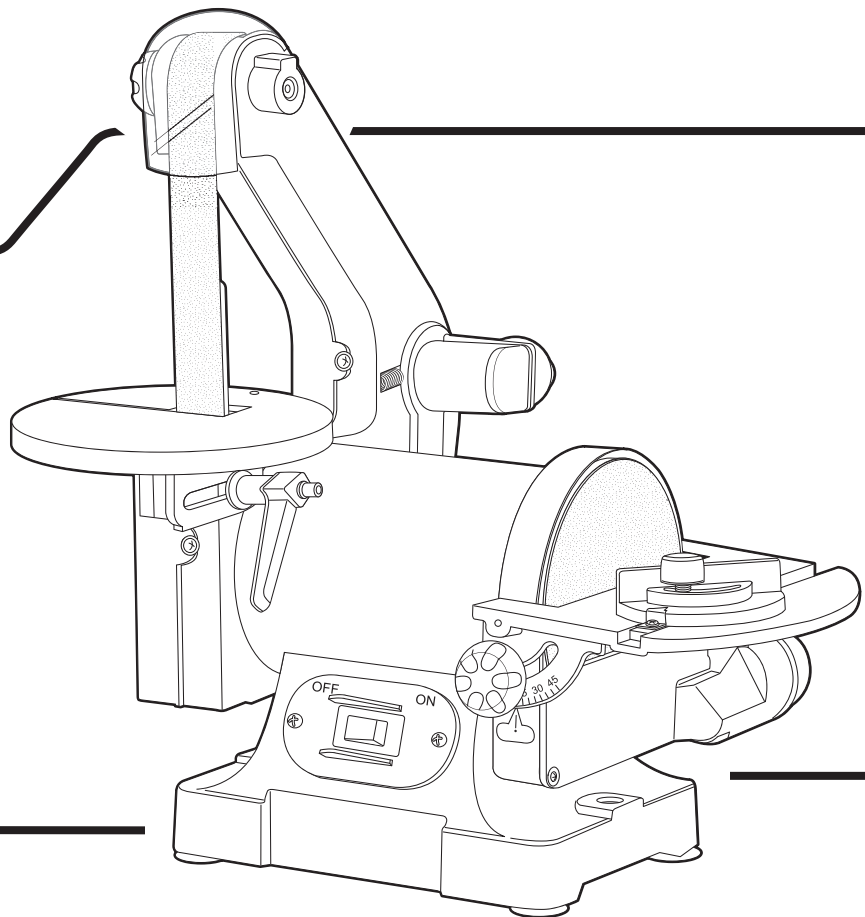


Owner's Manual

POWERTEC[®]

1" X 30" BELT and 5" DISC SANDER

? QUESTION...
1-847-780-6120



Visit us on the web at www.powertecproducts.com



You will need this manual for safety instructions, operating procedures, and warranty. Put it and the original sales invoice in a safe, dry place for future reference.

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PRODUCT SPECIFICATIONS

Horsepower	1/3
Voltage	120
Amp	2.3
Hertz	60
Phase	Single
RPM	3450
Belt Size	1" x 30"
Belt Table Dimension	5-3/4"
Disc Diameter	5"
Disc Table Dimensions	4" x 7-1/4"
Dust Ports Diameter	
Side Belt Guard	1-3/4" OD
Sanding Disc Dust Chute	1-3/4" OD
Base Dimensions	5-29/32" x 8-17/64"
Net Weight	16 lb

GENERAL SAFETY RULES



1

WARNING

For your own safety, read and understand all warnings and operating instructions before using any tool or equipment.

WARNING

The 1" belt sander can be used for processing wood and metal products. However, combining both wood dust and metal filings can create a FIRE HAZARD. Make certain dust collector is free of wood dust deposits before processing metal products.

WARNING

Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain 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 and cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures vary, 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. Always wear OSHA/NIOSH approved, properly fitting face mask or respirator when using such tools.

WARNING

Failure to follow these rules may result in serious personal injury. Remember that being careless for even a fraction of a second can result in severe personal injury.

WORK PREPARATION

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of the tool.
- Nonslip protective footwear is recommended. Wear protective hair covering to contain long hair.
- Wear eye and hearing protection. Always use safety glasses. Eye protection equipment should comply with ANSI Z87.1 standards. Hearing equipment should comply with ANSI S3.19 standards.
- Wear face mask or dust mask if operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

WORK AREA PREPARATION

- Keep work area clean. Cluttered work areas and benches invite accidents.
- Work area should be properly lighted.
- Do not use the machine in a dangerous environment. The use of power tools in damp or wet locations or in rain can cause shock or electrocution.
- Three-prong plug should be plugged directly into properly grounded, three-prong receptacle.
- Use the proper extension cord. Make sure your extension cord is in good condition. It should have grounding prong and should be of the correct gauge.

- Keep children and visitors away. Your shop is a potentially dangerous environment. Children and visitors can be injured.
- Make your workshop childproof with padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.
- It should have a grounding prong and should be of the correct gauge.

TOOL MAINTENANCE

- Turn the machine "OFF", and disconnect the machine from the power source prior to inspection.
- Maintain all tools and machines in peak condition. Keep tools sharp and clean for best and safest performance.
- Follow instructions for lubricating and changing accessories.
- Check for damaged parts. Check for alignment of moving parts, binding, breakage, mounting and any other condition that may affect tool's operation.
- Poorly maintained tools and machines can further damage the tool or machine and/or cause injury.
- A guard or any other part that is damaged should be repaired or replaced. Do not perform makeshift repairs.

TOOL OPERATION

- Avoid accidental start-up. Make sure that the tool is in the "OFF" position before plugging in.
- Use the right tool for your job. Do not force your tool or attachment to do a job for which it was not designed.
- Disconnect tool when changing parts. Always use manufacturer recommended belts and disc.
- Don't force the workpiece on the machine. Damage to the machine and/or injury may result.
- Never leave tool running unattended. Turn the power off and do not leave tool until it comes to a complete stop.
- Do not overreach. Loss of balance can make you fall into a working machine, causing injury.
- Never stand on tool. Injury could occur if the tool tips, or if you accidentally contact the cutting tool.
- Know your tool. Learn the tool's operation, application and specific limitations before using it.
- Use a proper extension cord of the correct gauge. Your extension cord should have a grounding prong, and should be in good condition.
- Handle workpiece correctly. Keep hands away from moving parts.
- Turn tool off if it jams.
- Always support the workpiece against the table or backstop when sanding.
- Always feed workpiece against the direction of the sanding rotation. To maintain control, properly support long or wide work-pieces.

CAUTION

Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

WARNING

Do not attempt to operate tool until it is completely assembled according to the instructions.

**SAVE ALL WARNINGS AND INSTRUCTIONS
FOR FUTURE REFERENCE**



1

2

ASSEMBLY

UNPACKING

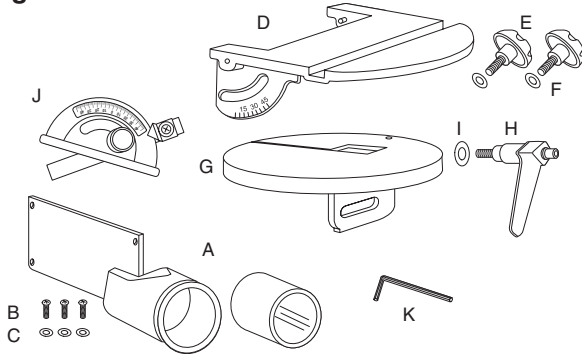
Refer to Figure 1.

Check for shipping damage. Check immediately whether all parts and accessories are included.

The sander comes assembled as one unit. Additional parts which need to be fastened to sander, should be located and accounted for before assembling.

ITEM	DESCRIPTION	QUANTITY
A	Dust Chute (with dust nozzle adapter)	1
B	Screw M4×10 (dust chute assembly)	3
C	Spring washer (dust chute assembly)	3
D	Sanding Disc Table	1
E	Locking Knobs (sanding disc table)	2
F	Washers (sanding disc table)	2
G	Sanding Belt Table	1
H	Locking Lever (Sanding Belt Table)	1
I	Washer 8 mm (Sanding Belt Table)	1
J	Miter Gauge	1
K	Hex Wrench	1
L	Operators Manual (not shown)	1

Figure 1

**WARNING**

Do not use the machine until it is completely assembled and you have read and understood the entire operating manual.

TOOLS NEEDED

The following tools (not included) are needed to assemble and adjust the belt/disc sander:

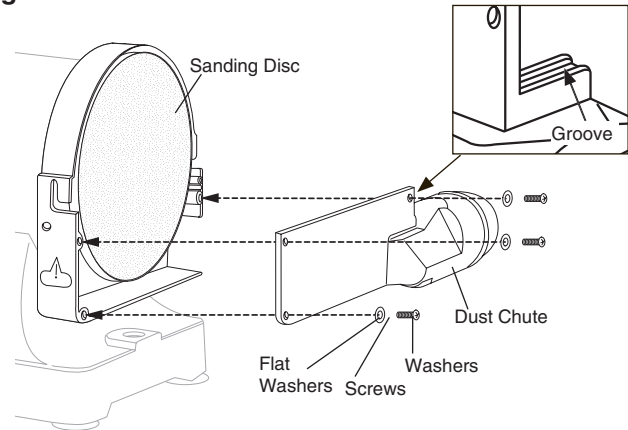
- Combination square
- Phillips screwdriver
- Standard screwdriver
- 4 mm Hex Wrench

ASSEMBLE THE DUST CHUTE

Refer to Figure 2

- Slide the groove in the dust chute onto the sanding disc guard casting as shown. Secure the dust chute to the sander with screws, flat washers and spring washers supplied. Ensure the dust chute opening faces the rear of the unit.

Figure 2

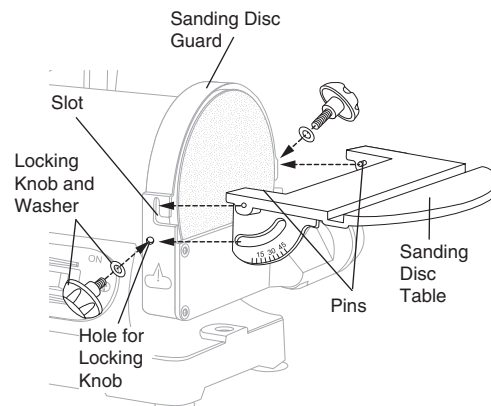


ASSEMBLE THE SANDING DISC TABLE

Refer to Figure 3, 4

- Align the sanding disc table to the sanding disc guard
- Align the pins on the sanding disc table with slots on the sanding disc guard. Slide the pins in and up into the slot.
- Place a washer on each locking knob.
- While holding the sanding disc table in place, thread a locking knob into the slot on each side of the table. Tighten each locking knob.

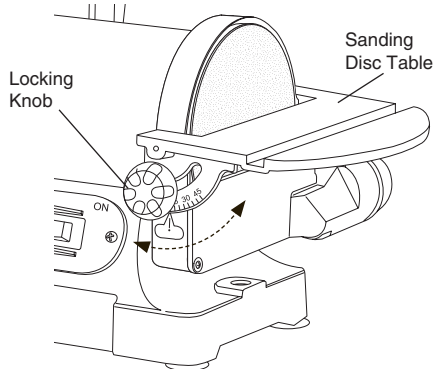
Figure 3



To adjust sanding disc table

- Place a square on the table with the ruler side against the sanding disc. The table should be 90° to the sanding disc.
- If the table is not 90° to the sanding disc, loosen the locking knobs and tilt table up and down until it is 90° to the sanding disc. Tighten locking knobs securely. Recheck adjustment using the square.
- For bevel sanding, loosen the locking knobs and tilt table up and down between 0 –45° to desired angle.

Figure 4

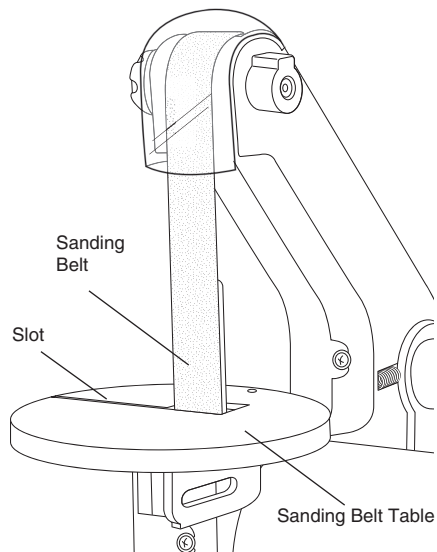


ASSEMBLE THE SANDING BELT TABLE

Refer to Figure 5–9

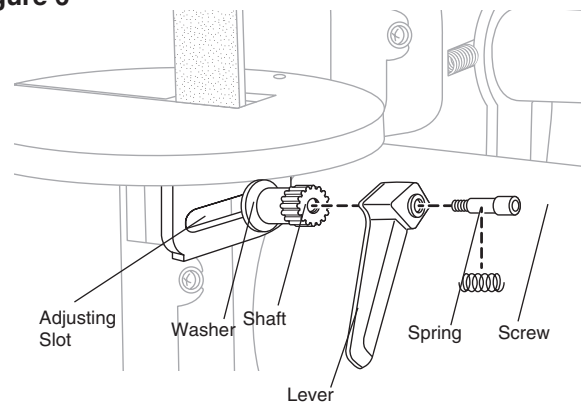
- Use the 4 mm hex wrench supplied to disassemble the locking lever assembly. (bolt, spring, lever and shaft, see Figure 6).
- Pass the sanding belt/backstop through the slot of the sanding belt table and position the table as shown.

Figure 5



- Use the washer and shaft from the locking lever assembly to secure the sanding belt table to the frame. The shaft should be placed at the rear of the adjusting slot as shown in Figure 6.
- Reassemble the screw, spring and lever to the shaft. Tighten the locking lever fully to lock the table.

Figure 6

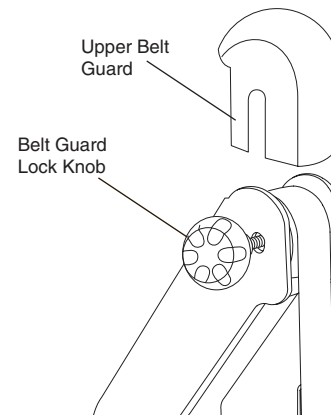


To adjust sanding belt table:

To square

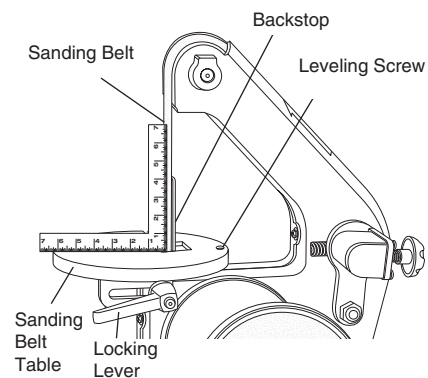
- If using the backstop, make sure it just touches the back of the belt. If adjustment is needed, see **Backstop** paragraph.
- Remove the upper guard, loosen the lock knob and slide the guard up and off the belt. See Figure 7.

Figure 7



- Place a square on the table against the belt as shown.
- Loosen the locking lever assembly and adjust until square.
- Retighten the locking lever.

Figure 8



To level

- A leveling screw is provided to aid in leveling the belt disc table.
- Once the belt table is square, use the 4 mm hex wrench provided to adjust the hex screw down until it touches the frame (under the table), then lock the screw in place by tightening the nut under the table using an 11 mm wrench.



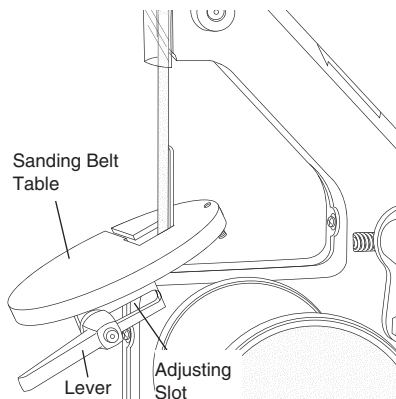
4

To set at 45°

- If needed the table may be tilted.
- Loosen the locking lever until it is very loose.
- Slide locking lever to the front of the adjusting slot as shown to tilt the table.
- Tighten the lock lever.

After all adjustments are made replace the upper guard and tighten the lock knob.

Figure 9



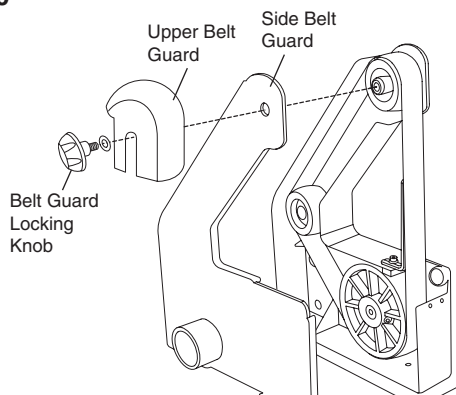
REPLACING THE SANDING BELT

Refer to Figure 10, 11

NOTE: This sander uses 1" x 30" sanding belts.

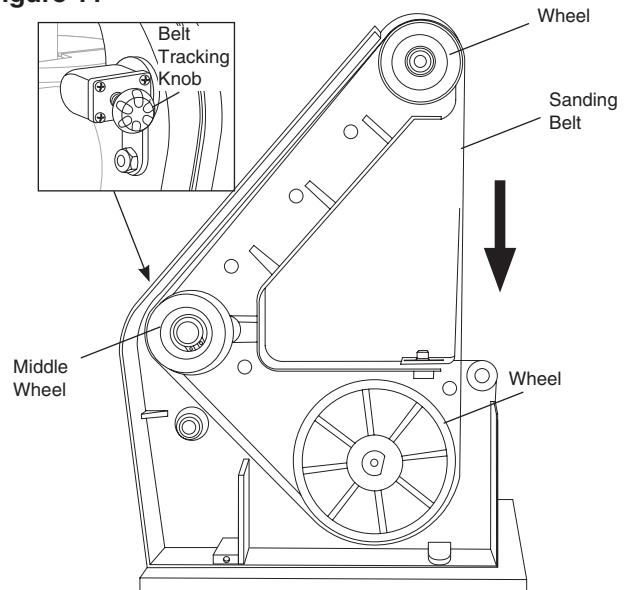
- Turn the machine "OFF", and disconnect the machine from the power source before assembling the sanding belt.
- Remove the belt guard locking knob and upper belt guard. Remove the screws securing the side belt guard and then remove the side belt guard. See Figure 10.

Figure 10



- Hold and apply moderate pressure to the belt tracking knob assembly to release the belt tension enough to remove the old belt. **NOTE:** The belt tracking knob is spring loaded.

Figure 11



- Position the new belt on the wheels. Applying pressure to the belt tracking knob will release tension allowing the belt to be assembled over the middle wheel. Make sure the directional arrows on the belt point in the same direction as the arrows on the sander.
- If needed, turn the belt tracking knob clockwise until the belt tracks to the center of the wheels.
- Replace the upper, side, and lower guards and secure in place with the belt guard lock knob and lower guard screws.
- Ensure the sanding belt table is level. To adjust see the **To Adjust Sanding Belt Table** paragraph in this section.

SANDING BELT TRACKING ADJUSTMENT

Refer to Figure 10, 11

- Turn the machine "OFF", and disconnect the machine from the power source.
- Remove the belt guard locking knob and upper belt guard. Remove the screws securing the side belt guard and then remove the side belt guard. See Figure 10.
- Rotate the sanding belt by hand to check the belt tracking. The belt should track to the center of the wheels.
 - When looking at the front of the sander if the belt tracks to the left, turn the tracking knob counterclockwise until the belt tracks to the center of the wheels.
 - When looking at the front of the sander if the belt tracks to the right, turn the tracking knob clockwise until the belt tracks to the center of the wheels.

- Replace the upper and side belt guards and secure in place with the belt guard locking knob.
- Plug the power cord into the correct receptacle. (Refer to **Power Source** paragraph in this section of the manual.)
- Turn the switch ON and OFF to make sure the belt is tracking at high speed; readjust with tracking knob if needed.

BACKSTOP

Refer to Figure 12

The backstop is a surface to sand against.

To Adjust

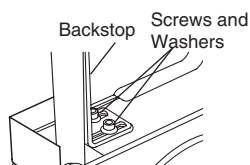
- Remove the sanding belt table. See **Mount the Sanding Belt Table** paragraph and reverse the order of assembly.
- Loosen the two screws on backstop and slide the backstop in or out until it just touches the back of the belt. Retighten the two screws and replace the sanding belt table. See **Mount the Sanding Belt Table** paragraph.

To Remove

The backstop can be removed for polishing and contour sanding.

- Remove the sanding belt table. See **Mount the Sanding Belt Table** paragraph and reverse the order of assembly.
- Remove screws and washers securing backstop. Place screws, washers and backstop in a safe place for future use.
- Replace the sanding belt table. See **Mount the Sanding Belt Table** paragraph.

Figure 12



REPLACING THE SANDING DISC

Refer to Figure 2, 3

NOTE: This sander disc uses 5" self adhesive sanding disc.

- Turn the machine "OFF", and disconnect the machine from the power source before assembling the sanding disc.
- Remove the sanding disc locking levers and slide the sanding disc table from the sander. See Figure 3.
- Remove the screws and washers securing the dust chute and remove the dust chute from the sander. See Figure 2.

- Peel the old sanding disc from the sanding wheel. Clean the sanding wheel with mineral spirits. Make sure the surface is clean and dry.
- Position the new sanding disc onto the sanding disc and press into place.
- Reassemble the sanding disc table and dust chute. Adjust the sanding disc table, if needed. See to **Adjust Sanding Disc Table**.

DUST PORT OPTIONS

Refer to Figure 13

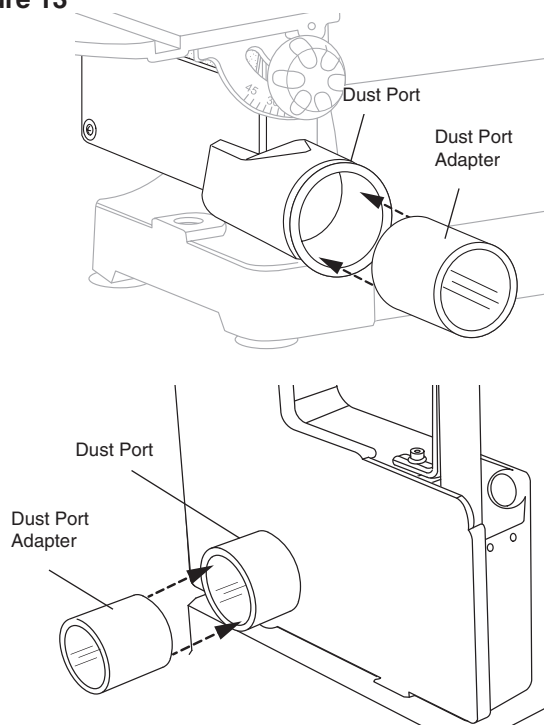
The dust ports can be easily connected to a dust collection system with a large diameter shop vacuum hose.

Sanding operations are inherently dusty. This sander is equipped with two 1-3/4" OD x 1-1/2" ID dust ports to help minimize the amount of dust escaping into the surrounding air. Attach the dust collection system vacuum hose to the dust chute.

NOTE: The dust chute is shipped with an adapter for use with smaller hose dust collectors. This adapter has a 1-1/4" ID and can be used in either dust port.

NOTE: The use of a dust collection system is strongly recommended when using the belt/disc sander. Use of a mask or respirator is still recommended even when using a dust collection system.

Figure 13



MOUNTING THE SANDER TO WORK SURFACE

Refer to Figure 14

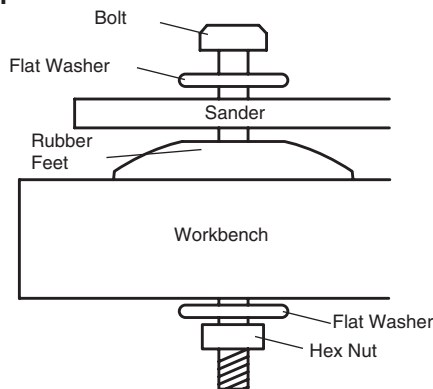
CAUTION

Properly mount the sander to a workbench or stand if during operation the sander has the tendency to tip over, slide or walk on the work surface.

- Remove the four rubber feet from the sander.
- Position the sander in place on the work surface. Mark the work surface using the holes in the sander base as a template. Remove the sander from the work surface.
- Drill holes in the work surface at the marks.
- Secure the sander to the work surface using long bolts, flat washers and hex nuts (not supplied) as shown.

NOTE: Bolts should be inserted from the top of the sander and secured underneath the work surface with flat washers, lock washers and hex nuts. The rubber feet removed from the sander should be placed between the sander and the workbench.

Figure 14



POWER SOURCE

WARNING

Do not connect to the power source until the machine is completely assembled.

The machine is wired for 120 volts, 60 HZ alternating current. Before connecting the machine to the power source, make sure the switch is in the "OFF" position. Running the unit on voltages which are not within range may cause overheating and motor burn-out. Heavy loads require that voltage at motor terminals be no less than the voltage specified on nameplate.

- Power supply to the motor is controlled by a locking rocker switch. Remove the key to prevent unauthorized use.

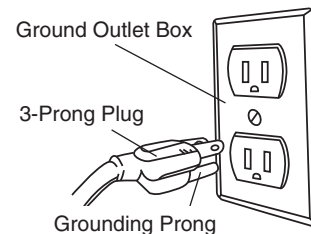
GROUNDING INSTRUCTIONS

WARNING

Improper connection of equipment grounding conductor can result in the risk of electrical shock.

- The machine should be grounded while in use to protect operator from electrical shock.
- In the event of an electrical short circuit, grounding reduces the risk of electrical shock by providing an escape wire for the electric current.
- This machine is equipped with an approved 3-conductor cord rated at 150V and a 3-prong grounding type plug for your protection against shock hazards.
- Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown (Figure 15).
- The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.
- Check with a qualified electrician or service personnel if these instructions are not completely understood or if in doubt as to whether the tool is properly grounded.
- Do not modify plug provided. If it will not fit in outlet, have proper outlet installed by a qualified electrician. Use only 3-wire extension cords, that have 3-prong grounding type plugs and matching 3-conductor receptacles that accept the machine's plug, as shown in Figure 15.

Figure 15



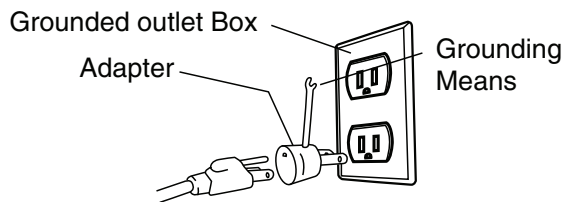
WARNING

Do not permit fingers to touch the terminals of plug when installing or removing from outlet.

- Inspect tool cords periodically, and if damaged, have repaired by an authorized service facility.
- The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the green (or green and yellow) wire to a live terminal.

A temporary 3-prong to 2-prong grounding adapter (see Figure 13) may be used to connect this plug to a matching 2-conductor receptacle as shown in Figure 16. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician.

Figure 16



In Canada, the use of temporary adapter is not permitted by the Canadian Electric Code. Where permitted, the rigid green tab or terminal on the side of the adapter must be securely connected to a permanent electrical ground such as a properly grounded water pipe, a properly grounded outlet box or a properly grounded wire system.

- Many cover plate screws, water pipes and outlet boxes are not properly grounded. To ensure proper ground, grounding means must be tested by a qualified electrician.

EXTENSION CORDS

Use proper extension cords. Make sure the extension cord is in good condition. Use only 3-wire extension cords have 3-prong grounding type plugs and 3-pole receptacles which accept the tool plug. When using an extension cord, make sure to use one heavy enough to carry the current of the machine. An undersized cord will cause a drop in the voltage, resulting in loss of power and overheating. Use the table to determine the minimum wire size (A.W.G.) extension cord.

Extension Cord Length

Wire Size	A.W.G.
Up to 25 ft	16

NOTE: Using extension cords over 25 ft. long is not recommended.

MOTOR

The sander is equipped with a 2.3 Amps motor. The 120 Volt motor has the following specifications:

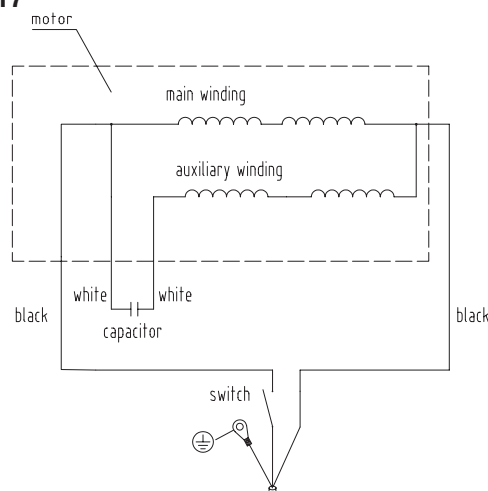
Horsepower	1/3
Voltage	120
Amp	2.3
Hertz	60
Phase	Single
RPM	3450

ELECTRICAL CONNECTIONS

- Turn the switch off and disconnect the machine from power source before performing any repair or maintenance work.
- Some electrical wiring and connection work must be performed by a qualified electrician in accordance with local regulations.
- Scheme of the motor and electric wiring inside this machine is shown in Figure 17.

- There is a green grounding wire fastened to the frame of the machine to provide Shock Protection. Do not disconnect the Grounding Wire from the frame.
- The Motor is rated for use at 120 Volts.
- Connect this machine to 3-Conductor Power outlet with appropriate rating only.
- Use only 3-pronged Extension Power Cord with appropriate rating with this machine.
- When changing the power cord, use only 3-pronged Power Cord with appropriate rating.
- The Power switch is a Single Pole Rocker switch with Locking Mechanism. Remove the Key when not in use to prevent accidents.

Figure 17



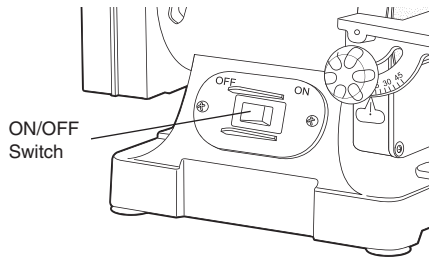


ON/OFF SWITCH

Refer to Figure 18

- To turn sander ON place the ON/OFF switch in the ON position.
- To turn the sander OFF, place the ON/OFF switch in the OFF position.

Figure 18



SURFACE SANDING ON SANDING BELT

Hold the workpiece firmly with both hands. Keep fingers away from sanding belt. Keep the workpiece end against the backstop and move it slowly across the sanding belt. Apply enough pressure to remove material; excessive pressure will reduce sanding efficiency.

END SANDING - DISC/BELT

Refer to Figure 19

Use end sanding when sanding the ends of small, narrow workpieces and outside curved edges.

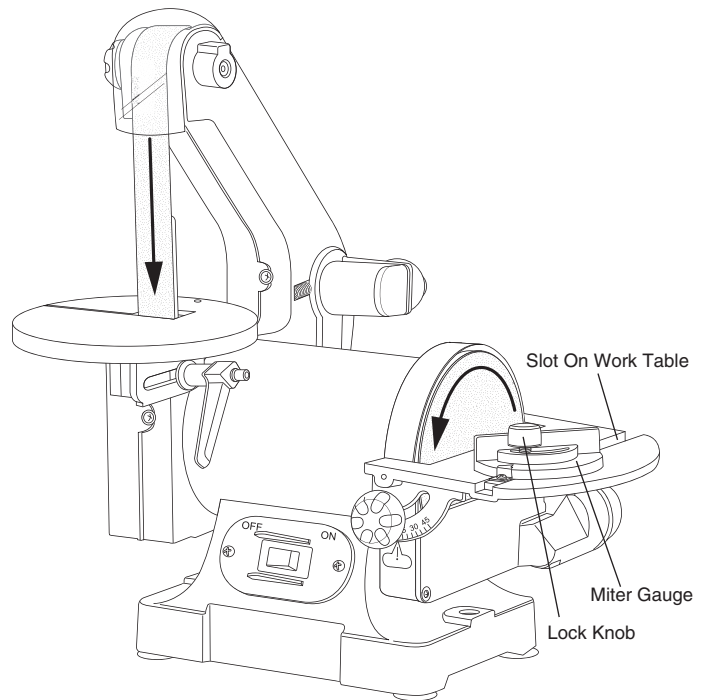
Always work on the left side of the disc (downward rotation side), holding the workpiece firmly with light pressure against the sanding disc.

CAUTION

To avoid personal injury and/or damage to the workpiece, become familiar with the rotation of the sanding belt and disc surfaces.

The sanding belt rotates counterclockwise or downward toward the table or backstop. The sanding disc rotates counterclockwise, downward toward the work table on the left side of the sanding disc and upward from the work table on the right side of the sanding disc. Always use the left side of the sanding disc; using the right side of the sanding disc will cause the workpiece to fly up or kickback and could result in injury.

Figure 19



MITER GAUGE - DISC SANDER

Refer to Figure 19

A miter-gauge is supplied with your sander, and can be used on the sanding disc table.

- Place the miter gauge slide pole into the slot on the work table.
- Loosen the miter gauge lock knob and move the miter gauge head to the left or right to the desired position. Tighten the miter gauge lock knob. **NOTE:** The miter gauge head can be moved right or left 0 to 60°.

NOTE: Use of the miter gauge is recommended for sanding small end surfaces on the sanding disc.

NOTE: Always move the workpiece across the sanding disc from the left side towards the right side, and be sure to hold the workpiece firmly onto the table surface.

CONTOUR SANDING WITH THE BELT

With the backstop removed the sanding belt conforms to a curved edge for sanding and polishing.

- Remove the backstop. See **Backstop** under **Assembly**.
- Turn the sander ON and slowly feed it into the sanding belt.



WARNING

For your own safety, turn the switch OFF and remove the plug from the electrical outlet before adjusting or performing maintenance or lubrication work on the belt/disc sander.

GENERAL MAINTENANCE

Before using, check to make sure parts are not damaged, missing, or worn; check for alignment of moving parts, binding of moving parts, improper mounting, or any other conditions that may affect the sander operation. Should any of these conditions exist, do not use the belt/disc sander until properly repaired or parts are replaced. Frequently blow or vacuum dust from all sanding parts and motor housing.

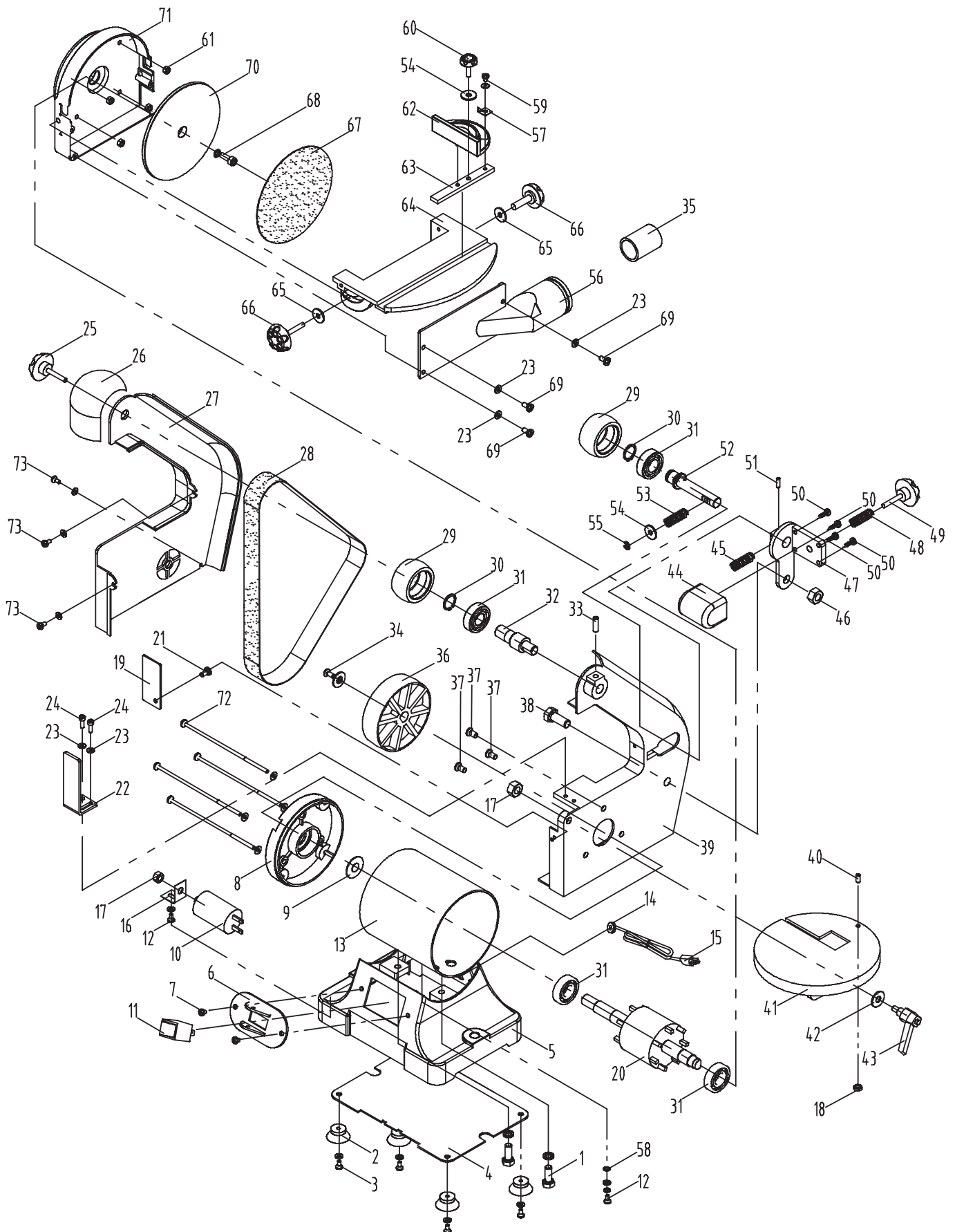
WARNING

Any attempt to repair or replace electrical parts on this tool may be hazardous. Repairs should be done by a qualified service technician.

LUBRICATION

Ball bearings are grease packed at the factory and require no further lubrication. Use a spray lubricant on all moving table parts to ensure smooth operation.





1 x 5 BELT/DISC SANDER PARTS LIST



Key#	Part#	Description	Specifications	Qty	Key#	Part#	Description	Specifications	Qty
1	BD1510001	Philips Screw Assy.	M6x18	2	38	BD1510038	Hex Bolt	M10x25	1
2	BD1510002	Rubber Feet		4	39	BD1510039	Belt Support		1
3	BD1510003	Philips Screw Assy.	M4x12	4	40	BD1510040	Inner Hex Set Screw	M6x20	1
4	BD1510004	Bottom Cover		1	41	BD1510041	Belt Work Table		1
5	BD1510005	Base		1	42	BD1510042	Big Flat Washer	D8	1
6	BD1510006	Switch Box		1	43	BD1510043	Locking Knob Assy.		1
7	BD1510007	Philips Screw	M5x10	2	44	BD1510044	Guard for Adjustable Shaft		1
8	BD1510008	End Bell		1	45	BD1510045	Adjustable Spring		1
9	BD1510009	Wave Spring Washer	35	1	46	BD1510046	Locking Nut	M10	1
10	BD1510010	Capacitor	25UF/300V	1	47	BD1510047	Adjustable Fixed Plate		1
11	BD1510011	Switch		1	48	BD1510048	Adjustable Spring I		1
12	BD1510012	Philips Screw Assy.	M4x8	2	49	BD1510049	Adjustable Knob		1
13	BD1510013	Stator		1	50	BD1510050	Philips Self Screw	ST4.2x16	4
14	BD1510014	Cord Clips	6P4	1	51	BD1510051	Elastic Cylindrical Pin	φ3x20	1
15	BD1510015	Power Cord with Plug		1	52	BD1510052	Adjustable Shaft		1
16	BD1510016	Capacitor Support		1	53	BD1510053	Adjustable Spring II		1
17	BD1510017	Hex Nut	M8	2	54	BD1510054	Big Flat Washer	D5	2
18	BD1510018	Hex Nut	M6	1	55	BD1510055	Split Washer	3.5	1
19	BD1510019	Belt Guard		1	56	BD1510056	Disc Cover		1
20	BD1510020	Rotor		1	57	BD1510057	Pointer		1
21	BD1510021	Philips Screw	M4x8	1	58	BD1510058	Tooth Lock Washer	D4	1
22	BD1510022	Belt Limited Plate		1	59	BD1510059	Philips Screw	M4x6	1
23	BD1510023	Flat Washer	D4	5	60	BD1510060	Index Plate Handle		1
24	BD1510024	Inner Hex Socket Cap Screw	M4x10	2	61	BD1510061	Hex Flange Nut	M4	4
25	BD1510025	Guard Locking Knob		1	62	BD1510062	Index Plate for Work Rest		1
26	BD1510026	Belt Guard Cover		1	63	BD1510063	Miter Gauge		1
27	BD1510027	Belt Support Cover		1	64	BD1510064	Disc Work Table		1
28	BD1510028	Belt 100#	1"x30"	1	65	BD1510065	Flat Washer	D6	2
29	BD1510029	Driven Pulley		2	66	BD1510066	Locking Knob for Work Table		2
30	BD1510030	Circlip for Shaft	D15	2	67	BD1510067	Disc Paper 80#	5"	1
31	BD1510031	Bearing	6202	4	68	BD1510068	Inner Hex Socket Cap Screws Assp.	M6x16	1
32	BD1510032	Driven Shaft		1	69	BD1510069	Philips Screw	M4x8	3
33	BD1510033	Inner Hex Set Screw	M6x8	1	70	BD1510070	Disc		1
34	BD1510034	Philips Screw Assy.	M5x16 Left	1	71	BD1510071	End Bell Of Disc Cover		1
35	BD1510035	Adaptor		1	72	BD1510072	Philips Screw Assy.	M4x153	4
36	BD1510036	Driving Wheel		1	73	BD1510073	Philips Screw Assy.	M4x8	3
37	BD1510037	Philips Screw	M6x10	3					



12 ? TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE(S)	CORRECTIVE ACTION
Sanding Grains easily rub off belt or discs.	<ol style="list-style-type: none"> 1. Sanding belt/disc has been stored in an incorrect environment. 2. Sanding belt/disc has been damaged or folded. 	<ol style="list-style-type: none"> 1. Ensure sanding accessories are stored away from extremely hot or dry temperatures. 2. Store sanding accessories flat – not bent or folded.
Deep sanding grooves or scars in workpiece.	<ol style="list-style-type: none"> 1. Sanding belt/disc grit is too coarse for the desired finish. 2. Workpiece sanded across the grain. 3. Too much sanding force on the workpiece. 4. Workpiece held still against the belt/disc for too long. 	<ol style="list-style-type: none"> 1. Use a finer-grit sanding accessory. 2. Sand with the grain of the wood. 3. Reduce pressure on workpiece while sanding. 4. Keep workpiece moving while sanding on the sanding accessory.
Sanding surface clogs quickly.	<ol style="list-style-type: none"> 1. Too much pressure against belt/disc. 2. Sanding softwood. 	<ol style="list-style-type: none"> 1. Reduce pressure on workpiece while sanding. 2. Use different stock, different sanding accessories, or accept that this will happen and plan on cleaning or replacing discs/belts frequently.
Burns on workpiece.	<ol style="list-style-type: none"> 1. Using a sanding grit that is too fine. 2. Using too much pressure. 3. Work held still for too long. 	<ol style="list-style-type: none"> 1. Use a coarser-grit sanding accessory. 2. Reduce pressure on workpiece while sanding. 3. Do not keep workpiece in one place for too long.
Motor will not start – fuses or circuit breakers tripping or blowing.	<ol style="list-style-type: none"> 1. Short circuit in line, cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line. 	<ol style="list-style-type: none"> 1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals and/or worn insulation. 3. Install correct fuses or circuit breakers or switch tool to an appropriately size circuit.
Motor overheats.	<ol style="list-style-type: none"> 1. Motor overloaded. 2. Extension cord too long and of insufficient gauge (weight). 	<ol style="list-style-type: none"> 1. Reduce load on motor (pressure on object being sanded). 2. Utilize an extension cord of appropriate gauge and length or plug tool directly into outlet.
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> 1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overload. 	<ol style="list-style-type: none"> 1. Inspect connections on motor for loose or shorted terminals or worn insulations. 2. Correct low voltage conditions (for example: improper extension cord length and/or gauge). 3. Install CORRECT fuses or circuit breakers or plug tool into an appropriate circuit, matched to an appropriate fuse or breaker. 4. Reduce the load on the motor.
Machine slows when operating.	<ol style="list-style-type: none"> 1. Feed rate too great. 2. Undersized circuit or use of undersized extension cord. 	<ol style="list-style-type: none"> 1. Reduce the rate at which the workpiece is fed into the working area of the tool. 2. Ensure circuit wires or extension cords are proper gauge, or eliminate use of extension cords.
Machine vibrates excessively.	<ol style="list-style-type: none"> 1. Rubber feet worn, mounting hardware loose 2. Workbench or table is not level 3. Worn bearings 	<ol style="list-style-type: none"> 1. Replace the rubber feet, tighten mounting hardware 2. Shim or adjust as need 3. Have bearings replaced by service technician.
Workpiece frequently gets pulled out of operator's hands.	<ol style="list-style-type: none"> 1. Not supporting the workpiece against the stop. 2. Attempting to sand (unaided) a workpiece that is too small. 	<ol style="list-style-type: none"> 1. Use the platen (backstop) or miter gauge to support the workpiece. 2. Use another hand tool or jig to grasp or hold the workpiece.
Workpiece lifts up from the sanding disc/table.	Sanding on the "up" side wheel.	Sand on right side of sanding disc (as operator faces the disc).

Thank you for investing in a **POWERTEC** power tool. This product has been designed and manufactured to meet high quality standards and is guaranteed for domestic use against defects in workmanship or material for a period of 12 months from the date of purchase. This guarantee does not affect your statutory rights.

SOUTHERN TECHNOLOGIES LLC. BENCH TOP AND STATIONARY POWER TOOL LIMITED 1 YEAR WARRANTY AND 30-DAY SATISFACTION GUARANTEE POLICY

POWERTEC products are designed and manufactured by **Southern Technologies LLC**. All warranty communications should be directed to **Southern Technologies LLC** by calling 847-780-6120, 9 AM to 5 PM, Monday through Friday, US Central Time.



30- DAY SATISFACTION GUARANTEE POLICY

During the first 30 days after the date of purchase, if you are dissatisfied with the performance of this **POWERTEC** tool for any reason, you may return the tool to the retailer from which it was purchased for a full refund or exchange. You must present proof of purchase and return all original equipment packaged with the original product. The replacement tool will be covered by the limited warranty for the remainder of the one year warranty period.

LIMITED ONE YEAR WARRANTY

This warranty covers all defects in workmanship or materials in this **POWERTEC** tool for a one year period from the date of purchase. This warranty is specific to this tool. **Southern Technologies, LLC** reserves the right to repair or replace the defective tool, at its discretion.

HOW TO OBTAIN SERVICE

To obtain service for this **POWERTEC** tool you must return it, freight prepaid, to **POWERTEC**. You may call (toll free) 847-780-6120 for more information. When requesting warranty service, you must present proof of purchase documentation, which includes a date of purchase. **POWERTEC** will either repair or replace any defective part, at our option at no charge to you. The repaired or replacement unit will be covered by the same limited warranty for the remainder of the one year warranty period.

WHAT IS NOT COVERED

This warranty applies to the original purchaser at retail and may not be transferred.

This warranty does not cover consumable items such as saw blades, knives, belts, discs, cooling blocks and sleeves. This warranty does not cover required service and part replacement resulting from normal wear and tear, including accessory wear.

This warranty does not cover any malfunction, failure or defect resulting from:

- 1) misuse, abuse, neglect and mishandling not in accordance with the owner's manual.
- 2) damage due to accidents, natural disasters, power outage, or power overload.
- 3) commercial or rental use.
- 4) alteration, modification or repair performed by persons not recommended by **POWERTEC**.

DISCLAIMER

To the extent permitted by applicable law, all implied warranties, including warranties of **MERCHANTABILITY** or **FITNESS FOR A PARTICULAR PURPOSE**, are disclaimed. Any implied warranties, that cannot be disclaimed under state law are limited to one year from the date of purchase. **Southern Technologies LLC**. is not responsible for direct, indirect, incidental or consequential damages. Some states do not allow limitations on how long an implied warranty lasts and/or do not allow the exclusion or limitation of incidental or consequential damages, so the above limitations may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state. **Southern Technologies LLC.**, makes no warranties, representations, or promises as to the quality or performance of its power tools other than those specifically stated in this warranty.

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