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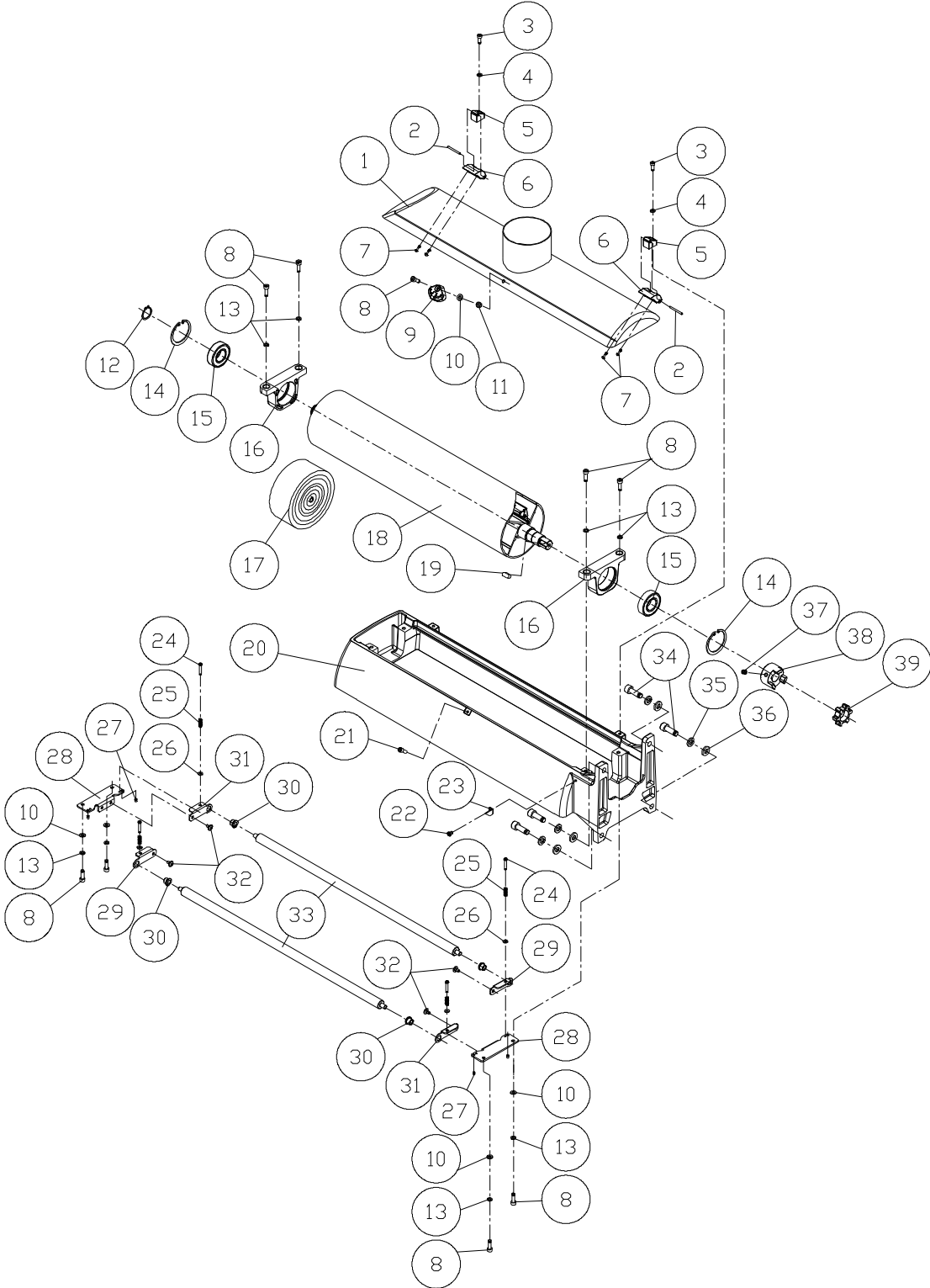
Operating Instructions and Parts Manual Drum Sander Model PM2244



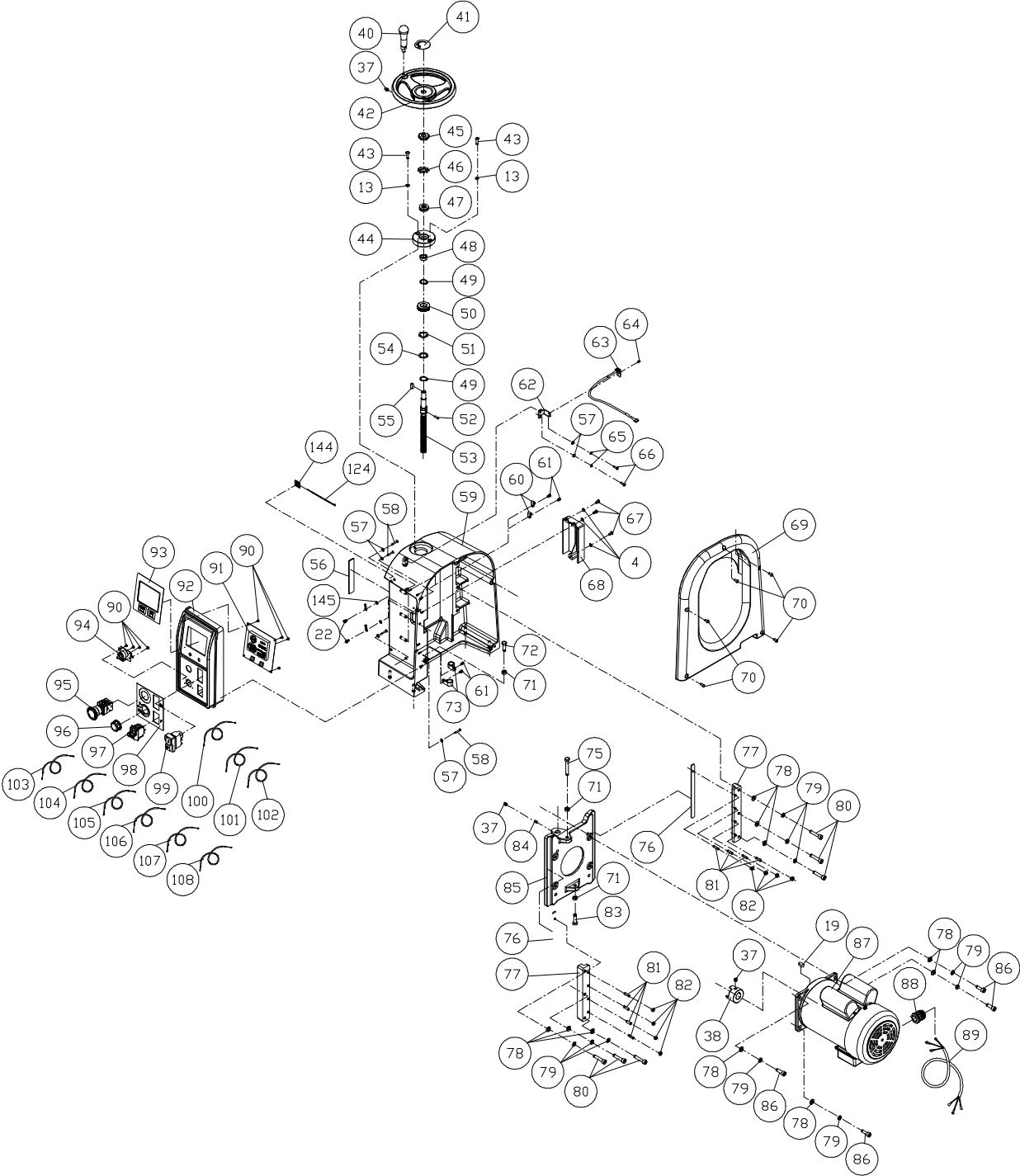
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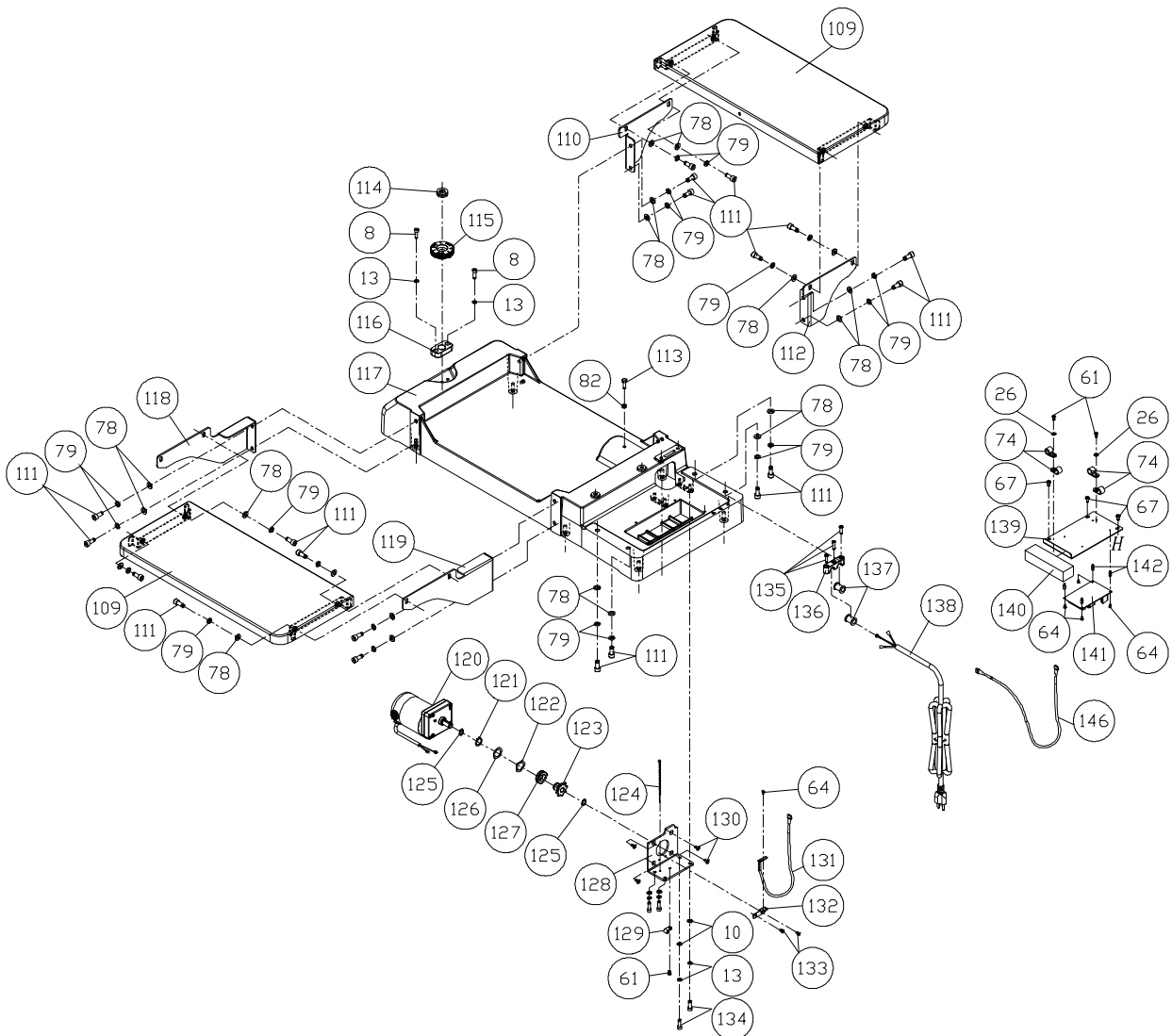
14.1.1 PM2244 Head Assembly I – Exploded View



14.1.2 PM2244 Head Assembly II – Exploded View



14.1.3 PM2244 Head Assembly III – Exploded View



14.1.4 PM2244 Head Assembly – Parts List

Note: Some parts may be listed for reference only and not available individually.

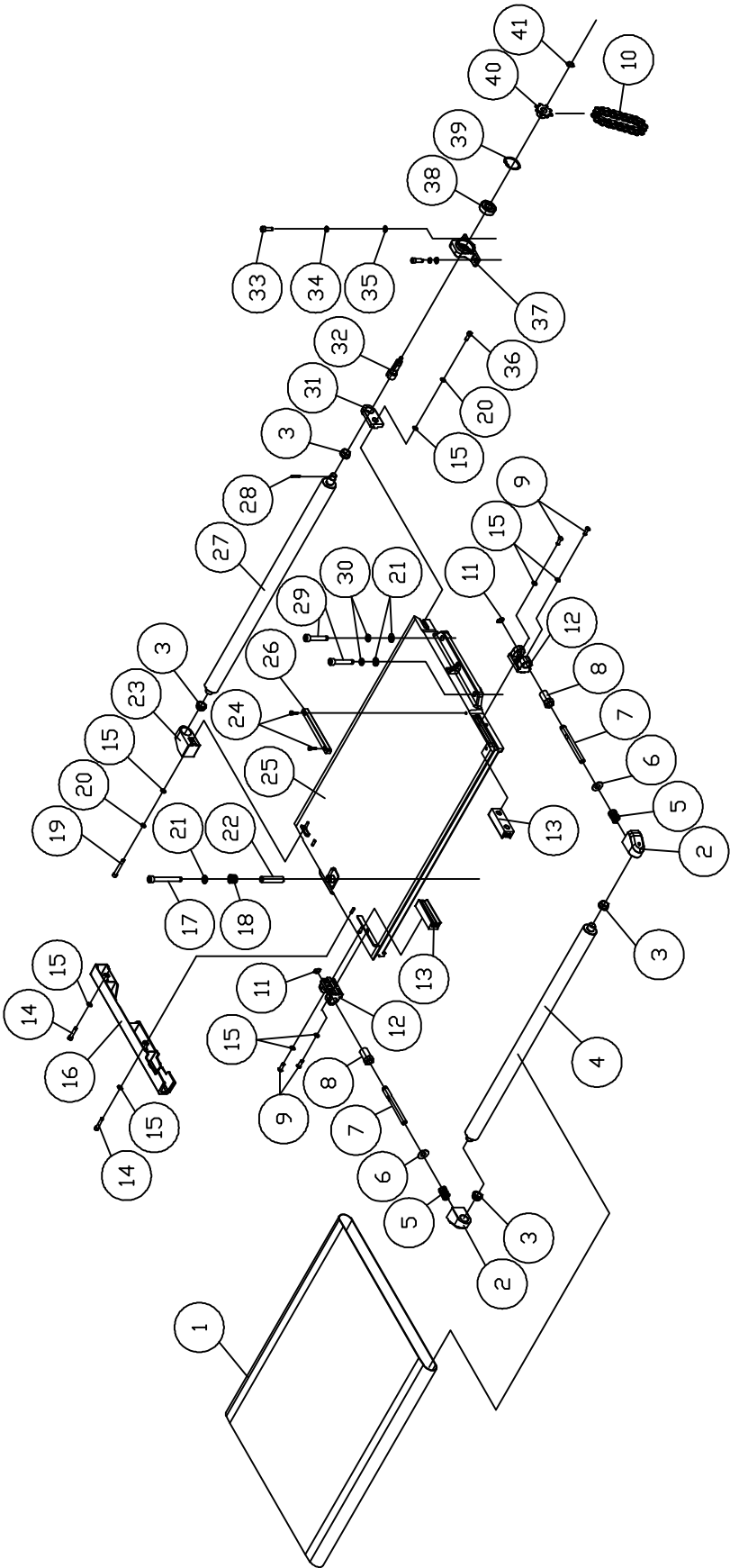
| Index No | Part No | Description | Size | Qty |
|----------|-------------|--|-------------------|-----|
| 1 | PM2244-101 | Dust Hood | | 1 |
| 2 | JCH4-16 | Spring Pin | 3*35 | 2 |
| 3 | F005365 | Socket Head Cap Screw | M5*0.8P*16L | 2 |
| 4 | F002633 | Flat Washer | 5.2*10*1.0T | 5 |
| 5 | PM2244-105 | Drum Carriage Hinge | | 2 |
| 6 | PM2244-106 | Dust Hood Hinge | | 2 |
| 7 | F011287 | Self Tapping Screw | M4*1.41P*12L | 4 |
| 8 | F005383 | Socket Head Cap Screw | M6*1.0P*20L | 11 |
| 9 | PM2244-109 | Knob | | 1 |
| 10 | F002636 | Flat Washer | 6.3*13*1.0T | 9 |
| 11 | F001694 | Nylon Insert Lock Nut | M6*1.0P | 1 |
| 12 | | Retaining Ring (Re:18A) | STW-25 | 1 |
| 13 | F002111 | Lock Washer | M6 | 16 |
| 14 | | Retaining Ring (Re:18A) | RTW-52 | 2 |
| 15 | | Ball Bearing (Re:18A) | 6205VV | 2 |
| 16 | | Bearing Housing (Re:18A) | | 2 |
| 17 | | Abrasive ¹ | 80 grit, 3" width | 1 |
| 18 | | Drum (Re:18A) | | 1 |
| 18A | PM2244-118A | Drum Assembly (includes #12,14-16,18,19,37-39) | | 1 |
| 19 | | Key (Re:18A) | 8*7*18 | 2 |
| 20 | PM2244-120 | Drum Carriage | | 1 |
| 21 | F005665 | Socket Head Cap Screw | M6*1.0P*15L | 1 |
| 22 | F001208 | Phillips Pan Head Screw | M5*0.8P*8L | 3 |
| 23 | PM2244-123 | Pointer | | 1 |
| 24 | PM2244-124 | Phillips Round Head Screw | M4*0.7P*25L | 4 |
| 25 | PM2244-125 | Compression Spring | | 4 |
| 26 | F002631 | Flat Washer | 4*10*1.0T | 6 |
| 27 | F010384 | Socket Set Screw | M4*0.7P*4L | 4 |
| 28 | PM2244-128 | Tension Roller Bracket | | 2 |
| 29 | PM2244-129 | Left Tension Roller Suspension Bracket | | 2 |
| 30 | PM2244-130 | Oilite Bushing | | 4 |
| 31 | PM2244-131 | Right Tension Roller Suspension Bracket | | 2 |
| 32 | PM2244-132 | Shoulder Screw | | 4 |
| 33 | PM2244-133 | Tension Roller | | 2 |
| 34 | F005429 | Socket Head Cap Screw | M10*1.5P*30L | 4 |
| 35 | F002115 | Lock Washer | M10 | 4 |
| 36 | F002643 | Flat Washer | 10*20*3.0T | 4 |
| 37 | F010407 | Socket Set Screw | M8*1.25P*8L | 4 |
| 38 | | Coupling (Re:18A) | | 2 |
| 39 | | Rubber Cushion (Re:18A) | | 1 |
| 40 | PM2244-140 | Handle | | 1 |
| 41 | PM2244-141 | Direction indication Label | | 1 |
| 42 | PM2244-142 | Handwheel | | 1 |
| 43 | F009897 | Socket Head Button Screw | M6*1.0P*20L | 2 |
| 44 | PM2244-144 | Bearing Housing | | 1 |
| 45 | PM2244-145 | Locking Nut | | 1 |
| 46 | PM2244-146 | External Tooth Lock Washer | | 1 |
| 47 | BB-51102 | Thrust Bearing | 51102 | 1 |
| 48 | PM2244-148 | Oilite Bushing | | 1 |
| 49 | F006047 | Retaining Ring | STW-20 | 2 |
| 50 | PM2244-150 | Ring Magnet | | 1 |
| 51 | PM2244-151 | Wave Washer | WW-20 | 1 |
| 52 | PM2244-152 | Spring Pin | 4*16 | 1 |
| 53 | PM2244-153 | Height Adjusting Screw | | 1 |
| 54 | PM2244-154 | Special Flat Washer | 21*37*1T | 1 |
| 55 | PM2244-155 | Key | 6*6*20 | 1 |

¹ see sect. 10.0 for replacement abrasives.

| Index No | Part No | Description | Size | Qty |
|----------|--------------|---------------------------------|--------------------|-----|
| 56 | PM2244-156 | Scale | | 1 |
| 57 | F002631 | Flat Washer | 4.3*10*1.0T | 6 |
| 58 | PM2244-158 | Self Tapping Screw | M4*1.59P*25L | 4 |
| 59 | | Motor Shield | | 1 |
| 60 | PM2244-160 | Cable Clamp | ACC-1.5-B | 2 |
| 61 | F001177 | Phillips Pan Head Screw | M4*0.7P*10L | 7 |
| 62 | PM2244-162 | Elevation Hall Sensor Bracket | | 1 |
| 63 | PM2244-163 | Elevation Hall Sensor Assembly | | 1 |
| 64 | F001148 | Phillips Pan Head Screw | M3*0.5P*6L | 6 |
| 65 | F002107 | Lock Washer | M4 | 2 |
| 66 | F005352 | Socket Head Cap Screw | M4*0.7P*12L | 2 |
| 67 | F001088 | Phillips Pan Head Screw | M5*0.8P*10L | 6 |
| 68 | PM2244-168 | Cable Cover | | 1 |
| 69 | PM2244-169 | Motor Shield Cover | | 1 |
| 70 | F009886 | Socket Head Button Screw | M5*0.8P*12L | 5 |
| 71 | F003074 | Hex Nut | M8*1.25P | 3 |
| 72 | F008789 | Hex Cap Screw | M8*1.25P*25L | 1 |
| 73 | PM2244-173 | Cable Clamp | ACC-6-B | 2 |
| 74 | PM2244-174 | Cable Clamp | ACC-4-B | 4 |
| 75 | F008805 | Hex Cap Screw | M8*1.25P*55L | 1 |
| 76 | PM2244-176 | Gib | | 2 |
| 77 | PM2244-177 | Clamping Block | | 2 |
| 78 | F002640 | Flat Washer | 8.5*16*2.0T | 30 |
| 79 | F002114 | Lock Washer | M8 | 30 |
| 80 | F005407 | Socket Head Cap Screw | M8*1.25P*40L | 6 |
| 81 | PM2244-181 | Special Socket Set Screw | M6*1.0P*20L | 8 |
| 82 | F003071 | Hex Nut | M6*1.0P | 9 |
| 83 | F008794 | Hex Cap Screw | M8*1.25P*30L | 1 |
| 84 | PM2244-184 | PU Block | | 1 |
| 85 | PM2244-185 | Motor Plate | | 1 |
| 86 | F005404 | Socket Head Cap Screw | M8*1.25P*25L | 4 |
| 87 | PM2244-187 | Sanding Motor | 1.75HP, 115V, 60Hz | 1 |
| | PM2244-187SC | Start Capacitor (not shown) | 300MFD 125VAC | 1 |
| | PM2244-187RC | Running Capacitor (not shown) | 50µF 300VAC | 1 |
| | PM2244-187FC | Fan Cover (not shown) | | 1 |
| | PM2244-187CF | Cooling Fan (not shown) | | 1 |
| 88 | PM2244-188 | Strain Relief | PGA16-14B | 1 |
| 89 | PM2244-189 | Motor Cable | 12AWG*3C | 1 |
| 90 | JSG96-262 | Self Tapping Screw | M3*1.06P*10 | 8 |
| 91 | PM2244-191 | Display Assembly | | 1 |
| 92 | PM2244-192 | Control & Display Panel | | 1 |
| 93 | LM000075 | Display Panel Label | | 1 |
| 94 | PM2244-194 | Variable Resistor Set | | 1 |
| 95 | PM2244-195 | Emergency Stop | | 1 |
| 96 | PM2244-196 | Knob | | 1 |
| 97 | PM2244-197 | Power Switch | | 1 |
| 98 | LM000076 | Control Panel Label | | 1 |
| 99 | PM2244-199 | Magnetic Switch | | 1 |
| 100 | PM2244-1100 | Connection Cable (No.L2, Black) | 12AWG*1C*150mm | 1 |
| 101 | PM2244-1101 | Connection Cable (No.L1, Black) | 12AWG*1C*600mm | 1 |
| 102 | PM2244-1102 | Connection Cable (No.N1, White) | 12AWG*1C*600mm | 1 |
| 103 | PM2244-1103 | Connection Cable (No.L2, Black) | 12AWG*1C*600mm | 1 |
| 104 | PM2244-1104 | Connection Cable (No.N2, White) | 12AWG*1C*600mm | 1 |
| 105 | PM2244-1105 | Connection Cable (No.0) | 24AWG*3C*650mm | 1 |
| 106 | PM2244-1106 | Connection Cable (No.1) | 24AWG*3C*650mm | 1 |
| 107 | PM2244-1107 | Connection Cable (No.2) | 24AWG*3C*200mm | 1 |
| 108 | PM2244-1108 | Connection Cable (No.8) | 18AWG*3C*200mm | 1 |
| 109 | PM2244-1109 | Extension Table | | 2 |
| 110 | PM2244-1110 | Rear-Left Table Bracket | | 1 |
| 111 | F005403 | Socket Head Cap Screw | M8*1.25P*20L | 20 |
| 112 | PM2244-1112 | Rear-Right Table Bracket | | 1 |

| Index No | Part No | Description | Size | Qty |
|----------|-------------|----------------------------------|-------------|-----|
| 113 | F008750 | Hex Cap Screw | M6*1.0P*25L | 1 |
| 114 | BB-51101 | Thrust Bearing | 51101 | 1 |
| 115 | PM2244-1115 | Table Micro-Adjusting Knob | | 1 |
| 116 | PM2244-1116 | Bracket | | 1 |
| 117 | PM2244-1117 | Base | | 1 |
| 118 | PM2244-1118 | Front-Left Table Bracket | | 1 |
| 119 | PM2244-1119 | Front-Right Table Bracket | | 1 |
| 120 | PM2244-1120 | Gear Motor | 100Volt | 1 |
| 121 | F006046 | Retaining Ring | STW-18 | 1 |
| 122 | F011908 | Wave Washer | WW-18 | 1 |
| 123 | PM2244-1123 | Sprocket | 8T | 1 |
| 124 | PM2244-1124 | Cable Tie | ALT-085S-B | 2 |
| 125 | F006041 | Retaining Ring | STW-12 | 2 |
| 126 | PM2244-1126 | Special Flat Washer | 18*32*1.0T | 1 |
| 127 | PM2244-1127 | Ring Magnet | | 1 |
| 128 | PM2244-1128 | Gear Motor Plate | | 1 |
| 129 | PM2244-1129 | Cable Clamp | ACC-2-B | 1 |
| 130 | F010955 | Flat Head Socket Screw | M5*0.8P*10L | 4 |
| 131 | PM2244-1131 | Speed Hall Sensor | | 1 |
| 132 | PM2244-1132 | Speed Hall Sensor Bracket | | 1 |
| 133 | F005349 | Socket Head Cap Screw | M4*0.7P*6L | 2 |
| 134 | F005382 | Socket Head Cap Screw | M6*1.0P*16L | 6 |
| 135 | F001207 | Phillips Pan Head Screw | M5*0.8P*20L | 3 |
| 136 | PM2244-1136 | Cable Clamp | | 1 |
| 137 | PM2244-1137 | Cable Protection Bushing | | 2 |
| 138 | PM2244-1138 | Power Cable | SJT12AWG*3C | 1 |
| 139 | PM2244-1139 | Circuit Board Holder | | 1 |
| 140 | PM2244-1140 | Foam Pad | 95*30*22T | 1 |
| 141 | PM2244-1141 | Circuit Board | | 1 |
| 142 | PM2244-1142 | Standoff | | 4 |
| 144 | PM2244-1144 | Cable Tie Mount | | 1 |
| 145 | PM2244-1145 | External Tooth Lock Washer | | 2 |
| 146 | PM2244-1146 | Connection Cable (No.8) | | 1 |
| 147 | LM000073 | Sanding Motor Label (not shown) | | 1 |
| 148 | LM000074 | Conveyor Motor Label (not shown) | | 1 |

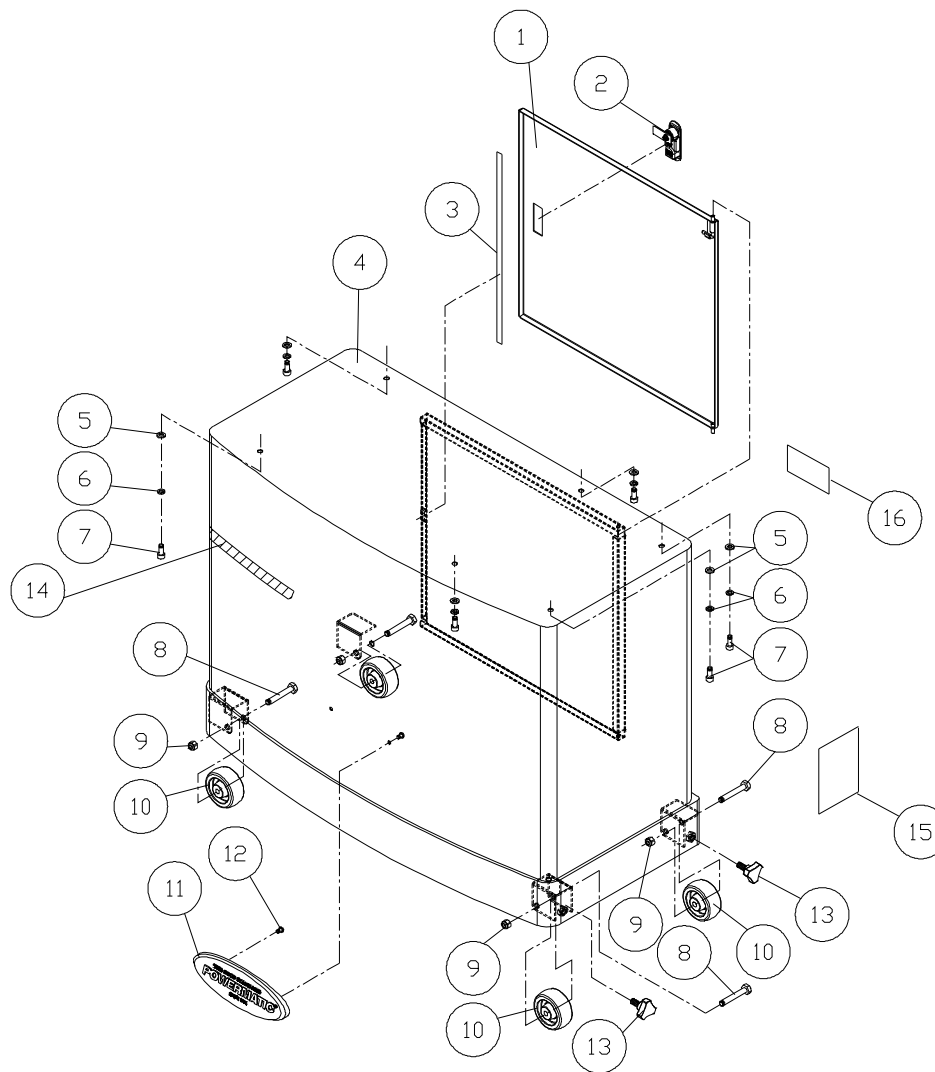
14.2.1 PM2244 Conveyor Bed Assembly – Exploded View



14.2.2 PM2244 Conveyor Bed Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|------------|-----------------------------|--------------|-----|
| 1 | PM2244-201 | Conveyor Belt | | 1 |
| 2 | PM2244-202 | Driven Roller Holder | | 2 |
| 3 | PM2244-203 | Oilite Bushing | | 4 |
| 4 | PM2244-204 | Driven Roller | | 1 |
| 5 | PM2244-205 | Compression Spring | | 2 |
| 6 | F002643 | Flat Washer | 10.3*22*2.0T | 2 |
| 7 | PM2244-207 | Rod | | 2 |
| 8 | PM2244-208 | Adjusting Shaft | | 2 |
| 9 | F009887 | Socket Head Button Screw | M5*0.8P*16L | 4 |
| 10 | PM2244-210 | Chain | #410*21P | 1 |
| 11 | F006040 | Retaining Ring | STW-10 | 2 |
| 12 | PM2244-212 | Bracket | | 2 |
| 13 | PM2244-213 | Tracker Kit (set of 2) | | 1 |
| 14 | F005367 | Socket Head Cap Screw | M5*0.8P*25L | 2 |
| 15 | F002633 | Flat Washer | 5.2*10*1.0T | 8 |
| 16 | PM2244-216 | Side Cover | | 1 |
| 17 | F005413 | Socket Head Cap Screw | M8*1.25P*70L | 1 |
| 18 | PM2244-218 | Compression Spring | | 1 |
| 19 | F005370 | Socket Head Cap Screw | M5*0.8P*40L | 1 |
| 20 | F002108 | Lock Washer | M5 | 3 |
| 21 | F002640 | Flat Washer | 8.5*16*2.0T | 3 |
| 22 | PM2244-222 | Sleeve | | 1 |
| 23 | PM2244-223 | Left Driving Roller Holder | | 1 |
| 24 | F005352 | Socket Head Cap Screw | M4*0.7P*12L | 2 |
| 25 | PM2244-225 | Conveyor Bed | | 1 |
| 26 | PM2244-226 | Guide Bar | | 1 |
| 27 | PM2244-227 | Driving Roller | | 1 |
| 28 | PM2244-228 | Spring Pin | 4*18 | 1 |
| 29 | F005405 | Socket Head Cap Screw | M8*1.25P*30L | 2 |
| 30 | F002114 | Lock Washer | M8 | 2 |
| 31 | PM2244-231 | Right Driving Roller Holder | | 1 |
| 32 | PM2244-232 | Shaft | | 1 |
| 33 | F005383 | Socket Head Cap Screw | M6*1.0P*20L | 2 |
| 34 | F002111 | Lock Washer | M6 | 2 |
| 35 | F002636 | Flat Washer | 6*13*1T | 2 |
| 36 | F005365 | Socket Head Cap Screw | M5*0.8P*16L | 1 |
| 37 | PM2244-237 | Sprocket Holder | | 1 |
| 38 | BB-6201VV | Ball Bearing | 6201VV | 1 |
| 39 | F006031 | Retaining Ring | RTW-32 | 1 |
| 40 | PM2244-240 | Sprocket | 10T | 1 |
| 41 | F006041 | Retaining Ring | STW-12 | 1 |

14.3.1 PM2244 Cabinet Assembly – Exploded View



14.3.2 PM2244 Cabinet Assembly – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|------------|---------------------------|-------------------|-----|
| 1 | PM2244-301 | Cabinet Door | | 1 |
| 2 | PM2244-302 | Door Latch | | 1 |
| 3 | PM2244-303 | Foam Strip | | 1 |
| 4 | PM2244-304 | Cabinet | | 1 |
| 5 | F002640 | Flat Washer | 8.5*16*2.0T | 6 |
| 6 | F002114 | Lock Washer | M8 | 6 |
| 7 | F005403 | Socket Head Cap Screw | M8*1.25P*20L | 6 |
| 8 | F006242 | Hex Cap Bolt | 3/8"-16NC*2-1/2"L | 4 |
| 9 | F001511 | Nylon Insert Lock Nut | 3/8"-16NC | 4 |
| 10 | PM2244-310 | Caster | | 4 |
| 11 | PM2000-105 | Powermatic Name Plate | | 1 |
| 12 | F000105 | Phillips Round Head Screw | 1/4"-20NC*3/8"L | 2 |
| 13 | PM2244-313 | Screw Knob | | 2 |
| 14 | PM2244-314 | Powermatic Stripe Set | | 1 |
| 15 | LM000071 | Warning Label | | 1 |
| 16 | LM000072 | ID Label, PM2244 | | 1 |



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