

DDB12|6 DRUM SANDER MANUAL



LAGUNA

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TABLE OF CONTENTS

TABLE OF CONTENTS	1
GENERAL SAFETY RULES FOR WOODWORKING MACHINERY	2
GROUNDING INSTRUCTIONS.....	4
ADDITIONAL SAFETY RULES FOR VERTICAL SPINDLE SANDER.....	6
UNPACKING AND CLEANING THE MACHINE	6
MACHINE FEATURES.....	6
SPECIFICATIONS	9
CONNECTING DUST COLLECTION SYSTEM	9
POWER SWITCH ON/OFF	10
SETTING THE BELT SANDER IN A HORIZONTAL POSITION.....	12
SETTING THE BELT SANDER IN A VERTICAL POSITION.....	12
REMOVING THE SANDING BELT.....	13
MOUNTING A NEW SANDING BELT.....	13
BELT TRACKING ADJUSTMENT	14
STOP FENCE	14
ATTACHING DISC SANDING PAPER.....	15
MAINTENANCE	15
TROUBLESHOOTING	16
PARTS LIST.....	17

GENERAL SAFETY RULES FOR WOODWORKING

MACHINERY

WARNING: Do not attempt to operate the machine until you have read thoroughly and have understood completely all instructions, rules and condition contained in this manual. Failure to comply can result in accidents involving fire, electric shock, or serious personal injury. Keep this owner's manual and refer to it frequently for continuous safe operation.

1. Know your machine. For your own safety, read the owner's manual carefully. Learn its application and limitations, as well as specific potential hazards pertinent to this machine.
2. Make sure all tools are properly grounded. If the tool electrical plug has three prongs, it should be used in a three hole electrical socket. If a three prong or two prong adapters is used, the adapter plug must be properly grounded. Do not remove or disable the third prong.
3. Keep guards in place and in good working order. If a guard must be removed for maintenance or cleaning, make sure it is properly reattached before using the machine again.
4. Remove adjusting keys and wrenches. Form a habit of checking to see that the keys and adjusting wrenches are removed from the machine before turning it on.
5. Keep your work area clean. Cluttered areas and workbenches increase the chance of an accident.
6. Do not use in dangerous environments. Do not use power tools in damp or wet locations or expose them to rain. Keep work areas well illuminated.
7. Keep children away. All visitors should be kept a safe distance from the work area.
8. Make the workshop childproof. Use padlocks, master switches and remove starter keys.
9. Do not force the machine. It will do the job better and be safer at the operating rate for which it is designed.
10. Use the right tools. Do not force the machine or attachments to do a job for which they are not designed. Contact the manufacturer or distributor if there is any question about the machine's suitability for a particular job.

11. Wear proper apparel. Avoid loose clothing, gloves, neckties, bracelets, and jewelry, which could get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
12. Always use safety glasses. Also, wear a face or dust mask if the operation area is dusty. Everyday eyeglasses only have impact resistant lenses. They are not safety glasses.
13. Do not over-reach. Keep proper footing and balance at all times.
14. Maintain machine in top condition. Keep machine clean for safety and best performance. Follow instructions for lubrication and changing accessories.
15. Disconnect the machine from the power source before servicing, when changing accessories and when mounting or remounting motor.
16. To avoid accidental starting, make sure the switch is in the OFF position before plugging in the power cord.
17. Never leave the machine running unattended. Turn the power off. Do not leave the machine until it comes to a complete stop.
18. Do not use any power tools while under the effects of drugs, alcohol or any medication.
19. Always wear a face or dust mask if operation creates a lot of sawdust and/or chips. Always operate the tools in a well-ventilated area and provide for proper dust removal. Use a dust-collection system whenever possible.
20. SECURE WORK. Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
21. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
22. USE RECOMMENDED ACCESSORIES. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
23. NEVER STAND ON TOOL. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
24. CHECK DAMAGED PARTS. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function-check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or

replaced.

25. USE PROPER EXTENSION CORD. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table 1 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.

Table
Minimum gage for cord^a

Ampere Rating	Voits		Total length of cord in feet			
	120 V	240 V	25 ft.	50 ft.	100 ft.	150 ft.
More Than	Not More Than		AWG			
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not	Recommended

^a Only the applicable parts of the Table need to be included. For instance, a 120-volt product need not include the 240-volt heading.

GROUNDING INSTRUCTIONS

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided - if it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

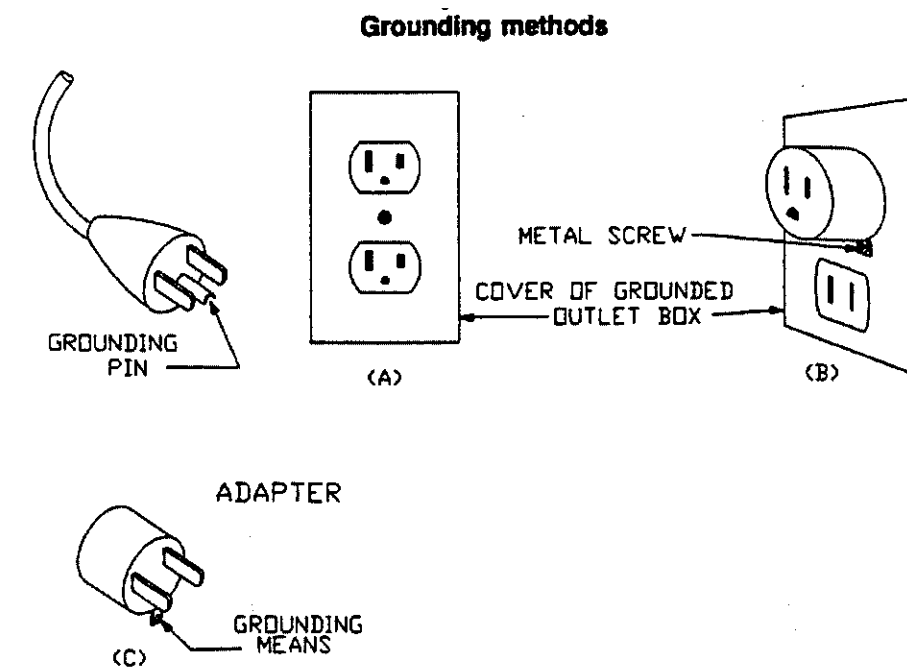
Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly

grounded.

Use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet that looks like the one illustrated in Sketch A. The tool has a grounding plug that looks like the plug illustrated in Sketch A. A temporary adapter, which looks like the adapter illustrated in Sketches B and C, may be used to connect this plug to a 2-pole receptacle as shown in Sketch B if a properly grounded outlet is not available. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician. **(This adapter is not permitted in Canada)** The green-colored rigid ear, lug, and the like, extending from the adapter must be connected to a permanent ground such as a properly grounded outlet box.



ADDITIONAL SAFETY RULES FOR VERTICAL SPINDLE SANDER

1. WARNING: FOR YOUR OWN SAFETY READ INSTRUCTION MANUAL BEFORE OPERATING SANDER. WEAR EYE PROTECTION.
2. SUPPORT WORK PIECE WITH MITER GAGE, BACKSTOP, OR WORKTABLE. MAINTAIN 1/16 INCH MAXIMUM CLEARANCE BETWEEN TABLE AND SANDING BELT OR DISC.
3. AVOID KICKBACK BY SANDING IN ACCORDANCE WITH THE DIRECTIONAL ARROWS.

UNPACKING AND CLEANING THE MACHINE

1. The machine is shipped in one carton.
2. Unpack the machine carefully.
3. Ensure that loose parts are present as listed in the manual. If any items are missing or damaged, please contact your local dealer immediately.
4. Remove the rust preventative oil thoroughly. Use a soft cloth moistened with kerosene to remove the oil.



WARNING: Do not use gasoline or lacquer thinner to remove the rust preventative oil, as these can damage the painted surface

MACHINE FEATURES

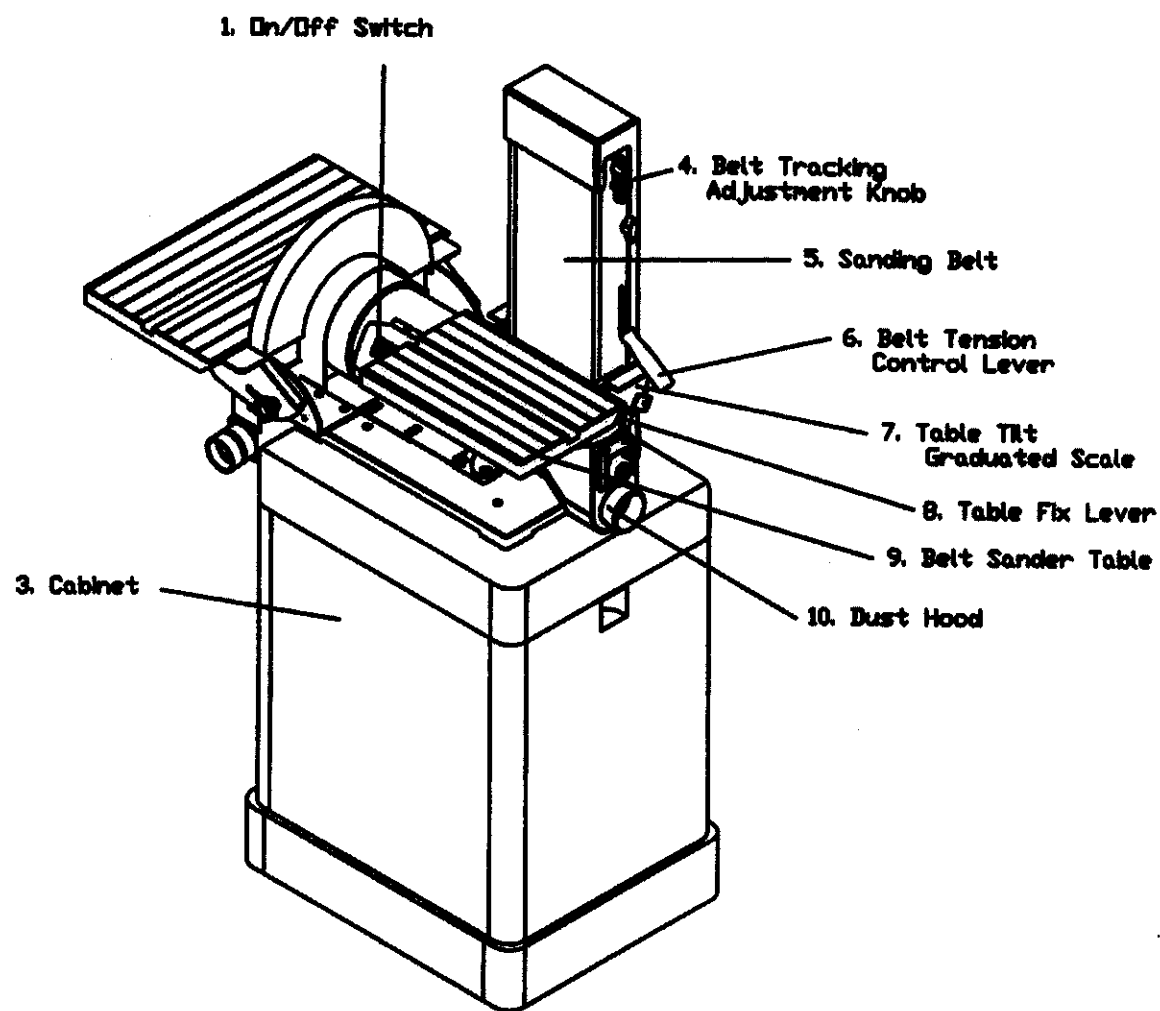
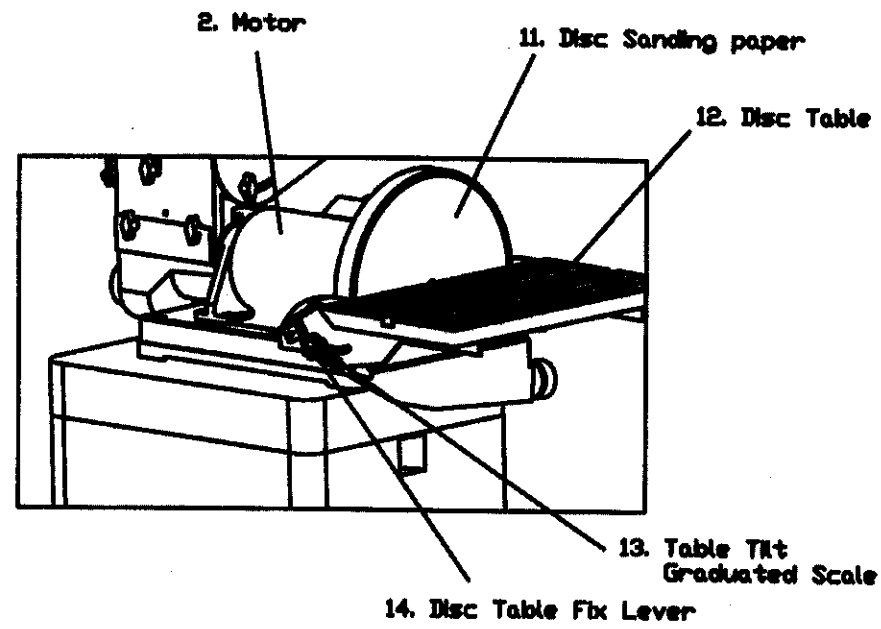
1. The oscillating sanding provides an extremely fine sanding finish.
2. Easily interchangeable spindle.

3. Two tables are both Rota table.

4. Standard accessories can be stored at the side of the machine.

5. Air ventilation in rear of machine.

MACHINE LEGEND



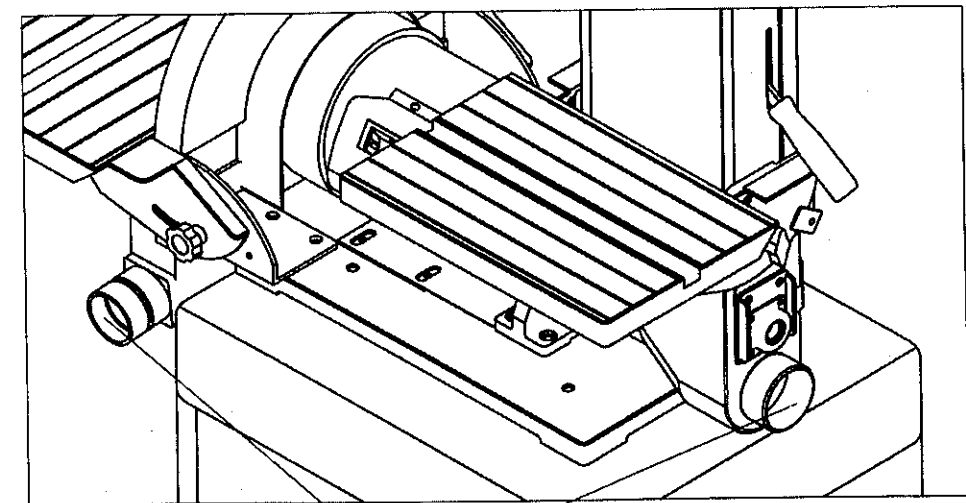
SPECIFICATIONS

Model	DB-1248
12" Table Size	450mm×254mm(17-11/16"×10")
6"×48" Table Size	250mm×203mm
Belt Diameter	6"×48"
Disc Diameter	12"
Motor Speed	60Hz 1720rpm 50Hz 1420rpm
Motor	1 1/2HP
Weight	Net: 74kgs
Cuft	18.6

CONNECTING DUST COLLECTION SYSTEM

There is dust hoods provided for the spindle drum sander and the belt sander, that which should be connected to a dust collector. The dust hoods are located under the tables.

Dust hood outlets are 2" diameter. Use a 2" diameter air hose to connect both dust hoods to a dust collector.



2" Dust Hood

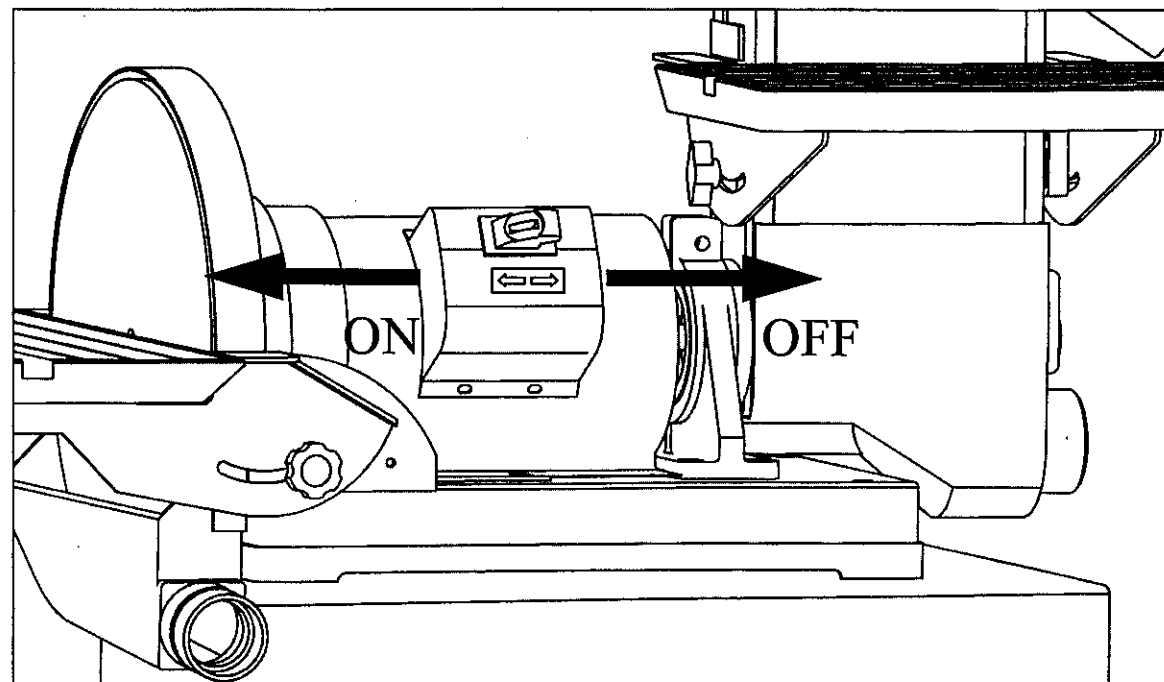
POWER SWITCH ON/OFF

The sander is equipped with a rocker-type power switch to start and stop the sander running. It is located on the junction box of the motor. The switch has a removable locking key to prevent unauthorized operations. If the sander is not in use for a long time, remove the locking key by pulling it out. It should then be stored in a safe place.

To start the sander running, insert the locking key and shift the switch to the left. To stop the sander, shift the switch to the right as shown below.

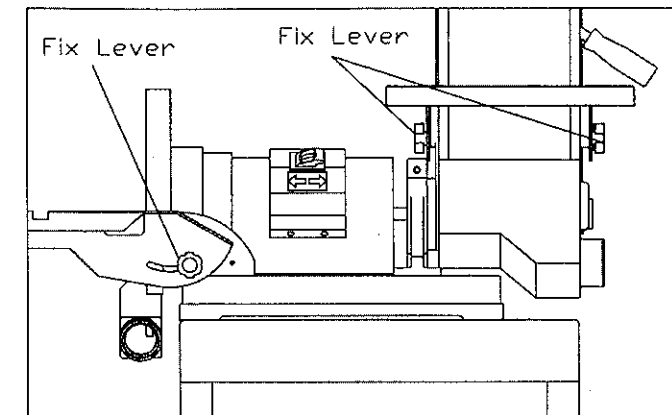


WARNING: Make sure the power switch is in the OFF position before connecting the sander to the power source.



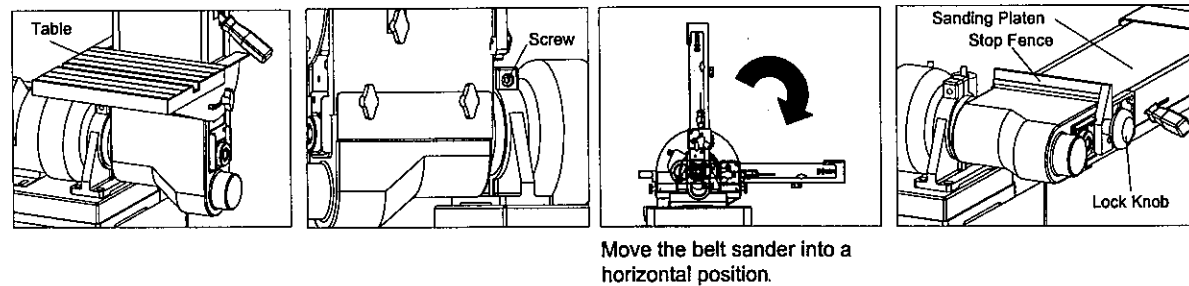
TILTING THE DRUM SANDER TABLE

The drum sander table can be tilted front downward from 0° to 45°. Loosen the two table fix levers located under the right and left sides of the table before tilting the table. Tighten both fix levers securely after the table has been tilted. A graduated scale is attached for indicating the tilting degree of the table.



SETTING THE BELT SANDER IN A HORIZONTAL POSITION

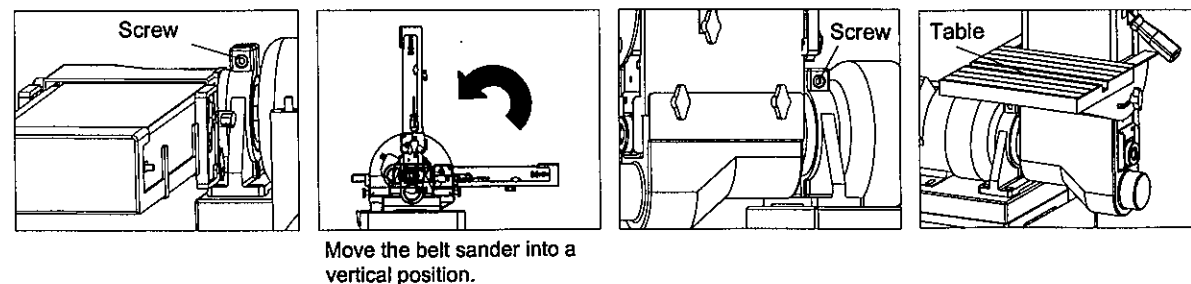
1. Loosen the screw that tightens the motor shaft bracket using a 6 mm. hexagonal wrench.
2. Remove the belt sander table.
3. Manually move the belt sander into a horizontal position.
4. Tighten the screw securely after the belt sander has been positioned horizontally.
5. Always remember to mount the stop fence when performing flat surface sanding.



SETTING THE BELT SANDER IN A VERTICAL

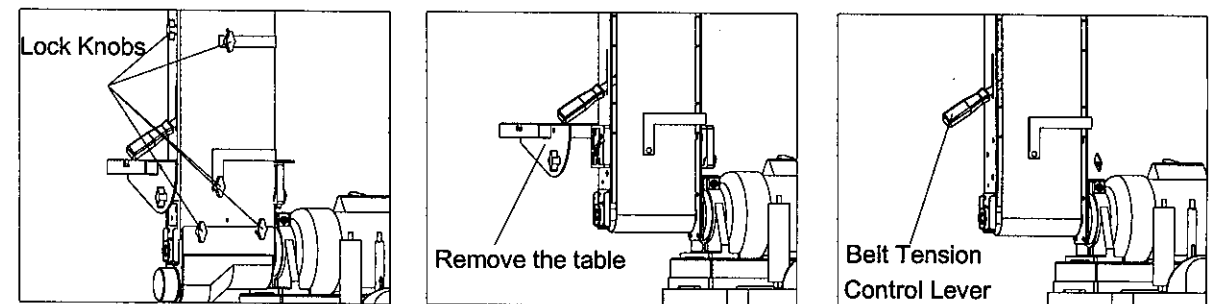
POSITION

1. Loosen the screw that tightens the motor shaft bracket using a 6 mm. hexagonal wrench.
2. Manually, move the belt sander into a vertical position.
3. Tighten the screw securely after the belt sander has been positioned vertically.
4. Mount the table.



REMOVING THE SANDING BELT

1. Disconnect the sander from the power source.
2. Loosen the 5 lock knobs that tighten the belt guard and then remove it.
3. Remove the belt sander table. Loosen the 2 lock screws located under the table before removing it.
4. Loosen and remove the table tilt graduated scale using a 5 mm. hexagonal wrench.
5. Loosen the belt tension by shifting the belt tension control lever upward.
6. The old sanding belt may now be removed from the right side



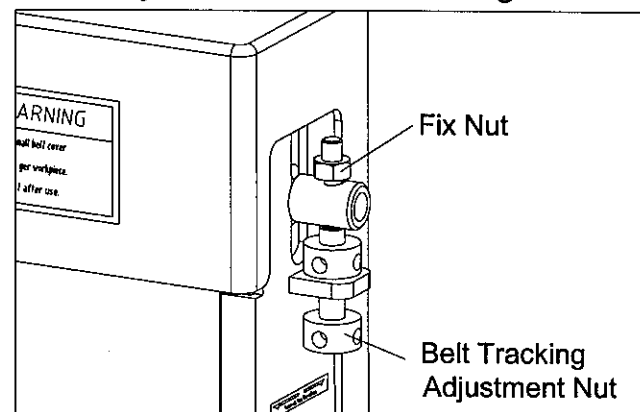
MOUNTING A NEW SANDING BELT

1. Disconnect the sander from the power source.
2. After the old belt has been removed, it is possible to fit a new one.
3. Fit a new sanding belt in the same place. Make sure the arrowheads marked on the back of the sanding belt point to the direction indicator attached on the belt guard.
4. The new sanding belt should be located in the center position of both the rollers.
5. Tighten belt tension by shifting the belt tension control lever downwards.
6. After the new belt has been mounted, reverse the above procedure to return the sander to its original condition.

7. It is necessary to make belt tracking adjustments. For details, refer to 'Belt Tracking Adjustment' on page 13 of this manual.

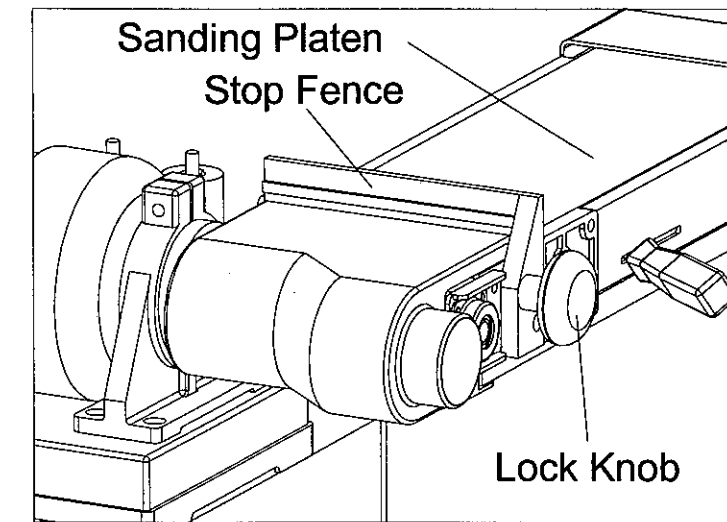
BELT TRACKING ADJUSTMENT

1. Disconnect the sander from the power source.
2. Manually rotate the sanding belt. At this time, check to see if the sanding belt runs in the center position of the rollers.
3. If the sanding belt runs out of proper tracking, make adjustments by turning the belt tracking adjustment knob using the supplied screwdriver.
4. Turn the knob in a counter-clockwise direction to move the belt forward. Turn it in a clockwise direction to move the belt backwards.
5. Loosen the fix nut before turning the belt tension adjustment knob. Tighten the nut securely after the belt tracking has been adjusted.



STOP FENCE

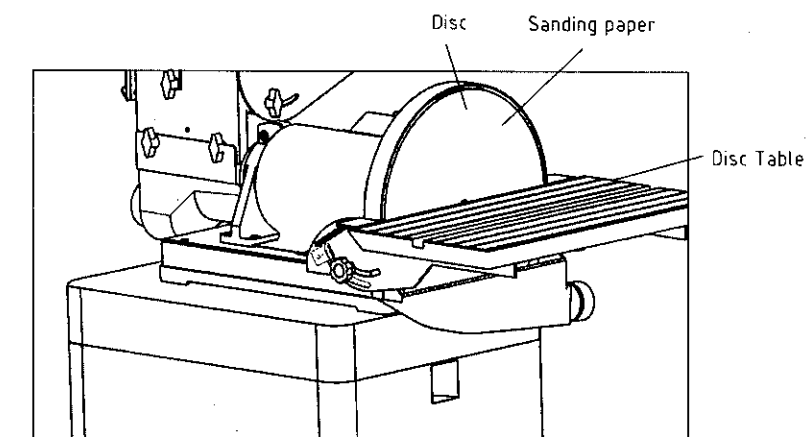
When the sanding platen is set for horizontal sanding, the stop fence should be used to prevent workpieces flying out during sanding. Mount the stop fence by fastening the two lock knobs on the edge of the sanding platen.



ATTACHING DISC SANDING PAPER

1. Dismantle the disc table.

Remove the old sanding paper from the disc. The disc features a self-adhesive function, so that the sanding paper can easily be attached to the disc.



MAINTENANCE

1. Everyday, after work is done, remove dust from the machine and clean it.
2. Everyday, after work is done, turn off the power switch and remove the switch key.
3. A build-up of dust in the motor can cause motor damage. Periodic cleaning of the motor is not only recommended, but also mandatory for normal sander performance.
4. Keep the machine and attachments clean.
5. Protect the spindle sleeves from nicks. Clean tapered sleeves and

- tapered socket before use.
6. Check for spindle straightness.
 7. All bearings are permanently lubricated and require no further lubrication.

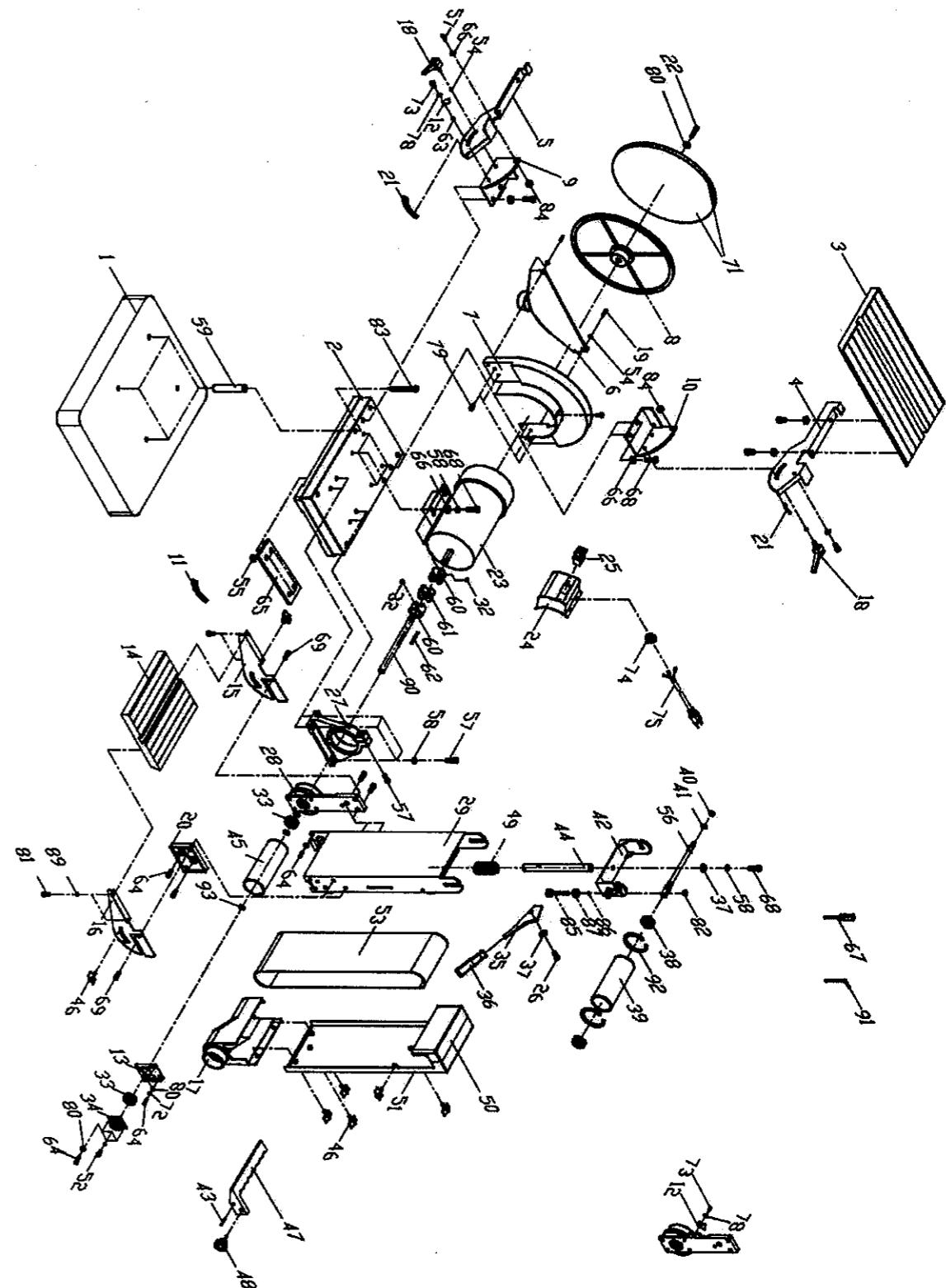


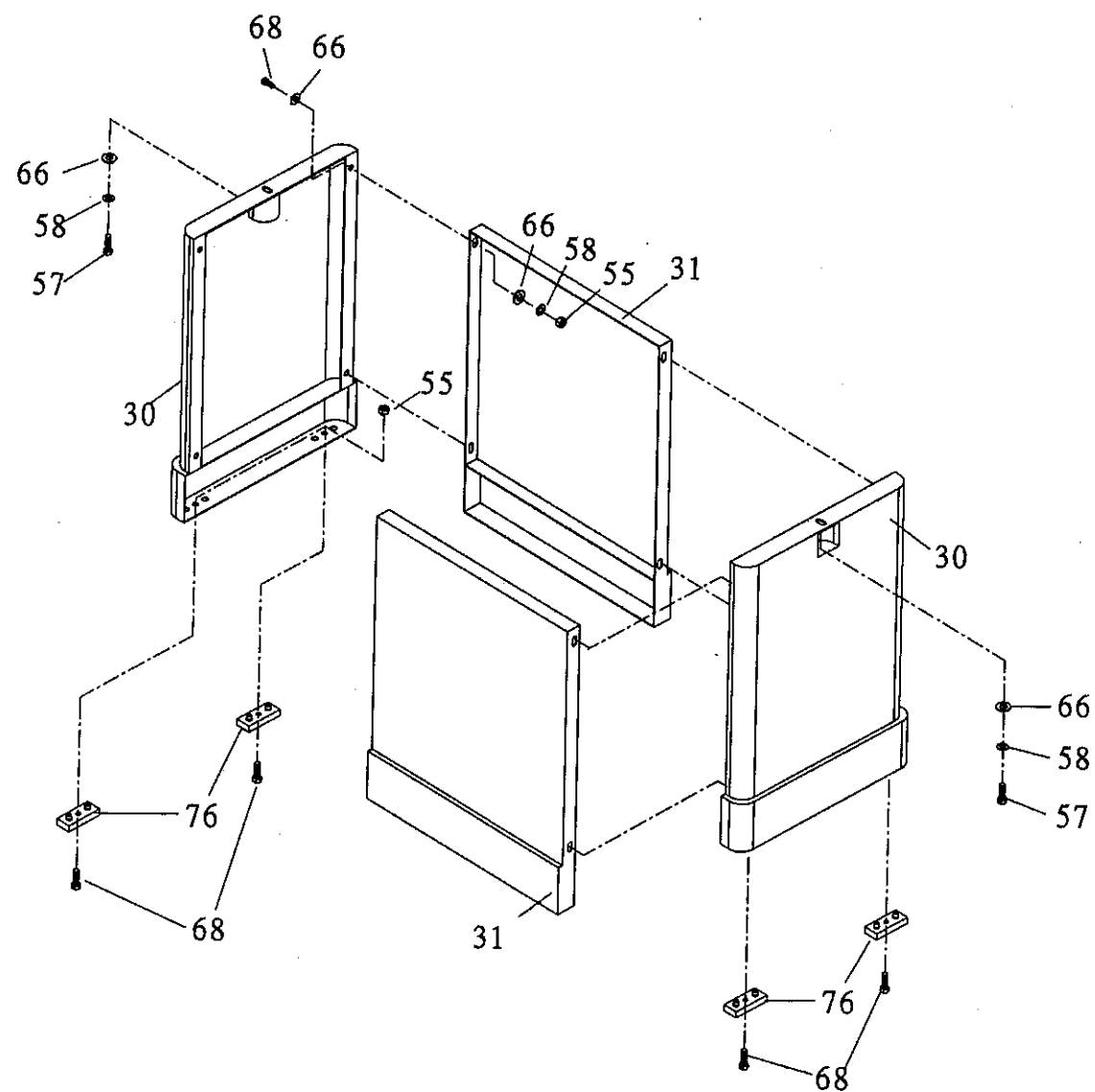
WARNING: Always disconnect the sander from the power source before commencing any maintenance.

TROUBLESHOOTING

TROUBLE	CAUSES	CORRECTION
Motor does not run when power switch is turned "ON".	<ol style="list-style-type: none"> 1. Switch is burned out. 2. Connection wire is loose or damaged. 	<ol style="list-style-type: none"> 1. Replace the switch. 2. Tighten or replace the wire.
Motor does not run at full speed.	<ol style="list-style-type: none"> 1. Power voltage is too low. 2. Motor is damaged. 	<ol style="list-style-type: none"> 1. Test voltage. 2. Check and repair motor.
Motor does not reach full power.	<ol style="list-style-type: none"> 1. Incorrect power wiring. 2. Overload. 	<ol style="list-style-type: none"> 1. Replace with the correct size power wiring. 2. Reduce sanding load.
Motor overheating	<ol style="list-style-type: none"> 1. Motor is dirty. 2. Motor is damaged. 	<ol style="list-style-type: none"> 1. Clean motor. 2. Check and repair motor.
Excessive machine vibration	Machine is incorrectly leveled.	Adjust machine leveling leveled.

PARTS LIST





PARTS LIST OF DB12-48

No.	COM No.	DESCRIPTION	QTY.
1	30500001	BASE LOW	1
2	30500002	BASE UP	1
3	21100028	12"TABLE WORKING TABLE	1
4	30300014	FRONT GRADUATED SCALE	1
5	30300015	REAR GRADUATED SCALE	1
6	30300016	12" DUST HOOD	1
7	30300017	DISC GUARD	1
8	30300018	DISC	1
9	30300019	FRONT BRACKET	1
10	30300020	REAR BARACKET	1
11	J3020005	GRADUATED SCALE	1
12	30300030	(6×48")INDICATOR	1
13	30400007	BEARING FIX PLATE	1
14	21000006A	6×48" TABLE	1
15	30400002	AUXICIARY LEFT SCALE PLATE	1
16	30400003	AUXICIARY RIGHT SCALE PLATE	1
17	30400006	6×48" DUST HOOD	1
18	30400008	SHORT SPACER	1
19	30400009	LONG SPACER	1
20	30400004	RIGHT GRADUATEDSCALE BASE	1
21	J30300027	GRADUATED SCALE	1
22	S0010615L	CPA M6X15L LEFT SCREW	1
23	M3050000	MOTOR	1
24	30500003	SWITCH BOX	1
25	W0000000	SWITCH	1
26	S0020529	SCREW 5/16"X11/2"L	1
27	30400001	TILTING FIX BRACKET	1
28	30400010	CONNECTION BLOCK	1
29	30400011	SANDING PLATEN	1
30	30300036	RIGHT & LEFT BRACKET	2
31	30300037	FRONT & REAR SPACING PLATE	2
32	S0050404	1/4"-24 UNC ×1/4" SOC-SET SCREW	1

PARTS LIST OF DB12-48

No.	COM No.	DESCRIPTION	QTY.
33	C1106202	BEARING 6202	1
34	20900049	BEARING CAP 6202	1
35	20101031	BELT CHANGEHANDLE	1
36	20101032a	HANDLE KNOB	1
37	S0210501	FLAT WASHER 5/16"	2
38	C1106201	BEARING 6201	2
39	21100012	DRIVEN ROLLER	1
40	S0120200	NYL ON NUT 1/4"	1
41	S0521200	" C " CIRCLIP STW-12	1
42	21100009	DRIVEN ROLLER BRACKET	1
43	S0310420	SPRING PIN 4 x 16	1
44	21100010	BRACKET SHAFT	1
45	21100013	DRIVE ROLLER	1
46	21100019	SCREW	5
47	20101040	STOP FENCE	1
48	20101024	SCREW	1
49	21100018	SPRING	1
50	21100014A	DUST GUARD A	1
51	21100014	DUST GUARD BASE	1
52	S0030304	ROUND CROSS HEAD SCREW 3/16" x 1/4"	4
53	21100029	SANDING BELT 6x48"	1
54	S0020300a	FLAT WASHER 5X12	4
55	S0110400	1/4" -20 UNC NUT	1
56	21100011	DRIVEN ROLLER AXLE	1
57	S0010501	CAP SCREW 5/16"-18UNC x 1"	7
58	S0230503	SPING WASHER 5/16 "	21
59	30400017	LONG SPACED RING	4
60	30400015	COUPLER	2
61	30102007	COMPOUND BLOCK	1
62	S0400530	KEY 5 x 5 x 30	1
63	40101011	UP SPACED RING	4
64	S0010409	HEX A GONAL SOCKET HEAD SCREW 1/4" x 1/2"	7

PARTS LIST OF DB12-48

No.	COM No.	DESCRIPTION	QTY.
65	30400016	PLATE	1
66	S0210500	FLAT WASHER	38
67	20103044	SCREWDRIVER	1
68	S0010501	HEX SCREW 5/16"-18UNC x 1"	20
69	S0010500	CAP 5/16"-18UNC-1/2"	2
70	30300038	FASFEN	1
71	30300039	SANDING PAPER	1
72	S0230400	SPRING WASHER 1/4"	8
73	S0030308	PAN-KEAP SCREW 3/16"-24UNC x 5/8"	2
74	S1006P1	STRAIN RELIEF BUSHING	1
75	L0000000	POWER CORD	1
76	10401029	PAD	4
77	S0090512	SCREW 1/4"-20UNC x 1"	4
78	S0220300	GEAR WASHER 1/4"	2
79	S0120500a	LOCKING NUT 5/16"-18UNC	5
80	S0210403	1/4"X16	8
81	S0030308	PAN-KEAP SCREW 3/16"-24UNC x 1/2"	6
82	S0110300	NYL ON NUT 3/16"	2
83	S0020531	HEX SCREW 5/16"-18UNC x 3"	4
84	S0120500a	NUT 5/16" CHEMICAL BLOCK	2
85	21000007	MICRO METRIC ADJUSTMENT SCREW	1
86	20103029B	STEEL BALL	1
87	20103029A	MICRO METRIC NUT	1
88	F3050001	CARTON	1
89	A3050001	POLYLON	1
90	30400014	COUPLED AXLE	1
91	S0910104	HEX WRENCH 6mm	1
92	S0520032	RTW-32 C" CIRCLIP	2
93	S0520015	STW-15 C" CIRCLIP	3
94	I3050000	MANUAL	1

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