

ES-108



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GENERAL SAFETY RULES

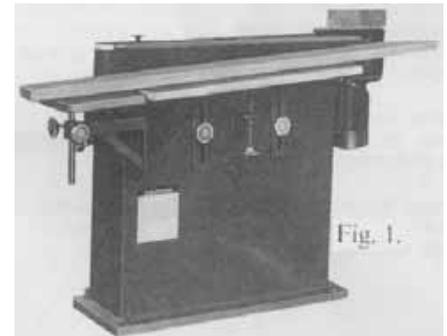
There is a certain amount of hazard involved with the use of woodworking machinery. Using the machine with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, severe personal injury to the operator can occur.

1. Read the operation manual before operating this machine.
2. If you are not thoroughly familiar with the machine operation, obtain advice from a supervisor or other qualified person.
3. The machine should be disconnected from the power source before performing maintenance or adjustments to the internal mechanisms, or when making repairs.
4. After maintenance job is finished, check to see if there are any tools or objects left on the machine. Close all safety guards.
5. Before leaving the machine, make sure the work area is clean.
6. Check timber for loose knots, nails, or other items, which may cause a hazard or affect the machine's performance.
7. Learn the machine's applications and limitations, as well as the specific potential hazards peculiar to it. Keep the machine in top condition for best and safest performance.
8. Keep all guards in place and in working order.
9. Do not force the machine. It will do the job better and be safer working at the rate for which it was designed.
10. All children and visitors should be kept a safe distance from the working area.
11. The operator should keep proper footing and balance at all times.
12. Do not operate the machine while under the influence of drugs, alcohol, or any other medication.
13. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the machine.
14. Never leave the machine until it comes to a complete stop, and never leave the machine running unattended.
15. The employer is responsible for selecting competent and qualified employees.
16. The employer must make sure that employees study and utilize this safety information.
17. Supervisors must alert personnel of any unsafe practices they observe.
18. All employees should be aware of first aid facilities and be encouraged to use them, regardless of the severity of the injury.
19. Fire prevention must be practiced and fire protection must be available to prevent loss of life, personal injury, and property damage.
20. Safety shoes should be worn to provide protection against rolling objects, falling objects, and sharp edges in the workplace.
21. Eye protection should be worn and such devices should be carefully selected, fitted and used. Compulsory wearing of glasses with impact resistant lenses and side shields is a good safety policy. All eye protection should conform to ANSI 87 standards.
22. Wear hearing protection when operating the machine.
23. Do not wear rings, necklaces or jewelry around moving machinery.
24. Do not wear loose fitting clothes. Clothing should be comfortable, but long sleeves, neckties, etc. should not be worn.
25. Do not wear gloves or other hand covering articles around moving machinery.
26. Cover long hair with a hair net or cap.

27. Protective guards and shields must be in place at all times unless they must be removed for specific service or maintenance. They should be immediately replaced when service or maintenance is completed.
28. Make sure that operator clearly knows how to stop the machine before starting work.
29. Never clean or remove chips while the machine is running.
30. Maintain the machine in good operating condition. Report unusual conditions or machine malfunctions immediately.
31. Do not alter or remove guards and warning labels.
32. Keep the immediate area clean. Do not allow the floor to become slippery, or covered with dust or obstacles. Dust that accumulates in the work area is a hazard that can cause you to fall or slip against the machine or its controls.
33. Employees should be required to report to their supervisors any hazardous condition of the machine or in the immediate area.

ADDITIONAL SAFETY RULES

- Before you turn on the machine, be sure everyone is clear of the machine. Keep hands away from the abrasive belt.
- Never take off safety guards.
- Make certain the abrasive belt is not torn or loose.
- When you turn on the machine, make sure the machine's rotation direction is correct. It should be the same as marked on the machine label. If not correct, change the power connection.
- When you change and install the abrasive belt, make sure that the abrasive belt has the same rotational direction as the machine. (See label on machine.)
- Make sure the abrasive belt is tracking correctly.
- Support work piece with worktable.
- When the front work table is going to be used at an incline, make sure that the inclined direction is correct and the work table is firmly fixed on the machine, Fig. 1, shows the correct front work table inclination.



SHIPPING & RECEIVING INSTRUCTIONS

This machine has been carefully inspected and tested before packing. It was delivered in good condition and was shipped in one wooden pallet.

When receiving this machine, inspect the wooden pallet and check to see if there is any damage. Then check the machine model and all items as according to the packing list.

If there is any damage on the machine or any missing parts, report it to your local distributor or the machine manufacturer immediately.

UNPACKING & CHECKING CONTENTS

The machine has been well packed at the manufacturer's factory and shipped in good condition. The machine is shipped in one wooden pallet.

Upon receiving the machine, carefully unpack it and check all items as according to the packing list.

If you find any part is missed or damaged, contact your local distributor or the manufacturer of the machine immediately. Do not attempt to operate the machine until the missing parts are obtained and are installed correctly.

CLEANING THE MACHINE

The machine is coated with rust preventative oil before shipment. When the machine has been moved to the proper work site, wipe the oil from the machine using a soft cloth soaked in kerosene. Do not use gasoline, lacquer thinner, or any other volatile solvent, as these may damage the paint surface of the machine.

LIFTING THE MACHINE

The machine should be lifted or moved by a forklift. Make sure the loading capacity of the forklift is sufficient to raise the machine. Pay special attention to the machine balance while lifting the machine to prevent the machine from falling. The forks of the forklift must protrude over the machine bottom for uniform distribution of the entire machine weight.

SPECIFICATIONS

Abrasive Belt Size	6" x 108"
Table Size	37" x 7- ³ / ₄ " 19" x 12"
Platen Size	6- ⁷ / ₈ " x 39"
Motor	2 HP, 3Ø
Motor Contact Wheel	7" O.D. x 6" Race
Dust Outlet	4"
Machine Size	64- ¹ / ₂ " x 22- ¹ / ₂ " x 44"
Net Weight	492 lbs.
Packing Dimensions	66" x 20" x 48"
Gross Weight	684 lbs.

ELECTRICAL SAFETY RULES

1. Do not alter or bypass any protective interlock.
2. Before starting the machine, read and observe all warning labels and markings such as nameplates and identification plates.
3. Only personnel who are properly trained and have adequate knowledge and skill should undertake all electrical/electronic troubleshooting and repair.
4. Use extra precautions in damp areas to prevent yourself from accidental grounding.
5. Make sure your body and your tools are clear of electrical grounding.
6. The control panel doors should be opened only when it is necessary to check the electrical equipment or electrical wiring.
7. Before applying power to any equipment, establish without a doubt that all persons are clear.
8. Be alert and be sure you can work with no outside distractions.
9. Avoid wearing metal frame glasses or wearing a metallic necklace or chain, and never work on electrical equipment while wearing rings, watches, or bracelets.
10. When replacing conductors, make sure they conform to the manufacturer's specifications, including proper color-coding.
11. Do not alter the electrical circuits. If machine damage is caused by an unauthorized alteration, the user is responsible, not the manufacturer.
12. Always assume the electrical power is ON and treat circuit as live. This caution develops a habit that may prevent an accident.
13. Give capacitors time to discharge. Otherwise, it should be done manually with care.
14. Use proper test equipment to make certain you have an open circuit. Test equipment must be checked and calibrated at regular intervals.
15. Open the control panel doors only when it is necessary to check the electrical equipment or wiring. After closing the door, make sure the disconnecting means are operating with the disconnecting handle mechanism in its proper position.
16. All covers on junction boxes must be closed before leaving any job.

NOTE: Read Installation Requirements carefully.

MACHINE INSTALLATION & LEVELING ADJUSTMENT

For the most part your machine is assembled. For shipping purposes the worktables, dust chute, steel platen and several other pieces are packed unattached.

You must install this machine on firm level ground. Adjust your position using a level to ensure maximum performance.

Follow the following instructions for installation of your machine.

First, place the machine in the spot you have chosen and mark four holes on the floor. Then, move the machine away and drill four holes, for 5/16" lag bolts. Reposition the machine back on to the spot and install the lag bolts but do not tighten until you have completely leveled your sander.

Using shims and a level to measure the machine tabletop in the lateral and longitudinal direction. Adjust so as to properly level your machine in all directions. Tighten the lag bolts and recheck the levelness of the tabletop. Repeat the above procedure again if necessary.

GROUNDING INFORMATION & POWER CONNECTIONS

NOTE: This machine has been factory wired; and before connection from the starter to the power source, be sure that the voltage is of the same characteristics as tied on cord tag.

Running on low voltage will damage the motor.

A competent electrician should complete the necessary wiring from the starter to the power source.

For personal safety, this machine must be properly grounded.

The edge sander must be grounded while in use to protect the operator from electric shock.

If this edge sander is 3-phase type, there is a four-conductor power source cable. If single phase type, there is a three-conductor power source cable. But whether 3-phase or single-phase their power source cable all have one ground conductor, the color is green or yellow with green.

NEVER CONNECT THE GREEN WIRE TO A LIVE TERMINAL.

The edge sander must be connected to a grounded, metal-enclosed wiring system per your local electrical code.

When wiring is completed tape all power box joints to keep out dust.

All wiring must conform to the National Electrical Code, State Laws and O.S.H.A.

ELECTRICAL CONTROLS

CAUTION: Be sure that your hands are clear of the machine and abrasive belt before starting machine.

This edge sander is equipped with a push-button magnetic control system: the start and stop push-buttons are mounted on the top/front of the machine.

When starting the machine, make sure the rotational direction is correct, if not, change power connection. If the machine is 3 phase change the two outside power leads; if single phase then you should check the motor connection. (Refer to wiring diagram in connection box)

ADJUSTING YOUR EDGE SANDER

If you are going to do any machine adjustment, disconnect machine from the power source.

Change Abrasive Belt

Changing the abrasive belt of your edge sander is very easy and fast. This machine uses a 6"x108" abrasive belt. The grit of the abrasive belt depends on what kind of finish you want to obtain. For more information, see page , "Use of Correct Abrasive Belt".

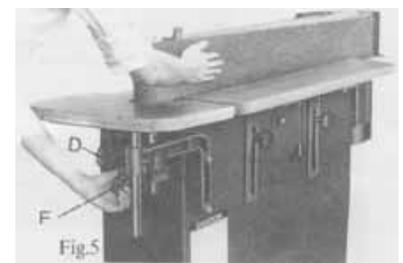
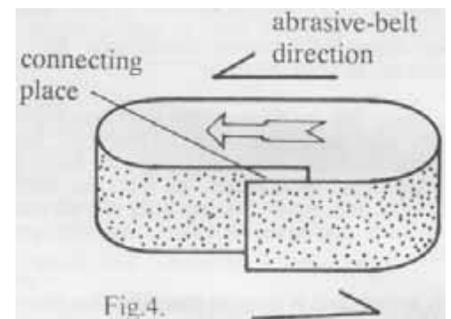
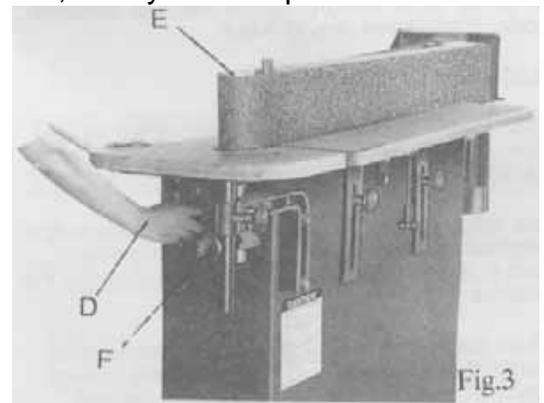
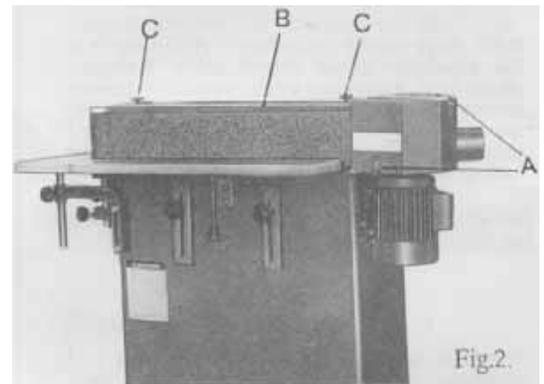
The following procedures show you how to change the abrasive belt:

1. Disconnect the machine from the power source.
2. Loosen the two push buttons (A) Fig. 2, on the dust chute, then you can open the dust hood.
3. Take the abrasive belt safety guard (B) out by removing the two knob bolts (C), which are on the safety guard.
4. Rotate the abrasive belt tension adjustment knob (D), Fig. 3, clockwise to release idler pulley device (E), then you can move out the old abrasive belt and put a new one on.

NOTE: Identify the abrasive belt direction before you install the abrasive belt, because the abrasive belt rotational direction must be the same as the machine. The abrasive belt direction should follow the arrow direction, which is marked, on the reverse side of the abrasive belt.

If there is no arrow direction marked on the reverse side of the abrasive belt you are using, find the joint (connection area) of the belt. Layers connect this area. The top layer of the abrasive belt surface will determine its directions. (Fig. 4) Using the wrong abrasive belt rotational direction may cause the abrasive belt to break.

5. Place the new abrasive belt between the contact wheel and idler pulley, and then adjust the tension adjustment knob (D). Counterclockwise will maximize the tension; clockwise will minimize it.
6. Rotating the abrasive belt along the correct direction with one hand (Fig. 5, you can test if the abrasive belt tracking is correct on the machine. With your other hand correct the adjustment by using the track adjustment knob (F). If you want to lower the abrasive belt, rotate the track adjustment knob clockwise and vice versa. When suitable level is obtained, the abrasive belt will rotate steadily and have the same level.
7. After you finish the track testing, replace the safety guard (B) and close the dust hood, tighten the knob.



8. Before hooking the machine to power and starting be sure the area is clear and your hands are away from the abrasive belt.
9. Turn the machine on and off quickly several times to check if the abrasive belt rotation is normal and the rotation track is correct. If not, you need to adjust track adjustment knob (F) as noted above in Fig. 5.

Abrasive Belt Tracking Adjustment

The correct abrasive belt tracking during machine rotation is that the abrasive belt should keep the same steady level without moving too high or low. If this inconsistency occurs, follow the following procedures to adjust:

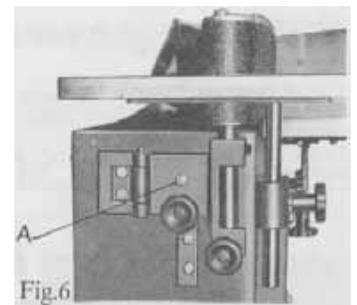
1. Disconnect the machine from the power source.
2. To determine the tracking situation of the abrasive belt, rotate the belt in the correct direction by hand. (Fig. 5)
3. While rotating the belt with one hand turn adjustment knob (F) with the other hand to get the correct tracking level. If the abrasive belt is too high, rotate the adjustment knob (F) clockwise; if the abrasive belt is too low, then rotate the adjustment knob (F) counterclockwise.

NOTE: Remember that the abrasive belt track adjustment equipment is very sensitive, so adjust it gently.

4. Making sure all workers are away from the machine and keeping all hands away from the abrasive belt, connect the power source to the machine. Turn the machine on and off quickly several times to check if the abrasive belt rotation is normal.

Abrasive Belt Tension Spring Fatigue Compensation Adjustment

Adjustment of the abrasive belt will cause spring fatigue when used for a long period. If this happens, you don't need to change the spring. Just rotate the tension adjustment screw (A), shown in Fig. 6, clockwise until you achieve the proper tension spring fatigue compensation.

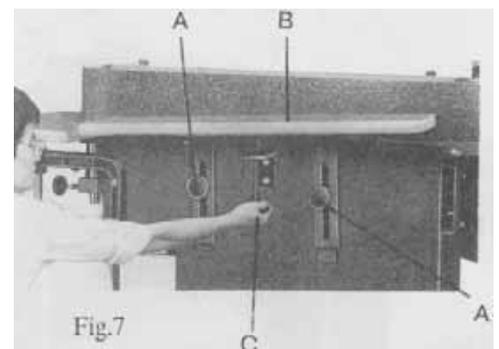


Front Work Table Inclination Adjustment

Using the inclined table method on this edge sander you may obtain a better abrasive surface contact, decreased sanding marks, and burn residue with results equal to that of an expensive oscillating sanding machine.

The procedures for adjusting the front worktable is as follows:

1. Disconnect machine from the power source.
2. Loosen the two fixed knobs (A), Fig. 7, raise the front worktable (B) by rotating the adjustment knob (C) and incline the degree you wish. Then tighten the two fixed knobs (A).

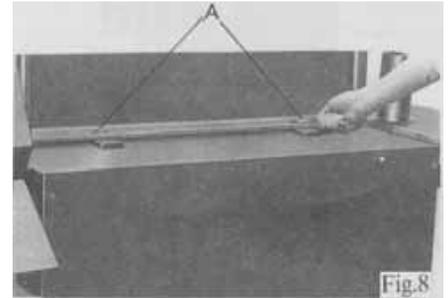


Steel Platen Adjustment

The steel platen is located between the motor contact wheel and the idler pulley. The surface of the steel platen should protrude about 1/8"-1/4" past the motor contact wheel and the idler pulley in order to assure that the abrasive belt will be in contact totally with the steel platen.

The procedures to adjust this platen are very simple:

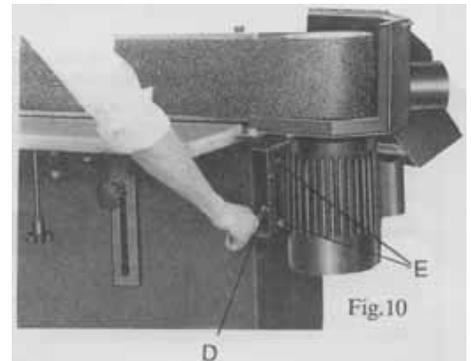
1. Disconnect the machine from the power source.
2. Follow previous "Change Abrasive Belt" procedures to remove the abrasive belt.
3. Loosen the two fixed screws (A), Fig. 8, on the steel platen.
4. Using a straight edge (B), Fig. 9, to measure the protruding distance between the surface of the steel platen and the two pulleys (i.e. motor contact wheel & idler pulley).
5. Tap, with hand, the steel platen, Fig. 9, until the protruding distance is 1/8"-1/4". Remember that with the platen on both sides the distance from the motor contact wheel and the idler pulley should be the same.
6. Tighten the two fixed screws (A), Fig. 7, on the steel platen.
7. Follow previous "Change Abrasive Belt" procedures to replace the abrasive belt, then the steel platen adjustment is complete.



Aligning Motor & Abrasive Belt

The motor and the abrasive belts on this machine were aligned before shipping. If you find them out of alignment due to shipping adjust as follows:

1. Disconnect the machine from the power source.
2. Adjust the front worktable to its lowest position.
3. Loosen the two fixed screws on the dust chute and take off the dust chute.
4. Remove the safety guard.
5. Rotate the belt by hand in order to check if the belt is completely parallel with the steel platen, top left to top right, this can be measured with a straight edge if necessary.
6. If the abrasive belt left to right is not parallel with the steel platen then the motor is not adjusted properly. To adjust, follow the procedure detailed below. By loosening the motor mounting screws (E) Fig. 10 and adjusting with the two jack screws (D).
7. If the right side of the abrasive belt (near motor) is too high, adjust motor inclination outward. If the left side of the abrasive belt (near idler pulley) is too high, adjust motor inclination inward, until the abrasive belt is parallel with the steel platen then tighten the four motor fixed screws (E).
8. Rotate the abrasive belt by hand again to make sure that the abrasive belt is completely parallel with the steel platen. Do the above adjustment again if necessary.
9. Replace the safety guard and dust hood, adjust the abrasive belt tracking (follow previous "Abrasive Belt Tracking Adjustment") if necessary.

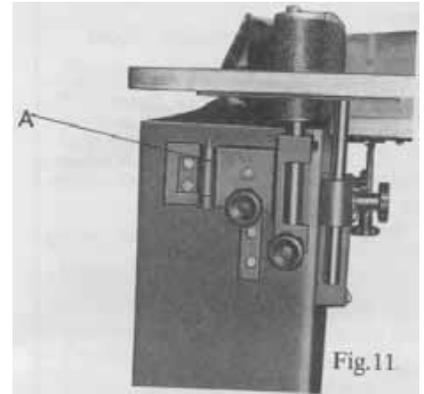


LUBRICATION GUIDE OF EDGE SANDER

Do not operate machine until properly lubricated.

All ball bearings are sealed type and require no further lubrication.

Apply a drop of light machine oil occasionally on the hinge of the tension mechanisms as shown in Fig. 11. (A). Service the machine every 6 weeks.



USE OF CORRECT ABRASIVE BELT

Chart A

Use chart "A" for selecting an abrasive belt. Aluminum oxide is recommended for general use in the home workshop.

Abrasive	Use	Coarse	Grit Medium	Fine
Aluminum	Hardwood	30-40	60-80	100-120
Oxide	Aluminum	40	60-80	100
	Copper	40-50	80-100	100-200
	Steel	24-30	60-80	100
	Ivory	60-80	100-120	120-180
	Plastic	50-80	120-180	240

Chart B

Chart "B" groups abrasives into five classes, indicating the grit numbers that fall in each.

Type	Very Fine	Fine	Medium	Coarse	Very Coarse
Aluminum Oxide	220-360	120-180	80-100	40-60	24-36

Contact your local dealer for all your sanding supplies. We have an outstanding line of abrasive belts for your convenience.

TROUBLESHOOTING

Should any difficulty arise during operation, check the power cord and connection, then go through the following list.

This machine was designed for very simple sanding operations and with proper, lost cost maintenance it will give you years of quality service.

Power

Symptom	Possible Cause	Correction
Sander will not start	Fuse blown or circuit breaker tripped	Replace fuse or reset circuit breaker
	Cord damaged	Have cord replace by an authorized repair station or qualified electrician
Overload kicks out frequently	Extension cord too light or too long	Replace with adequate size cord
	Excessive bite or feed pressure too great	Allow abrasive belt to cut freely—do not force
	Motor not wired for correct voltage	Refer to motor name plate for correct wiring
Abrasive belt does not come up to speed	Extension cord too light or too long	Replace with adequate size cord
	Low (house) current	Contact a qualified electrician
	Motor not wired for correct voltage	Refer to motor name plate for correct wiring
	Excessive bite or feed pressure too great	Allow abrasive belt to cut freely—do not force
Machine vibrates excessively	The spring, #28, for the tension mechanism is elastic fatigued or broken	Replace with a new spring
	The contact wheel, rubber covered #53, is too loose	Tighten the cap screw #52 in the motor shaft

Installation

Symptom	Possible Cause	Correction
Machine vibrates excessively	Stand or bench on uneven floor	Reposition on flat level surface. Fasten to floor if necessary. Refer to page 6

Mechanism

Symptom	Possible Cause	Correction
Machine vibrates excessively	Improper motor mounting	Check and adjust motor mounting
	Abrasive belt not tensioned correctly	Tensioning of the abrasive belt is accomplished through the use of the spring, which gives out the right amount of pressure for long belt life. Adjust abrasive belt tension by turning knob No. 11 out, and make sure the knob is released so the full tension of the spring is working.

Abrasive Belt

Symptom	Possible Cause	Correction
Machine vibrates excessively	Abrasive belt broken	Replace with a new abrasive belt
	Bad abrasive belt	Replace with a new abrasive belt
Inadequate job on metal	Wrong abrasive belt	Use aluminum oxide or silicon carbide abrasive belt not flint or garnet.
Sanding marks on work	Abrasive belt too coarse for finish required	Use very fine abrasive belt for final finish.
	Wrong abrasive belt grit	Use coarser grit for stock removal.
	Work sanded across grain	When surface sanding, use very fine abrasive belt then finish by hand, working in the direction of grain
Abrasive grains quickly rub form belt	Abrasive bond has lost its original properties	Do not store abrasive belts where it is extremely dry or where temperatures are extremely high
	Incorrect storage	Be sure to store abrasive belt and do not fold abrasive belt
Abrasive belt glazes	Sanding painted surface	Use open-grain flint abrasive belt.
	Wood is wet or gummy	No cure
Work burns	Wrong abrasive belt grit	Use coarser grit for stock removal

Operation

Symptom	Possible Cause	Correction
Work burns	Feed pressure too great	Never force work into steel plate
	Work held motionless	Keep work moving
Sanding marks on work	Work held motionless	Keep work moving
Abrasive belt burns, clogs quickly on thickness sanding	Biting too deep	Adjust for slight abrasive action and make repeated passes
Indentations in work	Work held motionless in one spot	Keep work moving
Sanding end idler pulley distorts	Excessive bite or feed pressure	Allow abrasive belt to sand freely—do not force
Work pulled from hand	No support	Use a stop to support work. The home made stop is made of hardwood and may be attached the right of the front table
Abrasive belt has broken at the joint	The abrasive belt is running in the wrong direction	Make sure the abrasive belt is running in the right direction

Adjustment

Symptom	Possible Cause	Correction
Sanded edge not square	Result of freehand sanding	Keep work piece flat on table top at all times when a square edge is desired
	Table misaligned	Check table alignment to steel platen. It should be at 90°. If not, adjust accordingly
Abrasive belt has bevel	Motor misalignment	Check out motor and adjust motor alignment.
Abrasive belt dropped while sanding	Abrasive belt not tensioned correctly	Adjust abrasive belt tension by turning knob #11 out or in for proper belt tension
	The spring #28 for the tension mechanism is elastic fatigued or broken	Replace with a new spring, #28
	Abrasive belt not tracked correctly	Adjust abrasive belt tracking.
Sander sanding unsatisfactorily	Incorrect positioning of the steel platen	Adjust the steel platen 1/8"-1/4" above the contact wheel and idler pulley

PARTS LIST

No	Part Name	Qty	No	Part Name	Qty
1	End Table	1	40	C-Ring STW12	1
4	End Steel Plate	1	41	Hinge Shaft	1
5	Hex. Head Wood Screw 1/4"-20NC*1-1/4"	8	42	Support Angle	1
6	Support Bar	1	43	Base	1
7	Table Support	1	44	Table Adjusting Knob 1/2"-12NC*200*61	1
8	Knob 1/2"-12NC*25*61	3	45	Hex. Head Bolt 1/4"-20NC*3/8"	8
9	Washer 3/8"*20*1.5	29	46	Washer 1/4"*16*1	8
10	Hex. Head Bolt 3/8"-16NC*2-1/2"	2	48	Washer 5/16"*16*1.5	4
11	Knob 3/8"-16NC*80-61	2	49	Back Cover	1
13	Spring Holder	1	50	Wing Screw 1/4"-20NC*3/4"	4
14	Hex. Head Bolt 3/8"-16NC*1-5/8"	1	51	Clamping Piece	2
15	Hex. Nut 3/8"-16NC	13	52	Socket Head Bolt 5/16"-18NC*1"	1
16	Spring	1	53	Contact Wheel	1
17	Cover Plate	2	54	Hex. Head Bolt 1/2"-12NC*- 1/2"	4
18	Socket Head Bolt 5/16"-18NC*2"	1	55	Hex. Nut 1/2"-12NC	4
19	Idler Pulley Holder	1	56	Set Screw 5/16"-18NC*3/8"	1
20	Socket Head Bolt 1/4"-20NC*5/8"	4	57	Motor	1
21	Front Table	1	58	Key 7*7*70	1
22	Front Steel Plate	1	59	Dust hood	1
23	Table Angle	2	61	Switch	1
24	Hex. Head Bolt 3/8"-16NC*1"	17	62	Washer 8.2*23*3	1
25	Hex. Head Bolt 3/8"-16NC*5/8"	2	65	Power Cord	1
26	Hinge Holder	1	66	Motor Cord	1
27	Spring Adjusting Block	2	68	Warning Label	1
28	Spring	1	69	Warning Label	1
30	Knob 5/16"-18NC*18*38	2	70	Label	1
31	C-Ring STW25	1	71	Pan Head Screw 3/16"-24NC85/8"	2
32	Bearing #6205LB	2	72	Strain Relief 1/2"	5
33	Safety Guard	1	73	Label	1
34	Pulley	1	74	Steel Platen	1
35	Abrasive Belt 6"*108	1	75	Hex. Head Bolt 5/16"-18NC*2-1/2"	2
36	Guard Support	2	76	Washer 5/16"*23*2	2
37	Pulley Shaft	1	77	Hex. Nut 5/16"-18NC	2
38	Steel Platen	1	80	Washer 1/2"*32*3	2
39	Graphite 6"*100m/m	1	81	Warning Label	1

