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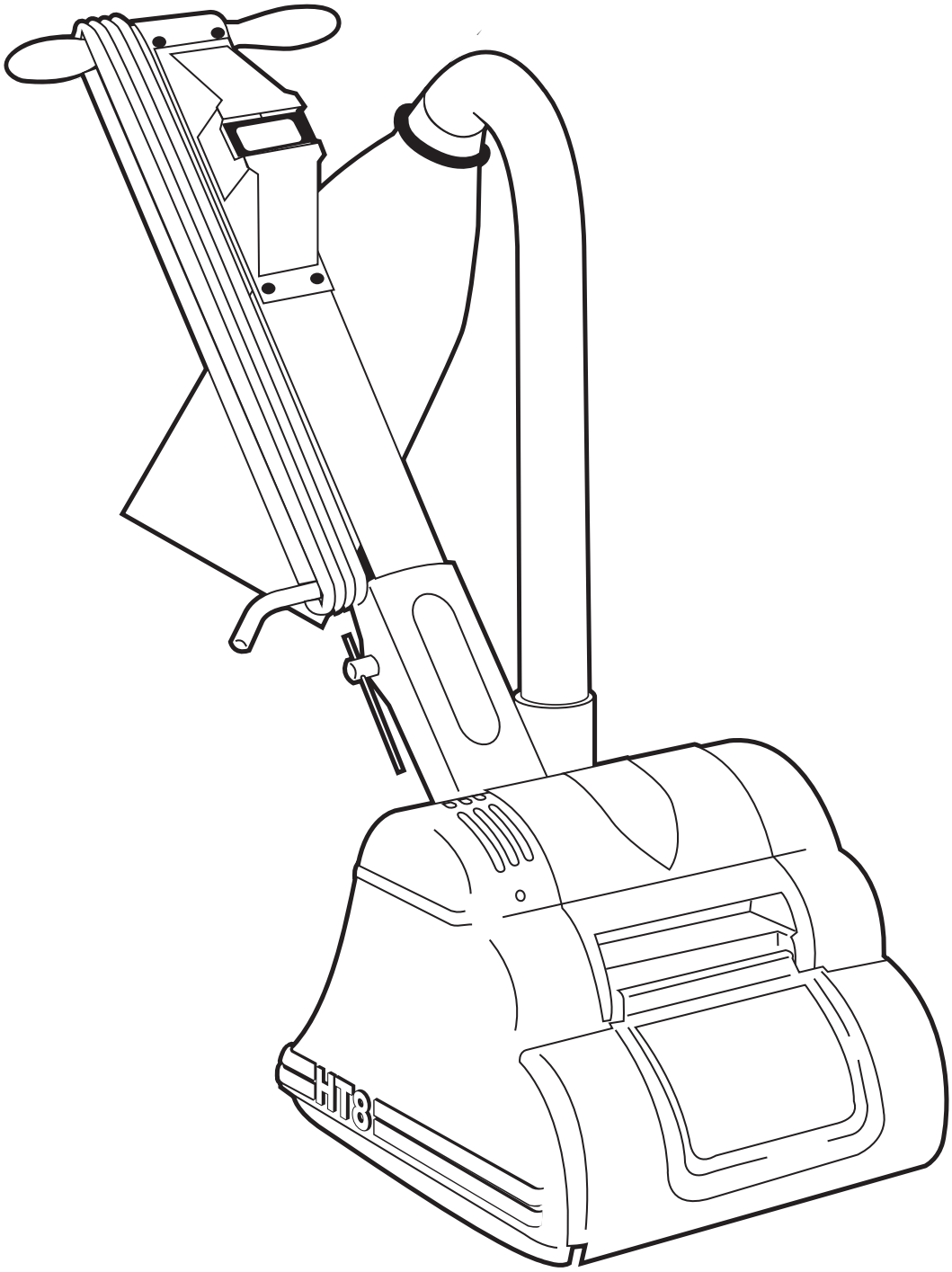
FLOOR SANDER



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INSTRUCTIONS FOR FITTING PRESS-IN TYPE DRUM INSERTS
MODELS: HT8-1, HT8-1.2, DU-8, DU8X

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PART No.163753-0

Please note that models DU-8 and DU8X used threaded inserts as original parts. These are easily identified and may be replaced using as screw driver without the need to remove the drum from the machine. Replace these inserts with Part No. 990000.

If the drum has been replaced with a new type drum follow the procedure below to replace the press in type inserts.

KIT CONTENTS

PSTK: 164607 Drum Insert Kit

3 x Threaded Inserts

2 x Screw 8-32 NC

1 x Fitting Instructions

REMOVE EXISTING INSERTS

1. Ensure that the power supply is disconnected.
2. REMOVE - guard-belt, guard-wall end, belts, pulley-drum, key (shaft drum).
3. REMOVE drum bearing retainer plate belt side (four screws).
4. The shaft can now be pushed out towards the brush gear side of the main frame.
5. REMOVE the bearing (belt side), drum and spacer.
6. REMOVE the drum end plate.
   A. Earlier models are retained by hammer drive rivets which can be removed by loosening with a cold chisel and drawing out with a pair of side cutters or pliers.
   B. Later models are retained by two cross recess screws.
7. Using a suitable drift and hammer remove the lifting pin assembly by placing the drift inside the drum web against the spring and driving towards the opposite end of the drum.
8. To remove the three inserts, use service tool Drum Insert Removal Tool Part No. 168322 or a drift/punch of 9mm (23/64") diameter preferably with a centre location to avoid slipping off the insert. Using clamps or a large vice ensure that the drum is firmly held and, using the punch and hammer, drive the inserts into the drum web.

TO FIT NEW INSERTS

1. If fitting the centre lifting pin assembly ensure that the assembly, including the centre inserts, are fitted together before punching the insert into the drum, as the lifting pin assembly cannot be fitted afterwards. Using a high strength engineering adhesive (loctite or similar) punch the inserts into the drum ensuring that the top of the insert is level with or just below the surface of the recessed portion of the drum.
2. To fit the drum end plate use the two new screws provided in the kit with a small quantity of thread lock. These screws are thread forming 8-32 nc. so will replace the hammer drive rivets without drilling & tapping unless the holes have been badly damaged during removal of the rivets, in which case it may be necessary to turn the end plate 90° and drill two new holes in the other webs (use drill diameter 3.8mm [0.149"]).

IMPORTANT: The machine is subject to high speeds, use a suitable thread lock compound on all screws.

TO RE-FIT THE DRUM

1. It is advisable to renew drum bearings with genuine parts only, as similar sized bearings may be unsuitable for this application.
2. Fit the drum, spacer and shaft taking care to position the spacer correctly (with the chamfer facing the bearing).

IMPORTANT: Carefully position the drum drive pin into the slot provided in the drum before continuing.

3. Fit the bearing and bearing retainer plate belt side (four screws) and fit the pulley, plain washer, lock washer and nut do not tighten. Check that the drive pin is still correctly located in the slot before tightening the nut to 28 ft.lbs. torque.

   ENSURE THAT THE DRUM NOW ROTATES FREELY.
4. Re-fit belts, belt guard and guard-wall end. Carry out safety checks..

DRUM ASSEMBLY