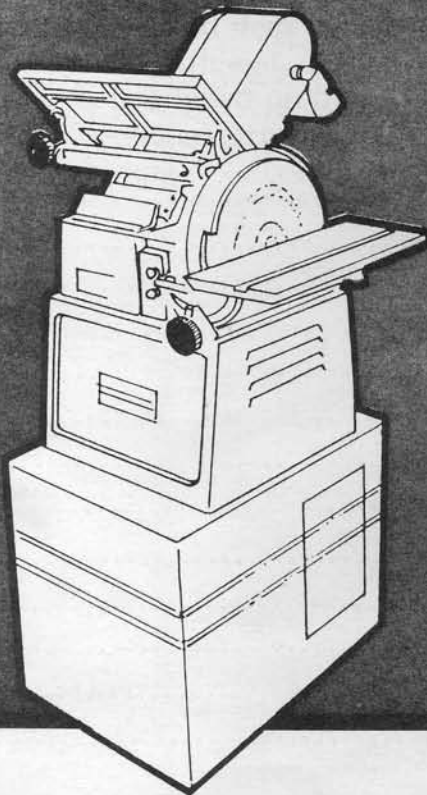


# MAINTENANCE INSTRUCTION AND PARTS LIST

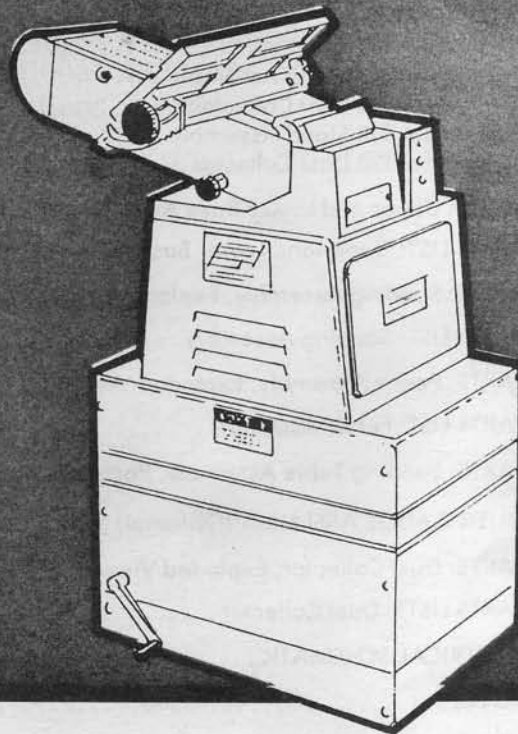
## 30-B

*COMBINATION BELT  
and DISC SANDER*



## 33-B

*BELT SANDER*



**Better By Design™**

# **POWERMATIC®**

McMINNVILLE, TENNESSEE 37110 ☐ AC 615-473-5551

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# FOREWORD

This manual has been prepared for the owner and those responsible for the maintenance of a **Powermatic Model 33-B Belt Sander** and a **Model 30-B Combination Belt and Disc Sander**.

Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Read the safety and maintenance instructions thoroughly before operating or servicing the machine.

In order to obtain maximum life and efficiency from your **Powermatic** sander and to aid in operating and maintaining the sander with safety, read this manual thoroughly and follow all instructions carefully.

The specifications put forth in this manual were in effect at the time of publication. However, owing to **Powermatic's** policy of continuous improvement, changes to these specifications may be made at any time without obligation on the part of **Powermatic**.

The information and recommendations contained in this publication come from sources believed to be reliable and to represent the best current practice. **Powermatic** does not intend this manual to be a complete course of instruction on how to use this machine with safety and does not guarantee or represent that the information is absolutely correct or sufficient. In addition, it cannot be assumed that all acceptable safety measures are listed or that other additional measures are not needed under particular or exceptional circumstances or conditions.

## Powermatic Warranty

Powermatic, a Division of DeVlieg-Bullard Inc., Morrison Road, McMinnville, Tennessee 37110 ("Powermatic") warrants to its authorized distributors for Powermatic products and the original purchasers for such distributors, all products manufactured by Powermatic to be free of defects in material and workmanship for a period of twelve (12) months from the date of delivery from its authorized distributors or 2000 hours of use, whichever occurs first. During said warranty period Powermatic will, at its option, repair or replace any product (or component part thereof) proving defective during said period. This warranty applies only to products which are used in accordance with all instructions as to operation, maintenance and safety set forth in the catalogs, manuals, and/or instruction sets furnished by Powermatic. This warranty becomes effective only if the accompanying card is fully and properly completed and returned to Powermatic within ten (10) days from date of delivery to the original purchaser.

This warranty does not apply to items that would normally be consumed or require replacement due to normal wear (blades, lubricants, etc.); to electrical motors and components which are warranted by their manufacturer; or the costs of removal, shipment for service and reinstallation. Claims relating to the electrical components must be taken to the component manufacturer's local authorized repair station for service.

This warranty is null and void if the product has been subjected to (1) misuse, abuse or improper service or storage; (2) accident, neglect, damage or other cir-

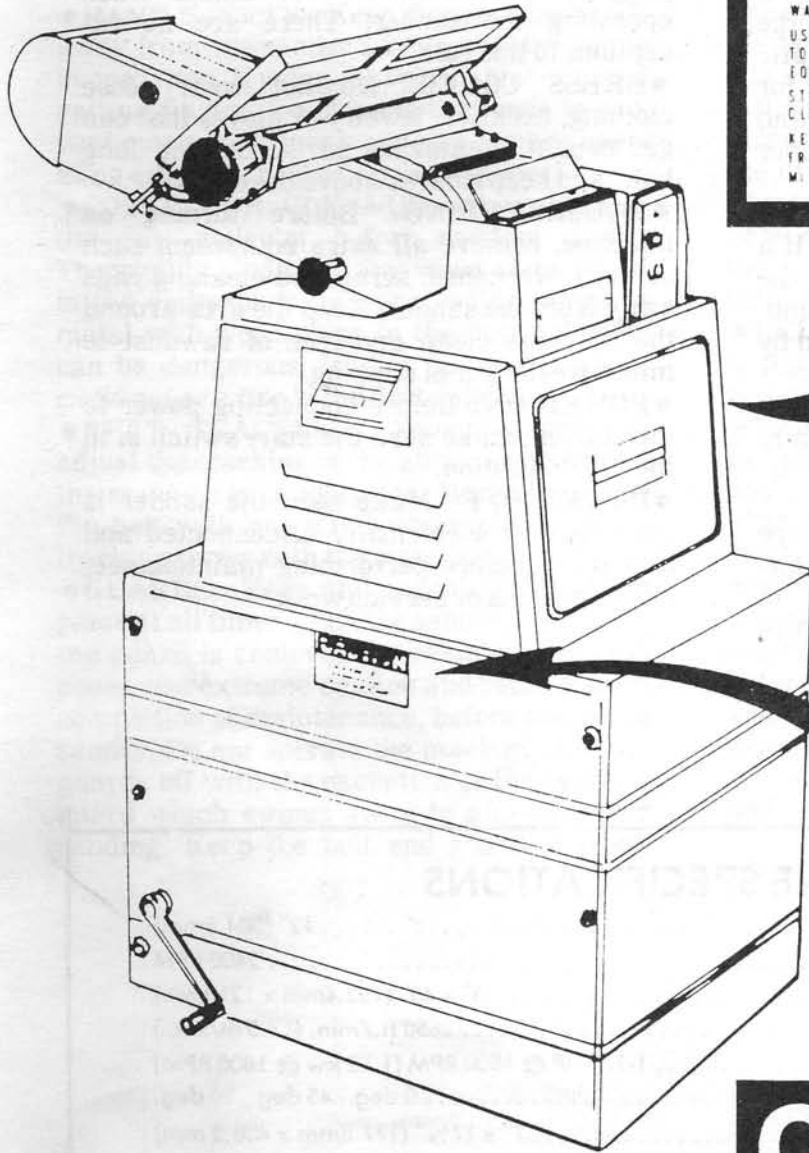
cumstances beyond Powermatic's control; (3) modifications, disassembly tampering, alterations or repairs outside of Powermatic's factory not authorized by Powermatic; or to any product not bearing its original serial number plate. This warranty does not apply to normal wear and tear, corrosion, abrasion, or repairs required due to natural causes or acts of God.

To obtain the fastest possible warranty service you must first notify in writing the authorized Powermatic distributor from whom you purchased the product specifying (1) the product by catalog number and serial number, (2) the date the product was delivered to you, (3) a description of the problem for which you seek warranty service, and (4) evidence of proof of purchase. Should circumstances prohibit you contacting the distributor then contact the Powermatic factory directly. If your claim is covered by this warranty, your Powermatic distributor will provide you with instructions as to how and where service will be provided. On simple warranty replacement or repairs, installation instructions will be provided to allow correction by customer personnel. Powermatic assumes no responsibility for products which are returned without its prior written authorization. Powermatic's obligation under this warranty shall be exclusively limited to repairing or replacing (at Powermatic's option) products which are determined by Powermatic to be defective upon delivery, F.O.B. (return freight paid by customer) Powermatic's factory, and on inspection by Powermatic. In no event shall Powermatic's liability under this warranty exceed the purchase price paid for the product.

# SAFETY: Decal Instruction

## SAFETY RULES

CAREFULLY READ INSTRUCTION MANUAL BEFORE OPERATING MACHINE  
DO NOT OPERATE WITHOUT ALL GUARDS AND COVERS IN POSITION  
BE SURE MACHINE IS ELECTRICALLY GROUNDED  
REMOVE OR FASTEN LOOSE ARTICLES OF CLOTHING SUCH AS NECKTIES, ETC. CONFINE HAIR  
REMOVE JEWELRY SUCH AS FINGER RINGS, WATCHES, BRACELETS, ETC.  
USE SAFETY FACE SHIELD, GOGGLES OR GLASSES TO PROTECT EYES AND OTHER PERSONAL SAFETY EQUIPMENT AS REQUIRED  
STOP MACHINE BEFORE MAKING ADJUSTMENTS OR CLEANING CHIPS FROM WORK AREA  
KEEP THE FLOOR AROUND THE MACHINE CLEAN AND FREE FROM SCRAPS, SAWDUST, OIL OR GREASE TO MINIMIZE THE DANGER OF SLIPPING



## CAUTION

CLEAN WOOD DUST FROM FILTER AND COLLECTOR BEFORE SANDING METAL

# SAFETY: General Rules

● **READ THE MANUAL:** Read, understand and follow the safety and maintenance instructions found in this manual. Know the limitations and hazards associated with the 33-B belt sander and 30-B combination belt and disc sander.

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

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

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

● **CARELESS ACTS:** Give the work you are doing your total, undivided attention. Horseplay, looking around, and talking to someone are careless acts that can result in

serious injury.

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

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

● **DRESS CODES:** Do not wear loose clothing, neckties, jewelry or gloves that can get caught in moving parts. Confine long hair, and keep sleeves above the elbow.

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

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

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

## MACHINE SPECIFICATIONS

Disc Size (Model 30B Only).....	12" (304.8mm)
Disc Speed (Model 30B Only).....	2400 RPM
Belt Size.....	6" x 48" (152.4mm x 1219mm)
Belt Speed.....	2850 ft./min. (14.5 m/sec.)
Motor.....	1-1/2 HP @ 1800 RPM (1.12 kw @ 1800 RPM)
Belt Position.....	0 deg., 45 deg., 90 deg.
Table Size.....	7" x 17 1/4" (177.8mm x 438.2 mm)
Table Tilt.....	15 deg. up to 45 deg. down
Fence Size (Non-tilting).....	1 3/4" x 12" (44.45mm x 304.8mm)
Tilting Fence Size.....	4 1/4" x 15" (108mm x 381mm)
Tilting Fence, Tilting Angle.....	45 deg.
Net Weight: Less: Dust Collector.....	210 lbs. (95.25 kg)
Weight of Dust Collector.....	96 lbs. (43.6 kg)

# SAFETY: Specific Rules

●**READ THE MANUAL:** Read, understand and follow the safety instructions found in this manual. Know what the Model 33-B Belt Sander and Model 30-B Combination Belt and Disc Sander can safely do, and what they cannot do. One safety rule decal and one caution decal are placed on each machine as reminders of good safety practices.

●**HAND SAFETY:** Keep fingers and hands away from the sander's belts and disc while in operation. If using the optional fence avoid getting fingers too close to the fence to prevent pinching. Never wear gloves while operating either of the Powermatic sanders.

●**COLLECTOR CLEANUP:** Always check the dust collector before sanding metal. Thoroughly clean out any wood chips found in the collector before proceeding. Sanding metal with wood chips in the dust collector can be dangerous, leading to sparks which could cause a fire in the dust collector.

●**BELT TRACKING:** Never attempt to adjust the tracking of the abrasive belt while the machine is in operation. Manually rotate the belt with one hand while adjusting the tracking screw with the other hand.

●**GUARDS:** Keep the machine guards in place at all times when the sander is in use. If the guard is removed for maintenance purposes, use extreme caution and replace upon completion of maintenance, before operating sander. **Do not** operate the machine with the guards off with the exception of the belt end guard which swings away to allow contour sanding. Keep the belt end guard in place

except when contour sanding and swing it back into position immediately after finishing the contour sanding task.

●**ABRASIVE BELT AND DISC:** Be sure the belt or disc is in good condition with no tears or holes before operating the sander. A worn or torn belt can break and cause an injury.

●**OPERATOR POSITION:** Do not stand in line or allow anyone else to stand in line with the belt or disc in the direction it is moving when the work stop is not in use.

●**BELT AND DISC DIRECTION:** Proper belt direction is from the idler pulley towards the drive pulley. The proper disc rotation is counterclockwise facing the disc. **Caution:** Sand only on the section of of the disc from the center to the left edge. **Do not** use the right-hand portion for sanding.

●**BELT TENSION:** Be sure the sanding belt and driving belts are properly tensioned before starting the sander.

●**TABLE SAFETY:** Be sure the table is locked in position before placing stock on it and that its front edge is 1/16 inch or less from the disc or belt.

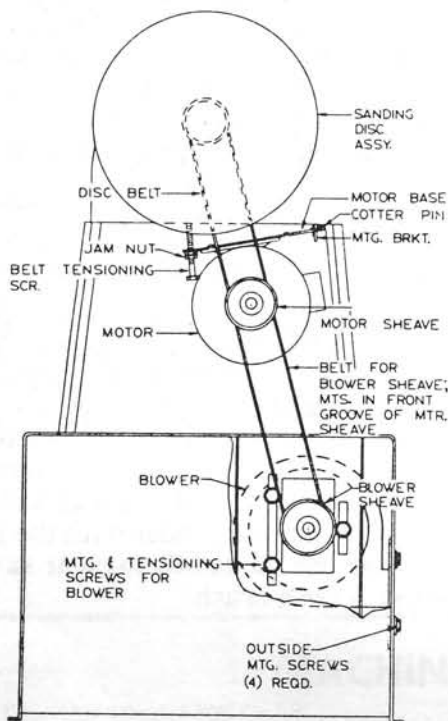
●**JOB COMPLETION:** If you must leave the machine area for any reason when operating the sander, you should turn it off and wait until the machine comes to a complete stop before leaving. If the operation is complete, you should also clean up the sander and work area. **Never** clean the sander with the power on and **never** use the hands to clear sawdust and debris — use a brush.

# MACHINE INSTALLATION, ADJUSTMENT AND MAINTENANCE

## RECEIVING THE SANDER

Remove the sander and any accessories ordered from their respective cartons and check for damage and to ensure all parts are intact. Any damage should be reported to your distributor and shipping agent immediately upon discovery.

Before proceeding with assembly read your maintenance manual thoroughly, familiarizing yourself with correct assembly, set-up, maintenance and safety procedures.



## INSTALLATION OF SANDER

If your Powermatic sander was ordered with its optional stand, remove the stand from its separate container and assemble the basic machine on the stand with hardware provided. Lag the machine to the floor through the four lag holes in the stand. If ordered with optional dust collector, mount the machine on the dust collector.

Remove the cover on the basic machine and install the belt between the motor and blower. Then adjust blower vertically by

loosening the three mounting screws inside and four mounting screws outside to tension the belt. Retighten all mounting screws. Lag the dust collector to the floor through its four mounting holes.

Wire the sander up to its power source following the requirements of the National Electric Code (ANSI/NFPA70). If the machine does not come wired to run, the electricals and motor wiring must be done by a qualified electrician. The machine must be properly grounded to help avoid electrical shock and associated hazards including possible death.

## INSPECT THOROUGHLY

Before putting power to sander, inspect machine thoroughly. Check to ensure that all screws are tight, all mechanical functions work freely, belt runs freely and tracks properly, and that the disc runs freely and does not come into contact with the guard or table.

Periodic or regular inspections are necessary to ensure that your sander is properly adjusted, that all screws are tight, the belts in good condition, that dust has not collected in the motor or electrical enclosures, and that there are no loose or worn electrical fittings or wiring.

## BEFORE YOU OPERATE

You should check the motor and switch wiring diagram for proper voltage connections before applying power to the sander. (See wiring diagram.) Turn the motor on and check for proper rotation direction, correcting as necessary. The sanding belt should move from the idler pulley toward the drive pulley while the disc should rotate counter-clockwise with the operator facing the disc.

Run the sander without sanding for a short period to ensure the belt tracks properly and the disc adhesive adheres properly to the disc.



## LUBRICATION

All bearings used on your sander are sealed for life and require no lubrication. Lubrication with Fisk Lubriplate No. 630AA is recommended monthly on the idler slide and table trunnion. Both the table clamp screw and belt arm shot pin should be lubricated monthly with SAE No. 10 oil.

## ABRASIVE BELT INSTALLATION

To change an abrasive belt, loosen the knob holding the belt end guard and swing it out of location. Remove the side guard by loosening and removing the two screws holding it. Release tension on the belt by loosening the tension knob at the bottom of the belt arm. Loosen the tracking screw at the back of the belt arm and move the drum forward.

Slide the worn sanding belt off the idler and driving drums and install a new belt. Retighten the belt tension and tracking screws. Check the tracking manually to ensure the belt tracks properly. Put the side guard track back into position and lock in place. Swing the end guard back into position and lock in place.

## ABRASIVE BELT ALIGNMENT

To properly align the abrasive belt, tighten the belt tension screw until the belt is relatively tight. Manually rotate the belt with one hand while at the same time adjusting the tracking screw with the other hand until the belt is tracking in the center of the idler and driving pulley. Caution is necessary since excessive tension can stretch a belt to the point where it will not track.

Make final adjustments on tracking by momentarily starting and stopping the motor while at the same time adjusting the tracking screw at the side of the belt arm. To lock the screw in place, rotate the tracking screw locking nut against the belt arm.

## PLATEN ADJUSTMENT

Due to wear, occasionally the platen may

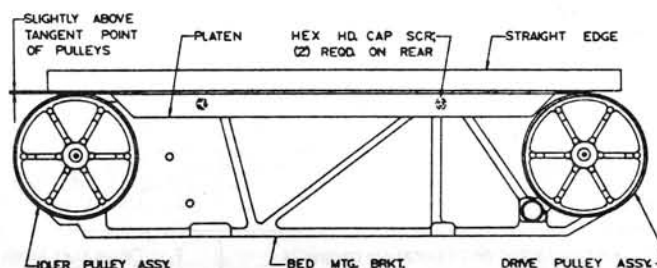
have to be readjusted. To do this, swing the end guard down out of position and remove the side guard. Loosen the two hex head cap screws in the back side of the belt arm and adjust the platen. It should be slightly above the tangent points of the pulleys and in contact with the belt at both ends. A straight edge can be used with the belt to align the platen.

## DISC INSTALLATION

To install a new sanding disc, remove the table by undoing its two hex head mounting screws. Remove the disc plate and use a putty knife to remove the old abrasive from the disc. Clean the disc plate with solvent and wait until it is dry.

Apply a light, even coat of glue to the abrasive disc. Mount the new disc on the disc plate and apply even pressure over the entire surface. Carefully align the driving pin on pulley with the slot in the back of the disc. Use a roller (iron pipe or wood) to prevent wrinkles.

Allow the glue to dry and reassemble on the pulley face. Remount the sanding table to the machine. Discs are also available with a self-adhesive backing which simplifies installation.



● **TABLE ANGLE ADJUSTMENT:** The table may be adjusted from any angle from 15 degrees up to 45 degrees down. To adjust, loosen the lock handle on the left hand side and pivot table to the desired angle as shown on the trunnion scale and relock.

●**BELT POSITIONING:** Your sander is equipped with a shot pin arrangement to lock the belt arm in 0-degree, 45-degree and 90-degree positions. To position the belt, simply pull out on the pin handle and swing the belt arm into the desire position. The table can be readily moved from the disc side to the belt via two screws used to mount it in both locations.

●**CONTOUR SANDING:** To permit contour sanding the end guard for the belt is designed to be swung out of position by loosening the knob and pulling out away from the arm and swinging down.

●**OPTIONAL FENCE:** The sander can be equipped with a wood faced 90-degree fence, adjustable across the belt. For work requiring a fence with a face that can be adjusted at any angle, an optional deluxe fence is available.

●**WORK STOP:** Your sander is also equipped with a work stop for use with the

arm in the horizontal position. When installed the work stop will prevent a work piece from being thrown from the belt. If removed for through sanding, the work stop should be immediately reinstalled unless the tilting table is used in its place for 45-degree or vertical positions of the arm.

### CHANGING MOTORS

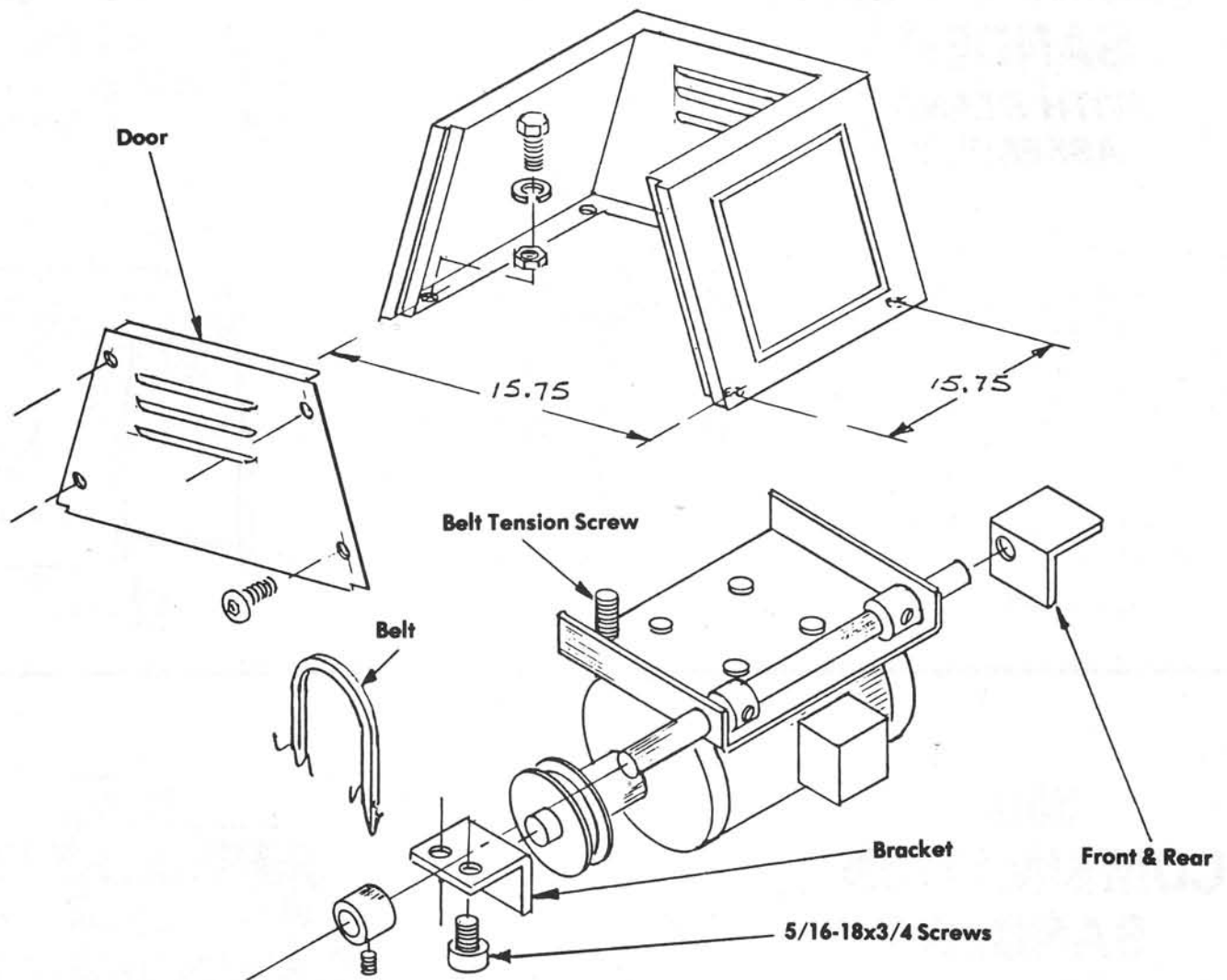
To change out a motor in the event of motor failure or when changing from a single to three-phase motor or vice versa use the procedure illustrated on page 11.

●**CHANGING MOTOR VOLTAGE:** Remove the terminal box cover and rewire per the circuit shown on the cover. On magnetic starter models, starter wiring and transformer wiring (when used) will also have to be changed as shown on the decals attached.

### TROUBLE – SHOOTING HINTS

PROBLEM	CAUSE	SOLUTION
Machine fails to start	<ol style="list-style-type: none"> <li>1. Fuses blown</li> <li>2. Starter coil burned out</li> <li>3. Bad motor</li> <li>4. Not connected to power source</li> <li>5. Connected to wrong voltage *</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace fuses</li> <li>2. Replace starter</li> <li>3. Replace motor</li> <li>4. Connect power source</li> <li>5. Reconnect to correct voltage</li> </ol>
Belt won't track	<ol style="list-style-type: none"> <li>1. Belt stretched unevenly</li> <li>2. Pulley is worn</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace belt</li> <li>2. Replace pulleys</li> </ol>
Abrasive disc comes free of aluminum discs	<ol style="list-style-type: none"> <li>1. Improperly bonded</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean adhesive off aluminum &amp; reapply adhesive</li> </ol>
Belt slips or stalls on application of pressure	<ol style="list-style-type: none"> <li>1. Abrasive belt tension inadequate</li> <li>2. Excessive pressure on platen</li> <li>3. Motor belt loose</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten belt</li> <li>2. Reduce pressure</li> <li>3. Tighten motor belt</li> </ol>
Disc stalls	<ol style="list-style-type: none"> <li>1. Motor belt loose</li> <li>2. Disc drive pin missing</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten motor belt</li> <li>2. Replace pin</li> </ol>
Dust collector not operating properly	<ol style="list-style-type: none"> <li>1. Drive belt loose</li> <li>2. Dirty filter</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten belt properly</li> <li>2. Clean or replace filter</li> </ol>
Excessive abrasive belt replacement	<ol style="list-style-type: none"> <li>1. Too much pressure</li> <li>2. Not using full width of belt</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce pressure</li> <li>2. Stroke across belt using full width</li> </ol>
Belt arm won't detent	<ol style="list-style-type: none"> <li>1. Shot pin stuck</li> <li>2. Broken spring</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove arm and free shot pin</li> <li>2. Remove arm and replace spring</li> </ol>
Dust discharge from outlet	<ol style="list-style-type: none"> <li>1. Drawer not fully closed</li> <li>2. Not using fine paper filter</li> </ol>	<ol style="list-style-type: none"> <li>1. Close drawer</li> <li>2. Install fine paper filter over coarse cloth filter</li> </ol>

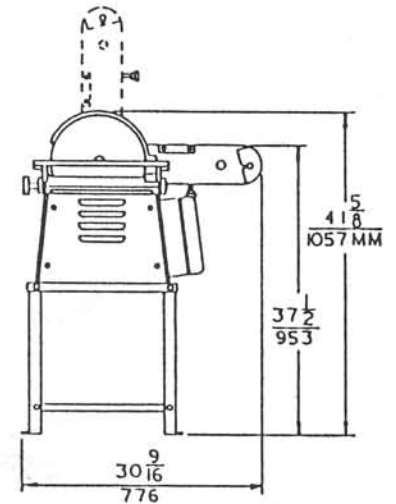
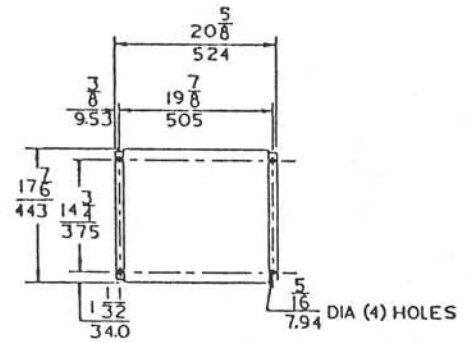
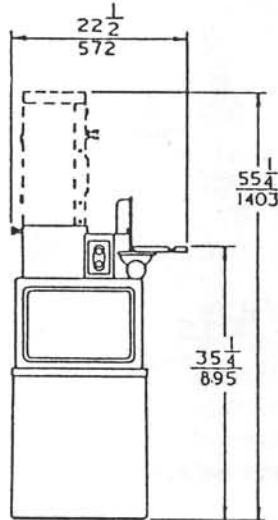
## MODEL 30B SANDER



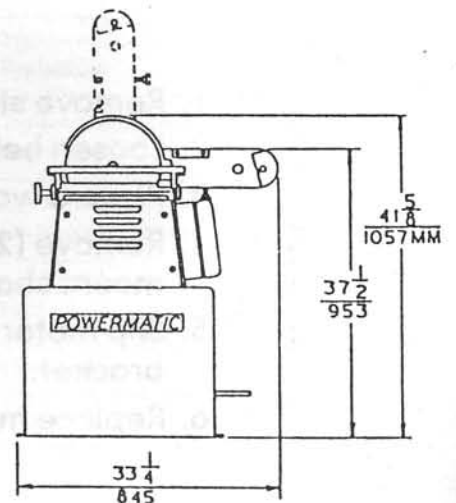
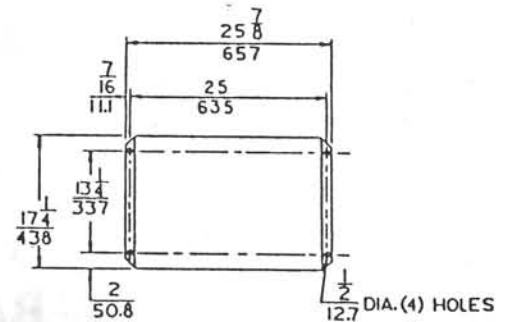
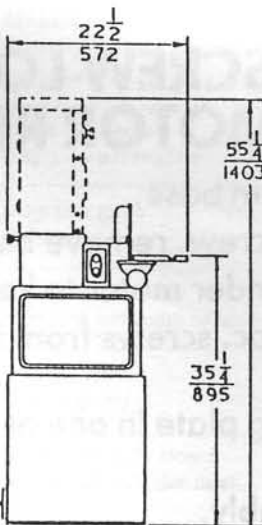
### BASE SCREW LOCATION AND MOTOR REMOVAL

1. Remove side door from base.
2. Loosen belt tension screw, remove belt.
3. Place a wood block under motor to keep from falling.
4. Remove (2) 5/16-18 soc. screws from front bracket holding motor mount shaft.
5. Slip motor & mounting plate in one assembly out of the rear bracket.
6. Replace motor assembly.

# 30B COMBINATION SANDER WITH STAND ASSEMBLY

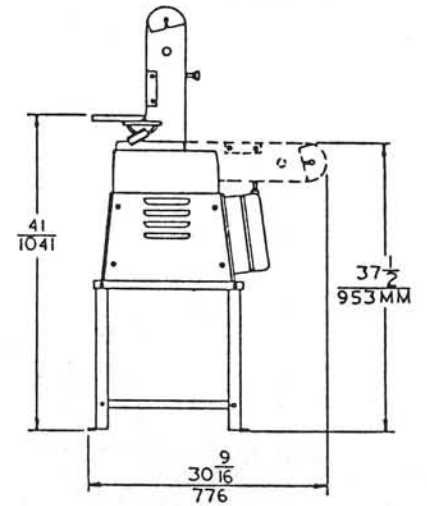
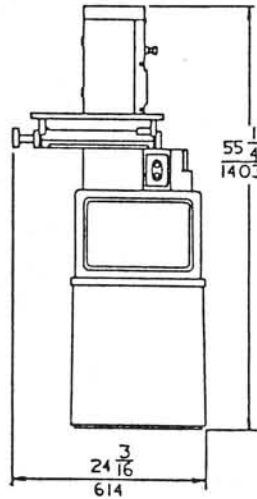
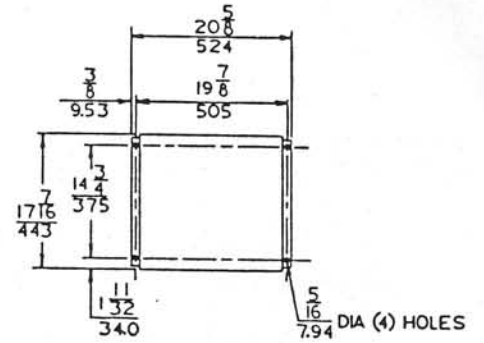


# 30B COMBINATION SANDER WITH DUST COLLECTOR

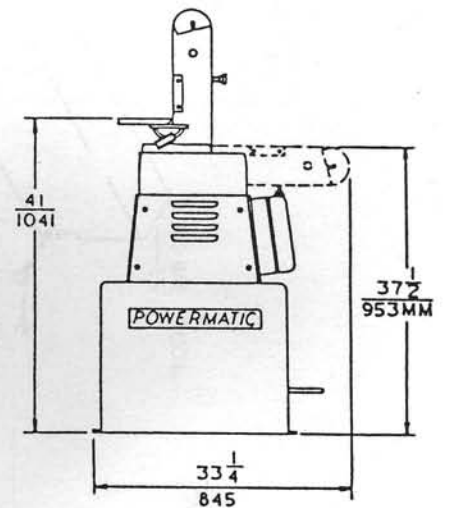
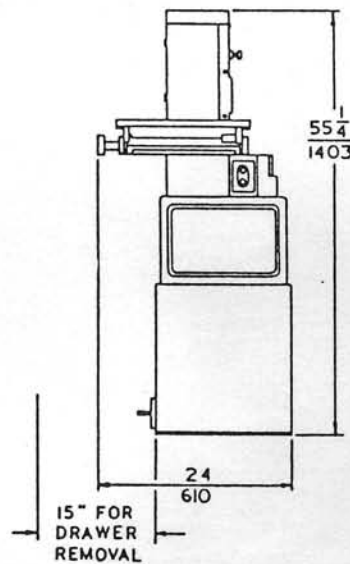
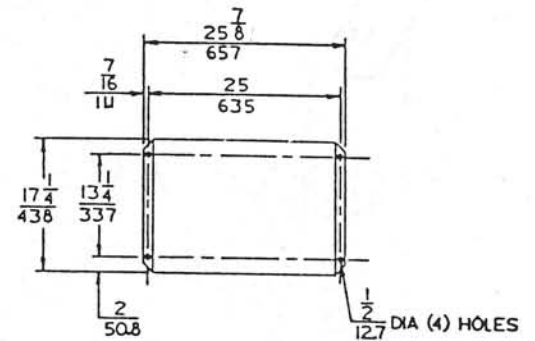


15" FOR  
DRAWER  
REMOVAL

# 33B BELT SANDER WITH STAND ASSEMBLY

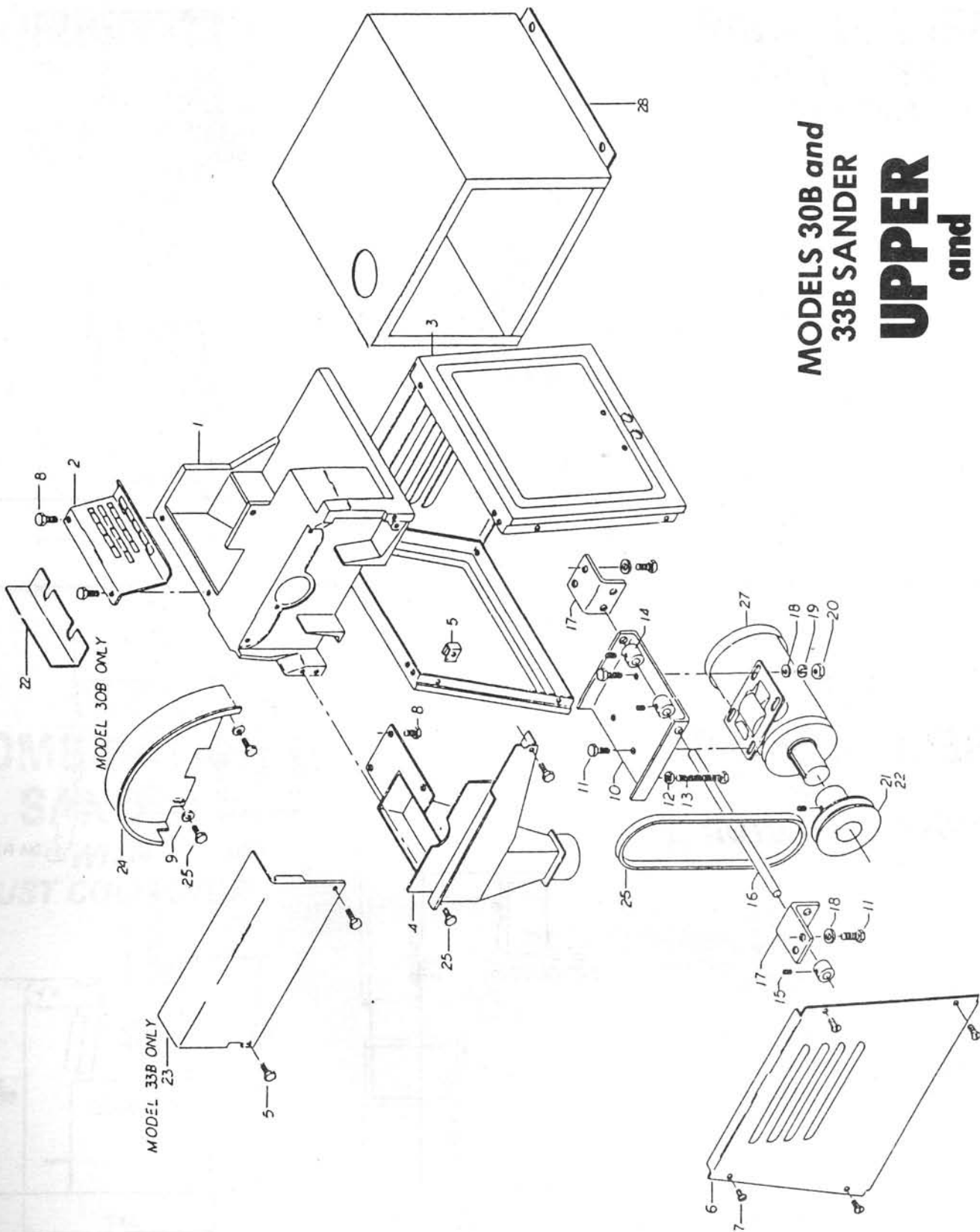


# 33B BELT SANDER WITH DUST COLLECTOR



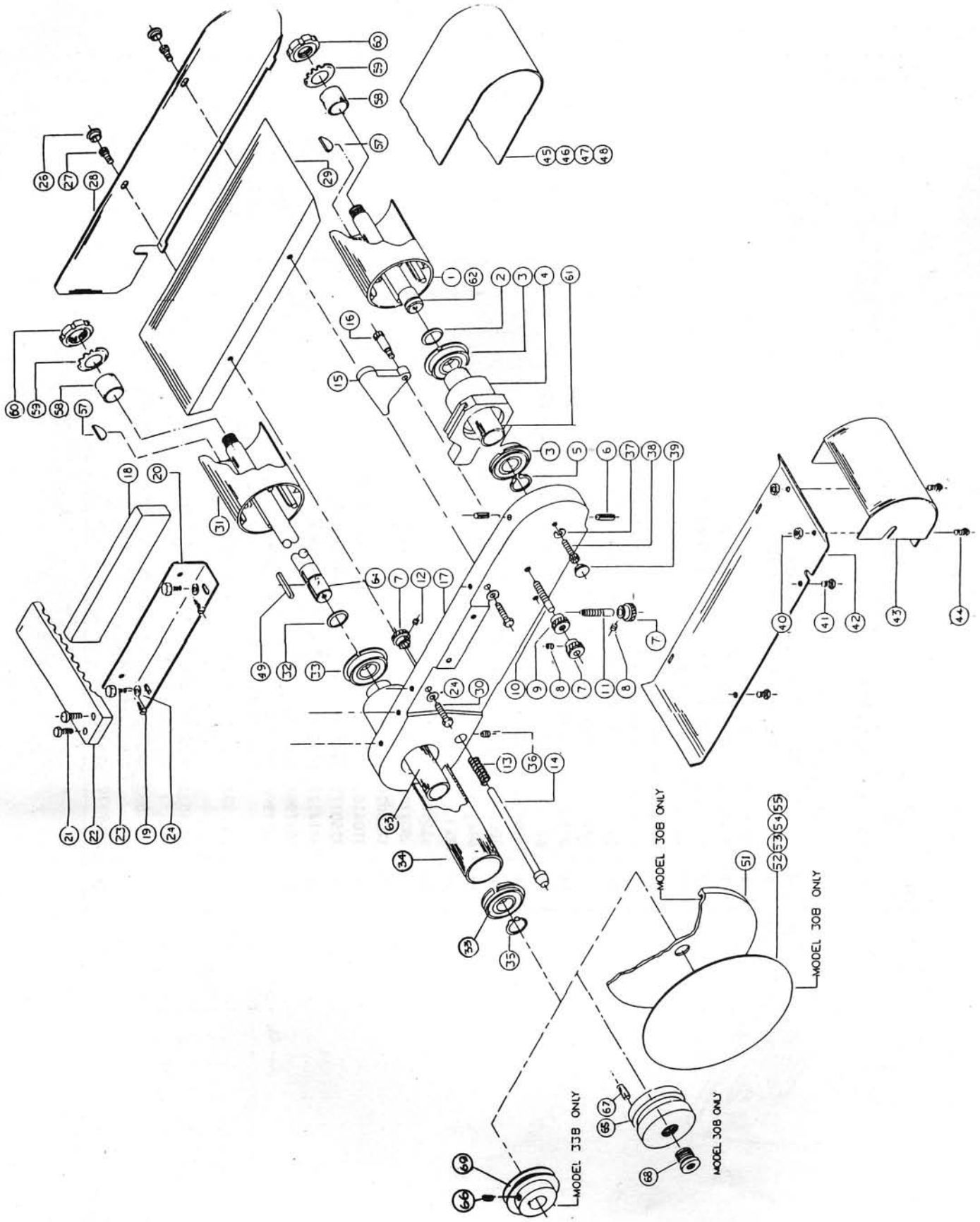
MODELS 30B and  
33B SANDER

**UPPER**  
and  
**LOWER**  
**BASE**



# ASSEMBLY

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	3042130	BASE, UPPER	1
2	3250135	GUARD BELT	1
3	2042242	BASE, LOWER (WELDMENT)	1
4	2087013	CHUTE, DUST (WELDMENT)	1
5	6510010	NUT, TINNEMAN C 8115-1024	4
6	3578134	PANEL, SIDE	1
7	6710003	SCREW, TRUSS HD #10-24 x 1/2	4
8	6715033	SCREW, HEX HD CAP 5/16-18 x 1/2	5
9	6861101	WASHER, FLAT 1/4	2
10	2042247	MTR BASE WELD	1
11	6715035	SCREW, HEX HD CAP 5/16-18 x 3/4	6
12	6520008	NUT HEX JAM 5/16-18 (BELT)	1
13	6715253	SCREW, (BELT TENSIONING)	1
14	3096009	COLLAR	3
15	6714006	SCREW, SOC SET KNURLED POINT 1/4-20 x 3/16	3
16	3584037	MOTOR BASE SWIVLE PIN	1
17	3062128	BRKT, ANGLE MTG BASE	2
18	6861201	WASHER, FLAT 5/16	4
19	68612000	WASHER, LOCK 5/16	4
20	6515001	NUT, HEX 5/6-18	4
21	6807108	SHEAVE AK 30, 7/8 BORE 1 GROOVE	2
22	3720025	SHIELD	1
23	3104133	COVER, CAVITY DISC (MODEL 338 ONLY)	1
24	3250117	GUARD, DISC (MODEL 30B ONLY)	1
25	6714127	SCREW, HEX HD CAP 1/4-20 x 1/2	6
26	6077007	BELT VEE 4L280	1
27	6471306	MOTOR, ELEC 1-1/2 HP, 1 PH, 1800 RPM, 115/230 V, TEFC, 56 FR	1
	6471304	MOTOR, ELEC 1-1/2 HP, 3 PH, 1800 RPM, 230/460 V, TEFC, 145 T FR	1
	6471317	MOTOR, ELEC 1-1/2 HP, 3 PH, 1800 RPM, 575 V, TEFC, 145 T FR	1
	6471332	MOTOR, ELEC 1-1/2 HP, 3 PH, 1800 RPM, 200 V, TEFC, 145 T FR	1
28	2759039	STAND ASSY.	1

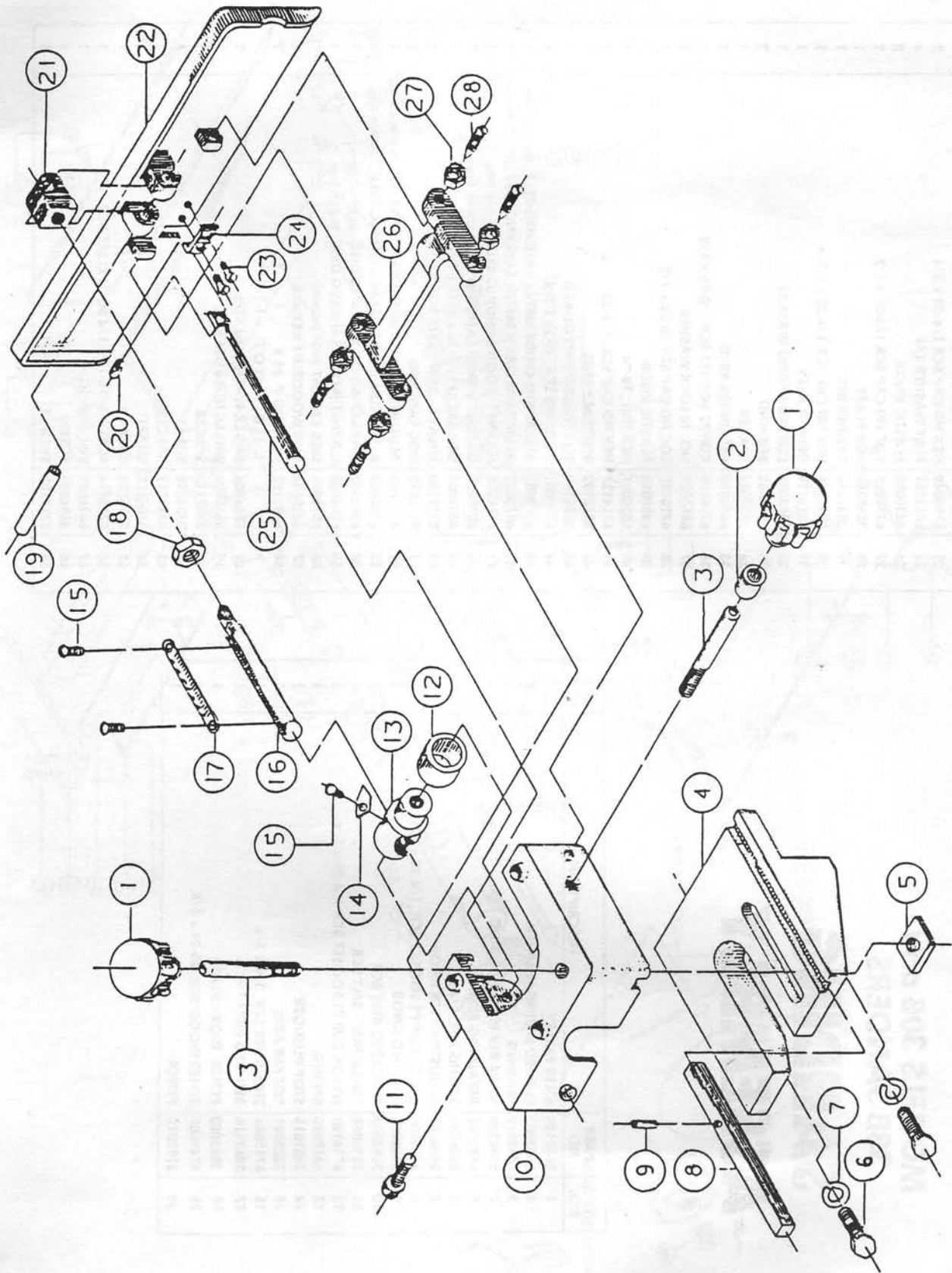




# MODELS 30B and 33B SANDERS SANDING ASSEMBLY

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	3610120	IDLER PULLEY	1
2	6863003	CURVED SPRING WASHER	2
3	6060052	BEARING	2
4	3298239	IDLER BEARING HOUSING	1
5	6670002	RETAINING RING	1
6	6626038	SPRING PIN, 1/4 x 1	2
7	3406005	ADJUSTING SCR KNOB	3
8	6714006	KNURL CUP PT SOC SET SCR, 1/4-20 x 3/16	2
9	3406001	LOCKING KNOB	1
10	3695069	TRACKING BELT SCR	1
11	3695068	TENSIONING BELT SCR	1
12	6714160	NYLON CUP PT SOC SET SCR 1/4-20 x 1/4	1
13	6813090	SPRING	1
14	2601015	STOP PLUNGER	1
15	3025081	ROCKER ARM	1
16	6715064	SHOULDER SCR, 3/8 x 3/4	1
17	3062116	BED MTG BRKT	1
18	3862002	FENCE, WORK PLATE	1
19	6749008	RD HD WOOD SCR, 10-24 x 5/8	2
20	3195012	FENCE	1

21	6714048	HEX HD CAP SCR, 1/4-20 x 1	2
22	3658016	WORK REST	1
23	6714049	HEX HD CAP SCR 1/4-20 x 3/4	2
24	6861101	FLAT WASHER 1/4	4
26	6430025	PLASTIC KNOB	2
27	6714015	SOC HD CAP SCR 1/4-20 x 1/2	2
28	3595369	SIDE PLATE	1
29	3047014	SANDER BED	1
30	6714168	HEX HD CAP SCR 1/4-20 x 1-3/4	2
31	3610120	DRIVE PULLEY	1
32	6863003	CURVED SPRING WASHER	1
33	6060052	BEARING	2
34	3737024	SPACER	1
35	6670002	RETAINING RING	1
36	6716009	CUP PT SOC SET SCR 3/8-16 x 1/2	1
37	6860802	NO. 10 LOCK WASHER	1
38	6710015	SOC HD CAP SCR 10-24 x 1/2	1
39	6430024	PLASTIC KNOB	1
40	6510001	HEX NUT, 10-24	2
41	6714127	HEX HD CAP SCR, 1/4-20 x 1/2	2
42	3578132	BOTTOM PANEL	1
43	2250138	BELT (WELDMENT) GUARD	1
44	6710001	TRUSS HD SCR, 10-24 x 1/4	1
45	6078001	ALUMINUM OXIDE METAL SANDING BELT, 100 Grit, Fine	2
46	6078002	ALUMINUM OXIDE METAL SANDING BELT, 50 Grit, Coarse	1
47	6078003	GARNET WOOD SANDING BELT, 80 Grit, Fine	1
48	6078004	GARNET WOOD SANDING BELT, 40 Grit, Coarse	1
49	3388004	SQUARE KEY, 3/16 x 3/16 x 1	1
50	3719180	SHEAVE, .7870/.7875 BORE	1
51	3127012	DISC SANDING	1
52	6206004	ALUMINUM OXIDE METAL SANDING DISC, 50 Grit, Coarse	1
53	6206003	ALUMINUM OXIDE METAL SANDING DISC, 100 Grit, Fine	1
54	6206002	GARNET WOOD SANDING DISC, 40 Grit, Coarse	1
55	6206001	GARNET WOOD SANDING DISC, 80 Grit, Fine	1
56	6012001	DISC CEMENT (NOT SHOWN)	1
57	6420004	#608 WOODRUFF KEY #13	1
58	6095190	BUSHING P. 89-9	2
59	6664004	7/8 I.D. 1-1/8 O.D. x 1-1/8 LG	2
60	6549004	BRG LK WASH W 04 STPL	2
61	3737213	BRG LK NUT #N04 STPL	2
62	3701058	SPACER	1
63	3737212	SHAFT	1
64	3700122	SPACER	1
65	3716036	SHAFT	1
66	6715014	SHEAVE	1
67	6626039	SCREW 5/16-18 x 1/4 SOC HD SET SCR	1
68	3696005	PIN, SPRING	1
69	3719180	SCREW	1
		SHEAVE	1



33B SANDER

# FENCE ASSEMBLY

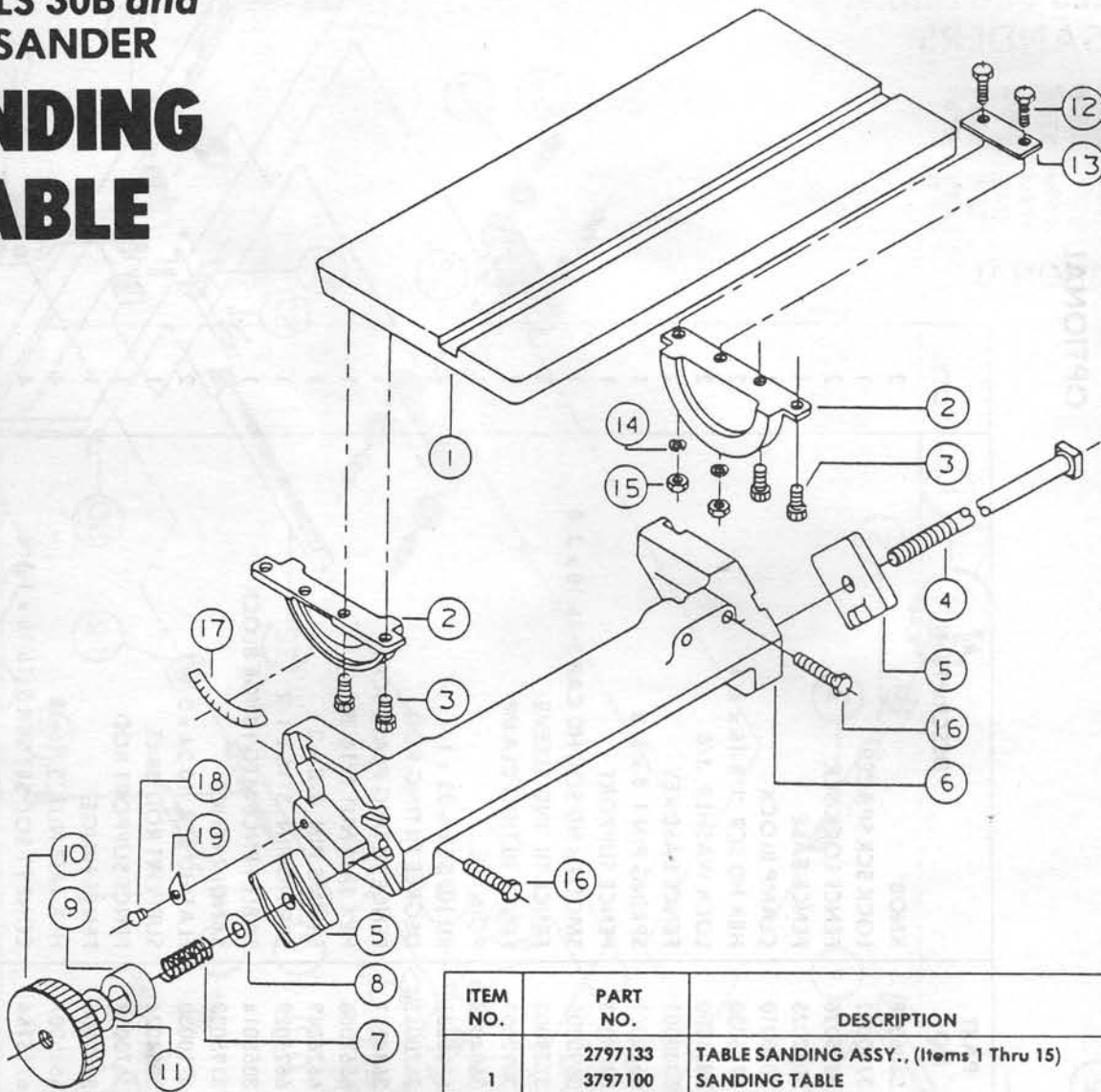
OPTIONAL

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	3406018	KNOB	2
2	3740002	LOCK SCR SPACER	1
3	3695026	FENCE LOCK SCR	2
4	3042025	FENCE BASE	1
5	3055010	CLAMP BLOCK	1
6	6716030	HEX HD SCR, 3/8-16 x 3/4	2
7	6861300	LOCK WASHER, 3/8	2
8	3388001	FENCE BASE KEY	1
9	6626001	SPRING PIN 1/8 x 5/8	1
10	3776015	FENCE SUPPORT	1
11	3690205	SMOOTH HD SOC HD CAP 5/16-18 x 3/8	1
12	3728003	FENCE TILTING SLEEVE	1
13	3092003	FENCE TILTING CLAMP	1
14	3604008	POINTER	1
15	6706035	RD HD SCR 6-32 x 1/4	3
16	3670017	DEGREE TILTING ROD	1
17	3684201	FENCE TILTING PLATE SCALE	1
18	6567006	HEX JAM NUT 7/16-20	1
19	6626049	SPRING PIN, 3/8 x 2	1
20	6626028	SPRING PIN, 3/16 x 1/2	1
21	3055014	TABLE FENCE MTG HINGE BLOCK	1
22	3195003	SANDER FENCE	1
23	6710030	FLAT HD SCR, 10-24 x 3/8	2
24	3064024	SUPPORT ROD BRKT	1
25	3670018	FENCE SUPPORT ROD	1
26	3282004	FENCE HINGE	1
27	6515007	HEX JAM NUT, 5/16-18	4
28	6715164	CONE PT SOC SET SCR 5/16-18 x 1-1/4	4

2195004 Fence Assy (Items 1 thru 28)

MODELS 30B and  
33B SANDER

# SANDING TABLE



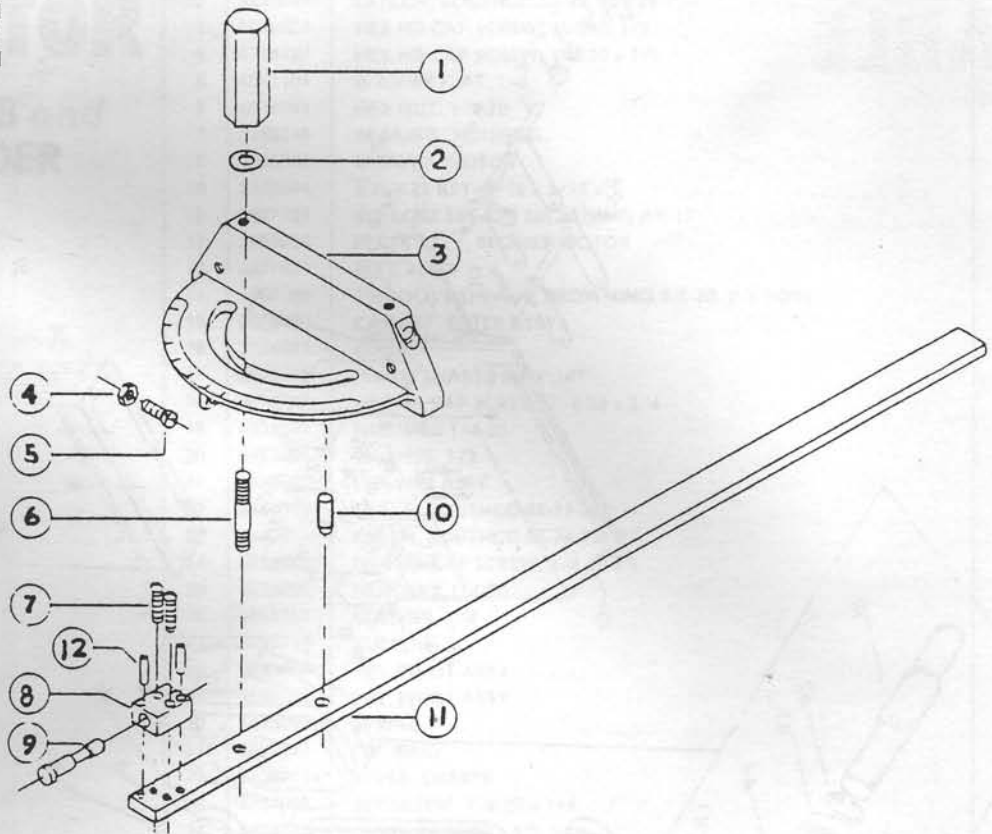
ITEM NO.	PART NO.	DESCRIPTION	QTY.
	2797133	TABLE SANDING ASSY., (Items 1 Thru 15)	
1	3797100	SANDING TABLE	1
2	3810028	TRUNNION	2
3	6714019	SOC HD CAP SCR, 1/4-20 x 5/8	4
4	2690054	CLAMP SCR ASSY (WELDMENT)	1
5	3092111	CLAMP (MACH)	2
6	3062114	TRUNNION BRACKET	1
7	6813073	COMP SPRING, LEE LC-072H-6	1
8	6861301	FLAT WASHER, 3/8	1
9	3735080	SPACER	1
10	3406046	KNOB	1
11	6861600	NYLATRON WASHER, 9/16 x 1	1
12	3761055	TABLE STOP	1
13	6714049	HEX HD CAP SCR, 1/4-20 x 3/4	2
14	6861100	LOCK WASHER, 1/4	2
15	6514001	HEX NUT 1/4-20	2
16	6714047	HEX HD CAP SCR 1/4-20 x 1/4	2
17	3119008	SCALE DECAL	1
18	6747000	RD HD DRIVE SCR, NO 4	1
19	3604001	POINTER	1

2797134 Table Assy. (Item 1 thru 19)

**MODELS 30B and  
33B SANDERS**

**MITER  
GAUGE**

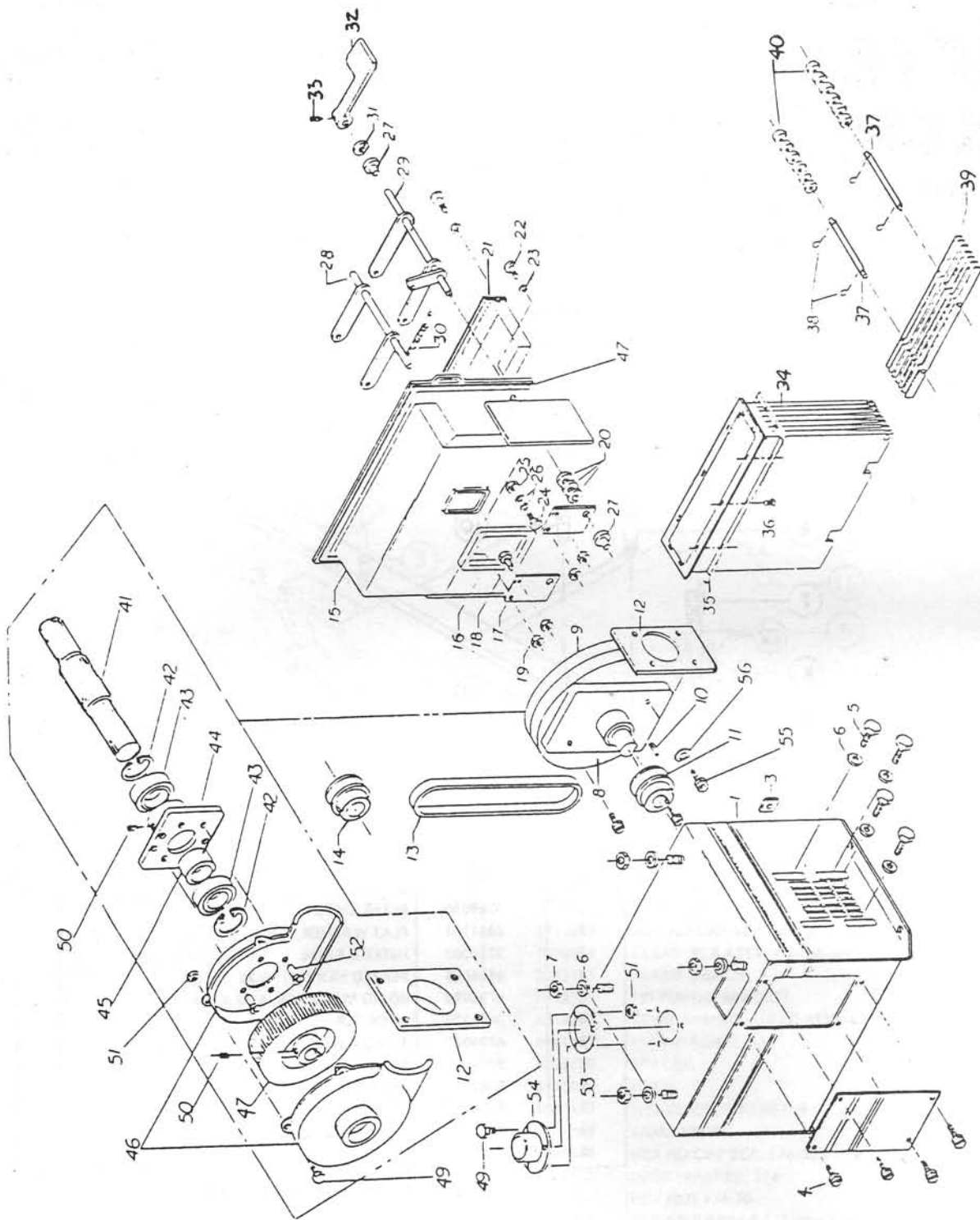
OPTIONAL



ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	3268050	MITER KNOB	1
2	6861101	FLAT WASHER, 1/4	1
3	3230007	MITER GAUGE	1
4	6506003	PLATED HEX NUT, 6-32	3
5	6706094	RD HD MACH SCR, 6-32 x 1/4	3
6	3695220	LOCK SCR	1
7	6706041	RD HD MACH SCR, 6-32 x 3/4	2
8	3055101	POINTER BLOCK	1
9	3582097	STOP PIN	1
10	6623012	DOWEL PIN, 1/4 x 1	1
11	3044312	MITER GAUGE BAR	1
12	6626004	SPRING PIN, 1/8 x 3/4	2

2471010 Miter Gauge (Items 1 thru 12)

# PARTS: Exploded View



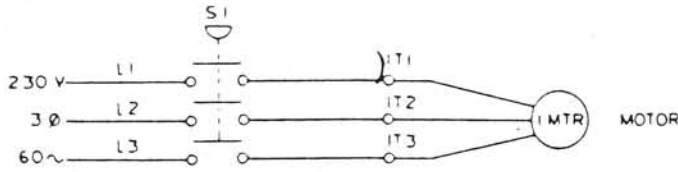
PARTS LIST:

**DUST  
COLLECTOR**  
MODELS 30B and  
33B SANDER

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	2075021	CABINET, ASSY	1
2	3104328	COVER	1
3	6440009	LATCCH, SOUTHCO 85-47, 101-15	4
4	6746034	HEX HD CAP SCREW, 10-24 x 1/2	4
5	6714127	HEX HD CAP SCREW, 1/4-20 x 1/2	4
6	6861101	WASHER FLAT, 1/4	8
7	6514001	HEX NUT, 1/4-20	4
8	3298248	BEARING, HOUSING	1
9	2053002	BLOWER, MOTOR	1
10	3388004	SQUARE KEY, 3/16 x 3/16 x 1	1
11	6807109	5/8 BORE SHEAVE BROWNING AK-17	1
12	2595020	PLATE ASSY, BLOWER MOTOR	1
13	6077011	BELT, 4L350	1
14	6807108	1 GROOVE SHEAVE, BROWNING AK-30, 7/8 BORE	1
15	2075020	CABINET, FILTER ASSY	1
16	3234025	GASKET	1
17	3595432	PLATE, SHAKER SUPPORT	2
18	6714049	HEX HD CAP SCREW, 1/4-20 x 3/4	4
19	6514001	NUT, HEX 1/4-20	4
20	6861501	WASHER, 1/2	3
21	2138006	DRAWER ASSY	1
22	6440010	LATCH, SOUTHCO 85-11-280-16	4
23	6440011	LATCH, SOUTHCO 85-34-101-17	4
24	6714048	HEX HD CAP SCREW, 1/4-20 x 1	1
25	6514001	NUT, HEX 1/4-20	1
26	6861101	WASHER, 1/4	2
27	6095191	BUSHING	2
28	2590004	PIN, PIVOT ASSY	1
29	2590003	PIN, PIVOT ASSY	1
30	6813023	SPRING	1
31	6804041	"O" RING	1
32	3426211	LEVER, SHAKER	1
33	6764038	SET SCREW, 1/4-20 x 1/4	1
34	3038003	FILTER BAG (20.6 SQ. FT.)	1
35	2092012	CLAMP ASSY	1
36	6746023	HEX HD CAP SCREW, SELF TAPPING, 1/4-20 x 5/8	10
37	3582206	PIN, SHAKER	2
38	6622011	PIN, COTTER, 3/32 x 1/2	4
39	3044346	BAR, FILTER WEIGHT	7
40	6811387	SPACER, FILTER	12
41	3700125	SHAFT	1
42	6670008	RING RETAINER 5100-62	2
43	6060005	BEARING 203PP	2
44	3298248	HOUSING (BRG)	1
45	3737025	SPACER	1
46	6084002	HOUSING (BLOWER)	1
47	3850018	WHEEL (BLOWER)	1
48	3388004	KEY 3/16 x 3/16 x 1	1
49	6716159	HEX HD CAP SCREW, 1/4-20 x 1	1
50	6716009	SET SCREW, 3/8-16 x 1/2 KNURLED PT	2
51	6514001	NUT, HEX 1/4-20	7
52	6716171	FLAT HD, SOC CAP SCREW 3/8-16 x 1-1/4	4
53	3234240	GASKET	1
54	6008108	ADAPTOR FLANGE	1
55	6716038	3/8-16 x 1/2 HEX HD CAP SCREW	3
56	6861301	3/8 FLAT WASHER	3
57	6823011	TAPE SEALING	7-1/2"

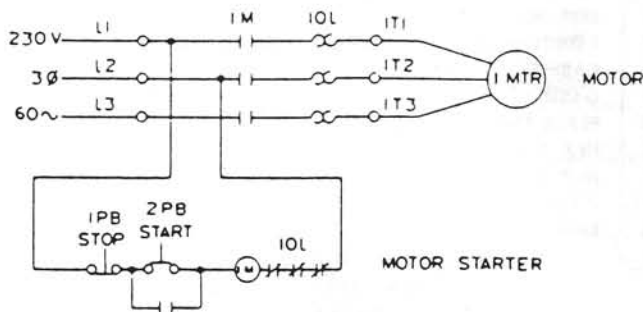
# ELECTRICAL SCHEMATIC

MANUAL



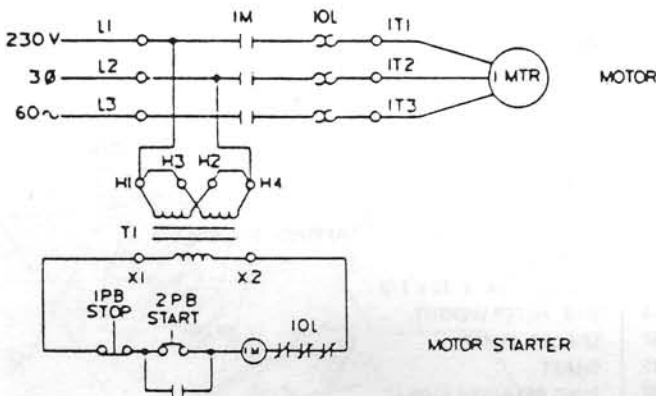
REF.	QTY.	POWERMATIC NO.
S1	1	(3Ø) 6821369 (1Ø) 6821368

**NOTE:**  
FOR SINGLE PHASE UNITS, OMIT LINE L3



MAGNETIC

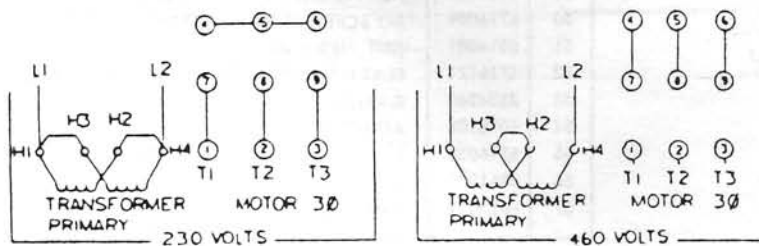
REF.	QTY.	POWERMATIC NO.
	1	(3Ø) 6816202
M1		(1Ø) 6816191
PB1		
PB2	1	6821014



MAGNETIC  
WITH LOW VOLTAGE CONTROL

REF.	QTY.	POWERMATIC NO.
PB1		
PB2	1	6821014 6831068 6831069 6831069 6831070
T1	1	6816196 6816207 6471301
Mtr.	1	6471304 6471317 6471322

**NOTE:**  
FOR SINGLE PHASE UNITS, OMIT LINE L3

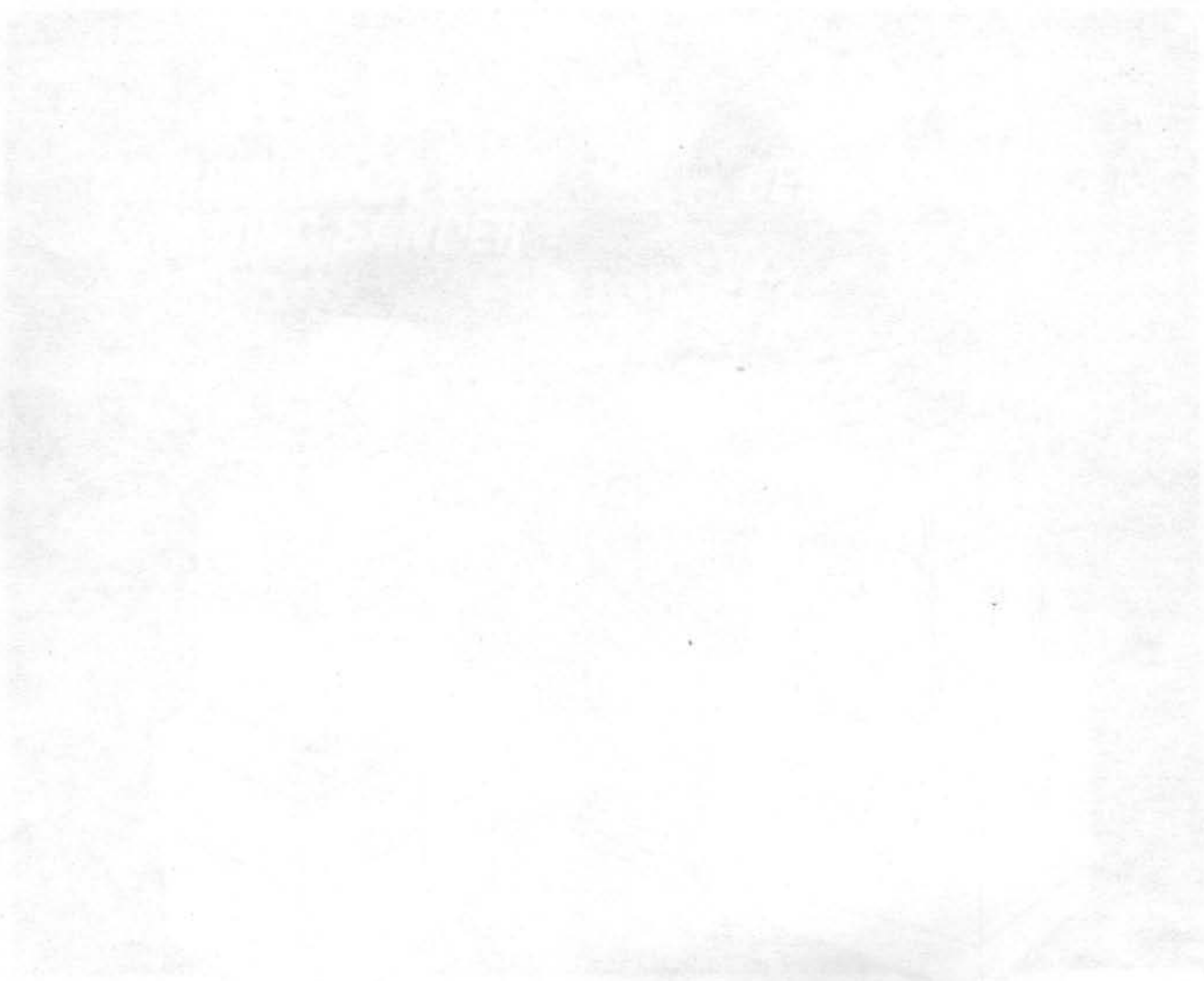








MANUAL OF INSTRUCTION  
AND PLANS SET



Better by a ~~Factor~~ ~~Factor~~ ~~Factor~~

**POWERMATIC®**

MCMINNVILLE, TN 37110