

DDB12|6 DRUM SANDER MANUAL



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GENERAL SAFETY RULES FOR WOODWORKING MACHINERY

WARNING: Do not attempt to operate the machine until you have read thoroughly and have understood completely all instructions, rules and condition contained in this manual. Failure to comply can result in accidents involving fire, electric shock, or serious personal injury. Keep this owner's manual and refer to it frequently for continuous safe operation.

1. Know your machine. For your own safety, read the owner's manual carefully. Learn its application and limitations, as well as specific potential hazards pertinent to this machine.
2. Make sure all tools are properly grounded. If the tool electrical plug has three prongs, it should be used in a three hole electrical socket. If a three prong or two prong adapters is used, the adapter plug must be properly grounded. Do not remove or disable the third prong.
3. Keep guards in place and in good working order. If a guard must be removed for maintenance or cleaning, make sure it is properly reattached before using the machine again.
4. Remove adjusting keys and wrenches. Form a habit of checking to see that the keys and adjusting wrenches are removed from the machine before turning it on.
5. Keep your work area clean. Cluttered areas and workbenches increase the chance of an accident.
6. Do not use in dangerous environments. Do not use power tools in damp or wet locations or expose them to rain. Keep work areas well illuminated.
7. Keep children away. All visitors should be kept a safe distance from the work area.
8. Make the workshop childproof. Use padlocks, master switches and remove starter keys.
9. Do not force the machine. It will do the job better and be safer at the operating rate for which it is designed.
10. Use the right tools. Do not force the machine or attachments to do a job for which they are not designed. Contact the manufacturer or distributor if there is any question about the machine's suitability for a particular job.
11. Wear proper apparel. Avoid loose clothing, gloves, neckties, bracelets, and jewelry, which could get caught in moving parts.

Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

12. Always use safety glasses. Also, wear a face or dust mask if the operation area is dusty. Everyday eyeglasses only have impact resistant lenses. They are not safety glasses.
13. Do not over-reach. Keep proper footing and balance at all times.
14. Maintain machine in top condition. Keep machine clean for safety and best performance. Follow instructions for lubrication and changing accessories.
15. Disconnect the machine from the power source before servicing, when changing accessories and when mounting or remounting motor.
16. To avoid accidental starting, make sure the switch is in the OFF position before plugging in the power cord.
17. Never leave the machine running unattended. Turn the power off. Do not leave the machine until it comes to a complete stop.
18. Do not use any power tools while under the effects of drugs, alcohol or any medication.
19. Always wear a face or dust mask if operation creates a lot of sawdust and/or chips. Always operate the tools in a well-ventilated area and provide for proper dust removal. Use a dust-collection system whenever possible.
20. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
21. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
22. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
23. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
24. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function-check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
25. **USE PROPER EXTENSION CORD.** Make sure your extension cord

is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table 1 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.

Table
Minimum gage for cord^a

		Volts	Total length of cord in feet			
		120 V	25 ft.	50 ft.	100 ft.	150 ft.
Ampere Rating		240 V	50 ft.	100 ft.	200 ft.	300 ft.
More Than	Not More Than	AWG				
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not	Recommended
^a Only the applicable parts of the Table need to be included. For instance, a 120-volt product need not include the 240-volt heading.						

GROUNDING INSTRUCTIONS

In the event of a 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.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

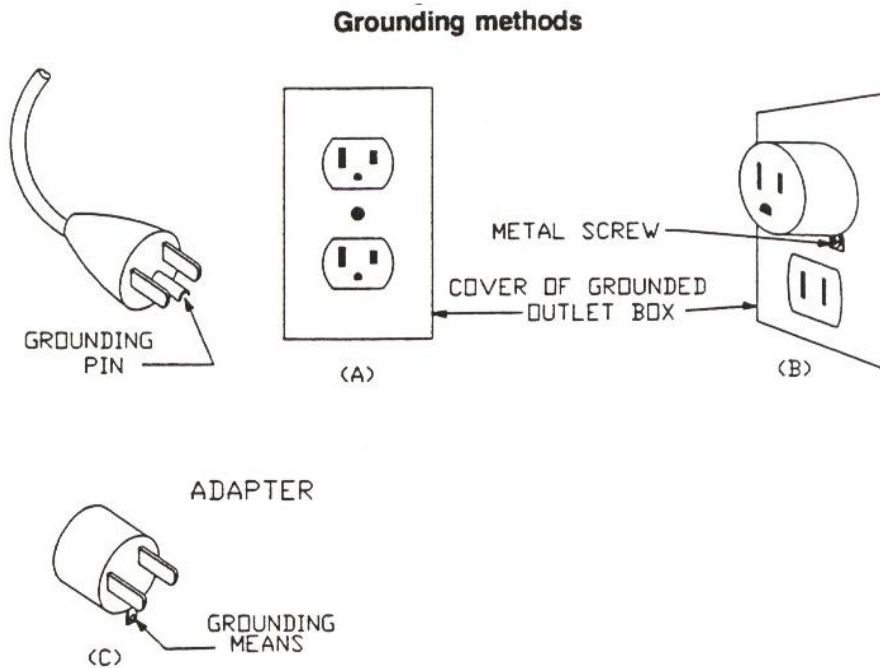
Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

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 is properly grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Sketch A. The tool has a grounding plug that looks like the plug illustrated in Sketch A. A temporary adapter, which looks like the adapter illustrated in Sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in Sketch 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. **(This adapter is not permitted in Canada)** The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.



ADDITIONAL SAFETY RULES FOR VERTICAL SPINDLE SANDER

SANDPAPER DIRECTION

Feeding workpiece incorrectly can cause it to be thrown from machine, striking operator or by standers, or causing your hands to slip into the moving sandpaper. To reduce these risks, only sand against direction of sandpaper travel, ensure workpiece is properly supported, and avoid introducing sharp edges into moving sandpaper on leading side of workpiece.

SANDPAPER CONDITION

Worn or damaged sandpaper can aggressively grab workpiece, resulting in subsequent injuries from operator loss of workpiece control. Always inspect sandpaper before operation and replace if worn or damaged.

FEEDING WORKPIECE

Jamming workpiece into sanding surface could cause it to be grabbed aggressively, pulling hands into sanding surface. Firmly grasp workpiece in both hands and ease it into sandpaper using light pressure.

WORKPIECE SUPPORT & HAND PLACEMENT

Rotating sandpaper can remove a large amount of flesh quickly, and kickback can occur with violent force if workpiece is not properly supported during operation. Always sand with workpiece firmly against table or another support device. Never touch moving sandpaper on purpose.

AVOIDING ENTANGLEMENT

Entanglement in moving parts can cause pinching and crushing injuries. Keep all guards in place and closed. Do not wear loose clothing, gloves, or jewelry, and tie back long hair.

IN-RUNNING NIP POINTS

The gap between moving sandpaper and fixed table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater the risk of fingers or workpieces getting caught in it. Minimize this risk by adjusting table/ support to no more than 1/16" away from sandpaper. For spindle sanders, always use the table insert that fits closest diameter of installed drum.

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MINIMUM STOCK DIMENSION

Small workpieces can be aggressively pulled from your hands, causing contact with sanding surface. Always use a jig or other holding device when sanding small workpieces, and keep hands and fingers at least 2" away from sanding surface.

WORKPIECE INTEGRITY

Sanding fragile workpieces can result in loss of control, resulting in abrasion injuries, impact injuries, or damage to sandpaper. only sand solid workpieces that can withstand power sanding forces. make sure workpiece shape is properly supported; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.

WORKPIECE INSPECTION

Nails, staples, knots, or other imperfections in workpiece can be dislodged and thrown from sander at a high rate of speed at people, or cause damage to sandpaper or sander. never sand stock that has embedded foreign objects or questionable imperfections.

UNPACKING AND CLEANING THE MACHINE

1. The machine is shipped in one carton.
2. Unpack the machine carefully.
3. Ensure that loose parts are present as listed in the manual. If any items are missing or damaged, please contact your local dealer immediately.
4. Remove the rust preventative oil thoroughly. Use a soft cloth moistened with kerosene to remove the oil.

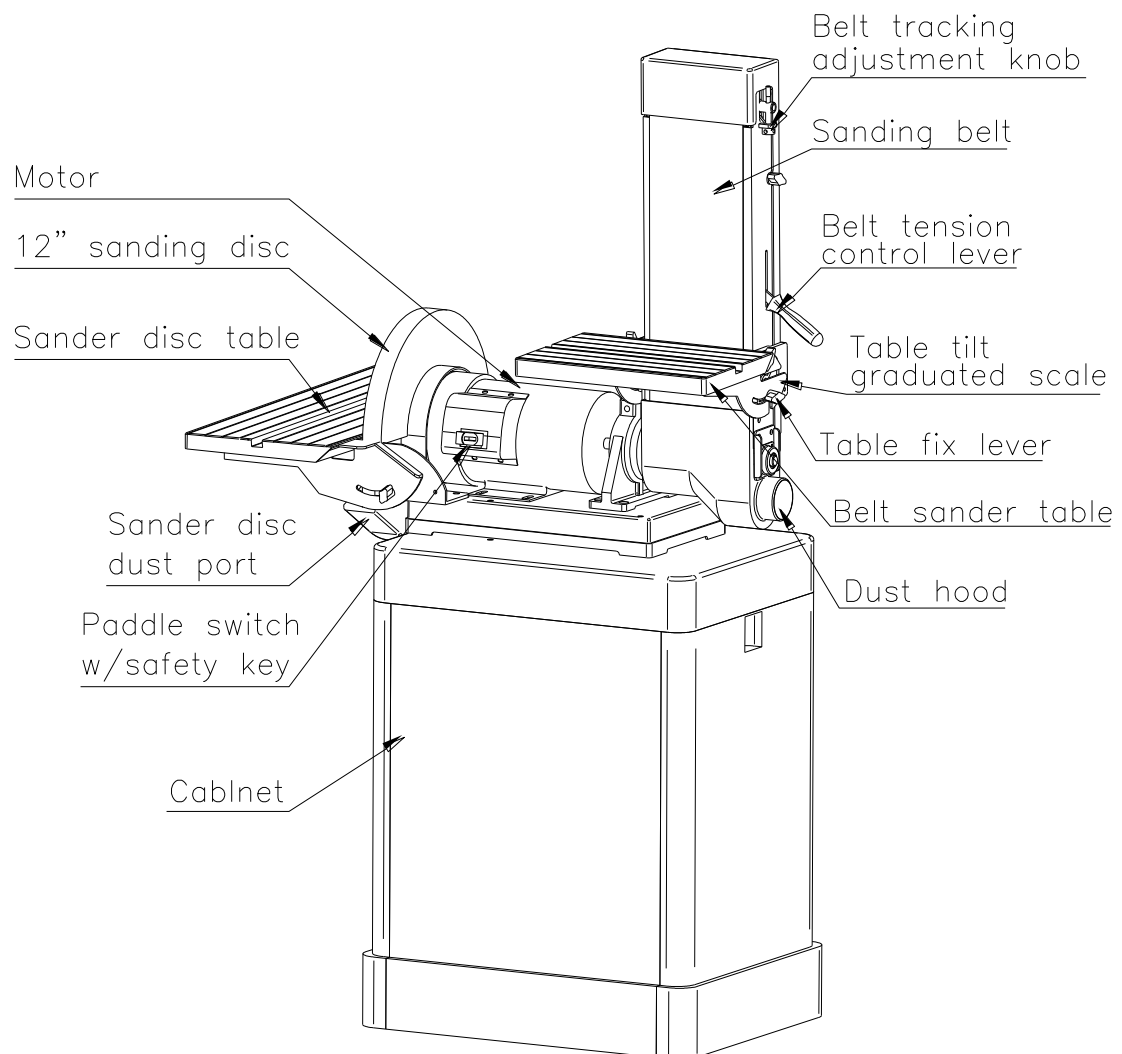


WARNING: Do not use gasoline or lacquer thinner to remove the rust preventative oil, as these can damage the painted surface

MACHINE FEATURES

1. The oscillating sanding provides an extremely fine sanding finish.
2. Two tables are both Rota table.
3. Tables tilt 0-45 degrees.
4. Direct ball bearing drive.
5. Quick change belt release.

MACHINE LEGEND



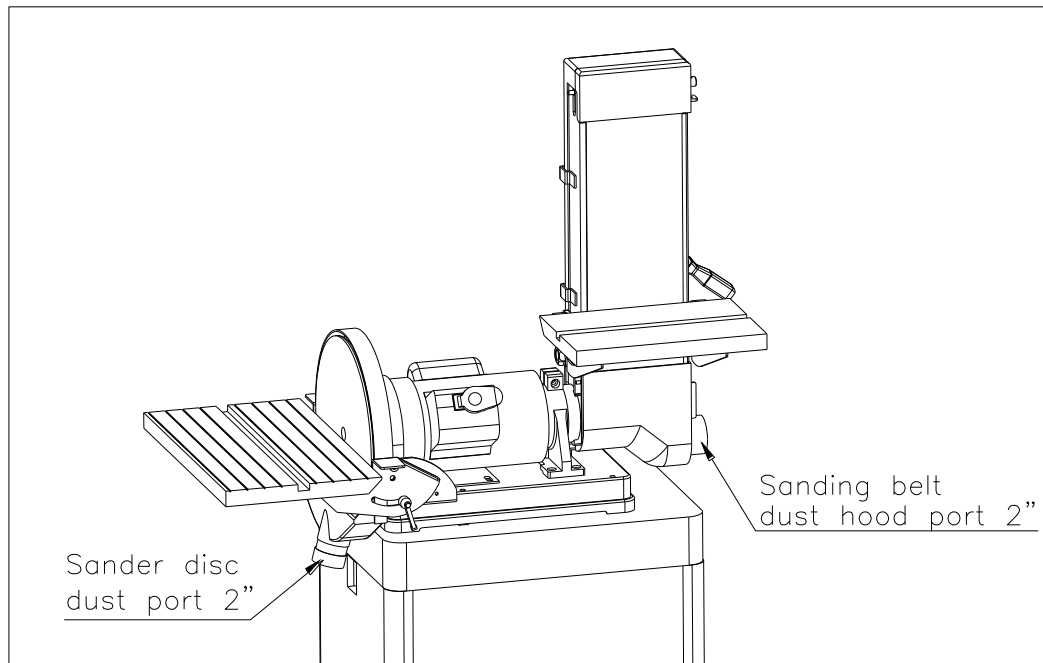
SPECIFICATIONS

Model	DB-1248
12" Table Size	450mm×254mm(17-11/16"×10")
6"×48" Table Size	250mm×203mm
Belt Diameter	6"×48"
Disc Diameter	12"
Motor Speed	50Hz 1420rpm
Motor	1- 1/2HP
Weight	Net: 74kgs
Cuft	18.6

CONNECTING DUST COLLECTION SYSTEM

There is dust hoods provided for the spindle drum sander and the belt sander, that which should be connected to a dust collector. The dust hoods are located under the tables.

Dust hood outlets are 2" diameter. Use a 2" diameter air hose to connect both dust hoods to a dust collector.



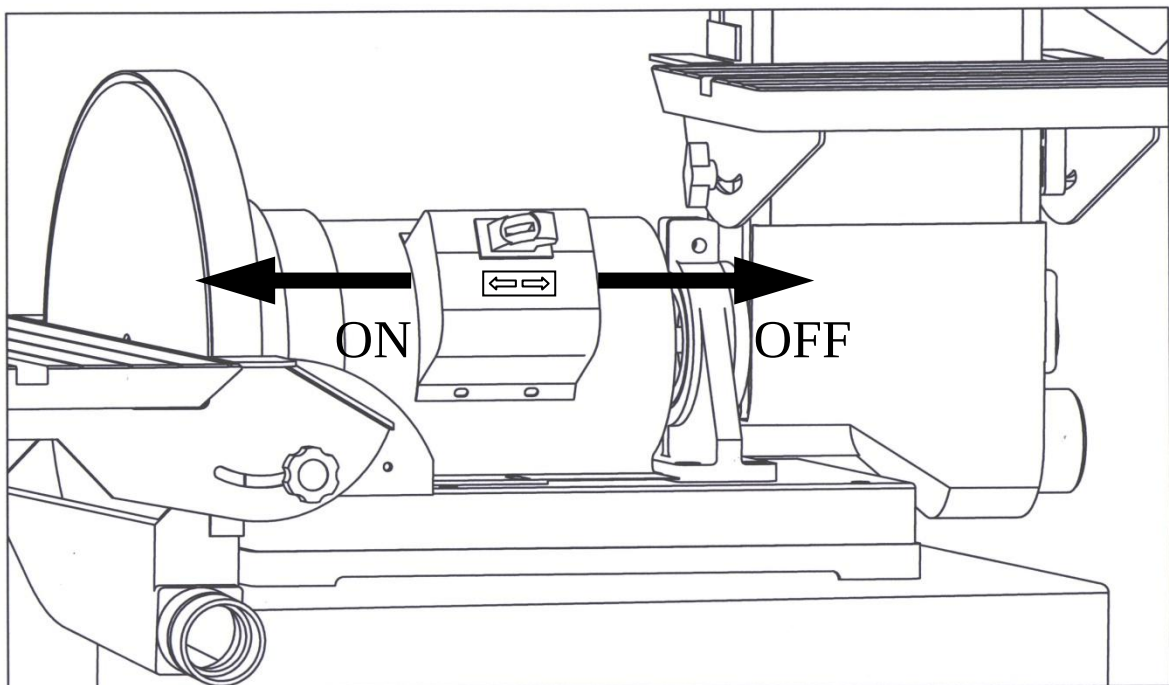
POWER SWITCH ON/OFF

The sander is equipped with a rocker-type power switch to start and stop the sander running. It is located on the junction box of the motor. The switch has a removable locking key to prevent unauthorized operations. If the sander is not in use for a long time, remove the locking key by pulling it out. It should then be stored in a safe place.

To start the sander running, insert the locking key and shift the switch to the left. To stop the sander, shift the switch to the right as shown below.



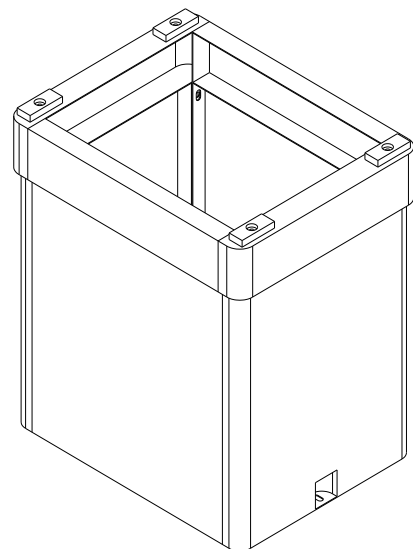
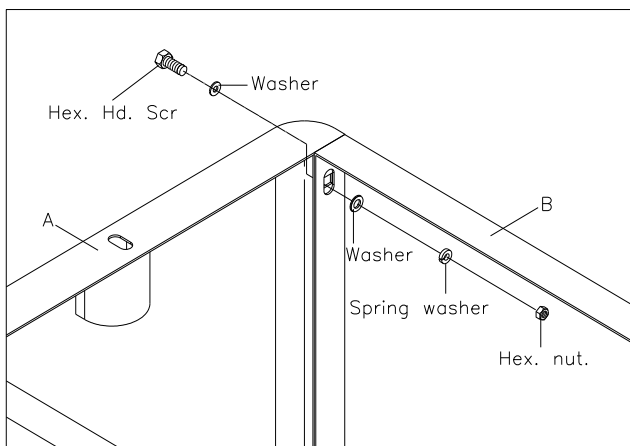
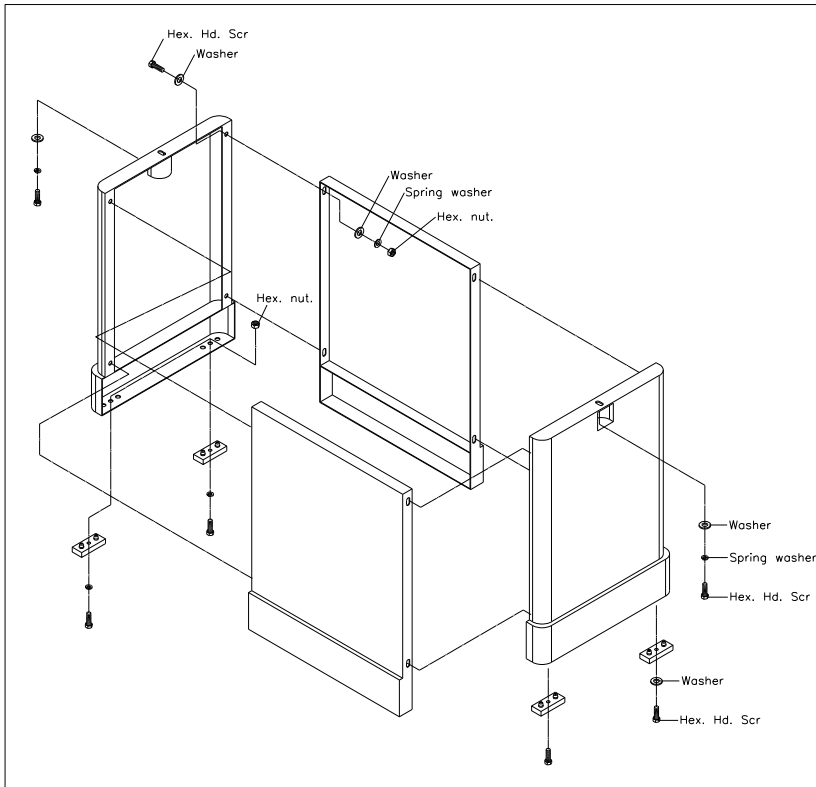
WARNING: Make sure the power switch is in the OFF position before connecting the sander to the power source.



CABINET ASSEMBLY

To assemble the cabinet stand, do these steps:

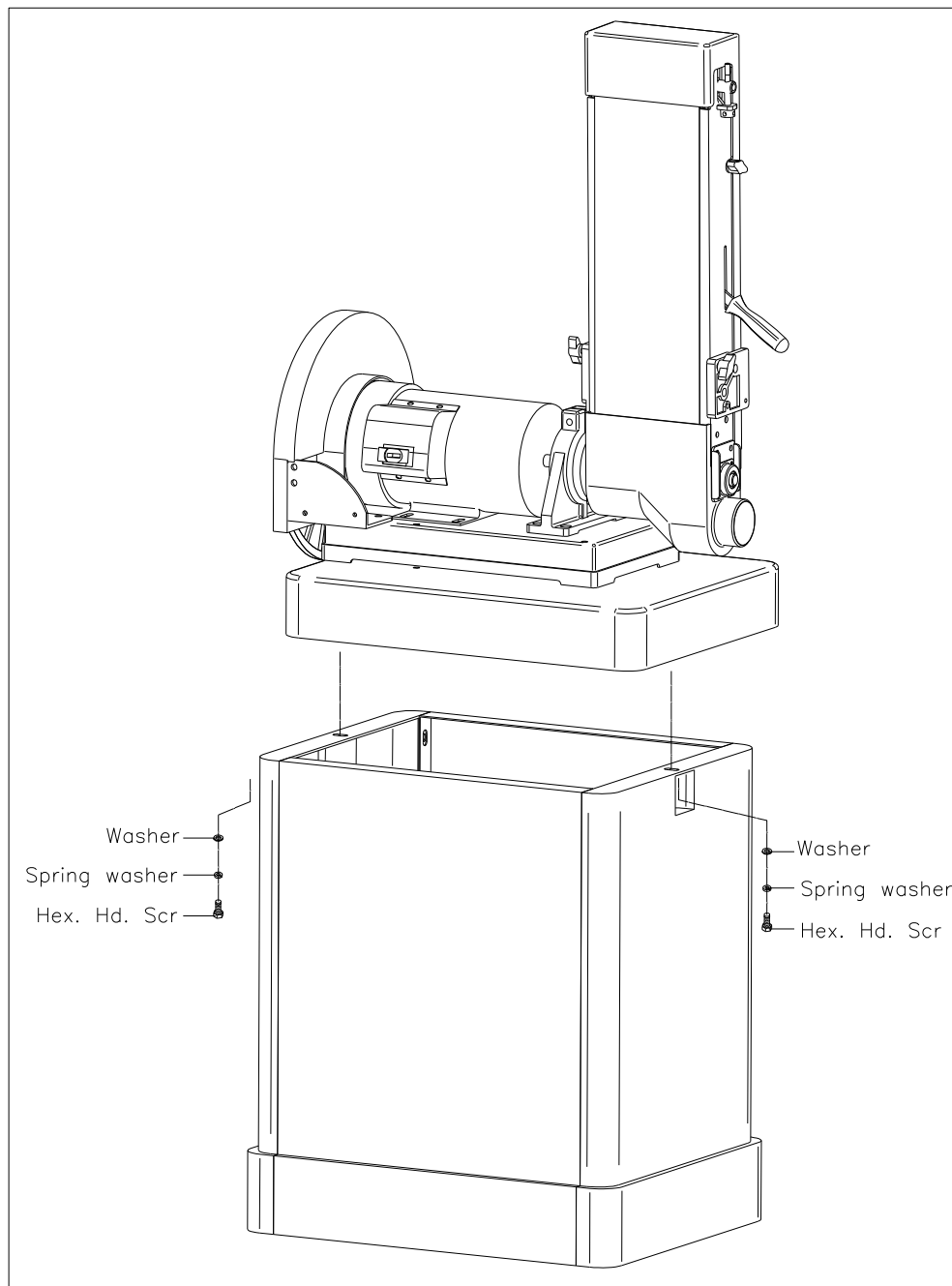
1. Assemble the cabinet panels together
2. Attach the remaining side panel
3. Secure the rubber feet to the bottom corners of the cabinet stand with the floor pad hardware bag



MOUNTING SANDER

To mount the sander, do these steps:

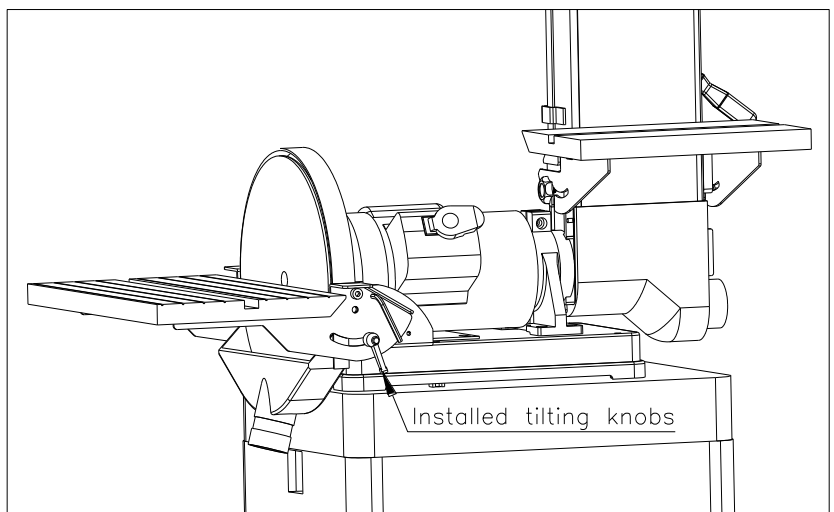
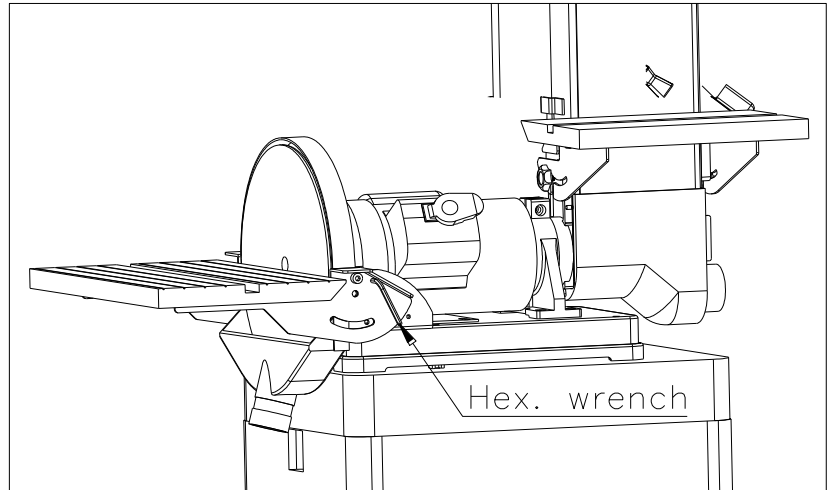
1. Keep the sander unplugged.
2. Place the sander on the stand.
3. Align the holes in the cabinet with the pre-drilled and tapped mounting holes in the sander.
4. Secure the sander to the stander.



INSTALLING TABLE

To install the sanding disc table, do these steps:

1. Keep the sander unplugged.
2. Align the sanding table mounting holes with the threaded holes in the bracket.
3. Secure the sanding table, with the cap screws supplied in the table hardware bag.
4. Install the table tilt control knobs.



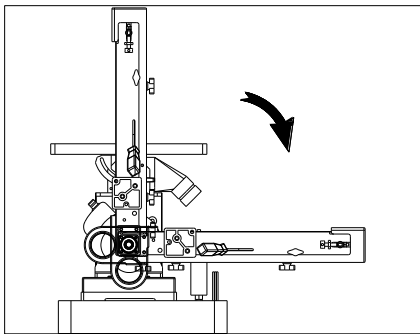
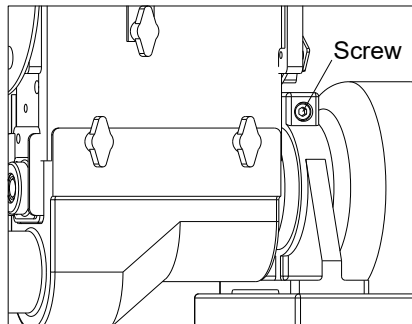
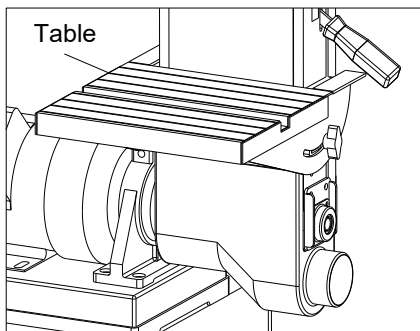
ADJUSTING THE TABLE

1. Using an Allen key, loosen the four bolts under the table and adjust to desired position. **NOTE:** To avoid damaging the table, keep a minimum of an 1/8" between the table and the sander.
2. Tighten bolts after adjusting.

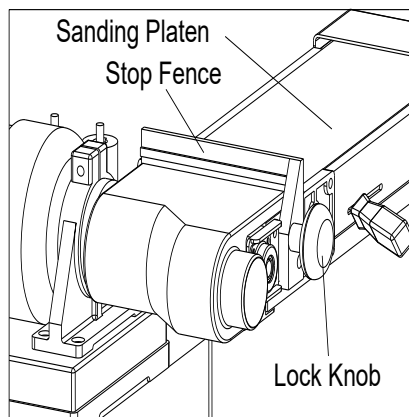


SETTING THE BELT SANDER IN A HORIZONTAL POSITION

1. Loosen the screw that tightens the motor shaft bracket using a 6 mm. hexagonal wrench.
2. Remove the belt sander table.
3. Manually move the belt sander into a horizontal position.
4. Tighten the screw securely after the belt sander has been positioned horizontally.
5. Always remember to mount the stop fence when performing flat surface sanding.

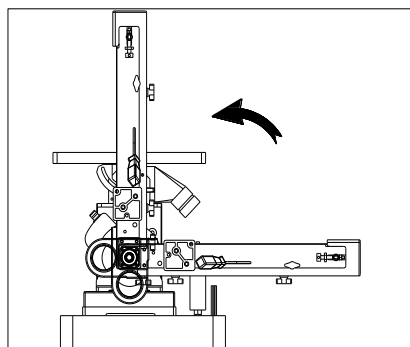
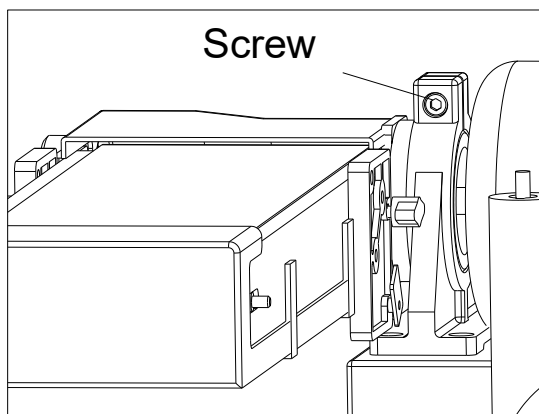


Move the belt sander into a horizontal position.

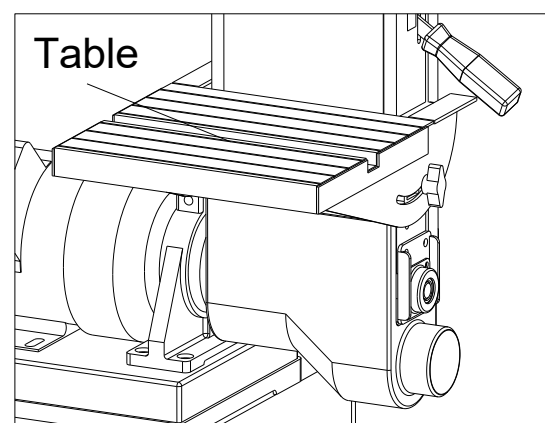
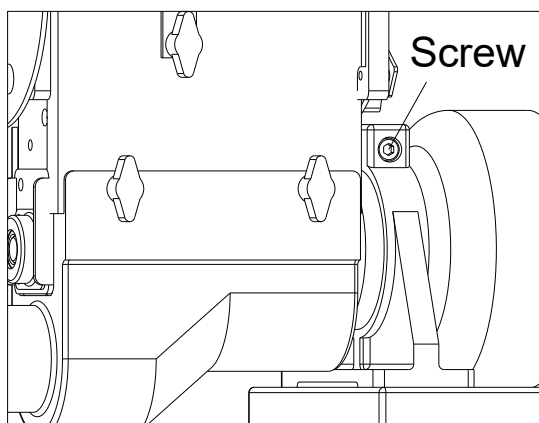


SETTING THE BELT SANDER IN A VERTICAL POSITION

1. Loosen the screw that tightens the motor shaft bracket using a 6 mm. hexagonal wrench.
2. Manually, move the belt sander into a vertical position.
3. Tighten the screw securely after the belt sander has been positioned vertically.
4. Mount the table.

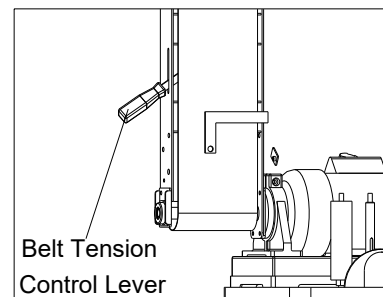
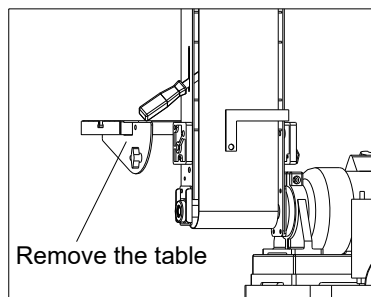
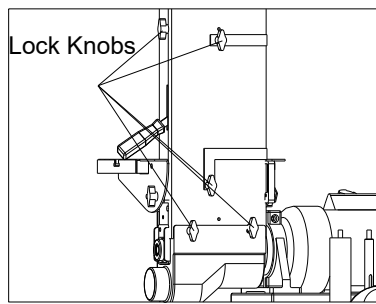


Move the belt sander into a vertical position.



REMOVING THE SANDING BELT

1. Disconnect the sander from the power source.
2. Loosen the 5 lock knobs that tighten the belt guard and then remove it.
3. Remove the belt sander table. Loosen the 2 lock screws located under the table before removing it.
4. Loosen and remove the table tilt graduated scale using a 5 mm hexagonal wrench.
5. Loosen the belt tension by shifting the belt tension control lever upward.
6. The old sanding belt may now be removed from the right side

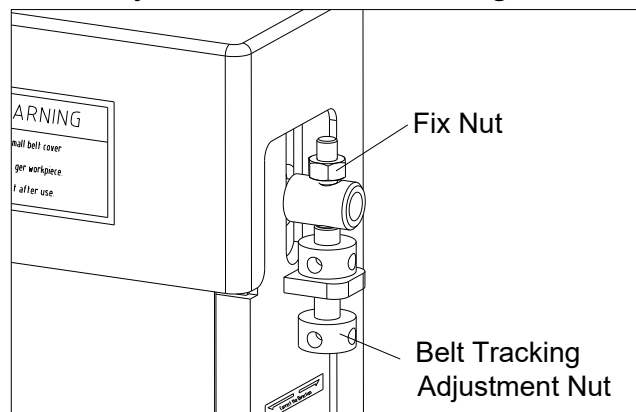


MOUNTING A NEW SANDING BELT

1. Disconnect the sander from the power source.
2. After the old belt has been removed, it is possible to fit a new one.
3. Fit a new sanding belt in the same place. Make sure the arrowheads marked on the back of the sanding belt point to the direction indicator attached on the belt guard.
4. The new sanding belt should be located in the center position of both the rollers.
5. Tighten belt tension by shifting the belt tension control lever downwards.
6. After the new belt has been mounted, reverse the above procedure to return the sander to its original condition.
7. It is necessary to make belt tracking adjustments. For details, refer to 'Belt Tracking Adjustment' on page 17 of this manual.

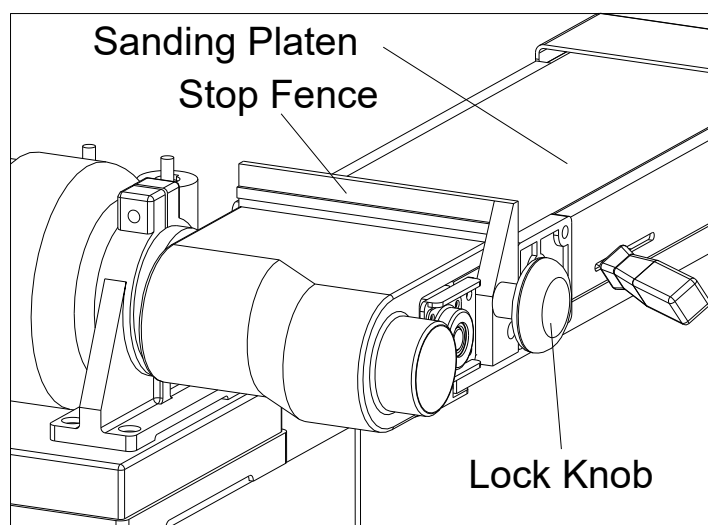
BELT TRACKING ADJUSTMENT

1. Disconnect the sander from the power source.
2. Manually rotate the sanding belt. At this time, check to see if the sanding belt runs in the center position of the rollers.
3. If the sanding belt runs out of proper tracking, make adjustments by turning the belt tracking adjustment knob using the supplied screwdriver.
4. Turn the knob in a counter-clockwise direction to move the belt forward. Turn it in a clockwise direction to move the belt backwards.
5. Loosen the fix nut before turning the belt tension adjustment knob. Tighten the nut securely after the belt tracking has been adjusted.



STOP FENCE

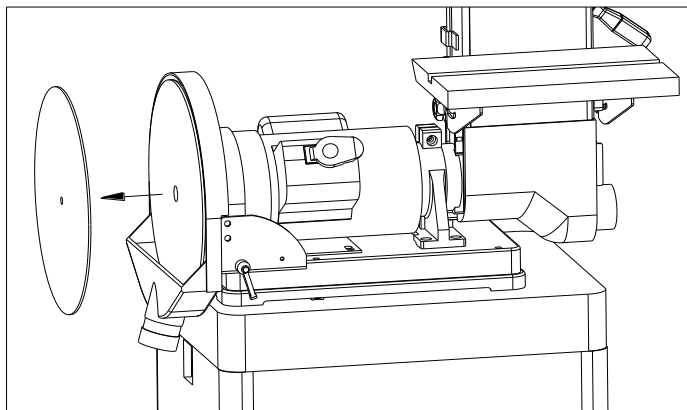
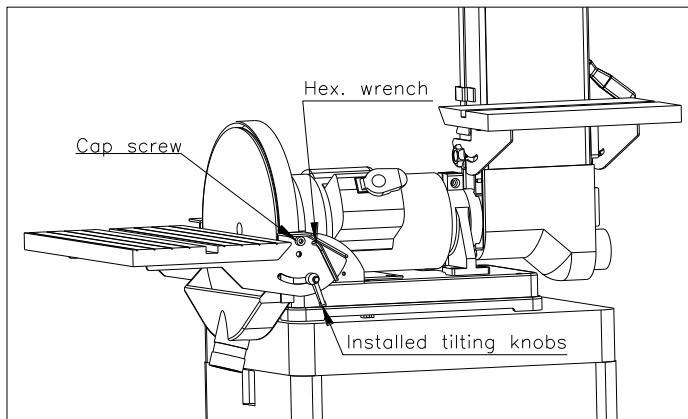
When the sanding platen is set for horizontal sanding, the stop fence should be used to prevent workpieces flying out during sanding. Mount the stop fence by fastening the two lock knobs on the edge of the sanding platen.



CHANGING SANDING DISC PAPER

To install a new sanding disc on the 12" disc sanding surface:

1. Unplug the sander.
2. Remove the disc sanding table.
3. Peel the old sanding paper off the sanding disc.
4. Place the new 12" sanding paper on the sanding disc.
5. Replace the disc sanding table.



MAINTENANCE

Make sure that your machine is unplugged during all maintenance procedures. if this warning is ignored, serious personal injury may occur

1. Everyday, after work is done, remove dust from the machine and clean it.
2. Everyday, after work is done, turn off the power switch and remove the switch key.
3. 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 sander performance.
4. Keep the machine and attachments clean.
5. Check for spindle straightness.
6. All bearings are permanently lubricated and require no further lubrication.
7. Cleaning the machine is relatively easy. vacuum excess wood chips and sawdust, and wipe off the remaining dust dissolving cleaner to remove it
8. Regularly clean your sanding belt and disc as sawdust builds up in the grit. clean the sanding belts and discs with pro stick. cleaning built-up sawdust will prolong the life of your sanding belts and discs.

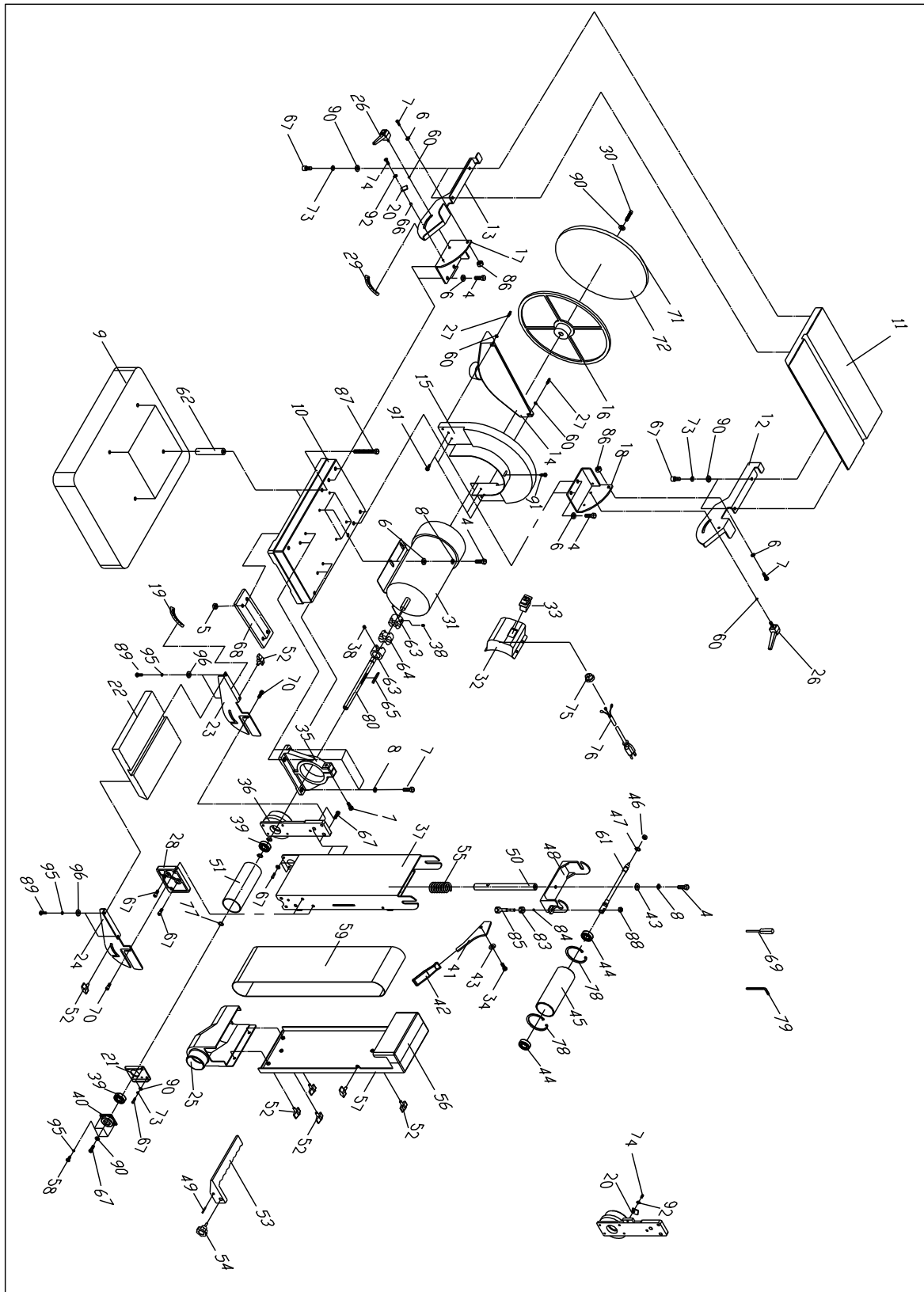


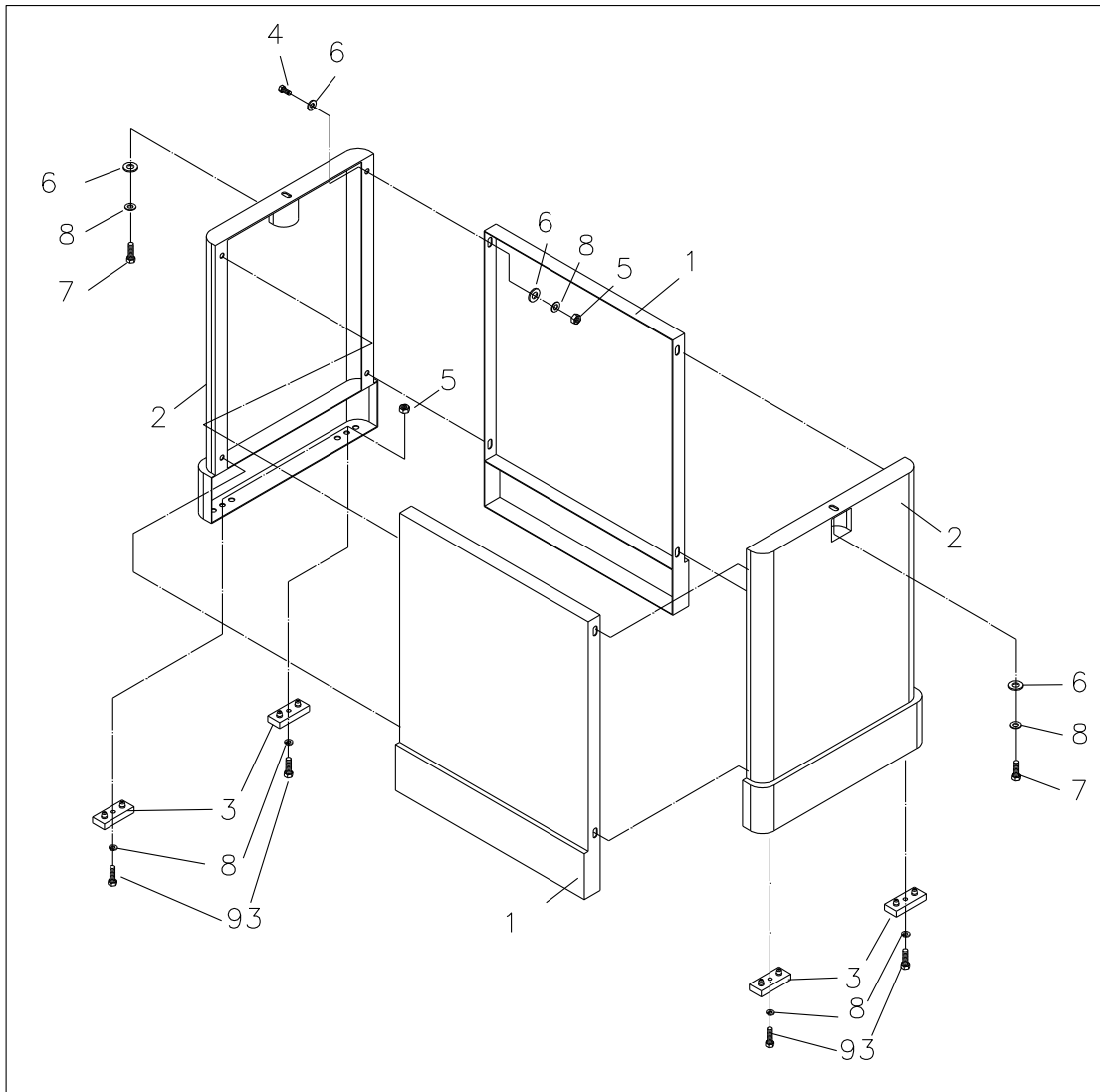
WARNING: Always disconnect the sander from the power source before commencing any maintenance.

TROUBLESHOOTING

TROUBLE	CAUSES	CORRECTION
Sanded surface not square	1. Work table not perpendicular to belt or disc.	1. Adjust work table square to sanding belt and disc.
Deep sanding grooves or scars in workpiece	1. Sandpaper too coarse for the desired finish 2. Workpiece sanded across the grain 3. Too much sanding force on workpiece 4. Workpiece held still against the belt/disc 5. Sandpaper clogged	1. Use a finer grit sanding belt/disc 2. Sand with the grain 3. Reduce pressure on workpiece while sanding 4. Keep workpiece moving while sanding on the belt/disc 5. Clean/replace sandpaper
Sanding surfaces clog quickly or burn	1. Too much pressure against belt/disc 2. Sanding softwood, or stock has surface residue	1. Reduce pressure on workpiece while sanding
Motor does not run when power switch is turned "ON".	1. Switch is burned out. 2. Connection wire is loose or damaged.	1. Replace the switch. 2. Tighten or replace the wire.
Motor does not run at full speed.	1. Power voltage is too low. 2. Motor is damaged.	1. Test voltage. 2. Check and repair motor.
Motor does not reach full power.	1. Incorrect power wiring. 2. Overload.	1. Replace with the correct size power wiring. 2. Reduce sanding load.
Motor overheating	1. Motor is dirty. 2. Motor is damaged.	1. Clean motor. 2. Check and repair motor.
Excessive machine vibration	1. Machine is incorrectly leveled.	1. Adjust machine leveling

ASSEMBLY DRAWING





MSANDB1248110 (DB-1248)

PART NO.	REFERENCE NO.	DESCRIPTION	Q'TY
1	20104053	FRONT & REAR SPACING PLATE	2
2	20104054	RIGHT & LEFT BRACKET	2
3	10401029	FOOT PADS	4
4	S0020501	HEX BOLT 5/16"-18UNCx1"	16
5	S0110400	NUT 5/16"-18UNC	12
6	S0210500	FLAT WASHER 5/16"x18x2T	34
7	S0010501	SCREW 5/16"-18UNC-1"	8
8	S0230506	SPRING WASHER 5/16"	19
9	30500001	BASE LOW	1
10	30500002	BASE UP	1
11	30500002G	12" WORKTABLE	1
12	30300014	FRONT SCALE	1
13	30300015	REAR SCALE	1
14	30300016b	DUST HOOD	1
15	30300017b	DUST GUARD	1
16	30300018	DISC	1
17	30300019	FRONT BRACKET	1
18	30300020	REAR BRACKET	1
19	J3020005	SCALE	2
20	30300030	INDICATOR	2
21	30400007	BEARING FIX PLATE	1
22	30500001G	6"x48" WORKTABLE	1
23	30400002	SCALE PLATE (LEFT)	1
24	30400003	SCALE PLATE (RIGHT)	1
25	30400006b	DUST HOOD	1
26	S0070615M	SCREW HANDLE M6xP1.0x15L	2
27	S0030512M	SCREW M8xP0.8x12	2
28	30400004	RIGHT SCALE BASE	1
29	30300041	LOCKING SCREW	2
30	S0010615L	SCREW M6xP1.0x15	1
31	M3050010	MOTOR 1.5HP/110/60/1	1

32	W0000001	SWITCH	1
33	30500020	SWITCH BOX	1
34	S0020520	HEX BOLT 5/16"-18UNCx1-1/4"	1
35	30400001	TILTING FIX BRACKET	1
36	30400010	CONNECTING BLOCK	1
37	30400011	SANDING PLATFORM	1
38	S0050404N	SET SCREW 1/4"-20UNC-1/4"	2
39	C1206202	BEARING 6202	2
40	20900049	BEARING 6202 CAP	1
41	20101031	BELT CHANGING HANDLE	1
42	20101032a	HANDLE KNOB	1
43	S0210400	FLAT WASHER 1/4"x19x2T	3
44	C1106201	BEARING 6201	2
45	21100012	DRIVEN ROLLER	1
46	S0120200	LOCKING NUT 1/4"-20UNC	1
47	S0520012	C RING STW-12	1
48	21100009	DRIVEN ROLLER BRACKET	1
49	S0310640	SPRING PIN Φ 6x40L	1
50	21100010	BRACKET SHAFT	1
51	21100013	DRIVE ROLLER	1
52	K2110001	SCREW 1/4"-20UNC-1/2"	5
53	20101040B	BLOCK BOARD	1
54	20101039	SCREW M8x35	1
55	21100018	SPRING	1
56	21100014Ab	DUST GUARD A	1
57	21100014b	DUST GUARD	1
58	S0030304	SCREW 3/16"-24UNC-1/4"	4
59	21100029	SANDING BELT 6"x1220mm	1
60	S0210401a	FLAT WASHER 1/4"x13x1T	2
61	21100011	ROLLER SHAFT	1
62	30400017	SPACER	2
63	30400015	COUPLER	2
64	30102007	COMPOUND BLOCK	1
65	S0410530	ROUND KEY 5x5x30L	1

66	40301012a	SPACER 8mm	1
67	S0010409	SCREW 1/4"-20UNC-1/2"	6
68	30400016	PLATE	1
69	20103044	SCREW DRIVER	1
70	S0010500	SCREW 5/16"-18UNC-1/2"	2
71	S0010410	SCREW 1/4"-20UNC-5/8"	5
72	30300039a	SANDING PAPER 12" 100#	1
73	S0230400	SPRING WASHER 1/4"	12
74	S0030518M	SCREW M5xP0.8x15	1
75	S1006P1	STRAIN RELIEF BUSHING	1
76	L0000035E	POWER CORD 7.5m 14AWG 3C1R2	1
77	S0520015	C RING STW-15	3
78	S0520032	C RING RTW-32	2
79	S0030515M	SCREW M5xP0.8x15	1
80	30400014	CONNECTING SHAFT	1
83	20103029A	NUT	1
84	20103029B	STEEL BALL	1
85	21000007	MICRO ADJUSTING SCREW	1
86	S0120500a	LOCKING SCREW 5/16"-18UNC	7
87	S0020531	SCREW 5/16-18UNCx3"	4
88	S0110300	LOCKING NUT 3/16"-24UNC	1
89	S0010303	SCREW 3/16"-24UNC-1/2"	4
90	S0210403a	WASHER 1/4"x16x2T	6
91	S0070300b	SCREW 3/16"x1/2"	5
92	S0220300	TEETH WASHER 3/16"	2
93	S0210516	FLAT WASHER 5/16"x16x2T	4
95	S0230300	SPRING WASHER 3/16"	8
96	S0210300	FLAT WASHER 3/16"x12x1T	4
97	40101011	SPACER 3.5mm	1
98	30500021	SCREW 1/4"-20UNCx1/2"	2
99	S0010505	SCREW 5/16"-18UNCx1-1/4"	1
100	20900081	SPACER 5mm	1
101	S0010505	SCREW 5/16"-18UNCx1-1/4"	4
102	S0090512	SCREW 5/16"-18UNCx3/4"	4

103	S0020412	SCREW 5/16-18UNCx3/4"	2
104	S0020408	SCREW 1/4"-20UNCx1/2"	4
105	S02104001a	FLAT WASHER 1/4"x13x1T	4
106	S0910204	WRENCH 4mm	1
107	S0910205	WRENCH 5mm	1
108	S0910104	WRENCH 6mm	1



LAGUNA TOOLS

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