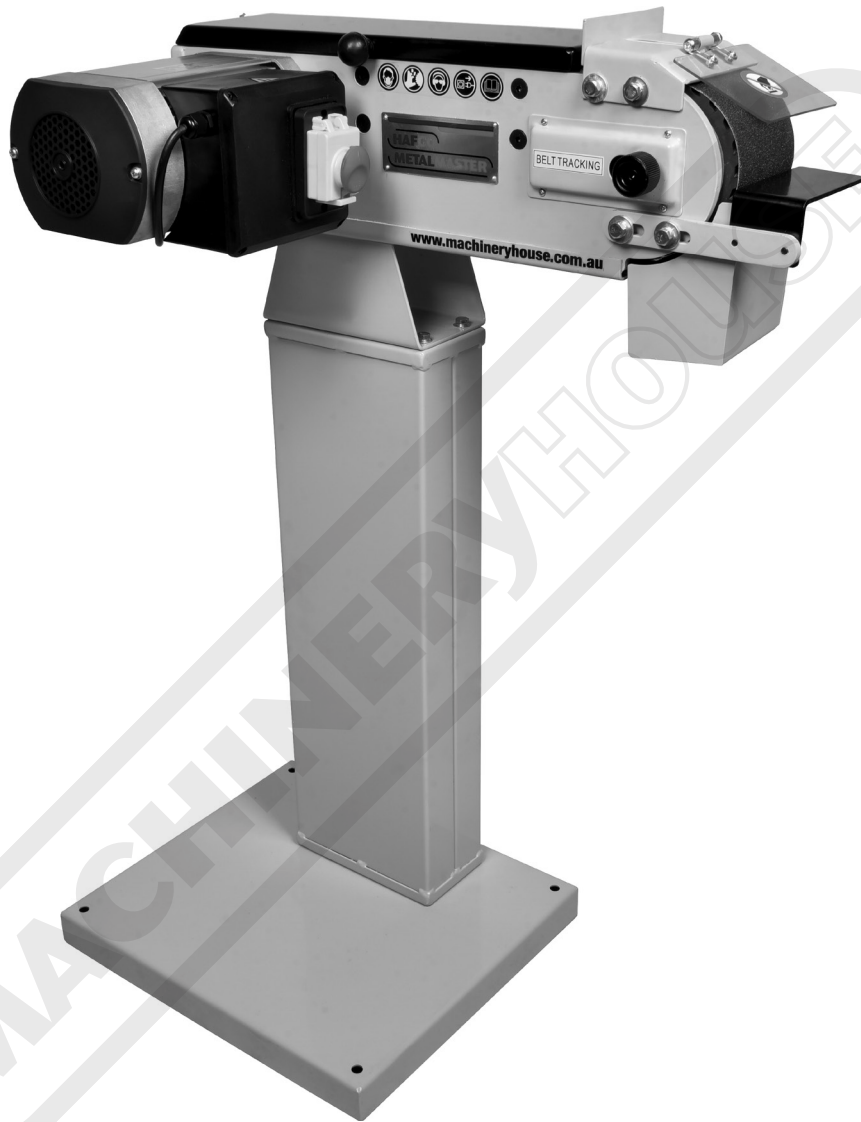


HAFCO METALMASTER



Edition : 1.0
Date: (03/25)

Instruction Manual

BELT LINISHER SANDER BS-48

Order Code: (L1185)

MACHINE DETAILS

MACHINE.	BELT LINISHER SANDER
MODEL NO.	BS-48
SERIAL NO.	
DATE OF MANF.	

Imported by

AUSTRALIA



www.machineryhouse.com.au

NEW ZEALAND



www.machineryhouse.co.nz

NOTE:

This manual is only for your reference. At the time of the compiling of this manual every effort to be exact with the instructions, specifications, drawings, and photographs of the machine was taken. Owing to the continuous improvement of the HAFCO METALMASTER machine, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating any electric machine.

SAFETY SYMBOLS:

The purpose of safety symbols is to attract your attention to possible hazardous conditions.



WARNING

Indicates a potentially hazardous situation causing injury or death.



CAUTION

Indicates an alert against unsafe practices.

Note:

Used to alert the user to useful information.

NOTE:

In order to see the type and model of the machine, please see the specification plate. Usually found on the back of the machine. See example (Fig.1)

HAFCO
METALMASTER

PRODUCT SPECIFICATIONS

Model: BS-48

Belt Size: 100 x 1220mm	Voltage: 240V/50Hz
Nett Weight: 42kg	Motor: 1.5kW/2hp
MFG Date:	FLC: 6.5A

Serial No:

Imported by www.machineryhouse.com.au Made in China www.machineryhouse.co.nz

FIG.1

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1.1 SPECIFICATIONS

Order Code	L1185
Model	BS-48
Type	Linisher Sander
Mounting Type (Bench / Pedestal)	Pedestal
Includes Stand	Yes
Belt Size (mm)	100 x 1220
Belt Speed (fpm / mpm)	5700 / 1740
Motor Speed (rpm)	2800
Motor Power (kW / hp)	1.5 / 2
Voltage (V)	240
Amps (A)	10
Dimensions WxHxL (mm) (Machine w/o stand)	630 x 410 x 355
Rear Dust Chute (mm)	74
Working Surface (mm)	100 x 290
Weight (kg)	50

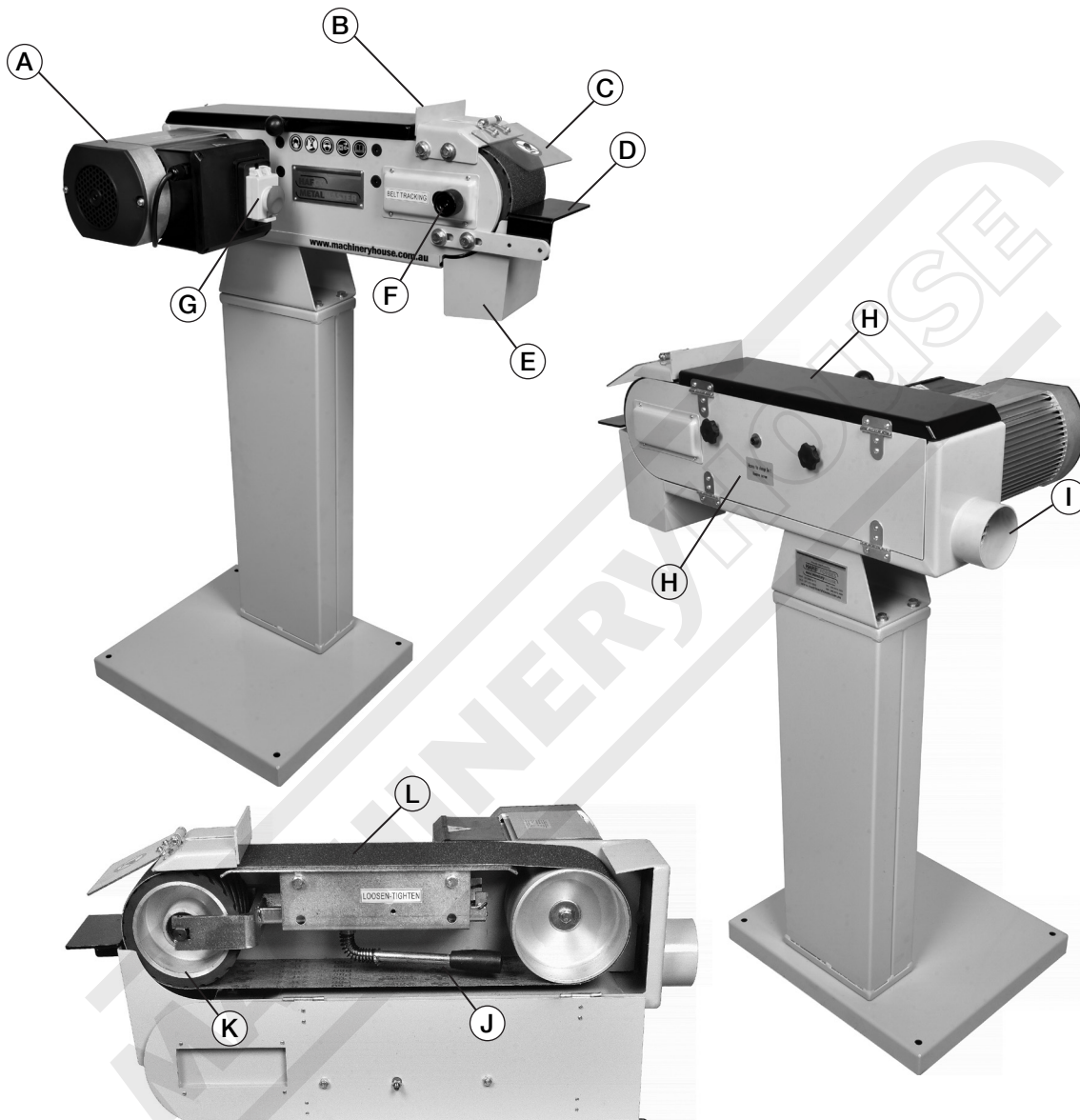
1.2 INCLUDED ACCESSORIES

1. Sanding Belt 100 x 1220mm
2. Stand



1.3 IDENTIFICATION

Become familiar with the names and locations of the controls and features shown below to better understand the instructions when mentioned later in this manual.



A	Motor	G	ON/OFF Buttons & Emergency Stop
B	Work Stop	H	Belt Guard
C	Eye Shield	I	Dust Chute
D	Work Rest	J	Belt Tension Lever
E	Spark Trap	K	Contact Wheel
F	Belt Tracking Adjustment Knob	L	Platen

2. IMPORTANT INFORMATION

2.1 GENERAL METALWORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation.



WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators. Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



- ✓ Always wear safety glasses or goggles.
- ✓ Wear appropriate safety footwear.
- ✓ Wear respiratory protection where required.
- ✓ Gloves should never be worn while operating the machine, and only worn when handling the workpiece.
- ✓ Wear hearing protection in areas > 85 dBA. If you have trouble hearing someone speak from one metre (three feet) away, the noise level from the machine may be hazardous.
- ✓ DISCONNECT THE MACHINE FROM POWER when making adjustments or servicing.
- ✓ Check and adjust all safety devices before each job.
- ✓ Ensure that guards are in position and in good working condition before operating.
- ✓ Ensure that all stationary equipment is anchored securely to the floor.
- ✓ Ensure all machines have a start/stop button within easy reach of the operator.
- ✓ Each machine should have only one operator at a time. However, everyone should know how to stop the machine in an emergency.

2.1 GENERAL SAFETY REQUIREMENTS Cont.

- ✓ Ensure that keys and adjusting wrenches have been removed from the machine before turning on the power. Appropriate storage for tooling should be provided.
- ✓ Ensure that all cutting tools and blades are clean and sharp. They should be able to cut freely without being forced.
- ✓ Stop the machine before measuring, cleaning or making any adjustments.
- ✓ Wait until the machine has stopped running to clear cuttings with a vacuum, brush or rake.
- ✓ Keep hands away from the cutting head and all moving parts.
- ✓ Avoid awkward operations and hand positions. A sudden slip could cause the hand to move into the cutting tool or blade.
- ✓ Return all portable tooling to their proper storage place after use.
- ✓ Clean all tools after use.
- ✓ Keep work area clean. Floors should be level and have a non-slip surface.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position any shade lighting sources so that they do not cause any glare or reflections.
- ✓ Ensure there is enough room around the machine to do the job safely.
- ✓ Obtain first aid immediately for all injuries.
- ✓ Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
- ✓ Clean machines and the surrounding area when the operation is finished.
- ✓ Use proper lock out procedures when servicing or cleaning the machines or power tools.

DO NOT

- × Distract an operator. Horseplay can lead to injuries and should be strictly prohibited.
- × Wear loose clothing, gloves, neckties, rings, bracelets or other jewellery that can become entangled in moving parts. Confine long hair.
- × Handle cuttings by hand because they are very sharp. Do not free a stalled cutter without turning the power off first. Do not clean hands with cutting fluids.
- × Use rags or wear gloves near moving parts of machines.
- × Use compressed air to blow debris from machines or to clean dirt from clothes.
- × Force the machine. It will do the job safer and better at the rate for which it was designed.

2.1 GENERAL SAFETY REQUIREMENTS Cont.

HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:

- Being struck by ejected parts of the machinery.
- Being struck by material ejected from the machinery.
- Contact or entanglement with the machinery.
- Contact or entanglement with any material in motion.

Health Hazards (other than physical injury caused by moving parts)

- Chemicals hazards that can irritate, burn, or pass through the skin.
- Airborne items that can be inhaled, such as oil mist, metal fumes, solvents, and dust.
- Heat, noise, and vibration.
- Ionizing or non-ionizing radiation. (X-ray, lasers, etc.)
- Biological contamination and waste.
- Soft tissue injuries (for example, to the hands, arms, shoulders, back, or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip.

Other Hazards

- Slips and falls from and around machinery during maintenance
- Unstable equipment that is not secured against falling over
- Safe access to/from machines (access, egress)
- Fire or explosion
- Pressure injection injuries from the release of fluids and gases under high pressure
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components
- Environment in which the machine is used (in a machine shop, or on a work site)



WARNING!

The machine is the sole responsibility of the owner for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training, proper inspection and maintenance, manual availability and comprehension. The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Machines are safeguarded to protect the operator from injury or death with the placement of guards. Machines must not be operated with the guards removed or damaged.

2.2 SPECIFIC SAFETY FOR LINISHER SANDER

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual



Safety glasses must be worn at all times in work areas



Long and loose hair must be contained or restrained



Sturdy footwear must be worn at all times in work areas



Close fitting/protective clothing must be worn



Gloves must not be worn when operating this equipment



Hearing protection must be worn when using this equipment.

PRE-OPERATIONAL SAFETY CHECKS

- ✓ Locate and ensure you are familiar with all machine operations including the E- Stop.
- ✓ Ensure all guards are fitted, secure and functional. Do not operate if guards are missing or faulty.
- ✓ Check the linishing belt is in a serviceable condition with no edge fraying, tears or holes.
- ✓ NEVER attempt to linish small items by hand without some form of method to secure them.
- ✓ Only one person may operate this machine at any one time.

OPERATIONAL SAFETY CHECKS

- ✓ Stand to the side out of the direct line of the abrasive belt.
- ✓ Let the machine gain maximum speed before starting to sand.
- ✓ Hold material firmly against stops or table before applying pressure on abrasive belt.
- ✓ Never force the workpiece against the belt. Apply gentle even pressure.

DON'T

- × Do NOT hold workpiece with gloves, cloth, apron or pliers.
- × Do NOT attempt to hold very small objects by hand.
- × Do NOT bend down near the machine while it is running.
- × DO NOT leave the machine running unattended.
- × DO NOT operate equipment without wearing appropriate PPE
- × DO NOT use the wrong type of belt or disc for the operation.
- × DO NOT Use faulty equipment. Immediately report any suspect equipment and apply a "Do Not Use" tag.

POST OPERATION

- ✓ Turn off the machine and wait until the linishing belt comes to a complete stop.
- ✓ Leave the machine and work area in a safe, clean and tidy condition.
- ✓ Dispose of any waste material in the appropriate bins provided

POTENTIAL HAZARDS

- Rotating parts – Entanglement
- Sparks
- Eye injuries
- Hot metal – Burns
- Noise
- Sharp edges and burs



3. POWER SUPPLY

3.1 ELECTRICAL REQUIREMENTS

Place the machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure there is access to a means of disconnecting the power source. The electrical circuit must meet the requirements for 240V. To minimize the risk of electrocution, fire, or equipment damage, these machines should be hard wired with installation work and electrical wiring done by a qualified electrician.

NOTE : The use of an extension cord is not recommended as it may decrease the life of electrical components on your machine.

ELECTRICAL REQUIREMENTS

Nominal Voltage.....	240V
Cycle.....	50 Hz
Phase.....	Single Phase
Power Supply Circuit.....	10 Amps
Full Load Current.....	6.5 Amps

(Full load current rating is also on the specification plate on the motor.)

3.2 FULL-LOAD CURRENT RATING

The full-load current rating is the amperage a machine draws when running at 100% of the output power. Where machines have more than one motor, the full load current is the amperage drawn by the largest motor or a total of all the motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating for these machine can be found on the motor nameplate. It should be noted that the full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating and if the machine is overloaded for a long period of time, damage, overheating, or fire may be caused to the motor and circuitry.

This is especially true if connected to an undersized circuit or a long extension lead. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements.



4 SET-UP

4.1 UNPACKING

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

NOTE: Save all the packaging materials until you are completely satisfied with the machine and have resolved any issues with the distributor, or the shipping agent.

When unpacking, check the packing list to make sure that all parts shown are included. If any parts are missing or broken, please contact your distributor.

4.2 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.

Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust preventive products.

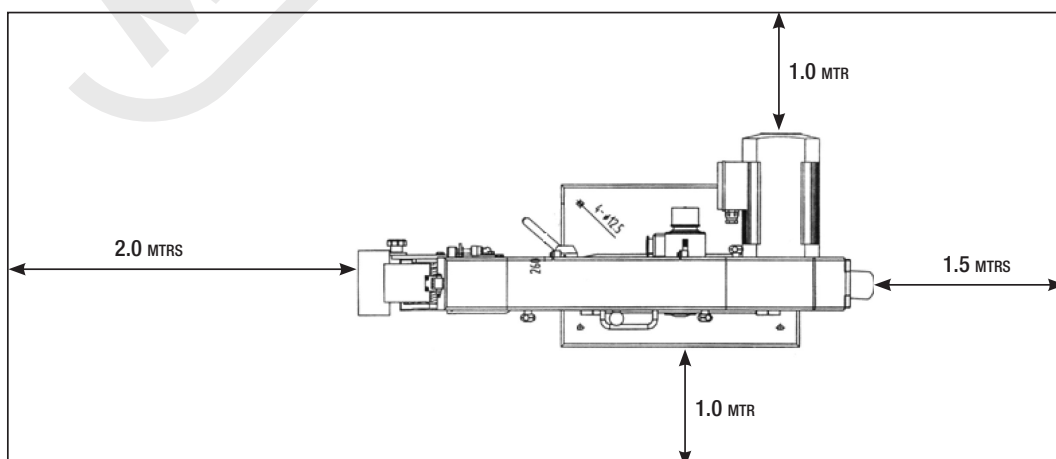
It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

4.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

Below is the recommended space required to operate the machine efficiently. (Dimensions not to scale)



4.4 LIFTING INSTRUCTIONS



WARNING

This machine is extremely heavy. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.



On the day that the machine arrives, make sure that a forklift or lifting device, with sufficient capacity is available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.

Lifting Point

When lifting the machine only certified lifting slings should be used.

Ensure that when lifting, the machine does not tip over.

Check that the lifting slings do not interfere or damage any parts of the machine. (Fig. 4.1)



Fig. 4.1

4.5 ANCHORING TO THE FLOOR

Options For Mounting

The machine is best mounted on a concrete slab. Masonry anchors with bolts are the best way to anchor machinery, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later if needed. (Fig. 4.2)

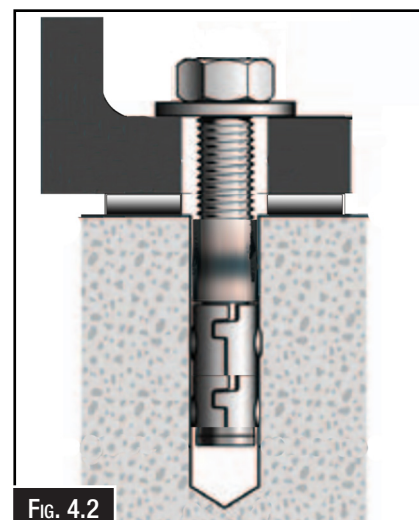
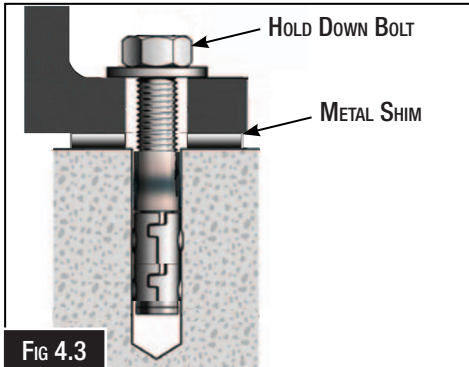


Fig. 4.2

4.6 MACHINE LEVELING

To set your machine up so that it operates to optimum performance, apply the following procedure. After your machine has been anchored to a concrete slab floor, it then needs to be leveled. Loosen the hold down bolts and place a level on the surface of the working table. Metal shims need to be placed under the corner of the base of the machine until level. Once level then tighten the hold down bolts. (Fig. 4.3).



4.7 ASSEMBLY

The machine must be fully assembled before it can be operated. First clean any parts that are coated in rust preventative to ensure the assembly process can proceed smoothly.

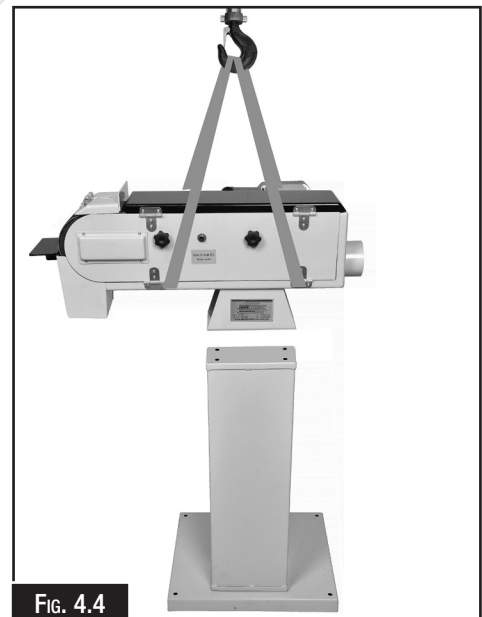
Safety regulations for set-up

Rated safety devices must be used when suspending the machine during set-up. Equipment used for lifting the machine must only be used by specially authorized personnel.

Installation

The machine is delivered in a cardboard case and should be placed on level ground or on a table strong enough to take the weight of the machine.

After unpacking all the parts, attach the column to the base with the 4 off M8x20mm bolts nuts and washers. Then place the stand on the floor and using a lifting device lift the body of the machine onto the stand and secure with the 4 off M8 x20mm bolts M8 washers and M8 nuts. (Fig. 4.4)



Eye Shield:

Locate the clear eye shield and attach to the bracket using the 2 off M4 x 10mm Cup head screw and M4 nuts. (Fig. 4.5)

4.8 TEST RUN

Once assembly is complete, test run the machine to ensure it is properly connected to the power and safety components are functioning correctly. Check that the direction of the motor is correct and make sure that the machine rotates in the correct direction.

If the direction is incorrect, isolate the machine and have the electrician make changes to the wiring.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The Troubleshooting table in the Maintenance section of this manual may be able to help. If the problem persists then contact your dealers service technician.

To test run the machine:

1. Connect the machine to the power supply.
2. Make sure that the manual has been read and that the safety instructions at the beginning of the manual are understood. Make sure the machine has been setup correctly
3. Make sure all tools and objects used during set up have been cleared away from the machine.
4. Turn the machine ON.
5. Make sure that the machine is traveling in the correct direction.
6. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.
7. Any strange or unusual noises should be investigated and corrected before operating the machine again. Always disconnect the machine from power supply when investigating or correcting potential problems. The troubleshooting chart in the maintenance section may be helpful in rectifying a problem.

Testing The Emergency Stop Button

Make sure that the emergency button is working correctly

1. Start the machine and then press the emergency stop button. The machine should stop and the power should be cut off. If the machine cannot be started then the emergency stop is working correctly. To reset the Emergency Stop release the catch so that the top opens and the start and stop button are exposed..
3. Press the start button and the machine should now work again.



CAUTION!

It must be determined by the operator that the materials being processed through the machine are NOT potentially hazardous to operator or personnel working nearby.

5. OPERATION

5.1 CONTROLS

This section helps the operator understand the control items and how they work. This will help the operator understand the rest of the manual and minimize the risk of injury when operating this machine.

- A. ON/OFF & Emergency Switch:** ON button turns motor ON; OFF button turns motor OFF. Depressing the Emergency Stop button on the cover will turn the motor OFF and prevent motor start until the cover is released and the buttons exposed. (Fig. 5.1)



- B. Belt Tracking Adjustment Knob:** Fine tunes the belt tracking along platen and wheels while the motor is running. (Fig. 5.1)

- C. Belt Tension Lever:** Releases and engages the belt tension when removing or replacing. (Fig. 5.2)

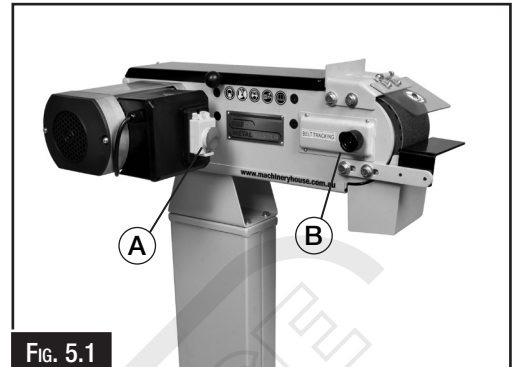


Fig. 5.1

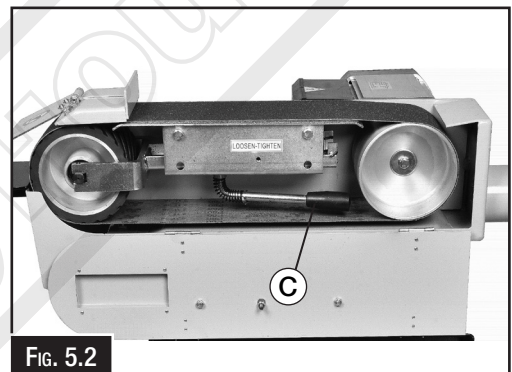


Fig. 5.2

5.2 GUIDE TO BELT SELECTION

Determine your project type - What material will be sanded (wood, metal, etc.) and what is your desired outcome (smoothing, shaping, finishing, etc.)

Identify the sanding machine being used - What kind of belt sander will be used? Handheld belt sander, stationary belt sander, or other types? Different machines require specific belt sizes and types.

Choose the appropriate abrasive grain - Take into consideration the material being sanded and what kind of finish is needed. Choose from options like aluminum oxide, zirconia, ceramic, silicon carbide, or non-woven based on the material and project goals.

Select the right grit - Grit size determines coarseness. Choose between coarse (for material removal), medium (for general sanding), or fine (for finishing) grits.

Consider the backing material - The backing material affects its flexibility and strength. Common backing materials include paper, cloth, and polyester. Each of these backing types also have their own "weights" with different features.

Decide on the belt size - Choose a belt that is compatible with your machine.

5.3 TIPS FOR GRINDING

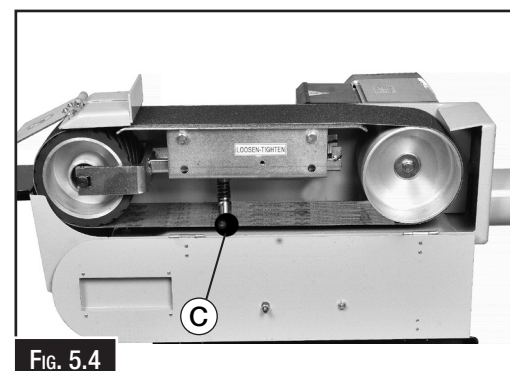
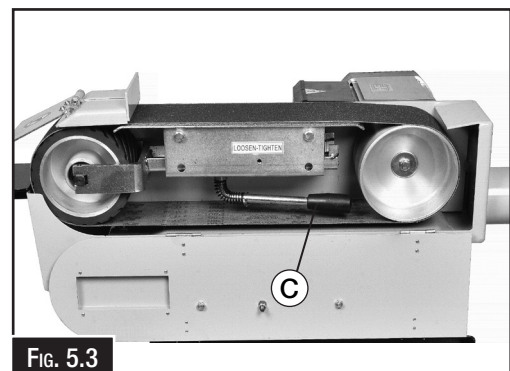
- When grinding against the contact wheel, make sure the belt guard is closed.
- Hold the workpiece securely with both hands. Use rests or stops where possible to support the workpiece.
- Never grind magnesium. Once shaved or powdered it is highly flammable and the fire is extremely difficult to extinguish.
- The grinding of metal often produces sparks. DO NOT allow anyone to stand in the path of the sparks. DO NOT grind metal near flammable materials.
- Make sure the side cover is closed and latched during operation.
- Choose the correct belt for the job. Change the belts frequently for the best performance.
- The workpiece will get hot as you continue to grind. Cool the workpiece frequently by quenching in water or another approved solution. Allow the workpiece to dry before allowing it to contact the abrasive belt.
- Wear the proper protective clothing. Prepare for particles expelled from the grinder at high speeds. Wear safety glasses, face shield, dust mask, earplugs, leather apron, and heavy leather boots

5.4 CHANGING THE BELT

The effectiveness of the process can only be obtained when using a completely clean grinding belt. To ensure this, the belt may need to be replaced.

To change the belt:

1. DISCONNECT THE MACHINE FROM THE POWER
2. Ensure the belt is at a complete standstill.
3. Open the side guard with tools.
4. Loosen the belt by moving the belt tension release lever from Tighten to Loosen. (C in Fig. 5.3)
5. Replace the belt.
6. Tighten the belt by moving the belt tension release lever from Loosen to Tighten. (C in Fig. 5.3)
7. Close and secure the side guard.
8. Adjust the tracking of the belt so it runs in the centre of the pulleys.



5.5 ADJUSTING THE BELT TRACKING

Belt Tracking is needed to make sure that the belt stays in the centre of the pulleys during the operation. It needs to be checked every time the belt is changed.

To check the belt tracking:

1. DISCONNECT THE MACHINE FROM THE POWER
2. Open the belt access cover.
3. Stand at the rear of the linisher, rotate the drive wheel with one hand and observe how the belt tracks. (C in Fig. 5.5)
 - If the sanding belt moves towards the motor, rotate the tracking knob clockwise 1/4 of a turn.
 - If the sanding belt tracks away from the motor, rotate the tracking knob counterclockwise 1/4 of a turn. (D in Fig. 5.6)
4. When the belt is tracking in the center of the platen and the wheels, close and secure the belt access cover.
5. Connect the power to the machine and turn it ON. Check the belt is tracking in the centre of the platen and wheels. Fine-tune the tracking as required while the linisher is running.



Fig. 5.5



Fig. 5.6

5.6 GRINDING TECHNIQUES

Flat Grinding (Fig. 5.7)

Flat grinding operations can be performed directly on the belt against the platen. Always use two hands to control the workpiece and use the work stop to support it.

Ease the workpiece slowly into the belt making sure it is against the stop. Use light pressure.

NOTE: DO NOT force the workpiece into the belt.

End Grinding (Fig. 5.8)

End grinding operations are performed on the front end of the grinder with the workpiece pressing against the contact wheel. For additional control over the workpiece, use the work rest to support the workpiece during operations. Always use two hands to maintain best control.



Fig. 5.7



Fig. 5.8

6. MAINTENANCE

Normal maintenance of the contact wheel and the steering roller is required. The outside cover of the belt grinder and the dust in the outlet should be frequently cleaned and kept tidy. Scrap material should be removed immediately to prevent jamming the belt and causing injury to the operator or damage to the machine.



CAUTION

Before attempting this feature, disconnect the machine from the power supply to avoid injury to the operator from accidental startup or damage to the machine

6.1 TROUBLESHOOTING

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts then follow the procedure in the beginning of the spare parts section or if additional help with a procedure is required, then contact your distributor.

Note: Make sure you have the model of the machine, serial number, and manufacture date before calling.

Symptoms	Possible Cause	Possible Solution
The machine will not start	<ol style="list-style-type: none"> 1. Unplugged from power supply 2. Protector is tripped 3. Power cord is damaged 	<ol style="list-style-type: none"> 1. Check all plug connections 2. Replace fuse or reset circuit breaker 3. Replace cord
Belt does not come up to speed	<ol style="list-style-type: none"> 1. Extension cord too light or too long 2. Motor is not wired for proper voltage 3. Low current 	<ol style="list-style-type: none"> 1. Replace with adequate size and proper length cord 2. Refer to motor junction box for proper wiring 3. Contact a qualified electrician
Machine vibrates excessively	<ol style="list-style-type: none"> 1. Stand on uneven floor 2. Motor mounts are loose 3. Tension spring is worn or broken 	<ol style="list-style-type: none"> 1. Adjust base so that it rests evenly on the floor 2. Tighten motor mount bolts. 3. Replace spring
Abrasive belt keeps tearing	<ol style="list-style-type: none"> 1. Belt is running in the wrong direction 	<ol style="list-style-type: none"> 1. The sanding belt should be running in the same direction as the rotation label.
Sanded edge not square	<ol style="list-style-type: none"> 1. Table isn't square to sanding platen 	<ol style="list-style-type: none"> 1. Use a square to adjust table to the sanding platen
Sanding marks on workpiece	<ol style="list-style-type: none"> 1. Workpiece is held still 2. Wrong grit sanding belt 3. Feed pressure too great 4. Sanding against the grain 	<ol style="list-style-type: none"> 1. Keep workpiece moving 2. Use coarser grit for stock removal and fine grit for finish sanding. 3. Never force the workpiece into sanding platen 4. Sand with the grain
Grains easily rub off belt.	<ol style="list-style-type: none"> 1. Belt has been stored in damp environment. 2. Belt has been smashed or folded. 3. Replacement belt is too old. 	<ol style="list-style-type: none"> 1. Replace damaged belt. Store belt in a cool, dry area. 2. Replace damaged belt. Do not bend or fold belt. 3. Use new belt.
Deep sanding grooves or scratches in workpiece.	<ol style="list-style-type: none"> 1. Excessive pressure while grinding. 2. Workpiece held still for too long against belt. 3. Belt too coarse. 4. Platen worn. 	<ol style="list-style-type: none"> 1. Reduce feed workpiece pressure. 2. Keep workpiece moving while grinding. 3. Use finer grit belt. 4. Replace platen.
Snake-shaped marks on workpiece.	<ol style="list-style-type: none"> 1. Belt loaded up. 2. Belt damaged. 3. Platen worn. 	<ol style="list-style-type: none"> 1. Clean belt. 2. Replace belt. 3. Replace platen.
Belt clogs quickly.	<ol style="list-style-type: none"> 1. Excessive pressure while grinding. 2. Belt worn or damaged. 3. Workpiece material is prone to belt clogging, such as soft aluminum. 	<ol style="list-style-type: none"> 1. Clean belt, and then reduce workpiece pressure. 2. Replace belt. 3. Reduce feed pressure. Use coarser-grit belt.

BELT LINISHER SANDER

BS-48

Order Code: (L1185)

Edition : 1.0
Date: (04/25)

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at anytime without notification.

HOW TO ORDER SPARE PARTS

1. Have your machines model number, serial number & date of manufacture on hand, these can be found on the specification plate mounted on the machine.
2. A scanned copy of your parts list/diagram with required spare part/s identified.

NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.



WARNING!

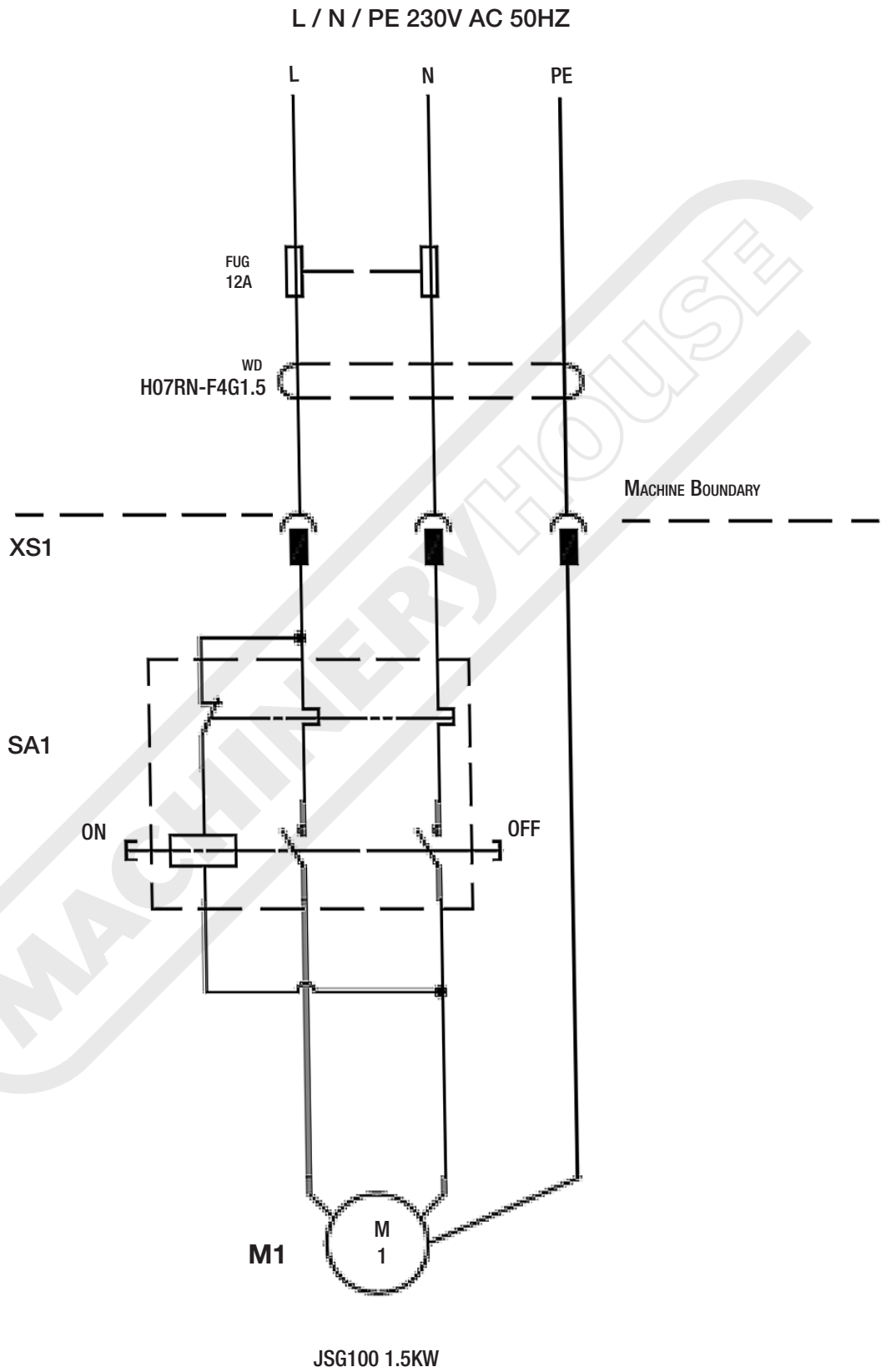
*Electricity is dangerous and could cause death
All electrical work must be carried out by a qualified electrician.*



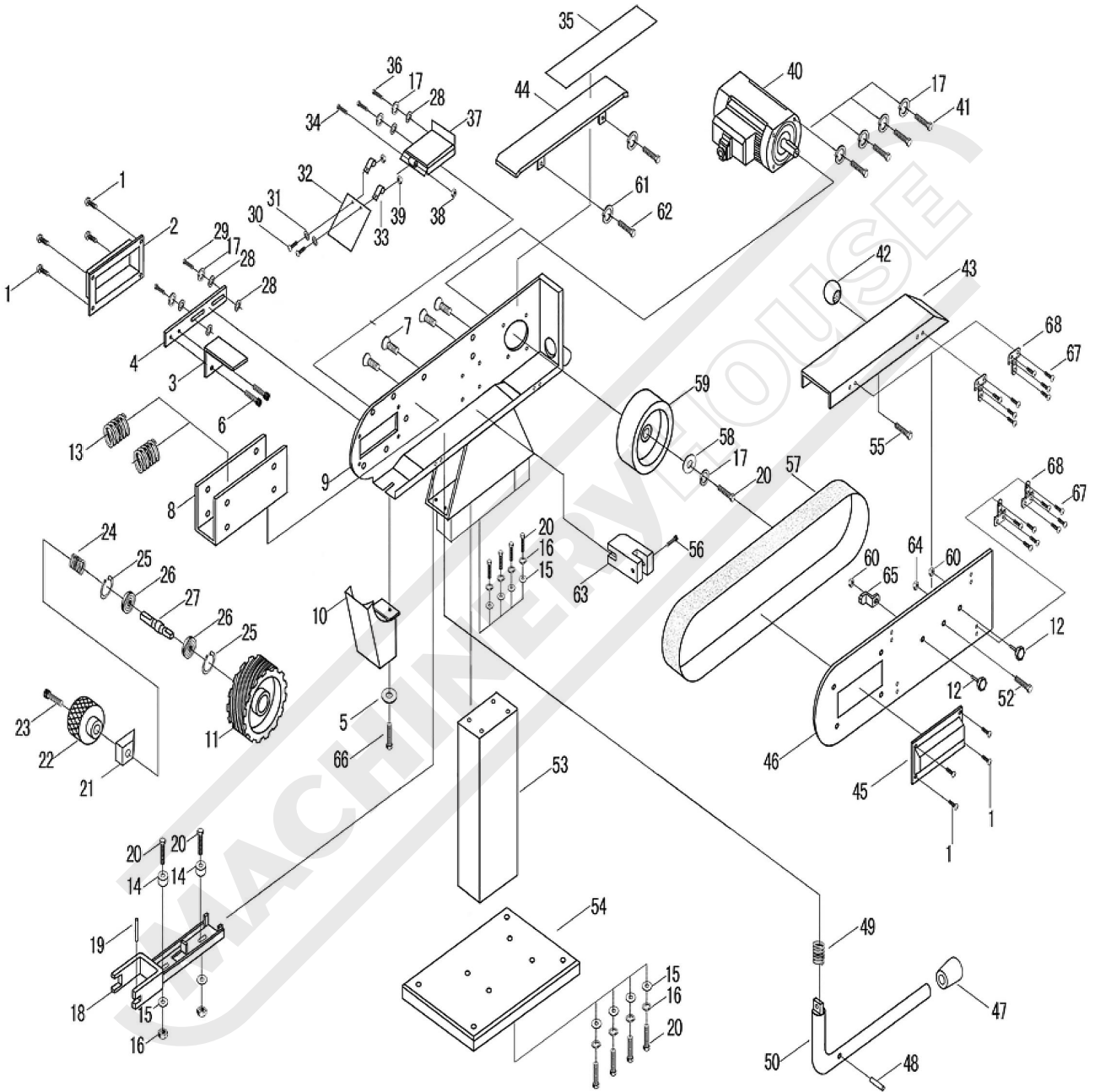
CAUTION!

It is impossible to cover all possible hazards Every workshop environment is different. These are designed as a guide to be used to compliment training and as a reminder to users prior to equipment use. Always consider safety first, as it applies to the individual working conditions.

WIRING DIAGRAM



SPARE PARTS DIAGRAM



SPARE PARTS LIST

ITEM	DESCRIPTION	QTY	ITEM	DESCRIPTION	QTY.
1	CUP HEAD SCREW M4X6	8	35	BLACK LEAD PLATE	1
2	LEFT COVER	1	36	BOLT M8X12	2
3	WORK TABLE	1	37	FENCE EXTENSIONS	1
4	FIXATION BOARD OF WORK TABLE	1	38	SELF-LOCKING NUT M6	1
5	FLAT WASHER Ø8	1	39	NUT M4	2
6	HEXAGONAL SOCKET SCREW M6X10	2	40	MOTOR	1
7	HEADING-EXTRUSION SCREW M8X16	4	41	BOLT M8X20	4
8	STOP BLOCK	1	42	HAND BALL	1
9	BODY	1	43	SAFETY GUARD	1
10	DUST RECEIVER	1	44	SUPPORT PLATE	1
11	DRIVEN WHEEL	1	45	RIGHT COVER	1
12	SCREW M6X12	2	46	SIDE FENCE	1
13	SPRING	2	47	PROTECT TUBE	1
14	POSITION TUBE	2	48	PIN 3X20	1
15	FLAT WASHER Ø8	12	49	SPRING	1
16	NUT M8	2	50	HAND BAR	1
17	ELASTIC WASHER Ø8	23	51	BASE (DELETE)	1
18	DRIVEN WHEEL GUIDE	1	52	BOLT M6X18	1
19	COLUMN PIN Ø5X35	1	53	STAND	1
20	BOLT M8X20	5	54	STAND PLATE	1
21	SHAFT BLOCK	1	55	SCREW 6X16	1
22	HAND WHEEL	1	56	HEXAGONAL SOCKET SCREW M5X20	1
23	HEXAGONAL SOCKET SCREW M6X30	1	57	SAND BELT	1
24	SPRING	1	58	BIG WASHER Ø32	1
25	RETAINING RING Ø47	2	59	DRIVE WHEEL	1
26	BEARING 204	2	60	SELF LOCK NUT M6	2
27	DRIVEN WHEEL SHAFT	1	61	ELASTIC WASHER Ø8	2
28	BIG FLAT WASHER Ø8	6	62	BOLT M8X12	2
29	BOLT M8X20	2	63	HAND BAR COLLECTING ROD	1
30	CUP HEAD SCREW M4X10	2	64	SELF- LOCK NUT M6	1
31	FLAT WASHER Ø4	2	65	SPRING PLATE	1
32	PERSPECTIVE PLATE	1	66	BOLT M6X12	1
33	COLLECTING BOARD	2	67	CUP HEAD SCREW M4X6	16
34	CUP HEAD SCREW M6X50	1	68	HINGE	4

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY



ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

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