

## Sanding Machine #48 (40 Grit)

1. This machine is for removing planer chatter marks, or creating a semi-smooth surface on solid wood. If more than 1/32" of wood needs to come off, use the thickness planer.
2. If you have any questions; check with a Board Member, or Shop Manager
3. Minimum Board Length:
  1. **7" minimum length (with or without sled)**
4. If you glued the wood today wait at least 24 hours before running it through the sander to prevent glue from damaging the sandpaper.
5. **When sanding multiple boards, they must be the same thickness!!** You cannot surface sand boards of different thickness at the same time!!
6. Things not to be done:
  - i. Don't sand wood with any excess exposed glue (scrape it off first).
  - ii. No sanding of MDF, particle board, plywood, or Melamine.
  - iii. Don't turn crank more than 1 indicator mark.
  - iv. No sanding of painted wood (use hand sanders).
7. Pine and wood with a light finish may be sanded on Surface Sander #48.
8. Remove any loose knots in the board before sanding.
9. Surface Sander #48 & has one sanding drum (40 grit)
10. Make sure sanding drum and conveyor belt switches are turned off.
11. Open vacuum vent.
12. Open flap on the top of the machine:
  - i. Check sanding drum for any tears or burn marks.
  - ii. Make note of any damage and report it to the Shop Manager.
13. Lower conveyor bed so that the board can fit in the front end.
14. Turn on conveyor belt and run the board through **with sanding drum not running**.

15. Slowly raise conveyor bed until the board just barely causes the sanding drum to rotate (look through the flap on the top of the machine to see the drum). **This is the most critical adjustment in setting up the machine !!!**
16. Start up sanding drum
17. Run the board through 3 times. This will give a more uniform sanding and help prevent damage to the sand paper.
18. Turn crank clockwise one indicator mark (1/32 of a turn). **Remember, you are only taking off hundredths of an inch**
19. Run the board through 3 times before raising the conveyor belt again
20. If sanding wood less than one inch wide, run boards through a slight angle so that the abrasive paper doesn't burn the wood.
21. When sanding oily exotic woods or fine grain woods (purple heart, teak, paduak etc...), sand very lightly with each pass (less than one indicator mark) and use a fast conveyor belt speed to prevent burning of the sand paper.
22. For wood less than 1/2" thick, use the sled under the wood.
23. When finished: turn off all switches, lower conveyor belt, clean up your mess (sweep floor, brush off conveyor belt) and close vacuum vent.