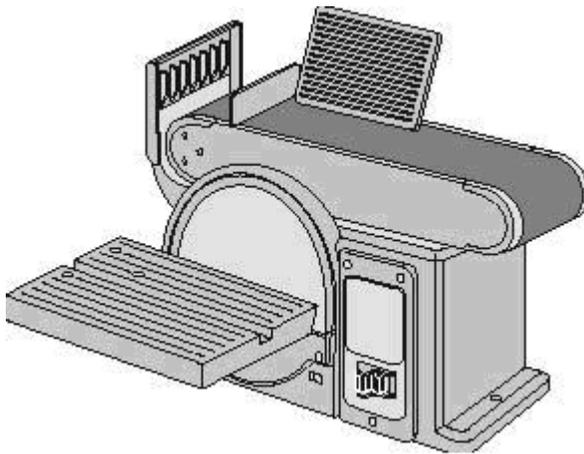


PERFORMAX™

4" x 36" Belt/Disc Sander



DO NOT RETURN TO STORE

**Questions? Problems?
Please call our customer help line:**

(888) 315-3080 M-F 8-5 CST or
by email:
partsandservice@greatlakestec.com

Model 90227

Operation and Safety Instructions

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Technical data

4" x 36" Belt/Disc Sander	Model: 90227
Motor:	120 V, 60 Hz, 6.0 A
Speed:	
Motor:	3450 RPM (no load)
Disc:	3450 RPM
Belt:	2150 FPM
Dimensions:	17-1/2" x 7-1/2" x 11" (44.5 x 19 x 28 cm)
Belt size:	4" x 36" (10.2 x 91.4 cm)
Belt table size:	6" x 4" (15.2 x 10.2 cm)
Belt bed tilt:	0–90°
Belt table tilt:	45–90°
Disc diameter:	8" (20.3 cm)
Disc table size:	10-1/2" x 6-1/4" (26.7 x 15.4 cm)
Disc table tilt:	0–45°
Dust port size:	2-1/4" (Diameter)
Net weight:	43 lb (19.5 kg)

General safety rules

Safety is a combination of common sense, staying alert, and knowing how your belt/disc sander works. **SAVE THESE SAFETY INSTRUCTIONS.**



WARNING: To avoid mistakes that could cause serious injury, do not plug in the sander until the following steps have been read and understood.

1. **READ** and become familiar with this entire instruction manual. **LEARN** the tool's applications, limitations, and possible hazards.
2. **AVOID DANGEROUS CONDITIONS.** Do not use power tools in wet or damp areas or expose them to rain. Keep work areas well-lit.
3. **DO NOT** use power tools in the presence of flammable liquids or gases.
4. **ALWAYS** keep your work area clean, uncluttered, and well-lit. **DO NOT** work on floor surfaces that are slippery.
5. **KEEP BYSTANDERS AT A SAFE DISTANCE** from the work area, especially when the tool is operating. **NEVER** allow children or pets near the tool.
6. **DO NOT FORCE THE TOOL** to do a job for which it was not designed.
7. **DRESS FOR SAFETY.** Do not wear loose clothing, gloves, neckties, or jewelry (rings, watches, etc.) when operating the tool. Inappropriate clothing and items can get caught in moving parts and draw you in. **ALWAYS** wear non-slip footwear and tie back long hair.
8. **WEAR A FACE MASK OR DUST MASK** as the sanding operation produces dust.



WARNING: Dust generated from certain materials can be hazardous to your health. Always operate this tool in a well-ventilated area and provide for proper dust removal. Use dust collection systems whenever possible.

9. **ALWAYS** remove the power cord plug from the electrical outlet when making adjustments, changing parts, cleaning or working on the tool.
10. **KEEP GUARDS IN PLACE AND IN WORKING ORDER.**
11. **AVOID ACCIDENTAL START-UPS.** Make sure the power switch is in the OFF position before plugging in the power cord.
12. **REMOVE ADJUSTMENT TOOLS.** Always make sure all adjustment tools are removed from the sander before turning it on.

General safety rules (continued)

13. **NEVER LEAVE A RUNNING TOOL UNATTENDED.** Turn the power switch to OFF. Do not leave the tool until it has come to a complete stop.
14. **NEVER STAND ON A TOOL.** Serious injury could result if the tool tips or is accidentally hit. **DO NOT** store anything above or near the tool.
15. **DO NOT OVERREACH.** Keep proper footing and balance at all times. Wear oil-resistant rubber-soled footwear. Keep the floor clear of oil, scrap, and other debris.
16. **MAINTAIN TOOLS PROPERLY. ALWAYS** keep tools clean and in good working order. Follow instructions for lubricating and changing accessories.
17. **CHECK FOR DAMAGED PARTS.** Check for alignment of moving parts, jamming, breakage, improper mounting, or any other conditions that may affect the tool's operation. Any part that is damaged should be properly repaired or replaced before use.
18. **MAKE THE WORKSHOP CHILDPROOF.** Use padlocks and master switches and **ALWAYS** remove starter keys.
19. **DO NOT** operate the tool if you are under the influence of drugs, alcohol, or medication that could affect your ability to use the tool properly.
20. **USE SAFETY GOGGLES AT ALL TIMES**—that comply with ANSI Z87.1. Normal safety glasses only have impact resistant lenses and are not designed for safety. Wear a face or dust mask when working in a dusty environment. Use ear protection, such as plugs or muffs, during extended periods of operation.



Specific safety rules for belt/disc sanders



WARNING: Do not operate this tool until it is completely assembled and installed according to the instructions.

1. This sander is designed to sand wood or wood-like products only. Sanding or grinding other materials could result in fire, injury, or damage to the workpiece.
2. Use the sander on horizontal surfaces only. Operating the sander when mounted on non-horizontal surfaces might result in motor damage.
3. Fasten the sander securely to a bench top or supporting surface in order to stop it from tipping over or moving when in use.
4. 4. Make sure the sanding belt is installed in the correct direction. See directional arrow on back of belt.
5. Always have the tracking adjusted properly so the belt does not run off the pulleys.
6. Do not use sanding belts or discs that are damaged, torn, or loose. Use only correct size sanding belt and disc.
7. 7. Always hold the workpiece firmly when sanding. Keep hands away from sanding belt or disc. Sand only one workpiece at a time.
8. 8. Always hold the workpiece firmly on the table when using the disc sander and when using the belt sander.
9. 9. Always sand on the downward side of the sanding disc when using the disc sander. Sanding on the upward side of the disc could cause the workpiece to fly out of position, resulting in injury.
10. 10. Always maintain a minimum clearance of 1/16 inch (1.6 mm) or less between the table or backstop and the sanding belt or disc.
11. 11. Do not sand pieces of material that are too small to be safely supported.
12. 12. When sanding a large workpiece, provide additional support at table height.

Specific safety rules for belt/disc sanders (continued)

13. Do not sand with the workpiece unsupported. Support the workpiece with the backstop or table. The only exception is curved work performed on the outer sanding drum.
14. Always remove scrap pieces and other objects from the table, backstop, or belt before turning the sander ON.
15. Never perform layout, assembly or set-up work on the table while the sander is operating.
16. Never use solvents to clean plastic parts. Solvents could dissolve or otherwise damage the material. Use only a soft damp cloth to clean plastic parts.
17. Should any part of your sander be missing, damaged, or fail in any way, or any electrical components fail to perform properly, shut off switch and remove plug from power supply outlet. Replace missing, damaged, or failed parts before resuming operation.
18. Never pull the power cord out of the receptacle. Keep cords away from heat, oil, and sharp edges.
19. Have an electrician replace or repair damaged or worn cords immediately.

Electrical information

Grounding instructions

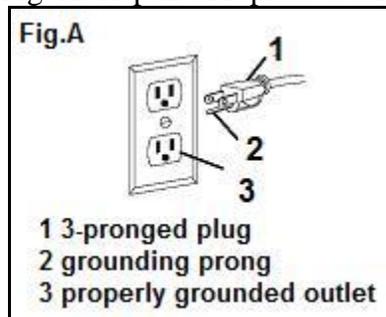
IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides the path of least resistance for electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching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

IMPROPER CONNECTION of the equipment grounding conductor can result in electric shock. The conductor with the 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 licensed electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure if the tool is properly grounded.

USE ONLY THREE-WIRE EXTENSION CORDS that have 3-pronged plugs and outlets that accept the tool's plug as shown in Fig. A. Repair or replace a damaged or worn cord immediately.



CAUTION: In all cases, make certain the outlet in question is properly grounded. If you are not sure if it is, have a licensed electrician check the outlet.

Electrical information (continued)

Guidelines for using extension cords



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

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 overheating. The table below shows the correct size to be used according to cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Minimum gauge for Extension Cords (AWG)
(When using 120V only)

Ampere Rating		Total Length of Cord in feet			
More Than	Not More Than	25	50	100	150
0	6	18	16	16	14
6	10	18	16	14	12
10	12	16	16	14	12
12	16	14	12	Not Recommended	

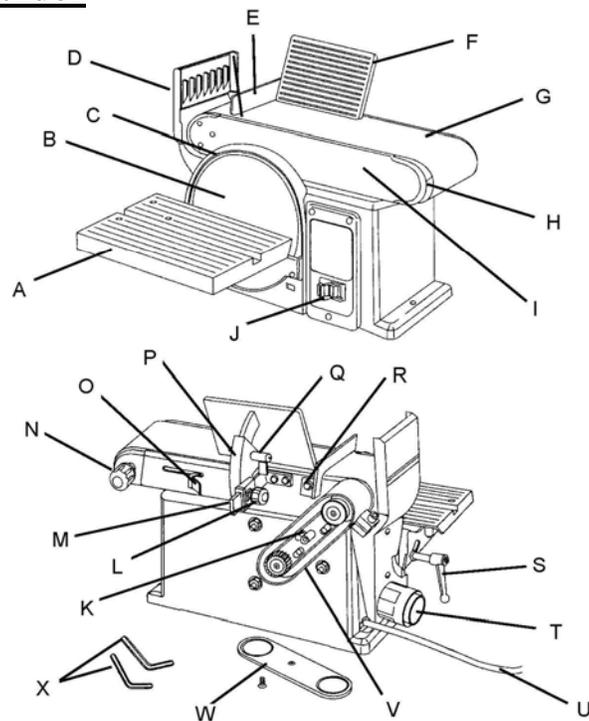
Be sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat and damp or wet areas. Use a separate electrical circuit for your tools. This circuit must not be less than a #12 wire and should be protected with a 15 A time-delayed fuse. Before connecting the motor to the power line, make sure the switch is in the OFF position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.



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

Know your belt/disc sander



A	Disc table	M	Holding bracket
B	Sanding disc	N	Tracking knob
C	Sanding plate	O	Tension lever
D	Dust deflector	P	Table adjusting bracket
E	Backstop	Q	Tilt lock
F	Belt table	R	Backstop locking screw
G	Sanding belt	S	Spring loaded handle
H	Idler drum	T	Dust chute
I	Belt bed	U	Power cord
J	On/off switch with safety Key	V	Drive belt housing
K	Drive belt	W	Drive belt housing cover
L	Belt table adjust knob	X	Hex wrenches (5 and 6 mm)

The disc table is used to support a workpiece when using sanding disc or when using belt sander in vertical position.

The belt table is used to support a workpiece when edge sanding on the belt only. The backstop holds the workpiece when using sander in horizontal position, and can be removed when the sanding operation requires use of the entire belt.

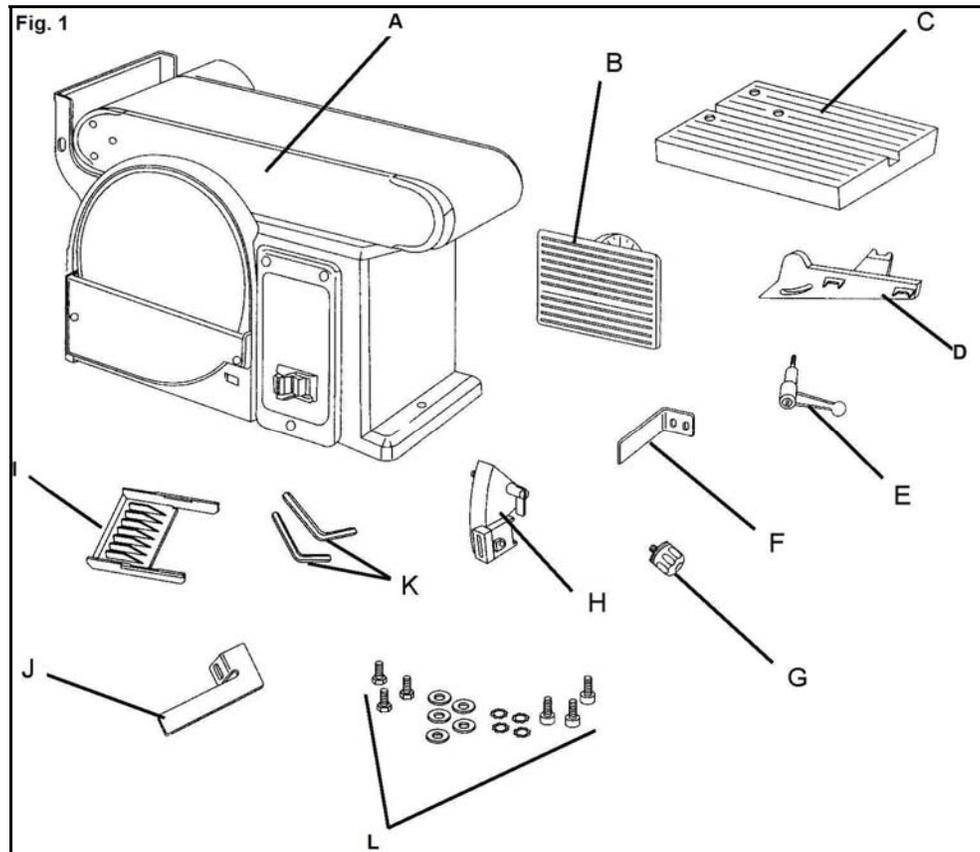
Assembly and adjustments

Unpacking (Fig. 1)



WARNING: To avoid injury from accidental starting, turn switch OFF and remove plug from power source outlet before making any adjustments.

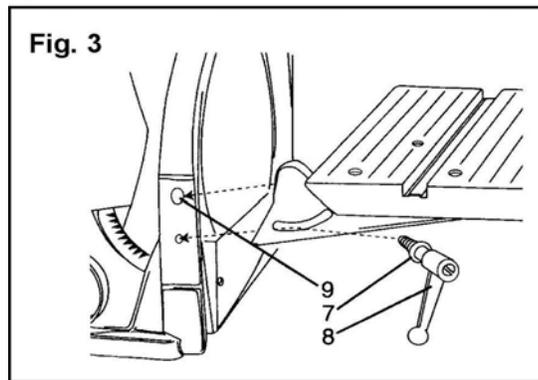
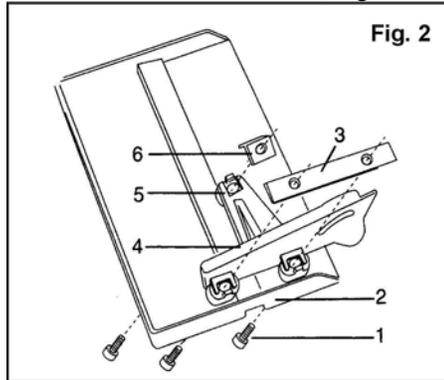
Carefully unpack the belt/disc sander and all its parts, and compare against the list below. Do not discard the carton or any packaging until the belt/disc sander is completely assembled.



- | | | | |
|---|----------------------|---|------------------------------|
| A | Belt/disc sander | G | Belt table knob |
| B | Belt table | H | Belt table adjusting bracket |
| C | Disc table | I | Dust deflector |
| D | Disc table bracket | J | Backstop |
| E | Spring loaded handle | K | Hex wrenches (5 and 6 mm) |
| F | Belt table bracket | L | Assorted mounting hardware |

Assembly and adjustments (continued)

Mount the disc sander table (Fig. 2 and 3)



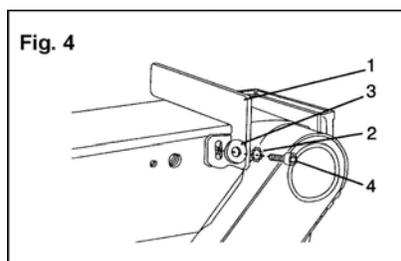
1. Insert bolts (1) from the top of the table (2) to secure the long plate (3) to the underside of the table. Do not tighten.
2. Slide the disc table bracket (4) under the long plate (3). The "U" mounting slots (5) fit around the bolts. Make sure the bracket is seated correctly; tighten the bolts to prevent the bracket from slipping.
3. Attach the short plate (6) with the lip facing the table, using bolt (1), to hold the single slot side of the bracket as shown. Tighten the bolt to prevent the bracket from slipping.
4. Place the washer (7) on the spring loaded handle (8).
5. With the table in a horizontal position, line up and insert the pivot indexing pin with the pivot hole (9) on the frame. Hold in place.
6. Insert the spring loaded handle (8) into the threaded hole and tighten.
7. Adjust the table so that the edge is a maximum of 1/16 inch from the disc. Holding the table in this position, tighten the three bolts on the top of the table.

Note: The table may have to be re-adjusted when tilted.



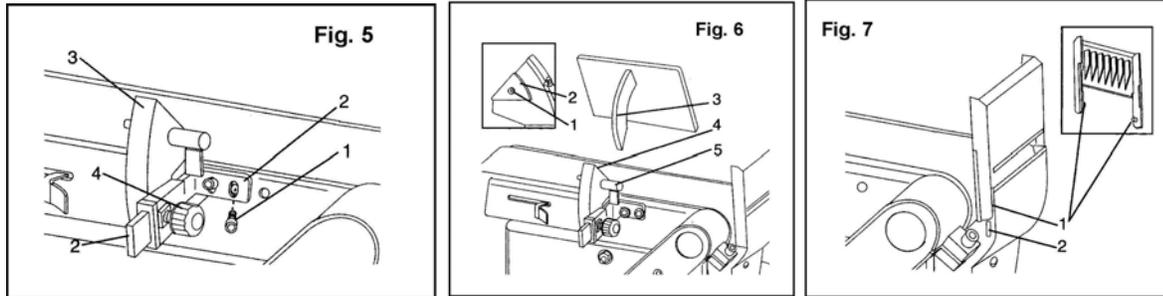
WARNING: To avoid trapping the workpiece or fingers between the table and the sanding disc, the table edge should be adjusted to a maximum of 1/16 inch from the sanding disc.

Mount the backstop (Fig. 4)



1. Align the backstop (1) with the hole.
2. Install a lock washer (2) and a flat washer (3) on the bolt (4).
3. Insert the bolt (4) into the backstop hole and tighten.
4. Adjust the backstop height to avoid contact with the sanding belt. Keep it perpendicular to the table.

Assembly and adjustments (continued)



Mount the belt sander table (Fig. 5)

1. Align the table holding bracket (2) with the threaded holes in the housing.
2. Insert the 2 bolts (1) and tightens.
3. Slide the table adjusting bracket (3) onto the holding bracket (2). Use the belt table knob (4) to lock the adjusting bracket in the correct position.

Install the belt table to the bracket (Fig. 6)

1. Loosen the screw (1) holding the wedge guide (2).
2. Slide the table guide (3) into the channel (4).
3. Tighten the screw (1).
4. Position the table at the desired angle and tighten the locking knob (5).

Note: The bottom edge of the table should not touch the sanding belt. Slide the holding bracket upward and retighten the bracket fastening bolts (1).

Install the dust deflector (Fig. 7)

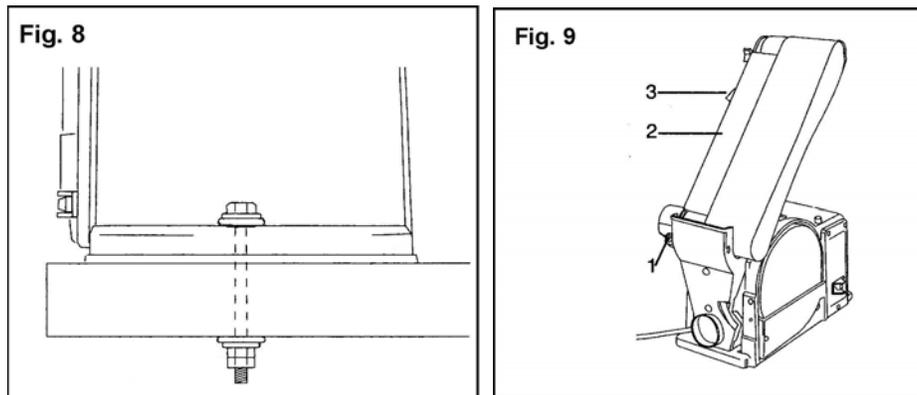
1. Insert deflector index pins (1) in the tracks (2) located on the side housing of the dust collecting assembly.
2. Slide upward to lock vertically. Lift up and pull downward allowing the dust collector to slide out of the way when not needed or when using the disc table at the end of the belt bed.

Note: The dust deflector can not be in a vertical position when using the disc table on the belt bed. The dust deflector must be lowered or removed.

Dust chute

The dust chute can be easily connected to a large diameter shop vacuum hose.

Assembly and adjustments (continued)



Mount sander to a supporting surface (Fig. 8)

Your sander must be securely fastened to a stand or workbench using the holes in the belt/disc sander base.

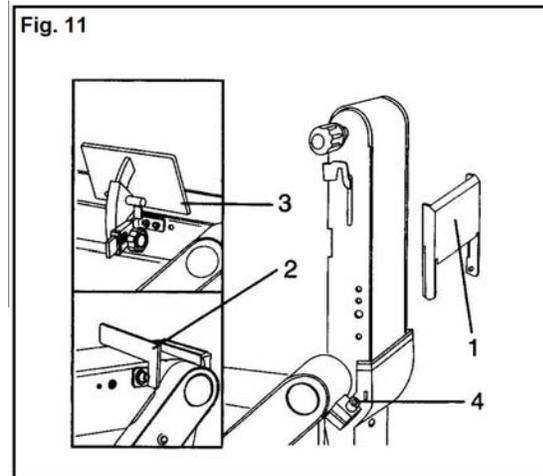
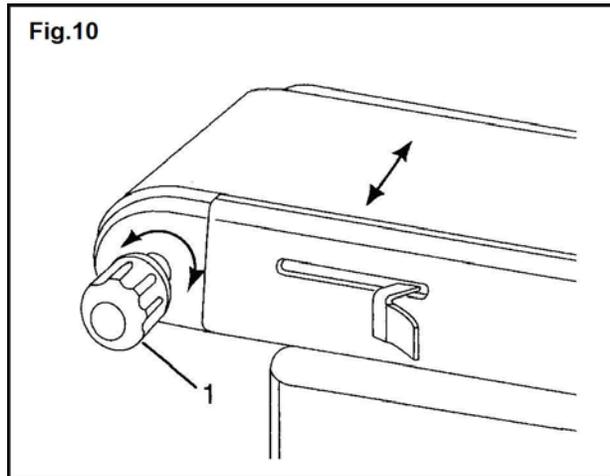
Important: When mounting the sander to a stand or workbench, do not overtighten the mounting bolts. Leave some cushion in the rubber washers so noise and vibration will be absorbed.

Note: If the stand or workbench moves during operation, secure it to the floor.

Install the sanding belt (Fig. 9)

1. Loosen the bed locking screw (1) with the hex key. Raise the sanding bed (2) about 45°; tighten the bed locking screw (1).
2. Release the tension lever (3).
3. Locate the directional arrow on the smooth side of the sanding belt.
4. Place the sanding belt over the drums with the directional arrow pointing toward the dust chute.
5. Center the belt correctly on both drums.
6. Slide the tension lever (3) to tighten the belt to the bed.
7. Loosen the bed locking screw (1); lower the bed to a horizontal position. Tighten the bed locking screw.

Assembly and adjustments (continued)



Sanding belt tracking adjustment (Fig. 10)

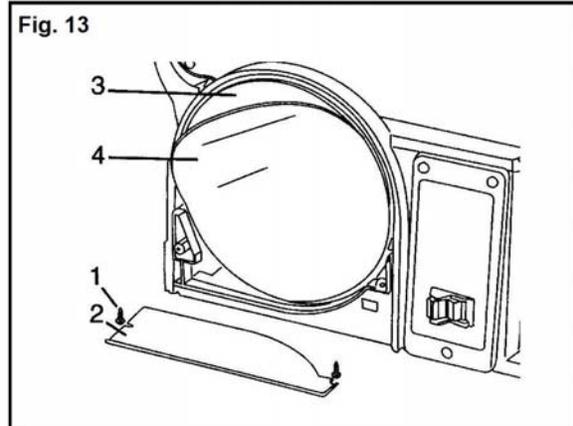
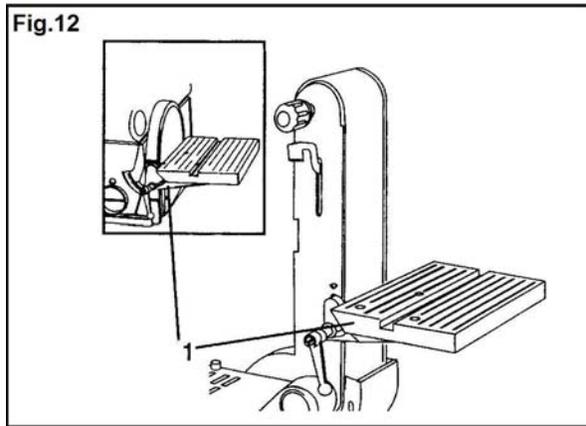
1. Plug in the power cord.
2. Turn the switch ON and OFF to make sure the sanding belt is correctly centered and not sliding off the idler and drive roller drums.
 - a. If the sanding belt moves toward the disc, slightly turn the tracking knob (1) counterclockwise.
 - b. If the sanding belt moves away from the disc, slightly turn the tracking knob (1) clockwise.
3. Turn the switch ON and OFF again; readjust the tracking knob if necessary.

Change sanding belt bed position (Fig. 11)

The sanding bed can be used in the horizontal or vertical positions or any angle in between. To use in the vertical position, do the following:

1. Lower or remove the dust deflector (1).
2. Remove the backstop assembly (2).
3. Remove the belt table (3) from the belt bed location.
4. Loosen the bed locking screw (4) with hex key, move the bed to the desired vertical position.
5. Tighten the locking screw (4) when at desired position.

Assembly and adjustments (continued)



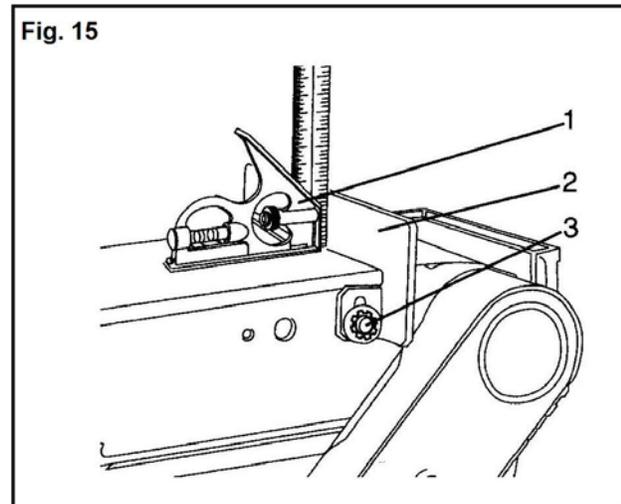
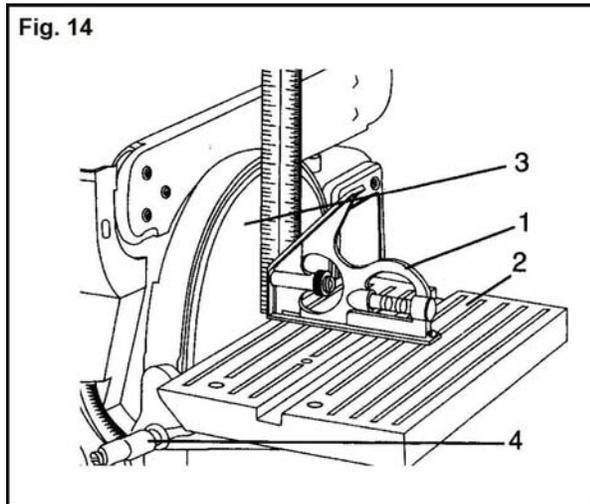
Attach disc table for vertical sanding (Fig. 12)

1. Remove the disc table (1) from the disc sanding position. Remove the backstop from the belt bed.
2. Attach the disc table bracket to the belt bed using the large pivot hole. Hold in place.
3. Insert the spring loaded handle through the bracket slot, into the threaded hole and tighten.
4. Adjust the table to the desired angle position.
5. Ensure 1/16 inch (1.6 mm) space between the table edge and the sanding belt bed. Re-adjust if necessary.

Install a sanding disc (Fig. 13)

1. Remove the two screws (1) from the sanding disc guard (2) and remove the guard.
2. Remove the used sanding disc (4).
3. Wipe the sanding disc plate clean (3).
4. Peel the backing from the new sanding disc (4), align the disc with the plate and press the sanding disc firmly on to the plate.
5. Reinstall the disc guard (2) and tighten the screws (1).

Assembly and adjustments (continued)



Square the tables (Fig. 14)

To ensure accurate end sanding, the work tables must be square to the sanding surfaces prior to using the tables for disc sanding, belt sanding, or vertical belt sanding.

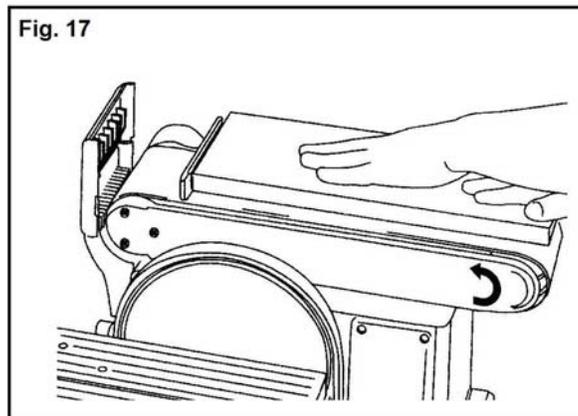
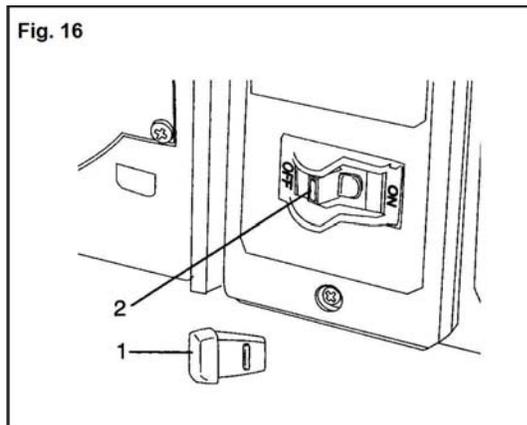
1. Adjust the table to be 90° with the sanding surface.
2. Using a combination square (1), place one end on the table with the ruler end against the sanding surface (3). Check that the table is 90° to the sanding surface.
3. If the table is not 90° to the sanding surface, loosen the spring loaded handle (4), adjust the table, tighten the handle and recheck with the square.

Square the backstop (Fig. 15)

The backstop (1) must be square to the sanding belt when using the belt sander in a horizontal position. To keep the workpiece from being carried along the belt:

1. Make sure the sanding belt is tight; also check that the tension lever is fully tightened.
2. Place the combination square (2) on the belt with the ruler against the backstop (1).
3. Adjust by loosening the backstop locking bolt (3), square the backstop.
4. Tighten the backstop locking bolt (3).

Operation



ON/OFF switch (Fig. 16)

The keyed switch is intended to prevent unauthorized use of the sander.



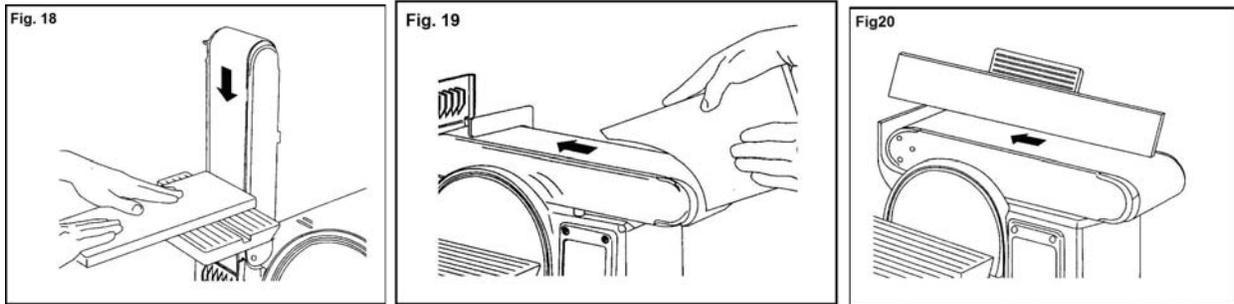
WARNING: Remove the safety key whenever the sander is not in use. Place the key in a safe place and out of the reach of children.

1. To turn sander ON, insert the safety key (1) into the key slot (2) in the center of the switch.
2. Push key firmly into the slot, then push switch to the ON position to start the sander.
3. To turn the sander OFF push switch to the OFF position.
4. Remove the safety key when the sander has come to a complete stop by gently pulling it forward and out.

Surface or edge sanding on sanding belt (Fig. 17)

Hold the workpiece firmly with both hands. Keep fingers away from sanding belt. Keep the workpiece end against the backstop and move it slowly across the sanding belt. Apply enough pressure to remove material; excessive pressure will reduce sanding efficiency.

Operation (continued)



End sanding on the belt (Fig. 18)

End sanding of wide workpieces requires the use of the sanding belt bed in the vertical position and the disc table moved to the sanding belt.

Note: Review Sections Change the sanding belt bed position and Square the tables before an end sanding operation.

Sanding inside curves (Fig. 19)

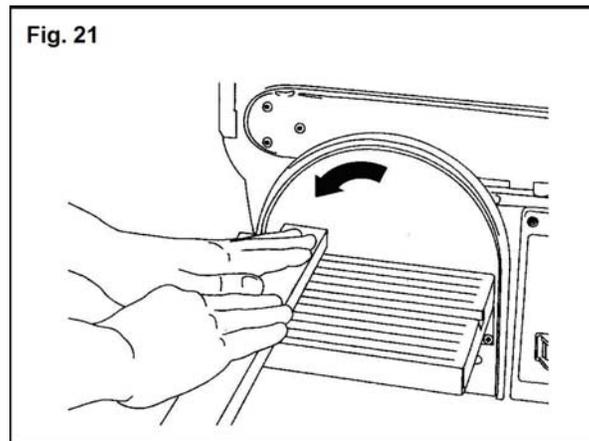
Sanding the inside curve of the workpiece is done by positioning the workpiece on the idler pulley of the sanding belt. Hold workpiece firmly with both hands.

Edge sanding of long workpieces (Fig. 20)

Adjust the belt sander table to the desired angle for either straight or bevel sanding of the edge. Hold the workpiece tightly with both hands. Keep the workpiece firmly against the sanding belt table while moving the workpiece slowly across the table.

Note: For long pieces of wood, remove the back stop and dust deflector.

Operation (continued)



End sanding and outside curve sanding with the disc (Fig. 21)

Use for sanding the ends of small and narrow workpieces and outside curved edges. Always work on the left side of the disc (downward rotation side), holding the workpiece firmly with light pressure against the sanding disc.

CAUTION: To avoid personal injury and/or damage to the workpiece, become familiar with the rotation of the belt and disc sanding surfaces.

The belt sander rotates counterclockwise or downward toward the table or backstop. The disc sander rotates counterclockwise, downward toward the table on the left side of the disc and upward from the table on the right side of the disc. Always use the left side of the disc; using the right side of the disc will cause the workpiece to fly up or kickback and could result in injury. Review this instruction manual for correct operation, adjustments, and basic sanding operations.

Maintenance



WARNING: For your own safety, turn the switch OFF and remove the plug from the electrical outlet before adjusting or performing maintenance or lubrication work on the belt/disc sander.

Before using, check to make sure parts are not damaged, missing, or worn; check for alignment of moving parts, binding of moving parts, improper mounting, or any other conditions that may affect the sander operation. Should any of these conditions exist, do not use the sander until properly repaired or parts are replaced. Frequently blow or vacuum dust from all sanding parts and motor housing.

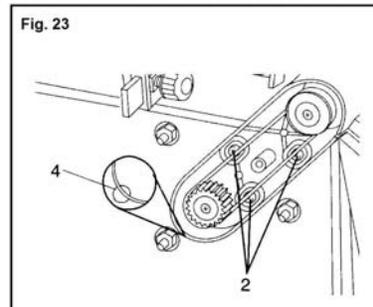
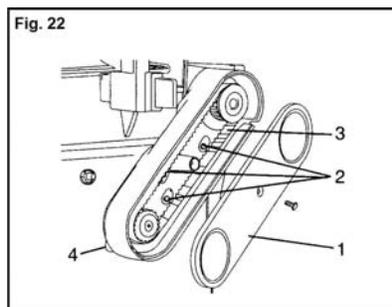


WARNING: Any attempt to repair or replace electrical parts on this tool may be hazardous. Repairs should be done by a qualified service technician.

Lubrication

Ball bearings are grease packed at the factory and require no further lubrication. Sleeve bearings on both ends of the idler pulley should be oiled with 3 drops of 30 weight oil after each 10 hours of operation. Use a spray lubricant on all moving table parts to ensure smooth operation.

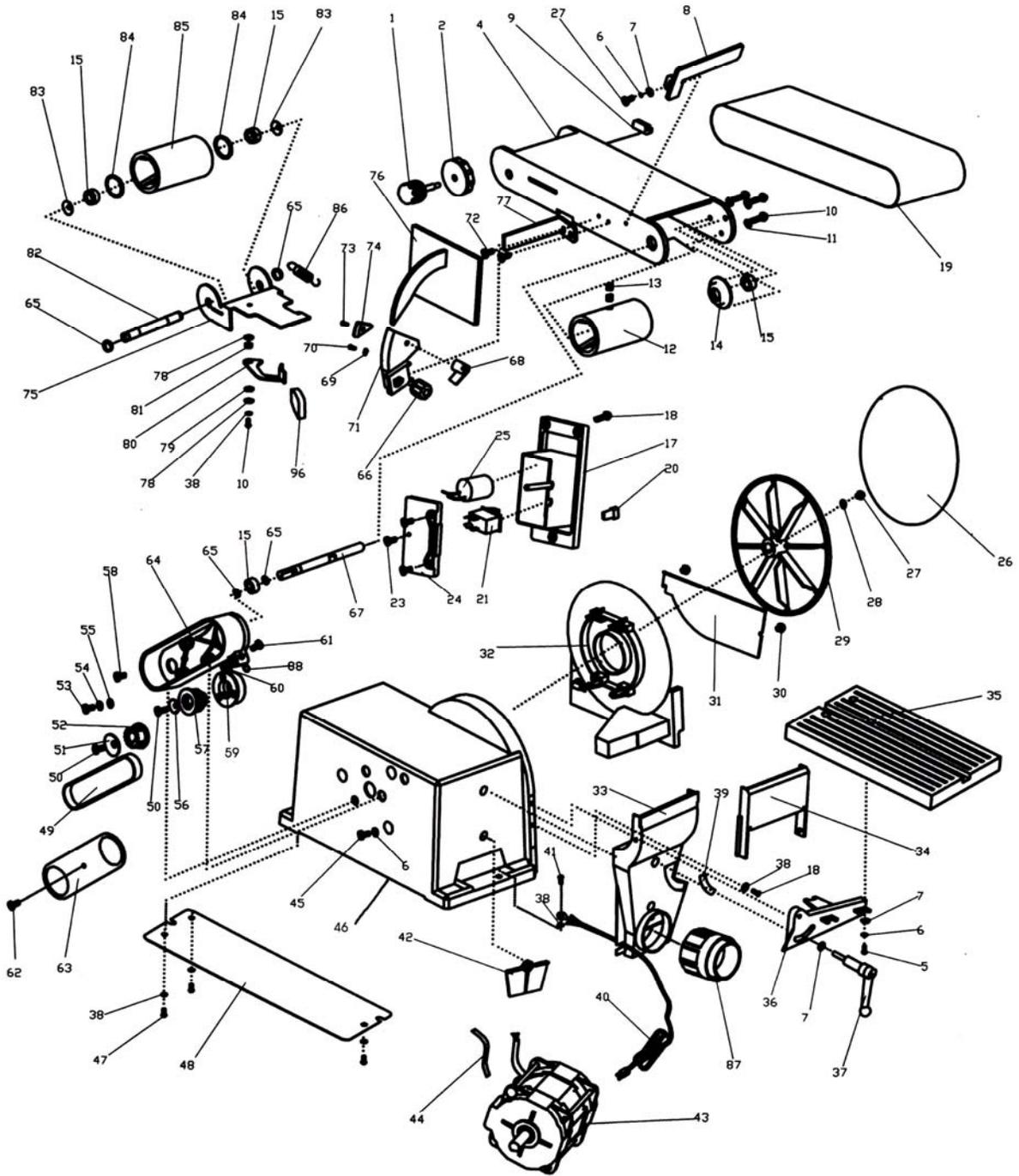
Adjust the Drive belt (Fig. 22 and 23)



1. Remove the drive belt housing cover (1).
2. Loosen the 3 screws (2) allowing the pulley to slip and the drive belt (3) to loosen. The drive belt should be seated correctly in the motor pulley and the drive pulley.
3. Adjust the tension of the belt by putting a slotted screwdriver in the bracing slot (4). Pushing up on the screwdriver will tighten the tension of the belt between the pulleys.
4. Tighten all 3 screws (2).
5. Test belt tension by squeezing both sides of the belt. If properly adjusted, the belt should "give" between 1/8–1/4 inch (3–6 mm). Make sure that the belt teeth are properly seated in the pulley gears.
6. Carefully reinstall the drive belt housing cover (1), insert and tighten screw.

Note: Excessive tightness on the pulley belt will cause increased noise and motor overload. Premature failure will occur if belt is too loose.

Exploded view and parts list



Exploded view and parts list (continued)

Part No.	DESCRIPTION	Qty.	Part No.	DESCRIPTION	Qty.
1	Tracking knob	1			
2	Spring base	1	50	Screw	2
4	Belt bed	1	51	Washer	1
5	Screw	1	52	Pulley drive	1
6	Washer	2	53	Screw	1
7	Washer	3	54	Lock washer	1
8	Back stop	1	55	Lock washer	1
9	Rubber bumper	1	56	Washer	1
10	Screw	4	57	Drive pulley	1
11	Washer	3	58	Screw	1
12	Drive drum	1	59	Support bearing	1
13	Screw	1	60	Nut	1
14	Bearing cap	1	61	Screw	1
15	Bearing	4	62	Screw	1
		1	63	Drive belt housing cover	1
17	Switch box	1	64	Drive belt housing	1
18	Screw	2	65	Retaining Ring	4
19	Sanding belt	1	66	Belt table adjust knob	1
20	Switch safety key	1	67	Drive shaft	1
21	Switch	1	68	Tilt lock	1
		1	69	Adjusting needle	1
23	Screw	3	70	Screw	1
24	Switch box cover	1	71	Table adjusting bracket	1
25	Capacitor	1	72	Screw	1
26	Sanding disc	1	73	Screw	1
27	Screw	2	74	Tracking board support	1
28	Lock washer	1	75	Idler drum guide	1
29	Sanding plate	1	76	Belt table	1
30	Screw	2	77	Holding bracket	1
31	Disc guard	1	78	Flat washer	2
32	Disc shroud	1	79	Washer	1
33	Dust deflector mount	1	80	Tension lever	1
34	Dust deflector	1	81	Washer	1
35	Disc table	1	82	Axle	1
36	Disc table bracket	1	83	Spacer idler	2
37	Spring loaded handle	1	84	Washer	2
38	Lock washer	4	85	Idler drum	1
39	Angle scale	1	86	Tension spring	1
40	Power cord	1	87	Dust chute	1
41	Screw	1	88	Nut	1
42	Dust deflecting	1	96	Plastic handle for #80	1
43	Motor	1			
44	Connector wire	1			
45	Nut	1			
46	Base	1			
47	Screw	3			
48	Base plate	1			
49	Drive belt	1			

Warranty

Performax™ belt/disc sanders are warranted against faulty workmanship and material for a period of two (2) years from the date of purchase, with the exception of damage directly or indirectly due to abuse, misuse, consumer negligence, accidents, alterations, or use for purposes other than those for which the tool was designed. Any return must be preauthorized, so please contact our Customer Service Department with warranty claims at 888-315-3080 M-F 8-5 CST for further instructions. If it is determined that the product is within this warranty, replacement parts or complete product replacement will be made at our discretion.

There are no warranties express or implied including fitness for a particular purpose and merchantability which extend beyond the description on the face hereof; no other warranty, written or oral, is authorized.

This warranty gives you specific legal rights. You may also have other rights, which vary from state to state.