

POWERMATIC®

Operating Instructions and Parts Manual 16-inch Open-End Belt Sander Model 1632



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1.0 Warranty and Service

Powermatic warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official Powermatic branded website.

- Powermatic products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. Powermatic woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. Powermatic has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the Powermatic website.

More Information

Powermatic is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the Powermatic website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

POWERMATIC LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. POWERMATIC SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Powermatic sells through distributors only. The specifications listed in Powermatic printed materials and on the official Powermatic website are given as general information and are not binding. Powermatic reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors, Machine Accessories
2 Year – Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery

NOTE: Powermatic is a division of JPW Industries, Inc. References in this document to Powermatic also apply to JPW Industries, Inc., or any of its successors in interest to the Powermatic brand.

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3.0 Safety warnings

As with all machines, there is a certain amount of hazard involved with the use of this sander. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.

1. **Read, understand and follow** the safety and operating instructions found in this manual. Know the limitations and hazards associated with this machine.
2. **Electrical grounding.** Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.
3. **Power on.** Before connecting power to the sander, make sure the start switch is in the "OFF" position.
4. **Protect yourself.** Protect yourself at all times when operating the wide belt sander. Avoid eye injury by wearing approved safety shields, goggles or glasses at all times (NOTE: Common eye glasses are only impact-resistant, they are *not* safety glasses). Wear protective footwear. Steel toed shoes are recommended because heavy parts can fall off the conveyor table onto feet.
5. **Personal protection.** Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows. Remove all loose outer clothing and confine long hair. Protective type footwear should be used. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations, use hearing protective devices. Do not wear gloves.
6. **Guards.** Do not operate the sander with guards off. Keep the guards in place at all times when the machine is running. If removed for maintenance purposes or any other reason, use extreme caution and replace the guards upon completion of the task and before using the machine again. Injury can result from exposure to the machine's internal moving parts.
7. **Check damaged parts.** Before continuing use of the machine, a guard or other part that is damaged should be carefully checked to

ensure that it will operate properly and safely and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that could affect its operation. A guard or other part that is damaged should be properly repaired or replaced before machine operation continues.

8. **Work area.** Keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Be sure the table is free of all scrap, foreign material and tools before starting to cut. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Powermatic recommends the use of anti-skid floor strips on the floor area where the operator normally stands and that each machine's work area be marked off. Provide adequate work space around the machine.
9. **Operator position.** Stand to one side of the conveyor table and make sure no one else is standing in line with the table while feeding into the machine. The wide belt sander operates at high speed and should a part slip, it will exit the machine at a high rate of speed and may result in injuries to anyone standing directly in front of the infeed. (Keep conveyor belt clean and check pin-roll adjustments.) Maintain a balanced stance and keep your body under control at all times. Do not overreach or use excessive force to perform any machine operation.
10. **Hand safety.** Keep hands clear while feeding parts onto the conveyor table. The part will be forced down as it begins to feed into the machine, causing a pinching action between the part and the table. Use caution! Hands should be clear of the stock and the table to avoid pinching. Never reach into a running machine. Turn off electrical power and stop machine before attempting to retrieve parts from within the machine. Contact with internal moving parts can result in loss or injury to fingers, hands and arms.
11. **Housekeeping.** Before turning on machine, remove all extra equipment such as keys, wrenches, scrap, and cleaning rags away from the machine
12. **Careless acts.** Give the work you are doing your undivided attention. Looking around, carrying on a conversation, and "horseplay" are careless acts that can result in serious injury.
13. **Disconnect machine** before performing any service or maintenance or when changing blades. A machine under repair should be

RED TAGGED to show it should not be used until the maintenance is complete.

14. **Maintain tools in top condition.** Keep all tools sharp and clean for the best and safest performance, and follow instructions for lubricating and changing accessories. Never stand on the machine. Serious injury could occur if the sander is tipped or if the sanding belt is accidentally contacted.
15. **Job completion.** The operator of the sander is responsible for shutting the machine down when it is not in use. **CAUTION:** The abrasive belt will coast to a stop in normal conditions, and will only break to a stop when the emergency devices are pressed! **IT IS DANGEROUS TO LEAVE A MACHINE UNATTENDED.** Persons not familiar with the sander's operation could injure themselves or others. **NEVER** clean the sander with power "ON" and never use the hands to clear sawdust and debris; use a brush or compressed air.
16. **Replacement parts.** Use only Powermatic or factory authorized replacement parts and accessories; otherwise the warranty and guarantee is null and void.
17. **Misuse.** Do not use this Powermatic open-end sander for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself

harmless for any injury or damage which may result from that use.

18. **If you are not** thoroughly familiar with the operation of wide belt sanders, obtain advice from your supervisor, instructor or other qualified person.
19. **Drugs, alcohol, medication.** Do not operate this machine while under the influence of drugs, alcohol, or any medication.

⚠ WARNING: This product can expose you to chemicals including lead and cadmium which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

⚠ WARNING: Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection.

Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠ WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

4.0 About this manual

This manual is provided by Powermatic, covering the safe operation and maintenance procedures for a Powermatic Model 1632 Open-End Sander. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions set forth in this document.

If there are questions or comments, please contact your local supplier or Powermatic. Powermatic can also be reached at our web site: www.powermatic.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠ WARNING **Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!**

Register your product using the mail-in card provided, or register online:
<http://www.powermatic.com/us/en/service-and-support/product-registration/>

5.0 Specifications

Stock number	1791250	1791251
Model number	1632-1	1632-3
Working width (reversing stock).....	16" (32")	16" (32")
Working thickness	5"	5"
Minimum board length.....	13-3/4"	13-3/4"
Head configuration	combination	combination
Feed motor	1/4 HP, 1 PH	1/4 HP, 3 Ph
Feed speeds (variable FPM).....	15/32.5	15/32.5
Sanding belt dimensions	17" W x 54" L.....	17" W x 54" L
Sanding belt grit	100	100
Sanding belt speed (SFPM).....	2,200	2,200
Table movement per one handwheel rotation.....	0.0082" (0.21mm).....	0.0082" (0.21mm)
Compressed air requirements at 5 atm (PSI)	4.....	4
Dust collection minimum CFM required	800	800
Dust port diameter.....	4"	4"
Overall dimensions.....	40" L x 29" W x 66" H.....	40" L x 29" W x 66" H
Main motor (1632-3).....	5HP, 1PH, 230V only	7-1/2HP, 3PH, 230/460V (prewired 230V)
Net weight	996 lbs.....	996 lbs.
Shipping weight.....	1,106 lbs.....	1,106 lbs.

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, Powermatic reserves the right to change specifications at any time and without prior notice, without incurring obligations.

6.0 Setup and assembly

Remove the sander from its crate and inspect for damage to ensure all parts are intact. Any damage should be reported to your distributor and shipping agent immediately upon discovery.

Before proceeding with installation, read your instruction manual thoroughly. Familiarize yourself with correct set-up, maintenance and safety procedures.

6.1 Shipping contents

- 1 Wide Belt Sander
- 1 Infeed Roller Assembly
- 1 Outfeed Roller Assembly
- 1 Side Support
- 1 Sanding Belt 100G
- 1 Toolbox, containing oil gun, door latches, and draw bar (for the graphite pad)

6.2 Installation

If using a forklift, run the forks between the upper cabinet and the conveyor belt. Level the machine and bolt it to the floor with high quality anchor bolts through the mounting holes located on the four corners of the base.

Remove the protective coating from the rollers with a soft cloth moistened with a good commercial solvent. DO NOT USE acetone, gasoline, lacquer thinner or any type of flammable solvent. Do not use an abrasive pad.

6.3 Assembly

1. Attach the infeed and outfeed roller assemblies with sixteen 5/16" x 2" hex head screws and spring washers.
2. Mount the side support with two hex cap screws and flat washers.
3. Insert the door latches into the slots on the cabinet doors.
4. Assemble the sanding belt to the rollers. Make sure the arrow on the belt matches the rotation of the rollers.

7.0 Electrical connections

⚠WARNING All electrical connections should be made by a qualified electrician in compliance with all relevant codes. Failure to comply may result in serious injury and/or damage to the machine and property. The machine must be properly grounded.

1. A cable of the proper gauge should be used to connect the sander to the power supply.
2. Remove the wiring cover and attach the ground wire (A), Figure 1.

3. For 3 Phase: Connect the three power leads (B) to the wiring board.

For 1 Phase: Connect the two power leads to the wiring board.

4. This machine should be hard wired into a dedicated circuit with a properly rated breaker according to your local code.
5. Replace wiring cover.
6. Turn on the feed belt and verify that the belt feeds into the machine. If it turns toward the user, disconnect the machine from the power source and switch only two of the power leads (on 3 Phase machine).

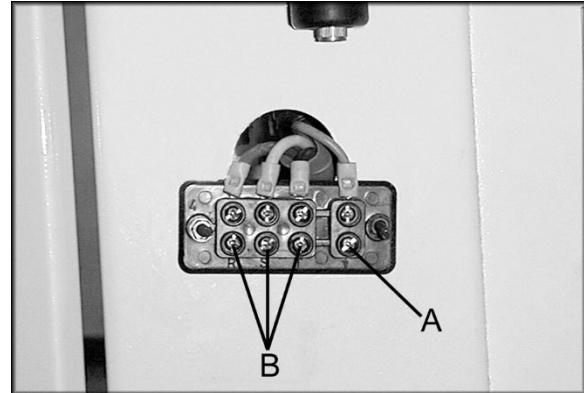


Figure 1

7.1 Voltage conversion

The 3 Phase machine is pre-wired for 230V operation. If 460V is needed, see the wiring box cover on the reduction motor and the main motor. BOTH motors must be switched if changing from 230V to 460V. The transformer, behind the control panel, must also be switched from 230V to 460V.

7.2 Extension cords

Amp Rating		Volts	Total length of cord in feet			
More Than	Not More Than	120	25	50	100	150
		240	50	100	200	300
			AWG			
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not Recommended	

Extension Cord Recommendations

Table 1

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 1 shows correct size to use depending on cord

length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

8.0 Adjustments

⚠WARNING Disconnect sander from power source before making adjustments.

8.1 Air control

Connect the machine to an air hose. The air pressure that flows into the filter can be adjusted with the knob (A), Figure 2. Normal working air pressure should be set at 75 psi, which can be read on the pressure gauge.

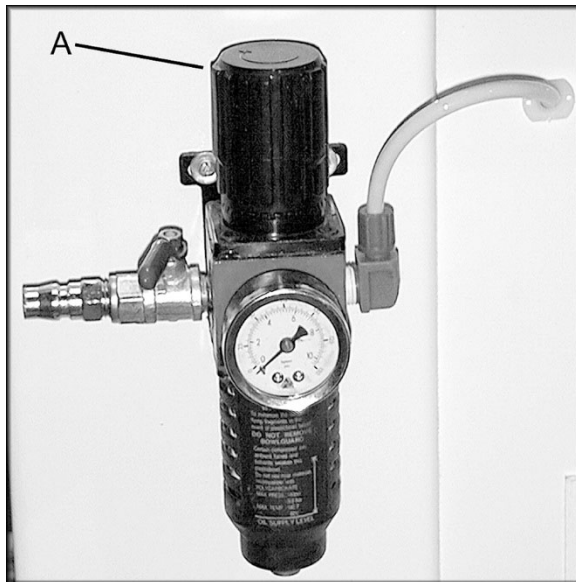


Figure 2

8.2 Sanding belt tracking and oscillation

The tracking and oscillation of your sander are pre-adjusted at the factory. However, should adjustment be required, do the following:

1. Adjust the air valve (A), Figure 3, to control the tracking sensitivity.
2. The oscillation speed can be controlled by adjusting the top air valve (B).
3. Empty the glass container (C) as needed.

NOTE: There is a limit switch at both ends of the upper roller. If the sanding belt comes in contact with these limit switches, the brakes will be activated.

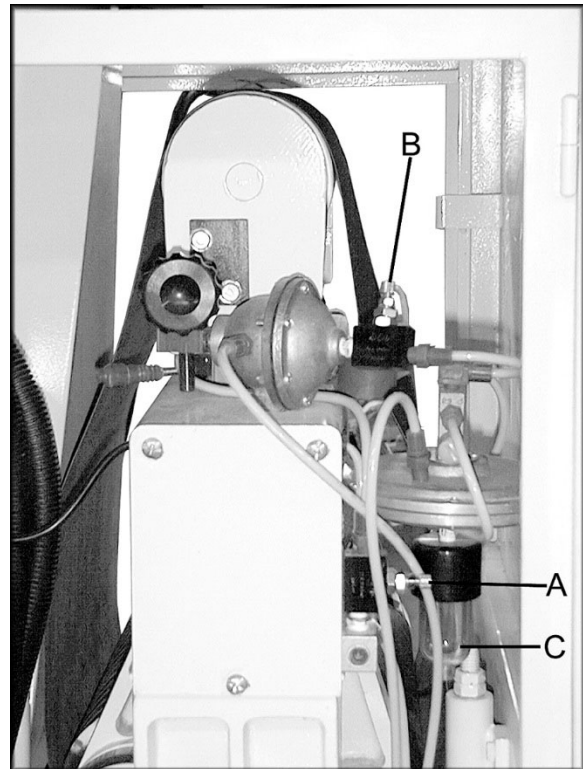


Figure 3

8.3 Feed belt tracking and tension

Tracking and tension for the feed belt is controlled by two socket set screws on each side of the belt (A) as shown in Figure 4.

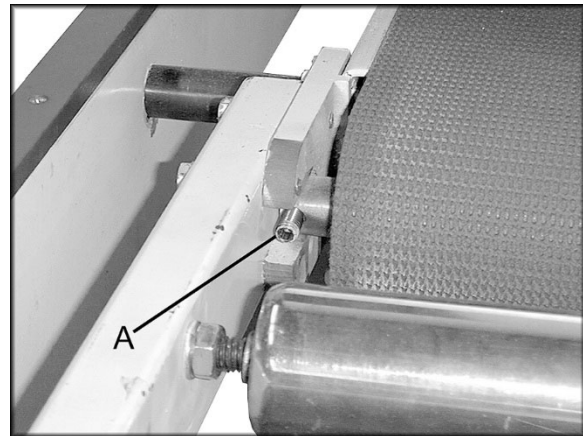


Figure 4

8.4 Adjusting table parallel to sanding surface

The table comes pre-adjusted from the factory. Check its parallelism by running a 16" wide piece of plywood through the sander. Use a pair of calipers to measure the thickness remaining on both sides.

Adjust the parallelism using the four hex. screws (A), under the table base. See Figure 5.



Figure 5

8.5 Feed speed adjustment

The Model 1632 has two speeds that feed the workpiece at 15 feet per minute (FPM) finished surface sanding, and 32.5 FPM for faster, lighter sanding.

To change the feed rate:

1. Disconnect machine from power source.
2. Remove cap screw that holds the sprocket cover at the right rear of the working table.
3. Loosen the four set screws holding the sprockets in place.
4. Remove the sprockets and chain together and position according to the required operation. See Figure 6.
5. Retighten the four set screws, then replace cover and cap screw.

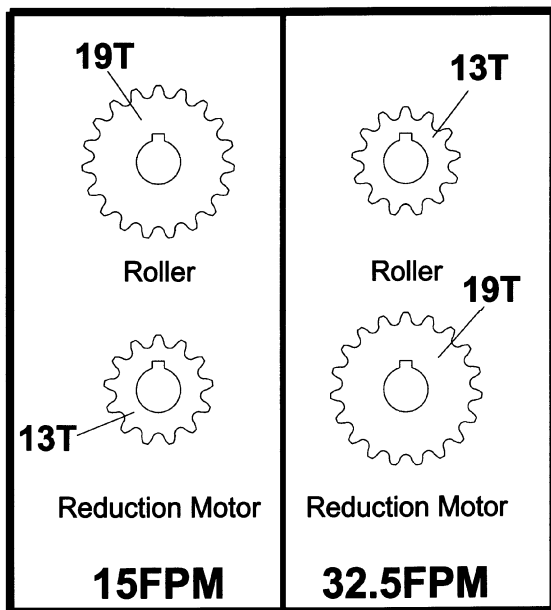


Figure 6

9.0 Operation

9.1 Controls

(see Figure 7):

Emergency stop (A) will stop the feeding belt and sanding belt. The button must be turned clockwise to reset sanding functions.

Amp Meter (B) displays the amperage.

Feeding Start (C) will start the feeding belt only.

Feeding Stop (D) will stop the feeding belt only.

Sanding Belt Start (E) will start the sanding belt only.

Sanding Belt Stop (F) will stop the sanding belt only.

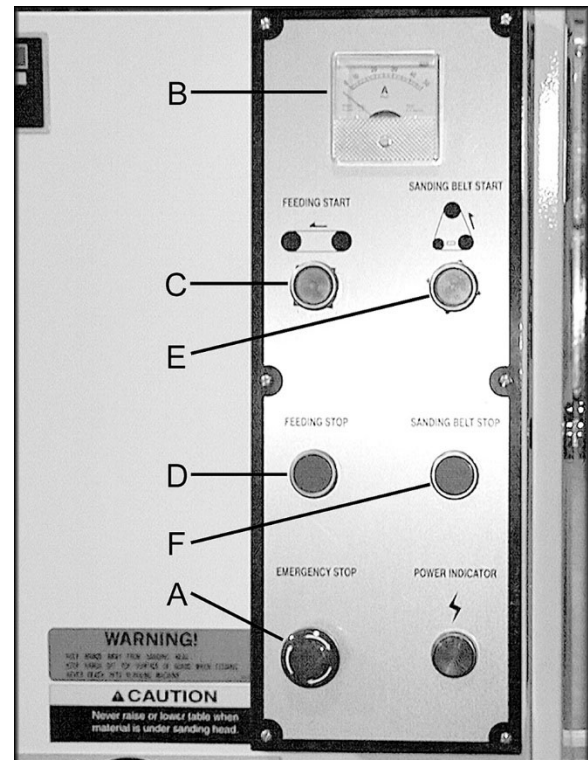


Figure 7

NOTE: The orange bar on the front of the infeed roller acts as a safety stop. When the bar is pressed, the brakes are applied.

1. Connect the air line to the sander.
2. Adjust the pressure gauge to 75 psi.
3. Engage the upper roller by turning the knob (A), Figure 8, to the upper position.
4. Adjust the platen with the lever (B) and lock it (C) in the desired position. The platen or main rubber roller can act as the sanding contact, as well as a combination of both.
5. Rotate the main handwheel (A), on the lower cabinet, to raise or lower the table. See Figure

9. Refer to the scale for the desired setting. The recommended depth of sanding is .0164" or two revolutions of the handwheel. The table can be locked in place by the lever at the base of the column.

6. Turn on the power to the machine.
7. Start the sanding belt.
8. Start the feeding conveyor.

NOTE: If you are sanding a workpiece greater than 16 inches, pull out the support extension, and tighten the wing nuts. After the first pass, the workpiece can be spun around and fed back through the machine, for a maximum sanding width of 32 inches.

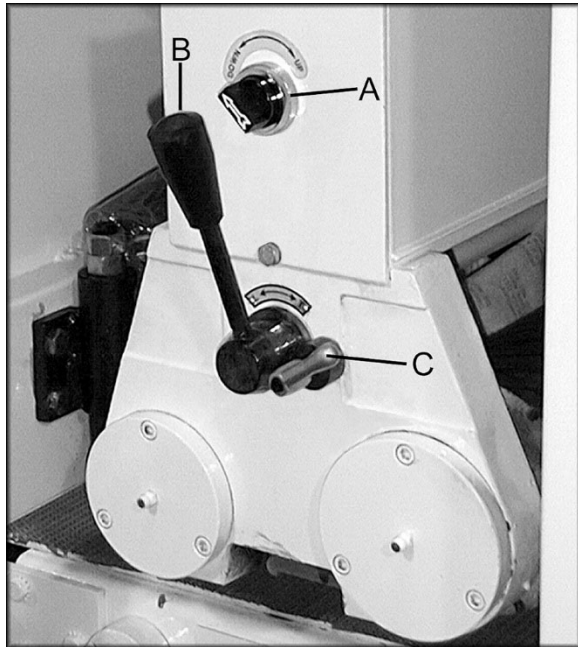


Figure 8

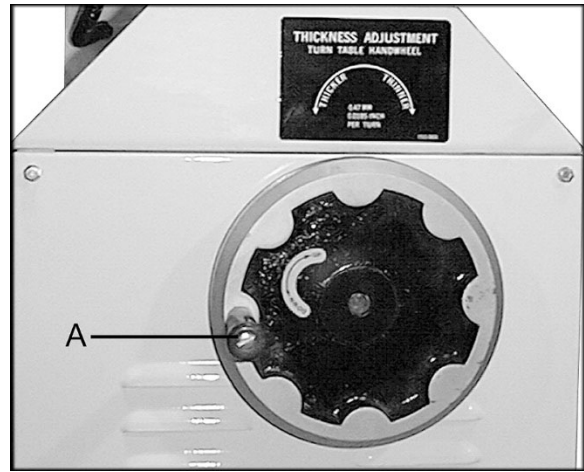


Figure 9

10.0 Maintenance

⚠ WARNING Before performing any maintenance on the sander, disconnect it from the electrical supply by pulling out the plug or switching off the main switch. Failure to comply may cause serious injury.

The interior of the machine should be thoroughly cleaned each day after using the sander.

Remove the sanding belt before cleaning and re-install it when finished.

Keep the sanding belt clean using cleaning sticks or pads (not provided).

Blow dust off the conveyor belt with compressed air or use a dust collector vacuum attachment.

The drum bearings should be greased (via grease fittings on each side) after every 150 work hours.

11.0 Troubleshooting the 1632 Sander

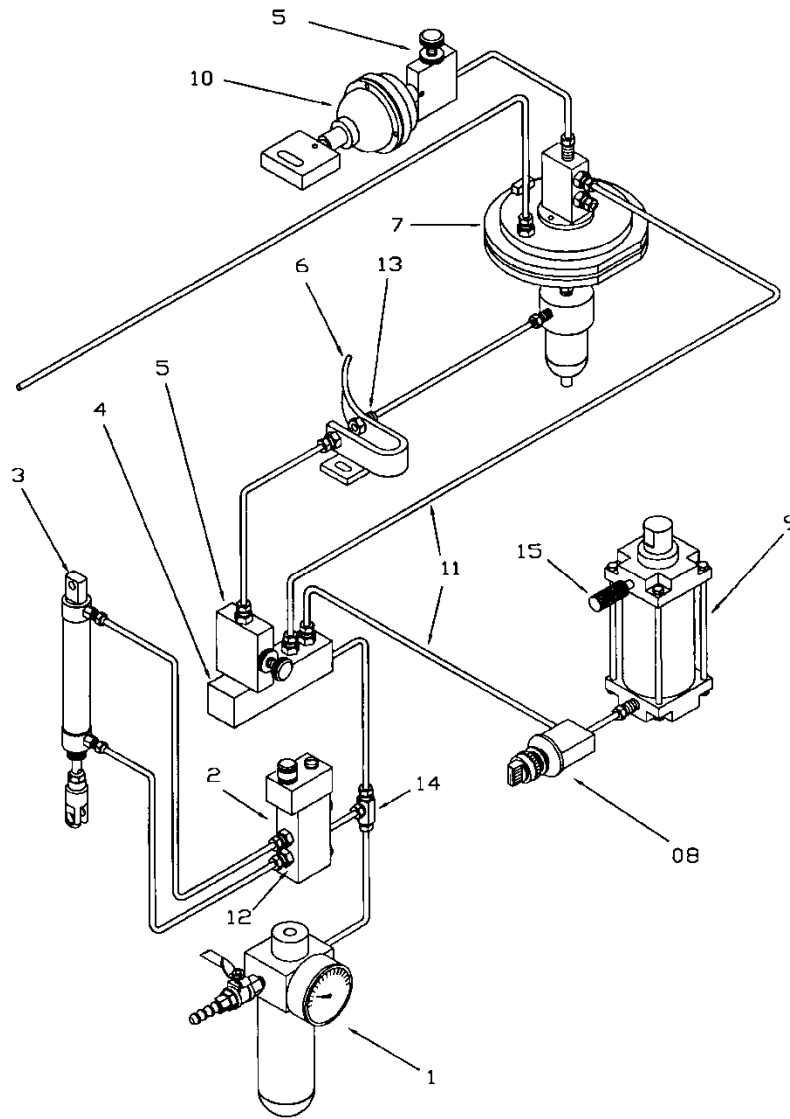
Symptom	Possible Cause	Correction
Motor will not start	Low voltage.	Check power line for proper voltage.
	Open circuit in motor or loose connection.	Inspect all lead connections on motor for loose or open connections.
Motor will not start: fuses or circuit breakers blow.	Short circuit in line cord or plug.	Inspect cord or plug for damaged insulation and shorted wires.
	Short circuit in motor or loose connections.	Inspect all connections on motor for loose or shorted terminals or worn insulation.
	Incorrect fuses or circuit breakers in power line.	Install correct fuses or circuit breakers.
The sanding belt clogs quickly.	Sandpaper grit too small.	Use larger grit.
	Too much material is being sanded off.	Reduce sanding depth.
	The wood is too dirty or oily.	Use dry stock.
	Suction is insufficient.	Increase suction.
Edges round when sanding.	Too much material being removed.	Reduce sanding depth.
The thickness differs on left and right sides of workpiece.	Conveyor table not parallel to contact roller or platen.	Adjust table to parallel.
	Worn out felt and graphite on platen head	Replace felt/graphite.
The thickness differs on front and back sides of workpiece.	Feed speed too fast.	Reduce speed.
	Too much material is being removed.	Reduce sanding depth.
	Sandpaper grit too fine.	Use coarser grit
	Pressure plate not level	Adjust plate to level.
Workpiece slips on conveyor belt.	Too much or too little pressure from pressure plate.	Adjust to proper pressure.
	Sanding belt clogged with dust.	Blow out dust with high-pressure air.
	Belt worn out.	Replace belt.
Straight notch grooves on workpiece.	Dirty pressure roller.	Clean pressure roller.
	Rubber roller scratched.	Replace rubber roller.
	Worn out lining and graphite on platen head.	Replace lining/graphite.
Snake marks on workpiece.	Sanding belt partially damaged.	Repair or replace sanding belt.
	Sanding grit loose.	Replace sanding belt.
Belt slips out of track.	Tracking air valve is clogged or not open enough.	Clean/enlarge valve opening.
Straight parallel stripes across the workpiece.	Sanding belt joint is too thick.	Replace sanding belt
	Sanding belt is worn.	Replace sanding belt.

12.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

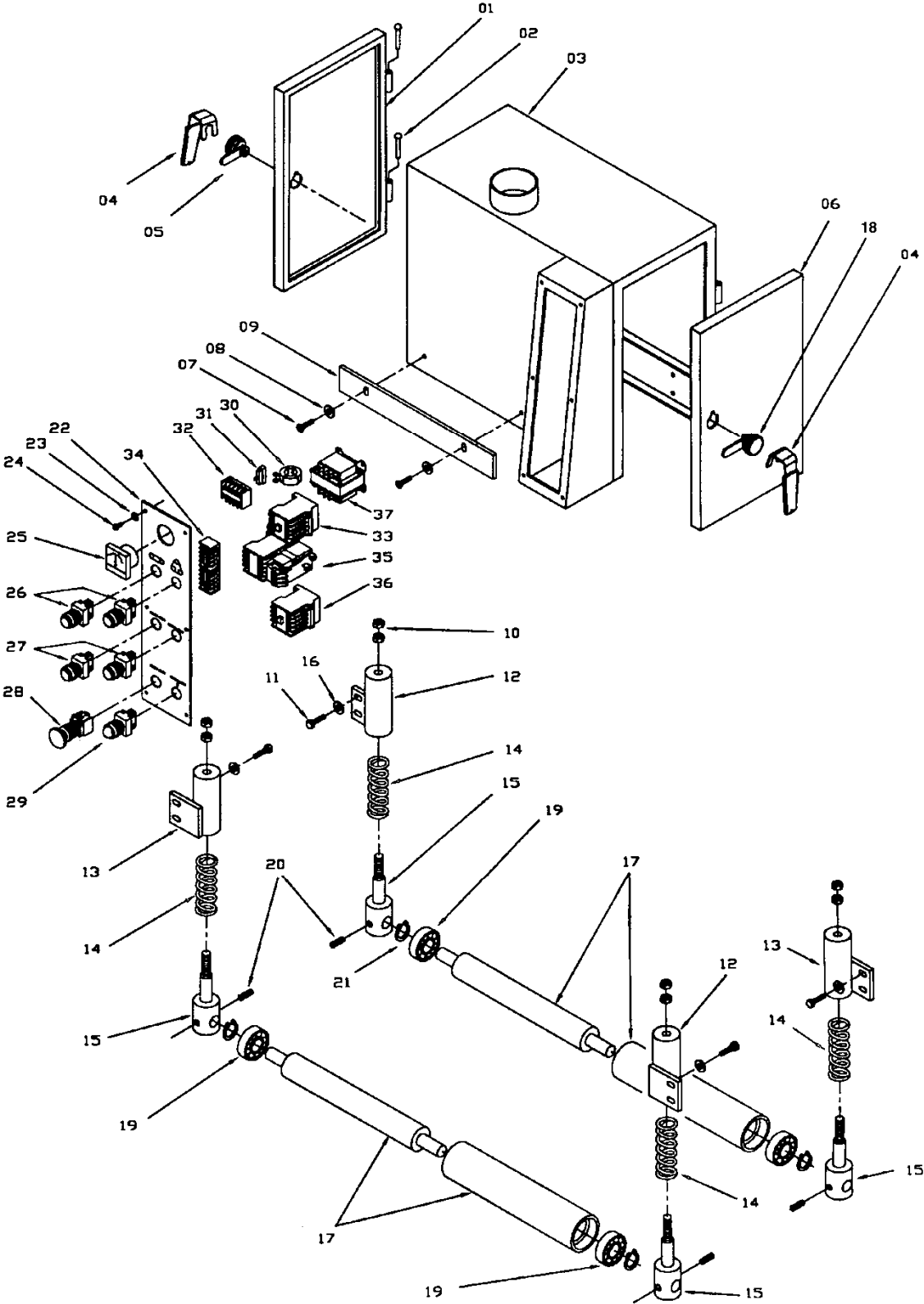
12.1.1 Air Control Assembly – Exploded View



12.1.2 Air Control Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	6293482	Filter		1
2	6293483	Solenoid Valve		1
3	6293484	Brake Cylinder		1
4	6293485	Multi-Hole Connector		1
5	6293486	Air Valve		1
6	6293487	Air Sensor Assembly		1
7	6293488	Air Sensor		1
8	6293489	Switching Valve		1
9	6293250	Cylinder		1
10	6293252	Oscillator Cylinder		1
11	6293490	Plastic Pipe		1
12	6293491	Plastic Joint	PT-1/8"	1
13	6293492	Copper Joint		1
14	6293493	T-Joint		1
15	6293494	Silencer		1

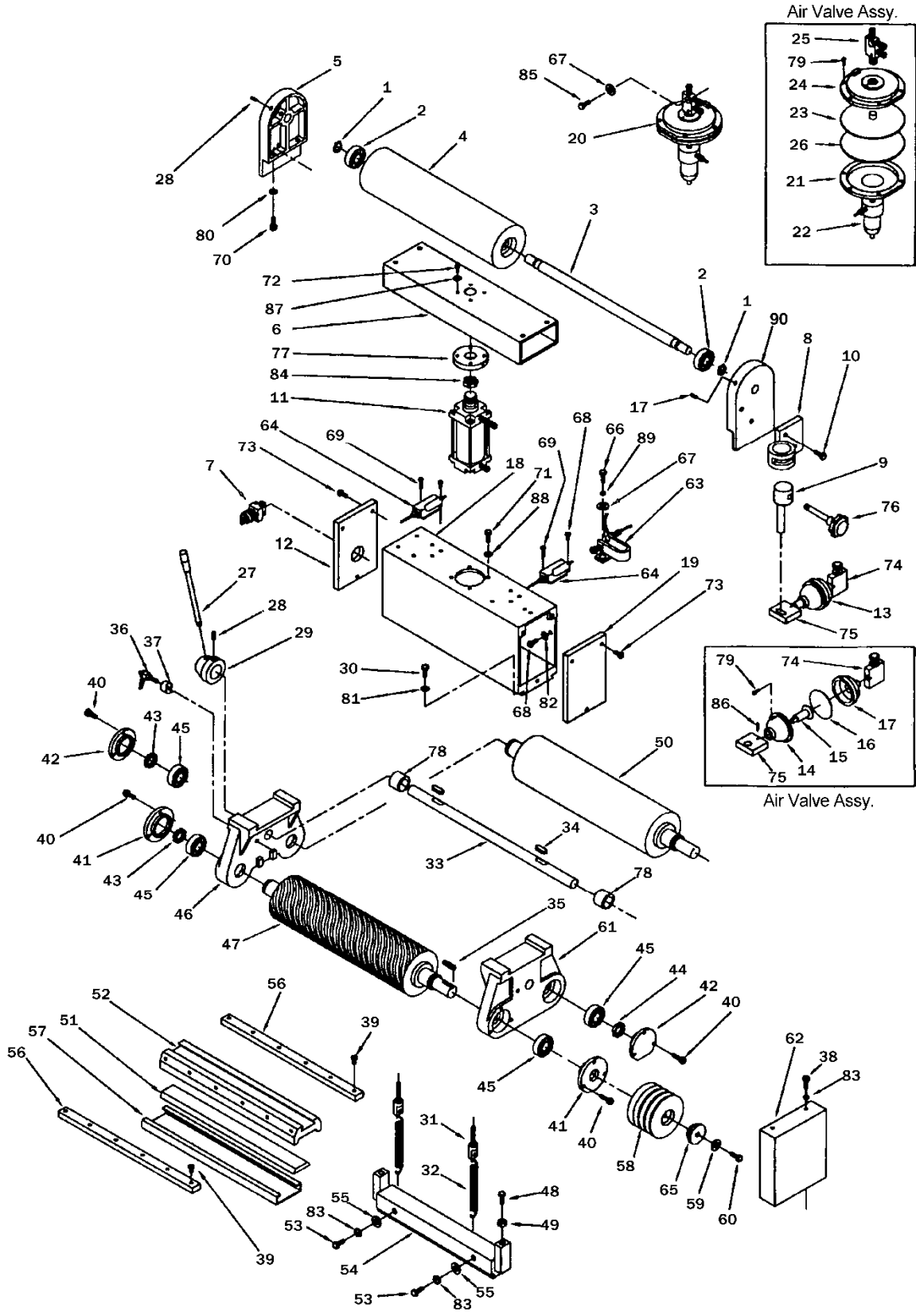
12.2.1 Electrical Control and Upper Adjustment Roller – Exploded View



12.2.2 Electrical Control and Upper Adjustment Roller – Parts List

Index No	Part No	Description	Size	Qty
1	6293203	Upper Door (L)		1
2	6293204	Pin for Upper Door		2
3	6293205	Upper Cabinet		1
4	6293206	Door Knob		2
5	6293207	Door Latch (L)		1
6	6293208	Upper Door (R)		1
7	6293209	Pan Head Screw	1/4" x 1/2"	2
8	6293210	Flat Washer	1/4"	2
9	6293211	Plate		1
10	6293212	Hex Nut		8
11	6293213	Hex Head Screw	1/2"	8
12	6293214	Adjust Stand (L)		2
13	6293215	Adjust Stand (R)		2
14	6293216	Spring		4
15	6293217	Fixed Roller Stand w/ Adjust Bolt		4
16	6293218	Flat Washer	3/8"	8
17	6293219	Shaft & Rubber Roller		2
18	6293311	Door Latch (R)		1
19	6293221	Ball Bearing		4
20	6293222	Set Screw	1/4" x 3/4"	4
21	6293223	Ring		4
22	6293224	Control Plate		1
23	6293225	Gear Washer	3/16"	6
24	6293226	Pan Head Screw	3/16" X 3/8"	6
25	6293227	Amp Meter		1
26	6293228	Feed Start Switch		1
	6293228	Sanding Belt Start Switch		1
27	6293229	Feed Stop Switch		1
	6293229	Sanding Belt Stop Switch		1
28	6293230	Stop Switch		1
29	6293231	Power Indicator Light		1
30	6293232	Current Coil		1
31	6293233	Fuse Stand (5 HP)		1
	6293312	Fuse Stand (7-1/2 HP)		1
32	6293234	Terminal Strip (5 HP)		1
	6293313	Terminal Strip (7-1/2 HP)		1
33	1632-233	Relay (5 HP)		1
	6293314	Relay (7-1/2 HP)		1
34	6293236	Terminal Strip (5 HP)		1
	6293315	Terminal Strip (7-1/2 HP)		1
35	1632-235	Overload Relay (5 HP)		1
	6293316	Overload Relay (7-1/2 HP)		1
36	1632-236	Relay (5 HP)		1
	6293317	Relay (7-1/2 HP)		1
37	6293239	Transformer (5 HP)		1
	6293318	Transformer (7-1/2 HP)		1

12.3.1 Sanding Drum Assembly – Exploded View

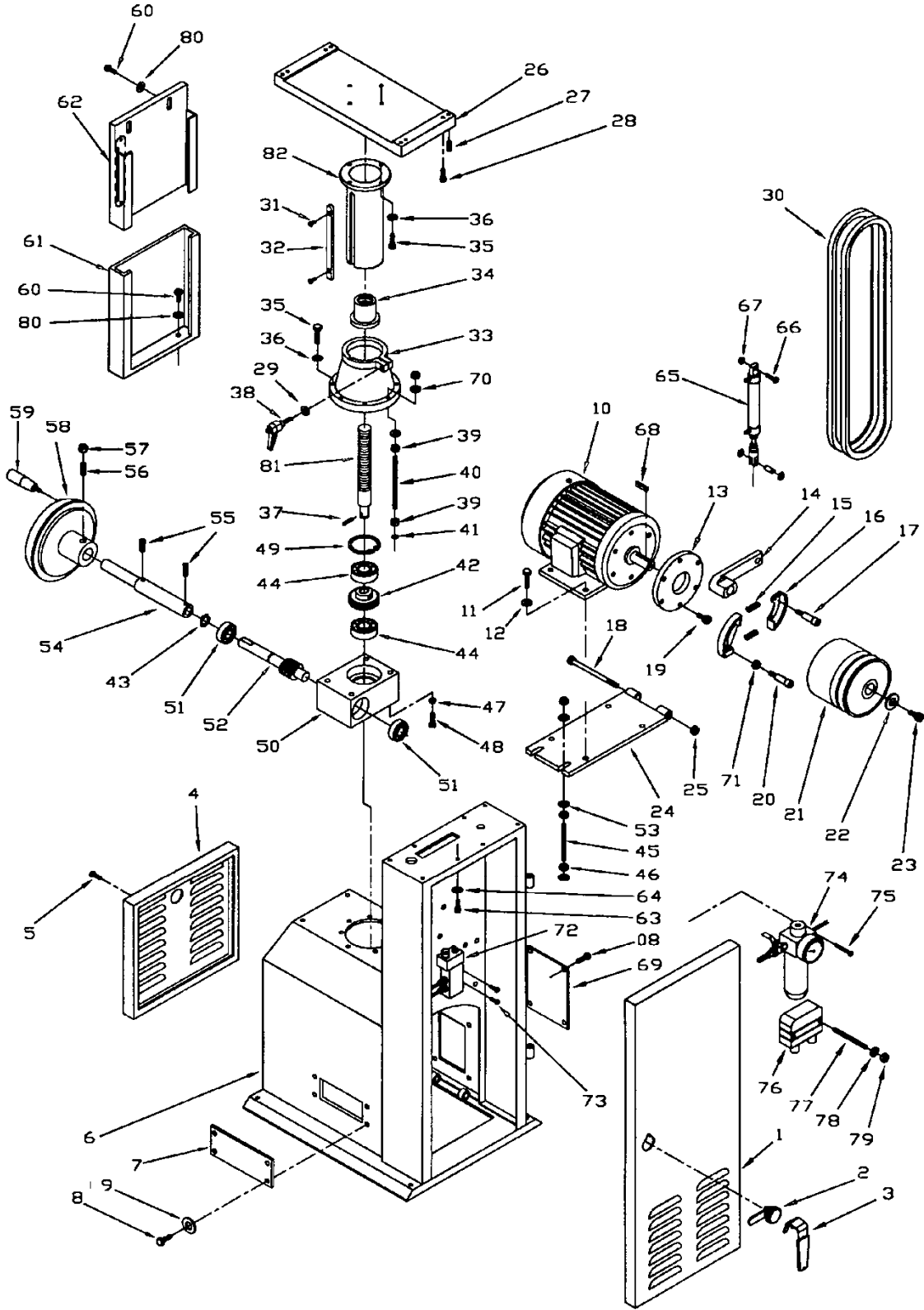


12.3.2 Sanding Drum Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	6293240	Ring		2
2	6293241	Ball Bearing		2
3	6293242	Shaft		1
4	6293243	Upper Roller		1
5	6293244	Upper Roller Base (L)		1
6	6293245	Column		1
7	6293246	Switch Valve		1
8	6293247	Eccentric Shaft Base		1
9	6293248	Eccentric Shaft		1
10	6293249	Hex Head Screw	5/16" x 1/2"	2
11	6293250	Air Cylinder Assembly		1
12	6293251	Cover (L)		1
13	6293252	Air Oscillator Cylinder		1
	6293496	Air Valve Assembly (Items 14 thru 17, 74, 75, 79 & 86)		1
14	6293253	Front Cover		1
15	6293254	Oscillator Shaft		1
16	6293255	Membrane		1
17	6293256	Rear Cover		1
18	6293257	Column		1
19	6293258	Cover (R)		1
20	6293259	Air Sensor		1
	6293497	Air Valve Assembly (Items 21 thru 26 & 79)		1
21	6293260	Lower Cover		1
22	6293261	Air Sensor Substance		1
23	6293262	Piston		1
24	6293263	Upper Cover		1
25	6293264	Plastic Joint Assembly		1
26	6293265	Membrane		1
27	6293266	Handle Assembly		1
28	6293267	Set Screw	1/4" x 1/4"	1
29	6293268	Handle Hub		1
30	6293269	Hex Head Screw	3/8" x 1-1/4"	4
31	6293270	Adjust Bolt	3/8" x 1-1/4"	2
32	6293271	Spring		2
33	6293272	Shaft		1
34	6293273	Key	5 x 5 x 30mm	2
35	6293274	Key	8 x 8 x 4 mm	1
36	6293275	Lock Handle		1
37	6293276	Knob		1
38	6293277	Hex Head Screw	3/8" x 1-1/2"	2
39	6293278	Pan Head Screw	5/32" x 3/8"	6
40	6293279	Hex Socket Cap Screw	1/4" x 1/2"	12
41	6293280	Bearing Cover		2
42	6293281	Bearing Cover (L)		1
	6293282	Bearing Cover (R)		1
43	6293283	Lock Nut (counter-clockwise)		2
44	6293284	Lock Nut (clockwise)		1
45	6293285	Ball Bearing		4
46	6293286	Round Bearing Frame		1
47	6293287	Main Rubber Roller		1
48	6293288	Hex Head Screw	5/16" x 1-3/4"	2
49	6293289	Hex Nut	5/16"	2
50	6293290	Back Steel Roller		1
51	6293291	Blanket		1
52	6293292	Pad Slider		1
53	6293293	Hex Head Screw	3/8" x 1"	2
54	6293294	Pad		1
55	6293218	Flat Washer	3/8"	2
56	6293295	Pressing Bar		2

Index No	Part No	Description	Size	Qty
57	6293296	Graphite Canvas		1
58	6293297	Pulley (5 HP)		1
	6293298	Pulley (7-1/2 HP)		1
59	6293299	Flat Washer	5/16"	1
60	6293300	Hex Head Screw	5/16" x 1"	1
61	6293301	Rectangular Bearing Base		1
62	6293302	Cover		1
63	6293303	Air Sensor Assembly		1
64	6293304	Limit Switch		2
65	6293305	Disk		1
66	6293306	Hex Head Screw	1/4" x 3/8"	1
67	6293210	Flat Washer	1/4"	1
68	6293330	Pan Head Screw	5/32" x 1/2"	2
69	6293331	Pan Head Screw	5/32" x 1"	2
70	6293332	Hex Head Screw	5/16" x 2"	4
71	6293333	Cap Screw	M8 x 20	4
72	6293334	Hex Head Screw	1/4" x 2"	4
73	6293209	Pan Head Screw	1/4" x 1/2"	6
74	6293335	Air Valve		1
75	6293336	Block Connector		1
76	6293337	Knob		1
77	6293338	Cylinder Disk		1
78	6293339	Eccentric Roller		2
79	6293340	Pan Head Screw	3/16" x 5/8"	8
80	6293341	Gear Washer	5/16"	4
81	6293342	Gear Washer	3/8"	4
82	6293343	Flat Washer	5/32"	1
83	6293344	Spring Washer	3/8"	2
84	6293345	Hex Nut		1
85	6293346	Hex Head Screw	1/4" x 1/2"	1
86	6293347	Spring Pin	3" x 16"	1
87	6293348	Gear Washer	1/4"	4
88	6293349	Gear Washer	M8	4
89	6293350	Spring Washer	1/4"	1
90	6293501	Upper Roller Base (R)		1

12.4.1 Base and Table Adjustment Assembly – Parts List

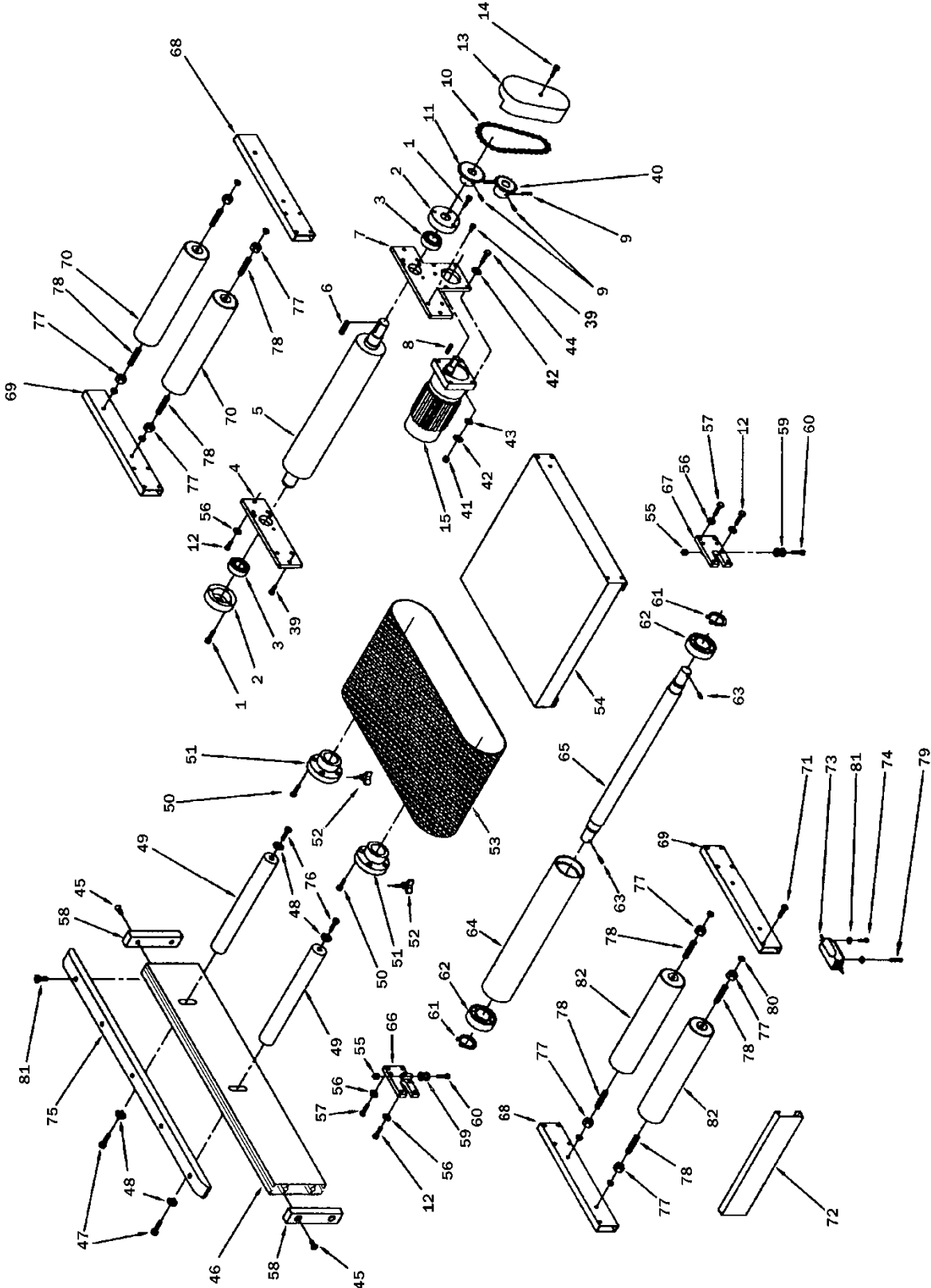


12.4.2 Base and Table Adjustment Assembly – Parts List

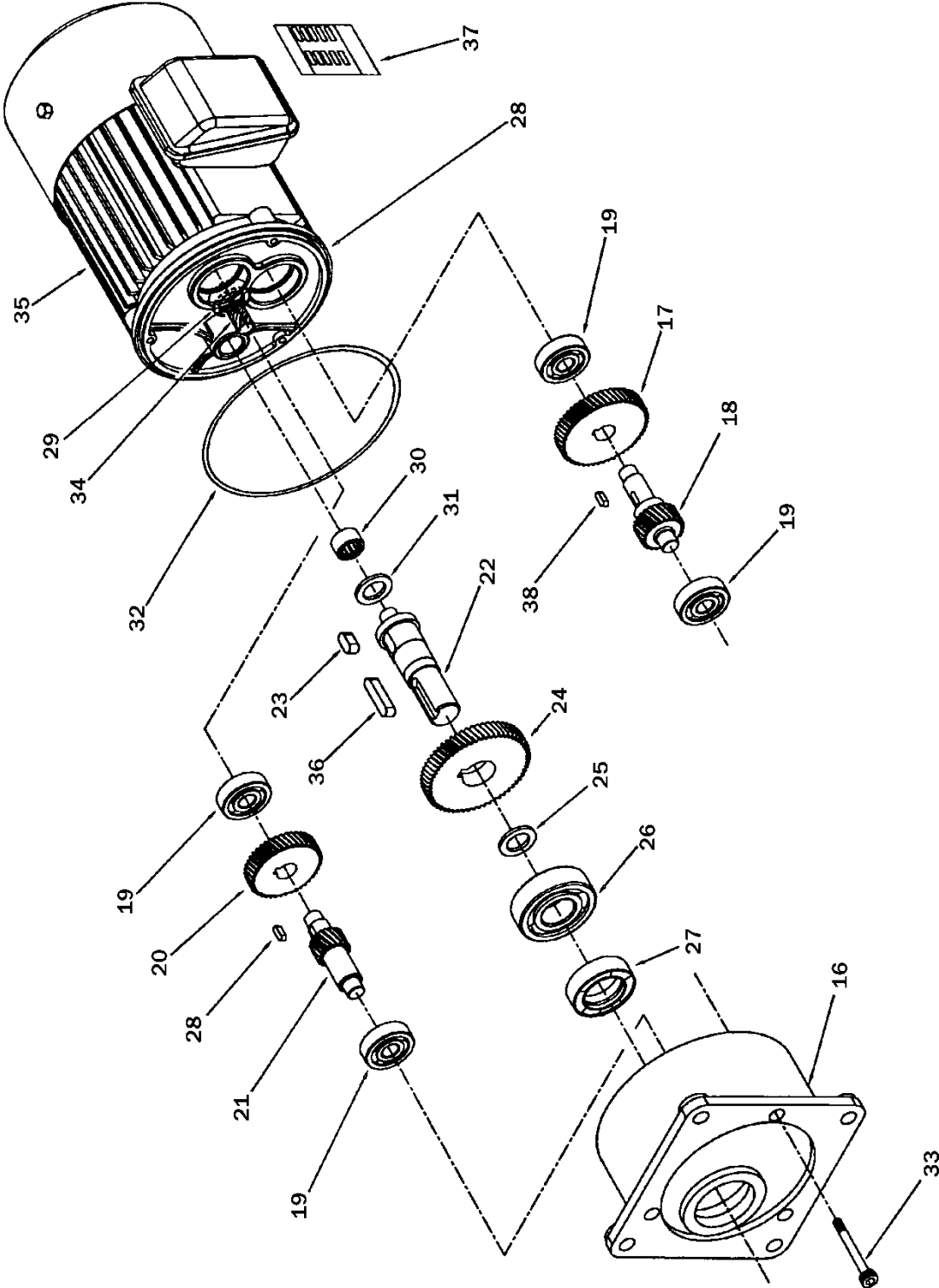
Index No	Part No	Description	Size	Qty
1	6293415	Door		1
2	6293416	Crosspiece		1
3	6293417	Door Knob		1
4	6293418	Cover		1
5	6293419	Hex Head Screw	1/4" x 1"	4
6	6293420	Base		1
7	6293421	Cover		1
8	6293422	Hex Head Screw	3/16" x 3/8"	4
9	6293423	Flat Washer	3/16"	4
10	1632-410	Motor (s/n 05061632360 and higher)	5 HP, 1 PH	1
	6293425	Motor	7-1/2 HP, 3 PH	1
11	6293293	Hex Head Screw	3/8" x 1"	4
12	6293426	Lock Washer	3/8"	4
13	6293427	Brake Base		1
14	6293428	Brake Pole		1
15	6293429	Brake Spring		2
16	6293430	Brake		2
17	6293431	Bolt	5/16" x 1-1/2"	1
18	6293432	Bolt	1/2"	1
19	6293433	Socket Head Screw	5/16" x 1/2"	6
20	6293434	Bolt	3/8" x 1-1/2"	1
21	1632-421	Pulley (5 HP)		1
	6293436	Pulley (7-1/2 HP)		1
22	6293210	Flat Washer	1/4"	1
23	6293437	Hex Head Screw	1/4" x 1"	1
24	1632-424	Motor Plate (5 HP) (s/n 05061632360 and higher)		1
	6293439	Motor Plate (7-1/2 HP)		1
25	6293212	Hex Nut	1/2"	1
26	6293440	Base		1
27	6293441	Set Screw	5/16" x 1"	4
28	6293442	Hex Socket Cap Screw	5/16" x 1-1/2"	4
29	6293299	Flat Washer	5/16"	1
30	1632-430	Belt (s/n 05061632360 and higher)	A-84	2
31	6293444	Flat Head Screw	1/4" x 1/2"	2
32	6293445	Key	19 x 3/8 x 270	1
33	6293446	Base Lifting Pipe		1
34	6293447	Cap Screw	3/4"	1
35	6293249	Hex Head Screw	5/16" X 1/2"	4
36	6293341	Gear Washer	5/16"	4
37	6293448	Spring Pin	5 x 25mm	1
38	6293449	Lock Handle		1
39	6293450	Hex Nut	1/4"	2
40	6293451	Bolt	1/4" x 290mm	1
41	6293452	Lock Washer	1/4"	1
42	6293453	Gear		1
43	6293454	Ring		1
44	6293455	Ball Bearing		2
45	6293456	Bolt	3/8" X 4"	2
46	6293457	Hex Nut	3/8"	6
47	6293218	Flat Washer	3/8"	4
48	6293458	Hex Head Screw	3/8" X 1-3/4"	4
49	6293459	Ring		1
50	6293460	Gear Box		1
51	6293461	Ball Bearing		2
52	6293462	Worm Gear		1
53	6293218	Flat Washer	3/8"	4
54	6293463	Shaft		1
55	6293267	Set Screw	1/4" x 1/4"	2
56	6293464	Set Screw	1/4" x 1"	1

Index No	Part No	Description	Size	Qty
57	6293450	Hex Nut	1/4"	1
58	6293465	Wheel	8"	1
59	6293466	Handle		1
60	6293209	Pan Head Screw	1/4" x 1/2"	2
61	6293467	Lower Guard		1
62	6293468	Upper Guard		1
63	6293277	Hex Head Screw	3/8" x 1-1/2"	8
64	6293342	Gear Washer	3/8"	8
65	6293469	Air Cylinder Assembly		1
66	6293300	Hex Head Screw	5/16" x 1"	2
67	6293289	Hex Nut, 5/16"		2
68	6293470	Key (7-1/2 HP)	10 x 8 x 60mm	1
	6293471	Key (5 HP)		1
69	6293472	Cover		1
70	6293210	Flat Washer	1/4"	2
71	6293457	Hex Nut	3/8"	1
72	6293473	Solenoid Valve		1
73	6293331	Pan Head Screw	5/32" x 1"	2
74	6293474	Filter		1
75	6293475	Pan Head Screw	5/32" x 1-3/8"	1
76	6293476	Hookup Box		1
77	6293477	Screw	3/16" X 1-3/8"	2
78	6293478	Flat Washer	3/16"	2
79	6293479	Hex Nut	3/16"	2
80	6293210	Flat Washer	1/4"	4
81	6293480	Screw Lead	3/4"	1
82	6293481	Lifting Pipe		1

12.5.1 Conveyor Belt and Table – Exploded View



12.5.2 Reduction Motor – Exploded View



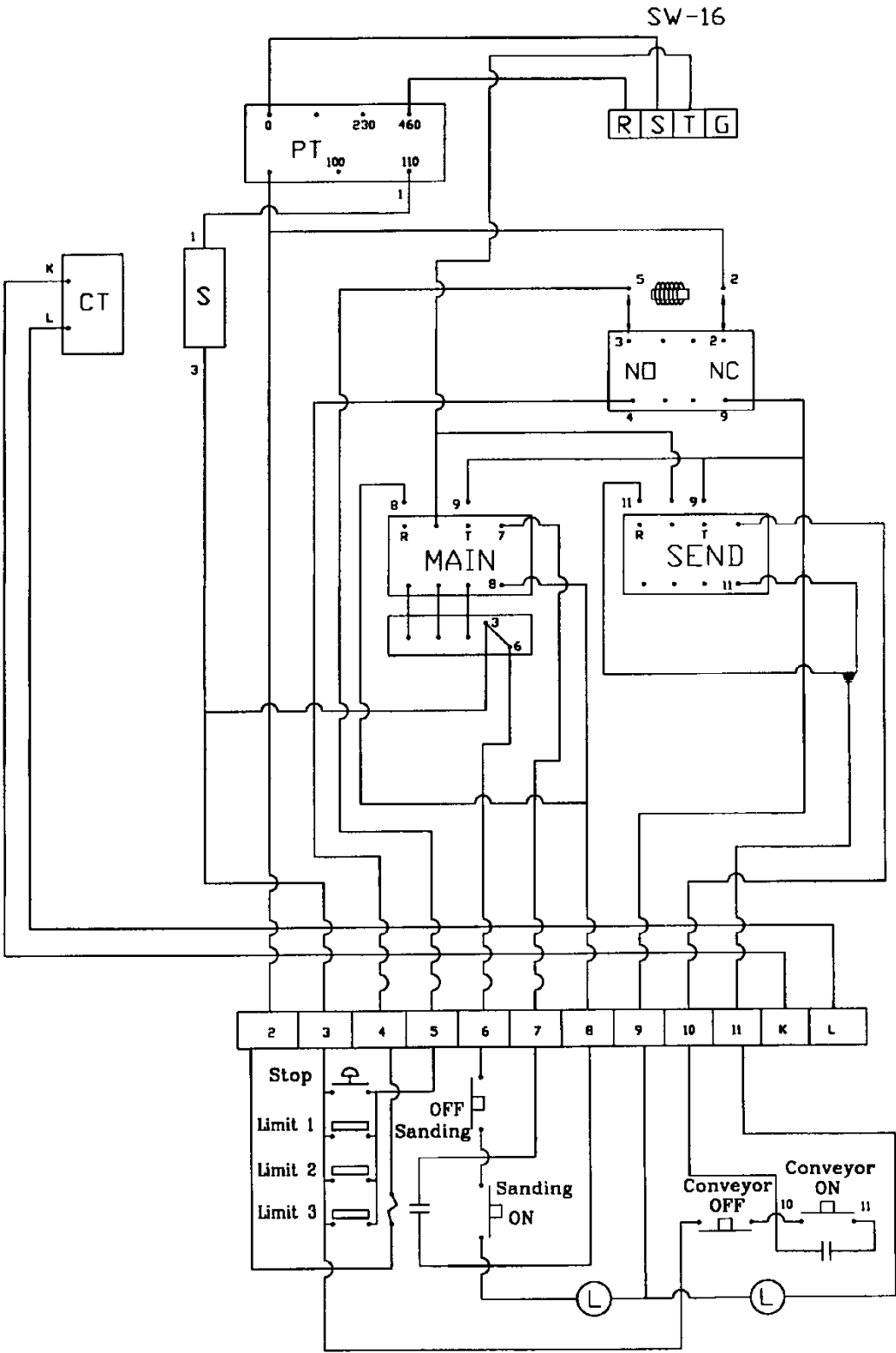
12.5.3 Conveyor Belt and Table; Reduction Motor – Parts List

Index No	Part No	Description	Size	Qty
1	6293351	Hex Socket Cap Screw	1/4" x 1/4"	6
2	6293352	Bearing Cover		2
3	6293353	Ball Bearing		2
4	6293354	Back Conveyor Roller Base (L)		1
5	6293355	Roller		1
6	6293356	Key	6 x 6 x 20mm	1
7	6293357	Back Conveyor Roller & Motor Base		1
8	6293358	Key	5 x 5 x 25mm	1
9	6293267	Set Screw	1/4" x 1/4"	4
10	6293359	Chain		1
11	6293360	Sprocket		1
12	6293332	Hex Head Screw	5/16" x 2"	5
13	6293361	Cover		1
14	6293362	Hex Socket Cap Screw	1/4" X 2"	1
15	6293495	Reduction Motor Assembly, 1 PH (Items 16 thru 38)		1
	6293498	Reduction Motor Assembly, 3 PH (Items 16 thru 38)		1
16		Body		1
17		Gear B	40T	1
18		Gear A	19T	1
19		Ball Bearing		4
20		Gear B	47T	1
21		Gear C	14T	1
22		Output Shaft		1
23		Key	5 x 5 x 10mm	1
24		Gear D	46T	1
25		Washer		1
26		Ball Bearing		1
27		Oil Seal	20, 35, 7	1
28		Rear Cover		1
29		Oil Seal	12, 22, 5	1
30		Needle Bearing	1012	1
31		Washer		1
32		O-Ring		1
33		Fixing Screw		3
34		Gear A	8T	1
35		Motor	1/4 HP, 1 PH	1
		Motor	1/4 HP, 3 PH	1
36		Key	5 x 5 x 25mm	1
37		Motor Label		1
38		Key	4 x 4 x 10mm	2
39	6293385	Hex Head Screw	5/16" x 3/8"	6
40	6293386	Sprocket		1
41	6293289	Hex Nut	5/16"	4
42	6293341	Gear Washer	5/16"	8
43	6293299	Flat Washer	5/16"	8
44	6293249	Hex Head Screw	5/16" x 1/2"	4
45	6293387	Flat Head Screw	5/32" x 1"	4
46	6293388	Stop Plate		1
47	6293277	Hex Head Screw	3/8" x 1-1/2"	2
48	6293218	Flat Washer	3/8"	4
49	6293389	Shaft		2
50	6293331	Pan Head Screw	5/32" x 1"	8
51	6293390	Shaft Base		2
52	6293391	Wing Screw	1/4" x 1/2"	2
53	6293392	Conveyor Belt		1
54	6293393	Working Table		1
55	6293289	Hex Nut	5/16"	2
56	6293394	Spring Washer	5/16"	8
57	6293300	Hex Head Screw	5/16" X 1"	8

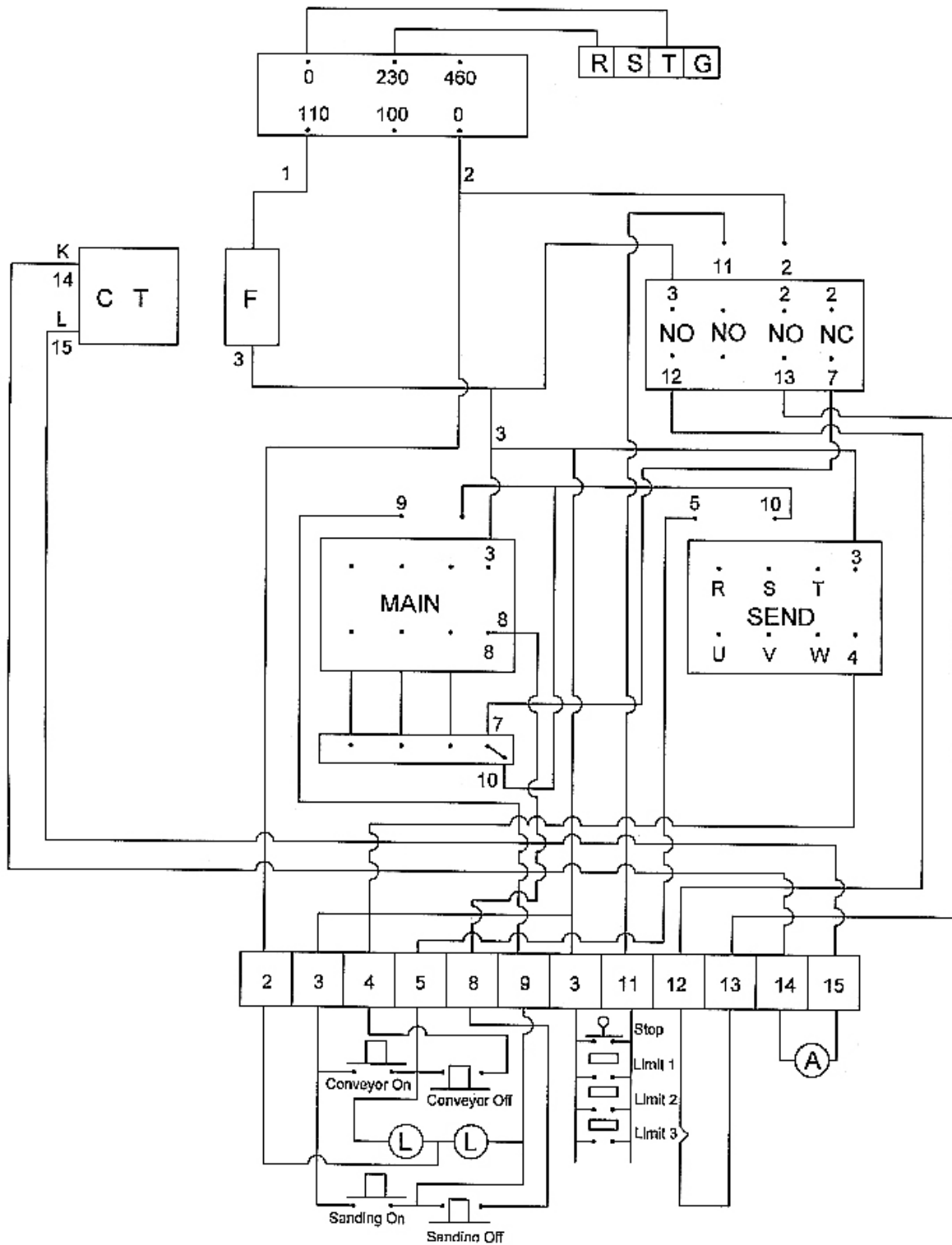
Index No	Part No	Description	Size	Qty
58	6293395	Stop Plate Annex		2
59	6293396	PVC Roller		2
60	6293397	Hex Head Screw	5/16" X 1-1/2"	2
61	6293398	Ring		2
62	6293241	Ball Bearing		2
63	6293399	Adjust Bolt	3/8" X 1-1/2"	2
64	6293400	Roller		1
65	6293401	Shaft		1
66	6293402	Roller Base (L)		1
67	6293403	Roller Base (R)		1
68	6293404	Roller Frame (L)		2
69	6293405	Roller Frame (R)		2
70	6293406	Roller		2
71	6293407	Pan Head Screw	5/32" X 1-3/4"	2
72	6293408	Front Plate		1
73	6293409	Limit Switch		1
74	6293330	Pan Head Screw	5/32" X 1/2"	1
75	6293410	Bakelite		1
76	6293411	Hex Head Screw	3/8" X 1/2"	2
77	6293212	Hex Nut	1/2"	8
78	6293412	Bolt	1/2" X 1-3/8"	8
79	6293331	Pan Head Screw	5/32" X 1"	1
80	6293413	Spring Washer	1/2"	8
81	TS-1550021	Flat Washer		5
82	6293500	Roller		2

13.0 Electrical Connections – 1632 Sander

13.1 460V – 3 Phase



13.2 230V – 1 Phase / 3 Phase



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