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	STANDARD: **OSHA 29 CFR 1910.212 & ASME B20.1**	AUDIT FREQUENCY: **Daily Pre-Shift**

Conveyor Belt Maintenance Inspection Checklist

Operational Scope: This inspection checklist governs the pre-operational assessment of material handling conveyor systems to mitigate caught-in, crush, and electrical hazards. Compliance is mandatory for all warehouse operations to satisfy workplace safety standards and ensure continuous equipment reliability.

MANDATORY PPE:	Hard Hat (ANSI Z89.1), Steel-Toe Safety Boots (ASTM F2413), High-Visibility Safety Vest, Safety Glasses with Side Shields (ANSI Z87.1), Cut-Resistant Gloves
PREREQUISITES:	Complete Lockout/Tagout (LOTO) verification if internal mechanical access is required. | Ensure all area emergency stop pull cords and trip switches are unobstructed. | Verify proper operational clearance around all conveyor transfer points.

MECHANICAL & STRUCTURAL INTEGRITY

#	COMPONENT / ITEM	VERIFICATION CRITERIA & ACCEPTANCE STANDARD	SEVERITY	STATUS
1	**Belt Surface and Splices**	Inspect belt for excessive fraying, deep punctures, tearing, or failing mechanical splices; no exposed carcass.	**Critical (Immediate Out of Service)**	[ ] PASS [ ] FAIL [ ] N/A
2	**Drive Rollers and Pulleys**	Check for material buildup, bearing overheating, unusual vibration, or excessive wear on lagging surfaces.	**Warning**	[ ] PASS [ ] FAIL [ ] N/A
3	**Idler Rollers**	Ensure all rollers spin freely without binding, squeaking, or missing retaining clips; replace seized rollers.	**Standard**	[ ] PASS [ ] FAIL [ ] N/A
4	**Belt Tracking and Alignment**	Verify belt tracks centrally along the bed without rubbing against structural side frames or supports.	**Warning**	[ ] PASS [ ] FAIL [ ] N/A

SAFETY GUARDS AND EMERGENCY CONTROLS

#	COMPONENT / ITEM	VERIFICATION CRITERIA & ACCEPTANCE STANDARD	SEVERITY	STATUS
5	**Nip Point and Drive Guards**	Confirm all fixed and interlocked machine guards covering drive chains, tail pulleys, and nip points are securely fastened.	**Critical (Immediate Out of Service)**	[ ] PASS [ ] FAIL [ ] N/A
6	**Emergency Stop (E-Stop) Systems**	Test all pull cords and push-button E-stops to verify immediate power interruption to the conveyor drive motor.	**Critical (Immediate Out of Service)**	[ ] PASS [ ] FAIL [ ] N/A
7	**Warning Signage and Audible Alarms**	Verify that all pinch point warning decals are legible and pre-start warning sirens/strobes function properly.	**Standard**	[ ] PASS [ ] FAIL [ ] N/A

DRIVE, ELECTRICAL, AND HOUSEKEEPING

#	COMPONENT / ITEM	VERIFICATION CRITERIA & ACCEPTANCE STANDARD	SEVERITY	STATUS
8	**Drive Motor and Gearbox**	Inspect motor housing for unusual heat, fluid leaks from the gearbox, and secure electrical conduit connections.	**Warning**	[ ] PASS [ ] FAIL [ ] N/A
9	**Take-Up Mechanisms**	Check counterweights or spring-loaded take-ups for proper tensioning travel, free movement, and physical security.	**Standard**	[ ] PASS [ ] FAIL [ ] N/A
10	**Under-Belt Clearance & Housekeeping**	Clear debris, spilled product, and combustible dust buildup from beneath the conveyor run and return paths.	**Warning**	[ ] PASS [ ] FAIL [ ] N/A

Certified Inspector / Lead Operator Signature: _____	**Date / Time:** _____	**Badge / Cert #:** _____
Site Safety Supervisor / Operations Manager Sign-off: _____	**Review Date:** _____	**Audit Status:** [ ] Approved [ ] Rectify

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