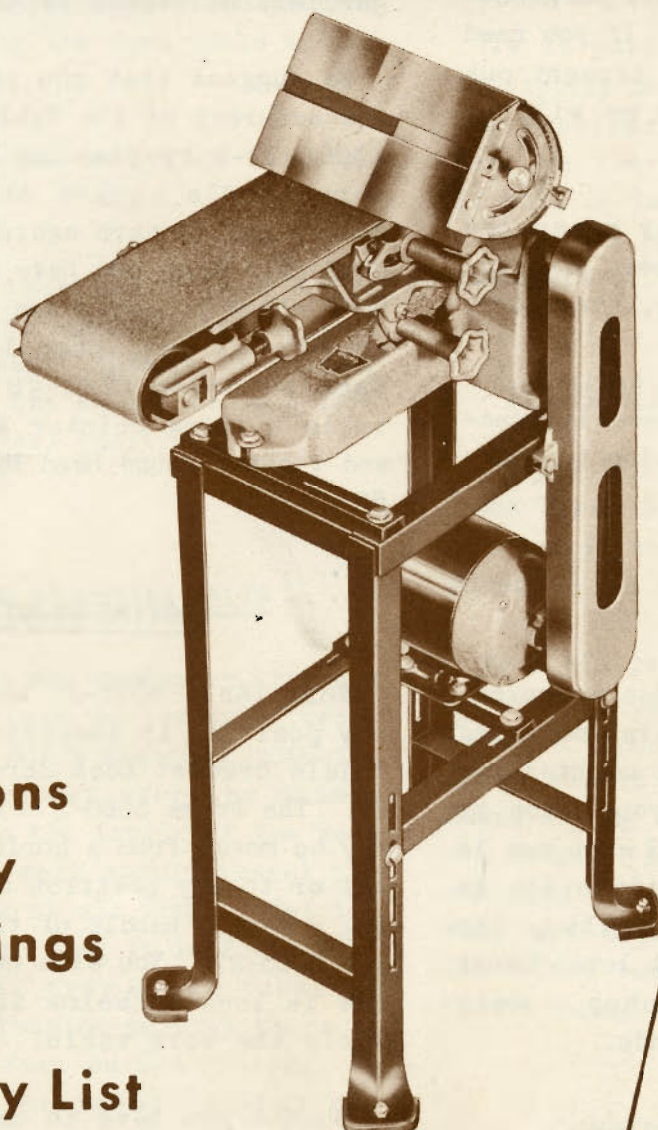


Keep this book for future reference

INSTRUCTION BOOK

for the

DURO 6-INCH SANDER



- Instructions
- Assembly
Drawings
- Parts List
- Accessory List

Read this book
carefully be-
fore operating
your DURO
SANDER

DURO METAL PRODUCTS CO.

2651 North Kildare Avenue, Chicago 39, Illinois

INSTRUCTION SHEET AND PARTS LIST

FOR

3065 SANDER

GENERAL INSTRUCTIONS

These instructions will assist you greatly in caring for your sander. If you need any more information than is brought out herein, please write us and we will be very glad to assist you.

This machine is completely assembled when you receive it. It has been checked, run and adjusted at the factory, therefore, it is ready for operation.

We suggest that you read these instructions carefully before attempting to operate your sander.

Please be certain that this table does not ride on the garnet or emery belt regardless of degree of tilt.

We suggest that you occasionally check the accuracy of the Table Tilting Pointer A3006-11-7 by placing a machinist's or carpenter's square on the Belt Table 3065-7 and in turn against the Work Table 3065-22. When you have secured a perfect 90°, check to determine if the pointer is at "0", if not, then loosen Round Head Machine Screw ST42-#8 x 1/8", set the table Tilting Pointer A3006-11-7 at "0" and tighten Round Head Machine Screw ST42-#8 x 1/8".

MOUNTING

Our Steel Stand 3161 provides a convenient, economical and substantial mounting for your sander. A sander so mounted may be moved to the center of your shop or pushed back against the wall when not in use - a most important consideration in shops of small floor area. Also, the sander may be bolted to a flat level bench or stand already in your shop - many craftsmen build their own stands.

WORK TABLE

The Work Table 3065-22 is used normally when the sander is in a vertical position. Also, it may be used as a back stop when the sander is in a horizontal position.

WORKING ADJUSTMENTS

Work Table 3065-22 may be adjusted to any position by loosening and tightening Saddle Bracket Lock Screw Assembly 3065-27. The Frame 3065-2 of the sander itself, may be moved from a horizontal to a vertical or to any position between by loosening a second handle of the same type, number 3065-27. You will note that this handle is located below the one which controls the work table.

Should you have to sand long, oval or round pieces, set the sander in a vertical position and run these pieces across the flexible portion of the belt in the back of the sander. If you wish to use the flexible belt feature, operating from the front of the sander with the work table as

a base for jigs or fixtures, proceed according to the directions given in the following paragraph.

Release tension on the sanding, garnet or emery belt by loosening Driven Drum Adjusting Screw Assembly 3065-18-2 and remove the belt. Loosen two Square Head Set Screws ST20-5/16" x 1/2" which will permit removal of Belt Table 3065-7. You may replace the belt which you have been using, secure the proper tension and then proceed with your work using the work table as the base.

Curved surfaces are sanded on the edge of the driven drum.

The sander is equipped with a mitre gauge assembly which operates in the slot of Work Table 3065-22. This is, of course, used normally when the sander is in a vertical or semi-vertical position.

CHANGING AND ADJUSTING BELTS

When belt changes are necessary, release the tension on the same by loosening driven Drum Adjusting Screw Assembly 3065-18-2. Place the new belt over the drums, noting the arrow on the inside of the belt indicates that the belt should travel toward the work table at all times. Set the belt on the drums so that it is flush with the edges, turn it over a few times by hand, take up the tension so that there is no slack and then turn on the switch. We suggest that you be ready to shut the power off immediately if the belt is not tracking properly. Make further adjustments by tightening on the left adjusting screw assembly if the belt seems to be tracking towards that side or vice versa if it is traveling to the right. Avoid too much tension.

BEARINGS

Self-lubricating bronze bearings are used in this machine and we suggest that you fill Drive Oil Cups ST51-3/16" every eight to ten operating hours. Bearings will absorb oil if they need it. DO NOT DRILL HOLES IN THESE BEARINGS.

BEARING REPLACEMENT

It is possible that you may have some difficulty in replacing the self-lubricating bearings in this sander, therefore, have the bearings replaced by our factory. If this is impossible, take the sander to a reputable machine repair company for replacement of these bearings.

INSTALLATION OF NEW TIRES OR SLEEVES

If you find it necessary to replace the Drum Tires 3065-10, we suggest that you proceed in accordance with the directions given in the next paragraph.

Wash all parts with naptha or gasoline, procure a good grade of rubber cement and paint a thin coat on the inside of the tires and on the drums. Allow about two hours drying time. Apply a second coat to the drums. After two hours have expired submerge the tires in naptha or gasoline, slip them over the drums while wet and allow about twenty-four hours drying time before using the sander.

MOTOR - SWITCH - WIRING

You should use a 1 H.P. 1750 R.P.M. ball bearing motor for heavy work or a 1/2 H.P. motor for average work. For very light work use a 1/3 H.P. motor. A 2" pulley should be used on a 1750 R.P.M. motor.

The V belt used on this unit should not be tightened too much but just sufficiently so that it will not slip or whip. A belt tighter than suggested will wear out faster and will cause an excess drag on the motor. It may injure the bearings in both the motor and the machine.

Our Double Pole Switch 301586 may be used with this unit for single phase 110-220 volt motors up to 1 H.P. If you use this switch, we suggest that you follow the directions given herein on wiring.

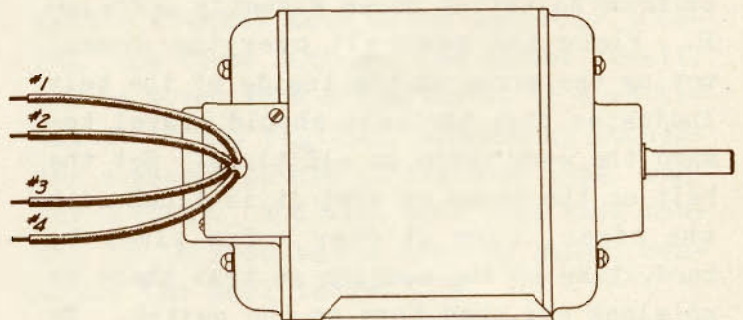
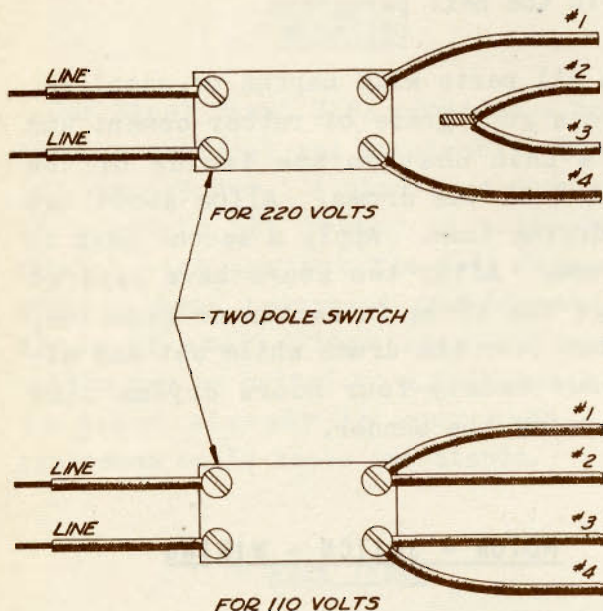
The directions for wiring cover all single phase motors up to 1 H.P., therefore, this unit will operate satisfactorily on most house currents.

The first step in connecting the motor with the switch is to secure sufficient 14 gauge two conductor BX or heavy cord,

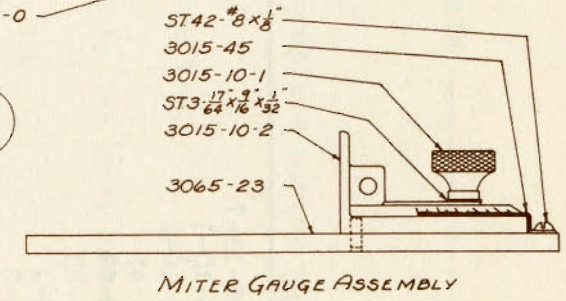
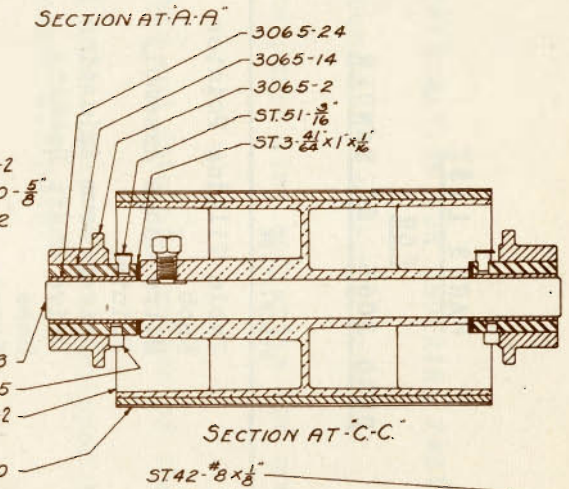
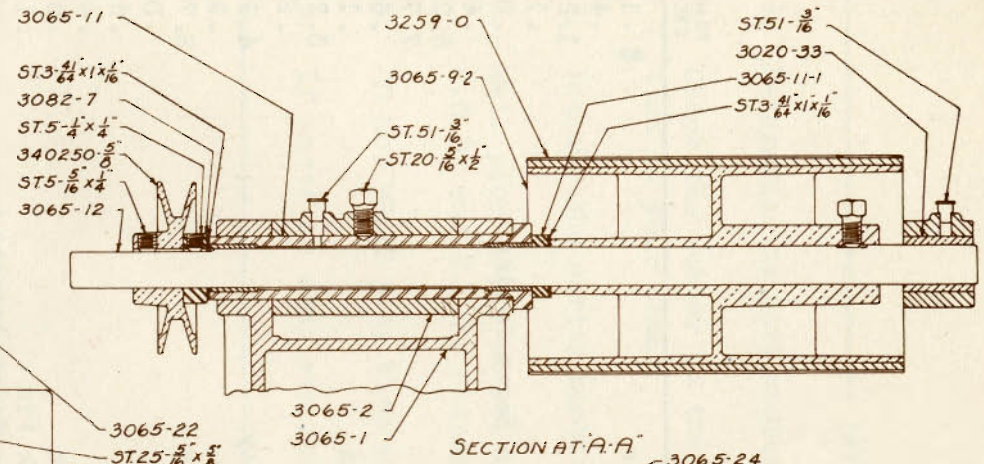
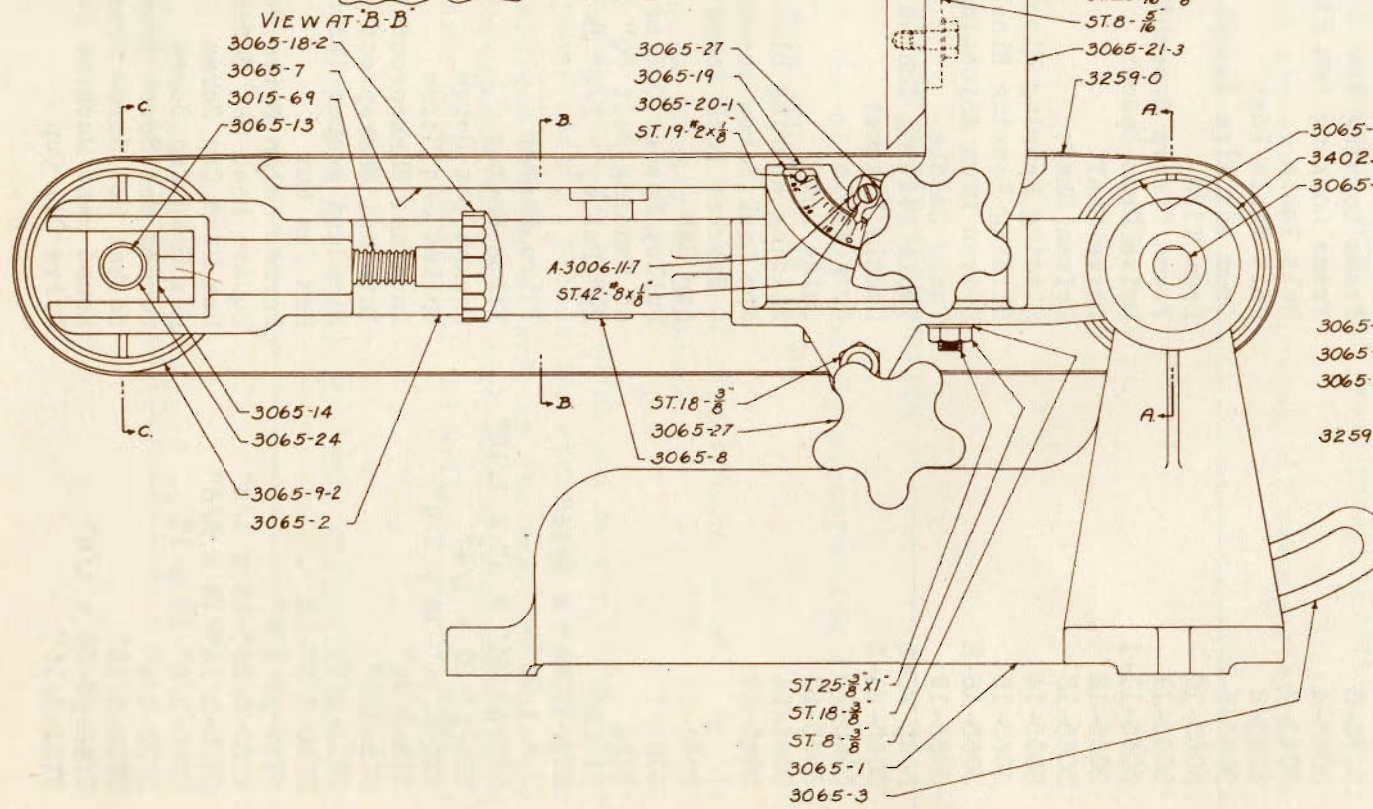
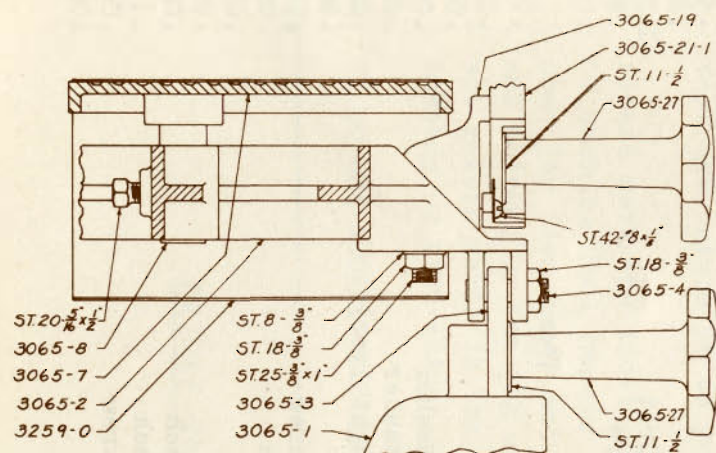
strip both ends, connect one end to the switch and the other end to the motor.

If you have a single voltage motor, attach #1 and #2 or A and B motor leads to one switch wire. Attach #3 and #4 or C and D motor leads to the other switch wire. If dual voltage (110-220 volt), for 110 or low current attach as above, but for 220 or high current attach #2 and #3 or B and C together using #1 or A to the switch lead and #4 or D to the other switch lead. When wiring for 220 volt or high current, completely tape #2 and #3 or B and C.

If this unit is to be installed in an industrial shop, switch of double pole type is sufficient for any single phase motor up to 1-1/2 H.P. If three phase current is to be used you must use a three pole switch. We suggest that you have an electrician wire the 3 phase system.



DOUBLE POLE SWITCH WIRING DIAGRAM



MITER GAUGE ASSEMBLY

PARTS LIST
FOR
DURO 3065 6" SANDER

QUAN. USED	PART NO.	DESCRIPTION	PRICE EACH
1	A3006-11-7	Table Tilting Pointer	\$.11
1	3015-10-1	Knob	.46
1	3015-10-2	Mitre Gauge Assembly	1.26
1	3015-45	Pointer	.11
2	3015-69	Driven Drum Adjusting Screw Spring	.20
1	3020-33	Drive Shaft Bushing	.40
1	3065-1	Base	6.03
1	3065-2	Frame	7.76
1	3065-3	Frame Locking Arm	.66
1	3065-4	Frame Locking Arm Pin	.11
1	3065-7	Belt Table	3.71
2	3065-8	Belt Table Post	.27
2	3065-9-2	Drum and Tire Assembly	4.91
2	3065-10	Drum Tire	.99
1	3065-11	Frame Sleeve Assembly	3.78
1	3065-11-1	Drive Drum Spacer	.20
1	3065-12	Drive Shaft	.66
1	3065-13	Driven Shaft	.46
2	3065-14	Sliding Bearing Block	.53
2	3065-15	Sliding Bearing Block Pin	.11
2	3065-18-2	Driven Drum Adjusting Screw Assembly	.53
1	3065-19	Table Saddle	2.19
1	3065-20-2	Table Tilting Indicator Plate	.20
1	3065-21-3	Saddle Bracket	1.00
1	3065-22	Work Table	5.10
1	3065-23	Guide Bar	.93
2	3065-24	Sliding Bearing Block Shaft Bushing	.40
2	3065-27	Arm Lock Screw Assembly (Saddle Bracket Lock Screw Assembly)	.88
1	3065-BS	Bag Set	.45
1	3082-7	Pulley Spacer Collar	.27
1	3259	6" Sanding Belt "O" Grit	1.32
1	340250	2 $\frac{1}{2}$ " Pulley - 5/8" Bore	.69
2	ST3-17/64" x 9/16" x 1/32"	Fibre Washer	.05
4	ST3-41/64" x 1" x 1/16"	Fibre Washer	.05
1	ST5- $\frac{1}{4}$ "-20 x 1/4"	Socket Set Screw	.05
1	ST5-5/16"-18 x 1/4"	Socket Set Screw	.05
3	ST8-5/16"	Internal Shakeproof Washer	.05
2	ST8-3/8"	Internal Shakeproof Washer	.05
2	ST11-1/2"	Standard Washer (Wrought Iron)	.05
3	ST18-3/8"-16	Hex Jam Nut	.05
2	ST19-#2-1/8"	Parker Kalon Drive Screw	.05
3	ST20-5/16"-18 x 1/2"	Square Head Set Screw	.05
3	ST25-5/16"-18 x 5/8"	Hex Head Cap Screw	.05
2	ST25-3/8"-16 x 1"	Hex Head Cap Screw	.05
1	ST33-1/4"	Socket Set Screw Wrench	.08
1	ST33-5/16"	Socket Set Screw Wrench	.11
2	ST42-#8-32 x 1/8"	Round Head Machine Screw	.05
4	ST51-3/16"	Drive Oil Cup	.05

INFORMATION FOR ORDERING PARTS

1. Determine the part number on the assembly drawing.
2. Check the number on the parts list and write the complete number and description on your order.
3. Include the serial number and date of purchase of the tool.
4. Mail your order to us. The parts will be shipped by the most prompt method, C.O.D. and F.O.B. Chicago, Illinois.
5. DO NOT WRITE your name and address: PRINT and avoid possible errors.
6. If parts or complete tool are sent to us, prepay all transportation charges.

REPAIR ORDER INFORMATION

1. Write us completely about the difficulty you are experiencing with your tool and explain what repair work you wish us to do.
2. Unless you request a quotation as to cost of repair work, we will repair your tool and return it to you as quickly as possible.
3. Please mark the label on all parts or tools which you return to us "Attention of Machine Tool Repair Department". Please tag each tool or part with your name (or firm name) and address printed clearly on the tag. Be sure the name and address on the tag corresponds with that used when writing us - that is, do not return parts in the name of an individual and write us in the name of your company or vice versa.
4. WE DO NOT ACCEPT RESPONSIBILITY FOR ANY TOOLS REPAIRED OUTSIDE OF OUR FACTORY.

PRICES SUBJECT TO CHANGE WITHOUT NOTICE

ACCESSORIES FOR 6" BELT SANDER

CATALOG NO.	DESCRIPTION	PRICE EACH
306532	Dust Chute	\$ 5.26
306590	Belt and Pulley Guard (See illustration on front cover)	7.92
3161	13" wide x 20" long x 28-7/8" high Steel Stand (See illustration on front cover)	10.52
3259	6" wide x 44 $\frac{1}{2}$ " long Endless Belt - Garnet - $\frac{1}{2}$ - 0 - 00 State grit wanted	1.32
3262	6" wide x 44 $\frac{1}{2}$ " long Endless Belt - Emery - Fine, Medium and Coarse State grit wanted	1.50
340200	2" V Pulley, $\frac{1}{2}$ ", 5/8" Bore (Bore depends upon size of motor shaft.)	.55
360244	44" V Belt. For use with sander when mounting on 3161 Steel Stand	1.40



301586 Remote Control Switch

Double Pole Toggle Switch approved by Underwriters' Laboratories. Positive in action, insuring complete current cut-off. Steel cover box protects switch. quickly attached to stand in most convenient place. Brings control of tools in easy reach. Use with motor up to 1 HP 220 volts. Complete with instructions for installing.

\$ 4.57