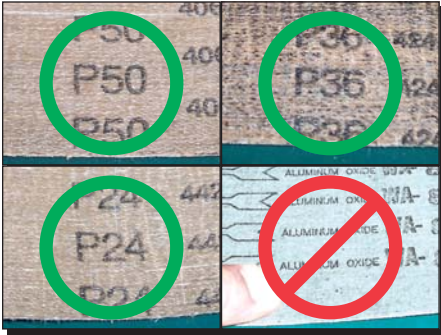




NITTA CORPORATION OF AMERICA

Skiving Instructions: S-300R PolyBelt™ Skiver

Tools Required: S-300R skiver, sandpaper, double-sided tape, brush, marker, steel ruler



1. Select sandpaper to use based on belt type (see chart below). Grits are clearly marked on back. **Use silica carbide paper only**, not aluminum oxide.



2. If correct sandpaper is already on sander, skip to **Step 5**. If not, raise sander and disengage locking devices to remove sandpaper.



3. Orient replacement sandpaper so that arrow points in direction of drive.



4. Slide replacement sandpaper onto sander and re-engage locking devices. Lower sander back into place.



5. Set thickness knob to the appropriate setting for the belt type being skived. Lock in place.



6. Adjust nosebar fine-tuner knob so sandpaper is as close to steel as possible without touching (sander should slide easily on shaft). Lock in place.

Silica Carbide Sandpaper – Grit Selection Chart

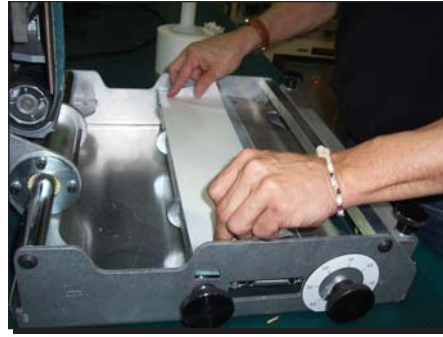
Grit	Belt Material Type
50 Grit	Light duty and thinner belts
36 Grit	Medium duty
24 Grit	Heavy duty and thicker belts

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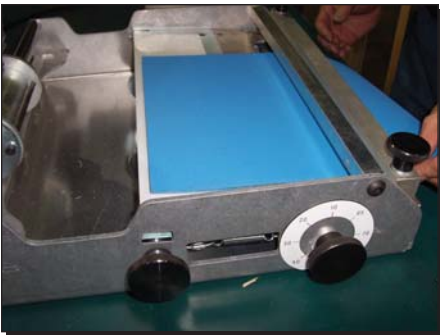
7. Apply talcum or baby powder to nosebar surface to make double-sided tape easier to remove.



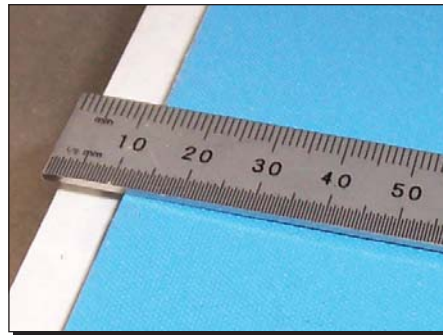
8. Apply piece of double-sided tape across the width of the nosebar. The long edge of the tape should line up with the very edge of the nosebar.



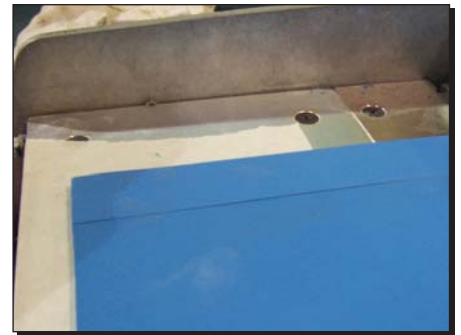
9. Peel edge of paper and remove from top side of tape to expose top side adhesive.



10. Slide belt to be skived underneath holding bar and center. The example shown is XH-500-4.



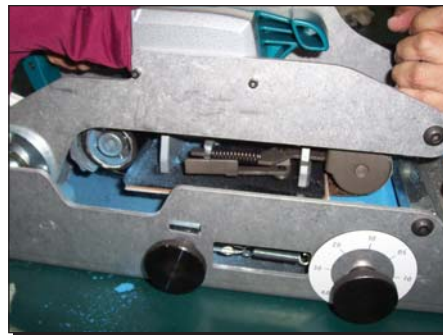
11. Place thicker belts about 12mm from the edge of the nosebar for first few skiving passes. Place thinner belts all the way to edge.



12. For wide belts, placing 1" wide sidebars of the same material along both sides of the belt will help to square the skive.



13. Tighten both knobs to close holding bar down on belt.



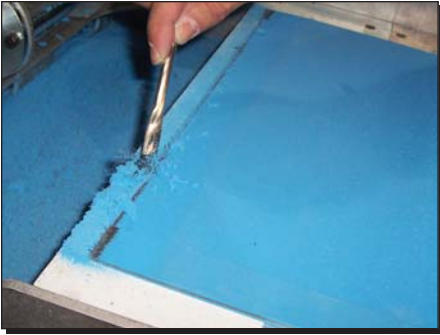
14. Activate sander and make two passes over belt (slide all the way to the opposite side, and then back).



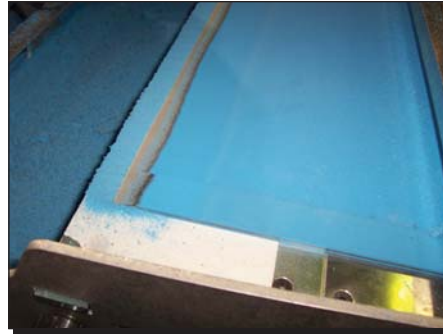
15. Cool sandpaper or switch out to another piece before continuing.

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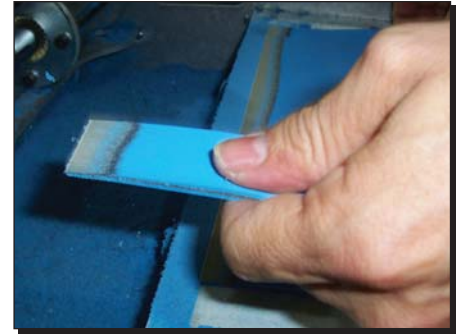
Skiving Instructions: S-300R PolyBelt™ Skiver



16. If skiving thicker material 12mm from edge (as shown in Step 11), use brush to clear dust before continuing.



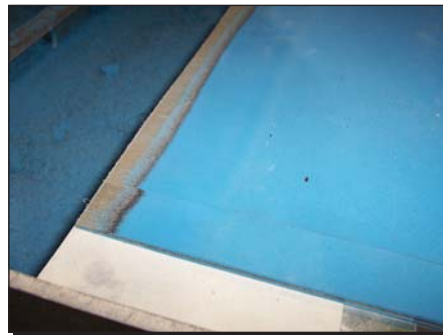
17. Make two more side-to-side passes with sander, to sand belt down further. Cool or switch out sandpaper.



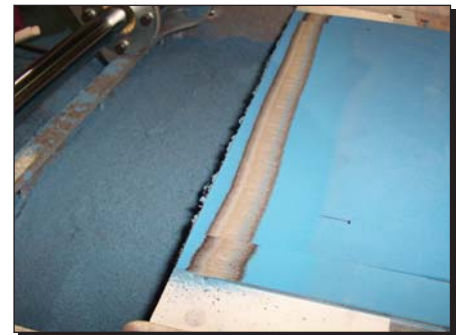
18. If skiving thicker material 12mm from edge, remove belt and any sidebars from tape. If not, skip to **Step 21**.



19. Remove tape, then follow Steps 7 through 9 to replace it.



20. Slide belt and any sidebars under holding bar, centering belt and aligning it with very edge of nosebar, and tighten down.



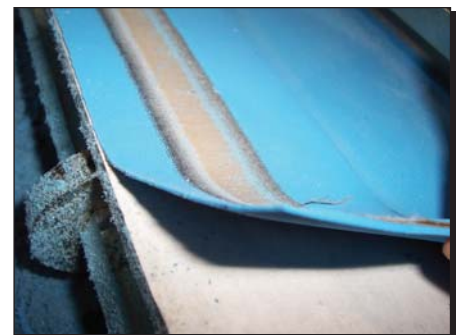
21. Continue making passes two at a time to sand belt down further. Cool or switch out sandpaper after each set of passes. Mark desired skive length if needed.



22. Continue sanding until exposed nylon is centered exactly between sanded rubber areas. You may need to adjust nosebar fine-tuner to achieve this effect.



23. Finished skive should have about 10mm width of exposed nylon, centered between sanded rubber areas of equal widths (depending on material).



24. Skive should taper to thin, feathered edge. Excess material along edge can be trimmed, or sanded down by adjusting nosebar fine-tuner.

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