  
 ✕ - Abrasion resistant  
 ||| - Cut resistant  
 ★ - Resistant to oils & animal/vegetable fats  
 ▼ - Partially resistant to vegetable and animal oils & fats  
 ◆ - Resistant to vegetable oils and fats, and partially resistant to animal oils & fats  
 ● - Cut resistant
- ◆ - Resistant to mineral oils and fats  
 ✕ - Abrasion resistant  
 ||| - Cut resistant  
 ★ - Resistant to oils & animal/vegetable fats  
 ▼ - Partially resistant to vegetable and animal oils & fats  
 ◆ - Resistant to vegetable oils and fats, and partially resistant to animal oils & fats  
 ● - Cut resistant
- ◆ - Low friction coefficient  
 □ - Flame resistant  
 ◆ - Low noise fabric  
 ⚡ - Pyrolysis test

# FOOD GRADE BELTS

FDA - Food Quality ★ - Antistatic  
 ▲ - Resistant to oils & animal/vegetable fats  
 ▼ - Partially resistant to vegetable & animal oils & fats

◆ - Resistant to vegetable oils and fats, and partially resistant to animal oils & fats  
 ✦ - Resistant to mineral oils & fats ✦ - Abrasion resistant III - Cut resistant  
 ✦ - Low friction coefficient □ - Flame resistant ◊ - Low noise fabric ◊ - Pyrolysis test

BELT STYLE	TOP COVER					BOTTOM COVER					Characteristics	Temp. (F)	FABRICS		MIN.PULLEY DIA.		TENSIONS		Max. Roll Width
	Material	Color	Thickness	Surface	Shore	Material	Color	Thickness	Surface	# Piles			Weft	Belt Thickness	Normal Flexing	Back Flexing	Breaking Load	Working (PW) load at 1% elongation	
A1206	PVC	White	.16	Pattern G	60	Natural	.004	Textured			Natural	.201	1.969	3.150	685	51	78-¾		
A21HF	PVC	White	.118	Pattern H	70	Natural	.004	Impregnated			Natural	.197	3.150	5.906	1142	80	78-¾		
C07UU	PU	Green	.004	Impregnated		Natural	.004	Impregnated			Natural	.020	0.315	0.315	381	39	118		
C07CF	PVC	White	.020	Smooth	70	Natural	.004	Impregnated			Natural	.039	0.394	1.181	336	39	118		
C0709	PU	White	.012	Smooth	93	Natural	.004	Impregnated			Natural	.031	0.393	1.181	336	39	118		
C08DF	PU	White	.024	Pattern D	86	Natural	.004	Impregnated			Natural	.043	0.394	1.181	286	29	78-¾		
C08UFMT	PU	White	.016	Matte	86	Natural	.004	Impregnated			Natural	.043	0.394	1.181	286	29	78-¾		
C09UFMT	PU	White	.008	Matte	94	Natural	.004	Impregnated			Natural	.043	0.472	1.378	685	57	78-¾		
C1009	PU	White	.012	Smooth	93	Natural	.004	Impregnated			Natural	.055	.787	1.968	462	57	78-¾		
C1209	PU	White	.012	Smooth	93	Natural	.004	Impregnated			Natural	.063	1.575	2.362	672	67	118		
C12CF	PVC	White	.020	Smooth	70	Natural	.004	Textured			Natural	.083	1.575	2.362	672	67	118		
C12AF	PVC	White	.028	Pattern A	70	Natural	.004	Impregnated			Natural	.106	1.575	2.362	672	67	118		
C12CK	PVC	White	.020	Smooth	70	White	.028	Pattern K			Natural	.106	2.362	2.362	672	67	78-¾		
C09RF	PU	Natural	.004	Impregnated		Natural	.004	Textured			Natural	.083	15.75	2.362	671	67	118		
C12FF	Cotton	Natural		Textured		Natural		Textured			Natural	.051	.787	.787	672	67	118		
C10FF	Cotton	Natural		Cotton Poly		Natural		Cotton Poly			Natural	.055	0.394	0.394	672	67	84-e		
C1312	Cotton	Natural		Textured		Natural		Textured			Natural	.067	1.81	1.81	672	67	84-e		
C16FF	Cotton	Natural		Cotton Poly		Natural		Cotton Poly			Natural	.094	1.575	1.575	896	90	82-e		
C2007	Cotton	Natural		Textured		Natural		Textured			Natural	.063	.787	1.377	952	95	118		
C19CF	PVC	Blue	.031	Smooth	70	Blue	.004	Textured			Natural	.110	2.262	3.150	1120	112	118		
C19CK	PVC	Blue	.031	Smooth	70	Blue	.028	Pattern K			Natural	.122	3.150	3.150	1120	112	78-¾		
C21CF	PVC	White	.031	Smooth	70	Natural	.004	Impregnated			Natural	.094	2.362	3.150	1120	112	118		
C22CF	PVC	White	.079	Smooth	70	Natural	.004	Textured			Natural	.157	3.150	3.937	1120	112	118		
C30CF	PVC	White	.031	Smooth	70	Natural	.004	Textured			Natural	.146	4.724	5.906	1680	168	118		
C31CF	PVC	White	.031	Smooth	70	Natural	.004	Textured			Natural	.122	3.937	5.906	1710	171	78-¾		
E2001	PVC	White	.080	Smooth	73	White	.040	Smooth			Natural	.200	5.905	7.874	1120	112	78-¾		
E30CC	PVC	White	.079	Smooth	73	White	.040	Smooth			Natural	.240	7.874	9.843	1680	168	78-¾		
V12SX	Silicone	Trans.	.012	Smooth	40	Natural		Textured			Natural	.069	1.575	2.362	672	67	118		
V18PF	Polyolefin	Trans.	.020	Matte	91	Natural	.040	Impregnated			Natural	.098	2.362	4.724	1120	101	118		
V18TF	Polyolefin	Trans.	.079	Pattern T	91	Natural		Impregnated			Natural	.106	3.937	5.906	1142	69	78-¾		
P08EF	Polyester	Natural	.300	Matte	93	Natural		Impregnated			Natural	.039	0.394	1.181	330	29	78-¾		
P08AF	Polyester	Natural	.300	Pattern A	93	Natural		Impregnated			Natural	.039	0.394	1.181	330	29	78-¾		
P18TF	Polyester	Natural	.079	Pattern T	93	Natural		Impregnated			Natural	.154	4.724	5.906	1028	69	78-¾		
P19EF	Polyester	Natural	.014	Matte	93	Natural		Impregnated			Natural	.071	1.575	3.937	1140	99	78-¾		
T2 Felt	Felt	White		Smooth		Natural		Textured			Natural	.079	.250	.250			72		
G120WCOS	PVC	White		Smooth		Natural		Textured			Natural	.145	2.00	2.00					

\*NBR = Butadiene

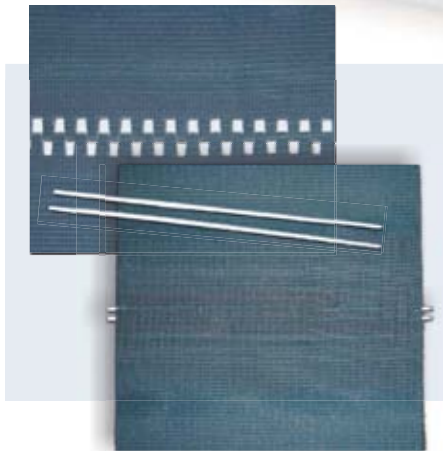
# FABRICATION

## Hinged Lace

A great alternative to an endless splice, plastic spiral or riveted lacing

*This fastener is ideal for applications:*

- When you would like a vulcanized splice, but don't have the space, time, or difficult and costly to install.
- Where the thickness of the belt and the coefficient of friction have to be the same between the belt and the splice.



- Strength: 110 lbs per inch of width
- Low Profile, vulcanized non-metallic lacing
- FDA / USDA approved
- Easy and simple to install and maintain

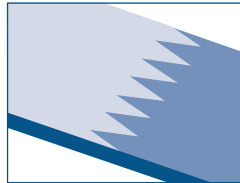
### Applications:

- Emergency Spare belts
- Metal detectors
- Wide Belt Sanders
- Inspection tables
- Accumulation conveyors

## Types of Endless Splices

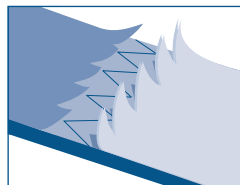
### Single Finger

Used on 1 ply or sometimes 2 ply belts.



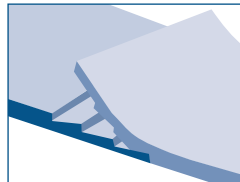
### Double Finger

Used on belts with 2 plies where additional strength or small pulleys are present.



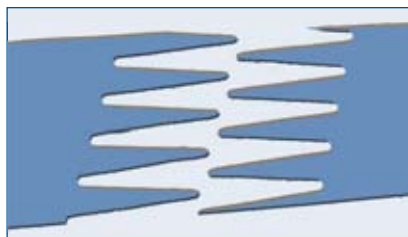
### Lap Splice

20 degree step splice.



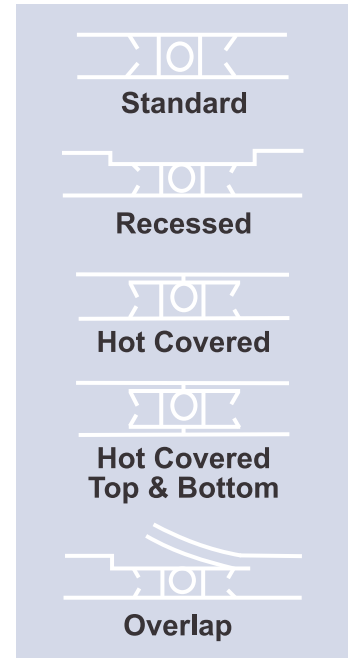
### Bias Finger Splices

A great splice where strength and flexibility are needed for demanding applications.



\*All splices can be prepared ends.

## Lacing Methods



## Felt Belts

Wool felt belts, woven endless. Also, natural white felt belts. Great release properties for wet sticky products and croissant moulders. Available in 2 or 4 mm thicknesses. Call for details.

## Longitudinal Splicing

Longitudinal splicing available up to 200" depending on belting material. Not available for 1-ply belt. Call ASGCO to confirm your requirements.

## Lacing Types



### Clipper®

Individual clips are installed via a special machine with minimal damage to the belt. It provides a smooth joint that is excellent for trough conveyors and small pulleys. Steel, stainless, Monel® and high tensile. Common styles are 25.1, 1, 2SP.



### Alligator®

Strips of steel with teeth are hammered or forced into the belting then joined via a pin. A popular style for its ease of installation and non-demanding application. Not recommended for trough conveyors or small pulleys. Steel, stainless and Monel®



### Unibar/Tiebar®

Individual clips are welded together via common bar and installed with a special machine. The common bar design prevents hooks from breaking away. Steel and stainless. Common styles UCN 36 and UX1SP.



### Staple

Small plates are fastened via staples and then joined by a pin. A special tool is needed to install lacing. This lacing is especially suited for high strength PVC style belting. Steel, stainless and megalloy. Common styles are 62, 125 and 187.



### Plastic Rivet

Small plastic plates are installed with a machine then joined via a pin. This lacing designed for areas that metal lacing cannot be used such as metal detectors. A 3" minimum pulley is required. Common styles are 100 and 150.



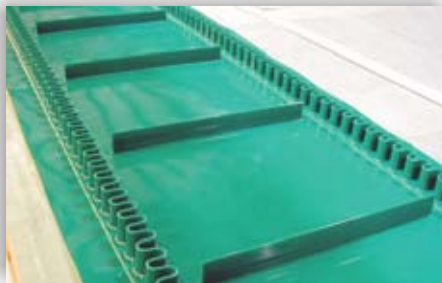
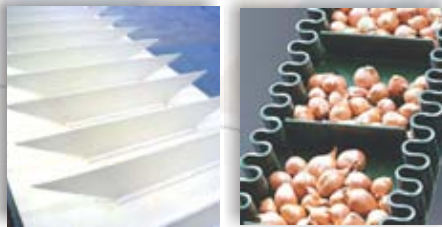
### Spiral Lace

Polyester webbing is vulcanized or sewn into the belt ends and then joined via a non-metallic pin. The bars can withstand temperatures over 300° F. Used on X-ray machines or metal detectors.

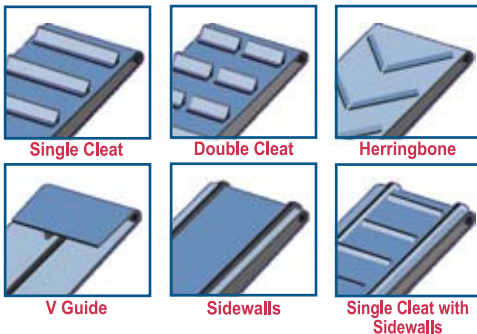
# FABRICATION

## Cleats & Sidewalls

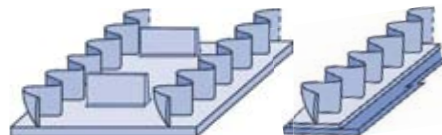
ASGCO's state of the art equipment is able to provide you with the ultimate in cleat and sidewall fabrication.



Colors available:  
green, white, black and blue



### Sidewalls with Base



### Compounds:

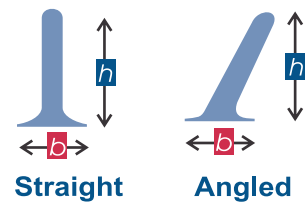
- PVC
- Polyurethane
- Polyolefin
- Polyester
- Rubber

### Applications:

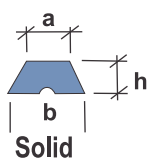
- Conveying
- Inclines
- Plastics
- Food Processing
- Confectionery
- Harvesting
- Pharmaceuticals
- Fertilizer
- Minerals

### All Styles Available

Any combination and styles are available for both cleats and sidewalls.



## V-Guides



Solid



Notched

	Part #	Dimensions (mm)			Material	
		b	h	a		
Solid	O section or K8	NE.Y05	8	5	4.4	PVC ①
	K 10	NE.Z06	10	6	5.6	
	A Section or K 13	NE.A08	13	8	7.2	
	B Section or K 17	NE.B11	17	11	9.0	
	C Section or K 22	NE.C14	22	14	11.8	
	D Section or K 30	NE.K16	30	16	18.4	
Notched	K 10	UE.Z06	10	6	5.6	PU ①
	A Section or K 13	UE.A08	13	8	7.2	
	B Section or K 17	UE.B11	17	11	9.0	
	C Section or K 22	DE.C14	22	14	11.8	
	D Section or K 30	DE.K16	30	16	8.4	
		O Section or K 8	DE.Y05	8	5	
	K 10	DE.Z06	10	6	5.6	
	A Section or K 13	DE.A08	13	8	7.2	
	B Section or K 17	DE.B11	17	11	9.0	
	C Section or K 22	DE.C14	22	14	11.8	
	D Section or K 30	DE.K16	30	16	8.4	

## Sealed Edges

ASGCO sealed edge fabrication provide solutions to contamination issues, frayed edges and moisture absorption concerns.



## ACCESSORIES/EQUIPMENT

### EXCALIBUR Belt Cleaner



#### Features:

- Snap-on Blade Easily Installed
- No Tools to Install / Replace Blade
- Electro-polished Stainless Steel
- Precise Pressure Tensioning System
- Complete Dissassembly in Seconds
- For Light Duty Thermoplastic Belts
- FDA / USDA Accepted Materials
- Meets All Sanitary Requirements



### TRU-TRAINER Training Idlers



#### Features:

- Easy installation
- No contact with edge of belt
- No maintenance
- Vibration free rolling action
- Simple design, few moving parts
- Finger tip movement under load
- Manufactured according to CEMA std.
- Operates in all conditions, wet and dry
- Operates on reversible belt
- Mounts on clean side of belt



### WASH BOX



#### Features:

- Completely enclosed belt washing system
- Dual sets of Razor-Back secondary cleaners and dry wipe
- All stainless steel construction
- Equal pressure on both cleaners
- Faster and more efficient cleaner
- Removable inspection and service door on each side
- Wash down hose included
- Two spray bars, nozzles and valves
- 6" NPT drain pipe



### SLIDE-N-ROLL Three Roll Heavy Duty



#### Features:

- Reduce spillage and clean-up
- Less costly than conventional impact or slider beds
- Slide-N-Roll beds can be supplied with center rollers or center impact rollers
- Increase skirtboard life
- Eliminate scalloping of interior skirt liners



# Conveyor Belt Trouble Shooting Guide

## Belt Comes Out of Alignment

### Cause

1. Bad splice or conveyor frame out of alignment
2. Material is loaded one side of the belt
3. An idler of group of idlers is not square
4. Accumulation of material on the pulleys
5. Insufficient tension
6. Pulleys and idlers out of alignment

### Solution

- 1.a. Cut the bad splice out and redo  
b. Install training idler
- 2.a. Install a deflector device to load in the center of the belt  
b. Install training idlers
- 3.a. Place idlers in the correct positions and / or replace the bad idlers  
b. Install training idlers
4. Install a V-plow on the inside of the return side of the belt
- 5.a. Increase the counterweight or tighten up the screw take-up  
b. Lag the drive pulley
- 6.a. Take a laser alignment and adjust the mis-aligned idlers or pulleys  
b. Install a crown pulley

## Tearing of the Fabrics or Delaminating

1. Excessive load of material
2. Excessive material fall height
3. Material getting caught in the load zone
4. Insufficient top cover
5. Pulleys too small
6. Temperature too high
7. Chemical incompatibility

1. Reduce it or speed up the belt
2. Break the height by installing deflectors
3. Improve the skirting system in the load zone
4. Select a more suitable belt
5. Change the belt and/or check the minimum pulley dimensions
6. Select a belt with the proper temperature resistance
7. Use a belt with the correct chemical resistance

## Splices Are Breaking

1. Excessive material impact
2. Excessive tension
3. Pulleys are too small
4. Material building up on the pulley
5. Material is very abrasive
6. Very aggressive or oily chemical products

- 1.a. Install deflector plates to reduce the fall  
b. Install a vulcanized splice
2. Reduce the tension to the point of slippage around the drive and then increase the tension to the point of no slippage
3. Increase the diameters of the pulleys or replace with smaller fasteners or a vulcanized splice
4. Install belt cleaners, plows and proper skirting systems to keep the pulleys and idlers clean
5. Install a vulcanized splice
6. Use a belt with the correct chemical resistance and physical properties

## Excessive Elongation

1. Working load is being exceeded
2. Excessive tension
3. Very aggressive or oily chemical products

- 1.a. Recalculate and select a more resistant type of belt  
b. Consult an ASGCO technical expert
2. Reduce the tension to the point of slippage around the drive and then increase the tension to the point of no slippage
3. Use a belt with the correct chemical resistance and physical properties

## Excessive Damage to the Bottom or Top Cover

1. Material build up on inner side of the belt
2. Belt slippage on pulleys
3. Incorrect cover
4. Idlers are not working or built up with material
5. The load zone containment / impact area is not designed properly

1. Install a proper load zone and skirting containment system to prevent material from escaping load zone
2. Increase the tension or cover
3. Replace with a more suitable cover
4. Install belt cleaners and return V-plows
5. Consult an ASGCO technical expert



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