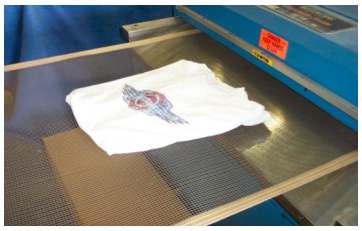
Teflon Belt Startup & Operation*

INSTALLATION AND START-UP PROCEDURES FOR CURING & DRYING BELTS

1. After removing the old belt, check all rolls for buildup of foreign matter (inks, yarn, adhesives, etc.) and remove it as necessary to ensure that no rolls with buildup will interfere with belt tracking or wear.
2. Check limit switches, if present, to ensure they are working properly.
3. Check to ensure that guide rolls and edge sensors are working together properly.
4. Align and level all rolls.
5. Inspect the new belt for damage caused in transit… a damaged belt may adversely affect tracking or guiding.
6. If all rolls were clean and aligned properly, use the old belt to pull the new belt through the oven, being careful not to damage the new belt. If the old belt had to be removed, use a section of it to pull the new belt through the oven, or feed it by hand carefully.
7. Connect the new belt to make it continuous.
8. Apply only enough tension to the belt to take out the slack and prevent slipping on the drive roll. REMEMBER, THE LESS TENSION APPLIED, THE BETTER!!! The exact tension required will vary with each application. Your experience will dictate proper running tension.
9. With the guide roll in neutral and deactivated, start moving the belt at about 10 ft./minute. Use any roll with 30 or 45 deg. of wrap to manually track the belt. Do not use a roll with more wrap since it will vary the path of the belt from side to side. Do not use more than one roll to manually track the belt. Auxiliary rolls should never be removed from their level and parallel position. Try to track the belt to within +/- 1/2".
10. Gradually bring the oven up to operating temperature while constantly checking the belt for tracking. Make any adjustments to the belt using only the roll you have selected to manually track the belt. Changes in temperature will cause variation in belt tension, requiring continued adjustment of the manual tracking roll… REMEMBER TO LEAVE ALL OTHER ROLLS LEVEL AND ALIGNED!!!
11. With the oven operating at maximum temperature, and the belt tracking within 1/2", activate the automatic tracking system. Monitor tracking for another 10 minutes or so to ensure proper operation.
12. Check the belt tension one more time. Remember, the less tension the better. If you need to adjust tension, remember to move the takeup roll equally on each side to maintain proper tracking.
13. Should your belt become damaged, consult the factory for the proper fix. In some cases, the damage may be corrected in the field.
14. Refer to the ***Optimum Operating Conditions*** on this pamphlet for maximum performance and life of your new belt. As always, please call the factory with any questions… We are here to help!

W.F. Lake Corp.
P.O. Box 4214
65 Park Road
Glens Falls, NY 12804
Customer Service: (800) 428-1162
Tel: (518) 798-9934
Fax: (518) 798-9936

www.wflake.com



W.F. LAKE

High Performance PTFE & Silicone Coated Products

OPTIMIMUM OPERATING CONDITIONS FOR W. F. LAKE CURING & DRYING BELTS

In order to ensure maximum life and peak performance of your new belt, please take a few minutes to familiarize yourself with the following points and keep them in mind when operating your equipment.

1. A belt should always be operated under tension… sufficient to take out slack and prevent slip against your drive roll. Minimum tension should be applied to make the belt run and in no circumstances should the belt be exposed to heat while slack!
2. The belt should ideally be operated with a tracking device in place. A simple sensing device operating in conjunction with a pivot roll is sufficient. The pivot roll should have 15 to 30 deg. of wrap and, as the belt off-tracks, will compensate accordingly with the sensing devices.
3. Ideally, the belt will continue to run while the oven is heated, even though your product run may be over. A thermally activated switch could be used to keep the belt running until the oven has cooled to about 190 deg. F. Limit switches and warnings should, of course, be in place to alert your operator or shut down in the event of run-away heat in excess of belt limits.
4. Severe off-tracking should also shut the line down, employing limit switches. Should the belt run off severely, irreparable damage is likely.
5. When attempting to manually track the belt, use an adjustable roll which will pivot forward & backward, or up & down. Ideally, the roll will have no more than 30 to 45 deg. of wrap. Using a tail or turnaround pulley with more than 45 deg. of wrap will alter the path of the belt from side to side.

W.F. Lake Corp. manufactures high performance PTFE and Silicone coated products designed for extreme operating environments. Our non-stick, temperature and chemical resistant materials are uniquely suited for a wide variety of specialized industrial applications in a number of diverse industries. By combining our broad based in-house processing and converting capabilities, we are able to offer you creatively engineered products especially suited to your application. Give us a call to discuss your material needs... we're ready to help!

We manufacture the industry's widest range of PTFE Coated Fiberglass products !

PTFE Coated …

Fabrics
Adhesive Tapes
S-2 Glass Fabrics
Kevlar* Fabrics
High Temperature Belting
Braided Draw Cords
Braided Lacing Tapes
Yarns
E-Glass Sewing Thread
S-2 Glass Sewing Thread (1400 deg. F)
Kevlar* Sewing Thread
Quartz Sewing Threads (2000 deg F !!!)

*Reg. DuPont

W.F. LAKE CORP., 65 Park Road, Glens Falls, NY 12804
Tel: (518) 798-9934 . Tel: (800) 428-1162. Fax: (518) 798-9936. E-mail: info@wflake.com
www.wflake.com

W.F. LAKE

High Performance PTFE & Silicone Coated Products