OPERATOR'S MANUAL

Metal Working

BELT / DISC SANDER

MODEL: DBG-106-V2

Baileigh Industrial Holdings LLC
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Rev. 03/2021

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THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial Holdings LLC. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without an RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without a RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTIAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.

Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy.

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial Holdings LLC makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial Holdings LLC reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:
Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at sales@baileigh.com

INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial Holdings LLC machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However, if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Setup and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial Holdings LLC and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any modifications.

Note: *This symbol refers to useful information throughout the manual.*

IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.

SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**

Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

DANGER: Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING: Indicates a hazardous situation which, if not avoided, could result in death or serious injury.

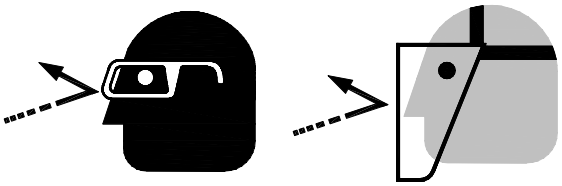
CAUTION: Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE: Indicates a situation which, if not avoided, could result in property damage.

SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.

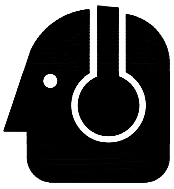
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



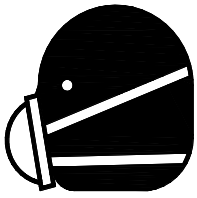
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as earmuffs or earplugs to protect against objectionable or uncomfortable loud noises.



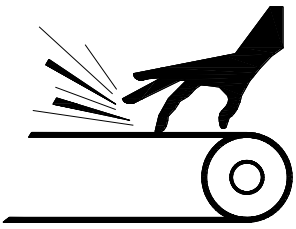
DUST HAZARD

Wear appropriate dust mask. Dust created while using machinery can cause cancer, birth defects, and long-term respiratory damage. Be aware of the dust hazards associated with all types of materials.



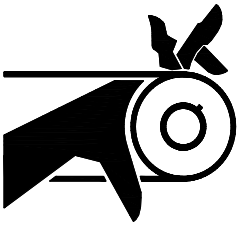
MOVING BELT ABRASIONS

DO NOT place hands or fingers near, or in contact with sanding belt during operation.



MOVING BELTS CAN CRUSH AND DISMEMBER

DO NOT allow fingers to get pinched between belt and belt rollers. This may pull the operator's hand into the machine causing serious personal injury. **DO NOT** operate without guards in place.



CALIFORNIA PROPOSITION 65

WARNING: Cancer and Reproductive Harm.
www.P65Warnings.ca.gov

SAFETY PRECAUTIONS

Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.
Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.
REMEMBER: Your personal safety is your responsibility.

WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

Dear Valued Customer:

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

PLEASE ENJOY YOUR BAILEIGH MACHINE! ....PLEASE ENJOY IT SAFELY!

Abrasive sanding can be hazardous to operators and bystanders. Sanding sparks, chips, and dust particles thrown off by the sanding disc can cause serious injury if contacted or inhaled. To avoid such injuries you must comply with the following safety requirements:

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Use eye protection**. Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be

impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.

3. **Wear** leather safety gloves, arm guards, leather aprons, and safety shoes.
4. **A dust collection system is recommended**, The operator should also wear a dust mask at all times.
5. Additional precautions may be necessary for sanding materials which are flammable or have other hazardous properties. You should always consult the manufacturer of such materials for instructions on sanding and handling.
6. **Before sanding**, always allow the motor to come up to operating speed, then check the sanding disc for wobble, run out, or any unbalanced condition. If the disc is not operating accurately and smoothly, immediately stop the motor and make repairs before attempting any sanding operations.
7. Abrasive discs must be stored in a controlled environment area. Relative humidity should be 35% to 50% and the temperature should be between 60° and 80° Fahrenheit. Failure to do so could cause premature disc failure.
8. Examine the face of the sanding disc carefully. Excessive sanding that wears down to the backing material can tear the disc. Never use a disc which shows backing, nicks or cuts on the surface or edge or damage due to creasing or poor handling.
9. When installing a new disc, be certain the disc is accurately centered on the drive wheel. Failure to do so could cause a serious unbalanced condition.
10. Always present the piece part to the wheel while resting the piece part firmly on the table. Failure to do so could result in damage to the piece part or throwing the piece part off the wheel.
11. Personal hearing protection such as ear plugs or ear muffs should be used to protect against the effect of noise exposure.
12. Only trained and qualified personnel can operate this machine.
13. Make sure guards are in place and in proper working order before operating machinery.
14. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
15. **Keep work area clean.** Cluttered areas invite injuries.
16. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
17. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machines rated capacity.
18. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.

19. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
20. Do not overreach. Maintain proper footing and balance at all times. DO NOT reach over or across a running machine.
21. **Stay alert**. Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
22. **Check for damaged parts**. Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
23. **Observe work area conditions**. **DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
24. **Keep children away**. Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
25. **Store idle equipment**. When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
26. **DO NOT operate machine if under the influence of alcohol or drugs**. Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
27. Wear oil-free protective garments such as leather gloves, heavy shirt, high shoes or boots, cuffless trousers, and a cap.
28. **DO NOT** touch live electrical components or parts.
29. **Turn off power** before checking, cleaning, or replacing any parts.
30. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
31. Keep all cords dry, free from grease and oil, and protected from sparks and dust.
32. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill!**
33. **DO NOT** bypass or defeat any safety interlock systems.
34. Keep visitors a safe distance from the work area.

TECHNICAL SPECIFICATIONS

Electrical	
Motor Type	Totally Enclosed Fan Cooled
Motor Power	1hp (0.75kw)
Motor Voltage	115V / 230V, 1ph, 60hz, Pre-Wired 115V
Motor Listed FLA (full load amps)	10 / 5.5 A
Power Requirements	115V, 60hz, 16A
On/off Switch	Toggle Switch
Motor Speed	3,450 RPM
Power Cord	16 AWG x 3C, 6 ft. SJT
Power Plug	5-15P, 125V/15A, installed
Recommended Circuit Size	Subject to local and national electrical codes
Sound Emission	80dB at 3 ft. without load
Belt Sander:	
Belt Speed	1,650 SFPM (503 m/min)
Belt Size and Grits	4” x 48” (153 x 1219 mm), 80 Grit
Dust Port (O.D.)	2.5” (63.5 mm)
Platen	Cast Iron
Belt Table	Cast Iron, 6” x 10.5” (153 x 267 mm)
Belt Table Miter Slot	0.625” [5/8 in.] (16 mm)
Disc Sander:	
Disc Speed	2,100 RPM
Abrasive Disc Size and Grit	10” (254 mm), 80 Grit
Disc Table	Cast Iron, 7.5” (153 x 267 mm)
Disc Table Miter Slot	0.625” [5/8 in.] (16 mm)
Disc Table Tilt	45 Degree Out
Dust Port (O.D.)	2.5” (63.5 mm)
Dimensions and Weight:	
Overall Dimensions, Sander and Stand (L x W x H)	23” x 26” x 61” (584 x 660 x 1550 mm)
Packing Material	Corrugated Box and Styrofoam
Packing Dimension for Sander (L x W x H)	28.56” x 16.5” x 16.875” (726 x 420 x 428 mm)
Packing Dimension for Stand (L x W x H)	22.125” x 15.85” x 24.875” (562 x 402 x 632 mm)
Net Weight for Sander / Stand	120 / 43 lbs. (54.40 / 19.40 kg)
Gross Weight for Sander / Stand	125 / 47 lbs. (56.60 / 21.20 kg)

Feature

- For added safety, the combination 6”x48” belt and 10” disc sander follows strict guidelines and electrical requirements to be UL Listed
- Removable safety key switch
- Quick-release tension mechanism makes belt changes quick and easy
- Enclosed base protects motor from dust and debris
- Two cast iron tilting tables for mitering applications
- Full access to the belt when tilted in the horizontal position
- Dust collection shrouds on belt and disc
- Heavy-duty one-piece steel stand
- 80 Grit Belt & Disc Provided on machine
- Miter gauge included

TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990 and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileigh.com, Phone: 920.684.4990, or Fax: 920.684.3944.

***Note**: The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*

***Note:** The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.*

UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.
If any parts are missing, DO NOT place the machine into service until the missing parts are obtained and installed correctly.

Cleaning

WARNING: DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.
Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.

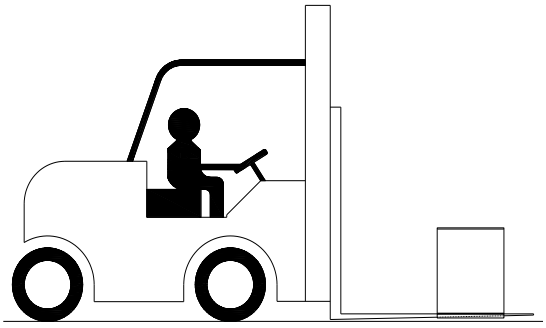
Important: *This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.*

TRANSPORTING AND LIFTING

NOTICE: *Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.*

Follow these guidelines when lifting with truck or trolley:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a forklift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.



- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.

INSTALLATION

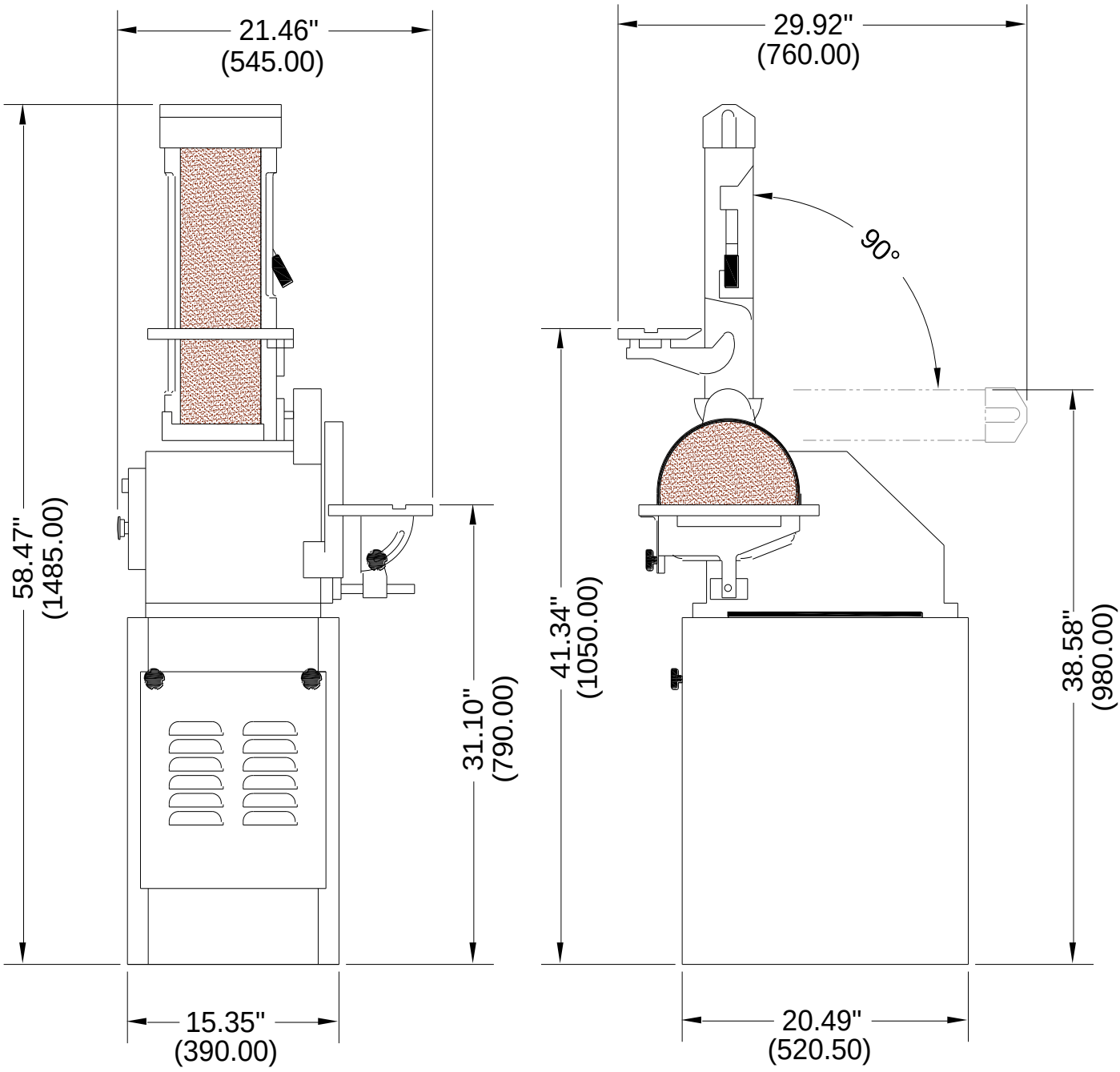
IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

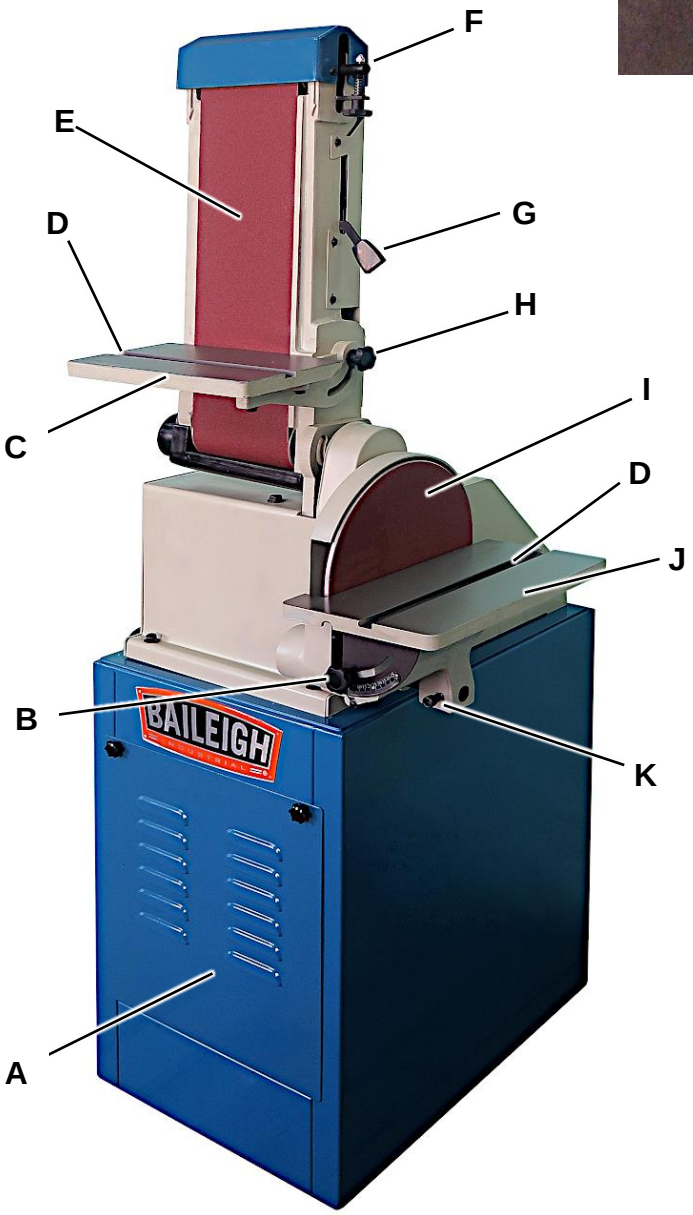
- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, worktables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.

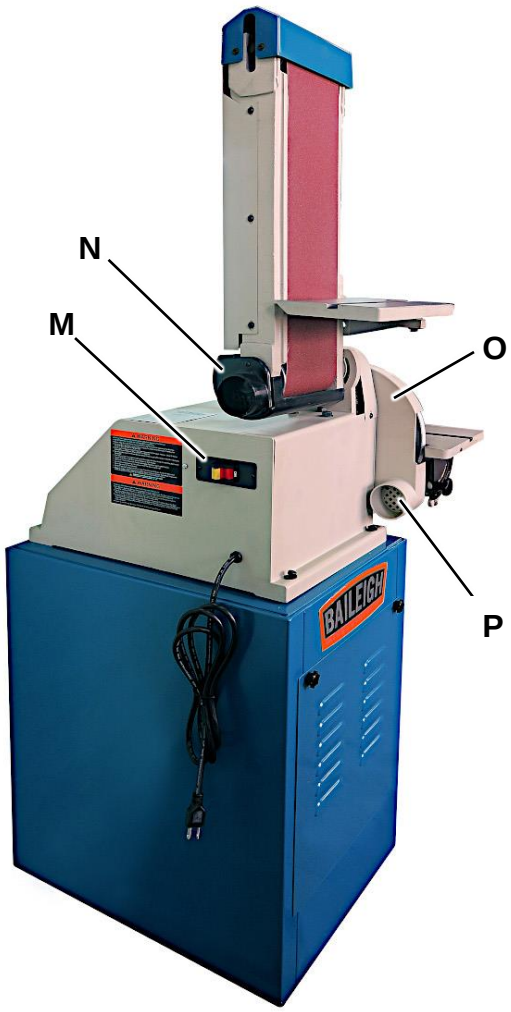
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This machine distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

OVERALL DIMENSIONS

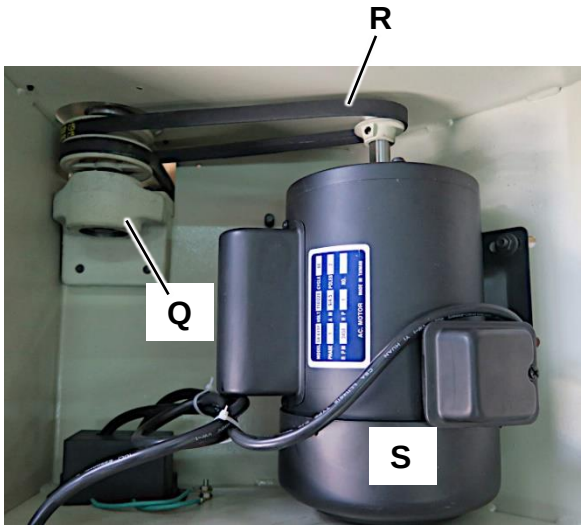


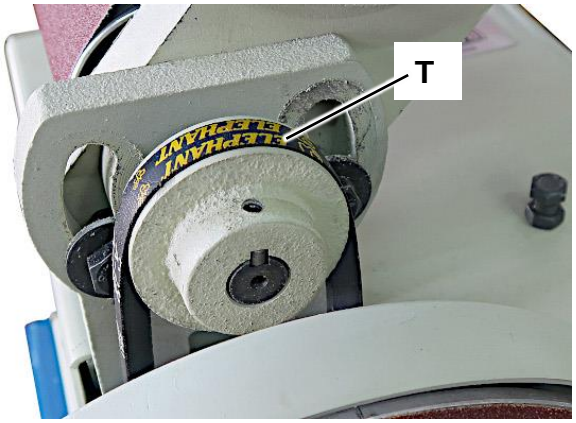
GETTING TO KNOW YOUR MACHINE





Item	Part Name
A	Panel (Remove to bolt stand to floor)
B	Table Angle Adjustment Gauge
C	Belt Table
D	Miter Gauge Slot
E	Sanding / Grinding Belt
F	Tracking Knob
G	Belt Tightener Lever
H	Table Adjustment Knob
I	Sanding / Grinding Disc
J	Disc Table
K	Table Adjustment Bolt
L	Belt Arm Adjustment Bolt
M	On/Off/E-Stop Switch with Remove Lock Out
N	Plastic Dust Chute
O	Disc Shroud
P	Dust Outlet
Q	Bearing Block
R	Main Drive Belt (A-25)
S	Drive Motor
T	Auxiliary Drive Belt (A-18)





ELECTRICAL

CAUTION: HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!
Check if the available power supply is the same as listed on the machine nameplate.

WARNING: Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

Power Specifications

Your machine is 115V/230V pre-wired for 115 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.
Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is ±5%, and for the frequency is ±1%.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. Before connecting the motor to the power line, make sure the switch is in the “OFF” position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- 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 machine 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.

WARNING: In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in 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 qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

	LENGTH		
AMP RATING	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
	WIRE GAUGE		

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

Power cord connection:

1. Determine if this machine will be run on 115V or 230V power.
    a. If this machine will be run at 115V. Proceed to step 2.
    b. If this machine will be run on 230V. Proceed to the “Voltage Change” instructions and then return to these instructions at step 2.
2. Turn the power switch on the control panel to the OFF position.
3. Unwrap the power cord and route the cord away from the machine toward the power supply.
    a. Route the power cord so that it will NOT become entangled in the machine.
    b. Route the cord to the power supply in a way that does NOT create a trip hazard.
4. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
5. When the machine is clear of any obstruction. The power switch may be turn ON to test the operation.
6. Turn the switch OFF when the machine is not in operation.

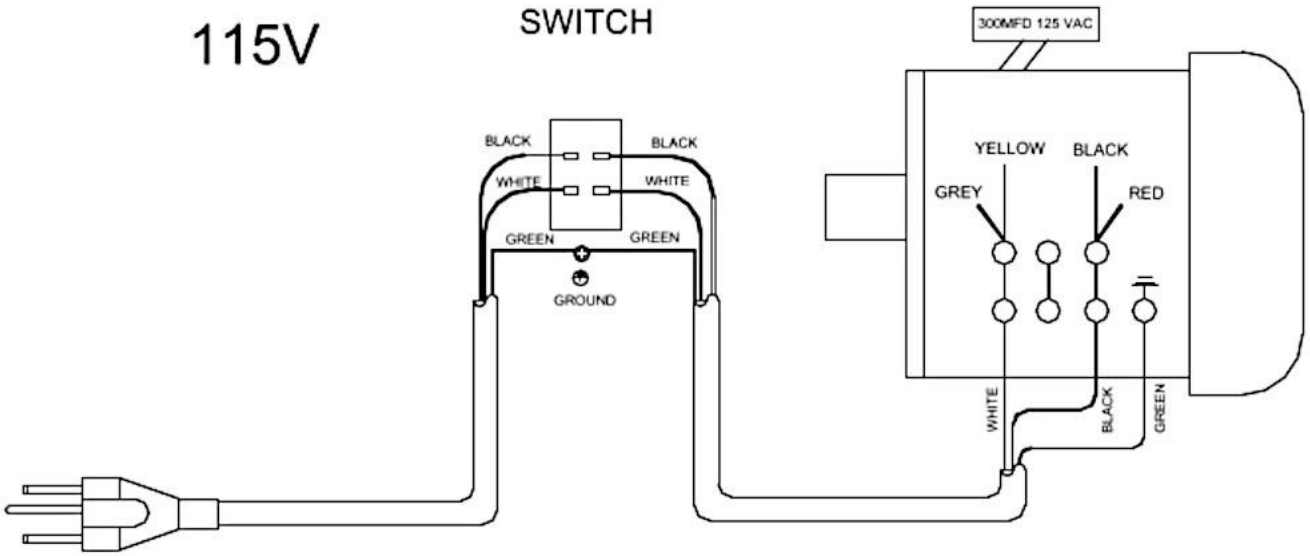
Voltage Change

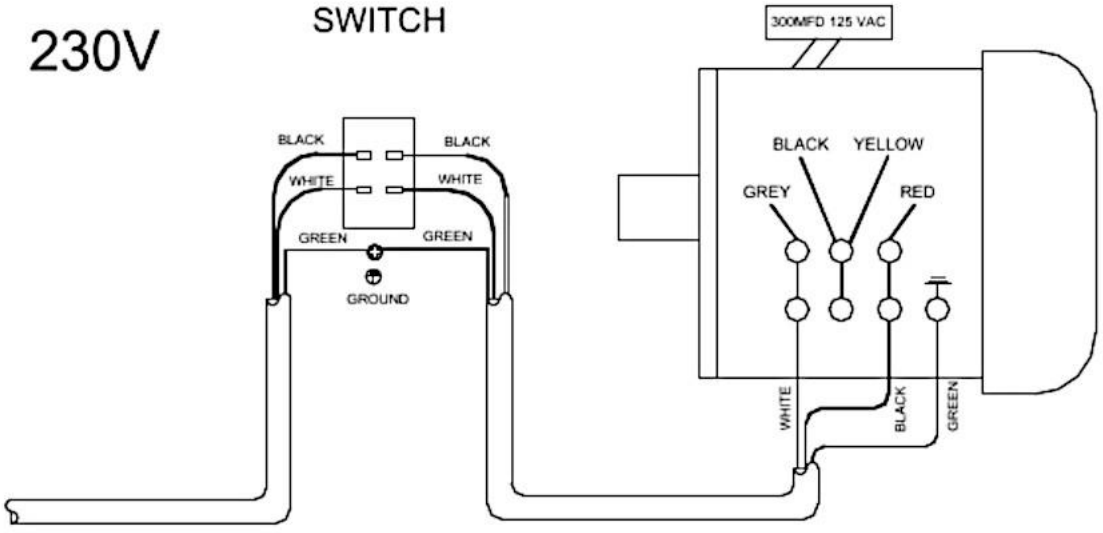
This belt/disc sander is prewired for 115 volt input power, but can be converted to 230 volt input. The wiring change takes place within the motor terminal box. This is accomplished by accessing the motor by removing the full sander assembly from the base; making the change and installing the sander assembly back onto the base.

1. Disconnect the sander from the power source.
2. Place the belt sander in the horizontal position and remove the belt sanding table.
3. Remove the four bolts securing the sander assembly to the base.
4. Using an assistant, lift the sander assembly and rotate it to expose the under side.
5. Place the sander assembly on a bench or back onto the base. Have the assistant hold the sander assembly to prevent unintended movement.
6. Remove the motor terminal box cover.
7. Using the wiring diagram, change the lead connections (Black, Red, Gray, and Yellow) to match the pattern and terminal connections (1, 2, 3, and 4). DO NOT change the Green (ground) connection.
8. Install motor terminal box cover.
9. Install the sander assembly onto the base and secure with the four bolts.
10. Install the belt sander table and place the belt sander in the desired position.

11. Remove existing plug from power cable and attach a UL/CSA listed plug designed for 230V power; or “hardwire” the machine directly to a panel. If hardwiring, make sure a disconnect is provided for the operator.

Electrical Diagram





MACHINE SETUP

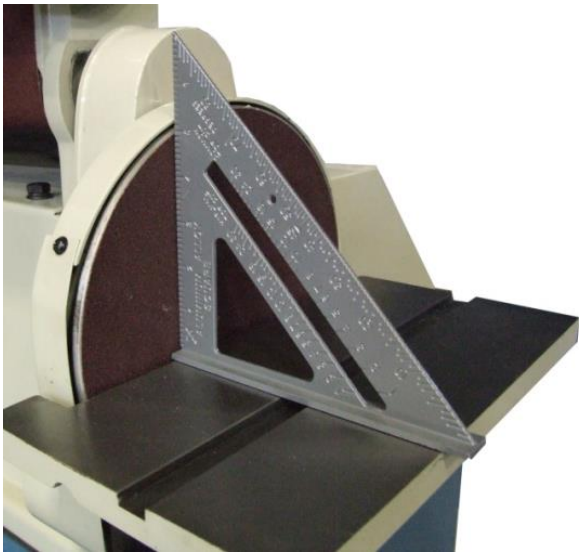
Mounting

1. Position the **DBG-106** where it will be located on the shop floor. When positioning the machine, consider the type of work which will be done on it so you allow sufficient room, not only for the piece parts, but also for service to the machine.
2. Open the door in the base of the machine and using the holes in the base as a template, mark the floor for the position of the hold-down bolts.
3. Move the machine to expose the hold-down bolt marks and install anchors for the hold-down bolts.
4. Put the machine back over the hold-down anchors and bolt the machine securely to the shop floor. **THIS MUST BE DONE FOR SAFE OPERATION OF THE MACHINE.**
5. Establish an electrical service connection to the machine.

⚠ CAUTION: HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!
Check if the available power supply is the same as listed on the machine nameplate.

Disc Table Angle Adjustment

1. Disconnect power to the machine to prevent accidental start-ups.
2. Loosen the table locking knob on the side of the disc table.
3. Using a square against the table and disc, set the table at exactly 90° to the disc.
4. Tighten the table locking knob.
5. Check the pointer. If it is not exactly on the zero mark, loosen the pointer attaching screw, adjust the pointer, and retighten the screw.
6. Reconnect electrical power to the machine.

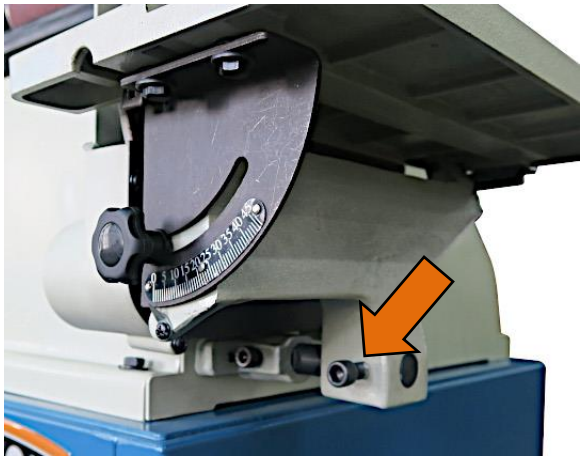


Disc Table Miter Parallelism

1. Disconnect power to the machine to prevent accidental start-ups.
2. From each end of the table, measure the distance from the miter slot to the sanding /grinding disc.
3. If an adjustment is required, loosen the (4) hex attachment screws under the table and move the table until the dimensions are equal at both ends.
4. Tighten the (4) adjustment screws.
5. Reconnect electrical power to the machine.

Disc Table Gap Adjustment

1. Disconnect power to the machine to prevent accidental start-ups.
2. Using a scale, check the gap between the edge of the table and the sanding / grinding disc. It should be set to 3/32” (2.36mm).
3. To set the distance, loosen the bolt as indicated by the arrow.
4. When re-tightening the bolt also check that the table is level from left to right.
5. Reconnect electrical power to the machine.



Belt Table Miter Slot Parallelism Adjustment

1. Disconnect power to the machine to prevent accidental start-ups.
2. From each end of the table, measure the distance from the miter slot to the sanding /grinding belt.
3. If an adjustment is required, loosen the (3) socket head attachment screws under the table and move the table until the dimensions are equal at both ends. At the same time, set a distance of 3/32” (2.86mm) between the table edge and the belt.
4. After adjustment tighten the (3) socket head adjustment screws.
5. Reconnect electrical power to the machine.

OPERATING INSTRUCTIONS and ADJUSTMENTS

⚠ CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.
When handling large heavy materials make sure they are properly supported.

These sanders can be used to remove stock from a wide variety of machinable materials. Different materials require different grit types and grades to achieve the desired stock removal rate and surface finish. Please consult with your abrasive materials supplier for specific recommendations on the correct grit material and grade required for your specific needs. When removing stock from soft materials (wood, plastic, etc.) these machines are typically called "sanders." When removing stock from hard materials (cast iron, steel, etc.) they are referred to as "grinders".

Belt Sander

The sanding belt must be in good condition, at proper tension, and tracking correctly, before doing any sanding, grinding or other abrasive machining operations. Refer to the section on Track Mechanism Maintenance if you have any problems with belt tension or tracking.

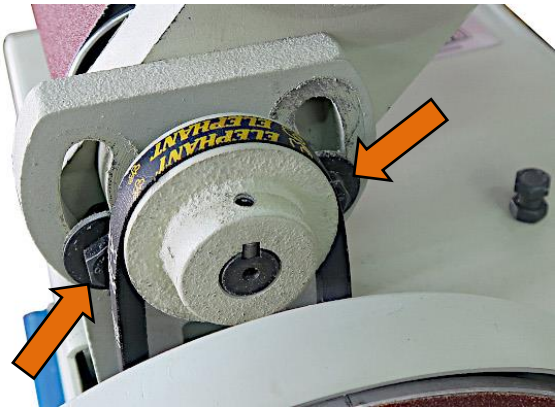
Adjusting the Belt Sander Table

You can tilt the table from a horizontal position to a 45° downward angle or any angle in between. A single locking knob on the side of the table is used to lock and unlock the table for adjustment.

⚠ CAUTION: Never adjust the table angle while the sander is running.
Always turn the motor off before adjusting the table angle.

Adjusting the Belt Sander Table

The belt sander table can be adjusted from a vertical position to a horizontal position or anywhere in between. To tilt the table, loosen the two bolts as indicated by the arrows using a 16mm wrench. (It is not necessary to remove the guard to pivot the table) When set at the desired angle, tighten the two bolts.



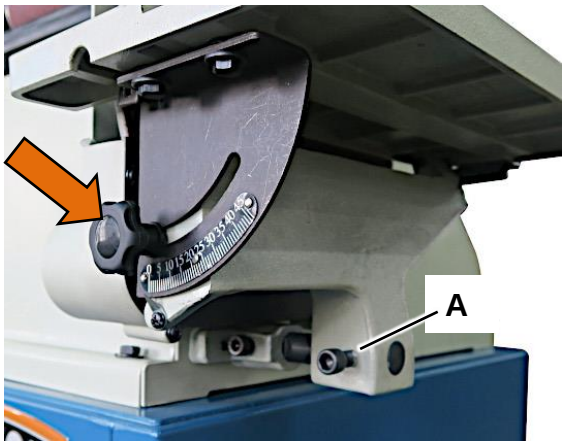
(shown with guard removed)

⚠ CAUTION: Never adjust the arm angle while the sander is running. Always turn the motor off before adjusting the arm angle.

To set the arm to an angle between horizontal and vertical use a machinist's protractor. Tighten both lock bolts to secure the arm.

Adjusting the Disc Sander Table

Loosen the locking knob (arrow) underneath the table as shown. Using the pointer and scale, set the angle between 0° and 45° downward as needed. Lock the knob when the desired angle is shown on the scale.



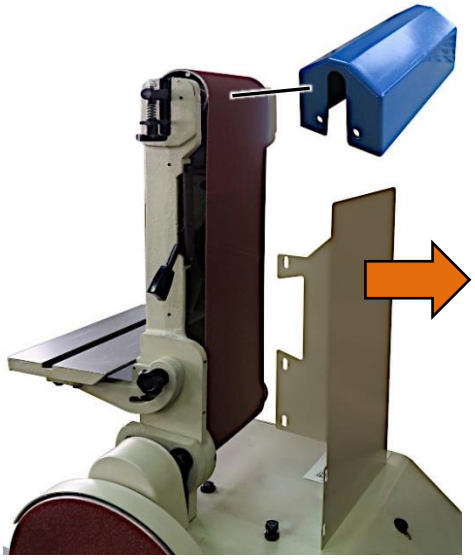
⚠ CAUTION: Never adjust the table angle while the sander is running. Always turn the motor off before adjusting the table angle.

The distance between the disc and the edge of the table can also be adjusted by loosening bolt (**A**) and sliding the table assembly either in or out. The table can also be removed when replacing the sanding / grinding disc.

Using the Miter Gauge

The miter gauge can be used on either the disc or belt surfaces to sand or grind accurate angles on the piece part. When using the gauge alone, you can sand or grind a single angle. However, by tilting the table and using the miter gauge in combination with the table tilt, it is possible to do compound angles as well.

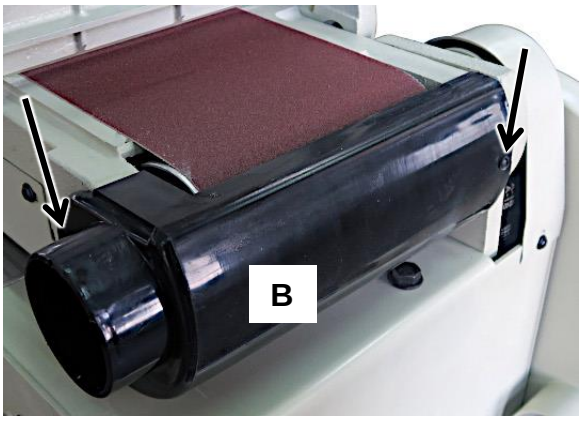
When grinding a compound angle you should always check the accuracy of your setup by sanding a piece of scrap material before doing any finish sanding on the actual work piece.



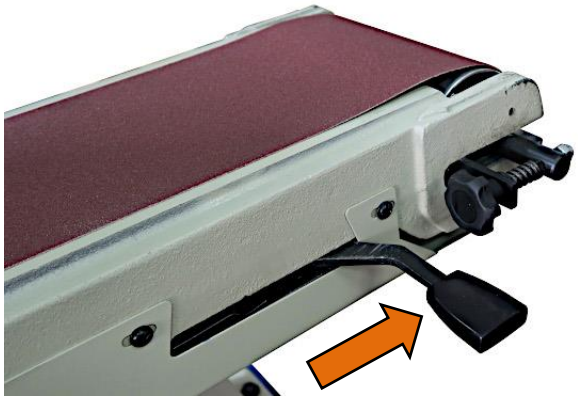
MAINTENANCE

WARNING: Make sure the electrical disconnect is OFF before working on the machine.
Maintenance should be performed on a regular basis by qualified personnel.
Always follow proper safety precautions when working on or around any machinery.

Sanding / Grinding Belt Replacement



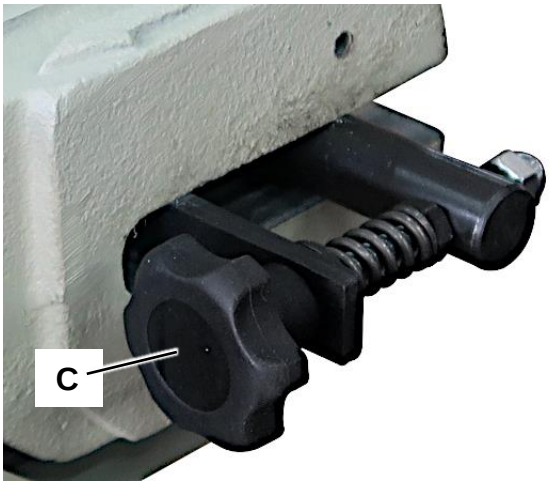
1. Disconnect power to the machine to prevent accidental start-ups. If the machine is plugged into an outlet, unplug it. If the machine is hardwired to a branch circuit with a junction box, remove the fuse or trip the circuit breaker to the branch.
2. Take off the bottom cover by removing (8) screws, and the top end cover held on with (4) screws.
3. Lower the arm to a horizontal position and take off the plastic dust chute (**B**) by removing two screws as indicated.
4. Release the belt tension by sliding the tension handle to the right.
5. Remove the belt.



6. Check the drums and platen for scoring or signs of wear which might require service or replacement.
7. Check the drums for looseness which might cause tracking problems. Correct any loose condition by tightening or replacing any parts as required.
8. Slide the new belt onto the drums and platen. (Check that the direction arrows on the inside of the belt match the direction that the motor turns.
9. Slide the tension handle to the left to tighten the belt, making sure the belt stays centered on the drums.
10. Turn the drums by hand to see if the belt tracks true. JUST BECAUSE THE OLD BELT TRACKED CORRECTLY DOES NOT MEAN THE NEW BELT WILL. Always check the tracking when replacing a belt.

Tracking Adjustment

1. To adjust the tracking, power up the machine.
2. Jog the motor on and off to observe the tracking and turn the tracking knob as necessary to make the belt track in the center of the platen and drums. Turn the tracking knob (**C**) clockwise (**cw**) to move the belt to the right, and counterclockwise (**ccw)** to move the belt toward the left.
3. When the belt seems to be tracking correctly, turn the motor on and leave it running while fine tuning the tracking.
4. When satisfied, turn the motor **OFF**, and re-attach the plastic dust chute, the top end cover, and the bottom cover.

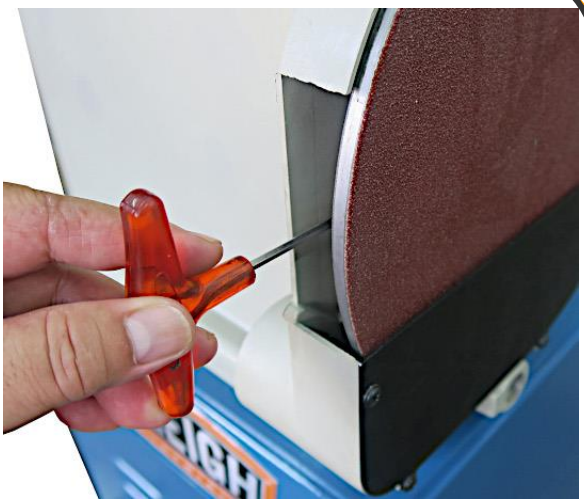


Installing Abrasive Discs

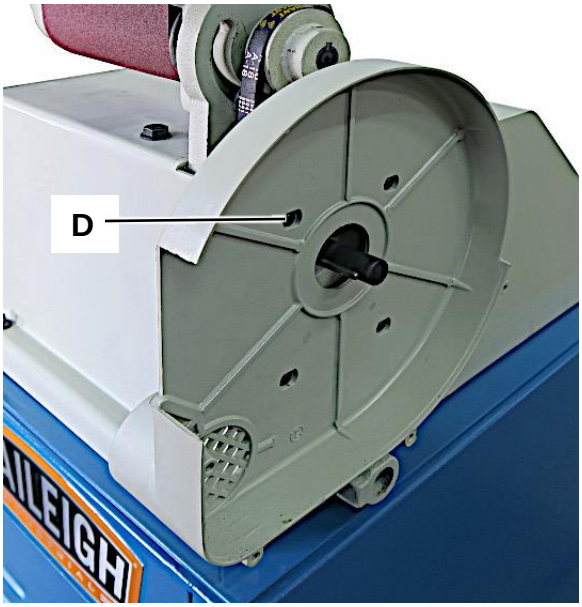
1. Disconnect power to the machine to prevent accidental start-ups.
2. Peel off the old abrasive disc.
3. Clean the drive disc surface using naptha or a similar nonflammable solvent that will dry film-free.
4. Pull the protective backing half off the new abrasive disc.
5. Position the new disc carefully so it is centered accurately on the drive disc.
6. When accurately centered, remove the rest of the protective backing and press the abrasive disc firmly against the drive disc so complete adhesive contact is made.
7. Reconnect power to the machine.

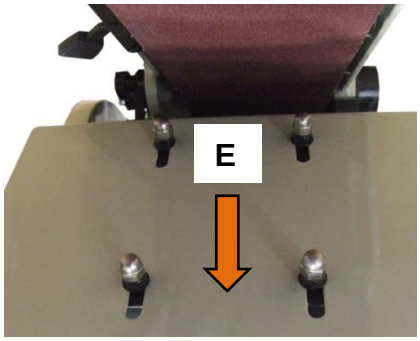
Replacing the V-Belts

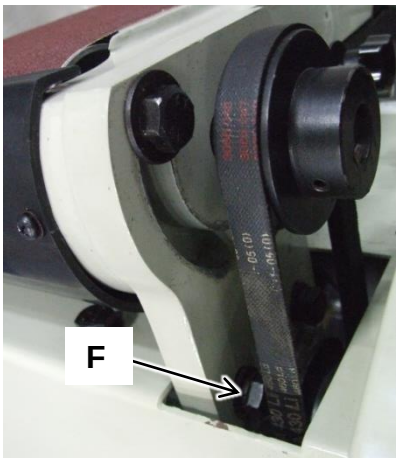
It is recommended to change both belts at the same time.



1. Disconnect power to the machine to prevent accidental start-ups.
2. Remove the two tables (**M**) & (**N**) from the machine.
3. Remove the disc plate. First remove the black plate at the bottom of the shroud (shown removed) to get at the 3mm setscrew, remove the access plate, loosen the setscrew and pull the plate off the shaft.
4. Remove the disc shroud (**D**) held on with (4) screws.
5. At this point you will need to remove the sander / grinder machine from the stand. Lower the belt sanding arm to a horizontal position and tighten the two bolts to lock it into position.
6. Remove the (4) bolts, washers, and nuts holding the sander to the stand. (To get access to the nuts, remove the back panel on the stand.
7. Carefully remove the sander / grinder from the stand and place on the floor or a sturdy work surface. Be careful not to damage the control buttons.
8. Release the tension on the two V-belts. Loosen the acorn nuts an allow the motor to slide downward to loosen the motor belt and loosen the hex bolts (F) for the auxiliary belt.







9. Remove the four bolts securing the sander assembly to the base.
10. Using an assistant, lift the sander assembly and rotate it to expose the under side.
11. Place the sander assembly on a bench or back onto the base. Have the assistant hold the sander assembly to prevent unintended movement.
12. Remove the bolts holding on the bearing block (G).
13. Remove the two V-belts and replace with new ones.
14. Re-install the bearing block.
15. Tension the motor belt so that when pressed, in the middle of its travel, it has no more than one belt's width of movement. Tighten the (4) motor adjustment nuts. (Check belt alignment and re-adjust if necessary).

16. Place the sander / grinder back onto the stand, replace the (4) bolts and nuts, and tighten securely.
17. Re-tighten the adjustment bolts for the auxiliary V-belt. (Check alignment).
18. Re-install the small V-belt belt guard.
19. Install the tables back onto the sander / grinder.
20. Verify that all parts have been re-installed and tightened properly. Make sure no loose tools have been left on the machine.
21. Re-establish electrical power to the sander / grinder.

Replacing motor

1. Disconnect electrical power.
2. Remove four screws from base. With assistance of a second person, lift base from stand.
3. Place base on bench with underside of base facing up.
4. Remove four hex head screws, nuts and washers from motor base.
5. Remove motor v-belt from motor pulley.
6. Remove motor from base.
7. Loosen set screw in pulley. Remove pulley.
8. Align set screw in pulley with flat on motor shaft and install pulley. Do not tighten set screw.
9. Install replacement V-belt over end of motor shaft and install motor in base. Secure with four screws, washers and nuts.
10. Install and tighten four hex bolts, nuts, and washers in the motor base.
11. Position pulley on motor shaft so the V-belt is parallel with inner wall of base. Tighten set screw in pulley against flat on motor shaft.
12. Place assembled base on stand. Secure with four screws, washers, nuts.
13. Connect electrical power and operate machine to check operation.

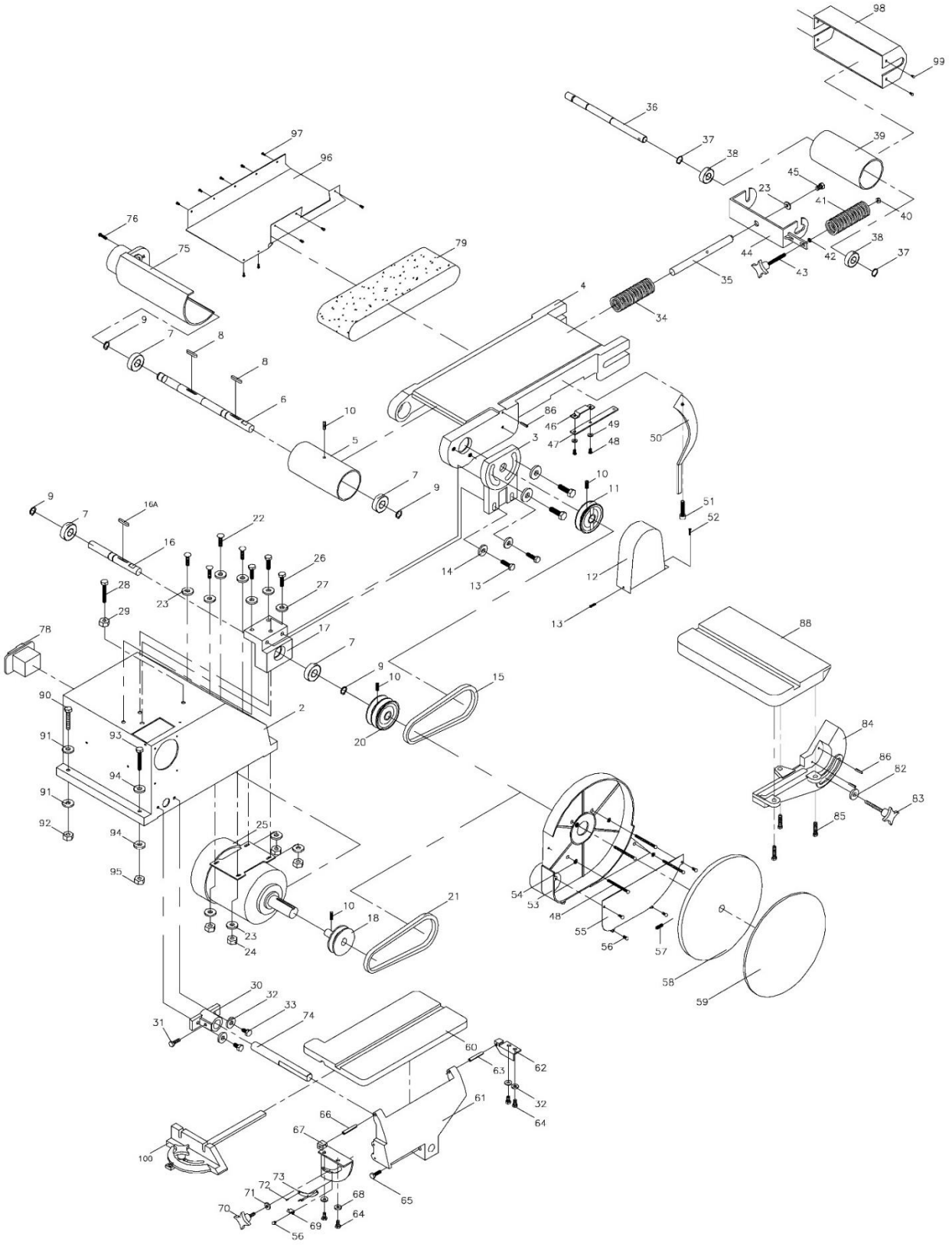
LUBRICATION AND MAINTENANCE

WARNING: Make sure the electrical disconnect is OFF before working on the machine.
Maintenance should be performed on a regular basis by qualified personnel.
Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.

***Note**: Proper maintenance can increase the life expectancy of your machine.*

DISC AND SANDER PARTS DRAWING – A



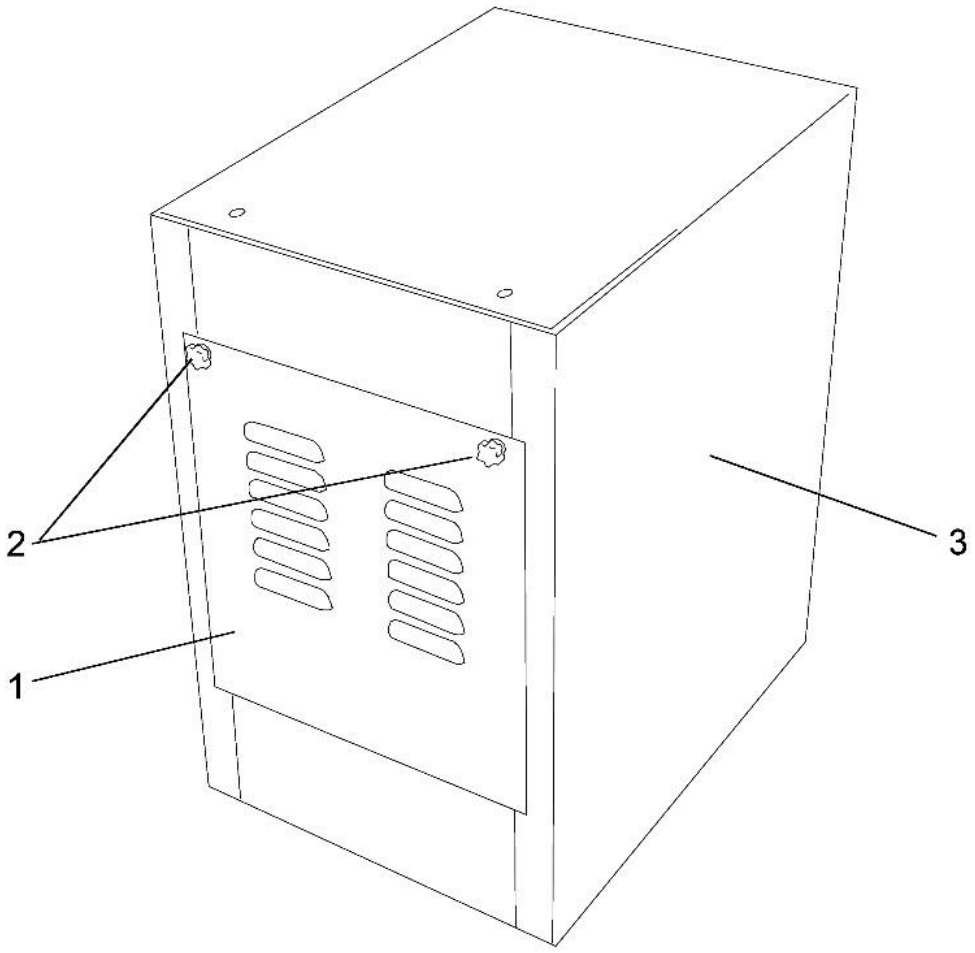
Disc and Sander Parts List – A

Item	Part No	Description
2	DBG106V2-02	Base
3	DBG106V2-03	Bracket
4	DBG106V2-04	Platen
5	DBG106V2-05	Drive Drum
6	DBG106V2-06	Drive Drum Shaft
7	BB-6203ZZ	Bearing 6203ZZ
8	DBG106V2-08	Key 5 x 5 x 30 mm
9	DBG106V2-09	Retaining Ring S-17
10	TS-0267041	Set Screw 1/4 x 3/8
11	DBG106V2-11	Pulley
12	DBG106V2-12	Pulley Cover
13	TS-0051071	Hex Cap Screw 5/16 x 1-1/2
14	TS-0680031	Flat Washer 5/16
15	DBG106V2-15	V-Belt A-18
16	DBG106V2-16	Drive Pulley Shaft
17	DBG106V2-17	Bracket
18	DBG106V2-18	Motor Pulley
20	DBG106V2-20	Idler Pulley
21	DBG106V2-21	V-Belt A-25
22	TS-0081031	Hex Cap Screw 5/16 x 3/4
23	TS-0680031	Flat Washer 5/16
24	TS-0640082	Hex Nut 5/16
25	DBG106V2-25	Motor 1HP, 115/230V
	DBG106V2-SC	Start Capacitor (not shown) 300MFD,125VAC
26	TS-0060051	Hex Cap Screw 3/8 x 1
27	TS-0680041	Flat Washer 3/8
28	TS-0060071	Hex Cap Screw 3/8 x 1-1/2
29	TS-0561031	Hex Nut
30	DBG106V2-30	Mounting Bracket
31	TS-0051051	Hex Cap Screw 5/16 x 1
32	TS-0680031	Flat Washer 1/4
33	TS-0050031	Hex Cap Screw 1/4 x 3/4
34	DBG106V2-34	Spring

Item	Part No	Description
35	DBG106V2-35	Shaft
36	DBG106V2-36	Driven Drum Shaft
37	DBG106V2-37	Retaining Ring S-15
38	BB-6202ZZ	Bearing 6202ZZ
39	DBG106V2-39	Driven Drum
40	DBG106V2-40	Cap Nut 1/4
41	DBG106V2-41	Spring
42	TS-0680021	Flat Washer 1/4
43	DBG106V2-43	Threaded Rod, Belt Tracking Adjustment
44	DBG106V2-44	Driven Drum Support
45	TS-0051011	Hex Cap Screw 5/16 x 1/2
46	DBG106V2-46	Bracket
47	DBG106V2-47	Bar
48	TS-081C032	Pan Head Mach Screw 3/16 x 1/2
49	TS-0720051	Lock Washer 3/16
50	DBG106V2-50	Belt Tension Lever
51	TS-0051061	Hex Cap Screw 5/16 x 1-1/4
52	TS-081C022	Pan Head Mach Screw 3/16 x 3/8
53	DBG106V2-53	Disc Guard
54	TS-0720051	Lock Washer 3/16
55	DBG106V2-55	Cover Plate
56	TS-081D012	Pan Head Mach Screw 3/16 x 1/4
57	TS-1523031	Set Screw M6 x 10
58	DBG106V2-58	Aluminum Disc Dia. 10”
59	DBG106V2-59	Sanding Pad 10", 80 Grit
60	DBG106V2-60	Side Table
61	DBG106V2-61	Table Support
62	DBG106V2-62	Table Support Bracket
63	DBG106V2-63	Spring Pin
64	TS-0050011	Hex Cap Screw 1/4 x 3/8
65	TS-0051051	Hex Cap Screw 5/16 x 1
66	DBG106V2-66	Spring Pin
67	DBG106V2-67	Table Support Bracket
68	TS-0680021	Flat Washer 1/4
69	DBG106V2-69	Pointer

Item	Part No	Description
70	DBG106V2-70	Knob
71	TS-0680021	Flat Washer 1/4
72	DBG106V2-72	Rivet
73	DBG106V2-73	Scale
74	DBG106V2-74	Table Support Rod
75	DBG106V2-75	Belt Guard
76	TS-081C042	Pan Head Mach Screw 3/16 x 5/8
78	DBG106V2-78	Switch Assembly
79	DBG106V2-79	Abrasive Belt 6 x 48, 80 Grit
82	TS-0680021	Flat Washer 1/4
83	DBG106V2-83	Knob 1/4 X 1-1/2
84	DBG106V2-84	Table Bracket
85	TS-0051071	Hex Cap Screw 5/16 X 1-1/2
86	DBG106V2-86	Pin 4 X 15
88	DBG106V2-88	Sanding Belt Table
90	TS-0051091	Hex Cap Screw 5/16 x 2
91	TS-0680031	Flat Washer 5/16
92	TS-0561021	Hex Nut 5/16
93	TS-0051091	Hex Head Screw 5/16 x 2
94	TS-0680031	Flat Washer 5/16
95	TS-0561021	Hex Nut 5/16
96	DBG106V2-96	Belt Cover
97	TS-081C022	Pan Head Mach Screw 3/16 x 3/8
98	DBG106V2-98	Belt Guard
99	TS-081C032	Pan Head Mach Screw 3/16 x 1/2
100	DBG106V2-100	Miter Gauge Assembly

STAND PARTS DRAWING – B



Stand Parts List – B

Item	Part No	Description
1	DBG106V2-101	Access Panel
2	DBG106V2-102	Knob
3	DBG106V2-103	Close Stand

TROUBLESHOOTING

WARNING: Make sure the electrical disconnect is OFF before working on the machine.

Fault	Possible Cause	Remedy
Machine does not start.	Blown fuse or tripped circuit breaker.	Determine reason for blown fuse/tripped breaker (such as a short circuit or motor overload). Correct reason for fault. Replace fuse/reset breaker.
	Motor failure.	Replace motor.
	Not connected to power source.	Check connections.
	Motor not wired for correct voltage.	Correct motor wiring.
	Motor not connected to correct voltage source.	Connect to proper voltage source.
Sanding belt does not track correctly.	Sanding belt stretched unevenly.	Replace sanding belt.
	V-belt worn.	Replace V-belt.
	Pulley worn.	Replace pulley.
Abrasive separates from disc.	Improperly bonded.	Clean residual adhesive from disc. Reapply adhesive-backed abrasive to the disc.
Sanding belt slips or stalls when pressure is applied.	Abrasive belt tension inadequate.	Tighten sanding belt.
	Excessive pressure being applied to platen housing.	Reduce pressure on sanding belt (and platen housing).
	Motor belt loose.	Tighten motor belt.
Disc stalls when pressure is applied.	Motor V-belt loose.	Tighten motor V-belt.
Frequent replacement of sanding belt.	Too much pressure being applied to work piece.	Reduce pressure on work piece.
	Full width of belt not being used.	Stroke across sanding belt using full width of belt surface.

NOTES

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