



Drum Thickness Sander

Operational Rules:

Sign in on “Operator Log” before using the Drum Thickness Sander.

Prior to any work, inspect the drum abrasive for tears or damage. If necessary, clean with an abrasive cleaning stick. The GWG cost for sandpaper is \$15.00 for a replacement strip.

Turn on dust collector and open port.

Using the thickness scale located next to the On-Off switch, set the table to a thickness slightly greater than the stock to be sanded.

Turn on the in-feed conveyor belt to a slow speed. Do not turn on the drum at this time.

Open the drum cover and feed the stock into the machine on the in-feed conveyor.

Once the stock is under the drum, slowly raise the in-feed table until the drum begins to rotate.

Remove the stock from the outfeed table and close the drum cover.

Turn on the drum motor using the On-Off switch located below the switch shield on the left side of the machine. Move the switch up to the on position and down to the off position.

Turn on the in-feed belt conveyor by rotating the “Table Feed Knob” clockwise 1/8 turn.

Place stock onto the infeed table & guide it under the pressure rollers. Listen carefully to the drum motor sound & reduce the infeed conveyor speed at the first indication of a slowing of the drum by rotating the dial counter-clockwise 1/8th turn maximum. DO NOT go beyond this.

As the work progresses, the in-feed conveyor speed may be increased a small amount at a time if there is no indication of strain. However, each thickness adjustment will necessitate repeating the previous step.

Observe the in-feed belt position on the slider bed after each pass to insure that the in-feed conveyor is tracking straight. If it is moving left or right on the slider bed, suspend operations and consult the Supervisor on Duty. Failure to have the tracking problem corrected will damage & make useless the conveyor belt (Cost: \$40.00)

Periodically clean the drum belt using an abrasive cleaning stick

At the end of the work session, clean the drum abrasive, the conveyor belt & blow dust from the two motors & drives.

Clean up the work area around the machine.

Turn off dust collector and close port.

The Drum Thickness Sander, also known as a “Drum” sander is similar to a thickness planer in that it removes material from the surface of a board. However, instead of a series of rotating knives & shaving the material, it uses sandpaper attached to a drum to abrade the work piece that feeds through on a conveyor belt. This is a 16” x 32” drum sander with a two speed drive. This system will provide accurate sanding for wood up to 16” in a single pass, or 32” wide in two passes.

To avoid accidents, the following operational safety rules must be observed by everyone working on the GWG Drum Sander.

Failure to be certified or to follow the safety rules will result in loss of shop privileges.

Drum Thickness Sander Safety Rules:

1. Wear proper apparel. Remove loose fitting clothing, jewelry and tie back long hair. Do not wear gloves.
2. Wear hearing, eye protection and a dust mask.
3. **Make sure there is NO glue (dry or fresh) on the surface of the piece that you are going to sand.**
4. Check the feed belt tracking periodically to prevent belt run-off.
5. Do not sand pieces of material that are shorter than 7” long or thinner than 1/32” thick.
6. Disconnect the machine from the power source before installing, removing or adjusting drum belts, conveyor belts or accessories.
7. A two foot perimeter around the sander should be kept clear of people and debris that impair traction or footing to avoid slips and falls.
8. Unplug the sander before adjusting or doing maintenance.
9. Prevent the work piece from contacting the sanding belt before starting the machine.
10. Sand with the grain of the wood.
11. The guard over the drum must be completely down while the machine is in operation.
12. Give the work your undivided attention.
13. Never leave a running tool unattended.
14. Some wood dust is irritating & can cause respiratory problems. Wear a dust mask or filter.
15. Avoid feeding more than one piece through the sander at once. There is often a temptation to “gang-feed” material that may result in kickback.
16. Stand clear of the drum while sanding to avoid kickback.
17. Any ripped belts, burn marks or glue on belt, should be reported to the supervisor at once.
18. Obey posted instructions on equipment,