



2" X 42" BELT & 8" DISC SANDER



MODEL: KC-770FX

INSTRUCTION MANUAL

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WARRANTY INFORMATION



**2-YEAR
LIMITED WARRANTY
FOR THIS BELT AND DISC SANDER**

**KING CANADA TOOLS
OFFERS A 2-YEAR LIMITED WARRANTY
FOR NON-COMMERCIAL USE.**

PROOF OF PURCHASE

Please keep your dated proof of purchase for warranty and servicing purposes.

REPLACEMENT PARTS

Replacement parts for this product are available at our authorized King Canada service centers across Canada. Please use the 10 digit part numbers listed in this manual for all part orders where applicable.

LIMITED TOOL WARRANTY

King Canada makes every effort to ensure that this product meets high quality and durability standards. King Canada warrants to the original retail consumer a 2-year limited warranty as of the date the product was purchased at retail and that each product is free from defects in materials. Warranty does not apply to defects due directly or indirectly to misuse, abuse, normal wear and tear, negligence or accidents, repairs done by an unauthorized service center, alterations and lack of maintenance. King Canada shall in no event be liable for death, injuries to persons or property or for incidental, special or consequential damages arising from the use of our products.

To take advantage of this limited warranty, return the product at your expense together with your dated proof of purchase to an authorized King Canada service center. Contact your retailer or visit our web site at www.kingcanada.com for an updated listing of our authorized service centers. In cooperation with our authorized service center, King Canada will either repair or replace the product if any part or parts covered under this warranty which examination proves to be defective in workmanship or material during the warranty period.

NOTE TO USER

This instruction manual is meant to serve as a guide only. Specifications and references are subject to change without prior notice.

KING CANADA INC. DORVAL, QUÉBEC, CANADA H9P 2Y4

www.kingcanada.com



SAFETY INSTRUCTIONS FOR YOUR BELT AND DISC SANDER

SAFETY INSTRUCTIONS FOR BELT AND DISC SANDER

Safety is a combination of common sense, staying alert and knowing how your belt disc sander works. Read this manual to understand this sander.

BEFORE USING THE SANDER

WARNING: To avoid mistakes that could cause serious, permanent injury, do not plug sander in until the following is understood.

- Assembly and alignment.
- Learn the use and function of the ON-OFF switch, belt tracking, work tables and work table tilt lock knobs.
- Review and understanding of all safety instructions and operating procedures in this manual.
- Review of the maintenance methods for this sander.

WHEN INSTALLING OR MOVING THE SANDER

AVOID DANGEROUS ENVIRONMENT. Use the sander in a dry, indoor place protected from rain. Keep work area well lighted. Place the sander so neither the user nor bystander are forced to stand in line with the abrasive belt or disc.

To avoid injury from unexpected sander movement:

- Always unplug the sander before moving it.
- Put the sander on a firm level surface where there is plenty of room for handling and properly supporting the workpiece.
- Support the sander so it does not rock.
- Bolt the sander to a work surface.
- **NEVER STAND ON TOOL.** Serious injury could occur if the tool tips. Do not store anything above or near the tool where anyone might stand on the tool to reach them.

BEFORE EACH USE:

Inspect your sander.

DISCONNECT THE SANDER. To avoid injury from accidental starting, unplug the sander, turn the switch off and remove the switch key before changing the setup, sanding disc or belt or adjusting anything.

CHECK DAMAGED PARTS, Check for:

- Alignment of moving parts
- Binding of moving parts
- Broken parts
- Work parts that cause a gap larger than 1/16" between work support and sanding surface.

- Sanding belt narrower than 1". Narrower belts uncover parts that could trap your fingers,
- Worn or damaged electric cords,
- stable mounting, and
- Any other conditions that may affect the way the sander works.

If any part is missing, bent, or broken in any way, or any electrical parts don't work properly, turn the sander off and unplug the sander. REPLACE damaged, missing or failed parts before using the sander again.

MAINTAIN TOOLS WITH CARE. Keep the sander clean for best and safest performance.

REMOVE ADJUSTING KEYS AND WRENCHES from tool before turning it on.

To avoid injury from jams, slips or thrown pieces:

- **USE ONLY RECOMMENDED ACCESSORIES.** The use of improper accessories may cause risk of injury to person.
- Adjust any work support to clear the sanding surface by no more 1/16".
- Make sure all lock handles are tight and no parts have excessive play.
- **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents. Floor must not be slippery.

To avoid burns or other fire damage, never use the sander near flammable liquids, vapors or gases.

PLAN AHEAD TO PROTECT YOUR EYES, HANDS, FACE, EARS. **KNOW YOUR SANDER.** Read and understand the instruction manual and labels affixed to the tool. Learn its application and limitations as well as the specific potential hazards related to it.

To avoid injury from accidental contact with moving parts:

- Don't do layout, assembly, or setup work on the sander while any parts are moving.
- **AVOID ACCIDENTAL STARTING.** Make sure switch is "OFF" before plugging sander into a power outlet.

Plan your work.

SAFETY INSTRUCTIONS FOR YOUR BELT AND DISC SANDER



USE THE RIGHT TOOL. Don't force tool or attachment to do a job it was not designed to do.

CAUTION: This machine is not designed for heavy deburring operations. When finishing metals, sparks or hot fragments could cause a fire. To avoid this:

- **Disconnect any dust collecting hose from the sander.**
- **Remove all traces of wood dust from the sander.**
- **Remove all traces of metal dust from the sander before sanding wood again. Never switch from one type of metal or any other material without first properly cleaning out the inside of the disc/belt housings, as they could ignite and cause a fire.**

Dress for safety.

Any power sanders can throw foreign object into eyes. This can cause permanent eye damage. Everyday eyeglasses have only impact resistant lenses. They are not safety glasses. Safety glasses are available.

- Do not wear loose clothing, gloves, neckties or jewelry (rings, wrist, watches). They can get caught and draw your fingers into moving parts.

Safety instructions for belt and disc sander:

- Wear nonslip footwear.
- Tie back long hair.
- Roll long sleeve above the elbow.
- Noise levels vary widely. To avoid possible hearing damage, wear ear plugs or muffs when using sander for hours at a time.
- Sanding operations are usually dusty. Wear a dust mask along with the safety glasses.

Inspect your workpiece.

Make sure there are no nails or foreign objects in the part of the workpiece to be sanded.

Plan your work to avoid **THROWBACKS** - when the workpiece catches on the sanding belt or disc and torn from your hands.

- Make sure there's no debris between the workpiece and its supports.
- When sanding irregularly shaped workpieces, plan your work support so it will not slip and be pulled from your hands.
- Use extra caution with large, very small or awkward workpieces.
- Never use this tool to finish pieces too small to hold by hand.
- Use extra supports (tables, saw horses, blocks etc.) for any workpieces large enough to tip when not held down to the table top.

- NEVER use another person as a substitute for a table extension, or as additional support for a workpiece that is longer or wider than the basic sander table, or to help feed, support, or pull the workpiece.
- When finishing on the disc, always press the workpiece against the "Down" side of the disc. Sanding against the side coming up from under the table could damage the work by making it chatter, or tear the work from your hands and throw it.
- Sand only one workpiece at a time.
- Clear everything except the workpiece and related support devices off the table before turning the sander on.

Plan the way you will hold the workpiece from start to finish.

Avoid awkward operations and hand positions where a sudden slip could cause fingers or hand to move into a sanding surface. Keep the fingers away from where the belt goes into the dust trap.

DON'T OVERREACH. Keep good footing and balance. Keep your face and body to one side, out of line with a possible throwback.

WHENEVER SANDER IS RUNNING

WARNING: Don't let familiarity (gained from frequent use of your belt and disc sander) cause a careless mistake. A careless fraction of a second is enough to cause a severe injury. Before starting your work, watch the sander while it runs. If it makes an unfamiliar noise or vibrates a lot, stop immediately. Turn the sander off. Unplug the sander. Do not restart until finding and correcting the problem. Make sure the sanding disc turns counterclockwise before using the sander.

KEEP CHILDREN AWAY. Keep all visitors a safe distance from the sander. Make sure bystanders are clear of the sander and workpiece.

DON'T FORCE TOOL. It will do better and safer job at its designed rate. Press the workpiece against the sanding material only hard enough to let it sand without bogging down or binding.

Before freeing any jammed material:

- Turn switch "OFF"
- Unplug the sander.
- Wait for all moving parts to stop.

BEFORE LEAVING THE SANDER:

NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. Don't leave until it comes to a complete stop.

MAKE WORKSHOP CHILD-PROOF. Lock the shop. Disconnect master switches. Remove the yellow switch key. Store it away from children and others not qualified to use the tool.



ELECTRICAL INFORMATION

WARNING

ALL ELECTRICAL CONNECTIONS MUST BE DONE BY A QUALIFIED ELECTRICIAN. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY! ALL ADJUSTMENTS OR REPAIRS MUST BE DONE WITH THE COMPRESSOR DISCONNECTED FROM THE POWER SOURCE. FAILURE TO COMPLY MAY RESULT IN SERIOUS INJURY!

POWER SUPPLY

WARNING: YOUR SANDER MUST BE CONNECTED TO A 120V WALL OUTLET, WITH A MINIMUM 15-AMP. BRANCH CIRCUIT AND USE A 15-AMP TIME DELAY FUSE OR CIRCUIT BREAKER. FAILURE TO CONNECT IN THIS WAY CAN RESULT IN INJURY FROM SHOCK OR FIRE.

GROUNDING

Your sander must be properly grounded. Not all outlets are properly grounded. If you are not sure if your outlet is properly grounded, have it checked by a qualified electrician.

WARNING: IF NOT PROPERLY GROUNDED, THIS SANDER CAN CAUSE ELECTRICAL SHOCK, PARTICULARLY WHEN USED IN DAMP LOCATIONS. TO AVOID SHOCK OR FIRE, IF THE POWER CORD IS WORN OR DAMAGED IN ANY WAY, HAVE IT REPLACED IMMEDIATELY.

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

WARNING: TO MAINTAIN PROPER GROUNDING, DO NOT REMOVE OR ALTER THE GROUNDING PRONG IN ANY MANNER.

120V OPERATION

As received from the factory, your sander is ready to run for 120V operation. This machine is intended for use on a circuit that has an outlet and a plug which looks like the one illustrated in Fig.1A.

WARNING: DO NOT USE A TWO-PRONG ADAPTOR(S) FOR THEY ARE NOT IN ACCORDANCE WITH LOCAL CODES AND ORDINANCES. NEVER USE IN CANADA.

EXTENSION CORDS

The use of any extension cord will cause some loss of power. If you do not have a choice, use the table in Fig.1B to determine the minimum wire size (A.W.G-American Wire Gauge) extension cord needed. Use only 3-wire extension cords which have 3-prong grounding type plugs and 3-hole receptacles which accept the tool's plug.

For circuits that are further away from the electrical circuit box, the wire size must be increased proportionately in order to deliver ample voltage to the sander motor. Refer to Fig.1B for wire length and size.

USING ON/OFF SWITCH WITH REMOVABLE SAFETY KEY

The On/Off switch (A) Fig.2 is used to turn the sander on and off. To turn the sander "On", move the switch upwards (On position), to turn the sander "Off", move the switch downwards (Off position).

This switch comes with a removable safety key (B) Fig.2. When the safety key is removed from the switch and placed in a safe location, unauthorized persons or children can't turn the switch to the On position. It is recommended to always remove the safety key from the switch whenever the sander is not in use. To remove the safety switch, make sure the switch is in the Off position and simply pull out the safety key.

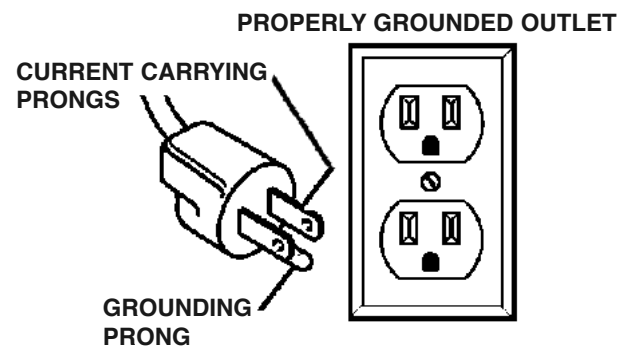


Figure 1A

<u>LENGTH OF CONDUCTOR</u>	<u>WIRE SIZES REQUIRED (AMERICAN WIRE GAUGE)</u>
	<u>110V LINES</u>
0-25 FEET	NO.14
26-50 FEET	NO.12
51-100 FEET	Not recommended

Figure 1B

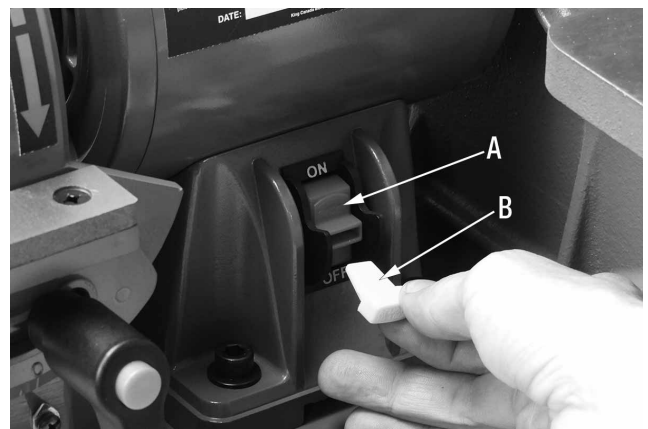
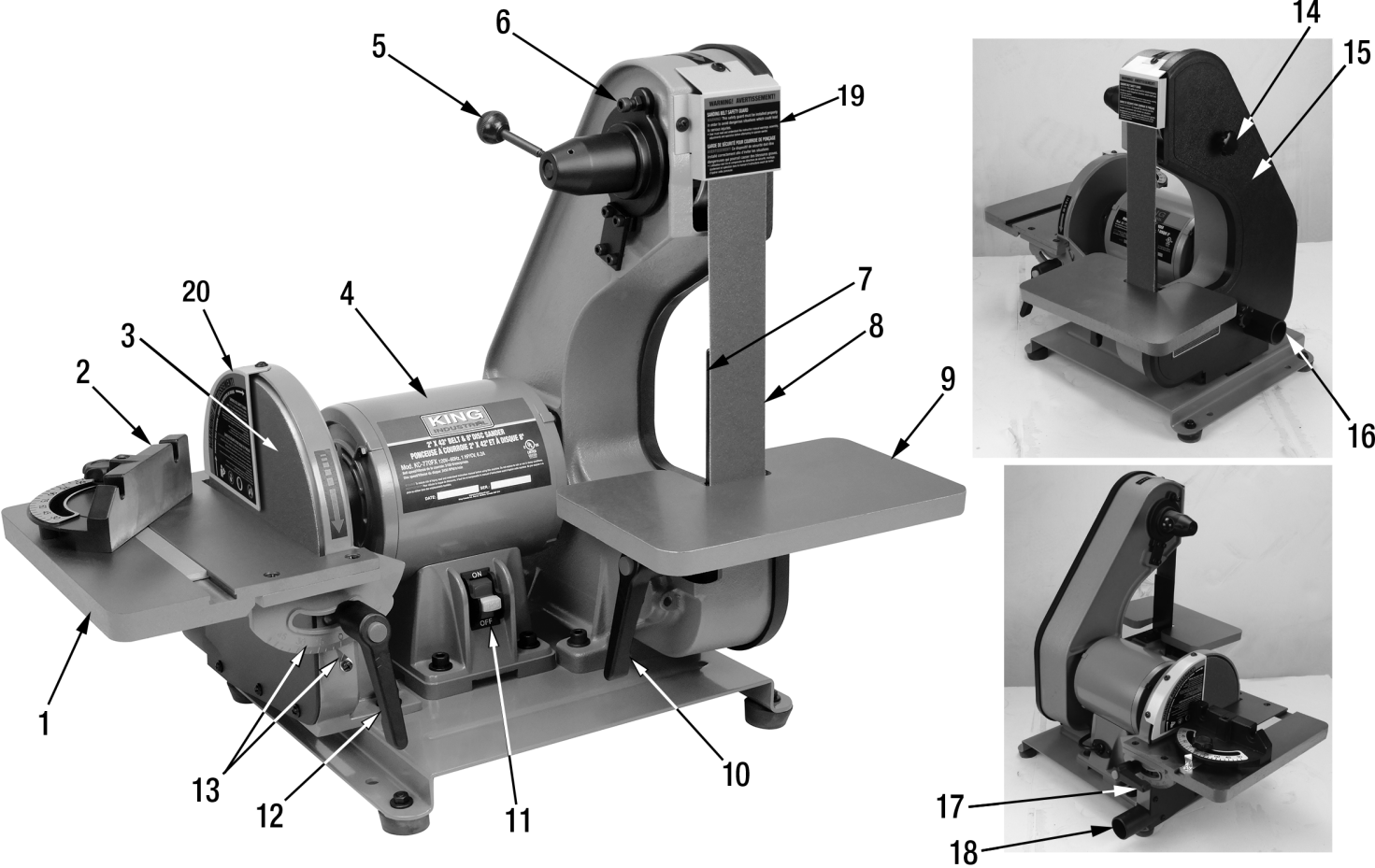


Figure 2

GETTING TO KNOW YOUR BELT & DISC SANDER



Getting to know your Belt & Disc Sander

- | | |
|---|--|
| 1. Disc tilting table with T-slot. | 11. On/Off switch with removable safety key. |
| 2. T-slot miter gauge. | 12. Front disc table lock handle. |
| 3. Aluminum disc with 8" adhesive sanding disc. | 13. Disc table tilt scale and angle indicator. |
| 4. Motor. | 14. Belt cover lock knob (1 of 2). |
| 5. Quick release sanding belt tension lever. | 15. Belt cover. |
| 6. Belt tracking adjustment screw. | 16. Sanding belt dust chute (1-1/2"). |
| 7. Sanding belt platen (2" platen installed). | 17. Rear disc table lock handle. |
| 8. 2" x 42" sanding belt (installed). | 18. Sanding disc dust chute (1-1/2"). |
| 9. Belt tilting table. | 19. Sanding belt safety guard. |
| 10. Belt table lock handle. | 20. Sanding disc safety guard. |

SPECIFICATIONS

Model	KC-770FX
Belt	1" x 42" & 2" x 42"
Belt speed.....	3,100 SFPM
Disc	8"
Disc speed.....	3450 RPM
Motor	6.2 Amp.
Voltage	120V, 1 phase, 60 Hz
Dimensions/weight	22-3/8" x 19-1/2" x 20-1/2" / 61 lbs



ASSEMBLY

UNPACKING

Clean all rust protected surfaces with ordinary house hold type grease or spot remover. Do not use gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces. Apply a coat of paste wax to the tables to prevent rust. Wipe all parts thoroughly with a clean dry cloth.

MOUNTING BELT AND DISC SANDER TO WORKBENCH

If the belt and disc sander is to be used in a permanent location, it should be fastened securely to a firm supporting surface such as a workbench (hardware not included).

If mounting to a workbench, use the provided holes (A) Fig.3 in the base for mounting and holes should be drilled through supporting surface of the workbench.

The belt and disc sander can also be clamped directly to a workbench using two or more "C" clamps on base of unit.

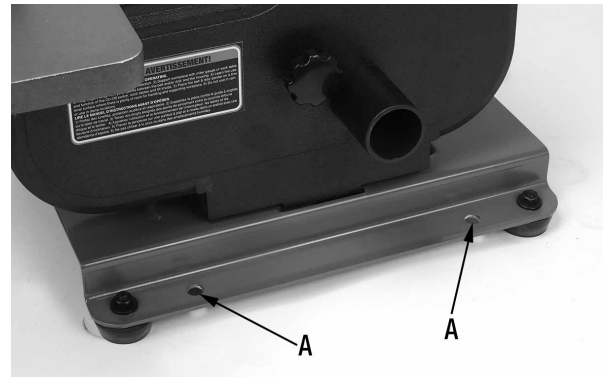


Figure 3

INSTALLING SANDING BELT TABLE

1. Position the opening of the sanding belt table bracket (A) Fig.4 over the stud (B) as shown.
2. Secure the sanding belt table (C) Fig.4 using a washer and lock handle (D).

Note: The lock handle (D) Fig.4 is spring loaded, screw the lock handle by rotating it clockwise. Then pull the handle outward and rotate back to starting point, release the handle and continue tightening the lock handle until the sanding belt table is secure.

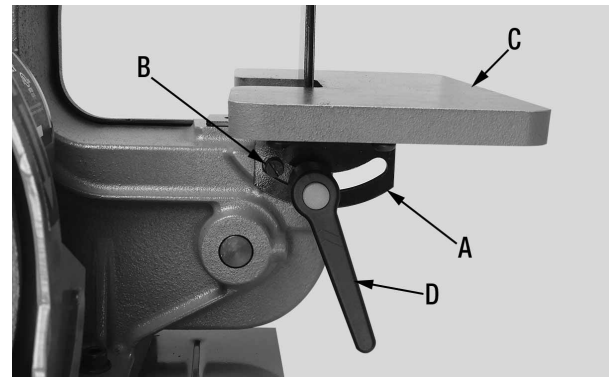


Figure 4

INSTALLING DISC DUST CHUTE

1. Install the disc dust chute (A) Fig.5 over the lower portion the sanding disc (B) as shown using 6 pan head screw (C).

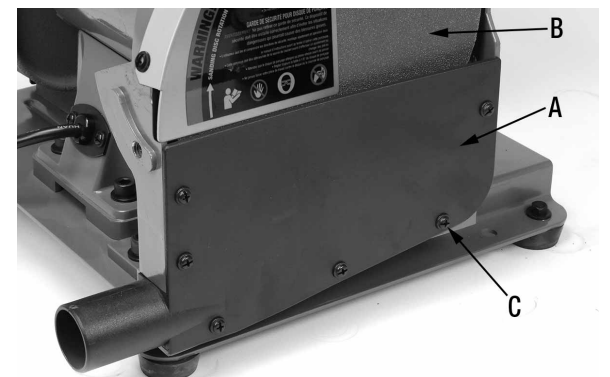


Figure 5

INSTALLING SANDING DISC TABLE

1. Position the sanding disc table (A) Fig.6 at an angle as shown, and slide the table on so that the trunnion slots (B) slide and fit over the raised tracks (C) on the disc guard.
2. Secure the sanding disc table (A) Fig.6 using two washers and lock handles (D) on each side of the table.
3. The gap between the sanding disc table and the sanding disc should be a maximum of 1/16". If the gap is larger than 1/16", loosen the two cap screws (E) which secure the disc guard, slide the disc guard to achieve the proper gap and retighten cap screws (E).

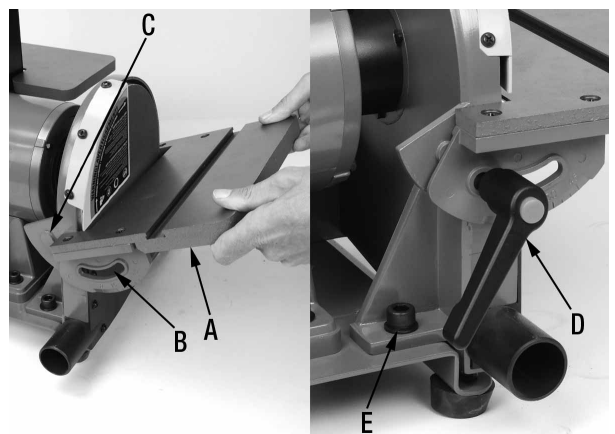


Figure 6

ASSEMBLY & ADJUSTMENTS



INSTALLING MITER GAUGE IN T-SLOT OF DISC TABLE

1. Slide the T-slot bar (A) Fig.7 of the miter gauge assembly (B) into one end of the T-slot (C) of the disc table (D).

Note: The miter gauge can be used in either direction in the t-slot of the disc table, use the most effective direction depending on the operation. Keep in mind, when sanding using the sanding disc, the workpiece must be positioned on the side of the disc which rotates downward.

2. To adjust the angle of the miter gauge (B) Fig.7, loosen lock knob (E), pivot miter gauge to the desired angle, and retighten lock knob. For precise angles, use a combination square to set the angle.

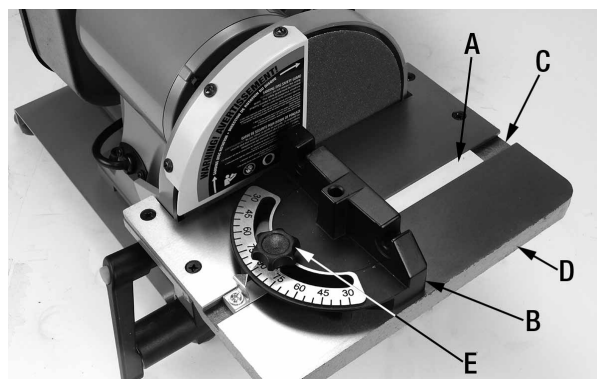


Figure 7

INSTALLING BELT TENSION LEVER

1. Install the belt tension lever and knob (A) Fig.8 into the threaded hole on the belt tension hub (B).

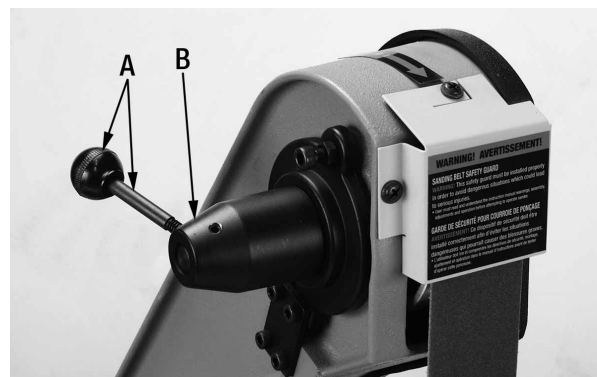


Figure 8

ADJUSTMENTS

TILTING BELT TABLE/SETTING TABLE 90°

The belt table (A) Fig.9 can be tilted downward from 0-45°. To adjust and set the belt table angle to a perfect 90° angle:

1. Loosen the belt table lock handle (B) Fig.9, now the belt table (A) can be tilted and locked at the desired angle.
2. To set the belt table at a perfect 90° angle to the sanding belt, loosen lock handle (B) Fig.9, then position a square (C) on the table and up against the sanding belt. Adjust the angle of the belt table until the sanding belt and belt table are square, retighten lock handle (B).

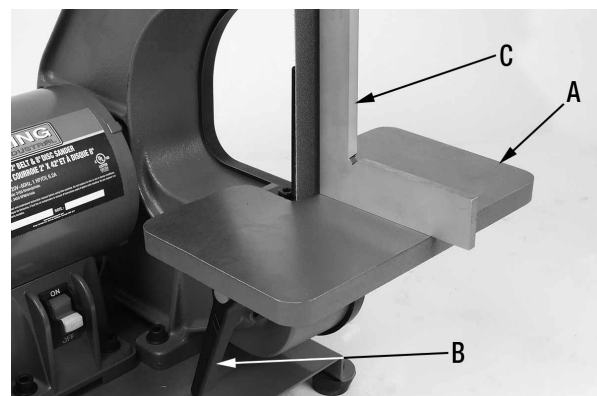


Figure 9

TILTING DISC TABLE/SETTING TABLE 90°

The disc table (A) Fig.10 can be tilted downward from 0-45°. To adjust and set the disc table angle to a perfect 90° angle.

1. Loosen both disc table lock handles (B) Fig.10, now the disc table (A) can be tilted and locked at the desired angle.
2. To set the disc table at a perfect 90° angle to the sanding disc, loosen lock handles (B) Fig.10, then position a square (C) on the table and up against the sanding disc. Adjust the angle of the disc table until the sanding disc and disc table are square, retighten lock handles (B).
3. If the disc table is square with the sanding disc, but the angle indicator (D) is not aligned with the 0° mark of the trunnion scale (E), loosen the angle indicator screw and reposition the angle indicator to line up with the 0° mark of the trunnion scale (E).

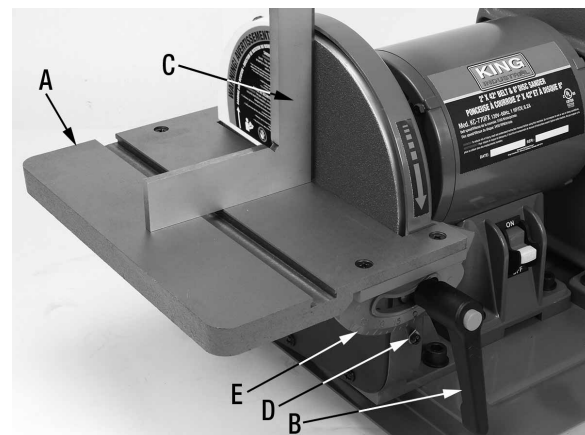


Figure 10



ADJUSTMENTS

REPLACING SANDING BELT

WARNING!: Disconnect the power cord from the power source before attempting to replace a sanding belt.

This belt & disc sander comes with a 2" x 42" sanding belt installed on the machine, and an additional 1" x 42" sanding belt (with 1" belt platen) is provided.

To replace the 2" x 42" sanding belt, follow these instructions:

1. Loosen and remove two belt cover lock knobs (A) Fig.11, then remove belt cover (B) as shown. Remove safety guard (C) and 2 pan hd screws (D).
2. Remove the belt table.
3. Rotate the belt tension lever (A) Fig.12 upwards as shown to release the tension on the sanding belt, remove sanding belt.
4. While holding tension lever in the released position, place new 2" x 42" sanding belt around the wheels, align the belt as well as you can on the wheels and release tension lever.

NOTE: Most sanding belts come with a directional arrow on the inside of the sanding belt. It is important to position the belt in the direction that the machine is running (downward), refer to labels on machine for the direction of rotation.

5. Install belt cover (B) Fig.11 and secure it in place using the two lock knobs (A) removed previously.
6. Connect power cord to power source and start the sander, observe the belt tracking. If the sanding belt is not tracking centered on the wheels, refer to Tracking Sanding Belt in the following section.

To install 1" x 42" sanding belt, follow these instructions:

The instructions for installing a 1" x 42" sanding belt is the same as the above instructions for installing 2" x 42" with only one exception. When using a 1" x 42" sanding belt, it is required to install the 1" belt platen (A) Fig.13, to install 1" belt platen:

1. Install 1" x 42" sanding belt as described above. Loosen and remove the large cap screw (B) Fig.13, replace the 2" belt platen with the 1" belt platen (A). Refer to Adjusting Belt Platen for more information on setting the belt platens.

TRACKING SANDING BELT

Tracking of the sanding belt is important. The sanding belt must run centered on the wheels and should remain vertical without shifting side to side. If your sanding belt is not tracking properly after installation, the following adjustment is possible:

1. Make sure the sanding belt is positioned centered on the wheels. Recheck adjustment if needed.
2. Turn sanding belt by hand and observe the direction the sanding belt is shifting side to side on the top wheel.
3. To adjust tracking, loosen hex. nut (A) Fig.14, and rotate the tracking cap screw (B) using a hex. key. If the sanding belt is tracking towards the right, turn cap screw clockwise. If the sanding belt is tracking towards the left, turn cap screw counterclockwise. Make small adjustments until sanding belt is tracking properly.
4. Retighten hex. nut (A) Fig.14, connect power cord to power source and check adjustment. Repeat if needed.

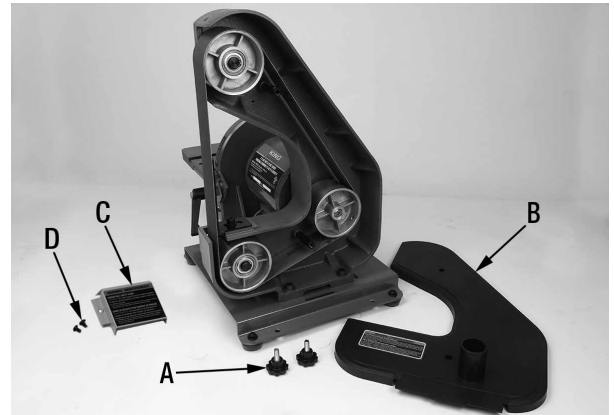


Figure 11

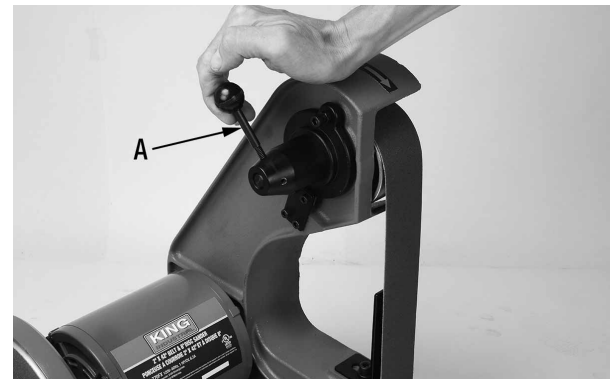


Figure 12

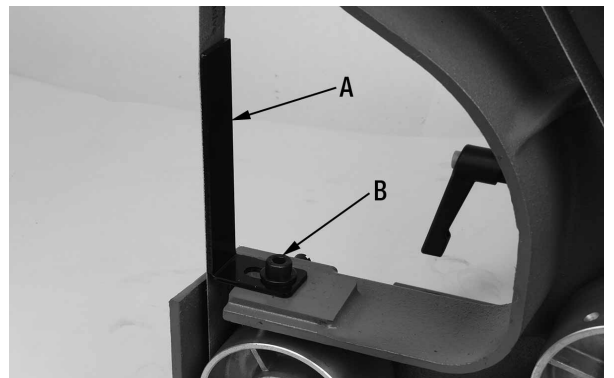


Figure 13

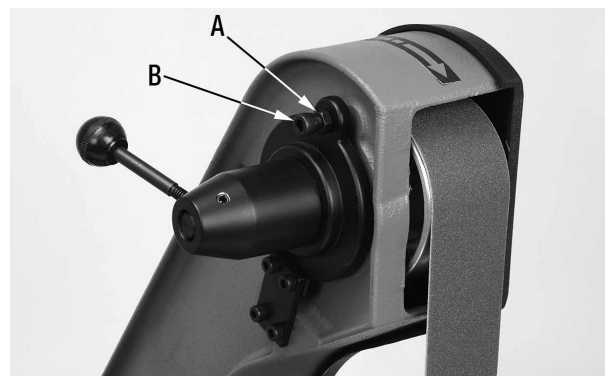


Figure 14

ADJUSTMENTS



ADJUSTING BELT PLATEN (1" OR 2" BELT PLATENS)

The belt platen (A) Fig.15 is used to support the workpiece against the sanding belt during operations. For most common operations using the sanding belt, belt platens (1" belt platen with 1" x 42" belt, 2" belt platen with 2" x 42" belt) must be adjusted so that it almost touches the back of the sanding belt. This is done by loosening cap screw (B) and positioning the belt platen (A) to the desired position.

For not so common operations such as contour sanding or polishing, the belt platen (A) Fig.15 can be removed. Once the operation is complete, the appropriate belt platen should be reinstalled.

REPLACING SANDING DISC

WARNING!: Disconnect the power cord from the power source before attempting to replace a sanding disc.

1. Loosen and remove both disc table lock handles and then remove disc table.
2. Remove disc dust chute as shown in Fig.16 by removing the 6 pan head screws that secure the dust chute. Also remove the safety guard by removing the 3 pan head screws.
3. Peel off the used 8" sanding disc (A) Fig.16. Once remove, clean the aluminum disc. Make sure the aluminum disc is perfectly clean and dry before attempting to install a new sanding disc.
4. Peel off the rear backing of the new sanding disc, carefully position the new sanding disc so it is centered on the aluminum disc. Firmly press the sanding disc onto the aluminum disc.
5. Reinstall dust chute, disc table and lock handles.

REMOVING ALUMINUM DISC

WARNING!: Disconnect the power cord from the power source before attempting to remove the aluminum disc.

If needed, the aluminum disc can be removed to simplify the cleaning of the aluminum disc. To remove the aluminum disc:

1. Loosen and remove both disc table lock handles and then remove disc table.
2. Remove disc dust chute as shown in Fig.16 by removing the 6 pan head screws that secure the dust chute.
3. Rotate the aluminum disc until the locking set screw (A) Fig.17 is visible through the opening behind the disc housing. See Fig.17. If the set screw is not accessible from the opening, it might be needed to move the disc housing forward to gain access to the set screw.
4. Loosen set screw (A) Fig.17 and pull the aluminum disc (B) out of the disc housing.
5. Make sure the keyway (A) Fig.18 on the motor shaft (B) is properly seated before attempting to reinstall the aluminum disc.
6. Once you have completed the cleaning of the aluminum disc, slide aluminum disc all the way onto the motor shaft and retighten set screw (A) Fig.17.

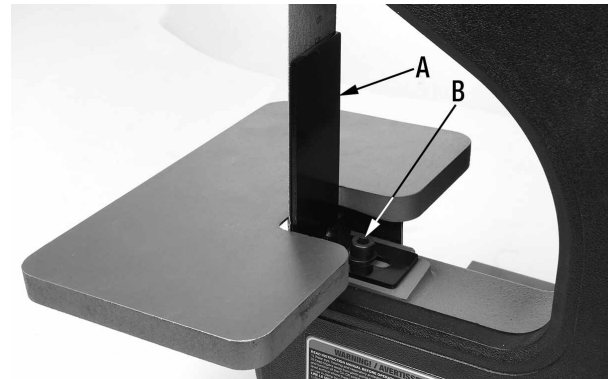


Figure 15

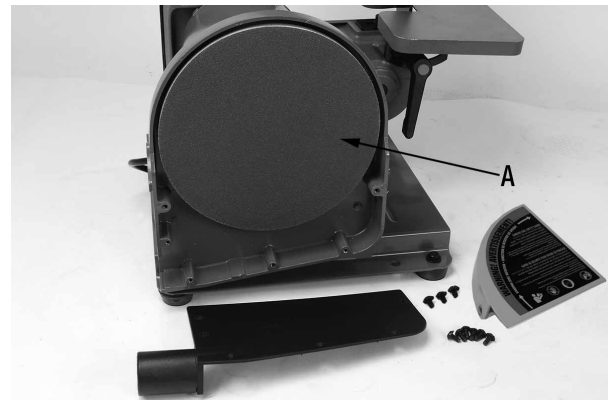


Figure 16

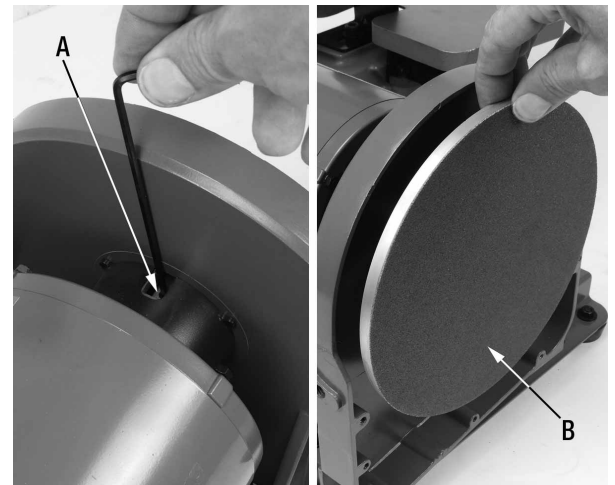


Figure 17

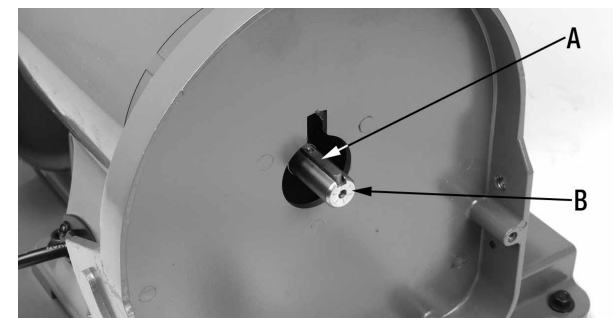


Figure 18



OPERATION

OPERATIONAL GUIDELINE FOR USING THIS BELT & DISC SANDER

WARNING! FOR YOUR SAFETY AND TO REDUCE THE RISKS OF FIRE, THIS BELT & DISC SANDER SHOULD BE DEDICATED TO SANDING ONLY ONE MATERIAL (WOOD OR METAL). IF YOU DESIRE TO SAND WOOD AND METAL, IT IS EXTREMELY IMPORTANT THAT THE SANDING BELT AND SANDING DISC HOUSINGS BE COMPLETELY CLEANED OF ALL WOOD DUST OR METAL DUST BEFORE USING AGAIN. FAILURE TO RESPECT THIS WARNING COULD LEAD TO FIRE.

1. The workpiece should not contact the sanding belt or disc during a start-up. Allow the motor come up to speed before attempting to sand a workpiece.
2. If you observe a wobble or runout. If the disc is not operating smoothly, stop the sander and have the machine serviced before using the sander again.
3. Always sand on the side of the sanding disc that rotates downward. Sanding on the opposite side could cause the workpiece to slip and fly out of your hands, creating a dangerous situation.
4. The disc and belt tables must be set a maximum of 1/16" away from the sanding disc or belt.

DISC SANDING

Warning! Always make sure the sander is unplugged prior to attempting any installation or changing of parts and accessories.

When sanding, always position your workpiece (A) Fig.19 on the downward, rotating side (right side) of the sanding disc as shown. Sanding on the left side of the sanding disc, upward rotating side is dangerous, as your workpiece cannot be controlled and 'kick-back' may occur - the wood being forced up and out of your hands.

Use the miter gauge (B) Fig.19 for added control of the work piece during sanding. The miter gauge can also be set to various degree angles for maintaining accurate angles when sanding small or multiple parts.

Do not force the work piece into the sanding disc. Sand using light pressure, move your workpiece slightly left and right on the disc, keeping to the right-of-center, downward side. This will help prevent resin or debris from building up on one area of the disc, and also helps to prevent burning of the sanded surface from excessive abrasive-action heat build-up.

NOTE: It is strongly recommended to use a dust-collection system when using this belt & disc sander. Use of a dust mask or respirator is still recommended, even when a dust collection system is in use.

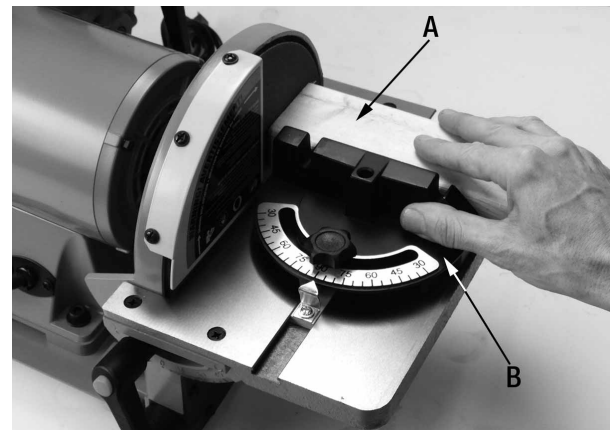


Figure 19

BELT SANDING

Warning! Always make sure the sander is unplugged prior to attempting any installation or changing of parts and accessories.

Depending on what type of sanding that you will be doing, set the sanding belt table to the proper angle using a square or a protractor.

Do not force the workpiece (A) Fig.20 into the sanding belt (B). Sand using light pressure. Move your workpiece slightly left and right on the belt. This will help prevent resin or debris from building up on one area of the belt, and also helps to prevent burning of the sanded surface from excessive abrasive-action heat build-up.

The platen (C) Fig.20 supports the back of the sanding belt and offers a flat surface to sand or sharpen against. It should be positioned so it is almost touching the back of the sanding belt. To adjust the platen, loosen the cap screw (D) at the rear of the platen. The platen can also be removed for contour sanding or polishing.

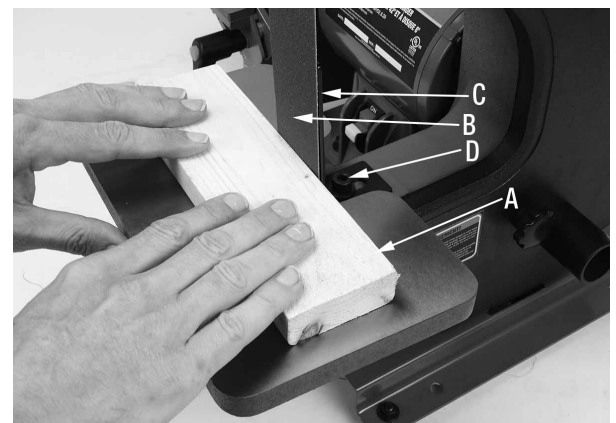


Figure 20

NOTE: It is strongly recommended to use a dust collection system when using this belt & disc sander. Use of a dust mask or respirator is still recommended, even when a dust collection system is in use.

OPERATION, MAINTENANCE & TROUBLESHOOTING



OPERATION

DUST COLLECTION

It is strongly recommended to use a dust collection system when using this belt & disc sander. Use of a dust mask or respirator is still recommended, even when a dust collection system is in use.

This belt & disc sander comes with two 1-1/2" dust ports (A & B) Fig.21.

MAINTENANCE

WARNING: For your own safety, turn switch "OFF" and remove plug from power source outlet before adjusting, maintaining, or lubricating your belt and disc sander.

WARNING: To avoid electrocution or fire, any repair to electrical system should be done by qualified service technicians. Unit must be reassembled exactly to factory specifications.

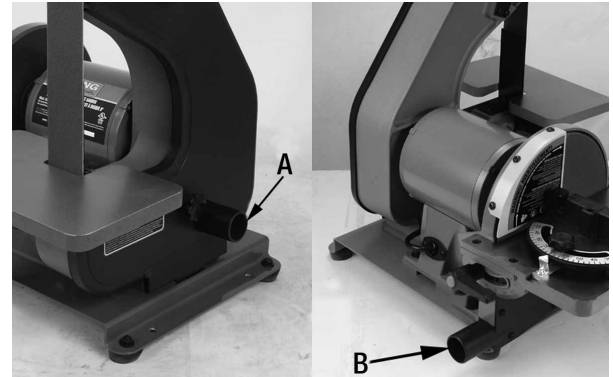


Figure 21

LUBRICATION

The ball bearings in this machine are packed with grease at the factory. They require no further lubrication. All other moving parts should be sprayed with a liquid lubricant to ensure smooth operation.

Before each use

1. Check the power cord for any damage.
2. Check sanding belt and disc for damage or wear.
3. Check all guards and hardware to make sure they are secure.
4. Check all moving parts for alignment and binding issues.

Inspect regularly

1. Dress/clean sanding surfaces for best abrasive action.
2. Replace sanding belt or disc when worn or damaged.
3. Clean and vacuum dust from the motor housing and other sander parts.
4. Keep tables free of rust. Apply coat of paste wax or silicon spray.

TROUBLESHOOTING

TROUBLE	PROBABLE CAUSE	SOLUTION
Motor will not run.	1. Defective ON-OFF switch. Defective switch cord. Defective switch box. 2. Burned out motor.	1. Replace defective parts before using sander again. 2. Any attempt to repair this motor may create a hazard unless repair is done by a qualified service technician.
Machine slows down when sanding.	1. Applying too much pressure to workpiece.	1. Ease up on the pressure.
Belt runs off drums.	1. Not tracking properly.	1. Adjust tracking.
Wood burns while sanding.	1. Sanding disc or belt is glazed with sap.	1. Replace disc or belt.

PARTS DIAGRAM & PARTS LISTS

Refer to the Parts section of the King Canada web site for the most updated parts diagram and parts list.