

## **Sanding Machine #74**

1. This machine is for removing planer chatter marks, or creating a 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. Board Length:
  - i. **8 inch minimum length (with or without sled)**
  - ii. **2 foot maximum length**
4. Board thickness:
  - i. **1/8 inch minimum thickness**
  - ii. **3 3/4 inch maximum thickness**
5. If you glued the wood today wait at least 24 hours before running it through the sander to prevent glue from damaging the sandpaper.
6. **When sanding multiple boards, they must be the same thickness!!** You cannot surface sand boards of different thickness at the same time!!
7. **Things not to be done:**
  - i. Don't sand wood with any excess exposed glue (scrape it off first).
  - ii. No sanding of pine boards.
  - iii. No sanding of painted or boards with **any finish** on it (use hand sanders).
  - iv. No sanding of MDF, particle board, plywood, or Melamine.
  - v. Don't turn crank more than 1/8 of a turn.
8. Remove any loose knots in the board before sanding.
9. Surface Sander # 74 has one sanding drum.
10. Make sure sanding drum and conveyor belt switches are turned off.

11. Open top hood of sander and inspect sand belt for any tears or burn marks. Make note of any damage and report it to the Shop Manager
12. Measure thickness of board and then check it against machine thickness indicator for preliminary pass. Make machine indicator mark slightly thicker than board itself
13. Turn on conveyer belt and run the board through **with sanding drum not running.**
14. Slowly raise conveyor bed until the board just barely causes the sanding drum to rotate. **This is the most critical adjustment in setting up the machine!!!**
15. Start up sanding drum and run board through while slowly cranking conveyor belt up till it starts to touch the board.
16. Close the top hood
17. Start up the sanding drum.
18. Run the board through 3 times. This will give a more uniform sanding and help prevent damage to the sand paper.
19. Turn crank clockwise 1/16 of a turn. Turning it more than 1/16 of a turn can damage the sanding belt. **Remember, you are only taking off hundredths of an inch.**
20. Run the board through 3 times before raising the conveyor belt again.
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. When finished: turn off all switches, lower conveyor belt, clean up your mess (sweep floor, brush off conveyor belt) and close vacuum vent.