



# GARDNER SCREW CORPORATION

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## Widebelt Sander Troubleshooting Guide

Problem	Probable Causes
<b>Belt Breaks</b>	<ol style="list-style-type: none"><li>1. Belts creased or damaged in handling.</li><li>2. Incorrect splice, or improperly made.</li><li>3. Backup roll misaligned or offset in wrong direction.</li><li>4. Belt tension too low—due usually to heavy grinding load on one side of belt.</li><li>5. Sanding load too high.</li><li>6. Shock load on belt, such as two sheets one on top of other.</li><li>7. Tramp metal in board.</li></ol>
<b>Belt Creases or Folds</b>	<ol style="list-style-type: none"><li>1. Belt cone-shaped—different in length from side to side. If crease angle is always in same direction, mount belt so directional arrow is running backward. If crease angle changes direction, belt is cone-shaped. If crease angle remains same, check for:<ol style="list-style-type: none"><li>2. Tapered contact roll. Redress to remove taper.</li><li>3. Contact roll and power roll not parallel.</li><li>4. Power roll worn—dumbbell shaped. Center portion where belts ride smaller in diameter than ends.</li><li>5. Belt tension too low.</li></ol></li></ol>
<b>Belt Runs Off Machine</b>	<ol style="list-style-type: none"><li>1. Damaged or fluttering edge of belt causes tracking malfunction.</li><li>2. Tracking mechanism not adjusted properly. Belt moves slowly in one direction, but fast in opposite direction.</li><li>3. Tapered contact roll. Redress to remove taper.</li><li>4. Belt tension too low.</li><li>5. Grinding load too high. (Usually accompanied by 4.)</li></ol>
<b>Belt Slips Under Load</b>	<ol style="list-style-type: none"><li>1. Belt tension too low.</li><li>2. Shock load on belt due to big variation in work thickness.</li><li>3. Plain steel rolls do not provide enough traction. Knurl or serrate roll surface.</li><li>4. Contact roll worn smooth or slick. Redress.</li></ol>
<b>Belt Life and Rate of Cut Inadequate</b>	<ol style="list-style-type: none"><li>1. Backup roll or conveyor belt worn unevenly (low in center), necessitating high grinding pressure to obtain full coverage of work. Check by using very light pressure. Full coverage of work should be obtained. Correct as required.</li><li>2. Contact roll tapered or not parallel with backup roll or conveyor belt. Grinding heavy on one side of belt.</li><li>3. Dust collection inadequate or restricted.</li><li>4. Backup roll misaligned or not parallel with contact roll.</li><li>5. Use coarser grit size.</li><li>6. Belt commodity not well suited to material being sanded or operating conditions.</li><li>7. Improper storage conditions for belts.</li></ol>
<b>Chatter Marks on Work</b>	<ol style="list-style-type: none"><li>1. Check for out-of-round, out-of-balance, or worn bearing conditions in some rotating member of machine, or the splice; also check machine parts that oscillate, such as tracking mechanism. More common causes are contact roll, power roll drive motor, stiff splice in drive belts, coolant pump.</li></ol>
<b>Wild or Deep Random Scratches in Finish</b>	<ol style="list-style-type: none"><li>1. Carryover of swarf between adjacent heads. Check dust collector.</li><li>2. Loading or glazing of abrasive.</li></ol>
<b>Streaks in Finish</b>	<ol style="list-style-type: none"><li>1. Contact roll or platen wear caused by running various widths of stock without redressing.</li><li>2. Damaged or scuffed abrasive surface on belt.</li><li>3. Damaged face of contact roll or platen.</li></ol>