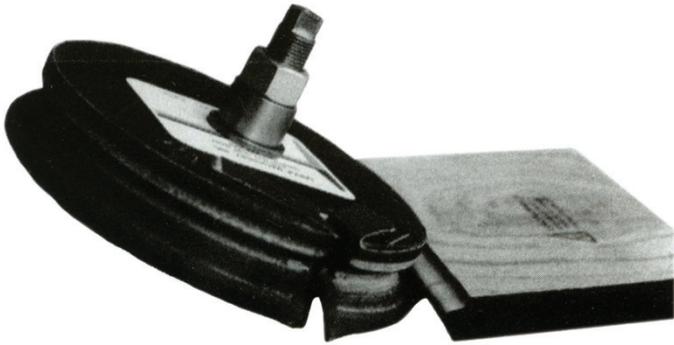


# LARICK

## PROFILE SANDING WHEELS

### UTILIZING REPLACEABLE ABRASIVE TO MATCH YOUR DISTINCTIVE PROFILE

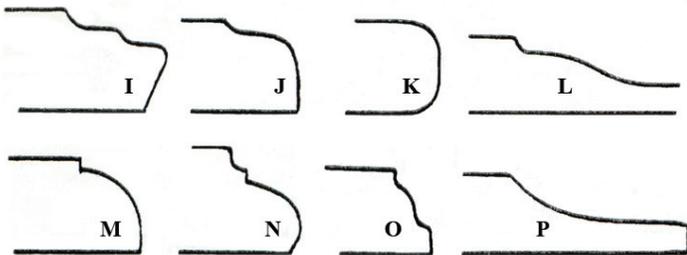
LARICK uses SIA AMERICA's patented "siafast" abrasive on their profile sanding wheels. The primary advantage of this abrasive is its ability to STRETCH! This stretch allows the abrasive to conform to a mildly contoured profile wheel. Its velcro-type backing makes changing abrasive fast, clean, and easy. Simply pull the worn abrasive off and stretch a new piece onto the wheel. Successful applications include details on cabinet door and drawer front edges, crowned panels for doors, moldings, etc. Larick's wheels are made to match your profile, are aggressive, and keep their shape.



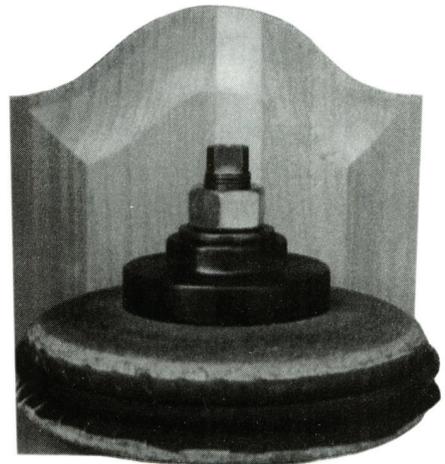
**DOOR OR DRAWER EDGE SANDING**



**SANDING BULLNOSED PARTS**



**TYPICAL PROFILES**



**CROWNED RAISED PANEL SANDING**



**LARICK MACHINERY, INC.**

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**USER FRIENDLY MACHINERY**

INNOVATIVE LEADER IN  
PROFILE SHAPING & SANDING

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# LARICK PROFILE SANDING WHEELS

Larick's profiled sanding wheels are one of the most aggressive available. They are formed to match a profile and do not distort or 'round them over'. There is a small amount of 'cushioning' built in to compensate for slight misalignment or movement of the profile due to inconsistencies in shaping or feeding. Normally, about 0003" to 0.005" is removed during sanding, which just removes a pencil mark. Abrasive cost is low, and averages about a penny per part sanded for kitchen cabinet doors. What enables this system to work is the ability of the abrasive to stretch. This stretch allows the sandpaper to conform to a profile as it is stretched onto a profiled wheel.

Raised panel wheels are normally made to use with a rub collar with the edge of the panel touching this collar. A consistent depth of cut from the outside edge is required when using a rub collar. Profiles similar to 'L' and 'P' work well. If the panel profile has a step or bead at the tip of the cutter, Larick will not be able to sand the entire profile, but can normally sand from the step or bead to the outside edge.

## Limitations with this system:

- a. The smallest cove that can be sanded is  $\frac{5}{32}$  inch.
- b. We cannot go into and out of a square inside corner. Therefore, we must skip any steps (as shown on profile 'M'). Normally, sanding will start within  $\frac{1}{16}$ " of the corner and will sand the remainder of the profile.
- c. 'Stepped' profiles like 'I' require extra care in installing abrasive.
- d. Some profiles ('N' and 'O') utilize two strips of abrasive. On 'N', one strip does the cove, one does the roundover, and the step skipped. For 'O', one strip does the wavy profile, and a second strip butts up to it to sand the lower flat, keeping the corner sharp.
- e. This abrasive will not come 'straight out' on the wheel, so we give a 15° relief angle on the top and bottom of profiles similar to 'K'.
- f. The deepest that a profile can be in the sanding wheel is  $\frac{3}{4}$ ". A deeper profile can be sanded by tilting the wheel. Reasons to tilt are to minimize the depth of cut into the sanding wheel and to keep the abrasive as flat as possible on the wheel. This makes changing of the abrasive easier and gives prolonged sandpaper life.

## Information required before manufacturing a sanding wheel:

1. Bore size —  $\frac{3}{4}$ ", 1",  $1\frac{1}{4}$ ", and 40mm are standard.
2. Tilt for edge wheels. Tell us if your sander spindle can tilt.
3. Rub collar/bearing diameter for panel wheels.
4. O.D. or minor diameter. If not specified, Larick's edge wheels are about 8" O.D.
5. Grit of abrasive desired. P100, P120, P150, and P180 are available.
6. We need an unsanded part to use as a template and like to have some endgrain. Shape all 4 sides of a small part and send to Larick. We will use part for a template and can test the wheel on the remainder.

**Edges** should be sanded with the reference side down — if profiled on a shaper or router table face up, the back is the reference side. If profiled with a router on the top, the top is the reference side. **Panels** work best face down when hand feeding. This allows the operator to make multiple passes without re-adjusting to sand end grain or remove defects.

A drawing or tracing of the profile can be faxed to Larick for a free feasibility review.

A CD giving tips on abrasive installation is available upon request.

**SAND FOR A PENNY PER PART WITH LARICK!**



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