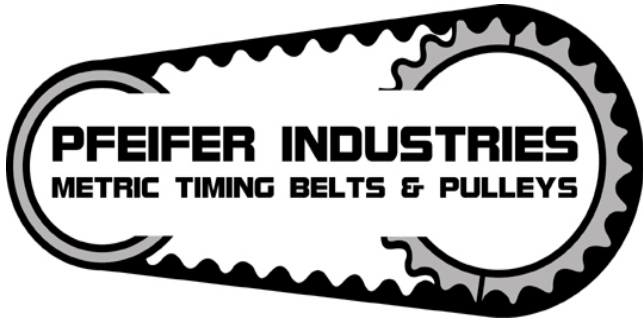


# TROUBLE SHOOTING

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## CORRECTIVE ACTION

TROUBLE	CAUSE OF PROBLEM	CORRECTIVE ACTION
Unusual Noise / Excessive Noise	Misaligned drive	Check Parallel and Angular Alignment of the Pulleys
	Too low or high tension	Adjust Tension to Recommended Value
	Backside idler	Check Horsepower Rating
	Density of pulley material	Check Belt / Pulley Compatibility
	Worn pulley	Replace Pulley
	Worn belt	Use Correct Pulley Diameter
	Bent guide flange	Eliminate or Control Condition
	Belt speed too high	Clean and Protect Drive
	Incorrect belt profile for pulley	Follow Proper Installation Procedure
	Use of Polyurethane (Plastic) belt	Follow Proper Handling and Storage Procedure
	Subminimal pulley diameter	Reinstall, Replace, Repair Flange
	Excessive load on bearings	Remount Bushing and Pulley
	Acoustics of drive enclosure	Change Pulley Material
	Excessive load	Use Inside Idler
		Redesign Drive
	Reinforce Structure	
	Noise level is reduced with the use of Rubber Timing Belt	
	Replace Belt	
	Check for conductive heat transfer from prime mover	
	Reduce ambient drive temperature to 185°F maximum	
	Use Proper Width Pulley	
	Increase Diameter of Backside Idler	
	Pre-heat Drive Environment	

# TROUBLE SHOOTING

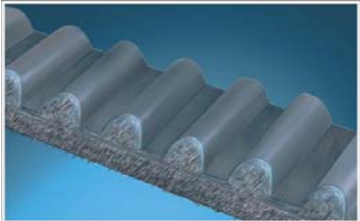
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## CORRECTIVE ACTION

TROUBLE	CAUSE OF PROBLEM	CORRECTIVE ACTION	
<b>Tension Loss / Ratcheting</b>	Weak support structure or mounts	Check Parallel and Angular Alignment of the Pulleys	
	Center to center distance fluctuates	Adjust Tension to Recommended Value	
	Excessive pulley wear	Check Horsepower Rating	
	Fixed (non-adjustable) centers	Check Belt / Pulley Compatibility	
	Excessive debris	Replace Pulley	
	Excessive load	Use Correct Pulley Diameter	
	Subminimal pulley diameter	Eliminate or Control Condition	
	Excessive low or high temperature (-30°F to 185°F)	Clean and Protect Drive	
	Exposure to oil, solvents, harsh	Follow Proper Installation Procedure	
	Belt, pulley or shafts running to hot	Follow Proper Handling and Storage Procedure	
	Unusual belt degradation	Reinstall, Replace, Repair Flange	
	<b>Excessive Belt Edge Wear</b>	Damage due to handling	Remount Bushing and Pulley
		Flange damage	Change Pulley Material
		Belt too wide	Use Inside Idler
Belt tension too low		Redesign Drive	
Rough flange surface finish		Reinforce Structure	
Improper tracking		Noise level is reduced with the use of Rubber Timing Belt	
Belt hitting drive guard or bracketry		Replace Belt	
Misalignment		Check for conductive heat transfer from prime mover	
		Reduce ambient drive temperature to 185°F maximum	
		Use Proper Width Pulley	
	Increase Diameter of Backside Idler		
	Pre-heat Drive Environment		



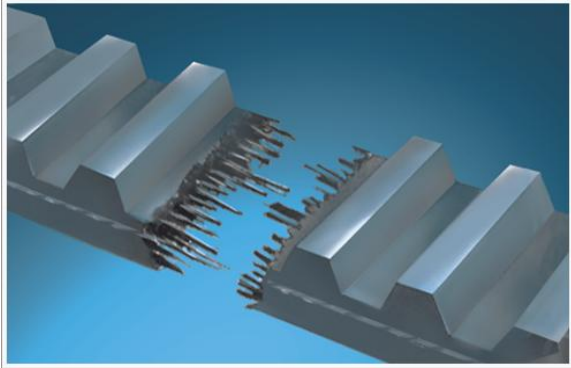
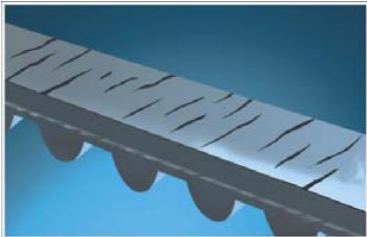
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## CORRECTIVE ACTION

TROUBLE	CAUSE OF PROBLEM	CORRECTIVE ACTION
<b>Tensile Break</b> 	Excessive shock load	<input type="checkbox"/>
	Rolling or prying the belt over the flange when installing	<input type="checkbox"/>
	Subminimal pulley diameter	<input type="checkbox"/>
	Misalignment	<input type="checkbox"/>
	Too low or high tension	<input type="checkbox"/>
	Momentary peak load exceeded design load	<input type="checkbox"/>
	Wrong belt pitch being used	<input type="checkbox"/>
	Improper belt handling and storage	<input type="checkbox"/>
	Weak support structure or mounts	<input type="checkbox"/>
	To narrow belt width	<input type="checkbox"/>
	Sharp teeth on the pulley	<input type="checkbox"/>
	Debris or foreign object in drive	<input type="checkbox"/>
	Extreme pulley run-out	<input type="checkbox"/>
	<b>Belt Cracking</b> 	Subminimal pulley diameter
Backside idler		<input type="checkbox"/>
Extreme low temperature at start-up		<input type="checkbox"/>
Exposure to oil, solvents, harsh chemicals		<input type="checkbox"/>
Cocked bushing/pulley assembly		<input type="checkbox"/>
		<input type="checkbox"/>

CORRECTIVE ACTION
Check Parallel and Angular Alignment of the Pulleys
Adjust Tension to Recommended Value
Check Horsepower Rating
Check Belt / Pulley Compatibility
Replace Pulley
Use Correct Pulley Diameter
Eliminate or Control Condition
Clean and Protect Drive
Follow Proper Installation Procedure
Follow Proper Handling and Storage Procedure
Reinstall, Replace, Repair Flange
Remount Bushing and Pulley
Change Pulley Material
Use Inside Idler
Redesign Drive
Reinforce Structure
Noise level is reduced with the use of Rubber Timing Belt
Replace Belt
Check for conductive heat transfer from prime mover
Reduce ambient drive temperature to 185°F maximum
Use Proper Width Pulley
Increase Diameter of Backside Idler
Pre-heat Drive Environment

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28"  
TIMING BELTS SLIT TO ANY WIDTH



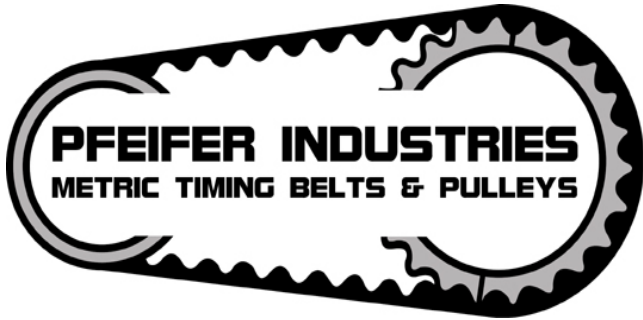
## CORRECTIVE ACTION

TROUBLE	CAUSE OF PROBLEM	CORRECTIVE ACTION
Premature Tooth Wear	Too low or high tension	Check Parallel and Angular Alignment of the Pulleys
	Belt running partly off unflanged pulley	Adjust Tension to Recommended Value
	Misaligned drive	Check Horsepower Rating
	Incorrect belt profile for pulley	Check Belt / Pulley Compatibility
	Worn pulley	Replace Pulley
	Rough pulley teeth	Use Correct Pulley Diameter
	Damaged pulley	Eliminate or Control Condition
	Pulley not to dimensional specification	Clean and Protect Drive
	Belt hitting drive bracketry or other part	Follow Proper Installation Procedure
	Excessive load	Follow Proper Handling and Storage Procedure
	Insufficient hardness of pulley material	Reinstall, Replace, Repair Flange
	Excessive debris	Remount Bushing and Pulley
	Cocked bushing/pulley assembly	Change Pulley Material
	Tooth Shear	Excessive shock load
Less than 6 teeth in mesh		Redesign Drive
Extreme pulley run-out		Reinforce Structure
Worn pulley		Noise level is reduced with the use of Rubber Timing Belt
Subminimal pulley diameter		Replace Belt
Backside idler		Check for conductive heat transfer from prime mover
Incorrect belt profile for pulley		Reduce ambient drive temperature to 185°F maximum
Misaligned drive		Use Proper Width Pulley
Belt tension too low		Increase Diameter of Backside Idler
		Pre-heat Drive Environment
Flange Failure	Belt forcing flange off	
	Misaligned drive	
	Flange incorrectly mounted	

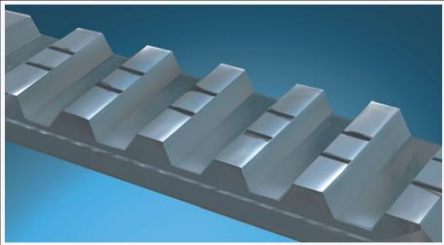
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## CORRECTIVE ACTION

TROUBLE	CAUSE OF PROBLEM	Check Parallel and Angular Alignment of the Pulleys	Adjust Tension to Recommended Value	Check Horsepower Rating	Check Belt / Pulley Compatibility	Replace Pulley	Use Correct Pulley Diameter	Eliminate or Control Condition	Clean and Protect Drive	Follow Proper Installation Procedure	Follow Proper Handling and Storage Procedure	Reinstall, Replace, Repair Flange	Remount Bushing and Pulley	Change Pulley Material	Use Inside Idler	Redesign Drive	Reinforce Structure	Noise level is reduced with the use of Rubber Timing Belt	Replace Belt	Check for conductive heat transfer from prime mover	Reduce ambient drive temperature to 185°F maximum	Use Proper Width Pulley	Increase Diameter of Backside Idler	Pre-heat Drive Environment
<b>Unusual Pulley Wear</b>	Pulley has too little wear resistance																							
	Misaligned drive	■																						
	Excessive debris							■																
	Excessive load																							
	Belt tension too low or high		■																					
	Incorrect belt profile for pulley					■																		
<b>Belt Tracking</b> 	Belt running partly off unflanged pulley	■																						
	Misaligned drive	■																						
	Weak support structure or mounts																							
	Centers exceed 8 times small pulley diameter																							
	Excessive belt edge wear																							
<b>Excessive temperature of belt, bearings, housing, shafts, etc.</b>	Misaligned drive	■																						
	Too low or high tension		■																					
	Incorrect belt profile for pulley					■																		
<b>Shafts Out of Sync</b>	Design error					■																		
	Incorrect belt						■																	

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### CORRECTIVE ACTION

TROUBLE	CAUSE OF PROBLEM	CORRECTIVE ACTION
Vibration	Incorrect belt profile for pulley	Check Parallel and Angular Alignment of the Pulleys
	Excessive load	Adjust Tension to Recommended Value
	Centers exceed 8 times small pulley diameter	Check Horsepower Rating
	Too low or high tension	Check Belt / Pulley Compatibility
	Unbalanced pulleys	Replace Pulley
	Weak support structure or mounts	Use Correct Pulley Diameter
	Bushing or key loose	Eliminate or Control Condition
Bearing Failure	Too high tension	Clean and Protect Drive
	Subminimal pulley diameter	Follow Proper Installation Procedure
	Misaligned drive	Follow Proper Handling and Storage Procedure
		Reinstall, Replace, Repair Flange
		Remount Bushing and Pulley
		Change Pulley Material
		Use Inside Idler
		Redesign Drive
		Reinforce Structure
		Noise level is reduced with the use of Rubber Timing Belt
		Replace Belt
		Check for conductive heat transfer from prime mover
		Reduce ambient drive temperature to 185°F maximum
		Use Proper Width Pulley
		Increase Diameter of Backside Idler
		Pre-heat Drive Environment