



OPERATOR'S MANUAL



Cat. No.
6065, 6065-6, 6066, 6066-6, 6072, 6078

SANDERS



WARNING To reduce the risk of injury, user must read and understand operator's manual.

GENERAL POWER TOOL SAFETY WARNINGS

⚠WARNING Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, and/or serious injury. **Save all warnings and instructions for future reference.** The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

WORK AREA SAFETY

- **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

ELECTRICAL SAFETY

- **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unplugs and matching outlets will reduce risk of electric shock.
- **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.
- **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- **If operating a power tool in a damp location is unavoidable, use a ground fault circuit interrupter (GFCI) protected supply.** Use of an GFCI reduces the risk of electric shock.

PERSONAL SAFETY

- **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- **Use personal protective equipment. Always wear eye protection.** Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your hand on the switch or energizing power tools that have the switch on invites accidents.
- **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.

- **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- **Dress properly. Do not wear loose clothing or jewelry. Keep your hair and clothing away from moving parts.** Loose clothes, jewelry or long hair can be caught in moving parts.
- **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related hazards.
- **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.

POWER TOOL USE AND CARE

- **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- **Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- **Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations from those intended could result in a hazardous situation.
- **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

SERVICE

- **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This will ensure that the safety of the power tool is maintained.

SPECIFIC SAFETY RULES FOR SANDERS

- Safety Warnings Common for Sanding Operations:
- **This power tool is intended to function as a sander. Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in personal injury.**
 - **Operations such as grinding, wire brushing, polishing or cutting-off are not recommended to be performed with this power tool.** Operations for

which the power tool was not designed may create a hazard and cause personal injury.

- **Do not use accessories which are not specifically designed and recommended by the tool manufacturer.** Just because the accessory can be attached to your power tool, it does not assure safe operation.
- **The rated speed of the accessory must be at least equal to the maximum speed marked on the power tool.** Accessories running faster than their rated speed

- **The outside diameter and the thickness of your accessory must be within the capacity rating of your power tool.** Incorrectly sized accessories cannot be adequately guarded or controlled.

- **Threaded mounting of accessories must match the grinder spindle thread. For accessories mounted by flanges, the arbour hole of the accessory must fit the locating diameter of the flange.** Accessories that do not match the mounting hardware of the power tool will run out of balance, vibrate excessively and may cause loss of control.

- **Do not use a damaged accessory. Before each use inspect the accessory such as abrasive wheels for chips and cracks, backing pad for cracks, tear or excess wear, wire brush for loose or cracked wires.** If power tool or accessory is dropped, inspect for damage or install an undamaged accessory. After inspecting and installing an accessory, position yourself and bystanders away from the plane of the rotating accessory and run the power tool at maximum no-load speed for one minute. Damaged accessories will normally break apart during this test time.

- **Wear personal protective equipment. Depending on application, use face shield, safety goggles or safety glasses. As appropriate, wear dust mask, hearing protectors, gloves and workshop apron capable of stopping small abrasive or workpiece fragments.** The eye protection must be capable of stopping debris generated by various operations. The dust mask or respirator must be capable of filtering particles generated by your operation. Prolonged exposure to high intensity noise may cause hearing loss.

- **Keep bystanders a safe distance away from work area. Anyone entering the work area must wear personal protective equipment.** Fragments of workpiece or of a broken accessory may fly away and cause injury beyond immediate area of operation.

- **Hold the power tool by insulated gripping surfaces only, when performing an operation where the cutting tool may contact hidden wiring or its own cord.** Contact with a "live" wire may also make exposed metal parts of the power tool "live" and could give the operator an electric shock.

- **Position the cord clear of the spinning accessory.** If you lose control, the cord may be cut or snagged and your hand or arm may be pulled into the spinning accessory.

- **Never lay the power tool down until the accessory has come to a complete stop.** The spinning accessory may grab the surface and pull the power tool out of your control.

- **Do not run the power tool while carrying it at your side.** Accidental contact with the spinning accessory could snag your clothing, pulling the accessory into your body.

- **Regularly clean the power tool's air vents.** The motor's fan will draw the dust inside the housing and excessive accumulation of powdered metal may cause electrical hazards.

- **Do not operate the power tool near flammable materials.** Sparks could ignite these materials.

- **Do not use accessories that require liquid coolants.** Using water or other liquid coolants may result in electrocution or shock.

Kickback and Related Warnings

Kickback is a sudden reaction to a pinched or snagged rotating wheel, backing pad, brush or any other accessory. Pinching or snagging causes rapid stalling of the rotating accessory which in turn causes the uncontrolled power tool to be forced in the direction opposite of the accessory's rotation at the point of the binding. For example, if an abrasive wheel is snagged or pinched by the workpiece, the edge of the wheel that is entering into the pinch point can dig into the surface of the material causing the wheel to climb out or kick out. The wheel may either jump toward or away from the operator, depending on direction of the wheel's movement at the point of pinching. Abrasive wheels may also break under these conditions.

Kickback is the result of power tool misuse and/or incorrect operating procedures or conditions and can be avoided by taking proper precautions as given below.

- **Maintain a firm grip on the power tool and position your body and arm to allow you to resist kickback forces. Always use auxiliary handle, if provided, for maximum control over kickback or torque reaction during start-up.** The operator can control torque reactions or kickback forces, if proper precautions are taken.

- **Never place your hand near the rotating accessory.** Accessory may kickback over your hand.

- **Do not position your body in the area where power tool will move if kickback occurs.** Kickback will propel the tool in direction opposite to the wheel's movement at the point of snagging.

- **Use special care when working corners, sharp edges etc. Avoid bouncing and snagging the accessory.** Corners, sharp edges or bouncing have a tendency to snag the rotating accessory and cause loss of control or kickback.

- **Do not attach a saw chain woodcarving blade or toothed saw blade.** Such blades create frequent kickback and loss of control.

Safety Warnings Specific for Sanding Operations:

- **Do not use excessively oversized sanding disc paper. Follow manufacturers recommendations, when selecting sanding paper.** Larger sanding paper extending beyond the sanding pad presents a laceration hazard and may cause snagging, tearing of the disc or kickback.

Additional Safety Warnings

- **Maintain labels and nameplates.** These carry important information. If unreadable or missing, contact a MILWAUKEE service facility for a free replacement.

- **⚠WARNING** Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead-based paint
- crystalline silica from bricks and cement and other masonry products, and

- arsenic and chromium from chemically-treated lumber. Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to

GROUNDING

⚠WARNING Improperly connecting the grounding wire can result in the risk of electric shock. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with the tool. Never remove the grounding prong from the plug. Do not use the tool if the cord or plug is damaged. If damaged, have it repaired by a MILWAUKEE service facility before use. If the plug will not fit the outlet, have a proper outlet installed by a qualified electrician.

Grounded Tools (Three-Prong Plugs)

Tools marked "Grounding Required" have a three wire cord and three prong grounding plug. The plug must be connected to a properly grounded outlet (See Figure A). If the tool should electrically malfunction or break down, grounding provides a low resistance path to carry electricity away from the user, reducing the risk of electric shock.

The grounding prong in the plug is connected through the green wire inside the cord to the grounding system in the tool. The green wire in the cord must be the only wire connected to the tool's grounding system and must never be attached to an electrically "live" terminal.

Your tool must be plugged into an appropriate outlet, properly installed and grounded in accordance with all codes and ordinances. The plug and outlet should look like those in Figure A.

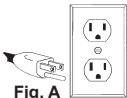


Fig. A

Double Insulated Tools (Two-Prong Plugs)

Tools marked "Double Insulated" do not require grounding. They have a special double insulation system which satisfies OSHA requirements and complies with the applicable standards of Underwriters Laboratories, Inc., the Canadian Standard Association and the National Electrical Code. Double Insulated tools may be used in either of the 120 volt outlets shown in Figures B and C.

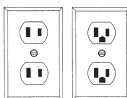


Fig. B

Fig. C

EXTENSION CORDS

Grounded tools require a three wire extension cord. Double insulated tools can use either a two or three wire extension cord. As the distance from the supply outlet increases, you must use a heavier gauge extension cord. Using extension cords with inadequately sized wire causes a serious drop in voltage, resulting in loss of power and possible tool damage. Refer to the table shown to determine the required minimum wire size.

The smaller the gauge number of the wire, the greater the capacity of the cord. For example, a 14 gauge cord can carry a higher current than a 16 gauge cord. When using more than one extension cord to make up the total length, be sure each cord contains at least the minimum wire size required. If you are using one extension cord for more than one tool, add the nameplate amperes and use the sum to determine the required minimum wire size.

Guidelines for Using Extension Cords

- If you are using an extension cord outdoors, be sure it is marked with the "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.
- Be sure your extension cord is properly wired and in good electrical condition. Always replace a damaged extension cord or have it repaired by a person before using it.
- Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

Recommended Minimum Wire Gauge For Extension Cords*

Nameplate Amps	Extension Cord Length				
	25'	50'	75'	100'	150'
0 - 2.0	18	18	18	18	16
2.1 - 3.4	18	18	18	16	14
3.5 - 5.0	18	18	16	14	12
5.1 - 7.0	18	16	14	12	12
7.1 - 12.0	16	14	12	10	--
12.1 - 16.0	14	12	10	--	--
16.1 - 20.0	12	10	--	--	--

* Based on limiting the line voltage drop to _____ volts at 150% of the rated amperes.

SPECIFICATIONS

Spindle Size.....	5/8"-11"
Max Capacity.....	7"/9"x1/4"
Cat. No.	6065 and 6065-6
Volts.....	120 AC/DC
Amps.....	15
No Load RPM.....	6000
Cat. No.	6066 and 6066-6
Volts.....	120 AC/DC
Amps.....	15
No Load RPM.....	6600
Cat. No.	6072
Volts.....	120 AC/DC
Amps.....	13
No Load RPM.....	6000
Cat. No.	6078
Volts.....	120 AC
Amps.....	13
No Load RPM.....	0 - 6600

SYMBOLGY



Double Insulated



Volts



Alternating Current



Alternating Current/Direct Current



Amps

n XXXX min⁻¹ Rated Revolutions per Minute (RPM)

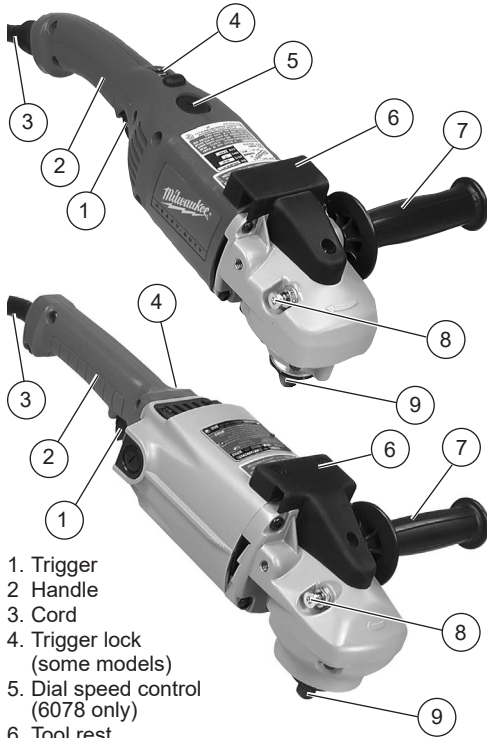


UL Listing Mark for Canada and U.S.



Approval Mark for Mexico

FUNCTIONAL DESCRIPTION



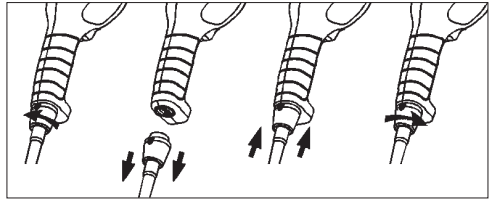
1. Trigger
2. Handle
3. Cord
4. Trigger lock (some models)
5. Dial speed control (6078 only)
6. Tool rest
7. Side handle
8. Spindle lock button
9. Spindle

ASSEMBLY

⚠WARNING To reduce the risk of injury, always unplug tool before changing or removing accessories.

Removing and Replacing Quik-Lok® Cords (Select Models)

MILWAUKEE's exclusive Quik-Lok® Cords provide



1. To remove the Quik-Lok® Cord, turn the cord nut 1/4 turn to the left and pull it out.
2. To replace the Quik-Lok® Cord, align the connector keyways and push the connector in as far as it will go. Turn the cord nut 1/4 turn to the right to lock.

⚠WARNING To reduce the risk of injury, always use a side handle when using this tool. Hold securely.

Installing Side Handle

The side handle may be installed on either side of the gear case. Position the side handle in the location which best control and guard protection. To install, thread side handle into side handle socket and tighten securely.

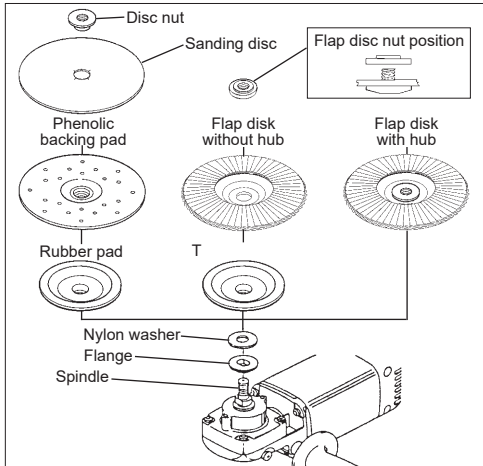
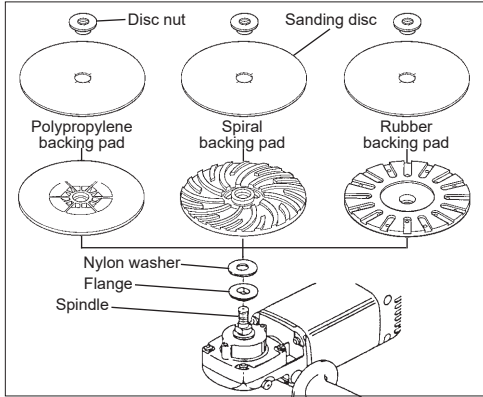
Sanding Disc Selection

Use sanding discs and accessories that are:

- correct size as written on tool's nameplate.
- rated at or above the RPM listed on the tool's nameplate.
- correct accessory, wheel type and grit for the job. Select the correct type of sanding disc for your job. Generally, use 24 or 36 grit for heavy stock removal; 50, 60, or 80 grit for medium stock removal and 120 grit for Always begin with a coarse grit, using successively grits to obtain the desired
- Aluminum Oxide:** For fast cutting, general purpose discs for most metal jobs. Best for cold-rolled steel, stainless steel or metals requiring tough, fast cutting, long lasting abrasives.
- Aluminum Zirconia Bi-Cut:** Unique grit pattern is arranged in clusters for faster stock removal and cleaning. Ideal for removing paint from cars, boats, etc. without clogging.
- Ceramic:** Lasts up to 3 times longer than Aluminum Oxide Discs. For general metal working. Ideal for tough jobs.

Installing Backing Pad and Sanding Discs

1. Unplug tool and place it upside down on a level surface as shown. **WARNING!** Always unplug tool before changing or removing accessories. Remove any accessories from spindle.
2. Thread _____ and nylon washer onto spindle. Attach backing pad and sanding disc as shown. **NOTE:** When installing _____ disc without hub, posi-
3. To tighten, press in the spindle lock button while turning disc nut clockwise.
4. To remove sanding disc and backing pad, unplug tool and reverse procedure.



OPERATION

WARNING! To reduce the risk of injury, always wear safety goggles or glasses with side shields. Never grind without proper safety equipment.

Starting and Stopping the Motor

1. To start the tool, pull the trigger.
2. To stop the tool, release the trigger.

WARNING! Always hold the tool firmly with both hands using the handles provided before and during use.

To reduce the risk of injury or damage to the tool, do not use the spindle lock button to stop the spindle while the tool is in use or is coasting after shut-off.

Locking the Trigger (Select Models)

The lock button holds the trigger in the ON position for continuous use.

1. To lock the trigger on, hold in the lock-on button while pulling the trigger. Release the trigger.
2. To unlock the trigger, pull the trigger and release. The lock-on button will pop out.

Using the Dial Speed Control (Cat. No. 6078 only)

Cat. No. 6078 has a dial speed control and variable speed trigger switch. The maximum speed may be preset using the speed control dial and the speed may be varied by the trigger switch. Speed control dial settings range from 1 to 5. Lower numbers correspond to lower speeds and higher numbers correspond to higher speeds. Use the setting that best suits the work.

To control the speed, set the dial to the desired number. Then, pull the trigger. Increase or decrease pressure on the trigger to vary the speed. To stop the tool, release the trigger.

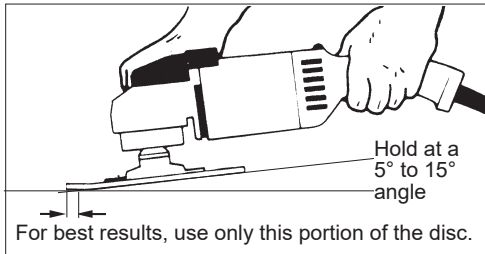
General Operation

1. If you have just installed an accessory or are beginning a period of work, test the wheel by letting it spin for one minute before applying it to the workpiece. **WARNING!** Never use a grinding wheel that has been dropped. Out-of-balance or damaged accessories can mar workpiece, damage the tool, and cause stress that may cause accessory failure.
2. Use a clamp, vise or other practical means to hold your work, freeing both hands to control the tool.
3. **WARNING!** Hold tool securely with both hands. Start the tool.
4. Allow accessory to come to full speed before beginning work.
5. Control pressure and surface contact between accessory and workpiece. **WARNING!** Never bang grinding wheel onto work. Too much pressure causes accessory failure or slows speed.
6. When _____ turn the tool and make sure it comes to a complete stop before laying it down.

Using Sanding Discs

Hold tool at 5° to 15° angle to ensure proper sanding pressure and control. Too great an angle will result in too much pressure and could cause excessive wear to the disc and workpiece. Too small an angle will reduce control.

Use long, sweeping, side to side strokes, advancing



Cross Sanding - When a surface that has been prepared by a coarse disc or wheel, sand at right angles to the strokes made by the coarser disc. Finishing marks left from previous sanding are easily seen and removed for a uniform surface. Failure to cross sand when changing from a coarse disc to a finer disc may result in deep scratches and circular marks.

Removing Welds or Hammer Marks - When removing welds or hammer marks, limit coarse sanding to the immediate area. Use successively finer grits to smooth surface.

Finishing Metal - Constantly move across the surface. Work faster on curved surfaces where contact areas are smaller and pressure is greater. Flat areas may appear at the end of the stroke when pressure is too heavy. Ease up on pressure at end of each stroke and when reversing strokes.

Troubleshooting

Deep scratches and circular marks can result from:

- Using too coarse a grit
 - Using a partially glazed disc
 - Dirt or loose metal on the workpiece
 - Failure to sand across the grain when changing from one grit to another
 - Failure to use closed coated discs to reduce the problem of grains working loose and scratching the workpiece
- Bluish discoloration of metal surface indicates:
- Excessive heat caused by circular motion in a small area
 - Excessive pressure
 - Use of worn out or glazed discs

⚠WARNING To reduce the risk of injury, always unplug the tool before performing any maintenance. Never disassemble the tool. Contact a MILWAUKEE service facility for ALL repairs.

Maintaining Tools

Keep your tool in good repair by adopting a regular maintenance program. Inspect your tool for issues such as undue noise, misalignment or binding of moving parts, breakage of parts, or any other condition that may affect the tool operation. Return the tool to a MILWAUKEE service facility for repair. After six months to one year, depending on use, return the tool to a MILWAUKEE service facility for inspection.

⚠WARNING To reduce the risk of personal injury, electric shock and damage, never immerse your tool in liquid or allow a liquid to flow inside it.

Cleaning

Clean dust and debris from vents. Keep handles clean, dry and free of oil or grease. Use only mild soap and a damp cloth to clean, since certain cleaning agents and solvents are harmful to plastics and other insulated parts. Some of these include gasoline, turpentine, lacquer thinner, paint thinner, chlorinated cleaning solvents, ammonia and household detergents containing ammonia. Never use flammable or combustible solvents around tools.

Repairs

For repairs, return the tool to the nearest service center.