

# “Swirl-Free Checklist”

## For Dynabrade Random Orbital Sanders

### Equipment Check:

#### Random Orbital Sander

- 90 PSIG (6.2 Bar) is the required operating air supply pressure.** Check the air pressure at the sander while it is running. Note: Promote the use of Dynabrade maximum flow plugs and couplers to ensure proper airflow.
- Confirm that the tool is running at the rated “Free Speed” RPM.** On an average a 10,000 RPM non-vacuum sander will run at 9,500 RPM; a 12,000 RPM non-vacuum sander will run at 11,500 RPM. A vacuum sander normally runs slightly slower.
- Inspect the balancer bearing (pad bearing).** Remove the back-up pad and rotate the balancer bearing shaft while holding the counterbalance stationary. The balancer shaft should turn freely.



#### Back-Up Pad

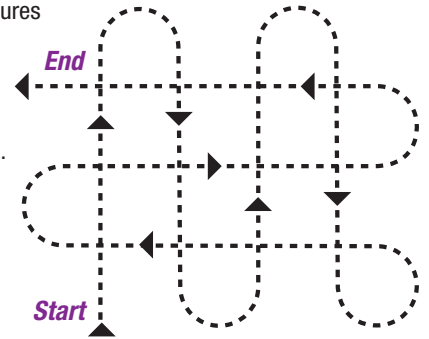
- Inspect the face of the sanding pad.** The pad must be flat and smooth, without any defects. Check if they are using a Dynabrade back-up pad that is “weight-mated” to the sander. Using another pad can make the sander vibrate excessively and lead to an unacceptable finish.

### Sanding Techniques:

- Always START the sander ON the surface, and STOP the sander OFF the surface.**
- When sanding keep the sander, and pad FLAT on the surface.** **Important:** Do not exert heavy downward force on the sander. Apply enough downward force to keep the back-up pad and abrasive flat on the surface allowing the back-up pad to orbit freely over the surface.

### Sanding Techniques (Continued)

- Follow a set pattern when sanding.** It is suggested to pass over the surface following a “North, South, East, West” pattern (see below), overlapping each pass 1/4 the diameter of the back-up pad and abrasive. This insures that the previous scratches are removed and that a uniform finish is achieved. Two “patterns” per sanding step are recommended.



- Frequently inspect abrasive for tears, folds, or build-up.** When changing abrasive to proceed to the next sanding step, first inspect the condition of the abrasive that is on the sander. If any defects are noticed in that abrasive, remove it and install another piece of the same grain and sand the work surface again before proceeding on to the next sanding step.
- Always clear away sanding dust and abrasive debris before progressing to the next sanding step with a finer “grit” abrasive.**

## Two-Hand Dynorbital® Air-Powered Random Orbital Sander



**SANDING PADS**  
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**ACCESSORIES**  
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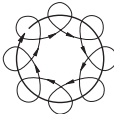
*For Comfortable, Controlled Two-Hand Operation*

**FOR ABRASIVE DISCS**  
5" (127 mm) diameter  
SEE PAGE 275

#### Model 57101 Low Profile Model

- Unique low profile two-hand model is weight-mated to 5" diameter sanding pad.
- 56106 Non-Vacuum, vinyl-face pad included.
- Also includes convenient 97166 Hanger.
- A versatile, lightweight two-hand random orbital sander.



 **3/16"**  
**(5 mm)**  
**Dia. Orbit**  
*For General Sanding*

Model  
57101

Model Number	Motor hp (W)	Motor RPM	Orbit Dia. Inch (mm)	Pad Dia. Inch (mm)	Sound Level	Maximum Air Flow SCFM (L/Min)	Hose I.D. Size Inch (mm)	Air Inlet Thread	Weight Pound (kg)	Length Inch (mm)	Height Inch (mm)
57101	.2 (149)	12,000	3/16 (5)	5 (127)	76 d(B)A	28 (793)	3/8 (10)	1/4" NPT	2.1 (.98)	8-5/16 (211)	3-3/4 (96)

**Tune-Up Kit: No. 96537** (page 267) • Additional Specifications: Air Pressure 90 PSIG (6.2 Bar)