

Conveyor Belt Replacement Guide



Thank you for purchasing a new conveyor belt from Oliver. Please follow the instructions below to replace the conveyor belt and recalibrate the machine.

Important: When replacing the conveyor belt with a belt of a different thickness, you must readjust the sanding belt minimum-height positive stop, extension table, and DRO.

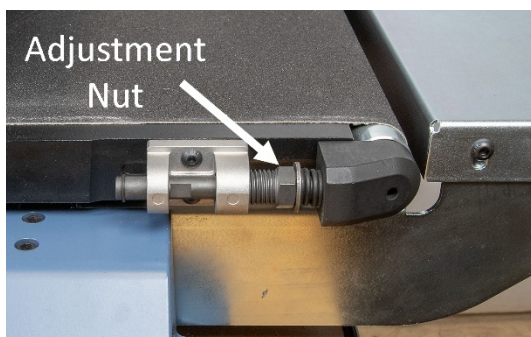
Failure to make these adjustments may damage the replacement conveyor belt and the workpiece.

1. Disconnect the machine from power.

2. Locate the belt-tension adjusters on each side of the conveyor belt. The tensioner is spring-loaded.



3. Using a 17 mm wrench, rotate the nut to decompress the conveyor belt tensioner spring until the conveyor belt can be removed from the rollers.

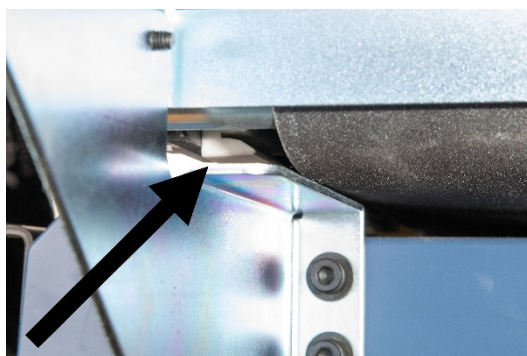


4. If the sander is equipped with a PVC conveyor belt, skip to Step 7.

5. Remove the conveyor belt guide.



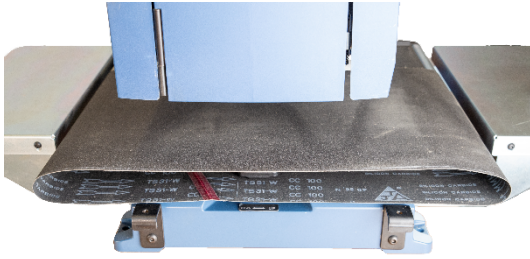
6. Slide the conveyor belt toward the inboard side of the table. This creates enough clearance to remove the ceramic guide located underneath the table.



7. Remove the stem that holds down the outboard side of the conveyor belt table.



8. Cover the adjustment knob with masking tape to protect it from scratches caused by the conveyor belt. Then, lift the table slightly and pull out the conveyor belt.



9. Install the new conveyor belt. Some conveyor belts are directional and have the running direction printed on the back of the belt. If the belt is directional, install it according to the indicated running direction.
10. Be careful not to catch the conveyor belt on the extension table brackets, as this can damage the edge of the belt.
11. When installing an abrasive conveyor belt, ensure that both edges of the conveyor belt are positioned inside the ceramic guides.
12. When installing a PVC conveyor belt, remove the ceramic guides.



13. Re-tension the conveyor belt. To increase belt tension, use a 17 mm wrench to rotate the nut and compress the conveyor belt tensioner spring.
14. Do not over-tension the conveyor belt. Excessive tension can reduce the service life of the belt and roller bushings. The conveyor belt should only be tensioned

enough to prevent slipping under normal operating conditions.

15. Make sure the adjustment tools are removed from the conveyor belt, then connect the sander to the power source.
16. Run the conveyor belt at high speed for a few minutes and observe its tracking. The belt should remain centered on the rollers. If the belt drifts to either side, repeat the following steps until it tracks properly.
17. **Disconnect the machine from power.**
18. Slightly increase the belt tension on the side the belt is drifting toward and slightly decrease the belt tension on the opposite side.
19. Make sure the adjustment tools are removed from the conveyor belt, then connect the sander to the power source and run the conveyor belt at high speed for a few minutes. Observe the tracking. The belt should remain centered on the rollers.

IMPORTANT

The PVC conveyor belt is significantly thicker than the abrasive conveyor belt.

When replacing the conveyor belt with a belt of a different thickness, readjust the following:

- Sanding belt minimum-height positive stop
- DRO
- Extension table

Failure to make these adjustments may damage the replacement conveyor belt and the workpiece.

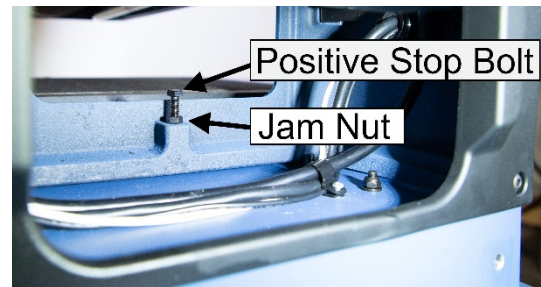
Instructions for these adjustments are provided in the following sections of this guide.

Sanding Belt Minimum Height Positive Stop Adjustment

1. **Ensure the sander is disconnected from the power source.**
2. Raise the sanding head and locate the positive-stop bolt below the motor. Remove the panel if additional clearance is needed to adjust the positive stop.



belt and the conveyor belt must be at least **1/32 in.** This prevents the sanding belt from contacting and damaging the conveyor belt and helps prevent the workpiece from being sanded too thin, which could cause it to break during sanding.



3. Loosen the jam nut to adjust the positive-stop bolt. When properly adjusted, the minimum distance between the sanding
4. Tighten the jam nut after the positive-stop bolt has been adjusted to the correct height.

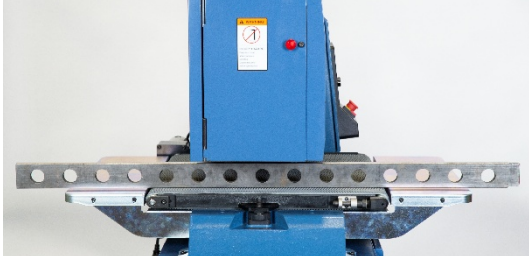
DRO Recalibration



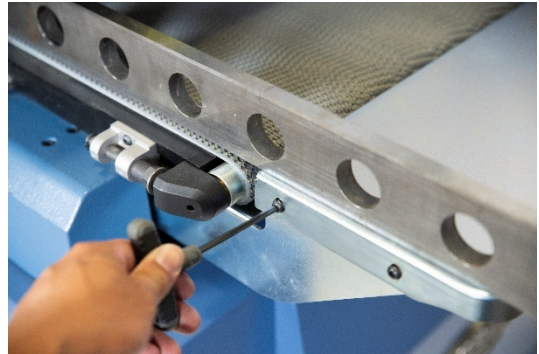
1. For the most accurate calibration, use a high-quality caliper. If a caliper is not available, use a measuring tape as an alternative.
2. Prepare a flat piece of scrap board that is slightly more than **1 in.** thick.
3. Connect the sander to the power source.
4. Sand the scrap piece, then measure its thickness to calculate the amount of material that must be removed to reach **1 in.** For example, if the scrap piece measures **1.125 in.**, remove **0.125 in.** of material.
5. Short press the **ABS Zero** button to zero the DRO reading.
6. Sand the scrap piece until the amount shown on the DRO matches the calculated amount of material to be removed. Stop sanding when the workpiece measures exactly **1.000 in.**
7. Long press the **ABS Zero** button on the control panel. The display should now read **1.000 in.**, matching the measured thickness of the workpiece.
8. The DRO is now calibrated.

Extension Table Adjustment

1. Place a straightedge across the conveyor belt and extension tables.



2. Adjust the extension tables so they are flush with the conveyor belt front-to-back and side-to-side, then fully tighten all fasteners.



For all other operating, safety, maintenance, and adjustment instructions, please refer to the sander's user manual:

<https://olivermachinery.net/oliver-machinery-manuals#sander-manuals>