



Operating Instructions and Parts Manual

Bench-top Drum Sander

Model JWDS-1020



JET
427 New Sanford Road
LaVergne, Tennessee 37086
Ph.: 800-274-6848
www.jettools.com

Part No. M-723510
Edition 3 05/2025
Copyright © 2019 JET



1.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. This drum sander is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a drum sander, do not use until proper training and knowledge have been obtained.
5. Do not use this drum sander for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear ANSI Z87.1 approved safety glasses or face shield while using this drum sander. (Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.)
7. Before operating this machine, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Kickback occurs when the workpiece is thrown towards the operator at a high rate of speed. If you do not have a clear understanding of kickback and how it occurs, DO NOT operate this drum sander.
9. Wear hearing protection (plugs or muffs) during extended periods of operation.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the OFF position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
16. Make sure the sander is firmly secured to the stand or work table before use.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. Keep children away.
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall onto moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep conveyor and abrasives clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use bare hands.
28. Do not stand on the machine. Serious injury could occur if the machine tips over.
29. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
30. Remove loose items and unnecessary work pieces from the area before starting the machine.

31. Stand out of the path of workpiece when feeding a board.
32. Always feed stock against the rotation of drum.
33. Keep hands clear when feeding parts onto the conveyor. The part will be forced down as it begins to feed, causing a pinching action between the part and the conveyor table. Never reach into a running machine. Turn off sander,

allow it to come to a complete stop, and disconnect from power, before attempting to retrieve parts from beneath the drum.

34. Pay particular attention to instructions on reducing risk of kickback.
35. Don't use in dangerous environment. Don't use power tools in damp or wet location or expose them to rain. Keep work area well lighted.

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

⚠ CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or machine damage.

⚠ WARNING

This means that if precautions are not heeded, it may result in serious or fatal injury.

⚠ DANGER

This means that if precautions are not heeded, it will result in serious or fatal injury.

2.0 About This Manual

This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model JWDS-1020 Drum Sander. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

This manual is not intended to be an exhaustive guide to sanding methods, choice of stock, selection of abrasives, etc. Additional knowledge may be obtained from experienced users or trade articles. Whatever accepted methods are used, always make personal safety a priority.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠ WARNING

Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

Register your product using the mail-in card provided or register online: www.jettools.com/product-registration

To quickly reach the product registration webpage, scan the QR code below.



3.0 Table of Contents

Section	Page
1.0 IMPORTANT SAFETY INSTRUCTIONS	2
2.0 About This Manual	3
3.0 Table of Contents	4
4.0 Specifications	5
5.0 Setup and Assembly	7
5.1 Shipping Contents	7
5.2 Tools Required for Assembly	7
5.3 Handle	7
5.4 Mounting to Workbench	7
5.5 Dust Collection	7
5.6 Installing Abrasives	7
6.0 Electrical Connections	8
6.1 Grounding Instructions	8
6.2 Extension Cords	9
7.0 Adjustments	9
7.1 Drum Height Control	9
7.2 Depth Scale	9
7.3 Conveyor Belt Tension/Tracking	9
7.4 Inspecting Drum Alignment	10
7.5 Tension Roller Adjustment	11
8.0 Operations	11
8.1 Basic Operating Procedure	11
8.2 Switch Safety Key	11
8.3 Circuit Breaker Reset	12
8.4 Setting Depth of Cut	12
8.5 Establishing Drum Height	12
8.6 Maximum Performance Tips	12
9.0 User-Maintenance	14
9.1 Cleaning and Lubrication	14
9.2 Drum Maintenance	14
9.3 Conveyor Belt Replacement	14
9.4 Commutator Brush Inspection	15
9.5 Additional Servicing	15
10.0 Abrasives	16
10.1 Selecting Drum Abrasives	16
10.2 Cleaning Abrasive Strips	16
10.3 Increasing Abrasive Life	16
10.4 Abrasive Selection Guide	16
11.0 Troubleshooting JWDS-Series Drum Sander	17
12.0 Optional Accessories	18
13.0 Replacement Parts	18
13.1.1 JWDS-1020 Drum Sander – Exploded View	19
13.1.2 JWDS-1020 Drum Sander Parts List	20
14.0 Electrical Connections for JWDS-1020	22
15.0 Warranty and Service	23

4.0 Specifications

Table 1

Model Number	JWDS-1020
Stock Number	723510
Motor and Electricals	
Drum Motor Type	Totally Enclosed, Fan-Cooled Induction
Horsepower	1 HP (0.75 kW)
Phase	1
Voltage	115 V
Cycle	60 Hz
Listed FLA (full load amps)	8 A
Motor Speed	1720 RPM
Starting Amps	34.5 A
Running Amps (no load)	4.8 A
Running Capacitor	30 μ F 250VAC
Conveyor Motor Type	Totally Enclosed DC
Horsepower	1/30 HP (25 W)
Phase	1
Voltage	115 V
Listed FLA (full load amps)	0.6 A
Motor Speed	54 RPM
On/off Switch	Toggle with Safety Key
Power Transfer	Direct Drive
Power Cable and Plug	SJT 3x16AWG, 300V, 6 ft., 15A plug
Recommended Circuit Size ¹	15 A
Sound Emission ²	70.6 dB at 100cm (3.3ft.); 74.7 dB at 50cm (1.6ft.)
Capacities	
Maximum Board Width (single pass)	10 in. (254 mm)
Maximum Board Width (two passes)	20 in. (508 mm)
Maximum Board Thickness	3 in. (76.2 mm)
Minimum Board Length	2-3/8 in. (60.3 mm)
Minimum Board Thickness ³	1/32 in. (0.8 mm)
Main materials	
Main Body	Aluminum Die Casting and Steel
Drum	Extruded Aluminum
Conveyor Table	Steel
Drum Height Adjustment Handle	Plastic
Sanding Drum	
Drum Dimensions, L x Dia	10 x 5 in. (254 x 127 mm)
Drum Speed	1725 RPM
Abrasive Installed	80 Grit, 3in. Wide, Alum. Ox.
Drum Elevation Per One Rotation of Handwheel	1/16 in. (1.6 mm)
Conveyor	
Conveyor Speed	Variable Within 0 to 10 FPM (0-3 MPM)
Conveyor Table Dimensions	10 x 15 in. (254 x 381 mm)
Dust collection	
Dust Port Outside Diameter	4 in. (101.6 mm)
Recommended Minimum Extraction Volume	550 CFM

Dimensions	
Assembled Dimensions, LxWxH	26-27/32 x 17-29/32 x 17-7/8 in. (682 x 455 x 454 mm)
Shipping Dimensions, LxWxH	24 x 18-7/8 x 17-5/8 in. (61 x 48 x 44 cm)
Weights	
Net Weight (approx.)	73 lbs. (34 kg)
Shipping Weight (approx.)	82 lbs. (37.19 kg)

¹ Subject to local/national electrical codes.

² The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

³ Use of a carrier or backer board (not provided) is recommended for cuts 1/16" or less. See section 8.4 Setting Depth of Cut.

L=length, W=width, H=height, Dia=diameter

CFM = cubic feet per minute

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

⚠ WARNING

Read and understand the entire contents of this manual before attempting set-up or operation. Failure to comply may cause serious injury.

5.0 Setup and Assembly

Open box and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Any missing parts should be reported to your distributor. Do not discard shipping material until the Drum Sander is assembled and running satisfactorily.

5.1 Shipping Contents

- 1 Sander with conveyor table
- 1 Handle
- 4 Foam pads
- 1 Operation and Parts manual
- 1 Product registration card

5.2 Tools Required for Assembly

3mm hex wrench
Straight edge (such as straight steel bar or carefully jointed board)

Additional tools may be needed for adjustments or mounting the sander to a workbench.

5.3 Handle

Install handle onto elevating screw, aligning flat in handle shaft with flat on elevating screw. Tighten set screw with 3mm hex wrench to secure handle.



Figure 5-1: Installing Handle

5.4 Mounting to Workbench

The sander should be bolted to a workbench or table to avoid any tendency to creep or slide during sanding operations. Use appropriate fasteners (not provided) through the 4 slots in the machine base.

5.5 Dust Collection

Dust collection is mandatory for a safe work environment and extended abrasive life. The JWDS-1020 is equipped with a 4-inch dust collection port. Secure a 4-inch dust collection hose (not provided) to the port with a hose clamp (see Figure 5-2). Connect to a high volume dust collector, minimum 400 CFM. *Note: Dryer vent hose is not acceptable for this purpose.*

A standard shop canister vacuum (16 gal. or larger) can be used for short periods of sanding time but requires converting the hose size down to 2-1/2". An adaptor is required.



Figure 5-2 (hose and clamp not included)

5.6 Installing Abrasives

Proper attachment of the abrasive strip to the drum is critical to achieving top performance from your drum sander.

An 80-grit, 3-inch wide abrasive strip is pre-installed on the drum. Optional pre-cut ("Ready-to-Wrap") abrasives of different grits are also available; see section 12.0 *Optional Accessories*.

(TIP: If you are using an after-market abrasive, use a new JET-supplied abrasive as a template to quickly cut a new strip. Alternatively, a diagram is supplied in Figure 5-3 showing trim measurements.)

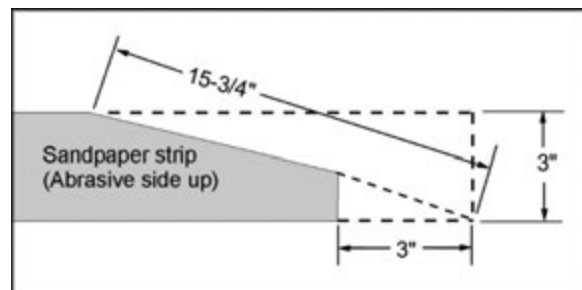


Figure 5-3: Abrasive Trimming – (not applicable to Ready-to-Wrap strips)

1. Rotate hood latch counterclockwise to open.
2. Press fastener lever (Figure 5-4) on outboard (left) end of drum, and insert tapered end of abrasive through slit in fastener, as shown. Align tapered edge of abrasive strip with left edge of drum. Insert enough strip so that the

right edge aligns with the reference notch; this will ensure the proper length of strip to be secured at the opposite end of the drum.

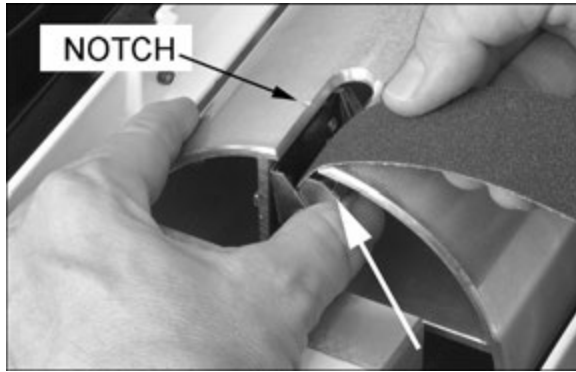


Figure 5-4

3. Release fastener lever to secure end of strip.
4. Begin wrapping abrasive around drum. The tapered edge of strip end should follow as closely as possible to edge of drum.
5. Continue to wrap abrasive in spiral fashion by rotating drum with one hand and guiding strip with the other. See Figure 5-5.

Successive windings of strip must not have any overlap. They should be flush with previous windings or with a slight gap between.

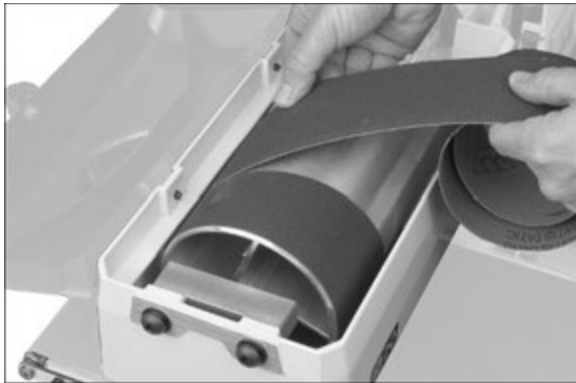


Figure 5-5

6. Press inboard take-up lever (Figure 5-6) and insert trailing end of strip as far as it will go. If necessary, trim tapered end of abrasive strip.
7. Release inboard take-up lever to secure strip.

All abrasive strips will stretch over time as they are used, and may stretch enough to allow the take-up lever to reach its lowest position so that it cannot maintain tension on the strip. If this occurs, follow the above procedures to reset the take-up lever.

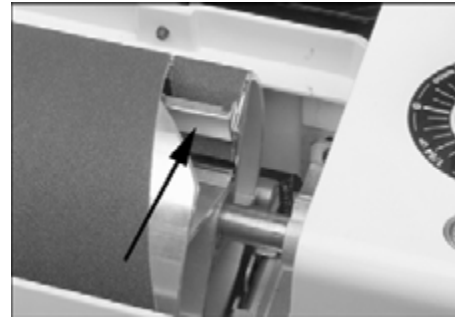


Figure 5-6

6.0 Electrical Connections

⚠ WARNING

Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

The JWDS-1020 sander is rated for 115-volt power only. Before connecting to power source, be sure the machine power switch is in *off* position and the safety key is removed.

This machine should be connected to a dedicated 15-amp circuit with a 15-amp circuit breaker or time-delay fuse marked "D". **Local codes take precedence over recommendations.**

6.1 Grounding Instructions

This machine must be grounded. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having 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 qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation that is green, 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.

⚠ WARNING

Check with a qualified electrician or service person if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded. Failure to comply may cause serious or fatal injury.

115V Operation

This model is intended for use on a 115V circuit and has a grounded outlet that matches the machine's electrical cord plug, as shown in Figure 6-1.

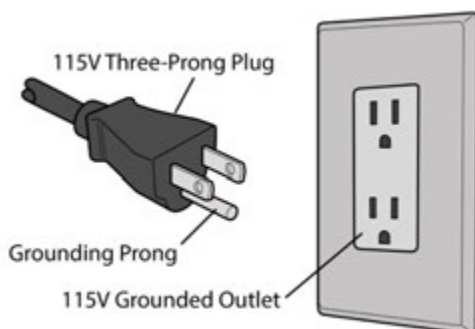


Figure 6-1: 115V Connection

If the outlet is not a properly grounded three-pole receptacle, do not use a temporary adaptor. Have a properly grounded three-pole receptacle installed by a qualified electrician.

6.2 Extension Cords

The use of extension cords is discouraged. If possible, position your machine within reach of the power supply. If an extension cord becomes necessary, use only 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug. Make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Do not use a damaged or worn extension cord. Repair or replace before use.

Use Table 2 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Recommended Gauges (AWG) of Extension Cords

Amp Rating		Volts	Total length of cord in feet			
More Than	Not More Than	120	25	50	100	150
		240	50	100	200	300
			AWG			
0	6		18	16	16	14
6	10		18	16	14	12
10	12		16	16	14	12
12	16		14	12	Not Recommended	

Table 2

7.0 Adjustments

7.1 Drum Height Control

Drum height and depth of cut are controlled by the height adjustment handle (see Figure 5-1). Rotating handle clockwise lowers drum, counterclockwise

raises it. One revolution of handle will move drum approximately 1/16" (or 1/4 turn = approx. 1/64"), as shown on the label below handle.

7.2 Depth Scale

The depth scale indicates distance between bottom of sanding drum and top of conveyor belt. Adjustment is performed by "zeroing" the scale.

1. Unplug sander from power source.
2. With an abrasive strip on drum, lower drum to where it touches top of conveyor belt. Note: Make sure drum contacts belt, not just the feed rollers.
3. At this drum position, the (top edge of) depth scale pointer should align with zero mark on scale. If it does not, loosen screw (Figure 7-1) and shift pointer to align with zero.
4. Retighten screw.

Note: Depending on desired accuracy, you may need to repeat this process when installing different abrasive grits.



Figure 7-1: Depth Scale Adjustment

7.3 Conveyor Belt Tension/Tracking

Conveyor belt tension adjustment may be necessary during the break-in period to compensate for belt stretching, and also after long-term use.

7.3.1 Belt Tension Adjustment

NOTE: Insufficient belt tension will cause slippage of conveyor belt on drive roller during sanding operation. The conveyor belt is too loose if it can be stopped by hand pressure applied directly to top of moving conveyor belt. Excessive belt tension can result in bent rollers, bent brackets, and/or premature wearing of bushings or conveyor belt.

To adjust conveyor belt tension:

1. Turn take-up screw (A, Figure 7-2) with 5mm hex wrench. Do this on *both sides* of conveyor to obtain approximately equal tension on both sides of sanding belt when taut.
2. Check conveyor belt tracking before operating machine. Proceed to section 7.3.2 *Tracking Adjustment*.

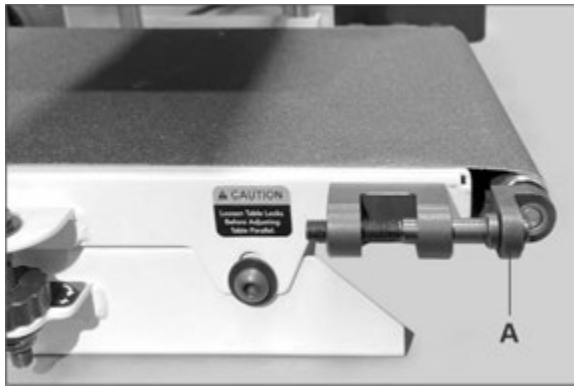


Figure 7-2: Belt Tension Adjustment

7.3.2 Tracking Adjustment

A belt tracks correctly when it moves centrally on the conveyor rollers without drifting to either side. Tracking adjustments are made while conveyor belt is running.

1. Make sure proper belt tension has been achieved (see section 7.3.1 *Belt Tension Adjustment*).
2. Turn on conveyor and set to maximum speed. Watch for tendency of conveyor belt to drift to one side of conveyor.
3. If conveyor drifts, turn take-up screw (A, Figure 7-2) counterclockwise to tighten the side the belt is drifting toward. Turn the opposite side take-up screw clockwise to loosen.

Note: Adjust take-up screw only 1/4-turn at a time. Allow time for belt to react to adjustments before proceeding further.

Avoid over-adjusting, as this may affect belt tension. If tension is affected, it may become necessary to use both take-up screws to accomplish tensioning and tracking.

7.4 Inspecting Drum Alignment

The sanding drum must be parallel to conveyor table for proper machine operation. The sanding drum comes pre-aligned from the manufacturer. If a problem with drum alignment should occur, follow the instructions below.

First, inspect the alignment with a gauge of some kind. The following procedure uses a steel straight-edge as a gauge.

1. Unplug sander from power source.
2. Open hood and remove abrasive strip from drum.
3. Position gauge (B, Figure 7-3) between drum and conveyor table at *outboard* side of drum.

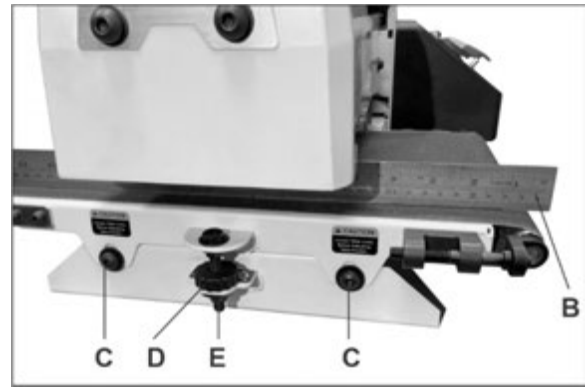


Figure 7-3: Drum Alignment

4. With hood open, lower sanding drum while slowly rotating drum by hand, until drum lightly contacts gauge. **NOTE:** Make sure gauge is contacted by the drum, not just the tension rollers. Make a note of the measurement on the sander's depth scale.
5. Remove gauge and place under drum at *inboard* side.
6. If drum does not contact gauge equally on both ends of drum, alignment is needed.

7.4.1 Performing Drum Alignment

To align conveyor table with drum:

1. Loosen both table locking screws (C, Figure 7-3) with 5mm hex wrench.



Loosen both table locking screws before adjusting drum alignment. Failure to comply may cause damage to conveyor table.

2. To *raise* outboard end of table, loosen lock nut (E, Figure 7-3) and rotate knurled nut (D, Figure 7-3) clockwise.
3. To *lower* outboard end of table, rotate knurled nut (D) counterclockwise, and tighten lock nut (E).
4. Verify setting using the gauge. Make further adjustments using knurled nut as needed.
5. Retighten table lock screws (C).

7.4.2 Fine-Tuning Drum Alignment

Note: This is an operational test for sanding boards wider than the drum. Perform this procedure only after you have become familiar with sander operation.

When sanding boards wider than the drum, table alignment is critical and table must be adjusted exactly level to slightly lower on the outboard end. This will prevent any ridges from developing in the stock. Always check this on a piece of scrap wood, as follows, before sanding the work piece.

1. Run a piece of scrap wood approximately 6" wide by 18 to 20" long through the sander

sideways so that end of board extends past outboard side of drum.

2. Without changing drum height, rotate board 180° and sand the same side.
3. If a ridge is visible where the drum overlaps, lower table at outboard end (see section 7.4.1 *Performing Drum Alignment*).
4. Repeat this process until the ridge is eliminated and entire board is sanded.

Note: When sanding narrow stock (less than 10"), return conveyor table to parallel position.

7.5 Tension Roller Adjustment

The infeed and outfeed rollers are tensioned to provide downward pressure on the workpiece to prevent slippage on the feed conveyor. Tension rollers have been set by the manufacturer, but should be inspected and may require adjustment as the sander receives use.

⚠ WARNING

Improperly adjusted tension rollers (i.e. those set too high, rendering them non-functional) could allow kickback of pieces being sanded.

Tension roller pressure may be increased or decreased by turning the screws on the tension roller brackets (Figure 7-4) at each end of drum..

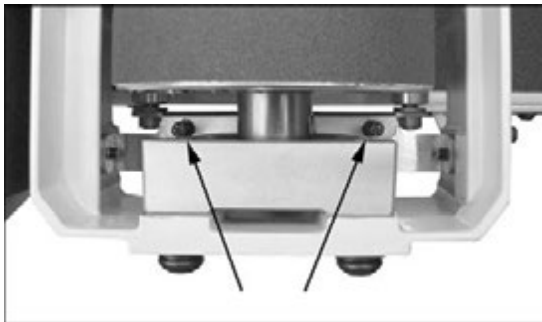


Figure 7-4: Tension Adjustment Screws

Too much tension roller pressure can result in a "snipe" mark, which is a visible line running across the width of the board and located approximately 2-1/4" from end of board.

If snipe occurs on the leading end of board, adjust outfeed tension roller. If the snipe occurs on trailing end of board, adjust infeed tension roller.

8.0 Operations

Before using your drum sander, review the previous sections on initial set-up and adjustment. Before operating, make sure an abrasive strip is mounted and a proper dust collection system is connected.

8.1 Basic Operating Procedure

1. Establish depth of cut.
2. Start dust collection system.
3. Start sanding drum (with control panel switch, Figure 8-1).
4. Start conveyor and select feed rate (with control panel dial, Figure 8-1).
5. Feed stock through machine.

To feed stock through the sander, rest and hold board to be sanded on conveyor belt, allowing conveyor belt to carry board into drum. Once stock is halfway through, reposition yourself to outfeed side of machine to receive and control board as it exits.

⚠ CAUTION

Board will be forced down against conveyor table as it begins feeding, causing pinching hazard. Keep fingers away.

⚠ CAUTION

Do not open drum hood until drum comes to a complete stop.

8.2 Switch Safety Key

To prevent unauthorized use of sander, turn off main switch and pull out safety key (Figure 8-1). Store key in a safe place. Key must be reinserted to start sander.

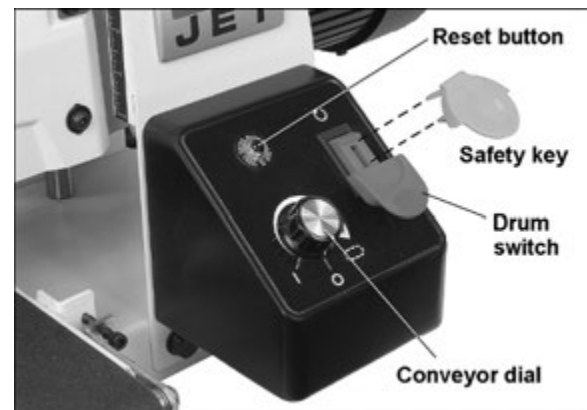


Figure 8-1: Control Panel

8.3 Circuit Breaker Reset

If the sander becomes overloaded, the built-in breaker will trip to help protect the motor. Allow the machine to cool down, then push the reset button (Figure 8-1) to restart.

If overloading happens frequently, refer to section *11.0 Troubleshooting*.

8.4 Setting Depth of Cut

Adjusting the drum sander for proper contact between abrasive and stock determines the depth of cut. The depth of cut is controlled by the height adjustment handle.

It may take experimentation to determine proper depth of cut, given the variables of abrasive grit, type of wood, and feed rate. For best results, use scrap wood to practice sanding and to develop skill and familiarity with the machine before doing finish work.

A combination of several variables will determine proper depth of cut to use, including the following:

1. Abrasive type and grit size.
2. Width of piece being processed.
3. Hardness of piece.
4. Feed rate of conveyor belt.

NOTE: The use of a carrier or backer board (not provided), is recommended for cuts 1/16" or less. This is a flat board, usually of wood or MDF, slightly larger than the workpiece and of even thickness, placed beneath the workpiece as it is fed through the sander. The workpiece may be attached to the carrier with rubber cement, carpenter's tape or some other easily removable adhesive. Some operators use a rubber or textured surface on the carrier to help stabilize the workpiece by simple friction.

8.5 Establishing Drum Height

A good rule of thumb when sanding with grits finer than 80:

1. To establish drum height, position stock under the drum. Do NOT start drum.
2. Lower drum to the stock thickness, making sure drum can still be rotated by hand while just contacting stock.



Do not start drum while in contact with stock.

3. Without changing drum height, turn on conveyor and run the stock out from under the drum. Start sanding drum and sand stock at that same position.
4. With the drum operating, feed stock under the drum from the infeed side and against the rotation of the drum. Always maintain control of the stock to avoid kickback and/or slippage.

NOTE: If motor heats up during operation, depth of cut may be too great for size of grit and/or feed rate may be too fast.

For sanding with grits coarser than 80, you can lower the drum slightly.

Always maintain control of stock. Through practice you will learn the proper depth of cut considering the variables above.

A faster feed rate allows faster sanding but fewer revolutions of the drum per inch of sanding. A slower feed rate provides more revolutions of the drum per inch of sanding to allow a greater depth of cut and smooth sanding.

Begin experimenting with the feed rate set at about 40% to 50% of maximum. The best feed rate will depend on a number of factors, including type of stock, grit and depth of cut used, and whether the stock is fed directly in line with the conveyor table or at an angle. If the drum motor is lugging down, if conveyor belt is slipping, or if you observe a ripple effect on the stock, slow the feed rate. If the finish is smooth and the machine is not overworking, you can experiment using a faster feed rate.

Also try a faster feed rate or less depth of cut if the stock you are working begins to show burn marks. With cherry, hard maple or other hardwoods, using a shallower depth of cut and a faster feed rate will help minimize burn marks. Slightly angling the stock as it is fed into the machine will also help prevent burning the stock.

Because of the wide range of variables, it is important to experiment with your specific conditions and make adjustments to achieve the optimum feed rate. If problems occur, first check and adjust the feed rate, referring to section *11.0 Troubleshooting*.

8.6 Maximum Performance Tips

The versatility designed into the JWDS-series drum sander allows it to be used for a variety of tasks that will boost return on your investment. For example, it will speed up fine sanding work often done with slower, dust-generating hand sanders, and will achieve fine thickness adjustments not possible on some sanders. It can be used to surface figured woods – bird's eye or curly maple, for example – which can be damaged if fed through a planer.

Learning how to use its adjustments and controls will allow you to fine-tune the machine for maximum results. The best results come from experimenting with different abrasive grits and machine adjustments to fit the job at hand. Following is a list of useful tips which can help you improve performance of your sander.

8.6.1 Dust Collection

When connecting dust collectors, remember that straight pipe will not restrict airflow as much as flexible tubing. Y's and elbows will restrict airflow less than T's. Also, a hose smaller than 2-1/2" diameter should not be used.

8.6.2 Multiple-Piece Sanding Runs

When abrasive planing (or thickness sanding) a run of similar pieces that you want to have the same thickness, it is best to determine the thickness of the thinnest piece and process all pieces to that same thickness in one session. Be aware that the sander will remove cups and crowns in the workpiece; consider this when measuring and processing stock to the same thickness.

8.6.3 Simultaneous Multiple Pieces

When sanding multiple pieces simultaneously, make sure to stagger (step) the pieces across the width of the conveyor belt. This provides better contact with the tension rollers. Try to process only multiple pieces of similar thickness.

If there is a significant thickness difference, the thinner pieces can slip on the conveyor belt if they do not contact the tension rollers. Also note that pieces thicker than 3/4" should be longer than the minimum normally recommended to prevent tipping of the stock.

8.6.4 Edge Sanding

When edge sanding, the sander will mimic the opposite edge of the stock which is lying on the conveyor belt. Because of this, it is important for the stock edge to have been ripped at the proper angle to the face before the sanding process. When edge sanding stock that is less than 3/4" wide or more than 2" high, it is good procedure to stack and clamp several pieces together to prevent them from slipping or tipping on the conveyor belt.

8.6.5 Sanding Imperfect Stock

When sanding stock with a cup or crown, place the crown up. This will stabilize the stock to help prevent tipping or rocking during sanding. After the crown has been removed and the top is flat, turn the stock over and sand the opposite side. To avoid personal injury, take special care when sanding stock that is twisted, bowed, or otherwise varies in thickness from end to end. If possible, support such stock as it is being sanded to keep it from slipping or tipping. Use extra roller stands, help from another person, or hand pressure on the stock, to minimize potentially hazardous situations.

8.6.6 Face Frames and Raised Panel Doors

It is very important to have the proper abrasive contact when doing this type of sanding. If the machine is set to take an excessive depth of cut, the result can be a gouge or dip as the drum goes from sanding the rails at full width to sanding just a few

inches of width on the stiles. To prevent this make sure, when using abrasives finer than 80 grit, that the drum is in contact with the wood but can still be spun by hand. If there is room, angling the stock on the conveyor belt can also help.

Slowing the conveyor feed when coming to a rail in the stock can help prevent a dip or gouge. This allows the abrasive to work the wider width with less effort, and to achieve better consistency of the finished surface.

8.6.7 Stock Feeding Angle

Some pieces, because of their dimensions, will need to be fed into the machine at a 90° angle (perpendicular to drum). However, even a slight offset angle of stock will provide for more effective stock removal. The optimum feeding angle for stock removal is about 60°.

Angling the workpiece for stock removal provides other advantages, such as less loading of certain areas of the drum due to glue lines or mineral streaks in the stock, more even wear of abrasive strips, potentially faster feed rates, and lighter loads on the motor. Note that to get the best final finish, however, the stock should be fed through the machine so it will be sanded in line with the grain of the wood on the final one or two passes.

9.0 User-Maintenance

⚠ WARNING

Before doing maintenance on the machine, disconnect it from the electrical supply (pull out the plug), unless indicated otherwise. Failure to comply may cause serious injury.

9.1 Cleaning and Lubrication

For best results, make cleaning the sander a regular shop procedure. Allowing excess build-up of dust and debris can adversely affect performance through loading of the abrasives, slippage on the conveyor table, and/or accumulation of material inside the drums which can throw off the center of balance.

Leave the dust collector on when cleaning dust from the drums. Also brush the conveyor belt after cleaning operations. If not cleaned, the conveyor belt could allow stock to slip during sanding operations.

NOTE: Bearings are pre-sealed and require no lubrication.

- Lubricate elevating leadscrew (A, Figure 9-1) as needed.
- Clean sawdust from abrasive strip and brush dust from conveyor belt.
- Keep guide bars clean (B, Figure 9-1).
- Blow dust from motor vents and switch area. Blow dust from inside of sanding drum, which may cause vibration or offset the center of balance.
- Check all set screws for tightness on parts such as bearings, conveyor table, and couplings.

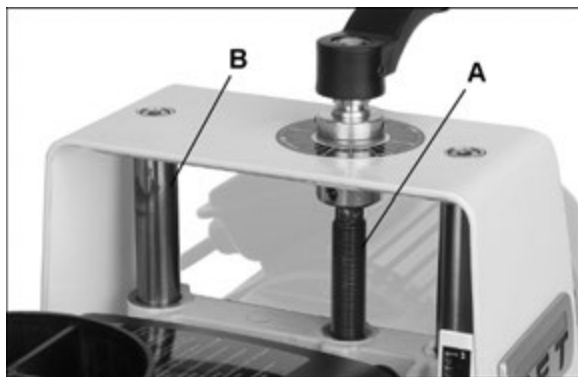


Figure 9-1

9.2 Drum Maintenance

The drum should not require removal from the machine under normal circumstances. Should maintenance ever become necessary, the drum has been designed for easy removal and replacement.

1. Remove two socket head screws (C, Figure 9-2) on the bearing block.
2. Loosen two screws on the coupling (D, Figure 9-2).
3. Carefully slide drum out of coupling and remove from machine.

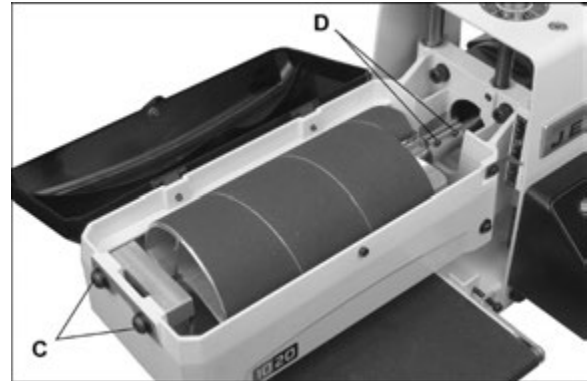


Figure 9-2: Drum Removal

9.3 Conveyor Belt Replacement

1. Disconnect sander from power.
2. Raise drum to highest position.
3. Turn take-up screws (F, Figure 9-3) on both sides of conveyor to relieve belt tension and slide the driven roller fully inward.
4. Loosen two table locking screws (G, Figure 9-3).
5. Remove lock nut (E, Figure 9-3).
6. Remove two socket head screws that attach conveyor table to base.
7. Lift up conveyor table and remove it from machine. Avoid tearing the belt on any edges underneath the conveyor table.
8. Set conveyor on motor side and slide conveyor belt off end of conveyor table.
9. Install new belt and re-install conveyor table. Check alignments, and tension and track the new belt.

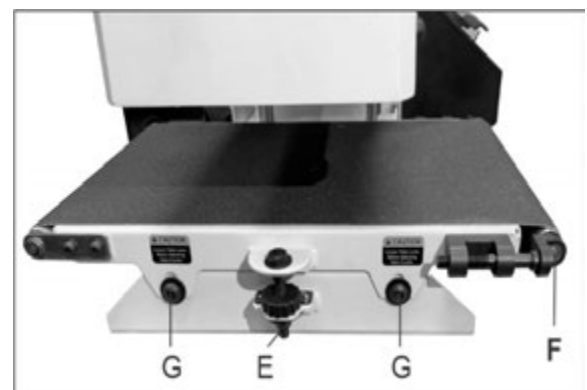


Figure 9-3

Note: If conveyor belt continually tracks to one side of the machine, reversing the belt on the conveyor table may remedy the problem. To make sure the conveyor table is not twisted, place a level on the conveyor table. Level the machine if needed. If there is still a problem, proceed with the steps below:

Step 1: Check conveyor drive roller and driven roller to make sure they are parallel to surface of conveyor table. To do this, first center conveyor belt on the conveyor table. Then lay a straight-edge on the exposed edge of conveyor table on left (outboard) side, extending it over the roller. Note distance between roller and straightedge.

Step 2: Now repeat Step 1 on right (inboard) side of conveyor. Compare the measurements from side to side. If they are not equal, loosen one of the brackets that hold the roller in place. Tip this bracket until distance between roller and straight-edge are equal from side to side, then tighten bracket.

9.4 Commutator Brush Inspection

To maintain motor efficiency, inspect the two carbon brushes every two months, or more frequently if sander is heavily used. Stalling or loss of power may be a symptom of worn carbon brushes. If one brush is worn out, replace both at the same time.

CAUTION

Continued use of damaged or worn brushes may result in damage to motor armature.

1. Unplug sander from power source.
2. Unscrew and remove cap with flat blade screwdriver. See Figure 9-4.
3. Gently pry up an edge of the brass clip, until the spring causes it to disengage from hole. (Notice orientation of brush as you remove it; it should

be inserted in the same manner; curvature of brush will match curvature of motor.)

4. Pull out brush and inspect. Brush should be replaced if any of the following are discovered:
 - Brush has worn to about 1/2-inch long.
 - Signs of crumbling, burning or breaking.
 - End of brush is rough or pitted.
 - Abnormal coloration of spring
 - Broken lead in spring
 - Collapsed spring
5. Install new brush (or reinstall current brush) and gently press it all the way into hole until the brass clip is secured.
6. Install cap.
7. Repeat for other brush.

NOTE: It is recommended that sander be run without load for several minutes to seat new brushes.

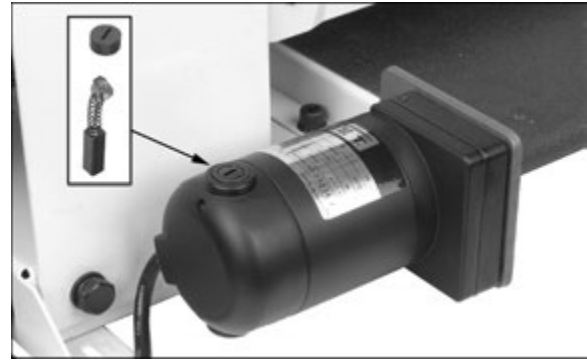


Figure 9-4

9.5 Additional Servicing

Any additional servicing should be performed by an authorized service technician.

10.0 Abrasives

The abrasive material you choose will have a substantial effect on the performance of your sander. Variations in paper type, weight, coating and durability all contribute to achieving your desired finish.

JET Abrasives are available in Ready-To-Wrap™ pre-cut lengths or in the convenient Ready-To-Cut pre-marked box. Your JET dealer can recommend the best choice for your application.

10.1 Selecting Drum Abrasives

It is important to select the proper grit of abrasive for the type of sanding being performed to achieve maximum results. As with any sanding operation, first begin sanding with a coarser grit, depending upon the roughness of the stock or the amount of stock to be removed. Then progressively work toward finer grits. The chart below shows the general uses for the various grits.

The amount of stock to be removed is a major consideration when choosing the grit grade with which to begin. Grits 24, 36, 50 and 60 are primarily designed for stock removal. Grits 24 and 36 will remove the most material in one pass, whether you are doing abrasive planing, cleaning up glued panels, or flattening stock. Grits from 100 through 220 are primarily finishing grits designed to remove the scratch pattern from the previous grit used. For best results, never skip more than one grit grade when progressing through a sanding sequence.

For fine work, such as furniture, try not to skip any grit grades during the sanding process.

In general, premium quality abrasives will produce a better finish with a less noticeable scratch pattern.

Note: Grits that are too fine can sometimes burnish the wood and leave a glossy surface which will not

accept stains evenly. This will vary by type of wood. Oak, for example, is susceptible to burnishing because of its open pores.

10.2 Cleaning Abrasive Strips

Regularly clean the abrasive strip on the drum with commercially available cleaning sticks, following the manufacturer's directions. When cleaning, also brush the stick crumbs from the drum while it is still rotating.

In some cases, heavy loaded areas can be removed with Plexiglas held on edge over the rotating drum.

CAUTION

Always wear eye protection while performing sandpaper cleaning, and take all precautions to avoid any contact of hands or clothing with the rotating drum.

Cloth-backed abrasives can be cleaned by soaking in paint thinner or mineral spirits for 20 minutes to one hour, then using a brush to remove any build-up. Dry the abrasive strips completely before using. Any used solvents should be discarded in compliance with environmental regulations.

10.3 Increasing Abrasive Life

Abrasive life can be increased not only by cleaning, but by removing the abrasive strip from the drum and reversing it. To do this, remove the strip and use what was the trailing end as the starting end on the left (outboard) side of the drum. Reversing the strip will provide a fresh set of cutting edges on the abrasive.

10.4 Abrasive Selection Guide

Grit	Common Application
24	Abrasive planing, surfacing rough-sawn boards, maximum stock removal, glue removal.
36	Abrasive planing, surfacing rough-sawn boards, maximum stock removal, glue removal.
50	Surfacing and dimensioning boards, truing warped boards
60	Surfacing and dimensioning boards, truing warped boards.
80	Light dimensioning, removal of planer ripples.
100	Light surfacing.
120	Light surfacing, minimal stock removal.
150	Finish sanding, minimal stock removal.
180	Finish sanding only, not for stock removal.
220	Finish sanding only, not for stock removal.

Table 3

11.0 Troubleshooting JWDS-Series Drum Sander

Symptom	Possible Cause	Correction *
Drum motor won't start when switch is activated.	No incoming current.	Check connections at plug or circuit panel.
	Safety key missing from switch.	Install safety key.
	Low voltage.	Check power line for proper voltage.
	Open circuit in motor or loose connection.	Inspect all lead connections on motor for loose or open connections.
	Switch malfunction.	Replace switch.
Drum motor will not start: fuses blow or circuit breakers trip.	Short circuit in line cord or plug.	Inspect cord or plug for damaged insulation and shorted wires.
	Short circuit in motor or loose connections.	Inspect all connections on motor for loose or shorted terminals or worn insulation.
	Incorrect fuse or circuit breaker in power line.	Install correct fuse or circuit breaker.
Drum motor overheats.	Air circulation through motor restricted.	Clean motor fan with compressed air to restore normal air circulation.
	Motor overloaded, excess feed rate.	Reduce conveyor speed.
	Motor overloaded, excess depth of cut.	Reduce depth of cut.
Drum motor stalls, resulting in blown fuses or tripped circuit.	Short circuit in motor or loose connections.	Inspect connections on motor for loose or shorted terminals or worn insulation.
	Low voltage.	Correct low voltage conditions.
	Incorrect fuse or circuit breaker in power line.	Install correct fuse or circuit breaker.
Loud, repetitive noise or vibration coming from machine.	Fasteners loose.	Inspect fasteners and tighten where needed.
	Motor fan is hitting cover.	Tighten fan or shim fan cover.
	Machine not level.	Place sander on flat surface, shim if needed.
Conveyor motor stalls.	Excessive depth of cut.	Reduce depth of cut; use coarser grit; reduce feed rate.
Conveyor belt slips on drive roller.	Improper conveyor belt tension.	Adjust belt tension.
	Excessive depth of cut and/or feed rate.	Reduce depth of cut and/or feed rate.
Abrasive strip comes off drum.	Slack in abrasive strip on drum.	Remove slack in strip.
	Abrasive improperly wrapped.	Read the section on installing abrasives, and rewrap.
Abrasive strip is loose.	Strip caught on inside edge of slot, or on inboard side of drum.	Re-adjust the strip end in the slot and/or trim the abrasive edge.
	Strip not cut properly.	Re-cut and re-install the abrasive strip.
Abrasive loads up prematurely.	Excessive depth of cut.	Reduce depth of cut.
	Excessive feed rate.	Reduce feed rate.
	Inadequate dust collection.	Increase airflow at dust port.
	Inadequate abrasive.	Use an open-coat abrasive.
Line or groove in stock.	Inconsistent feed rate.	Do not stop or change the feed rate while feeding stock.
Snipe marks.	Improper tension on rollers.	Re-tension rollers.

Symptom	Possible Cause	Correction *
Sander burns wood.	Abrasive strip is overlapped.	Re-wrap abrasive strip.
	Abrasive is loaded.	Clean abrasive.
	Depth of cut excessive for fine grit.	Use coarser grit or reduce depth of cut.
	Feed rate too slow.	Increase feed rate.
	Abrasive is worn.	Replace abrasive.
Board slips on conveyor belt.	Tension rollers too high.	Lower tension rollers.
	Excessive feed rate.	Reduce feed rate.
	Dirty or worn conveyor belt.	Replace conveyor belt.
Ripples in sanded surface. A. Non-uniformly spaced ripples. B. Uniformly spaced ripples.	A. Uneven feed rate.	Conveyor belt slipping (see above) Board slips on conveyor belt (see above). Conveyor motor stalls (see above).
	B. Conveyor table flexing or vibration.	Reduce depth of cut and/or feed rate. Check for loose bolts, loose shaft coupling set screws, or out-of-balance drum.
Wood is gouged.	Stock slipping on conveyor.	Correct depth of cut or roller tension.
	Work piece not properly supported.	Add work supports for long work pieces.

* **WARNING:** Some corrections may require a qualified electrician.

Table 3

12.0 Optional Accessories

The following abrasives are available for the JWDS-1020 Benchtop Drum Sander (Abrasive strips are 3" wide, cloth backed, aluminum oxide, resin bond, open coat.)

JT9-60-1060	Ready-To-Wrap™ Abrasive Strip, 60 Grit, (6 wraps in a box)
JT9-60-1080	Ready-To-Wrap™ Abrasive Strip, 80 Grit, (6 wraps in a box)
JT9-60-1100	Ready-To-Wrap™ Abrasive Strip, 100 Grit, (6 wraps in a box)
JT9-60-1120	Ready-To-Wrap™ Abrasive Strip, 120 Grit, (6 wraps in a box)
JT9-60-1150	Ready-To-Wrap™ Abrasive Strip, 150 Grit, (6 wraps in a box)
JT9-60-1180	Ready-To-Wrap™ Abrasive Strip, 180 Grit, (6 wraps in a box)
JT9-60-1220	Ready-To-Wrap™ Abrasive Strip, 220 Grit, (6 wraps in a box)
JT9-60-9036	Premium Ready-To-Cut™ Abrasive Strip, 36 Grit
JT9-60-9060	Premium Ready-To-Cut™ Abrasive Strip, 60 Grit
JT9-60-9080	Premium Ready-To-Cut™ Abrasive Strip, 80 Grit
JT9-60-9100	Premium Ready-To-Cut™ Abrasive Strip, 100 Grit
JT9-60-9120	Premium Ready-To-Cut™ Abrasive Strip, 120 Grit
JT9-60-9150	Premium Ready-To-Cut™ Abrasive Strip, 150 Grit
JT9-60-9180	Premium Ready-To-Cut™ Abrasive Strip, 180 Grit
JT9-60-9220	Premium Ready-To-Cut™ Abrasive Strip, 220 Grit

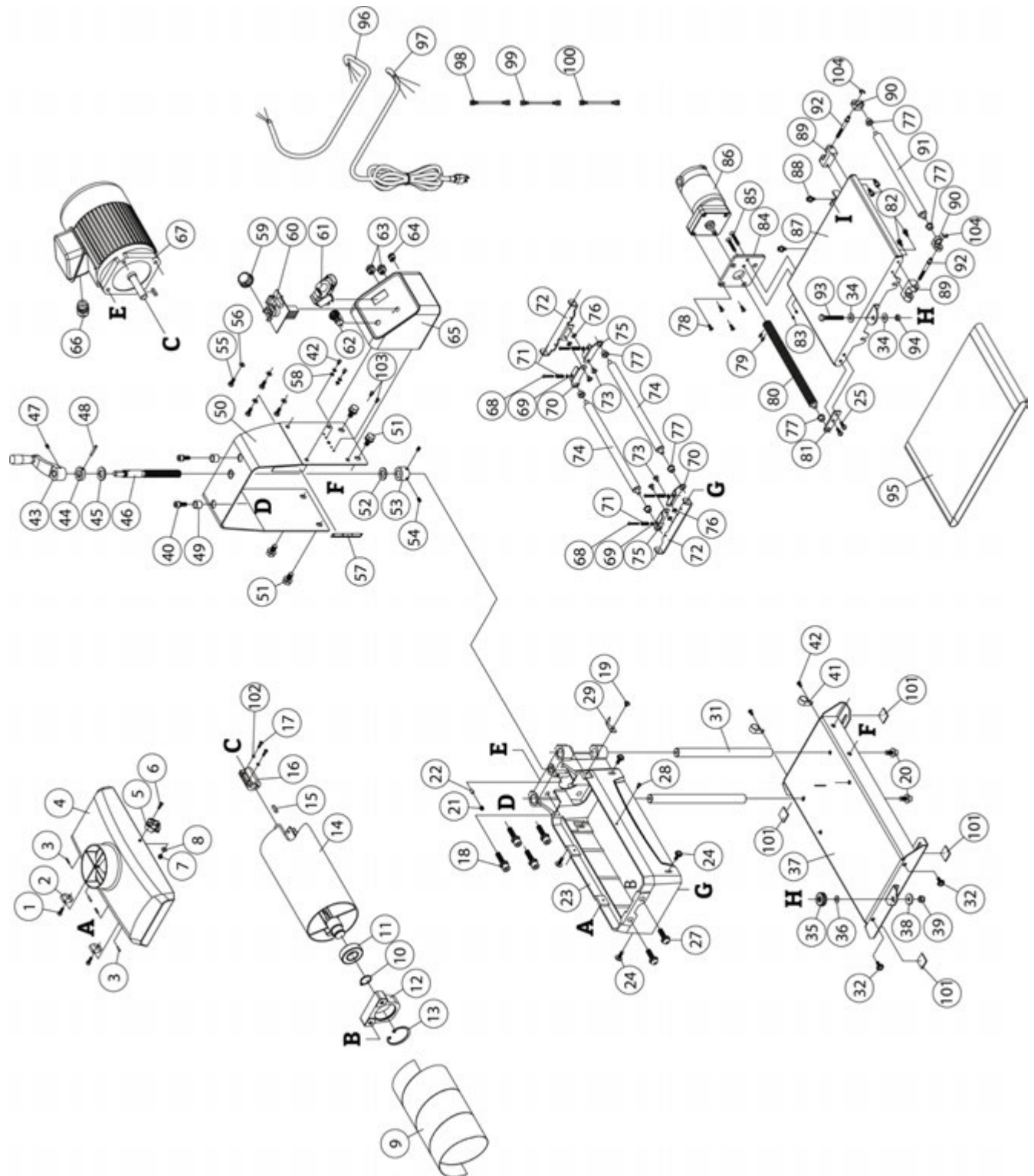
13.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET.

Some parts are shown for reference only, and may not be available individually.

13.1.1 JWDS-1020 Drum Sander – Exploded View

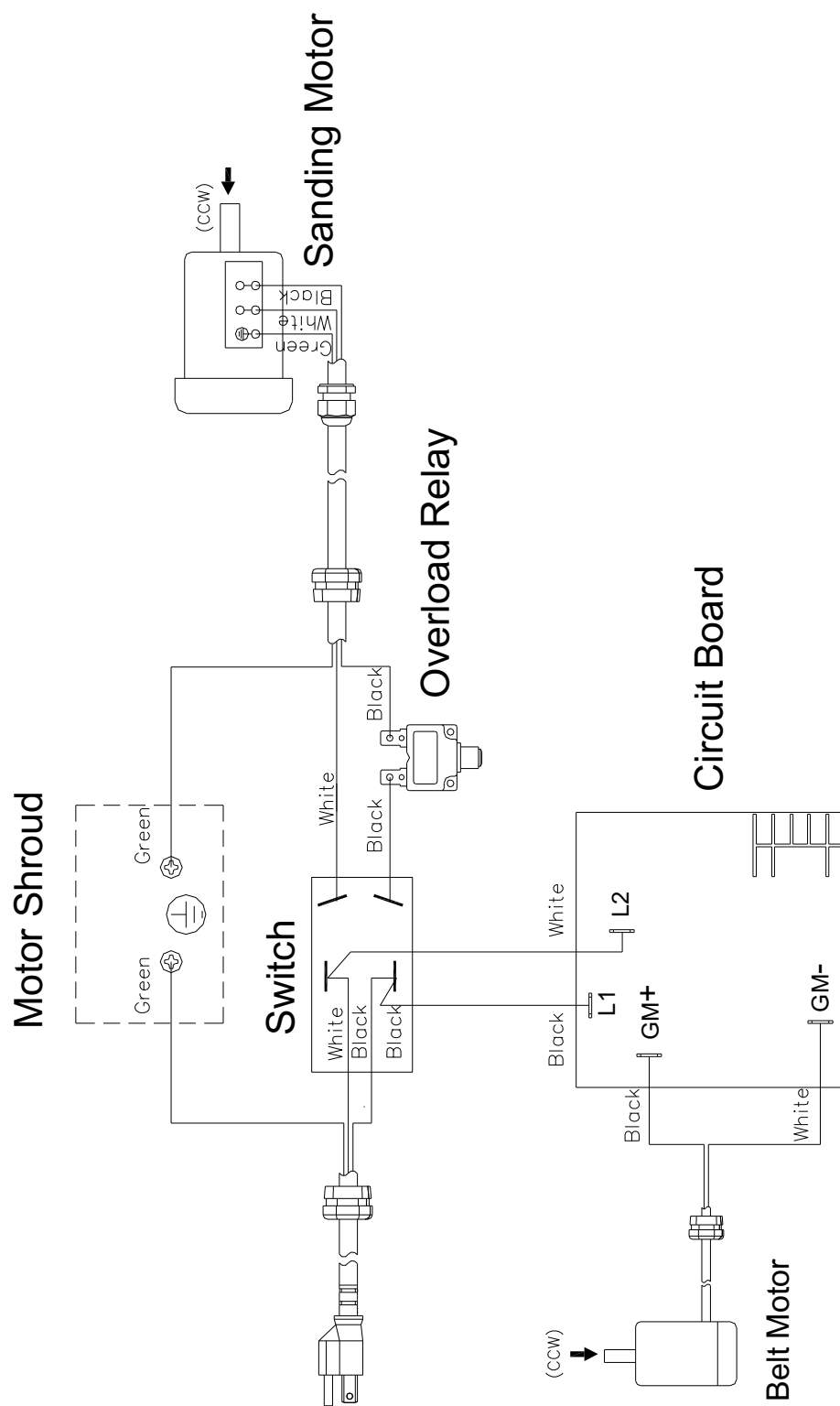


13.1.2 JWDS-1020 Drum Sander Parts List

Index	Part No	Description	Size	Qty
1	CM9-TS-1503041	Socket Head Cap Screw	M6 x 1.0P x 16L	2
2	JT9-JWDS1632-103	Drum Carriage Hinge		2
3	JT9-JWDS1632-103	Spring Pin	3 x 14L	4
4	JT9-JWDS1020-104	Dust Hood		1
5	PM9-PM2244-109	Knob		1
6	JT9-TS-1502041	Socket Head Cap Screw	M5 x 0.8P x 16L	1
7	JT9-TS-1541011	Nylon Lock Hex Nut	M5 x 0.8P	1
8	JT9-TS-1550031	Flat Washer	5.1 x 12 x 1T	1
9		Abrasive (see section 12.0 for replacements)		1
10		C-Retainer Ring Ext. (Re:14A)	STW-25	1
11		Ball Bearing (Re:14A)	6205VV	1
12		Outboard Bearing Housing (Re:14A)		1
13		C-Retainer Ring Int. (Re:14A)	RTW-52	1
14		Drum (Re:14A)		1
14A	JT9-JWDS1020-114A	Drum Assembly (includes #10-17)		1
15	5519710	Key	5 x 5 x 20L	1
16	JT9-JWDS1020-116	Coupling		1
17	CM9-TS-1501041	Socket Head Cap Screw	M4 x 0.7P x 12L	2
18	JWDS1020-118	Socket Hd. Cap Screw w/Lock & Flat Washers	M10 x 1.5P x 45L	4
19	JWDS1020-119	Phillips Pan Hd Machine Screw w/Washer	M5 x 0.8P x 10L	1
20	JWDS1020-120	Socket Hd. Cap Screw w/Lock & Flat Washers	M8 x 1.25P x 20L	2
21	5302731	Socket Head Set Screw	M8 x 1.25P x 6L	1
22	PM9-PM2244-184	PU Block		1
23	JT9-JWDS1020-123	Drum Carriage		1
24	JWDS1020-124	Socket Hd. Button Screw w/Lock & Flat Washers	M6 x 1.0P x 20L	4
25	JWDS1020-125	Socket Hd. Button Screw w/Lock Washer	M6 x 1.0P x 16L	2
27	JWDS1020-127	Socket Hd. Button Screw w/Lock & Flat Washers	M10 x 1.5P x 35L	2
28	JT9-TS-1502011	Socket Head Cap Screw	M5 x 0.8P x 8L	1
29	JT9-JWDS1020-129	Pointer		1
31	JT9-JWDS1020-131	Guide Bar		2
32	JWDS1020-132	Socket Hd. Button Screw w/Lock & Flat Washers	M8 x 1.25P x 16L	2
34	JT9-TS-1550061	Flat Washer	8.5 x 20 x 1.5T	2
35	JT9-JWDS1020-135	Knob		1
36	JT9-TS-1550061	Flat Washer	8.5 x 16 x 1.5T	3
37	JT9-JWDS1020-137	Base		1
38	JT9-TS-1550061	Flat Washer	8 x 25 x 3T	1
39	JT9-TS-1541031	Nylon Lock Hex Nut	M8 x 1.25P	1
40	JWDS1020-140	Socket Hd. Cap Screw w/thrdlckr & Lock Washer	M8 x 1.25P x 20L	2
41	JT9-JWDS1020-141	Cable Holder	ACC-6 (19mm)	2
42	JT9-TS-1533032	Phillips Pan Hd Machine Screw	M5 x 0.8P x 10L	4
43	JT9-JWDS1632-137	Crank Handle		1
44	JT9-JWDS1632-145	Collar		1
45	JT9-JWDS1632-140	Oilite Washer		1
46	JT9-JWDS1632-141	Height Adjusting Screw		1
47	CM9-TS-1523031	Socket Head Set Screw	M6 x 1.0P x 10L	1
48	JT9-JWDS1632-146	Spring Pin	4 x 30L	1
49	JT9-JWDS1020-149	Spacer		2
50	JT9-JWDS1020-150	Motor Shroud		1
51	JT9-TS-1491021	Hex Cap Screw w/Lock & Flat Washers	M10 x 1.5P x 20L	4
52	JT9-JWDS1632-148	Nylon Washer		1
53	JT9-JWDS1632-149	Collar		1
54	JT9-TS-2276081	Socket Head Set Screw	M6 x 1.0P x 8L	2
55	F011767	Pan Hd Phillips Tapping Screw	#14 x 3/4L	4
56	CM9-TS-1550041	Flat Washer	6 x 12 x 1T	4
57	JT9-JWDS1632-163	Depth Scale		1
58	JT9-F002097	Lock Washer, Ext. Tooth	M5	4
59	PM9-PM2244-196	Knob		1
60	JT9-JWDS1020-160	Circuit Board		1
61	JT9-JSG96-135	Switch		1
	JT9-JSG96-135A	Switch Key (not shown)		1

Index	Part No	Description	Size	Qty
62	JT9-JWDS1020-162.....	Overload Relay		1
63	JT9-JPS10TS-351.....	Strain Relief	SR-6R3	2
64	JT9-JWDS1020-164.....	Strain Relief	SB5P-2	1
65	JT9-JWDS1020-165.....	Control Box (incl. LM000390 Label)		1
66	JT9-JWDS1632-153.....	Strain Relief	PG 11.....	1
67	JT9-JWDS1020-167.....	Motor	"1HP, 115V, 60Hz"	1
	JT9-JWDS1020-167RC	Running Capacitor (not shown)	30mF 250VAC	1
	JT9-JWDS1020-167FC	Fan Cover (not shown)		1
	JT9-JWDS1020-167CF	Cooling Fan (not shown)		1
	JT9-JWDS1020-167WB	Wiring Box		1
	JT9-JWDS1020-167WBC	Wiring Box Cover.....		1
68	JT9-JWDS1020-168.....	Phillips Round Head Machine Screw	M4 x 0.7P x 30L	4
69	CM9-TS-1550021	Flat Washer	4.2 x 8 x 0.8T	4
70	JT9-JWDS1020-170.....	Right Tension Roller Suspension Bracket		2
71	PM9-PM2244-125	Compression Spring		4
72	JT9-JWDS1020-172.....	Tension Roller Fixed Bracket		2
73	PM9-PM2244-132	Shoulder Screw		4
74	JT9-JWDS1020-174.....	Tension Roller		2
75	JT9-JWDS1020-175.....	Left Tension Roller Suspension Bracket		2
76	63049	Wave Washer	WW-6	8
77	PM9-PM2244-130	Oilite Bushing		7
78	F010678	Socket Head Flat Screw	#10-32UNC x 1/2in L	4
79	JT9-TS-1522011	Socket Head Set Screw.....	M5 x 0.8P x 5L	2
80	JT9-JWDS1020-180.....	Drive Roller		1
81	JT9-JWDS1632-208.....	Drive Roller Bracket.....		1
82	JWDS1020-182.....	Socket Hd. Cap Screw w/Lock Washer.....	M6 x 1.0P x 12L	4
83	JT9-TS-1521021	Socket Head Set Screw.....	M4 x 0.7P x 5L	2
84	JT9-JWDS1632-204.....	Belt Motor Plate		1
85	JT9-F010985	Socket Head Flat Screw	M6 x 1.0P x 35L	2
86	JT9-JWDS1020-186.....	Belt Motor	1/30HP 115V	1
87	JWDS1020-187.....	Conveyor Table (serial #25068218 and lower).....		1
	JT1-2361	Conveyor Table (serial #25068219 and higher)		1
88	CM9-TS-1504031.....	Socket Hd. Cap Screw w/Lock & Flat Washers.....	M8 x 1.25P x 16L	2
89	JT9-JWDS1632-217.....	Bracket		2
90	JT9-JWDS1632-219.....	Driven Roller Bracket.....		2
91	JWDS1020-191A	Driven Roller		1
92	JT9-JWDS1632-218.....	Adjusting Rod		1
93	JT9-TS-1490101	Hex Cap Screw.....	M8 x 1.25P x 55L	1
94	JT9-TS-2311081	Hex Nut.....	M8 x 1.25P	1
95	JT9-JWDS1020-195.....	Conveyor Belt		1
96	JT9-JWDS1020-196.....	Motor Cable	SJT 16AWG x 3C	1
97	JT9-JWDS1020-197.....	Power Cable	SJT 16AWG x 3C	1
98	JT9-JWDS1020-198.....	Internal Connection Cable (Black).....	ST 16AWG x 1C x 10cm.....	1
99	JT9-JWDS1020-199.....	Internal Connection Cable (White).....	ST 16AWG x 1C x 15cm	1
100	JWDS1020-200.....	Internal Connection Cable (Black).....	ST 16AWG x 1C x 15cm.....	1
101	JT9-JWDS1020-1101.....	Foam Pad (set of 4).....		4
102	CM9-TS-2361041	Lock Washer.....	M4.....	2
103	JWDS1020-1103.....	Phillips Pan Hd Machine Screw.....	M5 x 0.8P x 5L.....	2
104	JT9-JWDS1632-220.....	Retaining Ring	ETW-7	2
	JT9-JET-92	JET Logo (<i>not shown</i>)	92x38mm	1
	JT9-LM000385	Warning Label, JWDS-1020 (<i>not shown</i>)		1
	JT9-LM000386	ID Label, JWDS-1020 (<i>not shown</i>)		1
	JT9-JWDS1632-142.....	Incremental Depth Scale (<i>not shown</i>)		1
	JT9-LM000236	Caution Label - Table Lock (<i>not shown</i>).....		2
	JT9-JWDS1632-163.....	Depth Scale (<i>not shown</i>)		1
	JT9-LM000387	Parallel Adjust Label (<i>not shown</i>)		1
	JT9-LM000388	Motor Label, JWDS-1020 (<i>not shown</i>)		1
	JT9-LM000389	Belt Motor Label (<i>not shown</i>).....		1
	JT9-LM000390	Control Panel Label (<i>not shown</i>)		1

14.0 Electrical Connections for JWDS-1020



15.0 Warranty and Service

JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET 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. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.



427 New Sanford Road
LaVergne, Tennessee 37086
Phone: 800-274-6848
www.jettools.com