



## **ORIGINAL INSTRUCTIONS**

# PRODUCT SPECIFICATION

Drum Sander	DS460VS
Main Motor	230V 50Hz 1800W
Feed Motor	230V 50Hz 80W
Maximum Board Width	460mm ( 18")
Minimum Board Width	25mm (1")
Maximum Board Thickness	115mm (4-1/2")
Minimum Board Thickness	3mm (1/8")
Sandpaper Speed	50Hz 950m/min 60Hz 3600FPM
Conveyor belt Speed	0.5~4m/min (2~12FPM)
Grinding Sand Belt Size	76 X 2115 mm
Conveyor Belt Size	450X1120 mm
Table Size (Length x Width)	465x460mm
With Dust Collection System	Yes
Dust Port Size	75mm (3")

## SAFETY

### GENERAL SAFETY INSTRUCTIONS

**WARNING:** Read carefully these Operating Instructions. Familiarise yourself with the controls and proper use of the machine. Keep the Operating Instructions for future reference. The warning labels on the machine provide important information on safe operation.

1. **READ** and become familiar with the entire Operator's Manual. **LEARN** the machine's application, limitations and possible hazards.
2. **KEEP GUARD IN PLACE** and in working order.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use machinery in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All children should be kept at a safe distance from work area when the machine is in use.
6. **DON'T FORCE THE MACHINE.** It will do the job better and safer at the rate for which it was designed.
7. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry that may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
8. **ALWAYS WEAR EYE PROTECTION.** Wear goggles for protection against projected chips.

## **SPECIFIC SAFETY INSTRUCTIONS FOR THE MACHINE**

1. Do not place your hands or any part of your body between the cutting head and the conveyor belt while the machine is running. It is very dangerous.
2. Do not place fingers under bottom of workpiece while feeding it into sander. It can result in pinching injuries, or possibly getting trapped and pulled into sanding area of machine.
3. Tie back long hair, remove jewelry, and do not wear loose clothing or gloves. These can easily get caught in moving parts.
4. Check carefully whether the safety guards are intact before starting the machine.
5. Never reach inside machine or try to clear jammed workpiece while machine is operating.
6. Do not sand any metal products. This sander is designed to sand only natural wood products or some products made from natural wood fiber.
7. Inspect the workpiece before operating. Nails, staples, knots, or other imperfections in workpieces can be dislodged and thrown from sander. This can cause personal injury and machine damage.
8. To reduce risk of kickback injuries, always stay out of workpiece path and do not sand anything too small.

## **ACCESSORIES AND ATTACHMENTS**

### **RECOMMENDED ACCESSORIES**

**WARNING:** To avoid injury:

- Follow instructions that accompany accessories. Use of improper accessories may cause hazards.
- Use only accessories designed for this machine to avoid injury from thrown broken parts or workpieces.
- Do not use any accessory unless you have completely read the instruction or operator's manual for that accessory.

## **PACKING BOX CONTENTS**

### **UNPACKING AND CHECKING CONTENTS**

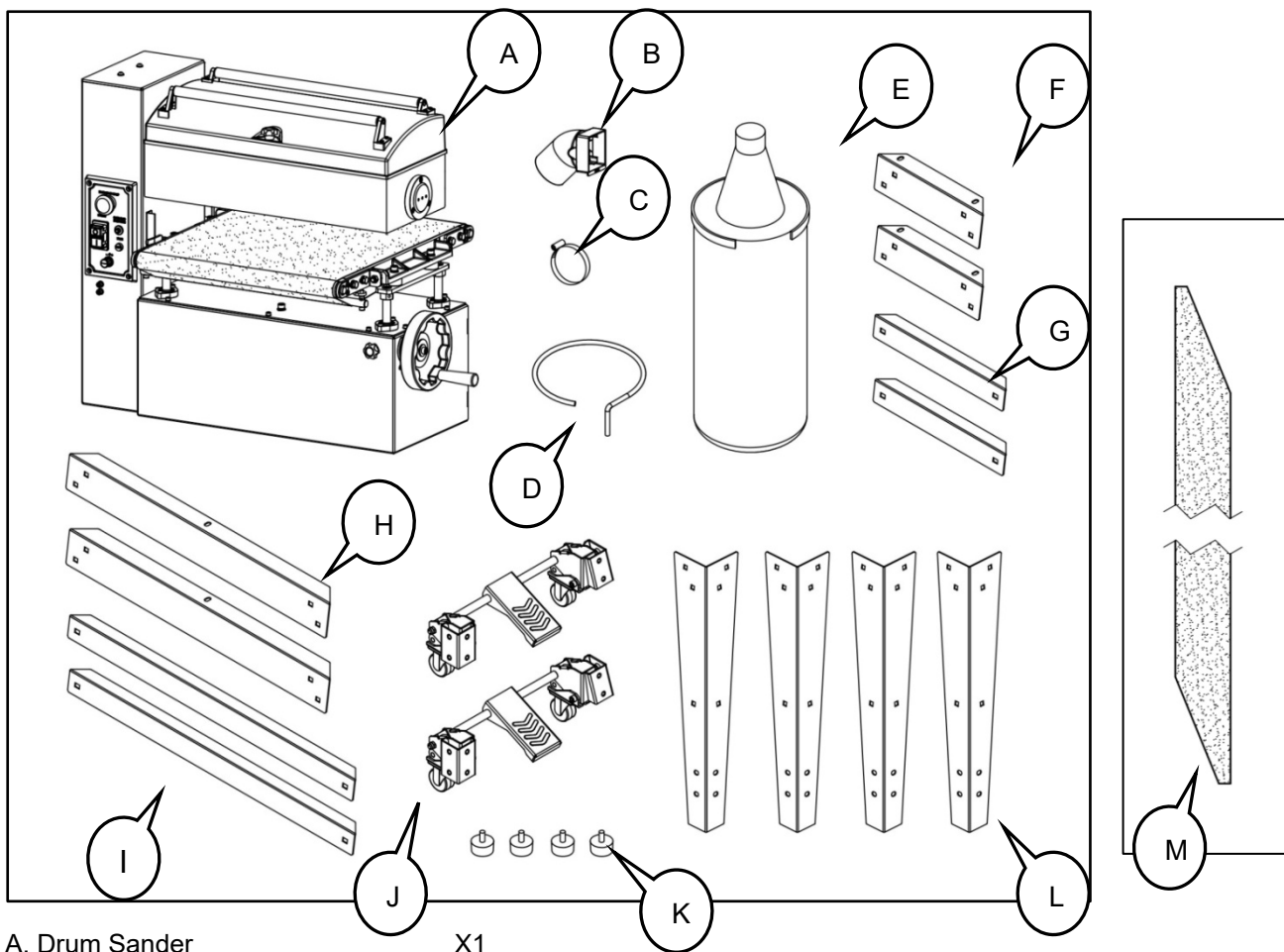
Carefully unpack the machine and all its parts, and compare against the illustration following.

**WARNING:**

- To avoid injury from unexpected starting, do not plug the power cord into a power source during unpacking and assembly. This cord must remain unplugged whenever you are assembling or adjusting the machine.
- If any part is missing or damaged, do not plug the machine in until the missing or damaged part is replaced, and assembly is complete.

## TABLE OF LOOSE PARTS

Check your machine to see parts listed below:



A. Drum Sander	X1
B. Dust Chute	X1
C. Hose Clamp	X1
D. Filter Bag Support	X1
E. Filter Bag	X1
F. Short Top Frame	X2
G. Short Brace	X2
H. Long Top Frame	X2
I. Long Brace	X2
J. Caster Assembly	X2
K. Foot	X4
L. Leg	X4
M. Grinding Sand Belt (Grit 150)	X1

(This grinding sand belt is an optional accessory )

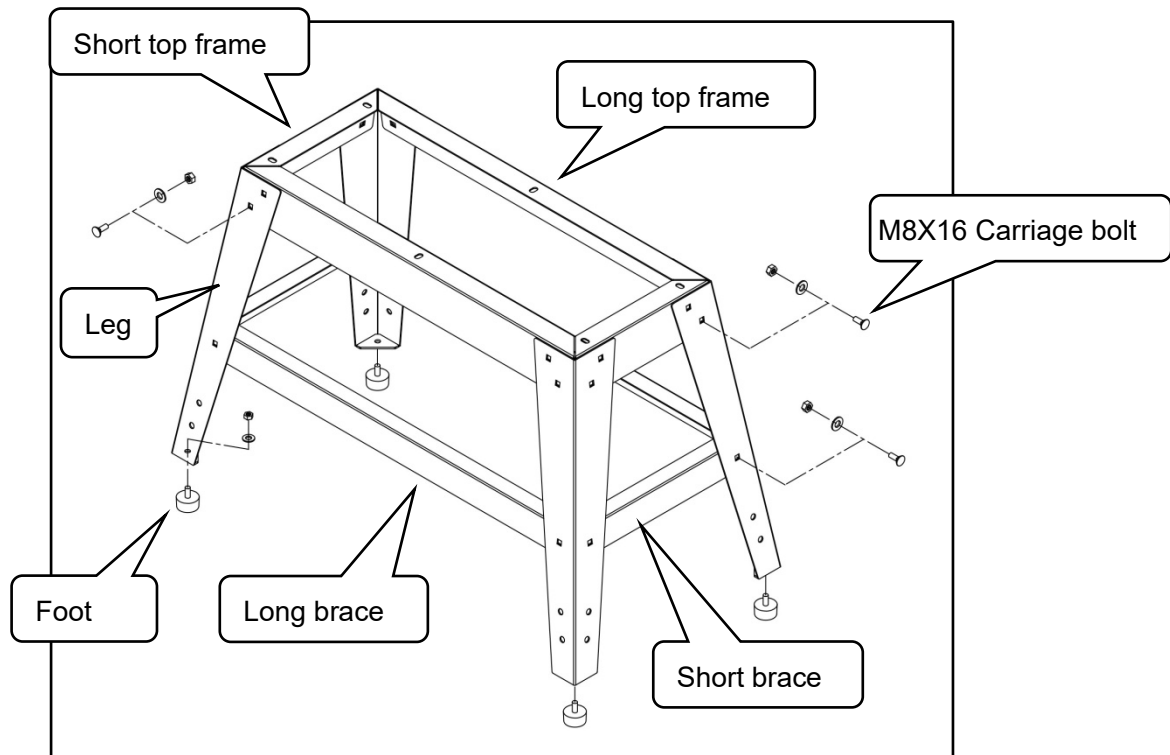
### Hardware bag(not shown)

M8X16 Carriage Bolt	X24
M8 Hex Nut	X28
M8X16 Hex Head Bolt	X6
M8X12 Socket Button Head Cap Screw	X16
8mm Flat Washer	X50
10-13mm Open End Wrench	X1
3, 4, 5, 6 mm Hex Wrench	X4

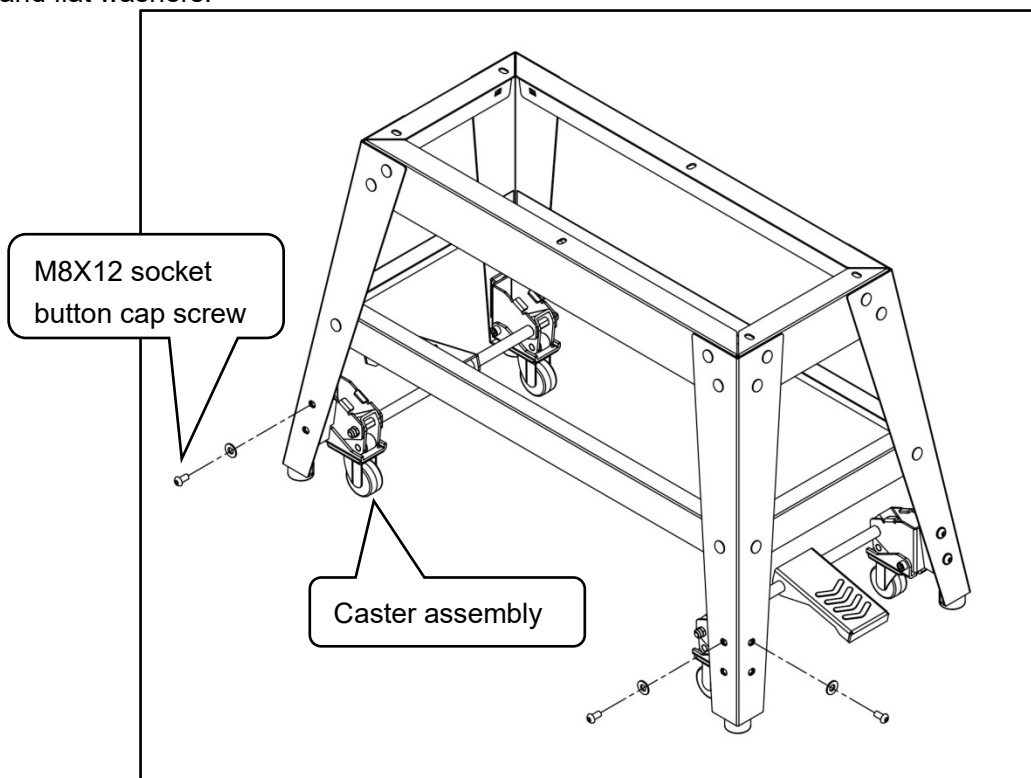
# ASSEMBLY

## Assemble the stand.

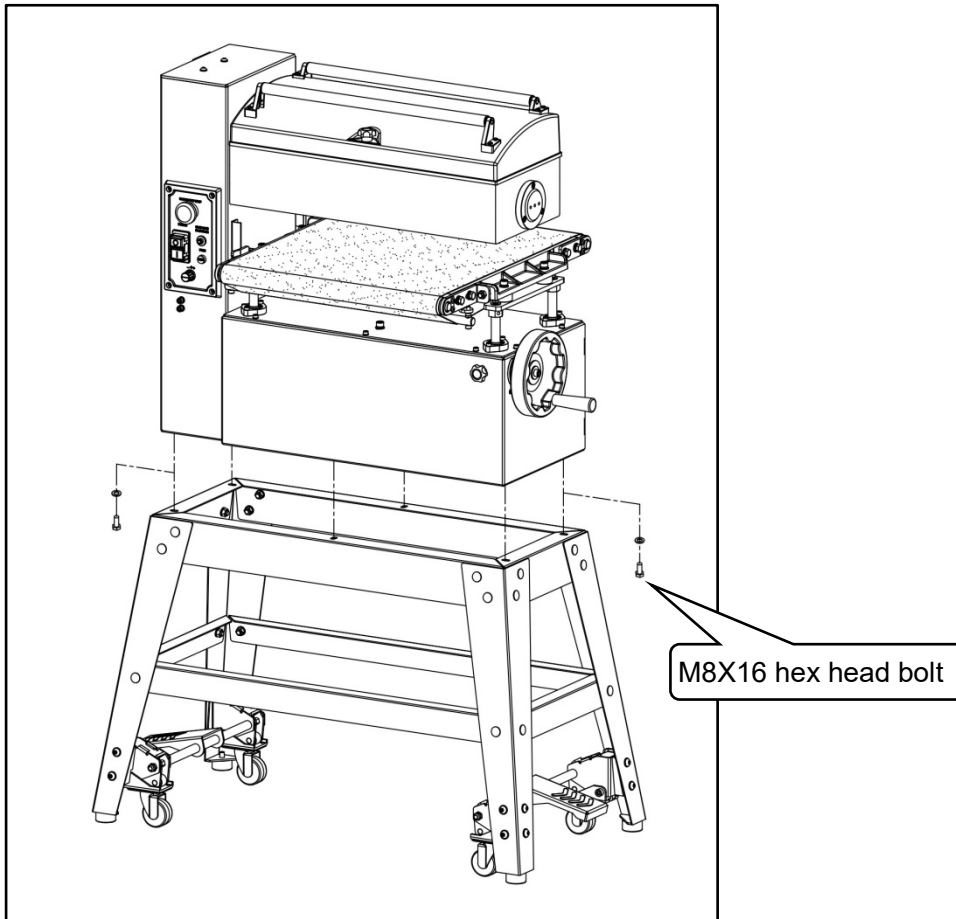
- 1. Assemble stand with M8x16 carriage bolts, 8mm flat washers and M8 hex nuts. Attach the four feet to the bottom of the leg and fix them by using the 8mm flat washers and M8 hex nuts. Place the stand on a flat surface, making sure there is no wobbling or tilting in the stand after fully tightening the nuts.



- 2. Attach the caster assembly onto the stand, fix it to legs by using M8X12 socket button cap screws and flat washers.

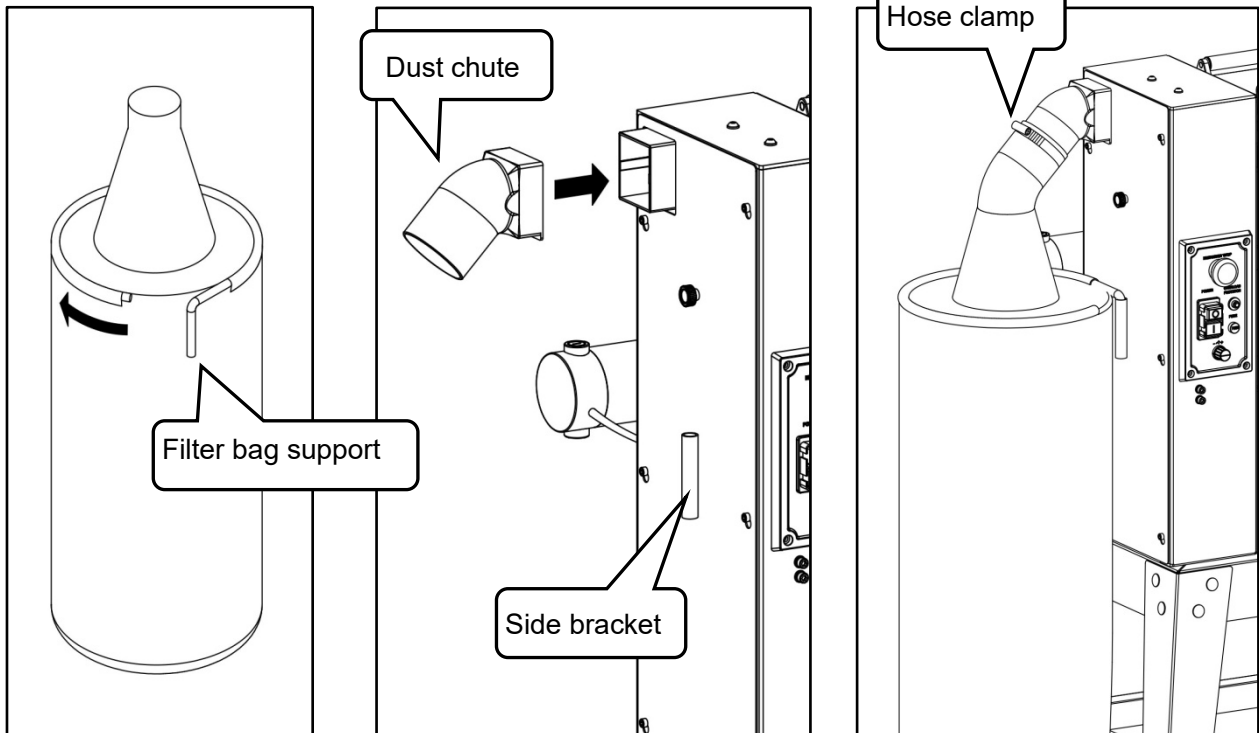


3. Place the drum sander onto the stand, secure them by using six M8X16 hex head bolts and washers.



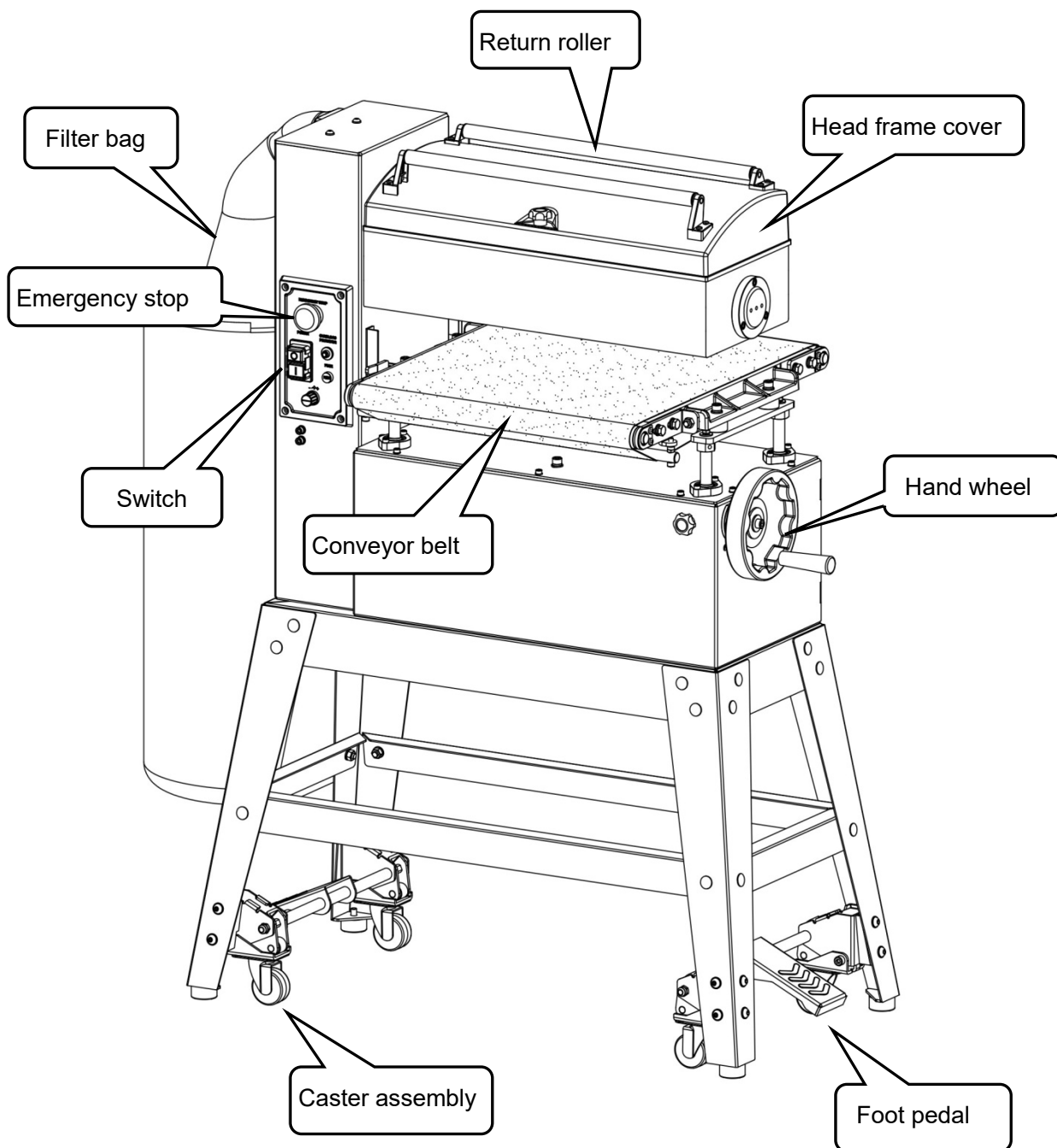
**Install the filter bag**

Align the slot of the filter bag with the circular support and rotate it into place. Attach the dust chute onto the dust port and push it on deep enough to secure. Attach the filter bag and bag support onto the side bracket. Connect the filter bag to the dust chute with the hose clamp.



## IDENTIFICATION

Become familiar with the names and locations of the controls and features shown below to have a better understanding of the instructions in this manual.



# ADJUSTMENTS

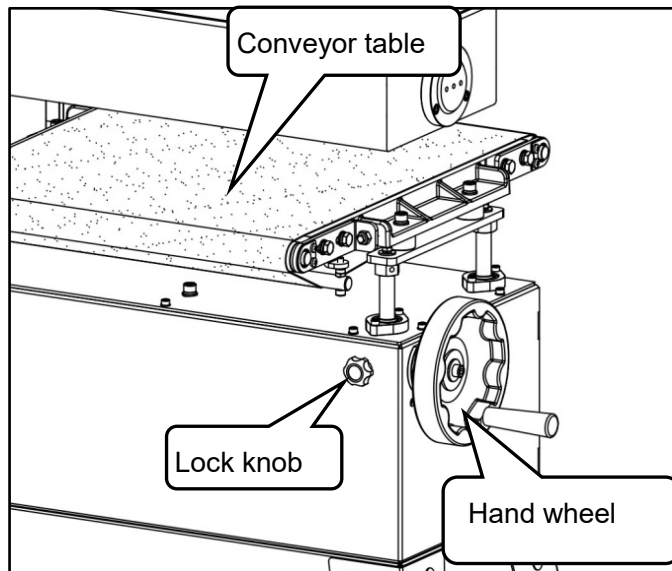
**Warning:** Turn off the machine and disconnect from the power supply before doing any adjustments.

## 1. Table Adjustment

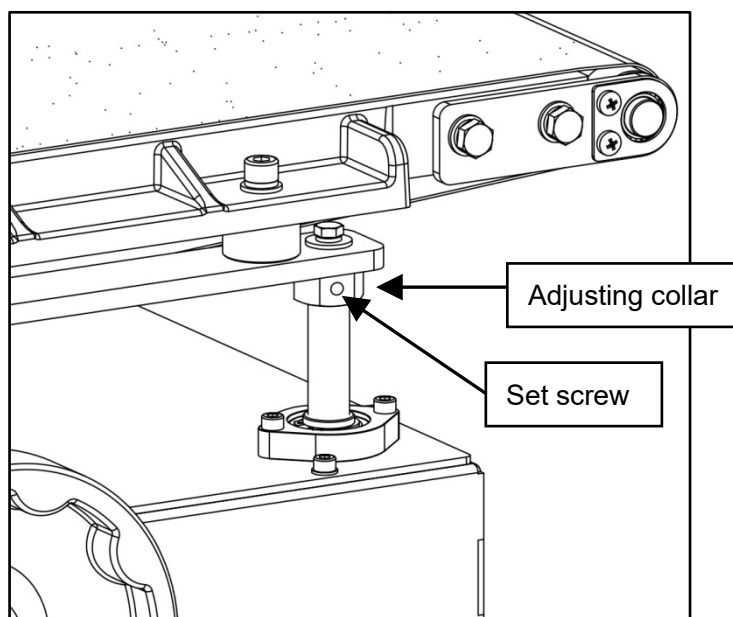
The height of the conveyor table can be adjusted by turning the hand wheel.

Each full turn of the hand wheel raises the conveyor table 2mm. Maximum depth for most sanding conditions is 0.5mm (1/4 turn=0.3mm).

After adjusting to the desired table height, tighten the locking knob to prevent the hand wheel from accidentally rotating.



If the thickness of the finished workpiece is not the same from left to right, you can loosen the set screw and adjust the adjusting collar to make the table parallel to the sanding drum.





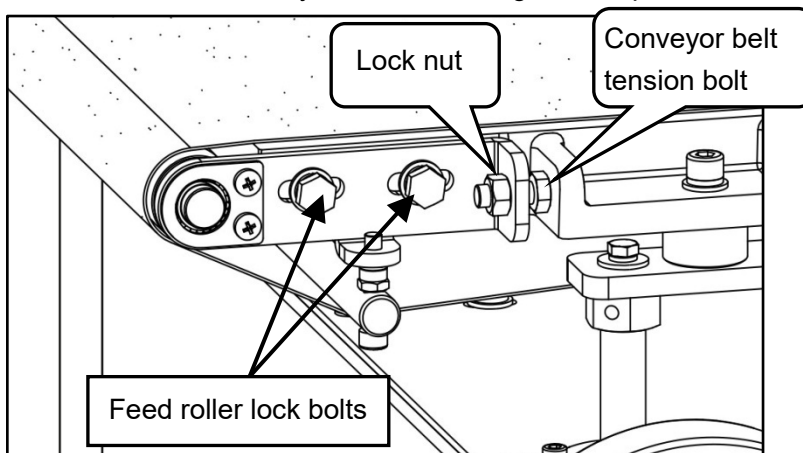
## 2. Tension & tracking conveyor belt

The conveyor belt will stretch when new and will eventually need to be tensioned. This is most obvious if the conveyor belt starts slipping on the rollers.

When you tension the conveyor belt, focus on adjusting the tensioning bolts in even increments. Adjusting one side more than the other will cause tracking problems.

### To tension conveyor belt:

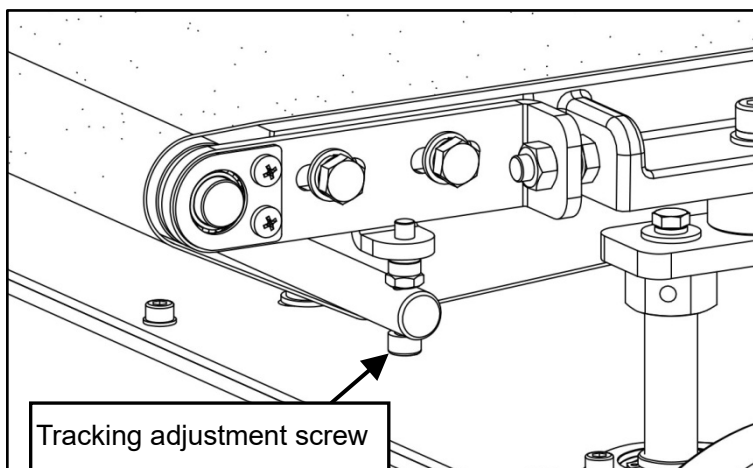
1. Loosen the feed roller lock bolts on both sides of the conveyor belt.
2. Loosen lock nuts and turn both conveyor belt tensioning bolts clockwise one full turn at a time until feed belt no longer slips during operation.  
If conveyor belt starts tracking to one side, back off the conveyor belt tensioning bolt that is being adjusted.
3. Tighten lock nuts to lock conveyor belt tensioning bolts in place.



The conveyor belt must track straight. If the feed belt tracks to either side, then the tracking must be corrected or the conveyor belt will become damaged and have to be replaced. The tracking was properly set at the factory, but it is the responsibility of the end user to keep it tracking properly during the life of the machine.

### To track conveyor belt:

1. Turn conveyor belt ON and watch it track.
2. Tension tracking adjustment screw until conveyor belt tracks in opposite direction.
3. When conveyor belt is near the middle of the rollers or table, loosen tracking adjustment screw until feed belt stops moving and tracks straight. If conveyor belt tracks too far to the other side, loosen tracking adjustment screw as necessary to bring it back.



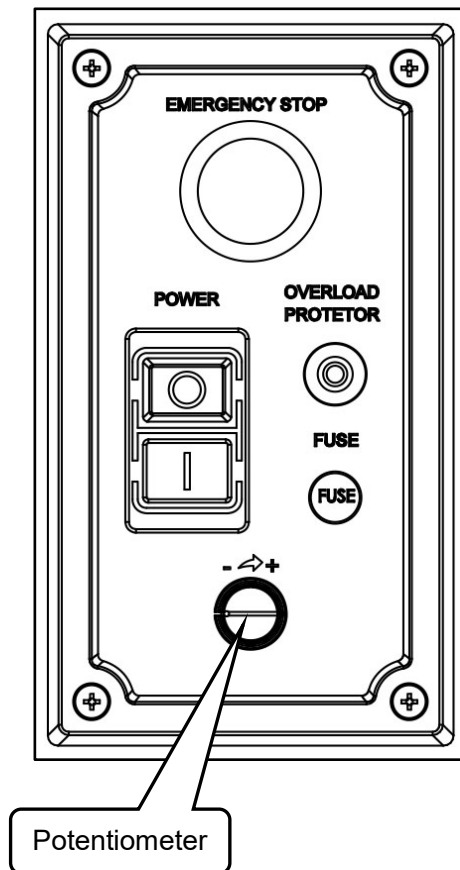
### 3. Feed rate adjustment

The potentiometer allows you to increase the feed rate from 2-12FPM. The correct speed to use depends on the type of stock you are using (hardwood vs. softwood) and the stage of finish with that workpiece.

As a general rule, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove material faster, but runs the risk of overloading the motor or damaging the sandpaper.

To adjust feed belt speed:

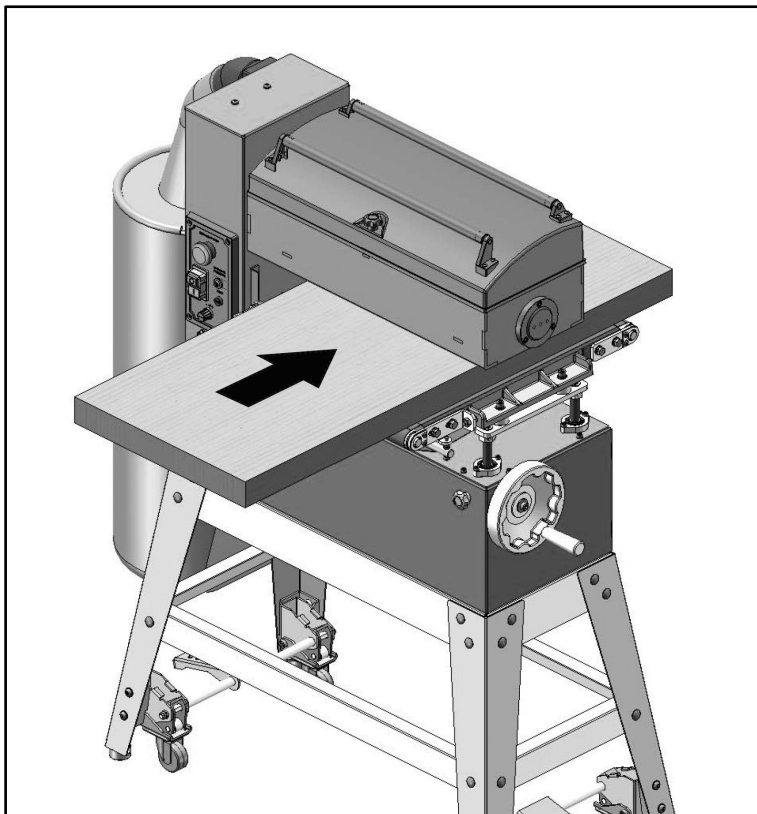
1. Turn ON the conveyor belt (DO NOT adjust conveyor speed when the conveyor motor is off).
2. Rotate potentiometer clock wise to increase the feed speed or counterclockwise to decrease the conveyor feed speed.



## OPERATION

To complete a typical sanding operation, the operator does the following:

1. Examine the workpiece to verify it is suitable for sanding and to determine which sanding belt grit size to use.
2. Verify the workpieces out-feed clearance and support. If workpiece is wider than conveyor table, operator supports workpieces full width. If the workpiece is overly long and difficult to handle, operator uses a roller support stand to assist with feeding.
3. Adjust table height to approximate workpiece thickness.
4. Put on required safety glasses and respirator.
5. Turn the machine ON.
6. Feed workpiece into the sander by placing front end on in-feed side of conveyor table and supporting back end until workpiece engages with pressure rollers.  
Note: During initial pass with a new workpiece, operator adjusts table height as necessary so workpiece only makes light contact with sanding belt and does not overload sander.
7. Receive workpiece from out-feed side of conveyor table.
8. Raises height of conveyor table a small amount (typically 1/8-1/4 of a full rotation of hand wheel), then repeats the feeding process of workpiece through sander.
9. Change sandpaper to a finer grit as needed.
10. Turns sander OFF, and disconnect it from power supply.



### Sanding Tips

- Replace coarse grit grinding sand belt with a finer grit to achieve a smoother finish.
- Raise the table a maximum of 1/4 turn of the hand wheel until the workpiece is the desired thickness.
- Feed boards into the sander at different places on the conveyor to maximise grinding sand belt life and prevent uneven conveyor belt wear.

- DO NOT sand boards less than 6" long or less than 1/8" thick to prevent damage to the workpiece and the drum sander.
- When sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When the drum moves from sanding a wide surface to sanding a narrow surface, the load on the motor will be reduced and the drum will speed up causing a gouge.
- DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury. Edge sanding boards also can cause damage to the conveyor belt and grinding sand belt.
- When sanding workpieces with a bow or crown, place the high point up (prevents the workpiece from rocking) and take very light passes.
- Feed the workpiece at an angle to maximise stock removal and sandpaper effectiveness, but feed the workpiece straight to reduce sandpaper grit scratches for the finish passes.

## MAINTENANCE

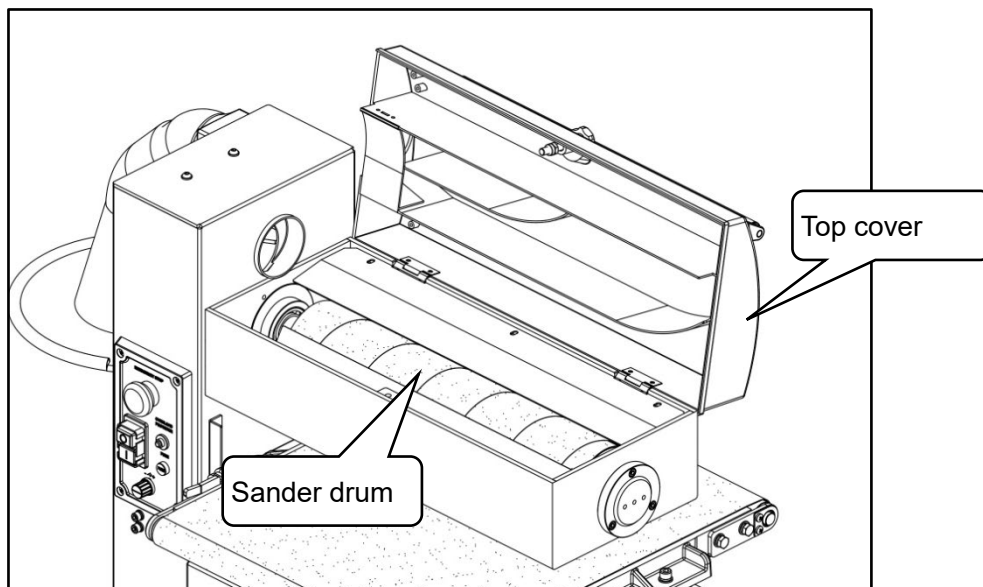
**Warning:** Turn off the machine and disconnect from the power supply before conducting maintenance work or settings.

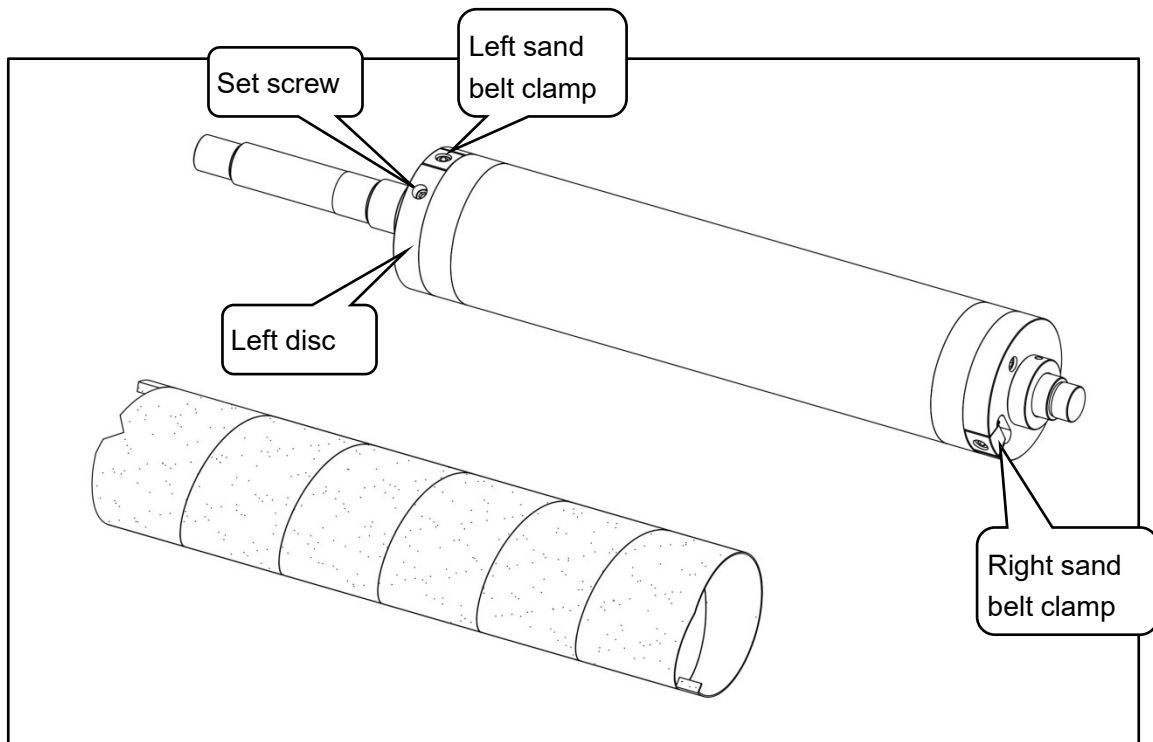
### Replacing Sanding Belt

This drum sander is designed for 3" wide sand belt rolls

To change sanding belt:

1. DISCONNECT MACHINE FROM POWER!
2. Open top cover and loosen cap screw on sand belt clamps.
3. Remove the old sanding belt from clamp. Use a flat head screwdriver if necessary to loosen clamp to free sand belt.  
Note: Take care not to rip or tear the old sand belt so you can use it as a template when cutting out the replacement sand belt strip.
4. Loosen the set screw, turn the left disc so that the internal spring turns to the tightest position, tighten the set screw to hold the left disc
5. Insert corner of new sanding belt into right clamp and tighten cap screws
8. Wrap sanding belt around drum ensuring there are no bubbles or over lapping edge.
9. When sanding belt reaches left side of drum, Place end of sandpaper into clamp, secure it.
10. Loosening the set screw & releasing the left disc, makes the sanding belt tension automatically, then tighten the set screw again.



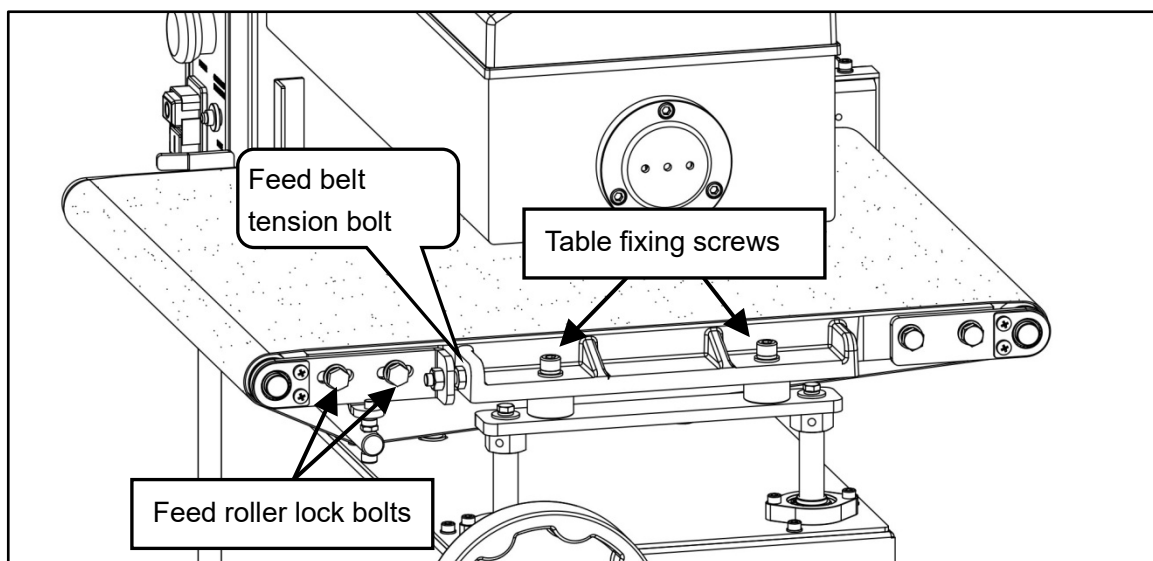


## Replacing Conveyor belt

Replacing the conveyor belt is a relatively simple process, but it will require re-tensioning and tracking once the new conveyor belt is installed.

To replace conveyor belt:

1. **DISCONNECT MACHINE FROM POWER!**
2. Loosen the roller lock bolts. Turn both of the feed belt adjustment bolts clockwise one full turn at a time to release tension from feed belt.
3. Loosen and remove the table fixing cap screws.
4. Have an assistant lift outside edge of the table then slide conveyor belt out.
5. Clean any dirt or dust off table and rollers, have an assistant lift the table then slide the new conveyor belt on.
6. Level and tighten all of the screws.



## Machine care

- Usually check the condition of the power supply cords and replace them if they are broken, or internal wires are showing.
- Use a brush and a shop vacuum to remove chips and other debris from the machine.
- Always keep the machines hand grip clean to prevent accidental slipping during use.
- Clean/vacuum dust build up from inside cabinet and off of the motor.
- If you do not intend to use the sander machine for a long time, clean it and put it in a dry place if possible.
- Before each use, inspect the general condition of the Belt Sander. Check for loose screws, misalignment or binding of moving parts, cracked or broken parts, damaged electrical wiring and any other condition that may affect its safe operation. If abnormal noise or vibration occurs, have the problem corrected before further use. Do not use damaged equipment.

## TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
Machine does not work	<ul style="list-style-type: none"> <li>● Defective motor, power cable or plug,</li> <li>● Overload protector is tripped,</li> <li>● Start capacitor is at fault.</li> <li>● Wall fuse/circuit breaker is blown / tripped.</li> <li>● Power switch is at fault.</li> <li>● Motor is at fault.</li> <li>● Emergency stop switch is locked</li> </ul>	<ul style="list-style-type: none"> <li>● Specialised personnel should check the machine.</li> <li>● Reset the overload protector.</li> <li>● Test/replace.</li> <li>● Ensure correct size for machine load; replace weak breaker.</li> <li>● Replace faulty power switch.</li> <li>● Test / repair / replace.</li> <li>● Release the emergency stop.</li> </ul>
Machine stalls or is underpowered.	<ul style="list-style-type: none"> <li>● Workpiece material is not suitable for machine.</li> <li>● Feed rate too fast.</li> <li>● Machine undersized for task.</li> <li>● V-belt is slipping.</li> <li>● Plug or receptacle at fault.</li> <li>● Overload protector is tripped,</li> <li>● Motor is at fault.</li> </ul>	<ul style="list-style-type: none"> <li>● Only sand wood; ensure moisture is below 20% and there are no foreign materials in the workpiece.</li> <li>● Decrease feed rate.</li> <li>● Clean/replace grinding sand belt; reduce feed rate/sanding depth.</li> <li>● Replace bad belt, and re-tension V-belt</li> <li>● Test for good contacts/correct wiring.</li> <li>● Reset the overload protector,</li> <li>● Test / repair / replace.</li> </ul>
Machine has vibration or noisy operation	<ul style="list-style-type: none"> <li>● Machine undersized for task.</li> <li>● Motor or component loose.</li> <li>● V-belt is worn, loose</li> <li>● Pulley loose.</li> <li>● Motor mount loose/broken.</li> <li>● Bearings at fault.</li> </ul>	<ul style="list-style-type: none"> <li>● Reduce feed rate/sanding depth.</li> <li>● Inspect/replace damaged bolts/nuts, and re-tighten with thread-locking fluid.</li> <li>● Inspect/replace belt</li> <li>● Inspect and retighten the set screw on pulley.</li> <li>● Test and replace bearing</li> </ul>

Grinding, screeching, or	<ul style="list-style-type: none"> <li>● Drum bearings are worn and</li> </ul>	<ul style="list-style-type: none"> <li>● Replace Drum Bearings</li> </ul>
Rubbing noise when sanding drum is powered up.	<ul style="list-style-type: none"> <li>● Need Replacing</li> </ul>	
Machine lacks power; drum stops turning under load.	<ul style="list-style-type: none"> <li>● V-belt loose.</li> <li>● Too much pressure on sanding drum.</li> </ul>	<ul style="list-style-type: none"> <li>● Tighten V-belt 2.</li> <li>● Lower conveyor table.</li> </ul>
Conveyor belt slips under load.	<ul style="list-style-type: none"> <li>● Belt tension not properly adjusted.</li> <li>● Belt tracking not properly adjusted.</li> <li>● Conveyor belt worn.</li> <li>● Workpiece too heavy.</li> </ul>	<ul style="list-style-type: none"> <li>● Properly adjust belt tension.</li> <li>● Properly adjust belt tracking.</li> <li>● Replace conveyor belt.</li> <li>● Use lighter workpiece.</li> </ul>
Conveyor belt tracks to one side	<ul style="list-style-type: none"> <li>● Conveyor belt tracking is incorrect.</li> </ul>	<ul style="list-style-type: none"> <li>● Track the conveyor belt so it runs straight.</li> </ul>
Burn marks on workpiece.	<ul style="list-style-type: none"> <li>● Using too fine sanding grit for depth of cut.</li> <li>● Sanding belt loaded with sawdust and gum</li> <li>● Feed rate too slow.</li> <li>● Sanding belt not properly wrapped onto drum.</li> <li>● Worn sand belt.</li> </ul>	<ul style="list-style-type: none"> <li>● Use coarser grit sand belt or decrease depth of cut.</li> <li>● Clean/replace sand belt</li> <li>● Increase feed rate.</li> <li>● Re-install grinding sand belt.</li> <li>● Replace sand belt.</li> </ul>

## PARTS LIST

1	4.2-1.4X19mm Thread forming screw	6	31	Fan	1
2	Rear plastic support A	1	32	6mm Flat washer	1
3	Insert cap	4	33	6mm Lock washer	1
4	Return roller	2	34	M6X12 Socket head cap screw	1
5	Rear plastic support B	1	35	Dust exhaust	1
6	Front plastic support A	1	35.1	Pin	1
7	Front plastic support B	1	36	Dust chute	1
8	4-1.2X14X23 Thread forming screw	2	37	Hose clamp	1
9	Head frame cover	1	38	Filter bag	1
10	Plastic cover	1	39	Filter bag support	1
11	3.5-1.3X9.5mm Thread forming screw	4	40	Knob	1
12	Knob	1	41	Side cover	1
13	M8 Lock nut	1	42	M5 Lock nut	1
14	Chip deflector plate	1	43	M5X10 Socket head cap screw	6
15	M5X10 Socket button head cap screw	3	44	M8X20 Socket head cap screw	6
16	M4 Hex nut	4	45	8mm Lock washer	6
17	4mm Flat washer	8	46	8mm Flat washer	6
18	M4X12 Pan head screw	4	47	Side cabinet	1
19	Hinge	2	48	Scale plate	1
20	4mm Flat washer	4	49	Height scale	1
21	M4X8 Pan head screw	4	50	5mm Flat washer	2
22	Fan pulley	1	51	M5X10 Hex head bolt	2
23	M6X8 Set screw	2	52	M6X12 Socket head cap screw	6
24	M6X16 Socket button head cap screw	2	53	Bearing house (Left)	1
25	6mm Flat washer	2	54	Ball bearing 6006-2RS	2
26	Mounting plate	1	55	Head frame	1
27	3.5-1.3x13mm Thread forming screw	5	56	Ball bearing 6205-2RS	1
28	Ball bearing 6000-2RS	2	57	Bearing house (Right)	1
29	26mm Internal retaining ring	1	58	M6X12 Socket head cap screw	3
30	Fan shaft	1	59	M6X8 Set screw	2

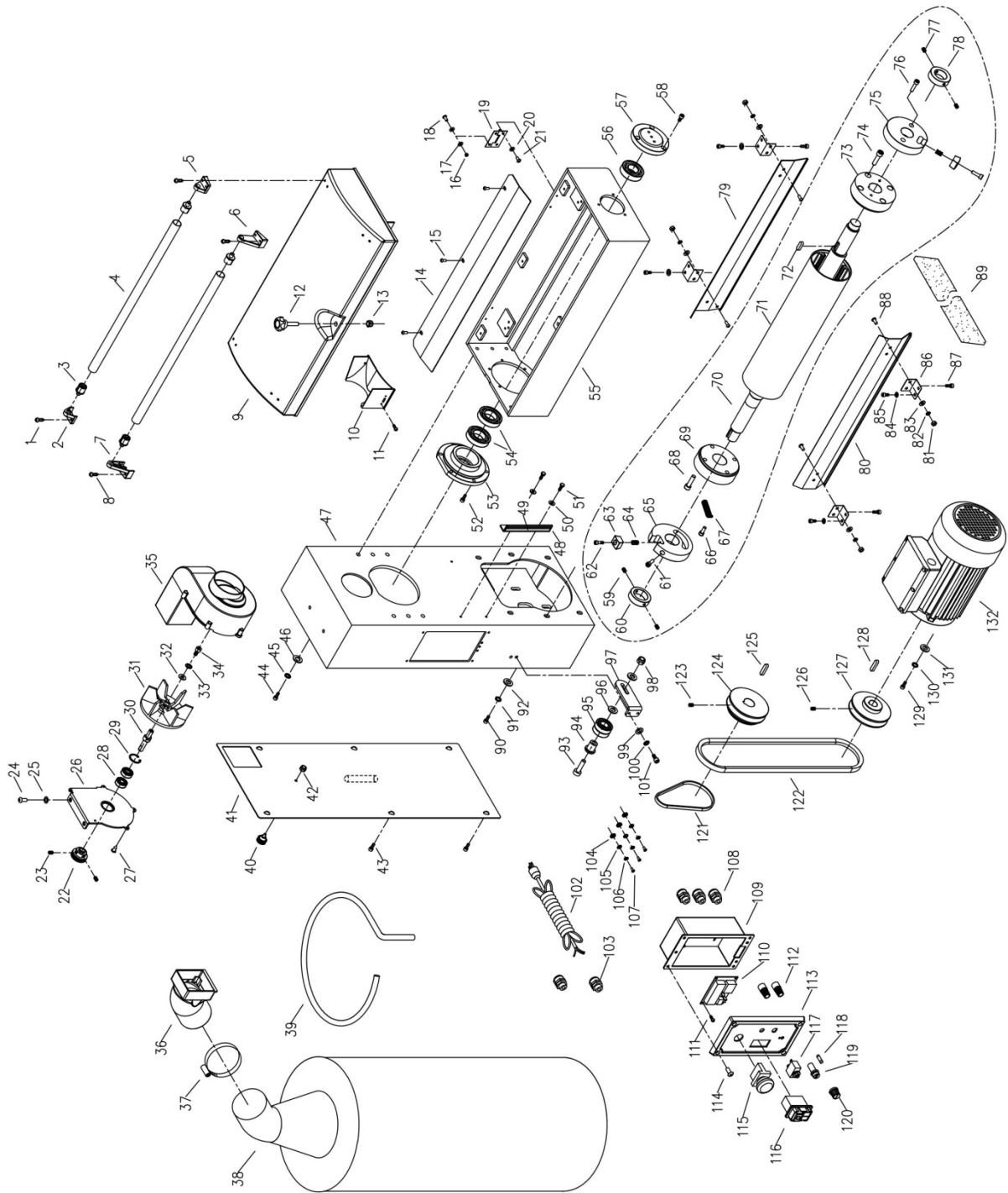


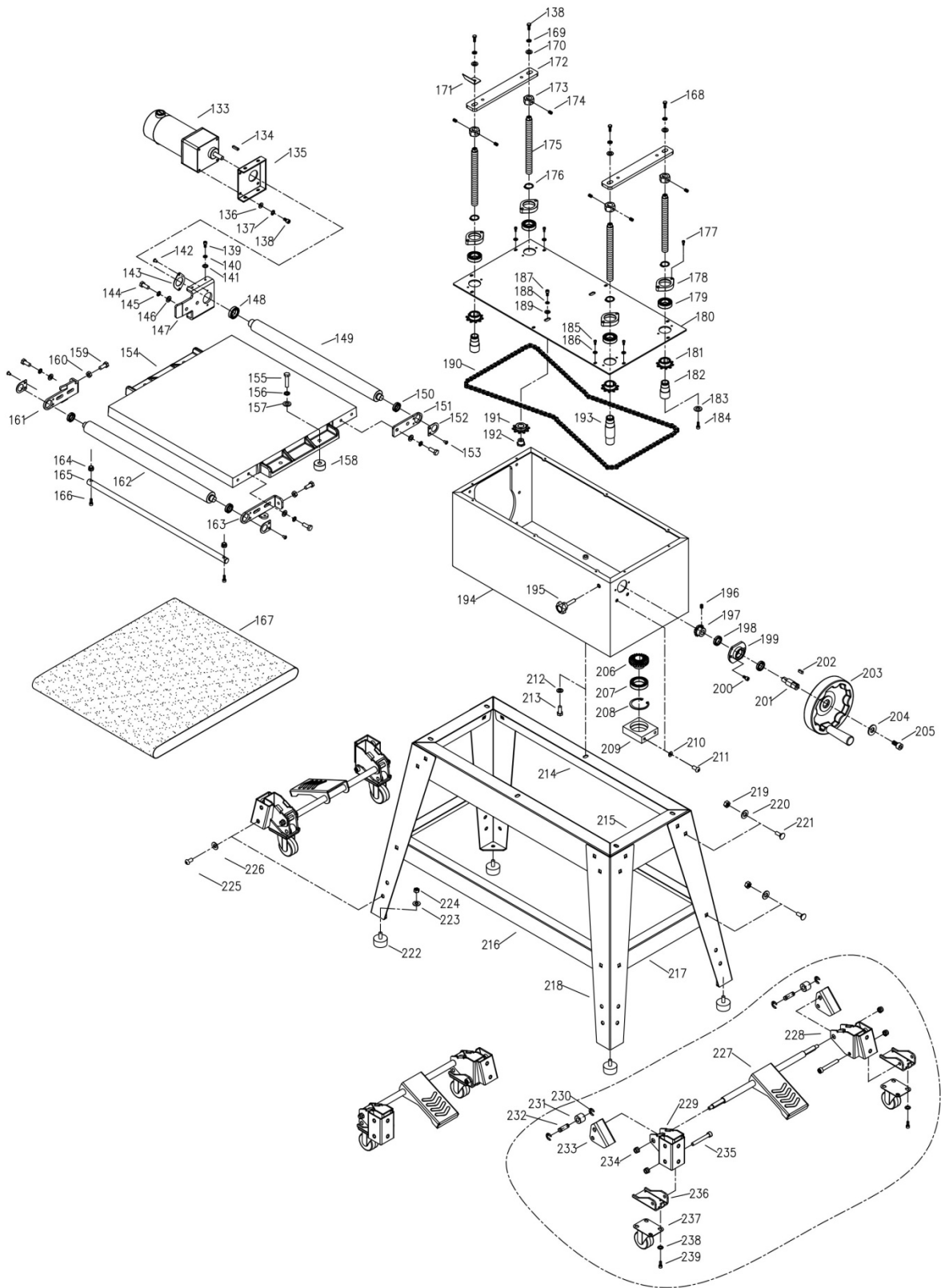
60	Left limiting collar	1	90	M8X20 Socket head cap screw	6
61	M6X20 Socket head cap screw	1	91	8mm Lock washer	6
62	M6X20 Socket head cap screw	2	92	8mm Flat washer	6
63	Belt locking block	2	93	M8X40 Socket head cap screw	1
64	Compression spring	2	94	Bushing	1
65	Sanding belt clamp bracket (Left)	1	95	Ball bearing 6003-2RS	2
66	M6X12 Socket head cap screw	1	96	8mm Flat washer	2
67	Belt tension spring	1	97	Support plate	1
68	M8X35 Socket head cap screw	4	98	M8 Lock nut	1
69	Left drum cover	1	99	6mm Flat washer	2
70	Shaft	1	100	6mm Lock washer	2
71	Belt drum	1	101	M6X12 Socket head cap screw	2
72	8X7X25mm Key	1	102	Power cord	1
73	Right drum cover	1	103	Strain relief	2
74	M8X35 Socket head cap screw	4	104	5mm Serrated washer	3
75	Sanding belt clamp bracket (Right)	1	105	5mm Flat washer	3
76	M6X20 Socket head cap screw	2	106	5mm Lock washer	3
77	M6X8 Set screw	2	107	M5X12 Pan head screw	3
78	Right limiting collar	1	108	Strain relief	3
79	Rear pressure plate	1	109	Switch box	1
80	Front pressure plate	1	110	DC motor driver	1
81	M5 Hex nut	8	111	2.9-1x9.5 Thread forming screw	4
82	5mm Lock washer	8	112	Terminal	2
83	5mm Flat washer	8	113	Switch mounting plate	1
84	5mm Flat washer	8	114	M5X12 Pan head screw	4
85	M5X10 Socket head cap screw	8	115	Emergency stop	1
86	Connecting plate	4	116	Switch	1
87	M5X10 Socket head cap screw	4	117	Overload protector	1
88	M5X10 Socket button head cap screw	8	118	Fuse	1
89	Grinding Sand belt	1	119	Fuse holder	1

120	Potentiometer knob	1	151	Rear feed roller bracket (Right)	1
121	Fan belt	1	152	Bearing cover	3
122	Drive belt	1	153	M5X10 Socket button head cap screw	6
123	M6X8 Set screw	1	154	Table	1
124	Shaft pulley	1	155	M8X40 Socket head cap screw	4
125	8X7X25mm Key	1	156	8mm Lock washer	4
126	M6X8 Set screw	1	157	8mm Flat washer	4
127	Motor pulley	1	158	Spacer bushing	4
128	6X6X30mm Key	1	159	M8X25 Hex head bolt	2
129	M8X20 Socket head cap screw	4	160	M8 Hex nut	2
130	8mm Lock washer	4	161	Front feed roller bracket (Left)	1
131	8mm Flat washer	4	162	Front feed roller	1
132	Motor	1	163	Front feed roller bracket (Right)	1
133	DC motor	1	164	M6 Lock nut	2
134	4X4X25mm Key	1	165	Adjusting rod	1
135	DC motor mounting plate	1	166	M6X35 Socket head cap screw	2
136	6mm Flat washer	4	167	Conveyor belt	1
137	6mm Lock washer	4	168	M6X12 Hex head bolt	2
138	M6X12 Socket head cap screw	6	169	6mm Lock washer	4
139	M5X16 socket head cap screw	4	170	6mm Flat washer	4
140	5mm Lock washer	4	171	Pointer	1
141	5mm Flat washer	4	172	Steel bar	2
142	M5X10 Socket button head cap screw	2	173	Adjusting collar	4
143	Bearing cover	1	174	M6X6 Set screw	8
144	M8X20 Hex head bolt	8	175	Elevation screw	4
145	8mm Lock washer	8	176	20mm External retaining ring	4
146	8mm Flat washer	8	177	M5X16 socket head cap screw	8
147	Rear feed roller bracket (Left)	1	178	Bearing seat	4
148	Ball bearing 61804-2RS	1	179	Ball bearing 61904-2RS	4
149	Rear feed roller	1	180	Base cover plate	1
150	Ball bearing 61802-2RS	3	181	Sprocket	4
			182	Elevation nut	3
			183	6mm Flat washer	1
			184	M6X12 Socket head cap screw	1
			185	M5X10 Socket head cap screw	10
			186	5mm Flat washer	10
			187	M8X16 Socket head cap screw	2
			188	8mm Lock washer	2
			189	8mm Flat washer	2
			190	Chain	1

191	Idle sprocket	2	221	M8X16 Carriage bolt	24
192	Support rod	2	222	Foot	4
193	Elevation nut	1	223	8mm Flat washer	4
194	Base	1	224	M8 Hex nut	4
195	Lock knob	1	225	M8X12 Socket button head cap screw	16
196	M6X8 Set screw	1	226	8mm Flat washer	16
197	Bevel gear (15T)	1	227	Foot pedal	2
198	Ball bearing 61803-2RS	2	228	Caster support A	2
199	Support bracket	1	229	Caster support B	2
200	M5X16 socket head cap screw	2	230	8mm External retaining ring	8
201	Shaft	1	231	Rolling bush	4
202	5X5X16mm KEY	1	232	Shaft	4
203	Hand wheel	1	233	Cam plate	4
204	8mm Flat washer	1	234	M8 Lock nut	8
205	M8X16 Socket head cap screw	1	235	M8X60 Hex head bolt	4
206	Bevel gear (25T)	1	236	Caster mounting plate	4
207	Ball bearing 61906-2RS	1	237	Caster	4
208	47mm Internal retaining ring	1	238	5mm Flat washer	16
209	Bearing support block	1	239	M5X8 Socket head cap screw	16
210	8mm Flat washer	2			
211	M8X12 Socket button head cap screw	2			
212	8mm Flat washer	6			
213	M8X16 Hex head bolt	6			
214	Long top frame	2			
215	Short top frame	2			
216	Long brace	2			
217	Short brace	2			
218	Leg	4			
219	M8 Hex nut	24			
220	8mm Flat washer	24			

# ASSEMBLY DIAGRAM





We Importer:

**TOOLSAVE LTD**

Unit C, Manders Ind. Est.,  
Old Heath Road, Wolverhampton,  
WV1 2RP.

Declare that the product:

**Designation: Drum Sander  
Model: DS460VS**

Standards & technical specifications referred to:

**EN ISO 19085-1:2017  
EN ISO 19085-8:2018**

**Authorized Technical File Holder: Bill Evans**

**20/09/2023**

**The Director**



