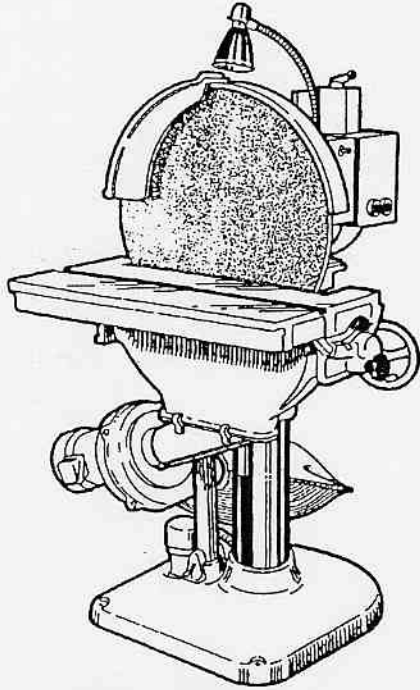


STATE



24"

Disc Sander

Operator's Manual

FOR YOUR OWN SAFETY

Before Assembling & Operating This Sander, Read This Operator's Manual Carefully & Completely. Become Familiar With The Operation, Applications & Potential Hazards Peculiar To This Sander.

Check To Make Sure That There Is No Apparent Damage From Shipment Before You Begin To Unpack & Set The Sander Up For Operation. Report Any & All Damages Immediately To The Carrier.

STATE Sanders Limited Warranty

We warrant that within one (1) year from date of shipment, provided sander has been installed and operated in accordance with its respective Operator's Manual, we will replace or repair at our option, free of charge, any part or parts which upon our examination are found to be defective in workmanship or material.

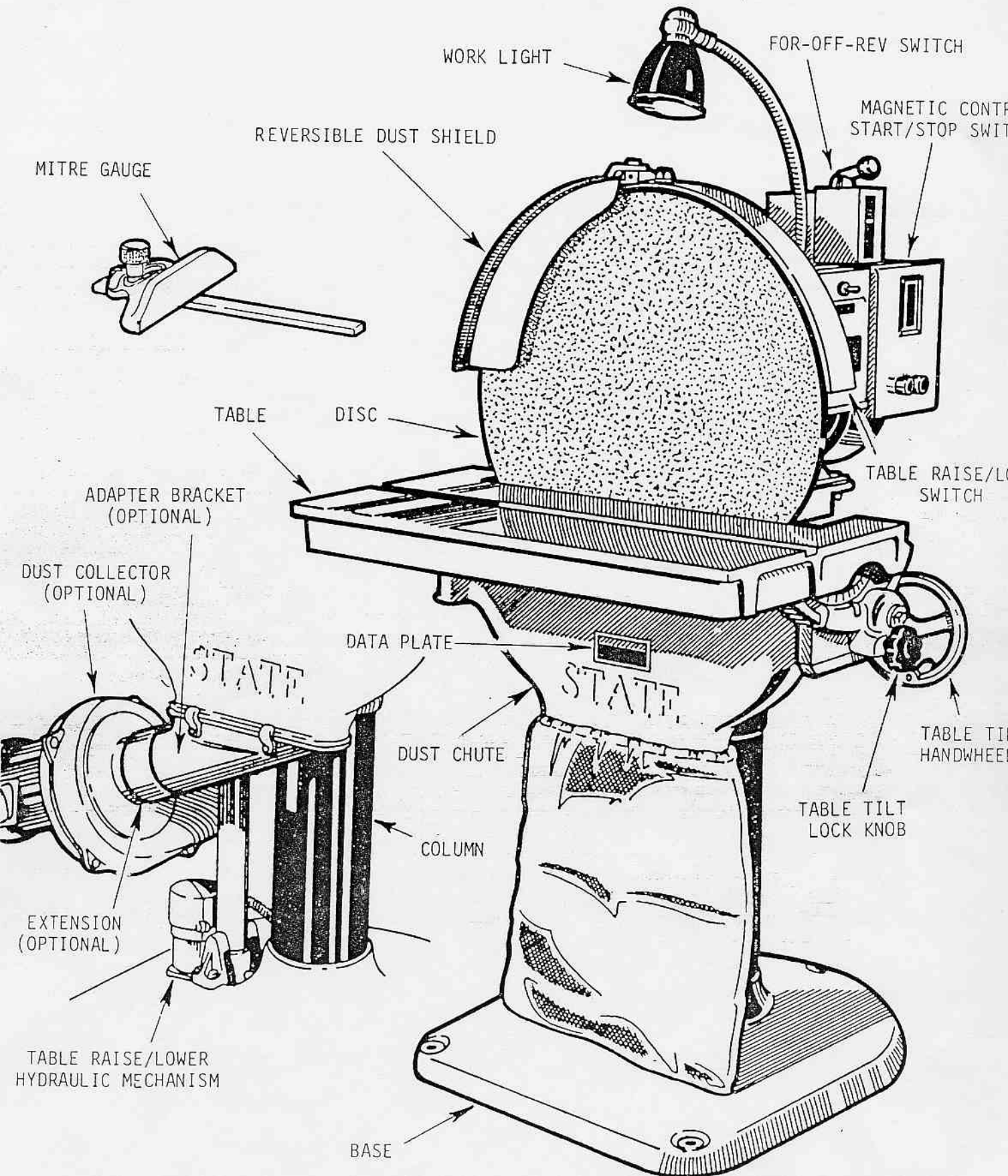
For a period of ninety (90) days from date of shipment, a State Sander which cannot be repaired by the customer, in the field, will be returned to State Manufacturing or FREEMAN Manufacturing & Supply Company in Cleveland, OH, at our cost for the necessary repairs to be performed and returned at no cost to the customer. We cannot however, provide a loner during this time period.

After ninety (90) days from date of shipment, a nominal per hour labor charge, plus expenses, will apply to cover any labor necessary to repair a State Sander either in the field, or at State Manufacturing, or at FREEMAN Manufacturing & Supply Company in Cleveland, OH.

FREEMAN MFG. & SUPPLY CO.

1101 MOORE ROAD AVON, OHIO 44011-1011
440-934-1902 FAX 440-934-7200 (800) 321-8511

STATE 24" Disc Sander



D-24 TILT TABLE COMPONENTS

TABLE TILTING
HANDWHEEL
(013227)

TABLE TILTING
STEEL SHAFT
(013226)

TABLE TILTING
LOCK KNOB
(013013)

TILTING TABLE
FEMALE SEGMENT
FOR STEEL WORM
(013222)

NYLON SPACER
-As Required-
(226A)

TILTING TABLE
STEEL WORM
(013239)

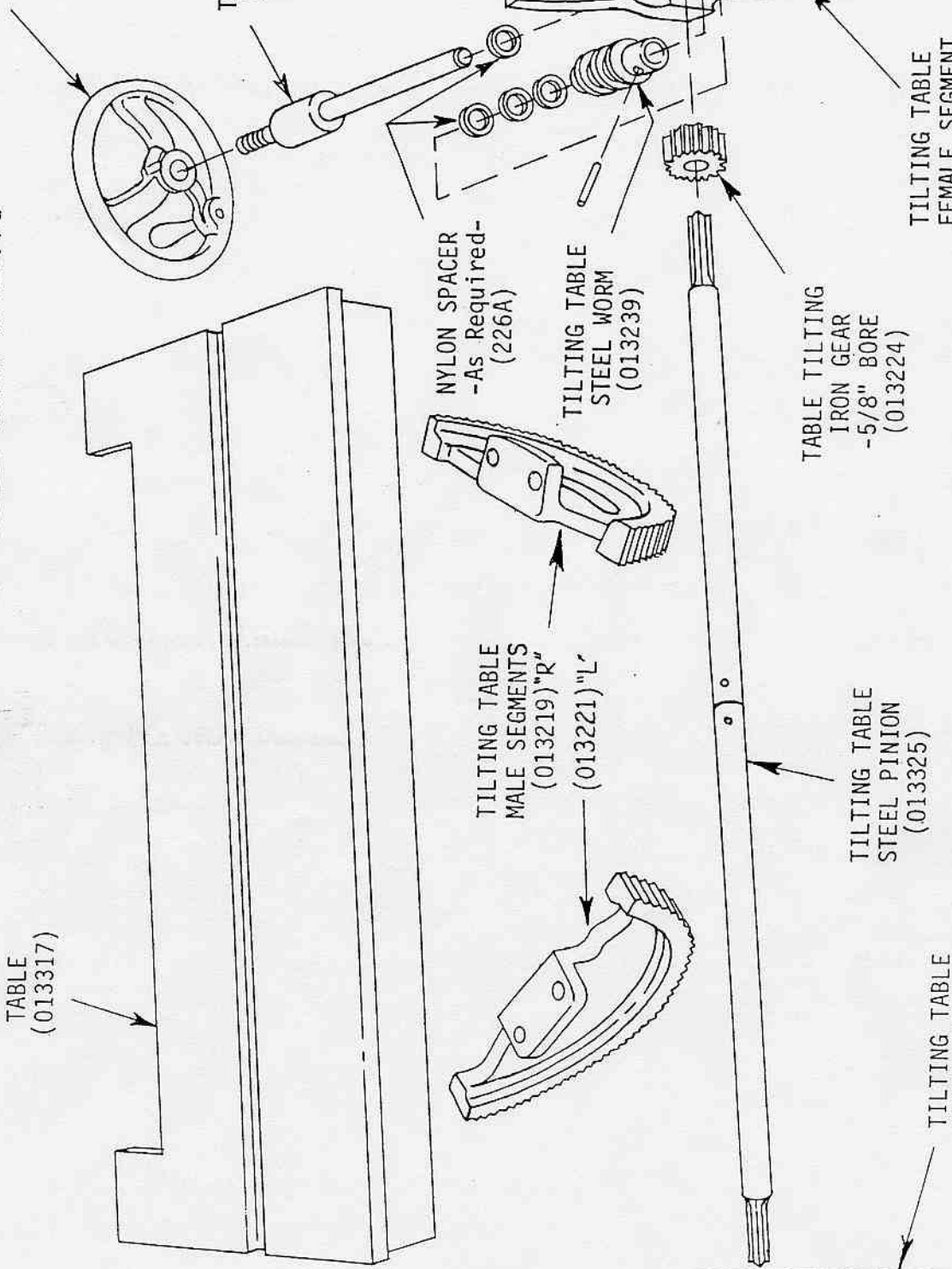
TABLE TILTING
IRON GEAR
-5/8" BORE
(013224)

TILTING TABLE
MALE SEGMENTS
(013219) "R"
(013221) "L"

TILTING TABLE
STEEL PINION
(013325)

TILTING TABLE
FEMALE SEGMENT
(013220)

TABLE
(013317)



24 STATE DISC SANDER REPLACEMENT PARTS

<u>PRODUCT CODE</u>	<u>DESCRIPTION</u>
013013	TABLE TILTING LOCK KNOB
013158	DISC MOUNTING FLANGE SCREW
013179	DUST BAG
013181	BASE CLAMP
013182	BLOWER ATTACHMENT
013187	WORK LIGHT
013203	MOTOR ³ / ₂ HP, 3 PH, 1200 RPM, TEFC
013207	DISC MOUNTING FLANGE
013210	COLUMN
013219	TABLE TILTING SEGMENT MALE "R" (FOR WORM GEAR)
013220	TABLE TILTING SEGMENT FEMALE
013221	TABLE TILTING SEGMENT MALE "L" (FOR WORM GEAR)
013222	TABLE TILTING SEGMENT FEMALE FOR STEEL WORM
013223	TABLE TILTING GRADUATION
013224	TABLE TILTING IRON GEAR, 5/8" BORE
013226	TABLE TILTING STEEL SHAFT
013227	TABLE TILTING HANDWHEEL
013228	TABLE MITER GAUGE
013235	STEEL RACK
013239	TABLE TILTING STEEL WORM
013304	MOTOR DISC GUARD
013305	STEEL DISC
013306	DISC DUST SHIELD
013309	MOTOR BASE
013311	COLUMN RAISING AND LOWERING BRACKET
013317	TABLE

SET-UP INSTRUCTIONS (continued)

ELECTRICAL INFORMATION

This Disc Sander is furnished with a 3-phase electric motor and must have power wired directly to the switch.

CAUTION: Check electrical tag on Sander to make sure correct voltage has been received and if necessary, contact local electrician to make sure wiring will meet local codes.

How To Apply Abrasive Disc (refer to illustrations at right)

FREEMAN stocks the most widely used type of abrasive discs normally used for disc-type sanding. Refer to, or request our FREEMAN Catalog Section 1 for availability information.

7.1 - With abrasive disc laid on flat surface (back side up), apply FREEMAN Latex Disc Cement to entire back surface. A brush or clean cloth can be used for this purpose.

7.2 - Lower table of Sander as far as it will go to expose as much of the metal disc surface as possible. Coat entire surface of metal disc with FREEMAN Latex Disc Cement. Brush can be cleaned immediately using soapy water.

7.3 - Allow cement to dry completely on both surfaces. When cement changes from its pink color to reddish-brown, it's dry.

7.4 - Line up abrasive disc to metal disc carefully because once contact is made, shifting of abrasive disc is very hard.

7.5 - Once abrasive disc has been located onto metal disc, use some type of roller to burnish down entire abrasive surface.

7.6 - When changing abrasive disc start on an outside edge using a putty knife to break the adhesive bond.

7.7 - Once started, abrasive disc can be easily stripped away from metal disc.

Make sure dust collector bag or some means of dust control system is connected to the Disc Sander before proceeding with Operating Instructions. This will assure operator safety as well as maintain a cleaner and safer work area.



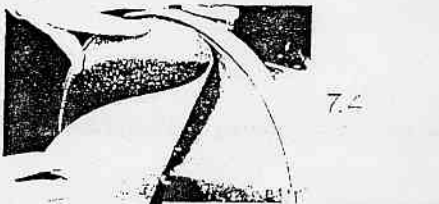
7.1



7.2



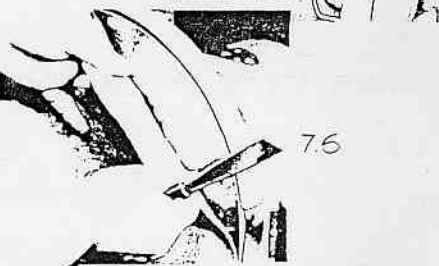
7.3



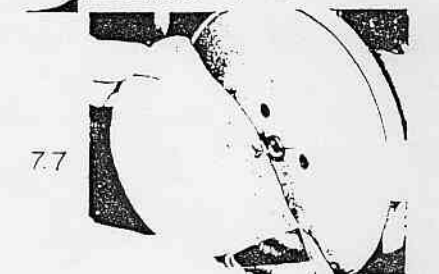
7.4



7.5



7.6

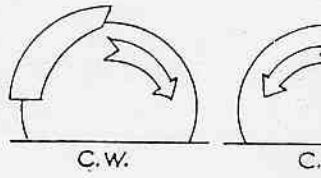


7.7

3.3 - Don't push too hard or "hog in" workpiece when sanding because quality of finish will suffer.

3.4 - Make sure lock knob is loosened before adjusting table angle and NEVER ADJUST TABLE ANGLE WITH WORKPIECE ON TABLE because piece could drop and be damaged or operator could become injured.

CAUTION: Adjustable dust shield should be in place and properly positioned before any sanding begins (refer to illustrations at right.)

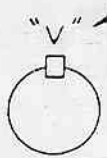


Maintenance Instructions

WARNING: BEFORE PERFORMING ANY ADJUSTMENTS OR MAINTENANCE ON YOUR SANDER MAKE SURE ELECTRICAL POWER TO SANDER IS TURNED OFF AT SOURCE.

1. The bearings in this Disc Sander are the pre-sealed, permanently lubricated type . . . NO OILING NECESSARY.
2. This Disc Sander does not require any grease, but wiping moving parts (table gears, etc.) with oily rag periodically will help.
3. Continually check for worn or loose parts.
4. Use FREEMAN Abrasive Cleaner Bar frequently to keep abrasive disc in top condition and to extend its useable life. This preventive maintenance will also produce finer sanding results.
5. The metal disc is factory balanced. If you ever have to temporarily remove this metal disc, it must be installed in the identical manner (bolt and hole alignment) as factory assembled to run correctly. For this reason every disc has a "V" stamped in it aligned to the keyway slot in the drive shaft.

STAMPED IN DISC -



Abrasive Discs For Use On Disc Sanders

The Abrasive Disc products listed on this page represent the most popular sizes & grits used throughout the pattern trade. These Abrasive Discs are subject to quantity discount based on the total number of units purchased.

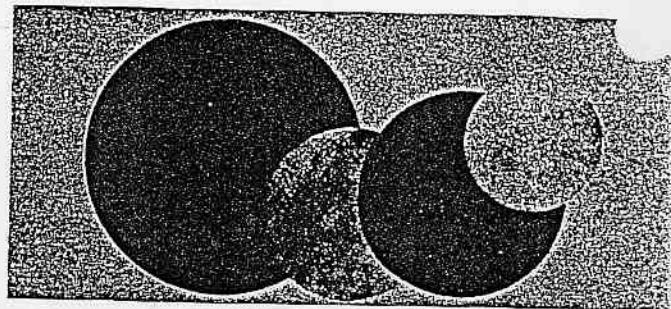
WE STOCK & DISTRIBUTE:

- **GARNET PAPER DISCS**
Used primarily for wood because of its' sharp cutting capabilities.
- **PRODUCTION PAPER DISCS**
Used primarily for wood. Not as sharp as Garnet Paper Discs but offers more durability.
- **3-MITE CLOTH DISCS**
Used primarily for metal & plastic & recognized as the most economical of the cloth discs.
- **3-MITE PSA CLOTH DISCS**
Same as 3-Mite Cloth Discs but with pressure sensitive backing for ease of application.
- **3-MITE PSA CLOTH RESIN BOND DISCS**
The premium abrasive disc in our line that offers the most durability & longer service & pressure-sensitive adhesive backing.

ORDERING INFORMATION

Cat. No.	Disc Dia.	Grit	No. of Discs In Std. Pkg.	No. of Discs in Std. Unit
GARNET PAPER DISCS				
131110	12"	50	50	100
131115	12"	40	50	100
131120	12"	36	50	100
131125	14"	40	50	100
131130	15"	50	50	100
131135	15"	40	50	100
131140	15"	36	50	100
131145	16"	100	50	100
131150	16"	50	50	100
131155	16"	40	50	100
131160	16"	36	50	100
131165	18"	40	50	100
131170	18"	36	50	100
131175	20"	40	50	100
131185	20"	36	50	100
131190	24"	40	20	20
131205	24"	36	20	20
131210	24"	24	20	20
131215	30"	40	20	20
131220	30"	36	20	20
131225	36"	36	20	20
131230	37 1/2"	36	20	20

3-MITE PSA CLOTH DISCS				
131345	12"	40	25	50
131350	15"	40	25	50
131355	15"	36	25	50
131360	16"	40	25	50
131365	16"	36	25	50
131367	18"	40	25	50
131370	18"	36	25	50
131375	20"	40	25	50
131385	20"	36	25	50
131390	20"	24	25	50
131395	24"	40	10	10
131410	24"	36	10	10
131420	30"	40	10	10
131425	30"	36	10	10
131435	36"	40	10	10
131440	36"	36	10	10
131445	36"	36	10	10

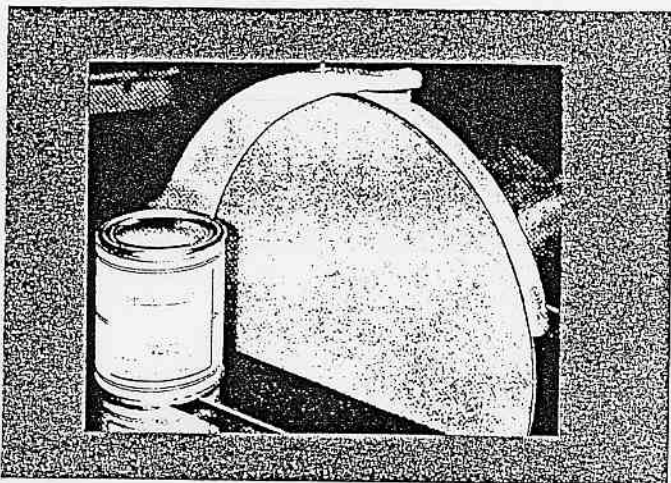


Cat. No.	Disc Dia.	Grit	No. of Discs In Std. Pkg.	No. of Discs In Std. Unit
PRODUCTION PAPER DISCS				
131005	12"	50	50	100
131010	12"	40	50	100
131015	15"	50	50	100
131020	15"	40	50	100
131030	16"	50	50	100
131035	16"	40	50	100
131050	18"	40	50	100
131060	20"	40	50	100
131070	24"	40	20	20
131092	30"	40	20	20

3-MITE CLOTH DISCS				
131240	12"	40	25	50
131245	12"	36	25	50
131250	15"	50	25	50
131255	15"	40	25	50
131260	15"	36	25	50
131265	16"	40	25	50
131270	16"	36	25	50
131275	16"	24	25	50
131280	18"	40	25	50
131285	18"	36	25	50
131290	20"	40	25	50
131295	20"	36	25	50
131300	24"	40	10	10
131310	24"	36	10	10
131320	30"	40	10	10
131325	30"	36	10	10
131330	36"	40	10	10
131335	36"	36	10	10

3-MITE PSA RESIN BOND DISCS				
131455	12"	40	25	50
131460	15"	40	25	50
131465	15"	36	25	50
131470	16"	40	25	50
131475	16"	36	25	50
131480	18"	40	25	50
131485	18"	36	25	50
131490	20"	40	25	50
131495	20"	36	25	50
131500	20"	24	25	50
131505	24"	40	10	10
131510	24"	50	10	10
131515	24"	36	10	10
131520	24"	24	10	10
131525	30"	40	10	10
131530	30"	36	10	10
131535	30"	24	10	10
131540	36"	40	10	10
131545	36"	36	10	10

FREEMAN Latex Disc Cement



Our Latex Disc Cement is recognized throughout the pattern trade as the finest available. This cement will satisfactorily hold the regular flexible paper back & cloth back abrasives to the disc, even under varying climate conditions. Because it is easily applied with a brush, very little time is required for abrasive changeover.

5 Easy Steps For Application

- Clean both surfaces to be bonded & make sure steel disc is free of grease.
- Completely cover surfaces of both the abrasive backing & steel disc by brushing on cement. Immediately wash out brush with water.
- Allow disc cement to dry completely before applying abrasive disc—10-30 min.
- Carefully align edges of abrasive disc to steel disc & make contact.
 - Roll down abrasive disc from center-out with firm pressure using a roller.

ORDERING INFORMATION

Cat. No.	Description	Quantity*	Wt. Lbs.
025505	FREEMAN Latex Disc Cement	1 U.S. Quart	2½

*Standard Case Package - 12 Quarts

FREEMAN Abrasive Cleaner Bar



The easiest way to increase the life of your abrasives. Each bar is 1½" x 1½" x 8"; a comfortable size to hold with both hands while using. This Abrasive Cleaner Bar

- **INCREASES** efficiency in wood production.
- **REDUCES** frequency of changing abrasives.
- **INCREASES** quality of surface finishing.
- **REDUCES** costly down time.

The Abrasive Cleaner Bar is easy to use; just hold bar, with both hands, against the moving abrasive disc or belt until all loaded particles on abrasive are removed. By using the abrasive cleaner bar you will:

- Realize 3 to 4 times more abrasive disc & belt life.
- Prevent burning, chatter marks & machine vibration caused by loaded abrasives.
- Increase capabilities to produce uniform finishes.
- Eliminate messy cleanup.

ORDERING INFORMATION

Cat. No.	Description	Size	Wt. Lbs.
136850	Abrasive Cleaner Bar	1½" x 1½" x 8"	¾

FREEMAN Pitch Solvent

Dissolves pitch instantly. Quickly removes soft, or burnt-on pitch from saw blades, planer knives, machine rolls & tables. Also used on abrasive discs & belts. FREEMAN Pitch Solvent contains no kerosene, fuel oil, or alcohol.

ORDERING INFORMATION

Cat. No.	Description	Quantity	Wt. Lbs.
027230	FREEMAN Pitch Solvent	1 U.S. Gallon	10
027235	FREEMAN Pitch Solvent	5 U.S. Gallons	50
027240	FREEMAN Pitch Solvent	55 U.S. Gallons	550

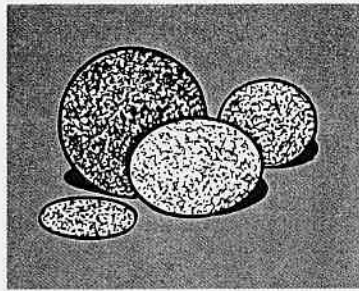


STATE Disc Sanders Accessories

Abrasive Discs

For Use On

Disc Sanders



The Abrasive Disc products listed on this page represent the most popular sizes and grits used throughout the pattern trade. These Abrasive Discs are subject to quantity discount based on the total number of units purchased.

We Stock & Distribute:

◆ Garnet Paper Discs

Used primarily for wood because of its' sharp cutting capabilities.

◆ Aluminum-Oxide Paper Discs

Used primarily for wood. Not as sharp as Garnet Paper Discs but offers more durability.

◆ Aluminum-Oxide, Glue-Bond Cloth Discs

Used primarily for metal and plastic and recognized as the most economical of the cloth discs.

◆ Aluminum-Oxide, Glue-Bond PSA Cloth Discs

Same as Aluminum-Oxide, Glue-Bond Cloth Discs but with pressure-sensitive backing for ease-of-application.

◆ Aluminum-Oxide, Resin-Bond Cloth Discs

The premium abrasive disc in our line that offers the most durability and longer service.

◆ Aluminum-Oxide, Resin-Bond Cloth, PSA Discs

The premium abrasive disc in our line that offers the most durability and a pressure-sensitive backing for mounting.

Cat. No.	Disc Dia.	Grit	No. of Discs in St'd. Pkg.	No. of Discs in St'd. Unit
Garnet Paper Discs (40 Grit St'd., Others Available)				
131115	12"	40	100	100
131135	15"	40	100	100
131155	16"	40	100	100
131165	18"	40	100	100
131175	20"	40	25	100
131195	24" x 1" *	40	20	20
131201	24"	40	20	20
131215	30"	40	20	20
131223	36"	40	20	20

Aluminum-Oxide, Glue-Bond, PSA Cloth Discs				
131345	12"	40	25	50
131350	15"	40	25	50
131355	15"	36	25	50
131360	16"	40	25	50
131365	16"	36	25	50
131367	18"	40	25	50
131375	20"	40	25	50
131385	20"	36	25	50
131395	24"	40	10	10
131400	24" x 1" *	40	10	10
131410	24"	36	10	10
131420	30"	40	10	10
131425	30"	36	10	10

Cat. No.	Disc Dia.	Grit	No. of Discs in St'd. Pkg.	No. of Discs in St'd. Unit
Aluminum-Oxide, Glue-Bond Cloth Discs				
131239	12"	50	25	50
131240	12"	40	25	50
131250	15"	50	25	50
131255	15"	40	25	50
131260	15"	36	25	50
131263	16"	50	25	50
131265	16"	40	25	50
131270	16"	36	25	50
131280	18"	40	25	50
131290	20"	40	25	50
131295	20"	36	25	50
131300	24"	40	20	20
131305	24" x 1" *	40	20	20
131320	30"	40	20	20
131325	30"	36	20	20

Alum.-Oxide, Resin-Bond, Closed-Coat, Paper Discs				
131011	12"	40	-	50
131021	15"	40	-	50
131036	16"	40	-	50
131051	18"	40	-	50
131061	20"	40	-	50
131071	24"	40	-	10
131076	24" x 1" *	40	-	10
131093	30"	40	-	10

Aluminum-Oxide, Resin-Bond Cloth Discs				
131560	12"	40	25	50
131565	15"	50	25	50
131570	15"	40	25	50
131575	15"	36	25	50
131580	16"	40	25	50
131585	16"	36	25	50
131590	20"	40	25	50
131595	20"	36	25	50
131600	24"	50	10	10
131605	24"	40	10	10
131610	24"	36	10	10
131615	30"	40	10	10
131620	30"	36	10	10

Aluminum-Oxide, PSA, Resin-Bond Discs				
131455	12"	40	25	50
131460	15"	40	25	50
131465	15"	36	25	50
131467	16"	80	25	50
131468	16"	60	25	50
131470	16"	40	25	50
131475	16"	36	25	50
131480	18"	40	25	50
131485	18"	36	25	50
131490	20"	40	25	50
131495	20"	36	25	50
131505	24"	40	10	10
131510	24"	50	10	10
131515	24"	36	10	10
131520	24"	24	10	10
131525	30"	40	10	10
131530	30"	36	10	10