

Woodmaster

TOOLS, INC.



MODELS 2675, 3875 & 5075 DRUM SANDER

OPERATOR'S MANUAL

YOU MUST READ THIS MANUAL BEFORE SETTING UP AND OPERATING THIS EQUIPMENT. PERSONAL PROTECTIVE EQUIPMENT MUST BE UTILIZED BY ALL PERSONS OPERATING THIS EQUIPMENT.

OPERATING MACHINES ALWAYS INVOLVES INHERENT DANGER. THIS MANUAL PROVIDES SAFETY GUIDELINES, AND IS NOT A SUBSTITUTE FOR ENSURING A PROPER WORK ENVIRONMENT WITH PROPERLY TRAINED WORKERS AND OPERATORS. ALL MACHINES MUST BE USED WITH CAUTION, WITH SAFETY BEING OF THE UTMOST IMPORTANCE. FAILURE TO MAKE SAFETY THE UTMOST IMPORTANCE CAN RESULT IN SERIOUS INJURY TO PERSONS AND/OR PROPERTY, AND CAN RESULT IN DEATH.

⚠️ WARNING

Read Instruction Manual Before Operating This Equipment

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

⚠️ DANGER

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

⚠️ WARNING

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

⚠️ CAUTION

Indicates a potentially hazardous situation which if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.

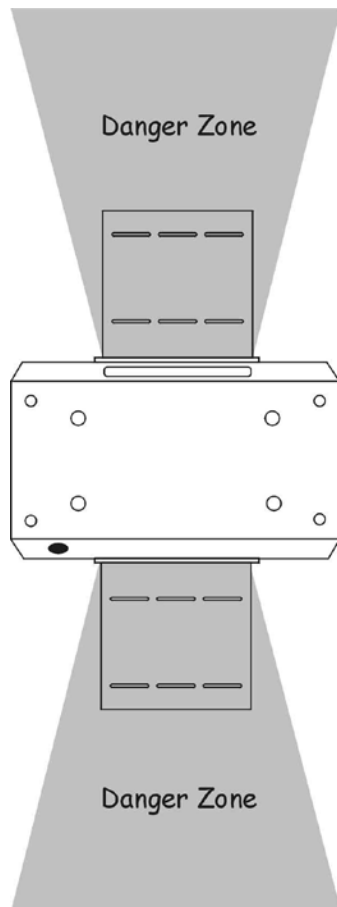
NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment.

WARNING

If sanding multiple pieces (more than one across), be aware that even when all stock is the same thickness, a warped, twisted or bowed piece can push the feed rollers upward. The feed rollers may then be too high to sufficiently grip the other pieces and a kickback can occur, causing serious injury or death.

▲WARNING Kickbacks can leave the machine at over 75 MPH and result in severe injury or death. Always stand outside the danger zone, never directly in the line of travel of the board(s) being planed.



▲WARNING When feeding stock, let the infeed roller grip the workpiece, then *release* stock and *remove* hands from the infeed area *before* the leading edge of the board reaches the sanding head. *Never attempt to adjust or push a workpiece after it has begun to feed into the machine.*



Failure to follow these instructions may result in severe injury or death.

YOU MUST READ THIS MANUAL BEFORE SETTING UP AND OPERATING THIS EQUIPMENT. PERSONAL PROTECTIVE EQUIPMENT MUST BE UTILIZED BY ALL PERSONS OPERATING THIS EQUIPMENT.

OPERATING MACHINES ALWAYS INVOLVES INHERENT DANGER. THIS MANUAL PROVIDES SAFETY GUIDELINES, AND IS NOT A SUBSTITUTE FOR ENSURING A PROPER WORK ENVIRONMENT WITH PROPERLY TRAINED WORKERS AND OPERATORS. ALL MACHINES MUST BE USED WITH CAUTION, WITH SAFETY BEING OF THE UTMOST IMPORTANCE. FAILURE TO MAKE SAFETY THE UTMOST IMPORTANCE CAN RESULT IN SERIOUS INJURY TO PERSONS AND/OR PROPERTY, AND CAN RESULT IN DEATH.

SAFETY INSTRUCTIONS

THE FOLLOWING IS A SUMMARY. MORE SPECIFIC DETAILS ARE CONTAINED WITHIN THE MANUAL.

READ THIS ENTIRE MANUAL BEFORE TURNING THE EQUIPMENT ON.

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN AND VENTILATED.** Cluttered areas and benches invite accidents, and may post a fire hazard.
4. **NEVER USE IN DANGEROUS ENVIRONMENT. DO NOT** use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept out of work area.
6. **MAKE WORKSHOP CHILDPROOF** with padlocks, master switches, or by removing starter keys.
7. **NEVER FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL. DO NOT** force tool or attachment to do a job for which it was not designed.
9. **PROPER ELECTRICAL CONNECTION.** Use a grounded source; check outlets and plugs regularly to avoid electrical shock and fire hazards.
10. **ENSURE THAT THE MACHINE IS ON FLAT, STABLE GROUND BEFORE USE.**
11. **PERSONAL PROTECTIVE EQUIPMENT.** The proper safety glasses, gloves, hearing protection and footwear MUST be used.
12. **DO NOT SAND ANY MAN-MADE COMPOSITES** such as hardboard, particle board, fiber board, flake board, fiberglass and/or any other materials other than solid natural wood.
13. **NEVER POSITION ANY BODY PARTS NEAR THE INFEED ROLLER OR ANY MOVING PARTS AND AVOID LOOSE CLOTHING AND HAIR.**
14. **ENSURE THAT THE SANDER IS PROPERLY ADJUSTED AND THAT THERE ARE NO LOOSE PARTS BEFORE OPERATING.**
15. **SAND IN THE SAME DIRECTION AS THE GRAIN** of the wood.
16. **ALWAYS STAND TO THE SIDE OF THE SANDER WHILE FEEDING THE WORKPIECE. KICKBACKS CAN OCCUR.**
17. **NEVER REMOVE OR ADJUST A WORKPIECE AFTER FEEDER HAS COMMENCED.**
18. **DO NOT LOOK INSIDE THE SANDER DURING OPERATION.**
19. **DO NOT USE THE SANDER FOR DIMENSIONING WOOD, IT IS ONLY MEANT TO TOUCH THE WORK SURFACE LIGHTLY.**
20. **ALWAYS PROVIDE ADEQUATE INFEED AND OUTFEED SPACE WHEN OPERATING THE SANDER.** Always support long pieces of stock on both sides of the sander.

SAFETY INSTRUCTIONS, cont.

21. **INSPECT YOUR STOCK BEFORE** sanding. Never sand stock with nails, staples or other foreign objects which may be embedded in the surface. Do not sand lumber with loose knots that may become loose during sanding.
22. **DO NOT ATTEMPT TO REMOVE JAMS UNTIL POWER IS DISCONNECTED** and all moving parts have come to a complete stop.
23. **DO NOT SAND WORKPIECES LESS THAN 8" LONG AND 1/4" THICK.**
24. **DO NOT OPERATE SANDER WITH WORN OR DAMAGED SANDPAPER.**
25. **ALWAYS UNPLUG THE SANDER** whenever making any adjustments or changing knives.
26. **WOOD CHIP FRAGMENTS AND METAL CHIP FRAGMENTS CAN OCCUR WHILE OPERATING THIS MACHINE.**
27. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES DURING OPERATION, STOP USING THE SANDER!** Then contact our service department or ask a qualified expert how the operation should be performed.



1431 NORTH TOPPING AVE. KANSAS CITY, MISSOURI 64120
816-483-0078

Dear Woodmaster Owner,

Thank you for purchasing the Woodmaster Drum Sander. Your new sander is designed for years of service in your shop - - whether you are a commercial user or a serious hobbyist, I know you are anxious to get your sander hooked up and running, but please read this manual completely before you run your machine. It will help you get to know your sander and will point out the areas that need special attention.

Throughout the manual you will see the following four symbols. Here's a description what each means - -

- WARNING:** Failure to follow the directions could result in injury, loss of limb or life.
- CAUTION:** Failure to follow the directions could result in temporary or permanent damage to the machinery.
- NOTE:** This symbol highlights important procedures - - either in set-up or operation.
- SHOP-TIP:** We have included some of the hints, tips, and suggestions that we have learned in our shop, and other Woodmaster owners.

We've included these symbols to draw your attention to important points that deserve special attention, either for your safety, the continued performance of your machine, or to enhance the usefulness of your machine.

If you should have problems that the manual does not cover, you can reach us during regular business hours at 1-800-821-6651.

Again, thank you for your business, and best wishes in all your woodworking projects.

Sincerely,

John E. Miller
President

WARNING

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

- * Lead from lead-based paints.
- * Crystalline silica from bricks, cement, and other masonry products.
- * Arsenic and chromium from chemically treated lumber.

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

This warning is in compliance with state of California Regulations

Contents

Warranty & Contact Information	4
Model Specifications	4
Safety Instructions	5-8
Dust Removal	8
Electrical Requirements	9
Assembly Instructions	
Unpacking	10
Extension Rollers (optional)	10-12
Reversing Switch (optional)	12-15
Maintenance	
Lubrication	16
Cleaning	17
Bed Alignment	17-18
Tiebar Adjustment	19
Conveyor Tracking	19-21
Velcro Pad	21-22
Sandpaper	22-23
Installation of Digital Gauge	23
Pre-Operation Checklist	24
Operation	
Digital Scale Function	25
Using the Digital Scale	25-26
Sanding tips	27
Parts List & Exploded View	28-32
Troubleshooting	34-35
Replacing Conveyor Belt	36
Changing Corner/Crank Screws	36-37
1033 and DB500 Dust Collectors	38-44
Assembling Your System	41
Installing SA300 Wheel Kit	45
Reversing Switch for Sander	46
Maintenance Schedule	47

Customer Information

Your Woodmaster sander will last you a lifetime, if you follow the instructions and maintenance suggestions in this manual. The machine is covered by a 30-day money back guarantee of satisfaction, and by a five year limited warranty against defects in parts or workmanship.

The enclosed warranty card will aid us in filling your service requirements in the future. Please take a few moments to fill it out and return it to us.

If you have technical problems not covered in the manual, or if there are accessories you would like to order, you can reach us from 8:30 until 5:00 (Central Time Zone) Monday through Friday.

1-800-821-6651

<http://www.woodmastertools.com>

Model 2675 Specifications:

Maximum width.....	26"
Stock thickness range	0 to 5-1/4"
Shortest sandable stock	7"
Pinch rollers.....	1-1/2" diameter, non-marking molded rubber
Feed Motor	1/6 HP
Rate of Speed.....	0' to 16' per minute
Sanding head	6" diameter, dynamically balanced precision-machined steel
Bearings	1-3/16", self-aligning
Bed size.....	32" x 26"
Sanding paper	6" x 105", felt backed
Power required	30-amp service
Motor & drive system.....	Complete 5HP power package includes 220v, 23 amp, single phase 1725 RPM motor, totally enclosed ball bearing motor, switch, cord, plug V-belt, pulley
Size.....	37"wx35"dx39"h
Weight	590 lbs.

Model 3875 Specifications:

Maximum width.....	38"
Stock thickness range	0 to 5-1/4"
Shortest sandable stock	7"
Pinch rollers.....	1-1/2" diameter, non-marking molded rubber
Feed Motor	1/6 HP
Rate of speed	0' to 16' per minute
Sanding head	6" diameter, dynamically balanced precision-machined steel
Bearings	1-1/2", self-aligning
Bed size.....	32" x 38"
Sanding paper	6" x 144", felt backed
Power required	30-amp service
Motor & drive system.....	Extra heavy-duty 5 HP power package includes 220v, 23 amp, single phase, 1725 RPM motor, totally enclosed ball bearing motor, switch, cord, plug V-belt, pulley
Size.....	37"wx49"dx43-1/2"h
Weight	720 lbs.

Model 5075 Specifications:

Maximum width.....	50"
Stock thickness range	0 to 5-1/4"
Shortest sandable stock	7"
Pinch rollers.....	1-1/2" diameter, non-marking molded rubber
Feed Motor	1/2 HP
Rate of speed	0' to 25' per minute
Sanding head	6" diameter, dynamically balanced precision-machined steel
Bearings	1-1/2", self-aligning
Bed size.....	32" x 50"
Sanding paper	6" x 190", felt backed
Power required	40-amp service
Motor & drive system.....	Extra heavy-duty 7.5 HP power package includes 220v, 31 amp, single phase, 1725 RPM motor, switch, cord, plug V-belt, pulley
Size.....	61-1/2"wx38-1/2"dx43-1/2"h
Weight	947 lbs.

Safety Instructions

⚠️ WARNING

Know your power tool. Read the this manual carefully. Learn the applications and limitations of your drum sander as well as the potential hazards this tool presents.

⚠️ WARNING

Ground all tools. Check the receptacles in your shop. They should all be approved 3-prong ground-ing type. If they are not, a qualified electrician should install grounded receptacles throughout your shop. Any tool that has a three prong plug should be connected to a grounded receptacle.

⚠️ WARNING

Danger Zone. Any time your drum sander is plugged in-- even when it is switched off-- it is surrounded by a “Danger Zone”. This zone extends away from the infeed and outfeed openings, as shown in diagram 1-2. Exposure of your hands, fingers, and body to the Danger Zone should be kept to an absolute minimum.

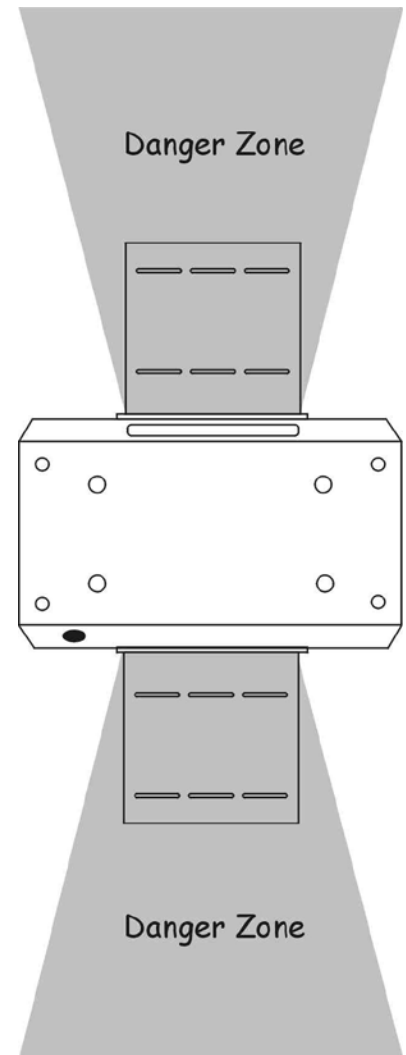
Note: Even though the outfeed is not in danger of kickback, loose knots, imbedded metal, or wood chips can come out.

Never stand directly behind the infeed table while feeding stock. Always stand to the left of the machine, out of the danger zone.

⚠️ WARNING

When the machine is not in use:

* Use padlocks, master switches, or other means to prevent unauthorized persons from starting machinery.



⚠️ WARNING

Before connecting power:

- * Replace and bolt down all safety guards.
- * Remove any loose tools or hardware.
- * Be sure no one (including you) is in the “danger zone”.

⚠️ WARNING

Before starting the drum sander:

- * Make sure the sander sits squarely on the floor.
- * Check all safety guards.
- * Make sure there is enough room in your shop for both infeed and outfeed of the stock.
- * Remove all tools and foreign material off the feed table and sander bed.
- * Clear anything that could get in your way or trip you while using the machine.
- * Advise all people present to stay clear of the “danger zone”.
- * Make sure there is no stock under the sanding head or on the conveyor.
- * Check condition of sanding belts.

⚠️ WARNING

When operating the drum sander:

- * **Wear appropriate clothes**
 - * Short sleeve shirts, or sleeves rolled up.
 - * No jewelry (including rings and watches).
 - * Long hair tied back or in a net.
- * **Wear appropriate safety gear**
 - * Face shield or safety glasses.
 - * Hearing protection.
 - * Dust mask.
 - * Non-slip shoes (steel-toes recommended).

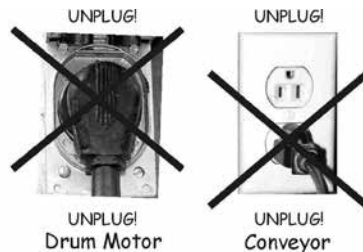
- * **Stay clear of the “Danger Zone”.** Woodmaster has positioned all controls to make it easy to stay out of the “Danger Zone”.
- * **Stay within the capacity of your machine.**
 - * Maximum sanding depth- 1/32”
- * **Never feed two boards of different thickness at the same time.** If one board is thinner than the other, the pinch rollers will not grip it securely, and there is a high risk of kickback. Boards can kick back out of the machine at over 75 MPH.
- * **Never attempt to clear dust from the sander while it is running.** Turn the machine off, disconnect the power supply, and allow the sanding drum to come to a complete stop before reaching under the cover.
- * **Feed the stock parallel to the sides of the sander.**
- * **Support long and/ or heavy boards with a roller stand or a helper.**
- * **Never sand painted or finished lumber or particleboard.** These materials will load up the sand paper.
- * **Keep hands and fingers at least 12” from the front, rear, and sides of your sander while it is operating.**
- * **Always handle the boards by the edges when feeding them into the sander. *Never stand directly behind the board.***



- * Carefully check all stock for nails, screws, imbedded bullets, loose knots, or any other foreign object that may contact the drum. Failure to do this may result in damage to the drum.

⚠ WARNING

When performing maintenance:



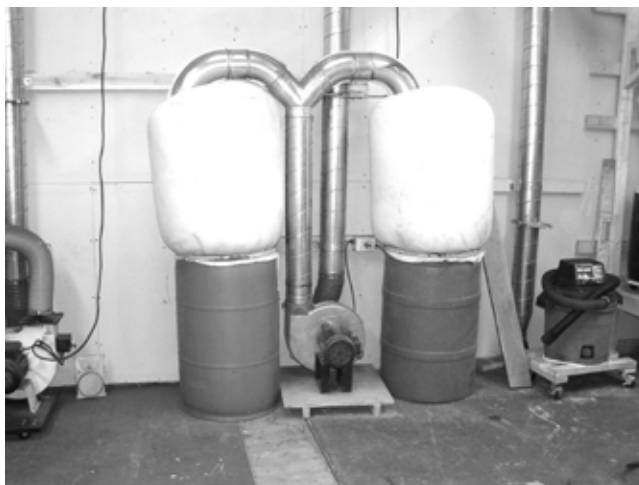
- * Unplug the drum and feed conveyor.
- * Turn drum and conveyor switches OFF.

Dust Removal

Woodmaster recommends the use of a minimum 2 hp dust collection system while operating your drum sander. Sanding dust poses fire and safety hazards, and may cause respiratory problems. Piles of sanding dust can hide power cords, lumber, tools, etc. that might cause you to trip.

The drum sander will operate more efficiently when the dust is removed before it accumulates and cakes on the pinch rollers and conveyor bed.

Even when using a dust collection system, you should provide ventilation in your shop and wear a dust mask while operating the drum sander.



Electrical Requirements

Woodmaster sanders have two motors. The large motor drives the sanding drum. The small gearmotor drives the conveyor.

***Sanding drum motor:** 230 Volts. Recommended Receptacle for 5-hp motors is a 6-30R see fig 1.



fig 1

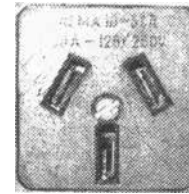


fig 2

A 10-50R for 7.5 motors, see fig 2. Do not use extension cords. Line loss could damage the motor during start-up and heavy cuts.

***Conveyor motor:** 115 Volts, 15 amps. Recommended receptacle is a standard 3-prong grounded. Do not use an extension cord. Line loss from extension cords could damage the solid state controls in the conveyor drive.

Mounting the main motor switch

****Do not plug this motor in until mounting is complete!****

The bolt pack for the motor switch is located inside the switch itself. Unscrew the (2) plastic Phillips screws located top center and bottom center of the switch. Remove the switch cover and remove the bolt pack. The bolt pack consist of (2) 8/32 x 3/4 pan head screws, (2) 8/32 flat washers and (2) 8/32 nylon nuts. **NOTE: The switch is mounted so the plug end of the switch is coming from the top of the switch. Do not mount upside down.**

Insert (1) pan head screw thru the top center of the black switch panel. (fig 3). Using a phillips screwdriver, push the pan head screw thru the side of the base leg. (fig 4).

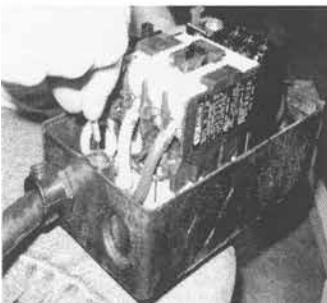


fig 3

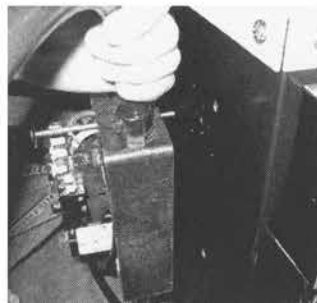


fig 4

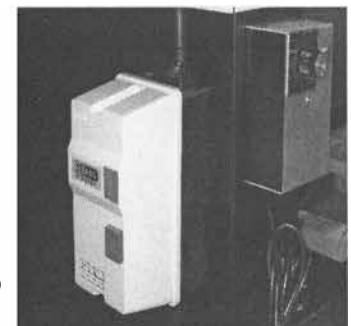


fig 5

Use (1) flat washer and nylon nut to secure the top screw using a 3/8" wrench. Repeat this for the bottom screw. Re-attach the front cover of the switch to complete the assembly. (fig 5). The switch will need to be reset anytime there is a power loss, failure or overload. The "Red" button is the reset. Simply push it to reset and push the "green" button to resume power.

Assembling Your Sander

Unpacking

1. Check for damage

Before you accept delivery, give the package a good once-over.



Look for serious damage to the shipping container. If it has dents that may go through into the machine, large tears, or tire marks on it, do not accept delivery.

Dismantle the crate. A drill with a Phillips bit will make the task much quicker.

2 Assemble the Crank

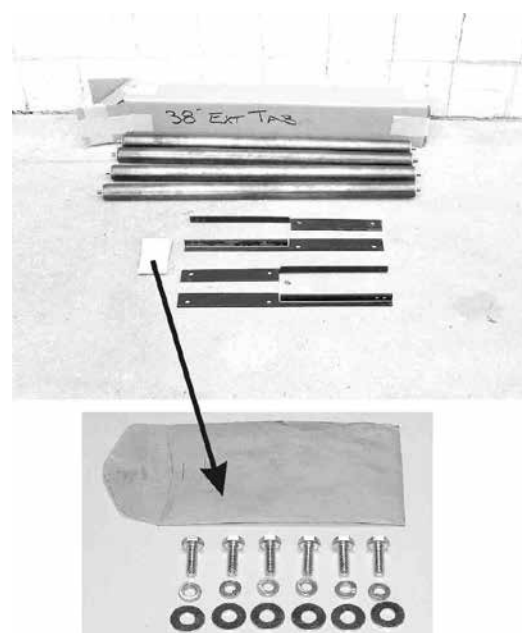


3. Bolt on the Optional Extension Rollers

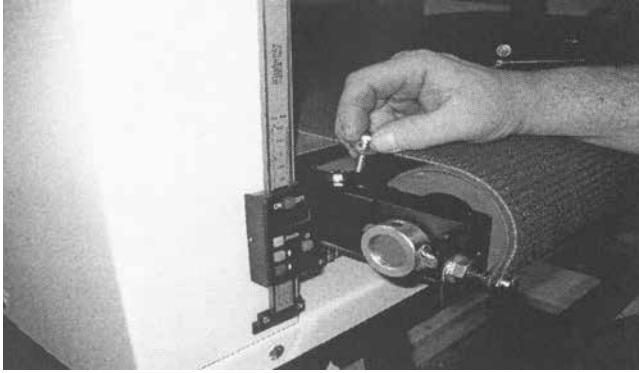
The extension rollers are an option that provides additional stability, particularly with long pieces of stock. If you purchased extension rollers, follow the instructions below to install them.

a. Open the Extension Table box.

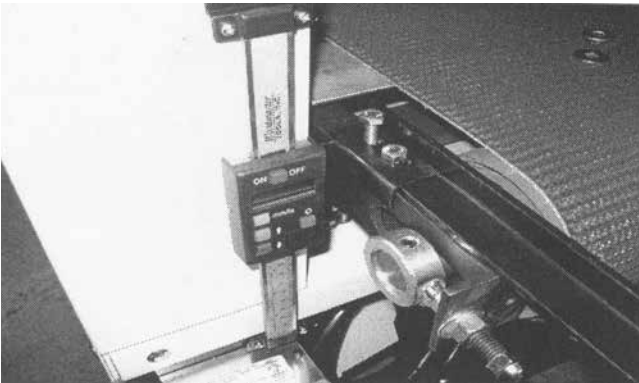
The box contains four rollers, four brackets, and a packet of hardware.



- b. Remove the Digital Scale Indicator by removing the (2) bolts that secure it to conveyor frame and (1) sheet metal screw located at the bottom of the indicator as shown.



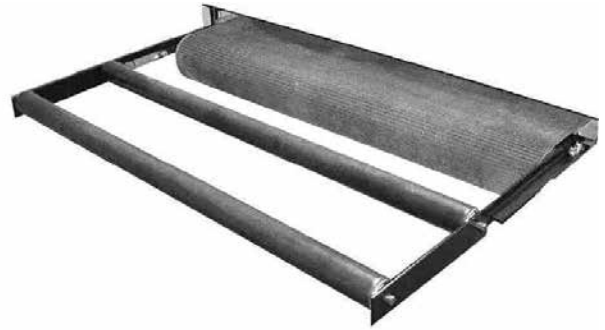
- c. Bolt the left infeed extension bracket in place, with the indicator scale bracket on top of the extension bracket as shown. Tighten the bolts finger-tight only.



- d. Attached the right infeed extension bracket. Again, only finger tight.



- e. Insert the extension rollers into the brackets. It is easiest to install the roller closest to the machine first.



- f. With the rollers in place, tighten down all four bolts holding the extension brackets. Using the same procedure, attach the rollers for the outfeed.



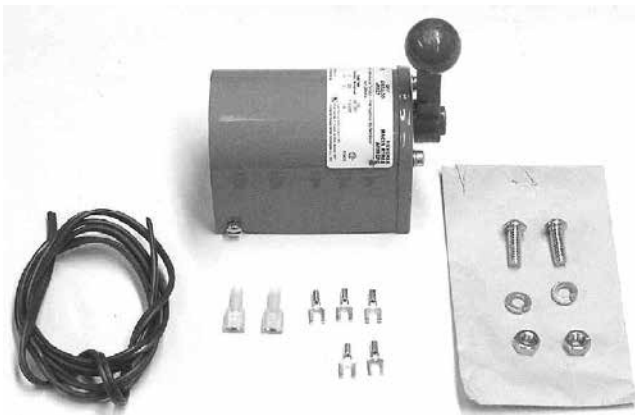
Install the Reversing Switch

The reversing switch is an option that allows you to feed stock backwards through the sander. This is very useful when making multiple passes on large pieces, as it allows the operator to bring the piece back for the next pass without removing it from the machine.

Connect the wires to the switch

a. Switch kit includes:

- (1) Drum Switch
- (2) 1/4-20 x 1" bolt
- (2) 1/4" flat washer
- (2) 1/4" lock washer
- (2) 1/4-20 hex nut
- (2) female spade connector
- (4) fork spade connector
- (15") 18/2 wire



- b. Loosen the two screws on the bottom. The bottom of the reversing switch and pull the front cover off.
- c. Disconnect the wire coming out of back of the control box that connects to the gear motor by pulling the the connectors apart.

- d. Cut the (2) female connectors off the end of the control box wires and replace them with (2) Fork spade connectors.



- e. Using the 18/2 wire, strip one end of the wire and connect the other (2) fork spade connectors. On the opposite side, strip the wire back and Install the (2) female spade connectors.



- f. Run the end of the 18/2 wire with the Fork spade connectors up thru the bottom of the switch & connect fork spades to the Center terminals of the switch, (1) on the Left and (1) on the right.

Next, follow instructions on mounting the switch to the base of the machine!

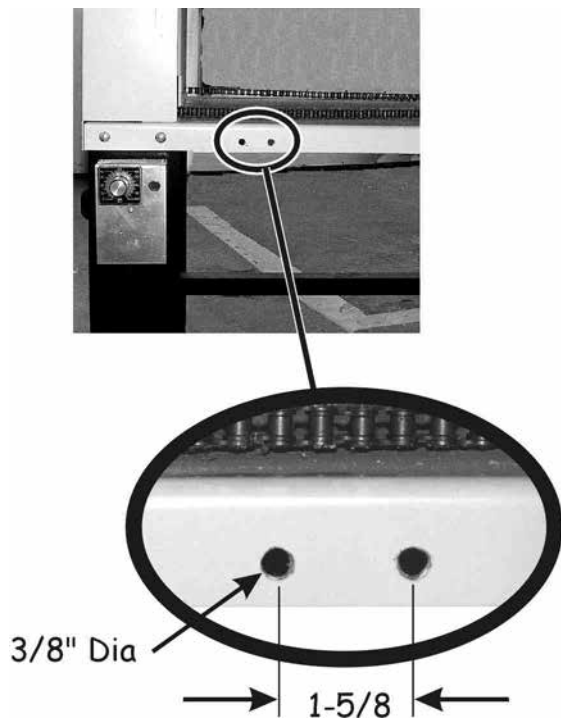
After the switch is mounted, you can make final connections from the control box by running the wire with the fork spade Connectors up thru the bottom of the switch and connect the fork spades to the top right & bottom right terminals of the switch.

Next connect the end of the 18/2 wire with Female connectors to the gear motor.

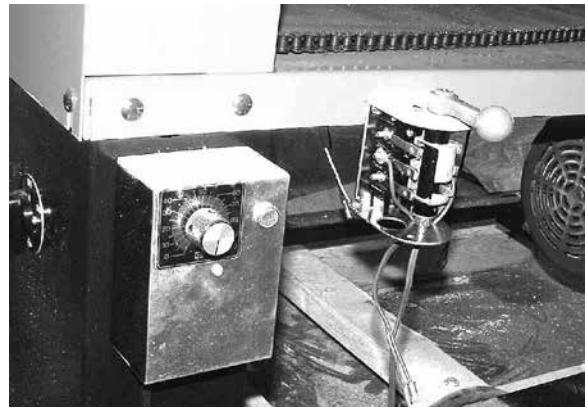
Once completed, make certain reversing switch is in the “neutral” position and turn the control box on full speed. Move reversing switch lever to “forward” and check direction of conveyor belt. It should be moving in the forward motion. If not, simply reverse the (2) wires going into the gear-motor from the reversing switch.

Fasten the Optional Switch the Frame

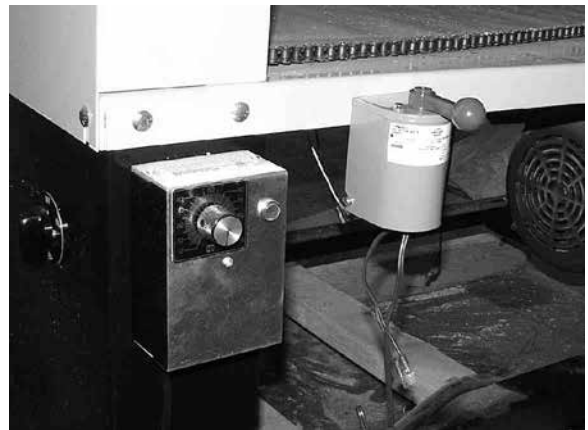
- a. Drill two 3/8” diameter holes 1-5/8” apart in the cross beam above the speed control (see illustration below).



- b. Bolt the reversing switch to the frame, using the two holes you drilled.

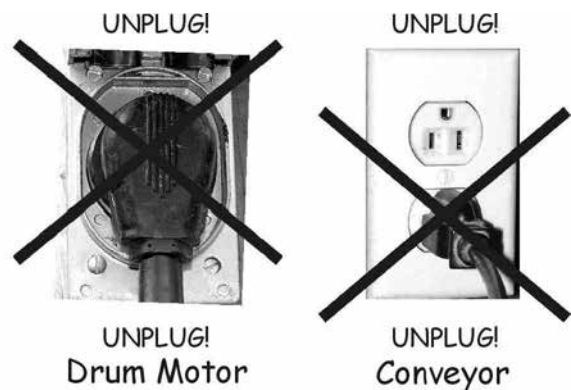


- c. Replace the switch cover.



Wire the Switch to the Sander

- a. **Unplug the drum and conveyor motors.**



b. Disconnect the speed control from the feed motor.

c. Connect the two short wires to the leads feed control.



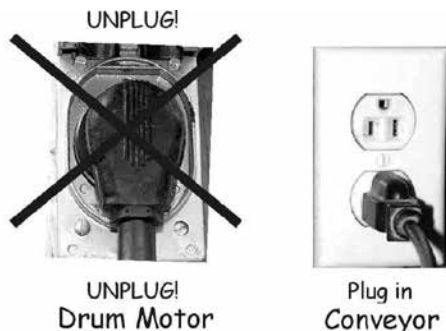
d. Connect the two long wires to the leads to the feed motor.



Check the feed direction

a. Make sure the feed control and reversing switch are **OFF**.

b. Plug in the feed control (110 V).



c. Turn the feed control on.

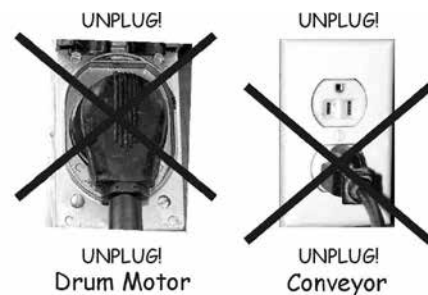
d. Turn the reversing switch to the **forward** feed position.

e. If the conveyer turns in the direction that would move the stock from the infeed table through the sander, the feed direction is correct.

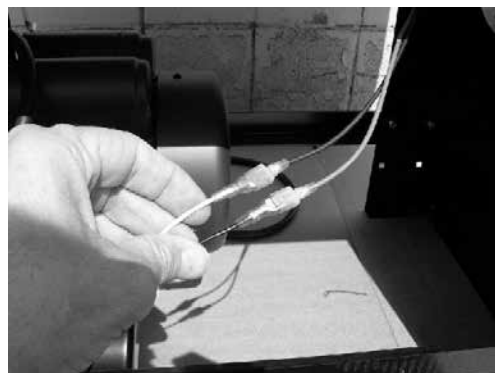
f. If the feed rollers turn in the direction that would push stock away from the infeed table, follow the instructions below:

*Turn off the feed control.

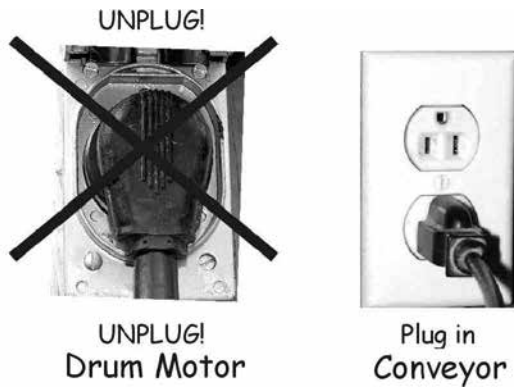
* **Unplug** the feed control.



* Reverse the feed control wires (these are the long wires that go from the reversing switch to the conveyer motor).



* plug in the feed control.



* Test the feed direction again.

The drum sander is now ready for use.

⚠ CAUTION

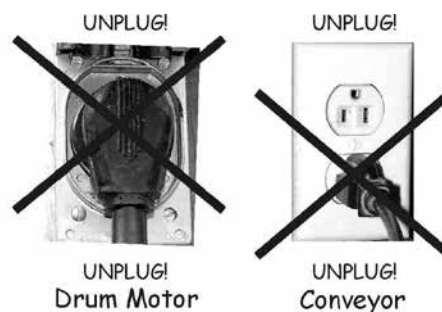
Always turn the feed off, and allow the conveyor to stop before reversing the feed direction.

Maintenance

With proper care and maintenance, your Woodmaster drum sander will provide years of trouble-free service. This chapter covers preventative maintenance, as well as repair of common problems that you may encounter with your machine.

⚠️ WARNING

Any time you remove the hood or perform an operation that puts your hands at risk, unplug the motors.



Lubrication

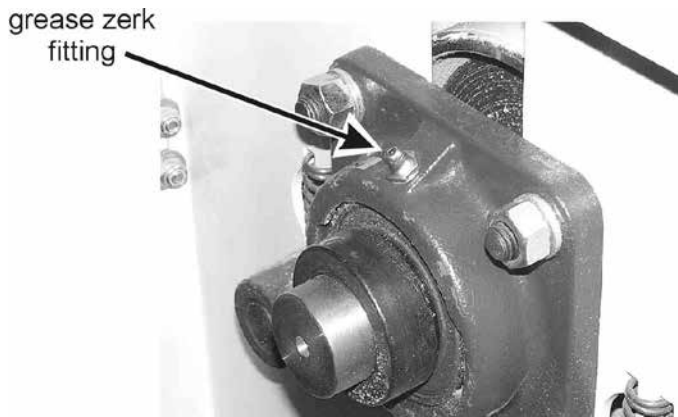
- The table jackpost screws should be cleaned and lubricated any time you notice an increase in the force required to raise or lower the bed. Powdered graphite works best for this application.



- The bushings which support the feed rollers are impregnated with a light machine oil. Apply a few drops of machine oil to the bearing surface between the pinch roll shafts and the bushings every eight machine hours, or if the machine has not been used for more than one week.



- c. The drumhead bearings are designed to swivel in the cast housings for self-alignment. To facilitate this swivel action, each housing is fitted with a grease zerk. These housings should be greased every 25 machine hours. Use a good quality high temperature lithium grease.



Cleaning

- a. Clean the dust from the machine each time it is used. This may be done with a shop vacuum or an air compressor.

Dust or wood chips on the conveyor can cause variations in board thickness, and reduce the effectiveness of the sanding drum.

- b. Clean sap or resin from the pinch rollers with alcohol.

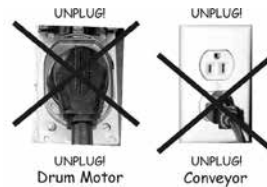
Pinch rollers lose their effectiveness when they are coated with sap or resin. Do not use petroleum products (mineral spirits, kerosene, gasoline, or diesel fuel) to clean pinch rollers. They will leave residue on your stock.

Bed Alignment

The bed to drumhead alignment is a critical adjustment on your sander. If the bed and drum are not perfectly parallel, your finished stock will be thinner on one side than the other. While this adjustment should not be necessary very often, it should be checked periodically.

⚠ WARNING

Test the Bed Alignment

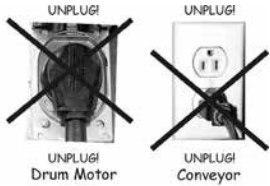


- a. **Unplug the drum and conveyor motors.**

- b. Place a small piece of scrap stock beneath the left end drum.
The scrap should be short enough that it does not touch the pinch rollers.
- c. Adjust the height of the bed so that the sanding drum just touches the scrap of wood.
- d. Slide the scrap from left to right across the bed.
* If the stock binds at the right side of the drum, the bed is too high on that side.
* If the stock does not touch the drum, the bed is too low.

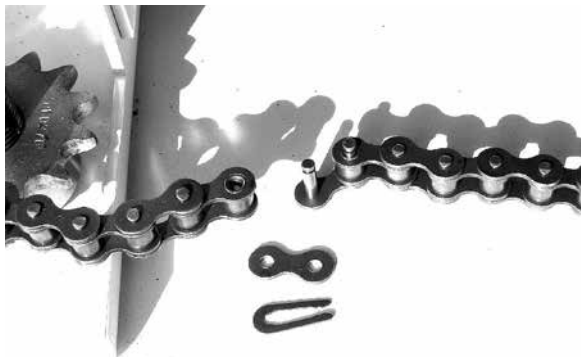
- e. If you have determined that the bed is out of alignment with the sanding drum, follow the instructions below.

Adjust the Bed Alignment

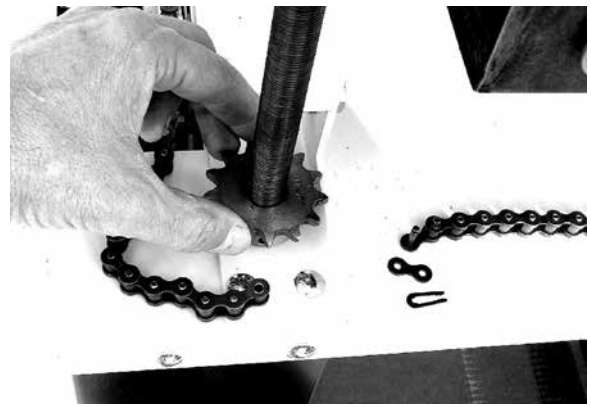


- a. **Unplug the drum and conveyor motors.**

- b. Remove the master link from the chain.

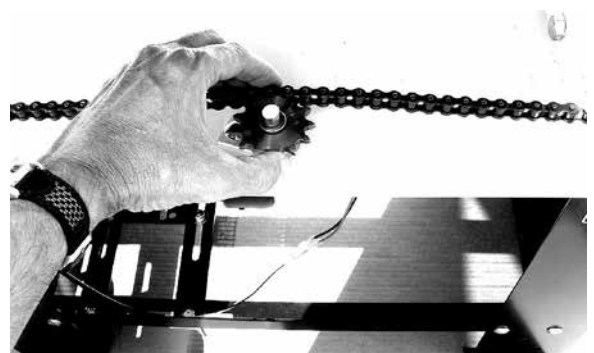


- c. Remove the chain from both sprockets on the right side of the machine.
- d. If the right side of the bed is high, turn **both** sprockets on the right side the same distance counter-clockwise.
Each revolution is 1/16". One tooth is .005".
- e. Remove the chain from both sprockets on the right side of the machine.



- f. If the right side of the bed is low, turn **both** sprockets on the right side the same distance clockwise.
- g. Without connecting the link, slide the scrap 2X4 left to right to re-check for alignment.
- h. Continue to test and adjust, until the bed is parallel with the cutter-head.
- i. When the bed is aligned, carefully replace the chain on the sprockets and install the master link.
- j. After assembling the master link, re-tighten the idler gear.

Note: If the chain is too tight, loosen the idler gear.



Jackpost and Tiebar Adjustment

The tiebars (see exploded view) perform three functions on your sander:

- * Hold the sides in position.
- * Upper pivot for the jackposts.
- * Support for the sander bed by holding the jackposts against the base of the sander.

Check Tiebar Adjustment

- Try to raise the front edge of the sander bed.

If there is up and down play in the bed, adjust the tiebar.

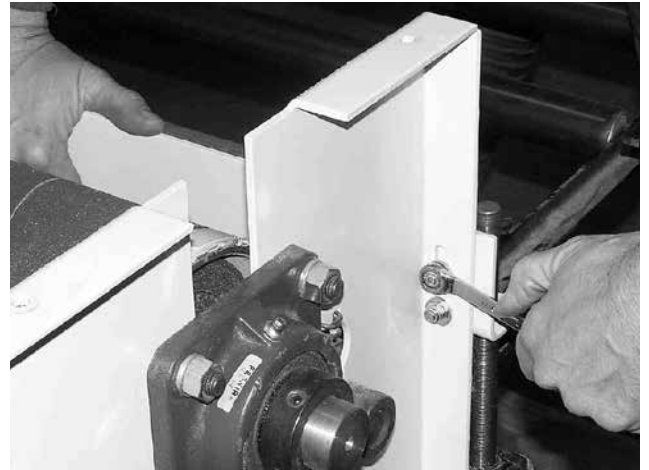
Adjusting the Tiebar

- Loosen the carriage bolts that hold the tiebar in place.



- Push straight down on the center of the tiebar while re-tightening the bolts.

Note: An extra pair of hands is welcome in the shop for this procedure.

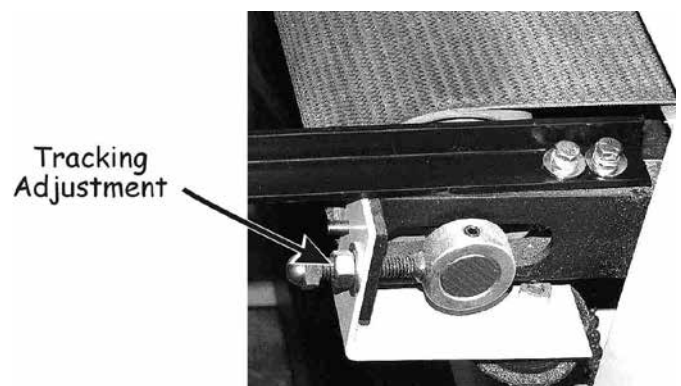


- Repeat the procedure on the other tiebar.

Conveyer Tracking

The conveyor belt will last for years and will not stretch providing over-tracking is not performed. Proper tracking of the belt will aid in the life of the belt. Over-tightening the belt will cause the belt to “Stretch” and fail prematurely.

During production, the belt is tracked running in “normal operating direction” infeed to outfeed.



Looking underneath the infeed side of the machine and to the right side of the conveyor is a “Tracking” wheel. Under normal direction, the side of the belt should be resting against the tracking wheel.

When the belt is properly tracked & tighten, it is normal for the left side of the belt to be tighter than the right side. This is what keeps the belt up against the tracking wheel.

MAKING ADJUSTMENTS TO THE BELT UNDER NORMAL OPERATING DIRECTION.

(INFEED TO OUTFEED ROTATION)

If the belt has wandered to the left (belt is no longer riding against tracking wheel) you will need to re-track the belt. To re-track, first measure how much the belt has moved to the left. If it has moved more than 1/4” away from the tracking wheel, use a 9/16” wrench to loosen both the left side & right side tracking nuts to where the infeed conveyor drum can be pushed inward to loosen the conveyor belt.

Move the belt to the right by hand so that it is up against the tracking wheel. Re-tighten the tracking nuts 4 full turns clockwise. Turn the conveyor belt on full speed. Standing on the outfeed of the machine, put pressure against the belt to see if you can stall by hand.

If so, turn both tracking nuts 2 more full turns and check again. Once you cannot stall the belt by hand, proper tension is achieved against the belt. However, it still needs to be properly tracked.

Let the belt continue to run keeping an eye on the tracking wheel and the edge of the belt. If after 2-3 minutes of running the belt starts moving left, “TIGHTEN” the left tracking nut (1) full turn. Allow the belt to continue to run again keeping an eye on the tracking wheel & edge of belt. After 2-3 minutes of run time, the belt should be moving towards the tracking wheel. Once the belt has contacted the wheel, it should not move any further. If the edge of the belt begins to roll under, it has moved too far right. Simply, back off the left tracking nut by 1/2 turn. Keep a close eye on the conveyor movement. It may need to be adjusted from time to time.

WARNING: DO NOT make drastic adjustments to the tracking nuts. Minimal turns should be done to track belt (Less than 1 turn). The belt should always be running normal operating direction when making adjustments and it is normal for it to take 2-3 minutes of run time before the belt will respond to adjustment.

While sanding with the machine, if the conveyor belt begins to slip or stop, first make certain the rear conveyor drum is not stopping. If the drum is stopping, contact us for further evaluation.

If the belt slips or stops but the drum is turning, you may be sanding too aggressively. DO NOT attempt to tighten the conveyor belt to solve this issue. It may ruin the conveyor belt. Simply back off the depth of cut to see if this solves the issue. If not, contact us for further assistance.

MAKING ADJUSTMENT TO THE BELT WITH THE REVERSING SWITCH INSTALLED.

When using the reversing switch, the belt will ultimately wander left. After a period of time, the belt will begin to rub against the conveyor frame so it will need to be re-aligned.

WARNING: Failure to re-track the belt will cause premature failure and wear to the belt. DO NOT attempt to tighten the conveyor belt to solve this issue. You must re-track the belt properly.

Again, using a 9/16" wrench, loosen both the left side & right side tracking nuts to where the infeed conveyor drum can be pushed inward to loosen the conveyor belt.

Move the belt to the right by hand so that it is up against the tracking wheel. Re-tighten the tracking nuts 4 full turns clockwise. Turn the conveyor belt on full speed. Standing on the outfeed of the machine, put pressure against the belt to see if you can stall by hand.

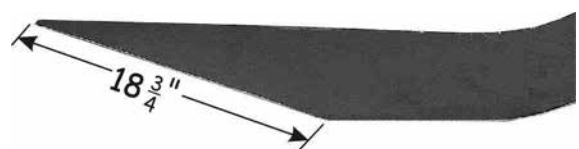
Follow the procedure as shown in "Normal operating direction". This will need to be done on a regular basis when using the reversing switch.

Replacing the Velcro Pad

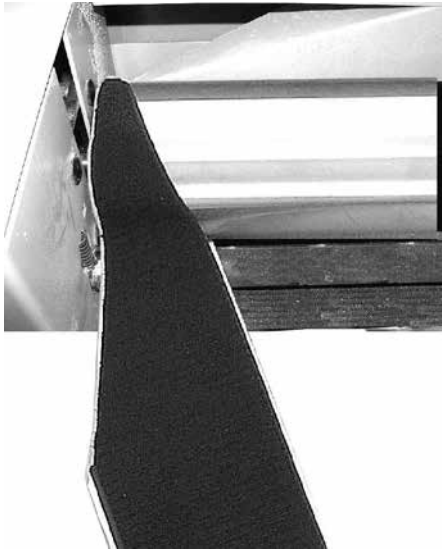
In the event that the Velcro pad should become worn or torn, follow this procedure for replacement.

Note: If the Velcro starts to peel up, it can be attached to the drum with rubber cement.

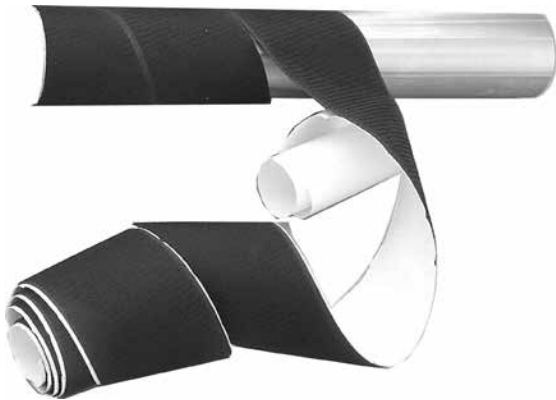
- a. Remove the old Velcro pad.
- b. Clean the metal drum.
Stripeeze varnish remover is an excellent solvent for cleaning the drum.
- c. Cut the replacement velcro strip on a diagonal, as shown below:



- d. Peel back about 8" of paper, and wind the cut edge against the edge of the drum.



- e. Continue to peel the paper backing, and roll the velcro onto the drum.



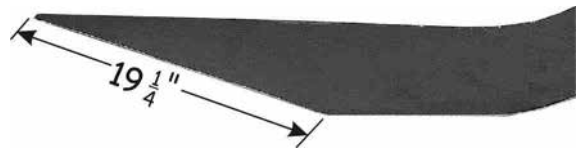
It is OK to have a slight gap between spirals, but do not overlap the velcro, or there will be bumps that affect the quality of the surface.

- f. Trim the end of the velcro even with the end of the sanding drum.

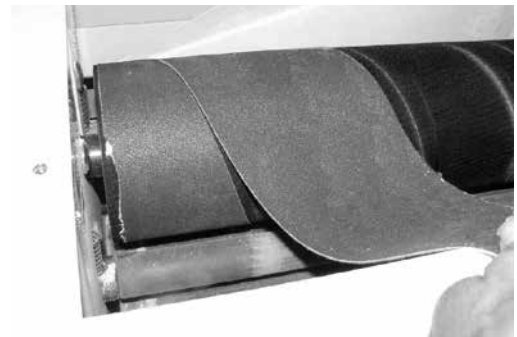
Replacing the Sandpaper

The Velcro Mount system makes it easy to replace sandpaper. Just peel off one piece and roll on another in its place.

- a. Remove any chips or other foreign material from the velcro pad.
- b. If putting new sandpaper on the pad, trim the end on a diagonal, as shown below

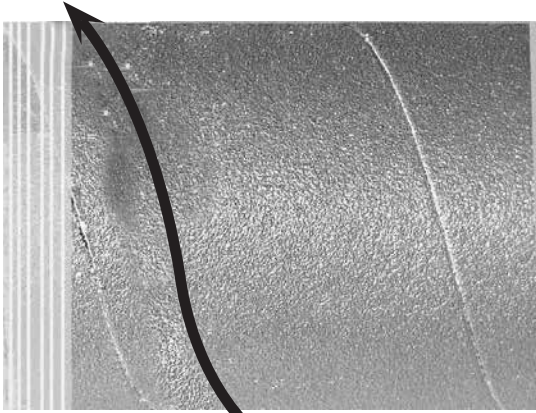


- c. Remove any chips or other foreign material from the back of the sandpaper strip.
- d. Roll the sandpaper strip onto the velcro wrapped drum.



It is OK to have a slight gap between spirals, but do not overlap the paper, or there will be bumps that affect the quality of the surface.

- e. If putting on a new piece of sandpaper, trim the ends.
- f. Tightly wrap two layers of filament strapping tape around the right edge of the sandpaper that would unwind when it contacts the wood.



Direction of rotation

Strapping Tape

If wrapped as shown, the tape would go on the left side as viewed from the infeed end.

Without the tape, the sandpaper unwraps when it comes in contact with the wood, creating a hazard, and possibly damaging the machine.

Note: Do not tape the other end of the sandpaper. This allows the sandpaper to self-tighten on the drum.

Installation of Digital Gauge

Note: If you ordered a digital scale with your sander go to page 25

The Digital Gauge Comes With;

- Digital Gauge (DG1)
- (2) Phillips Head machine screws mounted on the back of the gauge
- (1) LR44 Battery mounted in gauge

(DG3) Installation Hardware.

- (1) Sheet Metal Screw
 - (1) L-Shaped Mounting Bracket(1)
- Digital Gauge Manual (go to page 25 for operation instructions)



Tools Needed

On older Sanders you have to drill.

- Phillips Screwdriver
- 1/8" Drill Bit
- Drill
- 7/16" Wrench

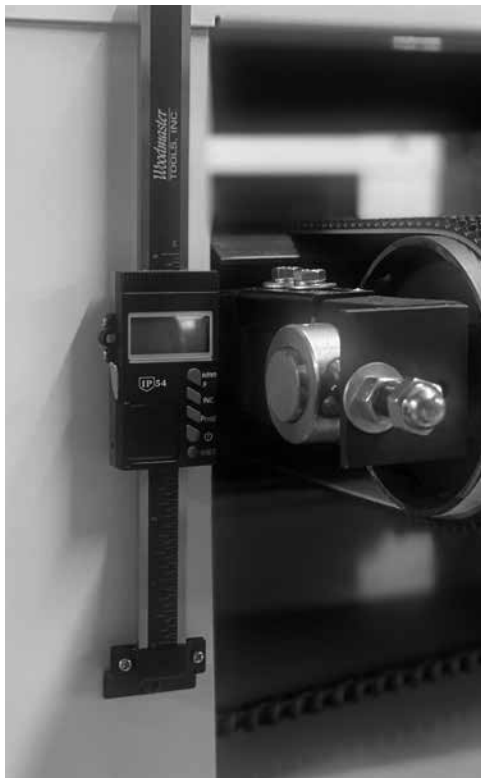
1. Attach the L shaped bracket to the back side of the Digital Gauge using the (2) machine screws found on the back of the gauge. Mount the bracket

to the two horizontal holes on the top back side of the Gauge.

2. If your sander has a red pointer remove the Red Pointer from the conveyor frame using a 7/16" wrench. Install the bracket in place of the pointer. Lower the conveyor frame all the way down to where it stops. Align the steel scale at "0" to the bottom of the black panel.

3. Mark and drill a hole thru the bottom mounting bracket onto the hood side of the sander.

4. Refer to the Digital Gauge Manual operation instructions (start on page 23) for instructions to setting the pre-sets and to learn the operation of the gauge.



Pre-Sanding Checklist

Each time you use your sander, go through this quick checklist:

- Sander sits flat and level
- Adequate room for infeed and outfeed of stock
- All safety shields in place and secure
- All tools and other material clear of the planer
- No wood under the sanding drum
- No caked-on dust on pinch rollers
- Sanding belt in good condition
- Drum motor switch **OFF**
- Conveyor motor switch **Off**
- Drum motor plugged in
- Feed motor plugged in
- Electrical cords out of the way
- Work area clear of hazards
- Safety glasses on
- No loose sleeves
- No jewelry
- Long hair tied back
- Danger Zone CLEAR

Operation

This section of the manual discusses the operation of your drum sander.

Digital Scale Functions, Battery & Maintenance.

Functions:

On/Off-"red button"

Mm/in.-"yellow button"-changes from millimeters to inches in decimals.

Preset button up-"orange button"-increases value.

Preset button down-"blue button"-decreases value.

NOTE: Preset buttons require holding them down for approx. 5 seconds before value changes. Continue to hold down until desired value is reached.

Zer-"green button"-zero's the gauge at any time.

Battery required. 1.5v oxide button cell. (Life 1 year in continuous operation). Operating temperature: 0-40 degree C Maximum operating range: 0"-6.67" in inches or 0-169.3 millimeters.

Battery Replacement:

The battery cover is located directly under the Zero button. Slide the door to the right to remove the cover. Replace battery with positive side facing out. Slide the battery cover back into place.

Maintenance

Keep the working face clean and dry. Prevent liquids from getting onto the frame. Clean body with liquid dish soap. Do not use petroleum based lacquer thinner, industrial alcohol or spirits.



Using the digital gauge.

The digital scale is pre-set from the factory. However, take this time to check the scale readout in insure it's still properly set. Make sure the sander motor is "off".

- a. Turn the power on to the digital gauge. The readout of the gauge should read around 2.70. To check the gauge for accuracy, use a piece of wood of a desired thickness. (Example: 3/4" thick).
- b. Raise the conveyor bed up until the piece of wood barely contacts the sanding drum. The gauge now should read 0.75. If so, the gauge is accurate. If not, continue to next step.
- c. To re-set the gauge, press and *hold* down the "orange" button to increase the reading, or the "blue" button to decrease the reading to 0.75. **Remember** you must hold the pre-set buttons for about approximately 5 seconds for the value to change.
- d. The gauge is now indexed from the conveyor belt to the drum.

Decimal equivalents:

The digital gauge reads to the nearest 1/100th inch (0.01”). The following chart provides decimal equivalents for fractional measurements.

.03 == 1/32	.50 == 1/2
.06 == 1/16	.53 == 17/32
.09 == 3/32	.56 == 9/16
.12 == 1/8	.59 == 19/32
.16 == 5/32	.62 == 5/8
.19 == 3/16	.66 == 21/32
.22 == 7/32	.69 == 11/16
.25 == 1/4	.72 == 23/32
.28 == 9/32	.75 == 3/4
.31 == 5/16	.78 == 25/32
.34 == 11/32	.81 == 13/16
.37 == 3/8	.84 == 27/32
.40 == 13/32	.87 == 7/8
.43 == 7/16	.90 == 29/32
.46 == 15/32	.93 == 15/16

The memory in the gauge will maintain the index setting as long as the “zero” button or pre-set buttons are not pressed. Even when the gauge is in the “off” position and conveyor bed is cranked up or down, the digital gauge will adjust accordingly.

At anytime the ‘zero’ button is pushed, the gauge will be re-calibrated to zero and the distance between the conveyor bed and sanding drum will be in-accurate.

WARNING

Serious damage to the machine and/or personal injury could result in improper settings. If at anytime the gauge is reading thicker or thinner than the actual work piece, this could cause a kickback and result in injuries. Never feed a board without indexing the gauge to the sanding drum.

Operating the sander:

Drum sanding can be divided into three steps.

- * Primary sanding-develops a flat surface with little concern for the sanded finish.
- * Secondary sanding-removes primary sanding scratches
- * Finish sanding-removes secondary sanding scratches. Finish sanding should remove only a few thousands of an inch.

CAUTION

Do not remove too much wood. The sander is intended to give smooth surfaces to the wood. It is not meant to replace a planer. With course (100 grit) sandpaper, the stock removal should not exceed 1/32”. Remember each full turn of the crank handle changes the bed height by 1/16”. If you are working with stock of varying thickness, sand the thicker boards down to the thinner ones before running all boards at a single setting.

Do not over-exert your sander

Depending on which grit you use and the width of your workpiece will determine how much material you may remove in a single pass. Example, sanding a piece of hardwood that is 8" wide and using 100 grit, you may achieve a depth of 1/32" or 0.03. Using the same grit on a piece that is 24" wide would require a lesser depth of 1/64" or 0.01 to 0.02. This would keep the paper and velcro from over-stressing thus damaging either paper and/or velcro.

Make very fine adjustments when sanding. Remember, this is not an abrasive planer.

Make multiple passes.

For the best results, make three passes at the same height setting. The velcro provides enough cushion that the sander will continue to remove material.

Experiment with different feed rates.

In most cases, the faster the feed rate, the better the overall finish product. Running the conveyor speed at 75% or more on the speed control dial will achieve the most successful finish. The slower the board passes under the sanding drum, the more friction is being created thus causing the soft grain of the wood to raise causing a "waviness" in the workpiece. Furthermore, it may cause the paper to "load-up" thus decreasing the life of the paper.

Some woods such as "Cherry" will tend to burn on slower speed settings.

Cross-Grain sanding.

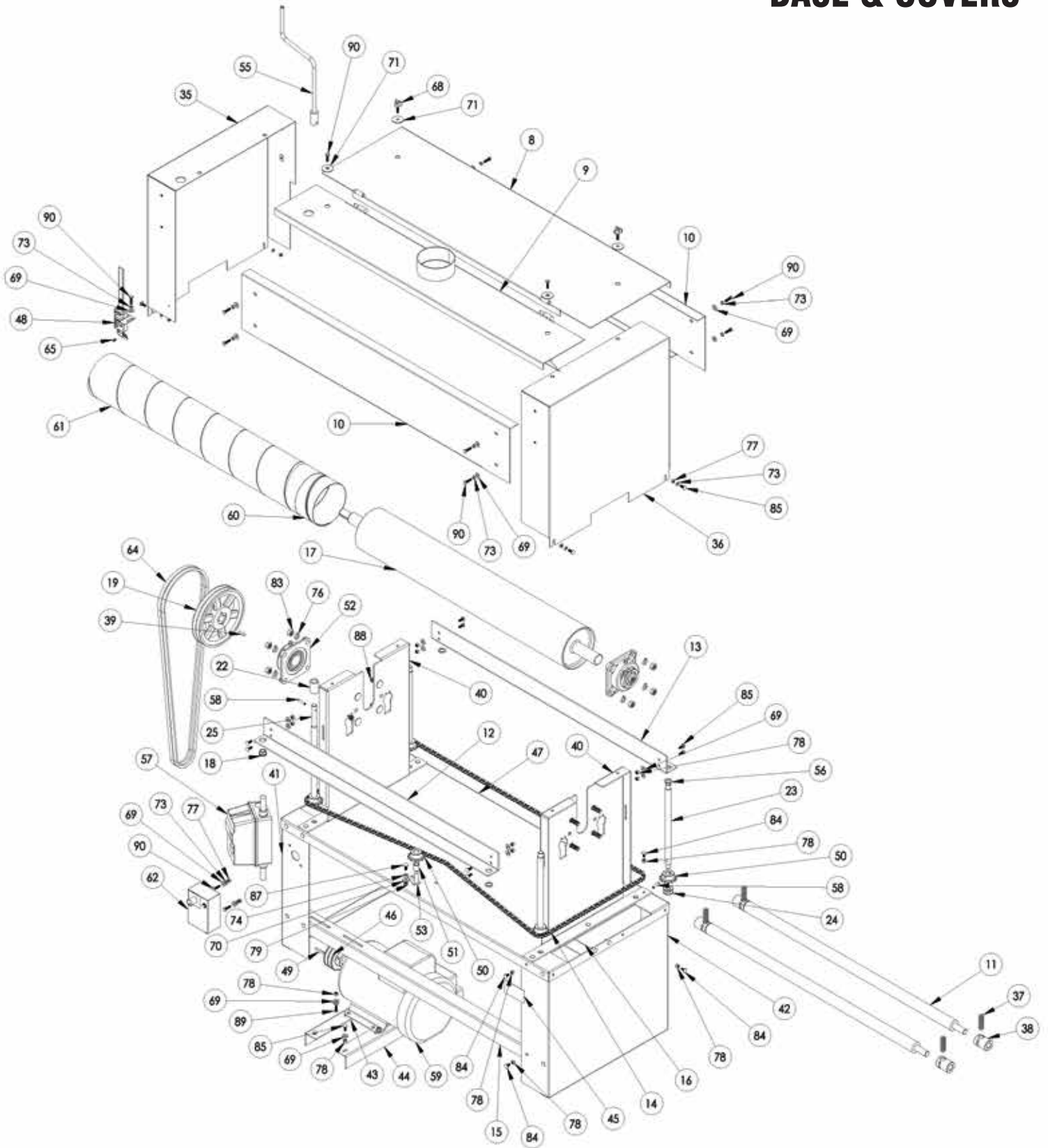
You can sand cross grain with your sander for flatness. However, the unit will leave cross grain scratches in the material. An orbital or palm sander is needed to remove cross grain marks.

At any time the grain changes while being sanded, marks will be apparent and the use of a palm or orbital sander will be needed.

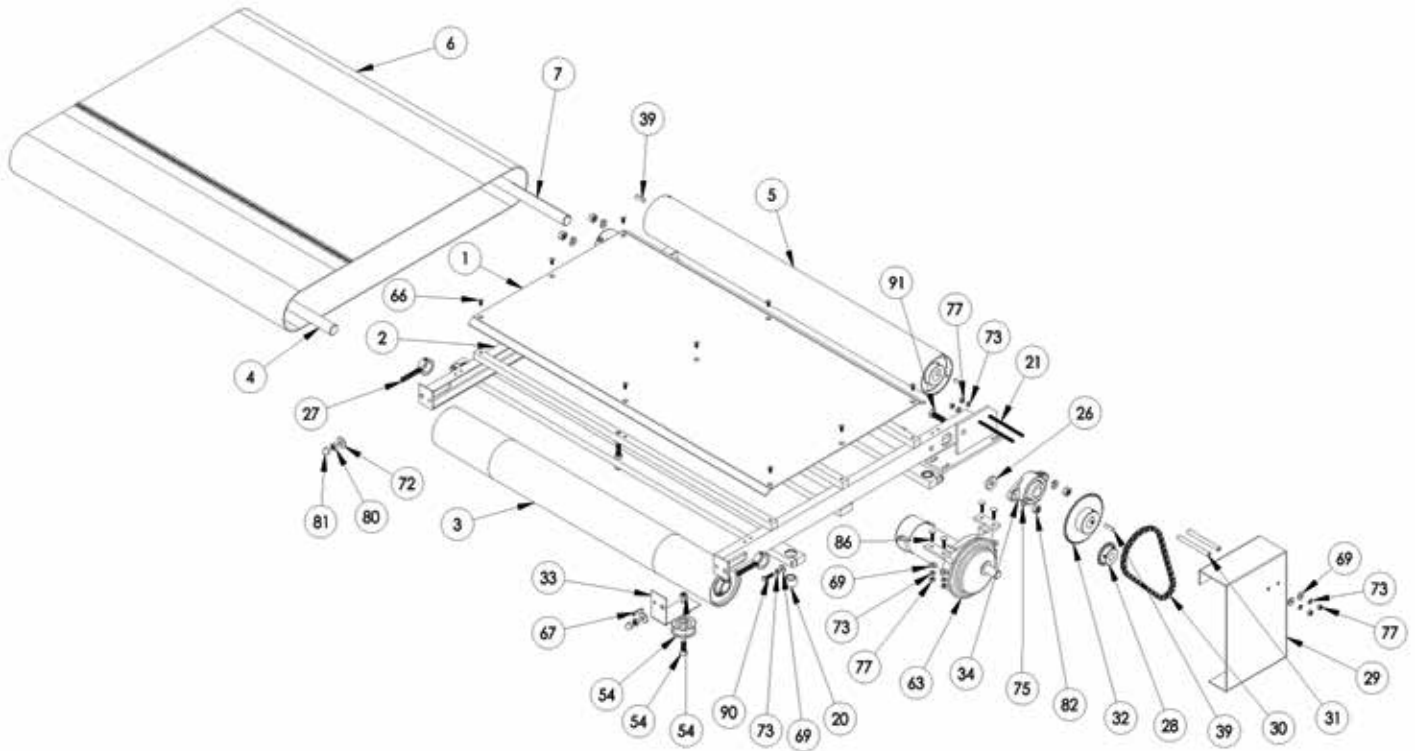
Just as in a wide belt sander, drum sanders were designed to alleviate the process from hand held belt sanders and at a much faster time-frame. The design gives you a flat, smooth surface but the final steps in sanding calls for the use of a palm or orbital sander.

SINGLE DRUM SANDER

BASE & COVERS



SINGLE DRUM SANDER CONVEYOR & FRAME



Repairs to Sanders built
PRIOR TO 2001 will require
part # 3820SB (Sander Block)

NOTE: YOU MUST DRILL AND
BOLT THIS PART TO (D28)
SIDEFRAME



Sanders built AFTER 2001 will have
part # CD30 (Swivel Nut) Installed.



2675 DRUM SANDER

ITEM	PART NUMBER	DESCRIPTION	QTY.	ITEM	PART NUMBER	DESCRIPTION	QTY.
1	CV-02	26" BED PLATE	1	47	D-42	26" BASE TOP	1
2	CV-03	26" CONVEYOR FRAME	1	48	DG-1	DIGITAL SCALE INDICATOR	1
3	CV-04	26" INFEED CONVEYOR DRUM	1	49	700013	1/4" x 1-3/8" SQUARE KEY STOCK	1
4	CV-09	26" INFEED CONVEYOR DRUM SHAFT	1	50	W-4	IDLER CHAIN SPROCKET	5
5	CV-18	26" OUTFEED CONVEYOR DRUM (FLAT)	1	51	W4BSH	IDLER CHAIN BUSHING	1
6	CV-24	26" CONVEYOR BELT	1	52	D-23	1-3/16" ID FLANGE BEARING	2
7	CV-26	26" OUTFEED CONVEYOR DRUM SHAFT	1	53	WR-45	CHAIN TENSIONER	1
8	CV-32	26" HINGE HOOD TOP	1	54	WR-62	IDLER PULLEY	1
9	CV-34	26" DUST CHUTE ASSEMBLY	1	55	WR-84	CRANK HANDLE	1
10	D-11	26" HOOD COVER PANEL	2	56	WR-549	5/8" ID MACHINE WASHER	3
11	D-17	26" PINCH ROLLER	2	57	WR37M	MOTOR SWITCH W/ CORD & PLUG ASSY	1
12	D-38-1	26" CROSS BRACE FRONT	1	58	700033	1/4" x 1-1/4" ROLL PIN	5
13	D-38	26" CROSS BRACE REAR	1	59	2675P	5 HP AC MOTOR	1
14	D-39	26" BED CHAIN	1	60	26VM	4" x 138" VELCRO STRIP	1
15	D-48	26" LEG TIE FRONT	1	61	26100S6	100 GRIT SANDING STRIP 6" X 105"	1
16	D-47	26" LEG TIE REAR	1	62	718CB	CONTROL BOX	1
17	D-54	26" SANDING DRUM	1	63	718GK	1/6 HP DC GEAR MOTOR	1
18	CD-13	5/8" ID FLANGE BUSHING	1	64	A-66	68" DRIVE BELT	2
19	CD-29	FIXED BORE HEAD PULLEY	1			STANDARD COMMEN HARDWARE	
20	CD-30	SWIVEL NUT	4	65	200001	#10 x 1/2" PHILIPS PAN HEAD, ZINC	1
21	CD-38	1/4"-20 THREADED ROD	2	66	200003	10-32 x 1/2" FHSCS, ZINC	9
22	CD-39	TABLE LIMIT STOP	1	67	200005	1/4" x 1 1/8" ROLL PIN	1
23	CD-40	CORNER SCREW	3	68	200007	1/4"-20 THREADED KNOB, THREE-ARM	2
24	CD-41	5/8" THRUST WASHER	8	69	700025	1/4" USS FLAT WASHER, ZINC	41
25	CD-42	CRANK SCREW	1	70	700045	5/16" USS FLAT WASHER, ZINC	1
26	CD-55	OUTFEED CONVEYOR BEARING SPACER	1	71	200015	5/16" FLAT WASHER, LARGE OD 1-1/2"	4
27	CV-08	TAKE-UP TRACKING ADJUSTMENT	2	72	200027	3/8" USS FLAT WASHER, ZINC	2
28	CV-14	GEAR MOTOR SPROCKET	1	73	200009	1/4" SPLIT LOCK WASHER, ZINC	29
29	CV-16	GEAR MOTOR GUARD FOR 1/6HP	1	75	200035	7/16" SPLIT LOCK WASHER, ZINC	4
30	CV-17	GEAR MOTOR CHAIN FOR 1/6HP	1	76	200035	7/16" SPLIT LOCK WASHER, ZINC	4
31	CV-21	GEAR MOTOR GUARD SPACER	2	77	700029	1/4"-20 HEX NUT, ZINC	14
32	CV-27	CONVEYOR DRIVE SPROCKET	1	78	700027	1/4"-20 NYLON-INSERT HEX LOCKNUT, ZINC	44
33	CV-35	TRACKING BRACKET	1	79	700047	5/16"-18 NYLON-INSERT HEX LOCKNUT, ZINC	1
34	CV-40	1" ID BEARING	2	80	700059	3/8"-16 HEX NUT, ZINC	2
35	D2	LEFT-HAND HOOD PANEL	1	81	200029	3/8"-16 HEX CAP NUT, ZINC	2
36	D-15	RIGHT-HAND HOOD PANEL	1	82	200037	7/16"-14 HEX NUT, ZINC	4
37	D-18	PINCH ROLLER SPRING	4	83	200037	7/16"-14 HEX NUT, ZINC	4
38	D-19	PINCH ROLLER BUSHING	4	84	700017	1/4"-20 x 5/8" CARRIAGE BOLT, ZINC	28
39	700011	1/4" x 1" SQUARE KEY STOCK	4	85	700031	1/4"-20 x 3/4" CARRIAGE BOLT, ZINC	16
40	D-28	SIDE FRAME	2	86	200011	1/4-20 X 1" CARRIAGE BOLT, ZINC	4
41	D-45	LEFT-HAND BASE LEG	1	87	700043	5/16"-18 x 3/4" CARRIAGE BOLT, ZINC	1
42	D-46	RIGHT-HAND BASE LEG	1	88	200033	7/16-14 x 1-1/2" HEX BOLT, ZINC	4
43	D-49	MOTOR MOUNT RAIL LEFT SIDE	1	89	700023	1/4"-20 x 1" HEX BOLT, ZINC	4
44	D-50	MOTOR MOUNT RAIL RIGHT SIDE	1	90	700023	1/4"-20 x 1" HEX BOLT, ZINC	17
45	N/A	SERIAL NUMBER PLATE	1	91	200033	7/16"-14 x 1-1/2" HEX BOLT, ZINC	4
46	DD-30	MOTOR PULLEY	1				

OPTIONAL PARTS LISTING

ITEM	PART NUMBER	DESCRIPTION	QTY.
		26ET EXTENSION ROLLER TABLE KIT	1
	26ETR	26" ROLLER	2
	CVEXTL	LEFT SIDE EXTENSION BRACKET	2
	CVEXTR	RIGHT SIDE EXTENSION BRACKET	2
	700023	1/4-20 X 1" HEX BOLT, ZINC	6
	700025	1/4" USS FLAT WASHER, ZINC	6
	200009	1/4" SPLIT LOCK WASHER, ZINC	6
	FRK2	REVERSING KIT	1
		DRUM SWITCH	1
		18/2 X 16" LAMP CORD	1
	700023	1/4-20 X 1" HEX BOLT, ZINC	2
	700025	1/4" USS FLAT WASHER, ZINC	2
	200009	1/4" SPLIT LOCK WASHER, ZINC	2
	700029	1/4-20 HEX NUT, ZINC	2
	700075	FEMALE WIRE CONNECTOR	2
	700079	WIRE CONNECTOR, PRONG	4

OPTIONAL PARTS LISTING

ITEM	PART NUMBER	DESCRIPTION	QTY.
		CASTOR KIT	1
	263850	METAL STRAP	2
	SA300WH	SWIVEL CASTOR W/LOCK	4
	200019	5/16-18 X 3/4" HEX BOLT, ZINC	16
	700045	5/16" USS FLAT WASHER, ZINC	16
	200021	5/16" SPLIT LOCK WASHER, ZINC	16
	200023	5/16-18 HEX NUT, ZINC	16
	700061	3/8-16 X 1" HEX BOLT, ZINC	4
	200027	3/8" USS FLAT WASHER, ZINC	4
	700059	3/8" SPLIT LOCK WASHER, ZINC	4
	700057	3/8-16 HEX NUT, ZINC	4
	2675 MODELS	SERIAL# PRIOR TO 4418 WILL HAVE THE FOLLOWING:	
	34 CV-05	1" ID BRONZE BUSHING	2
	34 CV-25	1" SET COLLAR	2

3875 DRUM SANDER

ITEM	PART NUMBER	DESCRIPTION	QTY.	ITEM	PART NUMBER	DESCRIPTION	QTY.
1	BCV-02	38" BED PLATE	1	47	D-42	38" BASE TOP	1
2	BCV-03	38" CONVEYOR FRAME	1	48	DG-1	DIGITAL SCALE INDICATOR	1
3	BCV-04	38" INFEED CONVEYOR DRUM	1	49	700013	1/4" x 1-1/2" SQUARE KEY STOCK	1
4	BCV-09	38" INFEED CONVEYOR DRUM SHAFT	1	50	W-4	IDLER CHAIN SPROCKET	5
5	BCV-18	38" OUTFEED CONVEYOR DRUM (FLAT)	1	51	W4BSH	IDLER CHAIN BUSHING	1
6	BCV-24	38" CONVEYOR BELT	1	52	WR-10	1-1/2" ID FLANGE BEARING	2
7	BCV-26	38" OUTFEED CONVEYOR DRUM SHAFT	1	53	WR-45	CHAIN TENSIONER	1
8	BCV-32	38" HINGE HOOD TOP	1	54	WR-82	IDLER PULLEY	1
9	BCV-34	38" DUST CHUTE ASSEMBLY	1	55	WR-84	CRANK HANDLE	1
10	BD-11	38" HOOD COVER PANEL	2	56	WR-549	5/8" ID MACHINE WASHER	3
11	BD-17	38" PINCH ROLLER	2	57	WR37M	MOTOR SWITCH W/ CORD & PLUG ASSY	1
12	BD-38-1	38" CROSS BRACE FRONT	1	58	700033	1/4" x 1-1/4" ROLL PIN	5
13	BD-38	38" CROSS BRACE REAR	1	59	3875P	5 HP AC MOTOR	1
14	BD-39	38" BED CHAIN	1	60	38VM	4" x 195" VELCRO STRIP	1
15	BD-48	38" LEG TIE FRONT	1	61	38100S6	100 GRIT SANDING STRIP 6" X 144"	1
16	BD-47	38" LEG TIE REAR	1	62	718CB	CONTROL BOX	1
17	BD-54	38" SANDING DRUM	1	63	718GK	1/6 HP DC GEAR MOTOR	1
18	CD-13	5/8" ID FLANGE BUSHING	1	64	A-66	68" DRIVE BELT	2
19	CD-29	FIXED BORE HEAD PULLEY	1			STANDARD COMMON HARDWARE	
20	CD-30	SWIVEL NUT	4	65	200001	#10 x 1/2" PHILIPS PAN HEAD, ZINC	1
21	CD-38	1/4"-20 THREADED ROD	2	66	200003	10-32 x 1/2" FHSCS, ZINC	9
22	CD-39	TABLE LIMIT STOP	1	67	200005	1/4" x 1 1/8" ROLL PIN	1
23	CD-40	CORNER SCREW	3	68	200007	1/4"-20 THREADED KNOB, THREE-ARM	2
24	CD-41	5/8" THRUST WASHER	8	69	700025	1/4" USS FLAT WASHER, ZINC	41
25	CD-42	CRANK SCREW	1	70	700045	5/16" USS FLAT WASHER, ZINC	1
26	CD-55	OUTFEED CONVEYOR BEARING SPACER	1	71	200015	5/16" FLAT WASHER, LARGE OD 1-1/2"	4
27	CV-08	TAKE-UP TRACKING ADJUSTMENT	2	72	200027	3/8" USS FLAT WASHER, ZINC	2
28	CV-14	GEAR MOTOR SPROCKET	1	73	200009	1/4" SPLIT LOCK WASHER, ZINC	29
29	CV-16	GEAR MOTOR GUARD FOR 1/6HP	1	75	200035	7/16" SPLIT LOCK WASHER, ZINC	4
30	CV-17	GEAR MOTOR CHAIN FOR 1/6HP	1	76	700065	1/2" SPLIT LOCK WASHER, ZINC	8
31	CV-21	GEAR MOTOR GUARD SPACER	2	77	700029	1/4"-20 HEX NUT, ZINC	14
32	CV-27	CONVEYOR DRIVE SPROCKET	1	78	700027	1/4"-20 NYLON-INSERT HEX LOCKNUT, ZINC	44
33	CV-35	TRACKING BRACKET	1	79	700047	5/16"-18 NYLON-INSERT HEX LOCKNUT, ZINC	1
34	CV-40	1" ID BEARING	2	80	700059	3/8"-16 HEX NUT, ZINC	2
35	D2	LEFT-HAND HOOD PANEL	1	81	200029	3/8"-16 HEX CAP NUT, ZINC	2
36	D-15	RIGHT-HAND HOOD PANEL	1	82	200037	7/16"-14 HEX NUT, ZINC	4
37	D-18	PINCH ROLLER SPRING	4	83	700067	1/2"-13" HEX NUT, ZINC	8
38	D-19	PINCH ROLLER BUSHING	4	84	700017	1/4"-20 x 5/8" CARRIAGE BOLT, ZINC	28
39	700011	1/4" x 1" SQUARE KEY STOCK	4	85	700031	1/4"-20 x 3/4" CARRIAGE BOLT, ZINC	16
40	D-28	SIDE FRAME	2	86	200011	1/4-20 X 1" CARRIAGE BOLT, ZINC	4
41	D-45	LEFT-HAND BASE LEG	1	87	700043	5/16"-18 x 3/4" CARRIAGE BOLT, ZINC	1
42	D-46	RIGHT-HAND BASE LEG	1	88	700069	1/2-13 x 1-1/4" CARRIAGE BOLT	8
43	D-49	MOTOR MOUNT RAIL LEFT SIDE	1	89	700023	1/4"-20 x 1" HEX BOLT, ZINC	4
44	D-50	MOTOR MOUNT RAIL RIGHT SIDE	1	90	700023	1/4"-20 x 1" HEX BOLT, ZINC	17
45	N/A	SERIAL NUMBER PLATE	1	91	200033	7/16"-14 x 1-1/2" HEX BOLT, ZINC	4
46	DD-30	MOTOR PULLEY	1				

OPTIONAL PARTS LISTING

ITEM	PART NUMBER	DESCRIPTION	QTY.
		38ET EXTENSION ROLLER TABLE KIT	1
	38ETR	38" ROLLER	2
	CVEXTL	LEFT SIDE EXTENSION BRACKET	2
	CVEXTR	RIGHT SIDE EXTENSION BRACKET	2
	700023	1/4-20 X 1" HEX BOLT, ZINC	6
	700025	1/4" USS FLAT WASHER, ZINC	6
	200009	1/4" SPLIT LOCK WASHER, ZINC	6
	FRK2	REVERSING KIT	1
		DRUM SWITCH	1
		18/2 X 16" LAMP CORD	1
	700023	1/4-20 X 1" HEX BOLT, ZINC	2
	700025	1/4" USS FLAT WASHER, ZINC	2
	200009	1/4" SPLIT LOCK WASHER, ZINC	2
	700029	1/4-20 HEX NUT, ZINC	2
	700075	FEMALE WIRE CONNECTOR	2
	700079	WIRE CONNECTOR, PRONG	4

OPTIONAL PARTS LISTING

ITEM	PART NUMBER	DESCRIPTION	QTY.
	SA300	CASTOR KIT	1
	263850	METAL STRAP	2
	S300WH	SWIVEL CASTOR W/LOCK	4
	200019	5/16-18 X 3/4" HEX BOLT, ZINC	16
	700045	5/16" USS FLAT WASHER, ZINC	16
	200021	5/16" SPLIT LOCK WASHER, ZINC	16
	200023	5/16-18 HEX NUT, ZINC	16
	700061	3/8-16 X 1" HEX BOLT, ZINC	4
	200027	3/8" USS FLAT WASHER, ZINC	4
	700059	3/8" SPLIT LOCK WASHER, ZINC	4
	700057	3/8-16 HEX NUT, ZINC	4
	3875 MODELS	SERIAL# PRIOR TO 5375 WILL HAVE THE FOLLOWING:	
	34 CV-05	1" ID BRONZE BUSHING	2
	34 CV-25	1" SET COLLAR	2

5075 DRUM SANDER

ITEM	PART NUMBER	DESCRIPTION	QTY.	ITEM	PART NUMBER	DESCRIPTION	QTY.
1	LCV-02	50" BED PLATE	1	47	LD-42	50" BASE TOP	1
2	LCV-03	50" CONVEYOR FRAME	1	48	DG-1	DIGITAL SCALE INDICATOR	1
3	LCV-04	50" INFEED CONVEYOR DRUM	1	49	700013	1/4" x 1-1/2" SQUARE KEY STOCK	1
4	LCV-09	50" INFEED CONVEYOR DRUM SHAFT	1	50	W-4	IDLER CHAIN SPROCKET	5
5	LCV-18	50" OUTFEED CONVEYOR DRUM (FLAT)	1	51	W4BSH	IDLER CHAIN BUSHING	1
6	LCV-24	50" CONVEYOR BELT	1	52	WR-10	1-1/2" ID FLANGE BEARING	2
7	LCV-26	50" OUTFEED CONVEYOR DRUM SHAFT	1	53	WR-45	CHAIN TENSIONER	1
8	LCV-32	50" HINGE HOOD TOP	1	54	WR-62	IDLER PULLEY	1
9	LCV-34	50" DUST CHUTE ASSEMBLY	1	55	WR-84	CRANK HANDLE	1
10	LD-11	50" HOOD COVER PANEL	2	56	WR-549	5/8" ID MACHINE WASHER	3
11	LD-17	50" PINCH ROLLER	2	57	650830M	MOTOR SWITCH W/ CORD & PLUG ASSY	1
12	LD-38-1	50" CROSS BRACE FRONT	1	58	700033	1/4" x 1-1/4" ROLL PIN	5
13	LD-38	50" CROSS BRACE REAR	1	59	7.5-P1	7.5 HP AC MOTOR	1
14	LD-39	50" BED CHAIN	1	60	50VM	4" x 258" VELCRO STRIP	1
15	LD-48	50" LEG TIE FRONT	1	61	50100S6	100 GRIT SANDING STRIP 6" X 190"	1
16	LD-47	50" LEG TIE REAR	1	62	725CB	1/2 HP CONTROL BOX	1
17	LD-54	50" SANDING DRUM	1	63	725GM	1/2 HP DC GEAR MOTOR	1
18	CD-13	5/8" ID FLANGE BUSHING	1	64	A-66	68" DRIVE BELT (for machines w/Leeson Motors)	2
19	DD-19	BUSHING BORE HEAD PULLEY	1	64a	4L660	60" DRIVE BELT (for machines w/Baldor Motors)	2
20	CD-30	SWIVEL NUT	4			STANDARD COMMON HARDWARE	
21	CD-38	1/4"-20 THREADED ROD	2	65	200001	# 10 x 1/2" PHILIPS PAN HEAD, ZINC	1
22	CD-39	TABLE LIMIT STOP	1	66	200003	10-32 x 1/2" FHSCS, ZINC	9
23	CD-40	CORNER SCREW	3	67	200005	1/4" x 1 1/8" ROLL PIN	1
24	CD-41	5/8" THRUST WASHER	8	68	200007	1/4"-20 THREADED KNOB, THREE-ARM	2
25	CD-42	CRANK SCREW	1	69	700025	1/4" USS FLAT WASHER, ZINC	37
26	CD-55	OUTFEED CONVEYOR BEARING SPACER	1	70	700045	5/16" USS FLAT WASHER, ZINC	1
27	CV-08	TAKE-UP TRACKING ADJUSTMENT	2	71	200015	5/16" FLAT WASHER, LARGE OD 1-1/2"	4
28	CV-14	GEAR MOTOR SPROCKET	1	72	200027	3/8" USS FLAT WASHER, ZINC	6
29	DCV-16	GEAR MOTOR GUARD FOR 1/2HP	1	73	200009	1/4" SPLIT LOCK WASHER, ZINC	25
30	DCV-17	GEAR MOTOR CHAIN FOR 1/2HP	1	75	200035	7/16" SPLIT LOCK WASHER, ZINC	4
31	CV-21	GEAR MOTOR GUARD SPACER	2	76	700065	1/2" SPLIT LOCK WASHER, ZINC	8
32	CV-27	CONVEYOR DRIVE SPROCKET	1	77	700029	1/4"-20 HEX NUT, ZINC	14
33	CV-35	TRACKING BRACKET	1	78	700027	1/4"-20 NYLON-INSERT HEX LOCKNUT, ZINC	40
34	CV-40	1" ID BEARING	2	79	700047	5/16"-18 NYLON-INSERT HEX LOCKNUT, ZINC	1
35	D2	LEFT-HAND HOOD PANEL	1	80	700059	3/8"-16 HEX NUT, ZINC	6
36	D-15	RIGHT-HAND HOOD PANEL	1	81	200029	3/8"-16 HEX CAP NUT, ZINC	2
37	D-18	PINCH ROLLER SPRING	4	82	200037	7/16"-14 HEX NUT, ZINC	4
38	D-19	PINCH ROLLER BUSHING	4	83	700067	1/2"-13" HEX NUT, ZINC	8
39	700011	1/4" x 1" SQUARE KEY STOCK	4	84	700017	1/4"-20 x 5/8" CARRIAGE BOLT, ZINC	28
40	D-28	SIDE FRAME	2	85	700031	1/4"-20 x 3/4" CARRIAGE BOLT, ZINC	16
41	D-45	LEFT-HAND BASE LEG	1	86	200025	3/8-16 X 1" CARRIAGE BOLT, ZINC	4
42	D-46	RIGHT-HAND BASE LEG	1	87	700043	5/16"-18 x 3/4" CARRIAGE BOLT, ZINC	1
43	D-49	MOTOR MOUNT RAIL LEFT SIDE	1	88	700069	1/2-13 x 1-1/4" CARRIAGE BOLT	8
44	D-50	MOTOR MOUNT RAIL RIGHT SIDE	1	89	700023	1/4"-20 x 1" HEX BOLT, ZINC	4
45	N/A	SERIAL NUMBER PLATE	1	90	700023	1/4"-20 x 1" HEX BOLT, ZINC	17
46	DD-30	MOTOR PULLEY	1	91	200033	7/16"-14 x 1-1/2" HEX BOLT, ZINC	4
				92	700059	3/8" SPLIT LOCK WASHER, ZINC	4

OPTIONAL PARTS LISTING

ITEM	PART NUMBER	DESCRIPTION	QTY.
		50ET EXTENSION ROLLER TABLE KIT	1
	50ETR	50" ROLLER	2
	CVEXTL	LEFT SIDE EXTENSION BRACKET	2
	CVEXTR	RIGHT SIDE EXTENSION BRACKET	2
	700023	1/4-20 X 1" HEX BOLT, ZINC	6
	700025	1/4" USS FLAT WASHER, ZINC	6
	200009	1/4" SPLIT LOCK WASHER, ZINC	6
	FRK2	REVERSING KIT	1
		DRUM SWITCH	1
		18/2 X 16" LAMP CORD	1
	700023	1/4-20 X 1" HEX BOLT, ZINC	2
	700025	1/4" USS FLAT WASHER, ZINC	2
	200009	1/4" SPLIT LOCK WASHER, ZINC	2
	700029	1/4-20 HEX NUT, ZINC	2
	700075	FEMALE WIRE CONNECTOR	2
	700079	WIRE CONNECTOR, PRONG	4

OPTIONAL PARTS LISTING

ITEM	PART NUMBER	DESCRIPTION	QTY.
	S300	CASTOR KIT	1
	263850	METAL STRAP	2
	S300WH	SWIVEL CASTOR W/LOCK	4
	200019	5/16-18 X 3/4" HEX BOLT, ZINC	16
	700045	5/16" USS FLAT WASHER, ZINC	16
	200021	5/16" SPLIT LOCK WASHER, ZINC	16
	200023	5/16-18 HEX NUT, ZINC	16
	700061	3/8-16 X 1" HEX BOLT, ZINC	4
	200027	3/8" USS FLAT WASHER, ZINC	4
	700059	3/8" SPLIT LOCK WASHER, ZINC	4
	700057	3/8-16 HEX NUT, ZINC	4
	5075 MODELS	SERIAL# PRIOR TO 1946 WILL HAVE THE FOLLOWING:	
	34 CV-05	1" ID BRONZE BUSHING	2
	34 CV-25	1" SET COLLAR	2

Troubleshooting Guide

This guide gives possible solutions to a variety of problems. If, after all solutions have been considered, you still experience problems, contact Woodmaster at 1-800-821-6651

Problem: Conveyors move stock in the wrong direction

Cause:

Drive motor turning wrong direction

Solution:

Reverse wires to the drive motor.

Problem: Conveyor does not move

Causes:

Wires disconnected to motor

Control box fuse blown

Motor brushes worn out

Conveyor belt stretched or worn.....

Solutions:

Reconnect wires

Replace fuse

Replace brushes (contact Woodmaster for parts and instructions)

Tighten or replace conveyor belt

Problem: Conveyor feed jerking

Causes:

Roller bushings dry

Roller springs too tight

Brushes worn in gear motor.....

Conveyor belt stretched or worn.....

Chain to conveyor pulley is loose

Solutions:

Oil bushings

Loosen roller springs

Replace brushes (contact Woodmaster for parts and instructions)

Tighten or replace feed conveyor belt.

To tighten the chain, loosen bolts attaching the motor to the base plate. Use a board to pry the motor toward you while retightening the bolts.

Problem: Outfeed conveyor drum has shifted, making contact with conveyor frame.

Causes:

Set screw and or keyway has worked loose.....

Solutions:

Loosen belt tension, re-center outfeed conveyor drum. Tighten set screws into keyways and follow conveyor tracking procedures shown in manual.

Problem: Boards thin on one side

Causes:

Conveyor bed misaligned Align bed (page ##)
Conveyor bed loose Tighten bed

Solutions:

Problem: Sander leaves chatter marks

Causes:

Drum bearing worn..... Replace drum bearing
Worn drive motor bearings..... Repair or replace motor
Worn conveyer pulley bearings..... Replace pulley bearing
Loose or worn drive belts Tighten or replace drive belts
Conveyer belt feed not constant Check conveyor drive chain for binding
Check electrical connections to the motor
Loose drum pulley..... Tighten drum pulley

Solutions:

Problem: Sander leaves wavy streaks

Causes:

Loaded or damaged abrasive Replace abrasive
Take a lighter cut
Check dust collection system
Stagger parts on conveyor (do not use
only one area of abrasive

Solutions:

Problem: Sander leaves straight streaks

Causes:

Resin build-up on abrasive..... Replace abrasive
Abrasive grit damaged Avoid this area or replace abrasive
Velcro on drum damaged..... Replace velcro
Wood chips between velcro and sandpaper Peel off the sandpaper and remove wood
chips or debris on the velcro.

Solutions:

Problem: Conveyor motor not operating

Causes:

Solutions:

Blown fuse on control unit..... Replace fuse

Connectors between control unit and motor pulled apart..... Unplug feed motor and re-connect wires.

If the problem is not the fuse or wiring:
unplug the cutter and feed motors
disconnect the control unit from the feed motor.

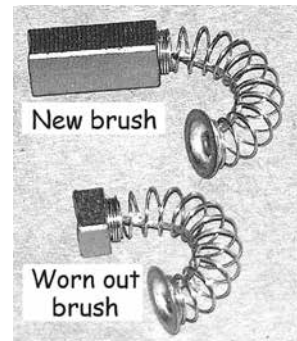
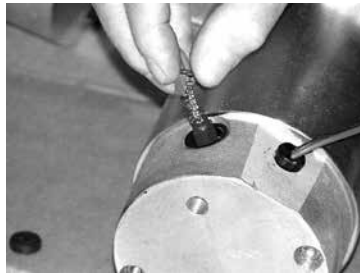
Connect a 12 V automotive battery or 12 V DC battery charger to the feed motor.
If the feed motor turns slowly, the problem is with the control unit.

As an alternative, you can attach the controller wires to the plug of an incandescent lamp. Plug in the controller, and adjust the feed. If the controller is working properly, the light will change intensity as you rotate the knob. If the lamp does not turn on, the problem is likely in the control unit.

If you determined the problem to be the control unit, contact Woodmaster's customer service.

If you determined that the motor is the problem, check the brushes:

a. Remove the brushes.



b. Check them for wear. The brush should be at least 1/4" long, and not have any chips.

If the brushes are worn or broken, contact Woodmaster for replacement brushes.

If the brushes appear to be good, contact Woodmaster about replacing the motor.

Appendix 1: Replacing the Conveyor Belt

We now supply a splined conveyor belt for easy installation in the event the belt needs to be replaced. Unplug drum motor and conveyor motor for safety! To remove the worn or damaged conveyor belt loosen the belt tension using the tracking adjustment. Cut the damaged belt then replace with the splined belt and track belt. For conveyor belt tracking go back to page 20 and follow tracking instructions.

Appendix 2: Changing Corner / Crank Screws

To change out corner screws, the top hood cowling must be removed (Dust Chute, Hinge hood, LH & RH side panels & front & back cover panels).

Remove the (2) black knobs that hold the hinge hood and (2) 1/4" bolts & fender washers that hold the dust chute. Lift both pieces off the top of machine.

Using a 7/16" wrench, remove the bolts that hold the digital gauge to the conveyor frame. On each side of the machine (where tan parts meet black base), loosen the carriage bolts located in each corner of the tan panels and lift the RH and LH side panels up off the machine. The front & back covers will lift off with them.

The corner screws are now exposed. Using a 1/2" wrench, loosen the idler sprocket to where the bed chain is loose. Locate the master link in the bed chain and remove the chain from the screw sprockets.

Using a 7/16" wrench, remove the (2) carriage bolts that secure the cross brace to the side frame. The cross brace is located on top of the corner screws (tan angle iron). Remove the cross brace.

NOTE: If the crank screw needs to be

changed, the roll pin located at the top of the screw must be removed. Using a 3/16" center punch & hammer, drive the roll pin out of the crank screw.

NOTE: Only remove the cross brace for whichever side you are working on. If you are replacing the rear corner screw(s) DO NOT remove the front cross brace.

Once the cross brace is removed, the sprocket needs to be disconnected from the screw. Using a 3/16" center punch, locate the roll pin on the sprocket and drive the roll pin out just enough to where the sprocket spins freely on the screw.

Lift up on the conveyor frame and remove the 2 brass washers located under the screw. (NOTE: 3820 & 5075X2 has (1) washer & (1) 5/8" ID bushing. Remove both washer & bushing).

Using 7/16" wrench, loosen the swivel nut located on the conveyor frame. (located where the screw goes into the frame). Once this is loose, lift the conveyor frame up and the screw should fall out of the frame. Remove the swivel nut from the screw and inspect the threads on both parts. If the nut is stripped but the screw is good, replace the nut. If both are stripped, replace both.

Install the new screw or nut and to re-install into frame, measure one of the existing screws in the machine from the bottom of the conveyor frame (where the swivel nut goes) to the hub of the sprocket. Make a note of that distance.

Slide the new screw up through the bottom of the machine (through the hole that the brass washers were). **NOTE BE SURE TO SLIDE THE SPROCKET** on the screw to where the hub of the sprocket is on top. Thread the swivel nut onto the screw. Run the nut down to where the screw will come up through the hole of the machine.

Using a 7/16" wrench, **SNUG** the swivel nut to where it will not turn inside of the conveyor frame. (**DO NOT FULLY TIGHTEN AT THIS TIME**).

Turn the screw to where you can re-install the brass washers on the bottom of the screw. Align the roll pin on the sprocket to the hole in the screw. Using a hammer, punch the roll pin back into the screw to where the end of the roll pin is flush with the edge of the sprocket.

Once the sprocket is connected to the screw, using the measurement taken from the existing screw, adjust the screw to where the bottom of the conveyor and the top of the sprocket is the distance you measured.

Re-Install the cross brace on top and tighten. Loosen the screw that holds the swivel nut in the frame. Make certain the frame is fully rested on the swivel nut. Re-tighten the swivel nut to 40 in-lbs of torque.

Re-install the chain around each sprocket and re-tighten chain with idler. Using a paste grease, grease each screw. Once the chain has been installed, run the bed up and down about 5-7 turns. It may be a little stiff but it should turn.

Raise the bed to where you can check levelness across the bed from side to side and directly under the drum. Level the drum as shown in the manual.

Once level, re-install the sheet metal guards and top. Re-attach the digital gauge bracket to the conveyor. You will most likely have to re-calibrate the digital gauge. To do so, use a piece of wood of known thickness, raise the bed to where the wood barely contacts the drum. Zero out the gauge and push and hold the down button to proper board thickness. (I.E. 3/4" board, hold the down button to where the gauge reads -0.75".

OPERATER'S MANUAL **FOR WOODMASTER** **DB350, DB550 & DB1000 DUST SYSTEMS**

Thank you for purchasing the Woodmaster dust system. In order for your woodworking equipment to function properly and the safety for you and others in your shop, it is essential that you take a few minutes to review this manual. Dust systems are just as vital as the tools you use to make your projects.

Depending on the size of your shop, the equipment you own, and the layout of your shop will determine what size dust system you need. In this manual, you will find helpful tips to get the most from your Dust System. If used properly, a Dust System will evacuate air born dust, and the majority of wood shavings your equipment produces.

HOW A DUST COLLECTOR WORKS.

Dust systems are rated by Cubic Feet per Minute (CFM). Various manufacturers' rate dust systems in different manners, but it all comes down to CFM. Many factors contribute to the CFM rating. Those factors are:

Motor Speed (RPM), Impeller Diameter & Design, Inlet & Outlet Port Diameter and Bag size (in Microns). These all contribute to the airflow the system will produce.

SETTING UP YOUR SHOP AND DUST SYSTEM.

Whichever dust system you own, one thing is certain. Machinery that creates massive chips should be as close to your dust system as possible. Chips or shavings are heavy and it requires the most CFM to extract the shavings from the machine. No dust system will remove 100% of chips, but if properly set up, you will not have a pile of shavings at your feet every-time you run a 10-foot long board.

The correct hose diameter is important to the collection system. When you purchase woodworking equipment, most equipment has a dust collector hood for that machine. Be sure to use the correct size hose for the equipment. HERE ARE TWO EXAMPLES:

- 1) A radial arm saw usually has a 2" or 2-1/2" port. Radial arm saws create dust not chips. What you need for this application is air velocity more than volume. A smaller diameter hose creates velocity. Using a 4" diameter hose will decrease your velocity to the saw thus weakening the dust system.
- 2) A Woodmaster 725 planer has a 4" port. Planers create chips. In this application you need volume more than velocity. A larger diameter hose creates that volume. Using a 4" diameter hose will decrease your volume to the planer thus weakening the dust system.

It's the same function as water pressure. The larger diameter water runs through, the volume of water is greater, and when water is forced through a smaller diameter, the pressure is greater.

A dust system is pulling debris in from your equipment and extracting the debris out to its dump area. Keeping the distances at a minimum will help the system perform. The inlet side will have the longest run since you have various attachments to the unit. Using blast gates at each tool you hook up to will help direct the airflow to the tool you are using.

When installing your hose and main trunk line in your shop, use connections that are of the same size as your inlet port on the dust system. Use connections that have little resistance in the path of the airflow. A 45-degree turn or bend in your main line will not decrease airflow or create a "backdraft" of air as a 90-degree will. Use a Y fitting versus a T fitting to route additional lines in your shop. Seal all joints so air does not escape. *CAUTION: GROUNDING THE MAIN LINE WILL DECREASE THE POSSIBILITY OF ELECTRICAL CHARGE AIRFLOW CREATES.*

MODEL 350

The DB350-dust system has a 3 HP motor. It requires 230vac. Will not operate on 208vac. The plug configuration is a NEMA 6-15P.

The housing and impeller are made of aluminum. The inlet and outlet port is 6". It will function as a multi machine unit.

Woodmaster offers a five-year warranty on these machines. If hooked up and used properly, these units will meet the demands of your shop. If your shop expands in the equipment, you will need to expand your dust collection system as well.

MODEL DB350 RECEPTACLE REQUIREMENTS

Model DB350 come with 8-foot cord & 6-15 plug. You need a 6-15 Receptacle.



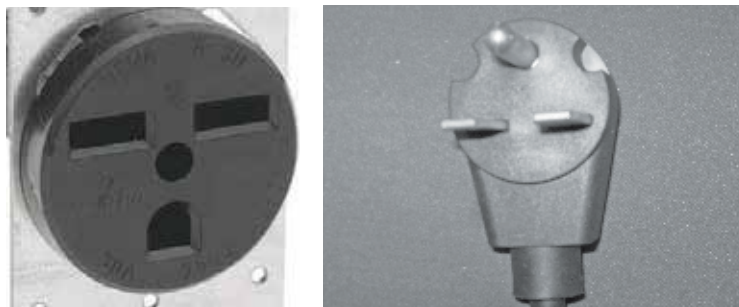
MODEL DB550

The 550 dust-system has a 5hp motor. It too requires 230vac and will not operate on 208vac. The plug configuration is a NEMA 6-30P.

Just like the DB350, it too has aluminum housing and impellor and the inlet port is 6" and the outlet is 6". The impellor for this unit is larger in diameter and has wider blade fins than the model DB350 so it creates higher CFM. It will function as a multi-machine unit and should be used.

MODEL DB550 RECEPTACLE REQUIREMENTS

Model DB550 comes with 8-foot cord & 6-30 Plug. You need a 6-30R Receptacle.



MODEL DB1000

The DB1000 is our largest dust system and available in both single and 3-phase. It is ideal for large shops and larger tools. Single phase models require 230vac and will not operate on 208vac. The plug configuration is a NEMA 10-50P.

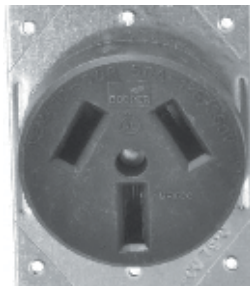
For 3-phase models, it can operate on (208/230vac low voltage) and (460vac high voltage). Make certain you match the voltage to the unit you purchased. 230vac model requires 30 amp and 460vac requires 15 amp.

It has aluminum housing and impeller, and the inlet port is 8" while the outlet is 6".

All of our Dust systems carry the limited 5-year warranty and 60-day money back guarantee.

MODEL DB1000 RECEPTACLE REQUIREMENTS

Model DB1000 comes with 8-foot cord & 6-50 Plug. You need a 6-50R Receptacle.



PARTS LIST & TOOLS NEEDED.

Make sure all the parts are with the unit. They are:

Motor, Blower and stand (assembled & wired).

Bag (2 bags for model 550 & 1000)

Steel tubing

Clamps minimum (3)

Sheet metal screws and whether stripping.

Y-Fitting for Model (550 & 1000).

Tools needed:

Drill & bits

Sealant for joint connections

Straight blade screwdriver

Socket set

Refer to drawing as to the set up of the dust systems.

If you experience any problems with your dust system, or need assistance, please call us at 1-800-821-6651 Monday-Friday 8:30 am to 5:00 pm CST.

ASSEMBLING YOUR SYSTEM

1. Place the blower unit either on the floor, or build a wooden platform for it to sit on. **Anchor the unit so it is secure and will not move while operating.** If you place on the floor, use concrete anchors to secure the unit. The unit can be mounted in ceiling rafters. Use lag bolts, lock washers and nuts to secure in rafters.

NOTE: AFTER SECURING THE BLOWER, TURN THE UNIT ON AND CHECK THE ROTATION OF THE BLOWER IMPELLOR BY LOOKING INTO THE INLET PORT. THE IMPELLOR SHOULD BE ROTATING COUNTER-CLOCKWISE. **DO NOT** PLACE ANY PART OF YOUR BODY CLOSE TO THE INLET. If the blower is rotating the wrong direction, call our toll free number to assist you in the procedures to correct.

2. The steel tubing snaps together by sliding the flange under the tab. This will form a diameter of the tube. Place the non-crimped end of one of the tubes over the outlet side of the blower. Using a drill, drill (three) holes through the tubing and aluminum flange of the blower outlet. Drill the holes to where they are evenly spaced from each other (every 120 degrees) around the tube.
3. Remove the tube from the outlet flange and coat the flange lightly with silicone. Replace the tube on the flange and secure with the screws provided.
4. Install the second tube to the first tube. Place the non-crimped side of the second tube over the crimped side of the first. Again drill holes through the tubes and secure with silicone and screws.
5. Join the two 90-degree elbows together and fasten with screws and tape. Fasten the 90-degree elbows on top of the second tube and secure with screws and tape. The 550 & 1000 uses the Y adaptor on the top of the 2nd tubing to branch both bags to barrels.
6. Slip the bag over your container. The bottom of the bag has a drawstring. Use it to secure the bag to your container. It is best if your container has a lip on the top so the drawstring of the bag has a surface to seal up against. Using a clamp, secure the top of the bag to the 90-degree elbow.
7. Using HVAC tape, you can seal all the joints in the tubing and elbows to prevent air from being drawn into the line.
8. Clamp the hose to the inlet side of the blower and secure.

PARTS For Models DB350, DB550 & DB1000

Dust Collector Replacement Parts

MODEL DB350

Part #	Description	Qty
DB-STD	MOTOR STAND	1
1033MTR	3HP MOTOR ONE PHASE 230VAC	1
1033SW	3HP MAGNETIC MOTOR STARTER	1
DB550FH	FRONT ALUMINUM HOUSING W/6" FLANGE	1
DB550BH	REAR ALUMINUM HOUSING	1
1033I	12" ALUMINUM IMPELLOR	1
1033B	FILTER BAG	1
6CLAMP	6" BAG CLAMP	1
1033VP	6" X 24" VERTICAL PIPE	2
1033EB	6" ELBOW	2

MODEL DB550

Part #	Description	Qty
DB-STD	MOTOR STAND	1
DB500MT	5HP MOTOR ONE PHASE 230VAC	1
WR37M	5HP MAGNETIC MOTOR STARTER	1
DB550FH	FRONT ALUMINUM HOUSING W/6" FLANGE	1
DB550BH	REAR ALUMINUM HOUSING	1
DB500I	13" ALUMINUM IMPELLOR	1
1033B	FILTER BAG	2
6CLAMP	6" BAG CLAMP	2
1033VP	6" X 24" VERTICAL PIPE	2
1033EB	6" ELBOW	4
6YC	6" Y ADAPTOR	1

MODEL DB1000

Part #	Description	Qty
10DBSTD	MOTOR STAND	1
DB1000M	10HP MOTOR ONE PHASE 230VAC	1
650830M	10HP MAGNETIC MOTOR STARTER	1
D1000FH	FRONT ALUMINUM HOUSING	1
DB10FL8	8" FLANGE MOUNT FOR FRONT HOUSING	1
D1000BH	REAR ALUMINUM HOUSING	1
DB1000I	14-3/4" ALUMINUM IMPELLOR	1
1033B	FILTER BAG	2
6CLAMP	6" BAG CLAMP	2
1033VP	6" X 24" VERTICAL PIPE	3
1033EB	6" ELBOW	4
6YC	6" Y ADAPTOR	1

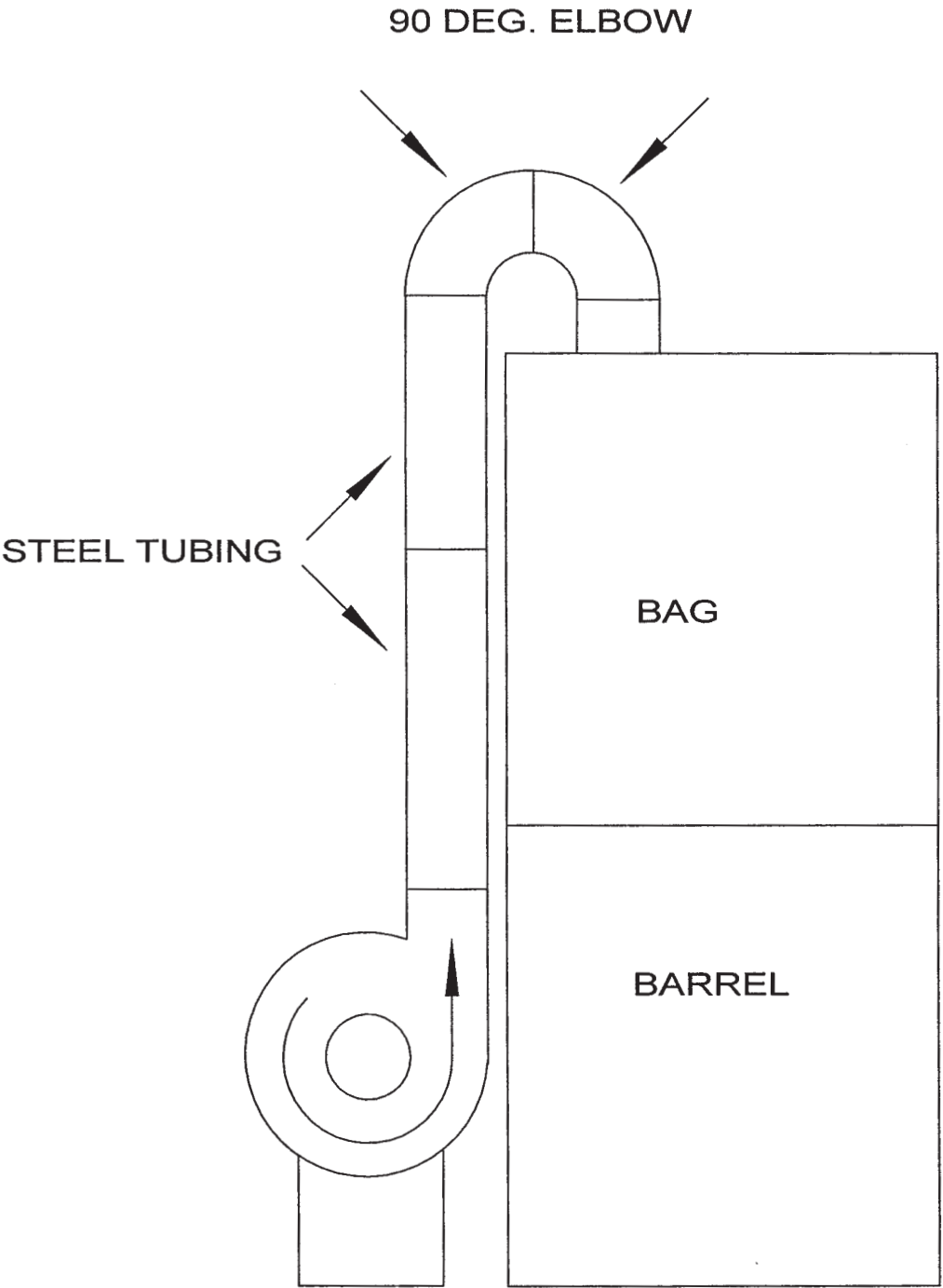
ACCESSORIES FOR DUST SYSTEMS

Part #	Description
820H	4" X10' FLEXIBLE HOSE
820HD	4" X20' FLEXIBLE HOSE
1033R	6" X 4" REDUCER
45R	5" X 4" REDUCER
65R	6" X 5" REDUCER
1033H	6" X 10' FLEXIBLE HOSE
1033HD	6" X 20' FLEXIBLE HOSE
86R	8" X 6" REDUCER
84R	8" X 4" REDUCER

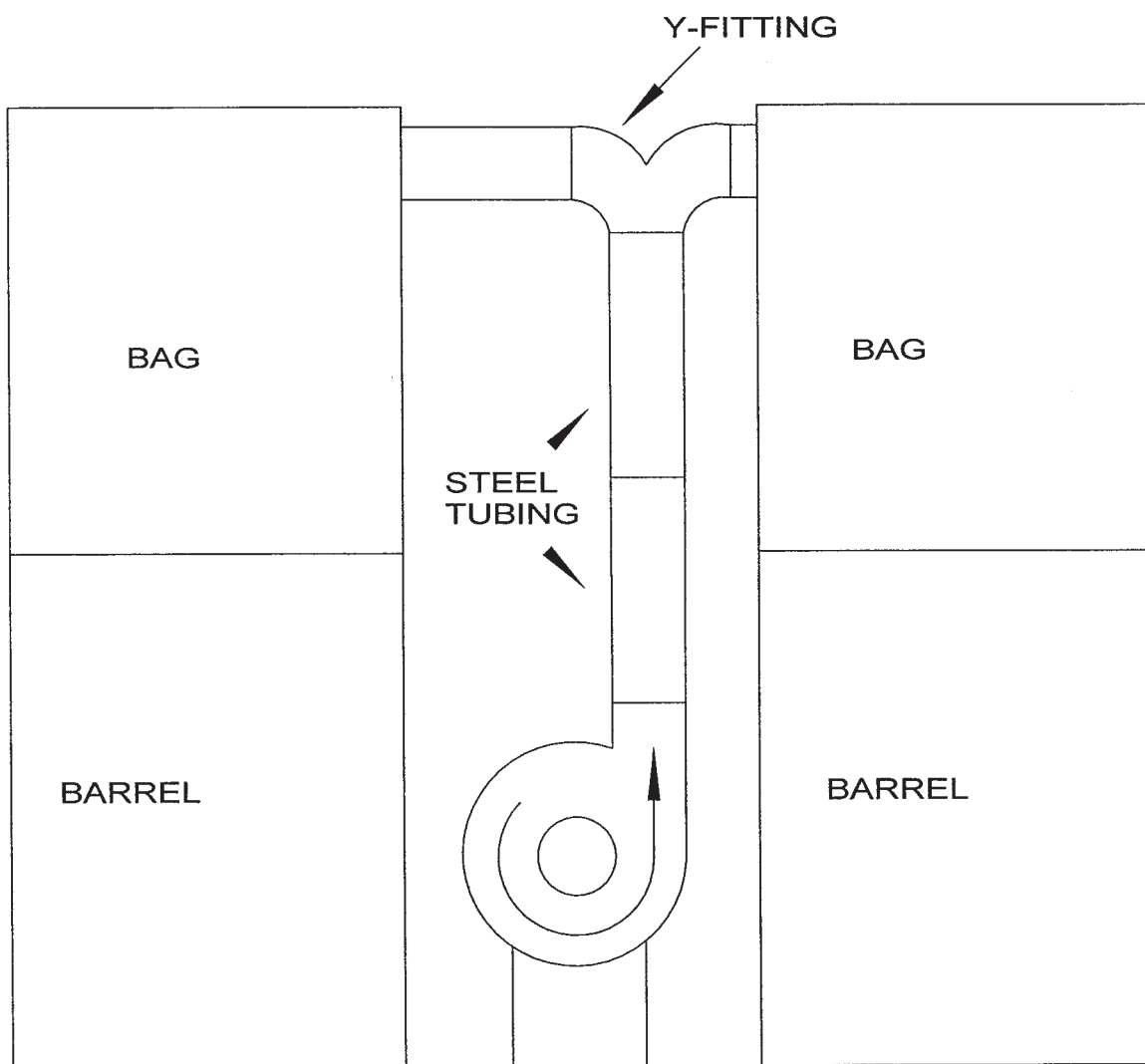
OPTIONS FOR DB1000

DB10230	10HP THREE-PHASE 208/230VAC
DB10460	10HP THREE PHASE 460VAC

MODEL 1033 ILLUSTRATION



MODEL DB500 & DV1000 ILLUSTRATION



INSTALLING SA300 WHEEL KIT

IN THE PARTS LISTS WILL SHOW ALL THE PARTS/HARDWARE THAT IS USED FOR THE SA300.

INSTALL (2) CASTORS ON EACH BLACK PLATE USING (4) 5/16" BOLTS, WASHERS AND NUTS. THE (4) SMALLER HOLES ON EACH SIDE OF THE PLATE IS WHERE THE CASTOR WILL BOLT TO. BE CERTAIN TO INSTALL THE BOLT UP THRU THE CASTOER BRACET AND ONTO THE BLACK PLATE. THE HEAD OF THE BOLTS SHOULD BE ON THE BOTTOM SIDE OF THE CASTOR PLATE. IF INSTALLED THE OPPOSITE WAY, THE BOLT WILL INTERFERE WITH THE SWIVEL ACTION OF THE CASTOR.

EITHER USING A FORKLIFT, HANDJACK OR OTHER MEANS, LIFT UP ON ONE SIDE OF THE MACHINE AND INSTALL THE BLACK PLATE TO THE BOTTOM OF THE MACHINE USING (2) 3/8" BOLTS, WASHERS AND NUTS. AGAIN, GO THRU THE BOTTOM OF THE BLACK PLATE UP THRU THE BASE LEG OF THE MACHINE.

REPEAT ON THE OTHER SIDE. THE CASTOR KIT WILL RAISE THE MACHINE 3" HIGHER OFF THE GROUND AND THE CASTORS ARE TUCKED UNDER THE BASE LEG ONCE ASSEMBLED. BE SURE TO LOCK EACH WHEEL ONCE THE MACHINE IS IN PLACE.

DRUM SANDER

MAINTENANCE SCHEDULE

Part	FREQUENCY	Recommended	Amount to use	Notes / CAUTION
Bed Chain	MONTHLY	3-1 Machine Oil or Tri-ow Oil	1 Drop per 5" of Chain	CLEAN WITH AIR AND APPLY OIL AFTER
Belts	EVERY 25 MACHINE HRS	Quality Belt Dressing	Minimal Amount Needed	
Chain Idler Sprocket Bushing	MONTHLY	3-1 Machine Oil or Tri-ow Oil		
Conveyor Frame Bushing	ONCE DAILY	3-1 Machine Oil or Tri-ow Oil	4 or 5 Drops	Do not Use WD-40
Corner Screw	TWICE MONTHLY	Paste Grease or Graphite	4 oz. per Rod	CLEAN SCREW WITH AIR AND WD-40 APPLY GREASE AFTER SCREW IS CLEAN AND DRY
Corner Screw Washer	ONCE DAILY	3-1 Machine Oil or Tri-ow Oil	1-2 drops each	LOCATED UNDER CORNER SCREW SPROCKET
Gear Motor Chain	TWICE MONTHLY	3-1 Machine Oil or Tri-ow Oil	1 Drop per 2" of Chain	CLEAN WITH AIR AND APPLY OIL AFTER
Main Bearing	25 Machine Hrs.	Medium Consistency Polyura Grease (Shell Dolium R)	1-2 Full Pumps	DO NOT OVERFILL USE SAME TYPE OF GREASE EACH TIME
Pinch Roller	ONCE WEEKLY	Denatured or Rubbing Alcohol	Wipe Entire Roller	DO NOT USE MINERAL SPIRITS OR ACETONE
Pinch Roller Bushing	ONCE DAILY	3-1 Machine Oil or Tri-ow Oil	4 or 5 Drops	DO NOT USE WD-40
Gear Motor	ONCE MONTHLY	Inspect Brushes (pg34 Single Drum PG 34 Dual drum manual)	Rotate Brushes	Look for Carbon build up and uneven wear. Clean and rotate brushes or replace
Pulleys	Once Monthly	Inspect and tighten set screw		
Conveyor Tracking	When Necessary	When Necessary		See Tracking procedure shown in the manual
Outfeed Conveyor Drum Set Screws	ONCE WEEKLY	Inspect and tighten set screws		Check that set screws and keyways are tight and in place. Especially important if using the reversing function.

With proper care and maintenance, your Woodmaster Sander will provide years of trouble-free service. Please follow this schedule to ensure your machine stays properly maintained.



www.woodmastertools.com

www.woodmasterdrumsanders.com