

POWERMATIC®

WMH | TOOL GROUP

Operating Instructions and Parts Manual Wide Belt Sanders

Models RB-25 and RB-37



WMH TOOL GROUP

2420 Vantage Drive
Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com

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This manual has been prepared for the owner and operators of a Powermatic Model RB-25 or RB-37 Wide Belt Sander. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your sander, and to aid in using the machine safely, read this manual thoroughly and follow all instructions carefully.

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WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can give you quick service.

In most cases, any one of these WMH Tool Group Repair Stations can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET, Performax, Powermatic or Wilton tools.

For the name of an Authorized Repair Station in your area, call 1-800-274-6848.

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WMH Tool Group (including JET, Performax, Powermatic and Wilton brands) makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

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To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, WMH Tool Group will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. WMH Tool Group will return repaired product or replacement at our expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of our warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights, which vary from state to state.

WMH Tool Group sells through distributors only. WMH Tool Group reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

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SAFETY RULES

As with all machines, there is a certain amount of hazard involved with the use of this sander. Use the machine with the respect and caution demanded where safety precautions are concerned. When normal safety precautions are overlooked or ignored, personal injury to the operator can result.

Read, understand and follow the safety and operating instructions found in this manual. Know the limitations and hazards associated with this sander.

Electrical grounding. Make certain that the machine frame is electrically grounded and that a ground lead is included in the incoming electrical service. In cases where a cord and plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the National Electrical Code.

Eye safety. Wear an approved safety shield, goggles, or glasses to protect eyes. (NOTE: Common eyeglasses are only impact-resistant, they are *not* safety glasses.)

Personal protection. Before operating the machine, remove tie, rings, watch and other jewelry and roll up sleeves above the elbows. Remove all loose outer clothing and confine long hair. Protective type footwear should be used - steel toed shoes are recommended since heavy parts can fall off the conveyor table onto feet. Where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations, use hearing protective devices. Do not wear gloves.

Guards. Do not operate the sander with the guards off. Keep the guards in place at all times when the machine is running. If removed for maintenance purposes or any other reason, use extreme caution and replace the guards upon completion of the task and before using the machine again.

Work area. Keep the floor around the machine clean and free of scrap material, saw dust, oil and other liquids to minimize the danger of tripping or slipping. Make certain the work area is well lighted and that a proper exhaust system is used to minimize dust. Powermatic recommends the use of anti-skid floor strips on the floor area where the operator normally stands and that each machine's work area be marked off. Provide adequate work space around the machine.

Power on. Before connecting power to the sander, make sure the start switch is in the "OFF" position.

Operator position. Maintain a balanced stance and keep your body under control at all times. Stand to one side of the conveyor table and make sure no one else is standing in line with the table while feeding into the machine. The wide belt sander operates at a high speed and should a part slip, it will exit the machine at a high rate of speed and may result in injuries to anyone standing directly in front of the infeed. (Keep conveyor belt clean and check pin-roll adjustment.) Never stand on the machine. Serious injury could occur if the sander is tipped or if the sanding belt is accidentally contacted.

Housekeeping. Before turning on machine, remove all extra equipment such as keys, wrenches, scrap, and cleaning rags away from the sander.

Careless acts. Give the work you are doing your undivided attention. Looking around, carrying on a conversation, and "horseplay" are careless acts that can result in serious injury.

Disconnect machine before performing any service, maintenance or adjustments. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.

Hand safety. Keep hands clear while feeding parts onto the conveyor table; the part will be forced down as it begins to feed into the machine, causing a pinching action between part and table. Never reach into a running machine. Turn off electrical power and stop machine before attempting to retrieve parts from within the machine. Contact with internal moving parts can result in loss or injury to fingers, hands and arms.

Stock length. Do not attempt to sand stock shorter than 9 inches (288.6 mm) long without butting a board of equal thickness behind it to help stock through the machine. Boards less than 9 inches long cannot be held secure enough for safe operation of this machine.

Do not leave unattended. The operator of the sander is responsible for shutting the machine down when it is not in use. **CAUTION:** The abrasive belt will coast to a stop in normal conditions, and will only brake to a stop when the emergency devices are pressed. It is dangerous to leave a machine unattended. Persons not familiar with the sander's operation could injure themselves or others.

Maintain tools. Keep all tools sharp and clean for the best and safest performance, and follow instructions for lubricating and changing accessories.

Replacement parts. Use only Powermatic or factory authorized replacement parts and accessories; otherwise the sander warranty and guarantee is null and void.

Misuse. Do not use this Powermatic sander for other than its intended use. If used for other purposes, Powermatic disclaims any real or implied warranty and holds itself harmless for any injury or damage which may result from that use.

If you are not thoroughly familiar with the operation of wide belt sanders, obtain advice from your supervisor, instructor or other qualified person.

Drugs, alcohol, medication. Do not operate this machine while under the influence of drugs, alcohol, or any medication.

Health hazards. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- * Lead from lead-based paint.
- * Crystalline silica from bricks and cement and other masonry products.
- * Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

Familiarize yourself with the following safety notices used in this manual:



CAUTION: (This means that if precautions are not heeded, it may result in minor or moderate injury and/or possible machine damage)



WARNING: (This means that if precautions are not heeded, it could result in serious injury or possibly even death).

SAFETY

Familiarize yourself with the location of these decals on your machine.



FIGURE 1

ELEVATION, Front (RB-25, RB-37)

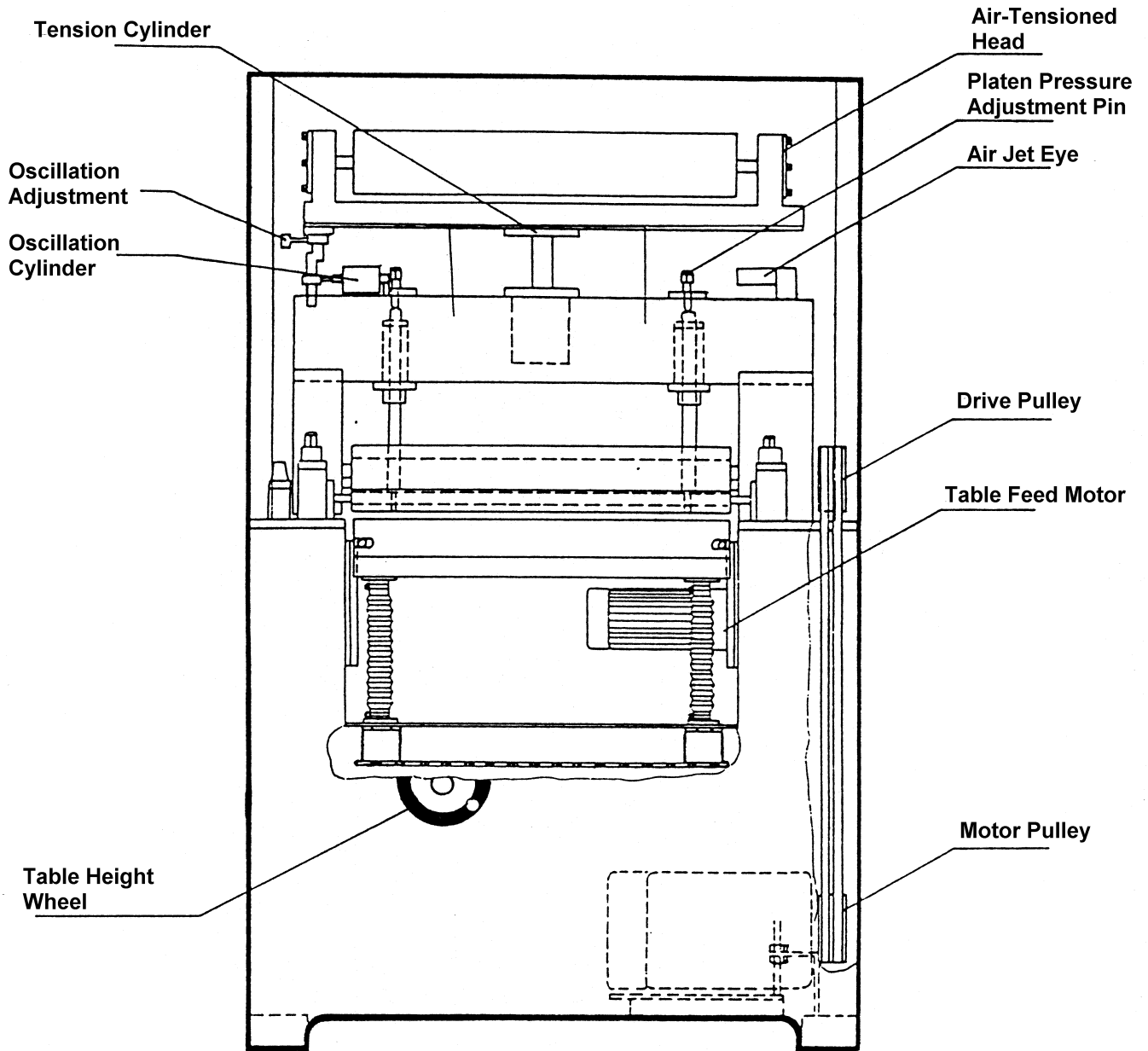


FIGURE 2

ELEVATION, Right Side (RB-25, RB-37)

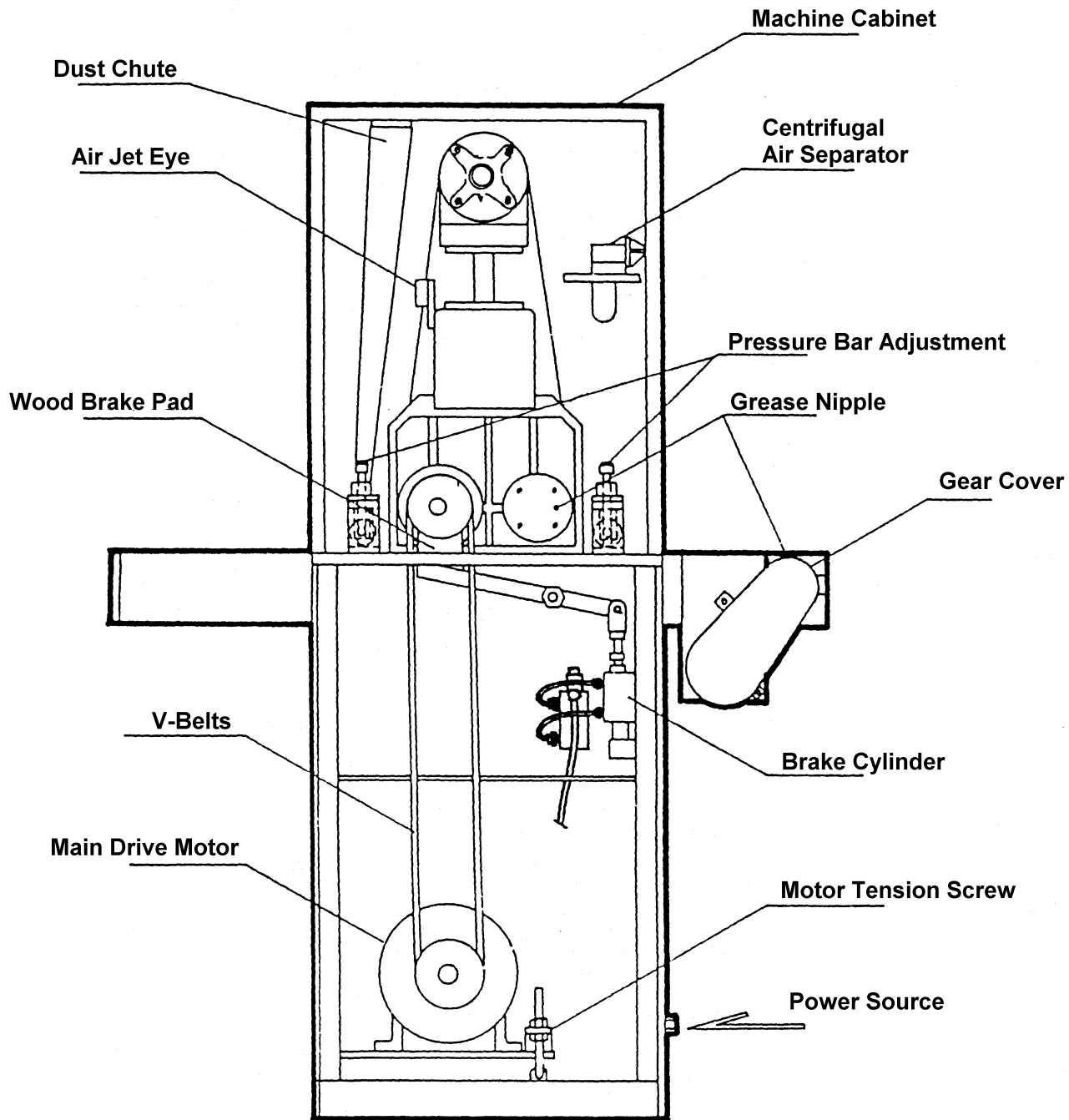


FIGURE 3

ELEVATION, Left Side (RB-25, RB-37)

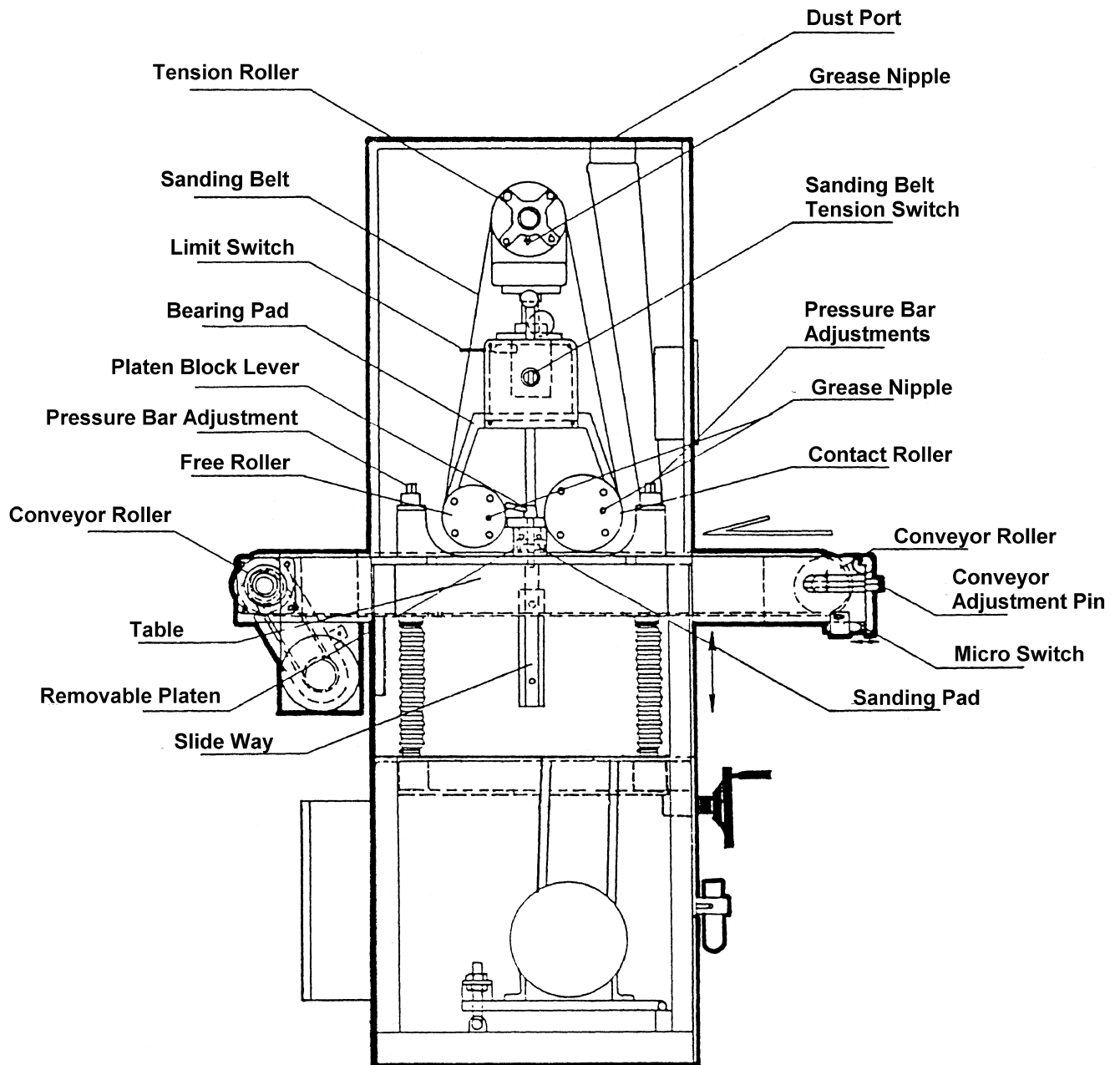


FIGURE 4

SPECIFICATIONS: RB-25 & RB-37 Wide Belt Sanders

| | RB-25 | RB-25-1 | RB-37 |
|-------------------------|--------------------|--------------------|--------------------|
| Stock Number | 1790804 | 1790808 | 1790805 |
| Working Width | 25" | 25" | 37" |
| Working Height | 5-7/8" | 5-7/8" | 5-7/8" |
| Table Height | 33-1/2" to 38-3/4" | 33-1/2" to 38-3/4" | 33-1/2" to 38-3/4" |
| Main Drive Motor | 10HP, 3Ph, 230V | 10HP, 1Ph, 230V | 15HP, 3Ph, 230V |
| Feed Motor | 1HP, 3Ph | 1HP, 1Ph | 1HP, 3Ph |
| Feed Rate | 15 & 30 FPM | 15 FPM | 15 & 30 FPM |
| Air Requirements | 60 psi, 3 CFM | 60 psi, 3 CFM | 60 psi, 3 CFM |
| Sanding Belt Size..... | 25" x 60" | 25" x 60" | 37" x 60" |
| Overall Dimensions..... | 52" x 44" x 71" | 52" x 44" x 71" | 52" x 58" x 71" |
| Gross Weight | 1600 lbs | 1600 lbs | 2000 lbs |

NOTE: The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, Powermatic reserves the right to change specifications without notice and without incurring obligations.

RECEIVING THE SANDER

Open shipping crate and check for shipping damage. Report any damage immediately to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

Contents of crate:

- 1 wide belt sander
- 2 sanding belts
- 1 tool box containing:
 - 1 platen pulling tool
 - 2 door handles
 - 1 can touch-up paint
 - 1 grease gun
 - 2 wrenches

INSTALLATION & ASSEMBLY

Level the machine and bolt it to the floor with high quality anchor bolts through the mounting holes located on the four corners inside the base.

Remove the protective coating from the rollers with a soft cloth moistened with a good commercial solvent. DO NOT USE acetone, gasoline, lacquer thinner or any type of flammable solvent.

INSTALLING DUST HOOD

Mount the dust hood to the top of the sander with the provided screws. See Figure 5 (Model RB-37 shown).

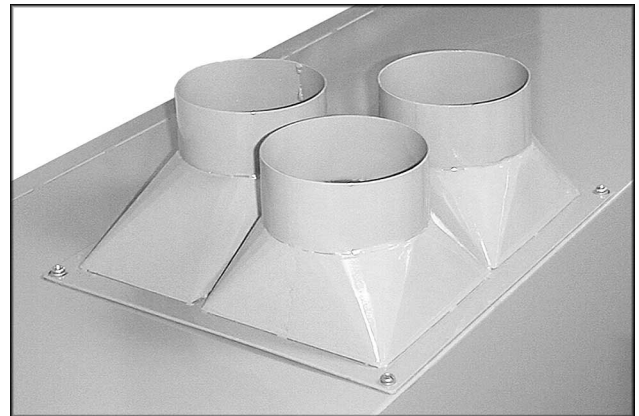


FIGURE 5

INSTALLING HANDLES

Mount the two handles to the doors. See Figure 6.



FIGURE 6

INSTALLING SANDING BELT

The wide belt sander is not shipped with the belt attached. Install the belt as follows:

1. Turn the platen lock lever (A, Fig. 7) counter-clockwise one half turn to loosen. Remove the lever (A, Fig. 7) and slide out the platen block (B, Fig. 7).

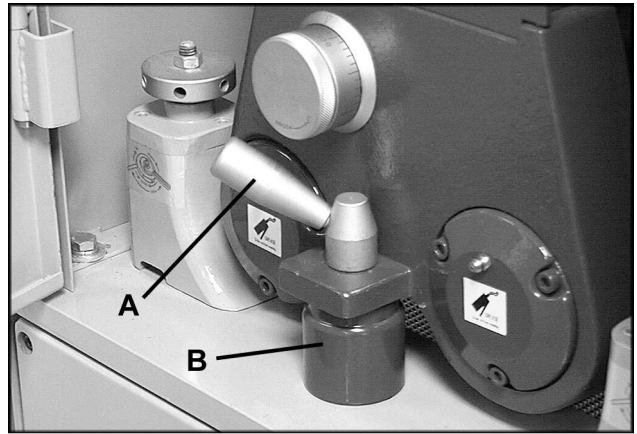


FIGURE 7

2. Notice the arrow on the inside of the belt. When operating, the arrow must turn in a counter-clockwise direction as shown in Figure 8. Slide the belt onto the three rollers, positioning it between the two limit switches (shown in Figure 17).



FIGURE 8

3. Replace the platen block (B, Fig. 7) and lock it in with the platen lock lever (A, Fig. 7).

4. Attach the air line (C, Fig. 9) to the filter regulator (D, Fig. 9) mounted on the front of the machine. A maximum of 60 pounds air pressure is required.

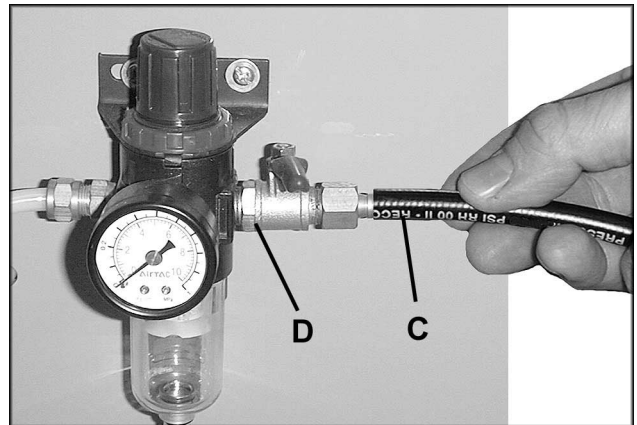


FIGURE 9

5. Turn the sanding belt tension switch (E, Fig. 10) clockwise, so that the white indicator on the switch is in the UP position. With this done, the operator should hear the sound of air on the tracking cylinder.

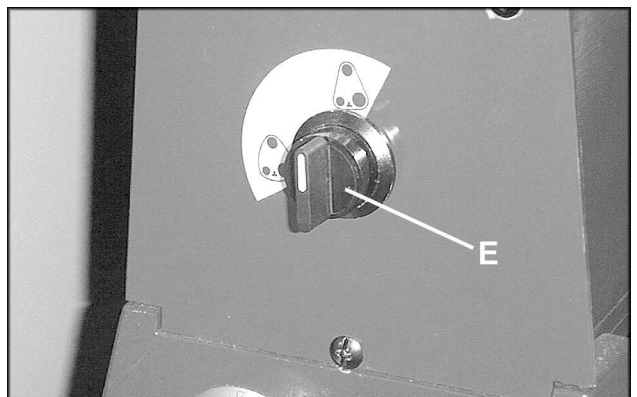


FIGURE 10

6. Bring the power supply into the bottom of the electrical box located at the rear of the machine. Check the motor and switch wiring diagram for proper voltage connections before applying power to the sander.

Wire the sander to its power source following the requirements of the National Electrical Code.

⚠ WARNING: All connections must be made by a qualified electrician. The Sander must be properly grounded in accordance with local and state codes and ordinances to prevent electrical shock and associated hazards including possible death.

7. When the proper voltage connections have been made, turn the power supply ON.

At this point the Power Lamp switch light (F, Fig. 11) on the control panel should be on. Turn the Emergency Brake button (G, Fig. 11) to the right (clockwise), then release.

8. Press the conveyor belt ON switch (H, Fig. 11). With the operator facing the control panel, the conveyor belt should rotate in a counterclockwise direction.

If the conveyor belt runs in the wrong direction, the electrician must change any two wires in the R-S-T set up in the control box.

9. With the conveyor belt switch properly wired, press the sanding belt ON switch (J, Fig. 11) for machine operation.

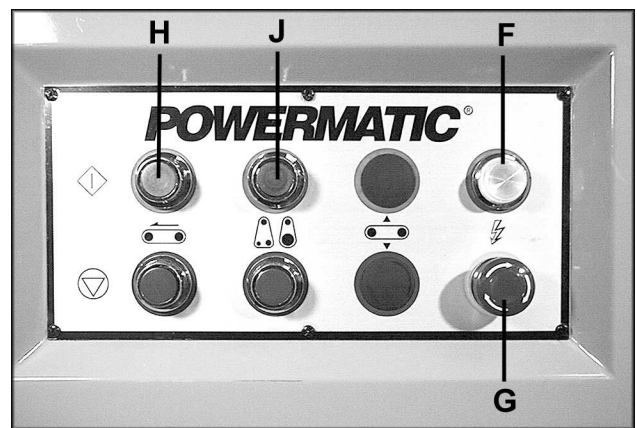


FIGURE 11

ADJUSTMENTS

SANDING BELT

The wide belt sander has been adjusted at the factory prior to shipping. However, if fine tuning is necessary, make adjustments with the oscillation adjusting knob (A, Fig. 12), so that the sanding belt will oscillate evenly between the two limit switches.

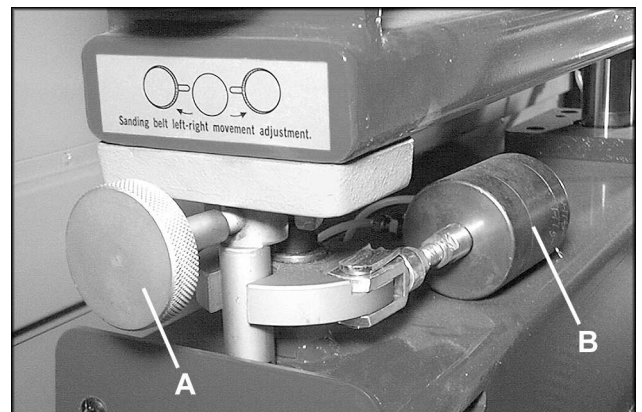


FIGURE 12

BELT TENSION

To tension the drive belts, remove the right side panel and raise or lower the motor using the hex nuts on the tension screw (C, Fig. 13).

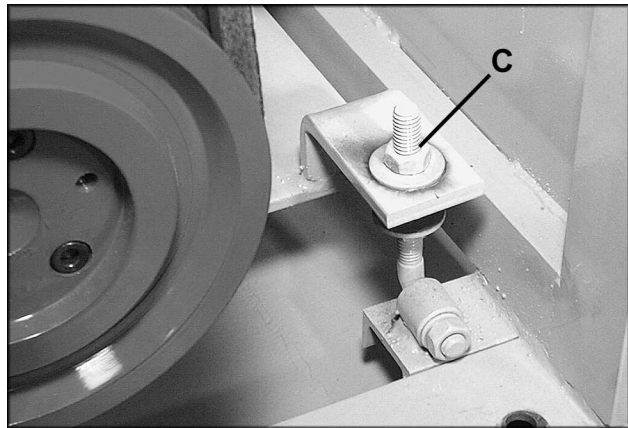


FIGURE 13

CONVEYOR TABLE

The table is raised or lowered by the handwheel (D, Fig. 14). The height is adjustable to accommodate stock up to 5-7/8" thick. A depth gauge scale (E, Fig. 14) is located on the left side of the table. The safety guard (F, Fig. 14) mounted on the front should be adjusted to within 1/4" from the top of the workpiece.



FIGURE 14

CONVEYOR BELT & ROLLERS

The conveyor belt is driven by a 1 Horsepower feed motor. Tension on the conveyor belt may be adjusted by rotating the conveyor adjustment pins (G, Fig. 14). These pins move the front conveyor rollers horizontally, and it is important to make sure that both ends of the rollers are adjusted symmetrically.

CONTACT ROLLER

The contact roller (H, Fig. 15), is the drive roller for the sanding belt, and is made of serrated hard rubber for maximum traction.



CAUTION: It is very important that narrow stock is not repeatedly fed in the same position during heavy sanding.

Repeated heavy pressure on a concentrated portion of the drive roller will cause premature and uneven wear of the roller which may greatly detract from the machine's performance. If large quantities of narrow stock have to be sanded, always alternate feed positions.

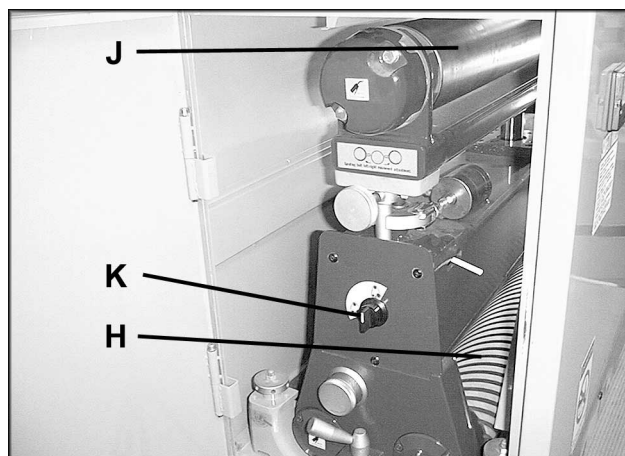


FIGURE 15

TENSION ROLLER & TRACKING SYSTEM

The tension roller (J, Fig. 15) is an unpowered roller. When the machine is connected to an air supply, the belt can be adjusted by turning the sanding belt tension switch (K, Fig. 15) to the up position. This activates the air cylinder located in the middle of the tension roller. Belt tension will automatically be maintained as long as the air supply is constant.

The tension roller also maintains the tracking of the belt by an oscillation cylinder.

The air jet eye (L, Fig. 16) triggers the movement of the oscillation cylinder (B, Fig. 12). The oscillation adjustment knob (A, Fig. 12) controls the initial camber of the head. Maximum oscillation movement is approximately 1/8".

Always be sure the oscillation adjusting knob is securely tightened if camber has been reset.

Mechanical limit switches (M, Fig. 17) on each side of the belt activate the pneumatic brake should the belt wander off track. This will shut down the sander rapidly to avoid fraying the belt.

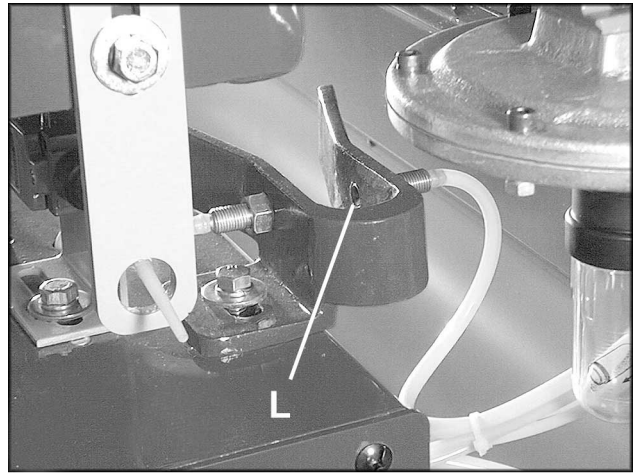


FIGURE 16

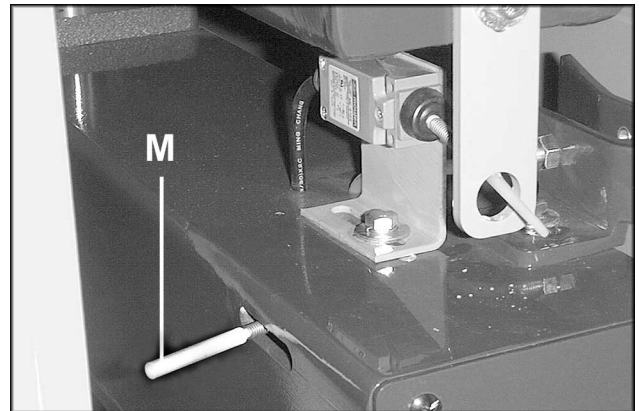


FIGURE 17

PRESSURE BARS

The infeed and outfeed pressure bars are pre-set at the factory. When properly adjusted, every point on the workpiece is sanded equally. The outfeed pressure bars (N) are shown in Fig. 18.

If the ends of the workpiece are sniped, the front bar is too low. The pressure should exert enough force to firmly hold the workpiece against the table conveyor, but not so hard that the ends of the workpiece spring up after clearing the bar. Also, if the ends of the bars are not exerting equal pressure, the workpiece will tend to move sideways on the table during sanding.

To raise or lower each set of pressure bars, proceed as follows:

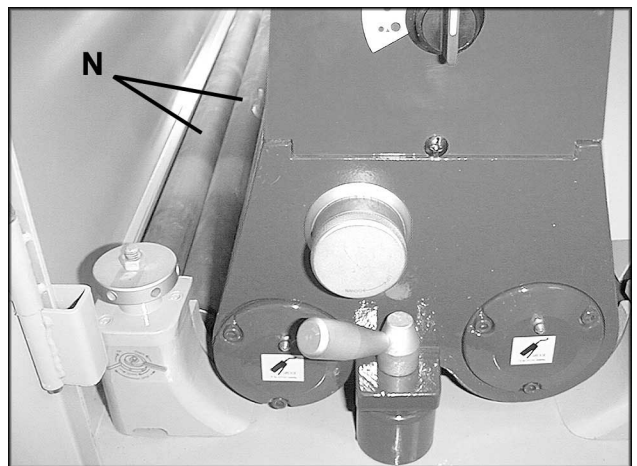


FIGURE 18

1. Release the locking nut (P, Fig. 19) with a wrench.
2. Insert a hex wrench (R, Fig. 19) or similar object into a hole in the adjusting knob (S, Fig. 19). With the hex wrench, turn the knob clockwise to raise the pressure bar. Turn in a counterclockwise direction to lower the bars. To ensure symmetry of both sets of bars, the recommended procedure is to use a gauge block on each end of both sets of bars.
3. When finished, re-tighten locking nut (P, Fig. 19).

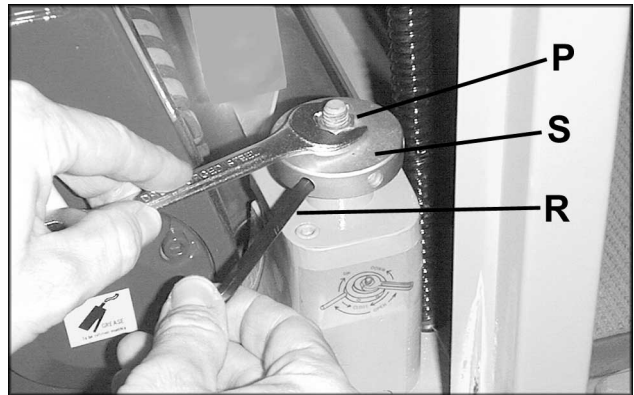


FIGURE 19

PLATEN

The head of the sander features a removable platen with a compressed felt pad and graphite bearing sheet attached to the bottom to reduce belt friction.

To remove the platen for replacement or cleaning purposes, proceed as follows:

1. Remove the platen lock lever and the platen block. (See Fig. 7).
2. Insert the special pulling tool (T, Fig. 20) into the hole in the platen (U, Fig. 20) and pull straight out.
3. Replace the felt pad and graphite bearing sheet. Clean the dovetail section of both male and female platens.

If the sanding belt needs to be changed, it should be done at this time.

4. Slide the female platen (U, Fig. 20) back into position and replace the platen block. Install the platen lock lever and secure.

NOTE: The height of the platen is adjusted at the factory but can be readjusted by rotating the platen bar adjusting scale (V, Fig. 20).

Each mark on the scale indicates a raising or lowering measurement of 0.005 mm. One complete rotation of the scale moves the platen 0.2 mm or approximately 8/1000 of an inch.

Theoretically, optimum finish sanding results are obtained when the bottom of the platen extends slightly below the bottom of the conveyor rollers. The main consideration in adjusting the platen is to make sure that both ends are symmetrical and level.

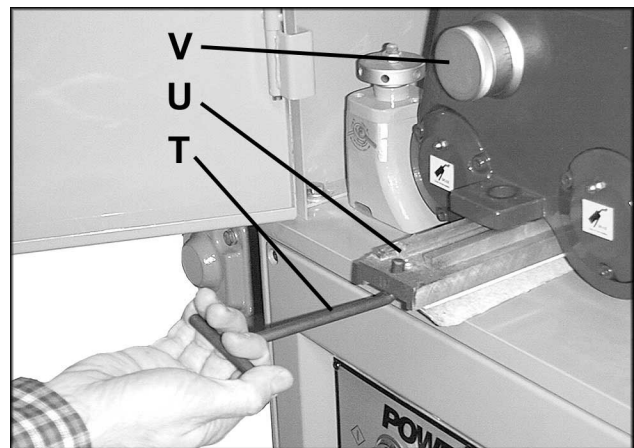


FIGURE 20

MAINTENANCE

Maintenance for the Wide Belt Sander is done on a weekly and monthly basis.

WEEKLY:

Grease sanding head - each of the three rollers has a grease nipple at each end (for a total of 6).

Shut off incoming air pressure. Unscrew the plastic air cup (A, Fig. 21) from the base of the air valve, and remove the dust particles. It is essential that this step be performed periodically to keep the internal air system clean.

MONTHLY:

Oil table drive chain.

Check oil level in gear box, and add if necessary. Oil should be changed at least once a year, more frequently if machine receives heavy use.

Exhaust System

The belt sander must use an exhaust system of sufficient size to provide an exhaust volume of 1200 cubic feet per minute. Frequent inspection of dust collection bags are necessary to ensure maximum removal of dust particles.

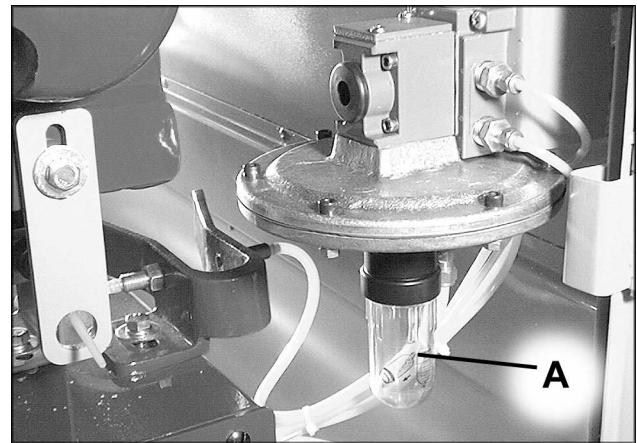


FIGURE 21

PNEUMATIC CONTROL SYSTEM (RB-25 & RB-37)

Figure 22 is a diagram explaining in further detail the operation of the air system:

1. Adjust air pressure at the regulator to 66 pounds per square inch.
2. The presence of air pressure will extend the brake air cylinder (3), which releases the brake and permits rotation of the sander.
3. Sanding belt tension is activated by a toggle switch (2) which releases air pressure to the belt tension cylinder (1).
4. Belt tracking is maintained by a pneumatic system that oscillates the upper belt tension roller back and forth.

An air orifice (12) regulates the air flow to air valve (5). The air orifice (13) and receiver (14) on the left side of the belt is used to signal the left limit of the oscillation.

The signal shifts the air valve (5) and releases pressure to the air cylinder (6) which rotates the cam (7) and consequently pivots the tension roller. This pivot action moves the belt to the right side. When the belt moves to the right side, the air orifice and receiver signal changes and releases pressure to the air cylinder, which pivots the tension roller back in the other direction.

Centering of the oscillation may be adjusted by the lever (9). The period of oscillation may be adjusted by the air orifices (11) which regulate air flow to and out of the air cylinder.

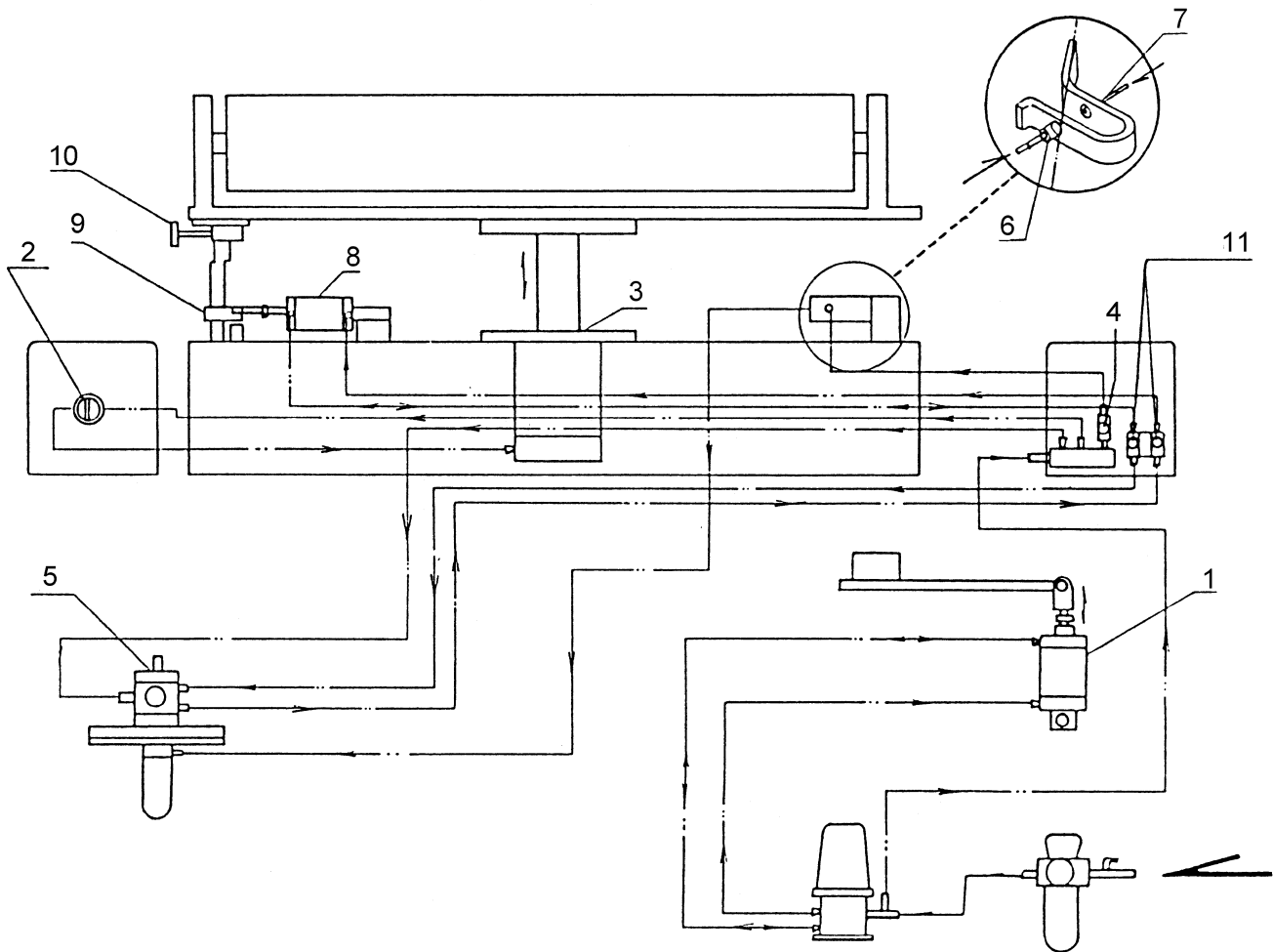
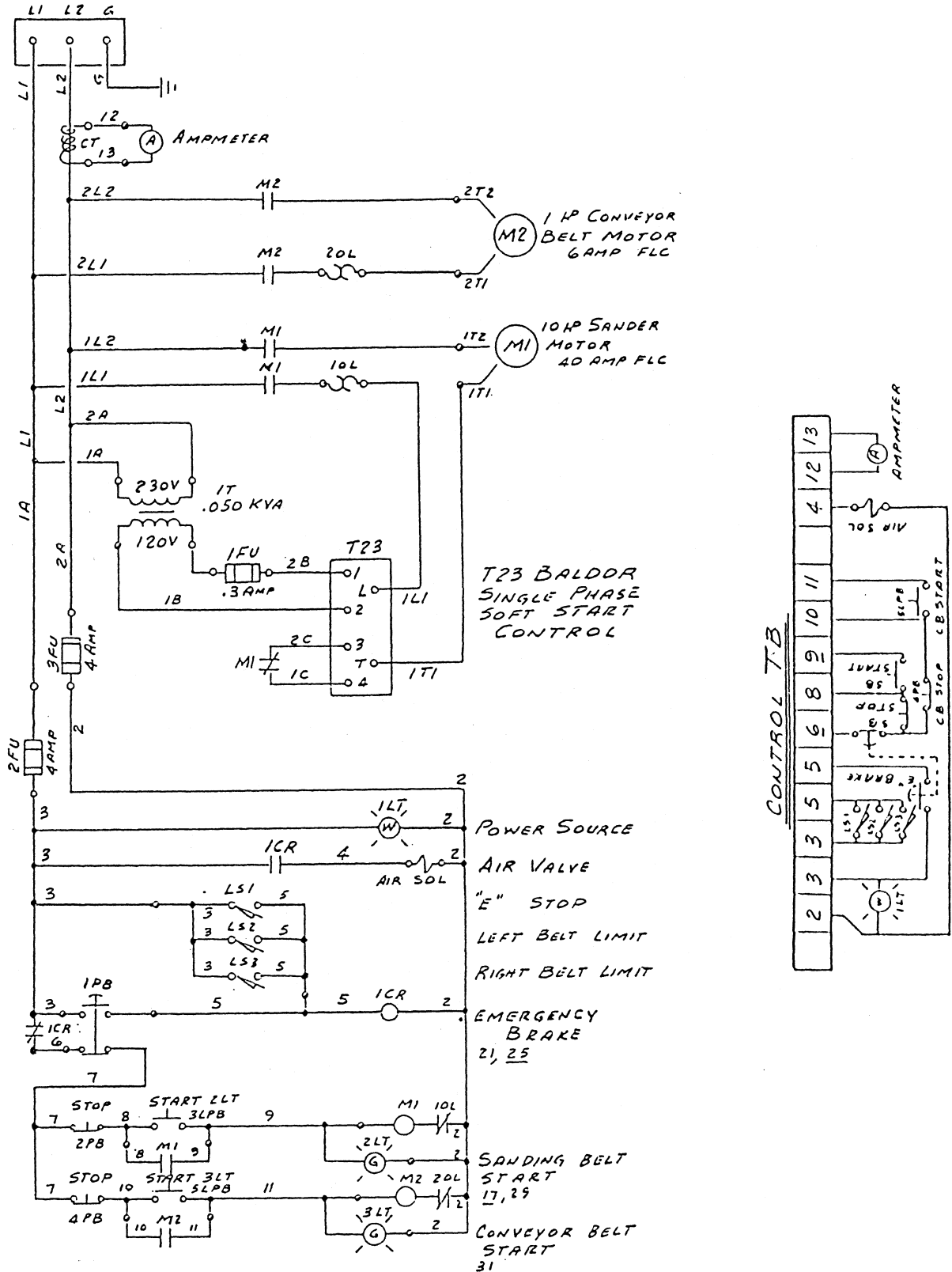


FIGURE 22

ELECTRICAL SCHEMATIC (RB-25-1 Sander – Single Phase only)



OPTIONAL ACCESSORIES (RB-25 & RB-37 Sanders)

| | |
|---------|------------------------------------|
| 6290285 | Sanding Belt, 100 Grit, 25" x 60" |
| 6290286 | Sanding Belt, 80 Grit, 25" x 60" |
| 6290471 | Sanding Belt, 60 Grit, 25" x 60" |
| 6290472 | Sanding Belt, 120 Grit, 25" x 60" |
| 6288724 | Sanding Belt, 100 Grit, 37" x 60" |
| 6288725 | Sanding Belt, 80 Grit, 37" x 60" |
| 6288738 | Sanding Belt, 60 Grit, 37" x 60" |
| 6288739 | Sanding Belt, 120 Grit, 37" x 60" |
| 6288607 | Drive Motor, 1 HP 460V Overload |
| 6288608 | Overload 10HP 3Ph 460V (for RB-25) |
| 6288609 | Overload 15HP 460V (for RB-37) |

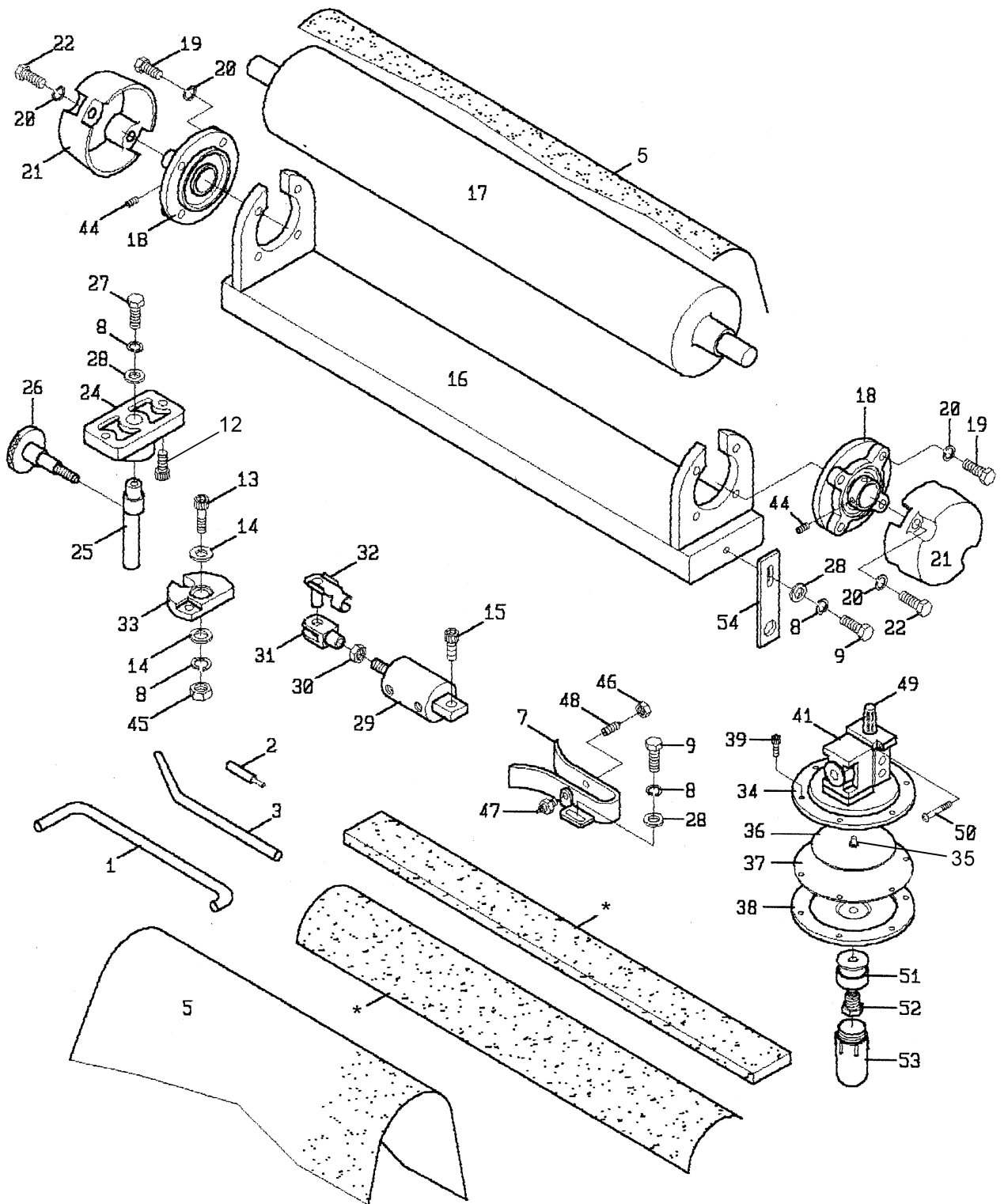
Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 between 7:00 a.m. and 6:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

PARTS LIST: Tension Roller Assembly (RB-25)

| No. | Part No. | Description | Quantity |
|-----|------------|---|----------|
| 1 | 6290281 | Graphite Hook..... | 1 |
| 2 | 6290282 | Switch Adjustment Rod..... | 2 |
| 3 | 6290283 | Roller Adjustment Rod..... | 1 |
| 5 | 6290285 | Sanding Belt, 25 x 60, 100 Grit..... | 1 |
| | 6290286 | Sanding Belt, 25 x 60, 80 Grit..... | 1 |
| | 6290471 | Sanding Belt, 25 x 60, 60 Grit..... | 1 |
| | 6290472 | Sanding Belt, 25 x 60, 120 Grit..... | 1 |
| 7 | 6290355 | Air Jet Eye Mounting Base..... | 1 |
| 8 | 6290356 | Lock Washer..... | 1 |
| 9 | 6290357 | Hex Cap Screw..... | 1 |
| 12 | 6290360 | Socket Head Cap Screw (shaft block)..... | 2 |
| 13 | 6290361 | Socket Head Cap Screw, (micro block)..... | 1 |
| 14 | 6290362 | Micro Block Copper Plate..... | 2 |
| 15 | 6290363 | Socket Head Cap Screw..... | 1 |
| 16 | 6290364 | Tension Roller Frame..... | 1 |
| 17 | 6290365 | Tension Roller..... | 1 |
| 18 | 6290366 | Upper Roller Bearing..... | 2 |
| 19 | 6290367 | Hex Head Screw..... | 4 |
| 20 | 6290368 | Lock Washer..... | 4 |
| 21 | 6290369 | End Cap..... | 2 |
| 22 | 6290370 | Hex Cap Screw..... | 4 |
| 24 | 6290372 | Shaft Block..... | 1 |
| 25 | 6290373 | Shaft..... | 1 |
| 26 | 6290374 | Oscillation Adjusting Knob..... | 1 |
| 27 | 6290375 | Hex Head Screw..... | 1 |
| 28 | 6290376 | Flat Washer..... | 1 |
| 29 | 6290377 | Cylinder, #50-4..... | 1 |
| 30 | 6290378 | Hex Nut..... | 1 |
| 31 | 6290379 | Clevis..... | 1 |
| 32 | 6290380 | Clevis Pin..... | 1 |
| 33 | 6290381 | Micro block..... | 1 |
| 34 | 6290384 | Aluminum Plate..... | 1 |
| 35 | 6290382 | Copper Shaft..... | 1 |
| 36 | 6290383 | Aluminum Plate..... | 1 |
| 37 | 6290385 | Plate..... | 1 |
| 38 | 6290386 | Aluminum Plate..... | 1 |
| 39 | 6290387 | Aluminum Plate Screw..... | 6 |
| 41 | 6290445 | Pressure Valve..... | 1 |
| | 6290466 | Diaphragm-Operated Valve Assembly (Items no. 34 thru 41)..... | 1 |
| 44 | TS-1523011 | Socket Set Screw, M6 x 6..... | 2 |
| 45 | 6290483 | Hex Nut, 1/2-12 UNC..... | 1 |
| 46 | TS-0561032 | Hex Nut, 3/8-24 UNC..... | 1 |
| 47 | 6290484 | Air Sensor Nozzle (male)..... | 1 |
| 48 | 6290485 | Air Sensor Nozzle (female)..... | 1 |
| 49 | 6290405 | Silencer..... | 1 |
| 50 | TS-081C062 | Phillips Pan Head Machine Screw, #10-24 x 1..... | 1 |
| 51 | 6290407 | Air Cup Connector..... | 1 |
| 52 | 6290486 | Air Cup Shaft..... | 1 |
| 53 | 6288615 | Air Cup..... | 1 |
| 54 | 6290487 | Power Off Plate..... | 1 |

Tension Roller Assembly (RB-25)

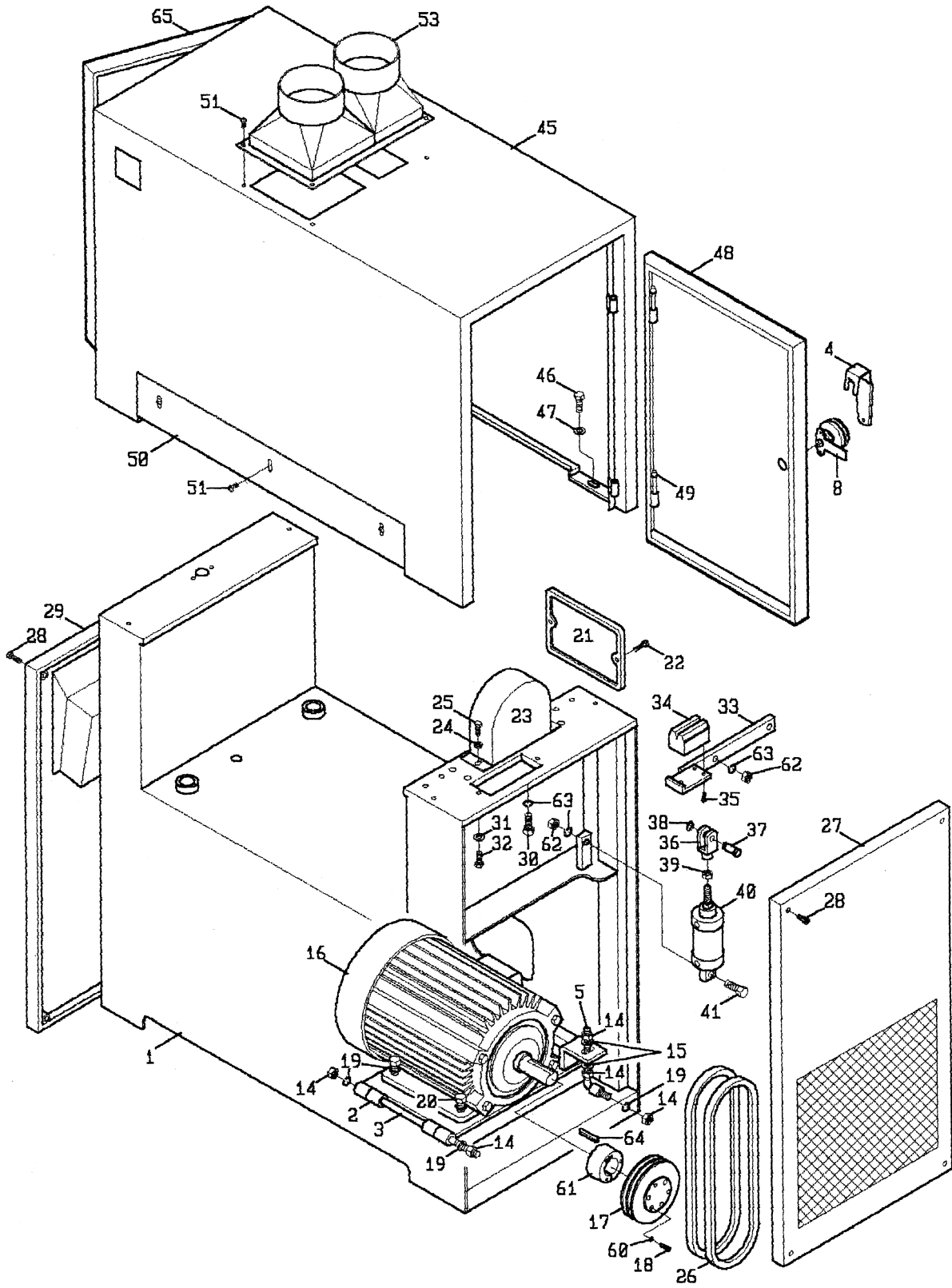


* Reference - see "Platen Assembly"

PARTS LIST: Cabinet & Motor Assembly (RB-25)

| No. | Part No. | Description | Quantity |
|-----|------------|--------------------------------------|----------|
| 1 | 6288625 | Machine Base | 1 |
| 2 | 6288626 | Motor Base | 1 |
| 3 | 6288627 | Motor Base Plate Pin | 1 |
| 4 | 6290284 | Door Lock Handle | 2 |
| 5 | 6288629 | Motor Tension Adjusting Screw | 1 |
| 8 | 6290488 | Door Latch Assembly | 2 |
| 14 | TS-0561051 | Hex Nut, 1/2-13..... | 5 |
| 15 | TS-0680061 | Plain Flat Washer, 1/2 | 2 |
| 16 | 6290478 | Motor, 10 HP, 1 PH (RB-25-1) | 1 |
| | 6288633 | Motor, 10 HP, 3 Ph (RB-25) | 1 |
| 17 | 6288632 | Motor Pulley..... | 1 |
| 18 | 6288634 | Pulley Screw..... | 1 |
| 19 | TS-0720111 | Lock Washer, 1/2..... | 5 |
| 20 | 6288635 | Hex Cap Screw, 1/2 | 4 |
| 21 | 6288636 | Motor Access Cover..... | 1 |
| 22 | 6288637 | Cover Screw | 2 |
| 23 | 6288638 | Pulley Cover | 1 |
| 24 | 6288639 | Washer | 2 |
| 25 | 6288640 | Phillips Round Head Screw..... | 2 |
| 26 | 6288641 | V-Belt | 2 |
| 27 | 6288642 | Right Ventilating Plate | 1 |
| 28 | 6288643 | Socket Head Cap Screw | 8 |
| 29 | 6288644 | Left Plate | 1 |
| 30 | 6288645 | Bearing Base Screw..... | 4 |
| 31 | 6288646 | Washer..... | 4 |
| 32 | 6288647 | Bearing Base Screw..... | 4 |
| 33 | 6288648 | Brake Arm | 1 |
| 34 | 6288649 | Brake Pad (RB-25)..... | 1 |
| 35 | 6288650 | Brake Pad Screw | 3 |
| 36 | 6288651 | Clevis | 1 |
| 37 | 6288652 | Clevis Pin | 1 |
| 38 | 6288653 | Retaining Ring..... | 1 |
| 39 | 6288654 | Cylinder Nut..... | 1 |
| 40 | 6288655 | Cylinder, 50-25 | 1 |
| 41 | 6288656 | Cylinder Screw..... | 1 |
| 45 | 6288664 | Upper Cabinet..... | 1 |
| 46 | 6288665 | Hex Cap Screw..... | 4 |
| 47 | 6288666 | Lock Washer (for Upper Cabinet)..... | 4 |
| 48 | 6288709 | Upper Cabinet Door (Right)..... | 1 |
| 49 | 6288667 | Upper Door Pin | 4 |
| 50 | 6288668 | Front Protection Plate | 1 |
| 51 | 6288669 | Front Protection Plate Screw..... | 4 |
| 53 | 6288671 | Dust Hood..... | 1 |
| 60 | 6290461 | Pulley Lock Washer | 1 |
| 61 | 6290460 | Pulley Bushing..... | 1 |
| 62 | TS-0561031 | Hex Nut, 3/8-16 UNC | 1 |
| 63 | TS-0720091 | Lock Washer, 3/8..... | 1 |
| 64 | 6290489 | Key, 10 x 8 x 56mm..... | 1 |
| 65 | 6290491 | Upper Cabinet Door (Left)..... | 1 |

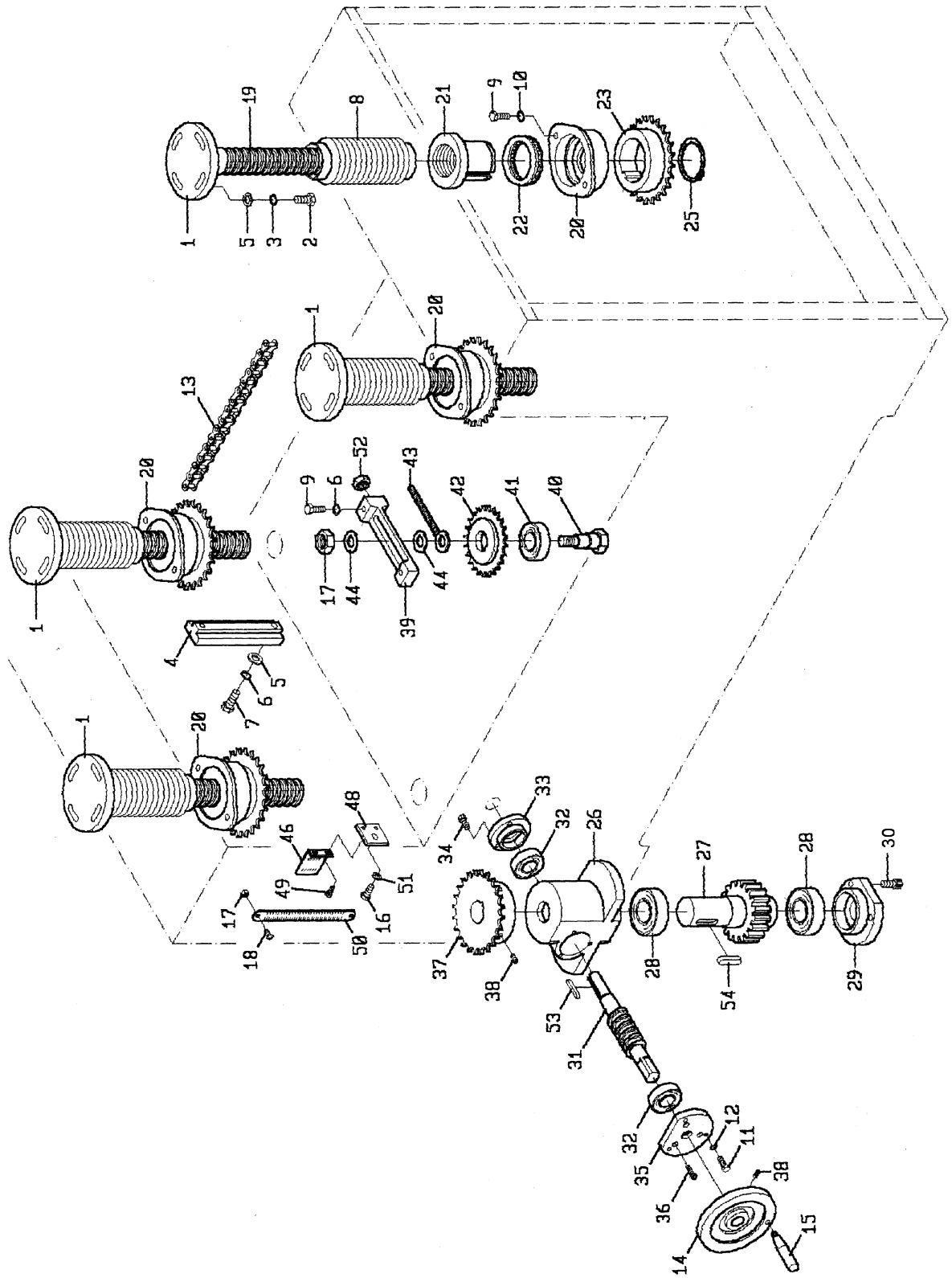
Cabinet & Motor Assembly (RB-25)



PARTS LIST: Table Raising Assembly (RB-25)

| No. | Part No. | Description | Quantity |
|-----|------------|--|----------|
| 1 | 6288672 | Lifting Rod Head | 4 |
| 2 | 6288673 | Lifting Rod Screw | 8 |
| 3 | 6288674 | Lifting Rod Washer..... | 8 |
| 4 | 6288675 | Slide Ways..... | 2 |
| 5 | 6288676 | Plain Washer..... | 4 |
| 6 | 6288677 | Lock Washer | 4 |
| 7 | 6288678 | Hex Head Screw | 4 |
| 8 | 6288679 | Lifting Rod Protection Tube..... | 4 |
| 9 | 6288680 | Hex Head Screw | 8 |
| 10 | 6288681 | Lock Washer | 8 |
| 11 | 6288682 | Hex Head Screw | 3 |
| 12 | 6288683 | Lock Washer | 3 |
| 13 | 6288684 | Chain | 1 |
| 14 | 6288685 | Handwheel | 1 |
| 15 | 6288686 | Handwheel Handle | 1 |
| 16 | 6288687 | Base Block Screw | 2 |
| 17 | 6288688 | Hex Nut, 3/8..... | 3 |
| 18 | 6288689 | Scale Screw | 2 |
| 19 | 6288690 | Lifting Rod..... | 4 |
| 20 | 6288691 | Lifting Rod Base..... | 4 |
| 21 | 6288692 | Lifting Rod Screw..... | 4 |
| 22 | 6288693 | Fixing Ring..... | 4 |
| 23 | 6288694 | Chain Gear..... | 4 |
| 25 | 6288696 | Retaining Ring..... | 4 |
| 26 | 6288697 | Gearbox | 1 |
| 27 | 6288698 | Worm Gear | 1 |
| 28 | 6288699 | Bearing | 2 |
| 29 | 6290200 | Gearbox Cover..... | 1 |
| 30 | 6290201 | Gearbox Screw | 3 |
| 31 | 6290202 | Worm Rod..... | 1 |
| 32 | 6290203 | Bearing | 2 |
| 33 | 6290204 | Gearbox Cover..... | 1 |
| 34 | 6290205 | Gearbox Screw | 3 |
| 35 | 6290206 | Gearbox Cover Base..... | 1 |
| 36 | 6290207 | Gearbox Cover Screw | 3 |
| 37 | 6290208 | Chain Gear..... | 1 |
| 38 | 6290209 | Chain Gear Screw | 2 |
| 39 | 6290210 | Chain Adjusting Base | 1 |
| 40 | 6290211 | Chain Gear Adjusting Shaft | 1 |
| 41 | 6290212 | Bearing | 1 |
| 42 | 6290213 | Chain Gear..... | 1 |
| 43 | 6290214 | Chain Adjusting Screw | 1 |
| 44 | TS-0680042 | Plain Washer, 3/8..... | 2 |
| 46 | 6290216 | Scale Base | 1 |
| 48 | 6290218 | Scale Base Mounting Block..... | 1 |
| 49 | 6290219 | Scale Base Screw | 2 |
| 50 | 6290220 | Scale | 1 |
| | 6290455 | Gear Box Assembly (Items 26 thru 36, 54) | 1 |
| 51 | TS-0680021 | Flat Washer, 1/4..... | 1 |
| 52 | 6290831 | Hex Nut, 3/16-16..... | 2 |
| 53 | 6290492 | Key , 4 x 4 x 20mm | 1 |
| 54 | 6290493 | Key , 5/16" x 5/16" x 20mm | 1 |

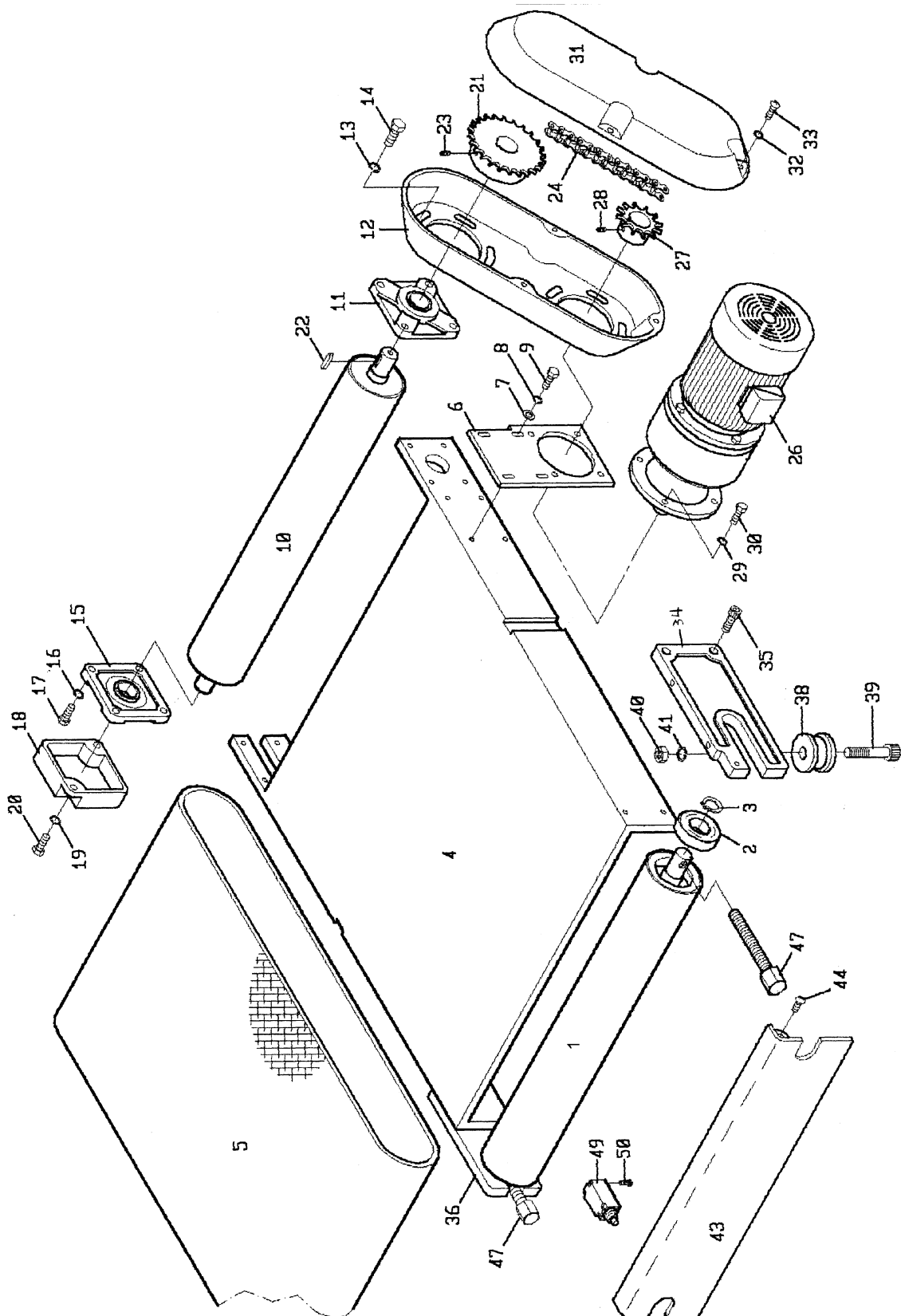
Table Raising Assembly (RB-25)



PARTS LIST: Table & Conveyor Belt Assembly (RB-25)

| No. | Part No. | Description | Quantity |
|-----|------------|---|----------|
| 1 | 6290262 | Front Conveyor Roller..... | 1 |
| 2 | 6290263 | Bearing..... | 2 |
| 3 | 6290264 | Retaining Ring..... | 2 |
| 4 | 6290221 | Conveyor Table..... | 1 |
| 5 | 6288606 | Conveyor Belt 25"..... | 1 |
| 6 | 6290222 | Gearbox Base..... | 1 |
| 7 | 6290223 | Plain Washer..... | 4 |
| 8 | 6290224 | Lock Washer..... | 4 |
| 9 | 6290225 | Hex Cap Screw..... | 4 |
| 10 | 6290226 | Back Conveyor Roller..... | 1 |
| 11 | 6290227 | Bearing..... | 1 |
| 12 | 6290228 | Lower Chain Gear Cover..... | 1 |
| 13 | 6290229 | Lock Washer..... | 4 |
| 14 | 6290230 | Hex Cap Screw..... | 4 |
| 15 | 6290231 | Bearing..... | 1 |
| 16 | 6290232 | Lock Washer..... | 2 |
| 17 | 6290233 | Hex Head Screw..... | 2 |
| 18 | 6290234 | Bearing Cover..... | 1 |
| 19 | 6290235 | Lock Washer..... | 2 |
| 20 | 6290236 | Hex Cap Screw..... | 2 |
| 21 | 6290237 | Chain Gear..... | 1 |
| 22 | 6290238 | Key..... | 1 |
| 23 | 6290239 | Chain Gear Set Screw..... | 2 |
| 24 | 6290240 | Chain, 5/8..... | 1 |
| 26 | 6290467 | Motor & Gear box, 10HP, 3Ph, 230V, 2-speed (RB-25)..... | 1 |
| | 6290476 | Motor & Gear box, 10HP, 3Ph, 460V, 2-speed (RB-25)..... | 1 |
| | 6290477 | Motor & Gear box, 15HP, 1Ph, 230V, 1-speed (RB-25-1)..... | 1 |
| 27 | 6290243 | Chain Gear..... | 1 |
| 28 | 6290244 | Chain Gear Set Screw..... | 2 |
| 29 | 6290245 | Lock Washer..... | 4 |
| 30 | 6290246 | Hex Head Screw..... | 4 |
| 31 | 6290247 | Upper Chain Gear Cover..... | 1 |
| 32 | 6290248 | Lock Washer..... | 3 |
| 33 | 6290249 | Phillips Pan Head Screw..... | 3 |
| 34 | 6290250 | Front Conveyor Roller Take-Up Plate, R.H..... | 1 |
| 35 | 6290251 | Socket Head Cap Screw..... | 4 |
| 36 | 6290252 | Front Conveyor Roller Take-Up Plate, L.H..... | 1 |
| 38 | 6290254 | Conveyor Roller (copper)..... | 2 |
| 39 | 6290255 | Roller Screw..... | 2 |
| 40 | TS-0561021 | Hex Nut, 5/16-18..... | 2 |
| 41 | TS-0720081 | Lock Washer, 5/16..... | 2 |
| 43 | 6290258 | Safety Guard..... | 1 |
| 44 | 6290259 | Safety Guard Screw..... | 2 |
| 47 | 6290444 | Conveyor Adjustment Pin..... | 2 |
| 49 | 6290494 | Limit Switch..... | 1 |
| 50 | TS-081C082 | Phillips Pan Head Machine Screw, #10-24 x 1-1/2..... | 1 |

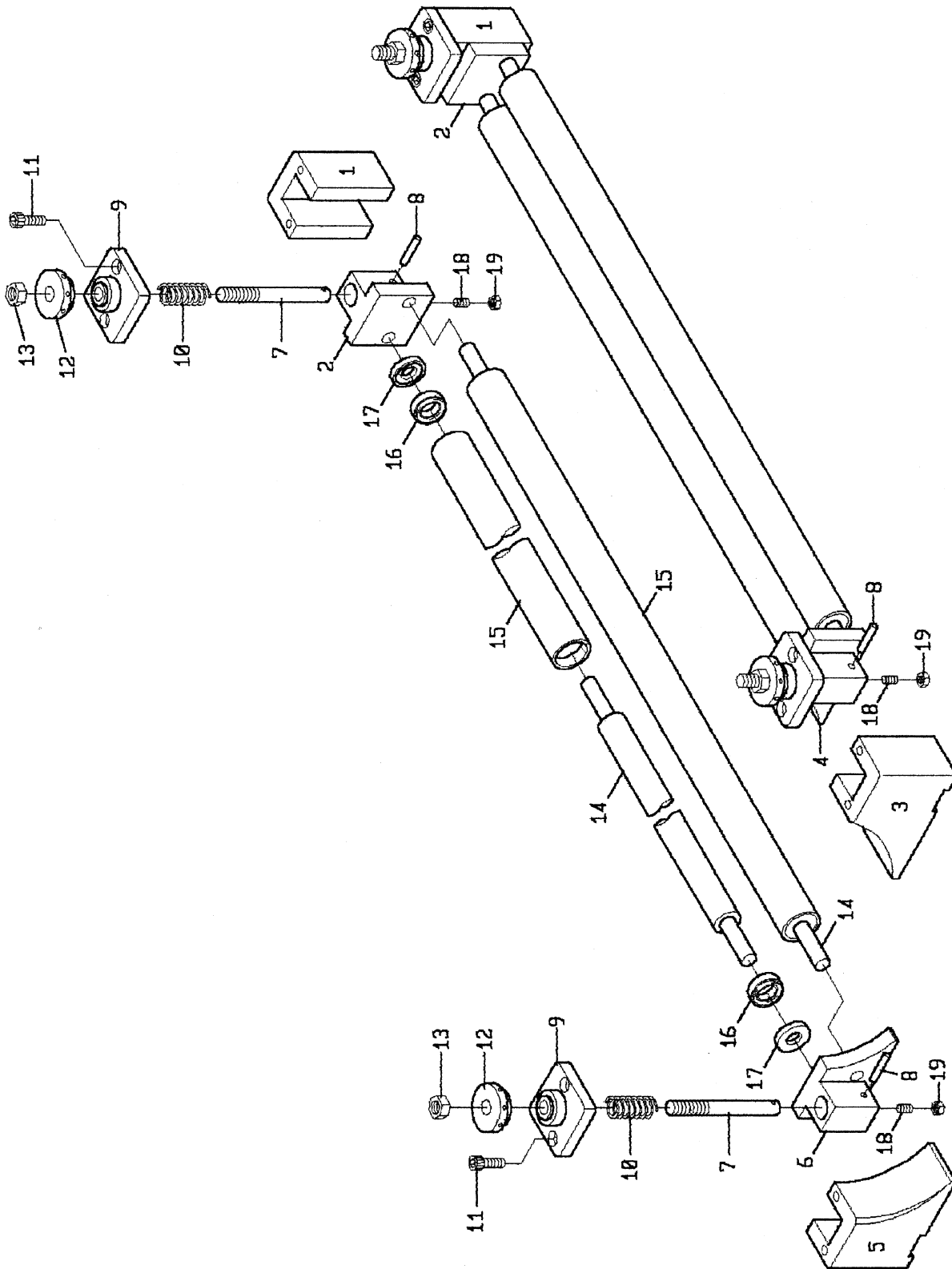
Table & Conveyor Belt Assembly (RB-25)



PARTS LIST: Pressure Bar Assembly (RB-25)

| No. | Part No. | Description | Quantity |
|-----|------------|---|----------|
| 1 | 6290265 | Roller Slider-female | 2 |
| 2 | 6290266 | Roller Slider-male | 2 |
| 3 | 6290267 | Front Roller Slider-female | 1 |
| 4 | 6290268 | Front Roller Slider-male | 1 |
| 5 | 6290269 | Back Roller Slider-female | 1 |
| 6 | 6290270 | Back Roller Slider-male | 1 |
| 7 | 6290271 | Roller Adjusting Rod | 4 |
| 8 | 6290272 | Spring Pin | 4 |
| 9 | 6290273 | Roller Slider Cover | 4 |
| 10 | 6290274 | Spring | 4 |
| 11 | 6290275 | Roller Slider Cover Screw | 8 |
| 12 | 6290276 | Roller Adjustment Knob | 4 |
| 13 | 6288688 | Hex Nut, 3/8 | 4 |
| | 6288740 | Pressure Bar Assembly (Items 14-17) | 1 |
| 14 | 6288605 | Pressure Bar Shaft | 4 |
| 15 | 6290278 | Pressure Bar Cover | 4 |
| 16 | 6290279 | Bearing | 8 |
| 17 | 6290280 | Bearing Cover | 8 |
| 18 | TS-0267071 | Socket Set Screw, 1/4-20 x 3/4 | 8 |
| 19 | TS-0570011 | Hex Nut, 1/4-20 UNC | 8 |

Pressure Bar Assembly (RB-25)



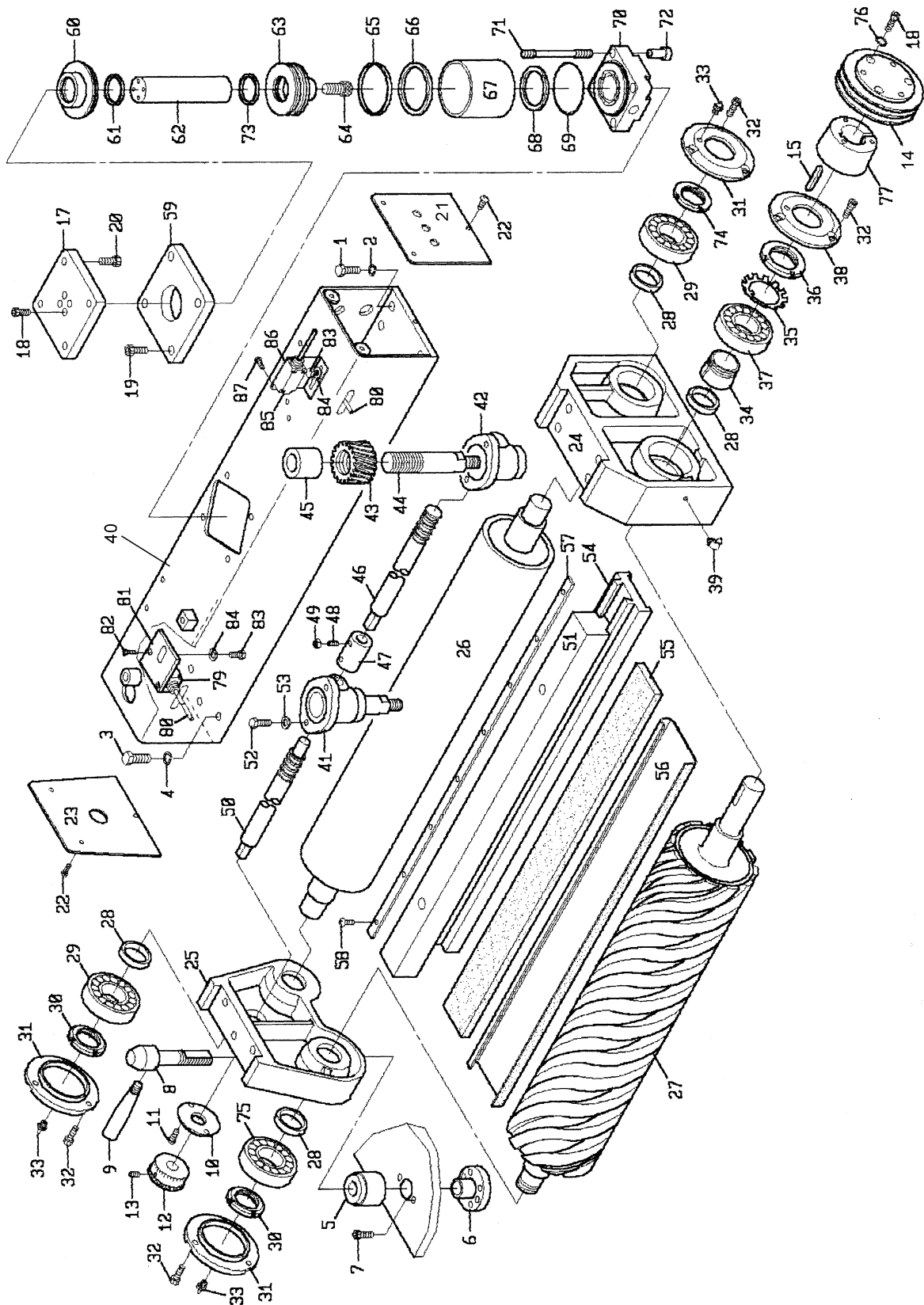
PARTS LIST: Platen Assembly (RB-25)

| No. | Part No. | Description | Quantity |
|-----|----------|--------------------------------------|----------|
| 1 | 6290287 | Hex Head Mounting Frame Screw..... | 4 |
| 2 | 6290288 | Mounting Frame Washer..... | 4 |
| 3 | 6290289 | Hex Head Mounting Frame Screw..... | 2 |
| 4 | 6290290 | Mounting Frame Washer..... | 2 |
| 5 | 6290291 | Diaphragm..... | 1 |
| 6 | 6290292 | Adjustable Knob..... | 1 |
| 7 | 6290293 | Adjustable Knob Screw..... | 2 |
| 8 | 6290294 | Screw Rod..... | 1 |
| 9 | 6290295 | Platen Lock Lever..... | 1 |
| 10 | 6290296 | Scale Ring Base..... | 1 |
| 11 | 6290297 | Scale Ring Base Screw..... | 2 |
| 12 | 6290298 | Scale Ring..... | 1 |
| 13 | 6290299 | Scale Ring Set Screw..... | 1 |
| 14 | 6290300 | Roller Pulley..... | 1 |
| 15 | 6290301 | Key..... | 1 |
| 17 | 6290303 | Mounting Block, 80-40 cylinder..... | 1 |
| 18 | 6290304 | Mounting Block Screw..... | 4 |
| 19 | 6290305 | Socket Head Cap Screw..... | 4 |
| 20 | 6290306 | Socket Head Cap Screw..... | 4 |
| 21 | 6290307 | Platen Seal, R.H..... | 1 |
| 22 | 6290308 | Seal Plate Screw..... | 6 |
| 23 | 6290309 | Seal Platen, L.H..... | 1 |
| 24 | 6290310 | Bearing Base..... | 1 |
| 25 | 6290311 | Bearing Frame..... | 1 |
| 26 | 6288623 | Free Roller..... | 1 |
| 27 | 6288604 | Contact Roller..... | 1 |
| 28 | 6290312 | Oil Seal..... | 4 |
| 29 | 6290313 | Bearing..... | 2 |
| 30 | 6290314 | Lock Nut, 30mm..... | 2 |
| 31 | 6290315 | Bearing Cover..... | 3 |
| 32 | 6290316 | Socket Head Cap Screw..... | 12 |
| 33 | 6290317 | Grease Fitting, 1/16..... | 3 |
| 34 | 6290318 | Fastening Ring #H307..... | 1 |
| 35 | 6290319 | Lock Washer..... | 1 |
| 36 | 6290320 | Lock Nut..... | 1 |
| 37 | 6290321 | Bearing..... | 1 |
| 38 | 6290322 | Bearing Cover..... | 1 |
| 39 | 6290323 | Grease Fitting..... | 1 |
| 40 | 6290324 | Mounting Frame..... | 1 |
| 41 | 6290325 | Graphite Base Gearbox, L.H..... | 1 |
| 42 | 6290326 | Graphite Base Gearbox, R.H..... | 1 |
| 43 | 6290327 | Gear Nut..... | 2 |
| 44 | 6290328 | Platen Bar Adjusting Rod..... | 2 |
| 45 | 6290329 | Bushing..... | 2 |
| 46 | 6290330 | Worm Gear Rod, R.H..... | 1 |
| 47 | 6290331 | Worm Gear Rod Connector..... | 1 |
| 48 | 6290332 | Worm Gear Rod Connector Screw..... | 2 |
| 49 | 6290333 | Worm Gear Rod Connector Hex Nut..... | 2 |
| 50 | 6290334 | Worm Gear Rod, L.H..... | 1 |
| 51 | 6290335 | Sliding Platen-male..... | 1 |
| 52 | 6290336 | Gearbox Screw..... | 4 |
| 53 | 6290337 | Gearbox Lock Washer..... | 4 |

PARTS LIST: Platen Assembly (RB-25) continued

| No. | Part No. | Description | Quantity |
|------------|-----------------|---|-----------------|
| 54 | 6288601* | Sliding Platen-female, 25" | 1 |
| 55 | 6288602* | Felt, 1/2 x 1-3/4 x 25 | 1 |
| 56 | 6288603 | Graphite | 1 |
| 57 | 6290339 | Bar..... | 1 |
| 58 | 6290340 | Bar Screw..... | 7 |
| 59 | 6290341 | Cylinder Mounting Block | 1 |
| 60 | 6290342 | Cylinder Cover..... | 1 |
| 61 | 6290343 | Cylinder Piston Rod Ring..... | 1 |
| 62 | 6290344 | Cylinder Piston Rod | 1 |
| 63 | 6290345 | Cylinder Piston | 1 |
| 64 | 6290346 | Cylinder Piston Screw..... | 1 |
| 65 | 6290347 | Piston Ring | 1 |
| 66 | 6290348 | Piston Ring..... | 1 |
| 67 | 6290349 | Aluminum Tube | 1 |
| 68 | 6290350 | O-ring | 1 |
| 69 | 6290351 | Retaining Ring | 1 |
| 70 | 6290352 | Cylinder cover | 1 |
| 71 | 6290353 | Threaded Rod..... | 4 |
| 72 | 6290354 | Cylinder Screw..... | 4 |
| 73 | 6290453 | Cylinder Ring..... | 1 |
| 74 | 6290465 | Lock Nut, 30mm, L.H. | 1 |
| 75 | 6062032 | Bearing..... | 1 |
| 76 | TS-0720081 | Lock Washer..... | 1 |
| 77 | 6290495 | Pulley Bushing..... | 1 |
| 79 | 6288611 | Limit Switch | 2 |
| 80 | 6288612 | Limit Switch Lever | 2 |
| 81 | 6290399 | Limit Switch Bracket | 2 |
| 82 | 6290398 | Limit Switch Screw..... | 4 |
| 83 | 6290401 | Limit Switch Hex Head Screw..... | 3 |
| 84 | 6290400 | Limit Switch Lock Washer..... | 3 |
| 85 | 6288611 | Limit Switch | 1 |
| 86 | 6290496 | Limit Switch Bracket (L type) | 1 |
| 87 | 6290832 | Phillips Pan Head Machine Screw, M5 x 8 | 2 |
| | * 6288600 | Platen & Felt (Items no. 54 & 55 ordered as a unit) | 1 |

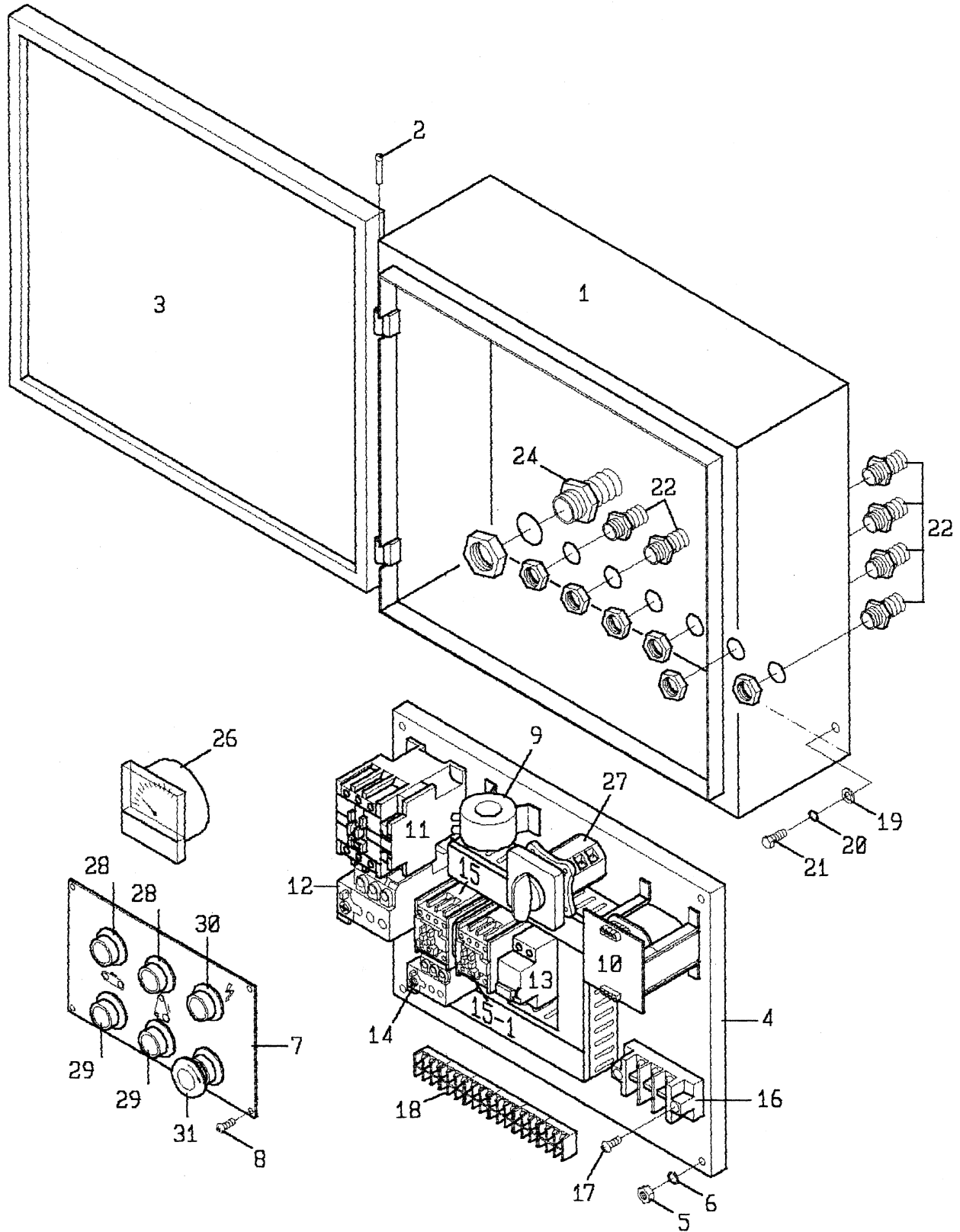
Platen Assembly (RB-25)



PARTS LIST: Electrical Box (RB-25)

| No. | Part No. | Description | Quantity |
|------|------------|--|----------|
| 1 | 6290390 | Electrical Box..... | 1 |
| 2 | 6290454 | Door Pin | 2 |
| 3 | 6290497 | Electrical Box Door | 1 |
| 4 | 6290429 | Electrical Box Base Plate..... | 1 |
| 5 | TS-0570011 | Hex Nut, 1/4-20 UNC | 4 |
| 6 | 6290391 | Power Cabinet Washer | 8 |
| 7 | 6290425 | Operation Nameplate..... | 1 |
| 8 | 6290389 | Nameplate Screw | 4 |
| 9 | 6290431 | Transformer..... | 1 |
| 10 | 6290435 | Transformer..... | 1 |
| 11 | 6290462 | Contactor, 10HP, 3Ph (for RB-25)..... | 1 |
| | 6288736 | Contactor, 15HP, 1Ph (for RB-25-1 & RB-37) | 1 |
| 12 | 6290463 | Overload Relay 35-50 Amp (for RB-25-1 & RB-37) | 1 |
| | 6290430 | Overload Relay, 3Ph (for RB-25) | 1 |
| 13 | 6294536 | Circuit Breaker, C-35 | 1 |
| 14 | 6290457 | Overload Relay, 3Ph (for RB-25) | 1 |
| | 6290481 | Overload Relay, 1Ph (for RB-25-1 & RB-37) | 1 |
| 15 | 6290432 | Overload Relay 1 HP 460V..... | 1 |
| 15-1 | 6290433 | Magnetic Contactor..... | 1 |
| 16 | 6290436 | Terminal Board..... | 1 |
| 17 | 6290441 | Base Plate Hex Head Screw..... | 4 |
| 18 | 6290437 | Terminal Board..... | 1 |
| 20 | TS-0720071 | Lock Washer, 1/4..... | 4 |
| 21 | 6290392 | Pan Head Phillips Screw..... | 4 |
| 22 | 6290393 | Strain Relief..... | 6 |
| 24 | 6290394 | Strain Relief..... | 1 |
| 26 | 6288610 | Load Meter 25", 10 HP 230V..... | 1 |
| 27 | 6290464 | Drum Switch, 2-speed 3 Ph..... | 1 |
| 28 | 6290426 | Push Button, Start..... | 2 |
| 29 | 6290498 | Push Button, Stop..... | 2 |
| 30 | 6290427 | Power Lamp | 1 |
| 31 | 6290428 | Emergency Brake Button | 1 |

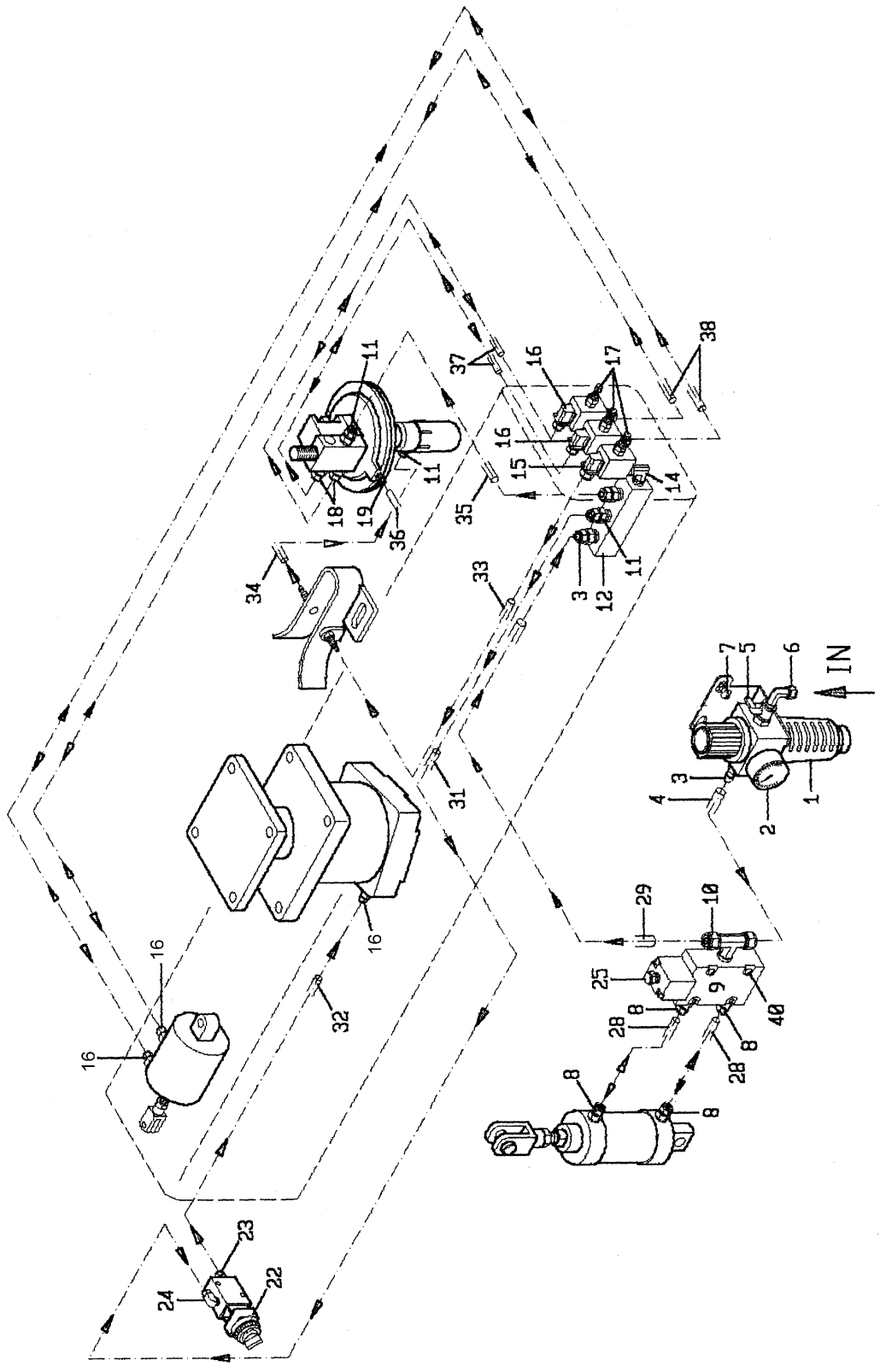
Electrical Box (RB-25)



PARTS LIST: Air Regulator (RB-25)

| No. | Part No. | Description | Quantity |
|-----|------------|---|----------|
| 1 | 6288622 | Filter-Cup | 1 |
| 2 | 6290499 | Pressure Regulator..... | 1 |
| 3 | 6288619 | Large Plastic Connector | 4 |
| 4 | 6288616 | Clear Polyurethane Hose, 8 x 6mm | 1 |
| 5 | 6290812 | Air Switch | 1 |
| 6 | 6290813 | Elbow | 1 |
| 7 | 6290419 | Phillips Pan Head Screw, M6..... | 1 |
| 8 | 6288620 | Medium Plastic Connector..... | 3 |
| 9 | 6290417 | Solenoid Valve | 1 |
| 10 | 6290814 | T-Joint..... | 1 |
| 11 | 6290406 | Small Plastic Connector | 1 |
| 12 | 6290414 | Manifold | 1 |
| 14 | 6290815 | Bronze Elbow | 1 |
| 15 | 6290816 | Plastic Connector | 2 |
| 16 | 6288621 | Small Plastic Connector | 6 |
| 17 | 6288614 | Air Valve | 1 |
| 18 | 6290817 | Plastic Connector | 2 |
| 19 | 6294562 | Bronze Connector..... | 1 |
| 20 | 6290397 | Tension Switch..... | 1 |
| 24 | 6290818 | Plastic Connector | 1 |
| 25 | 6290396 | Silencer | 1 |
| 28 | 6290819 | Flexible Hose, \varnothing 6mm x 6"..... | 2 |
| 29 | 6290820 | Flexible Hose, \varnothing 8mm x 32" | 1 |
| 31 | 6290821 | Flexible Hose, \varnothing 6mm x 40" | 1 |
| 32 | 6290823 | Flexible Hose, \varnothing 6mm x 18" | 1 |
| 33 | 6288618 | Medium Polyurethane Hose, \varnothing 6mm x 4..... | 1 |
| 34 | 6290825 | Flexible Hose, \varnothing 6mm x 11" | 1 |
| 35 | 6290826 | Flexible Hose, \varnothing 6mm x 22" | 1 |
| 36 | 6290827 | Flexible Hose, \varnothing 4mm x 14" | 1 |
| 37 | 6290828 | Flexible Hose, \varnothing 4mm x 20" | 1 |
| 38 | 6290829 | Flexible Hose, \varnothing 4mm x 35" | 2 |
| 40 | TS-081B072 | Phillips Pan Head Machine Screw, #8-32UNC x 1-1/4 | 2 |

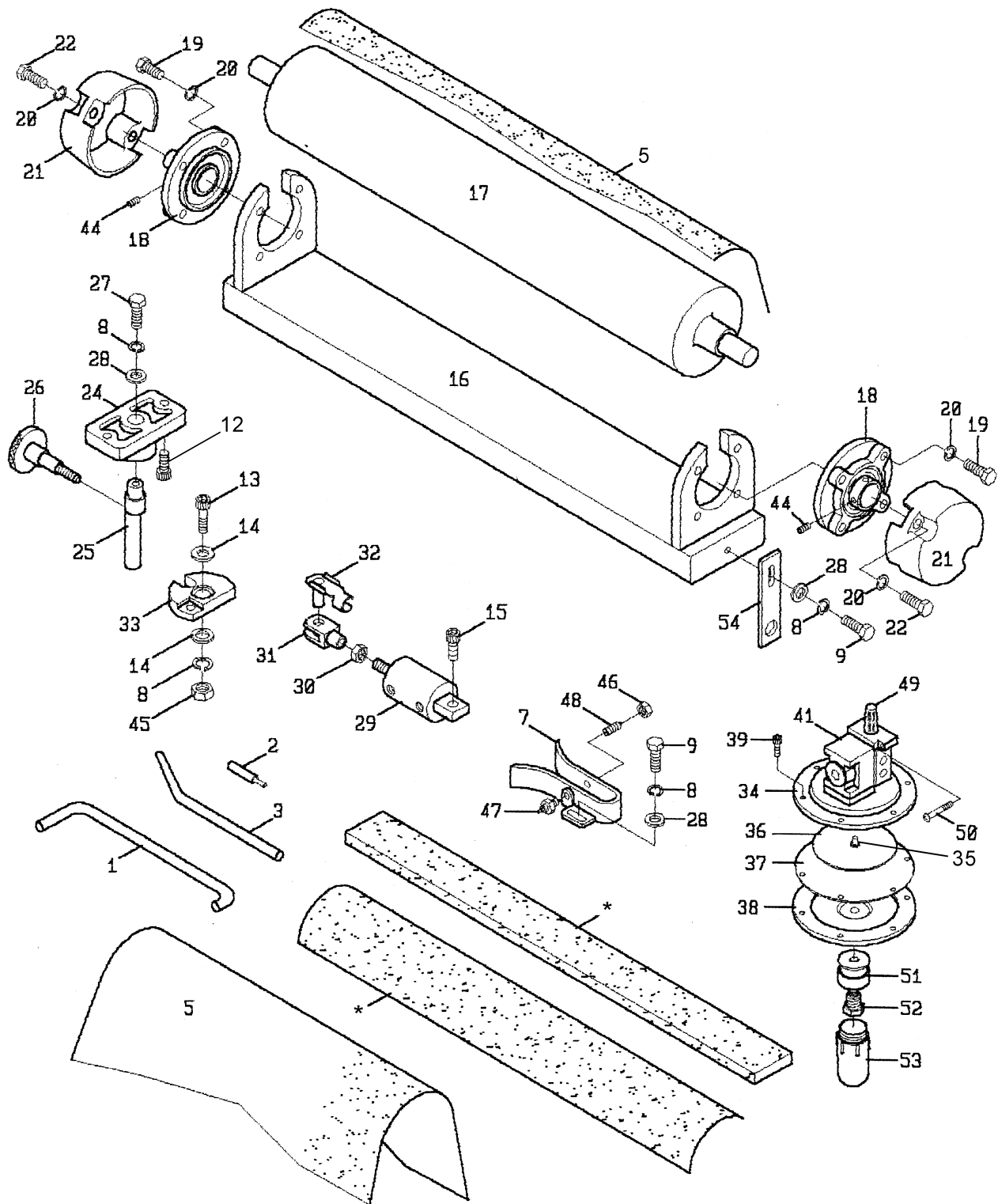
Air Regulator (RB-25)



PARTS LIST: Tension Roller Assembly (RB-37)

| No. | Part No. | Description | Quantity |
|-----|------------|---|----------|
| 1 | 6290281 | Graphite Hook..... | 1 |
| 2 | 6290282 | Switch Adjustment Rod..... | 2 |
| 3 | 6290283 | Roller Adjustment Rod..... | 1 |
| 5 | 6288724 | Sanding Belt, 37 x 60, 100 Grit..... | 1 |
| | 6288725 | Sanding Belt, 37 x 60, 80 Grit..... | 1 |
| | 6288738 | Sanding Belt, 37 x 60, 60 Grit..... | 1 |
| | 6288739 | Sanding Belt, 37 x 60, 120 Grit..... | 1 |
| 7 | 6290355 | Air Jet Eye Mounting Base..... | 1 |
| 8 | 6290356 | Lock Washer..... | 1 |
| 9 | 6290357 | Hex Cap Screw..... | 1 |
| 12 | 6290360 | Socket Head Cap Screw (shaft block)..... | 2 |
| 13 | 6290361 | Socket Head Cap Screw, (micro block)..... | 1 |
| 14 | 6290362 | Micro Block Copper Plate..... | 2 |
| 15 | 6290363 | Socket Head Cap Screw..... | 1 |
| 16 | 6288731 | Tension Roller Frame..... | 1 |
| 17 | 6288732 | Tension Roller..... | 1 |
| 18 | 6290366 | Upper Roller Bearing..... | 2 |
| 19 | 6290367 | Hex Head Screw..... | 4 |
| 20 | 6290368 | Lock Washer..... | 4 |
| 21 | 6290369 | End Cap..... | 2 |
| 22 | 6290370 | Hex Cap Screw..... | 4 |
| 24 | 6290372 | Shaft Block..... | 1 |
| 25 | 6290373 | Shaft..... | 1 |
| 26 | 6290374 | Oscillation Adjusting Knob..... | 1 |
| 27 | 6290375 | Hex Head Screw..... | 1 |
| 28 | 6290376 | Plain Washer..... | 1 |
| 29 | 6290377 | Cylinder, #50-4..... | 1 |
| 30 | 6290378 | Hex Nut..... | 1 |
| 31 | 6290379 | Clevis..... | 1 |
| 32 | 6290380 | Clevis Pin..... | 1 |
| 33 | 6290381 | Micro block..... | 1 |
| 34 | 6290384 | Aluminum Plate..... | 1 |
| 35 | 6290382 | Copper Shaft..... | 1 |
| 36 | 6290383 | Aluminum Plate..... | 1 |
| 37 | 6290385 | Plate..... | 1 |
| 38 | 6290386 | Aluminum Plate..... | 1 |
| 39 | 6290387 | Aluminum Plate Screw..... | 6 |
| 41 | 6290445 | Pressure Valve..... | 1 |
| | 6290466 | Diaphragm-Operated Valve Assembly (Items no. 10, 11, 34 thru 41)..... | 1 |
| 44 | TS-1523011 | Socket Set Screw, M6 x 6..... | 1 |
| 45 | 6290483 | Hex Nut, 1/2-12 UNC..... | 1 |
| 46 | TS-0561032 | Hex Nut, 3/8-24 UNF..... | 1 |
| 47 | 6290484 | Air Sensor Nozzle (male)..... | 1 |
| 48 | 6290485 | Air Sensor Nozzle (female)..... | 1 |
| 49 | 6290405 | Silencer..... | 1 |
| 50 | TS-081C062 | Phillips Round Head Machine Screw, #10-24 x 1..... | 1 |
| 51 | 6290407 | Air Cup Connector..... | 1 |
| 52 | 6290486 | Air Cup Shaft..... | 1 |
| 53 | 6288615 | Air Cup..... | 1 |
| 54 | 6290487 | Power Off Plate..... | 1 |

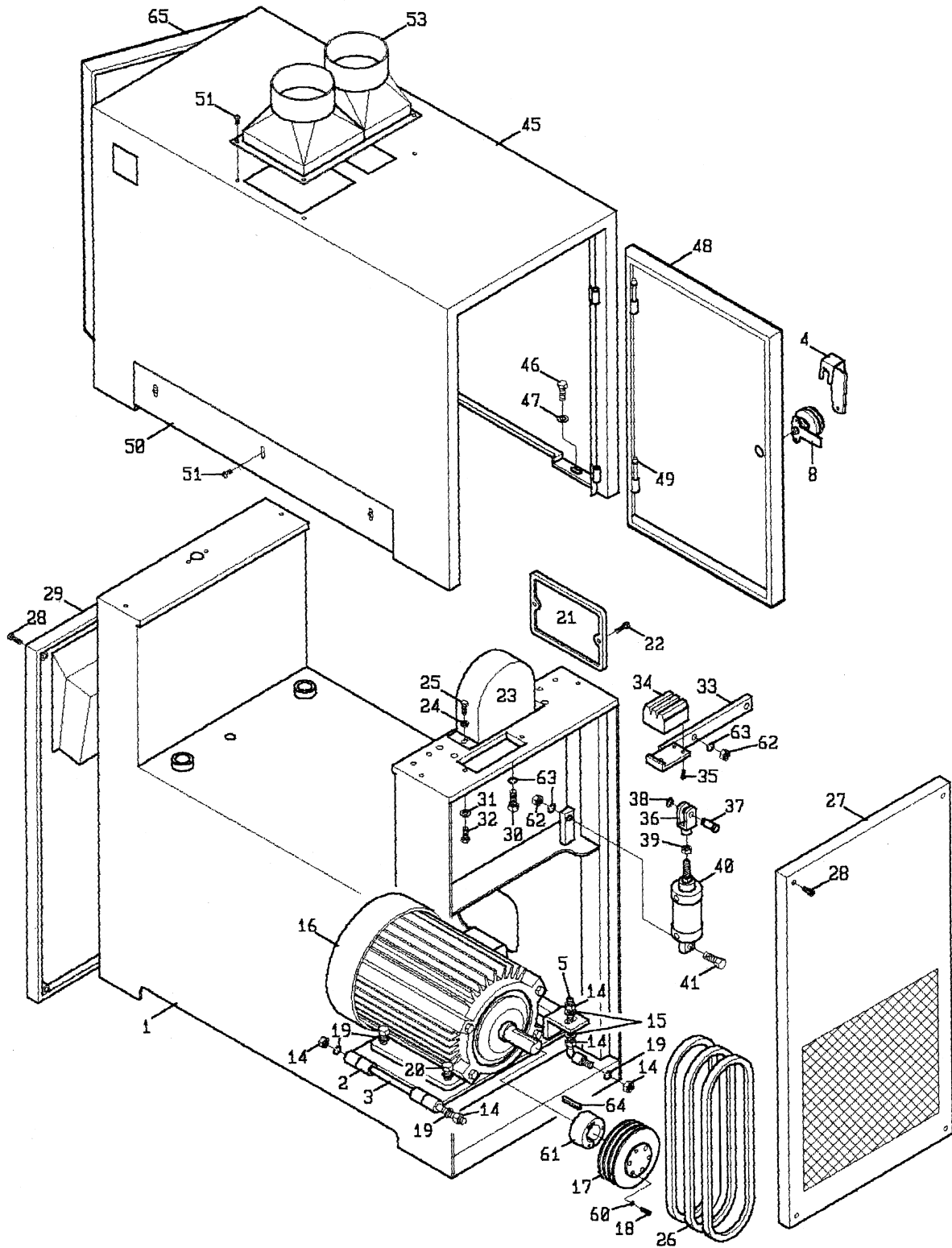
Tension Roller Assembly (RB-37)



PARTS LIST: Cabinet & Motor Assembly (RB-37)

| No. | Part No. | Description | Quantity |
|-----|------------|---------------------------------------|----------|
| 1 | 6288710 | Machine Base | 1 |
| 2 | 6288711 | Motor Base | 1 |
| 3 | 6288627 | Motor Base Plate Pin | 1 |
| 4 | 6290284 | Door Lock Handle | 2 |
| 5 | 6288629 | Motor Tension Adjusting Screw | 1 |
| 8 | 6290488 | Door Latch Assembly | 2 |
| 14 | 6288628 | Hex Nut, 1/2 | 5 |
| 15 | 6288631 | Plain Washer, 1/2 | 2 |
| 16 | 6288712 | Motor, 15 HP, 3 Ph (RB-37) | 1 |
| 17 | 6288734 | Motor Pulley, (3 groove) | 1 |
| 18 | 6288634 | Pulley Screw | 1 |
| 19 | 6288630 | Lock Washer, 1/2 | 5 |
| 20 | 6288635 | Hex Cap Screw, 1/2 | 4 |
| 21 | 6288636 | Motor Access Cover | 1 |
| 22 | 6288637 | Cover Screw | 2 |
| 23 | 6288638 | Pulley Cover | 1 |
| 24 | 6288639 | Washer | 2 |
| 25 | 6288640 | Phillips Round Head Screw | 2 |
| 26 | 6288641 | V-Belt | 3 |
| 27 | 6288642 | Right Ventilating Plate | 1 |
| 28 | 6288643 | Socket Head Cap Screw | 8 |
| 29 | 6288644 | Left Plate | 1 |
| 30 | 6288645 | Bearing Base Screw | 4 |
| 31 | 6288646 | Washer | 4 |
| 32 | 6288647 | Bearing Base Screw | 4 |
| 33 | 6288648 | Brake Arm | 1 |
| 34 | RB37-234 | Brake Pad (RB-37) | 1 |
| 35 | 6288650 | Brake Pad Screw | 3 |
| 36 | 6288651 | Clevis | 1 |
| 37 | 6288652 | Clevis Pin | 1 |
| 38 | 6288653 | Retaining Ring | 1 |
| 39 | 6288654 | Cylinder Nut | 1 |
| 40 | 6288655 | Cylinder, 50-25 | 1 |
| 41 | 6288656 | Cylinder Screw | 1 |
| 45 | 6288713 | Upper Cabinet | 1 |
| 46 | 6288665 | Hex Cap Screw | 4 |
| 47 | 6288666 | Lock Washer (for Upper Cabinet) | 4 |
| 48 | 6288709 | Upper Cabinet Door (Right) | 1 |
| 49 | 6288667 | Upper Door Pin | 4 |
| 50 | 6288714 | Front Protection Plate | 1 |
| 51 | 6288669 | Front Protection Plate Screw | 4 |
| 53 | 6288715 | Dust Hood | 1 |
| 60 | 6290461 | Lock Washer | 1 |
| 61 | 6290460 | Pulley Bushing | 1 |
| 62 | TS-0561031 | Hex Nut, 3/8-16 UNC | 1 |
| 63 | TS-0720091 | Lock Washer, 3/8 | 1 |
| 64 | 6290490 | Key, 12 x 8 x 80mm | 1 |
| 65 | 6290491 | Upper Cabinet Door (Left) | 1 |

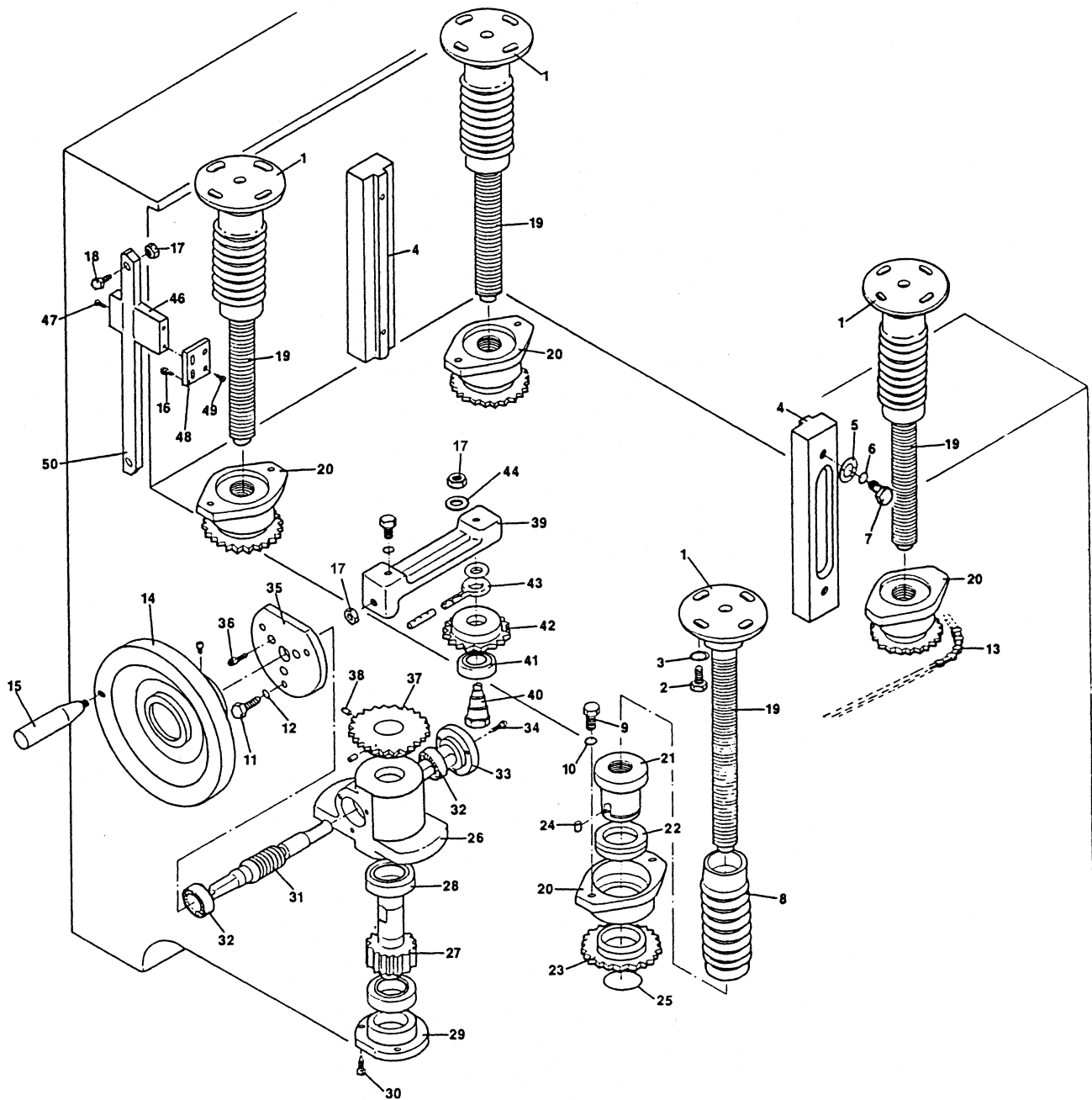
Cabinet & Motor Assembly (RB-37)



PARTS LIST: Table Raising Assembly (RB-37)

| No. | Part No. | Description | Quantity |
|-----|------------|--|----------|
| 1 | 6288672 | Lifting Rod Head | 4 |
| 2 | 6288673 | Lifting Rod Screw | 8 |
| 3 | 6288674 | Lifting Rod Washer | 8 |
| 4 | 6288675 | Slide Ways | 2 |
| 5 | 6288676 | Plain Washer | 4 |
| 6 | 6288677 | Lock Washer | 4 |
| 7 | 6288678 | Hex Head Screw | 4 |
| 8 | 6288679 | Lifting Rod Protection Tube | 4 |
| 9 | 6288680 | Hex Head Screw | 8 |
| 10 | 6288681 | Lock Washer | 8 |
| 11 | 6288682 | Hex Head Screw | 3 |
| 12 | 6288683 | Lock Washer | 3 |
| 13 | 6288716 | Chain | 1 |
| 14 | 6288685 | Handwheel | 1 |
| 15 | 6288686 | Handwheel Handle | 1 |
| 16 | 6288687 | Base Block Screw | 2 |
| 17 | 6288688 | Hex Nut, 3/8 | 3 |
| 18 | 6288689 | Scale Screw | 2 |
| 19 | 6288690 | Lifting Rod | 4 |
| 20 | 6288691 | Lifting Rod Base | 4 |
| 21 | 6288692 | Lifting Rod Screw | 4 |
| 22 | 6288693 | Fixing Ring | 4 |
| 23 | 6288694 | Chain Gear | 4 |
| 25 | 6288696 | Retaining Ring | 4 |
| 26 | 6288697 | Gearbox | 1 |
| 27 | 6288698 | Worm Gear | 1 |
| 28 | 6288699 | Bearing | 2 |
| 29 | 6290200 | Gearbox Cover | 1 |
| 30 | 6290201 | Gearbox Screw | 3 |
| 31 | 6290202 | Worm Rod | 1 |
| 32 | 6290203 | Bearing | 2 |
| 33 | 6290204 | Gearbox Cover | 1 |
| 34 | 6290205 | Gearbox Screw | 3 |
| 35 | 6290206 | Gearbox Cover Base | 1 |
| 36 | 6290207 | Gearbox Cover Screw | 3 |
| 37 | 6290208 | Chain Gear | 1 |
| 38 | 6290209 | Chain Gear Screw | 2 |
| 39 | 6290210 | Chain Adjusting Base | 1 |
| 40 | 6290211 | Chain Gear Adjusting Shaft | 1 |
| 41 | 6290212 | Bearing | 1 |
| 42 | 6290213 | Chain Gear | 1 |
| 43 | 6290214 | Chain Adjusting Screw | 1 |
| 44 | 6290215 | Plain Washer, 3/8 | 2 |
| 46 | 6290216 | Scale Base | 1 |
| 48 | 6290218 | Scale Base Mounting Block | 1 |
| 49 | 6290219 | Scale Base Screw | 2 |
| 50 | 6290220 | Scale | 1 |
| | 6290455 | Gear Box Assembly (Items 26 thru 36) | 1 |
| 51 | TS-0680021 | Flat Washer, 1/4 | 1 |
| 52 | 6290831 | Hex Nut, 3/16-16 UNC | 2 |
| 53 | 6290492 | Key, 4 x 4 x 20mm | 1 |
| 54 | 6290493 | Key, 5/16" x 5/16" x 20mm | 1 |

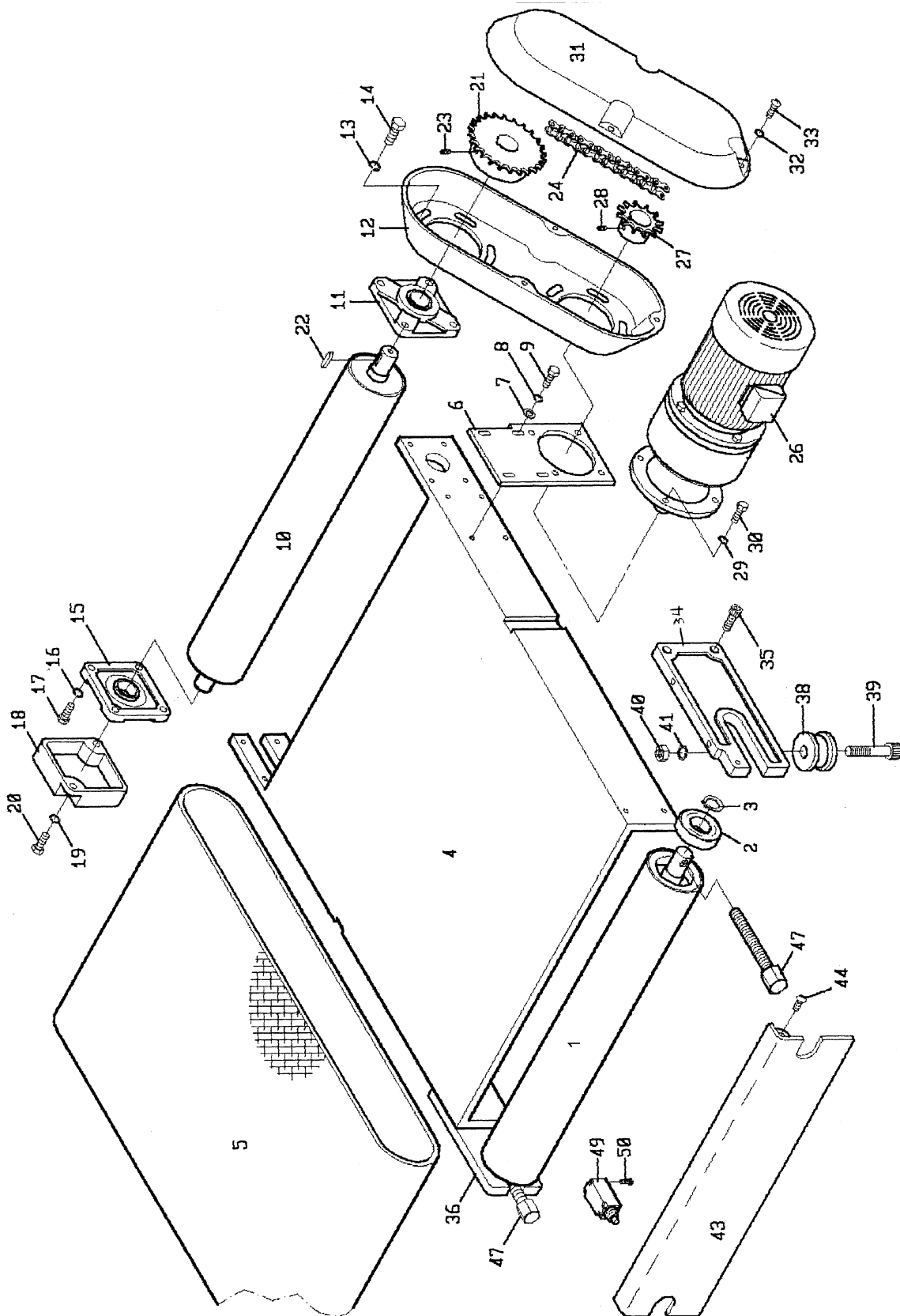
Table Raising Assembly (RB-37)



PARTS LIST: Table & Conveyor Belt Assembly (RB-37)

| No. | Part No. | Description | Quantity |
|-----|------------|--|----------|
| 1 | 6290833 | Front Conveyor Roller | 1 |
| 2 | 6290263 | Bearing..... | 2 |
| 3 | 6290264 | Retaining Ring..... | 2 |
| 4 | 6288717 | Conveyor Table..... | 1 |
| 5 | 6288706 | Conveyor Belt 37" | 1 |
| 6 | 6288718 | Gearbox Base | 1 |
| 7 | 6290223 | Plain Washer..... | 4 |
| 8 | 6290224 | Lock Washer | 4 |
| 9 | 6290225 | Hex Cap Screw | 4 |
| 10 | 6288719 | Back Conveyor Roller..... | 1 |
| 11 | 6290227 | Bearing..... | 1 |
| 12 | 6290228 | Chain Gear Cover Base | 1 |
| 13 | 6290229 | Lock Washer | 4 |
| 14 | 6290230 | Hex Cap Screw | 4 |
| 15 | 6290231 | Bearing..... | 1 |
| 16 | 6290232 | Lock Washer | 2 |
| 17 | 6290233 | Hex Head Screw | 2 |
| 18 | 6290234 | Bearing Cover | 1 |
| 19 | 6290235 | Lock Washer | 2 |
| 20 | 6290236 | Hex Cap Screw | 2 |
| 21 | 6290237 | Chain Gear..... | 1 |
| 22 | 6290238 | Key..... | 1 |
| 23 | 6290239 | Chain Gear Set Screw..... | 2 |
| 24 | 6290240 | Chain, 5/8..... | 1 |
| 26 | 6290473 | Motor & Gear box, 15HP, 3Ph, 460V, 2-speed (RB-37) | 1 |
| | 6290475 | Motor & Gear box, 15HP, 3Ph, 230V, 2-speed (RB-37) | 1 |
| 27 | 6290243 | Chain Gear..... | 1 |
| 28 | 6290244 | Chain Gear Set Screw..... | 2 |
| 29 | 6290245 | Lock Washer | 4 |
| 30 | 6290246 | Hex Head Screw | 4 |
| 31 | 6290247 | Upper Chain Gear Cover..... | 1 |
| 32 | 6290248 | Lock Washer | 3 |
| 33 | 6290249 | Phillips Pan Head Screw | 3 |
| 34 | 6290250 | Front Conveyor Roller Take-Up Plate, R.H..... | 1 |
| 35 | 6290251 | Socket Head Cap Screw..... | 4 |
| 36 | 6290252 | Front Conveyor Roller Take-Up Plate, L.H. | 1 |
| 38 | 6290254 | Conveyor Roller (copper) | 2 |
| 39 | 6290255 | Roller Screw..... | 2 |
| 40 | 6290256 | Hex Nut, 5/16 | 2 |
| 41 | 6290443 | Lock Washer | 2 |
| 43 | 6288721 | Safety Guard..... | 1 |
| 44 | 6290259 | Safety Guard Screw | 2 |
| 47 | 6290444 | Conveyor Adjustment Pin..... | 2 |
| 49 | 6290494 | Limit Switch..... | 1 |
| 50 | TS-081C082 | Phillips Round Head Screw, #10-24 x 1-1/2..... | 1 |

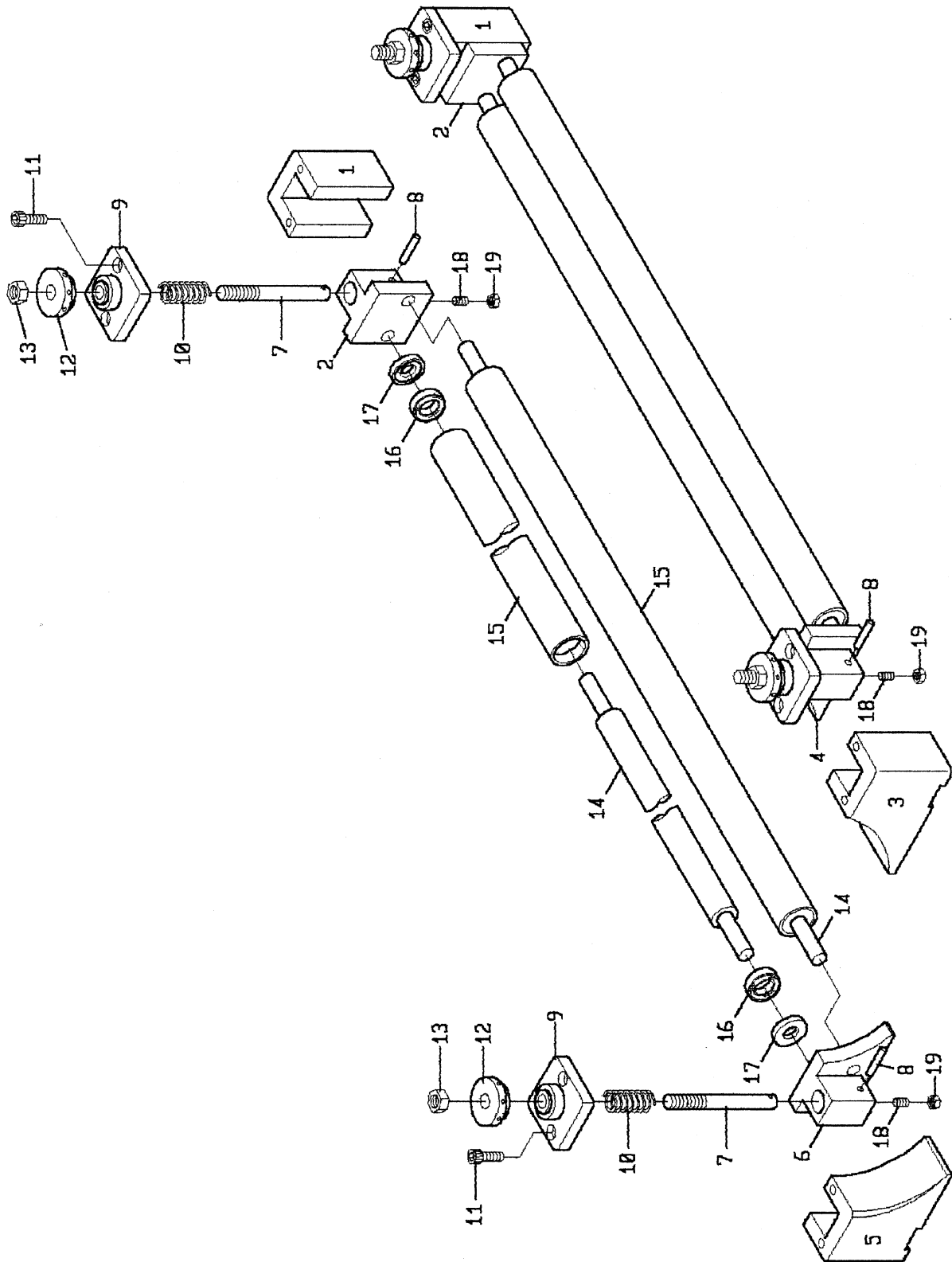
Table & Conveyor Belt Assembly (RB-37)



PARTS LIST: Pressure Bar Assembly (RB-37)

| No. | Part No. | Description | Quantity |
|------------|-----------------|--|-----------------|
| 1 | 6290265 | Roller Slider-female..... | 2 |
| 2 | 6290266 | Roller Slider-male..... | 2 |
| 3 | 6290267 | Front Roller Slider-female | 1 |
| 4 | 6290268 | Front Roller Slider-male | 1 |
| 5 | 6290269 | Back Roller Slider-female..... | 1 |
| 6 | 6290270 | Back Roller Slider-male..... | 1 |
| 7 | 6290271 | Roller Adjustment Rod..... | 4 |
| 8 | 6290272 | Spring Pin | 4 |
| 9 | 6290273 | Roller Slider Cover | 4 |
| 10 | 6290274 | Spring | 4 |
| 11 | 6290275 | Roller Slider Cover Screw | 8 |
| 12 | 6290276 | Roller Adjustment Knob..... | 4 |
| 13 | 6288688 | Hex Nut, 3/8..... | 4 |
| | 6290480 | Pressure Bar Assembly (Items 14-17)..... | 1 |
| 14 | 6288705 | Pressure Bar Shaft | 4 |
| 15 | 6288723 | Pressure Bar Cover | 4 |
| 16 | 6290279 | Bearing..... | 8 |
| 17 | 6290280 | Bearing Cover | 8 |
| 18 | TS-0267071 | Socket Set Screw, 1/4 x 3/4..... | 8 |
| 19 | TS-0570011 | Hex Nut, 1/4-20 UNC..... | 8 |

Pressure Bar Assembly (RB-37)



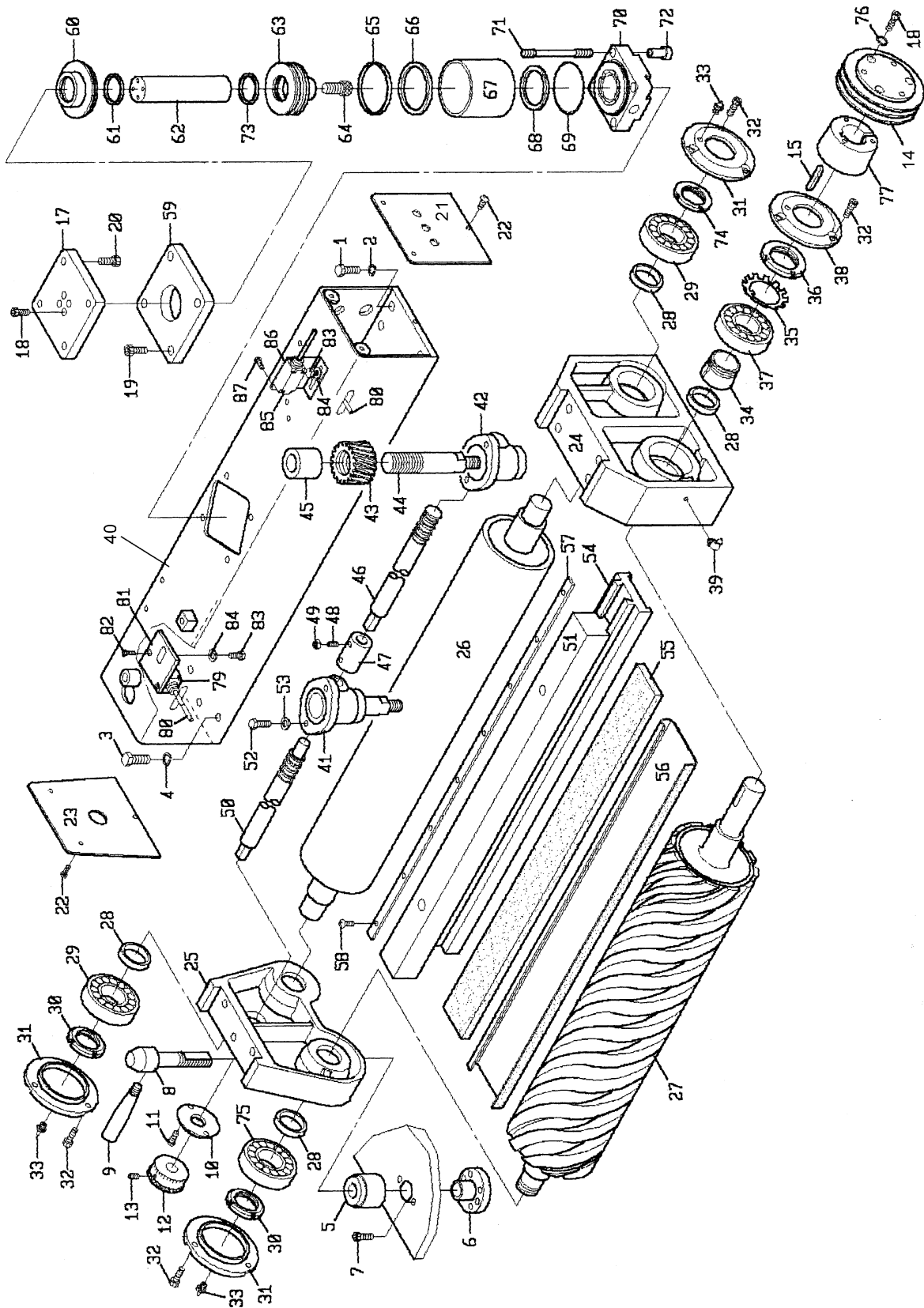
PARTS LIST: Platen Assembly (RB-37)

| No. | Part No. | Description | Quantity |
|-----|----------|--------------------------------------|----------|
| 1 | 6290287 | Hex Head Mounting Frame Screw | 4 |
| 2 | 6290288 | Mounting Frame Washer | 4 |
| 3 | 6290289 | Hex Head Mounting Frame Screw | 2 |
| 4 | 6290290 | Mounting Frame Washer | 2 |
| 5 | 6290291 | Diaphragm | 1 |
| 6 | 6290468 | Adjustable Knob..... | 1 |
| 7 | 6290293 | Adjustable Knob Screw | 2 |
| 8 | 6290294 | Screw Rod | 1 |
| 9 | 6290295 | Platen Lock Lever | 1 |
| 10 | 6290296 | Scale Ring Base | 1 |
| 11 | 6290297 | Scale Ring Base Screw..... | 2 |
| 12 | 6290298 | Scale Ring | 1 |
| 13 | 6290299 | Scale Ring Set Screw | 1 |
| 14 | 6288737 | Roller Pulley | 1 |
| 15 | 6290301 | Key | 1 |
| 17 | 6290303 | Mounting Block, 80-40 cylinder | 1 |
| 18 | 6290304 | Mounting Block Screw | 4 |
| 19 | 6290305 | Cylinder Mounting Block Screw..... | 4 |
| 20 | 6290306 | Frame Support Screw | 4 |
| 21 | 6290307 | Platen Seal, R.H. | 1 |
| 22 | 6290308 | Seal Plate Screw | 6 |
| 23 | 6290309 | Seal Platen, L.H..... | 1 |
| 24 | 6290310 | Bearing Base | 1 |
| 25 | 6290311 | Bearing Frame..... | 1 |
| 26 | 6288705 | Free Roller..... | 1 |
| 27 | 6288704 | Contact Roller..... | 1 |
| 28 | 6290312 | Oil Seal..... | 4 |
| 29 | 6290313 | Bearing | 2 |
| 30 | 6290314 | Lock Nut, 30mm | 2 |
| 31 | 6290315 | Bearing Cover..... | 3 |
| 32 | 6290316 | Socket Head Cap Screw | 12 |
| 33 | 6290317 | Grease Fitting, 1/16 | 3 |
| 34 | 6290318 | Fastening Ring #H307 | 1 |
| 35 | 6290319 | Lock Washer..... | 1 |
| 36 | 6290320 | Lock Nut | 1 |
| 37 | 6290321 | Bearing..... | 1 |
| 38 | 6290322 | Bearing Cover..... | 1 |
| 39 | 6290323 | Grease Fitting..... | 1 |
| 40 | 6288726 | Mounting Frame | 1 |
| 41 | 6290325 | Graphite Base Gearbox, L.H. | 1 |
| 42 | 6290326 | Graphite Base Gearbox, R.H. | 1 |
| 43 | 6290327 | Gear Nut..... | 2 |
| 44 | 6290328 | Platen Bar Adjusting Rod..... | 2 |
| 45 | 6290329 | Bushing | 2 |
| 46 | 6288727 | Worm Gear Rod, R.H. | 1 |
| 47 | 6290331 | Worm Gear Rod Connector | 1 |
| 48 | 6290332 | Worm Gear Rod Connector Screw..... | 2 |
| 49 | 6290333 | Worm Gear Rod Connector Hex Nut..... | 2 |
| 50 | 6290334 | Worm Gear Rod, L.H. | 1 |
| 51 | 6288728 | Sliding Platen-male..... | 1 |
| 52 | 6290336 | Gearbox Screw..... | 4 |
| 53 | 6290337 | Gearbox Lock Washer | 4 |
| 54 | 6288701* | Sliding Platen-female..... | 1 |
| 55 | 6288702* | Felt, 1/2 x 1-3/4 x 25..... | 1 |

PARTS LIST: Platen Assembly (RB-37) continued

| No. | Part No. | Description | Quantity |
|-----|------------|--|----------|
| 56 | 6288703 | Graphite..... | 1 |
| 57 | 6288730 | Bar..... | 1 |
| 58 | 6290340 | Bar Screw..... | 7 |
| 59 | 6290341 | Cylinder Mounting Block..... | 1 |
| 60 | 6290342 | Cylinder Cover..... | 1 |
| 61 | 6290343 | Cylinder Piston Rod..... | 1 |
| 62 | 6290344 | Cylinder Piston Rod..... | 1 |
| 63 | 6290345 | Cylinder Piston..... | 1 |
| 64 | 6290346 | Cylinder Piston Screw..... | 1 |
| 65 | 6290347 | Piston Ring..... | 1 |
| 66 | 6290348 | Piston Ring..... | 1 |
| 67 | 6290349 | Aluminum Tube..... | 1 |
| 68 | 6290350 | O-ring..... | 1 |
| 69 | 6290351 | Retaining Ring..... | 1 |
| 70 | 6290352 | Cylinder cover..... | 1 |
| 71 | 6290353 | Threaded Rod..... | 4 |
| 72 | 6290354 | Cylinder Screw..... | 4 |
| 73 | 6290453 | Cylinder Ring..... | 1 |
| 74 | 6290465 | Lock Nut, 30mm, L.H..... | 1 |
| 75 | 6062032 | Bearing..... | 1 |
| 76 | TS-0720081 | Lock Washer, 5/16..... | 1 |
| 77 | 6290495 | Pulley Bushing..... | 1 |
| 79 | 6288611 | Limit Switch..... | 2 |
| 80 | 6288612 | Limit Switch Lever..... | 2 |
| 81 | 6290399 | Limit Switch Bracket..... | 2 |
| 82 | 6290398 | Limit Switch Screw..... | 4 |
| 83 | 6290401 | Limit Switch Hex Head Screw..... | 3 |
| 84 | 6290400 | Limit Switch Lock Washer..... | 3 |
| 85 | 6288611 | Limit Switch..... | 1 |
| 86 | 6290496 | Limit Switch Bracket (L type)..... | 1 |
| 87 | 6290832 | Phillips Round Machine Head Screw, M5 x 8..... | 2 |
| | *8288700 | Platen & Felt (items no. 54 & 55 ordered as a unit)..... | 1 |

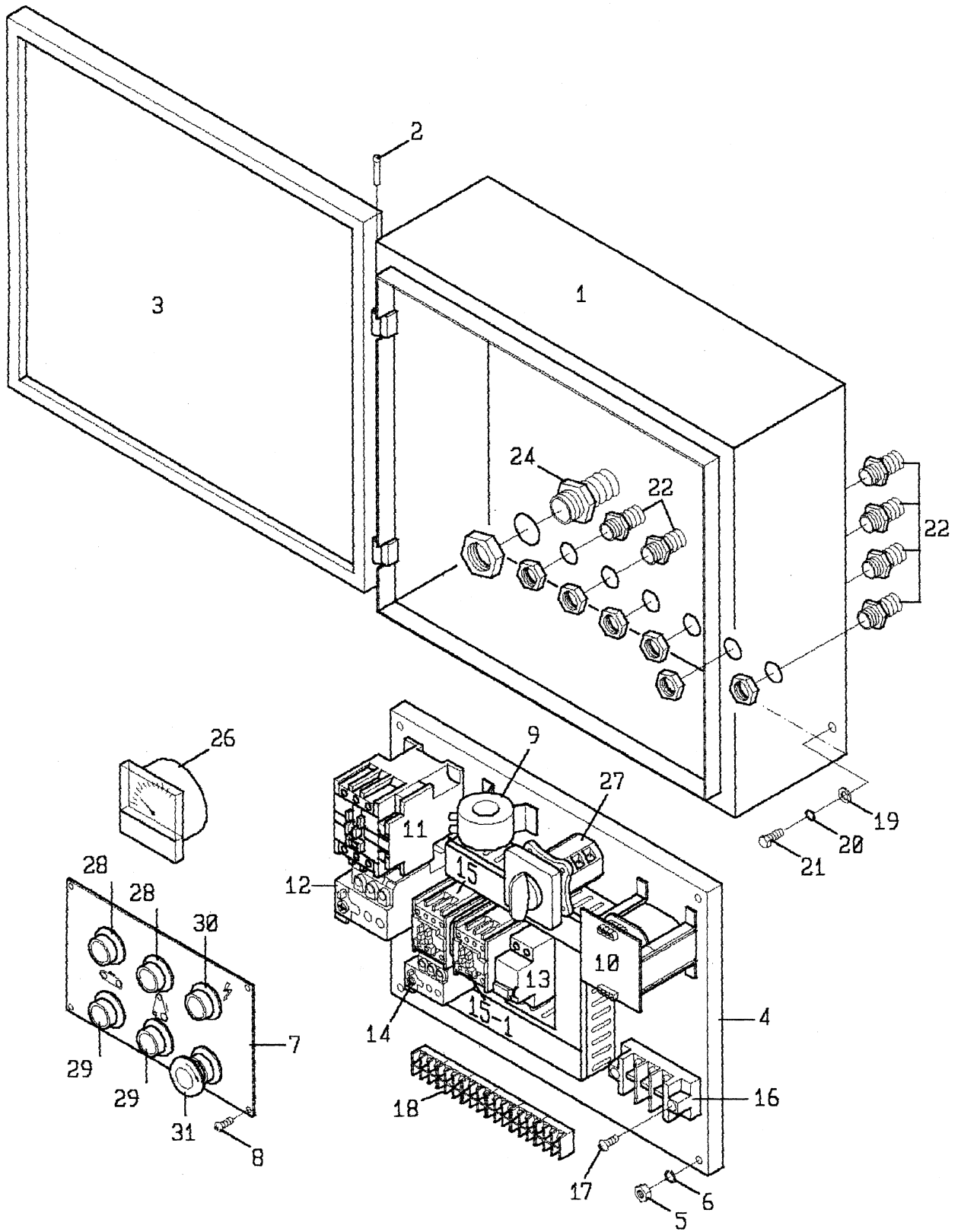
Platen Assembly (RB-37)



PARTS LIST: Electrical Box (RB-37)

| No. | Part No. | Description | Quantity |
|------|------------|---|----------|
| 1 | 6290390 | Electrical Box | 1 |
| 2 | 6290454 | Door Pin | 2 |
| 3 | 6290497 | Electrical Box Door..... | 1 |
| 4 | 6290429 | Electrical Box Base Plate | 1 |
| 5 | TS-0570011 | Hex Nut, 1/4-20 UNC | 4 |
| 6 | 6290391 | Power Cabinet Washer..... | 8 |
| 7 | 6290425 | Operation Nameplate | 1 |
| 8 | 6290389 | Nameplate Screw..... | 4 |
| 9 | 6290431 | Transformer | 1 |
| 10 | 6290435 | Transformer | 1 |
| 11 | 6288736 | Contact, 15HP, 1Ph, 50 Amp (for RB-25-1 & RB-37)..... | 1 |
| 12 | 6290463 | Overload Relay, 35-50 Amp (for RB-25-1 & RB-37)..... | 1 |
| 13 | 6294536 | Circuit Breaker, C-35..... | 1 |
| 14 | 6290457 | Overload Relay, 3Ph | 1 |
| 15 | 6290432 | Overload Relay 1 HP 460V | 1 |
| 15-1 | 6290433 | Magnetic Contactor | 1 |
| 16 | 6290436 | Terminal Board | 1 |
| 17 | 6290441 | Base Plate Hex Head Screw..... | 4 |
| 18 | 6290437 | Terminal Board | 1 |
| 20 | TS-0720071 | Lock Washer, 1/4 | 4 |
| 21 | 6290392 | Pan Head Phillips Screw | 4 |
| 22 | 6290393 | Strain Relief | 6 |
| 24 | 6290394 | Strain Relief | 1 |
| 26 | 6288707 | Load Meter 37", 15 HP 230V | 1 |
| 27 | 6290464 | Drum Switch, 2-speed 3 Ph | 1 |
| 28 | 6290426 | Push Button, Start | 1 |
| 29 | 6290498 | Push Button, Stop | 1 |
| 30 | 6290427 | Power Lamp..... | 1 |
| 31 | 6290428 | Emergency Brake Button..... | 1 |

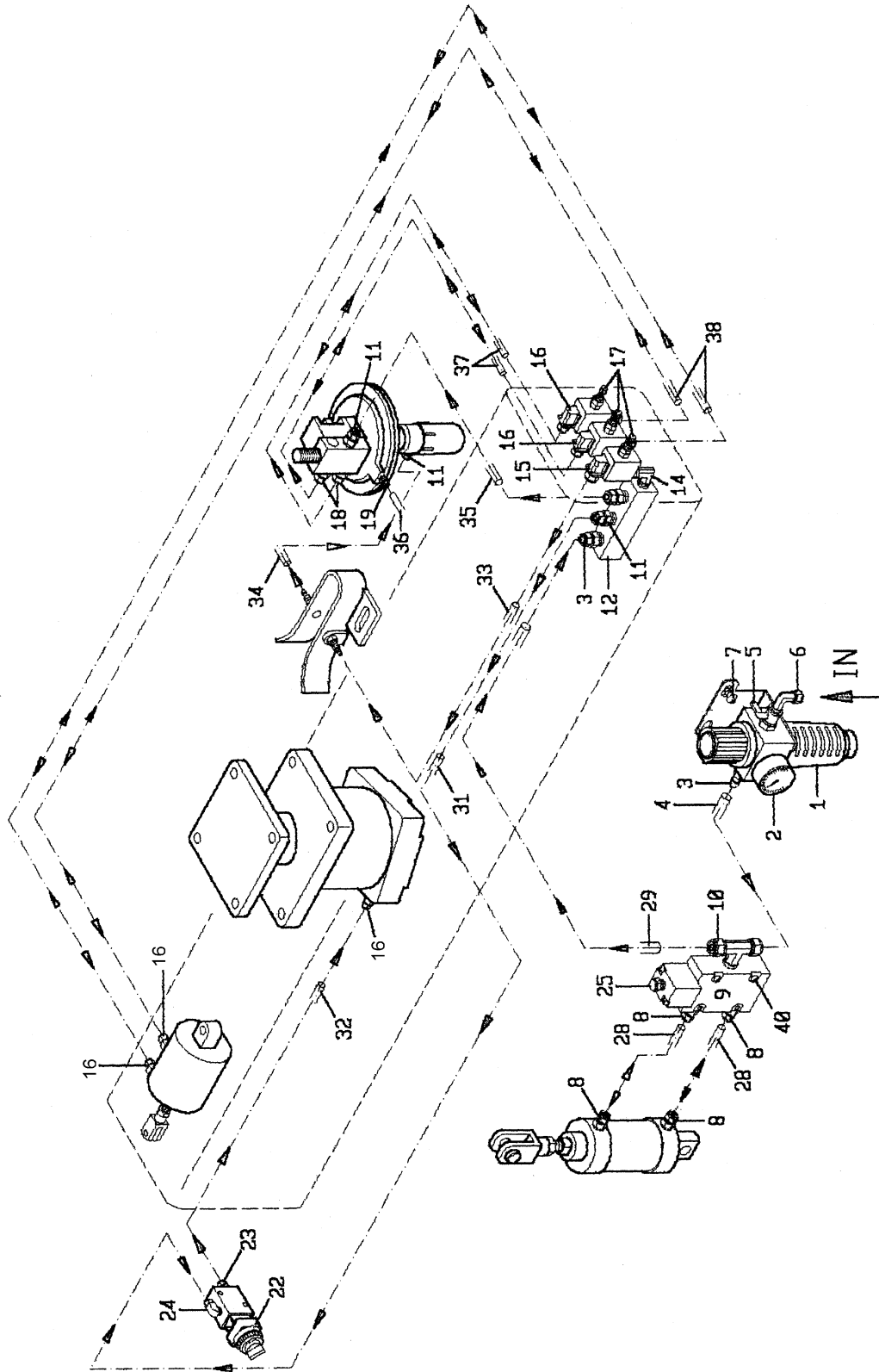
Electrical Box (RB-37)



PARTS LIST: Air Regulator (RB-37)

| No. | Part No. | Description | Quantity |
|-----|------------|---|----------|
| 1 | 6288622 | Filter-Cup | 1 |
| 2 | 6290499 | Pressure Regulator..... | 1 |
| 3 | 6288619 | Large Plastic Air Connector | 4 |
| 4 | 6288616 | Clear Polyurethane Hose, 8 x 6mm | 1 |
| 5 | 6290812 | Air Switch..... | 1 |
| 6 | 6290813 | Elbow | 1 |
| 7 | 6290419 | Phillips Pan Head Screw, M6 | 1 |
| 8 | 6288620 | Medium Plastic Connector..... | 3 |
| 9 | 6290417 | Solenoid Valve | 1 |
| 10 | 6290814 | T-Joint..... | 1 |
| 11 | 6290406 | Small Plastic Connector | 1 |
| 12 | 6290414 | Manifold | 1 |
| 14 | 6290815 | Bronze Elbow | 1 |
| 15 | 6290816 | Plastic Connector | 2 |
| 16 | 6288621 | Small Plastic Connector | 6 |
| 17 | 6288614 | Air Valve | 1 |
| 18 | 6290817 | Plastic Connector | 2 |
| 19 | 6294562 | Bronze Connector | 1 |
| 20 | 6290397 | Tension Switch..... | 1 |
| 24 | 6290818 | Plastic Connector | 1 |
| 25 | 6290396 | Silencer..... | 1 |
| 28 | 6290819 | Flexible Hose, \varnothing 6mm x 6" | 2 |
| 29 | 6290820 | Flexible Hose, \varnothing 8mm x 32" | 1 |
| 31 | 6290822 | Flexible Hose, \varnothing 6mm x 56" | 1 |
| 32 | 6290824 | Flexible Hose, \varnothing 6mm x 25" | 1 |
| 33 | 6288618 | Medium Polyurethane Hose, \varnothing 6mm x 4..... | 1 |
| 34 | 6290825 | Flexible Hose, \varnothing 6mm x 11" | 1 |
| 35 | 6290826 | Flexible Hose, \varnothing 6mm x 22" | 1 |
| 36 | 6290827 | Flexible Hose, \varnothing 4mm x 14" | 1 |
| 37 | 6290828 | Flexible Hose, \varnothing 4mm x 20" | 1 |
| 38 | 6290830 | Flexible Hose, \varnothing 4mm x 47" | 2 |
| 40 | TS-081B072 | Phillips Pan Head Machine Screw, #8-32UNC x 1-1/4 | 2 |

Air Regulator (RB-37)



POWERMATIC[®]

WMH Tool Group
2420 Vantage Drive
Elgin, Illinois 60123
Phone: 800-274-6848
www.wmhtoolgroup.com