



# Operating Instructions and Parts Manual

## Belt and Disc Sander (1x42" belt, 8" disc)

Model J-4002



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**Part No. M-577003**  
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# 1.0 Warranty and Service

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

## Warranty Period

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

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

## Who is Covered

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

## What is Covered

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

## Warranty Limitations

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

## How to Get Technical Support

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

## More Information

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

## How State Law Applies

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

## Limitations on This Warranty

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

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

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

## Product Listing with Warranty Period

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

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

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## 3.0 Safety Warnings

### 3.1 General Cautions

- Misuse of this machine can cause serious injury.
- For safety, the machine must be set up, used and serviced properly.
- Read, understand and follow the instructions in the Operating Instructions and Parts Manual which was shipped with your machine.

#### *When setting up the machine:*

- Always avoid using the machine in damp or poorly lighted work areas.
- Always be sure the machine is securely anchored to the floor or the work bench.
- Always keep the machine guards in place.
- Always put the start switch in the "OFF" position before plugging in the machine.

#### *When using the machine:*

- Never operate the machine with safety guards missing.
- Always wear safety glasses with side shields (See ANSI Z87.1)
- Never wear loose clothing or jewelry.
- Never overreach; you may slip and fall into the machine.
- Never leave the machine running while unattended.
- Always shut the machine off when not in use.

#### *When servicing the machine:*

- Always unplug the machine from the electrical power before servicing.
- Always follow the instructions in the Operating Instructions and Parts Manual when changing accessory tools or parts.
- Never modify the machine without consulting JET.

You — the stationary power tool user — hold the key to safety.

Read and follow these simple rules for best results and full benefits from your machine. Used properly, JET machinery is among the best in design and safety. However, any machine used improperly can be rendered inefficient and unsafe. It is mandatory that those who use our products be properly trained in how to use them correctly. They should read and understand the Operator's and Parts Manual as well as all labels affixed to the machine. Failure in following all of these warnings can cause serious injuries.

### 3.2 General Machinery Warnings

1. Always wear protective eye wear when operating machinery. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specifications. Use of eye wear which does not comply with ANSI Z87.1 specifications could result in severe injury from the breakage of the eye protection.
2. Wear proper apparel. No loose clothing or jewelry which can get caught in moving parts. Rubber soled, nonslip, footwear is recommended for best footing.
3. Do not overreach. Failure to maintain a proper working position can cause you to fall into the machine or cause your clothing to get caught — pulling you into the machine.
4. Keep guards in place and in proper working order. Do not operate the machine with the guards removed.
5. Avoid dangerous working environments. Do not use stationary machine tools in wet or damp locations. Keep work areas clean and well lit.
6. Avoid accidental starts by being sure that the start switch is in the "OFF" position before plugging in the machine.
7. Never leave the machine running while unattended. The machine shall be shut off whenever it is not being used.
8. Disconnect the electrical power before servicing, whenever changing accessories or when general maintenance is done on the machine.
9. Maintain all machine tools with care. Follow all maintenance instructions for lubricating and the changing of accessories. No attempt shall be made to modify or have makeshift repairs done to the machine. This not only voids the warranty but also renders the machine unsafe.
10. If there is any risk of tipping or sliding, the machinery must be anchored to the floor.
11. Secure your work. Use clamps or a vise to hold your work, when practical. It is safer than using your hands and it frees both hands to operate the machine.
12. Never brush chips away while the machine is in operation.
13. Keep work area clean. Cluttered areas invite accidents.
14. Remove adjusting keys and wrenches before turning the machine on.

15. Use the right tool. Don't force a tool or attachment to do a job for which it was not designed.
16. Use only recommended accessories and follow manufacturer's instructions pertaining to them.
17. Keep hands in sight and clear of all moving parts and cutting surfaces.
18. All visitors should be kept at a safe distance from the work area. Make your workshop completely safe by using padlocks, master switches, or by removing starter keys.
19. Know the tool you are using; its application, limitations, and potential hazards.

### 3.3 General Electrical Cautions

This machine should be grounded in accordance with the National Electrical Code and local codes and ordinances. The work should be done by a qualified electrician. The machine should be grounded to protect the user from electrical shock.

**WARNING:** Do not connect the sander to a 240 volt power source. The sander motor requires 120 volts alternating current.

#### Wire Sizes

**CAUTION:** For circuits which are far away from the electrical service box, the wire size must be increased in order to deliver ample voltage to the motor. To minimize power losses and to prevent motor overheating and burnout, the use of wire sizes for branch circuits or electrical extension cords according to the following table is recommended:

Conductor length	AWG number (American Wire Gauge)
	120 volt lines
0-50 feet	No. 14
50-100 feet	No. 12
Over 100 feet	No. 8

*Table 1*

### 3.4 Safety Instructions for the Belt/Disc Sander

**WARNING:** Do not operate your machine until it is completely assembled and installed according to the instructions.

**WARNING:** Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead based paint.
- Crystalline silica from bricks, cement and other masonry products.

- Arsenic and chromium from chemically treated lumber.

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.

**WARNING:** This machine can be used for processing wood or metal products. However, combining wood dust and metal filings can create a fire hazard. Make sure that the dust collector is free of wood dust deposits before processing metal products.

1. If you are not thoroughly familiar with the operation of belt and disc sanders, obtain advice from your supervisor, instructor or other qualified person.
2. If there is a tendency for the machine to tip over or move during operation such as when sanding long or heavy boards, the machine must be securely fastened to a supporting surface.
3. Make sure the sanding belt is running in the proper direction. The sanding belt must travel downward when viewed from the front of the machine.
4. Make sure the sanding belt is tracking correctly in order that it does not run off the pulleys.
5. Make sure the sanding belt or disc is not torn or loose.
6. Hold the work firmly when sanding.
7. Always hold the work firmly on the table when sanding on the belt or disc. The only exception is curved work performed on the top wheel of the belt.
8. Always sand on the downward side of the disc when using the disc portion of the machine, so that the work is held securely on the table. Sanding on the upward side of the disc could cause the workpiece to fly up which could be hazardous.
9. Always maintain a minimum clearance of 1/16-inch or less between the table and the sanding belt or disc.
10. Never wear gloves or hold the work with a rag when sanding.
11. Sand with the grain of the wood.
12. Do not sand pieces of material that are too small to be safely supported.

13. Avoid awkward hand positions where a sudden slip could cause a hand to move into the sanding belt or disc.
14. When sanding a large workpiece, provide additional support at table height.
15. Never force the work. Slowing or stalling the motor will cause overheating.
16. When sanding metal, never use a steady stream of water on the work piece. Dip the workpiece in water to cool it.
17. Do not sand or polish magnesium. It could catch fire.
18. Always remove scrap pieces and other objects from the belt and disc tables before turning on the machine.
19. Never perform layout, assembly or set-up work on the tables while the sander is operating.
20. Always turn the machine OFF and disconnect the cord from the power source before installing or removing accessories.
21. Never leave the machine work area when the power is ON or before the machine has come to a complete stop.

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

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

**WARNING** This means that if precautions are not heeded, it may result in serious injury or possibly even death.

## 4.0 About this manual

This manual is provided by JET covering the safe operation and maintenance procedures for the J-4002 Belt/Disc Sander. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

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

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

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

## 5.0 Specifications

Model number .....	J-4002
Stock number .....	577003
Disc speed .....	1,725 RPM
Disc diameter .....	8 in.
Belt size .....	1 W x 42 L in.
Belt speed .....	3,000 SFPM
Disc table size .....	4 x 10 in.
Table slots .....	5/8 in.
Disc table tilt .....	45 deg. out
Motor .....	1/3HP (0.25kW) 115VAC 1PH 60Hz 1725 RPM, 6A
Overall dimensions.....	21L x 22W x 14H in.
Net weight .....	62 lb

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

**⚠WARNING** For your own safety, do not connect sander to power source until the machine is completely assembled and you have read and understood the entire Operating Instructions and Parts Manual.

## 6.0 Unpacking

The sander is shipped complete in one carton. Carefully unpack the machine and all loose items from the carton. If any shipping damage is found, contact your distributor.

If any parts are missing, do not attempt to operate your sander until the missing parts are obtained and installed correctly.

Remove the protective coating from the surfaces of the sander and from any loose parts. This coating may be removed with a soft cloth moistened with kerosene (do not use acetone, gasoline or lacquer thinner for this purpose). After cleaning, cover the table surfaces with a good quality paste wax.

## 7.0 Assembly

**⚠WARNING** Sander must be disconnected from power source during assembly.

Assembly of sander is limited to the installation of disc table and belt table. Proceed as described in the following paragraphs.

### 7.1 Assembling disc sander table

1. Disconnect machine from power source.
2. The sanding disc table is secured with two cap screws and nuts. A hex wrench is required to tighten the screws.
3. Set table on rounded pockets in support casting (see Figure 1). Install nuts in channel on back side of pockets.

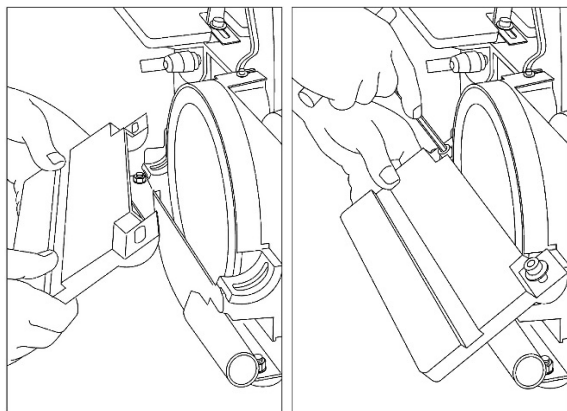


Figure 1

Figure 2

4. Install screws through table and base casting into the nuts. Tighten screws.

5. Check for 1/16-inch clearance between edge of table and face of disc. Adjust clearance if required (see sect. 10.4.2).

### 7.2 Assembling belt sander table

1. Disconnect machine from power source.
2. The belt table is secured with a spring-loaded locking handle assembly. The handle assembly is disassembled for ease of installation.
3. Remove screw and spring from handle assembly. Separate handle and stud.
4. Set table in place against sander.
5. Place flat washer (provided in sander carton) on the stud.
6. Install stud through belt table bracket and into sander housing. Tighten stud finger tight.

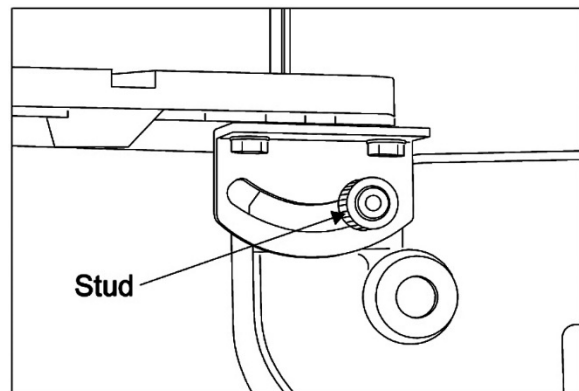


Figure 2: Installing stud in table bracket

7. Install handle over stud. Install spring and screw into stud.
8. To tighten handle (and secure table), pull out on handle (Figure 4). While holding handle out, turn handle counterclockwise. Release handle and tighten in clockwise direction. Repeat as required to secure table.

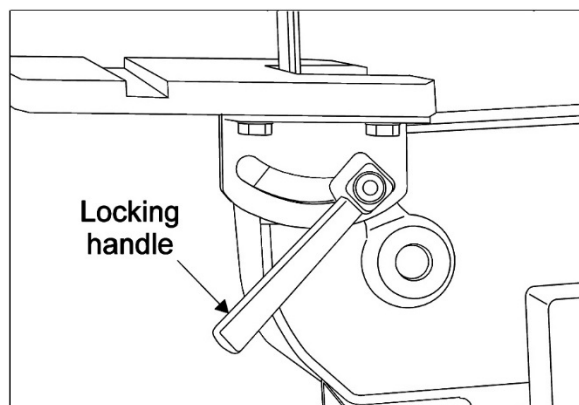


Figure 4: Belt table installed, handle in place

## 8.0 Setup

### 8.1 Fastening sander to supporting surface

During operation, the sander may have a tendency to slide or move about on the bench or table. It is recommended that the sander be fastened to the bench or table. Two holes are supplied in the sander base plate for easy mounting.

### 8.2 Dust chutes

The sander has two 1-1/4 inch diameter dust chutes (see Figure 5). The disc sander chute is at the rear of sander under the disc sander table. The belt sander chute is in the cover on left side of sander. The chutes can be connected to a vacuum system to collect dust particles during use.

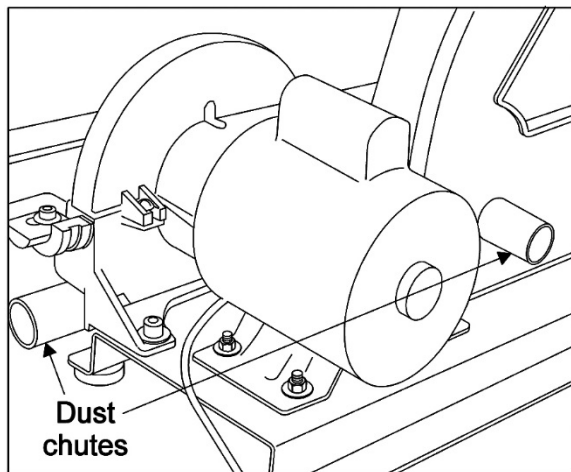


Figure 5: Dust chutes

## 9.0 Electrical connections

The motor supplied with your sander is wired for operation at 115 Volts. IT MUST NEVER BE CONVERTED TO OPERATE AT 230 VOLTS!

Before connecting motor cord to power source, make certain switch is in OFF position, and be sure that electric current is of same characteristics as stamped on motor nameplate.

### 9.1 Grounding instructions

**⚠ WARNING** The sander must be grounded while in use to protect operator from electric shock. Make sure that receptacle is properly grounded. If you are not sure receptacle is grounded, have a certified electrician check for proper grounding.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a

grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided—if it will not fit have a new outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment grounding conductor. If repair or replacement of the electric cord or plug is necessary do not connect the equipment grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only 3-wire extension cords that have 3-prong grounding type plugs and 3-hole receptacles that accept the plug, as shown in Figure 6.

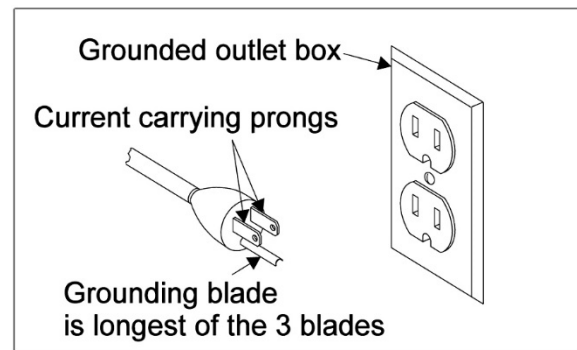


Figure 6: Grounded plug in grounded receptacle

Repair or replace damaged or worn cord immediately.

This tool is intended for use on a circuit that has an outlet and a plug that looks like the one shown in Figure 6.

A temporary adapter, which looks like the adapter illustrated in Figure 7, may be used to connect this plug to a 2-pole receptacle, as shown in Figure 7, if a properly grounded outlet is not available.

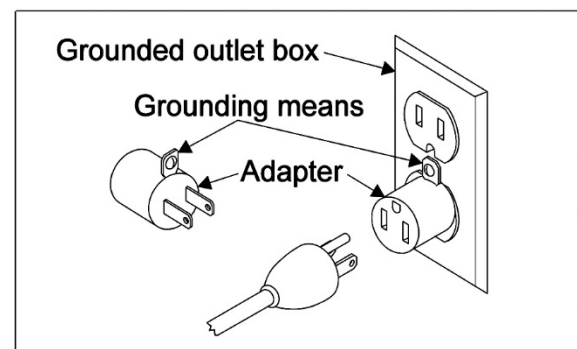


Figure 7: Grounded adaptor connection



## 10.0 Adjustments

**⚠WARNING** Disconnect machine from power source before making any adjustments.

### 10.1 Sanding belt tracking

The belt tracking adjustment is set at the factory so the belt runs true on the pulleys. However, if belt tracks to one side of pulleys, tracking can be adjusted by turning tracking knob. Turning knob clockwise moves belt to the right when facing the sander. Turning knob counterclockwise will move the belt to the left. *Avoid turning the knob too far. The amount of adjustment is usually very slight.*

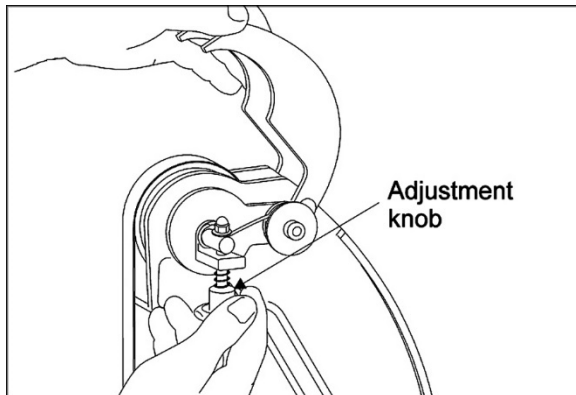


Figure 10: Adjusting belt tracking

### 10.2 Platen

The platen (see Figure 11) is used to properly support the work when sanding. The platen is constructed of heavy steel to provide adequate support.

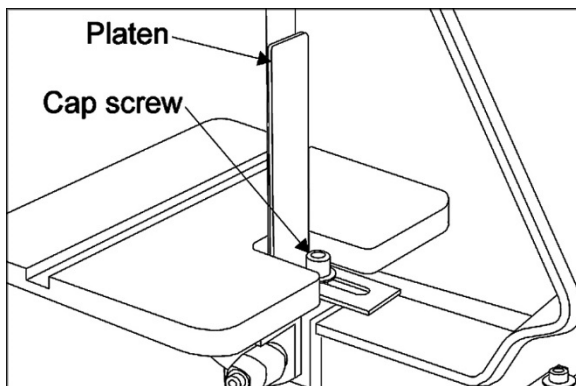


Figure 11: Platen

Disconnect machine from power source.

The platen should be adjusted so it is almost touching the back of sanding belt. Loosen cap screw and adjust platen to desired position. Tighten screw to secure platen.

The platen can be removed for operations such as stripping, contour sanding, polishing or other special operations. To remove platen, remove cap

screw. Be sure to reinstall platen before performing operations where support of the belt is required.

### 10.3 Belt table adjustments

The belt sander table can be tilted or moved in or out to accommodate the operation being performed. Loosen locking handle to change position of table. Move table to desired position and tighten locking handle.

**NOTE:** The locking handle is spring-loaded. Reposition the handle by pulling out on handle and turning handle on the serrated locking stud. Release handle and turn locking handle to tighten or loosen table.

**⚠WARNING** To avoid trapping the work or fingers between table and sanding belt, the table edge should be positioned a maximum of 1/16-inch from sanding belt.

#### 10.3.1 Setting belt table to 90-degrees

Disconnect machine from power source.

For most sanding operations, the table is set at 90-degree angle to sanding belt. Loosen table locking handle (see Figure 12) and tilt table to rear as far as possible. Use a combination square. Put one end of square on table with other end against sanding belt. Adjust table as needed until it is 90 degrees to belt. Re-tighten locking handle.

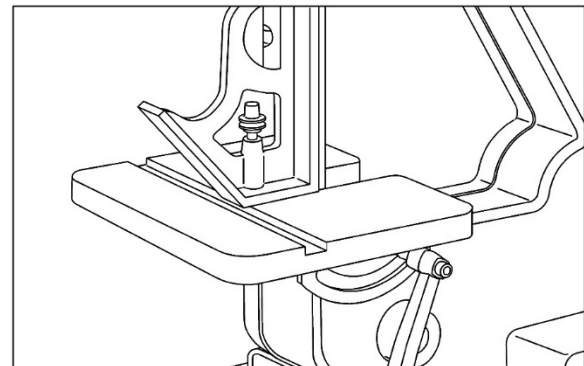


Figure 12: Setting belt table to 90-degree angle

#### 10.3.2 Setting belt table to 45-degrees

Disconnect machine from power source.

The table can be tilted to a 45-degree angle (see Figure 13). To change angle, loosen locking handle. Use a combination square to set table to 45 degrees to belt. Tighten locking handle to secure table.

**⚠WARNING** To avoid trapping the work or fingers between table and sanding belt, the table edge should be positioned a maximum of 1/16-inch from sanding belt.

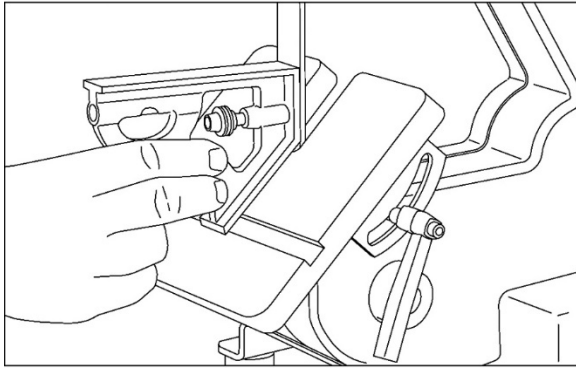


Figure 13: Setting belt table to 45-degrees

## 10.4 Disc table adjustments

### 10.4.1 Adjusting disc table angle

**⚠WARNING** To avoid trapping the work or fingers between table and sanding disc, the table edge should be positioned a maximum of 1/16-inch from sanding disc.

Disconnect machine from power source.

The disc table is positioned at 90 degrees to the sanding disc for most operations (see Figure 14). To check and see if table is 90 degrees, place a square on the table with one end of square against sanding disc. If an adjustment is necessary, loosen the cap screws and move table until it is 90 degrees to sanding disc. Tighten screws to secure table.

The disc table (see Figure 15) can be tilted downward 45 degrees. Loosen the two cap screws, tilt table to desired angle, and tighten cap screws.

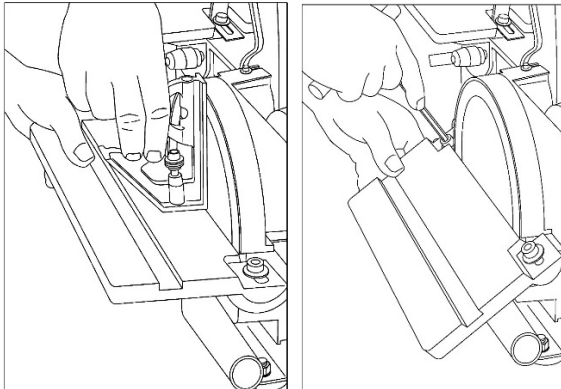


Figure 14: 90-deg.      Figure 15: 45-deg.

### 10.4.2 Adjusting disc-to-table gap

Disconnect machine from power source.

Adjust sanding disc to leave a maximum of 1/16-inch gap between table and disc. This can be accomplished by moving sanding disc in or out on motor shaft (see Figure 16).

Use T-handle type hex wrench. Put the wrench through the hole in top of disc guard. Loosen setscrew in hub of disc. Move disc in or out as

needed to establish a 1/16-inch gap. When gap is established, tighten setscrew.

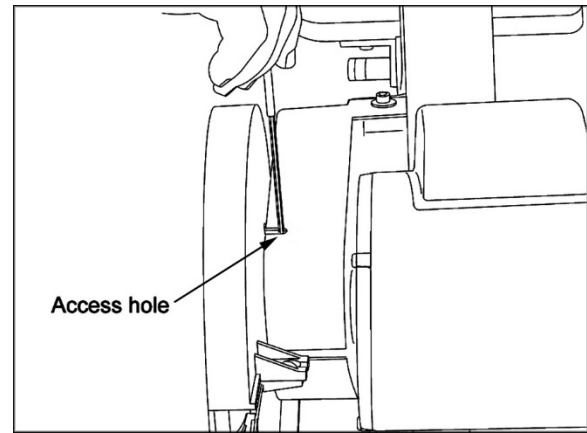


Figure 16: Removal of sanding disc

## 10.5 Changing abrasive belts

1. Disconnect machine from power source.
2. Remove upper belt cover by removing screw and nut (see Figure 17). Remove two knobs from side cover. Remove side cover.
3. Press down on tracking knob to release belt tension (see Figure 18).
4. Remove belt from the three pulleys. Install replacement belt.
5. Replace side cover; secure cover with two knobs.
6. Before installing upper belt cover, start sander and check belt tracking. Adjust tracking if needed (refer to sect. 10.1).

**IMPORTANT:** Some belts have a directional arrow printed on inside of belt. In these cases the belt must be installed so directional arrow is in same direction that machine is running. The sanding belt travels down the front of machine.

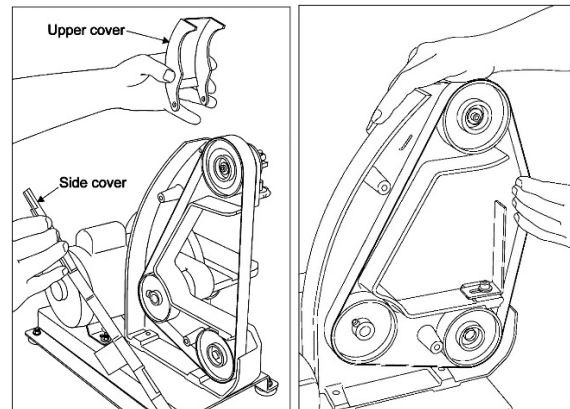


Figure 17:  
Cover removal

Figure 18:  
Belt removal

## 10.6 Changing abrasive discs

1. Disconnect machine from power source.
2. Remove screws and nuts from sanding disc table. Remove disc table.
3. Remove lower disc guard (see Figure 19).

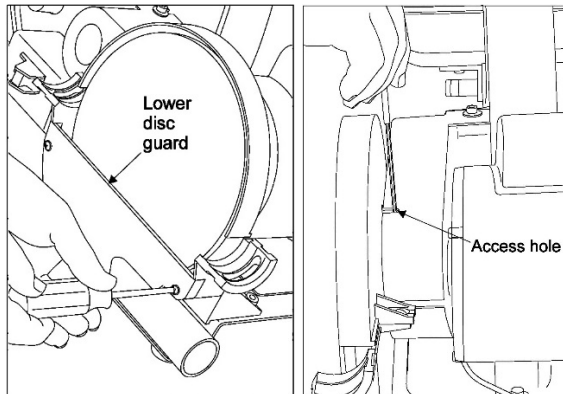


Figure 19:  
Lower guard removal

Figure 20:  
Sanding disc removal

4. Loosen setscrew in hub of disc. Remove disc from motor shaft (see Figure 20).
5. Remove old abrasive disc by peeling it from sanding disc plate.
6. Clean disc plate thoroughly. Spray the face of the disc with 3M Super 77 adhesive (or equivalent).
7. Remove backing from new abrasive disc and press abrasive disc firmly onto disc plate (see Figure 21).

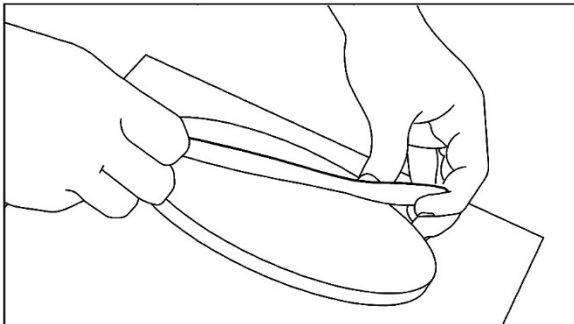


Figure 21: Attaching sanding disc

8. Align keyway in disc hub with key on motor shaft (see Figure 22). Install disc plate on shaft. Position disc so that the face of disc with the attached abrasive protrudes slightly more than the edge of upper disc guard.

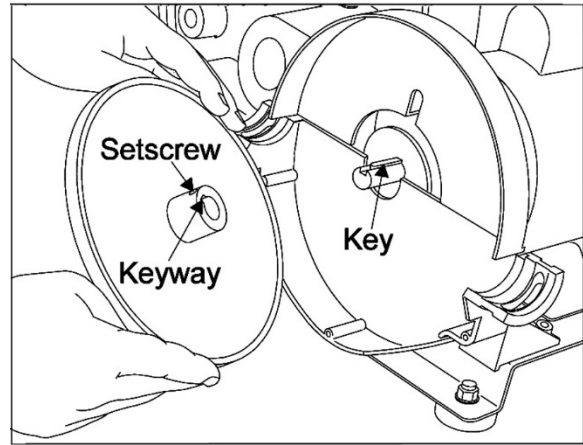


Figure 22: Disc installation

9. Tighten setscrew in hub of disc plate.
10. Replace lower disc guard and sanding disc table.

## 10.7 Miter gauge

A miter gauge (see Figure 23) is supplied with the sander. The miter gauge can be used on disc table or belt table. The miter gauge can be set anywhere up to 45 degrees right or left.

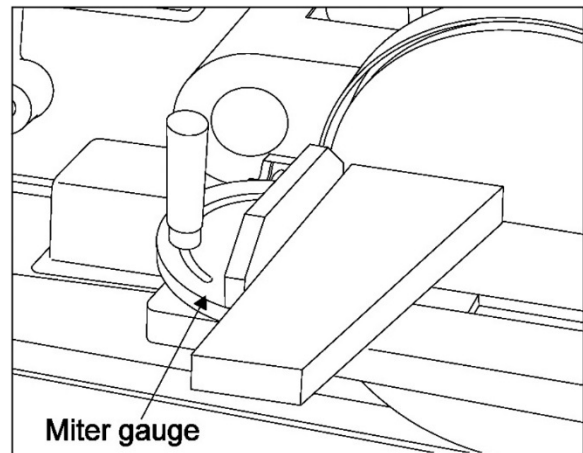


Figure 23: Miter gauge (shown on disc table)

Adjust the angle by loosening knob, rotating miter gauge to desired angle and retightening knob.

## 10.8 Motor Belt

Disconnect machine from power source.

If the motor belt becomes loose, the belt can be tightened by loosening the motor hold down nuts (see Figure 24). Slide motor to rear of sander to tighten belt. Hold motor in position and tighten the four hold down nuts.

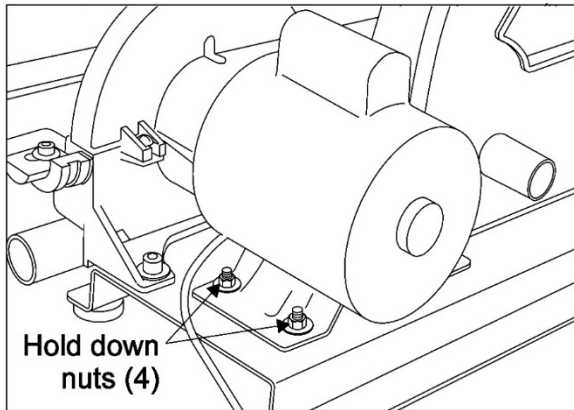


Figure 24: Tightening motor belt

## 11.0 Operating instructions

### 11.1 Starting and stopping sander

The on/off switch (see Figure 8) is mounted in a switch box on right side of sander base. Move switch to forward (ON) position to start sander. Move switch to rear (OFF) position to stop sander.

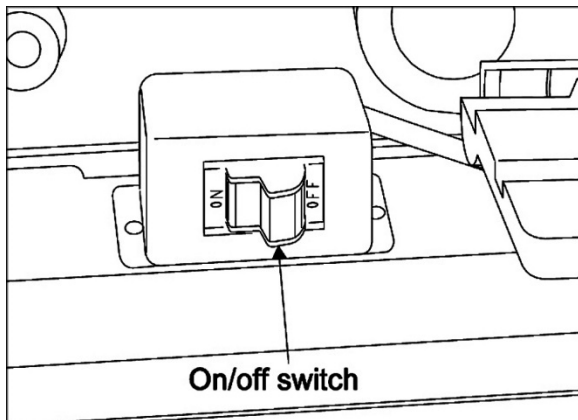


Figure 8: On/Off switch

### 11.2 Locking switch in OFF position

We recommend that switch be locked in OFF position when sander is not in use. The switch can be locked by pulling the switch locking tab out of the switch toggle (see Figure 9). The switch will not operate with locking tab removed. If switch toggle is removed when sander is running, it can be turned OFF once, but it cannot be restarted without inserting switch tab.

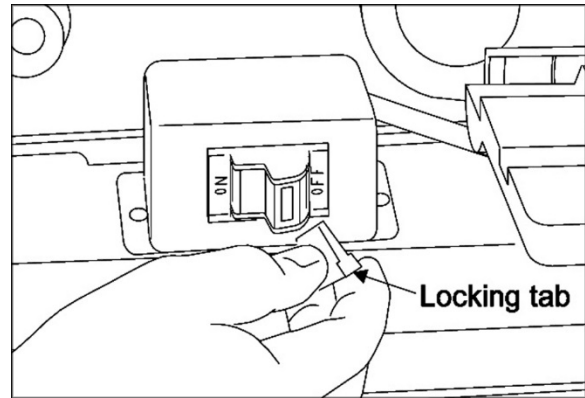


Figure 9: Switch locking tab

## 12.0 Typical operations

The following are just some of the many operations that can be performed with your JET Sander:

Sharpening a wood chisel on the sanding belt using a block of wood. Use the block of wood to support the chisel and provide clearance for the chisel handle (see Figure 25).

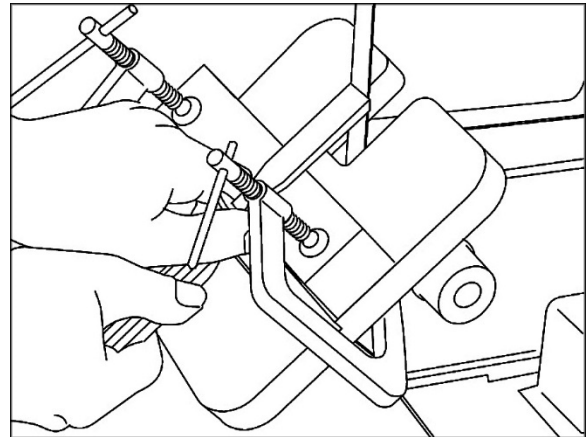
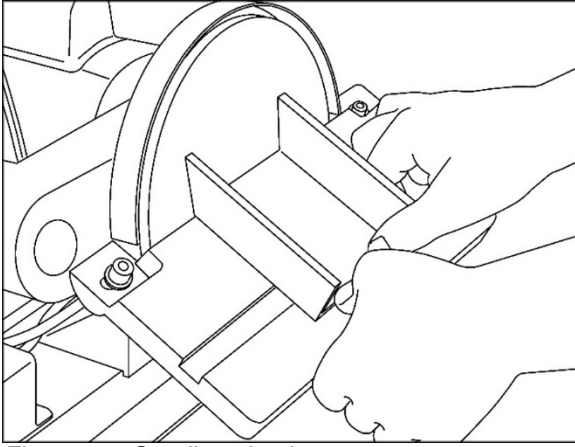


Figure 25: Sharpening a wood chisel

Sand a bevel in the block of wood in order to position the wood as close as possible to the sanding belt and clamp the wood to the table, as shown. A cold chisel can also be sharpened on the belt table with the table tilted.

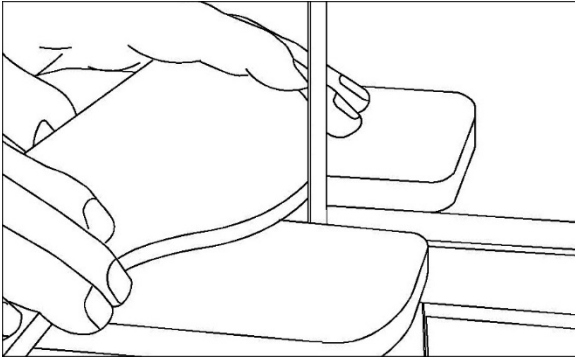
Sanding aluminum on the disc unit with the table tilted and using the miter gauge as a guide (see Figure 26).

**NOTE:** Always sand on the left (downward) side of the sanding disc, as shown. Sanding on the right (upward) side of the sanding disc could cause the workpiece to fly up which could be hazardous.



*Figure 26: Sanding aluminum*

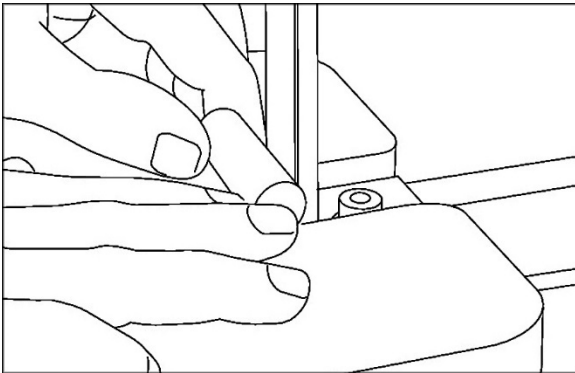
Sanding outside curves on the belt unit with the platen removed (see Figure 27).



*Figure 27: Sanding outside curves*

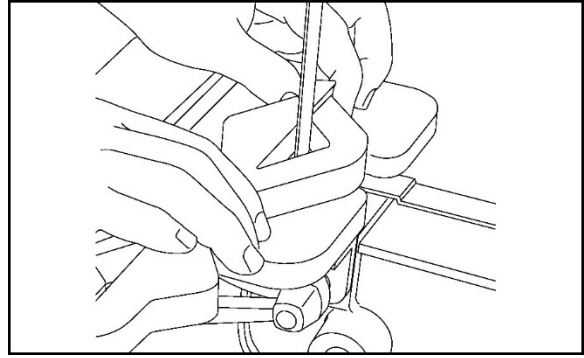
Polishing using the accessory felt belt in place of the sanding belt (see Figure 28).

**NOTE:** Most polishing operations are performed with the platen removed.



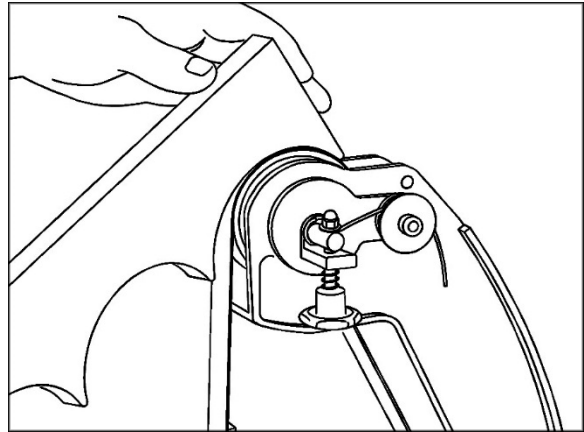
*Figure 28: Polishing using a felt belt*

Sanding in tight areas with the sanding belt (see Figure 29).



*Figure 29: Sanding in tight areas*

Inside curves can be sanded on the upper sanding belt idler wheel (see Figure 30). The upper cover can either be hinged back or removed.

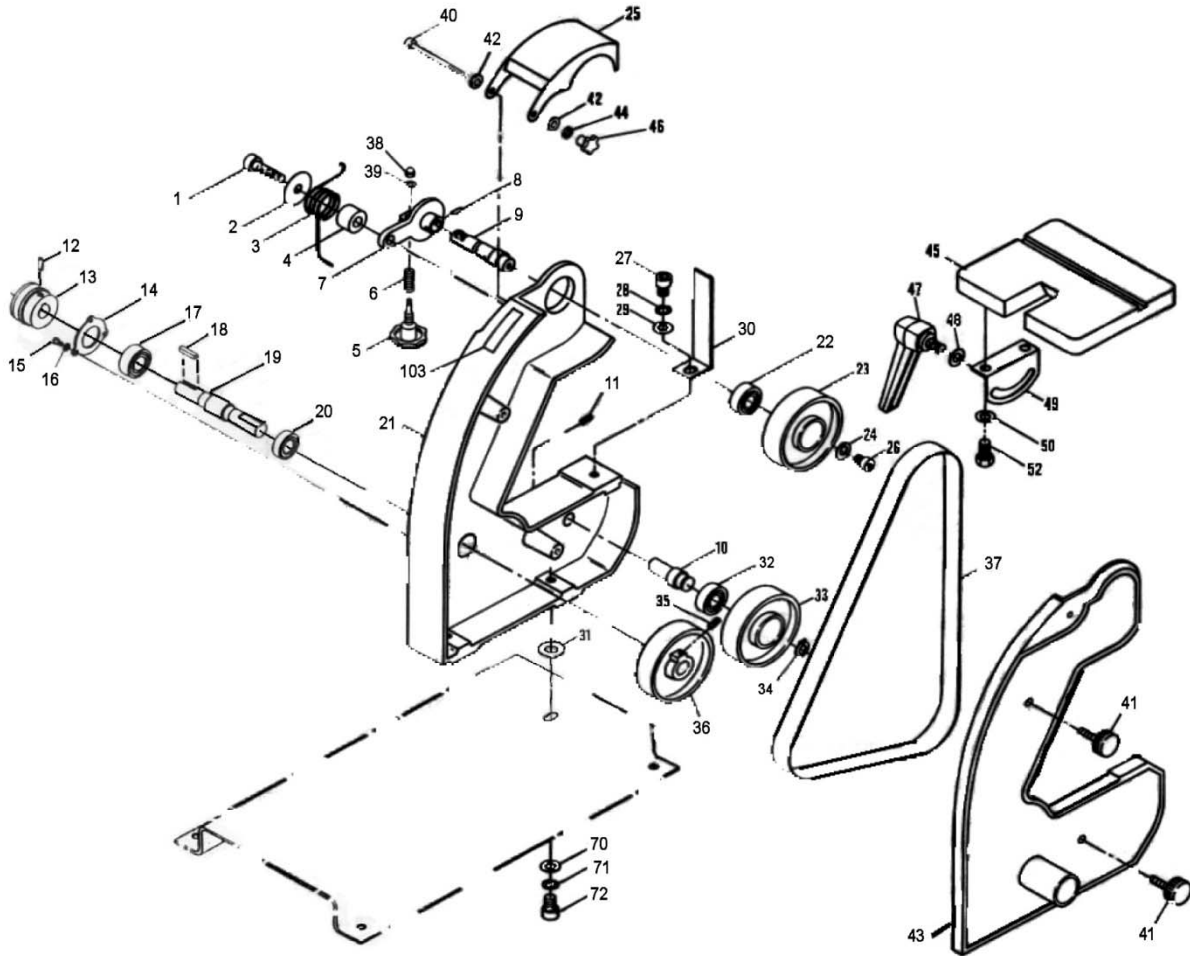


*Figure 30: Sanding inside curves*

## 13.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday (see our website for business hours, [www.jettools.com](http://www.jettools.com)). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

### 13.1.1 J-4002 Belt Parts – Exploded View

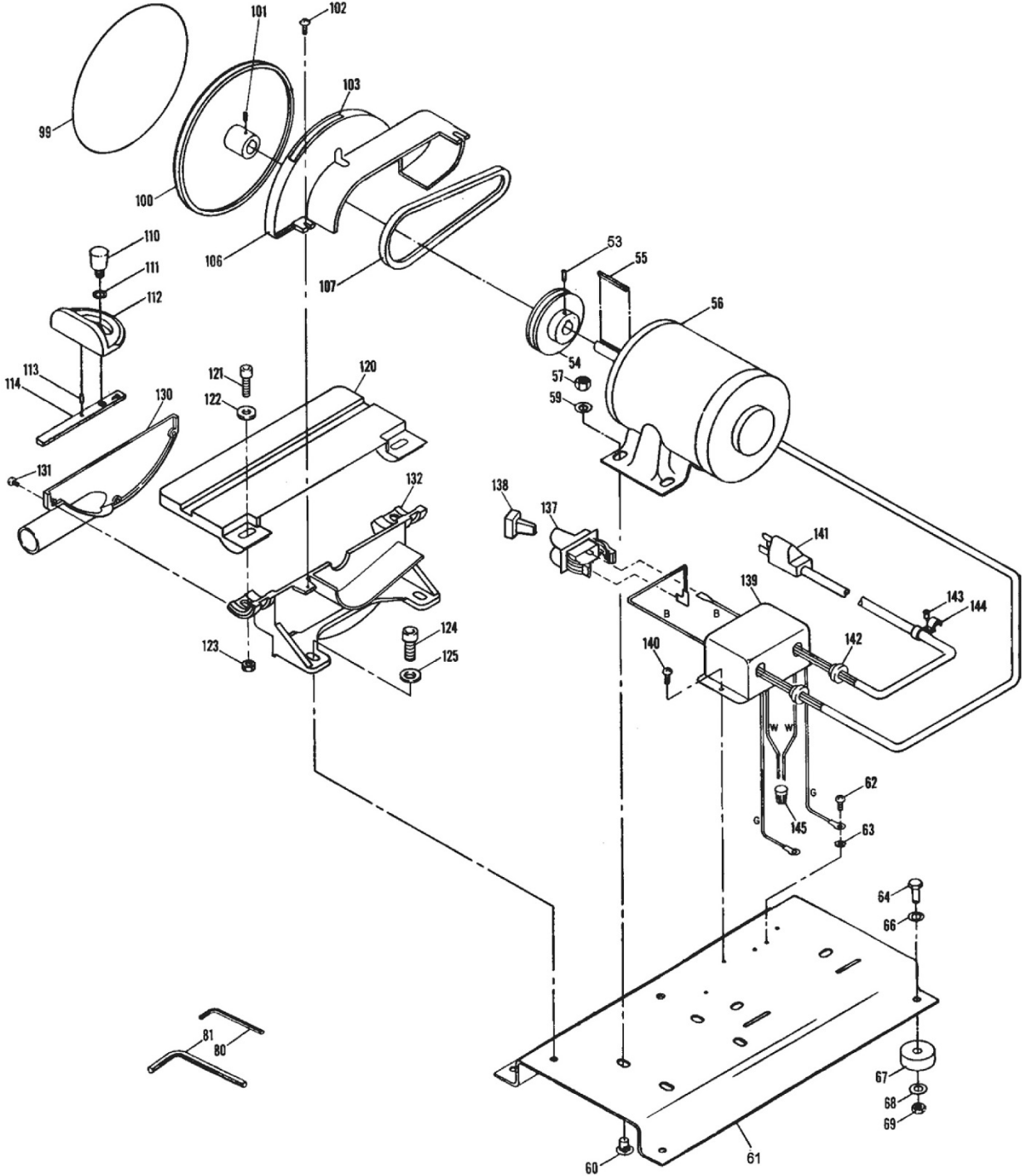


### 13.1.2 J-4002 Belt Parts – Parts List

Index No	Part No	Description	Size	Qty
1	5640031	Hex Socket Head Screw	M10x40	1
2	5640041	Flat Washer	10mm	1
3	5640051	Spring		1
4	5640061	Spacer		1
5	5640071	Tracking Adjustment Screw		1
6	5640081	Spring		1
7	5640091	Support		1
8	5640151	Spring Pin	M3x20	1
9	5640161	Idler Shaft		1
10	5640171	Idler Shaft		1
11	5640181	Hex Socket Set Screw	M5x5	1

Index No	Part No	Description	Size	Qty
12	5640191	Hex Socket Set Screw	M5x12	1
13	5640251	Drive Pulley		1
14	5640261	Retaining Plate		1
15	TS-2284081	Slot Head Machine Screw	M4x8	1
16	5640281	Lock Washer	M4	3
17	BB-6202ZZ	Ball Bearing	6202ZZ	1
18	5640331	Key		1
19	5640341	Main Drive Shaft		1
20	5640351	Ball Bearing		1
21	J-5640361G	Frame		1
22	BB-6202ZZ	Ball Bearing	6202ZZ	1
23	5640371	Idler		1
24	5640381	Flat Washer	6.4mm	1
25	5640391	Upper Cover		1
26	5640431	Hex Socket Head Cap Screw	M6x10	1
27	TS-1504041	Hex Socket Head Cap Screw	M8x20	1
28	TS-2361081	Lock Washer	M8	1
29	TS-1550061	Flat Washer	M8	1
30	5640471	Platen		1
31	5640481	Spacer		1
32	BB-6202ZZ	Ball Bearing	6202ZZ	1
33	5640371	Idler		1
34	5640491	Retaining Ring		1
35	TS-1523011	Hex Socket Set Screw	M6x6	1
36	5640521	Drive Wheel		1
37	5640101	Sanding Belt	50 Grit	
	5640111	Sanding Belt	80 Grit	
	5640121	Sanding Belt	120 Grit	
	5640131	Sanding Belt	220 Grit	
	5640141	Sanding Belt	320 Grit	
	5640301	Abrasive Belt, Non-woven – Fine		
	5640311	Abrasive Belt, Non-woven – Medium		
	5640321	Abrasive Belt, Non-woven – Coarse		
38	5640541	Nut		1
39	5640551	Washer		1
40	5640581	Bolt		1
41	5640571	Knob		2
42	5640631	Washer		2
43	5640591	Cover		1
44	5640681	Lock Washer		1
45	J-5640621G	Table		1
46	5640611	Knob		1
47	5640641	Clamp Assembly		1
48	5640651	Special Washer		1
49	5640661	Bracket		1
50	5640671	Flat Washer	M8	2
52	5640691	Screw	M8x16	2
70	5640461	Flat Washer	M10	2
71	5640451	Lock Washer	M10	2
72	5640441	Hex Socket Head Screw	M10x20	2
103	5640561	Rotation Label		1
104	JET-113	JET Logo (not shown)	113x47mm	1

13.2.1 J-4002 Disc Parts – Exploded View





### 13.2.2 J-4002 Disc Parts – Parts List

Index No	Part No	Description	Size	Qty
53	5640711	Hex Socket Head Screw	M5x12	1
54	5640721	Drive Pulley		1
55	5640731	Key		1
56	5640741	Motor		1
57	TS-0561031	Hex Nut	3/8"-16	4
59	TS-0680041	Flat Washer	3/8"	4
60	5640761	Carriage Head Screw	M10x12	4
61	J-5640771G	Base		1
62	TS-1533032	Pan Head Machine Screw	M5x10	2
63	TS-2193052	External Tooth Lock Washer	M5	2
64	5640811	Hex Head Screw	M8x20	4
66	5640671	Flat Washer	M8	4
67	5640821	Rubber Foot		4
68	5640671	Flat Washer	M8	4
69	5640831	Hex Nut	M8	4
80	5640841	Allen Wrench	2.5mm	1
81	5628781	Allen Wrench	6mm	1
99	5640201	Sanding Disc	50 Grit	
	5640211	Sanding Disc	80 Grit	
	5640221	Sanding Disc	120 Grit	
100	5640871	Disc Plate		1
101	TS-1523011	Socket Set Screw	M6x6	1
102	5640881	Screw		1
103	5640561	Rotation Label		1
106	5640921	Pulley Cover – Belt/Disc		1
107	5640931	V-Belt		1
	5640941	Miter Gauge Assembly (#110~114)		1
110	5640961	Hand Knob	1/4 in.	1
111	5640971	Flat Washer	3/16 in.	1
112	5640981	Miter Gauge Body		1
113	5640991	Spring Pin	M4x10	1
114	5641011	Guide Bar		1
120	J-5641021G	Table		1
121	5632851	Cap Screw		2
122	5641041	Washer		2
123	5641051	Nut		2
124	5641241	Cap Screw		2
125	5640461	Washer		2
130	5641121	Side Guard		1
131	TS-2285121	Pan Head Screw	M5x12	3
132	5641141	Support		1
137	5641161	Switch		1
138	5641171	Switch Key		1
139	5641181	Switch Cover		1
140	TS-1533032	Pan Head Machine Screw	M5x10	2
141	5641191	Cord		1
142	5641211	Heyco Bushing	5/8 in.	2
143	TS-1533032	Pan Head Machine Screw	M5x10	1
144	5641221	Cable Clamp		1
145	5641231	Connector		1

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