



**2022 CEMA FALL MEETING**  
**BULK HANDLING SECTION MEETING**  
Hilton Chicago O'Hare Airport, Chicago, IL  
Wednesday, September 21, 2022

**MINUTES**

1. Call to order  
Randy Webb, Syntron Material Handling, LLC; Acting Chair, called the meeting to order at 9:35 am.
2. Attendance and Introductions – Roll call attached.
3. Approval of Minutes of March 21, 2022 – Minutes were approved.
4. Current Business Conditions, Labor Situation, and Outlook – Updates  
Labor survey results were emailed in the morning. It was a discussion regarding the process to collect the data, about the poor response maybe the electronic version is not as easy. The thought was free up time in the meeting to discuss the statistics.
5. Committee/Sections Reports
  - a) **Screw Conveyor/Bucket Elevators**
    - Status of 'CEMA Bucket Elevator Book Best Practices in Design' Chapter 4 Final Review – The calculations will remain the same, but the subcommittee will provide examples and clarifications of the variables in the formulas.
    - Bucket Elevator Installation, Operation, and Maintenance Manual (IOM) – Changes regarding the title of the publication need to be discussed with the CEMA's Legal Counsel. The idea is to change from a manual to a guide.
    - Drive Arrangements – The subcommittee is still looking for other inputs or 3D models of how manufacturers mount their drive equipment.
    - Bucket Elevator Explosive or Flammable Material and Additional Topics – It was agreed to make this a standalone document separate from the IOM but referenced in the IOM. Also, to make additional standalone documents for screw conveyors and bucket elevators' explosive or flammable material safety.
    - ANSI/CEMA Standard No. 300 – The subcommittee is working on a survey to be sent to the bearing and seal manufacturers for specific data for specific tables.
    - Drag Conveyors Committee/Membership – The results of the survey reflect that the majority of companies do not see a need for a separate section at this time.



CONVEYOR EQUIPMENT  
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- Drag Conveyor “Best Practices” Book/Manual (Similar to Bucket Elevator Project) – It was agreed that the name should be “En-Masse/Drag Conveyors Best Practices Guide”, this section will move forward with the development of this document.
  - Shoots and Transfer Transitions Best Practices and Design – This section doesn’t see this topic as specifically relevant, so it was agreed to remove it from the agenda.
  - “CEMA Bucket Elevator Book Best Practices in Design”, 2<sup>nd</sup> Edition – Naylu Garces presented some changes needed to other chapters in the book. She has already done a bunch of work that needs to be reviewed. Also, she requested the section that instead of creating a second printing of the book, develop a second edition incorporating all the changes, add the drive arrangements chapter, and review the whole book. The section agreed to move forward with the second edition.
- b) **Chain and Sprocket**
- Chain Lubrication – The title of the white paper was changed to “Chain & Sprocket Lubrication Recommendation”. There are some references to documents that need to be cleaned up. The document will be sent to this section’s chairs for review and approval.
  - Calculating rated working load best practices, AUS, and other chain standard calculations - It was proposed to break out into different types of chains: safety factor/calculation. The subcommittee will schedule meetings to review the different categories of chains and discuss the next steps before the next CEMA Engineering Conference.
  - Section Meeting virtually for the 2023 CEMA Annual Meeting Discussion - Since some CEMA members were not present at this meeting. It was decided to send a survey for a final decision
6. Section Membership  
CEMA membership now stands at 157 members total, including sixteen (16) companies that were added this year.
7. Old business
- a) **Belt Tracking discussion and Comparison of CEMA and ISO Belt Tracking Allowances**  
Subcommittee: Todd Hollingsworth, Raw Resources, LLC (Chair); Jim Masek & Jeff Ellis, PPI; Brett DeVries, FLEXCO; Todd Swinderman, RTodds Engineering LLC; Benjamin Brewer, Douglas Manufacturing Co., Inc.; Akiko Wakatsuki, Fenner Dunlop Conveyor Belting, Joshua Holcombe, Continental Contitech North America, Inc.; Chad Brown, Dodge Industrial Inc.



The key people from CEMA's Conveyor Pulley Committee, Conveyor Idler Committee, and Bulk Conveyor Accessories Committee created a subcommittee but invite them all to join this section to review and discuss if a standard needs to be written on this topic.

Additionally, ARPM sent a letter to CEMA and the chair of the subcommittee explaining the belt training specifications in their publication (ARPM IP-1 Conveyor Belt Handbook): *"When the belt is running on a correctly aligned conveyor and loaded centrally, the movement of the belt should not deviate from the central track by more than +/- 40 mm (1-9/16 in) for a belt width up to including 800 mm (32 in), or by more than +/- 5% (+/- 75 mm (3 in) max.) of the belt width for widths over 800 mm (32 in), according to ISO standards (ISO 22721, ISO 14890, and ISO 15236-1)".*

ARPM requested that CEMA follows the recommendations of their document. The subcommittee agreed to review the document and offer their feedback to this section and ARPM.

The subcommittee was considering adding tolerances based on using CEMA standard components and then referencing the ISO tolerance. The subcommittee will continue working on the document.

b) **Drag Conveyor and Bucket Elevator discussion** – Results

Andy Solis, CEMA, sent out a survey to the Bulk Handling Section Members to determine how many members manufacture drag conveyors and to determine whether statistical reporting would be possible.

The results of the survey reflect that show that the majority of companies do not see a need for a separate section at this time. (See the results attached)

8. New Business – No new business was discussed at this meeting.
9. Next Meeting – March 13, 2023, at The Scottsdale Resort at McCormick Ranch, Scottsdale, AZ.
10. Meeting was adjourned at 10:30 am

Respectfully submitted,  
Randy Webb, Acting-Chair







# En Masse Conveyor Section Survey Results

