

PROMAC[®]

Operating Instructions Belt Sander Model 331C/331Y

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This machine complies with the European Directives

CE-Conformity Declaration
CE-Konformitätserklärung
Déclaration de Conformité CE

Product / Produkt / Produit:

Sander
Bandschleifmaschine
Touret à bande
331C / 331Y

Brand / Marke / Marque:

PROMAC

Manufacturer / Hersteller / Fabricant:
JPW (Tool) AG, Tämperlistrasse 5, CH-8117 Fällanden
Schweiz / Suisse / Switzerland

We hereby declare that this product complies with the regulations
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

2006/42/EC

Machinery Directive
Maschinenrichtlinie
Directive Machines

2014/30/EU

electromagnetic compatibility
elektromagnetische Verträglichkeit
compatibilité électromagnétique

designed in consideration of the standards
und entsprechend folgender zusätzlicher Normen entwickelt wurde
et été développé dans le respect des normes complémentaires suivantes

EN ISO 12100:2010
EN 61029-1:2009+A11:2010
EN 61029-2-4:2011
EN 61000-6-4:2007
EN 61000-6-2:2005

Responsible for the Documentation / Dokumentations-Verantwortung / Responsabilité de Documentation:

Hansjörg Meier

Head Product-Mgmt. / Leiter Produkt-Mgmt. / Resp. Gestion des Produits
JPW (Tool) AG



2017-10-13 Jan Dätwyler, General Manager

JPW (Tool) AG, Tämperlistrasse 5, CH-8117 Fällanden
Schweiz / Suisse / Switzerland

Safety Instructions

Note: Failure to follow these Safety Instructions can result in serious injury.

As with all machines, there are typical dangers associated with the operation and handling of a Sanding Belt. Careful operation and correct handling of the machine significantly reduce the risk of accidents. However, if normal precautionary measures are disregarded, risks of accident for the operator are unavoidable.

The design of this machine is specific to its intended use. Therefore, we strongly advise against carrying out any modifications of the machine or forcing it to perform tasks for which it has not been designed.

If you have any questions about the use of this machine and if you do not find the appropriate answer in this Instructions Manual, please contact your dealer who will be able to help you.

General safety rules and guidelines for handling machines

1. For your own safety, first read and become familiar with the entire Instructions Manual before operating the machine. Learn the machine's applications, its operating limits, and specific hazards. This Manual gives also information about the risks involved in case of negligence.
2. Keep guards in place and in perfect working order, do not remove them.
3. Always connect the electrical machinery equipped with mains plug with protective contact (earth contact) to a socket with earth contact.
When using adapters without earth contact, connect directly to the earth terminal of the machine. Never start a machine that is not connected to an outlet with ground connection.
4. Before turning the machine ON, remove loose clamping levers or keys from the machine. Systematically make sure that there are no loose parts near the moving elements.
5. Provide sufficient working space around the machine. Cluttered work stations and benches invite accidents.
6. Do not operate the machine in a dangerous environment. Do not use the machine in wet or damp areas and do not expose it to rain. Always keep the work area and workstation well lit.
7. Keep children and visitors away from the machine and at a safe distance from the machine and from the work area.
8. Secure the workshop or workroom against unauthorised access. Fit child safety devices, e.g., door latches, lockable main switches, etc. in order to prevent children from turning on.
9. Do not overload the machine. Its performance will be better and the operation safer if it is operated within the specified ranges without exceeding the capacities for which it has been designed.
10. Do not use the machine to perform tasks for which it is not designed. The machine is exclusively designed for its intended use.
11. Wear appropriate clothing. Do not wear loose clothing, gloves, neckties, rings, necklaces or bracelets and other jewellery that may be caught in moving parts of the machine. Wear non-slip footwear. Wear protective hair covering to contain long hair.
12. Always wear safety glasses and a dust mask, if necessary. Proceed according to the accident prevention regulations.
13. Always secure the workpiece in a vice or clamping device. Holding the workpiece with the hands is risky and it is recommended that both hands remain available for handling the machine.
14. Do not overreach. Keep proper footing and balance at all times.

15. Always keep the machine in good working order. Keep the cutting faces sharp and clean for optimum performance. Follow the instructions for cleaning, lubricating and replacing accessory equipment/tools.
16. Always disconnect the machine from the mains before carrying out any maintenance work or replacing machine parts such as saw blade, drill bits, cutting tools etc.
17. Only use the recommended accessories. Follow the instructions in the User Manual. The use of unsuitable accessories may cause accidents.
18. Prevent any accidental starting. Before connecting the equipment to the mains, always check that the operating switch is in OFF position (O).
19. Never stand on the machine. Any tipping over of the machine or contact with the cutting tool can result in very severe accidents.
20. Check for damaged parts. Damaged guards or parts should be properly repaired or replaced before further operation.
21. Never leave a running machine unattended. Always switch off the mains supply. Do not leave the machine unattended until it has come to a complete standstill.
22. Never operate the machine if you are under the influence of alcohol, medication or drugs.

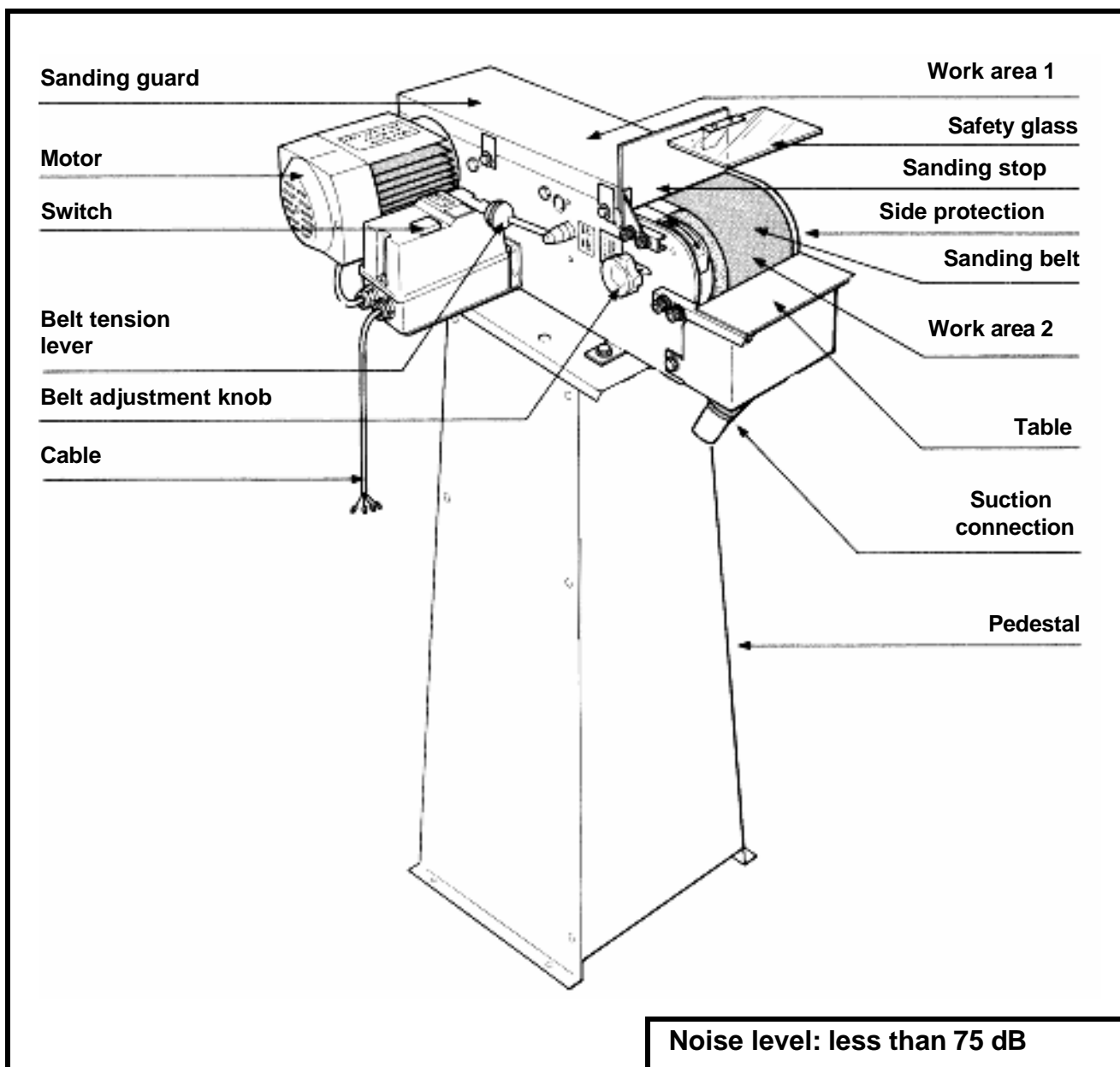


Always wear safety glasses!

Technical Data

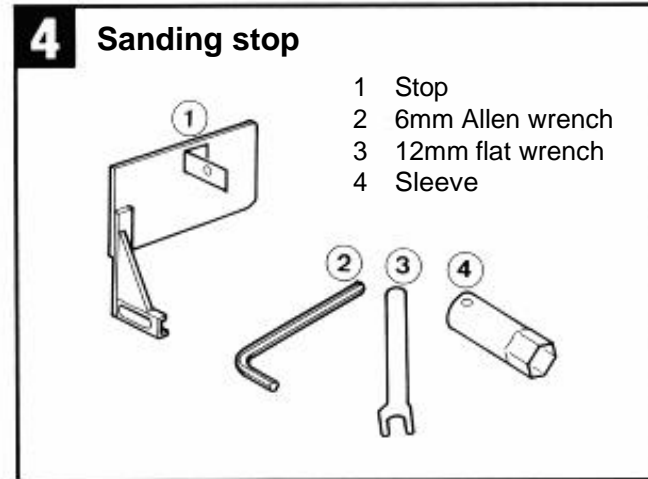
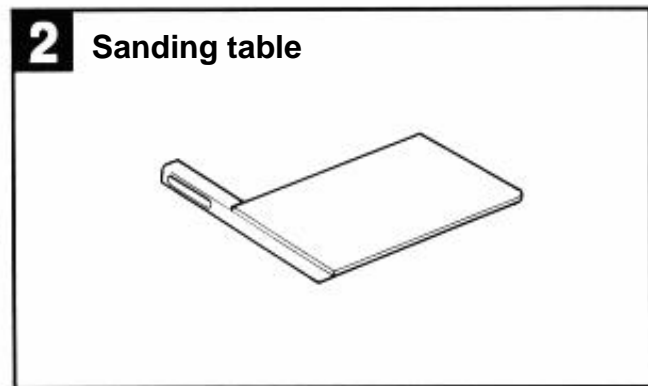
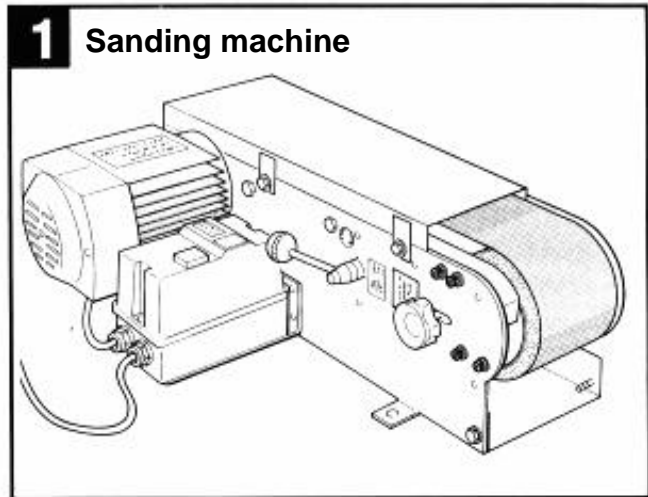
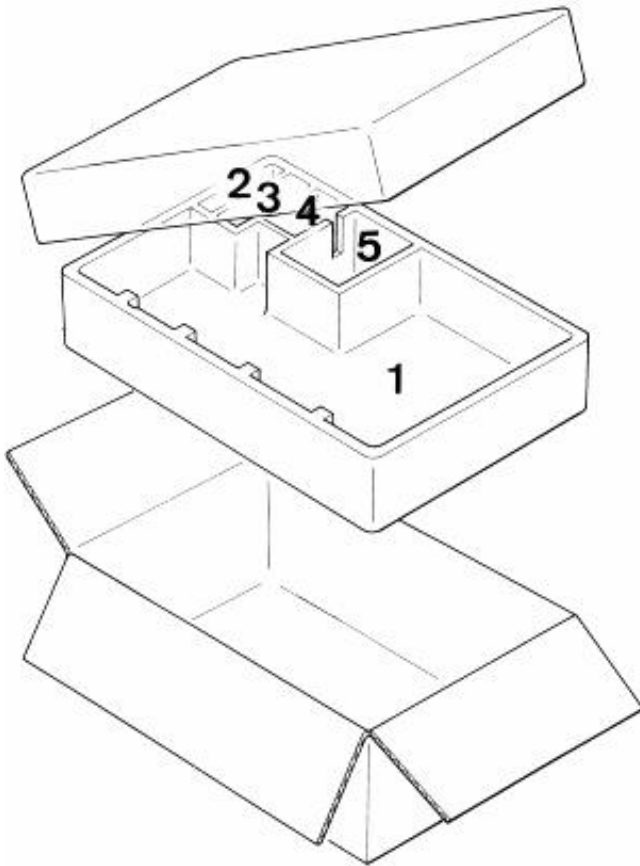
MODEL	331C	331Y
Motor	0.75 KW	
Power	400V/50Hz/3Ph	230V/50Hz/1Ph
Belt size	100x1220mm	
Belt speed	19m/sec.	
Rubber roller - Dimensions	126x105mm	
Sanding surface	320x105mm	
Overall dimensions (L x W x H)	650x380x260mm	
Height with pedestal	1070mm	
Weight	28 Kg	
Pedestal dimensions	380x395x810mm	

Machine Description

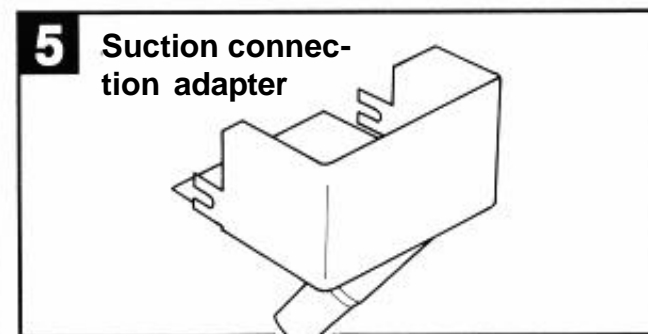


Unpacking and Check List

Packaging detail



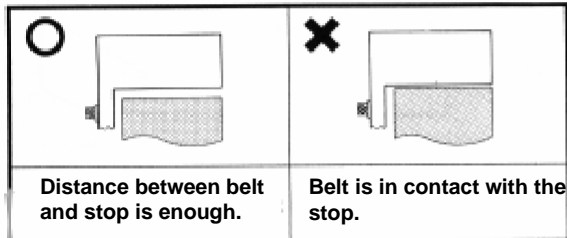
No.	Description	Pcs
1	Glass	1
2	Supporting bracket	1
3	Screw 1/4" x 1/2"	1
4	Washer M6 x 18 x 2	1
5	Spring washer 1/4"	1
6	Wing nut 1/4"	1
7	Screw 3/16" x 7/16"	2
8	Washer 3/16" x 12 x 0.8	2
9	Nut 3/16"	2



Installing the Sanding Arm

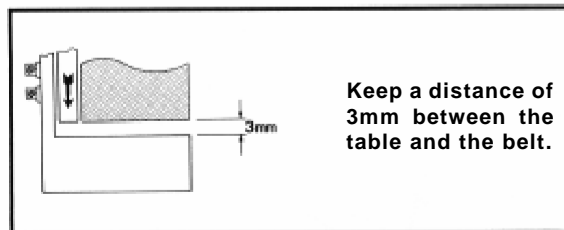
1. Installing the sanding stop

Set the lever so that the belt is tensioned. The belt is not tensioned upon delivery of the machine. Mount the stop as shown in the scheme, without the belt touching the stop.



2. Installing the work table

Assemble as shown in the scheme, keeping a distance of 3mm between the belt and the table.



3. Installing the suction connection system

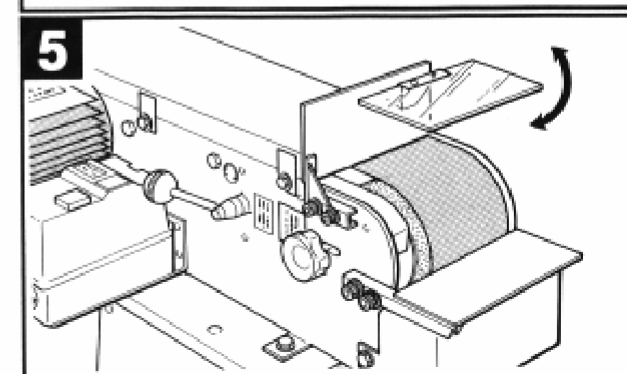
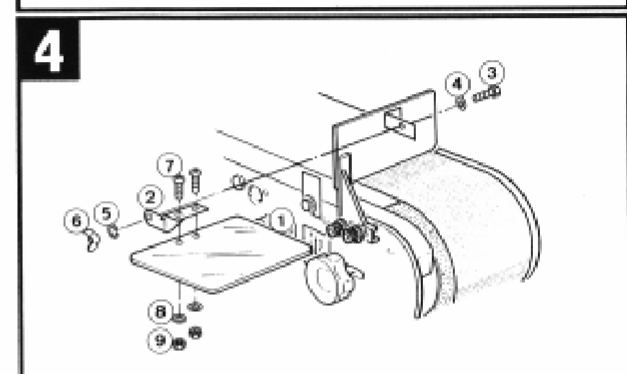
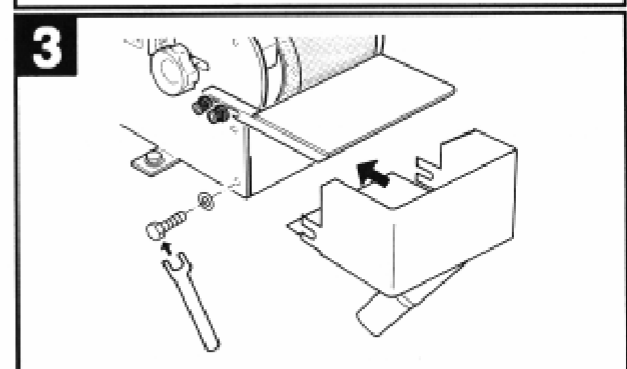
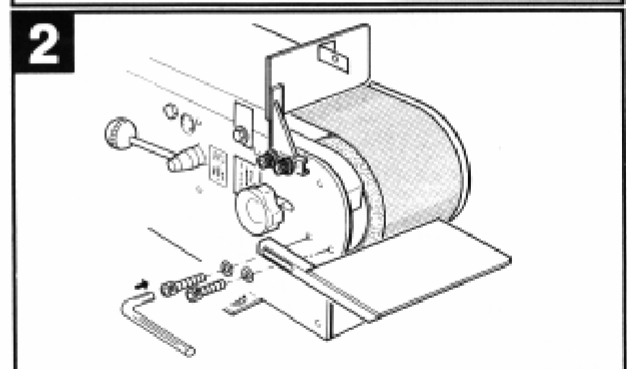
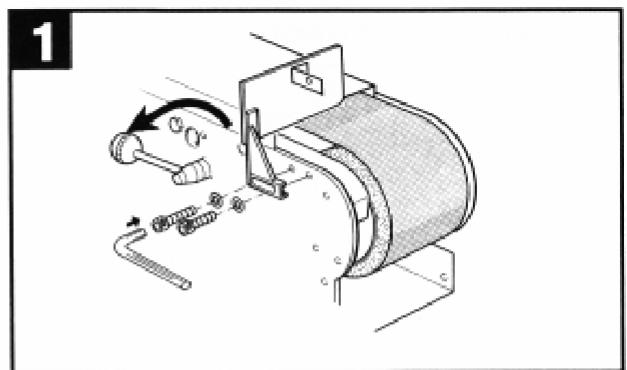
Mount the suction connection adapter as shown in the scheme. See page 13 for more information.

4. Installing the safety glass

Proceed as shown in the scheme. See page 13 for more information.

5. Adjusting the safety glass

Adjust the safety glass so that the protection is optimal.

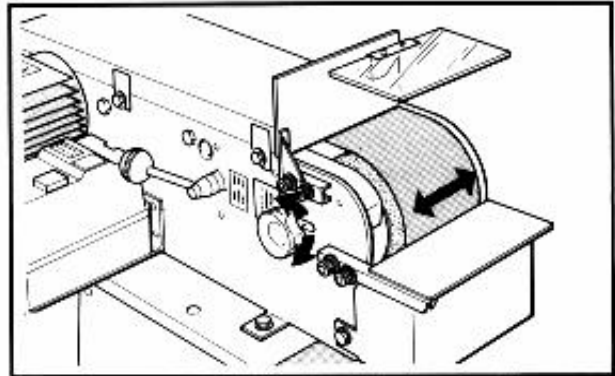
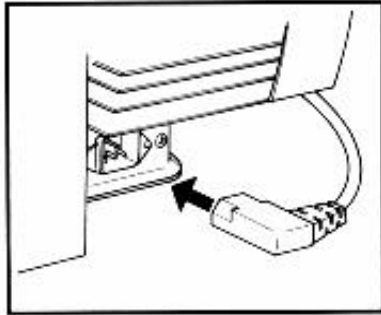


Adjusting the Belt

Adjustment

1. Connect the plug to the motor.

2. Turning the adjustment knob clockwise makes the belt running to the left while turning the knob anti-clockwise makes the belt running to the right.



CAUTION: Rotate gently to adjust.

3. Turn the belt by hand and, using the adjustment knob, adjust the belt in the middle.

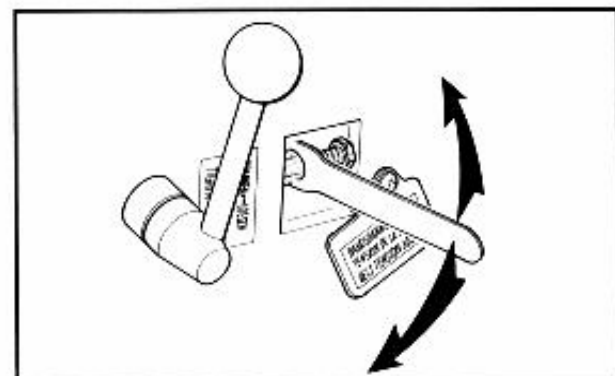
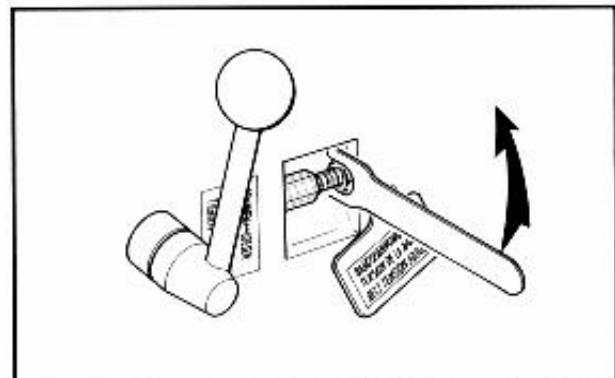
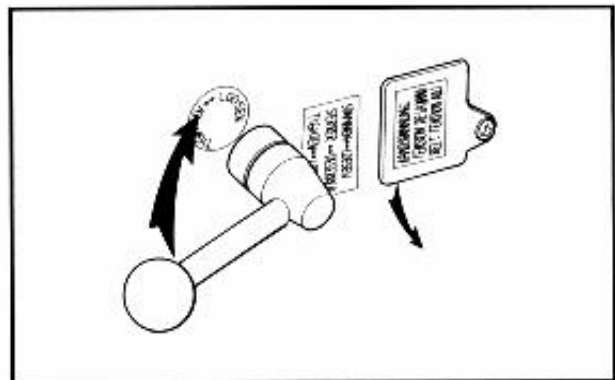
4. Start the motor and fine-tune the setting.

Belt tension

Stop the machine and cut off the power. The belt tension is a factory setting (at the time of manufacture) but a correction may be made, or must be made.

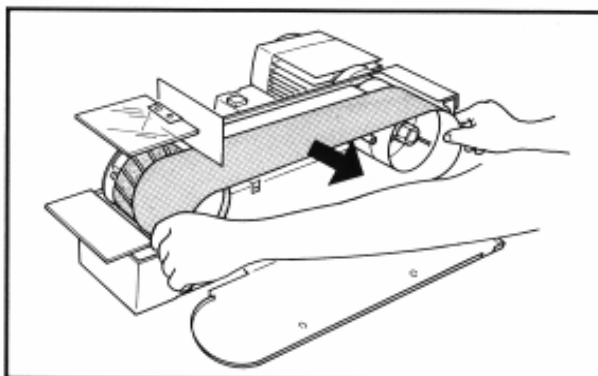
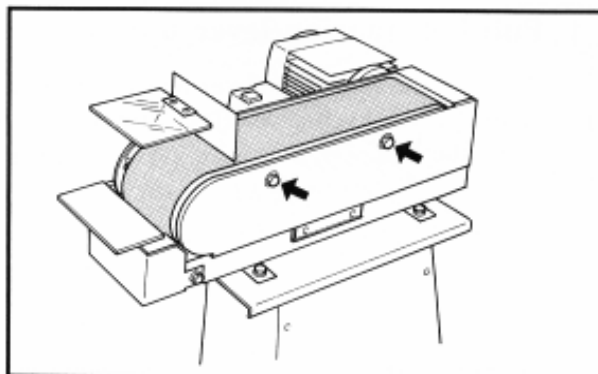
Proceed as described below:

1. Move the cover.
2. Turn the lever 120° to release the belt.
3. Release the nut using the special flat spanner.
- 4a. The belt is not tight enough. Turn the nut upwards.
- 4b. The belt is too tight. Turn the nut downwards.
5. *Information*
One turn of the nut increases or decreases the tension by 2.5mm.
6. Tighten the counter nut, close the cover, and tension the belt using the lever.
7. After correcting the tension, re-adjust the belt centring as described above.



Replacing the Belt

1. Release the belt using the lever.
2. Remove the side guard and remove the belt from the rollers.
3. Install the new belt, paying attention to the sanding direction.
4. Tension the belt using the lever.
5. Adjust the belt as described on page 7.



Tips

Transporting the machine

1. *The machine weighs 34Kg, including the pedestal.*
2. *If you intend to or must move or re-position the machine, ask for help or use a lifting and transporting device.*

Environment

1. *Make sure that the room where the sander is located is well lit and ventilated.*
2. *A light intensity of 300Lux is sufficient.*

Electrical connection and operation

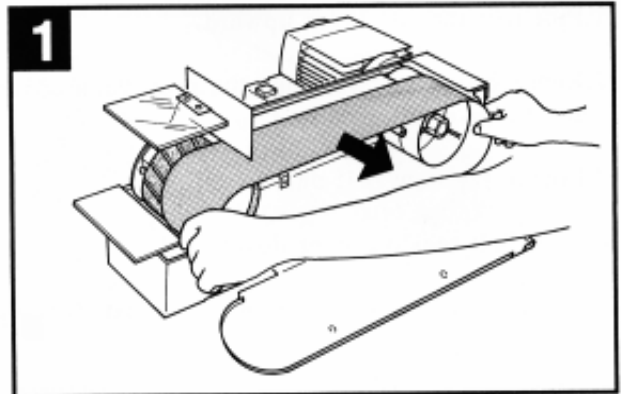
1. *This machine is equipped with a 4-wire cable for 400/50/3 connection.
For connection to the mains, use equipment complying with article 5.3 of the EN60204-1 standards.*
2. *For protection, we recommend to use 6A fuses.*
3. *The power supply in terms of frequency, voltage and number of phases must comply with the wiring diagram.*
4. *The correct rotation direction of the sander will be achieved by reversing 2 phases of the power supply, if necessary.*
5. *Always disconnect the machine from the mains when not in use, and to perform maintenance or adjustments works.*
6. *Le yellow/green ground cable must be connected to the ground of your electrical installation.*

To start and stop the machine.

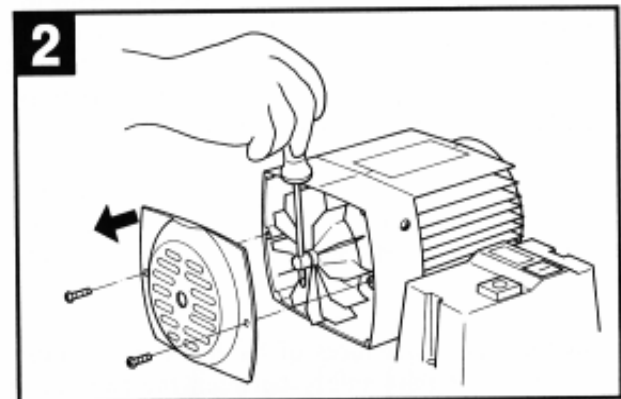
1. "Start" Press "I"
2. "Stop" Press "O"

Replacing the Drive Roller

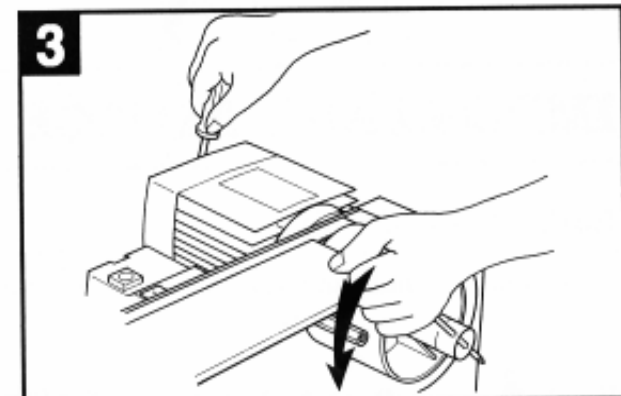
1. Disconnect the machine from the mains.
Remove the guard and the belt as described.



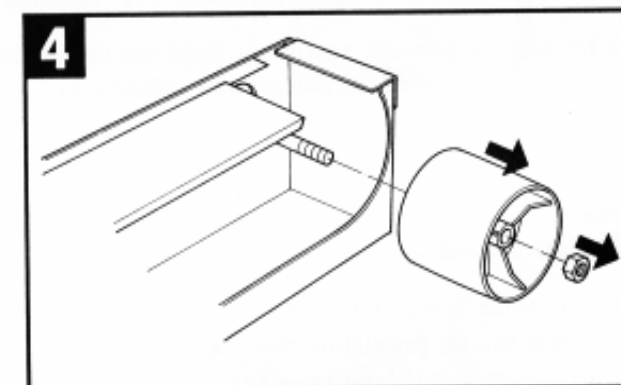
2. Remove the fan cover. Hold the motor shaft with a screwdriver, do not hold the fan.



3. Remove the nut from the roller, as described.



4. Remove the aluminium roller and replace it with a new one.

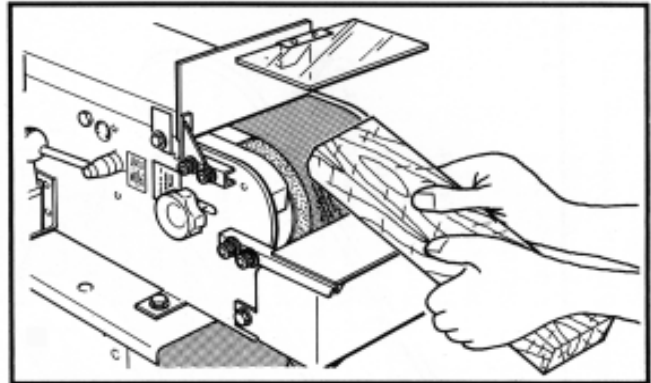


Sanding Examples

Example 1

Sanding with the roller.

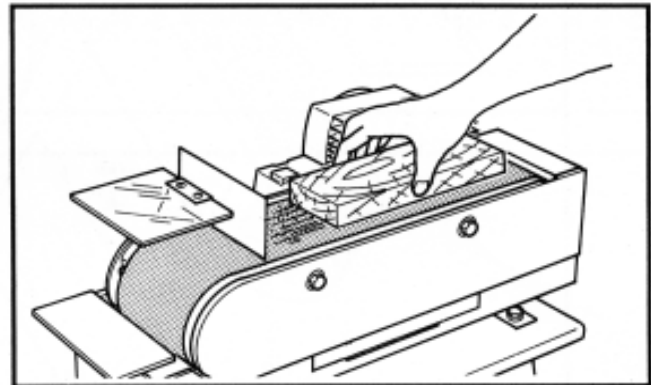
Place the workpiece on the table and move it to the corner of the table.
Protect the belt with the stop.



Example 2

Flat sanding.

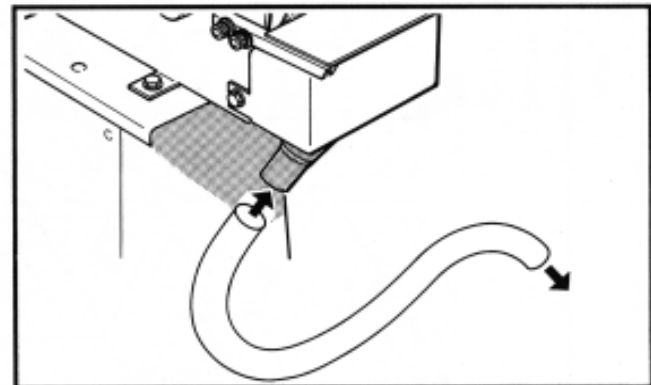
Remove the top guard. Place the workpiece on the belt and secure with the stop.



Example 3

Suction.

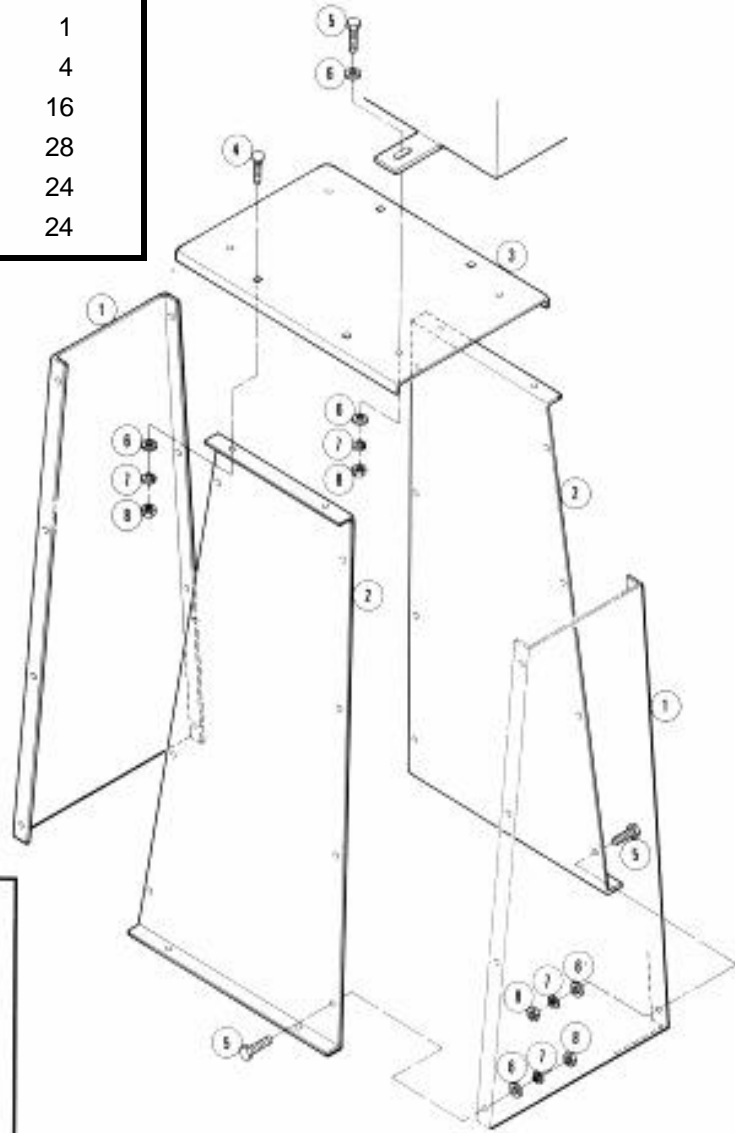
Sanding generates dust, which contaminates the atmosphere.
PROMAC machines are manufactured with a 35mm dust extraction system. You will find in the PROMAC Catalogue the dust extraction system to be connected to these machines.



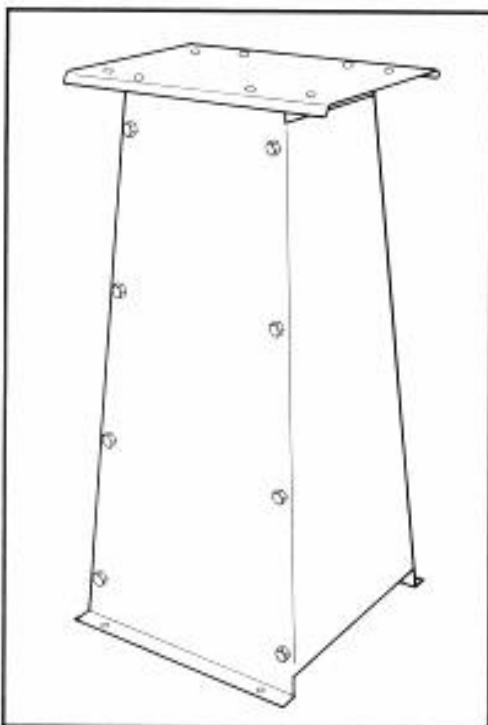
Machine Pedestal (stand)

1. Unpacking and Check List

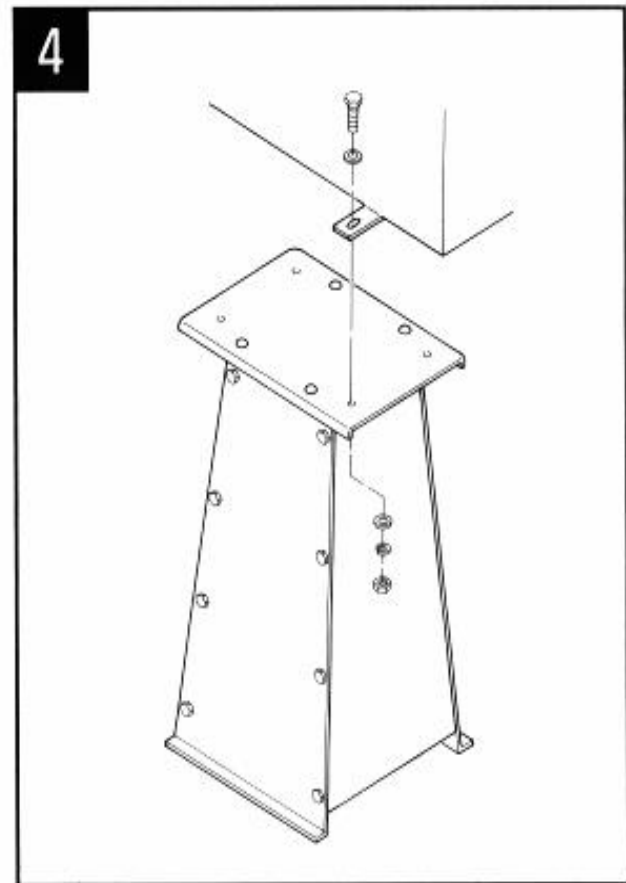
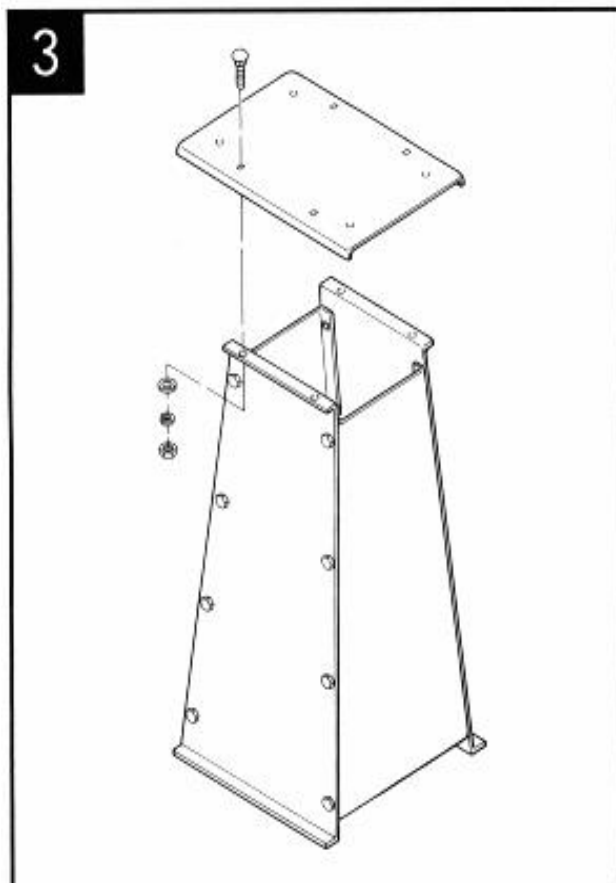
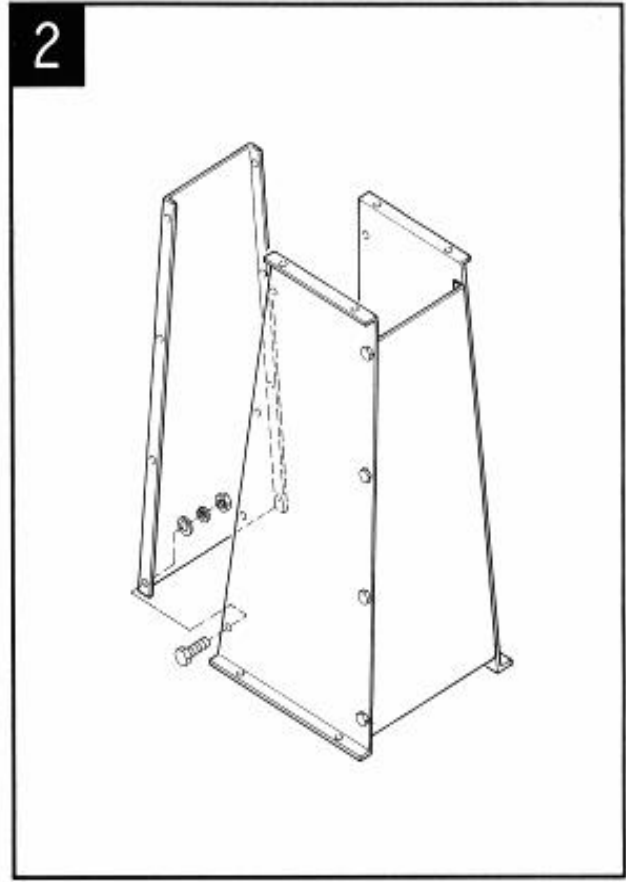
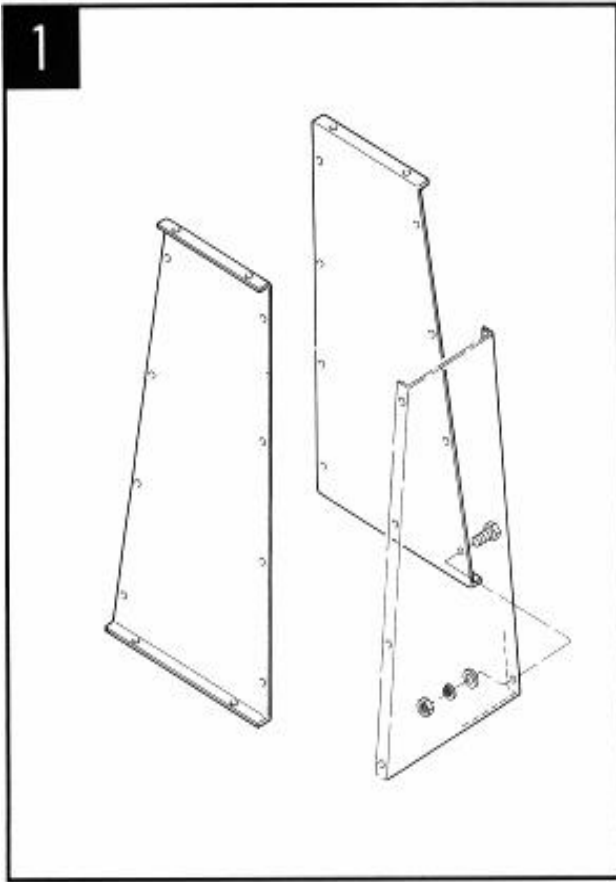
No.	Description	Qty.
1	Front & Rear face	2
2	Right & Left side	2
3	Plate	1
4	Bolt 5/16" -18NCx3/4"	4
5	Bolt 5/16" -18NCx3/4"	16
6	Washer 5/16"	28
8	Washer 5/16"	24
9	Nut 5/16-18NCx2	24



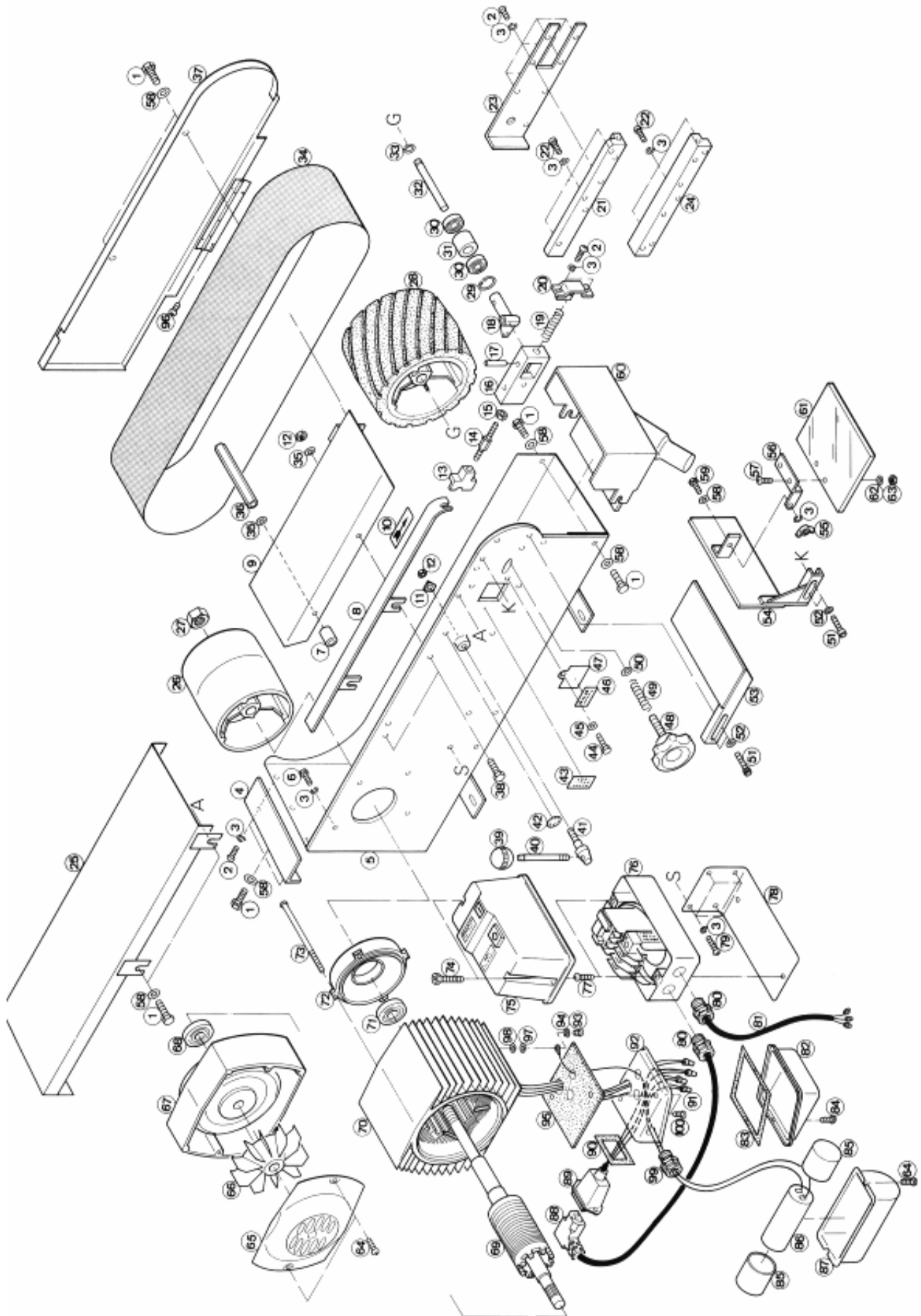
11. Assembling



Assembling the Pedestal (stand)



Exploded View



Spare Parts List

1.	PM - 331001	Screw
2.	PM - 331002	Screw
3.	PM - 331003	Spring washer
4.	PM - 331004	Support bracket
5.	PM - 331005	Housing
6.	PM - 331006	Screw
7.	PM - 331007	Bushing
8.	PM - 331008	Rail
9.	PM - 331009	Sanding plate
10.	PM - 331010	Label
11.	PM - 331011	Flange
12.	PM - 331012	Nut
13.	PM - 331013	Flange
14.	PM - 331014	Threaded rod
15.	PM - 331015	Nut
16.	PM - 331016	Block
17.	PM - 331017	Pin
18.	PM - 331018	Supporting bracket
19.	PM - 331019	Spring
20.	PM - 331020	Flange
21.	PM - 331021	Guide
22.	PM - 331022	Screw
23.	PM - 331023	Plate
24.	PM - 331024	Guide
25.	PM - 331025	Protective cover
26.	PM - 331026	Alu roller
27.	PM - 331027	Nut
28.	PM - 331028	Rubber roller
29.	PM - 331029	Circlip
30.	PM - 331030	Ball bearing
31.	PM - 331031	Bushing
32.	PM - 331032	Shaft
33.	PM - 331033	Circlip
35.	PM - 331035	Washer
36.	PM - 331036	Shaft
37.	PM - 331037	Cover
38.	PM - 331038	Screw
39.	PM - 331039	Knob
40.	PM - 331040	Spindle
41.	PM - 331041	Pin
44.	PM - 331044	Screw
45.	PM - 331045	Washer
47.	PM - 331047	Cover
48.	PM - 331048	Control knob
49.	PM - 331049	Spring
50.	PM - 331050	Washer
51.	PM - 331051	Screw
52.	PM - 331052	Washer
53.	PM - 331053	Table
54.	PM - 331054	Stop
55.	PM - 331055	Wing nut
56.	PM - 331056	Holder
57.	PM - 331057	Screw
58.	PM - 331058	Washer
59.	PM - 331059	Screw
60.	PM - 331060	Suction connection

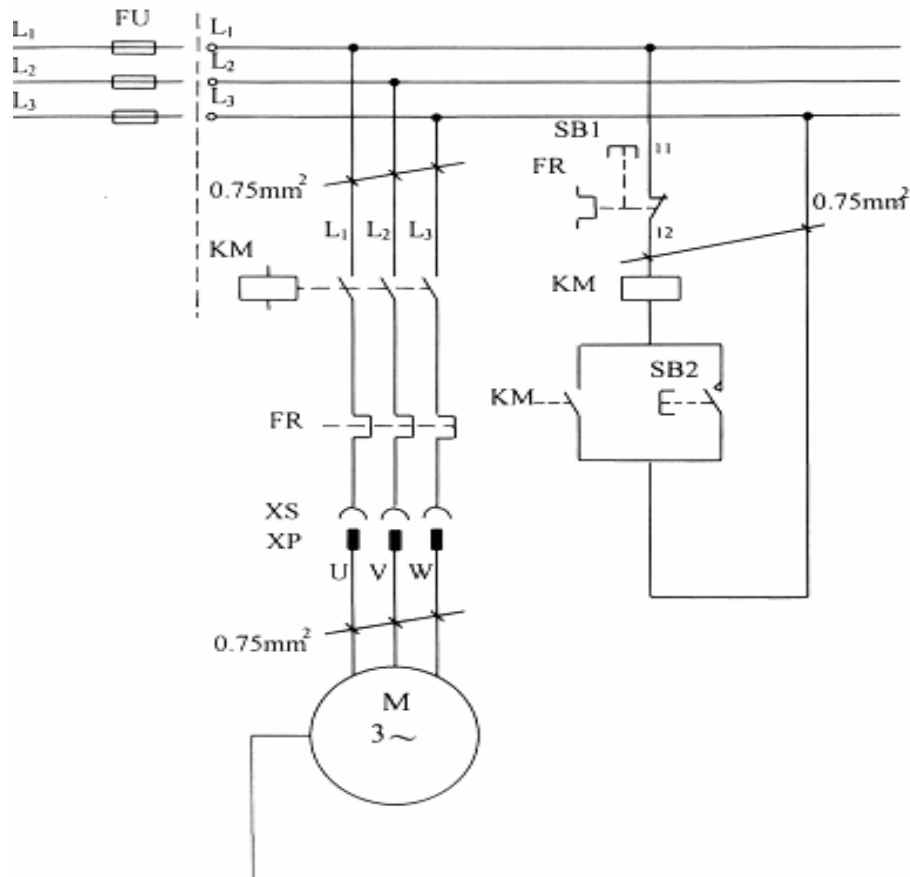
61.	PM - 331061	Safety glass
62.	PM - 331062	Washer
63.	PM - 331063	Nut
64.	PM - 331064	Screw
65.	PM - 331065	Motor cover
66.	PM - 331066	Fan
67.	PM - 331067	Motor flange
68.	PM - 331068	Ball bearing
64.-73.		
	PM - 331070	Motor, complete
71.	PM - 331071	Ball bearing
72.	PM - 331072	Motor flange
73.	PM - 331073	Screw
74.-77.		
	PM - 331074	Switch, complete
78.	PM - 331078	Supporting bracket
79.	PM - 331079	Screw
80.	PM - 331080	Fitting
81.		Cable
82.	PM - 331082	Cover
83.	PM - 331083	Gasket
84.	PM - 331084	Screw
88.	PM - 331088	Plug
89.	PM - 331089	Connector
90.	PM - 331090	Gasket
92.	PM - 331092	Housing
93.	PM - 331093	Screw
94.	PM - 331094	Washer
95.	PM - 331095	Gasket
96.	PM - 331096	Screw
97.	PM - 331097	Washer
98.	PM - 331098	Washer
100.	PM - 331100	Screw

Sanding belts

Sanding belt 100x1220mm, Pack of 5 pieces..

9869	Sanding belt	Grain size 60
9870	Sanding belt	Grain size 80
9871	Sanding belt	Grain size 100
9872	Sanding belt	Grain 120
9873	Sanding belt	Grain size 180

Wiring Diagram



Electrical Components

Designation	Description		
	Switch	IP 65	
KM	Contactor	AC3-1-1, 660 VAC, 20A	IEC 158-1, VDE 0660
FR	Relay	$\frac{1.6 - 2.5A}{2.0}$	IEC 292-1, BS775
SB1	"Stop" switch		
SB2	"Start" switch		
XS	Motor stop	500 VAC, 10A	VDE, CSA, UL, B
XP	Motor plug	500 VAC, 10A	VDE, CSA, UL, B
	Cable	VCTF, 4x0.75mm ²	VDE



Warranty / Garantie

TOOL FRANCE SARL guarantees that the supplied product(s) is/are free from material defects and manufacturing faults. This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, damage due to accidents, repairs or inadequate maintenance or cleaning as well as normal wear and tear.

Further details on warranty (e.g. warranty period) can be found in the General Terms and Conditions (GTC) that are an integral part of the contract.

These GTC may be viewed on the website of your dealer or sent to you upon request.

TOOL FRANCE SARL reserves the right to make changes to the product and accessories at any time.

TOOL FRANCE SARL garantiert, dass das/die von ihr gelieferte/n Produkt/e frei von Material- und Herstellungsfehlern ist. Diese Garantie deckt keinerlei Mängel, Schäden und Fehler ab, die - direkt oder indirekt - durch falsche oder nicht sachgemäße Verwendung, Fahrlässigkeit, Unfallschäden, Reparaturen oder unzureichende Wartungs- oder Reinigungsarbeiten sowie durch natürliche Abnutzung durch den Gebrauch verursacht werden.

Weitere Einzelheiten zur Garantie können den allgemeinen Geschäftsbedingungen (AGB) entnommen werden. Diese können Ihnen auf Wunsch per Post oder Mail zugesendet werden.

TOOL FRANCE SARL behält sich das Recht vor, jederzeit Änderungen am Produkt und am Zubehör vorzunehmen.

TOOL FRANCE SARL garantit que le/les produit(s) fourni(s) est/sont exempt(s) de défauts matériels et de défauts de fabrication.

Cette garantie ne couvre pas les défauts, dommages et défaillances causés, directement ou indirectement, par l'utilisation incorrecte ou inadéquate, la négligence, les dommages accidentels, la réparation, la maintenance ou le nettoyage incorrects et l'usure normale.

Vous pouvez trouver de plus amples détails sur la garantie dans les conditions générales (CG). Les CG peuvent être envoyées sur demande par poste ou par e-mail.

TOOL FRANCE SARL se réserve le droit d'effectuer des changements sur le produit et les accessoires à tout moment.

TOOL France SARL
9 Rue des Pyrénées
91090 LISSES France
www.promac.fr