## Powermatic Combination Belt/Disc Sander

<table>
<thead>
<tr>
<th>Description</th>
<th>Combination Belt/Disc Sander – Model 31A</th>
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<tbody>
<tr>
<td>Size / Horse power</td>
<td>6” x 48” Belt / 12” Disc / 2 HP</td>
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<tr>
<td>Power source</td>
<td>230 volt through plugged power cord</td>
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<tr>
<td>Uses</td>
<td>Sanding of wood and metal</td>
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### Safety Precautions

#### Hazards
- Abrasions
- Flying debris (potential eye and face damage)
- Electrical shock
- Entanglement of hair, jewelry, or clothing
- Fire risk

#### Training
- Shop Safety Fundamentals
- Site Specific Training

#### Protective Equipment
- Safety glasses
- Hearing protection
- Tie back long hair
- Avoid loose fitting clothing
- Remove rings, watches, bracelets, and other such jewelry

### Operation

#### Startup
1. Put on PPE listed above
2. Ensure work area is clean and free of obstacles
3. Ensure all tables are present and function properly (less than 1/16” from belt/disc)
4. Make necessary adjustments for safe operation
5. Inspect machine for damage or obstructions to operation
6. Turn on sander using power switch located on the front of the machine
7. Begin work
8. Slowly press work piece against belt/disc, avoid feeding material too quickly
9. Keep hands clear of sanding surfaces

#### Shutdown
1. Remove work piece
2. Turn off sander by using power switch located on the front of the machine
3. Allow sander to stop on its own, do not leave the sander until it has come to a complete stop

### Maintenance

#### Storage

#### Care
- Wipe the machine down after each use
- Keep exposed metal surfaces clean and rust free
- Make periodic inspection of the operation of the machine

#### Accessories
- Miter Gauge
**Belt Arm Adjustment**
1. Loosen the locking handle
2. Pull out on the index pin, and swing the belt arm into the desired position (0° - 45° - 90°), then release the index pin
3. Check that the index pin has gone into position by attempting to move the belt arm back and forth
4. Re-tighten the locking handle

![Diagram of Belt Arm Adjustment](image)

**Disc Table Adjustment**
1. Loosen both locking wheels (A)
2. Adjust table until desired angle is met, use the scale (B) on the side for proper angle
3. Tighten both locking wheels to secure table before use
4. Attempt to move the table to ensure it has been secured

![Diagram of Disc Table Adjustment](image)

**Installing and Tracking Abrasive Belt – Performed by Authorized Personnel Only**
1. Loosen the knob (A) and swing the belt end guard out of position
2. Remove the side cover by unscrewing the two knobs holding it, and sliding the tab of the side cover out of the slots of the sander
3. Loosen the tension knob (C), remove old belt
4. Slide the abrasive belt onto the drums until it is centered on them
5. Tighten the tension knob
6. Check the tracking of the belt manually. The abrasive belt should remain at the center of the drums
7. If the belt veers to one side or the other, loosen the locking wheel (D) and rotate the tracking knob (E) either left or right until the belt centers itself. When manual tracking appears successful, turn the machine on for a moment and confirm that the abrasive belt will remain centered during operation. Additional tuning may be needed
8. When satisfied, tighten the locking wheel (D) against the belt arm to secure the setting
9. Re-install the side cover and secure with the knobs. Swing the end guard (B) back into position and re-tighten the knob (A)