



Operating Instructions and Parts Manual Digital Read Out

For JWDS-2244, JWDS-2244OSC, JWDS-2550 JET Drum Sanders



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Unpacking

Open the DRO carton and compare contents with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Report any shipping damage immediately to your distributor and shipping agent.

Read this manual thoroughly for correct assembly procedures.

Shipping contents

- 1 DRO unit – **A**
- 1 Upper mounting bracket – **B**
- 1 Lower mounting bracket – **C**
- 2 Batteries – **D**

- 4 Socket hd cap screws M6x10 – **H1**
- 4 Flat washers M6 – **H2**
- 2 Phillips pan hd screws M3x5 – **H3**
- 1 Socket hd cap screw M5x12 – **H4**
- 1 Flat washer M5 – **H5**
- 1 Hex nut M5 – **H6**

Note: The unit may contain additional hardware for mounting to other machines.

Tools needed for assembly

- 4mm, 5mm hex wrenches
- Adjustable wrench
- Cross-point (Philips) screwdriver

Installation

Refer to Figure 2 to install the DRO unit on the motor shroud of the Drum Sander.

Use the slots on unit and brackets to adjust scale to vertical, then tighten all screws. Make sure digital display slides smoothly along the scale as sander drum is raised and lowered.

User-maintenance

- Check periodically that the screws holding the device to the sander are tight. Perform realignment if needed.
- Before using the device, wipe down the vertical scale with a dry, soft cloth. Do not use cleaning solutions. Do not allow any liquids (such as machine oil) to contact the body of the digital display. Keep the device clean.
- If a functional problem occurs, refer to *Troubleshooting* in Table 1.
- Turn off DRO after use to conserve battery.

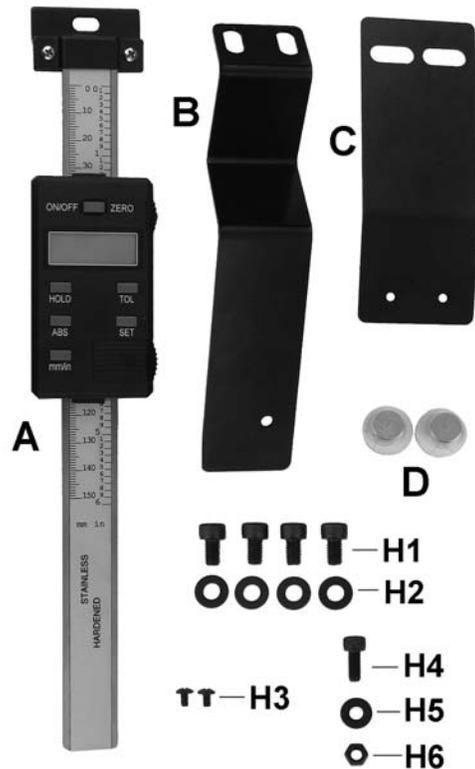


Figure 1: contents

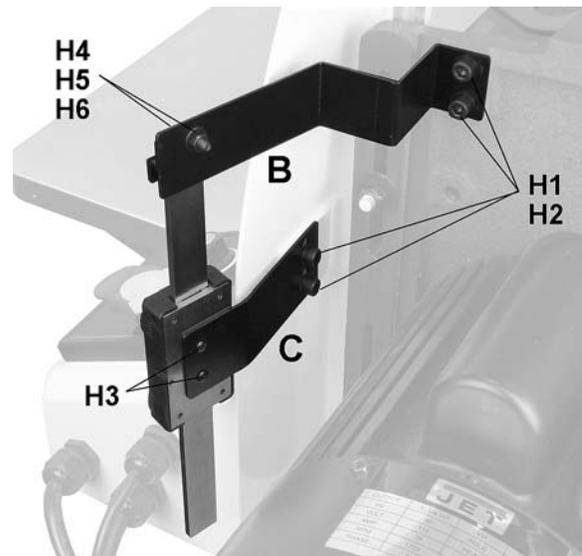


Figure 2: installation

Functions of digital scale

Figure 6 identifies the parts of the digital scale. The button functions are discussed below, followed by a section giving practical examples of how to calibrate your settings, and how these functions can be used for daily sander operations.

This device uses a 1.5-volt battery cell (SR44 or G-13A). If it needs replacing, slide off the battery cover and insert the battery, with the positive pole of the battery facing out.

Note: After replacing a battery, the digital display setting defaults to zero and needs to be reset as described in the *Setting the DRO* section.

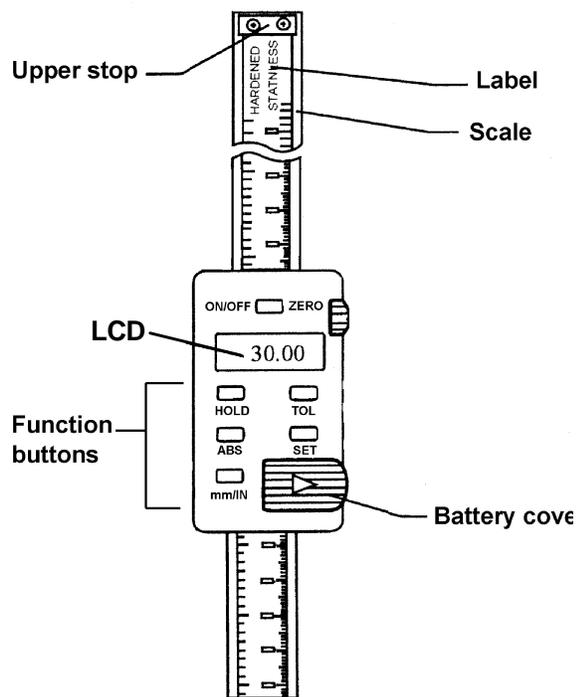


Figure 3

MM/INCH

Pressing this button toggles back and forth between imperial (inches) and metric (mm), and can be done at any time without affecting saved settings.

ON/OFF/ZERO – power and zero-setting

Press *ON/OFF* button no longer than 3 seconds to power on.

Press *ON/OFF* button at least 3 seconds to shut off the digital display.

While in relative mode, press *ON/OFF/ZERO* (no longer than 3 seconds) to set current position as relative zero point.

While in absolute mode, press *ON/OFF/ZERO* (no longer than 3 seconds) to set current position as absolute zero point.

ABS – relative/absolute modes

The device is in absolute mode as soon as power is turned on, and displays absolute zero. Moving the sanding drum up and down begins absolute measurement. Absolute measurement is set based upon the distance from drum to conveyor table, and thus represents the thickness of your board.

Press *ABS* button (no longer than 3 seconds) to switch to relative mode. "INC" will appear on the display. The value shown is in relative mode; it is an incremental position that can be zeroed at any point and determines not the thickness of a board, but how much material will be removed from it. Moving the drum up and down will now display relative measurement until you press *ABS* again to go back to absolute.

IMPORTANT: Always place the digital display in *relative* ("INC") mode before turning it off. If you turn it off while in *absolute* ("ABS") mode, your absolute setting will default to zero.

SET – preset a value

Press *SET*; the indicator will flash "SET". Press and hold the *SET* button and each digit flashes in turn. When the digit you want flashes, release the *SET* button. Press *SET* button once (no longer than 1 second) and that digit will increase by one each time *SET* is pressed. When finished, press and hold *SET* button until indicator "SET" flashes, then press *SET* again (no longer than 1 second). The indicator "SET" disappears and the value you just input is displayed on the screen.

From this point on, any drum movement will be based off this setting. The setting will be kept in the device's memory even when the digital display is turned off, and only needs re-setting after a battery has lost charge and needs replacing.

HOLD

The *Hold* button is used to record a critical setting for reference for the purpose of later resetting to that same position.

For example, if a board becomes jammed during sanding:

1. Press the *HOLD* button. The dimension is "frozen" in the display.
2. Raise the drum and remove the jammed board.
3. Make a mental note of the "frozen" dimension (from Step 1).
4. Press *HOLD* again to return to normal measurements

- Adjust the drum back to its original (frozen display) position.

NOTE: The HOLD button will not permanently save a setting. When the button is pressed a second time, the number disappears.

TOL – tolerance setting

This function is not generally used in sanding operations, but is here explained for reference.

Press TOL, and an up-arrow indicator will appear, as well as a flashing “SET” indicator. You can now change the upper tolerance limit. Hold down the TOL button and each digit flashes in turn. When the digit you want flashes, release the TOL button.

Press TOL button once (no longer than 1 second) and that digit will increase each time TOL is pressed.

When finished, press and hold TOL button until indicator “SET” flashes. While indicator “SET” is flashing, press SET button to change the arrow to the down-arrow indicator. You can now change the lower tolerance limit in the same manner as you changed the upper tolerance limit.

When finished setting the lower tolerance limit, while indicator “SET” is flashing, press SET button (no longer than 1 second). The device is now in tolerance measuring mode. When the up-arrow indicator is displayed, it means the measured value is beyond the upper limit. When the down-arrow indicator is displayed, the measured value is below the lower limit. When the display shows an “OK” indicator, the measured value is within tolerance.

Calibration and operation

Scale alignment

The scale should be in vertical position, and the digital device should slide smoothly along the full length of the scale. Check occasionally that the screws holding the device to the sander are tight. If any realignment of the scale should be needed, slots are provided in the mounting brackets.

Establish absolute zero

One of your first steps should be to “zero” the digital scale in absolute mode. This is equivalent to finding the exact point of contact between the sanding drum (with abrasive installed) and the table.

Open the drum cover and lower the drum while rotating it slightly. When drum contacts conveyor

table and can no longer be rotated, set the DRO to zero.

Note: This setting may need to be repeated if a new abrasive of different thickness is installed.

Using relative measurement mode

The absolute setting, for which you should have already established the zero point, gives the width of your finished board after sanding (distance from drum to table).

The relative measurement mode is useful for measuring only the amount of stock that you wish to remove (i.e., depth of cut), and eliminates having to add or subtract to find the proper setting. It is especially helpful when sanding multiple boards to the same thickness.

Here is an example using relative measurement:

- You have sanded a board at a setting of one inch at absolute measurement. Do not move the drum from this position. You wish to increase the depth of cut on the next run by 0.063 inches.
- Press ABS button to activate relative measurement mode (“INC” will appear on the display).
- Follow the previous instructions on using the SET button function. You would input zeros for all digits, thus establishing zero setting for relative measurement mode.
- After setting relative zero, move the drum down until the digital display reads “.065” inches in relative measurement mode. You can now sand your board with exact results. Of course, you can now toggle back and forth between relative and absolute mode (by pressing ABS button) and get both stock thickness and depth of cut readings at the same time.

More uses

The digital scale has been designed to save the operator time and energy, leading to increased productivity. As you become proficient with the use of the digital readout and explore how to use one function in conjunction with another, you’ll be able to tailor its functions to suit your own work habits and sanding needs.

Troubleshooting DRO unit for JWDS-2244/-2244OSC/-2550 Drum Sanders

Symptom	Possible Cause	Correction
Flashing digits.	Low voltage.	Replace battery.
Locked digits.	Haphazard memory.	Take battery out, wait thirty seconds, then re-insert it.
No display.	Poor contact of battery.	Improve battery contact.
	Low voltage.	Replace battery.
Displays only '0000'.	Short-circuit of zero setting spring and slider signal source.	Remove frame and adjust spring.
Function buttons won't work.	Distortion of springs from over-pressing.	Remove frame and adjust springs.

Table 1

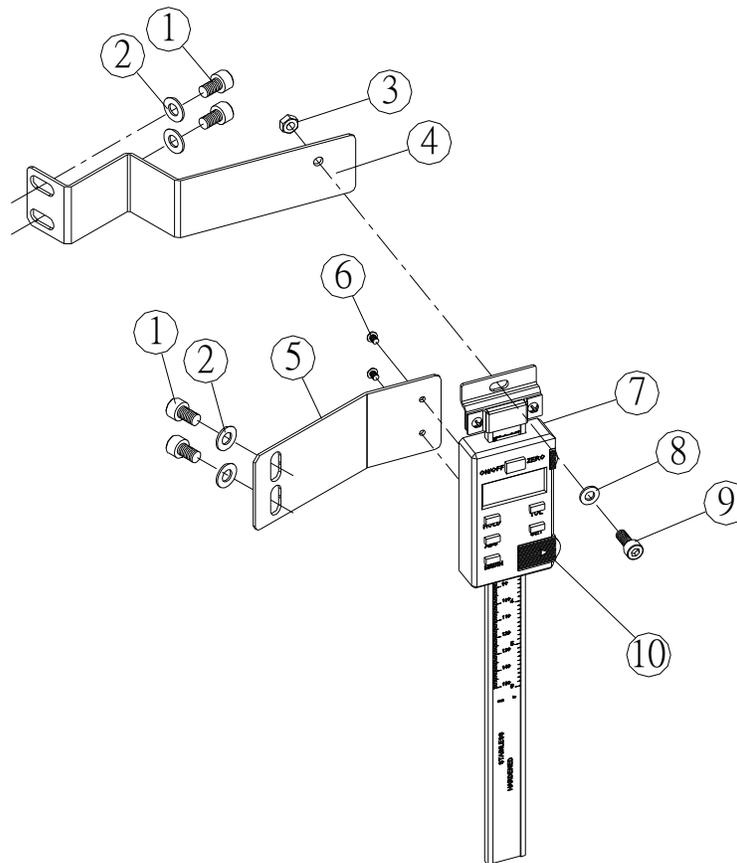
CALIFORNIA PROPOSITION 65 WARNING: This product contains chemicals known to the State of California to cause cancer, or birth defects or other reproductive harm. Wash hands after handling.

Ordering Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 between 8:00 a.m. and 5:00 p.m. (CST), Monday through Friday. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

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.

Digital Readout for JWDS-2244/-2244OSC/-2550 Drum Sanders – Exploded View



Digital Readout for JWDS-2244/-2244OSC/-2550 Drum Sanders – Parts List

Index No	Part No	Description	Size	Qty
	723552	Drum Sander DRO (includes #1 thru 11)		
1	TS-1503021	Socket Head Cap Screw	M6-1.0P x 10L	4
2	TS-1550041	Flat Washer	6.5 x 13 x 1T mm	4
3	TS-1540031	Hex Nut	M5-0.8P	1
4	JWDS2244-504	Upper Bracket		1
5	JWDS2244-505	Lower Bracket		1
6	JWDS2244-506	Phillips Round Hd Machine Screw	M3-0.5P x 5L	2
7	JWDS2244-507	DRO	0-150mm scale	1
8	TS-1550031	Flat Washer	5.1 x 10 x 1T mm	1
9	TS-1502031	Socket Head Cap Screw	M5-0.8P x 12L	1
10	15S-601	Battery Cover		1
11	15S-600	Battery (not shown)		2

17.0 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.

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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.

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1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
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