

MODEL W1855
4" x 36" HORIZONTAL/VERTICAL
BELT SANDER w/6" DISC



OWNER'S MANUAL
(FOR MODELS MANUFACTURED SINCE 6/17)

Phone: (360) 734-3482 • Online Technical Support: techsupport@woodstockint.com

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#19081JH Printed in China



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains 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.

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

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INTRODUCTION

Woodstock Technical Support

This machine has been specially designed to provide many years of trouble-free service. Close attention to detail, ruggedly built parts and a rigid quality control program assure safe and reliable operation.

Woodstock International, Inc. is committed to customer satisfaction. Our intent with this manual is to include the basic information for safety, setup, operation, maintenance, and service of this product.

We stand behind our machines! In the event that questions arise about your machine, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: tech-support@shopfox.biz. Our knowledgeable staff will help you troubleshoot problems and process warranty claims.

If you need the latest edition of this manual, you can download it from <http://www.shopfox.biz>.
If you have comments about this manual, please contact us at:

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MACHINE SPECIFICATIONS



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MODEL W1855 4" X 36" HORIZONTAL/VERTICAL BELT SANDER WITH 6" DISC

Product Dimensions

Weight..... 38 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 17-1/2 x 14-1/2 x 24 in.
 Footprint (Length x Width)..... 15 x 6 in.

Shipping Dimensions

Type..... Cardboard Box
 Content..... Machine
 Weight..... 41 lbs.
 Length x Width x Height..... 23 x 12 x 13 in.
 Must Ship Upright..... Yes

Electrical

Power Requirement..... 120V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 4.3A
 Minimum Circuit Size..... 15A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 18 AWG
 Plug Included..... Yes
 Included Plug Type..... NEMA 5-15
 Switch Type..... Toggle Safety Switch w/Removable Key

Motors

Main

Type..... Capacitor-Start Induction
 Horsepower..... 1/2 HP
 Phase..... Single-Phase
 Amps..... 4.3A
 Speed..... 3600 RPM
 Power Transfer Belt Drive
 Bearings..... Shielded & Permanently Lubricated



Main Specifications

Belt Sander Info

Sanding Belt Width.....	4 in.
Sanding Belt Length.....	36 in.
Sanding Belt Speed.....	1900 FPM
Sanding Belt Tilt.....	90 deg
Max Height of Belt in Vertical Position.....	24-1/2 in.
Belt Tension Release Type.....	Quick-Release Lever
Platen Type.....	Steel
Platen Length.....	12 in
Platen Width.....	4-7/8 in.

Disc Sander Info

Disc Diameter.....	6 in.
Disc Speed.....	3600 RPM
Disc Sandpaper Backing Type.....	PSA
Table Length.....	6-1/4 in.
Table Width.....	9 in.
Table Tilt.....	Left 0, Right 45 deg.
Table-to-Floor Height.....	4-3/4 in.

Construction Materials

Base.....	Cast Iron
Table.....	Die-Cast Aluminum
Frame.....	Cast Iron
Disc.....	Aluminum
Miter Gauge.....	Plastic and Steel
Paint Type/Finish.....	Urethane

Other Related Info

Miter Gauge Slot Width.....	5/8 in.
Miter Gauge Slot Height.....	1/4 in.
Number of Dust Ports.....	1
Dust Port Size.....	2-1/2 in.

Other

Country of Origin	China
Warranty	2 Years
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features

- Built-In Dust Port
- Fast-Tracking Adjustment Knob
- Quick-Release Belt Lever
- Adjustable Miter Gauge

Controls & Components

Refer to the **Figures 1-2** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

- A. **Belt Tensioning Lever:** When pressed in, provides tension to sanding belt during use. When pulled out, releases tension for changing/replacing belt.
- B. **Backstop:** Prevents workpiece from being thrown by rotation of sanding belt.
- C. **Sanding Belt:** Used for sanding with grain along length of workpiece, and for sanding inside curves.
- D. **Tracking Control Knob:** Used to adjust alignment of sanding belt to sanding bed.
- E. **ON/OFF Switch:** Turns motor **ON** and **OFF**. Remove yellow tab to lock in **OFF** position.
- F. **Sanding Disc:** Used for performing angle and miter sanding operations on work table.
- G. **Angle Scale:** Indicates angle of work table relative to sanding disc from 90° -45°.
- H. **Sanding Bed:** The surface around which the sanding belt rotates; tilts from 0° -90°.
- I. **Miter Gauge:** Used for miter sanding. Adjustable from 60° left or right.
- J. **Work Table:** Supports workpiece during angle, miter, and compound miter sanding. T-slot functions as a guide for miter gauge.
- K. **Angle Adjustment Knob:** Tightens to secure work table at desired angle.
- L. **2 1/2" Dust Port:** Connects a shop vacuum or dust collector for dust extraction.

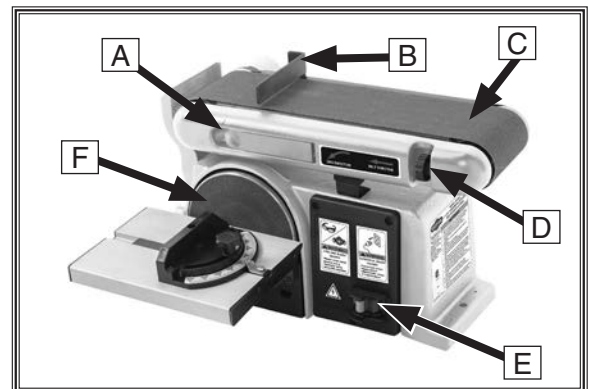
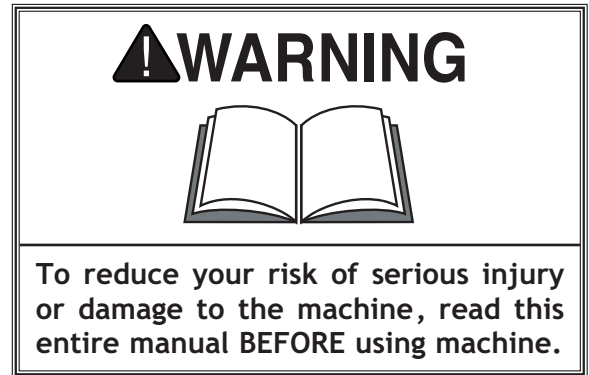


Figure 1. Sanding belt and controls, sanding disc, and ON/OFF switch.

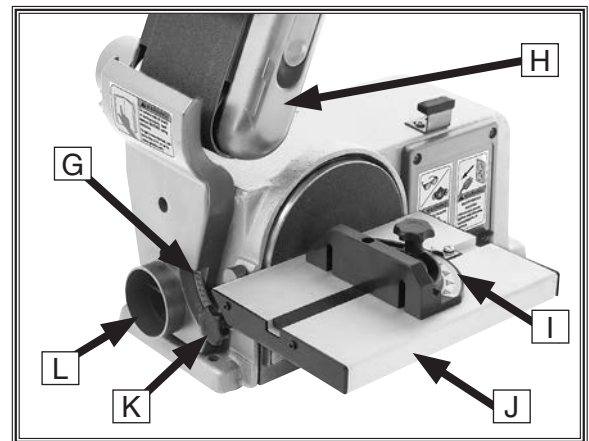


Figure 2. Work table and miter gauge controls, sanding bed, and dust port.

SAFETY

For Your Own Safety, Read Manual Before Operating Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures—this responsibility is ultimately up to the operator!



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



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



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment or a situation that may cause damage to the machinery.

Standard Machinery Safety Instructions

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow an electrician or qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This eliminates the risk of injury from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

WEARING PROPER APPAREL. Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

INTENDED USAGE. Only use machine for its intended purpose—never make modifications without prior approval from Woodstock International. Modifying machine or using it differently than intended will void the warranty and may result in malfunction or mechanical failure that leads to serious personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris—make sure they are properly installed, undamaged, and working correctly.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside, resulting in a short. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact Technical Support at (360) 734-3482.

Additional Safety for Combo Sanders

WARNING

Serious injury or death can occur if fingers, clothing, jewelry, or hair get entangled in moving components. Impact injuries can occur from kickback if workpiece is improperly fed into moving sandpaper. Serious pinch injuries can occur from touching in-running nip point between table and sanding surface. Long-term respiratory damage can occur from using sander without proper use of a respirator. To reduce the risk of these hazards, operator and bystanders **MUST** completely heed the hazards and warnings below.

SANDPAPER DIRECTION. Feeding workpiece incorrectly can cause it to be thrown from machine, striking operator or bystanders, or causing your hands to slip into the moving sandpaper. To reduce these risks, only sand against direction of sandpaper travel, ensure workpiece is properly supported, and avoid introducing sharp edges into moving sandpaper on leading side of workpiece.

FEEDING WORKPIECE. Jamming workpiece into sanding surface could cause it to be grabbed aggressively, pulling hands into sanding surface. Firmly grasp workpiece in both hands and ease it into sandpaper using light pressure.

AVOIDING ENTANGLEMENT. Entanglement in moving parts can cause pinching and crushing injuries. Keep all guards in place and closed. **DO NOT** wear loose clothing, gloves, or jewelry, and tie back long hair.

SANDING DUST. Sanding creates large amounts of dust that can lead to eye injury or respiratory illness. Reduce risk by wearing approved eye and respiratory protection when using sander. Never operate without adequate dust collection system in place and running. Dust collection is not a substitute for using a respirator.

WORKPIECE INTEGRITY. Sanding fragile workpieces can result in loss of control, resulting in abrasion injuries, impact injuries, or damage to sandpaper. Only sand solid workpieces that can withstand power sanding forces. Make sure workpiece shape is properly supported; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.

SANDPAPER CONDITION. Worn or damaged sandpaper can aggressively grab workpiece, resulting in subsequent injuries from operator loss of workpiece control. Always inspect sandpaper before operation and replace if worn or damaged.

WORKPIECE SUPPORT & HAND PLACEMENT. Rotating sandpaper can remove a large amount of flesh quickly, and kickback can occur with violent force if workpiece is not properly supported during operation. Always sand with workpiece firmly against table or another support device. Never touch moving sandpaper on purpose.

IN-RUNNING NIP POINTS. The gap between moving sandpaper and fixed table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater the risk of fingers or workpieces getting caught in it. Minimize this risk by adjusting table/support to no more than 1/16" away from sandpaper. For spindle sanders, always use the table insert that fits closest diameter of installed drum.

MINIMUM STOCK DIMENSION. Small workpieces can be aggressively pulled from your hands, causing contact with sanding surface. Always use a jig or other holding device when sanding small workpieces, and keep hands and fingers at least 2" away from sanding surface.

WORKPIECE INSPECTION. Nails, staples, knots, or other imperfections in workpiece can be dislodged and thrown from sander at a high rate of speed at people, or cause damage to sandpaper or sander. Never sand stock that has embedded foreign objects or questionable imperfections.

ELECTRICAL

Circuit Requirements

This machine must be connected to the correct size and type of power supply circuit, or fire or electrical damage may occur. Read through this section to determine if an adequate power supply circuit is available. If a correct circuit is not available, a qualified electrician **MUST** install one before you can connect the machine to power.

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 120V 4.3 Amps

Circuit Requirements for 120V


This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

- Circuit Type 110V/120V, 60 Hz, Single-Phase
- Circuit Size 15 Amps
- Plug/Receptacle NEMA 5-15

⚠ WARNING

The machine must be properly set up before it is safe to operate. **DO NOT** connect this machine to the power source until instructed to do so later in this manual.

⚠ WARNING



Incorrectly wiring or grounding this machine can cause electrocution, fire, or machine damage. To reduce this risk, only an electrician or qualified service personnel should do any required electrical work on this machine.

NOTICE

The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult with an electrician to ensure that the circuit is properly sized for safe operation.

ELECTRICAL

Grounding Requirements

This machine **MUST** be grounded. In the event of certain types of malfunctions or breakdowns, grounding provides a path of least resistance for electric current to travel—in order to reduce the risk of electric shock.

Improper connection of the equipment-grounding wire will increase the risk of electric shock. The wire with green insulation (with/without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

For 120V Connection

This machine is equipped with a power cord with an equipment-grounding wire and NEMA 5-15 grounding plug (see figure). The plug must only be inserted into a matching receptacle that is properly installed and grounded in accordance with local codes and ordinances.

Extension Cords

We do not recommend using an extension cord with this machine. Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases with longer extension cords and smaller gauge sizes (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

- Minimum Gauge Size 14 AWG
- Maximum Length (Shorter is Better) 50 ft.

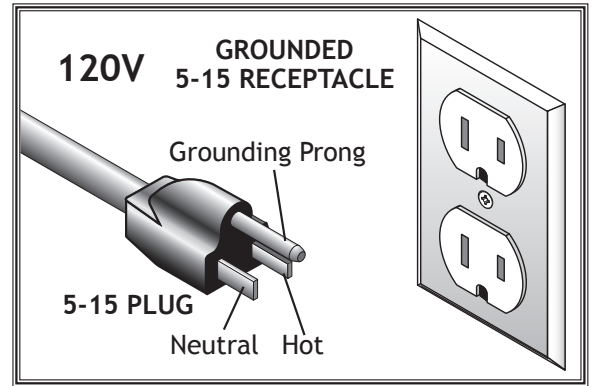
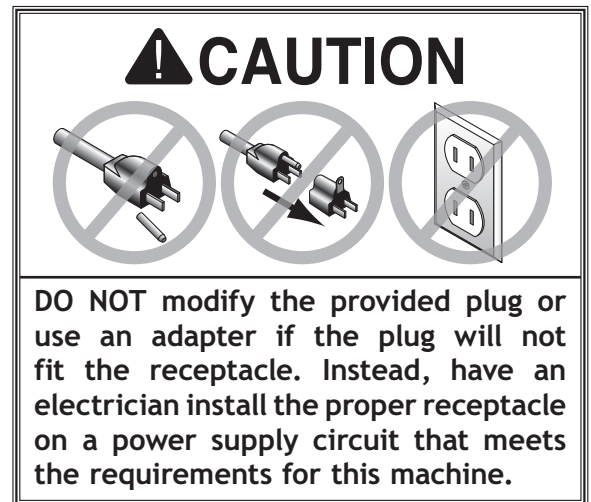


Figure 3. NEMA 5-15 plug & receptacle.



ELECTRICAL

SETUP

Unpacking

This machine has been carefully packaged for safe transportation. If you notice the machine has been damaged during shipping, please contact your authorized Shop Fox dealer immediately.

Items Needed for Setup

The following items are needed, but not included, to set up your machine.


Description	Qty
• Safety Glasses.....	1 Pair
• Screwdriver Phillips #2	1
• Hex Wrench 6mm.....	1
• Screwdriver Flat Head #2	1
• Dust Collection System	1
• Dust Hose 2 1/2".....	1
• Hose Clamps 2 1/2"	2

Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

Note: *If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.*

Box Contents (Figure 4)	Qty
A. Backstop	1
B. Disc Cover.....	1
C. Miter Gauge.....	1
D. Sanding Disc	1
E. Work Table.....	1
F. Hardware (Not Shown):	
–Fender Washer 6mm	1
–Cap Screws M8-1.25 x 16.....	2
–Flat Washers 8mm	2
–Tap Screws M4 x 10.....	2
–External Tooth Washers 4mm	2



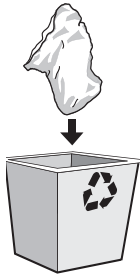
!WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING

Wear safety glasses during entire setup process!



!WARNING

SUFFOCATION HAZARD!

Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.

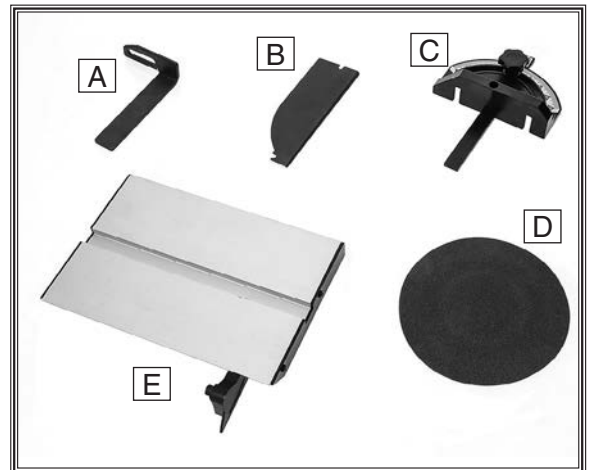


Figure 4. Model W1855 inventory.

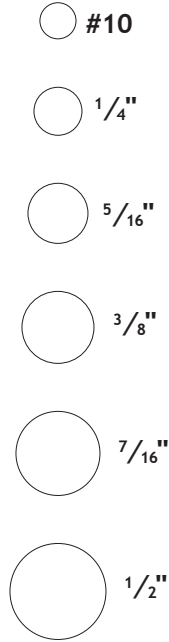
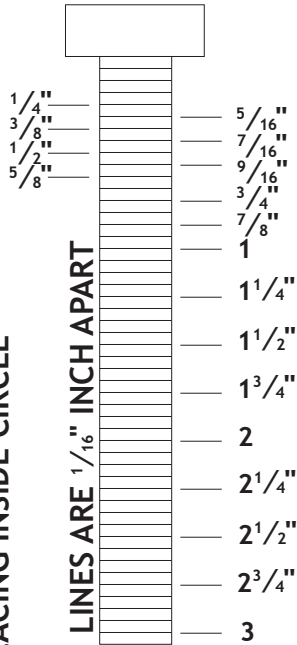
SETUP

Hardware Recognition Chart

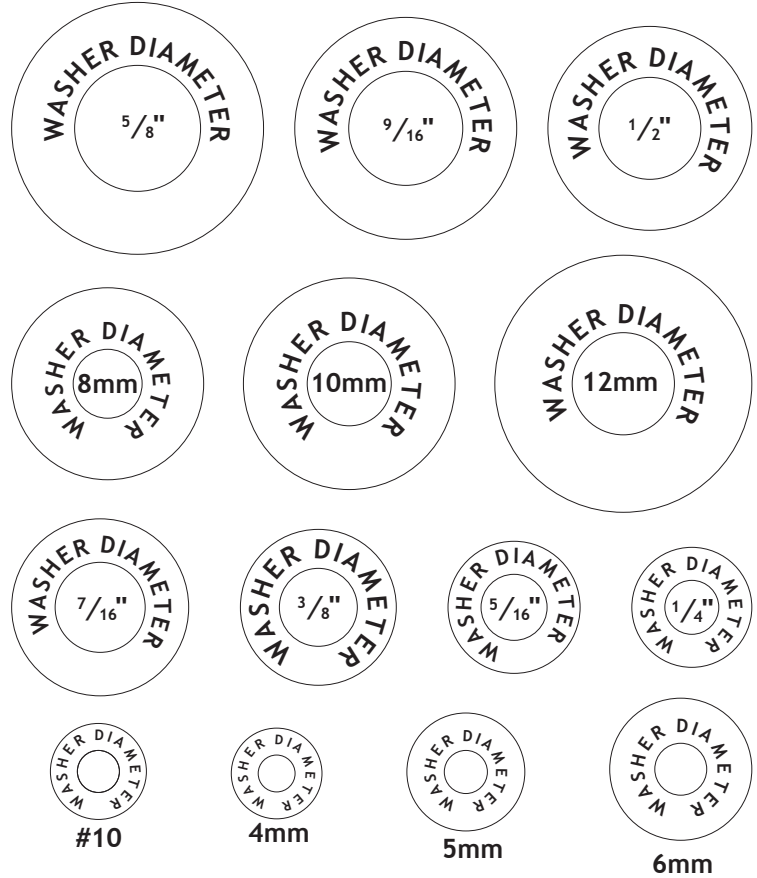
USE THIS CHART TO IDENTIFY HARDWARE DURING THE INVENTORY/ASSEMBLY PROCESS.

SETUP

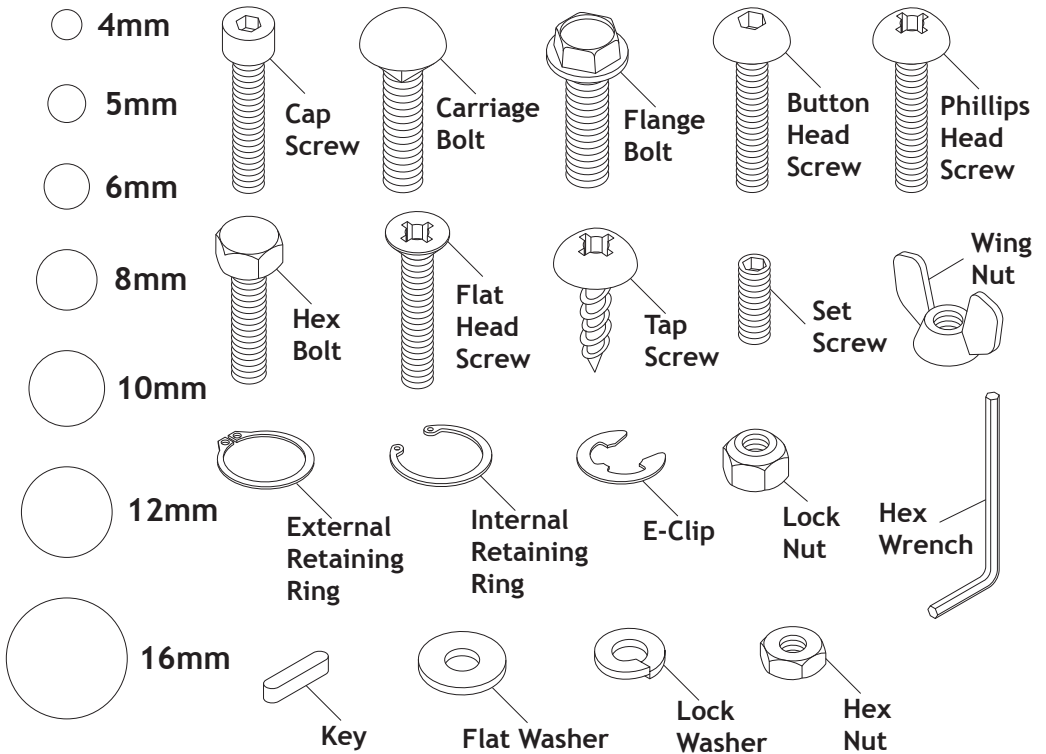
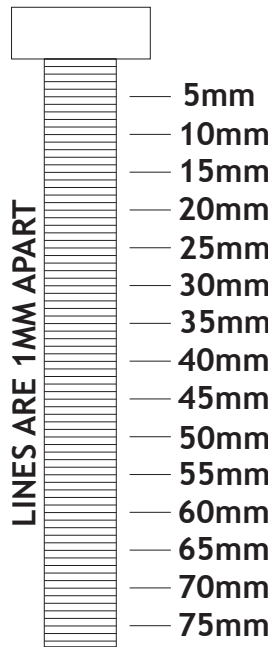
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE
LINES ARE 1MM APART



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE
LINES ARE 1MM APART



Machine Placement

Workbench Load

Refer to the **Machine Specifications** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.



CAUTION
INJURY HAZARD! Untrained users can injure themselves with this machine. Restrict access to machine when you are away, especially if it is installed where children are present.

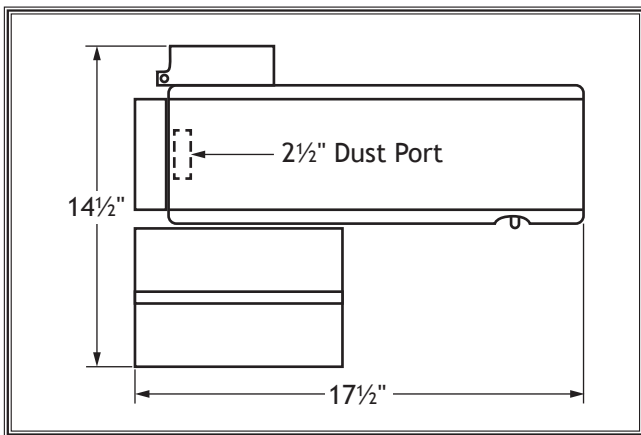


Figure 5. Minimum working clearances.

Cleaning Machine

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5-10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2-3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

SETUP

Bench Mounting

Number of Mounting Holes..... 4
 Diameter of Mounting Hardware Needed..... 1/2"

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

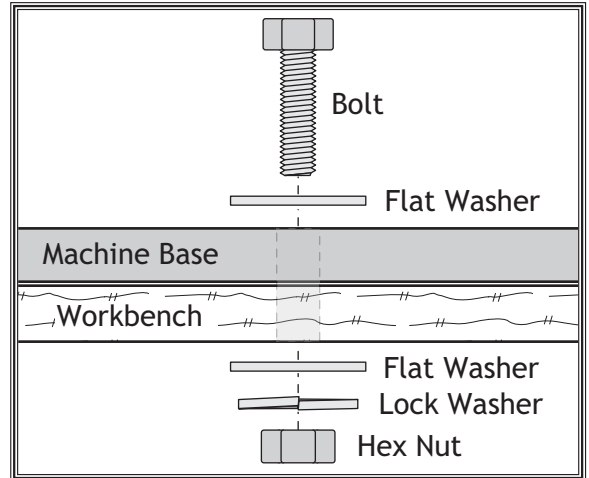


Figure 6. Typical "Through Mount" setup.

Another option is a "Direct Mount" (see example) where the machine is secured directly to the workbench with lag screws and washers.

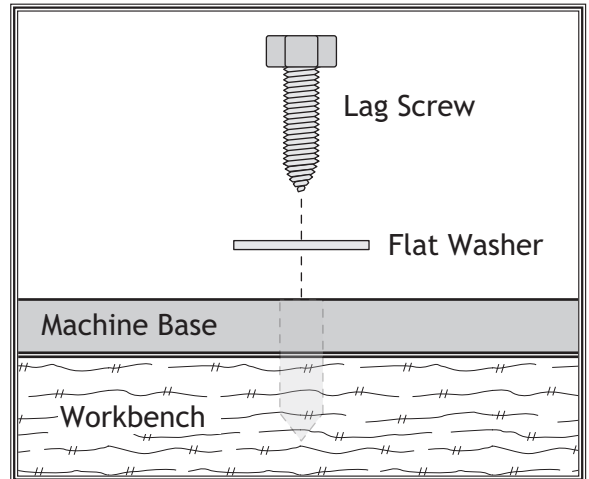


Figure 7. Typical "Direct Mount" setup.

SETUP

Assembly

Before beginning the assembly process, refer to **Items Needed for Setup** and gather everything you need. Ensure all parts have been properly cleaned of the heavy-duty rust-preventative applied at the factory, if applicable. Be sure to complete all steps in the assembly procedure prior to performing the **Test Run**.

The Model W1855 ships with the sanding belt pre-installed.

To assemble machine, do these steps:

1. Attach sandpaper disc to aluminium disc (see **Changing/Replacing Sandpaper Disc on Page 23**).
2. Mount disc cover to holes in sander body near bottom of aluminium disc, using (2) M4 x 10 tap screws, as shown in **Figure 8**.
3. Install 6mm fender washer on table lock knob, as shown in **Figure 9**.
4. Insert work table index pin into upper hole on sander base (see **Figure 9**).
5. Insert threaded end of table lock knob through slot in work table and into threaded hole in sander body.
6. Set work table at desired angle and tighten table lock knob.
7. Insert (2) M8-1.25 x 16 cap screws with (2) 8mm flat washers through slot in backstop and thread into mounting holes in sander body (see **Figure 10**).

Note: Do not fully tighten cap screws yet.

8. Use a square to position backstop perpendicular to sanding belt, with a gap of approximately 1/8" between backstop and belt, then tighten cap screws from **Step 7** (see **Figure 11**).

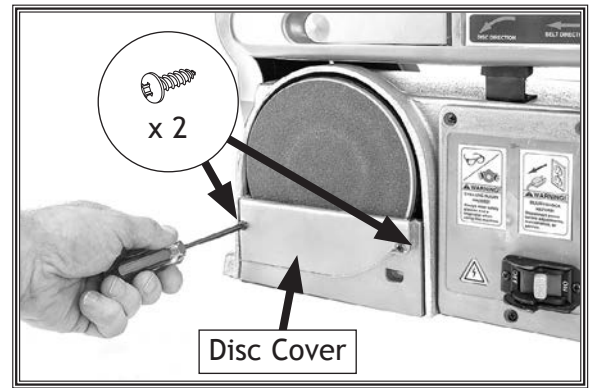


Figure 8. Installing disc cover.

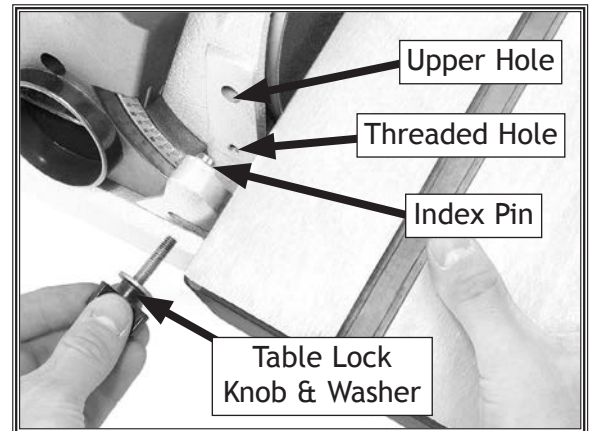


Figure 9. Installing work table.

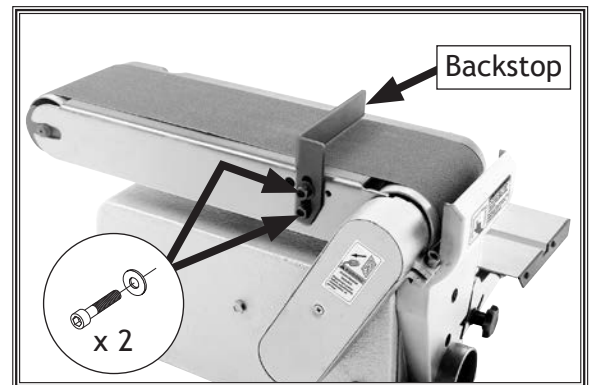


Figure 10. Backstop mounting location.

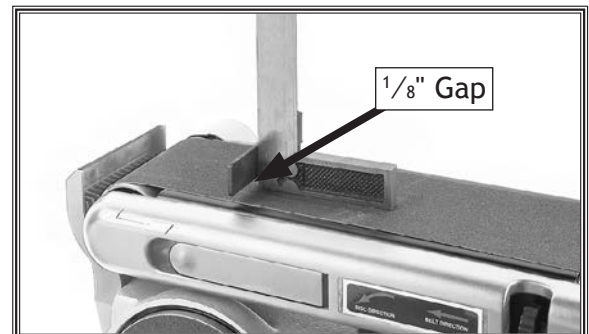


Figure 11. Squaring backstop.

SETUP

Dust Collection

Recommended CFM at Dust Port: 250 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection “how-to” book.

CAUTION

This machine creates substantial amounts of dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust collection system.

SETUP

Tools Needed	Qty
Dust Collection System	1
Dust Hose Adapter 2 ¹ / ₂ "-to-4"	1
Dust Hose 4"	1
Hose Clamps 4"	2

To connect a dust collection hose, do these steps:

1. Fit 2¹/₂" dust hose over dust port, as shown in **Figure 12**, and secure in place with hose clamp.
2. Tug hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.

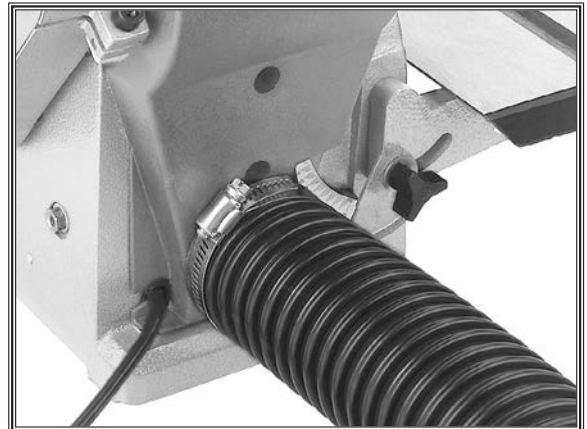


Figure 12. Dust port connected to dust-collection system.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning properly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem **BEFORE** operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

To test run machine, do these steps:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine **ON**, verify motor operation, and then turn machine **OFF**.

The motor should run smoothly and without unusual noises.

4. Remove locking key from toggle switch (see example).
5. Try to start machine with switch.

Machine should **NOT** start. If it *does* start, switch disabling feature is not functioning properly and switch must be replaced.

⚠ WARNING

Serious injury or death can result from using this machine **BEFORE** understanding its controls and related safety information. **DO NOT** operate, or allow others to operate, machine until the information is understood.

⚠ WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

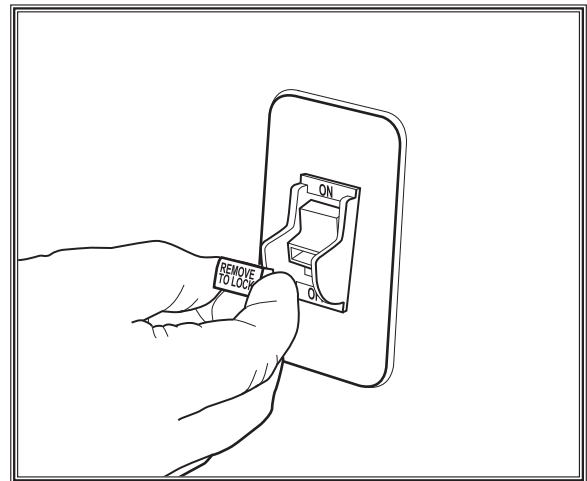


Figure 13. Removing switch key from toggle switch.

SETUP

OPERATIONS

General

This machine will perform many types of operations that are beyond the scope of this manual. Many of these operations can be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

The overview below provides the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand. Due to its generic nature, this overview is **NOT** intended to be an instructional guide.

This combination sander removes surface material from the edges, ends, and faces of wood stock using an abrasive belt and disc. A steel platen on the sanding belt frame provides a flat support surface for the sanding belt and workpiece.

The abrasive belt revolves around a pair of rollers, one of which is driven by the motor. The adhesive-backed abrasive disc is attached to an aluminum disc, which revolves in a counterclockwise direction.

During a typical operation, the sander is turned **ON**, and while holding the workpiece with both hands, the operator gradually eases the workpiece into the belt or the left side of the sanding disc.

⚠ WARNING

To reduce your risk of serious injury or damage to the machine, read this entire manual **BEFORE** using machine.

⚠ WARNING

To reduce the risk of eye injury and long-term respiratory damage, always wear safety glasses and a respirator while operating this machine.

NOTICE

If you are an inexperienced operator, we strongly recommend that you read books or trade articles, or seek training from an experienced operator of this type of machinery before performing unfamiliar operations. Above all, safety must come first!

OPERATIONS

Setting Work Table

⚠ CAUTION

Only sand workpiece on side of sanding disc that is rotating down toward work table. This will keep workpiece from flying out of your hands from rotational force of disc.

Set the work table angle relative to the sanding disc. The angle can be set using the angle scale on the sander body, or for greater accuracy, a protractor or machinist's square can be used.

To set work table angle, do these steps:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen angle adjustment knob, and position work table to desired angle using angle scale (see Figure 14).
3. Re-tighten angle adjustment knob.

Setting Miter Gauge

To set miter gauge angle, do these steps:

1. Place miter gauge in work table slot, and loosen lock knob shown in Figure 15.
2. Rotate miter gauge to desired angle on scale, then re-tighten lock knob.

Note: For instructions on calibrating your miter gauge, see *Calibrating Miter Gauge* on Page 29.

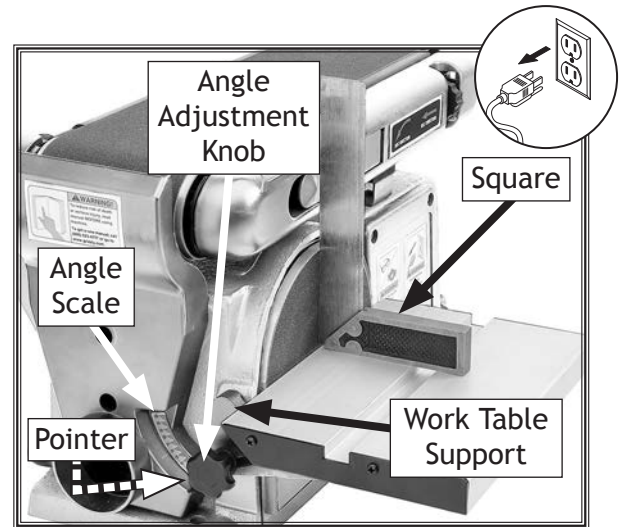


Figure 14. Components for setting work table angle.

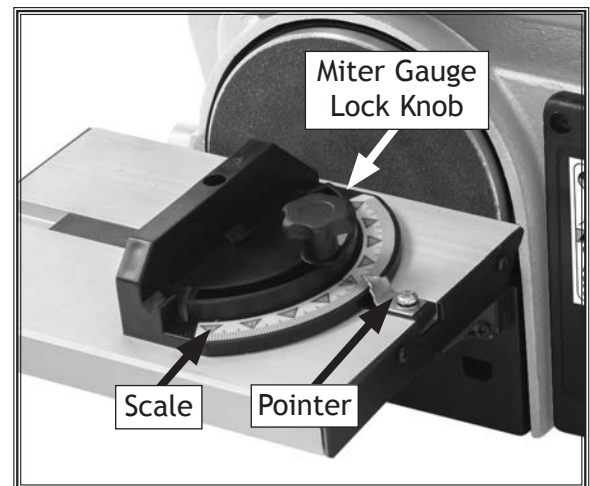


Figure 15. Components for setting miter gauge angle.

Disc Sanding

Sanding Straight Surfaces

For disc sanding straight lines, always brace your workpiece against the miter gauge for maximum stability.

To perform disc sanding operations, do these steps:

1. Set work table and miter gauge angles as necessary.
2. Turn machine *ON*.
3. Place workpiece on work table. Brace it against miter gauge, if necessary (see **Figure 16**).
4. While keeping workpiece snug against miter gauge fence, gently feed it into downward spinning half of sanding disc.
5. Using light pressure, slowly move workpiece only against downward spinning half of sanding disc to prevent workpiece kicking up or losing control.

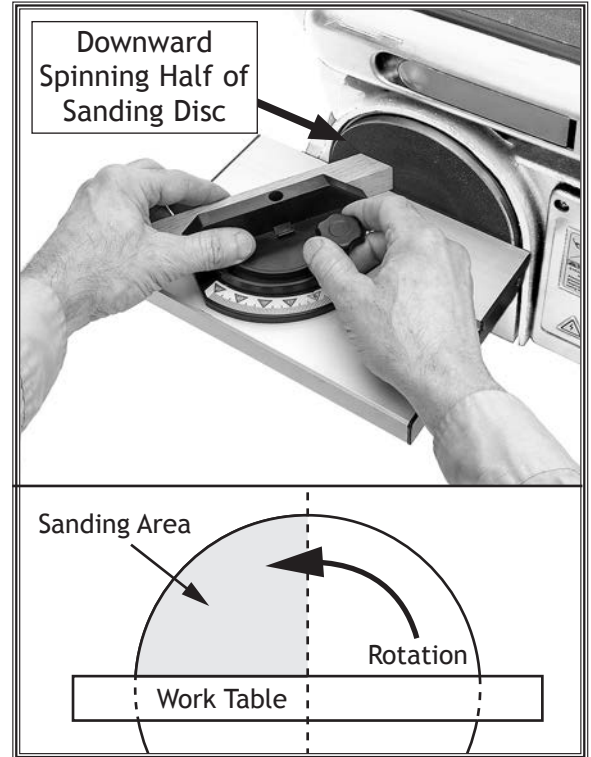


Figure 16. Disc sanding with miter gauge.

Sanding Outside Curves

The Model W1855 disc sander can be used to sand convex (outside) curves. Since the miter gauge is not used for this operation, use both hands to firmly hold the workpiece.

To sand outside curves, do these steps:

1. Remove miter gauge.
2. Turn machine *ON*.
3. Place workpiece on work table, and gently feed it into downward spinning half of sanding disc.
4. Using light pressure, slowly move workpiece only against downward spinning half of sanding disc to prevent workpiece kicking up or losing control.

Belt Sanding

The Model W1855 belt sander bed tilts from 0°-90°, allowing for both horizontal and vertical belt sanding.

The horizontal position is generally used for sanding with the grain along the length of a workpiece or for sanding inside curves.

The vertical position is best used with the work table attached to the bed, such as when miter sanding or sanding outside curves.

Adjusting Sanding Bed Angle

1. DISCONNECT MACHINE FROM POWER!
2. Loosen bed angle cap screw shown in **Figure 17**.
3. Raise or lower bed to desired angle, then re-tighten bed angle cap screw.

Horizontal Sanding

1. Adjust bed to horizontal position.
2. Turn machine **ON** and allow sander to reach full speed.
3. Place workpiece on surface of sanding belt, allowing it to rest against backstop. Hold workpiece firmly, and keep fingers away from sanding surface (see **Figure 18**).
4. Using light pressure, use both hands to move workpiece back and forth across surface of sanding belt to prevent burning workpiece, excessive loading of belt, and uneven belt wear.

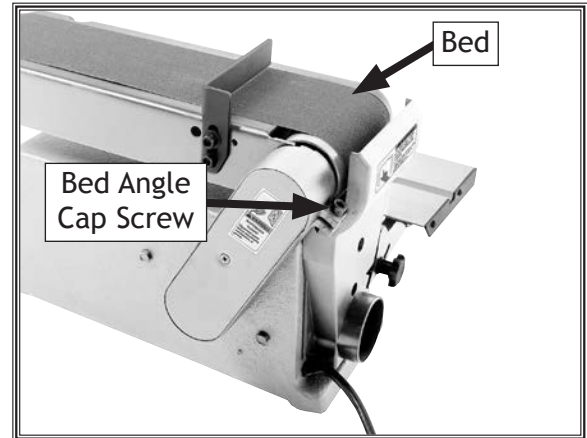


Figure 17. Bed angle adjustment.



Figure 18. Horizontal belt sanding.

Inside Curves

The sanding belt can be used to sand concave (inside) curves, using the idler drum end of the sanding belt.

To sand inside curves, do these steps:

1. Turn machine **ON** and allow sander to reach full speed.
2. Hold workpiece against idler drum end of sanding belt, as shown in **Figure 19**, and with light pressure, move workpiece slowly back and forth across surface of sanding belt.



Figure 19. Sanding an inside curve.

Vertical Sanding

Vertical sanding should be performed with the work table attached to the sanding bed to ensure proper workpiece support. With more surface area than the sanding disc, the sanding belt can sand more aggressively.

To sand in vertical position, do these steps:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (2) M8-1.25 x 16 cap screws, (2) 8mm flat washers, and backstop (see **Figure 20**).
3. Loosen work table lock knob (see **Figure 20**) and remove lock knob, washer, and work table from sanding disc.
4. Adjust sanding bed to vertical position (see **Adjusting Sanding Bed Angle** on Page 21).
5. Insert index pin of work table into mounting hole in sanding bed (see **Figure 21**).
6. Insert table lock knob (with washer) through slot in work table and into threaded hole in sander body (see **Figure 21**).
7. Set desired work table angle (see **Setting Work Table Angle** on Page 21), and tighten table lock knob.

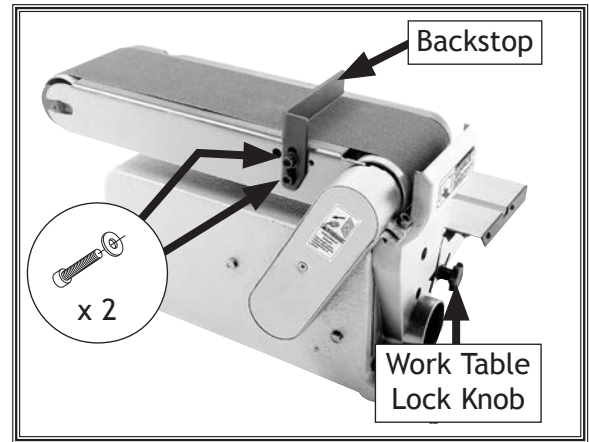


Figure 20. Backstop removal.

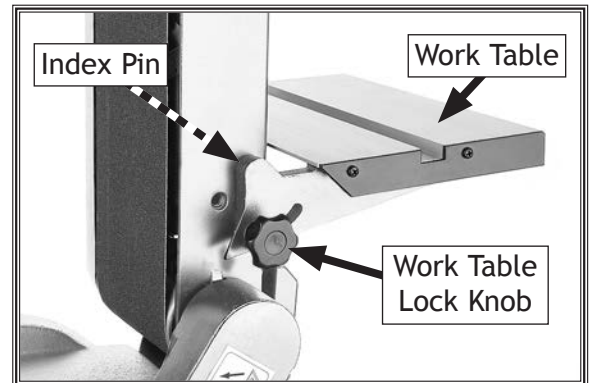


Figure 21. Work table installed on sanding bed in vertical position.

Changing/Replacing Sandpaper Disc

The Model W1855 Disc/Belt Sander accepts 6" diameter cloth- or paper-backed pressure sensitive adhesive (PSA) sandpaper discs. These are available in a variety of grits through the Woodstock catalog. See **Accessories** on **Page 26**.

The PSA sandpaper discs stick directly to the surface of the aluminium disc.

Removing Sandpaper Disc

1. DISCONNECT MACHINE FROM POWER!
2. Remove work table.
3. Remove (2) M4 x 10 tap screws and disc cover shown in **Figure 22**.
4. Remove old sandpaper disc from aluminium disc.



Figure 22. Removing disc cover.

Attaching Sandpaper Disc

1. Peel back protective layer from one-half of new sandpaper disc, and fold it against remaining half.
2. Center sticky half of sandpaper disc on upper half of aluminum disc, and press sandpaper disc onto surface (see **Figure 23**).
3. Remove remaining half of protective layer from sandpaper disc, then press remaining portion of sandpaper disc onto aluminum disc.
4. Rotate disc by hand and check to make sure sandpaper is firmly attached to disc without any bumps or wrinkles.
5. Re-install disc cover and work table.
6. Check work table alignment and adjust if necessary (see **Aligning Work Table** on **Page 28**).



Figure 23. Installing sanding disc.

Changing/Replacing Sanding Belt

To change or replace sanding belt, do these steps:

1. DISCONNECT MACHINE FROM POWER!
2. Raise sanding bed off of bed support, as shown in Figure 24 (see Adjusting Sanding Bed Angle on Page 21).
3. Pull belt-tension lever out (see Figure 24) to release sanding belt tension. The lever will snap into position.
4. Slide old sanding belt off.
5. Slide new sanding belt on, then push belt tension lever in to tension belt.

Note: Make sure arrow on inside of sanding belt points same direction as belt rotation arrow on machine.

6. Rotate belt by hand to verify it moves freely without rubbing against any parts of machine.
7. Check and adjust belt tracking (see Adjusting Belt Tracking on Page 25).

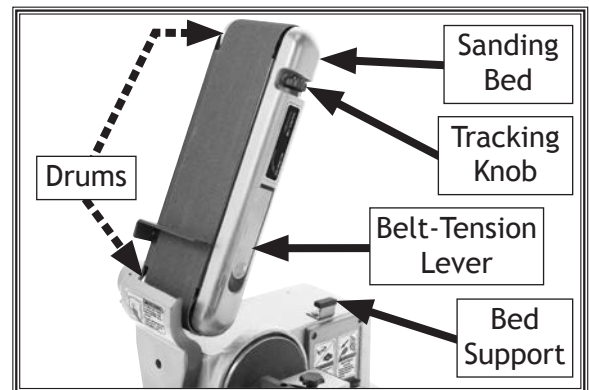
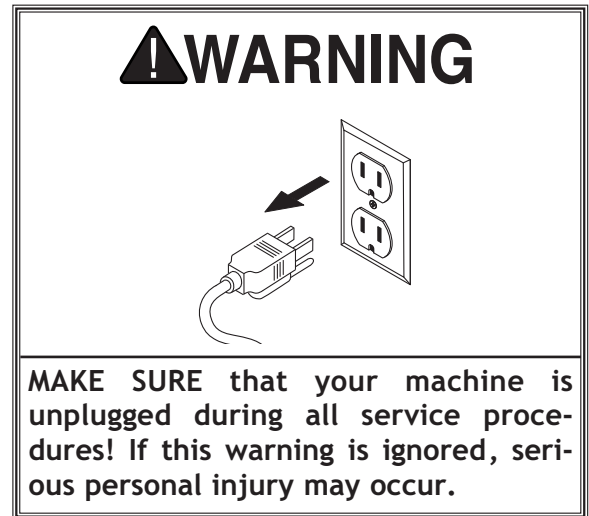


Figure 24. Belt replacement components.

Adjusting Belt Tracking

The belt tracking needs to be adjusted any time you change or replace the sanding belt, or if the belt drifts to one side of the sanding bed during operations.

To check and adjust sanding belt tracking, do these steps:

1. Connect machine to power source.
2. Turn sander **ON**, then immediately turn it **OFF**. Sanding belt should remain centered on drums and *not* drift to one side.
 - If sanding belt *does* drift to one side, proceed to **Step 3**.
3. If sanding belt moves toward disc (front of sander), rotate tracking knob (see **Figure 25**) clockwise $\frac{1}{4}$ turn. If sanding belt moves away from disc (toward back of machine), rotate tracking knob counterclockwise $\frac{1}{4}$ turn.
4. Repeat **Steps 2-3** until proper belt tracking is achieved.

Note: Listen for any unusual noises, vibrations, or rubbing while adjusting tracking. If anything sounds unusual, stop sander immediately. Disconnect machine from power source and find source of problem before operating further. If you cannot locate source of unusual noise or vibration, contact our service department for help.

5. Turn sander **ON** and allow it to run for up to 30 seconds to verify belt tracks properly and no further adjustments are needed.

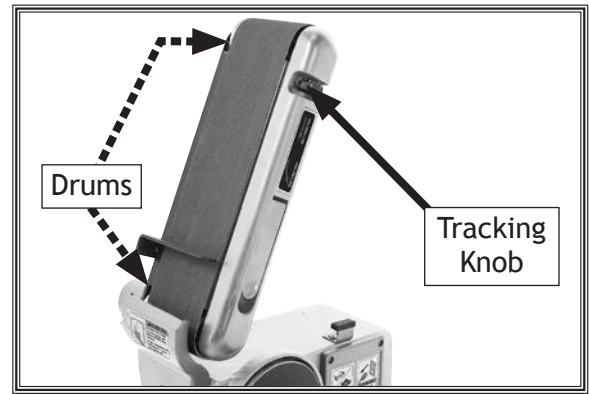


Figure 25. Belt tracking components.

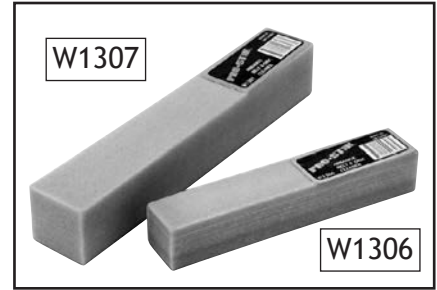
ACCESSORIES

Belt/Disc Sander Accessories

The following belt sander accessories may be available through your local Woodstock International Inc. Dealer. If you do not have a dealer in your area, these products are also available through online dealers. Please call or e-mail Woodstock International Inc. Customer Service to get a current listing of dealers at: 1-800-840-8420 or at sales@woodstockint.com.

These **PRO-STIK®** Abrasive Belt & Disc Cleaners quickly remove gum and grit from belts, sleeves and discs without damage. Extend the life of your belts, sleeves or discs with this innovative natural cleaner.

- W1304—1³/₈" x 4¹/₄"
- W1305—1³/₈" x 8¹/₂"
- W1306—1¹/₂" x 1¹/₂" x 8¹/₂"
- W1307—2" x 2" x 12"



The **Shop Fox D3640 Tool Table Plus** was designed in response to customer requests for a slightly wider and taller table to accommodate small planers, wood lathes, sanders and a variety of other bench-top machines.



Our tough 4" x 36" **Aluminum Oxide Sanding Belts** are sized perfectly for the W1855, and we offer a wide selection of popular grit options. Sold per 2-pack.

- | | |
|-------------------------|-------------------------|
| D1249 4" x 36" 60-Grit | D1253 4" x 36" 150-Grit |
| D1250 4" x 36" 80-Grit | D1254 4" x 36" 180-Grit |
| D1251 4" x 36" 100-Grit | D1255 4" x 36" 220-Grit |
| D1252 4" x 36" 120-Grit | |



These tough 6" **Aluminum Oxide Sanding Discs** provide the grit options you need to get the job done. Each disc has a pre-applied pressure-sensitive adhesive. Sold per 3-pack.

- | | |
|-------------------|-------------------|
| D1307 6" 60-Grit | D1311 6" 150-Grit |
| D1308 6" 80-Grit | D1312 6" 180-Grit |
| D1309 6" 100-Grit | D1313 6" 220-Grit |
| D1310 6" 120-Grit | |



OPERATIONS

MAINTENANCE

General

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check

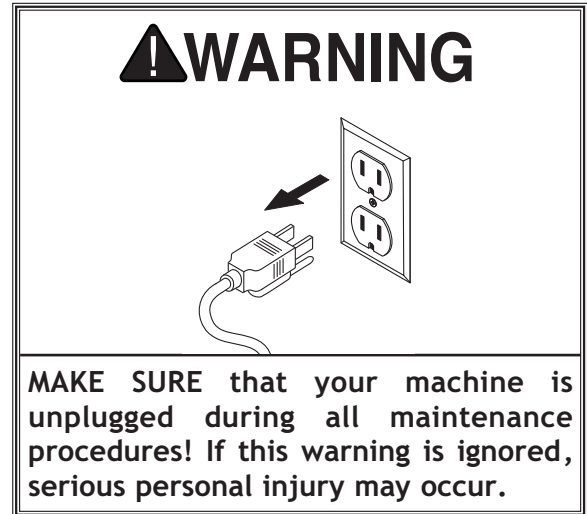
- Loose mounting bolts.
- Worn/damaged sanding disc or sanding belt.
- Worn or damaged wires.
- Any other unsafe condition.

As Needed

- Clean/replace sanding disc or sanding belt.

Monthly Check

- Drive belt tension, damage, or wear.



Cleaning & Protecting

Cleaning the Model W1855 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any pitch/resin has built up, use a pitch/resin dissolving cleaner to remove it.

Cleaning Sanding Belt/Disc

Using an abrasive belt/disc cleaner can prolong the life of a clogged sanding belt/disc, provided it is in otherwise good condition (see Figure 26).

To clean sanding belt/disc, do these steps:

1. Turn machine **ON**.
2. Using backstop or work table as support, rub abrasive cleaner on sanding belt/disc in continuous motion, covering entire surface of belt/disc until belt/disc is no longer clogged.
3. Turn machine **OFF**.

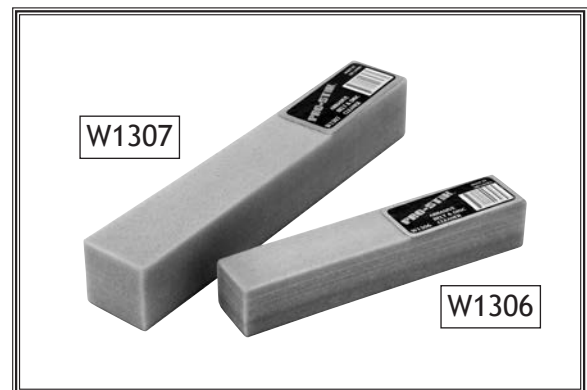


Figure 26. PRO-STIK® Abrasive belt & disc cleaners.

MAINTENANCE

SERVICE

General

This section covers the most common service adjustments or procedures that may need to be made during the life of your machine.

If you require additional machine service not included in this section, please contact Woodstock International Technical Support at (360) 734-3482 or send e-mail to: techsupport@woodstockint.com.

Adjusting Work Table

The work table must be adjusted so that the miter slot is parallel to the sanding disc (for accurate miter sanding), and the gap between the work table and sanding disc is not more than $\frac{1}{16}$ " (to minimize risk of pinch injury).

Work table alignment should be checked and adjusted, if necessary, before each use or any time the work table is removed and re-installed.

To adjust work table, do these steps:

1. DISCONNECT MACHINE FROM POWER!
2. Set work table angle to 0° (see **Setting Work Table Angle** on Page 19).
3. Check miter slot parallelism by measuring distance from each end of sanding disc to edge of miter slot (see **Figure 27**). Distance "A" should be equal to distance "B" with not more than a $\frac{1}{16}$ " gap between table and sanding disc.
 - If distance "A" is *not* equal to distance "B" or gap between table and disc exceeds $\frac{1}{16}$ ", proceed to **Step 4**.
4. Loosen flange nuts shown in **Figure 28**, and adjust table so distance "A" equals distance "B" (see **Figure 27**), with not more than a $\frac{1}{16}$ " gap between table and sanding disc.
5. Re-tighten flange nuts from **Step 4**. Re-check miter slot parallelism and spin disc by hand to verify that sanding disc does not touch work table. If necessary, repeat **Steps 3-5** until work table is properly adjusted.

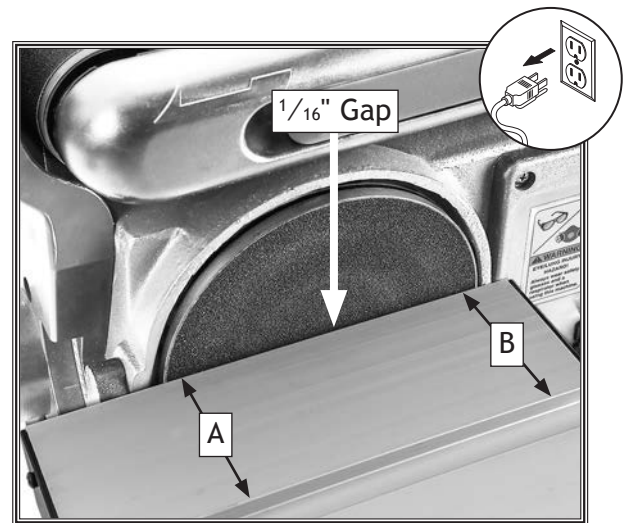
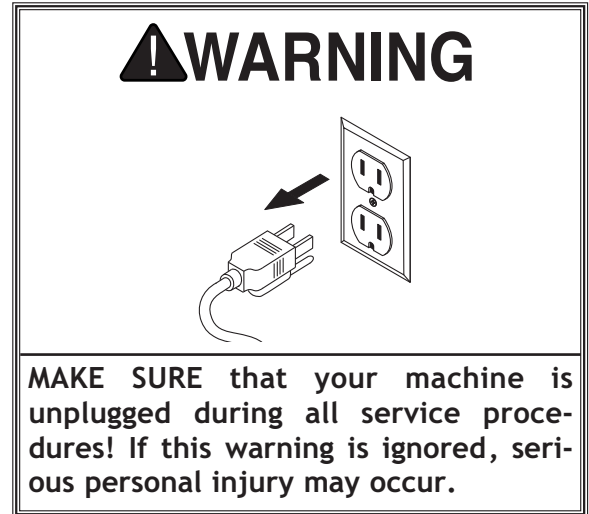


Figure 27. Work table alignment.

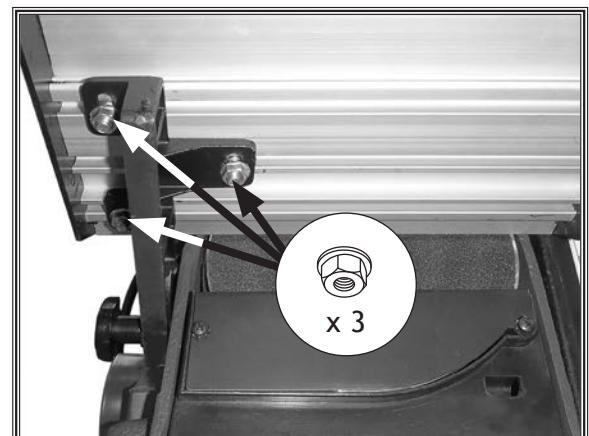


Figure 28. Work table alignment nuts.

Calibrating Miter Gauge

The miter gauge is pre-calibrated at the factory. However, if the scale pointer gets bumped during shipping or after prolonged use, it may need to be recalibrated to ensure accurate results with the miter gauge. Follow the instructions below any time you notice the miter gauge producing inaccurate results.

To check and calibrate miter gauge, do these steps:

1. DISCONNECT MACHINE FROM POWER!
2. Ensure work table is adjusted properly (see **Page 28**).
3. Loosen miter gauge lock knob. Place a machinist's square with one edge against miter gauge and other edge against sanding disc, as shown in **Figure 29**.
4. Re-tighten lock knob, making sure machinist's square remains flat against both miter gauge fence and sanding disc.
5. Pointer shown in **Figure 29** should point to "0" on the miter scale.
 - If the pointer does *not* point to "0" on the miter scale, proceed to **Step 6**.
6. Loosen calibration screw shown in **Figure 29**, set pointer to "0" on miter scale, making sure fence remains flush with machinist's square, and re-tighten screw.

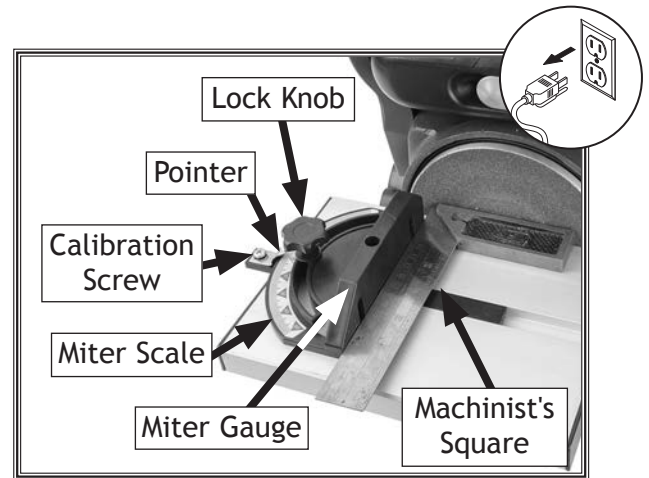


Figure 29. Miter gauge components.

Replacing Drive Belt

To ensure optimum power transmission, the belt must be in good condition (free from cracks, fraying, and wear) and properly tensioned. After the first 16 hours of belt life, re-tension the belt, as it will stretch and seat during this time.

To replace and tension drive belt, do these steps:

1. DISCONNECT MACHINE FROM POWER!
2. Remove drive belt cover plate (see **Figure 30**).
3. Loosen (3) belt housing screws shown in **Figure 30** to relieve tension on drive belt.
4. Remove old drive belt and place new drive belt around pulleys.
5. Insert screwdriver into tension hole, as shown in **Figure 31**, and pull up against belt housing to tighten drive belt.
6. While keeping tension on belt with screwdriver, use other hand to tighten belt-housing screws from **Step 3**.
7. Test belt tension by squeezing belt between your fingers. There should be no more than $\frac{1}{4}$ " of deflection in belt.

Note: *Too much tension in belt will cause increased noise and may overload motor. However, if drive belt is too loose, it may slip and cause excessive wear on belt.*

8. Replace drive belt cover plate.

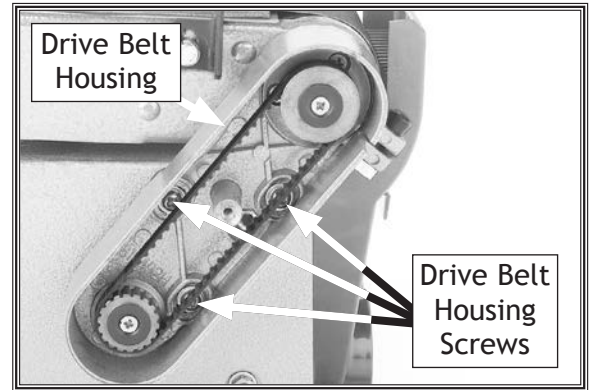


Figure 30. Example of drive belt housing screws.

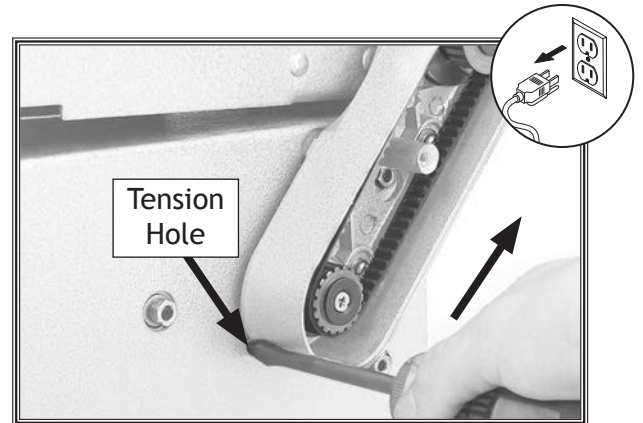


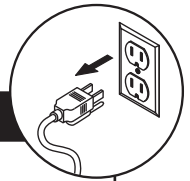
Figure 31. Prying housing up to tension belt.

Troubleshooting

The following troubleshooting tables cover common problems that may occur with this machine. If you need replacement parts or additional troubleshooting help, contact our Technical Support.

Note: Before contacting Tech Support, find the machine serial number and manufacture date, and if available, your original purchase receipt. This information is required to properly assist you.

Motor and Electrical



PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine does not start or a breaker trips immediately upon start-up.	<ol style="list-style-type: none"> 1. Switch disabling key removed. 2. Incorrect power supply voltage. 3. Power supply circuit breaker tripped or fuse blown. 4. Motor wires connected incorrectly. 5. Wiring open; has high resistance, or a short. 6. ON/OFF switch at fault. 7. Start capacitor at fault. 8. Motor at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key (Page 17). 2. Ensure correct power supply voltage (Page 9). 3. Ensure circuit is sized correctly. Reset circuit breaker or replace fuse. 4. Correct motor wiring connections (Page 34). 5. Check/fix broken, disconnected, or corroded wires. 6. Replace switch. 7. Test/replace. 8. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Sanding with too much pressure. 2. Machine undersized for task. 3. Workpiece material not suitable for machine. 4. Dust buildup or blockage of dust port. 5. Drive belt damaged and slipping. 6. Pulley/sprocket slipping on shaft. 7. Motor overheated. 	<ol style="list-style-type: none"> 1. Reduce pressure on workpiece while sanding. 2. Clean/replace sandpaper (Pages 24 & 27); reduce feed rate/sanding depth. 3. Only sand wood—ensure moisture is below 20%. 4. Clear blockages, seal leaks, use smooth-wall duct, eliminate bends, close other branches. 5. Replace drive belt (Page 30). Ensure belt is properly tensioned. 6. Replace loose pulley/shaft. 7. Clean motor, let cool, and reduce workload.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Machine incorrectly mounted to workbench. 2. Motor or other component loose. 3. Drive belt slapping cover/housing. 4. Sanding disc or drive roller out of balance, damaged, or loose. 5. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Adjust feet, shim, or tighten mounting hardware. 2. Check for and tighten loose bolts, screws, nuts, etc. 3. Properly tension drive belt. 4. Tighten, adjust, or replace affected component (Page 23). 5. Test by rotating shaft; rotational grinding noise or loose shaft requires bearing replacement.

PROBLEM	POSSIBLE CAUSE	CORRECTIVE ACTION
Sanding grains easily rub off belt or disc.	<ol style="list-style-type: none"> 1. Sanding belt/disc previously stored in an incorrect environment. 2. Sanding belt/disc has been smashed or folded. 	<ol style="list-style-type: none"> 1. Store sanding belt/disc in a cool, dry area. 2. Do not bend or fold sandpaper.
Deep sanding grooves or scars in workpiece.	<ol style="list-style-type: none"> 1. Sanding belt/disc too coarse for desired finish. 2. Too much sanding force on workpiece. 3. Workpiece sanded across the grain. 4. Workpiece held still for too long against belt/disc. 	<ol style="list-style-type: none"> 1. Use finer grit sanding belt/disc (Pages 23 & 24). 2. Reduce pressure on workpiece while sanding. 3. Sand with grain. 4. Keep workpiece moving while sanding.
Sanding belt/disc clogs quickly.	<ol style="list-style-type: none"> 1. Too much pressure on sanding belt/disc. 2. Sanding softwood. 3. Sanding belt/disc clogged. 4. Sanding belt/disc worn or damaged. 	<ol style="list-style-type: none"> 1. Reduce pressure on workpiece while sanding. 2. Use different stock, or accept characteristics of stock and plan to clean/replace sanding belt/disc frequently. 3. Clean sanding belt/disc (Page 27). 4. Replace sanding belt/disc (Pages 23 & 24).
Glazed sanding surface.	<ol style="list-style-type: none"> 1. Sanding wet stock. 2. Sanding stock with high amount of residue or applied finishes. 	<ol style="list-style-type: none"> 1. Only sand dry stock. 2. Use different stock, or accept characteristics of stock and plan to clean/replace sanding belt/disc frequently.
Burn marks on workpiece.	<ol style="list-style-type: none"> 1. Sanding grit too fine. 2. Using too much pressure. 3. Workpiece held still for too long. 	<ol style="list-style-type: none"> 1. Use coarser grit sanding belt/disc (Pages 23 & 24). 2. Reduce pressure on workpiece while sanding. 3. Keep workpiece moving while sanding.
Workpiece gets pulled out of your hand while belt sanding.	<ol style="list-style-type: none"> 1. Not supporting workpiece against backstop. 	<ol style="list-style-type: none"> 1. Use backstop to support workpiece.
Workpiece lifts up from sanding disc table.	<ol style="list-style-type: none"> 1. Sanding on upward spinning half of sanding disc. 	<ol style="list-style-type: none"> 1. Sand on downward spinning half of sanding disc.

Electrical Safety Instructions

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (360) 734-3482 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

WARNING

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

QUALIFIED ELECTRICIAN. Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

MODIFICATIONS. Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (360) 734-3482.

NOTICE

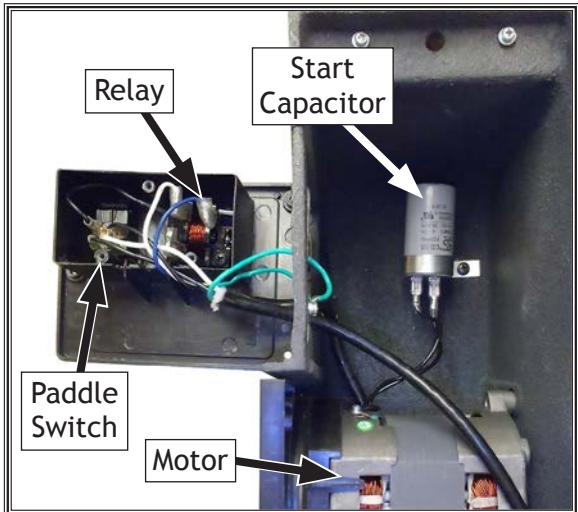
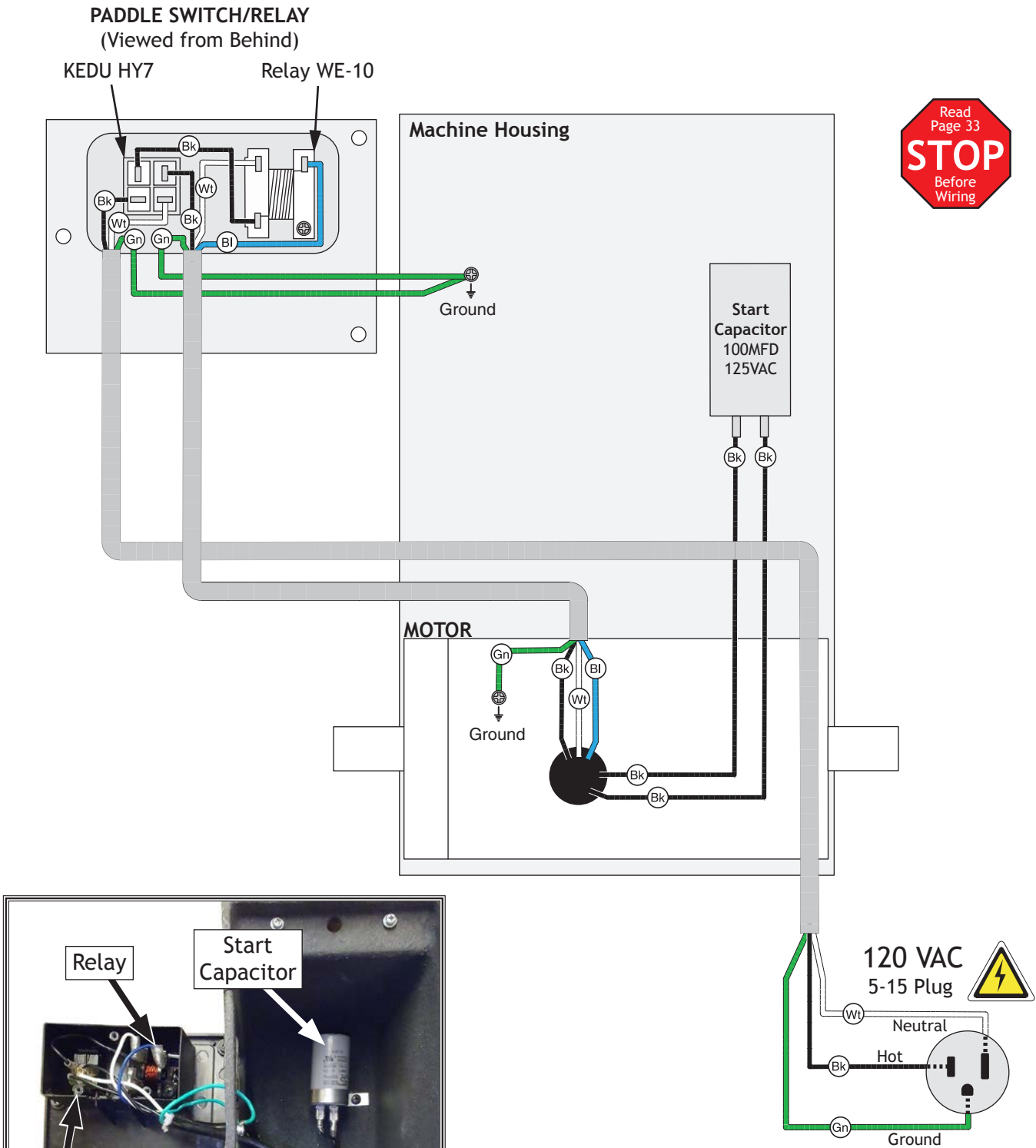
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.shopfox.biz.

WIRING DIAGRAM COLOR KEY

BLACK	BLUE	YELLOW	LIGHT BLUE
WHITE	BROWN	YELLOW GREEN	BLUE WHITE
GREEN	GRAY	PURPLE	TURQUOISE
RED	ORANGE	PINK	

SERVICE

Wiring Diagram



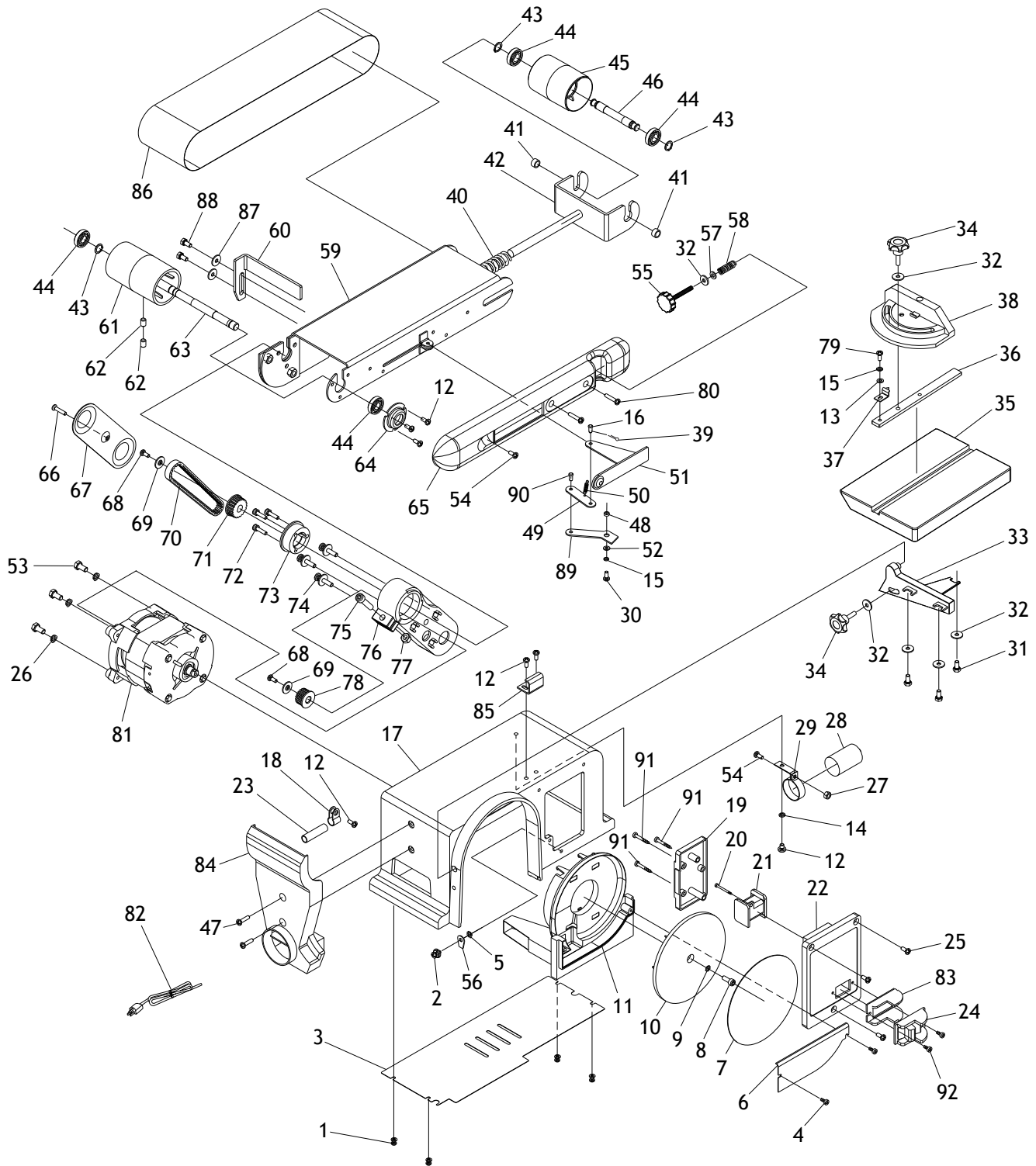
NOTICE
This motor wiring diagram is current at the time of printing; however, always use the diagram on the inside of the junction box cover when rewiring your motor!

SERVICE

Figure 32. Paddle switch, relay, start capacitor, and motor.

PARTS

Main



Main Parts List

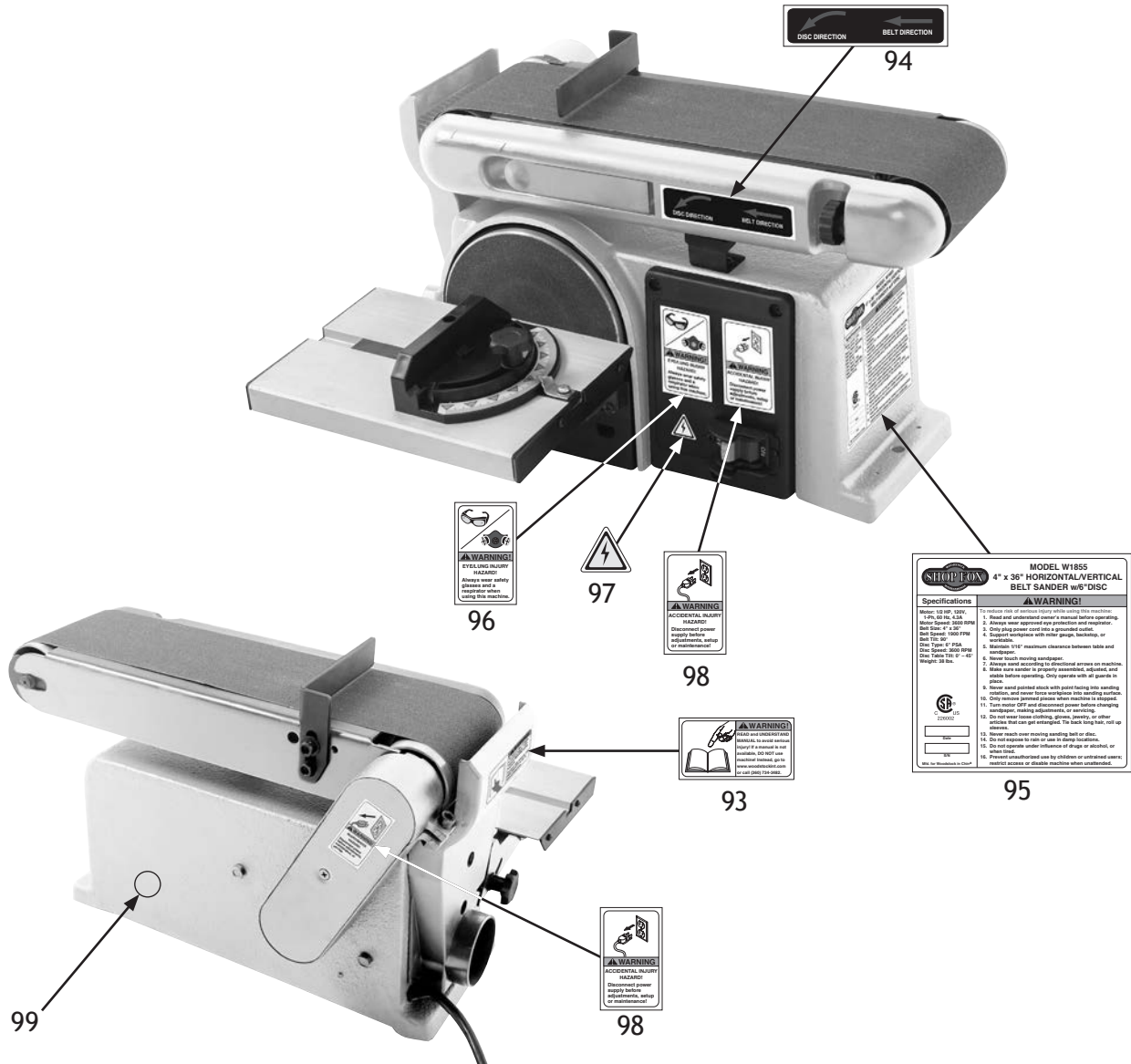
REF	PART #	DESCRIPTION
1	X1855001	PHLP HD SCR M4-.7 X 6 W/WASHER
2	X1855002	PHLP HD SCR M4-.7 X 8 W/WASHERS
3	X1855003	BASE BOTTOM COVER
4	X1855004	TAP SCREW M4 X 10
5	X1855005	EXT TOOTH WASHER 4MM
6	X1855006	DISC COVER
7	X1855007	SANDPAPER DISC 6" PSA A/O 80-GRIT
8	X1855008	CAP SCREW M6-1 X 16
9	X1855009	EXT TOOTH WASHER 6MM
10	X1855010	SANDING DISC 6" (ALUMINUM)
11	X1855011	DUST COLLECTION CHUTE
12	X1855012	PHLP HD SCR M5-.8 X 8
13	X1855013	FLAT WASHER 5MM
14	X1855014	FLAT WASHER 5MM
15	X1855015	EXT TOOTH WASHER 5MM
16	X1855016	CLEVIS PIN 5 X 10
17	X1855017	BASE
18	X1855018	CORD CLIP
19	X1855019	ELECTRICAL BOX COVER
20	X1855020	TAP SCREW M3 X 30
21	X1855021	RELAY WE-101
22	X1855022	ELECTRICAL BOX
23	X1855023	INSULATED SLEEVE
24	X1855024	TOGGLE SWITCH 125/250V W/KEY
25	X1855025	PHLP HD SCR M4-.7 X 10
26	X1855026	LOCK WASHER 6MM
27	X1855027	LOCK NUT M5-.8
28	X1855028	S CAPACITOR 100M 125V 1-3/8 X 2-5/16
29	X1855029	CAPACITOR CLAMP
30	X1855030	PHLP HD SCR M5-.8 X 12
31	X1855031	HEX BOLT M6-1 X 12
32	X1855032	FENDER WASHER 6MM
33	X1855033	WORK TABLE SUPPORT
34	X1855034	KNOB BOLT 6-LOBE M6-1 X 20
35	X1855035	WORK TABLE
36	X1855036	MITER GAUGE SLIDE BAR
37	X1855037	MITER GAUGE SCALE POINTER
38	X1855038	MITER GAUGE
39	X1855039	COTTER PIN 2 X 10MM
40	X1855040	COMPRESSION SPRING
41	X1855041	BUSHING
42	X1855042	BELT TENSIONER
43	X1855043	EXT RETAINING RING 12MM
44	X1855044	BALL BEARING 6001ZZ
45	X1855045	SANDING BELT IDLER PULLEY
46	X1855046	SANDING BELT IDLER SHAFT

REF	PART #	DESCRIPTION
47	X1855047	PHLP HD SCR M5-.8 X 20
48	X1855048	SPACER
49	X1855049	CONNECTION PLATE
50	X1855050	EXTENSION SPRING
51	X1855051	SANDING BELT TENSION LEVER
52	X1855052	FENDER WASHER 5MM
53	X1855053	HEX BOLT M6-1 X 20
54	X1855054	PHLP HD SCR M5-.8 X 16
55	X1855055	KNOB BOLT M6-1 X 45
56	X1855056	GROUND WIRE INDICATOR PLATE
57	X1855057	FLAT WASHER 6MM (RUBBER)
58	X1855058	COMPRESSION SPRING
59	X1855059	SANDING BELT SUPPORT
60	X1855060	BACKSTOP
61	X1855061	DRIVE ROLLER
62	X1855062	SET SCREW M8-1.25 X 12
63	X1855063	DRIVE SHAFT
64	X1855064	BEARING COVER
65	X1855065	FRAME COVER
66	X1855066	PHLP HD SCR M5-.8 X 10
67	X1855067	DRIVE BELT COVER
68	X1855068	PHLP HD SCR M5-.8 X 16 LH
69	X1855069	FLAT WASHER 5MM
70	X1855070	TIMING BELT 150XL037
71	X1855071	IDLER ROLLER
72	X1855072	PHLP HD SCR M5-.8 X 25 W/WASHER
73	X1855073	BEARING BASE
74	X1855074	PHLP HD SCR M6-1 X 25 W/WASHER
75	X1855075	CAP SCREW M8-1.25 X 25
76	X1855076	BELT COVER
77	X1855077	HEX NUT M8-1.25
78	X1855078	MOTOR PULLEY
79	X1855079	PHLP HD SCR M5-.8 X 8
80	X1855080	PHLP HD SCR M5-.8 X 25
81	X1855081	MOTOR 1/2 HP 120V 1-PH
82	X1855082	POWER CORD 18G 3W 72" 5-15P
83	X1855083	SWITCH PLATE
84	X1855084	DUST COLLECTION COVER
85	X1855085	FRAME SUPPORT
86	X1855086	SANDING BELT 4" X 36" A/O 80-GRIT
87	X1855087	FLAT WASHER 8MM
88	X1855088	CAP SCREW M8-1.25 X 16
89	X1855089	TENSION LEVER BRACKET
90	X1855090	CAPTIVE PIN 5 X 8
91	X1855091	TAP SCREW M4 X 20
92	X1855092	TAP SCREW M3 X 8

Labels & Cosmetics

⚠️ WARNING

Safety labels warn about machine hazards and how to prevent serious personal injury. The owner of this machine **MUST** maintain the original location and readability of all labels on this machine. If any label is removed or becomes unreadable, **REPLACE** that label before allowing machine to be operated again. Contact us at (360) 734-3482 or www.woodstockint.com to order new labels.



REF	PART #	DESCRIPTION
93	X1855093	READ MANUAL LABEL
94	X1855094	BELT/DISC ROTATION LABEL
95	X1855095	MACHINE ID LABEL
96	X1855096	EYE/LUNG INJURY HAZARD LABEL

REF	PART #	DESCRIPTION
97	X1855097	ELECTRICITY LABEL
98	X1855098	DISCONNECT 120V LABEL
99	X1855099	SHOP FOX WHITE TOUCH-UP PAINT

Warranty Registration

Name _____
Street _____
City _____ State _____ Zip _____
Phone # _____ Email _____ Invoice # _____
Model # _____ Serial # _____ Dealer Name _____ Purchase Date _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

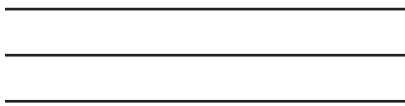
1. How did you learn about us?
 Advertisement Friend Local Store
 Mail Order Catalog Website Other:
2. How long have you been a woodworker/metalworker?
 0-2 Years 2-8 Years 8-20 Years 20+ Years
3. How many of your machines or tools are Shop Fox?
 0-2 3-5 6-9 10+
4. Do you think your machine represents a good value? Yes No
5. Would you recommend Shop Fox products to a friend? Yes No
6. What is your age group?
 20-29 30-39 40-49
 50-59 60-69 70+
7. What is your annual household income?
 \$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+
8. Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

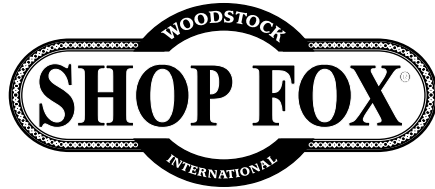
9. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



WOODSTOCK INTERNATIONAL INC.
P.O. BOX 2309
BELLINGHAM, WA 98227-2309



FOLD ALONG DOTTED LINE

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY

Woodstock International, Inc. warrants all Shop Fox machinery to be free of defects from workmanship and materials for a period of two years from the date of original purchase by the original owner. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, lack of maintenance, or reimbursement of third party expenses incurred.

Woodstock International, Inc. will repair, replace, or arrange for a dealer refund, at its expense and option, the Shop Fox machine or machine part proven to be defective for its designed and intended use, provided that the original owner returns the product prepaid to an authorized warranty or repair facility as designated by our Bellingham, Washington office with proof of their purchase of the product within two years, and provides Woodstock International, Inc. reasonable opportunity to verify the alleged defect through inspection. If it is determined there is no defect, or that the defect resulted from causes not within the scope of Woodstock International Inc.'s warranty, then the original owner must bear the cost of storing and returning the product.

This is Woodstock International, Inc.'s sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant that Shop Fox machinery complies with the provisions of any law, acts or electrical codes. We do not reimburse for third party repairs. In no event shall Woodstock International, Inc.'s liability under this limited warranty exceed the purchase price paid for the product, and any legal actions brought against Woodstock International, Inc. shall be tried in the State of Washington, County of Whatcom. We 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.

Every effort has been made to ensure that all Shop Fox machinery meets high quality and durability standards. We are committed to continuously improving the quality of our products, and reserve the right to change specifications at any time.



High Quality Machines and Tools

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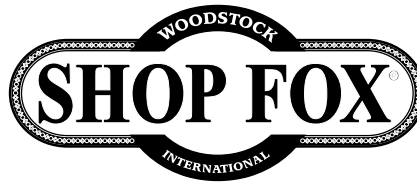
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