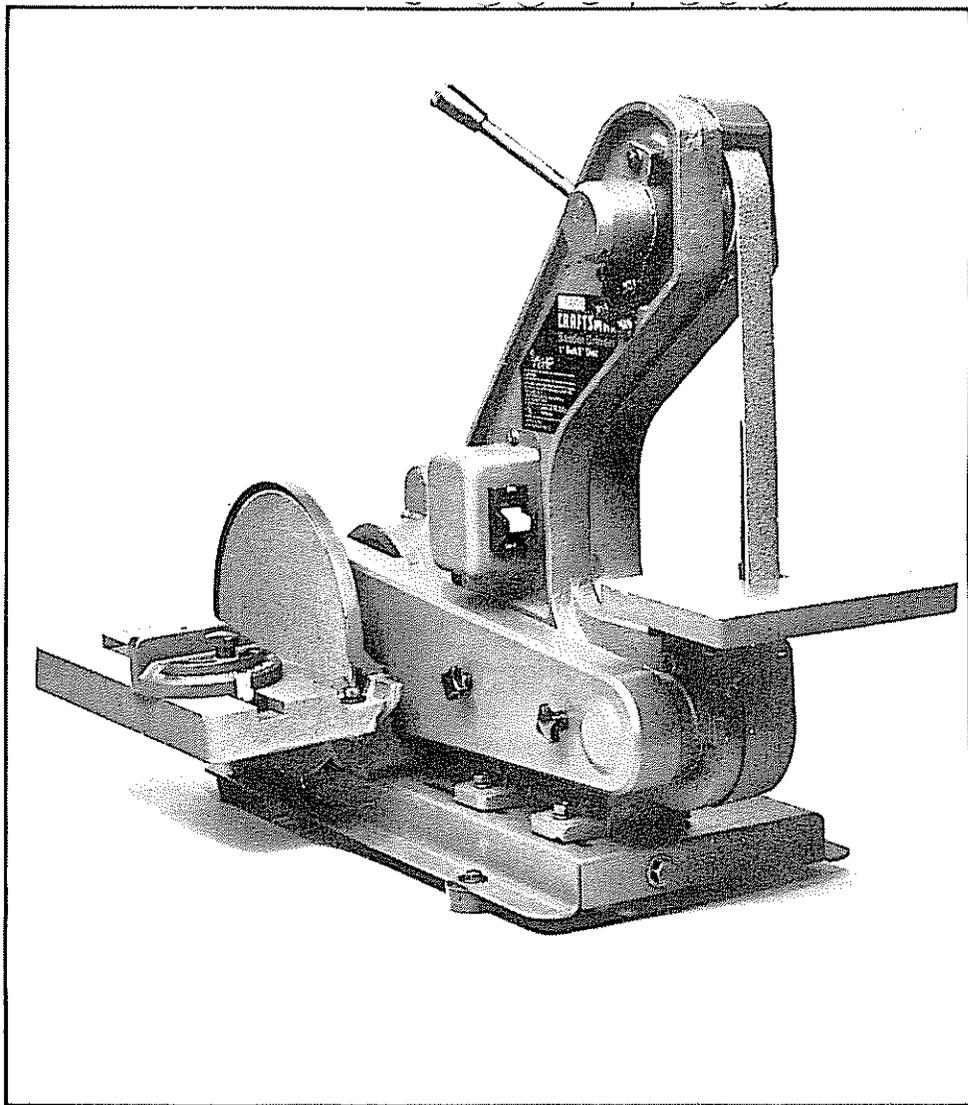


SAVE THIS MANUAL  
FOR FUTURE REFERENCE

**SEARS**

**OWNER'S  
MANUAL**

**MODEL NO.  
351.22632**



**SEARS / CRAFTSMAN**

**1in. BELT & 8in. DISC  
SANDER  
and MITER GAUGE**

**CAUTION:**  
READ ALL  
INSTRUCTIONS  
CAREFULLY!

- *assembly*
- *operating*
- *repair parts*

Sold by SEARS, ROEBUCK AND CO., Chicago, IL 60684 U.S.A.

## FULL ONE YEAR WARRANTY ON SEARS CRAFTSMAN

If within one year from the date of purchase, this Sears Craftsman Belt & Disc Sander fails due to a defect in material or workmanship, Sears will repair it, free of charge.

WARRANTY SERVICE IS AVAILABLE BY SIMPLY CONTACTING THE NEAREST SEARS STORE OR SERVICE CENTER THROUGHOUT THE UNITED STATES.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

SEARS, ROEBUCK AND CO., DEPT.698/731A SEARS TOWER, CHICAGO, IL 60684

## GENERAL SAFETY INSTRUCTIONS FOR POWER TOOLS

**BEFORE ANY WORK IS DONE, READ THE CAUTIONS LISTED BELOW CAREFULLY. WORKING SAFELY PREVENTS ACCIDENTS.**

### 1. OPERATOR SHOULD BE PREPARED FOR THE JOB:

- a. Do not wear loose clothing, jewelry or gloves that will get caught in moving parts of the machine.
- b. Wear safety shoes with non-slip soles.
- c. Wear safety glasses.
- d. Wear face mask or dust mask when needed.
- e. Be alert, and think clearly.
- f. Never operate power tools when tired, intoxicated, or when taking medications that cause drowsiness.

### 2. WORK AREA SHOULD BE READY FOR THE JOB:

- a. An uncluttered work area ensures that the operator has ample room for movement and placement of the work. Clean floors ensure good footing.
- b. Environment should be suitable for tool; Power tools should not be used in damp locations, or gaseous, explosive atmospheres.
- c. Area should be properly lighted.
- d. Proper electrical outlet should be available for the tool.
  1. Three-prong plug should be plugged directly into a properly grounded three-prong receptacle.
  2. If work area is not grounded, a qualified electrician should install the proper electrical system.
- e. Extension cords should have a grounding prong, and the three wires of the extension cord should be the correct gauge.
- f. Keep visitors a safe distance away from work area.

### 3. TOOL SHOULD BE MAINTAINED:

- a. Always unplug power tool prior to inspection or maintenance.

- b. Consult the owner's manual for specific maintaining and adjusting procedures.
- c. Keep machine lubricated.
- d. Use sharp blades, and keep the tool clean for best, and safest operation.
- e. Never leave adjusting keys and wrenches on machine; remove them.
- f. Workbed of power tool should only be used to support the workpiece and necessary accessories.
- g. Use recommended accessories only, and follow manufacturer's instructions.
- h. Keep all guards in place.
- i. Keep all parts in working order; do not perform makeshift repairs. (Use the Parts List provided with the owner's manual to order replacement parts.)
- j. Make sure the machine is mounted correctly; never attempt to stabilize a floor or benchtop tool by standing on it, or by holding it in position.

### 4. OPERATOR SHOULD KNOW HOW TO USE THE TOOL:

- a. Use the right tool for the job.
- b. Avoid accidental start-up; make sure that the machine is in the OFF position before plugging it in.
- c. Do not force a tool; it will work most efficiently at the rate for which it was designed.
- d. Turn the machine OFF if it jams: A blade jams when it digs too deeply into the work. (The motor force keeps it stuck in the work.)
- e. Handle the work piece correctly.
  1. Secure the work with clamps, or a vise whenever possible; leave hands free to operate the machine
  2. Use push sticks or push blocks when required; protect hands from possible injury.
- f. Do not overreach: Keep the proper footing and balance.
- g. Keep hands away from moving parts and cutting surfaces.
- h. Know your power tool: learn its operation, applications and specific limitations.

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## SAFETY INSTRUCTIONS FOR 1in. BELT & 8in. DISC SANDER

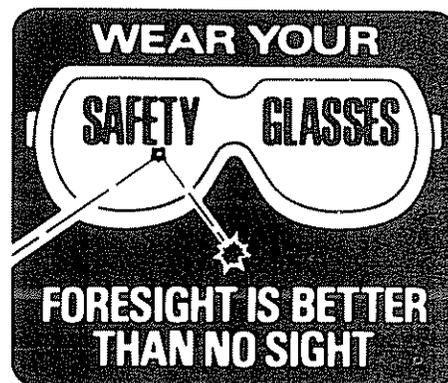
**WARNING: DO NOT ATTEMPT TO OPERATE BELT & DISC SANDER UNTIL IT IS COMPLETELY ASSEMBLED ACCORDING TO THE INSTRUCTIONS.**

1. **KNOW GENERAL POWER TOOL SAFETY.** Make sure all precautions are understood and provided for (page 2)
2. **SECURE ALL FASTENERS.** Frequently check that nuts and bolts are tight and have not vibrated loose
3. **FOLLOW OPERATION INSTRUCTIONS.** Operate the belt and disc sander as described in this manual. (page 8)
4. **BE SURE MOTOR RUNS CLOCKWISE.** Abrasive belt must travel down.
5. **DISC SAND ON DOWN SIDE (RIGHT SIDE).** The disc should pull work towards the table.
6. **SUPPORT WORKPIECE.** Maintain control of workpiece at all times.
7. **DO NOT FORCE WORK.** Slowing or stalling the motor will overheat it.
8. **DO NOT OVERHEAT WORK.** Move metal across the abrasive and cool it when it becomes hot.
9. **DO NOT WET GRIND OR POLISH.** Never use a steady stream of water on the workpiece. Only quench the workpiece in water to cool it.
10. **DO NOT GRIND OR POLISH MAGNESIUM.** It could catch on fire.

11. **KEEP SANDER MAINTAINED.** Follow maintenance instructions (page 10).
12. **DISCONNECT POWER.** Turn switch "off" and disconnect the power whenever sander is not being used.

**CAUTION: DO NOT ALLOW FAMILIARITY (GAINED) FROM FREQUENT USE OF YOUR BELT AND DISC SANDER TO BECOME COMMONPLACE. ALWAYS REMEMBER THAT A CARELESS FRACTION OF A SECOND IS SUFFICIENT TO INFLICT SEVERE INJURY.**

The operation of any power tool can result in foreign objects being thrown into the eyes, which can result in severe eye damage. Always wear safety goggles complying with ANSI Z87.1 (shown on package) before commencing power tool operation. Safety Goggles are available at Sears retail or catalog stores.



**THINK SAFETY:** Safety is a combination of operator common sense and alertness at all times when the Belt & Disc Sander is being used.

# MOTOR SPECIFICATIONS AND ELECTRICAL REQUIREMENTS

## MOTOR

The Belt and Disc Sander is assembled with motor and wiring installed.

The 120 Volt AC capacitor start motor has the following specifications:

Horsepower .....	1/3
Voltage .....	120
Amperes .....	7
Hertz .....	60
Phase .....	Single
RPM .....	1725
Rotation (viewed from pulley end) .....	clockwise
Frame size .....	NEMA 56Z

Use Sears Craftsman 912037C motor if a replacement motor is needed.

## POWER SOURCE

**CAUTION: DO NOT CONNECT THE BELT AND DISC SANDER TO ITS POWER SOURCE UNTIL ALL ASSEMBLY STEPS HAVE BEEN COMPLETED.**

The motor is designed for operation on the voltage and frequency specified on motor nameplate.

Normal loads will be handled safely on voltages not more than 10% above or below the nameplate voltage.

Running the unit on voltages which are not within the range may cause over-heating and motor burn-out.

Heavy loads require that voltage at motor terminals be not less than the voltage specified on nameplate.

This machine must be grounded while in use to protect the operator from electric shock.

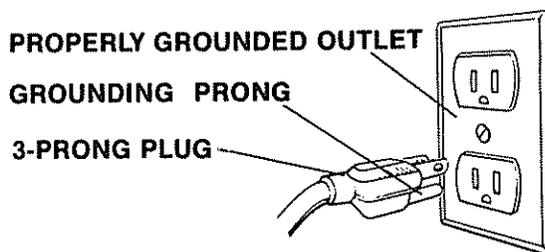
This power tool is equipped with a 3-conductor cord and grounding type plug which has a grounding prong, approved by Underwriters Laboratories and the Canadian Standards Association.

**Do not remove or alter the grounding prong in any manner.**

This plug requires a mating 3-conductor grounded type outlet as shown.

Use a 110-120V properly grounded type outlet protected by a 15-amp. time delay fuse or circuit breaker.

**WARNING: BE SURE THAT THE OUTLET IS PROPERLY GROUNDED, HAVE IT CHECKED BY A QUALIFIED ELECTRICIAN.**

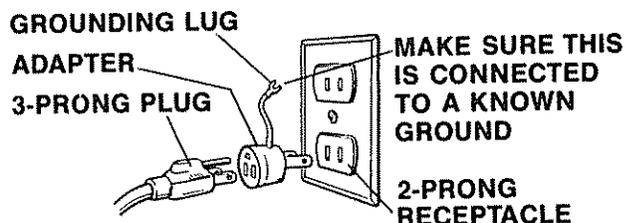


This unit is for use on less than 150V, it has a plug as illustrated above.

If the outlet you are planning to use for this power tool is of the two prong type, use an adapter as shown below.

The green grounding lug extending from the adapter must be connected to a permanent ground, such as to a properly grounded outlet box.

Having a qualified electrician replace the two prong outlet with a properly grounded three prong outlet is recommended.



**NOTE:** The adapter illustrated is for use only if you already have a properly grounded 2-prong receptacle. Adapter is not allowed in Canada by the Canadian Electrical Code.

## EXTENSION CORDS

The use of any extension cord will cause some drop in the voltage and loss of power.

The wires of the extension cord must be sufficient in size to carry the current and maintain adequate voltage.

Use the table below to determine the minimum wire size (A.W.G.) extension cord.

Use only 3 wire extension cords which have 3 prong grounding type plugs and 3-pole receptacles which accept the tool plug.

If power cord is worn, cut, or damaged in any way, have it replaced immediately.

Extension cord Length	Wire Size A.W.G.
Up to 50 ft. ....	16
50 - 100 ft. ....	14

**NOTE:** Using extension cords over 100 ft. long is not recommended.

**WARNING: DO NOT PERMIT FINGERS TO TOUCH THE TERMINALS OF PLUGS WHEN INSTALLING OR REMOVING THE PLUG TO OR FROM THE OUTLET**

# ELECTRICAL CONNECTIONS

**WARNING: MAKE SURE THE UNIT IS "OFF" AND DISCONNECTED FROM THE POWER SOURCE BEFORE INSPECTING ANY WIRING.**

The motor and wiring are installed as shown in the wiring diagram. (See Figure 1)

A label on the motor describes the possible wiring configurations.

The motor is assembled with an approved three conductor cord to be used on 115 volts as indicated.

If T5 and T6 are interchanged, the direction of rotation will be reversed.

The power supply to the motor is controlled by a double pole safety rocker.

Remove the key to prevent unauthorized use.

The power lines are inserted directly into the switch.

Both green ground lines must remain securely fastened to the frame to properly protect against electric shock.

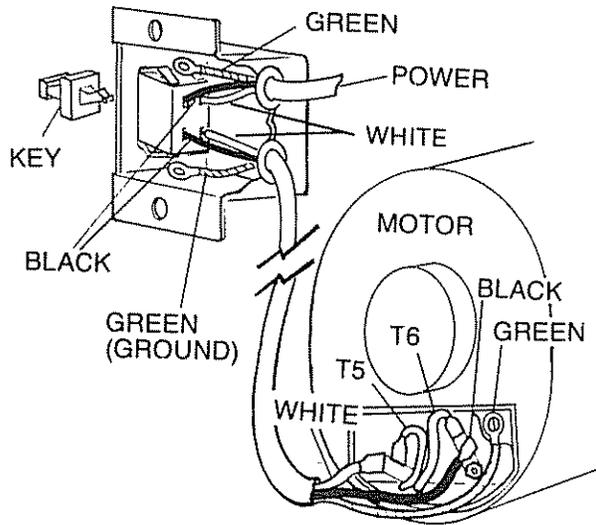


Figure 1

# UNPACKING AND CHECKING CONTENTS

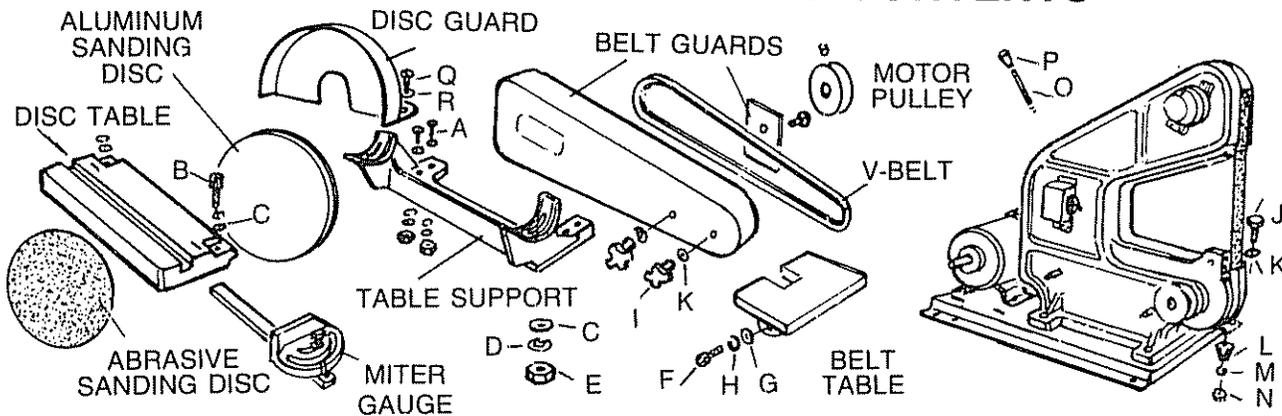


Figure 2

Check for shipping damages. If damage has occurred, a claim should be filed with the carrier for fastest action.

The belt and disc sander is assembled to the base at the factory.

Additional parts which need to be fastened to the unit should be located and accounted for (see Figure 2)

Locate the parts bag and make sure the proper hardware is included.

- A. Hex bolt, 5/16"-18 X 1 1/4"; 4 each for attaching the table mounting bracket to the base.
- B. Socket head bolt, 5/16"-18 X 1 1/4"; 2 each for mounting disc table to bracket.
- C. Flat washer, 5/16"; 12 each.
- D. Lockwasher, 5/16"; 6 each.
- E. Nut, 5/16"-18, 6 each.
- F. Socket head bolt 3/8"-16 X 3/4"; 1 each for fastening belt table to the frame.
- G. Flat washer, 3/8"; 1 each.
- H. Lockwasher, 3/8" 1 each.
- I. Thumb knob; 2 each for fastening belt cover to frame.

- J. Hex bolt, 1/4"-20 X 3/4; 4 each for attaching feet to base.
- K. Flat washer, 1/4"; 6 each.
- L. Rubber Foot, 4 each.
- M. Lockwasher, 1/4"; 4 each.
- N. Nut, 1/4"; 4 each.
- O. Tension Handle; 1 each.
- P. Knob; 1 each.
- Q. Screw, 3/16"-24-3/8"; 2 each.
- R. Flat washer, 3/16"; 2 each.

Adjusting tools are also located in the parts bag. See tools needed (Page 6).

Unpainted steel surfaces have been coated with a shipping preservative.

Remove the preservative with kerosene or penetrating oil.

Use soap and water on rubber and plastic parts. Cleaning fluids tend to deteriorate them.

Non-flammable solvents are recommended.

**CAUTION: DO NOT ATTEMPT ASSEMBLY IF PARTS ARE MISSING. USE OWNERS MANUAL TO ORDER REPLACEMENT PARTS**

## TOOLS NEEDED

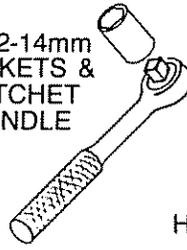


10-12-14mm  
WRENCHES

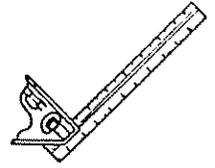
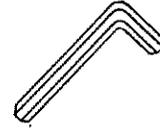


#2 PHILLIPS  
SCREWDRIVER

10-12-14mm  
SOCKETS &  
RATCHET  
HANDLE



3-5-6-8mm  
HEX WRENCHES  
(SUPPLIED)



COMBINATION  
SQUARE

## ASSEMBLY

(Refer to figure 6)

The frame (Key No. 77) and the motor are fastened to the base (Key No. 1)

The loose items which need to be attached have been described in unpacking and checking contents.

Fasten the additional parts in the manner described below, the order is important.

### MOUNT THE BELT AND DISC SANDER

1. The base has a mounting flange on each side.
2. Each flange has three mounting holes.
3. The holes toward the front and the holes which are 10½" from them can be used to mount the belt and disc sander to a leg set.
4. The Sears leg set can be set up to accommodate a set of holes with 9" X 10½" spacing.
5. Mount the base to the leg set prior to assembly (mounting bolts not included).

### MOUNT THE FEET

1. Four rubber feet (Key No. 2) and mounting hardware are supplied.
2. Use the feet if the sander is not fastened directly to a leg set.
3. Use the mounting holes which are farthest apart.
4. Push the bolts through the washer (Key Nos. 5&30), then through the base and the rubber foot.
5. Fasten the feet with the lock washers and nuts (Key Nos. 3 & 4).
6. The additional hole in each flange can be used to fasten the sander to a bench top after it is assembled.

### INSTALL THE MOTOR PULLEY (Key No. 26)

1. The set screw (Key No. 27) is installed in the pulley.
2. Slide the motor pulley on to the motor shaft with set screw over the flat of the shaft.
3. Align the pulleys, use a straight edge if necessary.
4. Secure the pulley position with the set screw.

### INSTALL THE "V" BELT (Key No. 50)

1. The "V" Belt is located inside the belt guard (Key No. 46)
2. Remove the screw (Key No. 48) and rear belt guard (Key No. 45) to remove the belt.
3. Place the "V" belt around the pulleys
4. Belt guard will be installed after the disc table bracket is installed.

### TENSION THE "V" BELT

1. The "V" belt is tensioned by moving the frame (Key No 77) forward
2. Loosen the mounting nuts (Key No. 7) so the frame can be moved. Remove wheel cover (Key No. 76) if necessary.
3. Move the frame by rotating the tension bolt (Key No. 10) clock wise; to tighten the belt.
4. The belt is properly tightened when light pressure applied between the pulleys produces about 3/8" deflection.
5. Do not over tighten; a belt which is too tight will wear fast and over work the motor.
6. Make sure the pulleys are aligned; poorly aligned pulleys make the unit vibrate and reduce the belt life.
7. Once the belt is tensioned and aligned secure the position by tightening the mounting nuts

### POSITION DISC TABLE BRACKET

1. The disc table bracket is attached with a combination of bolt, two flat washers, lockwasher and nut (4 each, Key Nos. 18, 9, 6, & 7).
2. Attach the bracket using the two holes closest to the left edge of the base, the two mounting bolts closest to the motor will be installed after the disc table is adjusted.
3. Insert the bolts through one flat washer, the bracket and the base
4. Attach the washer, lockwasher, and nut from beneath.
5. Only thread the nut on with a few turns the bracket must be loose in order to position the belt guard

## **FASTEN THE BELT GUARD**

1. The rear belt guard (Key No. 45) and screw (Key No. 48) should be unattached.
2. Hold the belt guard with the drive pulley end up and position it with the motor shaft through the opening in the guard.
3. Rotate the guard into place, bring it down over the belt guard supports (Key No. 47).
4. Move disc table bracket so the guard can be positioned on the supports, but leave the mounting bolts (Key No. 18) positioned.
5. Attach the belt guard with the washers and thumb knobs (Key Nos. 30 & 49).
6. Replace the rear belt guard and screw.

## **INSTALL THE DISC**

1. The set screw (Key No. 22) is installed in the disc.
2. Slide the disc on to the motor shaft with set screw over the flat.
3. Position disc back onto motor shaft but, make sure that the motor shaft will not interfere with the abrasive disc.
4. Tighten set screw to lock position.

## **FASTEN ABRASIVE DISC**

1. The abrasive disc (Key No. 19) has an adhesive backing.
2. The adhesive is not reusable. Be certain to place it centered on the disc.
3. Peel off the adhesive's covering and press the adhesive disc firmly against the aluminium disc.

## **ALIGN THE DISC TABLE**

1. Finger-tighten the disc table bracket mounting bolts. Allow for adjustment.
2. The table is attached to the bracket with a socket head bolt, two flat washers, a lockwasher and a nut (two each, Key Nos. 17, 9, 6 & 7).
3. Hold the table in position and insert bolts through washers, the table and the bracket.
4. Fasten the table by threading the washers and nuts onto the bolts; finger tighten.
5. When the table mounting bolts are finger tightened, the table can be positioned at any angle from 45° to 90° to the disc.

6. Use a square to set the table at 90° to the disc and tighten the bolts.
7. Reposition the mounting bracket so that the table and disc are parallel and the gap between them is 1/16"
8. Reposition the disc on the motor shaft if the table cannot be moved in far enough to close the gap.
9. Make sure the disc is centered relative to the table.

## **SECURE THE DISC TABLE.**

1. Once the table is positioned, secure the bracket.
2. Use an open-ended wrench to hold the head of the hex bolt (Key No. 18).
3. Use a socket and ratchet handle from under the sander to secure the bracket to the base.
4. Install the two remaining bolts through the holes closest to the motor in the same manner.

## **FASTEN THE DISC GUARD**

1. The disc guard (Key No. 23) attaches to the disc table bracket with two screws and lockwashers (Key Nos. 24 & 25).
2. Position the disc guard so it is centered and the lip covers the outer edge of the disc.

## **INSTALL THE BELT TABLE**

1. The belt table bracket (Key No. 54) is attached to the belt table.
2. The table and bracket are fastened to the frame with the socket head bolt, lockwasher and flat washer (Key Nos. 52, 53, & 11).
3. The belt table is angled and positioned 1/16' away from the belt at the same time.
4. If the table slot is not centered over the belt and platen, the belt table bracket needs to be repositioned.

## **INSTALL THE TENSION HANDLE**

1. Thread the knob (Key No. 63) onto the end of the handle farthest from the flats.
2. Screw handle into the spring cap (Key No. 66).
3. Use flats of handle to secure the handle to the spring cap.

# OPERATING INSTRUCTIONS

## SAFETY PRECAUTIONS

### **WARNING: ALWAYS OBSERVE THE FOLLOWING SAFETY PRECAUTIONS.**

Whenever adjusting or replacing any parts on the sander turn switch "OFF" and remove plug from power source.

Recheck table locking nuts and bolts. They must be tightened securely.

Make sure all guards are properly attached. All guards should be fastened securely.

Make sure all moving parts are free and clear of any interference; With power disconnected, test operation by hand for clearance and adjust if necessary.

Make sure abrasive belt always tracks properly; Correct tracking gives optimum performance.

After turning switch "On" always allow the belt to come up to full speed before sanding or grinding.

Keep your hands clear of abrasive belt, disc and all moving parts.

For optimum performance do not stall motor or reduce belt speed; Do not force the work into the abrasive.

Never push a sharp corner of the workpiece rapidly against the belt or disc; The abrasive may tear.

Replace abrasives when they become loaded (glazed) or frayed.

When grinding metal: Move the workpiece *across* the abrasive, to prevent built up heat.

Never attempt wet cutting. If the workpiece becomes too hot to handle, cool it in cold water.

Always wear eye protection or face shield.



## TENSIONING ABRASIVE BELT

Tension is created by a spring loaded cam shaft.

The tracking wheel is mounted on the opposite side of the shaft.

The spring return is transmitted to the tracking wheel and maintains the tension.

## REPLACING ABRASIVE BELT

Remove the wheel guard (Ref. No. 76) by removing thumb knobs (Key No. 49).

Remove belt table (Key No 59) by removing socket head bolt (Key No 52).

Release the tension on the belt by pulling the tension handle (Key No. 65) forward (towards operator).

Remove belt from the top wheel (tracking wheel, Key No. 72) release the tension handle and remove belt.

Install abrasive belt in the reverse manner.

Place the abrasive belt squarely on the wheels. The spring action will tension the belt.

Make sure the belt is tracking correctly. Adjust the tracking if necessary.

The abrasive belt has an arrow printed on the inside which indicates the direction of travel.

The arrow should point down toward the belt table to ensure that the splice in the belt will not come apart.

When the belt is tracking properly it rides squarely on the center of each wheel.

Replace the wheel guard and belt table.

## TRACKING ABRASIVE BELT

Remove the wheel guard.

Test the tracking. Plug in power cord. Turn the switch "ON" and immediately "OFF."

If the abrasive belt did not move to the right or left, it is tracking properly.

If the belt moved to the right or left, adjust the tracking.

To adjust the tracking wheel loosen the lock-nut (Key No. 4).

Use a 3mm setscrew wrench (Key No. 21) to turn the tracking adjusting screw (Key No. 63).

If the abrasive belt moves to the right, tilt the top of the tracking wheel towards the frame by turning the adjusting screw clockwise.

If the abrasive belt moves to the left, tilt the top of the tracking wheel away from the frame by turning the adjusting screw counter-clockwise.

Lock the position when the belt is tracking properly; so the belt will remain centered on the wheels.

Hold the position of the tracking adjustment screw with the 3mm setscrew wrench.

Tighten locknut (Key No. 64) to lock the position.

Replace wheel guard and secure with thumb knobs.

## ADJUSTING BELT TABLE ANGLE

To adjust the angle of the belt table, loosen the socket head bolt (Key No. 52) and adjust to the desired angle.

Use a combination square to set the belt table at 45° or 90° to the abrasive belt.

Adjust for 1/16" clearance between the belt and the table.

When the belt table is at the desired angle, lock it into position by securely tightening the socket head bolt.

## ABRASIVE BELT FINISHING

The abrasive belt can be used to sand wood, deburr metal, or polish plastic and glass.

The belt is most efficient when used with the table.

The 1" belt size is convenient for getting into corners and concave curved edges.

## ADJUSTING BELT PLATEN

Operating with the belt platen in place will allow the operator to sand or grind straight even lines.

Belt edges should be even with platen edges. (Key No. 58). To adjust belt platen, loosen two each 1/4-20 X 5/8" hex head bolts (Key No. 57) and adjust.

Tighten bolts securely.

## POLISHING AND CONTOUR SANDING:

Remove platen completely, remove hex head bolts and washers (Key Nos. 57, 3 & 30).

The belt has no rigid back and is able to follow the contour of curved parts.

Move the workpiece against the belt. The belt will follow the contour. (See Figure 4)

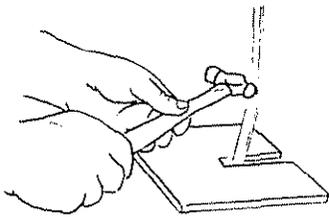


Figure 4

## SHARPENING:

Adjust belt table to the desired sharpening angle and tighten securely.

Use the belt sander to notch the back of an auxiliary piece of wood.

Using a "C" clamp, attach the auxiliary piece of wood to the table, it acts as a support while sharpening. (See Figure 5)

Top edge of the wood should be approximately 1/16" from abrasive belt.

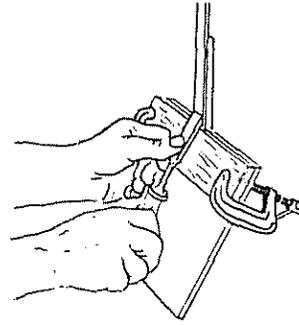


Figure 5

## REPLACING THE ABRASIVE DISC.

Remove disc table (Key No. 15).

Remove old abrasive disc by peeling it from the aluminum disc. Removing aluminum disc from motor shaft is not necessary.

Clean aluminum disc if necessary.

Select the proper abrasive disc and apply to aluminum disc.

The abrasive used can be changed to a different grit without replacing the abrasive disc.

Additional aluminum discs are available (see recommended accessories) use separate aluminum disc for each grit size used.

Interchange the aluminum disc to change grit size (see assembly page 7).

Replace disc table.

## ADJUSTING DISC TABLE ANGLE

The disc table is adjustable from 45° to 90° for beveled work.

To adjust the disc table, loosen the two socket head bolts and nuts (Key Nos. 17 & 7) and adjust to the desired angle.

Use a combination square to set the disc table at 45° or 90° to the abrasive disc.

When disc table is at desired angle, lock it into position by securely tightening the socket head bolts.

## ABRASIVE DISC FINISHING

Abrasive disc sanding is well suited for finishing small end surfaces and convex curved edges.

Move the workpiece across the "down side" (Right) of the face of the abrasive disc.

The abrasive disc produces almost no abrasive action at the center.

The abrasive disc moves fastest and removes more material at the outer edge.

If workpiece is fed without additional guidance, more material will be removed towards the outer edge of the disc.

For accuracy use the miter gauge.

## USING THE MITER GAUGE

The miter gauge is used only on the disc table. Use the miter gauge for securing work and holding the proper angle, while disc sanding.

Adjust the angle by repositioning the miter gauge scale (Key No. 29) and locking it into place with thumbscrew and flatwasher (Key Nos. 31 & 30).

Check the accuracy of the miter gauge scale.

Use a combination square to adjust the miter gauge square to the face of the disc.

Indicator (Key No 32) should be at zero. Loosen screw (Key No.24) and reposition indicator if necessary.

### DUST COLLECTION:

The wheel cover has a 1 1/4" diameter exhaust port in it.

The exhaust port will accept a standard 1 1/4" Dust collection hose.

Use the exhaust port to connect the belt and disc sander to a shop vac or dust collector.

## RECOMMENDED ACCESSORIES

### ABRASIVE BELTS 1" x 42"

FINE .....	9 26056
MEDIUM .....	9 26055
COARSE .....	9 26054

### ABRASIVE DISCS 8" .....

ALUMINUM DISC 8" .....

STEEL STAND .....

### POWER TOOL KNOW HOW "HANDBOOKS"

TABLE SAW .....	9 2918
RADIAL SAW .....	9 2917

The above recommended accessories are current and were available at the time this manual was printed.

## MAINTENANCE

**WARNING: MAKE CERTAIN THAT THE UNIT IS DISCONNECTED FROM THE POWER SOURCE BEFORE ATTEMPTING TO SERVICE OR REMOVE ANY COMPONENT.**

### CLEANING

Keep machine and workshop clean. Do not allow sawdust to accumulate on the belt and disc sander.

Keep the wheels clean. Dirt on wheels will cause poor tracking and belt slippage.

Operate sander/grinder with dust collector to keep dust from accumulating.

**IMPORTANT: AFTER SANDING WOOD OR NON-METALLIC MATERIAL, ALWAYS CLEAN DUST COLLECTOR AND WHEEL GUARD OF SAWDUST BEFORE GRINDING METAL. THE SPARKS COULD IGNITE THE DEBRIS AND CAUSE A FIRE.**

Be certain motor is kept clean and is frequently vacuumed or blown free of any dirt.

Unpainted surfaces should be cleaned with penetrating oil.

Use soap and water to clean painted parts, rubber parts and plastic guards.

### LUBRICATION

The shielded ball bearings in this sander are permanently lubricated at the factory. they require no further lubrication.

A small amount of machine oil can be applied to the cam shaft (Key No. 62) within the tracking bracket.

When operation seems stiff, a coat of automobile-type wax applied to the belt table and disc table will make it easier to feed the work while finishing.

Do not apply wax to the belt platen, the belt could pick up the wax and deposit it on the wheels, causing the belt to slip.

### KEEP SANDER IN REPAIR :

If power cord is worn, cut, or damaged in any way, have it replaced immediately.

Replace V-belt and worn abrasives when needed.

Replace any damaged or missing parts, use the parts list to order parts.

## TROUBLE SHOOTING

**WARNING: FOR SAFETY, TURN SWITCH "OFF" AND ALWAYS REMOVE PLUG FROM POWER SOURCE OUTLET BEFORE TROUBLE SHOOTING.**

Any attempt to repair the motor may create a hazard unless repair is done by qualified service technician. Repair service is available at your nearest Sears Store.

Trouble	Probable Cause	Remedy
Motor will not start.	<ol style="list-style-type: none"> <li>1. Low voltage.</li> <li>2. Open circuit in motor or loose connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power line for proper voltage.</li> <li>2. Inspect all lead terminations on motor for loose or open connection.</li> </ol>
Motor will not start, fuses or circuit breakers "blow".	<ol style="list-style-type: none"> <li>1. Short circuit in line, cord or plug.</li> <li>2. Short circuit in motor or loose connections.</li> <li>3. Incorrect fuses or circuit breakers in powerline.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect line cord or plug for damaged insulation and shorted wires.</li> <li>2. Inspect all lead terminations on motor for loose or shorted terminals or worn insulation on wires.</li> <li>3. Install correct fuses or circuit breakers.</li> </ol>
Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals)	<ol style="list-style-type: none"> <li>1. Power line overloaded with lights, appliances and other motors.</li> <li>2. Undersize wires or circuits too long</li> <li>3. General overloading of power company's facilities.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce the load on the power line.</li> <li>2. Increase wire sizes, or reduce length of wiring.</li> <li>3. Request a voltage check from the power company.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Air circulation through the motor restricted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor.</li> <li>2. Clean out motor to provide normal air circulation through motor.</li> </ol>
Motors stalls (resulting in blown fuses or tripped circuit breakers)	<ol style="list-style-type: none"> <li>1. Short circuit in motor or loose connections.</li> <li>2. Low voltage.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> <li>4. Motor overloaded.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect terminals in motor for loose or shorted terminals or worn insulation on lead wires.</li> <li>2. Correct the low line voltage conditions.</li> <li>3. Install correct fuses or circuit breakers.</li> <li>4. Reduce load on motor.</li> </ol>
Frequent opening of fuses or circuit breakers.	<ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Incorrect fuses or circuit breakers.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce motor load.</li> <li>2. Install correct fuses or circuit breakers.</li> </ol>
Machine slows down while operating	<ol style="list-style-type: none"> <li>1. "V"-Belt to loose</li> <li>2. Applying too much pressure to workpiece</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust belt tension by pushing motor toward back until all slack is removed from belt.</li> <li>2. Ease up on pressure.</li> </ol>
Abrasive belt runs off top wheel	<ol style="list-style-type: none"> <li>1. Not tracking properly.</li> </ol>	<ol style="list-style-type: none"> <li>1. See operations section "Tracking Belt"</li> </ol>

## REPLACEMENT PARTS LIST

KEY NO.	PART NO.	DESCRIPTION	QTY.
1	1381.00	Base	1
2	1336.00	Rubber Foot	4
3	STD551125	* Lockwasher, 1/4"	13
4	STD541025	* Nut, 1/4"-20	5
5	STD522507	* Hex bolt, 1/4"-20 x 3/4"	4
6	STD551131	* Lockwasher, 5/16 x 9/16"	16
7	STD541031	* Hex nut, 5/16"-18	14
8	1405.00	Tension plate	1
9	STD551031	* Flatwasher, 5/16 x 3/4"	22
10	STD523730	Tension bolt, 3/8-16 x 3"	1
11	STD551037	* Flatwasher, 3/8" x 1"	3
12	STD541431	* Locking nut, 3/8"-16	1
13	STD533107	Carriage bolt, 5/16-18 x 3/4"	4
14	912037C	Motor	1
15	1406.00	Disc table	1
16	1407.00	Disc table bracket	1
17	1382.00	Socket head bolt, 5/16"-18 x 1 1/4"	2
18	STD523112	Hex head bolt, 5/16"-18 x 1 1/4"	4
19	922745	■ Abrasive disc (adhesive backing) medium	1
20	925135	■ Aluminum disc (8")	1
21	1658.00	* Hex wrench, 3mm	1
22	STD502502	* Setscrew, 1/4"-20 x 1/4"	2
23	1383.00	Disc guard	1
24	STD511002	* Phillips head screw, 3/16"-24 x 1/4"	5
25	STD551110	Lockwasher, 3/16" x 5/16"	5
26	1411.00	Motor pulley	1
27	STD502503	* Setscrew, 1/4"-20 x 3/8"	3
28	0905.00	Miter gauge slide bar	1
29	0904.00	Miter gauge scale	1
30	STD551025	* Flatwasher, 1/4 x 3/4"	13
31	0902.00	Thumbscrew knob	1
32	0901.00	Indicator	1
33	1446.00	Miter gauge assembly (Includes Key Nos. 28-32)	1
34	1412.00	Line cord, (power to switch) SJT, 3C/14AWG	1
35	1413.00	Strain relief	4
36	1414.00	Line cord, (switch to motor) SJT, 3C/14AWG	1
37	1415.00	Rubber grommet	2
38	1416.00	Switch box	1
39	1384.00	Safety switch (2-pole locking rocker)	1
40	1385.00	Locking rocker key	1
41	1474.00	Ground star washer	2
42	1475.00	Ground cup washer	2
43	1476.00	Ground flatwasher	2
44	1477.00	Phillips head, ground screw, 3/16"-24 x 3/8"	2
45	1386.00	Rear belt guard	1

■ See recommended accessories (page 10)

\* Standard hardware item available locally

## REPLACEMENT PARTS LIST (Continued)

KEY NO.	PART NO.	DESCRIPTION	QTY.
46	1387.00	Belt guard	1
47	1419.00	Belt guard support	2
48	1388.00	* Thread forming scrow	1
49	1437.00	Thumb knob	4
50	STD304380	* V-belt (A38)	1
51	1420.00	Drive pulley	1
52	1389.00	* Socket head bolt, 3/8"-16 x 3/4"	1
53	STD551137	* Lockwasher, 3/8" x 11/16"	1
54	1421.00	Belt table bracket	1
55	1390.00	* Socket head bolt, 5/16-18 x 3/4"	2
56	1846.00	* Hex wrench, 8mm	1
57	1391.00	* Socket head bolt 1/4"-20 x 5/8"	5
58	1423.00	Belt platen 1"	1
59	1392.00	Belt table	1
60	1393.00	* Socket head bolt, 1/4"-20 x 1/2"	4
61	1424.00	Spring plate	2
62	1431.00	Tracking wheel cam shaft	1
63	1394.00	Knob	1
64	1395.00	* Setscrew, 1/4"-20 x 3/4"	1
65	1425.00	Tension handle	1
66	1426.00	Spring cap	1
67	1427.00	Tension spring	1
68	1428.00	Retaining ring	2
69	1429.00	Tracking bracket	1
70	1447.00	Tracking/Tension Assembly (includes Key Nos. 62-70)	1
71	1448.00	Wheel Assembly (includes Key Nos. 73&74)	1
72	1396.00	Idler Wheel	2
73	1397.00	* Retaining ring	2
74	STD315205	* Bearing, (6200)	2
75	1434.00	* Retaining ring (E type)	2
76	1398.00	Wheel guard	1
77	1435.00	Frame	1
78	1436.00	Wheel guard support	2
79	1438.00	Idler wheel shaft	1
80	1439.00	Drive wheel	1
81	1440.00	Bearing housing	1
82	1441.00	* Retaining ring (internal 23mm)	2
83	STD315225	* Bearing (6202)	2
84	1442.00	Drive shaft	1
85	1449.00	Bearing housing assembly (includes Key Nos. 81-83)	1
86	<sup>9</sup> 26055	Abrasive belt (cloth), medium	1
87	1126.00	Hex wrench, 4mm	1
88	1127.00	Hex wrench, 5mm	1
	1380.00	Owners Manual	1

Always order by Part No.; NOT by Key No.

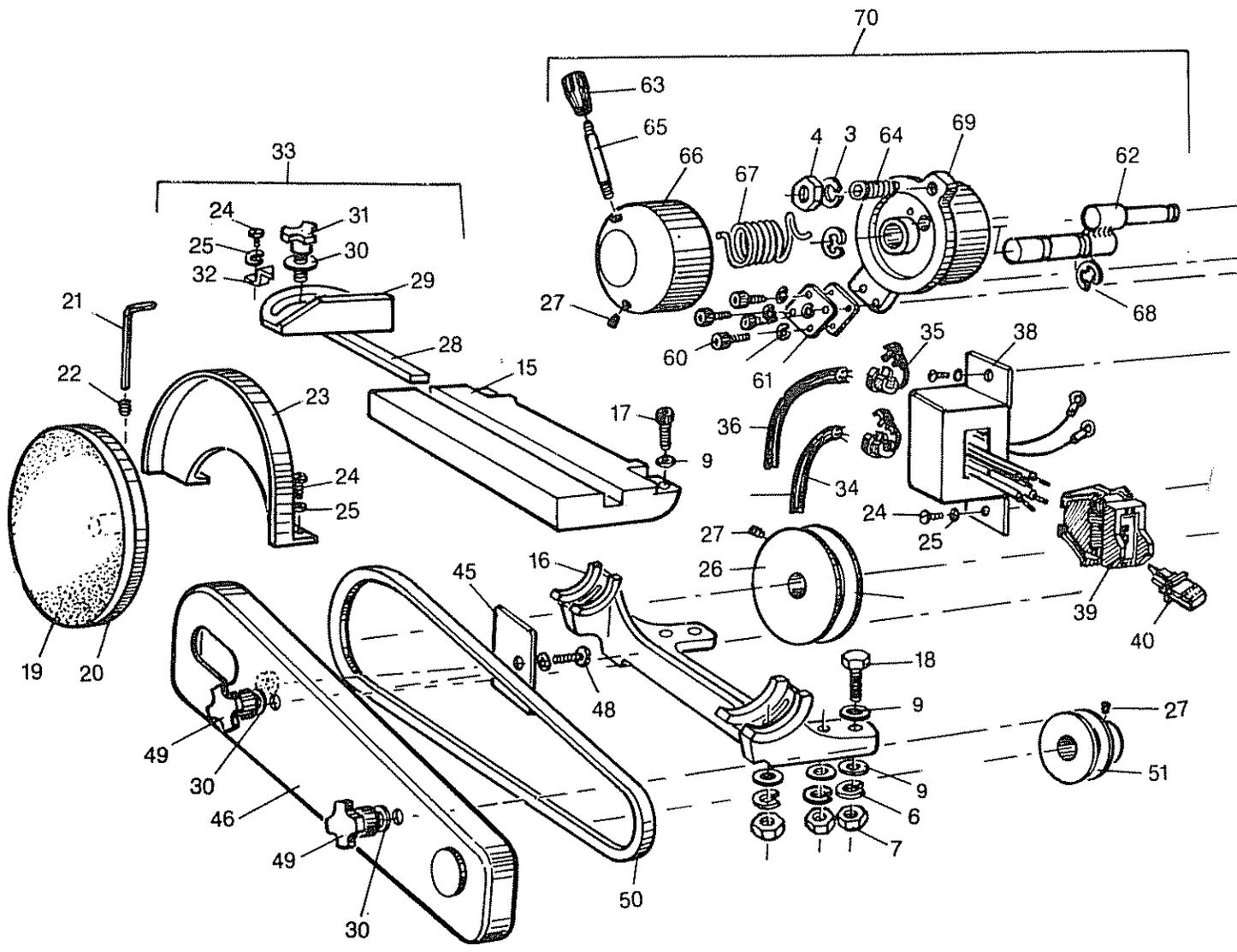
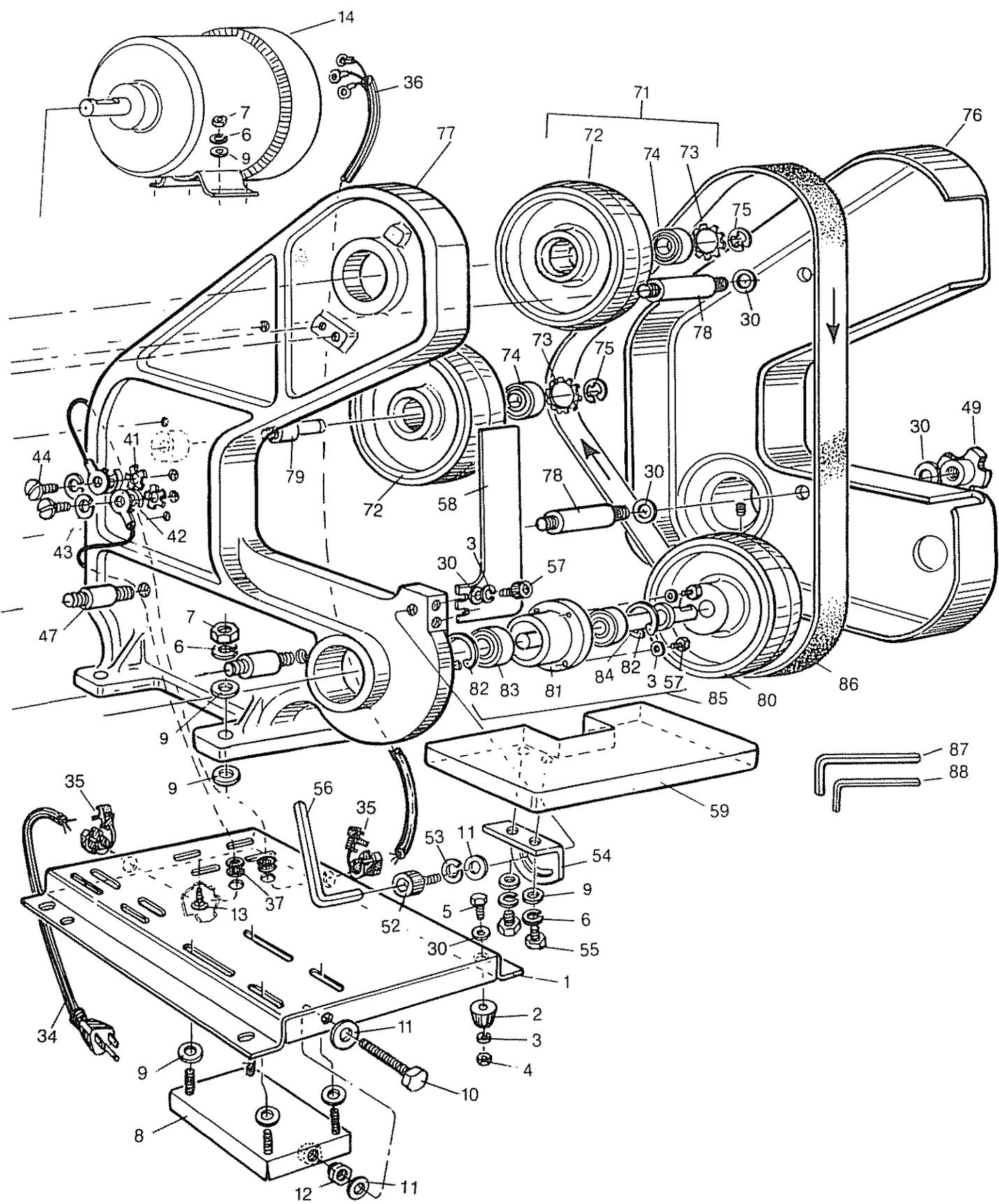


Figure 6



**SEARS**

**OWNER'S  
MANUAL**

**SERVICE**

**MODEL NO.  
351.22632**

**HOW TO ORDER  
REPAIR PARTS**

**1 in. BELT & 8 in.  
DISC SANDER  
and MITER GAUGE**

Now that you have purchased your Belt and Disc Sander should a need exist for repair parts or service, simply contact any Sears Service Center and most Sears, Roebuck and Co. stores. Be sure to provide all pertinent facts when you call or visit.

The model number of your 1-inch belt and 8-inch disc sander will be found on the side of the base.

All parts listed may be ordered from any Sears Service Center and most Sears stores. If the parts you need are not stocked locally, your order will be electronically transmitted to a Sears Repair Parts Distribution Center for handling.

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

PART NUMBER

PART DESCRIPTION

MODEL NUMBER

NAME OF ITEM

351.22632

1-in. Belt and 8-in. Disc Sander

**Sold by SEARS, ROEBUCK AND CO., Chicago, IL 60684 U.S.A.**