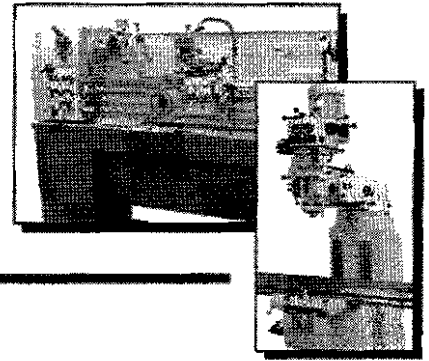


MACHINERY DIVISION

6465 18 MILE ROAD
STERLING HEIGHTS, MI 48314

PHONE:
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MODEL 6436 SANDER

THANK YOU FOR PURCHASING WITH KBC MACHINERY. ALL KBC MACHINES ARE BACKED BY OUR 1 YEAR PARTS REPLACEMENT WARRANTY. WHEN USED AS INTENDED, AND WITH PROPER MAINTENANCE THIS MACHINE WILL PROVIDE YOU WITH YEARS OF TROUBLE-FREE SERVICE. IF YOU NEED PARTS SIMPLY FILL OUT THE PARTS REQUEST FORM, AND FAX OR E-MAIL YOUR REQUEST. ALL OTHER QUESTIONS PLEASE CONTACT US @ :

**KBC MACHINERY
6465 18 MILE ROAD
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PH (800) 860-1740
FAX (800) 862-1740
MACHINERY@KBCTOOLS.COM
WWW.KBCTOOLSANDMACHINERY.COM**



PARTS REQUEST FORM

YOUR COMPANY NAME: _____

STATE/PROVINCE _____

YOUR NAME _____

PHONE # + EXT _____

FAX # _____

MACHINE INFO:

MAKE/MANUFACTURER _____

MODEL NUMBER _____

YEAR MADE _____

SERIAL# _____

PARTS REQUESTED:

PART#

DESCRIPTION

PLEASE INCLUDE COPY(S) OF THE PARTS DRAWING FROM THE
MANUAL AND CIRCLE THE PARTS NEEDED

FAX PARTS REQUEST TO (800) 862-1740

E-MAIL PARTS REQUEST TO: machinery@kbctools.com

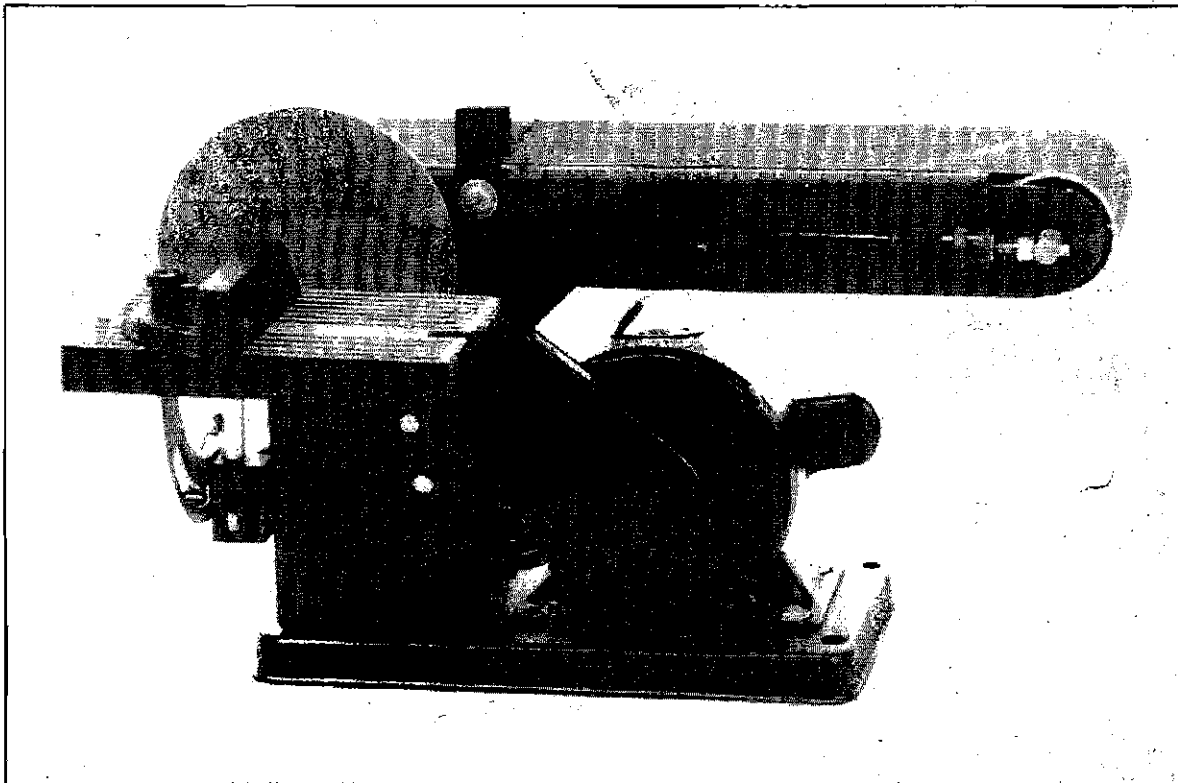
THANKS; KBC MACHINERY - MICHIGAN

MODEL 6436

MOTORIZED

Belt And Disc Sander

OWNER'S MANUAL



SAFETY RULES FOR POWER TOOLS

1. KNOW YOUR POWER TOOL

Read the owner's manual carefully. Learn the application and limitations as well as the specific potential hazards peculiar to this tool.

2. GROUND ALL TOOLS

If tool is equipped with three-prong plug, it should be plugged into a three-hole receptacle. If adapter is used to accommodate two-prong receptacle, the adapter wire must be attached to a known ground. Never remove third prong.

3. KEEP GUARDS IN PLACE

and in working order.

4. REMOVE ADJUSTING KEYS AND WRENCHES

Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on tool.

5. KEEP WORK AREA CLEAN

Cluttered areas and benches invite accidents.

6. AVOID DANGEROUS ENVIRONMENT

Don't use power tools in damp or wet locations. Keep work area well illuminated.

7. KEEP CHILDREN AWAY

All visitors should be kept a safe distance away from work area.

8. MAKE WORKSHOP KID PROOF

—with padlocks, master switches, or by removing starter keys.

9. DON'T FORCE TOOL

It will do the job better and be safer at the rate for which it was designed.

10. USE RIGHT TOOL

Don't force tool or attachment to do a job it was not designed for.

11. WEAR PROPER APPAREL

No loose clothing or jewelry to get caught in moving parts.

12. USE SAFETY GLASSES

Also use face or dust mask if cutting operation is dusty.

13. SECURE WORK

Use clamps or a vise to hold work when practical. It's safer than using your hand, frees both hands to operate tool.

14. DON'T OVERREACH

Keep your proper footing and balance at all times.

15. MAINTAIN TOOLS IN TOP CONDITION

Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

16. DISCONNECT TOOLS

before servicing and when changing accessories such as blades, bits, cutters.

17. AVOID ACCIDENTAL STARTING

Make sure switch is "OFF" before plugging in cord.

18. USE RECOMMENDED ACCESSORIES

Consult the owner's manual. Use of improper accessories may be hazardous.

OPERATING INSTRUCTIONS FOR BELT SANDER

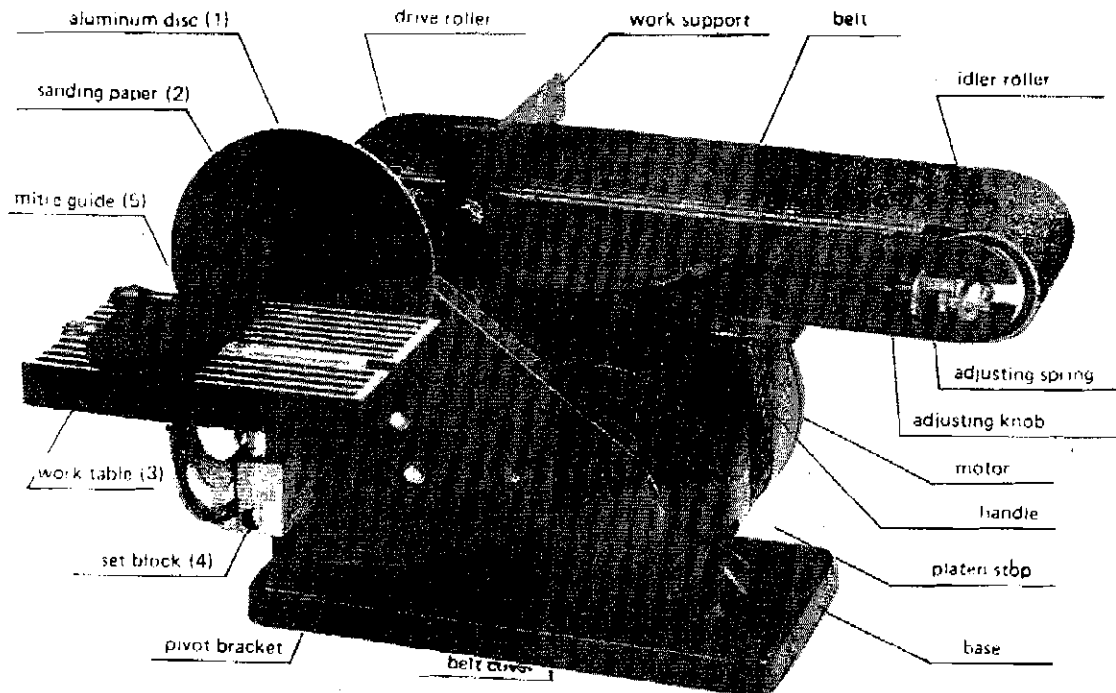


fig. 1

A. SAFETY

Due to the functions of this tool the revolving parts must remain exposed. Be careful! Hold the work firmly so that it may not be driven from your hands allowing them to come in contact with the abrasive surfaces.

- * Use the work support whenever possible.
 - * Be sure the rotation is correct.
 - * Do not wear clothes which are loose or dangling.
- Although the use of safety goggles is extremely helpful in all types of sanding operations, their use is particularly advantageous when finishing metal. Protection of your eyes should not be taken lightly. Many State working laws prohibit the use of sanding equipment in industrial plants without the use of safety goggles. Your unit is built to professional specifications; use the same operating and safety considerations adopted by the professionals.

In homes where there are small children, a good practice is to unplug the motor and remove the drive belt from the pulley when the sander is not in operation. Another good practice is not to let young teenagers or the unexperienced operate the machine without proper supervision. These practices hold true, for virtually all power tools.

B. MOTOR AND OPERATING SPEED REQUIREMENTS

A 1/4 h.p. motor with an operating belt speed of 1720 R.P.M. are recommended. Using a 2" motor pulley with a 1720 R.P.M. motor will produce a 1720 R.P.M. operating speed. The motor is mounted below the belt platen of the sander.

C. BELT AND DISC SANDER (Fig.1)

The belt and disc sander you have purchased is a combination finishing machine that offers all of the advantages of both a horizontal and a vertical belt sander in addition to the accurate sanding and forming obtainable with a disc sander. Its rigid cast iron and steel construction permits accurate sanding operations.

To prevent damage in shipment some of the parts are disassembled from the tool. These parts are listed below. Be sure they are all accounted for before discarding any of the packing materials.

1. Disc assembly consisting of:
 - (a) Aluminum disc casting, No.1, and sandpaper No.2
 - (b) Table, No.3, and set block, No.4
 - (c) Fastening knobs and washers for table assembly.
2. Complete mitre guide assembly, No.5
3. Set of Allen wrenches.

D. ASSEMBLE (Fig.2)

The table No.1, sanding disc and machine body are shipped disassembly. First, to attach the sanding disc to the shaft No.2 and lock securely with set screw furnished in sanding disc then put the rod No.3 into the hole of pivot bracket No.4 then lock the screw. By placing a square against the sanding disc you can move the table up to a perfect 90 degrees angle to the disc. To make sure to tighten the set screw when the table is in this position and set the witness pointer No.5 The witness pointer will now indicate the correct angle at all positions to 45 degrees.

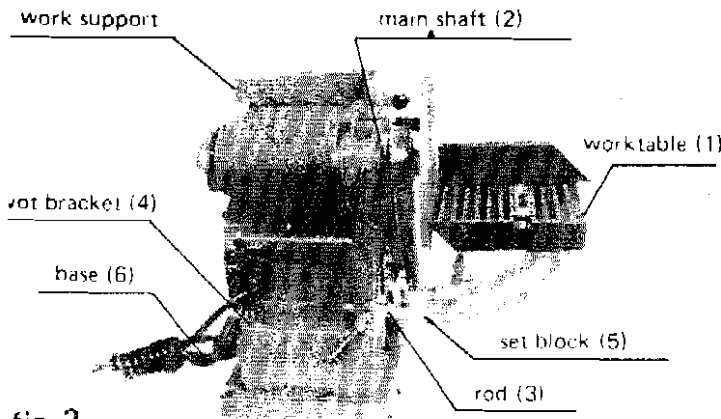


fig. 2

TABLE IS DISPLAYED UPSIDE-DOWN

E. ROTATION (Fig.3)

Rotation must be counter-clockwise, when facing the sanding disc. This rotation direction will cause the sanding belt to drive the work piece against the platen table for most convenient sanding. Since sanding belts are designed to go in only one direction (they can part when run in the wrong direction), look for the direction arrow on the back of the belt. If there is no direction arrow, the raised part of the seam, where the belt is connected, must be ahead in the direction of the travel of the belt.

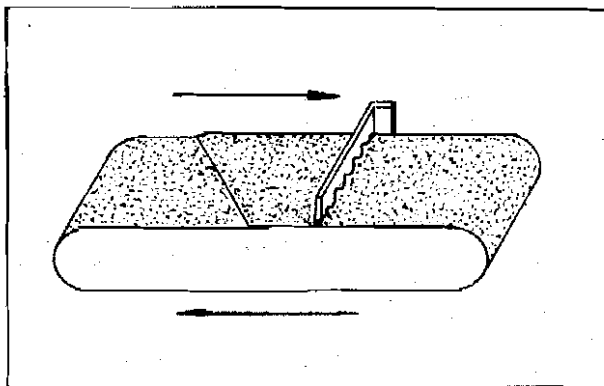


fig. 3

F. LUBRICATION

Your machine is fitted with sealed Ball Bearings which do not require additional lubrication.

INSTALLATION

G. MOUNTING

The unit is furnished with a base No.6, which is to be fastened securely to table or work bench through the holes in the base. Care should be taken in order that the positioning of the sander will provide sufficient clearance for all sizes of work pieces.

H. SANDING DISC

The sanding disc takes standard 6" diameter cloth or paper back discs. We recommend 80 grit for general purpose medium duty sanding, 50 grit for coarse or rough sanding, and 120 grit for fine sanding. - Use Disc Cement to adhere the paper or cloth discs to the face of the sanding disc....or use pressure sensitive discs.

I. SANDING BELT

Your machine takes a standard 4"x36" belt, No. 7. We recommend a medium belt for general purpose sanding, coarse for rough sanding, and a fine belt for finishing work. To change sanding belt, first, pull the handle No.12 moving the idle roller No.9, back until the belt is loose, slip off worn belt and replace. Reassemble and readjust tension and tracking.

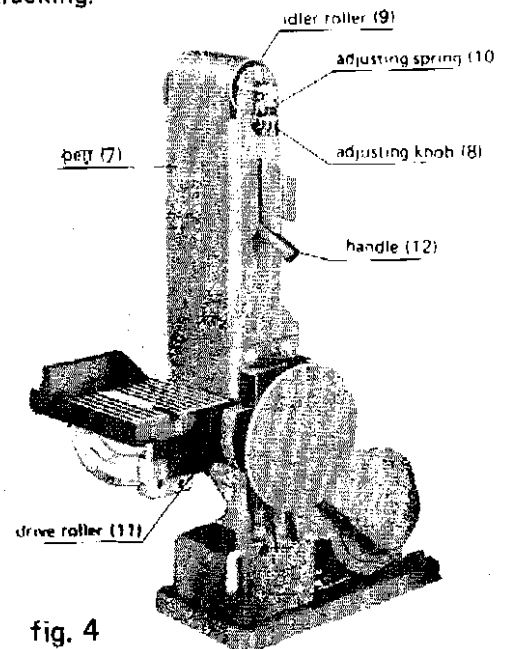


fig. 4

J. BELT TENSION AND TRACKING

Belt tension tighten by the idle roller No.9, and idle roller tighten with push back spring then the belt can get a just tightness. Turn the belt by hand, towards the drive roller No.11, adjust the adjusting knob, the belt should track on the center of the roller.

K. OPERATION

The sanding belt and sanding disc furnished with this tool are for general use. They are suitable for use on materials such as metal, wood, or plastics. Surface sanding is best accomplished by holding the work piece firmly, but without applying too much pressure to the sanding surface. The work piece should be moved back and forth over the sanding belt to maintain even belt wear and eliminate grooving.

Use the platen table to back up the work. (See Fig.5)

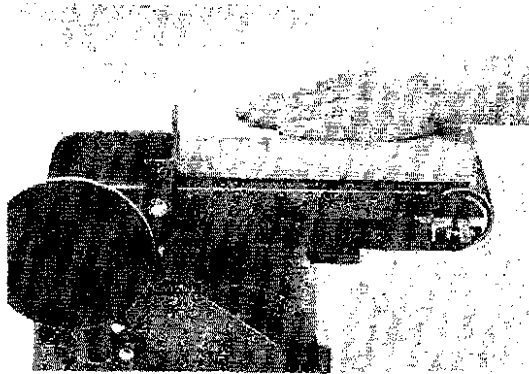


fig. 5

If the work piece is longer than the belt surface, remove the platen table to allow full use of the belt. Disc sanding has its greatest usage in truing the rough ends of wood.

Since a non-hardening type of disc cement should be used to fasten the abrasive paper to the sanding plate, the abrasive disc may be quickly replaced with one of a different grit or use a pressure sensitive disc.

Drum sanding may be done at either end of the sanding belt table. (See Fig.6 for a typical application.)

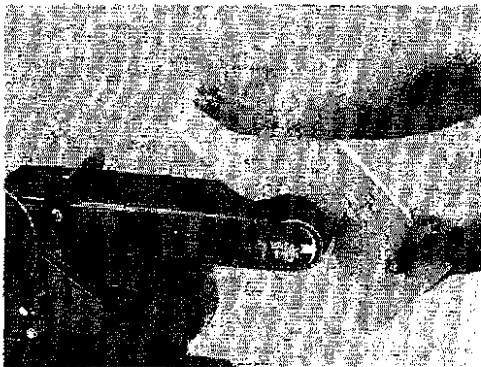


fig. 6

Flexible belt sanding may be done on the back of the belt with the belt table in vertical position. Release the belt tension to suit the curve of the work piece.

Quality of finish depends entirely upon the abrasive grit and the handling of the work. Highest quality is obtained by first rough sanding with the coarser grits, then changing to finer grits and making several light passes.

Abrasives are available in three primary grits—fine, medium and coarse. The belt and disc furnished are both medium grit.

It is often more convenient to use your belt sander in the vertical position. (See "Horizontal to Vertical Changeover"). When sanding in the vertical position, the work piece is normally rested on the table, rather than on the sanding surface.

A danger when sanding very soft wood is "over-sanding." Your new unit is highly efficient and is designed to produce effortless, fast sanding. Examine the working piece frequently to make sure you are not sanding off more than you desire. Wood should be sanded with the grain. Sanding against the grain can cause furrows in the wood and can scratch the wood during rough sanding. Let the sander do the work. Don't "push" the sanding operation. The results will be far more satisfactory.

Where an exceptionally fine finish is desired on soft wood, such as pine or fir, applying a very light coat of thinned down shellac sealer on the wood surface before the final sanding is a trick used by "old world" furniture manufacturers. As the sander removes the shellac, it also removes the fine "nap" common with soft woods, which could prevent the obtaining of a truly smooth finish.

Precise sanding, whether an angle or straight edge, is best done with the miter gauge. (See Fig.7,8)



fig. 7

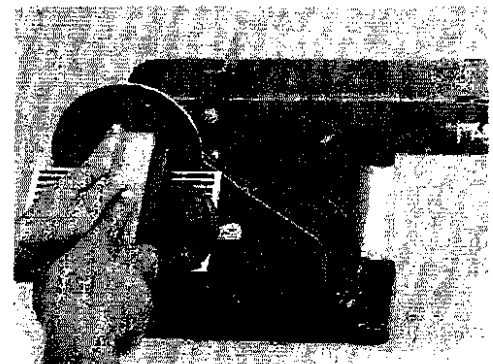


fig. 8

L. HORIZONTAL TO VERTICAL CHANGEOVER

To change from horizontal sanding to a vertical position.....first loosen the pivot bracket nuts. Rotate the platen to the desired position then tighten pivot bracket nuts securely. (See Fig.9)

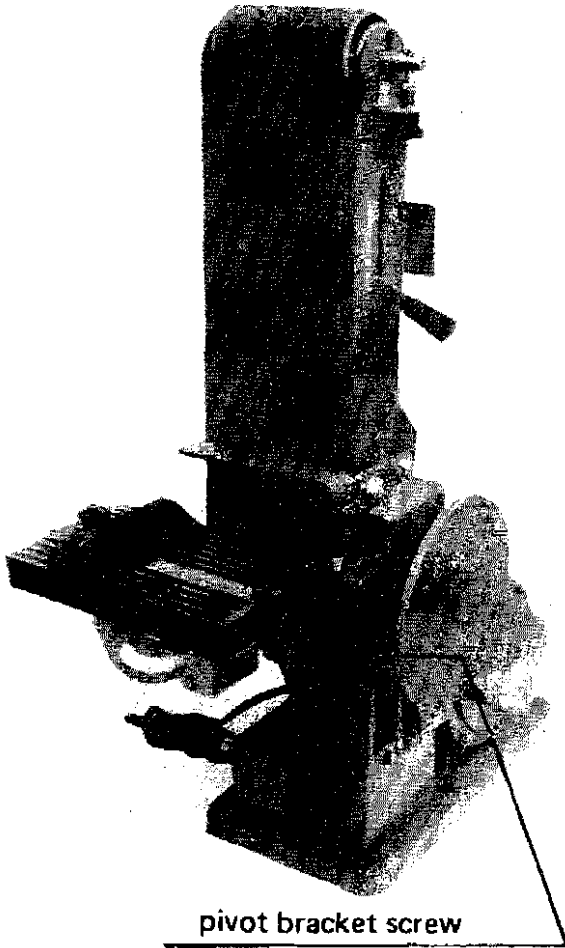


fig. 9

N. PART LIST

REF NO.	PARTS NO.	DESCRIPTION	SPEC.	Q'TY	REF NO.	PARTS NO.	DESCRIPTION	SPEC.	Q'TY
01	001	Base		1	33	033	Work support		1
02	002	Pivot bracket		1	34	034	Pull rod		1
03	003	Platen		1	35	035	Push back spring		1
04	004	Main shaft		1	36	036	Handle		1
05	005	Drive roller		1	37	037	Handle socket		1
06	006	Ball bearing		2	38	038	Block plate		1
07	007	Bearing cover		1	39	039	Adjusting knob		1
09	009	Drive pulley		1	40	040	Adjusting spring		1
10	010	Belt cover		1	41	041	Idler roller		1
11	011	Aluminum disc	6" or 7"	1	42	042	Idler shaft		1
12	012	Sanding paper	6" or 7" B0	1	43	043	Ball bearing		2
13	013	Work table		1	44	044	"C" ring	S12	2
14	014	Angle plate		1	45	045	Sanding belt	4"x36", 100#	1
15	015	Lock screw		1	46	-	Round head set screw	5/16"W18x1 1/2"	2
16	016	Table bracket		1	47	-	⊙ Round head screw	3/16"W24x3/8"	9
17	017	Point		1	48	-	⊙ Round head screw	3/16"W24x3/4"	1
18	018	Set block		1	49	-	Hexagon head screw	3/16"xW24x3/8"	2
19	019	Rod		1	50	-	Hexagon head screw	1/4"Wx20x1/2"	4
20	020	Lock screw		1	51	-	Hexagon head screw	5/16"W18x3/8"	5
21	021	Mitre guide		1	52	-	Hexagon head screw	5/16"W18x1/2"	2
22	022	Knob for mitre guide		1	53	-	Socket cap head screw	1/4"W20x3/4"	2
23	023	Pin		1	54	-	Socket set screw	1/4"W20x1/4"	2
24	024	Mitre bar		1	55	-	Socket set screw	5/16"W18x1/4"	1
25	025	Motor	1/4HP	1	56	-	Socket set screw	3/8"W16x3/8"	2
26	026	Motor pulley		1	57	-	Hexagon nut	5/16"W20	2
27	027	Belt	M21	1	58	-	Hexagon nut	1/4"W20	8
29	029	Electric line		1 set	59	-	Hexagon nut	1/2"W12	2
30	030	Switch		1	60	-	Spring washer	3/16"	8
31	031	Switch cover		1	61	-	Washer	1/4"	11
32	032	Plastic joint		1	62	-	Washer	5/16"	3

