



Conveyor Cleaning

Guidelines





Conveyor Cleaning Recommendations

Removable Components - Retaining Walls and Belt Supports should remain on the conveyor at all times except during the cleaning process. Failure to do so may cause injury.

Lift the Belt and Clean - The tensionless drive aspects of the belting allow the option to clean the conveyor and belt by lifting the belt while it is on the conveyor.

Water Temperature - 120o - 140o F (49o - 54o C) for most protein applications; up to 165o F (74o C) for beef; room temperature for heavy flour

Water Pressure - 15 - 17 bar (200 - 250 psi) optimum

Detergents - Let detergent stand no longer than 20 minutes

Sanitisers –



OK to use.

Use According to Manufacturers Directions, some discoloration and/or shrinkage may occur

Will result in significant shortening of component life.

		Belting					Conveyor Components		
		Polyethylene	Polypropylene	Acetal	Nylon	ThermoDrive	HDPE	UHMW	VHMW
Chlorine	Post Sanitation 200 ppm								
	Continuous or Intermittent 50 ppm								
Quaternary Ammonium	Post Sanitation Any Strength								
Peracetic Acid	Post Sanitation								
	Continuous or Intermittent								

Post Sanitation -- use after full cleaning performed at the end of a full production shift. Can be up to 4 times daily. Does not include soaking or exposure to sustained high temperatures.

Continuous or Intermittent -- applied all through production as a kill or intervention step. May or may not have direct product contact.

Soaking - Not recommended. In the event components are soaked Quaternary Ammonium is the only chemical that should be used.

Inspecting the Conveyor After Sanitation - Use all appropriate safety gear & procedures during inspections

Make sure that high concentrations of chemical residue are rinsed off of the entire conveyor system

Carryway and returnway should be properly seated onto the crossbars

Make sure that the belt is seated between sidewalls & the removable retaining walls (or under the belt containment guides for some flat conveyors)

Make sure that the belt is not tensioned (not tight) for any reason and includes catenary sag(s) in designated area(s)

Look for unusual wear patterns on the frame and belt. This could indicate a mechanical obstacle.

Important Notes

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