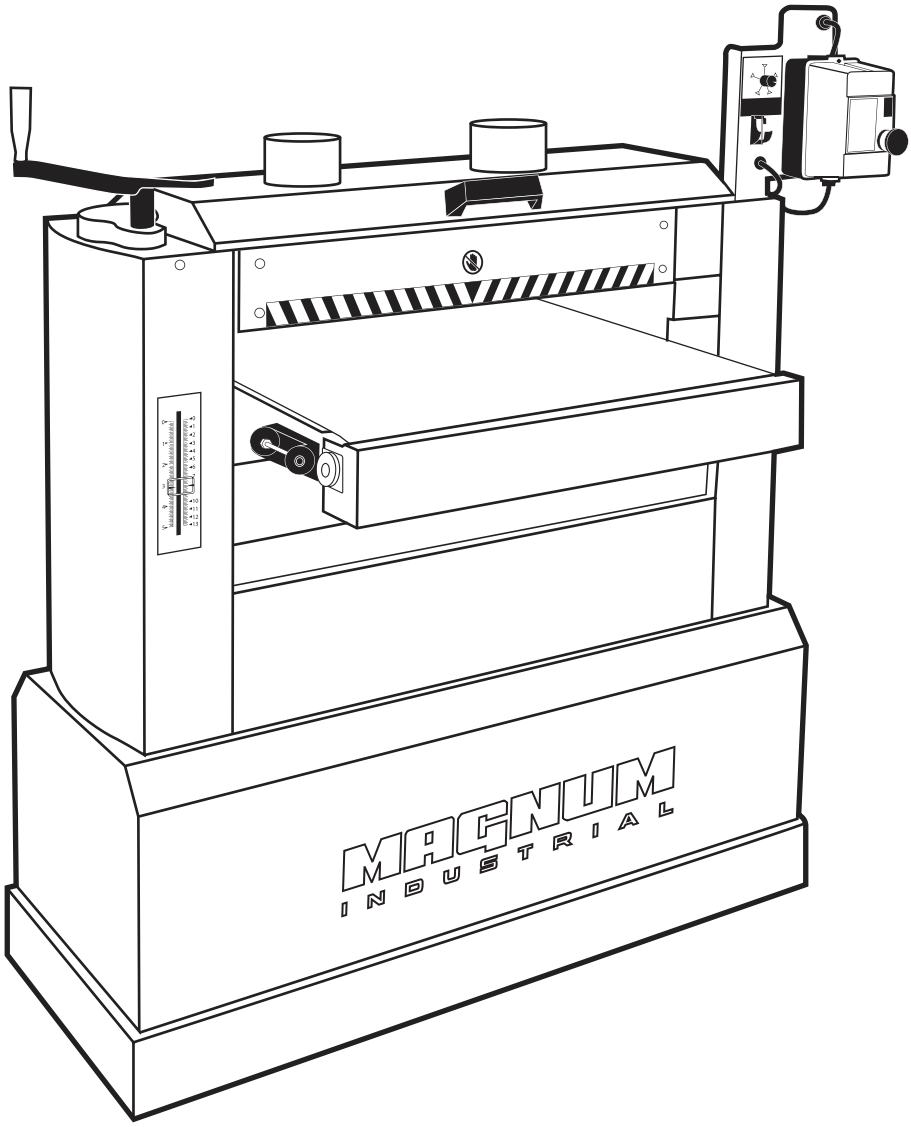
MAGNUM
INDUSTRIAL

MODEL NO.: MI-16750



OPERATING MANUAL

TABLE OF CONTNETS

PREFACE

Thank you for choosing this Drum Sander. We are pleased to offer you our best machinery and service, and trust that you will find our machinery economical, productive and easy to operate.

This manual covers the proper operation, safety and maintenance of the machine. It is important that this manual be read in its entirety before operating the machine. Although the machine has been checked and inspected in compliance with relevant safety regulations, the machine's safety and best performance are dependent on proper maintenance and operation. Hazards that arise due to improper operation and maintenance are solely the responsibility of the operator.

We thank you again for you choice, and for your careful reading of this manual.

GENERAL SAFETY RULES FOR WOODWORKING

There is a certain amount of hazard involved with the use of woodworking machinery. Using the machine with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, severe personal injury to the operator can occur.

1. Read the operation manual before operating this machine.
2. The machine should be disconnected from the power source before performing maintenance or adjustments to the internal mechanisms, or when making repairs.
3. Before leaving the machine, make sure the work area is clean.
4. Check timber for loose knots, nails, or other items which may cause a hazard or affect the machine's performance.
5. Keep all guards in place and in working order.
6. Do not force the machine. It will do the job better and be safer working at the rate for which it was designed.
7. All children and visitors should be kept a safe distance from the working area.
8. The operator should keep proper footing and balance at all times.
9. Do not operate the machine while under the influence of drugs, alcohol, or any other medication.
10. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the sanding drum.
11. Never leave the machine until it comes to a complete stop, and never leave the machine running unattended.

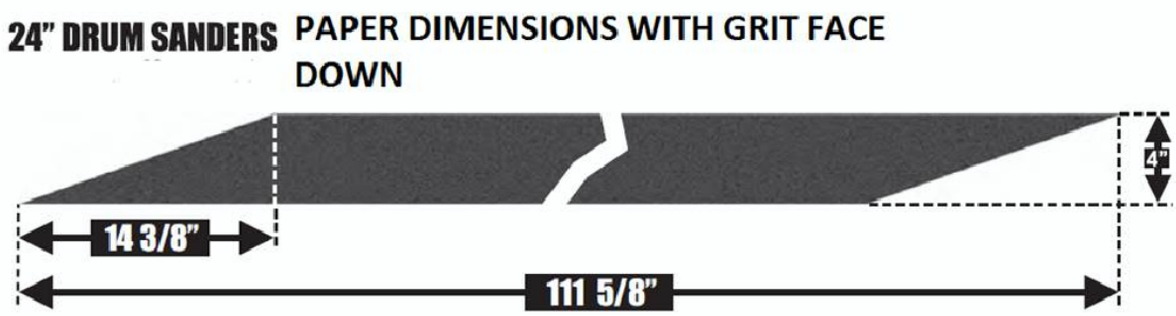
GENERAL SAFETY RULES FOR WOODWORKING

12. The employer is responsible for selecting competent and qualified employees.
13. Safety shoes should be worn to provide protection against rolling objects, falling objects, and sharp edges in the workplace.
14. Eye protection should be worn and such devices should be carefully selected, fitted and used. Compulsory wearing of glasses with impact resistant lenses and side shields is a good safety policy.
15. Wear hearing protection when operating the machine.
16. Do not wear rings, necklaces or jewelry around moving machinery.
17. Do not wear loose fitting clothes. Clothing should be comfortable, but long sleeves, neckties, etc. should not be worn.
18. Do not wear gloves or other hand covering articles around moving machinery.
19. Cover long hair with a hair net or cap.
20. Protective guards and shields must be in place at all times unless they must be removed for specific service or maintenance. They should be immediately replaced when service or maintenance is completed.
21. Make sure that operator clearly knows how to stop the machine before starting work.
22. Never clean or remove chips while the machine is running.
23. Do not alter or remove guards and warning labels.
24. Keep the immediate area clean. Do not allow the floor to become slippery, or covered with dust or obstacles. Dust that accumulates in the work area is a hazard that can cause you to fall or slip against the machine or its controls.

SPECIFICATIONS

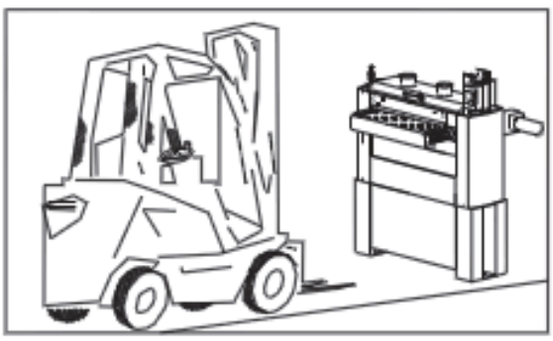
MODEL	MI-16750
Max. sanding width	24”
Max. thickness of workpiece	5 "
Min. thickness of workpiece	1/4 "
Sanding drum speed	1550RPM
Conveyor belt speed	3 ~ 20 FPM
Sanding drum motor	3 HP
Feed drive motor	1/6 HP (DC)
Sanding drum diameter	5 "
Weight	210 kgs
Machine dimensions	48 x 31" x 48" "
Voltage	220V
Number of sanding drums	2
Noise level	76dB

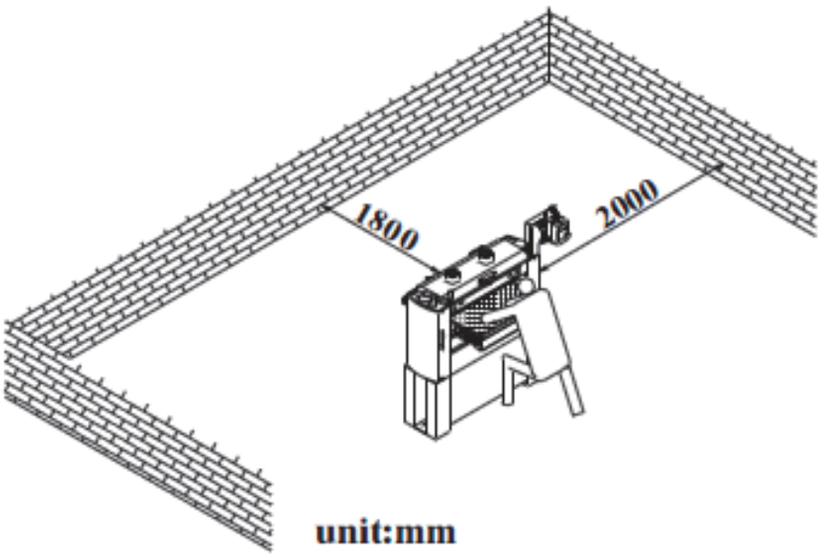
The above specifications are not binding. supplier reserves the right to amend any specifications or design characteristics without prior notice.



THE MOVE AND DIMENSION OF LOCATION

1. Using pallet truck or forklift while moving the machine
2. The center of gravity is in the first half of the machine. Using assistant to support and stable the machine, to prevent the dangerous from fall in.



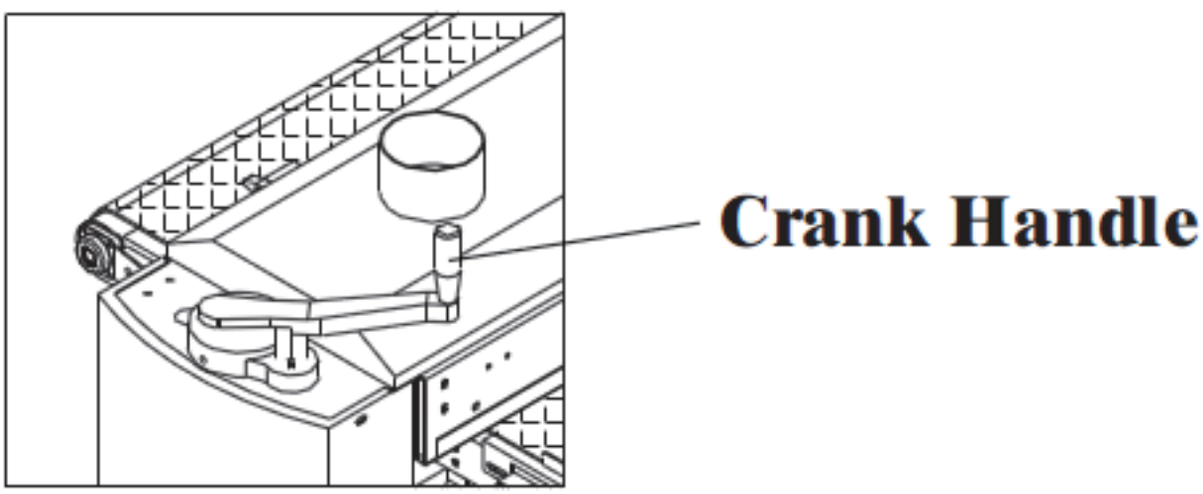


UNPACKING AND ASSEMBLY

Remove the sander and all parts from the container, and check to ensure that all parts are present as indicated. If any parts are damaged or missing, contact your distributor immediately.

Move the sander to the worksite with a forklift or lifting hook. Make sure that the equipment used for transportation of the sander is of adequate capacity.

Mount the table elevation crank handle as shown in figure. Align the slots on the shaft and crank handle, and use the pin supplied to fasten the crank handle to the shaft.



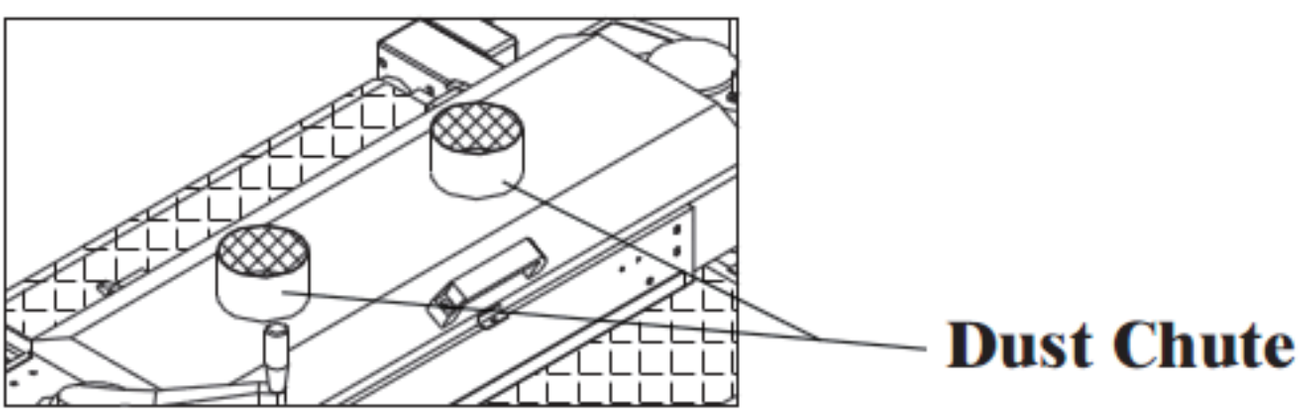
ELECTRICAL CONNECTIONS

This Sander is rated for voltage and amperage appropriate to the area where it is sold. Confirm that the electrical specifications match your setup before use. Proper grounding is essential. Failure to properly ground the machine may result in electrical shock and injury to the operator or other personnel. If the machine is to be used with other electrical configurations, all connections must be made by qualified service personnel, and the setup must comply with local codes and ordinances.
Use of an extension cord is not recommended. If an extension cord must be used, it must be of adequate size and capacity to support the amperage and distance between the machine and the power source.

WARNING
All electrical connections must be done by qualified service personnel!
Failure to comply may result in serious injury and/or damage to the machine!

ATTACHING A DUST COLLECTOR

The machine is provided with two 4-inch dust chutes. Use ring clamps to attach dust collection hoses to the chutes.



WARNING
Do not operate this machine without a dust collector attached and running.

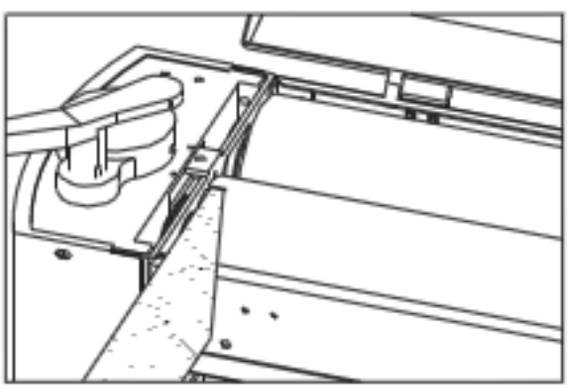
MOUNTING AND REPLACING SANDING BELT

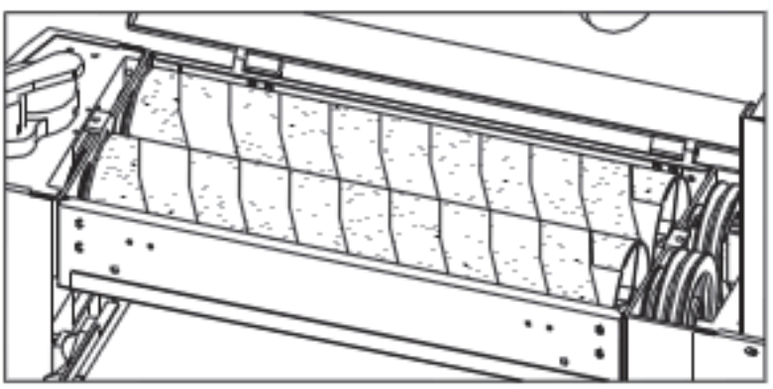
Removing the Sanding Belt

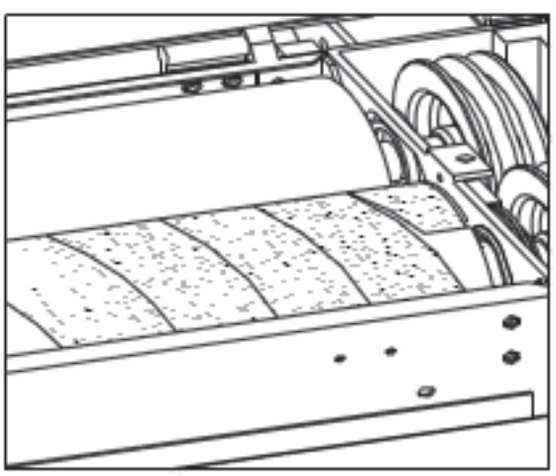
Lift the upper guard and tilt it to the rear, in order to access the sanding drum.
The sanding belt is fixed at either end of the drum by spring loaded clamps. To remove the sanding belt, push the right clamp forward and pull the tab of the sanding belt out of the right drum slot.
Unwind the sanding belt from the drum, and push the clamp forward at the left side of the drum to remove the sanding belt tab from the left drum slot.

Mounting a New Sanding Belt

Insert the tab of the belt on the left end of the drum, and push the left clamp forward so that the tab will slide under the clamp. Releasing the clamp will lock belt tab into place. Roll the sanding belt onto the drum, keeping the edges snug. Tuck the tab at the right end of the sanding belt into the slot at the other end of the drum, pushing the clamp forward so that the tab will slide in. The clamps are spring loaded, and will hold the belt increasingly tightly as the drum revolves. Replace and mount sanding belt on both sanding drum by this method.



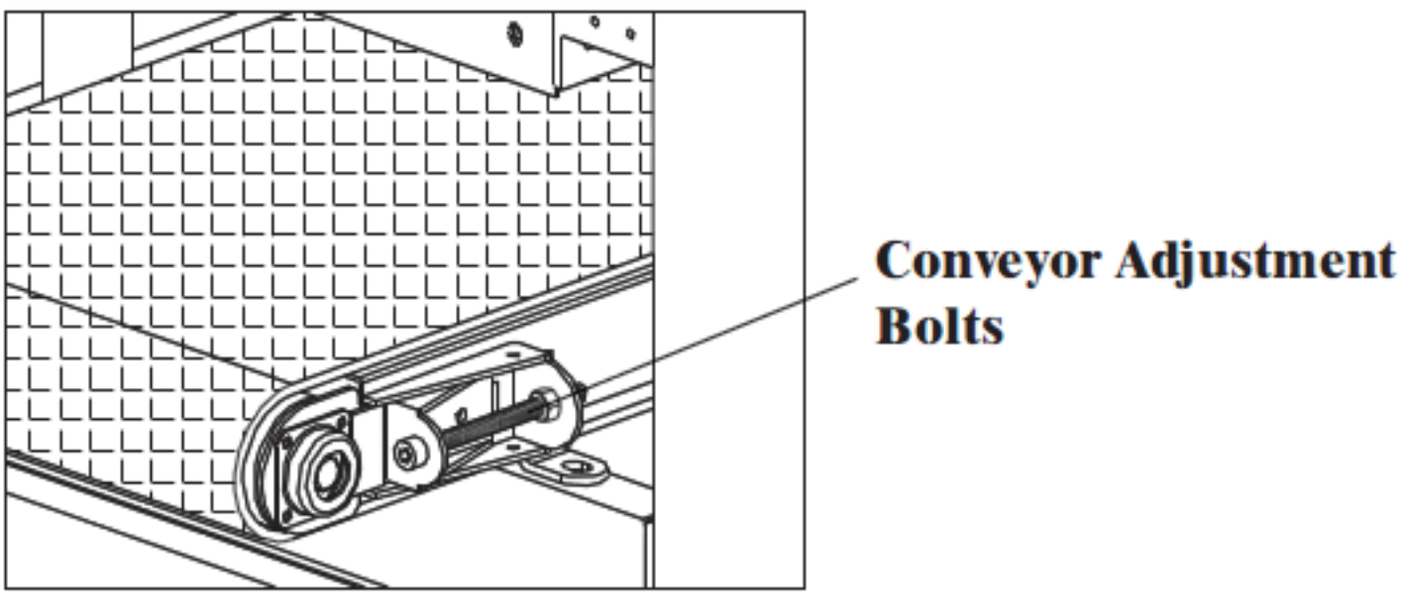




⚠ CAUTION
Make sure the machine is disconnected from the power source before mounting the sanding belt.

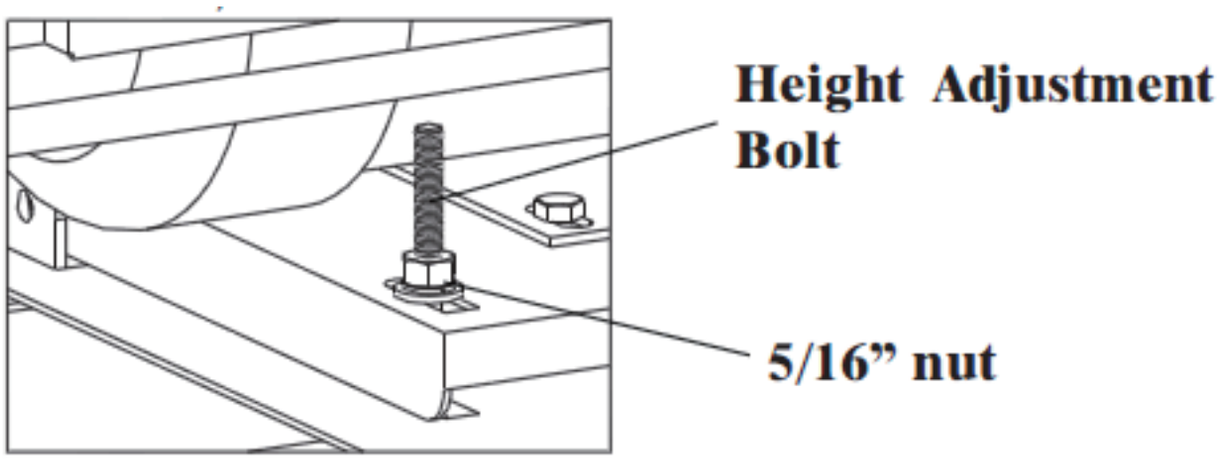
ADJUSTING THE CONVEYOR BELT TRACKING & TENSION

If the conveyor belt runs to the right or left during operation, or the conveyor belt tension is too loose or too tight, adjust it by turning the adjustment nuts on either side of the conveyor table. The conveyor belt should run at the center of the conveyor table, and should be tensioned so that there is good traction during stock feeding.



ADJUSTING THE SANDING DRUM DRIVE BELT

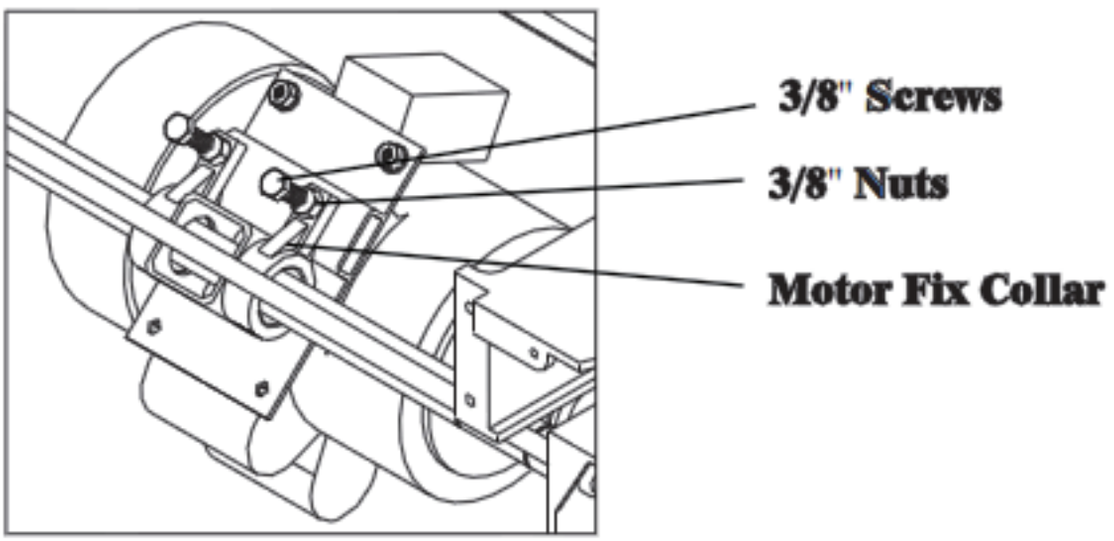
The drum is driven by one belt and powered by the main motor. If the belt become too loose, remove the right end guard, front guard, and then adjust the position of the motor (height) by turning the M12 nuts on the height adjustment bolts (See figure).



If the motor becomes damaged and needs to be replaced, remove the bolts on the bottom of the motor base plate, and remove the entire motor assembly.

ADJUSTING THE SANDING DRUM DRIVE BELT

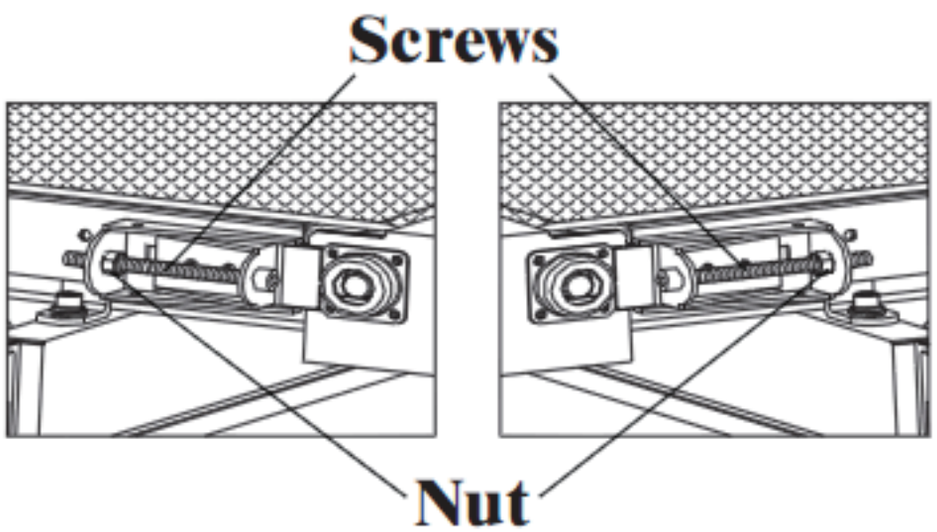
The drum is driven by one belt and powered by the main motor. If the belt become too loose, remove the right end guard, front guard, and then adjust the position of the motor (height) by turning the M12 nuts on the height adjustment bolts (See figure).



If the motor becomes damaged and needs to be replaced, remove the bolts on the bottom of the motor base plate, and remove the entire motor assembly.

REPLACING THE CONVEYOR BELT

If the conveyor belt becomes too worn, the workpiece will not be fed effectively. To replace the conveyor belt, remove the guards at both ends of the sander, and remove the four fix screws at the bottom of the feed table assembly. The feed table can then be removed so that the feed belt can be replaced. (see figure)



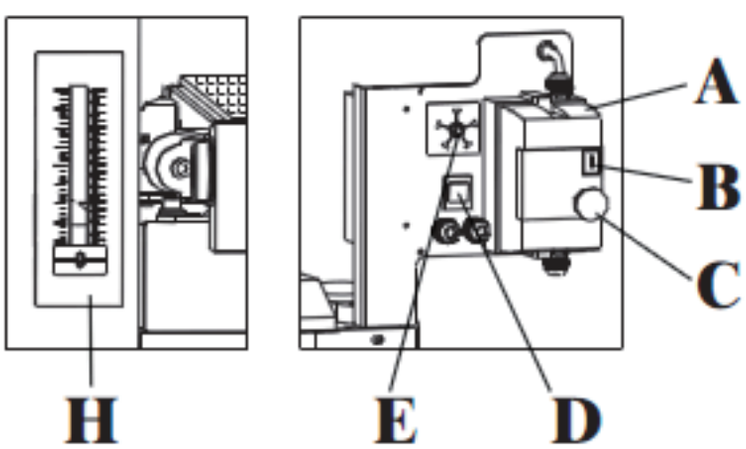
SANDING OPERATIONS

Start the dust collector before turning on the sander.

To start the machine, press the green 'ON' button on the control box. Turn the key switch to start the conveyor belt running. Turn the conveyor speed adjustment knob to the desired stock feeding speed. To stop the machine, press the red 'OFF' button on the control box.

Use the crank handle to set the sanding height to the desired thickness. If the thickness is not known, place the workpiece on the table, where under the sanding drums, and then raise the conveyor table until the sanding drums reach the workpiece. The thickness can be read on the depth gauge located on the front left of the machine. When feeding the workpiece, place it at the center of the conveyor belt. There is centering gauge on the infeed side of the machine frame that indicates the center of the conveyor belt.

The maximum workpiece thickness acceptable for this machine is 5". The minimum workpiece thickness is 1/4". Do not attempt to sand workpieces outside of these specifications.



A. Control box
B. ON button
C. Off button
D. Conveyor belt key switch
E. Conveyor belt adjustment knob
H. Depth gauge

L UBRICATION AND MAINTENANCE

NOTE

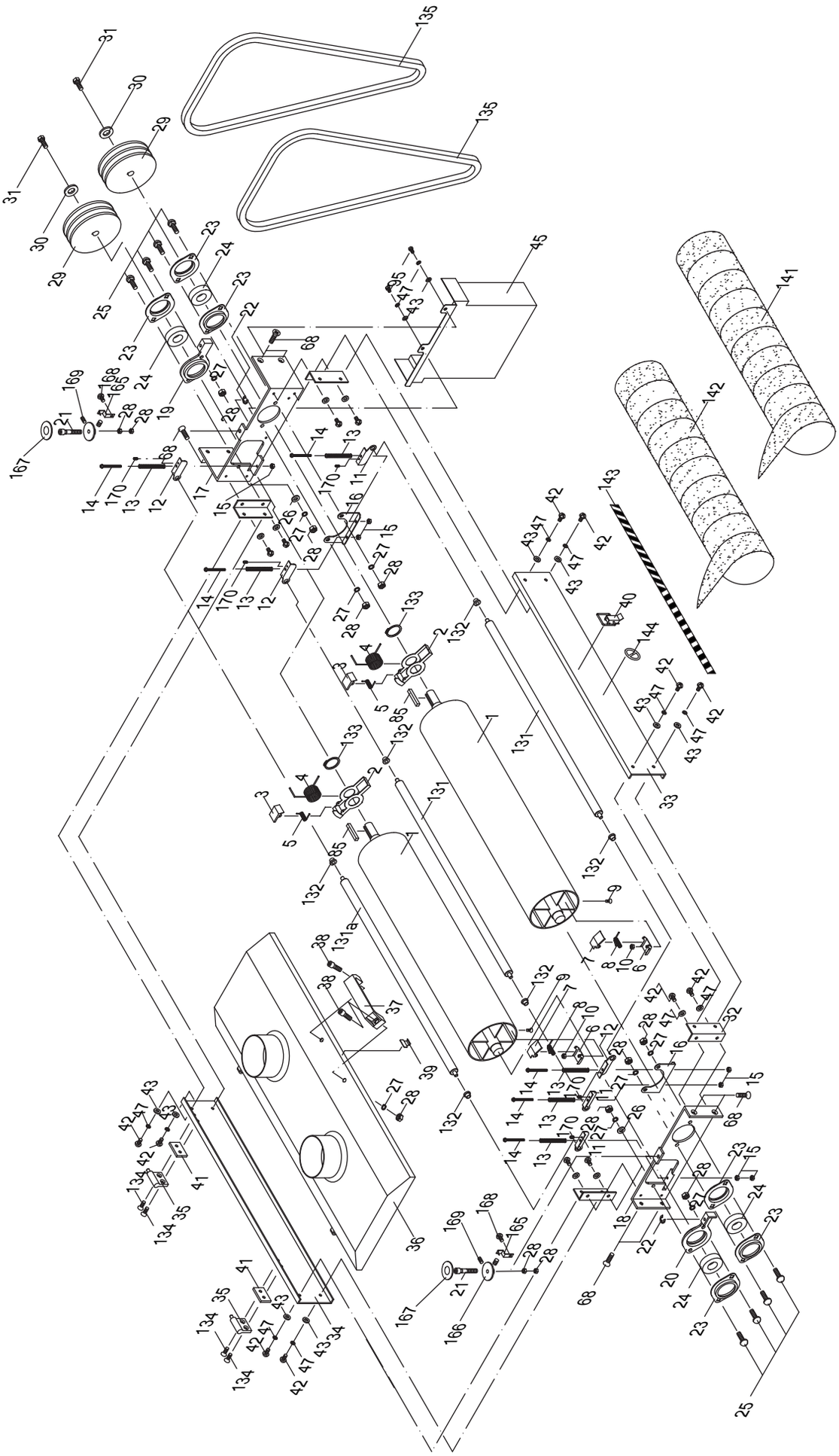
Before performing any maintenance or lubrication, disconnect the machine from the power source.

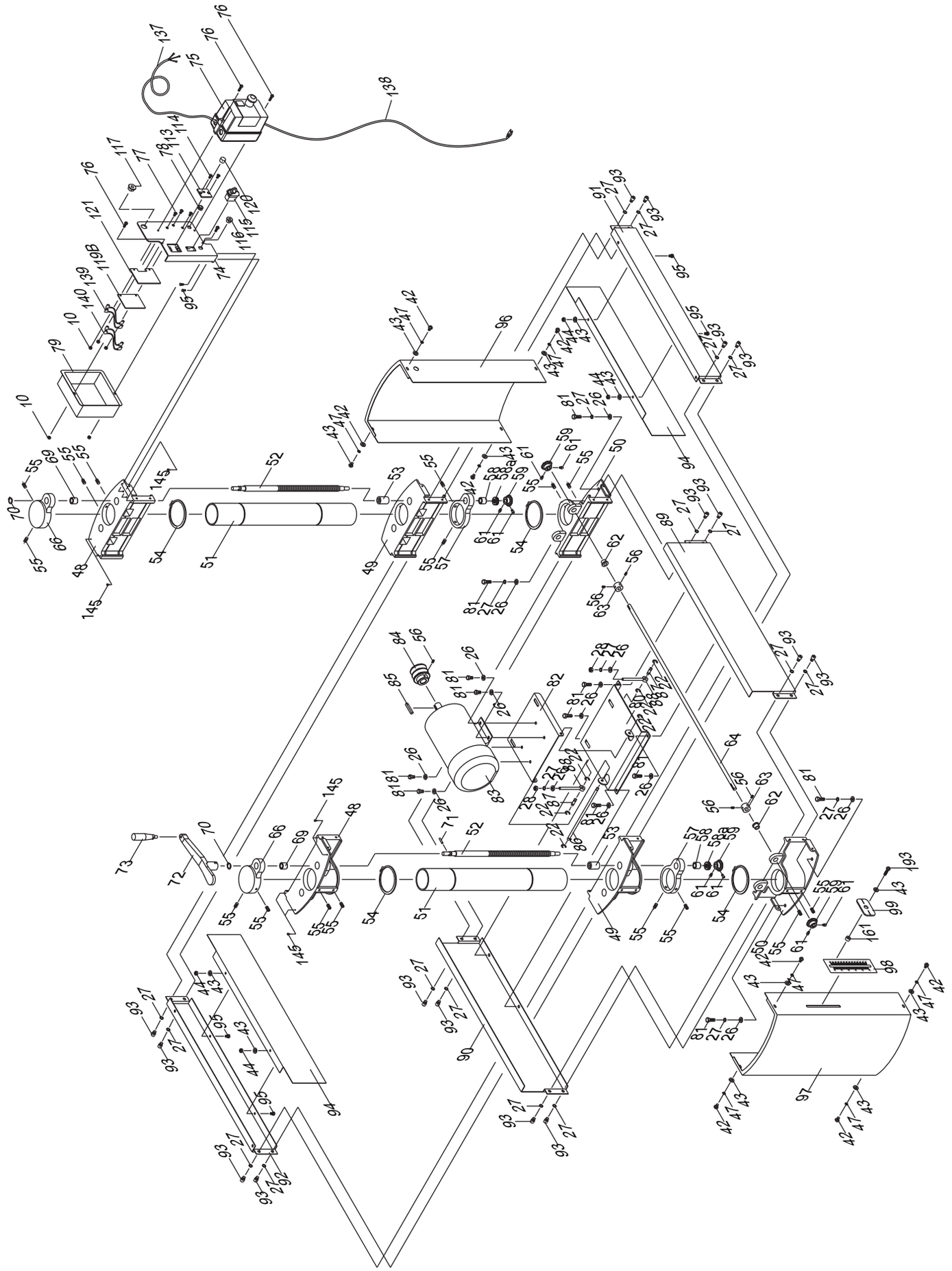
1. The table height adjustment screw shafts located at either end of the machine must be well lubricated with grease.
2. Make sure all nuts and screws are tight before sanding. Check that the sanding belt is mounted properly, and have not become loose or torn.
3. Do not allow excessive dust to accumulate on or in the machine.

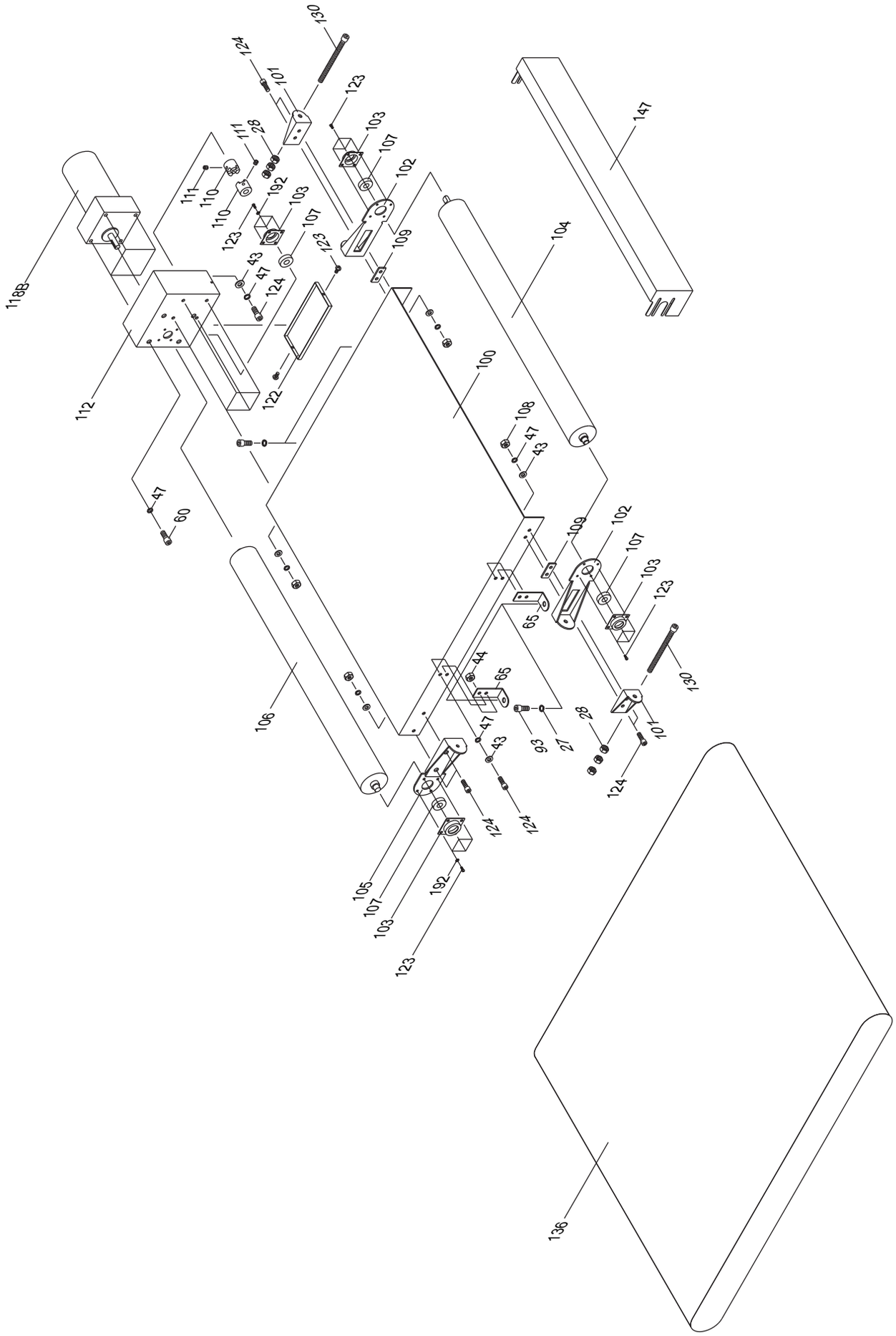
TROUBLESHOOTING

TROUBLE	PROBABLE
Sanding belt clogs too quickly	1. Sanding belt grit too fine. 2. Too much material being removed in one pass. 3. Dirty workpiece suction. 4. Insufficient dust suction. 5. Workpiece contains too much moisture.
Rounding occurs at edges or workpiece.	Too much material being removed in one pass.
Uneven thickness of right and left sides of workpiece after sanding.	1. Sanding drum is not parallel to the table. 2. Uneven wear on sanding belt
Stock slips on conveyor belt.	1. Too much material being removed in one pass. 2. Sanding belt grit too fine.
Shiny spots on sanded workpiece.	1. Conveyor belt is too smooth. 2. Conveyor belt tension is insufficient 3. Excessive dust accumulated on conveyor belt surface.
Marks on sanded surface of workpiece.	1. Sanding belt is too worn. 2. Sanding height set incorrectly 3. Sanding belt damaged.
Conveyor belt does not run smoothly, or stops.	Insufficient conveyor belt tension.

ASSEMBLY DIAGRAM



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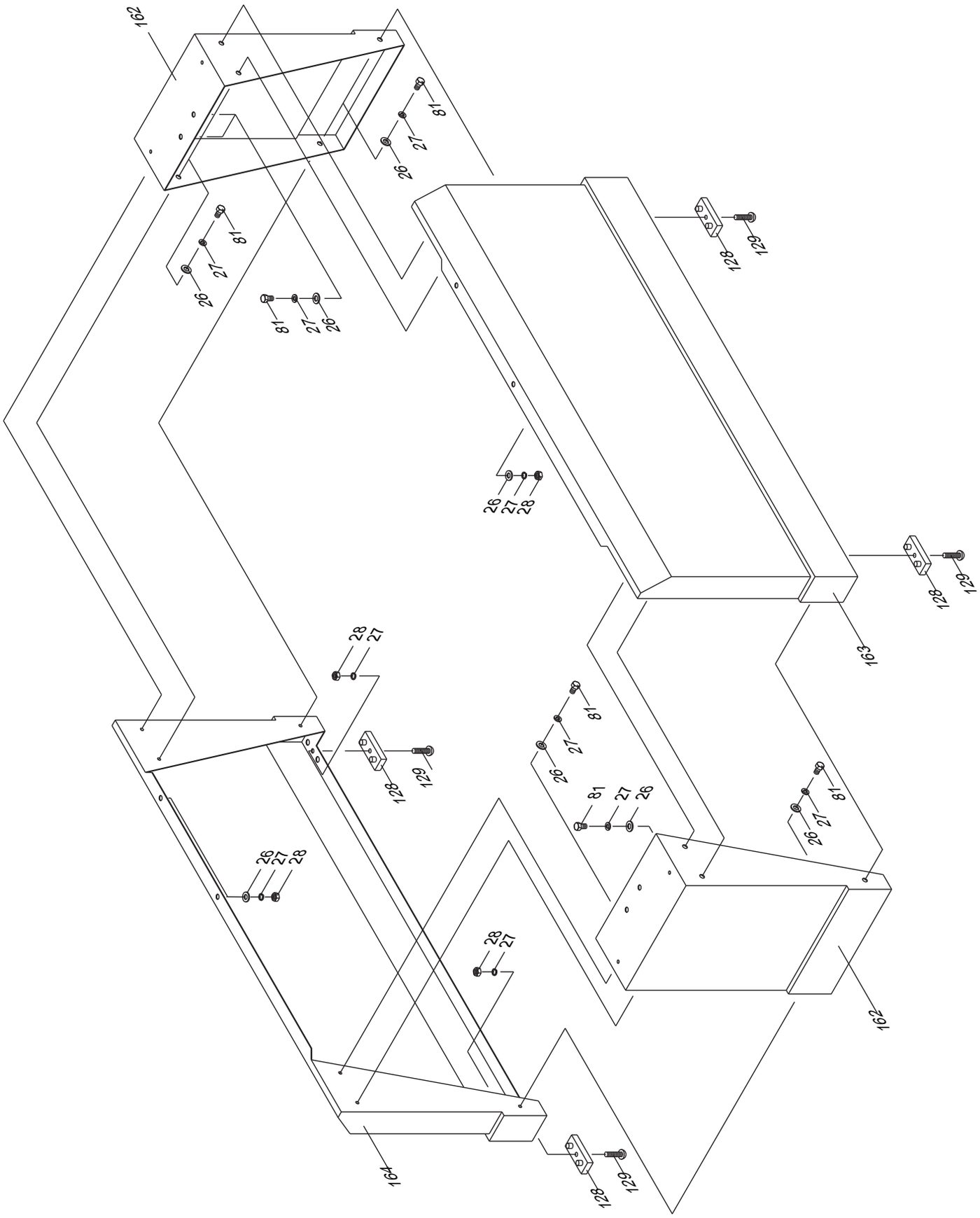
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PARTS LIST FOR MI-16750

PART N0.	REF N0.	DESCRIPTION	SPECIFICATION	QTY
MI-16750-01	20900001	DRUM		2
MI-16750-02	20703010	TWO-STEP CLAMP		2
MI-16750-03	20703010B	TWO-STEP CLAMP PLATE		2
MI-16750-04	20703010A	SPRING		2
MI-16750-05	20703014A	SPRING		2
MI-16750-06	20703014	FIXED CLAMP BRACKET		2
MI-16750-07	20703014B	FIXED CLAMP PLATE		2
MI-16750-08	20703014C	SPRING		2
MI-16750-09	S0040300	PHILLIPS HEAD SCREW		2
MI-16750-10	S0110300	NUT	3/16"-24UNC	7
MI-16750-11	20900086	RIGHT CLAMP		3
MI-16750-12	20900087	LEFT CLAMP		3
MI-16750-13	20900069	MICRO-ADJUSTMENT SPRING		6
MI-16750-14	S0030580M	PHILLIPS HEAD SCREW		6
MI-16750-15	S0120500M	NYLON NUT	M5X0.8	6
MI-16750-16	20900002	CLAMP BLOCK		2
MI-16750-17	20900003	RIGHT BEARING HOUSING		1
MI-16750-18	20900004	LEFT BEARING HOUSING		1
MI-16750-19	20900005	RIGHT MICRO-ADJUST.BEARING CAP		1
MI-16750-20	20900006	LEFT MICRO-ADJUST.BEARING CAP		1
MI-16750-21	S0020530A	MICRO-ADJUSTMENT SCREW		2
MI-16750-22	S05ETW06	CIRCLIP	E6	8
MI-16750-23	20703002	BEARING CAP		6
MI-16750-24	C1206205	BEARING	6205	4
MI-16750-25	S0060510	CAP SCREW		8
MI-16750-26	S0210500C	FLAT WASHER		38
MI-16750-27	S0230506	LOCK WASHER	5/16 "	62
MI-16750-28	S0120500	NUT	5/16"-18UNC	30
MI-16750-29	20900008	DRIVE ROLLER		2
MI-16750-30	S0210532	FLAT WASHER	3/8"X23	2
MI-16750-31	S0020512L	LEFT THREADED SCREW	5/16"-18UNCX1"L	2
MI-16750-32	20900009	CORNER BRACKET		4
MI-16750-33	20900010	FRONT UPPER PANEL		1
MI-16750-34	20900011	DUST HOOD SUPPORT PANEL		1
MI-16750-35	20702019	HINGE		2
MI-16750-36	20900012	DUST HOOD/DRUMS COVER		1
MI-16750-37	20703016	DUST HOOD/DRUMS COVER HANDLE		1
MI-16750-38	S0010502	CAP SCREW	5/16-18UNCX3/4"L	18
MI-16750-39	20900070	UPPER CLASP		1
MI-16750-40	20900071	LOWER CLASP		1
MI-16750-41	20900068	HINGE PAD	SS41	2
MI-16750-42	S0030405	PHILLIPS HEAD SCREW	1/4"-20UNC	24
MI-16750-43	S0210401	FLAT WASHER	1/4"X13X1	41
MI-16750-44	S0110400	NUT		12
MI-16750-45	20900013	PULLEY GUARD		1
MI-16750-47	S0230400	LOCK WASHER	1/4 "	46
MI-16750-48	20900014	UPPER BRACKET		2
MI-16750-49	20900015	COLUMN SUPPORT BRACKET		2

PARTS LIST FOR MI-16750

PART N0.	REF N0.	DESCRIPTION	SPECIFICATION	QTY
MI-16750-50	20900016	LOWER BRACKET		2
MI-16750-51	20900017	WORM GEAR		2
MI-16750-52	20900018	WORM		2
MI-16750-53	20900019	BUSHING		2
MI-16750-54	S0520080	CIRCLIP	S80	4
MI-16750-55	S0050500	SET SCREW		16
MI-16750-56	S0050406	SET SCREW		5
MI-16750-57	20900020	SCREW HOLDER		2
MI-16750-58A	C5151102	BEARING	51102	2
MI-16750-58	20900021	BRONZE COLLAR		2
MI-16750-59	20900022	BEVEL GEAR		4
MI-16750-60	S0010616M	HEX HEAD BOLT	M6 X 1.0 X 16	4
MI-16750-61	S0010303	HEX HEAD BOLT	3/16"-24UNCX3/8" L	8
MI-16750-62	20900023	GEAR SHAFT BUSHING		2
MI-16750-63	20900024	POSITIONING COLLAR		2
MI-16750-64	20900025	TRANSMISSION SHAFT		1
MI-16750-65	20900067	MOUNTING BRACKET		4
MI-16750-66	20900026	POST COVER		2
MI-16750-68	S0040307	PHILLIPS HEAD SCREW	5/16"-18UNCX1"L	8
MI-16750-69	20900028	BRONZE COLLAR COVER		2
MI-16750-70	S0520015	CIRCLIP	S15	2
MI-16750-71	S0310420	PIN	4X20	1
MI-16750-72	20900029	CRANK HANDLE		1
MI-16750-73	10105056A	HANDLE KNOB		1
MI-16750-74	20900030	SWITCH MOUNTING PLATE		1
MI-16750-75	W2092301D	MAGNETIC SWITCH		1
MI-16750-76	S0030318	SCREW	3/16"-24UNCX3/4"L	4
MI-16750-77	S0040308	FLAT HEAD SCREW		3
MI-16750-78	10401008	CORD BUSHING		1
MI-16750-79	20900066	SWITCH REAR GUARD		1
MI-16750-80	20900031	MOTOR BASE		1
MI-16750-81	S0020501	HEX HEAD BOLT		28
MI-16750-82	20900032	MOTOR ADJUSTMENT PLATE		1
MI-16750-83	M0000000	MOTOR		1
MI-16750-84	20900033	DRIVE PULLEY		1
MI-16750-85	S0430640	KEY	6X40	3
MI-16750-86	20900034	BASE SHAFT		1
MI-16750-87	20900035	POSITIONING SHAFT		2
MI-16750-88	20900036	SCREW		2
MI-16750-89	20900037	FRONT COVER		1
MI-16750-90	20900038	REAR COVER		1
MI-16750-91	20900039	FRONT PANEL		1
MI-16750-92	20900040	REAR PANEL		1
MI-16750-93	S0010500	CAP SCREW	5/16"-18UNCX1/2"	20
MI-16750-94	20900041	SHIELD PLATE		2
MI-16750-95	S0020408	CAP SCREW	1/4"X1/2"	8
MI-16750-96	20900042	RIGHT COVER		1

PARTS LIST FOR MI-16750

PART N0.	REF N0.	DESCRIPTION	SPECIFICATION	QTY
MI-16750-97	20900043	LEFT COVER		1
MI-16750-98	20900044	GRADUATED SCALE		1
MI-16750-99	20900045	INDICATOR		4
MI-16750-100	20900046	BELT PLATEN		1
MI-16750-101	20900047	MICRO-ADJUSTMENT BLOCK		2
MI-16750-102	20900048	MICRO-ADJUST. MOUNTING BRACKET		2
MI-16750-103	20900049	BEARING CAP		4
MI-16750-104	20900050	FRONT CONVEYOR ROLLER		1
MI-16750-105	20900051	POSITIONING PLATE		1
MI-16750-106	20900052	CONVEYOR DRIVE ROLLER		1
MI-16750-107	C1106202	BEARING	6202	4
MI-16750-108	S0120200	NYLON NUT	1/4"-20UNC	10
MI-16750-109	20900053	PAD		2
MI-16750-110	20900054	SHAFT JOINT		2
MI-16750-111	S0050404C	SCREW	1/4"-20UNCX1/4"L	2
MI-16750-112	20900055	ELECTRIC CONTROL BOX		1
MI-16750-113	20701011	ELECTRICAL INSULATION BOARD		1
MI-16750-114	S0040510M	PHILLIPS HEAD SCREW		2
MI-16750-115	W0000001	SAFETY SWITCH		1
MI-16750-116	S1017W-2	PLASTIC CLAMP		1
MI-16750-117	S1006P-4	PLASTIC CLAMP	6P-4	1
MI-16750-118B	M2090002	SPEED REDUCTION MOTOR		1
MI-16750-119B	20900073	PC BOARD		1
MI-16750-120	40501019	REGULATOR KNOB		1
MI-16750-121	40501018	PC BOARD MOUNTING PLATE		1
MI-16750-122	20900056	BOTTOM COVER, ELECTRIC CONTROL BOX		1
MI-16750-123	S0030304	PHILLIPS HEAD SCREW	3/16"-24UNCX1/4"L"	18
MI-16750-124	S0010615M	CAP SCREW	1/4"-20UNCX3/4"L	18
MI-16750-128	10401029	FOOT PAD		4
MI-16750-129	S0090512	SCREW	5/16"-18UNCX5/8"L	4
MI-16750-130	S0010503A	CAP SCREW	5/16"-18UNCX4"L	2
MI-16750-131	20900060	PRESSURE ROLLER	FRONT	2
MI-16750-131A	20900060A	PRESSURE ROLLER	REAR	1
MI-16750-132	20701006	BEARING		6
MI-16750-133	S0520028	CIRCLIP	S28	2
MI-16750-134	S0040410	PHILLIPS HEAD SCREW	1/4"-20UNCX5/8"L	4
MI-16750-135	V0017500	V-BELT		2
MI-16750-136	20900061	CONVEYOR BELT		1
MI-16750-137	L000000M	POWER CORD		1
MI-16750-138	L0000000	CORD		1
MI-16750-139	L2090001	SWITCH WIRE		2
MI-16750-140	L2090002A	WIRE WITH TERMINALS		2
MI-16750-141	20900062	SANDING BELT (SEE 15-253)	P80	1
MI-16750-142	20900063	SANDING BELT (SEE 15-255)	P120	1
MI-16750-143	J2090001	WARNING LABEL		1
MI-16750-144	J2090002	WARNING LABEL		1
MI-16750-145	10101002	COVER CUSHIONS		4
MI-16750-147	20900064	COVER PANEL		1

PARTS LIST FOR MI-16750

PART N0.	REF N0.	DESCRIPTION	SPECIFICATION	QTY
MI-16750-148	S0911214	COMBINATION WRENCH (NOT SHOWN)	12/14MM	1
MI-16750-149	S1206150	T HANDLE ALLEN WRENCH (NOT SHOWN)	6MM	1
MI-16750-149A	S1202100	T HANDLE ALLEN WRENCH (NOT SHOWN)	2MM	1
MI-16750-149B	S0910103	ALLEN KEY(NOT SHOWN)	5 MM	1
MI-16750-161	20900081	SPACER		1
MI-16750-162	20900082	SIDE PANEL		2
MI-16750-163	20900083	FRONT PANEL		1
MI-16750-164	20900084	REAR PANEL		1
MI-16750-165	20900100	SCALE POINTER		2
MI-16750-166	20900101	ADJUSTING COLLAR		2
MI-16750-167	J2090012	INDICATOR DIAL		2
MI-16750-168	S0030305	SCREW		2
MI-16750-169	S0050103	SCREW		2
MI-16750-170	S0050306N	SET SCREW	3/16"-24UNCX5/8"	6
MI-16750-192	S0230500M	LOCK WASHER		8
MI-16750-193	S0030310	SCREW	3/16"-24UNCX5/8"L	1