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JAPANESE INDUSTRIAL STANDARD

Drum sanders — Test and inspection methods

JIS B 6545—1991

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In the event of any doubt arising,
the original Standard in Japanese is to be final authority.



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Drum sanders - Test and inspection methods

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1. Scope

This Japanese Industrial Standard specifies the test methods relating to the functions, running performances and rigidities, and to the accuracy and machining accuracy inspection methods of the drum sanders of which effective lengths⁽¹⁾ of drums are 1100 mm or over to 2000 mm or under.

Note (1) The maximum width of grindable workpieces.

Remarks 1. The drum sander means the machine which grinds the surfaces of plywood and the like being fed automatically by the abrasive cloths and paper which are wound around the outer peripheral faces of rotating drums. Mostly the machine consists of two pieces of drum or more (see JIS B 0114).

2. The applicable standards to this Standard are as given in the following:

JIS B 0114-Glossary of Terms for Wood Working Machinery.

JIS B 0905-Balance Quality Requirements of Rigid Rotors

JIS B 6507-General Code of Safety for Wood Working Machinery.

JIS B 6521-Methods of Measurement for Noise Emitted by Wood Working Machinery.

JIS R 6251-Abrasive Cloths

JIS R 6252-Abrasive Papers

3. The units and numerical values given in { } in this Standard are in accordance with the traditional units, and are appended for informative reference.

2. Function test methods

The functional tests of drum sanders shall be in accordance with Table 1.

Table 1. Function test

No.	Test items	Test method
1	Electric equipments	Before and after the running test, examine insulating conditions once each.
2	Start, stop and running operation of drum	Carry out 10 times start and stop repeatedly at an appropriate rotational speed of the drum to examine the smoothness and reliability of actions.
3	Changing operation of rotational speeds of drum	Change rotational speed of the drum on overall rotational speeds of marking to examine the smoothness of actions and reliability of indications of the operating device.
4	Start, stop and running operation of feed device	At an appropriate feed speed, carry out start and stop 10 times repeatedly to examine the smoothness and reliability of actions.
5	Changing operation of feed speeds	Change speed on overall feed speeds of marking; and for the variable speed type, change speed on three feed speeds, lowest, intermediate and highest feed speeds to examine the smoothness of actions and the reliability of indications of the operating device.
6	Operations of up and down and clamping of table	Raise and lower the table to examine the smoothness and uniformity of actions thoroughly. For the center and both ends of the motion, examine the reliability of clamping and the smoothness of actions of the clamping device.
7	Cross slide of drum	Raise and lower the drum to examine the smoothness of actions and reliability of indications thoroughly.
8	Attaching and detaching of abrasive paper and cloth	Examine the smoothness and reliability of attaching and detaching of abrasive paper and cloth.
9	Brushing device	Examine the smoothness and reliability of the function.
10	Safety device	Examine the reliability of the safety function for workers and protective function for machine (see JIS B 6507).
11	Lubricating device	Examine the reliability of the functions such as oil-tightness, proper distribution of the oil quantity.
12	Accessory device	Examine the reliability of the functions.

Remarks: For the drum sanders which are not provided with the said functions, the corresponding test items to these in Table 1 may be omitted.