



07

Sanding

7.2 Wide Belt Sander

7.2.1 Sanding Solid Wood

Candidate Name: _____ Date/Time: _____

Evaluator Name: _____ Location: _____

Completed test successfully: Yes No (If no, reason:) _____

Pre-Operation Checklist

Level 1

PERFORMANCE STANDARD:

- ▶ Verifies dust collection operable/operating.
- ▶ Ensures paths of in-feed and out-feed have no obstructions to material and operator.
- ▶ Minimum part length is observed.
- ▶ Material is properly supported at in-feed and out-feed.

Level 2

PERFORMANCE STANDARD:

- ▶ Correct sanding head(s) are selected and engaged.
- ▶ Sets optimum initial thickness prior to first pass based on maximum thickness or species of material.
- ▶ Installs appropriate grit/type of belt for given operation.
- ▶ Checks and adjusts (when required) abrasive belt tracking.
- ▶ Verifies proper adjustment of platen(s).
- ▶ Inspects and clears moisture traps and drains.
- ▶ Meets Level 1 performance standard.

Considerations:

- ▶ Pre-Operation Checklist is a prerequisite for ANY operation.
- ▶ Tool/Machine Manufacturer's safety rules and guidelines are followed.
- ▶ Verifies tool is properly guarded.
- ▶ Demonstrates knowledge of and proper use of all machine specific controls.
- ▶ Proper stance and hand position are demonstrated.
- ▶ Inspect for evidence of defective finish conditions such as but not limited to chatter marks, streaking or part hesitation.
- ▶ Spot check sanded dimensions following the operation.
- ▶ Abrasive belt conditions are monitored, analyzed and changed as required.
- ▶ If required select proper program from controller or Programmable Logic Controller (PLC).
- ▶ Operator clears machine and cleans work area after use.
- ▶ Required OSHA approved personal protective equipment is worn.
- ▶ Lock-out/Tag-out procedure is in place and followed.
- ▶ Process is completed in a timely manner.

Please use back side for additional notes

Operation Checklist

Level 1:	Performance standard:	
Given machine already set up, adjusted, with material ready, sand to the specified grit and thickness.	<input type="checkbox"/> Correct surface is sanded. <input type="checkbox"/> Proper incremental adjustment made on each pass to reach specified thickness. <input type="checkbox"/> Staggers loading to ensure entire width of belt and bed is used. <input type="checkbox"/> Demonstrates ability to monitor load meter.	<input type="checkbox"/> Pieces fed in correct direction with regard to grain. <input type="checkbox"/> Desired thickness within specified tolerance ± 0.1 mm [0.004"] side to side is achieved. <input type="checkbox"/> Inspects sanded parts for visible defects.

Level 2:	Performance standard:	
Given specifications, set up machine to sand to the specified feed speed, grit and thickness.	<input type="checkbox"/> Proper feed speed selected. <input type="checkbox"/> Sanding heads are set for correct stock removal (grit compensation) if utilizing multiple heads. <input type="checkbox"/> Proper abrasive grit installed.	<input type="checkbox"/> Multiple head machine started in proper sequence and time delay. <input type="checkbox"/> Meets Level 1 performance standard.