



# Cleaning Recommendations — DRY-PT<sup>®</sup> TableTop<sup>®</sup> and MatTop<sup>®</sup> Chain

Dry running conveyors lack the advantage of the continuous cleaning effect of soap and water lubrication. This means spilled product (such as syrup, beer, soda, etc.), dirt and debris may build-up on the chain surface and inside the conveyor. Contamination can result in a higher friction between the PET containers and the chain surface, that has a negative effect on container stability, backline pressure and wear life of the chains and conveyor components.

A thorough and regular cleaning procedure is eminent for successful operation of any dry running conveyor line.

**NOTE:** *If conveyors are going to sit idle for a long time before start-up, they should be covered with plastic or drop cloth to minimize dirt and debris that can settle into the chains and tracks.*

**NOTE:** *Before start-up, remove any tools, fasteners, or other items that may have been left behind. Thoroughly clean chains, wear strips and tracks (carry & return) with air hose or high pressure water spray.*

## Recommended Cleaning Frequency

**Completely Dry Lines** — The main indicator for the necessity of cleaning is the increase of friction between the chain surface and PET container to a critical level, where it affects the product flow. The required intervals for cleaning depend on the product type that is being filled, the stability of the product and the position in the line. For example: a conveyor next to a filler needs to be cleaned more often, compared to a mass handling conveyor near the case packers.

In case of beverage spillage (that contains sugar) on the tracks, it is recommended to prevent drying up of the beverage as this will cause a sticky surface. The preferred method is by rinsing with warm softened water.

The dry running conveyors in the most critical sections of a line should be cleaned daily to obtain maximum sanitation and performance. At the very minimum, rinse **daily** and thoroughly sanitize **weekly**.

## General Guidelines for Cleaning Solutions

1. Recommended pH-values between +4 and +10.
2. Avoid cleaning agents that contain Chlorine (Bleach), Ammonia or Phosphoric Acid.
3. Always rinse sufficiently with clean **softened** water.
4. Refer to "Corrosion Resistance Guide" in the Engineering Manual to determine compatibility of cleaning agents used on the chain and other conveyor components in case of doubt.

## Methods of Cleaning

1. Periodic high pressure hot water rinse or steam cleaning should prove satisfactory. Spray the chain/belt in place on each conveyor, both on the carry and in the return sections. For easy access to the undersides of the chains/belts in the carry and return ways, some manufacturers provide "clean out" holes in the side frames.
2. Warm water and mild soap are commonly used to clean the conveyors.
3. Foaming agents or other chemical cleaners may be used only if they are compatible with conveyor materials (see General Guidelines, item 4). Carefully follow the instructions provided by the manufacturer to determine proper concentration of solutions and proper, safe use and disposal.








**NOTE:** *Keep water, steam and chemicals away from electrical sensors, motors, photo eyes, etc.*

4. It may be necessary to periodically clean the chains/belts with a bristle brush. Clean the chain/belt in place on the conveyor, both on the carry and in the return sections.
5. After a period of running the conveyor without lubrication, some fine wear-dust can collect in the conveyor, originating from the wear strips, corner tracks and/or chain. Removing this dust periodically with cloth or vacuum cleaner is sufficient.

**NOTE:** *The main objective is to clean the chain carrying surface and underside, as well as the wear strips and corner tracks.*

**NOTE:** *Inspect conveyors often. Remove jammed pieces of containers as soon as they are detected. Use warm water to clean away beverage spillage.*

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-  **WARNING:** Before working inside conveyor frames or coming in contact with conveyor components, always make sure all drives are locked out and tagged.
-  **WARNING:** Always use soft water on the conveyors, to prevent build-up of lime scale. Lime scale has a negative effect on the chain friction and reduces the wear life of the chain and conveyor components.
-  **CAUTION:** All cleaning agents and lubricants must be compatible with chain material, wear strip and sprocket materials. In case a material or chemical is not listed in the Corrosion Resistance Guide, contact Rexnord Application Engineering or the cleaner/lubricant manufacturer for assistance.
-  **CAUTION:** Failure to follow items 1 through 4 of the General Guidelines could result in chain damage and/or failure.
-  **CAUTION:** It is recommended that steam is not held on chain/ belts for prolonged periods. Chains/belts may deform or become permanently damaged.
-  **CAUTION:** Strong caustic agents should not be used with plastic chains.
-  **CAUTION:** Always thoroughly rinse all cleaning agents completely off the chain, components and conveyor frame. Make sure that the return section of the conveyor is also rinsed thoroughly, as chemicals that remain inside the chain can cause chemical attack on the plastic.