



## SuperMax 19-38 Combo VFD (ME300) Instructions

All parameters and functions for the VFD (ME300) have been programmed for the 19-38 Combo sander at the factory.



To turn "ON" the machine (drum or brush): Pull "ON" the safety paddle switch equipped on the conveyor control box to run drum or brush. The "RUN" button on the control panel of VFD is NOT programmed and does not control any functions.

To turn "OFF" the machine (drum or brush): Either push OFF the safety paddle switch equipped on the conveyor control box or press the "STOP" button on the control panel of VFD to stop the drum or brush.

For increasing or decreasing the drum or the brush speed (RPM): Turn the speed knob on the upper right of the VFD control panel clockwise to increase the speed or counterclockwise to decrease the speed.

## **Important, RPM settings:**

**Drum sanding** should always be set at the fastest RPM (maximum speed), approximately **1700-1800 RPM**.

**Brush sanding**, bristle brushes, (wire & nylon), should be set between **200-600 RPM**, never exceed **800 RPM**.

**Flatter brush** (abrasive fingers) sanding should be set between **100-400 RPM**.

Digital screen on control panel of VFD: Displays speed (RPM) of drum or brush. It displays three digits for the speed (RPM). For speed at 1,000 RPM and over, it will display PXXX.

For example: The display will show **100"P"** for **1,000** RPM. It will show **170"P"** for **1,700** RPM.

Pressing the "MODE" button on the control panel of VFD: The digital screen will change the display between; speed/RPM (P), amperage (A), forward (Frd), frequency (FXX.X) and actual output frequency (HXX.X) by repeatedly pressing the MODE button on the control panel of VFD.

To reset, if a fault code appears, press the "STOP/ RESET" button on the control panel of VFD for resetting. The remaining buttons do not have a control or function.

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