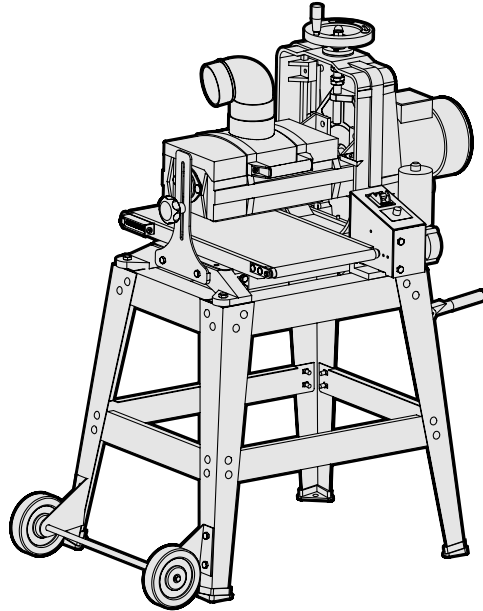




**MODEL 65911**

# 10-INCH DRUM SANDER



For replacement parts visit  
**WENPRODUCTS.COM**

## IMPORTANT:

Your new tool has been engineered and manufactured to WEN's highest standards for dependability, ease of operation, and operator safety. When properly cared for, this product will supply you years of rugged, trouble-free performance. Pay close attention to the rules for safe operation, warnings, and cautions. If you use your tool properly and for its intended purpose, you will enjoy years of safe, reliable service.

## NEED HELP? CONTACT US!

Have product questions? Need technical support?  
Please feel free to contact us at:



**800-232-1195** (M-F 8am-5pm CST)



**techsupport@wenproducts.com**



**WENPRODUCTS.COM**



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## SPECIFICATIONS

Model Number	65911
Motor	120V, 60Hz, 10.5A
Drum Speed	1700 RPM (60Hz)
Sandpaper Speed	2300 FPM
Conveyor Feed Speed	0 to 10 FPM
Maximum Workpiece Width	9-7/8" (250mm)
Minimum Workpiece Width	3/4" (19mm)
Maximum Workpiece Height	3-1/8" (80mm)
Minimum Workpiece Height	3/16" (5mm)
Minimum Workpiece Length	4-3/4" (120mm)
Sandpaper Width	3-1/4" (82mm)
Sandpaper Length	62-1/2" (1585mm)
Sanding Drum Size	5-1/8" x 10-1/4" (132mm x 260mm)
Dust Port Diameter	4" (101.6mm)
Floor-to-Conveyor Height	30-1/4"
Assembled Dimension	28-3/8" x 23-1/4" x 47-1/4"
Weight	161 lbs


**NOTE:** Your drum sander is compatible with the WEN 28200 10 ft. dust hose and the WEN 28221 20 ft. dust hose, available at [wenproducts.com](http://wenproducts.com).

Sandpaper may be purchased from [wenproducts.com](http://wenproducts.com) by searching 65910.

## INTRODUCTION

---

Thanks for purchasing the WEN drum sander. We know you are excited to put your tool to work, but first, please take a moment to read through the manual. Safe operation of this tool requires that you read and understand this operator's manual and all the labels affixed to the tool. This manual provides information regarding potential safety concerns, as well as helpful assembly and operating instructions for your tool.

 **WARNING:** Indicates danger, warning, or caution. The safety symbols and the explanations with them deserve your careful attention and understanding. Always follow the safety precautions to reduce the risk of fire, electric shock and personal injury. However, please note that these instructions and warnings are not substitutes for proper accident prevention measures.

**NOTE:** The following safety information is not meant to cover all possible conditions and situations that may occur. WEN reserves the right to change this product and specifications at any time without prior notice.

**Keep this manual available to all users during the entire life of the tool and review it frequently to maximize safety for both yourself and others.**

# GENERAL SAFETY RULES

**Safety is a combination of common sense, staying alert, and knowing how your item works. SAVE THESE SAFETY INSTRUCTIONS.**

**⚠ WARNING:** Read and understand all warnings, cautions and operating instructions before using this tool. Failure to follow all instructions listed below may result in personal injury and tool damage.

## WORK AREA SAFETY

1. Keep work area clean and well lit. Cluttered or dark areas invite accidents.
2. Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
3. Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
4. Keep children and bystanders away while operating a power tool.

## ELECTRICAL SAFETY

1. Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
2. Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
3. Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.
4. If operating a power tool in a damp location is unavoidable, use a ground fault circuit interrupter (GFCI) protected supply. Use of a GFCI reduces the risk of electric shock.

## PERSONAL SAFETY

1. Stay alert. Watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
2. Do not wear loose clothing, gloves, neckties, or jewelry (rings, watches, etc.) when operating the tool. Inappropriate clothing and items can get caught in moving parts and draw you in. Always wear non-slip footwear and tie back long hair.
3. Use personal protective equipment. Always wear safety goggles at all times that comply with ANSI Z87.1. Use ear protection such as plugs or muffs during extended periods of operation. Wear a face mask or dust mask to fight the dust.
4. Keep proper footing and balance at all times and do not overreach when operating the power tool.

# GENERAL SAFETY RULES

**⚠ WARNING:** Dust generated from certain materials can be hazardous to your health. Always operate the tool in a well-ventilated area and wear a dust mask. Use dust collection systems when processing wood and plastics. Dust extractors or dust bags must not be connected when processing metals.

## POWER TOOL USE AND CARE

1. Avoid accidental start-ups. Make sure the power switch is in the OFF position before connecting the plug to a power source or carrying the tool.
2. Check power tool for damaged parts. Check for misalignment of moving parts, jamming, breakage, improper mounting, or any other conditions that may affect the tool's operation. Do not use the power tool if the switch does not turn ON/OFF. Any part that is damaged should be properly repaired or replaced before use.
3. Do not force the tool to do a job for which it was not designed. Always use the correct tool/ accessory for the job and follow instructions to prevent a hazardous situation.
4. Never stand on the tool. Serious injury could occur if the tool is tipped over or if parts of the tool are unintentionally contacted.
5. Remove adjustment tools. Always make sure all adjustment tools or wrenches are removed from the tool before turning on the power tool.
6. Keep guards in place and in working order before operating the tool. All protection and safety devices must be in place after completing repair and maintenance procedures.
7. Never leave a running tool unattended. Do not leave the tool until it has come to a complete stop.

## SERVICE

Have your power tool serviced by a qualified repair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.

This product and some dust created by power sanding, sawing, grinding, drilling, and other construction activities may contain chemicals, including lead, known to the State of California to cause cancer, birth defects, or other reproductive harm. Wash hands after handling.

## CALIFORNIA PROPOSITION 65 WARNING

This product and some dust created by power sanding, sawing, grinding, drilling, and other construction activities may contain chemicals, including lead, known to the State of California to cause cancer, birth defects, or other reproductive harm. Wash hands after handling.

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.

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 with approved safety equipment such as dust masks specially designed to filter out microscopic particles.

# ELECTRICAL INFORMATION

## GROUNDING INSTRUCTIONS

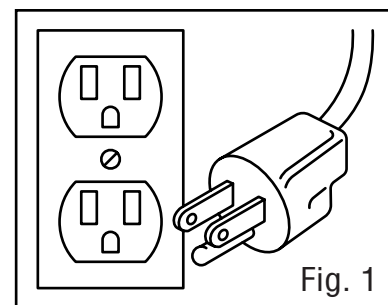
IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides the path of least resistance for an electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching outlet that is properly installed and grounded in accordance with ALL local codes and ordinances.

**DO NOT MODIFY THE PLUG PROVIDED.** If it will not fit the outlet, have the proper outlet installed by a licensed electrician. Make certain that the outlet in question is properly grounded, if you are unsure have a licensed electrician check the outlet.

**IMPROPER CONNECTION** of the equipment grounding conductor can result in electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment grounding conductor. If repair or replacement of the electric cord or plug is necessary, **DO NOT** connect the equipment grounding conductor to a live terminal.

**CHECK** with a licensed electrician or service personnel if you do not completely understand the grounding instructions or whether the tool is properly grounded.

**USE ONLY THREE-WIRE EXTENSION CORDS** that have three-pronged plugs and outlets that accept the tool's plug as shown in Fig. 1. Repair or replace a damaged or worn cord immediately.



**⚠ WARNING:** This tool is for indoor use only. Do not expose to rain or use in damp locations.

## GUIDELINES AND RECOMMENDATIONS FOR EXTENSION CORDS

When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. The table below shows the correct size to be used according to cord length and ampere rating. When in doubt, use a heavier cord. The smaller the gauge number, the heavier the cord.

AMPERAGE	REQUIRED GAUGE FOR EXTENSION CORDS			
	25 ft.	50 ft.	100 ft.	150 ft.
10.5A	16 gauge	16 gauge	14 gauge	12 gauge

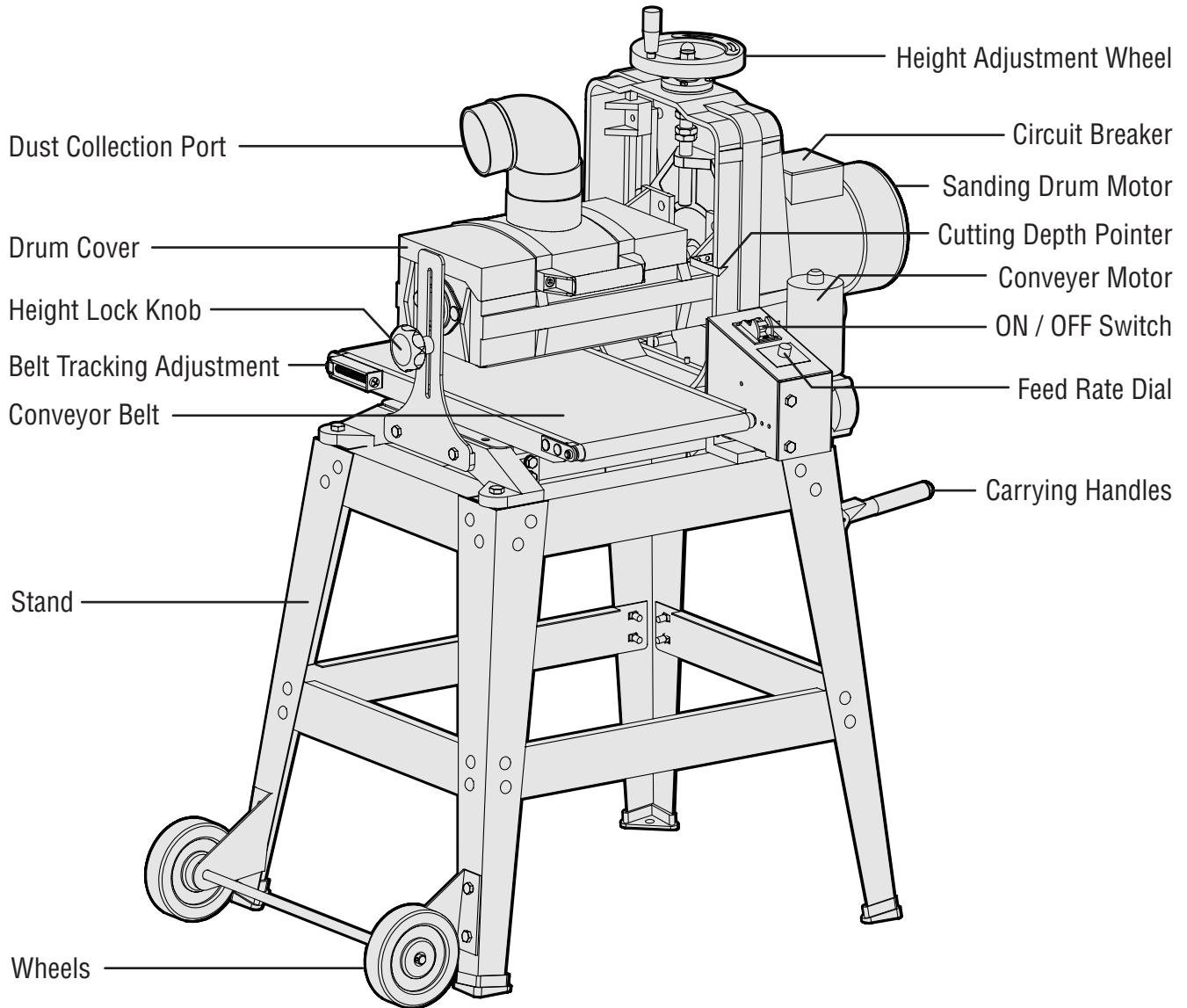
1. Examine extension cord before use. Make sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it.
2. Do not abuse extension cord. Do not pull on cord to disconnect from receptacle; always disconnect by pulling on plug. Disconnect the extension cord from the receptacle before disconnecting the product from the extension cord. Protect your extension cords from sharp objects, excessive heat and damp/wet areas.
3. Use a separate electrical circuit for your tool. This circuit must not be less than a 12-gauge wire and should be protected with a 15A time-delayed fuse. Before connecting the motor to the power line, make sure the switch is in the OFF position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.

## SPECIFIC RULES FOR DRUM SANDERS

- 1. INSPECT THE TOOL.** Before operation, check the tool for any damage or missing parts. Make sure all adjustments are correct and all connections are tight. Do not use the tool if any part is missing or damaged. Check the conveyor belt to make sure there is no debris or sawdust between components. Never sand with the sanding drum cover open or safety guards removed.
- 2. PERSONAL SAFETY.** Never put any body parts into the dust port or close to the sanding drum, as serious injury may occur. Always keep hands at a safe distance from the sanding drum when feeding the workpiece.
- 3. STANDING POSITION.** To avoid serious injury from kickback, do not stand in line with the infeed or outfeed sides of the sander. Keep your body to the side of the sanding path.
- 4. INSPECT YOUR WORKPIECE.** The sander is designed to sand only natural wood products or man-made products made from natural wood fiber. Make sure the workpiece is free from nails, knots, screws, stones or other foreign objects, as they may eject from the sander at a high speed and injure the operator. There should be no loose knots and as few tight knots as possible in the stock.
- 5. DEPTH OF CUT.** The sander can only remove 1/32 inches (0.8mm) of materials or less in each pass. Attempting to take greater depth of cut than 1/32 inches could result in kickback that can cause serious personal injury and machine damage.
- 6. WORKPIECE DIMENSIONS.** To maintain stable operation, do not sand materials shorter than 4-3/4 inches (120mm) or narrower than 3/4 inches (19mm).
- 7. WORKPIECE QUANTITY.** Never sand two or more workpieces side-by-side. No two workpieces are exactly the same thickness. One of them may be shot out from the sander at high speed and cause injury.
- 8. WORKPIECE SUPPORT.** Support the workpiece properly during operation. Insufficient support could cause the workpiece to kick back. Maintain control of the workpiece on both the infeed and outfeed sides of the sander at all times. Work with another person if necessary to support the workpiece on both ends of the machine.
- 9. WORKPIECE FEED RATE.** Set the proper feed rate for your purposes. Setting the feed rate too fast may cause kickback during operation.
- 10. FEEDING THE WORKPIECE.** Allow the sanding drum to reach full speed before feeding the workpiece. The workpiece can only be fed from the infeed side against the rotation direction of the drum. Carefully hold the workpiece on the conveyor and ease it into the sander. Do not force feed the workpiece through the machine. Do not try to back the workpiece from the infeed table.
- 11. MAKING ADJUSTMENTS.** Always turn off the machine and disconnect from the power source before making adjustments or changing sandpaper.
- 12. SANDPAPER INSTALLATION.** Make sure the sandpaper is attached correctly according to the instructions. Improperly installed sandpaper could come loose during operation and damage the workpiece and the machine.

# KNOW YOUR DRUM SANDER

Use the diagram below to become familiarized with the components and controls of your drum sander. If you have any questions or concerns, please contact our Customer Service at (800) 232-1195, M-F 8-5 CST or email us at [techsupport@wenproducts.com](mailto:techsupport@wenproducts.com).

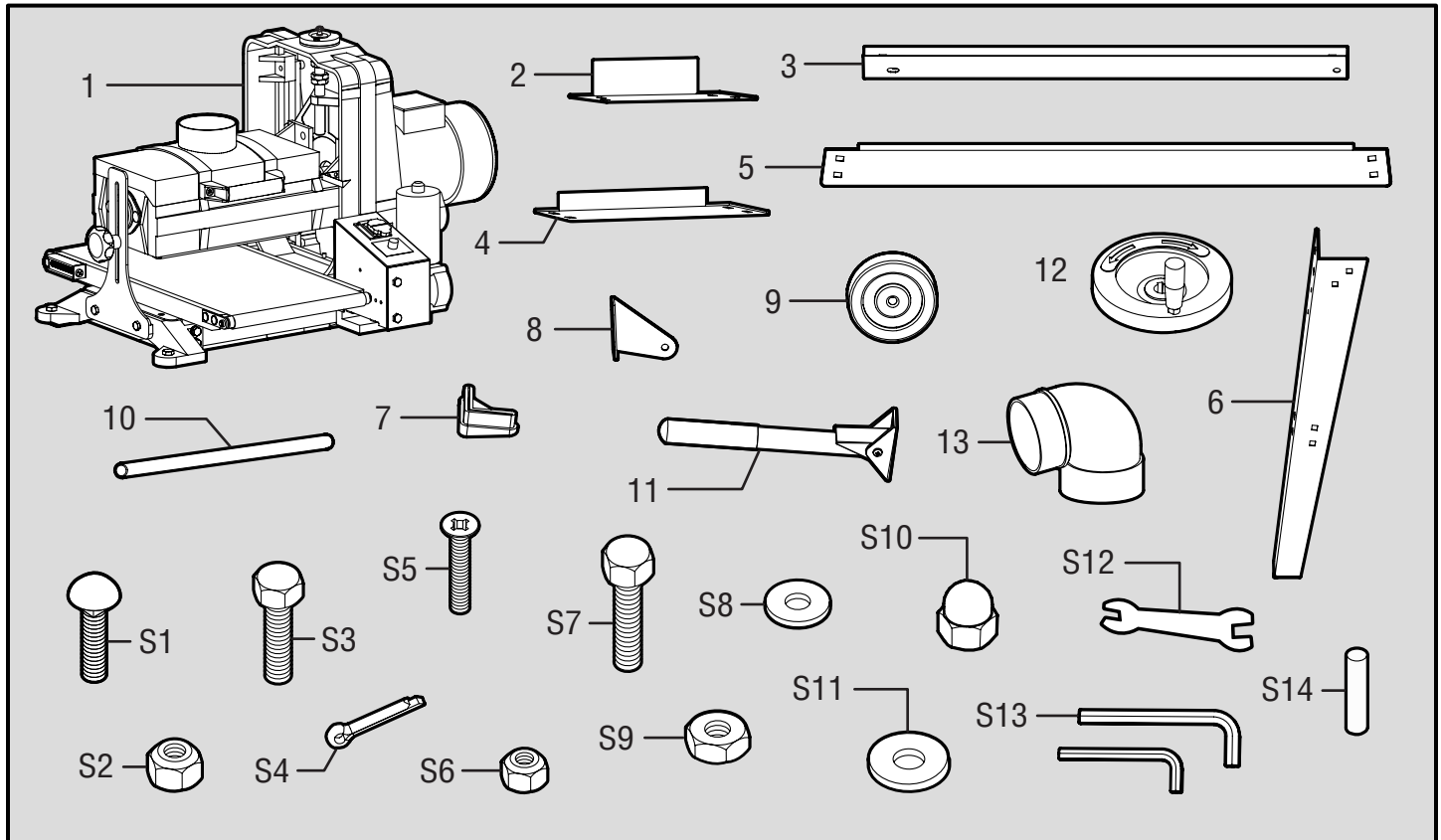




# UNPACKING

## PACKING LIST

Check your packing list against the diagram below. If any part is damaged or missing, please contact our customer service at (800) 232-1195, M-F 8-5 CST or email us at [techsupport@wenproducts.com](mailto:techsupport@wenproducts.com).



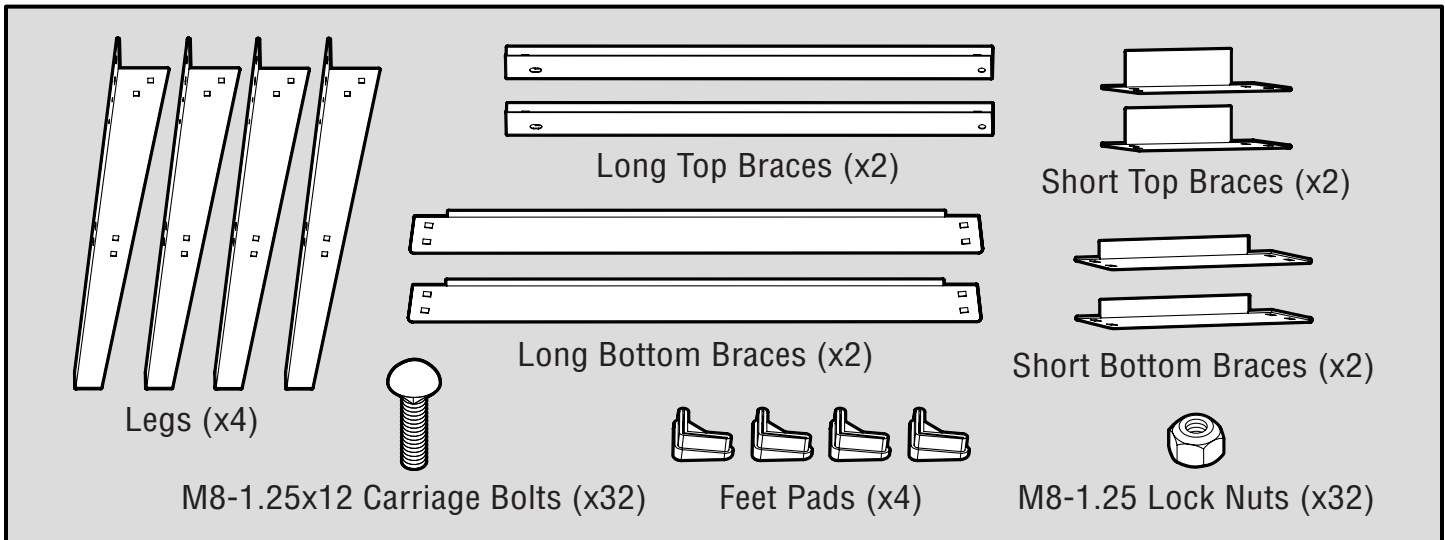
NO.	PARTS	QTY.
1	Drum Sander Assembly	1
2	Short Top Brace 14-5/8"	2
3	Long Top Brace 17-1/4"	2
4	Short Bottom Brace 20-1/4"	2
5	Long Bottom Brace 23-1/8"	2
6	Legs	4
7	Feet Pads	4
8	Wheel Brackets	2
9	Wheels	2
10	Wheel Axle	1
11	Lifting Handle Assembly	2
12	Height Adjustment Wheel	1
13	Dust Port	1

NO.	HARDWARE	QTY.
S1	Carriage Bolts M8-1.25 x 12	32
S2	Lock Nuts M8-1.25	36
S3	Hex Bolts M8-1.25 x 16	4
S4	Cotter Pins 4 x 20mm	2
S5	Flat Head Screws M6-1 x 10	4
S6	Lock Nuts M6-1	4
S7	Hex Bolts M10-1.5 x 30	4
S8	Flat Washer 10mm	4
S9	Hex Nuts M10-1.5	4
S10	Acorn Nut M12-1.75	1
S11	Large Washer 12mm	1
S12	Open End Wrench 11/13mm	1
S13	Hex Wrench 5mm, 6mm	2
S14	Holding Pin	1

# ASSEMBLY

**⚠ WARNING:** To avoid injury from accidental startups, do not plug in the drum sander until all assembly and preparation procedures have been completed.

## ASSEMBLING THE STAND (FIG. 2)



1. Place the 4 top braces upside down on a flat surface to form a rectangle.

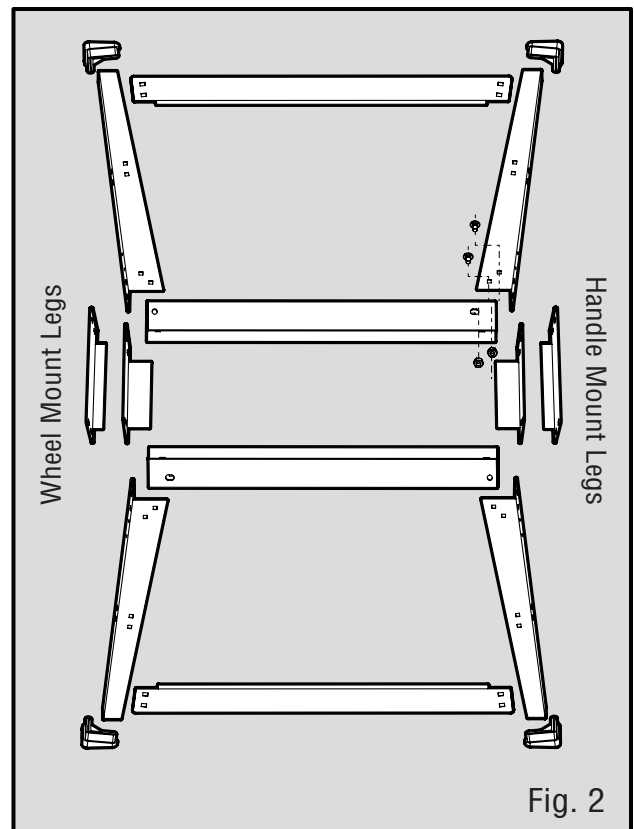
2. Attach the 4 legs to the top braces using (16) M8-1.25 x 12 carriage bolts and (16) M8-1.25 lock nuts. The legs should be on the outside of the braces. Hand tighten all fasteners.

**NOTE:** There are two types of corner legs: one type with handle-mounting holes just below the upper support mounting holes, the other with wheel-mounting holes on the bottom of each leg. Make sure that the short braces connect legs of matching styles.

3. Attach the 4 bottom braces to the lower brace mounting holes of the 4 legs with the remaining (16) M8-1.25 x 12 carriage bolts and (16) M8-1.25 lock nuts. Hand tighten all fasteners.

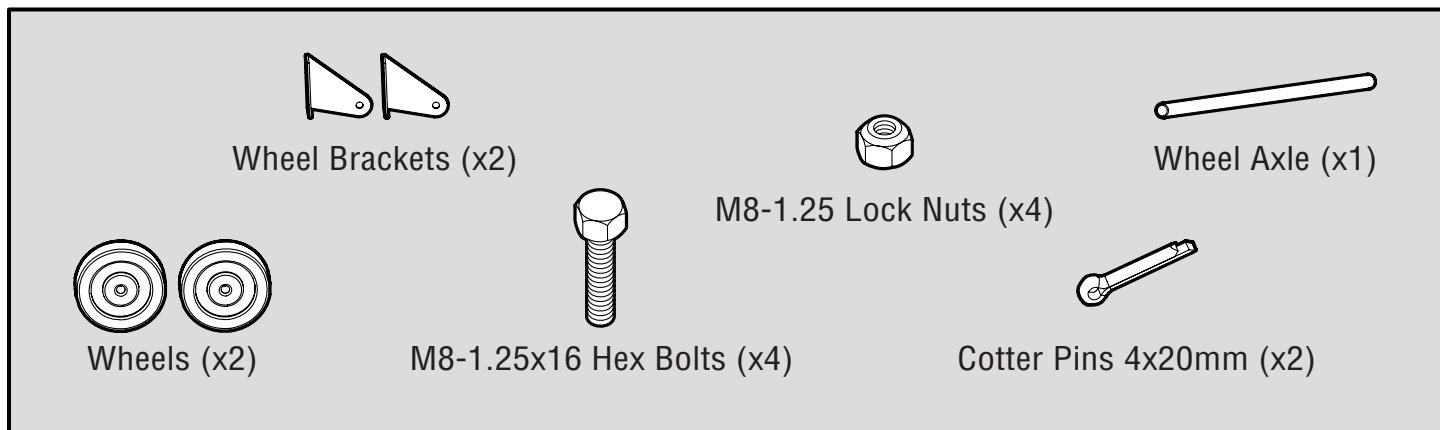
4. Slide the 4 feet pads onto the bottom of the 4 legs.

5. Turn the stand over, square up the braces and legs, then fully tighten all fasteners using an adjustable wrench or ratcheting socket wrench.



# ASSEMBLY

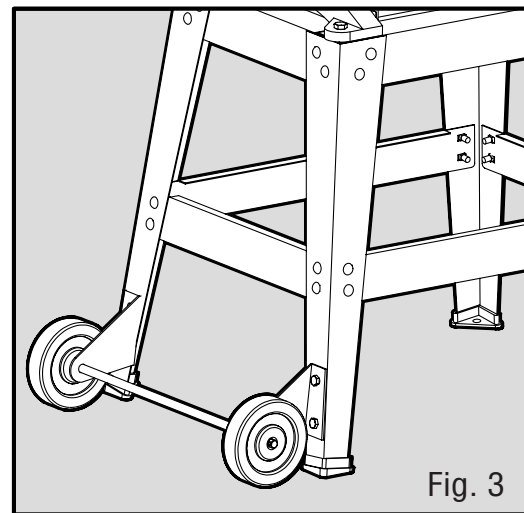
## INSTALLING THE WHEELS (FIG.3)



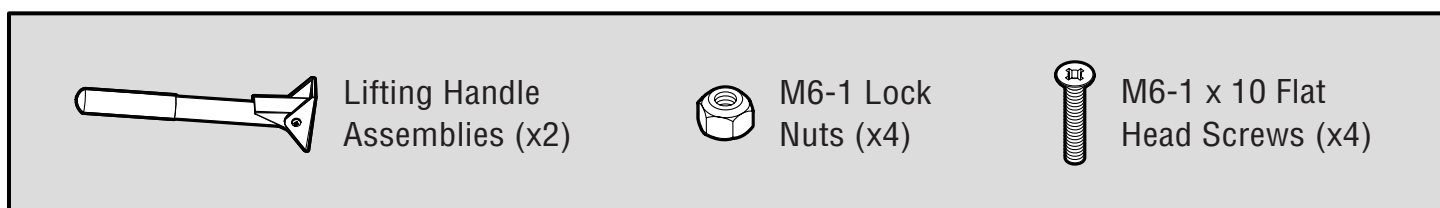
1. Attach the 2 wheel brackets to the 2 wheel-mounting legs with (4) M8-1.25 x 16 hex bolts and (4) M8-1.25 lock nuts. Note that the left and right wheel brackets are different configurations. Tighten the fasteners with a wrench.

2. Slide the wheel axle through the 2 wheel brackets. Then install the two wheels onto the two ends of the wheel axle.

3. Secure the 2 wheels with the 2 cotter pins by inserting them through the axle holes and bending back the ends.



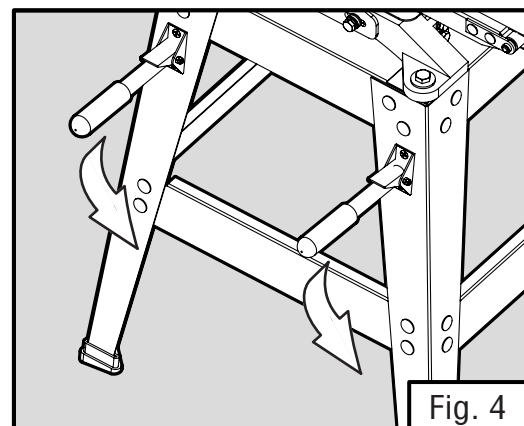
## INSTALLING THE HANDLES (FIG. 4)



1. Attach the lifting handle assemblies onto the handle-mounting with (4) M6-1 x 10 flat head screws and (4) M6-1 lock nuts.

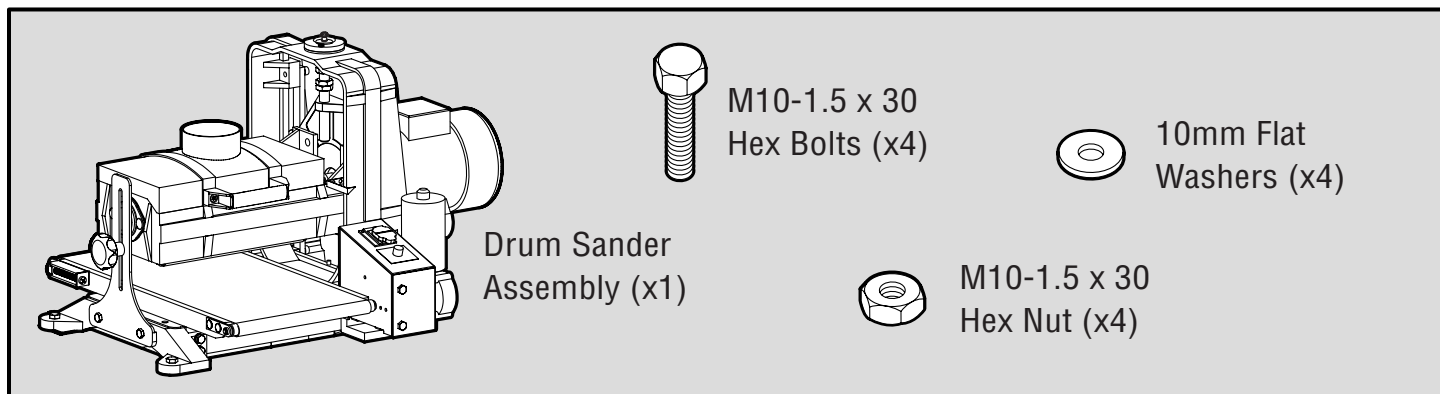
2. Use a Phillips screwdriver to hold the mounting screws stationary while tightening the locking nuts with a suitable wrench.

**NOTE:** The handle should be able to swing up 90 degrees from the “down” position, but not any farther.



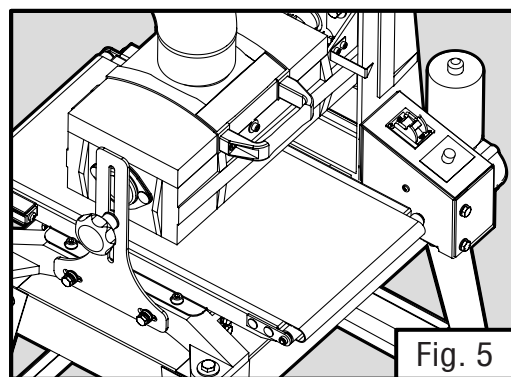
# ASSEMBLY

## MOUNTING THE MACHINE ONTO THE STAND (FIG. 5)



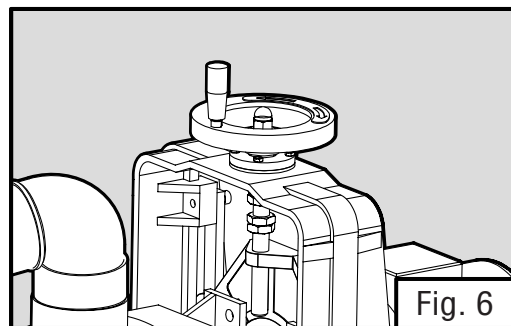
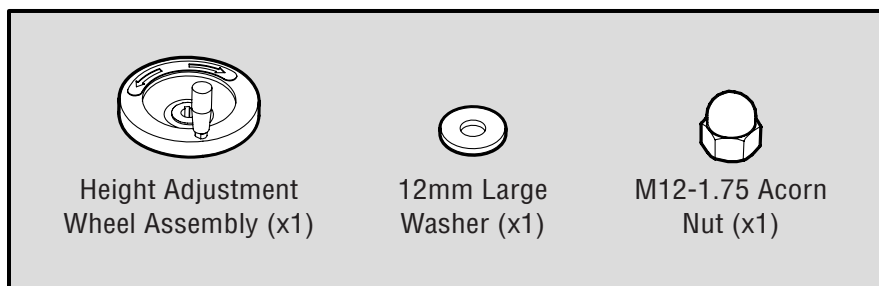
1. This sander weighs over 150 lbs, so you will need a strong muscular friend (or a trustworthy foe) to help you lift it up. Carefully place the sander onto the assembled stand in the orientation you prefer (the motor side of the sander can be positioned above the wheels side or the handles side).

2. Align the mounting holes on the base of the machine with the holes on the stand. Mount the machine in place using (4) M10-1.5 x 30 hex bolts, (4) 10mm flat washers, and (4) M10-1.5 hex nuts. Tighten the fasteners using a wrench.



**NOTE:** If necessary to align the mounting holes, you can slightly loosen the stand fasteners. Be sure to re-tighten them after securing the sander assembly.

## INSTALLING THE HEIGHT ADJUSTMENT WHEEL (FIG. 6)

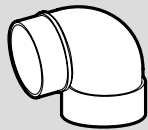


Attach the height adjustment wheel onto the screw on top of the sander. Mount the 12mm large washer and M12-1.75 acorn nut on top of the wheel and tighten the nut.

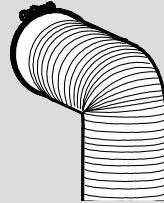
# ASSEMBLY

## MOUNTING THE DUST PORT (FIG. 7)

**⚠ WARNING:** Sanding produces a lot of dust that could be harmful to your health. Always operate using a dust collection system and approved face mask to minimize the risk of lung damage from dust inhalation. DO NOT operate the drum sander without an adequate dust collection system.



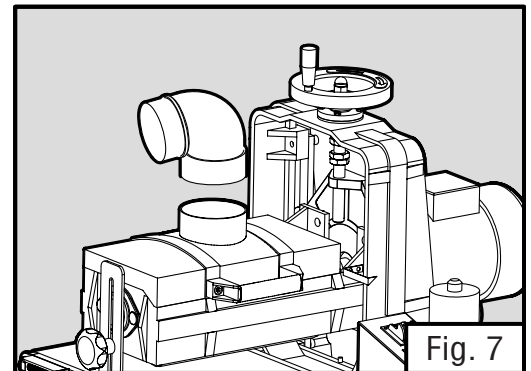
Dust Port (x1)



Dust hose and hose clamp (x1)  
(not included)

1. Install the dust port onto the drum cover.
2. Fit a 4-inch dust hose (not included) over the dust port and secure it in place with a hose clamp (not included). A tight fit is necessary for proper dust collection performance.
3. Connect the dust hose to your dust-collection system of choice.

**NOTE:** The dust port on your sander is compatible with the WEN 28200 10 ft. dust hose and the WEN 28221 20 ft. dust hose, available at [wenproducts.com](http://wenproducts.com).



# SANDPAPER INSTALLATION

## SANDPAPER GRIT SIZE

Your drum sander comes with 80-grit sandpaper pre-installed. The grit size of sandpaper determines the finish of the surface. The lower the grit number, the coarser the sandpaper and the rougher the sanded surface. The higher the grit number, the finer the sandpaper and the smoother the sanded surface. Typically, begin sanding with a coarse grit sandpaper and progressively work through finer grits until the desired finish or thickness is achieved.

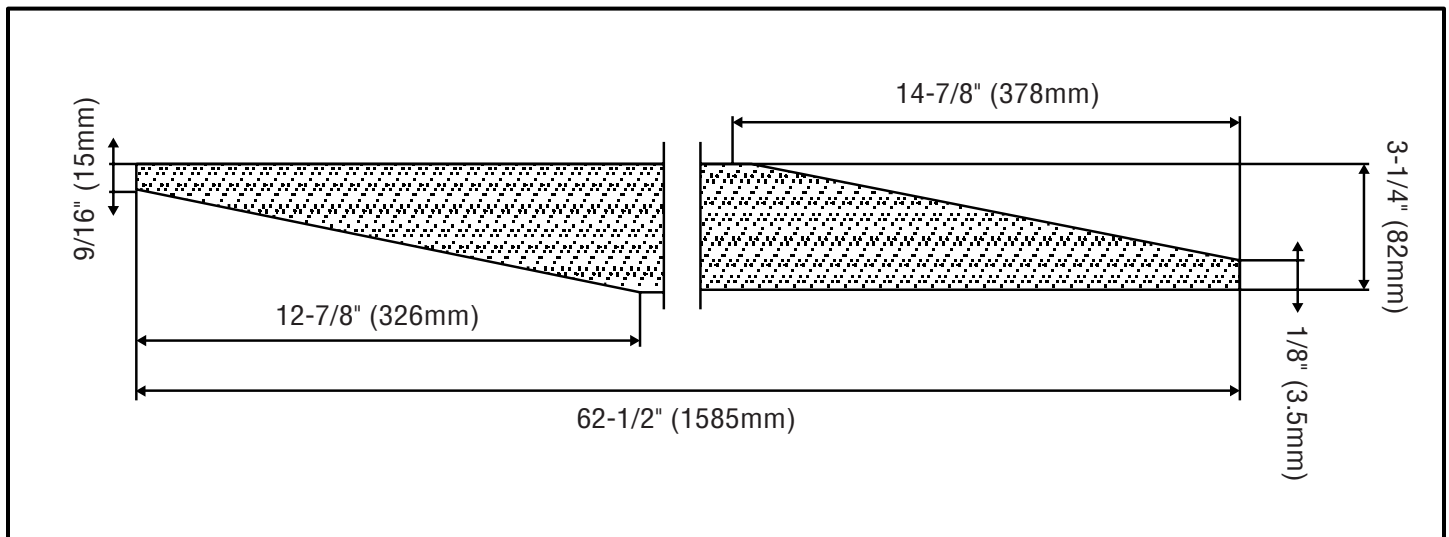
Experiment with different sanding grits on a scrap workpiece to determine the result of the sanded surface. Refer to the chart below for the characteristics and uses associated with different sandpaper grit sizes.

Grit Size	Coarse Level	Characteristics and Uses
36	Extra Coarse	Maximum stock removal, abrasive planning, paint removal
60-80	Coarse	Stock removal, surfacing, end grain surfacing, planer mark removal
100-120	Medium	End grain smoothing, light surfacing
150-180	Fine	Finish sanding, surface preparation, thin stock dimensioning
220	Very Fine	Finish sanding

## SANDPAPER PREPARATION

Sandpaper for drum sanders are trimmed specifically to properly wrap around the sanding drum. You can find pre-cut drum sander sandpaper that is ready to use and requires no measuring or trimming. You can also purchase a 3-1/4 inch (82mm) wide sandpaper roll and trim it using the diagram below or your existing sandpaper as a template.

**NOTE:** Your friends at WEN offer pre-cut sandpaper in different grit sizes specifically for your drum sander. Sandpaper can be ordered from [wenproducts.com](http://wenproducts.com) by searching the model number 65910.

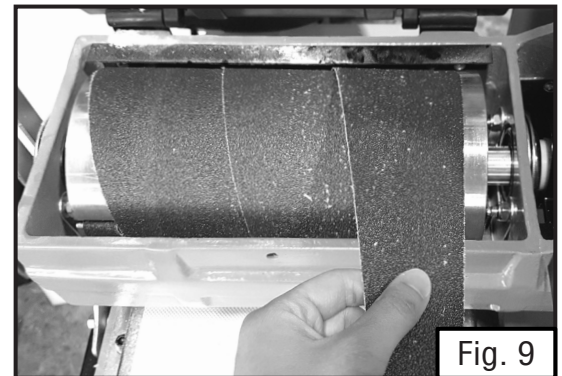
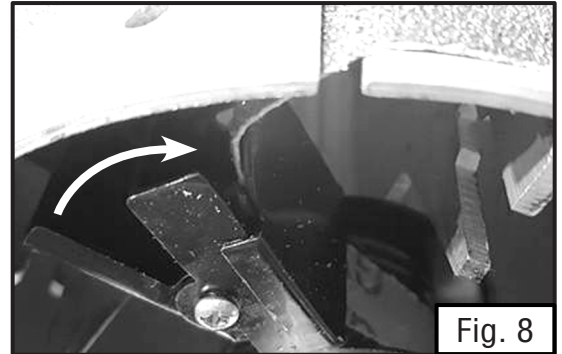


# SANDPAPER INSTALLATION

**⚠ WARNING:** To avoid injury from accidental startups, always ensure that the tool is switched OFF and unplugged from the power supply before making adjustments.

## REMOVING EXISTING SANDPAPER (FIG. 8 & 9)

1. Disconnect the drum sander from the power supply.
2. Using a hex wrench, remove the socket-head screw and washer securing the drum cover. Lift up the cover to expose the sanding drum.
3. Roll the sanding drum until the slot on the right side of the drum is on top. Reach under the right lip of the drum to locate the spring clamp (Fig. 8).
4. Push forward the clamp to release the tension on the sandpaper. Slide out the end of the sandpaper from the slot.
5. Start unwinding the sandpaper from the drum (Fig. 9) until you come to the clamping device on the left side of the drum.
6. Push the clamping device on the left of the drum to release the grip on the sandpaper.
7. Remove the sandpaper.





# PREPARATION

## INSTALLING NEW SANDPAPER (FIG. 10-13)

1. Roll the sanding drum until the slot on the left of the drum is on top. Reach under the left lip of the drum to locate the spring clamp.

**NOTE:** Align the directional arrows printed on the bottom of sandpaper with the drum's rotation direction.

2. Lift the clamping device and insert the end of the replacement sandpaper into the slot (Fig. 10). Push the sandpaper so that about 1 inch of sandpaper is loaded to ensure enough grip. Align the left side of the sandpaper with the left lip on the drum.

3. Release the left clamping device to hold the sandpaper in place. Pull on the sandpaper to make sure the end of the sandpaper strip has been securely clamped. If the strip comes loose, repeat steps 1 and 2.

4. Use your right hand to roll the drum away from you and use your left hand to apply reasonable tension on the sandpaper while wrapping the sandpaper onto the drum (Fig. 11). Make sure that the sandpaper strip remains tight as you wrap it.

**IMPORTANT:** DO NOT overlap the sandpaper. The sandpaper should be flush or slightly gapped in between.

5. Once the drum is completely wrapped (Fig. 12), keep tension on the sandpaper and insert the remaining end of the strip into the slot on the right of the drum.

6. Press the clamp forward until the slot on the clamp is in line with the slot on the drum. Insert the end of the sandpaper into the slot and through the jaw of the clamp (Fig. 13).

**NOTE:** It may help to insert a holding pin through the hole on the sanding drum and the clamp to hold the clamp in place as you are inserting the sandpaper. Remove pin after sandpaper installation afterwards.

7. Release the clamp to secure the end of the sandpaper. Check that the sandpaper is properly installed and is wrapped tight against the drum.

8. Close the drum cover and replace the washer and cap screw.

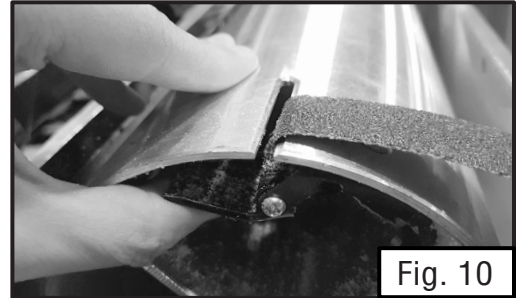


Fig. 10



Fig. 11

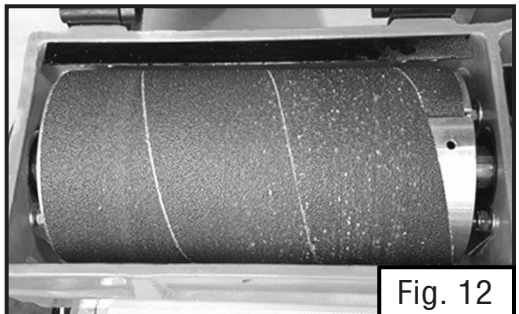


Fig. 12

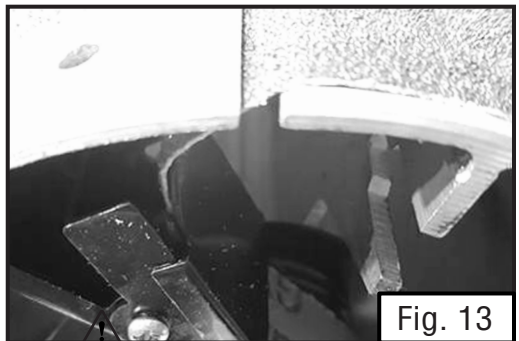


Fig. 13

**WARNING:** Make sure that the sandpaper is correctly installed and tightened onto the sanding drum before connecting the machine to the power supply.



# PREPARATION

## PLANNING YOUR WORK

Planning your work before operation will help to save time and minimize setups. Group your workpiece by thickness and grit requirements. Work through each required sanding grit from the thickest to the thinnest material. Then, change to a finer grit sandpaper and work through the process again.

**⚠️ WARNING:** To avoid injury from accidental startups, always ensure that the tool is switched OFF and unplugged from the power supply before making adjustments.

## INTRODUCTION

The drum sander is a machine designed to sand wooden workpieces to a desired thickness and smoothness. Before adjusting and operating the machine, it is important to know that drum sanding is different from thickness planing. Drum sanding can only remove material in increments of 1/32 inch (0.8mm) or less, depending on the sanding grit, material hardness, sanding width, etc. The drum sander is not suitable for quick bulk material removal. Forcing your drum sander to remove too much material too fast will cause damage to your machine and the workpiece.

## WORKPIECE INSPECTION

This drum sander is intended for sanding natural and man-made wood materials. This machine cannot sand other materials such as metal, glass, stone, tile, etc. Make sure to inspect all workpieces before operation and refer to the list below for materials that you should avoid or take extra care with.

**FOREIGN OBJECTS.** Foreign objects such as nails, staples, dirt, rocks, etc. are often embedded in wood. The objects may cause kickback that can hit the operator and damage the machine. Remove those foreign objects before operation.

**LARGE OR LOOSE KNOTS.** Choose workpieces that do not have large or loose knots. Large knots may cause kickback and damage the machine. Loose knots in stock can become dislodged during sanding operations.

**WOOD SPECIES WITH TOXIC PROPERTIES.** Wood species such as the rosewood family (e.g. cocobolo) have toxic properties that may result in allergic reactions. Even with dust control, you may inhale small airborne particles and possibly suffer an allergic reaction.

**HIGHLY RESINOUS SPECIES.** Highly resinous species tend to quickly clog or load up sandpaper easily. This includes some common pine species. It is almost impossible to clear the sandpaper of the pitch and sawdust from those species of wood. Avoid sanding those wood species or make sure to replace sandpaper often.

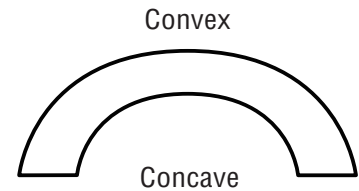
**WET OR GREEN STOCK.** Wood stock with a moisture content over 20% causes excessive wear on the sandpaper and motors as you're sanding. This may increase the risk of kickback and result in a poor surface finish. Use stock with moisture content below 20%.

**EXCESSIVE WARPING.** Do not sand workpieces with excessive warping or twisting as they are unpredictable and difficult to hold stable. DO NOT sand workpieces with excessive warping.

Continues on page 18

# PREPARATION

**MINOR WARPING.** When sanding workpieces with minor warping, make sure the concave side is downward, facing the conveyor belt. Check that the workpiece can be stable and well supported. Do not place the workpiece with the convex side down, as it will wobble during operation and cause kickback and possible injury.



## ADJUSTING THE DEPTH OF CUT (FIG. 14)

The depth of cut of your drum sander is the amount of material that is removed by the sanding drum in one pass. The proper depth of cut depends on many variables, including the feed rate, hardness of the material and width of the material. For a smoother result, a smaller depth of cut is always recommended.

**IMPORTANT:** You should never remove more than 1/32 inch (0.8mm) of material in one pass.

The depth of cut can be adjusted by rotating the height adjustment wheel (Fig. 14 - 2). Rotating the handwheel 1/4 turn adjusts the depth of cut by 1/32 inch. Generally, a 1/4 turn of the handwheel (1/32" depth of cut) per pass is acceptable for coarser grits or softer woods. A 1/8 turn of the handwheel (1/64" depth of cut) is recommended for finer grits or harder woods.

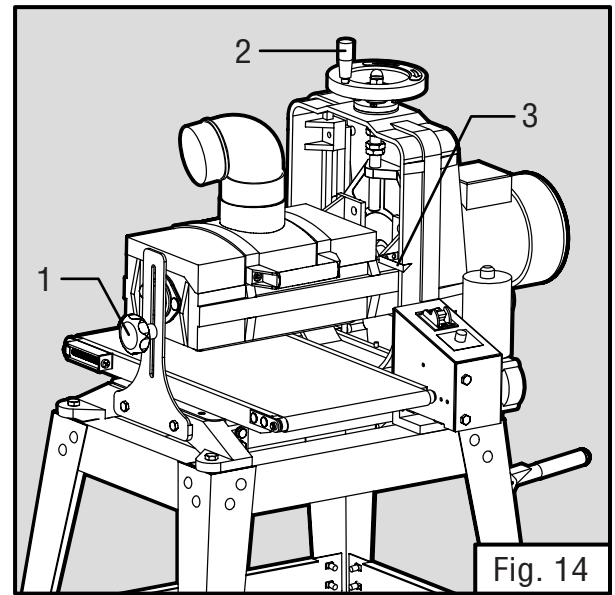


Fig. 14

### TO ADJUST THE DEPTH OF CUT:

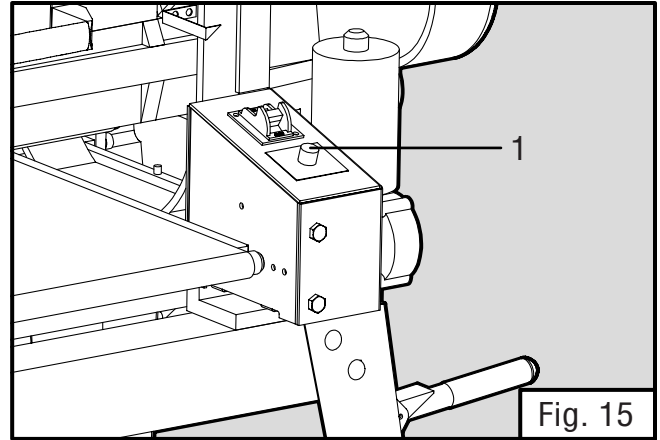
1. Loosen the elevation lock knob (Fig. 14 - 1).
2. Rotate the height adjustment wheel (Fig. 14 - 2). Rotating the handwheel clockwise raises the sanding drum and rotating the handwheel counterclockwise lowers the sanding drum. A 1/4 turn adjusts the depth of cut by 1/32".
3. Use the depth pointer (Fig. 14 - 3) to check the cutting depth. When the proper depth of cut has been set, firmly tighten the lock knob to secure the sanding drum in place.
4. For the best result, test on a scrap piece of wood of similar material and adjust the cutting depth accordingly.

## PREPARATION

### ADJUSTING THE FEED RATE (FIG. 15)

The feed rate is the speed that the conveyor belt travels to deliver the workpiece through the sanding drum. Setting the feed rate too fast may overload the motor, while setting the feed rate too slow may burn the surface of the workpiece. In general, a wider or harder workpiece and finer grit sandpaper will require a slower feed rate.

Rotate the feed rate dial (Fig. 15 - 1) to adjust the conveyor belt feed rate. Rotating the feed rate dial clockwise increases the feed rate and rotating it counter-clockwise decreases the feed rate. For the best result, test on a scrap piece of wood of similar material and adjust the feed rate accordingly.



### MOTOR OVERLOAD PROTECTOR

Your drum sander is equipped with an overload protector that shuts down the machine when it is overloaded to protect the motor. The machine can overload when the depth of cut is too much or the feed rate is too high. When an overload happens, wait for the motor to cool down. Press the red circuit breaker on the box above the motor to reset. Reduce the depth of cut and feed rate, then try again.

**⚠ WARNING:** Do not attempt to plug in or operate your tool until the entire operator's manual has been read and understood. Make sure that the machine is assembled and setup properly. Failure to do so could result in personal injury and damage to the tool.

**⚠ WARNING:** Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce the risk of injury.

**⚠ WARNING:** Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.

**⚠ WARNING:** This machine creates a lot of dust. Inhaling said dust on a regular basis can cause permanent respiratory illness. Minimize your exposure by wearing a respirator and using a dust collector. If you do not use some method of dust extraction or collection, the motor could overheat and fail. Failure to use some method of dust extraction or collection will void the warranty.

## PREPARATION

1. Make sure the drum sander is switched off and disconnected from the power supply. Connect the sander to a suitable dust collection system before operation.
  2. Inspect the workpiece and make sure it is acceptable for the sanding operation. Make sure that the correct sandpaper grit is selected and the sandpaper is properly installed onto the drum.
  3. Lay the workpiece flat on the conveyor belt below the sanding drum.
  4. Loosen the height lock knob (Fig. 14 - 1) and turn the height adjustment wheel (Fig. 14 - 2) to lower the sanding drum until it lands on the top surface of the workpiece. This will allow the sander to take off just the top surface of the workpiece with the first pass. Remove the workpiece from the conveyor belt and set it aside.
  5. Plug in and turn on the sander. Adjust the conveyor feed rate to suit the sanding operation.
  6. Stand to the side of the conveyor belt to avoid the risk of kickback. Allow the sanding drum to reach full speed before inserting the workpiece.
  7. Place the workpiece onto the infeed side of the conveyor belt, flush against the belt and parallel to the direction of the belt's movement. Hold the workpiece on the conveyor and carefully ease it into the sander. Be careful not to get your hand or any body parts close to the sanding drum.
  8. Once the sanding drum has control of the workpiece, step to the side of the outfeed conveyor belt and support of the workpiece as it leaves the sanding drum. Do not stand in line with the sanding path.
- NOTE:** Do not apply upward or downward pressure when supporting or guiding the workpiece through the sander. Doing so may induce snipe, where the sander drum digs into the workpiece.
9. Rotate the workpiece horizontally 180 degrees and pass it through the sander again, without changing the depth of cut setting. This will create a even finish on your sanding surface.
  10. Increase the depth of cut by the correct amount (must be less than 1/32"), then repeat steps 7–10 with progressively finer sandpaper grits until you have produced the desired results. Always use the correct depth of cut and feed rate. Taking too heavy of a cut or using too fast a feed rate may cause kickback.
- NOTE:** Keep in mind that as you change to finer grit size, the feed rate needs to be reduced accordingly.
11. When the sanding operation is complete, turn off the drum sander and unplug the power cord. Wait for the drum to come to a complete stop before leaving the work area.

# ADJUSTMENTS

**⚠ WARNING:** To avoid injury from accidental startups, always ensure that the tool is switched OFF and unplugged from the power supply before making adjustments.

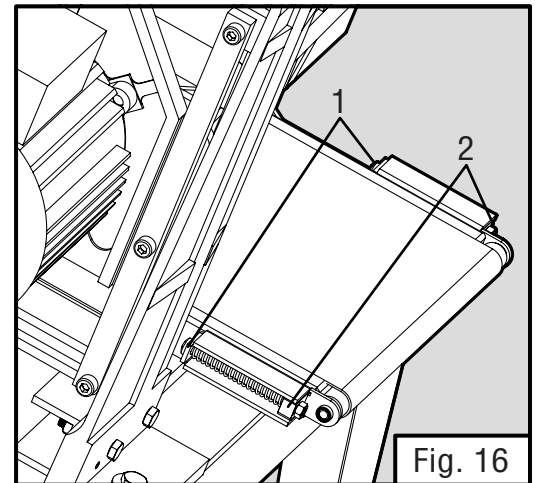
The following settings should be correctly adjusted from the factory. However, they may need to be checked and adjusted to ensure optimal sanding performance. Refer to the sections below to adjust the following settings.

- Conveyor belt tension and tracking (page 21)
- Elevation tension screw adjustment (page 22)
- Conveyor belt to drum alignment (page 23)
- Pressure roller adjustment (page 23)
- Elevation stop adjustment (page 24)

## CONVEYOR BELT TENSION ADJUSTMENT (FIG. 16)

The conveyor belt tension should be properly adjusted to ensure safe operation and protect the belt from damage. The belt tension can be adjusted by rotating the tensioning screws on both sides of the conveyor table. To adjust the belt tension:

1. Turn off and disconnect the machine from the power source.
2. Release the belt tension equally on both sides of the table by holding the hex nuts (Fig. 16 - 1) in place while rotating the tensioning screws (Fig. 16 - 2) counterclockwise. Position the belt in the center of the rollers.
3. Adjust the tensioning screws so that the end of both tensioning screws extend about 1/4" beyond the hex nuts (Fig. 16 - 1).
4. To tighten the belt tension, rotate the tensioning screws clockwise in small increments until the belt no longer slips on the rollers. To loosen the belt tension, rotate the tensioning screws counterclockwise.



# ADJUSTMENTS

## CONVEYOR BELT TRACKING ADJUSTMENT

The conveyor belt should track in the center of the conveyor table. Occasionally check the belt tracking by running the conveyor belt at high speed for a few minutes. If the belt shifts to one side or the other, the belt tracking needs to be adjusted.

**NOTE:** Do not allow the belt to track off the rollers as this may damage the belt.

1. If the belt tracks to the left (viewing from the infeed side), tighten the left side tensioning screw by rotating it clockwise while holding its nut in place. This will make the belt shift to the right side.
2. If the belt tracks to the right (viewing from the infeed side), tighten the right side tensioning screw by rotating it clockwise while holding its nut in place. This will make the belt shift to the left side.
3. Let the conveyor belt run for a few minutes to check the belt tracking. Re-adjust as necessary.

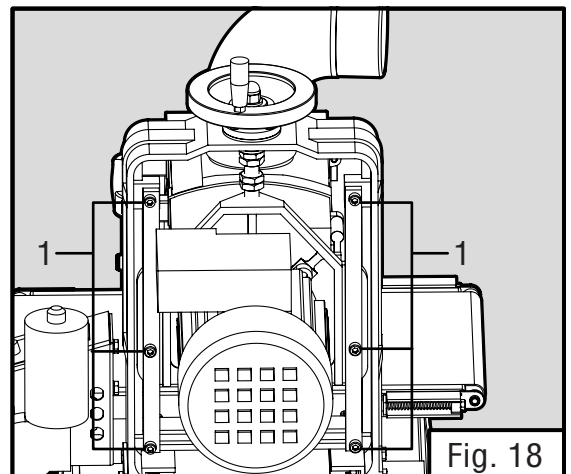
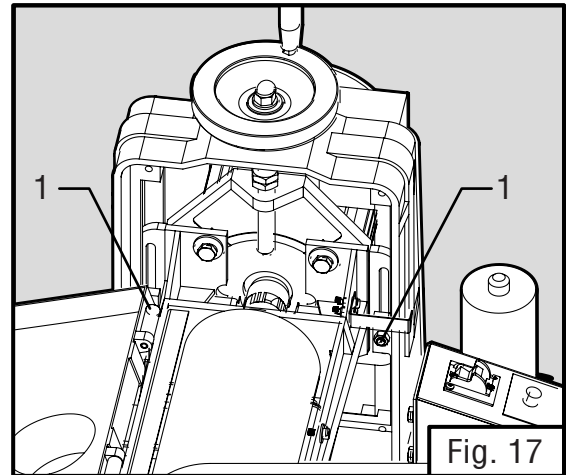
**NOTE:** The tracking adjustments may not be apparent immediately. Make small corrections of approximately 1/4 turn increments to the tensioning knob and evaluate the results. Re--adjust as necessary until the belt is tracking properly.

## ADJUSTING TENSION SCREWS (FIG. 17 & 18)

The six height adjustment tension screws on the height adjustment wheel side of the sander apply pressure to the sliding mechanism of the sanding head. The tightness of the screws can be tuned for accurate height adjustments.

If the screws are too loose, the drum will deflect during operation, causing an uneven sanded surface. If the screws are too tight, adjusting the height of the sanding drum will be difficult, causing excessive wear on the height adjustment system.

1. Turn off and disconnect from the power source.
2. Loosen the two center lock nuts on both sides of the frame (Fig. 17 - 1).
3. Step to the motor side of the sander. Loosen or tighten the 6 cap screws (Fig. 18 - 1) evenly in 1/4 turn increments. Rotate the height adjustment wheel to test the sanding head movement. Adjust the screws until the desired fit and smoothness is achieved.
4. Re-tighten the two center lock nuts (Fig. 17 - 1).



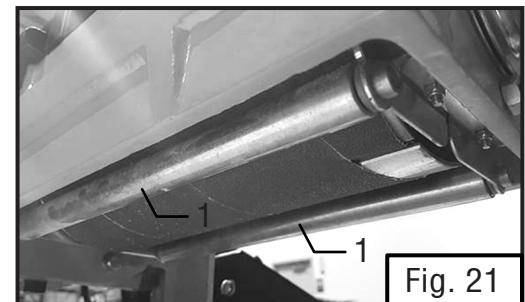
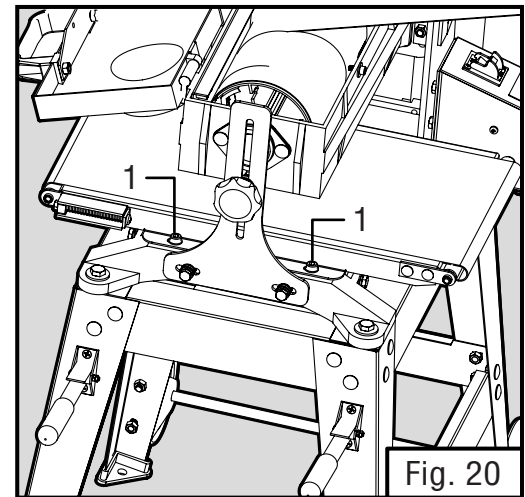
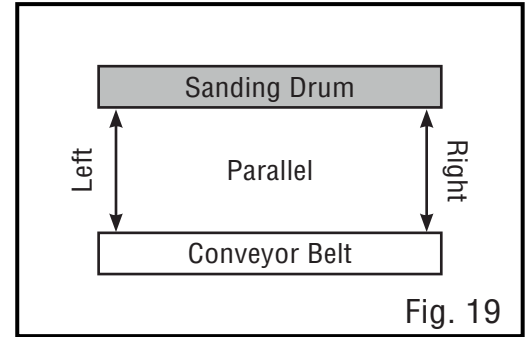


# ADJUSTMENTS

## BELT TO DRUM ALIGNMENT (FIG. 19 & 20)

To achieve an even sanding result, the sanding drum and conveyor belt should be parallel with each other. To check the belt to table alignment:

1. Make sure the height adjustment tension screws are properly adjusted. Otherwise the testing results may not be accurate.
2. Prepare a planed board about 2" thick and 8 - 10" wide. Make sure the thickness on both ends and sides of the board is even.
3. Turn on the machine. Feed the board through the sander to take several light cuts from the top surface of the board.
4. Measure the thickness of the left edge and right edge of the board. The difference between the two edges should be less than 0.05". If it is greater than 0.05", follow the steps below to correct it.
5. Remove the two cap screws (Fig. 20 - 1) on the side of the conveyor table that produces a thicker sanding result. Slide a metal shim (not included) between conveyor table and the frame to slightly elevate the conveyor table to reduce the sanding thickness on that side.
6. Tighten the cap screws to secure the conveyor table.
7. Repeat steps 2 to 6 as necessary until the alignment between the conveyor belt and drum is within 0.05" difference.



## ADJUSTING PRESSURE ROLLER (FIG. 21 & 22)

There are two pressure rollers (Fig. 21 - 1) on each side of the sanding drum. The rollers extrude slightly below the bottom of the drum in order to press the workpiece against the conveyor belt as it passes through the sander.

The pressure on the rollers is controlled by the springs and adjustment screws that can be accessed from the inside of the drum housing. If the roller pressure is too high, kickback and snipe may occur. If the roller pressure is too low, the workpiece may slip on the conveyor belt. To adjust the pressure of the rollers:

## ADJUSTMENTS

1. Turn off and disconnect the machine from the power source.
2. Remove the screw and washer securing the drum cover and lift the cover open.
3. There are two screws (Fig. 22 - 1) on both ends of the drum. To increase the roller pressure, evenly tighten all four Phillips screws by rotating them clockwise in small increments. To decrease the roller pressure, evenly loosen all four Phillips screws in small increments.

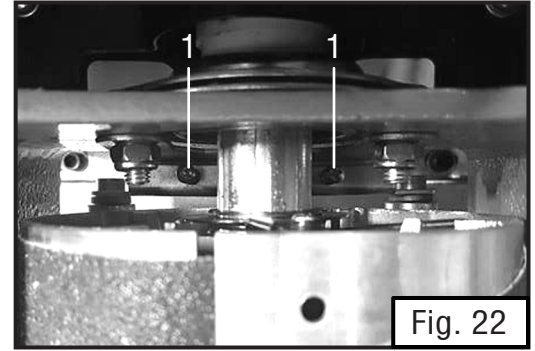


Fig. 22

4. To test the adjustments, turn on the machine and sand a scrap piece of workpiece. If the workpiece slips on the conveyor belt, increase the pressure by rotating the four screws one turn clockwise. If the workpiece tends to kick back, reduce the pressure by rotating the four screws one turn counterclockwise.
5. Repeat until roller pressure has been properly adjusted. Close the drum cover and replace the washer and cap screw.

### ADJUSTING THE STOP SCREW (FIG. 23)

The height adjustment stop, controlled by the protrusion of the Phillips head screw through the bottom of the frame, prevents the sanding drum from contacting the conveyor belt. If necessary, re-adjust the height adjustment stop screw as follow:

1. Turn off and disconnect the machine from the power source.
2. Loosen the height adjustment lock knob and raise the sanding drum using the height adjustment wheel.
3. Loosen the hex nut on the stop screw and adjust the height of the screw (Fig. 23 - 1) to protrude above the frame higher than 1/4 inch.
4. Tighten the hex nut and lower the sanding drum until the motor mount frame touches the top of the stop screw.
5. Check that the bottom of the sanding drum is at least 3/16" above the surface of the conveyor belt. If the distance is too close, repeat the steps above to re-adjust as necessary.

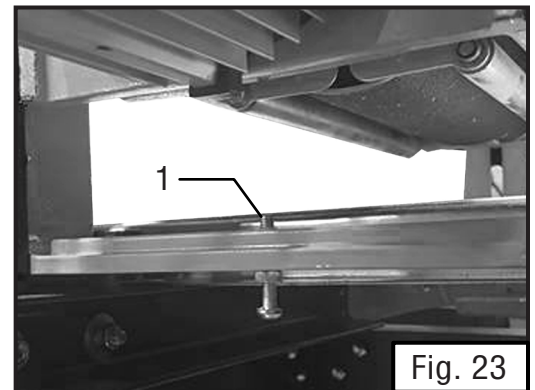


Fig. 23



# MAINTENANCE

**⚠ WARNING:** To prevent serious injury from accidental operation, always turn off and disconnect the machine from power source before installation, cleaning and maintenance operations.

**⚠ WARNING:** Use caution when performing maintenance on the drum sander. Do not wear long sleeve shirts, neckties or jewelry. Make sure to tie back long hair.

## DAILY INSPECTION

For optimum performance, inspect the machine before every use. Check the following before each operation.

- Loose mounting fasteners - tighten all fasteners
- Loaded, damaged, or worn sandpaper - clean or replace sandpaper
- Dirty or damaged conveyor belt - clean or replace conveyor belt
- Damaged wires, power cord or faulty switch - replace faulty parts immediately

## GENERAL CLEANING

Keep your drum sander clean. Vacuum accumulated sawdust from working parts and wipe clean with a dry cloth. To clean resin buildup on the sanding drum, remove the sandpaper strip and clean using a resin-dissolving cleaner of your choice. Clean the conveyor belt with soapy water and wipe dry with a clean towel.

**⚠ WARNING:** Do not use solvents to clean plastic parts. Do not at any time let brake fluids, gasoline, petroleum based products, penetrating oils, etc., come in contact with plastic parts. Chemicals can damage, weaken or destroy plastic which may result in personal injury.

## SANDPAPER CLEANING

Routinely cleaning the sandpaper is recommended for optimal sanding performance. The sandpaper may become clogged with sawdust, which will cause poor sanding performance and marring of the workpiece. Regularly check the condition of the sandpaper to see if it is clogged.

### TO CLEAN THE SANDPAPER:

1. Prepare a long abrasive belt cleaning stick, so that your hand can stay at a safe distance from the sanding drum during cleaning.
2. Set the conveyor belt speed to the lowest feed rate. Avoid contact with the conveyor feed belt.
3. Remove the cap screw and washer from the drum cover. Open the drum cover to expose the sanding drum.

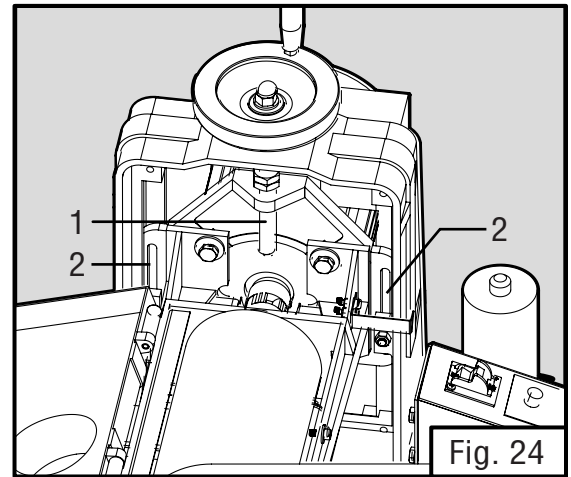
# MAINTENANCE

4. Turn on the machine. Hold the long abrasive belt cleaning stick with two hands and gently lower the stick onto the rotating sanding drum. Move the cleaning stick from side to side to remove the clogging sawdust from the drum
5. After cleaning is complete, remove the cleaning stick and turn off the machine. Close the drum cover and lock it with the washer and cap screw.

## LUBRICATION (FIG. 24)

Periodically lubricate exposed moving parts, the lead screw (Fig. 24 - 1) and sanding head slides (Fig. 24 - 2). Clean sawdust from the height adjustment leadscrew and sanding head slides. Apply a small amount of dry lubricant, such as graphite, onto the surfaces. Do not use oil or grease as lubricants as they tend to attract and hold sawdust.

The internal parts of the drum sander have already been lubricated and require no extra lubrication.



# MAINTENANCE

## CONVEYOR FEED BELT REPLACEMENT (FIG. 25 & 26)

Regularly check the conveyor belt before operation. The conveyor belt may need replacement due to normal wear and tear, contact with the sanding drum abrasive during operation, mis-tracking of the conveyor belt, or excessive build-up. Follow the steps below to remove and replace the conveyor belt.

1. Turn off and disconnect the machine from the power source.

2. Release the conveyor belt tension by rotating the tensioning screws on both sides of the conveyor in a counterclockwise direction while holding the hex nuts in place.

3. Unscrew and remove the elevation lock knob (Fig. 25 - 1) and flat washer from the side support frame (Fig. 25 - 2). Then remove the hex bolts, spacers and washers (Fig. 25 - 3) from the bottom of the side support frame. Keep all the removed fasteners in the same configuration to be reinstalled later.

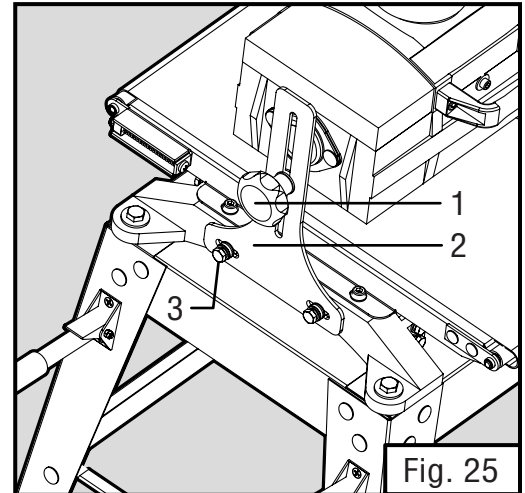


Fig. 25

4. Remove the side support frame from the sander body.

5. Unscrew and remove the two cap screws and flat washers (Fig. 26 - 1) from the conveyor table.

6. Hold the both sides of the conveyor belt and gently lift the conveyor table as you slide off the conveyor belt.

7. Lift the conveyor table and slide on a new replacement belt. Replace the conveyor table cap screw and flat washers.

8. Reinstall the side support frame and replace the fasteners to secure the frame in place.

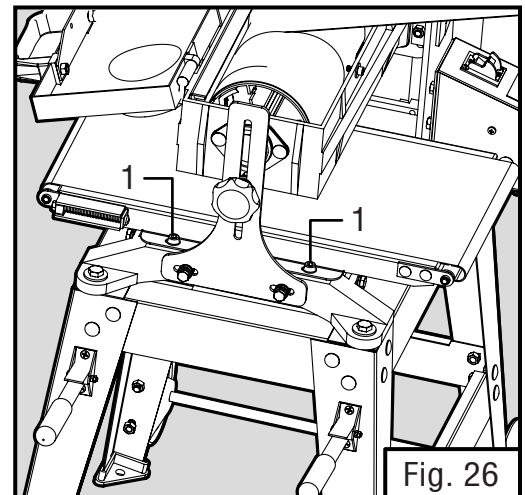


Fig. 26

9. Center the new conveyor belt on the conveyor table and evenly tension the belt.

# TROUBLESHOOTING

**⚠ WARNING:** Stop using the tool immediately if any of the following problems occur. Repairs and replacements should only be performed by an authorized technician. For any questions, please contact our customer service at (800) 232-1195, M-F 8-5 CST or email us at [techsupport@wenproducts.com](mailto:techsupport@wenproducts.com).

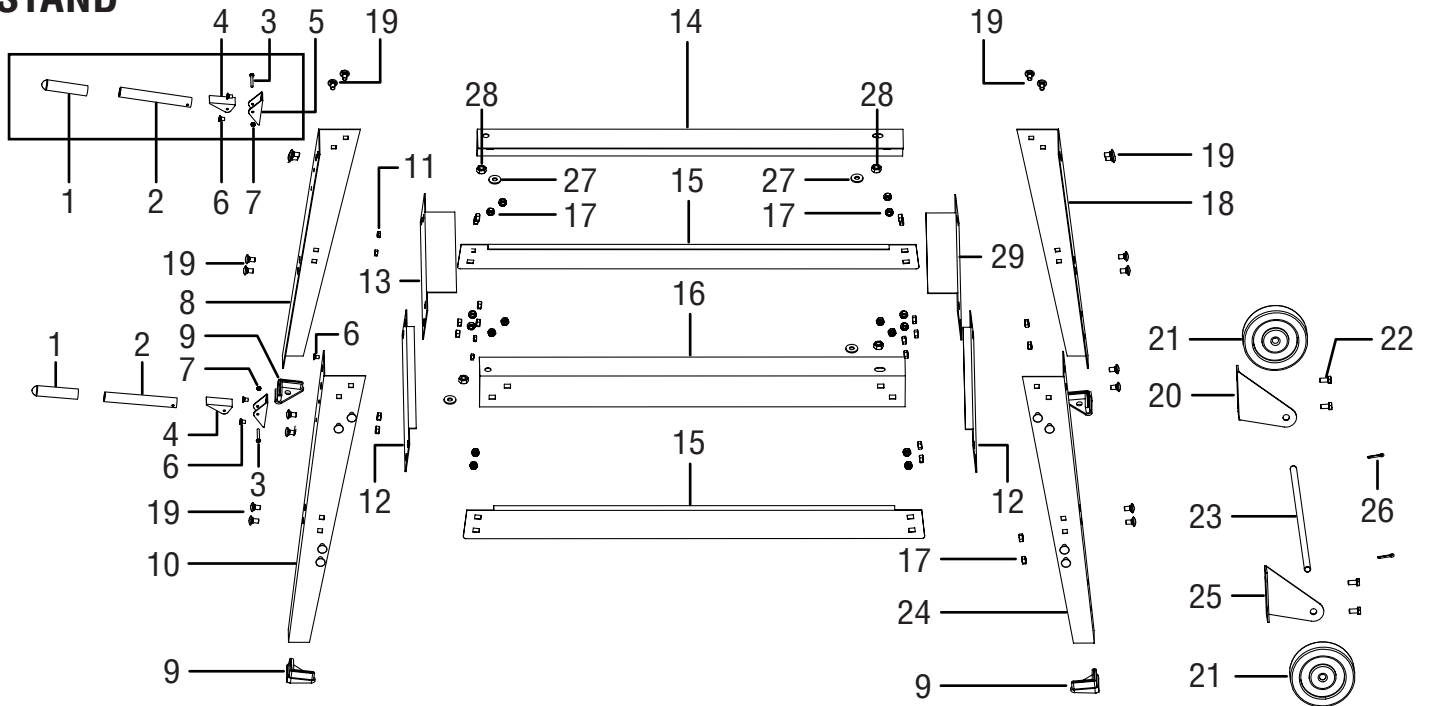
PROBLEM	COMMON CAUSE	SOLUTION
Machine does not start	<ol style="list-style-type: none"> <li>1. Safety key removed from switch.</li> <li>2. The power cord damaged or not properly plugged in.</li> <li>3. Faulty capacitor.</li> <li>4. Motor overloaded and circuit breaker trips.</li> <li>5. Loose wire or connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-install switch safety key.</li> <li>2. Check the power cord, power plug and the power outlet. Do not use if power cord is damaged.</li> <li>3. Test capacitor; replace if faulty.</li> <li>4. Wait for motor to cool, then reduce depth of cut or feed rate. Press breaker to reset.</li> <li>5. Check power switch and circuit breaker box for loose connections.</li> </ol>
Machine stalls or overloaded.	<ol style="list-style-type: none"> <li>1. Workpiece material not suitable for sanding</li> <li>2. Depth of cut too much</li> <li>3. Feed rate too high.</li> <li>4. Power source not adequate.</li> <li>5. Motor fan intake blocked.</li> </ol>	<ol style="list-style-type: none"> <li>1. Only sand natural wood products. Ensure moisture content is below 20% (page 14).</li> <li>2. Reduce depth of cut (page 18).</li> <li>3. Reduce feed rate (page 19).</li> <li>4. Ensure circuit amperage rating is adequate for the tool.</li> <li>5. Remove obstructions to fan intake.</li> </ol>
Excessive vibration or noise.	<ol style="list-style-type: none"> <li>1. Motor or components loose.</li> <li>2. Machine sits unevenly on floor.</li> <li>3. Motor fan rubbing on fan cover.</li> <li>4. Faulty motor bearings.</li> <li>5. Faulty sanding drum bearings.</li> <li>6. Sandpaper damaged or not properly installed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect and tighten/replace fasteners.</li> <li>2. Bolt machine on stable stand, set on flat ground.</li> <li>3. Fix/replace fan cover or fan.</li> <li>4. Contact customer service at 1-800-232-1195 for assistance.</li> <li>5. Contact customer service at 1-800-232-1195 for assistance.</li> <li>6. Replace/re-install sandpaper.</li> </ol>
Sandpaper clogs quickly.	<ol style="list-style-type: none"> <li>1. Depth of cut too much.</li> <li>2. Feed rate too slow.</li> <li>3. Sandpaper grit too fine.</li> <li>4. Workpiece has high moisture content or sap.</li> <li>5. Poor dust collection.</li> <li>6. Sandpaper loaded with sawdust and gum.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce depth of cut (page 18).</li> <li>2. Increase feed rate (page 19).</li> <li>3. Use coarser grit sandpaper.</li> <li>4. Clean/replace sandpaper more frequently or use different workpiece with less moisture.</li> <li>5. Unclog ducts and re-connect dust collection system.</li> <li>6. Clean/replace sandpaper.</li> </ol>
Burn marks on workpiece.	<ol style="list-style-type: none"> <li>1. Sanding grit too fine.</li> <li>2. Sandpaper loaded with sawdust.</li> <li>3. Depth of cut too much.</li> <li>4. Feed rate too slow.</li> <li>5. Sandpaper strip overlapped.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use coarser grit sandpaper.</li> <li>2. Clean/replace sandpaper.</li> <li>3. Decrease depth of cut (page 18).</li> <li>4. Increase feed rate (page 19).</li> <li>5. Properly re-install sandpaper strip (page 16).</li> </ol>

# TROUBLESHOOTING

PROBLEM	COMMON CAUSE	SOLUTION
Workpiece slips on conveyor.	<ol style="list-style-type: none"> <li>1. Conveyor belt dirty or worn.</li> <li>2. Pressure rollers not properly adjusted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean/replace conveyor belt (page 22).</li> <li>2. Properly adjust pressure roller (page 23).</li> </ol>
Uneven workpiece thickness from side to side.	<ol style="list-style-type: none"> <li>1. Height lock knob not tight and sanding drum is deflecting up.</li> <li>2. Conveyor belt not parallel to sanding drum.</li> <li>3. Height adjustment tension screws are too loose.</li> <li>4. Conveyor belt is worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Fully tighten height lock knob after setting the depth of cut.</li> <li>2. Properly adjust conveyor belt to sanding drum alignment (see page 23).</li> <li>3. Properly adjust the height adjustment tension screws (see page 22).</li> <li>4. Replace conveyor belt (page 27).</li> </ol>
Conveyor belt slips or does not track correctly	<ol style="list-style-type: none"> <li>1. Belt tension not properly adjusted.</li> <li>2. Belt tracking not properly adjusted.</li> <li>3. Conveyor belt is worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Properly adjust belt tension (page 18).</li> <li>2. Properly adjust belt tracking (page 22).</li> <li>3. Replace conveyor belt (page 27).</li> </ol>
Height adjustment wheel hard to rotate.	<ol style="list-style-type: none"> <li>1. Height lock knob too tight.</li> <li>2. Leadscrew and nut clogged with sawdust.</li> <li>3. Height adjustment tension screws are too tight.</li> </ol>	<ol style="list-style-type: none"> <li>1. Loosen the height lock knob.</li> <li>2. Clean and lubricate the leadscrew and nut (page 22).</li> <li>3. Properly adjust the height adjustment tension screws (page 22).</li> </ol>
Sandpaper strip becomes loose or comes off sanding drum.	<ol style="list-style-type: none"> <li>1. Sandpaper strip not properly wrapped onto drum.</li> <li>2. Sandpaper strip not cut to the correct dimensions (3" x 62.5").</li> <li>3. Slack in sanding strip.</li> <li>4. Torn or damaged sandpaper strip.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-install sandpaper strip properly (page 16).</li> <li>2. Only use sandpaper strips that are cut to the correct dimensions that match your existing sandpaper.</li> <li>3. Properly wrap sandpaper strip and make sure the right end is fully inserted into the clamp slot (page 16).</li> <li>4. Replace sandpaper (page 16).</li> </ol>
Ripples or lines in workpiece.	<ol style="list-style-type: none"> <li>1. Uneven feed rate.</li> <li>2. Height lock knob not tight and sanding drum deflecting from workpiece.</li> </ol>	<ol style="list-style-type: none"> <li>1. Maintain an even feed rate through the entire sanding operation.</li> <li>2. Make sure the height lock knob is tight.</li> </ol>
Snipe marks in workpiece.	<ol style="list-style-type: none"> <li>1. Improper pressure roller tension.</li> <li>2. Workpiece too long without sufficient support.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust pressure roller tension evenly (page 23).</li> <li>2. Use roller stands or tables on the infeed and outfeed ends of the conveyor table to prevent workpiece from bending.</li> </ol>

# EXPLODED VIEW & PARTS LIST

## STAND

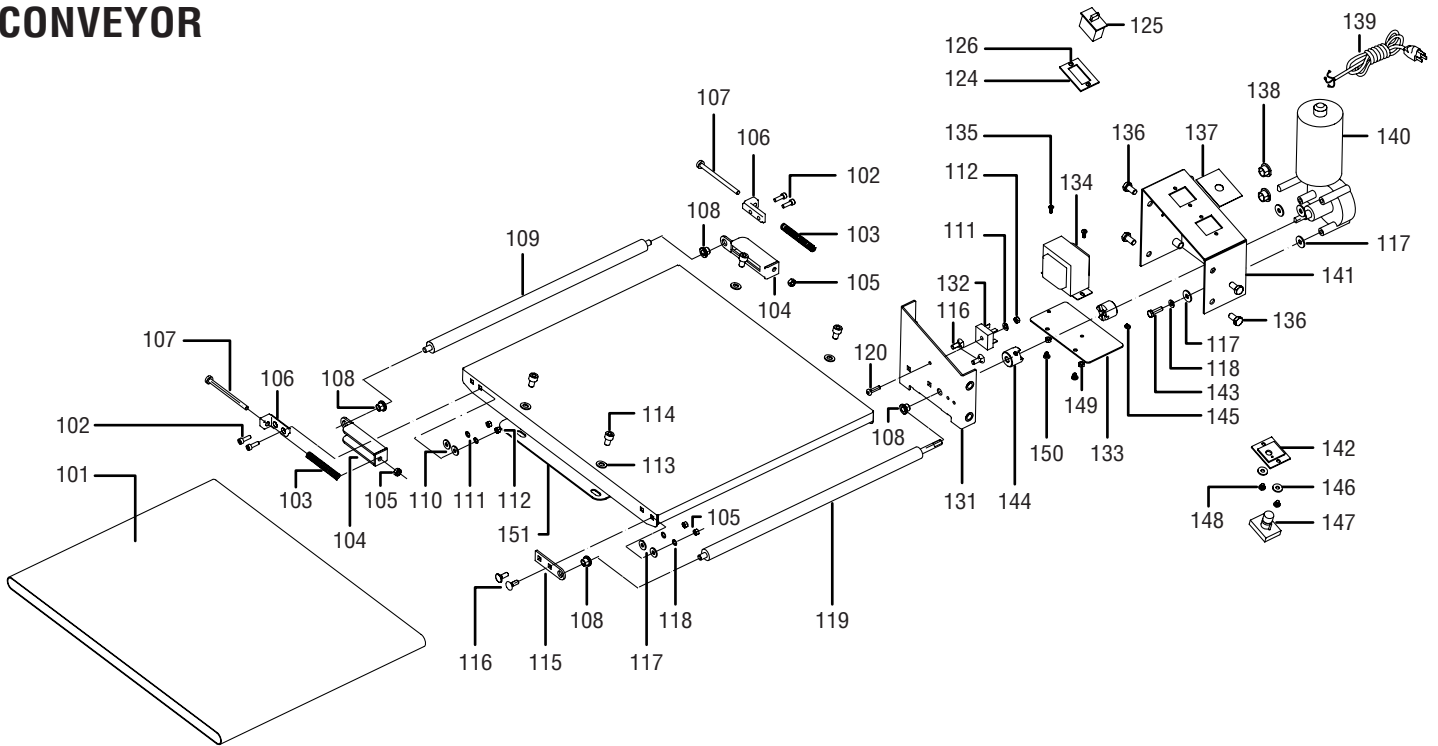


NO.	PART NO.	DESCRIPTION	QTY.
1	65911-001 (Handle)	Handle Grip	2
2		Handle	2
3		Phlp Hd Screw M4-0.7 x 35	2
4		Handle Bracket	2
5		Handle Base	2
6		Flat Hd Scr M6-1 x 10	4
7		Hex Nut M4-0.7	2
8	65911-008	Left Front Stand Leg	1
9	65910-009	Leg Foot Pad	4
10	65911-010	Right Front Stand Leg	1
11	65910-011	Lock Nut M6-1	4
12	65910-012	Short Bottom Brace	2
13	65910-013	Front Short Top Brace	1
14	65910-014	Left Long Top Brace	1
15	65910-015	Long Bottom Brace	2
16	65910-016	Right Long Top Brace	1

NO.	PART NO.	DESCRIPTION	QTY.
17	65910-017	Lock Nut M8-1.25	36
18	65911-018	Left Rear Stand Leg	1
19	65910-019	Carriage Bolt M8-1.25 x 12	32
20	65910-020	Left Wheel Mounting Bracket	1
21	65910-021	Wheel 5"	2
22	65910-022	Hex Bolt M8-1.25 x 16	4
23	65910-023	Wheel Axle	1
24	65911-024	Right Rear Stand Leg	1
25	65910-025	Right Wheel Mounting Bracket	1
26	65910-026	Cotter Pin 4 x 20	2
27	65910-027	Flat Washer 10mm	4
28	65910-028	Lock Nut M10-1.5	4
29	65910-029	Rear Short Top Brace	1

# EXPLODED VIEW & PARTS LIST

## CONVEYOR



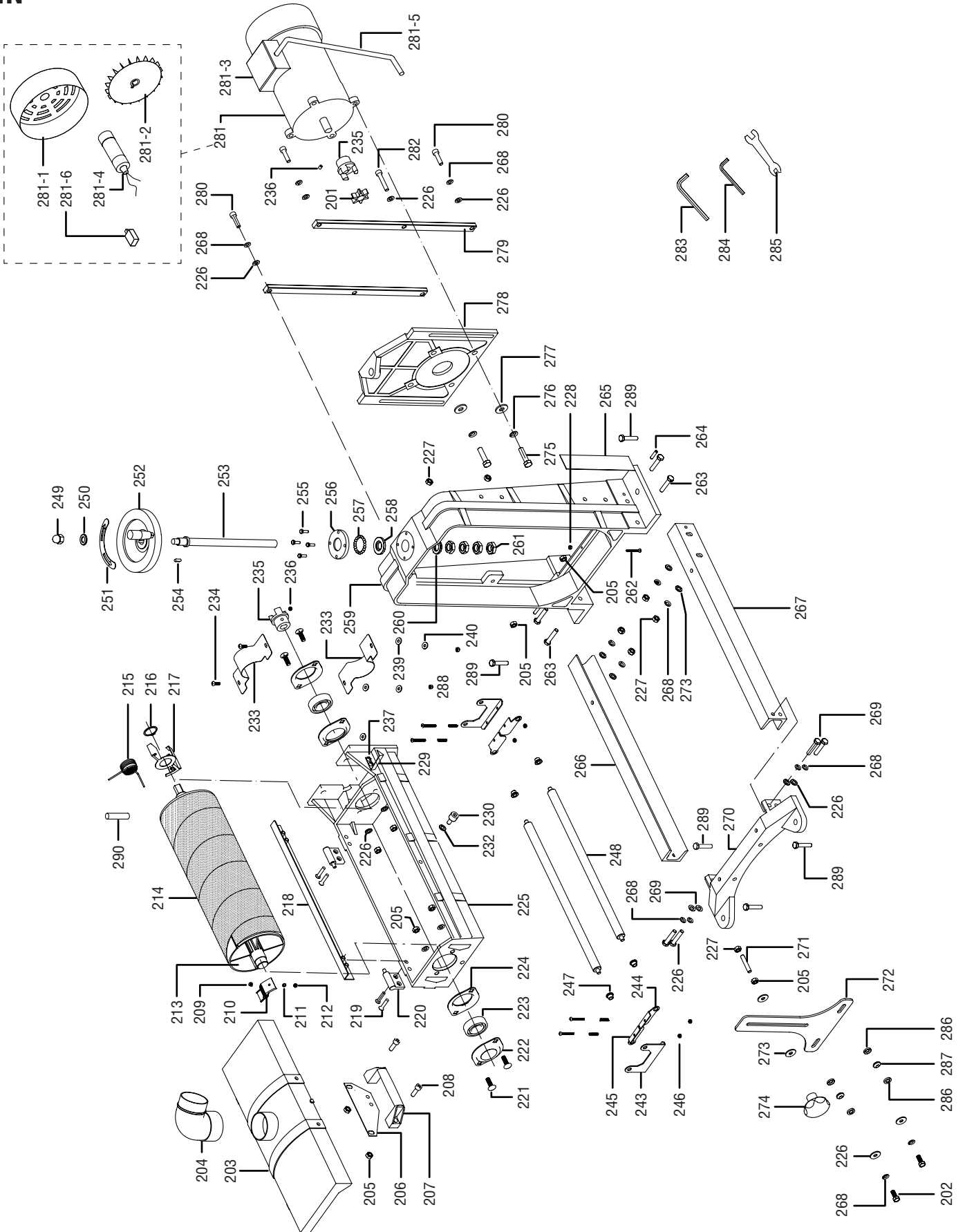
NO.	PART NO.	DESCRIPTION	QTY.
101	65910-101	Conveyor Belt	1
102	65910-102	Cap Screw M5-0.8 x 16	4
103	65910-103	Compression Spring	2
104	65910-104	Outfeed Adjustable Roller Bracket	2
105	65910-105	Hex Nut M6-1	3
106	65910-106	Adjustable Slide	2
107	65910-107	Phlp Hd Scr M6-1 x 90	2
108	65910-108	Feed Roller Bushing	4
109	65910-109	Outfeed Roller	1
110	65910-110	Flat Washer 5mm	4
111	65910-111	Lock Washer 5mm	5
112	65910-112	Hex Nut M5-0.8	5
113	65910-113	Flat Washer 8mm	4
114	65910-114	Cap Screw M8-1.25 x 12	4
115	65910-115	Infeed Roller Bracket	1
116	65910-116	Carriage Bolt M6-1 x 16	6
117	65910-117	Flat Washer 6mm	12
118	65910-118	Lock Washer 6mm	9
119	65910-119	Infeed Roller	1
120	65910-120	Phlp Hd Scr M5-0.8 x 20	1
124	65910-121	Switch Cover	1
125	65910-122	Safety On / Off Switch	1
126	65910-123	Phlp Hd Scr M4-0.7 x 12	1

NO.	PART NO.	DESCRIPTION	QTY.
131	65910-131	Switch Housing Bracket	1
132	65910-132	Terminal Block 4P	1
133	65910-133	Switch Housing Plate	1
134	65910-134	Transformer Omron Hf-7A 24/120V	1
135	65910-135	Phlp Hd Scr M4-0.7 x 10	2
136	65910-136	Hex Bolt M8-1.25 x 16	4
137	65910-137	Insulation Plate	1
138	65910-138	Strain Relief 1/2" Snap-In	3
139	65910-139	Power Cord 14G 3C 10' 42870	1
140	65910-140	Conveyor Motor 24Vdc	1
141	65910-141	Switch Housing	1
142	65910-142	Insulation Pad	1
143	65910-143	Hex Bolt M6-1 x 20	3
144	65910-144	Conveyor Clutch	2
145	65910-145	Flat Washer 4mm	2
146	65910-146	Flat Washer 5mm	2
147	65910-147	Vs Feed Dial Hf-7A 71015	1
148	65910-148	Phlp Hd Scr M5-0.8 x 6	2
149	65910-149	Hex Nut M4-0.7	2
150	65910-150	Phlp Hd Scr M5-0.8 x 10	2
151	65910-151	Conveyor Table	1



# EXPLODED VIEW & PARTS LIST

## MAIN





No.	Part No.	Description	Qty.
201	65910-201	Clutch Damper	1
202	65910-202	Hex Bolt M8-1.25 x 30	2
203	65910-203	Dust Hood	1
204	65910-204	Dust Connector 90 Deg 4"	1
205	65910-205	Lock Nut M8-1.25	9
206	65910-206	Locking Plate	1
207	65910-207	Dust Hood Handle	1
208	65910-208	Cap Screw M8-1.25 x 25	2
209	65910-209	Flat Hd Scr M4-0.7 x 8	1
210	65910-210	Left Sandpaper Clamp	1
211	65910-211	Lock Washer 4mm	1
212	65910-212	Hex Nut M4-0.7	1
213	65910-213	Sanding Drum V2.08.10	1
214	65910-SP80	Sandpaper 3"W x 63" 80 Grit	1
215	65910-215	Torsion Spring	1
216	65910-216	Ext Retaining Ring 28mm	1
217	65910-217	Right Sandpaper Clamp	1
218	65910-218	Internal Drum Guard	1
219	65910-219	Flat Hd Scr M6-1 x 30	4
220	65910-220	Dust Hood Hinge	2
221	65910-221	Carriage Bolt M8-1.25 x 25	4
222	65910-222	Outside Bearing Retainer	1
223	65910-223	Ball Bearing 6205-2Rs	2
224	65910-224	Internal Bearing Retainer	3
225	65910-225	Drum Housing	1
226	65910-226	Flat Washer 8mm	16
227	65910-227	Hex Nut M8-1.25	5
228	65910-228	Hex Nut M6-1	1
229	65910-229	Pointer	1
230	65910-230	Cap Screw M6-1 x 14	1
232	65910-232	Flat Washer 6mm	1
233	65910-233	Auxiliary Guard	2
234	65910-234	Phlp Hd Scr M5-0.8 x 16	4
235	65910-235	Drum Clutch	2
236	65910-236	Set Screw M6-1 x 8	2
237	65910-237	Cap Screw M4-0.7 x 20	2
238	65910-238	Flat Washer 4mm	2
239	65910-239	Flat Washer 5mm	2
240	65910-240	Lock Washer 5mm	2
241	65910-241	Phlp Hd Scr M4-0.7 x 30	4
242	65910-242	Compression Spring	4
243	65910-243	Pressure Roller Bracket	2
244	65910-244	Right Bracket Support	2
245	65910-245	Left Bracket Support	2
246	65910-246	Lock Nut M4-0.7	4
247	65910-247	Pressure Roller Bushing	4
248	65910-248	Pressure Roller	2
249	65910-249	Acorn Nut M12-1.75	1

No.	Part No.	Description	Qty.
250	65910-250	Flat Washer 12mm	1
251	65910-251	Elevation Rotation Label	1
252	65910-252	Handwheel Assembly	1
253	65910-253	Elevation Leadscrew	1
254	65910-254	Key 5 x 5 x 16	4
255	65910-255	Hex Bolt M5-0.8 x 16	1
256	65910-256	Shaft End Cap	23
257	65910-257	Steel Ball	1
258	65910-258	Bearing Race	1
259	65910-259	Frame Casting	1
260	65910-260	Leadscrew Flat Washer 16mm	1
261	65910-261	Thin Nut M16-1.5	4
262	65910-262	Phlp Hd Scr M6-1 x 35	1
263	65910-263	Hex Bolt M8-1.25 x 40	4
264	65910-264	Roll Pin 6 x 26	2
265	65910-265	Elevation Scale	1
266	65910-266	Outfeed Roller Support	1
267	65910-267	Infeed Roller Support	1
268	65910-268	Lock Washer 8mm	12
269	65910-269	Hex Bolt M8-1.25 x 25	4
270	65910-270	Conveyor Support	1
271	65910-271	Threaded Stud M8-1.25 x 80	1
272	65910-272	Drum Housing Support	1
273	65910-273	Fender Washer 8mm	6
274	65910-274	Knob M8-1.25	1
275	65910-275	Hex Bolt M10-1.5 x 30	4
276	65910-276	Lock Washer 10mm	4
277	65910-277	Flat Washer 10mm	4
278	65910-278	Motor Mount	1
279	65910-279	Gib	2
280	65910-280	Cap Screw M8-1.25 x 30	4
281	65910-281	Motor 1-1/2Hp 110V 60Hz	1
281-1	65910-281.1	Motor Fan Cover	1
281-2	65910-281.2	Motor Fan	1
281-3	65910-281.3	Motor Junction Box	1
281-4	65910-281.4	S Capacitor 80 uF 300V	1
281-5	65910-281.5	Motor Cord 14G 3C 18"	1
281-6	65910-281.6	Circuit Breaker 12A	1
282	65910-282	Cap Screw M8-1.25 x 45	2
283	65910-283	Hex Wrench 6mm	1
284	65910-284	Hex Wrench 5mm	1
285	65910-285	Combo Wrench 11mm/13mm	1
286	65910-286	Flat Washer 8mm	4
287	65910-287	Spacer 8mm	4
288	65910-288	Hex Nut M5-0.8	4
289	65910-289	Hex Bolt M10-1.5 x 35	4
290	65910-290	Holding Pin	1

# WARRANTY STATEMENT

WEN Products is committed to building tools that are dependable for years. Our warranties are consistent with this commitment and our dedication to quality.

## LIMITED WARRANTY OF WEN PRODUCTS FOR HOME USE

GREAT LAKES TECHNOLOGIES, LLC (“Seller”) warrants to the original purchaser only, that all WEN consumer power tools will be free from defects in material or workmanship during personal use for a period of two (2) years from date of purchase or 500 hours of use; whichever comes first. Ninety days for all WEN products if the tool is used for professional or commercial use. Purchaser has 30 days from the date of purchase to report missing or damaged parts.

SELLER’S SOLE OBLIGATION AND YOUR EXCLUSIVE REMEDY under this Limited Warranty and, to the extent permitted by law, any warranty or condition implied by law, shall be the replacement of parts, without charge, which are defective in material or workmanship and which have not been subjected to misuse, alteration, careless handling, misrepair, abuse, neglect, normal wear and tear, improper maintenance, improper storage, incorrect lubricants/fuels, or other conditions adversely affecting the Product or the component of the Product, whether by accident or intentionally, by persons other than Seller. To make a claim under this Limited Warranty, you must make sure to keep a copy of your proof of purchase that clearly defines the Date of Purchase (month and year) and the Place of Purchase. Place of Purchase must be a direct vendor of Great Lakes Technologies, LLC. Purchasing through third party vendors, including but not limited to garage sales, pawn shops, resale shops, or any other secondhand merchant, voids the warranty included with this product. Contact [techsupport@wenproducts.com](mailto:techsupport@wenproducts.com) or 1-800-232-1195 with the following information to make arrangements: your shipping address, phone number, serial number, required part numbers, and proof of purchase. Damaged or defective parts and products may need to be sent to WEN before the replacements can be shipped out.

Upon the confirmation of a WEN representative, your product may qualify for repairs and service work. When returning a product for warranty service, the shipping charges must be prepaid by the purchaser. The product must be shipped in its original container (or an equivalent), properly packed to withstand the hazards of shipment. The product must be fully insured with a copy of the proof of purchase enclosed. There must also be a description of the problem in order to help our repairs department diagnose and fix the issue. Repairs will be made and the product will be returned and shipped back to the purchaser at no charge for addresses within the contiguous United States.

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REMEMBERING**

