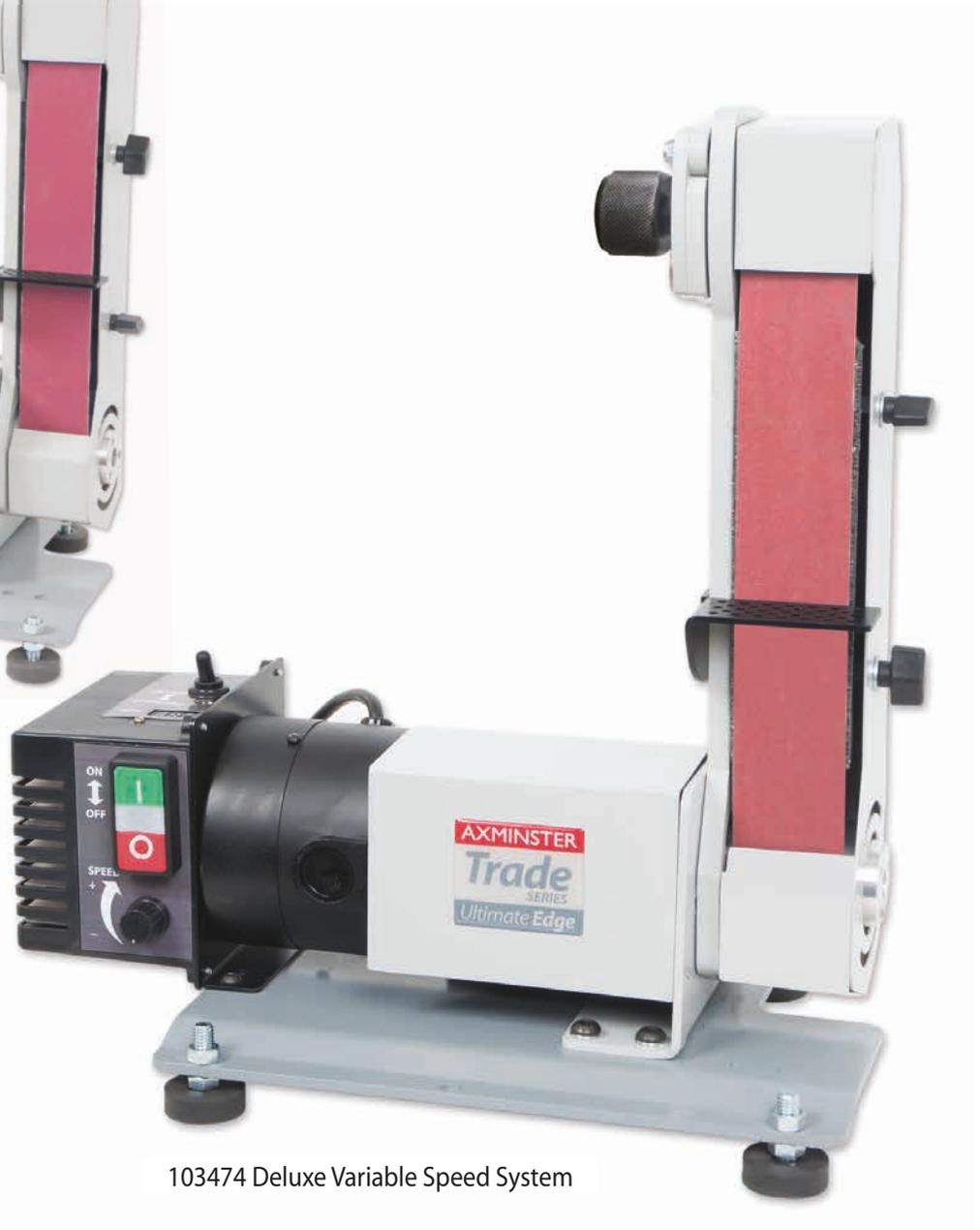


Ultimate Edge (P-50) Sharpening Systems



103473 Fixed Speed System



103474 Deluxe Variable Speed System



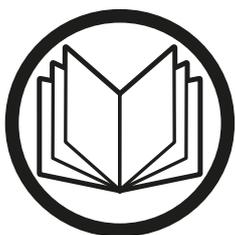
Index of Contents

| | |
|---------------------------------------|-------------|
| EU Declaration of Conformity | 02 |
| What's Included | 03 |
| General Instructions for 230 Machines | 04 |
| Specification | 04 |
| Assembly | 04-05-06-07 |
| Illustration & Parts Description | 08-09-10-11 |
| Setup/Adjustment | 12-13 |
| Operating Instructions | 14 |
| Changing the Belt | 15-16 |
| Changing Motor Brushes | 17 |
| Maintenance | 17 |
| Ultimate Edge Accessories | 18-19-20-21 |
| Exploded Diagrams/List | 20-21-22-23 |
| Wiring Diagrams | 24-25 |

EU Declaration of Conformity

| | | | | | |
|---|----------------------|--------------------|-------|----------------------|--|
| <p>Cert No: P-50</p> <p>Axminster Tools & Machinery Ltd Axminster Devon EX13 5PH UK axminster.co.uk</p> <p>declares that the machinery described:-</p> <table border="1"> <tr> <td>Type</td> <td>Belt Sander</td> </tr> <tr> <td>Model</td> <td>Ultimate Edge</td> </tr> </table> <p>Signed </p> <p>Andrew Parkhouse Operations Director</p> <p>Date: 08/05/2022</p> | Type | Belt Sander | Model | Ultimate Edge | <p>EU Declaration of Conformity</p> <p>This machine complies with the following directives:</p> <p>2006/42/EC 2014/35/EU EN ISO 12100:2010 EN ISO 60204-1:2006+AC:2010</p> <p>conforms to the machinery example for which the EC Type-Examination Certificate No M.2016.201.N1187, 14091705IDA 15001 has been issued by UDEM International Certification Auditing Training Centre Industry and Trade Co.Ltd at: Mullukent Mahallesi 2073 Sokak (Eski 93 Sokak) No: 10 Cankaya-Ankara-TURKEY and complies with the relevant essential health and safety requirements.</p> |
| Type | Belt Sander | | | | |
| Model | Ultimate Edge | | | | |

The symbols below advise the correct safety procedures when using this machine.



Fully read manual and safety instructions before use



Ear protection should be worn



Eye protection should be worn



Dust mask should be worn



HAZARD

What's Included

| Model Number | | | Ultimate Edge (P-50) | | | Model Number | | | Ultimate Edge (P-50) | | |
|--------------|---------------------------------------|----------|----------------------|---------------------------------------|----------|--------------|------|------|----------------------|---------------------------------------|----------|
| Quantity | Item | Part | Quantity | Item | Part | Quantity | Item | Part | Quantity | Item | Part |
| 1 | Ultimate Edge (Fixed Speed) | A | 1 | Ultimate Edge (Deluxe Variable Speed) | A | | | | | | |
| 1 | Abrasive Belt (Fitted) | | | | | | | | 1 | Abrasive Belt (Fitted) | B |
| 4 | Adjustable Rubber Feet | | | | | | | | 4 | Adjustable Rubber Feet | C |
| 1 | Work Table with two Caphead Screws | | | | | | | | 1 | Work Table with two Caphead Screws | D |
| 1 | Graphite Pad (Self Adhesive) | | | | | | | | 1 | Graphite Pad (Self Adhesive) | E |
| 1 | Long Hex Key 4mm | | | | | | | | 1 | Long Hex Key 4mm | F |
| 2 | Butterfly Threaded Knobs with Washers | | | | | | | | 2 | Butterfly Threaded Knobs with Washers | G |
| 1 | Sanding Belt Access Plate | | | | | | | | 1 | Sanding Belt Access Plate | H |
| 1 | Euro Plug Adaptor 13A | | | | | | | | 1 | Euro Plug Adaptor 13A | I |
| 1 | Instruction Manual | | | | | | | | | | |



General Instructions for 230 Machines

The following will enable you to observe good working practices, keep yourself and fellow workers safe and maintain your tools and equipment in good working order.



WARNING!! KEEP TOOLS AND EQUIPMENT OUT OF REACH OF YOUNG CHILDREN



KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.

Mains Powered Tools

- Tools are supplied with an attached 13 Amp plug.
- Inspect the cable and plug to ensure that neither are damaged. Repair if necessary by a suitably qualified person.
- Do not use when or where it is liable to get wet.

Workplace

- Do not use 230V a.c. powered tools anywhere within a site area that is flooded.
- Keep machine clean.
- Leave machine unplugged until work is about to commence.
- Always disconnect by pulling on the plug body and not the cable.

- Carry out a final checks to the machine.
- Ensure you are comfortable before you start work, balanced, not reaching etc.
- Wear appropriate safety clothing, goggles, gloves, masks etc. Wear ear defenders at all times.
- If you have long hair wear a hair net or helmet to prevent it being caught up in the rotating parts of the machine.
- Consideration should be given to the removal of rings and wristwatches.
- Consideration should also be given to non-slip footwear etc.
- If another person is to use the machine, ensure they are suitably qualified to use it.
- Do not use the machine if you are tired or distracted
- Do not use this machine within the designated safety areas of flammable liquid stores or in areas where there may be volatile gases.
- Check cutters are correct type and size, are undamaged and are kept clean and sharp, this will maintain their operating performance and lessen the loading on the machine.
- **OBSERVE....** make sure you know what is happening around you and **USE YOUR COMMON SENSE.**

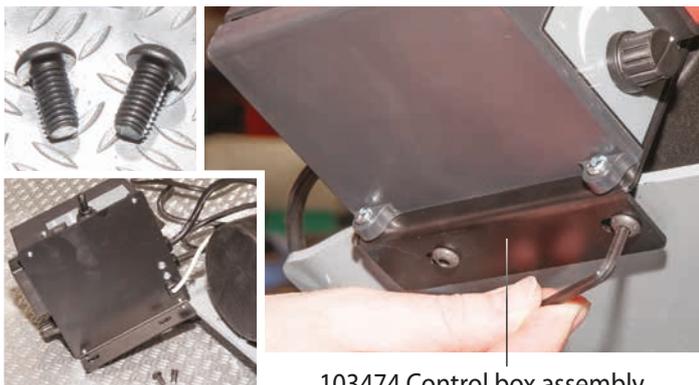
Specification

| | |
|------------------------|----------------------------------|
| Code No | 103473 |
| Model | Ultimate Edge Fixed Speed (P-50) |
| Rating | Trade |
| Power | AC 230V 50Hz 375W |
| Motor Speed | 2,800 rpm |
| Motor Pulley Diameter | 56mm |
| Belt Speed | 498 mpm |
| Belt Size | 50mm x 785mm |
| Dust Extraction Outlet | 25mm |
| Overall L x W x H | 330 x 280 x 480mm |
| Weight | 17.5kg |

| | |
|--------------------------------|--------------------------------------|
| Code No | 103474 |
| Model | Ultimate Edge Deluxe Variable (P-50) |
| Rating | Trade |
| Power | DC 230V 50Hz 560W |
| Motor Speed | 3,000 rpm |
| Motor Pulley Diameter | 56mm |
| Belt Speed (Metres Per Minute) | 200-600 mpm |
| Belt Size | 50mm x 785mm |
| Dust Extraction Outlet | 25mm |
| Overall L x W x H | 420 x 280 x 480mm |
| Weight | 17.5kg |

Assembly

Fig A



103474 Control box assembly

Fig B



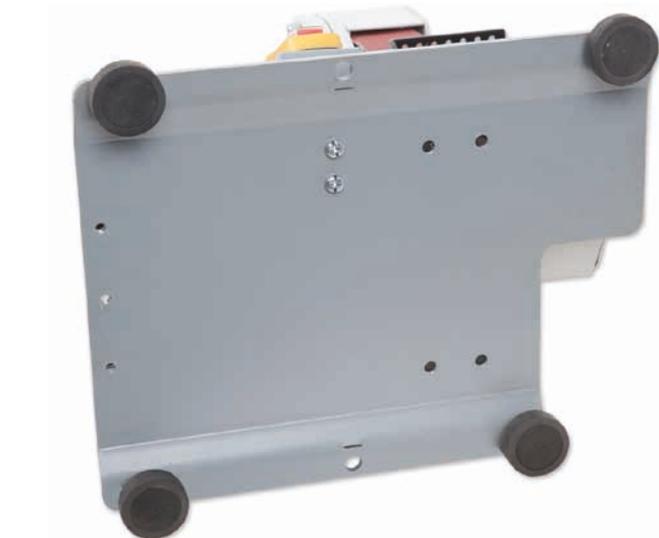
Euro plug adaptor 13A

Loosen the two screws on the Euro plug, open up and insert the pinned plug into the adapter as shown. Close the cover and tighten the screws.

Threaded Rubber Feet

Locate the four 'Rubber Feet' (C), remove one nut from each of the threaded feet and place aside. Slot each threaded foot through the four pre-drilled holes to each corner of the units base. Replace the nuts, stand the unit upright and adjust each foot in turn until the machine is level, see fig 01-02.

Fig 01-02



Work Table

Locate the work table and the two caphead screws (D). Line up the elongated slots on the work table bracket with the two threaded holes to the side of the linisher and secure the table in position with the caphead screws, see fig 03-04-05.

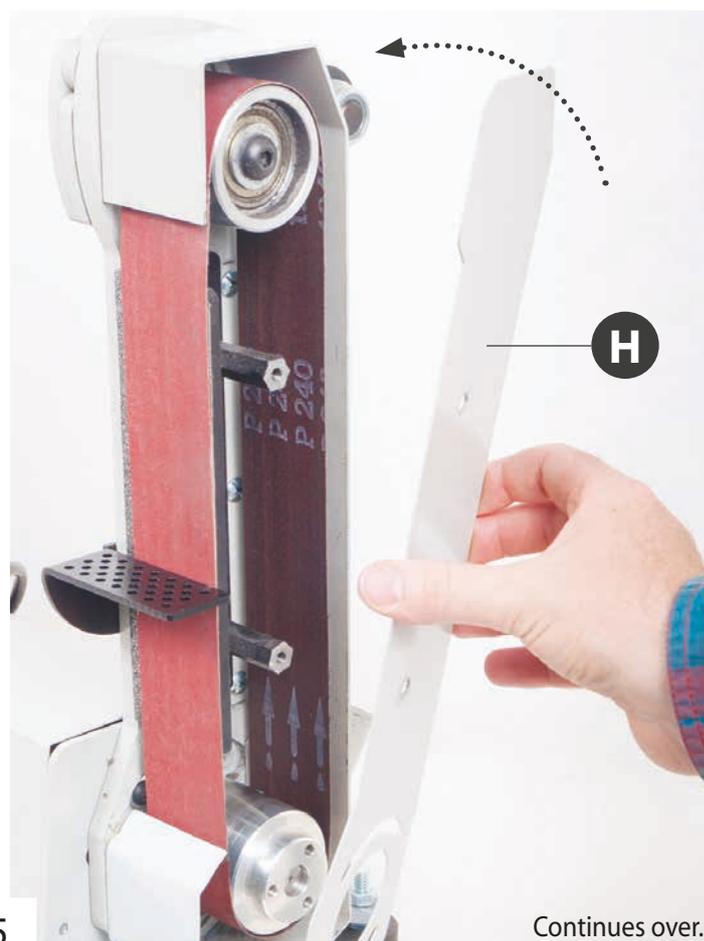
Fig 03-04-05



Access Plate

Find the the linishers side 'Access Plate' (H) and the two threaded butterfly knobs and washers (G). Position the plate against the linisher main assembly and line up the two holes with the wo threaded studs on the linisher. Secure the plate in position with the threaded knobs and washers, see fig 06-07-08.

Fig 06-07-08





Graphite Pad

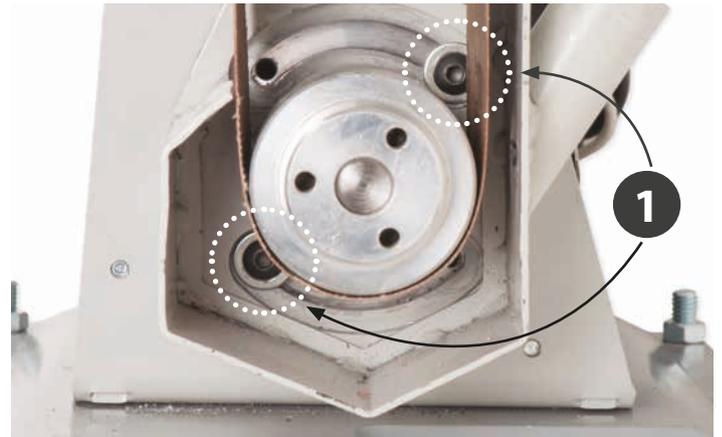


NOTE: IF YOU PREFER NOT TO USE THE 'GRAPHITE PAD' SKIP THIS STEP

The 'Graphite Pad' is used to reduce the friction and heat building between the abrasive belt and Linisher plate. This will help to prolong the life of the abrasive belt.

1. Remove the side access plate (H) and raise the linisher to the upright position by loosening the two Hex screws (1), see fig 09. Tighten the Hex screws to secure the linisher.

Fig 09



2. Rotate the lever (2) to the side of the linisher, see fig 10-11. Press down the lever to release the belt tension, see fig12.

Fig 10-11

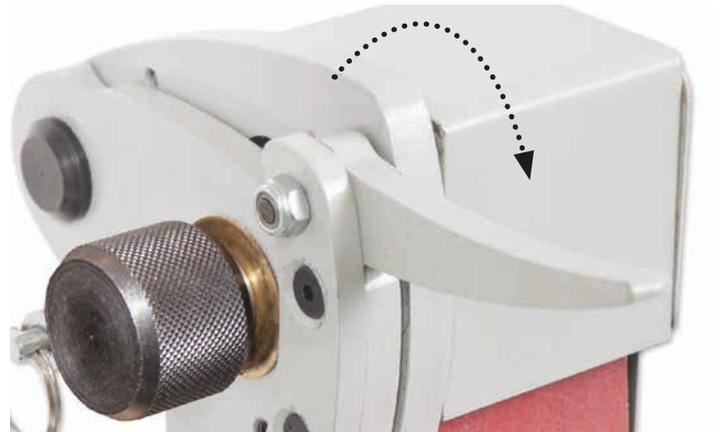
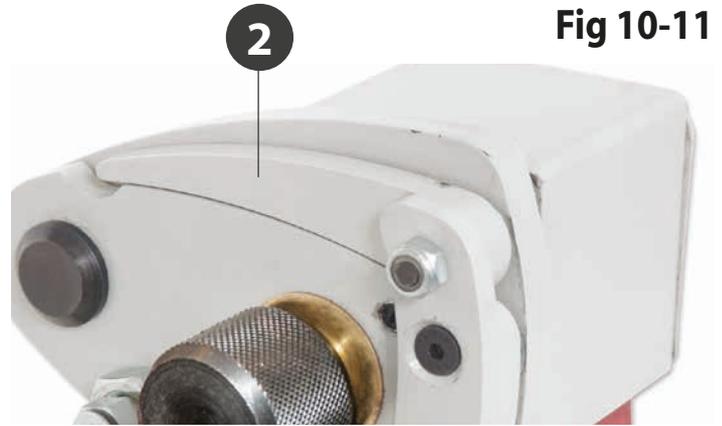


Fig 12



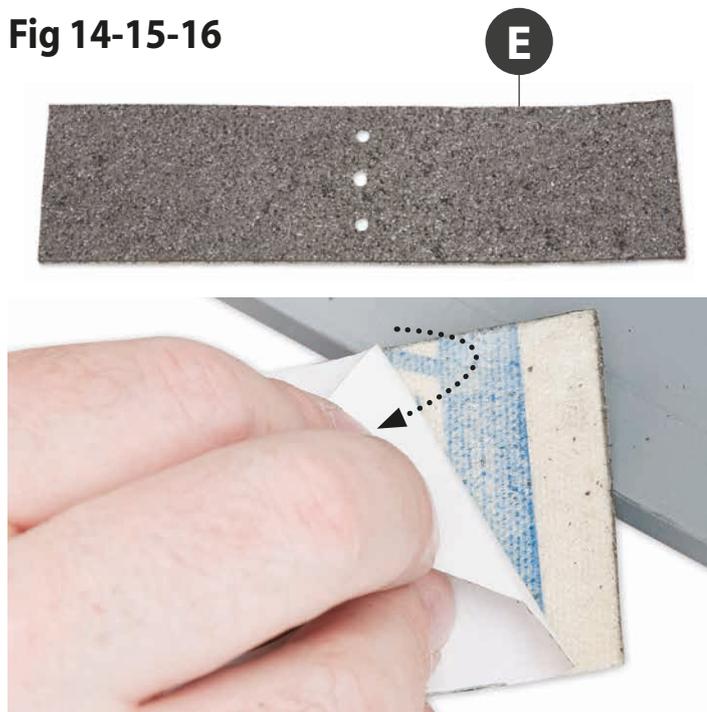
3. Remove the belt and place safely aside, see fig 13.

Fig 13



4. Locate the 'Graphite Pad', (E) and peel off the adhesive backing. Position the pad down onto the linisher's platen and press firmly down, see fig 14-15-16.

Fig 14-15-16

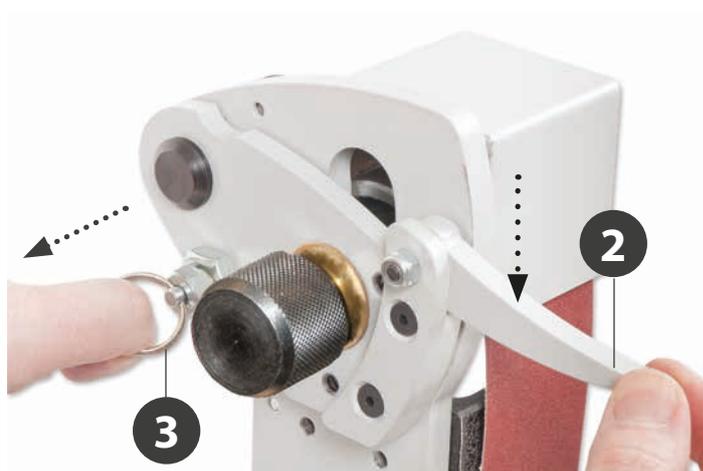


Note: After a period of time the 'Graphite Pad' will become worn and we recommend fitting the optional 'Slip Plate', code 105676, see picture below.



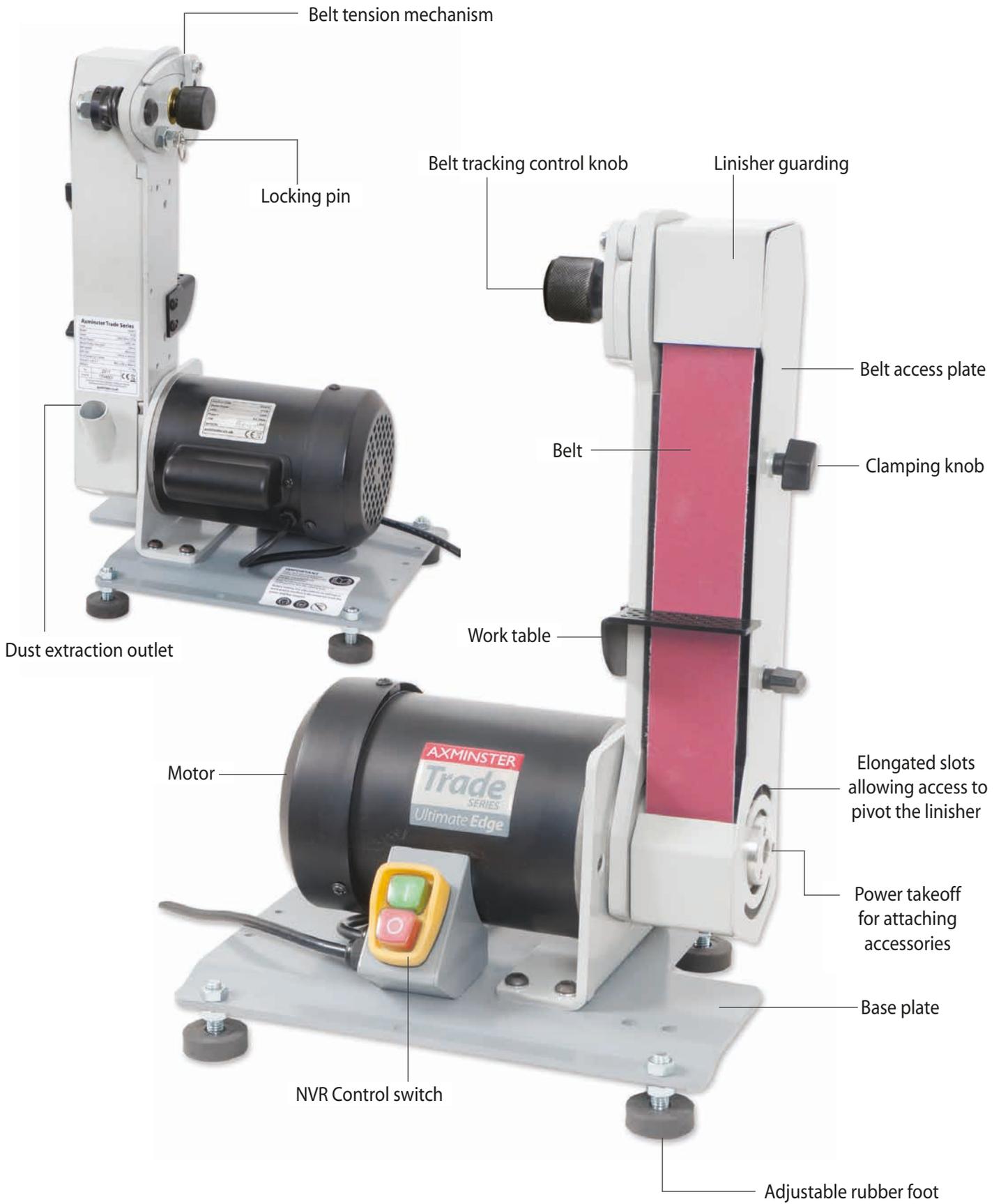
5. Slide the belt back on the drive rollers and centre the belt on the linisher. Press the lever (2) down and hold in place, pull the locking 'PIN' (3) out and raise the linisher's head to re-tension the belt, see fig 17.

Fig 17



6. Replace the side access plate (H)

Illustration & Parts Description



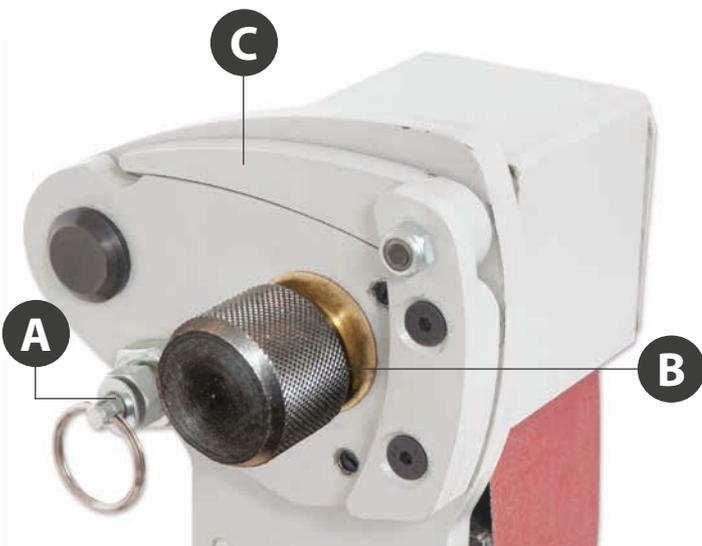
103473 P-50 (Fixed Speed)



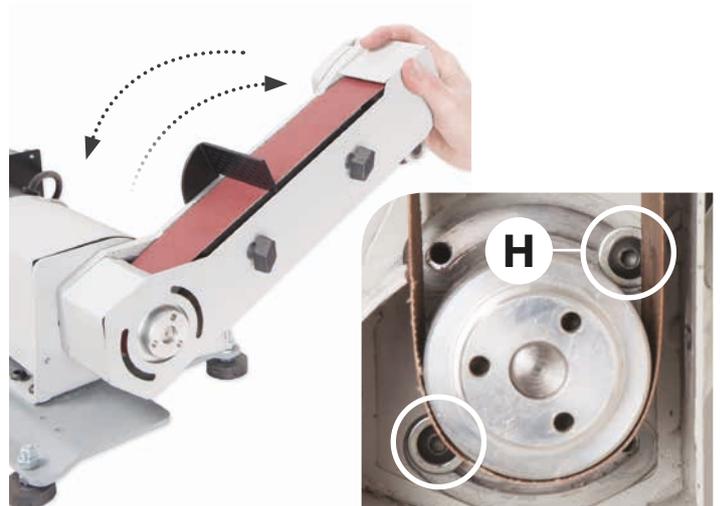
NVR ON/OFF switch (Green ON) & (Red OFF)



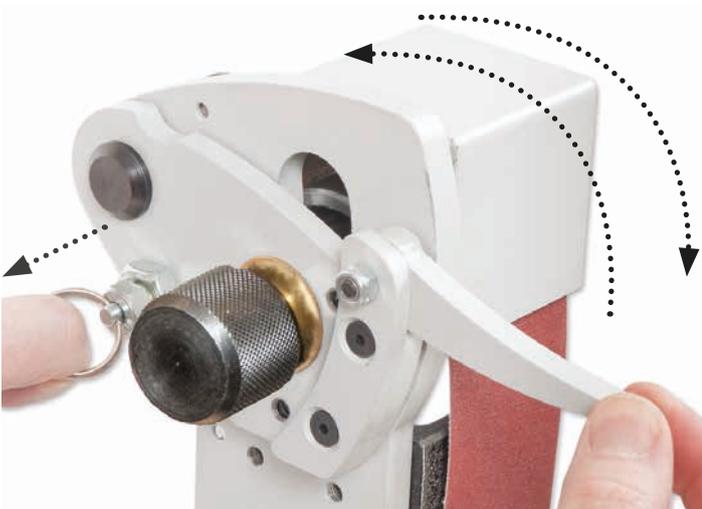
Work Table



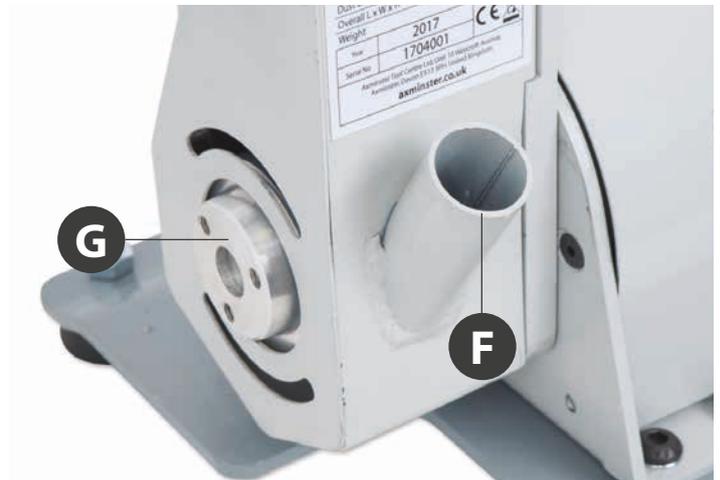
Locking pin for tension mechanism (A), Tracking control knob (B), Operating lever (C) to release the tension to the belt



The linisher can be pivoted to the required angle by adjusting the two Hex screws (H)

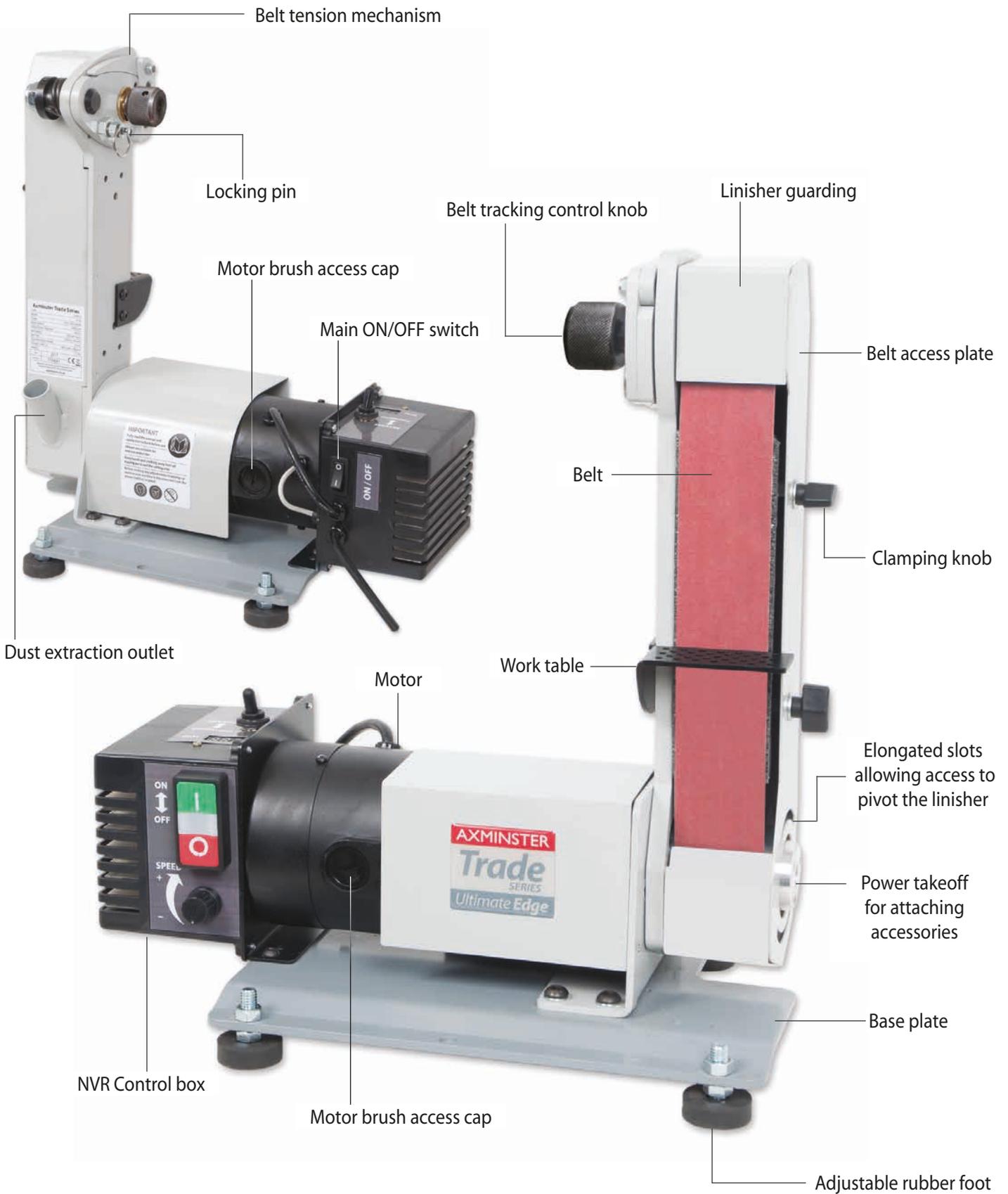


Belt tension mechanism



25mm Dust extraction outlet (F)
Power takeoff for attaching future accessories (G)

Illustration & Parts Description



103473 P-50 (Deluxe Variable Speed)



Main ON/OFF switch



Foward/Reverse selector switch

Speed digital readout

Heat sink air vents



Speed control dial

ON/OFF buttons

Setup/Adjustment

Tracking the Belt

(Variable Speed Model Only)



KEEP WORK AREA AS UNCLUTTERED AS IS PRACTICAL. UNDER NO CIRCUMSTANCES SHOULD CHILDREN BE ALLOWED IN WORK AREAS.



CONNECT THE MACHINE TO THE MAINS SUPPLY!

1. Press the main ON/OFF on switch to the 'ON' position, see fig 18.
2. Move the selector switch to the 'Forward' position, see fig 19.
3. Make sure the speed control dial is turned right down then press the 'GREEN' button to start the machine, see fig 20. The digital display will read 'For' (Forward) then '202' (MPM) will light up, see fig 21-22.

Fig 18-19-20-21-22



4. Turn the speed control knob until the display reads around '400' (MPM), see fig 23

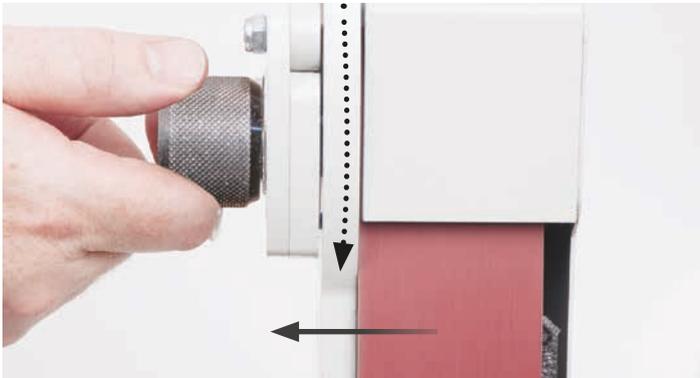
Fig 23



5. Turn the 'Tracking Control Knob' until the belt is centred on the platen, see fig 24-25-26.

NOTE: Don't make sudden adjustments otherwise you may over correct. Make small adjustments.

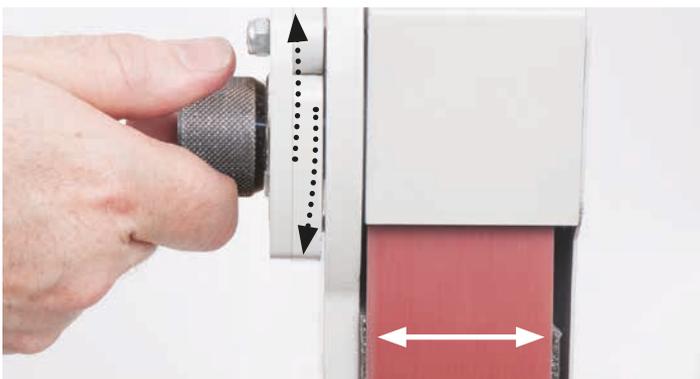
Fig 24-25-26



Turning the tracking knob clockwise moves the belt to the left



Turning the tracking knob anti-clockwise moves the belt to the right



Making small adjustments to centre the belt on the linisher

6. Once complete, turn down the speed until it reads '202' (MPM) on the display the press the 'RED' button to stop the machine.

7. Switch off the main ON/OFF switch to isolate the power the machine.

(Fixed Speed Model)

To power on the 'Ultimate Edge' fixed speed model press the 'Green' "ON" button, see fig 27 then proceed to step 5 as described on the opposite page.

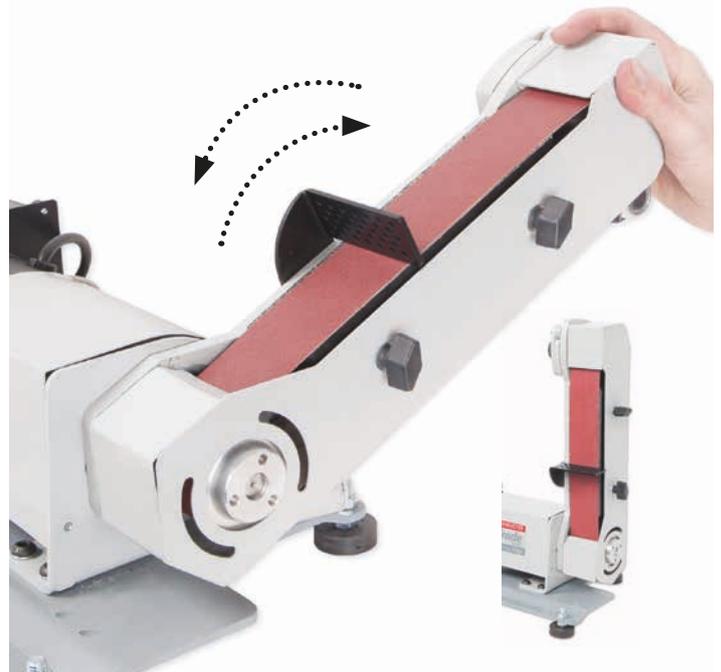
Fig 27



Setting the Linisher Angle

The linisher can be pivoted to the required angle by loosening the two button Hex screws, see fig 09 on page 06 then lower the linisher to the required angle, see fig 28-29. Re-tighten the Hex screws to secure the setting.

Fig 28-29



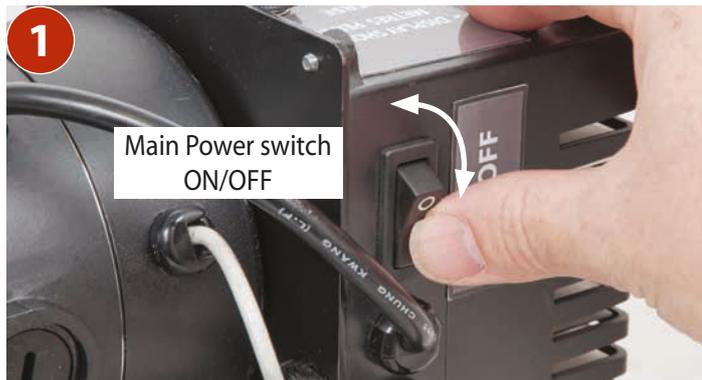
Operating Instructions

NVR Control Box (Variable Speed Model)

The control box comprises of a main ON/OFF switch to the rear that isolates the power to the machine, a Forward/Reverse switch to change the belts direction, 'Variable Speed Control Dial' to increase or decrease the belt speed and 'ON/OFF buttons' to start and stop the machine.



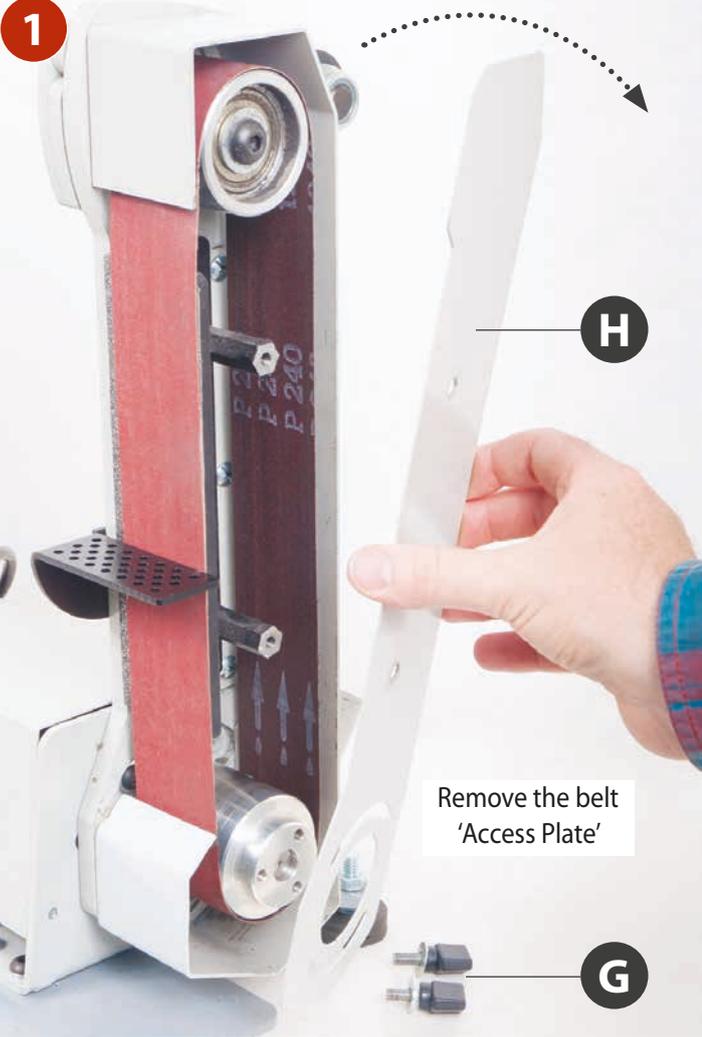
DO NOT CHANGE THE DIRECTION OF THE BELT WHILE THE MACHINE IS IN MOTION!





DISCONNECT THE MACHINE FROM THE MAINS SUPPLY!

1



Remove the belt 'Access Plate'

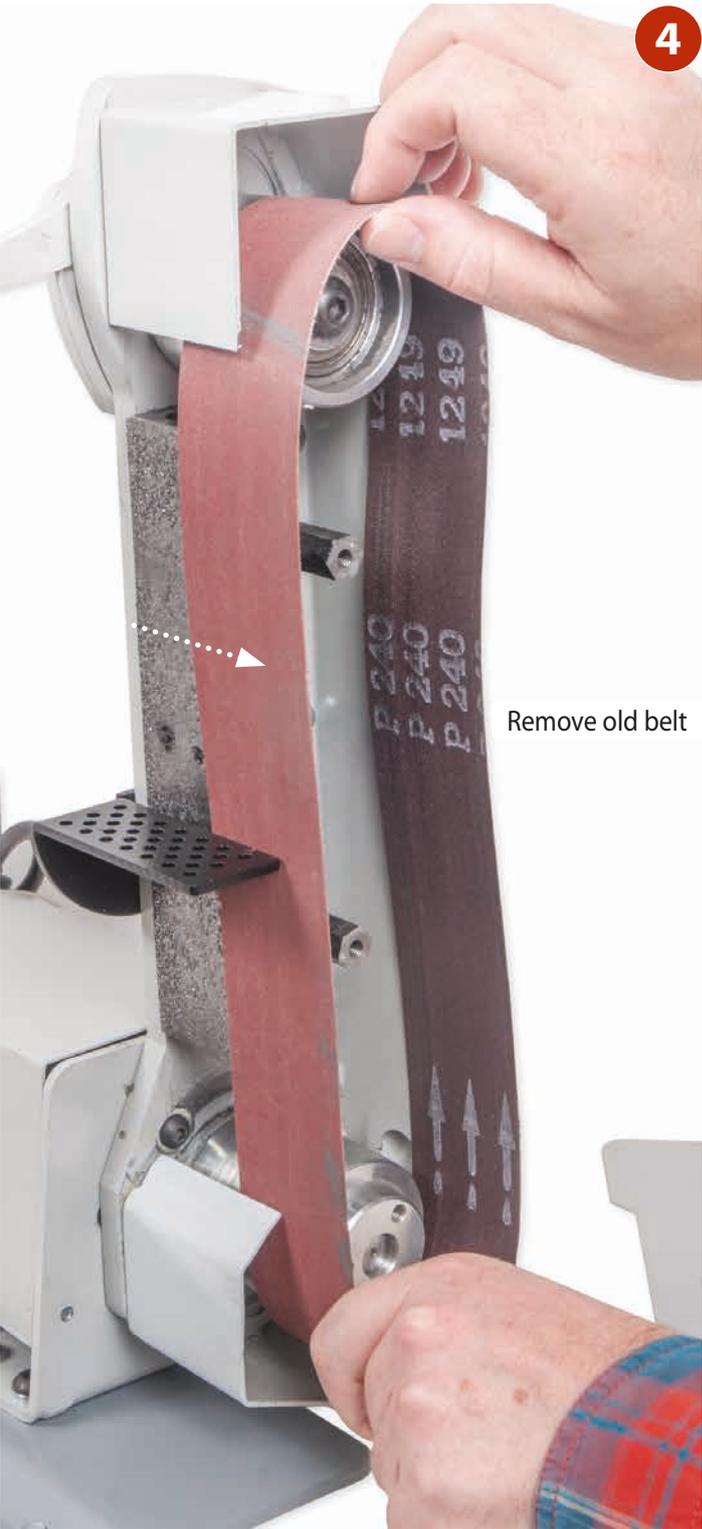
2



3



4



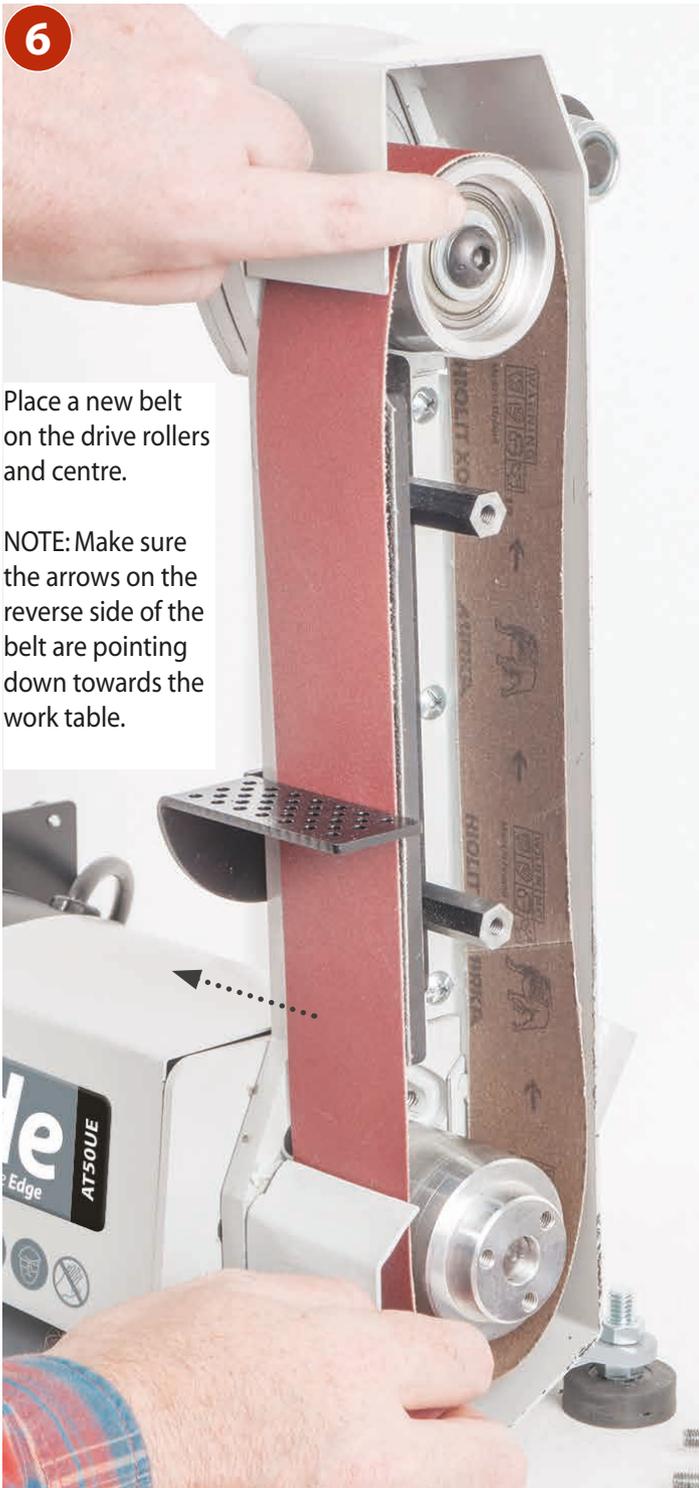
Remove old belt

5



Clean linisher

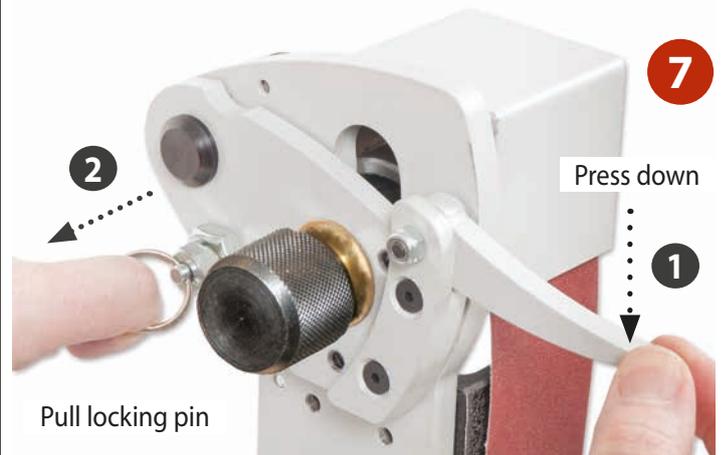
Changing the Belt



Place a new belt on the drive rollers and centre.

NOTE: Make sure the arrows on the reverse side of the belt are pointing down towards the work table.

Press down the lever and hold in place, pull the locking pin out and raise the roller assembly to re-tension the linisher belt.



Replace the belt 'Access Plate' (H) and secure in place with the two butterfly threaded knobs

Variable Speed Model Only

1. Check the condition of the motor brushes every 5-6 months. Unscrewing each brush cap screw in turn, see fig 30.

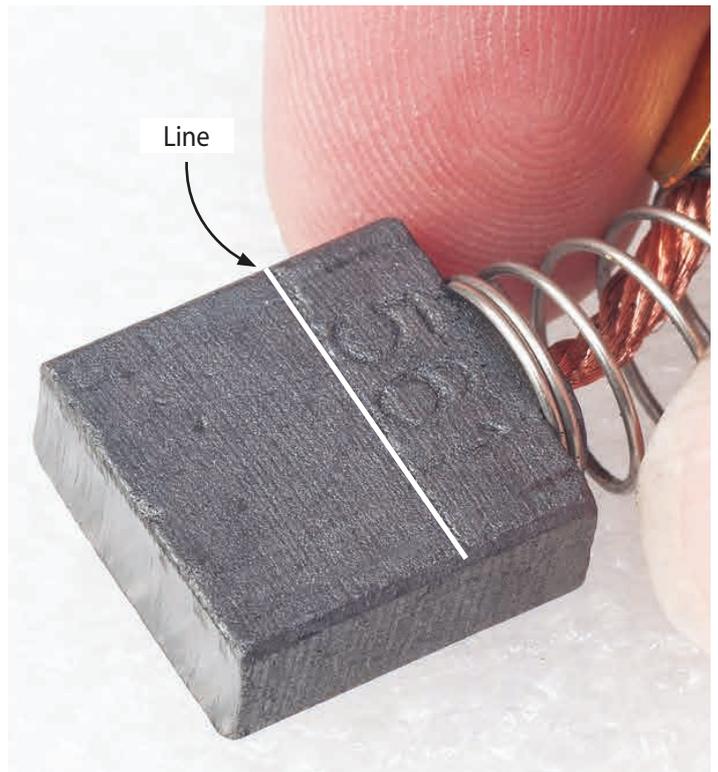
NOTE: Take careful note of the orientation, remember that they have bedded themselves to the profile of the commutator in that position. If you reverse them, it can cause excessive sparking and heat until they have re-bedded themselves.

2. Remove the motor brushes and check the condition of the brush head, see fig 31-32.
3. If they are in good condition, re-fit. If they were worn to the 'Line' replace with new brushes. For after sales enquires, call 03332 406406.
Email: cs@axminster.co.uk
Website: axminster.co.uk
4. Replace the new brushes and brush caps, re-connect to mains supply and run the machine off load for approx. 20 minutes to allow the brushes to bed in.

Fig 30



Fig 31-32



Maintenance

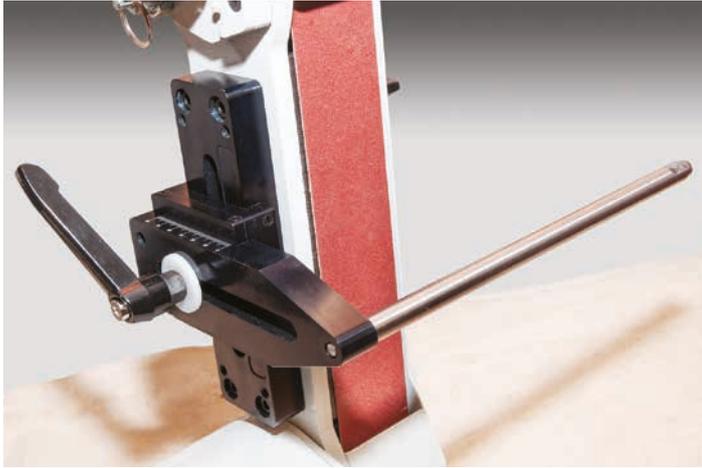
There is very little mechanical maintenance that can be carried out on the machine, keep the machine clean.

1. Remove the belt access plate and check there is no dust or resin build up on the pulleys or at the edges of the platen.
2. Remove all dust deposits and clean the motor using an Vacuum Cleaner.
3. Remove the dust extraction hose and check any build up of deposits inside the hose and extraction outlet.
4. Check the motor brushes every 5-6 months.



Ultimate Edge Accessories

Axminster Compound Jig (code 103738)



This is machined from specially anodised alloy and bolts easily onto 4 pre tapped threaded holes on the belt arm. This jig has the familiar round bar in ground silver steel to allow Tormek jigs to be mounted. One length of round bar are provided. A clever system of sliding the bar in two directions in one operation is employed, locked with just a twist of a handle. The jig has graduations laser marked into the body so that consistent repeat settings can be made. There are 4 adjusting grub screws to allow the jig to be set correctly to the belt platter both horizontally and vertically.

Axminster Honing Guide Assembly (code 105281)



The Ultimate Edge Honing Guide is perfect for plane blades, joinery chisels etc. This fits onto the round bar which is part of the Compound Jig. Clamping the blade tightly, both primary and secondary bevels can be achieved if required. The whole jig is manufactured from stainless steel and has a simple setting screw to control the width. The LH jaw is reversible and has twin jaws, one curved so that chisels that do not have perfectly parallel sides (such as Japanese and old hand forged chisels) can be clamped, the other jaw being parallel. The jaws are dovetailed, so securely clamp the tools against the body. The jaws accommodate blades from 3-66mm in width. A setting gauge is provided to enable the correct sharpening angle to be set based upon a standard projection of the cutting tool at 25mm from the guide.

Ultimate Edge Micro Bevel Gauge (code 105427)



Having ground the primary bevel on any tool the secondary bevel or micro bevel actually does the majority of the work. It is exactly what it says it is a micro bevel which can be increased with ease each time the tool becomes dull. The micro bevel guide is made of stainless steel and aluminium and has the ability to accept the tool still mounted in the honing guide, the precise angle of the micro bevel can be easily set and with a few positive passes over a fine diamond or waterstone a superb edge can be achieved.

Tormek® Jigs for Gouges (code 102132)



Many of the Tormek® jigs work amazingly well on the 12mm bar of the Ultimate Edge and provide the user with extremely sharp and accurately ground tools. The Tormek fingernail grinding jig is shown using an aluminium oxide belt with a 65mm protrusion. See the Tormek® pages for full details.

Polishing and Honing "Twist n Fix" Arbor (code 105419)



The unique "Twist n Fix" multipurpose arbor allows for the virtually instant change of different mops, felt wheels and profiling wheels. Supplied with mounting screws and one "Twist n Fix" arbor additional arbors can be purchased singularly or in a set of 3. This unique 12mm diameter quick change arbor system allows the power source to be run in either forward or reverse direction. Polishing mops, felt wheels etc should always be used in a specific order; the ability to change these almost instantly ensures that the process of starting coarse and ending up fine is always followed.

Polishing and Honing Accessories



A variety of 12mm bore accessories are available for use on the "Twist n Fix" 12mm arbor including a leather profiled wheel for carving tools, a rubberised wheel for polishing and traditional mops both stitched, loose leaf and sisal. N.B. Smaller sizes of abrasive soaps are available online.

Universal Sharpening Table (code 105426)



This table is an accessory for the Ultimate Edge Compound Jig. This is machined from anodised alloy and is supplied with a mitre setting guide. The table is locked by a handle locking securely onto the round bar. Anodised in black, there is a quadrant of angles laser marked into the surface for easy reference. Ideal for freehand lathe tool sharpening and general finishing. Size 130 x 75mm.

Universal Edge Gauge Setting (code 103730)



As with all accurate sharpening, it's all about the angles and our 18 piece set gives all angles from 90° through to 5°. The set is perfect for setting up sharpening guides as well as checking ground angles. The UJK level box is an additional useful accessory for the Ultimate Edge, its ability to record and set angles is perfect for this application.

Belts and Accessories for the Ultimate Edge Machine



There are many different types of abrasive ideally suited to the purpose of metal sharpening or grinding. We have listed below the most popular ones and will add online a number of other types of abrasive

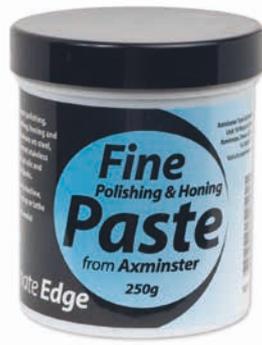
belt. As well as abrasive belts we have added a high quality ultra flexible leather honing belt which can be used with the various polishing pastes. For general use we recommend aluminium oxide at about 180g working finer to 400g for final finishing before any secondary bevel is applied using an ultra fine diamond or waterstone. 3M's Trizact abrasive is ideal for final grinding of all materials resulting in a fine edge ready to use straight off the machine. This is a different abrasive from normal convention but equates to 600G, 1200G and 3000G Note: if dust extraction is to be used a fireproof hose should ALWAYS be used (103717).

| Description | Grit | Code |
|---|--------|--------|
| Alu Oxide Cloth Belt 785 x 50mm | 120G | 105233 |
| Alu Oxide Cloth Belt 785 x 50mm | 180G | 105234 |
| Alu Oxide Cloth Belt 785 x 50mm | 240G | 105235 |
| Alu Oxide Cloth Belt 785 x 50mm | 320G | 105236 |
| Zirconium Cloth Belt 785 x 50mm | 60G | 105238 |
| Alu Oxide Cloth Belt 785 x 50mm | 400G | 105237 |
| Zirconium Cloth Belt 785 x 50mm | 120G | 105239 |
| Trizact Abrasive Belt 50 x 785mm A30 | 600G | 105428 |
| Trizact Abrasive Belt 50 x 785mm A16 | 1,200G | 105429 |
| Trizact Abrasive Belt 50 x 785mm A6 | 3,000G | 105430 |
| Hermes FB637 Blue Film 785 x 50mm Belt | 800G | 105553 |
| Hermes FB637 Blue Film 785 x 50mm Belt | 1500G | 105554 |
| Hermes FB637 Blue Film 785 x 50mm Belt | 2500G | 105555 |
| Slip Plate | | 105676 |
| Red Medium Grade Paste | | 103703 |
| Blue Fine Grade Paste | | 103715 |
| White Super Fine Paste | | 103716 |
| Flame Retardant Extraction Hose 25mm x 2m | | 103717 |

Ultimate Edge Accessories



Medium Polishing & Honing Paste 250g
Code 103703



Fine Polishing & Honing Paste 250g
Code 103715



Super Fine Polishing & Honing Paste 250g
Code 103716



Angle Gauge Set In Wallet 5-90 Deg
Code 103730



Flame Retardant Hose 25 mm x 2 m
Code 103717



Axminster Profiled Honing Wheel
Code 103717



Axminster Profiled Honing Wheel
Code 104737

- A three layer belt with a nylon core and two layers of chrome tanned leather
- **Always use the belt in a clockwise direction (belt traveling away from the blade tip)**
- **Never use the belt in a anti-clockwise direction (belt traveling towards the blade tip)**



Axminster Polishing & Honing Accessories

A variety of 12mm bore polishing wheel mops both stitched, loose leaf and sisal.

| No | Description | Code |
|----|--|--------|
| 1 | 4" Sisal Polishing Mop | 105421 |
| 2 | 4" Standard Stitched Polishing Mop | 105422 |
| 3 | 4" Loose Fold Polishing Mop | 105423 |
| 4 | Rubber Sharpening/Honing Wheel 100 x 13 x 12mm | 105202 |



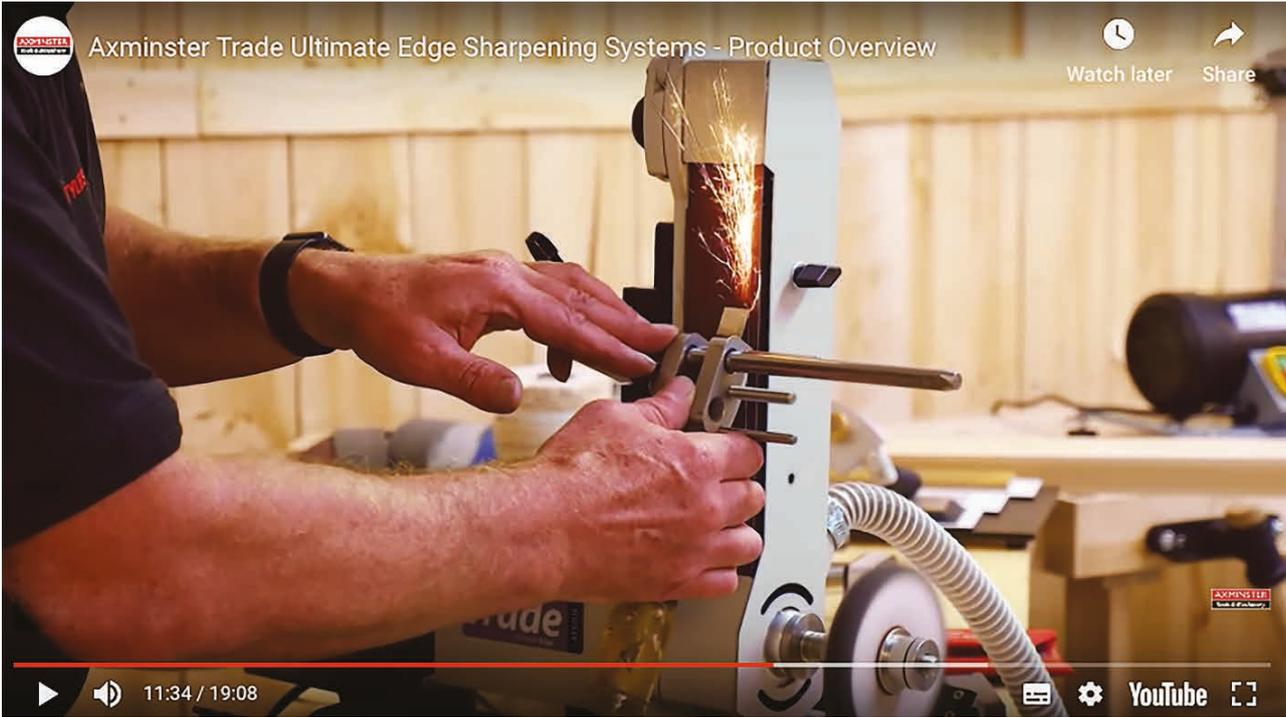
Numatic NQS350B-B1 Vacuum Extractor
Code 000000



| No | Description | Code |
|----|---|--------|
| 1 | Nylon Abrasive Wheel for Ultimate Edge - Soft | 105581 |
| 2 | Nylon Abrasive Wheel for Ultimate Edge - Medium | 105582 |
| 3 | Nylon Abrasive Wheel for Ultimate Edge - Hard | 105583 |
| | Felt Wheel for Ultimate Edge - Hard | 105580 |
| | Felt Wheel for Ultimate Edge - Medium | 105579 |
| | Felt Wheel for Ultimate Edge - Soft | 105578 |

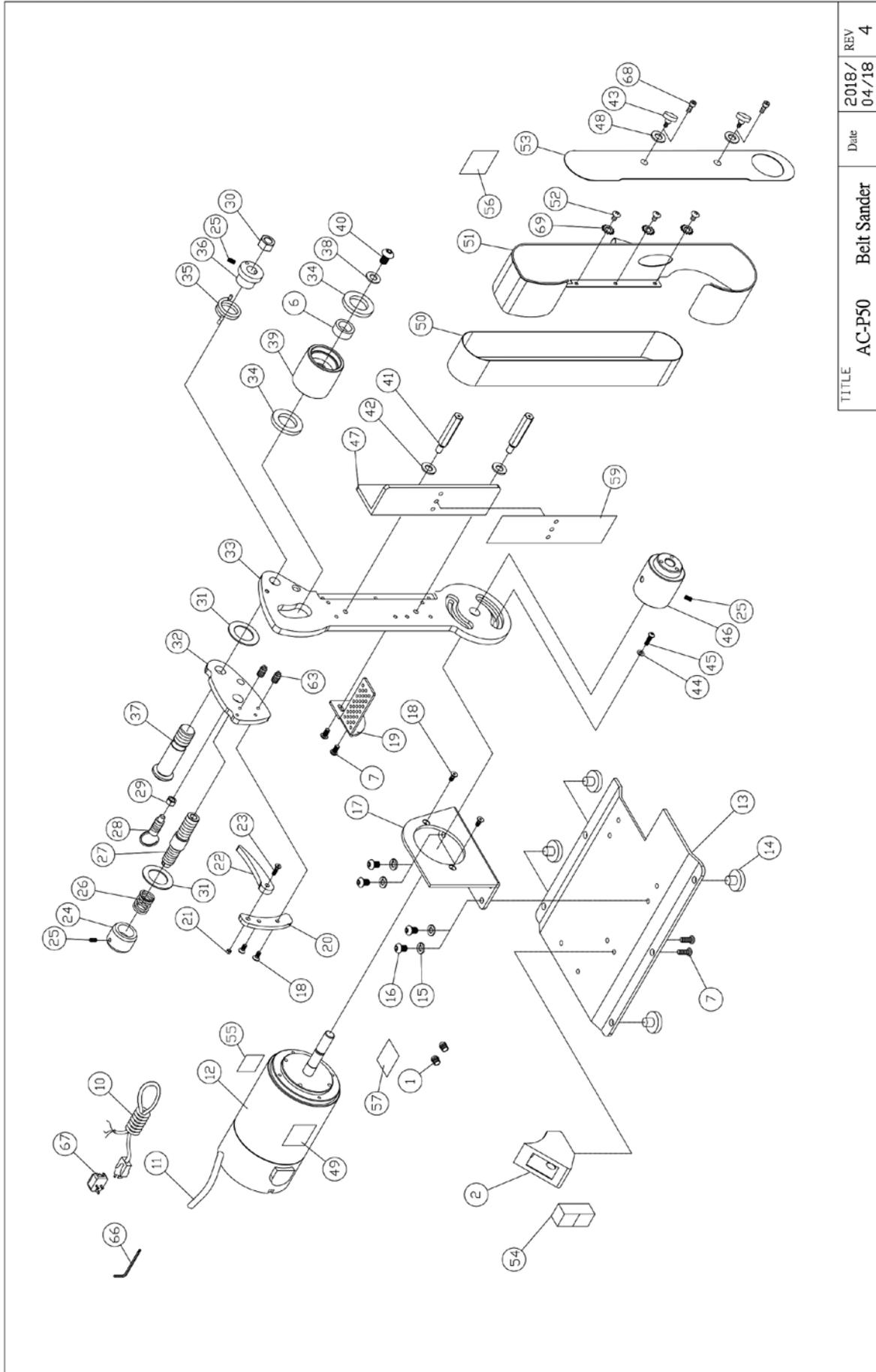
Online Product Video

Ultimate Edge Sharpening System



See the full range of accessories on our website including video guides on how to use

**103473
P-50 (Fixed Speed Model)**

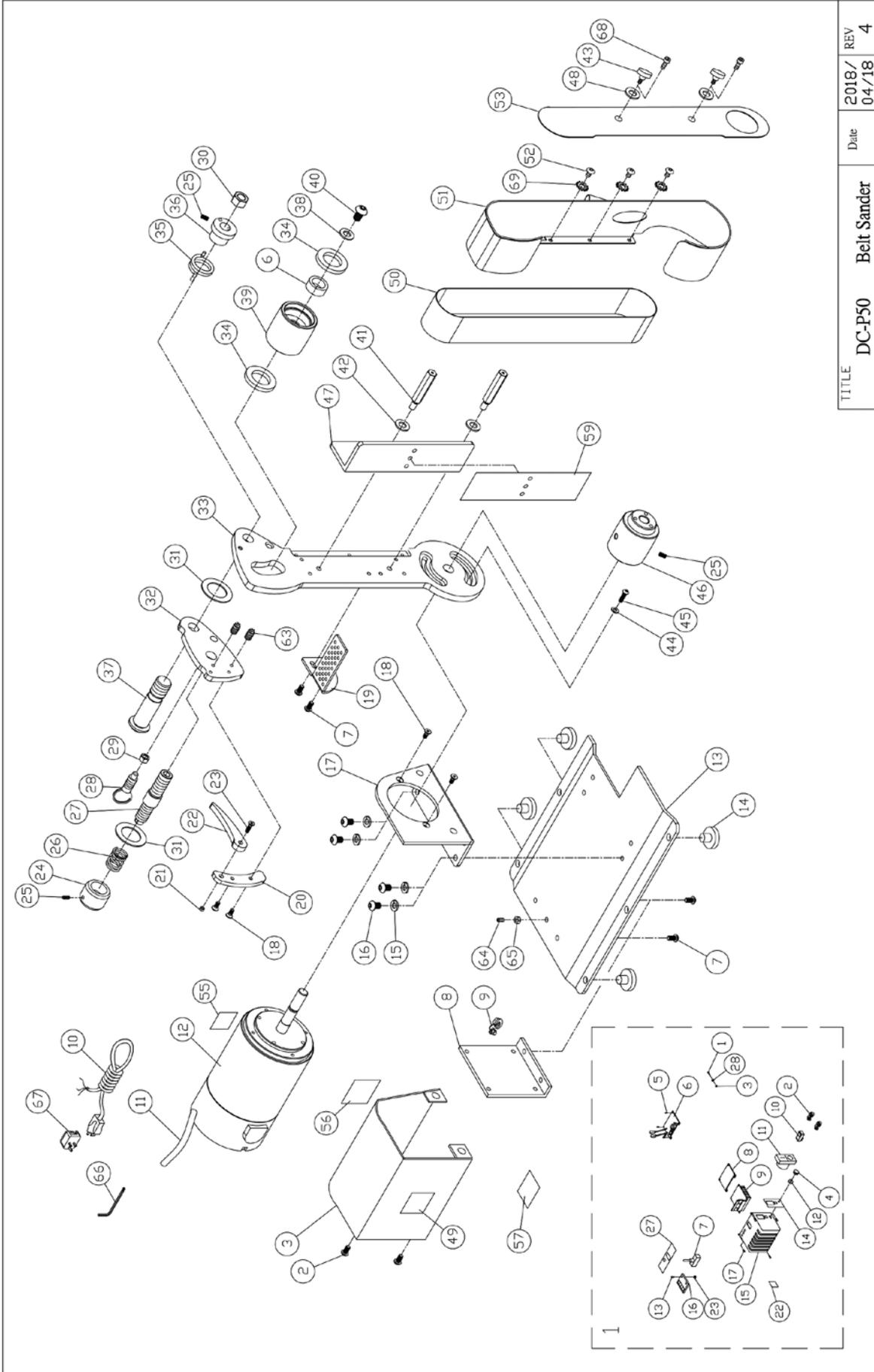


| | | | | | | |
|-------|--------|-------------|------|----------------|-----|---|
| TITLE | AC-P50 | Belt Sander | Date | 2018/ 04/18 | REV | 4 |
|-------|--------|-------------|------|----------------|-----|---|

Exploded Diagrams/List

| Part No | Description | Specification | Q'ty |
|---------|-----------------------------|---------------|------|
| 1 | Cable Gland | PG9 | 2 |
| 2 | Switch Box | | 1 |
| 6 | Bush | | 1 |
| 7 | Buttom Head Screw | M6x12 | 4 |
| 10 | Power Cord | | 1 |
| 11 | Motor Cord | | 1 |
| 12 | Motor | | 1 |
| 13 | Base Plate | | 1 |
| 14 | Rubber Foot | | 4 |
| 15 | Spring Washer | | 4 |
| 16 | Buttom Head Screw | M8x12 | 4 |
| 17 | Motor Plate | | 1 |
| 18 | Flat Head Screw | M5x12 | 4 |
| 19 | Work Table | | 1 |
| 20 | Fix Plate | | 1 |
| 21 | Nylon Nut | M6 | 1 |
| 22 | Handle | | 1 |
| 23 | Flat Head Screw | M6x18 | 1 |
| 24 | Knob | | 1 |
| 25 | Set Screw | M5x12 | 4 |
| 26 | Spring | | 1 |
| 27 | Shaft | | 1 |
| 28 | Lock Pin Pet | | 1 |
| 29 | Nut | 1/2"-13UNCx8t | 1 |
| 30 | Nylon Nut | M16x2.OP | 1 |
| 31 | Brass Washer | 16xl.2t | 2 |
| 32 | Live Plate | | 1 |
| 33 | Main Body | | 1 |
| 34 | Bearing | 6203ZZ | 2 |
| 35 | Twist Spring | | 1 |
| 36 | Bush | | 1 |
| 37 | Shaft | | 1 |
| 38 | Washer | M10 | 1 |
| 39 | Live Wheel | | 1 |
| 40 | Buttom Head Screw | M10x15 | 1 |
| 41 | Stop Rod | | 2 |
| 42 | Washer | M8 | 2 |
| 43 | Lock Nut | M6x15 | 2 |
| 44 | Washer | 1/4" | 2 |
| 45 | Buttom Head Screw | 1/4"x1" | 2 |
| 46 | Motor Wheel | | 1 |
| 47 | Lnisher Platen | | 1 |
| 48 | Washer | M6 | 2 |
| 49 | Label | | 1 |
| 50 | Belt | | 1 |
| 51 | Body Cover | | 1 |
| 52 | Big Round Head Screw | M5x6 | 3 |
| 53 | Side Access Plate | | 1 |
| 54 | Switch | | 1 |
| 55 | Motor Label | | 1 |
| 56 | I.D Label | | 1 |
| 57 | Warning Label | | 1 |
| 59 | Graphite Pad | | 1 |
| 63 | POM Set Screw | | 2 |
| 66 | Long Reach Ball End Hex Key | 4mm | 1 |
| 67 | Plug Adapter | | 1 |
| 68 | Cap Screw | | 2 |
| 69 | External Tooth Washer | | 3 |

**103474
P-50 (Deluxe Variable Speed Model)**



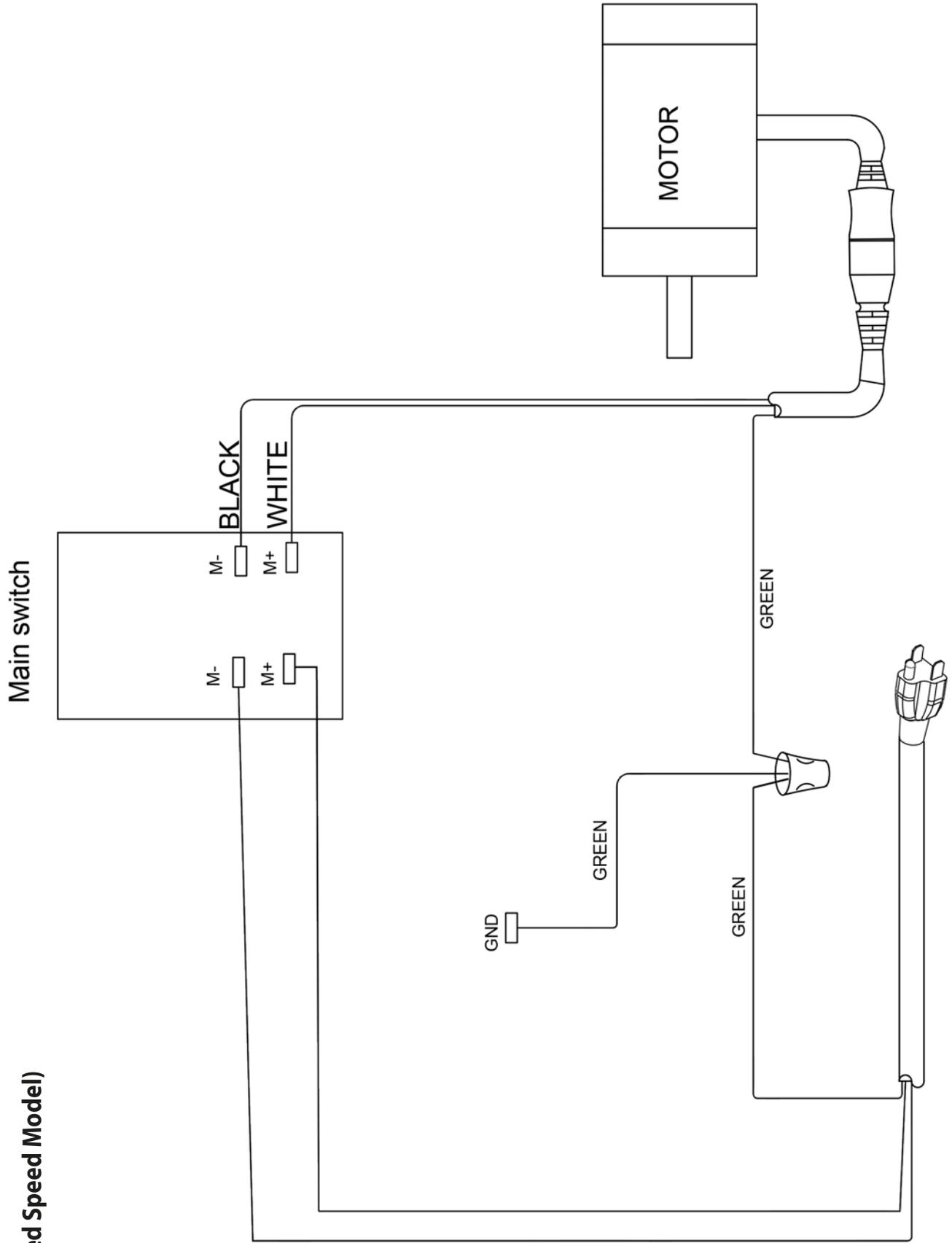
| | |
|-------|--------------------|
| TITLE | DC-P50 Belt Sander |
| Date | 2018/04/18 |
| REV | 4 |

Exploded Diagrams/List

| Part No | Description | Specification | Q'ty | | | | |
|---------|------------------------------|---------------|------|----|-----------------------------|----------------|---|
| 1 | Control Box | | 1 | 23 | Flat Head Screw | M6x18 | 1 |
| 1-1 | Round Head Screw | #10-24*5/16" | 2 | 24 | Knob | | 1 |
| 1-2 | Strain Relief Bushing | 6P-4 | 2 | 25 | Set Screw | M5x12 | 4 |
| 1-3 | Nut | #10-24 | 3 | 26 | Spring | | 1 |
| 1-4 | VR Knob | | 1 | 27 | Shaft | | 1 |
| 1-5 | Round Head Sheet Metal Screw | M3X20MM | 4 | 28 | Lock Pin Set | | 1 |
| 1-6 | PC Board | | 1 | 29 | Nut | 1/2"-13UN-Cx8t | 1 |
| 1-7 | For/Rev Switch | | 1 | 30 | Nylon Nut | M16x2.OP | 1 |
| 1-8 | Partition Plate | | 1 | 31 | Brass Washer | 16x1.2t | 2 |
| 1-9 | Heat Sink | | 1 | 32 | Live Plate | | 1 |
| 1-10 | Power Switch | | 1 | 33 | Main Body | | 1 |
| 1-11 | Switch | | 1 | 34 | Bearing | 6203ZZ | 2 |
| 1-12 | VR Control | | 1 | 35 | Twist Spring | | 1 |
| 1-13 | Round Head Sheet Metal Screw | M3X15MM | 2 | 36 | Bush | | 1 |
| 1-14 | Label | | 1 | 37 | Shaft | | 1 |
| 1-15 | Control Box | | 1 | 38 | Washer | M10 | 1 |
| 1-16 | Speed Display | | 1 | 39 | Live Wheel | | 1 |
| 1-17 | Round Head Screw | #8-32*3/8 | 4 | 40 | Button head screw | M10x15 | 1 |
| 1-22 | Label | | 1 | 41 | Stop Rod | | 2 |
| 1-23 | Nut | M3 | 2 | 42 | Washer | M8 | 2 |
| 1-27 | Label | | 1 | 43 | Lock Nut | M6x15 | 2 |
| 1-28 | Tooth Washer | #10-24 | 2 | 44 | Washer | 1/4" | 2 |
| 2 | Button Screw | M5x6 | 2 | 45 | ButtoN Head Screw | 1/4"x1" | 2 |
| 3 | Cover | | 1 | 46 | Motor Wheel | | 1 |
| 6 | Bush | | 1 | 47 | LInisher Platen | | 1 |
| 7 | Button Head Screw | M6x12 | 4 | 48 | Washer | M6 | 2 |
| 8 | Control Box Plate | | 1 | 49 | Label | | 1 |
| 9 | Strain Relief Bushing | SR-F51 | 1 | 50 | Belt | | 1 |
| 10 | Power Cord | | 1 | 51 | Body Cover | | 1 |
| 11 | Motor Cord | | 1 | 52 | Big Round Head Screw | M5x6 | 3 |
| 12 | Motor | | 1 | 53 | Side Cover | | 1 |
| 13 | Base Plate | | 1 | 55 | Motor Label | | 1 |
| 14 | Rubber Foot | | 4 | 56 | I.D Label | | 1 |
| 15 | Spring Washer | | 4 | 57 | Warning Label | | 1 |
| 16 | Button Head Screw | M8x12 | 4 | 59 | Graphite Pad | | 1 |
| 17 | Motor Plate | | 1 | 63 | POM Set Screw | | 2 |
| 18 | Flat Head Screw | M5x12 | 4 | 64 | Set Screw | M6x15 | 1 |
| 19 | Work Table | | 1 | 65 | Nut | M6 | 1 |
| 20 | Fix Plate | | 1 | 66 | Long Reach Ball End Hex Key | 4mm | 1 |
| 21 | Nylon Nut | M6 | 1 | 67 | Plug Adapter | | 1 |
| 22 | Handle | | 1 | 68 | Cap Screw | | 2 |
| | | | | 69 | External Tooth Washer | | 3 |

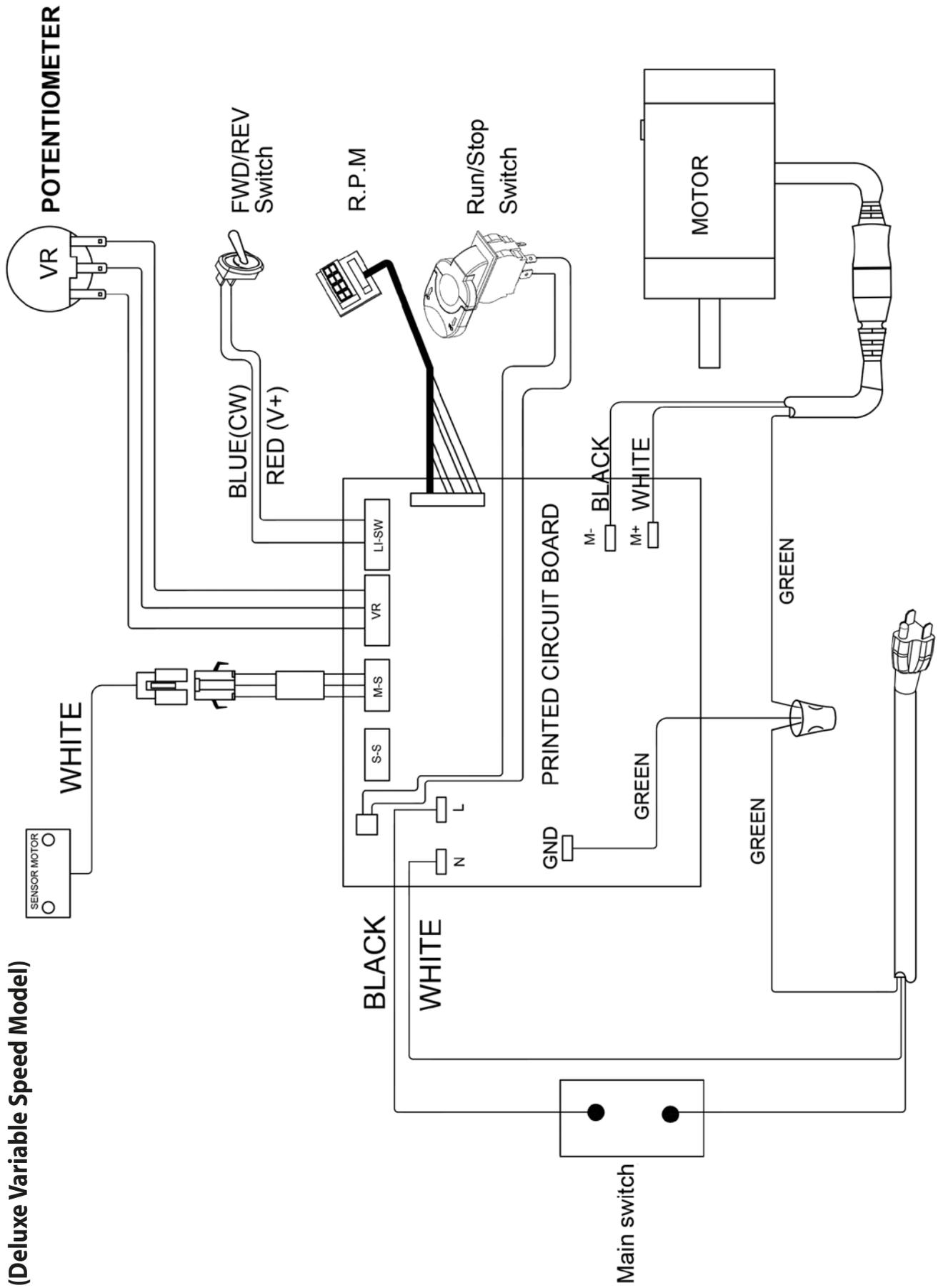
Wiring Diagram

103473
P-50 (Fixed Speed Model)



103474

P-50 (Deluxe Variable Speed Model)



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