

## No. 28-810 SANDING ATTACHMENT FOR 14" DELTA AND 10" HOMECRAFT BAND SAWS

### Operating and Maintenance Instructions

The Sanding Attachment is an accessory for the band saw which permits sanding the edges and ends of straight or curved band and scroll saw cuts. It is a handy attachment for use in furniture, toy and cabinet manufacturing as well as maintenance, carpenter and homework shops, and other woodworking shops, plants and schools.

Under the item No. 28-810, the customer receives a flat and curved platen with retaining clips, support block and a special table insert. Garnet belts are available in medium and fine grades, five to a package when ordered extra. Refer to Fig. 3.

Complete directions for adjusting the sanding attachment and performing the common sanding operations are contained in these instructions. For more complete information, hints and suggestions are given in our illustrated handbook, No 4531, "Getting the Most Out of Your Abrasive Tools."

Refer to the photographs, drawing and Table 1 to identify the parts mentioned in the following instructions.

#### INSTALLING SANDING BELT ON 14" BAND SAW

Remove the upper and lower wheel guards, LBS-187-S and LBS-186 respectively, from the machine. This is done by taking off the knurled hand knobs, LBS-177, and the wheel guards from the studs, LBS-188. Lower the upper wheel until the blade becomes loose on the tires by turning the star wheel and blade tensioning screw, LBS-104-S counter-clockwise. Remove the table alignment pin, LBS-55, and the table insert, LBS-56. Pull the blade forward out of the machine, guiding the right side out through the table slot.

Move the upper and lower guide block support brackets, LBS-127-S, and LBS-160-S respectively, out of the way of the sanding belts by turning clockwise on their knurled hand knobs. The ball bearing blade supports should also be moved back out of the way and the guide blocks moved outwardly to insure enough clearance when the sanding belt is in operation.

Before installing a sanding belt place the sanding attachment together as follows: Tighten the round head machine screws, SP-551, which pass through the

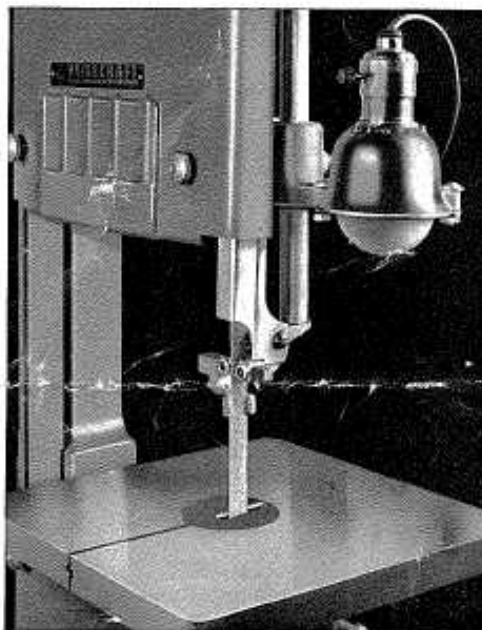


Fig. 1. Sanding Attachment Mounted on 10" Band Saw.

retaining clips, SBS-51, and into the tapped holes of the platen. Insert the round head machine screw, SP-559, through the steel washer, SP-1603, elongated hole in the platen and into the tapped hole of the mounting bracket, LBS-260. Loosen the hexagon socket set screw, SP-225, and remove the left blade guide block, LBS-132, from the upper blade guide support bracket, LBS-127-S. Insert the large end of the mounting bracket, LBS-260, of the sanding attachment in place of this guide block. Lock it in place by tightening the set screw against it firmly.

Enter the right side of the sanding belt through the table slot looping it loosely over the wheels. Center this belt on the tires so it falls within the retaining clips of the sanding attachment. Apply light tension on the belt by turning the star wheel and blade tensioning screw clockwise. Lower the platen until the

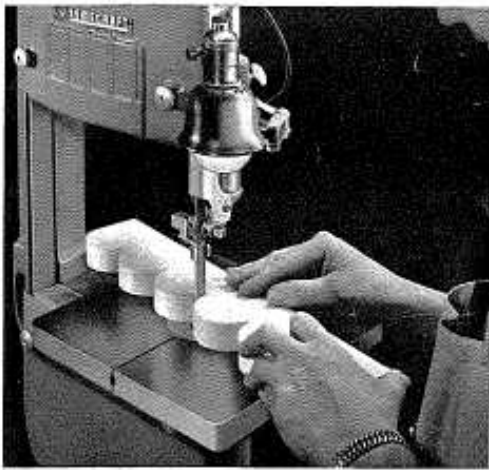


Fig. 2. Sanding Outside Curved Surfaces.

end of it is just below the table insert, LBS-261. Place the table insert into its seat with the open end of the slot to the rear surrounding the platen and sanding belt. Lightly tap the alignment pin, LBS-55, into the tapered hole in the front end of the table slot; this holds the two sides of the table in line. Remount the wheel guards before starting the job at hand. Refer to Figs. 1 and 3.

#### INSTALLING SANDING BELT ON 10" BAND SAW

Remove the upper and lower wheel guards, HBS-737-S and HBS-752 respectively, from the machine. This is done by taking off the knurled hand knobs, SBS-40, and the wheel guards from the studs, SBS-39. Remove the saw blade table insert, LBS-56, and the headless set screw, SP-107, from the threaded hole at the front of the table slot. Lower the upper wheel until the blade is loose on the tires by turning the hand knob and the blade tension screw assembly, HBS-706-S counter-clockwise. Pull the blade forward out of the machine, guiding the right side out through the table slot.

Take off the lower blade guide bracket, HBS-712, from the machine by tilting the table to the right and dismantling the hexagon nut, SP-1029, washer, SP-1603, and the square head bolt, SP-2353, which passes through the casting. Remove the blade support bearing and shaft assembly, HBS-714-S, from the upper blade guide bracket, HBS-711.

Before installing a sanding belt, place the sanding attachment together as follows: Tighten the round head machine screws, SP-551, which pass through the retaining clips, SBS-51, and into the tapped holes of the platen. Insert the round head machine screw, SP-559, through the steel washer, SP-1603, elongated hole in the platen and into the tapped hole of the

mounting bracket, LBS-260. Loosen the headless set screw, SP-101, and remove the left guide block, SBS-56, from the upper blade guide bracket, HBS-711. Loosen the headless set screw, SP-101, which holds the right guide block in the upper support bracket and push it flush with the bracket tightening it in this position. Insert the small end of the mounting bracket LBS-260 of the sanding attachment in place of this guide block. Lock it in place by tightening the headless set screw against it firmly.

Enter the right side of the sanding belt through the table slot and loop it loosely over the wheels. Center this belt on the tires so it falls within the retaining clips, SBS-51, of the sanding attachment. Apply light tension on the belt by turning the hand knob clockwise. Lower the platen so that the end of it is just below the table insert. Place the table insert LBS-261, into its seat with the open end of the slot to the rear surrounding the platen and the sanding belt. Turn the set screw, SP-107, into the threaded hole at the front end of the table slot; this holds the two sides of the table in line. Remount the wheel guards on the saw before starting the job at hand. Refer to Figs. 1 and 3.

#### SANDING WITH BELTS

Sanding the edges and ends of stock by the use of garnet belts on the band saw makes a neat and efficient job and is usually done free hand. The work is placed flat on the table and then projected into the sanding belt. A smooth light feed should be used. An inexperi-

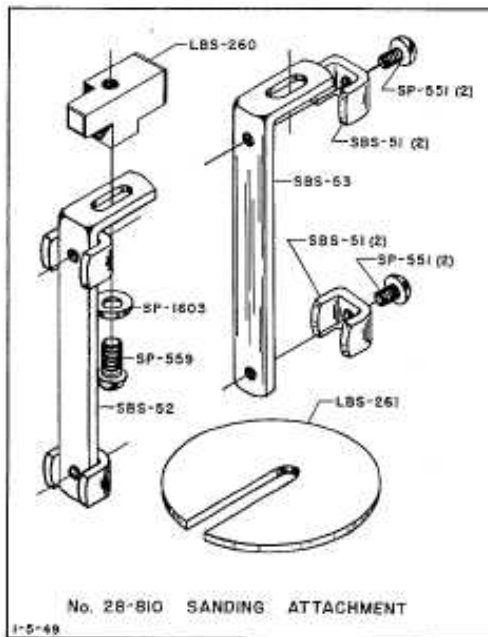


Fig. 3.

enced operator should make a few trial cuts to determine how the work should be fed against the garnet belt. The edges of a new garnet belt have a tendency to dig into the work more than intended if the work is not fed properly. If the operator finds that scratches appear on the work after making several attempts, use a small emery stone or a coarse oil stone against the extreme edges of the belt to remove the garnet and smooth the edges.

When a garnet belt becomes filled or loaded, the operator should stop the operation and install a new belt on the machine. Sanding with a loaded belt burns the work rather than cutting the edge or end of the stock. The garnet belts available are adapted for most types of wood. It gives a nice, clean cut and is hard enough to retain its sharp edges, thus insuring long life and economical operation.

#### SANDING CURVES

The sanding attachment is especially adapted for inside and outside curve sanding. Sanding to a curved pattern is illustrated in Fig. 2. Various methods are used to sand accurate curved shapes, the most common is to follow a line drawn on the stock. However, there are many opportunities to use templates, guides, jigs, center pins for circular arcs or wheels, and other devices.

When sanding outside curved surfaces, we recommend the use of the straight platen, SBS-52, whenever possible. For inside curved surfaces, the curved platen, SBS-53, should be used. Refer to Fig. 3.

#### SANDING BELTS

Band saw sanding belts are subjected to strains when in operation. Long service can only be obtained when selecting the correct belt for the work, and by carefully adjusting and operating the machine.

A new belt will sand effectively under moderate pressure and uniform feed. Excessive pressure should be avoided since it is harmful to the sanding belt in addition to taking extra time and possible breakage. It is not economical to try and glue the belt together after it has been broken; it will soon break again. New belts are comparatively cheap when considering the time involved in repairing a belt.

Standard belts available for use on the 14 inch band saw are #40 and #80 grit, 1/2 inch wide and 91 inches long. The belts for the 10 inch band saw are #40 and #80 grit, 1/2 inch wide and 70 inches long.

Use the coarser belts for rough work and reserve the fine belts where a smooth finish is needed.

#### ANGLE SANDING

Sanding the edges and ends of stock with a bevel is easily accomplished on the band saw. The table of the 14 and 10 inch band saws can be tilted 45 degrees to the right and 10 degrees to the left. Refer to the operating manual of your band saw to tilt the table correctly.

For best results we suggest the operator pre-cut the desired angle on the edge or end of the stock to be sanded. This method will prolong the life of the garnet belt considerably.

Feed the work slowly and with even pressure to insure smooth even sanding.

TABLE 1. REPLACEMENT PARTS

IMPORTANT: Give both the Part Number and the Description of each item when ordering from this list.

Part No.	Description	Number Required
<b>No. 28-310 SANDING ATTACHMENT</b>		
SBS-360	Mounting Bracket, Tapped #10-32 x 1/4"	1
LBS-261	Table Insert, 2" Aluminum Disk, 1/8" Th., 3/16" Slot	1
SBS-51	Sanding Belt Retaining Clip, 1/2 x 1/2 x 3/4"	4
SBS-52	Flat Platen, 1/2 x 4"	1
SBS-53	Curved Platen, 1/2 x 4"	1
SP-551	#10-32 x 1/4" Round Head Machine Screw	4
SP-559	#10-32 x 1/2" Round Head Machine Screw	1
SP-1603	1/4" Steel Washer	1

#### ACCESSORIES

No. 28-811	Five Fine Garnet Sanding Belts, 70' Long	1
No. 28-812	Five Medium Garnet Sanding Belts, 70' Long	1
No. 28-836	Five Fine Garnet Sanding Belts, 91' Long	1
No. 28-837	Five Medium Garnet Sanding Belts, 91' Long	1

CONSULT YOUR DELTA DEALER FOR PRICES OF REPLACEMENT PARTS, ACCESSORIES AND TOOLS TO FACILITATE HANDLING WE SUGGEST ORDERING ALL PARTS THROUGH YOUR DELTA DEALER

Foreign distribution is through TAUCO EXPORT CORPORATION, 28 Pearl Street, New York 4, New York, to Puerto Rico and the Canal Zone and to all foreign countries except Canada and the Philippine Islands.



Distribution in the United States, its possessions except Puerto Rico and the Canal Zone, and in Canada and the Philippine Islands is by authorized Delta Dealers.



DELTA MANUFACTURING DIVISION

ROCKWELL MANUFACTURING COMPANY

MILWAUKEE 1, WISCONSIN

Printed in the United States of America

