

ORBITAL SANDING GUIDELINES



Using the following guidelines will assure you get the most out of your random orbital sander.



EQUIPMENT OPERATION



- 1) Set the sander FLAT on the workpiece prior to starting the sander.
- 2) Remove the sander from the workpiece prior to releasing the sanding lever.
- 3) Let the abrasive do the work. You do not need to work the abrasive.
- 4) The typical sander weighs around 2-3 pounds. This is the exact weight that should be applied to the workpiece. Putting excessive pressure on the tool will cause the sander to stall, resulting in swirl marks.
- 5) Avoid tilting the sander on edge. This practice will result in dipping of the sanded surface and deeper swirl marks than normal.
- 6) Make sure that the back up pad is in good condition. Missing chunks, as well as buildup on the pads surface will “telegraph” through to the part being sanded, resulting in swirl marks.
- 7) Several passes over the area to be sanded are more effective than trying to push the sander hard with one pass. The best sanding pattern is long sweeping strokes with just the weight of the machine.
- 8) The sanding pattern of a random orbital sander is non-directional. It is not necessary to follow the grain of the wood.
- 9) Once a small area has been sanded, it is best to blend in the repair by lightly sanding the whole piece for a smooth consistent finish.

AIR SUPPLY RECOMMENDATIONS FOR ORBITAL SANDERS

- 1) When random orbital sanders are operated at air pressures below the manufacturer’s recommendations, they are far more likely to produce swirl marks on the work piece.
- 2) The air supply at the sander can be checked while the tool is running by utilizing a “T” fitting with an air pressure gauge attached. The “T” fitting should be the same I.D. as the connector on the tool.
- 3) The coupling from the tool to the hose should be the same I.D. as the pipe fitting recommended for that tool (i.e. Orbital sanders normally accept a 1/4” NPTF fitting). The I.D. of that fitting **SHOULD NOT** be reduced from 1/4” by a 3/16” quick-change coupler. Quick-change couplers in 1/4” are also available.
- 4) Most air tool manufacturers recommend the use of the next larger size I.D. hose from the tool to the pipe. A 5/16” hose is needed for a sander with a 1/4” I.D. coupling.
- 5) The length of hose between the tool and the air pipe should be as short as possible (under 20 feet) as rubber hoses restrict airflow. If longer hoses are necessary, the next larger I.D. should be utilized.
- 6) Any type of air control equipment attached to the iron supply pipe, (ex: oilers, gauges), should have an I.D. at least as large as the hose I.D.. Even one restriction in the air supply system will reduce the air supply below the minimum requirement.
- 7) Proper lubrication is required. If in-line oilers are not utilized, a daily application of the proper oil should be applied to the tool.
- 8) Random orbital sanders run most efficiently at approximately 90 PSI at the tool while running under load.



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