

SETUP & OPERATION MANUAL

FEATURES & SPECIFICATIONS

- ☛ Combination 6" x 48" belt sander and 12" disc sander.
- ☛ Heavy-duty enclosed cabinet protects motor from sanding dust.
- ☛ Two large surface, cast-iron, tilting tables for unlimited sanding operations.
- ☛ Sanding belt operates at any angle from horizontal to vertical with positive stops at 90° and 45°.
- ☛ Quick-change belt tension lever for faster belt changes.
- ☛ Handles all finishing operations including: sanding, polishing, grinding, surfacing and cleaning.
- ☛ Safety switch with key, prevents unit from being started when key is removed.
- ☛ Precision aluminum miter gauge included.

BELT SIZE

6" X 48" (152 X 1220 MM)

DISC SIZE

12" (305 MM)

BELT SPEED

2250 LIN. FPM (686 LIN. MPM)

DISC SPEED

1750 RPM

BELT TABLE TILT

0 TO 45°

DISC TABLE TILT

45° OUT. & 10° IN.

BELT POSITION

HORIZONTAL / VERTICAL

DISC BACK PLATE

CAST IRON

DUST CHUTE OUTLET (BELT) -

15-035 ONLY

4" (102 MM)

BASE DIMENSIONS

15 3/4" X 22" (400 X 559 MM)

MOTOR (PREWIRED 220V)

1 1/2 HP, 110 / 220 V, 13/6.5 A

MOTOR (DUST COLLECTOR) -

15-035DC ONLY

1/4 HP, 110/220 V, 3A/1.5A

WEIGHT

365 LBS (166 KG)

6" X 48" BELT & 12" DISC SANDERS

Built-in dust collector on model 15-035DC only.



MODELS

#15-035 MI

#15-035DC MI





GENERAL® INTERNATIONAL

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Telephone (514) 326-1161 • Fax (514) 326-5555 • www.general.ca

THANK YOU for choosing this General® International model 15-035/15-035DC 6" x 48" belt & 12" disc sander. This sander has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. For your safety, as well as to ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.

The manual's purpose is to familiarize you with the safe operation, basic function, and features of this edge belt / disc sander as well as the set-up, maintenance and identification of its parts and components. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.

Once you've read through these instructions, keep this manual handy for future reference.

GENERAL ® INTERNATIONAL WARRANTY

All component parts of General® International machinery are carefully tested and inspected during all stages of production, and each machine is thoroughly inspected upon completion of assembly. Because of our commitment to quality and customer satisfaction, General® International agrees to repair or replace, within a period of 24 months from date of purchase, any genuine part or parts which, upon examination, prove to be defective in workmanship or material. In order to obtain this warranty, all defective parts must be returned freight pre-paid to General® International Mfg. Co., Ltd. Repairs attempted without our written authorization will void this warranty.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making constant improvements, General International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit with which it was supplied. However, special orders and "after factory"

modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of sander and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your machine exactly. If you have any doubts or questions contact your retailer or our support line with the model and serial number of your unit for clarification.

GENERAL® & GENERAL® INTERNATIONAL WARRANTY

All component parts of General®, General® International and Excalibur by General International® products are carefully inspected during all stages of production and each unit is thoroughly inspected upon completion of assembly.

Limited Lifetime Warranty

Because of our commitment to quality and customer satisfaction, General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser for the life of the tool. *However, the Limited Lifetime Warranty does not cover any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our Standard 2-year Limited Warranty only. The Limited Lifetime Warranty is also subject to the "Conditions and Exceptions" as listed below.*

Standard 2-Year Limited Warranty

All products not covered by our lifetime warranty including products used in commercial, industrial and educational applications are warranted for a period of 2 years (24 months) from the date of purchase. General® and General® International agree to repair or replace any part or component which upon examination, proves to be defective in either workmanship or material to the original purchaser during this 2-year warranty period, subject to the "conditions and exceptions" as listed below.

To file a Claim

To file a claim under our Standard 2-year Limited Warranty or under our Limited Lifetime Warranty, all defective parts, components or machinery must be returned freight or postage prepaid to General® International, or to a nearby distributor, repair center or other location designated by General® International. For further details call our service department at 1-888-949-1161 or your local distributor for assistance when filing your claim.

Along with the return of the product being claimed for warranty, a copy of the original proof of purchase and a "letter of claim" must be included (a warranty claim form can also be used and can be obtained, upon request, from General® International or an authorized distributor) clearly stating the model and serial number of the unit (if applicable) and including an explanation of the complaint or presumed defect in material or workmanship.

CONDITIONS AND EXCEPTIONS:

This coverage is extended to the original purchaser only. Prior warranty registration is not required but documented proof of purchase i.e. a copy of original sales invoice or receipt showing the date and location of the purchase as well as the purchase price paid, must be provided at the time of claim.

Warranty does not include failures, breakage or defects deemed after inspection by General® or General® International to have been directly or indirectly caused by or resulting from; improper use, or lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any generally considered consumable parts or components.

Repairs made without the written consent of General® International will void all warranty.

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RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

1. Do not operate the sander when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the sander is in operation; do not permit them to operate the sander.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. **Stay alert!** Give your work your undivided attention. Even a momentary distraction can lead to serious injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices.
7. Do not wear loose clothing, gloves, bracelets, necklaces or other jewelry while the sander is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
8. Be sure that adjusting wrenches, tools, drinks and other clutter are removed from the machine and/or the feed table surface before operating.
9. Keep hands well away from the sanding belts and all moving parts. Use a brush, not hands, to clear away sanding dust.
10. Be sure sanding belts are securely installed on the sanding drums.
11. Do not operate the sander if the sanding belts are damaged or badly worn.
12. Do not push or force the workpiece into the sander. The machine will perform better and more safely when working at the feed rate for which it was designed.
13. Avoid working from awkward or off balance positions. Do not overreach and keep both feet on floor.
14. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning, be sure it is properly re-attached before using the tool again.
15. Never leave the machine unattended while it is running or with the power on.
16. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equipment malfunction or risk of injury.
17. Never stand on the machine. Serious injury could occur if the sander is tipped over or if the sanding drums are unintentionally contacted.
18. Always disconnect the tool from the power source before servicing, changing accessories or sanding belts, or before performing any maintenance or cleaning, or if the machine will be left unattended.
19. Make sure that switch is in the "OFF" position before plugging in the power cord.
20. Make sure the tool is properly grounded. If equipped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
21. Do not use the sander for any purpose other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

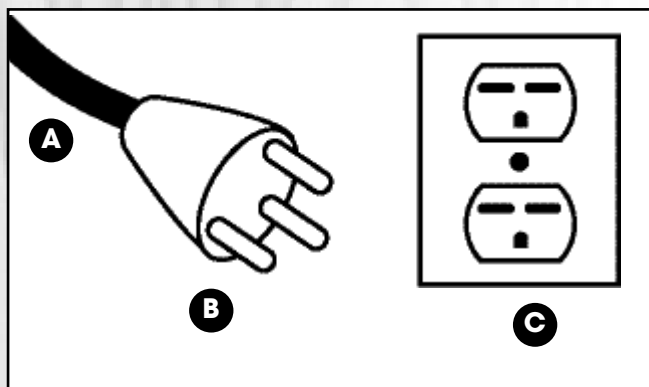


ELECTRICAL REQUIREMENTS



BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR POWER SUPPLY CORRESPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.

THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.



GROUNDING INSTRUCTIONS

In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock to the operator. The motor of this machine is wired for 220V single phase operation and is equipped with a 3-conductor plug **A** and a 3-prong grounded plug **B** to fit a matching grounding type receptacle **C**.

DO NOT MODIFY THE PLUG PROVIDED ! If it will not fit your receptacle, have the proper receptacle installed by a qualified electrician.

CHECK with a qualified electrician or service person if you do not completely understand these grounding instructions, or if you are not sure the tool is properly grounded.

CIRCUIT CAPACITY

Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician. If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

CONVERTING THE MOTOR TO 110V

Should you need to convert your machine's motor from 220 V to 110 V power. Unless you are a qualified electrician, we do not recommend attempting this conversion on your own. If you choose to do so, you may risk serious personal injury, damage to the motor and voiding the warranty of your machine.

We suggest you ask your local General International distributor to recommend qualified electricians in your area (or perhaps one of their own technicians) who can make this conversion properly and safely.

EXTENSION CORDS

The use of an extension cord is not generally recommended for 220V equipment. If you find it necessary, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool's plug. Repair or replace a damaged extension cord or plug immediately.

If you find it necessary to use an extension cord with your machine make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE - MINIMUM GAUGE FOR CORD

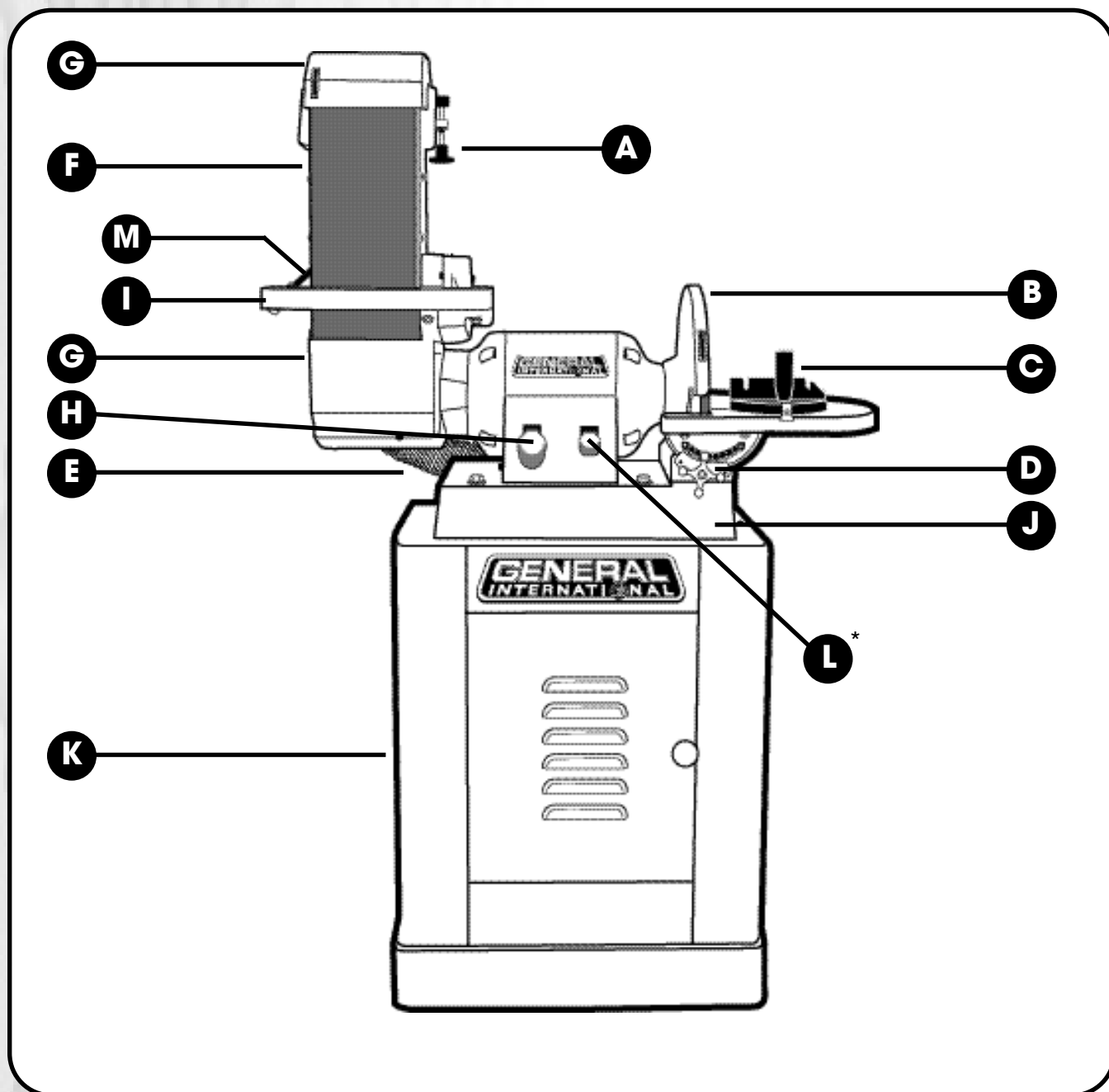
AMPERE RATING	TOTAL LENGTH OF CORD IN FEET				
	110 VOLTS	25 FEET	50 FEET	100 FEET	150 FEET
	220 VOLTS	50 FEET	100 FEET	200 FEET	300 FEET
AWG					
< 5	----->	18	16	16	14
6 TO 10	----->	18	16	14	12
10 TO 12	----->	16	16	14	12
12 TO 16	----->	14	12	* NR	* NR

* NR = Not Recommended



6" x 48" BELT & 12" DISC SANDERS 15-035/15-035DC

IDENTIFICATION OF MAIN PARTS AND COMPONENTS



A. BELT TRACKING ADJUSTMENT
B. SANDING DISC
C. MITER GAUGE
D. DISC TABLE LOCK KNOB
E. DUST HOSE

F. SANDING BELT
G. BELT GUARD
H. MAIN ON/OFF SWITCH
I. BELT SANDER WORK TABLE
J. MACHINE BASE

K. STAND
L.* DUST COLLECTOR SWITCH
(15-035DC ONLY)
M. BELT TENSION LEVER

*The switch panel shown is for 15-035DC. Model 15-035 is equipped with a large stop panel style switch (see A on page 8)

BASIC FUNCTIONS

This machine has been designed for sanding or polishing (removing kerf or pencil marks) on small workpieces, such as chair legs or cabinet doors. The sanding belt can be tilted at any angle between 90° and 180° for bevelled pieces. Flat sanding, with belt in horizontal position (180°), is easier and safer for longer workpieces.

The sanding disc can be used for sanding round or curved surfaces.

BASIC PRINCIPLES OF SANDING

It is always preferable to remove less material per pass and take multiple passes. This can extend sanding belt life, place less strain on the motor and provide better workpiece finish quality.



DO NOT USE THIS SANDER AS A THICKNESS PLANER. NEVER ATTEMPT TO REMOVE MORE THAN THE DEPTH OF THE GRIT OF THE SANDING BELT IN ANY SINGLE PASS. TOO MUCH FRICTION WILL CAUSE BELTS TO OVERHEAT AND WEAR PREMATURELY, AND IN EXTREME CASES, MAY CAUSE BURNS IN THE WORKPIECE.

UNPACKING

Carefully unpack and remove the unit and its components from its shipping container and check for missing or damaged items as per the list of contents below.

NOTE: Please report any damaged or missing items to your **GENERAL® INTERNATIONAL** distributor immediately.

LIST OF CONTENTS

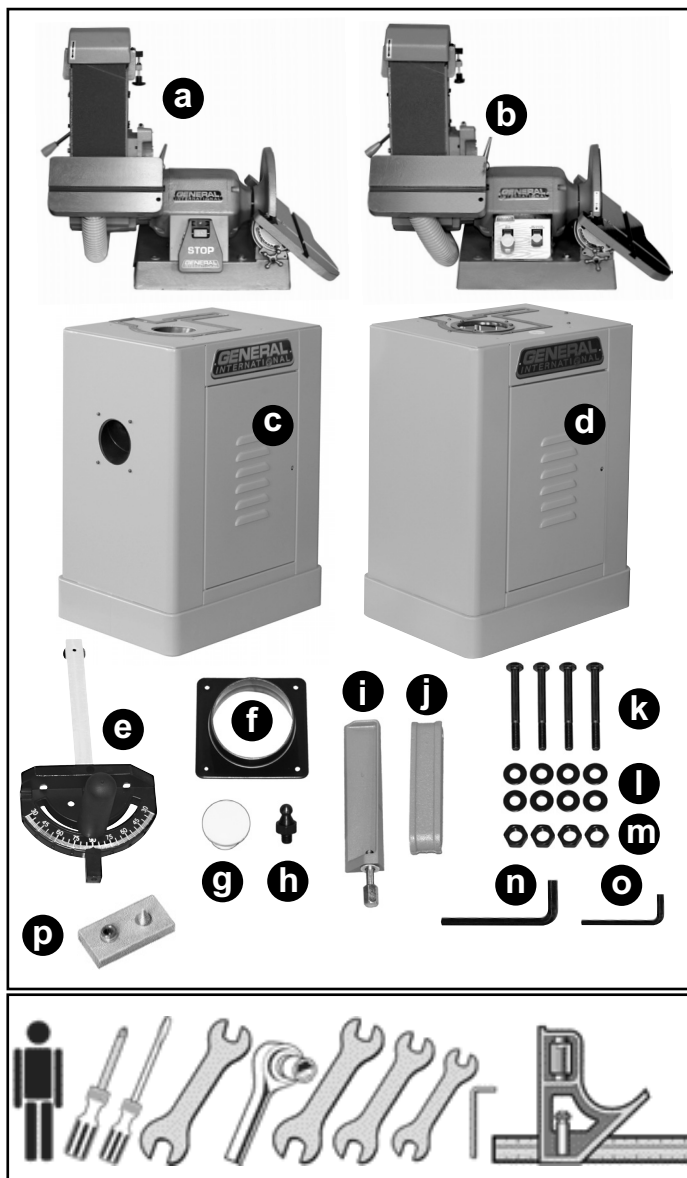
QTY

a	SANDING HEAD (15-035)	1
b	SANDING HEAD (15-035DC)	1
c	BASE (15-035)	1
d	BASE (15-035DC)	1
e	MITER GAUGE	1
f	4" DUST OUTLET (15-035 only)	1
g	DOOR KNOB	1
h	DOOR BOLT	1
i	BACKSTOP	1
j	BACKSTOP HOLDER	1
k	HEX HEAD BOLT	4
l	FLAT WASHER	8
m	NUT	4
n	4 MM ALLEN KEY	1
o	3 MM ALLEN KEY	1
p	CENTER POINT	1

* The sanding belt, sanding disc, flexible hose and dust collection bag (model 15-035DC only) are already installed.

ADDITIONAL REQUIREMENTS FOR SET UP

- Extra person for help with lifting
- Phillips head screwdriver
- Large flat head screwdriver
- 14 mm Hex socket and 14 mm open end wrench
- 17 mm open end wrench
- 10 mm open end wrench
- 8 mm open end wrench
- 2.5 mm Allen key
- Combination square



PLACEMENT WITHIN THE SHOP / ESTABLISHING A SAFETY ZONE



SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

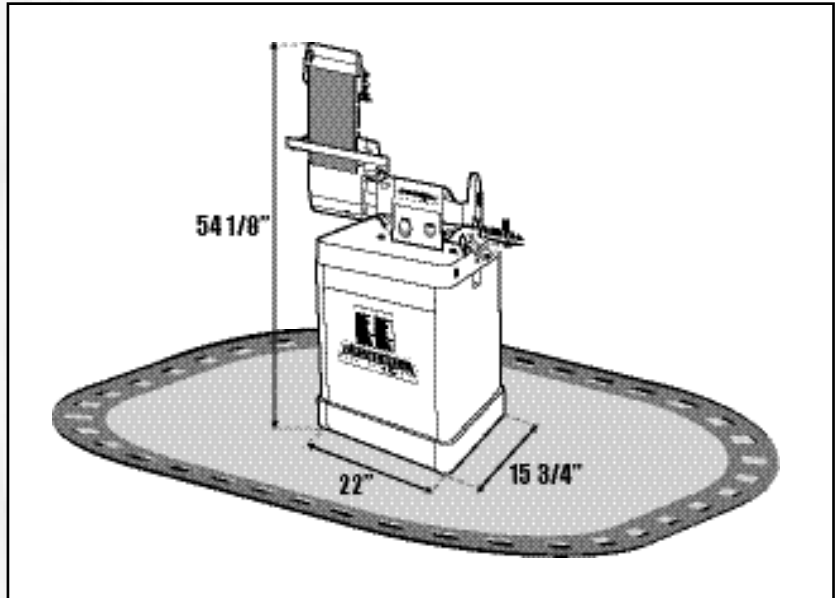
PLACEMENT WITHIN THE SHOP

This machine should be installed and operated only on a solid, flat and stable floor that is able to support the weight of the machine and the operator.

Using the dimensions shown as a guideline, plan for placement within your shop that will allow the operator to work unencumbered and unobstructed by foot traffic (either passing shop visitors or other shop workers) or other tools or machinery.

ESTABLISHING A SAFETY ZONE

For shops with frequent visitors or multiple operators, it is advisable to establish a safety zone around shop machinery. A clearly defined “no-go” zone on the floor around each machine can help avoid accidents that could cause injury to either the operator or the shop visitor. It is advisable to take a few moments to either paint (using non-slip paint) or using tape, define on the floor the limits or perimeter of each machine's safety zone. Take steps to ensure that all operators and shop visitors are aware that these areas are off limits whenever a machine is running for everyone but the individual operating the unit.



CLEAN UP

The protective coating on the sander table prevents rust from forming during shipping and storage. Remove it by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Dispose of potentially flammable solvent-soaked rags according to manufacturer's safety recommendations.)

A putty knife, held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing the sander's painted surfaces, as many solvent-based products will remove paint.

To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.



Tip: With a screw driver, push a solvent-saturated rag into the T-slot to remove the grease.

ASSEMBLY INSTRUCTIONS

For your convenience this sander is shipped from the factory partially assembled and requires only minimal assembly and set up before being put into service.



SERIOUS PERSONAL INJURY COULD OCCUR IF YOU CONNECT THE MACHINE TO THE POWER SOURCE BEFORE YOU HAVE COMPLETED THE INSTALLATION AND ASSEMBLY STEPS. DO NOT CONNECT THE MACHINE TO THE POWER SOURCE UNTIL INSTRUCTED TO DO SO.

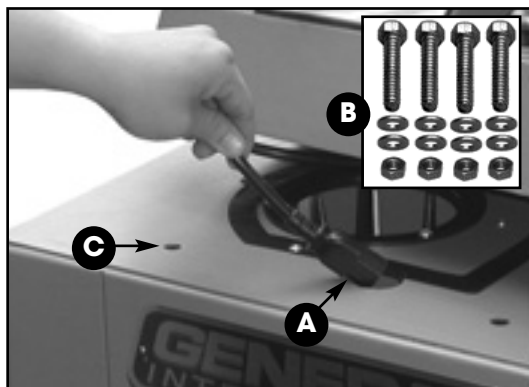
INSTALL THE SANDER ONTO THE BASE CABINET

The sander is mounted onto a base cabinet, which provides storage space for the miter gauge and replacement sanding discs and belts.

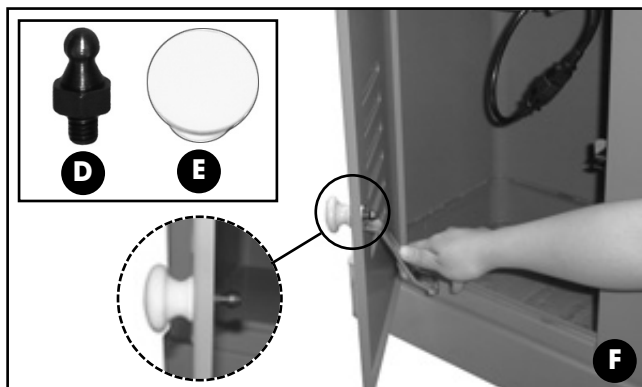


THE SANDER IS HEAVY. DO NOT OVER-EXERT. THE HELP OF AN ASSISTANT WILL BE NEEDED FOR THE FOLLOWING STEP.

1. Position the sanding head over the top of the base cabinet, passing the dust collector wire through the hole on the stand **A** (model 15-035DC only)
2. Insert the four supplied hex head bolts and flat washers **B** down through the holes in the base of the sanding head and into the base cabinet **C**. Then open the door and from the inside, secure the bolts with four hex nuts and washers, using a 14 mm open end wrench and 14 mm socket wrench.



ATTACH THE DOOR KNOB



1. From the inside, insert the door bolt **D** through the hole in the door, into the door knob **E**, as shown in **F**.
2. Tighten the door bolt using a 17 mm open end wrench.

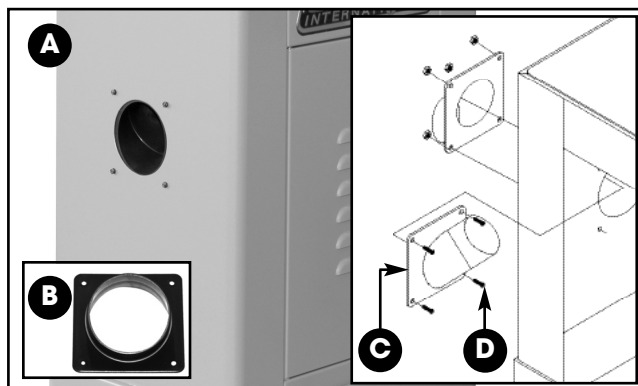
CONNECT DUST COLLECTOR WIRE (MODEL 15-035DC M1 ONLY)



Connect the power cord from the dust collector to the inlet plug on the switch.

INSTALL DUST OUTLET (MODEL 15-035 M1 ONLY)

1. Using a 8 mm open end wrench, loosen and remove the 4 nuts located on the left side of the base cabinet, **A**.
2. Attach the 4" dust outlet **B**, to the dust chute located inside the cabinet **C**, inserting screws **D** through the dust outlet mounting holes.
3. Secure with the nuts you just removed, and firmly tighten the nuts.



CONNECTING TO A DUST COLLECTOR (MODEL 15-035 M1 ONLY)



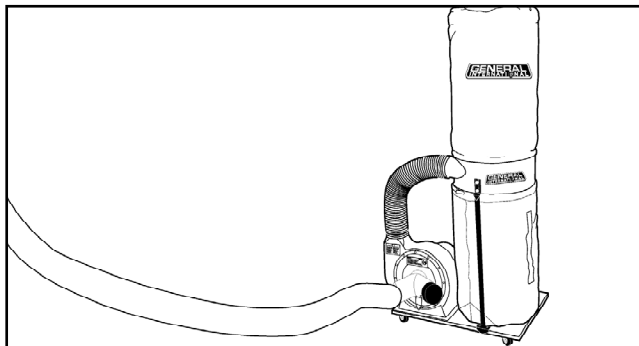
DO NOT OPERATE THIS SANDER WITHOUT AN ADEQUATE DUST COLLECTION SYSTEM PROPERLY INSTALLED AND RUNNING. OPERATING THIS SANDER WITHOUT ADEQUATE DUST COLLECTION CAN LEAD TO EQUIPMENT MALFUNCTION OR DANGEROUS SITUATIONS FOR THE OPERATOR OR OTHER INDIVIDUALS IN THE WORKSHOP.

The 4" diameter dust outlet allows for connection to a dust collector (not included).

Be sure to use appropriate sized hose and fittings (not included) and check that all connections are sealed tightly to help minimize airborne dust.

Note: Minimum recommended dust collection CFM requirements for this sander is 1100 CFM.

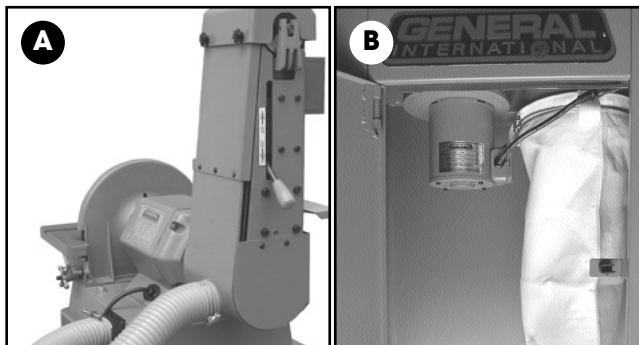
If you do not already own a dust collection system consider contacting your General® International distributor for information on our complete line of dust collection systems and accessories or visit our Web Site at www.general.ca.



ALWAYS TURN ON THE DUST COLLECTOR BEFORE STARTING THE SANDER AND ALWAYS STOP THE SANDER BEFORE TURNING OFF THE DUST COLLECTOR.

BUILT-IN DUST COLLECTOR (MODEL 15-035DC M1 ONLY)

Model 15-0035DC is equipped with a built-in dust collector connected to the sanding head, **A** to allow for direct dust extraction. A collector bag is supplied and already installed inside the base cabinet **B**.

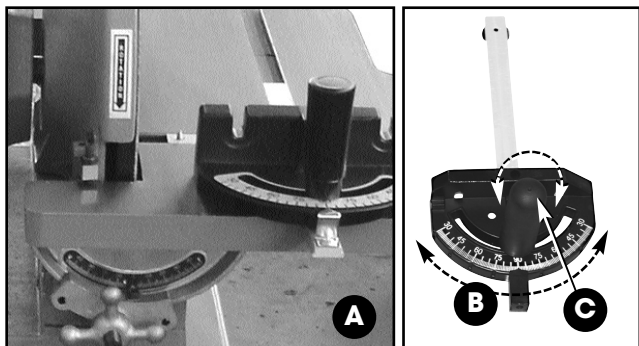


USING THE MITER GAUGE

The supplied miter gauge allows for easier and safer sanding by providing workpiece support when sanding straight (90°) or angled ends (0° to 30°).

The miter gauge rides in the both the sanding belt and sanding disc table slot as shown in **A** and can be set to any angle up to 30° to the left or right **B**.

To use a setting other than 90°, loosen the handle **C** by turning it counter-clockwise. Rotate the miter head to the required angle shown on the angle indicator. Then turn the handle clockwise to tighten it.

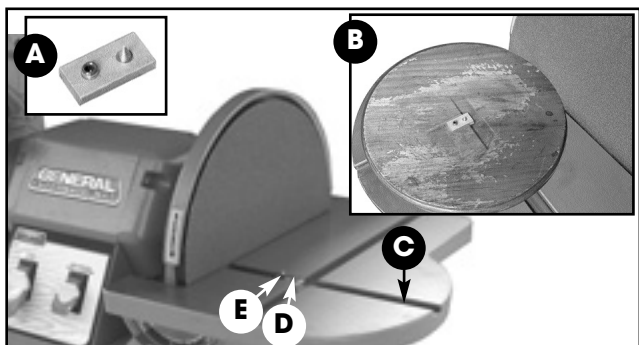


CENTER POINT

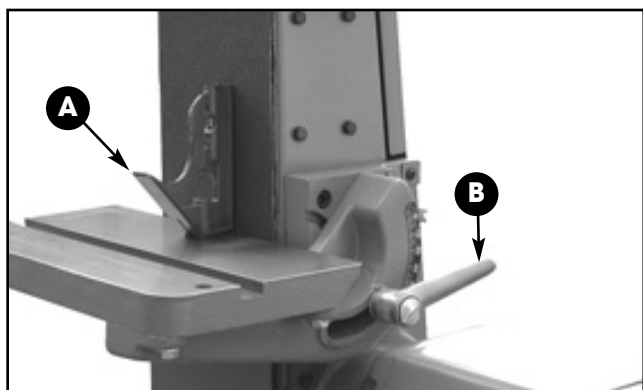
A center point **A** is supplied with the sander for sanding circles, **B**.

The center point slides into the miter slot that is perpendicular to the sanding disc **C** and must be positioned according to the radius of the workpiece.

1. Slide the center point along the miter slot **C** to the distance that matches the size of the workpiece.
2. Lock the center point in position by tightening the set screw **D**, using the supplied 3 mm Allen key.
3. Place the center of the workpiece on the center point's pin **E**.
4. Turn the sander on, and manually rotate the workpiece against the sanding disc until achieving desired results.



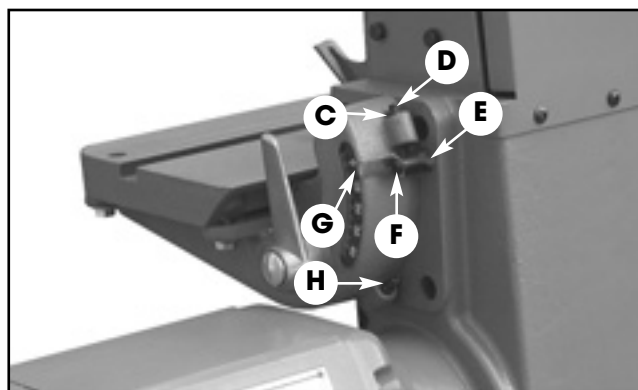
ADJUSTING THE 90° AND 45° BEVEL STOPS - SANDING BELT TABLE



BEFORE MAKING ANY ADJUSTMENTS, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED.

The sanding belt operates at any angle from horizontal to vertical with positive stops at 90° and 45°. These stops are factory set. However, with use and vibration over time, they eventually may need minor adjustments.

1. Make sure that the sander is turned off and unplugged.
2. Place a combination square on the table against the sanding belt as shown in **A** to verify the 90° angle of the table.
3. If needed, loosen the table locking lever **B**, then adjust the table to 90° to the sanding belt.
4. Tighten locking lever **B** to lock the table in position.



With the table set to 90°, verify and, if needed, adjust the 90° stop as follows:

1. Loosen lock nut **C** using a 8 mm wrench.
2. Adjust set screw **D** using a 2.5 mm allen key until the screw sits on the stop **E**.
3. Re-tighten lock nut **C**.

With the table set to 90°, the bevel pointer might need to be adjusted. Proceed as follows:

Loosen the screw **F** on the pointer mounting bracket and manually align the pointer with the zero on the bevel scale, **G**, then re-tighten the screw.

ADJUSTING THE 45° BEVEL STOP

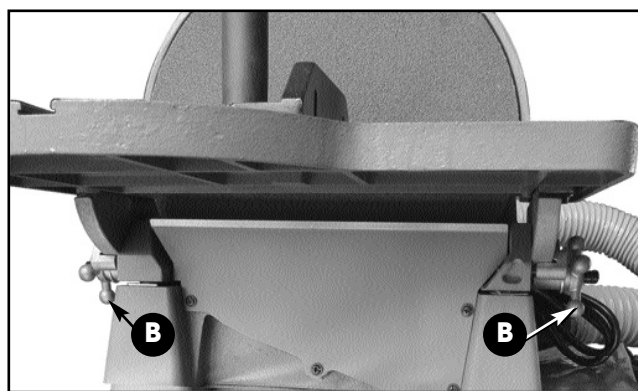
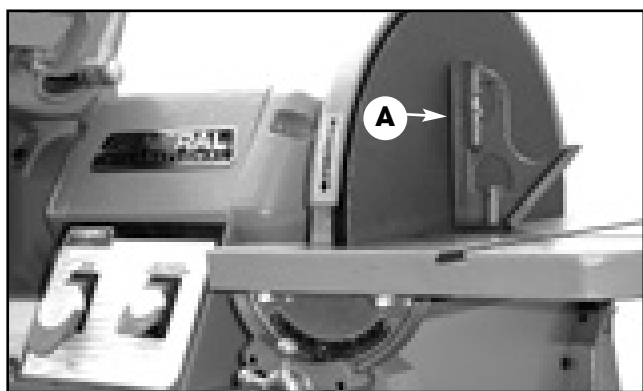
Verify the 45° setting by tilting the table down as far as possible and using a combination square, check the angle. If needed adjust as for the 90° stop, this time using the lower stop screw, **H**.

ADJUSTING THE 90° STOP - SANDING DISC TABLE

The sanding disc table can be tilted from 0° to 45° to the front and from 0° to 10° to the rear, with a positive stop at 90°. This stop is factory set. However, with use and vibration over time, it eventually may need minor adjustments.



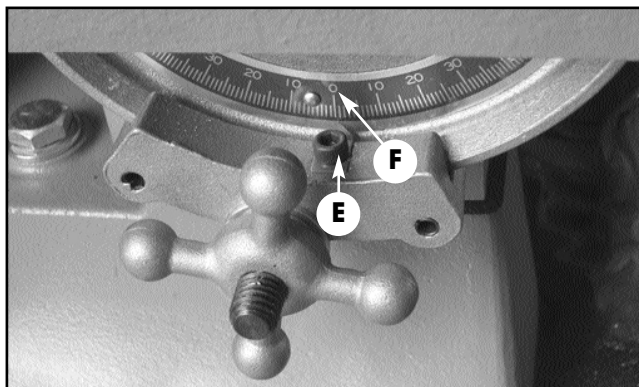
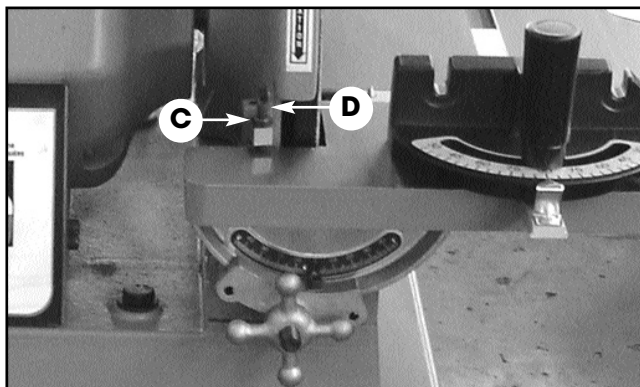
BEFORE MAKING ANY ADJUSTMENTS, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED.



1. Make sure that the sander is turned off and unplugged.
2. Place a combination square on the table against the sanding disc as shown in **A** to verify the 90° angle of the table.

Note: The square must not touch the wheel cover, only the sanding disc.

3. If needed, loosen both lock knobs **B**, then adjust the table to 90° to the sanding disc, then re-tighten both lock knobs to lock the table in position.



With the table set to 90°, verify and, if needed, adjust the 90° stop as follows:

1. Loosen lock nut **C** using a 10 mm wrench.
2. Adjust set screw **D** using the supplied 3 mm allen key until the screw sits on the table.
3. Re-tighten lock nut **C**.

ADJUSTING THE BEVEL POINTER

With the table set to 90°, the bevel pointer might need to be adjusted. Proceed as follows:

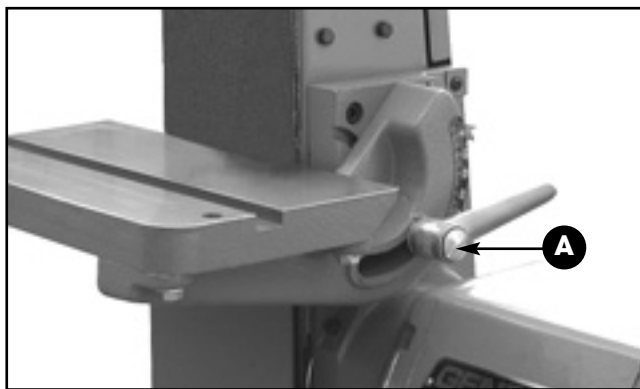
Loosen the screw **E** on the pointer mounting bracket using the supplied 4 mm allen key, and manually align the pointer with the zero on the bevel scale, **F**, then re-tighten the screw.

INSTALLING/SETTING THE WORKPIECE STOP

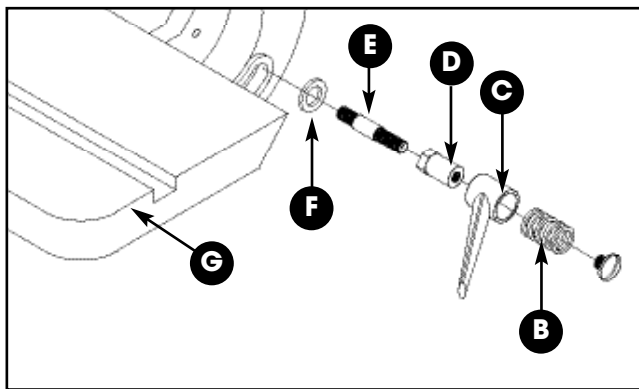
The sanding belt table can be used as a fence when operating the sanding belt in the vertical position. When sanding longer workpieces, with the sanding head in the horizontal position, the table can be replaced with a workpiece stop as follows.



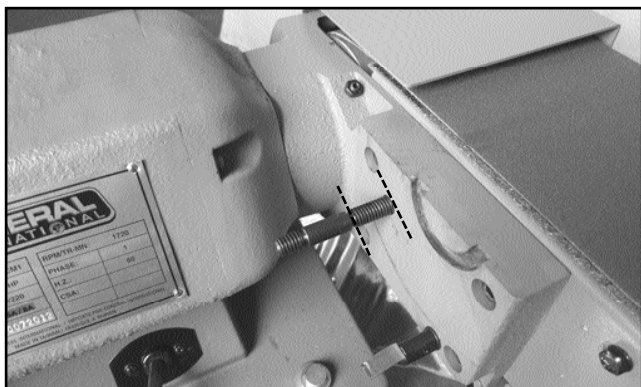
BEFORE MAKING ANY ADJUSTMENTS, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED.



1. Make sure that the sander is turned off and unplugged.
2. Using a large flat head screwdriver, loosen and remove pan head screw **A**.

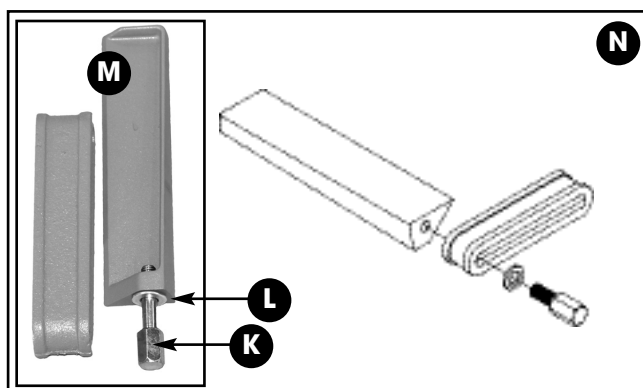


3. Remove spring **B**, handle **C** and toothed nut **D**.
4. Using a 10 mm open end wrench, loosen and remove stud **E**, then remove washer **F** and the table and trunnion assembly **G**.

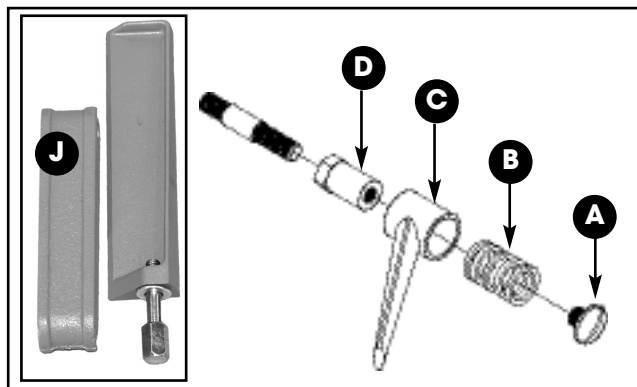


Note: For stop installation, the stud has to be re-installed with it's longer end threaded in as shown above.

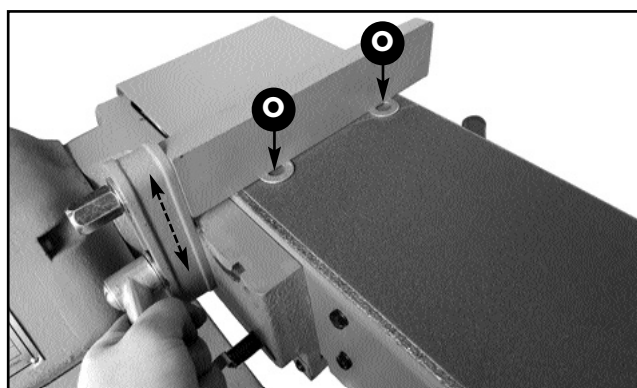
5. Re-install the washer **F**, then re-install the stud as shown above, threading its longer end in the sanding head.



8. Loosen and remove bolt **K** and washer **L** from the backstop **M**.
9. Place the workpiece stop against the workpiece stop holder and use the washer and bolt to secure in place as shown in **N**.



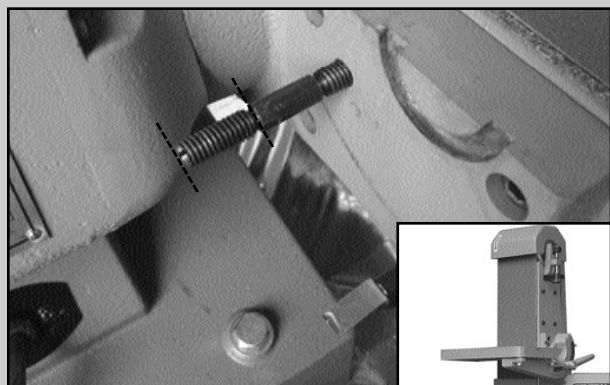
6. Re-install the toothed nut **D** on the stud.
7. Slide the backstop holder **J** onto stud with toothed nut and secure in place using the previously removed handle **C**, spring **B** and screw **A**.



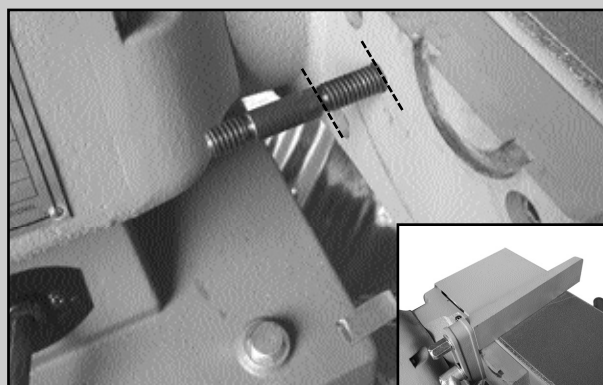
10. Loosen the locking handle and adjust the positioning of the workpiece stop up or down along the workpiece stop holder, making sure it clears the sanding belt, then re-tighten the locking handle.

Tip: Use 2 flat washers (3 mm thick approx.) placed under the workpiece stop, **O** as a reference for appropriate clearance.

NOTE



For table installation, the stud is installed with the shorter end threaded in as shown above.



For stop installation, the stud has to be removed and re-installed with the longer end threaded in as shown above.

BASIC ADJUSTMENTS & CONTROLS

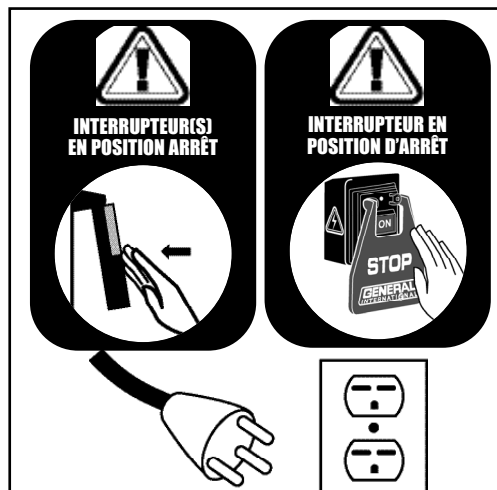
CONNECTING TO A POWER SOURCE



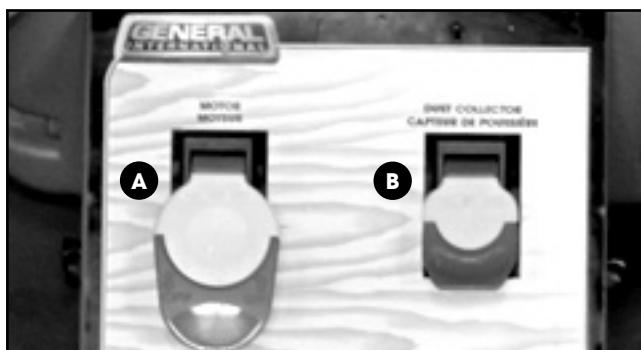
TO REDUCE THE RISK OF SHOCK OR FIRE DO NOT OPERATE THE UNIT WITH A DAMAGED POWER CORD OR PLUG. REPLACE DAMAGED CORD OR PLUG IMMEDIATELY.

TO AVOID UNEXPECTED OR UNINTENTIONAL START-UP, MAKE SURE THAT THE POWER SWITCH IS IN THE OFF POSITION BEFORE CONNECTING TO A POWER SOURCE.

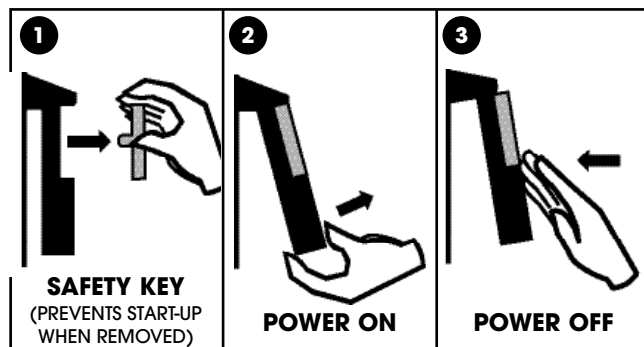
Once the assembly steps have been completed, uncoil the power cord and plug into an appropriate outlet. Refer back to the section entitled "Electrical Requirements" and make sure all requirements and grounding instructions are followed. When sanding operations have been completed turn off and unplug the sander from the power source.



ON/OFF POWER SWITCH WITH SAFETY KEY (MODEL 15-035DC ONLY)



The 15-035DC is equipped with 2 ON/OFF power switches with a removable lock out safety key: one for the sanding belt/disc motor **A** and one for the built-in dust collector motor **B**.



- To start the machine, insert the safety key, **1**, and lift the switch up, **2**.
- To stop the machine, push the switch down, **3**.



TO PREVENT UNWANTED OR UNAUTHORIZED START-UP OR USAGE, REMOVE THE LOCK-OUT KEYS AND STORE THEM IN A SAFE PLACE, OUT OF THE REACH OF CHILDREN, WHENEVER THE SANDER IS NOT IN USE.

ON/OFF SWITCH & SAFETY PIN (MODEL 15-035 ONLY)

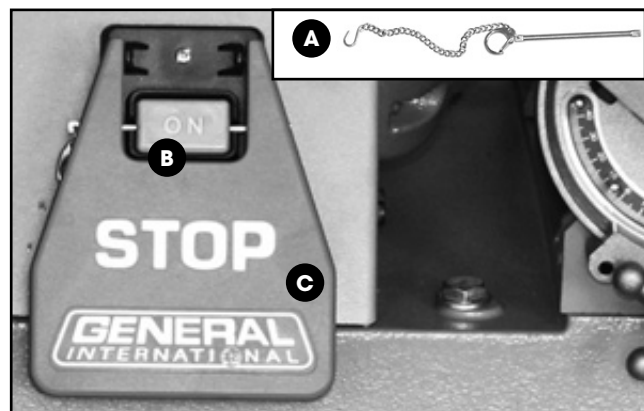
The ON/OFF switch assembly on the 15-035 is equipped with a lock-out safety pin **A**. When the pin is installed through the green "on" button **B**, the machine cannot be started.

To start the machine

Lift the red stop switch panel **C** and remove the lock-out pin. Lower the stop panel and push the green "ON" button. Wait for the sanding belt/disc to reach full speed before sanding.

To stop the machine

Push on the RED "STOP" panel and wait for the sanding belt/disc to come to a complete stop.



WHEN YOU HAVE FINISHED USING THE MACHINE BE SURE TO RE-INSTALL THE LOCK-OUT PIN AND UNPLUG THE SANDER FROM THE POWER SOURCE.

TILTING THE SANDING BELT/DISC TABLE



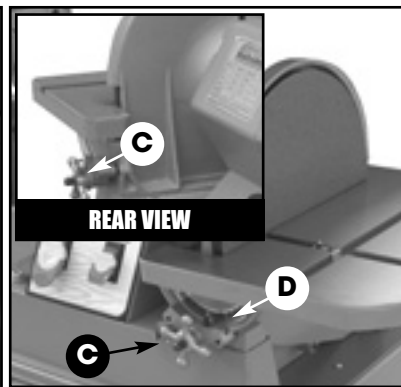
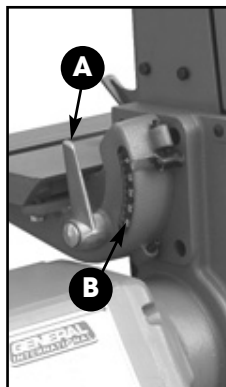
BEFORE MAKING ANY ADJUSTMENTS, MAKE SURE THAT THE SWITCH IS IN THE "OFF" POSITION AND THAT THE POWER CORD IS UNPLUGGED

To tilt the sanding belt table

1. Loosen table locking handle **A**.
2. Tilt the table to the desired angle, as indicated on the bevel scale **B**. Turn the lock knob clockwise to secure the table in position.

To tilt the sanding disc table

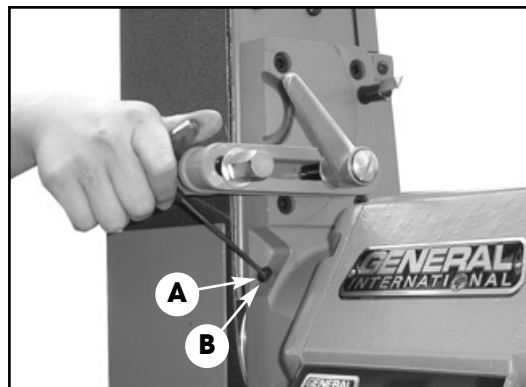
1. Loosen table locking handles **C**.
2. Tilt the table to the desired angle, as indicated on the bevel scale **D**. Turn the lock knobs clockwise to secure the table in position.



HORIZONTAL/VERTICAL SANDING BELT ADJUSTMENT

To change the sanding belt from vertical to horizontal position.

1. Make sure the sander is turned off and unplugged.
2. Using a 10 mm wrench and the supplied 3 mm allen key, loosen lock nut **A**, then set screw **B**.
3. Set the sanding head to the horizontal position.
3. Re-tighten set screw **B** and lock nut **A** to secure the sanding head in position.



Note: Belt tracking adjustments may be necessary after changing the position of the sanding head from vertical to horizontal position.

(See "Sanding belt tracking adjustment instructions below")

SANDING BELT TRACKING ADJUSTMENT



DO NOT ATTEMPT TO PERFORM ANY ADJUSTMENTS WHILE THE MACHINE IS RUNNING. ALWAYS TURN OFF AND UNPLUG THE SANDER BEFORE PERFORMING ANY ADJUSTMENTS.

KEEP HANDS WELL AWAY FROM THE SANDING BELT AND ALL MOVING PARTS WHEN THE SANDER IS RUNNING.

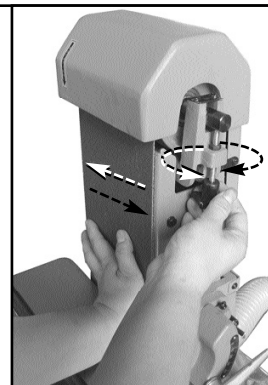
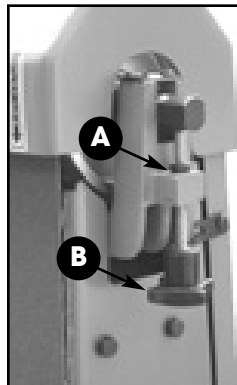
Though not essential, proper belt tracking (having the belt running straight and turning as evenly on the rollers as possible) can prolong belt life and avoid having the belt slip off during operation. This is done by tilting the idler roller (upper roller) ends slightly towards the front or rear, so that the belt does not get uncentered but stays on the middle of the rollers.

Note: Belt tracking adjustments may be necessary after changing or replacing a sanding belt, to counterbalance for unevennesses between sanding belts.

1. Make sure the sander is turned off and unplugged.
2. Manually rotate the sanding belt by hand to visually confirm the belt tracking.

If the belt is tracking straight and evenly on the middle of the rollers, you are ready to sand. Proceed with normal operations. If the belt is not tracking straight, follow the instructions below before proceeding with normal sanding operations.

3. Loosen lock nut **A** using a 10 mm wrench.
4. Slightly turn the tracking adjustment knob **B**.
 - Clockwise if the belt tracks to the right.
 - Counter-clockwise if the belt tracks to the left.
5. Turn on the machine on for a few seconds and check the position of the belt on the rollers
6. As needed, repeat this adjustment process until the belt is tracking evenly on the rollers.



MAINTENANCE



MAKE SURE THE SANDER HAS BEEN TURNED OFF AND UNPLUGGED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE.

PERIODIC MAINTENANCE

- Keep the machine **CLEAN** and **FREE OF DUST**. Vacuum or brush off any loose debris and wipe down the machine and the tables occasionally with a damp rag.
- Rollers must always be kept clean. Dirt on rollers will cause poor tracking and belt slippage.
- Periodically inspect the **ON/OFF switch**, power cord, plug and other parts for damage.



DO NOT OPERATE THE SANDER WITH A DAMAGED SWITCH, POWER CORD, PLUG, OR OTHER PARTS. REPLACE A DAMAGED PART IMMEDIATELY.

REQUIRED MAINTENANCE

REPLACEMENT OF THE SANDING BELT/DISC

Sanding belt / disc should be replaced when worn out.

Standard size (6" X 48") replacement belts/discs can be purchased in a variety of grits from your General® International dealer under the following part numbers:

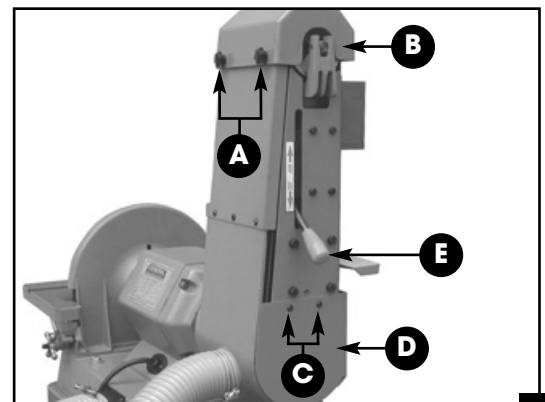
- | | |
|--|-------------------------------------|
| • #15-016 6" x 48" Sanding Belt 80 Grit | • #15-036 12" Sanding Disc 80 Grit |
| • #15-017 6" x 48" Sanding Belt 100 Grit | • #15-037 12" Sanding Disc 100 Grit |
| • #15-018 6" x 48" Sanding Belt 120 Grit | • #15-038 12" Sanding Disc 120 Grit |
| • #15-019 6" x 48" Sanding Belt 150 Grit | • #15-039 12" Sanding Disc 150 Grit |

or (depending on availability) from your local tool, abrasives or sharpening supply dealer. These are standard sizes that should be readily available in most areas. The use of any other size is not recommended and can lead to serious injury and/or damage to the machine.

Replace an installed, worn sanding belt/disc as follows:

BELT REPLACEMENT

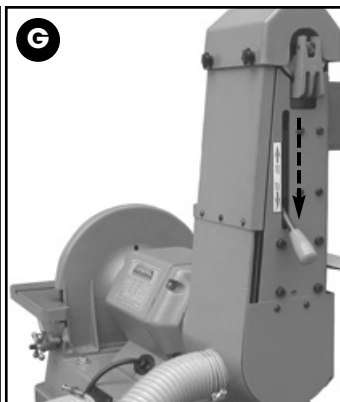
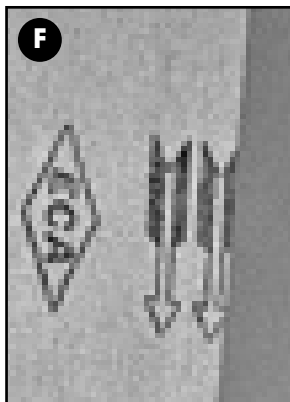
1. Make sure the sander is turned off and unplugged.
2. Loosen and remove both bolts on the guard **A** and remove the upper guard **B**.
3. Loosen and remove both lower guard phillips head screws **C** and remove the lower guard **D**.
3. Push the belt tension lever **E** up to release the tension on the belt and remove the belt.



Tip: To extend belt life and avoid premature breakage, take note of the direction arrows **F** printed on the inside of the sanding belt to make sure you install the belt in the correct direction.

5. Install a new sanding belt on the rollers, paying attention to the direction of the arrows, then pull the tension lever down, **G**, to tension the belt on the rollers, and re-install the upper and lower guards.

Note: Belt tracking adjustments may be necessary after changing or replacing a sanding belt.



SANDING DISC REPLACEMENT

1. Make sure the sander is turned off and unplugged.
2. Remove the worn sanding disc from the wheel.
3. Remove the protective sheet from the new sanding disc and carefully adhere one half of the disc to the wheel.
4. Rotate the wheel half a turn, and press the other half of the sanding disc into place as shown in **A**.



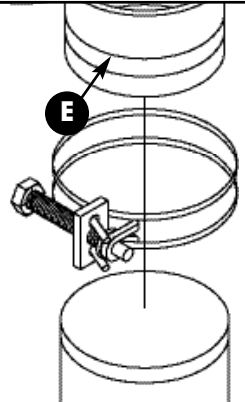
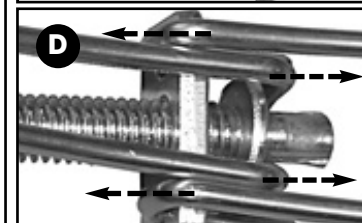
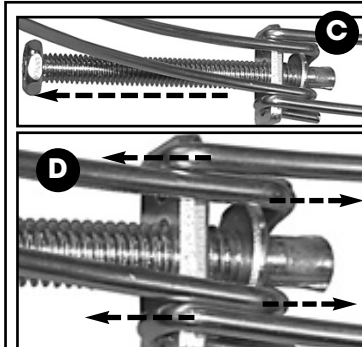
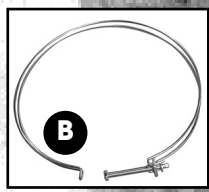
EMPTYING/CLEANING THE COLLECTOR BAG (15-035DC ONLY)



TURN THE SWITCH TO THE "OFF" POSITION AND UNPLUG THE UNIT FROM THE POWER SOURCE BEFORE EMPTYING OR REPLACING THE COLLECTOR BAG OR BEFORE PERFORMING ANY MAINTENANCE.

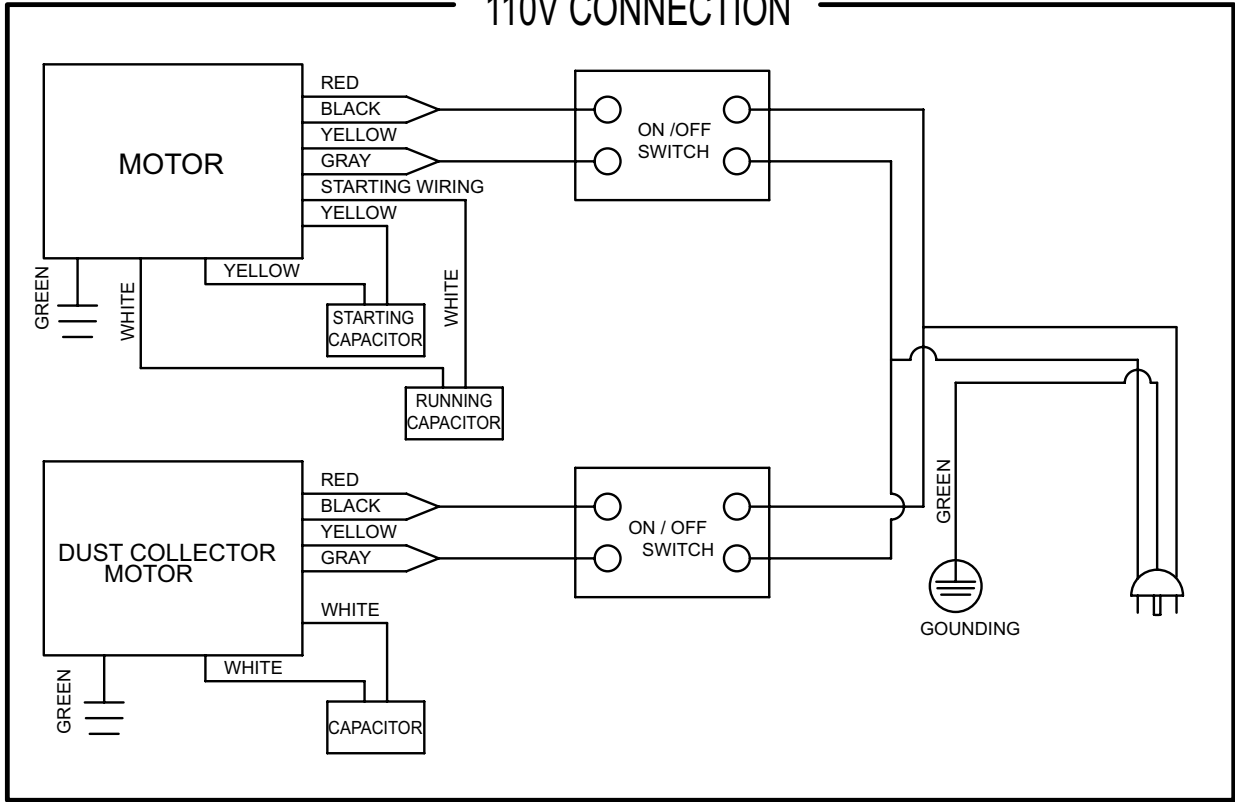
FINE PARTICULATE DUST IS A CARCINOGEN THAT CAN BE HAZARDOUS TO HEALTH. WEAR EYE A RESPIRATORY PROTECTION DEVICE WHEN EMPTYING/CLEANING THE DUST COLLECTOR BAG.

1. Using a screwdriver, loosen the clamp screw as much as needed, **C**, to loosen the belt clamp, then unclamp it by pushing in opposite directions as shown in **D**, and remove the bag from the machine.
2. Empty the bag (or, if it is too worn to be used again, dispose of the bag and its contents and replace with a new bag) disposing of the contents in a safe and responsible manner that complies with all local codes and regulations regarding waste disposal.
3. If needed, clean the bag by lightly tapping it to get rid of any build-up of debris.
4. Re-install the bag or install a new bag and use the bag clamp to hold the bag securely in place, making sure that the clamp is sitting in the groove **E**.

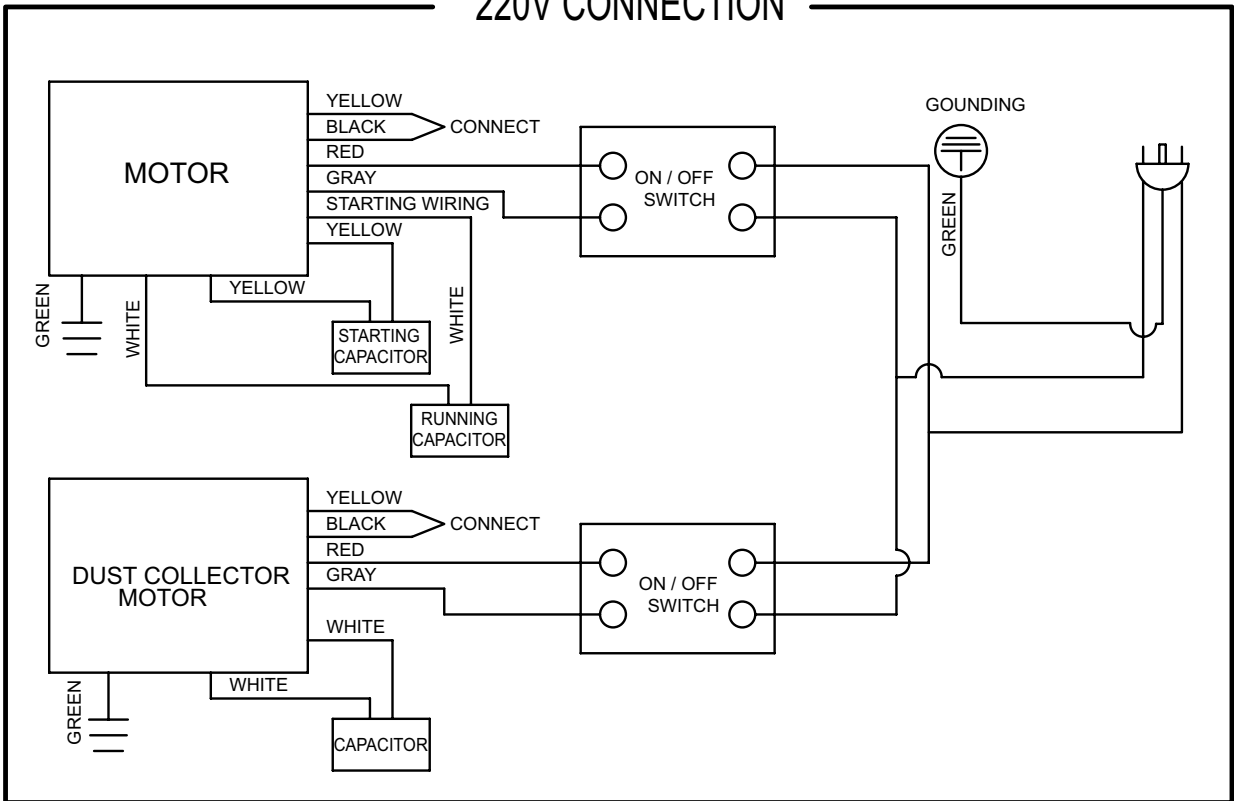


WIRING DIAGRAM

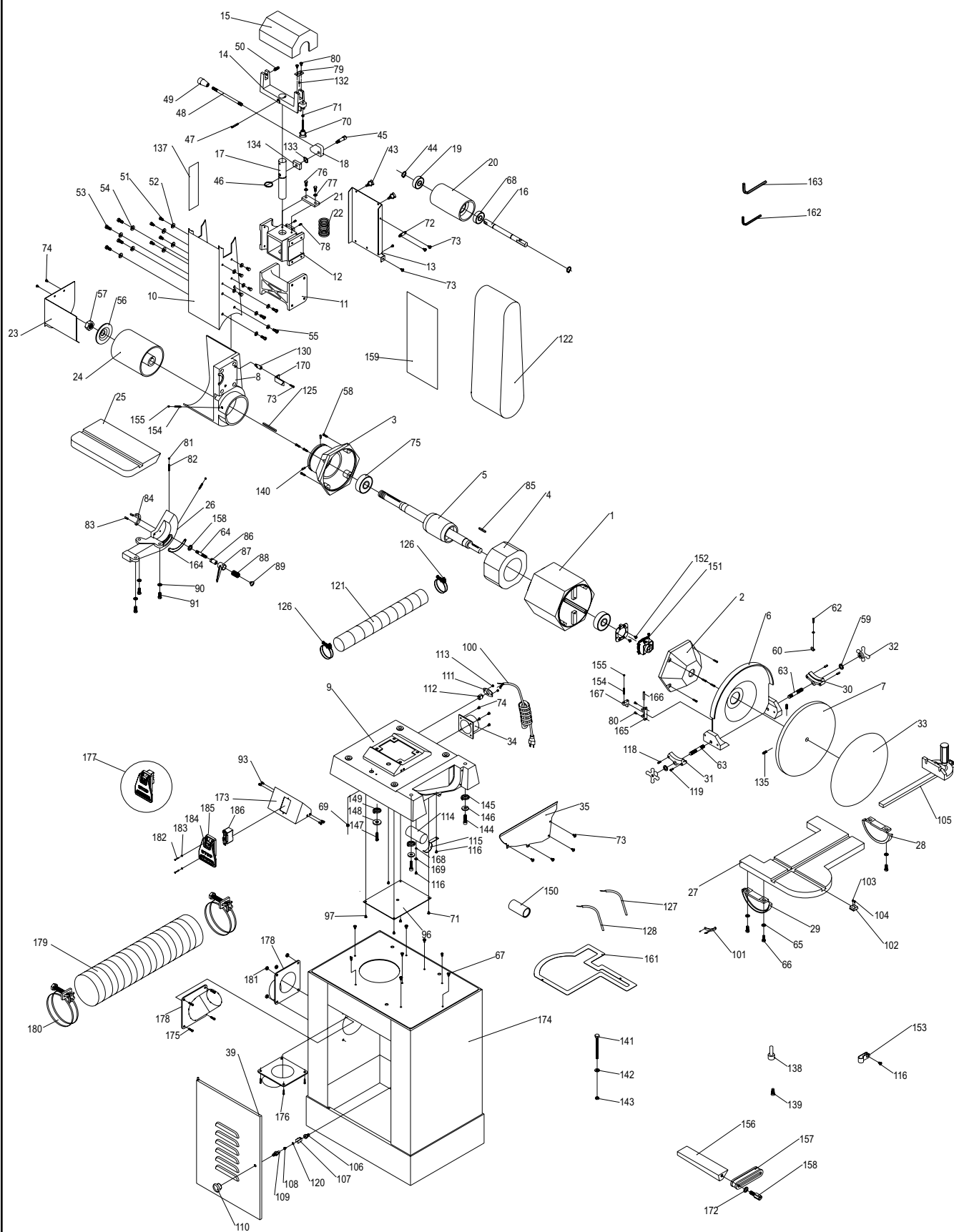
110V CONNECTION



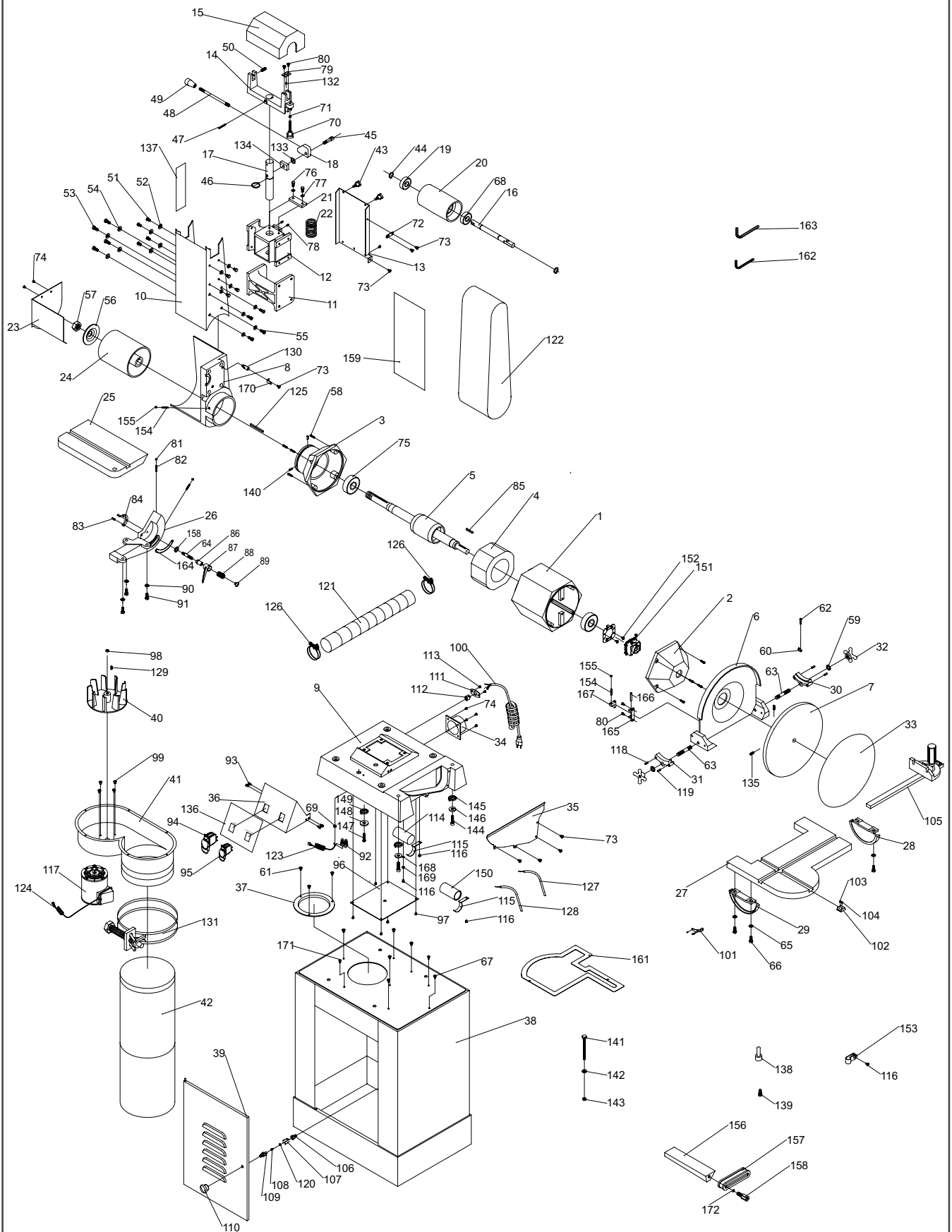
220V CONNECTION



MAIN ASSEMBLY (15-035)



MAIN ASSEMBLY (15-035DC)



PARTS LIST 15-035/15-035DC M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15035DC-01	MOTOR HOUSING		1
15035DC-02	MOTOR COVER (RH)		1
15035DC-03	MOTOR COVER (LH)		1
15035DC-04	STATOR	4P	1
15035DC-05	ROTOR SHAFT	4P	1
15035DC-06	DISC GUARD		1
15035DC-07	SANDING DISC PLATEN	12"	1
15035DC-08	BELT FRAME		1
15035DC-09	BASE		1
15035DC-10	BELT PLATE		1
15035DC-11	BELT PLATE BRACKET		1
15035DC-12	UPPER WHEEL BRACKET		1
15035DC-13	BELT COVER		1
15035DC-14	UPPER WHEEL BRACKET		1
15035DC-15	UPPER WHEEL GUARD		1
15035DC-16	UPPER WHEEL SHAFT	17x220	1
15035DC-17	SHAFT BRACKET	28x170	1
15035DC-18	QUICK ADJUSTING	57.8x42x16	1
15035DC-19	BEARING	#6203	1
15035DC-20	UPPER WHEEL (ALUM.)	3-1/2"	1
15035DC-21	SHAFT BRACKET	70x26x8	1
15035DC-22	UPPER WHEEL ADJUSTING SPRING	4.5x30x60	1
15035DC-23	LOWER WHEEL GUARD		1
15035DC-24	LOWER WHEEL (ALUM.)	5"	1
15035DC-25	BELT TABLE		1
15035DC-26	BELT TABLE BRACKET		1
15035DC-27	DISC TABLE		1
15035DC-28	ANGLE SLIDE (RH)		1
15035DC-29	ANGLE SLIDE (LH)		1
15035DC-30	ANGLE BRACKET (RH)		1
15035DC-31	ANGLE BRACKET (LH)	HOLE	1
15035DC-32	KNOB	7/16	2
15035DC-33	12" SANDING DISC	(SEE PAGE 17 FOR COMPLETE LIST)	1
15035DC-34	DUST CHUTE	2-1/2"	1
15035DC-35	DISC GUARD		1
15035DC-36	SWITCH PLATE		1
15035DC-37	FIXING RING		1
15035DC-38	CLOSED STAND		1
15035DC-39	DOOR PLATE		1
15035DC-40	FAN		1
15035DC-41	HOUSING		1
15035DC-42	DUST BAG	200x600x5	1
15035DC-43	KNOB	1/4x5/8	2
15035DC-44	C-RING	C-17	2
15035DC-45	QUICK ADJUSTING FIXED BOLT		1
15035DC-46	C-RING	C-26	1
15035DC-47	SPRING PIN	5x30	1
15035DC-48	HANDLE (LONG)	3/8x180	1
15035DC-49	BALL (RED)	3/8	1
15035DC-50	STOP SCREW	M8x25L	1
15035DC-51	HEX SCREW	1/4x5/8	8
15035DC-52	LOCK WASHER	1/4	8
15035DC-53	HEX SCREW	5/16x3/4	4
15035DC-54	LOCK WASHER	5/16	8
15035DC-55	TELESCOPIC SCREW	5/16x1-1/4	4
15035DC-56	FLANGE WASHER	1"	1

PARTS LIST 15-035/15-035DC M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15035DC-57	HEX NUT	1"	1
15035DC-58	PHILLIPS HEAD SCREW	1/4x1"	6
15035DC-59	FLAT WASHER	M10x25	2
15035DC-60	POINTER		1
15035DC-61	LOCK WASHER	3/16	1
15035DC-62	PHILLIPS HEAD SCREW	3/16x1/4	2
15035DC-63	BRACKET ADJUSTING SCREW		2
15035DC-64	BRACKET ADJUSTING SCREW	DITCH	1
15035DC-65	LOCK WASHER	5/16x18	4
15035DC-66	HEX SCREW	5/16x5/8	4
15035DC-67	PHILLIPS HEAD SCREW W/WASHER	3/16x3/8	18
15035DC-68	BEARING	#6003	1
15035DC-69	BALL	1/2	2
15035DC-70	LOCK KNOB	1/4x2-1/4	1
15035DC-71	HEX NUT	1/4	1
15035DC-72	BELT COVER BRACKET		1
15035DC-73	PHILLIPS HEAD SCREW W/WASHER	3/16x3/8	7
15035DC-74	PHILLIPS HEAD SCREW W/WASHER	3/16x3/8	3
15035DC-75	BEARING	#6206	2
15035DC-76	HEX SCREW	1/4x3/4	2
15035DC-77	FLAT WASHER	1/4x16x2	2
15035DC-78	STOP SCREW	M5x10	2
15035DC-79	ADJUSTING PLATE		1
15035DC-80	PHILLIPS HEAD SCREW W/WASHER	3/16x1/4	1
15035DC-81	HEX NUT	M5	2
15035DC-82	STOP SCREW	M5x30	2
15035DC-83	SPRING PIN	4x12	2
15035DC-84	HALF-CIRCLE KEY		2
15035DC-85	DOUBLE ROUND HEAD PIN	5x5x32	1
15035DC-86	TOOTH NUT		1
15035DC-87	HANDLE		1
15035DC-88	HANDLE SPRING		1
15035DC-89	ALUM. SCREW		1
15035DC-90	FLAT WASHER	5/16x18x2	3
15035DC-91	HEX SCREW	5/16x1	3
15035DC-92	TERMINAL	73B	2
15035DC-93	TELESCOPIC SCREW	1/4x1/2	4
15035DC-94	SWITCH (BIG)	4P	1
15035DC-95	SWITCH (SMALL)	4P	1
15035DC-96	BASE PLATE		1
15035DC-97	PHILLIPS HEAD SCREW W/WASHER	3/16x3/8	4
15035DC-98	NYLON SCREW	M10	1
15035DC-99	PHILLIPS HEAD SCREW W/WASHER	3/16x1/2	4
15035DC-100	POWER CORD	SJT14x3Cx2M 105°	1
15035DC-101	ANGLE LABEL		1
15035DC-102	SLIDING BLOCK		1
15035DC-103	SCREW	1/4x1/2	1
15035DC-104	CENTER POINT	1/4x1/2	1
15035DC-105	MITRE GAUGE		1
15035DC-106	HEX ADJUSTING BOLT		1
15035DC-107	SPRING CLIP		1
15035DC-108	PHILLIPS HEAD SCREW	3/16x1/4	1
15035DC-109	SPECIAL BOLT		1
15035DC-110	ROUND HEAD KNOB	3/8	1
15035DC-111	WIRE PLATE	MIDDLE	1
15035DC-112	WIRE RETAINER	8R-1	1

PARTS LIST
15-035/15-035DC M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15035DC-113	PHILLIPS HEAD SCREW W/WASHER	3/16x1/4	2
15035DC-114	CONDENSER	300UF 125V	1
15035DC-115	FIXTURE	34MM MIDDLE OPEN	2
15035DC-116	PHILLIPS HEAD SCREW W/WASHER	3/16x1/4	3
15035DC-117	DUST MOTOR		1
15035DC-118	SPRING PIN	6x40	2
15035DC-119	SPRING PIN	6x50	2
15035DC-120	SPRING FLAT	3/16	1
15035DC-121	DUST HOSE	2-1/2x750	1
15035DC-122	6" x 48" SANDING BELT	(SEE PAGE 17 FOR COMPLETE LIST)	1
15035DC-123	POWER CORD (MALE)	SJT16x3Cx1' 75°	1
15035DC-124	POWER CORD (FEMALE)	SJT16x3Cx1.8' 75°	1
15035DC-125	DOUBLE ROUND PIN	5x5x67	1
15035DC-126	DUST HOSE CLIP	70	2
15035DC-127	TERMINAL (BLACK)	16Ax105°1(H)	4
15035DC-128	TERMINAL (WHITE)	16Ax105°1(H)	4
15035DC-129	ROUND HEAD PIN	4x4x15	1
15035DC-130	INDICATOR FIXED BOLT	12x30	1
15035DC-131	DUST BAG CLAMP	210	1
15035DC-132	ADJUSTING SPRING (SMALL)	1x8x17L	1
15035DC-133	WAVE WASHER	12.5X17	1
15035DC-134	BRACKET OF UPPER SHAFT	35x23x10	1
15035DC-135	STOP SCREW	M6x10L	2
15035DC-136	SWITCH LABEL	165x131	1
15035DC-137	ARROW LABEL	100x15	1
15035DC-138	TERMINAL	A3-1	1
15035DC-139	TERMINAL	CE-2	4
15035DC-140	SPRING PIN	6x14	2
15035DC-141	HEX SCREW	5/16x4"	4
15035DC-142	FLAT WASHER	5/16x15x2T	8
15035DC-143	HEX NUT	5/16	4
15035DC-144	TELESCOPIC HEX SCREW	3/8x1-1/4	2
15035DC-145	LOCK WASHER	3/8	2
15035DC-146	FLAT WASHER	3/8x19x2T	2
15035DC-147	HEX SCREW	5/16x3/4	4
15035DC-148	FLAT WASHER	5/16x18x2T	4
15035DC-149	LOCK WASHER	5/16	4
15035DC-150	CONDENSER	16UF/350V	1
15035DC-151	CENTRIFUGAL SWITCH SET	32MM 4P	1
15035DC-152	PHILLIPS HEAD SCREW W/WASHER	3/16x3/8	2
15035DC-153	CLIP	ACC2.5	1
15035DC-154	STOP SCREW	M6x25	1
15035DC-155	HEX. NUT	M6	1
15035DC-156	BACKSTOP		1
15035DC-157	BACKSTOP HOLDER		1
15035DC-158	HEX HEAD BOLT	7/16" X 3"	1
15035DC-159	GRAPHITE	371.5 X 159	1
15035DC-160	DUST MOTOR LABEL		1
15035DC-161	RUBBER SEAL		1
15035DC-162	ALLEN KEY	M3x140L	1
15035DC-163	ALLEN KEY	M4	1
15035DC-164	SCALE		1
15035DC-165	BASE		1
15035DC-166	PIN	6x35	1
15035DC-167	L BRACKET		1

PARTS LIST
15-035/15-035DC M1

PART NO.	DESCRIPTION	SPECIFICATION	QTY
15035DC-168	WASHER	M5	1
15035DC-169	SPROCKET WASHER		1
15035DC-170	BELT POINTER		1
15035DC-171	SCREW	3/16" X 3/8"	2
15035DC-172	FLAT WASHER		1
15035-173	SWITCH PLATE		1
15035-174	CLOSED STAND		1
15035-175	PHILLIPS HEAD SCREW	3/16" X 1/2"	4
15035-176	PHILLIPS HEAD SCREW	3/16" X 1/4"	4
15035-177	SWITCH ASS'Y	GENERAL STOPPER	1
15035-178	DUST CHUTE	YW1075	3
15035-179	DUST HOSE	4" X 300 MM	1
15035-180	DUST HOSE CLAMP	4" X 1/4"	2
15035-181	HEX NUT	3/16"	4
15035-182	PHILLIPS HEAD SCREW		2
15035-183	HEX NUT		2
15035-184	STOP PLATE		1
15035-185	SWITCH COVER		1
15035-186	ON/OFF SWITCH		1

Notes

MODELS 15-035/15-035DC



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IMPORTANT

When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.