AXMINSTER

PROFESSIONAL

AP640DS Drum Sander

The packaging is suitable for recycling.
Please dispose of it in a responsible manner.

EU Countries Only
Do not dispose of electric tools together with household waste material. By law they must be collected and recycled separately.

Fully read manual and safety instructions before use. Save this manual for future reference.

Eye protection should be worn

Ear protection should be worn

Dust mask should be worn

Hazard

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

Original Instructions	
Code	113351
Version	1
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1. Safety

1.1 Safety instructions for general machinery

The purpose of safety symbols is to attract your attention to possible dangers. The safety symbols, and the explanations with them, deserve your careful attention and understanding. The safety warnings do not by themselves eliminate any danger. The instructions or warnings they give do not substitute for proper accident prevention measures.

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities may contain chemicals, including lead, birth defects, or other reproductive harm. Wash hands after handling. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

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

	For your own safety, read instruction manual before operating the machine. Learn the machine's application and limitations as well as the specific hazards peculiar.
	Always wear approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles everyday Eyeglasses are not approved safety glasses.
	Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear an approved respirator to reduce your risk.
	Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.
	Keep hands and clothing away from moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

Dirty or contaminated personal protective equipment can cause illness. Clean your personal protective equipment after each use and once a week.

1.2 Safety instructions for drum sanders

Main injury risks of drum sanders are: crushing or abrasion injuries from getting entangled between conveyor belt and sanding drums; impact injuries from being struck by workpieces that kickback or are thrown from the machine, or broken or dislodged components; respiratory damage or eye injury from to sawdust. To minimize your risk of these hazards, always heed the following warning information:

1. **FEEDING STOCK**. Do not allow anyone to stand at the out feed end when feeding your stock. Never sand more than one piece of stock at a time. DO NOT jam the workpiece into the machine during operation. Firmly grasp the workpiece in both hands and ease it into the machine using light pressure.
2. **MINIMUM STOCK DIMENSIONS.** Do not sand any stock thinner than 1⁄8", narrower than 2", or shorter than 9". Do not sand thin stock by using a “dummy” board under your workpiece.
3. **CLOTHING.** Do not wear loose clothing while operating this machine. Roll up or button sleeves at the cuff.
4. **HAND PROTECTION.** Do not place hands near, or in contact with, sanding drums during operation. DO NOT allow fingers to get pinched between board and conveyor belt during operation.
5. **INSPECTING WORKPIECES.** Always inspect workpiece for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.
6. **UNATTENDED OPERATION.** Never leave the machine running unattended.
7. **DUST COLLECTION SYSTEM.** Never operate the sander without an adequate dust collection system in place and running.
8. **REPLACING SANDING PAPER.** Replace sanding paper when it becomes worn.
9. **EXPERIENCING DIFFICULTIES.** Any problem, with the exception of conveyor belt tracking that is concerned with any moving parts or accessories, must be investigated and corrected with the power disconnected, and after all moving parts have come to a complete stop.
10. **MAINTENANCE AND ADJUSTMENTS.** Never attempt to adjust conveyor belt tracking when the sanding drums are engaged. Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.
11. **RESPIRATOR AND SAFETY GLASSES.** Always wear a respirator and safety glasses while operating the machine. Dust and chips are created when sanding. Some debris will be ejected, becoming hazards to the eyes and lungs.

No list of safety guidelines can be complete.
Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

1.3 Possible dangers caused by the drum sander.

The drum sander has undergone a safety inspection (hazard analysis with risk assessment).

It has been designed and built on the basis of this analysis. Anyway, there is a residual risk as the machine operates under electrical voltage and currents and high speed.

We have used design and safety engineering to minimize the health risk to personnel resulting from these hazards. If the machine is used and maintained by personnel who are not duly qualified, there may be a risk resulting from incorrect or unsuitable maintenance.
This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages.
Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

Live parts and movements of machine parts can cause severe injury to yourself and others! Proceed with extreme caution, if the mains plug of the drum sander cannot be disconnected due to the nature of the required work (e.g. functional check).

The use of unstable lifting and load suspension equipment that might break under load can cause severe injuries or even death. Check that the lifting and load suspension equipment are of sufficient load-bearing capability and are in perfect condition. Fasten loads carefully. Never walk under suspended loads!

1.4 Work area safety

1. Keep work area clean and well lit. Cluttered or dark areas invite accidents. Do not work on floor surfaces that are slippery with sawdust or wax. Keep the ground clear of tripping hazard.
2. Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
3. Keep bystanders at a safe distance from the work area. Never allow children or pets near the tool.

2. Technical Specification

2.1 Machine Description

A drum sander is used to remove surface material from stock using a looping abrasive belt, which is required when preparing a workpiece.
After the workpiece is placed on the conveyor, it moves forward and is pressed down slightly by the front pressure roller. Then the front and rear sanding drums remove material from the workpiece surface. Finally, the operator receives the workpiece at the back of the sander.
The table height handwheel is used to control cutting depth. Also, a variable speed knob allows the operator to adjust the conveyor speed for the specific type of workpiece and finish.

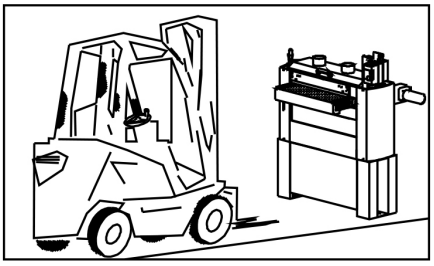
2.2 Technical Specification

Motor power	3000W
Small motor power	120W
Motor speed	1400RPM/50Hz 1680RPM/60Hz
Table size	660X625MM
Sanding belt length	3590MM
Sanding belt width	79MM
Sanding roller diameter x length	132X635MM
Max sanding width	625MM
Max workpiece height	130MM
Min workpiece height	5MM
Conveyor feeding speed	0-4.6 M/SEC
Dust port diameter	2X100MM

3. Assembly

3.1 Transport the machine

Transport the machine in its packing crate to a place near its final installation site before unpacking it. If the packaging shows signs of possible transport damage, take the necessary precautions not to damage the machine when unpacking.



1. Using pallet truck or forklift while moving the machine
2. The center of gravity is in the first half of the machine. Using assistant to support and stable the machine, to prevent the dangerous from fall in.

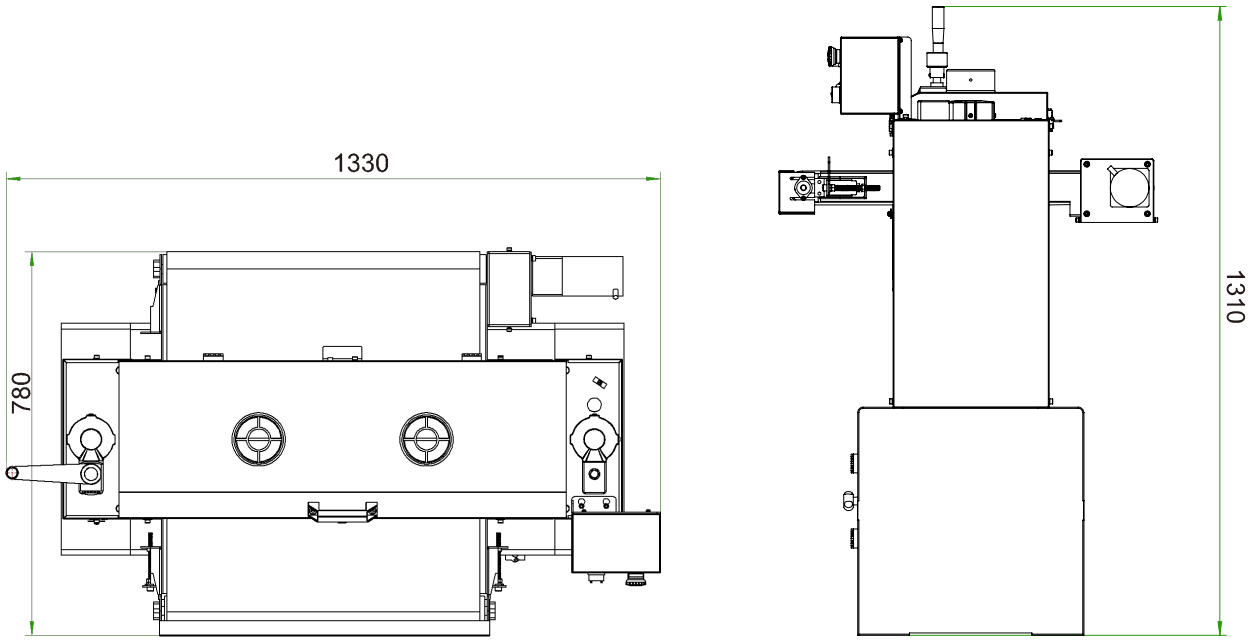
3.2 Unpacking the machine

The drum sander is delivered pre-assembled basically and users just need to install the switch control box. Inspect the machine completely and carefully, making sure that all materials, such as shipping documents, instructions and accessories supplied with the machine have been received.

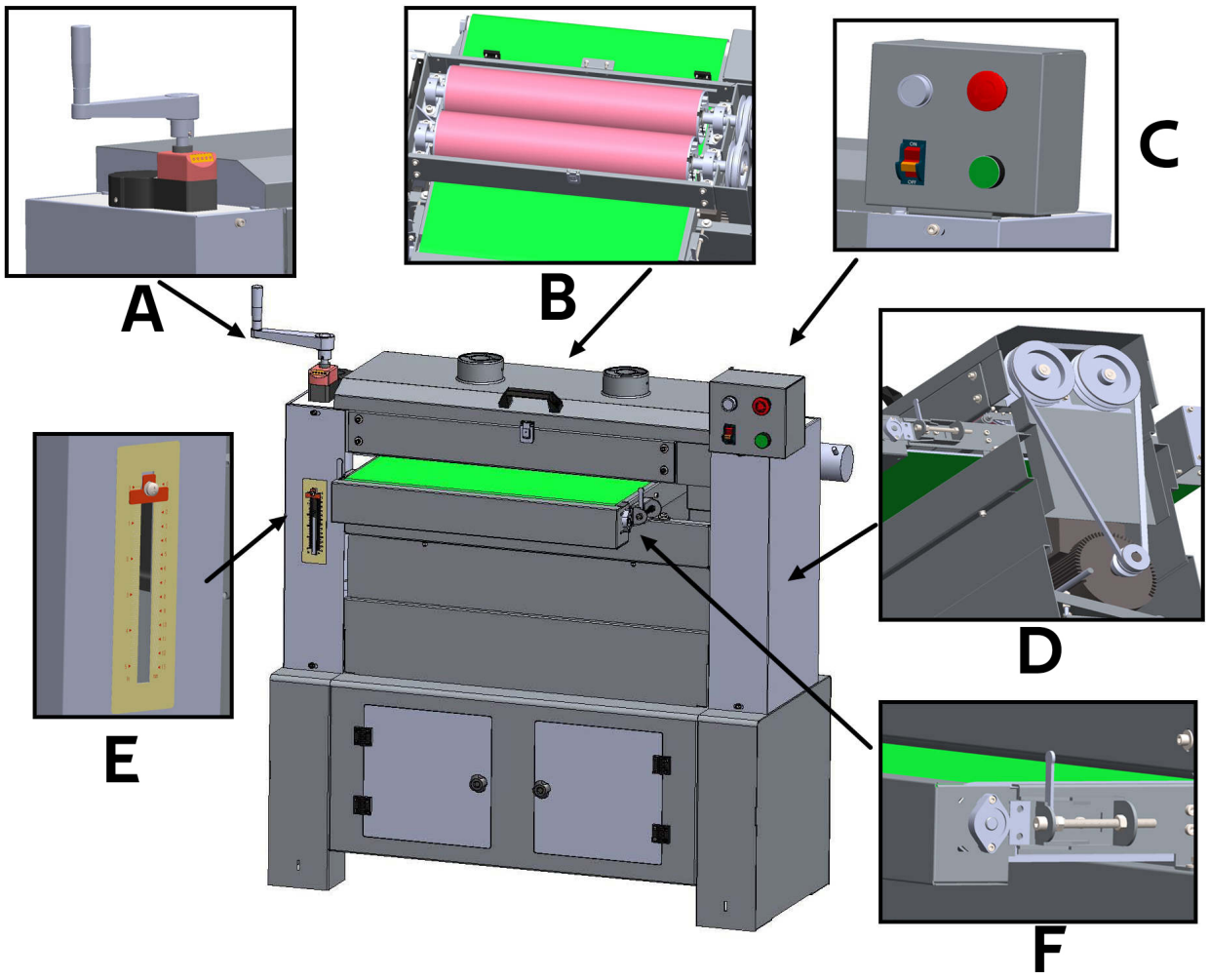
If you find some parts are missing, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

3.3 Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See Following Figure for the minimum working clearances.



3.4 Identification



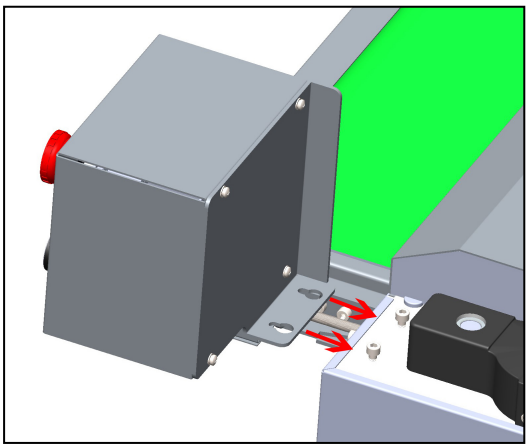
Part A	Crank Handle for Table Height.
Part B	Twin Drums system
Part C	Control Switch Panel

Part D	Belts Structure
Part E	Table Height Scale
Part F	Conveyor Tensioning and Tracking Structure

3.5 Assembly

The machine must be fully assembled before it can be operated. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

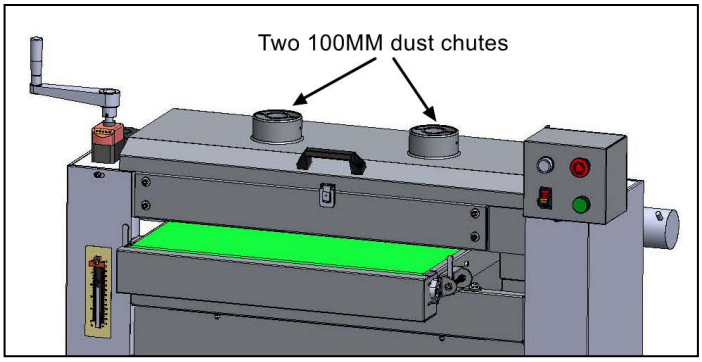
3.5.1 Install the control switch panel.



The machine is delivered pre-assembled basically and you just need to install the switch control box.

The two bolts are installed on the machine.
Loose the two bolts and make them through the mounting holes on the control box. Then tighten the two bolts at the small holes on the control box.

3.5.2 Attaching a dust collector.



The machine is provided with two 100mm dust chutes. Use ring clamps to attach dust collection hoses to the chutes.

Do not operate this machine without a dust collector attached and running!!

3.6 Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.
The test run consists of verifying the following:

1) Both motors power up and run correctly.
2) The safety disabling mechanism on the switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review Troubleshooting.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Make sure the sanding drum is safely above the conveyor belt so that it will not make contact when running.
4. Verify that the machine is operating correctly by turning it ON.

When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.
Investigate and correct strange or unusual noises or vibrations before operating the machine further.

Always disconnect the machine from power when investigating or correcting potential problems.
5. Rotate the conveyor variable feed rate dial clockwise to verify the conveyor belt feed rate changes, then turn it counterclockwise until the belt stops.
6. Turn the machine OFF.

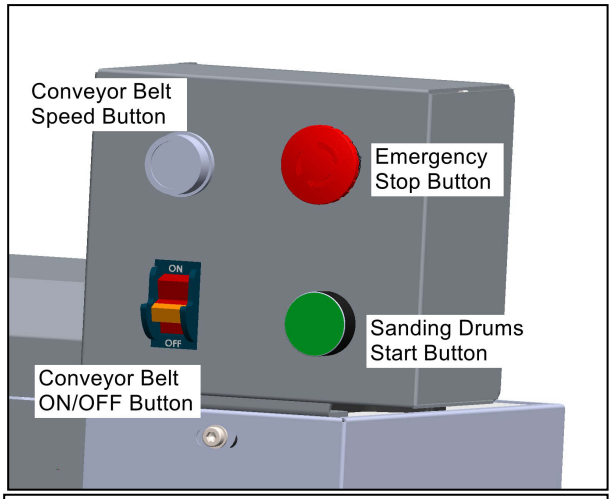
4. Operation

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.

Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.

Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

4.1 Basic control



Sanding Drums Start Button: Starts the sanding drums.
Conveyor Belt ON/OFF Button: Starts and Stop the conveyor belt.
Emergency Stop Button: Stops all electrical power to motors in event of emergency.
Conveyor Belt Speed Button: Adjust the infeed speed of the conveyor belt.

4.2 Aditional control

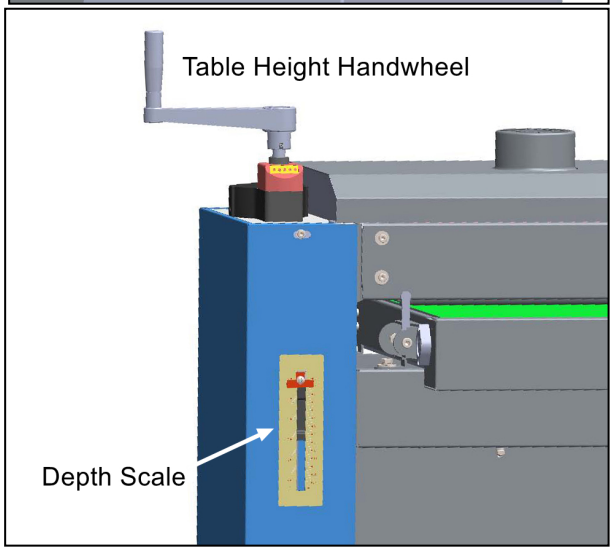


Table Height Handwheel:
Manually raises or lowers the conveyor table.
One full turn of the handwheel changes the height of the table 4mm.
Depth Scale: Indicates the thickness the workpiece will be after it has been sanded.

4.3 Workpiece inspection

Some workpieces are not safe to sand or may require modification before they are safe to sand. Before sanding, inspect all workpieces for the following:
▲ Material Type: This machine is intended for sanding natural and man-made wood products. This machine is NOT designed to sand metal, glass, stone, tile, etc.; sanding these materials with a drum sander saw may lead to injury.
▲ Foreign Objects: Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and hit the operator, cause kickback, or damage the machine.

Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.

▲ Large/Loose Knots: Loose knots can become dislodged during the sanding operation.
Large knots can cause kickback and machine damage. Choose workpieces that do not have loose knots.

▲ Wet or "Green" Stock: Sanding wood with a moisture content over 20% causes unnecessary wear on the sandpaper and motors, increases the risk of kickback, and yields poor results.

▲ Excessive Warping: Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!

▲ Minor Warping: Workpieces with slight cupping can be safely supported if the cupped side is facing the conveyor belt. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

4.4 Sandpaper selection

Sanding a workpiece smooth requires making progressively smaller scratches in the wood until they become too small to feel or be seen.

The abrasiveness of sandpaper is designated in grit size—the larger the number, the finer the abrasive and the smaller the scratches. Thus, 100 grit is finer than 60 grit.

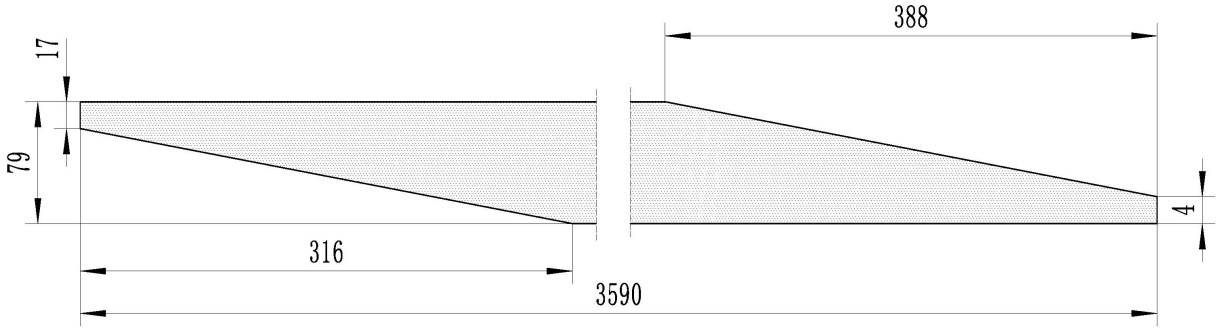
Typically, sanding operations start with a coarse grit and progressively work through the finer (larger number) grits until the desired finish is achieved. Avoid skipping a grit to achieve the best results. Choosing which grit to start and finish with depends on many factors, such as the workpiece condition, type and hardness of wood, the desired finish, and others.

There are many types of sanding belts to choose from. We recommend Aluminum Oxide for general workshop environments. Below is a chart that groups abrasives into different classes and shows which grits fall into each class.

Grit Size	Coarse Level	Characteristics and Uses
36	Extra Coarse	Maximum stock removal, abrasive planning, paint removal
60-80	Coarse	Stock removal, surfacing, end grain surfacing, planer mark removal
100-120	Medium	End grain smoothing, light surfacing
150-180	Fine	Finish sanding, surface preparation, thin stock dimensioning
220	Very Fine	Finish sanding

4.5 Sandpaper installation

We supply different replacement sandpapers with various grits, for meeting different uses.
The sandpaper is processed well with suitable size.

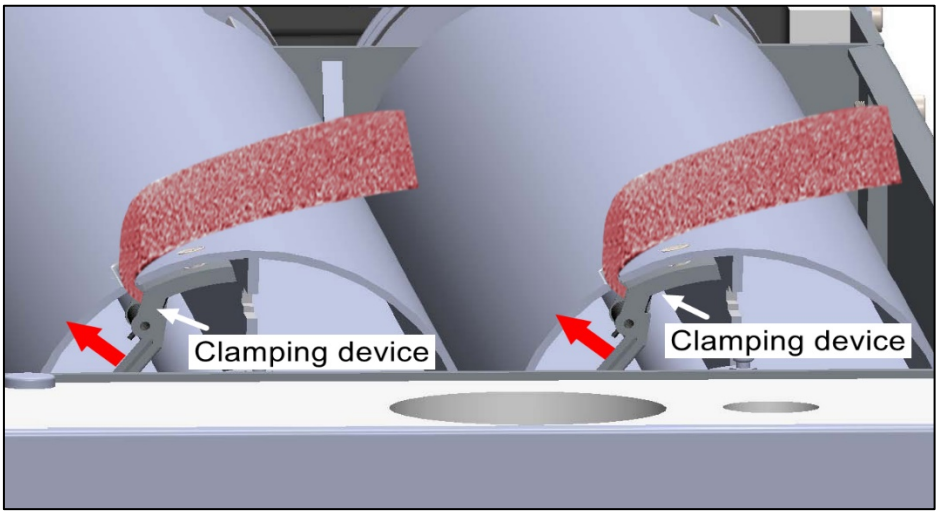


When fabricating a replacement sandpaper strip from bulk rolls, either use the existing strip as a template or refer to the dimensioning information.

The proper installation of the sandpaper strip on the drum is essential to ensure good sanding results and prevent the sandpaper from coming loose or tearing during operation.

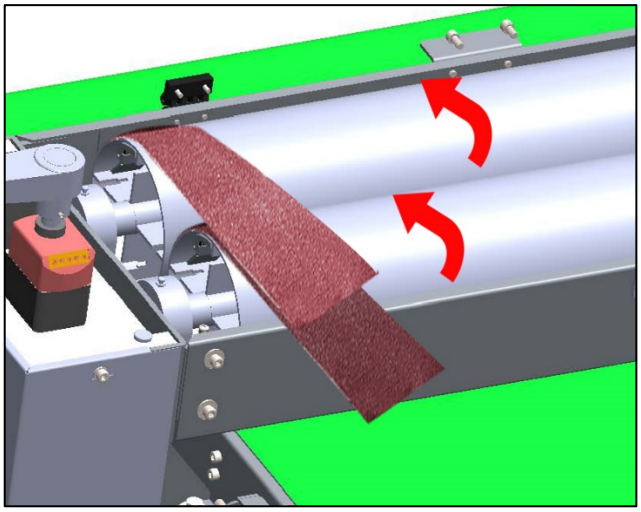
To install the sandpaper strip:

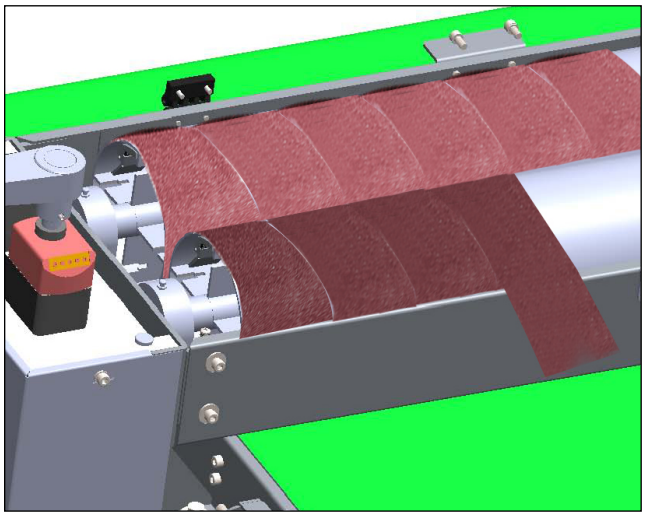
1. DISCONNECT SANDER FROM POWER!
2. Open the dust collection hood, then swing it up to gain access to the sanding drum.
3. Use the clamping device to clamp the end of the sand belt. The side of the sand belt should be parallel to the side of the roll, and the distance is 5MM.
4. Release the clamping device to hold the strip in place, then tug on it to make sure it is secure.



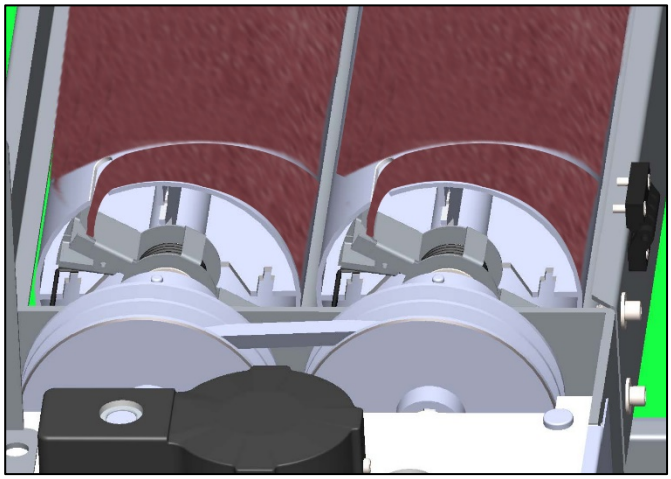
5. While keeping reasonable tension on the strip with one hand, roll the drum away from you with the other hand to wrap the strip onto the drum.

IMPORTANT: When wrapping the strip onto the drum, a minimum 1⁄8" gap between the edges may be necessary, but do not overlap. Additionally, make sure that the strip remains tight without any slack. DO NOT overlap the sandpaper. The sandpaper should be flush or slightly gapped in between.



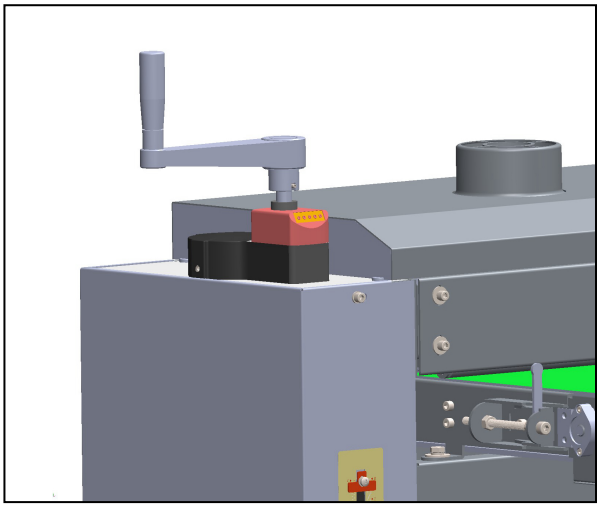


9. To secure the right end of the strip, move the clamping device forward by pressing against the spring lever until you can insert the strip between clamp and the spring lever.
10. Check to make sure the sandpaper strip is tight against the drum, the edges are not more than 1⁄8" apart, and they are not overlapped.
11. Close and secure the dust collection hood before connecting the sander to power.



4.6 Depth of cut

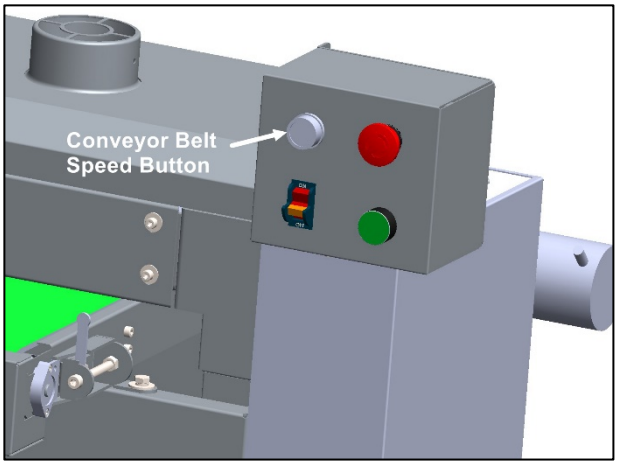
The correct depth of cut when surface sanding depends on many variables, such as the hardness of the wood, the width of the workpiece, and the feed rate.
Generally, a 1⁄4 turn of the elevation handwheel (1mm depth of cut) per pass is acceptable for coarser grits or softer woods. A 1⁄8 turn of the handwheel (0.5mm depth of cut) is recommended for finer grits or harder woods. However, use your best judgement to produce good sanding results for your operation.



IMPORTANT: Keep in mind that, although the thickness of the workpiece is reduced during sanding, this process is not a replacement for thickness planning, which should be done with a planer or other acceptable tool/machine before beginning the sanding process.
To adjust the depth of cut:
Rotate the crank handle wheel to lower and upper the worktable.

4.7 Feed rate

Setting the proper feed rate is a matter of experience and good judgement. When selecting the feed rate for the operation, consider variables such as the hardness and condition of the wood, the sandpaper grit being used, the finish desired, etc. As a guideline, wide or hard workpieces, or using finer grit sandpaper will require a slower feed rate.
The goal in setting the correct feed rate is to produce the desired results for the operation without burning the workpiece.



Using too fast of a feed rate may exceed the sanding motor capacity and trip the motor or power supply circuit breaker. Using too slow of a feed rate may burn the surface of the workpiece.
To adjust the conveyor belt feed rate, rotate the conveyor variable feed rate knob.
Note: The ON/OFF switch must be in the ON position to enable the conveyor motor to run.

4.8 Sanding tips

Follow these precautions to ensure safe sanding operation and quality results:

▲ Replace the sandpaper with a higher grit to achieve a finer finish.

▲ If possible, feed the workpiece at a 60 angle to the sanding drum. This will provide for more effective material removal, less loading and more even wear of the sandpaper, and lighter load on the motors. On the last finishing passes, feed the workpiece so that the majority of the grain is perpendicular to the sanding drum.

▲ Extend the life of the sandpaper by regularly using a PRO-STICK sanding pad.

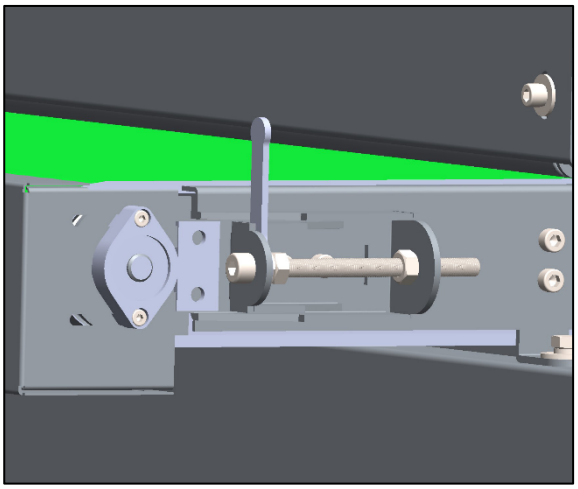
▲ Reduce snipe when sanding more than one board of the same thickness by feeding them into the sander with the front end of the second board touching the back end of the first board.

▲ DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury. Edge sanding boards also can cause damage to the conveyor belt and sandpaper.

▲ When sanding workpieces with a bow or crown, place the high point up (prevents the workpiece from rocking) and take very light passes.

4.9 Conveyor Belt Tension & Tracking

The conveyor belt tension and tracking must be properly adjusted to ensure that the workpiece correctly and safely passes underneath the sanding drum and that the conveyor belt does not become damaged during operation. If the conveyor belt slips on the rollers then the belt tension needs to be increased. If the conveyor belt moves to one side or the other when it is running, then the belt tracking needs to be adjusted.

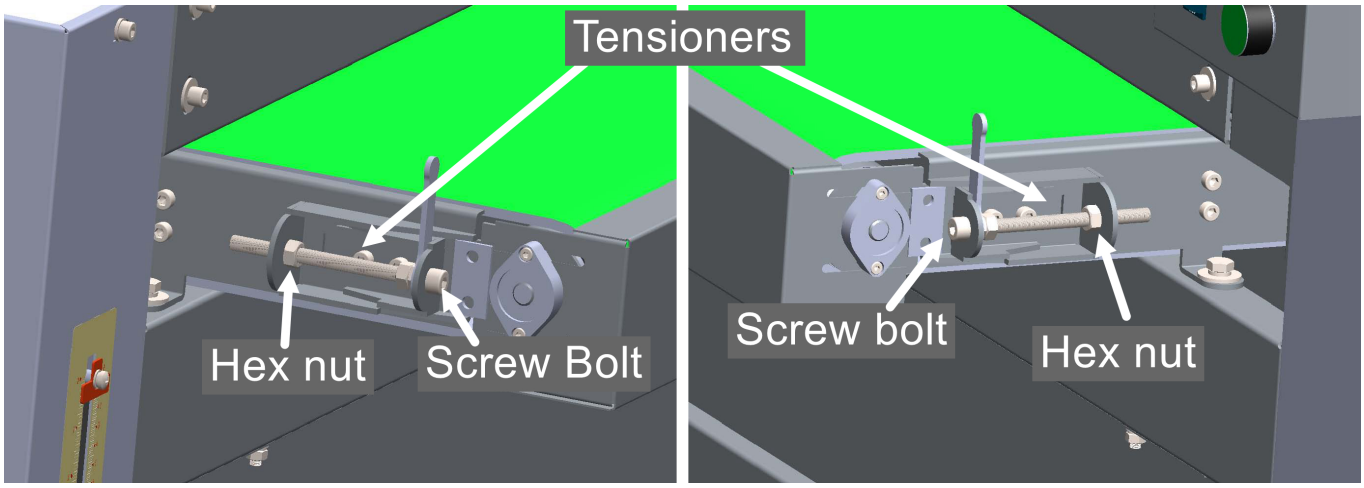


4.9.1 Belt tension

Make sure the conveyor belt is centered on the rollers.

— If it is not, release the belt tension equally on both sides of the belt. This is done by holding the hex nut still while rotating the hexagon socket bolt counterclockwise until you can move the belt from side-to-side with your hand. Then, center the belt on the rollers.

— If the belt slips during operation, rotate the screws clockwise in small amounts until the belt no longer slips on the rollers.



4.9.2 Belt tracking

1. Run the conveyor belt at high speed and note if it tracks to one side or the other. This make take a couple of minutes to show up.

Note: To avoid damaging the belt, do not allow the belt to track off the rollers.

▲ If the conveyor belt does not track to one side or the other, no further adjustments are necessary.

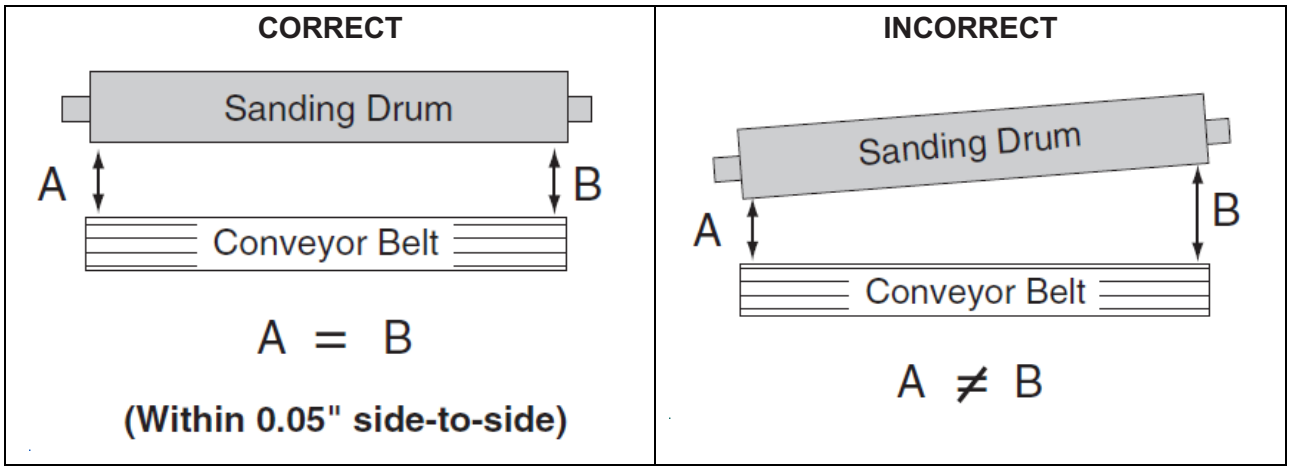
Note: In the next step, you may have to wait for several minutes to notice a change in tracking.

2. Rotate the tensioner screw clockwise on the side the belt is tracking toward until the belt moves to the center of the rollers, then back off the screw until it stops tracking to the opposite side.

3. Allow the belt to run for several minutes to make sure it is tracking properly. If necessary, repeat this procedure until the belt is properly tracking.

4.10 Conveyor belt to drum alignment

To ensure good sanding results, the conveyor belt and sanding drum must be parallel with each other from side to side. Otherwise, more material will be removed from one side of the workpiece than the other.



5. Maintenance

Failure to routinely inspect your drum sander for damage and wear could result in unsatisfactory work results, premature component or machinery failure, or operator injury. We recommend you create a checklist for routine inspection and maintenance.

Remember to always disconnect the drum sander from its power source before attempting to inspect, adjust, or repair this machine!

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

5.1 Daily Check

Daily Check

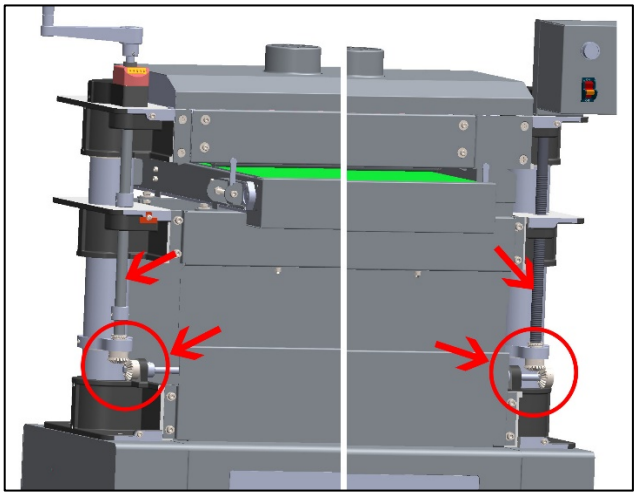
- ▲ Loose mounting bolts.
- ▲ Damaged, worn, or loaded sandpaper.
- ▲ Worn or damaged wires or switches.
- ▲ Worn or damaged conveyor belt.
- ▲ Any other unsafe condition.

5.2 Cleaning

Cleaning the drum sander is relatively easy. From time to time vacuum wood dust off of the internal components, especially the motor.

5.3 Lubrication

Moving parts such as lead screw, gears should be lubricated periodically with a light machine oil.



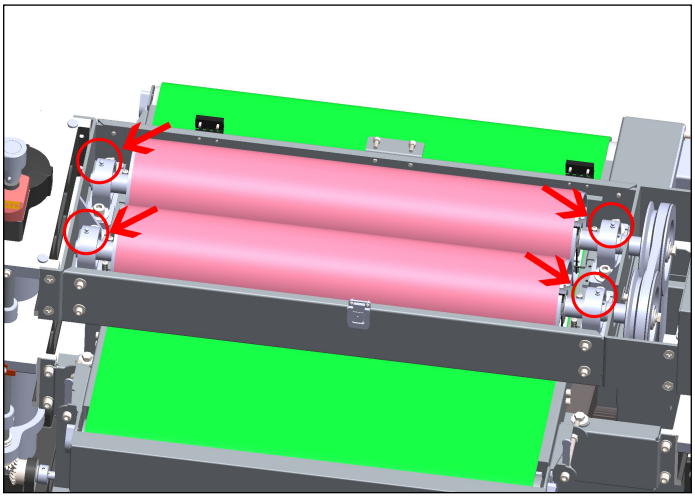
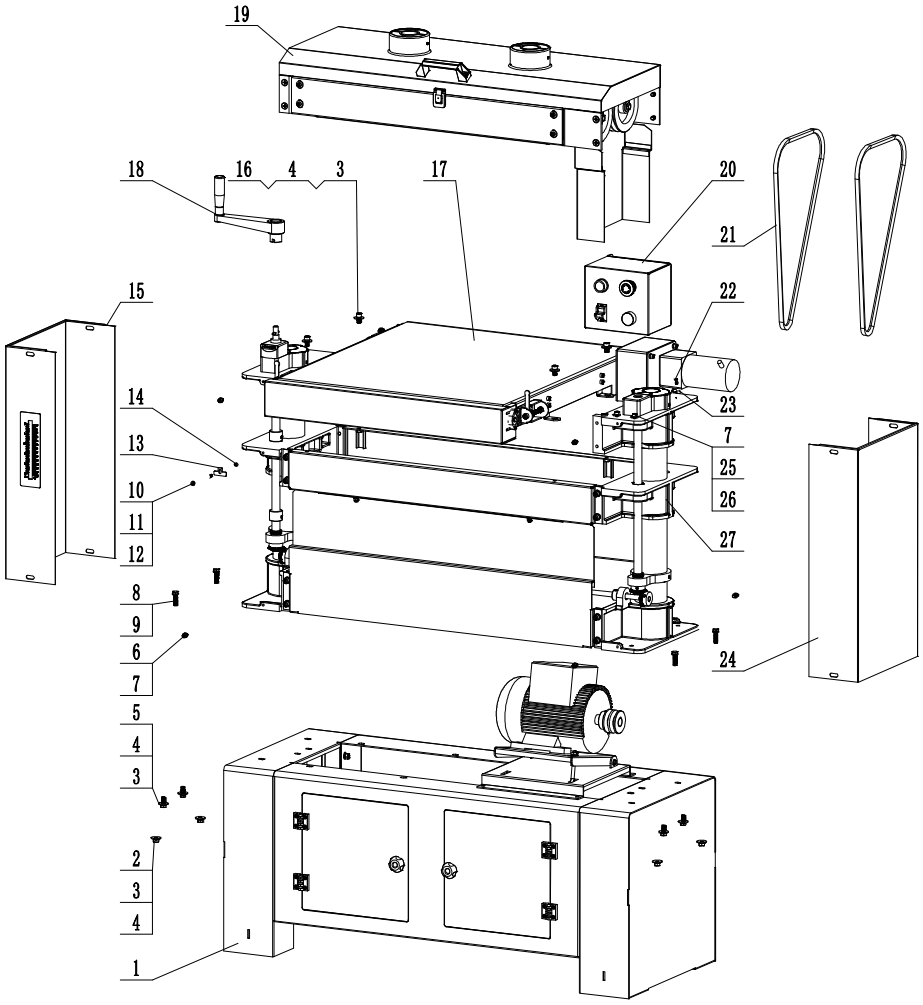


Table Lift Lead Screws and Gears: Should be cleaned with mineral spirits and painted with lithium grease every six months. Then, move the table up or down to spread the grease thoroughly over the threads. Do not over lubricate.

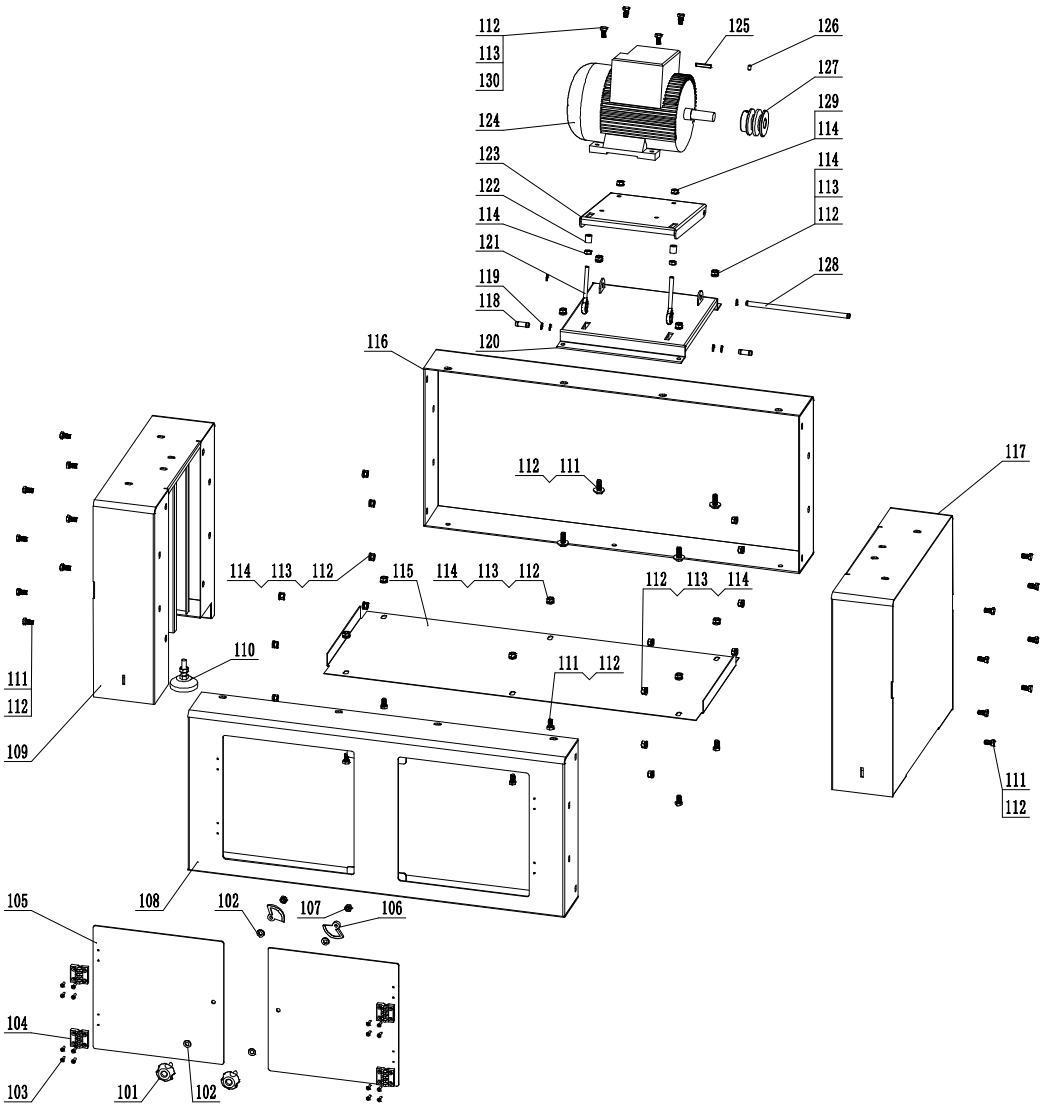
Pillow Bearing: Better be lubricated every 20 hours of operation. Use a high-quality, lithium based grease. A grease fitting is located on the top of each pillow bearing. Give only one to two pumps of the grease gun. Too much grease can pop seals out.

6. Diagram and Part list



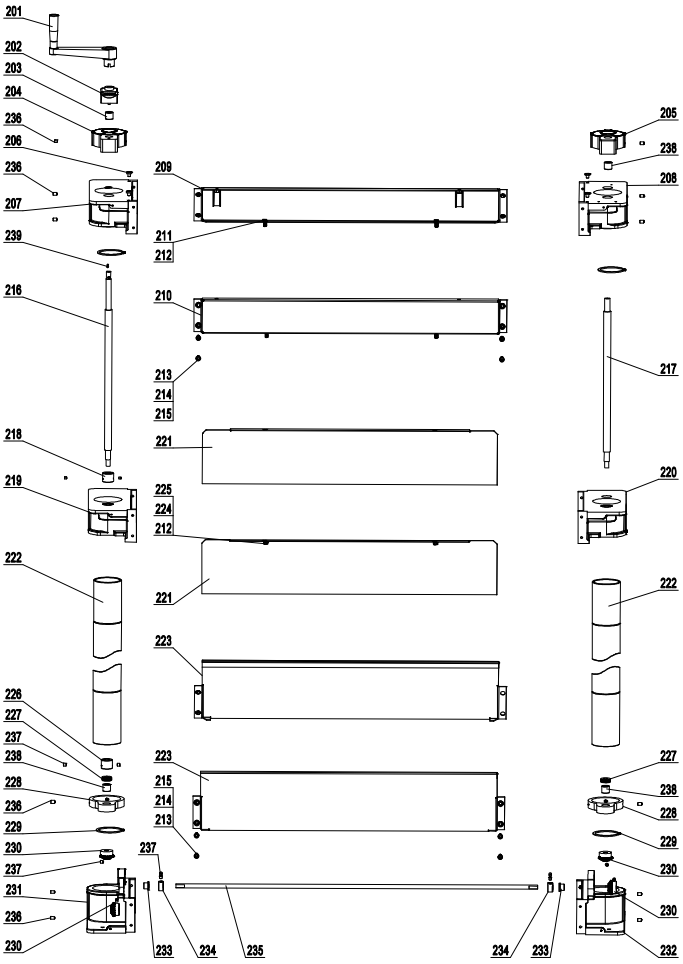
Part No.	Description	Qty
1	Machine base	1
2	Hex nut	4
3	Spring washer	12
4	Large gasket	12
5	Hexagonal head bolt	4
6	Hexagonal socket head screw	8
7	Large gasket	10
8	Hexagonal head bolt	4
9	Flat washer	4
10	Cross groove pan head screw	1
11	Spring washer	1
12	Flat washer	1
13	Pointer	1
14	Positioning sleeve	1

Part No.	Description	Qty
15	Protective cover left	1
16	Hexagonal socket head screw	4
17	Worktable assembly	1
18	Crank handle	1
19	Sand roller assembly	1
20	Control switch panel assembly	1
21	A-type triangle belt	2
22	Cross groove pan head screw	2
23	Cable ramp	1
24	Protective cover right-2	1
25	Hexagonal socket head screw	2
26	Spring washer	2
27	Vertical beam component	1
28	Countersunk head screw M8X14	4



Part No.	Description	Qty
101	Locking handle	2
102	Flat washer	6
103	Cross countersunk head screw	16
104	Hinge	4
105	Cover plate	2
106	Locking block	2
107	Locking nut	2
108	Front side plate	1
109	Left plate assembly	1
110	Adjustable footing	1
111	Hexagonal head bolt	26
112	Flat washer	52
113	Spring washer	26
114	Hex nut	30
115	Bottom plate	1

Part No.	Description	Qty
116	Back side plate	1
117	Right plate assembly	1
118	Pin shaft	2
119	Elastic collar for shaft	6
120	Motor seat assembly A	1
121	Screw	2
122	Bush	2
123	Motor seat assembly B	1
124	Motor 3000W	1
125	Key 5x30	1
126	Internal hexagon screw	1
127	Driven wheel	1
128	Connecting shaft	1
129	Large gasket	2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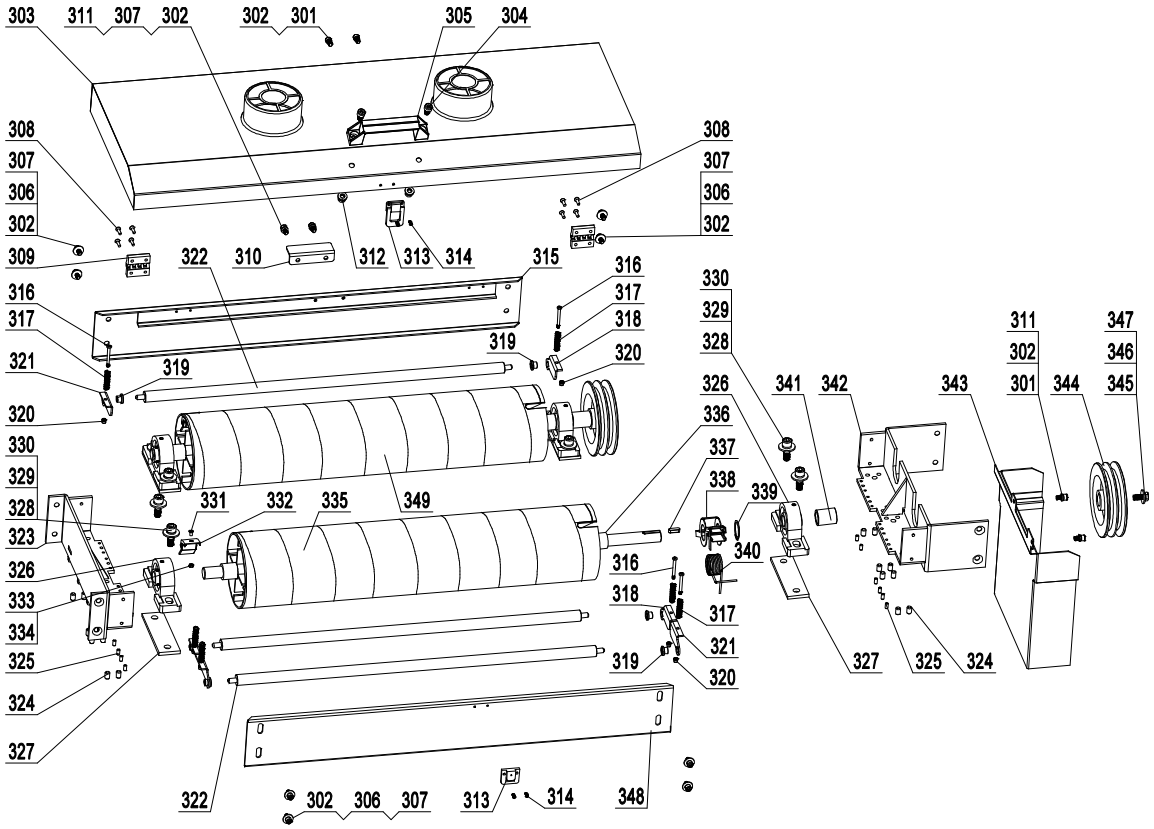
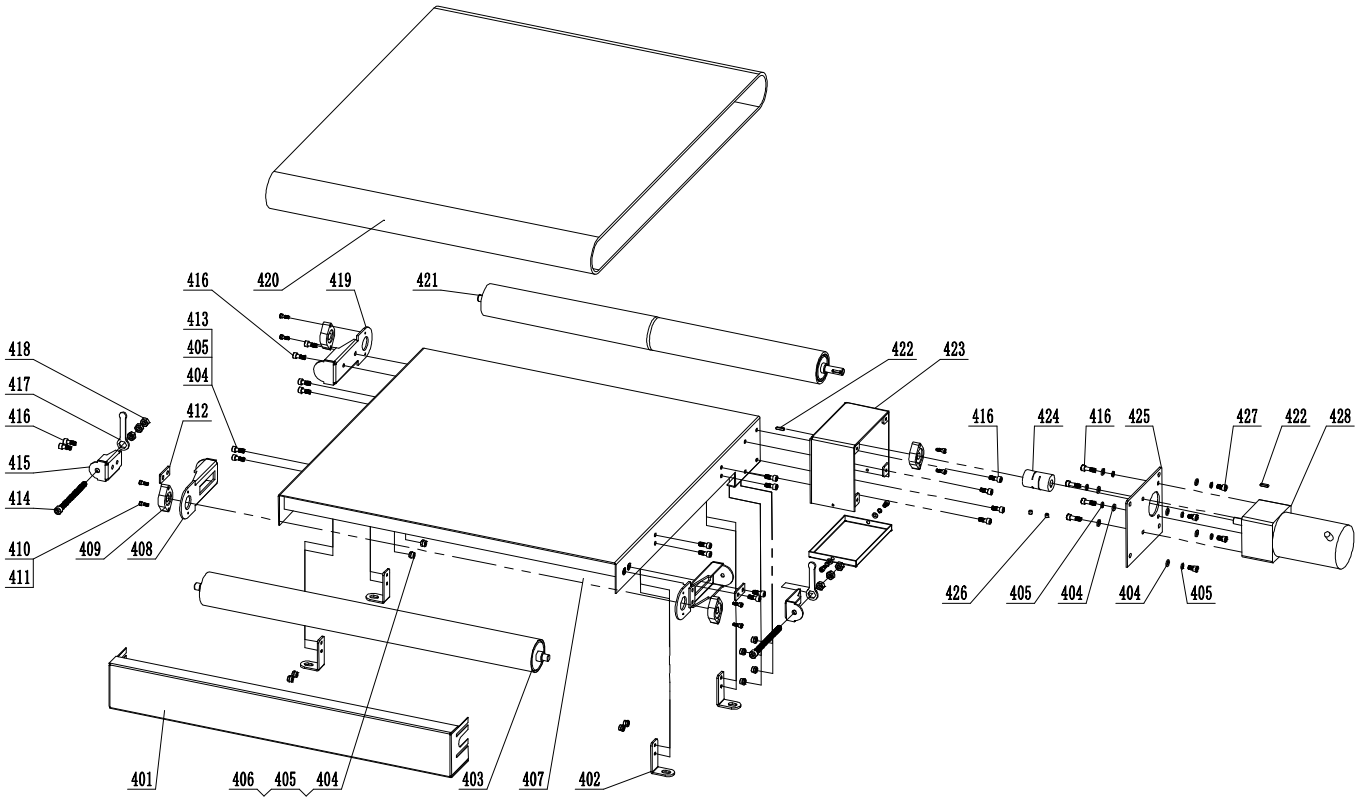
Part No.	Description	Qty
201	Crank handle	1
202	Digital Depth display	1
203	Lead screw shaft sleeve	1
204	Cover	1
205	Cover	1
206	T-shaped rubber plug	4
207	Upper fixed seat	1
208	Upper fixed base	1
209	Rear connection plate	1
210	Front connecting plate	1
211	Hexagonal socket head screw	4
212	Flat washer	8
213	Hexagonal socket head screw	16
214	Spring washer	16
215	Flat washer	16
216	Lifting lead screw	1
217	Lifting lead screw	1
218	Stop nut	2
219	Sliding seat	1
	Trapezoidal Nut	1
	Hexagonal flat end set screw	2

Part No.	Description	Qty
220	Sliding seat	1
	Trapezoidal Nut	1
	Hexagonal flat end set screw	2
221	Baffle	2
222	Column	2
223	Lower connection plate	2
224	Spring washer	4
225	Hex nut	4
226	Stop nut	2
227	Thrust ball bearing	2
228	Fixed disk	2
229	Elastic collar ring for shaft	4
230	Cone gear	4
231	Base	1
232	Base	1
233	Shaft sleeve	2
234	Stop sleeve	2
235	Spindle	1
236	Hexagonal flat end set screw	20
237	Hexagonal flat end set screw	12
238	Lead screw shaft sleeve	3
239	Elastic cylindrical pin	1



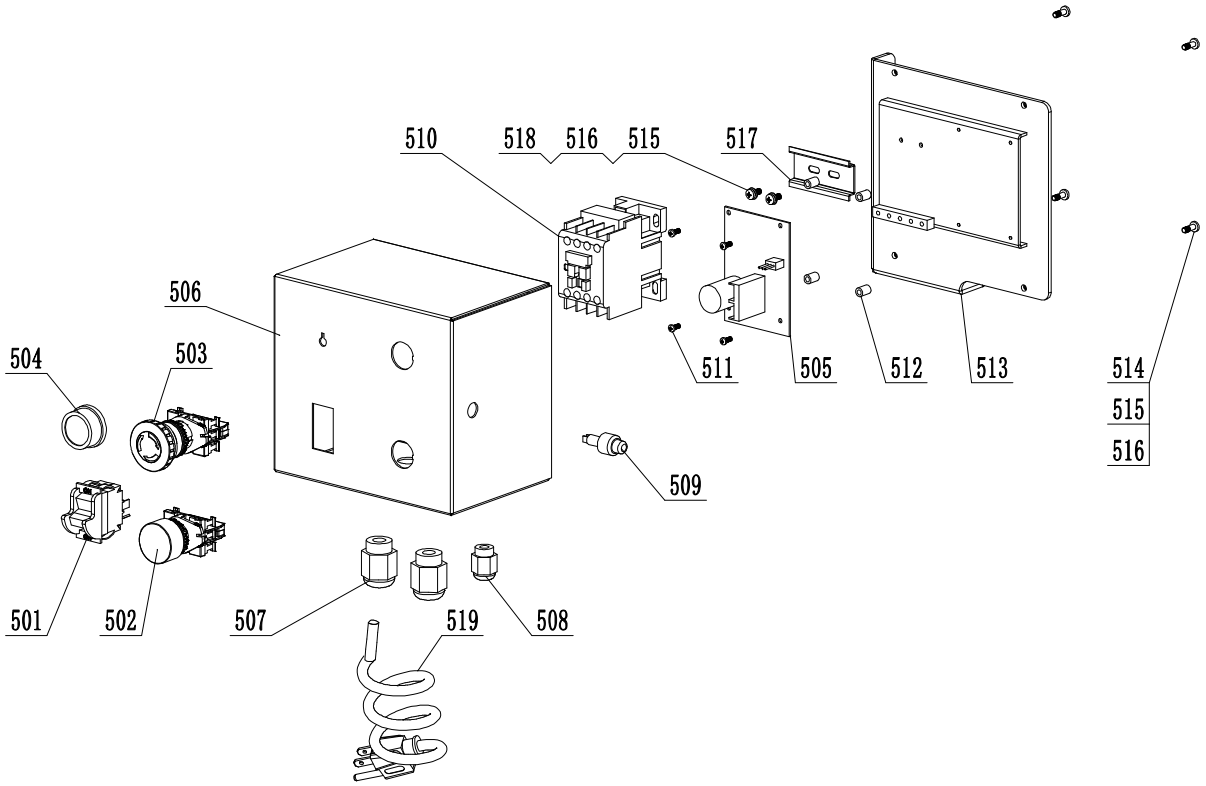
Part No.	Description	Qty
301	Hexagonal socket head screw	4
302	Spring washer	14
303	Box cover assembly	1
304	Hexagonal socket head screw	2
305	Square handle	1
306	Large gasket	8
307	Hexagonal socket head screw	10
308	Cross head screw	8
309	Hinge	2
310	Support plate	1
311	Flat washer	4
312	hexagonal lock nut	2
313	Latch	1
314	Cross groove pan head screw	4
315	Rear plate	1
316	Cross groove pan head screw	6
317	Pressure spring	6
318	Left pressure roller base	3
319	Pressure roller sleeve	6
320	Hexagonal lock nut	6
321	Right pressure roller base	3
322	Pressure roller	3
323	Front fixed plate	1
324	Hexagonal flat end set screw	16
325	Hexagonal flat end set screw	12

Part No.	Description	Qty
326	Bearing	4
327	Base plate	4
328	Hexagonal socket head screw	8
329	Spring washer	8
330	Gasket	8
331	Cross head screw	2
332	Sand belt clamp A	2
333	Spring washer	2
334	Hex nut	2
335	Sand belt	1
336	Roller	2
337	Flat key	2
338	Sand belt clamp B	2
339	Elastic collar ring for shaft	2
340	Belt clamp B torsion spring	2
341	Positioning sleeve	2
342	Rear fixed plate	1
343	Belt cover	1
344	Driven wheel	2
345	Hexagonal head bolt	2
346	Spring washer	2
347	Gasket	2
348	Front plate	1
349	Sand belt	1



Part No.	Description	Qty
401	Driven wheel cover	1
402	Worktable support plate	4
403	Driven shaft	1
404	Flat washer	26
405	Spring washer	26
406	Hex nut	10
407	Worktable	1
408	Tensioning plate	2
409	Flange bearing seat	4
410	Cross groove pan head screw	8
411	Spring washer	8
412	Tensioning block	2
413	Hexagonal socket head screw	8
414	Hexagonal socket head screw	2

Part No.	Description	Qty
415	Tensioning fixed plate	2
416	Hexagonal socket head screw	14
417	Tensioning wrench	2
418	Hex nut	6
419	Shaft fixing plate	1
420	Conveyor Belt	1
421	Shaft	1
422	Flat key	2
423	Motor cover box	1
424	Coupler	1
425	Motor side cover	1
426	Hexagonal flat end screw	2
427	Hexagonal socket head screw	4
428	DC motor A-110V 120W	1

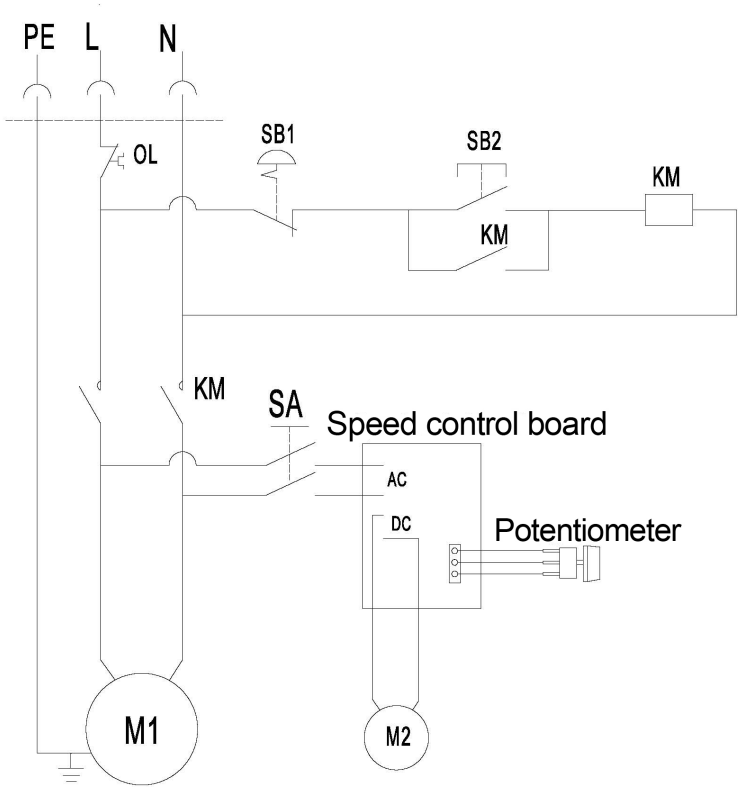


Part No.	Description	Qty
501	Self-locking switch	1
502	Green ON button	1
503	Emgerency switch	1
504	Speed knob	1
505	PCB	1
506	Switch box	1
507	Cable strain relief M20	2
508	Cable strain relief M16	1
509	Circuit protector	1
510	AC contactor	1

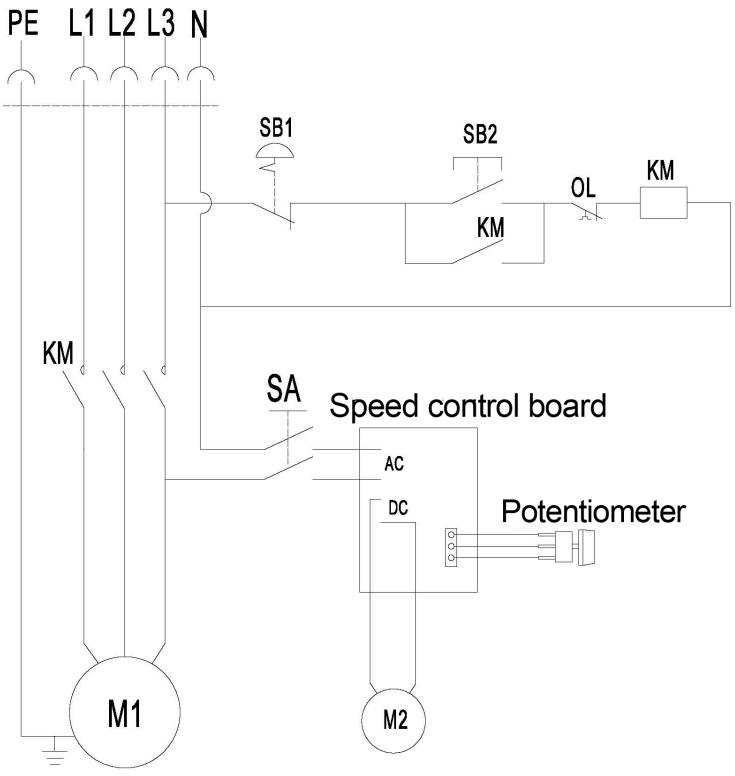
Part No.	Description	Qty
511	Cross groove pan head screw	4
512	Nylon Hexagonal Column M3X7	4
513	Control box plate	1
514	Cross groove pan head screw	4
515	Spring washer	6
516	Flat washer	6
517	Guide rail connection	1
518	Cross groove pan head screw	2
519	Power cable	1

7. Wiring Diagram

230V 50HZ 1PH



400V 50HZ 3PH



Declaration of Conformity

Nationality	
GB	The object of the declaration described is in conformity with the relevant GB/EU legislation.
DE	Der Gegenstand der beschriebenen Erklärung stimmt mit den einschlägigen GB/EU-Rechtsvorschriften überein.
FR	L'objet de la déclaration décrite est conforme à la législation GB/UE pertinente.
IT	L'oggetto della dichiarazione descritta è conforme alla legislazione GB/UE pertinente.
ES	El objeto de la declaración descrita está en conformidad con la legislación GB/UE pertinente.
NL	Het voorwerp van de beschreven verklaring is in overeenstemming met de relevante GB/EU-wetgeving.
DK	Genstanden for den beskrevne erklæring er i overensstemmelse med den relevante GB/EU-lovgivning.
SE	Föremålet för den beskrivna deklarationen överensstämmer med den relevanta GB/EU-lagstiftningen.
CZ	Předmět popsaného prohlášení je v souladu s příslušnými právními předpisy GB/EU.
PL	Przedmiot opisanej deklaracji jest zgodny z odpowiednimi przepisami GB/UE.
POR	O objeto da declaração descrita está em conformidade com a legislação GB/UE relevante.
NOR	Gjenstanden for den beskrevne erklæringen er i samsvar med den relevante GB/EU-lovgivningen.
FI	Määritellyn ilmoituksen kohde on asiaankuuluvan Ison-Britannian/EU: n lainsäädännön mukainen.
IS	Hluturinn í lýsingunni er í samræmi við viðeigandi lög GB/ESB.

Object of the Declaration: Axminster Professional AP640DS Drum Sander 230V 113351

UK:
Supply of Machinery (Safety) Regulations 2008 as amended
Electromagnetic Compatibility Regulations 2016 as amended
Directive 2011/65/EU (RoHS 2)
Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012

EU:
Machinery Directive 2006/42/EC
EMC Directive 2014/35/EU
Directive 2011/65/EU (RoHS 2)
Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012

UK Address:
Newhow Limited.
Trading as Axminster Tools
Weycroft Avenue
Axminster. Devon
EX13 5PH

Standards used or references to the other technical specifications in relation to which conformity is declared:

ISO 19085-8:2018, EN 60204-1:2018+A1:2025

IEC 55014-1:2021, IEC 55014-2:2021, IEC 61000-3-2:2019+A1:2021, 61000-3-3:2013+A1:2019+A2:2021

European Address:
Newhow Limited.
Trading as Axminster Tools
A-201. Haagsche Hof
Parkstraat 83
The Hague
2514 JG
Netherlands

Date: 26/1/2026
Place: Axminster

Charlie Cross
Operations Director