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JAPANESE INDUSTRIAL STANDARD

**Wide belt sanders —
Test and inspection methods**

JIS B 6546—1991

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In the event of any doubt arising,
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Wide belt sanders - Test and inspection
methods

B 6546-1991

1. Scope

This Japanese Industrial Standard specifies the test methods relating to the functions, running performances and rigidities, and accuracies and machining accuracy inspection methods for the wide belt sanders of 300 mm or over to 2000 mm or under in effective length⁽¹⁾ of the driving rolls.

Note (1) The maximum width of grindable workpieces.

Remarks 1. The wide belt sander means the machine which grinds the surfaces of automatically fed ply wood and the like by means of a sheet of endless abrasive cloth or paper which has been laid on two or more rotating drum pulleys over their total length. There are also machines which have been assembled of two or more sets.
(See JIS B 0114)

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

JIS B 0114 Glossary of terms for wood working machinery

JIS B 0905 Balance quality of requirements rigid rotors

JIS B 6507 General code of safety for wood working machinery 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. Units and numerical values given in { } in this Standard are in accordance with the traditional units, and are appended for informative reference.

2. Functional test methods

The functional tests of the wide belt sanders shall be in accordance with Table 1.

Table 1. Functional tests

No.	Test item	Test method
1	Electrical equipment	Before and after the running test, examine the insulation conditions once each.
2	Start, stop and running operation of driving roll	Attach abrasive cloth or paper, carry out 10 times start and stop repeatedly at an appropriate rotational speed of the driving roll to examine the smoothness and reliability of actions.
3	Changing operation of rotational speed of driving roll	Change rotational speed of the driving roll 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 10 times of start and stop repeatedly to examine the smoothness and reliability of actions.
5	Changing operation of feed speed	Change speeds on overall marked speeds; and for the variable speed type, change speed on three feed speeds, the minimum, intermediate and maximum to examine the smoothness of actions and the reliability of indications of the operating device.
6	Operations of raising and lowering and clamping of table	Raise and lower the table to examine the smoothness and uniformity of actions of table, thoroughly. For the center and both ends of the movement, examine the reliability of clamping and the smoothness of actions of the clamping device.
7	In feed device of driving roll	Raise and lower the driving roll to examine the smoothness of actions and the reliability of indications thoroughly.
8	Attaching and detaching of abrasive cloth or paper	Examine the smoothness and reliability of the attaching and detaching of abrasive cloth or paper.
9	Beam supporting device	Examine the smoothness and reliability of the function.
10	Platen or pad attaching device	Examine the smoothness and reliability of the function.
11	Pressure roll device	Examine the smoothness and reliability of the function. ,

Table 1 (Continued)

No.	Test item	Test method
12	Brushing device	Examine the smoothness and reliability of the function.
13	Belt cleaning device	Examine the smoothness and reliability of the function.
14	Safety device	Examine the reliability of the safety function for workers and protective function for machine (See JIS B 6507).
15	Lubrication device	Examine the reliability of the function such as oiltightness and proper distribution of oil quantity.
16	Pneumatic device	Examine the reliability of the function such as airtightness and pressure regulation.
17	Accessory equipments	Examine the reliability of the function.

Remarks: For the wide belt sanders which are not provided with the said function, the test items corresponding to those in Table 1 shall be omitted.

3. Running test methods

3.1 No-load running test Rotate the driving roll, continue running for 30 to 60 minutes, measure the required electric power and noise after the bearing temperatures have been stabilized, and record on respective items specified in the recording Format 1 of Table 2 and check for abnormal vibration by touch.

Furthermore, the measurement of the noise shall be in accordance with JIS B 6521.