

The 18-inch wide belt is a continuous speed sander for sanding the SURFACE (Face) of solid wood to a uniform thickness while smoothing out the UPPER SURFACE. Used for sanding clean - dry wood - **ONLY**.

	Bullet Point	Explain & Demonstrate
COMPONENTS Naming components now will ensure greater understanding of	SAFETY SWITCH [Breaker]	UP = Power On. Down = Power OFF.
	CONTROL PANEL	DIGITAL READOUT. Numerical Key Pad. 1 through 0. Power Light. EMERGENCY STOP BUTTON. EMERGENCY STOP THIGH PLATE. Enter [Set] key. Push button to raise table 0.005-inch. Table Raise button - Table lower button. Belt feed START button. Belt feed STOP button. STARTS abrasive pad.
	EMERGENCY STOP BUMP BAR.	Push plate or bump with thigh. Belt feed STOPS & power shuts OFF immediately.
	AMP METER [Measures workload]	Three zones: 15 amps = Safe load. 28 amps = Caution. Abrasive & Belt are under undue stress. 30 amps = Danger. STOP. Lower Belt feed. Remove workpiece.
	TABLE	Rubber belt. Never place fingers between belt & workpiece. Measure workpiece with calipers. Table height handwheel is only set [calibrated] by maintenance.
	SANDING BELT [Abrasive]	80-grit. Continuous speed. Set by maintenance ONLY .
	DUST PORT	Always OPEN.
ACCESSORIES	Under board" for sanding workpieces less than the default thickness'. Used often for making thin strips. Do not insert strips horizontal to the Sanding Belt. This will jam the belt. Secure workpiece with two-sided tape.	
SAFETY	Secure the area. Concentrate on the task at hand. No distractions. Develop a 'flow'. Set height, place workpiece, receive back from Monitor - on a cart. Raise table 0.005 (Enter). Repeat. Start by testing Emergency Bump Bar operation. Monitor Amp Meter for excessive current loads.	
Plan. Prepare. Measure. Mark.	Zero" calipers. {Inches or millimeters?}. Ask-For-Help. Monitors are available to 'catch' workpieces. Repeat process until thickness is achieved.	

Teaching Steps	Teaching Steps	Use calipers. ZERO {inches}. Mark workpiece measurements on EDGE or END. Squiggly pencil line on SURFACE. Set Table higher than the measured thickness - PLUS 1/8-inch. Turn on Table, run workpiece through to check for any resistance. Turn on Sanding belt.
	PARTICIPANTS	
	REVIEW LESSON HIGHLIGHTS	Enter measurements - Use calipers to measure thickest points of workpiece. Flip workpiece. Make multiple, incremental passes. Do not get fingers between workpiece and feed belt. If Amp Meter goes over 30 amps STOP, lower feed belt. If sander stops on its own, get maintenance. Always start by reviewing the SMART CHART . Use an "UNDER BOARD" Sands to 80-grit. Use hand sanders (Downdraft table) for final sanding.
	GLUE	Tight-Bond Glue takes a minimum of one-hour to SET and takes 12-hours to compeley DRY & BOND completely. Use a rag to clean glue at glue up. Scrape off excess glue before using on any shop equipment.
	RESTRICTIONS	Do not use the following on this Equipment: Wood that has been sealed - Paint / Varnish. Wood that has been in contact with the ground. Epoxy or Risen. Hand sand outside. Manufactured products - MDF / Plywood / Particle board. Pine. Pitch fills pores on sanding cloth. Glued up workpieces that have not been cured for 12-hours.