

Sanding Machine #13

1. This machine is for removing planer chatter marks, or creating a smooth surface on solid wood. If more than 1/32" of wood needs to come off, use the thickness planer.
2. If you have any questions; check with a Board Member, or Shop Manager
3. Minimum Board Length:
 1. **26" minimum length for # 13.**
4. If you glued the wood today wait at least 24 hours before running it through the sander to prevent glue from damaging the sandpaper.
5. **When sanding multiple boards, they must be the same thickness!!** You cannot surface sand boards of different thickness at the same time!!
6. Things not to be done:
 - i. Don't sand wood with any excess exposed glue (scrape it off first).
 - ii. No sanding of pine boards (you may use Surface Sander # 48).
 - iii. No sanding of painted or boards with **any finish** on it (use hand sanders).
 - iv. No sanding of MDF, particle board, plywood, or Melamine.
 - v. Don't turn crank more than 1 indicator mark.
7. Remove any loose knots in the board before sanding
8. Sander # 13 has two sanding drums: 80 grit on the front roller and 120 grit on the back roller
9. Make sure sanding drums and conveyor belt switches are turned off.
10. Open vacuum vents.
11. Open top flap of machine:
 - i. Check sanding drums for any tears or burn marks.
 - ii. Make note of any damage and report it to the Shop Manager.
12. Measure thickness of board and then check it against machine thickness indicator for preliminary pass. Make machine indicator mark slightly thicker than board itself
13. Place board to be sanded against front roller and turn the crank so that the board will just clear roller (use thickness gauge for estimation).
14. Turn on conveyor belt and run the board through **with sanding drums not running.**

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