

Sander

# Model 6320

Owner's Manual

For Models Manufactured Since 06/2023



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Stock Number: 6320.001  
6320.003  
Manual Version: 1.0.0





**READ AND UNDERSTAND ALL INSTRUCTIONS IN THIS MANUAL BEFORE ATTEMPTING TO ASSEMBLE OR OPERATE THE MACHINE.**

**FOLLOW THE INSTRUCTIONS AND THINK SAFETY!**

**THE OWNER OF THIS MACHINE IS SOLELY RESPONSIBLE FOR THE SAFETY OF ANYONE USING THIS MACHINE. SUCH RESPONSIBILITY INCLUDES BUT NOT LIMITED TO THE FOLLOWING:**

- **PROPER ASSEMBLY, OPERATION, INSPECTION, MAINTENANCE, AND RELOCATION OF THE MACHINE.**
- **PROPER TRAINING FOR THE OPERATORS AND ENSURES THIS MANUAL IS AVAILABLE AT ALL TIMES.**
- **USAGE AUTHORIZATION.**
- **USAGE OF SAFETY AND PROTECTION DEVICES.**

**OLIVER MACHINERY DISCLAIMS ANY LIABILITY FOR MACHINES THAT HAVE BEEN ALTERED OR ABUSED. OLIVER MACHINERY 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.**

**\*\* SAVE THIS MANUAL FOR FUTURE REFERENCE. \*\***

## **PROP 65 NOTICE**

**WARNING:** Drilling, sawing, sanding, or machining wood products can expose you to wood dust and/or other chemicals that are known to the State of California to cause cancer, birth defects, or other reproductive harm.

Some examples of these chemicals are:

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

Avoid inhaling wood dust and other harmful chemicals. Use a dust mask and/or other safety devices for personal protection.

For more information, go to <http://www.P65Warnings.ca.gov/wood>

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# Introduction

Thank you for choosing Oliver! This manual contains important information on how to safely set up, operate, and maintain this machine. Please take the time to read through this manual and make sure you understand all instructions.

While this manual may provide tips on optimizing the result of your workpiece, the manual is not intended as a substitute for formal woodworking training. If you need to know how to safely complete a woodworking task, please consult knowledgeable and qualified sources before proceeding further. We made every effort to keep this manual up-to-date. Instructions, specifications, drawings, and photographs in this manual should match the machine delivered. If you find any differences or anything that seems confusing in this manual, please check our website for an updated version:

## WWW.OLIVERMACHINERY.NET/MANUALS

Alternatively, you can contact our technical support for help:

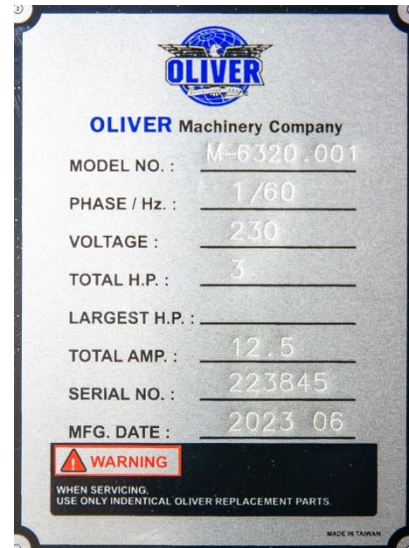
**1-800-559-5065**

Before calling, please note down the manufacture date and the serial number of the machine. You can find the information on a nameplate located on the back of the machine cabinet. This information is needed to provide proper technical support and to determine if an updated manual is available for your machine.

Please let us know how well this manual serves you. If you have any suggestions, please call the number above or email us at:

**info@olivermachinery.net**

We love to hear from our customers and make improvements.



# Specifications

## Quick View

Model	6320 Sander	
Stock Number	6320.001	6320.003
Power Requirement	230V 1Ph, 60Hz	230V, 3Ph, 60Hz
Motor	TEFC 3HP	
Sanding Belt Size	9" x 138-1/2"	
Sanding Belt Tilt	0° - 45°	
Dimensions	84"(W) x 40"(D) x 44"(H)	
Footprint	17"(W) x 42-1/8"(D)	
Fully Assembled Weight	623 lbs.	
Warranty	1 Year (Motor and electronics) 2 Years (All other parts)	

## Product Dimensions

Width x Depth x Height (Min. Space Needed)	84"(W) x 40"(D) x 44"(H)
Footprint	17" (W) x 42-1/8"(D)
Fully Assembled Weight	623 lbs.

## Shipment Info

Packaging	Wood Crate with Pallet Base
Content	Sander with Included Accessories
Dimensions	76-1/2"(L) x 30"(W) x 52-1/2"(H)
Weight	773 lbs.
Approx. Assembly Time	30 Minutes
Must Ship Upright	YES
Stackable	NO

## Electricals

Stock Number	6320.001	6320.003
Power Requirement	230V, 1Ph, 60Hz	230V, 3Ph, 60Hz
Full Load Current Rating	12.5A	TBD
Recommended Circuit Size	15A	TBD
Power Switch Type	ON/OFF Button Switch	
Connection Type	NEMA 6-15 Plug with 6' 14AWG Cord	Cord and plug are not included. Electrical hookup by licensed electrician required.

### Motor

Motor Type	TEFC	
Horsepower	3HP	
Power Requirement	230V, 1Ph, 60Hz	230V, 3Ph, 60Hz
Full Load Current Rating	12.5A	TBD
Speed	1720 RPM	
Efficiency / Power Factor	81% / 95.68%	TBD
Power Transfer Mechanism	Direct Drive	
Bearing type	Permanently Sealed Ball Bearing	

### Sander

Sanding Belt Size	9" x 138-1/2"
Sanding Belt Speed	Approx. 4100FPM
Sanding Belt Tilt	0° - 45°
Sanding Belt Oscillation Stroke	13/64" – 25/64"
Oscillation Per Minute	0, 40-60
Sanding Belt Drive Wheel	9" Rubber Coated Aluminum
Sanding Belt Idler	5" Aluminum
Platen Construction	Precision Ground Cast Iron with Graphite Coated Backing
Platen Dimensions	45-1/2" x 10"

### Table

Material	Precision Ground Cast Iron
Main Table Dimensions	46"(W) x 13"(D)
Main Table Height from Floor	33" – 40-1/2"
Main Table Horizontal Travel	5"
Side Table Dimensions	19-3/8"(W) X 6"(D)
Side Table Height from Floor	33-1/2" – 40"
Contour Sanding Drum Radius	4-1/2"

### Miter Gauge

Angle Range	-60° to 60°, with detents at -45°, -30°, 0°, 30°, 45°
Miter Fence Length	12-3/4"

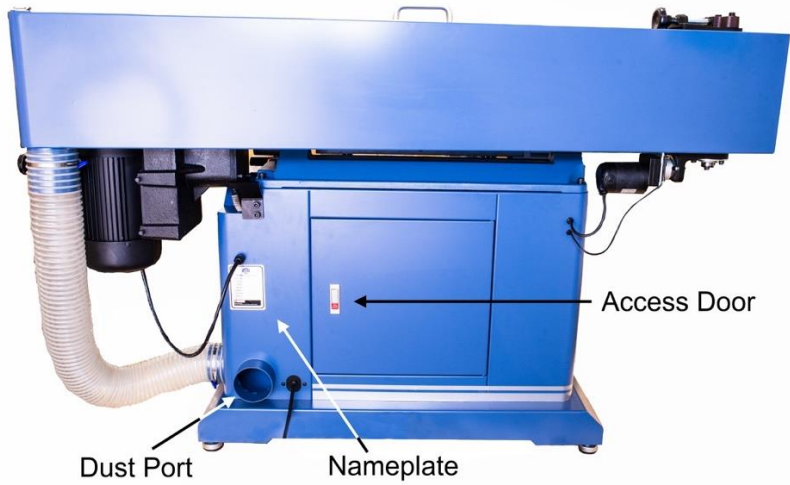
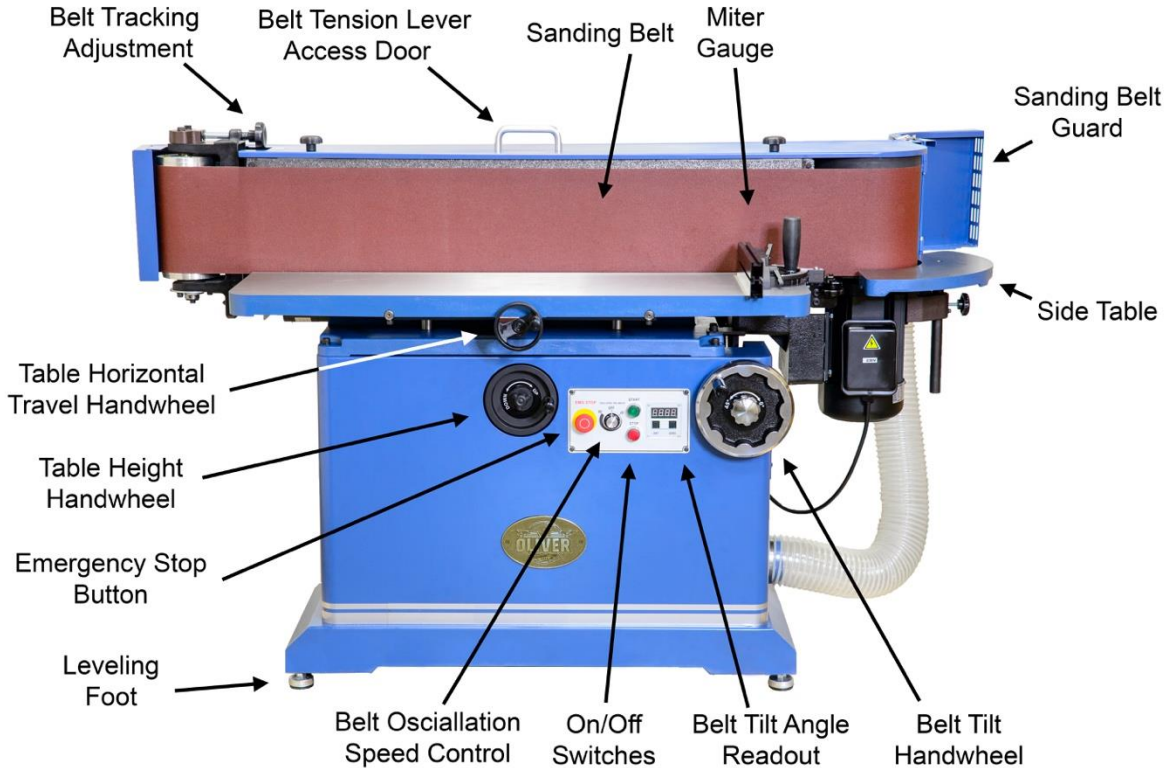
### Safety

Number of Dust Ports	1
Dust Port Size	4"
Minimum CFM Required	650 CFM
Sound Rating @ 2' distance	107 dB

### Others

Serial Number Location	On the back of the machine cabinet.
Certification	CSA 175370
Country of Origin	Taiwan




# Identification





# Safety

Oliver Machinery has made every attempt to provide a safe, reliable, easy-to-use piece of machinery. Safety, however, is ultimately depending on the individual machine operator. **Before operating this machine, please become familiar with the following safety labels and guidelines.**

 <b>DANGER</b>	This indicates an imminently hazardous situation which, if not avoided, <b>WILL</b> cause death or serious injury.
 <b>WARNING</b>	This means if the warning is not taken seriously, it <b>CAN</b> cause death or serious injury.
 <b>CAUTION</b>	This means if the precaution is not taken, it <b>MAY</b> cause minor or moderate injury.
<b>IMPORTANT</b>	This is a tip for properly operating the machine to avoid machine damage.

## General Safety Guidelines

1. **FAMILIARIZE** yourself with all safety instructions found in this manual. Know the limitations and hazards associated with this machine. Do not operate/service this machine until you are properly trained.
2. **ELECTRICAL GROUNDING**, when done properly, reduces the risk of electrocution, shocks, and fire. 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 a plug are used, make certain that the grounding plug connects to a suitable ground. Follow the grounding procedure indicated in the electrical code of your area.
3. **DISCONNECT** the machine from power before performing any service, maintenance, adjustments, or changing cutters. A machine under repair should be RED TAGGED to show it should not be used until the maintenance is complete.
4. **EYE PROTECTION**: Always wear an approved safety face shield, goggles, or glasses that comply with ANSI Z87.1 and CSA Z94.3 standards. Common eyeglasses are not safety glasses and may not provide adequate protection.
5. **EAR PROTECTION**: Use hearing protective devices where the noise exceeds the level of exposure allowed in Section 1910.95 of the OSHA Regulations. When in doubt, use it.
6. **OTHER PERSONAL PROTECTION**: Before the operation, remove tie, rings, watch, and other jewelry. Roll up sleeves above elbows. Remove all loose outer clothing and confine long hair. Protective footwear should be used. Do not wear gloves unless it is instructed to perform a particular step(s) in the manual.
7. **GUARDS**: Keep machine guards in place for all applicable operations. If any guards are removed for maintenance, DO NOT OPERATE the machine until all guards are reinstalled. Check clearance between the guards and the cutter before starting the machine.

8. **WORKPLACE SAFETY:** Keep the floor around the machine clean. Scrap material, sawdust, oil, and other liquids increase the risk of tripping or slipping. Be sure to clean up the table before starting the machine. Make certain the work area is well-lighted and that a proper exhaust system is used to minimize dust. Use anti-skid floor strips on the floor area where the operator normally stands and mark off the machine work area. Provide adequate workspace around the machine.
9. **ACCESS CONTROL** should be enforced so only trained personnel can access the work area and operate the machine. Use a childproof power switch when applicable.
10. **STAY ALERT** at all times. Do not operate this machine while under the influence of drugs/alcohol or when not feeling well.
11. **NEVER STAND ON THE MACHINE.** This prevents injuries from tipping-related accidents and accidental contact with cutters.
12. **REPLACEMENT PARTS:** Use only genuine Oliver Machinery replacement parts and accessories recommended for this machine. Generic parts made by other manufacturers may create a safety hazard and WILL void the factory warranty and other guarantees.
13. **PROPER USE:** Do not use this machine for anything other than its intended use. If used for other purposes, Oliver Machinery disclaims any real or implied warranty and holds itself harmless for any injury or damage which may result from that use.
14. **ADDITIONAL SAFETY INFORMATION:**
  - National Safety Council – *Accident Prevention Manual for Business and Industry:* <https://shop.nsc.org/apm-admin-program-14ed>
  - ANSI 01.1: <https://webstore.ansi.org/standards/wmma/ansio12013>
  - OSHA 1910.213: <https://www.osha.gov/laws-regs/regulations/standardnumber/1910/1910.213>

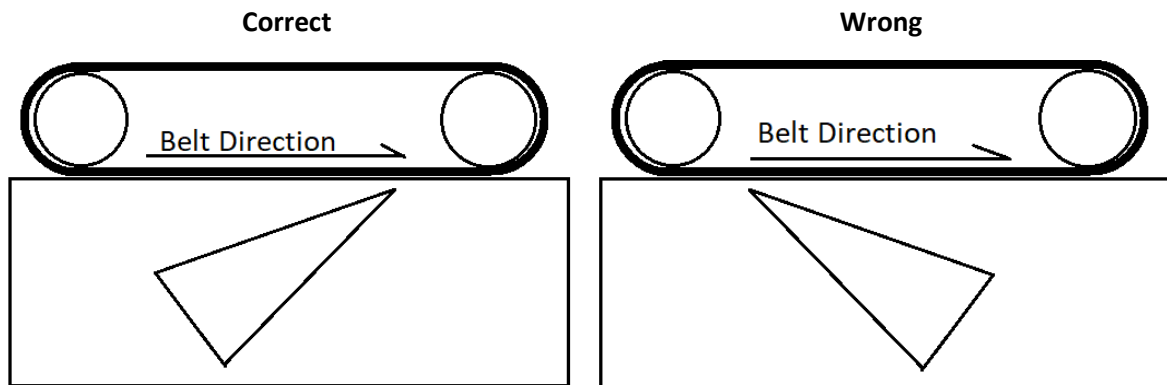
## Safety Guidelines Specific to Sander

### Before Work Begins:

1. Inspect the sanding belt for signs of failure. Replace damaged, overstretched, or worn sanding belts.
2. Ensure the sanding belt is tensioned.
3. Inspect the workpiece. Do not process workpieces with loose parts and/or containing dangerous chemicals. Do not sand wood with high moisture content.
4. Ensure the table is positioned at least 1/16" above the bottom edge of the sanding belt.
5. Ensure the sanding belt guard, platen, and table are locked into position.

### When Sanding:


1. Maintain control of the workpiece. Hold the workpiece firmly with both hands and apply light pressure against the sanding belt. Use the sander table and miter gauge to support the workpiece.
2. Keep hands away from the sanding belt and other moving parts. Use special jigs to hold down small workpieces as needed.
3. To avoid kickbacks and damaging the sanding belt, do not feed the workpiece with sharp corners pointing against the moving direction of the sanding belt.



### After Operation

1. STOP THE MACHINE when the operator leaves the machine for any reason.
2. WAIT until both the main motor and oscillation motor come to a complete stop.
3. CLEAN UP before departure.

# Electricals

 <b>WARNING</b>	<b>All electrical work must be done by a licensed electrician and must meet the electrical code in your area. Otherwise, the warranty is void.</b>
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## Minimum Circuit Size Required for Model 6320 Sander

<b>Stock Number</b>	<b>Voltage</b>	<b>Phase</b>	<b>Minimum Circuit Size Required</b>
6320.001	230V	1Ph	15A
6320.003	230V	3Ph	TBD

Please ensure the electrical circuit for this machine meets the minimum circuit size requirement. The minimum circuit size requirement applies to a dedicated circuit that provides power to one 6320 Sander. If more machines are sharing the same circuit, consult a licensed electrician to ensure the designated circuit is properly sized for safe operation.

If a circuit is available but not meeting the minimum circuit size requirement listed above, a new circuit must be installed for this machine.

## Grounding

 <b>WARNING</b>	<b>Improper grounding can cause electric shock, fire, and equipment damage.</b>
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Proper grounding reduces the risk to the operator in the event of electrical malfunction or breakdown. This machine must be connected to the grounding conductor when available, and all grounding connections must meet or exceed the electrical code requirements in your area. Furthermore, all grounds must be verified and must meet or exceed the electrical requirement of the machine.

For workshops that have a single phase system, If grounding is not available, consider the use of a GFCI protection device as an alternative if this complies with the electric code in your area.

For workshops that have an ungrounded 3-phase system, a ground detector must be present according to NEC 250.21(B).

Consult a licensed electrician to ensure this sander can operate safely before using this sander with an ungrounded electrical system.

## Electrical Wiring

The single phase variant of his machine is pre-wired with a cord and a NEMA 6-15 plug. See “Wiring Diagrams” on page 35 for wiring the three phase variant.

To connect the machine directly to the electrical panel (“Hardwiring”), ensure an electrical disconnect is installed near the machine so the operator or service person can easily disconnect the machine from power.

To connect this machine with a plug and a cord, use a UL/CSA listed plug that meets the power requirements. Organize the power cord so it does not create a tripping hazard.

The use of an extension cord is not recommended. If you need to use an extension cord to connect to a power source, select a durable cord type with a high-temperature rating (90C° or above). Use the minimum amount of extension cord as needed.

### Minimum cord size (AWG) required based on amperage draw and length of the cord:

<i>Amps</i>	<b>Power Cord Length</b>			
	25 feet	50 feet	75 feet	100 feet
<i>8 to 12</i>	14	14	12	10
<i>12 to 15</i>	12	12	10	10
<i>15 to 20</i>	10	10	10	NR
<i>21 to 30</i>	10	NR	NR	NR

\*NR: Not Recommended



**Use properly sized wires that meet or exceed the power requirement of your machine. Using undersized wires may cause overheating and increase the risk of fire and machine damage.**

# Setup

## Shop Preparation

### Space Requirement

The dimensions of this machine are 84"(L) x 40"(D). You will need additional space for manipulating your workpiece, electrical connection, and dust collection.

Keeping this sander several feet away from the wall allows easy access to the backside of the machine for maintenance. This also allows the sanding belt to tilt backwards.



### Load Limits

This machine has a shipping weight of 773 lbs. and a net weight of 623 lbs. Please ensure all lifting tools and building structures have adequate load capacity for transporting and supporting the total weight of this machine, the operator, and related items.

### Electricals

Make sure a properly sized circuit and electrical outlet are available near the machine. See “Electricals” on page 12 for details regarding electrical requirements.

### Lighting

Adequate lighting is needed for operating this machine. Overhead, non-glare lighting should be installed.

### Safety Labels

If this machine introduces a new safety hazard to your workplace, display proper warning signs in highly visible locations.

### Dust Collection

Wood dust created by this sander is a health hazard. High-quality dusk masks should be available for using the sander.

Connect this machine to a dust collection system. Check air suction strength regularly to ensure dust and shavings are effectively removed.



**Air resistance and leakage in a dust collection system impact its effectiveness. Use a dust collection system that is rated above 650 CFM at the dust port. Doing so improves air quality in the workplace and prevents the machine from jamming.**

## Receiving

Your shipment should come in one crate. Upon receiving your shipment, check for any significant damages before signing the delivery confirmation. If the crate is damaged, or if the crate has a TILTWATCH™ indicator and the indicator turns RED:

1. Accept the shipment.
2. Make notes on the Bill of Lading before signing it.
3. Inspect for damage immediately and thoroughly. Document and take photos of all damages found.



### IMPORTANT

If the machine arrived damaged, please call us immediately at **1-800-559-5065**. Keep all the items, including the packaging, for damage inspection.



**Always wear safety goggles and gloves when removing straps for securing your package. Straps may spring back violently when released and cause injury.**

## Moving the Machine into the Shop

Your machine will be delivered by freight service, and it will be left outside of your workshop by default. On the day of delivery, please be sure help is available to move the machine to its final location.



**6320 Sander has a gross weight of 773 lbs. and a net weight of 623 lbs.**

**Safe moving techniques and proper lifting equipment are required, or serious personal injury may occur.**



**Your machine may be secured by the packing straps. Do not lift your shipment by the strap. They are not designed to hold the total weight of your shipment. They may snap without warning and cause serious injury and machine damage.**

## Unboxing

Upon removing the crate cover, you should find the sander that is mostly assembled and protected by a plastic bag. There is also a paper box that contains all loose parts and accessories.



## Inventory

Carefully unwrap the packaging and make sure all components are included in the shipment. Inventory all items received and put them in groups.

### Group 1 – Sanding Belt



### Group 3 – Knobs for Belt Tension Lever Access Door



### Group 2 – Side Table



### Group 3 – Side Table Knob



**NOTICE:** If you cannot find an item in the list above, please check if it is still attached to the packaging. Occasionally, the item may have been pre-installed in the factory. See “**Parts List**” on page 37 to check if a component is included or installed.

**NOTICE:** This machine comes with various standard-sized, non-proprietary parts. If any of these parts are missing, we are happy to deliver them to you. To have the machine up and running as soon as possible, you can also find these parts at your local hardware store.

### Additional Items Needed for Machine Assembly

<i>Item</i>	<i>Purpose</i>
Safety glasses	Protection
Disposable gloves	Protection
Paper Towel	Cleaning
WD-40	Cleaning
Rust Inhibitor	Cast iron table top rust protection.



## Lifting the Sander from the Pallet

The sander is mounted on the pallet to stabilize the machine during transport. Remove the two retaining brackets from each side of the sander before lifting the sander from the pallet.



Connect the lifting slings to the lifting eye bolts and ensure the slings are balanced, then lift the sander from overhead and move to the designated location for operation.



Lower the sander gently to the floor to prevent damaging the leveling feet and the cabinet.

## Cleaning

To prevent rusting during shipment, the unpainted cast iron main table and end table are covered with rust protectant and plastic film.

A part of the plastic film is held in between the main table and the miter gauge. Remove two socket cap screws to unmount the miter gauge temporarily to release the plastic film and clean the entire table.



Wipe off the rust protectant with paper towels. Using WD-40 can help to dissolve the rust protectant and make it easier to remove.

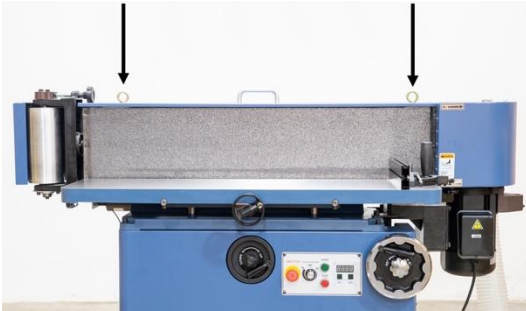


Once all rust protectant is removed, routinely coat the tabletops with rust preventive such as Boeshield® T-9 or paste wax. Do not use rust preventives that contain silicone, which is known to interfere with certain finishes and glues.

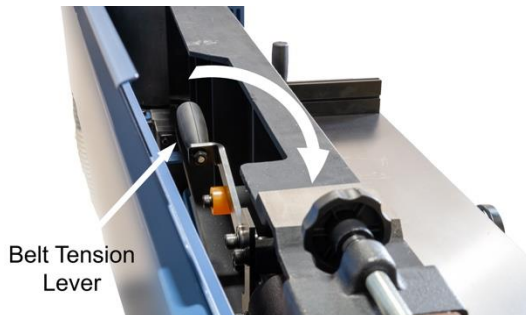
After the tables are cleaned, wipe off the excess oil at the bottom of the miter gauge and re-mount the miter gauge.

## Sanding Belt Installation

1. Remove the eye bolts for lifting the sander and open the belt tension lever access door.



2. Pull up the belt tension lever to install a sanding belt.



3. The sanding belt runs in a counter-clockwise direction. Make sure the arrows on the back of the sanding belt align with the belt running direction.



4. Loosen the lock knob under the belt guard to open the guard.



5. Slip the belt evenly and gradually into both drums until the belt is sitting in the middle of the drums.



6. Tighten the sanding belt by moving the belt tensioning lever back to its original position. When the sanding belt is properly tensioned, it should not slip off from the drums.

7. Close the belt guard and lock the guard with the lock knob.

8. Close the belt tension lever access door. Instead of reinstalling the eye bolts, install the pair of knobs provided to lock the door. Keep the eye bolts so the sander can be safely moved in the future.



## Side Table Installation

1. To maximize dust collection efficiency, only install the side table for contour sanding work.
2. Loosen the lock knob to unlock the sanding belt guard.



3. Use the buckle on top of the sanding belt guard to keep the guard in the open position.



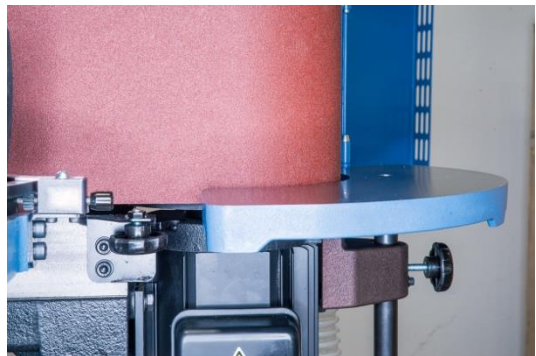
4. Install the side table lock knob onto the mounting bracket.



5. Insert the end table post into the mounting bracket. Align the groove of the post with the lock knob.



6. Make sure the table is not catching the sanding belt and the table is set above the bottom edge of the belt. Then tighten the lock knob to secure the table.



7. After using the side table, remove it from the sander. Close and lock the sanding belt guard.



## Leveling the Sander

This sander should be positioned on a level, stable floor. If the machine is rocking on the floor or if it vibrates excessively during operation, please adjust the rubber leveling feet with a 19mm wrench to level the machine. Test the adjustments to make sure the machine does not rock on the floor.



## Dust Collection

This sander can generate a lot of dust. Connect this machine to a dust collection system. Whenever possible, use the sander with the sanding belt guard closed to maximize dust collection efficiency.

The minimum CFM requirement for this sander is 650 CFM at the dust port, which means the dust collection system should have a rating greater than 650 CFM, as air friction and leakage can reduce effective CFM at the dust port.



### **IMPORTANT**

**Running this sander without a dust collection system or using a dust collection system with inadequate suction may damage the machine and cause other hazardous situations. Check your dust collection system regularly to make sure it is not jammed or filled up.**

## Test Run

This sander has been tested and calibrated before leaving the manufacturing facility. It should not require extensive adjustments. The essential checks provide an opportunity to get familiarized with the sander, and it helps to discover any potential issues before conducting production work.

### Mechanical Parts Inspection

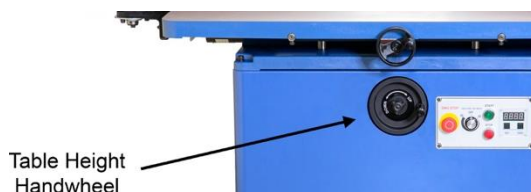
1. Make sure the sander is disconnected from the power source.
2. Make sure the belt tension lever access door and the sanding belt guard is closed and locked by the lock knobs.
3. Make sure the sanding belt is tensioned and it is not catching the guard, miter gauge, and table.
4. Set the miter gauge to 0° so the fence of the miter gauge is perpendicular to the sanding belt, then check the setting with a square.



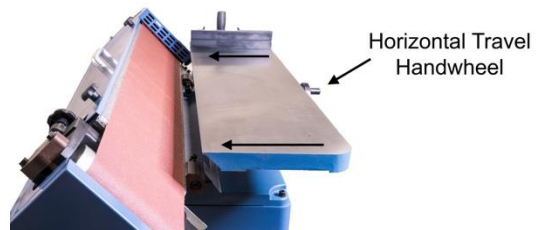
5. The sander is shipped with the sanding belt in the upright position. Use the belt tilt handwheel to tilt the belt all the way to the back. The belt should stop at a tilt angle of 45 degrees.



6. Use the table height handwheel to raise the table to its highest position.



7. Use the table horizontal travel handwheel to move the table towards the sanding belt. The table should shift towards the sanding belt and form a small gap with the belt.



8. Reverse steps 6 and 7 to move the table to its original position.
9. Change the sanding belt back to the upright position. Make sure the belt is perpendicular to the table.



## Electronic & Electrical Components Testing

1. Put on safety goggles and hearing protection.
2. Before connecting the sander to a power source, press the emergency stop button to prevent the machine from starting unintentionally.
3. Connect the machine to power.
4. Make sure the belt tilt digital readout is turned on. When changing the tilt angle of the sanding belt, the value on the readout should change accordingly.



5. Move the belt to the upright position and lock the belt tilt angle before moving to the next step.
6. Turn the belt oscillation speed dial to 0.



7. Attempt to turn on the machine by pressing the "START" button. The motor should not start as the emergency stop button is not reset.

8. To reset the emergency stop button, turn the button clockwise until it pops up.



9. Press the start button, and the motor should start. If the sanding belt is tracking within the platen and stays at least 1/16" below the table, increase the oscillation speed and continue to observe the movement of the sanding belt. The belt should now move up and down but still track within the platen and stay at least 1/16" below the table.

If the sanding belt is not tracking properly, **TURN OFF THE SANDER IMMEDIATELY.** See "Belt Tracking Adjustment" on page 32 to adjust belt tracking.

10. Allow the machine to run for a minute. During the initial run, a small amount of loose graphite may fall off from the platen. That is part of the break-in process, and it is expected. Remove the graphite flakes with a vacuum cleaner.
11. While the sander is running, disconnect the machine from power, then reconnect the machine to power. The sander motor should not start automatically as the magnetic power switch automatically opens the circuit when the power is out. Press the "START" button to restart the motor.
12. Press the "STOP" button to stop the main motor. Please note that unless the emergency stop button is pressed, the oscillation motor must be shut down by the oscillation speed dial.

Congratulations! You have completed the test run. If you discover any issues from the tests, refer to the troubleshooting section and maintenance section to diagnose issues and make adjustments.

# Operation

## Preparation Work

### Material Selection and Inspection

This machine is primarily designed for sanding good quality natural wood materials. Avoid cracked stock, and boards with loose knots can break apart. These can cause severe kickbacks, which can lead to severe injuries and machine damage. Using this sander for other material types may damage the sanding belt or shorten its lifespan. This may also cause other hazardous situations. For example, sanding ferrous metals can create sparks and ignite flammable materials nearby.

Do not sand treated lumber or anything that contains harmful chemicals, as this will spread dust that contains such harmful chemicals.

Carefully inspect the workpiece for foreign objects. Nails, staples, rock chips, and other objects embedded on the wood surface can damage the sanding belt. Clean the workpiece with a stiff brush as needed.

Glue and paint on the workpiece can gum up the sanding belt. Scrape off all excess glue and remove the paint with paint stripper before sanding.

The workpiece should have at least one flat surface so it can be pushed firmly against the table for feeding. Materials that do not have a flat surface should have the support surface flattened or be handled with a special jig that stabilizes the workpiece for feeding.

### Supporting Large Workpiece

Supporting large workpieces with an auxiliary table or roller to avoid injuries and to create a consistent finish.

### Safety Devices

To reduce the chance of a workpiece getting pulled out of your hand and to avoid accidental contact with the moving sanding belt, create special jigs to hold down workpieces that are less than 6" long and for those that are difficult to feed steadily.

Always wear high-quality dust masks when operating the sander.

### Clear the Work Area

Before turning on the sander, make sure the sander table is free of debris and the workpiece is not engaging the sanding belt.



## Adjustments

### Belt Tilt Digital Readout Initialization



1. To initialize the digital readout, move the sanding belt to the upright position. Use a square to verify the belt is perpendicular to the table, then press the “ZERO” button.



2. Once initialized, the digital readout displays the tilt angle of the sanding belt relative to the table.

**NOTE:** The “SET” button of the readout is not assigned with any functions.

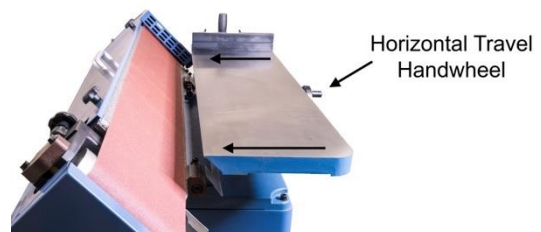
### Sanding Belt Tilt Adjustment

The sanding belt can be tilted to create a bevel on the workpiece.

1. To adjust the belt tilt, unlock the belt tilt handwheel.



2. Use the handwheel and the digital readout to set the desired tilt angle.
3. To minimize the gap between the table and the sanding belt, unlock the horizontal travel handwheel and move the table towards the sandbelt. Make sure the table does not touch the belt, as this will damage the table.



4. Lock all handwheels after the adjustment.

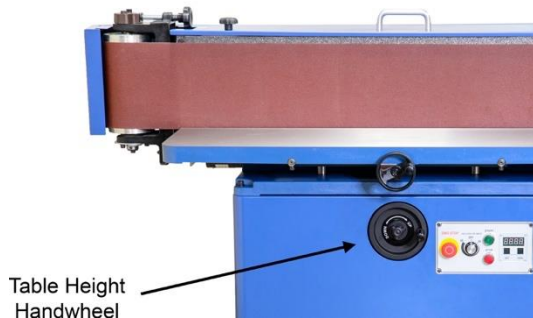
**IMPORTANT** Move the table away from the sanding belt before moving the belt back to the upright position. Failure to do so can damage the machine.



## Table Height Adjustment

### To set the height of the main table:

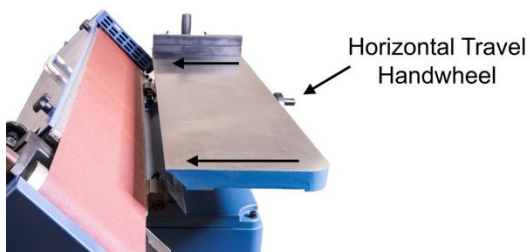
1. The main table can be raised and lowered with the table height handwheel. Unlock the handwheel before setting the table height. Make sure the table is positioned at least 1/16" above the bottom edge of the sanding belt.



2. **TIP:** Occasionally adjust the table height and make use of various sections of the sanding belt. This helps to even out the wearing of the sanding belt and extend its life.



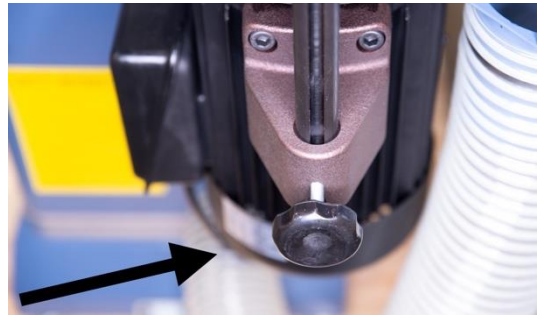
3. If the sanding belt is in a tilted position, raising the table will create a bigger gap between the belt and the table. To minimize the gap, unlock the horizontal travel handwheel and move the table towards the sandbelt. Make sure the table does not touch the belt, as this will damage the table.



4. Lock all handwheels after the adjustment.

### To set the height of the side table:

1. Loosen the lock knob on the table bracket.



2. Adjust the table height. Make sure the table does not touch the abrasive surface and is positioned at least 1/16" above the bottom edge of the sanding belt.
3. Tighten the lock knob to secure the side table.

### IMPORTANT

**Move the table away from the sanding belt before lowering the table or moving the belt back to the upright position. Failure to do so can damage the machine.**

### ⚠ WARNING ⚠

**Position the table at least 1/16" above the bottom edge of the sanding belt. Doing so prevents materials or body parts from getting caught between the table and the belt, which can cause serious injury.**

## Edge Sanding

1. Use the digital readout to set the sanding belt tilt angle to create a squared edge or a beveled edge.
2. Adjust the table height as needed.
3. Before starting the sander, clear the table and turn on the dust collection system.
4. Turn on the sander and set the belt oscillation speed.
5. Hold the workpiece firmly on the table and feed the workpiece gently to the sanding belt.



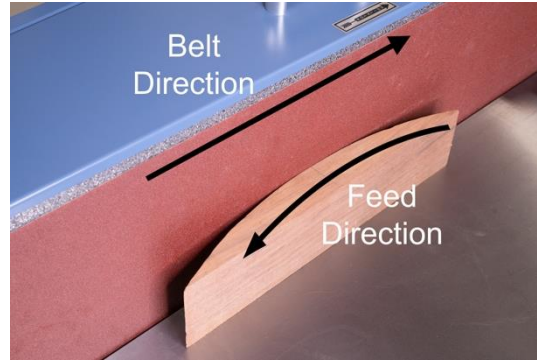
6. Using a miter gauge can provide additional support to the workpiece and create a squared or miter end. This sander comes with a miter gauge that is bolted onto the table. Check the miter angle against the sanding belt before use.



7. Use extra caution when sanding with a sharp miter angle pointing towards the traveling direction of the sanding belt. The workpiece can get wedged in between the belt and the miter gauge. This can damage the workpiece and the machine.

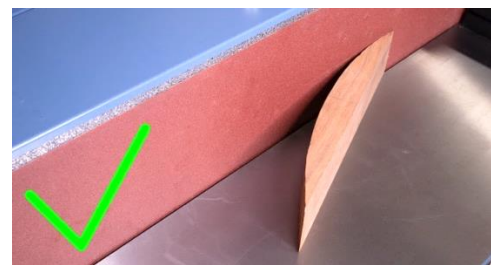


8. To sand a curved edge or to round a corner, begin the operation from a point where the edge is relatively straight/smooth, then rotate the workpiece against the direction of the sanding belt.



### ⚠️ WARNING ⚠️

Avoid feeding a sharp corner against the travel direction of the sanding belt. Doing so increases the risk of the workpiece pulling away from the operator, which may cause serious injuries and machine damage. Instead, start the work from a relatively flat surface and work towards the sharp corner.



## Contour Sanding with Side Table

1. To maximize dust collection efficiency, only install the side table for contour sanding work.
2. Loosen the lock knob to unlock the sanding belt guard.



3. Use the buckle on top of the sanding belt guard to keep the guard in the open position.



4. Install the side table lock knob onto the mounting bracket.



5. Insert the end table post into the mounting bracket. Align the groove of the post with the lock knob.



6. Make sure the table is not catching the sanding belt and the table is positioned at least 1/16" above the bottom edge of the sanding belt. Tighten the lock knob to secure the table.



7. After using the side table, remove it from the sander. Close and lock the sanding belt guard.

### **⚠ WARNING ⚠**

Avoid sanding edges with curvature closely matching the abrasive surface. Failure to comply increases the risk of a catch, which can cause severe injuries and damage to the workpiece.



### **IMPORTANT**

Only remove the belt guard and install the side table while performing contour sanding. Keeping all belt guards installed at most times improves dust collection effectiveness for edge sanding and reduces the risk of accidental body contact with the sanding surface and moving parts.

# Accessories

## Touchup Paint



Keeping all painted surfaces in good condition not only makes your machine look nice but also keeps rust away. Oliver Machinery has pre-mixed spray paint available in Oliver-Blue for purchase.

Accessories are available on our website: **OLIVERMACHINERY.NET**

To order by phone, please call us at **1-800-559-5065**. We are available Monday through Friday, 7:30 AM - 4 PM Pacific Time. You can also email us at **PARTS@OLIVERMACHINERY.NET** to purchase accessories.

Please visit our website at **OLIVERMACHINERY.NET** for additional recommended accessories.




**Using unapproved accessories may cause the machine to malfunction, which can result in serious injury and/or machine damage. Only use accessories recommended for this machine.**

# Maintenance

Routine maintenance keeps your sander in optimal condition. Please follow the maintenance schedule below and use the maintenance record worksheet in the manual to document all tasks completed.

**NOTICE:** Maintenance schedule may vary for individual users due to different situations and safety requirements.

Task	Frequency
Inspect the power switch, cord, and plugs for signs of failure.	Every day before any operation begins.
Inspect the sanding belt for signs of failure.	Every day before any operation begins.
Clean the sanding belt with a belt cleaning stick.	When the sanding belt is clogged.
Remove dust accumulated on/inside the machine.	Weekly
Clean and lubricate gears and shafts.	Monthly
Apply rust protectant on cast iron tables.	Monthly
Inspect and clean sanding belt drums.	Monthly
Bearings	Bearings are sealed and lubricated. They do not require lubrication.

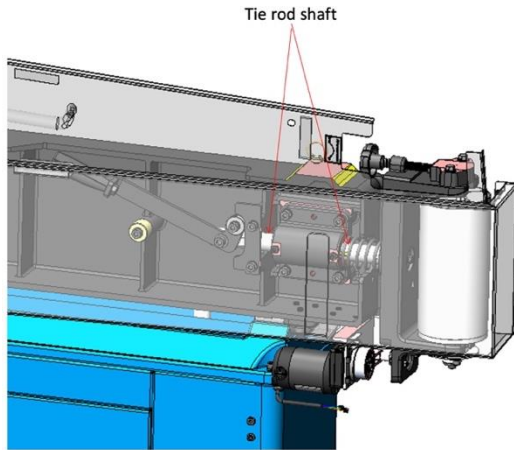
 <b>WARNING</b>	<b>Disconnect the machine from the power source before any maintenance work is performed. After servicing the sander, remove all tools before restarting the machine. Failure to comply can cause serious injury!</b>
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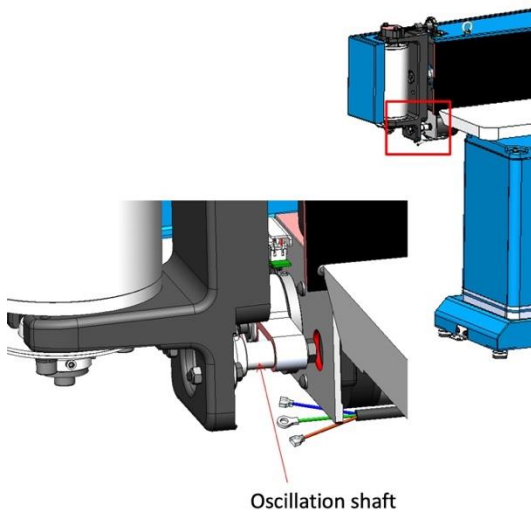
## Lubricating Machine

The gears and shafts of the sander should be cleaned and lightly lubricated regularly. Relubricate these components with self-cleaning dry lube, paste wax, or lithium grease. Avoid over lubrication, as this can attract dust.

### 1. Tie rod shaft



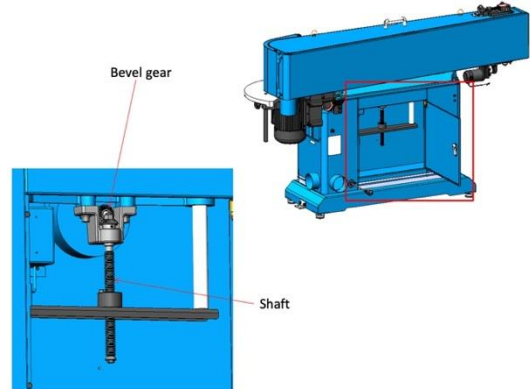
### 2. Oscillation shaft



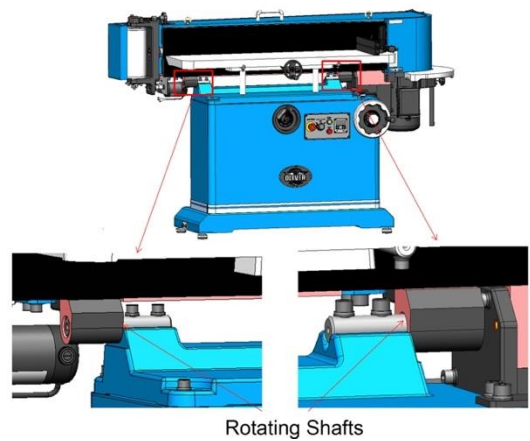
### 3. Worm gear



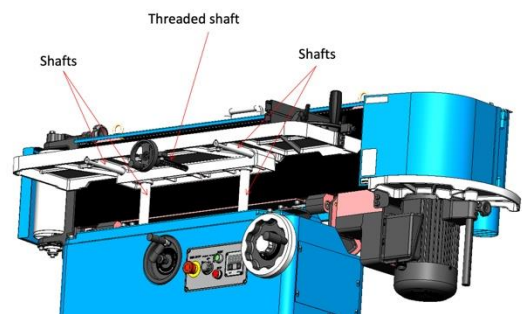
### 4. Bevel gear and shaft



### 5. Rotating shaft



### 6. Table shafts



## Changing Sanding Belt

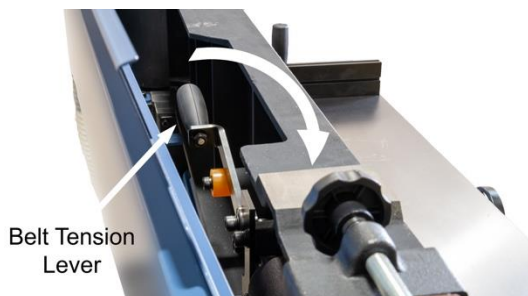
1. Disconnect the machine from the power source.
2. Remove the knobs and open the belt tension lever access door.



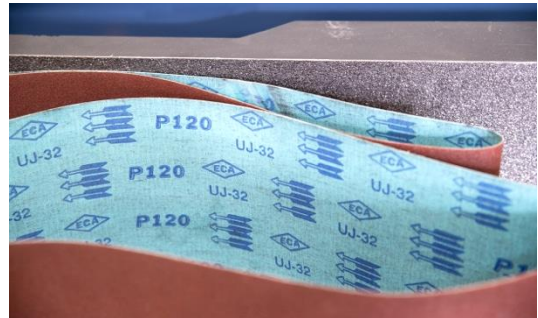
3. Loosen the lock knob under the belt guard to open the guard.



4. Pull up the belt tension lever to release and remove the sanding belt.



5. The sanding belt runs in a counter-clockwise direction. Make sure the arrows on the back of the sanding belt align with the belt running direction.



6. Slip the belt evenly and gradually into both drums until the belt is sitting in the middle of the drums.



7. Tighten the sanding belt by moving the belt tensioning lever back to its original position. When the sanding belt is properly tensioned, it should not slip off from the drums.
8. Close the belt guard and lock the guard with the lock knob.
9. Close the belt tension lever access door. Reinstall the pair of knobs to lock the door.
10. Run the sander with the new sanding belt for 20-30 seconds to make sure the new belt tracks within the platen. If the sanding belt is not tracking properly, **TURN OFF THE SANDER IMMEDIATELY**. See next section, "Belt Tracking Adjustment" if belt tracking needs to be adjusted.

## Belt Tracking Adjustment

Run the sander for 20-30 seconds to observe the tracking of the sanding belt. The sanding belt should track within the platen. If the sanding belt is not tracking properly, **TURN OFF THE SANDER IMMEDIATELY.**

### If adjustment is needed:

1. Turn off the sander.
2. Rotate the belt tracking control knob. Turn the knob clockwise to shift the belt up and vice versa.



3. Adjust belt tracking by rotating the bolt 1/10 turn at a time. Turn on the machine and run the sander for 20-30 seconds to verify the adjustment.
4. Repeat steps 1-3 as needed.



# Troubleshooting

## Mechanical / Electrical Issues

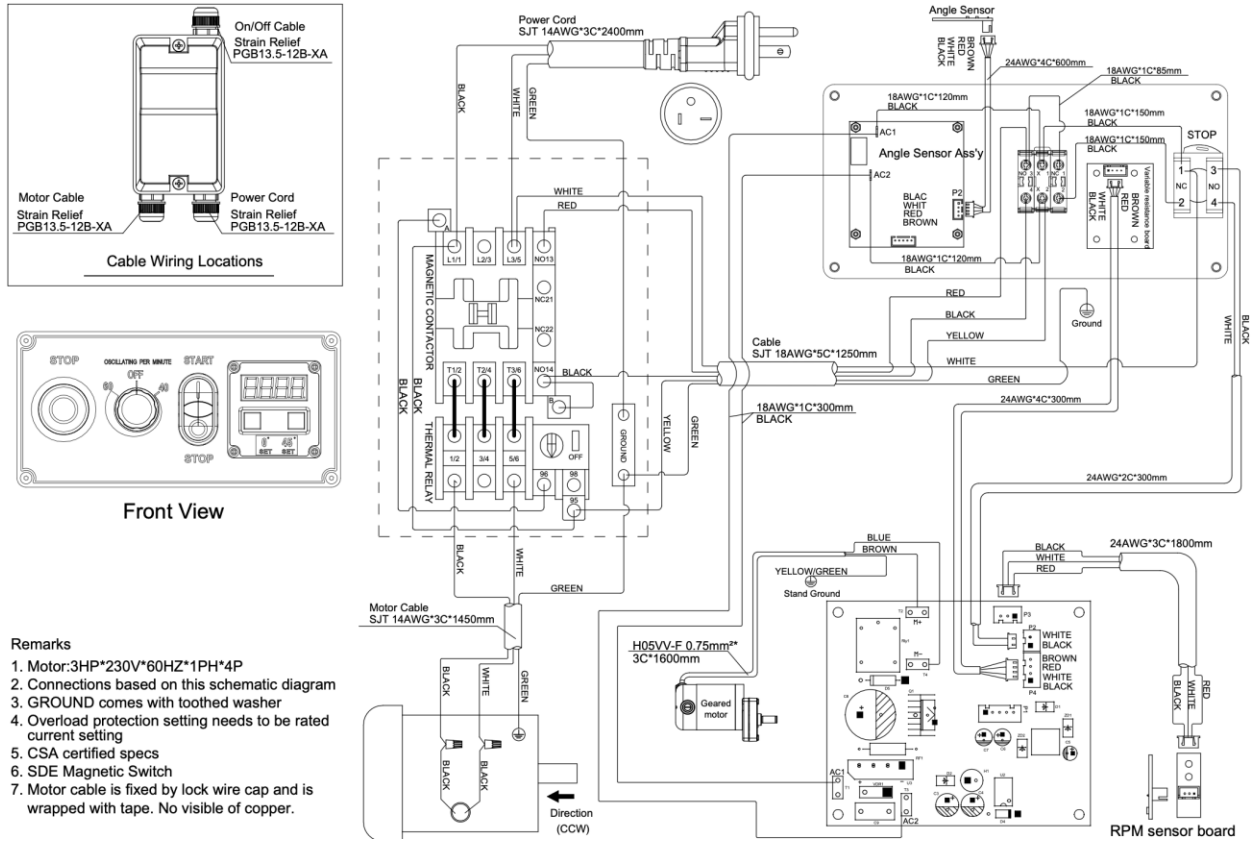
Problem	Possible Cause	Solution
<b>Machine will not start.</b>	Not connected to a power source.	Make sure the machine is plugged in. Check the electrical panel for a tripped circuit breaker or a blown fuse. Ensure all electrical connections have good contacts.
	Low voltage/current.	Have a licensed electrician check/repair the power circuit.
	Faulty switch/motor/capacitor.	Contact customer service for further assistance.
<b>Machine stopped during the operation.</b>	Tripped circuit breaker or blown fuse.	Reconnect circuit. Reduce feed pressure.
	Overload protection mechanism triggered.	Wait 5 minutes for the motor to cool down and the overload protection mechanism to reset automatically before restarting the sander.
<b>Circuit breaker trips frequently.</b>	Feed pressure is too high.	Reduce feed pressure.
	Extension cord is too light or too long.	Use a shorter / heavier cord that meets this machine's electrical requirements.
<b>Machine stalls or does not come up to speed</b>	Extension cord is too light or too long.	Use a shorter / heavier cord that meets this machine's electrical requirements.
	Feed pressure is too high.	Reduce feed pressure.
	Motor is not wired properly for the operating voltage.	Use the wiring diagram to properly wire up the motor.
	Motor/capacitor issue.	Contact customer service for further assistance.
<b>Machine vibrates excessively</b>	Machine stands on uneven floors.	Reposition the machine on a flat, level surface.
	Low sanding belt tension.	Make sure the belt tension lever is fully lowered and the belt tensioning mechanism is not obstructed. Replace broken tension spring as needed.
		Worn/broken sanding belt.
	Improper motor/component mounting.	Check, adjust, and tighten motor/component mounting.
	Motor bearing issue.	Contact customer service for further assistance.

## Operation / Quality-Related Issues

Problem	Possible Cause	Solution
<b>Work pulled from hand.</b>	Inadequate stock support.	Hold the stock firmly against the sanding belt. Use the miter gauge as support. Use special jigs to support the short stock.
	Sanding belt is not perpendicular to the table.	Adjust the sanding belt tilt.
	Digital readout not zeroed.	Set the sanding belt in the upright position and reset the digital readout.
<b>Unable to form a straight edge.</b>	Improper stock feeding.	Ensure stock is pressed firmly against the table when feeding.
	Worn graphite backing.	Apply even and consistent pressure on the entire edge when feeding. Use a straight edge to check the flatness of the platen with the graphite backing. Replace worn graphite backing as needed.
<b>Stock burns</b>	Sanding grit is too fine.	Use a sanding belt with a coarser grit.
	Clogged/worn sanding belt.	Use the sanding belt cleaner to unclog the belt. Replace the sanding belt as needed.
	Feed pressure is too high.	Lower feed pressure.
<b>Sanding belt clogs easily</b>	Sanding softwood or wood with high resin content.	Clean/replace the belt more frequently.
	Sanding wet stock.	Dry stock before sanding.
	Sanding non-wood materials.	Some materials may melt easily when heated. Sand with light pressure and keep it cool when sanding.
<b>Deep sanding marks on the workpiece</b>	Sanding belt grit is too coarse.	Use a finer grit sanding belt.
	Dirty/contaminated sanding belt.	Clean sanding belt. Replace as necessary.
	Too much feeding pressure and/or abrupt feeding.	Reduce feeding pressure and allow more time for the abrasive surface to work on the workpiece.
<b>Abrasive materials rub off the belt easily</b>	Aged sanding belt.	Avoid storing sanding belts in extreme temperatures and humidity, which may cause the belt to fail prematurely. Do not fold or smash the sanding belt, as it may disintegrate the bonding material on the belt.

# Wiring Diagrams

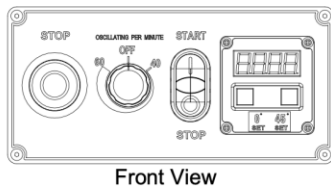
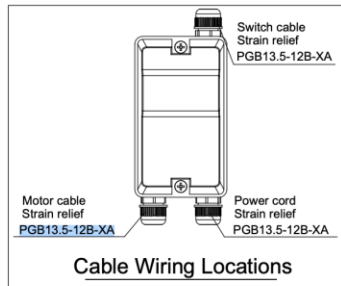
For Stock 6320.001 (230V 1Ph)



**DANGER** Deenergize the electrical circuit before touching any enclosed, electrified parts. Touching an electrified part WILL result in serious personal injury or death.

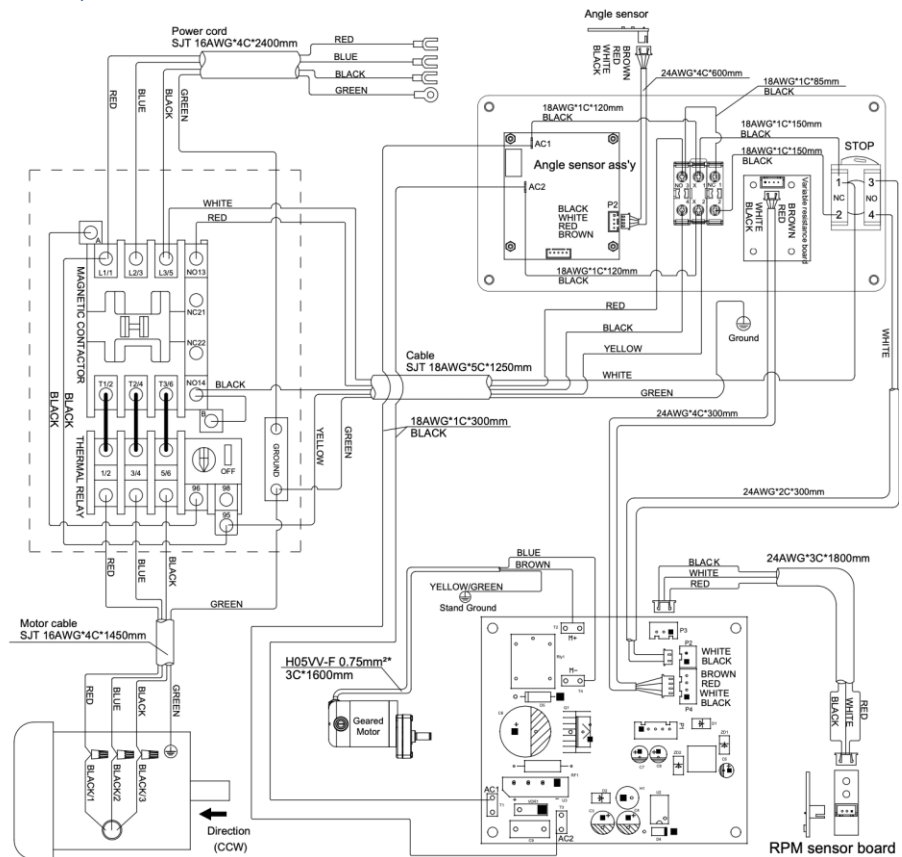
**WARNING** All electrical work must be done by a licensed electrician and must meet the electrical code in your area. Otherwise, the warranty is void.

For Stock 6320.003 (230V, 3Ph)



**Remarks**

1. Motor:3HP\*230V\*60HZ\*3PH\*4P
2. Connections based on this schematic diagram
3. GROUND comes with toothed washer
4. Overload protection setting needs to be rated current setting
5. CSA certified specs
6. SDE MAGNETIC SWITCH
7. Motor cable is fixed by lock wire cap and is wrapped with tape. No visible of copper.

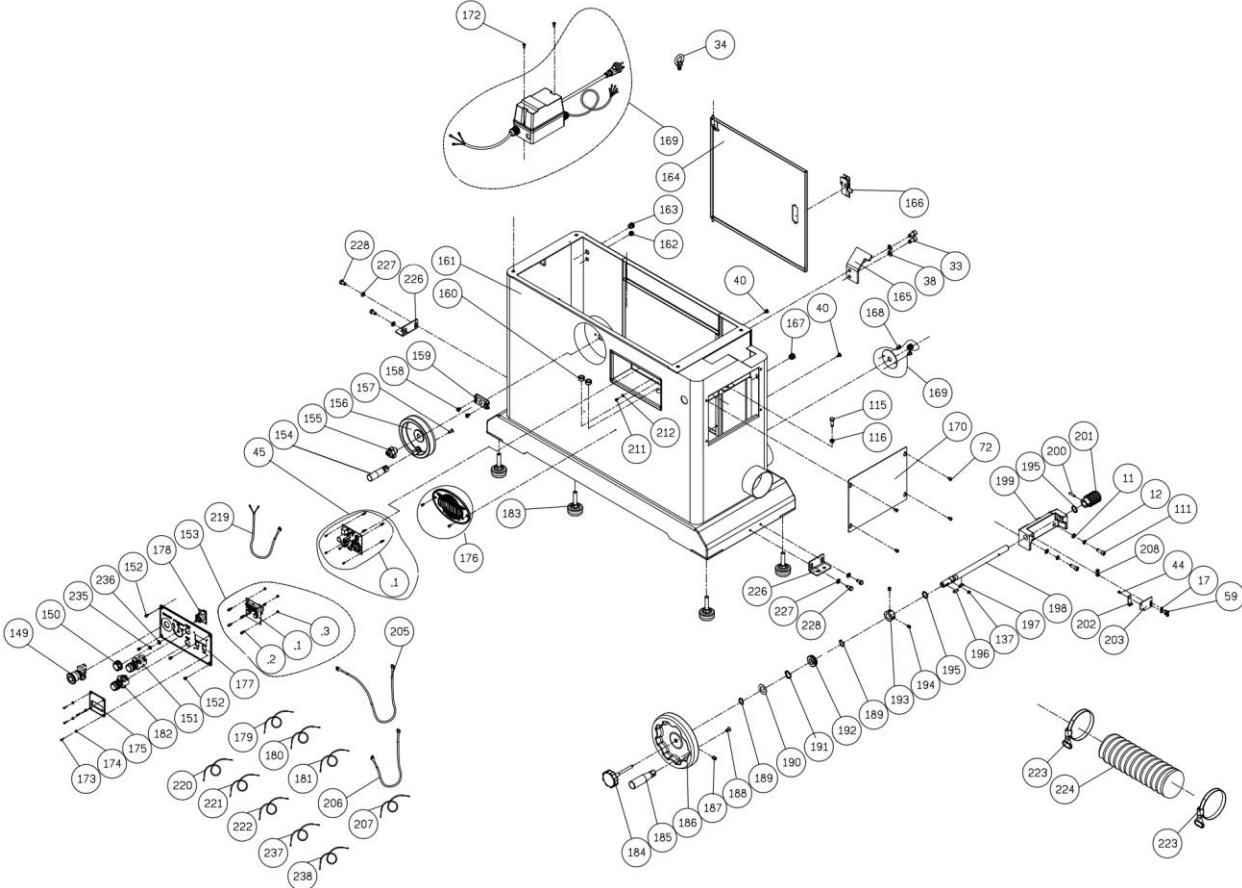


**DANGER** Deenergize the electrical circuit before touching any enclosed, electrified parts. Touching an electrified part WILL result in serious personal injury or death.

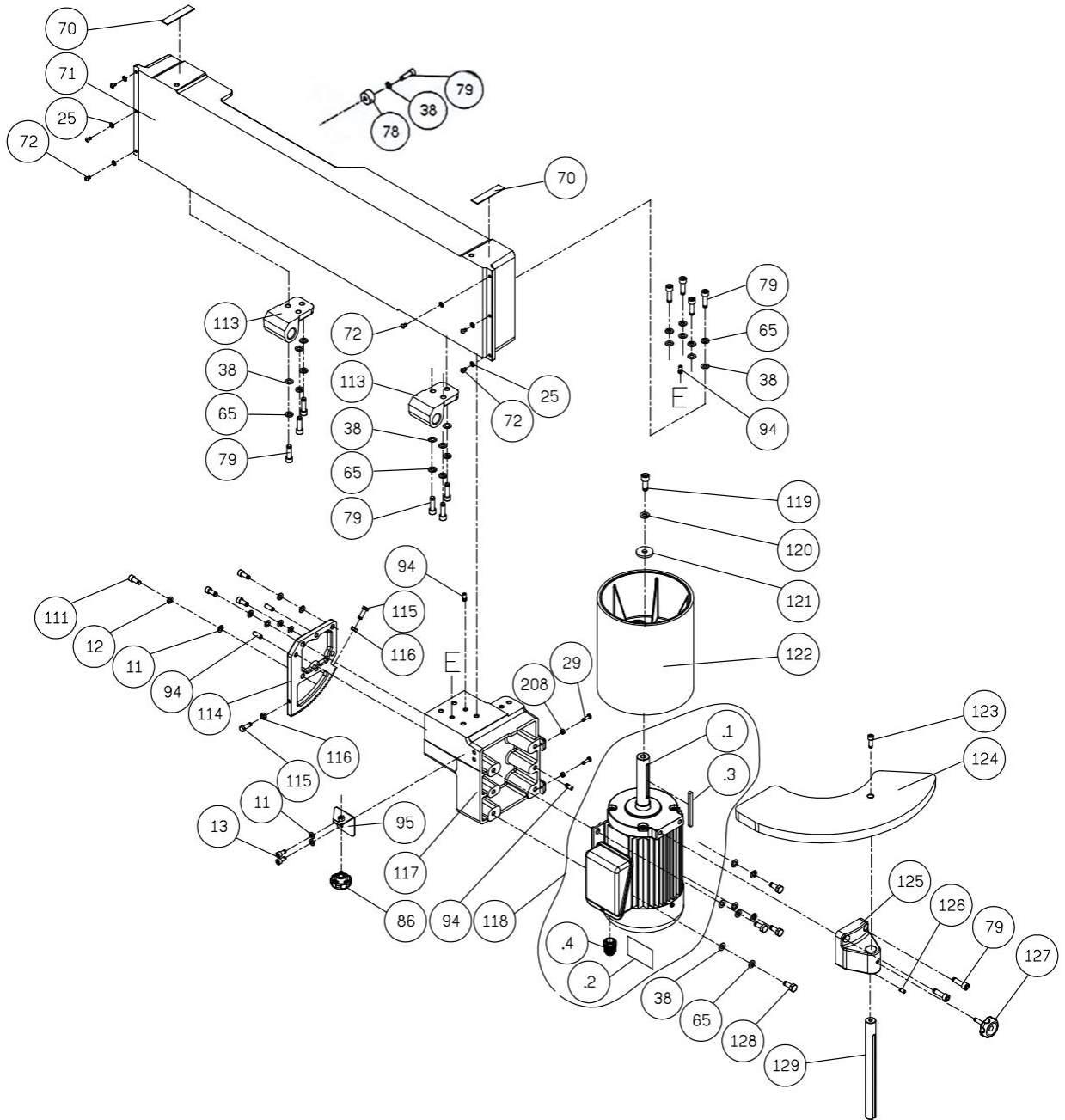
**WARNING** All electrical work must be done by a licensed electrician and must meet the electrical code in your area. Otherwise, the warranty is void.

# Parts List

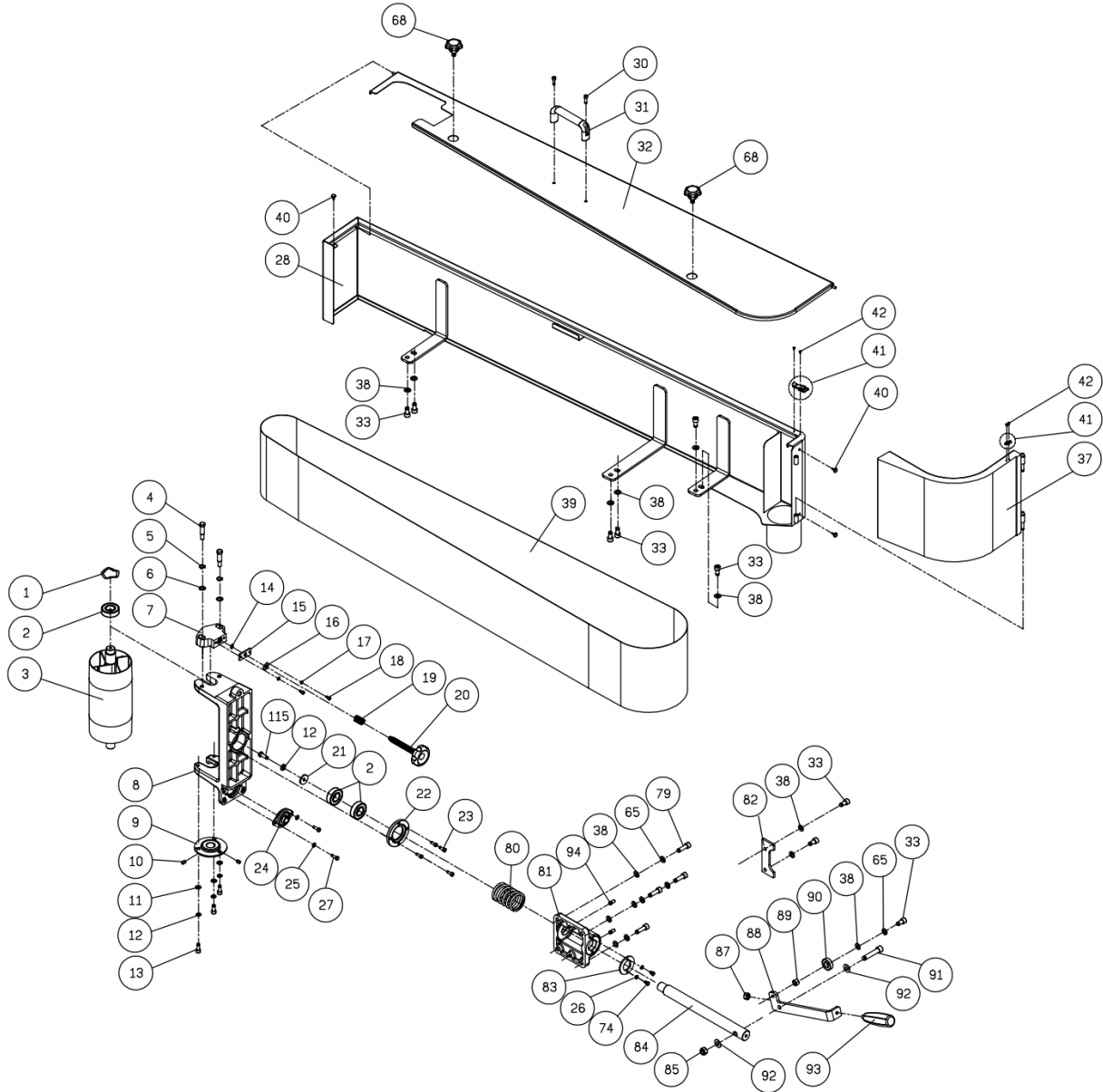
## Cabinet Stand



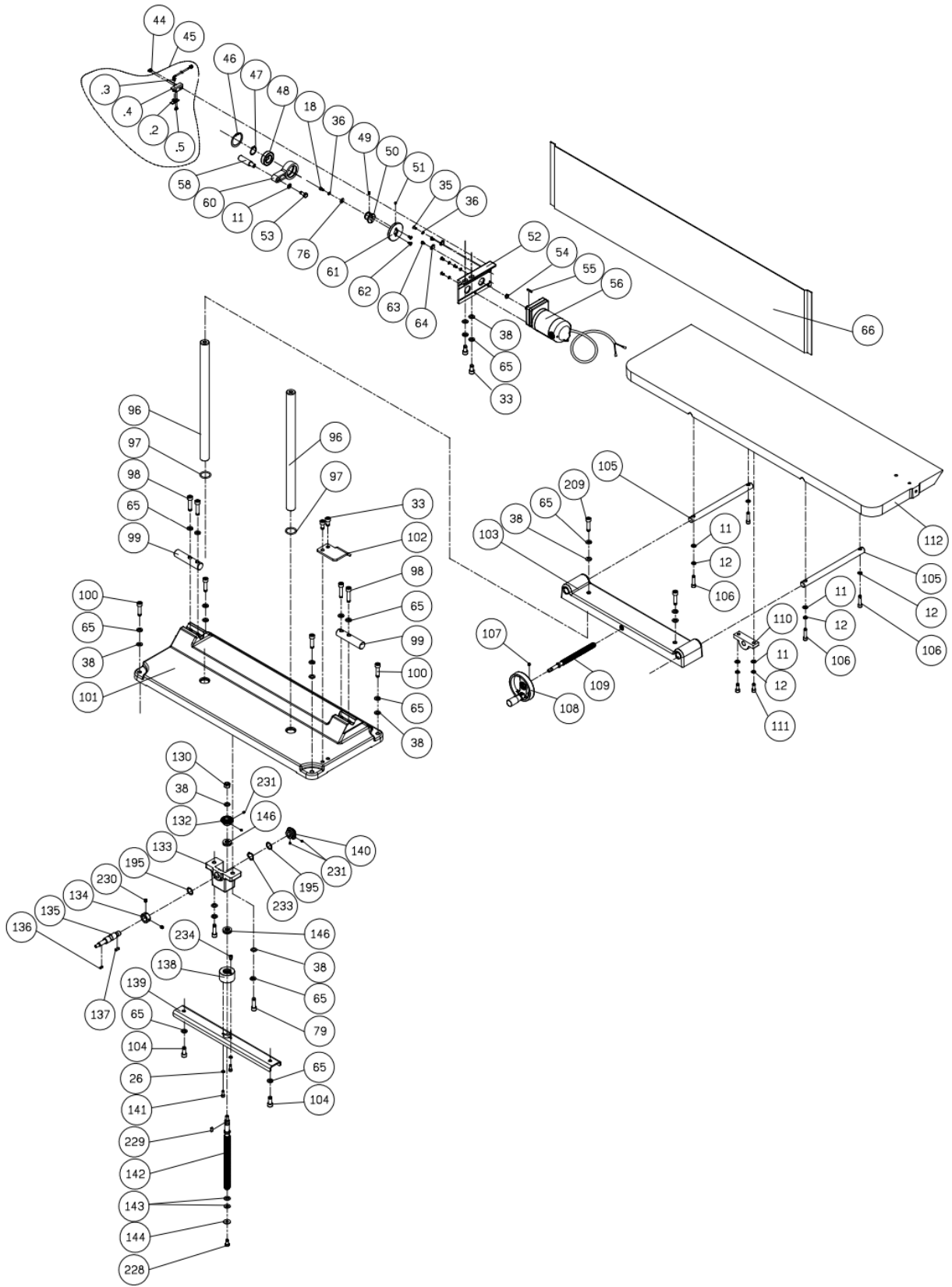
# Head Plate



# Safety Guard System

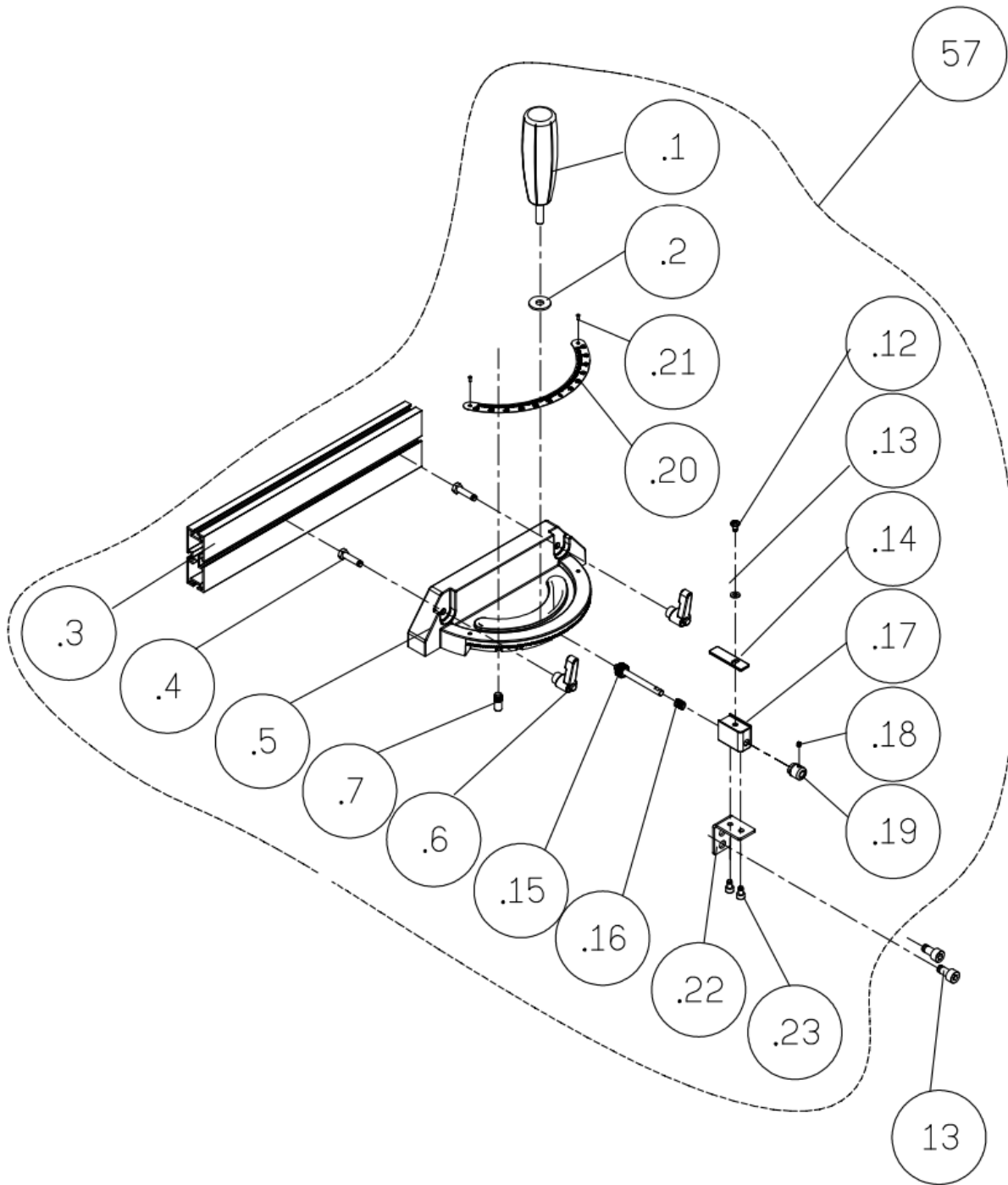








# Miter Gauge



Index	Part Number	Descriptions	QTY
1	006730-100	Wave Washer BWW-6205	1
2	030116-002	Ball Bearing 6205	3
3	925208-000	Abrasive Belt Shaft Assembly	1
4	290009-902	Shoulder Screw	2
5	006704-100	Wave Washer WW-12	2
6	006001-089	Flat Washer 12.1*18.7*1.0t	2
7	051499-901	Block	1
8	051498-000	Idler Bracket	1
9	034601-000	Bearing SBPF205	1
10	000203-102	Set Screw M6*1.0P*8	2
11	006001-046	Flat Washer 8.5*16*1.5t	16
12	006305-100	Spring Washer 8.2*13.7	16
13	000104-104	Cap Screw M8*1.25P*16	7
14	010026-000	Retaining Ring STW-9	1
15	175143-904	Clamper Support	1
16	006001-068	Flat Washer 10*20*2.0t	1
17	006001-009	Flat Washer 5.2*10*1.0t	4
18	000102-103	Cap Screw M5*0.8P*10	3
19	280293-901	Spring	1
20	230426-000	Knob	1
21	006001-043	Packing 8.2*30*4.0t	1
22	381485-901	Bearing Cover	1
23	000103-106	Cap Screw M6*1.0P*16	4
24	034602-000	Bearing SBPFL 203	1
25	006001-022	Flat Washer 6.3*13*1.0t	8
26	006303-100	Spring Washer 6.5*10.5	4
27	000002-106	Hex. screw M6*1.0P*30	2
28	175147-000	Safety Guard	1
29	000002-104	Hex. screw M6*1.0P*20	2
30	000103-107	Cap Screw M6*1.0P*20	2
31	230418-000	Handle B308-132-6S	1
32	175148-000	Safety Cover	1
33	000105-101	Cap Screw M10*1.5P*20	15
34	000604-801	Eye bolt M10*1.5P*20*	2
35	000804-103	Round Head Screw M5*0.8P*10	4
36	006302-100	Spring Washer 5.1*9.3	5

Index	Part Number	Descriptions	QTY
37	175150-000	Dust Hood	1
38	006001-078	Flat Washer 10.5*19*1.5t	41
39	660327-000	Abrasive Belt 9"(230mm)x138-1/2"(3517.9mm),#120	1
40	340007-615	Spacer	5
41	230429-905	0 C-12-A-B	1
42	000404-101	Flat Head Screw M3*0.5P*6	4
44	000301-201	Pan Head Screw M3*0.5P*6	3
45	950892-000	PC Board	1
45.1	950893-000	Control Driver Board Assembly	1
45.2	491248-000	Speed Detector Substrate MH253	1
45.3	473048-009	Connect Wire 24AWG*3C*1800mm	1
45.4	175227-000	Clamper Support	1
45.5	000301-201	Pan Head Screw M3*0.5P*6	2
46	010107-000	Retaining Ring RTW-47	1
47	010011-000	Retaining Ring STW-25	1
48	030104-001	Ball Bearing 6005	1
49	001902-102	Set Screw M6*1.0P*8	1
50	381490-901	Bushing	1
51	660220-000	Magnetic Iron N35	1
52	310591-909	Fixed Plate	1
53	000003-104	Hex. screw M8*1.25P*20	1
54	010003-000	Retaining Ring STW-12	1
55	012201-002	Key 4*4*20	1
56	499024-000	Geared Motor 1/30HP*200VDC*0.27A*44RPM	1
57	925221-000	Miter Gauge Assembly	1
57.1	230191-000	Handle	1
57.2	006002-056	Flat Washer 8.5*23*2t	1
57.3	310500-911	Fence	1
57.4	003001-102	Hex. screw 1/4"20NC*1"	2
57.5	090342-008	Miter gauge body	1
57.6	230408-000	Lock Handle	2
57.7	360355-901	Pin	1
57.12	000303-202	Pan Head Screw M5*0.8P*8	1
57.13	006002-009	Flat Washer 5.2*10*1.0t	1
57.14	251305-620	Pointer	1
57.15	924563-000	Mobile Wheel Assembly	1

Index	Part Number	Descriptions	QTY
57.16	280272-000	Spring	1
57.17	130378-903	Spacer	1
57.18	000201-105	Set Screw M4*0.7P*4	1
57.19	381388-904	Handle	1
57.20	574852-000	Fence Scale	1
57.21	002301-201	Rivet 2*5	2
57.22	175158-904	Fixed Plate	1
57.23	000102-102	Cap Screw M5*0.8P*8	2
58	361488-901	Shaft	1
59	000303-106	Pan Head Screw M5*0.8P*16	2
60	310592-909	Crank	1
61	381491-904	Fixing Plate	1
62	000705-104	Socket Hex. Screw M4*0.7*10	2
63	000303-102	Pan Head Screw M5*0.8P*8	2
64	021107-100	Wire Holder UC0.5BK	2
65	006307-100	Spring Washer 10.2*18.5	35
66	660328-000	Graphite Cloth	1
68	230438-000	Trox Knob S201-50-10-16	2
70	200118-615	Foam	2
71	051492-000	Fence	1
72	000801-101	Round Head Screw M6*1.0P*10	10
74	000002-101	Hex. screw M6*1.0P*12	2
76	006001-137	Flat Washer 5.3*16*1.5t	1
78	340140-000	Crash Pad	1
79	000105-104	Cap Screw M10*1.5P*35	19
80	280292-901	Spring	1
81	051493-901	Rod Seat	1
82	381492-904	Slot Bar	1
83	330072-000	Fence Block	1
84	361481-901	Connect Bar	1
85	008311-100	Anit-loose Nut M12*1.75P	1
86	230255-000	Knob	1
87	008007-100	Hex Nut M10*1.5P(17B*8H)	1
88	175154-904	Handle	1
89	381487-901	Bushing Sleeve	1
90	030102-001	Ball Bearing 6003	1

Index	Part Number	Descriptions	QTY
<b>91</b>	000106-101	Cap Screw M12*1.75P*60	1
<b>92</b>	006001-087	Flat Washer 12*25*1.5t	2
<b>93</b>	230301-615	Handle	1
<b>94</b>	360355-901	Pin	7
<b>95</b>	175161-904	Fixed Plate	1
<b>96</b>	361483-000	Up-Down Column	2
<b>97</b>	043329-000	O-Ring P30	2
<b>98</b>	000105-112	Cap Screw M10*1.5P*45	4
<b>99</b>	361484-901	Fix Shaft Bolt	2
<b>100</b>	000105-105	Cap Screw M10*1.5P*40	4
<b>101</b>	051502-000	Base	1
<b>102</b>	175159-904	Front Fixing Plate	1
<b>103</b>	051501-000	Clamper Support	1
<b>104</b>	002604-102	Pand Head Lock Screw M10*1.5P*25	4
<b>105</b>	361482-000	Table Column	2
<b>106</b>	000104-111	Cap Screw M8*1.25P*35	4
<b>107</b>	000202-101	Set Screw M5*0.8P*5	2
<b>108</b>	240098-000	Handlewheel Assembly W401-100-B10	1
<b>109</b>	361487-901	Lead Screw	1
<b>110</b>	051506-901	Spreader Bracket	1
<b>111</b>	000104-108	Cap Screw M8*1.25P*25	8
<b>112</b>	051500-000	Table	1
<b>113</b>	051497-901	Turning	2
<b>114</b>	051495-000	Gear Rotary Plate	1
<b>115</b>	000003-105	Hex. screw M8*1.25P*25	4
<b>116</b>	008006-100	Hex Nut M8*1.25P(13B*6.5H)	3
<b>117</b>	051494-000	Motor Bracket	1
<b>118</b>	901357-000	Motor Assembly 3HP*230V*60HZ*1PH*4P	1
<b>118.1</b>	603198-000	Motor 3HP*230V*60HZ*1PH*4P*12A	1
<b>118.1.1</b>	496329-000	Start Capacitor 300MFD/250VAC(LAI)(45*90)	1
<b>118.1.2</b>	496258-000	Run Capacitor 50UF/350VAC(LAI)(45*86)	1
<b>118.1.3</b>	496197-000	Capacitor Cover ID45	3
<b>118.1.4</b>	496330-000	Centrifugal Switch 4P(ID19)*60HZ	1
<b>118.1.5</b>	496331-000	Centrifugal Switch Plate	1
<b>118.1.6</b>	496297-000	Centrifugal Switch Cover	1

Index	Part Number	Descriptions	QTY
118.1.7	496332-000	Fan ID19*OD150*9F	1
118.1.8	496326-000	Motor End Cover	1
118.1.9	496324-000	Junction Box- Base	1
118.1.10	496325-000	Outlet Box Base	1
118.1.11	496012-000	Packing 70.5L	1
118.1.12	021206-000	Wire Lug SW-P4	2
118.1.13	003303-105	Pan Head Screw 3/16"-24NC*3/8"	1
118.2	589055-000	Motor Label 3HP*230V*60HZ*1PH*4P	1
118.3	012203-012	Key 8*7*100	1
118.4	023705-011	Strain Relief Bushing PGB13.5-12B	1
119	000106-110	Cap Screw M12*1.75P*30	1
120	006308-100	Spring Washer 12.2*21.6	1
121	172285-905	Flat Washer 13*35*5.0t	1
122	090385-000	Drive Roller	1
123	002601-107	Pand Head Lock Screw M8*1.25P*25	1
124	051496-000	Contour Table	1
125	051504-901	Support Rod Seat	1
126	001902-105	Set Screw M6*1.0P*12	1
127	230004-000	Knob	1
128	000004-102	Hex. screw M10*1.5P*25	4
129	361480-901	Column	1
130	008307-100	Anit-loose Nut M10*1.25P(17B*12H)	1
132	380767-000	Bevel Gear	1
133	051503-901	Elevation Bracket	1
134	360376-901	Fix Ring	1
135	361485-901	Transmission Shaft	1
136	012002-005	Key 4*4*12	1
137	012002-003	Key 4*4*8	2
138	381488-901	Up-Down Seat Nut	1
139	175156-904	Up-Down Fixing Plate	1
140	380768-000	Bevel Gear	1
141	002602-103	Pand Head Lock Screw M6*1.0P*16	2
142	361486-901	Elevation Lead Screw	1
143	006006-120	Flat Washer 20*10.2±0.1*2±0.1	2

Index	Part Number	Descriptions	QTY
144	006001-056	Flat Washer 8.5*23*2.0t	1
146	031005-001	Ball Bearing 51102	2
149	491256-000	Emergency Stop Switch NPB22-H11R	1
150	230389-615	Speed Knob	1
151	490183-000	Illuminated Start Switch 220V	1
152	000804-101	Round Head Screw M5*0.8P*8	4
153	950891-000	Angle Sensor Assembly	1
153.1	491222-000	Switch Plate	1
153.2	491160-000	Plastic Bolt HTS-308(M3) (KSS)	4
153.3	491166-000	Plastic Nut PN-3(M3) (KSS)	4
154	230284-000	Handle HL-65	1
155	920703-000	Fixing Knob	1
156	090392-008	Handwheel	1
157	000702-104	Socket Hex. Screw M6*1.0P*16	1
158	001603-102	Pan Head Screw w/Washer M6*1.0P*10/6*13.2*1.0t	2
159	250407-615	Worm Support Seat	2
160	021801-000	Strain Relief NB-1722	2
161	175144-000	Cabinet	1
162	020013-000	Strain Relief SB5M-2	1
163	020001-000	Strain Relief SB6R-3	1
164	175152-000	Door	1
165	175160-904	Rear Fixing Plate	1
166	230134-000	Latch	1
167	020003-000	Strain Relief SB7R-3	1
168	000304-102	Pan Head Screw M6*1.0P*10	2
169	938129-000	Magnetic Switch Assembly 3HP*230V*1PH	1
170	175194-000	Side Cover	1
172	003303-205	Pan Head Screw 3/16"-24NC*3/8"	2
173	000301-202	Pan Head Screw M3*0.5P*12	4
174	006002-139	Flat Washer 3*8*1.0t	4
175	250839-620	DRO Transparent Cover	1
177	925222-000	Control Panel	1
178	491209-000	Variable resistor group 10KΩ	1
179	471037-130	Connect Cord 18AWG*1C*300mm	1
180	471037-131	Connect Cord 18AWG*1C*150mm	1
181	471037-136	Connect Cord 18AWG*1C*85mm	1

Index	Part Number	Descriptions	QTY
182	491263-000	Stop Switch YS-F1-4*(10A 250V)(7.5A 380V)	1
183	230403-000	Foot	4
184	230171-916	Lock Handle	1
185	230046-000	Handle	1
186	240096-000	Handwheel	1
187	000203-104	Set Screw M6*1.0P*12	1
188	000702-102	Socket Hex. Screw M6*1.0P*12	1
189	010010-000	Retaining Ring STW-20	2
190	006001-191	Flat Washer 21*37*1t	1
191	006711-100	Wave Washer WW-20	1
192	660228-000	Magnetic Ring	1
193	361511-901	Spacer	1
194	001903-104	Set Screw M8*1.25P*10	2
195	006006-106	Flat Washer 19.1*25.4*1.6	4
196	012003-006	Key 5*5*18	1
197	130061-000	Key	1
198	361510-901	Angel Worm Shaft	1
199	050582-008	Worm Shaft Support	1
200	011003-107	Spring Pin 5*30	1
201	360371-901	Worm Shaft	1
202	491221-000	Angle Detector Substrate	1
203	175153-000	Fixed Plate	1
204	000101-101	Cap Screw M4*0.7P*8	2
205	474048-019	Connect Wire 24AWG*4C*600mm	1
206	474048-020	Connect Wire 24AWG*4C*300mm	1
207	471037-133	Connect Cord 18AWG*1C*150mm	1
208	008005-100	Hex Nut M6*1.0P(10B*5H)	4
209	002604-104	Pand Head Lock Screw M10*1.5P*30	2
211	000302-102	Pan Head Screw M4*0.7P*8	1
212	006501-100	Tooth Washer 4.3*8.5(BW-4)	1
219	472048-026	Connect Wire 24AWG*2C*300mm	1
220	471037-132	Connect Cord 18AWG*1C*300mm	1
221	471037-134	Connect Cord 18AWG*1C*120mm	1
222	471037-135	Connect Cord 18AWG*1C*120mm	1
223	042605-000	Clamp 4"	2



Index	Part Number	Descriptions	QTY
<b>224</b>	042620-018	Tube 4**1000mm	1
<b>226</b>	175233-000	Fence Block	2
<b>227</b>	006001-049	Flat Washer 8.5*16*2.0t	4
<b>228</b>	000003-102	Hex. screw M8*1.25P*16	5
<b>229</b>	012003-005	Key 5*5*16	1
<b>230</b>	004403-103	Set Screw 5/16"-18NC*5/16"	2
<b>231</b>	001901-101	Set Screw M5*0.8P*5	4
<b>233</b>	006712-100	Wave Washer BWW-6001	1
<b>234</b>	000103-101	Cap Screw M6*1.0P*8	1
<b>235</b>	008039-200	Hex Nut M8*0.75P(11B*2H)	1
<b>236</b>	006002-211	Flat Washer 8.1*13*0.5t	1
<b>237</b>	471037-150	Connect Cord 18AWG*1C*150mm	1
<b>238</b>	471037-151	Connect Cord 18AWG*1C*250mm	1









# Warranty and Service

Oliver Machinery makes every effort to assure that its equipment meets the highest possible standards of quality and durability. All products sold by Oliver Machinery are warranted to the original customer to be free from defects for a period of two (2) years on all parts excluding electronics and motors which are warranted for one (1) year from the date of shipment. Oliver Machinery's obligation under this warranty shall be exclusively limited to repairing or replacing products or parts or components, at its sole option, determined by Oliver Machinery to be defective. Oliver Machinery shall not be required to provide other form of indemnity or compensation including but not limited to compensatory damages.

This warranty does not apply to defects due to direct or indirect misuse, abuse, negligence, accidents, unauthorized repairs, alternation outside our facilities, lack of maintenance, acts of nature, or items that would normally be consumed or require replacement due to normal wear and tear.

## **OTHER TERMS**

To obtain and exercise the warranty right, please call 800-559-5065 or fill out warranty request form online at [www.olivermachinery.net](http://www.olivermachinery.net).

Warranty parts are shipped via Parcel or Ground. Additional charges will occur and charge to customers if express shipping is required.

## **DISCLAIMER**

Under no circumstances shall Oliver Machinery be liable for death, personal or property injury, or damages arising from the use of its products.

Oliver Machinery reserves the right to make changes without prior notice to its products to improve function or performance or design.

## **FOR MORE INFORMATION**

If you need assistance or have questions beyond what is covered in the scope of this warranty information, please call 800-559-5065 or email us at [info@olivermachinery.net](mailto:info@olivermachinery.net).







Oliver Machinery is always adding new Industrial Woodworking products to the line.

For complete, up-to-date product information, visit us online at:

[WWW.OLIVERMACHINERY.NET](http://WWW.OLIVERMACHINERY.NET)

or call toll-free 1-800-559-5065

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