

POWERMATIC®

WMH TOOL GROUP

Operating Instructions and Parts Manual 16-inch Open-End Belt Sander Model 1632



WMH TOOL GROUP

2420 Vantage Drive
Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com

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

Warranty and Service

WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can provide quick service or information.

In most cases, a WMH Tool Group Service Center can assist in authorizing repair work, obtaining parts, or perform routine or major maintenance repair on your Powermatic product.

For the name of an Authorized Service Center in your area, please call 1-800-274-6848, or visit our web site at www.wmhtoolgroup.com

More Information

Remember, WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit our web site at www.wmhtoolgroup.com

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WMH Tool Group 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 follows: 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 Service Center 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 at our discretion, or refund the purchase price if we cannot readily and quickly provide a repair or replacement. We will return the repaired product or replacement at WMH Tool Group's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH Tool Group'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.

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SAFETY RULES

As with all machines, there is a certain amount of hazard involved with the use of this 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 this machine.

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: Common eye glasses are only impact-resistant, they are *not* safety glasses). Wear protective 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. Be sure the table is free of all scrap, foreign material and tools before starting to cut. 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 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 machine

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 or when changing blades. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.

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. NEVER clean the sander with power "ON" and never use the hands to clear sawdust and debris; use a brush or compressed air.

Replacement parts. Use only Powermatic or factory authorized replacement parts and accessories; otherwise the 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).

SPECIFICATIONS: 1632 Open-End Sander

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 dimensions	17" W x 54" L
Sanding belt speed (SFPM)	2,200
Compressed air requirements at 5 atm (PSI).....	4
Dust collection minimum CFM required.....	800
Dust port 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, 230V only
Net weight.....	996 lbs.
Shipping weight.....	1,106 lbs.

NOTE: The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, WMH Tool Group reserves the right to change specifications without notice and without incurring obligations.

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. Do not use an abrasive pad.

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.
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.

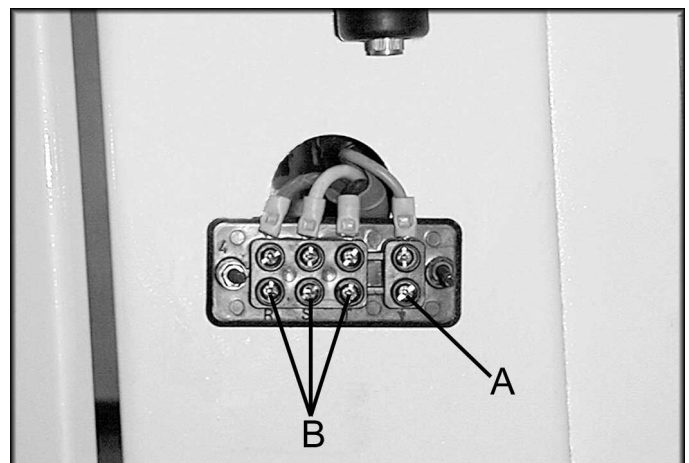


FIGURE 1

- 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

- Attach the infeed and outfeed roller assemblies with sixteen 5/16" x 2" hex. hd. screws and spring washers.
- Mount the side support with two hex cap screws and flat washers.
- Insert the door latches into the slots on the cabinet doors.
- 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.

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:

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

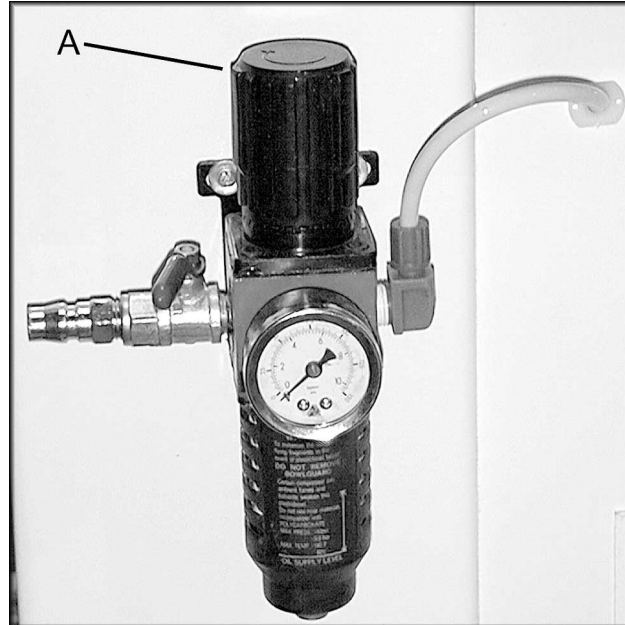


FIGURE 2

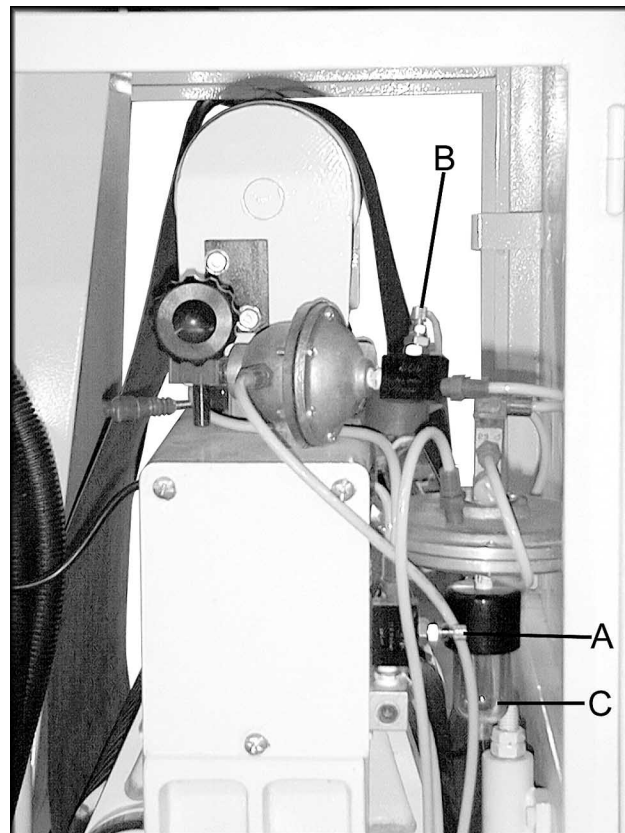


FIGURE 3

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.

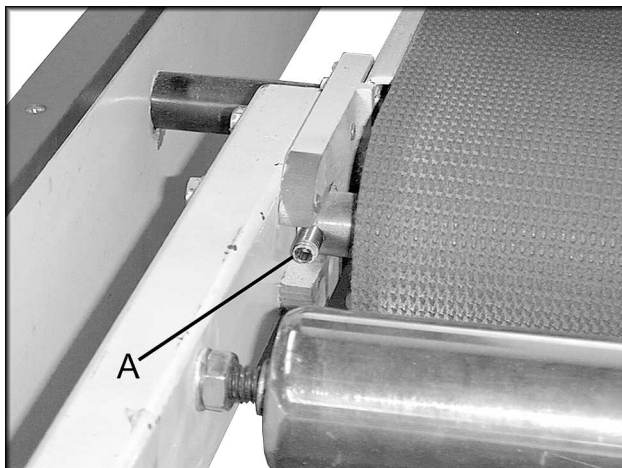


FIGURE 4

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.

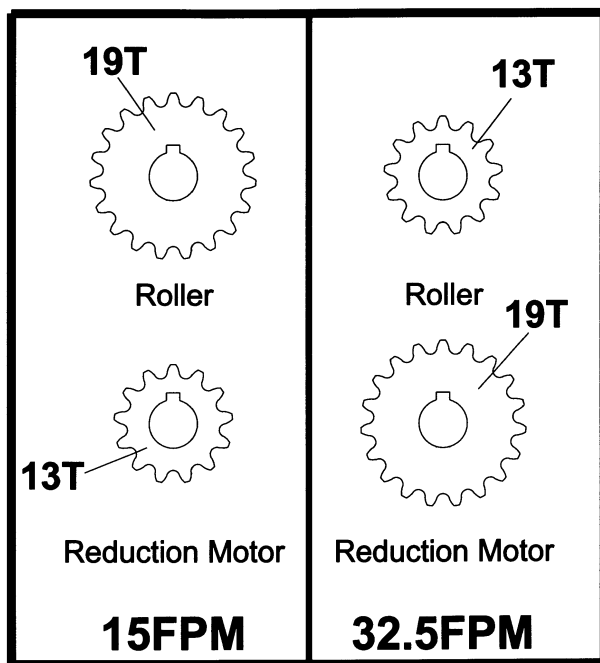


FIGURE 6

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.

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.
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.

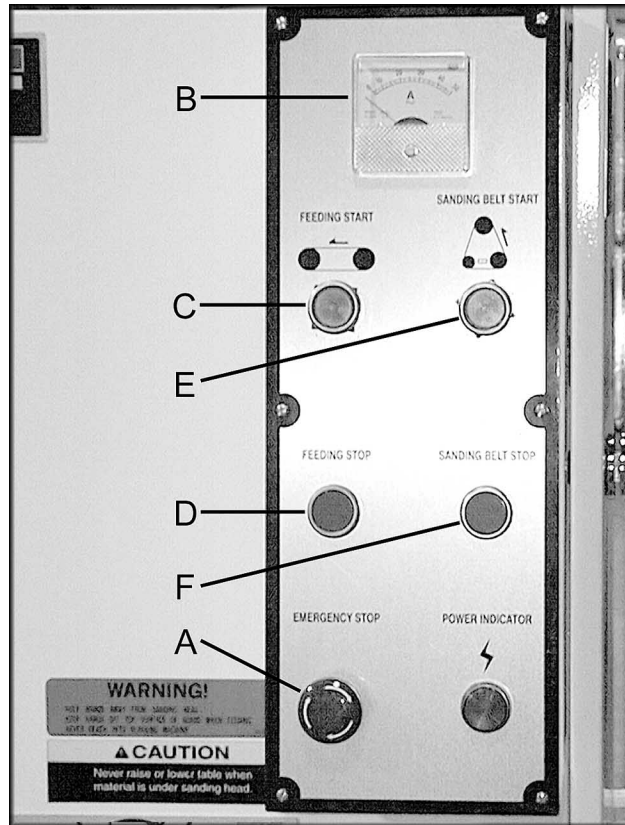


FIGURE 7

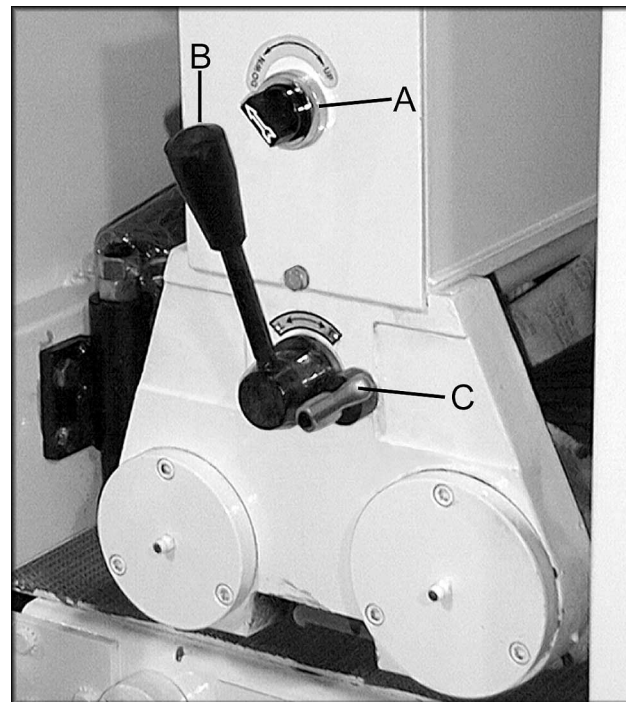


FIGURE 8

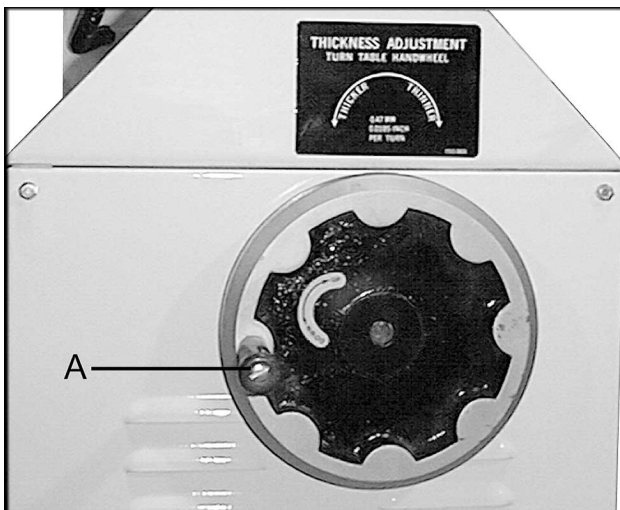


FIGURE 9

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.

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

TROUBLE-SHOOTING for 1632 Open-End Sander

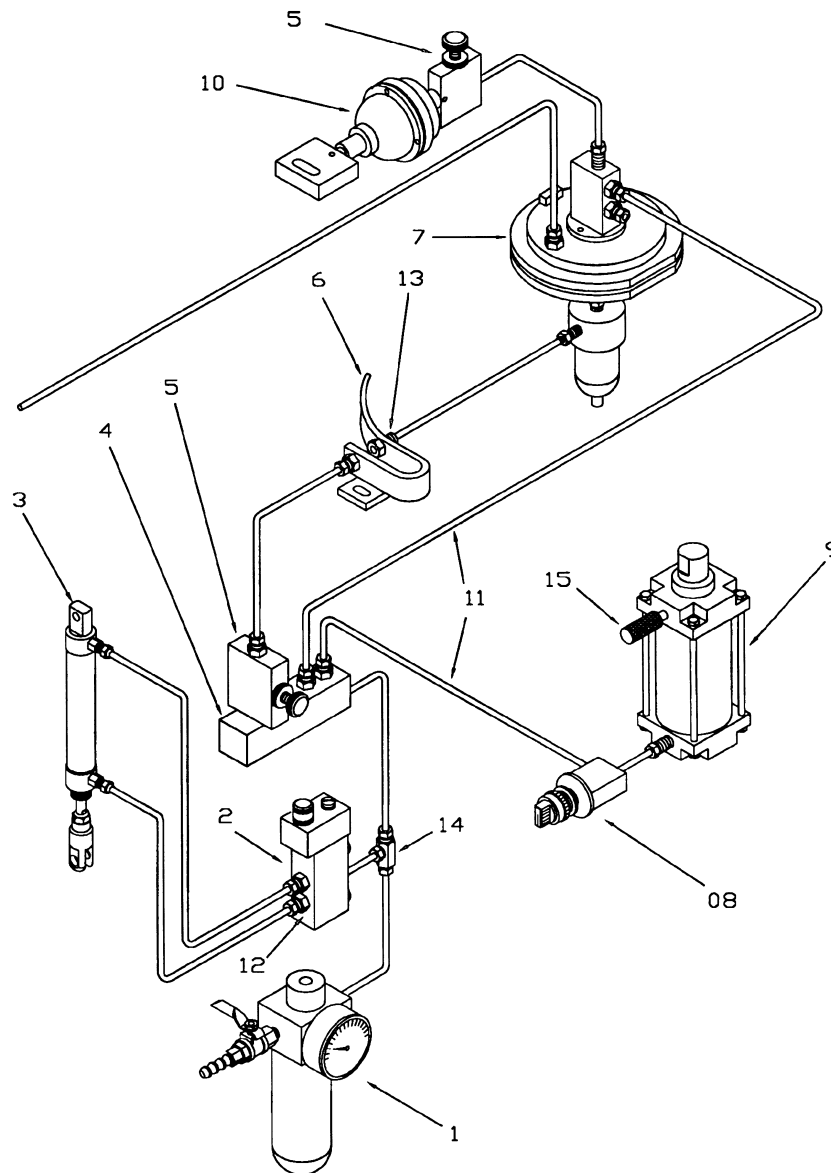
PROBLEM	POSSIBLE CAUSE	SOLUTION
The sanding belt clogs quickly.	<ol style="list-style-type: none">1. Sandpaper grit too small.2. Too much material is being sanded off.3. The wood is too dirty or oily.4. Suction is insufficient.	<ol style="list-style-type: none">1. Use larger grit.2. Reduce sanding depth.3. 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.

Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:30 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

PARTS LIST: Air Control Assembly (1632 Sander)

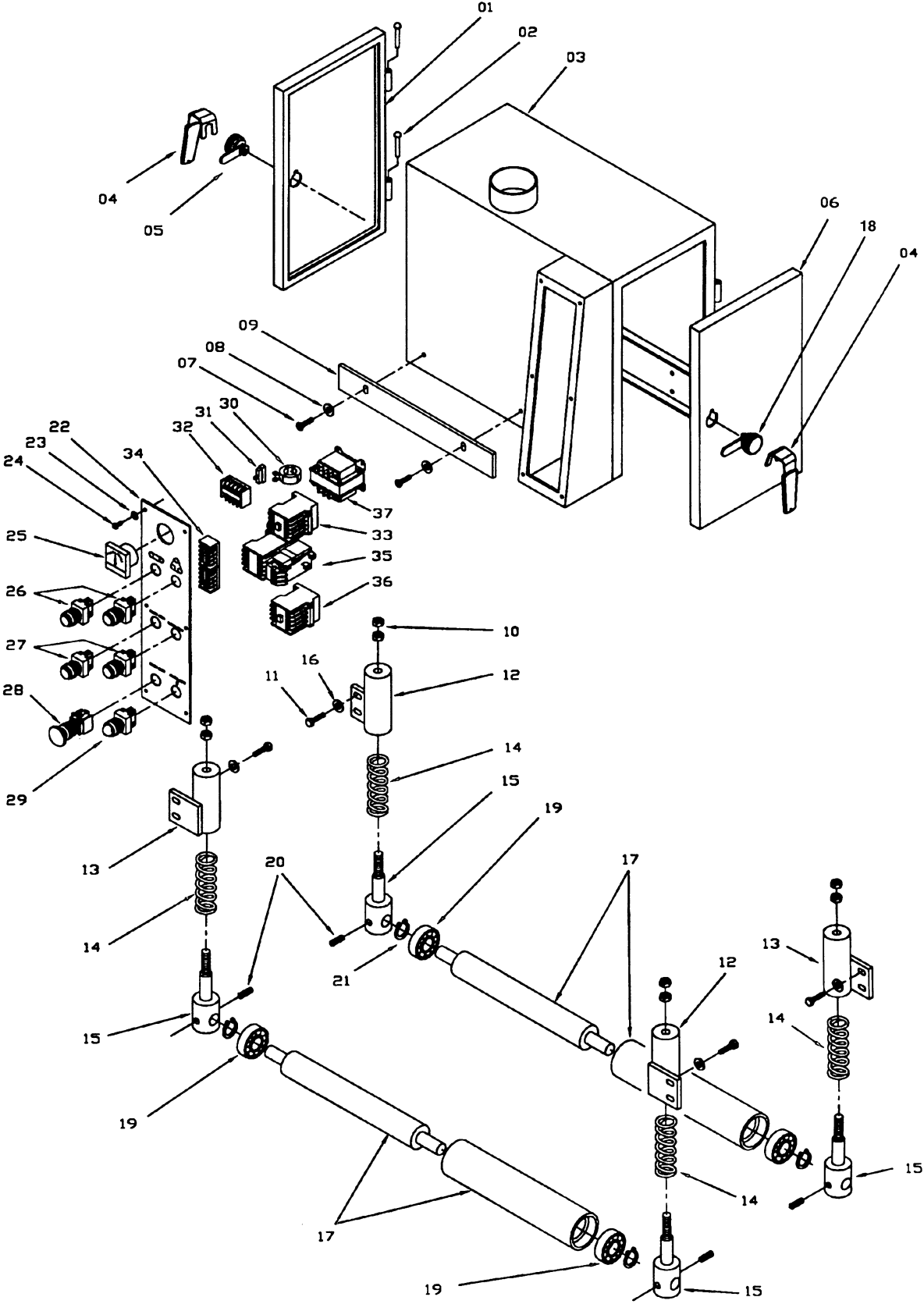
No.	Part No.	Description	Quantity
1	6293482	Filter	1
2	6293483	Solenoid Valve	1
3	6293484	Brake Cylinder	1
4	6293485	Multi-Hole Connector	1
5	6293486	Air Valve.....	1
6	6293487	Air Sensor Assembly.....	1
7	6293488	Air Sensor.....	1
8	6293489	Switching Valve	1
9	6293250	Cylinder	1
10	6293252	Oscillator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



PARTS LIST: Electricity Control & Upper Adj. Roller (1632 Sander)

No.	Part No.	Description	Quantity
1	6293203	Upper Door (L)	1
2	6293204	Pin for Upper Door	2
3	6293205	Upper Cabinet	1
4	6293206	Door Knob	2
5	6293207	Door Latch (L)	1
6	6293208	Upper Door (R).....	1
7	6293209	Pan Head Screw, 1/4 X 1/2.....	2
8	6293210	Flat Washer, 1/4.....	2
9	6293211	Plate	1
10	6293212	Hex Nut, 1/2	8
11	6293213	Hex Head Screw, 3/8 X 3/4	8
12	6293214	Adjust Stand (L)	2
13	6293215	Adjust Stand (R).....	2
14	6293216	Spring	4
15	6293217	Fixed Roller Stand w/ Adjust Bolt	4
16	6293218	Flat Washer, 3/8.....	8
17	6293219	Shaft & Rubber Roller	2
18	6293311	Door Latch (R).....	1
19	6293221	Ball Bearing.....	4
20	6293222	Set Screw, 1/4 X 3/4.....	4
21	6293223	Ring	4
22	6293224	Control Plate	1
23	6293225	Gear Washer, 3/16.....	6
24	6293226	Pan Head Screw, 3/16 X 3/8.....	6
25	6293227	Amp Meter	1
26	6293228	Feed Start Switch.....	1
	6293228	Sanding Belt Start Switch	1
27	6293229	Feed Stop Switch	1
	6293229	Sanding Belt Stop Switch	1
28	6293230	Stop Switch	1
29	6293231	Power Indicator Light.....	1
30	6293232	Current Coil.....	1
31	6293233	Fuse Stand, 5 HP	1
	6293312	Fuse Stand, 7-1/2 HP	1
32	6293234	Terminal Strip, 5 HP.....	1
	6293313	Terminal Strip, 7-1/2 HP	1
33	1632-233	Relay, 5 HP	1
	6293314	Relay, 7-1/2 HP.....	1
34	6293236	Terminal Strip, 5 HP.....	1
	6293315	Terminal Strip, 7-1/2 HP	1
35	1632-235	Overload Relay, 5 HP	1
	6293316	Overload Relay, 7-1/2 HP	1
36	1632-236	Relay, 5 HP	1
	6293317	Relay, 7-1/2 HP.....	1
37	6293239	Transformer, 5 HP.....	1
	6293318	Transformer, 7-1/2 HP.....	1

Electricity Control & Upper Adj. Roller (1632 Sander)



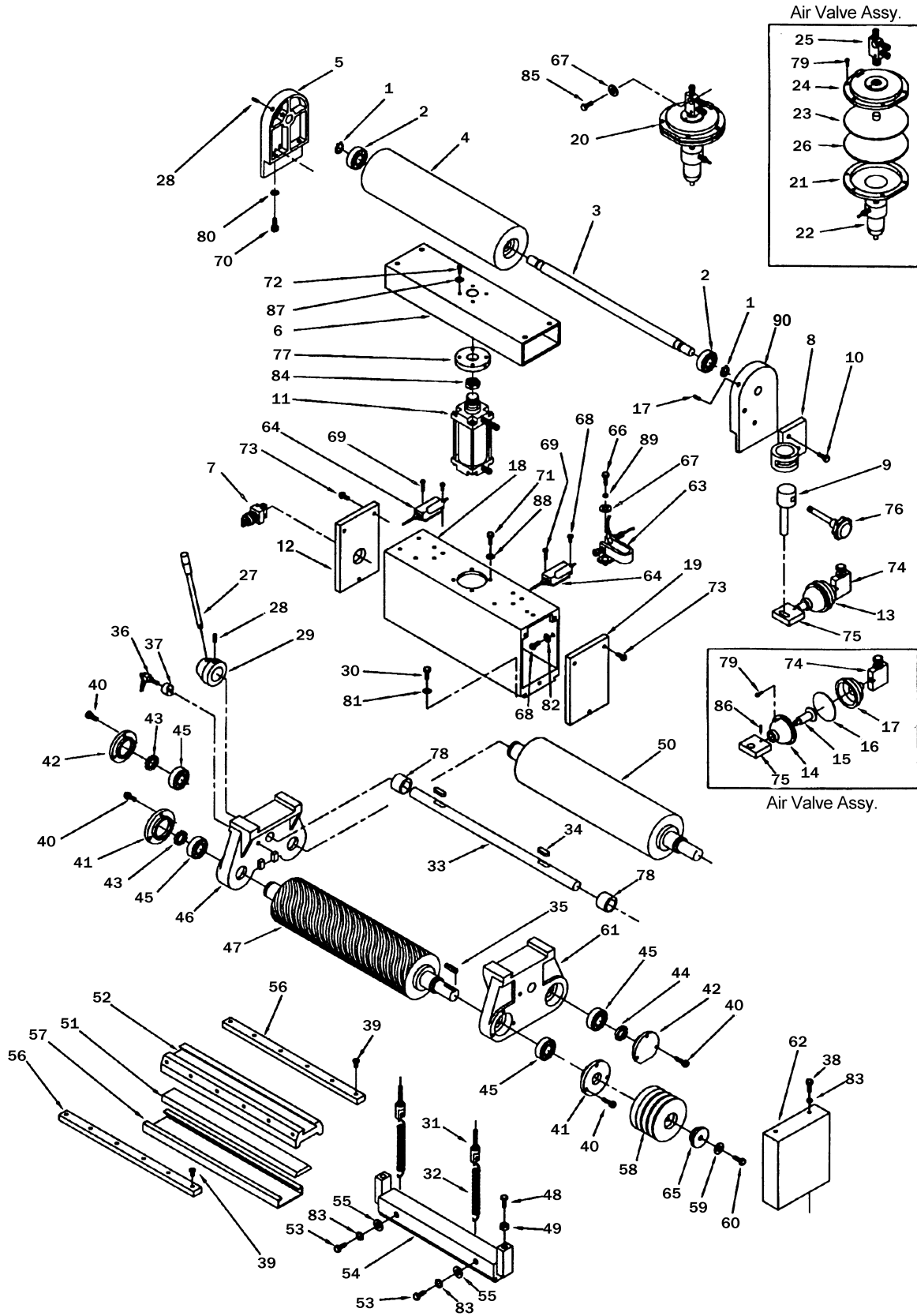
PARTS LIST: Sanding Drum Assembly (1632 Sander)

No.	Part No.	Description	Quantity
1	6293240	Ring	2
2	6293241	Ball Bearing.....	2
3	6293242	Shaft	1
4	6293243	Upper Roller.....	1
5	6293244	Upper Roller Base (L).....	1
6	6293245	Column	1
7	6293246	Switch Valve	1
8	6293247	Eccentric Shaft Base.....	1
9	6293248	Eccentric Shaft.....	1
10	6293249	Hex Head Screw, 5/16 X 1/2.....	2
11	6293250	Air Cylinder Assembly	1
12	6293251	Cover (L).....	1
13	6293252	Air Oscillator Cylinder.....	1
	6293496	Air Valve Assembly (Items 14 thru 17, 74, 75, 79 & 86).....	1
14	6293253	Front Cover.....	1
15	6293254	Oscillator Shaft.....	1
16	6293255	Membrane.....	1
17	6293256	Rear Cover.....	1
18	6293257	Column	1
19	6293258	Cover (R)	1
20	6293259	Air Sensor	1
	6293497	Air Valve Assembly (Items 21 thru 26 & 79)	1
21	6293260	Lower Cover.....	1
22	6293261	Air Sensor Substance.....	1
23	6293262	Piston.....	1
24	6293263	Upper Cover.....	1
25	6293264	Plastic Joint Assembly.....	1
26	6293265	Membrane.....	1
27	6293266	Handle Assembly	1
28	6293267	Set Screw, 1/4 X 1/4.....	1
29	6293268	Handle Hub	1
30	6293269	Hex Head Screw, 3/8 X 1-1/4	4
31	6293270	Adjust Bolt, 3/8 X 1-1/4.....	2
32	6293271	Spring	2
33	6293272	Shaft	1
34	6293273	Key, 5 X 5 X 30	2
35	6293274	Key, 8 X 8 X 40	1
36	6293275	Lock Handle	1
37	6293276	Knob	1
38	6293277	Hex Head Screw, 3/8 X 1-1/2	2
39	6293278	Pan Head Screw, 5/32 X 3/8.....	6
40	6293279	Hex Socket Cap Screw, 1/4 X 1/2.....	12
41	6293280	Bearing Cover	2
42	6293281	Bearing Cover (L).....	1
	6293282	Bearing Cover (R)	1
43	6293283	Lock Nut (counter-clockwise).....	2
44	6293284	Lock Nut (clockwise).....	1
45	6293285	Ball Bearing.....	4
46	6293286	Round Bearing Frame	1
47	6293287	Main Rubber Roller	1
48	6293288	Hex Head Screw, 5/16 X 1-3/4	2
49	6293289	Hex Nut, 5/16	2
50	6293290	Back Steel Roller.....	1
51	6293291	Blanket.....	1
52	6293292	Pad Slider	1
53	6293293	Hex Head Screw, 3/8 X 1	2

PARTS LIST: Sanding Drum Assembly (1632 Sander) continued

No.	Part No.	Description	Quantity
54	6293294	Pad.....	1
55	6293218	Flat Washer, 3/8.....	2
56	6293295	Pressing Bar.....	2
57	6293296	Graphite Canvas.....	1
58	6293297	Pulley (5 HP).....	1
	6293298	Pulley (7-1/2 HP).....	1
59	6293299	Flat Washer, 5/16.....	1
60	6293300	Hex Head Screw, 5/16 X 1.....	1
61	6293301	Rectangular Bearing Base.....	1
62	6293302	Cover.....	1
63	6293303	Air Sensor Assembly.....	1
64	6293304	Limit Switch.....	2
65	6293305	Disk.....	1
66	6293306	Hex Head Screw, 1/4 X 3/8.....	1
67	6293210	Flat Washer, 1/4.....	1
68	6293330	Pan Head Screw, 5/32 X 1/2.....	2
69	6293331	Pan Head Screw, 5/32 X 1.....	2
70	6293332	Hex Head Screw, 5/16 X 2.....	4
71	6293333	Cap Screw, M8 X 20.....	4
72	6293334	Hex Head Screw, 1/4 X 2.....	4
73	6293209	Pan Head Screw, 1/4 X 1/2.....	6
74	6293335	Air Valve.....	1
75	6293336	Block Connector.....	1
76	6293337	Knob.....	1
77	6293338	Cylinder Disk.....	1
78	6293339	Eccentric Roller.....	2
79	6293340	Pan Head Screw, 3/16 X 5/8.....	8
80	6293341	Gear Washer, 5/16.....	4
81	6293342	Gear Washer, 3/8.....	4
82	6293343	Flat Washer, 5/32.....	1
83	6293344	Spring Washer, 3/8.....	2
84	6293345	Hex Nut.....	1
85	6293346	Hex Head Screw, 1/4 X 1/2.....	1
86	6293347	Spring Pin, 3 X 16.....	1
87	6293348	Gear Washer, 1/4.....	4
88	6293349	Gear Washer, M8.....	4
89	6293350	Spring Washer, 1/4.....	1
90	6293501	Upper Roller Base (R).....	1

Sanding Drum Assembly (1632 Sander)



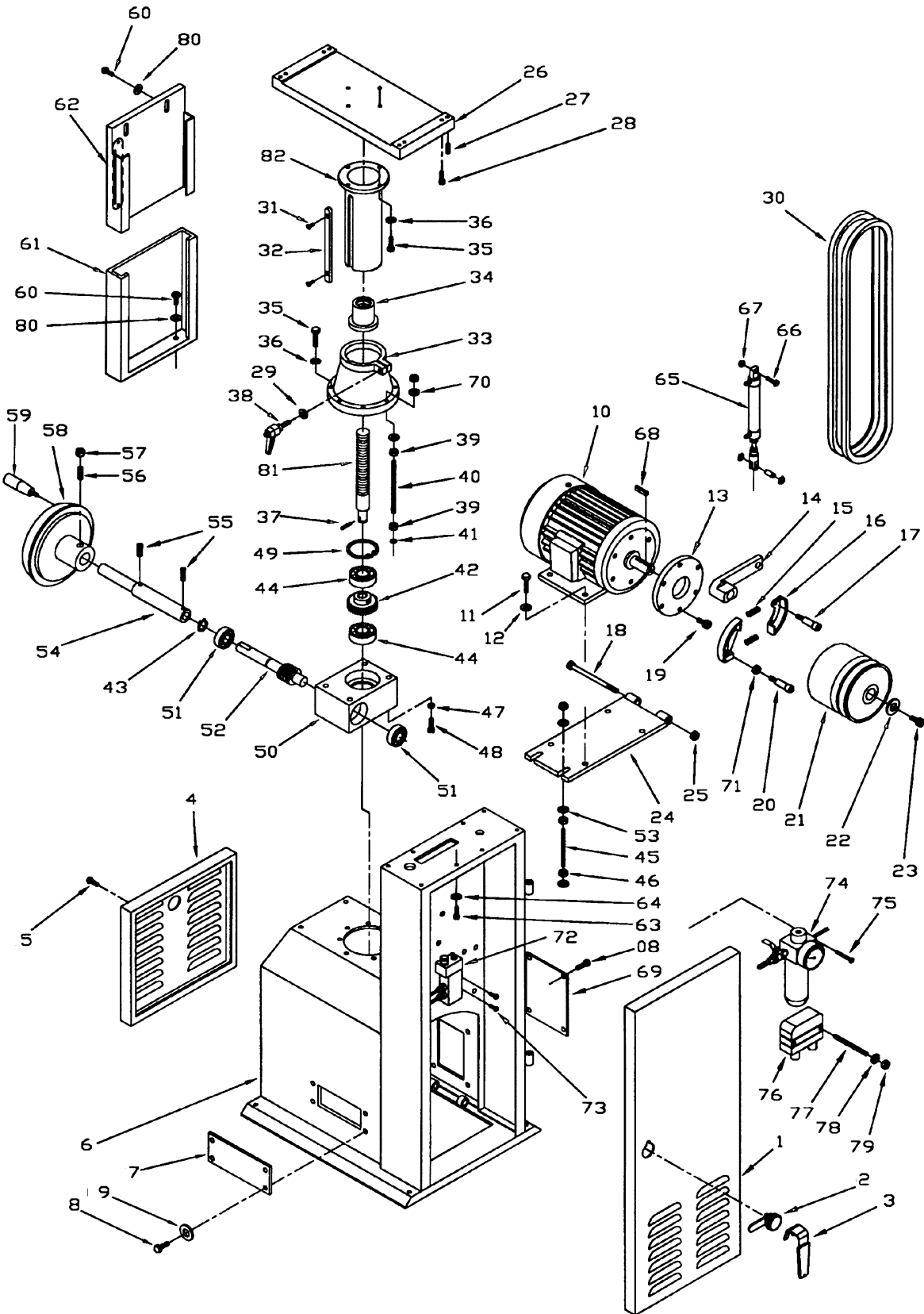
PARTS LIST: Base & Table Adjust Assembly (1632 Sander)

No.	Part No.	Description	Quantity
1	6293240	Ring.....	2
1	6293415	Door	1
2	6293416	Crosspiece.....	1
3	6293417	Door Knob	1
4	6293418	Cover.....	1
5	6293419	Hex Head Screw, 1/4 X 1.....	4
6	6293420	Base	1
7	6293421	Cover.....	1
8	6293422	Hex Head Screw, 3/16 X 3/8.....	4
9	6293423	Flat Washer, 3/16	4
10	1632-410	Motor (5 HP, 1 PH)	1
	6293425	Motor (7-1/2 HP, 3 PH)	1
11	6293293	Hex Head Screw, 3/8 X 1	4
12	6293426	Lock Washer, 3/8.....	4
13	6293427	Brake Base	1
14	6293428	Brake Pole.....	1
15	6293429	Brake Spring.....	2
16	6293430	Brake.....	2
17	6293431	Bolt, 5/16 X 1-1/2.....	1
18	6293432	Bolt, 1/2	1
19	6293433	Socket Head Screw, 5/16 X 1/2.....	6
20	6293434	Bolt, 3/8 X 1-1/2.....	1
21	1632-421	Pulley (5 HP)	1
	6293436	Pulley (7-1/2 HP)	1
22	6293210	Flat Washer, 1/4	1
23	6293437	Hex Head Screw, 1/4 X 1	1
24	1632-424	Motor Plate (5 HP).....	1
	6293439	Motor Plate (7-1/2 HP).....	1
25	6293212	Hex Nut, 1/2	1
26	6293440	Base	1
27	6293441	Set Screw, 5/16 X 1	4
28	6293442	Hex Socket Cap Screw, 5/16 X 1-1/2	4
29	6293299	Flat Washer, 5/16	1
30	1632-430	Belt, A-84.....	2
31	6293444	Flat Head Screw, 1/4 X 1/2	2
32	6293445	Key, 19 X 3/8 X 270	1
33	6293446	Base Lifting Pipe.....	1
34	6293447	Cap Screw, 3/4	1
35	6293249	Hex Head Screw, 5/16 X 1/2	4
36	6293341	Gear Washer, 5/16	4
37	6293448	Spring Pin, 5 X 25.....	1
38	6293449	Lock Handle.....	1
39	6293450	Hex Nut, 1/4	2
40	6293451	Bolt, 1/4 X 290mm	1
41	6293452	Lock Washer, 1/4.....	1
42	6293453	Gear	1
43	6293454	Ring.....	1
44	6293455	Ball Bearing.....	2
45	6293456	Bolt, 3/8 X 4.....	2
46	6293457	Hex Nut, 3/8	6
47	6293218	Flat Washer, 3/8	4
48	6293458	Hex Head Screw, 3/8 X 1-3/4.....	4
49	6293459	Ring.....	1
50	6293460	Gear Box	1
51	6293461	Ball Bearing.....	2
52	6293462	Worm Gear.....	1

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

No.	Part No.	Description	Quantity
53	6293218	Flat Washer, 3/8.....	4
54	6293463	Shaft	1
55	6293267	Set Screw, 1/4 X 1/4.....	2
56	6293464	Set Screw, 1/4 X 1.....	1
57	6293450	Hex Nut, 1/4.....	1
58	6293465	Wheel, 8"	1
59	6293466	Handle	1
60	6293209	Pan Head Screw, 1/4 X 1/2.....	2
61	6293467	Lower Guard	1
62	6293468	Upper Guard	1
63	6293277	Hex Head Screw, 3/8 X 1-1/2	8
64	6293342	Gear Washer, 3/8.....	8
65	6293469	Air Cylinder Assembly	1
66	6293300	Hex Head Screw, 5/16 X 1	2
67	6293289	Hex Nut, 5/16".....	2
68	6293470	Key (7-1/2 HP), 10 X 8 X 60	1
	6293471	Key (5 HP)	1
69	6293472	Cover	1
70	6293210	Flat Washer 1/4.....	2
71	6293457	Hex Nut, 3/8.....	1
72	6293473	Solenoid Valve	1
73	6293331	Pan Head Screw, 5/32 X 1.....	2
74	6293474	Filter.....	1
75	6293475	Pan Head Screw, 5/32 X 1-3/8.....	1
76	6293476	Hookup Box	1
77	6293477	Screw, 3/16 X 1-3/8.....	2
78	6293478	Flat Washer, 3/16.....	2
79	6293479	Hex Nut 3/16	2
80	6293210	Flat Washer, 1/4.....	4
81	6293480	Screw Lead, 3/4	1
82	6293481	Lifting Pipe	1

Base & Table Adjust Assembly (1632 Sander)



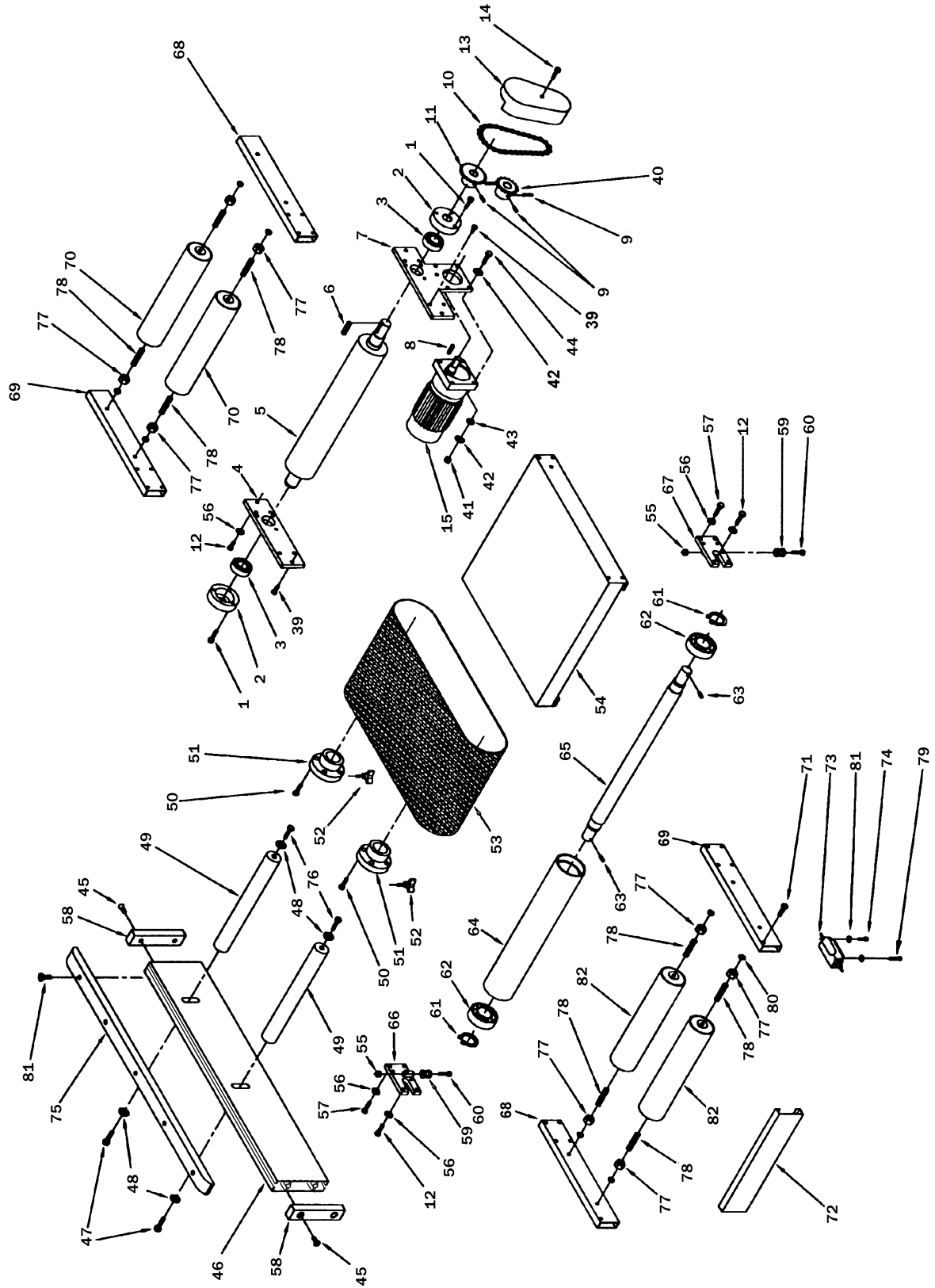
PARTS LIST: Conveyor Belt & Table; Reduction Motor (1632 Sander)

No.	Part No.	Description	Quantity
1	6293351	Hex Socket Cap Screw, 1/4 X 1/4.....	6
2	6293352	Bearing Cover	2
3	6293353	Ball Bearing.....	2
4	6293354	Back Conveyor Roller Base (L)	1
5	6293355	Roller	1
6	6293356	Key, 6 X 6 X 20	1
7	6293357	Back Conveyor Roller & Motor Base	1
8	6293358	Key, 5 X 5 X 25	1
9	6293267	Set Screw, 1/4 X 1/4.....	4
10	6293359	Chain	1
11	6293360	Sprocket.....	1
12	6293332	Hex Head Screw, 5/16 X 2	5
13	6293361	Cover.....	1
14	6293362	Hex Socket Cap Screw, 1/4 X 2.....	1
15	6293495	Reduction Motor Assembly, 1 Ph (Items 16 thru 38)	1
	6293498	Reduction Motor Assembly, 3 Ph (Items 16 thru 38)	1
16	6293363	Body.....	1
17	6293364	Gear B, 40T	1
18	6293365	Gear A, 19T	1
19	6293366	Ball Bearing.....	4
20	6293367	Gear B, 47T	1
21	6293368	Gear C, 14T	1
22	6293369	Output Shaft.....	1
23	6293370	Key, 5 X 5 X 10	1
24	6293371	Gear D, 46T	1
25	6293372	Washer	1
26	6293373	Ball Bearing.....	1
27	6293374	Oil Seal, 20, 35, 7	1
28	6293375	Rear Cover.....	1
29	6293376	Oil Seal, 12, 22, 5	1
30	6293377	Needle Bearing, 1012.....	1
31	6293378	Washer	1
32	6293379	O-Ring	1
33	6293380	Fixing Screw	3
34	6293381	Gear A, 8T	1
35	6293382	Motor, 1/4 HP, 1 PH.....	1
	6293220	Motor, 1/4 HP, 3 PH.....	1
36	6293358	Key, 5 X 5 X 25	1
37	6293383	Motor Label	1
38	6293384	Key, 4 X 4 X 10	2
39	6293385	Hex Head Screw, 5/16 X 3/8.....	6
40	6293386	Sprocket.....	1
41	6293289	Hex Nut, 5/16	4
42	6293341	Gear Washer, 5/16.....	8
43	6293299	Flat Washer, 5/16.....	8
44	6293249	Hex Head Screw, 5/16 X 1/2.....	4
45	6293387	Flat Head Screw, 5/32 X 1	4
46	6293388	Stop Plate	1
47	6293277	Hex Head Screw, 3/8 X 1-1/2	2
48	6293218	Flat Washer, 3/8.....	4
49	6293389	Shaft	2
50	6293331	Pan Head Screw, 5/32 X 1.....	8
51	6293390	Shaft Base	2
52	6293391	Wing Screw, 1/4 X 1/2.....	2
53	6293392	Conveyor Belt	1
54	6293393	Working Table.....	1

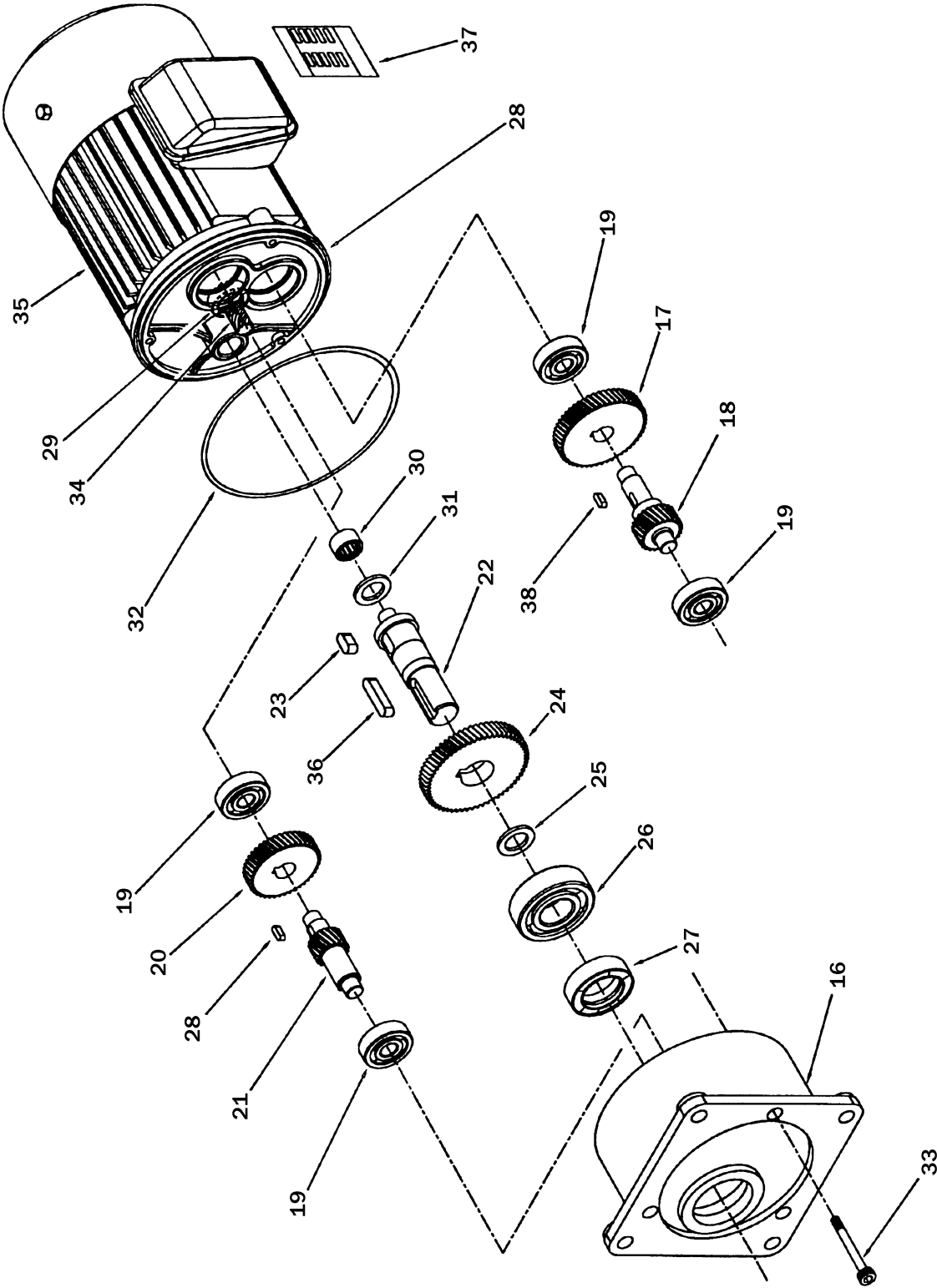
PARTS LIST: Conveyor Belt & Table; Reduction Motor (1632 Sander) continued

No.	Part No.	Description	Quantity
55	6293289	Hex Nut, 5/16.....	2
56	6293394	Spring Washer, 5/16.....	8
57	6293300	Hex Head Screw, 5/16 X 1.....	8
58	6293395	Stop Plate Annex.....	2
59	6293396	PVC Roller.....	2
60	6293397	Hex Head Screw, 5/16 X 1-1/2.....	2
61	6293398	Ring.....	2
62	6293241	Ball Bearing.....	2
63	6293399	Adjust Bolt, 3/8 X 1-1/2.....	2
64	6293400	Roller.....	1
65	6293401	Shaft.....	1
66	6293402	Roller Base (L).....	1
67	6293403	Roller Base (R).....	1
68	6293404	Roller Frame (L).....	2
69	6293405	Roller Frame (R).....	2
70	6293406	Roller.....	2
71	6293407	Pan Head Screw, 5/32 X 1-3/4.....	2
72	6293408	Front Plate.....	1
73	6293409	Limit Switch.....	1
74	6293330	Pan Head Screw, 5/32 X 1/2.....	1
75	6293410	Bakelite.....	1
76	6293411	Hex Head Screw, 3/8 X 1/2.....	2
77	6293212	Hex Nut, 1/2.....	8
78	6293412	Bolt, 1/2 X 1-3/8.....	8
79	6293331	Pan Head Screw, 5/32 X 1.....	1
80	6293413	Spring Washer, 1/2.....	8
81	6293414	Flat Washer.....	5
82	6293500	Roller.....	2

Conveyor Belt & Table (1632 Sander)

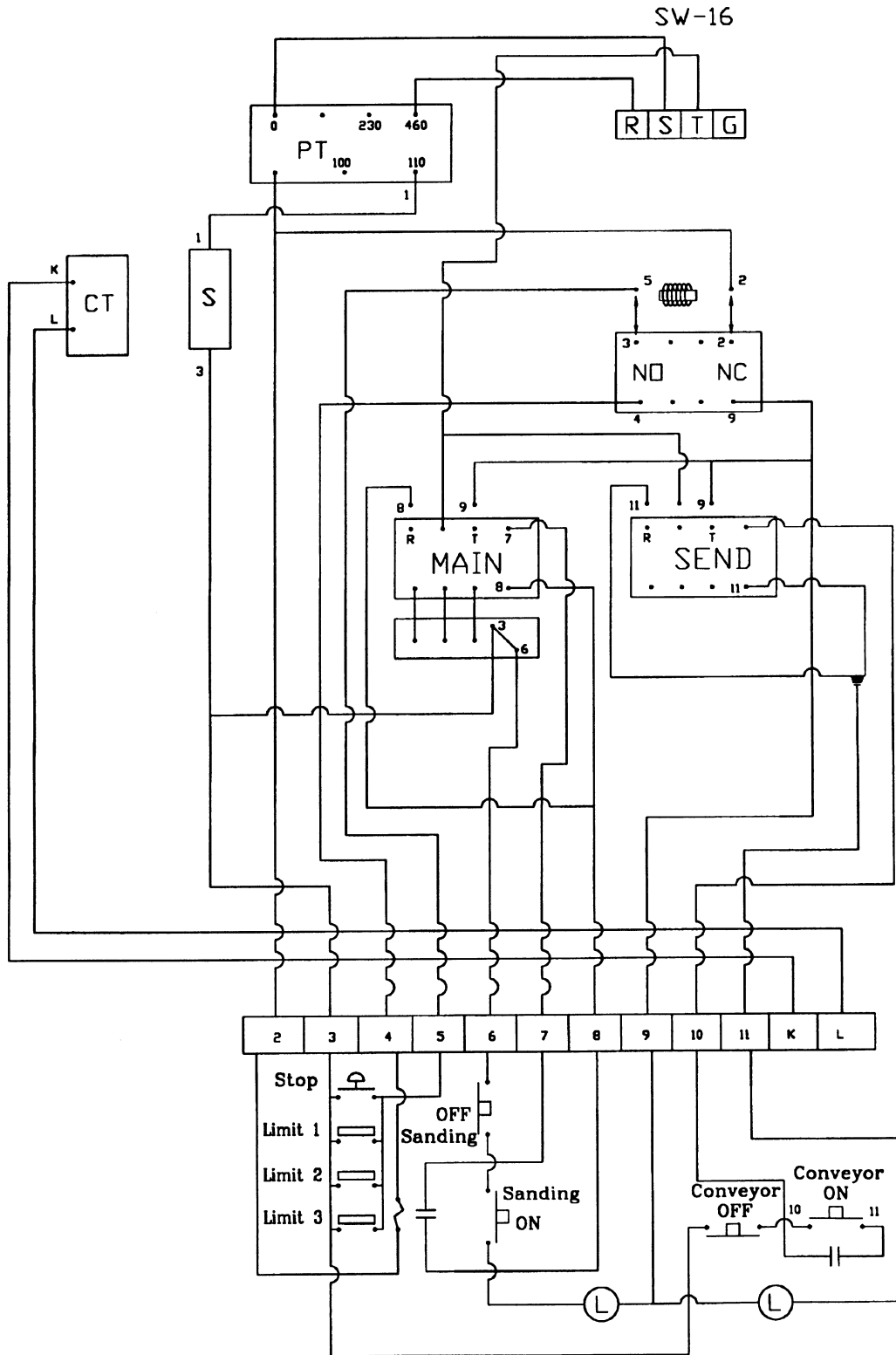


Reduction Motor (1632 Sander)



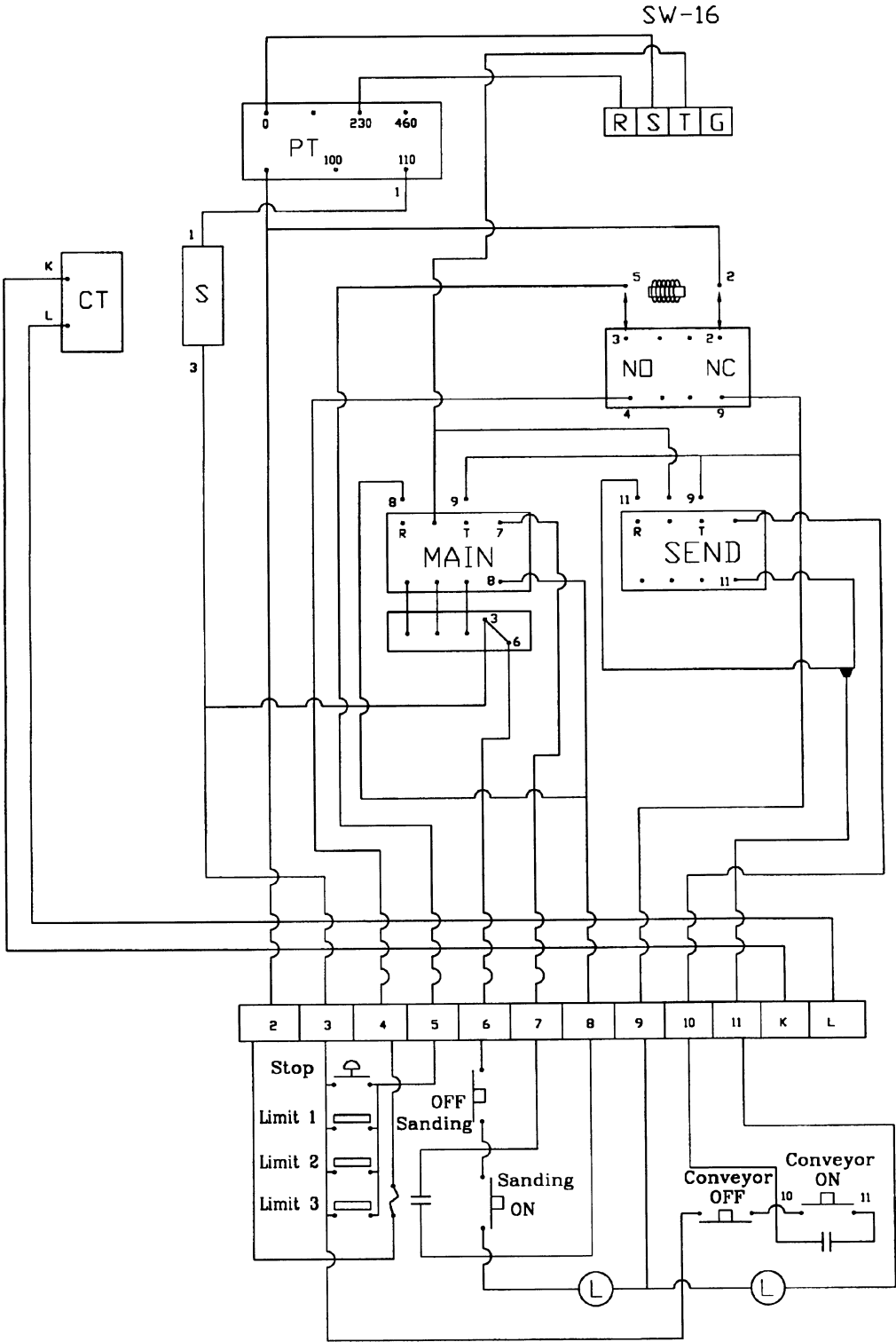
ELECTRICAL SCHEMATIC (1632 Sander)

460V – 3 Phase



ELECTRICAL SCHEMATIC (1632 Sander)

230V – 1 Phase / 3 Phase



POWERMATIC[®]

WMH Tool Group
2420 Vantage Drive
Elgin, Illinois 60123
Phone: 800-274-6848
www.wmhtoolgroup.com