**Cause of Failure:** Excessive exposure to oil or grease has caused the belt to swell, become soft and the bottom envelope seam to "open up".

**Correction:** Do not over lubricate, check for oil leaks. Clean sheaves before installing new belt.

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**Cause of Failure:** A tensile break, as shown at left, can be caused by high shock loads, a foreign object between the bottom of the sheave and the bottom of the belt or by damage due to improper installation.

**Correction:** Check to assure proper tension is maintained. Assure idlers are not worn or binding. Release tension prior to installing a new belt. Do not pry belt over pulleys. Check for foreign objects that might jam the drive system.

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**Cause of Failure:** Back side of belt envelope is worn prematurely.

**Correction:** Assure proper clearance on belt guides. Check for frozen back side idler.
**Cause of Failure:** Foreign object damage.

**Correction:** Assure all protective shields are in place and removed periodically for cleaning.

**Cause of Failure:** Spin burn-damage is limited to one area. Belt burned by friction.

**Correction:** Assure belt guides allow de-clutching. Check for something frozen or jammed in the drive system (example: frozen blade spindle bearing).

**Cause of Failure:** Dusty environment or rough sheaves combine to cause severe envelope wear and early failure.

**Correction:** Replace rough sheaves. Due to weather conditions, dust may not be avoidable.
**Cause of Failure:** Misalignment of sheaves. Causes wear to one side.

**Correction:** Check for a sheave with a rough edge. Align sheaves to specifications.

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**Cause of Failure:** Belt is narrow or bulged in one spot, and has a bend in it. It will not lay flat. Some of the load carrying members (cords) are broken. Cause is either a shock load or improper installation.

**Correction:** Assure proper tension. Install after relieving tension. Do not pry or roll the belt onto the pulleys. Advise operator to avoid objects that might cause sudden stoppage.

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**Cause of Failure:** Rapid wear where the belt contacts the sheaves. The wear will cover the full length of the belt. Cause is slippage due to overloading or improper tension.

**Correction:** Assure proper tension, neither too high nor too low. Check idlers for free movement and assure idler springs are undamaged. On fixed idlers, check adjustment periodically. Check application and avoid misuse.
**Cause of Failure:** Overloading and shock load causes shearing of cogs. However, note wear between cogs. This belt was severely worn before the shearing began.

**Correction:** Replace worn pulleys, install new belt and correct tension.

A special thank you to the Goodyear Tire & Rubber Co. for their assistance in compiling this information.