

WIDE BELT SANDER

METAL PRO SERIES 37"

MANUAL



Model # MSANWB37X75-1K-20-0197-1

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Wide Belt, 37" metal sanding, single head

Model # MSANWB37X75-1K-20-0197-1

LATEST MANUAL:

Below is a QR code which will direct you to the manual reference page, where the latest version of the wide belt metal 37 manual is located on the Laguna Tools website. The online manual may have updates and information added after the printed copy was released. Scan the code with your smartphone or copy the URL link to be directed to the latest manual page to reference your specific machine and model.

<https://lagunatools.com/resources/product-manuals/#industrial>



LAGUNA TOOLS

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SAFETY RULES:

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
9. **USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Table A (on the next page) shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gage. The smaller the gage number, the heavier the cord.
10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
11. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
12. **SECURE WORK.** Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
13. **DON'T OVERREACH.** Keep proper footing and balance at all times.
14. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **DISCONNECT TOOLS** before servicing; when changing accessories, such as blades, bits, cutters, and the like.
16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
18. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
19. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
20. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
21. **NEVER LEAVE TOOL RUNNING UNATTENDED.** **TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

Proposition 65 Warning

Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain 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, cement, and other masonry products.
- **Arsenic and chromium** from chemically treated lumber.

Your risk of exposure 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 face or dust masks that are specifically designed to filter out microscopic particles.



SAFETY RULES

As with all machinery, there are certain hazards involved with the operation and use. Using it with caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. If you have any questions relative to the installation and operation, do not use the equipment until you have contacted your supplying distributor.

Read the following carefully before operating the machine.

1. Keep the working area clean and be sure adequate lighting is available.
2. Do not wear loose clothing, gloves, bracelets, necklaces, or ornaments. Wear face, eye, respiratory and body protection devices as indicated for the operation or the environment.
3. Be sure that the power is disconnected from the machine before tools are serviced or an attachment is to be fitted or removed.
4. Never leave the machine with the power on.
5. Do not use dull, gummy or cracked cutting tools.
6. Be sure that the keys and adjusting wrenches have been removed and all the nuts and bolts are secured.

Sound emission.

Notes concerning noise emission.

Given that there exists a relationship between noise level and exposure times, it is not precise enough to determine the need for supplementary precautions. The factors affecting the true level of exposure to operators are clearly the amount of time exposed, the characteristics of the working environment, such as other sources of dust and noise – for example, adjacent machines – in other words, the level of ambient noise. It is possible that exposure level limits will vary from country to country.



WARRANTY & REGISTRATION

Thank You!

Welcome to the Laguna Tools® group of discriminating industrial machinery owners. We understand that you have a choice of where to purchase your machines and appreciate the confidence you have in the Laguna Tools® brand.

Through hands-on experience, Laguna Tools® is constantly working hard to make innovative, precision products. Products that inspire you to create works of art are a joy to operate and encourage your best work.

Laguna Tools®
Imagination, Innovation, and Invention at Work

Warranty & Registration

Every product sold is warranted to be free of manufacturer's defective workmanship, parts, and materials. For any questions about this produce, the intended use or what it was designed for, customer service, or replacement parts, please contact our customer service department:

Laguna Tools® Customer Service
744 Refuge Way, Grand Prairie, Texas 75050, USA
1-800-234-1976
customerservice@lagunatools.com
www.lagunatools.com/why/customer-service/
8AM. To 5PM PST. Monday through Friday

For warranty claims or to report damage upon receiving-please reach out to our warranty department:

Laguna Tools® Warranty Service
744 Refuge Way, Grand Prairie, Texas 75050, USA
1-800-234-1976
customerservice@lagunatools.com
www.lagunatools.com/policies/warranty
8AM to 5PM PST, Monday through Friday

Registration

To prevent voiding this warranty, all products sold must be registered within thirty (30) days of receiving the product. Registering the product will enable the original purchaser to receive notifications about important product changes, receive customer service, and be able to file a warranty claim against defective workmanship, parts, or materials.



Who is Covered

The applicable warranty covers only the initial purchaser of the product from the date of receiving the product. To file such claims, the original purchaser must present the original receipt as proof of purchase.

What is Covered

The warranty covers any defects in the workmanship of all parts and materials that make up the machine unless otherwise specified. Any part determined by Laguna Tools® to have a defect will be repaired or replaced (and shipped), without charge. The defective item/part must be returned to Laguna Tools® with the complaint and proof of purchase in the original packaging that it was received in. In the event the item/part is determined to be not covered by this warranty, the customer will be responsible for the cost to replace the item/part and all related shipping charges

Warranty Limitations

This limited warranty does not apply to natural disasters, acts of terrorism, normal wear and tear, product failure due to lack of maintenance or cleaning, damage caused by accident, neglect, or lack-of inadequate dust collection. The warranty may be voided against proof of misuse/abuse, damage caused where repair or alterations have been made or attempted by others, using the product for purposes other than those described as intended use (unless with consent by Laguna Tools®), modification to the product, or use with an accessory that was not designed for the product. It is the responsibility of the user to understand basic machinery settings and procedures and to properly maintain the equipment in accordance with the standards provided in this manual.

Length of Warranty

Machines sold for either commercial or industrial use have a one-year warranty. Wearable parts like throat plates, bandsaw guides, etc., have a ninety-day warranty.

Table A-1 Warranty Lengths

1 Year – Machines Sold for Commercial or Industrial Use
1 Year – Blades and Accessories outside of Machine Options
90 Days – Wearable Parts

Aside from being free of defects upon receiving, consumable parts, like cutters and abrasives, are not covered by this warranty unless otherwise stated by Laguna Tools®. These parts are designed to be used at the expense of the operator and are available for replacement or inventory purchase. The determination of a consumable part will be made on a case-by-case basis by Laguna Tools®.

Shipping Damage

Laguna Tools® is not responsible for damage or loss caused by a freight company or other circumstances not in the direct control of Laguna Tools®. All shipping-related claims for loss or damage to goods must be made to Laguna Tools® within twenty-four hours of delivery.

How to Receive Support

To file a warranty-claim please contact the warranty department at 1-800-234-1976. To receive customer service or technical support please contact the customer service or technical support please contact the customer service department at 1-800-332-4049. Parts, under warranty, are shipped at the expense of Laguna Tools® either by common carrier, FedEx ground services or similar method. Technical support to install replacement parts is primarily provided by phone, fax, email, or the Laguna Tools® Customer Service Support Website.



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SPECIFICATIONS 37" metal wide belt sander.

<u>SPECIFICATIONS</u>	
Model # MSANWB37X75-1K-20-0197-1	
Main motor	20 HP
Conveyor motor, variable feed speed	1 HP
Table lifting motor	0.25 HP
Voltage	220V / three phase / 60 HZ
Max sanding height/thickness	5" (127 mm)
*Min sanding height/thickness	*1/32" (0.8 mm)
Max sanding width	36 1/2" (927 mm)
Min sanding length	9" (229 mm)
Sanding belt size	37" x 75" (940 mm x 1905 mm)
Diameter of sanding drum	7.87" (200 mm)
Length of sanding drum	38" (965 mm)
Sanding drum RPM	1725 RPM
Conveyor speed	15-49 FPM
Dust port size	4" (100 mm)
Number of dust ports	3
Footprint	19" x 51" (483 mm x 1300 mm)
Width x Depth	25 1/2" x 52" (650 mm X 1320 mm)
Height with dust collection ports	77 1/2" (1968 mm)
Height without dust collection ports	71 1/2" (1816 mm)
Conveyor height at lowest setting	32" (813 mm)
Cabinet	Steel
Operating air pressure	6 Bar / 87 psi.
Sanding belt oscillation	Adjustable
Sanding belt motor brake	Air operated disc brake

CAUTION!

* Minimum thickness can vary depending on material, size (dimensions), abrasives, application, etc. and could be greater than or less than, depending on those and other possible parameters and conditions.



RECEIVING

Note. It is probable that your machine will be delivered by a third party. Before you unpack your new machine, you will need to first inspect the packing, invoice and shipping documents supplied by the driver.

Ensure that there is no visible damage to the packing or the machine. You need to do this prior to the driver leaving. **All damage must be noted on the delivery documents** and signed by you and the delivery driver. You must then contact the seller (Laguna Tools) as soon as practical. If damage is found after delivery, contact the seller as soon as is practical.

Note. It is probable that you will find dust/debris within your machine. This is because the machine has been tested prior to shipment from the factory and or Laguna Tools.

Laguna Tools endeavors to test machines prior to shipping to customers, as movement can take place during transportation. It must be noted that additional machine movement can take place between Laguna Tools and the end user and that some adjustments may have to be undertaken by the customer. These adjustments are covered in the various sections of this manual.



Wide belt sander with box removed.



INTRODUCTION

This machine is designed to give you years of safe service. Read this owner's manual in its entirety before assembly or use.

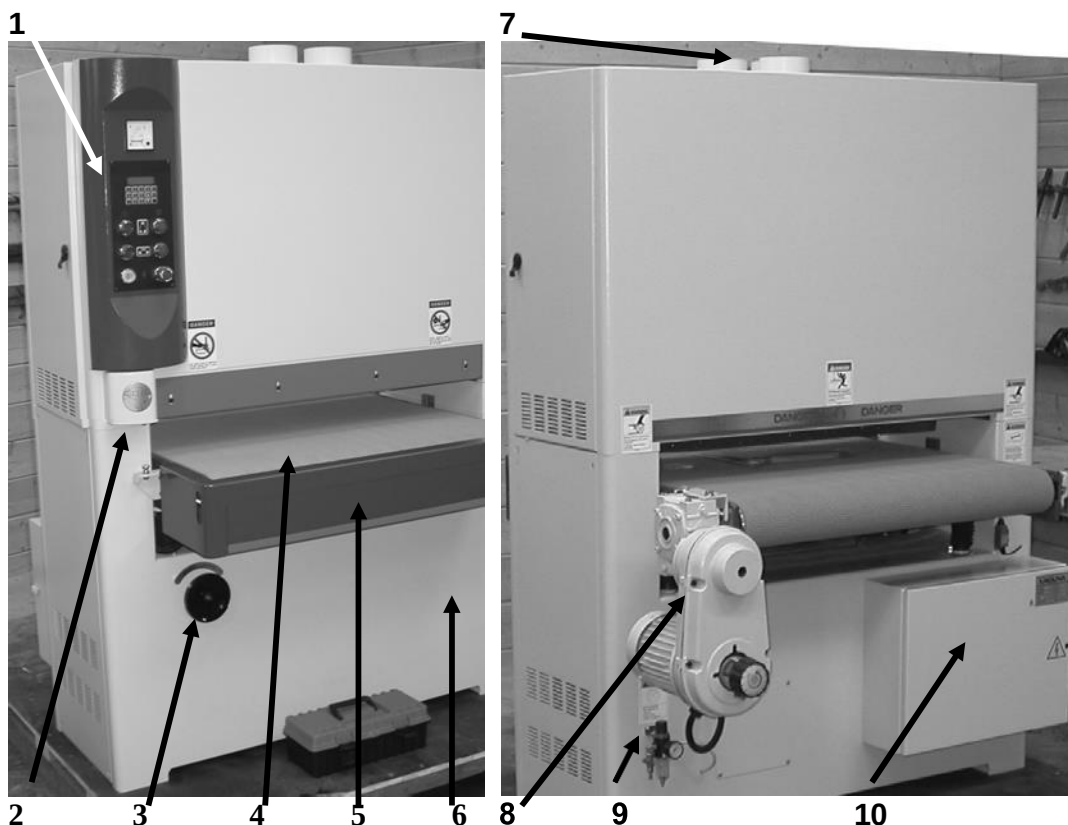
Parts of the wide belt sander.

The wide belt sander consists of several major parts, which are discussed in this manual. Take the time to read this section and become familiar with the machine.

Identification.

There is a plate on the side of the machine listing all the manufacturing data, including the model and serial number. Have these numbers available when ordering supplies, accessories or parts.

COMPONENTS



1. Control Panel
2. Automatic Thickness Control/Sensor
3. Thickness Adjustment Handwheel
4. Conveyor Bed
5. Emergency STOP
6. Sander Frame

7. Dust Ports
8. Conveyor Speed Adjustment
9. Air Connection, Filter & Regulator
10. Electrical Connection & Distribution Box



1. Control panel.

The control panel controls all the electrical functions of the machine. This includes the speed of the drive belt, vertical adjustment of the bed and on/off functions.

2. Bed, vertical setting device.

This device is used to set the height of the bed in relation to the sanding rollers.

3. Bed, manual vertical adjusting handle.

This handle is used to manually adjust the bed vertically.

4. Bed, conveyor.

The bed of the sander has a rubber drive belt that transports the job through the machine. The speed of the belt is adjustable.

5. EMERGENCY STOP, (aka. safety bar, bump plate, bump bar)

The EMERGENCY STOP safety bar is used to remove power from the motors. If a job became jammed, the bump-bar can be operated by hand, leg, or hip.

6. Machine body.

The machine body is manufactured from heavy-gauge steel.

7. Dust extraction.

There are three dust extraction ports located on the top of the machine and are 4 inches (100mm) in diameter. Dust extraction is critical when sanding. The sander produces dust that must be removed for health reasons and also because the belt will clog and a poor surface finish will result. It is not possible to be exact when recommending what size of dust collector should be used; this will depend on the type of work and applications that the machine is used for. It is recommended that a dust collector with a minimum of 3500 cubic feet/minute is attached to the sander.

8. Conveyor belt speed control.

The conveyor belt speed is variable between 6-30FPM. The belt speed is adjusted by the **control knob, which must be adjusted while the belt is running**. To decrease the speed, turn the adjuster clockwise. To increase the speed, turn the adjuster counterclockwise. Damage may occur if operated when the conveyor is not in motion.

9. Air supply.

A clean dry air supply with a minimum pressure of 6 bar (87 psi.) must be connected to the sander. If the pressure drops below 5 bar (73 psi.), the machine will stop functioning.

10 Electrical control box.

The electrical control box houses all the electrical control components and must never be opened while power is supplied to the machine.





11. Main Motor/Sanding
12. Conveyor Lift Motor



13. Sanding Belt Limiter
14. Sanding Belt Sensor
15. Sanding Belt Controls

11. Sanding drum motor.

12. Conveyor bed vertical adjusting motor.

The conveyor bed vertical adjusting motor moves a chain that rotates four cogs. The cogs turn threaded shafts that lift or lower the bed.

13. Sanding belt limiter.

There are two ceramic limiters, one on either side of the machine. If the belt touches either of the limiters, a micro switch is activated, and the machine will stop. If the sanding belt touches any of the limiters, the sanding belt will have to be adjusted prior to restarting the sander.

14. Sanding belt sensor.

This sensor controls the action of the sanding belt oscillation. As the belt moves in and out of the sensor, a piston moves a cam that is attached to the top sanding roller. This action changes the angle of the top roller and forces the belt to move along the roller.

15. Sanding belt control knobs.

These knobs control the actions of the sanding belt sensor and the amount of oscillation of the sanding belt.





16. Spacer
17. Clamp
18. Sanding Belt Tension Knob



19. Sanding Belt Adjuster
20. Sanding Belt Oscillation Piston
21. Sanding Belt Tension Piston

16. Spacer.

The spacer is used to support the sanding head to the body of the machine. The spacer is removed when changing sanding belts.

17. Clamp

The clamp secures the sanding head to the machine frame.

18. Sanding belt tension knob.

The belt tensioning knob controls the amount of pressure that the piston exerts on the sanding belt.

19. Sanding belt adjustor.

The sanding belt adjustor is used to adjust the belt centrally on the top roller.

20. Sanding belt oscillation piston.

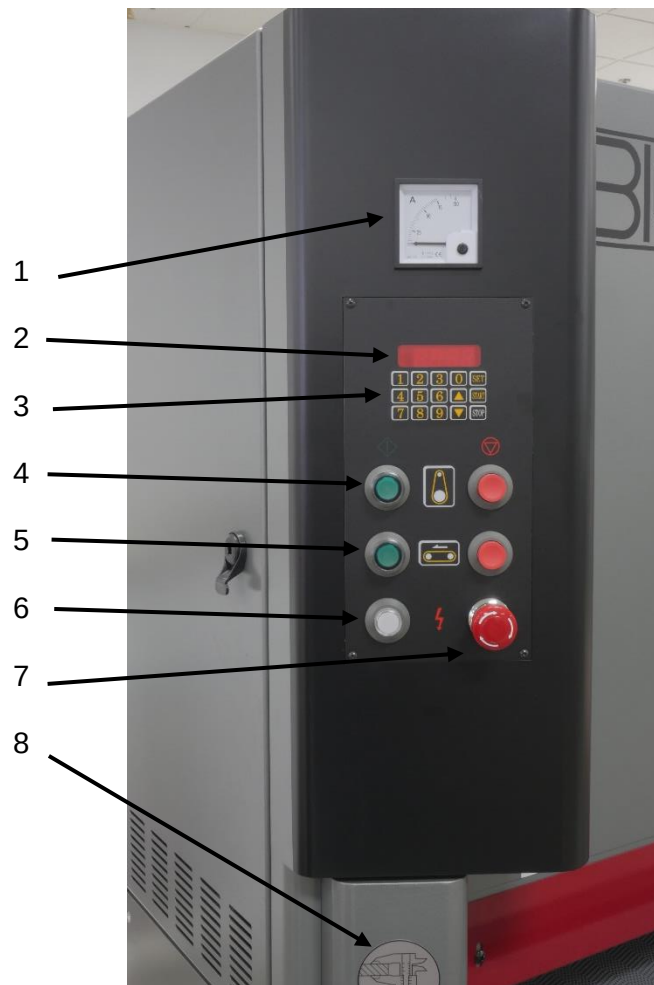
The sanding belt oscillation piston moves a cam that is attached to the top sanding roller. This action changes the angle of the top roller and oscillates the belt along the rollers.

21. Sanding belt tension piston.

The piston keeps a constant pressure on the sanding belt and is retracted to allow the belts to be changed.



Control Panel Functions & Features

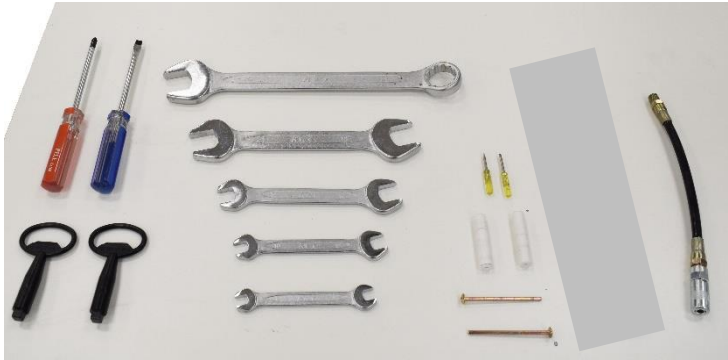


1. **Amp Meter**
2. **DRO/Thickness display**
3. **Thickness Control operation pad**
4. **Sanding Belt ON (green) & OFF (red)**
5. **Conveyor Belt ON (green) & OFF (red)**
6. **Power indicator light**
7. **Emergency STOP**
8. **Automatic Thickness sensor**



INVENTORY

What you will receive with the wide belt sander.



Screwdrivers
Door Keys
Wrenches
Ceramic Belt Limiters and hardware
Flexible extension, (greasing)
Abrasive Belt
Hex wrenches (not shown)
Toolbox (not shown)



Abrasive Belt

Locating the wide belt sander.

Before removing your machine from the packaging, select the area where to use the machine. There are no hard-and -fast rules for its location, but below are a few guidelines:

- 1.** There should be an area at the front and back of the machine suitable for comfortable working and to accommodate the longest length of the work pieces.
- 2.** Adequate lighting. The better the lighting, the more accurately and safely you will be able to work.
- 3.** Solid floor. You should select a solid, flat floor, preferably concrete or something similar.
- 4.** Locate it close to a power source and dust collection.
- 5.** Allow an area for the storage of blanks, finished products and tools.



UNPACKING

To unpack the sander, you will need tin snips, knife, screwdriver, hammer, and a wrench.

1. Using the tin snips, cut the banding that is securing the packing box (if fitted). **WARNING: EXTREME CAUTION MUST BE USED BECAUSE THE BANDING WILL SPRING AND COULD CAUSE INJURY.**

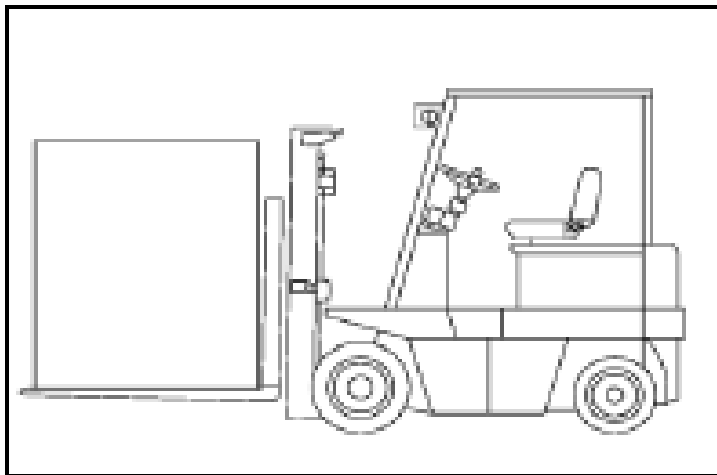
2. Dismantle the box.

3. Remove any bolts that secure the machine to the base (if fitted).

4. Remove the machine from the base with a forklift truck. The forklift must have sufficient capacity to achieve the job safely.

5. Remove the base and lower the machine to the floor.

Note. If you have any doubt about the described procedure, seek professional assistance. Do not attempt any procedure that you feel is unsafe or that you do not have the physical capability of achieving.



ASSEMBLY & SETUP

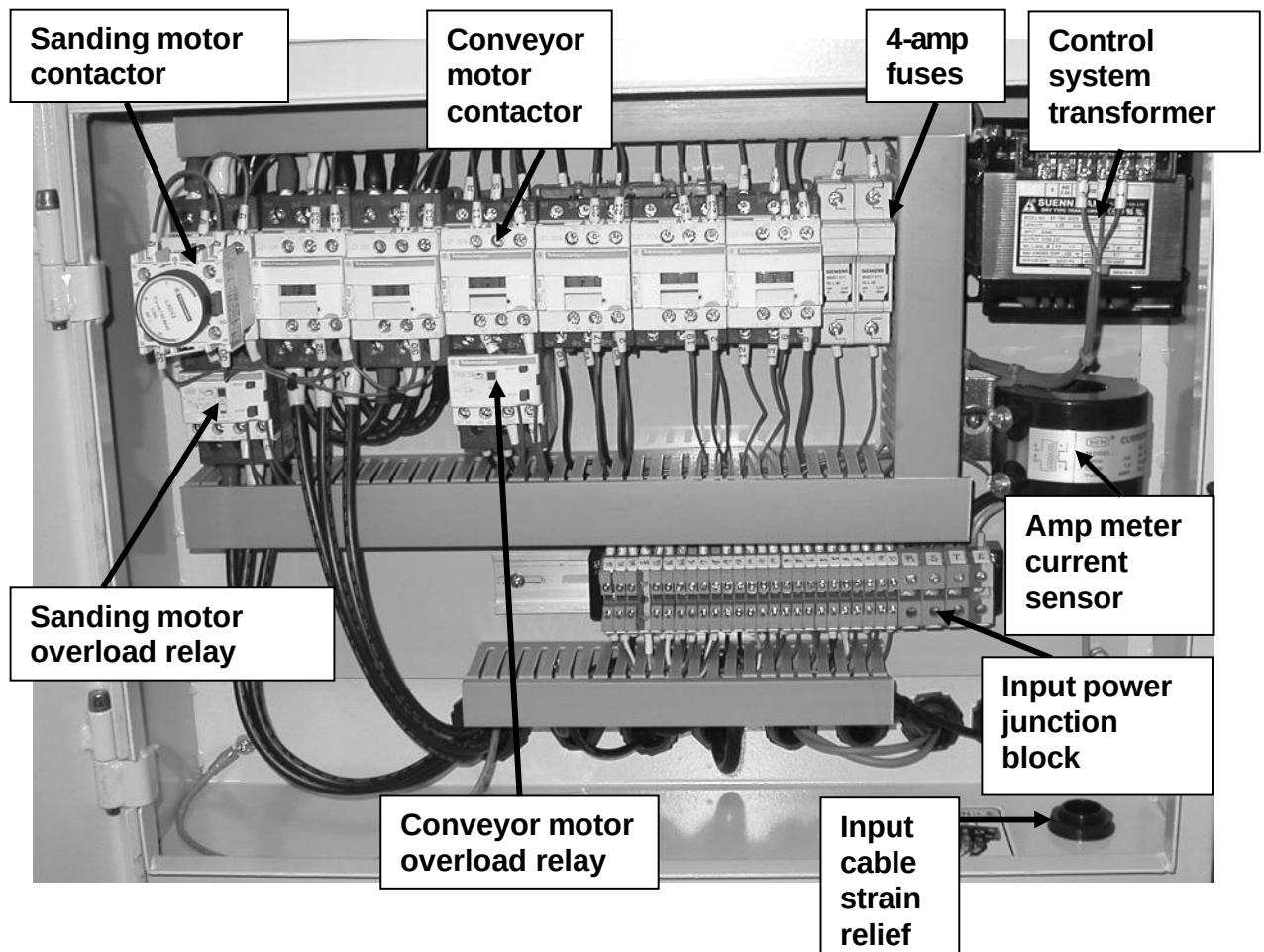
Very little assembly and setup is required, as the machine comes fully assembled. You will have to install the sanding belt and connect the air, dust collection and electrical supply as described in this manual.

Cleaning the machine.

Remove the rust protection packing-grease with WD-40®, green or citrus de-greasers or a similar grease-remover. It is important that you remove all the packing-grease. It is important not to introduce solvent into bearings or conveyor belt!



COMPONENTS, electrical box



ELECTRICAL SUPPLY CONNECTIONS

Note. A qualified electrician must carry out the electrical installation. Confirm the main power supply corresponds with that of the machine motor plate and wiring, (typically three-phase, 208-240 V, 60 HZ).

It is recommended that you use a minimum 60-amp main breaker/service for 3 phase, 220-volt operation.

Due to the amp draw of this machine, it is recommended that the machine is wired directly into the electrical distribution system and is on a dedicated circuit. Do not use an extension cord.

IMPORTANT!

The correct rotation of the contact roll (sanding drum) is clockwise, when facing into the sander from the access door for belt changing. The sanding belt should rotate toward the dust collection pick-up with the sanding head making a "climb-cut" on stock being sanded. If the contact roll rotates incorrectly, with a three phase system, have an electrician reverse two of the three power leads into the input power junction block.

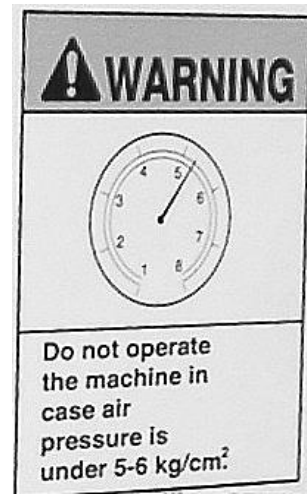


Connecting air supply.



Air line connection

Air pressure regulator



Label

The input air regulator regulates the air pressure that is supplied to the machine. The machine is supplied with an air connector, to connect the air supply. An air supply that can deliver a constant minimum pressure of 6 bar (87 psi.) is required. The machine is supplied with an input air regulator that you will need to adjust to 6 bar (87 psi.) once you have connected your air supply to the machine.

Note. No air pipe is supplied, as the length will depend on your installation.

To adjust the air pressure, pull the cap up and rotate until the gauge reads the correct pressure. Once the pressure is adjusted, push the cap in.

Note. An air supply of 6 bar (87 psi.) minimum is required for the machine.

It is strongly recommended that **7 bar (102 psi.) be supplied** to the machine and that the regulator then be set to **6 bar (87 psi.)**. This will ensure that the machine always has the minimum required air pressure. The input regulator has a moisture trap that must be emptied each day.

Note. It is important that the air that is supplied to the machine be clean and dry. The machine will not perform consistently if the air is dirty, as any dirt will block the valves. Wet or damp air will damage your machine and cause inconsistent performance.

Note. The pneumatic system does not need any type of lubricant. Some types of lubricant can damage the machine and compromise the machine's functions.

Note. During maintenance, always disconnect the air supply.



INSTALLING ABRASIVE BELT

Note. Disconnect the sander from the electrical supply.



Clamp & Spacer



Abrasive Belt tension switch



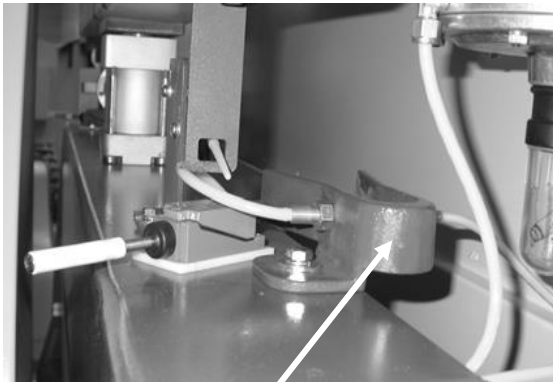
Abrasive sanding belt installation

- 1. Disconnect power to machine.** Rotate the roller tension switch counterclockwise to lower the tension roller.
- 2** Rotate the clamp counterclockwise and lift it out.
Note. The clamp is a quick-release and needs only to be rotated approximately 90 degrees to release.
- 3.** Remove the spacer. This will allow access for the sanding belt.
- 4.** Slide the sanding belt onto the top and bottom rollers.
Note. Ensure that the direction arrows on the inside of the sanding belt are facing in the correct direction (clockwise). If the belt is assembled with the arrows in the incorrect direction, the belt will not track properly and/or break.
- 5.** Replace the spacer and clamp.
- 6.** Rotate the roller tension switch clockwise to raise tension roller.





Clamp and spacer assembled



Belt sensor



Abrasive sanding belt installed

Note. Never run the sander without the spacer and clamp assembled, this will damage the machine.

Note. The machine is supplied with a sanding belt and may not be the correct one for your work/application. Purchase several sanding belts to suit your applications and always have spare belts available; you can never predict when a belt will break or wear out.

Note. The sanding belt must be positioned centrally on the rollers. It must also be between the forks of the belt sensors.



Choosing abrasive belts.

The grit type (backing and material) that you choose will depend on the type of work and the finish that the job dictates. It usually saves time and results in a better finish if you start a job with a coarse grit and then complete the finishing cuts with a fine grit. This will entail changing the sanding belts but can save time in the long run.

Grit	Type
24-60	Coarse
80 to 100	Medium
120 to 220	Fine

NOTE: Modern abrasive materials (e.g. ceramics, zirconium, etc.) and backings can be a better, more economical choice for many applications. Consult your abrasive supplier for details.

Starting the sander.

1. Connect the sander to the power.
2. Press the table up and down keys. The table should move smoothly and the display figures change.

Note. Check that the table moves in the correct direction according to the arrow that is being pressed. If the table moves in the incorrect direction, changing two of the phases (wires) of the input cable (3 phase machines only) should correct the issue.

3. Press the conveyor start and stop buttons. The conveyor should start, run and stop smoothly.
4. Press the sanding belt start and stop buttons. The sanding belt should start, run, and stop smoothly.
5. Let the sander run for a few minutes and listen for unusual noises or vibration. If any unusual noises or excessive vibration is detected, correct the problem before sanding a job.

Adjusting the sander.

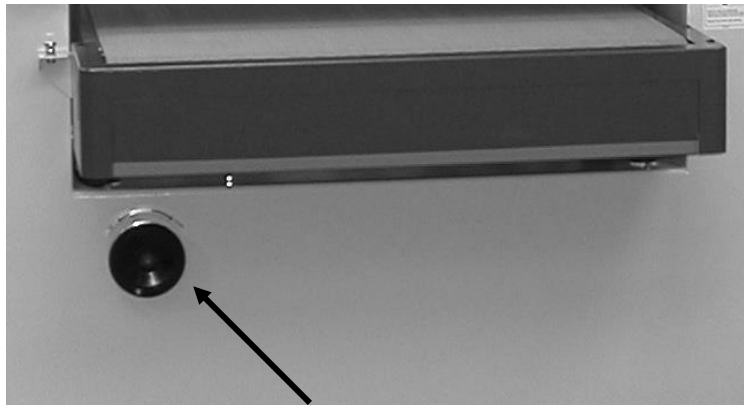
There are two main functions to adjust on the sander: the bed of the sander and the sanding belt.

Vertical adjustment of the bed.

The bed can be adjusted either manually or electronically.



Manual vertical bed adjustment.

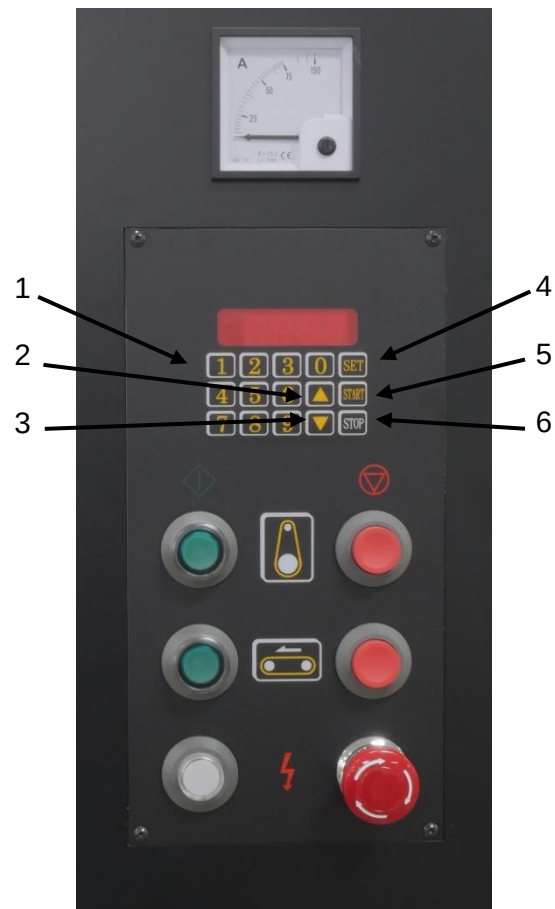


Thickness adjusting handwheel

The manual handwheel is located on the front of the machine under the bed. It is not recommended that the wheel is used for everyday operations and is only used for fine tuning and setting, emergency operations, or when the bed must be moved while no power is connected to the machine.



Electronic vertical bed adjustment/Control Panel.



Control panel

The control panel is set on the front of the machine. It has a control pad and several buttons. The numeric pad controls the vertical movement of the bed.

1. Numeric pad for inputting dimensions into the computer.
2. Bed up button.
3. Bed down button.
4. Set button.
5. Bed start button.
6. Bed stop button.



Calibrating the control panel.

Sand a piece of wood and measure the thickness. The sander must have been adjusted prior to sanding the wood. See sanding belt adjustment.

Using the numeric pad, input the thickness of the wood.

Press the set button and hold for 2.5 seconds.

The computer is now calibrated.

NOTE: Calibrating the control panel is the only time wood should be sanded using a metal sanding wide belt sander.



Setting the depth of cut (sanding depth).

- Press any button, and the display will read 000.0".
- Input the depth of cut using the numeric keypad (0,005").
- Press the set button and hold for 2.5 seconds.
The display will begin to flash; when it stops, the depth of cut is set.
- Press the start button, and the display will revert to 000.0". The input and run lights will illuminate, and the table will move to the new dimension.

A second method of setting the depth of cut is to press the arrow UP button until the desired depth of cut is reached.

Note. If you go past the dimension, press the arrow DOWN button to lower the table.

Note. The magnification resolution can be changed by changing the position of a switch that is located on the back of the control panel. This is not recommended, as the machine has been set to suit most workshop usages.

Automatic Thickness Control/Quick set Micro Switch.

The sander has a device on the side that is used to set the height of the bed without measuring the job. Simply put the job on the height setting button, press and hold the arrow up button. The table will move up until the job hits the micro switch. The distance between the sanding head and the job is now set. Set the depth of cut as described earlier.



Micro switch & Height setting button



HINT, Setting Depth of Cut.

If you are not certain setting the depth of cut; Measure the thickness of the stock. Place the stock on the conveyor under the sanding head (with abrasives installed). Raise the conveyor bed by hand using the handwheel until the stock is touching the abrasive belt and the belt can be rotated using hand pressure. Note the height setting on the DRO, lower the conveyor bed, remove the stock. Reset the thickness to the DRO setting. Start machine and process stock.

Setting the display to metric or inches.

Press the set button for 10 seconds, and the display will change from inches to metric, or vice versa.

Down limit switch.



Belt speed adjuster

Limit switch



Limit switch

The sander is fitted with a limit switch located at the back of the machine. This limit switch limits the down travel of the bed.



CONVEYOR BELT SPEED



Belt speed adjuster

The speed of the belt can be adjusted to between 6 and 30 feet per minute.

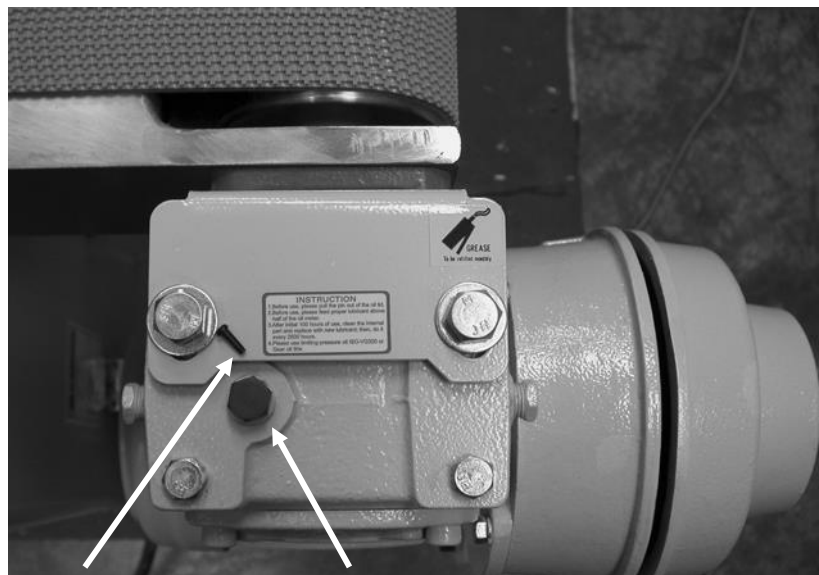
The speed is infinitely variable to suit the various applications to be sanded. It is a matter of experience when selecting the correct speed. Change the speed by rotating the belt speed adjuster while the motor is running. Clockwise decreases the speed, while counterclockwise increases the speed.

Note. Never adjust the speed

while the conveyor motor is not running, as this will cause damage to the machine.

Belt drive gear box.

The belt drive gear box is filled with oil. As the oil heats, it expands and causes pressure within the gear box. To relieve this pressure, there is a small hole on the side of the red bolt. To ensure there is no leakage during shipping, the hole is sealed with a small plastic pin. **Before the machine is run, this pin must be removed.** This will allow the oil to expand without causing damage or leakage during use.



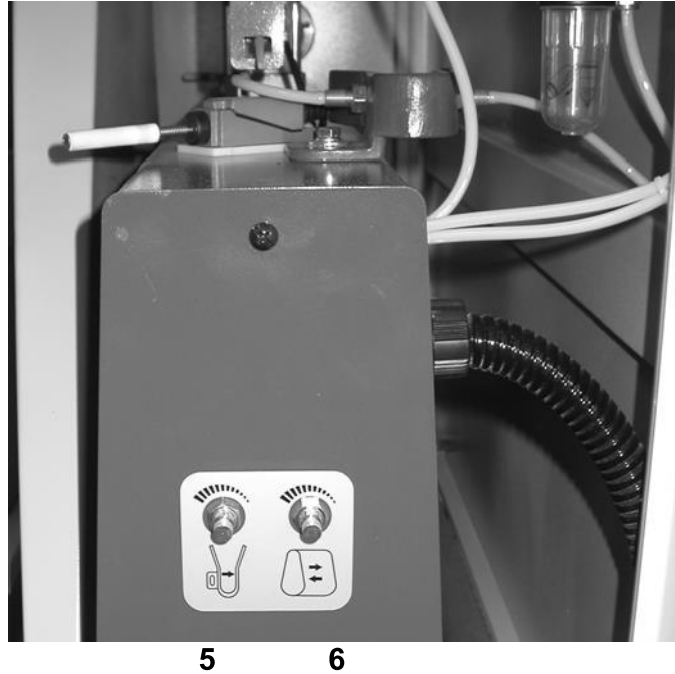
Blanking pin

Red bolt



SANDING BELT ADJUSTMENTS

General description of sanding controls and actions.



The sanding belt is tensioned by the central belt tension piston. The piston is activated by the sanding belt tension switch. This switch must be activated prior to starting the sander. The sanding belt oscillates along the top and bottom rollers. This greatly enhances the performance of the sander and reduces the chances of lines and marks on the job. To achieve this oscillation, the top roller pivots about a central air cylinder (1). This air cylinder also keeps pressure on the belt and keeps it tight to the rollers.



Sanding belt tension switch

The pivoting is controlled by a non-contact air sensor (4). Should the sanding belt break, a micro switch (3) is activated and stops the machine. If the oscillation



is excessive or the sanding belt runs off center, the sanding belt will hit one of the two ceramic rollers (2). The rollers are attached to micro switches that stop the machine. The sensitivity of the non-contact air sensor can be adjusted by rotating the control knob (5). This has been factory set and should not need adjustment. The speed of the belt oscillation can be increased or decreased by adjusting the control knob (6).

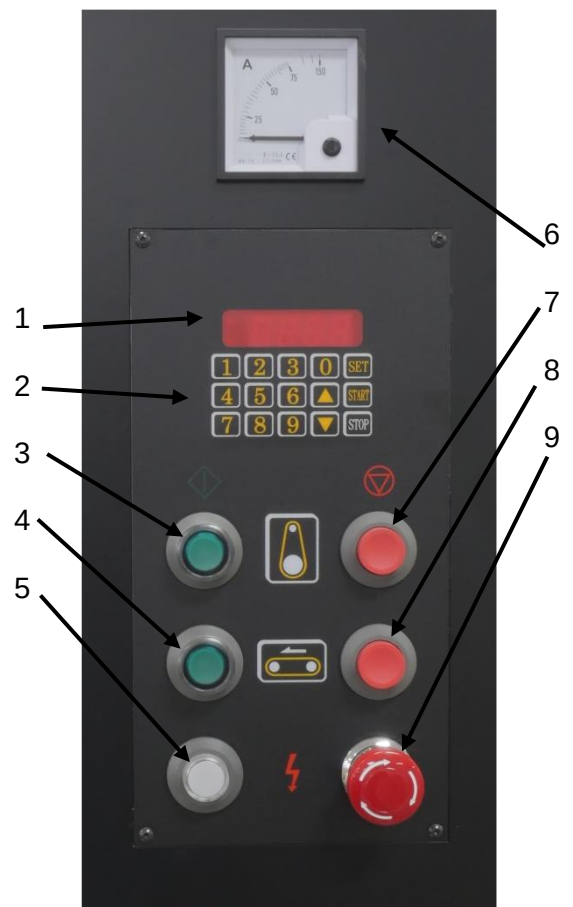
The sanding belt is centralized on the rollers by adjusting the sanding belt centralizing cam. This will have to be done for every belt, as each belt will run differently.



**Sanding belt
centralizing cam**

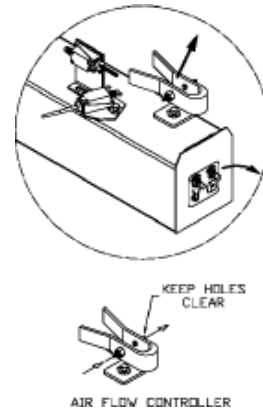
Control panel functions

1. DRO/Thickness display
2. Thickness Control pad
3. Sanding belt start button.
4. Conveyor belt start button.
5. Power on light.
6. Amp Meter
7. Sanding belt stop button.
8. Conveyor belt stop button.
9. Emergency STOP button (twist to release).



Sanding belt oscillation adjustment.

1. With no sanding belt fitted, restrict the airflow across the sensor (U) with a piece of wood or something similar.
2. The top roller should pivot, and when the obstruction is removed, the top roller should pivot back to the original position.
3. Check that the roller pivots a few times.
4. With the sanding belt installed, run the sanding head and note the time that it takes the sanding belt to oscillate in both directions. The time taken to oscillate in either direction should be the same.
5. If the oscillation to the right is longer than the time for the sanding belt to oscillate to the left, adjust the control knob (5) to the right.
6. The speed of oscillation is adjusted with control knob (6). The speed of oscillation will change the sanding results. Test the sanding results with a piece of scrap.
7. Turning the knob clockwise will reduce the oscillation speed.



Running the machine after installing a new sanding belt.

1. Fit the sanding belt as detailed earlier.
 2. Check that the belt is not hitting the ceramic rollers and is positioned approximately central on the rollers.
 3. Check that the emergency stop button is not engaged (**twist to release**).
 4. Check that the bed is at least 1 inch down from the sanding belt.
 5. Check that the sanding belt tension piston has been activated.
 6. Press the sanding belt start button. The sanding belt will start to rotate.
 7. Open the left-hand door and check that the sanding belt oscillations are central on the rollers. You will probably find that they are biased to one end.
 8. Press the sanding belt stop button. After the belt has completely stopped, loosen the sanding belt centralizing cam and move either left or right depending on the error.
 9. You may find that the sanding belt will have hit one of the ceramic rollers. This will mean that the sanding belt is not running central. Release the sanding belt tension piston and re-centralize the belt on the rollers. Then adjust the sanding belt centralizing cam and retest.
- Note.** As the name implies, this is a sanding machine and is not designed to cut large amounts of material from the job. It is far better to take several small slow cuts rather than one large cut. The sanding belt will last far longer, the surface finish will be better, and the machine will not be damaged.



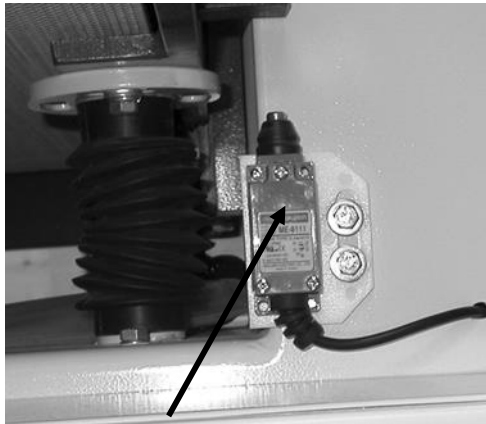
Testing the machine.

Note. Remove all tools and other materials from the machine prior to testing it.

1. Connect the electrical supply.
2. Switch “ON” the sanding machine momentarily. Check that the sanding belt is running true and balanced on the rollers.
3. If the belt is not running true, adjust the belt (detailed later in the manual).
4. If the belt is running true and balanced on the rollers, switch on the machine and allow the machine to run for a few minutes.
5. While the machine is running, check for rattles and vibration. If rattles or vibration is detected, investigate the cause and tighten/correct the relevant parts.



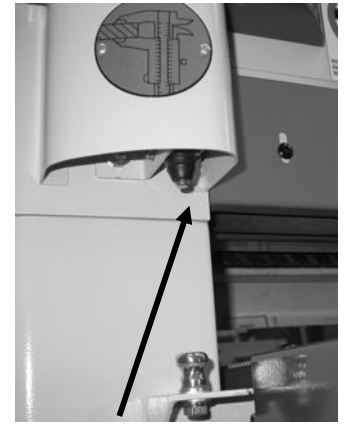
Check that all the safety switches are functioning.



Bed lower limit switch



**Bed safety switch
(Emergency STOP)**



**Bed upper limit
switch**

1. Lower the bed until it hits the lower limit switch. The bed travel must stop once the switch is activated.
2. With the sanding belt and the drive belt running, activate the bed safety switch. The sanding belt and the drive belt must stop once the safety switch has been activated.
3. Raise the bed until it hits the bed upper limit switch. The bed travel must stop once the switch is activated.
4. With the sanding belt and the drive belt running, press the emergency stop button.
5. With the sanding belt running, press the sanding belt stop button.
6. With the drive belt running, press the drive belt stop button.



**5 6
Emergency STOP**

Operating/Sanding.

Sanding is a finishing process, and no more than 0.008" should be removed with each pass. Larger cuts will result in jamming, poor surface finish, burn marks, excessive sandpaper wear, excessive motor loading, and so on.

Wearing the correct safety equipment, start sanding as follows.

1. Switch on the dust collector.
2. Set the bed to a height that will just miss the thickest part of the job.
3. Raise the table with each pass until the job is sanded over the complete surface.



Maintenance and troubleshooting.

Note. When conducting maintenance, disconnect the machine from the electricity and the air supply.

General.

Keep your machine clean. At the end of each day, clean the machine. If dust is not removed, it will cause rust. In general, we recommend that you only use a Teflon-based lubricant.

Regular oil attracts dust and dirt. Teflon lubricant tends to dry and has fewer tendencies to accumulate dirt and dust.

Weekly (Daily in heavy work environments).

1. Check that all nuts and bolts are tight.
2. Check the sanding belt for damage and wear.
3. Check cables for wear, damage, or cuts.
4. Empty the two water traps.
5. Remove any excessive dust and check the dust extraction system for blockages.
6. Grease the bearings.

Monthly.

1. All the above.
2. Cover the table adjustment screws with grease. Ensure that the rubber covers are replaced once greasing has been completed.
3. Grease the table lifting chain.

After the first 100 hours of operation, replace the oil in the conveyor drive gear box. Repeat the oil change every 2,500 hours. Recommended oil 90 wt. gear oil.

Drive V-belts.

The drive belts should last for a long time (depending on the usage) but need to be inspected regularly for cracks, cuts and general wear. If damage is found, replace the belts.

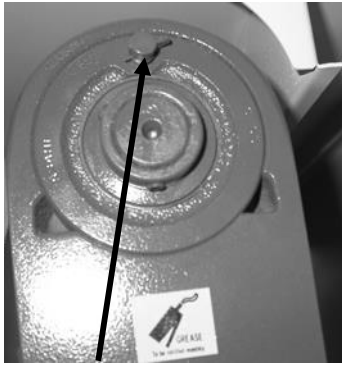
The belts come factory set, but they should be checked for tension after about 8 hours of use. The belts could need to be re-tensioned, as they will have bedded into the “V” grooves.

Note. The sanding head motor has multiple belts. They are matched, so if one belt requires replacement, you must replace all the belts with a matched set. If all the belts are not replaced, this will cause vibration and could put excessive strain on the motor and bearings. Not replacing all the belts will also cause the belts to wear out very quickly, as they are not all the same length and will slip.



Bearing lubrication.

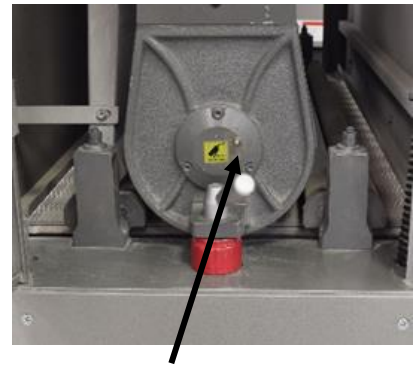
The bearings need to be greased. There are several grease points, as shown in the photographs below. It is recommended that the machine be greased after every 40 hours of operation. Greasing the bearings will flush out dust from the seals. After greasing, wipe off any excess. A grease gun extender is supplied to ease access to the bearings.



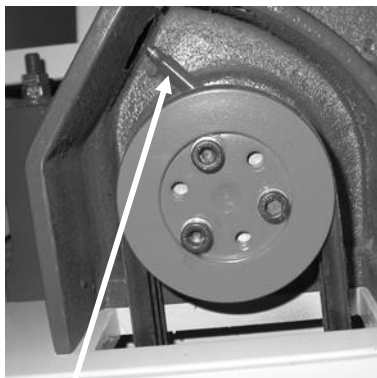
Grease nipple



Grease nipple



Grease nipple



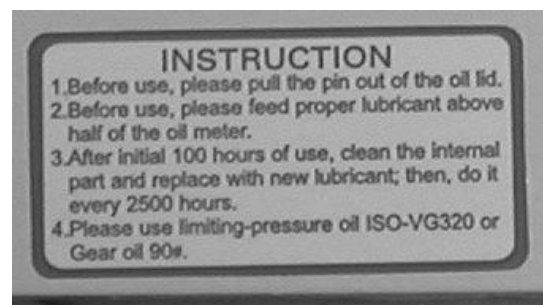
Grease nipple with cover removed



Grease nipple



Lubrication instructions



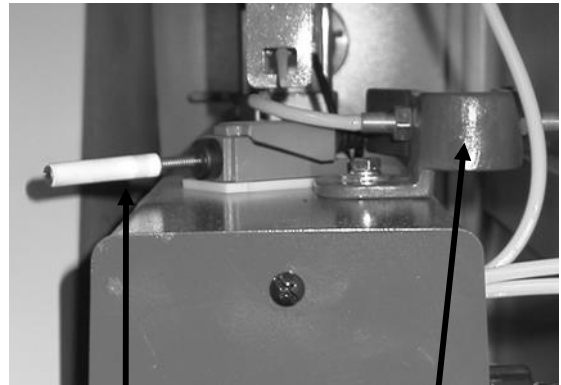
Lubrication instructions



Sanding belt non-contact air sensor.

There are holes in the sensor for the air to escape through. The holes should be checked regularly, and if they block, they must be cleaned. If the holes block, the belt will not track correctly on the rollers.

Ceramic rollers. The ceramic rollers must be checked regularly for wear, cracks and general damage. Two spares are supplied.

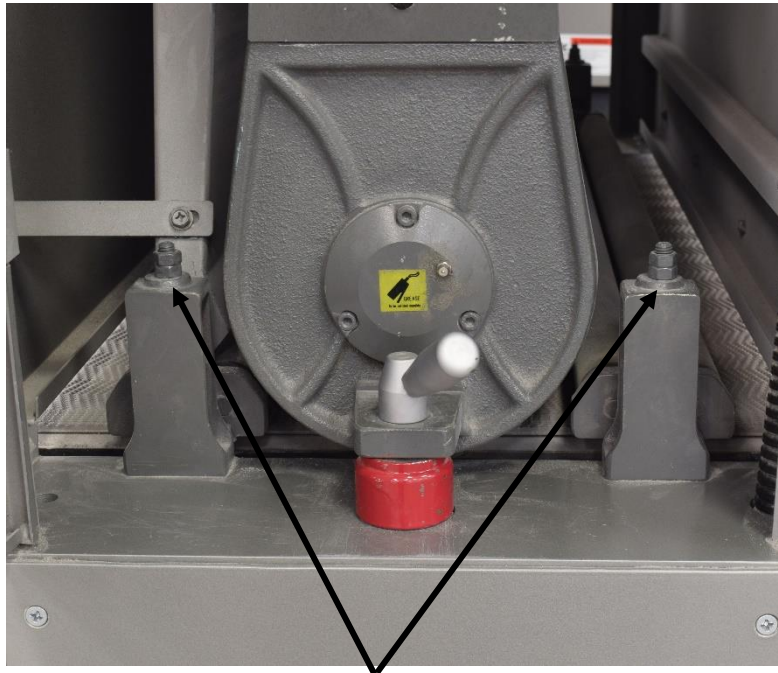


Ceramic rollers

Air sensor



Pressure roller adjustment.



Pressure roller adjusting studs & nuts

There are four pressure rollers: two on the infeed side and two on the outfeed side of the contact roll. The pressure rollers come factory set but may need to be adjusted during the life of the machine or certain applications.

Adjust the rollers as follows.

1. Place a panel on the bed of the sander so that it is under both the infeed and outfeed rollers.
2. Set the bed of the sander vertically so that one of the pressure rollers just touches the panel.
3. Loosen the lock nuts and adjust the pressure rollers so that they are both just touching the panel. This must be completed at the extremities of the rollers to ensure that they are parallel.
4. With the rollers parallel, adjust the rollers to the required setting and lock the lock nuts.

Note. When adjusting the height of the pressure rollers, after ensuring that they are parallel, adjust each screw the same amount or the rollers will not be parallel.

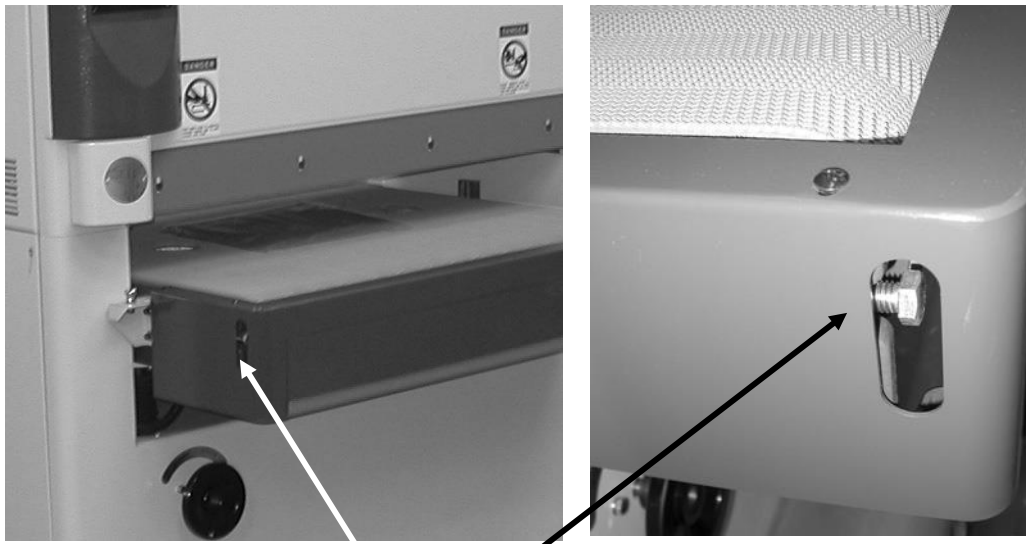
Note. Adjusting the pressure rollers must be done with the sanding belt stationary.

Note. The amount of pressure that you set the pressure rollers to exert on the job will vary depending on such variables as the depth of cut, hardness



of the material and other factors. Experimentation will be required to achieve the correct setting. It is suggested that setting the pressure rollers to 0.020" to 0.030" is a good starting point. Never set the pressure rollers level or higher than the sanding roller (contact roll), as this may result in injury from stock slippage.

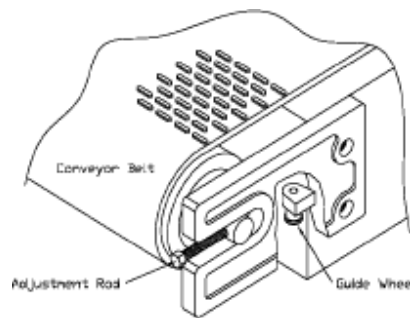
Adjusting/tracking the conveyor belt.



Conveyor belt adjusting bolt (tracking)

The conveyor belt comes factory set but may need to be adjusted at some time.

The conveyor belt must run centrally on the rollers and must be tensioned to prevent slippage. If the belt is not running centrally, check that the tension is correct before adjusting the tracking. Adjust as follows.



Conveyor tracking adjustment.

1. You may find it easier to remove the steel cover to expose the two guide wheels. To achieve this, remove the fixing screws.
2. Turn the conveyor on.
3. If the conveyor is running to the right, turn the right-hand adjusting screw clockwise. Only make very small adjustments and wait for the conveyor to settle before making additional adjustments. It is better to take your time and not rush the adjustments.



4. If the conveyor is running to the left, turn the left-hand adjusting screw clockwise.

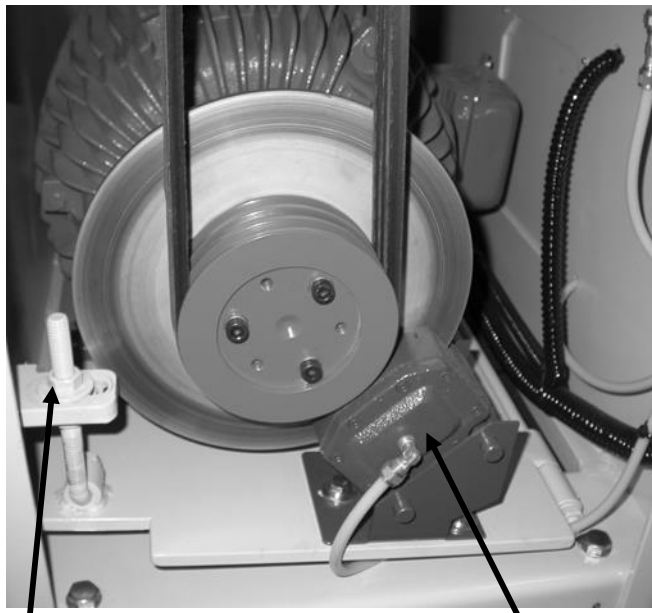
5. Once the conveyor is running centrally, stop the conveyor and replace the steel cover.

Conveyor tensioning.

To increase the tension on the conveyor belt, turn the adjusting bolts clockwise. To reduce the tension on the conveyor belt, turn the adjusting bolts counterclockwise.

Note. Adjust both adjusting bolts the same amount or the tracking will be affected.

Motor drive V-belt adjustment.



Lock nut

Break

Sanding head drive motor



Adjusting nut

Lock nut

Conveyor drive motor

Sanding head drive motor V-belt adjustment/tension.

The sanding head drive motor has a brake that is activated when the power is removed from the motor. The brake is air activated and should not need any regular servicing.

The drive V-belts will need to be adjusted from time to time. To adjust, loosen the lock nut and turn the adjusting nut (under bracket) until the correct tension is achieved. Do not forget to re-tighten the lock nut after the adjusting has been completed.

Note. Never access the motor with the power connected to the sander.



Conveyor drive motor belt adjustment.

The drive belts will need to be adjusted from time to time. To adjust, loosen the lock nut, and turn the adjusting nut (on top of bracket) until the correct tension is achieved. Do not forget to re-tighten the lock not after the adjusting has been completed.

Note. Never access the motor with the power connected to the sander.

Motor brake.

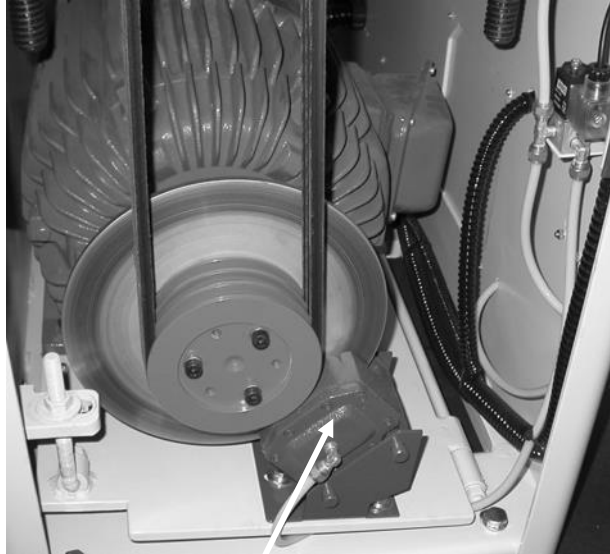
The brake pads will wear out after an extended period of use.

Replace the disc pads as follows.

Note. Remove the power to the machine prior to conducting any maintenance or repairs.

Note. Disconnect the air supply prior to brake pad replacement.

1. Remove the access panel to expose the sanding drum motor.



Brake caliper

2. Check the thickness of the disc pads. The pad is constructed from a metal backing plate and breaking material. The breaking material must be a minimum of 1/8" thick. If either of the pads is thinner than 1/8", both pads must be replaced.

3. Remove the nuts from the two mounting bolts and the two snap rings on the pins behind the bracket.

4. Pull the pins out.

5. Remove the air line and remove the caliper.

6. Disassemble the caliper and remove the disc pads.

7. Clean and degrease the disc. Check the disc for cracks and general wear. If the disc is damaged or worn excessively, have it resurfaced prior to fitting the new brake pads.

8. Assemble the new pads and reassemble the caliper to the sander. Ensure that the air is reconnected to the caliper.

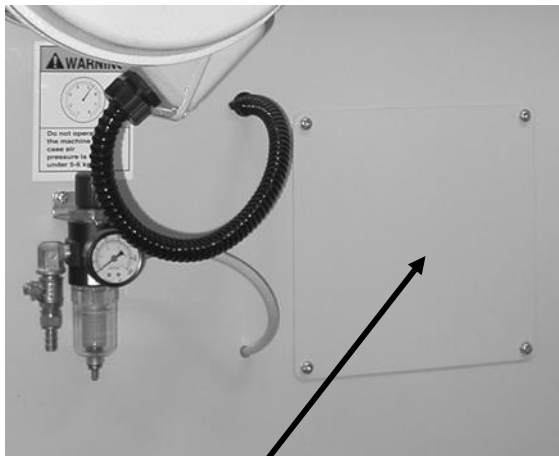
9. Test the brake system by pressing the emergency stop button; the sanding drum must stop rotating quickly and smoothly.



Accessing sanding head drive motor electrical termination.

To access the motor electrical terminations, remove the cover plate located beside the air regulator.

Note. Never access the motor with the power connected to the sander.



Cover plate



**Motor electrical terminations
(cover plate removed)**



Troubleshooting.

Problem	Possible cause	Solution
Display fails to come on.	Breaker tripped.	Reset breaker.
	Power switched off.	Switch power on.
	Display faulty.	Replace display.
Display shows incorrect figures.	Incorrect figures input into computer.	Input correct figures.
	Computer corrupted.	Turn power off then on.
	Display faulty.	Replace display.
Sanding belt clogs.	Sanding grit too fine.	Change the belt to a coarser grit.
	Depth of cut too big.	Reduce depth of cut.
	Oil or dirt on sanding surface.	Clean or discard.
	Poor dust collection.	Check for dust collection blockage.
Sanding belt slows down during a cut.	Feeding stock too fast.	Slow the feed rate.
	Dull sanding belt.	Replace the sanding belt.
	Low voltage.	Check the incoming voltage to the machine.
	Excessive depth of cut.	Reduce depth of cut.
Glazed sanding belt.	Stock is wet or oily.	Dry or clean the stock or replace stock with dry stock.
Grit comes off the sanding belt easily.	Poor quality sanding belt.	Replace sanding belt with good-quality sanding belt.
	Sanding belt stored in an incorrect environment (damp).	Discard belt.
	Sanding belt creased or folded.	Discard sanding belt.



Sanding belt breaks.	Belt assembled to machine with arrows in the wrong direction.	Replace belt.
Burn marks on the job.	Sanding belt is too fine for the job.	Replace the sanding belt with coarser grit sanding belt.
	Sanding belt clogged.	Clean belt or replace the sanding belt.
Deep sanding marks or grooves in job.	Sanding belt too coarse.	Replace sanding belt with finer grit.
	Clogged sanding belt.	Clean or replace sanding belt.
Job has rounded start and/or finish edges.	Excessive depth of cut.	Reduce depth of cut.
Sanded job not parallel.	Table not parallel to sanding head.	Adjust the table to sanding head.
Job dented or scratched.	Dirty pressure rollers.	Clean pressure rollers.
Job has glazed marks or scratches snaking along the job.	Glazed sanding belt.	Clean or replace sanding belt.
Poor sanding results.	Worn sanding belt.	Replace sanding belt.
	Clogged sanding belt.	Clean sanding belt and check dust extraction for blockages.
Sander will not start.	No power supplied to machine.	Check that the electrical power cord is plugged into the power outlet.
		Check that the electrical supply is on (reset the breaker).
		With the power disconnected from the machine, check that the wiring to the plug is correct. Check that the rubber insulation is



		stripped enough and is not causing a bad connection. Check that all the screws are tight.
		Check the supply voltage is correct.
Sander will not stop.	This is a very rare occurrence, as the machine is designed to fail-safe. If it should occur and you cannot fix the fault, seek professional assistance. The machine must be disconnected from the power and never run until the fault has been rectified.	Switch faulty. Replace the switch.
Motor tries to start but will not turn.	Machine jammed.	With the power disconnected from the machine, try to turn the sanding belt by hand. If the sanding belt will not turn, check the reason for the jamming.
	Motor faulty.	Replace the motor.
	Motor break locked on.	Release break.
Motor overheats.	The motor is designed to run hot, but should it overheat. It has an internal thermal overload protector that will shut it down until the motor has cooled, and then it will reset automatically. If the motor shuts down consistently, check for the reason.	Wait until motor has cooled and restart.
	Dull sanding belt.	Replace sanding belt.
	Motor cooling fins	Clean cooling fins.



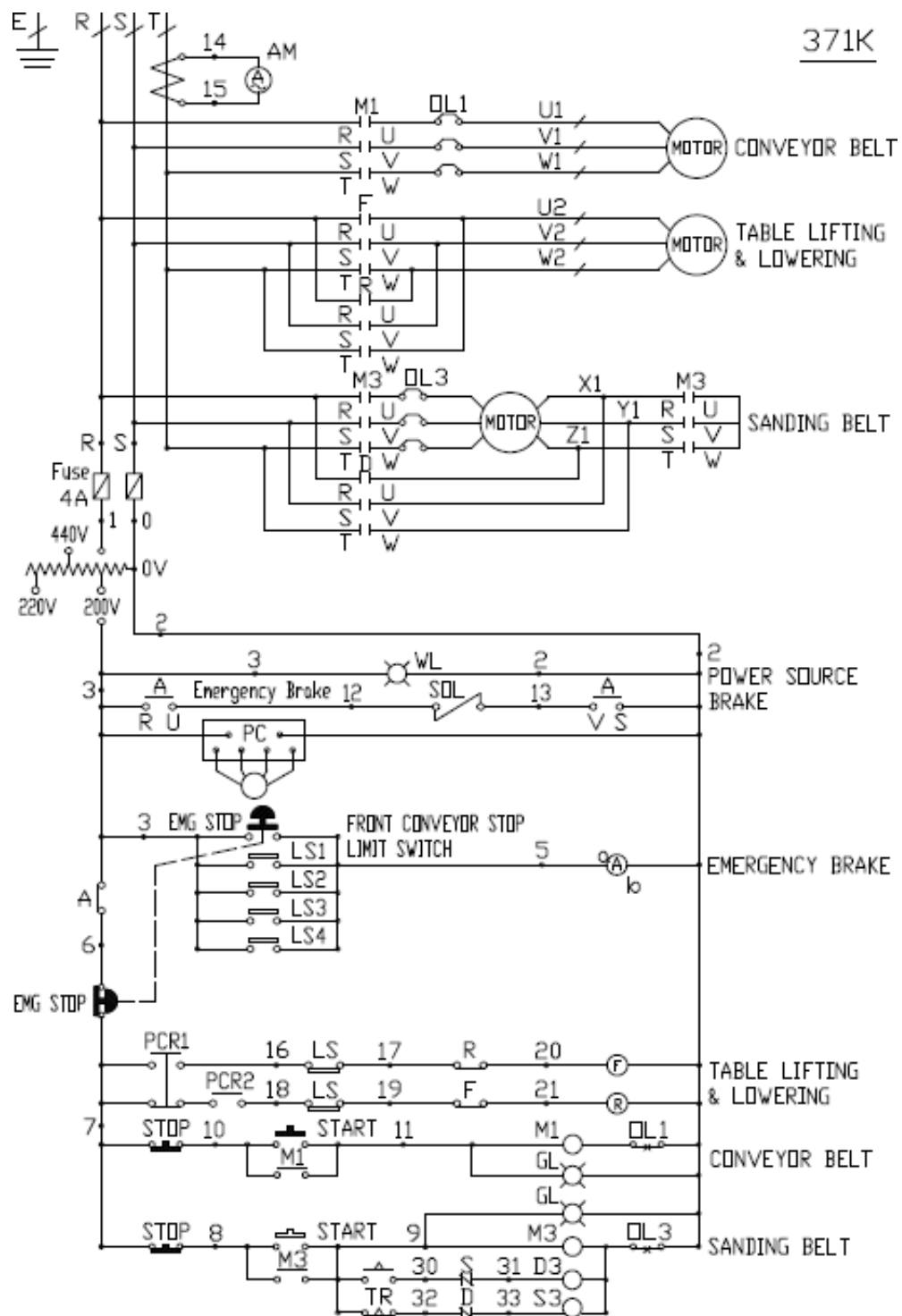
	clogged.	
	Over-feeding the job.	Slow feed rate.
	Excessive ambient temperature.	Cool area.
	Motor overloaded.	Reduce load on motor [(educe depth of cut or feed speed).
Squeaking noise.	Check the bearings.	Re-lubricate or replace bearing.
Machine vibrates.	Machine not level on the floor.	Re-level the machine, ensuring that it has no movement.
	Broken, damaged or defective sanding belt.	Replace the sanding belt.
	Loose fixing bolts.	Check all the fixing bolts and tighten if found loose.
Respective noise.	Damaged V belt(s).	Replace V belt(s).
	Motor fan hitting the cowl.	Tighten the fan or the cowl.
	Part loose.	Tighten loose part.
	Conveyor belt worn.	Replace conveyor belt.
Job slips when sanding.	Greasy or dirty conveyor belt.	Clean conveyor belt.
	Excessive depth of cut.	Reduce depth of cut.
	Conveyor belt worn.	Replace conveyor belt.
	Pressure roller not exerting correct pressure on job.	Adjust pressure rollers.
Conveyor belt not running in center.	Conveyor belt not tracked.	Adjust conveyor belt.
	Conveyor belt worn out.	Replace conveyor belt.
Conveyor belt slipping.	Incorrect pressure on conveyor belt.	Retention conveyor belt.
	Depth of cut too big.	Reduce depth of cut.
	Conveyor belt dirty.	Clean conveyor belt.



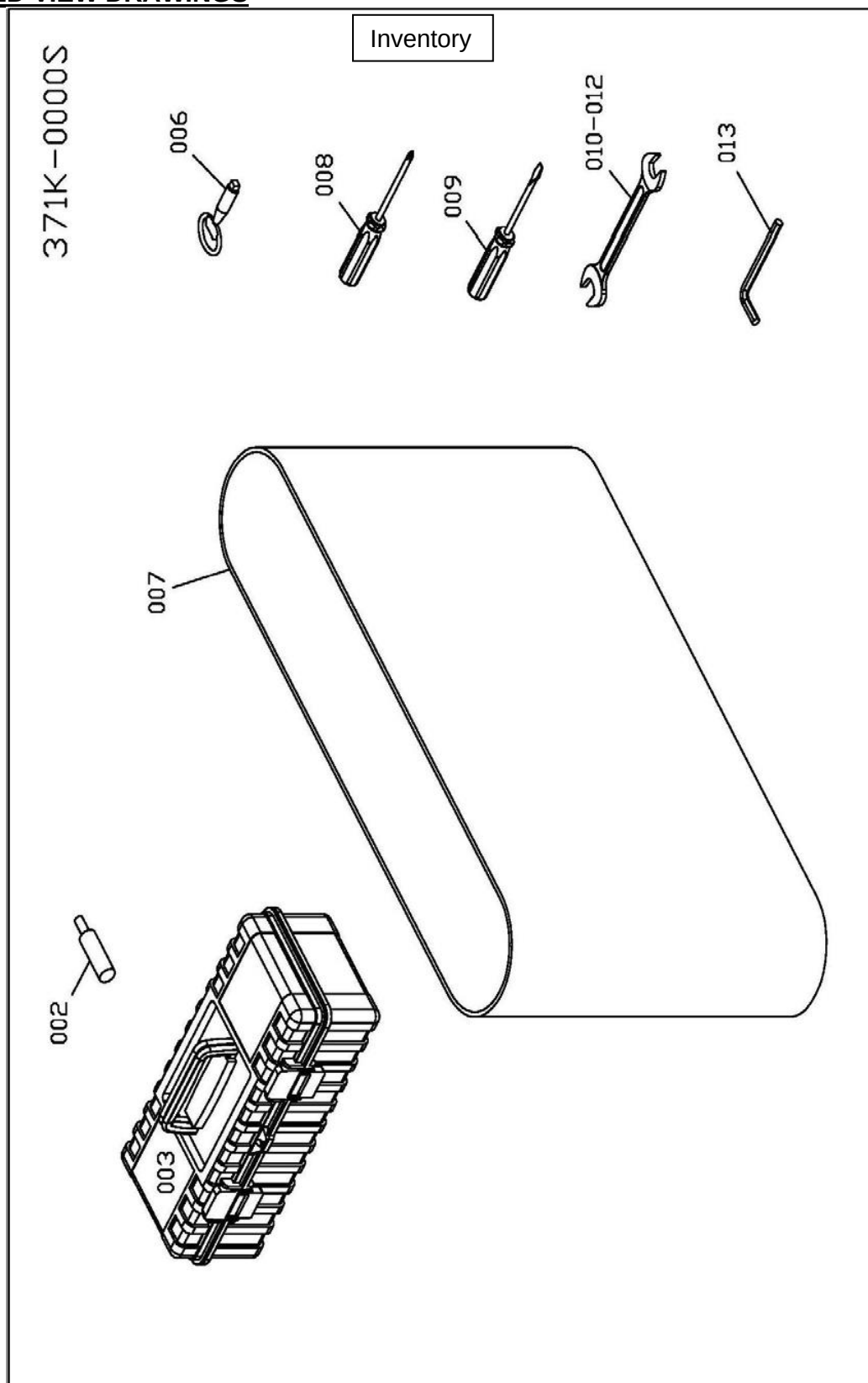
	Conveyor belt contaminated with sawdust.	Clean conveyor belt and check dust extraction for blockages.
Sanding belt hits ceramic switch.	Tracking out of adjustment.	Re-track the sanding belt.
Sanding belt will not track correctly.	Blocked tracking sensor.	Clear sensor blockage.
	Oscillation control valve not adjusted correctly (closed).	Adjust oscillation control valve.
	Belt not centralized on top roller.	Adjust sanding belt adjuster.
Sanding belt slips on rollers.	Tension cylinder not exerting sufficient pressure.	Check for air leaks. Low air pressure.
Sanding belt will not start.	No tension on the sanding belt.	No air pressure.
	Limit switch engaged.	Adjust sanding belt.
	Emergency stop button engaged.	Reset emergency stop button.



Electrical drawing



EXPLODED VIEW DRAWINGS



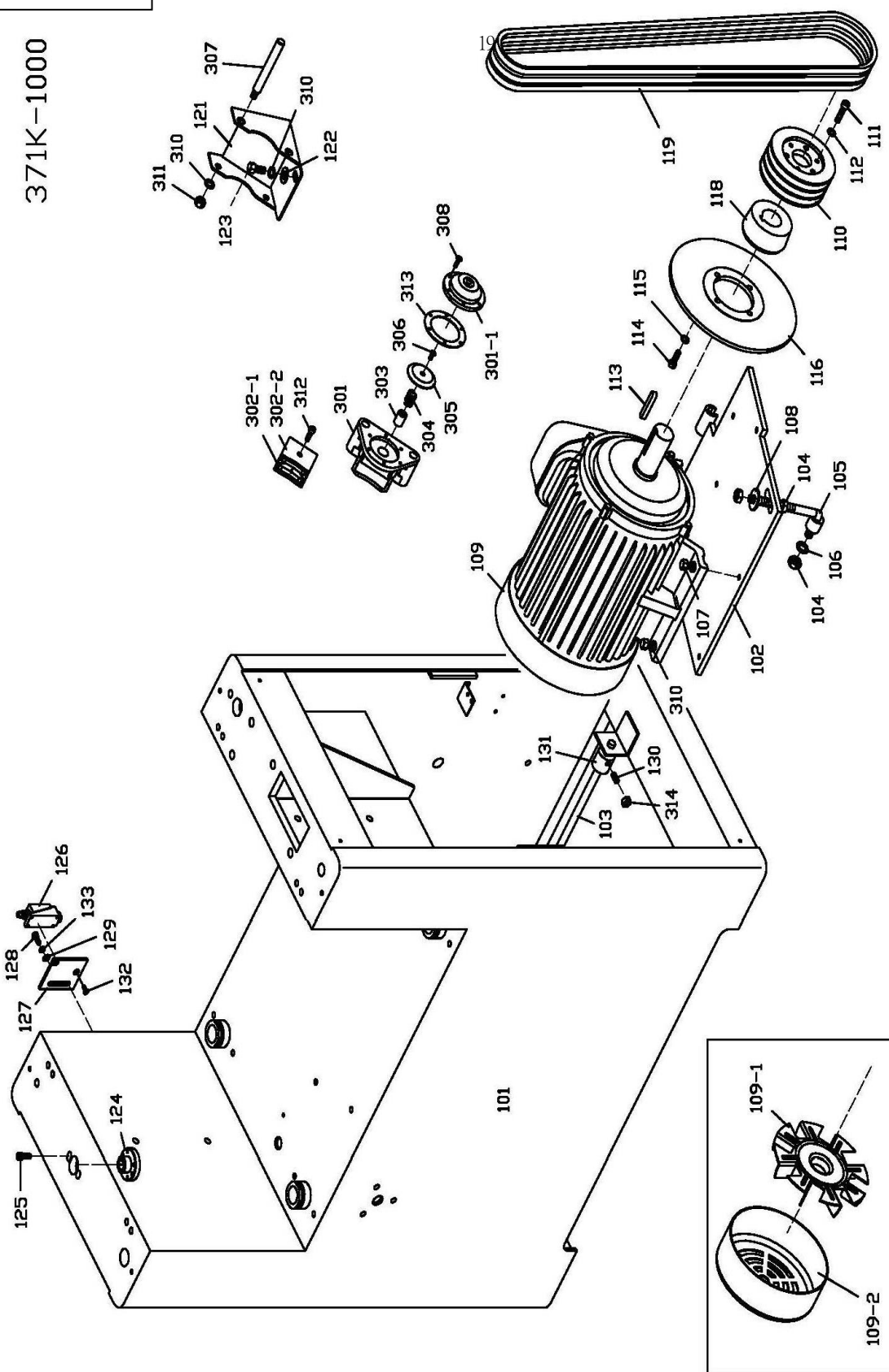
Inventory

0000	
ITEM NO	DESCRIPTION
002	LIMIT SWITCH TUBE
003	TOOLBOX
006	KEY
007-1	SANDING BELT #100
007-2	SANDING BELT #180
008	PHILLIP'S SCREWDRIVER
009	FLAT SCREWDRIVER
010	WRENCH 8 X 10
011	WRENCH 12 X 14
012	WRENCH 17 X 19
013	HEX WRENCH



Main Motor

371K-1000

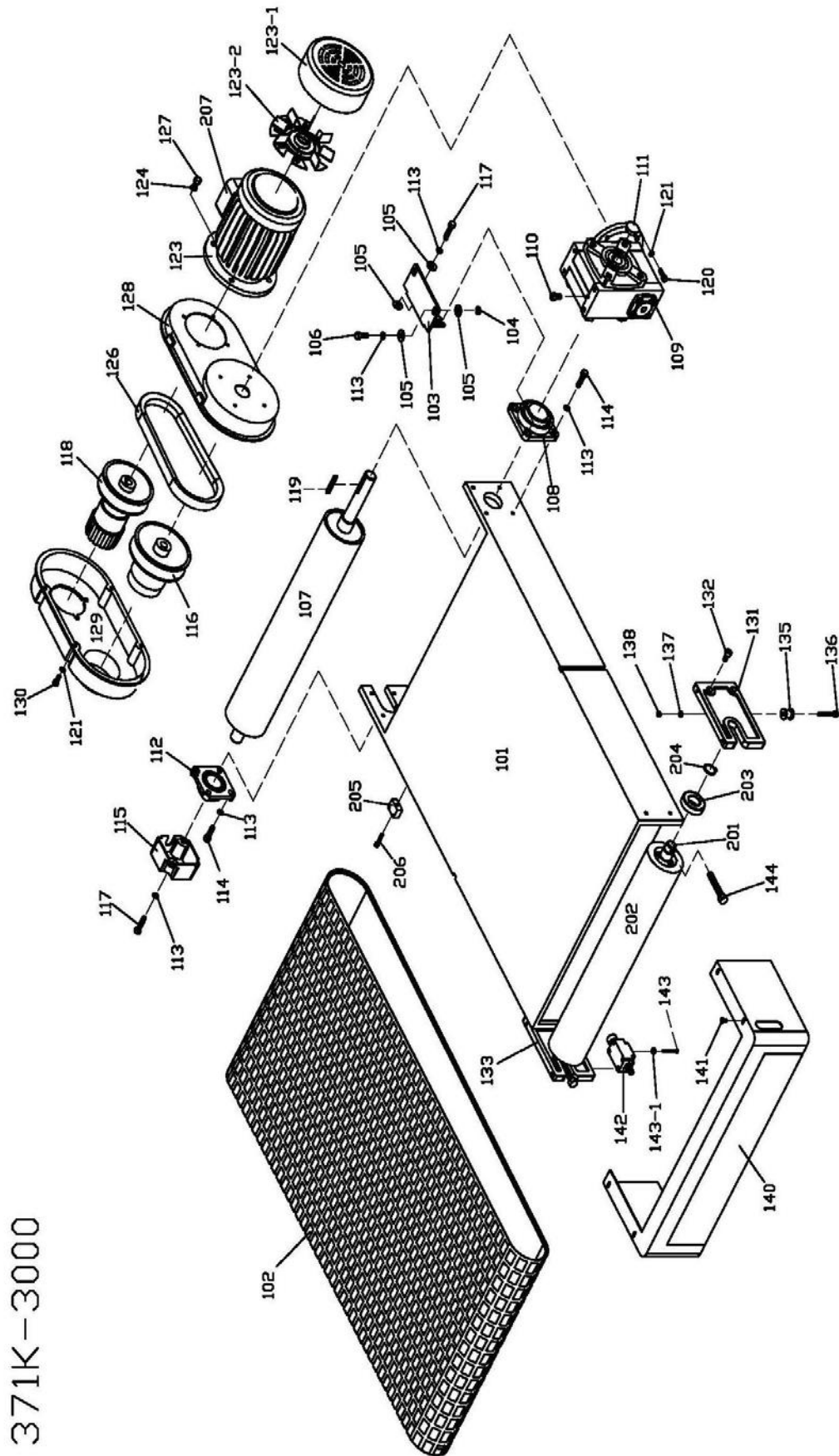


1000		Main Motor	1000	
ITEM NO	DESCRIPTION		ITEM NO	DESCRIPTION
101	MACHINE FRAME		126	LIMIT SWITCH
102	MOTOR BASE		127	LIMIT SWITCH PLATE
103	MOTOR BASE HINGE		128	SCREW 1/4" X 1/2"
104	NUT 1/2"		129	PLAIN WASHER 1/4"
105	MOTOR BASE ADJUSTMENT ROD		132	FLAT HEAD SCREW
106	SPRING WASHER 1/2"		133	SPRING WASHER
107	SCREW		301	BRAKE BRACKET
108	PLAIN WASHER 1/2"		301-1	BRAKE BRACKET FRONT GUARD
109	MOTOR		302-1	BRAKE LINING
109-1	FAN		302-2	BRAKE LINING
109-2	FA COVER		303	BRAKE ARBOR
110	PULLEY		304	BRAKE SPRING
111	HEX SOCKET HEAD SCREW 5/16" X 1 1/4"		305	BRAKE INSIDE PIECE
112	SPRING WASHER 5/16"		306	FLAT HEAD SCREW 1/4" X 1/2"
113	KEY		307	BRAKE PIN
114	SCREW 5/16" X 1"		308	HEX SOCKET HEAD SCREW
115	SPRING WASHER 5/16"		310	SPRING WASHER 3/8"
116	DISC BRAKE		311	NUT 3/8"
118	PULLEY BUSHING		312	HEX SOCKET HEAD SCREW 1/4" X 5/8"
119	BELT		313	BRAKE GASKET
121	BRAKE BRACKET			
122	PLAIN WASHER 3/8"			
123	SCREW 3/8" X 3/4"			
124	FLAT HEAD NUT			
125	HEX SOCKET HEAD SCREW 1/4" X 3/4"			



2000		Elevation Components	2000	
ITEM NO	DESCRIPTION		ITEM NO	DESCRIPTION
101	ELEVATION SCREW		320	HEADLESS SCREW 1/4" X 1/2"
102	SCREW 5/16" X 1"		321	HAND WHEEL
103	PLAIN WASHER 5/16"		322	MOTOR BASE
104	SPRING WASHER 5/16"		323	SCREW 1/4" X 1"
105	SPRING WASHER 3/8"		324	SPRING WASHER 1/4"
106	SCREW 3/8" X 1"		325	MOTOR BASE ADJUSTMENT ROD
107	ELEVATION SLIDE		326	PLAIN WASHER 1/2"
108	DUST GUARD BELLOW		327	NUT 1/2"
109	SCREW 5/16" X 3/4"		328	SPRING WASHER 1/2"
110	SPRING WASHER 5/16"		331	MOTOR
111	CHAIN		332	NUT 1/4"
			333	SCREW 1/2" X 4 1/2" LONG
201	NUT HOUSING		334	PROXIMITY SWITCH FIXING PLATE
202	NUT		335	SCREW 1/4" X 1/2"
203	THRUST BEARING 51107		336	PROXIMITY SWITCH
204	"C" CIRCLIP S 35		337	ROUND PHILLIP'S SCREW M3 X 35MM
206	SPROCKET WHEEL		338	NUT M3
			339	KEY 5/16" X 20MM
301	ELEVATION GEAR BOX		340	KEY
302	WORM GEAR		341	KEY
303	BEARING 6005Z			
304	BEARING CAP		401	SPROCKET WHEEL ADJUSTMENT PIECE
305	HEX SOCKET HEAD SCREW 1/4" X 3/4"		402	SPROCKET WHEEL SHAFT
306	WORM SHAFT		403	BEARING 6003ZZ
307	BEARING 6002Z		404	ADJUSTMENT SPROCKET WHEEL
308	BEARING CAP		405	SPROCKET WHEEL ADJUSTMENT ROD
309	HEX SOCKET HEAD SCREW		406	PLAIN WASHER 3/8"
310	BEARING CAP		407	NUT 3/8"
311	HEX SOCKET HEAD SCREW 1/4" X 5/8"		408	NUT 5/16"
312	SPROCKET WHEEL		409	SPRING WASHER 5/16"
313	HEADLESS SCREW 5/16" X 1/2"		410	SCREW 5/16" X 3/4"
314	PULLEY		411	MOTOR BASE
315	BELT			
316	PULLEY			
317	HEADLESS SCREW 1/4" X 1/2"			
318	SPRING WASHER 5/16"			
319	SCREW 5/16" X 3/4"			



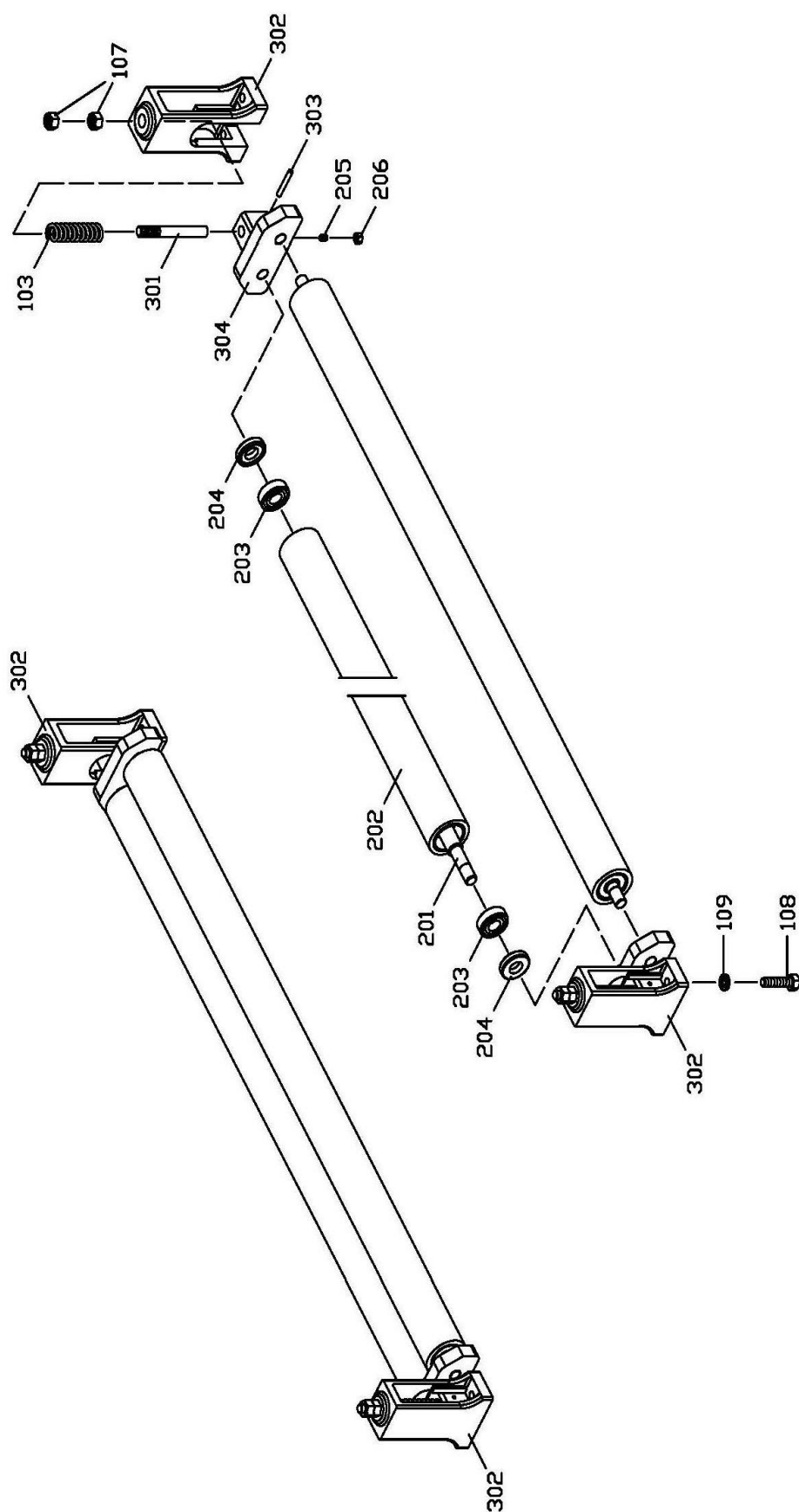


3000		Conveyor	3000	
ITEM NO	DESCRIPTION		ITEM NO	DESCRIPTION
101	CONVEYOR TABLE		142	LIMIT SWITCH
102	CONVEYOR BELT		143	ROUND PHILLIP'S SCREW
103	REDUCER FIX PLATE		144	SCREW 1/2" X 3" LONG
104	CUSHION			
105	PLAIN WASHER 3/8"		201	INFEED ROLLER SHAFT
106	SCREW 3/8" X 1"		202	INFEED ROLLER
107	OUTFEED ROLLER		203	BEARING
108	BEARING UCF 205		204	"C" CIRCLIP S30
109	REDUCER		205	ELEVATION ALUMINUM LIMITER
110	PLUG		206	HEX SOCKET HEAD SCREW
111	PLUG			
112	BRAING UCF 205			
113	SPRING WASHER 3/8"			
114	SCREW 3/8" X 1 1/4"			
115	BEARING CAP			
116	DRIVEN PULLEY			
117	SCREW 3/8" X 1 1/2"			
118	DRIVING PULLEY			
119	KEY 7MM X 55MM			
120	SCREW M8 X 25MM			
121	SPRING WASHER 8MM			
123	MOTOR			
124	SPRING WASHER 10MM			
126	TIMING BELT			
127	SCREW M10 X 25MM			
128	VARIABLE SPEED UNIT BASE PLATE			
129	VARIABLE SPEED UNIT COVER			
130	HEADLESS SCREW M8 X 20MM			
131	INFEED ROLLER BRACKET			
132	HEX SOCKET HEAD SCREW 3/8" X 3/4"			
133	INFEED ROLLER BRACKET			
135	CONVEYOR BELT POSITIONING WHEEL			
136	HEX SOCKET HEAD SCREW 5/16" X 2"			
137	SPRING WASHER 5/16"			
138	NUT 5/16"			
140	FRONT BRAKE COVER			
141	ROUND PHILLIP'S SCREW 1/4" X 1/2"			



Hold-Down Components

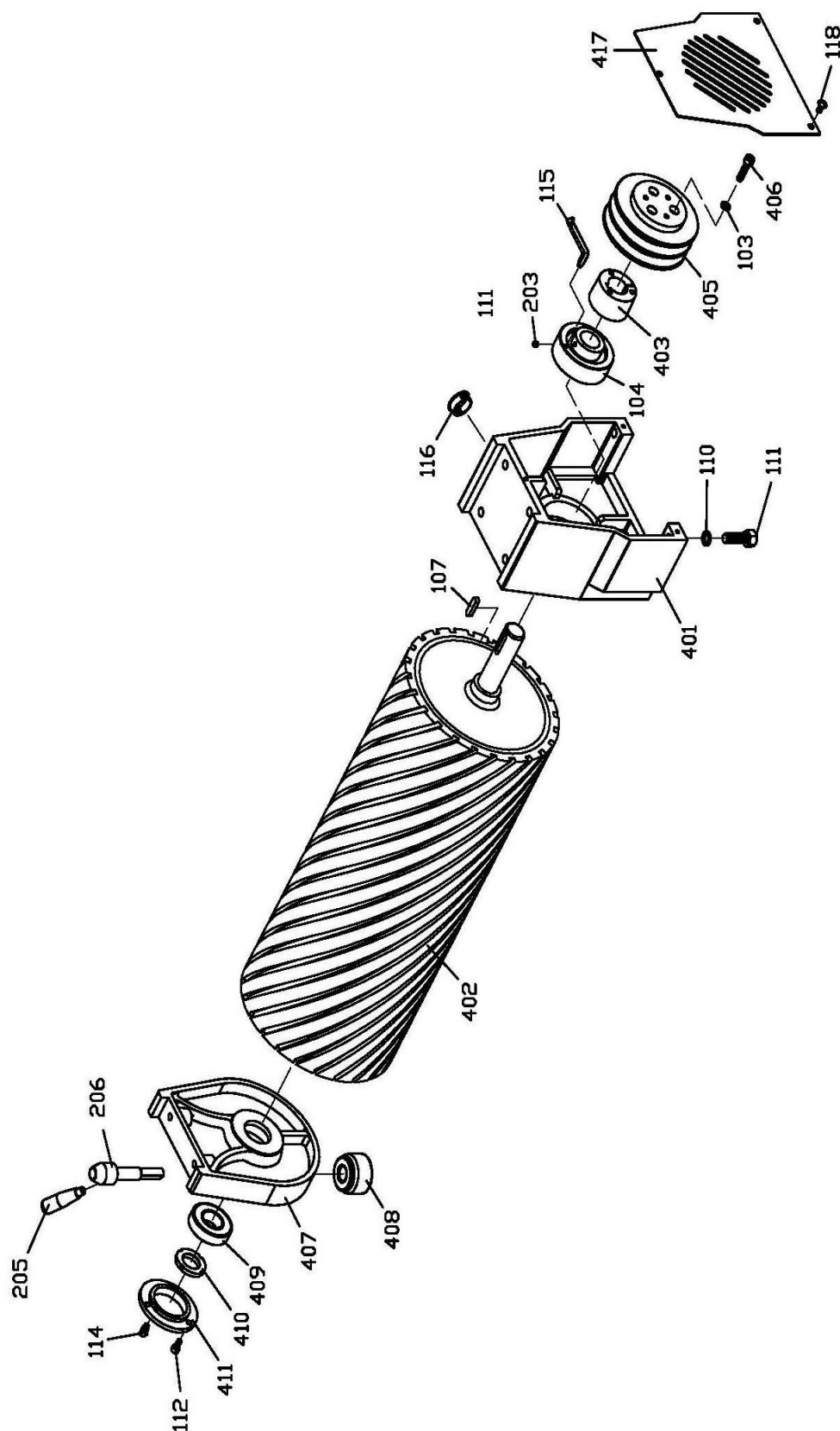
371K-4000



4000		Hold-Down Components	
ITEM NO	DESCRIPTION		
103	SPRING 3 X 15.6 X 57		
107	HEX NUT 3/8"-18		
108	HEX BOLT 5/16"-18 x 1-1/4"		
109	LOCK WASHER 5/16"		
201	PISTON ROLLER SHAFT		
202	PISTON ROLLER		
203	BEARING 6001 2RS		
204	SHAFT BEARING COLLAR		
205	HEADLESS SCREW 1/4"-20x3/4"		
206	HEX NUT 1/4"		
301	PISTON ROLLER ADJ. ROD		
302	PISTON BRACKET		
303	PIN 3x27MM		
304	PISTON SLIDERAIL		



371K-5000S

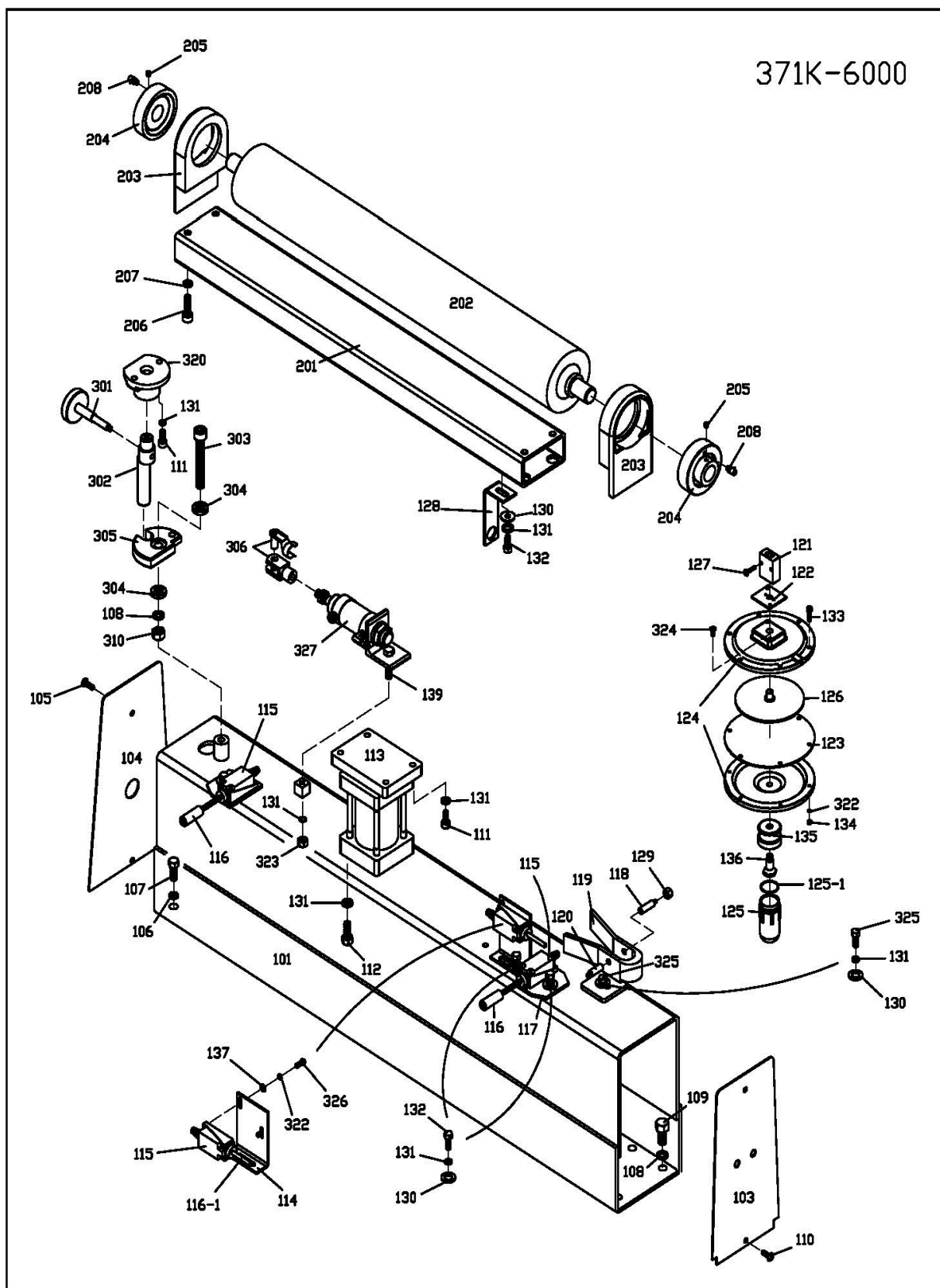


5000		Contact Roller
ITEM NO	DESCRIPTION	
104	BEARING UCC206	
103	LOCK WASHER 5/16"	
107	KEY 5/16"x5/16"x 30MM	
110	LOCK WASHER 1/2"	
111	CAP SCREW 1/2"-12 x 1-1/2"	
112	CAP SCREW 1/4"-20 x 1/2"	
114	FILTER	
115	GREASE FITTING 1/16 W/CAP 90 DEG	
116	PLUG 30mm	
118	PHLP HD SCR 1/4"-20 x 1/2"	
203	CAP SCREW M6-1.0 x 6	
205	HANDLE	
206	ROLLER LOCKDOWN SHAFT	
401	BEARING HOUSING	
402	RUBBER ROLLER	
403	FASTENING TUBE	
405	PULLEY	
406	CAP SCREW 5/16"-18 x 1-1/4"	
407	BEARING HOUSING	
408	BEARING BRACKET PAD	
409	BEARING 6205-2RS	
410	SCREW CAP	
411	BEARING CAP	
417	PULLEY COVER	



Idle Roller

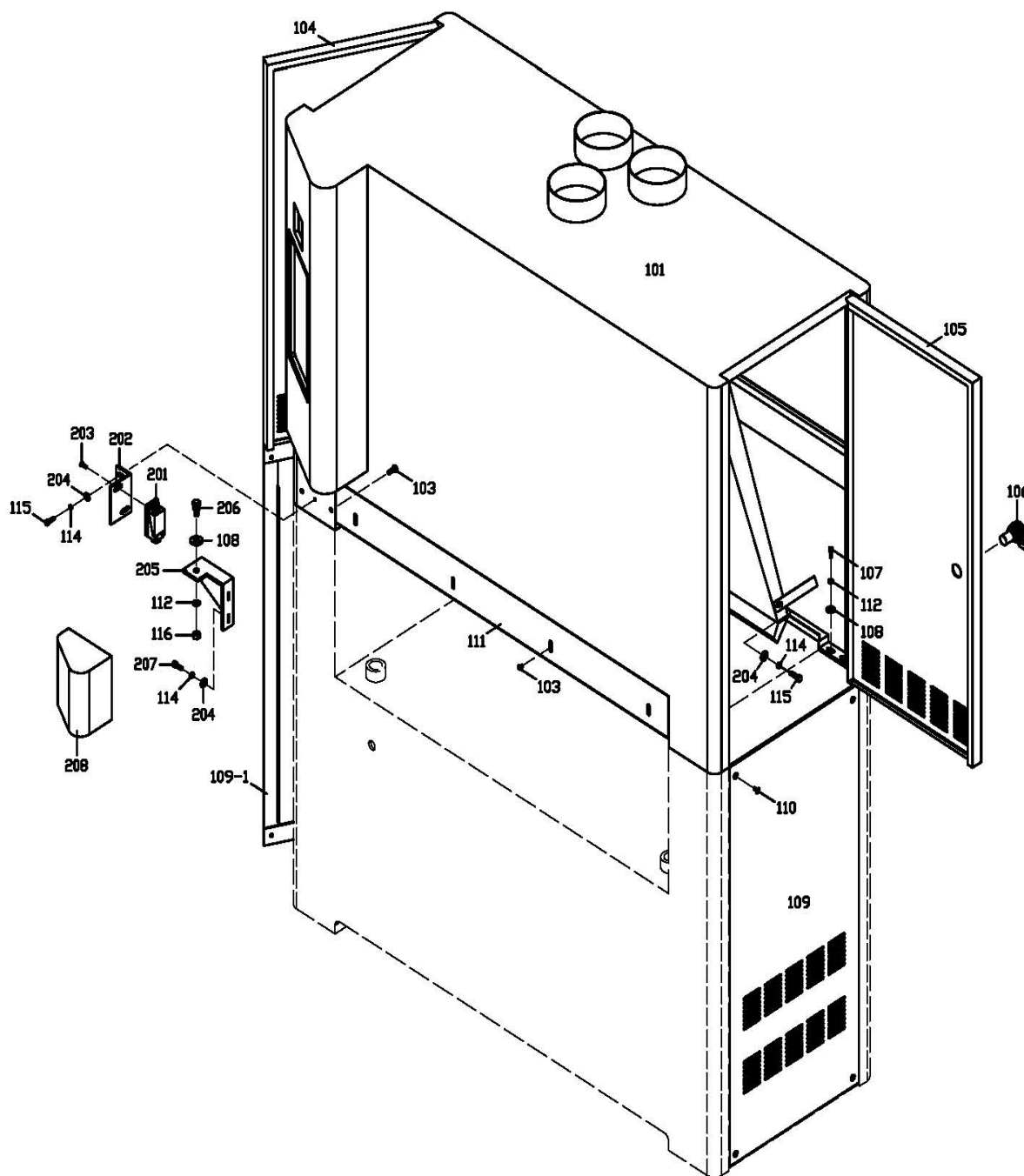
371K-6000



6000		Idle Roller	6000	
ITEM NO	DESCRIPTION		ITEM NO	DESCRIPTION
101	SQUARE FRAME		201	UPPER ROLLER BRACKET
103	SQUARE FRAME SEAL (RIGHT)		202	UPPER ROLLER
104	SQUARE FRAME SEAL (LEFT)		203	UPPER ROLLER BRACKET
105	FLAT HEAD SCREW 1/4" X 1/2"		204	BEARING UCC205
106	SPRING WASHER 3/8"		205	HEADLESS SCREW M6 X 6MM
107	SCREW 3/8" X 1"		206	HEX SOCKET HEAD SCREW
108	SPRING WASHER 1/2"		207	SPRING WASHER 3/8"
109	SCREW 1/2" X 1"		208	FILTER
111	HEX SOCKET HEAD SCREW 5/16" X 3/4"			
112	SCREW M8 X 20MM		301	TRIMMING SCREW
113	AIR CYLINDER		302	ECCENTRIC ROD
114	LIMIT SWITCH HOLDER (L TYPE)		303	HEX SOCKET HEAD SCREW 1/2" X 3 1/2"
115	LIMIT SWITCH		304	PLAIN WASHER 1/2"
116	LIMIT SWITCH TUBE		305	ECCENTRIC PIECE
117	LIMIT SWITCH HOLDER		306	UNIVERSAL JOINT FORK
118	AIR SENSOR NOZZLE (FEMALE)		310	NUT 1/2"
119	AIR CYLINDER BRACKET		320	FRAME OF ECCENTRIC SHAFT
120	AIR SENSOR NOZZLE (MALE)		322	SPRING WASHER 3/16"
121	THROTTLE VALVE		323	NUT 5/16"
122	THROTTLE VALVE BASE		324	SPRING M4 X 12L
123	PLATE		325	HEX SOCKET HEAD SCREW 5/16" X 3/4"
124	ALUMINUM DISC		326	SCREW M5 X 8L
125	OIL CAP		327	AIR CYLINDER 30*4
126	ALUMINUM PLATE			
127	SCREW M4 X 20MM			
128	SANDING BELT POWER OFF PLATE			
129	NUT 3/8"			
130	FLAT WASHER 5/16"			
131	SPRING WASHER 5/16"			
132	SCREW 5/16" X 3/4"			
133	SCREW 3/16" X 3/4"			
134	NUT 3/16"			
135	CONNECTOR OF OIL CAP			
136	SHAFT OF OIL CAP			
137	FLAT WASHER 3/16"			
139	HEX SOCKET HEAD SCREW 5/16" X 1 1/2"			



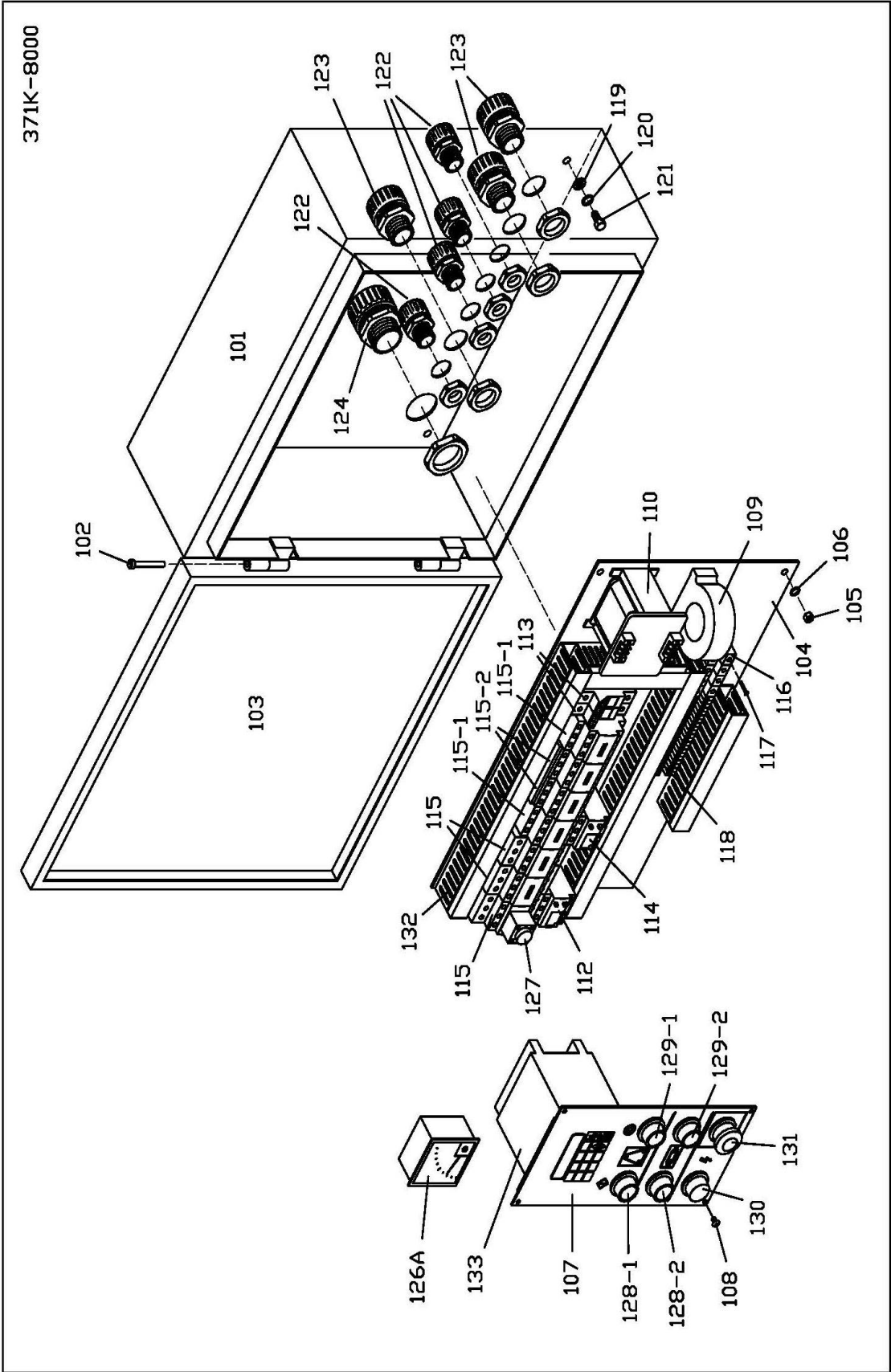
371K-7000S



7000		Cabinet/Frame	
ITEM NO	DESCRIPTION		
101	UPPER FRAME COVER		
103	HEAD SCREW M6		
104	LEFT DOOR, UPPER FRAME		
105	RIGHT DOOR, UPPER FRAME		
106	DOOR LOCK		
107	SCREW 5/16"		
108	PLAIN WASHER 5/16"		
109	RIGHT DOOR, LOWER FRAME		
109-1	LEFT DOOR, LOWER FRAME		
110	SCREW 1/4"		
111	FRONT PROTECTION PLATE		
112	SPRING WASHER 1/4"		
114	SPRING WASHER 1/4"		
115	HEAD SCREW M6		
201	LIMIT SWITCH		
202	LIMIT SWITCH PLATE		
203	ROUND PHILLIP'S SCREW 5X10 MM		
204	PLAIN WASHER 1/4"		
205	FIXED PLATE		
206	THICKNESSER		
207	CAP 1/4 X 3/4		
208	COVER		

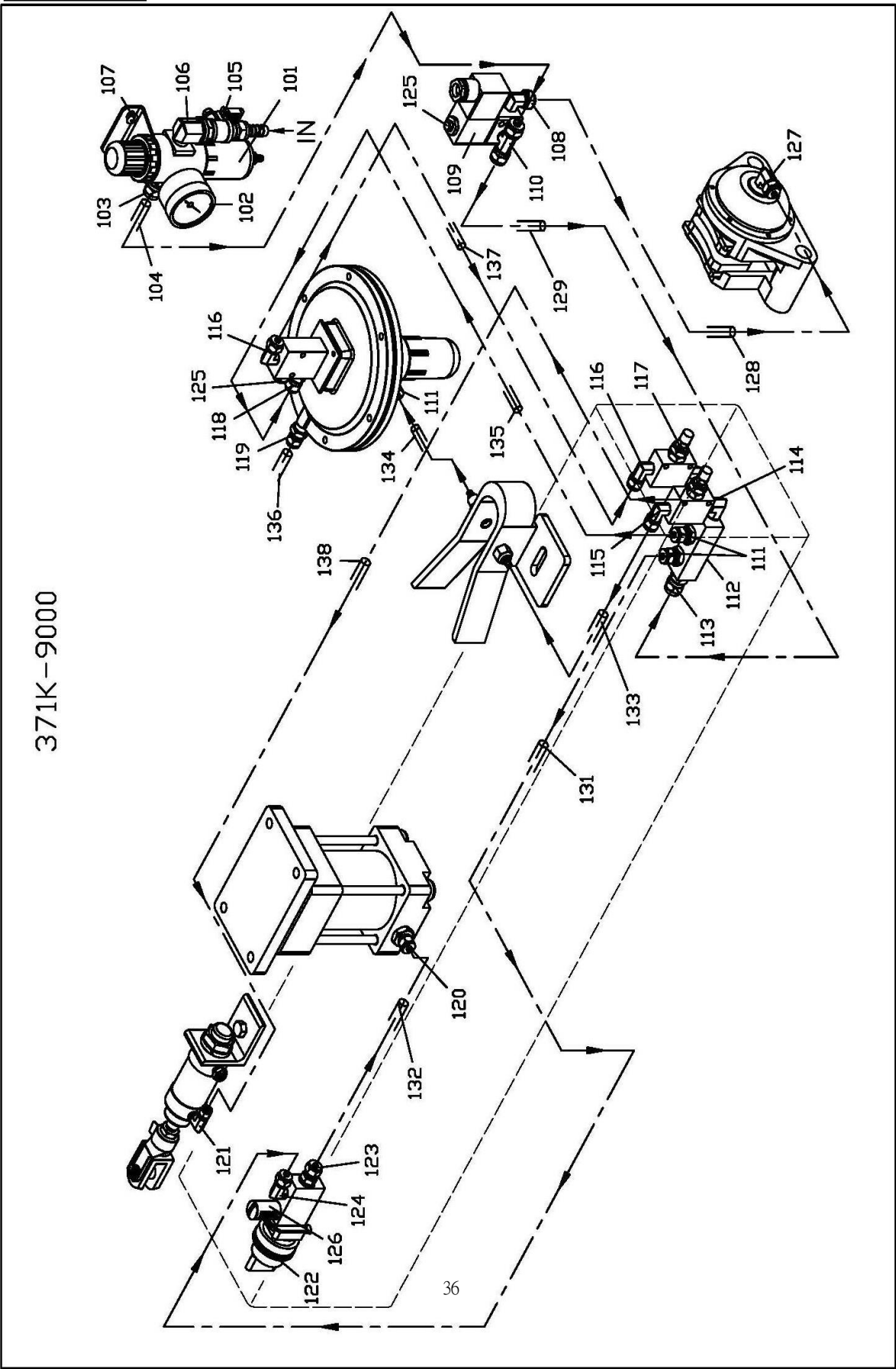


ELECTRICAL PARTS - 37 1K - THREE PHASE



8000		Electrical	8000	
ITEM NO	DESCRIPTION		ITEM NO	DESCRIPTION
101	ELECTRICAL CONTROL BOX		128-1	START SWITCH
102	HINGE		128-2	START SWITCH
103	ELECTRICAL CONTROL BOX OF DOOR		129-1	STOP SWITCH
104	BASE PLATE		129-2	STOP SWITCH
105	NUT 1/4"		130	POWER INDICATION LIGHT
106	SPRING WASHER 1/4"		131	EMERGENCY STOP SWITCH
107	CONTROL PANEL		132	WIRE COLUMN
108	PHILLIP'S SCREW M4 X 8MM		133	COMPUTER
109	PROPORTIONAL CURRENT DEVICE			
110	TRANSFORMER: 3PH ONLY			
112	OVERLOAD RELAY			
113	FUSE			
114	OVERLOAD RELAY			
115	CONTACTOR			
115-1	CONTACTOR			
115-2	CONTACTOR WITH LOCK			
116	POWER WIRE TERMINAL			
117	PHILLIP'S SCREW M4 X 30MM			
118	TERMINAL PLATE			
119	PLAIN WASHER 1/4"			
120	SPRING WASHER 1/4"			
121	SCREW 1/4" X 1/2"			
122	PU CONNECTOR 1/2"			
123	PU CONNECTOR 3/4"			
124	CABLE CONNECTOR 1"			
126A	AMP METER			
127	TIMER			





9000		Air System		9000	
ITEM NO	DESCRIPTION			ITEM NO	DESCRIPTION
101	FILTER CUP			128	FLEXIBLE HOSE
103	BRONZE CONNECTOR			129	FLEXIBLE HOSE
104	FLEXIBLE HOSE			131	FLEXIBLE HOSE
105	AIR SWITCH			132	FLEXIBLE HOSE
106	ELBOW			133	FLEXIBLE HOSE
107	SCREW 3/16"			134	FLEXIBLE HOSE
108	CONNECTOR			135	FLEXIBLE HOSE
109	SOLENOID VALVE			136	FLEXIBLE HOSE
110	T-JOINT			137	FLEXIBLE HOSE
111	CONNECTOR			138	FLEXIBLE HOSE
112	MULTIPLE HOLE CONNECTOR				
113	CONNECTOR				
114	BRONZE ELBOW				
115	CONNECTOR				
116	CONNECTOR				
117	THROTTLE VALVE				
118	CONNECTOR				
119	BRONZE CONNECTOR				
120	CONNECTOR				
121	CONNECTOR				
122	AIR SWITCH				
123	CONNECTOR				
124	CONNECTOR				
125	BUFFER				
126	BUFFER				
127	CONNECTOR				





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