HAFCO WOODMASTER

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Instruction Manual

BELT & DISC LINISHER SANDER L-69A

Order Code: (L107)

MACHINE DETAILS

MACHINE	Belt & Disc Linisher Sander
MODEL NO.	L-69A
SERIAL NO.	
DATE OF MANF.	

DISTRIBUTED BY

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NOTE:
This manual is only for your reference. At the time of the compiling of this manual every effort to be exact with the instructions, specifications, drawings, and photographs of the machine was taken. Owing to the continuous improvement of the HAFCO WOODMASTER machine, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating any electric machine.

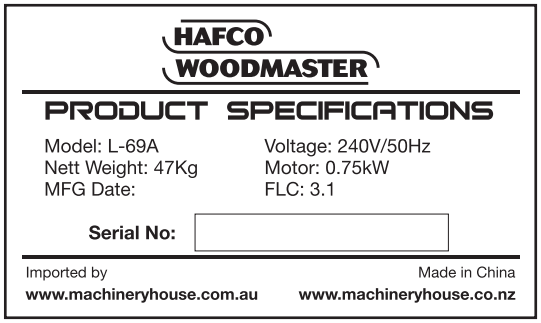
SAFETY SYMBOLS

The purpose of safety symbols is to attract your attention to possible hazardous conditions

⚠WARNING	*Indicates a potentially hazardous situation causing injury or death*
⚠CAUTION	*Indicates an alert against unsafe practices.*
Note:	*Used to alert the user to useful information*

NOTE:
In order to see the type and model of the machine, please see the specification plate. Usually found on the back of the machine. See example (Fig.1)

FIG.1



CONTENTS:

WARNING!

The machine is the sole responsibility of the owner for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training, proper inspection and maintenance, manual availability and comprehension. The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

1.1 SPECIFICATIONS

Order Code	L107
Model	**L-69A**
Belt Sander Operation	Horizontal & Vertical
Belt Size (mm)	150 x 1220
Disc Diameter (mm)	230
Table Size (mm)	160 x 440
Disc Table Size (mm)	155 x 310
Dust Port Size (mm)	63.5
Motor Speed (r.p.m)	1400
Motor Power (kW / hp)	0.75 / 1
Voltage / Amps (V / amp)	240 / 10
Floor Space (W x D x H) (mm)	750 x 550 x 1030
Nett Weight (kg).	50

1.2 INCLUDED ACCESSORIES

- ❒ Tilting Table
- ❒ Mitre Guide
- ❒ Sanding Belt
- ❒ Sanding Disc
- ❒ Stand
- ❒ Instruction Manual

1.3 IDENTIFICATION

Become familiar with the names and locations of the controls and features shown below to better understand the instructions when mentioned later in this manual.

A	230mm Disc	**G**	Mitre Gauge
B	Back Stop	**H**	Quick Release Belt Tensioner
C	150 x 1220 Sanding Belt	**I**	ON/OFF Switch
D	Sanding Belt Guard Lock Knob	**J**	Motor
E	Belt Guard	**K**	Stand
F	Disc Table	**L**	Dust Port

2. IMPORTANT INFORMATION

2.1 GENERAL WOODWORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation.

WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators.
Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer and death. Avoid breathing the dust, and avoid prolonged contact with dust. Some examples of these chemicals are:

- ❑ Lead from lead-based paints.
- ❑ Crystalline silica from bricks, cement and other masonry products.
- ❑ Arsenic and chromium from chemically-treated timber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

Safety glasses must be worn at all times in work areas. Earmuffs should be worn if the work area is noisy.

Sturdy footwear must be worn at all times in work areas.

Gloves should NOT be worn when operating machinery. Should only be worn when handling the material

Long and loose hair must be contained with a net or under a hat

2.1 2.1 GENERAL WOODWORKING MACHINE SAFETY Cont.

DISCONNECT POWER FIRST. If using power, always disconnect the machine from power supply before making adjustments, or servicing the machine. This prevents any risk of injury from unintended startup or contact with live wires.

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewellery that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of operating control.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave hex keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose. Do not force the machine or its attachments to do a job for which they were not designed. Never make unapproved modifications. Modifying the machine or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make operating control difficult. This could increase the risk of accidental injury

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

TRAINED OPERATORS ONLY. Only allow trained or supervised people to use this machine. When the machine is not being used, disconnect the power, to the machine to prevent unauthorized use—especially around children. Make the workshop safe.

FORCING MACHINERY. Do not force the machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if the machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify the machine is stable and if using a mobile base it is locked in position.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn the machine OFF and ensure all moving parts have completely stopped before walking away. Never leave the machine running while unattended.

MAINTAIN WITH CARE. Follow all the maintenance instructions and lubrication schedules to keep the machine in good working condition.
A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect the machine for any condition that may affect the safe operation. Immediately repair or replace damaged or parts that are incorrectly fitted before operating.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

2.2 SPECIFIC SAFETY FOR LINISHER SANDER

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual

Safety glasses must be worn at all times in work areas

Long and loose hair must be contained or restrained

Sturdy footwear must be worn at all times in work areas

Close fitting/protective clothing must be worn

Rings and jewellery must not be worn.

A mask must be worn when excessive airborne dust is created

PRE-OPERATIONAL SAFETY CHECKS

- ✓ Check the workroom and walkways to ensure there are no slip/trip hazards present.
- ✓ Ensure you are familiar with the operation of the ON/OFF DOL switch and emergency stop.
- ✓ Check the linishing belt is in a serviceable condition with no edge fraying, tears or holes.
- ✓ Ensure the operator be positioned out of direct line of abrasive belt at all times.
- ✓ Ensure dust extraction is on before operating sanding machine.
- ✓ Faulty equipment must not be used. Immediately report suspect machinery.
- ✓ Ensure material is well supported – use roller/support stand/s for longer lengths.

OPERATIONAL SAFETY CHECKS

- ✓ Allow machine to reach maximum revolutions before operating to avoid overloading.
- ✓ Hold material firmly against stops or table before applying pressure on abrasive belt.
- ✓ Keep fingers clear of the sanding belt while sanding.
- ✓ NEVER attempt to sand small items or try to sharpen metal items.
- ✓ Never leave the machine while it is running.
- ✓ Before making adjustments switch OFF and bring the machine to a complete standstill.

DON'T

- × DO NOT operate equipment without wearing appropriate PPE safety protection
- × DO NOT use the wrong type of belt or disc for the operation.
- × DO NOT attempt to sand very small items or use heavy pressure
- × NEVER leave the machine running unattended.
- × DO NOT use faulty equipment. Immediately report any suspect equipment & apply a "DO NOT USE" tag

POTENTIAL HAZARDS

- ❑ Exposure to moving, abrasive and rotating parts
- ❑ Eye injuries
- ❑ Pinch and squash
- ❑ Burns to skin
- ❑ Ejected waste
- ❑ Lung Damage
- ❑ Excessive dusts

3. POWER SUPPLY

3.1 ELECTRICAL INSTALLATION

Place the machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure there is access to a means of disconnecting the power source. The electrical circuit must meet the requirements for 240V.

NOTE : The use of an extension cord is not recommended as it may decrease the life of electrical components on your machine.

ELECTRICAL REQUIREMENTS

Nominal Voltage..... 240V
Cycle..... 50 Hz
Phase..... Single Phase
Power Supply Circuit..... 10 Amps
Full Load Current..... 3.1 Amps

(Full load current rating is also on the specification plate on the motor.)

3.2 FULL-LOAD CURRENT RATING

The full-load current rating is the amperage a machine draws when running at 100% of the output power. Where machines have more than one motor, the full load current is the amperage drawn by the largest motor or a total of all the motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating for these machine is available on the motor plate.

It should be noted that the full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating and if the machine is overloaded for a long period of time, damage, overheating, or fire may be caused to the motor and circuitry.

This is especially true if connected to an undersized circuit or a long extension lead. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements.

4 SET-UP

4.1 UNPACKING

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

NOTE: Save all the packaging materials until you are completely satisfied with the machine and have resolved any issues with the distributor, or the shipping agent.

When unpacking, check the packing list to make sure that all parts shown are included. If any parts are missing or broken, please contact your distributor.

4.2 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.

Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust preventive products.

It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

4.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

4.4 LIFTING INSTRUCTIONS

⚠WARNING ***This machine is very heavy. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance from another person when moving the shipping crate and removing the machine from the crate.***

On the day that the machine arrives, make sure that there is assistance available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.

4.5 ASSEMBLY

The machine must be fully assembled before it can be operated. First clean any parts that are coated in rust preventative to ensure the assembly process can proceed smoothly.

STAND ASSEMBLY

The L-69A comes with an open stand that needs to be assembled before installing the belt sander onto it.

1. Place the two lower long brackets parallel to each other and place the two lower short brackets on the long brackets. Align the holes on the lower short brackets with the two lower long brackets and attach them together using four bolts, four washers, four lock washers and four nuts. Hand tighten the nuts. Do not fully tighten at this time. (Fig. 4.1)

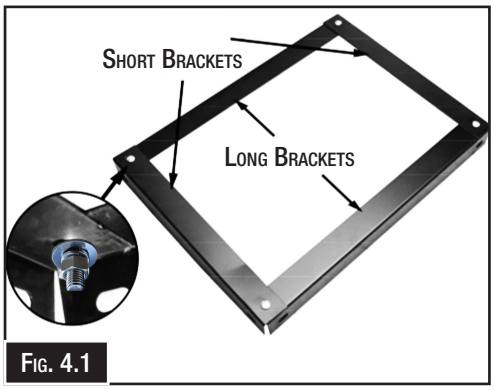


Fig. 4.1

2. Now attach the upper longer and shorter brackets together in the same manner. Place the upper shorter brackets with square holes on the upper longer brackets, securing them using bolts, washers, lock washers and nuts provided. Do not fully tighten the nuts. (Fig. 4.2)

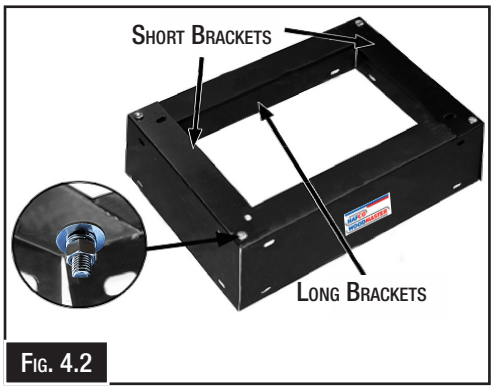


Fig. 4.2

3. Now, attach the four legs to the outside of the upper brackets assembly and secure them using bolts, washers, lock washers and nuts. Hand tighten the nuts at this time.Insert the lower brackets assembly between the four legs. Align the holes on the brackets with the holes on each leg and secure it using bolts, washers, lock washers and nuts. Hand tighten the nuts at this time. (Fig. 4.3)


Fig. 4.3

4. Once all four legs are attached to the brackets, fully tighten all the nuts using a wrench and make sure the stand is level from all four sides.

5. Place the stand upside down on the floor and attach the four rubber feet to the each leg securing it with the nuts and washers provided. (Fig. 4.4)

6. Place the stand up right and adjust the rubber feet making sure that the stand is level from all four sides and tighten the lock nuts on the rubber feet.


Fig. 4.4

4.5 ASSEMBLY Cont.

MOUNTING THE MACHINE ON TO THE STAND

1. Lift the sander up using a fork truck or any other mechanical device and align the four holes on the sander base with the holes on the four corners of the stand. Slowly, lower the machine onto the stand and secure it from underneath the stand using bolts and washers provided. (Fig. 4.5)

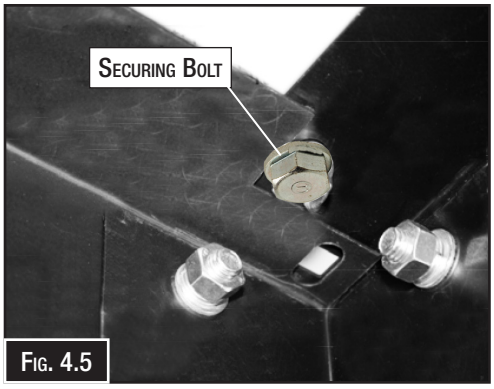


Fig. 4.5

INSTALLING THE DUST PORTS

1. Install the dust ports to the back of the sanding belt frame and to the bottom of the sanding disc cover using the screws and washers provided. (Fig. 4.6)

2. Once the dust ports are installed, attach the coupler to the sanding belt dust port.

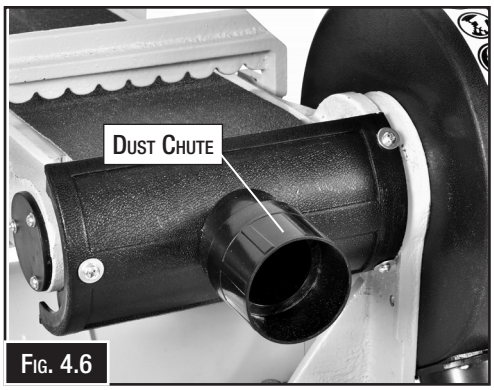


Fig. 4.6

INSTALLING THE TABLE

The table is most commonly installed to be used with the sanding disc but it can also be installed to be used with the sanding belt when the sanding belt is in vertical position.

1. Loosen the two cap screws shown in Fig. 4.7 and slide the table support rod into the hole, making sure that the flat surface of the rod is facing the two set screws.
2. Then tighten the two set screws.
3. Slide the table with its bracket onto the support rod as shown in Fig. 4.7, making sure that the flat surface of the rod is facing the set screws on the table bracket, and then tighten the set screws.

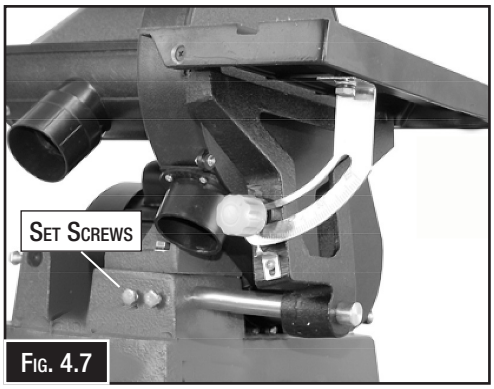


Fig. 4.7

NOTE: The table can also be used with the sanding belt when the belt is raised to its vertical position (Fig. 4.8)


Fig. 4.8

WARNING!

DO NOT operate any machine before it is fully assembled and all the safety guards have been fitted and secured. Failure to do so may cause death or severe injury.

4.5 ASSEMBLY Cont.

INSTALLING THE BACKSTOP

When the sanding belt is set for horizontal sanding, the backstop should be used to prevent the work piece flying out while sanding.

Install the backstop to the sanding platen as shown in Fig. 4.9 using screw and washer provided.

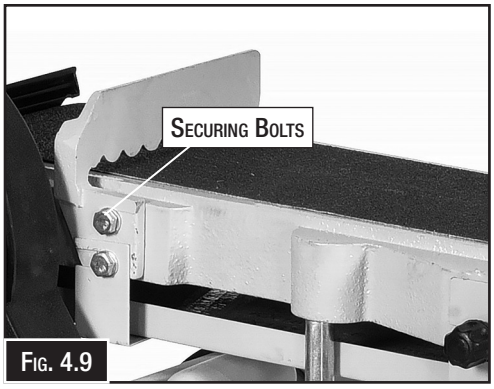


Fig. 4.9

5. OPERATION

This machine may perform many types of operations that are beyond the scope of this manual. Many of these operations may be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced operator before performing any unfamiliar operations. **Above all, your safety should come first!**

5.1 OPERATIONAL OVERVIEW

The typical operation, consists of the following:

1. Examine the workpiece to make sure it is suitable for sanding.
2. Inspect and install the correct sanding belt/disc with the appropriate grit for operation.
3. For sanding on the belt: Adjust the platen tilt as desired (and table/miter gauge, if used).

   For sanding on disc: Adjust the table tilt and or or miter gauge position to the desired location.
4. Secure loose clothing, remove loose jewellery, and tie back long hair.
5. Put on safety glasses and respirator. Take all other required safety precautions.
6. Start the dust collector, then turn the sander ON.
7. Hold the workpiece firmly against the back stop or table and miter gauge (if used), then slowly push the workpiece into the sanding belt or along the sanding disc on the down spin side of the disc. Move the workpiece back and forth to wear the belt or disc evenly and to prevent overheating.
8. Turn the sander OFF, then stop the dust collector.

WARNING!

Abrasive belts are dangerous and can cause serious injury if fingers or clothing are caught in the belt. Take care to ensure that safety is followed at all times when operating the machine.

WORK-PIECE INSPECTION

The L-69A is designed to sand wood only. Do not use this machine to sand metals, glass or stone etc.

Before sanding, make sure to inspect the work-piece for nails, staples, small pieces of stone or metal and any other foreign objects.

Sanding the work-piece with this kind of objects can tear the sanding paper. For a safe sanding always inspect your workpiece carefully before cutting and wear eye protection.

Some woods with excessive finish or glue load up the sand paper and reduce its usefulness. Use an abrasive cleaner to clean the sanding paper.

SANDING TIPS

When sanding a flat surface, firmly hold the work-piece with both hands, keeping your fingers away from the sanding belt.

External curves must be sanded on the flat portion of the sanding belt. Internal curves must be sanded on the roller portion of the sanding belt.

Make sure to move the work-piece equally along the sanding belt and use the miter gauge for precise work.

To sand a perfectly straight edge, make sure the belt table is perfectly square with the sanding belt.

The sanding disc turns much faster and removes more of the external edge. When sanding small flat surfaces or convex edges, disc sanding is the best way to achieve good results.

5.2 CHOOSING BELT AND DISC MATERIAL

The L-69A uses a 150 x 1220mm sanding belt and a 230mm sanding disc. Below is a chart with suggested abrasive grits sizes and their application.

Grit	Group	Application
40	Extra Course	Rough sawn timber, thickness sanding, and glue removal.
60	Course	Thickness sanding and glue removal
80 ~ 100	Medium	Removing marks and initial finish sanding
120 ~ 180	Fine	Finish sanding

Hafco/Woodmaster recommend using aluminum-oxide sanding belts and discs for best results. The grit size will depend on the condition and type of wood, and the level of finish you wish to achieve.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers. Avoid skipping grits; the larger the grit increase at one time, the harder it will be to remove the scratches from the previous grit.

Ultimately, the type of wood you use and your stage of finish will determine the best grit types to used on the sander.

WARNING!

A moving belt or disc can cause serious personal injury if it comes in contact with your fingers, hands, or other body parts. Always support the workpiece against the table, back stop, or miter gauge when sanding. Use extreme care to provide a safe distance between sanding paper and any body part.

5.3 INSTALLING / REMOVING THE SANDING BELT

The L-69A comes with a 150 x 1220 sanding belt.

TO INSTALL/REMOVE THE SANDING BELT:

1. Make sure the switch is in the OFF position and the power cord is disconnected from the power source.
2. Remove the belt guard by removing the three lock knobs. (Fig.5.1)
3. Remove the dust port by removing the screws and washers securing the dust port to the sander frame.
4. Turn the belt tension handle to the left releasing tension on the belt. (Fig. 5.2)
5. Remove the old belt and install the new sanding belt onto the rollers. Make sure the arrow on the back of the sanding belt is pointing towards the sanding disc.
6. Once the belt is installed onto the rollers, turn the belt tension lever back to the right to tension the belt.

NOTE: The sanding belt should be centered on both rollers. Before installing the removed parts of the sander, the belt tracking adjustment should be performed to check and adjust the belt.

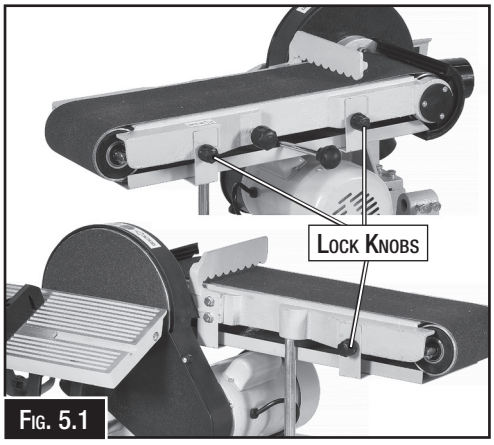


Fig. 5.1

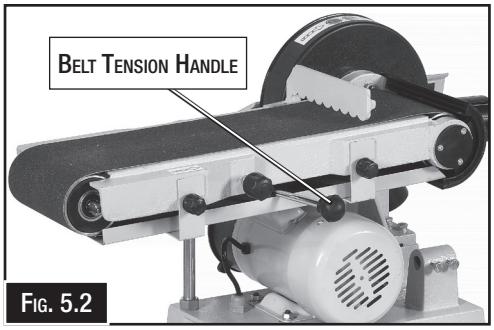


Fig. 5.2

5.4 BELT TRACKING ADJUSTMENT

Belt tracking means where the belt rides on the rollers. The belt should always be centered on both the rollers.

The L-69A sander is shipped with the belt tracking mechanism properly adjusted but in-perfections in different belt manufactures will require tracking adjustment.

When installing a new sanding belt, you will need to perform the belt tracking adjustment to center the belt on the rollers.

TO CHECK THE SANDING BELT TRACKING:

Turn the sander ON and see if the belt wanders to the left or right. Be prepared to immediately turn OFF the machine.

If the sanding belt is not riding the rollers on a centered path, adjustment is necessary

TO ADJUST THE SANDING BELT TRACKING:

1. Turn the sander ON and turn it OFF quickly.
2. Loosen the lock nut on the tracking knob.
3. Turn the tracking knob clockwise to move the belt towards the tracking knob and counter-clockwise to move the belt away. (Fig. 5.3)
4. Now, turn the sander ON and adjust the belt tracking with the sander ON.
5. Once the sanding belt is centered on both pulleys, re-tighten the lock nut. Turn OFF the sander.

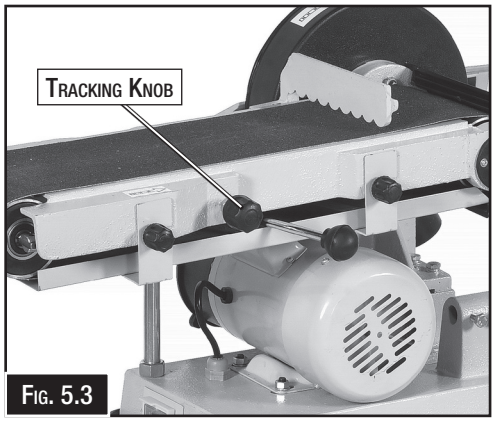


Fig. 5.3

5.5 INSTALLING / REMOVING THE SANDING DISC

The L-69A comes with a 230mm PSA (pressure sensitive adhesive backed disc).

TO CHANGE THE DISC

1. Make sure the switch is in the OFF position and the power cord is disconnected from the power source.
2. Remove the old sanding disc by peeling it off from the plate. A hair dryer can help release the glue. (Fig. 5.4)
3. Clean the plate before installing the new sanding disc and make sure there is no dust or debris on its surface.

NOTE: You may experience poor and unsatisfactory results, or the sanding disc may loose contact with the plate during operation if there is dust or debris on the plate surface.

4. Peel the paper at the back of the new sanding disc and install the sanding disc on to the plate. Make sure the sanding disc is centered and adheres completely flat against the plate.

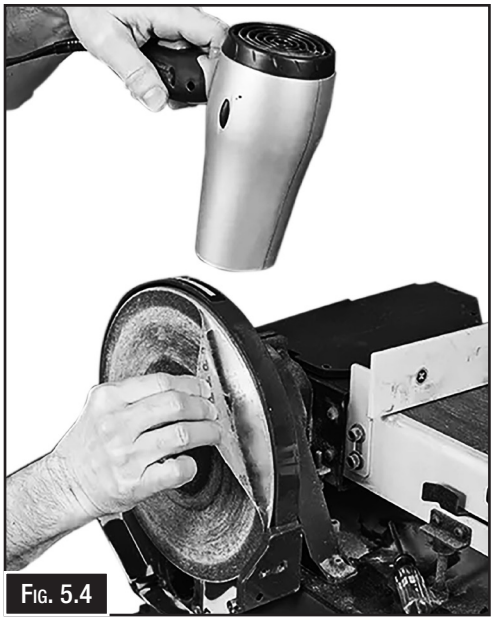


Fig. 5.4

5.6 DUST COLLECTION

The L-69A features two 2-1/2" dust ports to connect to a dust collector.

When connecting to a dust collector, use a proper sized hose and make sure all the connections are sealed tightly. (Fig. 5.5)

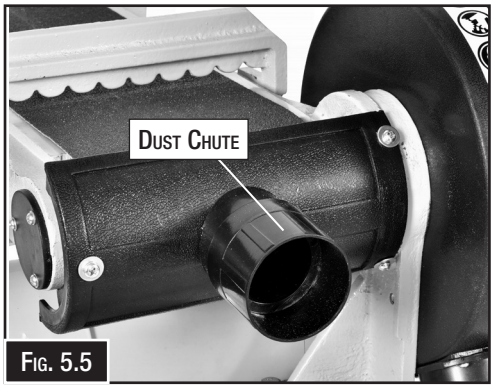


Fig. 5.5

OPTIONAL DUST COLLECTOR (Not Included)

DC-2 - Dust Collector (Order Code W332)

500cfm
Portable on wheels
Ø100mm single inlet
Quick-action clamps
5 Micron Fine Filter Bag
0.75kW / 1hp 240V motor
Magnetic safety switch

Hose Reducer
100 ~ 63mm
Order Code W334

Hose
100mm x 3metre
Order Code W3981

WARNING!

The fine dust particles produced by the woodworking machines can go inside your lungs and cause serious respiratory problems. Make sure to wear a dust mask and connect the machine to a proper dust collection system while operation.

5.7 ADJUSTING THE TABLE TILT

The work table can be tilted from 0° to 45° by loosening the lock knob shown in Fig 5.6 and tilting the table to the desired angle as indicated on the tilt scale and then re-tighten the lock knob.

CAUTION!

Never walk away from the machine while it is still running. Always lock the switch in the Off position and unplug from the power supply when not in use.

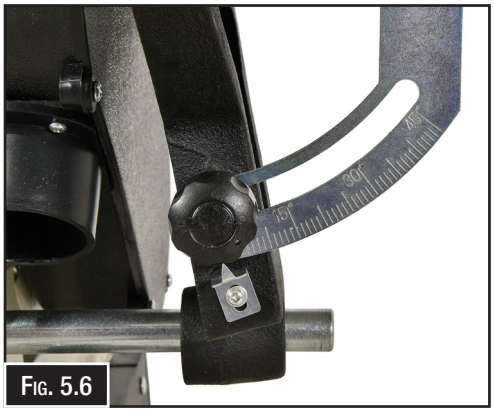


FIG. 5.6

5.8 HORIZONTAL & VERTICAL SANDING

The belt sander can be positioned vertically or horizontally and it can also be positioned at any angle in between, depending on the sanding needs.

TO ADJUST THE SANDING BELT ANGLE:

1. Make sure the switch is in the OFF position and the cord is disconnected from the power source.
2. Loosen the two lock nuts shown in Fig. 5.7 and slowly lift or lower the belt sander to the desired angle.
3. Re-tighten the lock nuts securing the belt sander in position.
4. To position the belt sander horizontally, Lower the belt sander completely until it sits on the stop bar shown in Fig. 5.8.
5. When using the belt sander in horizontal position, make sure to install the backstop to the sanding frame, so that the work-piece does not fly out.

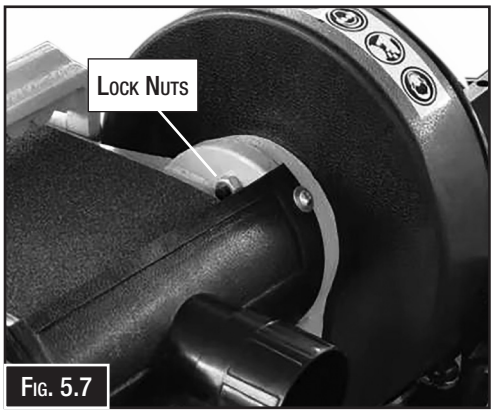


FIG. 5.7

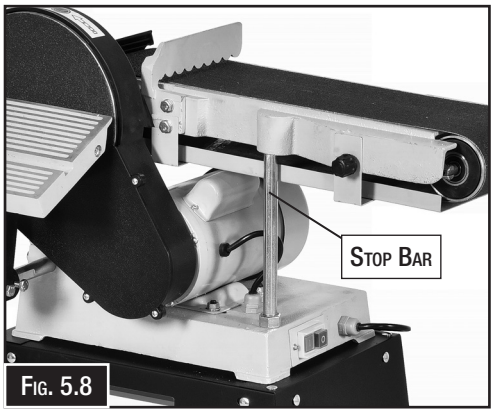


FIG. 5.8

CAUTION!

Before attempting this feature, disconnect the machine from the power supply to avoid injury to the operator from accidental startup, injury or death to the operator.

6. MAINTENANCE

During the lifetime of your machine, you will need to practice some regular maintenance to keep your sander in peak operating condition.

6.1 SCHEDULE

DAILY:

The sander should be checked daily for loose mounting bolts, damaged or worn belt or disc, damaged cord or plug, worn or damaged wires and any other unsafe condition before use.

Clean the machine daily after use, and when the machine is not in use turn the switch off and remove the power plug. The moisture from the wood dust remaining on the table surface can cause rust. The table and other un-painted surfaces of the machine should be cleaned and wiped after every use to make sure that there is no moisture against bare metal surface.

PERIODICALLY

A build-up of dust in the motor can cause motor damage. Periodic cleaning of the motor is not only recommended, but also mandatory for normal sanding performance. All bearings are permanently lubricated and require no further lubrication.

WARNING!

Make sure the machine is turned OFF and the cord is disconnected from the power source before installing/removing and servicing any component of the machine.

6.2 V-BELT TENSION & REPLACEMENT

The V-belt is pre-installed and tensioned at the factory but with prolonged use stretches and should be checked regularly for proper tension and belt condition.

TO REPLACE AND TENSION THE V-BELT:

1. Make sure the switch is in the OFF position and disconnect the cord from the power source.
2. Remove the work table from the sanding disc if installed.
3. Remove the sanding disc cover.
4. Remove the sanding disc, then remove the screw securing the sanding disc plate and remove the plate. (Fig.6.1)
5. Loosen the four motor mounting lock nuts securing the motor.
6. At this point the V-belt should be loose enough to slip it off the pulleys. Replace the V-belt with a new one and install it on the pulleys.
7. Re-install the sanding disc plate and secure it with the screw removed.
8. Tension the V-belt by moving the motor away from the sanding disc and tighten the motor mounting lock nuts.
9. Push the centre of the V-belt; with moderate pressure, there should be a 6 mm deflection (Fig. 6.2).

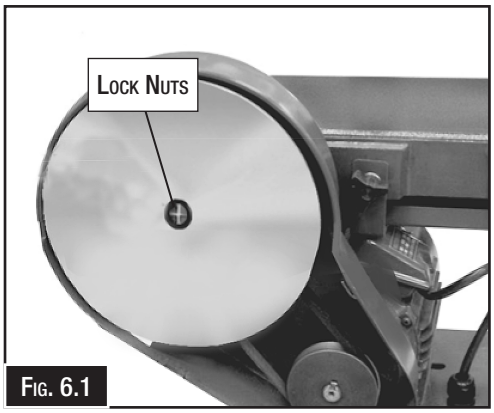


Fig. 6.1

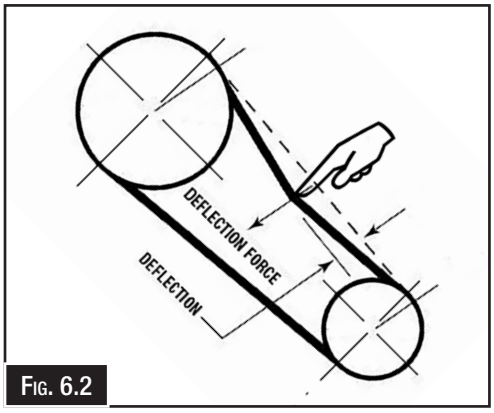


Fig. 6.2

6.3 TROUBLESHOOTING

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts then follow the procedure in the beginning of the spare parts section or if additional help with a procedure is required, then contact your distributor.

Note: Make sure you have the model of the machine, serial number,and manufacture date before calling.

Symptoms	Possible Cause	Possible Solution
The machine will not start	1. Unplugged from power supply 2. Protector is tripped 3. Power cord is damaged	1. Check all plug connections 2. Replace fuse or reset circuit breaker 3. Replace cord
Belt does not come up to speed	1. Extension cord too light or too long 2. Motor is not wired for proper voltage 3. Low current	1. Replace with adequate size and proper length cord 2. Refer to motor junction box for proper wiring 3. Contact a qualified electrician
Machine vibrates excessively	1. Stand on uneven floor 2. Motor mounts are loose 3. Belt Tension not correct	1. Adjust base so that it rests evenly on the floor 2. Tighten motor mount bolts. 3. Re-tension the V-belt
Abrasive belt keeps tearing	1. Belt is running in the wrong direction	1. The sanding belt should be running in the same direction as the rotation label.
Sanded edge not square	1. Table isn't square to sanding platen	1. Use a square to adjust table to the sanding platen
Sanding marks on workpiece	1. Workpiece is held still 2. Wrong grit sanding belt 3. Feed pressure too great 4. Sanding against the grain	1. Keep workpiece moving 2. Use coarser grit for stock removal and fine grit for finish sanding. 3. Never force the workpiece into sanding platen 4. Sand with the grain
Grains easily rub off belt.	1. Belt has been stored in damp environment. 2. Belt has been smashed or folded. 3. Replacement belt is too old.	1. Replace damaged belt. Store belt in a cool, dry area. 2. Replace damaged belt. Do not bend or fold belt. 3. Use new belt.
Deep sanding grooves or scratches in workpiece.	1. Excessive pressure while grinding. 2. Workpiece held still for too long against belt. 3. Belt too coarse. 4. Platen worn.	1. Reduce feed workpiece pressure. 2. Keep workpiece moving while grinding. 3. Use finer grit belt. 4. Replace platen.
Snake-shaped marks on workpiece.	1. Belt loaded up. 2. Belt damaged. 3. Platen worn.	1. Clean belt. 2. Replace belt. 3. Replace platen.
Belt clogs quickly.	1. Excessive pressure while grinding. 2. Belt worn or damaged. 3. Workpiece material is prone to belt clogging, such as soft aluminum.	1. Clean belt, and then reduce workpiece pressure. 2. Replace belt. 3. Reduce feed pressure. Use coarser-grit belt.

WARNING!

Always disconnect the power to the machine before servicing or doing maintenance to the machine.

WARNING!

When operating a Sander 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.

BELT & DISC LINISHER SANDER
L-69A

Order Code: (L107)

Edition : 2.0
Date: (01/26)

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at anytime without notification.

HOW TO ORDER SPARE PARTS

1. Have your machines model number, serial number & date of manufacture on hand, these can be found on the specification plate mounted on the machine.

2. A scanned copy of your parts list/diagram with required spare part/s identified.

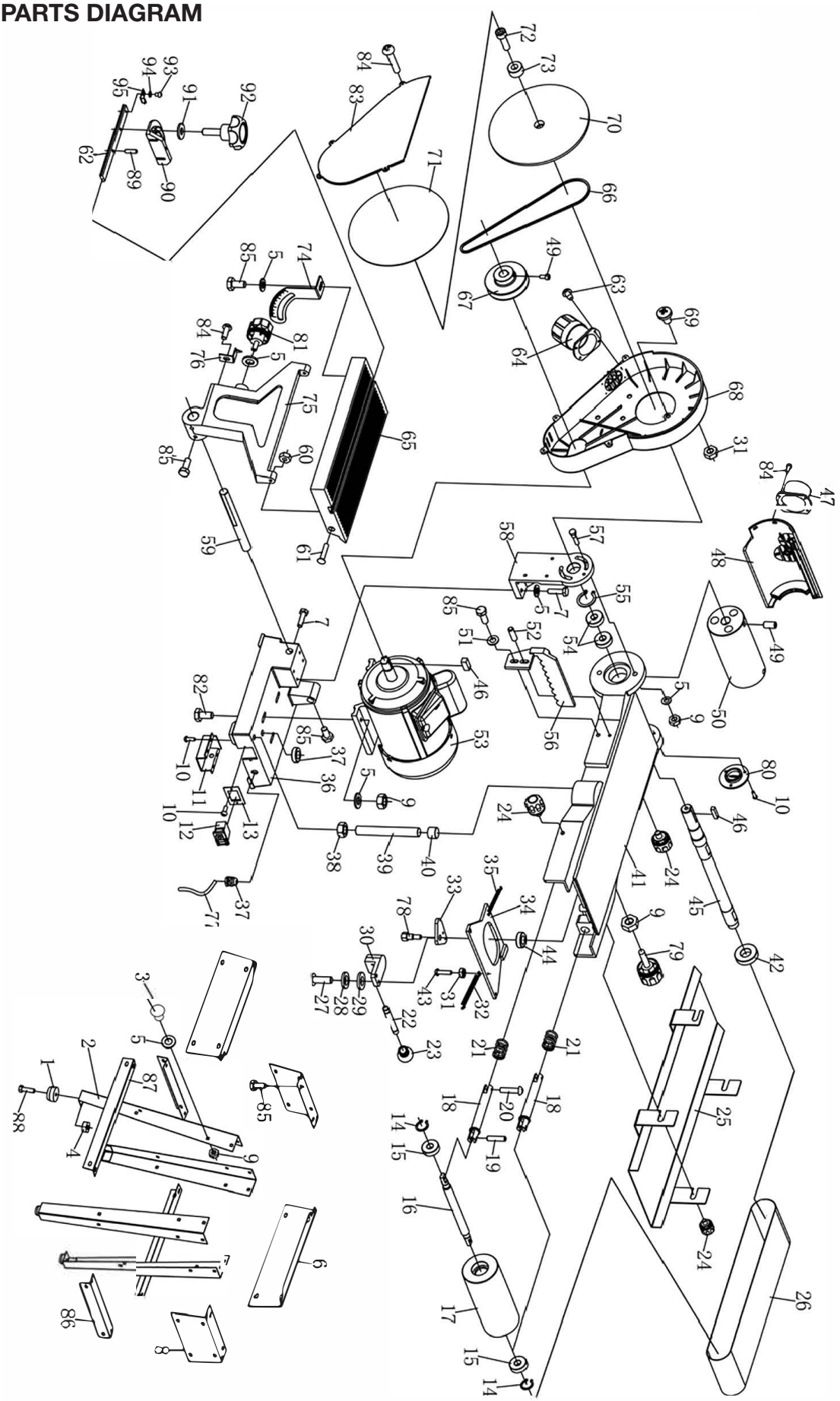
NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.

WARNING!
Electricity is dangerous and could cause death.
All electrical work must be carried out by a qualified electrician.

CAUTION!
It is impossible to cover all possible hazards Every workshop environment is different. These are designed as a guide to be used to compliment training and as a reminder to users prior to equipment use. Always consider safety first, as it applies to the individual working conditions.

SPARE PARTS DIAGRAM



SPARE PARTS LIST

ITEM	DESCRIPTION	SIZE	QTY	ITEM	DESCRIPTION	SIZE	QTY.
1	FEET		4	50	DRIVE ROLLER		1
2	LEG		4	51	WASHER		1
3	CARRIAGE BOLT	M8×12	20	52	PIN	A5×12	1
4	NUT	M6	6	53	MOTOR		1
5	FLAT WASHER	8	44	54	BEARING	80103	2
6	UPPER LONG BRACES		2	55	C-RING	35	1
7	BOLT	M8×30	6	56	WORK STOP		1
8	UPPER SHORT BRACES		2	57	SCREW		1
9	NUT	M8	20	58	PLATE BEARING		1
10	SCREW	M4×8	6	59	SUPPORT		1
11	SWITCH BOX		1	60	NUT	M6	2
12	SWITCH		1	61	SCREW	M6×30	2
13	FIXED PLATE		1	62	MITER BAR		1
14	C-RING	12	2	63	TAPPING SCREW	ST4.2×6	3
15	BEARING	80201	2	64	DUST PORT		1
16	IDLER ROLLER SHAFT		1	65	WORKTABLE		1
17	IDLER ROLLER		1	66	V-BELT		1
18	FULCRUM BAR		2	67	PULLEY		1
19	SPRING PIN	4×16	2	68	GUARD		1
20	SCREW	M5×16	2	69	SCREW	M8×12	4
21	SPRING		1	70	DISC PLATE	9”	1
22	HANDLE LEVER		1	71	ABRASIVE DISC	9”	1
23	HANDLE KNOB		1	72	SCREW	M6×16	1
24	KNOB A		3	73	WASHER B		1
25	BELT GUARD		1	74	ANGLE SUPPORT		1
26	ABRASIVE BELT	6” X 48”	1	75	TABLE SUPPORT BRACKET		1
27	SCREW	M5×16	2	76	POINTER		1
28	FLAT WASHER	5	2	77	PLUG		1
29	SPRING WASHER	5	2	78	BOLT		1
30	CONTROL AGENT		1	79	KNOB		1
31	NUT	M4	8	80	END CAP		1
32	SPRING		1	81	KNOB		1
33	CONTROL BLOCK		1	82	BOLT		3
34	ACTIVE PLATE		1	83	COVER PLATE		1
35	SPRING		1	84	SCREW	M4×16	5
36	BASE		1	85	BOLT	M8×16	10
37	STRAIN RELIEF		2	86	LOWER SHORT BRACKET		2
38	NUT	M16	1	87	LOWER LONG BRACKET		2
39	SUPPORT ROD		1	88	BOLT		4
40	SLEEVE		1	89	ROUND PIN		1
41	LAYER BOARD		1	90	MITER GAUGE BODY		1
42	BEARING	80102	1	91	WASHER	Φ15	1
43	SCREW	M4×12	2	92	KNOB		1
44	WASHER		1	93	SCREW	M5×6	1
45	MAIN SHAFT		1	94	FLAT WASHER	5	1
46	KEY	B5×28	1	95	INDICATOR		1
47	DUST PORT		1				
48	DUST CAP		1				
49	SCREW	M8×12	3				

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

NOTES:

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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