ES-05108

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GENERAL SAFETY RULES

There is a certain amount of hazard involved with the use of woodworking machinery. Using the machine with the respect and caution demanded as far as safety precautions are concerned will considerable lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, to the operator can occur.

1. Read the operation manual before operating this machine.
2. If you are not thoroughly familiar with the machine operation, obtain advice from a supervisor or other qualified person.
3. the machine should be disconnected from the power source before performing maintenance or adjustments to the internal mechanisms, or when making repairs.
4. After maintenance job is finished, check to see if there are any tools or objects left on the machine. Close all safety guards.
5. Before leaving the machine, make sure the work area is clean.
6. Check timber for loose knots, nails, or other items, which may cause a hazard or affect the machine's performance.
7. Learn the machine's applications and limitations, as well as the specific potential hazards peculiar to it. Keep the machine in top condition for best and safest performance.
8. Keep all guards in place and in working order.
9. Do not force the machine. It will do the job better and be safer working at the rate for which it was designed.
10. All children and visitors should be kept a safe distance from the working area.
11. The operator should keep proper footing and balance at all times.
12. Do not operate the machine while under the influence of drugs, alcohol. Or any other medication.
13. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the machine.
14. Never leave the machine until it comes to a complete stop, and never leave the machine running unattended.
15. The employer is responsible for selecting competent and qualified employees.
16. The employer must make sure that employees study and utilize this safety information.
17. Supervisors must alert personnel of any unsafe practices they observe.
18. All employees should be aware of first aid facilities and be encouraged to use them, regardless of the severity of the injury.
19. Fire prevention must be practiced and fire protection must be available to prevent loss of life, personal injury, and property damage.
20. Safety shoes should be worn to provide protection against rolling objects, falling objects, and sharp edges in the workplace.
21. Eye protection should be worn and such devices should be carefully selected, fitted and used. Compulsory wearing of glasses with impact resistant lenses and side shields is a good safety policy. All eye protection should conform to ANSI 87 standards.
22. Wear hearing protection when operating the machine.
23. Do not wear rings, necklaces or jewelry around moving machinery.
24. Do not wear loose fitting clothes. Clothing should be comfortable, but long sleeves, neckties, etc. should not be worn.
25. Do not wear gloves or other hand covering articles around moving machinery.
26. Cover long hair with a hair net or cap.

27. Protective guards and shields must be in place at all times unless they must be removed for specific service or maintenance. They should be immediately replaced when service or maintenance is completed.
28. Make sure that operator clearly knows how to stop the machine before starting work.
29. Never clean or remove chips while the machine is running.
30. Maintain the machine in good operating condition. Report unusual conditions or machine malfunctions immediately.
31. Do not alter or remove guards and warning labels.
32. Keep the immediate area clean. Do not allow the floor to become slippery, or covered with dust or obstacles. Dust that accumulates in the work area is a hazard that can cause you to fall or slip against the machine or its controls.
33. Employees should be required to report to their supervisors any hazardous condition of the machine or in the immediate area.

ADDITIONAL SAFETY RULES

1. Do not operate your machine until it is completely assembled and installed according to the instructions.
2. If you are not thoroughly familiar with the operation of abrasive finishing machines, obtain advice from your supervisor, instructor or other qualified person.
3. This machine is designed to sand wood or wood-like products only. Sanding or grinding other materials could result in fire, injury or damage to product.
4. Always wear eye protection.
5. This machine is intended for indoor use only.
6. Mount and use this machine on horizontal surfaces only. Use of this machine on an uneven surface may result in motor damage.
7. If there is any tendency for the machine to tip over or move during certain operations such as when sanding long or heavy boards, the machine must be securely fastened to a supporting surface.
8. Make sure sanding belt runs in the proper direction. See directional arrow on back side of belt.
9. Make sure the sanding belt is tracking correctly in order that it does not run off the pulleys.
10. Make sure the sanding belt is not torn or loose.
11. Hold the work firmly when sanding.
12. Always use the backstop when the belt sander is in the horizontal position.
13. Always hold the work firmly on the table when sanding on the disc.
14. Always sand on downward side of disc when using the disc portion of the machine, so that the work is held securely on the table. Sanding on the upward side of the disc could cause the work piece to fly up which could be hazardous.
15. Always maintain 1/16” maximum clearance between the table or backstop and the sanding belt or disc.
16. Never wear gloves or hold the work with a rag when sanding.
17. Sand with the grain of the wood.
18. Do not sand pieces of material that are too small to be safely supported.
19. Avoid awkward hand positions where a sudden slip could cause a hand to move into the sanding belt or disc.

20. When sanding a large work piece, provide additional support at table height.
21. Do not sand with the work piece unsupported. Support the work piece with the miter gauge, backstop or worktable. The only exception is curved work performed on the outer sanding drum.
22. Always remove scrap pieces and other objects from the table, backstop or belt before turning the machine “ON”.
23. Never perform layout, assembly or set-up work on the table while the sander is operating.
24. Always turn the machine “OFF” and disconnect the cord from the power source before installing or removing accessories.
25. Never leave the machine work area when the power is “ON” or before the machine has come to a complete stop.
26. To safeguard the sander from unauthorized operation and to avoid accidental starting by children, the use of padlock is requested. To lock out the on-off switch, open the padlock, insert through the hole in the ON switch knob, and close the padlock. Place the key in location that is inaccessible to children and others not qualified to use the tool

UNPACKING & CHECKING CONTENTS

The machine has been well packed at the manufacturer’s factory and shipped in good condition. The machine is shipped in one wooden pallet.

Upon receiving the machine, carefully unpack it and check all items as according to the packing list.

If you find any part is missed or damaged, note it on the bill of lading, contact your local distributor or the manufacturer of the machine immediately. Do not attempt to operate the machine until the missing parts are obtained and are installed correctly.

LIFTING THE MACHINE

The machine should be lifted or moved by a forklift. Make sure the loading capacity of the forklift is sufficient to raise the machine. Pay special attention to the machine balance while lifting the machine to prevent the machine from falling. The forks of the forklift must protrude over the machine bottom for uniform distribution of the entire machine weight.

CLEANING THE MACHINE

The machine is coated with rust preventative oil before shipment. When the machine has been moved to the proper work site, wipe the oil from the machine using a soft cloth soaked in kerosene. Do not use gasoline, lacquer thinner, or any other volatile solvent, as these may damage the paint surface of the machine.

ELECTRICAL SAFETY RULES

1. Do not alter or bypass any protective interlock.
2. Before starting the machine, read and observe all warning labels and markings such as nameplates and identification plates.
3. Only personnel who are properly trained and have adequate knowledge and skill should undertake all electrical/electronic troubleshooting and repair.
4. Use extra precautions in damp areas to prevent yourself from accidental grounding.
5. Make sure your body and your tools are clear of electrical grounding.
6. The control panel doors should be opened only when it is necessary to check the electrical equipment or electrical wiring.
7. Before applying power to any equipment, establish without a doubt that all persons are clear.
8. Be alert and be sure you can work with no outside distractions.
9. Avoid wearing metal frame glasses or wearing a metallic necklace or chain, and never work on electrical equipment while wearing rings, watches, or bracelets.
10. When replacing conductors, make sure they conform to the manufacturer's specifications, including proper color-coding.
11. Do not alter the electrical circuits. If machine damage is caused by an unauthorized alteration, the user is responsible, not the manufacturer.
12. Always assume the electrical power is ON and treat circuit as live. This caution develops a habit that may prevent an accident.
13. Give capacitors time to discharge. Otherwise, it should be done manually with care.
14. Use proper test equipment to make certain you have an open circuit. Test equipment must be checked and calibrated at regular intervals.
15. Open the control panel doors only when it is necessary to check the electrical equipment or wiring. After closing the door, make sure the disconnecting means are operating with the disconnecting handle mechanism is its proper position.
16. All covers on junction boxes must be closed before leaving any job.

CONNECTION TO POWER SOURCE

Power Connection

A separate electrical circuit should be used for your machines. This circuit should not be less than and should be protected with a 10 amp, time lag fuse. Have a certified electrician repair or replace damaged or worn cord immediately. Before connecting the motor to the power line, make certain the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as stamped on the motor nameplate. All line connections should make good contact. Running on low voltage will damage the motor.

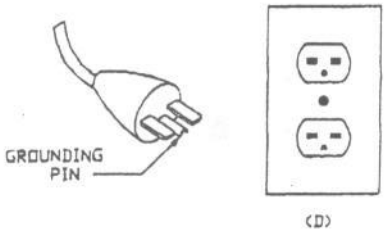
Grounding Instructions

The edge sander must be grounded. If it should malfunction or break down, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. The edge sander is equipped with a cord having an equipment-grounding conductor and grounding plug. The plug must be inserted into an appropriate outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Warning: This machine must be grounded while in use to protect the operator from electric shock.

Warning: Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a qualified electrician or service person if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with the belt sander. If it will not fit the outlet, have a proper outlet installer by a qualified electrician. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded. Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the machine's plug. Repair or replace damaged or worn cord immediately.



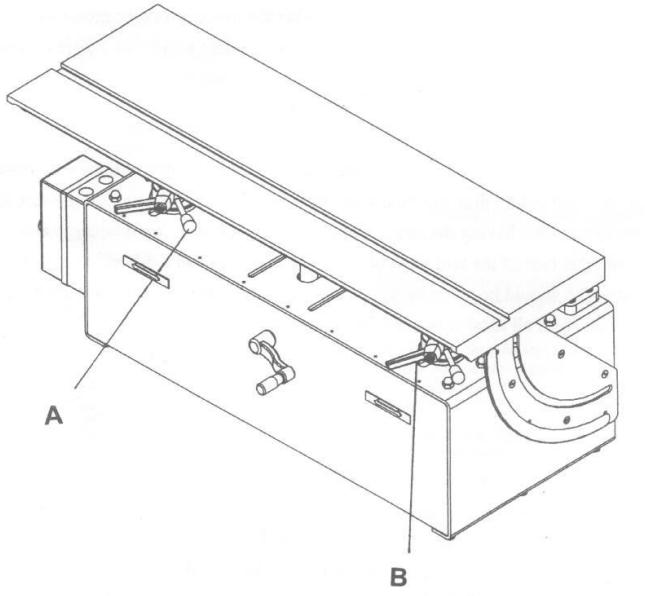
The machine is intended for use on a circuit that has an outlet that looks like the one illustrated. The machine has a grounding plug that looks like the plug illustrated. Make sure the tool is connected to an outlet having the same configuration as the plug. No adapter is available or should be used with this machine. If the machine must be reconnected for use on a different type of electric circuit, the reconnection should be made by a qualified service personnel; after reconnection, the machine should comply with all local codes and ordinances.

Amp Rating		Total Length of Cord in Feet				
		Volt	50ft	100ft	200ft	300ft
More Than	Less Than		AWG			
6	10	240V	18	16	14	12
10	12	240V	16	16	14	12

OPERATION INSTRUCTIONS

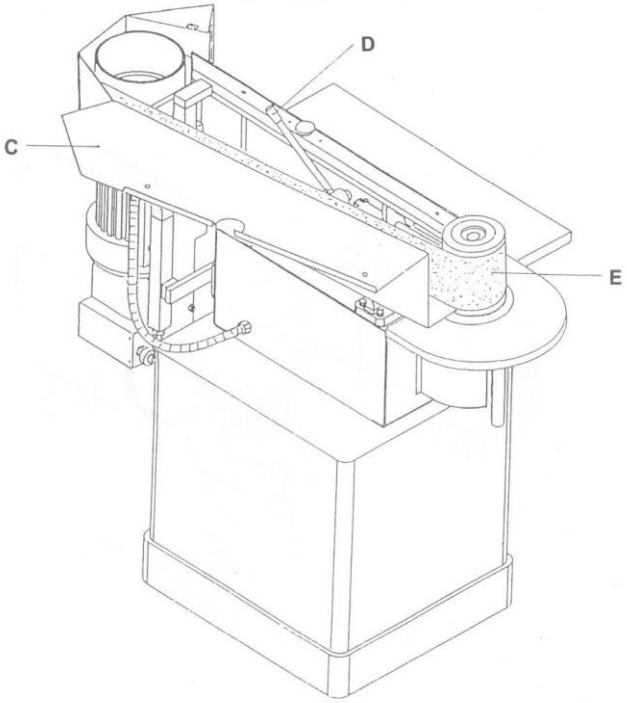
Height Adjustment of the Main Table

1. Loosen the two adjusting knobs (A) and (B) at right and left hand side.
2. Turn the handle up in front of the main table and swivel it to your required height.
3. Lock the two adjusting knobs (A) and (B) again to insure the main table is stable.



Changing the Sanding Belt

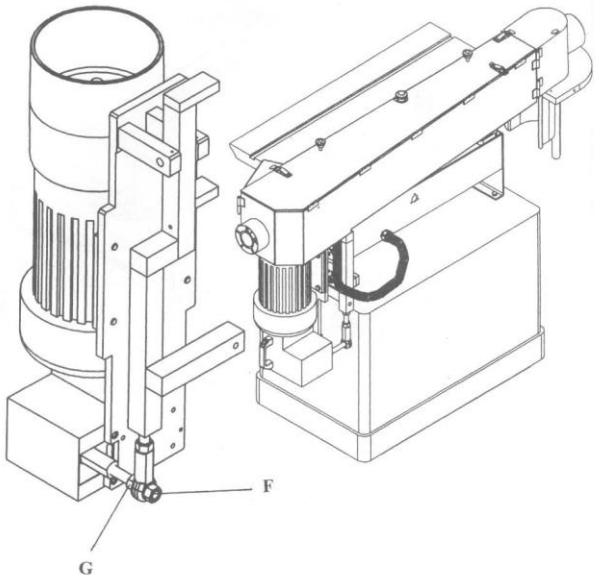
Open the platen cover (C) by loosening the two bolts on the top of the platen cover. Raise the handle bar (D) for releasing the sanding belt (E). Next, take off the sanding belt and change a new one then put it back by pushing back the handle bar (D) for tightening up the sanding belt.



Micron Adjustment for Sanding Belt Alignment Adjustment

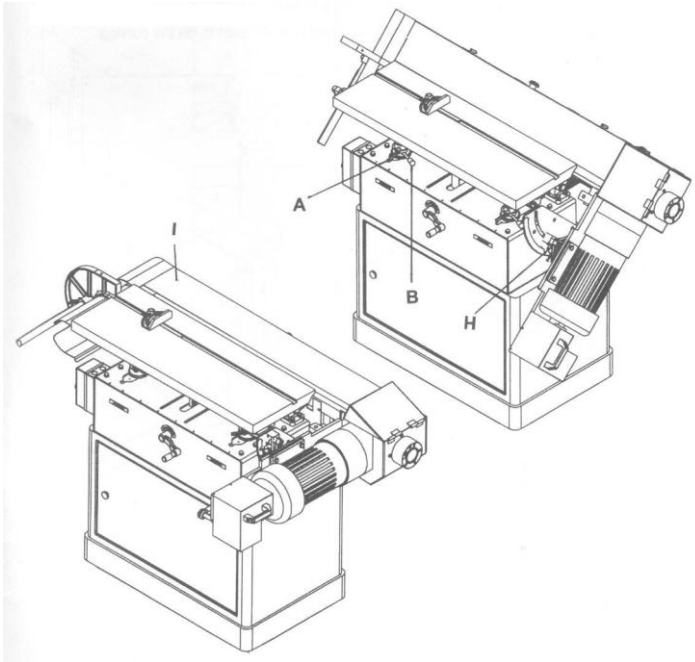
(When the sanding belt is not running at the central position of the platen)

1. Loosen nut (F).
2. Rotate nut (G) clockwise or counter clockwise to adjust belt tracking.
3. When belt is tracking properly. Retighten nut (F) again.



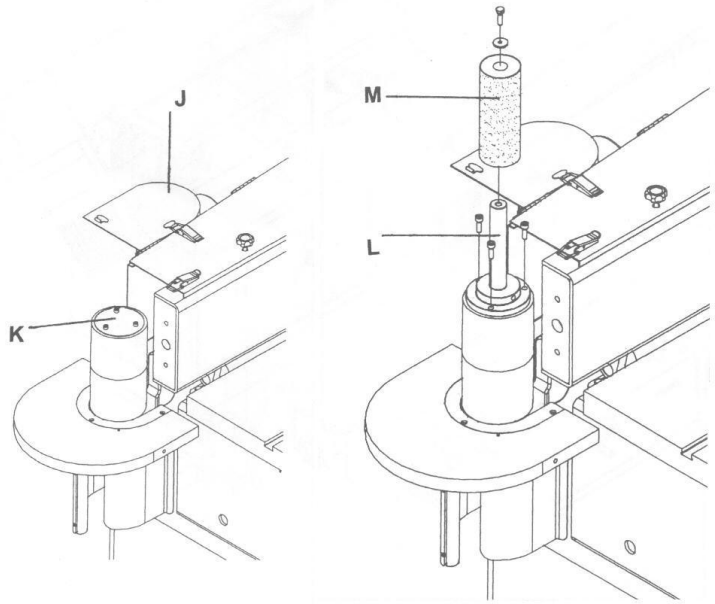
Vertical & Horizontal Sanding

1. Loosen the two knobs (A) and (B) under the main table and pull the table backward position.
2. Loosen the adjusting knob (H) at the scale and set up the angle as your request by moving the platen (I). Lock the adjust knob (H) again while the angle is set up already.
3. Move the main table forward to close the platen and tighten up the two knobs (A) and (B) again to insure the table is stable.



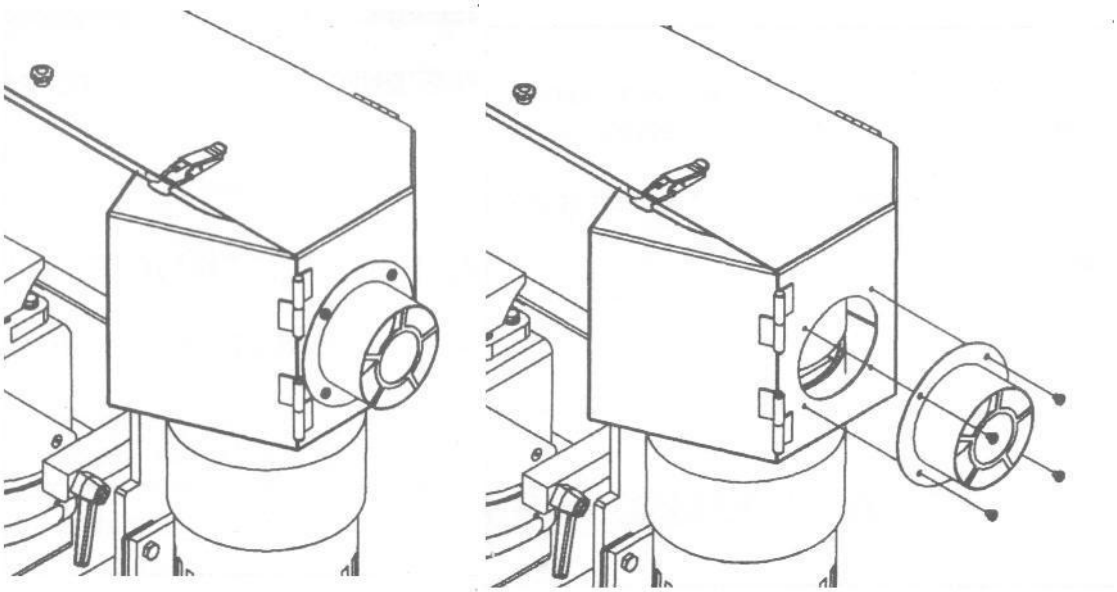
Curve Sanding

1. Open the platen cover (J) and fasten it at the clamp position.
2. Loosen the three socket screws. Take the idler roller cover (K) off and mount the sanding drum spindle (L) by tightening 3 pieces of M5 x 15L socket screw.
3. Insert the rubber drum (M) by using one piece of washer and one piece of ¼" x ½" hex head screw. Then you can start to do the curve sanding.



Mounting the Dust Port Before Operating

Mounting the dust port by using four pieces of ¼" x ¼" round head screw tightly.



TROUBLESHOOTING

Warning: Turn switch “OFF” and always remove plug from power source before troubleshooting.

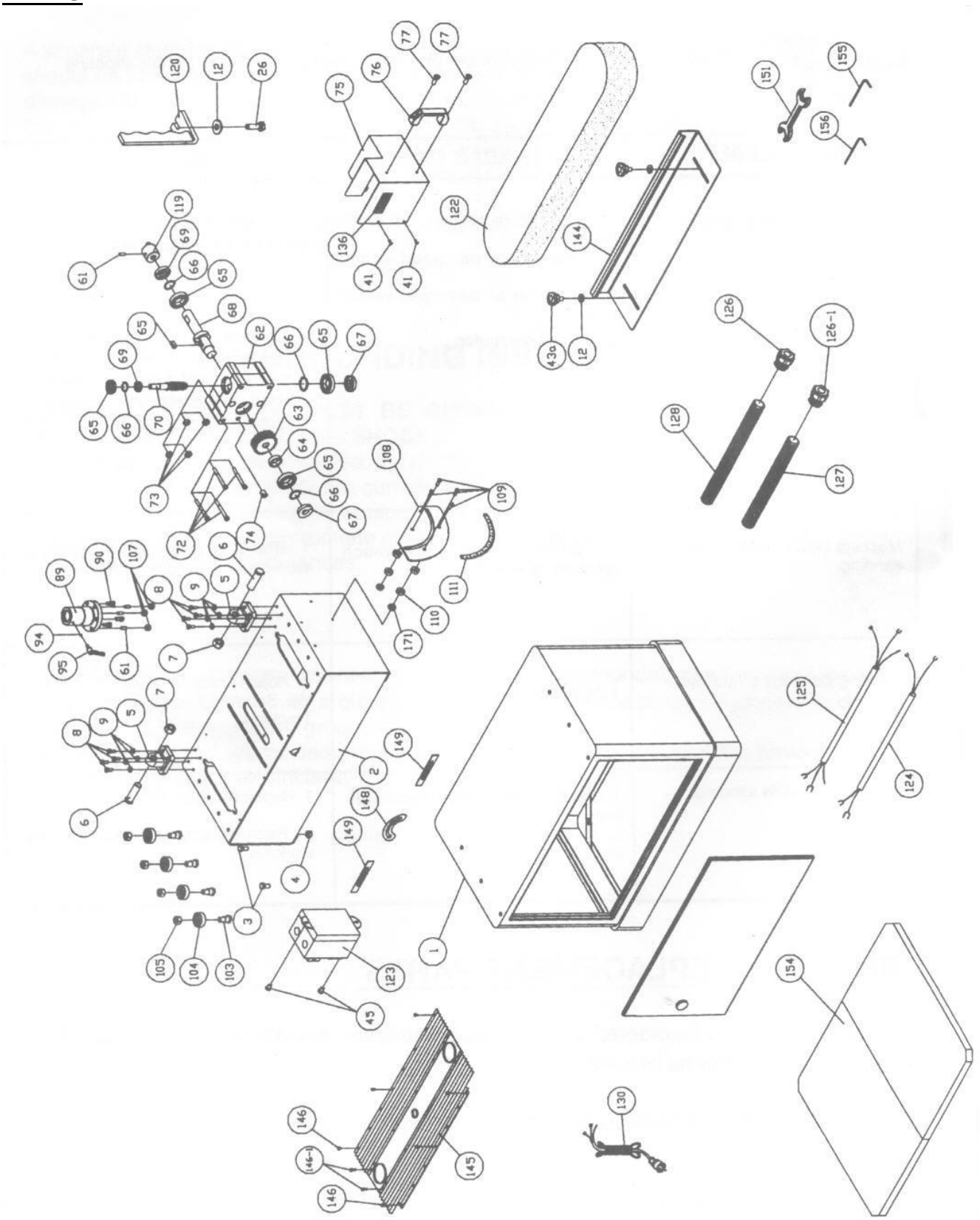
Problem	Probable Cause	Remedy
Motor will not run	Defective or broken “ON-OFF” switch	Replace all broken or defective parts before using sander
	Defective or damaged switch cord	Replace all broken or defective parts before using sander
	Defective or damaged switch relay	Replace all broken or defective parts before using sander
	Burned out motor	Consult your local Authorized Service Station. Any attempt to repair this motor may create a hazard unless repair is done by a qualified technician
	Blown house fuse	Replace fuse
Machine slows down while sanding	Operator applying too much pressure to work piece	Use less pressure in applying work piece to sanding surface
Sanding belt runs off pulleys	Not tracking properly	Adjust tracking. See “Replacing the Sanding Belt, Tensioning and Tracking”
Wood Burns while sanding	Sanding disc or belt glazed with sap	Replace belt or disc
	Excessive pressure being applied to work piece	Reduce pressure applied to work piece

ORDERING REPLACEMENT PARTS

Replacement parts may be ordered from your local distributor. When ordering replacement parts, always provide the following information:

1. The model number and serial number of the belt sander.
2. The part number.
3. The part name.
4. The desired quantity of the part.

PARTS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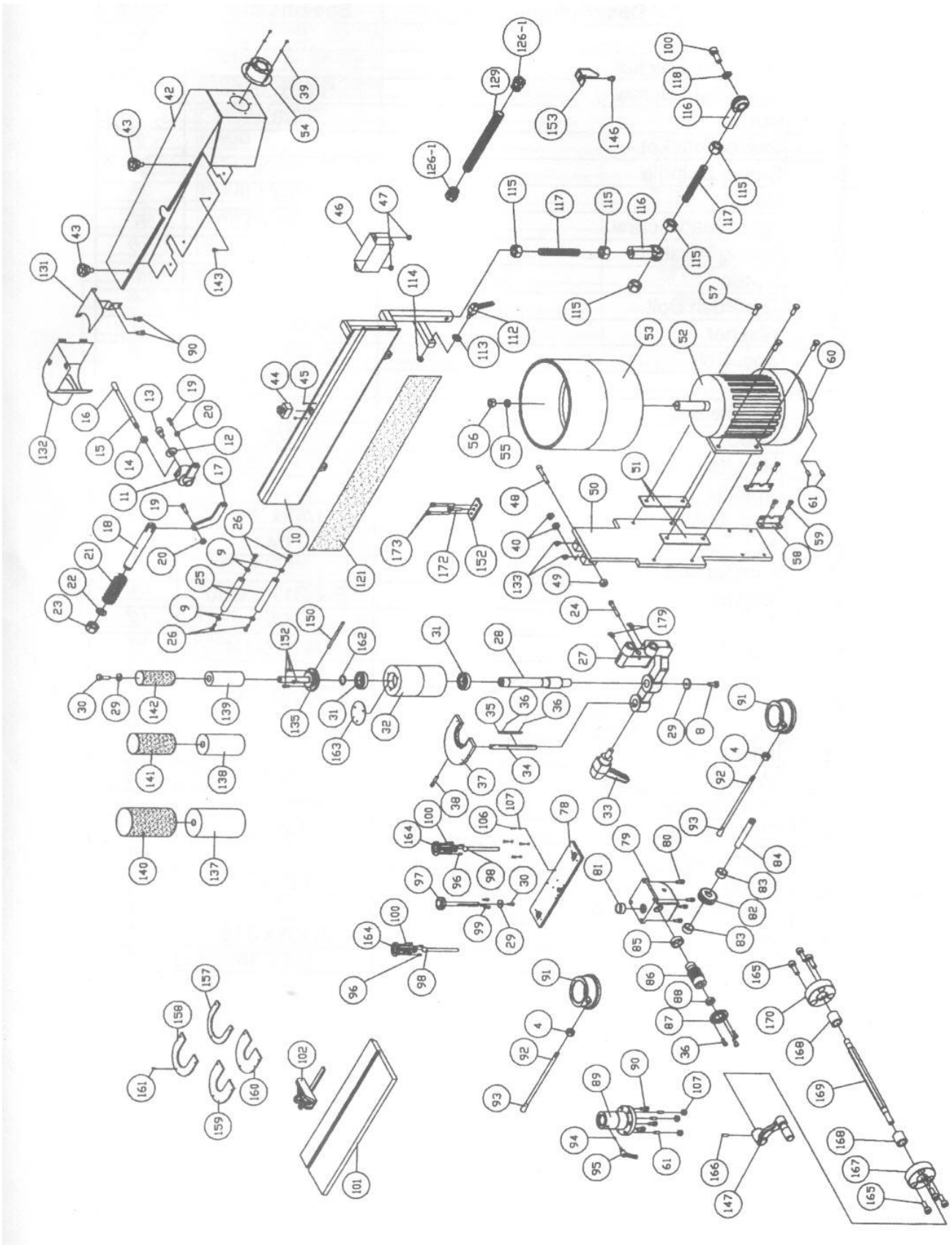

No	Description	Qty
1	Base	1
2	Adjusting Bracket	1
3	Hex Head Screw 3/8” x 3/4"	6
4	Nut 3/8”	8
5	Swivel Bracket	2
6	Swivel Spindle	2
7	Nut 3/4"	2
8	Hex Head Screw 5/16” x 1”	6
9	Spring Washer 5/16”	12
10	Platen	1
11	Top Push Bolt	1
12	Washer 5/16” x 23	6
13	Soc Bolt 5/16” x ½”	1
14	Nut 1/2"	1
15	Handle Bar	1
16	Knob 1/2"	1
17	Handle Bracket	1
18	Spindle	1
19	Soc Bolt 1/4" x 3/4"	1
20	Nut 1/4"	2
21	Condensed Spring	1
22	Washer 3 x ∅17 x ∅30	1
23	Nut 5/8”	2
24	Soc Bolt 1/4" x 1-1/4”	1
25	Fixing Spindle	2
26	Hex Head Screw 5/16” x 1”	6
27	Idler Roller Bracket	1
28	Idler Roller Spindle	1
29	Washer 5/16”	4
30	Hex Screw 5/16” x 1/2"	2
31	Ball Bearing 6205Z	2
32	Idler Roller	1
33	Knob 3/8” x 25	1
34	U-Type Table Spindle	1
35	Key 8 x 8 x 315	1
36	Soc Bolt M4 x 10	5
37	U Type Cast Iron Table	1
38	Soc Bolt 3/8” x 3/4"	1
39	Round Head Screw 1/4" x 1/4"	4
40	Thrust Ball Bearing 5101	2
41	Phillip Head Screw 3/8” x 3/8”	8
42	Platen Cover	1
43	Knob 5/16” x 1”	2
44	Emergency Stop Switch	1

45	Round Head Screw 3/16” x 3/4"	2
46	Switch Cover	1
47	Nut 3/16”	2
48	Soc Bolt M12 x 3”	1
49	Nut M12	1
50	Motor Bracket	1
51	Motor Plate	2
52	Motor	1
53	Drive Roller	1
54	Dust Port	1
55	Impeller Washer	1
56	Nut 5/8”	1
57	Hex Screw 3/8” x 1”	4
58	Gear Box Fixing Plate	2
59	Hex Screw 5/16” x 1/2"	4
60	Spindle Connector	1
61	Hex Screw 1/4" x 1/2"	16
62	Gear Box	1
63	Gear	1
64	Aluminum Ring	1
65	Ball Bearing 6202Z	4
66	Ring R-35	4
67	Oil Sealed Without Hole	2
68	Turbine Spindle	1
69	Oil Sealed With Hole	2
70	Turbine Rod (A)	1
71	Key 7 x 7 x 16	1
72	Socket Screw M8 x 80	2
73	Nut M8	4
74	Set Screw PT 1/8”	1
75	Gear Box Cover Set	1
76	Handle	1
77	Phillip Head Screw 1/4" x 5/8”	2
78	Adjusting Plate	1
79	Turbine Box	1
80	Soc Screw 5/16” x 3/4"	4
81	Tooth Row Copper Ring	1
82	Turbine	1
83	Packing	1
84	Turbine Spindle	2
85	Copper Ring	1
86	Turbine Rod (B)	1
87	Packing	1
88	Thrust Ball Bearing Dia. 38 x 42 x 20t	1
89	Orientating Spindle Packing	2
90	Soc Screw 1/4" x 1/2"	9

91	Locked Nut	2
92	Handle Bar	2
93	Knob 3/8”	2
94	Copper Plate ∅5 x 3	2
95	Handle 1/4" x 1/2"	2
96	Set Screw 5/16” x 1”	6
97	Adjusting Screw Spindle	1
98	Orientating Spindle	2
99	Soc Screw 5/16” x 1”	8
100	Soc Screw 5/6” x 3/4"	6
101	Table	1
102	Miter Gauge	1
103	Bias Spindle	8
104	Ball Bearing 6001ZZ	8
105	Nut with Cap 3/8”	8
106	Carriage Screw 5/16” x 1-1/4”	4
107	Nut 5/16”	4
108	Scale Plate	1
109	Screw 1/4" x 3/4"	4
110	Miter Gauge Packing	4
111	Label	1
112	Handle 3/8” x 50	1
113	Washer Dia. 5/16” x 34.3	1
114	Swivel Packing	1
115	Nut M4	5
116	Ball Bearing ∅14	2
117	Adjusting Thread	2
118	Washer 1/4" x 18	1
119	Bias Packing	1
120	Platen Table	1
121	Graphite Paper	1
122	Sanding Belt Paper	1
123	Switch	1
124	Emergency Stop Power Cord	1
125	Motor Power Cord	1
126	Connector 3/8”	2
126-1	Connector 1/2"	4
127	Hose Connector 3/8”	1
128	Hose Connector 1/2"	1
129	Hose Connector 1/2"	1
130	Power Cord	1
131	Packing Washer Right	1
132	Packing Washer Left	1
133	Hex Head Screw 1/4" x 3/8”	1
134	Hex Screw 5/16” x 1-1/2”	4
135	Sanding Drum Spindle	1

136	Sanding Paper Adjusting Label	1
137	Rubber Drum ∅3”	1
138	Rubber Drum ∅2”	1
139	Rubber Drum ∅1-1/2”	1
140	Drum Sanding Paper ∅3”	1
141	Drum Sanding Paper ∅2”	1
142	Drum Sanding Paper ∅1-1/2”	1
143	Hex Head Screw 1/4" x 1/4"	5
144	Fence	1
145	Extendable Cover	1
146	Round Head Screw 3/16” x 3/8”	26
146-1	Round Head Screw 3/16” x 3/4"	4
147	Handle Wheel	1
148	Label	1
149	Label	2
150	Hex Rod	1
151	Open End Wrench 10 x 12mm	1
152	Plate 70 x 31.7 x 5/16”	1
153	Pointer	1
154	Wooden Board 25 x 395 x 457	2
155	Hex Wrench M6	1
156	Hex Wrench M5	1
157	U Type Packing 4”	1
158	U Type Packing 3”	1
159	U Type Packing 2-1/2”	1
160	U Type Packing 1-1/2”	1
161	Pan Head Screw 3/16” x 3/8”	3
162	Ring S-25	1
163	Idler Roller Cover	1
164	Socket Screw M6 x 16	3
165	Set Screw 5/16” x 1/2"	4
166	Hex Spindle Front Cover	1
167	Thrust Ball Bearing Dia. 17 x 19 x 15	2
168	Hex Spindle	1
169	Hex Spindle Back Cover	1
170	Nut 1/4"	4
171	Nut 1/4"	4
172	Socket Screw 5/16” x 1-1/4”	1
173	Socket Screw 1/4" x 1-3/4”	2
174	Spring	1