



TECHNICAL BULLETIN

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935/970 Oven Chain Tension and Adjustment

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NOTE

Keep this T B With the Operations And Maintenance Manual.

Before Maintenance please read and understand all Safety Precautions in your Operations and Maintenance Manual.

A new Oven chain will need to be adjusted after the first (3) months of operation refer to your Operations and Maintenance Manual (see Preventative Maintenance table).

0.1 935/970 Oven Chain Tension Adjustment

Loose Chain; A chain that is too loose may kink (two pitches lifting up on each other) as it leaves the sprockets or shoes. This can cause the conveyor to jam.

Tight Chain; A chain that is too tight can cause premature wearing out of the chains, sprockets and shoes. This can also cause the conveyor to Surge.

The chain tension is increased by turning adjustment nuts (E) and (F) in a clock-wise direction. They must be adjusted evenly so that spring yoke remains parallel with carriage. This can be checked by being sure that spring yoke is the same distance top and bottom from carriage (see Figure 0.3.2: "935/970 Chain Tension Adjustment", on page -4).

0.2 Setting Chain Tensions

Occasionally the chains may surge slightly when the oven is cold. This is normal and should stop once the oven has reached baking temperatures provided the chains are properly tensioned and lubricated.

Since chain tension must only be determined by observation, it requires a certain degree of skill and patience to do the job properly. There is only one place where the chain tension can be observed and that is at the drive end. In any case, the proper tension is indicated when the chain makes a gentle arc as it comes off the rear sprockets or shoe onto the rails (see Figure 0.3.3: "935/970 Chain Tension Adjustment", on page -4).

The conveyor chains on either side of the oven are adjusted independently of each other. The amount of adjustment needed on the left hand (double chain) side of the oven will differ from that on the right hand (single chain) side of the oven.

- Take up unit No. 1 adjusts the double chain side
- Take up unit No. 2 adjusts the single chain side.