

## **ORIGINAL INSTRUCTIONS**

## TECHNICAL SPECIFICATION

**Attention:** Please choose proper power source, voltage and frequency that are shown in the label for your machine.

Drum Sander	DS460VS
Main Motor	1800W
Feed motor	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

**WARNING:** To avoid electrical hazards, fire hazards, or damage to the machine, use proper circuit protection. Use a separate electrical circuit for your machine. To avoid shock or fire, replace power cord immediately if it is worn, cut or damaged in any way.

### GENERAL SAFETY INSTRUCTIONS

**WARNING:** Read carefully these Operating Instructions. Familiarise with the controls and proper use of the machine. Keep the Operating Instructions for future reference. The warning labels with instructions attached to 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. **REMOVE ADJUSTING TOOLS.** Form a habit of checking to see that keys, adjusting wrenches or any other tools are removed from the machine before turning ON.
4. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
5. **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.
6. **KEEP CHILDREN AWAY.** All visitors should be kept at a safe distance from work area.
7. **MAKE WORKSHOP CHILDPROOF** with padlocks.
8. **DON'T FORCE THE MACHINE.** It will do the job better and safer at the rate for which it was designed.
9. **USE THE RIGHT TOOL.** Do not force tool or attachment to do a job for which it was not designed.
10. **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 under sized cord will result in a drop in line voltage and in loss of power that will cause the tool to overheat.

11. **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.
12. **ALWAYS WEAR EYE PROTECTION.** Wear goggles for protection against projected chips.
13. **DON'T OVERREACH.** Keep proper footing and balance at all times.
14. **MAINTAIN WITH CARE.** Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.
15. **DISCONNECT POWER FIRST** before servicing; when changing belt and other part.
16. **USE RECOMMENDED ACCESSORIES.** Consult the Operator's Manual for recommended accessories.  
The use of improper accessories may cause serious injury.
17. **NEVER STAND ON MACHINE.** Serious injury could occur if the machine is tipped or if the cutting tool is unintentionally contacted.
18. **CHECK FOR 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.
20. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER "OFF".** Don't leave tool until it comes to a complete stop.
21. **BE CAREFUL.** Pay attention to what you are doing. Work reasonably. Do not use the machine when you are tired.
22. **HAVE YOUR MACHINE REPAIRED BY AN EXPERT ONLY!** This machine meets the applicable safety provisions. Any repairs may only be executed by an expert, using original spare parts; otherwise, the user could face a risk of injury.
23. **STABLE MACHINE.** Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.
24. **HAZARDOUS DUST.** Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a proper respirator to reduce your risk.
25. **HEARING PROTECTION.** Always wear hearing protection when operating or observing loud machinery.  
Extended exposure to this noise without hearing protection can cause permanent hearing loss.
26. Children and persons not familiarised with the machine and persons with limited physical, sensory and mental skills must not use the machine.

## **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.

# ELECTRICAL REQUIREMENTS

## POWER SUPPLY AND MOTOR SPECIFICATIONS

**WARNING:** To avoid electrical hazards, fire hazards, or damage to the tool, use proper circuit protection. Use a separate electrical circuit for your tools. To avoid shock or fire, if power cord is worn or cut, or damaged in any way, have it replaced immediately.

## GROUNDING INSTRUCTIONS

**WARNING:** This tool must be grounded while in use to protect the operator from electrical shock.

**IN THE EVENT OF A MALFUNCTION OR BREAKDOWN**, grounding provides a path of least resistance for electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching receptacle 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 receptacle, have the proper receptacle installed by a qualified electrician.

**IMPROPER CONNECTION** of the equipment-grounding conductor can result in risk of electric shock. The conductor with green insulation (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 person if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

Refer to picture:



**WARNING:** Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock.

**WARNING:** This machine is for indoor use only. Do not expose to rain or use in damp locations.

## GUIDELINES FOR EXTENSION CORDS

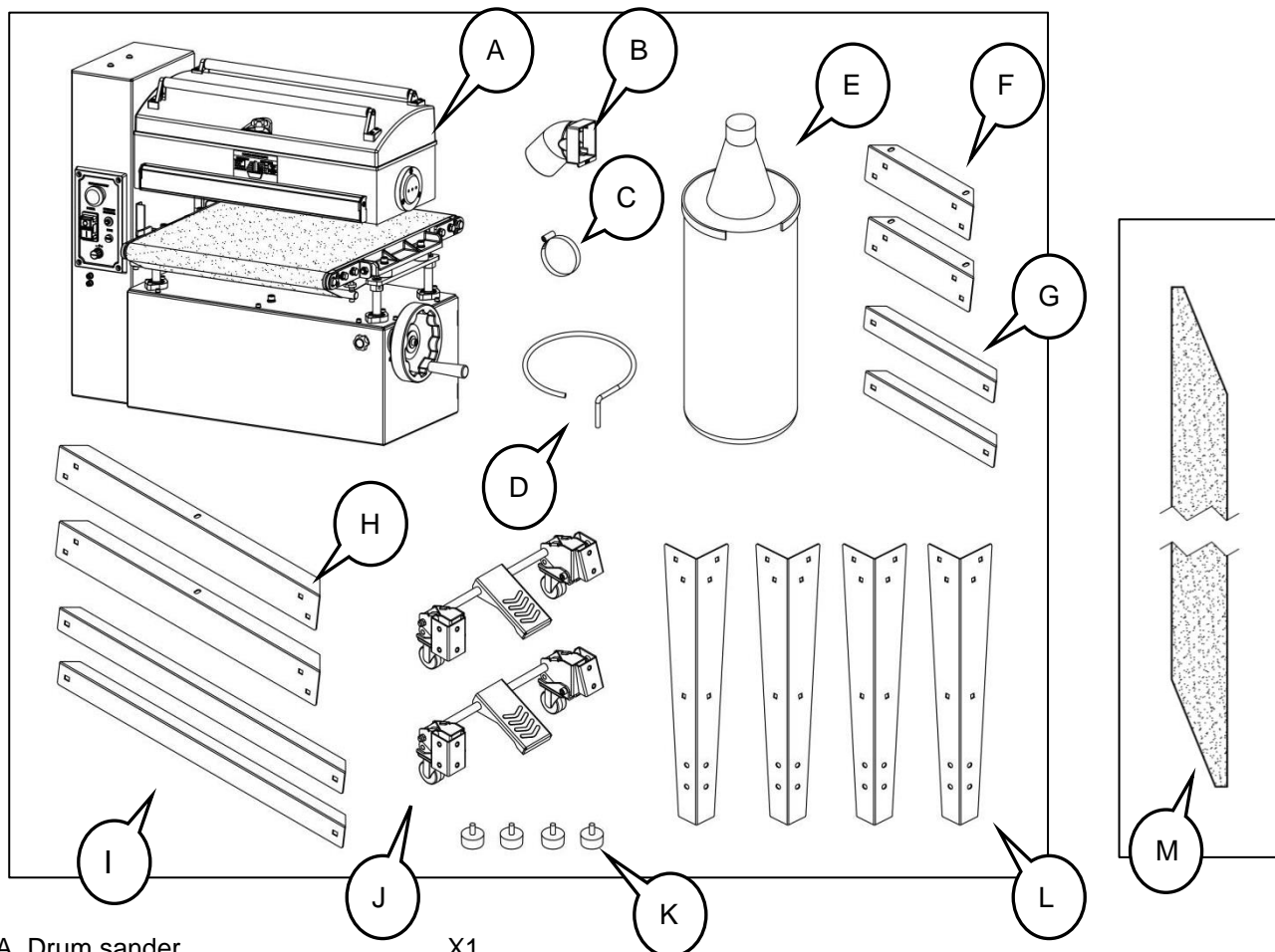
**USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord,

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 cause overheating.

**Be sure your extension cord is properly wired** and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it. Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

# PACKING BOX CONTENTS

## UNPACKING AND CHECKING CONTENTS



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. Carrier assembly	X2
K. Feet	X4
K. Legs	X4
M. Grinding sand belt (Grit 150)	X1
(This grinding sand belt is an optional accessory )	

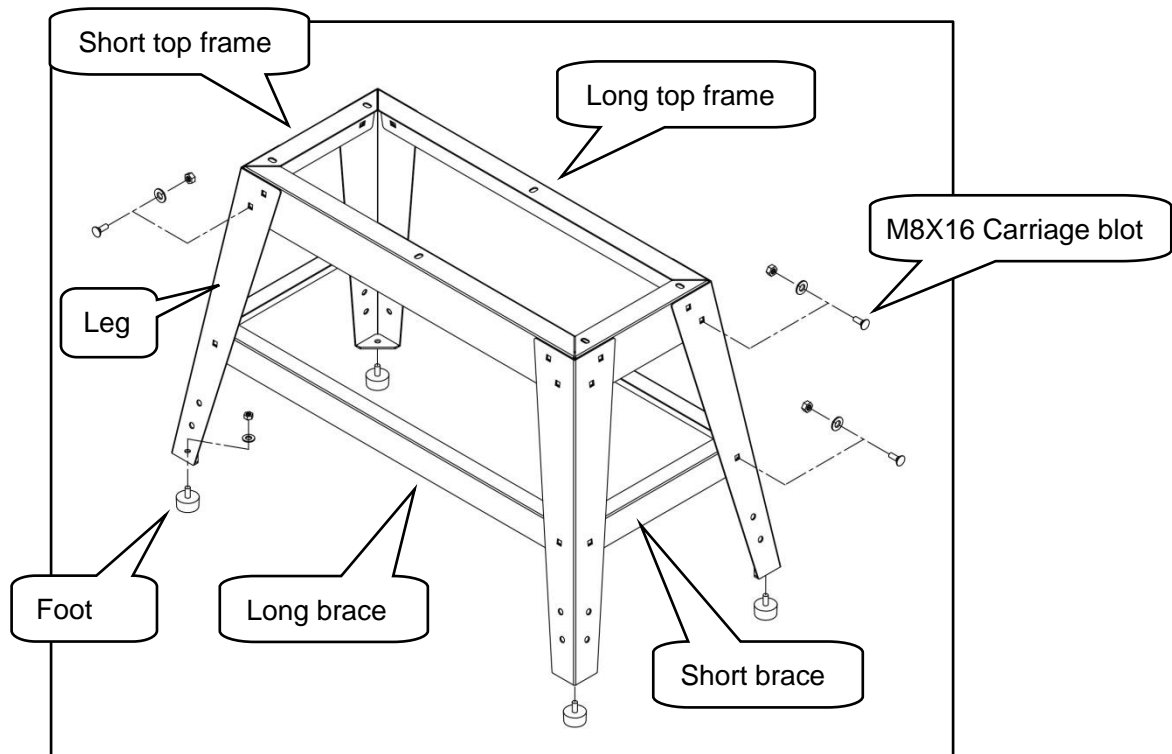
### Hardware bag(not shown)

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

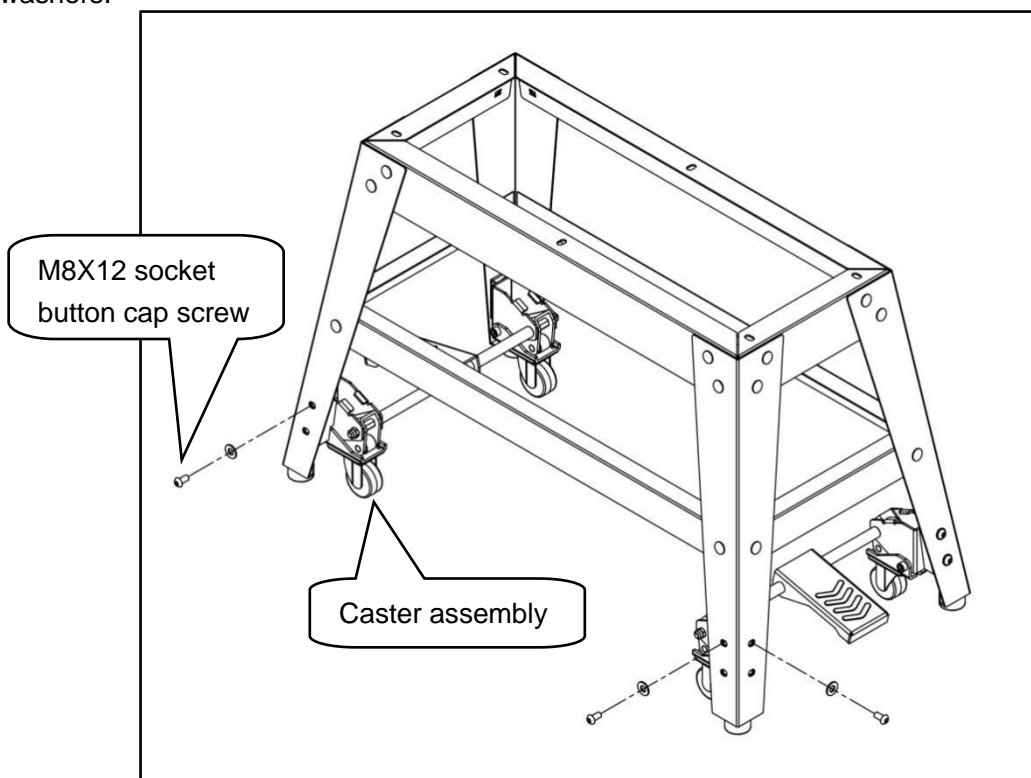
# ASSEMBLY

## Assemble the stand.

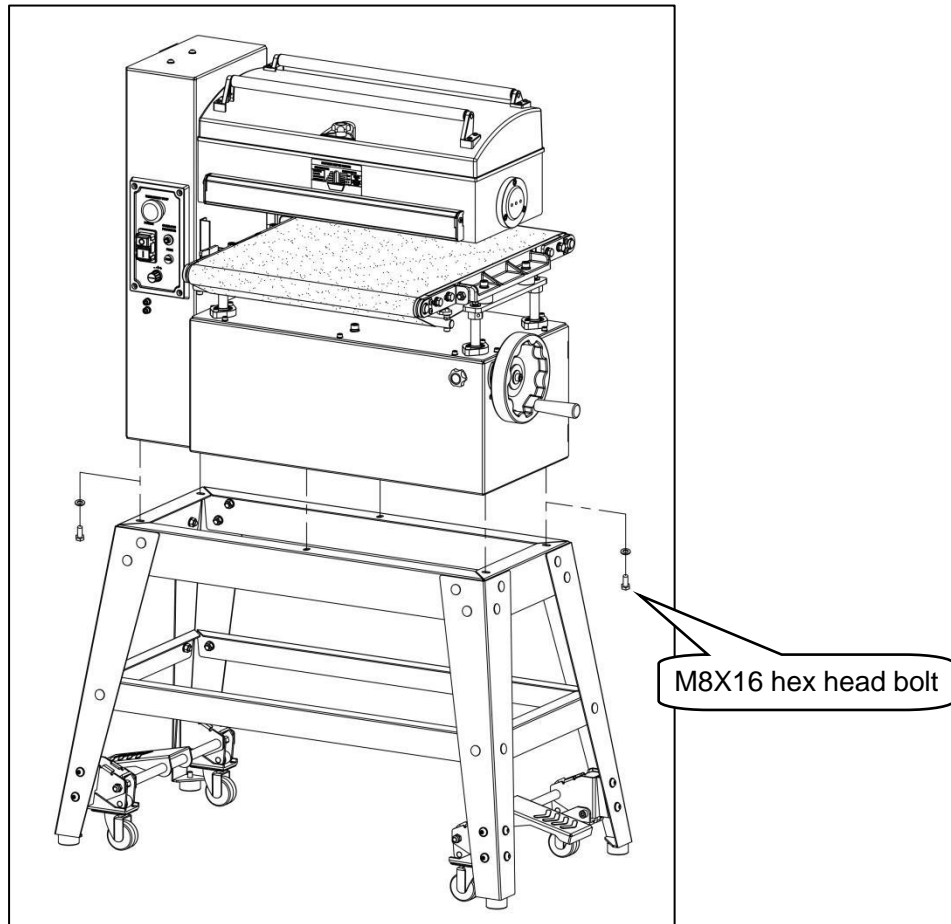
- 1. Assemble stand with M8x16 carriage bolts, 8mm flat washers and M8 hex nuts. Attach the four feet to the bottom of the leg and fix them by using 8mm flat washers and M8 hex nuts. Place the stand on a level ground, make sure there is no wobbling or tilting in the stand after fully tightening the nuts.



- 2. Attach the caster assembly into 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.



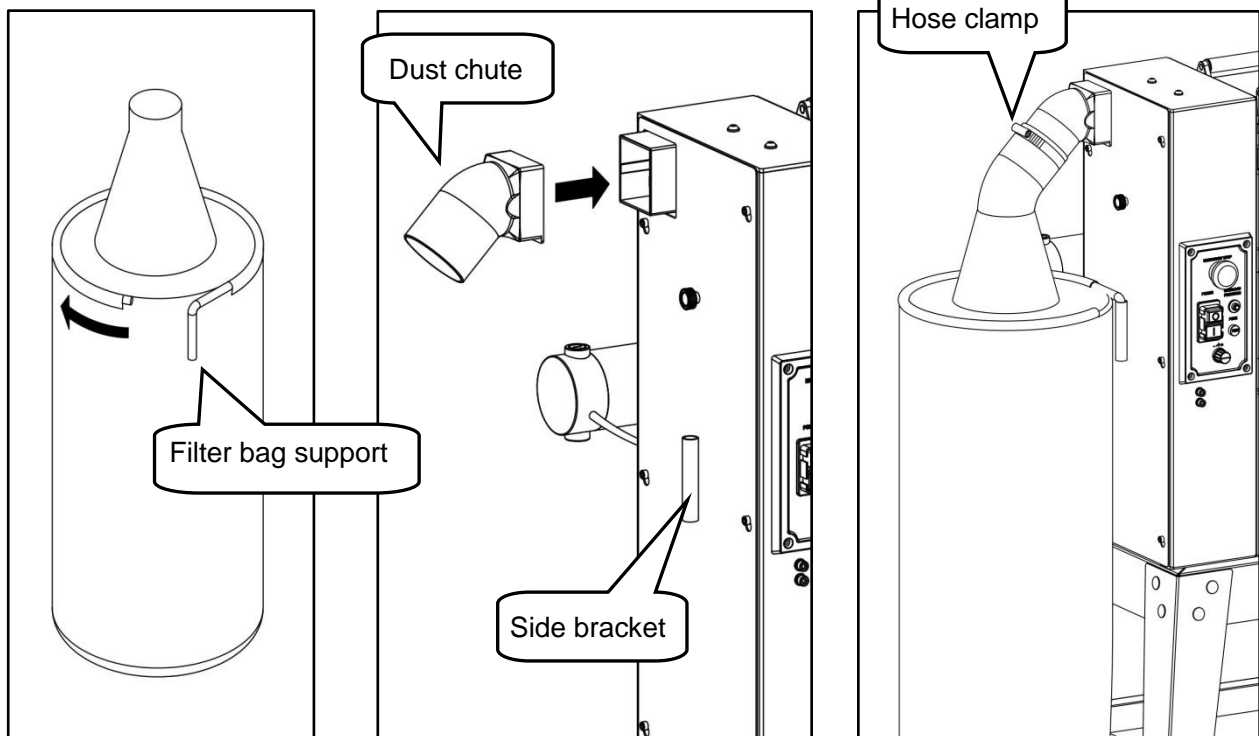
### Install the filter bag

Align the slot of the filter bag with the circular support and rotate it into place.

Attach the dust chute onto the dust export and push it deep enough.

Attach the filter bag and bag support onto the side bracket.

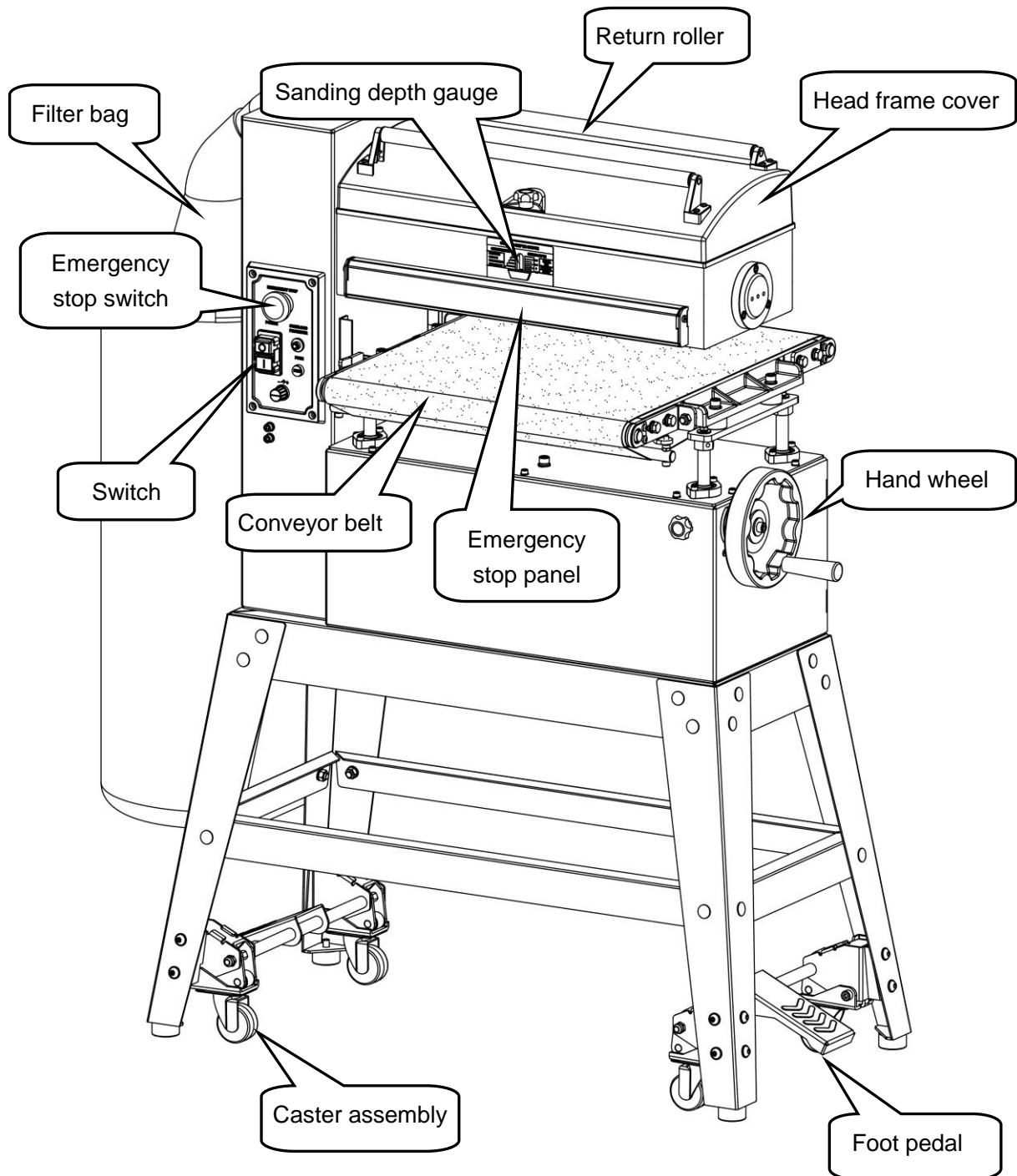
Connect the filter bag to the dust chute with the hose clamp.





## IDENTIFICATION

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





## ADJUSTMENTS

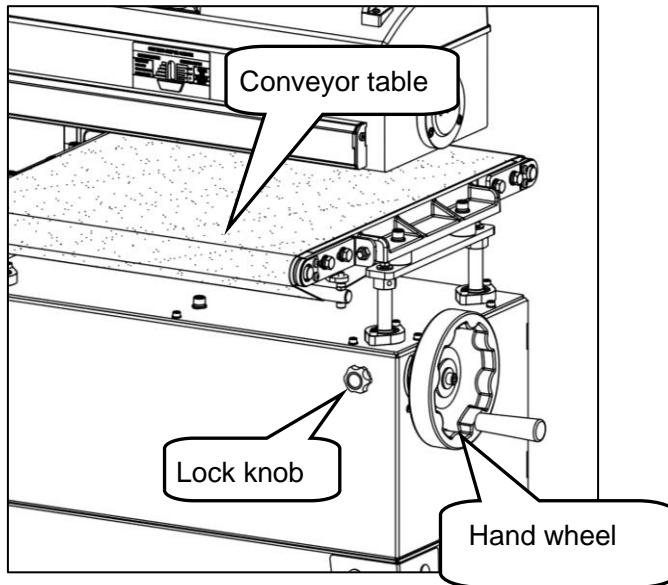
**Warning:** Turn off the machine and disconnect from the power supply before doing any adjustment.

### 1. Table adjustment

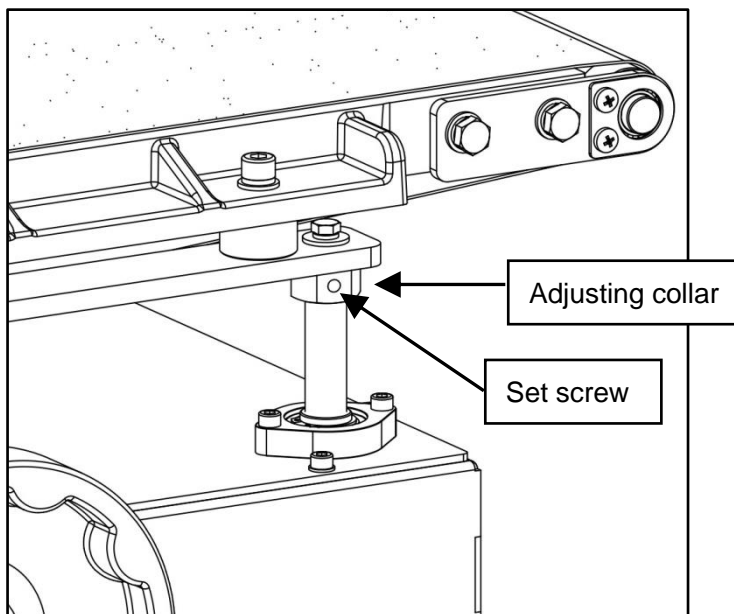
The height of the conveyor table can be adjusted by turning the hand wheel.

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.

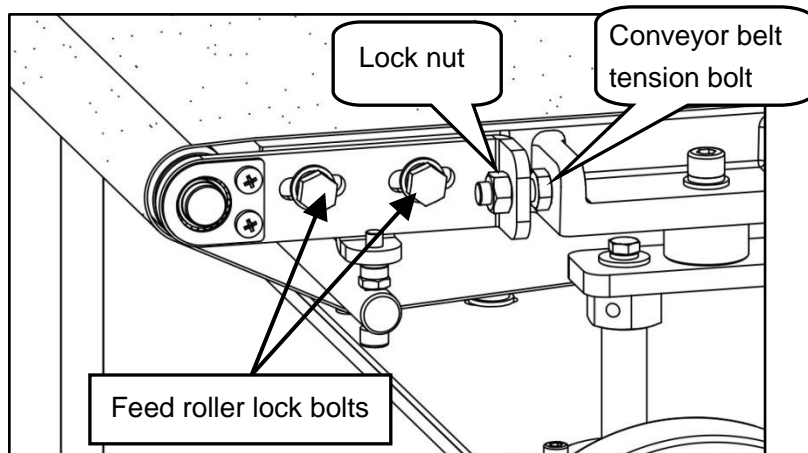
When you tension the conveyor belt, focus on adjusting the tensioning bolts in even increments. Adjusting one side more than the other will cause tracking problems.

### To tension conveyor belt:

1. Loosen feed roller lock bolts on both sides of 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.

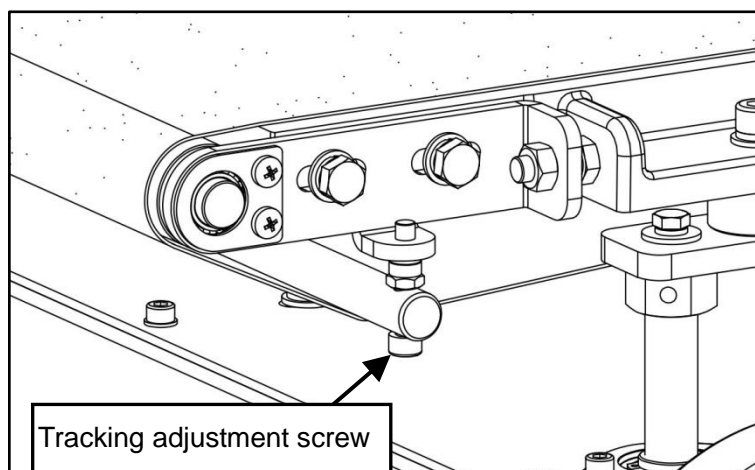
3. Tighten lock nuts to lock conveyor belt tensioning bolts in place.



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:

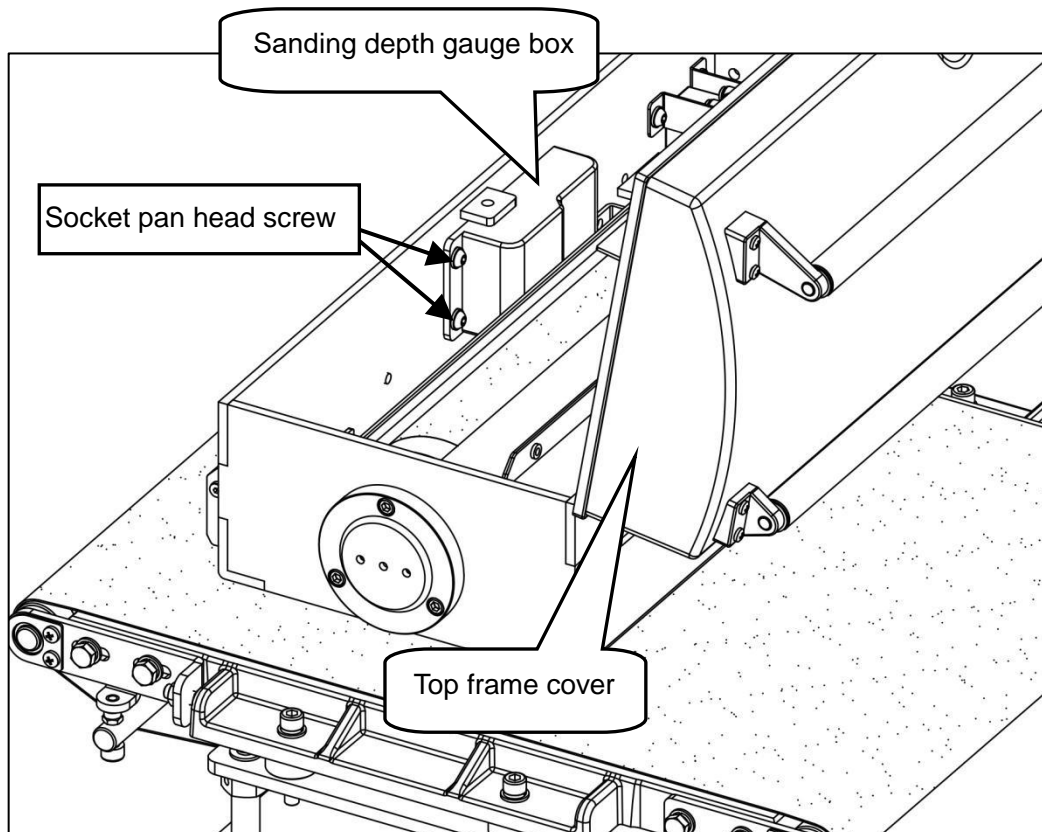
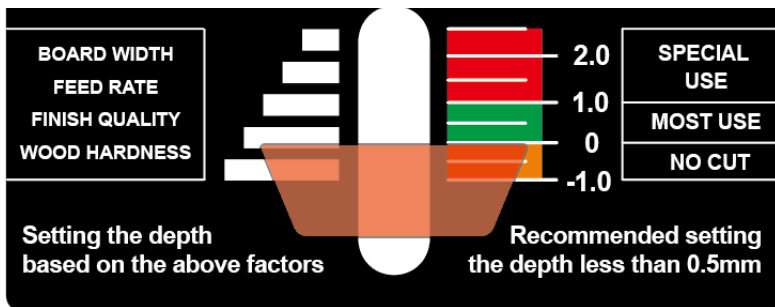
1. Turn conveyor belt ON and watch it track.
2. Tension tracking adjustment screw until conveyor belt tracks in opposite direction.
3. When conveyor belt is near the middle of the rollers or table, loosen tracking adjustment screw until feed belt stops moving and tracks straight. If conveyor belt tracks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



### 3. Sanding depth gauge adjustment

The optimum depth of cut will vary based on the type of wood, feed rate, board width, and finish quality. Attempts to remove too much material can cause jamming, wood burning, rapid paper wear or tearing, poor finish and motor overload.

Place a flat workpiece on the table, turn machine ON and feed workpiece into the sander. Slowly raise the table until workpiece makes light contact with sanding drum. After sanding, feed the workpiece into the machine again by not adjusting table height. Then turn the machine off and use the workpiece to check sanding depth gauge. The sanding depth gauge should indicating zero. If not, Open the top frame cover and loosen the three socket pan head screw and adjust the cutting depth gauge box to set the pointer indicating zero.



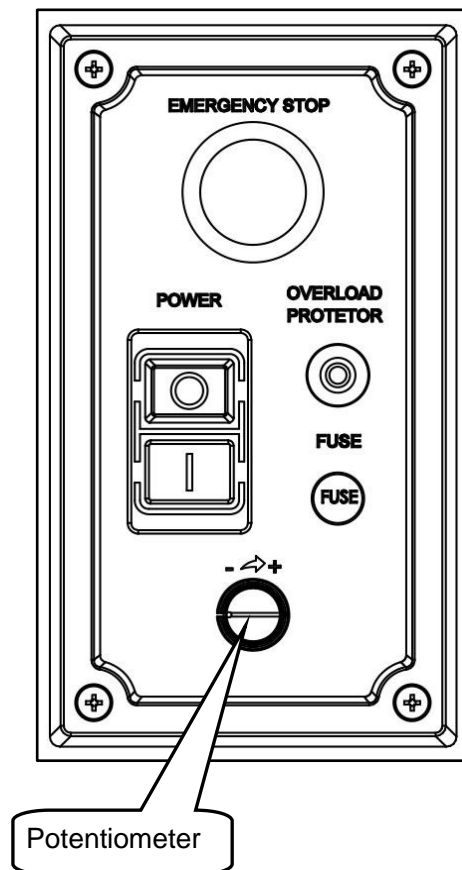
## 4. Feed rate adjustment

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.

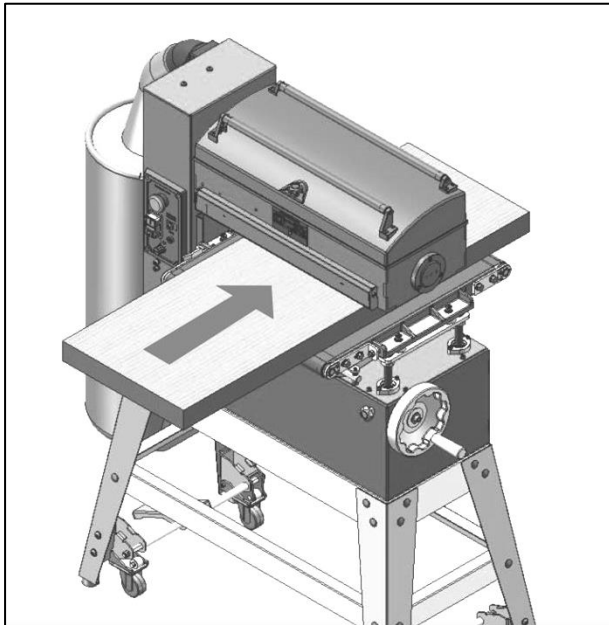


## OPERATION

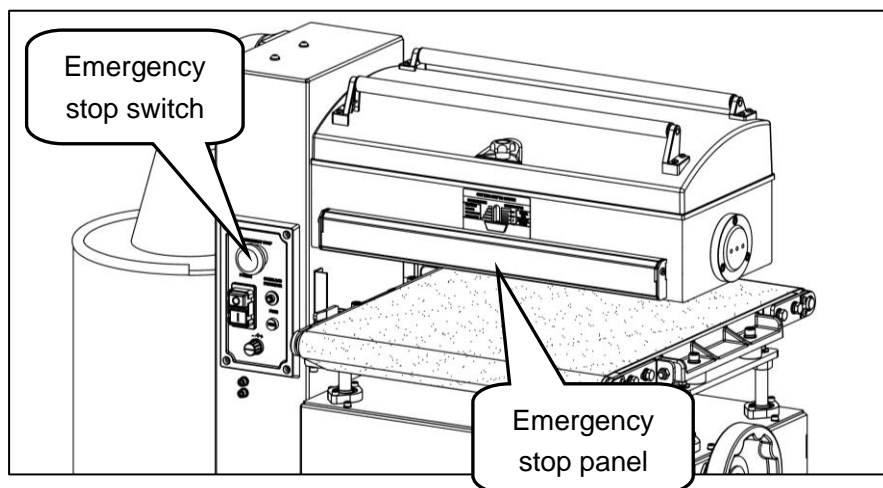
To complete a typical sanding operation, the operator does the following:

1. Examines workpiece to verify it is suitable for sanding and to determine which sanding belt grit size to use.
2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is wider than conveyor table, operator supports workpiece full width. If 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 sander by placing front end on infeed 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 outfeed side of conveyor table.
8. Raises height of conveyor table a small amount (typically 1/8-1/4 of a full rotation of handwheel), then repeats the feeding process of workpiece through sander.
9. Change sandpaper to a finer grit as needed.
10. Turns sander OFF, and disconnects it from power.



Note: If there is an unexpected situation and you need to stop the machine in an emergency, you can push the emergency stop switch or the emergency stop panel on the front side of the frame.



### 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 maximize 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

- 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 maximize stock removal and sandpaper effectiveness, but feed the workpiece straight to reduce sandpaper grit scratches for the finish passes.

## MAINTENANCE

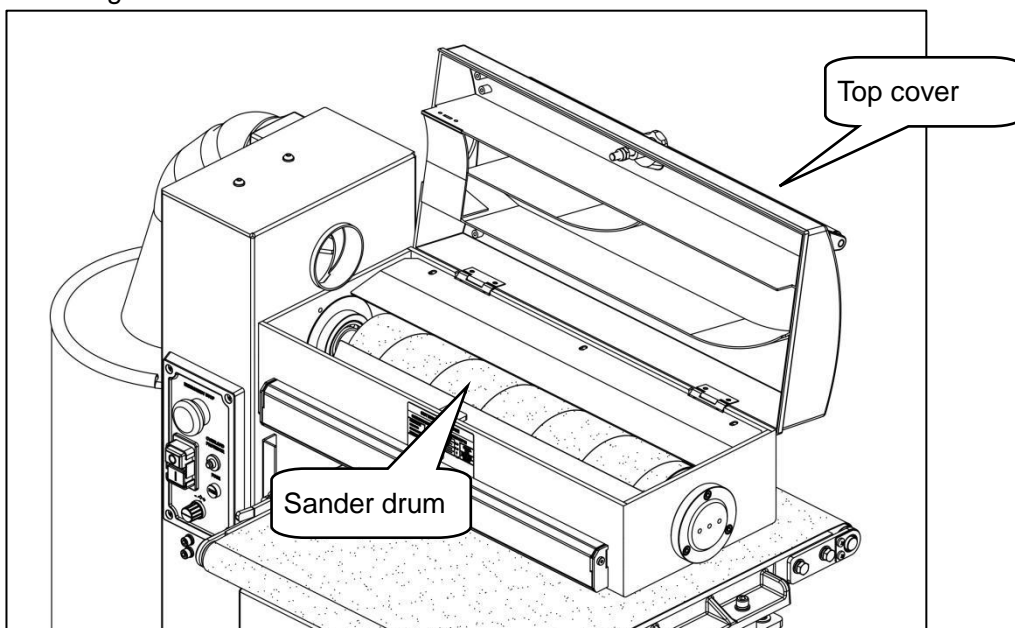
**Warning:** Turn off the machine and disconnect from the power supply before conducting maintenance work or settings.

### Replacing grinding sand belt

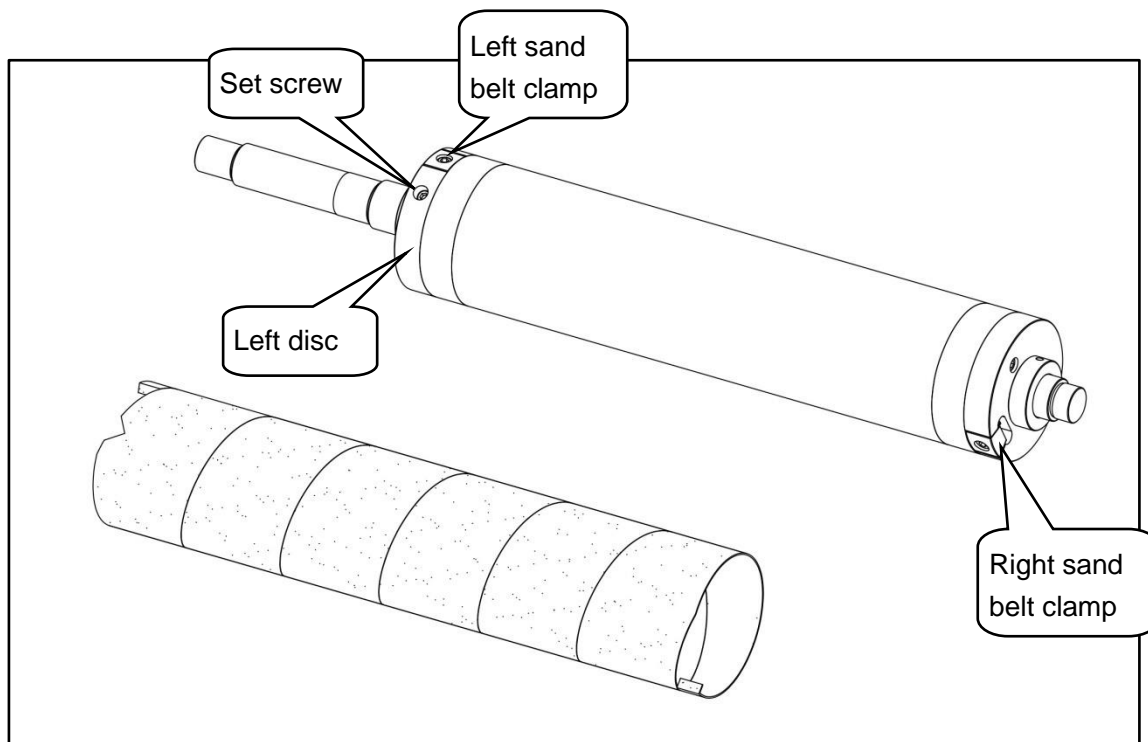
This drum sander is designed for 3" wide sand belt rolls

To change grinding sand belt:

1. DISCONNECT MACHINE FROM POWER!
2. Open top cover and loosen cap screw on sand belt clamps.
3. Remove the old grinding sand 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 to the tightest position, tighten the set screw to hold the left disc
5. Insert corner of new sand belt into right clamp and tighten cap screws
8. Wrap sand belt around drum ensuring there are no bubbles or over lapping edge
9. When sand belt reaches left side of drum, Place end of sandpaper into clamp, secure it.
10. Loosen the set screw release the left disc, make the sand belt tensioned automatically, Tighten the set screw again.





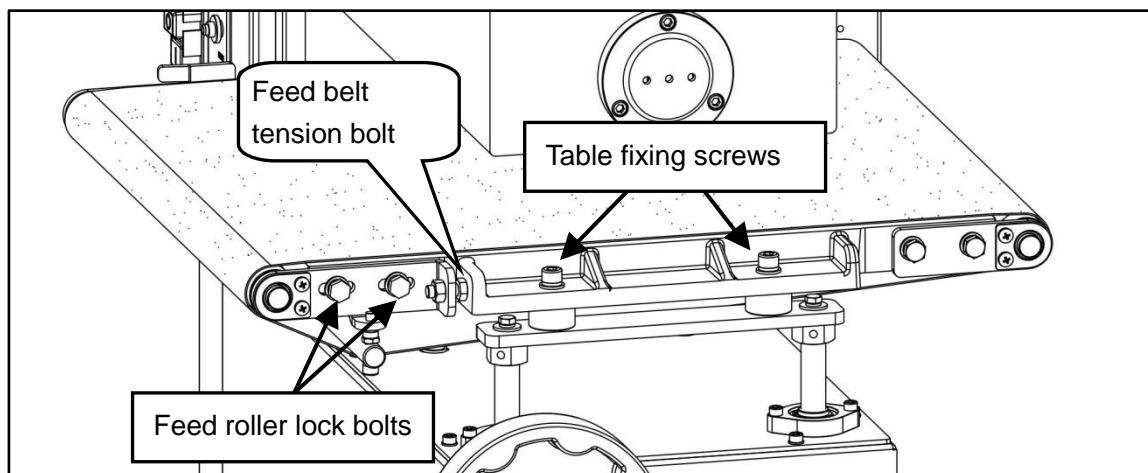


## Replacing Conveyor belt

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. Re-install and tighten all of the screws.





## Machine care

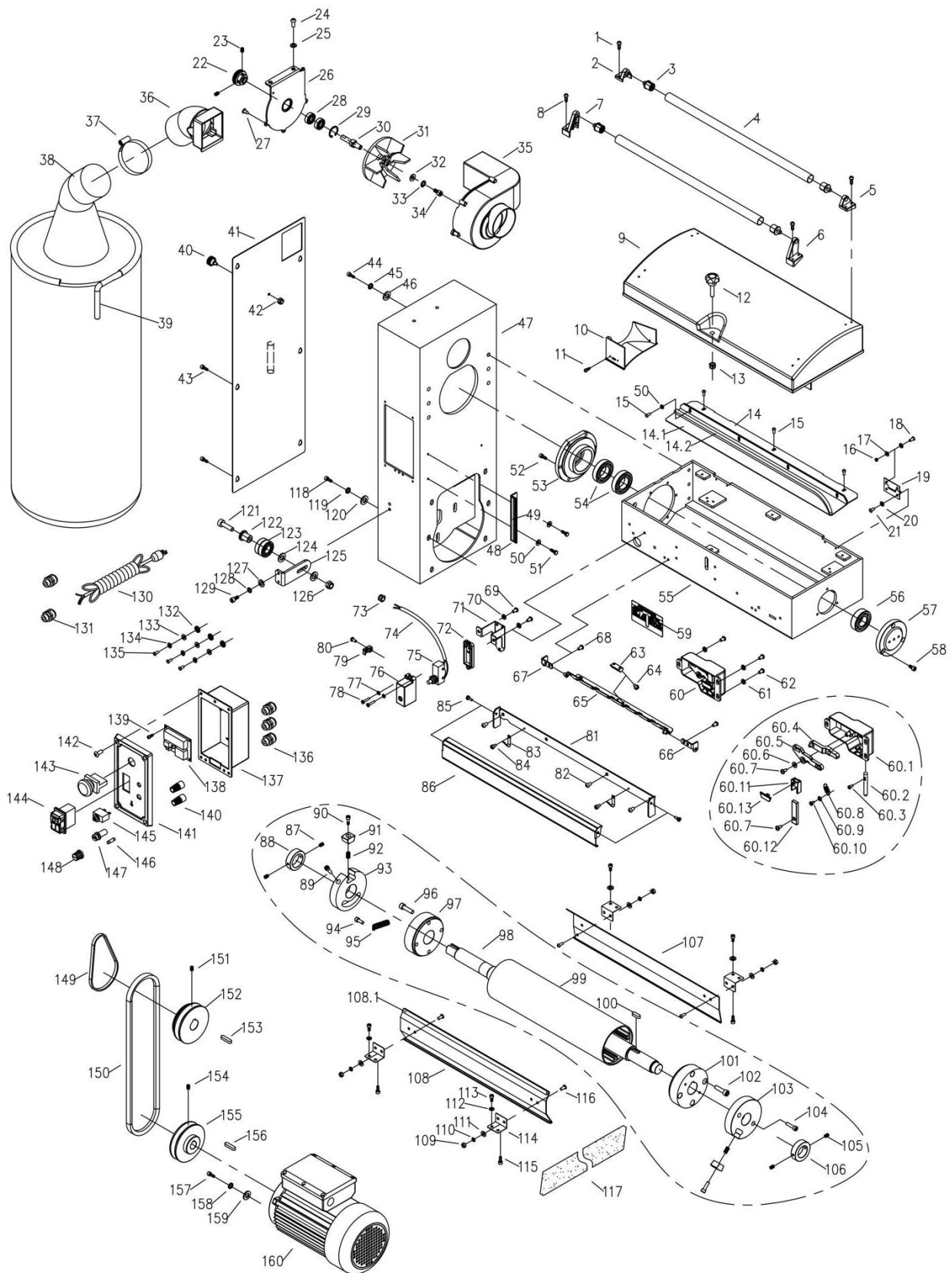
- Usually check the condition of the power supply cords and replace them if they are broken, or even worse if the internal wires are shown.
- Use a brush and a shop vacuum to remove chips and other debris from the machine.
- Always keep the machine handgrip clean to prevent accidental slipping during use.
- Clean/vacuum dust buildup 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.

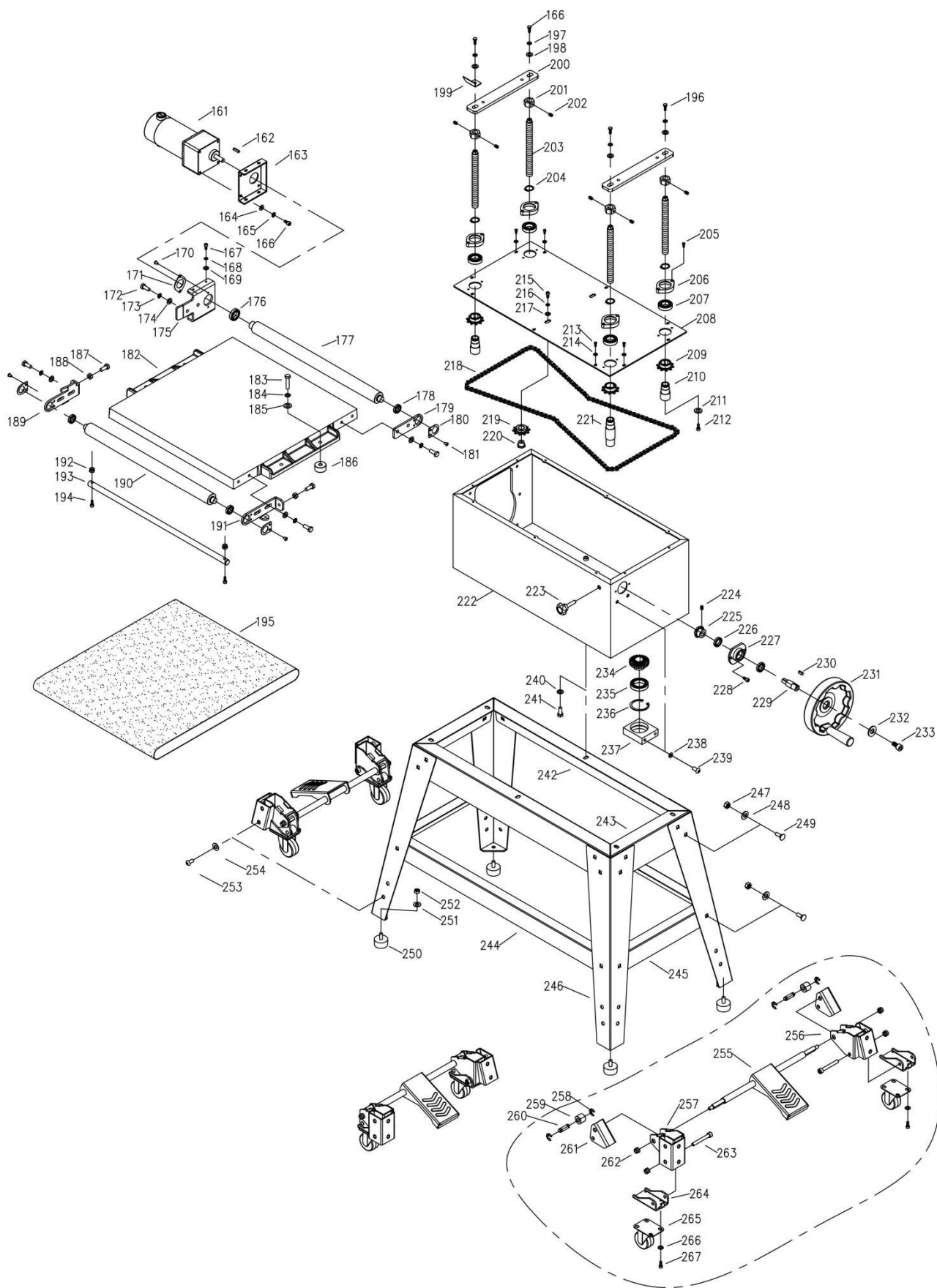
## TROUBLESHOOTING

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>● Specialized 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 rubbing noise when sanding drum is powered up.	<ul style="list-style-type: none"> <li>● Drum bearings are worn and need replacement.</li> </ul>	Replace drum bearings.
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 of sanding grit for depth of cut.</li> <li>● Grinding sand belt loaded with sawdust and gum</li> <li>● Feed rate too slow.</li> <li>● Grinding sand 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>

# ASSEMBLY DIAGRAM





# Parts List

1	4.2-1.4X19mm Thread forming screw	6
2	Rear plastic support A	1
3	Insert cap	4
4	Return roller	2
5	Rear plastic support B	1
6	Front plastic support A	1
7	Front plastic support B	1
8	4-1.2X14X28 Thread forming screw	2
9	Head frame cover	1
10	Plastic cover	1
11	3.5-1.3X9.5mm Thread forming screw	4
12	Knob	1
13	M8 Lock nut	1
14	Support base plate	1
14.1	Chip deflector plate	1
14.2	Sponge gasket	1
15	M5X10 Socket button head cap screw	7
16	M4 Hex nut	4
17	4mm Flat washer	8
18	M4X12 Pan head screw	4
19	Hinge	2
20	4mm Flat washer	4
21	M4X8 Pan head screw	4
22	Fan pulley	1
23	M6X8 Set screw	2
24	M6X16 Socket button head cap screw	2
25	6mm Flat washer	2
26	Mounting plate	1
27	3.5-1.3x13mm Thread forming screw	5
28	Ball bearing 6000-2RS	2
29	26mm Internal retaining ring	1
30	Fan shaft	1
31	Fan	1
32	6mm Flat washer	1
33	6mm Lock washer	1
34	M6X12 Socket head cap screw	1
35	Dust exhaust	1
35.1	Pin	1
36	Dust chute	1
37	Hose clamp	1
38	Filter bag	1
39	Filter bag support	1
40	Knob	1
41	Side cover	1
42	M5 Lock nut	1
43	M5X10 Socket head cap screw	6
44	M8X20 Socket head cap screw	6
45	8mm Lock washer	6
46	8mm Flat washer	6
47	Side cabinet	1
48	Scale plate	1
49	Height scale	1
50	5mm Flat washer	6
51	M5X10 Hex head bolt	2
52	M6X12 Socket head cap screw	6
53	Bearing house (Left)	1
54	Ball bearing 6006-2RS	2
55	Head frame	1

56	Ball bearing 6205-2RS	1
57	Bearing house (Right)	1
58	M6X12 Socket head cap screw	3
59	Depth scale label	1
60	Cutting depth indicator assembly	1
60.1	Mounting box	1
60.2	Joint rod	1
60.3	M4X6 Socket head cap screw	1
60.4	Rod connecting plate	1
60.5	Transition panel	1
60.6	4mm Flat washer	1
60.7	3.5-1.3X9.5mm Thread forming screw	2
60.8	Sring	1
60.9	3mm Flat washer	1
60.10	2.9-1x6.5 Thread forming screw	1
60.11	Sliding block	1
60.12	Guide plate	1
60.13	Depth pointer	1
61	6mm Flat washer	3
62	M6X10 Socket pan head screw	3
63	Rod connecting block	1
64	3.5-1.3X9.5mm Thread forming screw	2
65	Pointer trigger plate	1
66	Right support plate	1
67	Left support plate	1
68	M6X8 Socket pan head screw	4
69	M6X8 Socket pan head screw	2
70	6mm Flat washer	2
71	Micro switch supporting plate	1
72	Micro switch cover	1
73	Rubber bushing	1
74	Inner wire	1
75	Micro switch	1
76	Micro switch box	1
77	4mm Flat washer	3
78	M4X20 Pan head screw	3
79	Cord clamp	1
80	M5X12 Socket head cap screw	1
81	Stop panel base	1
82	M6X8 Socket pan head screw	4
83	Spring plate	2
84	M4X6 Socket head cap screw	2
85	Shoulder screw	2
86	Emergency stop panel	1
87	M6X8 Set screw	2
88	Left limiting collar	1
89	M6X20 Socket head cap screw	1
90	M6X20 Socket head cap screw	2
91	Belt locking block	2
92	Compression spring	2
93	Sanding belt clamp bracket (Left)	1
94	M6X12 Socket head cap screw	1
95	Belt tension spring	1
96	M8X35 Socket head cap screw	4
97	Left drum cover	1
98	Shaft	1
99	Belt drum	1
100	8X7X25mm Key	1

101	Right drum cover	1
102	M8X35 Socket head cap screw	4
103	Sanding belt clamp bracket (Right)	1
104	M6X20 Socket head cap screw	2
105	M6X8 Set screw	2
106	Right limiting collar	1
107	Rear pressure plate	1
108	Front pressure plate	1
108.1	Sponge gasket	1
109	M5 Hex nut	8
110	5mm Lock washer	8
111	5mm Flat washer	8
112	5mm Flat washer	8
113	M5X10 Socket head cap screw	8
114	Connecting plate	4
115	M5X10 Socket head cap screw	4
116	M5X10 Socket button head cap screw	8
117	Grinding Sand belt	1
118	M8X20 Socket head cap screw	6
119	8mm Lock washer	6
120	8mm Flat washer	6
121	M8X40 Socket head cap screw	1
122	Bushing	1
123	Ball bearing 6003-2RS	2
124	8mm Flat washer	2
125	Support plate	1
126	M8 Lock nut	1
127	6mm Flat washer	2
128	6mm Lock washer	2
129	M6X12 Socket head cap screw	2
130	Power cord	1
131	Strain relief	2
132	5mm Serrated washer	3
133	5mm Flat washer	3
134	5mm Lock washer	3
135	M5X12 Pan head screw	3
136	Strain relief	3
137	Switch box	1
138	DC motor driver	1
139	2.9-1x9.5 Thread forming screw	4
140	Terminal	2
141	Switch mounting plate	1
142	M5X12 Pan head screw	4
143	Emergency stop	1
144	Switch	1
145	Overload protector	1
146	Fuse	1
147	Fuse holder	1
148	Potentiometer knob	1
149	Fan belt	1
150	Drive belt	1
151	M6X8 Set screw	1
152	Shaft pulley	1
153	8X7X25mm Key	1
154	M6X8 Set screw	1
155	Motor pulley	1
156	6X6X30mm Key	1
157	M8X20 Socket head cap screw	4

158	8mm Lock washer	4
159	8mm Flat washer	4
160	Motor	1
161	DC motor	1
162	4X4X25mm Key	1
163	DC motor mounting plate	1
164	6mm Flat washer	4
165	6mm Lock washer	4
166	M6X12 Socket head cap screw	6
167	M5X16 socket head cap screw	4
168	5mm Lock washer	4
169	5mm Flat washer	4
170	M5X10 Socket button head cap screw	2
171	Bearing cover	1
172	M8X20 Hex head bolt	8
173	8mm Lock washer	8
174	8mm Flat washer	8
175	Rear feed roller bracket (Left)	1
176	Ball bearing 61804-2RS	1
177	Rear feed roller	1
178	Ball bearing 61802-2RS	3
179	Rear feed roller bracket (Right)	1
180	Bearing cover	3
181	M5X10 Socket button head cap screw	6
182	Table	1
183	M8X40 Socket head cap screw	4
184	8mm Lock washer	4
185	8mm Flat washer	4
186	Spacer bushing	4
187	M8X25 Hex head bolt	2
188	M8 Hex nut	2
189	Front feed roller bracket (Left)	1
190	Front feed roller	1
191	Front feed roller bracket (Right)	1
192	M6 Lock nut	2
193	Adjusting rod	1
194	M6X35 Socket head cap screw	2
195	Conveyor belt	1
196	M6X12 Hex head bolt	2
197	6mm Lock washer	4
198	6mm Flat washer	4
199	Pointer	1
200	Steel bar	2
201	Adjusting collar	4
202	M6X6 Set screw	8
203	Elevation screw	4
204	20mm External retaining ring	4
205	M5X16 socket head cap screw	8
206	Bearing seat	4
207	Ball bearing 61904-2RS	4
208	Base cover plate	1
209	Sprocket	4
210	Elevation nut	3
211	6mm Flat washer	1
212	M6X12 Socket head cap screw	1
213	M5X10 Socket head cap screw	10
214	5mm Flat washer	10
215	M8X16 Socket head cap screw	2

216	8mm Lock washer	2
217	8mm Flat washer	2
218	Chain	1
219	Idle sprocket	2
220	Support rod	2
221	Elevation nut	1
222	Base	1
223	Lock knob	1
224	M6X8 Set screw	1
225	Bevel gear (15T)	1
226	Ball bearing 61803-2RS	2
227	Support bracket	1
228	M5X16 socket head cap screw	2
229	Shaft	1
230	5X5X16mm KEY	1
231	Hand wheel	1
232	8mm Flat washer	1
233	M8X16 Socket head cap screw	1
234	Bevel gear (25T)	1
235	Ball bearing 61906-2RS	1
236	47mm Internal retaining ring	1
237	Bearing support block	1
238	8mm Flat washer	2
239	M8X12 Socket button head cap screw	2



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**

**01/01/2025**

**The Director**

