JET

INSTRUCTION MANUAL

WIDE BELT SANDER

JWB-25P

708411B

R.S.T. : Power Input

CT (A) : Current Coil and Ampere Meter

(M1) : Magnetic Switch for Main Motor

M1 : Main Contact of (M1) (Magnetic Switch for Main Motor)

M1a : Aux. Contact Open of (M1) (Magnetic Switch for Main Motor)

OL1 : Overload Relay Protector for Main Motor

(M3) : Magnetic Switch for Feeding Motor

M3 : Main Contact of (M3) (Magnetic Switch for Feeding Motor)

M3a : Aux. Contact Open of (M3) (Magnetic Switch for Feeding Motor)

OL2 : Overload Relay Protector for Feeding Motor

(M4A) : Magnetic Switch for Lifting Motor Up

(M4B) : Magnetic Switch for Lifting Motor Down

M4A : Main Contact of (M4A) (Magnetic Switch for Feeding Motor Up)

M4B : Main Contact of (M4B) (Magnetic Switch for Feeding Motor Down)

M4Ab : Aux. Contact Close of (M4A) (Magnetic Switch for Lifting Motor Up)

M4Bb : Au . Contact Close of (M4B) (Magnetic Switch for Lifting Down)

OL3 : Overload Relay Protector for Lifting Motor

PT : Transformer

Fuse : Control Fuse

S1 : Election Switch

PB1 : Switch for Stop Circuit

PB2 : Switch for Start Circuit

(L2) : Indicator for Start Circuit

PB5 : Switch for Stop Circuit

PB6 : Switch for Start Circuit

(L4) : Indicator for Start Circuit

PB7 : Push Button for Lifting Motor Up

PB8 : Push Button for Lifting Motor Down

PB9 : Push Button for Emergency Stop

LS1 : Safety Limit Switch

LS2 : Sanding Belt Limit Switch

LS3 : Sanding Belt Limit Switch

LS6 : Table Elevation Limit Switch

LS7 : Table Elevation Limit Switch

(L1) : Indicator for Circuit Source

(PH) : Photo-Electric Control Coil

PH : Contact of Photo-Electric Control

(R1) : Aux. Relay for Tracking Solenoid Valve

R1a : Aux. Contact of (R1) (Aux. Relay for Tracking Solenoid Valve)

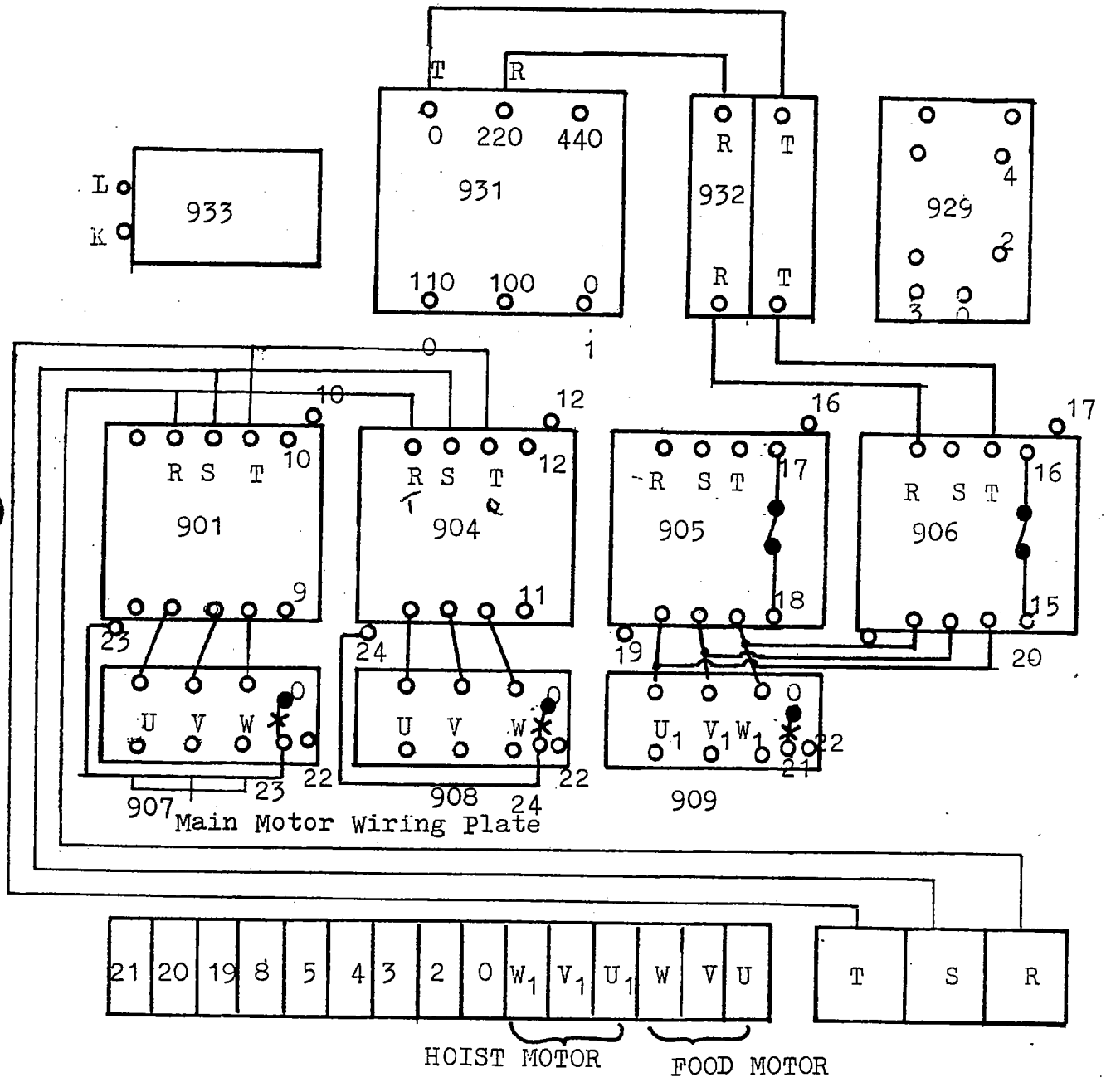
SOL1 : Tracking Solenoid Valve Coil

SOL3 : Brake Solenoid Valve

(L5) : Alarm Indicator

JWB-25P

FILE



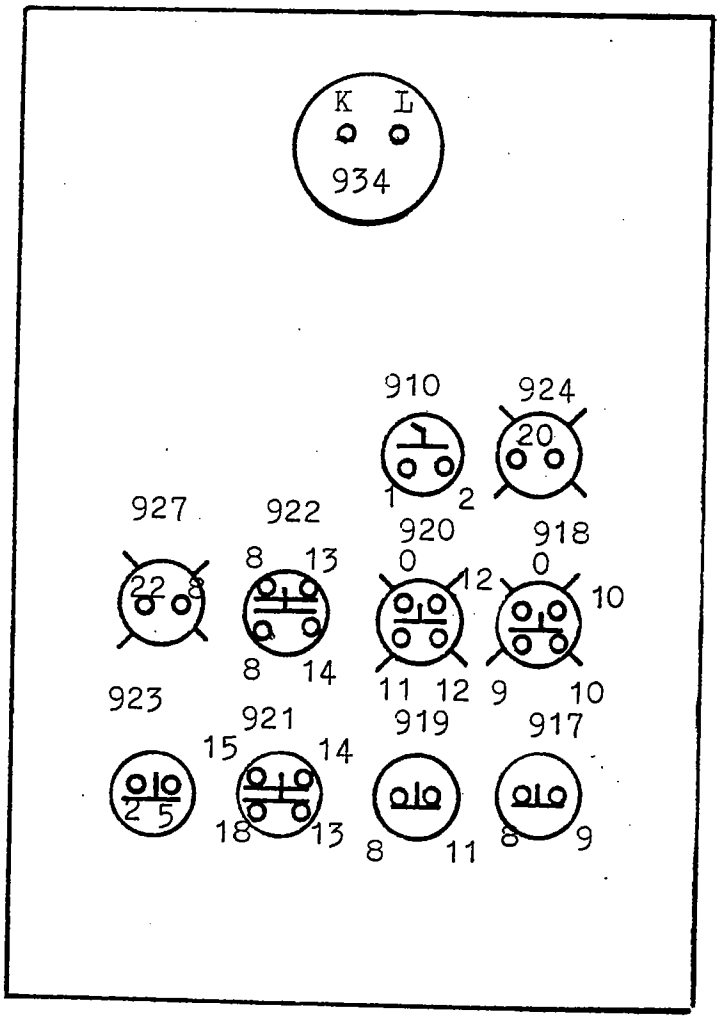
R - R
S - S
T - T
K - K
L - L
U - U
V - V
W - W
U1 - U1
V1 - V1
W1 - W1
0 - 0
1 - 1
2 - 2
3 - 3
4 - 4
5 - 5
6 - 6
7 - 7
8 - 8
9 - 9
10 - 10
11 - 11

E-1

FILE

JWB-25P

R - R
S - S
T - T
K - K
L - L
U - U
V - V
W - W
U1 - U1
V1 - V1
W1 - W1
0 - 0
1 - 1
2 - 2
3 - 3
4 - 4
5 - 5
6 - 6
7 - 7
8 - 8
9 - 9
10 - 10
11 - 11

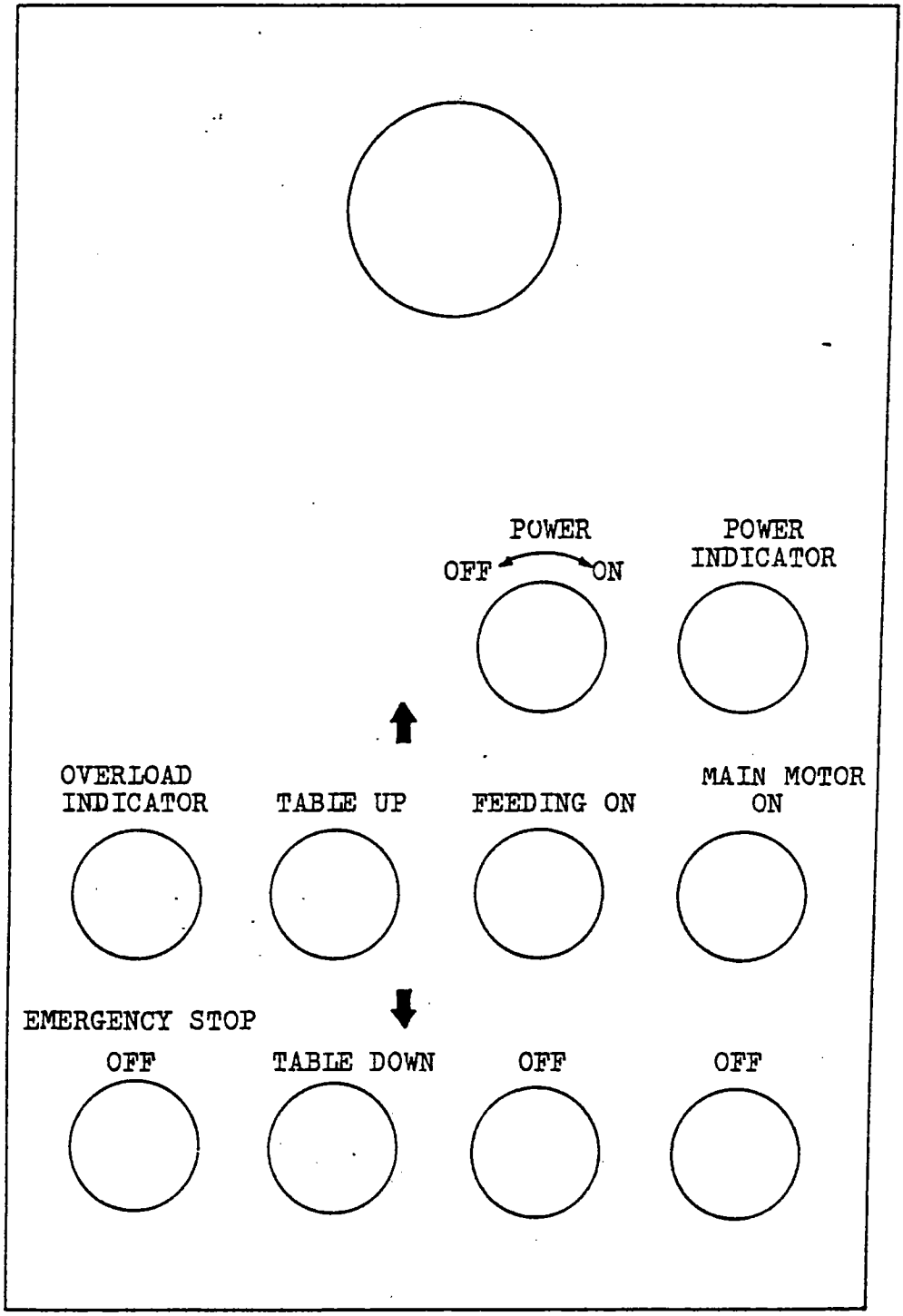


12 - 12
13 - 13
14 14
15 - 15
16 - 16
17 - 17
18 - 18
19 - 19
20 - 20
21 - 21
22 - 22
23 - 23
24 - 24

E-2

JWB 25P
FILE

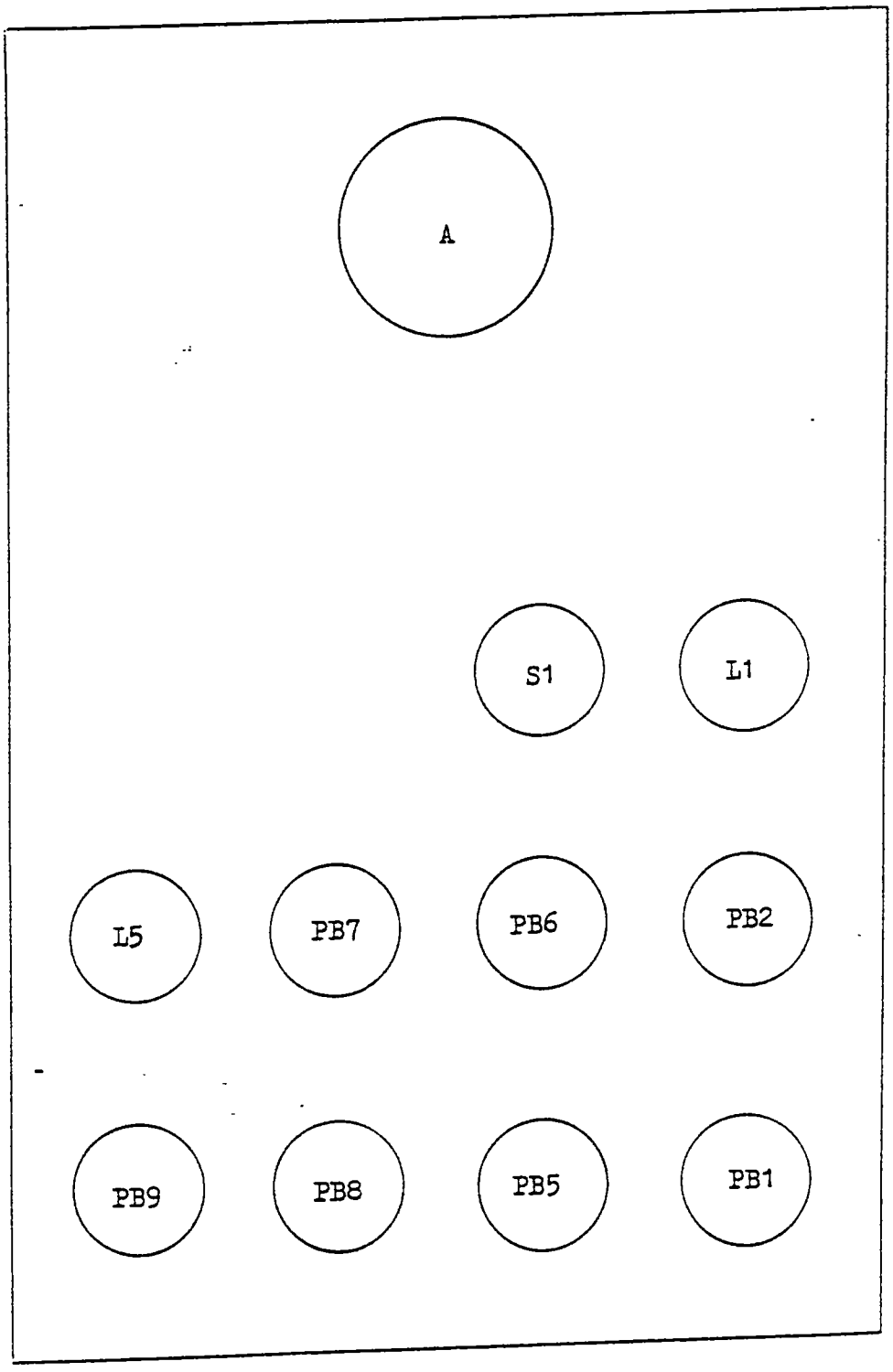
CONTROL PANEL



JWB 25P

CONTROL PANEL WIRING DIAGRAM

FILE

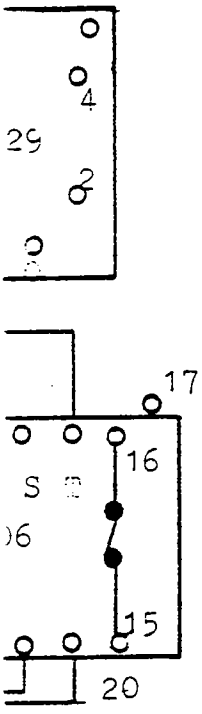


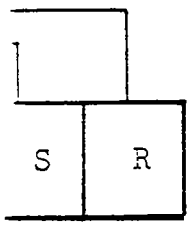
S1 :Power On Switch
L1 :Power On Indicator
L5 :Overload Indicator
PB7:Lifting Motor "Up"
PB6:Feeding Motor "On"

PB2 : Main Motor "On"
PB9 : Emergency Stop Push Butto
PB8 : Lifting Motor "Down"
PB5 : Feeding Motor "Off"
PB1 : Main Motor "Off"

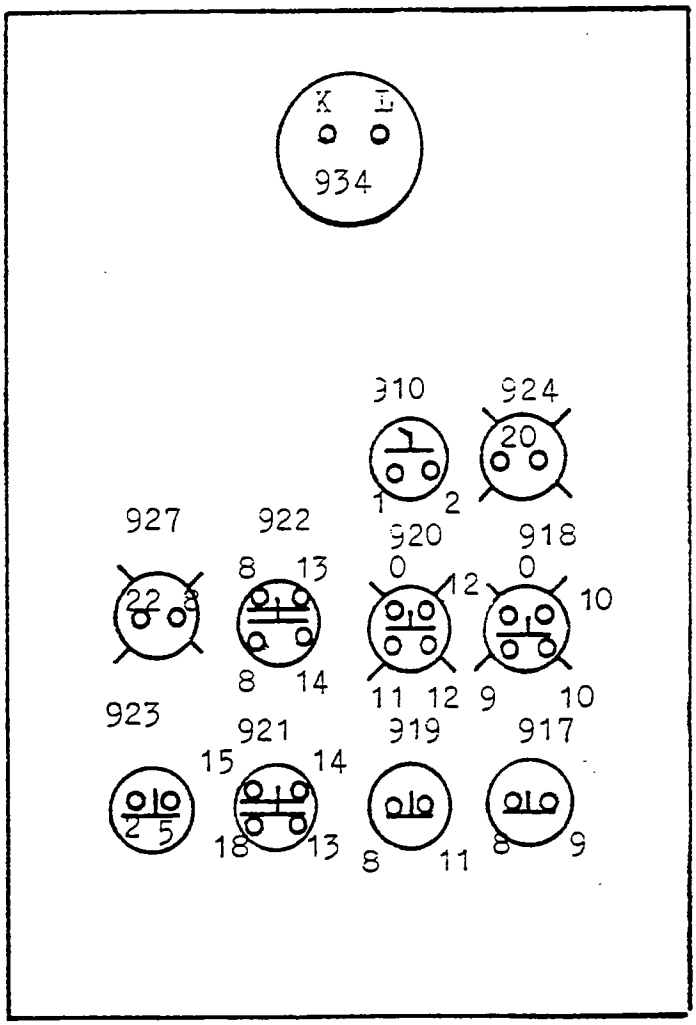
GWB-25P

FIL

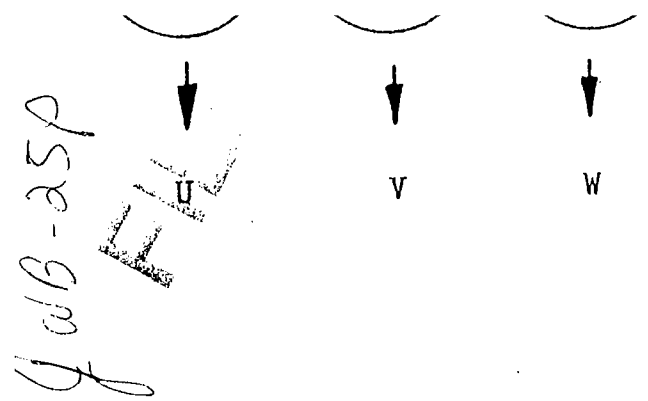


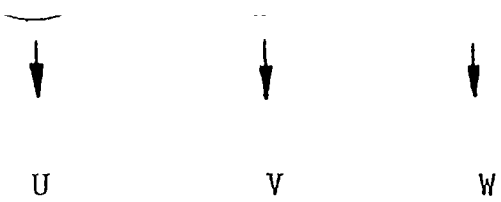


R - R
S - S
T - T
K - K
L - L
U - U
V - V
W - W
U1 - U1
V1 - V1
W1 - W1
0 - 0
1 - 1
2 - 2
3 - 3
4 - 4
5 - 5
6 - 6
7 - 7
8 - 8
9 - 9
10 - 10
11 - 11

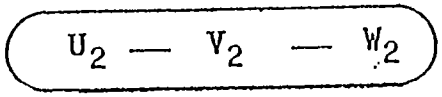


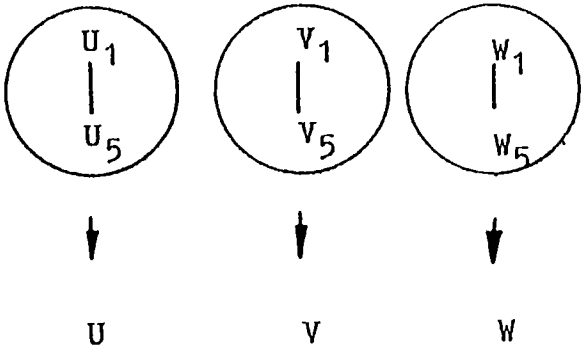
12 - 12
13 - 13
14 - 14
15 - 15
16 - 16
17 - 17
18 - 18
19 - 19
20 - 20
21 - 21
22 - 22
23 - 23
24 - 24



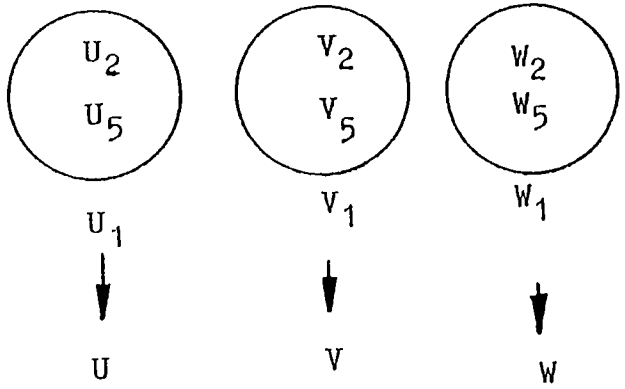


1HP & ½HP MOTOR

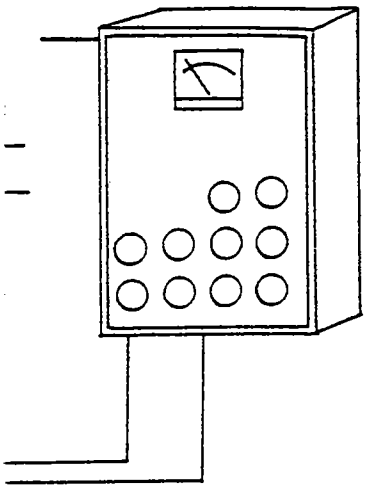




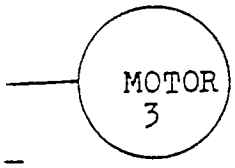
1HP & ½HP MOTOR



GWB-25P
FIL



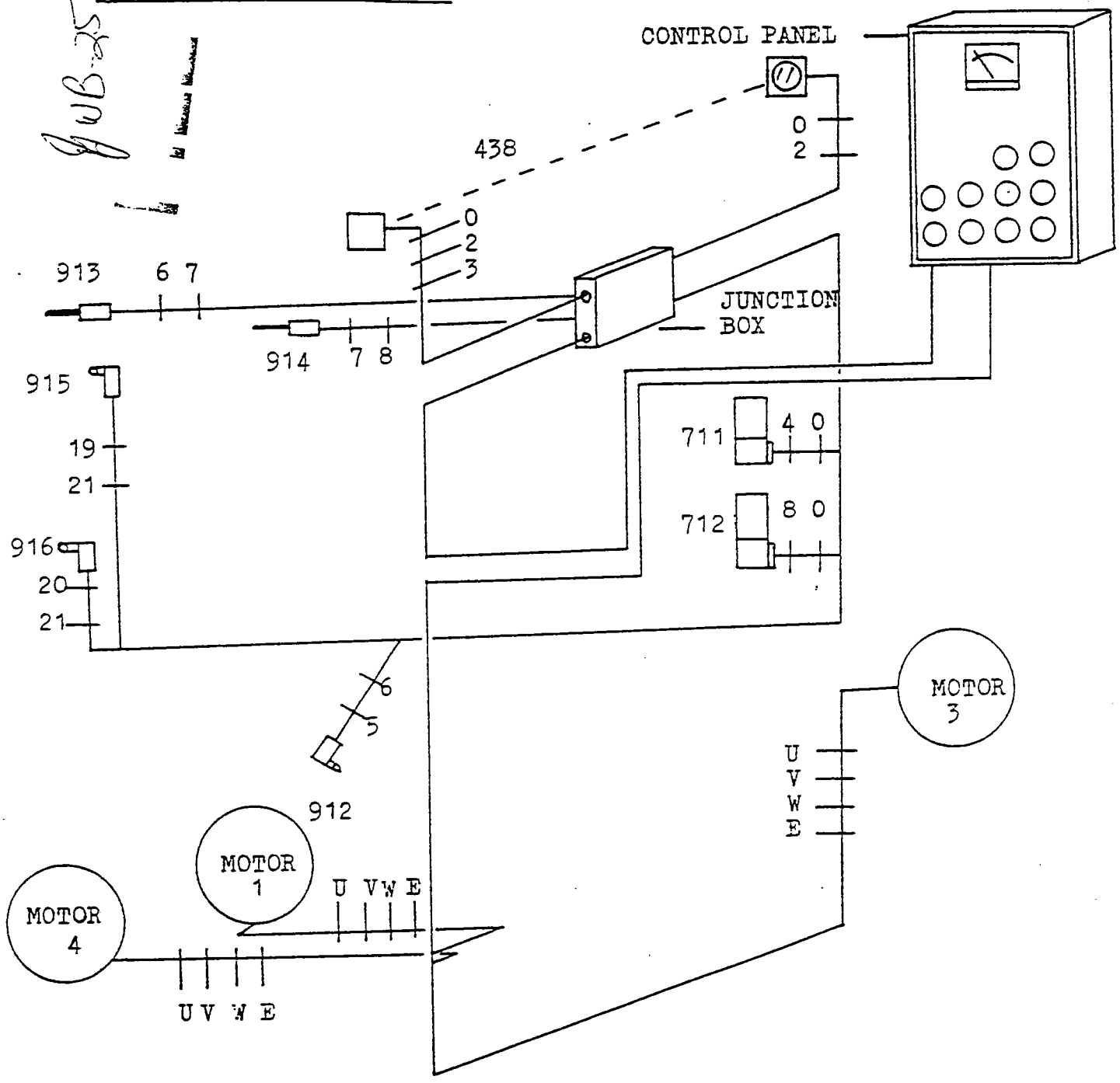
912 : Emergency Stop Limit Switch
913 : Sanding Belt Limit Switch
914 : Sanding Belt Limit Switch
915 : Table Elevation Limit Switch
916 : Table Elevation Limit Switch
438 : Photo-Electric Switch
711 : Solenoid Valve for Photo-Electric Switch
712 : Solenoid Valve for Brake
MOTOR 1 : Main Motor
MOTOR 3 : Feeding Motor



JWB-25P

JWB-25P

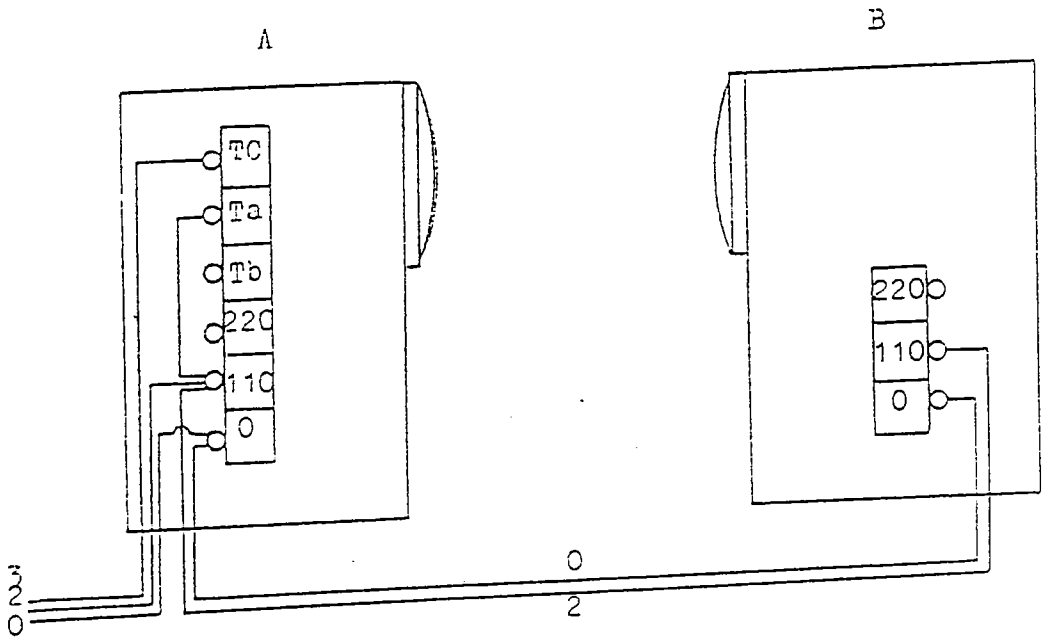
ELECTRIC WIRING DIAGRAM



FILE

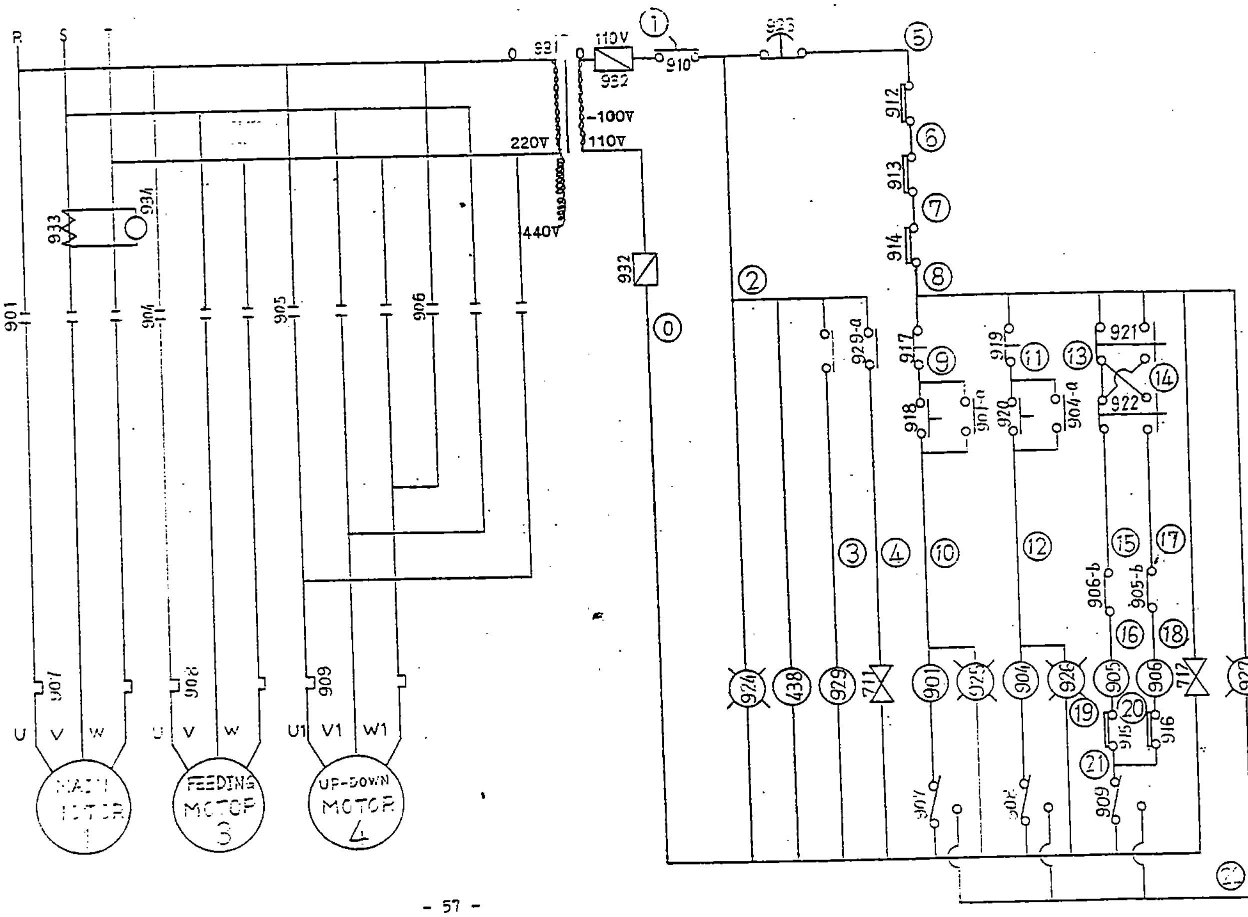
PHOTO ELECTRIC SWITCH DIAGRAM

Wiring Diagram for Electric Eye. P.66 (438)



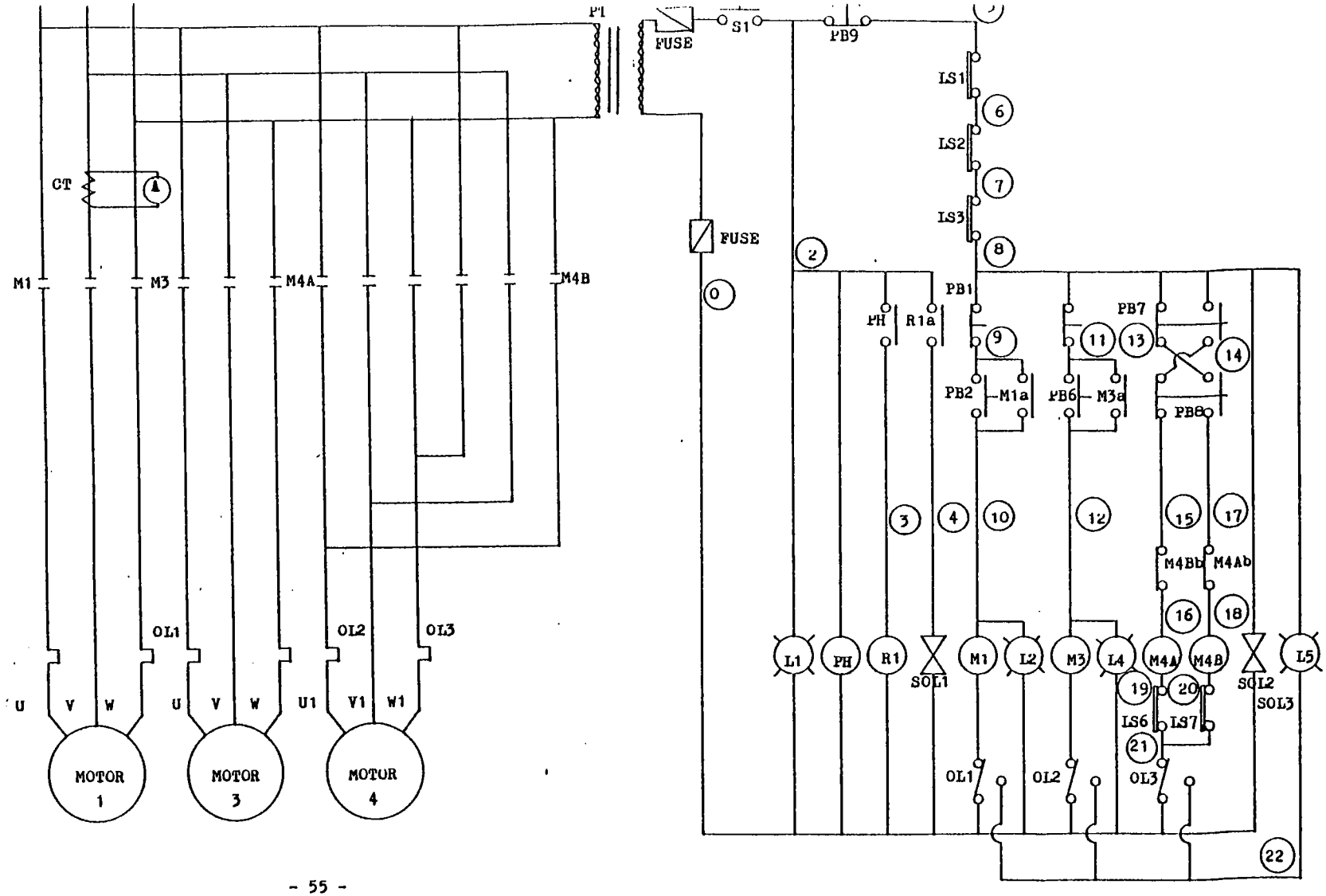
A. Sender

B. Receiver


R
S
T
931
110V
932
910
1
923
5
912
6
913
7
914
8
-100V
110V
220V
440V
933
934
901
904
905
906
932
0
2
929-a
917
9
919
11
921
13
14
922
918
901-a
920
904-a
3
4
10
12
15
17
906-b
905-b
16
18
924
438
929
711
901
925
904
926
905
906
712
927
19
20
915
916
21
907
908
909
22
U
V
W
U1
V1
W1
MAIN MOTOR 1
FEEDING MOTOR 3
UP-DOWN MOTOR 4

FILE

JWB-25P


P1
FUSE
S1
PB9
LS1
LS2
LS3
FUSE
CT
M1
M3
M4A
M4B
PB1
PH
R1a
PB7
PB2
M1a
PB6
M3a
PB8
M4Bb
M4Ab
OL1
OL2
OL3
U
V
W
U1
V1
W1
MOTOR 1
MOTOR 3
MOTOR 4
L1
PH
R1
SOL1
M1
L2
M3
L4
M4A
M4B
SOL2
SOL3
L5
LS6
LS7
OL1
OL2
OL3
0
2
3
4
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22

FILE

General Safety Precautions

1. Disconnect the machine from power source before servicing; When changing accessories such as sanding belt or any adjustments.
2. Keep safety guard in place and in working order.
3. Remove adjusting keys and wrenches: Form habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
4. Keep work area clean. Cluttered work areas invite accidents.
5. Do not use in dangerous environment. Do not use this machine in damp or wet locations, or expose it to rain. Keep work area well lighted.
6. Keep children away. All visitors should be kept a safe distance from work area.
7. Do not force the machine. It will do the job better and safer at the rate for which it was designed.
8. Use the right tools.
9. Wear proper apparel.
10. Always use safety glasses.
11. Do not overreach. Keep proper footing and balance at all times.
12. Maintain the machine with care.
13. Reduce the risk of unintentional starting. Make sure switch is in off position before plugging in.
14. Never stand on the machine.
15. Check damaged parts. Before further use of the machine, a belt or any parts that is damaged should be properly repaired or replaced.
16. Never leave the machine running unattened. Turn power off. Do not leave tool until it comes to a complete stop.
17. Proper grounding. The machine must be grounded while in use to protect the operator from electric shock.
18. Do not use emergency stop except in emergent condition.

Unpacking and Cleaning

JWB-25P FILE

To ensure maximum performance from your Wide Belt Sander, clean it properly and install it accurately before use.

As soon as you receive the Wide Belt Sander, we recommend you follow these procedures:

1. Inspect packing crate for damage from transit. Record damage, and report it immediately to shipper.
2. Open crate and check that machine arrived in good condition. If not, let your distributor know immediately.
3. Before lifting machine, remove all foot bolts locking it to its shipping base.
4. Do not use solvents on plastic parts; Solvents disslove or damage plastic.

Transportation and Installation

As to the transportation of machine, it shall be done by stack machine.

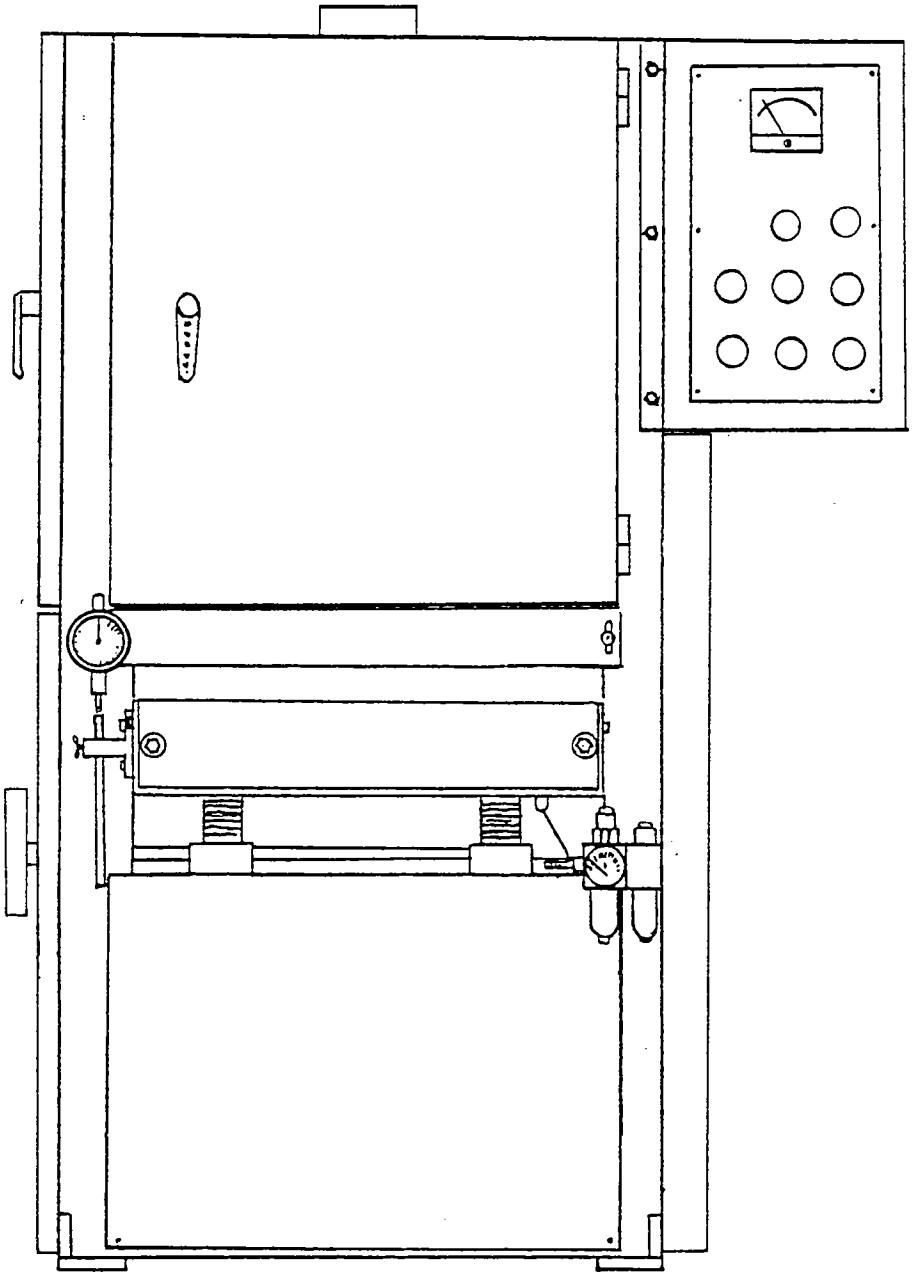
1. First the support of stack machine has to extend itself into the machine about 1½' in depth, and it shall raise the machine from the ground about 3/4' slowly, then, place a oblong block in the front of machine bottom, at this moment, the support can fully extend itself into the machine and raise the machine well.
2. When the machine was transported in the proper position, the procedure of installation is contrary to the Point 1.
3. As to the installation of machine, please note the machine shall be put in the ground steadily, no shake is permitted.
4. Please pay attention to the center of gravity for the machine when it shall be transported.

GWD-25P

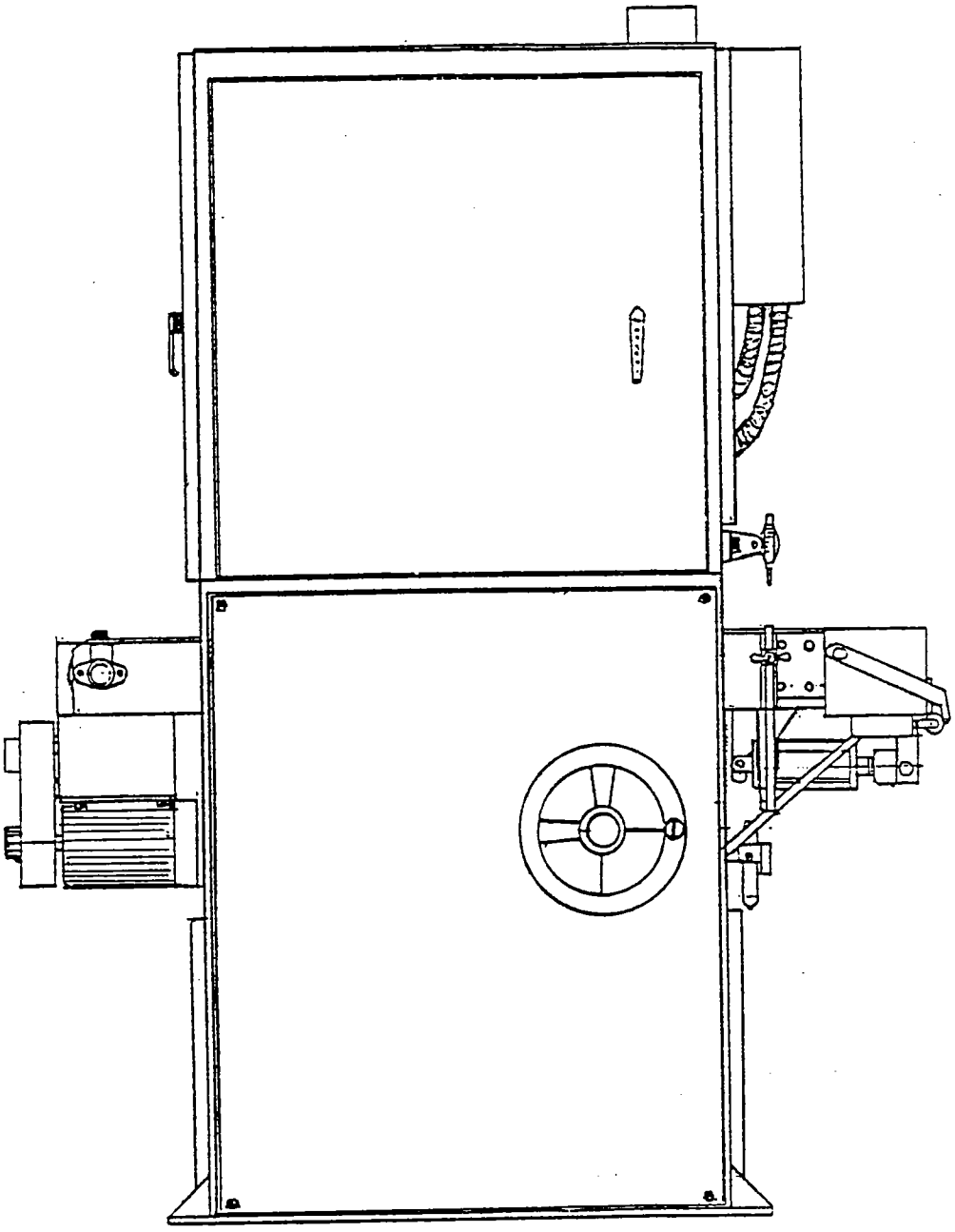
FILE

MACHINE APPEARANCE

FRONT VIEW



SIDE VIEW



4WB-25P

FILE

ADJUSTMENT OF TABLE PARALLEL

Number	Description
1	Lock Screw
2	Acme Screw
3	Dial Gage
4	Sanding Belt
5	Contact Drum
6	Table

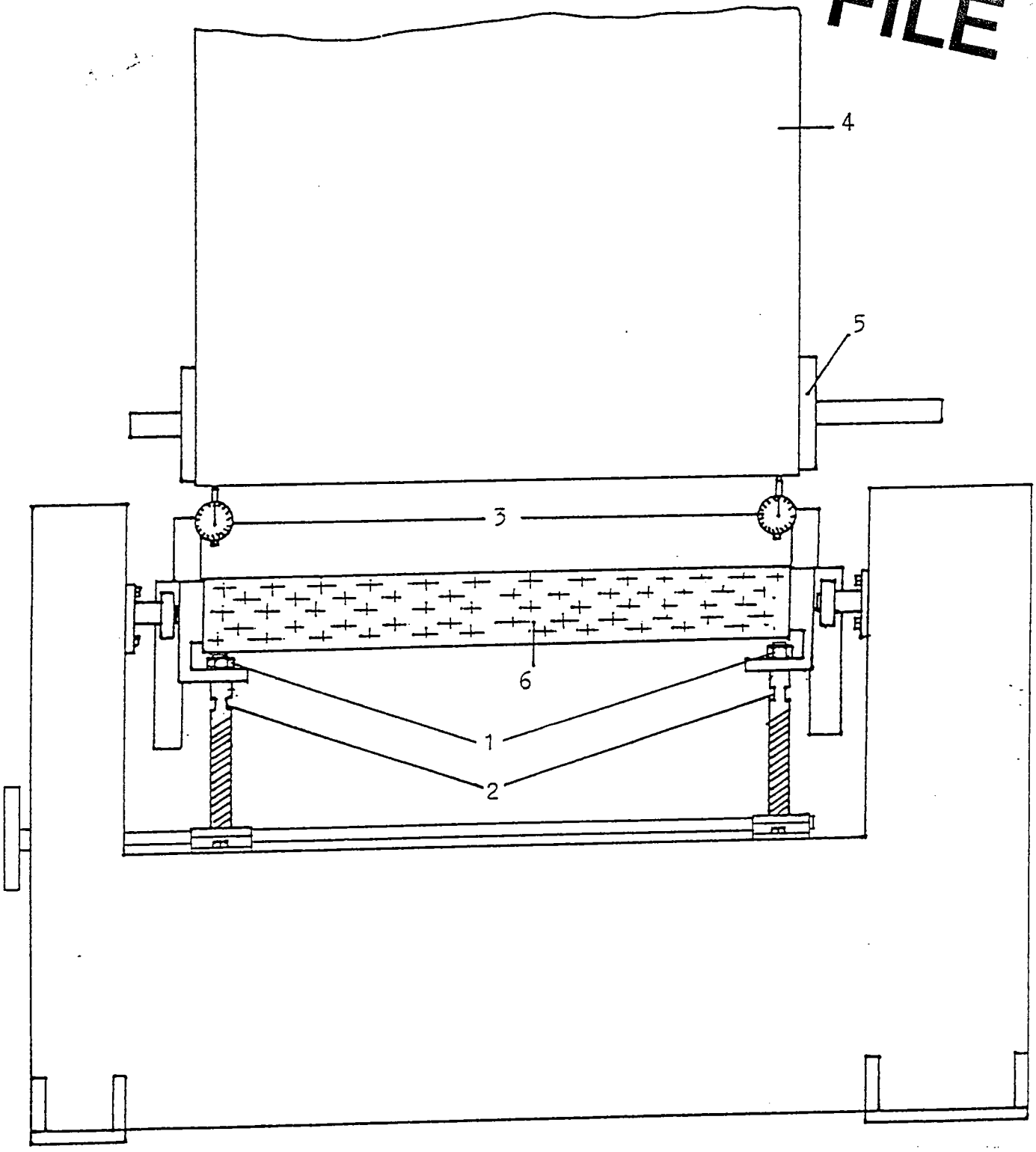
Step to adjust table:

A. Disconnect power supply.
B. Put dial gage on table (6) to touch the sanding belt (4) & Contact Drum (5) until the dial gage indicates approx. " 0 ".
C. Unlock screw (1).
D. Turn screw (2) for table adjustment till you reach approx. " 0.004 " total indicator same on both sides of the table.
E. Tighten lock screw.

ADJUSTMENT OF TABLE PARALLEL

JWB-25P

FILE



FEED BELT ADJUSTMENT

FILE

Number	Description
1	Adjustment Screw
2	Feed Belt
3	Air Flow Valve
4	Belt Tension Cylinder
5	Feed Belt Tension Arm
6	Plastic Idler Wheel (Air Valve)
7	Speed Dial Knob
8	Variable Drive Gear

* No. 3 & 6 are in same figuration.

Step to adjust feed belt:

A. Loosen the screw (1).
B. Pressure the plastic turning wheel (6), see if the cylinder (4) functions.
C. If the cylinder works, put the belt (2) in the right position. (Touch plastic idler wheel (6) slightly.)
D. Push feeding-on button and observe feed belt tracking.
E. Tighten the left screw (1) first, then do same the right screw.

Note: Let the belt show a tendency to move to the right side to make periodic contact with the idler wheel (6).

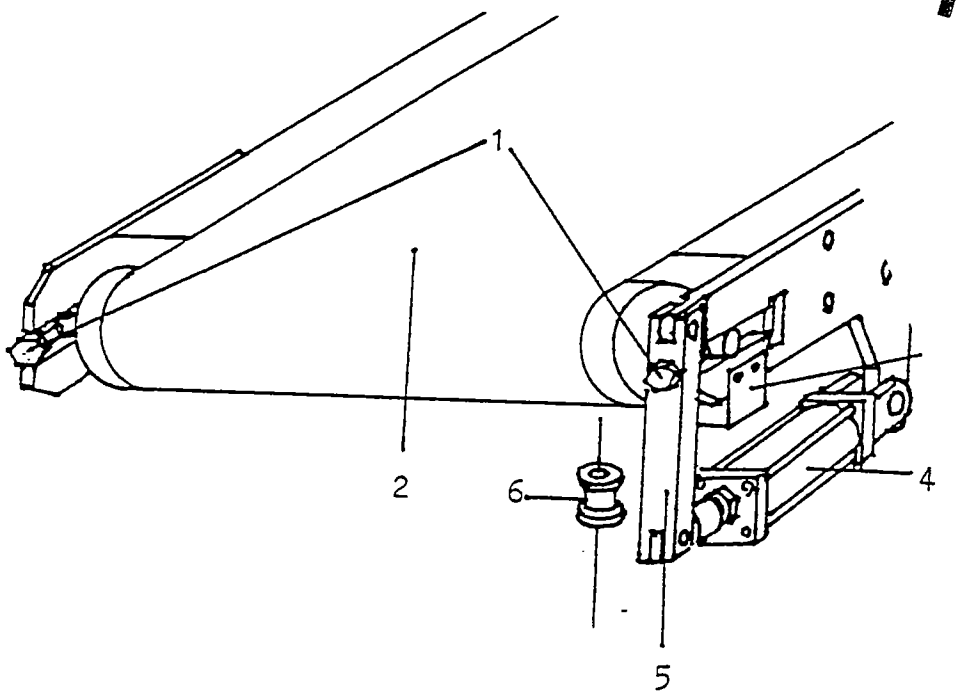
Speed Adjustment:

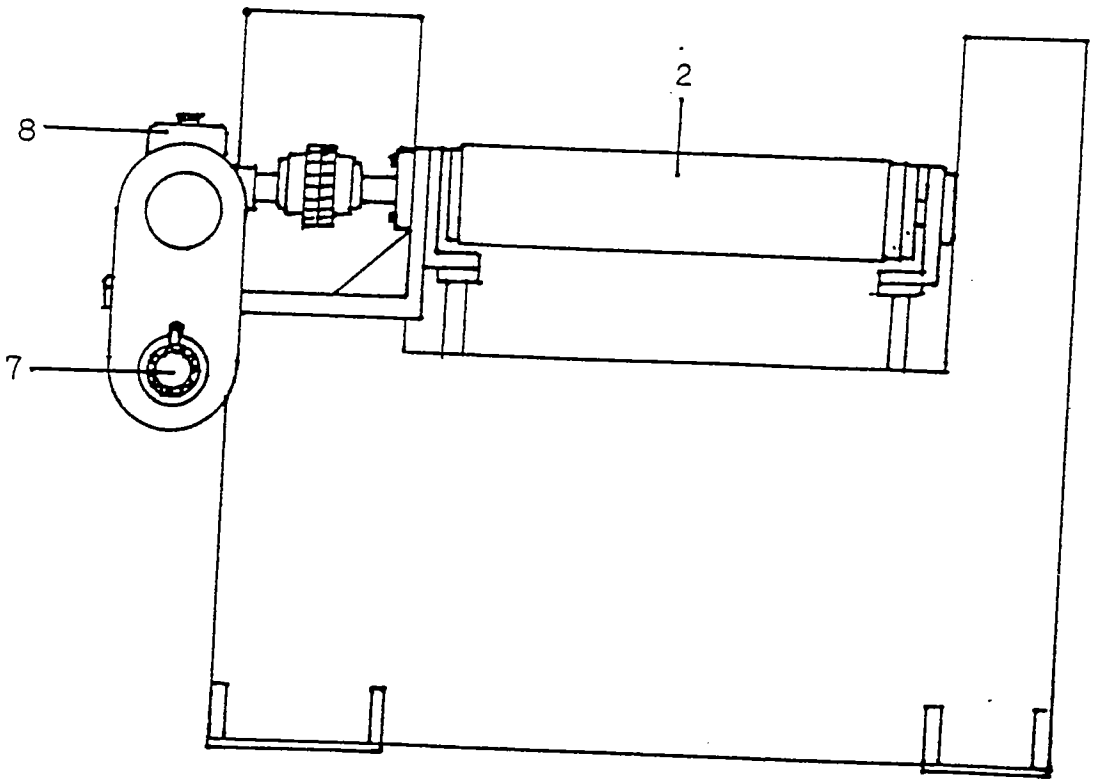
A. Push the feeding-on button.
B. Turn the speed dial knob to the right, the speed will be faster; If turns it to the left the speed will be slower.

Feed BELT ADJUSTMENT

JWB-25P

FILE





FILE

ADJUSTMENT OF PRESSURE SHOES PARALLEL

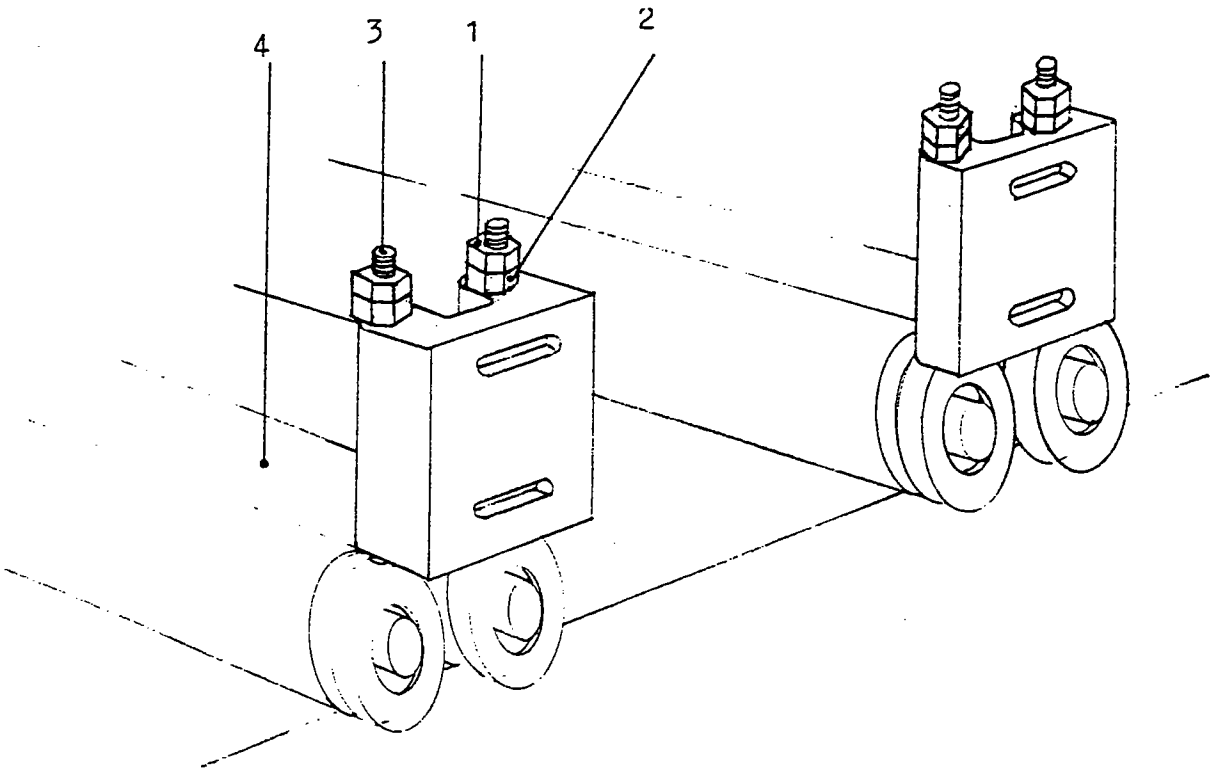
Number	Description
1	Fixed Nut
2	Adjust Nut
3	Fixed Screw
4-1,4-2,4-3,4-4	Feeding Roller
5	Contact Drum
6	Roller
7	Dial Gage
8	Sanding Belt

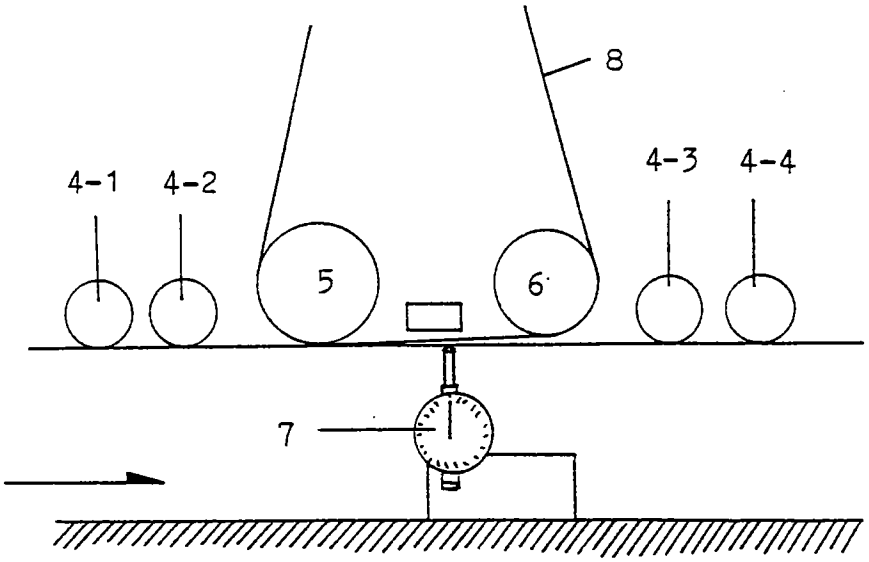
Step to adjust Feeding Roller parallel:

A. Insert a wood stock between the table and feeding roller.
B. Raise table up to touch the roller (5) & (6).
C. Loosen fixed nut (1).
D. Unlock nut (2) in order to press the working piece.
E. Checking the movement of working piece on table, be sure the working piece is in a correct position but not be pressed to tighten.
F. Tighten the fixed nut (1) to its' right position.

gWB-25P
FILE

ADJUSTMENT OF PRESSURE SHOES PARALLEL





TABLE

V-BELT TENSIONING/CHANGING

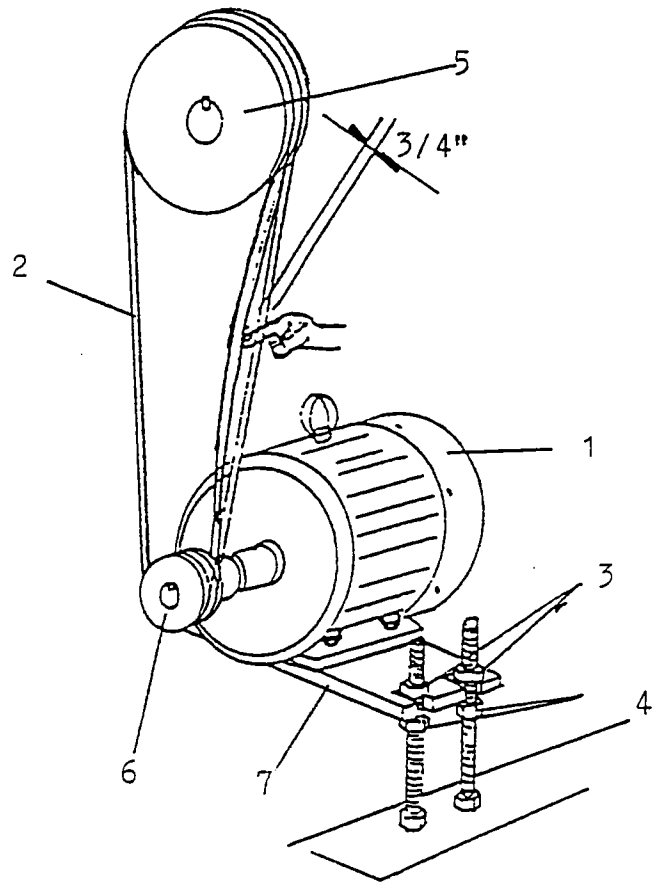
CAUTION

MAKE SURE THAT POWER IS DISCONNECTED

A. Loosen upper lock nuts (3) to free the motor mount plate (7).
B. Change set of V-Belts (2) with matching length belts.
C. Turn lower adjusting nuts (4) to raise or lower motor mount plate (7). The weight of the motor will pivot the mounting plate until proper belt tension is achieved.
D. Adjust motor mount plate until belt tension reaches approximately 3/4" tension.
E. Make sure that both lower nuts (4) have equal contact with the motor mounting plate and tighten counter nuts (3).

Please Note: New belts will wear in during the first few days of operation and need special attention before starting the machine.

V-Belt Tensioning/Changing



1. Motor
2. V-Belt
3. Nut
4. Nut
5. Pulley
6. Motor Pulley
7. Motor Mount Plate

PLATEN HEAD ADJUSTMENT

Number	Description
1	Eccentric Handle
2	Unlock Handle
3	Eccentric Shaft
4	Eccentric Cam
5	Adjustment Screw & Nut
6	Dial Gage
7	Platen
8	Idle Roller
9	Contact Drum
10	Sanding Belt

Step:

A. When handle (1) is in the position as figure shown, the platen (7) should be higher than roller approx. 0.039".

B. Move left the handle (2).

C. When moving the handle (1) to left to about 45° position, platen will be lower than roller (9) approx. 0.039" (1mm), when it is in 90° position, platen (7) lower than roller (9) about 0.078" (2mm).

D. Adjust it to the suitable condition depends on the hardness of piece to be sanded.

E. Turn handle (2) to left.

ATTENTION: If the thickness between the left and the right side of working piece is different, please use dial gage to check.

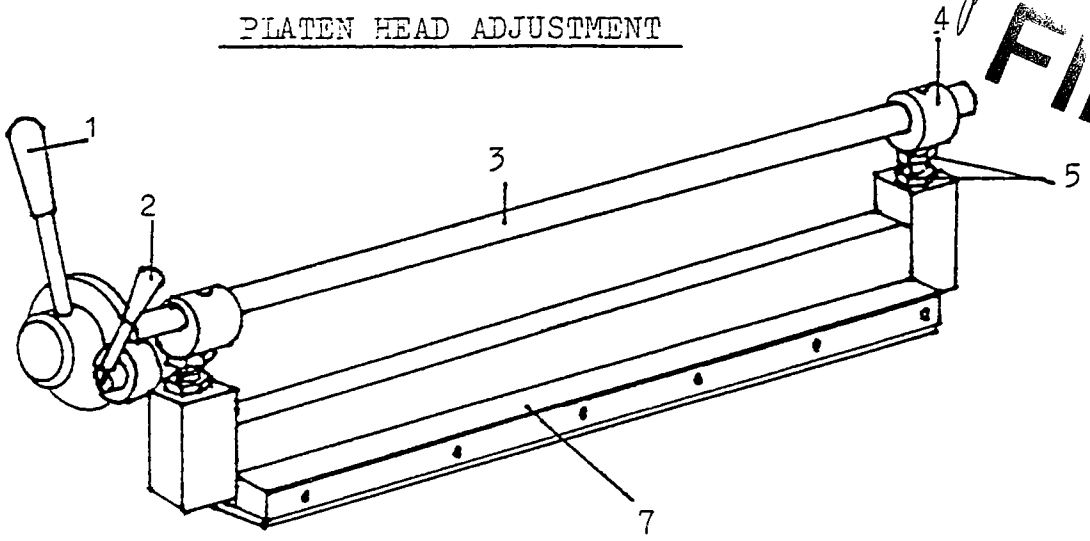
A. Down the table to suitable position.

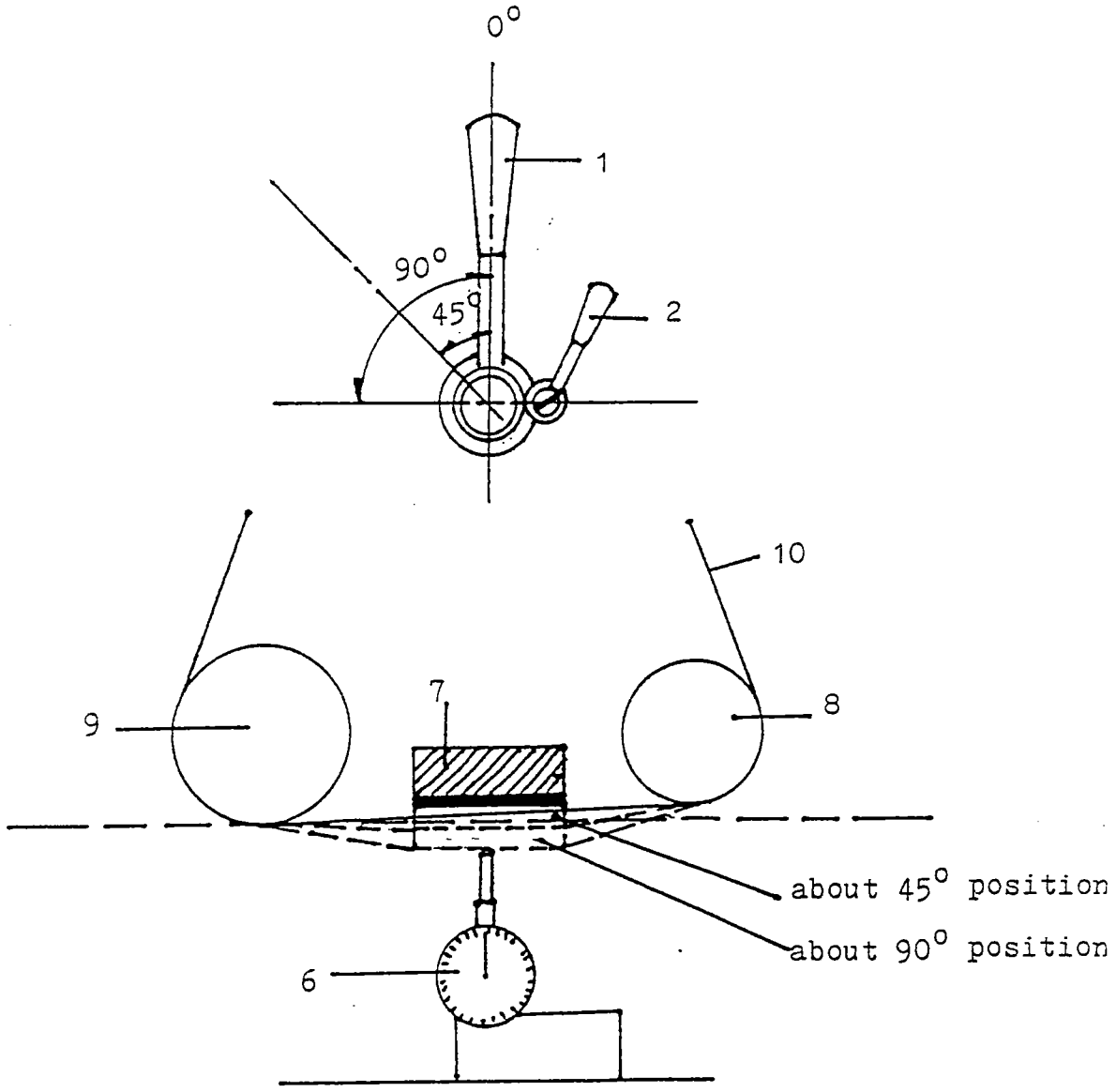
B. Put dial gage to touch the two side of platen (7) between the platen and table.

C. Loosen Nut (6), to test the pointer movement of dial gage are in the same deviation by means of moving the screw (5) up and down.

D. Tighten Nut (6).

PLATEN HEAD ADJUSTMENT





CHANGING FEED BELT

DISASSEMBLE WORK TABLE TO REPLACE CONVEYOR BELT.

A. Have power disconnected on the machine.
B. Lower the table by 3".
C. Remove safety guard (fig.1-1) and unscrew conveyor tension bolts (fig.2-A & B).
D. Take off left and right hand support plates of the front feed roller (fig.2-B) and remove the roller (fig.2-C).
E. Remove the reduction gear as one unit and separate the coupling (fig.5-1 & 4).
F. Unbolt roller bearing block (fig.5-1) and remove rear feed roller (fig.5-8).
G. Remove slide plate bolts (fig.4-1) and table support bar bolts (fig.3-1).
H. Support table on wood and prepare to slide the unit out.
I. Slide table out and remove old feed belt.
J. Slip new pre-fitted belt over table and reverse disassembly sequence.

- New Conveyor Belt - Refer to conveyor belt adjustment chapter 2-2, Keep in mind that the new belt needs to settle a bit and must show a tendency to move to the right side to make intermittent contact with the idler wheel of the air flow valve.

JWB-25P
FILE

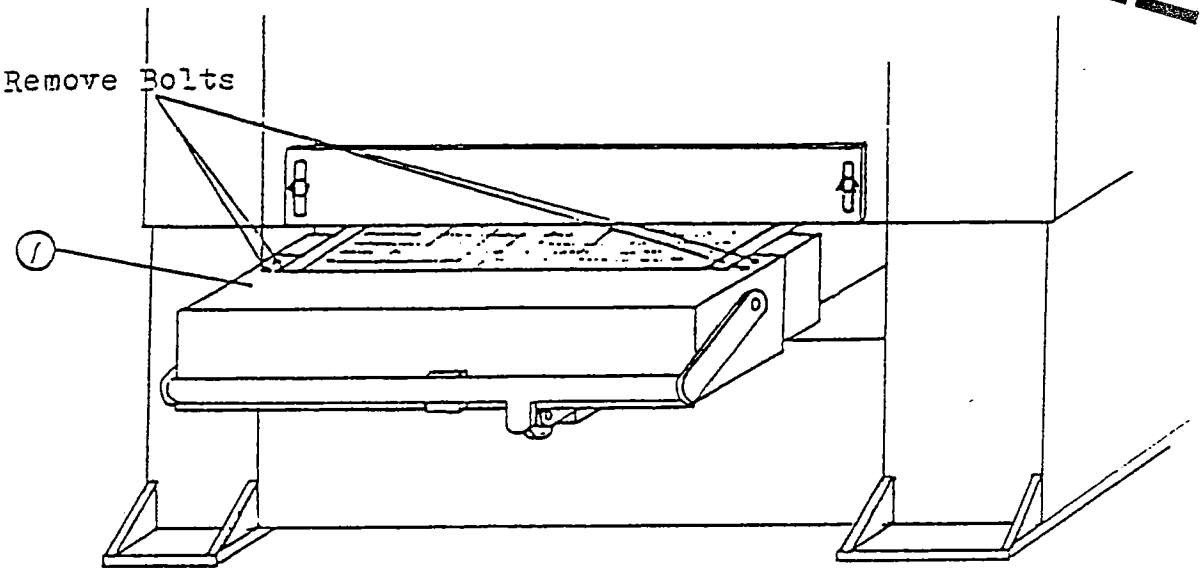


FIG. 1

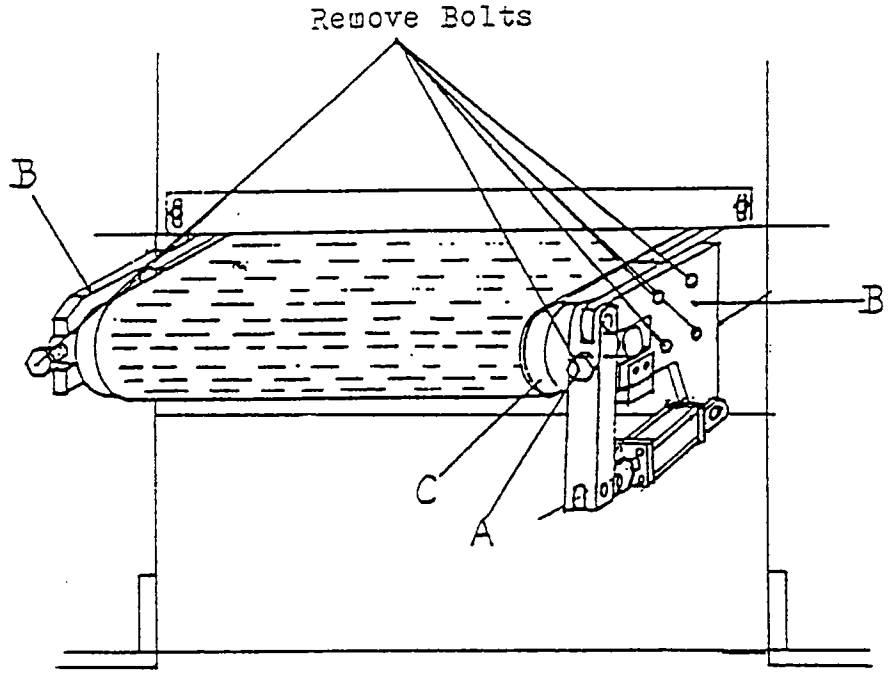


FIG. 2

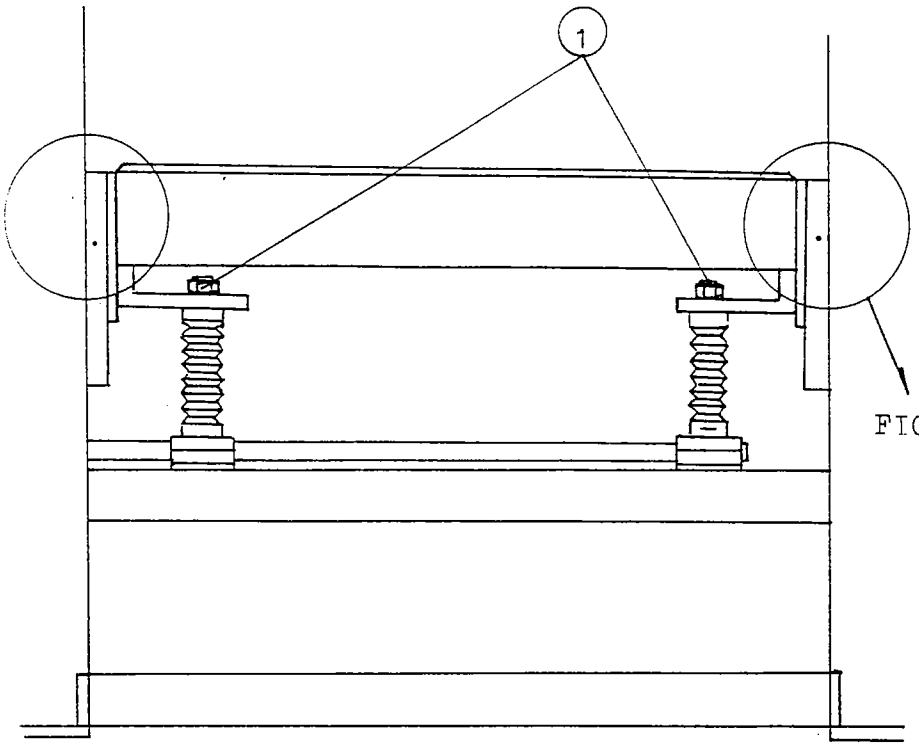


FIG. 4

FIG. 3

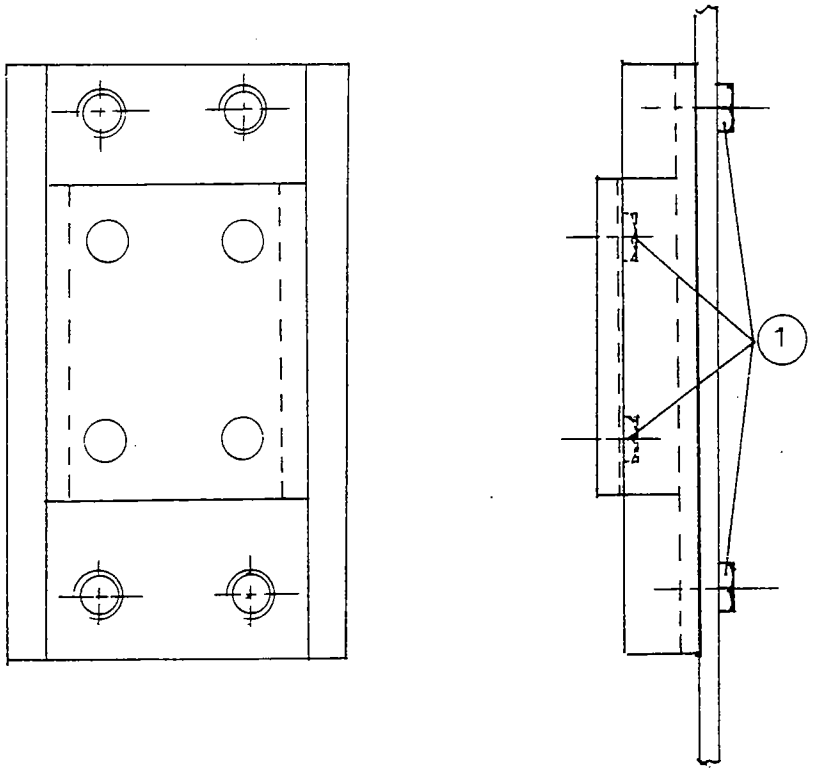
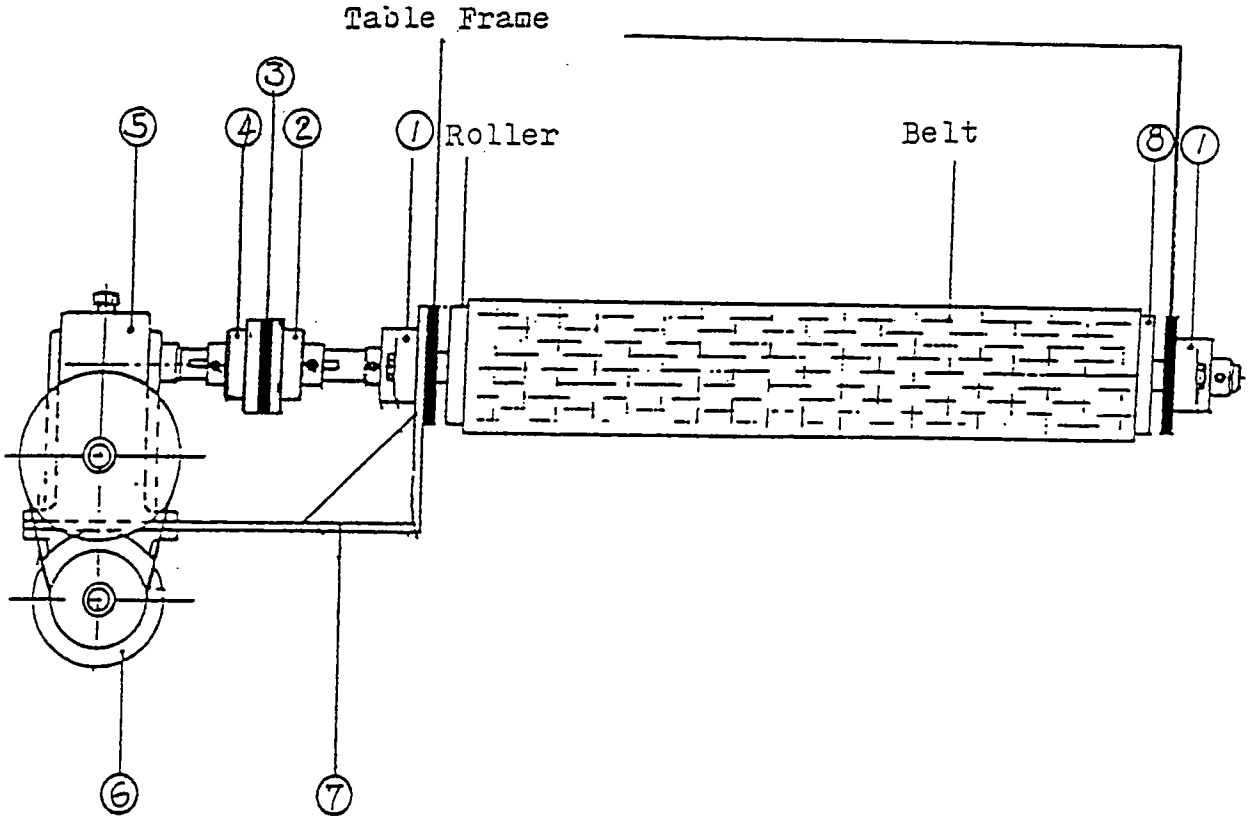


FIG. 4

JWB-25P

FILE

Changing Feed Belt (III)



The Princliple for Oscillation of Sanding Belt

When the sanding belt is driving and moving toward the inside, the edge inside the sanding belt will pass through the central line of light projected by the electric-eye (that is ray of light will be projected and also will be blocked by the light). The electric-eye is controlled by the current which can control the solenoid valve under oscillation from flying action to static action. To turn off the air flow hole which was opened, but turn on the other air flow hole which was closed. As flowing of metric atmoshpere inside the metric atmosphere pipe, the sanding belt will oscillate in order to make cylinder to change its former condition of shrink to the action of extension.
Thus, the sanding belt will move outside although it is move inside previously, then, it will break away the central line projected by the electric-eye. The above-mentioned process will be repeated again and again.

FIG. I PHOTO-ELECTRIC

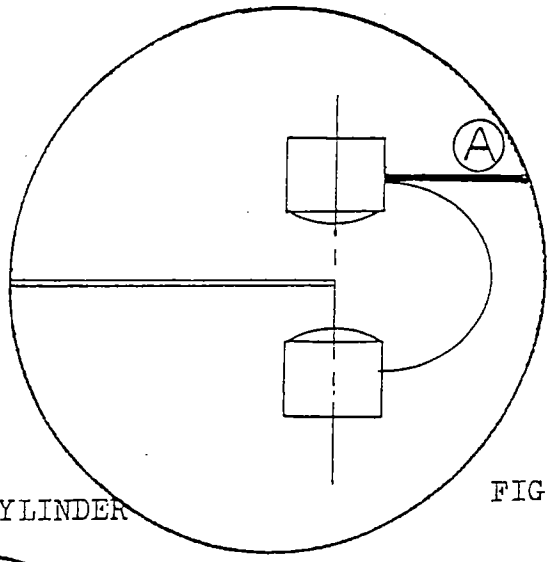


FIG. III TRACKING CYLINDER

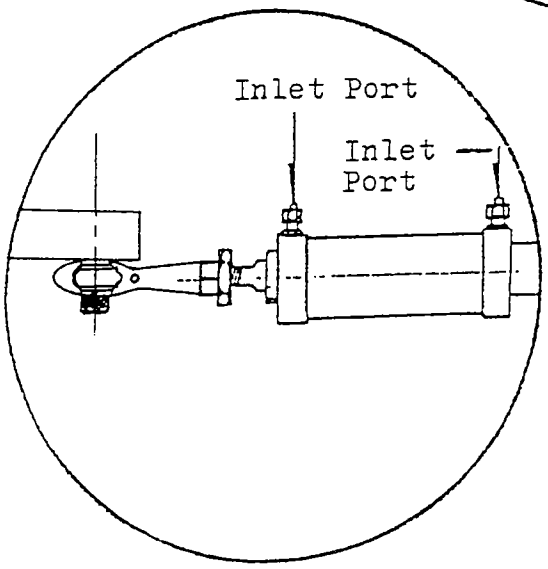
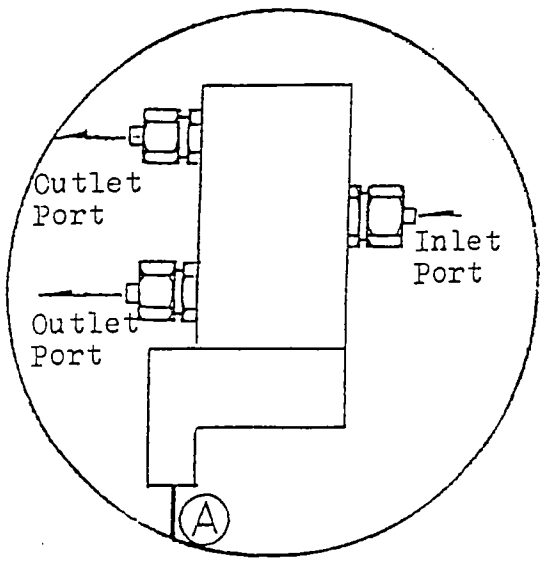


FIG.II SOLENOID VALVE



INSPECTION FOR THE OSCILLATION OF SANDING BELT

GWB-25

FILE

Step to inspect the oscillation of sanding belt:

A. Take sanding belt off.
B. Switch power off. Compressed air required at 6 atm. Do not start the machine.
C. Refer the principle for oscillation of sanding belt (page.19).
D. To cover the electric-eye with board, then, take it away. Please check if the projected bulb will be sometimes in view and sometimes hidden so as to make sure whether the electric-eye is normal or not. If the bulb can not be sometimes in view and sometimes hidden, the electric-eye is damaged, otherwise, it is normal.
E. There are two solenoid valves inside the machine (Shown as fig. 2). Covering the electric-eye with board, then, take it away. In this moment, please note if the upper solenoid valve has sound of exhausting air.
F. To notice whether the wobble plate (13) of Cylinder (10) can swing or not.

Step to repair:

G. If electric-eye is damaged please change new one.
H. If electric-eye is normal or has been changed, however, the upper solenoid valve has no sound of exhausting air, which means the solenoid valve is damaged. Please change new one.
I. If the above-mentioned conditions are normal or the parts have been changed, however, the wobble plate mentioned in the procedure 3 is still unable to swing, which means there are hollow and blend condition happened in the air piping (shown as fig.2 & fig.3), the air is stuffy. Please check it and make it swing.
J. After all procedures mentioned above were normal, install the sanding belt according to the right procedure and instruction to position in order to make the sanding belt being installed as Fig. 3 shown.

K. If there are not smooth to the oscillation of sanding belt in moving, please loosen the sanding belt (shown as fig.5 & fig.11), then move it leftward/rightward. And tightly screw it when it is normal.

L. After the "Main Motor" being pressed in "ON", you have to press the "Main Motor" in "OFF" at once.

M. To observe the condition of sanding belt in revolving and oscillating:

(1) Condition - The oscillation of sanding belt is normal, but it slightly swings toward the right.
Adjustment- Please refer to the fig.4. To loosen the set screw on the base plate of electric-eye, then, move an half of deviation for base plate of electric-eye toward the left according to the groove of screw. After it being done, please lock the screw.

(2) Condition - The oscillation of sanding belt is normal, but it slightly swings toward the left.
Adjustment- Please refer to the fig.4. To loosen the set screw on the base plate of electric-eye, then, move an half of deviation for base plate of electric-eye toward the right according to the groove of screw. After it being done, please lock the screw.

(3) Condition - The sanding belt swings toward the right.
Adjustment- 1. Please refer to the fig.6. First release the adjusting nut of cylinder (14), and there is a notch in (A) place, clockwise turn it with open-end wrench for two circles so as to fix the (14).
2. Adjust sanding belt to the proper position.
3. After the "Main Motor" being pressed in "ON", you have to press the "Main Motor" in "OFF" at once.
4. Repeat the motions of adjustment step 1,2 & 3 if sanding belt is not in normal condition.

JWB-25P

FILE

(4) Condition - The sanding belt swings toward the left.

Adjustment- 1. Please refer to the fig. 6. First release the adjusting nut of cylinder (14), and there is a notch in (A) place, counter-clockwise turn it with open-end wrench for two circles so as to fix the (14).

2. Adjust sanding belt to the proper position.
3. After the "Main Motor" being pressed in "ON", you have to press the "Main Motor" in "OFF" at once.
4. Repeat the motions of adjustment step 1, 2 & 3 if sanding belt is not in normal condition.

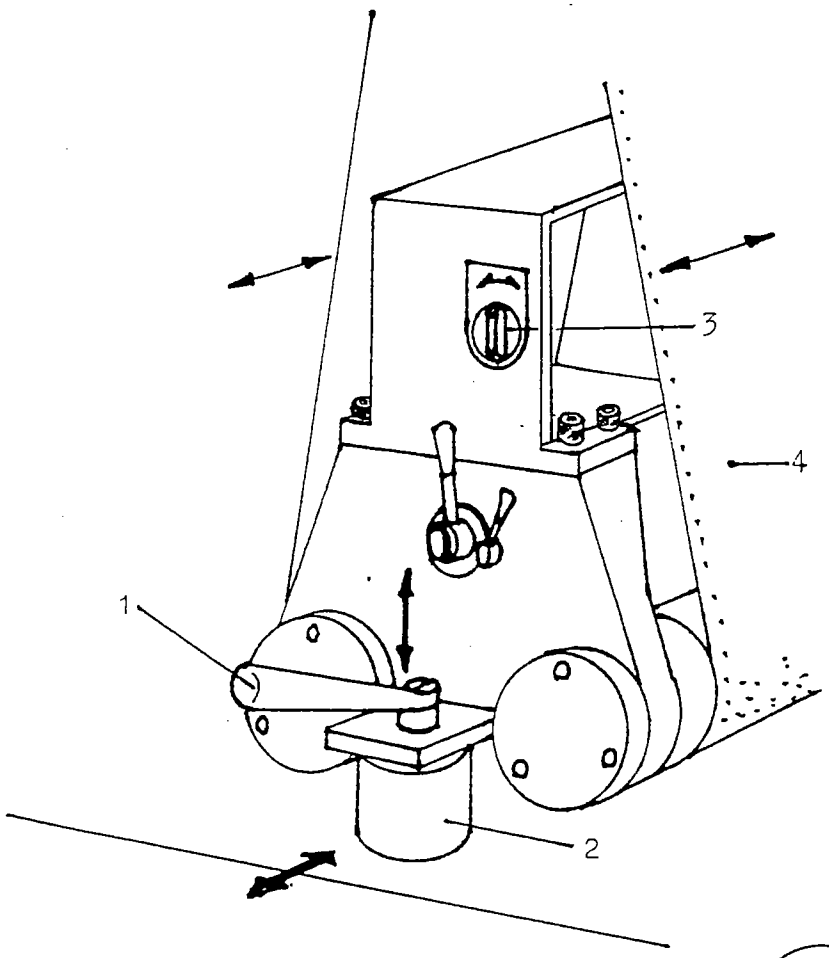


FIG. 1

1. Lock Screw
2. Spacer Block
3. Air Valve Switch
4. Sanding Belt
5. Idle Roller
6. Contact Drum

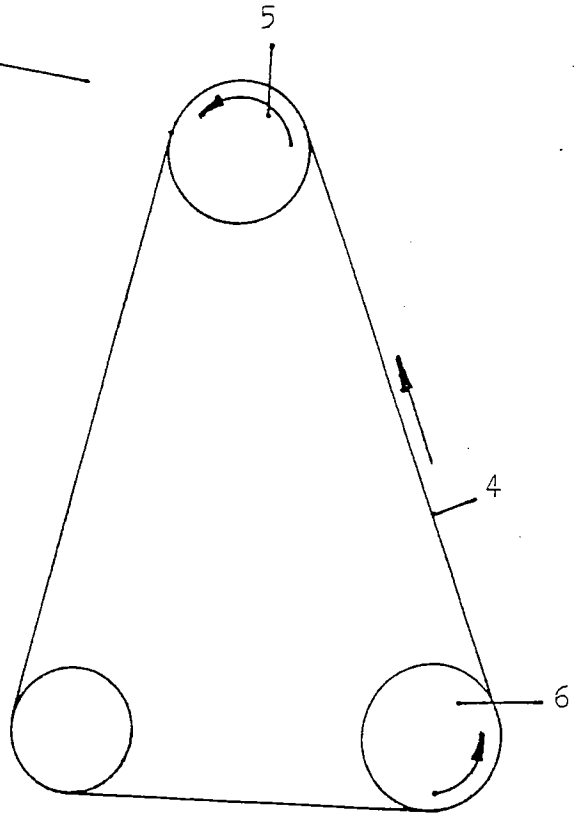


FIG. 2

INSPECTION FOR THE OSCILLATION OF SANDING BELT

GWB-29P

FILE

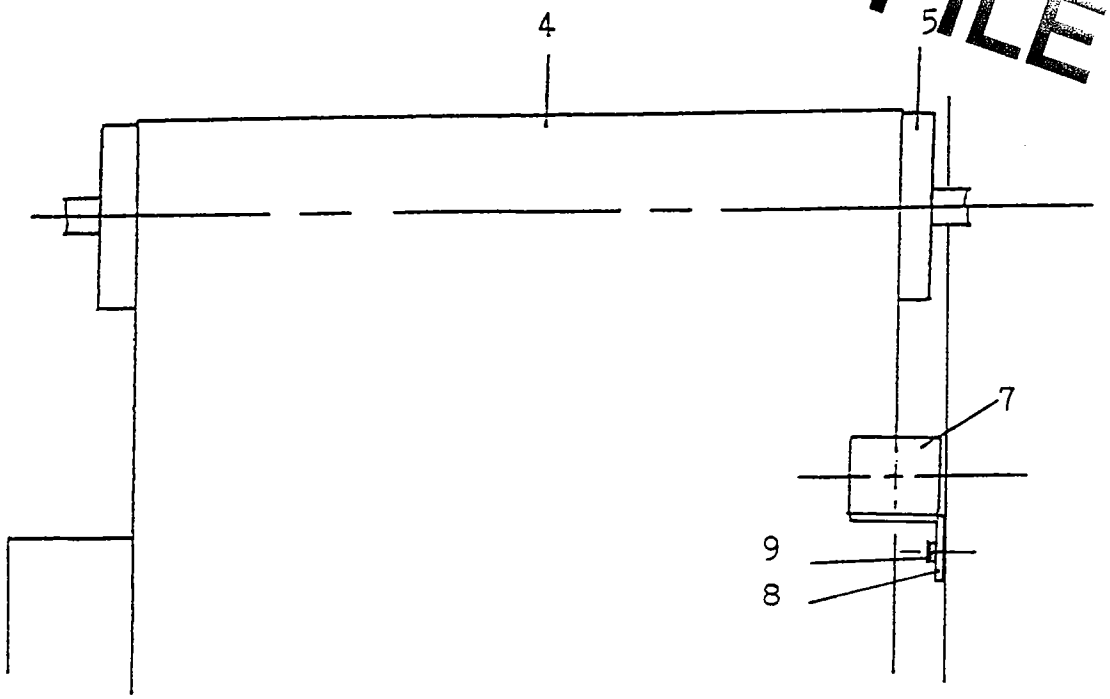


FIG. 3

4. Sanding Belt
5. Idle Roller

7. Photo-Electric
8. Photo-Electric Plate
9. Fixed Screw
15. Indicator
16. Wire Contact Box

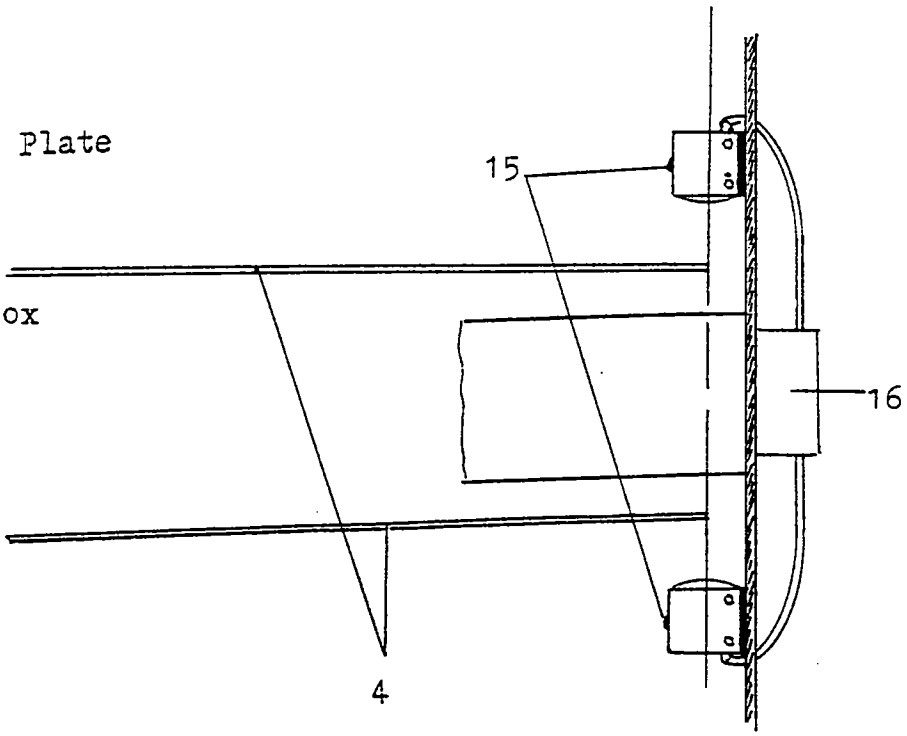


FIG. 4

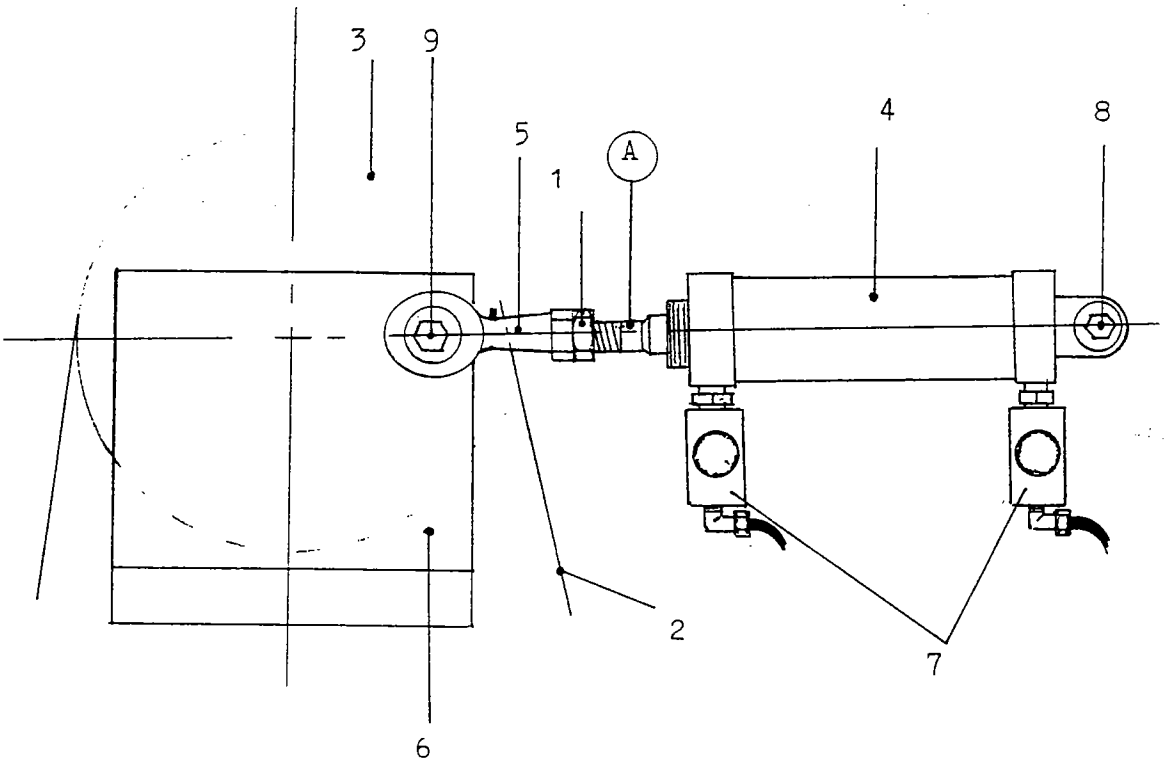


FIG. 5

1. Lock Nut
2. Sanding Belt
3. Idle Roller
4. Air Cylinder
5. Feeding Bearing
6. Wobble Spacer
7. Cut-Off Valve
8. Screw
9. Screw

CHANGING SANDING BELT

Step to change sanding belt:

A. Switch off power supply.
B. Shut off air valve switch (3) to the belt tension cylinder.
C. Remove lock screw (1), turning counter closckwise (fig.1).
D. Remove spacer block (2).
E. Remove old belt.

CAUTION

F. Make sure that arrows at the inner side of the new belt matches the rotation of the machine (fig.2).

   Make sure that sanding belt edges are not chipped or torn.

G. Insert new belt by starting first on the top tension roller and then on the contact roller (fig.2). Center the belt and avoid contact with limit switch fingers on both sides of the belt.
H. Replace spacer block and tighten lock screw (fig.1).
I. Turn "ON" air valve switch (3) for sanding belt tensioning and check that belt edges have clearancer with limit Switch fingers on both sides.

CAUTION

Machine will not start running if limit is depressed.

J. Make repeated belt position corrections if need with air valve switch (3) at "OFF" position and repeat motions of paragraph - H -.

CAUTION

Never start machine without safety check.
Never start machine without air supply.
Never start macnine in the mode of air valve.
Switch "OFF" position.

ywb-25

FILE

Changing Sending Belt

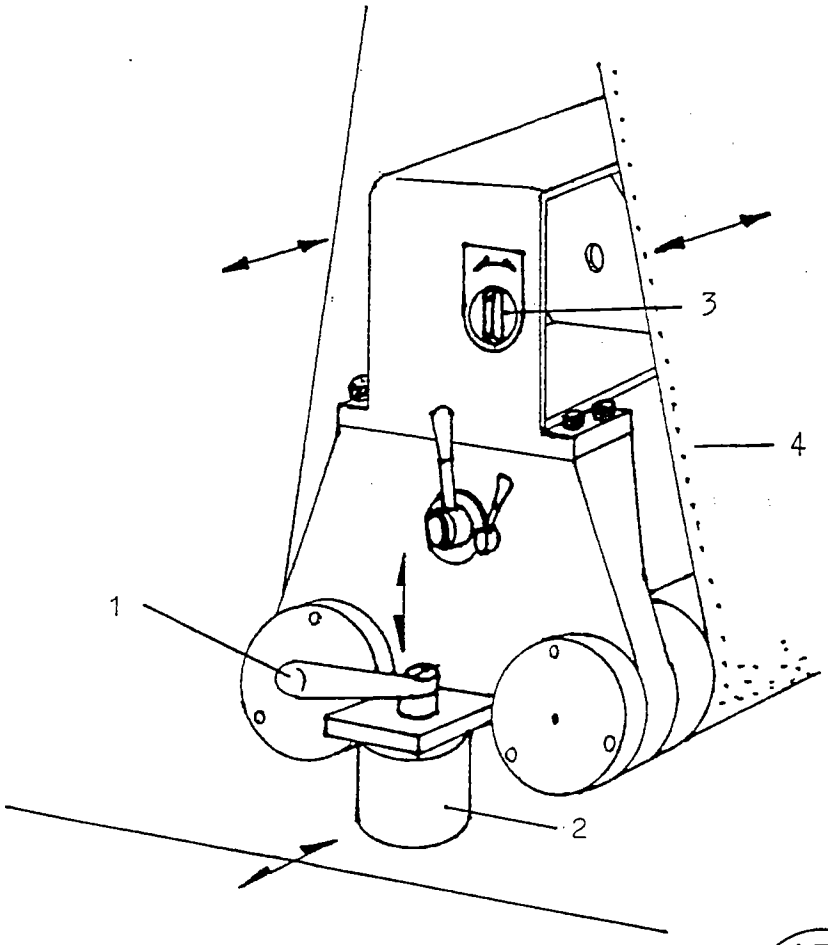


FIG. 1

1. Lock Screw
2. Spacer Block
3. Air Valve Switch
4. Sanding Belt
5. Tension Roller
6. Contact Roller

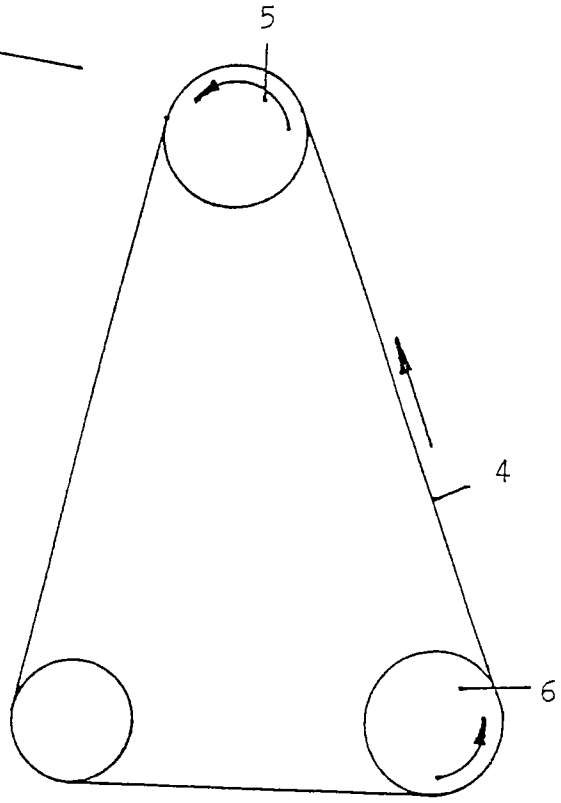
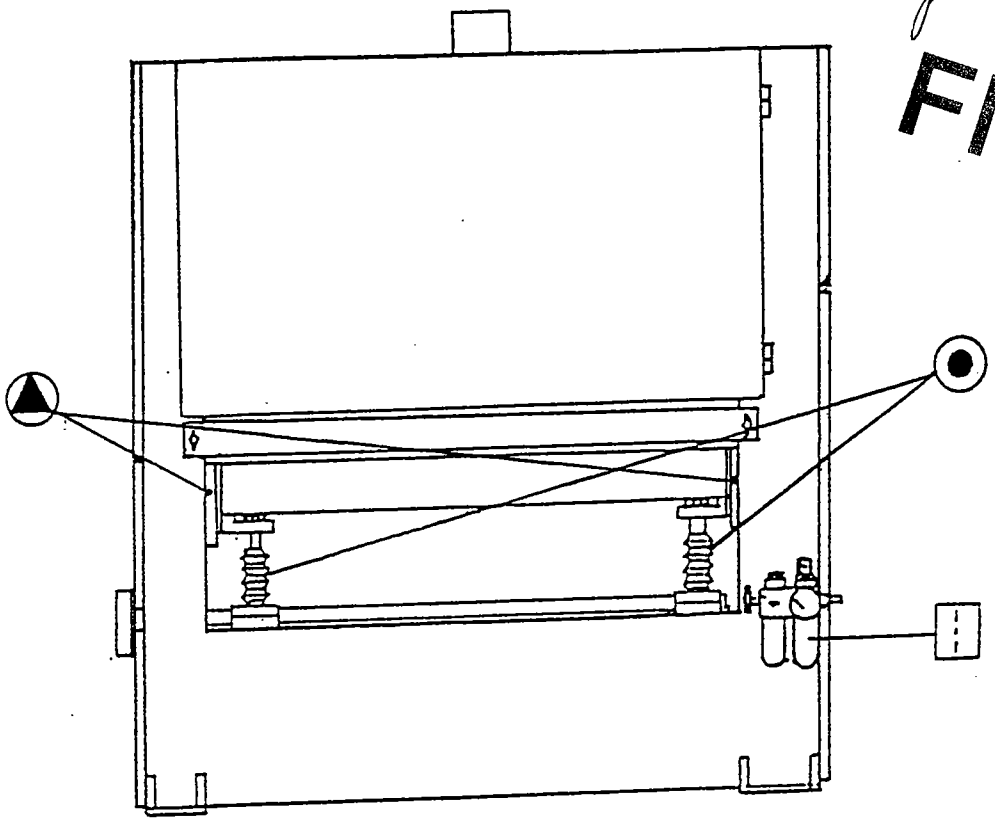
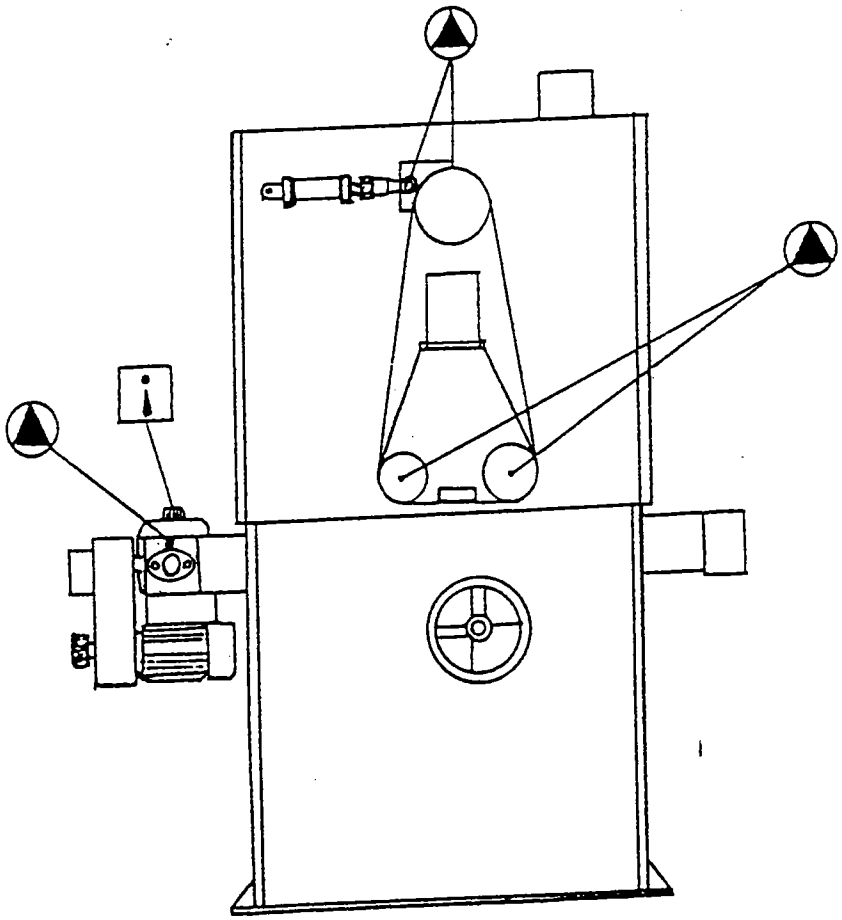


FIG. 2

JWB-25P

FILE





LUBRICATION (II)

	Grease Nipples	Monthly	Shell Alvania R2
	Oil Nipples Table Adjustment	Weekly Yearly	Shell Omala Shell Tonna T68
	Gear Box	Yearly	Shell Fett #90
	Spindles	Yearly	Shell Heavy Duty Grease

All lubrication points of the machine are indicated in red. After 15.000 operation hours all bearings have to be checked to be renewed if necessary.

Regulary lubricate the shaft and the bush of the tension unit.

JWB-25P
FILE

AIR SUPPLY UNIT

1. The machine is to be connected to an air supply unit which supplies a pressure of minimum 6 atm.
   It should be checked whether this supplies really dry and clean air. If this is not the case a special water separator and airfilter have to be installed in front of the machine, for even the slightest moist particle affects the interior of the machine and disturbs the optical operation.
   If pressure drop is lower than 6 atm. the unit has to be provided with an extra buffer tank which has to be installed between the compressor and the machine.
   Attention should be paid to the fact the the pressure drop may never be lower than 5 atm. otherwise, the belt control will be adversely affected.

2. The connection of the air supply hose into the machine has to be means of hose on the airfilter situated at the left bottomside in the machine.

3. You can check this valve by opening the main cock and reading the pressure of the manometer.
   Should this unexpectedly not fit, you should check the pressure of your unit as yet.
   Only now you can, by using a pick-lock, adjust the correct pressure by turning plug no. 1.

4. The machine should also be connected to an extraction unit of a satisfactory capacity.
   The need of the air in the suction tube has to be minimum 25 PSI whereas the capacity has to be equal to that which to be found in chapter.
   The diameter of the suction pipe is also indicated.

MAINTENANCE OF THE AIRUNIT

Maintenance:

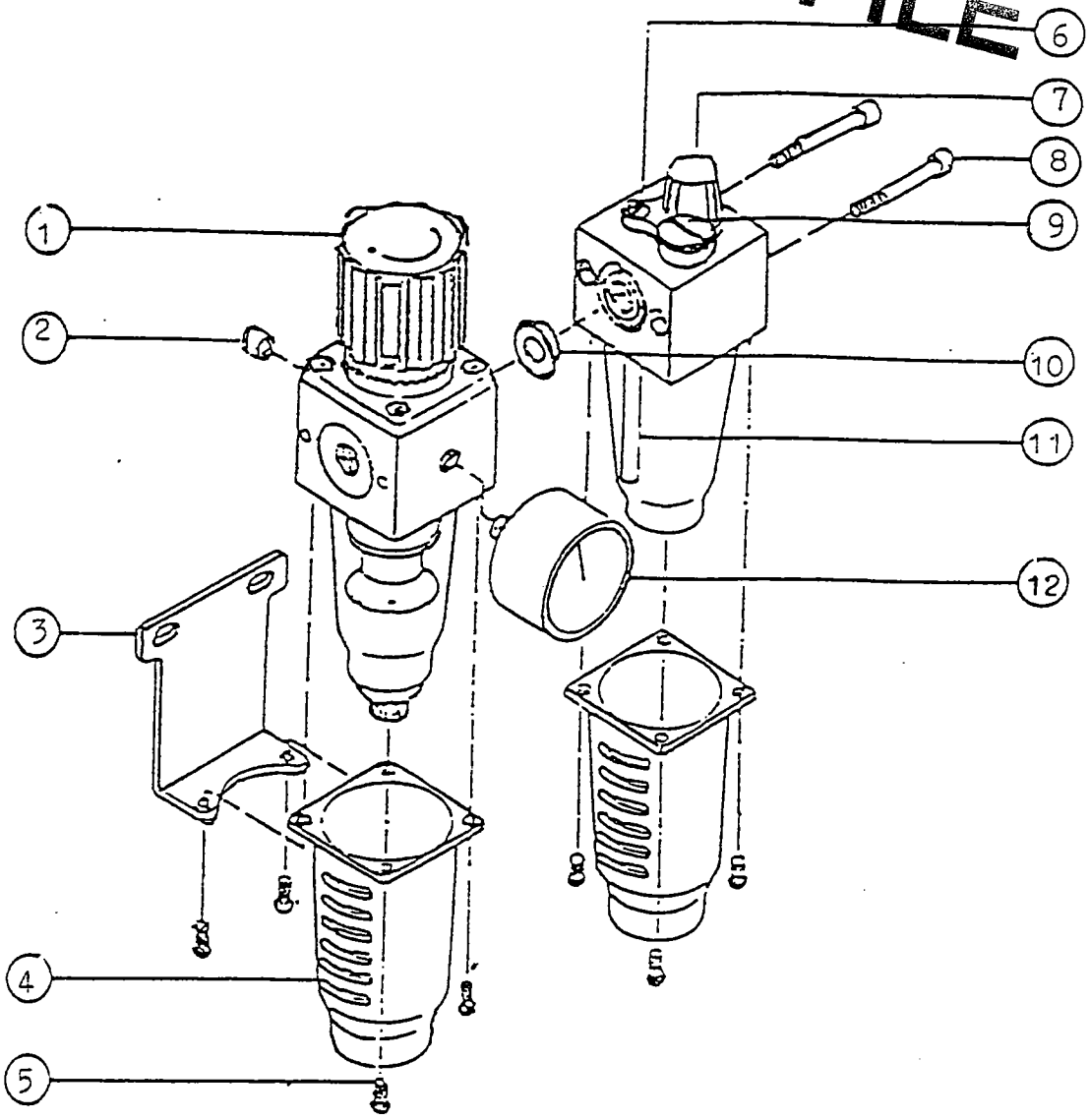
1. Daily maintenance
   Remove condensation water from glass filter.

2. Monthly maintenance
   Unlock and remove ring A of the plastic housing.
   Clean with a dry rag the plastic housing.
   Do not clean with detergent or any other liquid.
   Remove brass filter unit by unlocking nut.
   Clean with airpistol.
   Assemble properly again.

AIR SUPPLY UNIT

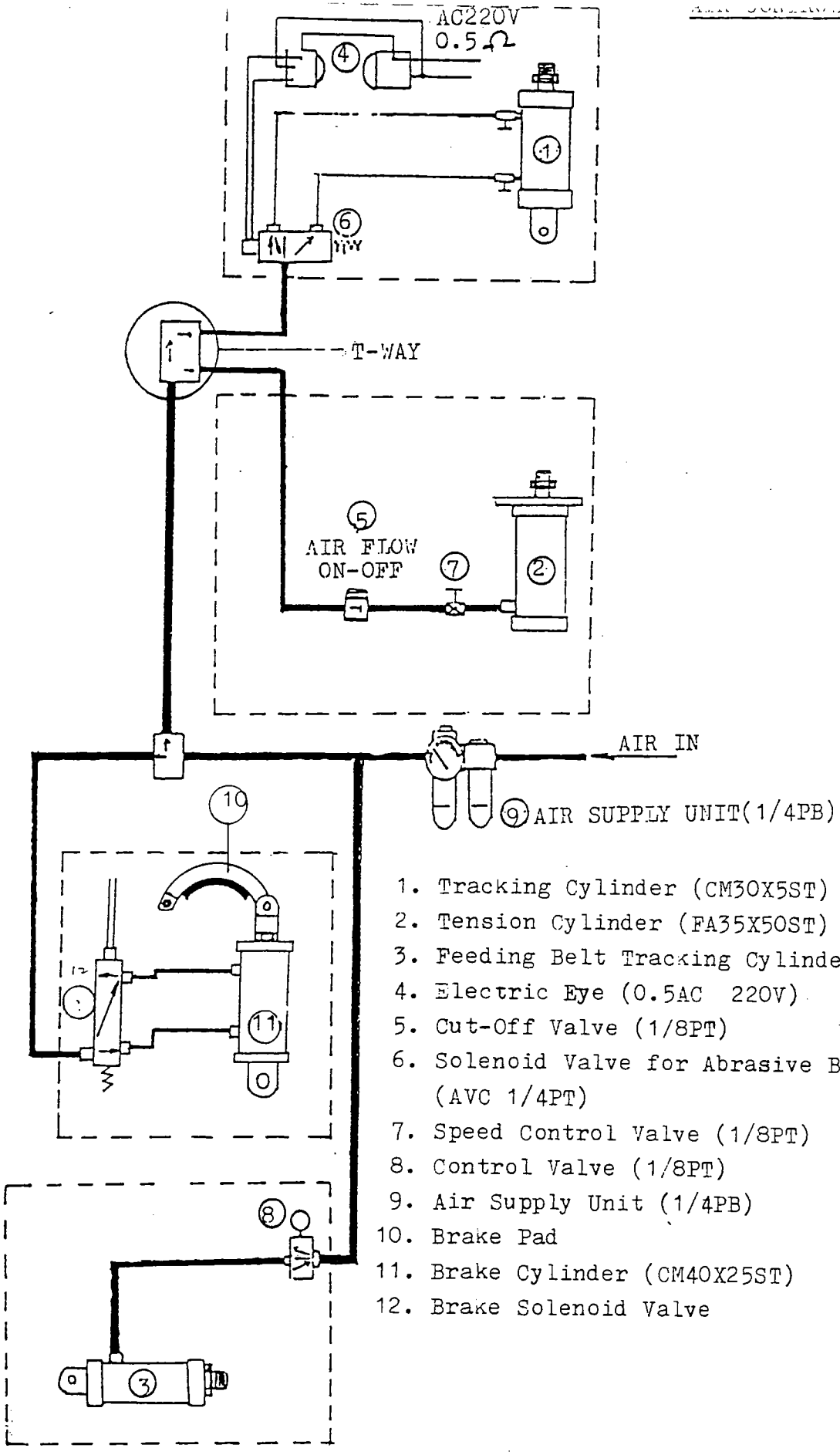
REGULATOR · FILTER · LUBRICATOR

JWB-25P FILE



1. Locking Adjusting Knob
2. Fill Head
3. Mcunting Brackets
4. Bowl Guards
5. Bowl Guards Screws
6. Oil Drip-Rate Adjusting Screws
7. Oil Glass
8. Assembly Screws
9. Oil-Fill Plug
10. C-Gasket
11. Siphon Tube Assy.
12. Pressure Gauges

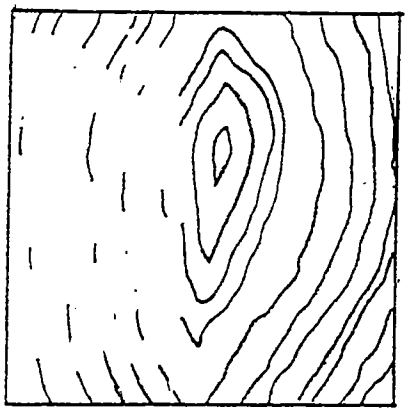
FILE

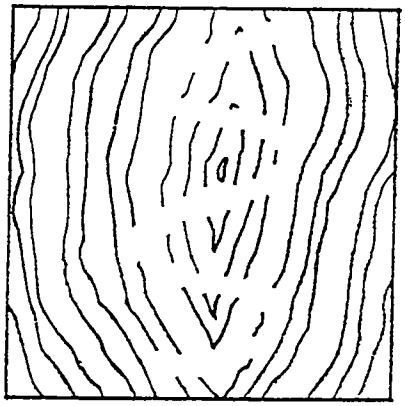


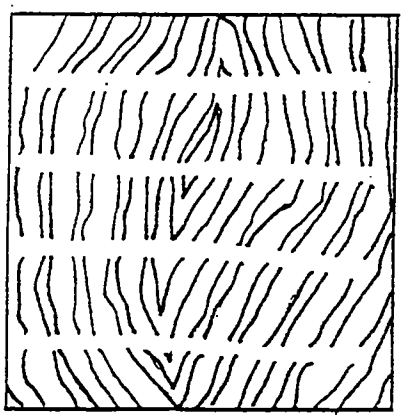
1. Tracking Cylinder (CM30X5ST)
2. Tension Cylinder (FA35X50ST)
3. Feeding Belt Tracking Cylinder (CB50X25ST)
4. Electric Eye (0.5AC 220V)
5. Cut-Off Valve (1/8PT)
6. Solenoid Valve for Abrasive Belt Oscillation (AVC 1/4PT)
7. Speed Control Valve (1/8PT)
8. Control Valve (1/8PT)
9. Air Supply Unit (1/4PB)
10. Brake Pad
11. Brake Cylinder (CM40X25ST)
12. Brake Solenoid Valve

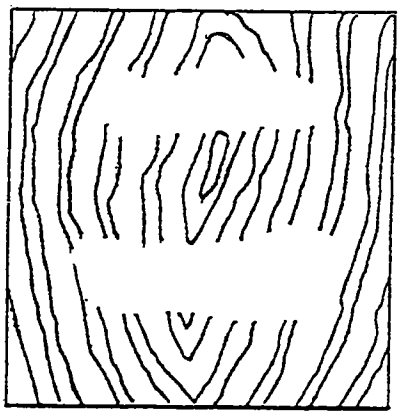
DEFICIENCES IN THE SANDING PATTERN:

1. Notches of grooves in the work piece straight strip
   CAUSE: Dirty pressure bar.
2. Snake-marks on a part of the working piece.
   CAUSE: Local damage of the sanding belt.
3. Striaght parallel running stripes over the entire width of the working piece.
   CAUSE: Joint of the sanding belt is too thick or open.
4. Gleaming spots on the wood.
   CAUSE: * The sanding belt is too old.
   * The rear pressure bar is too low.
   * The contact roller is too high.









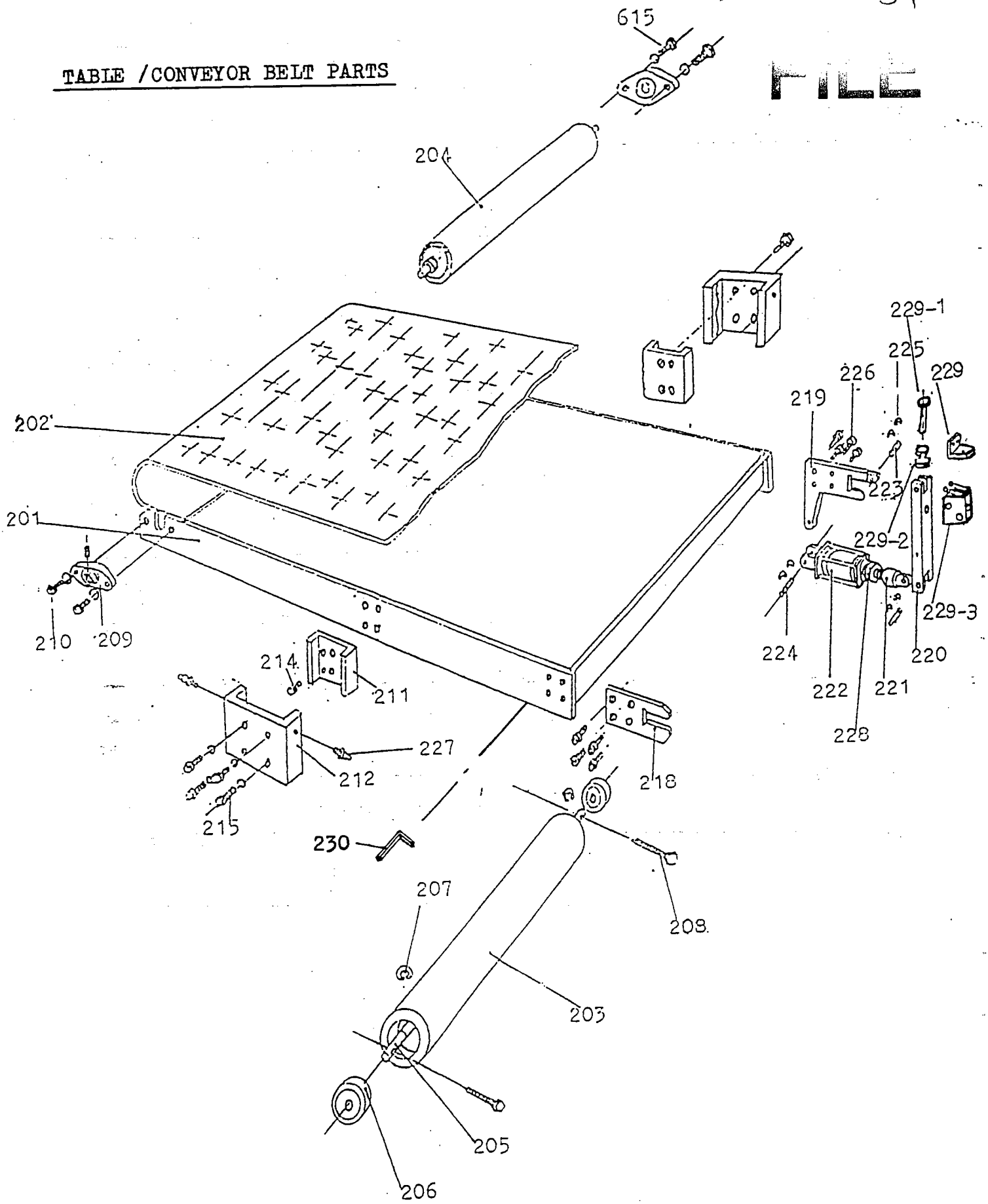
DEFICIENCES DURING THE SANDING OPERATION

SIGNS	CAUSE
The stock to be sanded is thinner at the beginning.	The rear pressure bar is too low in relation to the contact roller.
The stock to be sanded is thinner at the end.	The front pressure bar is too low in relation to the contact roller.
The sanding paper clogs too quickly.	The grit of the sanding paper is too fine. Too much material is sanded off. The wood is too oily and clogs the abrasive grains too quickly. The exhaust is insufficient. There is too much dirt or glue on the wood. The wood is too moist.
Too much roundings occur along the edges when solid wood is sanded.	Too much material is removed so that the contact roller is pressed too much.
Differences in thickness between the left and the right side of the working piece.	The table is not correct position in relation to the contact roller. (See checking page chapter Q) The front pressure bar is not in a correct position in relation to the contact roller.
Differences in thickness between the front and back side of the working piece.	Through feed speed is too high. Too much stock-removal. The sanding paper is too fine in relation to the stock-removal.
The work piece slips on the conveyor belt.	Too small pressure between the pressure bar, working piece and/ or table working piece. Too much dust on the conveyor belt The rear pressure bar is too low, so that this stops the work piece.

JWB-25P

FILE

TABLE /CONVEYOR BELT PARTS

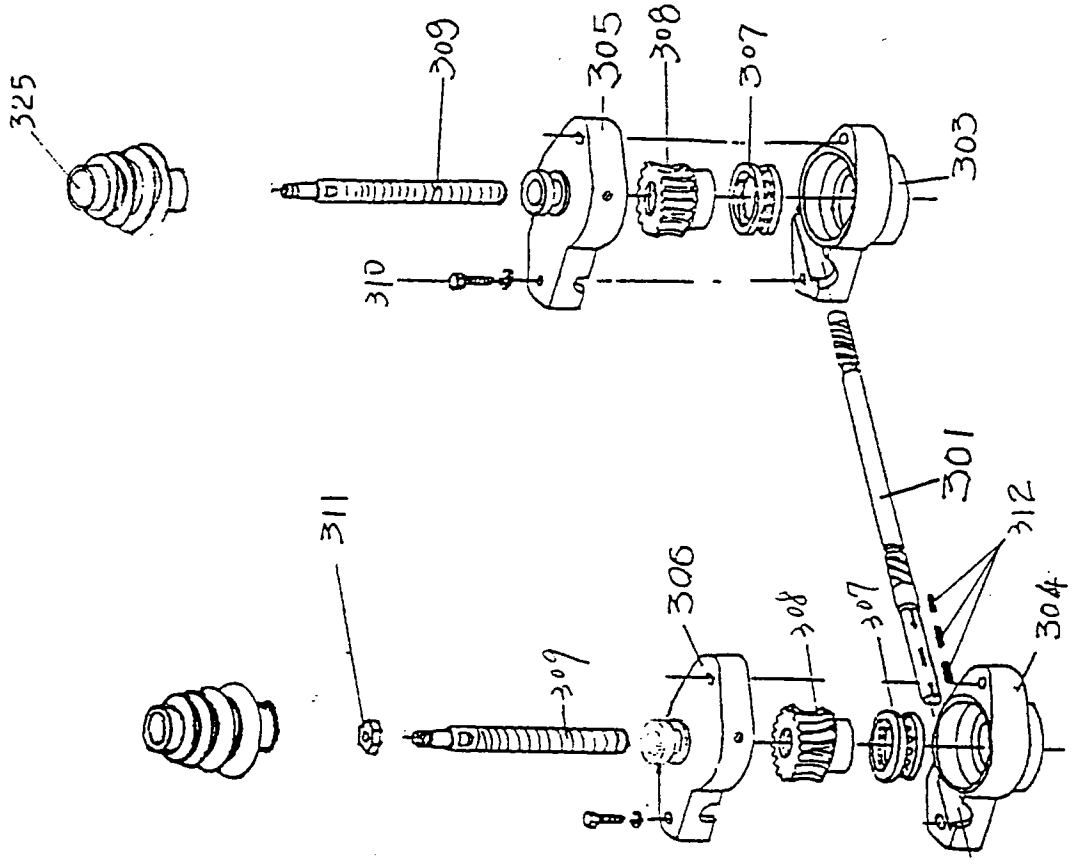


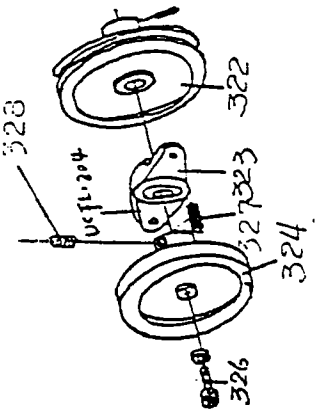
Item	Part No.	Quantity	Description
201	JWB-25201	1	Table
202	JWB-25202	1	Conveyor Belt
203	JWB-25203	1	Roller Tube
204	JWB-25204	1	Rear Feeding Roller
205	JWB-25205	1	Roller Tube Bar
206	JWB-25206	2	Bearing (6205 2RS)
207	JWB-25207	2	Spring Ring (C15)
208	JWB-25208	2	Adjustable Screw
209	JWB-25209	2	Bearing (UCFL-205)
210	JWB-25210	4	Screw
211	JWB-25211	2	Inner Slide Plate
212	JWB-25212	2	Outer Slide Plate
215	JWB-25215	4	Screw
218	JWB-25218	1	Roller Support
220	JWB-25220	1	Conveyor Belt Adjusting Fork
221	JWB-25221	1	Cylinder Joint
222	JWB-25222	1	Cylinder (ST-50)
223	JWB-25223	2	Setting Pin
224	JWB-25224	1	Setting Pin
225	JWB-25225	6	Spring Ring
226	JWB-25226	8	Screw
229	JWB-25229	1	Conveyor Belt Automatic Oscilation Combination Founddation
229-1	JWB-25229-1	1	Conveyor Belt Automatic Oscilation Wheel Shaft
229-2	JWB-25229-2	1	Conveyor Belt Automatic Oscilation Wheel
229-3	JWB-25229-3	1	Micro Machine Valve

JWB-25P

FILE

TABLE DRIVE PARTS





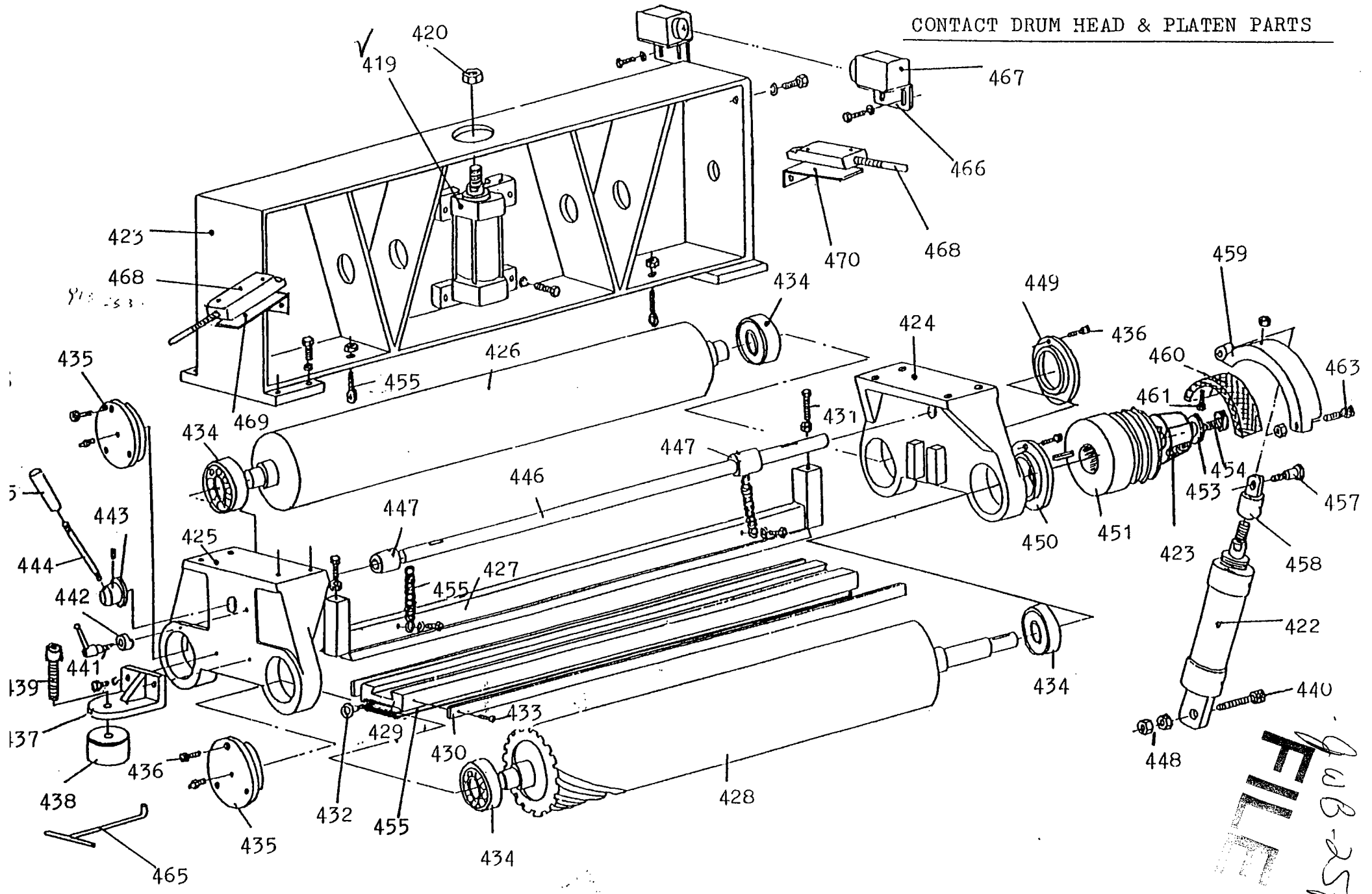
4 WB-25

FILE

TABLE DRIVE PARTS

Item No.	Part No.	Quantity	Description
301	JWB-25301	1	Shaft-Front
303	JWB-25303	1	Bottom Worm Case-Right
304	JWB-25304	1	Bottom Worm Case-Left
305	JWB-25305	1	Top Worm Case-Right
306	JWB-25306	1	Top Worm Case-Left
307	JWB-25307	2	Thrust Bearing (2907)
308	JWB-25308	2	Hoist, Axle Spiral
309	JWB-25309	2	Axle Sprial
310	JWB-25310	4	Screw & Washer
311	JWB-25311	2	Nut
312	JWB-25312	3	Key
322	JWB-25322	1	Pulley
323	JWB-25323	1	Bearing (#UCFL204)
324	JWB-25324	1	Hand Wheel
325	JWB-25325	2	Rubber Loop
326	JWB-25326	1	Screw & Washer
327	JWB-25327	1	Key
328	JWB-25328	1	Screw

CONTACT DRUM HEAD & PLATEN PARTS



PLATEN HEAD PARTS

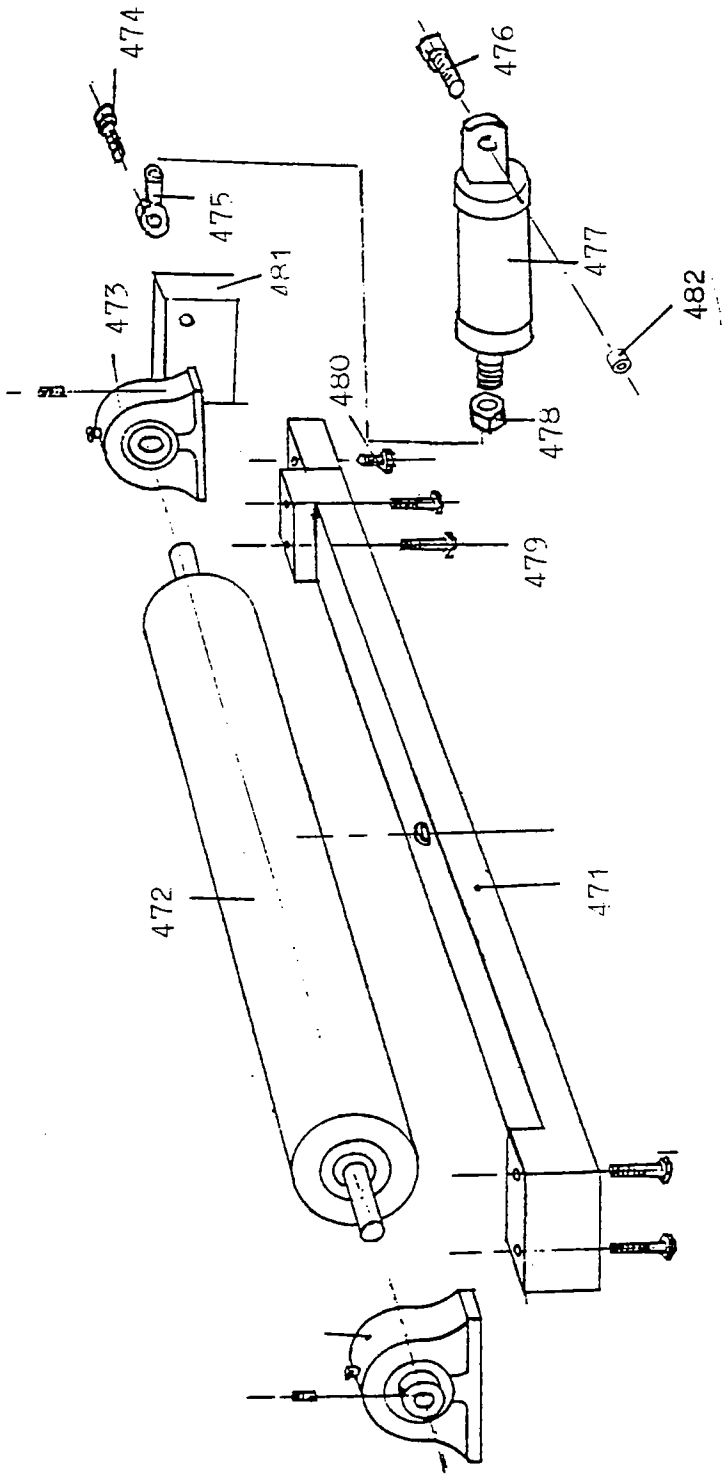
Item No.	Part No.	Quantity	Description
423	JWB-25423	1	Cantilever
424	JWB-25424	1	Drum Supporter-Right
425	JWB-25425	1	Drum Supporter-Left
426	JWB-25426	1	Drum
427	JWB-25427	1	Pad
428	JWB-25428	1	Rubber Roller
429	JWB-25429	1	Pad Slider
430	JWB-25430	2	Graphite Cloth Fixing Plate
431	JWB-25431	2	Adjusting Screw
432	JWB-25432	1	Screw Ring
433	JWB-25433	8	Screw
434	JWB-25434	4	Bearing (#6205 2RS)
435	JWB-25435	2	Bearing Cover
436	JWB-25436	12	Screw (ø1/4")
437	JWB-25437	1	Supporting Base
438	JWB-25438	1	Tracking Fork
439	JWB-25439	1	Screw (ø1/2")
440	JWB-25440	2	Screw (ø5/16")
441	JWB-25441	1	Unlock Screw (ø1/4")
442	JWB-25442	1	Fixing Ring
443	JWB-25443	1	Link Head
444	JWB-25444	1	Screw (ø3/8")
445	JWB-25445	1	Handle
446	JWB-25446	1	Adjustable Handle
447	JWB-25447	2	Eccentric Sleeve
448	JWB-25448	2	Nut (1/2")
449	JWB-25449	1	Bearing Cover
450	JWB-25450	1	Bearing Cover
451	JWB-25451	1	Pulley
453	JWB-25453	1	Unlock Plate
454	JWB-25454	1	Unlock Screw
455	JWB-25455	1	Plumbage Canvas Glve Advance

JWB-25P

FILE

Item No.	Part No.	Quantity	Description
455	JWB-25455	2	Spring
456	JWB-25456	2	Screw
457	JWB-25457	1	Screw
458	JWB-25458	1	Cylinder Joint
459	JWB-25459	1	Air Brake
460	JWB-25460	1	Brake Pad
461	JWB-25461	1	Screw & Nut
462	JWB-25462	1	Screw & Nut
463	JWB-25463	1	Screw & Nut
464	JWB-25464	1	Pulley Inner Lock Sleeve
465	JWB-25465	1	Draw Bar
466	JWB-25466	2	Electric Eye Fixed Base
467	JWB-25467	2	Electric Eye
468	JWB-25468	2	Limit Switch
469	JWB-25469	1	Limit Switch Fixed Base-Right
470	JWB-25470	1	Limit Switch Fixed Base-Left

IDLE ROLLER

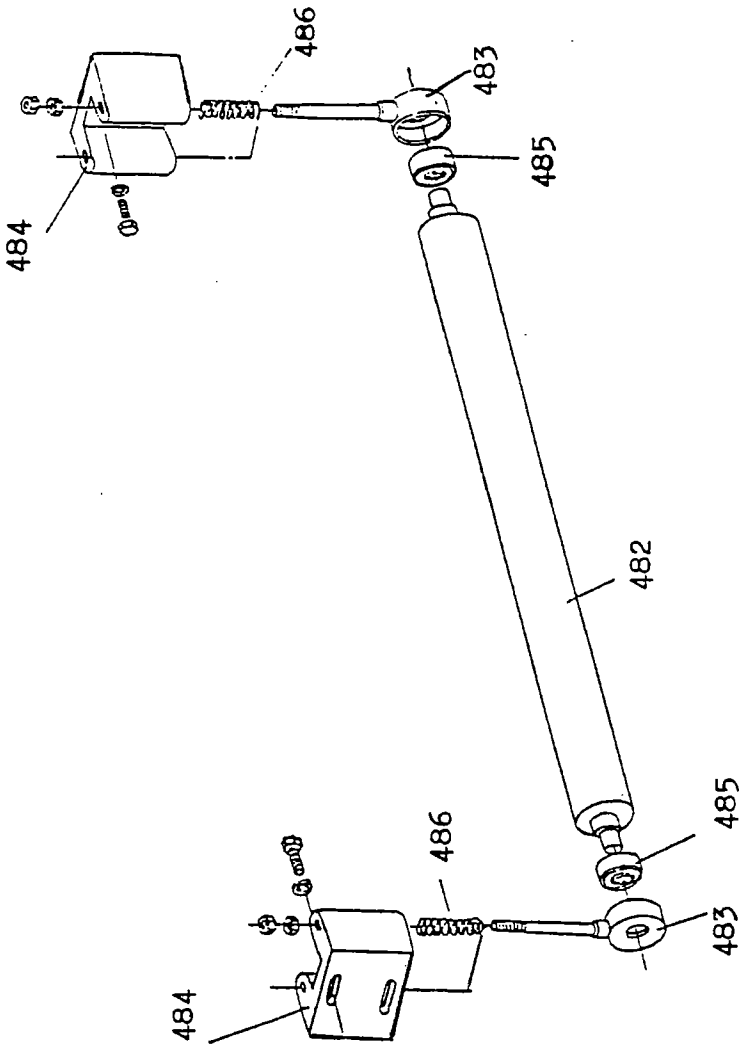


IDLE ROLLER

JWB-25P FILE

Item No.	Part No.	Quantity	Description
471	JWB-25471	1	Idle Roller Yoke
472	JWB-25472	1	Idle Roller
473	JWB-25473	2	Ball Bearing (#UCPA-205)
474	JWB-25474	1	Screw
475	JWB-25475	1	Bearing (#PHS-8)
476	JWB-25476	1	Screw
477	JWB-25477	1	Cylinder
478	JWB-25478	1	Cylinder Nut
479	JWB-25479	4	Screw & Spring Washer
480	JWB-25480	2	Screw & Spring Washer
481	JWB-25481	1	Flag
482	JWB-25482	1	Copper Cover

FEEDING ROLLER PARTS



FEEDING ROLLER PARTS

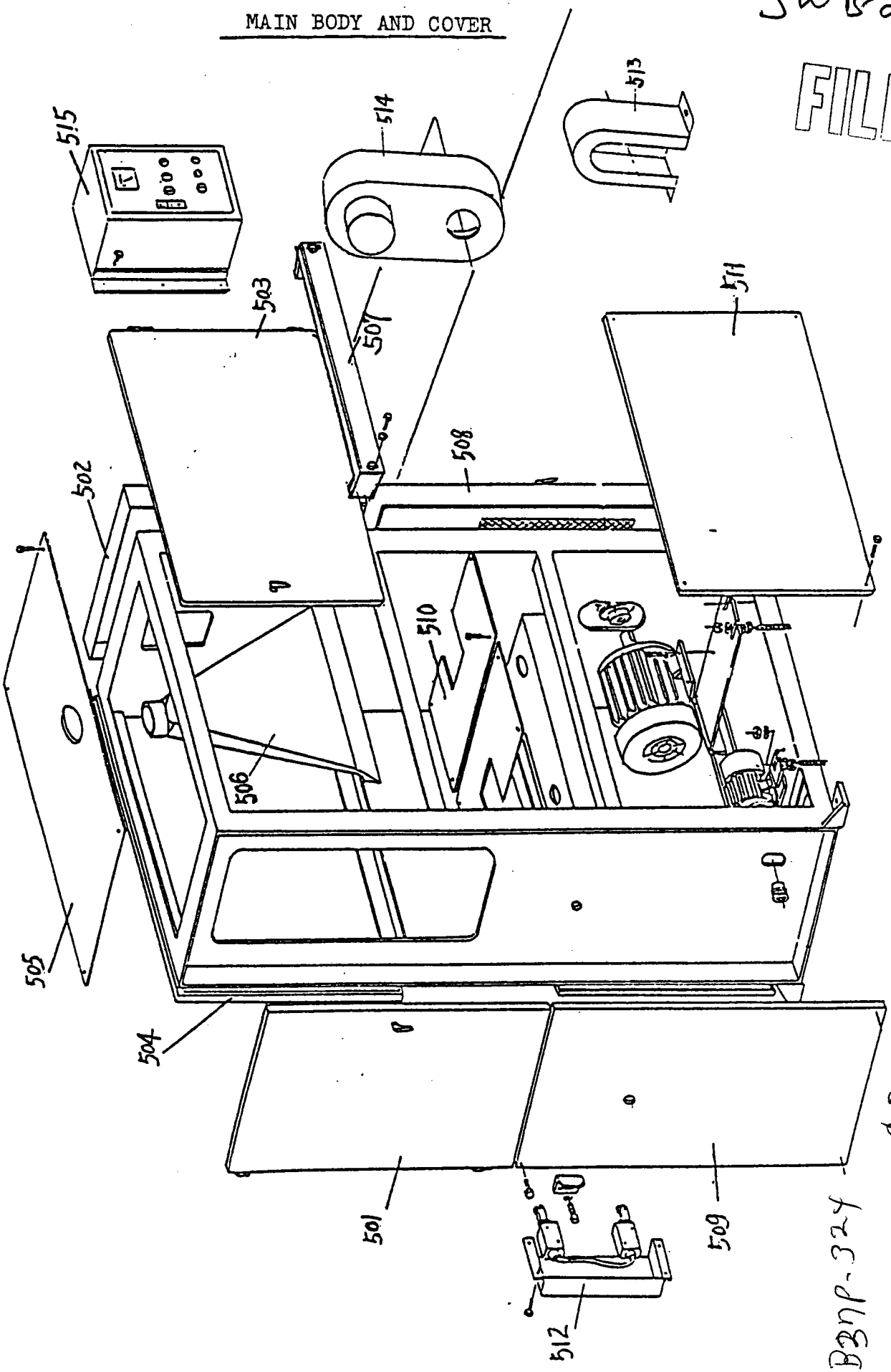
JWB-25P FILE

Item No.	Part No.	Quantity	Description
482	JWB-25482	4	Feeding Roller-Front & Rear
483	JWB-25483	8	Supporting Seat
484	JWB-25484	2	Feeding Roller Bracket
485	JWB-25485	2	Feeding Roller Bracket
486	JWB-25486	8	Bearing (#6002 2RS)
487	JWB-25487	2	Spring

JWB-25A

FILE

MAIN BODY AND COVER



JWB3NP-324 # 325 handle

Hand wheel

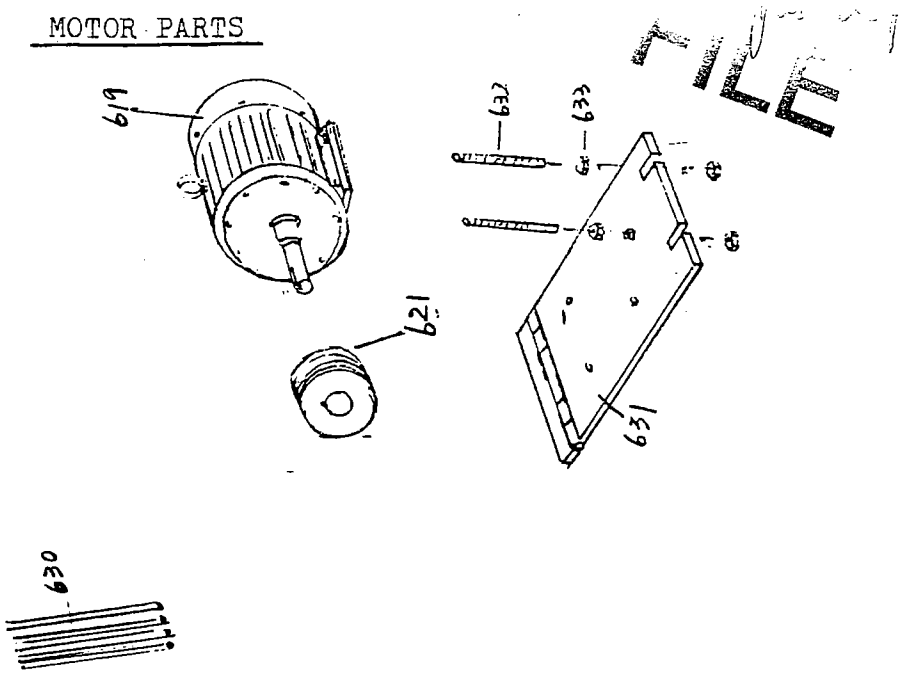
JWB-25P

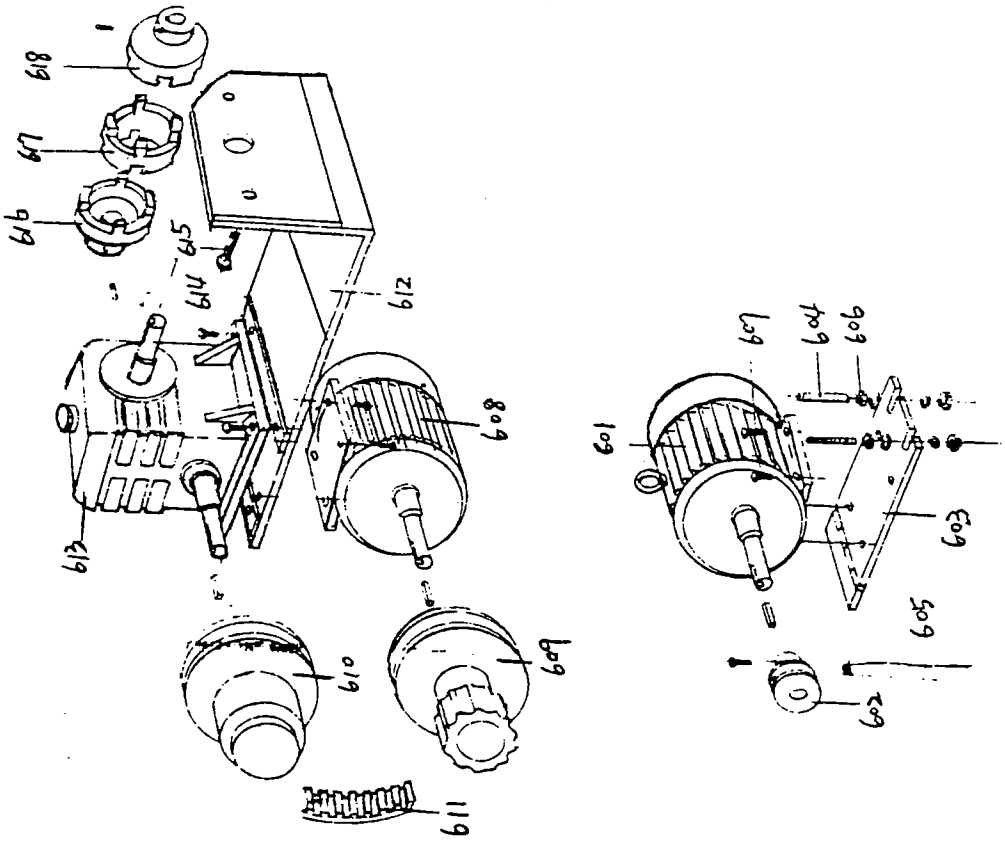
FILE

MAIN BODY AND COVER

Item No.	Part No.	Quantity	Description
501	JWB-25501	1	Left Side Support With Cover
502	JWB-25502	1	Right Side Support With Cover
503	JWB-25503	1	Front Cover
504	JWB-25504	1	Rear Cover
505	JWB-25505	1	Top Cover
506	JWB-25506	2	Dust Collect Hood
507	JWB-25507	1	Front Port Cover
508	JWB-25508	1	Motor Cover
509	JWB-25509	1	Left Botton Cover
510	JWB-25510	2	Dust Proof Plate
511	JWB-25511	1	Botton Cover
512	JWB-25512	1	Gear Cover
513	JWB-25513	1	Gear Reducer Shaft Coupling
514	JWB-25514	1	Gear Reducer Motor Cover
515	JWB-25515	1	Control Panel
516	JWB-25516	1	Feed Damper
517	JWB-25517	1	Safety Switch Bar
518	JWB-25518	2	Screw & Nut
519	JWB-25519	1	Micro to Open and Close Seat

MOTOR PARTS


619
621
632
633
631
630

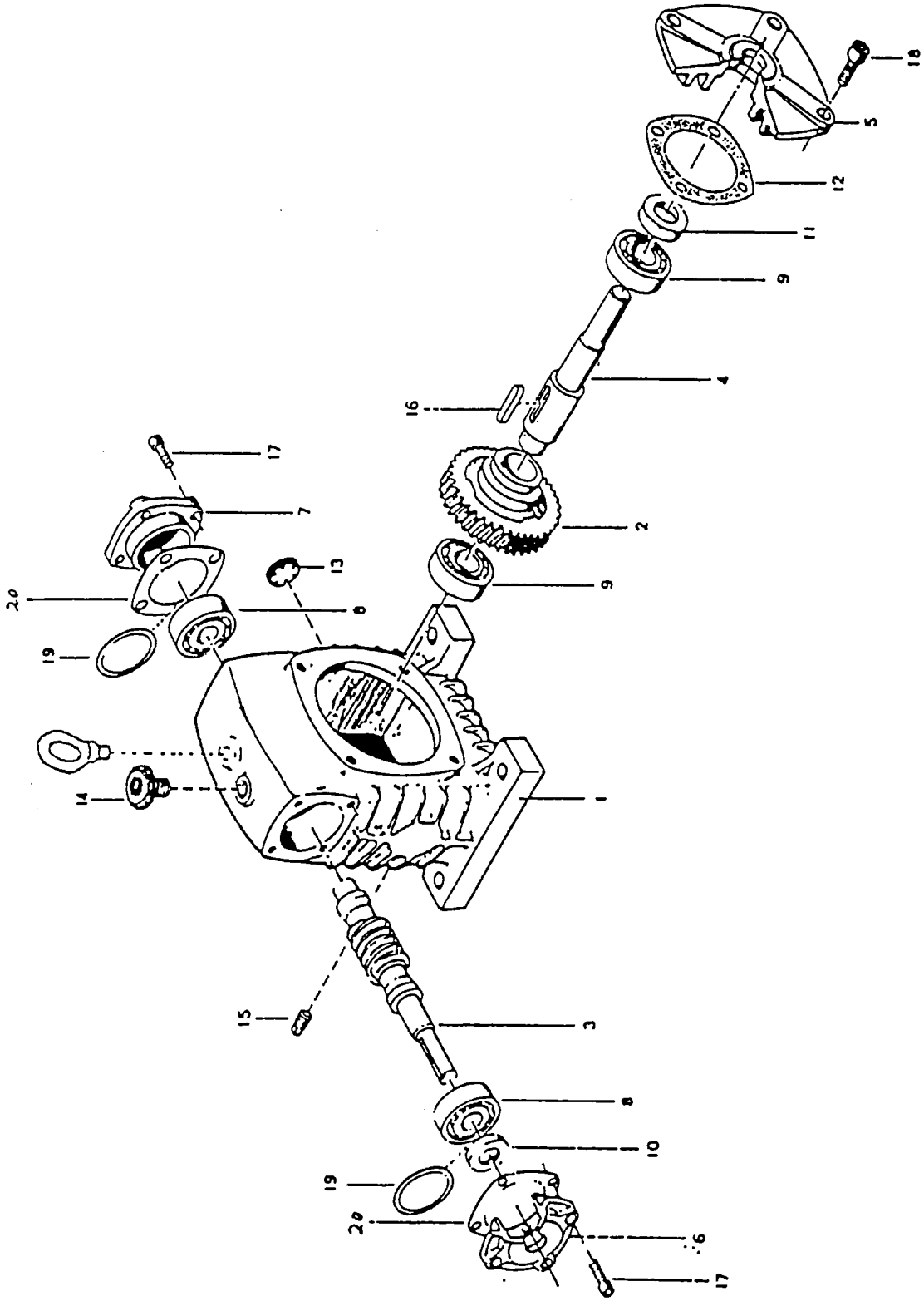

618
617
616
615
614
612
613
608
610
609
611
601
604
606
603
605
602

MOTOR PARTS

JWB-25P FILE

Item No.	Part No.	Quantity	Description
601	JWB-25601	1	Hoist Motor (1/2HP)
602	JWB-25602	1	Pulley
603	JWB-25603	1	Motor Bracket
604	JWB-25604	2	Screw
605	JWB-25605	1	V-Belt
606	JWB-25606	4	Nut
607	JWB-25607	4	Screw
608	JWB-25608	1	Feed Motor (1 HP)
609	JWB-25609	1	Variable Speed Control
610	JWB-25610	1	Variable Speed Control
611	JWB-25611	1	Flat Belt
612	JWB-25612	1	Gear Reducer Base
613	JWB-25613	1	Gear Reducer
614	JWB-25614	4	Screw
615	JWB-25615	2	Screw
616	JWB-25616	1	Gear Reducer Shaft Coupling
617	JWB-25617	1	Plastic Shaft Coupling Sleeve
618	JWB-25618	1	Gear Reducer Shaft Coupling
619	JWB-25619	1	Main Motor (15 HP)
621	JWB-25621	1	Brake Pulley
630	JWB-25630	3	V-Belt
631	JWB-25631	1	Motor Bracket
632	JWB-25632	2	Screw
633	JWB-25633	4	Nut

WORM GEAR REDUCER



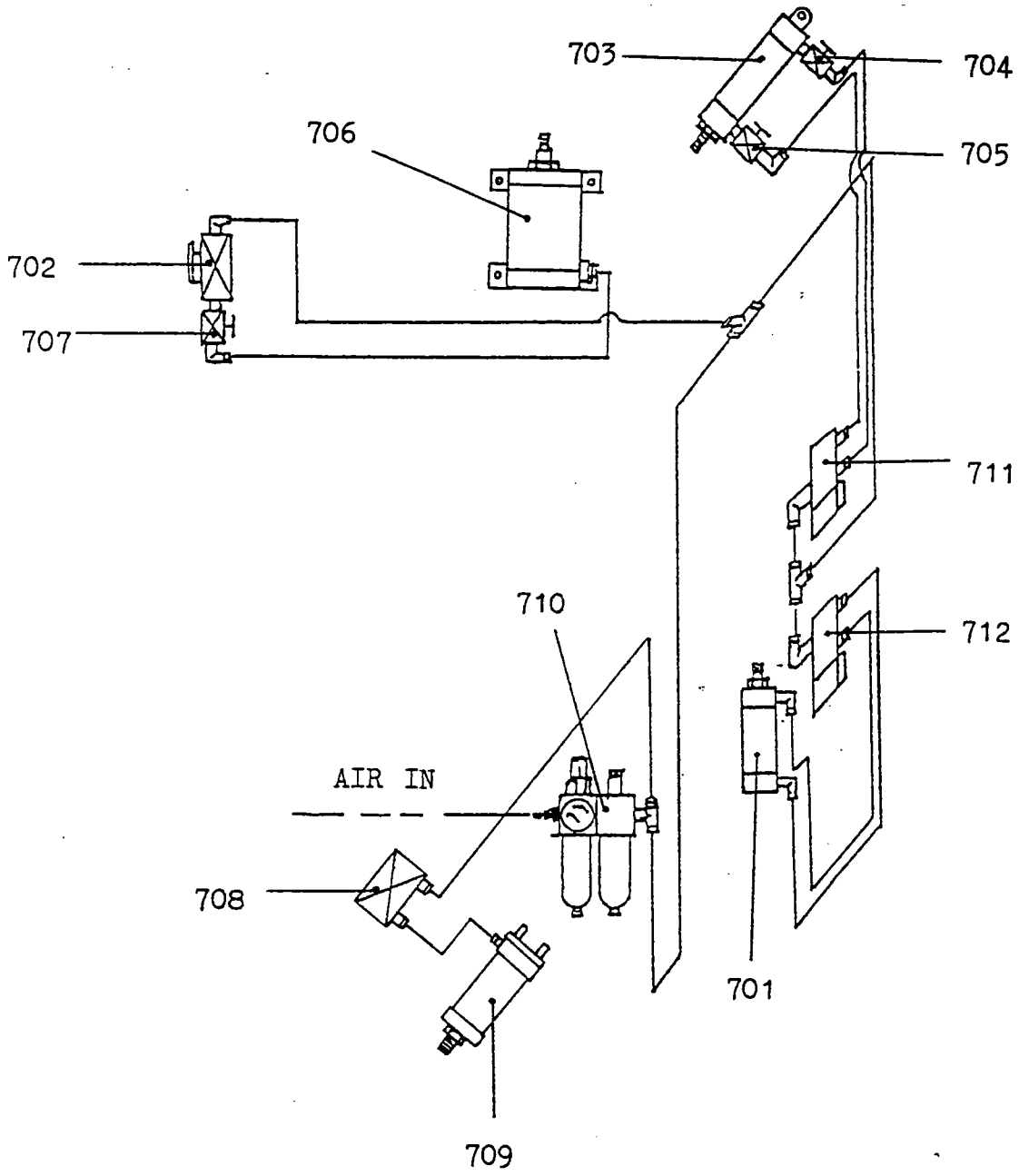
WORM GEAR REDUCER (J)

JWB-25P FILE

Item No.	Part No.	Description
1	RP-J1	Case
2	RP-J2	Worm Wheel
3	RP-J3	Input Shaft
4	RP-J4	Output Shaft
5	RP-J5	Output Shaft Cover
6	RP-J6	Input Shaft Cover
7	RP-J7	Input Shaft Cover
8	RP-J8	Input Bearing (30205)
9	RP-J9	Output Bearing (6206)
10	RP-J10	Oil Seal Input (25X40X7)
11	RP-J11	Oil Seal Output (30X46X8)
12	RP-J12	Packing
13	RP-J13	Oil Gage
14	RP-J14	Oil Plug
15	RP-J15	Drain Plug
16	RP-J16	Key for Wheel
17	RP-J17	Bolt Input
18	RP-J18	Bolt Output
19	RP-J19	Shim
20	RP-J20	Packing

AIR SUPPLY SYSTEM PARTS

FILE



AIR SUPPLY SYSTEM PARTS

FILE

Item No.	Part No.	Quantity	Description
701	JWB-25701	1	Brake Arrangement
702	JWB-25702	1	Cut-Off Valve (1/8 PT)
703	JWB-25703	1	Tracking Cylinder (CM30X5ST)
704	JWB-25704	1	Speed Control Valve (1/8 PL)
705	JWB-25705	1	Speed Control Valve (1/8 PL)
706	JWB-25706	1	Tension Cylinder (AS63X50ST)
707	JWB-25707	1	Speed Control Valve (1/8 PL)
708	JWB-25708	1	Mechanical Valve (VM2)
709	JWB-25709	1	Feeding Belt Tracking Cylinder (CB50X25ST)
710	JWB-25710	1	Air Supply Unit-Filter/Lubricator Regulator (1/4PB)
711	JWB-25711	1	Solenoid Valve for Oscillation Cc (AVC 1/4PT)
712	JWB-25712	1	Solenoid Valve for Brake (AVC 1/4

FILE

FILE
JWB-25P

ELECTRIC MATERIAL

Part No.	Material No.	Specification	Quantity	Description
901	M1	10HP S-C35L 110V (15HP S-C60L 110V)	1 1	Magnetic Switch for Motor 1 Magnetic Switch for Motor 1
904	M3	1HP S-C11 4a 110V	1	Magnetic Switch for Motor 3
905	M4A	½HP S-C11L 3a1b 110V	1	Magnetic Switch for Lifting Motor Up
906	M4B	½HP S-C11L 3a1b 110V	1	Magnetic Switch for Lifting Motor Down
907	OL1	10HP TH-20TA 22-34A (15HP H-60 32-48A)	1	Overload Relay Protector for Motor 1
908	OL3	1HP TH-12 2.5-4.1A	1	Overload Relay Protector for Motor 3
909	OL4	½HP TH-12 1.6-2.6A	1	Overload Relay Protect r for Motor 4
910	SS1	22¢ YS-D1 (Black)	1	Safety Switch
912	LS1	TZ-7312	1	Safety Limit Switch
913	LS2	TZ-8166	1	Sanding Belt Limit Switch
914	LS3	TZ-8166	1	Sanding Belt Limit Switch
915	LS6	TZ-7311	1	Table Elevation Limit Switch
916	LS7	TZ-7311	1	Table Elevation Limit Switch
917	PB1	22¢ YS-H1 (Red)	1	Push Button for Motor 1 Stop (Flat Head,Red)
918	PB2	22¢ YS-PF1 (Green)	1	Push Button for Motor 1 Start (Illuminated, Green)
919	PB5	22¢ YS-H1 (Red)	1	Push Button for Motor 3 Stop (Flat Head,Red)
920	PB6	22¢ YS-PF1 (Green)	1	Push Button for Motor 3 Start (Illuminated,

910	SS1	22ø YS-D1 (Black)	1	Safety Switch
912	LS1	TZ-7312	1	Safety Limit Switch
913	LS2	TZ-8166	1	Sanding Belt Limit Switch
914	LS3	TZ-8166	1	Sanding Belt Limit Switch
915	LS6	TZ-7311	1	Table Elevation Limit Switch
916	LS7	TZ-7311	1	Table Elevation Limit Switch
917	PB1	22ø YS-H1 (Red)	1	Push Button for Motor 1 Stop (Flat Head,Red)
918	PB2	22ø YS-PF1 (Green)	1	Push Button for Motor 1 Start (Illuminated, Green)
919	PB5	22ø YS-H1 (Red)	1	Push Button for Motor 3 Stop (Flat Head,Red)
920	PB6	22ø YS-PF1 (Green)	1	Push Button for Motor 3 Start (Illuminated, Green)
921	PB7	22ø YS-H1 (Green)	1	Push Button for Motor 4 Up (Flat Head,Red)
922	PB8	22ø YS-H1 (Green)	1	Push Button for Motor 4 Down (Flat Head,Green)
923	PB9	22ø YS-L1 (Red)	1	Push Button for Brake (Mushroom Head,Red)
924	L1	22ø S-22 110V(Green)	1	Power Indicator
925	L2	PB2 to Contain PB2	1	Indicator for Motor 1 (918)
926	L4	PB6 to Contain PB6	1	Indicator for Motor 3 (920)
927	L5	22ø S-22 (Yellow)	1	Alarm Indicator
929	R1	HH-52P 110V	1	Relay (MY-2)
929		PYE-08N	1	Relay Base (MY-2)
931	PT	PT-25 (0.220.440/ 0.100.110)	1	Transformer
932	TFB	TFB-102	1	Fuse Base
932	Fuse	5A	2	Fuse
933	CT	50:5	1	Current Coil
934	A1	80P 50:5	1	Ampere Meter
438	PH	STR-109	1	Electric Eye
711	SOL1	7V-43 110V	1	Solenoid Valve for Sanding Belt Oscilation
712	SOL3	7V-43 110V	1	Solenoid Valve for Brake
937		3P100A	1	Terminal Board
937-1		20A20P	1	Terminal Board