

# **POWERMATIC®**

## **Operating Instructions and Parts Manual Wide Belt Sanders**

**Models WB-25, WB-37, WB-43**



*model WB-37 shown*

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# 1.0 Warranty and Service

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

## Warranty Period

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

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

## Who is Covered

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

## What is Covered

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

## Warranty Limitations

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

## How to Get Technical Support

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

## More Information

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

## How State Law Applies

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

## Limitations on This Warranty

POWERMATIC LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

POWERMATIC SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

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

## Product Listing with Warranty Period

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

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

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### 3.0 Safety warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This sander is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a sander, do not use until proper training and knowledge have been obtained.
5. Do not use this sander for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this sander. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this sander, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves. Steel toed shoes are recommended because heavy parts can fall off the conveyor table onto feet.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
10. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
11. Make certain the machine is properly grounded.
12. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
13. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
14. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
15. Provide for adequate space surrounding work area and non-glare, overhead lighting.
16. Keep the floor around the machine clean and free of scrap material, oil and grease.
17. Keep visitors a safe distance from the work area. **Keep children away.**
18. Make your workshop child proof with padlocks, master switches or by removing starter keys.
19. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
20. Remove loose items and unnecessary work pieces from the area before starting the machine.
21. Maintain a balanced stance at all times so that you do not fall or lean against the conveyor belt or other moving parts. Do not overreach or use excessive force to perform any machine operation.
22. Keep hands clear while feeding workpieces onto the conveyor table. The workpiece will be forced down as it begins to feed into the machine, causing a pinching action between workpiece and conveyor table.
23. Stand to one side of the conveyor table and do not let anyone else stand in line with the table while a workpiece is being fed through the machine.


24. Do not attempt to sand stock shorter than 12 inches long without butting a board of equal thickness behind it to help it through the machine. Do not sand stock less than 1/8" thick.
25. Never reach into a running machine. Turn off and disconnect from power source before attempting to retrieve parts from within the machine.
26. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
27. Use recommended accessories; improper accessories may be hazardous.
28. Turn off the machine and disconnect from power before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until all parts come to a complete stop.


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

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

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

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

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

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

**- - SAVE THESE INSTRUCTIONS - -**

## 4.0 Introduction

This manual is provided by Powermatic covering the safe operation and maintenance procedures for a Powermatic WB Series Wide Belt Sander. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide consistent, long-term operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or Powermatic. Powermatic can also be reached at our web site: [www.powermatic.com](http://www.powermatic.com).

## 5.0 Specifications

Model Number.....	WB-25.....	WB-37.....	WB-43.....
Stock Number.....	1790825.....	1790837.....	1790843.....
Working Width (in.).....	25.....	37.....	43.....
Maximum Stock Thickness (in.).....	6.....	6.....	6.....
Minimum Stock Thickness (in.).....	1/8.....	1/8.....	1/8.....
Minimum Board Length (in.).....	12.....	12.....	12.....
Table Height from Floor (in.).....	31-3/8 to 37-3/8.....	31-3/8 to 37-3/8.....	31-3/8 to 37-3/8.....
Main Drive Motor.....	15HP, 3Ph, 230/460V*.....	20HP, 3Ph, 230/460V*.....	25HP, 3Ph, 230/460V*.....
Power Feed Motor.....	1HP, 3Ph.....	1HP, 3Ph.....	2HP, 3Ph.....
Table Hoist Motor.....	1/4HP, 3Ph.....	1/4HP, 3Ph.....	1/4HP, 3Ph.....
Sanding Belt Size (in.).....	25x75.....	37x75.....	43x75.....
Dust Ports.....	two @ 5" diameter.....	three @ 5" diameter.....	three @ 5" diameter.....
Dust Collection CFM Required.....	800.....	1600.....	1900.....
Required Air Pressure (PSI).....	75 to 80.....	75 to 80.....	75 to 80.....
Overall Dimensions (LxWxH/in.).....	53 x 45 x 72.....	53 x 58 x 72.....	53 x 65 x 72.....
Gross Weight (lbs.).....	1,760.....	2,090.....	2,530.....
Net Weight (lbs.).....	1,650.....	1,970.....	2,400.....

\* **NOTE:** The sander is pre-wired 230V. Conversion to 460V requires the purchase and installation of two overload relays. See parts list for stock numbers.

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

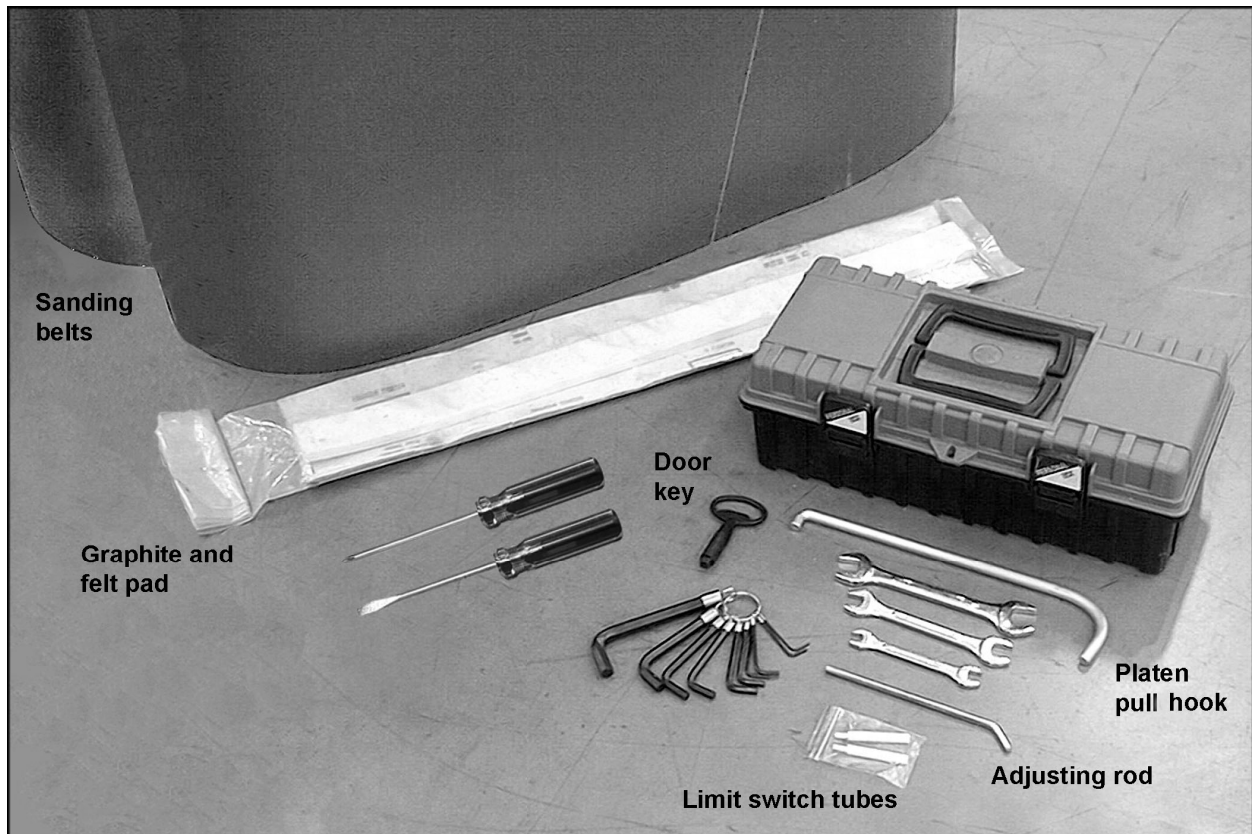
## 6.0 Unpacking

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the sander is installed and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read this instruction manual thoroughly for assembly, maintenance and safety instructions.

## 6.1 Contents of Shipping Container

- 1 Sander
- 2 Sanding belts (100 and 180 grit)
- 1 Felt pad
- 1 Graphite strip
- 1 Tool box containing:
  - 1 Door key
  - 1 Platen pull hook
  - 1 Adjusting rod
  - 2 Limit switch tubes
  - 1 Flat blade screwdriver
  - 1 Cross point screwdriver
  - 3 Open-end wrenches, 8-10, 12-14, 17-19
  - 1 Set of hex wrenches
- 1 Owner's manual
- 1 Warranty card



### **⚠ WARNING**

Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.



## 7.0 Assembly

The sander should be placed on a level, sturdy floor, preferably concrete, with plenty of space surrounding it for on- and off-loading of stock, and general maintenance work.

Open the two lower side panels and use the leveling screws inside the cabinet (Figure 1) to level the sander. The machine can also be secured to the floor with high quality lag screws (not provided) through the four mounting holes inside the cabinet.

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 or lacquer thinner, as these have a low flash point and can be a fire hazard, as well as damage the paint finish. Do not get solvents on rubber or plastic areas of the machine.



Figure 1

### 7.1 Air Supply Connection

The sander must be connected to an air supply unit. The recommended working pressure is 75 to 80 PSI.

The air connection is on the Filter/Regulator unit located at the back of the sander (Figure 2). Attach the incoming air supply to the connector with a flexible hose.

The working pressure can be adjusted with the pressure regulator. Lift up on the adjustment knob and rotate it clockwise to increase air pressure, counterclockwise to decrease air pressure. When the desired pressure is shown on the pressure gauge, push down the adjustment knob to lock the setting.

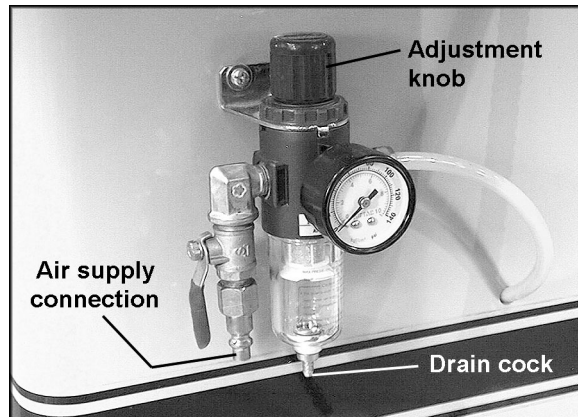


Figure 2

### 7.2 Dust Collection

Connect a dust collection system (not provided) to the dust ports atop the sander cabinet with 5" flexible hose and hose clamps. Make sure your dust collector has sufficient capacity for this machine.

Always turn on the dust collector prior to operating the sander.

### 7.3 Installing/Replacing Sanding Belt

1. Machine should be disconnected from power source.
2. Turn the air valve switch (A, Figure 3) to Off position.
3. Remove the lock screw (B, Figure 3) by turning it counterclockwise and lifting up.
4. Remove the spacer block (C, Figure 3).
5. Inspect the sanding belt for defects such as chipped or torn edges. Do not use a belt if it is damaged.

**CAUTION** Make sure the direction of the arrows on the inside of the sanding belt matches the rotation of the machine. See Figure 4.

6. Install the new belt by placing it first over the upper roller, then over the free and contact rollers, and slide the belt all the way onto the rollers.
7. Center the belt while avoiding contact with the limit switch fingers that are located on each side of the belt.
8. Re-install the spacer block (C, Figure 3) and lock screw (B, Figure 3) and tighten the lock screw by turning clockwise.
9. Turn the air valve switch (A, Figure 3) to ON to tension the sanding belt.
10. Make sure there is clearance between sanding belt edges and the limit switch fingers on either side. If there is not, make the appropriate corrections (with the air valve turned OFF).

NOTE: The sander will not start if a limit switch is engaged.

11. Before doing any sanding, the sanding belt should be tested for proper tracking and oscillation. See the appropriate sections in this manual.

## 8.0 Electrical

### 8.1 Grounding Instructions

**WARNING** Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded while in use to help protect the operator from electrical shock and possible fatal injury.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for

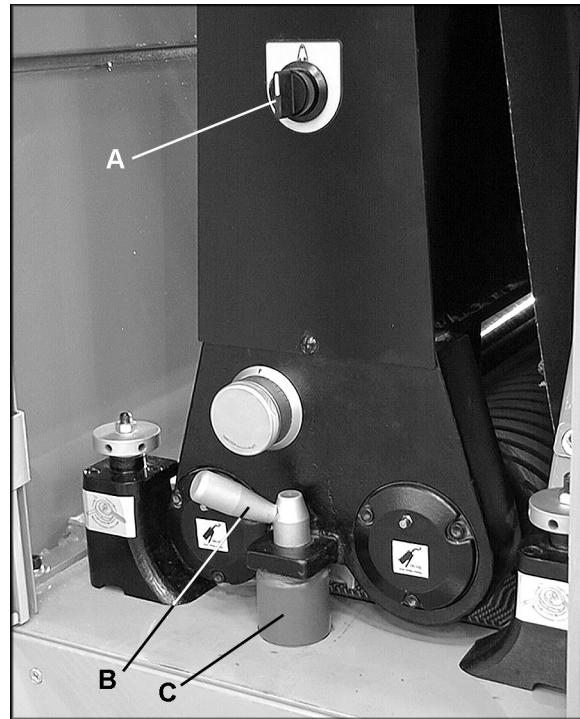


Figure 3

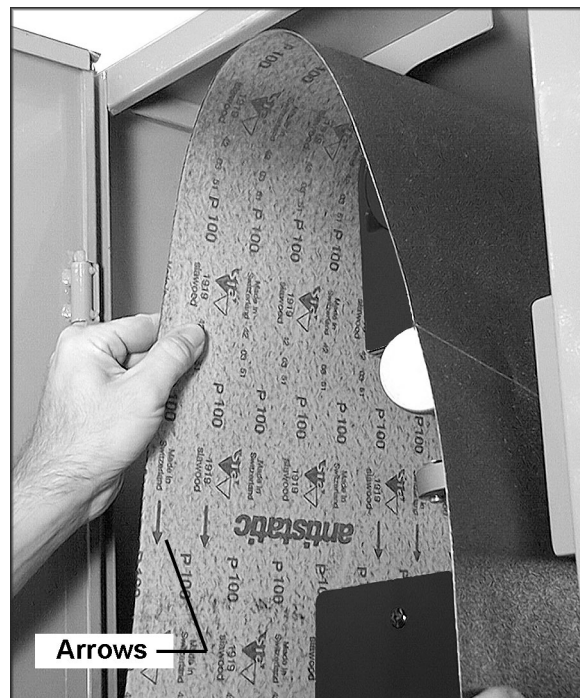


Figure 4

electric current to reduce the risk of electric shock to the operator.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

The sander should be connected to a dedicated circuit with a *minimum* 100 Amp service. The sander has been factory wired to run at 230 volt operation. It can be converted to 460 volt if desired. See the appropriate sections below.

## 8.2 230 Volt Operation

The sander may be fitted with a 230 volt plug, or may be “hard-wired” directly to an electrical control panel. **If hard-wired to a panel, make sure a disconnect is available for the operator.**

Refer to the diagram inside the sander’s electrical box for clarification of electrical connections. These diagrams are also shown in *sections 17.0 and 18.0* of this manual.

1. Make sure the machine’s plug is disconnected from the power source. If it will be hard-wired, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the sander will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired. Always follow proper Lock Out/Tag Out procedures when performing any wiring on this machine.
2. Make sure the power source corresponds to the specifications of the sander as recorded on the sander’s motor plate.
3. Open the sander’s electrical box and connect the three incoming power leads to the terminals marked R,S,T. See Figure 5. Connect the green ground wire to grounding terminal E.
4. Connect the machine to power (or install the fuses or reset the breaker at the power source). The power light (see Figure 19) should now be lit.

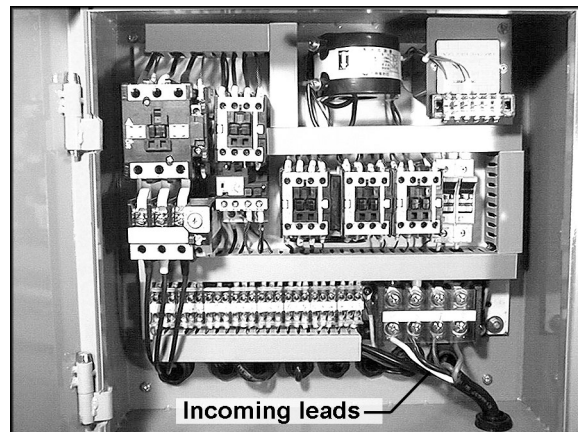


Figure 5  
(Model WB-25 shown)

5. Press the Up ▲ or Down ▼ button on the keypad (see page 18 for detailed keypad instructions). Make sure the conveyor table moves in the same direction as indicated on the button.
6. If the conveyor table moves in the wrong direction, turn off the machine and **disconnect from power**. Switch any two of the three incoming power leads at R,S,T.
7. Re-connect power to the sander.

### 8.3 460 Volt Conversion

To convert the sander to 460V:

1. Disconnect sander from power source.
2. In the electrical cabinet, switch the #1 wire on the transformer from the 220V to the 440V terminal. See Figure 6. (Refer to the wiring diagram on the inside cover of the electrical box for clarification.)
3. Replace two 230V overload relays with two 460V overload relays (not included; see parts list for stock numbers).
4. Change the wiring at the main motor, the conveyor table motor, and the table elevating motor, according to the wiring diagrams inside their respective junction boxes.
5. If using a plug, install a UL/CSA-listed plug appropriate for 460V operation.

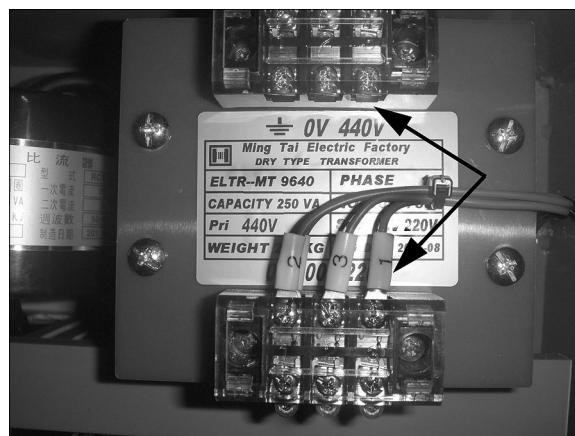


Figure 6

### 8.4 Extension cords

The use of an extension cord for this sander is discouraged, because of the machine's high amperage draw. If an extension cord becomes necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

## 9.0 Adjustments

### 9.1 Sanding Belt Tracking and Oscillation

The sanding belt should oscillate left and right without a tendency to slide off the rollers. If the sanding belt runs outside of the normal track, it will contact a limit switch and the machine will stop automatically.

The oscillation settings have been made at the factory, but should be checked by the operator. NOTE: When a new sanding belt is installed, there may be a slight length tolerance between the right and left sides of the sanding belt which

may result in incorrect tracking. If this occurs, the oscillation timing can be set to compensate.

1. Adjust oscillation while the machine is running. Turn on the air valve switch and press the sanding belt start button (see Figure 19).
2. The upper roller will pivot left and right. The duration of the sanding belt's oscillation to the right side and to the left should be equal. For example, if the oscillation time to the right is one second, then the oscillation time to the left should also be one second.
3. If the oscillation time to the right side is one second, but the oscillation time to the left side is longer, then loosen the tracking adjustment lever (rotate it counterclockwise) and move it to the left until proper timing is achieved. See Figure 7.
4. When finished, tighten the tracking adjustment lever.
5. If the oscillation time to the left side is one 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 timing is achieved. Tighten the tracking adjustment lever.

## 9.2 Oscillation Air Flow

For correct sanding belt oscillation, there must be adequate air flow through the holes of the oscillation bracket (Figure 8). When the sanding belt is operating, its edge will pass over the holes in the oscillation bracket. The blocked air flow will cause a sensor to activate the tracking cylinder, which pivots the upper roller and shifts the belt back out, causing it to leave the air flow. This process will continually repeat itself.

If there is inadequate air flow, the sanding belt will track too far and contact a limit switch. Adjust the air flow using the air flow control knob (Figure 9). Loosen the jam nut and rotate the knob clockwise to decrease air flow, counterclockwise to increase air flow. Tighten the jam nut to lock the setting.

Frequently inspect the holes in the oscillation bracket – make sure they are clean and clear of obstructions.

## 9.3 Oscillation Speed

To adjust the speed of the oscillation, loosen the jam nut on the speed control knob (Figure 9), then turn knob clockwise to decrease oscillation speed or counterclockwise to increase oscillation speed. When finished, tighten jam nut.

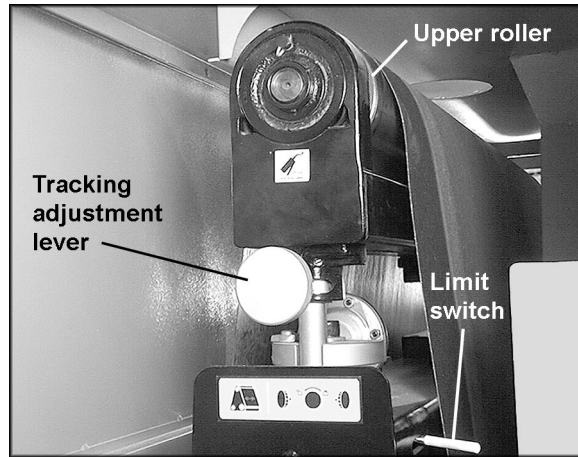


Figure 7

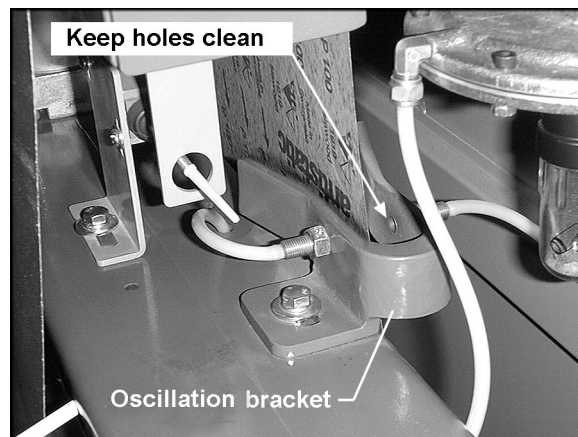


Figure 8

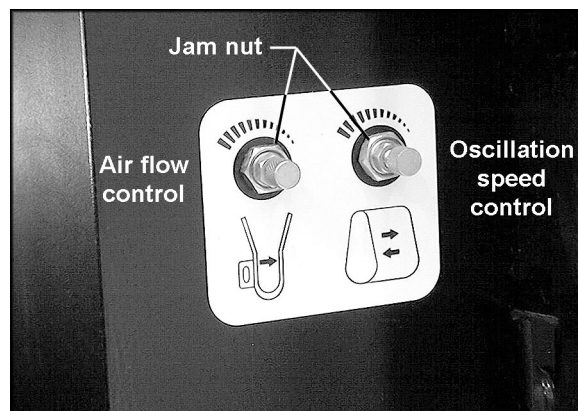


Figure 9

## 9.4 Platen Position

The sander has a removable platen with a graphite strip and a felt pad to reduce friction against the sanding belt. Positioning of the platen depends upon the type of wood being used.

The height of the platen is set at the factory, but can be re-adjusted by rotating the platen adjustment knob (Figure 10). Each mark on the scale indicates a raising or lowering measurement of 0.005mm. One complete rotation of the scale moves the platen 0.2mm or approximately 8/1000 of an inch.

Theoretically, optimum finish sanding results are obtained when the bottom of the platen extends slightly below the bottom of the conveyor rollers. The main consideration in adjusting the platen is to make sure that both ends are symmetrical and level.

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

## 9.5 Replacing Graphite and Felt Pad

To replace the graphite strip and felt pad, proceed as follows:

1. Remove the lock screw (B, Figure 3) and the spacer block (C, Figure 3).
2. Place the platen pull hook into the hole on the end of the platen and pull out the lower portion of the platen assembly, as shown in Figure 10. NOTE: The platen is tightly fitted and will require a firm pull with the pull hook.
3. Note carefully how the current graphite and felt strip are mounted. Replace them with the new ones.
4. Re-install the platen by aligning the end of it with the dovetail track on the fixed portion of the platen assembly, and push it all the way in using the pull hook.
5. Replace the spacer block and lock screw.

## 9.6 V-Belt Tension and Replacement

For the first few days of operation a new belt should be checked occasionally and adjusted for tension as necessary until the belt is properly "worn in."

The v-belts on the main motor and table elevating motor should be checked for proper tension.

Tighten any of the v-belts as follows:

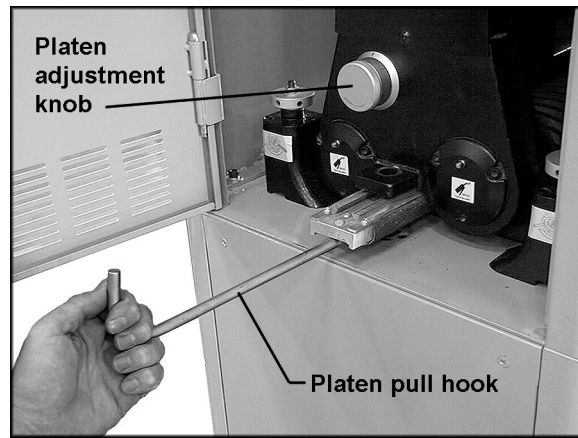


Figure 10

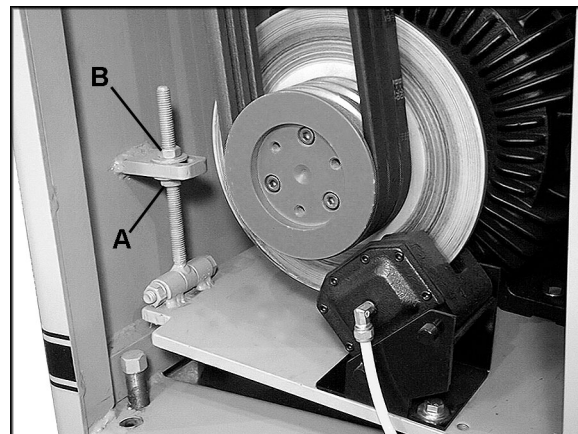


Figure 11



Figure 12

1. Disconnect sander from power source.
2. Loosen the lower hex nut (A, Figure 11/12) on the motor base.
3. Tighten the top hex nut (B, Figure 11/12) to lower the motor plate until proper tension is achieved.
4. When the belt is properly tensioned, you should be able to push in the belt approximately 3/4" at a point midway between the pulleys using moderate finger pressure.
5. Re-tighten the bottom hex nut (B, Figure 11/12) against the bottom of the motor plate.

If installing a new v-belt, use the hex nuts to raise the motor plate enough to remove the old belt and mount the new one.

NOTE: When replacing v-belts on the main motor, replace the entire set of three simultaneously.

### 9.7 Conveyor Belt Tension

Check the tension of the conveyor belt on the infeed and outfeed rollers – the conveyor belt should be tight enough that you cannot shift it with your hands. If the conveyor belt needs tightening, proceed as follows.

1. Disconnect sander from power source.
2. Rotate the adjustment screws (the left one is shown in Figure 13) as needed with a 19mm wrench. Rotate clockwise to increase tension, counter-clockwise to decrease tension. (NOTE: Removal of the emergency stop cover is not necessary for tensioning.)

NOTE: Do not over-tighten the screws as this will hasten wear of the conveyor belt.

### 9.8 Conveyor Belt Tracking

The conveyor belt should remain centered upon the rollers during operation. If it approaches to either the left or right side, adjustment is necessary.

First check that the conveyor belt tension is correct. If the tension needs adjustment, do this **first** before you adjust the tracking (see "Conveyor Belt Tension"). Then proceed as follows.

Conveyor belt tracking should be adjusted while the conveyor belt is running. Make adjustments in increments and allow the conveyor belt time to respond to each change.

**⚠WARNING** Keep hands away from the moving conveyor belt.

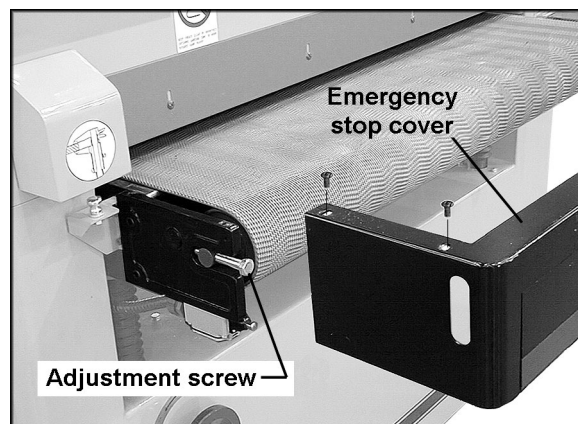


Figure 13

1. Remove the four screws securing the emergency stop cover and remove the cover. See Figure 13. This will allow better inspection of the belt's movement on the roller.
2. Turn on the conveyor belt.
3. Adjust tracking using the same adjustment screws that were used for tensioning in Figure 13.
4. If the conveyor belt is moving to the right side, turn the right screw clockwise. This will return the tracking toward the left.
5. If the conveyor belt is moving to the left side, turn the left screw clockwise. This will return the tracking toward the right.
6. A positioning wheel (Figure 14) has been provided on the right and left sides of the conveyor belt to limit the belt tracking. When adjusting the tracking, the conveyor belt should be moved until its edge just touches the positioning wheels.
7. Allow the sander to run for several minutes while observing the conveyor belt tracking and readjust if necessary.
8. Turn off the conveyor belt and re-install emergency stop cover.

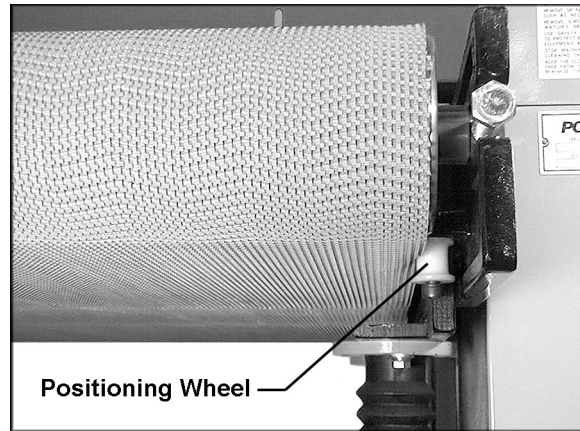


Figure 14

## 9.9 Feed Rate

The feed rate is infinitely variable within the provided range, in order to meet the sanding requirements of a wide variety of materials. Selecting a proper feed rate is largely a matter of experience. In general, soft woods require a higher feed rate, while hard woods require a lower feed rate.

**CAUTION** Change the feed rate only while the conveyor belt is running. Failure to comply may cause damage to the gearbox.

Adjust the feed rate with the selector knob on the worm gear reducer (Figure 15). Turn the selector knob clockwise to decrease the conveyor belt speed, counterclockwise to increase it.

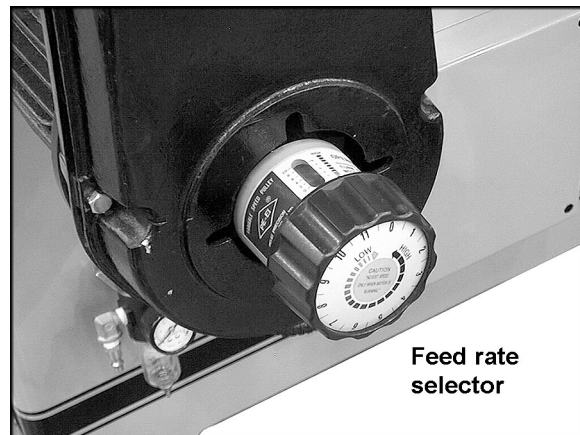


Figure 15

## 9.10 Pressure Bar Adjustment

The front and rear sets of pressure bars have been factory adjusted. This setting should, however, be checked before operating the sander.

The pressure bars should be parallel to the conveyor table with equal pressure on each end, and are set slightly below the level of the sanding belt.



If the ends of the workpiece are sniped, the front pressure bars are too low. The pressure should be enough to firmly hold the workpiece against the conveyor, but not so hard that the ends of the workpiece spring up after clearing the bar.

Also, if the ends of the bars are not exerting equal pressure, the workpiece will tend to move sideways on the conveyor during sanding.

To raise or lower each set of pressure bars:

1. Disconnect sander from power source.
2. The sanding belt should be installed, and the air valve turned ON.
3. Place a sanded panel with even thickness on the conveyor table and under the pressure bars. The panel should be long enough to contact both front and back sets of pressure bars.
4. Raise the table manually using the handwheel (Figure 16) until the panel contacts the pressure bars.
5. Make sure the pressure at the right and left side of pressure bars is even.
6. If adjustment is needed, release the lock nut (A, Figure 17) with a 14mm wrench.
7. Insert the adjusting tool (B, Figure 17) into a hole in the adjusting knob. Rotate the adjusting knob clockwise to raise that side of the pressure bar, counterclockwise to lower it.
8. When finished, re-tighten lock nut (A, Figure 17).

### 9.11 Table Parallelism

Parallelism of the conveyor table to the contact roller has been factory-set and should not require further adjustment. However, as the machine receives extended use, this setting should be checked.

Inspect parallelism by one of two methods:

1. Use a sanded board of equal thickness. Pass the board several times through the machine at a sanding depth of approximately  $1/64$ " , then measure the thickness of the board at different points along the edges with calipers. If excessive variation occurs, the table needs adjusting.

OR, remove the sanding belt and place a gauge of some kind at one side of the conveyor table and below the contact roller. Raise the table manually using the handwheel until the gauge just touches the contact roller. Repeat at the other side of the table and compare the gauge readings.

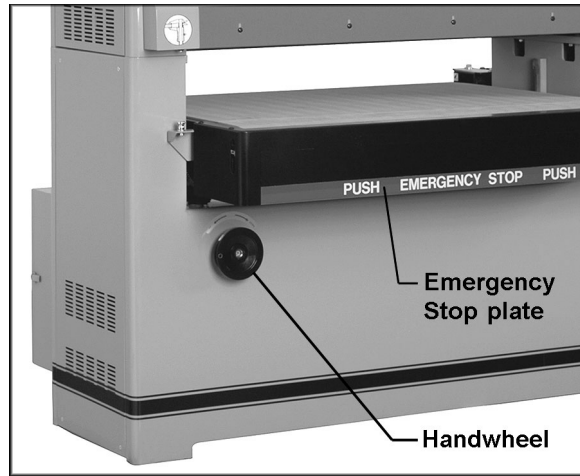


Figure 16

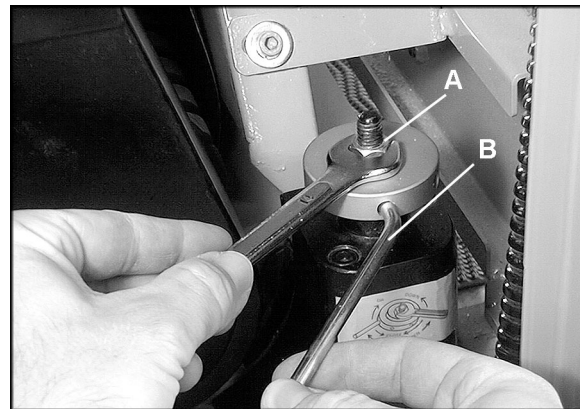


Figure 17

If the readings are different, the table needs adjusting.

2. Disconnect sander from power source.
3. At the area of the table that needs adjustment, loosen the two screws (A, Figure 18) on the bracket of the elevation screw, and rotate the bracket as needed. (The elevation screw is protected by the dust guard bellow.) Turn the elevating screw clockwise to lower the table in that area, counterclockwise to raise the table (see Figure 18).

**IMPORTANT:** Turn both elevating screws on one side of the table an equal amount, in order to maintain front-to-back parallelism with the rollers.

4. Tighten screws (A, Figure 18).
5. Re-connect sander to power, and make further test runs. Make additional adjustments as needed, **with the machine disconnected from power.**

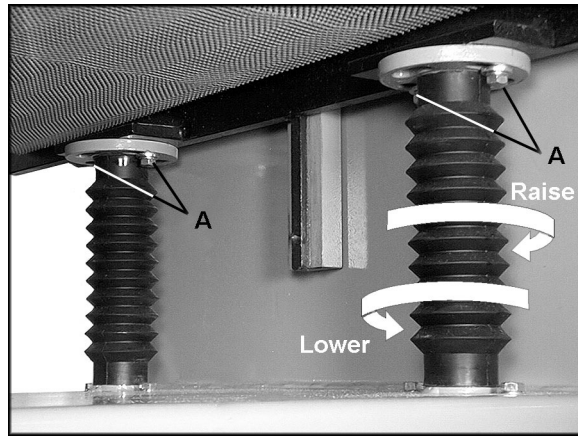


Figure 18

## 10.0 Operating Controls

Figure 19 shows the control panel functions.

The emergency stop button shuts down all machine operations. The button remains engaged after being pushed. To disengage, rotate the ring until the emergency stop button pops back out.

The emergency stop cover has a plate (shown in Figure 16) which shuts down all machine operations when it is pushed.

### 10.1 Amperage Meter

The amperage meter (Figure 19) continually monitors the load upon the sander. To avoid tripping of the circuit breaker and the overload relays, reduce the load immediately when the amperage meter indicates excessive amperage pull.

### 10.2 LED Controller and Keypad

The controller is used for precise positioning of the conveyor table based upon the workpiece thickness and your desired sanding depth.

Figure 20 shows the key features of the unit.

**⚠️WARNING** The LED control unit comes pre-programmed from the factory. Do NOT alter the specifications of your control unit without authorization from WMH Tool Group. Incorrect programming of the device could cause unit failure as well as risk of injury to people and damage to the sander.

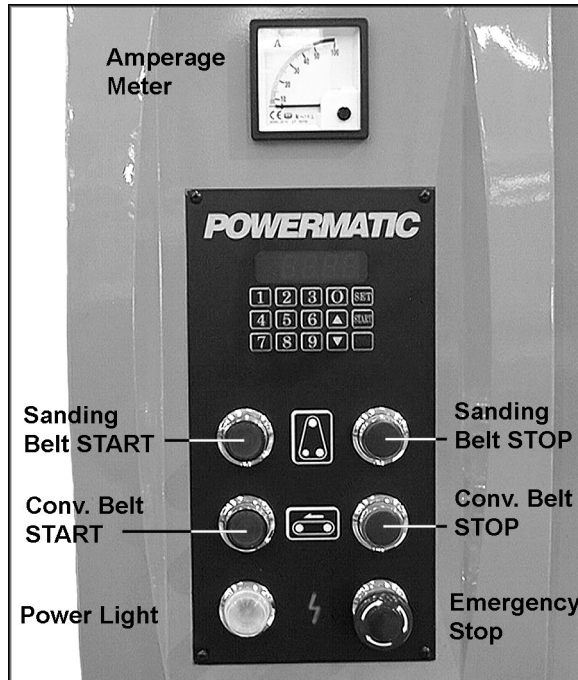


Figure 19

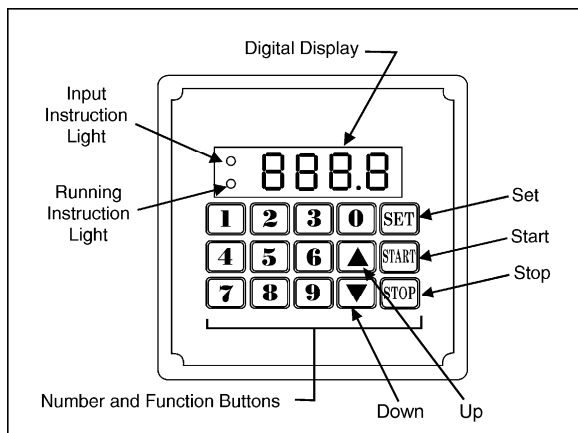


Figure 20

### 10.2.1 Calibration

To establish the distance between conveyor table and sanding belt, proceed as follows:

1. Connect power and air to the sander, and turn the air valve switch on to tighten the sanding belt. NOTE: The controller will not move the table if the air valve switch is off.
2. Press and hold the UP ▲ button on the keypad to raise the conveyor table until the thicknesser knob (Figure 21) contacts the limit switch. The table will automatically stop while making slight contact with the sanding belt.
3. Press "0" (zero) on the keypad (the display will begin flashing and the input light will be lit). Then press SET for 2 to 3 seconds. The display will now read zero. This is the distance between sanding belt and conveyor table, upon which further movement of the table can be based.
4. Input a number using the keypad (display will begin flashing and the input light will be illuminated).
5. While the display is still flashing, press the START button on the keypad (run light will now be illuminated). The conveyor table will move to the desired distance from the sanding belt.

### 10.2.2 Using the LED for Operations

The sander has a thicknesser which automatically sets the table at the thickness of your workpiece:

1. Place your workpiece upon the conveyor table and move it below the thicknesser, as shown in Figure 21. Keep the workpiece flat upon the table. Press and hold the UP ▲ button on the keypad to raise the conveyor table. When the workpiece contacts the limit switch the conveyor table will stop. The table is now positioned at the thickness of your workpiece.
2. Remove the workpiece.
3. Press and release the UP ▲ button, which will raise the table for the first sanding pass. NOTE: The arrow buttons are programmed to move the table in .005" increments.

### 10.2.3 Inch/Metric Toggle

At any time you may switch between standard and metric measurements by pressing and holding SET for ten seconds.

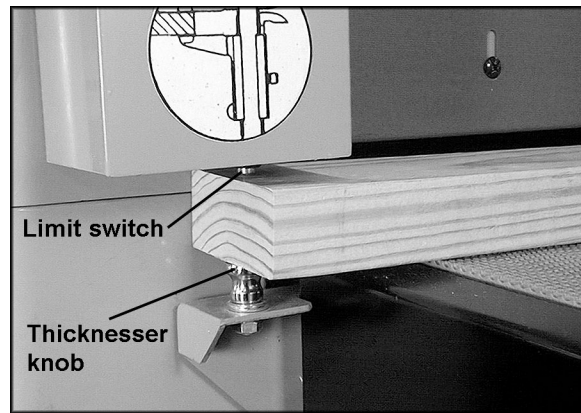


Figure 21

4. Press the sanding belt START button and the conveyor table START button on the control panel, and feed the workpiece through the machine.
5. Make further passes as needed, raising the table each time using the UP▲ button.

## 11.0 Operation

Before operating the sander, make sure that:

1. The dust collection system is turned on.
2. Sanding belt tracking and oscillation are working properly.
3. Conveyor belt tracking is correct.
4. All screws and handles are tightened securely.
5. Working air pressure is correct. (Normal working pressure is 75 to 80 PSI.) *Do not operate sander until normal pressure is reached.*
6. Thickness is correctly input into the LED unit.
7. Feed rate is correctly set.
8. Workpiece is free of nails, knots and other obstructions.

### 11.1 Braking System

The sander will not start or will halt operations if any of the following occur:

- No air supply to the machine.
- No sanding belt installed.
- Improper belt tension.
- Sanding belt runs out of track.
- The emergency stop button on the control panel is pressed.
- The emergency stop plate on the conveyor table is pushed.

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 re-set and started.

## 12.0 Maintenance

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

The interior of the machine should be thoroughly cleaned each day after using the sander. Remove the sanding belt before cleaning and re-install it when finished.

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

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

The bearings should be greased after every 150 work hours.

The water should be removed daily from inside the filter cups. On the filter/regulator at the back of the cabinet, press the drain cock (see Figure 2). On the filter inside the cabinet, unscrew the cup to empty it.

The oil inside the gear reducer should be replaced after the first 100 work hours and every 2500 work hours thereafter. Recommended oil is #90 gear oil. Pour oil into the filler hole until the level is above the dot on the sight glass. See Figure 22.

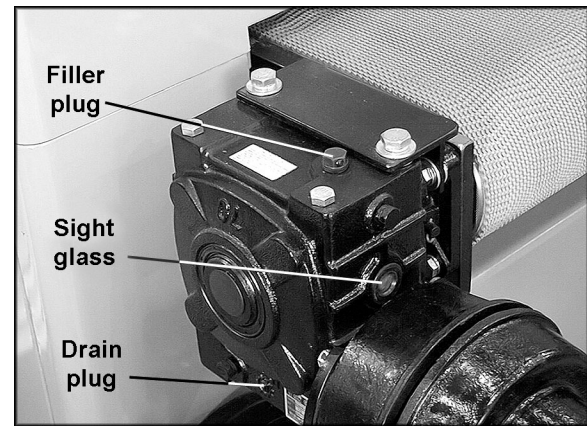
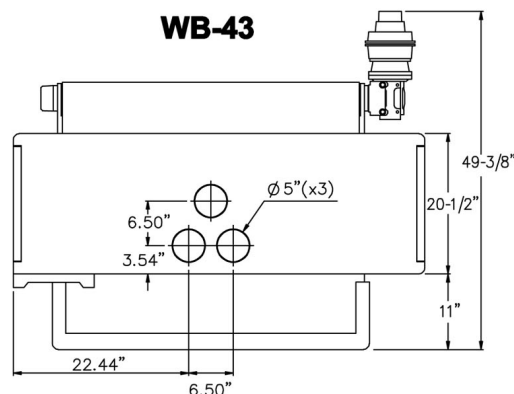
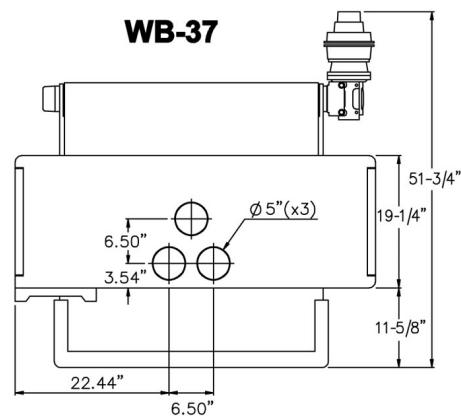
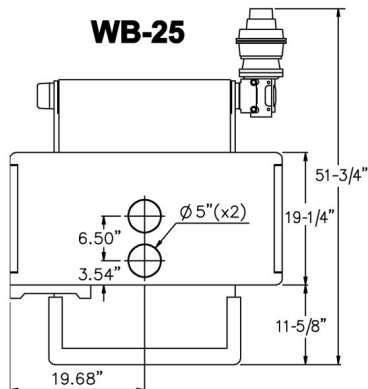


Figure 22

## 13.0 Dust Port Layout



## 14.0 Troubleshooting the Sander

Trouble	Probable Cause	Remedy
Sander will not start.	No incoming power.	Check that sander is connected to power, fuses are not blown or circuit breakers are not tripped.
	Low voltage.	Check voltage at power source.
	Loose wiring.	Inspect and remedy any loose connections on sander.
	Starting switch is defective.	Replace switch.
	Motor is defective.	Replace motor.
Sanding belt clogs too quickly.	Grit of sanding belt is too fine.	Choose a larger grit of sanding paper.
	Too much material being sanded off.	Reduce the amount of material being removed.
	Wood is too oily.	Choose different stock.
	Too much dirt or glue on the wood.	Choose cleaner stock.
	Wood is too moist.	Allow wood to dry before sanding.
Sanding belt will not run, or slips on the rollers.	Air valve switch is Off.	Turn on air valve.
	Emergency stop button is engaged.	Disengage the stop button.
	Limit switches are activated.	Position sanding belt so it is between the limit switches.
	Insufficient air pressure causing belt to slip on rollers.	Make sure air pressure regulator is set at 75 to 80 PSI (page 9).
	Dust or debris on conveyor rollers	Clean conveyor rollers.
Sanding belt keeps triggering the limit switches.	Tracking adjustment/oscillation is not correct.	Set tracking correctly. See page 12 and 13.
	Air flow control is closed.	Open air flow control (page 13).
	Sensors are blocked on the air cylinder bracket.	Clean the sensor areas on the cylinder bracket. See page 13.
Machine takes too long to stop after emergency switch is activated.	Air pressure is too low.	Set air pressure to 75 to 80 PSI.
	Brake pads are worn.	Replace brake pads.
Grinding noise when brake is activated.	Brake pads are worn.	Replace brake pads (rotor may need turning also).
Too much rounding occurs along edges when solid wood is sanded.	Too much material is being removed, making the contact drum press too tightly.	Reduce the amount of material being removed.
The front end of stock is thinner than the rear.	Rear pressure bar is too low in relation to the contact drum.	Raise rear pressure bar (page 16-17).

<b>Trouble</b>	<b>Probable Cause</b>	<b>Remedy</b>
The rear end of stock is thinner than the front.	Front pressure bar is too low in relation to the contact drum.	Raise front pressure bar (page 16).
Uneven thickness between the left and right sides of the workpiece.	Table not positioned correctly in relation to contact drum.	Adjust table until it is parallel left to right (pages 17-18).
	Front pressure bar not in correct position in relation to contact drum.	Adjust front pressure bar to parallel. See page 16.
	Graphite strip and felt pad are worn out.	Replace graphite strip and felt pad. See page 14.
	Conveyor belt is worn.	Replace conveyor belt (contact Powermatic Technical Service).
Uneven thickness between the front and rear ends of the workpiece.	Feed rate is too high.	Reduce feed rate. See page 16.
	Too much stock removal.	Reduce amount of material being removed.
	Grit of sanding belt too fine.	Use larger grit sanding belt.
	Unequal position of pressure bars.	Adjust pressure bars to produce equal pressure on stock.
	Table not parallel front to back.	Adjust table until it is parallel front to back (pages 17-18).
Workpiece slips on conveyor belt.	Not enough pressure between pressure bar and workpiece.	Increase pressure between pressure bar and workpiece.
	Too much dust or debris on conveyor belt.	Clean conveyor belt with compressed air.
	Rear pressure bar too low, halts the workpiece.	Raise rear pressure bar until proper contact is achieved.
Straight strip of notches or grooves in the workpiece.	Dirty pressure bar.	Clean pressure bar.
	Contact drum is scratched.	Replace contact drum.
	Graphite strip and felt pad are worn.	Replace graphite and pad.
“Snake” marks on workpiece.	Local damage to the sanding belt.	Replace sanding belt.
Straight parallel running stripes over entire width of workpiece.	Joint of the sanding belt is too thick or is open.	Repair joint or replace sanding belt.
Glossy spots on the wood.	Sanding belt is too old.	Replace with new sanding belt.
	Rear pressure bar is too low.	Raise rear pressure bar.

## 15.0 Troubleshooting the LED Unit

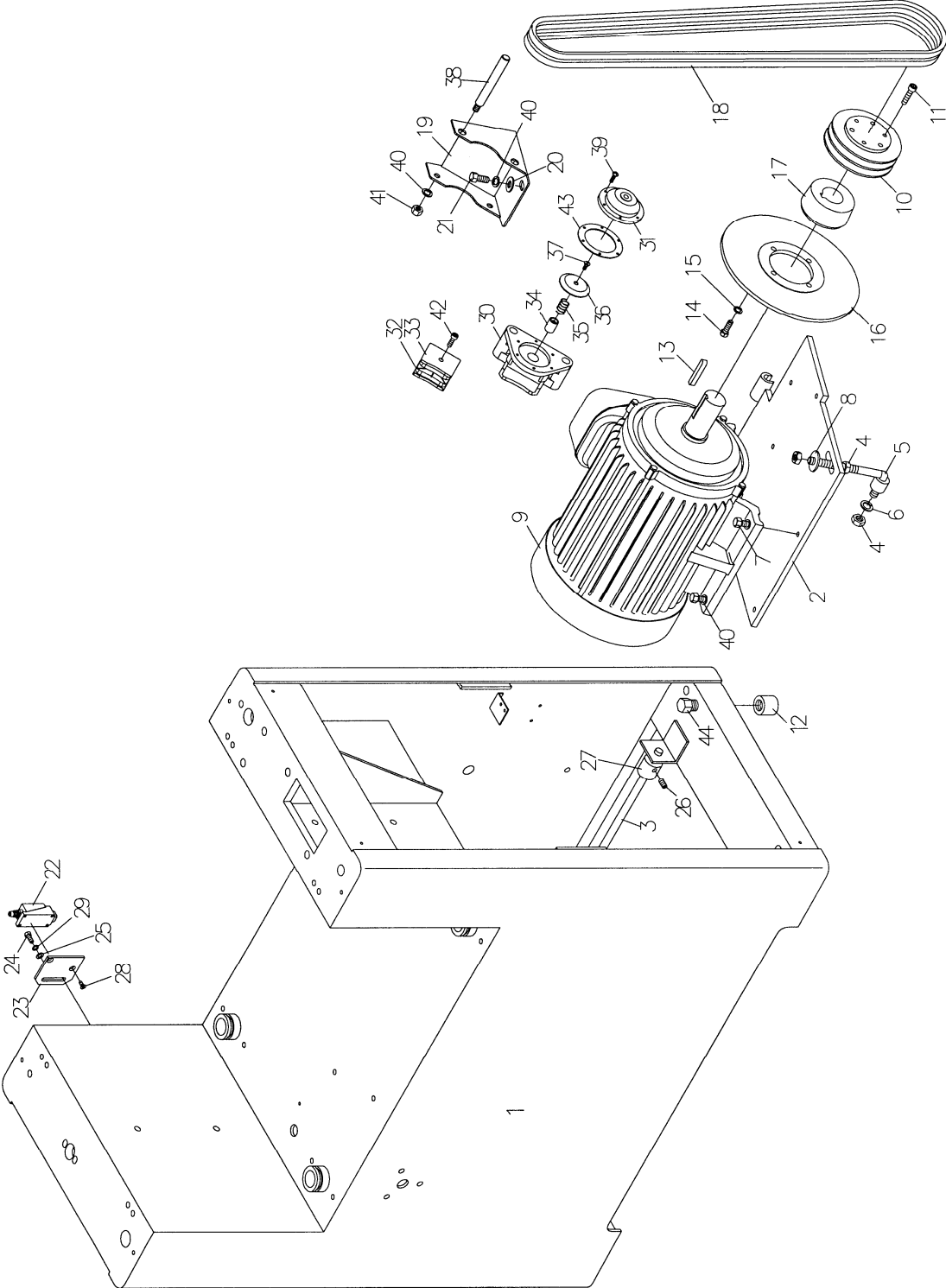
Trouble	Probable Cause	Remedy
The display fails to show figures.	Fuse is burned out.	Replace 1A fuse.
	Control unit is malfunctioning.	Unit must be repaired or replaced by authorized service personnel.
Display shows abnormal figures.	Wrong figures were input.	Input the proper numbers in accordance with the actual dimensions.  If the above step is ineffective, turn the power off and then on. If the display is still not working properly, it should be repaired or replaced. Contact Powermatic Technical Service.
Display shows figures, but they do not change in conjunction with the hoist motor's operation.	Proximity switch is not functioning.	Have proximity switch replaced by authorized service personnel.
	Distance between induction unit and induction sheet is more than 1mm.	Adjust distance between induction unit and induction sheet to less than 1mm.
	Encoder not running in accordance with the table movement.	Encoder should be repaired or replaced by a service representative.
Travel dimension incorrect.	Distance between sanding roller and conveyor belt has not been input correctly into the unit.	Correct control unit parameter. See page 19.
Table will not respond to figures input into unit.	Air valve turned off, sanding belt not tensioned.	Turn air valve on.

## 16.0 Replacement Parts

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

16.1.1 Base and Motor Assembly – Model WB-25 ONLY

Parts list on page 25.





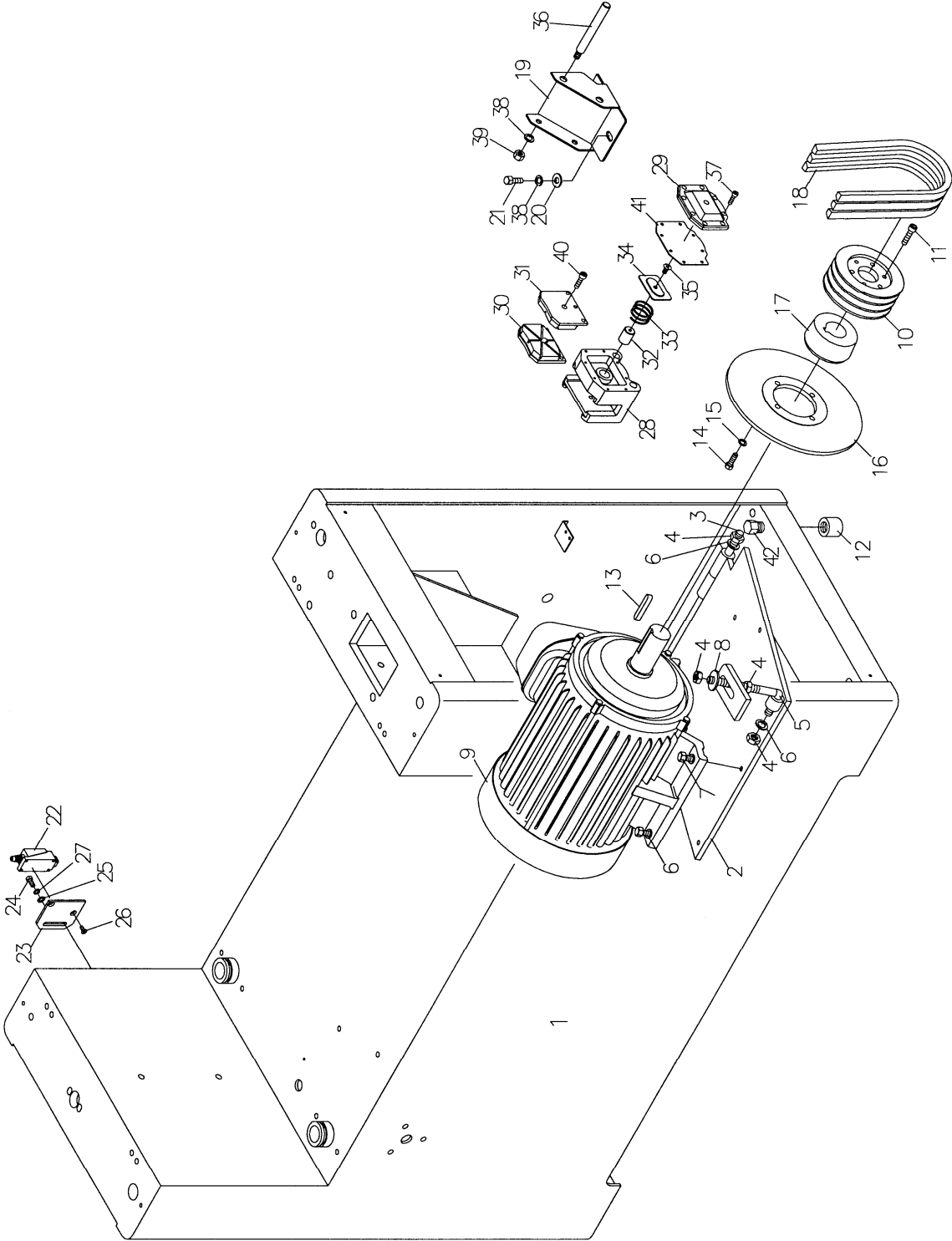
## 16.1.2 Parts List: Base and Motor Assembly – Model WB-25

Exploded view on page 24.

Index No.	Part No.	Description	Size	Qty
1	WB25-201	Machine Base		1
2	WB25-202	Motor Plate		1
3	WB25-203	Rod		1
4	WB25-149	Hex Nut	1/2-12	3
5	WB25-205	Motor Adjusting Screw		1
6	TS-0720111	Lock Washer	1/2	1
7	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	4
8	TS-0680061	Flat Washer	1/2	2
9	WB25-209	Motor	15HP, 230/460V, 3Ph	1
10	WB25-210	Motor Pulley		1
11	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	3
12	WB25-212	Leveling Nut		4
13	WB25-213	Key	8x10x74	1
14	TS-0051051	Hex Cap Screw	5/16-18x1	4
15	TS-0720081	Lock Washer	5/16	4
16	WB25-216	Disc Brake		1
17	WB25-217	Pulley Bushing		1
18	VB-B73	V-Belt	B-73	2
19	WB25-219	Brake Base		1
20	TS-0680041	Flat Washer	3/8	2
21	TS-0060031	Hex Cap Screw	3/8-16x3/4	2
22	6294280	Limit Switch		2
23	6294281	Limit Switch Plate		2
24	TS-0050021	Hex Cap Screw	1/4-20x5/8	2
25	TS-0680021	Flat Washer	1/4	2
26	TS-0270071	Set Screw	5/16-18x3/4	4
27	WB25-227	Bushing		2
28	WB25-131	Flat Head Screw	M5x8	4
29	TS-0720071	Lock Washer	1/4	2
30	WB25-230	Brake Housing		1
31	WB25-231	Front Cover		1
32	WB25-232	Brake Lining		1
33	WB25-233	Brake Lining		1
34	WB25-234	Bushing		1
35	WB25-235	Spring		1
36	WB25-236	Inner Plate		1
37	TS-1514041	Flat Head Socket Screw	M6x25	1
38	WB25-238	Pin		2
39	TS-1502051	Socket Head Cap Screw	M5x20	6
40	TS-0720091	Lock Washer	3/8	7
41	TS-0561031	Hex Nut	3/8-16	2
42	TS-1503031	Socket Head Cap Screw	M6x12	1
43	WB25-243	Gasket		1
44	WB25-244	Leveling Screw		4

**16.2.1 Base and Motor Assembly – Model WB-37 ONLY**

Parts list on page 27.



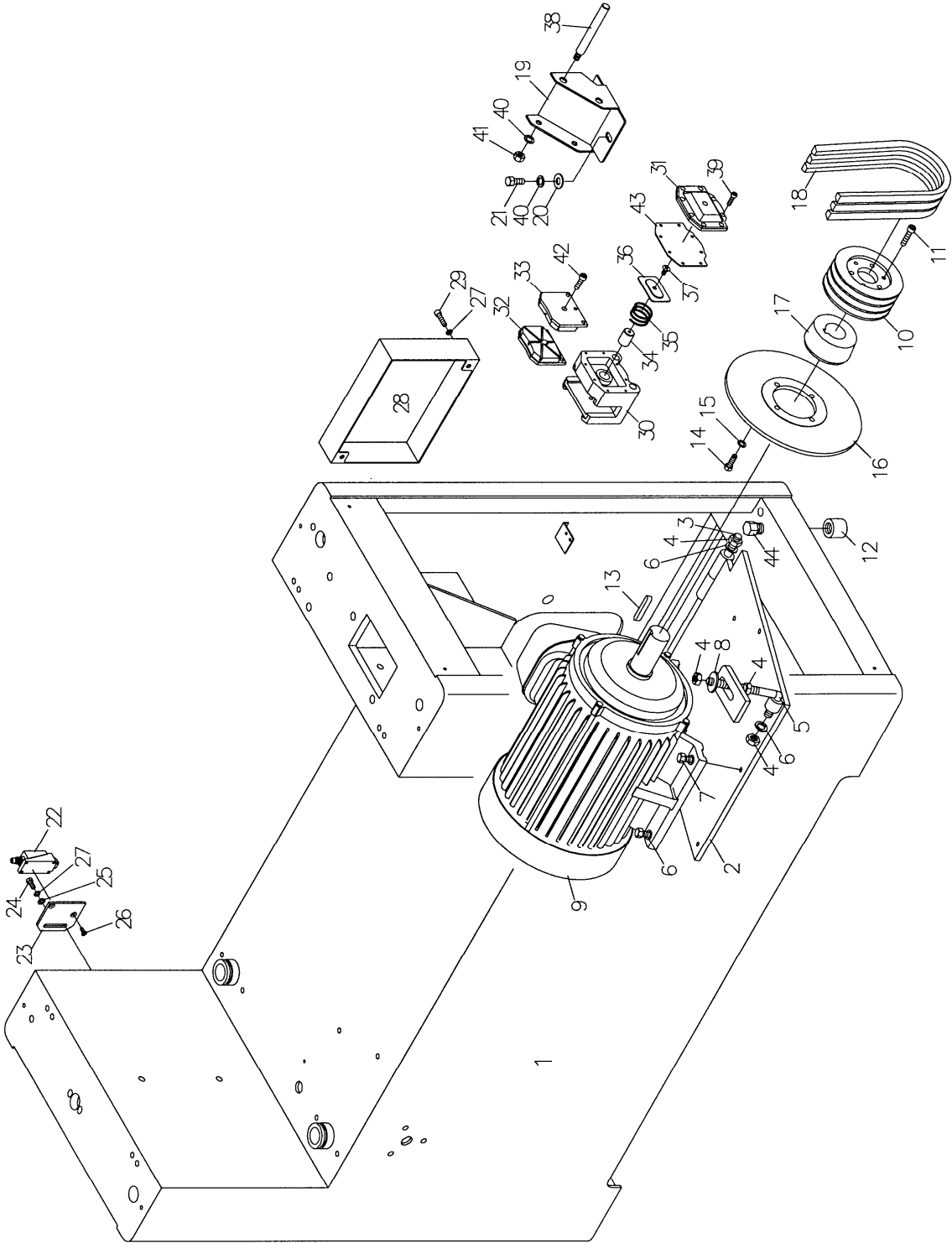
## 16.2.2 Parts List: Base and Motor Assembly – Model WB-37

Exploded view on page 26.

Index No.	Part No.	Description	Size	Qty
1	WB37-201	Machine Base		1
2	WB37-202	Motor Plate		1
3	WB37-203	Rod		1
4	WB25-149	Hex Nut	1/2-12	4
5	WB37-205	Motor Adjusting Screw		1
6	TS-0720111	Lock Washer	1/2	6
7	WB25-701	Hex Cap Screw	1/2-12x1-1/2	4
8	TS-0680061	Flat Washer	1/2	2
9	WB37-209	Motor	20HP, 230/460V, 3Ph	1
10	WB37-210	Motor Pulley		1
11	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	3
12	WB25-212	Leveling Nut		4
13	WB37-213	Key	8x12x105	1
14	TS-0051051	Hex Cap Screw	5/16-18x1	4
15	TS-0720081	Lock Washer	5/16	4
16	WB25-216	Disc Brake		1
17	WB37-217	Pulley Bushing		1
18	VB-B73	V-Belt	B-73	3
19	WB37-219	Brake Base		1
20	TS-0680041	Flat Washer	3/8	2
21	TS-0060031	Hex Cap Screw	3/8-16x3/4	2
22	6294280	Limit Switch		2
23	6294281	Limit Switch Plate		2
24	TS-0050021	Hex Cap Screw	1/4-20x5/8	2
25	TS-0680021	Flat Washer	1/4	2
26	WB25-131	Flat Head Screw	M5x8	4
27	TS-0720071	Lock Washer	1/4	2
28	6294284	Brake Housing		1
29	6294285	Front Cover		1
30	6294286	Brake Lining		1
31	6294661	Rear Brake Lining		1
32	6294287	Bushing		1
33	6294288	Spring		1
34	6294289	Inner Plate		1
35	TS-081F031	Flat Head Screw	1/4-20x1/2	1
36	6294291	Pin		2
37	TS-0206041	Socket Head Cap Screw	10-24x3/4	8
38	TS-0720091	Lock Washer	3/8	3
39	TS-0561031	Hex Nut	3/8-16	2
40	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	2
41	6294296	Gasket		1
42	WB25-244	Leveling Screw		4

### 16.3.1 Base and Motor Assembly – Model WB-43 ONLY

Parts list on page 29.



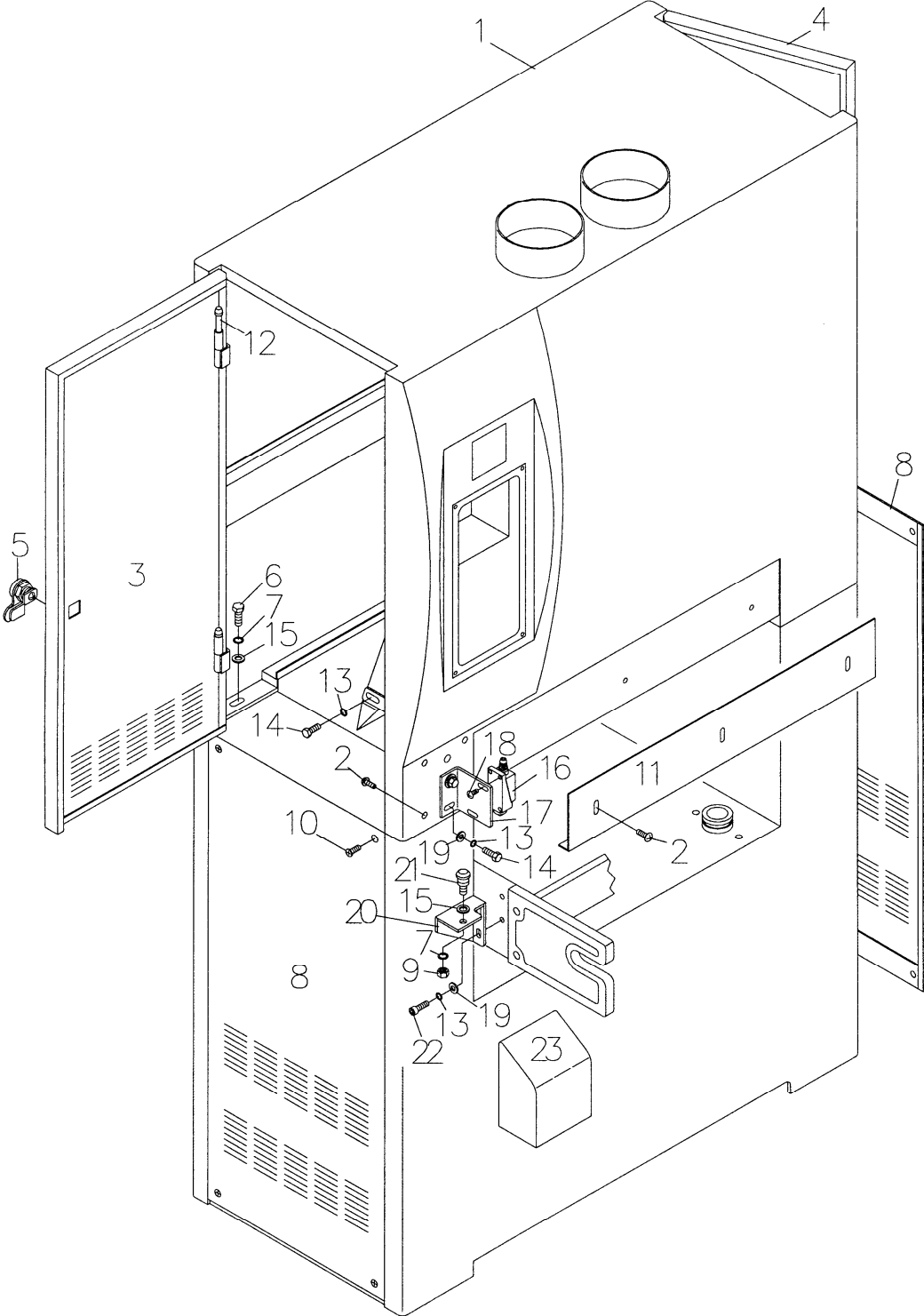
### 16.3.2 Parts List: Base and Motor Assembly – Model WB-43

Exploded view on page 28.

Index No.	Part No.	Description	Size	Qty
1	WB43-201	Machine Base		1
2	WB43-202	Motor Plate		1
3	WB43-203	Rod		1
4	WB25-149	Hex Nut	1/2-12	4
5	6294262	Motor Adjusting Screw		1
6	TS-0720111	Lock Washer	1/2	6
7	WB25-701	Hex Cap Screw	1/2-12x1-1/2	4
8	TS-0680061	Flat Washer	1/2	2
9	WB43-209	Motor	25HP, 230/460V, 3Ph	1
10	WB43-210	Motor Pulley		1
11	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	3
12	WB25-212	Leveling Nut		4
13	WB43-213	Key	9×14×105	1
14	TS-0051051	Hex Cap Screw	5/16-18x1	4
15	TS-0720081	Lock Washer	5/16	4
16	WB25-216	Disc Brake		1
17	WB43-217	Pulley Bushing		1
18	VB-B70	V-Belt	B-70	3
19	WB37-219	Brake Base		1
20	TS-0680041	Flat Washer	3/8	2
21	TS-0060031	Hex Cap Screw	3/8-16x3/4	2
22	6294280	Limit Switch		2
23	6294281	Limit Switch Plate		2
24	TS-0050021	Hex Cap Screw	1/4-20x5/8	2
25	TS-0680021	Flat Washer	1/4	2
26	WB25-131	Flat Head Screw	M5x8	4
27	TS-0720071	Lock Washer	1/4	3
28	WB43-228	Motor Cover		1
29	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	2
30	6294284	Brake Housing		1
31	6294285	Front Cover		1
32	6294286	Brake Lining		1
33	6294661	Brake Lining		1
34	6294287	Bushing		1
35	6294288	Spring		1
36	6294289	Inner Plate		1
37	TS-081F031	Flat Head Screw	1/4-20x1/2	1
38	6294291	Pin		2
39	TS-0206041	Socket Head Cap Screw	10-24x3/4	8
40	TS-0720091	Lock Washer	3/8	3
41	TS-0561031	Hex Nut	3/8-16	2
42	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	2
43	6294296	Gasket		1
44	WB25-244	Leveling Screw		4

**16.4.1 Upper Cabinet Assembly – Model WB-25 ONLY**

Parts list on page 31.



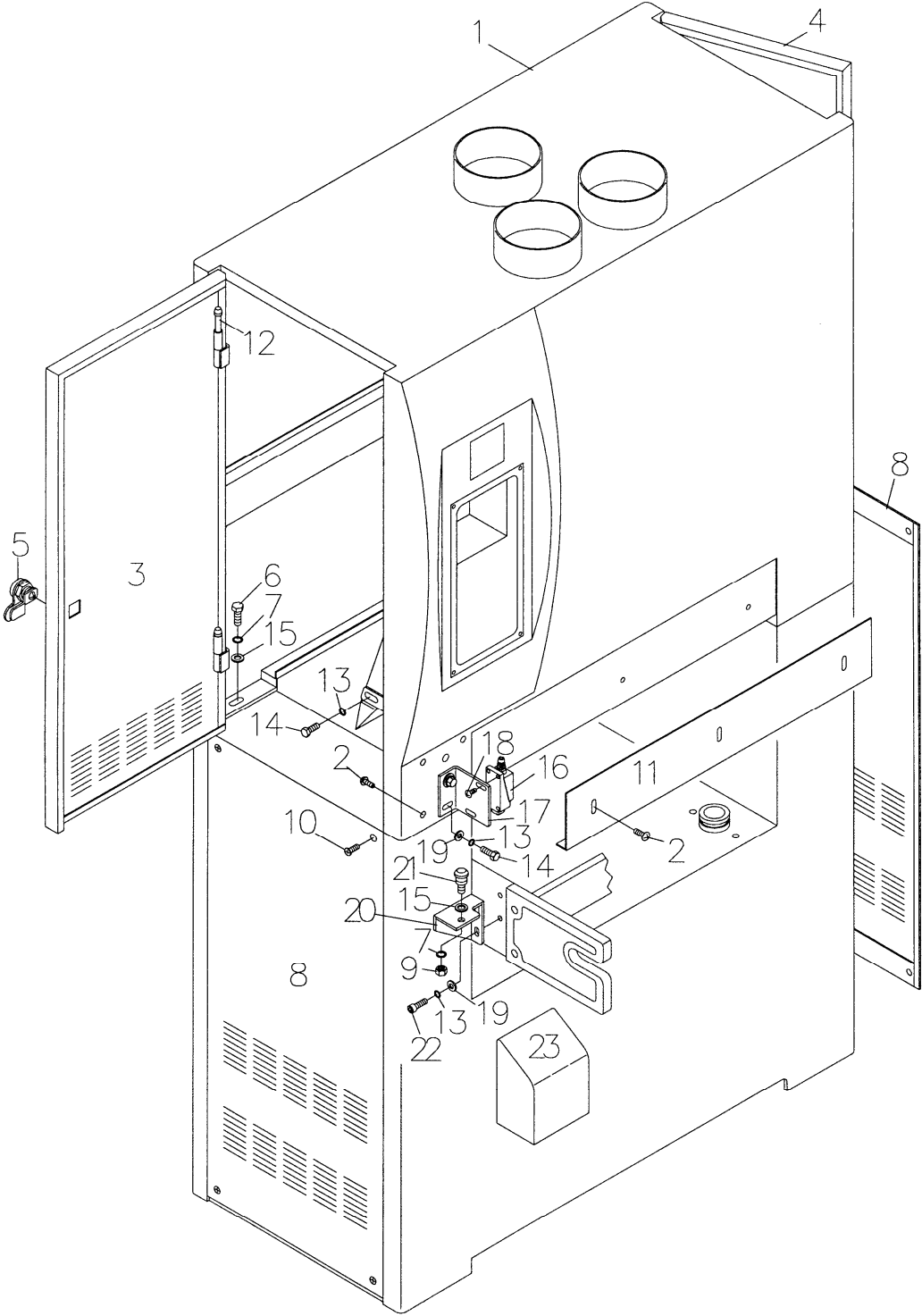
## 16.4.2 Parts List: Upper Cabinet Assembly – Model WB-25

Exploded view on page 30.

Index No.	Part No.	Description	Size	Qty
1	WB25-301	Upper Cabinet		1
2	TS-1534032	Pan Head Screw	M6x10	7
3	WB25-303	Upper Left Door		1
4	WB25-304	Upper Right Door		1
5	6294509	Door Lock		2
6	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	4
7	TS-0720081	Lock Washer	5/16	5
8	WB25-308	Lower Door		2
9	TS-0561021	Hex Nut	5/16-18	1
10	TS-081F031	Flat Head Screw	1/4-20x1/2	8
11	WB25-311	Emergency Plate		1
12	WB25-312	Door Hinge Pin		4
13	TS-2361061	Lock Washer	M6	6
14	TS-1482021	Hex Cap Screw	M6x12	4
15	TS-0680031	Flat Washer	5/16	5
16	6294280	Limit Switch		1
17	WB25-317	Limit Switch Holder		1
18	TS-1533032	Pan Head Screw	M5x10	1
19	TS-0680021	Flat Washer	1/4	3
20	WB25-320	Fixed Bracket		1
21	WB25-321	Thickener Post		1
22	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	2
23	WB25-323	Cover		1

### 16.5.1 Upper Cabinet Assembly – Models WB-37, WB-43

Parts list on page 33.





### 16.5.2 Parts List: Upper Cabinet Assembly – Model WB-37

Exploded view on page 32.

Index No.	Part No.	Description	Size	Qty
1	WB37-301	Upper Cabinet		1
2	TS-1534032	Pan Head Screw	M6x10	8
3	WB25-303	Upper Left Door		1
4	WB25-304	Upper Right Door		1
5	6294509	Door Lock		2
6	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	4
7	TS-0720081	Lock Washer	5/16	5
8	WB25-308	Lower Door		2
9	TS-0561021	Hex Nut	5/16-18	1
10	TS-081F031	Flat Head Screw	1/4-20x1/2	8
11	WB37-311	Emergency Plate		1
12	WB25-312	Door Hinge Pin		4
13	TS-2361061	Lock Washer	M6	6
14	TS-1482021	Hex Cap Screw	M6x12	4
15	TS-0680031	Flat Washer	5/16	5
16	6294280	Limit Switch		1
17	WB25-317	Limit Switch Holder		1
18	TS-1533032	Pan Head Screw	M5x10	1
19	TS-0680021	Flat Washer	1/4	2
20	WB25-320	Fixed Bracket		1
21	WB25-321	Thickneser Post		1
22	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	2
23	WB25-323	Cover		1

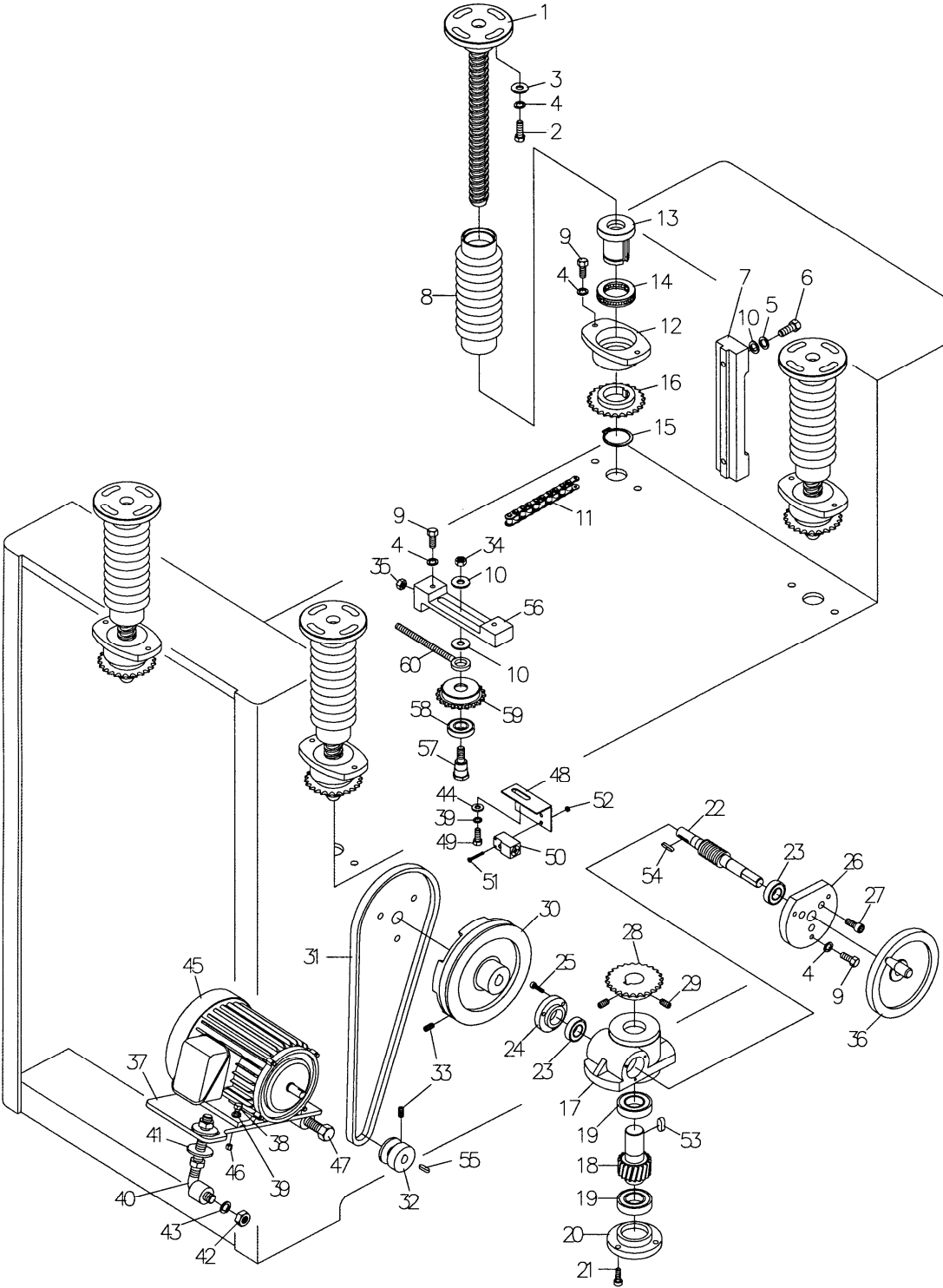
### 16.5.3 Parts List: Upper Cabinet Assembly – Model WB-43

Exploded view on page 32.

Index No.	Part No.	Description	Size	Qty
1	WB43-301	Upper Cabinet		1
2	TS-1534032	Pan Head Screw	M6x10	8
3	WB43-303	Upper Left Door		1
4	WB43-304	Upper Right Door		1
5	6294509	Door Lock		2
6	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	4
7	TS-0720081	Lock Washer	5/16	5
8	WB43-308	Lower Door		2
9	TS-0561021	Hex Nut	5/16-18	1
10	TS-081F031	Flat Head Screw	1/4-20x1/2	8
11	WB43-311	Emergency Plate		1
12	WB25-312	Door Hinge Pin		4
13	TS-2361061	Lock Washer	M6	6
14	TS-1482021	Hex Cap Screw	M6x12	4
15	TS-0680031	Flat Washer	5/16	5
16	6294280	Limit Switch		1
17	WB25-317	Limit Switch Holder		1
18	TS-1533032	Pan Head Screw	M5x10	1
19	TS-0680021	Flat Washer	1/4	2
20	WB25-320	Fixed Bracket		1
21	WB25-321	Thickneser Post		1
22	TS-0207031	Hex Socket Cap Screw	1/4-20x5/8	2
23	WB25-323	Cover		1

**16.6.1 Table Raising Assembly – Models WB-25, WB-37, WB-43**

Parts list on page 35 (WB-25), page 36 (WB-37) and page 37 (WB-43).



## 16.6.2 Parts List: Table Raising Assembly – Model WB-25

Exploded view on page 34.

Index No.	Part No.	Description	Size	Qty
1	6294297	Elevation Screw		4
2	TS-0051051	Hex Cap Screw	5/16-18x1	8
3	TS-0680031	Flat Washer	5/16	8
4	TS-0720081	Lock Washer	5/16	20
5	TS-0720091	Lock Washer	3/8	4
6	TS-0060051	Hex Cap Screw	3/8-16x1	4
7	6294302	Elevation Slide		2
8	6294303	Dust Guard Bellow		4
9	TS-0081031	Hex Cap Screw	5/16-18x3/4	12
10	TS-0680041	Flat Washer	3/8	6
11	6294305	Chain		1
12	6294306	Nut Housing		4
13	6294307	Nut		4
14	6294308	Thrust Bearing		4
15	6294309	C-Circlip		4
16	6294310	Sprocket Wheel		4
17	6294311	Elevation Gearbox		1
18	6294312	Worm Gear		1
19	BB-6005Z	Ball Bearing	6005Z	2
20	6294314	Bearing Cap		1
21	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	3
22	6294316	Worm Gear		1
23	BB-6002Z	Ball Bearing	6002Z	2
24	6294318	Bearing Cap		1
25	TS-0206031	Socket Head Cap Screw	10-24x5/8	3
26	6294320	Bearing Cap		1
27	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	3
28	6294322	Sprocket Wheel		1
29	TS-0270051	Set Screw	5/16-18x1/2	2
30	6294324	Pulley		1
31	VB-A37	V-Belt	A-37	1
32	6294326	Motor Pulley		1
33	TS-0267051	Set Screw	1/4-20x1/2	3
34	TS-0561031	Hex Nut	3/8-16	1
35	TS-0561021	Hex Nut	5/16-18	1
36	6294330	Hand Wheel		1
37	6294331	Motor Base		1
38	TS-0050051	Hex Cap Screw	1/4-20x1	4
39	TS-0720071	Lock Washer	1/4	5
40	6294333	Motor Base Adjustment Rod		1
41	TS-0680061	Flat Washer	1/2	2
42	WB25-149	Hex Nut	1/2-12	3
43	TS-0720111	Lock Washer	1/2	2
44	TS-0680021	Flat Washer	1/4	1
45	6294334	Motor	1/4HP, 230/460V, 3Ph	1
46	TS-0561011	Hex Nut	1/4-20	4
47	WB25-447	Hex Head Screw	1/2-12x4	1
48	WB25-448	Switch Plate		1
49	TS-0050011	Hex Cap Screw	1/4-20x1/2	1
50	WB25-450	Switch		1
51	TS-2283302	Pan Head Screw	M3x30	2
52	TS-1540011	Hex Nut	M3	2
53	6294337	Key	5/16x5/16x3/4	1
54	6294338	Key	4x4x20	1
55	6294339	Key	4x4x16	1

56	6294340	Sprocket Wheel Adjustment Piece	1
57	6294341	Sprocket Wheel Shaft	1
58	BB-6003ZZ	Bearing	6003ZZ 1
59	6294343	Adjustment Sprocket Wheel	1
60	6294344	Sprocket Wheel Adjustment Rod	1

### 16.6.3 Parts List: Table Raising Assembly – Model WB-37

Exploded view on page 34.

Index No.	Part No.	Description	Size	Qty
1	6294297	Elevation Screw		4
2	TS-0051051	Hex Cap Screw	5/16-18x1	8
3	TS-0680031	Flat Washer	5/16	8
4	TS-0720081	Lock Washer	5/16	20
5	TS-0720091	Lock Washer	3/8	4
6	TS-0060051	Hex Cap Screw	3/8-16x1	4
7	6294302	Elevation Slide		2
8	6294303	Dust Guard Bellow		4
9	TS-0081031	Hex Cap Screw	5/16-18x3/4	12
10	TS-0680041	Flat Washer	3/8	6
11	6294305	Chain		1
12	6294306	Nut Housing		4
13	6294307	Nut		4
14	6294308	Thrust Bearing		4
15	6294309	C-Circlip		4
16	6294310	Sprocket Wheel		4
17	6294311	Elevation Gearbox		1
18	6294312	Worm Gear		1
19	BB-6005Z	Ball Bearing	6005Z	2
20	6294314	Bearing Cap		1
21	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	3
22	6294316	Worm Gear		1
23	BB-6002Z	Ball Bearing	6002Z	2
24	6294318	Bearing Cap		1
25	TS-0206031	Socket Head Cap Screw	10-24x5/8	3
26	6294320	Bearing Cap		1
27	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	3
28	6294322	Sprocket Wheel		1
29	TS-0270051	Set Screw	5/16-18x1/2	2
30	6294324	Pulley		1
31	VB-A37	V-Belt	A-37	1
32	6294326	Motor Pulley		1
33	TS-0267051	Set Screw	1/4-20x1/2	3
34	TS-0561031	Hex Nut	3/8-16	1
35	TS-0561021	Hex Nut	5/16-18	1
36	6294330	Hand Wheel		1
37	6294331	Motor Base		1
38	TS-0050051	Hex Cap Screw	1/4-20x1	4
39	TS-0720071	Lock Washer	1/4	5
40	6294333	Motor Base Adjustment Rod		1
41	TS-0680061	Flat Washer	1/2	2
42	WB25-149	Hex Nut	1/2-12	3
43	TS-0720111	Lock Washer	1/2	2
44	TS-0680021	Flat Washer	1/4	1
45	6294334	Motor	1/4HP, 230/460V, 3Ph	1
46	TS-0561011	Hex Nut	1/4-20	4
47	WB25-447	Hex Head Screw	1/2-12x4	1

48	WB25-448	Switch Plate		1
49	TS-0050011	Hex Cap Screw	1/4-20x1/2	1
50	WB25-450	Switch		1
51	TS-2283302	Screw	M3x30	2
52	TS-1540011	Hex Nut	M3	2
53	6294337	Key	5/16x5/16x3/4	1
54	6294338	Key	4x4x20	1
55	6294339	Key	4x4x16	1
56	6294340	Sprocket Wheel Adjustment Piece		1
57	6294341	Sprocket Wheel Shaft		1
58	BB-6003ZZ	Bearing	6003ZZ	1
59	6294343	Adjustment Sprocket Wheel		1
60	6294344	Sprocket Wheel Adjustment Rod		1

#### 16.6.4 Parts List: Table Raising Assembly – Model WB-43

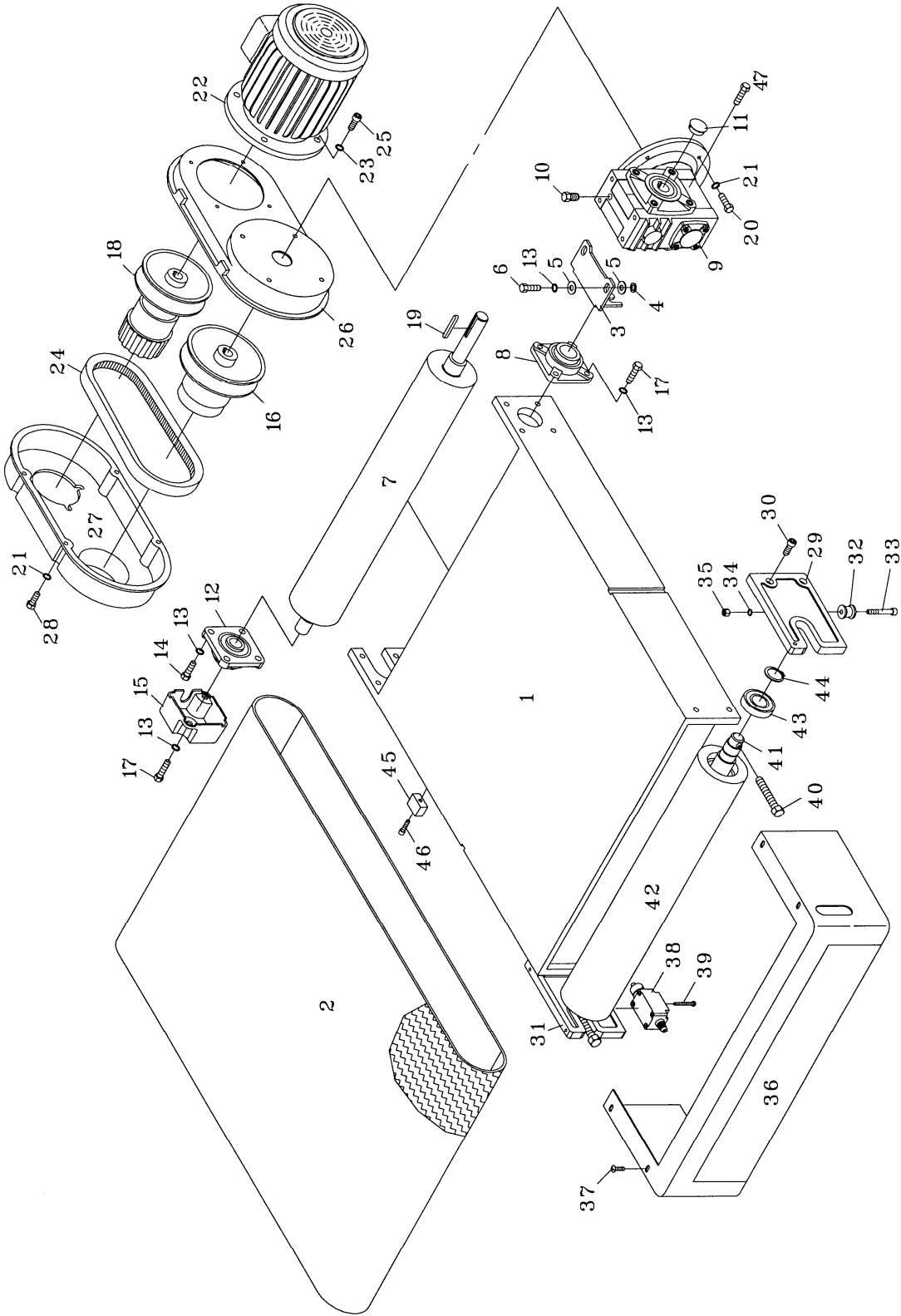
Exploded view on page 34.

Index No.	Part No.	Description	Size	Qty
1	6294297	Elevation Screw		4
2	TS-0051051	Hex Cap Screw	5/16-18x1	8
3	TS-0680031	Flat Washer	5/16	8
4	TS-0720081	Lock Washer	5/16	20
5	TS-0720091	Lock Washer	3/8	4
6	TS-0060051	Hex Cap Screw	3/8-16x1	4
7	6294302	Elevation Slide		2
8	6294303	Dust Guard Bellow		4
9	TS-0081031	Hex Cap Screw	5/16-18x3/4	12
10	TS-0680041	Flat Washer	3/8	6
11	6294305	Chain		1
12	6294306	Nut Housing		4
13	6294307	Nut		4
14	6294308	Thrust Bearing		4
15	6294309	C-Circlip		4
16	6294310	Sprocket Wheel		4
17	6294311	Elevation Gearbox		1
18	6294312	Worm Gear		1
19	BB-6005Z	Ball Bearing	6005Z	2
20	6294314	Bearing Cap		1
21	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	3
22	6294316	Worm Gear		1
23	BB-6002Z	Ball Bearing	6002Z	2
24	6294318	Bearing Cap		1
25	TS-0206031	Socket Head Cap Screw	10-24x5/8	3
26	6294320	Bearing Cap		1
27	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	3
28	6294322	Sprocket Wheel		1
29	TS-0270051	Set Screw	5/16-18x1/2	2
30	6294324	Pulley		1
31	VB-A36	V-Belt	A-36	1
32	6294326	Motor Pulley		1
33	TS-0267051	Set Screw	1/4-20x1/2	3
34	TS-0561031	Hex Nut	3/8-16	1
35	TS-0561021	Hex Nut	5/16-18	1
36	6294330	Hand Wheel		1
37	6294331	Motor Base		1
38	TS-0050051	Hex Cap Screw	1/4-20x1	4
39	TS-0720071	Lock Washer	1/4	5

40	6294333	Motor Base Adjustment Rod		1
41	TS-0680061	Flat Washer	1/2	2
42	WB25-149	Hex Nut	1/2-12	3
43	TS-0720111	Lock Washer	1/2	2
44	TS-0680021	Flat Washer	1/4	1
45	6294334	Motor	1/4HP, 230/460V, 3Ph	1
46	TS-0561011	Hex Nut	1/4-20	4
47	WB25-447	Hex Screw	1/2-12x4	1
48	WB25-448	Switch Plate		1
49	TS-0050011	Hex Cap Screw	1/4-20x1/2	1
50	WB25-450	Switch		1
51	TS-2283302	Pan Head Screw	M3x30	2
52	TS-1540011	Hex Nut	M3	2
53	6294337	Key	5/16x5/16x3/4	1
54	6294338	Key	4x4x20	1
55	6294339	Key	4x4x16	1
56	6294340	Sprocket Wheel Adjustment Piece		1
57	6294341	Sprocket Wheel Shaft		1
58	BB-6003ZZ	Bearing	6003ZZ	1
59	6294343	Adjustment Sprocket Wheel		1
60	6294344	Sprocket Wheel Adjustment Rod		1

16.7.1 Table and Conveyor Belt Assembly – Models WB-25, WB-37, WB-43

Parts list on page 40 (WB-25), page 41 (WB-37) and page 42 (WB-43).



## 16.7.2 Parts List: Table and Conveyor Belt Assembly – Model WB-25

Exploded view on page 39.

Index No.	Part No.	Description	Size	Qty
1	WB25-501	Conveyor Table		1
2	WB25-502	Conveyor Belt		1
3	WB25-503	Mounting Bracket		1
4	WB25-504	Washer		2
5	TS-1550071	Flat Washer	M10	4
6	TS-1491031	Hex Cap Screw	M10x25	2
7	WB25-507	Outfeed Roller		1
8	6294352	Bearing, Flange Mount		1
9	WB25-509	Reducer		1
10	WB25-510	Plug		1
11	WB25-511	Cover		1
12	6290231	Bearing, Flange Mount		1
13	TS-2361101	Lock Washer	M10	10
14	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	2
15	6294356	Bearing Cap		1
16	WB25-516	Driven Pulley		1
17	TS-0060071	Hex Cap Screw	3/8-16x1-1/2	6
18	WB25-518	Driving Pulley		1
19	WB25-519	Key	8x8x55	1
20	TS-1490041	Hex Cap Screw	M8x25	4
21	TS-2361081	Lock Washer	M8	8
22	WB25-522	Motor	1HP, 230/460V, 3Ph	1
23	TS-1551071	Lock Washer	M10	4
24	WB25-524	Timing Belt		1
25	TS-1505031	Socket Head Cap Screw	M10x25	4
26	6294383	Variable Speed Unit Base Plate		1
27	6294387	Variable Speed Unit Cover		1
28	TS-1490031	Hex Cap Screw	M8x20	1
29	WB25-529	Infeed Roller Bracket, Right		1
30	TS-0209031	Socket Head Cap Screw	3/8-16x3/4	4
31	WB25-531	Infeed Roller Bracket, Left		1
32	6294372	Conveyor Belt Position Wheel		2
33	TS-0208101	Socket Head Cap Screw	5/16-18x2	2
34	TS-0720081	Lock Washer	5/16	2
35	TS-0561021	Hex Nut	5/16-18	2
36	WB25-536	Emergency Stop Cover		1
37	TS-081F032	Pan Head Screw	1/4-20x1/2	4
38	6294376	Limit Switch		1
39	TS-0810102	Round Head Screw	10-24x1-3/4	2
	WB25-IRA	Infeed Roller Assembly (Includes Index #40 thru #44)		1
40	WB25-540	Adjustment Screw	1/2-12x3	2
41	WB25-541	Infeed Roller Shaft		1
42	WB25-542	Infeed Roller		1
43	BB-6206VV	Bearing	6206-2RS	2
44	6294573	C-Circlip		2
45	6294576	Elevation Aluminum Limiter		1
46	TS-0207081	Socket Head Cap Screw	1/4-20x1-1/2	1
47	WB25-547	Plug		2



### 16.7.3 Parts List: Table and Conveyor Belt Assembly – Model WB-37

Exploded view on page 39.

Index No.	Part No.	Description	Size	Qty
1	WB37-501	Conveyor Table		1
2	WB37-502	Conveyor Belt		1
3	WB25-503	Mounting Bracket		1
4	WB25-504	Washer		2
5	TS-1550071	Flat Washer	M10	4
6	TS-1491031	Hex Cap Screw	M10x25	2
7	WB37-507	Outfeed Roller		1
8	6294352	Bearing, Flange Mount		1
9	WB25-509	Reducer		1
10	WB25-510	Plug		3
11	WB25-511	Cover		1
12	6290231	Bearing, Flange Mount		1
13	TS-2361101	Lock Washer	M10	10
14	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	2
15	6294356	Bearing Cap		1
16	WB25-516	Driven Pulley		1
17	TS-0060071	Hex Cap Screw	3/8-16x1-1/2	6
18	WB25-518	Driving Pulley		1
19	WB25-519	Key	8x8x55	1
20	TS-1490041	Hex Cap Screw	M8x25	4
21	TS-2361081	Lock Washer	M8	8
22	WB25-522	Motor	1HP, 230/460V, 3Ph	1
23	TS-1551071	Lock Washer	M10	4
24	WB25-524	Timing Belt		1
25	TS-1505031	Socket Head Cap Screw	M10x25	4
26	6294383	Variable Speed Unit Base Plate		1
27	6294387	Variable Speed Unit Cover		1
28	TS-1490031	Hex Cap Screw	M8x20	1
29	WB25-529	Infeed Roller Bracket, Right		1
30	TS-0209031	Socket Head Cap Screw	3/8-16x3/4	4
31	WB25-531	Infeed Roller Bracket, Left		1
32	6294372	Conveyor Belt Position Wheel		2
33	TS-0208101	Socket Head Cap Screw	5/16-18x2	2
34	TS-0720081	Lock Washer	5/16	2
35	TS-0561021	Hex Nut	5/16-18	2
36	WB37-536	Emergency Stop Cover		1
37	TS-081F032	Screw	1/4-20x1/2	4
38	6294376	Limit Switch		1
39	TS-0810102	Round Head Screw	10-24x1-3/4	2
	WB37-IRA	Infeed Roller Assembly (Includes Index #40 thru #44)		1
40	WB25-540	Adjustment Screw	1/2-12x3	2
41	WB37-541	Infeed Roller Shaft		1
42	WB37-542	Infeed Roller		1
43	BB-6206VV	Bearing	6206-2RS	2
44	6294573	C-Circlip		2
45	6294576	Elevation Aluminum Limiter		1
46	TS-0207081	Socket Head Cap Screw	1/4-20x1-1/2	1
47	WB25-547	Plug		2

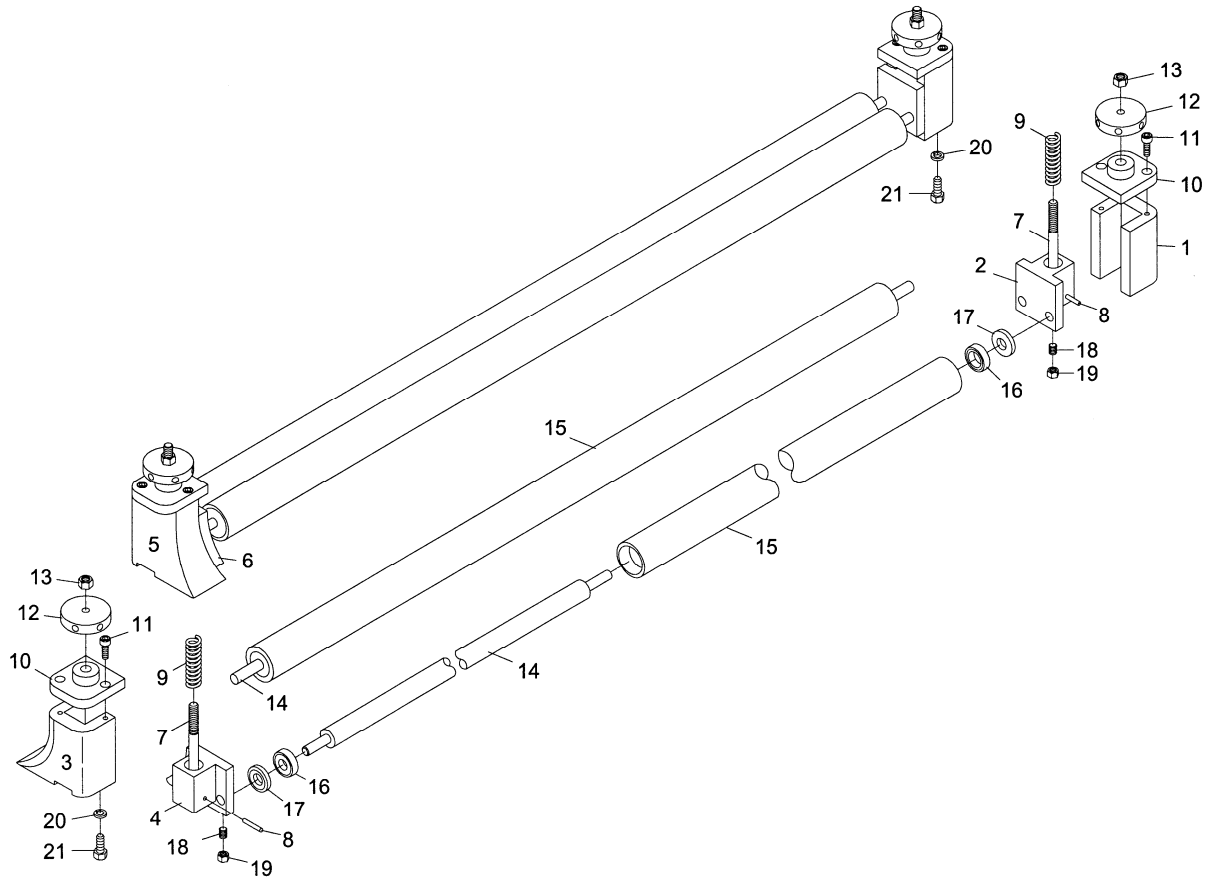
## 16.7.4 Parts List: Table and Conveyor Belt Assembly – Model WB-43

Exploded view on page 39.

Index No.	Part No.	Description	Size	Qty
1	WB43-501	Conveyor Table		1
2	WB43-502	Conveyor Belt		1
3	WB43-503	Mounting Bracket		1
4	WB25-504	Washer		2
5	TS-1550071	Flat Washer	M10	4
6	TS-1491031	Hex Cap Screw	M10x25	2
7	WB43-507	Outfeed Roller		1
8	6294352	Bearing, Flange Mount		1
9	WB43-509	Reducer		1
10	WB25-510	Plug		3
11	WB25-511	Cover		1
12	6290231	Bearing, Flange Mount		1
13	TS-2361101	Lock Washer	M10	10
14	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	2
15	6294356	Bearing Cap		1
16	6294386	Driven Pulley		1
17	TS-0060071	Hex Cap Screw	3/8-16x1-1/2	6
18	6294385	Driving Pulley		1
19	WB25-519	Key	8x8x55	1
20	TS-1490041	Hex Cap Screw	M8x25	4
21	TS-2361081	Lock Washer	M8	8
22	6294363	Motor	2HP, 230/460V, 3Ph	1
23	TS-1551071	Lock Washer	M10	4
24	WB25-524	Timing Belt		1
25	TS-1505031	Socket Head Cap Screw	M10x25	4
26	6294383	Variable Speed Unit Base Plate		1
27	6294387	Variable Speed Unit Cover		1
28	TS-1490031	Hex Cap Screw	M8x20	1
29	WB25-529	Infeed Roller Bracket, Right		1
30	TS-0209031	Socket Head Cap Screw	3/8-16x3/4	4
31	WB25-531	Infeed Roller Bracket, Left		1
32	6294372	Conveyor Belt Position Wheel		2
33	TS-0208101	Socket Head Cap Screw	5/16-18x2	2
34	TS-0720081	Lock Washer	5/16	2
35	TS-0561021	Hex Nut	5/16-18	2
36	WB43-536	Emergency Stop Cover		1
37	TS-081F032	Pan Head Screw	1/4-20x1/2	4
38	6294376	Limit Switch		1
39	TS-0810102	Round Head Screw	10-24x1-3/4	2
	WB43-IRA	Infeed Roller Assembly (Includes Index #40 thru #44)		1
40	WB25-540	Adjustment Screw	1/2-12x3	2
41	6294388	Infeed Roller Shaft		1
42	WB43-542	Infeed Roller		1
43	BB-6206VV	Bearing	6206-2RS	2
44	6294573	C-Circlip		2
45	6294576	Elevation Aluminum Limiter		1
47	WB25-547	Plug		2

## 16.8.1 Pressure Bar Assembly – Models WB-25, WB-37, WB-43

Parts list on page 43 (WB-25) and page 44 (WB-37, WB-43).



## 16.8.2 Parts List: Pressure Bar Assembly – Model WB-25

Index No.	Part No.	Description	Size	Qty
1	WB25-601	Roller Slider, Female		2
2	6294391	Roller Slider, Male		2
3	6294392	Front Roller Slider, Female		1
4	6294393	Front Roller Slider, Male		1
5	6294394	Back Roller Slider, Female		1
6	6294395	Back Roller Slider, Male		1
7	6294396	Roller Adjusting Screw		4
8	6294397	Spring Pin		4
9	6294398	Spring		4
10	6294399	Roller Slider Cover		4
11	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	8
12	6294401	Roller Adjusting Knob		4
13	TS-0561031	Hex Nut	3/8-16	4
	WB25-PBA	Pressure Bar Assembly (Includes Index #14 thru #17)		1
14	6288605	Pressure Bar Shaft		4
15	6290278	Pressure Bar Cover		4
16	BB-6001ZZ	Ball Bearing	6001ZZ	8
17	6294405	Bearing Cover		8
18	TS-0267071	Set Screw	1/4-20x3/4	8
19	TS-0561011	Hex Nut	1/4-20	8
20	TS-0720081	Lock Washer	5/16	8
21	TS-0051061	Hex Cap Screw	5/16-18x1-1/4	8

### 16.8.3 Parts List: Pressure Bar Assembly – Model WB-37

Exploded view on page 43.

Index No.	Part No.	Description	Size	Qty
1	WB25-601	Roller Slider, Female		2
2	6294391	Roller Slider, Male		2
3	6294392	Front Roller Slider, Female		1
4	6294393	Front Roller Slider, Male		1
5	6294394	Back Roller Slider, Female		1
6	6294395	Back Roller Slider, Male		1
7	6294396	Roller Adjusting Screw		4
8	6294397	Spring Pin		4
9	6294398	Spring		4
10	6294399	Roller Slider Cover		4
11	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	8
12	6294401	Roller Adjusting Knob		4
13	TS-0561031	Hex Nut	3/8-16	4
	WB37-PBA	Pressure Bar Assembly (Includes Index #14 thru #17)		1
14	6288705	Pressure Bar Shaft		4
15	6288723	Pressure Bar Cover		4
16	BB-6001ZZ	Ball Bearing	6001ZZ	8
17	6294405	Bearing Cover		8
18	TS-0267071	Set Screw	1/4-20x3/4	8
19	TS-0561011	Hex Nut	1/4-20	8
20	TS-0720081	Lock Washer	5/16	8
21	TS-0051061	Hex Head Screw	5/16-18x1-1/4	8

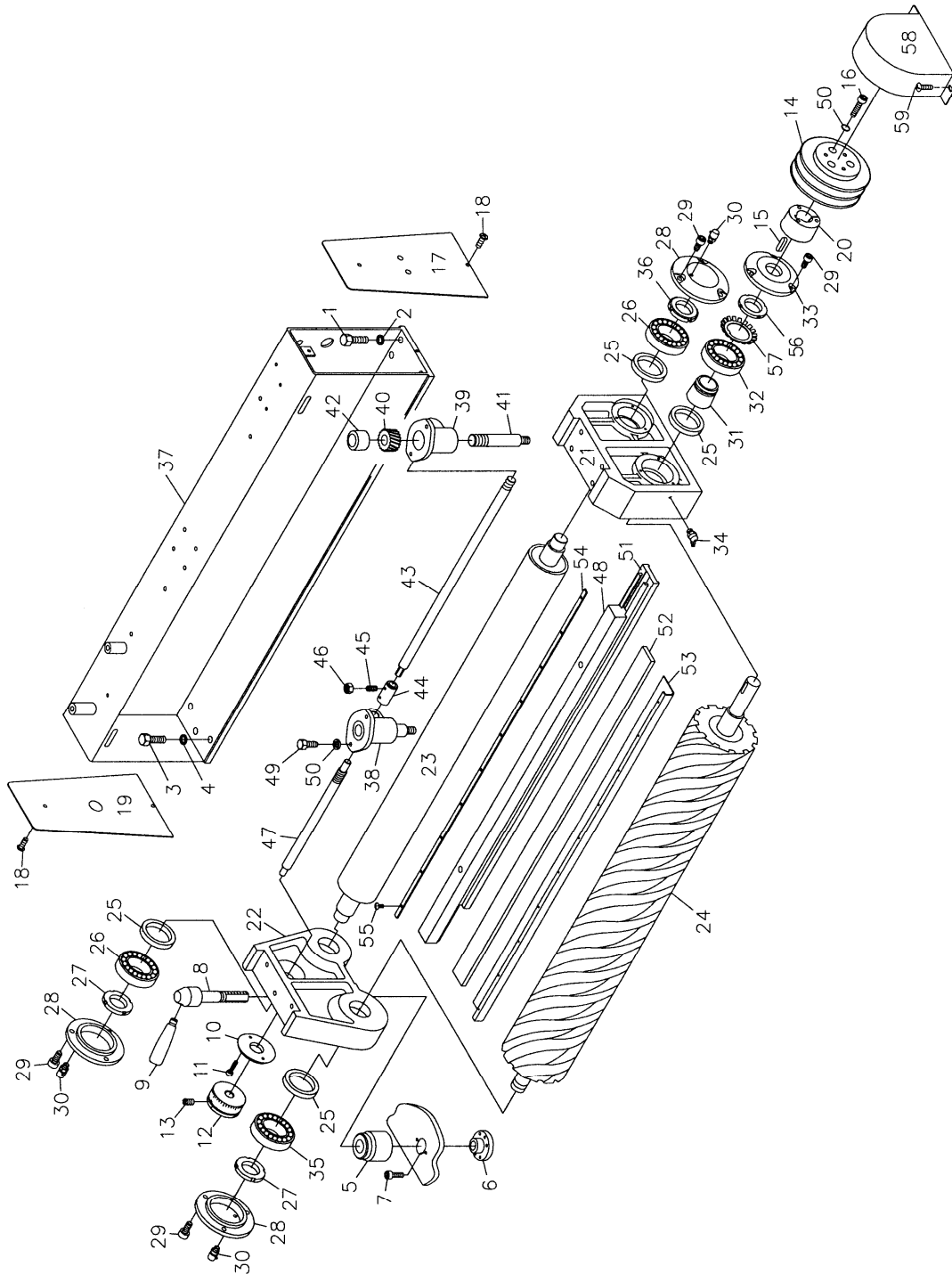
### 16.8.4 Parts List: Pressure Bar Assembly – Model WB-43

Exploded view on page 43.

Index No.	Part No.	Description	Size	Qty
1	WB25-601	Roller Slider, Female		2
2	6294391	Roller Slider, Male		2
3	6294392	Front Roller Slider, Female		1
4	6294393	Front Roller Slider, Male		1
5	6294394	Back Roller Slider, Female		1
6	6294395	Back Roller Slider, Male		1
7	6294396	Roller Adjusting Screw		4
8	6294397	Spring Pin		4
9	6294398	Spring		4
10	6294399	Roller Slider Cover		4
11	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	8
12	6294401	Roller Adjusting Knob		4
13	TS-0561031	Hex Nut	3/8-16	4
	WB43-PBA	Pressure Bar Assembly (Includes Index #14 thru #17)		1
14	6294402	Pressure Bar Shaft		4
15	6294403	Pressure Bar Cover		4
16	BB-6001ZZ	Ball Bearing	6001ZZ	8
17	6294405	Bearing Cover		8
18	TS-0267071	Set Screw	1/4-20x3/4	8
19	TS-0561011	Hex Nut	1/4-20	8
20	TS-0720081	Lock Washer	5/16	8
21	TS-0051061	Hex Head Screw	5/16-18x1-1/4	8

### 16.9.1 Platen Assembly – Model WB-25 only

Parts list on page 45.



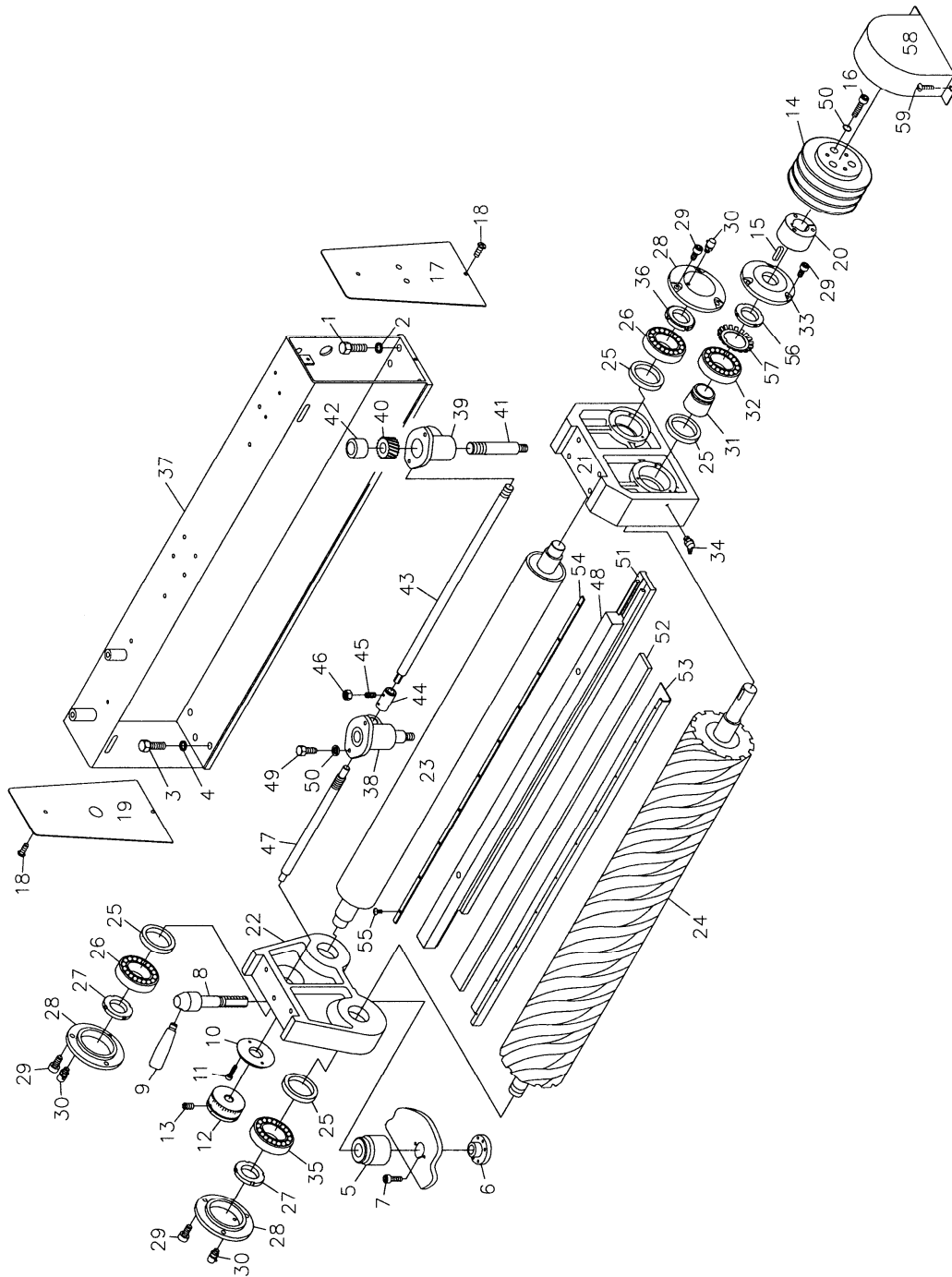
### 16.9.2 Parts List: Platen Assembly – Model WB-25

Index No.	Part No.	Description	Size	Qty
1	WB25-701	Hex Cap Screw	1/2-12x1-1/2	4
2	TS-0720111	Lock Washer	1/2	4
3	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	3
4	TS-0720091	Lock Washer	3/8	3
5	6290291	Diaphragm		1
6	6290292	Adjustment Knob		1

Index No.	Part No.	Description	Size	Qty
7	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	2
8	6290294	Screw Rod		1
9	6290295	Platen Lock Lever		1
10	6290296	Scale Ring Base		1
11	6290297	Scale Ring Base Screw	5/32x3/8	2
12	6290298	Scale Ring		1
13	TS-0267051	Set Screw	1/4-20x1/2	1
14	6290300	Roller Pulley		1
15	6290301	Key	5/16x5/16x1-3/16	1
16	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	3
17	WB25-717	Seal Plate, Right		1
18	TS-081F032	Pan Head Screw	1/4-20x1/2	4
19	WB25-719	Seal Plate, Left		1
20	WB25-720	Bushing		1
21	6290310	Bearing Base		1
22	6290311	Bearing Frame		1
23	6288623	Free Roller		1
24	6288604	Contact Roller		1
25	6290312	Oil Seal		4
26	BB-6206	Bearing	6206	2
27	6290314	Bearing Lock Nut		2
28	6290315	Bearing Cover		3
29	TS-0207021	Socket Head Cap Screw	1/4-20x1/2	12
30	6290317	Grease Fitting		3
31	6290318	Fastening Ring		1
32	6290321	Bearing	22207	1
33	6290322	Bearing Cover		1
34	6290323	Grease Fitting		1
35	6062032	Bearing	22206	1
36	6290465	Lock Nut	30mm (LH)	1
37	WB25-737	Mounting Frame		1
38	6290325	Graphite Base Gearbox, Left		1
39	6290326	Graphite Base Gearbox, Right		1
40	6290327	Gear Nut		2
41	6290328	Platen Bar Adjusting Rod		2
42	6290329	Bushing		2
43	6290330	Worm Gear Rod, Right		1
44	6290331	Worm Gear Rod Connector		1
45	TS-0267051	Set Screw	1/4-20x1/2	2
46	TS-0561011	Hex Nut	1/4-20	2
47	6290334	Worm Gear Rod, Left		1
48	6290335	Sliding Platen, Male		1
49	TS-0060051	Hex Cap Screw	3/8-16x1	4
50	TS-0720091	Lock Washer	3/8	7
51	6288601	Sliding Platen, Female		1
52	6288602	Felt		1
53	6288603	Graphite		1
54	6290339	Bar		2
55	6294433	Bar Screw		7
56	6290319	Adaptor Assembly (includes #31 and 57)		1
57	6290320	Lock Nut		1
58	WB25-758	Pulley Guard		1
59	TS-081F032	Pan Head Screw	1/4-20x1/2	2

## 16.10.1 Platen Assembly – Models WB-37, WB-43

Parts list on page 47 (WB-37) and page 48 (WB-43).



## 16.10.2 Parts List: Platen Assembly – Model WB-37

Index No.	Part No.	Description	Size	Qty
1	WB25-701	Hex Cap Screw	1/2-12x1-1/2	4
2	TS-0720111	Lock Washer	1/2	4
3	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	3
4	TS-0720091	Lock Washer	3/8	3
5	6290291	Diaphragm		1
6	6290292	Adjustment Knob		1
7	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	2

Index No.	Part No.	Description	Size	Qty
8	6290294	Screw Rod		1
9	6290295	Platen Lock Lever		1
10	6290296	Scale Ring Base		1
11	6290297	Scale Ring Base Screw	5/32x3/8	2
12	6290298	Scale Ring		1
13	TS-0267051	Set Screw	1/4-20x1/2	1
14	6288737	Roller Pulley		1
15	6290301	Key	5/16x5/16x1-3/16	1
16	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	3
17	WB37-717	Seal Plate, Right		1
18	TS-081F032	Pan Head Screw	1/4-20x1/2	4
19	WB37-719	Seal Plate, Left		1
20	WB25-720	Bushing		1
21	6290310	Bearing Base		1
22	6290311	Bearing Frame		1
23	WB37-723	Free Roller		1
24	6288704	Contact Roller		1
25	6290312	Oil Seal		4
26	BB-6206	Bearing	6206	2
27	6290314	Lock Nut		2
28	6290315	Bearing Cover		3
29	TS-0207021	Socket Head Cap Screw	1/4-20x1/2	12
30	6290317	Grease Fitting		3
31	6290318	Fastening Ring		1
32	6290321	Bearing	22207	1
33	6290322	Bearing Cover		1
34	6290323	Grease Fitting		1
35	6062032	Bearing	22206	1
36	6209465	Lock Nut	30mm (LH)	1
37	WB37-737	Mounting Frame		1
38	6290325	Graphite Base Gearbox, Left		1
39	6290326	Graphite Base Gearbox, Right		1
40	6290327	Gear Nut		2
41	6290328	Platen Bar Adjusting Rod		2
42	6290329	Bushing		2
43	6288727	Worm Gear Rod, Right		1
44	6290331	Worm Gear Rod Connector		1
45	TS-0267051	Set Screw	1/4-20x1/2	2
46	TS-0561011	Hex Nut	1/4-20	2
47	6290334	Worm Gear Rod, Left		1
48	6288728	Sliding Platen, Male		1
49	TS-0060051	Hex Cap Screw	3/8-16x1	4
50	TS-0720091	Lock Washer	3/8	7
51	6288701	Sliding Platen, Female		1
52	6288702	Felt		1
53	6288703	Graphite		1
54	6288730	Bar		1
55	6294433	Bar Screw		7
56	6290319	Adaptor Assembly (includes #31 and 57)		1
57	6290320	Lock Nut		1
58	WB37-758	Pulley Guard		1
59	TS-081F032	Pan Head Screw	1/4-20x1/2	2

### 16.10.3 Parts List: Platen Assembly – Model WB-43

Exploded view on page 47.

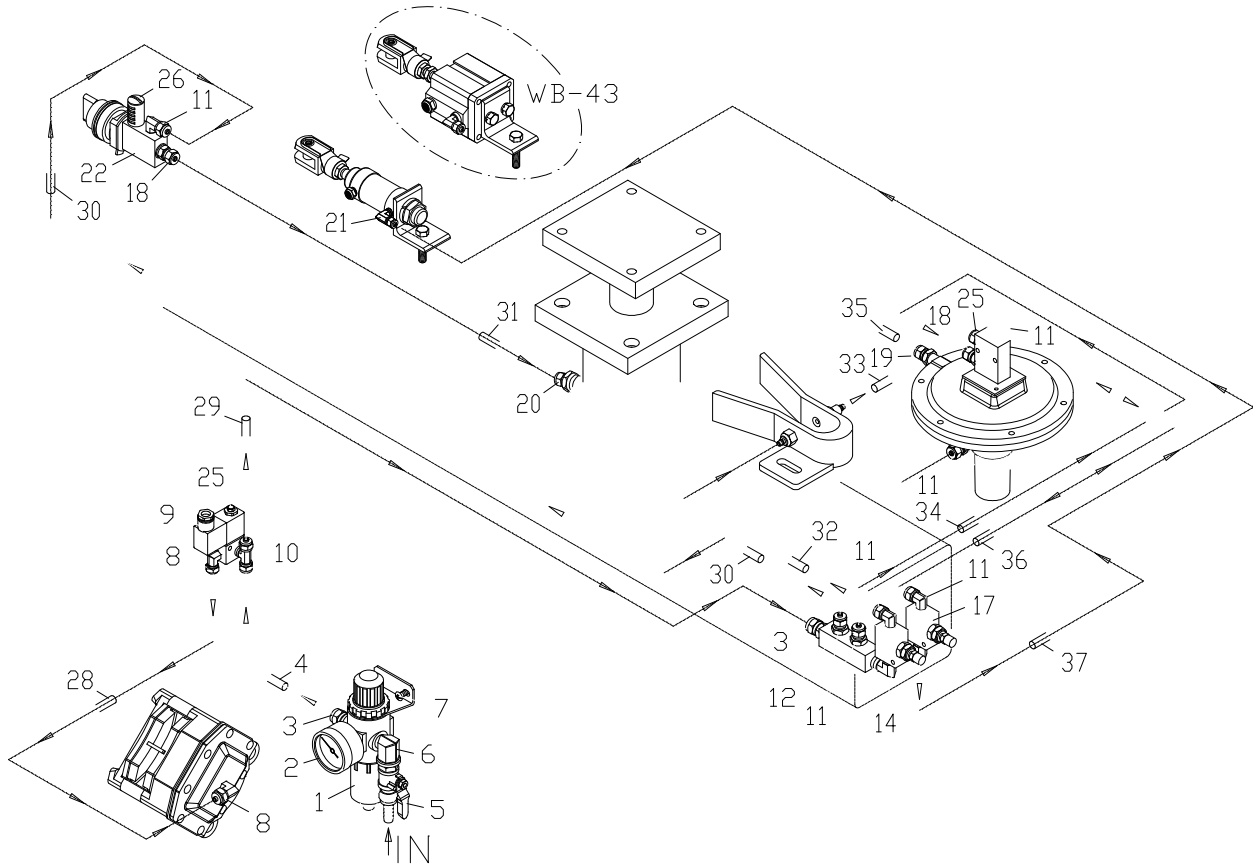
Index No.	Part No.	Description	Size	Qty
1	WB25-701	Hex Cap Screw	1/2-12x1-1/2	4
2	TS-0720111	Lock Washer	1/2	4



3	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	3
4	TS-0720091	Lock Washer	3/8	3
5	6290291	Diaphragm		1
6	6290292	Adjustment Knob		1
7	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	2
8	6290294	Screw Rod		1
9	6290295	Platen Lock Lever		1
10	6290296	Scale Ring Base		1
11	6290297	Scale Ring Base Screw	5/32x3/8	2
12	6290298	Scale Ring		1
13	TS-0267051	Set Screw	1/4-20x1/2	1
14	6288737	Roller Pulley		1
15	6290301	Key	5/16x5/16x1-3/16	1
16	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	3
17	WB43-717	Seal Plate, Right		1
18	TS-081F032	Screw	1/4-20x1/2	4
19	WB43-719	Seal Plate, Left		1
20	WB25-720	Bushing		1
21	WB43-721	Bearing Base		1
22	6290311	Bearing Frame		1
23	WB43-723	Free Roller		1
24	WB43-724	Contact Roller		1
25	6290312	Oil Seal		4
26	BB-6206	Bearing	6206	2
27	6290314	Bearing Lock Nut		2
28	6290315	Bearing Cover		3
29	TS-0207021	Socket Head Cap Screw	1/4-20x1/2	12
30	6290317	Grease Fitting		3
31	6290318	Fastening Ring		1
32	6290321	Bearing	22207	1
33	6290322	Bearing Cover		1
34	6290323	Grease Fitting		1
35	6062032	Bearing	22206	1
36	6290465	Lock Nut	30mm (LH)	1
37	WB43-737	Mounting Frame		1
38	6290325	Graphite Base Gearbox, Left		1
39	6290326	Graphite Base Gearbox, Right		1
40	6290327	Gear Nut		2
41	6290328	Platen Bar Adjusting Rod		2
42	6290329	Bushing		2
43	6294439	Worm Gear Rod, Right		1
44	6290331	Worm Gear Rod Connector		1
45	TS-0267051	Set Screw	1/4-20x1/2	2
46	TS-0561011	Hex Nut	1/4-20	2
47	6290334	Worm Gear Rod, Left		1
48	6294429	Sliding Platen, Male		1
49	TS-0060051	Hex Cap Screw	3/8-16x1	4
50	TS-0720091	Lock Washer	3/8	7
51	6294430	Sliding Platen, Female		1
52	6294431	Felt		1
53	6294432	Graphite		1
54	6294434	Bar		1
55	6294433	Screw		7
56	6290319	Adaptor Assembly (includes #31 and 57)		1
57	6290320	Lock Nut		1
58	WB37-758	Pulley Guard		1
59	TS-081F032	Pan Head Screw	1/4-20x1/2	2

### 16.11.1 Air Regulator Assembly – Models WB-25, WB-37, WB-43

Parts list on page 50 (WB-25), page 51 (WB-37) and page 52 (WB-43).



### 16.11.2 Parts List: Air Regulator Assembly – Model WB-25

Index No.	Part No.	Description	Size	Qty
	WB25-FCA	Filter Cup Assembly (index # 1,2,3,5,6,7)		1
1	6294544	Filter Cup		1
2	6294545	Pressure Regulator		1
3	6294546	Bronze Connector		2
4	6294547	Flexible Hose		1
5	6294548	Air Switch		1
6	6294549	Elbow		1
7	TS-081C042	Screw	10-24x5/8	2
8	6294551	Elbow		2
9	6294552	Solenoid Valve		1
10	6294553	T-Joint		1
11	6294554	Bronze Connector		6
12	6294555	Multiple Hole Connector		1
14	6294557	Bronze Elbow		1
17	6294560	Throttle Valve		2
18	6294561	Bronze Connector		2
19	6294562	Bronze Connector		1
20	6294563	Bronze Connector		1
21	WB25-921	Bronze Connector		1
22	6294565	Air Switch		1
25	6294568	Buffer		2
26	WB25-926	Buffer		1
28	WB25-928	Flexible Hose	φ8×700mm	1

Index No.	Part No.	Description	Size	Qty
29	6294571	Flexible Hose	ψ8×1400mm	1
30	WB25-930	Flexible Hose	ψ6×1100mm	1
31	WB25-931	Flexible Hose	ψ6×500mm	1
32	WB25-932	Flexible Hose	ψ6×560mm	1
33	6294664	Flexible Hose	ψ6×250mm	1
34	6294665	Flexible Hose	ψ6×650mm	1
35	6294666	Flexible Hose	ψ6×300mm	1
36	6294667	Flexible Hose	ψ6×650mm	1
37	WB25-937	Flexible Hose	ψ6×860mm	1

### 16.11.3 Parts List: Air Regulator Assembly – Model WB-37

Exploded view on page 50.

Index No.	Part No.	Description	Size	Qty
	WB25-FCA	Filter Cup Assembly (index # 1,2,3,5,6,7)		1
1	6294544	Filter Cup		1
2	6294545	Pressure Regulator		1
3	6294546	Bronze Connector		2
4	6294547	Flexible Hose		1
5	6294548	Air Switch		1
6	6294549	Elbow		1
7	TS-081C042	Pan Head Screw	10-24x5/8	2
8	6294551	Elbow		2
9	6294552	Solenoid Valve		1
10	6294553	T-Joint		1
11	6294554	Bronze Connector		6
12	6294555	Multiple Hole Connector		1
14	6294557	Bronze Elbow		1
17	6294560	Throttle Valve		2
18	6294561	Bronze Connector		2
19	6294562	Bronze Connector		1
20	6294563	Bronze Connector		1
21	WB25-921	Bronze Connector		1
22	6294565	Air Switch		1
25	6294568	Buffer		2
26	WB25-926	Buffer		1
28	WB25-928	Flexible Hose	ψ8×700mm	1
29	6294571	Flexible Hose	ψ8×1400mm	1
30	WB37-930	Flexible Hose	ψ6×1420mm	1
31	WB37-931	Flexible Hose	ψ6×620mm	1
32	WB25-932	Flexible Hose	ψ6×560mm	1
33	6294664	Flexible Hose	ψ6×250mm	1
34	6294665	Flexible Hose	ψ6×650mm	1
35	6294666	Flexible Hose	ψ6×300mm	1
36	6294667	Flexible Hose	ψ6×650mm	1
37	WB37-937	Flexible Hose	ψ6×1350mm	1

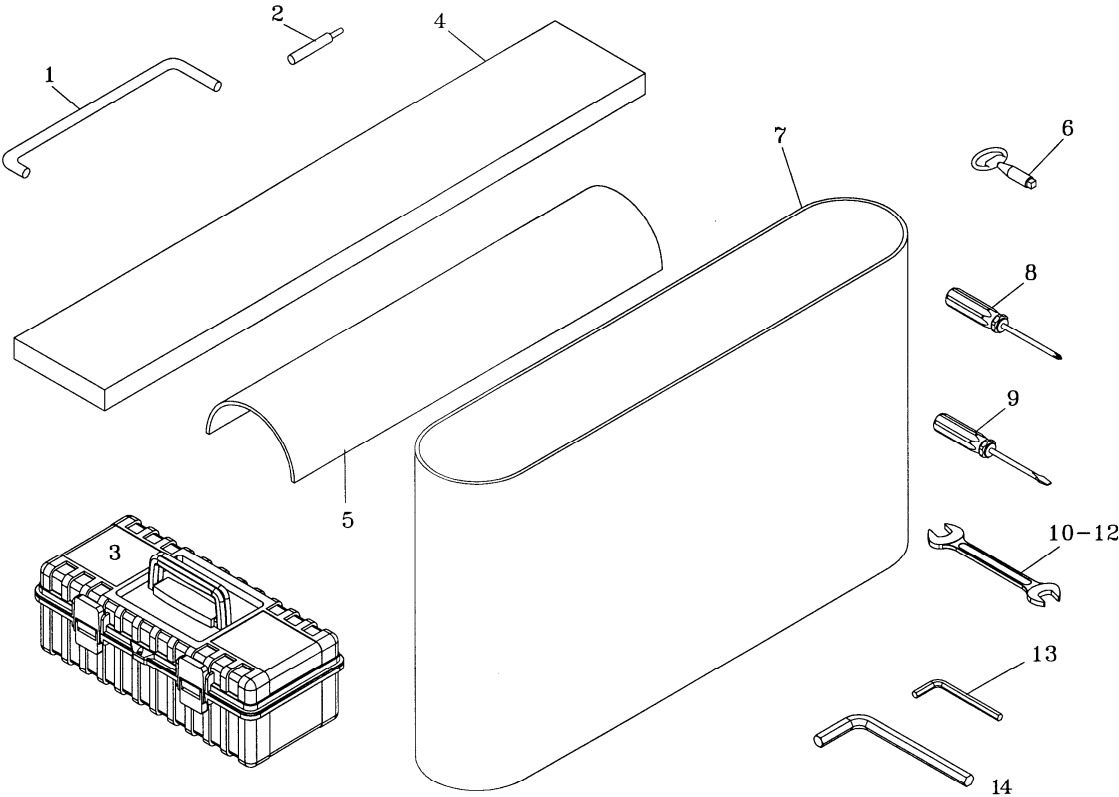
## 16.11.4 Parts List: Air Regulator Assembly – Model WB-43

Exploded view on page 50.

Index No.	Part No.	Description	Size	Qty
	WB25-FCA	Filter Cup Assembly (index # 1,2,3,5,6,7)		1
1	6294544	Filter Cup		1
2	6294545	Pressure Regulator		1
3	6294546	Bronze Connector		2
4	6294547	Flexible Hose		1
5	6294548	Air Switch		1
6	6294549	Elbow		1
7	TS-081C042	Screw	10-24x5/8	2
8	6294551	Elbow		2
9	6294552	Solenoid Valve		1
10	6294553	T-Joint		3
11	6294554	Bronze Connector		6
12	6294555	Multiple Hole Connector		1
14	6294557	Bronze Elbow		1
17	6294560	Throttle Valve		2
18	6294561	Bronze Connector		2
19	6294562	Bronze Connector		1
20	6294563	Bronze Connector		1
21	WB43-921	Bronze Connector		1
22	6294565	Air Switch		1
25	6294568	Buffer		2
26	WB25-926	Buffer		1
28	WB25-928	Flexible Hose	ψ8×700mm	1
29	6294571	Flexible Hose	ψ8×1400mm	1
30	6294657	Flexible Hose	ψ6×1600mm	1
31	6294658	Flexible Hose	ψ6×750mm	1
32	6294663	Flexible Hose	ψ6×600mm	1
33	6294664	Flexible Hose	ψ6×250mm	1
34	6294665	Flexible Hose	ψ6×650mm	1
35	6294666	Flexible Hose	ψ6×300mm	1
36	6294667	Flexible Hose	ψ6×650mm	1
37	6294662	Flexible Hose	ψ6×1500mm	1

16.12.1 Sanding Belt and Accessories – Models WB-25, WB-37, WB-43

Parts list on page 54.



### 16.12.2 Parts List: Sanding Belt and Accessories – Model WB-25

Exploded view on page 53.

Index No.	Part No.	Description	Size	Qty
1	6290281	Platen Pull Hook		1
2	6294461	Limit Switch Tube		2
3	WB25-1003	Tool Box		1
4	6288602	Felt		1
5	6288603	Graphite		2
6	6294256	Door Lock Key		2
7		Sanding Belt (local purchase)	25"x75" (100 Grit)	1
		Sanding Belt (local purchase)	25"x75" (180 Grit)	1
8	WB25-1008	Cross Point Screwdriver		1
9	WB25-1009	Flat Blade Screwdriver		1
10	WB25-1010	Open End Wrench	8/10 mm	1
11	WB25-1011	Open End Wrench	12/14 mm	1
12	WB25-1012	Open End Wrench	17/19 mm	1
13	WB25-1013	Hex Wrench Set		1
14	WB25-1014	Adjusting Rod		1

### 16.12.3 Parts List: Sanding Belt and Accessories – Model WB-37

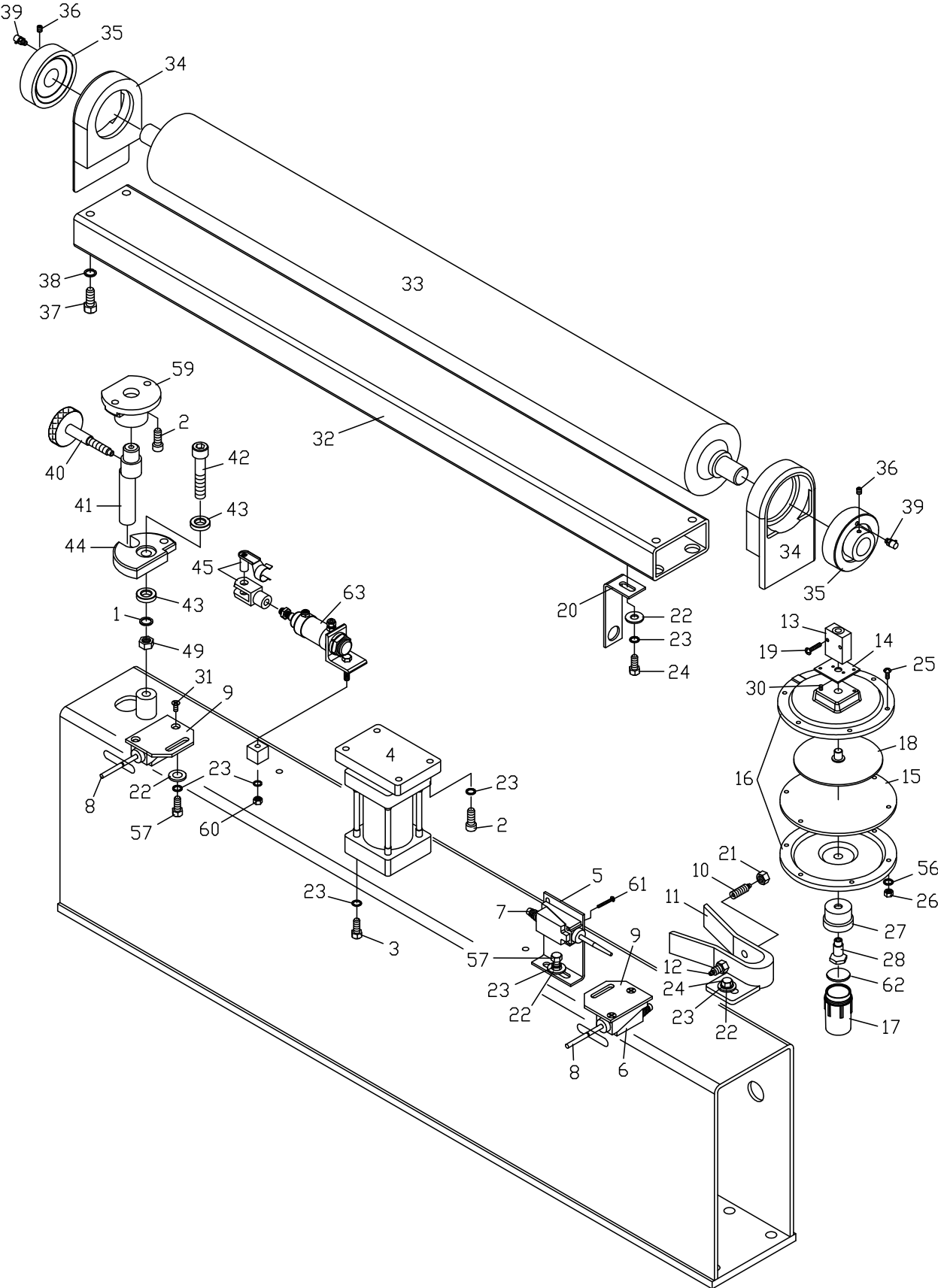
Index No.	Part No.	Description	Size	Qty
1	6290281	Platen Pull Hook		1
2	6294461	Limit Switch Tube		2
3	WB25-1003	Tool Box		1
4	6288702	Felt		1
5	6288703	Graphite		2
6	6294256	Door Lock Key		2
7		Sanding Belt (local purchase)	37"x75" (100Grit)	1
		Sanding Belt (local purchase)	37"x75" (180Grit)	1
8	WB25-1008	Cross Point Screwdriver		1
9	WB25-1009	Flat Blade Screwdriver		1
10	WB25-1010	Open End Wrench	8/10 mm	1
11	WB25-1011	Open End Wrench	12/14 mm	1
12	WB25-1012	Open End Wrench	17/19 mm	1
13	WB25-1013	Hex Wrench Set		1
14	WB25-1014	Adjusting Rod		1

### 16.12.4 Parts List: Sanding Belt and Accessories – Model WB-43

Index No.	Part No.	Description	Size	Qty
1	6290281	Platen Pull Hook		1
2	6294461	Limit Switch Tube		2
3	WB25-1003	Tool Box		1
4	6294431	Felt		1
5	6294432	Graphite		2
6	6294256	Door Lock Key		2
7		Sanding Belt (local purchase)	43"x75" (100Grit)	1
		Sanding Belt (local purchase)	43"x75" (180Grit)	1
8	WB25-1008	Cross Point Screwdriver		1
9	WB25-1009	Flat Blade Screwdriver		1
10	WB25-1010	Open End Wrench	8/10 mm	1
11	WB25-1011	Open End Wrench	12/14 mm	1
12	WB25-1012	Open End Wrench	17/19 mm	1
13	WB25-1013	Hex Wrench Set		1
14	WB25-1014	Adjusting Rod		1

### 16.13.1 Tension Roller Assembly – Models WB-25 and WB-37 ONLY

Parts list on page 56 (WB-25) and page 57 (WB-37).



## 16.13.2 Parts List: Tension Roller Assembly – Model WB-25

Exploded view on page 55.

Index No.	Part No.	Description	Size	Qty
1	TS-0720111	Lock Washer	1/2	1
2	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	6
3	TS-1490031	Hex Cap Screw	M8x20	4
4	WB25-104	Air Cylinder 63-30		1
5	6294459	Limit Switch Holder (L Type)		1
6	6294460	Limit Switch		2
7	6294653	Limit Switch		1
8	6294461	Limit Switch Tube		2
9	6294462	Limit Switch Holder		2
10	6294463	Air Sensor Nozzle (Female)		1
11	6294464	Air Cylinder Bracket		1
12	6294465	Air Sensor Nozzle (Male)		1
13	6294466	Throttle Valve		1
14	6294467	Throttle Valve Base		1
15	6294468	Plate		1
16	6294469	Aluminum Disc		1
17	6294470	Oil Cup		1
18	6294471	Aluminum Plate		1
19	TS-2284202	Pan Head Screw	M4x20	2
20	WB25-120	Sanding Belt Power Off Plate		1
21	TS-0561032	Hex Nut	3/8-24	2
22	TS-0680031	Flat Washer	5/16	5
23	TS-0720081	Lock Washer	5/16	14
24	TS-0081031	Hex Cap Screw	5/16-18x3/4	5
25	TS-0206041	Socket Head Cap Screw	10-24x3/4	6
26	TS-0560071	Hex Nut	10-24	6
27	6294478	Connector, Oil Cap		1
28	6294479	Shaft, Oil Cup		1
29	TS-0208111	Socket Head Cap Screw	5/16-18x2-1/4	1
30	TS-1532032	Pan Head Screw	M4x10	2
31	WB25-131	Flat Head Screw	M5x8	4
32	WB25-132	Upper Roller Frame		1
33	WB25-133	Upper Roller		1
34	WB25-134	Bearing Housing		2
35	WB25-135	Bearing	C205	2
36	TS-1523011	Set Screw	M6x6	4
37	TS-0209031	Socket Head Cap Screw	3/8-16x3/4	4
38	TS-0720091	Lock Washer	3/8	2
39	WB25-139	Grease Fitting with Cover		2
40	6294490	Trimming Screw		1
41	6294491	Eccentric Rod		1
42	WB25-142	Socket Head Cap Screw	1/2-12x3-1/2	1
43	6294265	Copper Plate		2
44	6294493	Eccentric Piece		1
45	6294494	Universal Joint Fork		1
46	JWP15H-224	Retaining Ring	STW-15	1
47	TS-1540071	Hex Nut	M10	1
48	6294496	Shaft, Air Cylinder		1
49	WB25-149	Hex Nut	1/2-12	1
56	TS-0720051	Lock Washer	#10	6
57	TS-0051011	Hex Cap Screw	5/16-18x1/2	3
59	WB25-159	Eccentric Shaft Housing		1
60	TS-0561021	Hex Nut	5/16-18	1



Index No.	Part No.	Description	Size	Qty
61	TS-1533032	Pan Head Screw	M5x10	6
62	WB25-162	Seal		1
63	WB25-ACA	Air Cylinder Assembly		1

### 16.13.3 Parts List: Tension Roller Assembly – Model WB-37

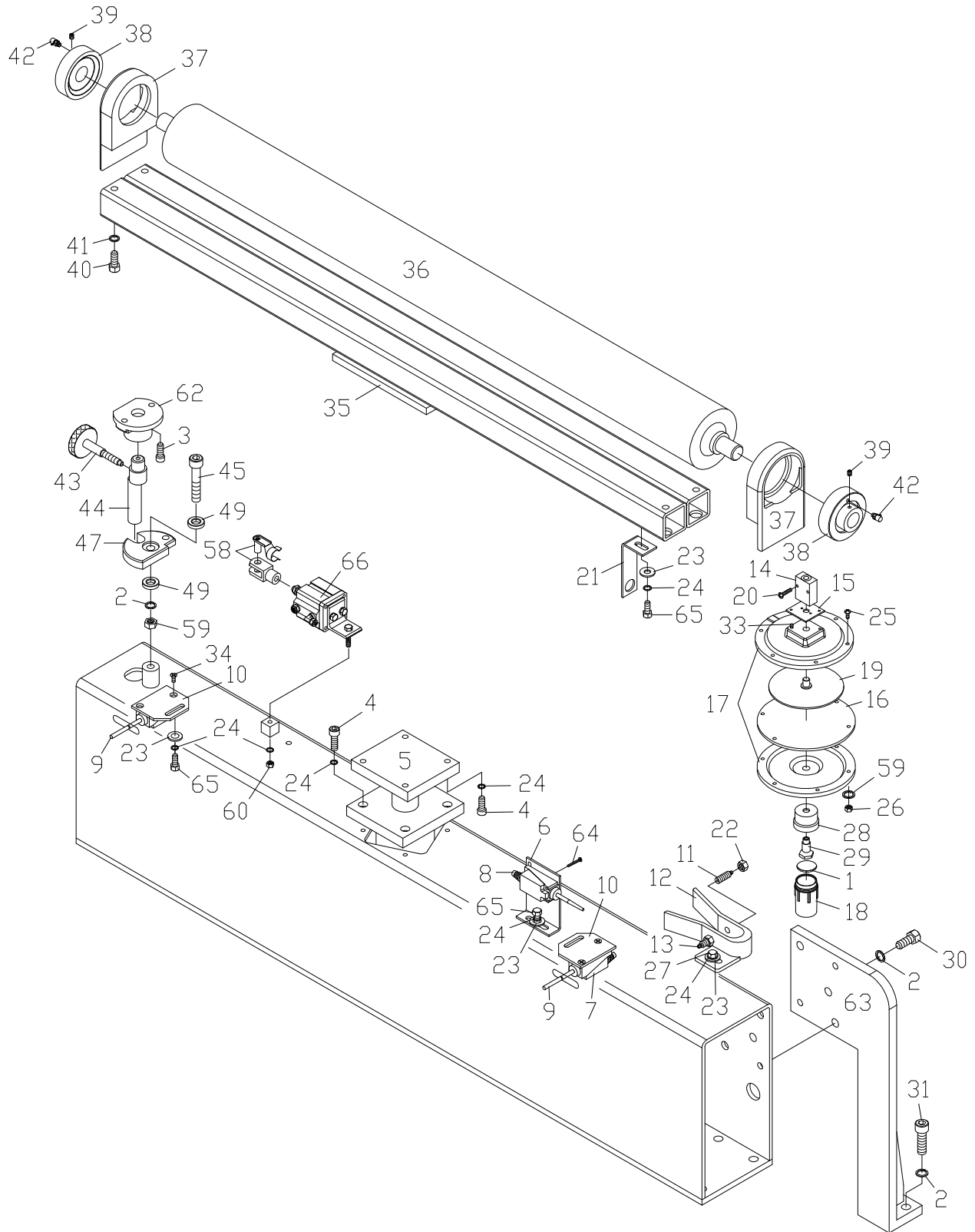
Exploded view on page 55.

Index No.	Part No.	Description	Size	Qty
1	TS-0720111	Lock Washer	1/2	1
2	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	6
3	TS-1490031	Hex Cap Screw	M8x20	4
4	WB25-104	Air Cylinder 63-30		1
5	6294459	Limit Switch Holder (L Type)		1
6	6294460	Limit Switch		2
7	6294653	Limit Switch		1
8	6294461	Limit Switch Tube		2
9	6294462	Limit Switch Holder		2
10	6294463	Air Sensor Nozzle (Female)		1
11	6294464	Air Cylinder Bracket		1
12	6294465	Air Sensor Nozzle (Male)		1
13	6294466	Throttle Valve		1
14	6294467	Throttle Valve Base		1
15	6294468	Plate		1
16	6294469	Aluminum Disc		1
17	6294470	Oil Cup		1
18	6294471	Aluminum Plate		1
19	TS-2284202	Pan Head Screw	M4x20	2
20	WB25-120	Sanding Belt Power Off Plate		1
21	TS-0561032	Hex Nut	3/8-24	2
22	TS-0680031	Flat Washer	5/16	5
23	TS-0720081	Lock Washer	5/16	14
24	TS-0081031	Hex Cap Screw	5/16-18x3/4	5
25	TS-0206041	Socket Head Cap Screw	10-24x3/4	6
26	TS-0560071	Hex Nut	10-24	6
27	6294478	Connector, Oil Cap		1
28	6294479	Shaft, Oil Cup		1
29	TS-0208111	Socket Head Cap Screw	5/16-18x2-1/4	1
30	TS-1532032	Pan Head Screw	M4x10	2
31	WB25-131	Flat Head Screw	M5x8	4
32	WB37-132	Upper Roller Frame		1
33	WB37-133	Upper Roller		1
34	WB25-134	Bearing Housing		2
35	WB25-135	Bearing	C205	2
36	TS-1523011	Set Screw	M6x6	4
37	TS-0209031	Socket Head Cap Screw	3/8-16x3/4	4
38	TS-0720091	Lock Washer	3/8	2
39	WB25-139	Grease Fitting with Cover		2
40	6294490	Trimming Screw		1
41	6294491	Eccentric Rod		1
42	WB25-142	Socket Head Cap Screw	1/2-12x3-1/2	1
43	6294265	Copper Plate		2
44	6294493	Eccentric Piece		1
45	6294494	Universal Joint Fork		1
46	JWP15H-224	Retaining Ring	STW-15	1
47	TS-1540071	Hex Nut	M10	1
48	6294496	Shaft, Air Cylinder		1

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
49	WB25-149	Hex Nut	1/2-12	1
56	TS-0720051	Lock Washer	#10	6
57	TS-0051011	Hex Cap Screw	5/16-18x1/2	3
59	WB25-159	Eccentric Shaft Housing		1
60	TS-0561021	Hex Nut	5/16-18	1
61	TS-1533032	Pan Head Screw	M5x10	6
62	WB25-162	Seal		1
63	WB25-ACA	Air Cylinder Assembly		1

# 16.14.1 Tension Roller Assembly – Model WB-43 ONLY

Parts list on page 60.



## 16.14.2 Parts List: Tension Roller Assembly – Model WB-43

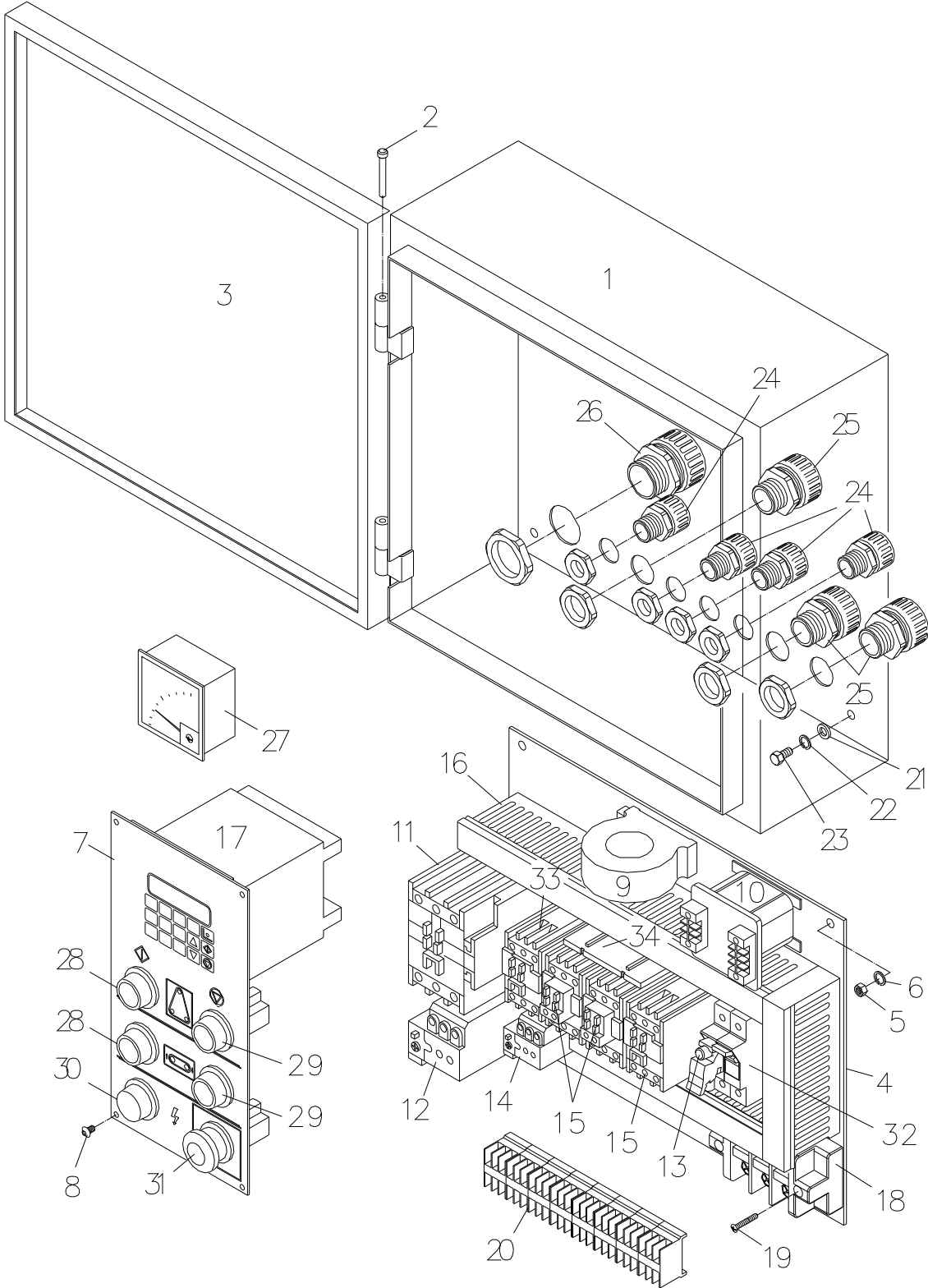
Exploded view on page 59.

Index No.	Part No.	Description	Size	Qty
1	WB25-162	Seal		1
2	TS-0720111	Lock Washer	1/2	7
3	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	6
4	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	4
5	6294458	Air Cylinder		1
6	6294459	Limit Switch Holder (L Type)		1
7	6294460	Limit Switch		2
8	6294653	Limit Switch		1
9	6294461	Limit Switch Tube		2
10	6294462	Limit Switch Holder		2
11	6294463	Air Sensor Nozzle (Female)		1
12	6294464	Air Cylinder Bracket		1
13	6294465	Air Sensor Nozzle (Male)		1
14	6294466	Throttle Valve		1
15	6294467	Throttle Valve Base		1
16	6294468	Plate		1
17	6294469	Aluminum Disc		1
18	6294470	Oil Cup		1
19	6294471	Aluminum Plate		1
20	TS-2284202	Pan Head Screw	M4x20	2
21	6294473	Sanding Belt Power Off Plate		1
22	TS-0561032	Hex Nut	3/8-24	2
23	TS-0680031	Flat Washer	5/16	5
24	TS-0720081	Lock Washer	5/16	14
25	TS-0206041	Socket Head Cap Screw	10-24x3/4	6
26	TS-0560071	Hex Nut	10-24	6
27	TS-0081031	Hex Cap Screw	5/16-18x3/4	5
28	6294478	Connector, Oil Cap		1
29	6294479	Shaft, Oil Cup		1
30	WB43-130	Hex Cap Screw	1/2-12x1	4
31	WB43-131	Socket Head Cap Screw	1/2-12x1-3/4	2
32	TS-0208081	Socket Head Cap Screw	5/16-18x1-1/2	1
33	TS-1532032	Pan Head Screw	M4x10	2
34	WB25-131	Flat Head Screw	M5x8	4
35	WB43-135	Upper Roller Frame		2
36	WB43-136	Upper Roller		1
37	WB25-134	Bearing Housing		2
38	WB25-135	Bearing	C205	2
39	TS-1523011	Set Screw	M6x6	4
40	TS-0209031	Socket Head Cap Screw	3/8-16x3/4	4
41	TS-0720091	Lock Washer	3/8	2
42	WB25-139	Grease Fitting with Cover		2
43	6294490	Trimming Screw		1
44	6294491	Eccentric Rod		1
45	WB25-142	Socket Head Cap Screw	1/2-12x3-1/2	1
46	JWP15H-224	Retaining Ring	STW-15	1
47	6294493	Eccentric Piece		1
48	6294496	Shaft, Air Cylinder		1
49	6294265	Copper Plate		2
56	TS-0720051	Lock Washer	#10	6
57	TS-1540071	Hex Nut	M10	1
58	6294494	Universal Joint Fork		1
59	WB25-149	Hex Nut	1/2-12	1
60	TS-0561021	Hex Nut	5/16-18	1
62	WB25-159	Eccentric Shaft Housing		1

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
63	WB43-163	Frame Support		1
64	TS-1533032	Pan Head Screw	M5x10	6
65	TS-0051011	Hex Cap Screw	5/16-18x1/2	4
66	WB43-ACA	Air Cylinder Assembly		1

**16.15.1 Electrical Box Assembly – Models WB-25 and WB-37**

Parts list on page 63 (WB-25) and 64 (WB-37).



## 16.15.2 Parts List: Electrical Box Assembly – Model WB-25

Exploded view on page 62.

Index No.	Part No.	Description	Size	Qty
1	WB25-801	Electrical Control Box		1
2	6294516	Hinge Pin		2
3	WB25-803	Electrical Control Box Door		1
4	WB25-804	Base Plate		1
5	TS-0561011	Hex Nut	1/4-20	4
6	TS-0720071	Lock Washer	1/4	4
7	WB25-807	Control Panel		1
8	WB25-808	Button Head Socket Screw	M4x8	4
9	WB25-809	Proportional Current Device		1
10	WB25-810	Transformer		1
	WB25-COR	Contactor & Overload Relay (for 230V) (includes #11, 12) *		1
	WB25-CORA	Contactor & Overload Relay (for 460V) (includes #11, 12) *		1
11	WB25-811A	Contactor		1
12	WB25-812B	Overload Relay (for 230V)		1
	WB25-812C	Overload Relay (for 460V)		1
13	WB25-813	Fuse	4A	2
14	WB25-814	Overload Relay (for 230V)		1
	WB25-814A	Overload Relay (for 460V)		1
15	6294647	Contactor	CN-11	3
16	WB25-816	Wire Column		1
17	WB25-817	Controller		1
18	WB25-818	Power Wire Terminal		1
19	WB25-819	Tap Screw	M4x10	2
20	WB25-820	Terminal Board		8
21	TS-0680021	Flat Washer	1/4	4
22	TS-0720071	Lock Washer	1/4	4
23	TS-081F032	Pan Head Screw	1/4-20x1/2	4
24	6294532	PU Connector 1/2"		4
25	6294533	PU Connector 3/4"		3
26	6294534	Cable Connector 1"		1
27	WB25-827	Amp Meter		1
28	6294537	Start Switch		2
29	6294538	Stop Switch		2
30	6294539	Power Indication Light		1
31	6294540	Emergency Stop Switch		1
32	WB25-832	Fuse Support Base		2
33	WB25-833	Contactor (Feed Motor only)		1
34	WB25-834	Plate		1

\* For WB-25 sanders with serial number 1909WB25008 *and lower*, you must purchase this contactor/relay kit. For serial numbers higher than this, you may purchase this kit or the individual elements.

### 16.15.3 Parts List: Electrical Box Assembly – Model WB-37

Exploded view on page 62.

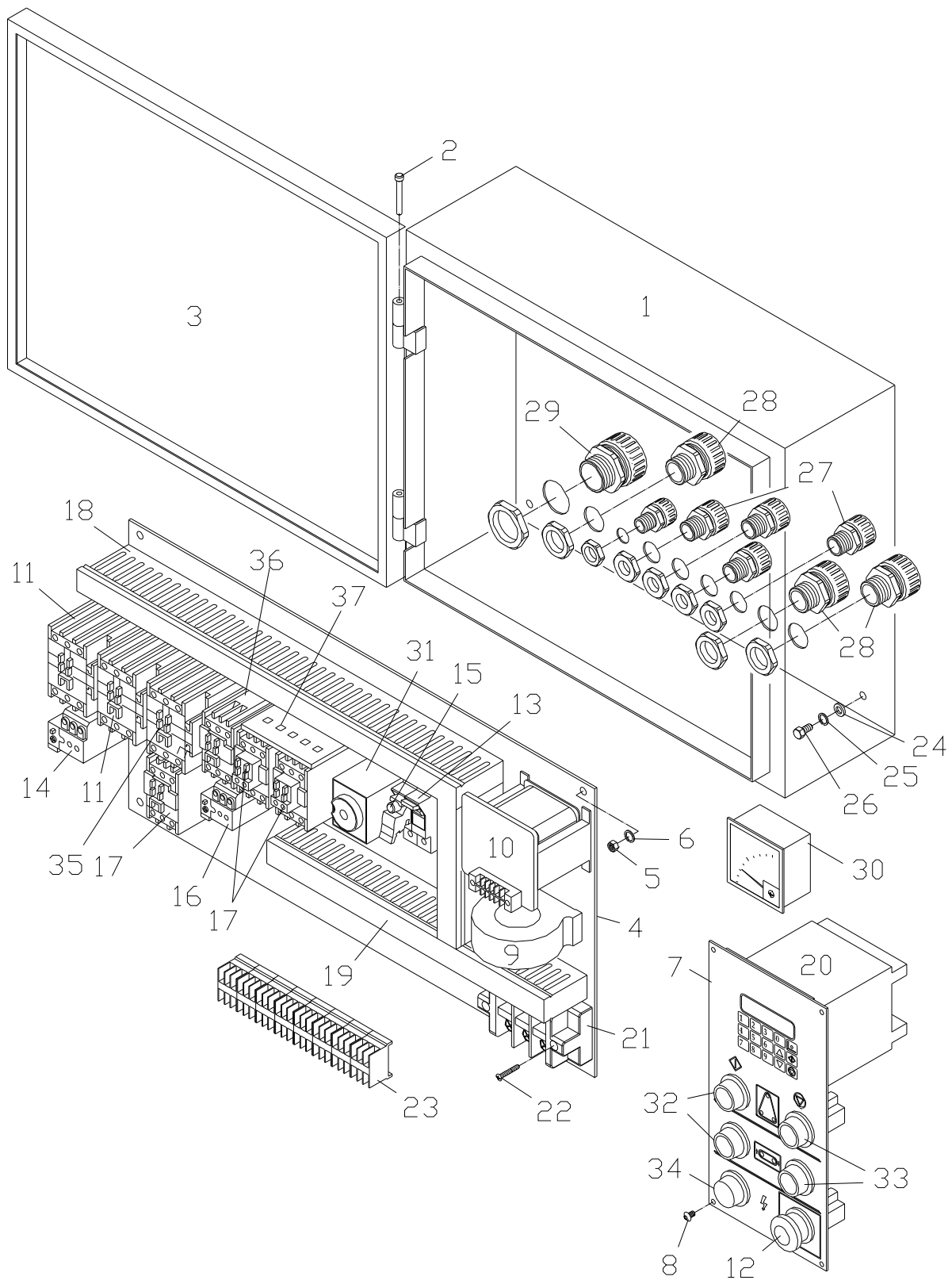
Index No.	Part No.	Description	Size	Qty
1	WB25-801	Electrical Control Box		1
2	6294516	Hinge Pin		2
3	WB25-803	Electrical Control Box Door		1
4	WB25-804	Base Plate		1
5	TS-0561011	Hex Nut	1/4-20	4
6	TS-0720071	Lock Washer	1/4	4
7	WB25-807	Control Panel		1
8	WB25-808	Button Head Socket Screw	M4x8	4
9	WB25-809	Proportional Current Device		1
10	WB25-810	Transformer		1
	WB37-COR	Contacto & Overload Relay (for 230V) (includes #11,12) *		1
	WB37-CORA	Contacto & Overload Relay (for 460V) (includes #11,12) *		1
11	WB37-811A	Contacto		1
12	WB37-812B	Overload Relay (for 230V)		1
	WB37-812C	Overload Relay (for 460V)		1
13	WB25-813	Fuse	4A	2
14	WB25-814	Overload Relay (for 230V)		1
	WB25-814A	Overload Relay (for 460V)		1
15	6294647	Contacto	CN-11	3
16	WB25-816	Wire Column		1
17	WB25-817	Controller		1
18	WB25-818	Power Wire Terminal		1
19	WB25-819	Tap Screw	M4x10	2
20	WB25-820	Terminal Board		8
21	TS-0680021	Flat Washer	1/4	4
22	TS-0720071	Lock Washer	1/4	4
23	TS-081F032	Pan Head Screw	1/4-20x1/2	4
24	6294532	PU Connector 1/2"		4
25	6294533	PU Connector 3/4"		3
26	6294534	Cable Connector 1"		1
27	WB25-827	Amp Meter		1
28	6294537	Start Switch		2
29	6294538	Stop Switch		2
30	6294539	Power Indication Light		1
31	6294540	Emergency Stop Switch		1
32	WB25-832	Fuse Support Base		2
33	WB25-833	Contacto (Feed Motor only)		1
34	WB25-834	Plate		1

\* For WB-37 sanders with serial number 1909WB37004 *and lower*, you must purchase this contactor/relay kit. For serial numbers higher than this, you may purchase this kit or the individual elements.



### 16.16.1 Electrical Box Assembly – Model WB-43 ONLY

Parts list on page 66.



## 16.16.2 Parts List: Electrical Box Assembly – Model WB-43

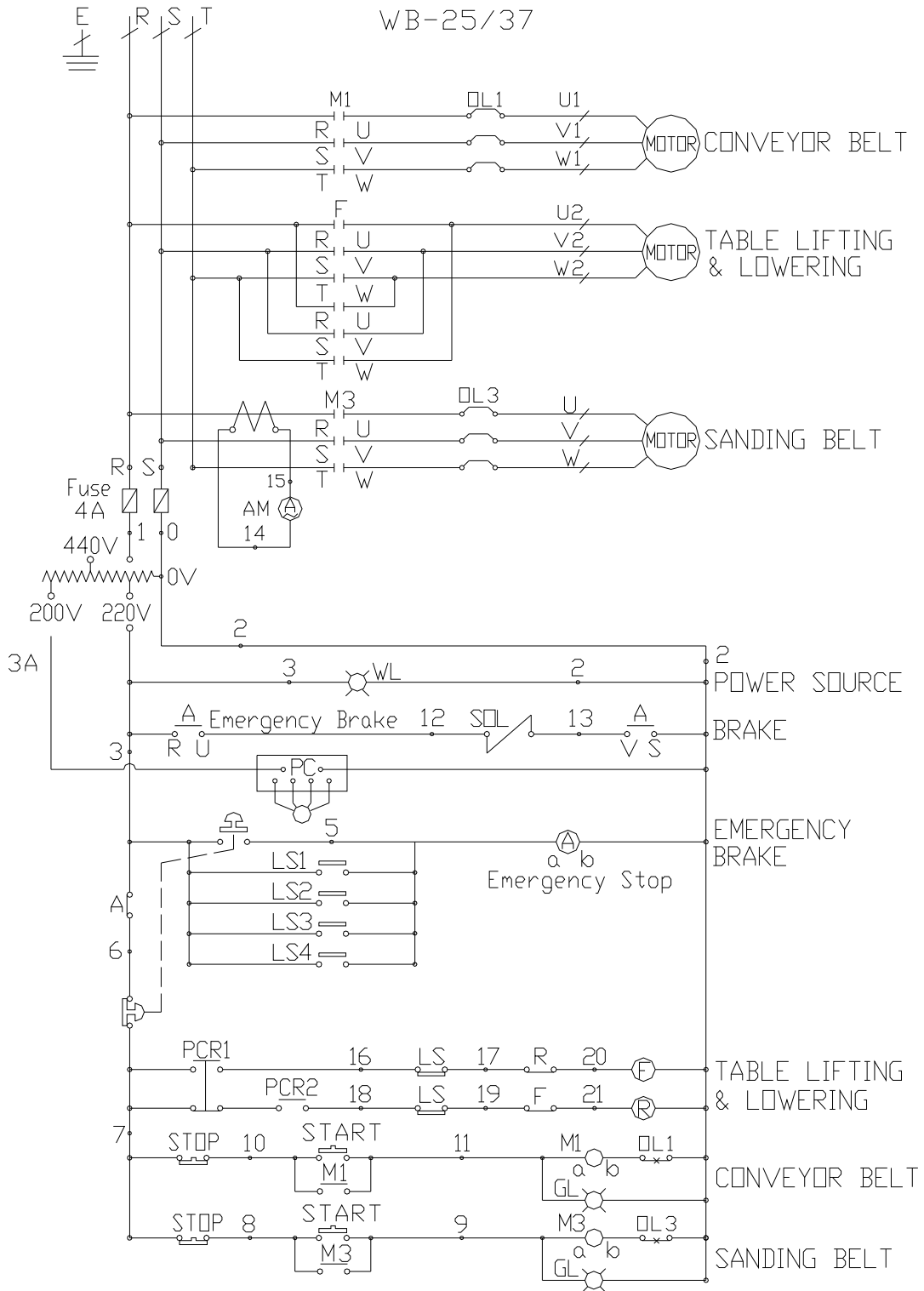
Exploded view on page 65.

Index No.	Part No.	Description	Size	Qty
1	WB43-801	Electrical Control Box		1
2	6294516	Hinge Pin		2
3	WB43-803	Electrical Control Box Door		1
4	6294518	Base Plate		1
5	TS-0561011	Hex Nut	1/4-20	4
6	TS-0720071	Lock Washer	1/4	4
7	WB25-807	Control Panel		1
8	WB25-808	Button Head Socket Screw	M4x8	4
9	WB25-809	Proportional Current Device		1
10	WB43-810	Transformer		1
	WB43-COR	Contactor & Overload Relay (for 230V) * (Includes #11, 14, 35)		1
	WB43-COR	Contactor & Overload Relay (for 460V) * (Includes #11, 14, 35)		1
11	WB43-811	Contactor	CU-40R	2
12	6294540	Emergency Stop Switch		1
13	WB25-832	Fuse Support Base		2
14	WB43-814B	Overload Relay (for 230V)		1
	WB43-814C	Overload Relay (for 460V)		1
15	WB25-813	Fuse	4A	2
16	WB43-816	Overload Relay (for 230V)		1
	WB43-816A	Overload Relay (for 460V)		1
17	6294647	Contactor	CN-11	3
18	WB43-818	Wire Column		1
19	WB43-819	Wire Column		1
20	WB25-817	Controller		1
21	WB43-821	Power Wire Terminal		1
22	WB25-819	Tap Screw	M4x10	2
23	WB43-823	Terminal Board		8
24	TS-0680021	Flat Washer	1/4	4
25	TS-0720071	Lock Washer	1/4	4
26	TS-081F032	Pan Head Screw	1/4-20x1/2	4
27	6294532	PU Connector 1/2"		4
28	6294533	PU Connector 3/4"		3
29	6294534	Cable Connector 1"		1
30	WB25-827	Amp Meter		1
31	WB43-831	Timer		1
32	6294537	Start Switch		2
33	6294538	Stop Switch		2
34	6294539	Power Indication Light		1
35	WB43-835	Contactor	CU-32R	1
36	WB25-833	Contactor (Feed Motor only)		1
37	WB25-834	Plate		1

\* For WB-43 sanders with serial number 1812WB43011 *and lower*, you must purchase this contactor/relay kit. For serial numbers higher than this, you may purchase this kit or the individual elements.

# 17.0 Electrical Connections

## 17.1 Models WB-25 and WB-37 ONLY



## 17.2 Model WB-43 ONLY

