

# WIDE-BELT SANDER



Models  
RB-43 & RB-51

# 0460227

**POWERMATIC<sup>®</sup>**

This manual has been prepared for the owner and operators of a Powermatic Wide Belt Sander, Model RB-43 or RB-51. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your sander, and to aid in using the machine safely, read this manual thoroughly and follow all instructions carefully.

## **Warranty & Service**

The JET Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can give you quick service.

In most cases, any one of these JET Group Repair Stations can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET, Performax or Powermatic tools.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848.

## **More Information**

Remember, the JET Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local JET Group distributor.

## **JET Group Warranty**

The JET Group (including Performax and Powermatic brands) makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

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To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

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## SAFETY: GENERAL RULES

**READ THE MANUAL:** Read, understand and follow the safety and operating instructions found in this manual. Know the limitations and hazards associated with the Wide Belt Sander.

**WORK AREA:** Keep the floor around the machine clean and free of scrap material, sawdust, oil or grease to minimize the danger of tripping or slipping. Powermatic recommends the use of anti-skid strips for the operator. Mark off the machine area, make sure it is well lighted, and includes a proper exhaust system to minimize dust.

**ELECTRICAL GROUNDING:** Your machine must be electrically grounded. If a cord and plug are used, make sure the grounding lug connects to a suitable ground. Follow the grounding procedure indicated by the National Electrical Code. Keep power tools in dry areas free from moisture.

**PROTECTION:** Take every precaution to protect yourself, others around you, and the machine itself from improper use.

**CARELESS ACTS:** Give the work you are doing your complete, undivided attention. Horseplay, looking around, and talking to someone are careless acts that can result in serious injury. All children and visitors should be kept a safe distance from your work area.

**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 effect its operation. A guard or other part that is damaged should be properly repaired or replaced before machine operation continues.

**DO NOT OVER-REACH:** Maintain a balanced stance and keep your body under control at all times. Do not over-reach or use excessive force to perform any machine operation.

**EYES:** Always wear approved safety goggles, glasses or a face shield when operating the sander. There are no exceptions to this rule.

**DRESS CODES:** This machine can cause injury by catching loose clothing, jewelry, hair and gloves. Do not wear anything loose such as clothing, neckties, jewelry or gloves that can get caught in moving parts. Confine long hair, avoid wearing rings

and watches, and keep sleeves above the elbow while operating this machine.

**HOUSEKEEPING:** Before turning on machine, remove all extra equipment such as keys, wrenches, scrap and cleaning rags away from the sander. Keep the area around the machine clean and free of sawdust to minimize danger of slipping.

**POWER ON:** Before connecting power to the sander, make sure the start switch is in the "OFF" position.

**POWER OFF:** Make sure the sander is unplugged or electrically disconnected and locked out before performing maintenance, checking belts or service work.



## SAFETY: SPECIFIC RULES

**READ THE MANUAL:** Do not operate the Wide Belt Sander until you read, understand and are able to follow the safety instructions found in this manual. Know what the wide belt sander can safely do, and what it cannot do. Safety rules and caution decals are placed on the machine as reminders of good safety practices.

**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.

**PROTECT YOUR SELF:** 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. Wear protected footwear. Steel toed shoes are recommended because heavy parts can fall off the conveyor table onto feet.

**KEEP GUARDS IN PLACE:** 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.

**NEVER REACH:** 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.

**DO NOT LEAVE UNATTENDED:** 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.

**OPERATING 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 a 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.)

**STOCK LENGTH:** Do not attempt to sand stock shorter than 9 inches (288.6 mm) long without butting a board of equal thickness behind it to help stock through the machine. Boards less than 9 inches long cannot be held secure enough for safe operation of this machine.

**MAINTAIN TOOLS:** 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.

**DISCONNECT POWER:** Make sure sander is unplugged before performing maintenance or adjustments.

**IF YOU ARE NOT** thoroughly familiar with the operation of Wide Belt Sanders, obtain advice from your supervisor, instructor or other qualified person.

**DRUGS, ALCOHOL, MEDICATION:** Do not operate tool while under the influence of drugs, alcohol, or any medication.

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

- \* Lead from lead-based paint.
- \* Crystalline silica from bricks and cement and other masonry products.
- \* 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 specifically designed to filter out microscopic particles.

## SPECIFICATIONS

	<b>Model RB 43</b>	<b>Model RB 51</b>
Stock No.	1791265	1791266
Working Width	43"	51"
Working Height	6"	6"
Main Drive Motor	25 HP, 3 Ph, 230/460V (prewired 230V)	30 HP, 3 Ph, 230/460V (prewired 230V)
Feed Motor	2 HP, 3 Ph	2 HP, 3 Ph
Table Hoist Motor	1/4 HP	1/4 HP
Feed Rate	16-62 FPM variable	16-62 FPM variable
Comp. air requirements	60 psi, 3 CFM	60 psi, 3 CFM
Sanding Belt Size	43" x 60"	51" x 60"
Overall dimensions	52" x 69" x 73"	52" x 77" x 73"
Dust Chute Diameter	4"	4"
Gross Weight	2750 lbs.	3400 lbs.

## RECEIVING THE SANDER

Remove the crate from around the sander. Check for damage and ensure all parts are intact. Any damage should be reported to your distributor and shipping agent immediately upon discovery. Before proceeding with assembly, read the manual thoroughly, familiarizing yourself with correct assembly and maintenance procedures and proper safety precautions.

## INSTALLATION & ASSEMBLY

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. Make sure there is enough room to service the machine on all four sides.

Remove the protective coating from exposed metal surfaces with a soft cloth moistened with kerosene or a good commercial solvent. DO NOT use acetone, gasoline, lacquer thinner or any type of flammable solvent, as they can damage the surface of the machine.

## ELECTRICAL CONNECTIONS

Wire the sander in accordance with the requirements of the National Electric Code (ANSI/NFPA70). Before connecting the machine to the power supply, make sure the supply is compatible with the information on the machine's motor plate.

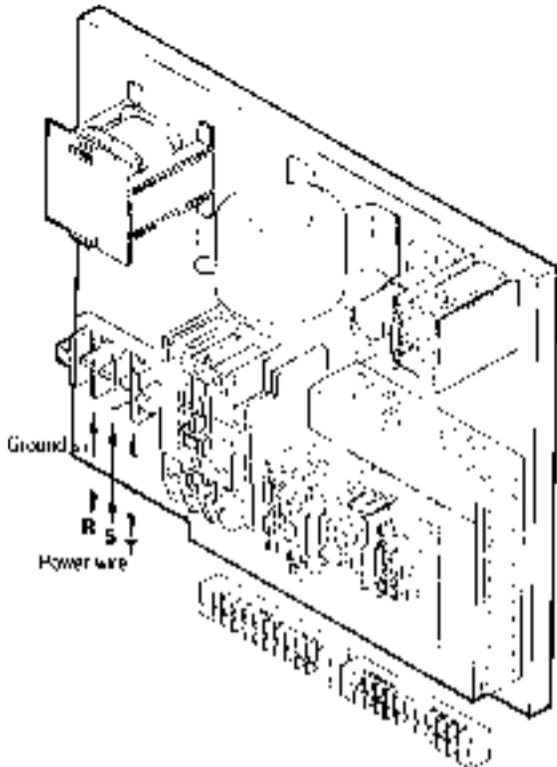


FIGURE 1

The power source connection points are located inside the control box and are marked "R.S.T." The ground wire connection point is marked "E." See Figure 1.

Once the wiring is completed, turn the machine on, press the conveyor table raising switch and see if the table moves the same direction indicated on the switch. If it does not, turn the machine off and switch any two of the three power source wires.

**⚠ WARNING:** ELECTRICAL WIRING SHOULD BE DONE BY A QUALIFIED ELECTRICIAN. THE MACHINE MUST BE PROPERLY GROUNDED TO HELP AVOID ELECTRIC SHOCK AND ASSOCIATED HAZARDS INCLUDING POSSIBLE DEATH.

## AIR CIRCUIT CONNECTION

The air circuit connector is on the Filter/Regulator unit located on the back side of sander. Connect your air supply to the 5/16" air source connector with a flexible hose.

The working pressure can be adjusted with the pressure regulator. Lift the adjustment knob and rotate it clockwise to increase pressure, counter-clockwise to decrease pressure. When the correct pressure is set, push the knob down to lock it in place.

The recommended working pressure is 4-5 kg/cm<sup>2</sup>

## DUST HOOD

Connect your dust collection system to the machine's dust hood (located on top) with a 4" diameter flexible hose. Make sure the dust collector has sufficient capacity for the Sander.

**NOTE:** Always turn on the dust collector BEFORE operating the sander!

## ADJUSTMENTS

### SANDING BELT TRACKING

If the sanding belt runs outside of the normal track, the machine will stop automatically. When replacing the sanding belt, there may be a length tolerance between the right and left sides of the belt which may result in the incorrect tracking of the sanding belt. If this occurs, it will be necessary to adjust the tracking:

1. The degree of sanding belt oscillation to the right side and to the left should be equal. For example, if the oscillation time to the right is 1 second, then the oscillation time to the left should also be 1 second.
2. If the oscillation time to the right is 1 second, but the oscillation time to the left side is longer, then loosen the tracking adjustment lever (A), Figure 2, and move it to the left until proper tracking is achieved. When satisfied, tighten the lever.

3. If the oscillation time to the left is 1 second, but the oscillation time to the right side is longer, then loosen the tracking adjustment lever and move it to the right until proper tracking is achieved. Tighten adjustment lever.

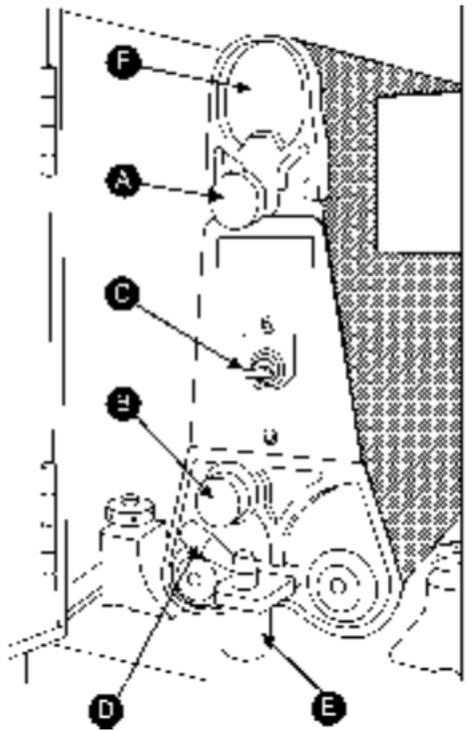


FIGURE 2

### CHANGING SANDING BELT

1. Disconnect machine from power source.
2. Shut "OFF" the air valve switch (C), Figure 2.
3. Remove the lock screw (D) by turning it counter-clockwise.
4. Remove the spacer block (E).
5. Remove old belt by sliding it out the end.
6. Insert new belt by starting first on the top tension roller (F), then the contact roller. Center the belt while avoiding contact with the limit switch fingers that are located on each side of the belt.

**⚠ CAUTION:** Make sure the direction of the arrows on the inside of the belt matches the rotation of the machine. Check that the edges of the sanding belt are not chipped or torn.

7. Replace spacer block (E) and tighten lock screw (D).
8. Turn "ON" the air valve switch (C).
9. Make sure there is clearance between the belt edges and limit switch fingers on either side. If there is not, make the appropriate belt corrections according to the procedure above (with the air valve turned off) as necessary.

NOTE: Machine will not start if a limit switch is depressed.

### SANDING BELT OSCILLATION

The sanding belt oscillation is controlled by the air cylinder. Oscillation speed can be adjusted by means of the speed controller (C) on the cylinder, Figure 3. Loosen the fixing nut on the speed controller, then turn controller clockwise to decrease oscillation speed. Turn counter-clockwise to increase oscillation speed.

The hole in the air flow controller (D) should be checked frequently. If it becomes blocked with dust, it may cause the sanding belt to run out of its normal track and the machine will shut off. In the event of blockage, this hole should be cleaned.

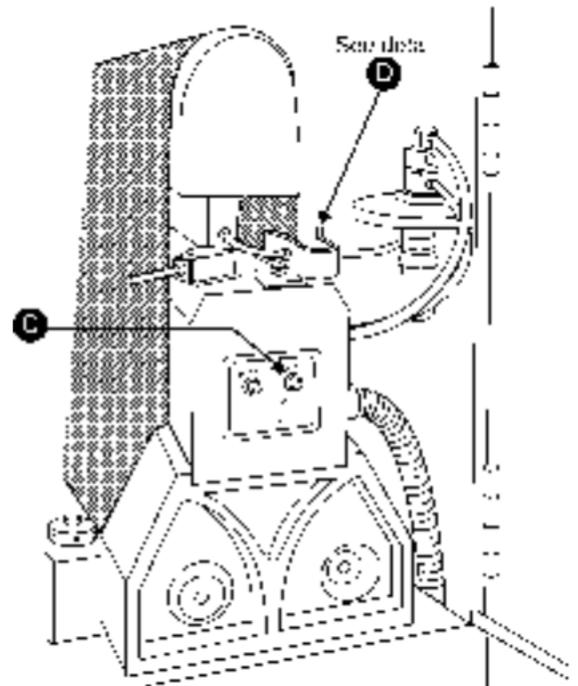


FIGURE 3a

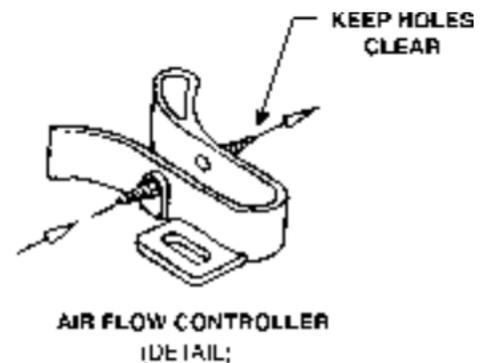


FIGURE 3b

## SANDING PLATEN POSITION

The sanding platen is constructed of graphite cloth and carpet. It is applied for polishing or fine finishing operations with approx. 0.1 mm sanding load. It is NOT suitable for heavy sanding operations. Positioning of the platen depends upon the type of wood being used.

Adjust the platen position with the platen adjustment knob, (see B, Figure 2). Turn it clockwise to lower the platen, counter-clockwise to raise it. Each revolution of the knob is 0.2 mm.

NOTE: The platen should always be kept clean. After sanding if the workpiece has straight notches across it, the graphite cloth and carpet have worn out and should be replaced immediately.

## V-BELT TENSION ADJUSTMENT

After the machine has been in operation for a long time, the V-belt may become slightly loose. Should this occur, there will be an abnormal sound while the motor is running. Adjust the V-belt as follows (Figure 5): Slightly loosen the lock nut (A) that tightens the motor base (B), and turn the adjustment screw (C) until correct tension is achieved. Re-tighten lock nut (A).

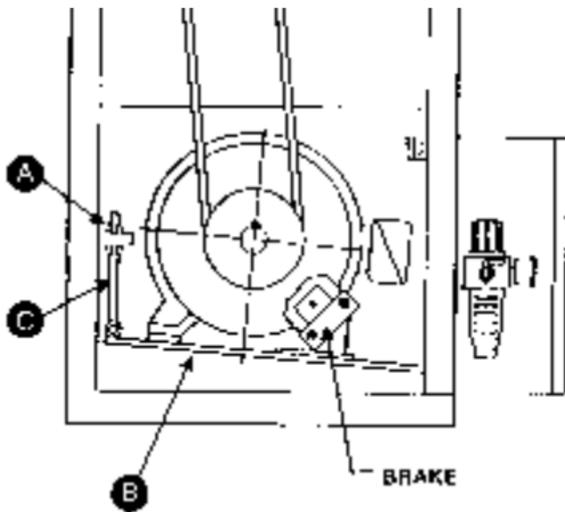


FIGURE 5

## CONVEYOR BELT TRACKING

The conveyor belt should always run at the center part of the contact drum. If it approaches either to the left or right, adjustment is necessary. First check that the conveyor belt tension is correct. If the tension is too tight or too loose, adjust this first *before* you adjust the tracking. Then proceed as follows:

NOTE: Conveyor belt tracking should be adjusted while the machine is running.

1. Remove front brake cover by removing the four screws.
2. Adjust tracking with the screws (A) located at right and left front sides of the conveyor table. See Figure 6.
3. If the conveyor belt is moving to the right side, turn the right screw clockwise. This will return the tracking to the left. (Each turn of the screw adjusts approx. 30 degrees).
4. If the conveyor belt is moving to the left side, turn the left screw clockwise. This will return the tracking to the right. (Each turn of the screw adjusts approx. 30 degrees).
5. Limit wheels (B) have been provided on the right and left sides of the conveyor belt to limit the belt tracking. When adjusting the tracking, the belt should be moved until its edge just touches the limit wheels.
6. After the machine has been running 3 to 5 minutes, recheck the conveyor belt tracking and readjust if necessary.
7. When satisfied, replace the brake cover.

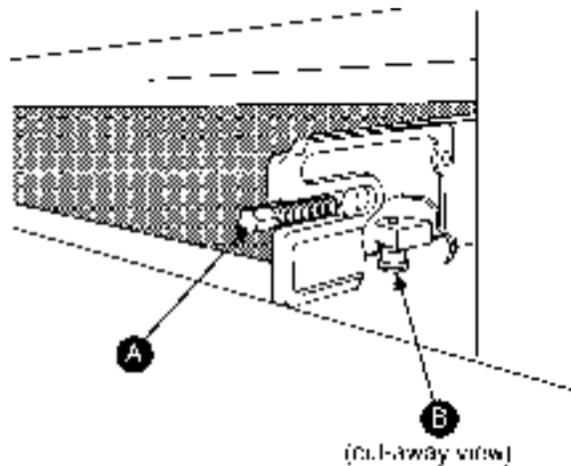


FIGURE 6

## FEED SPEED

The feed speed adjustment is infinitely variable in order to meet the sanding requirements of a wide variety of materials. In general, soft woods require a higher feed speed, while hard woods require a lower feed speed. However, correct feed speed selection is largely a matter of experience.

**CAUTION:** CHANGE THE FEED SPEED ONLY WHILE THE MACHINE IS RUNNING.

Adjust the feed speed with the speed selector knob of the worm gear reducer, (A) Figure 7, and the speed adjustment valve of the hydraulically driven conveyor belt.

Turn the feed speed selector knob clockwise to decrease the conveyor belt speed, counter-clockwise to increase it.

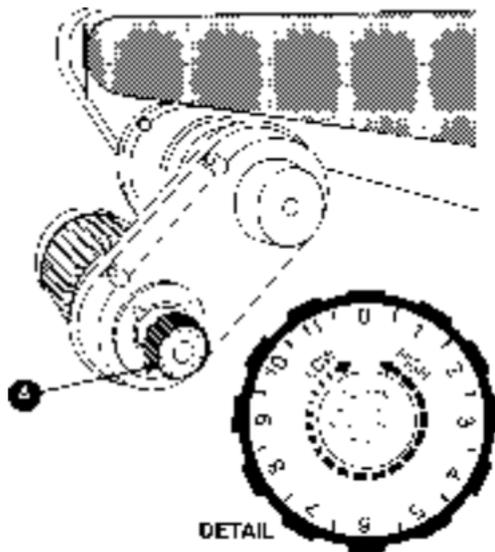


FIGURE 7

### PRESSURE ROLLER ADJUSTMENT

The front and rear pressure rollers have been factory adjusted. However, if further adjustment is ever required, proceed as follows:

1. Stop machine.
2. Place a sanded panel on the conveyor belt and under the rollers. The panel should be long enough to contact both front and back rollers. Raise the table until the panel contacts the rollers.
3. Make sure the pressure at the right and left side of pressure rollers is even.
4. Loosen the fix nut (A) then turn the adjustment knob (B) as shown in Figure 8.
5. When parallelism is satisfactory, retighten the fix nut.

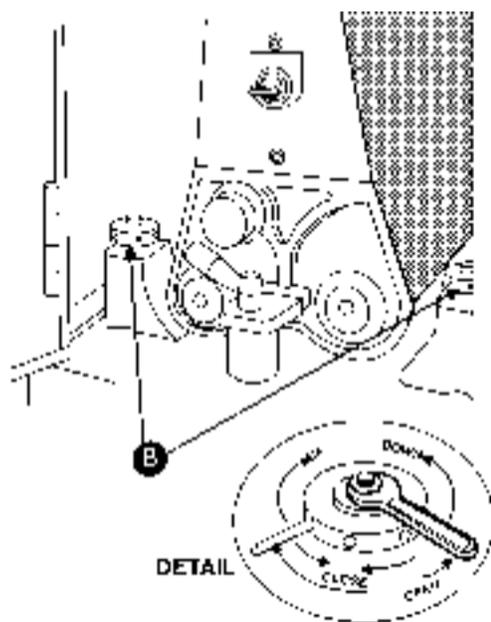


FIGURE 8

### OPERATION

Before operating sander, make sure that:

1. Dust collection system is turned on.
2. Sanding belt specification is correct.
3. Sanding belt is running in proper direction.
4. Sanding belt tension is correct.
5. All screws and handles are tightened securely.
6. Working air pressure is correct. (Normal working pressure is 4-5 kg/cm<sup>2</sup>). Do not operate sander until normal pressure is reached.
7. Sanding belt is tracking correctly.
8. Conveyor belt is tracking correctly.
9. Thickness is correctly set.
10. Feed speed is correctly set.

### BRAKING SYSTEM

The sander will stop automatically if any of the following occur:

- No air supply to the machine.
- No sanding belt mounted.
- Improper belt tension.
- Sanding belt runs out of track.
- If the sanding belt breaks, all movement will be stopped, though the conveyor table can still be raised or lowered.

Once the machine has stopped, the operator should find where the braking system was tripped, and make the necessary adjustments. The machine can then be reset and restarted. See Figure 9 for the location of limit switches.

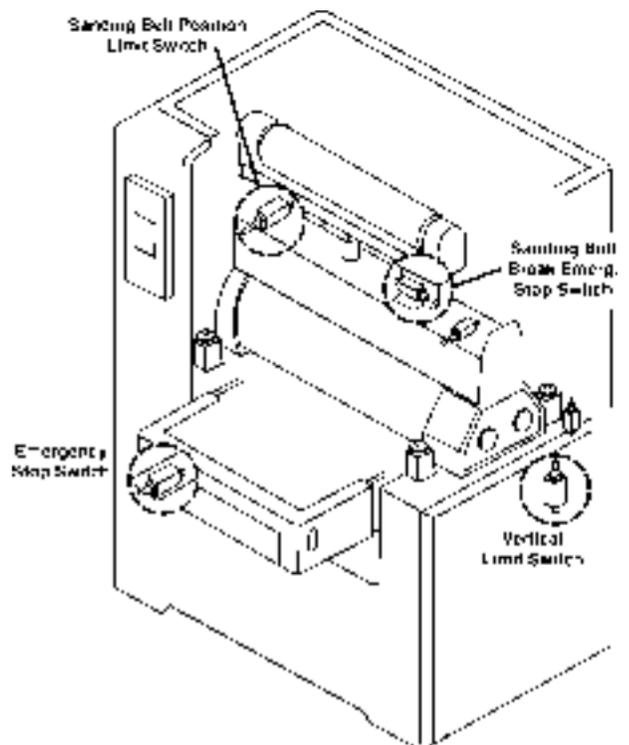


FIGURE 9

## MAINTENANCE

1. The interior of the machine should be thoroughly cleaned each day after use of the sander. Remove the sanding belt before cleaning and replace it when finished.
2. The bearings should be greased after every 150 work hours.
3. If the machine is equipped with an hydraulic power system, the hydraulic oil should be renewed after every 6000 work hours.

4. The water should be released from inside the filter cup.
5. Ensure that there is an adequate film of oil on the table jack screws at all times.
6. The oil inside the gear reducers should be renewed after the first 300 work hours and every 2500 work hours thereafter. Recommended oil is #140 gear oil.

## TROUBLE SHOOTING RB-43 & RB-51

PROBLEM	POSSIBLE CAUSE	SOLUTION
Sanding belt clogs too quickly.	<ol style="list-style-type: none"> <li>1. Grit of sanding belt is too fine.</li> <li>2. Sanding overload.</li> <li>3. Too much oil, dirt on wood surface.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace with larger grit.</li> <li>2. Reduce sanding load.</li> <li>3. Clean wood, or use better stock.</li> </ol>
Too many roundings created along the edge while sanding solid wood.	<ol style="list-style-type: none"> <li>1. Too much material being removed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce the amount of material being removed.</li> </ol>
Uneven thickness between the left and right sides of the workpiece.	<ol style="list-style-type: none"> <li>1. Conveyor table not parallel with contact roller.</li> <li>2. Conveyor belt worn out.</li> <li>3. Graphite cloth and carpet on the pad are worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust conveyor table/contact roller to parallel.</li> <li>2. Replace conveyor belt.</li> <li>3. Replace graphite cloth and carpet.</li> </ol>
Uneven thickness between the front and rear ends of the workpiece.	<ol style="list-style-type: none"> <li>1. Feed speed too fast.</li> <li>2. Sanding overload.</li> <li>3. Grit of sanding belt too fine.</li> <li>4. Unequal position of pressure plate.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce rate of feed.</li> <li>2. Reduce sanding load.</li> <li>3. Use larger grit sanding belt.</li> <li>4. Adjust pressure plate to produce equal pressure on stock.</li> </ol>
Workpiece slips on conveyor belt.	<ol style="list-style-type: none"> <li>1. Too much pressure from pressure plate.</li> <li>2. Dirty conveyor belt.</li> <li>3. Conveyor belt is worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce force from pressure plate.</li> <li>2. Clean conveyor belt.</li> <li>3. Replace conveyor belt.</li> </ol>
Straight notches on workpiece surface.	<ol style="list-style-type: none"> <li>1. Dirty pressure plate.</li> <li>2. Contact drum is scratched.</li> <li>3. Graphite cloth and carpet on the pad are worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean pressure plate.</li> <li>2. Replace drum.</li> <li>3. Replace cloth and carpet.</li> </ol>
Snake markings on workpiece.	<ol style="list-style-type: none"> <li>1. Sanding belt partially damaged.</li> <li>2. Worn areas on sanding belt.</li> </ol>	<ol style="list-style-type: none"> <li>1. Repair/replace sanding belt</li> <li>2. Replace sanding belt.</li> </ol>
Cross-parallel stripes across the entire width of workpiece	<ol style="list-style-type: none"> <li>1. Sanding belt joint is too thick.</li> <li>2. Worn areas on sanding belt.</li> <li>3. Sanding load not less than 0.0mm.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace sanding belt.</li> <li>2. Replace sanding belt.</li> <li>3. Reduce sanding load to less than 0.0mm.</li> </ol>

## OPERATION OF DIGITAL PANEL

Your wide belt sander comes equipped with a single chip microcomputer with digital readout, Figure 10.

### SPECIFICATIONS:

Power Input ..... AC(0V-110V-220V) 50/60 Hz  $\pm$ 20%  
 Signal Input..... Standard ENCODER A B Phase  
 Signal (DC12V)  
 Relay Max. Load..... AC(250V-3A)  
 Safety Limit Switch:

Use NC, C in the electromagnetism on-off return circuit to protect automatically, or cascade with the relay R1, R2 of this unit.

**⚠ WARNING:** For safety reasons, this control unit *must be equipped* with the stroke safety limit switch.

**⚠ WARNING:** The computerized control unit comes pre-programmed from the factory. **DO NOT** alter the above specifications on your control unit without authorization from a qualified factory representative. Incorrect programming of the device could cause unit failure as well as risk of injury to people and damage to the sander.

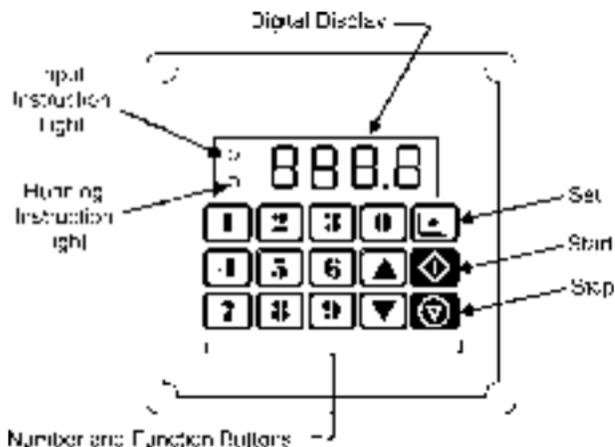


FIGURE 10

### RELAY FUNCTION (Figure 11):

- R1 = dimension increasing
- R2 = dimension decreasing
- R3 = high speed
- R4 = low speed
- R5 = under running
- R6 = job finished
- R7 = braking

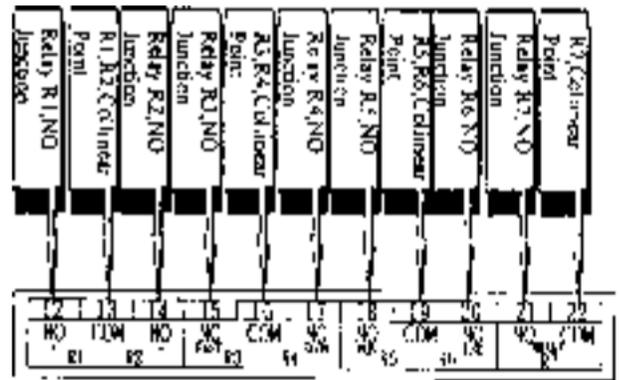


FIGURE 11

### CALIBRATION

1. Calibrate the digital readout by first measuring the thickness of your workpiece.
2. Input the correct figure to match the workpiece thickness, and press SET for 2 to 5 seconds.

### INPUT OF DATA

1. Press any of the number buttons and "000.0" will appear on the display.
2. Input the correct figure with the number buttons, then press "set" for 2-3 seconds.
3. The display will begin flashing and then stop, with the new data on the display.

Alternatively, you may set the new input by pressing the + or - button until the proper figure is reached (NOTE: The INPUT and RUN lights will be illuminated at the same time.)

4. Press START (the INPUT and RUN lights will be illuminated at the same time). The control unit will begin to run and the figure on the display will change back to 0, then it will start to increase up to the figures that were inputted.

### MAGNIFICATION SETTING

1. This control unit can multiply the number of Encoder signals, 1, 2 or 4 times to increase the resolution.
2. Turn off the power.
3. Select the function of X1, X2 or X4 with the switch on the rear of the control unit.
4. Turn on the power.

## TROUBLE SHOOTING for Digital Control Panel

PROBLEM	POSSIBLE CAUSE	SOLUTION
The display fails to show figures.	<ol style="list-style-type: none"> <li>1. Electric pressure of the 220V or AC110V is abnormal.</li> <li>2. Fuse is burned out.</li> <li>3. Control unit is out of order.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-input correct electric pressure.</li> <li>2. Replace 1A fuse.</li> <li>3. Unit must be repaired or replaced by authorized service personnel.</li> </ol>
Display shows abnormal figures.	<ol style="list-style-type: none"> <li>1. Wrong figures were input.</li> <li>2. Parameter is incorrect.</li> </ol>	<ol style="list-style-type: none"> <li>1. Input the proper numbers in accordance with the actual dimensions.</li> <li>2. Calculate correct parameter and input it. * If the above steps are ineffective, turn the power off and then on. If it is still not working properly it should be repaired or replaced.</li> </ol>
Display shows figures, but they do not change in conjunction with the hoist motor's operation.	<ol style="list-style-type: none"> <li>1. Proximity switch is not functioning (a functioning prox. switch will cause the light on the induction switch to be illuminated or put out depending on movement of the table).</li> <li>2. Distance between induction unit and induction sheet is more than 1mm.</li> <li>3. Encoder not running in accordance with the table movement. Axle connector off or damaged.</li> <li>4. Use Watt-hour meter to measure if phase A.B matches the change of DC12V and 0V. If phase A.B has no change, Encoder is defective.</li> </ol>	<ol style="list-style-type: none"> <li>1. Change proximity switch.</li> <li>2. Adjust distance between induction unit and induction sheet to less than 1mm.</li> <li>3. Repair or replace Encoder.</li> <li>4. Replace Encoder.</li> </ol>
Travel dimension incorrect	<ol style="list-style-type: none"> <li>1. Control unit parameter is not in harmony with the table.</li> </ol>	<ol style="list-style-type: none"> <li>1. Correct control unit parameter.</li> </ol>

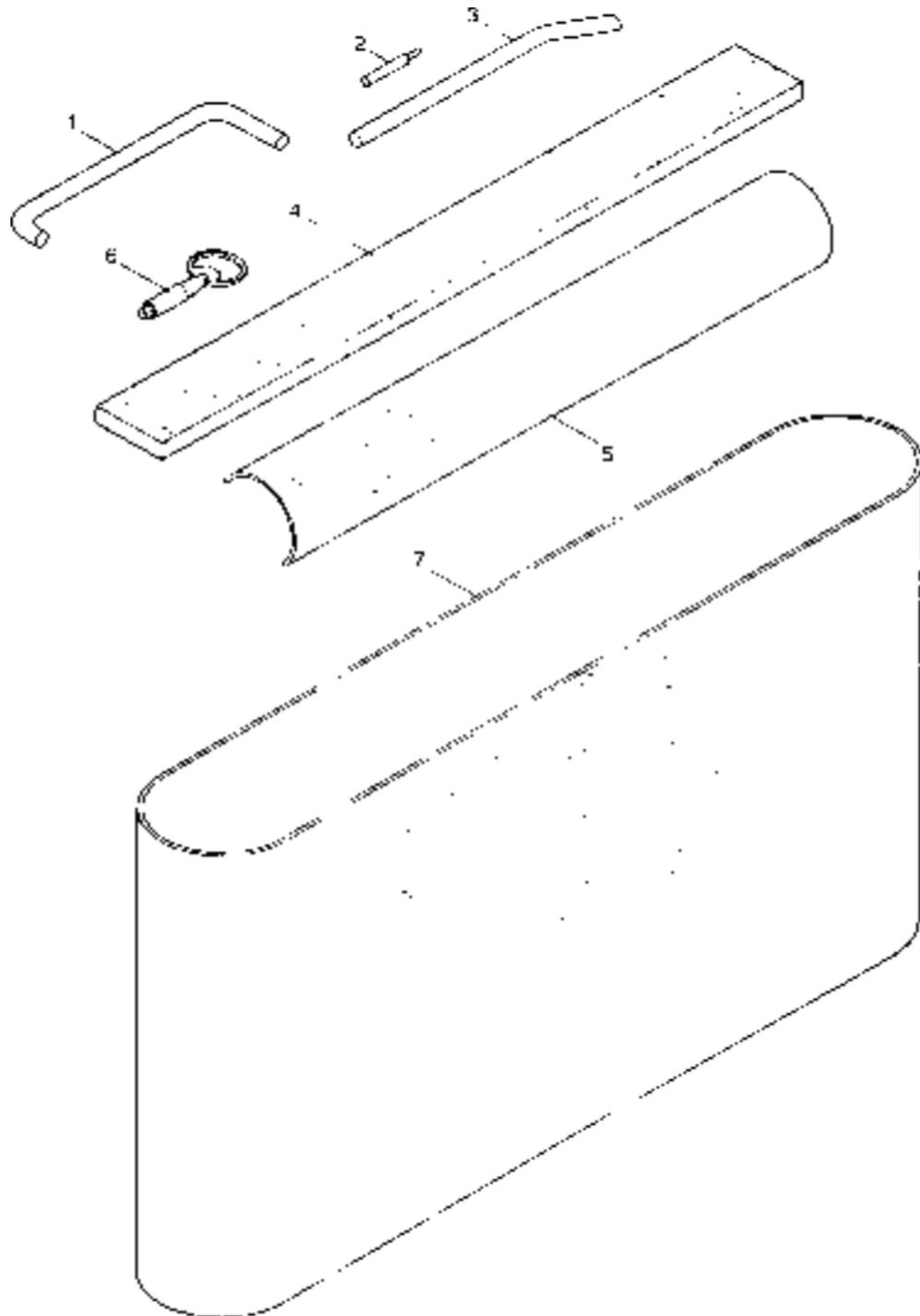
## PARTS LIST: Sanding Belt (RB-43)

NO. PART NO. DESCRIPTION

1 6294251 HOLDER, GRAPHITE  
 2 6294252 TUBE, LIMIT SWITCH  
 3 6294253 ROD, PLUG ADJUSTMENT  
 4 6294254 FELT  
 5 6294255 GRAPHITE  
 6 6294256 HANDLE, DOOR  
 7 6294313 60 GRIT SANDING BELT,  
 43" X 60"

NO. PART NO. DESCRIPTION

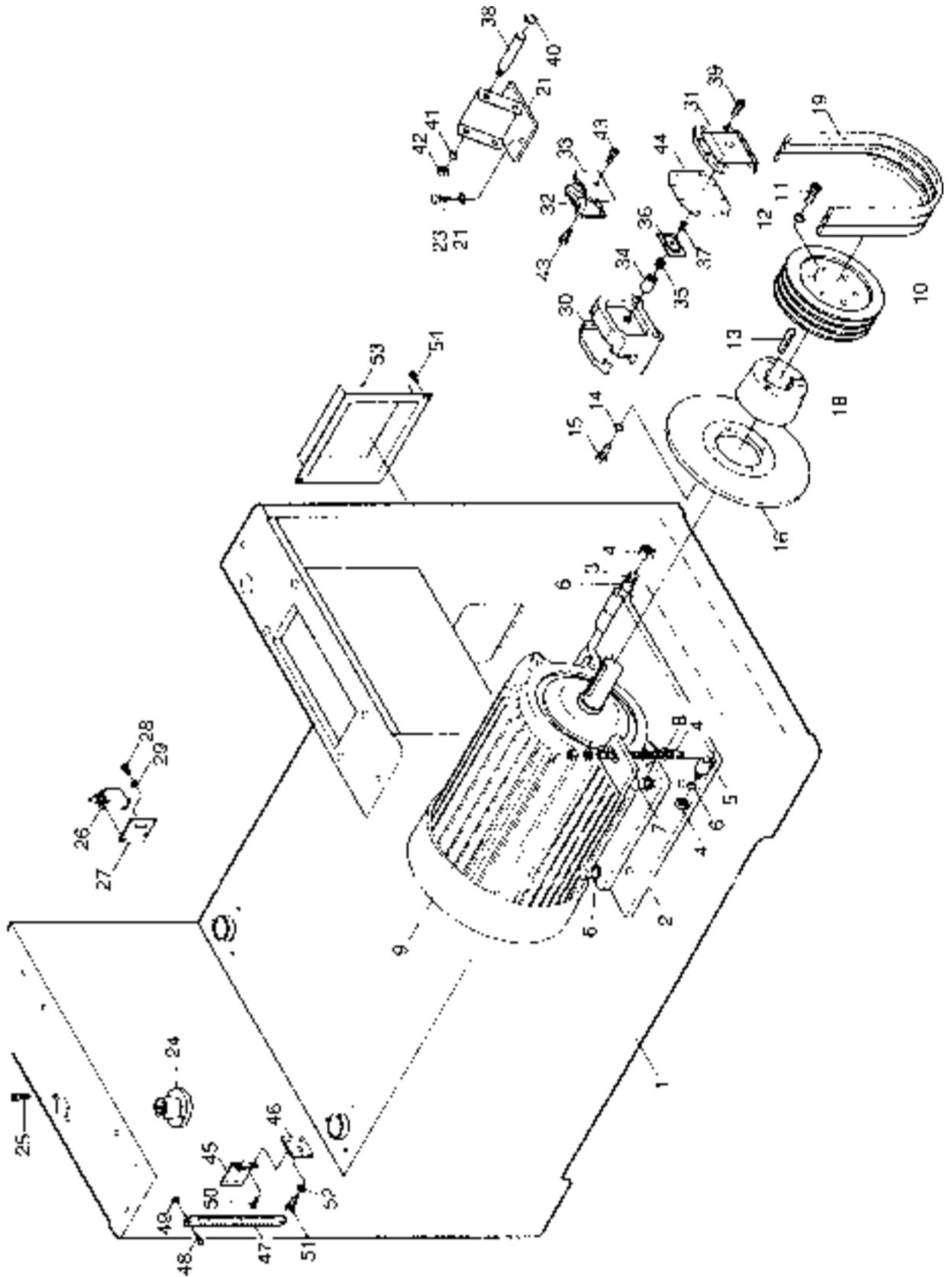
6294579 80 GRIT SANDING BELT,  
 43" X 60"  
 6294257 100 GRIT SANDING BELT,  
 43" X 60"  
 6294580 120 GRIT SANDING BELT,  
 43" X 60"



## PARTS LIST: Lower Machine Body / Brake / Hoist Motor (RB-43)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294258	FRAME, MACHINE	25	6294279	SCREW, HEX. SOC. HD.
2	6294259	BASE, MOTOR	26	6294280	SWITCH, LIMIT
3	6294260	HINGE, MOTOR BASE	27	6294281	PLATE, LIMIT SWITCH
4	6294261	NUT, 1/2"	28	6294282	SCREW, 1/4"
5	6294262	ROD, MOTOR BASE ADJ.	29	6294283	WASHER, PLAIN
6	6294263	WASHER, SPRING, 1/2"		6294659	ASSY., BRAKE (Items 30 thru 44)
7	6294264	SCREW, 1/2"	30	6294284	BRACKET, BRAKE
8	6294265	WASHER, PLAIN, 1/2"	31	6294285	GUARD, BRAKE BRKT. FRONT
9	6294266	MOTOR, 25 HP	32	6294286	LINING, BRAKE FRONT
10	6294267	PULLEY	33	6294661	LINING, BRAKE REAR
11	6294268	SCREW, HEX. SOC. HD.	34	6294287	ARBOR, BRAKE
12	6294263	WASHER, SPRING, 1/2"	35	6294288	SPRING, BRAKE
13	6294269	KEY	36	6294289	PIECE, BRAKE INSIDE
14	6294270	WASHER, SPRING, 3/8"	37	6294290	SCREW, FLAT HEAD, 1/4"
15	6294271	SCREW, 3/8"	38	6294291	PIN, BRAKE
16	6294272	BRAKE, DISK	39	6294292	SCREW, HEX. SOC. HD.
18	6294273	BUSHING, PULLEY	40	6294293	"C" CIRCLIP S/3
19	6294274	BELT, B72	41	6294270	WASHER, SPRING, 3/8"
21	6294275	BRACKET, BRAKE	42	6294294	NUT, 3/8"
22	6294276	WASHER, PLAIN, 3/8"	43	6294295	SCREW, HEX. SOC. HD.
23	6294277	SCREW, 3/8"	44	6294296	GASKET, BRAKE
24	6294278	NUT, FLAT HEAD			

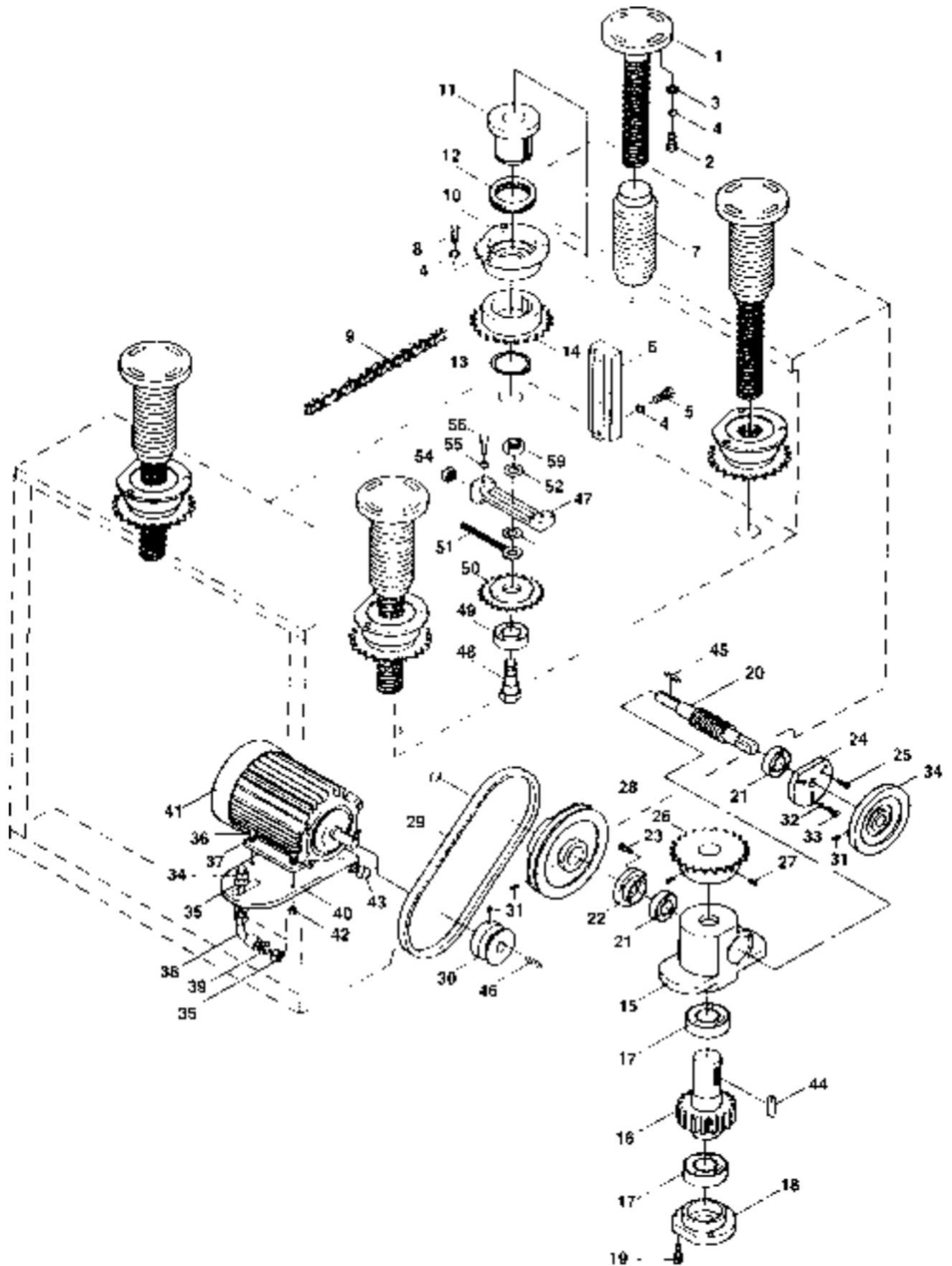
**EXPLODED VIEW: Lower Machine Body / Brake / Hoist Motor (RB-43)**



## PARTS LIST: Table Drive Assembly (RB-43)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294297	SCREW, ELEVATION	29	6294325	BELT A35
2	6294298	SCREW, 5/16"	30	6294326	PULLEY
3	6294299	WASHER, PLAIN, 5/16"	31	6294327	SCREW, HEADLESS, 1/4"
4	6294300	WASHER, SPRING, 5/16"	32	6294328	WASHER, SPRING, 1/4"
5	6294301	SCREW, 5/16"	33	6294329	SCREW, 5/16"
6	6294302	SLIDE, ELEVATION	34	6294330	WHEEL, HAND
7	6294303	BELLOW, DUST GUARD	35	6294331	BASE, MOTOR
8	6294304	SCREW, 5/16"	36	6294332	SCREW, 1/4"
9	6294305	CHAIN	37	6294328	WASHER, SPRING, 1/4"
	6294660	ASSY., NUT HOUSING (Items 10 thru 14)	38	6294333	ROD, MOTOR BASE ADJ.
10	6294306	HOUSING, NUT	39	6294265	WASHER, PLAIN, 1/2"
11	6294307	NUT	40	6294261	NUT, 1/2"
12	6294308	BEARING, THRUST 51107	41	6294334	MOTOR, 1/4 HP
13	6294309	"C" CIRCLIP S35	42	6294335	NUT, 1/4"
14	6294310	WHEEL, SPROCKET	43	6294336	SCREW, 1/2" X 4"
15	6294311	BOX, ELEVATION GEAR	44	6294337	KEY
16	6294312	GEAR, WORM	45	6294338	KEY
17	6291817	BEARING 6005Z	46	6294339	KEY
18	6294314	CAP, BEARING	47	6294340	PIECE, SPROCKET WHEEL ADJ.
19	6294315	SCREW, HEX. SOC. HD.	48	6294341	SHAFT, SPROCKET WHEEL
20	6294316	WORM	49	6294342	BEARING 6003ZZ
21	6294317	BEARING 6002Z	50	6294343	WHEEL, ADJ. SPROCKET
22	6294318	CAP, BEARING	51	6294344	ROD, SPROCKET WHEEL ADJ.
23	6294319	SCREW, HEX. SOC. HD.	52	6294276	WASHER, PLAIN, 3/8"
24	6294320	CAP, BEARING	53	6294345	NUT, 3/8"
25	6294321	SCREW, HEX. SOC. HD.	54	6294346	NUT, 5/16"
26	6294322	WHEEL, SPROCKET	55	6294300	WASHER, SPRING, 5/16"
27	6294323	SCREW, HEADLESS, 5/16"	56	6294347	SCREW, 5/16"
28	6294324	PULLEY			

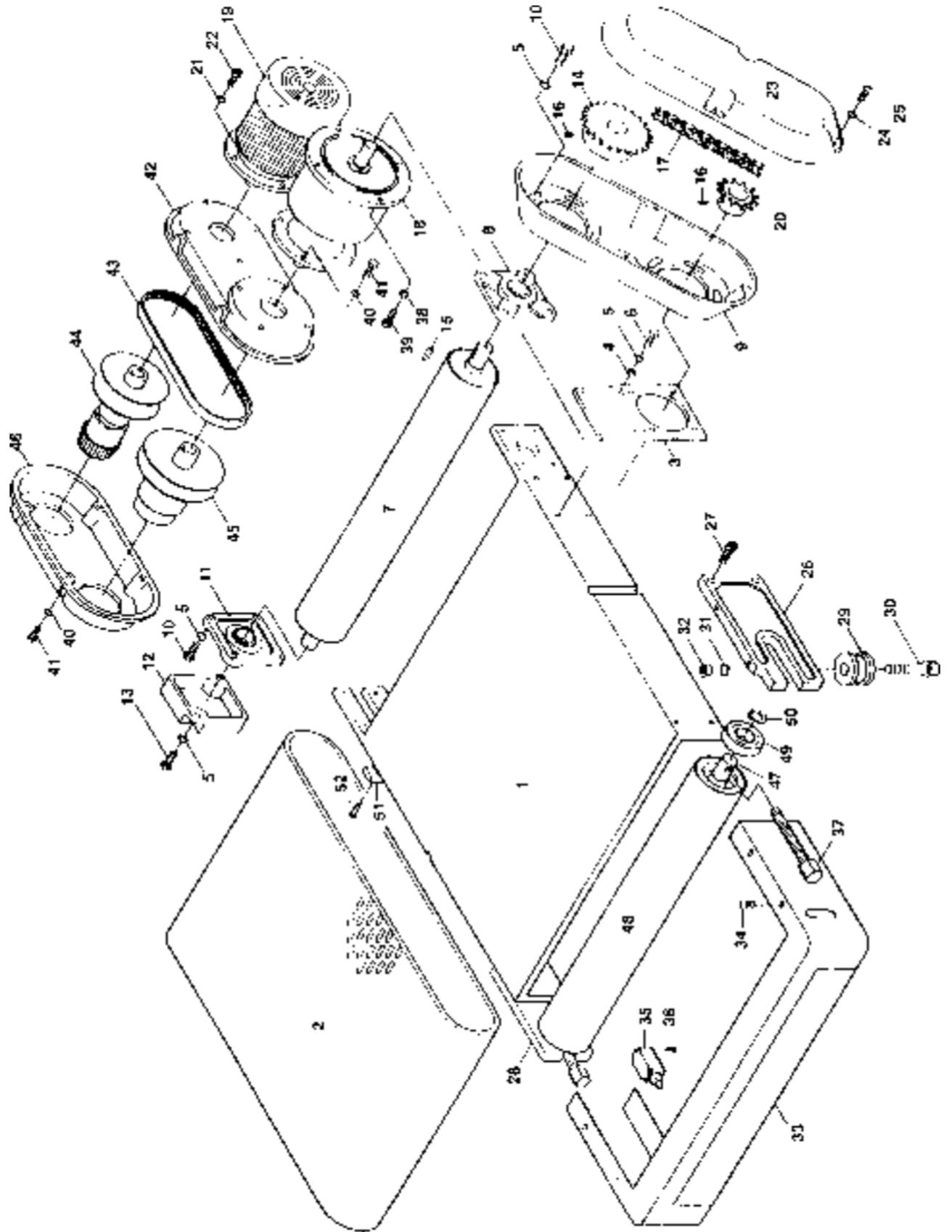
**EXPLODED VIEW: Table Drive Assembly (RB-43)**



## PARTS LIST: Table & Conveyor Belt (RB-43)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294348	TABLE, CONVEYOR	29	6294372	WHEEL, CONVEYOR BELT POSITIONING
2	6294349	BELT, CONVEYOR	30	6294373	SCREW, HEX. SOC. HD., 5/16"
3	6294572	PLATE, GEARBOX FIX	31	6294270	WASHER, SPRING, 3/8"
4	6294276	WASHER, PLAIN, 3/8"	32	6294294	NUT, 3/8"
5	6294270	WASHER, SPRING, 3/8"	33	6294374	COVER, FRONT BRAKE
6	6294350	SCREW, 3/8"	34	6294375	SCREW, RD. PHILLIP'S, 1/4"
7	6294351	ROLLER, OUTFEED	35	6294376	SWITCH, LIMIT
8	6294352	BEARING, UCF206	36	6294377	SCREW, RD. PHILLIP'S, M5
9	6294353	GUARD, CHAIN	37	6294378	ROD, CONVEYOR BELT ADJ.
10	6294354	SCREW, 3/8"	38	6294379	WASHER, SPRING
11	6294355	BEARING, UCF205	39	6294380	SCREW
12	6294356	CAP, BEARING	40	6294381	WASHER, SPRING, M8
13	6294357	SCREW, 3/8"	41	6294382	SCREW, M8
14	6294358	WHEEL, SPROCKET	42	6294383	PLATE, VARIABLE SPEED UNIT BASE
15	6294359	KEY	43	6294384	BELT, TIMING
16	6294360	SCREW, HEADLESS, 5/16"	44	6294385	PULLEY, DRIVING
17	6294361	CHAIN	45	6294386	PULLEY, DRIVEN
18	6294362	REDUCER, GEAR	46	6294387	COVER, VARIABLE SPEED UNIT
19	6294363	MOTOR, 2 HP	47	6294388	SHAFT, INFEED ROLLER
20	6294364	WHEEL, SPROCKET	48	6294389	ROLLER, INFEED
21	6294365	WASHER, SPRING, M10	49	6294390	BEARING
22	6294366	SCREW, M10	50	6294573	"C" CIRCLIP, S30
23	6294367	GUARD, CHAIN	51	6294574	BRACKET, OUTFEED ROLLER
24	6294328	WASHER, SPRING, 1/4"	52	6294575	BRACKET, OUTFEED ROLLER
25	6294368	SCREW, RD. PHILIP'S, 1/4"	53	6294576	LIMITER, ELEVATION ALUMINUM
26	6294369	BRACKET, INFEED ROLLER	54	6294577	SCREW, HEX. SOC. HD., 1/4"
27	6294370	SCREW, HEX. SOC. HD, 3/8"			
28	6294371	BRACKET, INFEED ROLLER			

**EXPLODED VIEW: Table & Conveyor Belt (RB-43)**



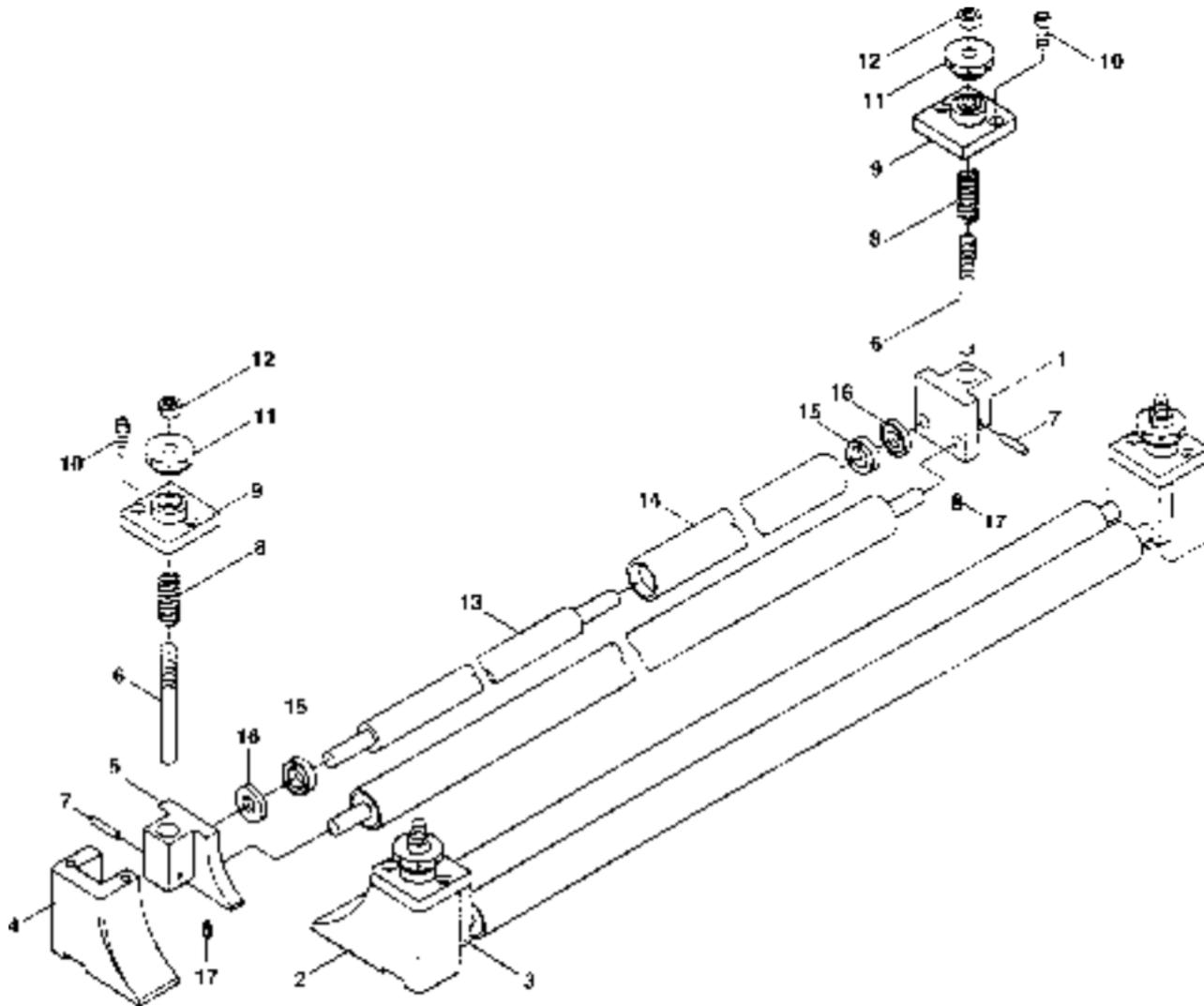
# PARTS LIST: Pressure Roller (RB-43)

NO. PART NO. DESCRIPTION

- 1 6294391 SLIDER, PISTON
- 2 6294392 BRACKET, PISTON
- 3 6294393 SLIDER, PISTON
- 4 6294394 BRACKET, PISTON
- 5 6294395 SLIDER, PISTON
- 6 6294396 SCREW, PISTON ADJ.
- 7 6294397 PIN
- 8 6294398 SPRING
- 9 6294399 COVER, PISTON UPPER

NO. PART NO. DESCRIPTION

- 10 6294400 SCREW, HEX. SOC. HD., 5/16"
- 11 6294401 NUT, PISTON ADJ.
- 12 6294294 NUT, 3/8"
- 13 6294402 SHAFT, PISTON ROLLER
- 14 6294403 ROLLER, PISTON
- 15 6294404 BEARING, 6001
- 16 6294405 COLLAR, SHAFT BEARING
- 17 6294406 SCREW, HEADLESS, 1/4"



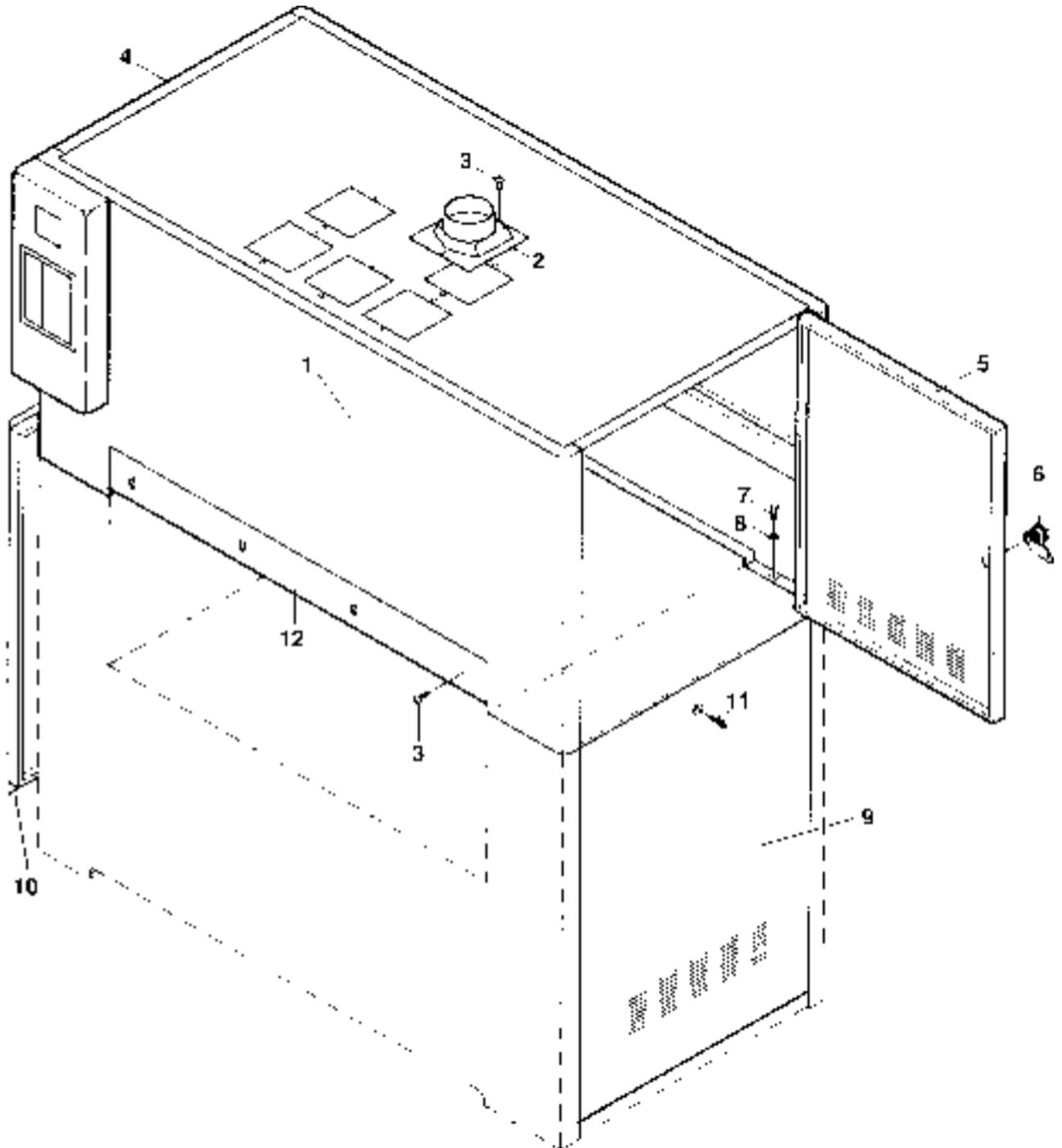
## PARTS LIST: Upper Machine Body (RB-43)

NO. PART NO. DESCRIPTION

- 1 6294504 COVER, UPPER
- 2 6294505 HOOD, DUST
- 3 6294506 SCREW, PHILLIP'S, M6
- 4 6294507 DOOR, UPPER FRAME (L)
- 5 6294508 DOOR, UPPER FRAME (R)
- 6 6294509 LOCK, DOOR

NO. PART NO. DESCRIPTION

- 7 6294510 SCREW, HEX. SOC. HD., 5/16"
- 8 6294299 WASHER, PLAIN, 5/16"
- 9 6294511 DOOR, LOWER FRAME (R)
- 10 6294512 DOOR, LOWER FRAME (L)
- 11 6294513 SCREW, 1/4"
- 12 6294514 PLATE, FRONT PROTECTION



## PARTS LIST: Contact Drum (RB-43)

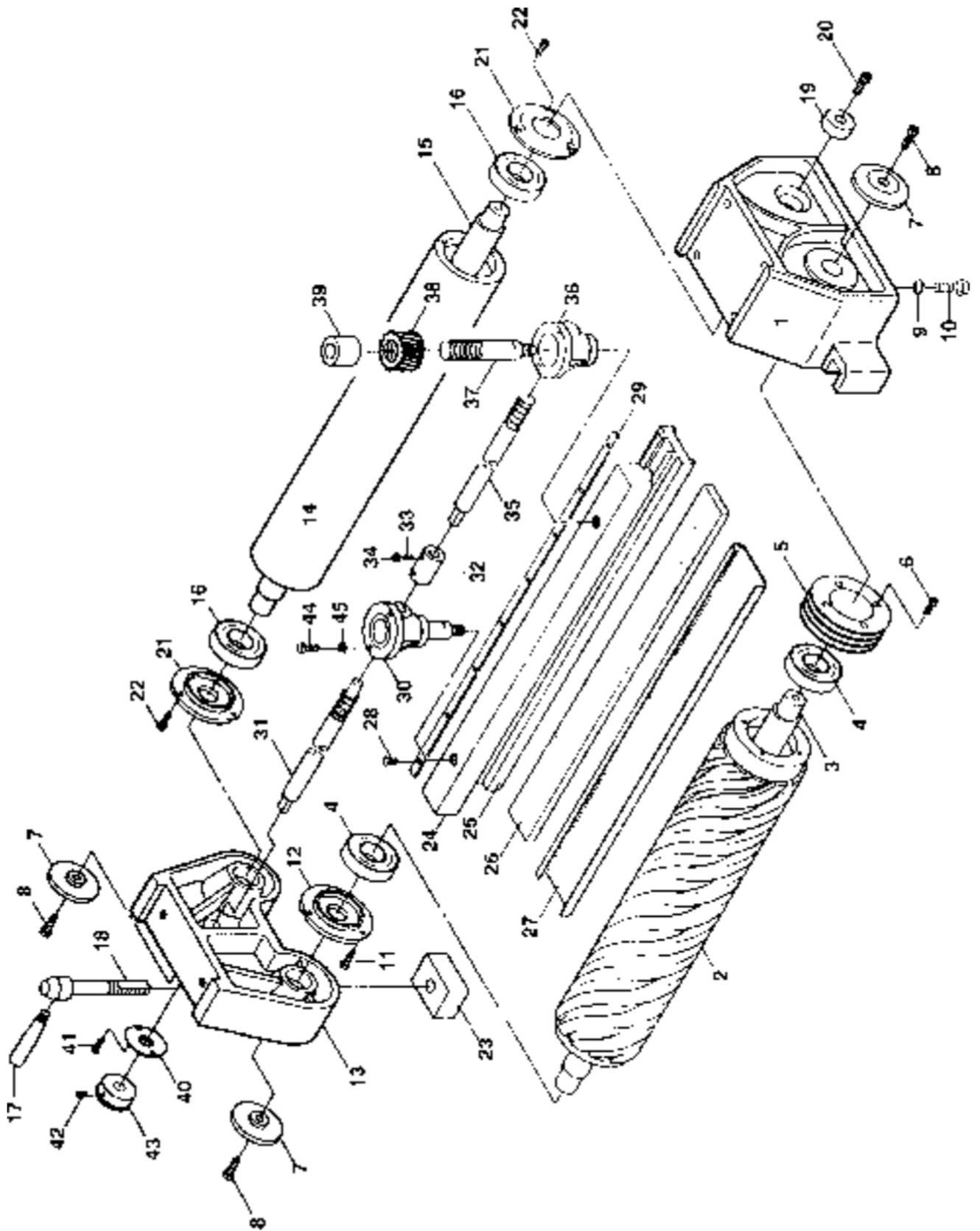
### NO. PART NO. DESCRIPTION

1	6294407	HOUSING, BEARING
2	6294408	ROLLER, RUBBER
3	6294409	SHAFT, RUBBER ROLLER
4	6294410	BEARING, 6206
5	6294411	PULLEY
6	6294412	SCREW, HEX. SOC. HD., 3/8"
7	6294413	WASHER, ROLLER SHAFT LOCK
8	6294414	SCREW, HEX. SOC. HD., 3/8"
9	6294263	WASHER, SPRING, 1/2"
10	6294415	SCREW, HEX. SOC. HD., 1/2"
11	6294416	SCREW, HEX. SOC. HD., 1/4"
12	6294417	CAP, BEARING
13	6294418	HOUSING, BEARING
14	6294419	ROLLER, STEEL
15	6294420	SHAFT, STEEL ROLLER
16	6294421	BEARING, 6206-2RS
17	6294422	HANDLE
18	6294423	SCREW, FLAT HEAD
19	6294424	WASHER, ROLLER SHAFT LOCK
20	6294425	SCREW, HEX. SOC. HD., 3/8"
21	6294426	CAP, BEARING
22	6294427	HANDLE
23	6294428	PAD, BEARING BRACKET

### NO. PART NO. DESCRIPTION

24	6294429	BRACKET, GRAPHITE (MALE)
25	6294430	BRACKET, GRAPHITE (FEMALE)
26	6294431	FELT
27	6294432	GRAPHITE
28	6294433	SCREW, PHILLIP'S, 3/16"
29	6294434	PLATE, GRAPHITE PRESSURE
30	6294435	BOX, GEAR (LEFT)
31	6294436	WORM (FRONT)
32	6294437	COLLAR, WORM CONNECTION
33	6294438	SCREW, HEADLESS, 1/4"
34	6294335	NUT, 1/4"
35	6294439	WORM (REAR)
36	6294440	BOX, GEAR (RIGHT)
37	6294441	SHAFT, SCREW
38	6294442	GEAR, WORM
39	6294443	BUSHING
40	6294444	PLATE, GRADUATED COLLAR
41	6294445	SCREW, PHILLIP'S, 5/32"
42	6294446	SCREW, HEADLESS, 1/4"
43	6294447	COLLAR, GRADUATED
44	6294448	SCREW, 5/16"
45	6294299	WASHER, PLAIN, 5/16"

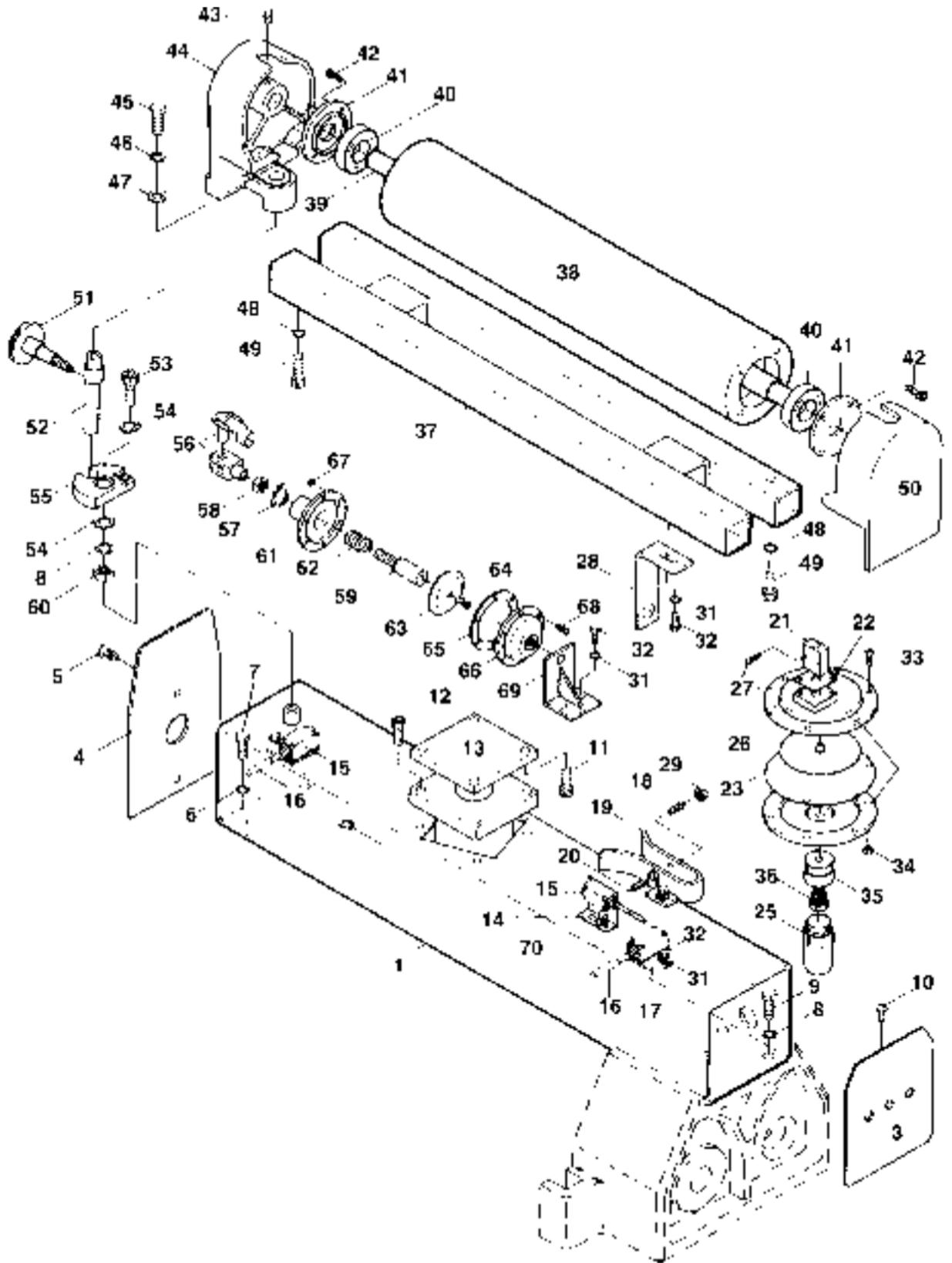
EXPLODED VIEW: Contact Drum (RB-43)



## PARTS LIST: Upper Roller/Frame Assembly (RB-43)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294449	FRAME, SQUARE	37	6294480	BRACKET, UPPER ROLLER
3	6294450	SEAL, SQUARE FRAME (R)	38	6294481	ROLLER, UPPER
4	6294451	SEAL, SQUARE FRAME (L)	39	6294482	SHAFT, UPPER ROLLER
5	6294452	SCREW, FLAT HEAD, 1/4"	40	6294410	BEARING, 6206
6	6294270	WASHER, SPRING, 3/8"	41	6294483	CAP, BEARING
7	6294453	SCREW, 3/8"	42	6294484	SCREW, HEX. SOC. HD., 1/4"
8	6294263	WASHER, SPRING, 1/2"	43	6294485	SCREW, HEADLESS, 5/16"
9	6294454	SCREW, 1/2"	44	6294486	BRACKET, UPPER ROLLER (L)
10	6294455	SCREW, PHILLIP'S, 1/4"	45	6294487	SCREW, 5/16"
11	6294456	SCREW, HEX. SOC. HD., 5/16"	46	6294300	WASHER, SPRING, 5/16"
12	6294457	SCREW, HEX. SOC. HD., 5/16"	47	6294299	WASHER, PLAIN, 5/16"
13	6294458	CYLINDER, AIR	48	6294270	WASHER, SPRING, 3/8"
14	6294459	HOLDER, LIMIT SWITCH (Type L)	49	6294488	SCREW, HEX. SOC. HD., 3/8"
15	6294460	SWITCH, LIMIT	50	6294489	BRACKET, UPPER ROLLER (R)
16	6294461	TUBE, LIMIT SWITCH	51	6294490	SCREW, TRIMMING
17	6294462	HOLDER, LIMIT SWITCH	52	6294491	ROD, ECCENTRIC
18	6294463	NOZZLE, AIR SENSOR (female)	53	6294492	SCREW, HEX. SOC. HD., 1/2"
19	6294464	BRACKET, AIR CYLINDER	54	6294265	WASHER, PLAIN, 1/2"
20	6294465	NOZZLE, AIR SENSOR (male)	55	6294493	PIECE, ECCENTRIC
21	6294466	VALVE THROTTLE	56	6294494	FORK, UNIVERSAL JOINT
22	6294467	BASE, THROTTLE VALVE	57	6294477	NUT, 3/16"
23	6294468	PLATE	58	6294495	NUT, M10
24	6294469	DISC, ALUMINUM	59	6294496	SHAFT, AIR CYLINDER
25	6294470	CAP, OIL	60	6294261	NUT, 1/2"
26	6294471	PLATE, ALUMINUM	61	6294497	COVER, BOTTOM
27	6294472	SCREW, M4	62	6294498	SPRING
28	6294473	PLATE, SANDING BELT POWER OFF	63	6294499	PLATE, ALUMINUM
29	6294474	NUT, 3/8" (fine thread)	64	6294500	SCREW, M6
31	6294475	SCREW, 5/16"	65	6294501	PLATE
32	6294300	WASHER, SPRING, 5/16"	66	6294502	COVER, TOP
33	6294476	SCREW, 3/16"	67	6294477	NUT, 3/16"
34	6294477	NUT, 3/16"	68	6294476	SCREW, 3/16"
35	6294478	CONNECTOR, OIL CAP	69	6294503	BASE, AIR CYLINDER FIRING
36	6294479	SHAFT, OIL CAP	70	6294653	SWITCH, LIMIT

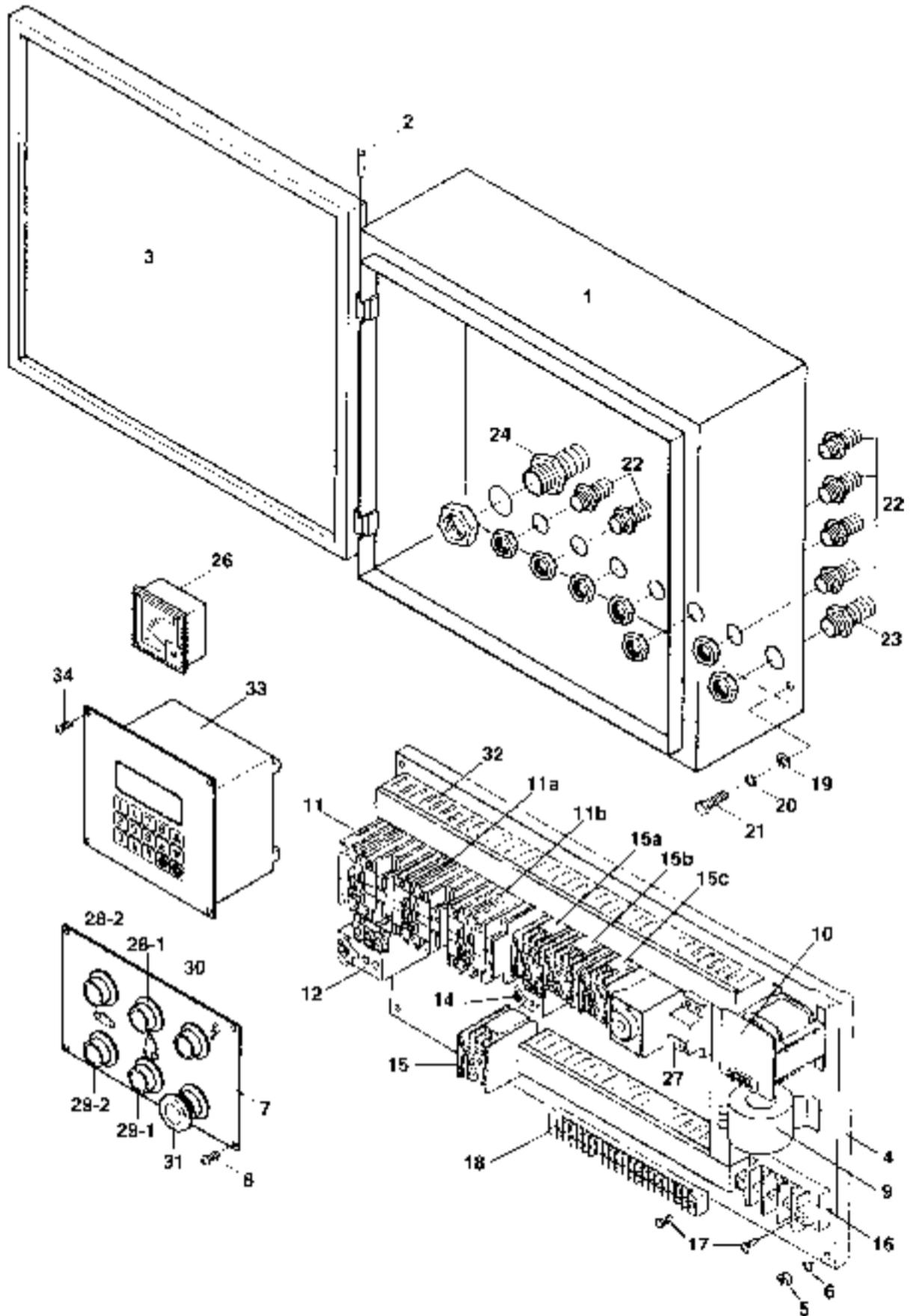
**EXPLODED VIEW: Upper Roller/Frame Assembly (RB-43)**



## PARTS LIST: Control Box (RB-43)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294515	BOX, ELECTRICAL CONTROL	15b	6294647	CONTACTOR, MAGNETIC
2	6294516	HINGE	15c	6294648	CONTACTOR, MAGNETIC
3	6294517	BOX, ELECTRICAL CONTROL DOOR	16	6294528	TERMINAL, POWER WIRE
4	6294518	PLATE, BASE	17	6294529	SCREW, PHILLIP'S, 3/16"
5	6294335	NUT, 1/4"	18	6294530	PLATE, TERMINAL
6	6294328	WASHER, SPRING, 1/4"	19	6294299	WASHER, PLAIN, 5/16"
7	6294519	PANEL, CONTROL	20	6294300	WASHER, SPRING, 5/16"
8	6294520	SCREW, PHILLIP'S, M4	21	6294531	SCREW, 5/16"
9	6294521	DEVICE, PROPORTIONAL CURRENT	22	6294532	CONNECTOR, PU, 1/2"
10	6294522	TRANSFORMER	23	6294533	CONNECTOR, PU, 3/4"
11	6294523	CONTACTOR, MAGNETIC	24	6294534	CONNECTOR, CABLE, 1"
11a	6294644	CONTACTOR, MAGNETIC	25	6294535	METER, AMP
11b	6294645	CONTACTOR, MAGNETIC	27	6294536	SWITCH, CAM
12	6294524	RELAY, OVERLOAD	28	6294537	SWITCH, START
13	6294525	FUSE	29	6294538	SWITCH, STOP
14	6294526	RELAY, OVERLOAD	30	6294539	LIGHT, POWER INDICATION
15	6294527	CONTACTOR, MAGNETIC	31	6294540	SWITCH, EMERGENCY STOP
15a	6294646	CONTACTOR, MAGNETIC	32	6294541	COLUMN, WIRE
			33	6294542	COMPUTER
			34	6294543	SCREW, M4

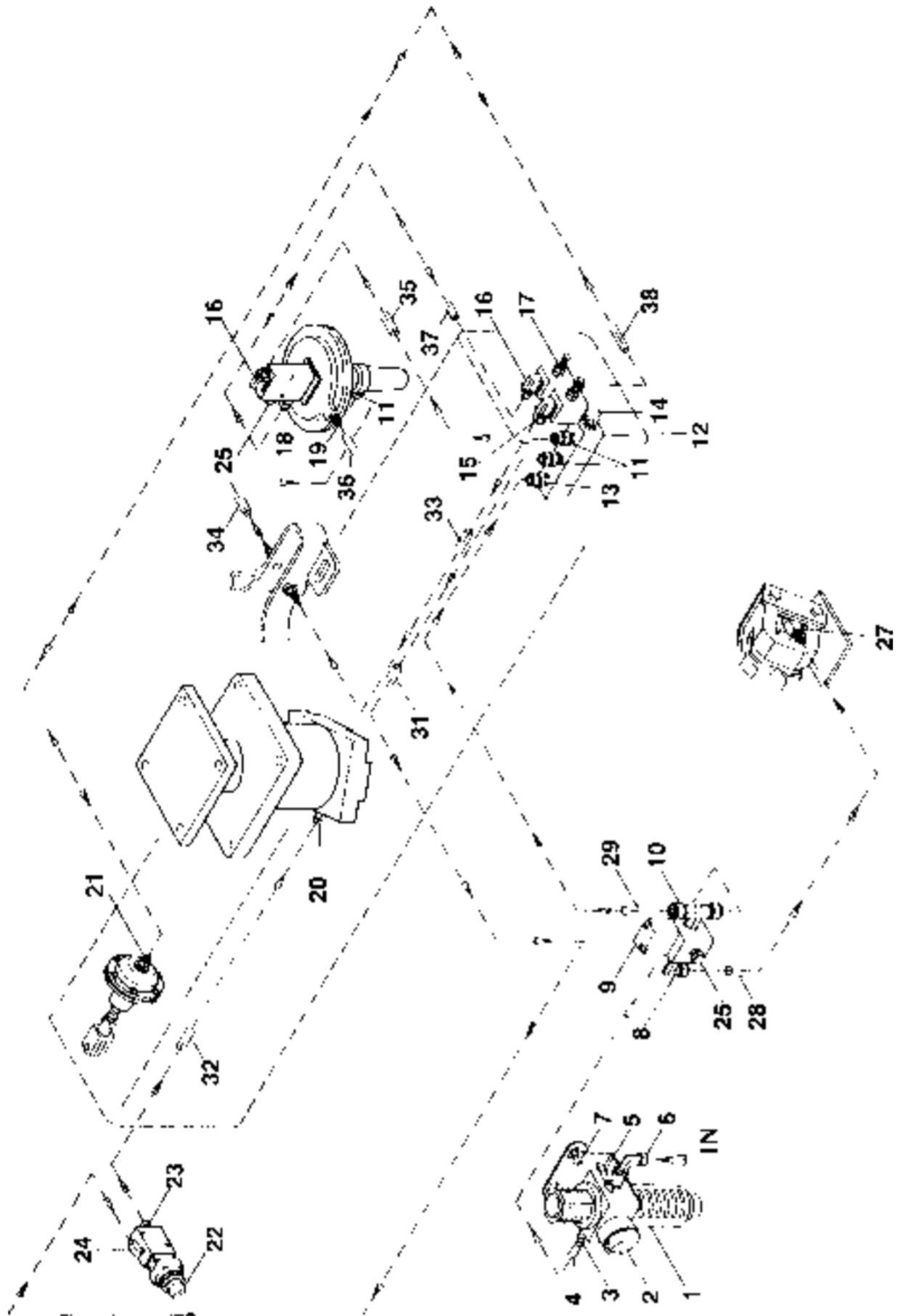
**EXPLODED VIEW: Control Box (RB-43)**



## PARTS LIST: Air Supply System (RB-43 & RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294544	CUP, FILTER	21	6294564	CONNECTOR, PLASTIC
2	6294545	REGULATOR, PRESSURE	22	6294565	SWITCH, AIR
3	6294546	CONNECTOR, BRONZE	23	6294566	CONNECTOR, PLASTIC
4	6294547	HOSE, FLEXIBLE	24	6294567	CONNECTOR, PLASTIC
5	6294548	SWITCH, AIR	25	6294568	BUFFER
6	6294549	ELBOW	26	6294569	CONNECTOR, MULTIPLE HOLE
7	6294550	SCREW, M6	27	6294570	CONNECTOR, PLASTIC
8	6294551	ELBOW	29	6294571	HOSE, FLEXIBLE (RB-43 & 51)
9	6294552	VALVE, SOLENOID	31	6294657	HOSE, FLEXIBLE (RB-43)
10	6294553	T-JOINT		6294654	HOSE, FLEXIBLE (RB-51)
11	6294554	CONNECTOR, PLASTIC	32	6294658	HOSE, FLEXIBLE (RB-43)
12	6294555	CONNECTOR, MULTIPLE HOLE		6294655	HOSE, FLEXIBLE (RB-51)
13	6294556	CONNECTOR, PLASTIC	33	6294663	HOSE, FLEXIBLE (RB-43 & 51)
14	6294557	ELBOW, BRONZE	34	6294664	HOSE, FLEXIBLE (RB-43 & 51)
15	6294558	CONNECTOR, PLASTIC	35	6294665	HOSE, FLEXIBLE (RB-43 & 51)
16	6294559	CONNECTOR, PLASTIC	36	6294666	HOSE, FLEXIBLE (RB-43 & 51)
17	6294560	VALVE, THROTTLE	37	6294667	HOSE, FLEXIBLE (RB-43 & 51)
18	6294561	CONNECTOR, PLASTIC	38	6294662	HOSE, FLEXIBLE (RB-43)
19	6294562	CONNECTOR, BRONZE		6294656	HOSE, FLEXIBLE (RB-51)
20	6294563	CONNECTOR, PLASTIC			

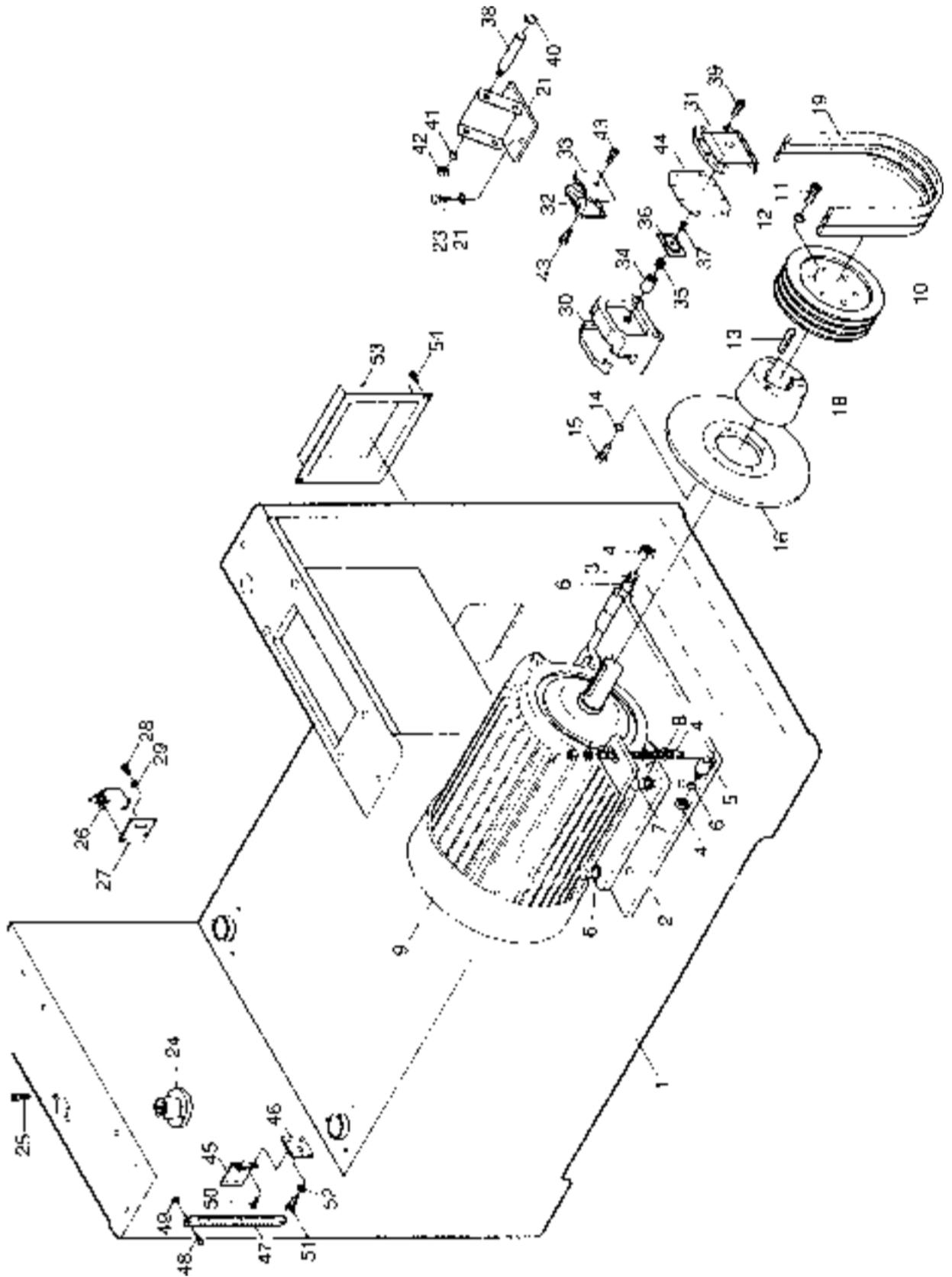
**EXPLODED VIEW: Air Supply System (RB-43 & RB-51)**



## PARTS LIST: Lower Machine Body / Brake / Hoist Motor (RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294586	FRAME, MACHINE	25	6294279	SCREW, HEX. SOC. HD.
2	6294587	BASE, MOTOR	26	6294280	SWITCH, LIMIT
3	6294588	HINGE, MOTOR BASE	27	6294281	PLATE, LIMIT SWITCH
4	6294261	NUT, 1/2"	28	6294282	SCREW, 1/4"
5	6294589	ROD, MOTOR BASE ADJ.	29	6294283	WASHER, PLAIN
6	6294263	WASHER, SPRING, 1/2"		6294659	ASSY., BRAKE (Items 30 thru 44)
7	6294264	SCREW, 1/2"	30	6294284	BRACKET, BRAKE
8	6294265	WASHER, PLAIN, 1/2"	31	6294285	GUARD, BRAKE BRKT. FRONT
9	6294590	MOTOR, 30 HP, 3 Ph, 230/460V	32	6294286	LINING, BRAKE FRONT
10	6294267	PULLEY	33	6294661	LINING, BRAKE REAR
11	6294268	SCREW, HEX. SOC. HD.	34	6294287	ARBOR, BRAKE
12	6294263	WASHER, SPRING, 1/2"	35	6294288	SPRING, BRAKE
13	6294591	KEY	36	6294289	PIECE, BRAKE INSIDE
14	6294270	WASHER, SPRING, 3/8"	37	6294290	SCREW, FLAT HEAD, 1/4"
15	6294271	SCREW, 3/8"	38	6294291	PIN, BRAKE
16	6294272	BRAKE, DISK	39	6294292	SCREW, HEX. SOC. HD.
18	6294273	BUSHING, PULLEY	40	6294293	"C" CIRCLIP S/3
19	6294592	BELT	41	6294270	WASHER, SPRING, 3/8"
21	6294275	BRACKET, BRAKE	42	6294294	NUT, 3/8"
22	6294276	WASHER, PLAIN, 3/8"	43	6294295	SCREW, HEX. SOC. HD.
23	6294277	SCREW, 3/8"	44	6294296	GASKET, BRAKE
24	6294278	NUT, FLAT HEAD			

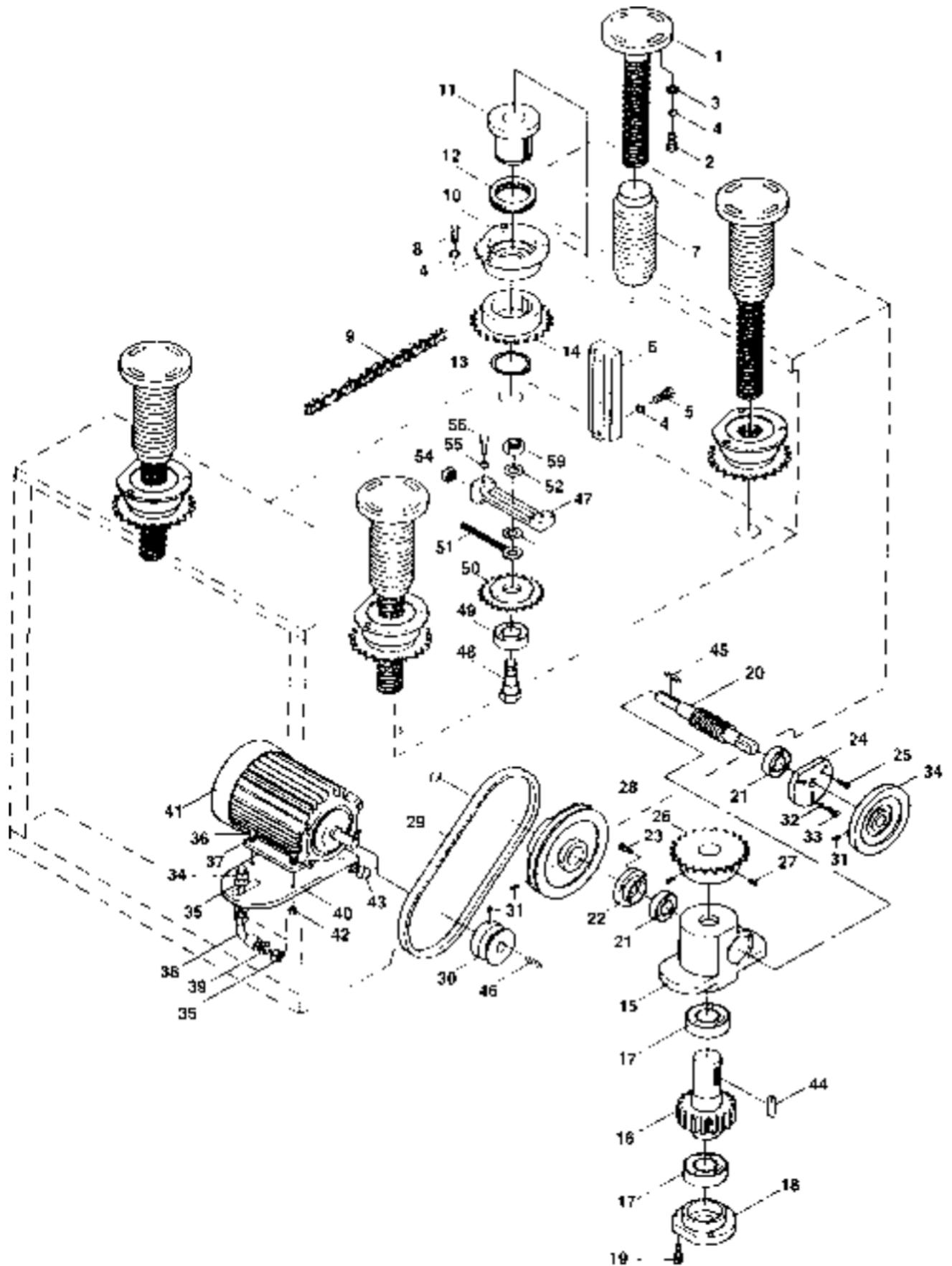
**EXPLODED VIEW: Lower Machine Body / Brake / Hoist Motor (RB-51)**



## PARTS LIST: Table Drive Assembly (RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294297	SCREW, ELEVATION	29	6294325	BELT A35
2	6294298	SCREW, 5/16"	30	6294326	PULLEY
3	6294299	WASHER, PLAIN, 5/16"	31	6294327	SCREW, HEADLESS, 1/4"
4	6294300	WASHER, SPRING, 5/16"	32	6294328	WASHER, SPRING, 1/4"
5	6294301	SCREW, 5/16"	33	6294329	SCREW, 5/16"
6	6294302	SLIDE, ELEVATION	34	6294330	WHEEL, HAND
7	6294303	BELLOW, DUST GUARD	35	6294331	BASE, MOTOR
8	6294304	SCREW, 5/16"	36	6294332	SCREW, 1/4"
9	6294593	CHAIN	37	6294328	WASHER, SPRING, 1/4"
	6294660	ASSY., NUT HOUSING (Items 10 thru 14)	38	6294333	ROD, MOTOR BASE ADJ.
10	6294306	HOUSING, NUT	39	6294265	WASHER, PLAIN, 1/2"
11	6294307	NUT	40	6294261	NUT, 1/2"
12	6294308	BEARING, THRUST 51107	41	6294334	MOTOR, 1/4 HP
13	6294309	"C" CIRCLIP S35	42	6294335	NUT, 1/4"
14	6294310	WHEEL, SPROCKET	43	6294336	SCREW, 1/2" X 4"
15	6294311	BOX, ELEVATION GEAR	44	6294337	KEY
16	6294312	GEAR, WORM	45	6294338	KEY
17	6291817	BEARING 6005Z	46	6294339	KEY
18	6294314	CAP, BEARING	47	6294340	PIECE, SPROCKET WHEEL ADJ.
19	6294315	SCREW, HEX. SOC. HD.	48	6294341	SHAFT, SPROCKET WHEEL
20	6294316	WORM	49	6294342	BEARING 6003ZZ
21	6294317	BEARING 6002Z	50	6294343	WHEEL, ADJ. SPROCKET
22	6294318	CAP, BEARING	51	6294344	ROD, SPROCKET WHEEL ADJ.
23	6294319	SCREW, HEX. SOC. HD.	52	6294276	WASHER, PLAIN, 3/8"
24	6294320	CAP, BEARING	53	6294345	NUT, 3/8"
25	6294321	SCREW, HEX. SOC. HD.	54	6294346	NUT, 5/16"
26	6294322	WHEEL, SPROCKET	55	6294300	WASHER, SPRING, 5/16"
27	6294323	SCREW, HEADLESS, 5/16"	56	6294347	SCREW, 5/16"
28	6294324	PULLEY			

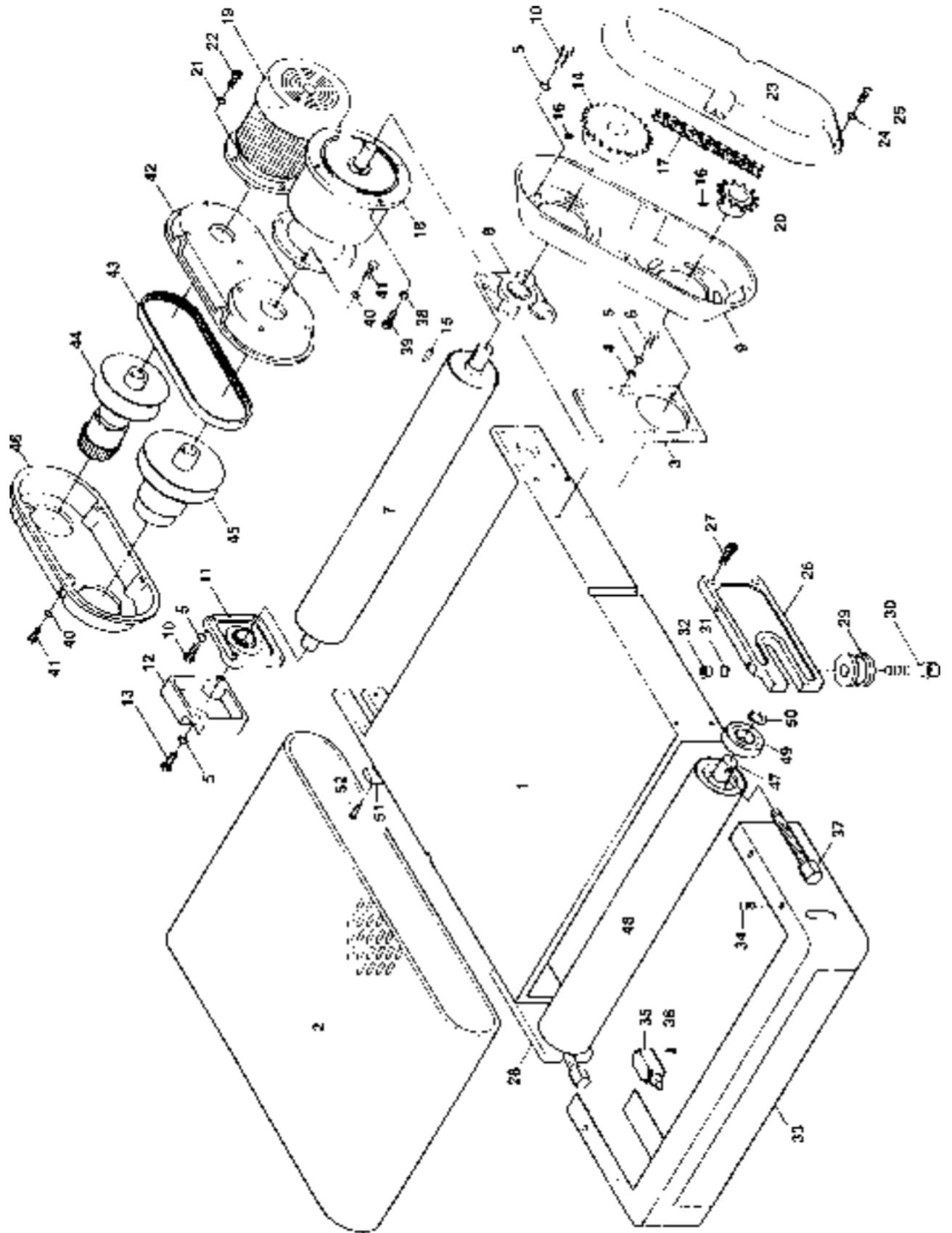
**EXPLODED VIEW: Table Drive Assembly (RB-51)**



## PARTS LIST: Table & Conveyor Belt (RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294594	TABLE, CONVEYOR	29	6294372	WHEEL, CONVEYOR BELT POSITIONING
2	6294595	BELT, CONVEYOR	30	6294373	SCREW, HEX. SOC. HD., 5/16"
3	6294572	PLATE, GEARBOX FIX	31	6294270	WASHER, SPRING, 3/8"
4	6294276	WASHER, PLAIN, 3/8"	32	6294294	NUT, 3/8"
5	6294270	WASHER, SPRING, 3/8"	33	6294597	COVER, FRONT BRAKE
6	6294350	SCREW, 3/8"	34	6294375	SCREW, RD. PHILLIP'S, 1/4"
7	6294596	ROLLER, OUTFEED	35	6294376	SWITCH, LIMIT
8	6294352	BEARING, UCF206	36	6294377	SCREW, RD. PHILLIP'S, M5
9	6294353	GUARD, CHAIN	37	6294378	ROD, CONVEYOR BELT ADJ.
10	6294354	SCREW, 3/8"	38	6294379	WASHER, SPRING
11	6294355	BEARING, UCF205	39	6294380	SCREW
12	6294356	CAP, BEARING	40	6294381	WASHER, SPRING, M8
13	6294357	SCREW, 3/8"	41	6294382	SCREW, M8
14	6294358	WHEEL, SPROCKET	42	6294383	PLATE, VARIABLE SPEED UNIT BASE
15	6294359	KEY	43	6294384	BELT, TIMING
16	6294360	SCREW, HEADLESS, 5/16"	44	6294385	PULLEY, DRIVING
17	6294361	CHAIN	45	6294386	PULLEY, DRIVEN
18	6294362	REDUCER, GEAR	46	6294387	COVER, VARIABLE SPEED UNIT
19	6294363	MOTOR, FEED 2 HP	47	6294598	SHAFT, INFEED ROLLER
20	6294364	WHEEL, SPROCKET	48	6294599	ROLLER, INFEED
21	6294365	WASHER, SPRING, M10	49	6294390	BEARING
22	6294366	SCREW, M10	50	6294573	"C" CIRCLIP, S30
23	6294367	GUARD, CHAIN	51	6294600	BRACKET, OUTFEED ROLLER
24	6294328	WASHER, SPRING, 1/4"	52	6294601	BRACKET, OUTFEED ROLLER
25	6294368	SCREW, RD. PHILIP'S, 1/4"	53	6294602	LIMITER, ELEVATION ALUMINUM
26	6294369	BRACKET, INFEED ROLLER	54	6294577	SCREW, HEX. SOC. HD., 1/4"
27	6294370	SCREW, HEX. SOC. HD, 3/8"			
28	6294371	BRACKET, INFEED ROLLER			

**EXPLODED VIEW: Table & Conveyor Belt (RB-51)**



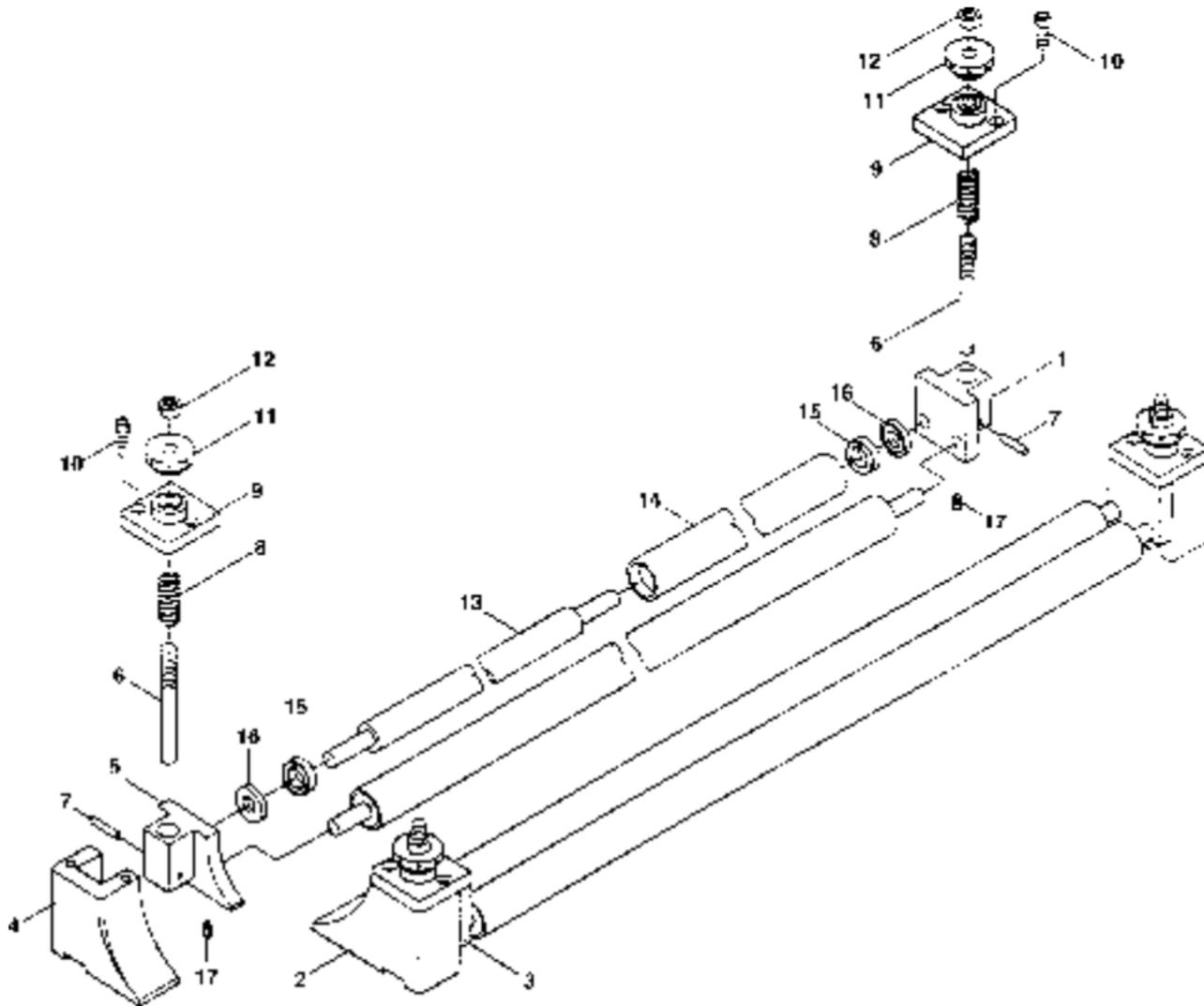
# PARTS LIST: Pressure Roller (RB-51)

NO. PART NO. DESCRIPTION

- 1 6294391 SLIDER, PISTON
- 2 6294392 BRACKET, PISTON
- 3 6294393 SLIDER, PISTON
- 4 6294394 BRACKET, PISTON
- 5 6294395 SLIDER, PISTON
- 6 6294396 SCREW, PISTON ADJ.
- 7 6294397 PIN
- 8 6294398 SPRING
- 9 6294399 COVER, PISTON UPPER

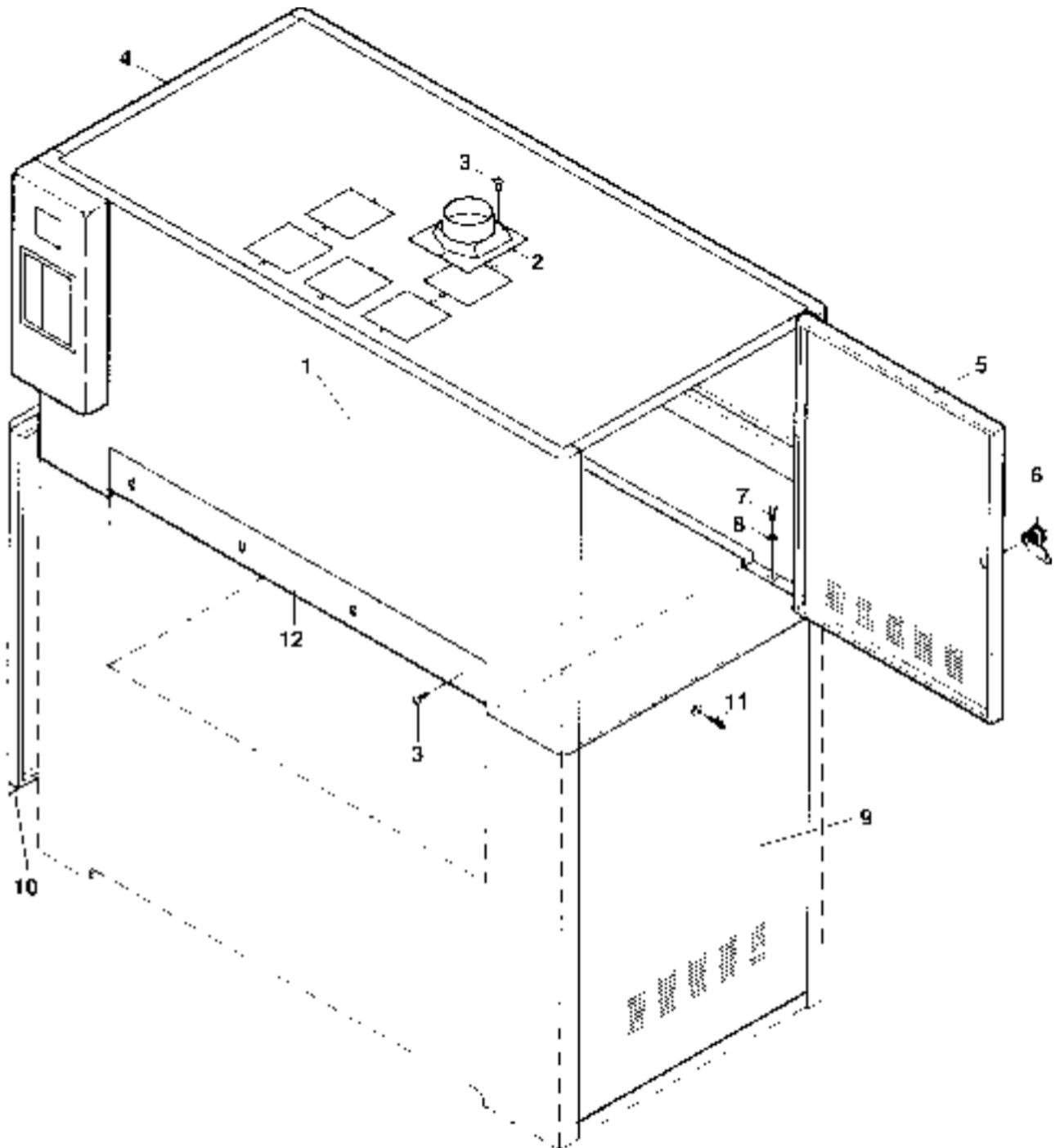
NO. PART NO. DESCRIPTION

- 10 6294400 SCREW, HEX. SOC. HD., 5/16"
- 11 6294401 NUT, PISTON ADJ.
- 12 6294294 NUT, 3/8"
- 13 6294603 SHAFT, PISTON ROLLER
- 14 6294604 ROLLER, PISTON
- 15 6294404 BEARING, 6001
- 16 6294405 COLLAR, SHAFT BEARING
- 17 6294406 SCREW, HEADLESS, 1/4"



## PARTS LIST: Upper Machine Body (RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294605	COVER, UPPER	7	6294510	SCREW, HEX. SOC. HD., 5/16"
2	6294606	HOOD, DUST	8	6294299	WASHER, PLAIN, 5/16"
3	6294506	SCREW, PHILLIP'S, M6	9	6294511	DOOR, LOWER FRAME (R)
4	6294507	DOOR, UPPER FRAME (L)	10	6294512	DOOR, LOWER FRAME (L)
5	6294508	DOOR, UPPER FRAME (R)	11	6294513	SCREW, 1/4"
6	6294509	LOCK, DOOR	12	6294607	PLATE, FRONT PROTECTION



## PARTS LIST: Contact Drum (RB-51)

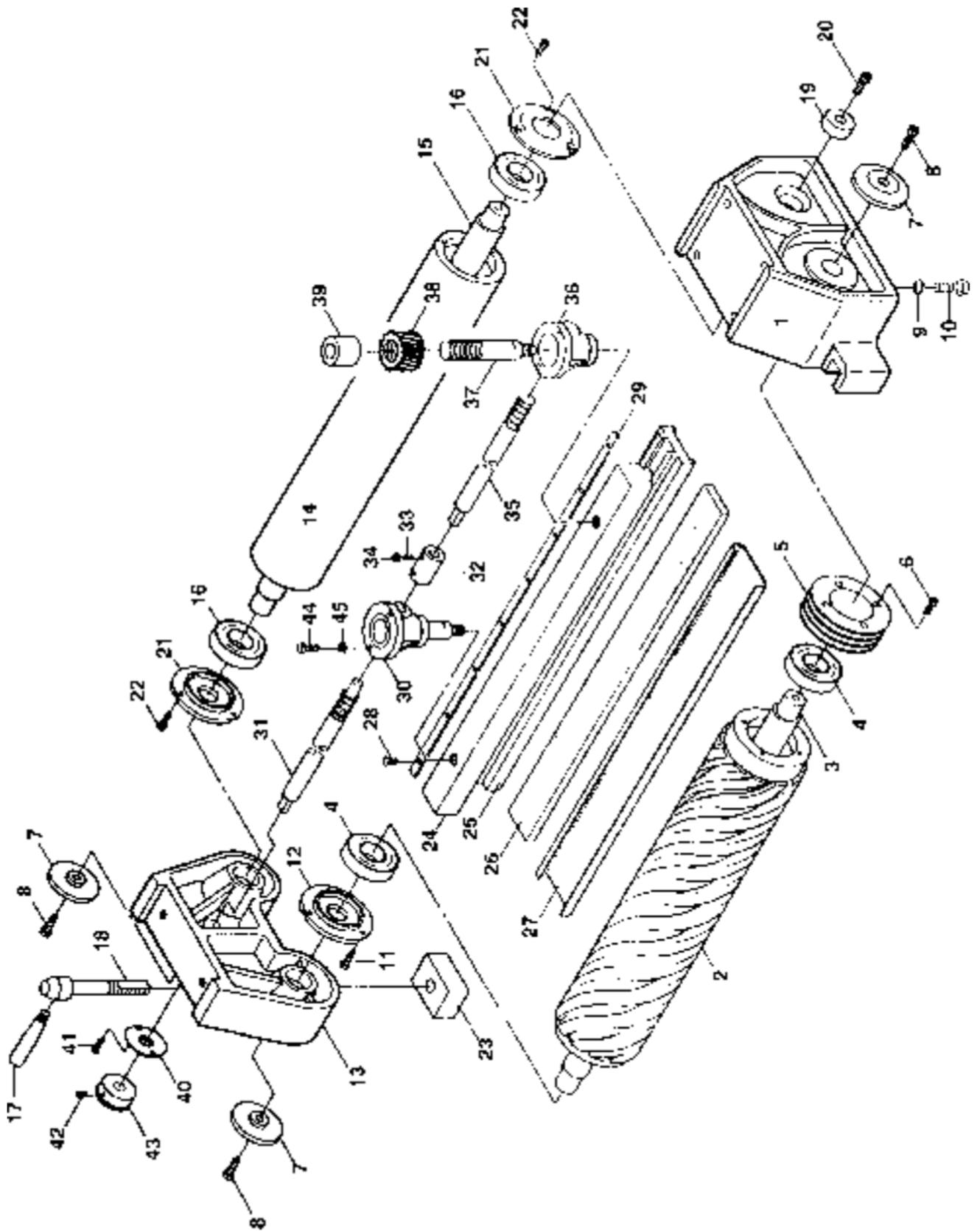
### NO. PART NO. DESCRIPTION

1	6294407	HOUSING, BEARING
2	6294608	ROLLER, RUBBER
3	6294609	SHAFT, RUBBER ROLLER
4	6294410	BEARING, 6206
5	6294411	PULLEY
6	6294412	SCREW, HEX. SOC. HD., 3/8"
7	6294413	WASHER, ROLLER SHAFT LOCK
8	6294414	SCREW, HEX. SOC. HD., 3/8"
9	6294263	WASHER, SPRING, 1/2"
10	6294415	SCREW, HEX. SOC. HD., 1/2"
11	6294416	SCREW, HEX. SOC. HD., 1/4"
12	6294417	CAP, BEARING
13	6294418	HOUSING, BEARING
14	6294610	ROLLER, STEEL
15	6294611	SHAFT, STEEL ROLLER
16	6294421	BEARING, 6206-2RS
17	6294422	HANDLE
18	6294423	SCREW, FLAT HEAD
19	6294424	WASHER, ROLLER SHAFT LOCK
20	6294425	SCREW, HEX. SOC. HD., 3/8"
21	6294426	CAP, BEARING
22	6294427	HANDLE
23	6294428	PAD, BEARING BRACKET

### NO. PART NO. DESCRIPTION

24	6294612	BRACKET, GRAPHITE (MALE)
25	6294613	BRACKET, GRAPHITE (FEMALE)
26	6294614	FELT
27	6294615	GRAPHITE
28	6294433	SCREW, PHILLIP'S, 3/16"
29	6294616	PLATE, GRAPHITE PRESSURE
30	6294435	BOX, GEAR (LEFT)
31	6294617	WORM (FRONT)
32	6294618	COLLAR, WORM CONNECTION
33	6294438	SCREW, HEADLESS, 1/4"
34	6294335	NUT, 1/4"
35	6294619	WORM (REAR)
36	6294440	BOX, GEAR (RIGHT)
37	6294441	SHAFT, SCREW
38	6294442	GEAR, WORM
39	6294443	BUSHING
40	6294444	PLATE, GRADUATED COLLAR
41	6294445	SCREW, PHILLIP'S, 5/32"
42	6294446	SCREW, HEADLESS, 1/4"
43	6294447	COLLAR, GRADUATED
44	6294448	SCREW, 5/16"
45	6294299	WASHER, PLAIN, 5/16"

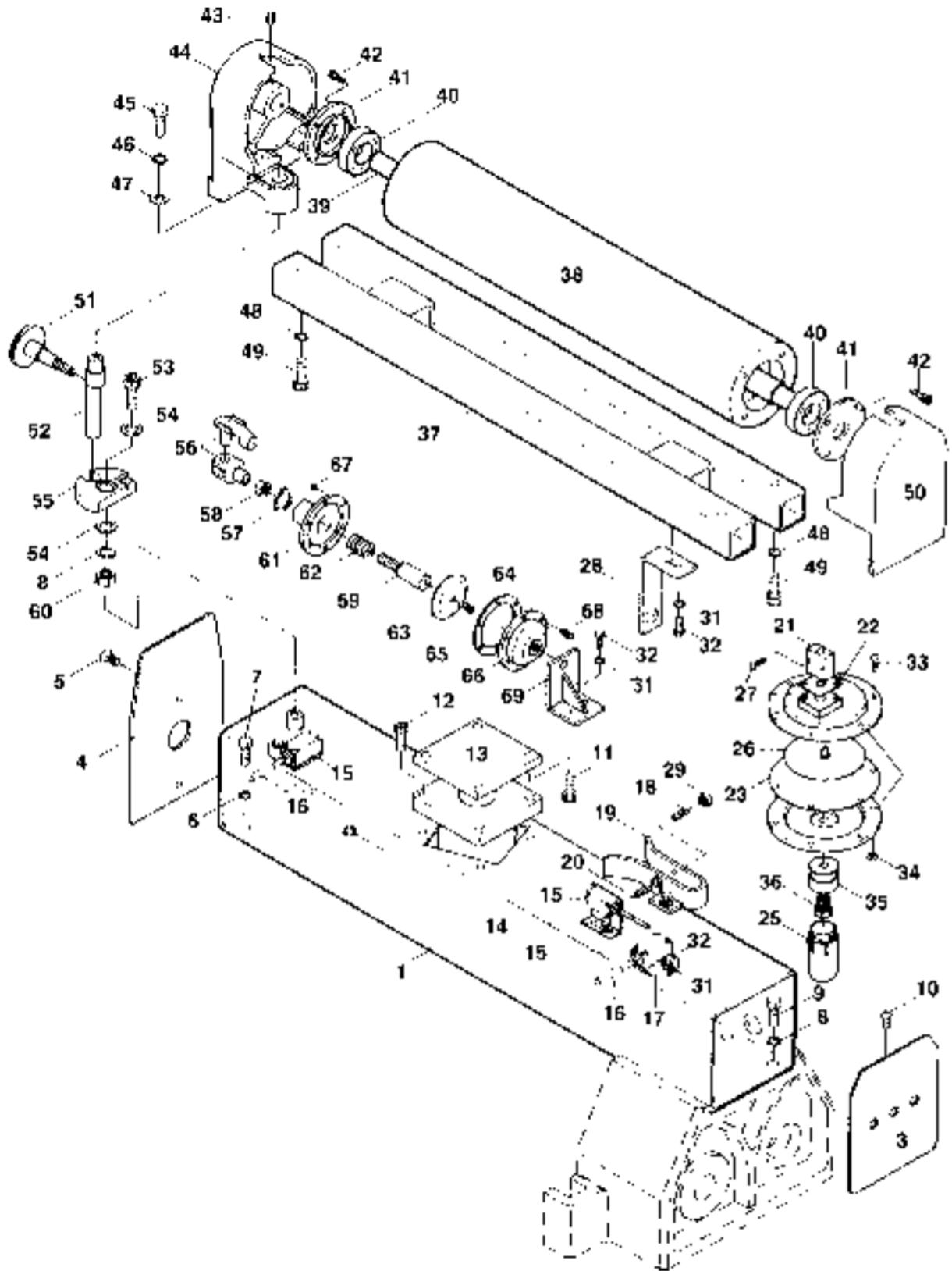
EXPLODED VIEW: Contact Drum (RB-51)



## PARTS LIST: Upper Roller/Frame Assembly (RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294620	FRAME, SQUARE	37	6294622	BRACKET, UPPER ROLLER
3	6294668	SEAL, SQUARE FRAME (R)	38	6294623	ROLLER, UPPER
4	6294669	SEAL, SQUARE FRAME (L)	39	6294624	SHAFT, UPPER ROLLER
5	6294452	SCREW, FLAT HEAD, 1/4"	40	6294410	BEARING, 6206
6	6294270	WASHER, SPRING, 3/8"	41	6294483	CAP, BEARING
7	6294453	SCREW, 3/8"	42	6294484	SCREW, HEX. SOC. HD., 1/4"
8	6294263	WASHER, SPRING, 1/2"	43	6294485	SCREW, HEADLESS, 5/16"
9	6294454	SCREW, 1/2"	44	6294486	BRACKET, UPPER ROLLER (L)
10	6294455	SCREW, PHILLIP'S, 1/4"	45	6294487	SCREW, 5/16"
11	6294456	SCREW, HEX. SOC. HD., 5/16"	46	6294300	WASHER, SPRING, 5/16"
12	6294457	SCREW, HEX. SOC. HD., 5/16"	47	6294299	WASHER, PLAIN, 5/16"
13	6294458	CYLINDER, AIR	48	6294270	WASHER, SPRING, 3/8"
14	6294459	HOLDER, LIMIT SWITCH (Type L)	49	6294488	SCREW, HEX. SOC. HD., 3/8"
15	6294460	SWITCH, LIMIT	50	6294489	BRACKET, UPPER ROLLER (R)
16	6294461	TUBE, LIMIT SWITCH	51	6294490	SCREW, TRIMMING
17	6294462	HOLDER, LIMIT SWITCH	52	6294491	ROD, ECCENTRIC
18	6294463	NOZZLE, AIR SENSOR (female)	53	6294492	SCREW, HEX. SOC. HD., 1/2"
19	6294464	BRACKET, AIR CYLINDER	54	6294265	WASHER, PLAIN, 1/2"
20	6294465	NOZZLE, AIR SENSOR (male)	55	6294493	PIECE, ECCENTRIC
21	6294466	VALVE THROTTLE	56	6294494	FORK, UNIVERSAL JOINT
22	6294467	BASE, THROTTLE VALVE	57	6294477	NUT, 3/16"
23	6294468	PLATE	58	6294495	NUT, M10
24	6294469	DISC, ALUMINUM	59	6294496	SHAFT, AIR CYLINDER
25	6294470	CAP, OIL	60	6294261	NUT, 1/2"
26	6294471	PLATE, ALUMINUM	61	6294497	COVER, BOTTOM
27	6294472	SCREW, M4	62	6294498	SPRING
28	6294621	PLATE, SANDING BELT POWER OFF	63	6294499	PLATE, ALUMINUM
29	6294474	NUT, 3/8" (fine thread)	64	6294500	SCREW, M6
31	6294475	SCREW, 5/16"	65	6294501	PLATE
32	6294300	WASHER, SPRING, 5/16"	66	6294502	COVER, TOP
33	6294476	SCREW, 3/16"	67	6294477	NUT, 3/16"
34	6294477	NUT, 3/16"	68	6294476	SCREW, 3/16"
35	6294478	CONNECTOR, OIL CAP	69	6294625	BASE, AIR CYLINDER FIRING
36	6294479	SHAFT, OIL CAP	70	6294653	SWITCH, LIMIT

**EXPLODED VIEW: Upper Roller/Frame Assembly (RB-51)**



## PARTS LIST: Control Box (RB-51)

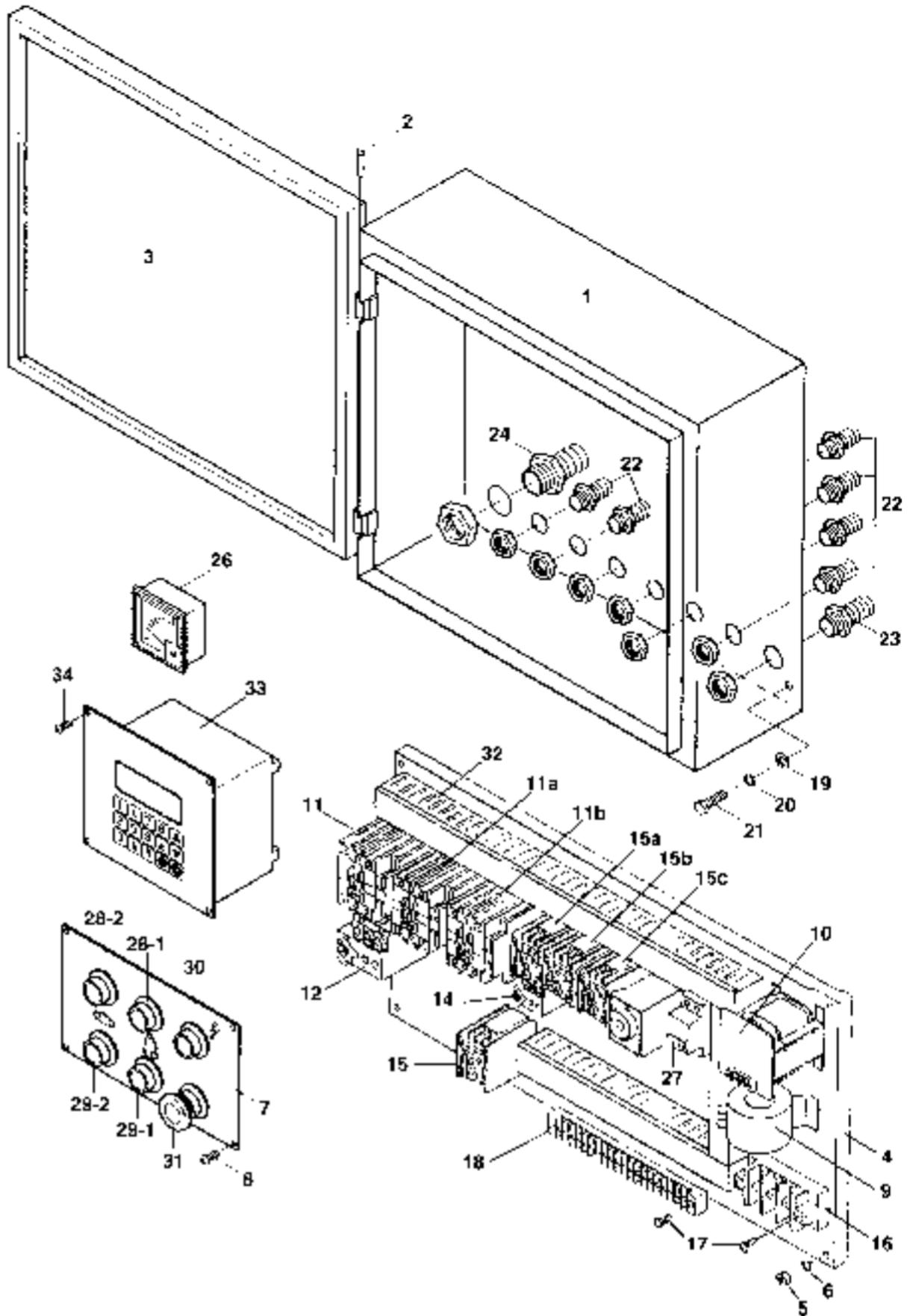
### NO. PART NO. DESCRIPTION

1	6294626	BOX, ELECTRICAL CONTROL
2	6294627	HINGE
3	6294628	BOX, ELECTRICAL CONTROL DOOR
4	6294518	PLATE, BASE
5	6294335	NUT, 1/4"
6	6294328	WASHER, SPRING, 1/4"
7	6294519	PANEL, CONTROL
8	6294520	SCREW, PHILLIP'S, M4
9	6294629	DEVICE, PROPORTIONAL CURRENT
10	6294630	TRANSFORMER
11	6294631	CONTACTOR, MAGNETIC
11a	6294644	CONTACTOR, MAGNETIC
11b	6294645	CONTACTOR, MAGNETIC
12	6294632	RELAY, OVERLOAD
13	6294525	FUSE
14	6294526	RELAY, OVERLOAD
15	6294635	CONTACTOR, MAGNETIC
15a	6294646	CONTACTOR, MAGNETIC

### NO. PART NO. DESCRIPTION

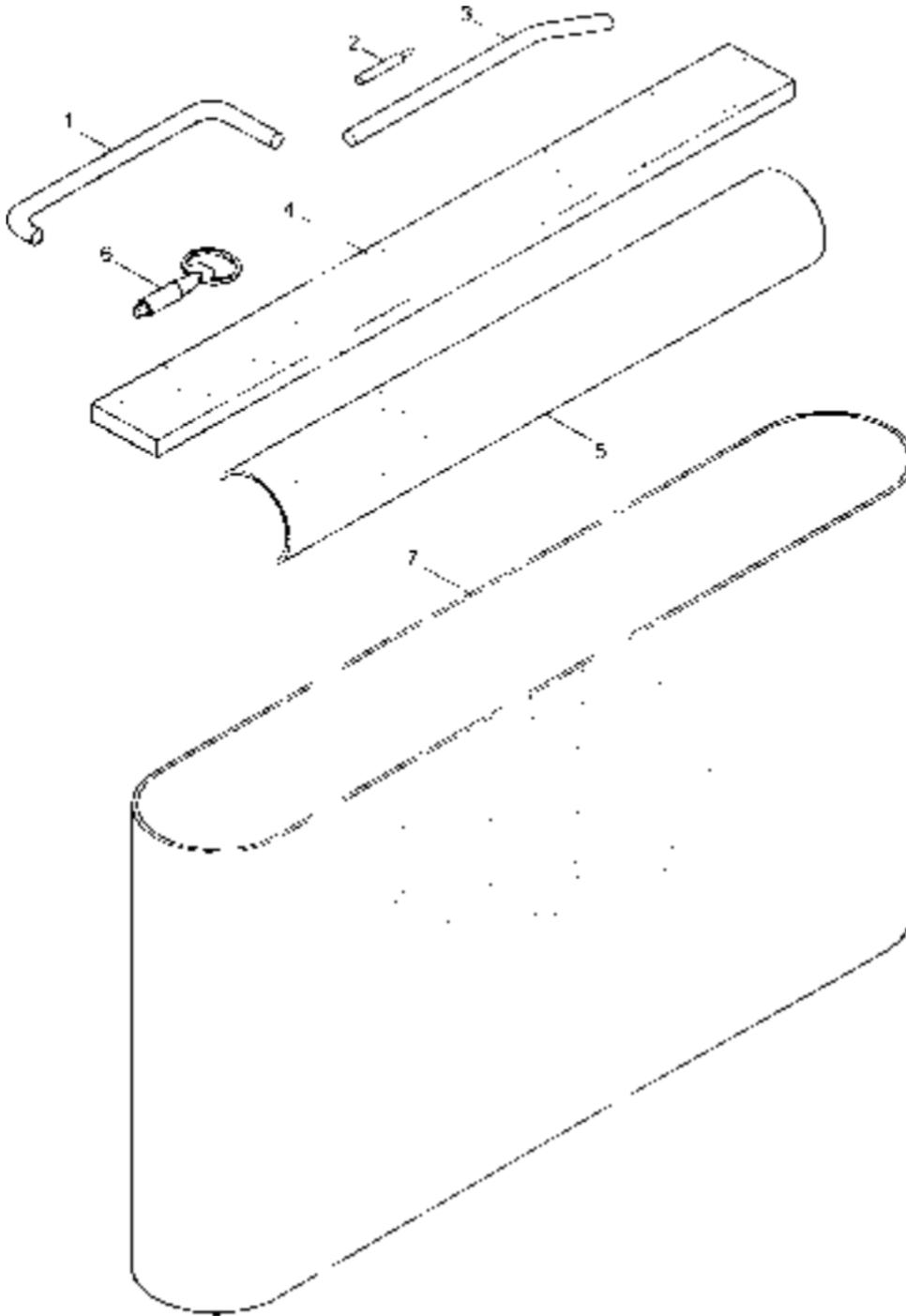
15b	6294647	CONTACTOR, MAGNETIC
16	6294636	TERMINAL, POWER WIRE
17	6294529	SCREW, PHILLIP'S, 3/16"
18	6294637	PLATE, TERMINAL
19	6294299	WASHER, PLAIN, 5/16"
20	6294300	WASHER, SPRING, 5/16"
21	6294531	SCREW, 5/16"
22	6294532	CONNECTOR, PU, 1/2"
23	6294533	CONNECTOR, PU, 3/4"
24	6294534	CONNECTOR, CABLE, 1"
25	6294535	METER, AMP
27	6294536	SWITCH, CAM
28	6294537	SWITCH, START
29	6294538	SWITCH, STOP
30	6294539	LIGHT, POWER INDICATION
31	6294540	SWITCH, EMERGENCY STOP
32	6294643	COLUMN, WIRE
33	6294542	COMPUTER
34	6294543	SCREW, M4

**EXPLODED VIEW: Control Box (RB-51)**



## PARTS LIST: Sanding Belt (RB-51)

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
1	6294251	HOLDER, GRAPHITE	6294581	6294581	BELT, SANDING 51" X 60" (60 GRIT)
2	6294252	TUBE, LIMIT SWITCH	6294582	6294582	BELT, SANDING 51" X 60" (80 GRIT)
3	6294253	ROD, PLUG ADJUSTMENT	6294583	6294583	BELT, SANDING 51" X 60" (120 GRIT)
4	6294584	FELT			
5	6294585	GRAPHITE			
6	6294256	HANDLE, DOOR			
7	6294578	BELT, SANDING 51" x 60" (100 GRIT)			



## OPTIONAL ACCESSORIES

### RB-43

6294257	100 GRIT SANDING BELT, 43" X 60".
6294313	60 GRIT SANDING BELT, 43" X 60".
6294579	80 GRIT SANDING BELT, 43" X 60".
6294580	120 GRIT SANDING BELT, 43" X 60".

### RB-51

6294578	100 GRIT SANDING BELT, 51" X 60".
6294581	60 GRIT SANDING BELT, 51" X 60".
6294582	80 GRIT SANDING BELT, 51" X 60".
6294583	120 GRIT SANDING BELT, 51" X 60".



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