

PT Pro™ Belt Trainer

Installation, Operation and Maintenance Manual



Serial Number: _____

Purchase Date: _____

Purchased From: _____

Installation Date: _____

Serial number information can be found on the Serial Number Label on the product.

This information will be helpful for any future inquiries or questions about belt cleaner replacement parts, specifications or troubleshooting.

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Section 1 - Important Information

1.1 General Introduction

We at Flexco are very pleased that you have selected a PT Pro™ Belt Trainer for your conveyor system.

This manual will help you to understand the installation, operation and maintenance of this product and assist you in making it work up to its maximum efficiency over its lifetime of service.

It is essential for safe and efficient operation that the information and guidelines presented be properly understood and implemented. This manual will provide safety precautions, installation instructions, maintenance procedures and troubleshooting tips. In addition, please follow all standard, approved safety guidelines when working on your conveyor.

If, however, you have any questions or problems that are not covered, please visit our web site or contact our Customer Service Department:

Customer Service: 1-800-541-8028

Visit www.flexco.com for other Flexco locations and products.

Please read this manual thoroughly and pass it on to any others who will be directly responsible for installation, operation and maintenance of this belt trainer. While we have tried to make the installation and service tasks as easy and simple as possible, **this product does however require correct installation and regular inspection and maintenance to maintain top working condition.**

1.2 User Benefits

Belt mistracking is a common problem that produces various problems, ranging from belt and structure damage to product spillage and safety issues. By utilizing the PT Pro™, it is possible to correct a belt that is mistracking and causing these problems. Multiple units may be required depending on the length of the mistracking belt.

Section 1 - Important Information

1.3 Proper Belt Trainer Selection

MODEL	APPLICATION RANGE
Belt Positioner™	Return side only, 800 PIW max tension on Small, Medium and Large; 1200 PIW max tension on Extra Large. Also works on reversing belts.
PT Smart™	Medium-duty belts up to 1600 PIW max tension. Belt width + 3" idler. Belt thickness 1" maximum.
PT Smart™ Underground	Medium-duty belts up to 1600 PIW max tension. Belt width + 9" idler. Belt thickness 1" maximum. Fits underground structure.
PT Pro™	Medium-duty belts 150 PIW min to 1600 PIW max tension. Belt width 18" - 72" (450 - 1800mm). Also works on reversing belts.
HD PT Pro™	Heavy-duty belts 300 PIW min to 2400 PIW max tension. Belt width 48" - 96" (1200 - 2400mm). Also works on reversing belts.
PT Max™	Heavy-duty belts up to 3000 PIW max Generally 3/4" to 1" thick (19mm to 25mm) Belt width 24" - 60" (600 - 1500mm)
HD PT Max™	Heavy-duty belts up to 6000 PIW max tension. Belt width 54" - 84" (1350 - 2100mm)

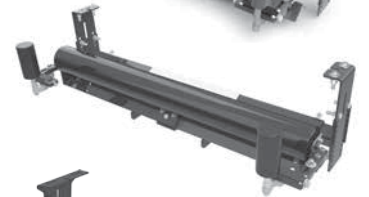
Belt Positioner™



PT Smart™
Standard



PT Smart™
Underground
Structure



PT Pro™



PT Max™
Top Side



PT Max™
Return Side



CONVEYOR CRITERIA	BELT POSITIONER™	PT Smart™	PT Pro™	HD PT Pro™	PT Max™	HD PT Max™
Top side mistracking	NO	NO	NO	NO	YES	YES
Return side mistracking	YES	YES	YES	YES	YES	YES
Reversing	YES	NO	YES	YES	NO	NO
Belt mistracking to one side	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT
Belt mistracking to both sides	POOR	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT
Inconsistent tracking problem	GOOD	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT
Belt is cupped (heavy)	GOOD	GOOD	GOOD	GOOD	EXCELLENT	EXCELLENT
Belt has low running tension (150 - 300 PIW)	POOR	EXCELLENT	GOOD	GOOD	GOOD	GOOD
Belt has medium running tension (300 - 600 PIW)	GOOD	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT	EXCELLENT
Belt has high running tension (600+ PIW)	GOOD	GOOD	GOOD	GOOD	EXCELLENT	EXCELLENT
Approx. "upstream" effect*	50' (15 M)	20' (6 M)	20' (6 M)	20' (6 M)	50' (15 M)	50' (15 M)
Approx. "downstream" effect*	50' (15 M)	120' - 150' (36 - 45 M)	100' (30 M)	100' (30 M)	150' - 200' (45 - 61 M)	150' - 200' (45 - 61 M)

*Typical results; actual results may vary

* Disc idlers have the potential to reduce these numbers

Section 2 - Safety Considerations and Precautions

Before installing and operating the PT Pro™ Belt Trainer, it is important to review and understand the following safety information.

There are setup, maintenance and operational activities involving both **stationary** and **operating** conveyors. Each case has a safety protocol.

2.1 Stationary Conveyors

The following activities are performed on stationary conveyors:

- Installation
- Idler replacement
- Cleaning
- Repairs

DANGER

It is imperative that OSHA/MSHA Lockout/Tagout (LOTO) regulations, 29 CFR 1910.147, be followed before undertaking the preceding activities. Failure to use LOTO exposes workers to uncontrolled behavior of the belt trainer caused by movement of the conveyor belt or belt trainer. Severe injury or death can result.

Before working:

- Lockout/Tagout the conveyor power source
- Clear the conveyor area where work is to take place

WARNING

Use Personal Protective Equipment (PPE):

- Safety eyewear
- Hardhats
- Safety footwear

Close quarters and heavy components create a worksite that compromises a worker's eyes, feet and skull.

PPE must be worn to control the foreseeable hazards associated with conveyor belt components. Serious injuries can be avoided.

2.2 Operating Conveyors

There are two routine tasks that must be performed while the conveyor is running:

- Inspection of belt trainer performance
- Dynamic troubleshooting

DANGER

Every belt conveyor is an in-running nip hazard. Never touch or prod an operating belt trainer. Conveyor hazards cause instantaneous amputation and entrapment.

WARNING

Conveyors contain moving hazards. Stay as far from the trainer as practical and use safety eyewear and headgear.

WARNING

Never adjust anything on an operating belt trainer. Flailing hardware can cause serious injury or death.

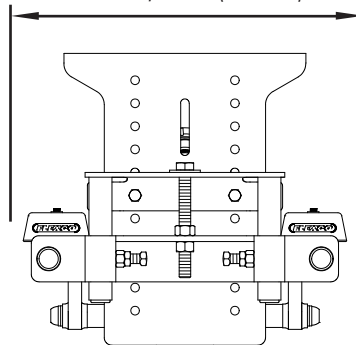
Section 3 - Pre-installation Checks and Options

3.1 Checklist

- Check the model and size of the belt trainer. Is it the right one for your beltline?
 - If using a return-side trainer, verify the trainer is the correct choice for the belt. Flat return trainers are only effective on flat return belts. For V-returns, contact Flexco.
- Check the PT Pro™ to be sure all the parts are included in the shipment.
 - Trainer
 - Rollers
 - Mounting hardware
 - Instruction kit
- Review the “Tools Needed” section on the front of the installation instructions.
- Prepare the conveyor site:
 - Identify the point(s) of mistracking, expecting 100' (30 M) of downstream influence.
 - Position the unit 20' (6.1 M) after the start of the mistracking.
 - Identify an opening per clearance dimensions pictured below.
 - Remove any existing tracking devices that fall in the estimated tracking range.
 - If the conveyor has disc idlers, replace one idler before and one idler after the location where the trainer will be installed with a standard idler.

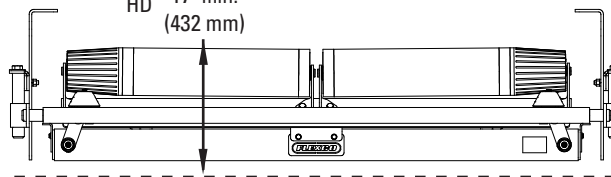
Return Side model

Horizontal Clearance
Standard: 20" min (508 mm)
HD: 21-1/2" min (546 mm)



Vertical Clearance

Standard 15" min.
(381 mm)
HD 17" min.
(432 mm)



Section 3 - Pre-Installation Checks and Options (cont.)

3.2 Optional Installation Accessories

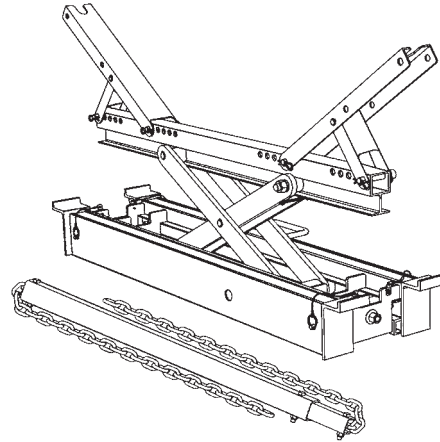
Optional tools can make the installation of the PT Pro™ Belt Trainer easier and faster.

Flex-Lifter™ Conveyor Belt Lifter

Description	Ordering Number	Item Code
Medium Flex-Lifter 36" - 60" (900 - 1500 mm)	FL-M	76469
Large Flex-Lifter 48" - 72" (1200 - 1800 mm)	FL-L	76470
XL Flex-Lifter 72" - 96" (1800-2400 mm)	FL-XL	76983

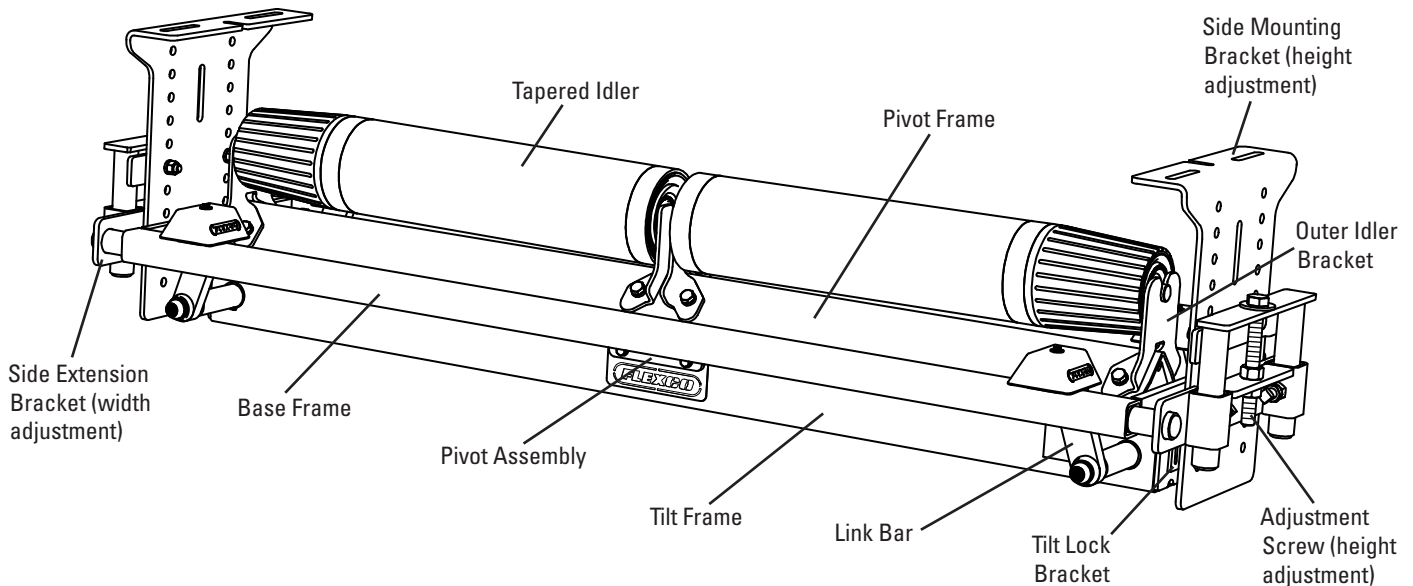
Flex-Lifter™ Conveyor Belt Lifter

The Flexco Flex-Lifter makes the job of lifting the conveyor belt easy and safe. Using two Flex-Lifters, the belt can be quickly lifted out of the way to install the PT Pro™. The Flex-Lifter has the highest safe lift rating available at 4000 lbs. (1810 kg). And it's versatile. It can also be used to lift topside or return side belt for splicing, roller replacement or other maintenance jobs. Available in three sizes: Medium for belt widths 36" - 60" (900 - 1500mm), Large for belt widths 48" - 72" (1200 - 1800mm), and XL for belt widths 72" - 96" (1800 - 2400mm).



Section 4 - Installation Instructions - PT Pro™

4.1 PT Pro



Physically lock out and tag the conveyor at the power source before you begin belt trainer installation.

CAUTION: Components may be heavy. Use safety-approved lifting procedures.

Before You Begin:

- These instructions are designed to be used when installing the PT Pro model.
- The PT Pro has been purposely designed with a much heavier construction than conventional tracking devices. It is, in most cases, TOO HEAVY to manage manually. Please use the necessary mechanical lifting equipment (crane, come-alongs, etc.) for safe installation.
- Ensure that the idler(s) are secure to prevent them from falling out while the unit is being lifted into position on the conveyor.
- The trainer should not be positioned closer than 20 feet (6M) from the tail pulley, take-up pulleys, snub pulley, or head pulley.
- Follow all safety precautions when using a cutting torch.
- If the belt is excessively dirty or caked up, the trainer will NOT perform as intended.

Tools Needed:

- Tape Measure
- 3/4" Wrench (19mm)
- 15/16" Wrench (24mm)
- Medium or Large Adjustable Wrench
- Cutting Torch
- 2 -3 Come-Alongs (3/4 Ton Minimum) and Flex-Lifter
- Any necessary equipment for moving and lifting heavy components

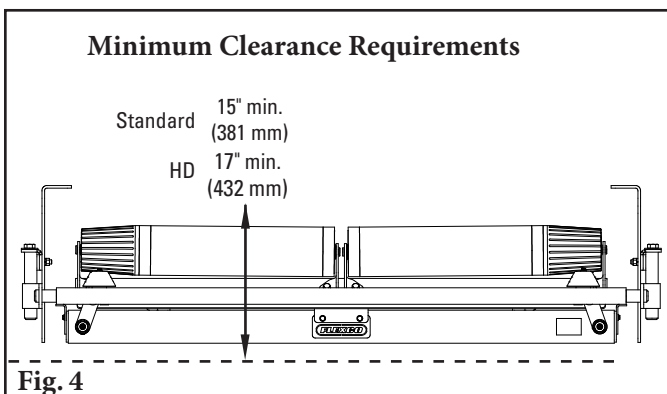
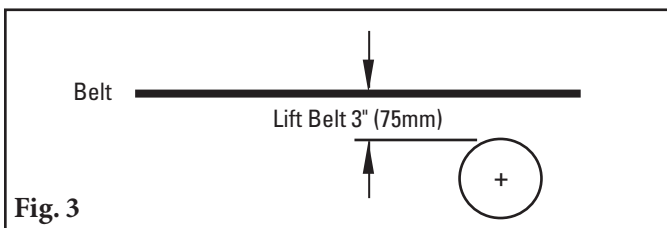
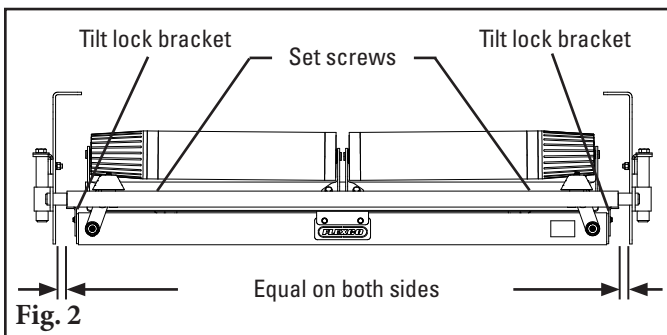
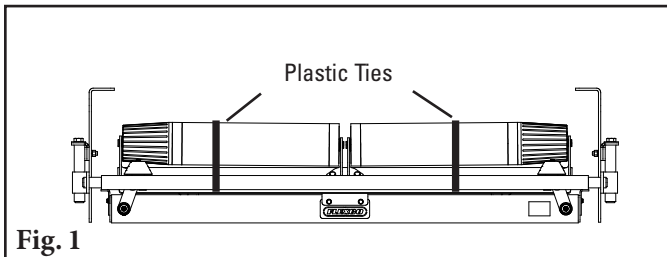
Conveyor Site Preparation:

- Identify the point(s) of mistracking, expecting 100' (30 M) of downstream influence.
- Position the unit 20' (6 M) after the start of the mistracking.
- Identify an opening of at least 20" (506mm) for Standard model, or 21-1/2" (546mm) for HD model.
- Remove any existing tracking devices that fall in the estimated tracking range of the PT Pro as multiple different tracking devices may reduce or prevent the PT Pro from tracking as intended.
- Remove old tracking device or idler at desired installation location.

Section 4 - Installation Instructions - PT Pro™

4.1 PT Pro

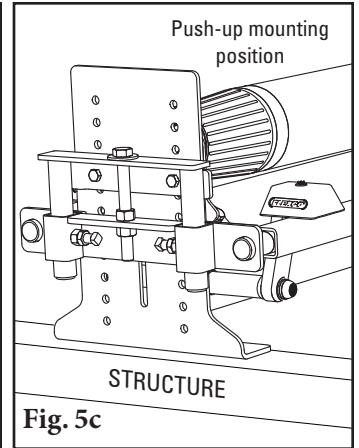
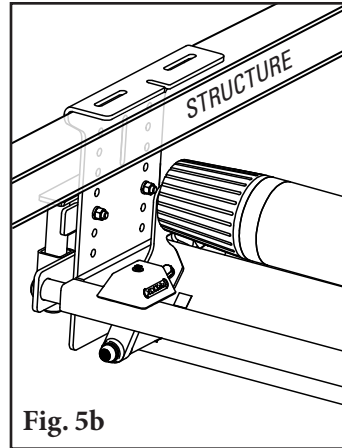
PT Pro Preparation and Installation:



1. **Ensure rollers are secured in the unit.** Do not remove plastic ties from rollers yet. Failure to ensure the rollers are secure may result in serious injury if a roller falls out (Fig 1).
2. **Adjust/telescope extending brackets to match width of structure.** Rings on the extending brackets are provided to match CEMA standard (belt width +9"/225mm) and wide (belt width +15"/375mm) structures. Slide extending bracket horizontally until ring is in line with base frame end for CEMA widths. A set screw on the inside of the base frame is provided to tighten extending bracket. Ensure mainframe is centered (within 1/8"/3mm) on the extending brackets (equal length of extenders showing on both sides (Fig 2).
NOTE: Do not extend beyond Belt Width +15" (375mm), minimum extension is Belt Width +7" (180mm).
3. **Lift the belt where the trainer will be installed.** At the site where the trainer will be installed, lift the belt 3" (75mm) off the return roller that will be replaced (Fig. 3). **Caution:** Some lifting equipment or tools may be required depending upon the weight of the belt.
4. **Remove existing idler.** Unbolt the return roller and mounting brackets and drop it out of the conveyor. **Note:** if the conveyor has disc idlers, replace one idler before and one idler after the location where the trainer will be installed with a standard idler.
5. **Verify clearance for the lower sections of the PT Pro where it is to be located on the conveyor (Fig. 4).** Remove any obstructions such as structure supports.

4.1 PT Pro

-



-
- Fig. 6**
- Equal on both sides
(Previously set up in Step 2)
- Equal within 1/8" (3mm) on both sides
Square and center unit to the structure
- 90°
- 90°

Section 4 - Installation Instructions - PT Pro™

4.1 PT Pro

8. **Determine the roll height or drop of leading and trailing idler.** Measure the height of the PT Pro unit and make adjustments to mounting plate so unit sits at height (see Table 1) relative to leading and trailing idler (Fig. 7a). This may require fine-tuning after belt is lowered back onto trainer. Mounting plate holes allow 1-1/2" (38mm) incremental adjustment and the adjustment screw on the mounting bracket (referenced in Step 12) allow 4" (102mm) of adjustment in order to help dial in the PT Pro height (Fig. 7b). Tighten the four bolts on each side of the mounting bracket.

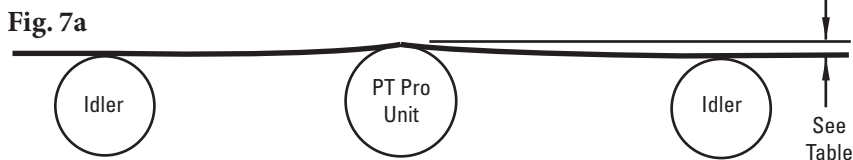
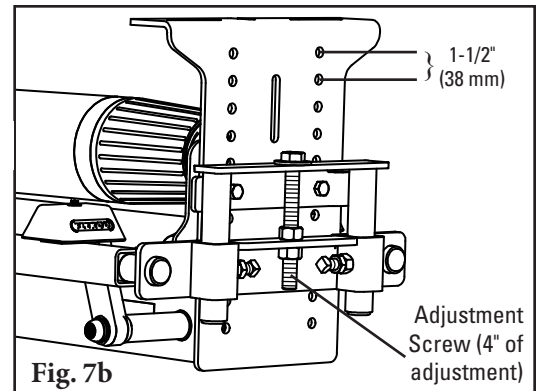


Table 1

Take-Up Type or Belt Tension Range	Trainer Height (higher than leading and trailing idlers)
Screw Take-Up; < 150 PIW	1 ½" (38mm)
Gravity Take-Up; < 400 PIW	½ - 1" (13 - 25mm)
Hydraulic Take-Up; > 400 PIW	0 - ½" (0 - 13mm)

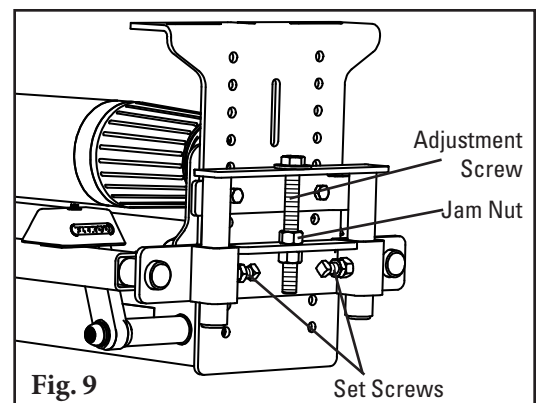
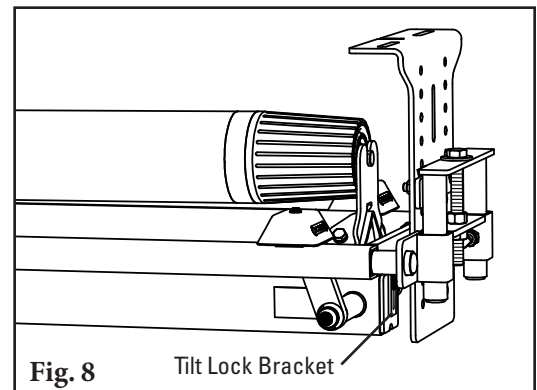


9. **Lower the belt onto the trainer.**

10. **Remove Tilt Lock Brackets from both sides of base frame (Fig. 8).** Failure to do so will prevent the trainer from functioning as intended.

11. **Check for clearance as the unit moves.** Pivot the unit in both directions to ensure there are no obstructions to its movement. **Note:** Unit may be difficult to manually move due to the weight of the belt.

12. **Adjust force required to pivot the trainer.** The belt should be resting on the trainer at this point. To fine-tune performance run the conveyor and monitor how the PT Pro adjusts the mistracked belt. Incrementally move PT Pro up or down to add or reduce pressure by loosening the jam nut and moving the adjustment screw (Fig. 9) until optimal performance is achieved. Lock set screws at final height. Tighten all hardware. **NOTE: Make adjustments in 1/4" increments.**



Section 5 - Pre-Operation Checklist and Testing

5.1 Pre-Op Checklist

- Recheck that all fasteners are tight
- Be sure that all installation materials and tools have been removed from the belt and conveyor area
- Check again that the tilt lock brackets have been removed from both sides of the base frame

5.2 Test Run the Conveyor

- Run the conveyor for at least 15 minutes and confirm the belt is tracking properly.
- If belt is still mistracking too far to one side, refer to Step 12 for optimal pivot force.
- Confirm unit is centered to the structure.

Section 6 - Maintenance

Flexco belt trainers are designed to operate with minimum maintenance. However, to maintain superior performance some service is required. When the trainer is installed a regular maintenance program should be set up. This program will ensure that the trainer operates at optimal efficiency, and problems can be identified and fixed before any damage is done to the belt, the trainer, other conveyor components, or structure.

All safety procedures for inspection of equipment (stationary or operating) must be observed. The PT Pro™ is in direct contact with the moving belt. Only visual observations can be made while the belt is running. Service tasks can be done only with the conveyor stopped and by observing the correct lockout/tagout procedures.

6.1 New Installation Inspection

After the PT Pro has run for 15 minutes a visual inspection should be made to ensure the trainer is performing properly. Make adjustments as needed.

6.2 Routine Visual Inspection (every 2-4 weeks)

A visual inspection of the PT Pro can determine:

- If the belt is tracking as required
- If the trainer is moving freely
- If the main frame is free of material and rolling properly
- If there is damage to the main frame or other components

If any of the above conditions exist, a determination should be made on when the conveyor can be stopped for trainer maintenance.

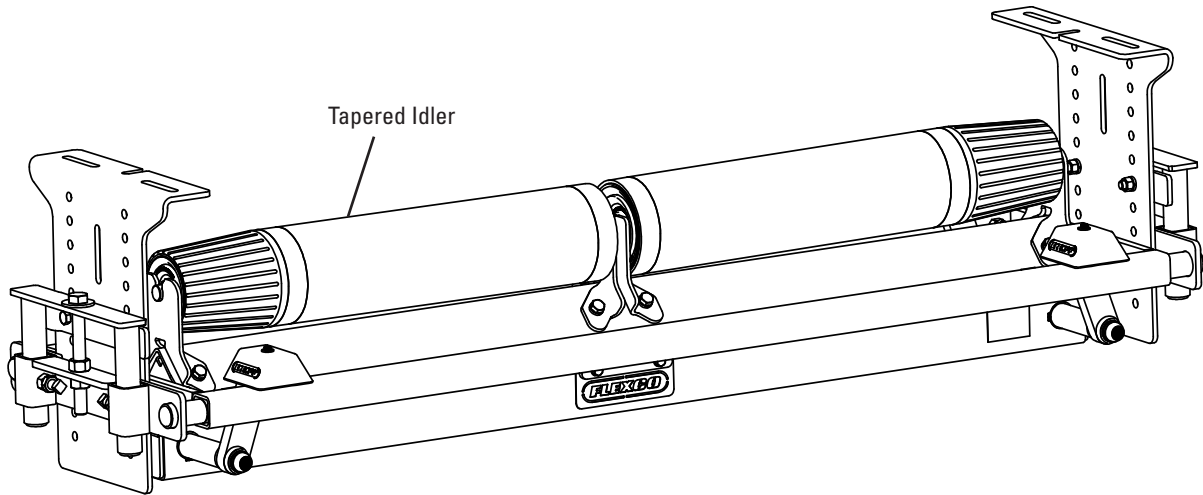
6.3 Routine Physical Inspection (every 6-8 weeks)

When the conveyor is not in operation and properly locked and tagged out, a physical inspection of the trainer to perform the following tasks:

- Clean material buildup off the trainer and components.
- Closely inspect main rollers for free movement and wear. Replace if needed.
- Pivot unit to ensure full and easy movement.
- Closely inspect complete unit for damage.
- Inspect all fasteners for tightness and wear. Tighten or replace if needed.
- When maintenance tasks are completed, test run the conveyor to ensure the trainer is performing properly.

Section 6 - Maintenance

6.4 Roller Replacement Instructions



Physically lock out and tag the conveyor at the power source before you begin cleaner installation.

CAUTION: Components may be heavy. Use safety-approved lifting procedures.

- 1. Remove tension from belt.** Use a Flex-Lifter or other appropriate lifting equipment to lift the belt approx. 3" (75mm) off the trainer.
- 2. Remove roller(s).**
- 3. Install new roller(s).** Be sure rollers are oriented with tapered ends facing outward. Confirm roller turns smoothly.
- 4. Lower the belt.** Ensure belt completely contacts roller(s). Tighten all bolts.

Section 6 - Maintenance (cont.)

6.5 Maintenance Log

Conveyor Name/No. _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Date: _____ Work done by: _____ Service Quote # _____

Activity: _____

Section 6 - Maintenance

6.6 Belt Trainer Maintenance Checklist

PT Pro: _____ Serial Number: _____

Beltline Information:

Beltline Number: _____ Belt Condition: _____

Belt Width: ☐ 18" ☐ 24" ☐ 30" ☐ 36" ☐ 42" ☐ 48" ☐ 54" ☐ 60" ☐ 72" ☐ 84" ☐ 96"
450mm 600mm 750mm 900mm 1050mm 1200mm 1350mm 1500mm 1800mm 2100mm 2400mm

Belt Speed _____ Belt Thickness _____

Idler Roller Life:

Date roller installed: _____ Date roller inspected: _____ Estimated roller life: _____

Roller condition: _____

PT Pro Frame Condition:

☐ Good ☐ Bent ☐ Rusted

Overall PT Pro Performance: (Rate the following 1 - 5; 1=very poor, 5=very good)

Appearance: _____ Comments: _____

Location: _____ Comments: _____

Maintenance: _____ Comments: _____

Performance: _____ Comments: _____

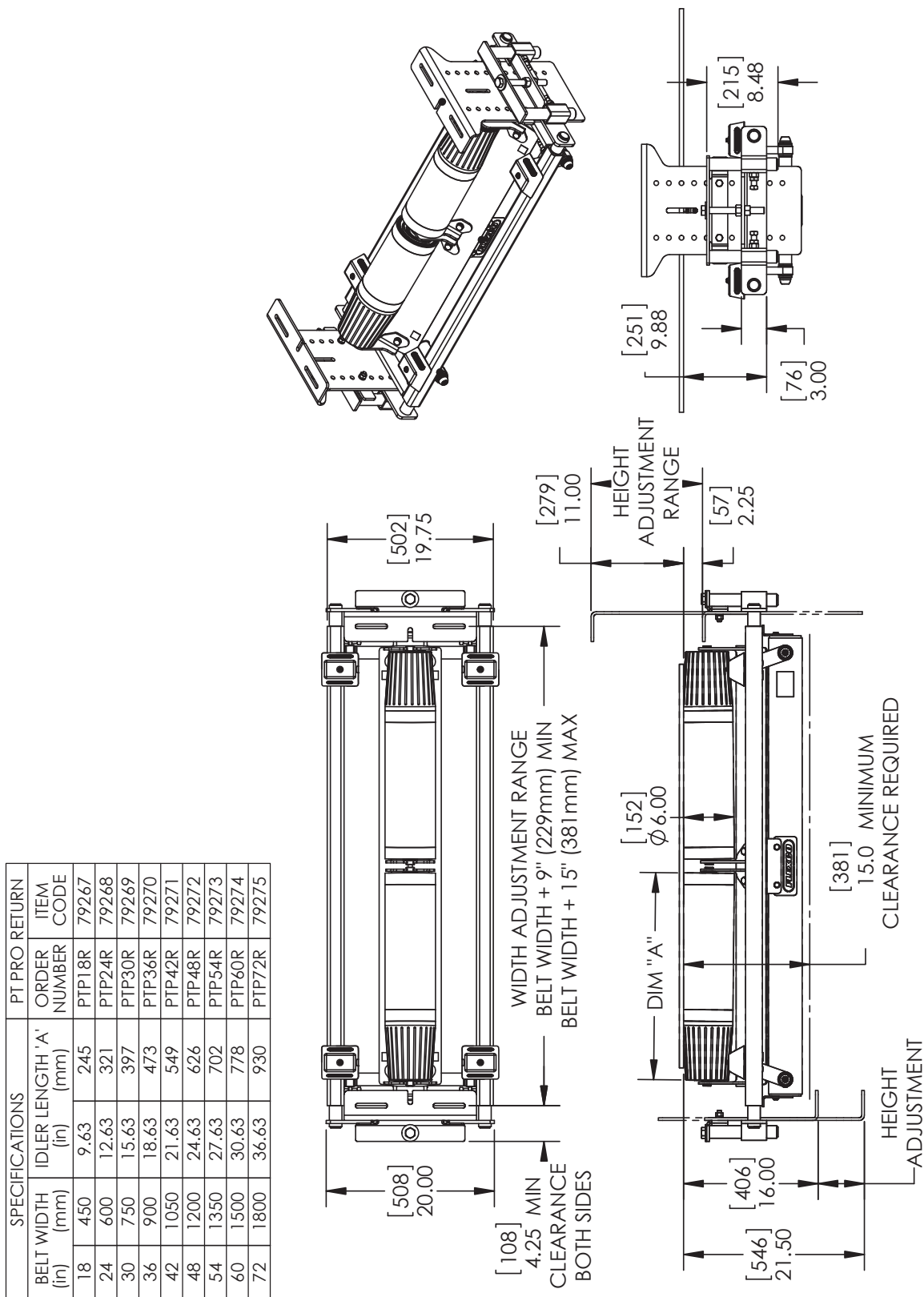
Other Comments: _____

Section 7 - Troubleshooting

Problem	Possible Cause	Possible Solutions
Little to no effect on trouble area of belt	Unit installed in wrong location	Relocate unit 20' (6M) after start of problem area of belt
	Incorrect tension on unit	Refer to step 12 in the installation instructions to fine-tune PT Pro
	Buildup on rollers	Clean unit; add belt cleaners
	Unit installed too close to head/tail pulley or takeup	Move unit 20' (6.0 M) away from head/tail or takeup pulleys
	Angle and profile of trainer does not match nearby idlers	Contact Flexco for idler brackets to match nearby idlers
Belt corrected better in one direction than in other on reversing belts	Unit not centered on frame	Re-center unit
	Unit not square to structure	Re-square to structure
Unit does not pivot	Buildup of material	Clean unit; add belt cleaners
Pivot assembly not turning	Buildup on main roller	Clean unit; add belt cleaners
	Main roller bearing bad	Replace main roller

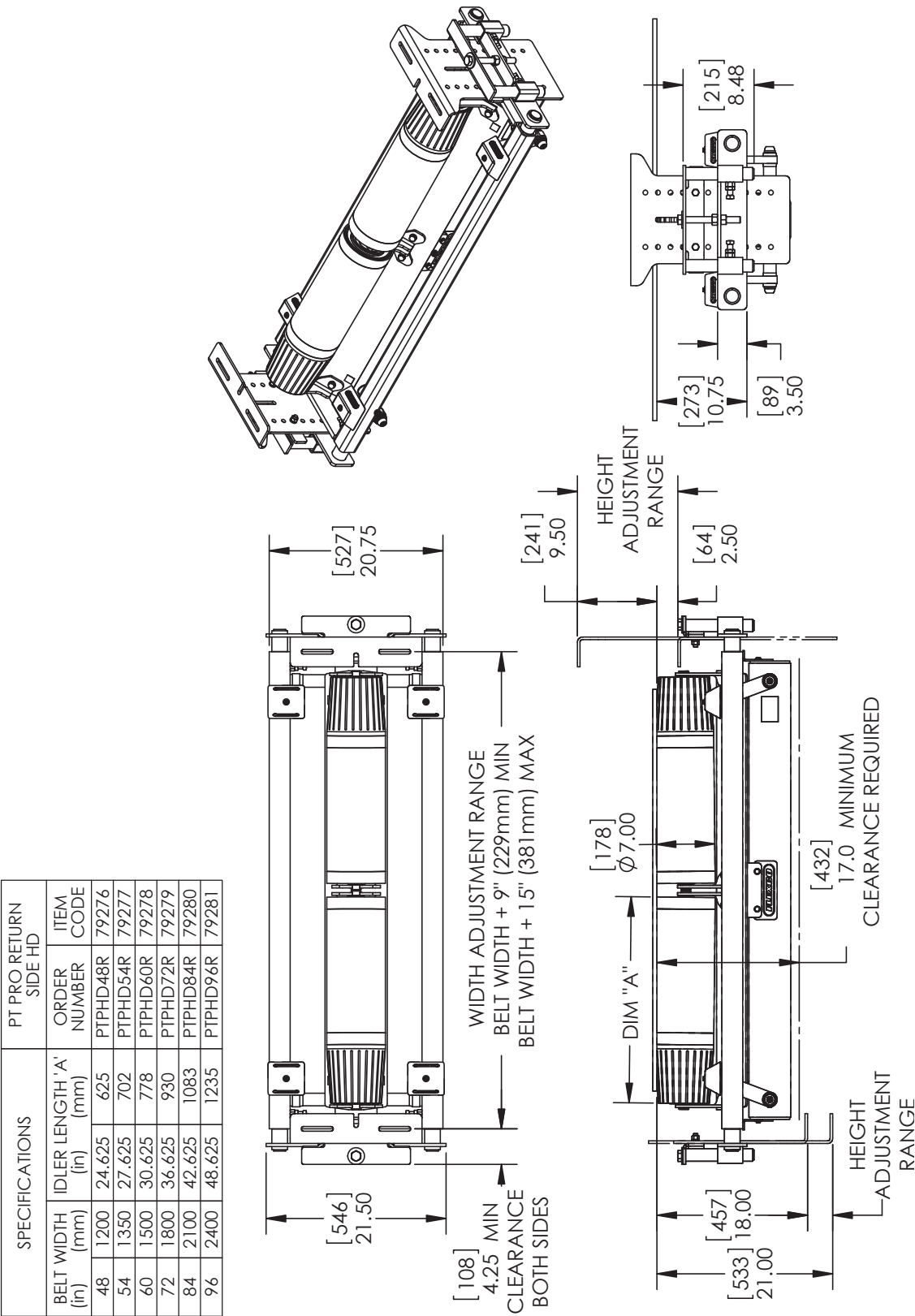
Section 8 - CAD Drawings

8.1 CAD Drawing - PT Pro



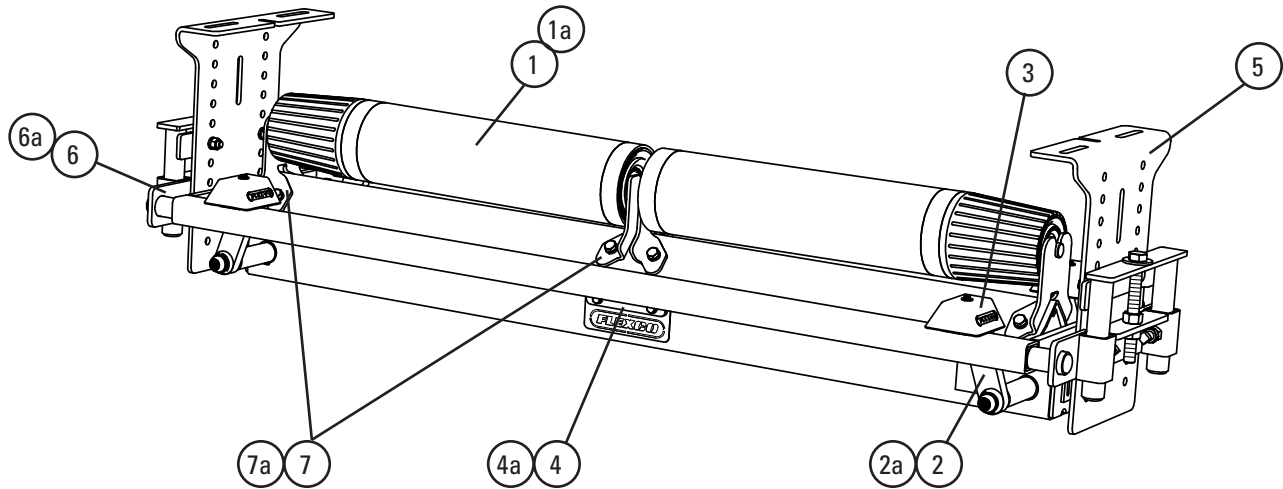
Section 8 - CAD Drawings

8.2 CAD Drawing - PT Pro HD



Section 9 - Replacement Parts

9.1 Replacement Parts List - PT Pro



Replacement Idlers

Ref	Belt Width		Description	Ordering Number	Item Code
	in.	mm			
1	18	450	PTPR Idler 18" (450mm)	NS6DV-18-9.625-A45	26714
	24	600	PTPR Idler 24" (600mm)	NS6DV-24-12.625-A45	26715
	30	750	PTPR Idler 30" (750mm)	NS6DV-30-15.625-A45	26716
	36	900	PTPR Idler 36" (900mm)	NS6DV-36-18.625-A45	26717
	42	1050	PTPR Idler 42" (1050mm)	NS6DV-42-21.625-A45	26718
	48	1200	PTPR Idler 48" (1200mm)	NS6DV-48-24.625-A45	26719
	54	1350	PTPR Idler 54" (1350mm)	NS6DV-54-27.625-A45	26720
	60	1500	PTPR Idler 60" (1500mm)	NS6DV-60-30.625-A45	26721
1a	72	1800	PTPR Idler 72" (1800mm)	NS6DV-72-36.625-A45	26722
	48	1200	PTPR HD Idler 48" (1200mm)	NS7EV-48-24.625-A105	26723
	54	1350	PTPR HD Idler 54" (1350mm)	NS7EV-54-27.625-A105	26724
	60	1500	PTPR HD Idler 60" (1500mm)	NS7EV-60-30.625-A105	26725
	72	1800	PTPR HD Idler 72" (1800mm)	NS7EV-72-36.625-A105	26726
	84	2100	PTPR HD Idler 84" (2100mm)	NS7EV-84-42.625-A105	26727
2	96	2400	PTPR HD Idler 96" (2400mm)	NS7EV-96-48.625-A105	26728
	2		PT Pro Link Bar*	PTPLB	79470
	2a		PT Pro HD Link Bar*	PTPLB-HD	79473
	3		PT Pro Link Shield	PTP-LS	79488
	4		PT Pro Pivot Assy	PTP-RPA	79476
	4a		PT Pro HD Pivot Assy	PTP-HDRPA	79478
	5		PT Pro Mounting Bracket	PTP-RMB	79490
	6		PT Pro Extension Bracket Kit	PTP-EBKR	79484
	6a		PT Pro HD Extension Brkt Kit	PTP-HDEBKR	79486
	7		PT Pro Roller Bracket Kit**	PTP-RRB	79491
	7a		PT Pro HD Roller Bracket Kit**	PTP-HDRBK	79492

Lead time: 1 working day

*Set of 4

**Bracket set for 1 roller

Section 10 - Other Flexco Conveyor Products

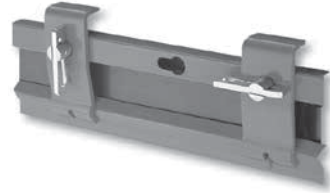
Flexco provides many conveyor products that help your conveyors to run more efficiently and safely. These components solve typical conveyor problems and improve productivity. Here is a quick overview on just a few of them:

EZP1 Precleaner



- Patented ConShear™ blade renews its cleaning edge as it wears
- Visual Tension Check™ for optimal blade tensioning and simple retensioning
- Quick and easy one-pin blade replacement
- Material Path Option™ for optimal cleaning and reduced maintenance

Flex-Lok™ Skirt Clamps



- Eliminates transfer zone spillage
- Interlocking design for easy installation and one-person maintenance
- Unique wedge pin holds rubber securely in place and is easy to adjust
- Available in various models and in stainless steel

MMP Precleaner



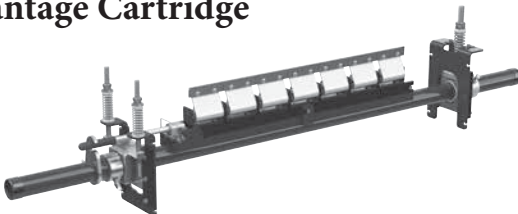
- Extra cleaning power for tough applications
- 10" TuffShear™ blade provides increased blade-to-belt tension
- A 3-piece telescoping pole is lighter to lift and easier to install
- Dual Quick-Mount Tensioners ensure optimal tension throughout the life of the blade

PT Max™ Belt Trainer



- Patented "pivot & tilt" design for superior training action
- Dual sensor rollers on each side to minimize belt damage
- Pivot point guaranteed not to freeze up
- Available for topside and return side belts

MHS Secondary Cleaner with Service Advantage Cartridge



- An easy slide-out cartridge for service
- Cartridge design to speed up blade-change maintenance
- Patented PowerFlex™ Cushions for superior cleaning performance
- Compatible with Flexco mechanical splices

Belt Plows



- A belt cleaner for the tail pulley
- Exclusive blade design quickly spirals debris off the belt
- Economical and easy to service
- Available in vee or diagonal models

The Flexco Vision

To become the leader in maximising
belt conveyor productivity for our customers worldwide
through superior service and innovation.



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