



Wide Belt Stock Removal Chart

This chart is to explain best stock removal methods for wide belt sanding

Maximum STOCK REMOVAL for each grit

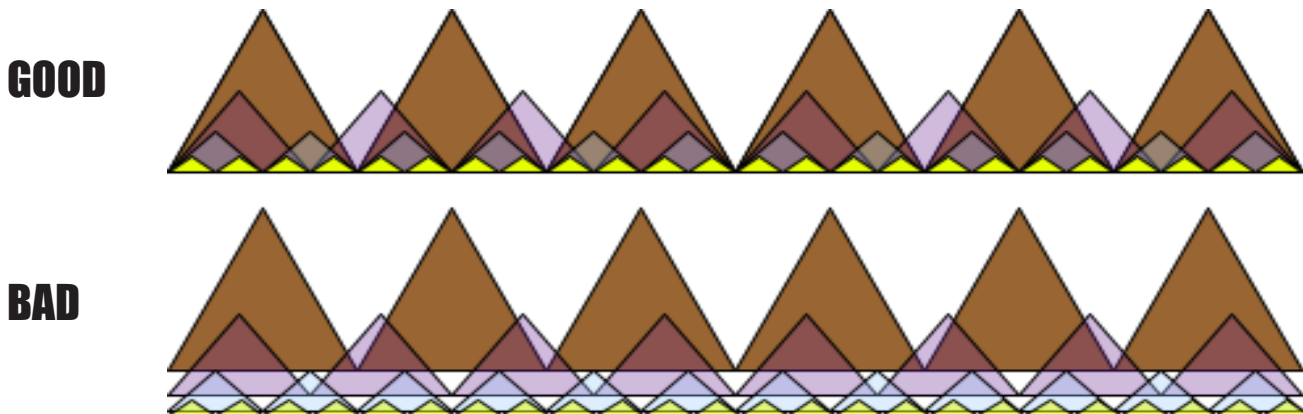
This chart is meant to give a machine operator a reasonable starting place for stock removal per sanding station. Staying under the maximum stock removal is critical to avoid damaging the abrasives and rubber on the drums. Removing the minimum is important to achieve the best possible scratch pattern. Removing more than the minimum will result in compression of the wood and damage to the grain structure, the cause of polishing and poor stain penetration.

GRIT	INCHES	MM
40	0.040	1.0
60	0.035	0.9
80	0.024	0.6
100	0.017	0.4
120	0.010	0.25
150	0.006	0.15
180	0.004	0.1
220	0.002	0.05

Maximum to remove

Minimum stock to remove a scratch pattern. This can change with the hardness of the drums or the use of a platen, although the change is very small. This is not the same as scratch depth, but for measuring purposes only. This is how much you need to remove to get rid of a particular scratch.

GRIT	INCHES	MM
60	0.015	0.4
80	0.008	0.2
100	0.006	0.15
120	0.004	0.1
150	0.0025	0.05
180	0.001	0.025
220	0.0005	0.012



The stock removal listed above is measured from the top of the scratch pattern. This is exactly as you would measure it with calipers. For wide belt sanding questions, please email: adam@surfprepsanding.com