

HAFCO

METALMASTER



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Instruction Manual

FINISHING ATTACHMENTS

HLA-915 & HLA-1220

Order Code: (L0920 & L0921)

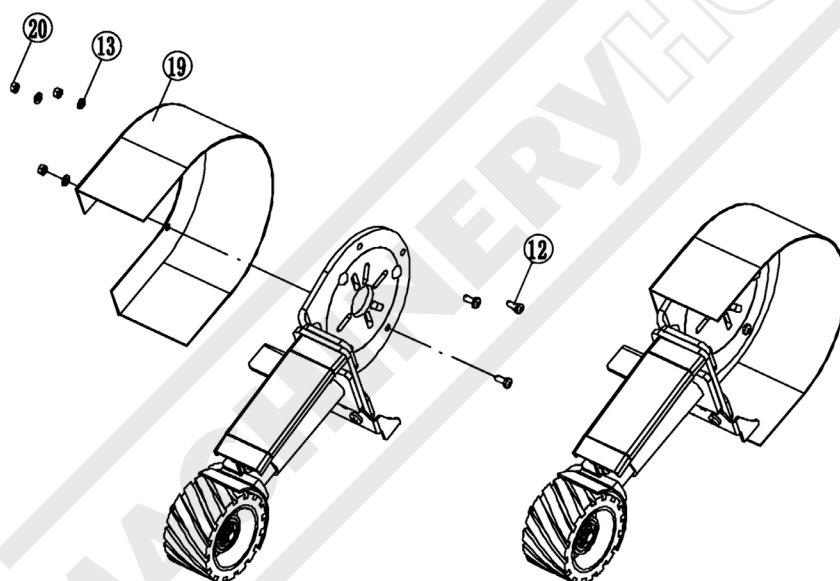
SPECIFICATIONS

Order Code	L0920	L0921
MODEL	HLA-915	HLA-1220
(mm) Belt Size	915 x 50	1220 x 50
(mm) Dia Size	178	
(mm) Suits Grinder Size	200	

ASSEMBLY INSTRUCTIONS

1. Layout the parts of the finishing attachment on a flat surface.
2. Attach the protective cover using (#12) screws M5 x 16, flat washer and M5 nut.

Note: For art number reference see **Parts Breakdown on page 7.**



WARNING!

Machines are safeguarded to protect the operator from injury or death with the placement of guards. Machines must not be operated with the guards removed or damaged.

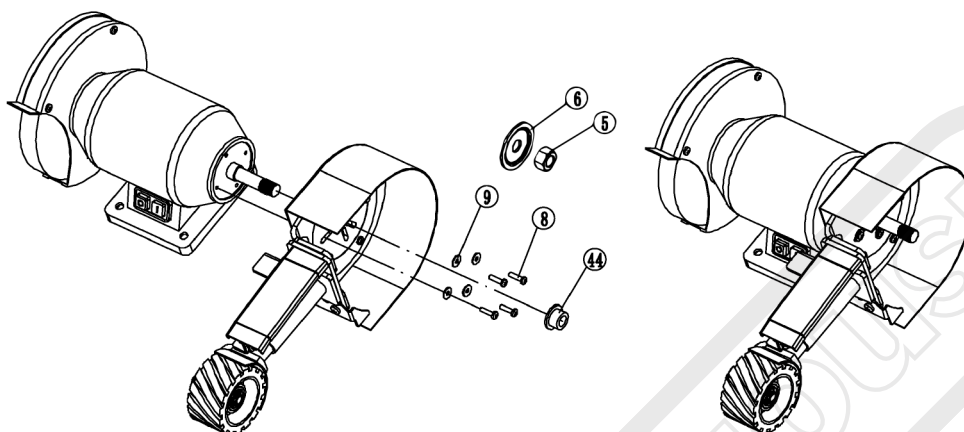


WARNING

Before operating any machine, take time to read and understand all safety signs and symbols. If not understood seek explanation from your supervisor or an experienced operator.

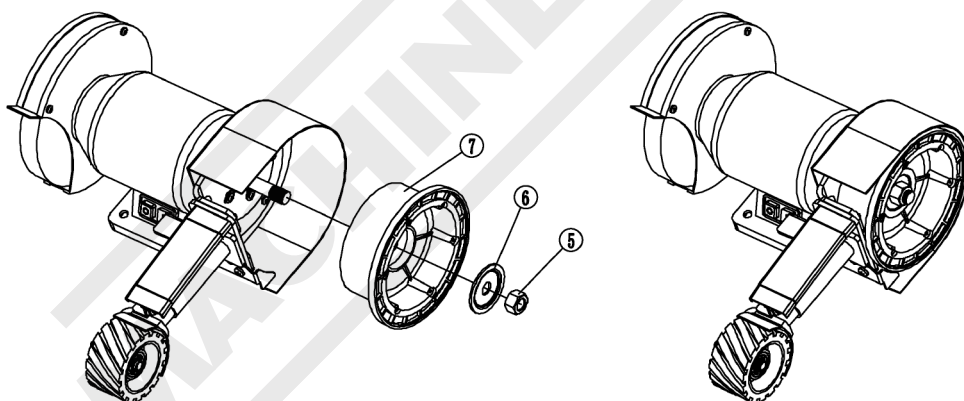
INSTALL SANDING BELT FRAME

3. Remove the right hand grinding wheel and guard, and keep the nut (#5) and grinding wheel flange (#6) to be used later.
4. Install the sanding belt frame onto the motor shaft with the (#8) M5 x 16 bolt and (#9) M5 flat washer and tighten them. Apply shaft bushing (#44) if necessary.



INSTALL THE ALUMINIUM DRIVING WHEEL

5. Install the aluminium driving wheel (#7) onto the wheel shaft of the grinder (apply shaft bushing if necessary), install the grinding wheel flange #6 and tighten the nut (#5).

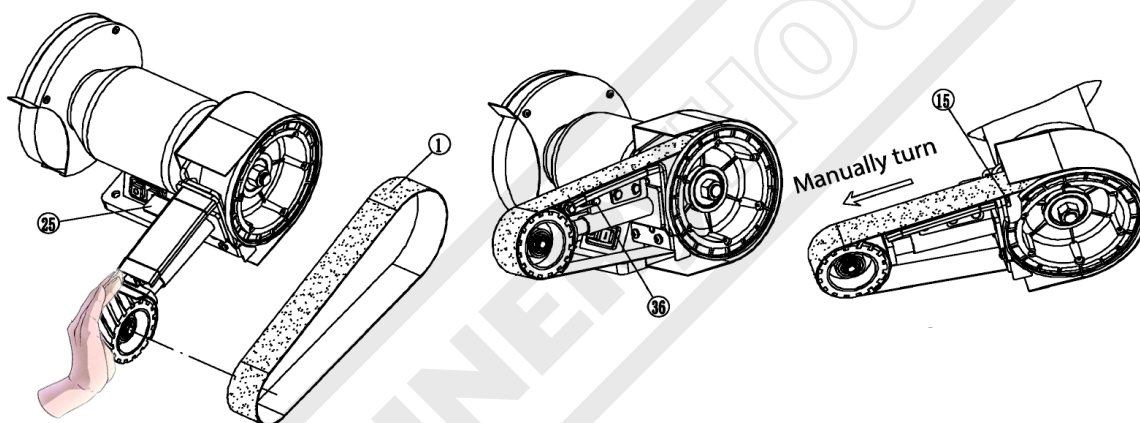


WARNING

Serious injury could occur if you connect machine to power before completing the setup process. DO NOT connect to power until all assembly and adjusting processes are complete.

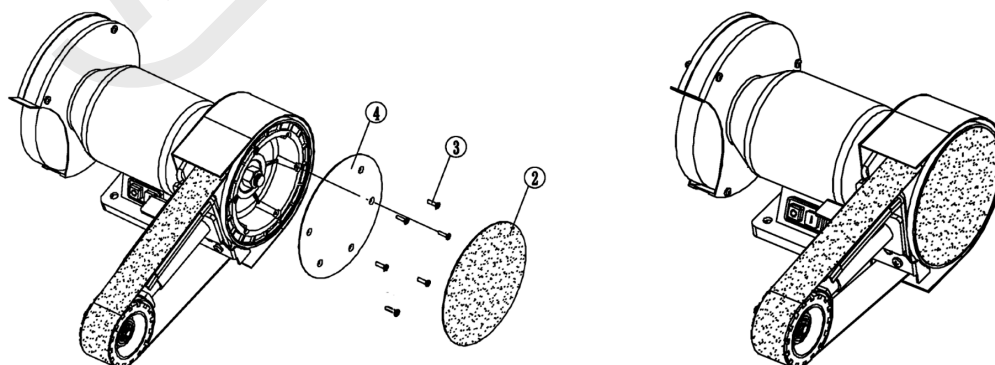
INSTALL THE SANDING BELT

6. Press the rubber idle driven wheel, the tension lock will drop and hold the frame in place to allow the belt to be installed.
- a. Install the sanding belt, making sure that the arrow on the back of the belt is running in the correct direction, then lift the tension lock and the spring loaded tension will tighten the sanding belt.
- b. Turn the sanding belt by hand according to the arrow direction to check that the belt is tracking correctly.
- c. Turn on the power and adjust the eccentric plate (#25) for fine adjustment. If the tracking is large, it may be necessary to remove the abrasive belt and move the eccentric plate to the middle position, by loosening the (#15) M5 x 16 bolts (upper and lower 2 pieces). Install the abrasive belt again and rotate by hand to check the tracking. Tap the upper part of the transition plate at the rear end of the grinding wheel bracket with a hammer to make the abrasive belt run at a reasonable position. Remove the abrasive belt and tighten the bolts (#15). Install the abrasive belt again. After the abrasive belt is tightened, lock the bolts (#36). Start the tool and use the eccentric plate (#25) to fine tune the abrasive belt to the ideal position. If it cannot be adjusted to the ideal position, repeat the above operation until it is reasonable.



INSTALL THE SANDING DISC

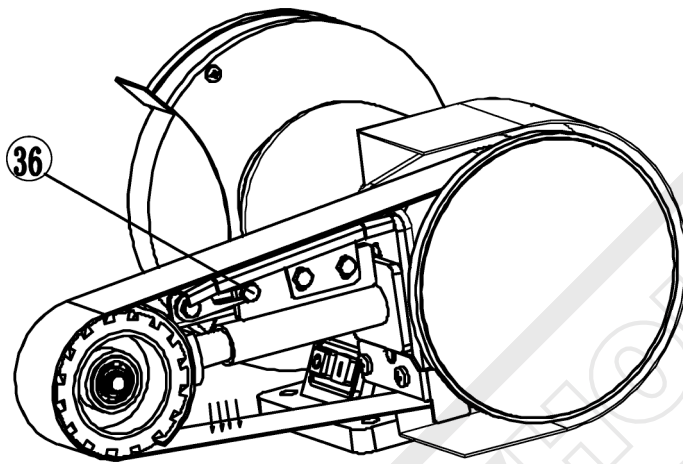
7. Install the sanding disc (#4) and tighten the screws (#3).
8. Tear off the back paper and paste sanding paper to the disc, press paper to stick it evenly and firmly.



REPLACING THE SANDING BELT:

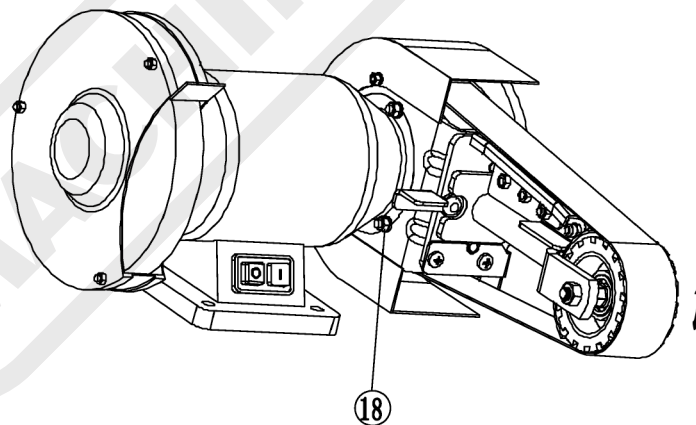
Loosen bolt (#36) and press front driven wheel, the tension lock board will drop and fix the driven wheel support. This makes it easy to remove the belt and install a new belt. Lift the tension lock board, and then tighten the bolt (#36).

Note: After replacement, do a trial run to check the belt tracking and adjust the eccentric plate to get the ideal position before working on a project.



ADJUSTING THE BELT FRAME WORKING POSITION

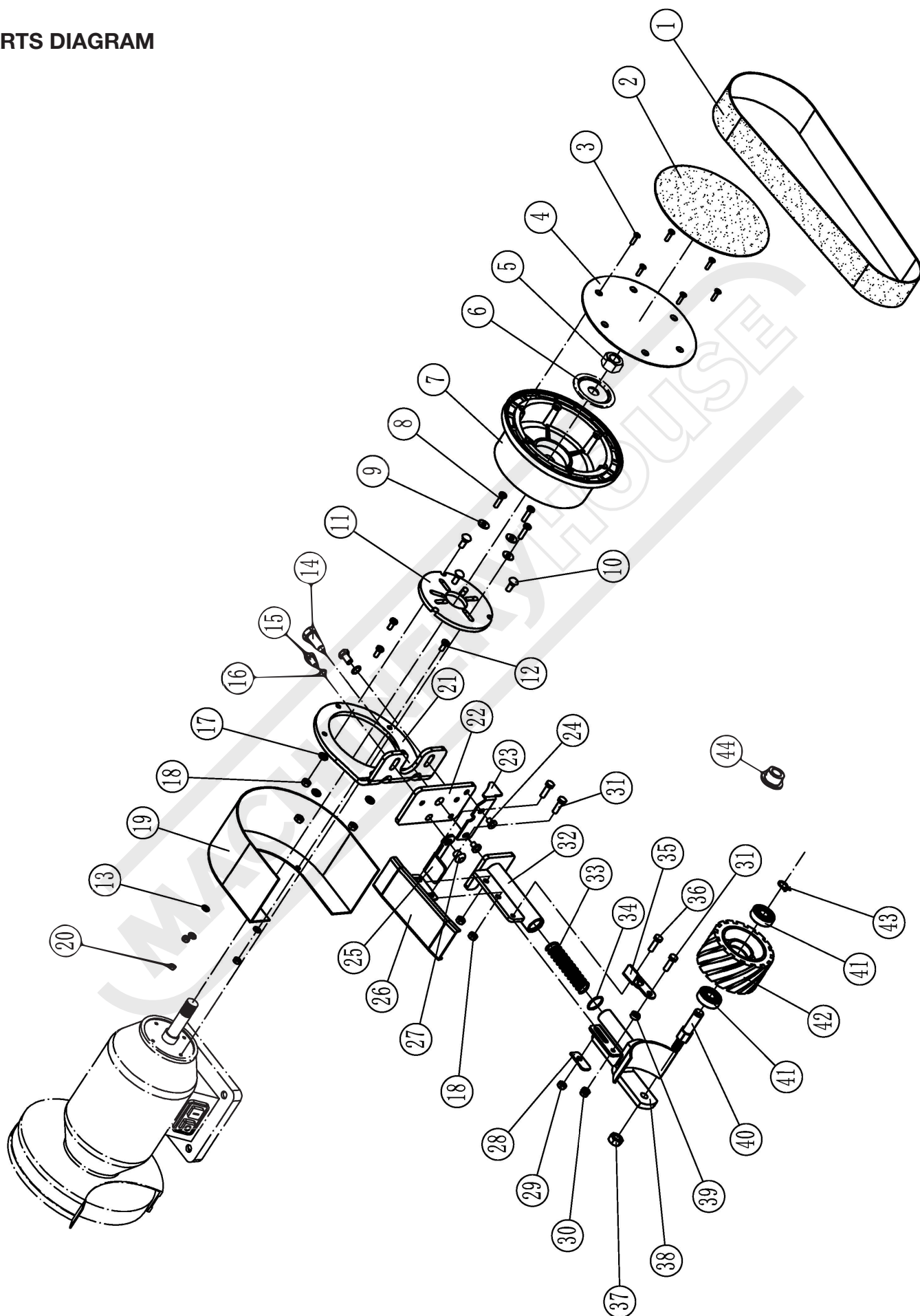
Loosen the nut (#18), adjust the frame up or down to desired angle, then tighten the nut (#18).



WARNING.

When operating a grinder it is important to wear appropriate safety gear to protect yourself from injury. This includes safety glasses or goggles, or a face shield to protect your eyes from flying debris.

PARTS DIAGRAM



PARTS LIST

No.	Part No.	Description	Spec/Material	Qty	Remarks
1	SLEJ-01	Abrasive Sanding Belt	915x50mm	1	60G
2	SLEJ-02	Sanding Paper	178mm (7")	1	80G
3	GB/T819.1-2000	Philips Screws	M4X12	6	
4	SLEJ-03	Sanding Board 7"	Q235/1.25	1	
5		Nut		1	From Grinder
6		Grinding Wheel Flange		1	
7	SLEJ-04	Alu. Driving Wheel	ZL102	1	
8	GB/T818-2000	Philips Screws	M5*16	3	
9	GB/T96.1-2002	Big Flat Washer	Ø5	3	
10	GB/T801-1998	Carriage Bolts	M6*12	3	
11	SLEJ-05	Mounting Flange	Q235/6	1	
12	GB/T818-2000	Philips Pan-head Screw	M5*16	3	
13	GB/97.1-2002	Flat Washer	Ø5	3	
14	GB/T5781-2000	Hex Bolt	M12*20	1	
15	GB/T5781-2000	Hex bolt	M8*16	2	
16	GB/97.1-2002	Big Flat Washer	Ø8	2	
17	GB/97.1-2002	Flat Washer	Ø6	3	
18	GB/T6170-2000	Hex Nut	M6	5	
19	SLEJ-06	Shield	Steel	1	
20	GB/T6170-2000	Hex Nut	M5	3	
21	SLEJ-07	Fixing Frame	Q235/6	1	
22	SLEJ-08	Fixing Board	Q235/6	1	
23	SLEJ-09	Protection Plate	Q235/2	1	
24	GB/T818-2000	Philips Pan-head Screw	M6*8	2	
25	SLEJ-10	Eccentric Plate	Q235/3	1	
26	SLEJ-11	Belt Support Board	Q235/2	1	
27	SLEJ-12	Rivet	45	1	
28	SLEJ-13	Clamp Plate	Q235/2	1	
29	GB/T6170-2000	Hex Nut	M6(8.8)	1	
30	GB/T889.1-2000	Self-locking Nut	M6	1	
31	GB/T5781-2000	Hex Bolt	M6*16	2	
32	SLEJ-14	Spring Housing	Welding Part	1	
33	SLEJ-15	Spring	65Mn	1	
34	GB/T1092-1991	O- Sealing Ring	1.8*20 (Rubber)	1	
35	SLEJ-16	Tension Lock Board	Q235/2	1	
36	GB/T5781-2000	Hex Bolt	M6*20(8.8)	2	
37	GB/6171-2000	Hex Fine Thread Nut	M10*1	1	
38	SLEJ-17	Driven Wheel Support	Welding Part	1	
39	SLEJ-18	Spacer	Powder Metallurgy	1	
40	SLEJ-19	Driven Wheel Shaft	45	1	
41	GB/T276-1994	Bearing	6201	2	
42	SLEJ-20	Driven Wheel	Rubber Coated	1	
43	GB/T894.1-1986	Clip Ring for Shaft	12	1	
44	SLF-22/23	Shaft Bushing		2	

MACHINERYHOUSE

WARNING

General Machinery Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.



WARNING

Linisher/Disc Sander Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure the sander is turned off and disconnect from the main power supply and make sure all moving parts have come to a complete stop before any inspection, adjustment or maintenance is carried out.
- 2. Sander Condition.** Sander must be maintained for a proper working condition. Never operate a sander that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Disc/Belt Condition.** Never operate a sander with a damaged or badly worn disc or belt. Replace if required.
- 4. Disc/Belt Rotation.** Be aware of the Disc and Belt rotation when sanding.
- 5. Hand Hazard.** Keep hands and fingers clear from moving parts. Serious injury can occur.
- 6. Leaving a sander Unattended.** Always turn the sander off and make sure all moving parts have come to a complete stop before leaving the sander. Do not leave sander running unattended for any reason.
- 7. Avoiding Entanglement.** Sander guards must be used at all times. Remove loose clothing, belts, or jewelry items. Never wear gloves while machine is in operation. Tie up long hair and use the correct hair nets to avoid any entanglement with the sander moving parts.
- 8. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 9. Power outage.** In the event of a power failure during use of the Linisher, turn off all switches to avoid possible sudden start up once power is restored.
- 10. Work area hazards.** Keep the area around the sander clean from oil, tools, chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 11. Workpiece Handling.** Never hold small workpieces with your fingers during a cut. Always support/feed the workpiece with push stick, table support, vice, or some sort of clamping fixture.
- 12. Hearing protection and hazards.** Always wear hearing protection as noise generated from sander and workpiece vibration can cause permanent hearing loss over time.
- 13. Dust hazards.** Always wear dust mask or respirator and eye protection when sanding. Use a dust collector as well to keep dust to a minimum.
- 14. Feeding material.** Always feed material evenly and smoothly against the direction of rotation. Never use excessive force when sanding or serious injury can occur.
- 15. Job Material.** Check material prior to sanding for nails, staple and other objects that make cause any danger when sanding.
- 16. Starting position/speed.** Never turn the sander on when the workpiece is resting on the disc or belt. Allow disc and belt to reach full speed before sanding.
- 17. Disc sanding.** Keep workpiece down toward the table whilst sanding. Workpiece may cause serious injury if not held correctly.
- 18. Guards.** Do not operate sander without the correct guards in place.
- 19. Stopping the Disc/Belt.** Do not stop or slow the Disc or Belt with your hand or workpiece. Allow the machine to stop on its own.
- 20. Wood dust may cause allergic reactions.** Make sure you know what type of dust you are exposed to as it may cause you an allergic reaction. Always wear an approved respirator.
- 21. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Linisher-Disc Sander

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures
This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace (WHSA 2011 No10)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies (Recommended for Purchase / Buyer / User)
A	ENTANGLEMENT	HIGH	Eliminate, avoid loose clothing / Long hair etc.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Isolate power to machine prior to any checks or maintenance being carried out. Do not adjust or clean machine until the machine has fully stopped.
D	SHEARING	MEDIUM	Always keep gap between table and disc to a minimum. Make sure all guard are secured shut when machine is on.
E	FRICTION	MEDIUM	Keep hands and body clear from sanding disc/belt.
F	STRIKING	MEDIUM	Wear appropriate protective clothing. Wear safety glasses.
			Stand clear of moving parts on machine. Remove all loose objects around moving parts. Ensure belts are in good condition and at correct tension. Always sand on the down stroke of the disc's rotation.
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine.
O	OTHER HAZARDS, NOISE, DUST.	LOW	Wear hearing protection as required. Must be connected to a dust extraction.
Plant Safety Program to be read in conjunction with manufactures instructions			



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Authorised and signed by:
Safety officer:

Manager:

Revised Date: 12th March 2012



ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

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