

Please dispose of packaging for the product in a responsible manner. It is suitable for recycling. Help to protect the environment, take the packaging to the local amenity tip and place into the appropriate recycling bin.



Never dispose of electrical equipment or batteries in with your domestic waste. If your supplier offers a disposal facility please use it or alternatively use a recognised re-cycling agent. This will allow the recycling of raw materials and help protect the environment.

FOR HELP OR ADVISE ON THIS PRODUCT PLEASE CONTACT YOUR DISTRIBUTOR, OR SIP DIRECTLY ON:
TEL: 01509500400
EMAIL: sales@sip-group.com or technical@sip-group.com
www.sip-group.com

Ref: 02JUN2021

SIP INDUSTRIAL

machinery specialists since 1968

4” x 8”
Belt Disc Sander



01946

Please read and fully understand the instructions in this manual before operation. Keep this manual safe for future reference

Declaration of Conformity

We

SIP (Machinery Europe) Ltd
ASM Chartered Accountants
First Floor Block One
Quayside Business Park
Dundalk
County Louth
Republic of Ireland

As the manufacturer's authorised representative within the EC declare that the

4”x 8” Belt / Disc Sander - SIP Part. No. 01946

Conforms to the requirements of the following directive(s), as indicated.

2006/42/EC	Machinery Directive
2014/30/EU	EMC Directive
2011/65/EU & (EU)2015/863	RoHS Directive

And the following harmonised standard(s)

EN 55014-1:2017+A11
EN 55014-2:2015
EN IEC 61000-3-2:2019
EN 61000-3-3:2013+A1
EN 62841-1:2015

Signed: ……...

Mr P. Ippaso - Director - SIP (Industrial Products) Ltd Date: 02/06/2021.

CE

UK - DECLARATION OF CONFORMITY

Declaration of Conformity

We

SIP (Industrial Products) Ltd
Gelders Hall Road
Shepshed
Loughborough
Leicestershire
LE12 9NH
England

As the manufacturer within the UK, England, Scotland & Wales, declare that the

4" x 8"Belt Disc Sander - SIP Part No 01946

Conforms to the requirements of the following directive(s), as indicated.

Electromagnetic Compatibility Regulations 2016
Supply of Machinery (Safety) Regulations 2008
The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012

And The Relevant Harmonised Standard/s, Including

BS EN 55014-1:2017+A11
BS EN 55014-2:2015
BS EN IEC 61000-3-2:2019
BS EN 61000-3-3:2013+A1
BS EN 62841-1:2015

Signed: .....

Mr P. Ippaso - Director - SIP (Industrial Products) Ltd
Date: 02/06/2021

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SAFETY INSTRUCTIONS

IMPORTANT: Please read the following instructions carefully, **failure to do so could lead to serious personal injury and / or damage to the Belt Disc Sander.**
When using your belt disc sander, basic safety precautions should always be followed to reduce the risk of fire, electric shock, personal injury and / or damage to the belt disc sander. Read all these instructions before operating the belt disc sander and save this user manual for future reference.
SIP recommends that this belt disc sander should **not** be modified or used for any application other than that for which it was designed. If you are unsure of its relative applications do not hesitate to contact us and we will be more than happy to advise you.

The sander is only designed for sanding wood or wood composites - It is not designed for sanding metals.

KNOW YOUR BELT DISC SANDER: Read and understand the owner's manual and labels affixed to the belt disc sander. Learn its applications and limitations, as well as the potential hazards specific to it.
DO NOT USE THE BELT DISC SANDER IN DANGEROUS ENVIRONMENTS: Do not use your belt disc sander in damp or wet locations, or expose it to rain. Always provide adequate space around the belt disc sander.
KEEP CHILDREN AND UNTRAINED PERSONNEL AWAY FROM THE WORK AREA: All visitors should be kept at a safe distance from the work area.
STAY ALERT: Always watch what you are doing and use common sense.
DISCONNECT THE BELT DISC SANDER FROM THE MAINS SUPPLY: When not in use.
DO NOT ABUSE THE MAINS LEAD: Never pull the mains lead it to remove the plug from the mains socket. Keep the mains lead away from heat, oil and sharp edges. If the mains lead is damaged, it must be replaced by the manufacturer or its service agent or a similarly qualified person in order to avoid unwanted hazards.
HAVE YOUR BELT DISC SANDER REPAIRED BY A QUALIFIED PERSON: The belt disc sander is in accordance with the relevant safety requirements. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user.

- **DANGER!** Check that the belt disc sander is in sound condition and good working order. Take immediate action to repair or replace damaged parts.
- **USE RECOMMENDED PARTS ONLY** - Unapproved parts may be dangerous and will invalidate the warranty.
- **WARNING!** Only operate on a level and stable surface.
- **WARNING!** Do not allow untrained persons to operate the machine and do not operate the machine without all covers etc. correctly fitted.
- **WARNING! RISK OF ELECTRIC SHOCK.** Do not expose the belt disc sander to water spray, rain, dripping water or moisture of any kind.
- Do not move or handle the machine when it is running.

PARTS LIST….cont

106	Capacitor 12μF 450V	WD01-00100
107	Hex screw M6×25	WD01-00101
108	Capacitor support 2	WD01-00102
109	Capacitor 100μF 250V	WD01-00103
110	Disc plate	WD01-00104
111	Flat washer M4	WD01-00105
112	Hex screw M5×8	WD01-00106
113	Dust bag	WD01-00107
114	Position shaft	WD01-00108
115	Miter gauge pointer	WD01-00109
116	Hex nut M8	WD01-00110
117	Dust box cover	WD01-00111
121	Scale label left	WD01-00112
122	Scale label right	WD01-00113
123	Rotation label	WD01-00114
124	Belt tension label	WD01-00115
125	hex wrench	WD01-00116
126	Scale label	WD01-00117
127	Spring washer D40	WD01-00118
128	Spring washer M4	WD01-00119
129	Tooth lock washer M4	WD01-00120
130	Bearing bushing	WD01-00121
131	Spring pin 4X22	WD01-00122
132	Spring washer M6	WD01-00123
133	Disc work table Knob	WD01-00124
134	Hex screw M5×12	WD01-00125
135	Screw M4×10	WD01-00126
136	Spring washer M5	WD01-00127
137	Screw M5×10	WD01-00128
138	Flat washer M5	WD01-00129
139	Lock washer M4	WD01-00130
140	Flat washer M4	WD01-00131
141	Index plate scale	WD01-00132
142	Support locating plate	WD01-00133
143	Flat washer M8	WD01-00134

PARTS LIST….cont

69	Screw M4X12	WD01-00068
70	Belt exhaust	WD01-00069
71	Collector mounting shaft	WD01-00070
72	Hex screw M5×20	WD01-00071
73	Belt mounting plate	WD01-00072
74	End cap	WD01-00073
75	Mains lead	WD01-00074
76	Strain relief	WD01-00075
77	Preventer plate	WD01-00076
79	Relay	WD01-00077
81	Left end cap	WD01-00078
82	Key 5X5X15	WD01-00079
83	Washer	WD01-00080
84	Screw M6x16	WD01-00081
85	Sanding disc 150 grit	06837
85	Sanding disc 120 grit	06839
85	Sanding disc 60 grit	06841
86	Disc cover	WD01-00082
87	Screw M4×10	WD01-00083
88	Angle pointer	WD01-00084
89	Disc left support	WD01-00085
90	Handle assembly	WD01-00086
91	Disc work table	WD01-00087
92	Miter gauge bar	WD01-00088
93	Miter gauge	WD01-00089
94	Disc right support	WD01-00090
95	Bearing 6203RZ	WD01-00091
96	Rotor	WD01-00092
97	Screw M5×180	WD01-00093
98	Stator	WD01-00094
99	Hex nut M5	WD01-00095
100	Motor cover	WD01-00096
103	Switch	WD01-00097
104	Tube connector	WD01-00098
105	Capacitor support1	WD01-00099

SAFETY INSTRUCTIONS….cont

- Do not leave the machine unattended when in use. Switch the machine off and unplug from the mains supply before leaving the work area.
- Do not allow children or animals near the belt disc sander, particularly when in use.
- Ensure that the belt disc sander is correctly turned off when not in use and store in a safe, dry area, out of reach of children.
- Do not unplug the belt disc sander to switch it off - always use the on/off switch.
- ALWAYS locate belt disc sander on a stable and level surface.
- Never stand on the belt disc sander.
- DO NOT dismantle or tamper with the belt disc sander, as this may be dangerous and will invalidate the warranty.
- Always ensure that the belt / disc sander is turned off and that the mains lead is removed from the supply during all cleaning and maintenance procedures, and when changing the disc or tracking / changing the belt.

WARNING: Risk of Electric Shock!

- Use only the electrical power (voltage and frequency) specified on the model plate of the belt disc sander. If in doubt contact the manufacturer.
- Use only a three-prong, grounded outlet and where required.
- ALWAYS unplug the belt disc sander when not in use.
- Always wear approved eye protection.
- Always wear respiratory protection.
- it is advisable to ensure the operator as well as those in the area wear ear protection, particularly during extended periods of use.
- Never wear gloves, neck-ties, jewellery or loose clothing, and always contain long hair during operation.
- Support the work-piece with the mitre gauge, backstop or worktable.
- Maintain 1/16" maximum distance between table and sanding belt / disc.
- Avoid kickback by sanding in accordance with the directional arrows.
- Always mount the sander securely on a firm level surface.
- Do not expose the sander to rain or moisture.
- Always disconnect the sander from the mains supply before making repairs or adjustments.
- Do not move or handle the machine when it is running.

If a problem with the belt disc sander is experienced, or if the mains lead or plug become damaged, contact your distributor for repair.

If the charger is used in a place of work all rules and laws etc. relating to the use of portable electrical appliances should be followed.

SAFETY INSTRUCTIONS….cont

Safety Symbols Used Throughout This Manual.

Danger / Caution: Indicates risk of personal injury and/or the possibility of damage.

Warning: Risk of electrical injury or damage!

Note: Supplementary information.

Operational Safety.



When using the sander always ensure the operator as well as those in the area wear eye protection.



Sanding operations will cause dust to become airborne with the potential to be highly toxic; always wear a face mask during these operations, as well as ensuring the area is well ventilated. It is also highly recommended to use a dust collector to reduce airborne particles.



When using this sander, it is advisable to ensure the operator as well as those in the area wear ear protection, particularly during extended periods of use.

CAUTION: The warnings and cautions mentioned in this user manual can not cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be applied.

PARTS LIST….cont

35	Pin 5×10	WD01-00035
36	Screw M5×25	WD01-00036
37	Belt tracking knob	WD01-00037
38	Flat washer M6	WD01-00038
39	Rubber washer	WD01-00039
40	Adjust spring	WD01-00040
41	Belt frame	WD01-00041
42	Tension spring	WD01-00042
43	Sleeve	WD01-00043
44	Spring washer M12	WD01-00044
45	Bearing 6001RZ	WD01-00045
46	Idler shaft	WD01-00046
47	Idler pulley	WD01-00047
48	Belt tension assembly	WD01-00048
49	Hex screw M6×12	WD01-00049
50	Belt working table	WD01-00050
51	Big washer M6	WD01-00051
52	Miter gauge Knob	WD01-00052
53	Sanding belt 120 grit	07740
53	Sanding belt 60 grit	07744
54	Drive pulley	WD01-00053
55	Hex screw M8×12	WD01-00054
56	Collector shaft	WD01-00055
57	Screw M5×8	WD01-00056
58	Flat washer M5	WD01-00057
59	Work table angle point	WD01-00058
60	Belt frame connect	WD01-00059
61	Cord bushing	WD01-00060
62	Belt cover	WD01-00061
63	Pin 2x10	WD01-00062
64	Spring washer	WD01-00063
65	Connection plate	WD01-00064
66	Right cover	WD01-00065
67	Left cover	WD01-00066
68	Small pulley	WD01-00067

PARTS LIST

Ref No.	Description	SIP Part No.
1	Rubber Foot	WD01-00001
2	Screw M4×10	WD01-00002
3	Bottom Plate	WD01-00003
4	Screw M8×25	WD01-00004
5	Lock washer M8	WD01-00005
6	Flat washer M8	WD01-00006
7	Base	WD01-00007
8	Connect tube	WD01-00008
9	Big pulley	WD01-00009
10	Poly-v- belt	WD01-00010
11	Collector bearing 6000RZ	WD01-00011
12	Spring washer D26	WD01-00012
13	Screw ST4.2×15	WD01-00013
14	Fan cover	WD01-00014
15	Fan	WD01-00015
16	Big washer M5	WD01-00016
17	Spring washer M5	WD01-00017
18	Screw M5×16	WD01-00018
19	Fan Housing	WD01-00019
20	Screw M5×10	WD01-00020
21	Front cover	WD01-00021
22	Dust storage box	WD01-00022
23	Screw M5×8	WD01-00023
24	Exhaust cover	WD01-00024
25	Dust exhaust	WD01-00025
26	Hex nut M6	WD01-00026
27	Bag Clamp	WD01-00027
28	Clamp handle	WD01-00028
29	Screw M6×40	WD01-00029
30	Tooth lock washer M5	WD01-00030
31	Tension level	WD01-00031
32	Sleeve	WD01-00032
33	Tension handle	WD01-00033
34	Pin 5×8	WD01-00034

ELECTRICAL CONNECTION

WARNING! It is the responsibility of the owner and the operator to read, understand and comply with the following:
You must check all electrical products, before use, to ensure that they are safe.
You must inspect power cables, plugs, sockets and any other connectors for wear or damage.
You must ensure that the risk of electric shock is minimised by the installation of appropriate safety devices; A residual current circuit Breaker (RCCB) should be incorporated in the main distribution board. We also recommend that a residual current Device (RCD) is used. It is particularly important to use an RCD with portable products that are plugged into a supply which is not protected by an RCCB. If in any doubt consult a qualified electrician.

Connecting to the power supply:

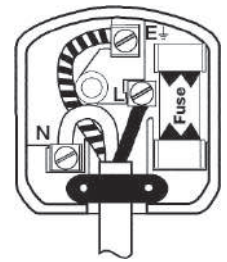
This SIP sander is fitted with a standard 230v ~ 13 amp type plug. Before using the machine, inspect the mains lead and plug to ensure that neither are damaged. If any damage is visible have the machine inspected / repaired by a suitably qualified person. If it is necessary to replace the plug a heavy duty impact resistant plug would be preferable.

The wires for the plug are coloured in the following way:

Yellow / green	Earth
Blue	Neutral
Brown	Live

As the colours of the wires may not correspond with the markings in your plug, proceed as follows: The wire which is coloured blue, must be connected to the terminal marked with N or coloured black. The wire which is coloured brown, must be connected to the terminal, which is marked L or coloured red. The wire which is coloured yellow / green should be connected to the terminal which is coloured the same or marked 

Always secure the wires in the plug terminal carefully and tightly. Secure the cable in the cord grip carefully.



ELECTRICAL CONNECTION….cont

Warning: Never connect live or neutral wires to the earth terminal of the plug. Only fit an approved plug with the correct rated fuse. If in doubt consult a qualified electrician.

Note: Always make sure the mains supply is of the correct voltage and the correct fuse protection is used. In the event of replacing the fuse always replace the fuse with the same value as the original.

Note: If an extension lead is required in order to reach the mains supply; ensure that this too is rated for the correct voltage and fuse rating.

Note: The cross section of the extension lead should be checked so that it is of sufficient size so as to reduce the chances of voltage drops.

GUARANTEE

Guarantee:

This SIP belt / disc sander is covered by a 12 month parts and labour warranty, covering failure due to manufacturers defects. This does not cover failure due to misuse or operating the sander outside the scope of this manual - any claims deemed to be outside the scope of the warranty may be subject to charges including, but not limited to parts, labour and carriage costs. Consumable items such as fuses, sanding belts and discs are not covered by the warranty.

In the unlikely event of warranty claims, contact your distributor as soon as possible. Proof of purchase will be required before any warranty can be honoured.

Note: Proof of purchase will be required before any warranty can be honoured.

EXPLODED DIAGRAM



TROUBLESHOOTING

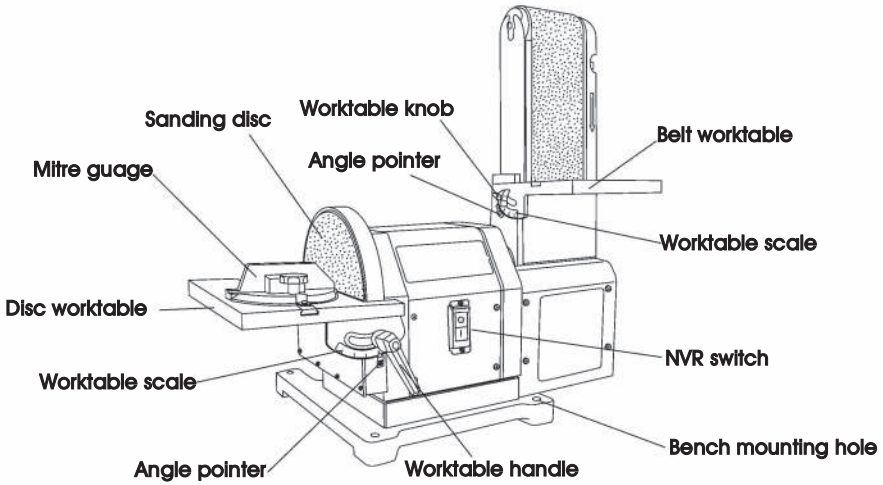
Problem	Possible cause	Suggested corrective action
Motor will not run.	1.Defective or broken ON/OFF switch. 2.Defective or damaged switch relay. 3.Defective or damaged switch cord. 4.Burned out motor. 5.Blown house fuse.	1-3.Replace all broken or defective parts before using sander. 4.Contact supplier for repair. 5.Replace house fuse. Turn OFF other appliances and power tools on the same circuit.
Machine slows down while sanding.	1.Operator applying too much pressure to work piece. 2.Dirt on wheels. 3.Worn or stretched belt.	1.Use less pressure in applying work piece to sanding surface. 2.Clean wheels. 3.Replace pulley belt.
Motor does not develop full speed.	1.Power line overloaded with lights, other tools, etc. 2.Long/wrong extension lead being used. 3.Incorrect fuses or circuit breakers in power line	1.Reduce the load on power line. 2.Replace with correct extension lead. 3.Install correct fuses or circuit breaker.
Sanding belt runs off pulleys.	1.Not tracking properly.	1.Adjust tracking (see pg15 tracking the belt).
Wood burns while sanding.	1.Sanding disc or belt glazed with sap. 2.Excessive pressure being applied to work piece.	1.Replace belt or disc. 2.Reduce pressure applied to work piece.
Motor overheats.	1.Motor overload.	1.Reduce motor load. Allow to cool off before restarting.
Dust Collection not working.	1.Collection bag is full. 2.Dust exhaust is blocked.	1.Empty collection bag. 2.Turn sander off and unplug. Remove bag and use a vacuum to remove sawdust blockage.

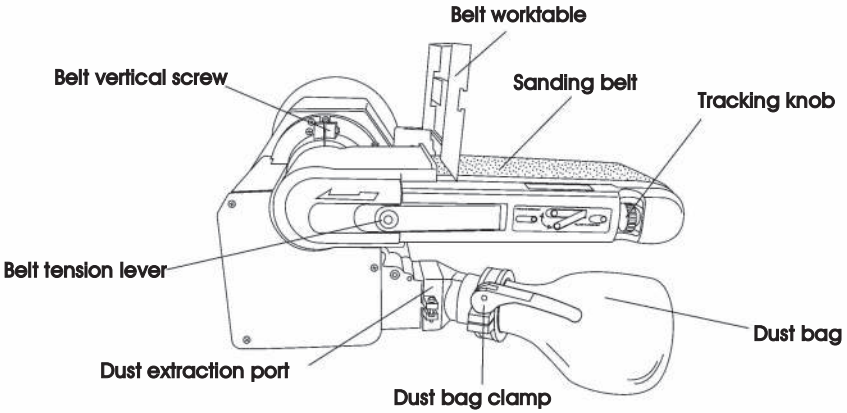
Note: Only use original spare parts, the use of non original parts is dangerous and will void your warranty.

TECHNICAL SPECIFICATIONS

Model No.	01946
Supply	230v ~ 50Hz
Power	500w (Induction motor)
Belt speed	550m/min
Disc speed	2850rpm
Disc workable tilt	0°-45°
Belt tilt	0°-90°
Disc size	8" (203mm)
Belt size	4" x 36" (100mm x 914mm)
Table size (Sanding disc)	264mm x 150mm
Table size (Sanding bed)	170mm x 125mm

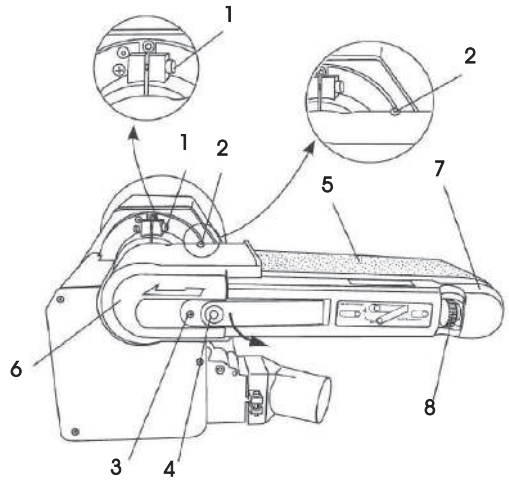
GETTING TO KNOW YOUR BELT / DISC SANDER





CARE AND MAINTENANCE….cont

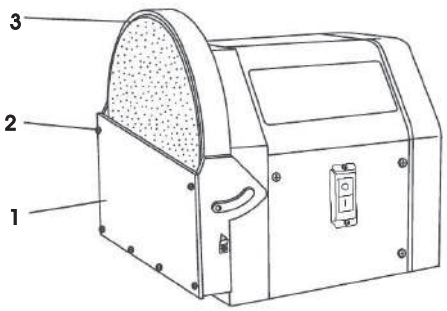
Fig. U

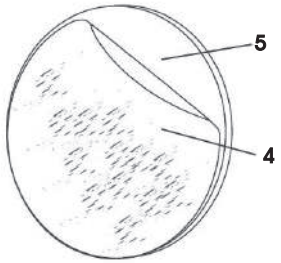


1.Remove the belt worktable.
2.Position the belt work support frame horizontally as shown in Fig. U; Loosen the inner hex screw (1) using a 5 mm hex wrench, turning it anti-clockwise. Do not remove the screw.
3.Remove the two screws (2, 3) using a screwdriver, and pull out the tension lever (4) to release the tension of the sanding belt (5). Remove the belt exhaust cover (6).
4.Remove the sanding belt (5) from both sanding drums (7).
5.Place new sanding belt over the sanding drums. Make sure the belt arrow located on the inside of the belt is pointed in the right direction.
6.Replace the belt exhaust cover (6) into position. Replace and tighten the two screws (2, 3) and push the tension lever (4) in to apply belt tension.
7.Track the belt by following the instructions on page 15.
8.Plug in the sander and turn the switch ON and OFF quickly to check if the sanding belt moves to either side. Re-adjust and fine-tune the tracking knob if necessary.

CARE AND MAINTENANCE….cont

1.Remove the disc worktable, and then remove the disc cover (1) by removing six screws (2).
2.Remove the existing disc, and clean any residue left on disc plate (3). Only use mineral spirits to remove this residue.
3.Peel the plastic (4) back from new sanding disc (5) and carefully press sanding disc firmly in position around the sanding plate. Make sure the disc is centered on the plate.
4.Reinstall the disc cover, tighten screws and place sanding table back on unit.



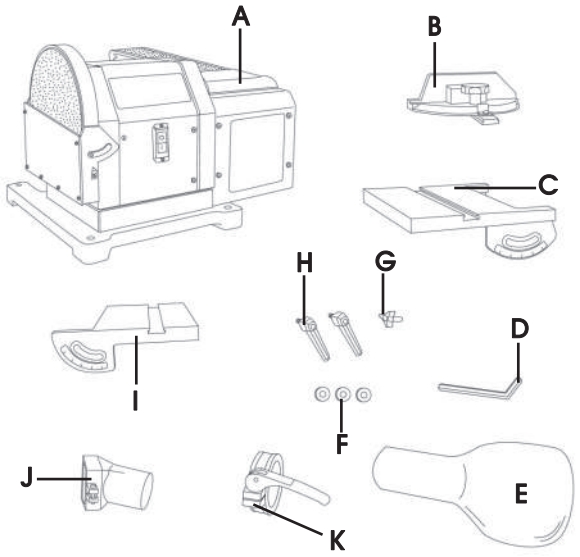


Replacing the sanding belt.

Note: For your safety, turn switch OFF and remove the mains lead from the electrical outlet before adjusting or performing maintenance on your sander.

Note: Use only sanding belts that measures 4 in. (102 mm) in width / 36 in. (914 mm) in length.

CONTENTS AND ACCESSORIES



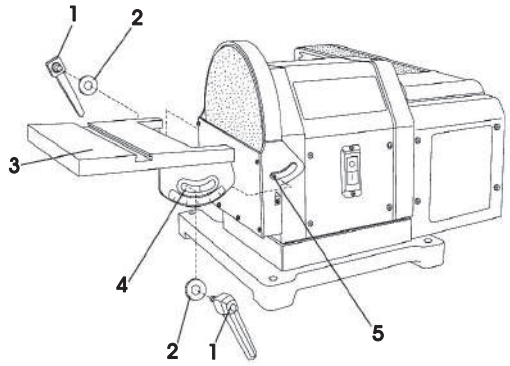
Ref.	Description	QTY
A	Belt / disc sander	1
B	Mitre guide	1
C	Disc worktable	1
D	Hex key	1
E	Dust bag	1
F	Washers	3
G	Knob	1
H	Lock handle	2
I	Belt worktable	1
J	Dust extraction port	1
K	Dust bag clamp	1

Note: If any of the above items are missing, contact your distributor immediately.

ASSEMBLY INSTRUCTIONS

Attaching the disc worktable.

1.Locate the worktable lock handles (1) and washers (2).
2.Place the worktable (3) onto the sander, aligning the semi-circle slot (4) and the threaded hole (5).
3.Put a washer (2) on the worktable lock handle (1), insert through the semi-circular slot (4), and then tighten into threaded hole (5), repeat on the other side of the table.



Note: Always check to make sure both handles are tight before beginning any sanding operations.

ASSEMBLEY INSTRUCTIONS….cont

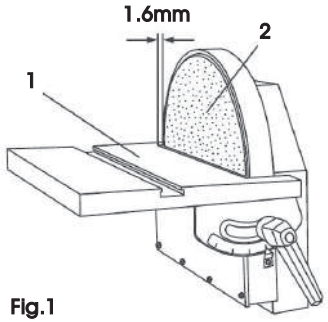
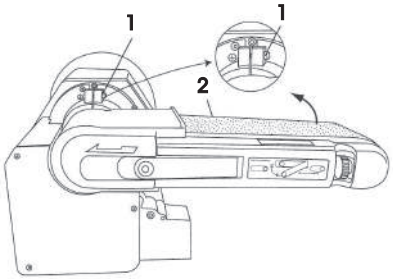


Fig.1

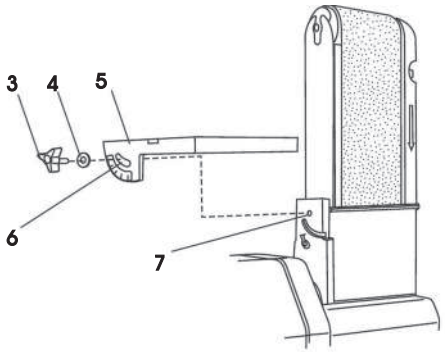
Caution: To avoid trapping the work piece or fingers between the worktable (1) and the sanding disc (2), leave a maximum gap of 1.6mm as shown in fig.1

Attaching the belt worktable.



1.Loosen the belt angle locking screw (1) using a 5mm hex key, raise the belt bed (2) into a vertical position, then re-tighten the screw.

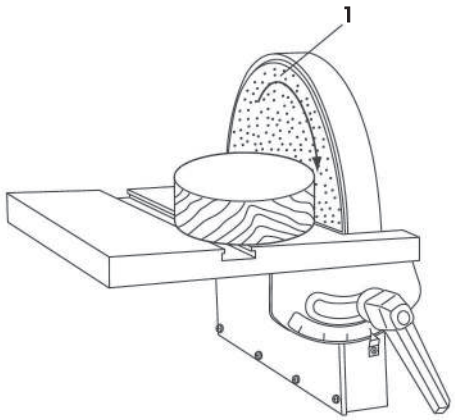
2.Locate the worktable knob (3) and washer (4).
3.Place the worktable (5) onto the sander frame, aligning the semi-circle slot (6) with the threaded hole (7).
4.Place a washer (4) onto the threaded shaft of the worktable knob (3).
5.Insert through semi-circular slot (6) and tighten into threaded hole (7).



Note: The belt worktable should be used to support work-pieces in all sanding operations except for inside curve applications.

OPERATING INSTRUCTIONS….cont

Sanding outside curves.



Freehand sanding of outside curves should be done on the sanding disc (1). Keep fingers a minimum of 1 in. (25.4 mm) from the sanding disc.

Note: Always sand on the right (downward) side of the sanding disc (1) as shown. Sanding on the left (upward) side of the sanding disc could cause the work piece to jump or kickback.

Note: The edge of the table must be positioned a maximum of 1.6 mm from the sanding disc to avoid trapping the work piece or fingers between the disc table and sanding disc.

CARE AND MAINTENANCE

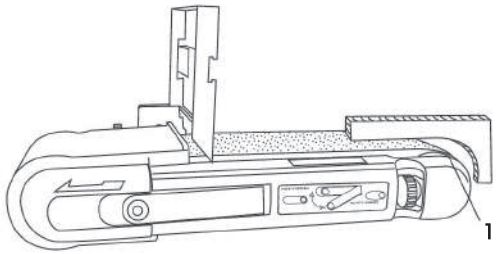
Replacing the sanding disc.

Note: To avoid injury, turn switch OFF and disconnect the plug from the power source before removing and installing sanding belt.

Note: A sanding disc is pre-mounted at the factory. Use only sanding discs that measures 8 in. (203 mm) in diameter.

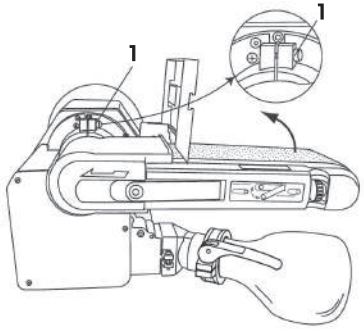
Sanding inside curves.

Note: To avoid injury, do not apply the end of the work piece to the idler drum (1). This could cause the work piece to fly up or cause kickback.

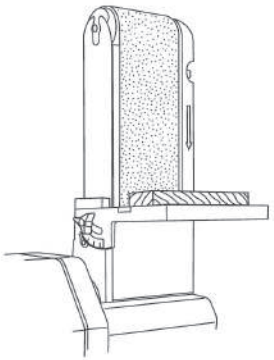


With care, freehand sanding of inside curves can be accomplished on the idler drum (1). Never attempt to sand the ends of a work piece on the idler drum (1).

Belt vertical sanding.



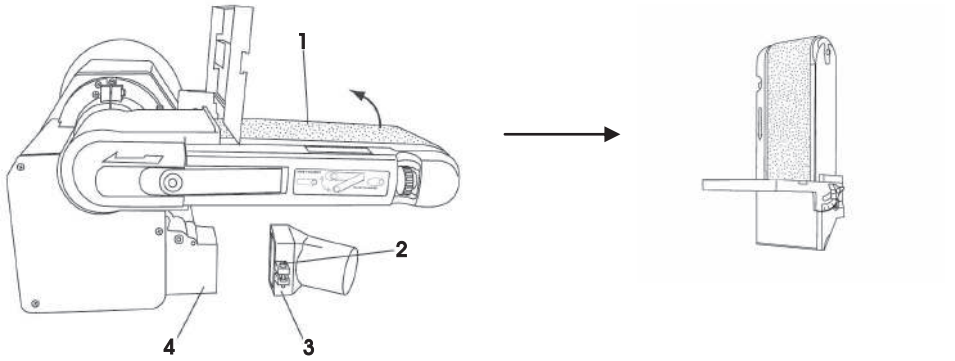
The belt / disc sander can sand vertically as well as horizontally. Depending on operator needs and the work piece, the worktable can be used with either the horizontal or vertical position.



1.Locate the 5 mm hex key.
2.Loosen the inner hex screw (1) by turning it anti -clockwise.
3.Manually move the sanding bed into the vertical or horizontal position, as required.
4.Re-tighten the inner hex screw (1) by turning it clockwise.

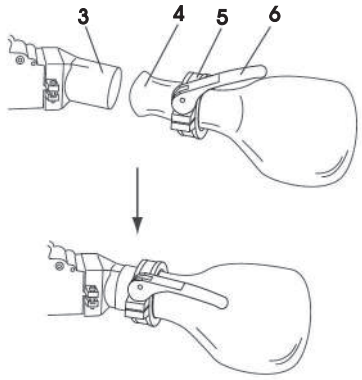
Attaching the extraction port.

1.Ensure that the belt bed (1) is in the vertical position (as shown on page12).
2.Loosen the hex screw (2) using a 5mm hex screw, attach the dust extraction port (3) onto the dust port (4), and re-tighten the hex screw (2).



Attaching the dust bag.

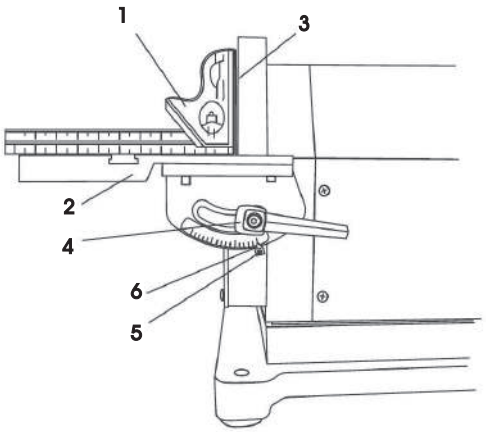
3.Insert the opening of the dust bag (4) into bag clamp (5).
4.Attach the dust bag (4) onto the dust port (3).
5.Tighten the bag clamp handle (7) clockwise one or two full turns before locking, do not over tighten.



Note: It is extremely important that the dust bag is connected to the machine before any sanding operations are carried out, we also recommend using a mask or respirator even when the dust bag is connected,

ADJUSTMENTS

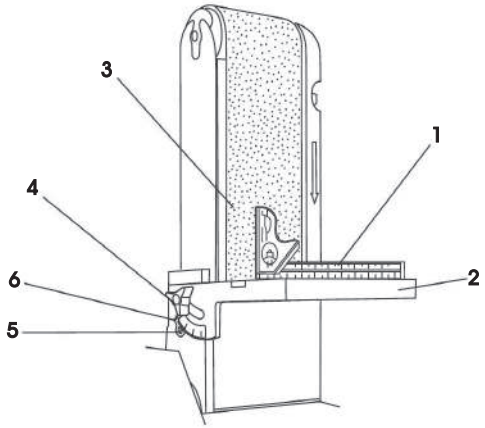
Adjusting the table square with the disc.



1.Using a combination square (1), place one side of the square on the disc worktable (2) with the other side against the sanding disc (3) to check to see if the disc worktable is at 90°.
2.If its not at 90°, loosen the lock handles (4).
3.Adjust the table square with the disc and re-tighten the lock handles (4).
4.Loosen the screw (5) and set the scale pointer (6) to 0°.

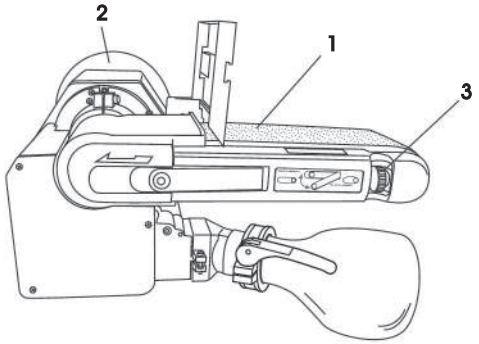
Adjusting the table square with the belt.

1.Again, using the combination square (1), place one side of the square on to the belt worktable (2), place the other side against the sanding belt (3) and check to see if its at 90°.
2.If its not at 90°, loosen the table lock knob (4), adjust the table square to the belt and re-tighten the lock knob.
3.Loosen the screw (5) and set the scale pointer (6) to 0°.



ADJUSTMENTS….cont

Tracking the belt.

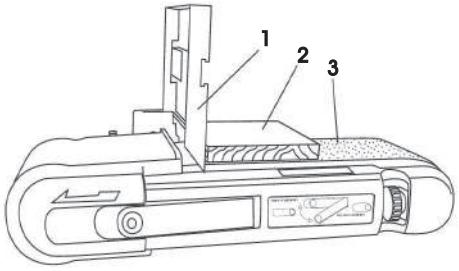


1.Turn the sanding belt slowly by hand, noting if the belt (1) tends to slide off the bed, and to which side front or back.
2.If it doesn't slide from side to side then the belt is tracked correctly.
3.Viewed from the switch end, if the sanding runs towards the disc (2), slightly turn the tracking knob (3) clockwise.
4.Viewed from the switch end, if the sanding belt runs away from the disc, slightly turn the tracking knob (3) anti-clockwise.
5.Readjust tracking knob another 1/4 turn, as necessary.

OPERATING INSTRUCTIONS

Note: This belt disc sander is designed only for sanding operations involving wood or wood derived products. It is not suitable for use with any type of metal - your warranty will be void if the sander is used for this purpose.

Belt horizontal sanding.



When using the sanding belt in the horizontal position, to perform surface or edge sanding, the belt worktable (1) must always be used. Always hold the work piece (2) firmly, keeping your fingers away from the sanding belt . Always keep the end of the work piece against the belt worktable (1) and move the work evenly across the sanding belt. Apply only enough pressure to allow the sanding belt to remove material. Use extra caution when sanding very thin pieces.