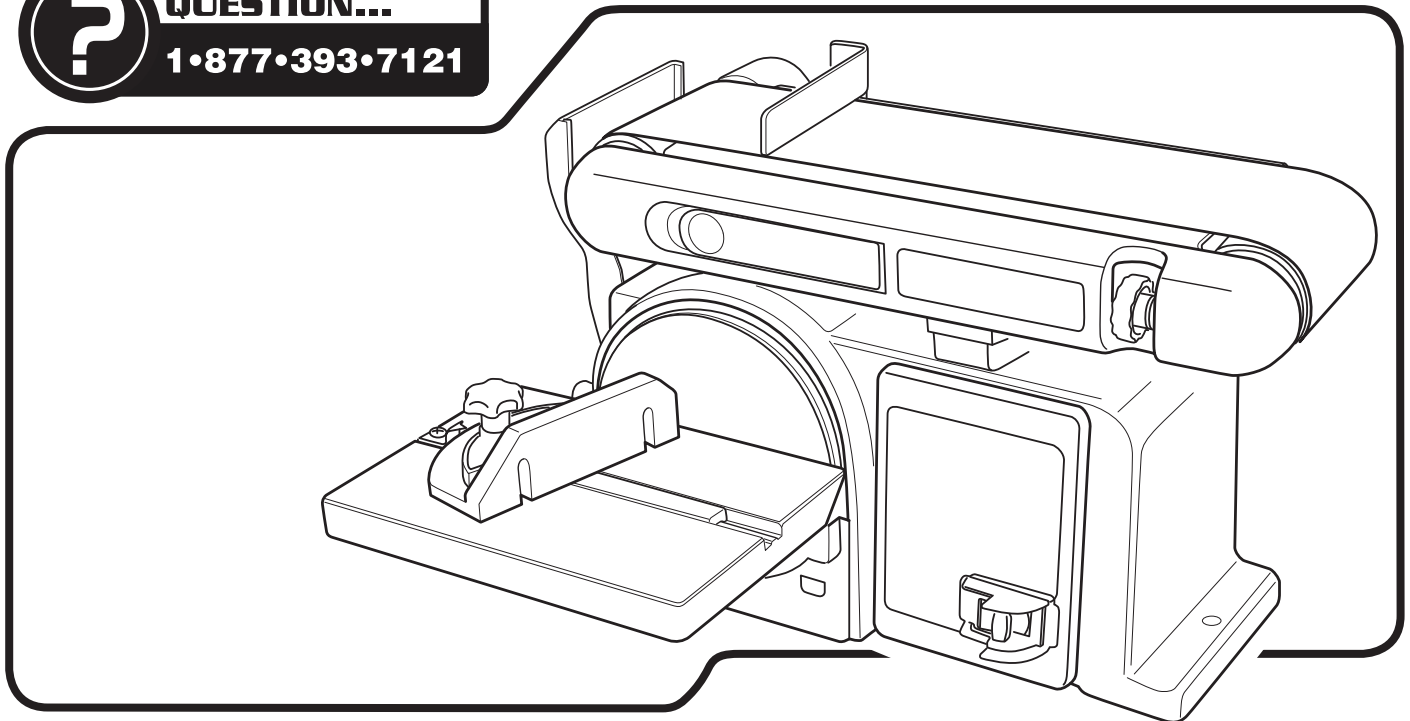


Owner's Manual

POWERTEC®

4" x 6" Belt/Disc SANDER



Visit us on the web at www.southerntechllc.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	1/2
Voltage	120
Amp	4.3
Hertz	60
Phase	Single
RPM	3600
Belt Size	4" x 36"
Belt speed	1900 SFM
Belt Grit	A80
Table Dimensions	6-1/2" x 8-3/4"
Table Tilts	0 to 90°
Disc Diameter	6"
Disc Speed	3600 RPM
Disc Grit	A80 PSA Type (Pressure Sensitive Adhesive)
Dust Port Diameter	2-1/4"
Base Dimensions	10" x 17"
Net Weight	.38 lb

WARNING

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

WARNING

Some dust created by operation of power tool contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. 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.
- 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 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.



2

ASSEMBLY

UNPACKING

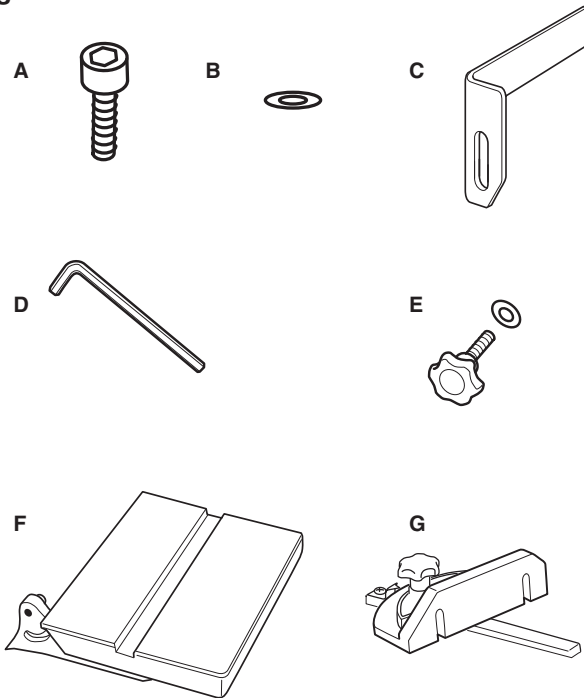
Refer to Figure 1.

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	Socket Head Screws	2
B	Washer	2
C	Work Support	1
D	Hex Wrench 6 mm	1
E	Adjustment Knob and Washer	1
F	Work Table	1
G	Miter Gauge	1

Figure 1



WARNING

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

TOOLS NEEDED

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

- 10 mm wrench
- 6 mm hex wrench (supplied)
- Combination square
- Phillips screwdriver

MOUNT THE WORK TABLE

Refer to Figure 2

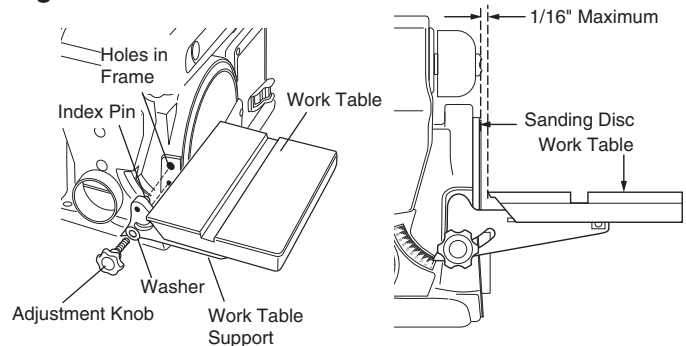
- Position the work table horizontal to the sanding disc and insert the index pins into the work table pivot holes in frame. Secure in place with adjustment knob and washer as shown.
- Maximum distance between the work table and sanding disc should be $1/16"$. To adjust, loosen the three bolts securing the work table to the work table support. Adjust the work table in or out to the $1/16"$. Tighten three bolts securely.

NOTE: Work table will need to be adjusted each time the work table is tilted.

WARNING

To prevent trapping the workpiece or fingers between the table and the sanding disc adjust the work table to a maximum of $1/16"$ from the sanding disc

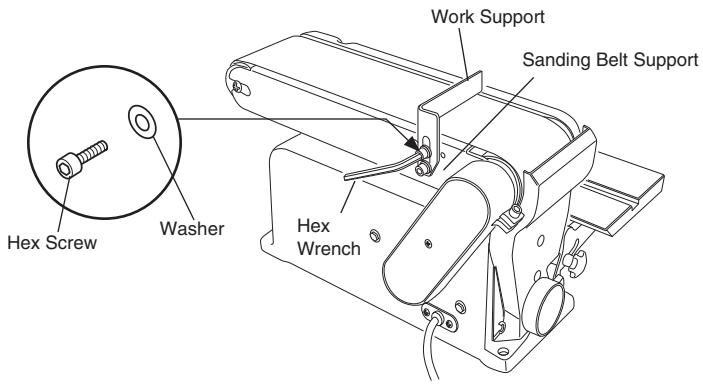
Figure 2



MOUNT THE WORK SUPPORT

Refer to Figure 3

- Secure the work support to the sanding belt support with the hex screws and washers supplied.
- The work support height must be adjusted to avoid contact with the sanding belt. Adjust work support and tightening hex screws.

Figure 3

MOUNTING THE SANDER TO WORK SURFACE

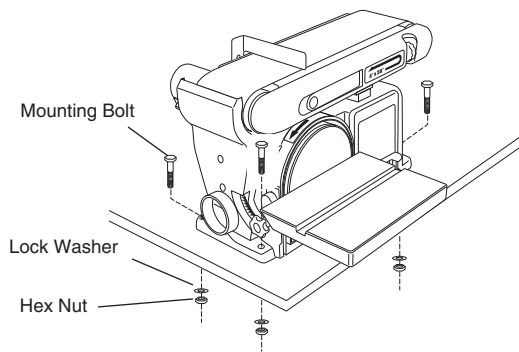
Refer to Figure 4

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.

- 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, locking 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.

Figure 4

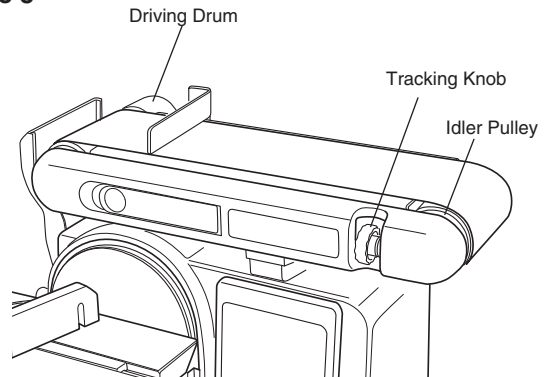
SANDING BELT TRACKING ADJUSTMENT

Refer to Figure 5

- Plug the power cord into the correct receptacle. (Refer to **Power Source** paragraph in this section of the manual.)
- To check tracking adjustment, turn the ON/OFF switch ON and OFF. Ensure the sanding belt is correctly centered and not sliding off the idler pulley and driving drum.

To adjust:

- Turn the tracking knob clockwise to move the sanding belt away from the disc.
 - Turn the tracking knob counterclockwise to move the sanding belt toward from the disc.
- Turn the switch ON and OFF again to check the adjustment; readjust the tracking knob if necessary.

Figure 5

SANDING BELT BED POSTIONS

Refer to Figure 18 and 19

The sanding bed can be adjusted to any horizontal or vertical position. For more informations refer to **Belt Sanding- Horizontal or Vertical Sanding** under **Operation**.

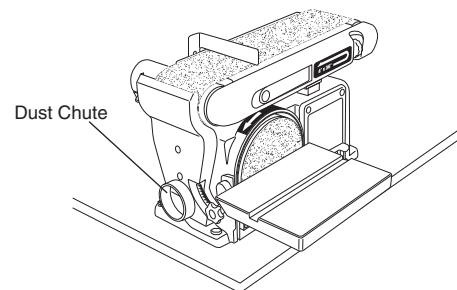
DUST PORT OPTIONS

Refer to Figure 6

The dust port 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 a 2-1/4" dust chute 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 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 6

SQUARE THE TABLE

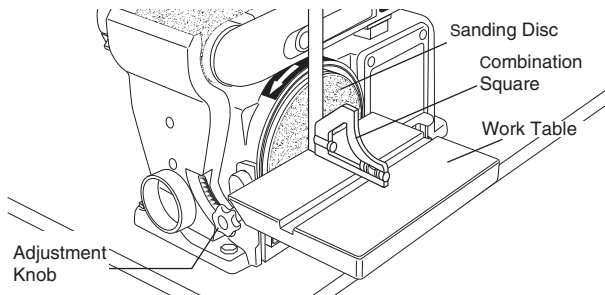
Refer to Figure 7

To ensure accurate end sanding, the work table must be square to the sanding surfaces prior to using the work table for disc sanding.

To check:

- Place combination 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 adjustment knob and tilt table up and down until it is 90° to the sanding disc. Tighten adjustment knob securely. Recheck adjustment using the combination square.

Figure 7



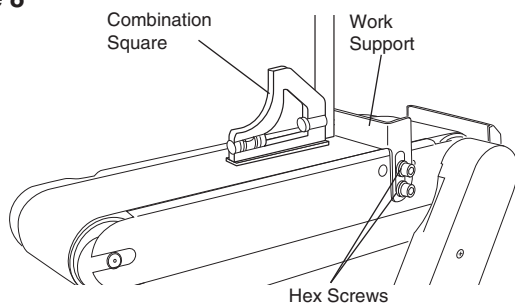
SQUARE THE WORK SUPPORT

Refer to Figure 8

When using the sander belt in the horizontal position the work support must be square to the sanding belt to prevent the workpiece from being carried along the belt.

- Ensure the belt is tight and belt tension lever is closed. Refer to **Adjust The Drive Belt** paragraph under **Maintenance**.
- Place the combination square on the belt with the ruler against the work support.
- Loosen the two hex screws securing the work support. Adjust the work support to the square and tighten the hex screws.

Figure 8



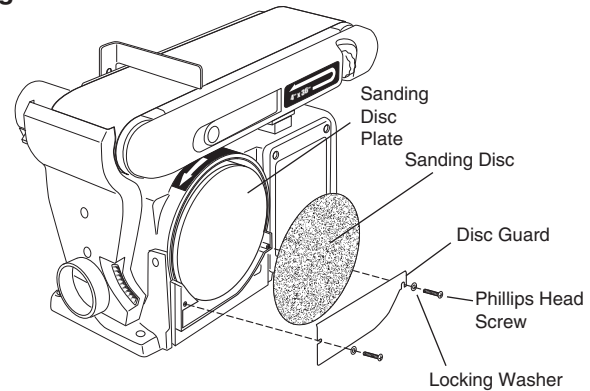
REPLACE THE SANDING DISC

Refer to Figure 9

- Remove the work table in reverse order of assembly. Refer to **Mount the Work Table** paragraph in this section.
- Remove Phillips head screw and locking washer securing guard disc.

- Remove the used sanding disc from the sanding disc plate and dispose of properly.
- Wipe the sanding disc plate clean.
- Peel the backing from the new sanding disc. Align the new sanding disc with sanding disc plate and press firmly into position. Ensure all edges are secure.
- Replace disc guard as shown, align holes and fasten in place with Phillips head screw and locking washer. Tighten securely.

Figure 9

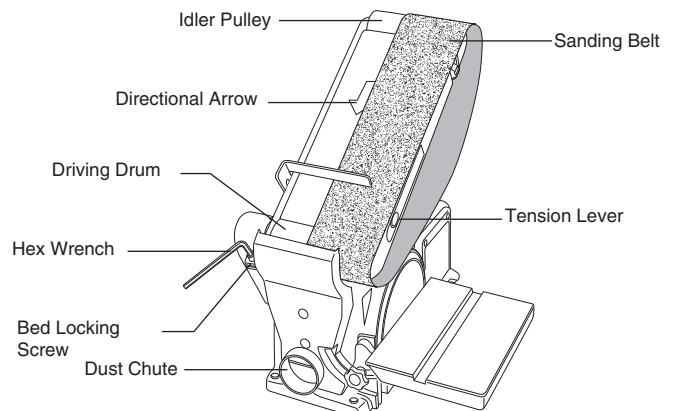


REPLACE THE SANDING BELT

Refer to Figure 10

- Use hex wrench supplied to loosen the bed locking screw. Raise the sanding bed to 45° and tighten the bed locking screw.
- Swing the belt tension lever open to release the belt tension.
- Remove the used sanding belt and dispose of properly.
- Locate the directional arrow on the smooth side of the sanding belt.
- Slide the new sanding belt over the idler pulley and driving drum with the directional arrow pointing towards the dust chute.
- Center the belt correctly on idler pulley and driving drum.
- Close the tension lever to tighten the belt tension.
- Loosen the bed locking screw. Lower the bed to a horizontal position and tighten the bed locking screw.

Figure 10



POWER SOURCE



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.

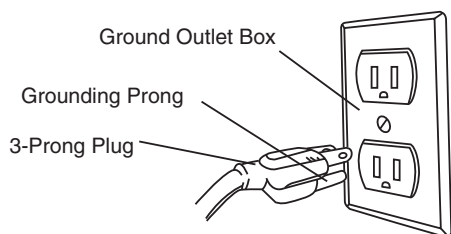
GROUNDING INSTRUCTIONS



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 11).
- 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 show in Figure 11.

Figure 11

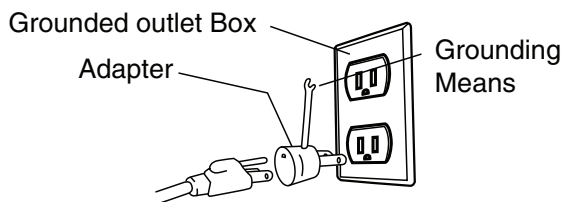


Do not permit fingers to touch the terminals of plug when installing or removing from outlet.

- 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 Figure12) may be used to connect this plug to a matching 2-conductor receptacle as shown in figure 6. The temporary adapter should be used only until a properly grounded outlet can be installed by a qualified electrician.

Figure 12



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 gauge

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

MOTOR

The sander is equieped with a 4.3 Amps motor. The 120 Volt motor has the following specifications:

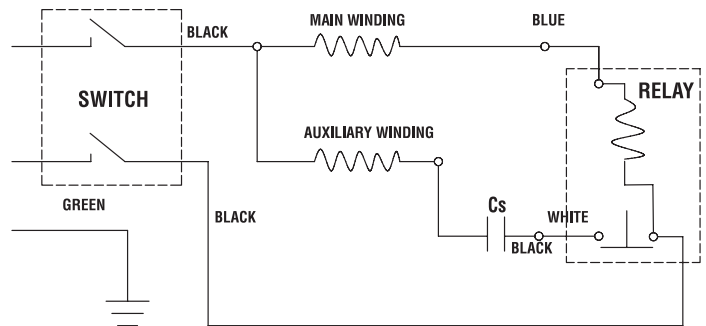
Horsepower	1/2
Voltage	120
Amp.	4.3
Hertz60
Phase.Single
RPM.3600

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 13.
- 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 used 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 13



OPERATION

ON/OFF SWITCH

Refer to Figure 14

The sander is equipped with a keyed switch to prevent unauthorized use of the sander.

⚠ WARNING

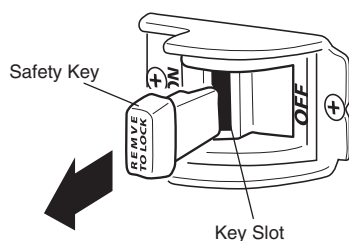
Your Powertec 6 x 9 belt disc sander is designed and engineered to sand wood or wood products. Sanding of steel or other ferrous materials is a fire hazard and could damage your sander.

⚠ CAUTION

Remove the safety key whenever the sander is not in use. Place the safety key in a safe place and out of the reach of children.

- To turn sander ON, insert the safety key into the key slot in the center of the switch.
- Push safety key firmly into the slot and then place the ON/OFF switch in the ON position to start the sander.
- To turn the sander OFF, place the ON/OFF switch in the OFF position.
- When the sander comes to a complete stop gently pull the safety key forward and out. Place the key in a safe place out of the reach of children.

Figure 14

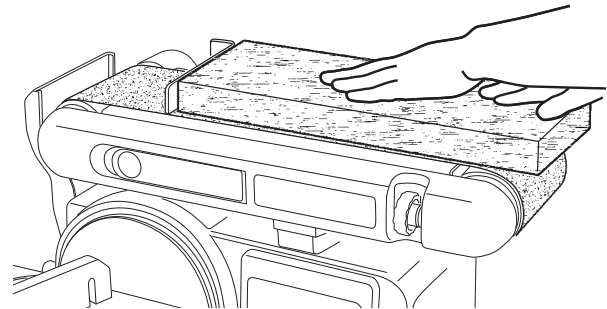


SURFACE SANDING ON SANDING BELT

Refer to Figure 15

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

Figure 15



SANDING INSIDE CURVES

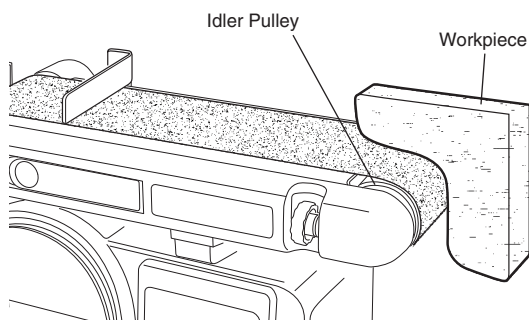
Refer to Figure 16

When sanding inside curves on the sanding belt always sand on the idler pulley end of the sanding belt as shown (right side of the machine is shown in Figure 16). Hold the workpiece firmly with both hands, keeping fingers away from the sanding belt.

Keep the curve section of the workpiece pressed firmly against the idler pulley and move it evenly back and forth across the idler pulley.

NOTE: Use extra caution when sanding very thin workpieces. Apply only enough pressure to allow the sanding belt to remove the material.

Figure 16



END SANDING AND OUTSIDE CURVE SANDING WITH THE DISC

Refer to Figure 17

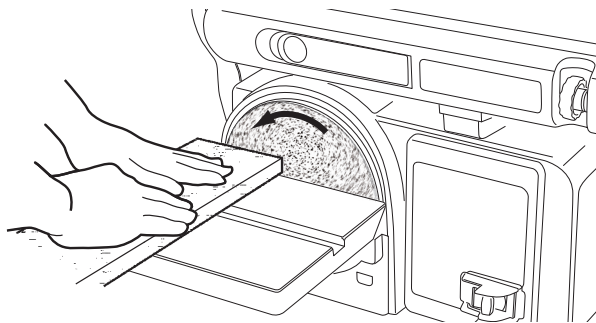
Use for sanding the ends of small and narrow workpieces and outside curved edges. Always work on the left side of the disc (downward rotation side), holding the workpiece firmly with light pressure against the sanding disc.

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. Review this instruction manual for correct operation, adjustments and basic sanding operations.

Figure 17



BELT SANDING - HORIZONTAL AND VERTICAL SANDING

Refer to Figure 18 and 19

The sanding belt station can be used in the vertical or horizontal position. The work support can be used with both positions.

The work table can be used when sanding bed is in the vertical position.

To change positions:

- Use 6 mm hex key supplied to loosen (counterclockwise) the bed locking screw.
- Raise or lower the sanding bed to the desired position and tighten the bed socket screw (clockwise).

OPERATIONAL NOTE: Sand long workpieces with the sanding belt in the vertical position by moving the work evenly across the sanding belt.

To assemble work table for the vertical sanding:

- Remove the work table in reverse order of assembly. Refer to **Mount the Work Table** paragraph in this section.
- Remove the work support in reverse order of assembly. Refer to **Mount the Work Support** paragraph in this section. Save the work support and hardware for future use.
- Position the sanding bed in the desired position. Ensure bed locking screw is tight.
- Position the work table horizontal to the sanding bed and insert the index pins into the work table mounting holes in sanding bed. Secure in place with adjustment knob and washer.
- Maximum distance between the work table and sanding bed should be 1/16". To adjust, loosen the three bolts securing the work table to the work table support. Adjust the work table in or out to the 1/16". Tighten three bolts securely.

Figure 18

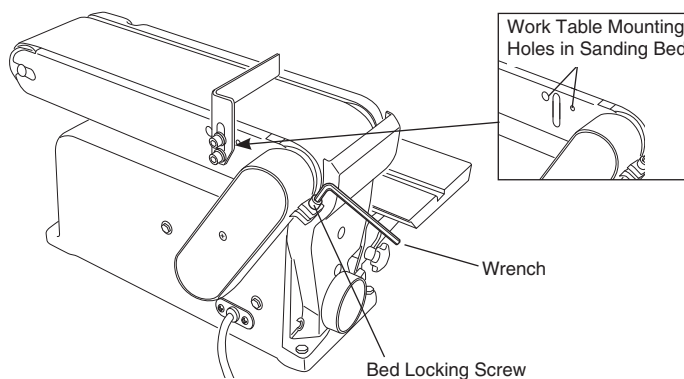
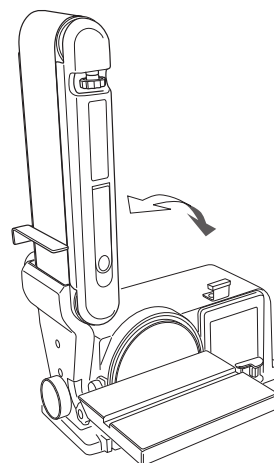


Figure 19





8

MITER GAUGE - DISC SANDER

Refer to Figure 20

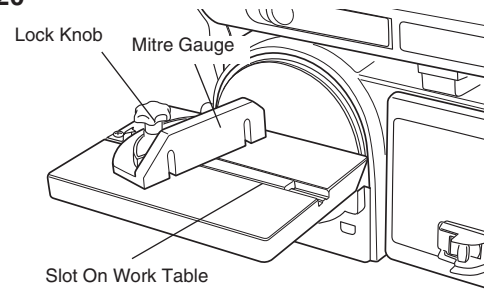
A miter-gauge is supplied with your sander, and can be used on the work table.

- 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.

Figure 20



MAINTENANCE



8

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.

ADJUST THE DRIVE BELT

Refer to Figure 21 and 22

- Remove the drive belt housing cover.
- Loosen the three screws to loosen the drive belt. Ensure the drive belt is seated correctly on the motor pulley and the drive pulley.
- Place a slotted screwdriver in the bracing slot, push up on the screwdriver to tighten the belt tension.
- Tighten all three screws.
- Test the belt tension by squeezing both sides of the belt. If properly adjusted, the belt should “give” between

1/8–1/4". Ensure the belt teeth are properly seated on the pulley gears.

- Carefully reinstall the drive belt housing cover, insert and tighten screw.

NOTE: Over tightening the belt will cause increased noise and motor overload. Premature failure will occur if belt is too loose.

Figure 21

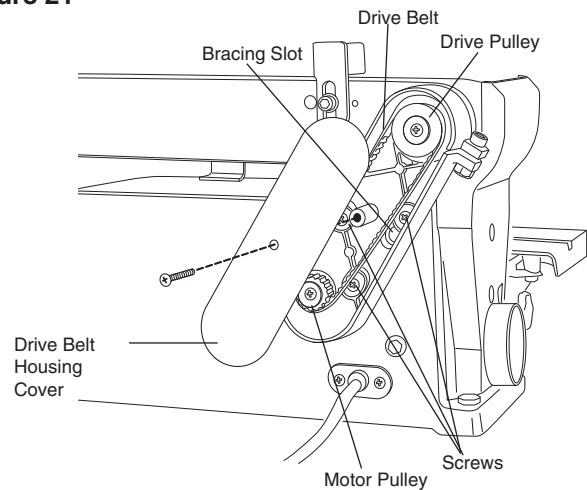
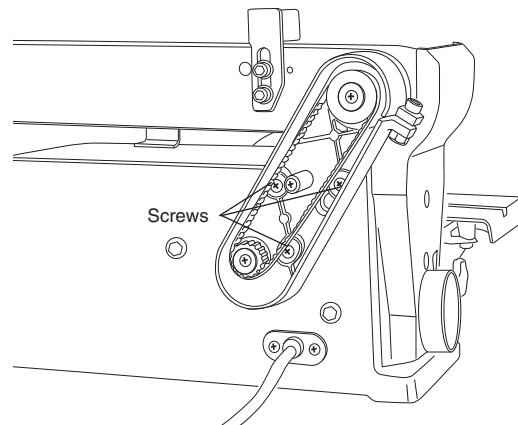
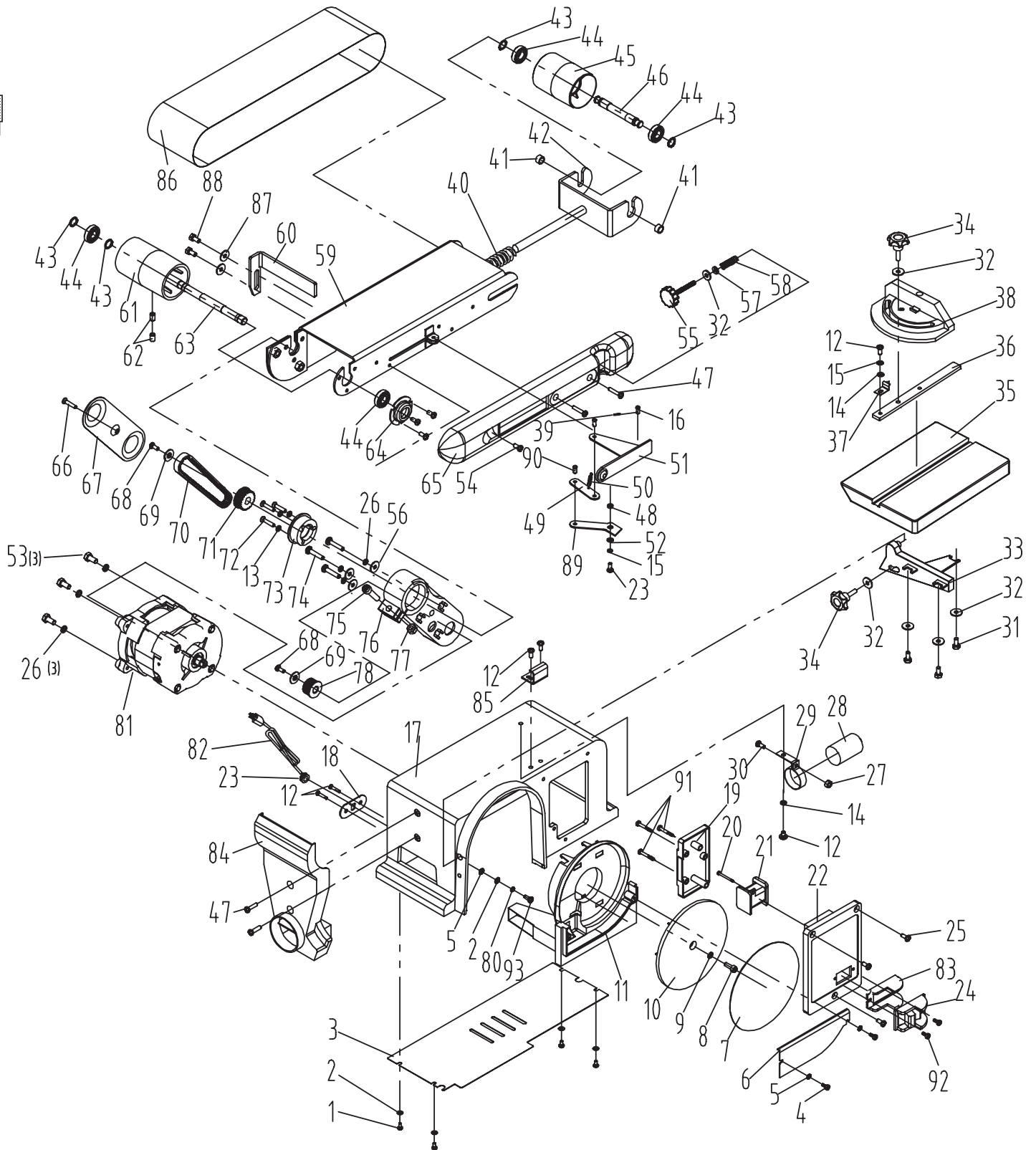


Figure 22



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. Incorrect motor mounting. 2. Incorrect sanding-belt tension. 3. Weak or broken tension spring. 4. Idler roller is too loose. 5. Broken/defective sanding accessories. 	<ol style="list-style-type: none"> 1. Have motor mountings inspected by service technician. 2. Adjust tension adjustment knob. Follow belt-tensioning/ tracking instructions in this manual. 3. Have tension spring replaced by service technician. 4. Have service technician adjust idler roller. 5. Replace sanding belt/disc.
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 mitre 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).



4 x 6 BELT/DISC SANDER PARTS LIST



Key No.	Part No.	Description	Specification	Qty	Key No.	Part No.	Description	Specification	Qty
1	BD4600001	Philips Screw	M4x6	4	48	BD4600048	Screw Sleeve		1
2	BD4600002	Flat Washer	D4	5	49	BD4600049	Connection Plate		1
3	BD4600003	Base Plate		1	50	BD4600050	Spring		1
4	BD4600004	Philips Screw	ST4.2X10	2	51	BD4600051	Sanding Belt Tension Knob		1
5	BD4600005	Out tooth Locking Washer	D4	3	52	BD4600052	Big Flat Washer	D5	1
6	BD4600006	Disc Cover		1	53	BD4600053	Hex Bolt	M6X20	3
7	BD4600007	Sanding Disc		1	54	BD4600054	Philips Screw		1
8	BD4600008	Hex Socket Head Screw	M6x16	1	55	BD4600055	Adjusting Knob		1
9	BD4600009	Out Tooth Locking Washer	D6	1	56	BD4600056	Flat Wahser	M8x15	3
10	BD4600010	Disc		1	57	BD4600057	Rubber Pad	M5x16	1
11	BD4600011	Sanding Disc Plastic Guard		1	58	BD4600058	Adjusting Spring		1
12	BD4600012	Philips Screw	M5x8	4	59	BD4600058	Sanding Belt Support	D6	1
13	BD4600013	Spring washer	D5	3	60	BD4600060	Work Rest		1
14	BD4600014	Flat Washer	D5	2	61	BD4600061	Driving Roller		1
15	BD4600015	Out Tooth Locking Washer	D5	2	62	BD4600062	Hex Socket Head Dcrew	M8X12	2
16	BD4600016	Pin	5X10	1	63	BD4600063	Driving Shaft		1
17	BD4600017	Base		1	64	BD4600064	Bearing Cap		1
18	BD4600018	Cord Clip Fixing Plate		1	65	BD4600065	Frame Cover		1
19	BD4600019	PCB Cover		1	66	BD4600066	Philips Screw	M5x10	1
20	BD4600020	Philips Screw	ST2.9X28	1	67	BD4600067	Drive Belt Cover		1
21	BD4600021	Relay		1	68	BD4600068	Philips Screw	M5x16 left	2
22	BD4600022	PC Board		1	69	BD4600069	Special Locking Flat		2
23	BD4600023	Cord Clip	6P4	1	70	BD4600070	Cog Belt		1
24	BD4600024	Switch		1	71	BD4600071	Idler Roller		1
25	BD4600025	Philips Screw	M4X10	3	72	BD4600072	Philips Screw	M5x25	3
26	BD4600026	Spring Washer	D6	6	73	BD4600073	Bearing Base		1
27	BD4600027	I Type Hex Nut	M5	1	74	BD4600074	Philips Screw	M6x25	3
28	BD4600028	Capacitor	100uF/125V	1	75	BD4600075	Hex Socket Round Head Screw	M8x25	1
29	BD4600029	Capacitor Support		1	76	BD4600076	Belt Cover		1
30	BD4600030	Philips Screw	M5x12	1	77	BD4600077	Nut M8		1
31	BD4600031	Hex Bolt	M6X12	3	78	BD4600078	Motor Driving Pulley		1
32	BD4600032	Big Flat Washer	D6	6	80	BD4600080	Spring Washer	D4	1
33	BD4600033	Work Table Support		1	81	BD4600081	Motor Assy.		1
34	BD4600034	Mitre Gauge Knob		2	82	BD4600082	Power Cord		1
35	BD4600035	Work Table		1	83	BD4600083	Switch Plate		1
36	BD4600036	Mitre Gauge Slide Pole		1	84	BD4600084	Dust Collection Cover		1
37	BD4600037	Mitre Gauge Scale Pointer		1	85	BD4600085	Frame Support		1
38	BD4600038	Mitre Gauge		1	86	BD4600086	Sanding Belt		1
39	BD4600039	Open-End Pin		1	87	BD4600087	Flat Wahser	D8	2
40	BD4600040	Belt Tension Spring		1	88	BD4600088	Hex Socket Round Head Screw	M8X16	2
41	BD4600041	Bushing		2	89	BD4600089	Tension Pole		1
42	BD4600042	Belt Tension Assy.		1	90	BD4600090	Pin	5X8	2
43	BD4600043	Spring Retaining Ring	D12	4	91	BD4600091	Philips Screw	ST4.2X20	3
44	BD4600044	Bearing 101		4	92	BD4600092	Philips Screw	ST2.9X6	2
45	BD4600045	Sanding Belt Idler Pulley		1	93	BD4600093	Philips Screw	M4X8	1
46	BD4600046	Sanding Belt Idler Shaft		1					
47	BD4600047	Philips Screw	M5X20	4					





Thank you for investing in a **POWERTEC** power tool. These products have been designed and manufactured to meet high quality standards and are 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**, 206 Terrace Dr. Mundelein, IL 60060, Attn: **POWERTEC** technical service; or by calling 1-877-393-7121 (toll free), 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 balance 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 an authorized **POWERTEC** service center for bench top and stationary power tools. You may obtain the location of the authorized service center nearest you by calling (toll free) 1-877-393-7121 or by logging on to the **POWERTEC** website at www.southerntechllc.com. When requesting warranty service, you must present the proof of purchase documentation, which includes a date of purchase. The authorized service center 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 balance of one year warranty period.

WHAT IS NOT COVERED

This warranty applied to the original purchaser at retailer 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 by other than an authorized service center for **POWERTEC** product.

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.

**NOTE**

POWERTEC

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