



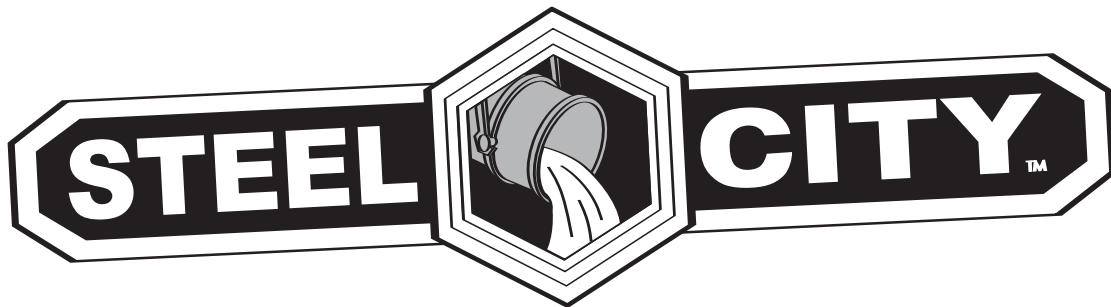
User Manual

Read and understand this manual before using machine.

16-32 DRUM SANDER

Model No.
55210





THANK YOU for purchasing your new Steel City Drum Sander. This drum sander has been designed, tested, and inspected with you, the customer, in mind. When properly used and maintained, your drum sander will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This drum sander is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your drum sander or Steel City Tool Works, please visit our web site at www.steelcitytoolworks.com .

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INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

WARRANTY

STEEL CITY TOOL WORKS 5 YEAR LIMITED WARRANTY

Steel City Tool Works, LLC (“SCTW”) warrants all “STEEL CITY TOOL WORKS” machinery to be free of defects in workmanship and materials for a period of 5 years from the date of the original retail purchase by the original owner. SCTW will repair or replace, at its expense and at its option, any SCTW machine, machine part, or machine accessory which in normal use has proven to be defective, provided that the customer returns the product, shipping prepaid, to an authorized service center with proof of purchase and provides SCTW with a reasonable opportunity to verify the alleged defect by inspection. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, or lack of maintenance, or to repairs or alterations made or specifically authorized by anyone other than SCTW. Normal wear components are also excluded under this coverage. Every effort has been made to ensure that all SCTW machinery meets the highest quality and durability standards. We reserve the right to change specifications at any time due to our commitment to continuous improvement of the quality of our products.

EXCEPT AS SET FORTH ABOVE, SCTW MAKES NO EXPRESS OR IMPLIED REPRESENTATIONS OR WARRANTIES WITH RESPECT TO ITS MACHINERY, OR ITS CONDITION, MERCHANTABILITY, OR FITNESS FOR ANY PARTICULAR PURPOSE OR USE. SCTW FURNISHES THE ABOVE WARRANTIES IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHICH ARE HEREBY SPECIFICALLY DISCLAIMED.

SCTW SHALL NOT BE LIABLE FOR ANY (A) SPECIAL, INDIRECT, INCIDENTAL, PUNITIVE OR CONSEQUENTIAL DAMAGES, INCLUDING WITHOUT LIMITATION LOSS OF PROFITS, ARISING FROM OR RELATED TO THIS WARRANTY, THE BREACH OF ANY AGREEMENT OR WARRANTY, OR THE OPERATION OR USE OF ITS MACHINERY, INCLUDING WITHOUT LIMITATION DAMAGES ARISING FROM DAMAGE TO FIXTURES, TOOLS, EQUIPMENT, PARTS OR MATERIALS, DIRECT OR INDIRECT LOSS CAUSED BY ANY OTHER PARTY, LOSS OF REVENUE OR PROFITS, FINANCING OR INTEREST CHARGES, AND CLAIMS BY ANY THIRD PERSON, WHETHER OR NOT NOTICE OF SUCH POSSIBLE DAMAGES HAS BEEN GIVEN TO SCTW; (B) DAMAGES OF ANY KIND FOR ANY DELAY BY OR FAILURE OF SCTW TO PERFORM ITS OBLIGATIONS UNDER THIS AGREEMENT; OR (C) CLAIMS MADE A SUBJECT OF A LEGAL PROCEEDING AGAINST SCTW MORE THAN ONE (1) YEAR AFTER SUCH CAUSE OF ACTION FIRST AROSE.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the laws of the Commonwealth of Pennsylvania, without regard to conflicts of laws provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW, or any claim related to the performance of any agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

STEEL CITY TOOL WORKS

WARRANTY CARD

Name _____
 Street _____
 Apt. No. _____
 City _____ State _____ Zip _____
 Phone Number _____
 E-Mail _____

Product Description: _____
 Model No.: _____
 Serial No. _____

The following information is given on a voluntary basis and is strictly confidential.

1. Where did you purchase your STEEL CITY machine?
 Store: _____
 City: _____

2. How did you first learn of Steel City Tool Works?
 Advertisement Mail Order Catalog
 Web Site Friend
 Local Store Other _____

3. Which of the following magazines do you subscribe to?
 American Woodworker American How-To
 Cabinetmaker Family Handyman
 Fine Homebuilding Fine Woodworking
 Journal of Light Construction Old House Journal
 Popular Mechanics Popular Science
 Popular Woodworking Today's Homeowner
 WOOD Woodcraft
 WOODEN Boat Woodshop News
 Woodsmith Woodwork
 Woodworker Woodworker's Journal
 Workbench Other _____

4. Which of the following woodworking / remodeling shows do you watch?
 Backyard America The American Woodworker
 Home Time The New Yankee Workshop
 This Old House Woodwright's Shop
 Other _____

5. What is your annual household income?
 \$20,000 to \$29,999 \$30,000 to \$39,999
 \$40,000 to \$49,999 \$50,000 to \$59,999
 \$60,000 to \$69,999 70,000 to \$79,999
 \$80,000 to \$89,999 \$90,000 +

6. What is your age group?
 20 to 29 years 30 to 39 years
 40 to 49 years 50 to 59 years
 60 to 69 years 70 + years

7. How long have you been a woodworker?
 0 to 2 years 2 to 8 years
 8 to 20 years over 20 years

8. How would you rank your woodworking skills?
 Simple Intermediate
 Advance Master Craftsman

9. How many Steel City machines do you own? _____

10. What stationary woodworking tools do you own?
Check all that apply.
 Air Compressor Band Saw
 Drill Press Drum Sander
 Dust Collection Horizontal Boring Machine
 Jointer Lathe
 Mortiser Panel Saw
 Planer Power Feeder
 Radial Arm Saw Shaper
 Spindle Sander Table Saw
 Vacuum Veneer Press Wide Belt Sander
 Other _____

11. Which benchtop tools do you own? *Check all that apply.*
 Belt Sander Belt / Disc Sander
 Drill Press Band Saw
 Grinder Mini Jointer
 Mini Lathe Scroll Saw
 Spindle / Belt Sander Other _____

12. Which portable / hand held power tools do you own?
Check all that apply.
 Belt Sander Biscuit Jointer
 Dust Collector Circular Saw
 Detail Sander Drill / Driver
 Miter Saw Orbital Sander
 Palm Sander Portable Thickness Planer
 Saber Saw Reciprocating Saw
 Router Other _____

13. What machines / accessories would you like to see added to the STEEL CITY line?

14. What new accessories would you like to see added?

15. Do you think your purchase represents good value?
 Yes No

16. Would you recommend STEEL CITY products to a friend?
 Yes No

17. Comments:

CUT HERE

FOLD ON DOTTED LINE

PLACE
STAMP
HERE

Steel City Tool Works
P.O. Box 10529
Murfreesboro, TN 37129

FOLD ON DOTTED LINE

PRODUCT SPECIFICATIONS

Drum Motor Specifications

| | |
|-------------------------------|----------------------------|
| Type | Induction, Ball Bearing |
| Continuous Duty Horsepower | 1-1/2 HP |
| Amps | 13 |
| Voltage | 115V |
| Phase | single |
| Hertz | 60 |
| RPM | 1720 (no load) |

Belt Feed Motor Specifications

| | |
|------------|-----------|
| Type | Universal |
| Horsepower | 1/15 HP |

Product Specifications

| | |
|----------------------------|------------------------------------|
| Maximum width of sanding | 16" (one pass) 32" (two passes) |
| Maximum thickness of board | 5" |
| Minimum thickness of board | 1/8" |
| Minimum board length | 6" |
| Feed rate | Variable (0-10 SFPM) |
| Drum Size | 5" x 16" |
| Drum Speed | 1725 R.P.M. |
| Dust Ports | 2-1/2" with 4" adapter |

Product Dimensions

| | |
|-----------|---------------|
| Footprint | 27" x 37-1/2" |
| Length | 37-1/2" |
| Width | 27" |
| Height | 61-1/2" |
| Weight | 163 lbs. |

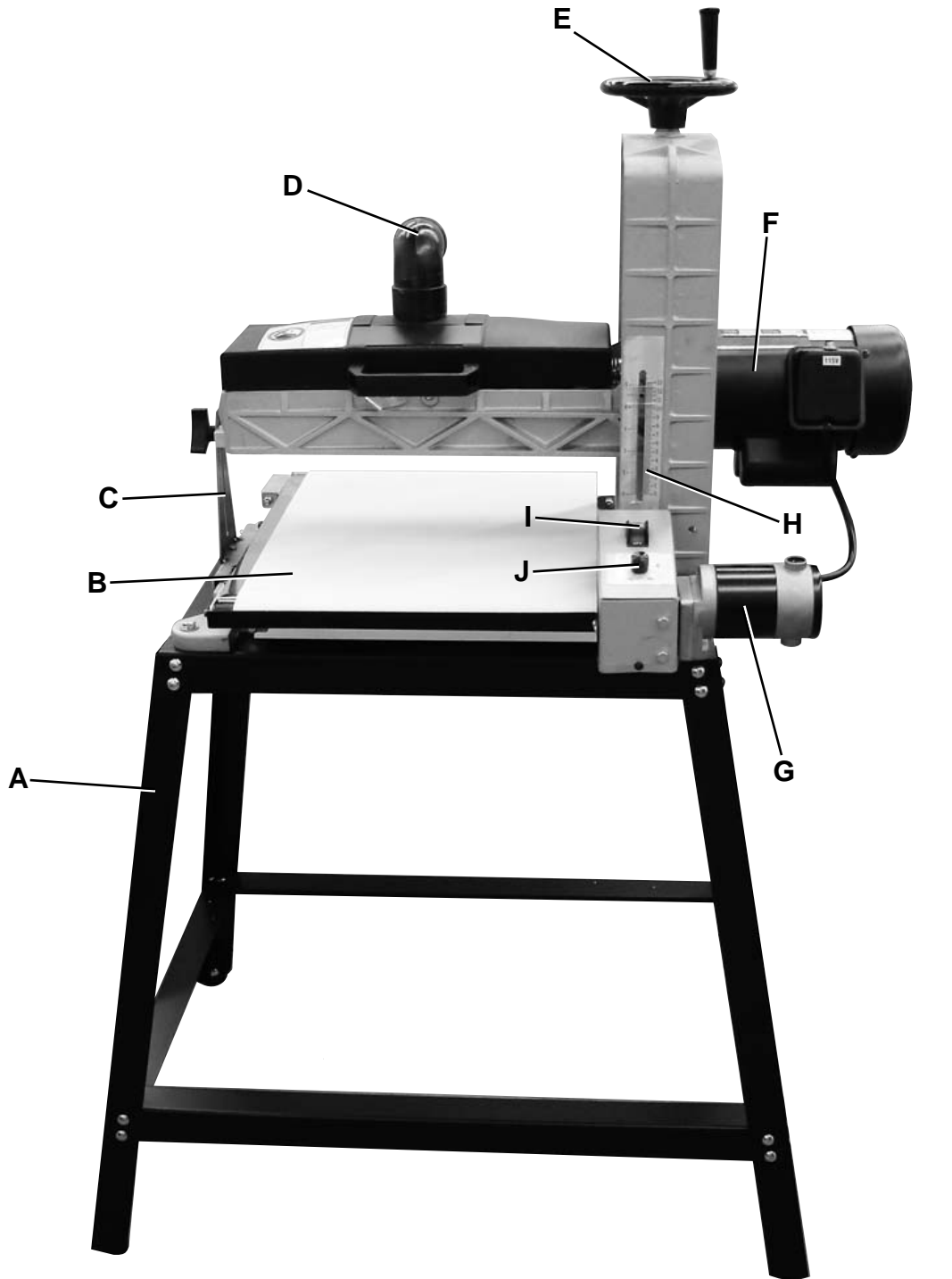
Shipping Dimensions

| | |
|--------------|---------------|
| Carton Type | Cardboard box |
| Length | 37" |
| Width | 25" |
| Height | 26-1/2" |
| Gross Weight | 172 lbs. |

ACCESSORIES AND ATTACHMENTS

There are a variety of accessories available for your Steel City Product. For more information on any accessories associated with this and other machines, please contact your nearest Steel City distributor, or visit our website at: www.steelcitytoolworks.com.

FEATURE IDENTIFICATION



- A. STAND
- B. CONVEYOR BELT
- C. STABILIZER BRACKET
- D. DUST PORT
- E. RAISE / LOWER HANDWHEEL

- F. SANDING DRUM MOTOR
- G. CONVEYOR BELT MOTOR
- H. DEPTH SCALE
- I. ON / OFF SWITCH
- J. VARIABLE SPEED CONTROL KNOB

GENERAL SAFETY

⚠ WARNING

TO AVOID serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

⚠ DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

⚠ WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

⚠ CAUTION

Indicates a potentially hazardous situation, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

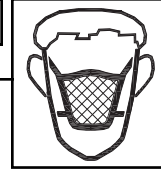
CAUTION

CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

⚠ WARNING



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

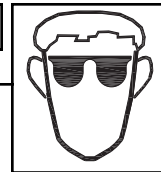
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

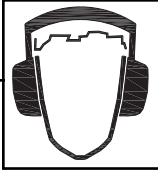
1. To avoid serious injury and damage to the machine, read the entire User Manual before assembly and operation of this machine.

⚠ WARNING



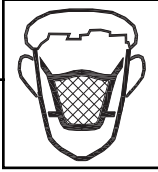
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

▲ WARNING



3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

▲ WARNING



4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that has slippery floor surfaces from debris, grease, and wax.
6. **ALWAYS** unplug the machine from the electrical receptacle when making adjustments, changing parts or performing any maintenance.
7. **AVOID ACCIDENTAL STARTING.** Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

▲ WARNING



8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain or moisture.

▲ WARNING



9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.
12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.
13. **DO NOT** store anything above or near the machine.
14. **DO NOT** operate any machine or tool if under the influence of drugs, alcohol, or medication.
15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.
16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.
17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.
18. **KEEP** protective guards in place and in working order.
19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.
20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.
21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.
22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.
23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.
24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
27. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
28. Information regarding the safe and proper operation of this tool is also available from the following sources:

Power Tool Institute
1300 Summer Avenue
Cleveland, OH 44115-2851
www.powertoolinstitute.org

National Safety Council
1121 Spring Lake Drive
Itasca, IL 60143-3201

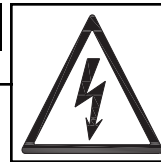
American National Standards Institute
25 West 43rd Street, 4th floor
New York, NY 10036
www.ansi.org

ANSI 01.1 Safety Requirements for
Woodworking Machines, and the U.S. Department
of Labor regulations
www.osha.gov

PRODUCT SAFETY

1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

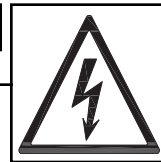
▲ WARNING



4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.

5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
7. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
8. **ALWAYS** turn the power switch "OFF" before unplugging the drum sander.

▲ WARNING



9. **DO NOT** handle the plug or drum sander with wet hands.

10. **USE** accessories only recommended by Steel City.
11. **DO NOT** pull the drum sander by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.
12. **DO NOT** unplug the drum sander by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.
13. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. If the drum sander is not operating properly, or has been damaged, left outdoors or has been in contact with water.
14. **DO NOT** use the drum sander as a toy. **DO NOT** use near or around children.

15. **ALWAYS** wear eye protection. The operation of any drum sander can result in debris being thrown into your eyes, causing severe eye damage. Everyday glasses are not safety glasses. Wear safety glasses that comply with ANSI standard Z87.1
16. **KEEP** hands and clothing away from the rotating drum, belts and pulleys. **NEVER** place hands under the drum or dust cover.
17. **ALWAYS** feed workpieces against the rotation of the drum.
18. **HOLD** workpieces firmly and be aware of the possibility of kickback.
19. **DO NOT** make passes deeper than recommended in the specifications to avoid damage to the machine.
20. **NEVER** operate the machine without the dust cover in position.
21. **ALWAYS** stand to one side of the workpiece; **NEVER** stand directly in line with it.
22. **NEVER** force the workpiece into the sander; allow the feed belt to move the workpiece at the proper speed.
23. **MAKE SURE** that the workpiece has no loose knots, screws, nails or other foreign objects that might damage the feed belt or sanding drum.
24. **ALWAYS** keep bystanders and yourself away from the infeed and outfeed ends when a workpiece is fed into the sander.
25. **ALWAYS** keep your hands away from the sanding drum during operation.
26. **ALWAYS** keep fingers away from the conveyor and the underside of the workpiece during sander and conveyor operation.
27. **ALWAYS** adjust the conveyor feed rate and sanding drum height, so when you feed the workpiece into the sander using light pressure, you do not overload the sander. **NEVER** force the workpiece into the sander.
28. **ALWAYS** shut the sander down, let the drum come to a complete stop, and disconnect power or engage applicable safety-lock devices before you service, adjust, troubleshoot, or leave the machine unattended.
29. **ALWAYS** keep this machine in correct adjustment and properly serviced. **NEVER** attempt to clear a jammed workpiece while the sander is running.
30. **ALWAYS** replace the sandpaper when it is worn, and use only undamaged sandpaper.
31. **NEVER** sand if there is any doubt about the stability or integrity of the workpiece.
32. **NEVER** sand stock smaller than 1/8" thick or 6" long.
33. **NEVER** adjust the conveyor belt tracking when the sanding drum is engaged.
34. **NEVER** use the sander without a dust collection system.

ELECTRICAL REQUIREMENTS

WARNING

TO PREVENT electrical shock, follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

TO REDUCE the risk of electrical shock, **DO NOT** use machine outdoors. **DO NOT** expose to rain. Store indoors in a dry area.

DO NOT connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

The motor in this machine is designed to run at 115V.

GROUNDING INSTRUCTIONS

⚠ WARNING



This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

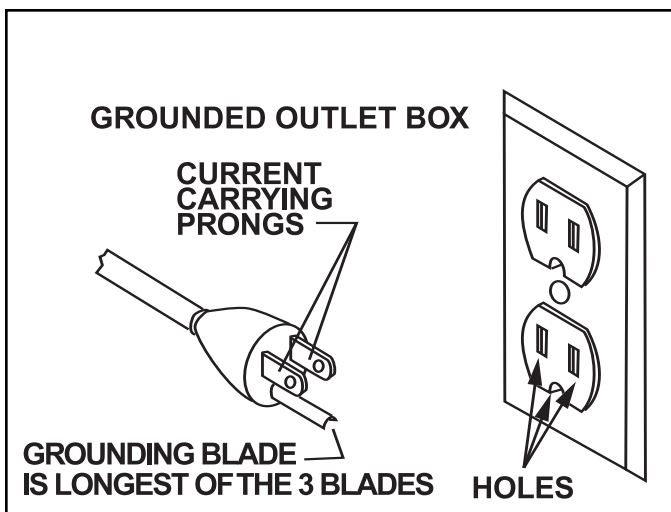
In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. This machine is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

IMPROPER ELECTRICAL CONNECTION of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

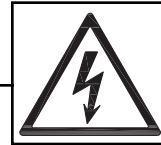
Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

Fig. 1-1



PLUGS/RECEPTACLES

⚠ WARNING

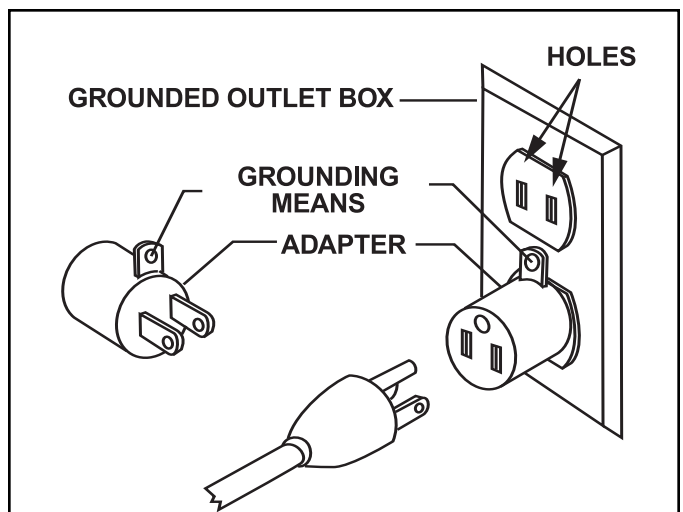


- Electrocutation or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 115 volt motor. It is shipped wired for 115 volt application. Never connect the green or ground wire to a live terminal.

This tool is intended for use on a circuit that has an electrical receptacle as shown in Figure 1-1. Figure 1-1 shows a NEMA approved 3-wire, 15 amp electrical plug and receptacle that have a grounding conductor. If a properly grounded electrical receptacle is not available, an adapter as shown in Figure 1-2 can be used to temporarily connect this plug to a 2-contact ungrounded receptacle. The adapter has a rigid lug extending from it that **MUST** be connected to a permanent earth ground, such as a properly grounded receptacle box. **THIS ADAPTER IS PROHIBITED IN CANADA.**

Fig. 1-2



EXTENSION CORDS

⚠ WARNING



To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

⚠ CAUTION

USE ONLY a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

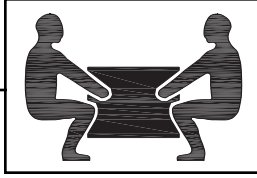
Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)

| 115 VOLT OPERATION ONLY | | | |
|-------------------------|----------|----------|-----------------|
| | 25' LONG | 50' LONG | 100' LONG |
| 0 to 6 Amps | 18 AWG | 16 AWG | 16 AWG |
| 6 to 10 Amps | 18 AWG | 16 AWG | Not recommended |
| 10 to 12 Amps | 16 AWG | 16 AWG | Not recommended |

UNPACKING & INVENTORY

⚠ WARNING



- The machine is heavy, two people are required to unpack and lift.

Check shipping carton and machine for damage before unpacking. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

Remove any protective materials and coatings from all of the parts and the drum sander. The protective coat-

ings can be removed by spraying WD-40 on them and wiping it off with a soft cloth. This may need redone several times before all of the protective coatings are removed completely.

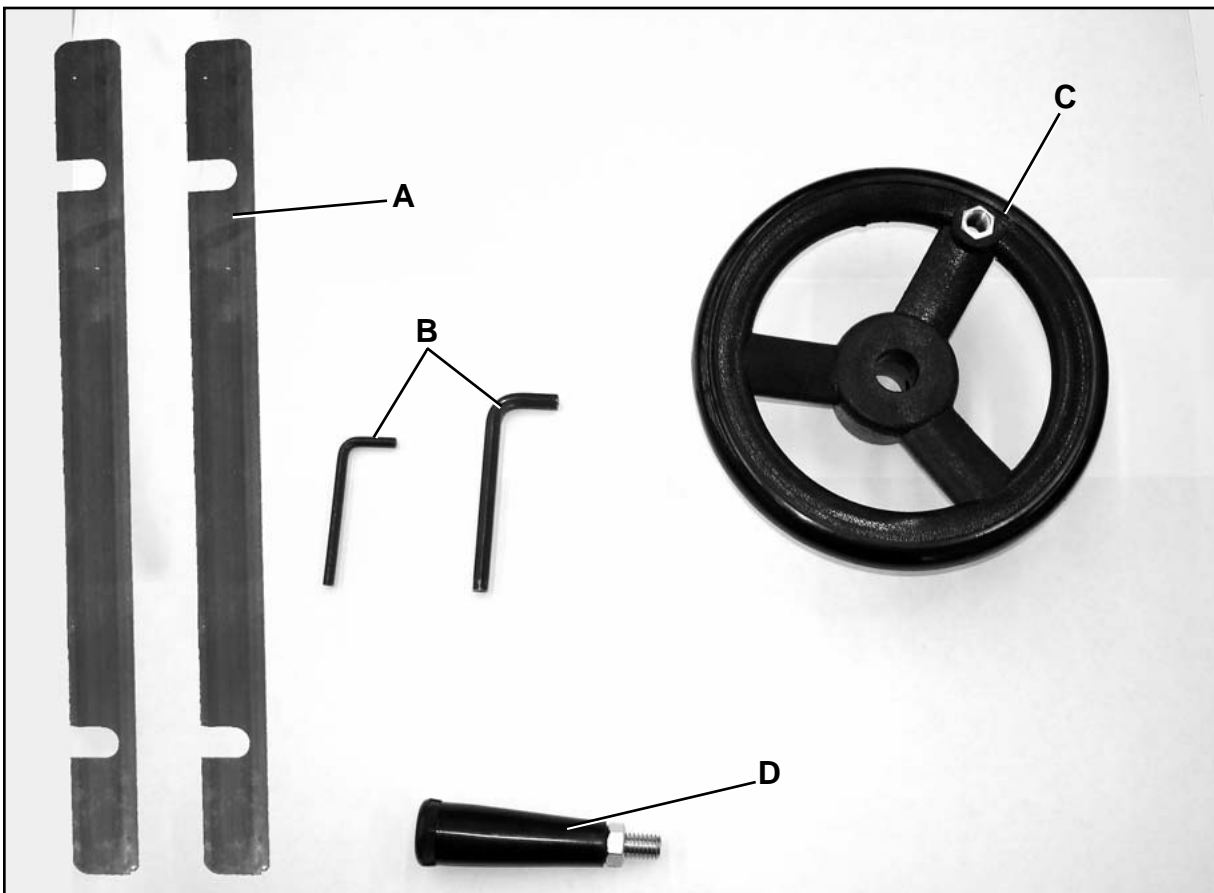
After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Compare the items to inventory figures; verify that all items are accounted for before discarding the shipping box.

⚠ WARNING

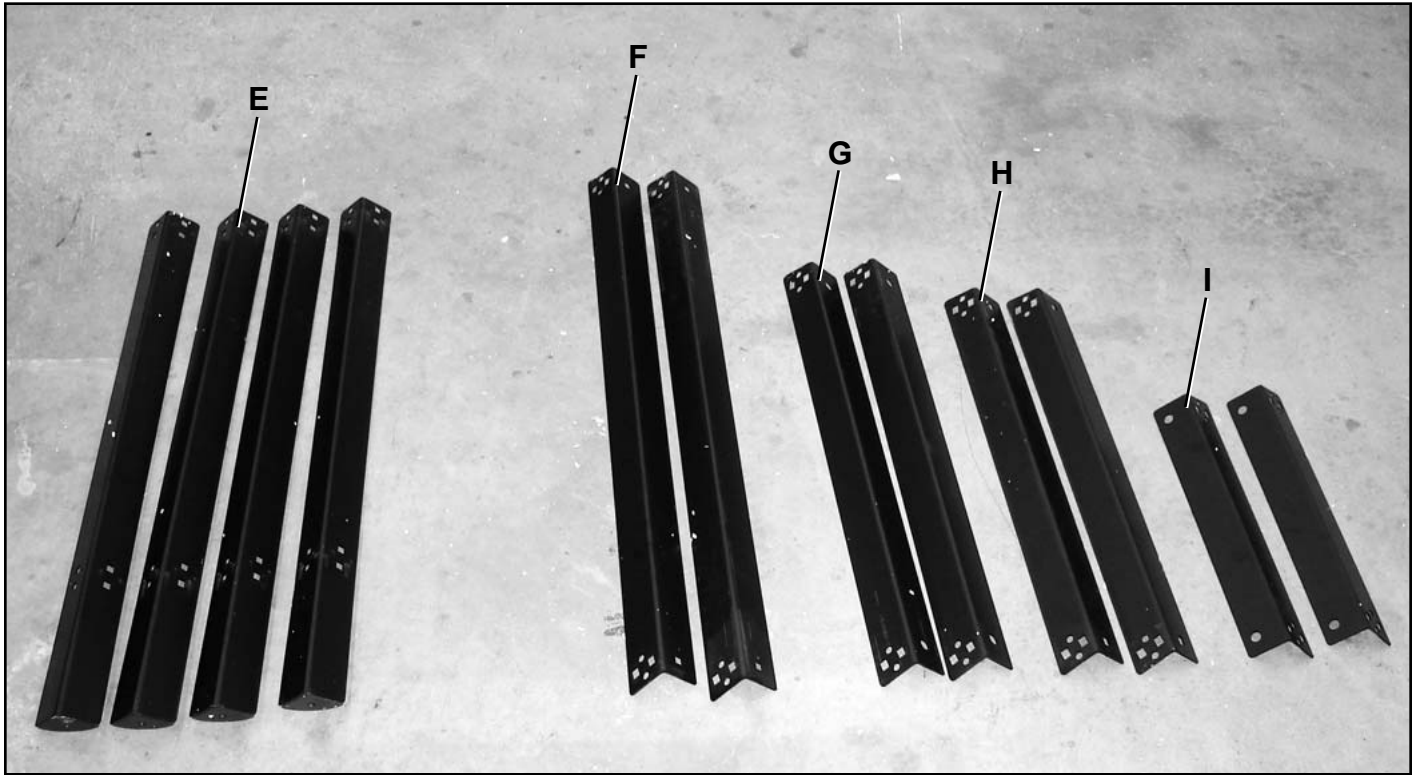
If any parts are missing, do not attempt to plug in the power cord and turn "ON" the machine. The machine should only be turned "ON" after all the parts have been obtained and installed correctly. **For missing parts, contact Steel City at 1-877-SC4-TOOL.**

Fig. A



- A. SHIMS (2)
- B. HEX WRENCHES (2)
- C. RAISING / LOWERING HANDWHEEL
- D. HANDLE

Fig. B



E. LEGS (4)

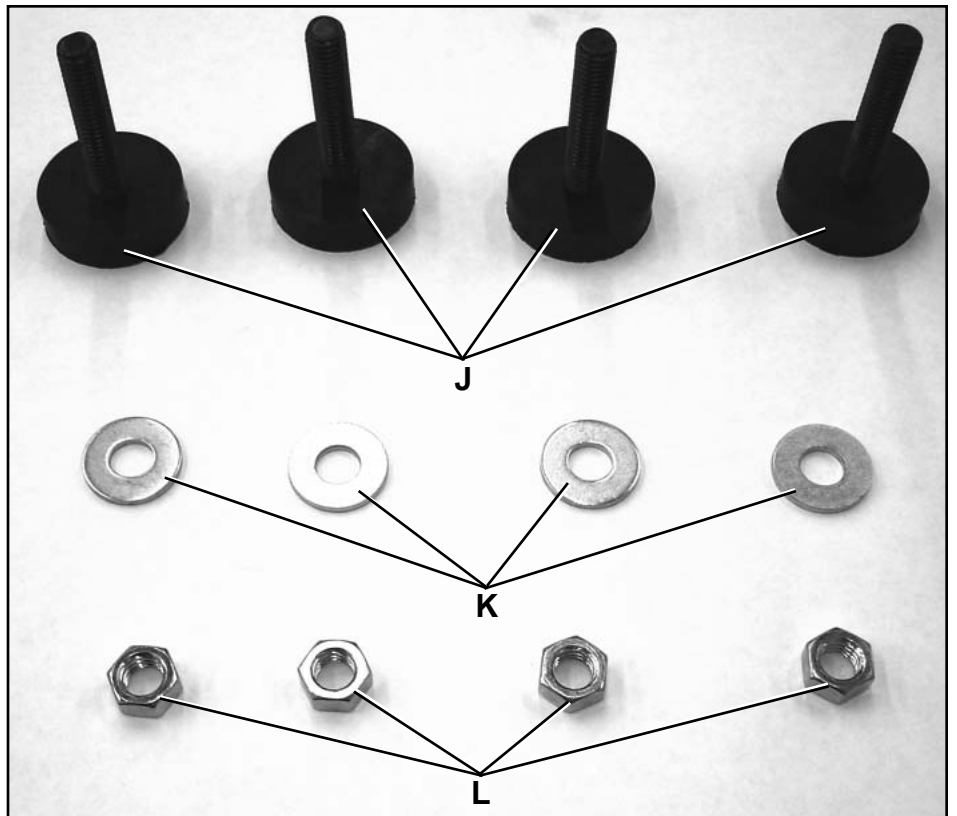
F. LONG LOWER HORIZONTAL SUPPORT (2)

G. LONG UPPER HORIZONTAL SUPPORT (2)

H. SHORT LOWER HORIZONTAL SUPPORT (2)

I. SHORT UPPER HORIZONTAL SUPPORT (2)

Fig. C

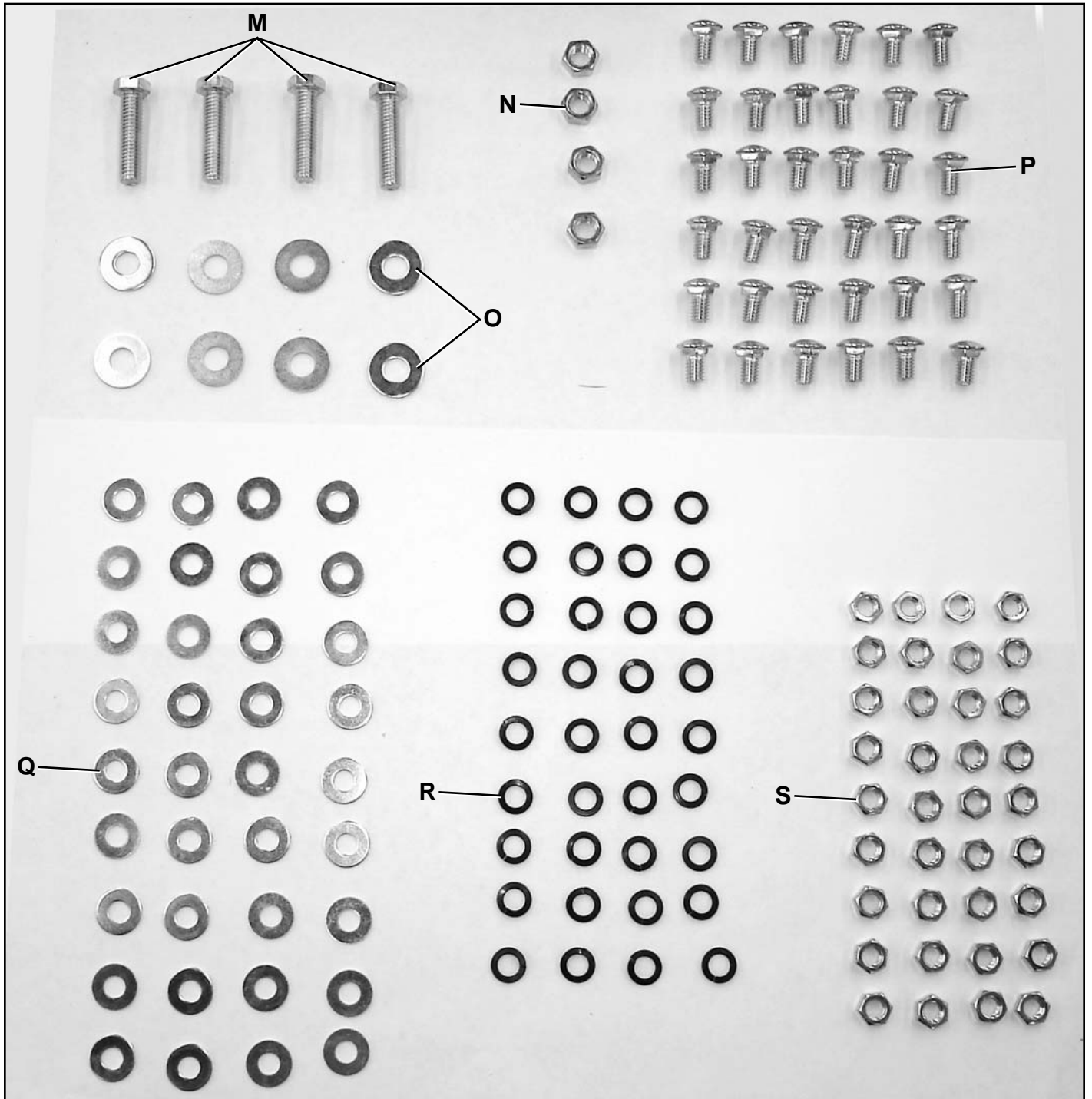


J. LEVELING FEET (4)

K. 3/8 HEX NUT (4)

L. 3/8 FLAT WASHER (4)

Fig. D



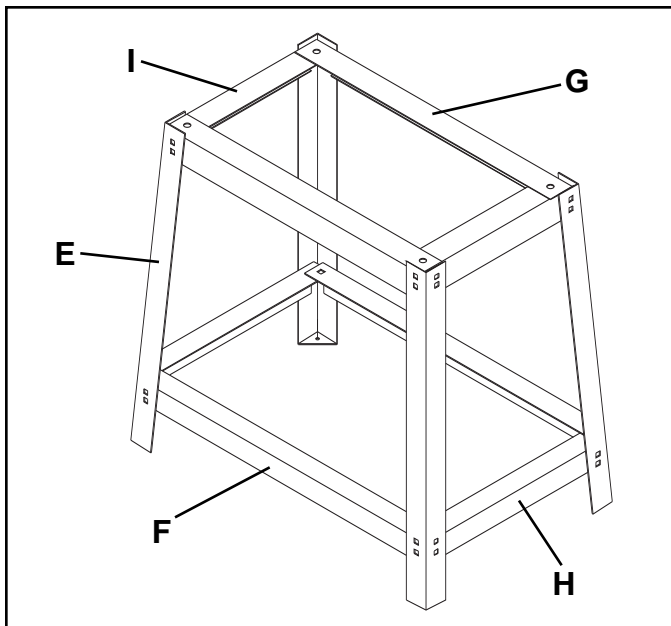
- M. 3/8" X 1-1/2" HEX HEAD SCREW (4)
- N. 3/8" HEX NUT (4)
- O. 3/8" FLAT WASHER (8)
- P. 5/16-18 X 5/8" CARRIAGE BOLT (36)
- Q. 5/16" FLAT WASHER (36)
- R. 5/16" LOCK WASHER (36)
- S. 5/16" HEX NUT (36)

ASSEMBLY

STAND ASSEMBLY

1. Assemble the stand according to the layout in Fig 1. Refer to Fig B in the UNPACKING AND INVENTORY section to determine which piece is which. All segments of the stand are fastened together using one 5/16-18 x 5/8" carriage bolt, one 5/16" flat washer, one 5/16" lock washer, and one 5/16" hex nut for each square hole. Just snug all hardware at this time. **SEE FIG 1 and FIG B, page 16 .**

Fig. 1

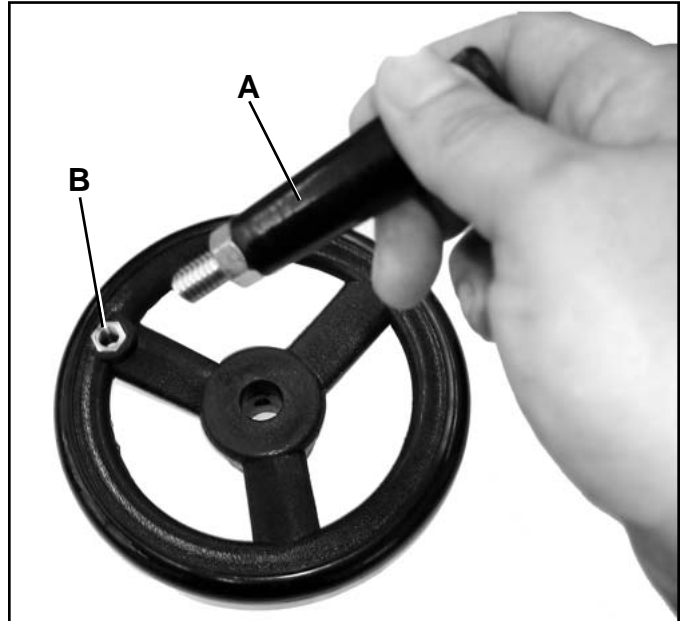


2. Turn the stand upside down and thread the four leveling feet into the holes in the bottom of the legs.
3. Fasten each foot using one 3/8" flat washer and one 3/8" hex nut for each leveling foot.
4. Turn stand right side up and make sure that it does not wobble. If the stand does wobble, adjust one or more of the leveling feet until the stand is stable.

HANDWHEEL ASSEMBLY

Thread Handle (A) into the threaded hole (B) in the Handwheel and tighten the handle. **SEE FIG 2.**

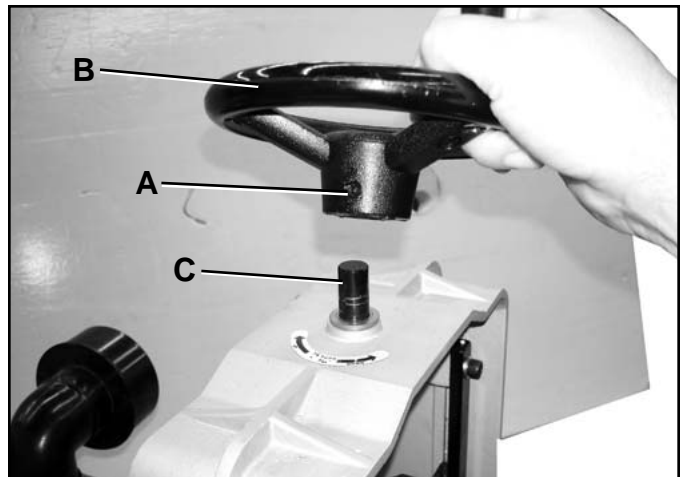
Fig. 2



MOUNTING HANDWHEEL ASSEMBLY

1. Locate the set screw (A) threaded into the side of the handwheel assembly (B). **SEE FIG 3.**

Fig. 3



2. Place handwheel over the height adjustment shaft (C). Take note of the flat side on the height adjustment shaft. The set screw in the handwheel assembly should be positioned on the same side as this flat on the shaft.
3. Tighten set screw.

MOUNTING SANDER TO THE STAND

NOTE: The sander is heavy. The use of a helper is strongly recommended for mounting the sander to the stand.

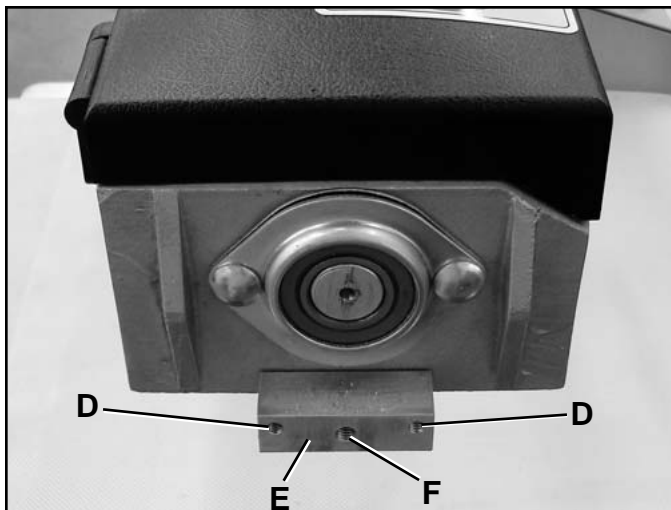
1. Lift the sander up and place it on the stand
2. Line up the 4 holes in the corners of the sander with the four holes in the top of the stand.
3. Fasten the sander to the stand using one 3/8" X 1-1/2" hex head screw, one 3/8" hex nut, and two flat washers on each corner. Tighten all hardware securely.
4. Securely tighten all stand hardware at this time.

FASTENING STABILIZER BRACKET

The Stabilizer Bracket helps prevent deflection the sanding drum. It is designed to be used on workpieces 16" wide or less. If you are sanding a workpiece wider than 16", you will have to remove the bracket.

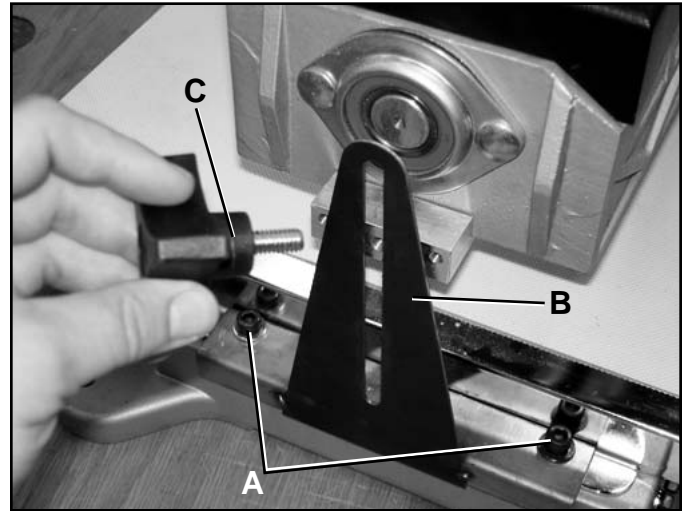
1. Attach block (E) to the sander by aligning the groove in the block with the edge of the sander. **SEE FIG 3A.**

Fig. 3A



2. Fasten the block to the sander by tightening the 2 set screws (D).
3. Loosen the 2 socket head cap screws (A) and slide the stabilizer bracket (B) underneath both the socket head cap screws and the flat washers. **SEE FIG 4.**
4. Reposition block(E), if necessary, so that the threaded hole (F), is centered with the slot in the stabilizer bracket (B)
5. Insert knob (C), through the stabilizer bracket and thread into the threaded hole in the head of the sander.

Fig. 4



INSTALLING ABRASIVE STRIPS

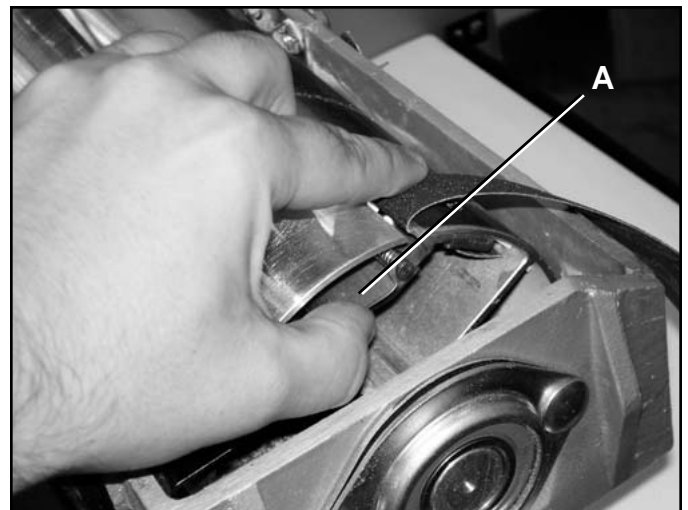
NOTE: DO NOT install the abrasive strips until you have completed all of the adjustments in the ADJUSTMENTS section of this manual. There are several adjustments that require the abrasive strip to be removed in order to complete the operation. Once you have completed the ADJUSTMENTS section of this manual you may come back to this section for information on how to install the abrasive strips.

⚠ WARNING

MAKE CERTAIN THAT THE SANDER IS DISCONNECTED FROM THE POWER SOURCE.

1. Insert the tapered tip of the abrasive strip into the left side of the drum while depressing the clip (A). Release the clip once the strip is securely located in the clip jaws. **SEE FIG 4A.**

Fig. 4A



2. Stand in front of the unit and roll the drum away from you as you wrap the abrasive strip around the drum. Make sure not to overlap the strip or to leave any gaps in between the strip and drum. **SEE FIG 4B.**

Fig. 4B



3. Once you have completely wrapped the drum, keep tension on the strip and insert the remaining end of the strip into the slot in the drum.
4. Using your right hand push in on the spring loaded shaft (B) so that it enters the drum before the tensioner clip (C). **SEE FIGS 4C and 4D.**

Fig. 4C

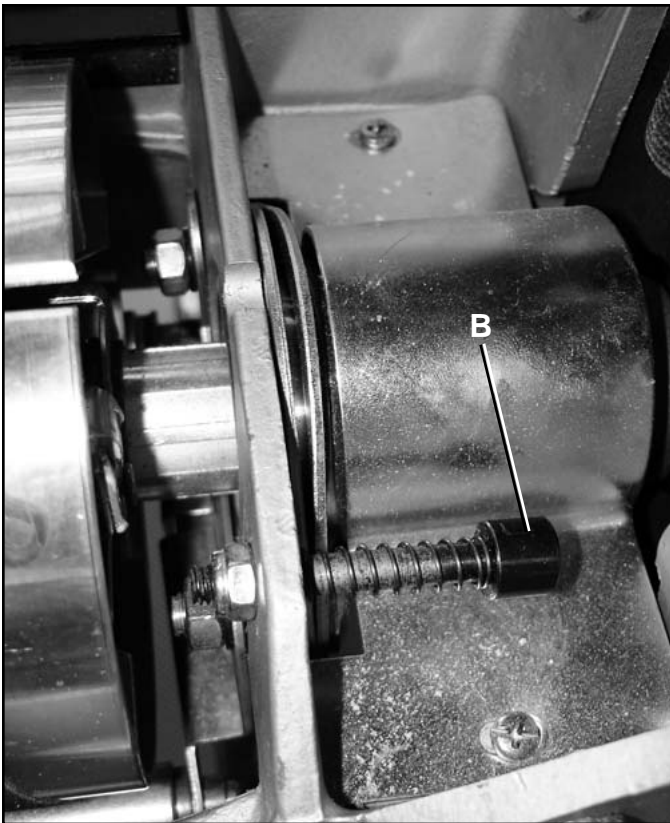
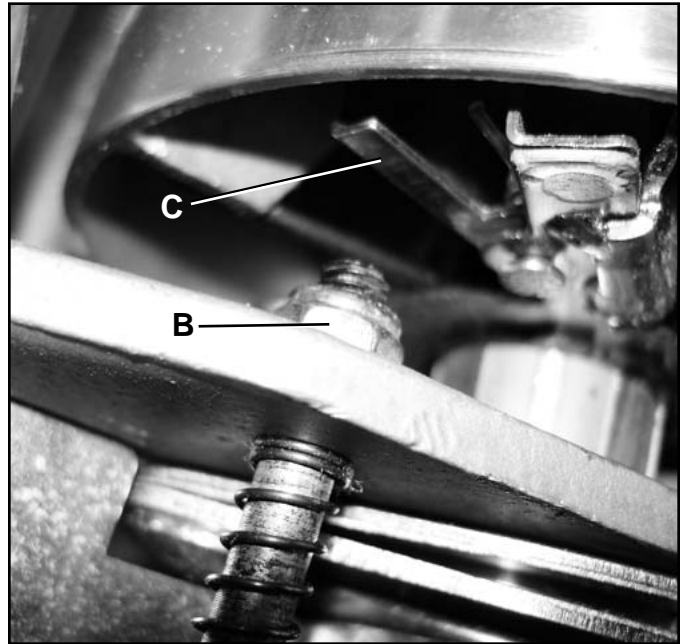


Fig. 4D



5. While still holding the spring loaded shaft, roll the drum towards you to compress the tensioner clip.
6. Push the end of the abrasive strip into the drum until there is no slack in the strip.
7. Release the spring loaded shaft and check to make sure that the abrasive strip fits snugly around the drum. If any slop is detected, repeat steps 3-6.

ADJUSTMENTS

The Sanding Drum is aligned parallel with the table and completely adjusted at the factory during assembly. However, due to stresses that occur to the unit during shipping. It is recommended that you adjust or align your sander using the following procedures to return it to optimal working conditions. Do not attempt to use the sander until you have performed all of the adjustments in this section.

SANDING DRUM ALIGNMENT

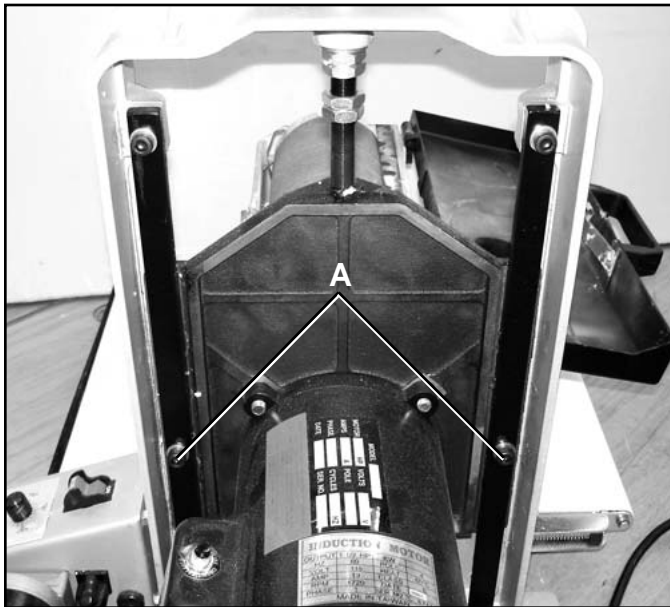
The tightness of the Elevation Tension Adjustment Screws needs to be adjusted to allow for smooth height adjustments while still ensuring a tight enough fit as to limit deflection of the drum. Too tight a fit will result in difficulty in making height adjustments. Too loose a fit will cause the drum to deflect excessively. To adjust:

▲ WARNING

MAKE CERTAIN THAT THE SANDER IS DISCONNECTED FROM THE POWER SOURCE.

1. Loosen the locknuts (not shown) on the opposite end of the Elevation Tension Adjustment Screws (A). **SEE FIG 5.**

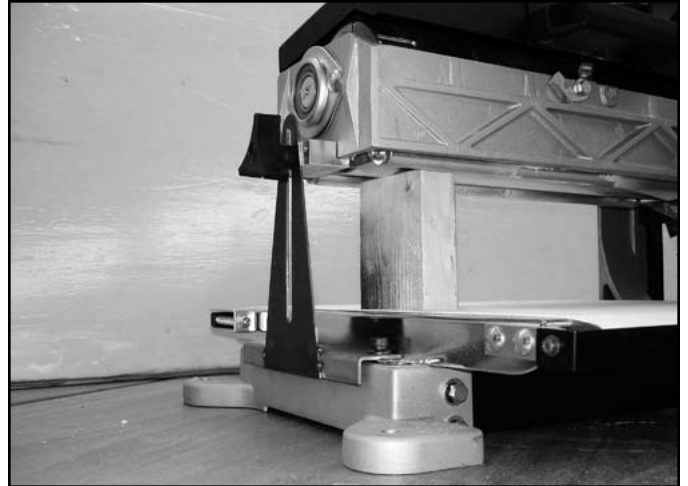
Fig. 5



2. Loosen or tighten each screw as required. Make adjustment in 1/4 turn increments until the desired fit is achieved.
3. Retighten the locknuts loosened in step 1 to secure the tension screws in position.

4. Place a block of wood at the left side of the sander between the drum and the conveyor belt. We will call this Measurement A. **SEE FIG. 6.**

Fig. 6



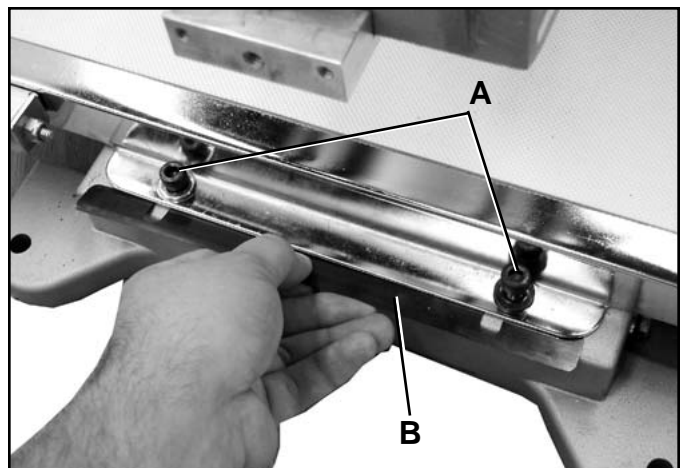
NOTE: The abrasive strip must **NOT** be on the drum when performing this step.

5. Crank the handwheel counterclockwise to lower the drum until it just touches the block of wood
6. Using a feeler gauge, check and see the clearance between the block of wood and the drum.
7. Without raising or lowering the drum, slide the block of wood over to the right side of the sander and, again, using a feeler gauge, check the clearance between the drum and the block of wood. This is Measurement B. The difference between the measurement A and Measurement B should be .010 or less. If this is the case, no further adjustment is necessary. Otherwise,

If Measurement A is greater than Measurement B by .020 or less:

1. Loosen the two outboard conveyor table mounting bolts (A) **SEE FIG 7.**

Fig. 7



- Slide one(or both, depending on how much the two measurements are off) of the .010 shims (B) under the edge of the conveyor belt as shown in **FIG 7**.
- Recheck Measurement A and Measurement B again. Confirm that the difference between the two Measurements is less than .010.

If Measurement A is greater than Measurement B by more than .020 OR If Measurement B is greater than Measurement A:

- Loosen the two front adjustment bolts (A) and the two rear adjustment bolts (B) slightly. This will allow the entire drum assembly to pivot. **SEE FIGS. 8 and 9.**

Fig. 8

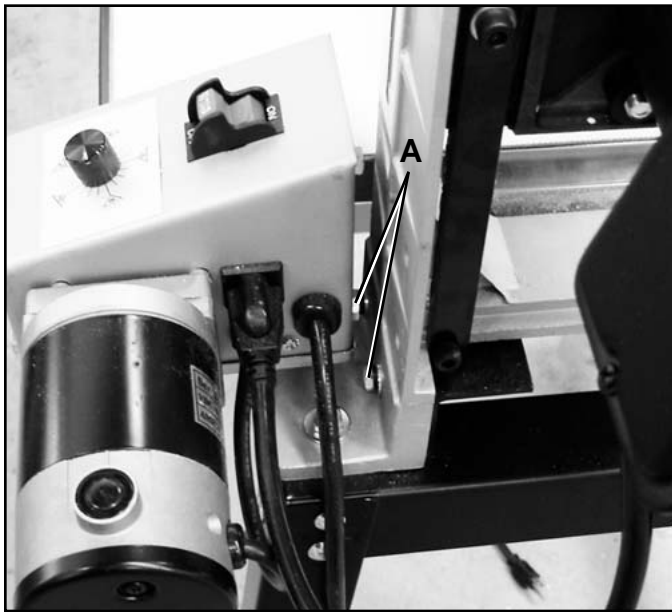
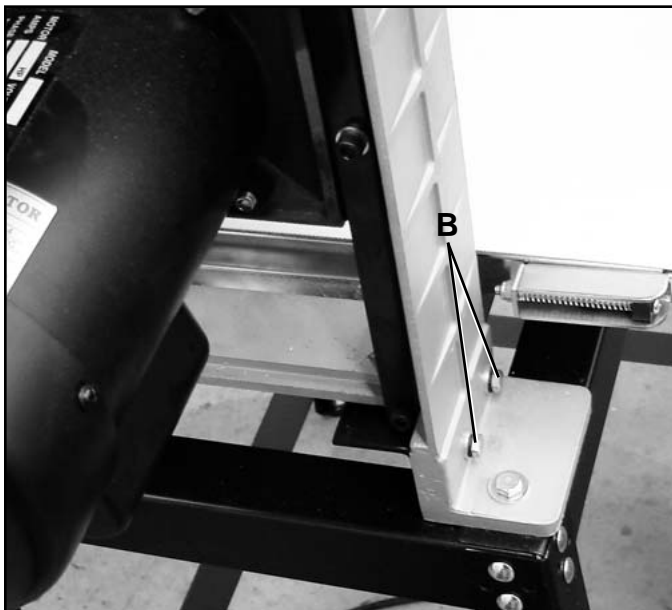
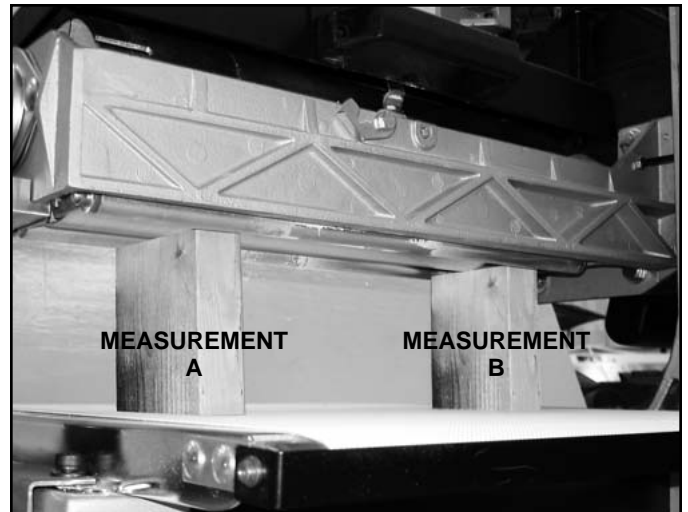


Fig. 9



- Using two wood blocks of **IDENTICAL** height, place one at Measurement A and one at Measurement B. **SEE FIG. 10.**

Fig. 10



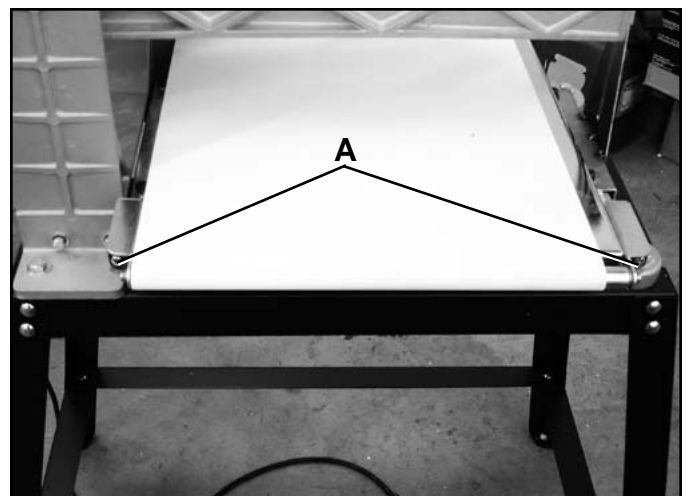
- Crank the handwheel counterclockwise to lower the drum until it touches both wood blocks.
- Retighten the bolts loosened in step 1.
- Using one woodblock and a feeler gauge, recheck both Measurements A and B. Confirm that the difference between the two is less than .010

CONVEYOR FEED BELT TRACKING ADJUSTMENT

Occasional adjustment of the conveyor feed belt tracking may be required due to belt stretching, normal wear and tear, and improper tensioning. Ideally, the conveyor feed belt should track in the center of the conveyor belt feed table

- The conveyor belt feed tracking adjustment screws (A) are located at the rear of the machine on both the left and right side of the drum sander. **SEE FIG 11.**

Fig. 11



2. To tighten the tracking tension, the tracking screw must be rotated clockwise while holding the nut on the opposite end in place using an open end wrench. Turning the screw counterclockwise loosens the tension. **SEE FIG 12.**
3. While the belt is moving, tighten the screw on the side that the belt is tracking towards. For example, if the belt is tracking towards the motor side of the machine, tighten the tracking adjustment screw on that side.

NOTE: Tracking adjustments may not become apparent immediately. Increase the speed of the belt to hasten the effects of your adjustments. It is good practice to make adjustments in 1/4 turn increments.

Fig. 12

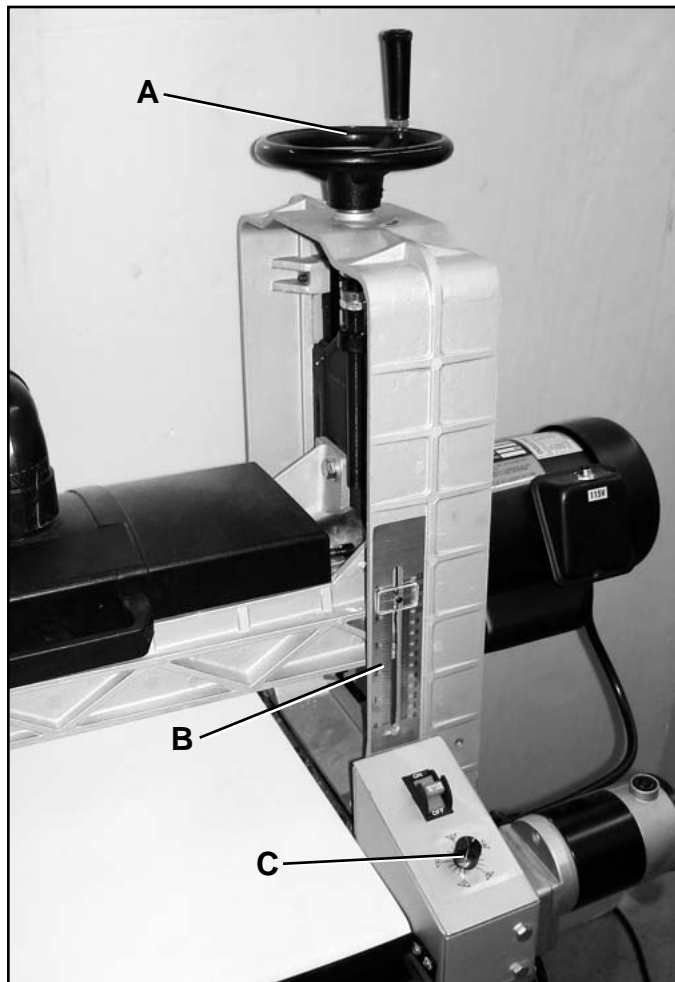


OPERATIONS

DRUM HEIGHT CONTROL

The height of the drum is raised and lowered by turning the handwheel (A). Turning the handwheel clockwise will raise the drum, while turning it counterclockwise will lower it. The depth of the movement is approximately 1/16" per full revolution. Depth settings can be measured using the Depth indicator scale (B) on the front of the machine. **SEE FIG 13.**

Fig. 13



VARIABLE SPEED CONTROL SWITCH

The variable speed control switch (C) controls the feed rate of the conveyor belt. This speed range is from 0-10 SFPM. When selecting the feed rate, wider workpieces and harder wood require a slower feed rate while narrow or soft pieces can be put through the sander at a faster rate. **SEE FIG 13.**

BASIC OPERATING PROCEDURE

The basic operating procedure for the sander as follows.

1. Set the depth of wood removal
2. Start the machine
3. Set the feed rate for the conveyor belt
4. Start your dust collector
4. Feed stock through the unit

Determining the depth of cut is one of the most important procedures for the sander. It may take some experimentation to determine the proper depth of cut, given the variables of abrasive grit, type of wood and feed rate. Never remove more than 1/32" of material in a single pass. As a general rule, 1/4 turn, or 1/64", or less is recommended for coarser grits and softer woods, while 1/8 of a turn, or 1/128" may be more desirable with harder woods and/or finer grits of abrasives. For best results, use a scrap piece of wood to practice on. This will help you develop familiarity with the machine before doing finish work.

GRIT SELECTION

The grit size of the sandpaper designates the coarseness of the abrasive. The lower the grit number, the coarser the abrasive. With coarser grit papers, such as 36 and 60 grit, very aggressive material removal and surface scratching occurs. With finer grit abrasives, very little material is removed and a buffed like look begins to appear. The table below shows different types of grit and their uses.

| <u>Description</u> | <u>Normal Use</u> |
|--------------------|--|
| 60 Grit Sandpaper | surfacing and dimensioning boards, trueing warped boards |
| 80 Grit Sandpaper | surfacing, light dimensioning, removing planer ripples |
| 120 Grit Sandpaper | light surfacing, minimal stock removal |
| 150 Grit Sandpaper | finish sanding, minimal stock removal |
| 180 Grit Sandpaper | finish sanding only, not for stock removal |
| 220 Grit Sandpaper | finish sanding only, not for stock removal |

DUST COLLECTION

This sander is equipped with a 2-1/2" dust port with a 4" adapter that can be used to attach to a dust collection system. **NEVER** attempt to operate your sander without a dust collector attached and running.

MAINTENANCE

LUBRICATION

The motor on this unit has sealed bearings and requires no further lubrication.

Periodically lubricate moving parts using a white lithium grease, including the threaded depth control, sliding surfaces, and bronze bushings associated with the depth control mechanism.

CONVEYOR FEED BELT REPLACEMENT

Common cause which require replacement of the conveyor feed belt are:

- Normal wear and tear.
- Inadvertent contact with the sanding drum abrasive during operation.
- Tears caused by mistracking of the belt.
- Excessive buildup of non-removable film.

The following steps describe how to remove and replace the conveyor belt, if it ever becomes necessary:

▲ WARNING

MAKE CERTAIN THAT THE SANDER IS DISCONNECTED FROM THE POWER SOURCE.

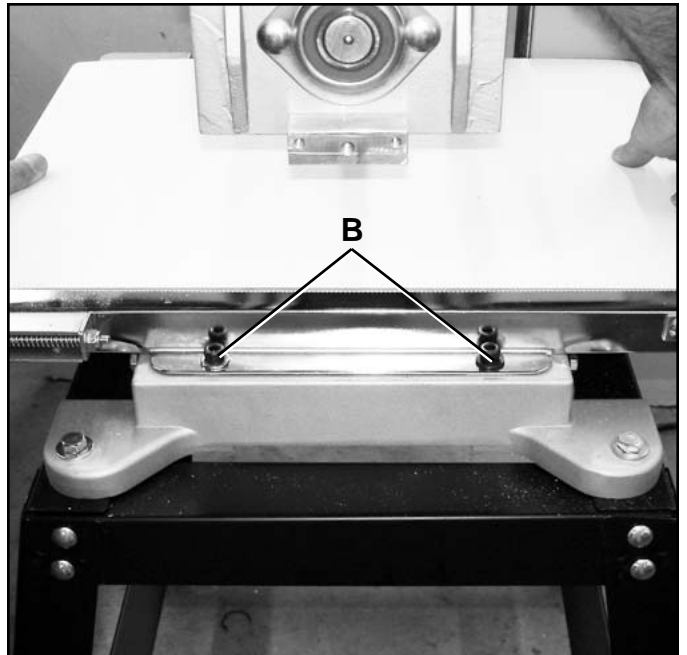
1. Raise the sanding drum to it's highest position by turning the handwheel clockwise.
2. Using a Phillips screwdriver, remove the two screws(A) and star washers securing the front guard to the variable speed control box and remove the guard. **SEE FIG 14.**

Fig. 14



3. Using the supplied hex wrench, remove both conveyor table mounting bolts(B) on the open side of the sander. **SEE FIG 15.**

Fig. 15



4. Reduce the tension on the conveyor belt by loosening both of the feed belt tracking adjustment screws **SEE FIG 11 on page 22.**
5. Remove the conveyor belt by grasping both sides of the belt as shown in Fig 15. Gently lift the conveyor table as you slide off the conveyor feed belt. If the belt will not move, further reduce the tension on the feed belt and ensure that you are lifting the table high enough to allow the belt to slide off.
6. To install a new belt, follow steps 2-5 in reverse order. Make sure to set the tracking on the new conveyor belt. The procedure for setting the tracking can be found in the **ADJUSTMENTS** section of this manual.

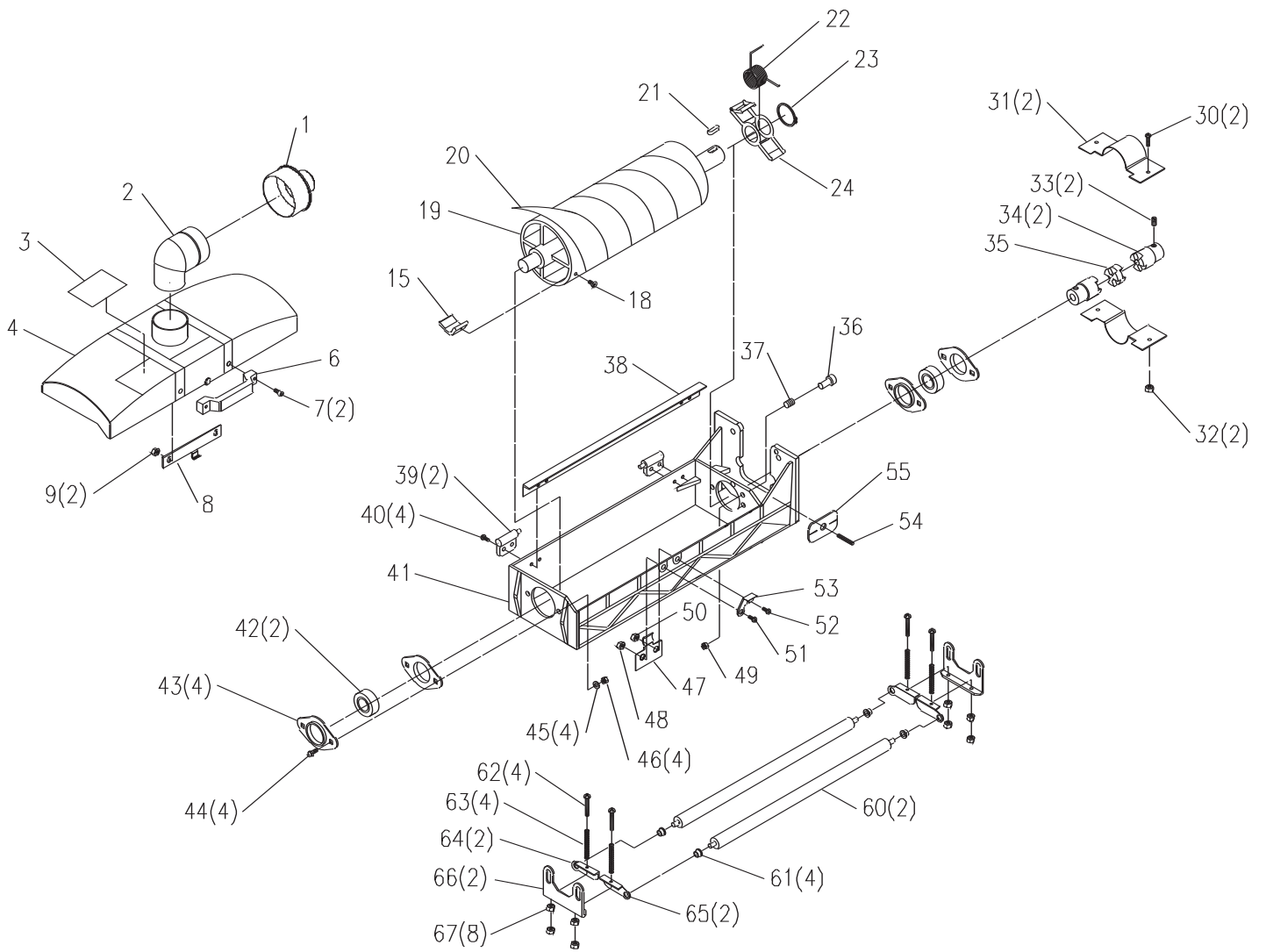
TROUBLESHOOTING GUIDE

Troubleshooting Guide for Wide Drum Sander

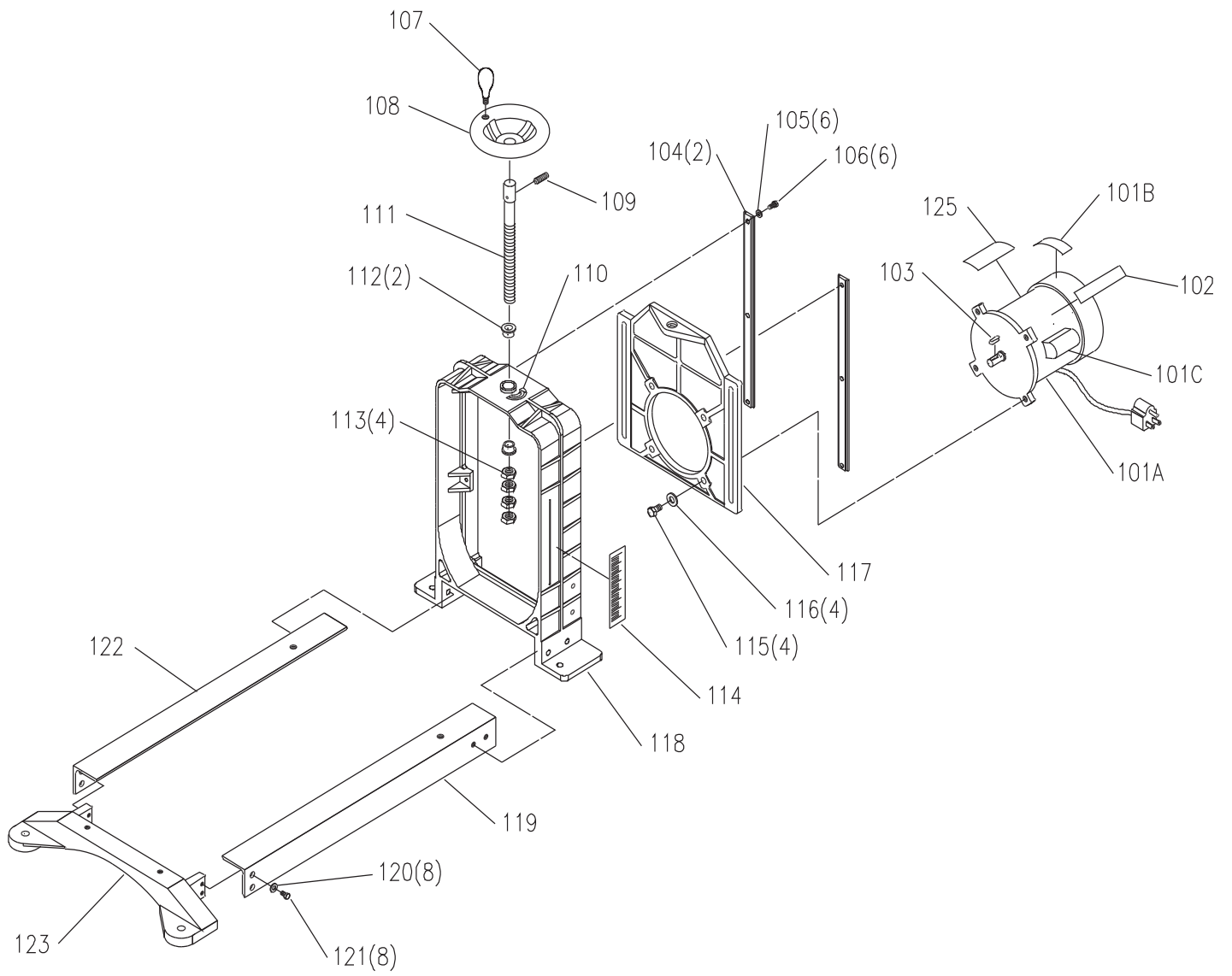
| PROBLEM | LIKELY CAUSE(S) | SOLUTION |
|---|---|--|
| Abrasive strip comes loose from clips. | 1. Slack in abrasive strip; abrasive improperly. | 1. Reattach abrasive strip. (Refer to pages 19 and 20). |
| Wood burned during sanding. | 1. Abrasive strip edges overlapped. 2. Abrasive loaded with resin. 3. Depth of cut excessive. 4. Feed rate too slow. | 1. Reattach abrasive strip properly. 2. Replace abrasive. 3. Try coarser grit - limit depth of cut. 4. Increase feed rate. |
| Sanding drum feed belt - runs intermittently. | 1. Shaft coupling loose. | 1. See Authorized Service Center. |
| Sanding drum feed belt slips on drive rollers. | 1. Belt tension loose. | 1. Adjust belt tension. 2. Reduce depth of cut. 3. Reduce feed rate. |
| Stock slips on sanding drum feed belt. | 1. Feed rate excessive. 2. Dirty/worn conveyor belt. | 1. Reduce feed rate. 2. Replace/clean feed belt. |
| Non-evenly spaced ripples on stock. | 1. Uneven feed rate. 2. Motor stalls on conveyor feed drive. | 1. Check for belt/gear slipping on feed drive belt. 2. Adjust belt tension. |
| Evenly spaced ripples on stock. | 1. Sanding bed flexing. 2. Sander vibration. 3. Drum dirty - out of balance. | 1. Reduce depth of cut. 2. Reduce feed rate. 3. Check for: Loose bolts, loose shaft coupling set screws; Clean sanding drum if out of balance. (Have service performed by a Factory or Authorized Service Center.) |
| Motor overload trips or shop wiring circuit breaker trips. | 1. Excessive combined total load on sanding drum and motor. 2. Low line voltage/extension cord gage too small. 3. Excessive length or inadequate gage extension cord. | 1. Allow motor to cool and reset overload button. 2. Reduce feed rate and/or depth of cut. Limit length of cord and gage of wire 50' or less, 12 gage minimum. 3. If overload continues to trip, see Factory or Authorized Service Center. |

◆ NOTES ◆

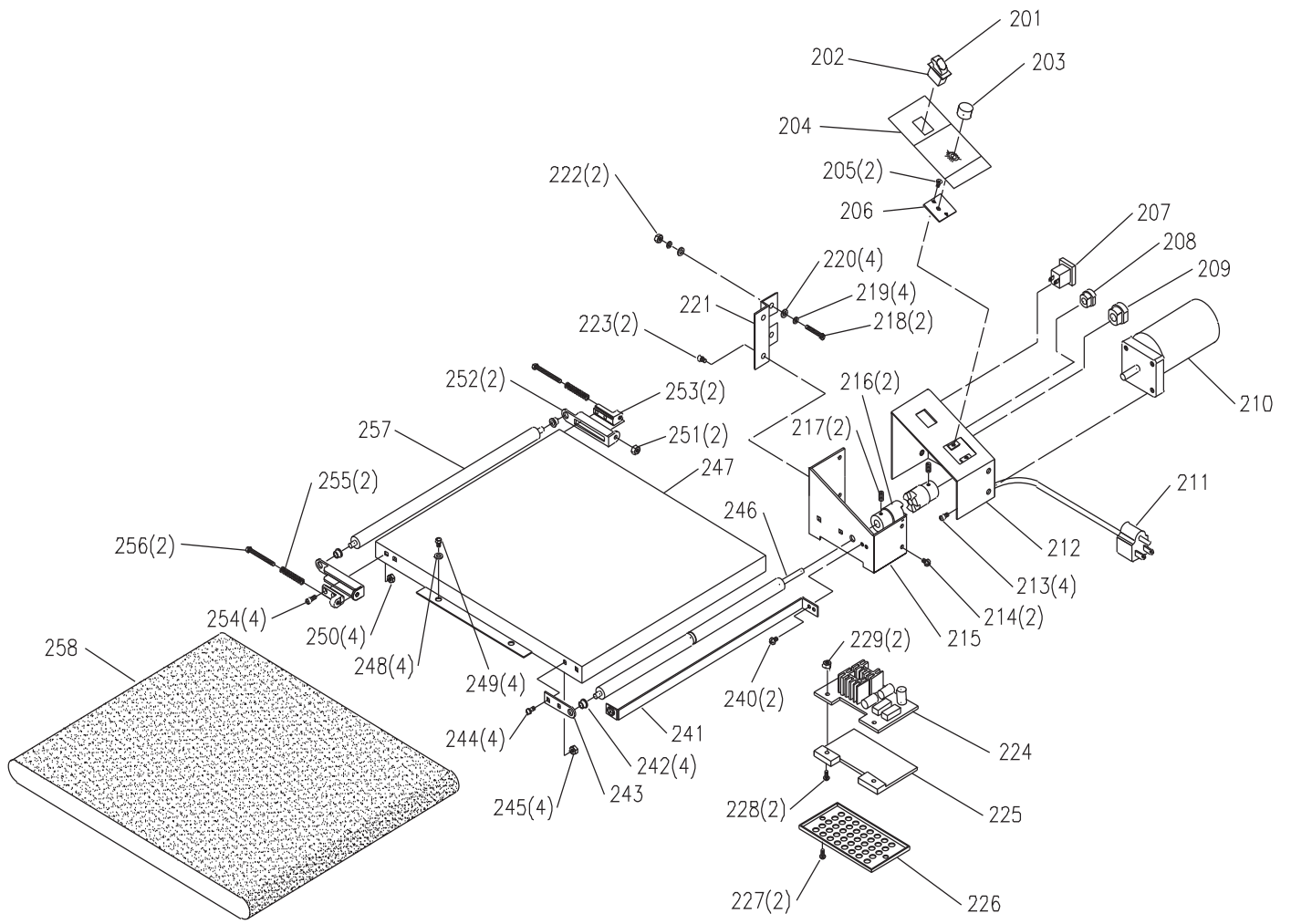
PARTS



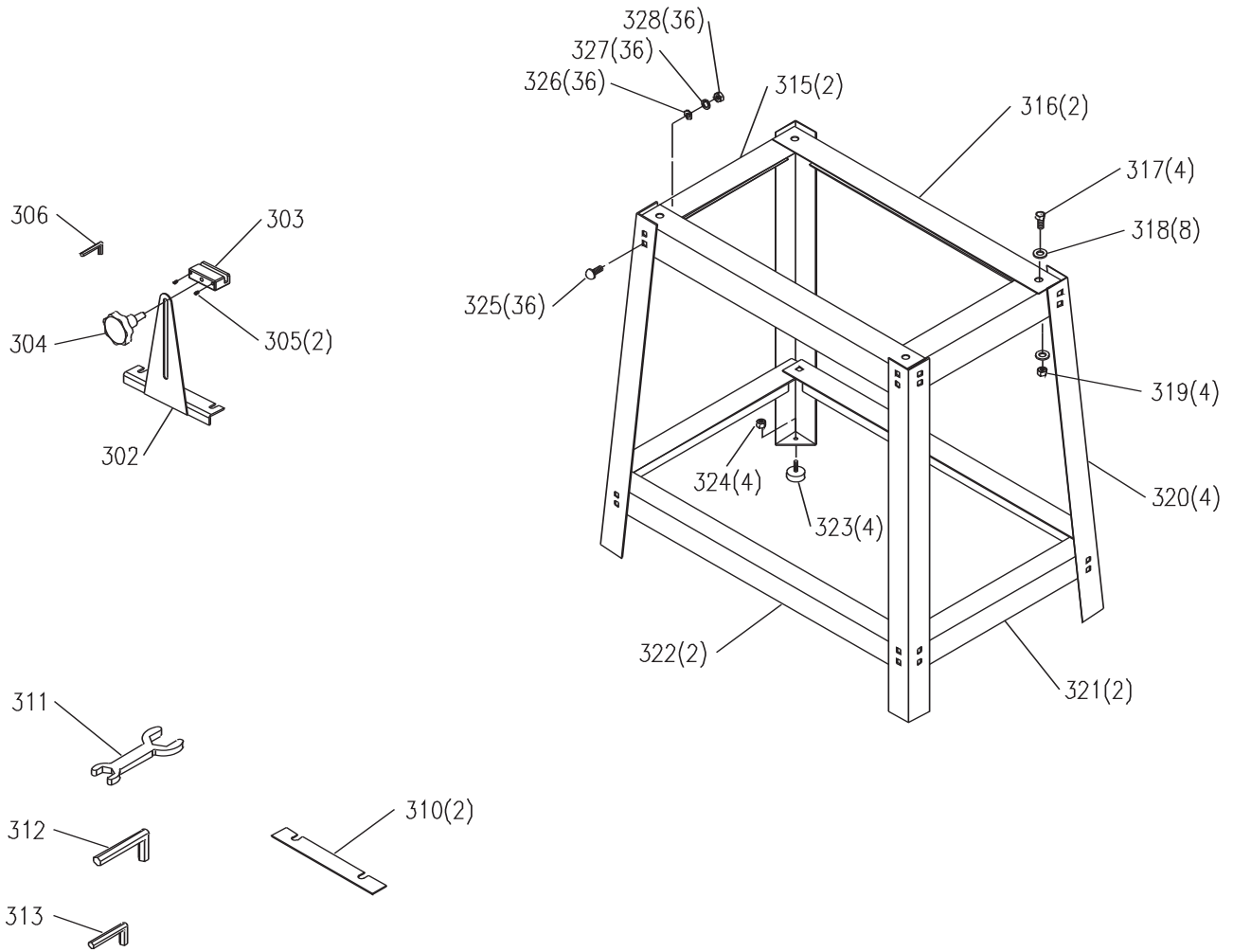
| KEY NO. | PART NO. | DESCRIPTION | QTY. | KEY NO. | PART NO. | DESCRIPTION | QTY. |
|---------|----------|-------------------------------------|------|---------|----------|--------------------------------|------|
| 1 | OR72232 | DUST PORT ADAPTER | 1 | 37 | OR94479 | SPRING | 1 |
| 2 | OR72233 | DUST PORT ELBOW | 1 | 38 | OR72248 | DRUM DUST DEFLECTOR | 1 |
| 3 | OR72234 | WARNING LABEL | 1 | 39 | OR72249 | COVER HINGE | 2 |
| 4 | OR72235 | DUST COVER | 1 | 40 | OR94460 | 1/4 - 20 x 1 PAN HEAD SCREW | 4 |
| 6 | OR72236 | HANDLE | 1 | 41 | OR72250 | DRUM HOUSING | 1 |
| 7 | OR94452 | 5/16 - 18 x 1 SOC HEAD CAP SCREW | 2 | 42 | OR94418 | BEARING (6205ZZ) | 2 |
| 8 | OR72237 | HANDLE LATCH PLATE | 1 | 43 | OR72251 | BEARING CAP | 4 |
| 9 | OR90616 | 5/16 - 18 HEX NUT | 2 | 44 | OR94087 | 5/16 - 18 x 1 CARRIAGE BOLT | 4 |
| 15 | OR72238 | CLAMP BRACKET | 1 | 45 | OR91658 | 5/16 LOCK WASHER | 4 |
| 16 | OR72239 | CLAMP (NOT SHOWN) | 1 | 46 | OR90616 | 5/16 -18 HEX NUT | 4 |
| 17 | OR94453 | SPRING (NOT SHOWN) | 1 | 47 | OR72252 | LATCH PLATE | 1 |
| 18 | OR94454 | 10-32 x 3/8 FLAT HEAD SCREW | 1 | 48 | OR94480 | 5/16 HEX NUT NYLOK | 1 |
| 19 | OR72240 | DRUM | 1 | 49 | OR91754 | M6 HEX NUT NYLOK | 1 |
| 20 | OR72241 | SANDING SLEEVE | 1 | 50 | OR90071 | 1/4"-20 HEX NUT | 1 |
| 21 | OR94455 | 5mm x 5mm x 25mm KEY | 1 | 51 | OR94461 | SPECIAL SCREW | 1 |
| 22 | OR94456 | SPRING | 1 | 52 | OR94462 | 1/4 - 20 x 5/8 FLAT HEAD SCREW | 1 |
| 23 | OR94457 | RETAINING RING | 1 | 53 | OR72253 | FLIP LATCH | 1 |
| 24 | OR72242 | CLAMP BRACKET | 1 | 54 | OR94463 | SPECIAL STUD | 1 |
| 25 | OR72243 | CLAMP (NOT SHOWN) | 1 | 55 | OR72254 | CURSOR | 1 |
| 26 | OR94458 | SPRING (NOT SHOWN) | 1 | 60 | OR72255 | PRESSURE ROLLER | 2 |
| 30 | OR94459 | 10 -24 x 1 1/2 PAN HEAD SCREW | 2 | 61 | OR72256 | ROLLER BUSHING | 4 |
| 31 | OR72244 | COUPLING GUARD | 2 | 62 | OR94464 | M4 x 35mm PAN HEAD SCREW | 4 |
| 32 | OR90374 | 10 - 24 HEX NUT | 2 | 63 | OR94465 | SPRING | 4 |
| 33 | OR91762 | 1/4 - 20 x 1/4 HEX SOCKET SET SCREW | 2 | 64 | OR72257 | PRESSURE ROLLER MOUNT | 2 |
| 34 | OR72245 | MOTOR COUPLING | 2 | 65 | OR72258 | PRESSURE ROLLER MOUNT | 2 |
| 35 | OR72246 | COUPLING ALIGNMENT BLOCK | 1 | 66 | OR72259 | PRESSURE ROLLER BRACKET | 2 |
| 36 | OR72247 | DRUM LOCK STUD | 1 | 67 | OR90078 | M4 HEX NUT | 8 |



| KEY NO. | PART NO. | DESCRIPTION | QTY. | KEY NO. | PART NO. | DESCRIPTION | QTY. |
|---------|----------|--------------------------------------|------|---------|----------|------------------------------|------|
| 101A | OR70412 | MOTOR (1.5HP, 115VDC,13AMP,1725 RPM) | 1 | 112 | OR72266 | BUSHING | 2 |
| 101B | OR70361 | MOTOR SPEC PLATE | 1 | 113 | OR94469 | 5/8 -18 THIN HEX NUT | 4 |
| 101C | OR94466 | CAPACITOR | 1 | 114 | OR72267 | SCALE LABEL | 1 |
| 102 | OR72260 | WARNING LABEL | 1 | 115 | OR93546 | M10 x 40 mm HEX HEAD SCREW | 4 |
| 103 | OR94455 | 5mm x 5mm x 25mm KEY | 1 | 116 | OR94470 | SPECIAL WASHER | 4 |
| 104 | OR72261 | MOUNTING BAR | 2 | 117 | OR72268 | MOTOR MOUNTING PLATE | 1 |
| 105 | OR91658 | 5/16 LOCK WASHER | 6 | 118 | OR72269 | FRAME | 1 |
| 106 | OR94467 | 5/16-18 x 1 1/2 SOC HEAD CAP SCREW | 6 | 119 | OR72270 | FEED ROLLER BRACKET | 1 |
| 107 | OR72262 | HAND WHEEL KNOB | 1 | 120 | OR90625 | 5/16 FLAT WASHER | 8 |
| 108 | OR72263 | HAND WHEEL | 1 | 121 | OR90634 | 5/16 - 18 x 1 HEX HEAD SCREW | 8 |
| 109 | OR94468 | 5/16 - 18 x 5/16 HEX SOC SET SCREW | 1 | 122 | OR72271 | FEED ROLLER BRACKET | 1 |
| 110 | OR72264 | ROTATION LABEL | 1 | 123 | OR72272 | FEED TABLE MOUNTING BASE | 1 |
| 111 | OR72265 | ELEVATION SHAFT | 1 | 125 | OR70302 | SPEC PLATE | 1 |



| KEY NO. | PART NO. | DESCRIPTION | QTY. | KEY NO. | PART NO. | DESCRIPTION | QTY. |
|---------|----------|---|------|---------|----------|------------------------------------|------|
| 201 | OR72273 | SWITCH SAFETY KEY | 1 | 225 | OR72285 | INSULATED BOARD | 1 |
| 202 | OR72274 | SWITCH | 1 | 226 | OR72286 | CONTROL BOX BOTTOM PLATE | 1 |
| 203 | OR72275 | KNOB | 1 | 227 | OR90062 | 10-24 x 1/4 PAN HEAD SCREW | 2 |
| 204 | OR72276 | CONTROL PANEL | 1 | 228 | OR90568 | M8 x 12mm HEX HEAD SCREW | 2 |
| 205 | OR93987 | M5 x 10mm FLAT HEAD SCREW | 2 | 229 | OR94473 | 10 -24 x 1 1/2 PAN HEAD SCREW | 2 |
| 206 | OR72277 | PC BOARD | 1 | 240 | OR90568 | M8 x 12mm HEX HEAD SCREW | 2 |
| 207 | OR72278 | PLUG SET | 1 | 241 | OR72287 | FRONT GUARD | 1 |
| 208 | OR94471 | STRAIN RELIEF | 1 | 242 | OR72288 | ROLLER BUSHING | 4 |
| 209 | OR94472 | STRAIN RELIEF | 1 | 243 | OR72289 | ROLLER MTG PLATE | 1 |
| 210 | OR70413 | REDUCTION MOTOR (1/15HP,90 VDC,0.9AMP,35RPM) | 1 | 244 | OR90460 | 1/4"-20 x 3/4 CARRIAGE BOLT | 4 |
| 211 | OR72279 | POWER CORD | 1 | 245 | OR90071 | 1/4"-20 HEX NUT | 4 |
| 212 | OR72280 | CONTROL BOX COVER | 1 | 246 | OR72290 | INFEED ROLLER | 1 |
| 213 | OR94279 | M5 x 10mm SOC HEAD CAP SCREW | 4 | 247 | OR72291 | FEED TABLE | 1 |
| 214 | OR90568 | M8 x 12mm HEX HEAD SCREW | 2 | 248 | OR90625 | 5/16 FLAT WASHER | 4 |
| 215 | OR72281 | CONTROL BOX HOUSING | 1 | 249 | OR94474 | 5/16 - 18 x 5/8 SOC HEAD CAP SCREW | 4 |
| 216 | OR72282 | COUPLING | 2 | 250 | OR90235 | M6 HEX NUT | 4 |
| 217 | OR91762 | 1/4 - 20 x 1/4 HEX SOCKET SET SCREW | 2 | 251 | OR90071 | 1/4 - 20 HEX NUT | 2 |
| 218 | OR90640 | 5/16 - 18 x 3/4 HEX HEAD SCREW | 2 | 252 | OR72292 | FEED BELT ADJUSTMENT BRACKET | 2 |
| 219 | OR91658 | 5/16 LOCK WASHER | 4 | 253 | OR72293 | FEED BELT TENSION BRACKET | 2 |
| 220 | OR90625 | 5/16 FLAT WASHER | 4 | 254 | OR94475 | M6 x 15mm HEX HEAD SCREW | 4 |
| 221 | OR72283 | CONTROL BOX MTG BRACKET | 1 | 255 | OR94476 | SPRING | 2 |
| 222 | OR90616 | 5/16 HEX NUT | 2 | 256 | OR94478 | 1/4 -20 x 3 1/2 PAN HEAD SCREW | 2 |
| 223 | OR90065 | 5/16 - 18 x 5/8 HEX HEAD SCREW | 2 | 257 | OR72294 | OUTFEED ROLLER | 1 |
| 224 | OR72284 | PC BOARD | 1 | 258 | OR72295 | FEED BELT | 1 |



| KEY NO. | PART NO. | DESCRIPTION | QTY. | KEY NO. | PART NO. | DESCRIPTION | QTY. |
|---------|----------|---|------|---------|----------|-------------------------------|------|
| 301 | OR71403 | SUPPORT BRKT ASSY CONST OF; REF 302 TO REF 306 | 1 | 319 | OR90646 | 3/8 HEX NUT | 4 |
| 302 | OR71400 | BRACKET | 1 | 320 | OR72299 | LEG | 4 |
| 303 | OR71402 | HEAD MOUNTING BLOCK | 1 | 321 | OR72300 | SHORT BOTTOM BRACKET | 2 |
| 304 | OR71401 | KNOB | 1 | 322 | OR72301 | LONG BOTTOM BRACKET | 2 |
| 305 | OR91789 | 1/4 - 20 x 3/8 HEX SOC SET SCREW | 2 | 323 | OR72302 | FOOT PAD | 4 |
| 306 | OR91808 | 1/8 ALLEN WRENCH | 1 | 324 | OR90646 | 3/8 HEX NUT | 4 |
| 310 | OR72296 | SHIM | 2 | 325 | OR94477 | 5/16 - 18 x 5/8 CARRIAGE BOLT | 36 |
| 311 | OR90050 | WRENCH 10mm x 12mm | 1 | 326 | OR90625 | 5/16 FLAT WASHER | 36 |
| 312 | OR91729 | WRENCH 6mm | 1 | 327 | OR91658 | 5/16 LOCK WASHER | 36 |
| 313 | OR90291 | WRENCH 4mm | 1 | 328 | OR90616 | 5/16 HEX NUT | 36 |
| 315 | OR72297 | SHORT TOP BRACKET | 2 | 400 | OR72303 | MANUAL (NOT SHOWN) | 1 |
| 316 | OR72298 | LONG TOP BRACKET | 2 | 401 | OR72304 | MANUAL FRENCH (NOT SHOWN) | 1 |
| 317 | OR93833 | 3/8 - 16 x 1 1/2 HEX HEAD SCREW | 4 | 402 | OR72305 | MANUAL SPANISH (NOT SHOWN) | 1 |
| 318 | OR90467 | 3/8 FLAT WASHER | 8 | | | | |



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