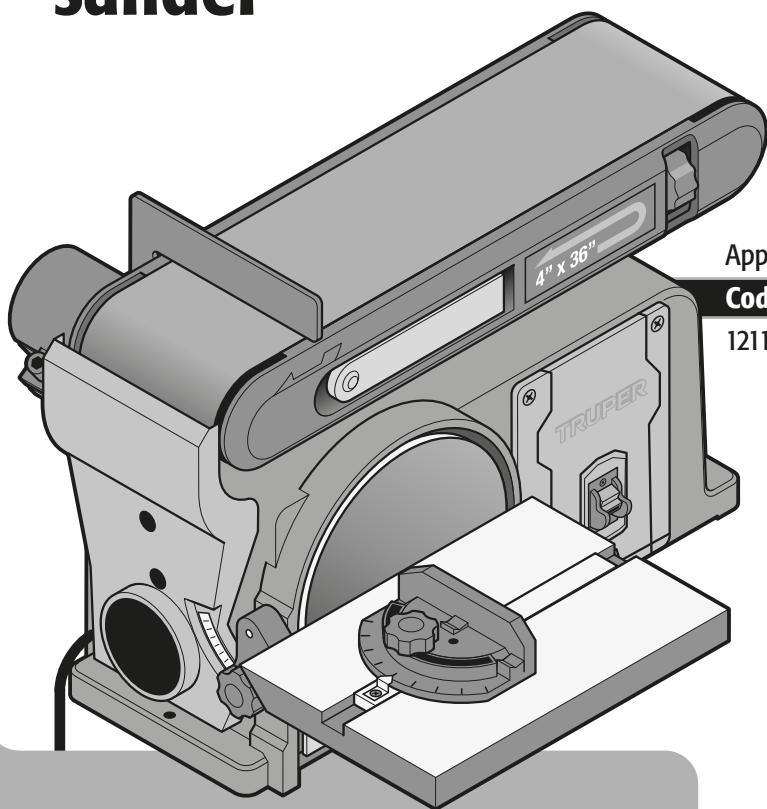


Manual

## Belt & disc sander

**1/2 Hp**

Power



Applies for:

Code	Model
12110	PUL-4X6T

# PUL-4X6T



Read the user's manual thoroughly  
before operating this tool.



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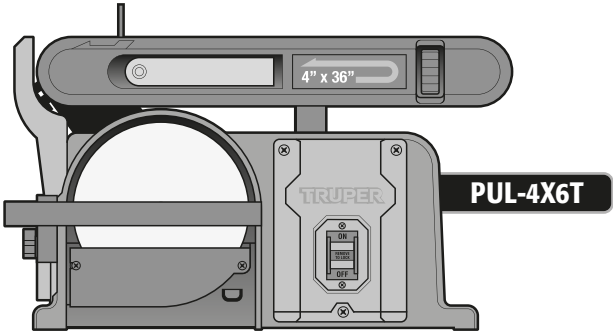
Warranty policy ..... 12

**! CAUTION**

To gain the best performance of the tool, prolong the duty life, make the Warranty valid if necessary, and to avoid hazards of fatal injuries please read and understand this Manual before using the tool.

Keep this manual for future references.

The illustrations in this manual are for reference only. They might be different from the real tool.



## PUL-4X6T

Code	•	12110			
Description	•	Belt & disc sander			
Band	•	4" x 36"			
Disc	•	6" diameter auto adhesive			
Voltage	•	120 V~			
Frequency	•	60 Hz			
Current	•	4.5 A			
Power	•	1/2 HP			
Speed	•	Belt: 1 969 fpm   Disc: 3 500 RPM			
Conductors	•	18 AWG x 3C with insulation temperature of 221 °F			
Insulation	•	Class I	IP Grade	•	IP20
Power cord grips used in this product: Type: Y Build quality: Basic insulation. Thermal insulation on motor winding: Class B					

**⚠ WARNING** Avoid the risk of electric shock or severe injury. When the power cable gets damaged it should only be replaced by the manufacturer or at a TRUPER Authorized Service Center. The build quality of the electric insulation is altered if spills or liquid gets into the tool while in use. Do not expose to rain, liquids and/or dampness.

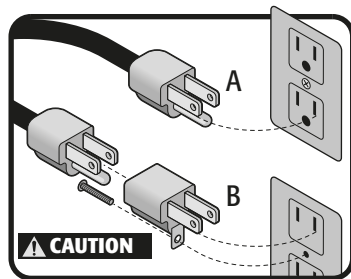
**⚠ WARNING** Before gaining access to the terminals all power sources should be disconnected.



## Power requirements

**⚠ WARNING** To prevent electric shock, the tool shall be grounded while in use. • Connect the plug into a correctly grounded outlet as shown in example A. Not all the outlets are properly grounded. If in doubt, verify with a qualified electrician. • If the outlet where you will connect the tool has two poles (2 orifices). **UNDER ANY CIRCUMSTANCE, DO NOT REMOVE OR ALTER THE PLUG'S GROUND CONNECTOR.** Use a temporary adaptor as shown in example B and always connect the ground conductor lug as shown.

**⚠ CAUTION** When using an extension cable, verify the gauge is enough for the power that the tool needs. A lower gauge cable will cause voltage drop in the line, resulting in power loss and the motor will overheat. The following table shows the right size to use depending on cable's length and the ampere capability shown in the tool's nameplate. When in doubt use the next higher gauge.



Ampere capacity	Number of conductors	Extension gauge	
		From 6 ft to 49 ft	Higher than 49 ft
From 0 A and up to 10 A	3 (one grounded)	18 AWG	16 AWG
From 10 A and up to 13 A		16 AWG	14 AWG
From 13 A and up to 15 A		14 AWG	12 AWG
From 15 A and up to 20 A		8 AWG	6 AWG

\* It is safe to use only if the extensions have a built-in artifact for over current protection.

AWG = American Wire Gauge. Reference: NMX-I-195-ANCE

**⚠ WARNING** When using power tools outdoors use a **VOLTECK** grounded extension cable labeled "Outdoors Use". These extension cables are specially manufactured for outdoors use and reduce the risk of electric shock.





**⚠ WARNING! Read carefully all safety warnings and instructions listed below.** Failure to comply with any of these warnings may result in electric shock, fire and / or severe damage. **Save all warnings and instructions for future references.**

### Work area

**Keep your work area clean, and well lit.**

Cluttered and dark areas may cause accidents.



**Never use the tool in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.**

Sparks generated by power tools may ignite the flammable material.



**Keep children and bystanders at a safe distance while operating the tool.**

Distractions may cause losing control.



### Electrical Safety

**The tool plug must match the power outlet. Never modify the plug in any way. Do not use any adapter plugs with grounded power tools.**

Modified plugs and different power outlets increase the risk of electric shock.



**Avoid body contact with grounded surfaces, such as pipes, radiators, electric ranges and refrigerators.**

The risk of electric shock increases if your body is grounded.

**Do not expose the tool to rain or wet conditions.**

Water entering into the tool increases the risk of electric shock.

**Do not force the cord. Never use the cord to carry, lift or unplug the tool. Keep the cord away from heat, oil, sharp edges or moving parts.**

Damaged or entangled cords increase the risk of electric shock.

**When operating a tool outdoors, use an extension cord suitable for outdoor use.**

Using an adequate outdoor extension cord reduces the risk of electric shock.

**If operating the tool in a damp location cannot be avoided, use a ground fault circuit interrupter (GFCI) protected supply.**

Using a GFCI reduces the risk of electric shock.

### Personal safety

**Stay alert, watch what you are doing and use common sense when operating a tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.**

A moment of distraction while operating the tool may result in personal injury.

**Use personal protective equipment. Always wear eye protection.**

Protective equipment such as safety glasses, anti-dust mask, non-skid shoes, hard hats and hearing protection used in the right conditions significantly reduce personal injury.



**Prevent unintentional starting up. Ensure the switch is in the "OFF" position before connecting into the power source and / or battery as well as when carrying the tool.**

Transporting power tools with the finger on the switch or connecting power tools with the switch in the "ON" position may cause accidents.

**Remove any wrench or vice before turning the power tool on.**

Wrenches or vices left attached to rotating parts of the tool may result in personal injury.

**Do not overreach. Keep proper footing and balance at all times.**

This enables a better control on the tool during unexpected situations.

**Dress properly. Do not wear loose clothing or jewelry. Keep hair, clothes and gloves away from the moving parts.**

Loose clothes, jewelry or long hair may get caught in moving parts.



**If you have dust extraction and recollection devices connected onto the tool, inspect their connections and use them correctly.**

Using these devices reduce dust-related risks.

### Power Tools Use and Care

**Do not force the tool. Use the adequate tool for your application.**

The correct tool delivers a better and safer job at the rate for which it was designed.



**Do not use the tool if the switch is not working properly.**

Any power tool that cannot be turned ON or OFF is dangerous and should be repaired before operating.

**Disconnect the tool from the power source and / or battery before making any adjustments, changing accessories or storing.**

These measures reduce the risk of accidentally starting the tool.

**Store tools out of the reach of children. Do not allow persons that are not familiar with the tool or its instructions to operate the tool.**

Power tools are dangerous in the hands of untrained users.



**Service the tool. Check the mobile parts are not misaligned or stuck. There should not be broken parts or other conditions that may affect its operation. Repair any damage before using the tool.**

Most accidents are caused due to poor maintenance to the tools.



**Keep the cutting accessories sharp and clean.**

Cutting accessories in good working conditions are less likely to bind and are easier to control.

**Use the tool, components and accessories in accordance with these instructions and the projected way to use it for the type of tool when in adequate working conditions.**

Using the tool for applications different from those it was designed for, could result in a hazardous situation.

### Service

**Repair the tool in a TRUPER Authorized Service Center using only identical spare parts.**

This will ensure that the safety of the power tool is maintained.

**Children or people with reduced physical, sensory or mental capabilities shall not operate the tool, neither inexperienced people or without knowledge in the use of the tool, unless supervised by a person responsible of their safety or if receiving previous instructions about the tool operation.**

Children shall be kept under supervision to double-check they will not play with the tool. Tight supervision shall be used with children or disabled persons to prevent from using or being close to any household tool.



This tool is in compliance with the Official Mexican Standard (NOM - Norma Oficial Mexicana).

## Safety warnings for belt sanders

# TRUPER

### Dust and residue caution

**⚠ CAUTION** • Observe applicable regulations while sanding painted surfaces. Take special care with lead paint.

- Remove dust and any other waste material to have a safe working environment. As far as possible, use a vacuum or extractor for dust collection.

**⚠ CAUTION** • All personnel within the working area must wear professional ventilators to protect users against dust and smoke generated while sanding.

- Don't use this machine to sand pieces made of magnesium.

**⚠ CAUTION** • Use TRUPER professional ventilators and cartridges appropriate for working with dust and paint fumes. Ordinary painting masks do not offer this protection.

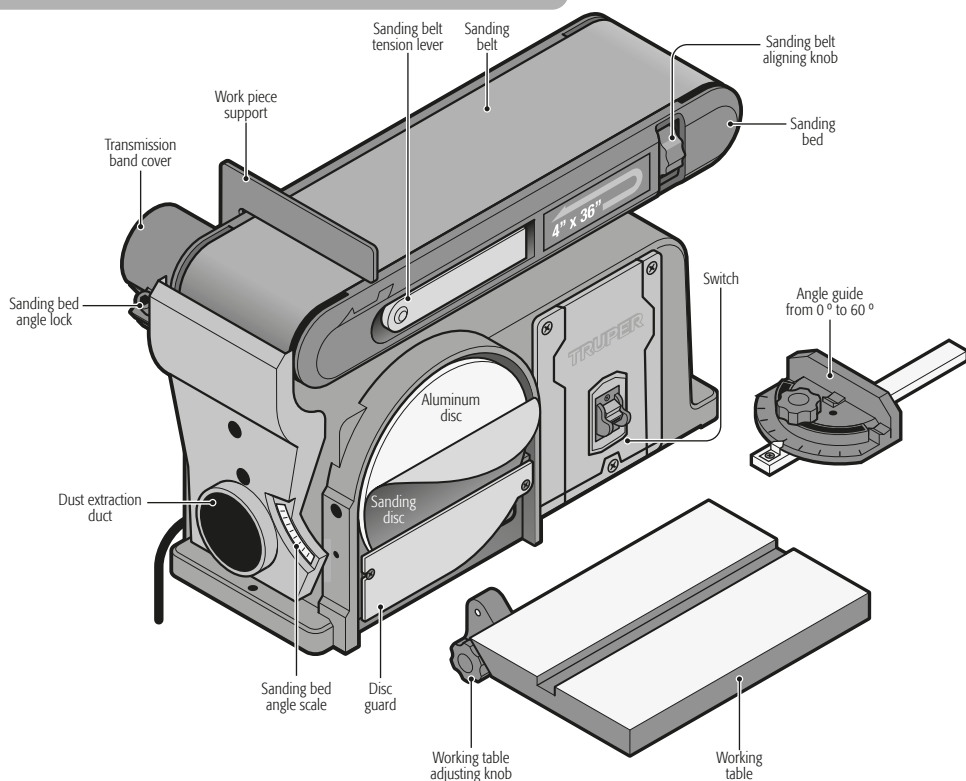
**⚠ WARNING** • Children and pregnant women shall not enter the working area.

### Wear appropriate clothing

**⚠ WARNING** • Wear appropriate clothing. Loose clothes, jewelry or long hair may be snatched by moving parts.



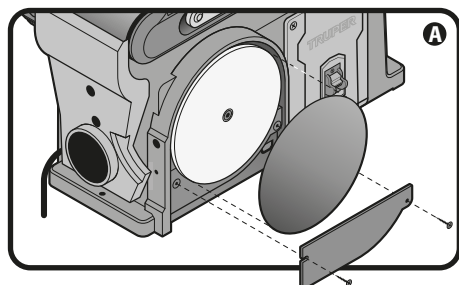
## Parts



- The sander must be fixed to a stable, solid, fixed, flat and leveled working bench before starting up.
- Put the sander on the working bench, in the most appropriate position to work. Consider at least a 12" space of the sanding working table from any wall or obstacle, and in case of working with large pieces, even more, to prevent working pieces to bump and losing control of the tool.
- Mark with a pencil the four mounting holes on top of the working bench.
- Remove the sander from the working bench and drill two 3/8" diameter holes on the marks.
- Fix the sander to the working bench with 5/16" diameter screws, bolts and lock washers (not included). Gradually tighten each screw one by one for perfectly sitting the sander base.

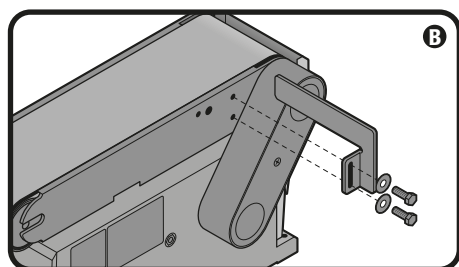
## Sanding disc and guard (A)

- Peel off the disc protection from the auto adhesive sander.
- Align the sanding disc with the aluminum disc and attach pressing firmly.
- Put the disc guard on the bottom of the sanding disc, in order to align the mounting holes and fix with two screws included.



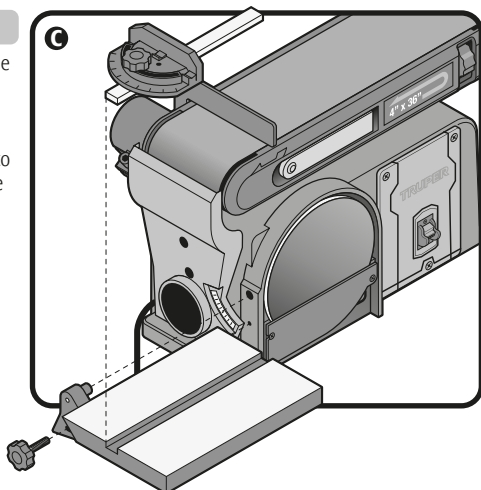
## Working piece support (B)

- Place the working piece support on the sanding band as shown in the graphic and secure it with two sets of screws and bolts included. Do not tighten excessively.



## Working table (C)

- Place the table support on the corresponding hole on the side of the graduated guide.
- Insert the knob through the working table support slot and the threaded hole below.
- Loosen the nuts fixing the working table to the support to adjust, in order to stay perfectly parallel to the disc surface and having a maximum 1/16" space between the disc and the table. Tighten the nuts.
- Insert the mitered guide bar in the working table slot.



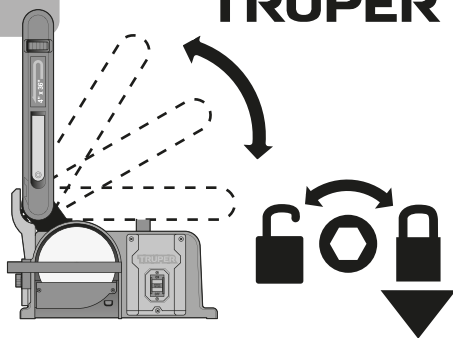
# Assembly

TRUPER

## Sanding base angle adjustment

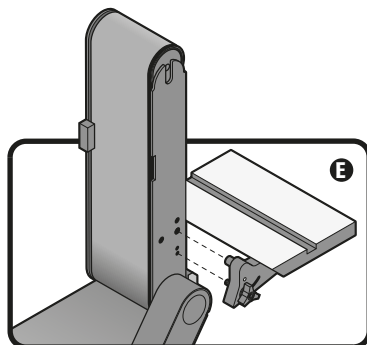
To set the sanding base at a 90° angle (vertical sanding), follow these steps:

- Loosen the angle lock on the sanding base using the included hex wrench by turning it counterclockwise.
- Once the lock is released, raise the sanding base until it reaches the desired angle (maximum 90°).
- Tighten the angle lock clockwise to adjust the sanding base and prevent it from moving during operation.



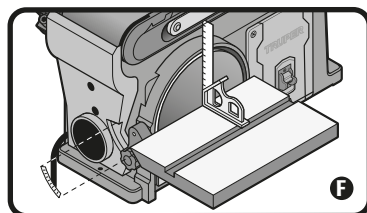
## Working table for vertical sanding (E)

- When the sanding bed is in a vertical position, you can install the working table on it to make the sanding job easier and more accurate.
- Remove the working table from its position to sand with the disc.
- Remove the working piece support (B), to put in its place the table support in the corresponding hole.
- Insert the knob through the table support slot and the threaded hole below.



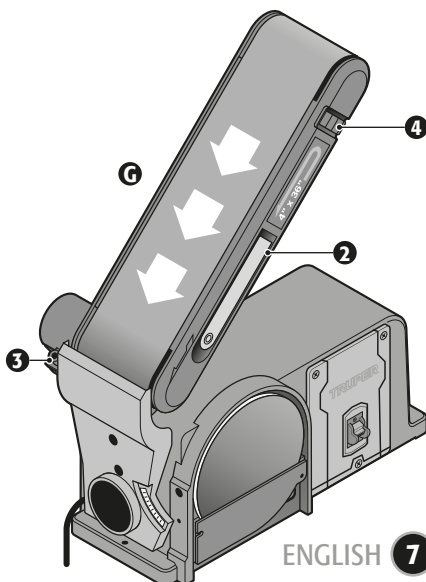
## Adjust the working table (F)

- The working table must be adjusted and calibrated before starting the sanding job.
- Place the combination bracket on the table surface and against the disc to make sure the table is at 0°.
- In case the table is not leveled, loosen the adjusting knob and tilt the table until it sets at 0°.
- Once the table is leveled, tighten the adjusting knob.
- Peel off the self-adhesive graduated guide protection and attach it next to the dust extraction duct, ensuring that the 0 (zero) aligns with the table support pointer.



## Changing the sanding belt (G)

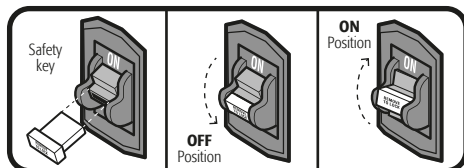
- Turn off and unplug the sander.
- Lift the tension lever (2) to loosen the sanding belt rods and lift the sanding bed to 45°.
- Remove the worn-out sanding belt.
- Place the new sanding belt passing both rods into the belt.
- Make sure the direction arrow is pointing downwards, to the driver rod.
- Center the belt in sanding bed.
- Move the tension lever to the left in order to tighten the belt.
- Tighten the angle lock of the sanding bed (3).
- Connect and turn on for a moment the sander to look thoroughly the belt performance. In case the belt moves out from the sanding bed it should be adjusted.
- If the belt moves towards the disc, turn off the sander and turn the aligning knob (4) 1/4 to the right. Turn on the sander to verify and repeat the operation if necessary until the belt is in its place.
- If the belt moves away from the disc, turn off the sander and turn the aligning knob 1/4 to the left. Turn on the sander in order to verify and repeat the operation if necessary until the belt is in its place.



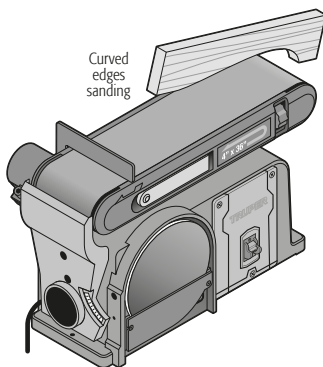
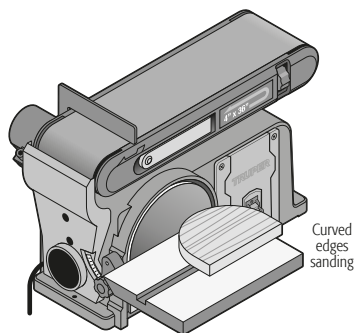
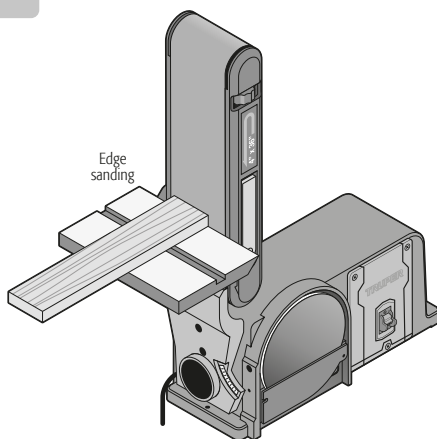
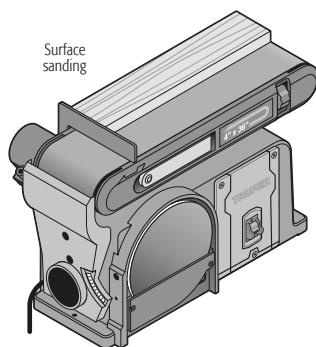
### Turning ON and OFF

- The sander has a locking safety switch to prevent unauthorized use. If you are leaving the machine for a long period of time and there is the possibility untrained personnel would use it, especially children, remove the locking safety key with switch in the **OFF / 0** position. Leave the safety key in a secure place, do not misplace it or you would not be able to operate the sander again.
- To turn on the sander, insert the safety key and move the switch to the **ON / I** position.
- To turn off the sander, move the switch to the **OFF / 0** position.

**⚠ WARNING** • Make sure the switch is in the **OFF / 0** position before connecting the sander to the power supply.



### Sanding procedures





## Cleaning and care

Always keep the motor cover ventilation slots free and clean. After each use apply compressed air. In case of failure only go to a TRUPER Authorized Service Center.

## Lubricating

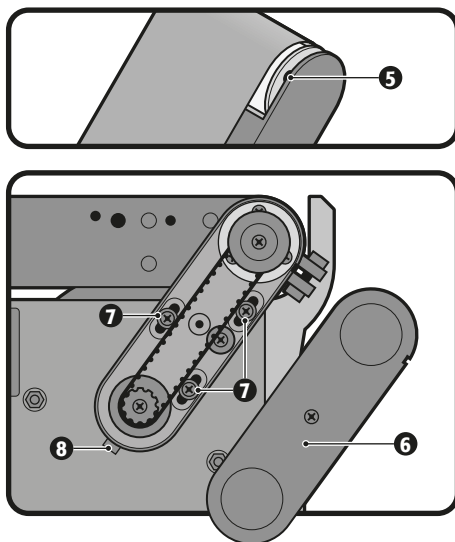
- Lubricate the hubs after every 10 hours of use with 30 degree oil.
- Move the tension lever to the right, slightly move through the sanding belt to the right or left of the free spinning rod to leave the oval lubricating hole exposed (5).
- Apply two or three drops of oil into the lubricating holes in both rods, adjust the belt alignment as described in page 7 (Changing the sanding belt).

## Changing the drive-belt

- With a screwdriver loosen the cover screw from the belt and remove the cover (6).
- Loosen the three screws from the inner cover to bring together both shafts (7).
- Place the belt around the shafts.
- Slightly tighten the three screws of the inner cover.
- Adjust the tension of the drive-belt placing a flat screwdriver in the adjusting hole (8), pushing the screwdriver to apply tension to the drive-belt.
- Firmly tighten the three screws in the inner cover.
- Hold the drive-belt with two fingers on the center outer part and press. It should give in approximately 1/4" for the drive-belt to have the correct tension.

**CAUTION** • Excessive tension on the drive-belt can force the motor and cause damage. If the drive-belt is loose, it can prematurely fail.

- Put the belt cover back in place.



# Troubleshooting

## Problem

## Cause

## Solution

The machine does not work when it is turned on.

- No power supply.
- The power cord is defective, motor or wiring problem.

- Check the cord for any breakage.
- Consult an TRUPER authorized service center for repair.

The motor runs slowly when sanding.

- The drive belt is too tight.
- Too much pressure is being applied to the workpiece.

- Loosen the drive belt.
- Apply less pressure to the workpiece.

The sanding belt runs out of the rollers.

- Misaligned Band.

- Align the belt (see page 7 changing the sanding belt).

Wood burns when sanding.

- The disc or sanding belt have accumulated debris.

- Clean or replace the disc or sanding belt.

The sander makes excessive noise.

- The drive belt is too tight.
- The bearings need lubrication.

- Loosen the drive belt.
- Lubricate the sanding bed rollers.



In the event of any problem contacting a TRUPER Authorized Service Center, please see our webpage [WWW.TRUPER.COM](http://WWW.TRUPER.COM) to get an updated list, or call our toll-free numbers 800 690-6990 or 800-018-7873 to get information about the nearest Service Center.

**AGUASCALIENTES** **DE TODO PARA LA CONSTRUCCIÓN**  
GRAL. BARRAGÁN #1201, COL. GREMIAL, C.P. 20030,  
AGUASCALIENTES, AGS. TEL.: 449 994 0537

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AV. LA ENCANTADA, LOTE #5, PARQUE INDUSTRIAL EL  
FLORIDO II, C.P. 22244, TIJUANA, B.C.  
TEL.: 664 969 5100

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TEL.: 613 132 1115

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C.P. 24080 CAMPECHE, CAMP. TEL.: 981 815 2808

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TAPACHULA, CHIS. TEL.: 962 118 4083

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**COLIMA** **BOMBAS Y MOTORES BYMTESA DE MANZANILLO**  
BLVD. MIGUEL DE LA MADRID #190, COL. 16 DE  
SEPTIEMBRE, C.P. 28239, MANZANILLO, COL.  
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JILOTEPEC, JILOTEPEC, EDO. DE MÉX. C.P. 54257  
TEL.: 761 782 9101 EXT. 5728 Y 5102

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CELAYA, GTO. TEL.: 461 617 7578 / 79 / 80 / 88

**GUERRERO** **CENTRO DE SERVICIO ECLIPSE**  
CALLE PRINCIPAL MZ 1 LT. 1, COL. SANTA FE, C.P. 39010,  
CHILPANCIÑO, GRO. TEL.: 747 478 5793

**HIDALGO** **FERREPRECIOS S.A. DE C.V.**  
LIBERTAD ORIENTE #304 LOCAL 50, INTERIOR DE PASAJE  
ROBLEDO, COL. CENTRO, C.P. 43600, TULANCINGO,  
HGO. TEL.: 775 753 6615 / 775 753 6616

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AV. ADOLFO B. HORN # 6800, COL. SANTA CRUZ DEL  
VALLE, C.P.: 45655, TLAJOMULCO DE ZUÑIGA, JAL.  
TEL.: 33 3606 5285 AL 90

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EX-HACIENDA DE LA HUERTA, C.P. 58050, MORELIA,  
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**NAYARIT** **HERRAMIENTAS DE TEPIC**  
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TEL.: 311 258 0540

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TAMS. TEL.: 899 926 7552

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PRIMAVERA C.P. 93308, POZA RICA, VER.  
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MPIO. UMAN, C.P. 97390, MÉRIDA, YUC.  
TEL.: 999 912 2451

Code	Model	Brand
12110	PUL-4X6T	TRUPER

Warranty. Duration: 1 year. Coverage: parts, components and workmanship against manufacturing or operating defects, except if used under conditions other than normal; when it was not operated in accordance with the instructive; was altered or repaired by personnel not authorized by TRUPER®. To make the warranty valid, present the product, stamped policy or invoice or receipt or voucher, in the establishment where you bought it or in Corregidora 35, Centro, Cuauhtémoc, CDMX, 06060, where you can also purchase parts, components, consumables and accessories. It includes the costs of transportation of the product that derive from its fulfillment of its service network. Phone number 800-018-7873. Made in China. Imported by TRUPER, S.A. de C.V. Parque Industrial 1, Parque Industrial Jilotepec, Jilotepec, Edo. de Méx. C.P. 54257, Phone number 761 782 9100.



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