



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 $\pm 0.1$ 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.