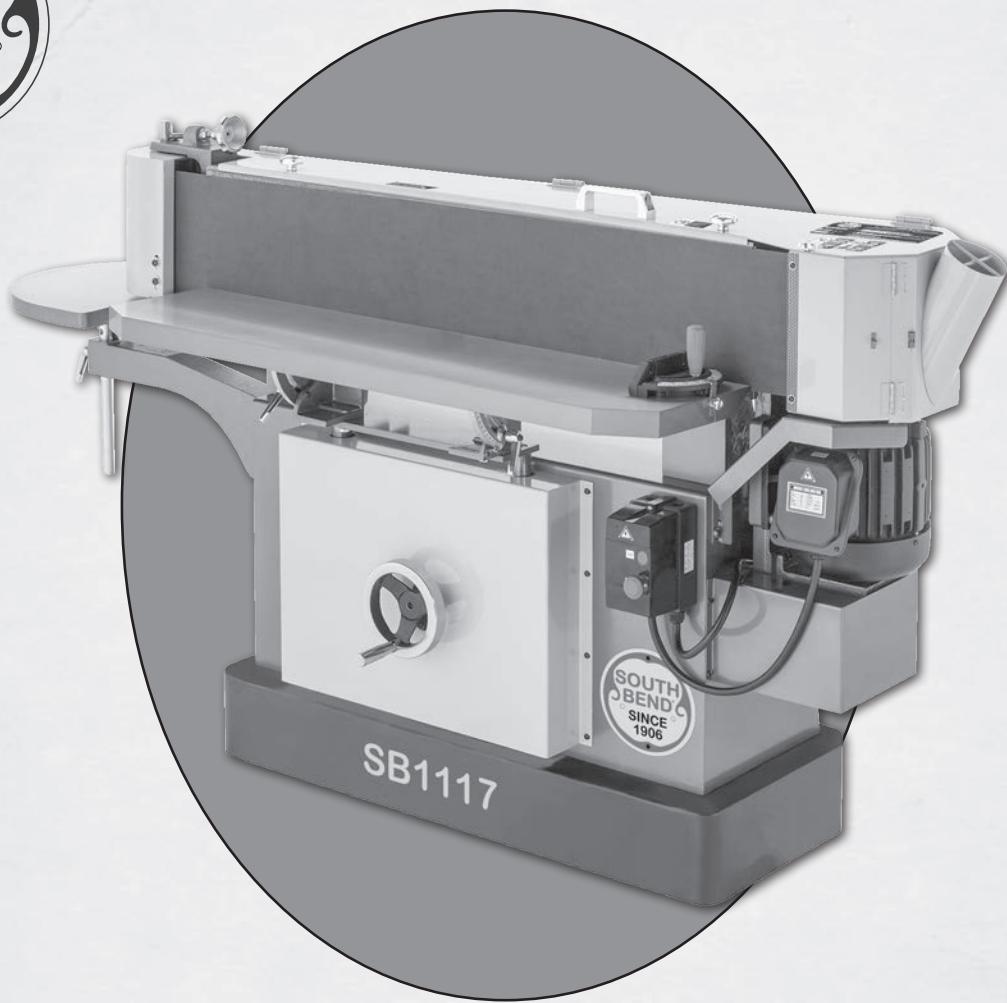


9" X 138½" OSCILLATING EDGE SANDER

MODEL SB1117



****Keep for Future Reference****

OWNER'S MANUAL

South Bend Tools®

A Tradition of Excellence



Scope of Manual

This manual helps the reader understand the machine, how to prepare it for operation, how to control it during operation, and how to keep it in good working condition. We assume the reader has a basic understanding of how to operate this type of machine, but that the reader is not familiar with the controls and adjustments of this specific model. As with all machinery of this nature, learning the nuances of operation is a process that happens through training and experience. If you are not an experienced operator of this type of machinery, read through this entire manual, then learn more from an experienced operator, schooling, or research before attempting operations. Following this advice will help you avoid serious personal injury and get the best results from your work.

Manual Feedback

We've made every effort to be accurate when documenting this machine. However, errors sometimes happen or the machine design changes after the documentation process—so the manual may not exactly match your machine. If a difference between the manual and machine leaves you in doubt, contact our customer service for clarification.

We highly value customer feedback on our manuals. If you have a moment, please share your experience using this manual. What did you like about it? Is there anything you would change to make it better? Did it meet your expectations for clarity, professionalism, and ease-of-use?

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Updates

For your convenience, any updates to this manual will be available to download free of charge through our website at:

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Customer Service

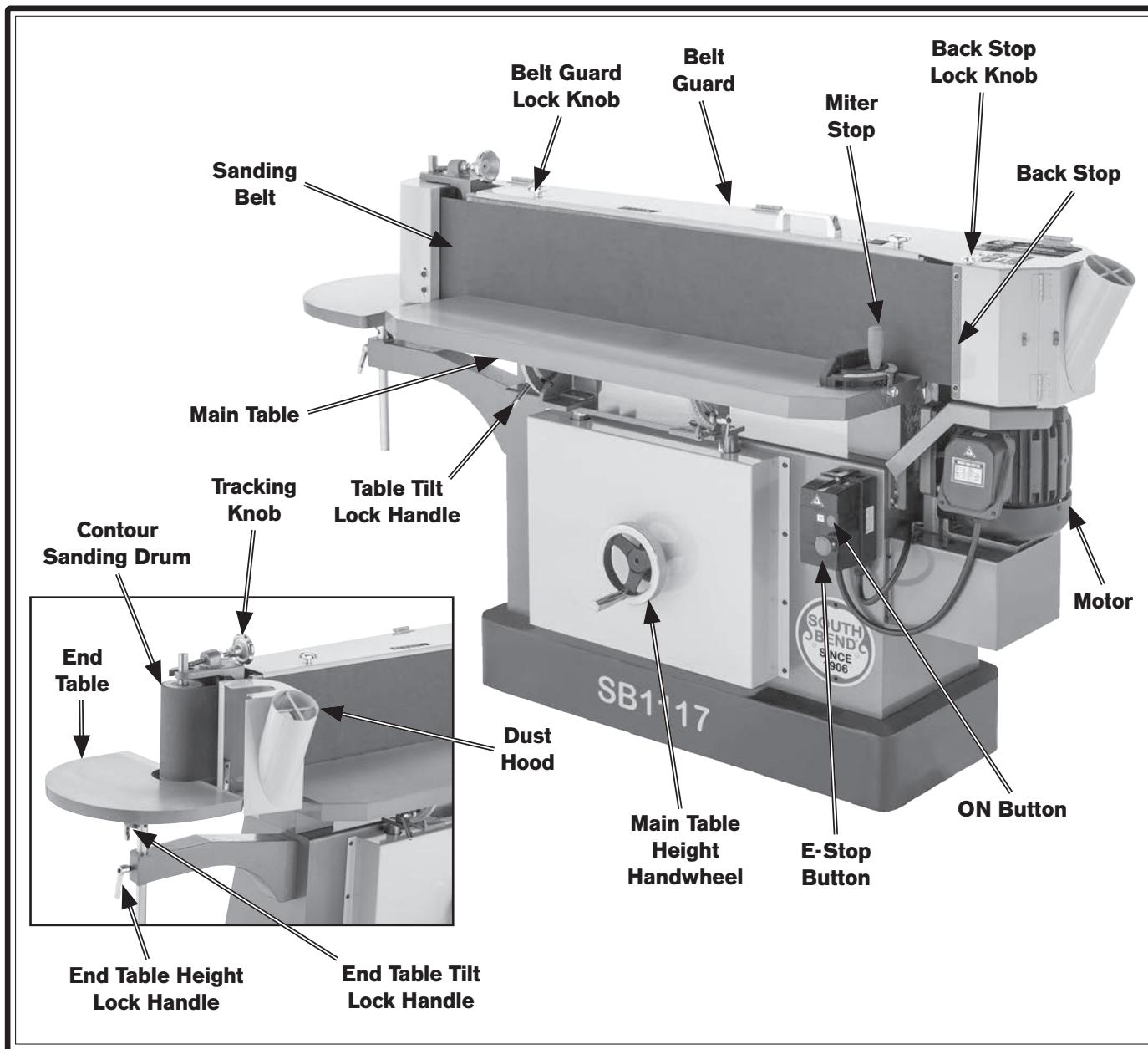
We stand behind our machines. If you have any service questions, parts requests or general questions about your purchase, feel free to contact us.

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Identification



WARNING

For Your Own Safety, Read Instruction Manual Before Operating Sander

- a) Wear eye protection.
- b) Support workpiece with miter gauge, backstop, or worktable.
- c) Maintain $1/16$ " maximum clearance between table and sanding belt.
- d) Avoid kickback by sanding in accordance with the directional arrows.

Description of Controls & Components

⚠ WARNING

Serious personal injury could occur if you connect the machine to power before completing the setup process. DO NOT connect power until instructed to do so later in this manual.

⚠ WARNING

Untrained users have an increased risk of seriously injuring themselves with this machine. Do not operate this machine until you have understood this entire manual and received proper training.

Refer to **Figures 1–5** and the following descriptions to become familiar with the basic controls and components used to operate this machine.

A. ON Button: Starts motor.

B. E-Stop Button: Stops motor and prevents accidental startup. Twist to reset.

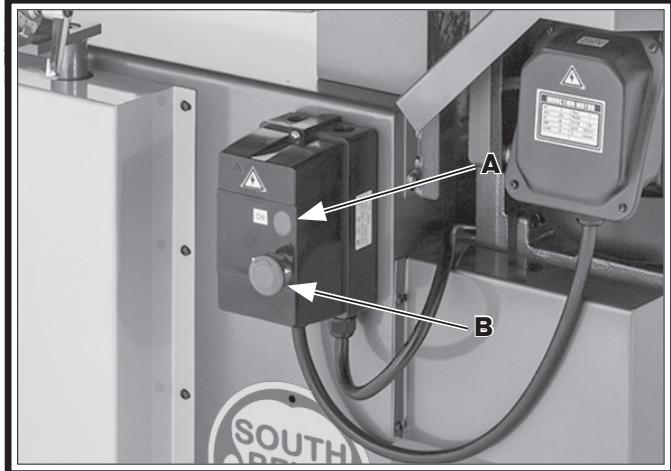


Figure 1. Electrical components.

- C. Tracking Knob:** Adjusts sanding belt tracking.
- D. Belt Guard Lock Knob:** Tightens to lock belt guard and loosens to open belt guard.
- E. Belt Guard:** Opens and closes to allow for belt replacement and maintenance.

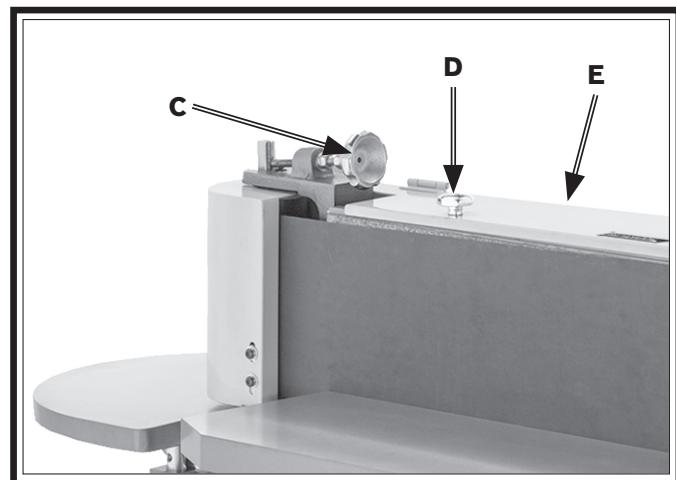


Figure 2. Belt controls and components.

- F. Table Tilt Lock Handles:** Tighten to lock table tilt angle and loosen to adjust tilt angle.
- G. Main Table Height Handwheel:** Adjusts main table height.

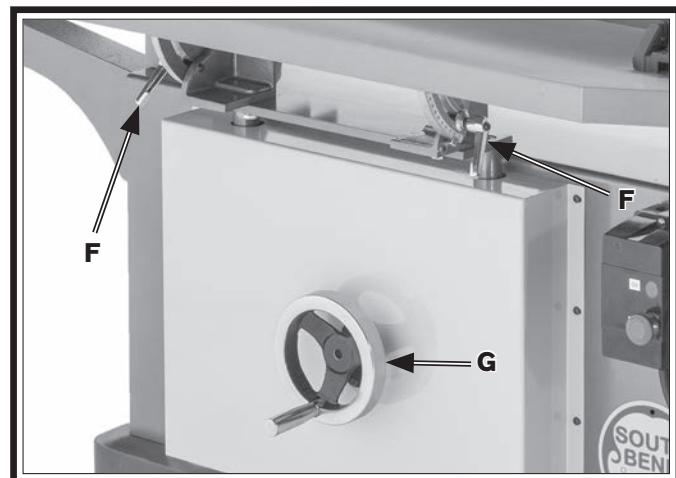


Figure 3. Main table adjustment components.

- H. **End Table Tilt Lock Handle:** Tightens to lock end table tilt angle and loosens to adjust tilt angle.
- I. **End Table Height Lock Handle:** Tightens to lock end table height and loosens to adjust table height.
- J. **Dust Hood Lock Handle:** Tightens to lock dust hood position and loosens to adjust dust hood position.

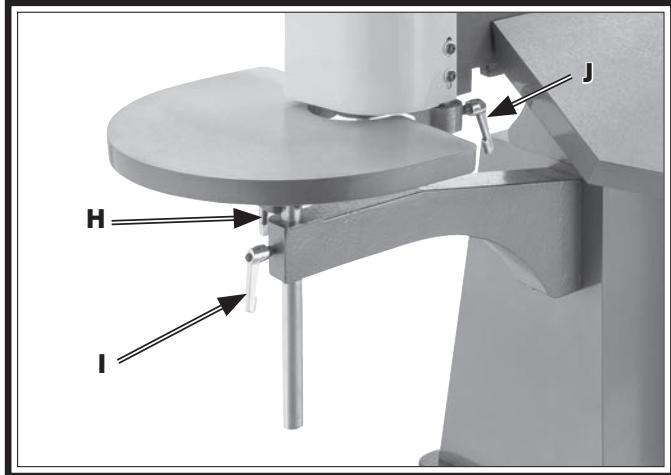


Figure 4. End table adjustment components.

- K. **Miter Stop:** Adjusts from 0–60 degrees to support workpiece against sanding belt and main table.
- L. **Back Stop Lock Knob:** Tightens to lock back stop closed and loosens to open.
- M. **Back Stop:** Supports workpiece and prevents entanglement.

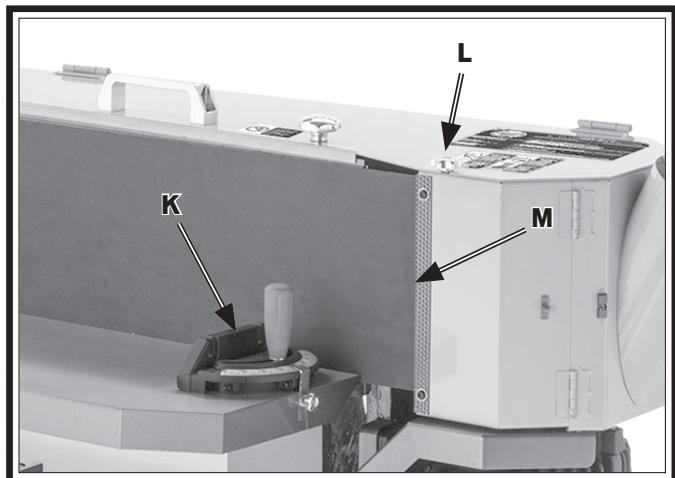


Figure 5. Additional support components.



Product Specifications

P.O. Box 2027, Bellingham, WA 98227 U.S.A.
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Model SB1117 9" x 138-1/2" Oscillating Edge Sander

Product Dimensions

Weight.....	739 lbs.
Width (side-to-side) x Depth (front-to-back) x Height.....	82-1/2 x 26-1/2 x 46-1/2 in.
Footprint (Length x Width).....	44-1/2 x 19 in.

Shipping Dimensions

Type.....	Wood Crate
Content.....	Machine
Weight.....	839 lbs.
Length x Width x Height.....	82 x 30 x 51 in.
Must Ship Upright.....	Yes

Electrical

Power Requirement.....	220V, Single-Phase, 60 Hz
Full-Load Current Rating.....	15A
Minimum Circuit Size.....	20A
Connection Type.....	Cord & Plug
Power Cord Included.....	Yes
Power Cord Length.....	110 in.
Power Cord Gauge.....	12 AWG
Plug Included.....	Yes
Included Plug Type.....	6-20
Switch Type.....	Magnetic Switch w/Overload Protection

Motors

Main

Horsepower.....	3 HP
Phase.....	Single-Phase
Amps.....	15A
Speed.....	1720 RPM
Type.....	TEFC Capacitor-Start Induction
Power Transfer	Direct Drive
Bearings.....	Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type.....	External

Main Specifications

Operation Information

Sanding Belt Speed.....	4120 FPM
Sanding Belt Oscillations.....	1/4 in.
Sanding Belt Length.....	138-1/2 in.
Sanding Belt Width.....	9 in.

Table Information

Table Length.....	47-3/4 in.
Table Width.....	11-3/4 in.
Table Thickness.....	1-5/8 in.
Table Tilt.....	0 - 45 deg.
Table Travel.....	5-1/8 in.
Floor To Table Height.....	33-1/4 - 38-3/8 in.
End Table Length.....	18 in.
End Table Width.....	13 in.
End Table Thickness.....	1-1/4 in.
End Table Travel.....	8 in.

Platen Information

Platen Type.....	Graphite Coated
Platen Length.....	47-1/2 in.
Platen Width.....	9-1/2 in.

Construction

Table.....	Aluminum
Frame.....	Cast Iron
Base.....	Steel
Drive Roller.....	Rubber
Idler Roller.....	Rubber
Paint Type/Finish.....	Enamel

Other Related Information

Number of Dust Ports.....	2
Dust Port Size.....	4 in.
Belt Release.....	Quick Release
Drive Roller Size.....	9 in.
Idler Roller Size.....	4 in.

Other

Country of Origin	Taiwan
Warranty	2 Years
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label
Sound Rating	96 - 98 dB

Features

- Miter Work Stop
- Quick-Release Belt Lever
- Conveniently Located Belt Tracking and Tension Adjustment
- 1/4" Belt Oscillation
- Two Large Sanding Tables
- Table Height Handwheel for Easy Adjustment and Maximum Use of Sanding Surface Area

Understanding Risks of Machinery

Operating all machinery and machining equipment can be dangerous or relatively safe depending on how it is installed and maintained, and the operator's experience, common sense, risk awareness, working conditions, and use of personal protective equipment (safety glasses, respirators, etc.).

The owner of this machinery or equipment is ultimately responsible for its safe use. This responsibility includes proper installation in a safe environment, personnel training and usage authorization, regular inspection and maintenance, manual availability and comprehension, application of safety devices, integrity of cutting tools or accessories, and the usage of approved personal protective equipment by all operators and bystanders.

The manufacturer of this machinery or equipment will not be held liable for injury or property damage from negligence, improper training, machine modifications, or misuse. Failure to read, understand, and follow the manual and safety labels may result in serious personal injury, including amputation, broken bones, electrocution, or death.

The signals used in this manual to identify hazard levels are as follows:



DANGER
Death or catastrophic harm WILL occur.



CAUTION
Moderate injury or fire MAY occur.



WARNING
Death or catastrophic harm COULD occur.



NOTICE
Machine or property damage may occur.

Basic Machine Safety

Owner's Manual: All machinery and machining equipment presents serious injury hazards to untrained users. To reduce the risk of injury, anyone who uses THIS item MUST read and understand this entire manual before starting.

Personal Protective Equipment: Operating or servicing this item may expose the user to flying debris, dust, smoke, dangerous chemicals, or loud noises. These hazards can result in eye injury, blindness, long-term respiratory damage, poisoning, cancer, reproductive harm or hearing loss. Reduce your risks from these hazards by wearing approved eye protection, respirator, gloves, or hearing protection.

Trained/Supervised Operators Only: Untrained users can seriously injure themselves or bystanders. Only allow trained and properly supervised personnel to operate this item. Make sure safe operation instructions are clearly understood. If electrically powered, use padlocks and master switches, and remove start switch keys to prevent unauthorized use or accidental starting.

Guards/Covers: Accidental contact with moving parts during operation may cause severe entanglement, impact, cutting, or crushing injuries. Reduce this risk by keeping any included guards/covers/doors installed, fully functional, and positioned for maximum protection.

Entanglement: Loose clothing, gloves, neckties, jewelry or long hair may get caught in moving parts, causing entanglement, amputation, crushing, or strangulation. Reduce this risk by removing/securing these items so they cannot contact moving parts.

Mental Alertness: Operating this item with reduced mental alertness increases the risk of accidental injury. Do not let a temporary influence or distraction lead to a permanent disability! Never operate when under the influence of drugs/alcohol, when tired, or otherwise distracted.

Safe Environment: Operating electrically powered equipment in a wet environment may result in electrocution; operating near highly flammable materials may result in a fire or explosion. Only operate this item in a dry location that is free from flammable materials.

Electrical Connection: With electrically powered equipment, improper connections to the power source may result in electrocution or fire. Always adhere to all electrical requirements and applicable codes when connecting to the power source. Have all work inspected by a qualified electrician to minimize risk.

Disconnect Power: Adjusting or servicing electrically powered equipment while it is connected to the power source greatly increases the risk of injury from accidental startup. Always disconnect power BEFORE any service or adjustments, including changing blades or other tooling.

Secure Workpiece/Tooling: Loose workpieces, cutting tools, or rotating spindles can become dangerous projectiles if not secured or if they hit another object during operation. Reduce the risk of this hazard by verifying that all fastening devices are properly secured and items attached to spindles have enough clearance to safely rotate.

Chuck Keys or Adjusting Tools: Tools used to adjust spindles, chucks, or any moving/rotating parts will become dangerous projectiles if left in place when the machine is started. Reduce this risk by developing the habit of always removing these tools immediately after using them.

Work Area: Clutter and dark shadows increase the risks of accidental injury. Only operate this item in a clean, non-glaring, and well-lighted work area.

Properly Functioning Equipment: Poorly maintained, damaged, or malfunctioning equipment has higher risks of causing serious personal injury compared to those that are properly maintained. To reduce this risk, always maintain this item to the highest standards and promptly repair/service a damaged or malfunctioning component. Always follow the maintenance instructions included in this documentation.

Unattended Operation: Electrically powered equipment that is left unattended while running cannot be controlled and is dangerous to bystanders. Always turn the power **OFF** before walking away.

Health Hazards: Certain cutting fluids and lubricants, or dust/smoke created when cutting, may contain chemicals known to the State of California to cause cancer, respiratory problems, birth defects, or other reproductive harm. Minimize exposure to these chemicals by wearing approved personal protective equipment and operating in a well ventilated area.

Difficult Operations: Attempting difficult operations with which you are unfamiliar increases the risk of injury. If you experience difficulties performing the intended operation, STOP! Seek an alternative method to accomplish the same task, ask a qualified expert how the operation should be performed, or contact our Technical Support for assistance.

Additional Oscillating Edge Sander Safety

WARNING

Serious injury or death can occur if fingers, clothing, jewelry, or hair get entangled in moving components. Impact injuries can occur from kickback if workpiece is improperly fed into moving sandpaper. Serious pinch injuries can occur from touching in-running nip point between table and sanding surface. Long-term respiratory damage can occur from using sander without proper use of a respirator. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

Avoiding Entanglement. Becoming entangled in moving parts of this machine can cause pinching and crushing injuries. To avoid these hazards, DO NOT wear loose clothing, gloves, or jewelry, and tie back long hair. Keep all guards in place and secure.

In-Running Nip Points. The gap between moving sandpaper and fixed table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater risk of fingers or workpieces getting caught in it. Minimize this risk by adjusting table no more than $\frac{1}{16}$ " away from sandpaper.

Sandpaper Direction. Feeding workpiece incorrectly can cause it to be thrown from machine, striking operator or bystanders, or causing your hands to slip into the moving sandpaper. To reduce these risks, only sand against direction of sandpaper travel, ensure workpiece is properly supported, and avoid introducing sharp edges into moving sandpaper on leading side of workpiece.

Workpiece Support & Hand Placement. Rotating sandpaper can remove a large amount of skin quickly, and kickback can occur with violent force if workpiece is not properly supported during operation. Always sand with workpiece firmly against table or another support device. Never touch moving sandpaper on purpose.

Workpiece Integrity. Only sand solid workpieces that can withstand power sanding forces. Make sure shape of workpiece is properly supported on table; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.

Feeding Workpiece. Forcefully jamming workpiece into sanding surface could cause workpiece to be aggressively grabbed and pull your hands into sanding surface. Firmly grasp workpiece in both hands and ease it into sandpaper using light pressure.

Small Workpieces. Small workpieces are difficult to control and require close support near sanding surface. Always use a jig or other holding device when sanding small workpieces, and keep hands and fingers at least 2" away from sanding surface.

Workpiece Inspection. Nails, staples, knots, or other imperfections in workpiece can be dislodged and thrown from sander at high rate of speed into operator or bystanders, or cause damage to sandpaper or sander. Never try to sand stock that has embedded foreign objects or questionable imperfections.

Sandpaper Condition. Worn or damaged sandpaper not only produces poor sanding results, but could fly apart, aggressively grab workpiece, and throw debris at the operator. Always inspect sandpaper before operation and replace if worn or damaged.

Sanding Dust & Dust Collection. Sanding creates large amounts of dust and flying particles that can lead to eye injury or respiratory illness. Reduce risk by wearing approved eye and respiratory protection when using sander. Never operate without adequate dust-collection system in place and running. Proper dust collection reduces dust in work area, decreasing risk of long-term respiratory damage, but it is not a substitute for using a respirator.

Preparation Overview

The purpose of the preparation section is to help you prepare your machine for operation. The list below outlines the basic process. Specific steps for each of these points will be covered in detail later in this section.

The typical preparation process is as follows:

1. Unpack the machine and inventory the contents of the box/crate.
2. Clean the machine and its components.
3. Identify an acceptable location for the machine and move it to that location.
4. Level the machine and either bolt it to the floor or place it on mounts.
5. Assemble the loose components and make any necessary adjustments or inspections to ensure the machine is ready for operation.
6. Connect the machine to the power source.
7. Test run the machine to make sure it functions properly and is ready for operation.

Required for Setup

The items listed below are required to successfully set up and prepare this machine for operation.

For Lifting

- A forklift or other power lifting device rated for the weight of the machine.
- Lifting Strap or Chain (rated for at least 1000 lbs.)

For Power Connection

- A power source that meets the minimum circuit requirements for this machine. (Refer to the **Power Supply Requirements** section for details.)
- A qualified electrician to ensure a safe and code-compliant connection to the power source.

For Assembly

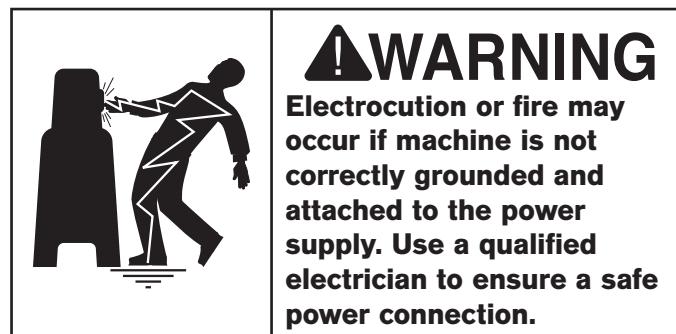
- Disposable Rags
- Cleaner/Degreaser
- Disposable Gloves
- Safety Glasses
- Floor Mounting Hardware (As Needed)
- Calipers or Measuring Tape
- Wrench or Socket 17mm
- Dust Collection System
- Dust Hose 4"
- Hose Clamp 4"
- Open-End Wrench 19mm

Power Supply Requirements

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed.

To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with applicable electrical codes and safety standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Rating at 220V 15 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

! WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

Circuit Requirements

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 208V/220V/230V/240V
Cycle 60 Hz
Phase Single-Phase
Circuit Rating 20 Amps
Plug/Receptacle (included) NEMA 6-20

A power supply circuit includes all electrical equipment between the main breaker box or fuse panel in your building and the incoming power connections inside the machine. This circuit must be safely sized to handle the full-load current that may be drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

! CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or applicable electrical codes.

Note: The circuit requirements in this manual are for a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure the circuit is properly sized.

Grounding Requirements

This machine must be grounded! In the event of certain types of malfunctions or breakdowns, grounding provides a path of least resistance for electric current in order to reduce the risk of electric shock.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

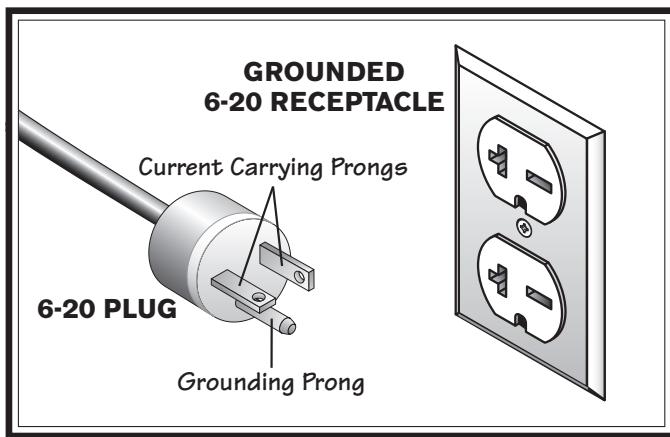
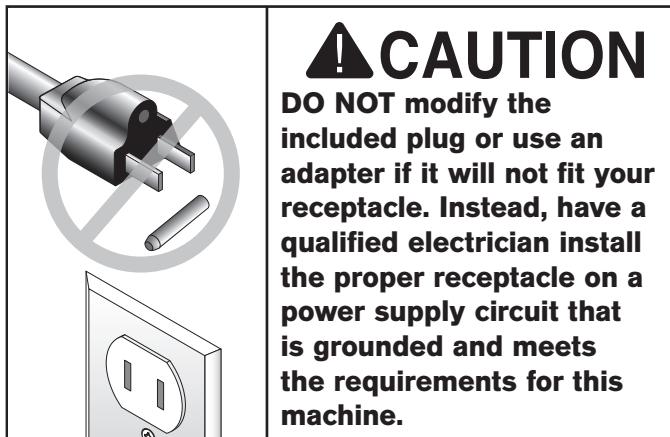


Figure 6. NEMA 6-20 plug and receptacle.



Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with an electrician or qualified service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded.

If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use one, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle listed in the **Circuit Requirements** for the applicable voltage, and meet the following requirements:

**Minimum Gauge Size.....12 AWG
Maximum Length (Shorter is Better)50 ft.**

Unpacking

This item was carefully packaged to prevent damage during transport. If you discover any damage, please immediately call Customer Service at (360) 734-1540 for advice. You may need to file a freight claim, so save the containers and all packing materials for possible inspection by the carrier or its agent.

Inventory

Inventory (Figures 7–8)	Qty
A. Sander.....	1
B. Sanding Belt 9" x 138 $\frac{1}{2}$ " 180-Grit.....	1
C. End Table Assembly	1
D. Machine Feet M12-1.75 x 40	4
E. Handle M10-1.5 x 30.....	1
F. Knob Bolts M10-1.5 x 15.....	2
G. Flat Washers 10mm.....	2
H. Lock Washers 10mm.....	2

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

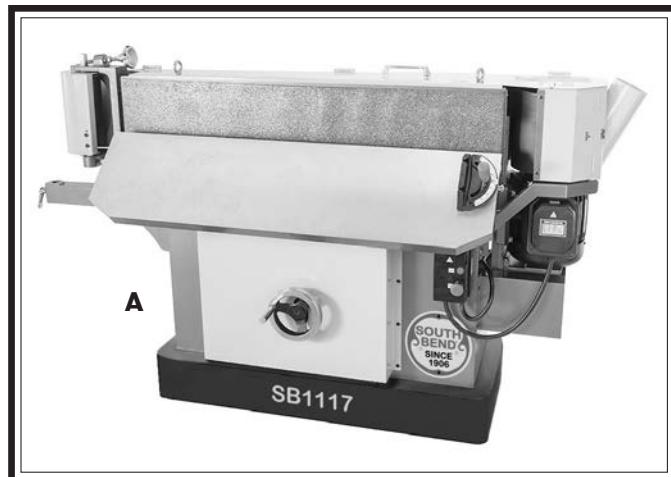


Figure 7. Machine as shipped.

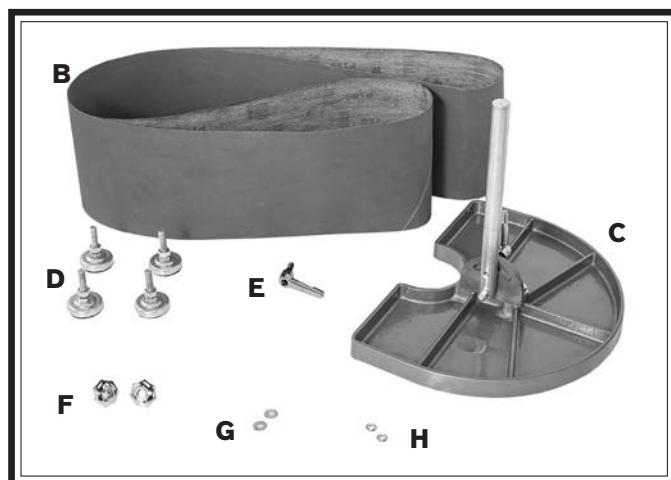


Figure 8. Loose parts.

Cleaning & Protecting

The unpainted surfaces are coated at the factory with a heavy-duty rust preventative that prevents corrosion during shipment and storage. The benefit of this rust preventative is that it works very well. The downside is that it can be time-consuming to thoroughly remove.

Be patient and do a careful job when cleaning and removing the rust preventative. The time you spend doing this will reward you with smooth-sliding parts and a better appreciation for the proper care of the unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, the following process works well in most situations.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (certain citrus-based degreasers work extremely well and they have non-toxic fumes)
- Safety glasses & disposable gloves

Note: Automotive degreasers, mineral spirits, or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of a painted surface to make sure they will not damage it.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.
2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner or degreaser and let them soak for a few minutes.
3. Wipe off the surfaces. If your cleaner or degreaser is effective, the rust preventative will wipe off easily.

Note: To clean off thick coats of rust preventative on flat surfaces, such as beds or tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or it may scratch the surface.)

4. Repeat Steps 2–3 as necessary until clean, then coat all unpainted surfaces with a quality metal protectant or light oil to prevent rust.

T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from the **non-painted** parts of the machine during clean up.

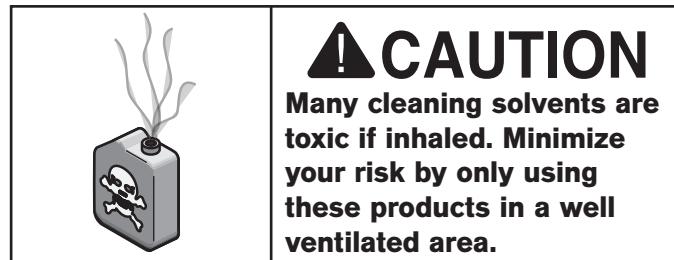
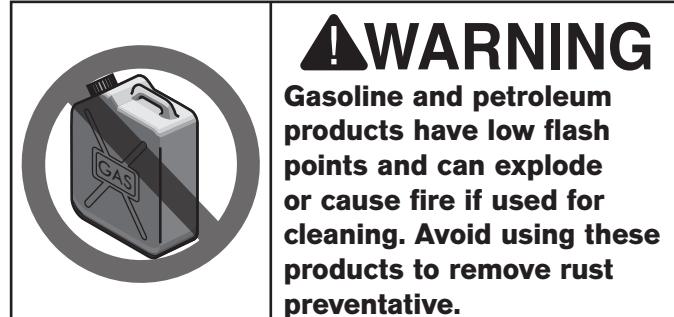


Figure 9. T23692 Orange Power Degreaser.

Location

Physical Environment

The physical environment where your machine is operated is important for safe operation and longevity of parts. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous or flammable chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature is outside the range of 41°–104°F; the relative humidity is outside the range of 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

Lighting around the machine must be adequate enough to perform operations safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

Weight Load

Refer to the **Machine Specifications** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual.

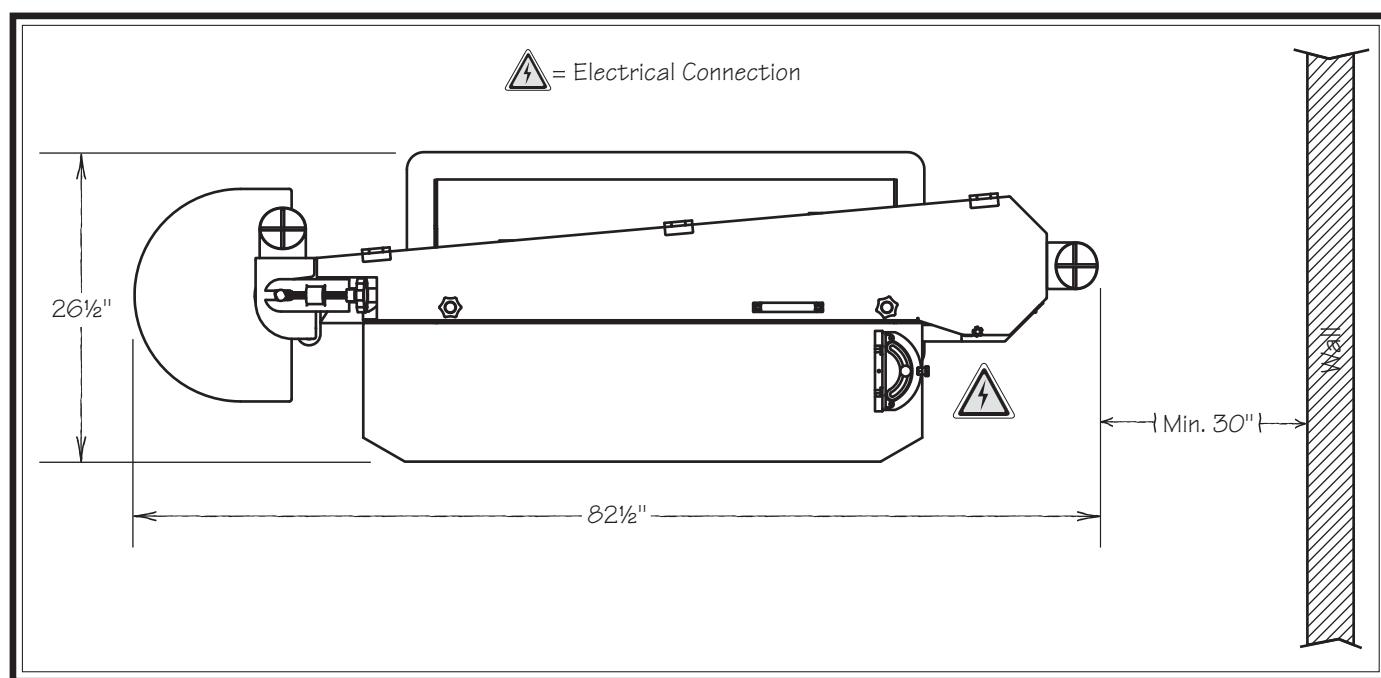
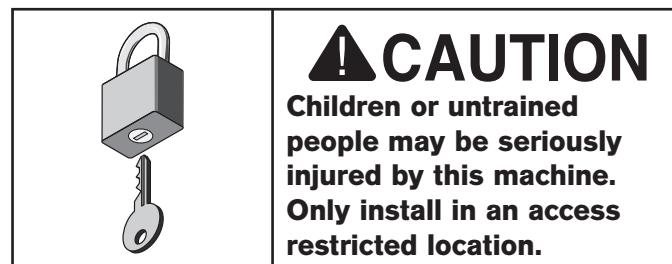
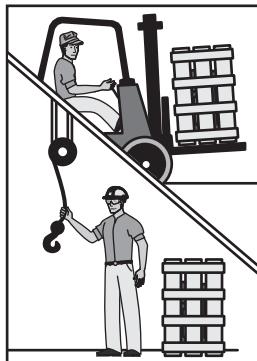


Figure 10. Minimum working clearances.

Lifting & Moving



WARNING
This machine and its parts are heavy! Serious personal injury may occur if safe moving methods are not used. To reduce the risk of a lifting or dropping injury, ask others for help and use power equipment.

Do not attempt to lift or move this machine without using the proper lifting equipment (such as forklift or crane). Each piece of lifting equipment must be rated for at least 1000 lbs. to support dynamic loads that may be applied while lifting.

Use lifting straps or chains to lift the machine off the pallet using the eye bolts shown in **Figure 11**. While machine is suspended, install machine feet as described in **Machine Mounts** before placing machine in a suitable location.

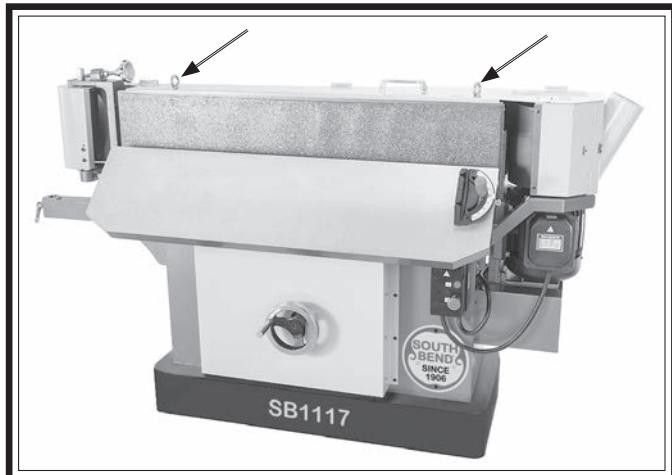


Figure 11. Lifting eye bolt locations.



WARNING
Lifting using only one ring or different location could unbalance and tip machine, which could result in serious crushing injury or machine damage. To reduce risk of this injury, be sure to use BOTH lifting rings to lift machine.

Machine Mounts

Machine mounts are rubber pads mounted to a threaded stud, which can be fastened to the bottom of the machine.

Machine mounts offer certain advantages such as ease of installation, vibration dampening, and easy leveling. They also make it easier to relocate the machine later on.

The disadvantage of machine mounts is that the machine can shift or move over time. For this reason, electrical codes may limit their use if the machine is hardwired to the power source. Also, mounts may reduce the total surface area of machine-to-floor contact, depending on the design of the machine.



Figure 12. Typical machine mount.

To install machine mounts:

1. While machine is suspended to provide access to mounting holes at base of machine, install (4) M12-1.75 x 40 machine feet at locations shown in **Figure 13**.

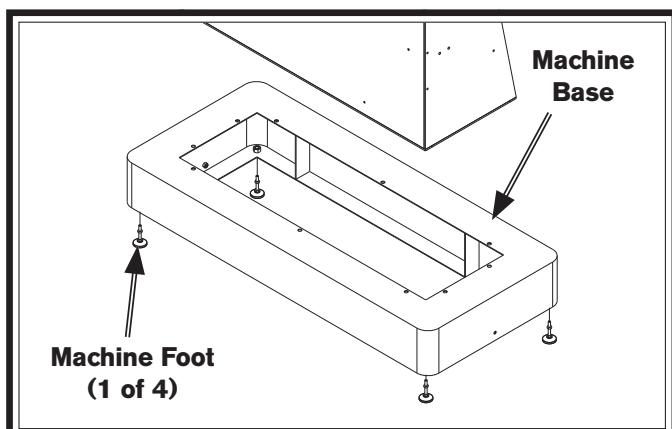


Figure 13. Machine feet mounting locations (machine base separated for clarity).

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Required for Setup on Page 10** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

Assembly of the Model SB1117 consists of installing the sanding belt and end table.

To assemble machine:

1. Remove (2) eye bolts used for lifting (see **Figure 14**).

Note: Save eye bolts in case you need to move machine later.

2. Loosen back stop lock knob (see **Figure 14**) and open belt guard and back stop door.

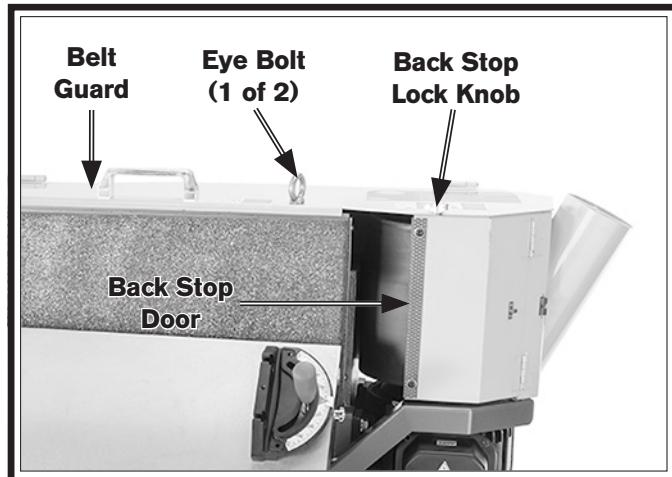


Figure 14. Lifting eye bolts and access door components.

3. Loosen dust hood lock handle to open end table dust hood (see **Figure 15**).

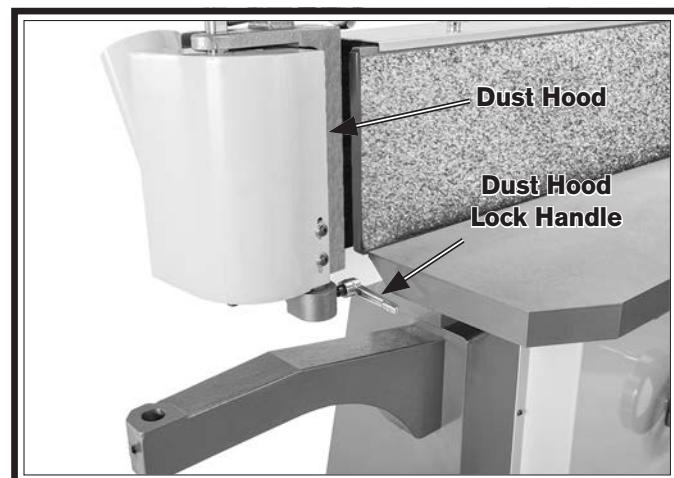


Figure 15. Location of dust hood lock handle.

4. Move belt tension lever up and toward contour drum, as shown in **Figure 16**.

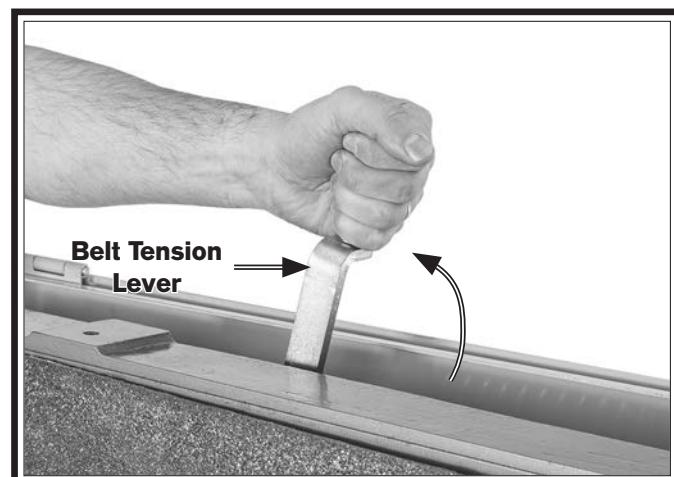


Figure 16. Moving belt tension lever to un-tensioned position.

5. Install and center sanding belt around sanding drums, being sure arrows on belt match arrow of belt rotation on machine (see **Figure 17**).

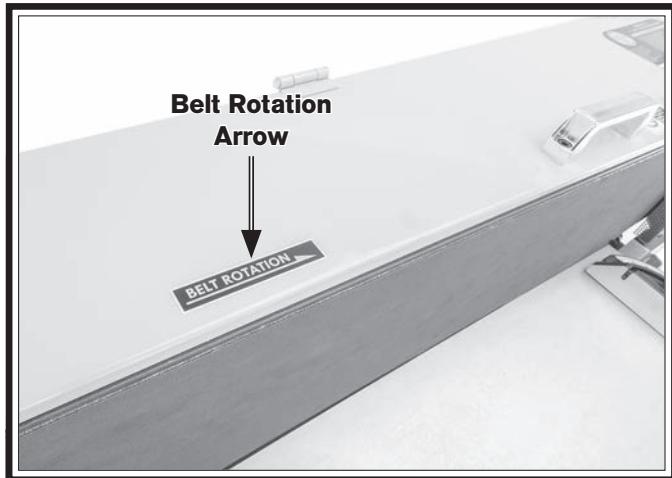


Figure 17. Sanding belt rotation arrow.

6. Move belt tension lever down to tension sanding belt (see **Figure 18**).

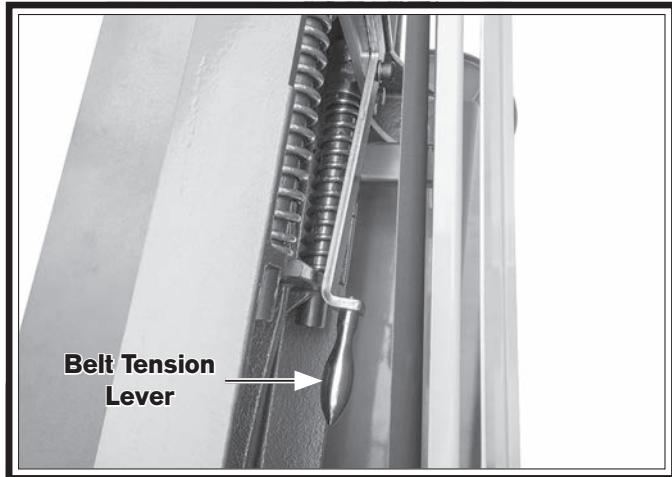


Figure 18. Sanding belt installed and tensioned.

7. Close belt guard and secure with (2) M10-1.5 x 15 knob bolts, 10mm lock washers, and 10mm flat washers (see **Figure 19**).

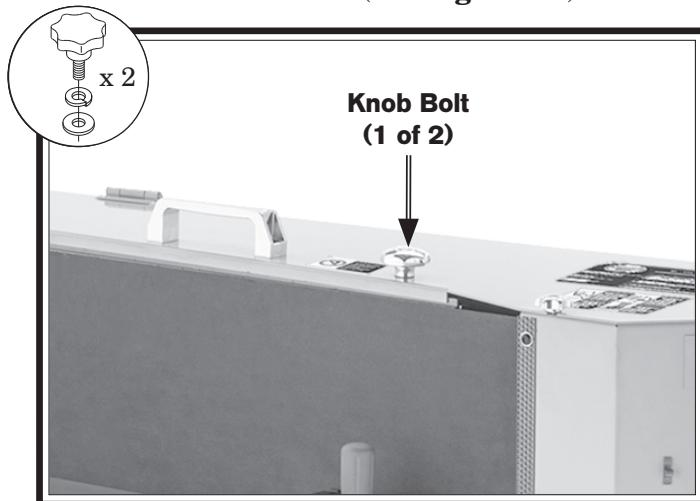


Figure 19. Belt guard lock knob installed.

8. Loosen main table tilt lock handles (see **Figure 20**).

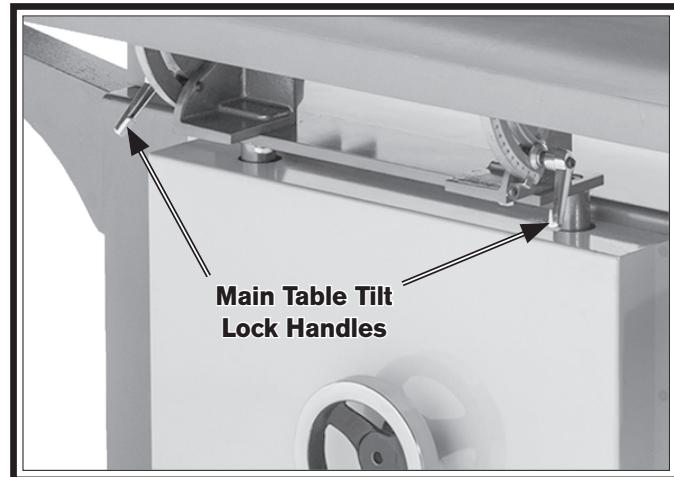


Figure 20. Location of main table tilt lock handles.

- 9.** Tilt main table until pointer on tilt scale indicates 0° (see **Figure 21**).

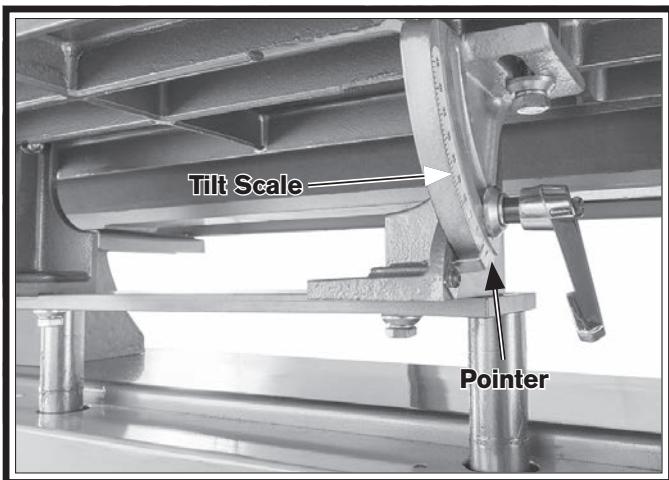


Figure 21. Main table tilt scale and pointer.

- 10.** Tighten lock handles from **Step 8** to secure setting.
- 11.** Measure clearance between table and sanding belt.

- If clearance is *less than* $\frac{1}{16}$ ", no further adjustment is necessary.
- If clearance is *more than* $\frac{1}{16}$ ", proceed to **Step 12**.

- 12.** Loosen lock bolts shown in **Figure 22**, push table so there is $\frac{1}{16}$ " or less between table and sandpaper, then tighten bolts.

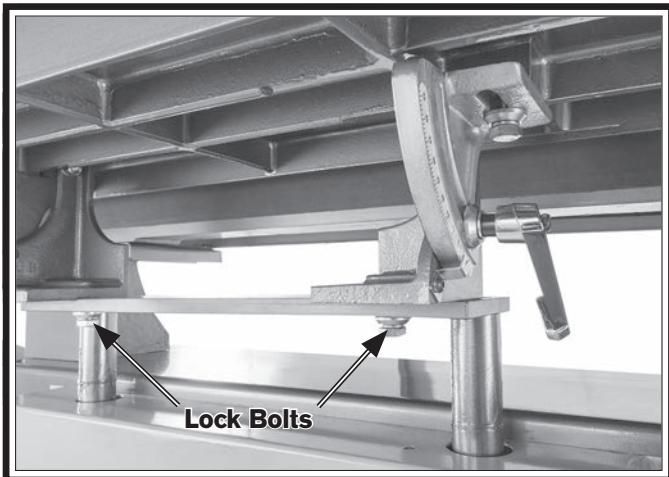


Figure 22. Location of main table lock bolts.

- 13.** Insert end table shaft into machine arm mount and secure with M10-1.5 x 30 handle (see **Figure 23**).

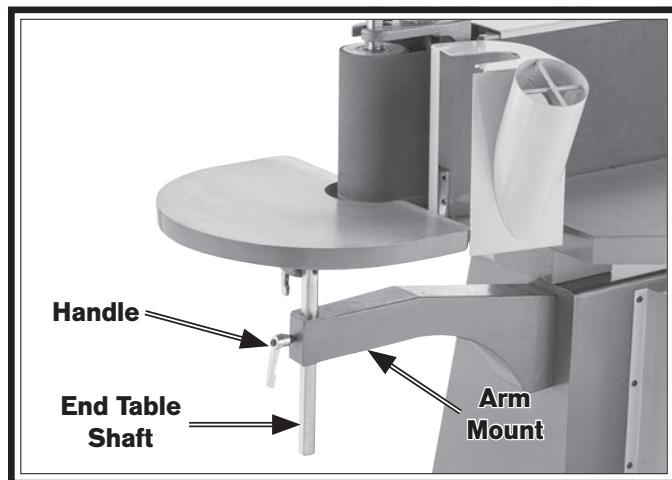


Figure 23. End table installed.

- If dust hood is in the way, loosen end table tilt lock handle (see **Figure 24**) to angle end table so it will fit past dust hood.

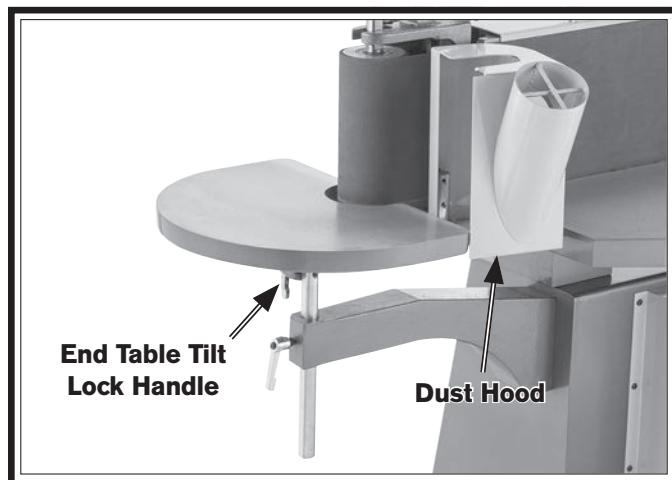


Figure 24. Location of end table tilt lock handle.

Note: Leave back stop door and end table dust hood open until instructed to close in **Test Run**.

Dust Collection

CAUTION

This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

Recommended CFM at Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect machine to dust collector:

1. Fit (2) 4" dust hoses connected to a dust collector over dust ports and secure in place with hose clamps (see **Figure 25**).

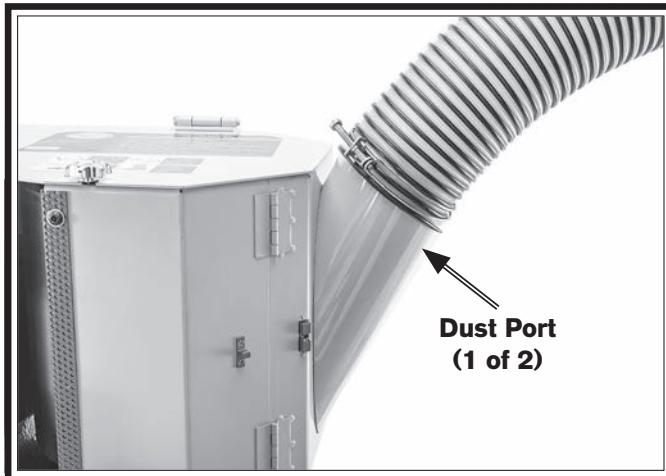


Figure 25. Dust hose connected to dust port.

2. Tug hoses to make sure they do not come off.

Note: A tight fit is necessary and ensures proper performance during operation.

Test Run

After all preparation steps have been completed, the machine and its safety features must be tested to ensure correct operation. If you discover a problem with the operation of the machine or its safety components, do not operate it further until you have resolved the problem.

Note: Refer to **Troubleshooting on Page 36** for solutions to common problems that may occur. If you need additional help, contact our Tech Support at (360) 734-1540.

The test run consists of verifying the following:

- Belt tracks properly and will not come off the drums during initial startup.
- Motor powers up and runs correctly.
- E-Stop button works correctly.

WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear away all tools and objects used during preparation and assembly.
2. Follow **Steps 2–5** as described in **Pre-Tracking Belt on Page 26** to pre-track sanding belt.

- 3.** Press E-Stop button in (see **Figure 26**).

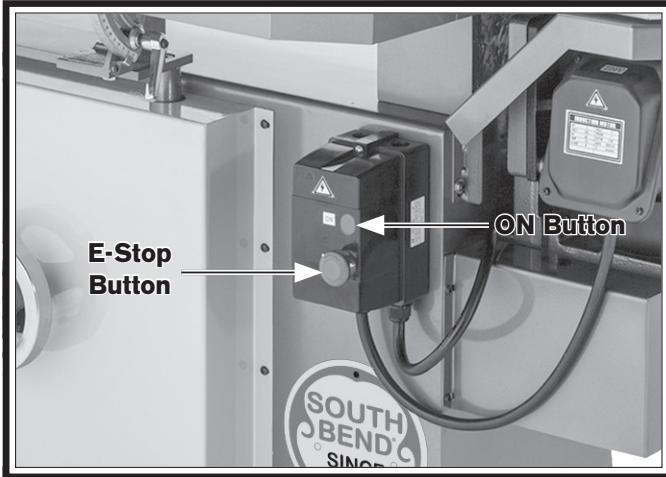


Figure 26. Power control components.

- 4.** Connect machine to power source.
- 5.** Twist E-Stop button clockwise until it springs out (see **Figure 27**). This resets the switch so machine can start.

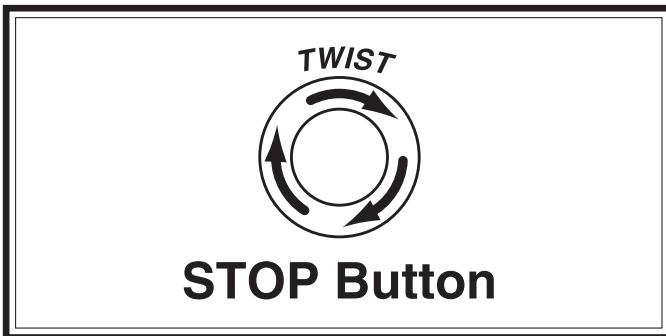


Figure 27. Resetting the switch.

- 6.** Use ON and E-Stop buttons (see **Figure 26**) to start and immediately stop machine, while watching how belt tracks on drums. Belt "tracking" refers to belt positioning on drums when belt rotates. When tracking properly, belt remains centered on drums as they rotate.
- If belt tracks centered on drums, proceed to **Step 7**.

— If belt does not track centered on drums, you must adjust belt tracking before proceeding to next step so belt is not damaged. Refer to **Checking/Adjusting Belt Tracking on Page 26** and follow **Steps 3–8** before continuing.

- 7.** Close and secure end table dust hood and back stop door.
- 8.** Start machine and allow it to run while ensuring belt tracks properly.

The motor should run smoothly and without unusual problems or noises and belt MUST rotate in same direction as arrows of belt rotation on machine.

- If motor runs smoothly and belt rotates in correct direction, proceed to **Step 9**.
- If motor *does not* run smoothly, or belt *does not* rotate in correct direction, turn machine **OFF** and disconnect power. Contact Technical Service before proceeding.
- 9.** Press E-Stop button to turn machine **OFF**.
- 10.** WITHOUT resetting E-Stop button, try to start machine by pressing ON button. Machine should not start.
- If machine *does not* start, safety feature of E-Stop button is working correctly. Congratulations! Test run is complete.
- If machine *does* start, immediately turn it **OFF** and disconnect power. Safety feature of E-Stop button is NOT working properly and must be replaced before further using machine. Contact Technical Support.

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so they can more easily understand the controls discussed later in this manual.

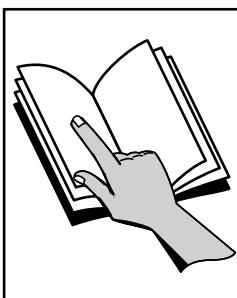
Note: Due to the generic nature of this overview, it is not intended to be an instructional guide for performing actual machine operations. To learn more about specific operations and machining techniques, seek training from people experienced with this type of machine, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, South Bend Tools will not be held liable for accidents caused by lack of training.

To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for sanding. No extreme bows, knots, or cracks should exist.
2. Prepares and trims workpiece as necessary.
3. Installs sanding belt with appropriate grit for operation.
4. Adjusts table tilt as desired, then adjusts table height to allow maximum $\frac{1}{16}$ " clearance between table and sandpaper.
5. Ties back loose hair and clothing, and puts on safety glasses and respirator. Takes all other required safety precautions.
6. Starts sander and dust collector system.
7. With both hands, holds workpiece firmly and flatly against table (and miter stop or back stop if used), and gradually eases workpiece into sanding belt.
8. Stops machine.



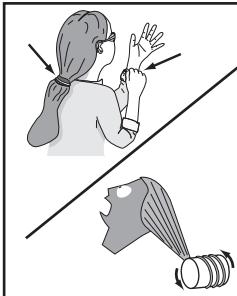
WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.



WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.



WARNING

Keep hair, clothing, and jewelry away from moving parts at all times. Entanglement can result in death, amputation, or severe crushing injuries!

Stock Inspection & Requirements

Some workpieces are not safe to sand or may require modification before they are safe to sand.

Before sanding, inspect all workpieces for the following:

- **Material Type:** This machine is intended for sanding natural and man-made wood products. This machine is NOT designed to sand metal, glass, stone, tile, plastics, drywall, cement backer board, laminate products, etc.

Sanding improper materials increases risk of respiratory harm to operator and bystanders due to especially fine dust inherently created by all types of sanding operations—even if a dust collector is used. Additionally, life of machine and sanding belts will be greatly reduced (or immediately damaged) from sanding improper materials or from exposure to fine dust created when doing so.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear sanding belt. Always visually inspect your workpiece for these items. If they cannot be removed, DO NOT sand the workpiece.
- **Wet or "Green" Stock:** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding belt, increases the risk of kickback, and yields poor results.

Sanding Tips

- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.
- Extend the life of sanding belts by regularly using a PRO-STIK® abrasive surface cleaner (see **Accessories** on **Page 32**).
- As a rule-of-thumb, sand with progressively higher grit numbers in increments of 50 or less.
- Replace sandpaper with a higher grit to achieve a finer finish (refer to **Installing/Changing Sanding Belts** on **Page 24**).
- Hold the workpiece securely with both hands. Use the tables/miter stop/back stop whenever possible to support workpieces. Do not force the workpiece against the belt.
- When sanding workpieces with a bow or crown, place the high point up on the table to prevent the workpiece from rocking, then take very light passes.
- Use the full width of the sanding belt by adjusting the table height or workpiece position so sanding is not always done in just one area.
- Make sure belt guard is closed and secured during operation.
- Belts clog and wear. Change belts whenever you notice a difference in sanding quality/performance.

WARNING

Moving belt can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Always support workpiece against table or miter stop when sanding. Use extreme care to provide a safe distance between belt and any body part.

Choosing Sanding Belts

The Model SB1117 uses a 9" x 138^{1/2}" sanding belt.

We recommend using aluminum-oxide sanding belts for best results. The grit you choose will depend on the condition and species of wood, and the level of finish you wish to achieve.

Grit	Class	Usage
36	Extra Coarse	Rough sawn boards, thickness sanding, and glue removal.
60	Coarse	Thickness sanding and glue removal.
80–100	Medium	Removing marks and initial finish sanding.
120–180	Fine	Finish sanding.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers—in increments of 50 or less. Avoid skipping grits; the larger the grit increase at one time, the harder it will be to remove the scratches from the previous grit.

Note: Sandpaper finer than 180-grit will easily load up or burn workpieces.

Installing/Changing Sanding Belts

The sanding belt should be replaced whenever there is a noticeable change in sanding quality/performance. You may also need to change grit sizes of sanding belt for quick material removal or finer finishes.

Required Sanding Belt Size9" x 138^{1/2}"

To install/change sanding belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (2) belt guard lock knobs and washers (see **Figure 28**).
3. Loosen back stop lock knob (see **Figure 28**) and open belt guard and back stop door.

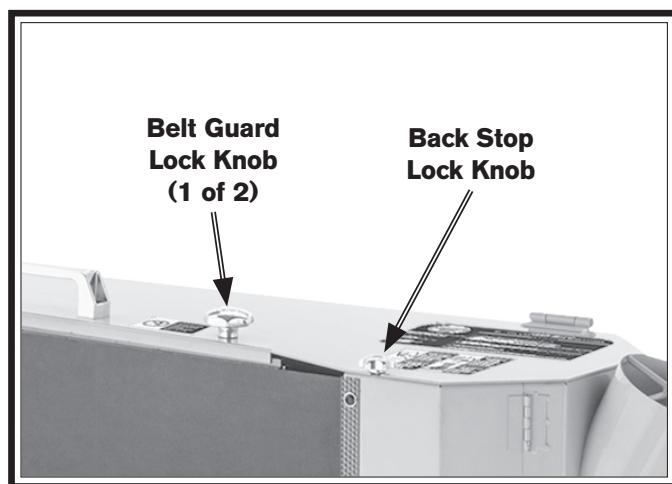


Figure 28. Belt guard components.

4. Loosen dust hood lock handle to open end table dust hood (see **Figure 29**).

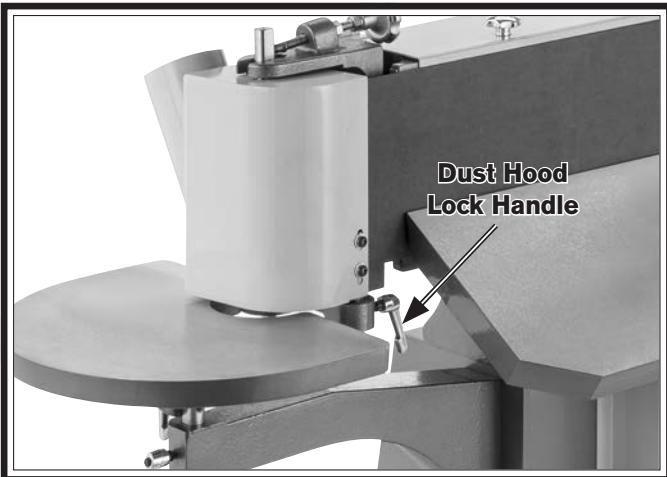


Figure 29. Location of dust hood lock handle.

5. Move belt tension lever up and toward contour drum, as shown in **Figure 30**.

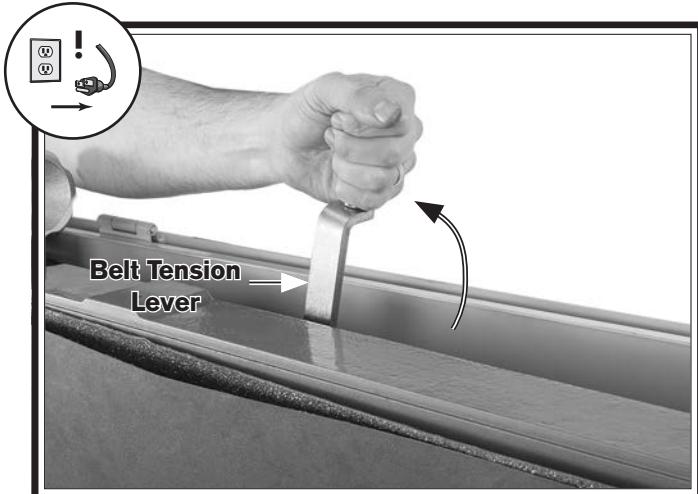


Figure 30. Moving belt tension lever to un-tensioned position.

6. Remove old sanding belt and replace with new one, being sure arrows on belt match arrows of belt rotation on machine (see **Figure 31**).

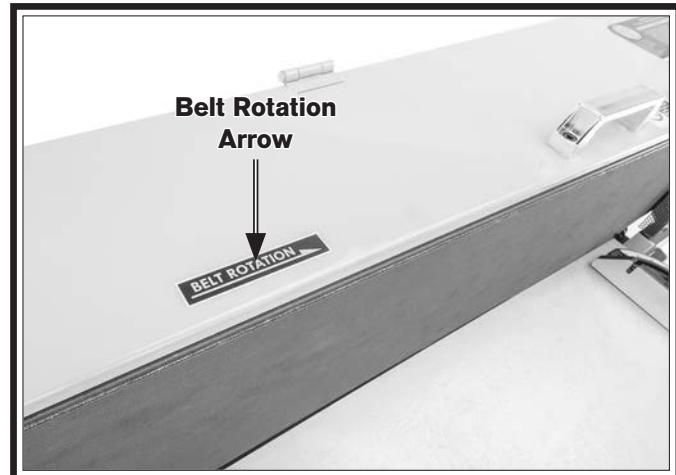


Figure 31. Sanding belt rotation arrow.

7. Move belt tension lever down to tension sanding belt (see **Figure 32**).



Figure 32. Sanding belt installed and tensioned.

8. Close belt guard and secure with lock knobs and washers removed in **Step 2**.
9. Belt MUST be pre-tracked before connecting machine to power. Proceed to **Pre-Tracking Belt on Page 26**.

Pre-Tracking Belt

You must perform the following procedure after installing a sanding belt to ensure that the belt does not come off or get jammed against the sanding belt frame.

Items Needed	Qty
Protective Gloves.....	1 Pair

To pre-track belt:

1. Install desired sanding belt as described in **Installing/Changing Sanding Belts on Page 24**.

CAUTION

Fingers or other body parts can be quickly injured if they touch moving sanding surfaces. To reduce this risk, wear gloves in next step.

2. Standing in front of sander, push sanding belt multiple times along platen, so that it moves in direction of operation (counterclockwise on rollers), then watch how belt tracks on drums.
3. Loosen jam nut shown in **Figure 33**.
4. Adjust tracking with tracking adjustment knob and continue to rotate belt by hand until sanding belt is centered on drive wheel (see **Figures 33–34**).

Note: Adjust tracking adjustment knob in about 1-turn increments.

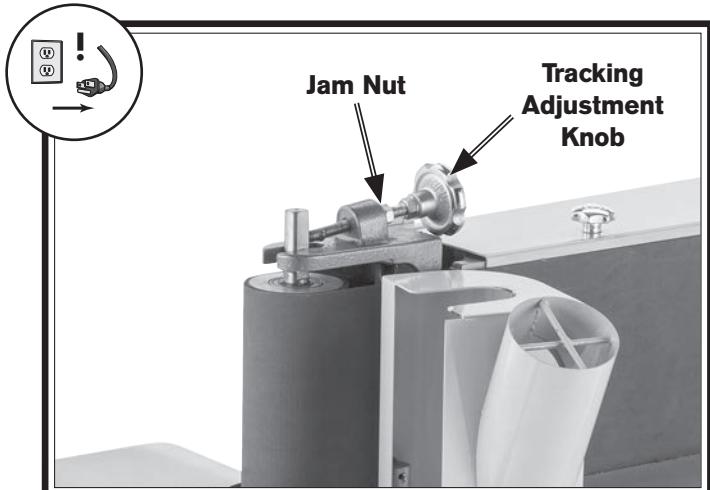


Figure 33. Belt tracking components.

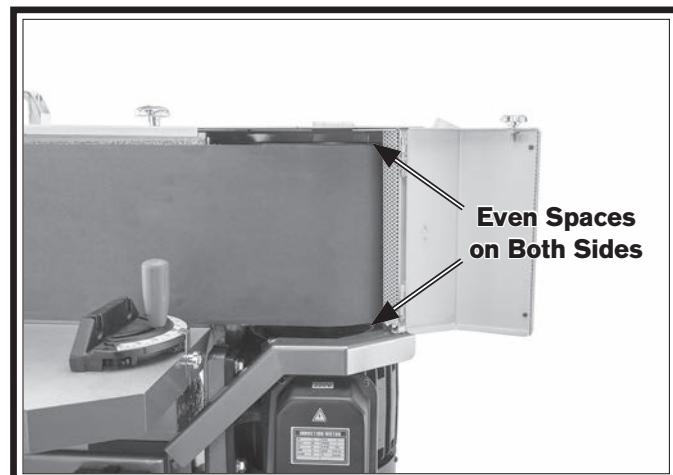


Figure 34. Example of sanding belt centered on drive wheel.

5. Once belt tracks centered on drive wheel, tighten jam nut from **Step 3** to secure setting.
6. Proceed to **Checking/Adjusting Belt Tracking** to complete belt tracking.

Checking/Adjusting Belt Tracking

The purpose of belt tracking is to make sure the belt stays centered on the drums and platen during sanding operations. The belt tracking needs to be checked any time you change or replace the belt.

If sanding belt tracking is not adjusted properly, the belt can be damaged and present a serious safety hazard if it moves off center of the drums and throws material when it contacts the belt guard and other components.

WARNING

It is necessary to connect machine to power to visually track the sanding belt tracking. DO NOT attempt to perform any adjustments to sanding belt while machine is connected to power. Failure to unplug machine before making adjustments could result in serious personal injury.

To check/adjust belt tracking:

1. Install desired sanding belt as described in **Installing/Changing Sanding Belts on Page 24**.
2. Pre-track sanding belt as described in **Pre-Tracking Belt on Page 26**.
3. Connect machine to power, press ON button, then press E-Stop button immediately after. Sander should run just long enough to observe belt tracking across drums and platen.
 - If belt tracks centered on drums, no adjustment is necessary.
 - If belt does not track centered on drums, proceed to **Step 4**.
4. DISCONNECT MACHINE FROM POWER!
5. Loosen jam nut shown in **Figure 35**.
6. Turn tracking adjustment knob counterclockwise to adjust tracking upward or clockwise to adjust tracking downward (see **Figure 35**).

Note: Adjust tracking adjustment knob in about 1-turn increments.

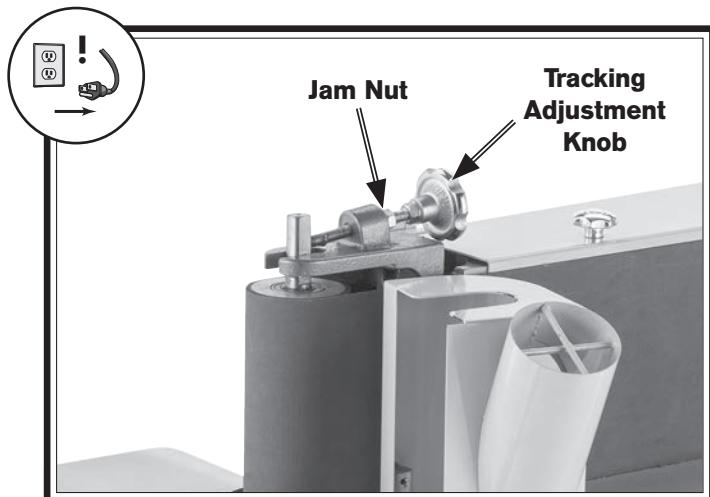


Figure 35. Belt tracking components.

7. Repeat **Steps 3–6** until belt tracks in center of drums.
8. Tighten jam nut from **Step 5** to secure setting.

Adjusting Main Table

The main table is adjustable to accommodate a wide range of workpiece and sanding operations. The table is easily adjusted up and down due to the special balance mount, and can be tilted 0°–45°.

Adjusting Main Table Height

Turn main table height handwheel counterclockwise to raise the table or clockwise to lower it (see **Figure 36**).

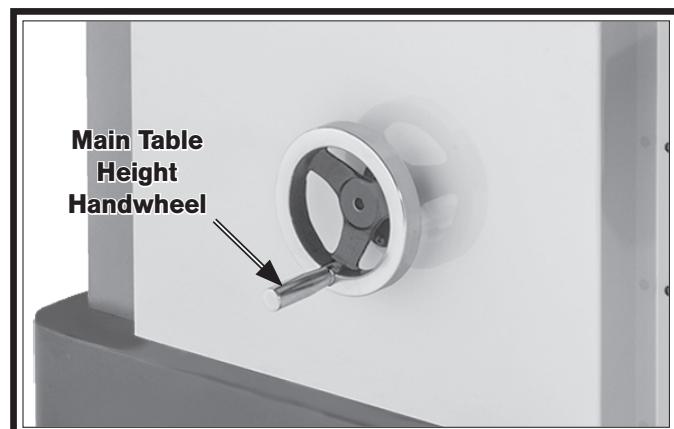


Figure 36. Location of main table height handwheel.

Adjusting Main Table Tilt

Tools Needed	Qty
Calipers.....	1
Wrench or Socket 17mm.....	1

To adjust main table tilt:

1. Loosen main table tilt lock handles (see **Figure 37**).

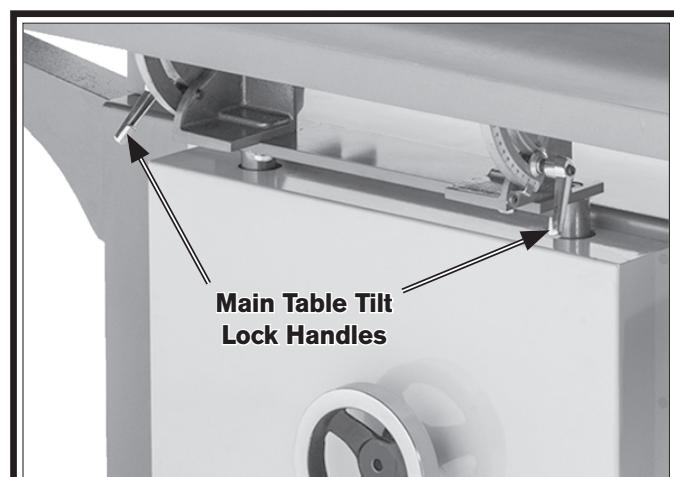


Figure 37. Location of main table tilt lock handles.

2. Tilt main table until pointer on tilt scale indicates desired angle (see **Figure 38**).

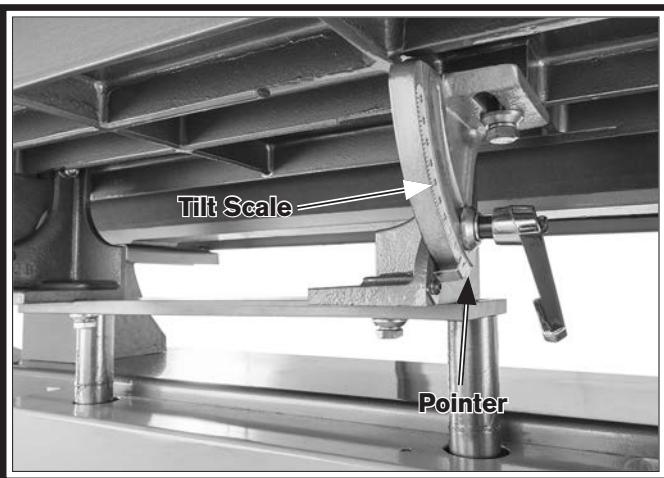


Figure 38. Main table tilt scale and pointer.

3. Tighten lock handles from **Step 1** to secure setting.
4. Measure clearance between table and sanding belt.
 - If clearance is less than $\frac{1}{16}$ ", no further adjustment is necessary.
 - If clearance is more than $\frac{1}{16}$ ", proceed to **Step 5**.
5. Loosen lock bolts shown in **Figure 39**, push table so there is $\frac{1}{16}$ " or less between table and sandpaper, then tighten bolts.

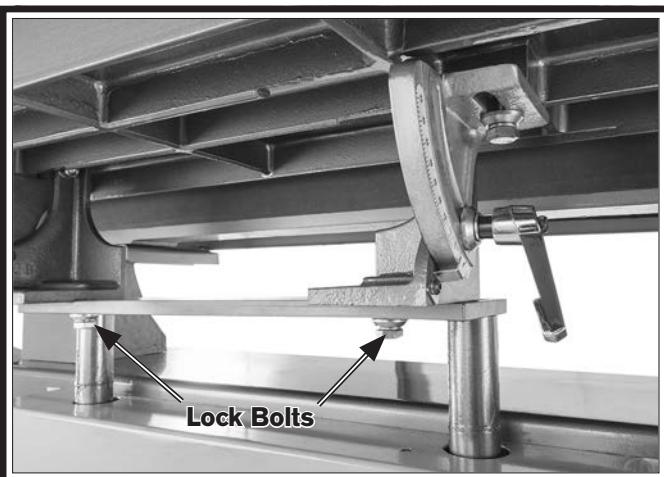


Figure 39. Location of lock bolts.

Adjusting End Table

The end table has 8" of travel and can be tilted. Loosen the dust hood lock handle (see **Figure 40**) to open the end table dust hood before adjusting the table height or tilt.

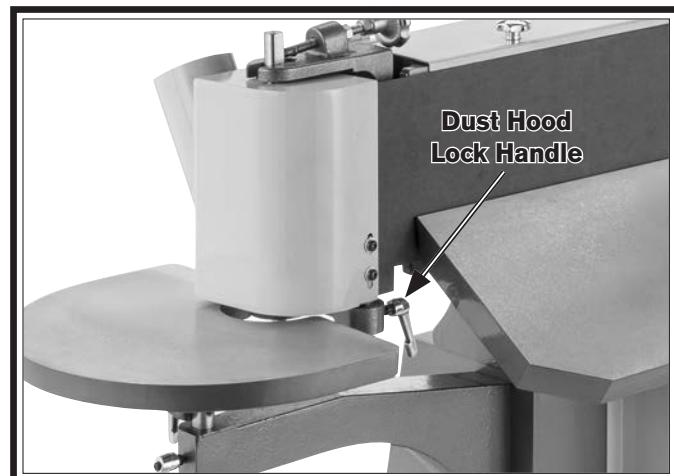


Figure 40. Location of dust hood lock handle.

Adjusting End Table Height

1. Loosen end table height lock handle (see **Figure 41**).
2. Move end table to desired height (see **Figure 41**).

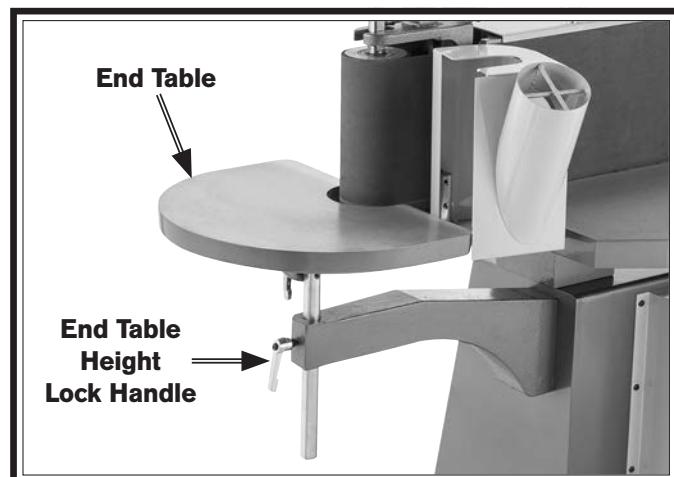


Figure 41. End table height components.

3. Tighten end table height lock handle to secure.

Adjusting End Table Tilt

1. Loosen end table tilt lock handle (see **Figure 42**).
2. Tilt end table to desired angle (see **Figure 42**).

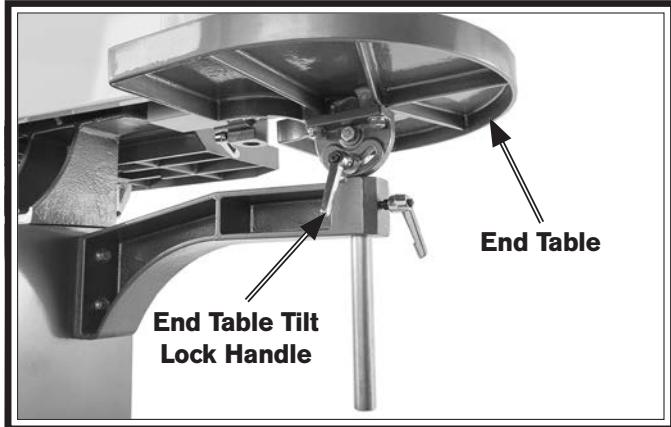


Figure 42. End table tilt components.

3. Tighten end table tilt lock handle to secure.

Adjusting Miter Stop

The main table has a stationary miter stop (see **Figure 43**) that is used to support the workpiece at various angles against the sanding belt.

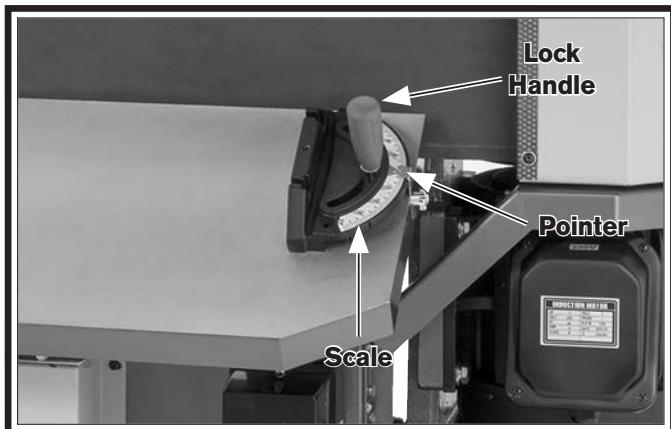


Figure 43. Main table miter stop.

To adjust miter stop:

1. Loosen lock handle shown in **Figure 43**.
2. Rotate miter stop to until pointer on scale indicates desired angle (see **Figure 43**).
3. Tighten lock handle from **Step 1** to secure.

Using Back Stop

When mitered support is not needed, the miter stop can be removed so workpieces can be instead supported by the back stop and the main table.

Note: Use these steps to re-install the miter stop and be sure to calibrate the scale before use by referring to **Calibrating Miter Stop** on **Page 35**.

To use back stop:

1. Remove lock handle and flat washer shown in **Figure 44**.
2. Remove scale pointer knob shown in **Figure 44** to remove pointer.

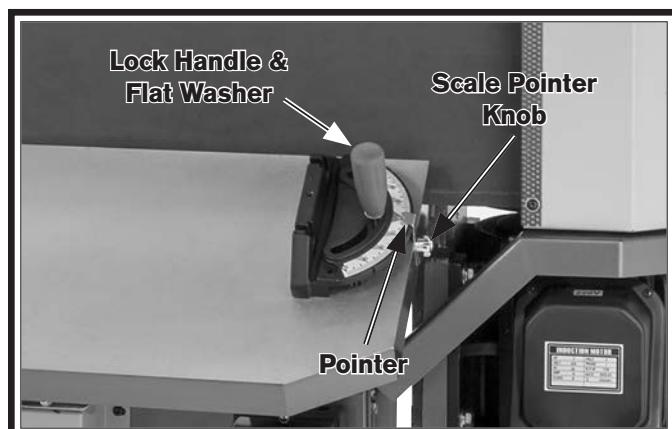


Figure 44. Miter stop removal components.

3. Remove miter stop body from table.
4. Use back stop to support workpieces, as shown in **Figure 45**.

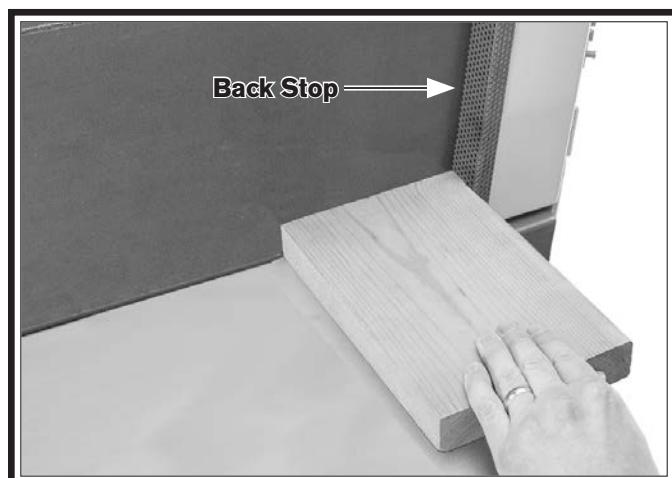


Figure 45. Workpiece supported by back stop.

Note: Loosen back stop lock knob and open back stop door to reveal hidden back stop for larger workpieces (see **Figure 46**).

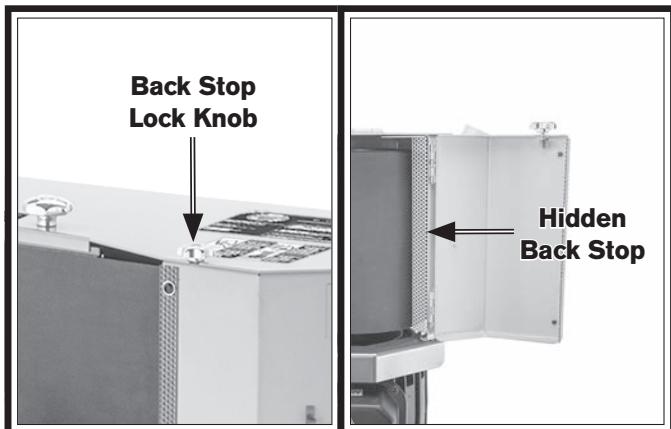


Figure 46. Hidden back stop components.

Edge & End Sanding

Proper use of the oscillating edge sander will yield excellent sanding results due to the oscillating movement. Always use the miter stop to support the workpiece whenever possible. Edge and end sanding operations are performed on the main table against the platen.

WARNING

Moving sanding belt can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Make sure workpiece is always supported against table. Use extreme care to provide a safe distance between belt and any part of your body.

CAUTION

If you must feed workpiece into sanding belt corner first, feed trailing corner first. Feeding leading corner first could cause sanding belt to grab workpiece and jerk it out of your hands.

To edge or end sand:

1. Connect machine to power, turn it **ON**, and allow it to reach full speed.
2. Raise main table to desired height and adjust table tilt to desired setting (refer to **Adjusting Main Table on Page 27**).
3. Support workpiece against miter stop and slowly feed workpiece into moving belt with light, even pressure. Maintain control of workpiece, as shown in **Figures 47–48**. DO NOT force workpiece against belt.

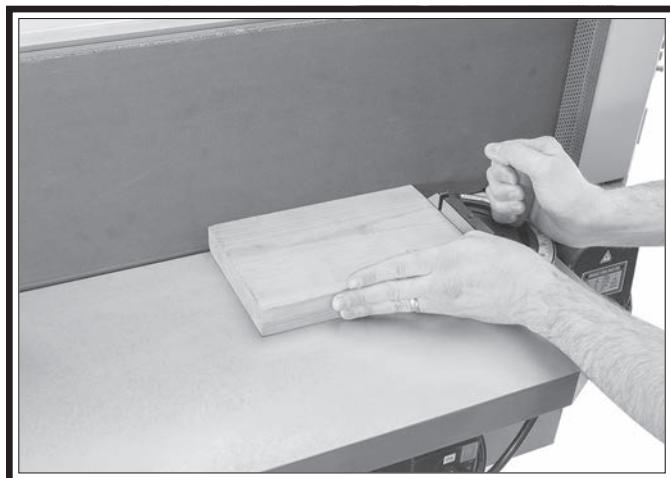


Figure 47. Typical edge sanding operation.

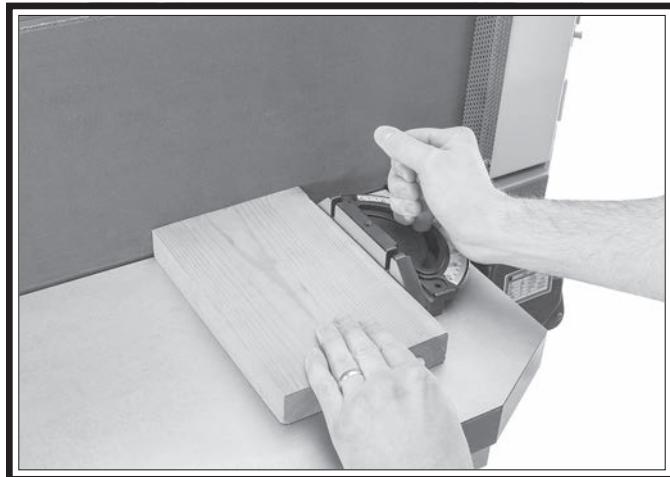


Figure 48. Typical end sanding operation.

Contour Sanding

Contour sanding operations are performed on the end table with the workpiece pressing against the idler wheel sanding drum. Always use two hands to maintain best control.

!WARNING

Do not contour sand without end table properly installed or serious personal injury could result.

To contour sand:

1. Open end table dust hood.
2. Raise end table to desired height and adjust table tilt to desired setting (refer to **Adjusting End Table on Page 28**).
3. Connect machine to power, turn it **ON**, and allow it to reach full speed.
4. While securely holding workpiece, slowly feed workpiece into moving belt with light, even pressure. Maintain control of workpiece, as shown in **Figure 49**. DO NOT force workpiece against belt.

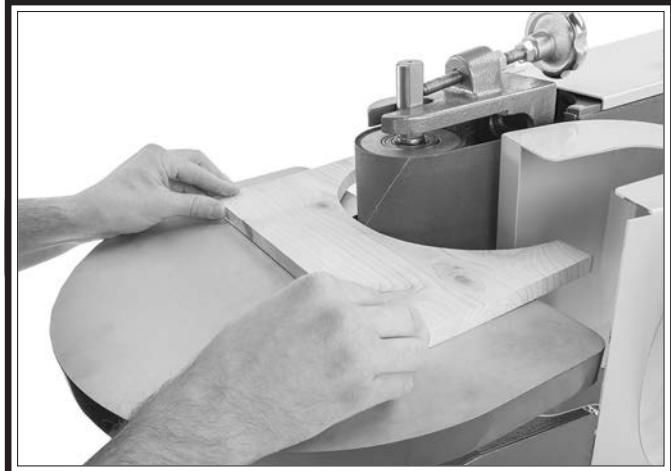


Figure 49. Typical contour sanding operation.

Bevel Sanding

Bevel sanding can take place on either the main table or the end table on the Model SB1117.

Adjust the table tilt to match the angle you wish to sand on a workpiece. Regardless of the table being used, always keep the workpiece against the table and use two hands to control it.

To bevel sand:

1. Set table tilt to match angle of bevel on workpiece, and set main table height to match workpiece thickness.
2. Connect machine to power, turn it **ON**, and allow it to reach full speed.
3. Support workpiece with table (and miter gauge or back stop if operation allows), and slowly feed workpiece into moving belt with light, even pressure (see Figures 50–51). DO NOT force workpiece against belt.



Figure 50. Bevel sanding operation example.



Figure 51. Bevel contour sanding operation example.

Accessories

This section includes the most common accessories available for your machine, which are available through our exclusive dealer, Grizzly Industrial, Inc., at grizzly.com.

WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended by South Bend or Grizzly.

NOTICE

Refer to Grizzly's website or latest catalog for additional recommended accessories.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray

H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 52. Recommended products for protecting unpainted cast iron/steel parts on machinery.

Pro-Stik® Abrasive Surface Cleaners

W1306—1½" x 1½" x 8½"

W1307—2" x 2" x 12"

Extend the life of your sanding belts! Choose the Pro-Stik® with a handle for greater control or without a handle for more usable area.

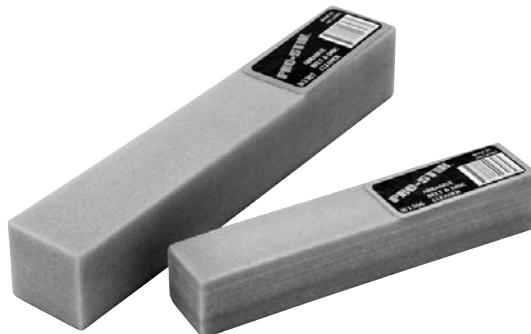


Figure 53. Pro-Stik® abrasive surface cleaners.

A/O Sanding Belts 9" x 138½"

H4181—60-Grit

H4182—80-Grit

H4183—100-Grit

H4184—120-Grit

H4185—150-Grit

These belts feature tough aluminum oxide grain and are sized for the Model SB1117.

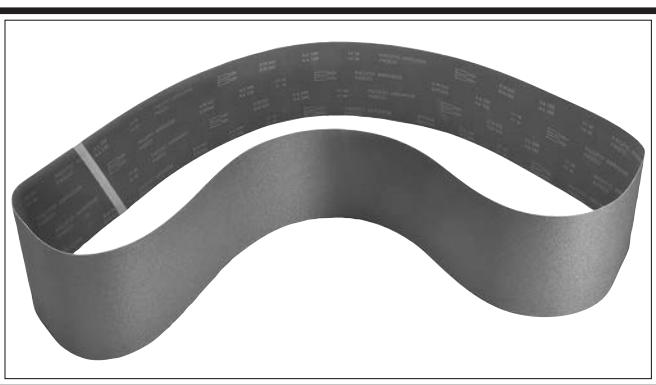
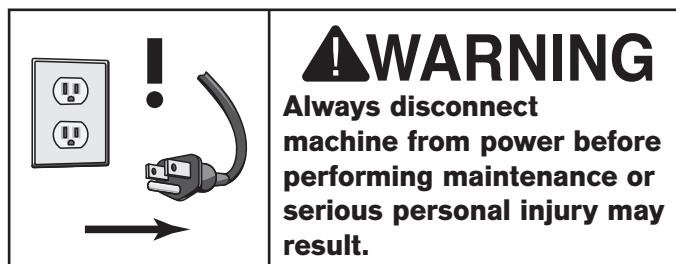


Figure 54. Model H4181 60-Grit Sanding Belt.

order online at www.grizzly.com or call 1-800-523-4777

Maintenance Schedule



For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

- Check/correct loose mounting bolts.
- Check/replace damaged sanding belt.
- Check/replace worn switch.
- Check/replace worn or damaged wires.
- Clean/protect table.
- Correct any other unsafe condition.

Monthly

- Lubricate oscillation grease fittings.
- Clean/vacuum dust buildup from inside cabinet and belt guard and off motor.

Cleaning & Protecting

Bare metal surfaces can quickly develop surface rust if not coated. Machinery stored near windows in direct sunlight or where paints, thinners, or certain gasses are open to the air can experience bleaching, discoloring of paint or yellowing of clear plastic guards.

Cleaning the SB1117 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Page 32 for more details).

Lubrication

The oscillation grease fittings shown in **Figure 55** should be lubricated once every 50 hours of operation with a thin coat of light machine oil and 1–2 pumps of NLGI #2 or Syn-O-Gen grease.



Figure 55. Location of oscillation grease fittings.

T26419—Syn-O-Gen Synthetic Grease

Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water-resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.



Figure 56. Model T26419 Syn-O-Gen Synthetic Grease (NLGI #2 equivalent).

Machine Storage

All machinery will develop serious rust or corrosion damage if it is not properly prepared for storage. If decommissioning this machine, disconnect all power sources, thoroughly clean bare metal surfaces, coat them with light weight grease or rust preventative, and cover machine with a tarp or plastic sheet to keep out dust.

Calibrating Main Table Tilt

For best sanding results, ensure the table angle is calibrated correctly. If calibrated correctly, the scale should read 0° when perpendicular to the sanding belt.

Tools Needed

	Qty
90° Square	1
Hex Wrench 3mm	1

To calibrate main table tilt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove sanding belt.
3. Set one edge of 90° square on main table surface and other edge against face of platen, as shown in **Figure 57**.

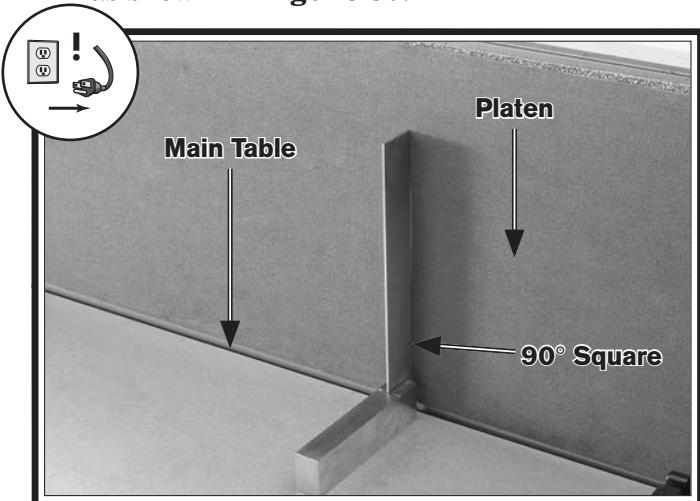


Figure 57. Square positioned to check table angle.

4. Adjust main table angle until perpendicular to face of platen.
 - If tilt scale reads 0° when main table is perpendicular to platen, no calibration is required.
 - If tilt scale *does not* read 0° when main table is perpendicular to platen, proceed to **Step 5**.
5. Loosen scale pointer button head cap screw (see **Figure 58**), adjust pointer to 0°, then tighten screw.

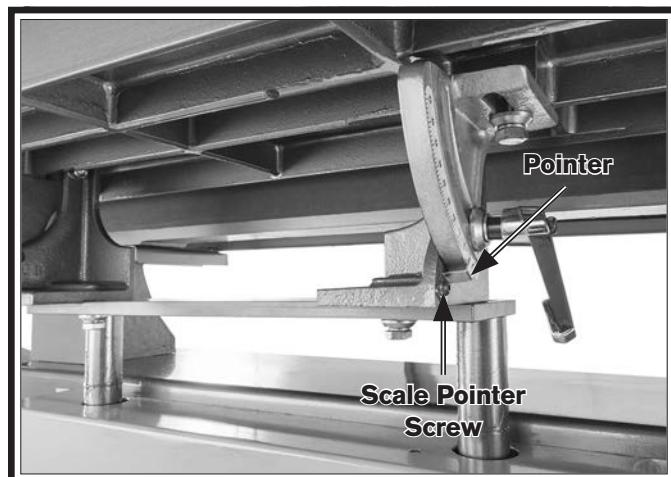


Figure 58. Tilt scale pointer components.

6. Check accuracy with 90° square before installing sanding belt.

Calibrating Miter Stop

This procedure ensures the miter stop angle is accurate when set to 0°.

Tool Needed	Qty
90° Square	1

To calibrate miter stop:

1. DISCONNECT MACHINE FROM POWER!
2. Remove sanding belt.
3. Set one edge of 90° square against miter stop and other edge against face of platen, as shown in **Figure 59**.

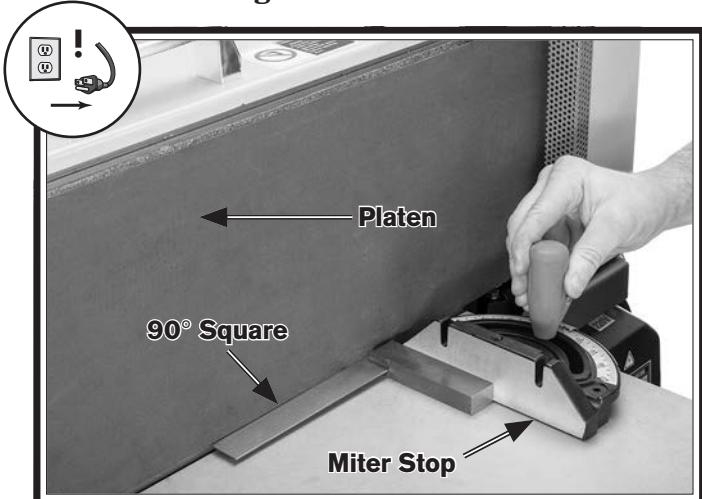


Figure 59. Square positioned to miter angle.

4. Adjust miter stop angle until perpendicular to face of platen.
 - If miter scale reads 0° when miter stop is perpendicular to platen, no calibration is required.
 - If miter scale *does not* read 0° when miter stop is perpendicular to platen, proceed to **Step 5**.
5. Loosen scale pointer knob (see **Figure 60**), adjust pointer to 0°, then tighten knob.

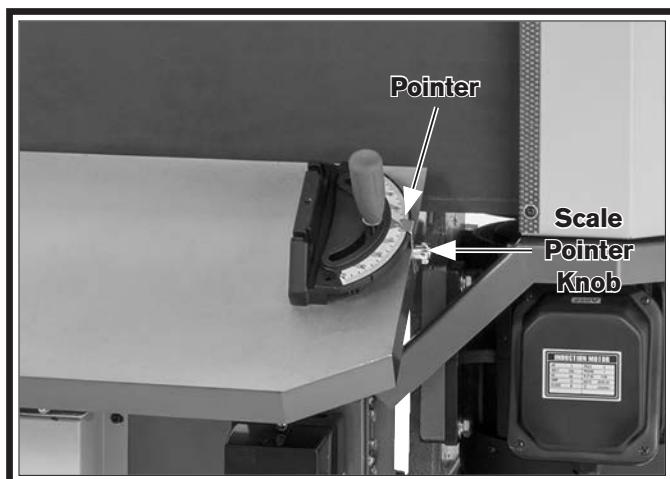


Figure 60. Miter scale pointer components.

6. Check accuracy with 90° square before installing sanding belt.

If you need replacement parts, or if you are unsure how to do any of the solutions given here, feel free to call us at (360) 734-1540.

Symptom	Possible Cause	Possible Solution
Machine does not start or power supply breaker trips immediately after startup.	<ol style="list-style-type: none"> 1. E-Stop button depressed/at fault. 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped or fuse blown. 4. Motor wires connected incorrectly. 5. Thermal overload relay has tripped/at fault. 6. Start capacitor at fault. 7. Contactor not energized/at fault. 8. Wiring broken, disconnected, or corroded. 9. Centrifugal switch adjustment/contact points at fault. 10. ON button at fault. 11. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Rotate E-Stop button head to reset. Replace if at fault. 2. Ensure correct power supply voltage and circuit size. 3. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 4. Correct motor wiring connections. 5. Reset. Adjust or replace if at fault. 6. Test/replace if at fault. 7. Test all legs for power; replace if necessary. 8. Fix broken wires or disconnected/corroded connections. 9. Adjust centrifugal switch/clean contact points. Replace either if at fault. 10. Replace button. 11. Replace motor.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Workpiece material unsuitable for machine. 2. Motor wires connected incorrectly. 3. Machine undersized for task. 4. Motor overheated. 5. Run capacitor at fault. 6. Extension cord too long. 7. Contactor not energized/at fault. 8. Centrifugal switch/contact points at fault. 9. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Only sand wood/ensure moisture is below 20% (Page 23). 2. Correct motor wiring connections. 3. Clean (Page 32)/replace sandpaper (Page 24); reduce feed rate/sanding depth. 4. Clean motor, let cool, and reduce workload. 5. Test/repair/replace. 6. Move machine closer to power supply; use shorter extension cord. 7. Test all legs for power; repair/replace if necessary. 8. Adjust centrifugal switch/clean contact points. Replace either if at fault. 9. Replace motor.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Stand feet not adjusted properly. 3. Drive wheel cap screw is missing or loose. 4. Motor fan rubbing on fan cover. 5. Centrifugal switch at fault. 6. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Adjust stand feet to stabilize machine. 3. Inspect keys and set screws. Replace or tighten if necessary. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Adjust/replace if at fault. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Sanding belt slaps or vibrates excessively.	<ol style="list-style-type: none"> 1. Incorrect sanding belt tension. 2. Belt tracking needs adjustment. 3. Broken/defective sanding belt. 4. Idler wheel is too loose. 5. Weak or broken tension spring. 	<ol style="list-style-type: none"> 1. Make sure tension lever is engaged (Page 24). 2. Adjust sanding belt tracking (Page 26). 3. Replace sanding belt (Page 24). 4. Tighten idler roller. 5. Replace spring.

Symptom	Possible Cause	Possible Solution
Sanded surface not square when main table tilt and miter stop both set to 0°.	<ol style="list-style-type: none"> 1. Main table not perpendicular to platen/belt. 2. Miter stop not perpendicular to platen/belt. 	<ol style="list-style-type: none"> 1. Calibrate tilt scale (Page 34). 2. Calibrate miter stop scale (Page 35).
Deep sanding grooves or scores in workpiece.	<ol style="list-style-type: none"> 1. Using too coarse of sanding grit. 2. Workpiece sanded across grain. 3. Too much pressure against belt. 4. Workpiece held still for too long. 5. Graphite pad on platen damaged. 	<ol style="list-style-type: none"> 1. Use finer grit sanding belt (Page 24). 2. Sand with workpiece grain. 3. Reduce pressure on workpiece while sanding. 4. Do not keep workpiece in one place for too long. 5. Replace graphite pad.
Abrasive grit rubs off the belt easily.	<ol style="list-style-type: none"> 1. Sanding belt has been stored in an incorrect environment. 2. Sanding belt has been folded or crushed. 	<ol style="list-style-type: none"> 1. Replace sanding belt (Page 24). Store sanding belt in a cool, dry area. 2. Replace sanding belt (Page 24). Store sanding belt flat, not folded or bent.
Snake-shaped marks on workpiece.	<ol style="list-style-type: none"> 1. Sanding belt loaded with sawdust, resin, and/or pitch. 2. Sanding belt damaged. 	<ol style="list-style-type: none"> 1. Clean (Page 32) or replace belt (Page 24). 2. Replace sanding belt (Page 24).
Sanding belt surfaces clog quickly or burn.	<ol style="list-style-type: none"> 1. Worn sanding belt. 2. Too much pressure against belt. 3. Sanding softwood. 4. Workpiece has high moisture content or sap. 5. Using too fine of sanding grit. 6. Poor dust collection. 	<ol style="list-style-type: none"> 1. Replace sanding belt (Page 24). 2. Reduce pressure on workpiece while sanding. 3. Use different stock or accept characteristics of workpiece and plan on cleaning/replacing belt frequently. 4. Use different stock or accept characteristics of workpiece and plan on cleaning (Page 32)/replacing belt frequently (Page 24). 5. Use coarser grit sanding belt (Page 24). 6. Unclog ducts; close gates to improve suction; re-design dust collection system.
Burn marks on workpiece.	<ol style="list-style-type: none"> 1. Using too fine of sanding grit. 2. Too much pressure against belt. 3. Workpiece held still for too long. 4. Sanding belt loaded with sawdust, resin, and/or pitch. 	<ol style="list-style-type: none"> 1. Use coarser grit sanding belt (Page 24). 2. Reduce pressure on workpiece while sanding. 3. Do not keep workpiece in one place for too long. 4. Clean (Page 32) or replace belt (Page 24).
Glazed sanding surfaces.	<ol style="list-style-type: none"> 1. Sanding wet stock. 2. Sanding stock with high pitch/residue. 3. Belt worn or filled with pitch/residue. 	<ol style="list-style-type: none"> 1. Dry stock properly before sanding (Page 23). 2. Use different stock or accept characteristics of workpiece and plan on cleaning (Page 32)/replacing belt frequently (Page 24). 3. Replace belt or clean pitch/residue from belt (Page 32).
Workpiece frequently gets pulled out of your hand.	<ol style="list-style-type: none"> 1. Not supporting workpiece properly. 2. Starting workpiece on a leading corner. 	<ol style="list-style-type: none"> 1. Use backstop/miter stop to support workpiece. 2. Start workpiece on a trailing corner.
Belt does not track correctly.	<ol style="list-style-type: none"> 1. Belt tracking needs adjustment. 2. Incorrect sanding belt tension. 3. Sanding belt damaged, worn, or misshapen. 	<ol style="list-style-type: none"> 1. Adjust sanding belt tracking (Page 26). 2. Make sure tension lever is engaged. (Page 24). 3. Replace sanding belt (Page 24).

Electrical Safety Instructions

These pages are accurate at the time of printing. In the constant effort to improve, however, we may make changes to the electrical systems of future machines. Study this section carefully. If you see differences between your machine and what is shown in this section, call Technical Support at (360) 734-1540 for assistance BEFORE making any changes to the wiring on your machine.

Shock Hazard: It is extremely dangerous to perform electrical or wiring tasks while the machine is connected to the power source. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. For your own safety, disconnect machine from the power source before servicing electrical components or performing any wiring tasks!

Wire Connections: All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

Modifications: Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

Motor Wiring: The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

Circuit Requirements: Connecting the machine to an improperly sized circuit will greatly increase the risk of fire. To minimize this risk, only connect the machine to a power circuit that meets the minimum requirements given in this manual.

Capacitors/Inverters: Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

Wire/Component Damage: Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.

Experiencing Difficulties: If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (360) 734-1540.

WIRING DIAGRAM COLOR KEY

BLACK	Bk	BLUE	Bw	RED	Rd	PINK	Pk	WHITE	Wt
BLUE	Bl	WHITE	Gn	LIGHT	Lb			YELLOW	Yg
BROWN	Br	GREEN	Gy	BLUE	Or	PURPLE	Pu	GREEN	Yl

NOTICE: The photos and diagrams included in this section are best viewed in color. You can see them in color at www.southbendtools.com.

Wiring Diagram

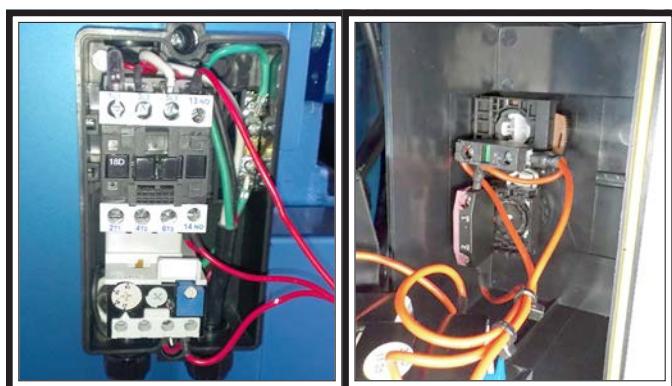
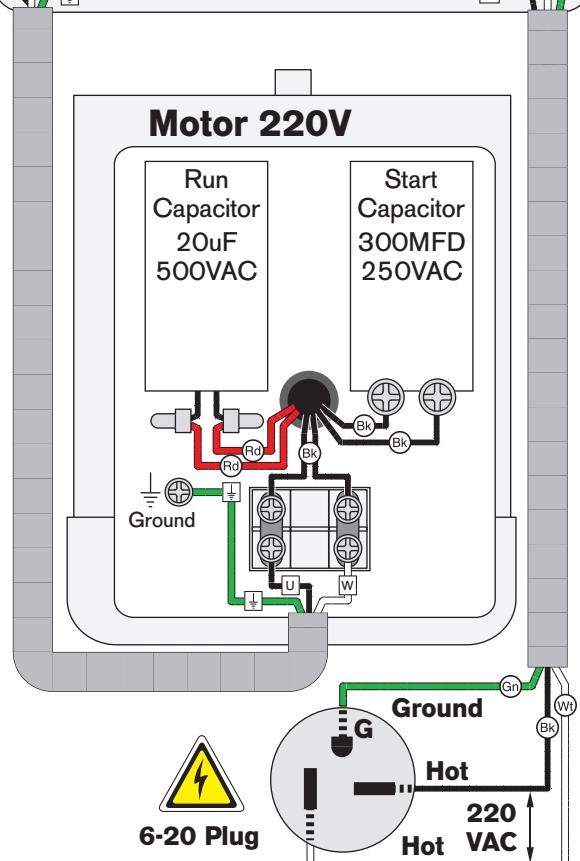
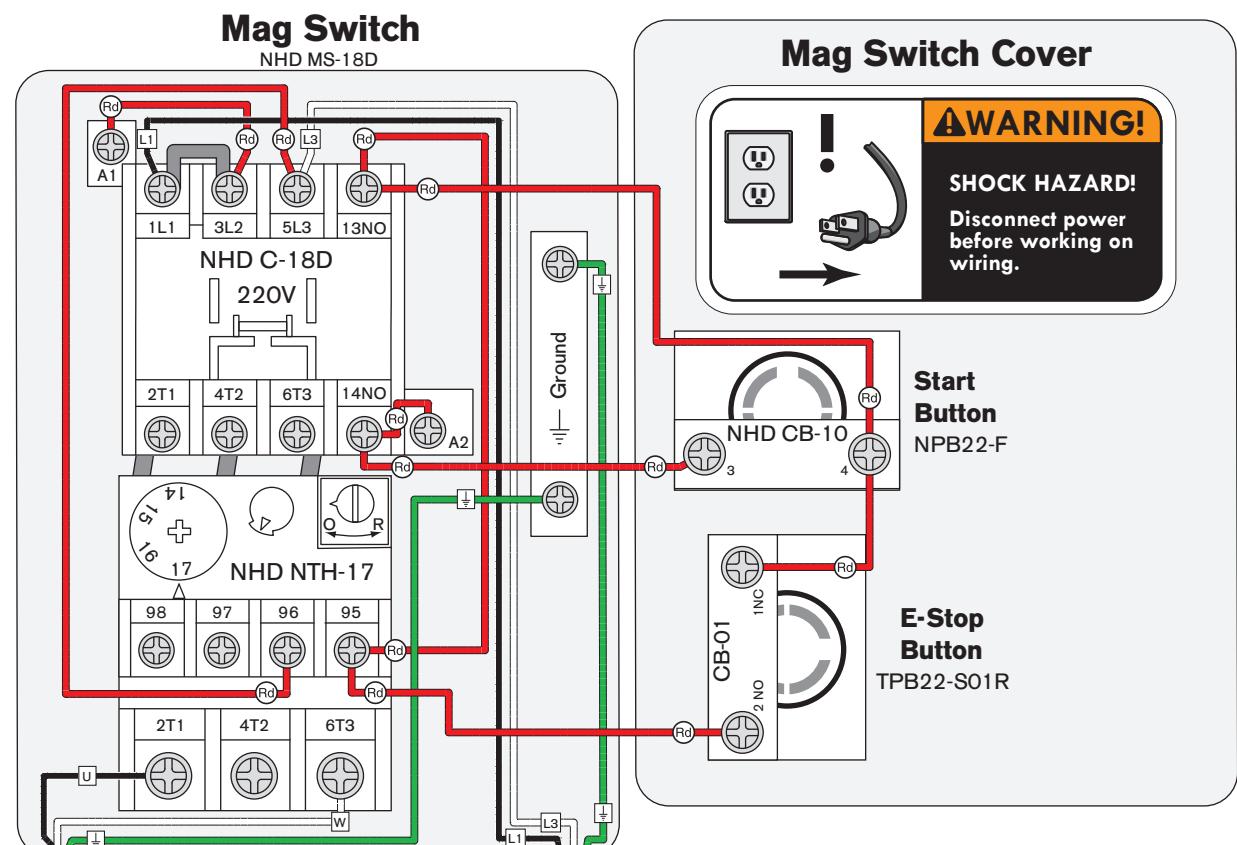
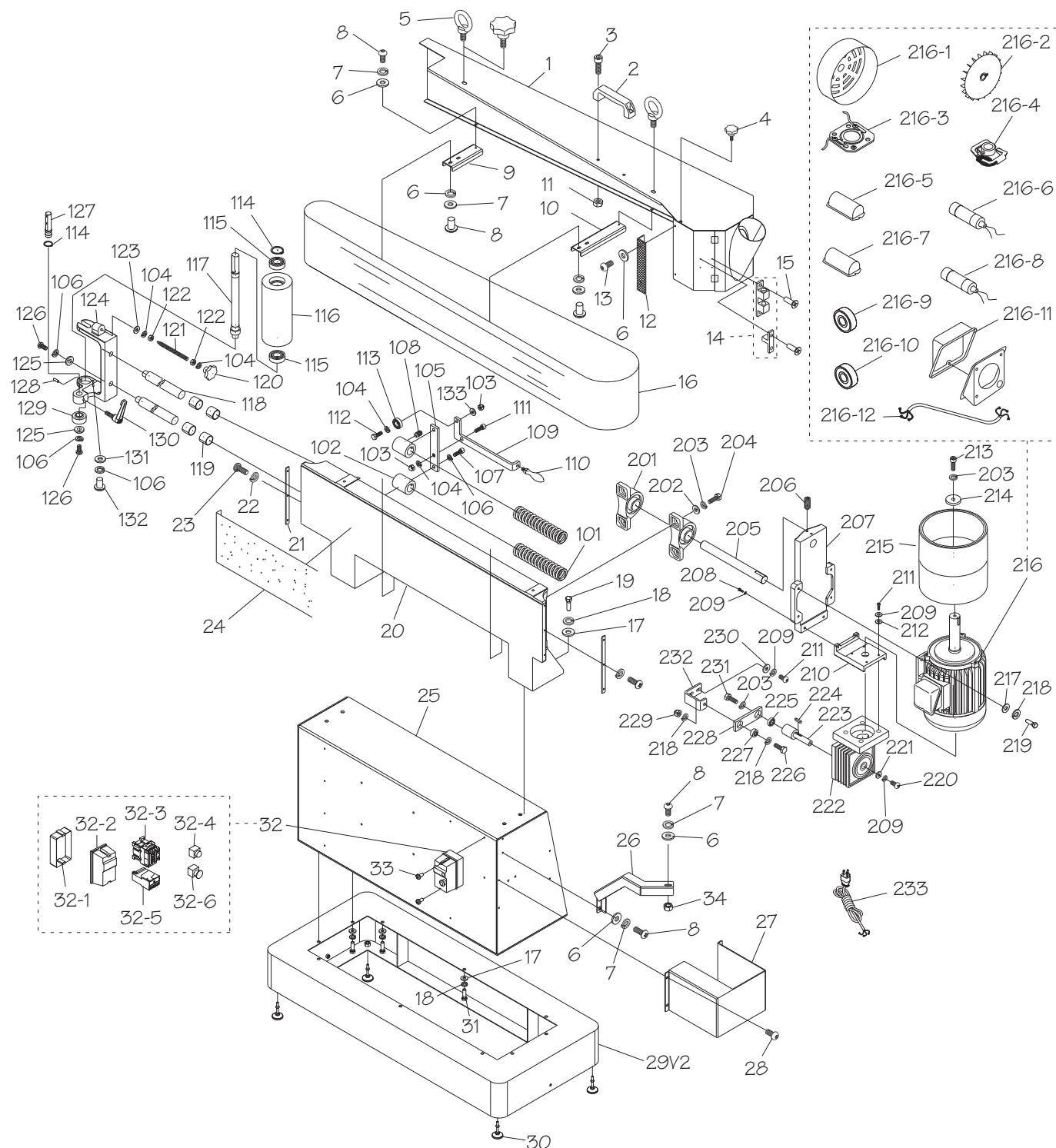


Figure 61. Magnetic switch wiring.



Figure 62. Motor junction box wiring.

Main



REF	PART #	DESCRIPTION
1	PSB1117001	SANDING BELT GUARD
2	PSB1117002	GUARD HANDLE
3	PSB1117003	CAP SCREW M8-1.25 X 16
4	PSB1117004	KNOB BOLT 1/4-20 X 3/4, 7-LOBE, D1-1/8
5	PSB1117005	EYE BOLT 1", M10-1.5 X 18

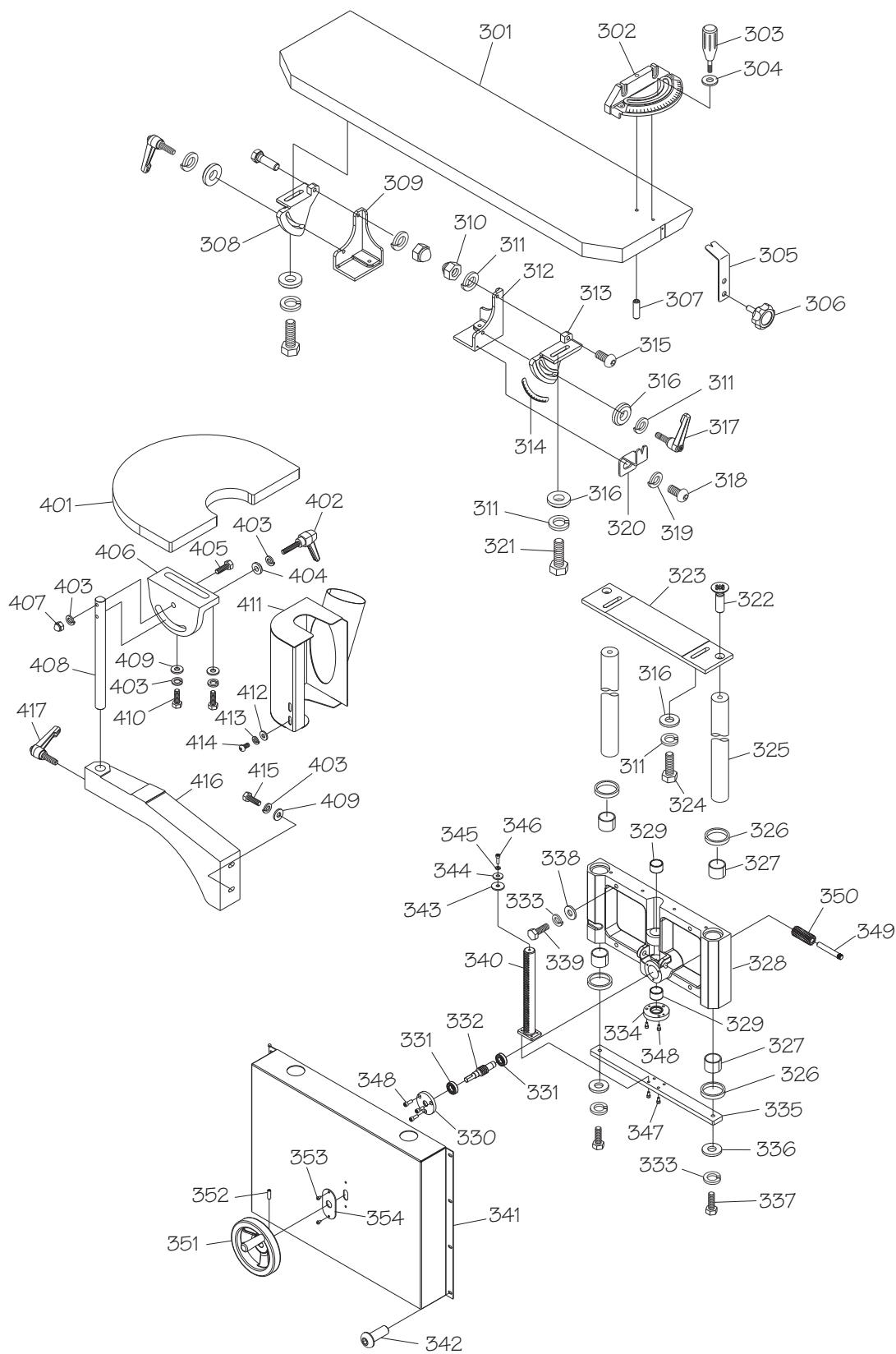
REF	PART #	DESCRIPTION
6	PSB1117006	FLAT WASHER 6MM
7	PSB1117007	LOCK WASHER 6MM
8	PSB1117008	BUTTON HD CAP SCR M6-1 X 16
9	PSB1117009	GUARD BRACKET (SHORT)
10	PSB1117010	GUARD BRACKET (LONG)

Main Parts List

REF	PART #	DESCRIPTION
11	PSB1117011	HEX NUT M8-1.25
12	PSB1117012	STOP GUARD
13	PSB1117013	BUTTON HD CAP SCR M6-1 X 8
14	PSB1117014	BALL-STYLE GRAB LATCH
15	PSB1117015	FLAT HD SCR M3-5 X 6
16	PSB1117016	SANDING BELT 9" X 138-1/2" 180-GRIT
17	PSB1117017	FLAT WASHER 10MM
18	PSB1117018	LOCK WASHER 10MM
19	PSB1117019	HEX BOLT M10-1.5 X 40
20	PSB1117020	PLATEN
21	PSB1117021	GRAPHITE PAD BRACKET
22	PSB1117022	LOCK WASHER 5MM
23	PSB1117023	BUTTON HD CAP SCR M5-.8 X 16
24	PSB1117024	GRAPHITE PAD 9" X 50-3/8"
25	PSB1117025	MACHINE BASE
26	PSB1117026	GUARD SUPPORT
27	PSB1117027	GEARBOX COVER
28	PSB1117028	BUTTON HD CAP SCR M6-1 X 12
29V2	PSB1117029V2	BASE SUPPORT V2.03.22
30	PSB1117030	FOOT M12-1.75 X 40
31	PSB1117031	HEX BOLT M10-1.5 X 25
32	PSB1117032	MAG SWITCH NHD M5-18D
32-1	PSB1117032-1	SWITCH BOX
32-2	PSB1117032-2	SWITCH BOX COVER
32-3	PSB1117032-3	CONTACTOR C-18D 220V
32-4	PSB1117032-4	START BUTTON NPB22-F
32-5	PSB1117032-5	OL RELAY NTH-1714-17A
32-6	PSB1117032-6	E-STOP BUTTON TPB22-S01R
33	PSB1117033	PHLP HD SCR 10-24 X 1/2
34	PSB1117034	HEX NUT M6-1
101	PSB1117101	COMPRESSION SPRING 5.5 X 43 X 236
102	PSB1117102	LOCK COLLAR 49 X 60
103	PSB1117103	ACORN NUT M12-1.75
104	PSB1117104	LOCK WASHER 12MM
105	PSB1117105	TENSION PLATE 9.5 X 31.8 X 175
106	PSB1117106	LOCK WASHER 10MM
107	PSB1117107	CAP SCREW M10-1.5 X 20
108	PSB1117108	SET SCREW M10-1.5 X 10
109	PSB1117109	TENSION LEVER
110	PSB1117110	REVOLVING HANDLE 25 X 85, M10-1.25 X 12
111	PSB1117111	CAP SCREW M12-1.75 X 30
112	PSB1117112	HEX BOLT M12-1.75 X 30
113	PSB1117113	BALL BEARING 6201ZZ
114	PSB1117114	EXT RETAINING RING 25MM
115	PSB1117115	BALL BEARING 6205ZZ
116	PSB1117116	IDLER WHEEL
117	PSB1117117	WHEEL SHAFT 25 X 334
118	PSB1117118	TENSION SHAFT 30 X 550
119	PSB1117119	BUSHING 30 X 34 X 25
120	PSB1117120	KNOB M12-1.75, 7-LOBE, D60
121	PSB1117121	TAPERED THREADED ROD M12-1.75 X 155
122	PSB1117122	HEX NUT M12-1.75
123	PSB1117123	FLAT WASHER 10MM
124	PSB1117124	TENSION BRACKET

REF	PART #	DESCRIPTION
125	PSB1117125	FENDER WASHER 10 X 25 X 6
126	PSB1117126	BUTTON HD CAP SCR M10-1.5 X 25
127	PSB1117127	TENSION MOUNTING SHAFT 25 X 112
128	PSB1117128	SET SCREW M6-1 X 12
129	PSB1117129	SPHERICAL BEARING PB-20
130	PSB1117130	FIXED HANDLE 21 X 81, M10-1.5 X 30
131	PSB1117131	FLAT WASHER 10MM
132	PSB1117132	BUTTON HD CAP SCR M10-1.5 X 16
133	PSB1117133	FLAT WASHER 12MM
201	PSB1117201	PILLOW BEARING UCP107
202	PSB1117202	FLAT WASHER 12MM
203	PSB1117203	LOCK WASHER 12MM
204	PSB1117204	HEX BOLT M12-1.75 X 40
205	PSB1117205	OSCILLATION SHAFT 35 X 355
206	PSB1117206	SET SCREW M10-1.5 X 10
207	PSB1117207	MOTOR MOUNT
208	PSB1117208	HEX BOLT M8-1.25 X 35
209	PSB1117209	LOCK WASHER 8MM
210	PSB1117210	MOTOR/GEARBOX BRACKET
211	PSB1117211	BUTTON HD CAP SCR M8-1.25 X 20
212	PSB1117212	FLAT WASHER 8MM
213	PSB1117213	CAP SCREW M12-1.75 X 35
214	PSB1117214	FENDER WASHER 14MM
215	PSB1117215	DRIVE WHEEL
216	PSB1117216	MOTOR 3HP 220V1-PH
216-1	PSB1117216-1	MOTOR FAN COVER
216-2	PSB1117216-2	MOTOR FAN
216-3	PSB1117216-3	CONTACT PLATE 24 X 67MM
216-4	PSB1117216-4	CENTRIFUGAL SWITCH 3/4 1720 RPM
216-5	PSB1117216-5	S CAPACITOR COVER
216-6	PSB1117216-6	S CAPACITOR 300M 250V 1-3/4 X 3-5/8
216-7	PSB1117216-7	R CAPACITOR COVER
216-8	PSB1117216-8	R CAPACITOR 20M 500V 2 X 3-5/8
216-9	PSB1117216-9	BALL BEARING 6308ZZ (FRONT)
216-10	PSB1117216-10	BALL BEARING 6205ZZ (REAR)
216-11	PSB1117216-11	MOTOR JUNCTION BOX
216-12	PSB1117216-12	MOTOR CORD 12G 3W 24"
217	PSB1117217	FLAT WASHER 10MM
218	PSB1117218	LOCK WASHER 10MM
219	PSB1117219	HEX BOLT M10-1.5 X 35
220	PSB1117220	BUTTON HD CAP SCR M8-1.25 X 25
221	PSB1117221	FENDER WASHER 8MM
222	PSB1117222	GEARBOX REDUCER
223	PSB1117223	PLUG-IN SHAFT 35 X 120
224	PSB1117224	KEY 6 X 6 X 30 RE
225	PSB1117225	BALL BEARING 6001ZZ
226	PSB1117226	HEX BOLT M10-1.5 X 30
227	PSB1117227	SPHERICAL BEARING PB-10
228	PSB1117228	BEARING HOUSING
229	PSB1117229	ACORN NUT M10-1.25
230	PSB1117230	FLAT WASHER 8MM
231	PSB1117231	HEX BOLT M12-1.75 X 30
232	PSB1117232	GEARBOX MOUNTING BRACKET
233	PSB1117233	POWER CORD 12G 3W 110" 6-20P

Tables



Tables Parts List

REF	PART #	DESCRIPTION
301	PSB1117301	MAIN TABLE
302	PSB1117302	MITER GAUGE
303	PSB1117303	FIXED HANDLE 1-3/16 X 3-1/8
304	PSB1117304	FENDER WASHER 10 X 25 X 6
305	PSB1117305	MITER ANGLE POINTER
306	PSB1117306	KNOB BOLT M5-.8 X 10, 6-LOBE, D20
307	PSB1117307	HINGE PIN M8-1.25 X 20
308	PSB1117308	TRUNNION (LEFT)
309	PSB1117309	TRUNNION MOUNT (LEFT)
310	PSB1117310	ACORN NUT M10-1.5
311	PSB1117311	LOCK WASHER 10MM
312	PSB1117312	TRUNNION MOUNT (RIGHT)
313	PSB1117313	TRUNNION (RIGHT)
314	PSB1117314	ANGLE SCALE
315	PSB1117315	BUTTON HD CAP SCR M10-1.5 X 35
316	PSB1117316	FENDER WASHER 10 X 25 X 6
317	PSB1117317	FIXED HANDLE 21 X 81, M10-1.5 X 35
318	PSB1117318	BUTTON HD CAP SCR M5-.8 X 10
319	PSB1117319	LOCK WASHER 5MM
320	PSB1117320	TABLE ANGLE POINTER
321	PSB1117321	HEX BOLT M10-1.5 X 35
322	PSB1117322	FLAT HD SCR M10-1.5 X 15
323	PSB1117323	ADJUSTMENT PLATE
324	PSB1117324	HEX BOLT M10-1.5 X 30
325	PSB1117325	ELEVATION SHAFT 35 X 425
326	PSB1117326	SEAL 35 X 50 X 8
327	PSB1117327	BUSHING 35 X 39 X 30
328	PSB1117328	ELEVATION BLOCK
329	PSB1117329	SLEEVE BEARING 28 X 32 X 20
330	PSB1117330	BEARING CAP (FRONT)
331	PSB1117331	BALL BEARING 6002ZZ
332	PSB1117332	WORM GEAR SHAFT
333	PSB1117333	LOCK WASHER 8MM
334	PSB1117334	BEARING CAP (LOWER)
335	PSB1117335	ADJUSTMENT PLATE
336	PSB1117336	FENDER WASHER 8MM

REF	PART #	DESCRIPTION
337	PSB1117337	HEX BOLT M8-1.25 X 30
338	PSB1117338	FLAT WASHER 8MM
339	PSB1117339	HEX BOLT M8-1.25 X 60
340	PSB1117340	ELEVATION LEADSCREW
341	PSB1117341	CABINET COVER
342	PSB1117342	BUTTON HD CAP SCR M6-1 X 8
343	PSB1117343	FENDER WASHER 12MM
344	PSB1117344	FENDER WASHER 6MM
345	PSB1117345	LOCK WASHER 6MM
346	PSB1117346	CAP SCREW M6-1 X 12
347	PSB1117347	CAP SCREW M5-.8 X 15
348	PSB1117348	CAP SCREW M5-.8 X 10
349	PSB1117349	WORM GEAR SHAFT
350	PSB1117350	WORM GEAR T15-1.5
351	PSB1117351	HANDWHEEL TYPE-24 165DX B-S
352	PSB1117352	SET SCREW M8-1.25 X 12
353	PSB1117353	BUTTON HD CAP SCR M5-.8 X 6
354	PSB1117354	DUST COVER PLATE
401	PSB1117401	CORNER TABLE
402	PSB1117402	FIXED HANDLE 21 X 81, M10-1.5 X 35
403	PSB1117403	LOCK WASHER 10MM
404	PSB1117404	FENDER WASHER 10 X 25 X 6
405	PSB1117405	HEX BOLT M10-1.5 X 50
406	PSB1117406	PIVOT BASE
407	PSB1117407	ACORN NUT M10-1.5
408	PSB1117408	CORNER TABLE SHAFT
409	PSB1117409	FLAT WASHER 10MM
410	PSB1117410	HEX BOLT M10-1.5 X 25
411	PSB1117411	DUST HOOD
412	PSB1117412	FLAT WASHER 8MM
413	PSB1117413	LOCK WASHER 8MM
414	PSB1117414	BUTTON HD CAP SCR M8-1.25 X 16
415	PSB1117415	HEX BOLT M10-1.5 X 40
416	PSB1117416	CORNER TABLE SUPPORT
417	PSB1117417	FIXED HANDLE 21 X 81, M10-1.5 X 30

Machine Labels


REF PART #
DESCRIPTION

501	PSB1117501	BELT ROTATION LABEL
502	PSB1117502	DOOR CLOSED LABEL
503V2	PSB1117503V2	MACHINE ID LABEL V2.03.22
504	PSB1117504	MACHINE WARNINGS LABEL
505	PSB1117505	SOUTH BEND NAMEPLATE 203MM

REF PART #
DESCRIPTION

506	PSB1117506	MODEL NUMBER LABEL
507	PSB1117507	ELECTRICITY LABEL
508	PSB1117508	TOUCH-UP PAINT, SB DARK BLUE
509	PSB1117509	TOUCH-UP PAINT, SB LIGHT BLUE

WARNING

The safety labels provided with your machine are used to make the operator aware of the machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of these safety labels. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact South Bend Tools at (360) 734-1540 or www.southbendtools.com to order new labels.

Warranty

This quality product is warranted by South Bend Tools to the original buyer for **2 years** from the date of purchase. This warranty does not apply to consumable parts, or defects due to any kind of misuse, abuse, negligence, accidents, repairs, alterations or lack of maintenance. We do not reimburse for third party repairs. In no event shall we be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our products.

We do not warrant or represent that this machine complies with the provisions of any law, act, code, regulation, or standard of any domestic or foreign government, industry, or authority. In no event shall South Bend's liability under this warranty exceed the original purchase price paid for this machine. Any legal actions brought against South Bend Tools shall be tried in the State of Washington, County of Whatcom.

This is the sole written warranty for this machine. Any and all warranties that may be implied by law, including any merchantability or fitness, for any purpose, are hereby limited to the duration of this warranty.

Thank you for your business and continued support.

To take advantage of this warranty, register at <https://www.grizzly.com/forms/warranty>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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