



Ashworth Bros., Inc.

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Conveyor Belt Cleaning Protocol

Ashworth Conveyor Belts are to be cleaned and sanitized using the following 7-Step Process.

Step 1: Dry Clean

Dry clean the conveyor belt and related equipment by removing large pieces of soil and food from the belt's surfaces. Also make sure compacted debris is removed from the sprockets, idler wheels and support rails (heretofore referred to as the belt's support system).

When cleaning the conveyor belt, work in a top-down, inside-edge-of-belt to outside-edge-of-belt, ordered pattern. All subsequent cleaning and sanitizing steps of this procedure are to be completed using this same pattern.

Step 2: Pre-Rinse

Pre-rinse the belt and support system with hot water heated to a temperature of 125 – 130°F (52 – 54°C) and at a pressure of 150 – 300 psi (10 – 20 bar). Care is to be taken that floor drains are kept clear of debris to avoid pooling of water.

Step 3: Apply Detergent

Apply an appropriate foaming detergent mixture to the belt and support system at 150 psi (10 bar). The detergent foam can be allowed to remain on the belt for 10 – 15 minutes, but *should not allowed to dry, as dried chemical is often more difficult to completely remove and may support the growth of biofilms.*

Step 4: Rinse and Inspect

Flood rinse the belt and support system with 40 – 60 psi (2.8 – 4.1 bar) water at 125 – 130°F (52 – 54°C). After the rinse, inspect the belt and support system components to ensure it is free of soils, water beads, hazes, films and other residue. This inspection should be conducted using sight, touch and smell.

Step 5: Pre-Op the Belt

Verify that all cleaning chemical is removed from the conveyor belt, sprockets, idlers and support rails. It's recommended that pH testing be used as an aid in determining that the belt is free of the detergent. Run the conveyor belt slowly to help dry it and its supports, and remove any pooled water from the floor.



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Step 6: Inspect and Release for Sanitizing

Re-inspect the belt and support system using sensory analysis to detect the presence of bacteria. Ashworth recommends adenosine triphosphate (ATP) testing be used to verify absence of bacteria. ATP is present in all animal, vegetable, yeast and mold cells. Detection of ATP indicates contamination by at least one of these sources. Correct any noted deficiencies detected by ATP testing and re-lubricate the belt and support rails as directed by Ashworth. Release the belt for sanitizing.

Step 7: Sanitizing

Apply the appropriate sanitizers at “no rinse” concentrations, following the manufacturer’s recommendations. Run the belt as the sanitizer is applied in order to ensure that all parts of the belt and support system have been completely exposed to the chemical. Squeegee any sanitizer that has pooled on the floor into floor drains.

Important Cautionary Notes

- I. Ashworth recommends that water pressure not exceed 300 psi at any stage of the cleaning process to avoid contamination resulting from overspray of water and chemicals.
- II. A caustic wash may be necessary due to health or other safety requirements. We recommend that caustic solutions not be left on the belt or used in any stronger concentrations than necessary to meet local regulations. Use of these products must strictly follow the manufacturer’s directions.

Of special concern is the use of caustic or harsh chemicals on plastic belts, support rails and cage bar caps, as these chemicals can soften plastic materials, which can lead to damage or failure of the belt and other components. Food processors should likewise be aware that chlorine-based cleaning products can also affect stainless steel and rubber components that are common to food processing equipment.

III. Conveyors and equipment that operate Ashworth conveyor belts can be large and often have exposed moving parts. When working around operating conveying equipment, workers must be aware of possible safety hazards and work within their company’s safety guidelines to prevent personal injury.

VI. It is sound practice to alternate appropriate sanitizers to prevent development of bacteria resistance to any one sanitizing agent and to prevent overgrowth by certain bacteria stains.