

DESCRIPTION:	Mechanical - Inspection of Conveyor Wear Bars Thickness	FREQUENCY:
LOCATION:	Various Locations	STANDARD JOB No.:

Reference Material
Replacement of wear bar required when shank length of bolt reaches 6 mm or less.
** Allowance must be made for washer thickness on fixing bolt.**
**** e.g. if washer thickness is 2 mm then shank length of bolt is 8 mm or less.****
e.g. ii washer thickness is 2 min their shark length of bolt is 6 min of less.
ST033 Wacol STP – Grit Removal Screw Conveyor
Internal wear bars as new = 8 mm thickness
Screw Conveyor tube wall as new = 3 mm thickness
ST060 Kooralbyn STP Inlet Works Sand Conveyor
Internal wear bars as new = 8 mm thickness
Screw Conveyor tube wall as new = 3 mm thickness
Length of bolt at new = 12 mm
ST060 Kooralbyn STP Inlet Works Grit Conveyor
Internal wear bars as new = 8 mm thickness
Screw Conveyor trough wall as new = 2.5 mm thickness
Length of bolt at new = 12 mm
ST057 Beaudesert STP Inlet Works Sand Conveyor
Internal wear bars as new = 8 mm thickness
Screw Conveyor tube wall as new = 3 mm thickness
Length of bolt at new = 12 mm
ST057 Pagudasart STP Inlat Warks Grit Canyovar
ST057 Beaudesert STP Inlet Works Grit Conveyor Internal wear bars as new = 8 mm thickness
Screw Conveyor trough wall as new = 2.5 mm thickness
Length of bolt at new = 12 mm
Length of bolt at new – 12 mm

Doc Id:FOR450Active Date:20/05/2022Revision 2OwnerTyson CraigPrinted:Page 1 of 2

Note: Printed copies of this document should be verified for currency against the published electronic copy.





DESCRIPTION:	Mechanical - Inspection of Conveyor Wear Bars Thickness	FREQUENCY:	
LOCATION:	Various Locations	STANDARD JOB No.:	

Procedural Steps
Before isolating any equipment where possible observe in running condition. Check for correct operation.
This task is to establish the remaining useful life of the wear bars and if replacement is required.
Isolate screw conveyor.
Isolate all incoming flow.
** If by-pass of conveyor/s not in place then a Risk Assessment to be undertaken to determine if flow can remain while carrying out condition assessment.
Drain conveyor.
** If by-pass of conveyor/s not in place then a Risk Assessment to be undertaken to determine if draining is required to perform condition assessment.
Wear bar fixing bolts located on outside of conveyor tube/trough.
Remove only one wear bar fixing bolt at a time.
** The number of bolts to be removed is a case by case basis that will allow condition assessment of remaining thickness of each wear bar section that is accessible.
Measure shank length bolt to establish remaining thickness of wear bar.
Replace bolt once measured.
Return conveyor to service.

Doc Id:FOR450Active Date:20/05/2022Revision 2OwnerTyson CraigPrinted:Page 2 of 2

Note: Printed copies of this document should be verified for currency against the published electronic copy.