GARDNER SCREW CORPORATION

Screw Machine Products • Furniture Hardware • Metal Fasteners & Stamping • Industrial Supplies

Serving Industry Since 1923

Sanding Room Supplies

Carborundum Pump Sleeves
Resin Bond Garnet

Drum Size	*Sleeve Size*
3" x 9"	9" x 10-5/8"
4" x 9"	9" x13-3/4"
6" x 9"	9" x 20"
8" x 9"	9" x 26-5/16"

- ***Pneumatic Drums***
- ***Rubber Tubes***
- ***Bump-Free Canvas Sleeves***
- ***Famowood Wood Filler***
- ***Famosolvent***

- ***Standard Graphite Cloth***
- ***#303 Graphite HD Cloth***
- ***Graphite Coated Mitts***
- ***Abrasive Cleaning Sticks***
- ***Lubrifilm Graphite Sticks***

Stocking All Grits

9" x 11" Sheets

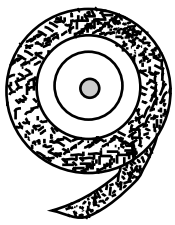
Stocking The Following Portable Belts:

3" x 21"	4" x 21
3" x 24"	4" x 21-3/4"
	4" x 24"

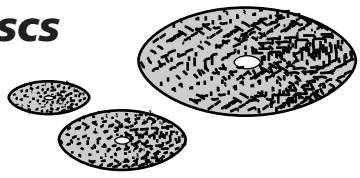
Stocking the Following Wide Belts:

24" x 51"	42" x 98"
25" x 48"	42" x 101"
25" x 60"	43" x 75"
25" x 75"	50" x 98"
36" x 75"	50" x 103"
37" x 60"	52" x 75"

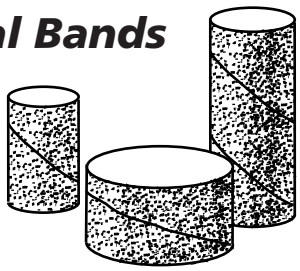
Sheets & Rolls



Discs



Spiral Bands



We would be pleased to quote and stock your specific abrasive requirement.

220 Union Street, Gardner, MA 01440-0862 • Telephone (978) 632-0850 • Fax (978) 632-4606 • Email: GardScrew@aol.com

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Widebelt Sander Troubleshooting Guide

Problem	Probable Causes
Belt Breaks	1. Belts creased or damaged in handling. 2. Incorrect splice, or improperly made. 3. Backup roll misaligned or offset in wrong direction. 4. Belt tension too low—due usually to heavy grinding load on one side of belt. 5. Sanding load too high. 6. Shock load on belt, such as two sheets one on top of other. 7. Tramp metal in board.
Belt Creases or Folds	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: 2. Tapered contact roll. Redress to remove taper. 3. Contact roll and power roll not parallel. 4. Power roll worn—dumbbell shaped. Center portion where belts ride smaller in diameter than ends. 5. Belt tension too low.
Belt Runs Off Machine	1. Damaged or fluttering edge of belt causes tracking malfunction. 2. Tracking mechanism not adjusted properly. Belt moves slowly in one direction, but fast in opposite direction. 3. Tapered contact roll. Redress to remove taper. 4. Belt tension too low. 5. Grinding load too high. (Usually accompanied by 4.)
Belt Slips Under Load	1. Belt tension too low. 2. Shock load on belt due to big variation in work thickness. 3. Plain steel rolls do not provide enough traction. Knurl or serrate roll surface. 4. Contact roll worn smooth or slick. Redress.
Belt Life and Rate of Cut Inadequate	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. 2. Contact roll tapered or not parallel with backup roll or conveyor belt. Grinding heavy on one side of belt. 3. Dust collection inadequate or restricted. 4. Backup roll misaligned or not parallel with contact roll. 5. Use coarser grit size. 6. Belt commodity not well suited to material being sanded or operating conditions. 7. Improper storage conditions for belts.
Chatter Marks on Work	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.
Wild or Deep Random Scratches in Finish	1. Carryover of swarf between adjacent heads. Check dust collector. 2. Loading or glazing of abrasive.
Streaks in Finish	1. Contact roll or platen wear caused by running various widths of stock without redressing. 2. Damaged or scuffed abrasive surface on belt. 3. Damaged face of contact roll or platen.

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How to read a Coated Abrasive Specification

A coated abrasive product is made up of three basic raw materials: (1) an abrasive mineral, (2) the backing onto which the abrasive is applied, and (3) an adhesive bond.
The Carborundum Abrasives coated abrasive marking system includes both a generic and a technical marking.

The generic markings identify the abrasive type, bond, backing, and any special features and/or tradenames. An example would be "Premier Red Aluminum Oxide Dri-Lube Resin Paper Open."
The technical markings identify the actual components which make up the product. Technical markings consist of up to 10 parts. An example would be "P400 B 0912 DO." The following terminology explains the technical marking system.

Coated Abrasive Terminology Key

P	60	Y	C		09	8	6	A	0
GRADING	**GRIT SIZE**	**BACKING WEIGHT**	**CLOTH TYPE**	**BACKING FLEXIBILITY**	**MINERAL (ABRASIVE)**	**BACKING**	**BOND**	**PERFORMANCE**	**COATING**
P FEPA _ ANSI/CAMI	12 ↕ 2000 CRS MED FIN MICRON	PAPER: A B C D E F CLOTH: J X Y M MESH V FIBRE	B POLY/ COTTON BLEND C COTTON P POLYESTER	F FLEXIBLE _ STANDARD S STIFF	01 CROCUS 02 EMERY 03 GARNET 04 S/C 07 LBA 08 A/O 09 HT A/0 HEAT TREATED 11 ZA 12 ZA PREMIUM 25 SG	0 MESH 1 PAPER 4 FIBRE CLOTH: 5 MOST ↕ FLEXIBLE 8 LEAST FLEXIBLE	0 GLUE 1 U/G 2 U/U FULL RESIN: 4 LEAST ↕ DURABLE 7 MOST DURABLE	A ANTI-STATIC D DRI-LUBE OVERSIZE R REACTIVE OVERSIZE W WASHABLE OR WATERPROOF	O OPEN COAT _ CLOSED COAT

Abrasive Types

01 Crocus

Iron oxide (crocus) is a very soft, natural abrasive which is red in color.

- for fine polishing soft metals such as gold

02 Emery

Emery is a dark gray, round-shaped grain which tends to polish rather than abrade a work surface.

- for polishing and cleaning metal only

03 Garnet

Garnet is reddish brown in color. This natural abrasive is medium hard and relatively sharp, but not as durable as synthetic abrasives.

- for use on wood only
- particularly good for soft woods such as pine
- produces an excellent finish

04 S/C Silicone Carbide

Silicon carbide is the hardest and sharpest of the manufactured abrasives. Because of its extreme sharpness, this bluish-black abrasive grain permits fast stock removal and cool cut.

- cast iron
- non-ferrous metals, i.e. brass, aluminum and bronze
- non-metallics, i.e. glass, rubber, plastic and stone
- final finish on wood and stainless steel
- abrasive planing particleboard

07 LBA Light Brown Aluminum Oxide

Light brown aluminum oxide is a tough, yet sharp, synthetic abrasive characterized by cool cut, long life, and the ability to break down under pressure producing new cutting edges.

- production wood sanding
- non-ferrous metal finishing

08 A/O Brown Aluminum Oxide

Brown aluminum oxide is a tough, durable, synthetic abrasive characterized by the long life and wear resistance if its cutting edges. It offers enormous penetrating strength, even at high speeds.

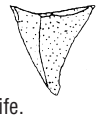
- ferrous metals
- aluminum
- hardwood

11 ZA, 12 ZA Zirconia Alumina

Zirconia alumina is an ultra-tough, synthetic abrasive which provides a free, cool cut for high stock removal applications. It is tougher and sharper than aluminum oxide. It has a micro-crystalline structure which allows for controlled breakdown and self-sharpening.

- heavy duty snagging and grinding all ferrous and non-ferrous metals
- abrasive planing of wood, plywood, particleboard
- grinding fibreglass, rubber and plastics

25 SG Ceramic Alumina



The sub-micron structure of ceramic alumina allows each grain to continually expose sharp cutting points, resulting in a cooler cutting action and an extended life.

- all ferrous and non-ferrous metals, carbon steel, and exotic alloys

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