

GALLANT MANUFACTURING (2010)

HEAVY DUTY, MULTI-PURPOSE

GRINDERS SANDERS BUFFERS POLISHERS

REPAIRS & RE-CONDITIONING ABRASIVES CUSTOM SOLUTIONS

Owner's Manual

ROTOBELT

Model #1 thru #7

MANUFACTURERS
OF
ROTOBELT®
MADE IN CANADA

Phone: 604-253-1212 | Fax: 604-859-9931 | Email: info@gallantmanufacturing.com

Website: www.gallantmanufacturing.com

TABLE OF CONTENTS

CONTENT	PAGE
Set Up and Warranty	3
Safety Procedures if Equipped for Belt Sanding	4
Belt Installation, Belt Tracking and Maintenance	5
Trouble Shooting for Belt Sanding Operations	6
Safety Procedures if Equipped for Grinding	7
Grinding Wheel Installation and Trouble Shooting for Grinding Operations	8
Safety Procedures if Equipped for Polishing and Polishing Attachment Installation	9
Part Numbers and Descriptions	10
Part Numbers and Descriptions (continued)	11
Common Replacement Parts (PHOTOS)	12

SET UP OF YOUR NEW ROTOBELT MACHINE:

Immediately upon receipt of your RROBELT machine, unpack and inspect for any possible freight damage. If you suspect any damage contact the carrier immediately.

Location of your machine should allow for rear access to change the abrasive belts, if it is MODEL # 1,3,4,6, or 7.

Level and anchor the machine to the floor with 1/2 inch bolts.

Wiring of this machine should be performed by a certified electrician. Check the name plate on the front of the machine to determine that your power requirements match. Have your electrician check your power source for "VOLTAGE DROP", as a lower voltage will cause lack of power when operating the machine.

Abrasive belt and contact wheel rotation must be counter clockwise when facing the right hand side of the machine, if not consult you electrician.

WARRANTY:

Your machine has a 5 year parts and labour warranty against manufacturer's defect. This warranty is null and void due to the following:

- Damage due to shipping.
- Normal wear due to use.
- Operator error that damage parts.
- Failure to follow set up procedure.

IF YOUR MACHINE IS EQUIPPED FOR BELT SANDING READ THE FOLLOWING

DUE DILIGENCE:

Before anyone operates this or any other equipment it is the responsibility of the supervisor to instruct the operator or operators on its safe operation.

Below are some standard safe operating procedures.

OPERATING SAFETY:

- Persons using the rotobelt machine must be thoroughly trained in its operation, as it is impossible to guard the operation completely.
- Remove any tools or parts you are working with that may get in the way.
- Remove any flammable objects from the work envelope.
- NEVER operate without guards in place
- Only use the correct sized belts.
- When operating this machine, always wear adequate eye protection, tight fitting gloves and clothing.
- Tie long hair back so it will not get it caught in any moving parts.
- Check sanding belt for damage prior to start up.
- On initial start up stand to the side, also stand to the side if possible when performing your job.
- NEVER work above the equator/centre of the wheel.
- When working on small parts always use a tool such as vice grips to hold work piece securely.
- Let wheel stop naturally, do not apply pressure to stop wheel.
- NEVER operate under the influence of drugs or alcohol.
- LOCKOUT machine when changing belts or doing any type of maintenance.

BELT INSTALLATION:

1. Pull tension lever toward the front of the machine, this will loosen the rear idler pulley.
2. Slide belt around the back of the sanding arm then around the front of the sanding arm.
3. Centre belt on the contact wheel and idler pulley.
4. Slowly release the tension lever back to its original place and lock.
5. Perform tracking operations.

NOTE: The guard DOES NOT need to be removed for installing or changing belts.

BELT TRACKING:

To track the belt, move the lever on the end of the idler pulley axle slowly by hand, either forward or back ward while machine is running. The tracking lever should move with only a small amount of force and stay in position after the operator has tracked the belt. The lever only needs to be moved a small amount for tracking to happen.

MAINTENANCE:

The abrasive dust build up should be blown off the contact wheel and idler pulley. We recommend doing this twice a week under heavy use.

The bearings used on this machine are sealed, and do not require lubrication.

The four V-Belts should be checked monthly for proper tension. To do this remove the motor cover door in the front of the machine by pulling straight up on the door handle. Adjust belt tension with the threaded tension rod as necessary and lock with the jam nut.

TROUBLE SHOOTING:

PROBLEM:

- **Abrasive belt does not track properly.**

SOLUTION:

1. Install new idler pulley.
2. Remove idler pulley and sent to our facility for re-conditioning.
3. Check the edges of the contact wheel if they have a large radius this will cause incorrect tracking.
4. Replace contact wheel.
5. Remove contact wheel and send to our facility for re-covering.

PROBLEM:

- **Excessive vibration**

SOLUTION:

1. Check for abrasive dust build up on the contact or idler pulleys.
2. If there is dust build up remove using compressed air.
3. Check contact wheel for damage.
4. Adjust belt tension.

IF YOUR MACHINE IS EQUIPPED WITH A GRINDING WHEEL READ THE FOLLOWING

DUE DILIGENCE:

Before anyone operates this or any other equipment it is the responsibility of the supervisor to instruct the operator or operators on its safe operation.

Below are some standard safe operating procedures.

OPERATING SAFETY:

- Persons using the rotobelt machine must be thoroughly trained in its operation, as it is impossible to guard the operation completely.
- Remove any tools or parts you are working with that may get in the way.
- Remove any flammable objects from the work envelope.
- NEVER operate without guards in place
- Only use the correctly rated grinding wheels.
- When operating this machine, always wear adequate eye protection, tight fitting gloves and clothing.
- Tie long hair back so it will not get caught in any moving parts.
- Check wheel for damage prior to start up.
- On initial start up stand to the side, also stand to the side if possible when performing your job.
- NEVER work above the equator/centre of the wheel.
- NEVER grind on the side of the grinding wheel.
- When working on small parts always use a tool such as vice grips to hold work piece securely.
- The tool rest should always be secure and never be more than 1/8 of an inch away from the grinding wheel.
- Let wheel stop naturally, do not apply pressure to stop wheel.
- NEVER operate under the influence of drugs or alcohol.
- LOCKOUT machine when changing wheels or doing any type of maintenance.

GRINDING WHEEL INSTALLATION:

1. Check wheel for cracks or any other damage.
2. Remove safety guard cover for access.
3. Install new grinding stone and replace safety guard cover securely.
4. Re-adjust the tool rest 1/8 of an inch from the grinding wheel.

NOTE: The right side of the machine has RH threads and the left side has LH threads.

TROUBLE SHOOTING:**PROBLEM:**

- Excessive vibration

SOLUTION:

1. Grinding wheel may be out of round.
2. Replace or re-dress the wheel.

IF YOUR MACHINE IS EQUIPPED WITH A POLISHING ATTACHMENT READ THE FOLLOWING

DUE DILIGENCE:

Before anyone operates this or any other equipment it is the responsibility of the supervisor to instruct the operator or operators on its safe operation.

Below are some standard safe operating procedures.

OPERATING SAFETY:

- Persons using the rotobelt machine must be thoroughly trained in its operation, as it is impossible to guard the operation completely.
- Remove any tools or parts you are working with that may get in the way.
- Only use the correctly sized buffing wheels.
- When operating this machine, always wear adequate eye protection, tight fitting gloves and clothing.
- Tie long hair back so it will not get it caught in any moving parts.
- Check buffing wheel for damage prior to start up.
- On initial start up stand to the side, also stand to the side if possible when performing your job.
- NEVER work above the equator/centre of the wheel.
- When working on small parts always use a tool such as vice grips to hold work piece securely.
- Let wheel stop naturally, do not apply pressure to stop wheel.
- NEVER operate under the influence of drugs or alcohol.
- LOCKOUT machine when changing wheels or doing any type of maintenance.

POLISHING ATTACHMENT INSTALLATION:

1. Apply a light film of grease to the main drive shaft threads before installing polishing attachment.
2. Align the polishing attachment with the main drive shaft and screw on hand tight to the aluminum inner collar.
3. Insert a punch or steel rod into the half inch hole in the attachment. With a hammer give the rod a light tap to seat the attachment to the aluminum collar.
4. To remove the polishing attachment secure the opposite end you are removing and repeat in reverse step #3 above.

NOTE: The right side of the machine has RH threads and the left side has LH threads.

WARNING!

Diameter of the puffing wheel should not exceed 14 inches.

PARTS LIST

Part #	Description
P-10	Pedestal
P-11	Main Shaft Housing
P-12	Main Shaft
P-13	Main Shaft Bearings
P-14	Bearing Retaining Ring
P-15	Door Grab Handle
P-16	Water Pan
E-10-7.5	Motor Mount 7.5 HP
E-11-10	Motor Mount 10 HP
P-17	Motor Tension Bracket
P-18	V-Belt 3VX670
P-19	Motor Sheave 4GR3V 3.65
P-20	Motor Sheave Bushing 1-3/8"
E-12	Motor 7.5 HP
E-13	Motor 10 HP
E-14	Heater Element
E-15	Non Reversing Starter
E-16	Coil
E-17	Switch Plate
E-18	Legend Plates Start
E-19	Legend Plate Stop
E-20	Start Button
E-21	Stop Button
P-21	Inner Collar
S-10	14' x 4" Contact Wheel
P-22	Outer Collar
P-22 RH or LH	Main Shaft Nuts (x1)
S-11	Stem Ring
S-12 RH or LH	Belt Sanding Tube (44" long)
S-13 RH or LH	Belt Tension Lever
S-14	Tension Spring
S-15	O Ring
S-16	Sliding Pin
S-17	Alum Idler Axle
S-18	Alum Idler Pulley
S-19	Alum Idler Bearing Spacer

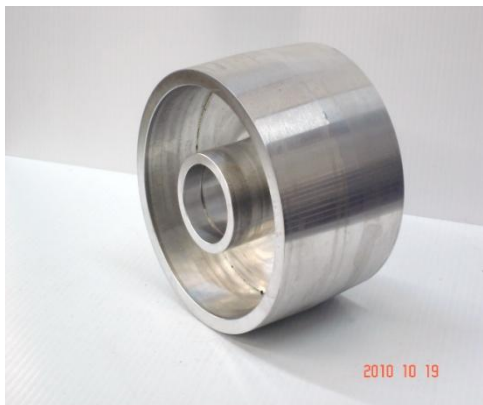
PARTS LIST CON'T

Part #	Description
S-21	Alum Idler Retaining Rings
S-22	1" Nylock Nut
S-23 RH or LH	Belt Guard
S-24 RH or LH	Platen Assembly
S-25 RH or LH	Platen Guard
S-26	Graphite Pads 4" x 26 3/4"
G-10	Grind Wheel Guard
G-11	Grind Side Eye Guard
G-12	Grind Side Tool Rest
B-10	Polishing Extension

COMMON REPLACEMENT PARTS



Part# S-10 14"x 4" Contact Wheel



Part # S-18 Aluminum Idler Pulley



Part# S-17 Idler Axle