

CAREFULLY READ THE INSTRUCTIONS PROVIDED, OBSERVE THE SIMPLE SAFETY PRECAUTIONS, AND YOU WILL HAVE MANY HOURS OF SATISFACTORY USE FROM YOUR NEW CRAFTSMAN TOOL.

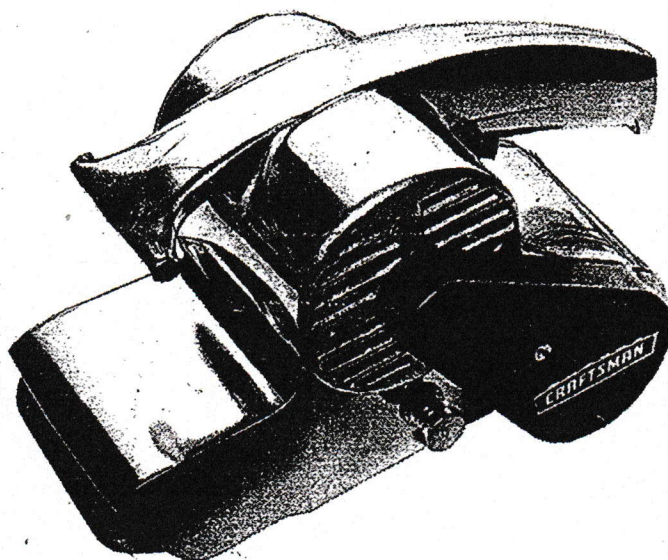
**ASSEMBLY, OPERATING INSTRUCTIONS
AND PARTS LIST FOR**



Reg. Trade Mark

3 INCH BELT SANDER

MODEL NUMBER 315.22420



GUARANTEE

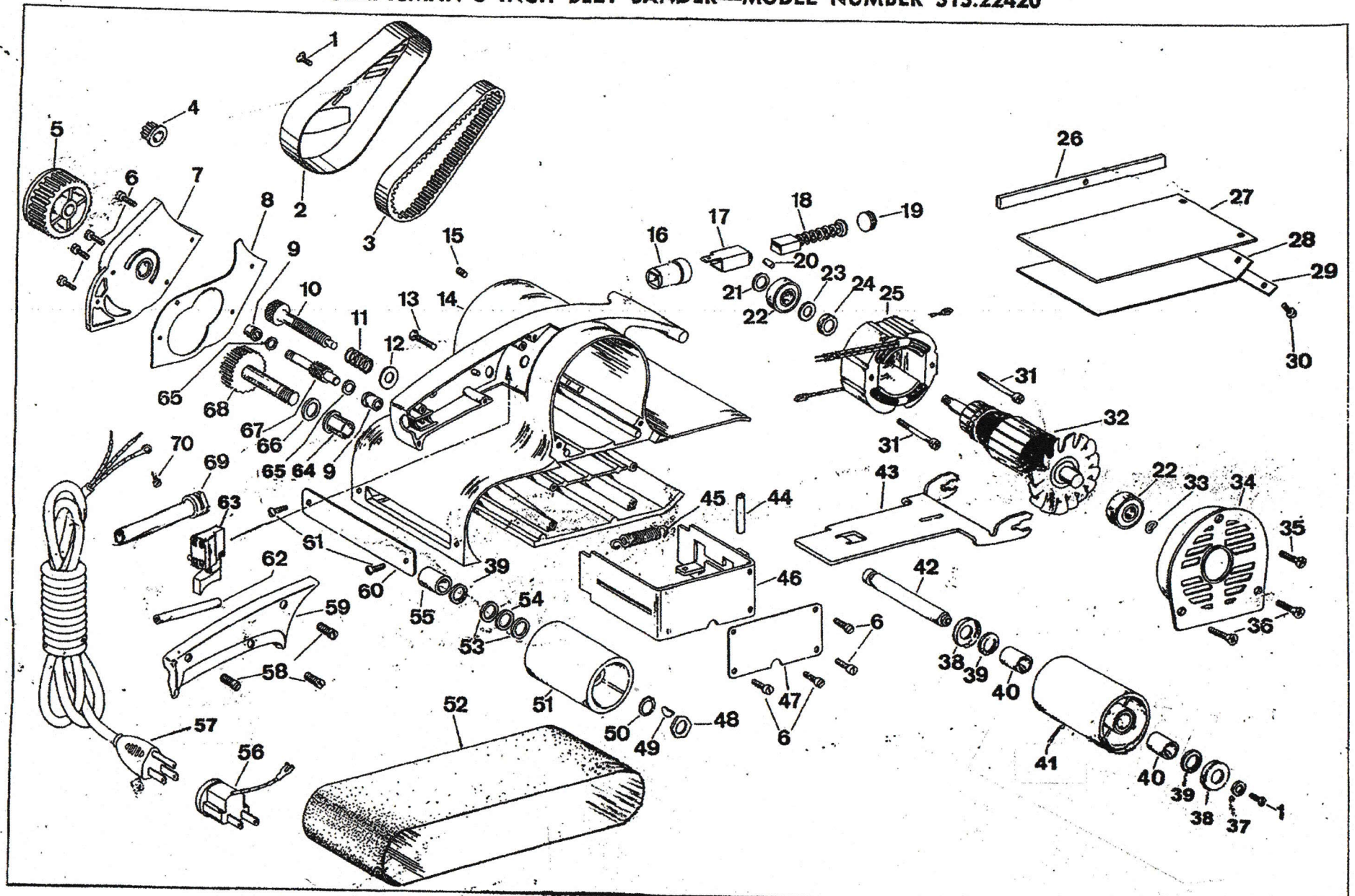
During the first year, we will repair your Craftsman Portable Electric Tool, free of charge, if defective in material or workmanship.

This guarantee service is available by simply returning the tool to any Sears store throughout the United States or Canada.

SEARS, ROEBUCK AND CO. and SIMPSON-SEARS LTD.

**Designed exclusively for and sold only by
SEARS, ROEBUCK AND CO.—Chicago, Illinois 60607 U.S.A.
and SIMPSON-SEARS LIMITED—Toronto**

CRAFTSMAN 3 INCH BELT SANDER—MODEL NUMBER 315.22420



CRAFTSMAN 3 INCH X 21 INCH BELT SANDER -- MODEL NUMBER 315.22420

WHEN ORDERING REPAIR PARTS, ALWAYS GIVE THE FOLLOWING INFORMATION:

1. THE PART NUMBER
2. THE PART NAME
3. THE MODEL NUMBER -- 315.22420
4. THE NAME OF ITEM -- 3" BELT SANDER

DO NOT USE KEY NUMBERS WHEN ORDERING REPAIR PARTS. ALWAYS USE THE PART NUMBER.

PARTS LIST

Key No.	Part No.	Description	Quan.	Key No.	Part No.	Description	Quan.
1	1-703428-10	*Screw (8-32 x 3/8 Fl. Hd.)	2	36	1-703488-807	Screw (8-32 x 7/16 oval hd.)	2
2	3-622872-00	Belt Guard	1	37	1-622862-00	Shaft end Washer	1
3	2-622827-00	Timing Belt	1	38	1-622854-00	Cupped Washer	2
4	2-614251-02	Drive Pulley	1	39	1-622853-00	Felt Washer	3
5	2-614252-03	Driven Pulley	1	40	1-622805-01	Sleeve Bearing (Incl. With Key No. 41)	2
6	1-622140-31	Screw (8-32 x 3/8 Fl. Hd.)	8	41	2-622804-02	Idler Pulley (Includes Key No. 40)	1
7	3-622899-03	Gear Housing Cover (Incl. 1 Key No. 9)	1	42	2-622840-00	Idler Pulley Shaft	1
8	2-622875-00	Gasket -- Gear Case Cover	1	43	3-622835-00	Idler Pulley Support	1
9	1-622865-01	Flange Bearing	2	44	1-622832-01	Spiral Pin	1
10	2-622828-00	Adjusting Screw	1	45	1-622922-00	Spring	1
11	1-622923-00	Spring	1	46	3-622831-00	Idler Pulley Support Bracket	1
12	1-621721-02	Washer	1	47	2-615809-01	Nameplate	1
13	1-614661-02	*Screw (8-32 x 3/4 Fl. Hd.)	1	48	1-622206-06	Nut	1
14	4-615806-04	Housing (Includes 1 ea. Key No. 9, Key Nos. 55, 64, 60 & 61)	1	49	3-616452-03	Hi-Pro Key	1
15	1-930687-06	*Set Screw (8-32 x 1/4 Hex Soc. Headless)	2	50	1-620389-03	Retaining Ring	1
16	2-623436-01	Brush Holder	2	51	2-614291-01	Pulley	1
17	2-730373-00	Brush Tube	2	52	*	Sanding Belt (3" x 21")	3
18	2-730352-01	Brush Assembly	2	53	1-706239-813	Thrust Washer	2
19	1-614008-01	Brush Cap	2	54	1-622205-05	Thrust Washer	1
20	1-623019-01	Bearing Plug	1	55	1-614287-01	Sleeve Bearing (Incl. With Key No. 14)	1
21	1-614210-01	Washer	1	56	1-706875-00	Grounding Adapter (Not Supplied With Canadian Tools)	1
22	1-621221-01	Ball Bearing	2	57	2-622897-01	Cord	1
23	1-614210-02	Washer	1	58	1-622140-31	Screw (8-32 x 3/8 Fil. Hd.)	3
24	1-614294-01	Washer Insulation	1	59	3-615805-712	Handle Cover	1
25	3-615810-01	Field Core	1	60	2-621877-00	Vacuum Opening Cover	1
26	1-622813-00	Striker Bar	1	61	1-620369-02	*Screw (10-32 x 3/8 Rd. Hd.)	2
27	2-622823-00	Pad Backing	1	62	1-622286-01	Insulating Tubing	1
28	2-622822-00	Sanding Shoe Pad	1	63	2-623247-00	Switch	1
29	1-622814-00	Plate	1	64	1-714043-03	Flange Bearing (Incl. With Key No. 14)	1
30	2-737983-03	Screw (8-32 x 3/8 Pan Hd.)	2	65	1-706382-805	Washer	2
31	1-940038-09	Screw (8-32 x 1-1/4 Fil. Hd.)	2	66	1-706239-807	Thrust Washer	1
32	2-615814-01	Armature	1	67	3-622817-00	Shaft	1
33	1-621463-02	Loading Spring	1	68	2-614289-01	Gear and Shaft	1
34	3-614292-714	Motor Housing Cover	1	69	2-613651-01	Bend Relief	1
35	1-703488-806	Screw (8-32 x 3 oval hd.)	1	70	1-930993-01	Screw (6-32 x 5/16 Pan. Hd. T. C.)	1
					EN 507	Instruction Sheet	

*Standard Hardware Item -- May Be Purchased Locally.

**Sanding Belts in Assorted Grits for Sanding Both Wood and Metal May Be Obtained From Your Nearest Sears Retail or Catalog Order Store.

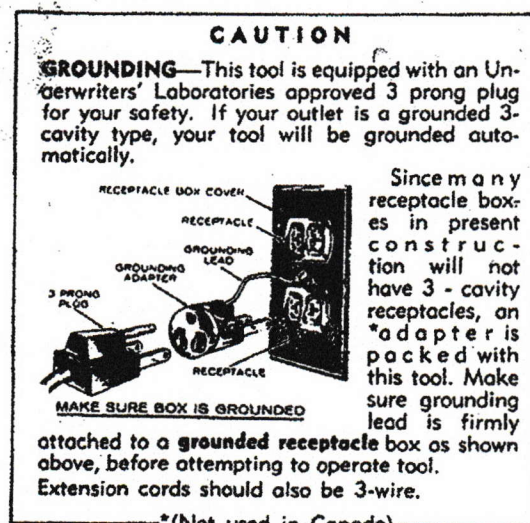


CRAFTSMAN 3 INCH BELT SANDER—MODEL NUMBER 315.22420

CUSTOMER DO'S AND DON'TS

1. **DO** be sure that the voltage of the power supply agrees with the name plate marking on the sander.
2. **DO** be sure tool is properly grounded. (See "Grounding").
3. **DO** replace both brushes when either is worn to about $\frac{1}{4}$ " in length.
4. **DO** keep good sanding belt on tool. A wornout belt will not produce satisfactory results.
5. **DO** keep motor air vents and tracking mechanism clean. Sanding dust may be blown out with an air jet.
6. **DO** keep drive belt and sprockets clean and free from grease and oil.
7. **DO** lubricate Sander according to instructions. (See "Lubrication").

CAUTION: When Electric Tools are used on fiberglass boats, sports cars, etc. it has been found that they are subject to accelerated wear and possible premature failure as the fiberglass chips and grindings are highly abrasive to Bearings, Brushes, Commutator, etc. Consequently it is not recommended that this tool be used for continuous production work on any fiberglass material. During any use on fiberglass it is extremely important that the tool is cleaned frequently by blowing with an air jet.



1. **DON'T** leave the power cord connected to the power supply when changing belts or doing any maintenance work on tool.
2. **DON'T** use two wire extension cord.
3. **DON'T** overload tool so that it slows down to the point of over heating.
4. **DON'T** use Sander without adjusting belt tracking mechanism.
5. **DON'T** pick the tool up by the power cord.
6. **DON'T** jerk the power cord to remove the plug from the socket.
7. **DON'T** plug or cover air vents to keep dust from flying. Vents must be kept open to keep motor cool.

SWITCH—The Trigger switch controls "ON-OFF" operation of this Sander. This trigger switch may be locked in the "ON" position by depressing the lock button when switch is in the "ON" position. Further trigger depression disengages locking mechanism.

BRUSH REPLACEMENT

IMPORTANT — (See Fig. 1) Be sure the power cord is disconnected from the power supply. Periodically check the brushes for wear and replace both brushes when either is about $\frac{1}{4}$ inch in length. To check the length of brushes, they must be removed from the tool. (See instructions below): Replacement of these relatively inexpensive parts, when necessary, will keep your tool operating more efficiently and prolong the life of the motor.

To replace carbon brushes (Key No. 18), unscrew brush cap (Key No. 19) and remove old brush and spring. Replace both brushes making sure, when inserting, that curvature of brush matches curvature of the surface of the motor to which it is mated. Make sure that the brushes move freely in the holder.

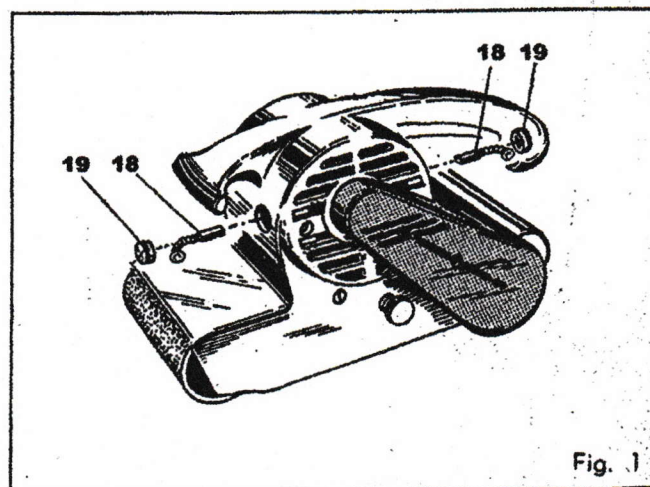


Fig. 1

EXTENSION CORDS—The use of any Extension Cord will cause some loss of power. To keep this to a minimum and to prevent overheating and motor burn-out, use the table below to determine the MINIMUM wire size (A.W.G.) Extension Cord. Cords should be 3-wire grounded.

Extension Cord Length	Wire Size A.W.G.
25- 50 Feet	16
50- 75 Feet	14
75-100 Feet	12
100-200 Feet	10

CRAFTSMAN

CRAFTSMAN 3 INCH BELT SANDER—MODEL NUMBER 315.22420

FOR YOUR SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN USING YOUR CRAFTSMAN BELT SANDER

THE OPERATION OF ANY POWER TOOL CAN RESULT IN FOREIGN OBJECTS BEING THROWN INTO THE EYES, WHICH CAN RESULT IN SEVERE EYE DAMAGE. ALWAYS WEAR SAFETY GLASSES OR EYE SHIELDS BEFORE COMMENCING POWER TOOL OPERATION. WE RECOMMEND WIDE VISION SAFETY MASK FOR USE OVER SPECTACLES, OR STANDARD SAFETY GLASSES . . . AVAILABLE AT SEARS RETAIL OR CATALOG STORES.

TO SAND—Clamp or otherwise secure the work to prevent it moving under the Sander. With Sander off work, pull the switch to the on position and when the motor reaches its maximum speed, lower the Sander on the work with a slight forward motion. Using the main handle to control the Sander and the front handle only to guide it, move it slowly over the work. Allowing the Sander to remain in one place will result in an uneven surface. The Sander was designed to provide the proper weight on the sand belt and extra pressure will only result in uneven work, slow cutting from slow belt speed, clogged belts and possible motor burn-out.

Use the proper belt when heavy cutting is desired, not heavy pressure. The importance of this cannot be over-emphasized, the weight has been built into the tool to give the most efficient pressure at the proper location.

LUBRICATION—(See Fig. 2) Before beginning operation and after four (4) hours of continuous use or after eight (8) hours of intermittent use, this Sander should be lubricated with good quality *machine oil. Remove the flat head screw and washer marked (Oil) from the front pulley shaft and put a few drops of oil in the screw hole.

* This oil can be purchased from your local Sears Retail Store or Catalog Order House.

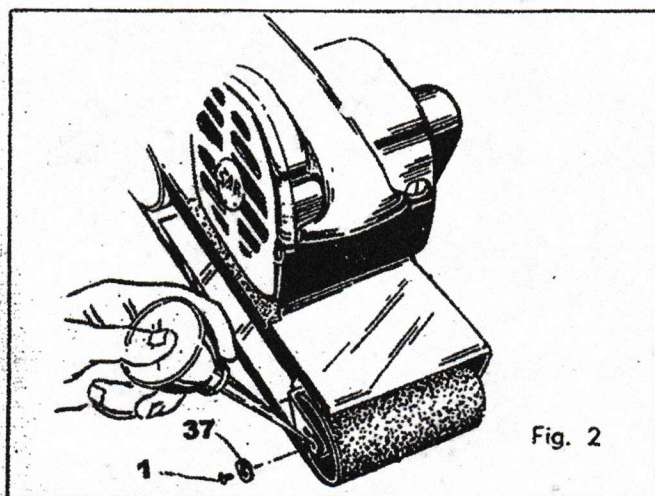
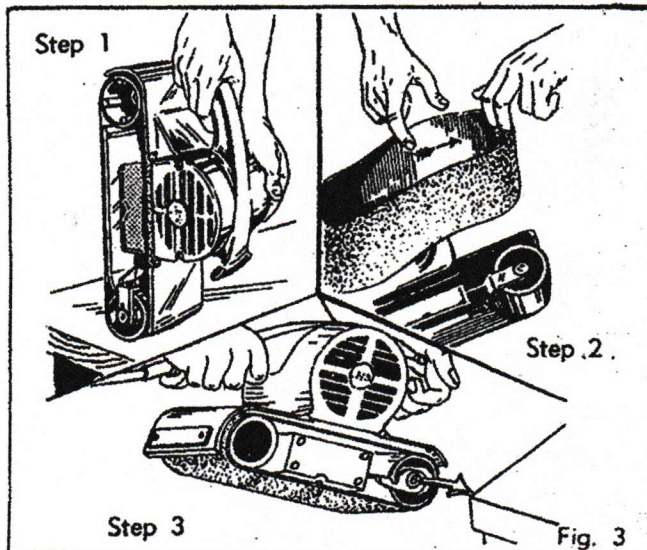


Fig. 2



CHANGING BELTS—(See Fig 3) Disconnect the power supply cord from the receptacle before changing belts.

Step 1—Loosen belt by pushing the front pulley squarely against the top or edge of the bench. When the pulley is pushed back it will lock in that position allowing slack in the belt so it may be easily removed.

Step 2—Install new belt, making sure that arrows inside of belt is pointing in the direction of rotation which is clockwise when looking into the open side of sander.

Step 3—To put tension on the belt, strike the front pulley on the edge of the workbench or table as illustrated or place a piece of wood over pulley support and strike with mallet or press downward with palm of hand. Adjust the belt for correct running before proceeding to sand.

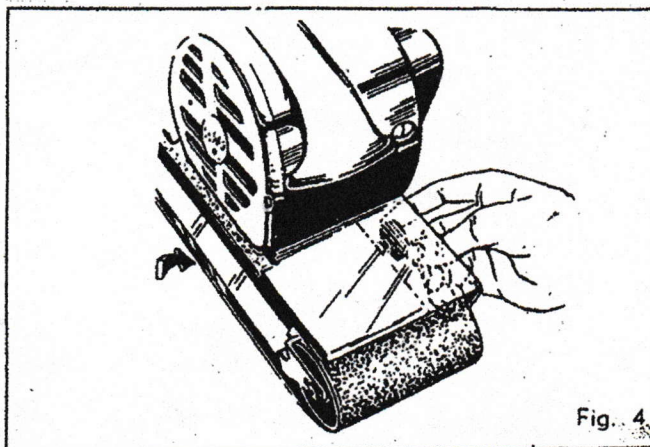


Fig. 4

BELT ADJUSTMENT—(See Fig. 4) With tool running, turn thumb screw located on the left side of the sander until the sanding belt runs even with the edge of the shoe.