

16" OPEN-END BELT SANDER

Model 1632

Instruction Manual & Parts List

0460219



POWERMATIC®

(800) 248-0144
www.powermatic.com

This manual has been prepared for the owner and operators of a Powermatic Model 1632 Belt Sander. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your sander and to aid in using the machine safely, read this manual thoroughly and follow all instructions carefully.

Warranty & Service

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

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

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

More Information

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

JET Group Warranty

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

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

The JET Group sells through distributors only. Members of the JET Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

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SPECIFICATIONS

Working width (reversing stock)	16" (32")
Working thickness	5"
Minimum board length	13-3/4"
Head configuration	combination
Feed motor (1632-3)	1/4 HP, 3 Ph
Feed motor (1632-1)	1/4 HP, 1 Ph
Feed speeds (variable FPM)	15/32.5
Sanding belt dim.	17" W x 54" L
Sanding belt speed (SFPM)	2,200
Comp. air requirements at 5 atm (CFM)	4
Exhaust volume required (CFM)	800
Dust chute diameter	4"
Overall dimensions	40" L x 29" W x 66" H
Main motor (1632-3)	7-1/2 HP, 3 Ph, 230/460V (prewired 230V)
Main motor (1632-1)	5 HP, 1 Ph, 230 Volt only
Net weight	996 lbs.
Shipping weight	1,106 lbs.

Safety Rules

As with all machines, there is a certain amount of hazard involved with the use of this belt sander. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.

Read, understand and follow the safety and operating instructions found in this manual. Know the limitations and hazards associated with the open-end sander.

Electrical grounding. Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.

Power on. Before connecting power to the sander, make sure the start switch is in the "OFF" position.

Protect yourself. Protect yourself at all times when operating the wide belt sander. Avoid eye injury by wearing approved safety shields, goggles or glasses at all times (NOTE: Normal eye glasses are only impact-resistant, they are *not* safety glasses). Wear protected footwear. Steel toed shoes are recommended because heavy parts can fall off the conveyor table onto feet.

Personal protection. Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows. Remove all loose outer clothing and confine long hair. Protective type footwear should be used. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations, use hearing protective devices. Do not wear gloves.

Guards. Do not operate the sander with guards off. Keep the guards in place at all times when the machine is running. If removed for maintenance purposes or any other reason, use extreme caution and replace the guards upon completion of the task and before using the machine again. Injury can result from exposure to the machine's internal moving parts.

Check damaged parts. Before continuing use of the machine, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and safely and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that could effect its operation. A guard or other part that is damaged should be properly repaired or replaced before machine operation continues.

Work area. Keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Powermatic recommends the use of anti-skid floor strips on the floor area where the operator normally stands and that each machine's work area be marked off. Provide adequate work space around the machine.

Operator position. Stand to one side of the conveyor table and make sure no one else is standing in line with the table while feeding into the machine. The wide belt sander operates at a high speed and should a part slip, it will exit the machine at a high rate of speed and may result in injuries to anyone standing directly in front of the infeed. (Keep conveyor belt clean and check pin-roll adjustments.) Maintain a balanced stance and keep your body under control at all times. Do not overreach or use excessive force to perform any machine operation.

Hand Safety. Keep hands clear while feeding parts onto the conveyor table. The part will be forced down as it begins to feed into the machine, causing a pinching action between the part and the table. Use caution! Hands should be clear of the stock and the table to avoid pinching. Never reach into a running machine. Turn off electrical power and stop machine before attempting to retrieve parts from within the machine. Contact with internal moving parts can result in loss or injury to fingers, hands and arms.

Housekeeping. Before turning on machine, remove all extra equipment such as keys, wrenches, scrap, and cleaning rags away from the saw.

Careless acts. Give the work you are doing your undivided attention. Looking around, carrying on a conversation, and “horseplay” are careless acts that can result in serious injury.

Disconnect machine before performing any service or maintenance. Make sure the sander is unplugged or electrically disconnected and locked out before performing maintenance, checking belts or service work. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.

Alignment. Check the alignment of the splitter, fence and miter slot to the blade. A caution decal is installed on each guard and splitter to remind the operator of the dangers of misalignment.

Maintain tools in top condition. Keep all tools sharp and clean for the best and safest performance, and follow instructions for lubricating and changing accessories. Never stand on the machine. Serious injury could occur if the sander is tipped or if the sanding belt is accidentally contacted.

Job completion. The operator of the sander is responsible for shutting the machine down when it is not in use. CAUTION: The abrasive belt will coast to a stop in normal conditions, and will only break to a stop when the emergency devices are pressed! IT IS DANGEROUS TO LEAVE A MACHINE UNATTENDED. Persons not familiar with the sander's operation could injure themselves or others.

Replacement parts. Use only Powermatic or factory authorized replacement parts and accessories; otherwise the table saw warranty and guarantee is null and void.

Misuse. Do not use this Powermatic open end sander for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless for any injury or damage which may result from that use.

If you are not thoroughly familiar with the operation of wide belt sanders, obtain advice from your supervisor, instructor or other qualified person.

Drugs, alcohol, medication. Do not operate this machine while under the influence of drugs, alcohol, or any medication.

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

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

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

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



CAUTION: (This means that if precautions are not heeded, it may result in minor or moderate injury and/or possible machine damage)



WARNING: (This means that if precautions are not heeded, it could result in serious injury or possibly even death).

RECEIVING THE SANDER

Remove the sander from its crate and inspect for damage to ensure all parts are intact. Any damage should be reported to your distributor and shipping agent immediately upon discovery.

Before proceeding with installation, read your instruction manual thoroughly. Familiarize yourself with correct set-up, maintenance and safety procedures.

Contents of crate:

- 1 Wide belt sander
- 1 Infeed roller assembly
- 1 Outfeed roller assembly
- 1 Side support
- 1 Sanding belt
- 1 Toolbox containing oil gun, door latches, and draw bar (for the graphite pad)

INSTALLATION

If using a forklift, run the forks between the upper cabinet and the conveyor belt. Level the machine and bolt it to the floor with high quality anchor bolts through the mounting holes located on the four corners of the base.

Remove the protective coating from the rollers with a soft cloth moistened with a good commercial solvent. DO NOT USE acetone, gasoline, lacquer thinner or any type of flammable solvent.

ELECTRICAL CONNECTIONS



WARNING: All electrical connections should be made by a qualified electrician. Failure to comply may result in serious injury and/or damage to the machine and property. The machine must be properly grounded.

1. A cable of the proper gauge should be used to connect the sander to the power supply.
2. Remove the wiring cover and attach the ground wire (A), Figure 1.

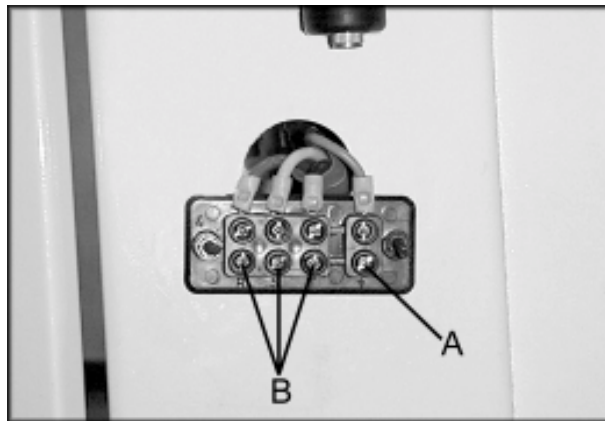


FIGURE 1

3. For 3 Phase: Connect the three power leads (B) to the wiring board.

For 1 Phase: Connect the two power leads to the wiring board.

4. This machine should be hard wired into a dedicated circuit with a properly rated breaker according to your local code.
5. Replace wiring cover.
6. Turn on the feed belt and verify that the belt feeds into the machine. If it turns toward the user, disconnect the machine from the power source and switch only two of the power leads (on 3 Phase machine).

SWITCHING VOLTAGE

The 3 Phase machine is pre-wired for 230V operation. If 460V is needed, see the wiring box cover on the reduction motor and the main motor. BOTH motors must be switched if changing from 230V to 460V. The transformer, behind the control panel, must also be switched from 230V to 460V.

ASSEMBLY

1. Attach the infeed and outfeed roller assemblies with sixteen 5/16" x 2" hex. hd. screws and spring washers.
2. Mount the side support with two hex cap screws and flat washers.
3. Insert the door latches into the slots on the cabinet doors.
4. Assemble the sanding belt to the rollers. Make sure the arrow on the belt matches the rotation of the rollers.

ADJUSTMENTS

AIR CONTROL

Connect the machine to an air hose. The air pressure that flows into the filter can be adjusted with the knob (A), Figure 2. Normal working air pressure should be set at 75 psi, which can be read on the pressure gauge.

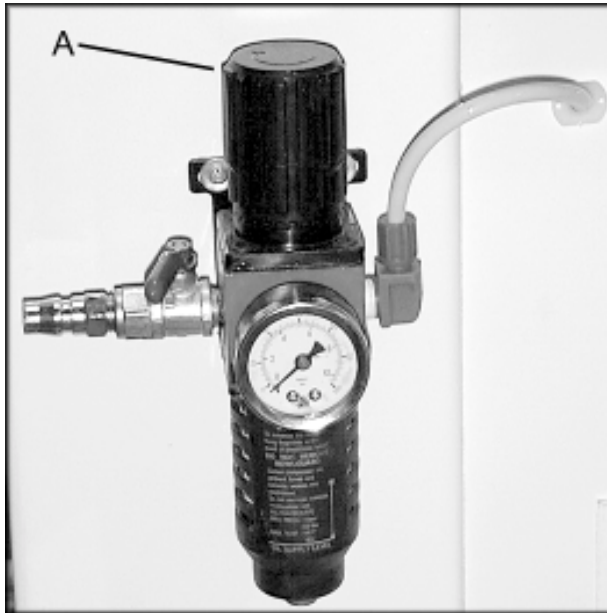


FIGURE 2

SANDING BELT TRACKING & OSCILLATION

The tracking and oscillation of your sander are pre-adjusted at the factory. However, should adjustment be required, do the following:

1. Adjust the air valve (A), Figure 3, to control the tracking sensitivity.
2. The oscillation speed can be controlled by adjusting the top air valve (B).
3. Empty the glass container (C) as needed.

NOTE: There is a limit switch at both ends of the upper roller. If the sanding belt comes in contact with these limit switches, the brakes will be activated.

FEED BELT TRACKING & TENSION

Tracking and tension for the feed belt is controlled by two socket set screws on each side of the belt (A) as shown in Figure 4.

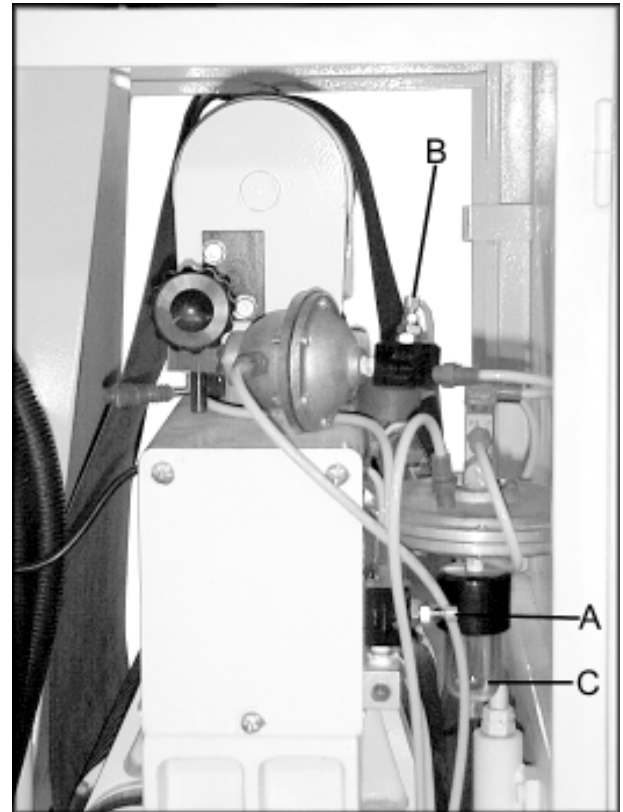


FIGURE 3

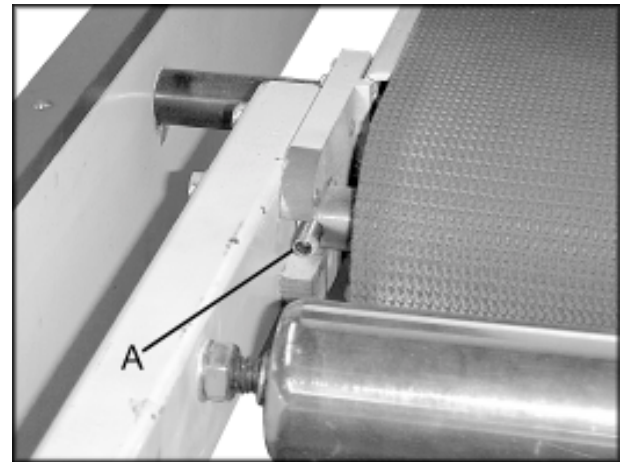


FIGURE 4

ADJUSTING TABLE PARALLEL TO SANDING SURFACE

The table comes pre-adjusted from the factory. Check its parallelism by running a 16" wide piece of plywood through the sander. Use a pair of calipers to measure the thickness remaining on both sides.

Adjust the parallelism using the four hex. screws (A), under the table base. See Figure 5.



FIGURE 5

FEED SPEED ADJUSTMENT

The Model 1632 has two speeds that feed the workpiece at 15 feet per minute (FPM) finished surface sanding, and 32.5 FPM for faster, lighter sanding.

To change the feed rate:

1. Disconnect machine from power source.
2. Remove cap screw that holds the sprocket cover at the right rear of the working table.
3. Loosen the four set screws holding the sprockets in place.
4. Remove the sprockets and chain together and position according to the required operation. See Figure 6.
5. Retighten the four set screws, then replace cover and cap screw.

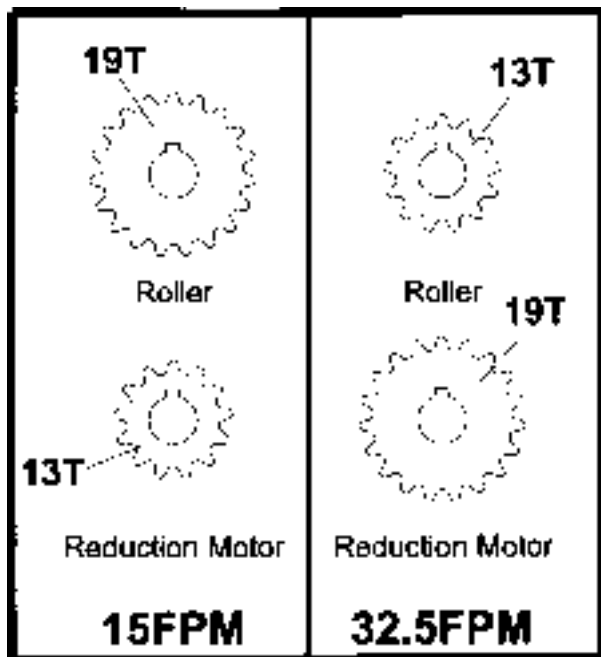


FIGURE 6

OPERATION

CONTROLS (Figure 7):

Emergency stop (A) will stop the feeding belt and sanding belt. The button must be turned clockwise to reset sanding functions.

Amp Meter (B) displays the amperage.

Feeding Start (C) will start the feeding belt only.

Feeding Stop (D) will stop the feeding belt only.

Sanding Belt Start (E) will start the sanding belt only.

Sanding Belt Stop (F) will stop the sanding belt only.

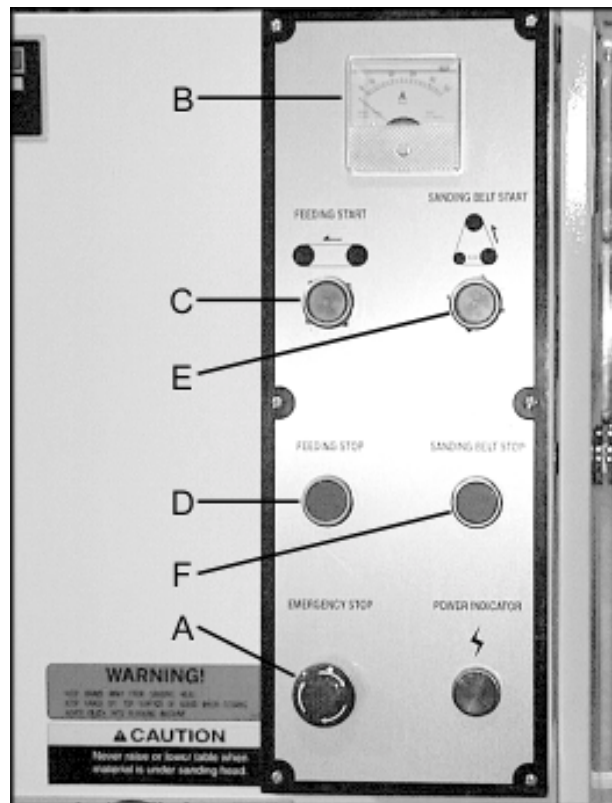


FIGURE 7

NOTE: The orange bar on the front of the infeed roller acts as a safety stop. When the bar is pressed, the brakes are applied.

1. Connect the air line to the sander.
2. Adjust the pressure gauge to 75 psi.
3. Engage the upper roller by turning the knob (A), Figure 8, to the upper position.
4. Adjust the platen with the lever (B) and lock it (C) in the desired position. The platen or main rubber roller can act as the sanding contact, as well as a combination of both.

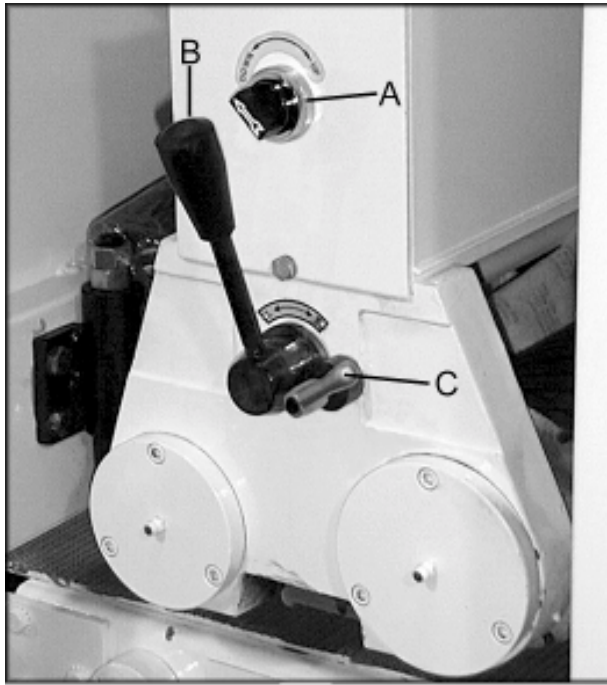


FIGURE 8

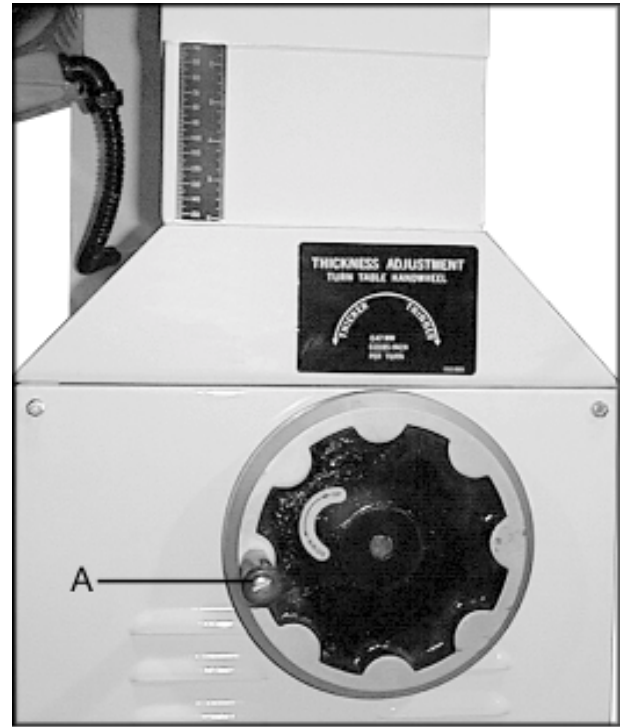


FIGURE 9

5. Rotate the main handwheel (A), on the lower cabinet, to raise or lower the table. See Figure 9. Refer to the scale for the desired setting. The recommended depth of sanding is .0164" or two revolutions of the handwheel. The table can be locked in place by the lever at the base of the column.
6. Turn on the power to the machine.
7. Start the sanding belt.
8. Start the feeding conveyor.

NOTE: If you are sanding a workpiece greater than 16 inches, pull out the support extension, and tighten the wing nuts. After the first pass, the workpiece can be spun around and fed back through the machine, for a maximum sanding width of 32 inches.

Trouble-Shooting for Model 1632 Sander

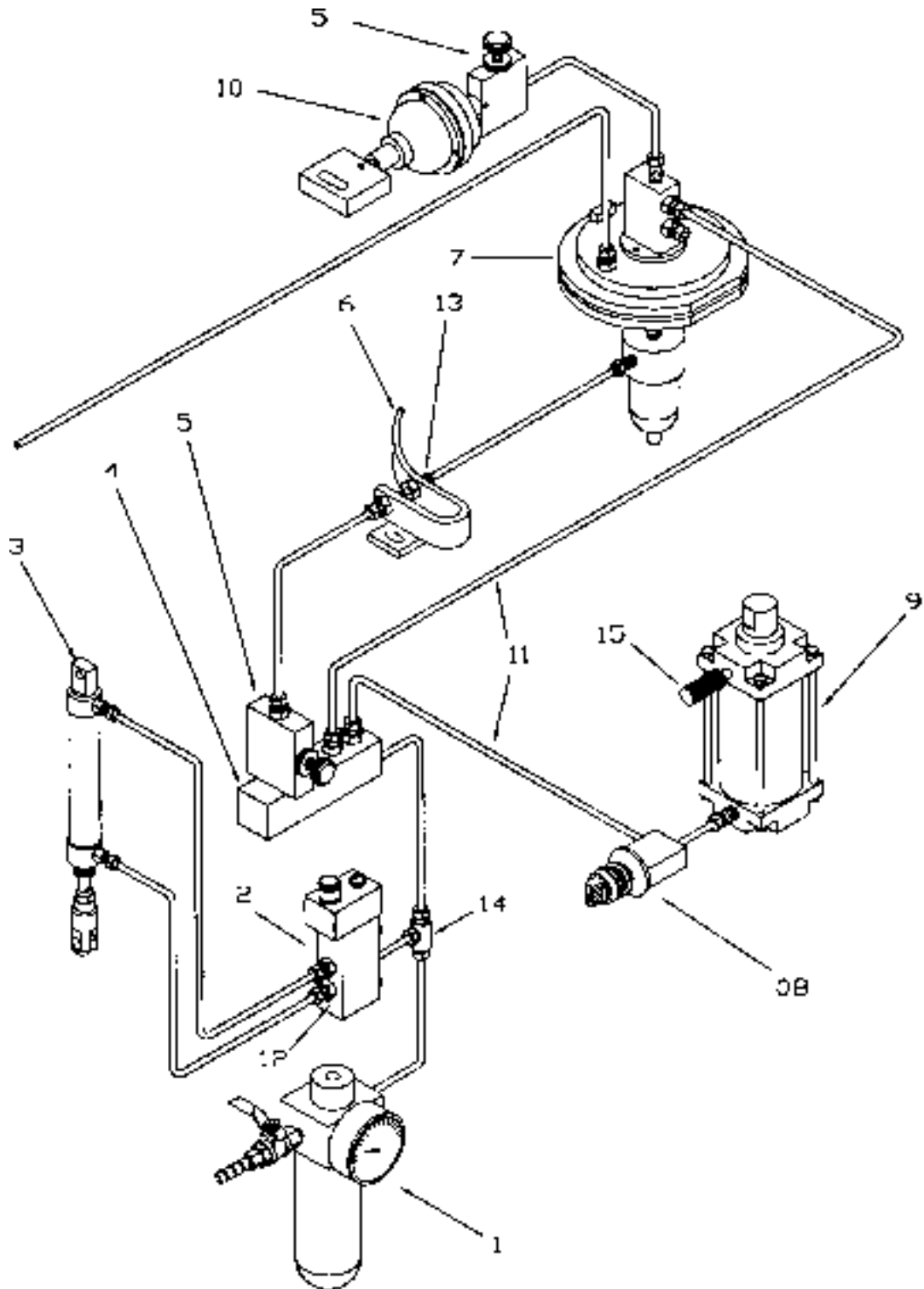
PROBLEM	POSSIBLE CAUSE	SOLUTION
The sanding belt clogs quickly.	<ol style="list-style-type: none"> 1. Sandpaper grit too small. 2. Too much material is being sanded off. 3. The wood is too dirty or oily. 4. Suction is insufficient. 	<ol style="list-style-type: none"> 1. Use larger grit. 2. Reduce sanding depth. 3. Use dry stock. 4. Increase suction.
Edges round when sanding.	<ol style="list-style-type: none"> 1. Too much material being removed. 	<ol style="list-style-type: none"> 1. Reduce sanding depth.
The thickness differs on left and right sides of workpiece.	<ol style="list-style-type: none"> 1. Conveyor table is not parallel to the contact roller or platen. 2. Worn out felt and graphite on platen head. 	<ol style="list-style-type: none"> 1. Adjust table to parallel. 2. Replace felt/graphite.
The thickness differs on front and back sides of workpiece.	<ol style="list-style-type: none"> 1. Feed speed too fast. 2. Too much material is being removed. 3. Sandpaper grit too fine. 4. Pressure plate not level. 	<ol style="list-style-type: none"> 1. Reduce speed. 2. Reduce sanding depth. 3. Use coarser grit. 4. Adjust plate to level.
Workpiece slips on conveyor belt.	<ol style="list-style-type: none"> 1. Too much or too little pressure from pressure plate. 2. Sanding belt clogged with dust. 3. Belt worn out. 	<ol style="list-style-type: none"> 1. Adjust to proper pressure. 2. Blow out dust with high-pressure air. 3. Replace belt.
Straight notch grooves on workpiece.	<ol style="list-style-type: none"> 1. Dirty pressure roller. 2. Rubber roller scratched. 3. Worn out lining and graphite on platen head. 	<ol style="list-style-type: none"> 1. Clean pressure roller. 2. Replace rubber roller. 3. Replace lining/graphite
Snake marks on workpiece.	<ol style="list-style-type: none"> 1. Sanding belt partially damaged. 2. Sanding grit loose. 	<ol style="list-style-type: none"> 1. Repair or replace sanding belt. 2. Replace sanding belt.
Belt slips out of track.	<ol style="list-style-type: none"> 1. Tracking air valve is clogged or not open enough. 	<ol style="list-style-type: none"> 1. Clean/enlarge valve opening.
Straight parallel stripes across the workpiece.	<ol style="list-style-type: none"> 1. Sanding belt joint is too thick. 2. Sanding belt is worn. 	<ol style="list-style-type: none"> 1. Replace sanding belt. 2. Replace sanding belt.

OPTIONAL ACCESSORIES

6293307	Sanding Belt, 17" X 54" - 60 Grit
6293308	Sanding Belt, 17" X 54" - 80 Grit
6293309	Sanding Belt, 17" X 54" - 100 Grit
6293310	Sanding Belt, 17" X 54" - 120 Grit

PARTS LIST: Air Control Assembly

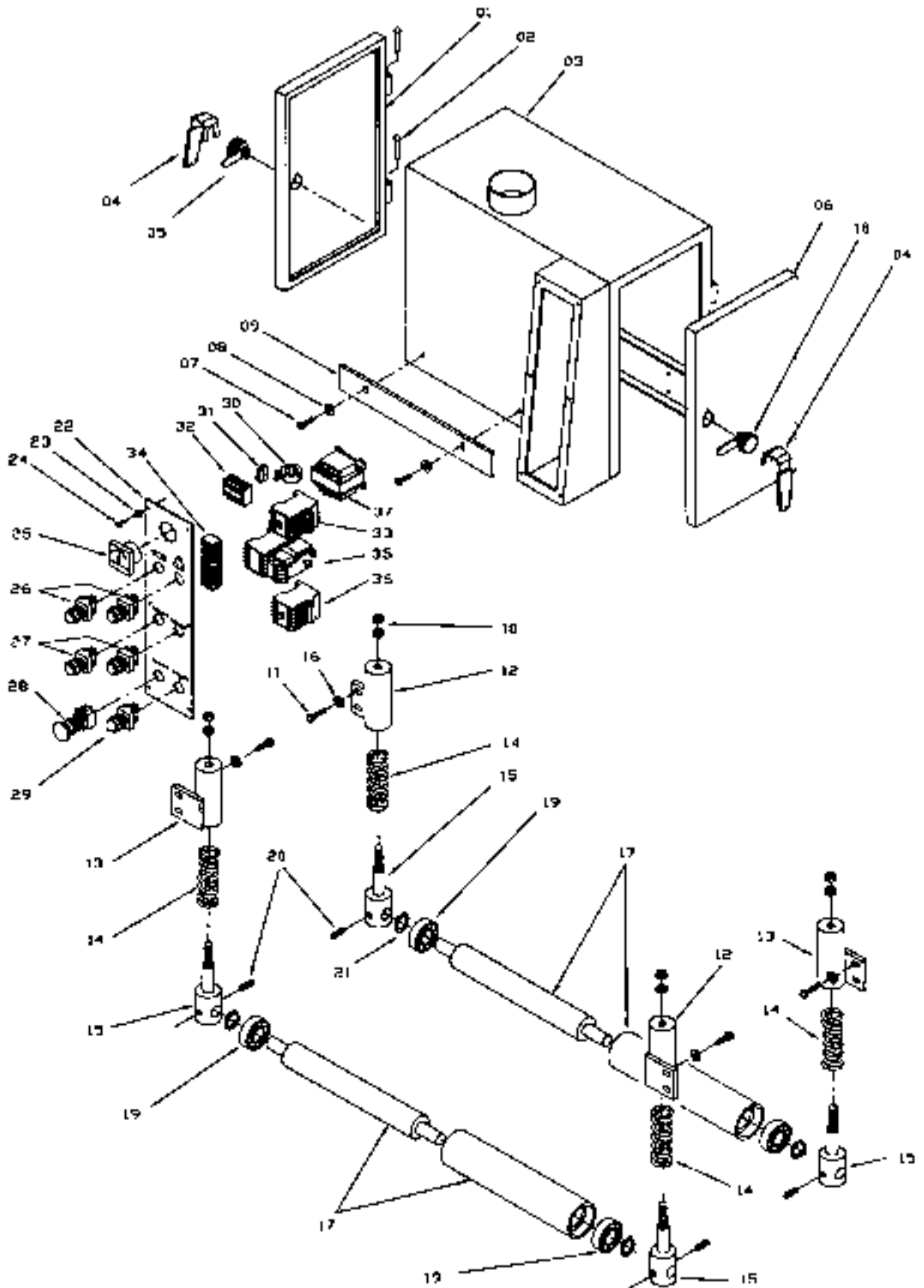
No.	Part No.	Description	No.	Part No.	Description
1	6293482	Filter	9	6293250	Cylinder
2	6293483	Solenoid Valve	10	6293252	Oscillator Cylinder
3	6293484	Brake Cylinder	11	6293490	Plastic Pipe
4	6293485	Multi-Hole Connector	12	6293491	Plastic Joint, PT-1/8"
5	6293486	Air Valve	13	6293492	Copper Joint
6	6293487	Air Sensor Assembly	14	6293493	T-Joint
7	6293488	Air Sensor	15	6293494	Silencer
8	6293489	Switching Valve			



PARTS LIST: Electricity Control & Upper Adj. Roller Assembly

No.	Part No.	Description	No.	Part No.	Description
1	6293203	Upper Door (L)	24	6293226	Pan Head Screw, 3/16 X 3/8
2	6293204	Pin for Upper Door	25	6293227	Amp Meter
3	6293205	Upper Cabinet	26	6293228	Feed Start Switch
4	6293206	Door Knob		6293228	Sanding Belt Start Switch
5	6293207	Door Latch (L)	27	6293229	Feed Stop Switch
6	6293208	Upper Door (R)		6293229	Sanding Belt Stop Switch
7	6293209	Pan Head Screw, 1/4 X 1/2	28	6293230	Stop Switch
8	6293210	Flat Washer, 1/4	29	6293231	Power Indicator Light
9	6293211	Plate	30	6293232	Current Coil
10	6293212	Hex Nut, 1/2	31	6293233	Fuse Stand, 5 HP
11	6293213	Hex Head Screw, 3/8 X 3/4		6293312	Fuse Stand, 7-1/2 HP
12	6293214	Adjust Stand (L)	32	6293234	Terminal Strip, 5 HP
13	6293215	Adjust Stand (R)		6293313	Terminal Strip, 7-1/2 HP
14	6293216	Spring	33	6293235	Relay, 5 HP
15	6293217	Fixed Roller Stand w/ Adjust Bolt		6293314	Relay, 7-1/2 HP
16	6293218	Flat Washer, 3/8	34	6293236	Terminal Strip, 5 HP
17	6293219	Shaft & Rubber Roller		6293315	Terminal Strip, 7-1/2 HP
18	6293311	Door Latch (R)	35	6293237	Overload Relay, 5 HP
19	6293221	Ball Bearing		6293316	Overload Relay, 7-1/2 HP
20	6293222	Set Screw, 1/4 X 3/4	36	6293238	Relay, 5 HP
21	6293223	Ring		6293317	Relay, 7-1/2 HP
22	6293224	Control Plate	37	6293239	Transformer, 5 HP
23	6293225	Gear Washer, 3/16		6293318	Transformer, 7-1/2 HP

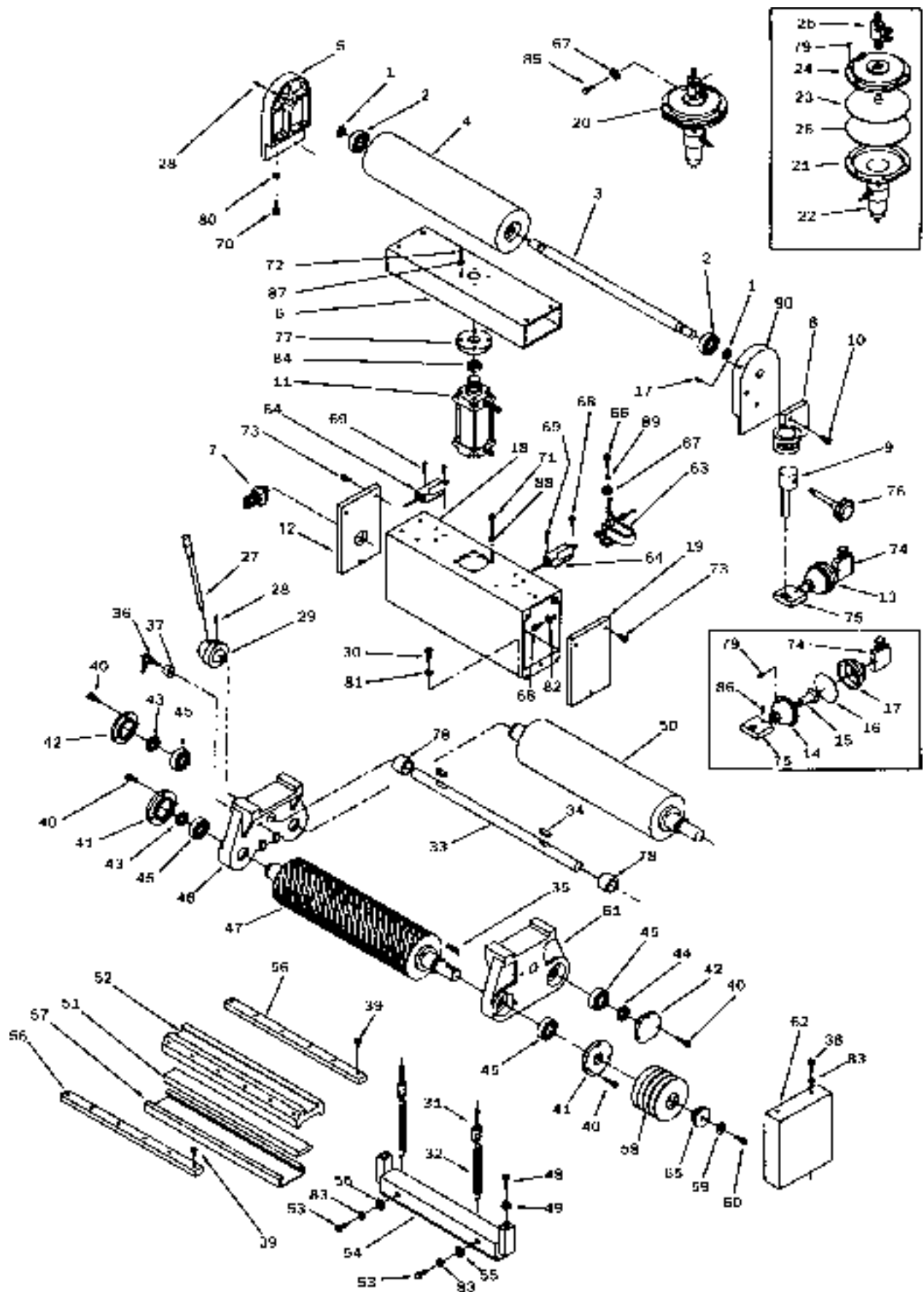
Electricity Control & Upper Adj. Roller Assembly (1632 Sander)



PARTS LIST: Sanding Drum Assembly (1632 Sander)

No.	Part No.	Description	No.	Part No.	Description
1	6293240	Ring	43	6293283	Lock Nut (counter-clockwise)
2	6293241	Ball Bearing	44	6293284	Lock Nut (clockwise)
3	6293242	Shaft	45	6293285	Ball Bearing
4	6293243	Upper Roller	46	6293286	Round Bearing Frame
5	6293244	Upper Roller Base	47	6293287	Main Rubber Roller
6	6293245	Column	48	6293288	Hex Head Screw, 5/16 X 1-3/4
7	6293246	Switch Valve	49	6293289	Hex Nut, 5/16
8	6293247	Eccentric Shaft Base	50	6293290	Back Steel Roller
9	6293248	Eccentric Shaft	51	6293291	Blanket
10	6293249	Hex Head Screw, 5/16 X 1/2	52	6293292	Pad Slider
11	6293250	Air Cylinder Assembly	53	6293293	Hex Head Screw, 3/8 X 1
12	6293251	Cover (L)	54	6293294	Pad
13	6293252	Air Oscillator Cylinder	55	6293218	Flat Washer, 3/8
	6293496	Air Valve Assembly (Items 14 thru 17, 74, 75, 79 & 86)	56	6293295	Pressing Bar
14	6293253	Front Cover	57	6293296	Graphite Canvas
15	6293254	Oscillator Shaft	58	6293297	Pulley (5 HP)
16	6293255	Membrane		6293298	Pulley (7-1/2 HP)
17	6293256	Rear Cover	59	6293299	Flat Washer, 5/16
18	6293257	Column	60	6293300	Hex Head Screw, 5/16 X 1
19	6293258	Cover (R)	61	6293301	Rectangular Bearing Base
20	6293259	Air Sensor	62	6293302	Cover
	6293497	Air Valve Assembly (Items 21 thru 26 & 79)	63	6293303	Air Sensor Assembly
21	6293260	Lower Cover	64	6293304	Limit Switch
22	6293261	Air Sensor Substance	65	6293305	Disk
23	6293262	Piston	66	6293306	Hex Head Screw, 1/4 X 3/8
24	6293263	Upper Cover	67	6293210	Flat Washer, 1/4
25	6293264	Plastic Joint Assembly	68	6293330	Pan Head Screw, 5/32 X 1/2
26	6293265	Membrane	69	6293331	Pan Head Screw, 5/32 X 1
27	6293266	Handle Assembly	70	6293332	Hex Head Screw, 5/16 X 2
28	6293267	Set Screw, 1/4 X 1/4	71	6293333	Cap Screw, M8 X 20
29	6293268	Handle Hub	72	6293334	Hex Head Screw, 1/4 X 2
30	6293269	Hex Head Screw, 3/8 X 1-1/4	73	6293209	Pan Head Screw, 1/4 X 1/2
31	6293270	Adjust Bolt, 3/8 X 1-1/4	74	6293335	Air Valve
32	6293271	Spring	75	6293336	Block Connector
33	6293272	Shaft	76	6293337	Knob
34	6293273	Key, 5 X 5 X 30	77	6293338	Cylinder Disk
35	6293274	Key, 8 X 8 X 40	78	6293339	Eccentric Roller
36	6293275	Lock Handle	79	6293340	Pan Head Screw, 3/16 X 5/8
37	6293276	Knob	80	6293341	Gear Washer, 5/16
38	6293277	Hex Head Screw, 3/8 X 1-1/2	81	6293342	Gear Washer, 3/8
39	6293278	Pan Head Screw, 5/32 X 3/8	82	6293343	Flat Washer, 5/32
40	6293279	Hex Socket Cap Screw, 1/4 X 1/2	83	6293344	Spring Washer, 3/8
41	6293280	Bearing Cover	84	6293345	Hex Nut
42	6293281	Bearing Cover (L)	85	6293346	Hex Head Screw, 1/4 X 1/2
	6293282	Bearing Cover (R)	86	6293347	Spring Pin, 3 X 16
			87	6293348	Gear Washer, 1/4
			88	6293349	Gear Washer, M8
			89	6293350	Spring Washer, 1/4
			90	6293501	Upper Roller Base (R)

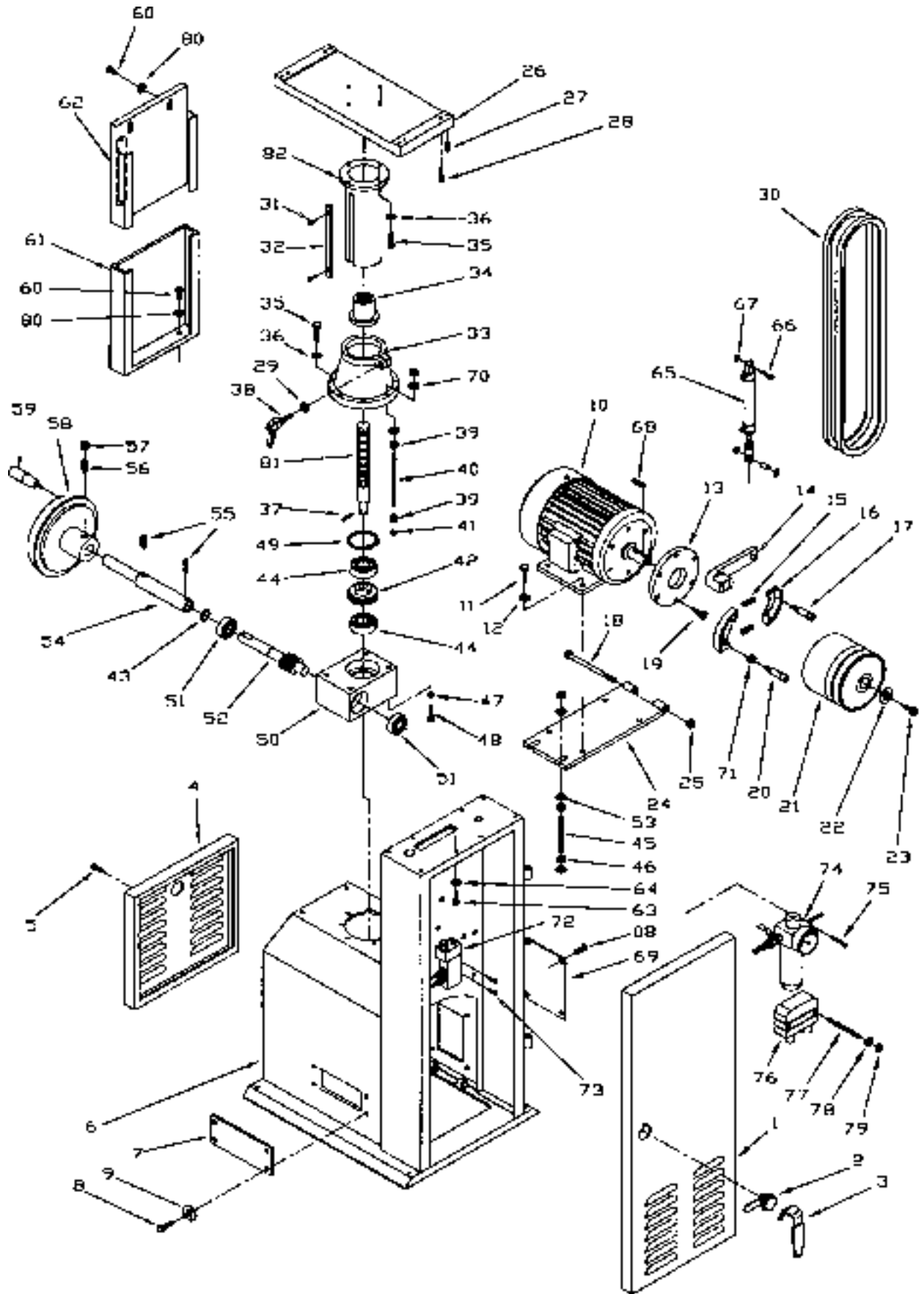
EXPLODED VIEW: **Sanding Drum Assembly (1632 Sander)**



PARTS LIST: Base & Table Adjust Assembly (1632 Sander)

No.	Part No.	Description	No.	Part No.	Description
1	6293415	Door	41	6293452	Spring Washer, 1/4
2	6293416	Crosspiece	42	6293453	Gear
3	6293417	Door Knob	43	6293454	Ring
4	6293418	Cover	44	6293455	Ball Bearing
5	6293419	Hex Head Screw, 1/4 X 1	45	6293456	Bolt, 3/8 X 4
6	6293420	Base	46	6293457	Hex Nut, 3/8
7	6293421	Cover	47	6293218	Flat Washer, 3/8
8	6293422	Hex Head Screw, 3/16 X 3/8	48	6293458	Hex Head Screw, 3/8 X 1-3/4
9	6293423	Flat Washer, 3/16	49	6293459	Ring
10	6293424	Motor (5 HP, 1 PH)	50	6293460	Gear Box
	6293425	Motor (7-1/2 HP, 3 PH)	51	6293461	Ball Bearing
11	6293293	Hex Head Screw, 3/8 X 1	52	6293462	Worm Gear
12	6293426	Spring Washer, 3/8	53	6293218	Flat Washer, 3/8
13	6293427	Brake Base	54	6293463	Shaft
14	6293428	Brake Pole	55	6293267	Set Screw, 1/4 X 1/4
15	6293429	Brake Spring	56	6293464	Set Screw, 1/4 X 1
16	6293430	Brake	57	6293450	Hex Nut, 1/4
17	6293431	Bolt, 5/16 X 1-1/2	58	6293465	Wheel, 8
18	6293432	Bolt, 1/2	59	6293466	Handle
19	6293433	Socket Head Screw, 5/16 X 1/2	60	6293209	Pan Head Screw, 1/4 X 1/2
20	6293434	Bolt, 3/8 X 1-1/2	61	6293467	Lower Guard
21	6293435	Pulley (5 HP)	62	6293468	Upper Guard
	6293436	Pulley (7-1/2 HP)	63	6293277	Hex Head Screw, 3/8 X 1-1/2
22	6293210	Flat Washer, 1/4	64	6293342	Gear Washer, 3/8
23	6293437	Hex Head Screw, 1/4 X 1	65	6293469	Air Cylinder Assembly
24	6293438	Motor Plate (5 HP)	66	6293300	Hex Head Screw, 5/16 X 1
	6293439	Motor Plate (7-1/2 HP)	67	6293289	Hex Nut, 5/16"
25	6293212	Hex Nut, 1/2	68	6293470	Key (7-1/2 HP), 10 X 8 X 60
26	6293440	Base		6293471	Key (5 HP)
27	6293441	Set Screw, 5/16 X 1	69	6293472	Cover
28	6293442	Hex Socket Cap Screw, 5/16 X 1-1/2	70	6293210	Flat Washer 1/4
29	6293299	Flat Washer, 5/16	71	6293457	Hex Nut, 3/8
30	6293443	Belt, A-82	72	6293473	Solenoid Valve
31	6293444	Flat Head Screw, 1/4 X 1/2	73	6293331	Pan Head Screw, 5/32 X 1
32	6293445	Key, 19 X 3/8 X 270	74	6293474	Filter
33	6293446	Base Lifting Pipe	75	6293475	Pan Head Screw, 5/32 X 1-3/8
34	6293447	Cap Screw, 3/4	76	6293476	Hookup Box
35	6293249	Hex Head Screw, 5/16 X 1/2	77	6293477	Screw, 3/16 X 1-3/8
36	6293341	Gear Washer, 5/16	78	6293478	Flat Washer, 3/16
37	6293448	Spring Pin, 5 X 25	79	6293479	Hex Nut 3/16
38	6293449	Lock Handle	80	6293210	Flat Washer, 1/4
39	6293450	Hex Nut, 1/4	81	6293480	Screw Lead, 3/4
40	6293451	Bolt, 1/4 X 290mm	82	6293481	Lifting Pipe

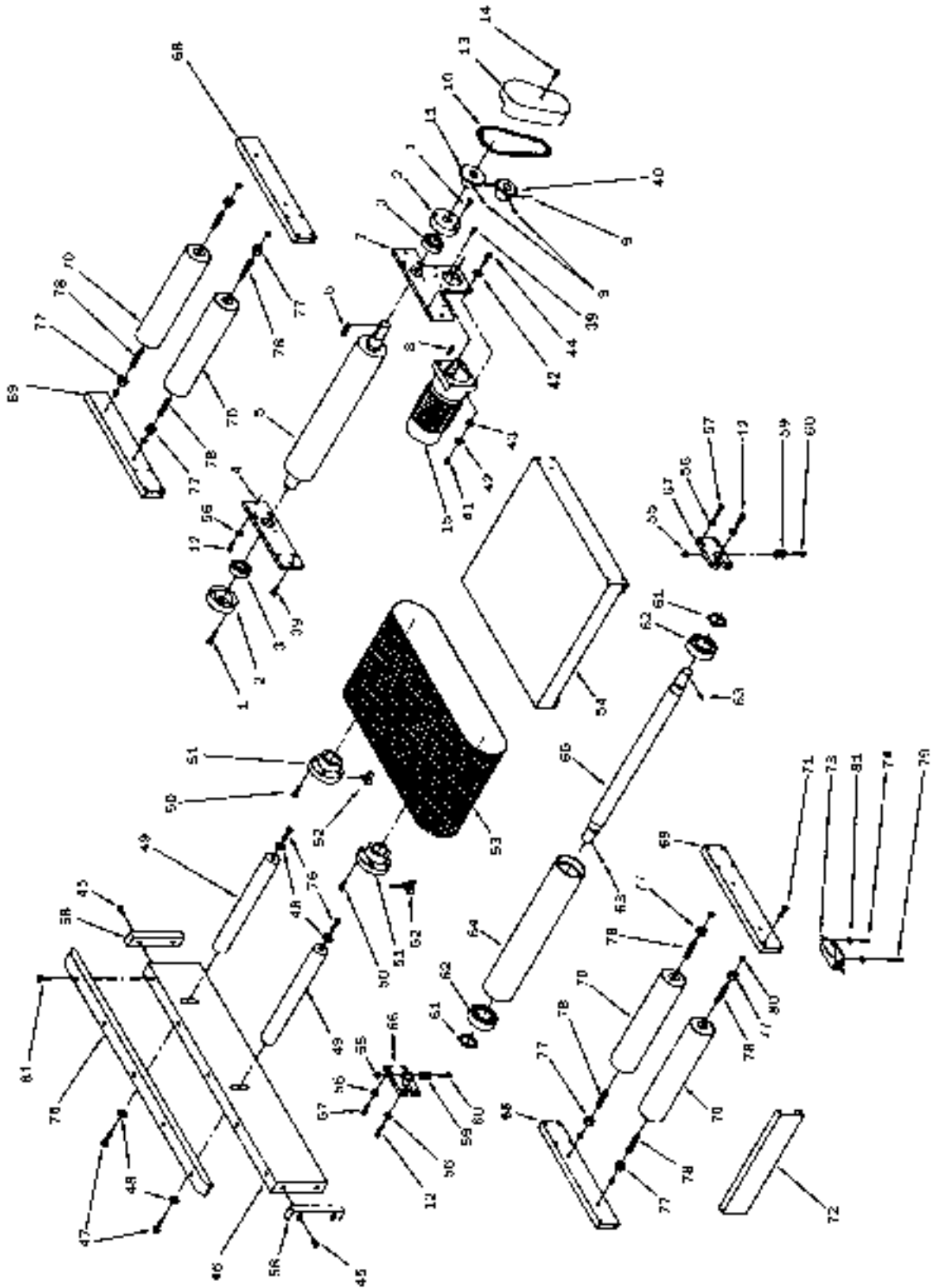
Base & Table Adjust Assembly (1632 Sander)



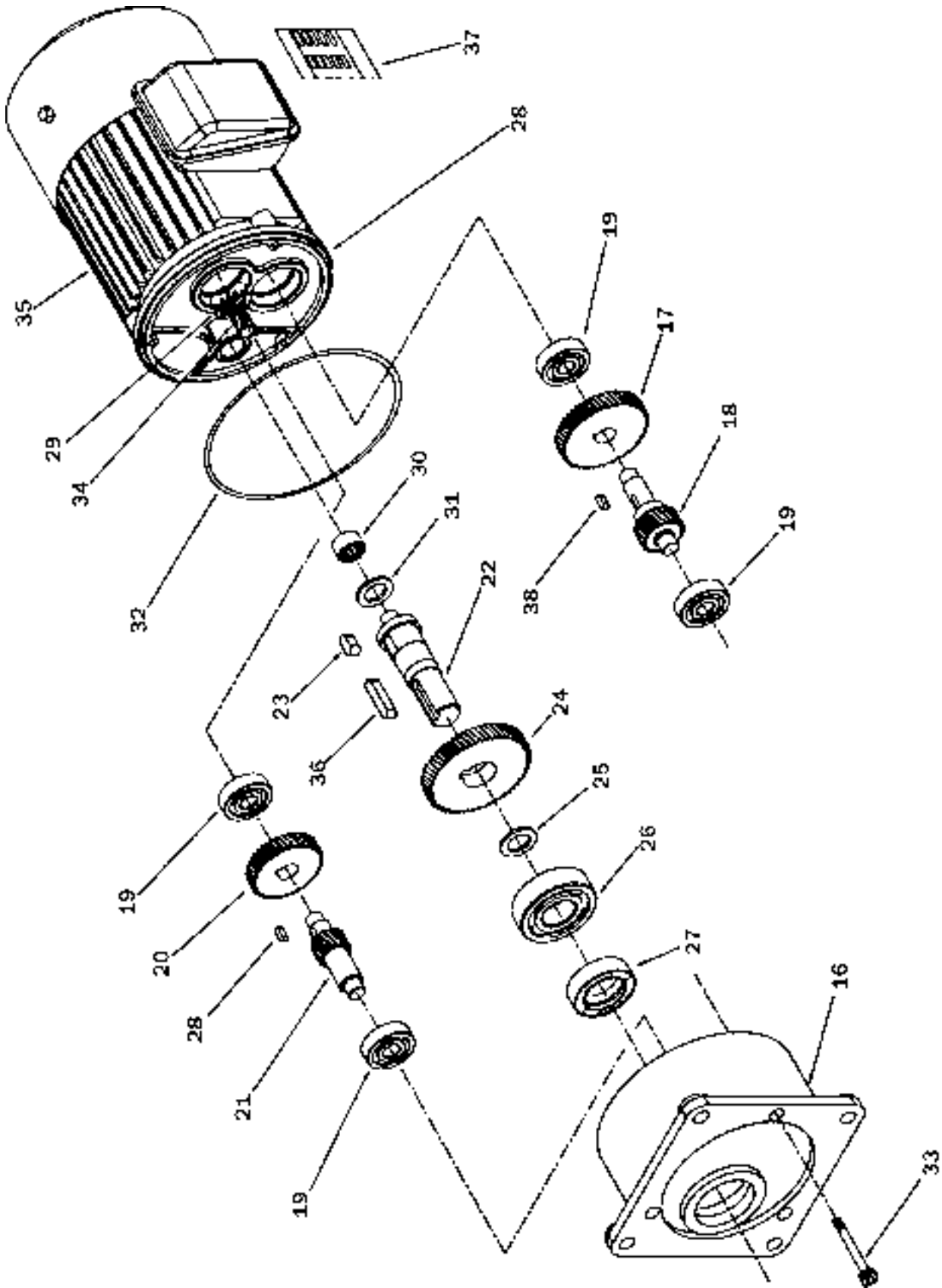
PARTS LIST: Conveyor Belt & Table Assembly (1632 Sander)

No.	Part No.	Description	No.	Part No.	Description
1	6293351	Hex Socket Cap Screw, 1/4 X 1/4	39	6293385	Hex Head Screw, 5/16 X 3/8
2	6293352	Bearing Cover	40	6293386	Sprocket
3	6293353	Ball Bearing	41	6293289	Hex Nut, 5/16
4	6293354	Back Conveyor Roller Base (L)	42	6293341	Gear Washer, 5/16
5	6293355	Roller	43	6293299	Flat Washer, 5/16
6	6293356	Key, 6 X 6 X 20	44	6293249	Hex Head Screw, 5/16 X 1/2
7	6293357	Back Conveyor Roller & Motor Base	45	6293387	Flat Head Screw, 5/32 X 1
8	6293358	Key, 5 X 5 X 25	46	6293388	Stop Plate
9	6293267	Set Screw, 1/4 X 1/4	47	6293277	Hex Head Screw, 3/8 X 1-1/2
10	6293359	Chain	48	6293218	Flat Washer, 3/8
11	6293360	Sprocket	49	6293389	Shaft
12	6293332	Hex Head Screw, 5/16 X 2	50	6293331	Pan Head Screw, 5/32 X 1
13	6293361	Cover	51	6293390	Shaft Base
14	6293362	Hex Socket Cap Screw, 1/4 X 2	52	6293391	Wing Screw, 1/4 X 1/2
15	6293495	Reduction Motor Assembly, 1 Ph (Items 16 thru 38)	53	6293392	Conveyor Belt
	6293498	Reduction Motor Assembly, 3 Ph (Items 16 thru 38)	54	6293393	Working Table
16	6293363	Body	55	6293289	Hex Nut, 5/16
17	6293364	Gear B, 40T	56	6293394	Spring Washer, 5/16
18	6293365	Gear A, 19T	57	6293300	Hex Head Screw, 5/16 X 1
19	6293366	Ball Bearing	58	6293395	Stop Plate Annex
20	6293367	Gear B, 47T	59	6293396	PVC Roller
21	6293368	Gear C, 14T	60	6293397	Hex Head Screw, 5/16 X 1-1/2
22	6293369	Output Shaft	61	6293398	Ring
23	6293370	Key, 5 X 5 X 10	62	6293241	Ball Bearing
24	6293371	Gear D, 46T	63	6293399	Adjust Bolt, 3/8 X 1-1/2
25	6293372	Washer	64	6293400	Roller
26	6293373	Ball Bearing	65	6293401	Shaft
27	6293374	Oil Seal, 20, 35, 7	66	6293402	Roller Base (L)
28	6293375	Rear Cover	67	6293403	Roller Base (R)
29	6293376	Oil Seal, 12, 22, 5	68	6293404	Roller Frame (L)
30	6293377	Needle Bearing, 1012	69	6293405	Roller Frame (R)
31	6293378	Washer	70	6293406	Roller
32	6293379	O-Ring	71	6293407	Pan Head Screw, 5/32 X 1-3/4
33	6293380	Fixing Screw	72	6293408	Front Plate
34	6293381	Gear A, 8T	73	6293409	Limit Switch
35	6293382	Motor, 1/4 HP, 1 PH	74	6293330	Pan Head Screw, 5/32 X 1/2
	6293220	Motor, 1/4 HP, 3 PH	75	6293410	Bakelite
36	6293358	Key, 5 X 5 X 25	76	6293411	Hex Head Screw, 3/8 X 1/2
37	6293383	Motor Label	77	6293212	Hex Nut, 1/2
38	6293384	Key, 4 X 4 X 10	78	6293412	Bolt, 1/2 X 1-3/8
			79	6293331	Pan Head Screw, 5/32 X 1
			80	6293413	Spring Washer, 1/2
			81	6293414	Flat Washer

Conveyor Belt & Table Assembly (1632 Sander)

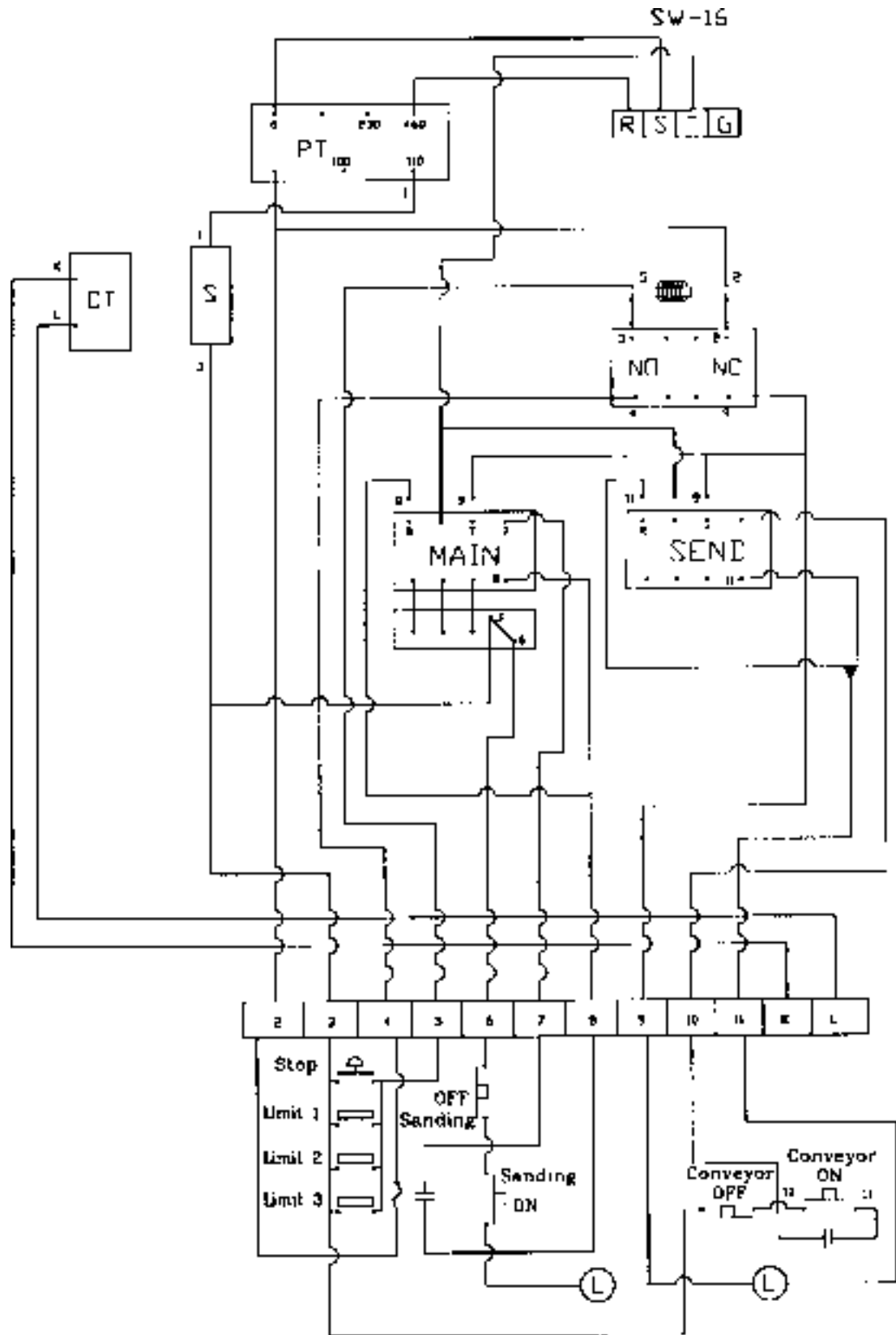


Reduction Motor Assembly (1632 Sander)



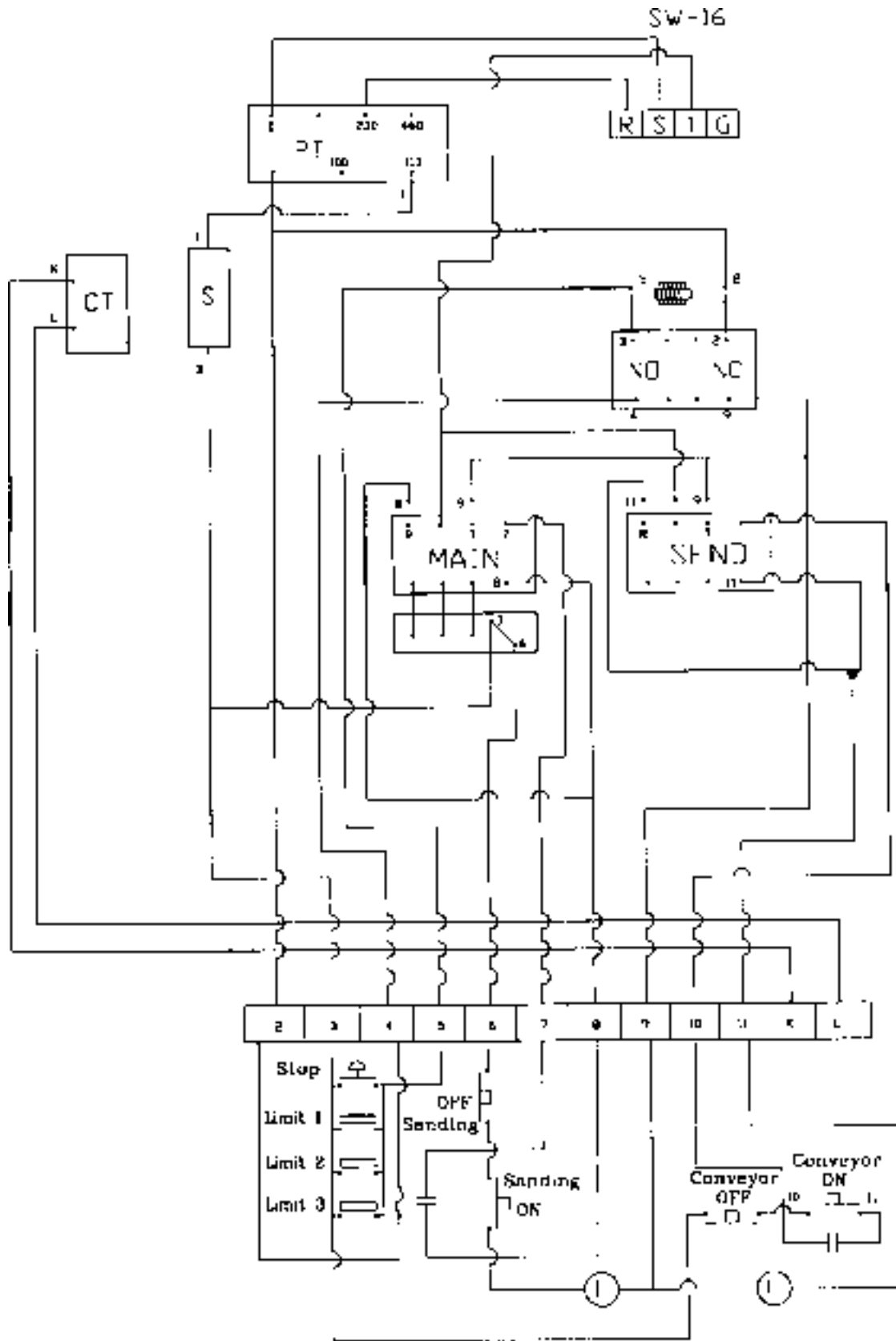
ELECTRICAL SCHEMATIC (1632 Sander)

460V - 3 Phase



ELECTRICAL SCHEMATIC (1632 Sander)

230V - 1 Phase / 3 Phase



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