

# Safety, Operation, & Maintenance of Conveyor Pulleys



Conveyor Pulley Committee  
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See following CEMA Standards for the appropriate selection and application of conveyor pulleys:

**ANSI/CEMA B105.1-2015** Specification for Welded Steel Conveyor Pulleys

**ANSI/CEMA 501.1-2015** Specification for Welded Steel Wing Pulleys

## Handling:

Conveyor pulleys can be lifted using a double chain sling hooked onto the inside lip of the shell. If web type slings are available, these should be fixed around the shaft between the pulley face and bearing at each end. Under NO circumstances are the pulleys to be lifted using the bearing housings.

Before beginning work on a conveyor always lockout and tag-out the equipment. Follow all OSHA and other guidelines that pertain to lockout and tag-out procedures.

**Failure to follow these procedures may result in serious injury or death.**

CEMA Safety Label CHR930001, [Click to Purchase](#)



Bearings and housings, if provided, have been mounted to manufacturer's instructions provided with the order. For long life use care to keep clean and remount to manufacturers specs, if any work needs to be done. Proper alignment of bearing housings on shaft is necessary for bearing and seal life. Check mounting surfaces and holes before installing pulley assembly.

Adhere to the instructions for Bushing Installation Instructions that are provided for your bushing type.

Before lowering the pulley assembly onto the conveyor frame. Check the following items:

- Be sure the conveyor system power has been locked out and tagged-out.
- Bearing mounting surfaces should be level across the width of the conveyor frame. If not, shims may be required to level the assembly.
- Mounting holes or slots in the conveyor frame must match the bearings about to be installed.
- If jacking bolts are provided on the bearing mounts, make sure they are flush with the heel of the mount prior to installation.

Insure a belt cleaning device is properly selected and installed to minimize carryback of material. See **CEMA Safety label CHS060029**.

Install guarding to limit exposure to moving components and pinch points. See **MSHA Equipment Guarding Free PDF**.

Apply appropriate safety labels for area with **CEMA Safety Placement Guidelines, BH-1 (Bulk Belt Conveyors) & BH-2 (Bulk Belt Conveyor Accessories)**

Use the CEMA Risk Assessment Process to evaluate risk in the area. See **CEMA Risk Assessment Technical Report 2015-01**.