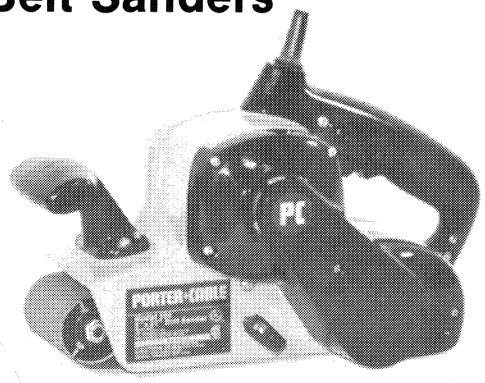
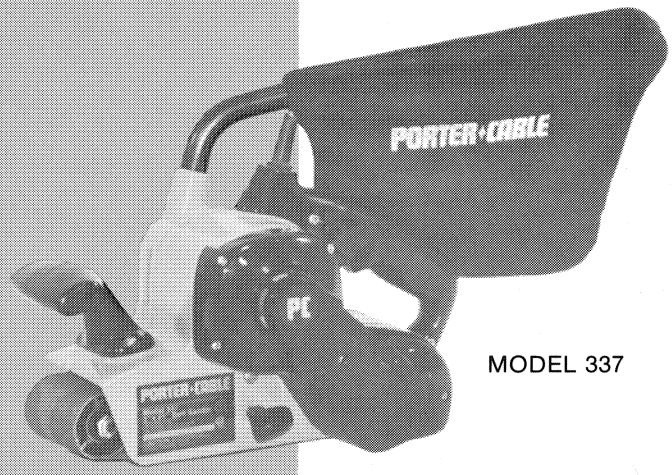
Instruction manual

Belt Sanders



MODEL 336



MODEL 337

IMPORTANT

Please make certain that the person who is to use this equipment carefully reads and understands these instructions before starting operations.

The Model and Serial No. plate is located on the main housing of the tool. Record these numbers in the spaces below and retain for future reference.

Model No. _____

Type _____

Serial No. _____

PORTER-CABLE
PROFESSIONAL POWER TOOLS

Part No. 692522-486

SAFETY INSTRUCTIONS

GROUNDING INSTRUCTIONS

This tool should be grounded while in use to protect the operator from electric shock. The tool is equipped with an approved three-conductor cord and three-prong grounding type plug to fit the proper grounding type receptacle. The green (or green and yellow) conductor in the cord is the grounding wire. Never connect the green (or green and yellow) wire to a live terminal.

If your unit is for use on less than 150 Volts, the power cord is equipped with a plug that has two flat, parallel current-carrying prongs and one longer, round or "U"-shaped, ground prong which requires a mating 3-conductor grounded type receptacle, as shown in Fig. 1.

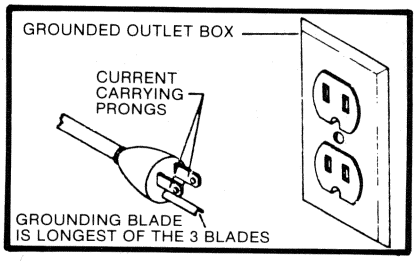


Fig. 1

An adapter, shown in Fig. 2, is available for connecting 3-prong grounding type plugs that are used on units less than 150 Volts to 2-prong receptacles. THIS ADAPTER IS NOT ALLOWED IN CANADA. The green colored rigid ear, lug, etc., must be connected to a permanent ground such as a properly grounded outlet box, as shown in Fig. 2.

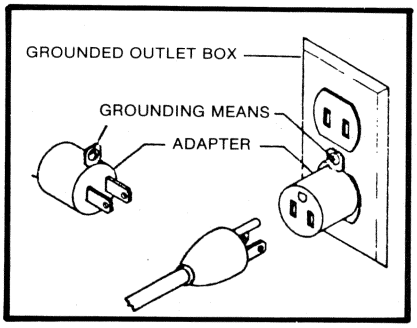


Fig. 2

If your unit is for use on 150 to 250 Volts, the power cord is equipped with a plug that has two flat current-carrying prongs in tandem, and one round or "U" - shaped, longer ground prong, as shown in Fig. 3. This plug is used only with the proper mating 3-conductor grounding type receptacle, as shown in Fig. 3. No adapter is available for this type plug.

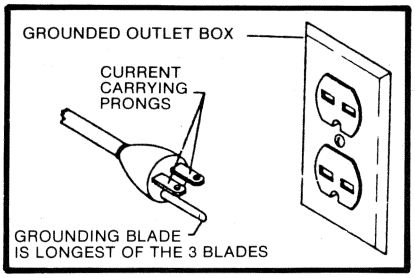


Fig. 3

IN ALL CASES, MAKE SURE THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED.

NEVER REMOVE GROUNDING BLADE FROM POWER PLUG

EXTENSION CORDS

Use only three-wire extension cords which have three prong grounding-type plugs and three-pole receptacle which accept the tool's plug. Replace or repair damaged or worn cord immediately.

IMPORTANT SAFETY INSTRUCTIONS

WARNING: When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following:

READ AND FOLLOW ALL INSTRUCTIONS.

There are certain applications for which this tool was designed. Porter-Cable strongly recommends that this tool NOT be modified and/or used for any application other than for which it was designed. If you have any questions relative to its application DO NOT use the tool until you have written Porter-Cable and we have advised you.

Manager of Product Engineering
Porter-Cable Corporation
Youngs Crossing at Highway 45
P.O. Box 2468
Jackson, TN 38302-2468

1. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite injuries.

2. **AVOID DANGEROUS ENVIRONMENT.** Don't expose power tools to rain. Don't use power tools in damp or wet locations. Keep area well lit. Avoid chemical or corrosive environment. Do not use tool in presence of flammable liquids or gases.

3. **GUARD AGAINST ELECTRIC SHOCK.** Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges, refrigerator enclosures.

4. **KEEP CHILDREN AWAY.** Do not let visitors contact tool or extension cord. All visitors should be kept away from work area.

5. **STORE IDLE TOOLS.** When not in use, tools should be stored in dry and high or locked-up place — out of the reach of children.

6. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was intended.

7. **USE RIGHT TOOL.** Don't force small tool or attachment to do the job of a heavy duty tool. Don't use tool for purpose not intended—for example—do not use a circular saw for cutting tree limbs or logs.

8. **DRESS PROPERLY.** Do not wear loose clothing or jewelry. Loose clothing, draw strings and jewelry can be caught in moving parts. Rubber gloves and non-skid footwear are recommended when working. Wear protective hair covering to contain long hair.

9. **USE SAFETY GLASSES.** Wear safety glasses or goggles while operating power tools. Also face or dust mask if operation creates dust. All persons in the area where power tools are being operated should also wear safety glasses and face or dust mask.

10. **DON'T ABUSE CORD.** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil, and sharp edges. Have damaged or worn power cord and strain reliever replaced immediately.

11. SECURE WORK. Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.

12. DON'T OVERREACH. Keep proper footing and balance at all times.

13. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and if damaged, have repaired by authorized service facility. Inspect extension cords periodically and replace if damaged. Have all worn, broken or lost parts replaced immediately. Keep handles dry, clean and free from oil and grease.

14. DISCONNECT TOOLS. When not in use, before servicing, and when changing accessories such as blades, bits, cutters, etc.

15. REMOVE ADJUSTING KEYS AND WRENCHES. Form habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.

16. AVOID UNINTENTIONAL STARTING. Don't carry plugged-in tool with finger on switch. Be sure switch is off when plugging in.

17. OUTDOOR USE EXTENSION CORDS. When tool is used outdoors, use only extension cords marked "Suitable for use with outdoor appliances - store indoors when not in use."

18. STAY ALERT. Watch what you are doing. Use common sense. Do not operate tool when you are tired or while under the influence of medication, alcohol or drugs.

19. CHECK DAMAGED PARTS. Before further use of the tool, 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 by an authorized service center unless otherwise indicated elsewhere in this instruction manual. Have defective switches replaced by authorized service center. Do not use tool if switch does not turn it on and off.

SAVE THESE INSTRUCTIONS

ADDITIONAL SAFETY RULES FOR BELT SANDERS

1. Make sure switch is in the "OFF" position before connecting tool to power circuit.

2. Do not wear loose clothing that might become entangled between the abrasive belt and sander frame.

3. Keep sander away from your body while the abrasive belt is in motion.

4. Always disconnect sander from power circuit before changing abrasive belts.

REPLACEMENT PARTS

When servicing use only identical replacement parts.

MOTOR

Most Porter-Cable tools will operate on either D.C., or single phase 25 to 60 cycle A.C. current and voltage within plus or minus 5 percent of that shown on the specification plate on the tool. Several models, however, are designed for A.C. current only. Refer to the specification plate on your tool for proper voltage and current rating.

CAUTION: Do not operate your tool on a current on which the voltage is not within correct limits. Do not operate tools rated A.C. only on D.C. current. To do so may seriously damage the tool.

EXTENSION CORD SELECTION

If an extension cord is used, make sure the conductor size is large enough to prevent excessive voltage drop which will cause loss of power and possible motor damage. A table of recommended extension cord sizes will be found below. This table is based on limiting line voltage drop to 5 volts (10 volts for 230 volts) at 150% of rated amperes.

If an extension cord is to be used outdoors it must be marked with the suffix W-A following the cord type designation. For example — SJTW-A to indicate it is acceptable for outdoor use.

RECOMMENDED EXTENSION CORD SIZES FOR USE WITH PORTABLE ELECTRIC TOOLS

		Length of Cord in Feet								
	115V	25 Ft.	50 Ft.	100 Ft.	150 Ft.	200 Ft.	250 Ft.	300 Ft.	400 Ft.	500 Ft.
	230V	50 Ft.	100 Ft.	200 Ft.	300 Ft.	400 Ft.	500 Ft.	600 Ft.	800 Ft.	1000 Ft.
Nameplate Ampere Rating	0-2	18	18	18	16	16	14	14	12	12
	2-3	18	18	16	14	14	12	12	10	10
	3-4	18	18	16	14	12	12	10	10	8
	4-5	18	18	14	12	12	10	10	8	8
	5-6	18	16	14	12	10	10	8	8	6
	6-8	18	16	12	10	10	8	6	6	6
	8-10	18	14	12	10	8	8	6	6	4
	10-12	16	14	10	8	8	6	6	4	4
	12-14	16	12	10	8	6	6	6	4	2
	14-16	16	12	10	8	6	6	4	4	2
	16-18	14	12	8	8	6	4	4	2	2
	18-20	14	12	8	6	6	4	4	2	2

OPERATING INSTRUCTIONS

FOREWORD

Porter-Cable Belt Sanders are designed for smoothing rough boards, removing old paint and varnish, fine-surfacing wood, metal, plastics and other materials.

SELECTING AN ABRASIVE BELT

The principal abrasive material used on belts for machine sanding are aluminum oxide and silicon carbide. The first is not as hard as the second, but is tougher and more suited for woods and soft (non-ferrous) metals. Silicon carbide is extremely hard and is best suited for surfacing stone, marble and glass.

Abrasives are classed as open-coated (spaced) or closed-coated, meaning that the grits are spaced apart or close together. Closed coatings provide hard, fast cutting action for hardwoods and dense metals while the open coatings are more suited to soft materials and painted surfaces.

To obtain the best finish, start with a "COARSE" grade of abrasive and change to "MEDIUM" and "FINE" grades as work progresses.

A wide range of available PORTER-CABLE Sanding Belts are listed in the back of the Manual. It is recommended that you keep a full assortment on hand so you will always have the correct belt for any job you may encounter.

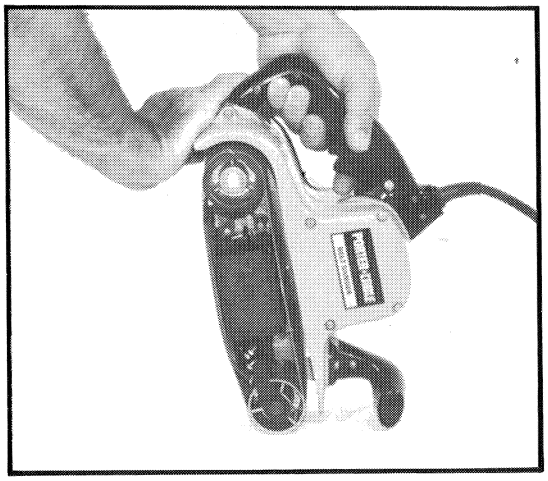


Fig. 1

INSTALLING AND REMOVING THE ABRASIVE BELT

CAUTION: Make sure sander is disconnected from power circuit before installing or removing the abrasive belt.

Stand machine on its front (idler) pulley and push down on rear handle until the pulley is fully retracted, as shown in Fig. 1. Then, tilt machine slightly to the right and ease off on the pressure to lock pulley in retracted position. The belt may now be easily removed or installed. Be careful not to strike outer end of idler pulley while removing or installing the abrasive belt. Hold the new belt so the arrow which is printed on the inside of the belt is on top of the pulleys and pointing forward toward idler pulley, as shown in Fig. 2. To release idler pulley, strike outer end with heel of hand. It will snap forward against the belt.

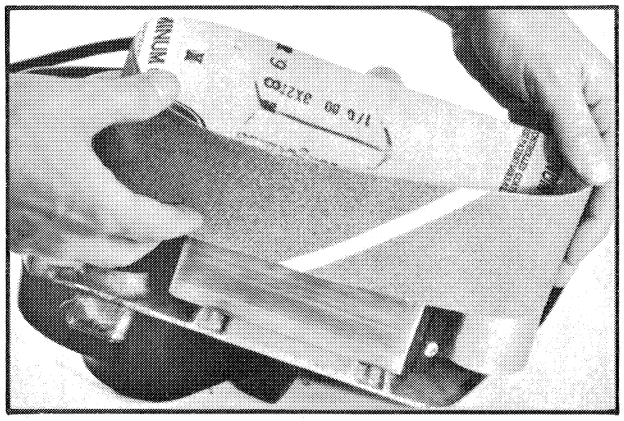


Fig. 2

TO START AND STOP MACHINE

To start the sander, squeeze the switch trigger (A) Fig. 3, into the handle. To stop the sander, release the trigger. A switch locking button (B) Fig. 3, is provided to keep the sander running without having to hold a finger on the switch trigger. This locking button is located on the left side of the handle. To engage locking button, squeeze switch trigger into handle, push in on locking button and, while holding button in, release trigger. To release locking button, squeeze trigger and release.

CAUTION: Always make sure switch is in OFF position before connecting sander to power circuit.

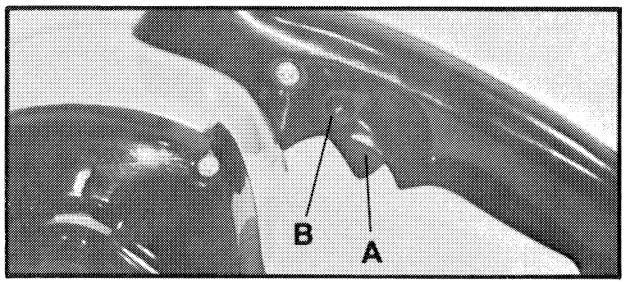


Fig. 3

TRACKING THE ABRASIVE BELT

NEVER allow abrasive belt to rub on frame of sander. This causes excessive wear to both the sander and belt. To prevent this, track the belt in the following manner:

1. **CAUTION:** Make sure trigger switch is OFF before connecting machine to power circuit.

2. Turn machine over, grasping rear handle with left hand so last two fingers rest on trigger switch (Fig. 4).

3. Start motor by squeezing trigger.

4. Turn the belt aligning screw (A) in either direction until edge of

belt runs flush with outer edge of rear rubber covered pulley. The edge of the belt will extend beyond edge of the front pulley.

5. Turn motor OFF and allow sander to come to a COMPLETE STOP before setting it down.

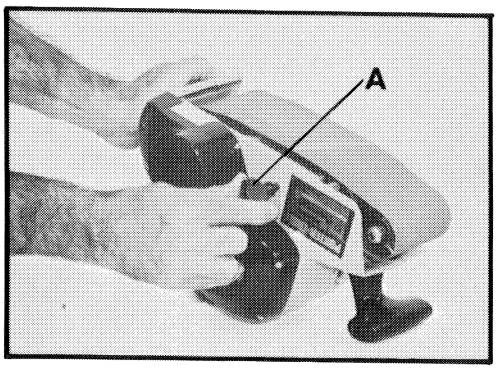


Fig. 4

HOW TO USE THE SANDER

1. **CAUTION:** SECURE WORK and maintain a FIRM GRIP on sander. Friction between sanding belt and work will try to move the work backwards and the sander forwards.

2. **CAUTION:** ALWAYS be sure switch is OFF before connecting sander to power circuit.

3. HOLD sander OFF the work and start motor.

4. LOWER sander to work, letting the rear part of the belt touch first. Level the machine as it is moved forward.

5. GUIDE the machine over the work in overlapping strokes allowing the sander to do the work.

6. AVOID applying excessive pressure when sanding. The weight of the machine is usually sufficient for a fast smooth finish. A slight increase in pressure may speed removal of material, while too much pressure will slow the motor and decrease removal.

7. WORK BACK and FORTH over a fairly wide area to obtain an even surface.

8. DO NOT let the machine tilt or the edge of the belt will make a deep cut into the surface.

9. NOTE: Do not pause in any one spot during the sanding operation because the belt will quickly remove material making the surface uneven.

10. Lift sander from work before turning OFF motor.

11. ALWAYS be sure motor has completely stopped before setting sander down.

FAST SANDING ON ROUGH WORK

To smooth a rough surface quickly, use 2½ grit abrasive belt. With the belt positioned diagonally across the grain, move the sander in the direction of the grain. Overlap the strokes well and cover the entire surface, working from both sides of the board. That is, once with the sander angled to the left and once angled to the right. Smooth the surface by guiding the sander back and forth with the grain. Change the belt to a #1 or 1½ grit and follow the same procedure. Finish off by thoroughly working over the grain lengthwise. Change again to a #2/0 or 3/0 grit and work entirely back and forth with the grain. Always finish your work by sanding with the grain.

REMOVING OLD PAINT AND VARNISH

Your sander is an excellent tool for removing old paint and varnish from flat surfaces. Two problems are common to such work. One is loading the abrasive with the material being removed and the other is overheating the paint or varnish by working too long in one place. Use a spaced grain or open coat abrasive belt and a single stroke action to overcome the loading problem. Lower the sander at the far end of the work and pull back. Raise the machine and do the same in a different location. Overheating can be avoided by using a fairly quick stroke and moving to another area for the next. A piece of felt about ¼" thick can be inserted under the shoe for fast spot sanding and for working on stubborn areas of paint and varnish.

SPECIAL SANDING PROCEDURES

Ordinarily the sanding stroke is back and forth. Some materials and some types of operations, however, require a different technique. In rough sanding, use the machine at an angle. In spot sanding, use the machine with only the front pulley touching the surface. This is especially required in smoothing excess glue from wood joints. On metals, slate, marble or plastic materials, there is no grain to worry about so the sanding may be done in different directions.

DOORS AND MILL WORK

When sanding doors, cabinet frames, sash, storm windows and screens, care must be taken to avoid working into the cross grain where one member meets another. Notice that the right edge of the belt is visible on your sander and you should watch it closely as work progresses. Work carefully along the edge where the rail meets the stile. If the joint is slightly uneven, use a 2/0 abrasive and very light sanding pressure to get it smooth before making the finishing runs.

SANDING VERTICAL SURFACES

For lengthy work on walls or other vertical surfaces, the sander can be counterbalanced with a length of sash cord, two small pulleys, a light wood frame and a weight the same as or slightly less than the weight of the sander. The frame consists of two pieces leaned against the wall with a third piece nailed across their top ends. The two pulleys are located so the weight on one end of the cord will be out of the way, but will balance the sander fastened to the other end. When starting vertical work, angle the sander so you can see the belt make contact with the material. As the belt touches, level the machine and

make the stroke away and to the left. This movement will offset any tendency to cut heavily into the work at the start of the stroke.

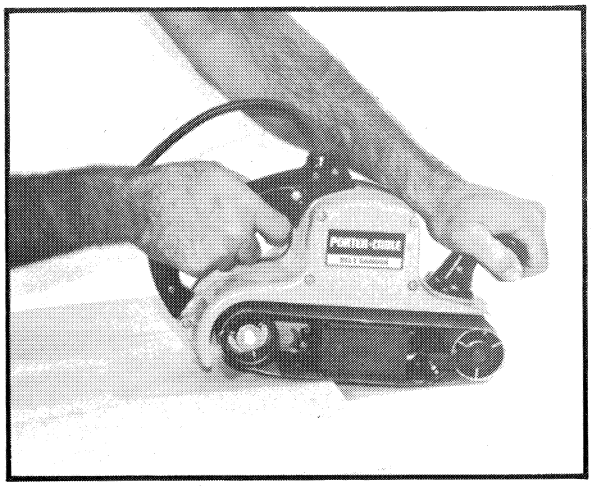


Fig. 5

GOOD SANDING TECHNIQUE

Getting the feel of your sander is most important in obtaining smooth results with a minimum of labor. You will quickly learn how to start the stroke with a sweeping motion that will produce the best results. Use a long even stroke without any additional pressure on the machine. Overlap each stroke and vary the length of movement so the results will be even over the entire surface. Always lift the sander from the work before starting and stopping the motor, BE CAREFUL WHEN RUNNING OUT TO THE END OF A BOARD NOT TO LET THE FRONT OF THE MACHINE DROP, AS SHOWN IN FIG. 5. This will have the effect of rounding the edge. Keep the sander on the work surface.

Your sander will do a perfect job for you if you will follow these few suggestions. It works very fast and can do a thorough job in a fraction of the time required by hand sanding. Do not rush the job. Give every surface a thorough working over with each grade of abrasive before changing to finer grits. Always use the abrasive material and grit size recommended for the job at hand.

THE DUST BAG - DUSTLESS SANDERS ONLY

To Install Dust Bag Assembly - Insert dust bag assembly elbow in vacuum housing nozzle on top of sander and push in until bag retainer spring engages groove in nozzle.

To Empty Dust Bag - For most efficient operation, empty the dust bag when it is not more than half filled. Grasp dust bag assembly elbow where it enters the vacuum housing nozzle and pull straight out. Unzip rear of bag and shake out dust. Occasionally turn the dust bag inside out and brush the dust accumulations from the lining with a soft brush. This will permit the bag to "breathe" better.

MAINTENANCE

KEEP TOOL CLEAN

Periodically blow out all air passages with compressed air. Remove built-up grime resulting from working green or sappy woods. All plastic parts should be cleaned with soft cloths. NOTE: Never use any solvents to clean plastic parts. Plastics can be easily damaged by such solvents.

CAUTION: Wear safety glasses while using compressed air.

LUBRICATION

This tool has been lubricated with a sufficient amount of high grade lubricant for the life of the unit under normal operating conditions. No further lubrication is necessary.

BRUSH INSPECTION

At approximately 100 hours of use, take or send your tool to your nearest Authorized Porter-Cable Service Station to be thoroughly cleaned and inspected; worn parts replaced, when necessary; relubricated with fresh lubricant, if required; reassembled with new brushes; and performance tested.

Any loss of power before the above maintenance check may indicate the need for immediate servicing of your tool. DO NOT CONTINUE TO OPERATE TOOL UNDER THIS CONDITION. If proper operating voltage is present, return your tool to the Service Station for immediate service.

BELT GUIDE

A belt guide is mounted on the motor frame directly back of the top portion of the abrasive belt. This guide protects the frame from being cut should the abrasive belt track improperly or be forced towards the frame during the sanding operation.

Inspect this guide frequently. Should it be worn, it can be turned over. If it is badly worn, replace it before the abrasive belt cuts thru into the motor frame. To turn guide over or to replace it, first remove the abrasive belt. Remove two top and rear button screws from shoe and tracking box assembly. Loosen front bottom screw only enough so shoe and tracking box assembly can be tilted out to make removal of belt guide easy. Remove belt guide screw. Turn guide over (do not turn it end for end) or replace it.

DRIVE PULLEY

The rubber-covered drive pulley at the rear of the machine is crowned or tapered from the center to either side to make the abrasive belt run true and in line with the idler pulley at the front of the machine. After considerable use, the crown will wear away and the belt will begin to run off the side of the pulley and cut into the guide block or frame. When the crown is worn to this extent, have the drive pulley replaced by your Authorized Porter-Cable Service Station. This action can be checked each time the abrasive belt is replaced and tracked. After the belt is tracked to the front pulley, watch it for a few seconds to see that it runs true and stays in place on the back

pulley. Avoid getting oil and grease on the rubber cover. It will cause it to fail.

FAILURE TO START

Should your tool fail to start, check to make sure the prongs on the cord plug are making good contact in the outlet. Also, check for blown fuses or open circuit breakers in the line.

SERVICE AND REPAIRS

All quality tools will eventually require servicing or replacement of parts due to wear from normal use. These operations, including brush inspection and replacement, should ONLY be performed by either an AUTHORIZED PORTER-CABLE SERVICE STATION or a PORTER-CABLE SERVICE CENTER. All repairs made by these agencies are fully guaranteed against defective material and workmanship. We can not guarantee repairs made or attempted by anyone other than these agencies.

Should you have any questions about your tool, feel free to write us at any time. In any communications, please give all information shown on the nameplate of your tool (model number, type, serial number, etc.).

ACCESSORIES

The testing of this tool has been accomplished with the following accessories. For safest operation, it is recommended that only these accessories be used with this product.

WARNING - Since accessories other than those listed have not been tested with this product, use of such accessories could be hazardous.

ABRASIVE BELTS

SA: Aluminum oxide open coat. For soft woods, paint and varnish removal.
A: Aluminum oxide closed coat. For hard woods.
T: Silicon carbide. For stone.

Size	Type	FINE Mesh and Grit Number 120-3/0	100-2/0	80-1/0
3" × 21"	SA	13141-10	13138-10	13135-10

Size	Type	MEDIUM Mesh and Grit Number 60-½	50-1	40-1½
3" × 21"	SA	13132-10	13129-10	13126-10

Size	Type	COARSE Mesh and Grit Number 36-2	30-2½	24-3
3" × 21"	SA	13123-10		

PORTER-CABLE LIMITED
ONE YEAR WARRANTY

Porter-Cable warrants its Professional Power Tools for a period of one year from the date of original purchase. We will repair or replace at our option, any part or parts of the product and accessories covered under this warranty which examination proves to be defective in workmanship or material during the warranty period. For repair or replacement return the complete tool or accessory, transportation prepaid, to your nearest Porter-Cable Service Center or Authorized Service Station as listed under"TOOLS-ELECTRIC" in the Yellow Pages of your telephone directory. Proof of purchase may be required. This warranty does not apply to repair or replacement required due to misuse, abuse, normal wear and tear or repairs attempted or made by other than our Service Centers or Authorized Service Stations.

To obtain information on warranty performance please write to: PORTER-CABLE CORPORATION, Youngs Crossing At Highway 45, P.O. BOX 2468, Jackson, Tennessee 38301; Attention: Product Service. The foregoing obligation is Porter-Cable's sole liability under this or any implied warranty and under no circumstances shall Porter-Cable be liable for any incidental or consequential damages. Some states do not allow limitations on how long an implied warranty lasts on the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

This warranty gives you specific legal rights and you may also have other legal rights which vary from state to state.

PORTER-CABLE SERVICE CENTERS

Parts and Repair Service for Porter-Cable Power Tools are Available at These Locations

ALABAMA
Birmingham 35209
131 West Oxmoor Road
Suite 105
Phone: (205) 942-6325

CALIFORNIA
Los Angeles 90007
2400 South Grand Avenue
Phone: (213) 749-0386

Orange 92668
385 North Anaheim Blvd.
Phone: (714) 634-4111

San Leandro 94577
3039 Teagarden Street
Phone: (415) 357-9762

COLORADO
Denver 80207
4900 East 39th Avenue
Phone: (303) 388-5803

CONNECTICUT
Manchester 06040 (Hartford)
57 Tolland Turnpike
Phone: (203) 646-1078

FLORIDA
Hialeah 33014
16373-75 NW 57th Ave.
Phone: (305) 624-2523

Jacksonville 32205
517 Cassat Avenue
Phone: (904) 387-4455

Tampa 33609
4538 W. Kennedy Boulevard
Phone: (813) 877-9585

Orlando 32803
1807½ Winter Park Road
Phone: (305) 644-8100

GEORGIA
Forest Park 30050 (Atlanta)
4017 Jonesboro Road
Phone: (404) 363-8000

ILLINOIS
Addison 60161
311 Laura Drive
Phone: (312) 628-6100

INDIANA
Indianapolis 46268
5317 West 86th Street
Park 100—Building 6
Phone: (317) 875-9078

LOUISIANA
Kenner 70062 (New Orleans)
2440-0 Veterans Memorial Blvd.
Phone: (504) 469-7363

MARYLAND
Baltimore 21205
4714 Erdman Avenue
Phone: (301) 483-3100

Hyattsville 20781
4811 Kenilworth Avenue
Phone: (301) 779-8080

MASSACHUSETTS
Allston 02134 (Boston)
414 Cambridge Street
Phone: (617) 782-1700

MICHIGAN
Grand Rapids 49506
Indian Village Mall
2750 Birchcrest Drive S.E.
Phone: (616) 949-9040

Southfield 48075 (Detroit)
18650 W. Eight Mile Road
Phone: (313) 569-4333

MINNESOTA
Minneapolis 55429
4315 68th Avenue North
Phone: (612) 561-9080

MISSOURI
North Kansas City 64116
1141 Swift Avenue
P.O. Box 12393
Phone: (816) 221-2070

St. Louis 63139
2348 Hampton Avenue
Phone: (314) 644-3166

NEW JERSEY
Union 07083
945 Ball Avenue
Phone: (201) 964-1730

NEW YORK
New York 10013 (Manhattan)
132 Lafayette Street
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