



**KING CANADA**

# **16" OPEN WIDE BELT SANDER**



**MODEL: KC-1632DS**

# **INSTRUCTION MANUAL**

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## IMPORTANT INFORMATION

<b>2-YEAR LIMITED WARRANTY FOR THIS 16" OPEN WIDE BELT SANDER</b>	<b>KING CANADA TOOLS OFFERS A 2-YEAR LIMITED WARRANTY FOR NON-COMMERCIAL USE.</b>
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### **PROOF OF PURCHASE**

Please keep your dated proof of purchase for warranty and servicing purposes.

### **REPLACEMENT PARTS**

Replacement parts for this tool are available at our authorized KING CANADA service centers across Canada. For servicing, contact or return to the retailer where you purchased your product along with your proof of purchase.

### **LIMITED TOOL WARRANTY**

KING CANADA makes every effort to ensure that this product meets high quality and durability standards. KING CANADA warrants to the original retail consumer a 2-year limited warranty as of the date the product was purchased at retail and that each product is free from defects in materials. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations and lack of maintenance. KING CANADA shall in no event be liable for death, injuries to persons or property or for incidental, special or consequential damages arising from the use of our products. To take advantage of this warranty, the product or part must be returned for examination by the retailer. Shipping and handling charges may apply. If a defect is found, KING CANADA will either repair or replace the product.

### **PARTS DIAGRAM & PARTS LISTS**

Refer to the Parts section of the King Canada web site for the most updated parts diagram and parts list.

# SAFETY RULES FOR WIDE DRUM SANDERS



## SAFETY RULES FOR WIDE DRUM SANDERS

1. **DURING NORMAL OPERATIONS**, there is a tendency for the tool to tip over, slide, or walk on the supporting surface. Always secure tool to workbench or workstand.
2. **NEVER PERFORM THE SANDING OPERATION** with the sanding drum dust cover or drive guard removed.
3. **NEVER MAKE A SANDING PASS** deeper than 1/64".
4. **DO NOT SAND MATERIAL** shorter than 3" or narrower than 3/4".
5. **MAINTAIN THE PROPER RELATIONSHIP** between the infeed and outfeed surfaces and the sander drum path.
6. **SUPPORT THE WORK PIECE ADEQUATELY** at all times during operation; maintain control of the work at all times.
7. **DO NOT BACK THE WORK** toward the infeed table.
8. **DO NOT ATTEMPT TO PERFORM** an abnormal or little used operation without the use of sturdy and adequate jigs, fixtures, stops, and a thorough understanding of the operation being performed.
9. **BEFORE STARTING**, recheck to make certain adjustments are correct and all locks and screws are tight.
10. **ALWAYS STOP THE MOTOR** and disconnect the power source before making any adjustments or changing abrasive strips.
11. **STOP THE MACHINE** and recheck the motor/drum mounting bolts and feed rollers for tightness after about 50 hours of operation. (See Figure 8.)
12. **DO NOT FORCE-FEED THE WORK PIECE** through the machine. Let the sander apply the proper feed rate.
13. **CHECK THE FEED BELT** occasionally to be sure there is no debris or sawdust between any components.
14. **SAND ONLY SOUND LUMBER**; there should be no loose knots and as few tight knots as possible. Make sure the work piece is free from nails, screws, stones, or other foreign objects that could damage the sanding drum or feed belt.
15. **NEVER STAND DIRECTLY IN LINE** with either the infeed or outfeed sides. Stand to one side.
16. **MAKE SURE THE ABRASIVE STRIP IS ATTACHED** as described in the operation instructions. An improperly attached abrasive strip could come loose during operation and damage the work piece or internal components.
17. **NEVER PUT YOUR FINGERS** into the dust port or under the drum dust cover. (See Figure 2.)
18. **ALLOW THE SANDING DRUM** to reach full speed before using the Wide Drum Sander.

### WARNING

**This drum sander has a maximum sanding capacity of 1/64" per pass.**

Taking off more than 1/64" may result in feed motor damage and voiding warranty.



## ELECTRICAL INFORMATION

### GROUNDING INSTRUCTIONS

1. In the event of an electrical malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.
  2. Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.
  3. Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
  4. Check with a qualified electrician or service personnel if the grounding instructions are not completely understood or if in doubt as to whether the tool or outlet is properly grounded.
  5. Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.
  6. Have a damaged or worn cord repaired or replaced immediately.
7. This tool is intended for use on a circuit that has an outlet like the one shown in Figure 1, Illustration A. The tool has a grounding plug that looks like the plug illustrated in Figure 1. A temporary adapter, like the one shown in Figure 1, Illustration B, may be used to connect this plug to a 2-pole receptacle as shown in Illustration B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. The green-colored rigid ear, lug, or wire extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.

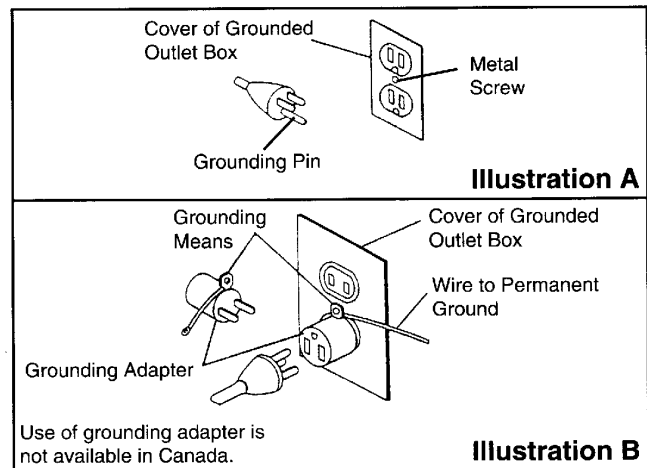


Figure 1

### EXTENSION CORDS

When using a power tool at a considerable distance from a power source, use an extension cord heavy enough to carry the current that the tool will draw. An undersized extension cord will cause a drop in line voltage, resulting in a loss of power and overheating. A minimum 12 AWG (gage) extension cord no longer than 50 feet in length may be used with this tool. Only round jacketed cords listed by Underwriter's Laboratories (UL) should be used.

When working with the tool outdoors, use an extension cord that is designed for outside use. This is indicated by the letters "WA" on the cord's jacket.

Before using an extension cord, inspect it for loose or exposed wires and cut or worn insulation.

Also, do not use an extension cord on a take up reel. The electric current passing through the extension cord will generate heat, and if the cord is wrapped around a reel, a heat buildup will result that could melt the insulation, causing a fire and/or electric shock.



**CAUTION:** Keep the cord away from the sanding area and position the cord so that it will not be caught on lumber, tools, or other objects during sanding.

## SAVE THESE INSTRUCTIONS



## INTRODUCTION TO DRUM SANDING

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### FUNCTION

Drum sanding, sometimes referred to as "abrasive planing," is a repetitive process of sanding both sides of wooden stock to a desired thickness and/or smoothness. When this process is performed correctly, both face surfaces will be parallel to one another.

**Do not confuse drum sanding with thickness planing!** Drum sanding gradually removes material in increments of 1/64" or less depending on sanding grit, stock hardness, stock width, etc. Thickness planing, on the other hand, is for quick, bulk material removal at rates up to 1/8" per pass with portable machines. If you have used a thickness planer to smooth and dimension stock you will quickly learn to work *with* your new drum sander and *not against* the machine. Be patient, let the drum sander do the work, 1/64" or less per pass for best results.

**The most common mistake made** with a drum sander is forcing it to remove too much material too fast. Variables such as sandpaper grit, stock width, wood type, feed rate, and moisture content all influence how much material can be removed in a single pass.

### DRUM SANDING ADVANTAGES

One advantage of the wide drum sander is that you can work with material up to 32" wide with the KC-1632DS because of its open side design. Although you still abrasive sand *with* the grain, you do not have to read the grain to prevent tear-out. This is especially important with thin stock and material with convoluted or mixed grain directions, like burl, crotch, and tiger patterns.

Drum sanders exert much less pressure on stock than a thickness planer, giving you the capability of working with very thin material. You have the ability to sand to veneer thickness if desired, expanding your woodworking horizons. You can also sand smaller length wood, odd-shaped pieces, and end-grain.

### REMOVING LUMBER CUP

The ideal machine for removing cup from lumber is a jointer. However, because of the minimal pressure exerted by the drum sander, it is possible to remove cup, since the lumber is not compressed flat on feed belt and table. Be patient, this process can take quite a while depending on cup depth. Feed the stock into the machine cup crown up (edges resting on feed belt) and use a coarse grit abrasive. Repeat until the crown is flat. With one face now flat, flip the board over and sand it flat. Do not be shocked by how thin the board may become after all cup has been removed.

Board warp and twist will not be remedied by a drum sander, or a planer, for that matter. Always inspect your lumber for warp and twist before drum sanding since it is prone to hanging-up in the machine, shorter length lumber in this condition is especially troublesome.



## PLANNING & UNPACKING

### PLAN YOUR WORK IN ADVANCE

Planning your drum sanding operations in advance will minimize setups, work time, and frustration level. Group material to be sanded by thickness and grit requirements and work through each required sanding grit starting with the thickest material through the thinnest, then change over to next finer grit and begin the process again.

We suggest that you experiment with the various sanding grits and wood species to determine the results you can expect before ruining project material. With new set-ups, always test with scrap lumber before sanding your project material.

### WOOD SPECIES TO BE CAUTIOUS WITH

Highly resinous species will tend to quickly clog (load-up) abrasives and in many cases abrasive loading cannot be removed with belt cleaning sticks. The most notorious abrasive loaders are some common pine species. It is nearly impossible to clear the abrasive of the pitch, sap, sawdust combination.

Be aware of species that have toxic properties, such as members of the rosewood family (*i.e. cocobola*). Despite dust control, you may inhale small airborne particulate or suffer allergic reactions through handling of stock. Wear a mask and gloves for extra protection.

## UNPACKING

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1. Carefully remove all parts from the shipping carton.
2. Do not discard the packing materials until you have identified all the parts using the *Loose Parts List*.
3. If you are missing a part, contact your dealer to obtain it.
4. Examine all parts to make sure that no breakage has occurred during shipping. Any damaged parts should be replaced before attempting to use the tool.

### Loose Parts List

The following items are included with the Wide Drum Sander:

- 1 - 4 mm hex wrench key
  - 1 - 6 mm hex wrench key
  - 1 - 10/12 mm open-end wrench
  - 2 - Conveyor table height adjustment shims (.010" each, see alignment procedure)
  - 1 - Owner's Operating Manual
  - 1 - Height adjustment handle
  - 1 - Height adjustment crank
- (See Figure 4.)

# FEATURES



## FEATURES

Familiarize yourself with the following components and features of the Wide Drum Sander using Figures 2, 3, and 4 before connecting the power cord or using the tool.

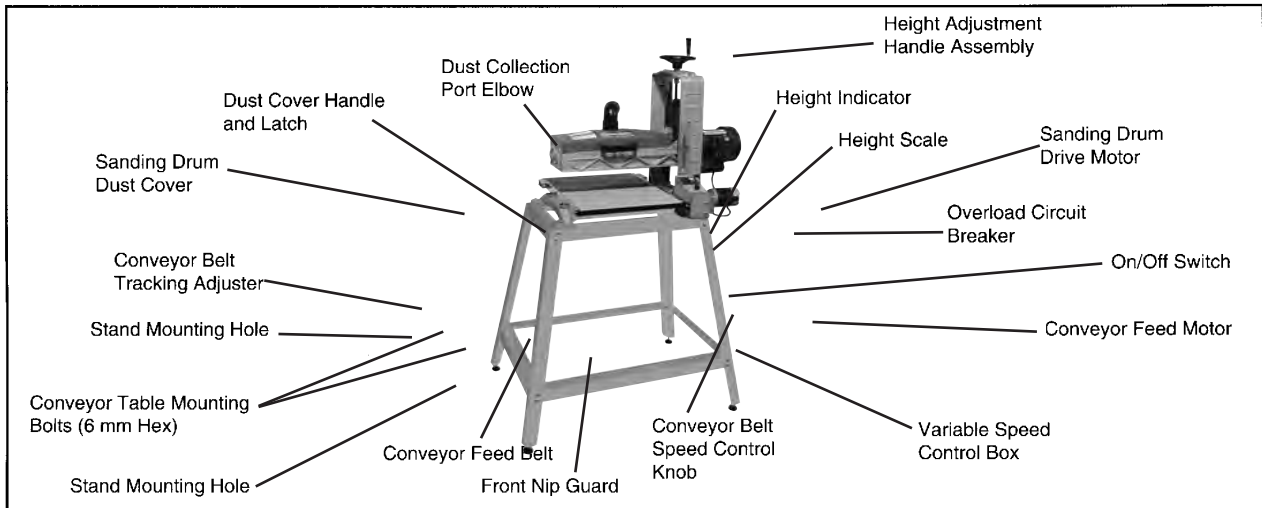


Figure 2

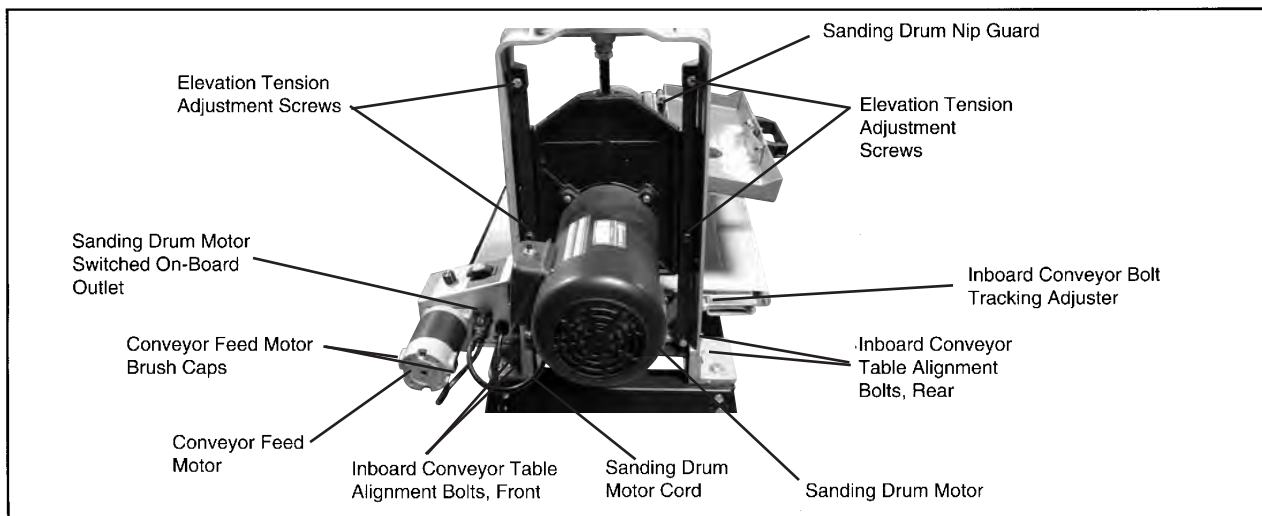


Figure 3

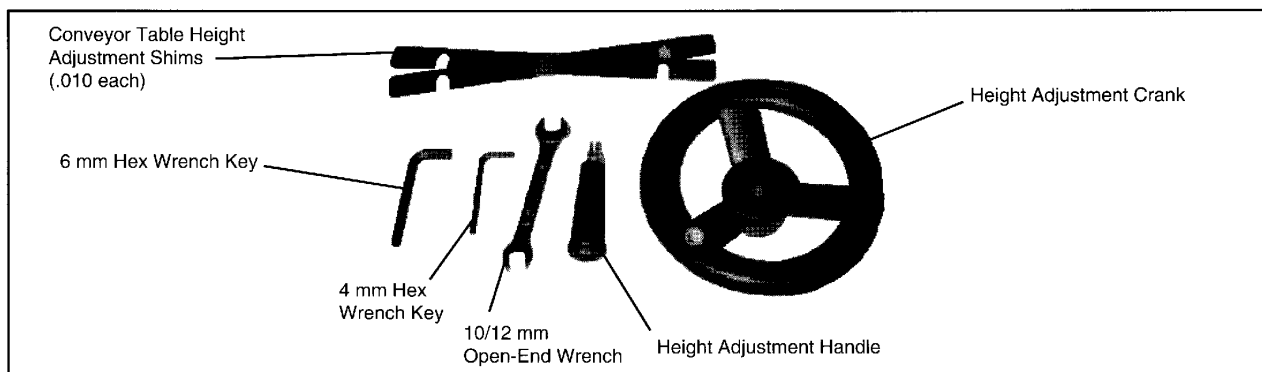


Figure 4



## ASSEMBLY

### ASSEMBLY

After unpacking your KC-1632DS Wide Drum Sander and checking the Loose Parts List for missing components, you are ready to assemble and install the Height Adjustment Handle Assembly.

1. Screw the Height Adjustment Handle into the threaded nut in the Height Adjustment Crank using a slotted screwdriver until snug. (See Figure 5.)
2. Locate the 4 mm set screw threaded into the side of the Height Adjustment Crank. Position the Height Adjustment Crank over the Height Adjustment Shaft with the set screw aligned with the machined flat area on the Height Adjustment Shaft. (See Figure 6.)
3. Lower the Height Adjustment Handle Assembly onto the Height Adjustment Shaft and tighten the set screw with the supplied 4 mm Hex Wrench Key. (See Figure 7.)
4. Secure the assembled Wide Drum Sander to the accessory workstand or to an adequately stable workbench or stand before operating the machine.

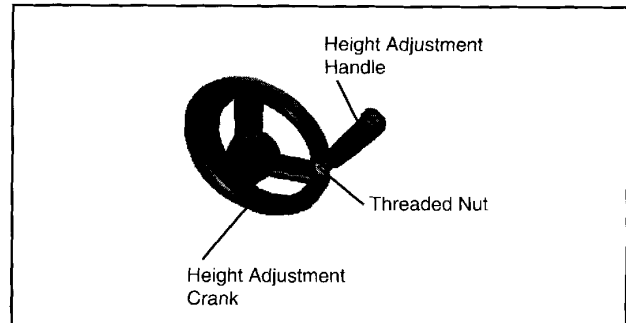


Figure 5

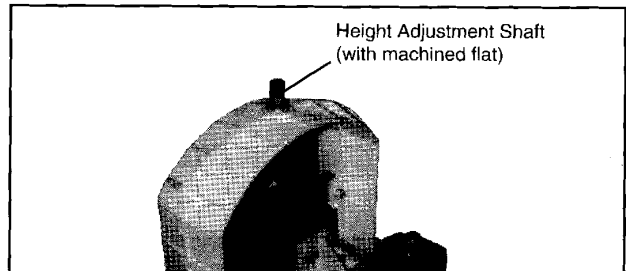


Figure 6

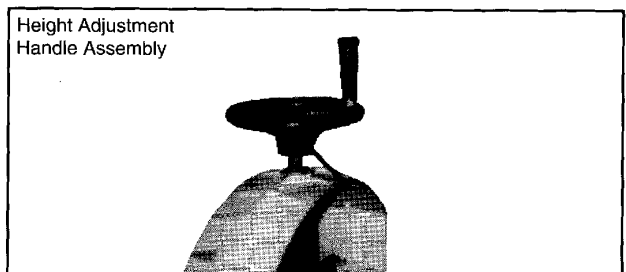


Figure 7



**WARNING:** To prevent possible serious personal injury, always disconnect the Wide Drum Sander from the power source before servicing the unit or changing the abrasive strips.



**WARNING:** For your own safety, never connect the plug to a source outlet until you have read and understand the safety and operating instructions for your Wide Drum Sander.



**WARNING:** Make certain that the switch is in the OFF position before inserting the plug into a power source. Do not connect the power until you are ready to operate the machine. Be sure that the bolts are firmly tightened before connecting to power source.



**CAUTION:** The surface to which the Wide Drum Sander is mounted must not be warped or uneven. Mounting the base to a warped surface will cause distortion and poor operation.



## ADJUSTMENTS

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Your **King** Wide Drum Sander was aligned and completely adjusted during assembly. However, due to stresses imposed on the unit during shipment, you may need to adjust or align your unit to return it to perfect alignment. It is very important that the following adjustments be performed as described.



**WARNING:** Never make any adjustments with the unit connected to the power source. Failure to heed this warning can result in serious personal injury.



**WARNING:** Always secure tool to workbench or workstand to avoid tendency for tool to tip over, slide, or walk on the supporting surface. Failure to secure tool can result in serious personal injury.

### SANDING DRUM DEFLECTION

Before beginning the sanding drum alignment procedures outlined in the following section, ensure that minimal upward deflection of the sanding drum occurs when sanding. The three primary causes of excessive sanding deflection are:

1. **Excessive depth of cut.** Decrease the depth of cut to minimize pressure on the sanding drum assembly. Refer to the *Introduction to Drum Sanding* section for hints regarding depth of cuts.
2. **Loose Elevation Tension Screws.** Refer to Step 1 in the *Drum Alignment* section for correct adjustment procedure.
3. **Loose Motor/Sanding Drum Assembly Mounting Bolts.** (See Figure 8.) Check the tightness of the four (4) bolts, 2 upper and 2 lower, and tighten as needed.

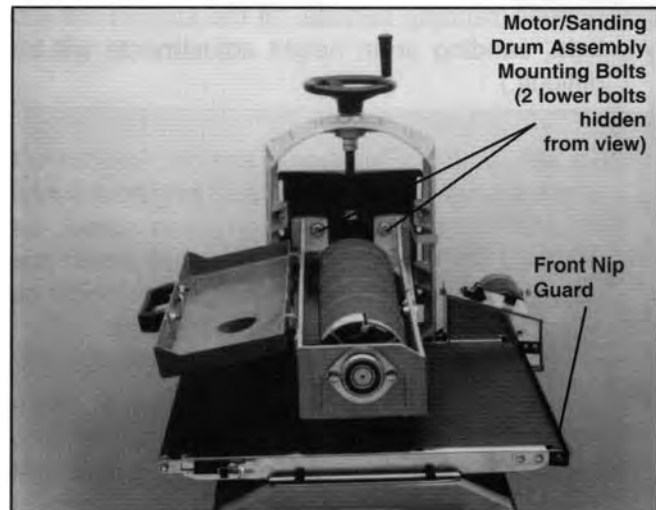


Figure 8



## ADJUSTMENTS

### DRUM ALIGNMENT



**WARNING:** To prevent possible serious personal injury, always disconnect the Wide Drum Sander from the power source before servicing the unit, aligning, or making any adjustments.

1. Check the tightness of the Elevation Tension Adjustment Screws (Figure 9). The tightness of these screws must be adjusted to allow smooth height adjustments, while ensuring a tight enough fit to limit drum deflection. (If the screws are too loose, the drum will deflect during use, causing an uneven sanding surface. If the screws are too tight, sanding drum height adjustments will be difficult.)

To adjust the Elevation Tension Adjustment Screws, loosen the locknuts, securing each screw in place. Loosen or tighten each screw, as required, in 1/4 turn increments to attain the desired fit and smoothness. Retighten the locknuts to secure the tension screws in position.

2. Check the sanding drum to conveyor table alignment by first removing the abrasive strip from the drum. The purpose of this adjustment is to achieve equal distances at point A and point B which will ensure that the drum is parallel to the feed table and provide uniform sanding. (See Figures 10 and 11.)

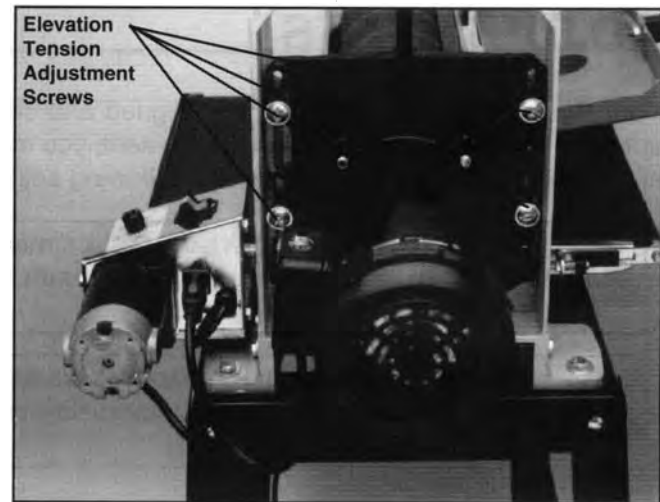


Figure 9

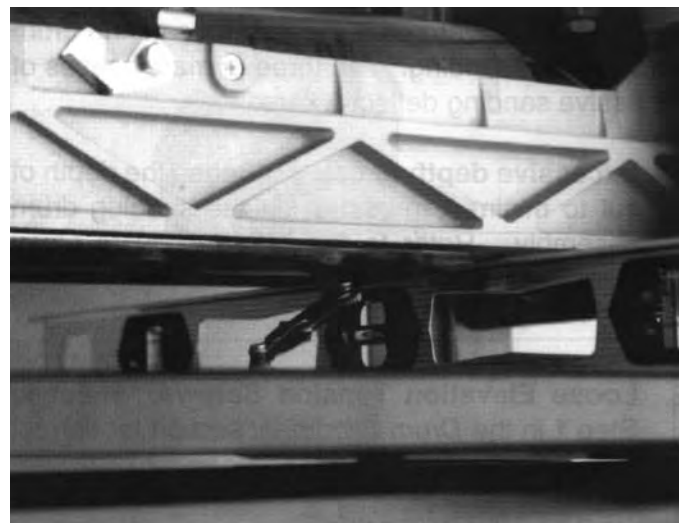


Figure 10

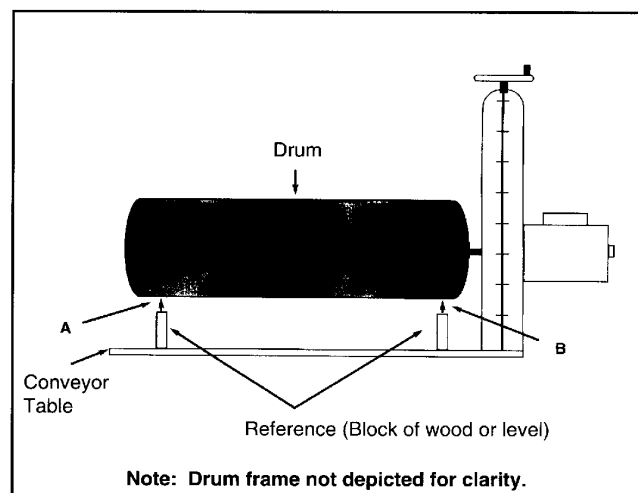


Figure 11

# ADJUSTMENTS



*If the measurement at A is greater than the same point at B by .020 or less, proceed as follows:*

1. Loosen the 2 outboard conveyor table mounting bolts as shown in Figure 12.
2. Slide one or both of the supplied shims as needed under the edge of the conveyor table as shown.
3. Tighten conveyor table mounting bolts. Recheck the measurement at A and at B.
4. Test sand a piece of wood and check for uniform thickness.

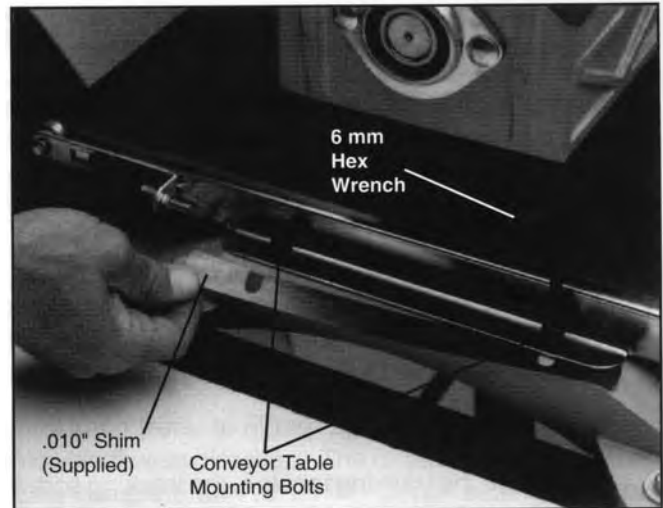


Figure 12

*If the measurement at A exceeds B by more than .020", or if distance B is greater than A, proceed as follows:*

1. Loosen the two front and two rear adjustment bolts as shown in Figure 13, thus allowing the entire drum assembly to pivot.

**NOTE:** If the unit is bolted to a stand or bench, loosen the mounting bolts at the motor end.

2. Using the Height Adjustment Handle Assembly, lower the drum until the distances at A and B are equal. Tighten the alignment bolts and the mounting bolts.
3. Test sand a piece of wood and check for uniform thickness. Repeat the above procedure if necessary.

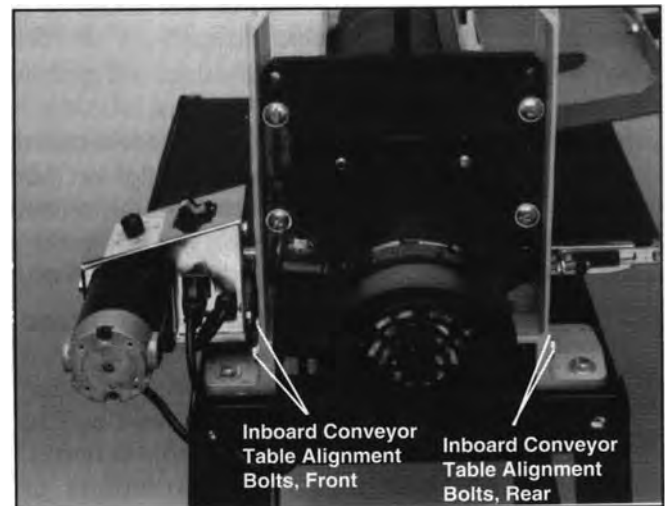


Figure 13



## ADJUSTMENTS

### CONVEYOR FEED BELT TRACKING ADJUSTMENT

Occasional adjustment of the conveyor feed belt tracking may be required due to belt stretching, normal wear and tear, and improper tensioning. Ideally, the conveyor feed belt should track in the center area of the conveyor feed belt table.

1. Conveyor feed belt tracking adjustment screws are located on both the inboard and outboard sides on the rear of the wide drum sander. (See Figures 14 and 15.)
2. To tighten the tracking tension, the tracking screw is rotated clockwise while holding its nut in place with a 7/16" open end wrench (not supplied). To loosen the tracking tension, the tracking screw is rotated counterclockwise while the nut is held with the wrench. (See Figure 15.)
3. If the conveyor feed belt is tracking towards the inboard (motor side) of the machine, tighten (add tension) to the tracking adjustment screw on that side of the machine.

**NOTE:** Due to the width of the conveyor feed belt, tracking adjustments may not become apparent immediately! Increase the speed of the conveyor feed belt to hasten the effects of your adjustments. Make small measured corrections of approximately 1/4 turn increments and evaluate the results. Readjust as necessary until the proper tracking solution is found.

#### HELPFUL

**HINT:** Tighten the side opposite the desired tracking direction. For example, tighten the right side tracking adjustment to make the conveyor feed belt track left.

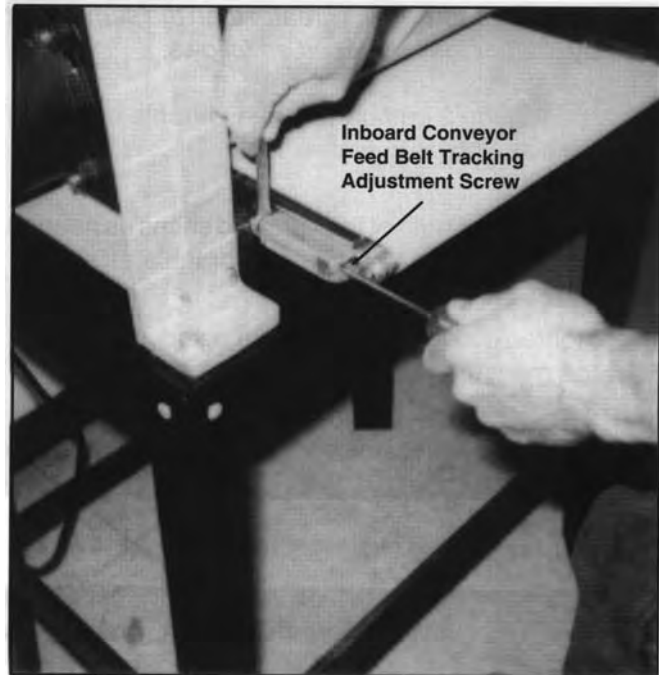


Figure 14

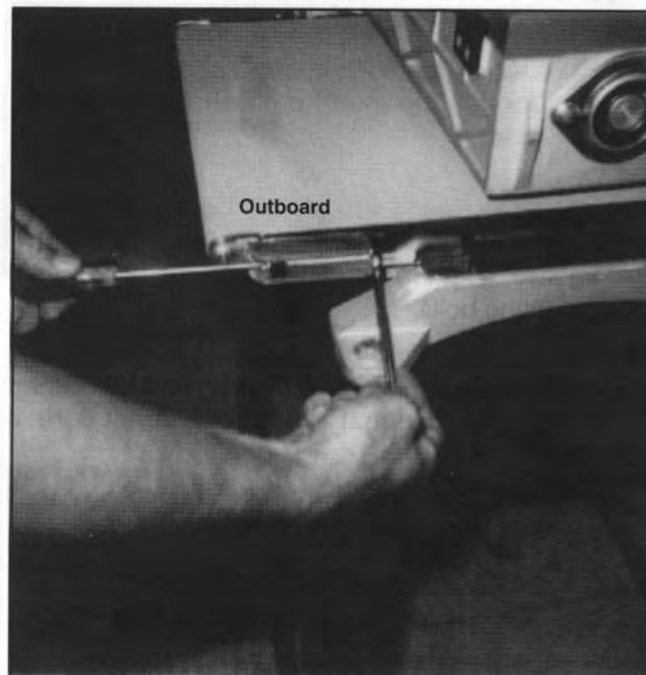


Figure 15

# OPERATING INSTRUCTIONS



## OPERATING INSTRUCTIONS

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**WARNING:** Never put your fingers into dust port or under drum cover.



**CAUTION:** To avoid damage to your King Drum Sander, adequate dust collection must be used during sanding operations. A 2-1/2" port is included in the sanding drum dust cover for connecting dust collection unit/hose to your Wide Drum Sander.

### DRUM HEIGHT CONTROL

The height of the drum is raised by turning the height control knob (refer to Figure 2) in a clockwise direction. To lower the drum, turn the height control knob in the counter-clockwise direction. The depth of the movement is approximately 1/64" per 1/4 turn in either direction. One complete turn is 1/16". Depth settings can be measured using the depth indicator scale located on the right side of the drum support frame.

**NOTE:** Depth settings used during surface sanding of stock are adjusted by considering several variables. The hardness of the material, the width of the material being surfaced, and the feed rate selected are all considered when determining the amount of material to be removed on each pass. Never remove more than 1/64" of material in one pass. The variable feed rate is set to prevent burning and provide a smooth sanded surface on different types and widths of materials. As a general rule, 1/4 turn or 1/64" or less is recommended stock removal for coarser grits and softer woods, while 1/8 of a turn or 1/128" may be more desirable with harder woods and/or finer grits of abrasives. When selecting the rate of feed for the material being surfaced, the wider the material, the slower the feed rate to be set. Similarly, the harder the wood, the slower the feed rate.

Some experimenting and practice will be required to become familiar with the sanding performance of your **King** Wide Drum Sander. While performing a surfacing operation with your **King** Wide Drum Sander closely parallels the wide surface preparation of a planer, a planer is much more capable of making deeper passes due to its characteristic knives, while a Wide Drum Sander is limited to its abrasive material for stock removal.



## OPERATING INSTRUCTIONS

### SANDING

1. With power off, rest stock on the feed table and advance the stock to a point so that you can adjust height of sanding drum to equal thickness of stock at its greatest point.
2. Connect and turn on dust collection equipment.
3. Adjust feed rate to match sanding requirements and width of stock.
4. Turn on unit and rest stock on the feed conveyor table allowing the feed belt to carry the stock into and engage the sanding action of the drum. Support long stock as necessary during the feed operation. Once the sanding operation feed allows, reposition yourself to the outfeed side of the machine to accept, support, and control the board as it exits the Wide Drum Sander.

**NOTE:** Do not apply upward or downward pressure when supporting and guiding stock through the sander. To do so may induce snipe (sander drum dig-in) into the sanded stock.

5. Reverse the feed direction of the stock on successive passes, while adjusting the depth of cut using the height adjustment handle assembly (refer to Figure 2). Several variables affect the proper depth of cut selected. They are: abrasive grit choice, width of stock, hardness of stock, feed rate, and moisture content of stock.

### INSTALLING NEW REPLACEMENT ABRASIVE STRIPS



**WARNING:** To prevent possible serious personal injury, always disconnect the Wide Drum Sander from the power source before servicing the unit or changing the abrasive strips.

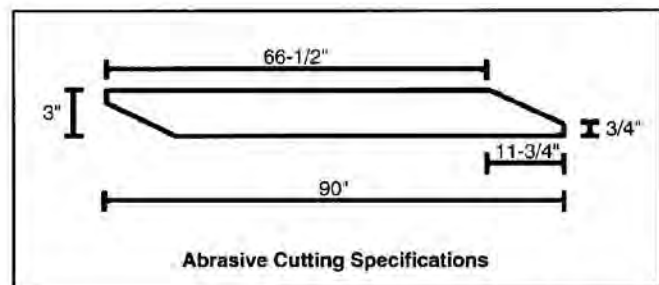


Figure 16

1. Make sure the power switch is off and disconnect the power cord from the outlet.
2. Using a strip which you have cut for use, you begin the abrasive strip installation by inserting the tip of the tapered strip into the slot in the left side of the drum while depressing the clip (Figure 17). Approximately one inch of material should be inserted into the slot to make the connection in the abrasive clip. Release clip pressure once the inserted tapered end is securely loaded in the clip jaws.



Figure 17

# OPERATING INSTRUCTIONS



3. Once the abrasive strip is secured in the left clip, stand in front of the unit and radially wrap the abrasive material. Roll the drum away from you with your left hand while holding tension on the abrasive strip with your right hand and guiding the material onto the drum. Use this technique to wrap the abrasive strip edge to edge radially around the drum. Make sure you do not overlap the material as you wrap the abrasive (Figure 18). The material should be flush to slightly gapped, but not overlapped, during the wrap.
4. When you have completely wrapped the drum, keep tension on the strip and insert the remaining tapered end of the strip into the slot in the drum. Using your right hand, raise the tensioner clip completely to open the jaws. Insert the tapered end of the abrasive strip, and release the tensioner clip to secure the abrasive strip (Figure 19). The tensioner clip will secure and tension the abrasive strip during use and will hold tension in the event the strip stretches during use. If the abrasive strip is not tightly captured, the tensioner clip was not raised sufficiently to open the jaws properly before inserting the abrasive strip.

**NOTE:** In some cases, if the abrasive strip stretches, it may be necessary to readjust/reposition the abrasive clip points on the abrasive strip. Ensure the tension remains positive on the abrasive strip during extended use.

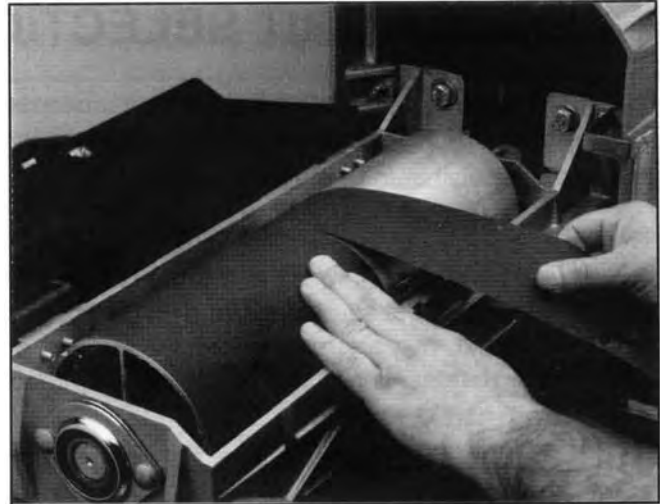


Figure 18

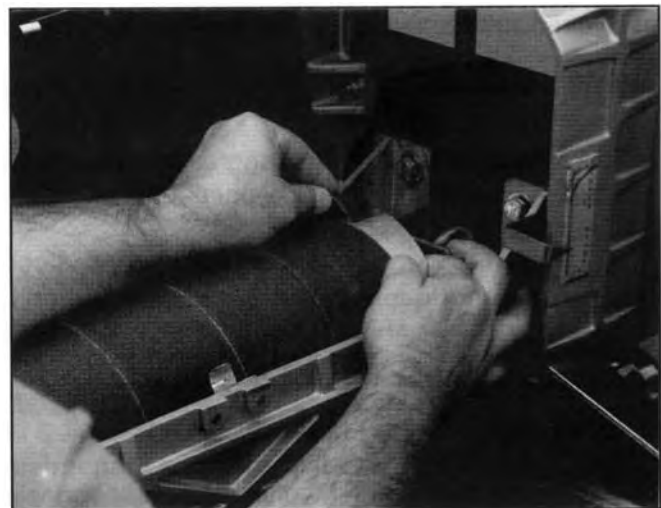


Figure 19



## MAINTENANCE OF UNIT

### MAINTENANCE OF UNIT

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**WARNING:** To prevent possible serious personal injury, always disconnect the Wide Drum Sander from the power source before servicing the unit or changing abrasive strips.

Keep your Wide Drum Sander clean. Remove accumulated sawdust from the drum and other working parts. Frequently clean resin buildup from the inner drum using a kerosene or a resin remover dampened cloth with the unit disconnected from the power source.



**WARNING:** Provide adequate ventilation when using solvents. Do not use solvents to clean plastic parts.

Some basic requirements are necessary to ensure a long and enjoyable life for your **King** Wide Drum Sander:

1. Periodically lubricate moving parts using a non-petroleum based lubricant, including the threaded depth control, sliding surfaces, and bronze bushings associated with the depth control mechanism. Do not use oil or grease because they tend to attract and hold sawdust.
2. Periodically check the tightness of all frame bolts and motor/drum mounting bolts/screws.
3. Keep sanding drum feed belt clean.
4. Use only clean sanding abrasives.
5. Periodically check the sanding drum feed belt table alignment. If out of alignment, see alignment procedure.



**WARNING:** To ensure safety and reliability, all repairs (with the exception of externally accessible brushes) should be performed at a King Authorized Service Center. Use only King replacement parts.



**WARNING:** Do not operate the Wide Drum Sander with the drum cover open. Use extreme caution when performing drum cleaning maintenance on your Wide Drum Sander. **DO NOT** wear long sleeve shirts, neckties, or jewelry. Tie back long hair when cleaning the sanding drum. Failure to heed this warning can result in serious personal injury.



# MAINTENANCE OF UNIT



## DRUM ABRASIVE STRIP CLEANING

During use, the sanding strip abrasive may become clogged with sawdust, causing insufficient sanding, marring of workpiece, and burning of the workpiece. With the machine off and unplugged from its power source, occasionally check the condition of the abrasive strip on the sanding drum for clogging. This should be done often, especially with resinous woods, because material can become so packed into the abrasive that it cannot be removed, and the abrasive strip must be replaced.

1. Heed all warnings and use extreme caution when performing this cleaning operation.
2. Set the conveyor belt speed control knob to lowest feed setting. Avoid contact with conveyor feed belt.
3. Open the protective dust cover to expose the sanding drum and abrasive strip.
4. Use a long belt cleaning stick to distance your hands from the rotating drum. (See Figure 20.)
5. Turn on the machine, grip the belt cleaning stick with two hands, rest the cleaning stick on the casting which houses the sanding drum. Gently lower the cleaning stick onto the rotating drum, moving the cleaning stick from side to side to remove the impacted sawdust. (See Figure 20.)
6. When cleaning is completed, remove the stick, turn off the machine, and close and latch the protective dust cover.

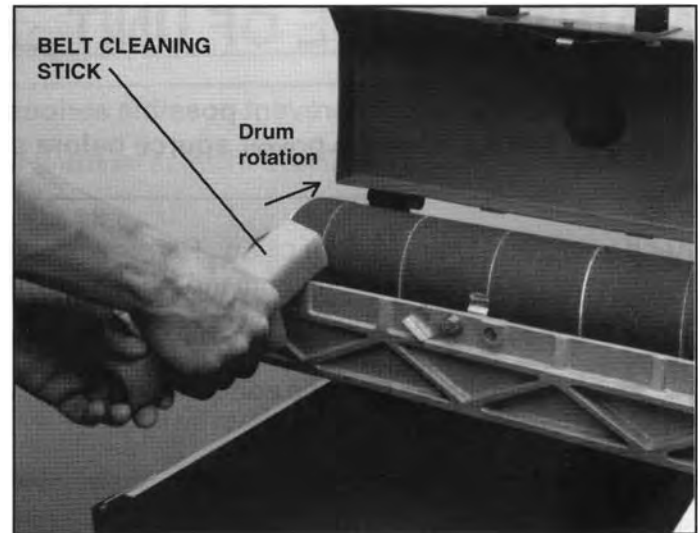


Figure 20



## MAINTENANCE OF UNIT

### CONVEYOR FEED BELT REPLACEMENT

Common causes which require replacement of the conveyor feed belt are: normal wear and tear, inadvertent contact with the sanding drum abrasive during operation, tears caused by mistracking of the conveyor feed belt, or excessive build-up of non-removable film.

The following steps describe how to remove and replace the conveyor feed belt when necessary:

1. Disconnect the machine from the power source.
2. Using the Height Adjustment Handle, raise the sanding drum to its highest position (roughly 3" above the conveyor belt table).
3. Using a phillips type screwdriver, remove the 2 screws and star washers securing the front nip guard to the variable speed control box. Then remove the front nip guard by sliding it to the left and off the outboard drive roller bushing. (See Figure 21 for reference.)
4. Using the supplied 6 mm hex wrench key, remove both conveyor table mounting bolts on the outboard, open side of the wide drum sander. (See Figure 12 in the *Drum Alignment* section for reference.)
5. Reduce tension on the conveyor feed belt by rotating both the inboard and outboard conveyor feed belt tracking adjustment screws in a counterclockwise direction. (See Figures 14 and 15 in the *Conveyor Feed Belt Tracking Adjustment* section for reference.)
6. Remove the used conveyor feed belt by grasping both sides of the belt as shown in Figure 21. Gently lift the conveyor table as you slide off the conveyor feed belt. If the belt will not move, further reduce the tension on the feed belt and ensure you are lifting the table high enough to allow the feed belt to slide off.
7. To install the replacement conveyor feed belt, follow Steps 6 through 3 in reverse order. Center the new feed belt on the conveyor feed belt table and evenly tension the new feed belt using the inboard and outboard tracking adjusters. If you experience tracking problems, consult the *Conveyor Feed Belt Tracking Adjustment* section.

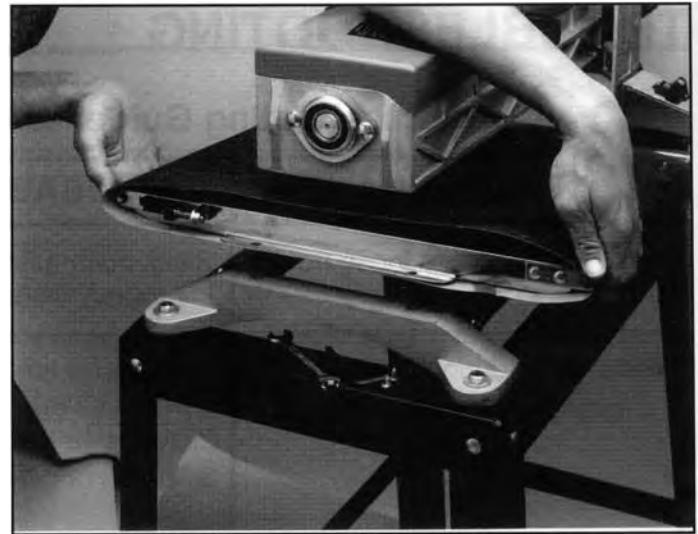


Figure 21