

Thermo Scientific Belt Scale Maintenance

Thermo Scientific Model 10-14, 10-17, 10-20, 10-30, and 10-101 Belt Conveyor Scales

Belt conveyor scales have become an important part of most bulk material handling facilities. However, being relatively unobtrusive in most conveyor systems, they are often overlooked or ignored after their initial installation. Lack of simple maintenance will potentially cause significant reduction in the accuracy capabilities of these instruments. Most belt conveyor scales are capable of providing reliable results within $\pm 0.50\%$ of their full-scale rating. Belt conveyor scales that have been certified via the National Type Evaluation Program (NTEP) are capable of providing results that meet the criteria of the National Institute of Standards and Technology (NIST) Handbook-44, which is 0.25%. This is defined as being within 0.25% of actual material load and repeatable within a 0.25% bandwidth.

Regardless of the accuracy capability of the scale design, it is unlikely that these devices will perform as promised if simple maintenance procedures are not strictly adhered to. Every scale installation will develop its own set of operating characteristics; therefore it is absolutely necessary to monitor the scales performance and provide routine maintenance as required. It is generally advised, throughout the belt scale industry, that calibration checks be made frequently during the weeks after initial installation, then to increase the time frame between calibrations as statistical results are obtained. While this is a simple suggestion to follow, all too frequently the increase in time between calibration verifications defaults to only whenever a problem is suspected. By then it is too late, incorrect weighments have been made, processes have been interrupted and inventory levels need other means of verification.

Establishment of a routine inspection procedure, including not only the belt conveyor scale, but the entire material handling system, will result in an increased confidence in the scale and ultimately greater control of the accuracy it is providing. It is important to remember that the entire conveyor that the belt scale is installed in becomes part of the "weighing system," and that any changes that occur or are performed within this conveyor can and probably will affect the performance of the scale. Therefore, in addition to a routine scale maintenance procedure it becomes imperative that any and all maintenance performed on the conveyor be reported to the individual or department responsible for the scales performance.

Verification of the basic mechanics of the conveyor system itself is an integral part of the scale maintenance procedure.

Please see Thermo Scientific Belt Conveyor Scale Maintenance Check List.



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Applicable to Thermo Scientific Model 10-14, 10-17, 10-20, 10-30, and 10-101 Belt Conveyor Scales

Item	Verification Interval	Notes
Scale Area - Debris	Daily	Clean scale area. Determine cause of debris and take steps to remedy
Zero Cal	Daily	Perform Auto Zero procedure. Accept and record any changes. If change is >0.25%, identify cause and correct. Record results
Idler Roll Condition	Weekly	Inspect idlers for wear / damage. Replace rolls or bearings as needed
Span Cal	Weekly	Perform Auto SPAN simulated load tests. Check repeatability. Record results. Refer the HB-44 section UR.3.2 for actions if error exceeds 0.25%
Belt Scraper	Weekly	Check operation, adjust or replace blades if worn
Belt Condition	Weekly	Visual inspection for cuts, tears or worn edges
Take-Up	Monthly	Inspect for free travel (bearings, sheaves, etc.)
Speed Pulley	Monthly	Inspect for wear, material build-up, belt wrap. Check bearings.
Speed Sensor Coupling	Monthly	Inspect for tightness, wobble and corrosion
Load Cell Offset	Quarterly	No load output must be within 1% of rated maximum (typical "S" cell is ± 0.3 mV)
Load Cell Balance	Quarterly	Multiple load cell scales must be balanced to within 1 mV
Static Weight Condition	Quarterly	Check for corrosion, location and clearances
Revolution Time	Quarterly	Verify time for 1 belt rev at maximum speed
Zero Reference Number	Quarterly	Compare ZERO # with Reference #. Maximum change is 2%/year
Audit Trail	Quarterly	Review scale history
Line Voltage	Quarterly	Measure Hot to Neutral, Hot to Ground, Neutral to Ground. Correct as needed
Alignment	Annually	Complete per instruction manual
Excitation	Annually	Verify value and stability
Belt Length	Annually	Measure and verify. Perform acquire test duration if changes noted
Check Rods	Annually	Inspect check rods. Rods must be straight, spherical washers w/o corrosion
I/O Integrity	Annually	Check and verify performance of all I/O being used
Dead Band	Annually	Confirm settings and adjust if necessary
Auto Zero Track Limit	Annually	Record data
Auto Zero Track Correction	Annually	Record data
Passwords	Annually	Confirm and revise if required
Wire Terminations	Annually	Inspect for corrosion and tightness
Cable Integrity	Annually	Visual and ohm check (corrosion, moisture, deterioration)
Spherical Washers	Annually	Inspect for corrosion, pitting, etc. Replace if necessary
Material Factors	Annually	Verify with weighed load test

After performing ANY tests or maintenance as part of weekly, monthly, quarterly, or annual schedule, ALWAYS repeat zero and span tests.

Factory Assistance in the United States:

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Find out more at thermofisher.com/bulkweighing

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