SuperMax Tools

OWNER'S MANUAL

C SA US
256540

19-38 Combo Brush/Drum SANDER

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Congratulations

You have made a wise purchasing decision by adding this machine to your tool line-up. The main purpose in inventing and developing the combo machine you've purchased was to bring a new dimension of productivity to your shop, be it large or small. Right from the start, our goal at SuperMax Tools has been to design and manufacture equipment that is capable of providing you with maximum economy, maximum utility, and maximum performance.

Your 19-38 Combo will pay you back many fold in the years ahead by helping you get better results in less time, start to finish. This tool incorporates a bundle of exclusive features which you will appreciate more every time you use it. All SuperMax Tools brush sanders feature a variable brush speed (RPM) and the exclusive variable-speed power feed conveyor system. Together, they provide you with ultra-precise control, for a variety of applications.

SuperMax Tools and its dealers are committed to providing you with innovative solutions, from selecting the right machine to helping you get top performance when you put it to work in your shop. Regardless of how you take advantage of these innovations, we are confident our equipment will help bring you a giant step forward in precision shop productivity.

Caution, Safety First

When maintaining and operating this machine, always put safety first. For your own safety, read and understand this owner's manual before operating this machine. Always heed and follow all normal safety precautions, including the following:

- **Always wear eye protection while operating the sander.**
- **Always feed stock against the brush rotation.**
- **Never place hands or fingers under the brush or dust cover.**
- **Keep hands and clothing away from operating brush and drum.**
- **Never operate the sander without its dust cover or guarding in place.**
- **Always maintain control of stock to avoid kickback; know how to prevent it.**
- **Always disconnect electrical power before doing any servicing or adjusting of the machine.**

Model Identification

Your 19-38 Combo sander is one of a family of machines from SuperMax Tools designed to help you achieve results comparable to industrial-size sanders at a fraction of the cost. For future reference, find the model, stock and serial numbers on the back of machine base and write them in below.

Model: _____

Stock Number: _____

Serial Number: _____

Date Purchased: _____

Dealer: _____

Important: Keep This Manual Handy

Please read this manual first. It was designed to help you get the most from your 19-38 Combo sander. Before unpacking or using the machine, familiarize yourself with its components, features, and basic adjustments by reviewing the following pages. You will find it an invaluable aid in setting up, operating and servicing your machine. If, after reviewing this manual, you still have a problem you can't solve, please call your SuperMax Tools dealer.

FOR YOUR SAFETY: Read all instructions carefully, and note the safety cautions on the opposite page and on the back cover of this manual.

About The SuperBrush System

This manual is designed to help familiarize you with your SuperMax sander, and to help you take advantage of its exclusive features. By understanding its major components, and how they work together, you will be able to get the most from your investment. The SuperBrush system is basically made up of: 1) a height adjustment handle which raises and lowers the sanding head; 2) a brush speed control knob which controls brush speed from 200 to 1000 RPM and drum speed to 1750 RPM; 3) a motor starter switch which starts and stops the drive motor and sanding brush; and 4) a feed rate control knob which starts feed conveyor and selects feed rate from 0-10 feet per minute.

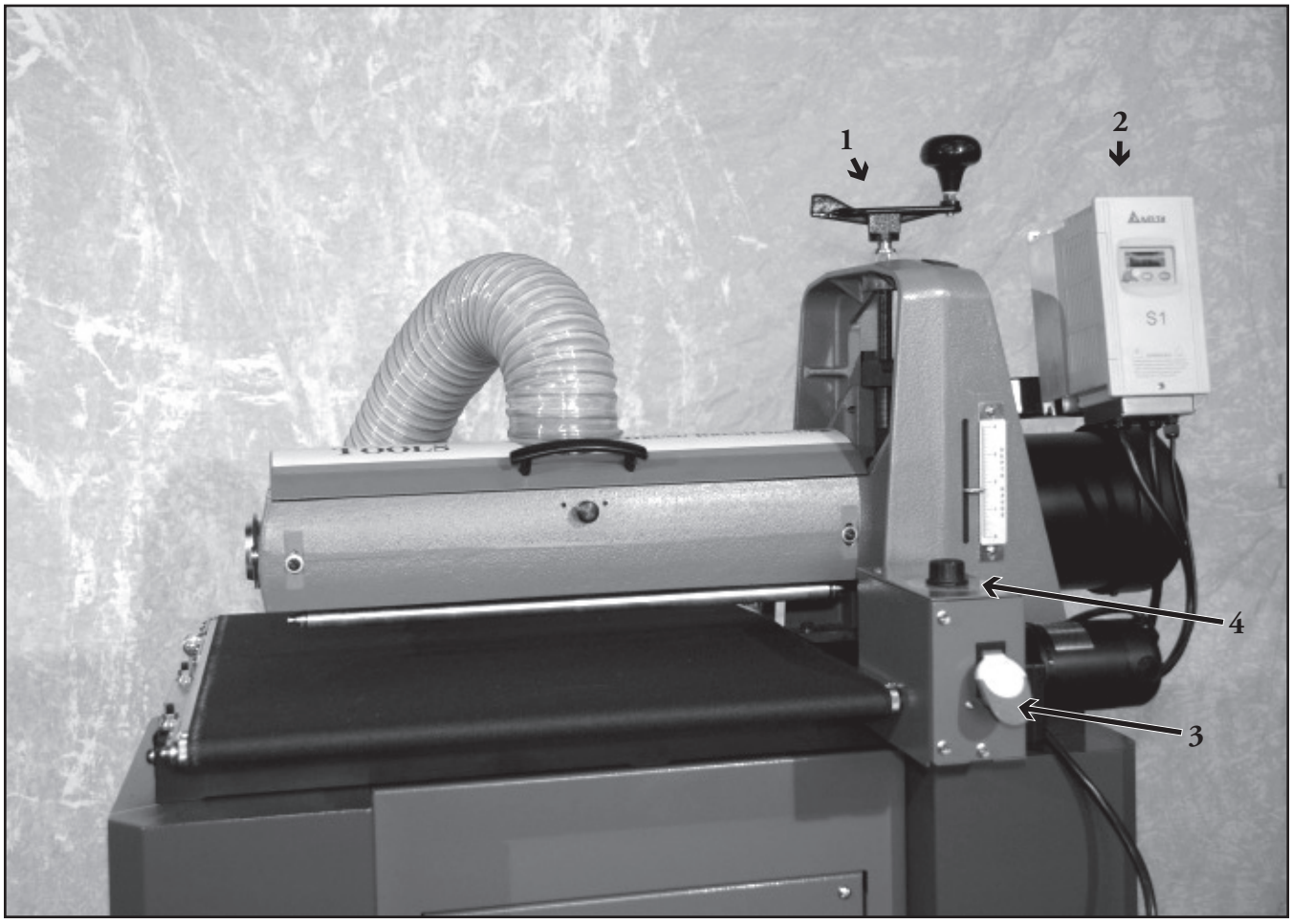


Fig. 1 SuperBrush nomenclature.

Unpacking Your SuperBrush

Your 19-38 Combo sander has been shipped mostly assembled from the factory. If any damage has occurred as a result of shipment, notify the transportation company as soon as possible and ask them to make an immediate inspection. Ask for a damage or loss report. Also notify your dealer of any loss or damage during shipment. See enclosed Warranty Statement.

Important: To avoid problems and potential damage to the machine, please read through the unpacking instructions below before proceeding to set up the machine in your shop.

1. Assemble stand or prepare dedicated bench for sander attachment

2. Open "Box 1" with main sanding unit. Remove cardboard liner. Open plastic bag.

3. Cut each corner of Box 1 to fold sides flat, providing access to sanding unit. (Fig 2)

4. Remove two wood packing plates from bottom of sanding unit. (Fig 3)

5. With one or two helpers, place sanding unit on stand or bench and attach securely. Use bolts from packing plates.

6. Install knob to height adjustment handle, finger tighten nut to knob. Thread stud from knob into hand wheel (Fig 2). Tighten nut against handwheel.

7. Using handle, raise sanding head to high position and remove packing block from under carriage arm and motor, if so equipped. (Fig 4)

8. Remove conveyor from packaging and place on sanding unit. The conveyor motor should be near main motor and depth gauge.

9. Install two lock washers and two flat washers on studs on outboard side of conveyor.

10. Install lock washer and flat washer onto two socket head (or hex head bolts) and install into flange of conveyor bed on inboard (motor side). Keep support plate in place on inboard side and make sure "fast lever" is positioned up. Fig. 4A

11. Tighten all bolts and nuts.

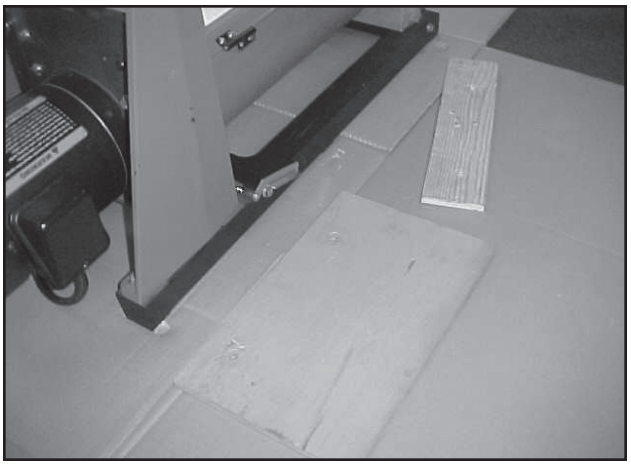


Fig. 3 Remove packing plates

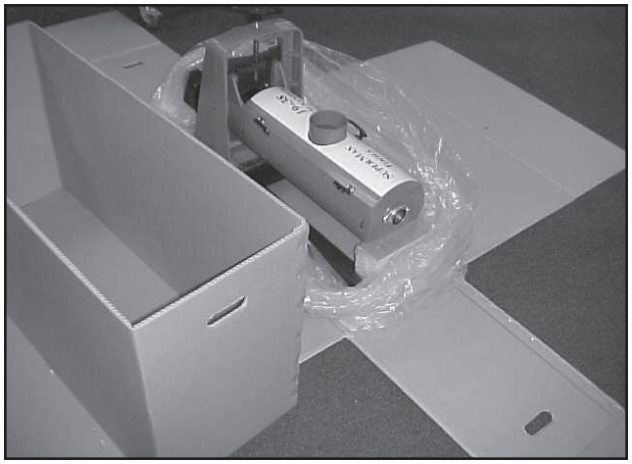


Fig. 2 Open plastic, remove liner, cut box

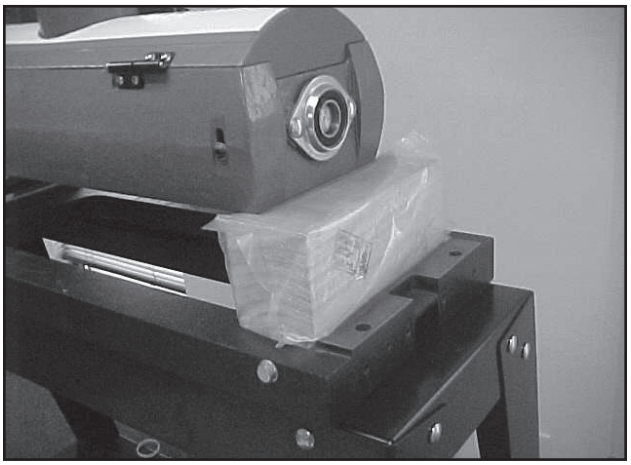


Fig. 4 Secure to stand, remove packing block

Setting Up Your SuperBrush

Your 19-38 Combo sander was adjusted and aligned at the factory, and it has been carefully packed for shipment. However, because of possible stress during transit, the unit should be thoroughly checked before being put to use. This section covers the preoperational checks you should make after unpacking and final assembly. Unnecessary problems can be avoided if these essential checks are performed before operating. Likewise, performing the recommended monthly maintenance procedures (page 12) will help assure trouble-free service.

Connecting Dust Collectors

Dust collection is necessary for all models. The 19-38 Combo is equipped with one 4" diameter dust exhaust port at the top of the cover.

To attach to your collection system, install 4" hose from your collector. (See Tips For Maximum Performance, page 12 of this manual.) The minimum recommended dust collector capacities is 600 cfm. For best results, follow the recommendations of the manufacturer of your dust collection equipment. NOTE: Some applications will require more dust collection than the recommended minimum CFM.

Checking Machine For Level

Proper leveling of the machine is important to achieve continued maximum performance from the 19-38 Combo.

Fig. 4A Install knob

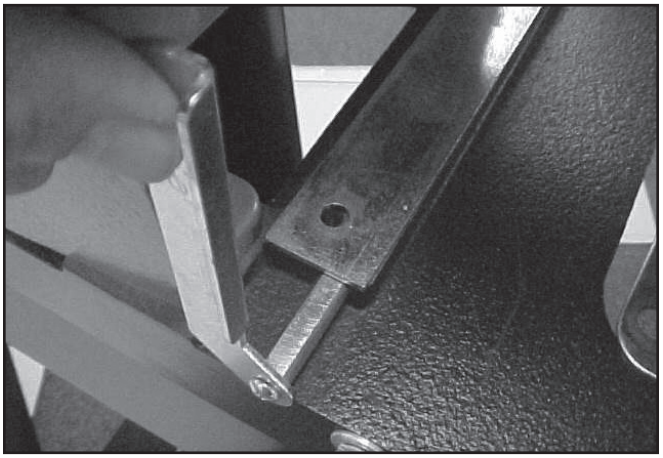


Fig. 4B FAST Lever "UP"

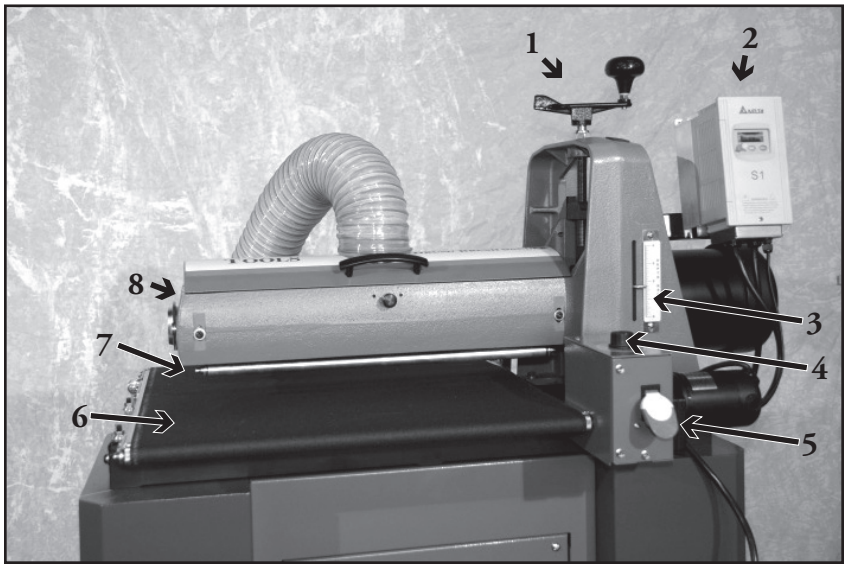


Fig. 5

Fig. 5 SuperBrush Components.

1. **Height Adjustment Handle**
2. **Brush Speed Knob (RPM)**
3. **Depth Gauge**
4. **Conveyor Adjustment**
5. **Drum/Brush ON/OFF Switch**
6. **Conveyor Table**
7. **Tension Rollers**
8. **Drum/Brush Carriage**

Height Adjustment

The brush/drum height is controlled by the height adjustment handle (Fig.5). Turning the handle raises or lowers the sanding head. One revolution of the handle raises or lowers the table 1/16 of an inch.

Before operating height adjustment, be sure the packing-block is removed. It is located under the outboard end of the carriage arm (Fig. 3). Raise drum/brush to remove.

Brush Alignment

The brush must be parallel to the conveyor bed surface. Brush alignment can be visually checked by raising the tension rollers (Fig. 6) to their highest position (See Tension Roller Adjustment page 9) and lowering the head so the brush just contacts the conveyor surface. Brush contact should be equal across the width of the conveyor. Brush misalignment can be corrected by loosening the four cap screws on the outboard edge of the conveyor and turning the 7/16" adjustment nut to bring the conveyor parallel to the brush or drum. See Fig. 7

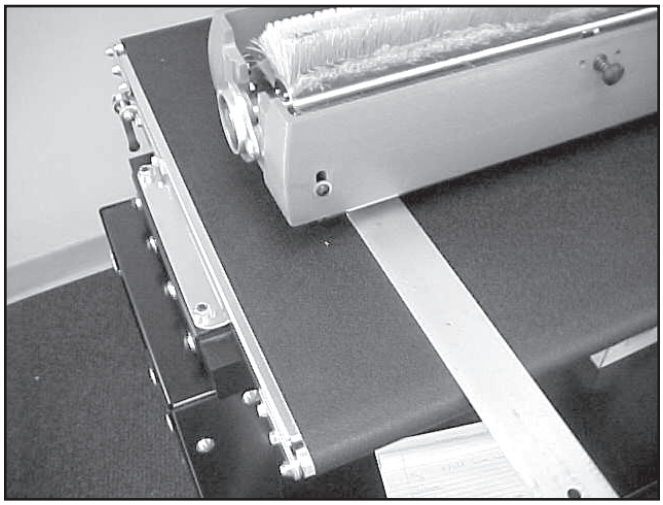


Fig. 6 Checking brush alignment and table height adjustment (outboard side).

Drum Alignment

Check alignment when using sanding drum. After installing sanding drum, remove abrasive from drum. Using a flat piece of wood or aluminum as a thickness gauge, insert it between the conveyor belt and the drum on the right (inboard) side of the machine (Fig. 5). Lower the sanding head so the drum just contacts the thickness gauge. Then, holding up the front tension roller, check both sides of the drum using the thickness gauge. If the drum is not parallel, loosen the four socket head cap screws (along the outboard edge of the conveyor)and raise or lower the conveyor with the 7/16" adjustment nut to achieve parallel alignment. Tighten the four socket head cap screws.

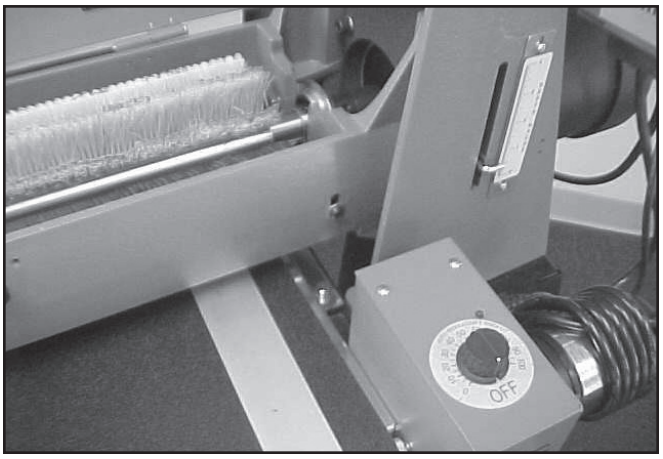


Fig. 6A Checking brush alignment (inboard side).

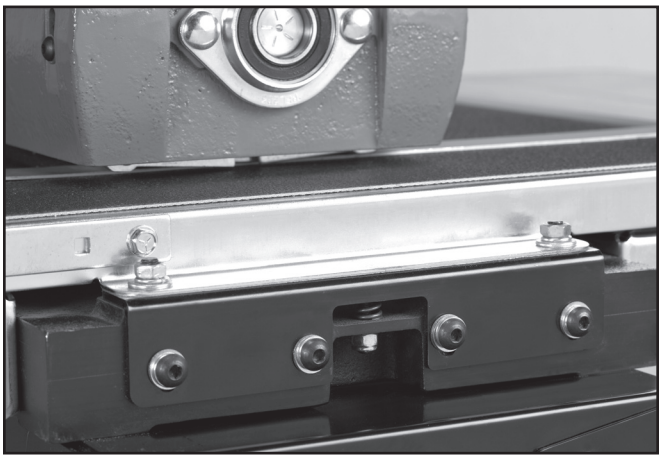


Fig. 7 Adjusting brush alignment.

IMPORTANT! When using the sanding drum accessory, adjust RPM Gauge to "drum sanding" highest setting, turned fully clockwise. Only use drum sander at this setting!

RPM Gauge

The RPM gauge or readout (Fig. 8) displays the brush speed or rotation. The label under the control knob is a guide. **IMPORTANT:** The brush heads are to be run between 200-1000 RPM only! The sanding drum is to be run at max (1750) RPM only! Damage to the machine, brush or drum can result from not following this guide. Choose proper brush RPM for the best results and type of brush.

Checking Conveyor Belt Tracking

Conveyor belt tracking adjustments may occasionally be necessary during break-in and normal operation to compensate for belt stretching. If adjustments are necessary, follow the instructions below: Belt tracking adjustments are made while the conveyor belt is running. With the conveyor unit on and set at the fastest speed setting, watch for a tendency of the conveyor belt to drift to one side of the conveyor. To adjust the belt tracking, tighten the take-up screw nut (Fig. 9) on the side the belt is drifting toward, and loosen the take-up screw nut on the opposite side. Adjusting the take-up screw nuts on both sides of the conveyor allows belt tracking adjustments to be made without affecting belt tension. Adjust the takeup screw nuts only 1/4 turn at a time. Then allow time for the belt to react to the adjustments before proceeding further. Try to avoid over-adjustments. NOTE: Make sure wrench is below surface when brushing or sanding.

Fig. 8 Brush RPM gauge.

Fig. 9 Hanging wrench 1 of 2, for tracking conveyor

Operating Your 19-38 Combo Drum/Brush

Before using your Brush, review the previous pages in this manual on initial set-up and adjustment. In this section, you will learn how to operate the machine. Note that connecting the machine to an adequate dust collection system is necessary before operating the unit.

The SuperBrush offers considerable control and versatility through variable brush speed and feed rate. Experiment with both to find the proper sander performance for a given application. Varying the brush speed makes the brush more or less aggressive. Too aggressive on the brush may tend to raise the grain or excessively round edges. Sometimes it may be better to make two or more passes with a less aggressive brush or setting.

The brush is rotating against the direction of feed; therefore, the leading edges of contours will receive more sanding than trailing edges. Stock should be reversed on subsequent passes to sand all surfaces. Stock may also be fed at an angle to allow more brush penetration on the sides.

Basic Operating Procedures

After you have connected the machine to a dust collection system, you are ready to begin to use the SuperBrush. The basic operating procedure for the SuperBrush models is as follows (Fig. 10):

1. Set depth of cut/bristle contact (page 10).
2. Set tension rollers to type of stock being sanded (See Tension Roller Adjustment below and Fig. 11).

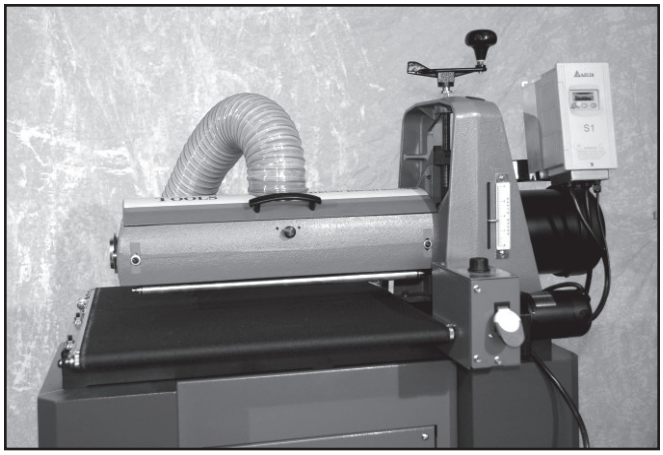


Fig. 10 Operating controls.

3. Start sanding brush and select slow brush speed (page 8).
4. Start conveyor and select feed rate (page 10)
5. Start dust collector system.
6. Feed stock through unit.
7. Gradually increase brush speed (RPM) until the desired finish is achieved (Fig. 8).

To feed stock through the SuperBrush, rest and hold the stock to be sanded on the conveyor table, allowing the conveyor belt to carry the stock into the brush. Once the stock is halfway through, reposition yourself to the outfeed side of the machine to receive and control the stock as it exits the unit.

Tension Roller Adjustment

Spring loaded infeed and outfeed Tension Rollers (Fig. 11 & page 26) are provided to maintain downward pressure on stock being sanded and to prevent slippage of the stock on the conveyor. When properly set, the Tension Rollers should engage or raise up about 1/8" to accommodate the stock being brushed.

The Tension Rollers can and must be adjusted to accommodate flat surfaced stock vs highly contoured surface stock. Tension Roller height is adjusted as follows: Note: Make sure brush head is appropriate for application and contact.

Tension Roller Pressure

The tension roller pressure is factory set for most applications. However, the pressure of each roller can be adjusted. Caution, too little pressure can result in slippage of stock on conveyor belt or kick-back. Too much tension can cause snipe when drum sanding or not enough lift when sanding profiled material. To increase tension turn the tension adjusting screw clockwise ¼ revolution at a time. To decrease tension turn the adjusting screw counter-clockwise ¼ revolution at a time. See fig (11).

Tension Roller Pressure

The tension rollers are factory set for the most versatile use and longest minimum length, approximately 4-1/2" for most applications. The rollers can be adjusted closer to the sanding drum when sanding

short, flat stock only. To adjust, remove the four tension adjusting screws, keeping track of screw penetration into retaining nut. Slide rollers in toward drum using retaining nut closest to drum. Reinstall four adjusting screws with the same tension or penetration into retaining nut. See page 26.

Flat Surfaced Stock: Loosen the four socket head screws holding the tension roller brackets. Place stock under brush. Lower brush to proper bristle penetration. Raise brush two-to-three revolutions. Tighten the four socket head screws. Remove stock, lower brush head to previous setting when adjusting and brush material.

Bristle Contact: Proper bristle penetration is critical for the best finish and longest brush life. Flatter brushes should be set to penetrate between 1/8 to ¼" into the deepest part of the profile being sanded. Nylon brushes should be set to penetrate approximately 1/16" into the deepest part of the profile being sanded. Wire brushes should be set to penetrate 1/32 to 1/16" into the material being brushed.

Selecting Brush Stock Feed Rates

Selecting the proper feed rate is essential to proper Brushing and sanding. Feed rate controls the duration or "dwell time" of brushing on the contact area. A slower feed rate allows more brushing to occur. In some instances, a slow feed rate and slow brush speed may produce the same result as a fast feed rate and fast brush speed. The variable feed rate control of the conveyor belt adjusts the load on the machine; it can be infinitely adjusted for maximum operating

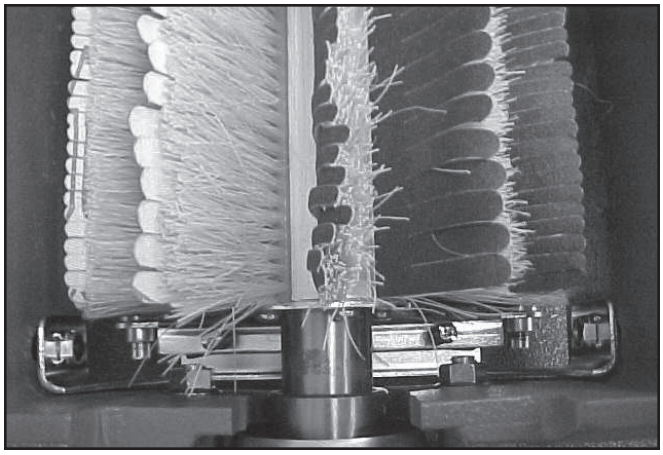


Fig. 11 Tension rollers and adjustment bracket

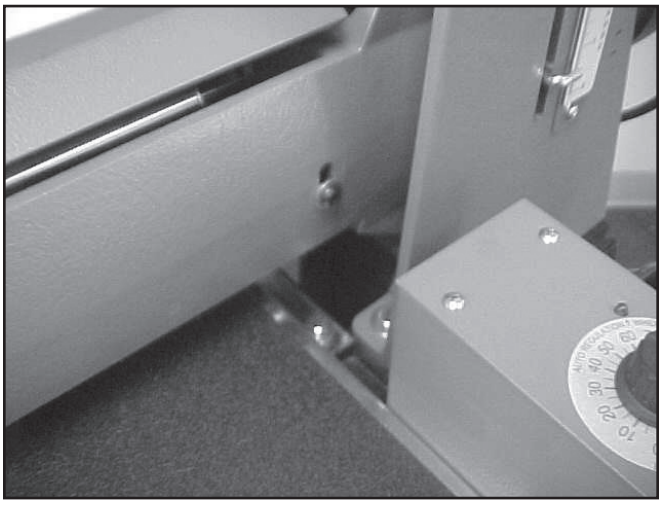


Fig. 11A Tension roller height and depth gauge adjustment

performance. A faster feed rate allows faster brushing but fewer revolutions of the brush per inch of sanding. A slower feed rate provides more revolutions of the brush per inch of sanding (Fig. 10).

The best feed rate will depend on a number of factors, including type of stock, brush, depth of cut used, and whether the stock is fed directly in line with the conveyor bed or at an angle. When testing feed rates, begin with a mid range (50%) setting and adjust faster or slower depending on conditions and performance.

Drum Sanding Feed Rates

Selecting the proper feed rate is essential to proper finish sanding. For finish sanding the best finish is usually achieved with a slow to moderate feed rate, after the proper depth of cut has been determined. This allows for the most revolutions of the drum per inch of sanding. When abrasive planning, faster feed rates can be used as long as the machine is not over stressed. Please note, angling stock as it is sanded will allow the most effective stock removal and least loading of the abrasives. Feeding stock straight through yields the widest sanding capacity and least noticeable scratch pattern.

Please note; when drum sanding with RPM adjusted to fastest speed, INTELLISAND will automatically adjust the conveyor feed rate if an excess load is detected. This prevents excessive gouging, reduces the risk of burning and it protects the machine from overload or stalling. The red light by the adjustment

knob will come on when INTELLISAND is operating. (Fig. 11 a) When the load is decreased, INTELLISAND will automatically increase the feed rate to the pre-selected speed. INTELLISAND **does not** engage when brush sanding or if drum sanding at a slower RPM than recommended.

Setting Brush Depth of Cut/Contact

When a nylon or wire brush is worn and needs changing, the bristles will either have fractured and the brush head looks "bald" or the bristle length has worn and the bristles are too short for effective brushing.

When an abrasive or cloth brush is worn, the brushing material will become smooth or the brush will be considerably smaller in diameter as compared to new. Please call SuperMax Tools if you have any questions. Brush life can vary considerably, due to RPM, contact, type of brush, and material being brushed.

Some types of brush heads, some fladder brushes, for example, will allow changing of the brush material by the operator.

When using a wire brush for "distressing" wood, slowing brush RPM, using light contact and a moderate feed rate generally will give the best finish and longest brush life. When using a wire brush on metal, it is important to use a light contact of the bristle tips. **Nylon Brushes.** If a nylon brush brush becomes uneven dressing the tips of bristle brush to maintain uniform brush wear will be a benefit.

Dressing Instructions:
Staple or glue a wide sheet of 60 grit sandpaper to a 1/2" thick flat wood surface. Strips of narrow sandpaper can also be used. Lower the brush so the tips of the bristles contact the sandpaper by 1/32". Set the conveyor speed to approximately 50% feed rate. Pass the abrasive loaded board through the machine until the brush fibers are sharp and even

Setting Drum Depth of Cut

Determining the depth of cut is the most IMPORTANT set-up procedure before operating as a drum sander. It may take some experimentation to determine the proper depth of cut, given the variables of abrasive grit, type of wood, and conveyor feed rate. Practicing on scrap before sanding a project can be beneficial.

A good rule-of-thumb when sanding is to place the workpiece under the drum and lower the sanding head until the workpiece contacts the drum but the drum can still be rotated by hand. When making successive passes, lower the sanding head no more than the thickness of the grit abrasive, I.e. 1/8-1/16 of a turn for 80 grit and less for finer grits. **Note:** one revolution of the height adjustment handle moves the sanding head 1/16".

Depth Gauge Operation

The depth gauge (see Fig. 5) measures the distance between the conveyor table and the bottom of the sanding brush or drum. The sanding head must be parallel to the conveyor bed surface. To calibrate the depth gauge, loosen the two screws holding the scale. Lower the brush or sanding head (with abrasive installed) until the head touches the conveyor belt. Slide the scale to align with the pointer at the "0" mark. Tighten the two screws holding the scale. An optional DRO (digital read out) for depth is available. Fig. 12. This offers the most precise reading of sanded thickness and allows for accurate repeatability of a thickness. Great when making parts that must be an exact thickness or when matching a thickness.

To operate, turn ON and select standard inch "in" or metric millimeter "mm". Lower drum, with abrasive installed, until it touches the conveyor belt. Press "zero" button to calibrate.

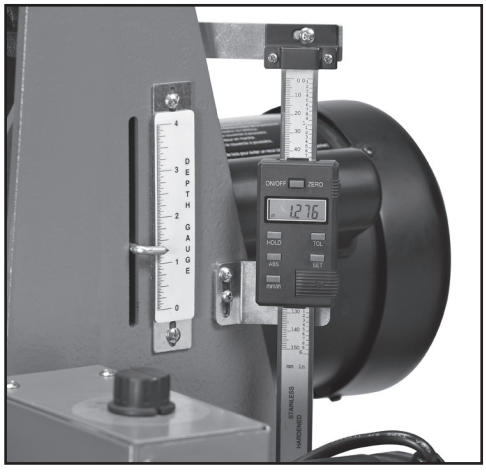


Fig. 12 Depth Gauge and optional DRO

Changing brush heads or drum.

To remove head:
Unplug sander. Loosen two set screws in motor coupler half. Loosen two set screws in outboard (left) bearing. Loosen two set screws in inboard (right) bearing. Remove two bolts from outboard bearing. and two bolts from inboard bearing. Lift and pivot brush or drum from outboard side and pull from motor coupler. Use gloves when handling wire brush.

To install head:
Install bearings on shaft with set screws loose. Install coupler with key on inboard side. Tighten set screws in coupler half of head. Install rubber spider in coupler half of head. Make certain no spider is in coupler half on motor. Pivot new head into place by first aligning couplers. When pivoting new head in place, lower head. Tapping on the outboard end of the shaft with a rubber hammer can help seat coupler. Caution, do not damage bearing when tapping. When head is in place install bolts into both bearings and tighten. Make sure head is centered in housing and couplers seated. If needed, slide motor coupler half into new head and tighten set screws. Tighten two set screws in each bearing, inboard and outboard. Make sure all bolts and screws are tight.

Monthly Maintenance

For best results, perform the following recommended maintenance procedures on a monthly basis:

- Lubricate conveyor bushings and check for wear.
- Lubricate all moving parts, such as threaded rods and washers
- Clean dust from the conveyor belt.
- Blow dust from the motors.
- Check all set screws for tightness.
- Clean brush or drum and abrasives, if applicable.

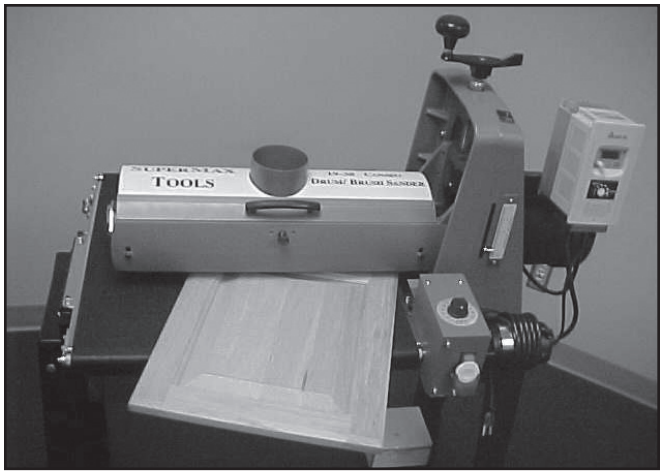


Fig. 13 Offset stock feeding angle.

Tips For Maximum Performance

The versatility designed into the 19-38 Combo allows it to be used for a wide-ranging variety of tasks that will boost the return on your investment. Learning to use its multiple adjustments and controls will allow you to fine-tune the machine for maximum results, regardless of the job to be done. The best results come from experimenting with different machine adjustments to fit the job at hand. Following is a listing of useful tips which can help you improve performance of your brush sander.

Dust Collection. When connecting dust collectors, remember that straight pipe will not restrict airflow as much as flexible tubing. Also, Ys and elbows will restrict airflow less than Ts.

Brushing Multiple Pieces At Once. When brushing multiple pieces simultaneously, make sure to stagger (step) the pieces across the width of the conveyor belt. This provides better contact with the tension rollers. Try to only process multiple pieces of similar thickness. If there is a significant thickness difference, the thinner pieces can slip on the conveyor belt if they do not contact the tension rollers. When brushing high stock, special care is needed to prevent tipping.

Brushing Imperfect Stock. To avoid personal injury, take special care when sanding/brushing stock that is twisted, bowed, or otherwise varies in thickness from end to end. If possible, support such stock as it is being brushed to keep it from slipping or tipping. Use extra roller stands, help from another person, or hand pressure on the stock, to minimize potentially hazardous situations.

Stock Feeding Angle. Some pieces, because of their dimensions, will need to be fed into the machine at a 90° angle (perpendicular to the brush). However, even a slight offset angle of the stock can provide for more effective sanding/brushing on some stock (Fig. 13).

Keeping the Machine Clean. For best results, make cleaning the machine a regular shop procedure. Allowing excess build-up of dust and debris can adversely affect performance, slippage on the conveyor belt, and/or the accumulation of material on the brush which can throw off the center of balance. Leave the dust collector on when cleaning dust from the drum or brush. Also sweep the conveyor belt after cleaning operations. If not cleaned, the conveyor belt could allow stock to slip during operation.

WARNING: Do Not Re-wire machine to 220 volt

Changing Flatter Strips

19-38 Combo Flatter abrasive strip changing

Unplug sander

Loosen two set screws from outboard (left) brush support bearing

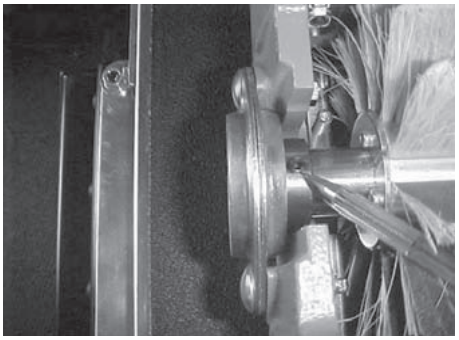


Fig. 14A

Remove two 3/8" carriage bolts from outboard brush support bearing

Remove outboard bearing from shaft of brush

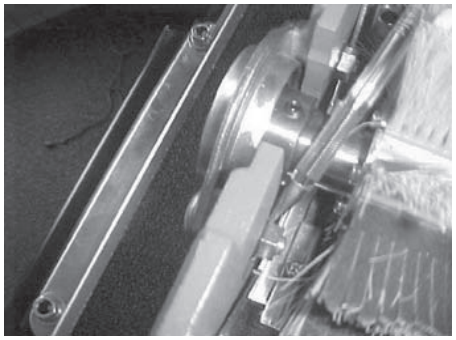


Fig. 14B

Remove four screws from end-caps of outboard side of brush head

Remove two end caps

Pull strips of abrasive from outboard side of brush head. Remove one strip at-a-time

Replace strips by sliding them into brush head. Abrasive side must face "up" on infeed or front of brush head.

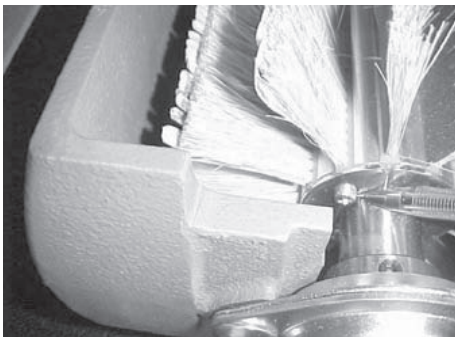


Fig. 14C

Note: Abrasive side of strips must be oriented so abrasive side contacts top of stock as it passes through sander.

Replace end caps of brush head and install four screws

Reinstall bearing and tighten the two 3/8" carriage bolts

Tighten the two set screws, in the bearing, to the brush shaft

Close dust cover

Plug in sander

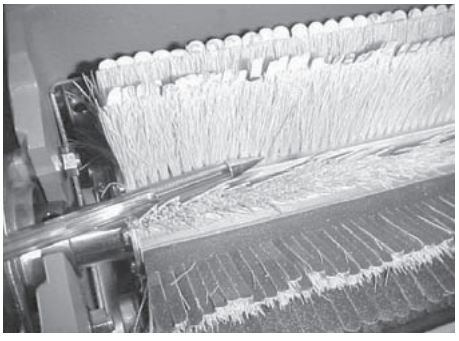


Fig. 14D

Abrasive Selection Guide

Grit	Common Application
24 Grit	Abrasive planing, surfacing rough-sawn boards, maximum stock removal, glue removal.
36 Grit	Abrasive planing, surfacing rough-sawn boards, maximum stock removal, glue removal.
50 Grit	Surfacing and dimensioning boards, trueing warped boards.
60 Grit	Surfacing and dimensioning boards, trueing warped boards.
80 Grit	Light dimensioning, removal of planer ripples.
100 Grit	Light surfacing, removal of planer ripples.
120 Grit	Light surfacing, minimal stock removal.
150 Grit	Finish sanding, minimal stock removal.
180 Grit	Finish sanding only, not for stock removal.
220 Grit	Finish sanding only, not for stock removal.

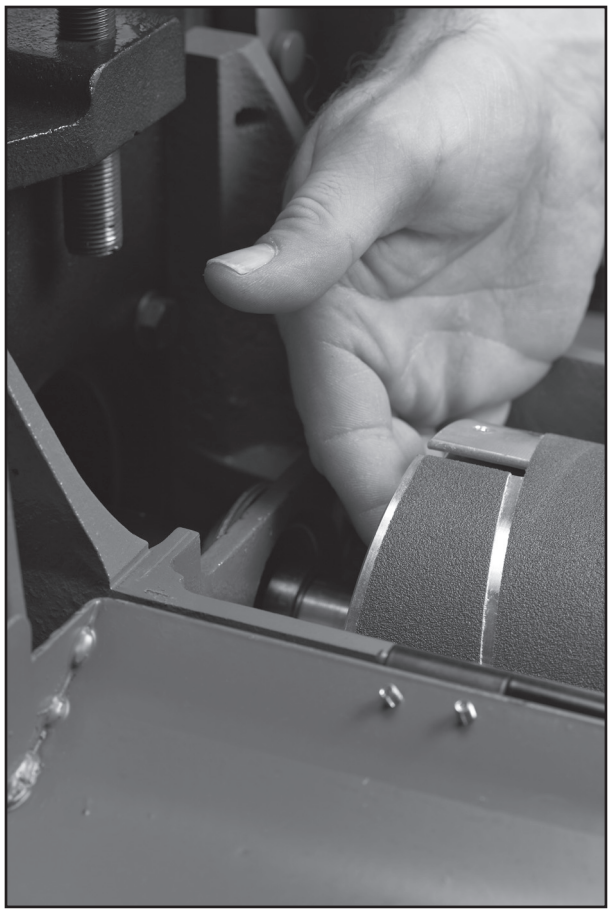


Fig. 15 Accessing inboard abrasive fastener

Wrapping Abrasive Strips

Note: When using Pre-Marked™ or Pre-Cut™ abrasives, not all of the steps below are necessary.

Proper attachment of the abrasive strip to the drum is critical to achieving top performance from your SuperMax Tools drum sander. Abrasive strips do not have to be pre-measured. The end of the roll is first tapered and attached to the left (outboard) side of the drum. Then the strip is wrapped around the drum, and the second taper is made for attachment to the right (inboard) side of the drum. To attach a strip to the drum, follow the procedure below.

1. Mark and cut a taper at one end of the roll as shown in Fig. 16a. Because the tapered end should use most of the left (outboard) slot width, its end must be trimmed (Fig. 16B and 16C). Raise the clip lever on the left (outboard) side of the drum (Fig. 16D). Insert the tapered end through the slot and into the fastener so that it uses most of the width of the slot. Release the clip lever to securely hold the strip end in the fastener.
2. Wrap the strip around the drum, being careful not to overlap the windings. The tapered cut of the strip end should follow the edge of the drum. Continue to wrap the abrasive in a spiral fashion by rotating the drum with your left hand and guiding the strip with your right hand (Fig 16E). Successive windings of the strip should be flush with previous windings without any overlap.
3. Mark the trailing end of the strip where it crosses the right (inboard) end of the drum (Fig. 16F). From this point, cut a taper as was done with the starting edge of the strip. (The taper on the remaining roll can be used as the taper for the starting edge of the next strip to be cut.)
4. With the trailing edge of the strip properly cut, rewrap the drum and insert the tapered end through the slot in the right (inboard) end of the drum. Insert the tapered end into the inboard take-up fastener. Pull up on the clip lever to open the clip, and pull the take-up lever to the top as shown (Fig. 16G). After inserting the strip end, release the clip lever by moving your index finger toward the drum slot. This allows the clip to retain the abrasive while holding the take-up lever in an "up"position.
5. The take-up fastener is designed to automatically take up any slack caused by stretching of the abrasive strip. ***Important: Position the abrasive strip in the slot with sufficient room between the inside of the slot and the tapered end of the strip to allow it to be pulled into the drum as needed (Fig. 16H). Note that not leaving enough space between the strip and the inside of the slot will prevent the take-up fastener from operating properly.***
6. The abrasive strip may stretch enough in use to allow the take-up lever to reach its lowest position so it no longer is able to maintain tension on the strip (Fig. 16I). If this occurs, it will be necessary to reset the take-up lever by raising it, pushing the strip end into the slot, and then releasing the clip lever.

Note: A sandpaper cleaning stick may be used to remove deposits and help extend sandpaper life. To use, operate the sanding drum with the dust cover open. (**Caution:** For your own safety, always wear eye protection while performing sandpaper cleaning, and take all precautions to avoid any contact of hands or clothing with uncovered drums.) Hold the cleaning stick against the rotating drum and move it along the drum surface. It is good procedure to use a shop brush to remove any cleaning stick crumbs from the drums before resuming sanding operations.

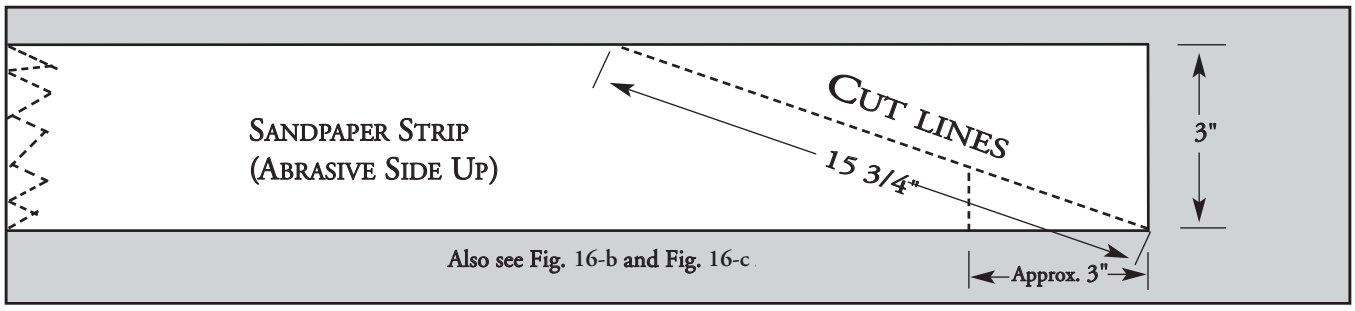


Fig. 16 Marking and cutting taper on strip.

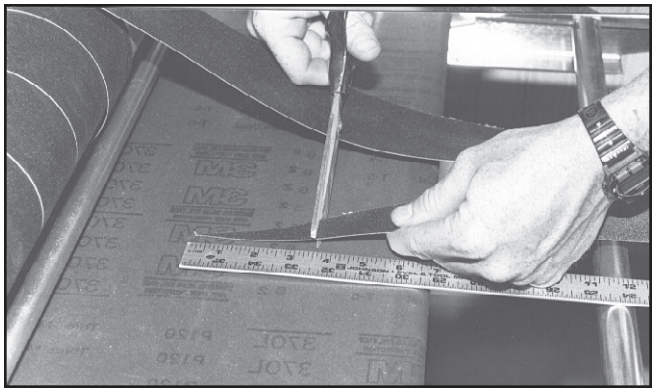


Fig. 16B Trim about 3" from end of cut taper.

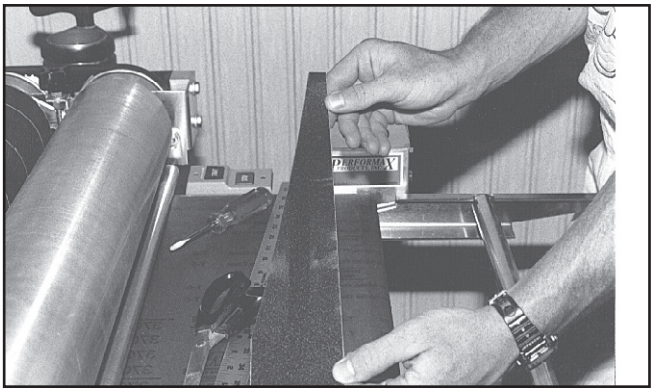


Fig. 16C Trimmed tapered end ready to install.

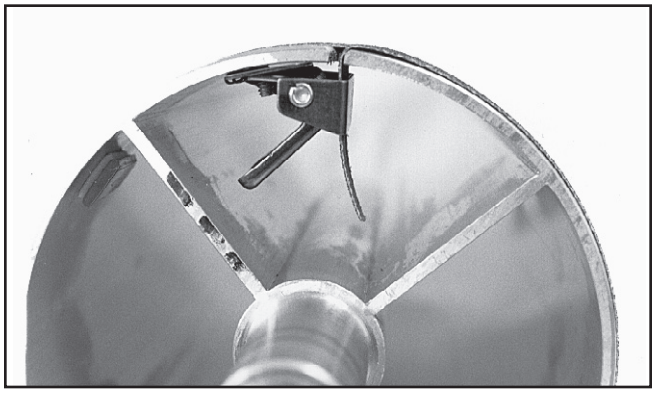


Fig. 16D Insert tapered end into outboard slot.

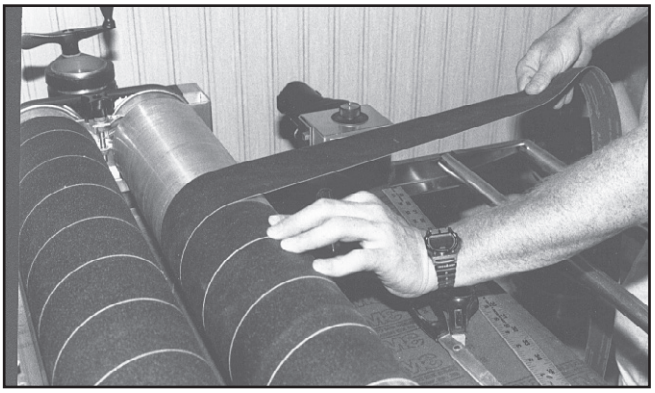


Fig. 16E Wrap strip around drum without overlap.

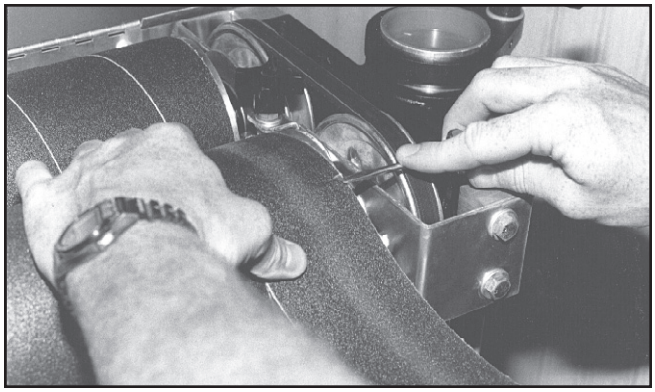


Fig. 16F Mark strip where it crosses drum edge.

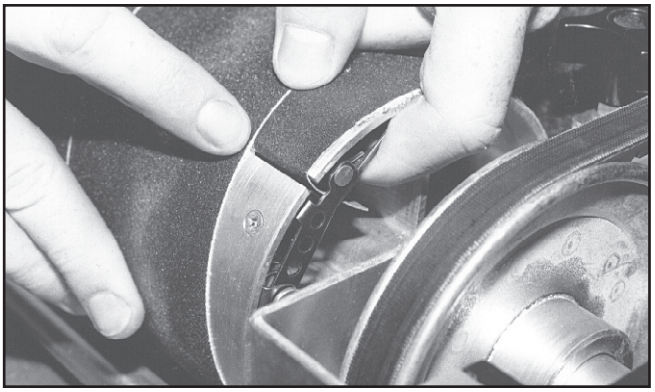


Fig. 16G Insert tapered end into inboard slot.

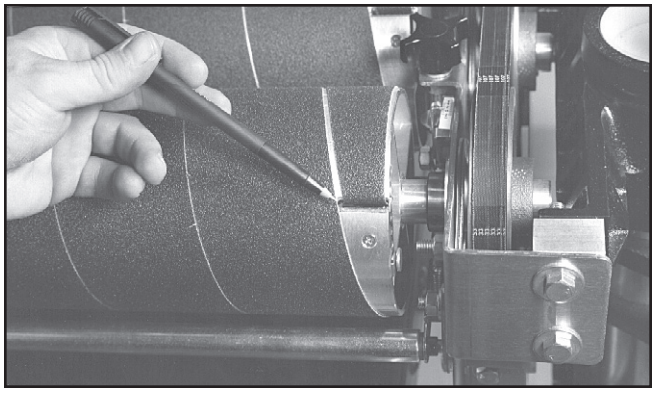


Fig. 16H Allow room inside slot for strip to move.

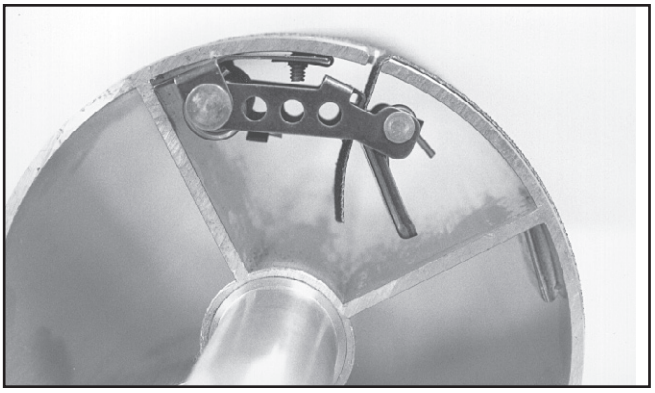


Fig. 16I Reset take-up as needed as strip stretches.

Replacing Conveyor Belts

To replace the conveyor belt, the conveyor assembly must be removed from the machine. Raise the drum/brush carriage to its highest position using the height adjustment handle. Turn off power source to machine. Unplug main drive motor and inverter from receptacle (in gear motor assembly). Loosen the conveyor take-up screws (Fig. 9) to relieve belt tension and slide the driven roller fully inward. Remove the two bolts (inboard side) that attach the conveyor assembly to the base (see Fig. 11A & 17). Remove the two nuts and washers (outboard side) (Fig. 7 & 18). Lift the conveyor and remove it from the sander. Stand conveyor on motor side. Avoid tearing the belt on any edges underneath the conveyor bed during removal. Reverse the procedure for re-installation. Re-install the conveyor bed to sander.

Conveyor Belt Tension: To adjust the tension of the conveyor belt, first adjust the take-up screw nut (Fig. 9) on both sides of the conveyor to obtain approximately equal tension on both sides of the belt when taut. Insufficient belt tension will cause slippage of conveyor belt on the drive roller during sanding operation. The conveyor belt is too loose if it can be stopped by hand pressure applied directly to the top of the conveyor belt. Excessive belt tension can result in bent rollers, premature wearing of the bronze bushings or conveyor belt

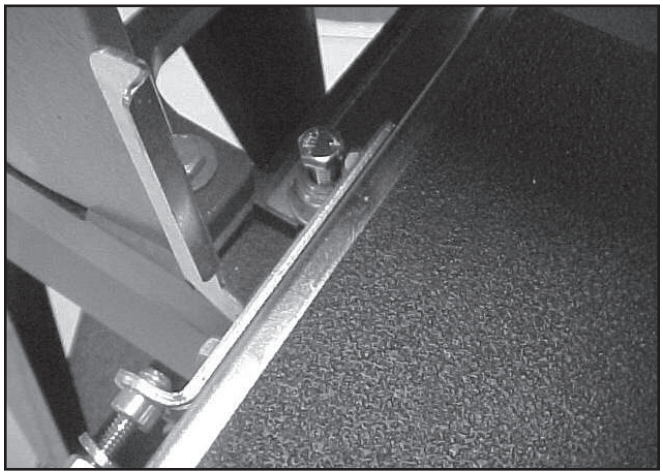


Fig. 17 Inboard conveyor attachment bolts.

Conveyor Belt Tracking: Belt tracking adjustments are made while the conveyor belt is running. After the proper belt tension is obtained (see above), turn the conveyor unit on and set it at the fastest speed setting. Watch for a tendency of the conveyor belt to drift to one side of the conveyor. To adjust the belt tracking, tighten the take-up screw nut (Fig. 9) on the side the belt is drifting toward, and loosen the take-up screw nut on the opposite side. Adjusting the take-up screw nuts on either side of the conveyor allows belt tracking adjustments to be made without affecting belt tension. Note: Adjust the take-up screw nuts only 1/4 turn at a time. Then allow time for the belt to react to the adjustments before proceeding further. Avoid over-adjustments.

Fig. 18

Troubleshooting Your SuperBrush

Any operating problems with the SuperBrush will likely occur most often during the period that you are becoming familiar with its components and their adjustments. If you are experiencing a problem affecting the machine's brushing performance, check the following listings for potential causes and solutions; it may also pay to review the previous sections in this manual on setting up and operating your machine.

Troubleshooting Guide: Motors

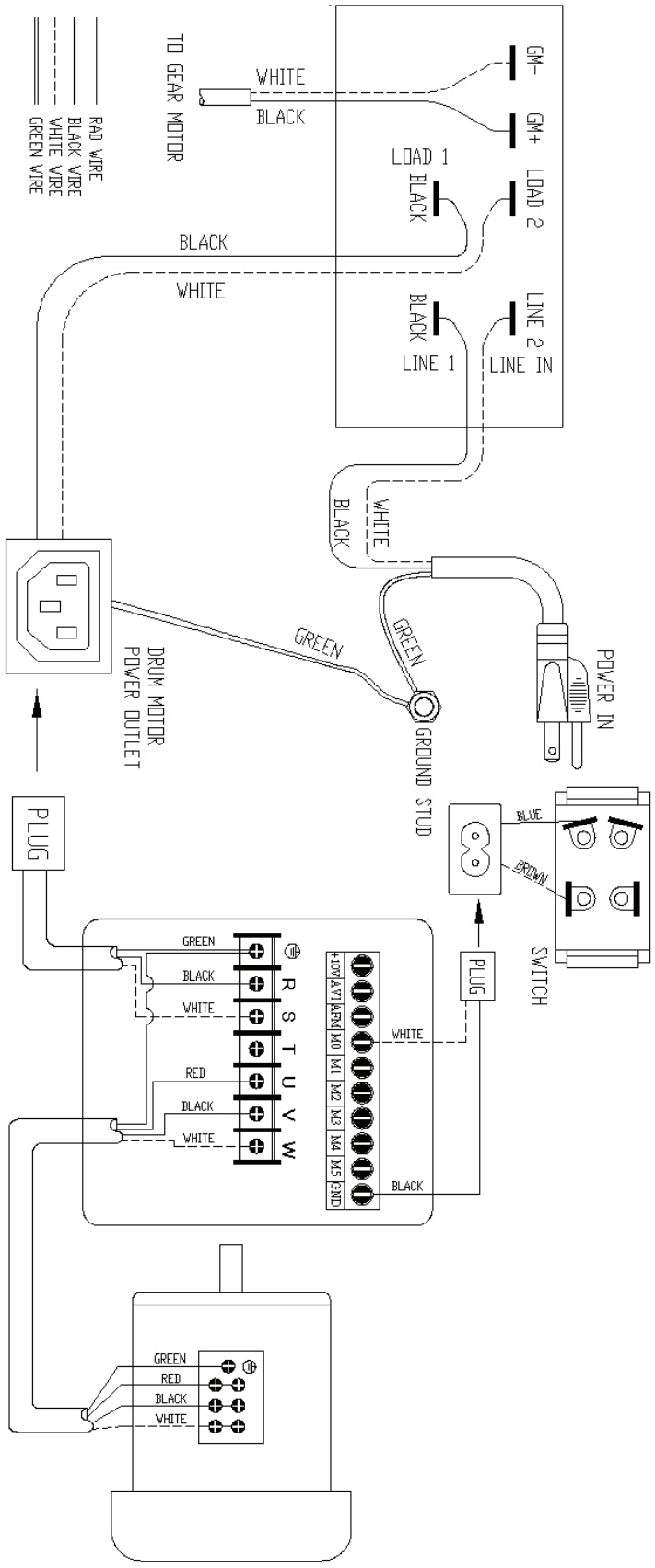
Problem	Possible Cause	Solution
Motors do not start.	1. Main power cord unplugged from receptacle.	Plug in primary power cord.
	2. Brush motor cord unplugged from receptacle near power-feed motor.	Plug in brush motor and inverter cord at receptacle on machine if so equipped (Fig. 5).
	3. Circuit fuse blown or circuit breaker tripped.	Replace fuse or retrip breaker (after determining cause).
Brush motor overloads.	1. Inadequate circuit.	Check electrical requirements
	2. Machine overloaded.	Use slower feed rate; slower brush RPM; reduce depth of cut.
Conveyor motor oscillates.	1. Motor not properly aligned.	Loosen housing bolts, run motor, retighten bolts.
	2. Shaft collar or bushing worn.	Replace shaft collar or bushing
	3. Drive roller bent.	Replace drive roller
Brush motor or conveyor gear motor stalls.	1. Excessive depth of cut.	Reduce depth of cut; decrease brush speed; reduce feed rate.

Troubleshooting Guide: Conveyor

Problem	Possible Cause	Solution
Conveyor rollers run intermittently.	1. Shaft coupling loose.	Align shaft flats of gear motor and drive roller; tighten shaft coupling set screws.
Conveyor belt slips on drive roller.	1. Improper conveyor belt tension.	Adjust belt tension (page 8).
	2. Excessive depth of cut.	Reduce depth of cut; reduce feed rate.
Stock slips on conveyor belt.	1. Excessive depth of cut.	Reduce depth of cut.
	2. Tension rollers too high.	Lower tension rollers (page 9).
	3. Excessive feed rate.	Reduce feed rate.
	4. Dirty or worn conveyor belt.	Clean or replace conveyor belt.
Conveyor belt tracks to one side, or oscillates from side to side.	1. Belt out of adjustment.	Readjust belt; (page 8).
	2. Drive or driven conveyor belt rollers misaligned.	Readjust
	3. Conveyor table not flat and square.	Readjust by leveling machine
	4. Conveyor belt worn.	Replace conveyor belt (page 19).
	5. Drive roller worn or damaged.	Replace drive roller.
	6. Roller bushings elongated due to excessive wear.	Replace bushings.

Troubleshooting Guide: Machine

Problem	Possible Cause	Solution
Brush height adjustment works improperly.	1. Improper adjustment of height control.	Readjust height control
Knocking sound while running.	1. Bearing worn.	Replace bearing
Sniping of wood (gouging near end of board).	1. Inadequate support of stock.	Use roller stands to support stock.
	2. Conveyor drive or driven rollers higher than conveyor bed.	Readjust rollers
Burning of wood. or melting of finish	1. Feed rate too slow.	Increase feed rate.
	2. Excessive depth of cut	Reduce depth of cut, decrease brush RPM.
Gouging of wood.	1. Conveyor belt is too loose.	Adjust belt tension.
	2. Excessive depth of cut.	Reduce depth of cut, decrease brush RPM.
	3. Wood slipping on conveyor due to lack of contact.	Use alternate feeding procedure


RAD WIRE
BLACK WIRE
WHITE WIRE
GREEN WIRE
TO GEAR MOTOR
WHITE
BLACK
GM-
GM+
LOAD 1
BLACK
LOAD 2
BLACK
WHITE
BLACK
LINE 1
LINE 2
LINE IN
BLACK
WHITE
GREEN
GREEN
GROUND STUD
POWER IN
DRUM MOTOR
POWER OUTLET
PLUG
BLUE
BROWN
SWITCH
PLUG
GREEN
BLACK
WHITE
RED
BLACK
WHITE
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RPM
M0
M1
M2
M3
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GND
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GREEN
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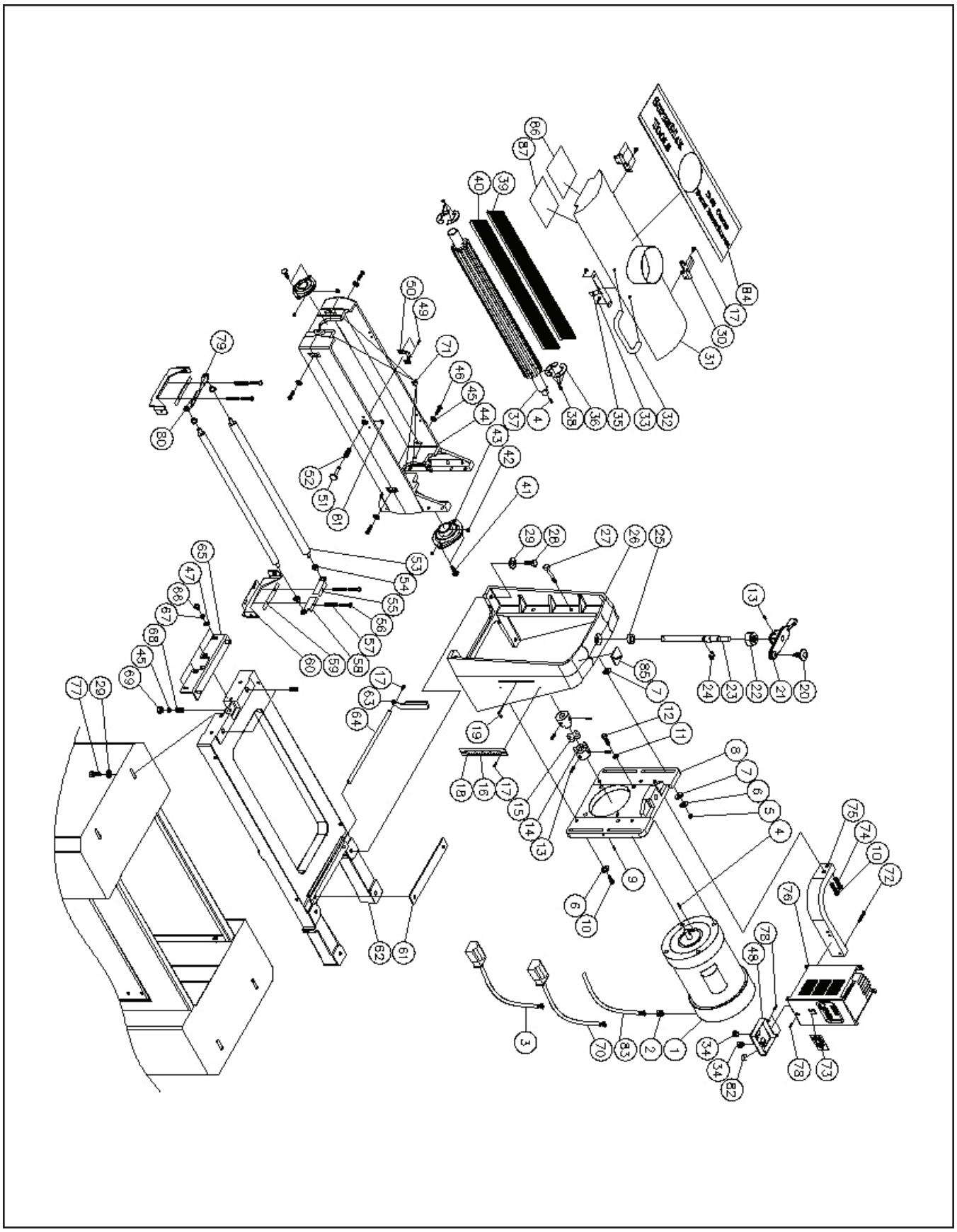
BLACK
WHITE

Part List: Drum Head Assembly

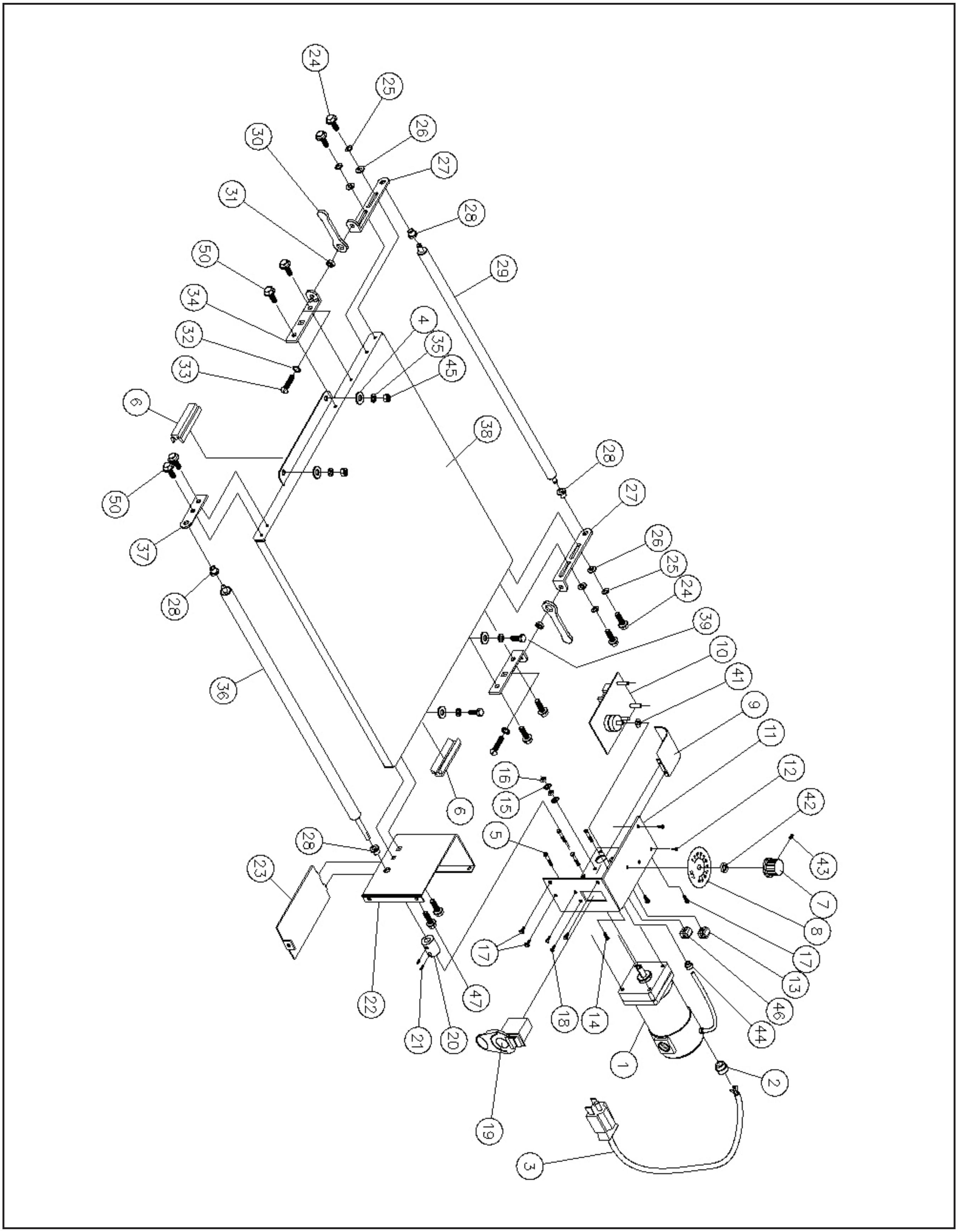
Index No.	Part No.	Description	Size	Qty.
1	480BS-101	Motor		1
	480BS-101MF	Motor Fan (not shown)		1
	480BS-101MFC	Motor Fan Cover (not shown)		1
	480BS-101JB	Junction Box (not shown)		1
	480BS-101JBC	Junction Box Cover (not shown)		1
2	480BS-102	Strain Relief, motor	7P-2	1
3	480BS-103	Main Cord, Inverter to Control Box		1
4	480BS-104	Key	3/16"SQx3/4"	2
5	480BS-105	Nylon Insert Lock Nut	5/16"-24UNF	4
6	480BS-106	Flat Washer	5/16"	9
7	480BS-107	Oilite Washer		8
8	480BS-108	Motor Slide Plate		1
9	480BS-109	Set Screw	#8-32x1/4"	1
10	480BS-110	Hex Cap Screw	5/16"-18x1-1/4"	6
11	480BS-111	Lock Washer	3/8"	4
12	480BS-112	Socket Head Cap Screw	3/8"-16x1-1/4"	4
13	480BS-113	Set Screw	1/4"-20x1/4"	5
14	480BS-114	Coupling		2
15	480BS-115	Coupling Spider		1
16	480BS-116	Height Plate, Depth Gauge		1
17	480BS-117	Screw	M4x0.7x6	11
18	480BS-118	Label, Depth Gauge (inch)		1
19	480BS-119	Depth Gauge Pointer		1
20	480BS-120	Knob		1
21	480BS-121	Height Adjustment Handle		1
22	480BS-122	Nylon Insert Lock Nut	5/8"-11	1
23	480BS-123	Height Adjustment Screw		1
24	480BS-124	E-Ring	E12	1
25	480BS-125	Thrust Bearing	51103	1
26	480BS-126	Shroud		1
27	480BS-127	Stud		4
28	480BS-128	Hex Cap Screw	3/8"-16x1-1/4"	4
29	480BS-129	Flat Washer	3/8"	8
30	480BS-130	Hinge		2
31	480BS-131	Dust Cover		1
32	480BS-132	Handle		1
33	480BS-133	Pan Head Machine Screw	#8x1/2"	2
34	480BS-134	Strain Relief, inverter	7N-2	2
35	480BS-135	Dust Cover Latch		1
36	480BS-136	End Cover		4
37	480BS-137	Flatter Head		1
38	480BS-138	Screw	M4x0.7x6	8
39	480BS-139	180 Grit Abrasive Strip	7mm Wide	6
40	480BS-140	180 Grit Arbasive Strip	4mm Wide	6
41	480BS-141	Carriage Bolt	M8x1.25x30	4
42	480BS-142	Set Screw	1/4"-28UNFx1/4"	4
43	480BS-143	Bearing Set		2
44	480BS-144	Drum Carriage		1
45	480BS-145	Flat Washer	1/4"	5
46	480BS-146	Round Socket Head Cap Screw	1/4"-20x1"	4
47	480BS-147	Flat Washer	5/16"	4
48	480BS-148	Junction Box		1

49	480BS-149	Hex Cap Screw w/ Washer	#10-24x3/8”	2
50	480BS-150	Dust Cover Catch		1
51	480BS-151	Stud		1
52	480BS-152	Spring		1
53	480BS-153	Tension Roller		2
54	480BS-154	Bushing, Oilite		4
55	480BS-155	Tension Roller Bracket, Inner Left		1
56	480BS-156	Screw	#8-32x1”	4
57	480BS-157	Spring, Tension Roller		4
58	480BS-158	Tension Roller Bracket, Inner Right		1
59	480BS-159	Pad, Bracket-Tension Roller		2
60	480BS-160	Bracket		2
61	480BS-161	Plate		1
62	480BS-162	Base		1
63	480BS-163	Adjusting Lever		1
64	480BS-164	Adjusting Rod		1
65	480BS-165	Height Adjusting Plate		1
66	480BS-166	Round Socket Head Cap Screw	5/16”-18x1/2”	4
67	480BS-167	Lock Washer	5/16”	4
68	480BS-168	Spring		3
69	480BS-169	Nylon Insert Lock Nut	1/4”-20	1
70	480BS-170	Signal Cord, Interver to Control Box		1
71	480BS-171	Hex Nut w/ Washer	M8x1.25	4
72	480BS-172	Hex Cap Screw	M5x30	2
73	480BS-173	RPM Speed Label		1
74	480BS-174	Hex Cap Screw	5/16”-18x1-1/2”	1
75	480BS-175	Mounting Bracket		1
76	480BS-176	Inverter		1
77	480BS-177	Hex Cap Screw		1
78	480BS-178	Screw	M3x10	3
79	480BS-179	Tension Roller Bracket, Outer Right		1
80	480BS-180	Tension Roller Bracket, Outer Left		1
81	480BS-181	E-Ring	E5	1
82	480BS-182	Strain Relief, Signal Cord	HP-19	1
83	480BS-183	Motor Cord, Motor to Inverter		1
84	480BS-184	Label		1
85	480BS-185	Height Direction Label		1
86	480BS-186	Maintenance Label		1
87	480BS-187	Warning Label		1



Part List: Conveyor and Motor Assembly

Index No.	Part No.	Description	Size	Qty.
1	480BS-201	Gear Motor	90 VDC	1
2	480BS-202	Strain Relief, Power Cord	6P3-4	1
3	480BS-203	Power Cord		1
4	480BS-147	Flat Washer	5/16"	4
5	480BS-205	Socket Head Cap Screw	#10-32x1/2"	4
6	480BS-206	Tracker Kit (optional)		2
7	480BS-207	Knob		1
8	480BS-208	Speed Adjustment Label		1
9	480BS-209	Wiring Guard		1
10	480BS-210	Controller		1
11	480BS-211	Control Housing Bracket		1
12	480BS-212	Pan Head Self-Tapping Screw	5/32"x1/2"	2
13	480BS-213	Receptacle, Main Cord		1
14	480BS-214	Pan Head Machine Screw	#10-32x1/2"	1
15	480BS-215	Washer, Lock-Int. Tooth	#10	2
16	480BS-216	Hex Nut	#10-32	2
17	480BS-217	Screw, Hex Head-Slotted	#10-32x3/8"	5
18	480BS-218	Screw, Phil Pan Head	#6-32x1/2"	2
19	480BS-219	Switch, ON/OFF		1
20	480BS-220	Coupler, Shaft		1
21	480BS-113	Set Screw	1/4-20x1/4"	2
22	480BS-222	Bracket, Base- Controller		1
23	480BS-223	Cover, Base-Control Housing		1
24	480BS-224	Hex Cap Screw	1/4"-20x3/4"	4
25	480BS-225	Washer, Wave	1/4"	4
26	480BS-145	Flat Washer	1/4"	4
27	480BS-227	Bracket, Take Up-Slide		2
28	480BS-154	Bushing, Oilite.		4
29	480BS-229	Roller, Driven		1
30	480BS-230	Wrench		2
31	480BS-231	Hex Nut	1/4"-20	2
32	480BS-232	Washer, Lock-Int. Tooth	1/4"	2
33	480BS-233	Screw, Round Head- Slotted	1/4"-20x1-3/4"	2
34	480BS-234	Bracket, Take Up-Base		2
35	480BS-167	Lock Washer	5/16"	4
36	480BS-236	Roller, Drive		1
37	480BS-237	Bracket, Support-Drive Roller		1
38	480BS-238	Bed, Conveyor		1
39	480BS-239	Hex Cap Screw	5/16"-18x3/4"	2
40	480BS-240	Belt Conveyor, Rubber (Not Shown)		1
41	480BS-241	Flat Washer		1
42	480BS-242	Hex Nut	5/16"-24	1
43	480BS-243	Slotted Set Screw	#8-36UNFx5/16"	1
44	480BS-244	Strain Relief, Gear Motor	6N-4	1
45	480BS-245	Hex Nut	5/16"-18	2
46	480BS-246	Receptacle, Signal Cord		1
47	480BS-247	Hex Cap Screw	1/4-20x1/2"	8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19-38 Combo Specifications

Warranty: Two years on parts and labor, limited;
Manufacturer's warranties on conveyor belts, brush heads and abrasives.

Sanding Capacity:	
Maximum Width:	38" (two passes)
Minimum Length:	2-1/4" to 3-1/2" (varies with application)
Maximum Thickness:	4" typical (varies with brush/drum style & application)
Minimum Thickness:	1/32" typical (varies with applications)
Dimensions:	Length – 36" Width – 42" Height – 24" without stand
Brush:	5" diameter typical Typical bristle length: 1-1/2" (varies)
Brush Speed:	Infinitely variable 200 to 1000 RPM Brush 1750 RPM Drum
Dust Hood:	Hinged back with 4" vacuum port
Height Adjustment:	1/16" per revolution, Depth Gauge included
Conveyor Motor:	43"–lb. torque Direct drive D.C. motor Infinitely variable 0–10 feet-per-minute
Drive Motor (TEFC):	1-3/4 HP Continuous-duty
Power Requirements:	110 Volt, Single Phase 20 amp service
Shipping Weight:	242lbs. (*weight varies on how equipped*) 2 boxes

2 YEAR WARRANTY

Limited warranty. We will provide all replacement parts which are found to be defective in materials or workmanship. Manufacturers' warranties on conveyor belts and brush heads.

Brushes & Supply Checklist

SuperBrush Options:

Description	Qty.
80–320 grit flatter abrasives	
Nylon impregnated brush configurations in various grits	
Wire brush configurations	

Please contact SuperMax Tools for a complete listing of brushes and brush material available

Accessories:

Item #	Description	Qty.
71938-1	Sanding Drum	
71938-CL	Closed Stand, includes locking wheels	
71938-OP	Open Stand	
98-08130	Caster Set: Heavy duty, roll & swivel lock (used with open stand).	
71938-7	Infeed/Outfeed Tables	
71938-DRO	DRO (digital read out) depth gauge	

Conveyor Belts:

Item #	Description	Qty.
60-0322	Type 1: 100 grit abrasive surface with reinforced backing	
61-1003	Type 2: Polyurethane textured surface with monofilament backing	

Drum Abrasives:

Item #	Description	Qty.
60-19-036	36 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-060	60 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-080	80 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-100	100 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-120	120 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-150	150 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-180	180 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	
60-19-220	220 Grit: SuperMax 19-38 Combo - 3-Wraps in Box	

For information on the SuperBrush and supplies
call SuperMax Tools (888) 454-3401 or visit www.supermaxtools.com.

Caution:
Important Safety Information

Keep This Manual Handy For Quick Reference

For Safe Sanding Operation, Follow These Guidelines:

- BECOME FAMILIAR WITH THE PROPER OPERATIONAL PROCEDURES FOR USING THIS MACHINE.
- ALWAYS BE SAFETY CONSCIOUS WHEN OPERATING THE MACHINE.
- ALWAYS WEAR EYE PROTECTION WHILE OPERATING THE SANDER.
- ALWAYS FEED STOCK AGAINST THE ROTATION OF THE BRUSH OR DRUM
- NEVER PLACE HANDS UNDER THE BRUSH, DRUM OR DUST COVER.
- NEVER OPERATE WITHOUT ITS DUST COVER OR GUARDS IN PLACE.
- KEEP HANDS AND CLOTHING AWAY FROM OPERATING BRUSH DRUM AND COUPLER.
- ALWAYS MAINTAIN CONTROL OF STOCK TO AVOID KICKBACK; KNOW HOW TO PREVENT IT.
- ALWAYS DISCONNECT ELECTRICAL POWER BEFORE PERFORMING ANY SERVICING OR ADJUSTMENT OF THE MACHINE.
- DO NOT MODIFY THIS MACHINE: MODIFICATIONS ARE DONE AT THE OWNER'S RISK AND ALSO WILL VOID THE MANUFACTURER'S WARRANTY.
- FOR CUSTOMER SERVICE AND QUESTIONS ABOUT THE OPERATION OR MAINTENANCE OF THIS MACHINE, PLEASE CALL YOUR AUTHORIZED SUPERMAX DEALER.
- IMPORTANT: BEFORE OPERATING YOUR SUPERBRUSH READ THE INSTRUCTIONS IN THIS MANUAL FOR UNPACKING AND SETTING UP YOUR MACHINE.

PART NO. 92-1938

PRINTED IN USA

Installing Heads

WARNING! Unplug machine from power prior to proceeding!
NOTICE! Make sure to follow instructions about set screws and cotter pins. Failures to remove a set screw or cotter pin can damage the machine.
NOTICE! USE EXTREME CAUTION TO NOT DROP THE ALUMINUM DRUM OR BRUSH HEAD DURING THIS PROCESS. Allays place in secure location when not installed.
NOTICE! Never store brush heads on the brushing, stand the brush-head up in a vertical positions to prevent flat spots.

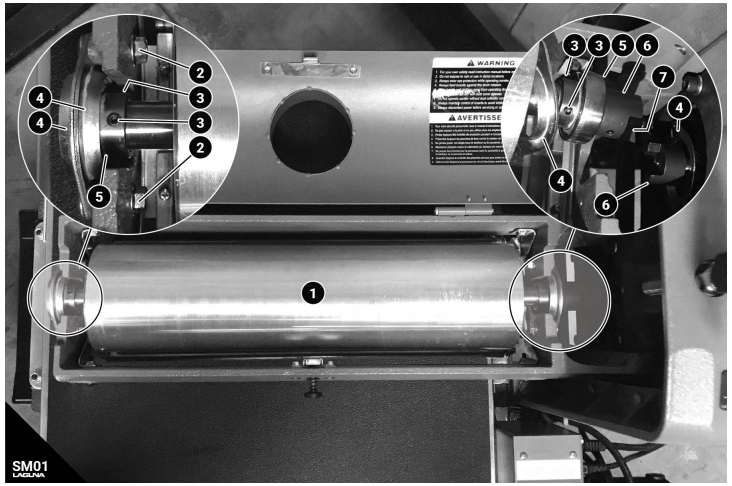
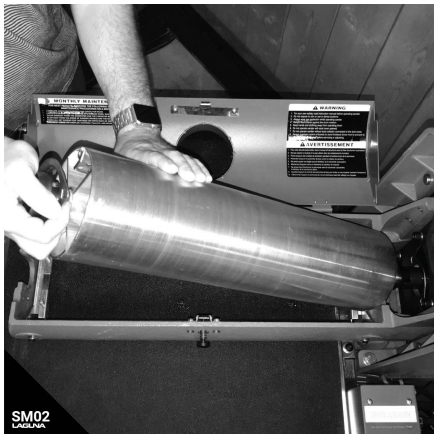


Fig SM01: Drum Head Assembly Installation/Removal. (1) Drum Head. **(2)** Mounting Bolts/Nuts. **(3)** Bearing to Shaft Set Screws. **(4)** Bearing Seat. **(5)** Bearing. **(6)** Coupling. **(7)** Spider.

The drum can be interchanged between the different heads offered for the 19|38 combination machine. Although a cumbersome process to the uninformed, the drums interchange easily by removing the bolts and seating the spider coupling properly. Please take the time to learn these instructions prior to attempting a head change.
NOTICE! Pay particular attention to the set screws and the removed drum or head. Make sure to release set screws prior to removal and to tighten them only when instructed to. Make sure to place the removed drum head in a location where it can not fall - it will loose a fight against a concrete floor every time.
NOTICE! This help section is only intended for the 19|38 combination drum/brush sanding machine (SKU: SUPMX-71938). The standard 19|38 (SKU: SUPMX-71938-D) is only compatible with the sanding drum head included with purchase.

Removing (Head)
Tools Needed: Size 14MM Wrench. Allen Wrenches
1. Make sure Sander is disconnected form power and cannot be turned on.
2. Use 14mm wrench to remove the four (2) mounting bolts/nuts from the left and right side. **SEE STEP 3 PRIOR TO REMOVAL.**
3. Remove all four (3) Bearing to Shaft Set Screws with an allen wrench. The four (4) Bearing seats should now be loose enough to remove the drum head.
4. Remove the (1) Drum head assembly by tilting the drum head upright from the left side. Pull the drum head away carefully not to bump metal parts.

Installing (Head)
Tools Needed: Size 14MM Wrench. Allen Wrenches. WD40 or other Lubricant



1. Make sure machine is disconnected from power and cannot be turned on.
2. Check the (6) coupling that is connected to the motor shaft. The motor shaft should be flush with the inner face of the coupling. If not, adjust it by loosening the (not shown) two set screws on the coupling, position it flush, and tighten the set screws back in place.
3. Check the (6) coupling that is connected to the drum/brush shaft. The drum/brush shaft should be flush with the inner face of the coupling. If not, adjust it by loosening the (not shown) two set screws on the coupling, position it flush, and tighten the set screws back in place.
4. Remove all four (3) Bearing to Shaft Set Screws with an allen wrench. **DO NOT** remove the set screws on the coupling unless they need to be adjusted (preceding steps). This will allow the bearings to move left to right on the shaft, giving clearance to position the (6) couplings and (7) rubber spider together.
5. **IMPORTANT.** Place one if the (4) bearing seats behind the motor shaft coupling and motor shaft as shown in figure SM01. Make sure each bearing seat is installed after each bearing on the shaft.
6. Reference the top right of figure SM01. Place the (7) spider in the drum/brush coupling.
7. With the couplings position as shown in figure SM01, install the drum head by tilting the left side and aligning the couplings such that the brush/drum couplings sits inside the motor shaft coupling. **NOTICE: WD40 can prevent damage to the rubber spider and make the installation easier.**
8. Use moderate force as shown in figure SM02 to seat the coupling s together. Lower the (1) drum head into the left casting slot.
9. Now that the spider coupling is in place, set the position by fastening the four (2) mounting bolts/nuts with a 14mm wrench. The order is: bolt, bearing seat, bearing, bearing seat, cast iron, nut - as shown in figure SM01. **NOTICE:** Make sure the four (3) bearing to shaft set screws are removed while fastening the four (2) mounting bolts/nuts. The mounting bolts will position the shaft correctly as long as steps 1 and 2 were performed.
10. Tighten down the four (3) bearing to shaft set screws.

SuperMax Tools

19–38 COMBINATION SANDER

MACHINE OVERVIEW

The 19-38 Combination Sander comes standard as a bench-top unit with a 180 grit flatter brush head. Additional brush heads, sanding drum, stands and other accessories are available for purchase.

Flatter brush: Produces a hand sanded finish on profiles like mouldings, raised panel doors, and plywood.

Nylon brush: Scuff sand and defuzz stock and clean reclaimed wood.

Wire brush: Pull the soft grain out from soft woods to create a distressed finish.

Sanding drum: Dimension or finish sand flat stock.

- **Simple alignment feature**
  Just one nut adjusts the conveyor to parallel the sanding head.
- **Easy height adjustments**
  No backlash or slop allowing easier and smoother height adjustments.
- **Extra-wide conveyor**
  The conveyor table is 22” to properly support wide stock.
- **Sanding brush and drum will never go “out of alignment”**
  Sanding head carriage is bolted to the base, preventing any movement or alignment issue.
- Excellent dust extraction, as metal dust cover is formed to shape of drum.
- Tension rollers are adjustable in height and hold down pressure, eliminating snipe.
- Heavy-duty cast iron construction for strength, rigidity and reduced vibration.

Shown on optional closed stand and with optional brush head accessories

2 YEAR WARRANTY

Maximum sanding width	38” (two passes)
Minimum sanding length	5-1/2”
Maximum sanding thickness	4”
Minimum sanding thickness	1/32”
Dimensions	24” D x 40” W x 24” H
Brush speed	AC inverter, infinitely variable, 200-1000 RPM
Drum	5” x 19” extruded aluminum
Drum speed	1740 RPM
Dust hood	1 x 4”, vacuum port (min. 600 CFM recommended)
Conveyor motor	43 in.-lb. torque, direct drive D.C. motor, infinitely variable 0-10 FPM
Drive motor (TECH)	1-3/4 HP
Power requirements	110V, 15 Amp, 20 Amp service
Shipping weight	242 lbs (2 boxes) bench-top unit only

PROFILE SAND, SURFACE SAND, AND BRUSH SAND

The 19-38 combination sander is the most versatile multi-purpose lighter-duty sander on the market today! Interchangeable drum and brush heads allows for unlimited applications. A true one-of-a-kind machine for the serious hobbyist.

- INTELLISAND™ Technology: Automatically adjusts conveyor speed based on load
  - Prevents gouging, damaging or burning stock
  - Provides consistent finish even with varying grain pattern and density
  - Greatly increases abrasive planing and dimensioning speed.
- Indexed alignment setting for narrow and wide stock. When sanding stock wider than 19", the index lever will properly adjust the conveyor for flawless wide sanding.
- Flatness Guarantee: Precision-flattened steel conveyor bed reinforced with four steel cross sections for no "flex" in conveyor, guaranteeing flatness to less than .010 across the width of the sander.
- Patented abrasive attachment system effectively tensions the abrasive wraps, preventing loosening and overlapping.
- Easiest access to abrasive fastening system of any drum sander. Extra wide space to access fasteners to eliminate need for special tools.
- Self-cooling sanding drum prevents overheating and extends abrasive life.

Easy height adjustments with a thrust bearing below the handle. No backlash or slop in the height adjustment mechanism allowing easier and smoother height adjustments.

Convenient access to coupler and fasteners to allow for quick and easy changes of various brushes or sanding drum.

Electronic Variable Speed control box for adjusting brush RPM for endless finish possibilities.

Simple alignment feature makes adjustment quick and easy.

Fast Lever makes it easy to change alignment settings for narrow and wide stock.

#71938

19-38
COMBINATION SANDER

OPTIONAL ACCESSORIES

#71938-1

Sanding drum

#71938-3

Nylon brush head

#71938-2

Wire brush head

#62-2XXX

Replacement Flatter Strips (12 ct.) - specify grit 60-320 available

#98-0130

Casters, set of 4

#59120

Abrasive cleaning stick

#71938-OP

Open stand with shelf

#71938-CL

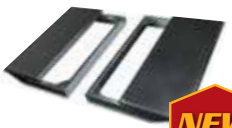
Closed stand with built-in casters

#71938-DRO

Digital depth gauge (.000 increments)

#71938-7F
For use with open stand

#71938-7F-CL
For use with closed stand



Folding infeed/outfeed tables

NEW

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