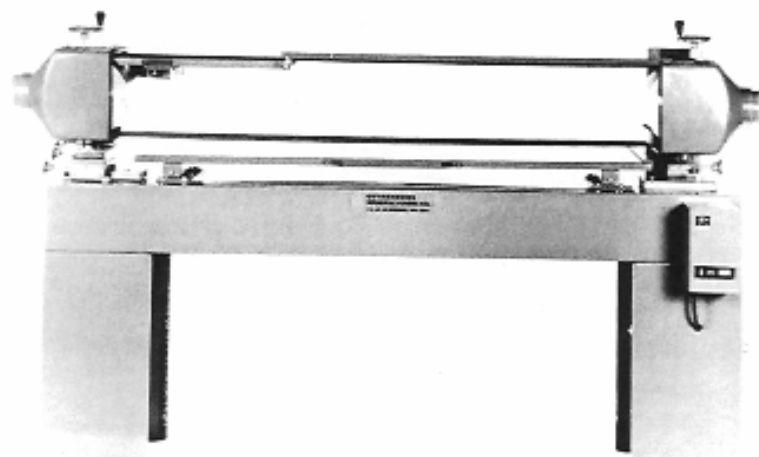


Study Carefully
Before Operating

OPERATORS' MANUAL AND REPAIR PARTS LIST

60" BELT-STROKE SANDER FINISHER



GOTHENBURG MANUFACTURING CO.

P.O. Box 308 • GOTHENBURG, NEBRASKA 69138 • (308) 537-3628

OPERATION

1. Place material to be sanded on sliding worktable with abrasive belt running approximately 1/2 inch above work. To adjust height of abrasive belt, release column clamping screws (28 Fig. 2) on both idler and power ends, and rotate drum raising cranks. Then relock clamping screws. Work with minimum belt tension.
2. Always place work against work-stop of table, to avoid accidental throwing. The standard work-stop is high enough on ordinary work, but a higher one can be bolted on if needed.
3. Flat pieces of irregular shape may require fixtures to prevent rotating. Multiple small work-pieces may be placed close together and held in a fixture.
4. Care must be taken when working near the edge of a work-piece that hand-stroker does not tilt and sand a rough edge. No part of hand-stroker should ever project beyond abrasive belt, otherwise a groove may be cut into work piece.
5. Work table should move forward and back while hand-stroker is kept moving sidewise to obtain a uniform surface. If hand-stroker is pressed on one spot only for even just a few seconds, a small depression will appear. Face of hand-stroker must be a flat surface at all times if you desire smooth flat surface. Whenever face of hand-stroker wears away, re-dress it smooth again, and either slightly round over the leading edge, or bevel it, and be careful that point of the screws holding handle in place do not project through.
6. Experiment with padded and unpadded stroker. Finish on certain materials is improved when padded; on others, not. Use canvas (wax it) or graphite treated heavy fabric over padding to reduce friction and promote wear.
7. On mere touch-up jobs or those requiring a minimum amount of stock removal and already having a flat surface, a useful kind of stroker is the #346007 Mitt, of graphite coated fabric. One advantage is less fatigue to manipulate, although it applies pressure to a smaller area than standard size stokers.
8. Apply floor wax to surface of unpadded hand-stroker, a little at a time. The extra slickness makes hand-stroking ever so much easier, lessens belt heat up, and lessens pitch formation. Too much floor wax however, may cause belt to slip on the power drum.
9. Drums may be used for sanding of contour cuts. Always move work opposite to the direction of abrasive belt travel.
10. Any material that can be ground, may be polished by using the proper abrasive belt. Metal hand-strokers that are fairly heavy may be used for burning or polishing metal parts. The weight of these metal hand-strokers provides enough pressure, and since metal polishes away slowly, there is little danger of removing too much metal.

MOUNTING THE AUXILIARY PLATEN

Many jobs, like drawer sanding, are best done with a platen. This reasonably priced accessory is Part No. 502143. See catalog. Easy attachment is achieved by using the following procedure:

1. Attach the platen to the platen bracket using the three 5/16 - 18 Hex Head Cap Screws and washers. Only start these screws; do not snug them up.
2. Start the three 5/16 - 18 x 1" Round Head Leveling screws into the platen.
3. Now, mount the above on the idler drum shaft housing, using the (4) 5/16 - 18 x 2 - 1/4" cap screws. Keep the platen bracket arm away from the drum and lock it down.
4. Finally, adjust the leveling screw so that the top of the platen is level with the top of the drum. Line up the platen with the drum unit and keeping it pulled out away from the drum unit; lock down the three attachment screws.

LUBRICATION

1. **Drum Shafts** run on needle bearings and have grease seals at each end of the bearing housing to retain the grease. Grease once daily or every other day depending upon usage, using ordinary automobile chassis grease.
2. **Idler Pulleys** run on needle bearings. Relubricate occasionally by loosening set screw in collars, remove collars and pulleys and add grease to the bearing and recesses in collars.
3. **Motor Bearings** are ball and are factory packed with grease. Once yearly, remove grease plugs and install a grease fitting. Inject a small amount of bearing grease. **Do not overlubricate.** If motor has a drain or relief plug at bottom of bearing remove this also before adding grease. Replace all plugs when finished.

GENERAL

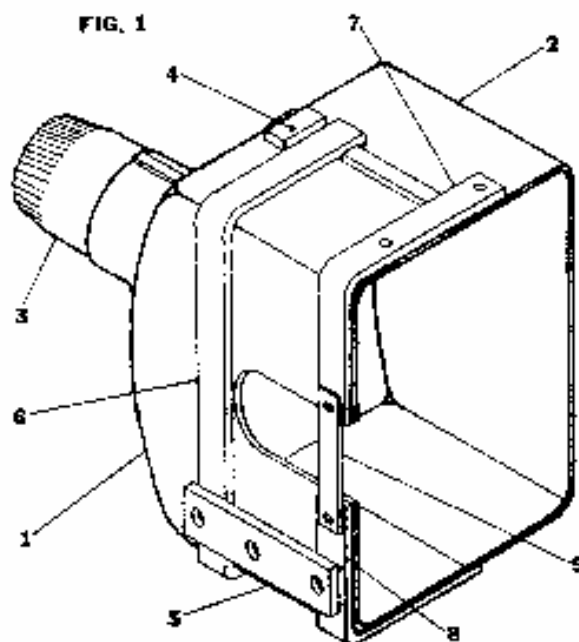
If you have purchased only the 502122 Drum Unit Set, be sure you mount both idler and power drum units on solid, level foundation. For ease in obtaining abrasive belts, position drums so you can use one of the following standardized belt lengths, 169" or 226". The above listed abrasive belts are 6" wide, flexible and cloth backed. For wood or metal use aluminum oxide. — Grits stocked are 150, 100, 80, 60, 50, and 40. Specify grit when ordering.

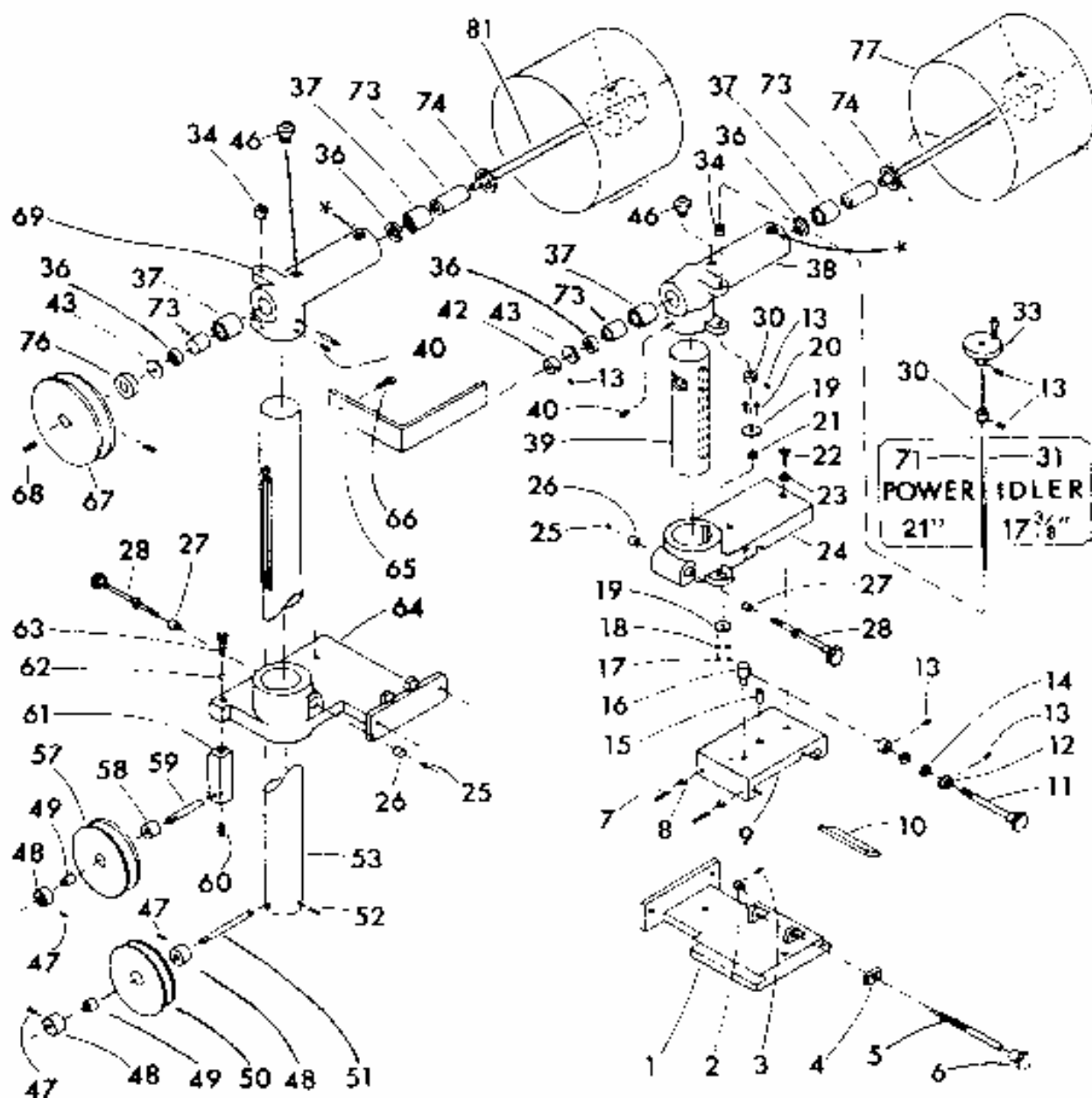
DRUM GUARD INSTALLATION

1. Remove one screw (3) from stiffener bar (2) and swing bar out of the way. Place hood in position and fasten it in place on Hood Mounting Safety Stop (4). Return stiffener bar to position and fasten securely.
2. A two piece hood (1-7) is provided to permit changing of abrasive belt. The outer hood is easily removed by the two draw catches.

DUST EXHAUSTING SYSTEM

1. The dust collector hood may be connected to your plant exhaust system. The cover on the right hand (power-end) drum guard is easily removed and may be attached to a 4" dust collector hose.
2. A satisfactory dust collector unit for this sander is one having a minimum of 1/3 horsepower and 1-1/4 to 1-1/2 cu. ft. or larger dust receptacle. Recirculating type is best.





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FIG. TWO DRUM UNIT PARTS

DRUM UNIT PARTS

DRUM UNIT ASSEMBLY-IDLER END

Fig. & Key	Part No.	Part Name	Amt.
	502049	Column Housing Assy., Idler End	1
1	502079	Base Casting, Idler End	1
2	502077	Collar, tensioning Screw	1
3	961095	Setscrew-Tensioning	1
4	502076	Nut, Tensioning Screw	1

ALUMINUM DRUM MODELS

Fig. & Key	Part No.	Part Name	Amt.
5	502078	Screw, Tensioning	1
6	500448	Star Wheel, (3/8 Bore)	1
7	961105	Screw, Gib Adjusting	2
8	968469	Nut, Gib Screw Jam	2

DRUM UNIT ASSEMBLY-IDLER END

Fig. & Part Key No.	Part Name	Amt.	Fig. & Part Key No.	Part Name	Amt.
9	502072 Slide Casting	1	31	502067 Screw, Drum Raising, Idler	1
10	502073 Gic	1	33	500293 Handwheel, Drum Raising	1
11	502062 Screw Assembly Belt tracking	1	34	902044 (Nice) Bearing, Raising Screw Ball Thrust	1
12	504140 Collar, Tracking Screw Outer & Inner	2			
13	961095 Setscrew, Collar	3	36	906279 Seal, Grease	2
14	923052 Washer, Tracking Screw Thrust	2	37	902042 Bearing, Needle	2
15	502075 Pin, Pivot	1	38	502050 Housing, Idler End (needle bearing model counter clockwise)	1
16	502074 Nut, Tracking Screw	1			
17	969005 Nut, Retainer Washer Screw	2	39	502047 Column Assembly Idler End (includes Key)	1
18	923426 Lockwasher	2	NS	504313 Key, Column, Idler End	1
19	502071 Washer, Floating Nut Retaining	2	40	961095 Setscrew, Column to Bearing Housing Fastening	2
20	965072 Screw, Retainer Washer Fastening	2			
21	502070 Nut, Raising Screw	1	41	911374 Grease Zerk	1
22	963007 Screw, Column Idler End Support to Slide Casting Fastening	2	42	502057 Collar, idler Shaft Thrust	1
23	923053 Washer, Support to slide casting	2	43	923708 Washer, Bearing & Thrust	1
24	502064 Support, Column, Idler End	1	46	911375 Zerk Grease Fitting	1
25	968008 Nut	1	73	902045 Race, Bearing	2
26	500372 Plug, Column lock, outside	1	74	923708 Washer Thrust, Drum End	1
27	500373 Plug, Column lock, plain side	1	77	502124 Drum and Shaft Assembly	1
28	504169 Clamping Screw Assembly, Column	1			
30	502069 Collar, Raising Screw	2			

DRUM UNIT PARTS - ALUMINUM DRUM MODELS

DRUM UNIT ASSEMBLY-POWER END

NS	502137	Column & Housing Assy., Power End	1	41	911374	Grease Zerk	1
17	968005	Nut, Retainer Washer Screw	2	43	923708	Washer	1
18	923426	Lockwasher	2	46	911375	Zerk	1
19	502071	Washer, Floating Nut Retaining	2	47	961085	Setscrew, Thrust Collar	1
20	965072	Screw, Retaining Washer, Fastening	2	48	502092	Collar, Flat Idler Pulley Thrust	1
21	502070	Nut, Raising Screw Power End	1	49	902043	(Torrington) Bearing Flat Idler Pulley Needle	1
25	968008	Nut	1	50	502091	Pulley, Flat Flanged Idler	1
26	500372	Plug, Column Lock, Nut side	1	51	502090	Shaft, Column Pulley	1
27	500373	Plug, Column Lock, Plain Side	1	52	961125	Setscrew, Shaft to Column Retaining	1
28	504169	Starwheel & Screw Assy., Column Locking	1	53	502081	Column Assembly, Power End, Includes Key	1
30	502069	Collar, Raising Screw	2	NS	504314	Key, Column, P.E.	1
33	500293	Handwheel	1	57	502088	Pulley, V-Idler	1
34	902044	(Nice) Bearing, Raising Screw Ball Thrust	1	NS	501797	V-Idler Pulley Assbly.	1
36	906279	Seal, Grease	2	NS	501798	Flat Idler Pulley Assbly.	1
37	902042	Bearing, Needle V-Pulley, Power	2				
40	963003	Setscrew, Column to Bearing Housing	2				

DRUM UNIT ASSEMBLY - POWER END

Fig. & Key	Part No.	Part Name	Amt.	Fig. & Key	Part No.	Part Name	Amt.
58	502094	Collar, Vee Idler Pulley, Inner	1	71	502086	Screw, Drum Raising	1
59	502093	Shaft, V-Idler Pulley	1	72	925145	Groove Pin, Housing to Column	1
60	961103	Setscrew, Shaft to Support Fastening	1	73	902045	Race, Bearing	2
6*	502087	Support, Stationary Idler Pulley (V Pulley)	1	74	923708	Washer, Thrust Drum End	1
62	923431	Lockwasher, Post Fastening Screw	1	76	502089	Spacer, Thrust Drum End	1
63	963057	Screw, Post to Base Casting Fastening	1	81	502128	Drum & Shaft Assy.	1
64	502085	Base Casting, P.E.	1	NS*	911354	Wrench	1
65	500003	Guard, Stroker Safety Stop	1	NS*	911355	Wrench	1
66	963028	Screw, Guard to Power End Column Fastening	1	DRUM UNIT PARTS EXCLUSIVELY FOR ALUMINUM TYPE			
67	911490	V-Pulley, P.E. 5"	1				
68	504293	Key	1	NS	502123	Aluminum Drum Unit Assembly, Idler End	1
69	502060	Housing, Power End (needle bearing model counterclockwise)	1	77	502124	Aluminum Drum & Shaft Assembly, Idler End	1
				NS	502127	Aluminum Drum Unit Assembly, Power End	1
				81	502128	Aluminum Drum & Shaft Assembly, Power End with Inner Races	1

FIGURE 1 PAGE 3 — HOOD ASSEMBLIES

	501776	Power End Hood, Comp	1		501777	Idler End Hood	1
1	500001	Hood, Fixed	1	1	500001	Hood, Fixed	1
2	500291	Hood, Removable	1	2	500291	Hood, Removable	1
3	501770	Hose Adaptor Std. 4-1/2" (4" optional)	1	4	946008	Draw Catch	2
4	946008	Draw Catch	2	5	500004	Mounting Plate	1
5	500003	Guard Safety Stop (Std. with machine)	1	6	502377	"U" Bracket Assy.	1
6	502377	"U" Bracket Assy.	1	7	501773	Bracket	1
7	501766	Bracket	1	8	502379	Bracket Assembly	1
8	502379	Bracket Assembly	1	9	501775	Re-Enforcing Bar	1
9	501775	Re-Enforcing Bar	1				

FIGURE 3 PAGE 7 — FLOOR STAND, TABLE, AND BELT GUARD

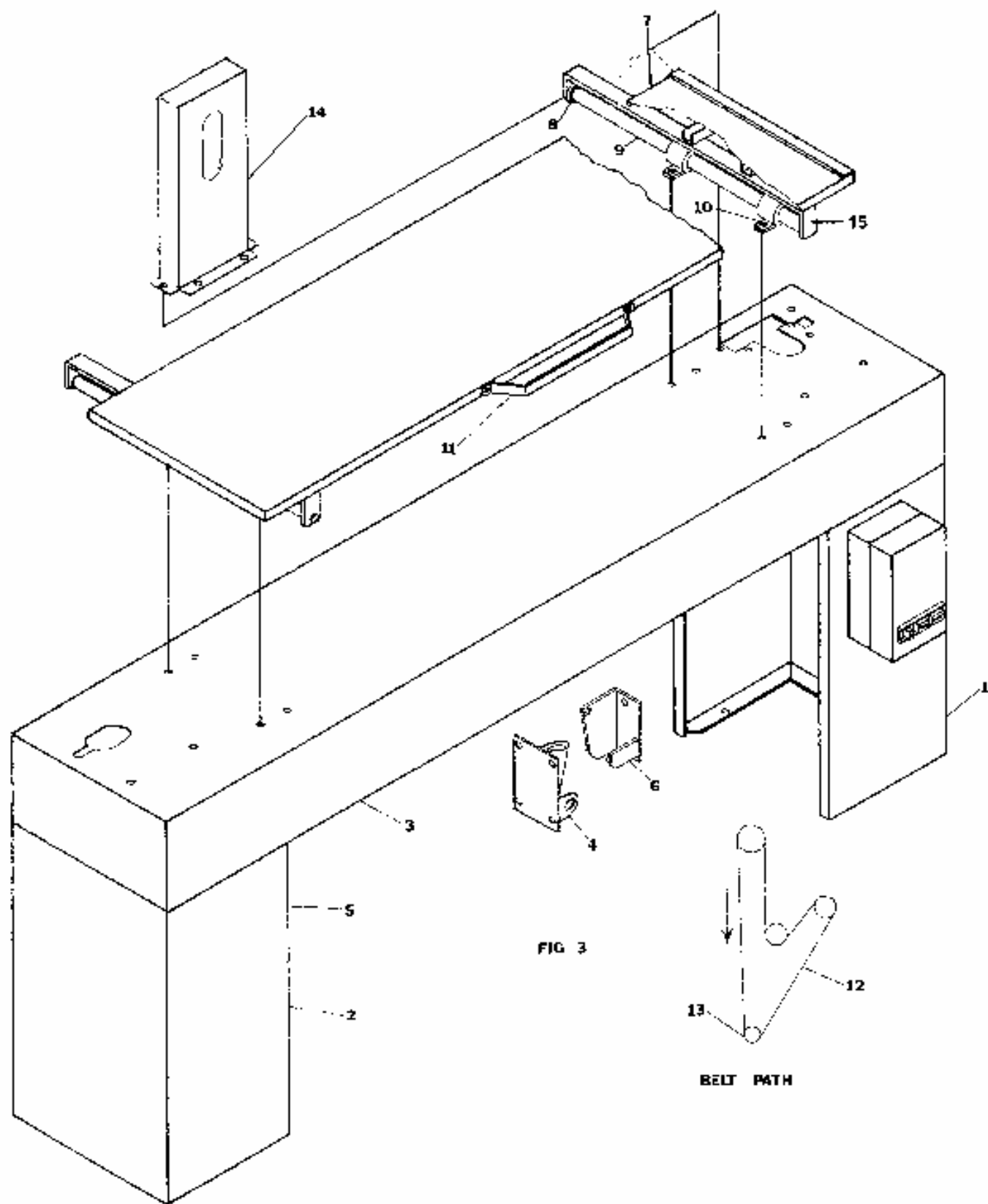
1	504093	Column, Power End	1	9	503016	Ball Bushing Shaft	1
2	504094	Column, Idler End	1	10	503024	Ball Bushing Assy., Complete with Ball Bushings	4
3	504098	Center Panel Weldment	1	11	502089	Handle	1
4	500300	Motor Mtg. Plate	1	12	911868	V-Belt	1
5	907507	Gecal	1	13	911489	Motor Pulley	1
6	502110	Motor Mount Weldment	1	14	504352	Belt Guard	1
7	502087	Table Weldment	1	15	504231	Table Mounting Bracket	2
8	975012	Rubber Bumper	4				

NS* 502100 Hand Stroker

NS* 946007 Mitt Stroker

NS* 502096 Table, Complete, includes Key Nos. 7, 8, 9, 10 and 11

NS* - Not shown in literature



NOTES: 1. Minimum Order \$10.00

2. Prices in this list apply only to parts ordered for repair or replacement. They are not to be used for "allowance" values when ordering machines "less" certain parts. Write for quotation on such special machines.

3. Please indicate machine serial number when ordering repair or spare parts.

4. All prices are F.O.B. Warehouse and subject to change without notice.

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