

**A Helping Hand**  
 **RPM & Feed Speed Recommendations**

Wheels sand best when run between 600 rpms and 1200 rpms, with 600 rpms the BEST STARTING POINT. However, 1200 rpms is quite acceptable for these wheels.

**FEED SPEEDS:** on the double-end tenoners can vary according to whether you are sanding WITH the grain or ACROSS the grain or outside profiles or raised panels.

**YIELD:** 30,000 lineal feet average max.

OUTSIDE EDGES	50 FPM (feet per minute) with grain	35 FPM across grain
RAISED PANELS	44 FPM with grain	28 FPM across grain



*Profile Sanding Made Easy!*

*The feel of a solid wheel with qualities of non-woven flapwheels*

**Note:** 2" DEBB wheels can be flipped over for 2nd sanding pattern to maximum use.

**Machine, Grit, RPM and Forming Recommendations:**

- Use of a variable speed shaper and power feeder is highly recommended.
- 600 to 1200 RPM Max. (higher RPM will may be ineffective.)
- Use a medium grit wheel to achieve a 120 to 150 grit end finish result.
- Use a fine grit wheel to achieve a 180 to 220 grit end finish result.
- To form your DEBB wheel, glue 60 grit cloth-backed flexible sandpaper to your moulding and burn-in your profile. We suggest you burn in at lower speeds.

**DEBB WHEELS USAGE RECOMMENDATIONS**

*Single sanding station tenenor, or a vertical spindle sander (i.e. Whirlwind, Larick, Unique, etc.)*

- Use a MEDIUM grit DEBB wheel.
- Tilting the wheel at a 45 degree angle to the part is ideal if your machinery allows for it. This will allow you to attack the board coming IN from the side, as well as, coming DOWN on the board. You will be using both the side of the wheel and the outside edge.

*Two station sanding tenenor*

- The first station should have a MEDIUM grit DEBB wheel rotating the wheel INTO the direction of the feed.
- The second station should have a FINE grit DEBB wheel rotating WITH the direction of feed.

**NOTE:** For consistent finish on verticle spindle sanders, it would be best to have a power feeder for consistent feed speed and pressure.

**NEW! - Bardo Impregnated Flapwheels**

- Fast “burn” in, or take shape to the moulding being sanded.
- Incredibly wide variety of options.

General rules:

- Aluminum Oxide is the grain to use when looking for sanding action on raw board
  - Silicon Carbide is the grain to use for finishing and after sealer, stain or primer.
- There are exceptions, but this is a good GENERAL rule of thumb. You will find that these wheels have the feel of a solid wheel, yet posses the qualities of a conformable non-woven abrasive flapwheel!

Based on the type of board you are sanding, what type of sanding you are doing and the degree of sanding to be done, in the standard 8” OD x 3” ID in a variety of width sizes you may choose:

**D Treat Recommendations:**

- Use after stain, sealer or primer has been applied to MDF or natural wood!
- Several large bass shutter & louver, as well as moulding manufacturers – use 8” OD x 3” ID in a variety of widths Green VFN HD D Trt. and Silicon Carbide Very Fine MD D Trt. for both light sand on raw and seal sand.
- Green Very Fine or Silicon Carbide Very Fine

**C6 Treat Recommendations:**

- Aggressive wheel – ideal for scuffing a hard coat of UV on MDF between coats.
- Large MDF moulding manufacturer uses a variety of these wheels on raw MDF for presand prior to white primer. They use Alox FN HD C6 Trt. or Alox VFN MD C6 Trt., according to the condition of the surface. Alox Med HD C6 Trt. in 8” OD x 3/4” wide x 3” ID is used on the sides of the mouldings successfully.
- Aluminum Oxide Very Fine, Fine or Medium
- Silicon Carbide Fine or Medium

Bardo can create a wheel to meet special applications.

Due of the large number of applications this product can be used for, we recommend that you call one of our Wood Tech’s technical specialists to help match the product to your usage.

