

KALAMAZOO **INDUSTRIES, INC.**

S660MW Wet Belt Sander — Maintenance Checklist

Machine: Kalamazoo Industries S660MW (6" x 60" wet belt sander)

Location/Asset ID: _____

Serial #: _____

Maintainer: _____

Supervisor sign-off: _____

How to Use This Checklist

- Work through the intervals in order (Pre-Start → End-of-Shift → Weekly → Monthly → Quarterly → Semiannual/Annual).
- Initial and date each item when complete. Use the Result and Initials/Date fields; record any corrective actions in your maintenance log.
- Always perform LOTO before removing guards, changing belts, or servicing electrics/coolant.

Safety Essentials

- Eye/face protection, gloves off near the moving belt, no loose clothing/hair.
- Keep guards installed; let the machine come to a full stop before belt changes.
- Use only coolant with a rust inhibitor. Never run straight water.

Pre-Start (Each Use / Each Shift)

#	Task	Criteria / How to Verify	Result	Initials/Date
1	LOTO cleared, area clean & dry; no leaks around tank/hoses/pump.	Visual check of floor, under base, hose joints.	☐ Pass ☐ Needs Attn	
2	Coolant level & concentration are correct.	Level above pickup; refractometer ____ % per supplier.	☐ Pass ☐ Needs Attn	
3	Nozzle aimed and steady flow at grind zone.	Open valve; observe continuous flood before grinding.	☐ Pass ☐ Needs Attn	
4	Belt condition acceptable (no tears/fray/glazing).	Inspect edges/splice; replace if damaged or loaded.	☐ Pass ☐ Needs Attn	

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#	Task	Criteria / How to Verify	Result	Initials/Date
5	Belt tracks centered on platen.	Jog ON/OFF; adjust tracking knob until centered.	☐ Pass ☐ Needs Attn	
6	Platen face flat and smooth.	Straightedge check; rotate/flip if grooved.	☐ Pass ☐ Needs Attn	
7	Table locks tight; ~1/8" clearance; miter slot clear.	Set gap; verify tilt/height locks hold.	☐ Pass ☐ Needs Attn	
8	Guards installed; magnetic starter Start/Stop operates.	Cycle Start/Stop; confirm firm contactor action.	☐ Pass ☐ Needs Attn	
9	No abnormal motor/bearing noise or vibration.	Listen on start; if abnormal, stop and investigate.	☐ Pass ☐ Needs Attn	

End-of-Shift (Daily)

#	Task	Criteria / How to Verify	Result	Initials/Date
10	Release belt tension for idle periods.	Tension lever lifted; belt slack.	☐ Pass ☐ Needs Attn	
11	Rinse/wipe splash panels, platen, table, belt cover.	Surfaces free of swarf/slurry.	☐ Pass ☐ Needs Attn	
12	Blow off motor housing and enclosure exterior (dry areas only).	Light dust only; no coolant on electrics.	☐ Pass ☐ Needs Attn	
13	Check for drips under machine.	No new spots under base or fittings.	☐ Pass ☐ Needs Attn	

Weekly (or every 40 hours)

#	Task	Criteria / How to Verify	Result	Initials/Date
14	V-belt drive wear/ tension OK.	Inspect glazing/cracks; re-tension if squeal.	☐ Pass ☐ Needs Attn	
15	Tracking system free and smooth.	Tracking knob turns freely; idler spindle moves without bind.	☐ Pass ☐ Needs Attn	
16	Upper pulley/yoke square to platen.	If constant correction is needed, square/adjust yoke.	☐ Pass ☐ Needs Attn	
17	Hoses/clamps sound.	Tighten clamps; replace cracked/damp lines.	☐ Pass ☐ Needs Attn	
18	Frame/table/platen fasteners snug.	Torque to spec; no looseness.	☐ Pass ☐ Needs Attn	
19	Electrical enclosure protected.	Exterior clean/dry; door gasket seals; no ingress.	☐ Pass ☐ Needs Attn	

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Monthly

#	Task	Criteria / How to Verify	Result	Initials/Date
20	Coolant tank service / quality.	Drain/clean/refill if dirty; otherwise sample & top off per guidance.	☐ Pass ☐ Needs Attn	
21	Pickup screen/strainer clean; pump primed.	Inspect/clean; verify solid flow at nozzle.	☐ Pass ☐ Needs Attn	
22	Pump motor condition.	Check temperature; listen for noise.	☐ Pass ☐ Needs Attn	
23	Platen rotated/flipped or replaced if worn.	Replace if below service limit or deeply grooved.	☐ Pass ☐ Needs Attn	
24	Idler/drive bearings smooth.	Spin-check for roughness/play; plan replacement if needed.	☐ Pass ☐ Needs Attn	
25	Switchgear functions correctly.	Test magnetic starter and overloads; verify Start/Stop.	☐ Pass ☐ Needs Attn	

Quarterly

#	Task	Criteria / How to Verify	Result	Initials/Date
26	Drive & idler pulleys clean; crown OK.	Remove guards; clean debris; inspect crown wear.	☐ Pass ☐ Needs Attn	
27	Yoke spring & tension lever operate smoothly (no lubrication required).	Cycle lever; confirm full travel and return.	☐ Pass ☐ Needs Attn	
28	Table flatness/squareness to belt.	Check with square/straightedge; adjust stops.	☐ Pass ☐ Needs Attn	
29	Grounding and cord strain reliefs intact.	Test GFCI where used; inspect cords/clamps.	☐ Pass ☐ Needs Attn	

Semiannual / Annual

#	Task	Criteria / How to Verify	Result	Initials/Date
30	Replace V-belts as needed; align pulleys.	Inspect for cracking/set-in; replace as a set; check alignment.	☐ Pass ☐ Needs Attn	
31	Replace aged coolant lines & clamps.	Lines supple; clamps tight; no seepage.	☐ Pass ☐ Needs Attn	
32	Replace rough/noisy bearings.	No roughness/play after replacement; collars secured.	☐ Pass ☐ Needs Attn	
33	Touch up coatings to prevent corrosion.	Bare metal sealed; finish intact.	☐ Pass ☐ Needs Attn	

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Belt Change & Tracking (Quick Procedure)

- LOTO → remove guard.
- Lift tension lever to release; remove belt.
- Install new belt (arrow direction correct).
- Lower lever to tension.
- Jog start/stop to verify tracking; use tracking knob to center belt on platen (small adjustments).
- Re-fit guard and run up to speed; re-check tracking.

Tracking Troubleshooting Notes

- Belt walks: check drive pulley crown, belt splice squareness, and that upper pulley/yoke is squared to platen.
- Excess edge wear: reduce tracking knob pressure and confirm belt is centered before load.

Coolant System (Wet Operation)

- Use only a rust-inhibited metalworking coolant suitable for abrasive belts.
- Maintain manufacturer-recommended concentration; test regularly.
- Keep nozzle aimed at the grind zone; ensure a steady flood before contacting the belt.
- Never run the pump dry. Prime after tank service.
- Clean tank and pickup routinely to protect the pump and finish quality.
- Tank service log — Date _____ Cleaned by _____ Concentration ____% Notes

Acceptance Test After Service

- Smooth start, no abnormal vibration/noise.
- Belt tracks centered at speed, no edge rubbing.
- Coolant flow steady at nozzle; no leaks.
- Start/Stop via magnetic starter works correctly.
- Scrap test piece shows expected finish; no burning.