



# Instruction Manual

## Backstand Grinder Sanders Series Covers: BG14 and BG214

**[www.kalamazooind.com](http://www.kalamazooind.com)**

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## GENERAL POWER TOOL SAFETY WARNINGS

 **WARNING:** TO REDUCE THE RISK OF FIRE OR SHOCK HAZARD, DO NOT EXPOSE THIS EQUIPMENT TO RAIN, LIQUID, OR MOISTURE.

### READ AND SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

#### Precautions (Grinding & Power Tool Use)

- Personal protective equipment (PPE)

#### Work area & environment

- Keep the area clean, dry, and well-lit; remove trip hazards.
- Never operate in explosive atmospheres (flammable liquids, gases, or dust).
- Keep children, bystanders, and pets away from the work zone.
- Provide adequate ventilation and, where possible, use dust collection.
- Keep a Class ABC fire extinguisher within reach and know how to use it.

#### Clothing & personal safety

- Tie back or cover long hair; remove jewelry and secure hoodie strings.
- Wear close-fitting clothing—no loose sleeves or dangling items near moving parts.
- Use non-slip, closed-toe footwear.

#### Machine & accessory checks (before powering on)

- Verify guards, tool rests, and spark deflectors are installed and adjusted correctly.
- Inspect sanding belts/pully/contact wheel for damage, cracks, or wear; replace if questionable.
- Confirm tracking and tension on belts.
- Ensure workpieces and fixtures are secure and clear of the belt/wheel path.
- Check power cords, plugs, and switches.

#### After use & maintenance

- Power off and unplug/lock out before changing belts/wheels or performing maintenance.
  - Allow parts and accessories to stop completely and cool before handling.
  - Clean the work area, empty spark/dust collectors safely, and store tools properly.
  - Repair any damage before the next use.
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## OPERATING INSTRUCTIONS

- Stand to the side of the belt/contact wheel on start-up and allow it to reach full speed before contacting the work.
  - Maintain a firm grip; keep hands and fingers clear of pinch points.
  - Apply even pressure—do not force the tool or stall the motor.
  - Grind on the intended surface of the accessory; avoid side-loading unless rated for it.
  - Never remove guards or defeat safety devices.
  - Keep sparks directed away from yourself, others, and combustibles.
  - Disconnect power before making any adjustments
  - Abrasive belt rotation is clockwise. If the abrasive belt is lap spliced, be sure of correct rotation. Butt spliced belts are bi-directional.
  - Belt tension is pre-set with tension spring (44, 38). No belt tension adjustment is needed.
  - Belt changing – Disconnect power. Using the tension release lever, compress the tension shaft (43, 37) and draw out (47, 41) to change or replace the belt. When finished, push the tension release lever (43, 37) to reapply belt tension.
  - Belt tracking – With power disconnected, hand-rotate the belt to center it; loosen hex nut (59, 53), then turn tracking knob (60, 54) in or out to “track” the belt. When the belt is correctly positioned, hold the tracking knob (60, 54) steady with one wrench and tighten hex nut (59, 53) with a second wrench.
  - Examine the abrasive belt carefully before use. Never use an abrasive belt with a nicked or cut edge, crease, or handling damage.
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## **BG14 & BG214 3" x 132" Industrial Backstand Belt Grinder – Machine Overview**

### **Description:**

The Kalamazoo Industries BG14 and BG214 are heavy-duty industrial backstand grinders engineered for demanding metalworking and foundry applications. The BG14 features a 3" x 132" belt with a 14" x 3" serrated contact wheel, delivering powerful, cool, and fast metal removal for aggressive grinding, gate and riser cleanup, deburring, and finishing. The BG214 adds dual 3" x 132" belt stations on a rugged industrial frame, giving you two 14" x 3" contact wheels and the ability to run multiple grits for maximum throughput and flexibility. Both machines are built for smooth operation, quick belt changes, long belt life, and precise control—making them ideal choices for high-production shops and steel foundries.

### **Intended Use:**

The BG14 and BG214 backstand grinders are intended for heavy-duty industrial material removal, surface conditioning, and finishing of ferrous and non-ferrous metals. These machines are designed for applications such as gate and riser cleanup, casting preparation, deburring, descaling, and general stock removal in foundries, fabrication shops, and production environments. Their long-belt design, serrated contact wheels, and stable operating platforms make them ideal for shaping, refining, and smoothing metal components with consistent control and efficiency. Both grinders are built for continuous use in high-demand workflows where durability, accuracy, and fast abrasive changes are essential.

### **Key Benefits:**

- Heavy-duty construction built to withstand continuous industrial grinding.
  - Long 3" x 132" belt design provides cooler grinding, smoother tracking, and extended belt life.
  - Serrated 14" contact wheels deliver aggressive, fast stock removal with excellent control.
  - Smooth, stable operation reduces operator fatigue and improves grinding accuracy.
  - Quick belt-change system minimizes downtime and keeps production moving.
  - Ideal for foundry work including gate and riser cleanup, casting prep, and heavy deburring.
  - Versatile material removal suitable for steel, castings, and other ferrous metals.
  - High-production capability designed for demanding fabrication, foundry, and industrial environments.
  - BG214 dual-belt configuration allows running multiple grits for faster workflow and increased throughput.
  - Precision grinding performance ensures consistent, repeatable results across long shifts.
  - Made in the USA – backed by Kalamazoo Industries' reputation for quality and performance.
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## **Setup and Installation – BG14 & BG214 Industrial Backstand Grinder**

### **Pre-Installation Requirements**

- Verify that the installation area has sufficient space for machine footprint, operator movement, and maintenance access.
- Confirm proper 3-phase electrical supply is available:
  - BG14: 10 HP, 3PH
  - BG214: 15 HP, 3PH
- Ensure incoming voltage matches the grinder's motor plate and wiring configuration.
- Inspect floor structure to confirm it can support the machine weight and vibration load.
- Prepare appropriate lifting equipment (forklift, hoist, or pallet jack).

### **Uncrating and Handling**

- Carefully remove crating materials, keeping hardware and documentation for future reference.
- Use approved lifting points or a forklift under the machine's base—never lift by the contact wheel or motor.
- Inspect for shipping damage before proceeding with installation.

### **Positioning the Grinder**

- Place the grinder on a level, stable surface to ensure proper belt tracking and smooth operation.
- Allow adequate clearance around the machine for belt changes, service access, and operator workflow.
- For the BG214, ensure both belt stations have clear operating space and unobstructed access.

### **Anchoring and Leveling**

- Level the machine using the adjustable pads to achieve a stable operating position.
- Anchor the base to the floor if required by local safety regulations or for high-production environments.
- Recheck level after anchoring to maintain belt tracking accuracy.

### **Electrical Connection**

- Wiring must be performed by a qualified electrician following local and national electrical codes.
  - Connect to the appropriate 3-phase voltage supply (typically 220V or 440V).
  - Verify correct motor rotation before belt installation—reverse phases if rotation is incorrect.
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## **Setup and Installation – BG14 & BG214 Industrial Backstand Grinder Continued**

### **Belt Installation & Tracking Setup**

- Install the correct 3" x 132" abrasive belt for the application.
- Use the quick-release tension mechanism to mount and tension the belt.
- Adjust belt tracking knob for centered running on the contact wheel.
- Run the machine briefly to fine-tune tracking before full operation.

### **Guarding & Safety Checks**

- Confirm all guards, shields, and covers are installed and secure.
- Check that the contact wheel, idler wheel, and tracking system rotate freely.
- Install required dust collection or spark containment systems as per shop standards.

### **Initial Test Run**

- Start the machine and allow it to reach full speed.
  - Listen for unusual vibration or noise, confirming smooth operation.
  - Test belt tracking under load and adjust as needed.
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## Troubleshooting

- Check belt tension and adjust as needed.
- Inspect tracking knob and collar for proper adjustment.
- Ensure pulleys and contact wheels are clean and free of debris.
- Verify belt is installed correctly and not worn or stretched.
- Crown on the idler pulley is worn (needs to be replaced)
- Contact wheel is damaged (needs to be replaced)

### **Excessive vibration or noise:**

- Confirm grinder is securely mounted to a stable surface.
- Check belt for damage, uneven wear, or improper tension.
- Inspect contact wheel and pulleys for balance or bearing wear.
- Tighten all mounting and guard fasteners.

### **Poor grinding performance:**

- Replace worn or glazed abrasive belt.
  - Verify correct belt grit and type for the material being ground.
  - Check that belt tracking is properly centered.
  - Clean buildup from contact wheel and work surface.
  - Check for damaged contact wheel and or idler pulley.
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## **Preventive Maintenance**

### **Daily:**

- Inspect abrasive belt for wear, damage, or loading; replace if necessary.
- Check belt tracking and tension before operation.
- Ensure all guards and covers are securely in place.
- Clean dust and debris from around the grinder, pulleys, and motor vents.
- Verify on/off switch operates properly.

### **Weekly:**

- Inspect contact wheel, idler wheel, and drive pulley for wear or buildup; clean as needed.
- Check fasteners and mounting bolts to ensure the machine is securely tightened.
- Inspect electrical cord and connections for signs of wear or damage.
- Confirm belt alignment and tracking knob function smoothly.

### **Monthly:**

- Inspect motor ventilation openings and clean thoroughly to prevent overheating.
- Examine machine frame and stand for signs of vibration fatigue or loose hardware.
- Check overall grinder performance for unusual noise or vibration and address issues promptly.

### **General Tips:**

- Always disconnect power before performing maintenance.
  - Use only recommended replacement belts and parts.
  - Keep maintenance records to track performance and part replacement intervals.
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## Technical Information – BG448 4" x 48" Industrial Belt Grinder

### Models: BG14 & BG214

- Belt Size: 3" x 132" long abrasive belts
- Contact Wheels: 14" diameter x 3" wide serrated rubber wheels
- Machine Type: Industrial backstand grinder
- BG14: Single-station backstand grinder
- BG214: Dual-station backstand grinder (dual grinding heads)
- **Motor & Power:**
  - **BG14:**
    - 10 HP, 3-phase
    - Designed for heavy, continuous grinding and foundry cleanup
  - **BG214:**
    - 15 HP, 3-phase
    - Higher horsepower for maximum throughput and dual-station use
- **Electrical Requirements:**
  - 3-phase industrial power (commonly 220V or 440V, depending on configuration)
  - Built for continuous-duty, industrial environments
- Frame Construction: All-steel, welded, heavy-duty base for rigidity and long service life
- Tracking System: Adjustable belt tracking for stable, accurate grinding
- Tension Mechanism: Quick-release belt tension system for fast belt changes
- Wheel Bearings: Industrial-grade, sealed bearings for smooth operation and long life
- Work Height: Stand-up operating height designed for control and operator comfort

### Replacement Belts and Parts

Contact Kalamazoo Industries, Inc. for parts, accessories, or technical support.

- Phone: (269) 382-2050
  - Website: [www.kalamazooind.com](http://www.kalamazooind.com)
  - [info@kalamazooindustries.com](mailto:info@kalamazooindustries.com)
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SIDE VIEW OF BELT GUARD  
BELTS AND PULLEYS

DETAIL C  
SCALE 1 : 2  
V-BELT GUARD  
MOUNTING DETAILS

### WHEEL, SPINDLE, AND SPINDLE BEARING DETAILS

DETAIL G  
LEVELER PAD ASSEMBLY DETAILS  
X 4 PLACES

SECTION F-F  
R PULLEY DETAILS  
SCALE 1 : 2

DETAIL A  
SCALE 1 : 2  
MOTOR MOUNT BRACKET DETAILS

FRONT VIEW

SIDE VIEW OF  
IDLER ASSEMBLY

DETAIL E

TOP VIEW OF  
IDLER ASSEMBLY

TOP VIEW OF  
IDLER ASSEMBLY

LEFT SIDE VIEW

FRONT VIEW

RIGHT SIDE VIEW


BACK SIDE VIEW

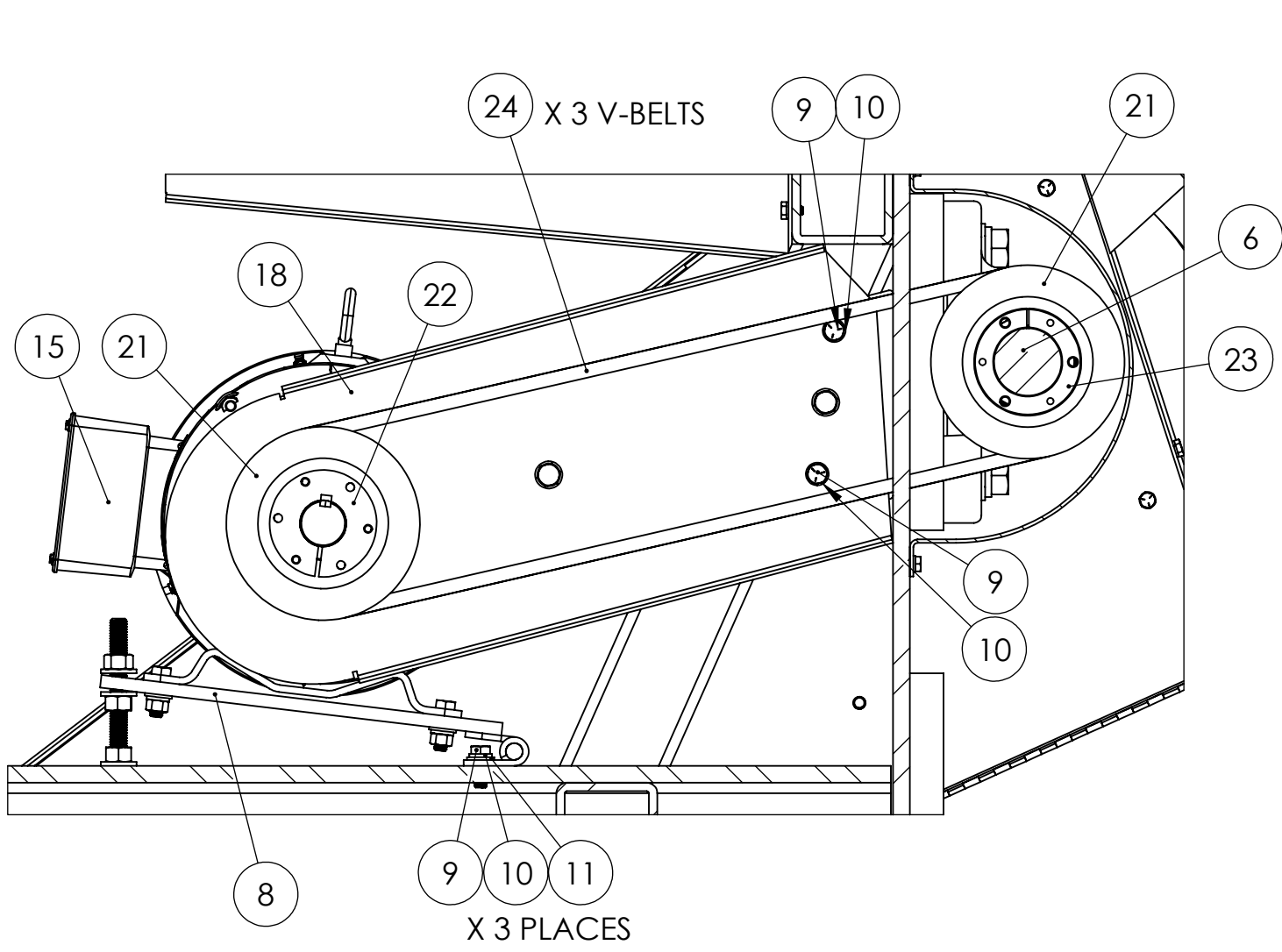
DETAIL B  
SCALE 1 : 1

MOTOR MOUNT  
DETAILS

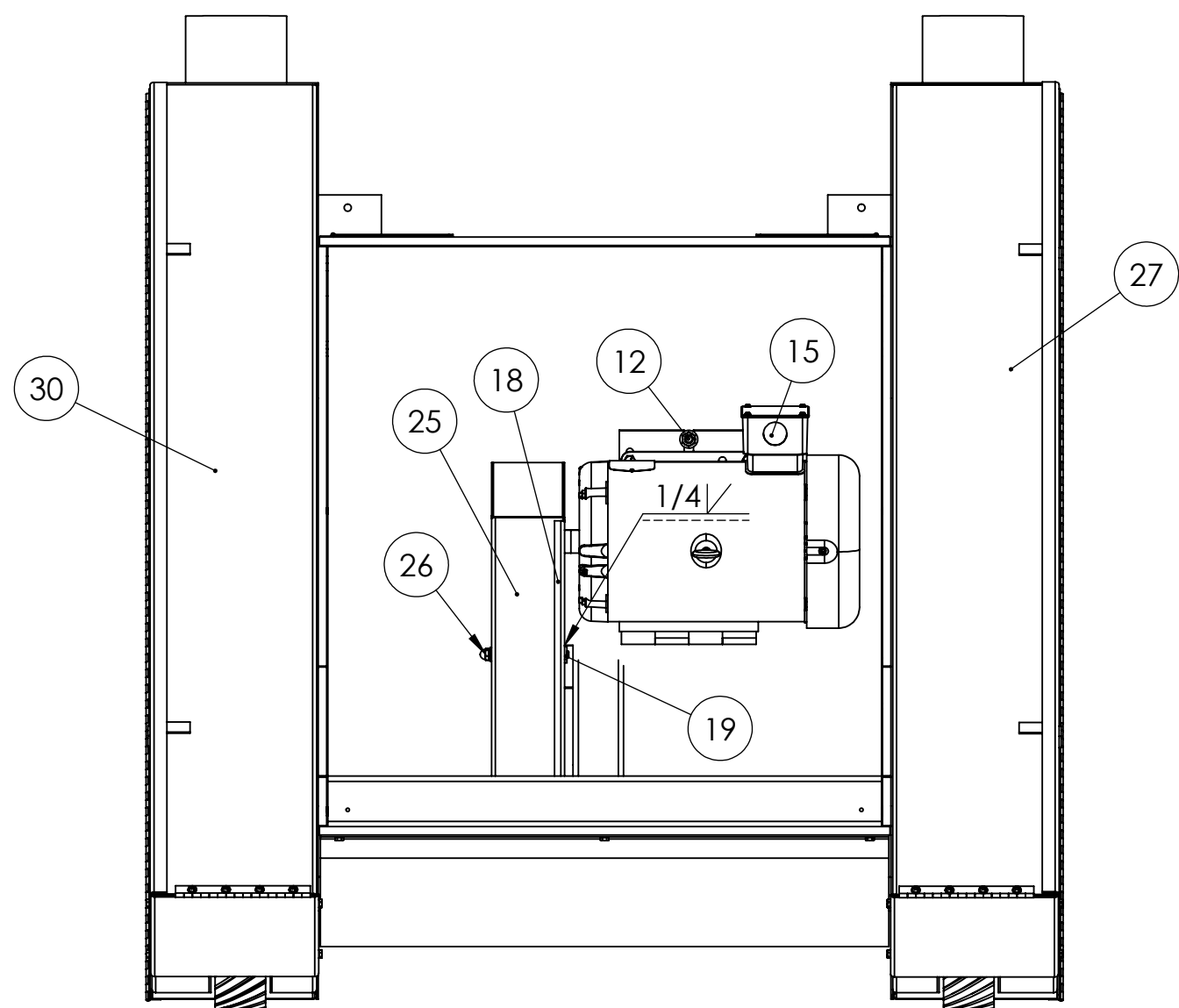
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
C7, G8	1	560-106 REPLACES 385V54. 049-072 REPLACES 049-082. 049-117 REPLACES 049-072.	2/28/2024	
G7	2	342-101-REV1 REPLACES 342-101 342-101A-REV1 REPLACES 342-101A. 051-133 REPLACES 051-139	11/26/2024	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	716-029PLATE-REV1	BG14 STAND ASSEMBLY, MADE FROM 1/2 INCH PLATE/ REV1	1
2	486-078	MOTOR MOUNT ASSEMBLY FOR BG14 AND BG214	1
3	HHC5037016	3/8-16 X 1 HHCS GR5 Z	8
4	UFWZ037	3/8 USS F/W Z	11
5	SLWZ037	3/8 SPLIT L/W Z	14
6	RND0.5-13THRDRODX5.0	5 INCHES OF RND-1/2-13 THRD ROD	1
7	UFWZ050	1/2 USS F/W Z	11
8	FHN5050	1/2-13 FHN GR5 Z	15
9	044-037	PILOW BLOCK BEARING	2
10	HHC8076032	3/4-16 X 2 HHCS GR8 YEL/ZN	4
11	SFW8075	3/4 SAE F/W GR8 YL/ZN	4
12	SLW8075	3/4 L/W GR8 YL/ZN	4
13	701-016	DRIVE SPINDLE FOR BG14 WITH WIDER GUARD	1
14	SC200D	SC200D 2" SPLIT COLLAR	2
15	486-019	10HP MOTOR FOR K16-18, KM16-18, BG14	1
16	HHC5037020	3/8-16 X 1-1/4 HHCS GR5 Z	4
17	FHN5037	3/8-16 FHN GR5 Z	10
18	342-101A-REV1	INNER V-BELT GUARD FOR BG14/ REV1	1
19	BUCKGN3316	3/8-16 WELD NUT STEEL TAB PROJECTION	1
20	RND0.375-16THRDRODX6.	6 INCHES OF RND-3/8-16 THRD ROD	2
21	560-106	BROWNING SHEAVE FOR BG14, BG214 MOTOR AND SPINDLE, K26S-30HF	2
22	049-072	MOTOR PULLEY BUSHING FOR BG14	1
23	049-117	SPINDLE PULLEY BUSHING FOR BG14	1
24	051-133	V-BELT FOR BG14 AND BG214	3
25	342-101-REV1	OUTER V-BELT GUARD FOR BG14/ REV1	1
26	CPNZ037	3/8-16 CAP NUT NICKEL	2
27	342-110	BELT GUARD FOR BG14	1
28	FHN5151	1-1/2-12 FHN Z	1
29	HHC5031012	5/16-18 X 3/4 HHCS GR5 Z	4
30	936-027	14 DIA X 3 WIDE X 1.25 BORE C130 STYLE CONTACT WHEEL BUSHING FOR K20S AND K26 SPINDLE PULLEY	1
31	049-011		1
32	SLWZ031	5/16 SPLIT L/W Z	4
33	342-110THROAT-L.H.3INCH	L.H. THROAT GUARD (3 INCH WHEEL) FOR BG14 BELT GUARD	1
34	342-110B	WHEEL SIDE GUARD (UNIVERSAL) FOR BG14 BELT GUARD	2
35	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	17
36	342-110THROAT-R.H.3INCH	R.H. THROAT GUARD (3 INCH WHEEL) FOR BG14 BELT GUARD	1
37	BUCKSN2113	1/4-20 TAB WELD SPOT NUT OFFSET	4
38	SLWZ025	1/4 SPLIT L/W Z	17
39	IDLER ASSEMBLY STUD	4 INCHES OF 1/2-13 THREADED ROD TO ATTACH IDLER ASSEMBLY TO BG214 STAND	2
40	SLWZ050	1/2 SPLIT L/W Z	4
41	IDLER ASSEMBLY SPACER	SPACER FOR IDLER ASSEMBLY FOR BG14 AND BG214	2
42	291-004	CAST IRON FRAME WITH BUSHINGS FOR S6 SERIES SANDERS	1
43	960-006YA	YOKE WITH TENSION SHAFT FOR S6 SANDERS	1
44	697-035	BG14 IDLER BELT TENSION SPRING	1
45	HHT5031032	5/16-18X2 HEX HEAD TAP BOLT GR5 ZINC	1
46	UFWZ031	5/16 USS F/W Z	1
47	455-002	TENSION RELEASE LEVER FOR BG14 TRACKING	1
48	BWWA031	5/16 BOWED SPRING WASHER 21/64	1
49	STNZ031	5/16-18 STOVER LOCK NUT ZINC- WAX	1
50	CRBZ025032	1/4-20 X 2 CARRIAGE BOLT ZINC PLATED	2
51	FHN5025	1/4-20 FHN GR5 Z	2
52	563-002	PLATEN FOR S6M SANDERS	1
53	560-016S	ALUMINUM IDLER PULLEY W STEEL JACKET FOR 6" SANDER. INCLUDES PULLEY AND BEARINGS	1
54	701-019N	S6 IDLER SPINDLE- NEW STYLE	1
55	123-016	S6 IDLER PULLEY LOCK COLLAR	2
56	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	2
57	ROLA018032	3/16 X 2 ROLL PIN	1
58	DOWA025032	1/4 X 2 DOWEL PIN	1
59	FHN5031	5/16-18 FHN GR5 ZINC	1
60	441-014	TRACKING KNOB ASSEMBLY	1
61	FSCA031016	5/16-18 X 1 FSHCS	2
62	SC100D	SC100D 1" 2PC SPLIT COLLAR	1
63	342-114	SPINDLE BEARING GUARD FOR BG14	1
64	716-029TRAY	TOP TRAY FOR BG14 WITH PLATE FRAME	1
65	455-016	LEVELER PAD ASSEMBLY	4
66	041-092	SWITCH BRACKET FOR MAG SWITCH ON K20 ARM	1

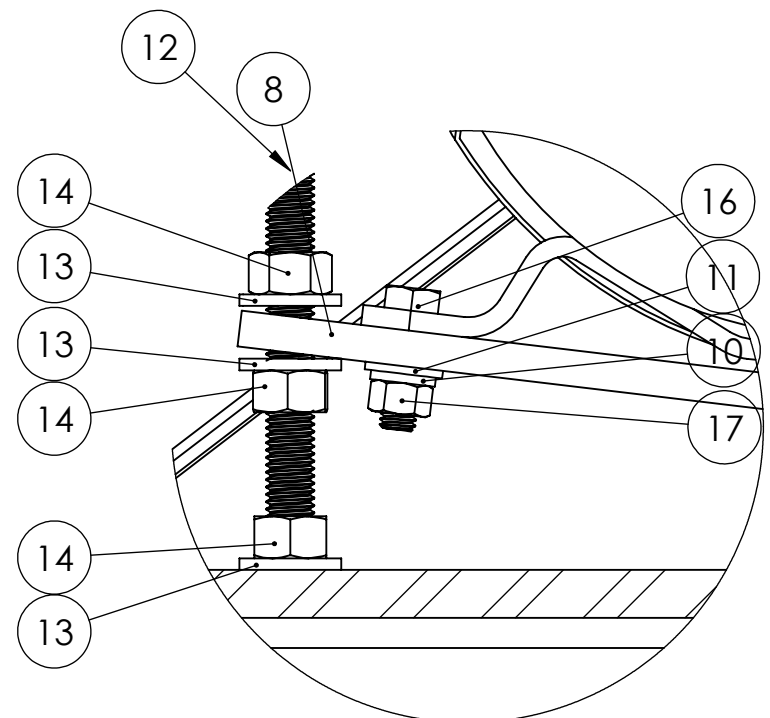
		UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
		DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONS & DECIMALS: ± .005 ANGLES & MATCHES: ± .005 TWO THICE DECIMAL: ± .002 THREE THICE DECIMAL: ± .001		DRAWN CHECKED INCH APPR G.A. COMMENTS:	TITLE BG14 WITH STAND MADE FROM PLATE/ REV1		
		INTERIERS GEOMETRIC TOLERANCES SPECIFIC MATERIALS		SIZE DWG. NO. REV E BG14PLATE-REV2 2			
NEXT ASSY	USED ON	FINISH		SCALE: 1:5 WEIGHT: SHEET 1 OF 1			
APPLICATION		DO NOT SCALE DRAWING					



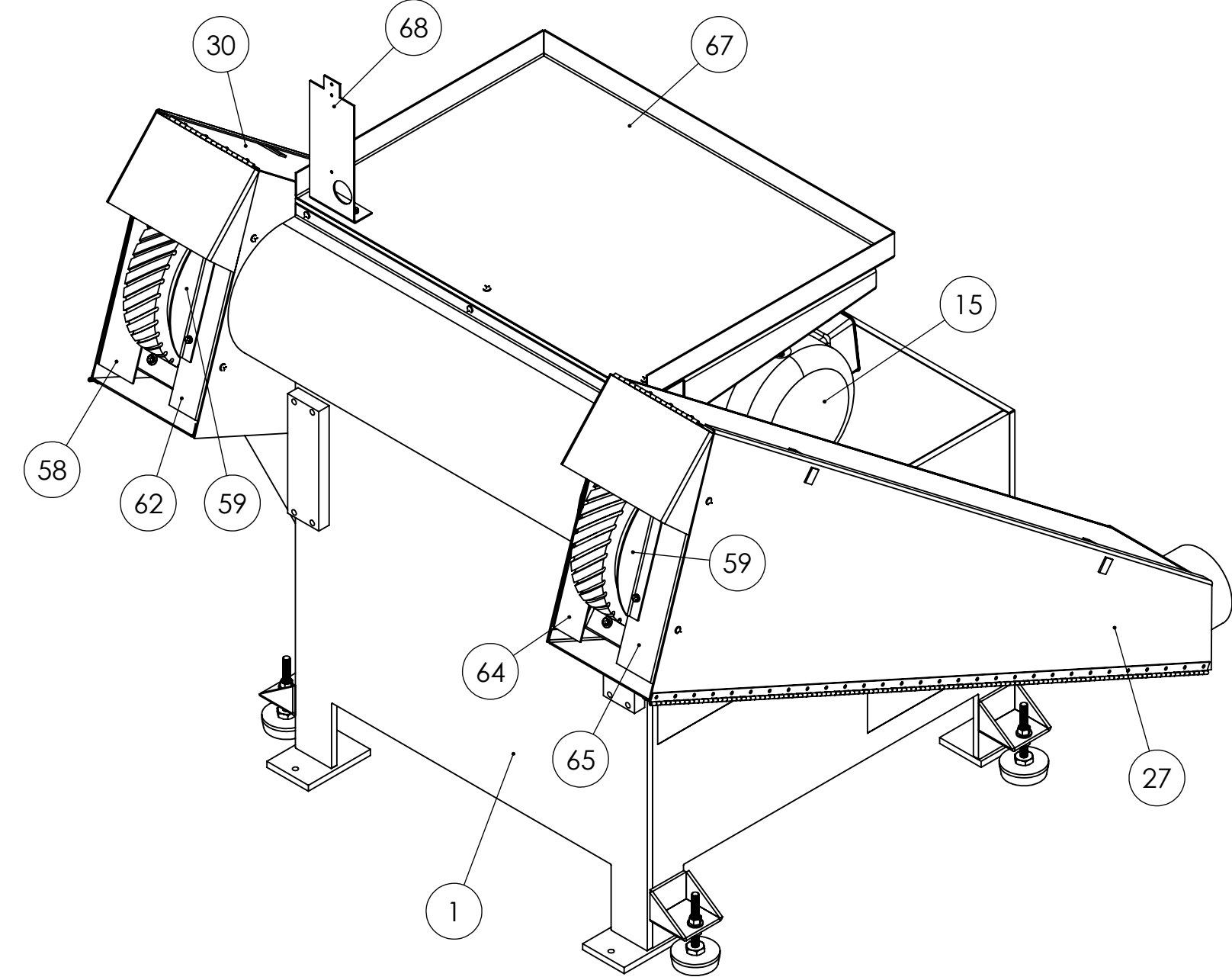
SECTION B-B  
INNER V-BELT GUARD,  
V-BELTS, AND PULLEYS



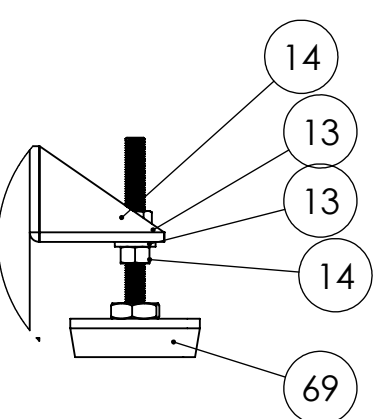
TOP VIEW OF MOTOR  
AND MOTOR TENSION SCREW



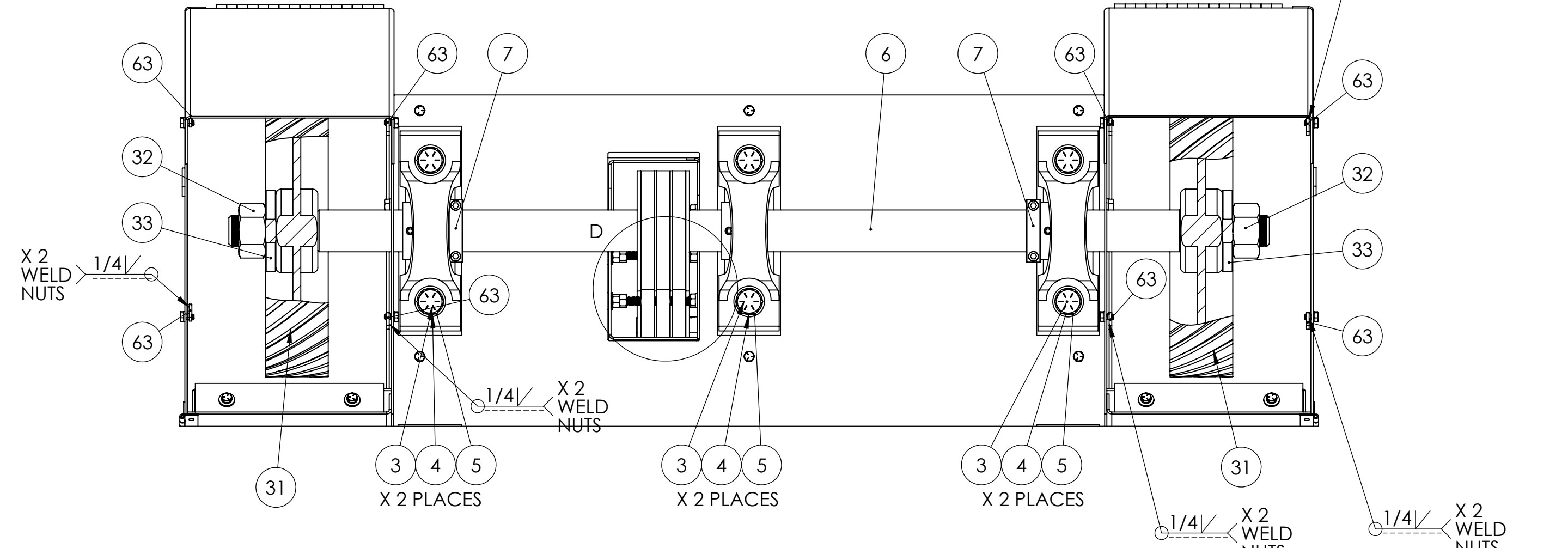
DETAIL C  
SCALE 1 : 2  
MOTOR MOUNT TENSION POST  
AND MOTOR MOUNT DETAILS



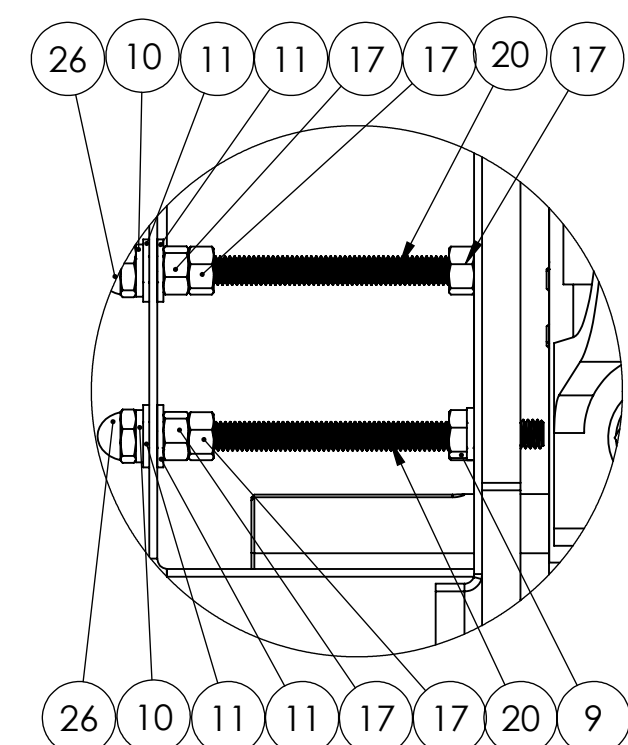
X 4 PLACES



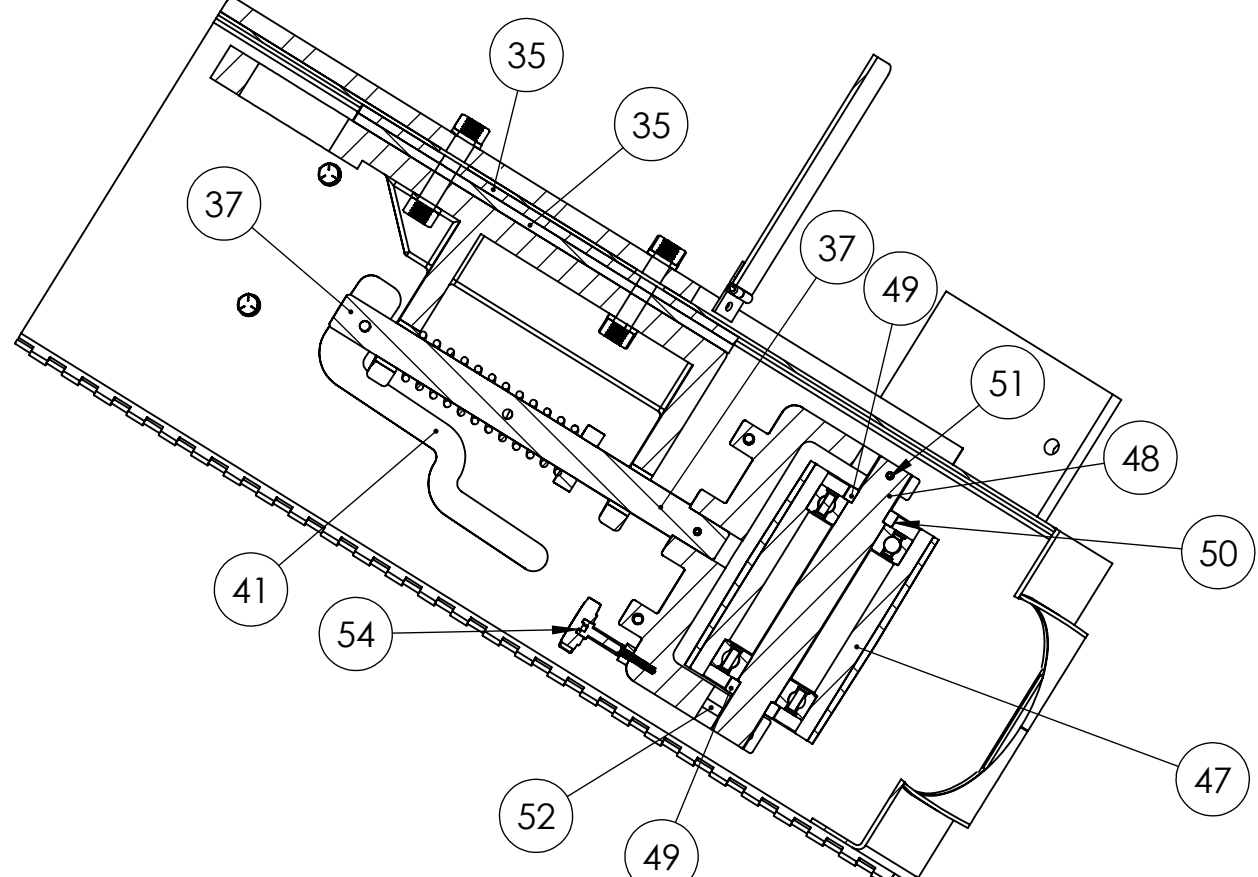
DETAIL I  
ADJUSTABLE FOOT  
PAD DETAILS



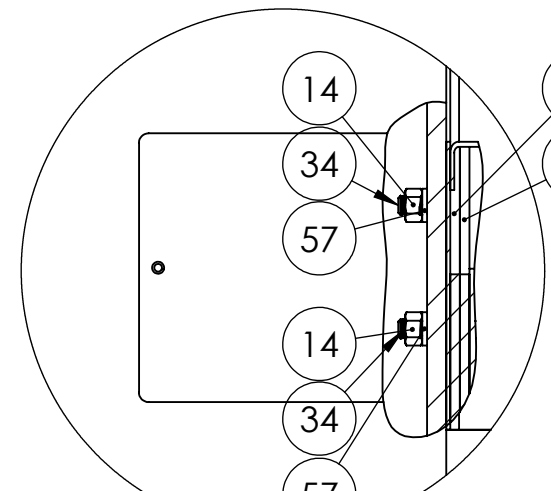
WHEEL, SPINDLE AND  
SPINDLE BEARING DETAILS



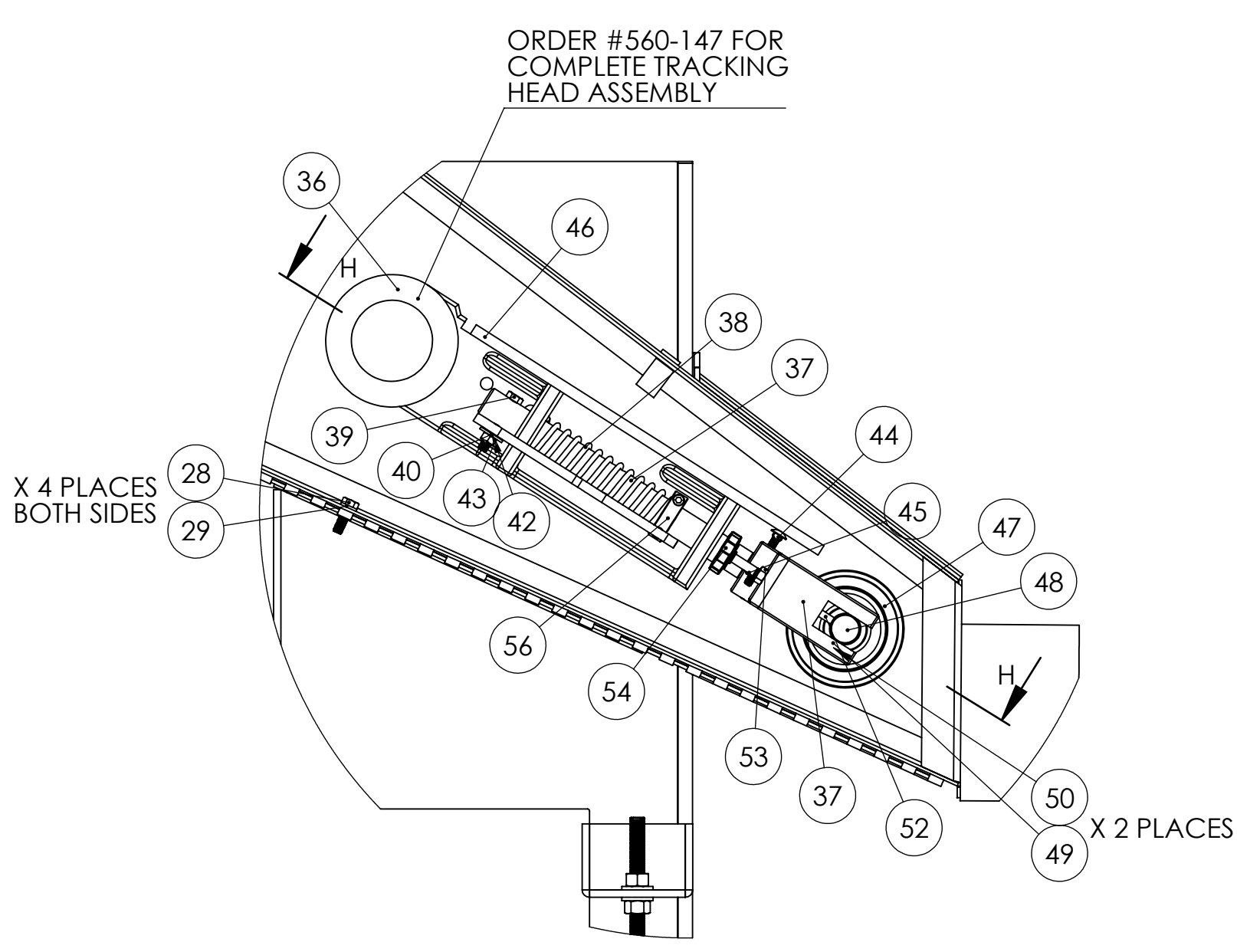
DETAIL D  
SCALE 2 : 5  
ATTACHING BELT GUARD  
TO FRAME DETAILS



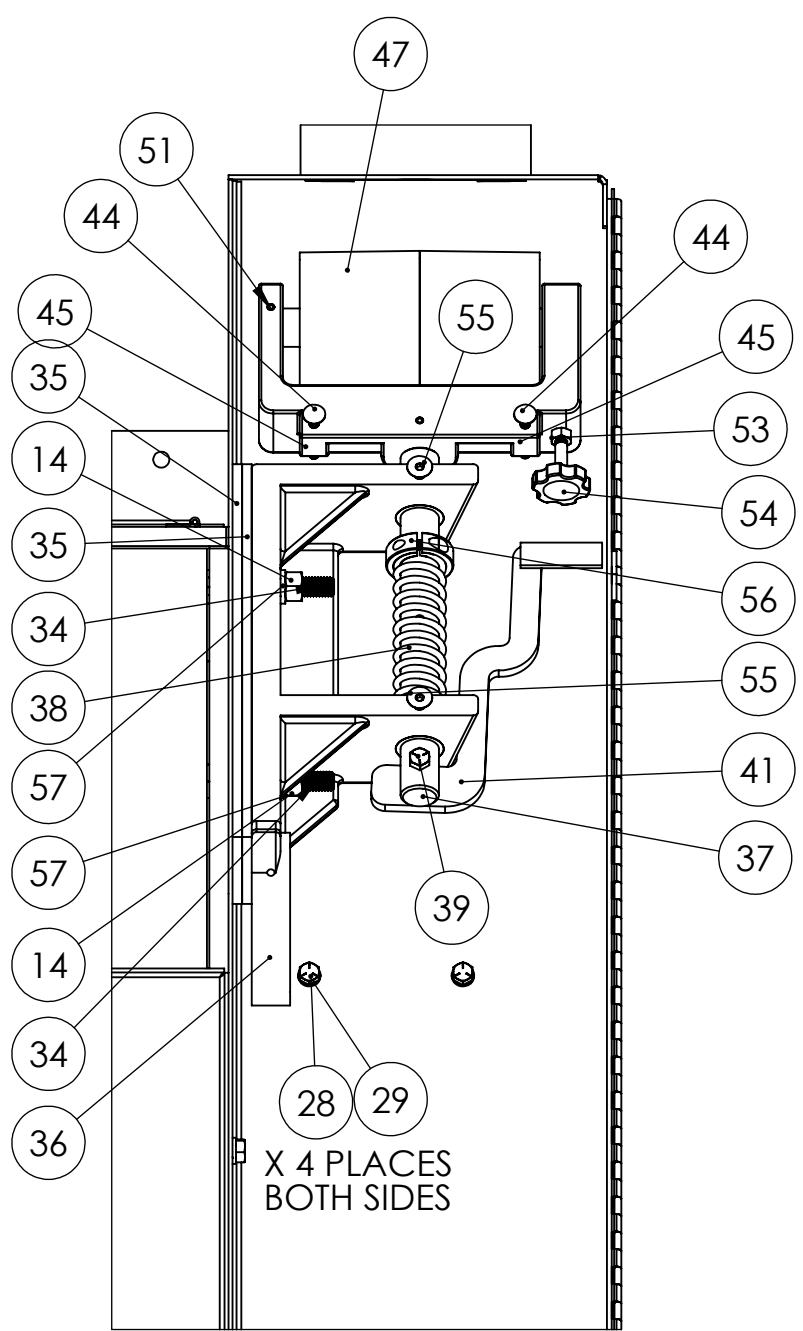
SECTION H-H  
TRACKING HEAD HALF SECTION



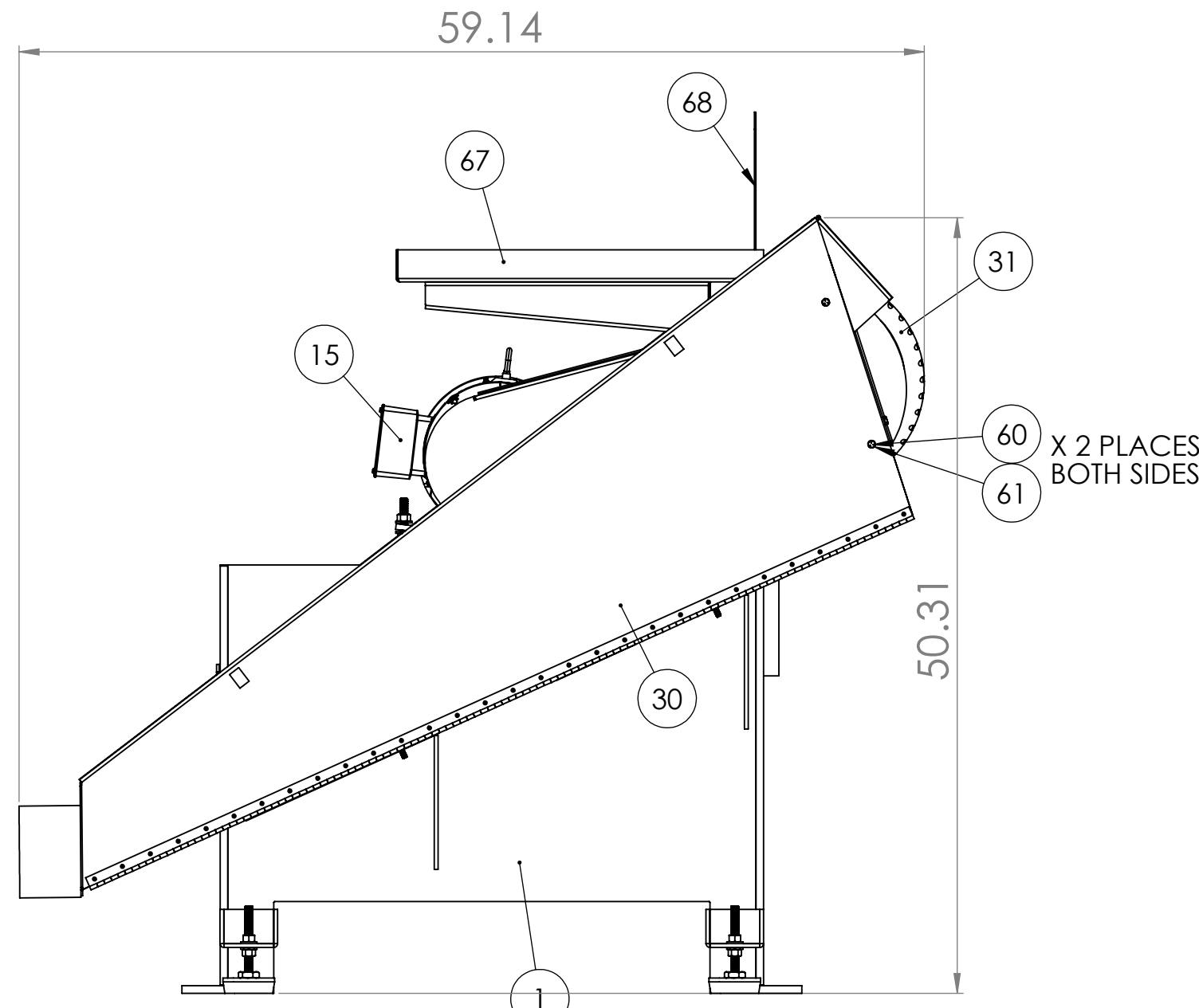
DETAIL F  
ATTACHMENT OF IDLER  
PULLEY ASSEMBLY TO FRAME  
COMMON TO BOTH SIDES



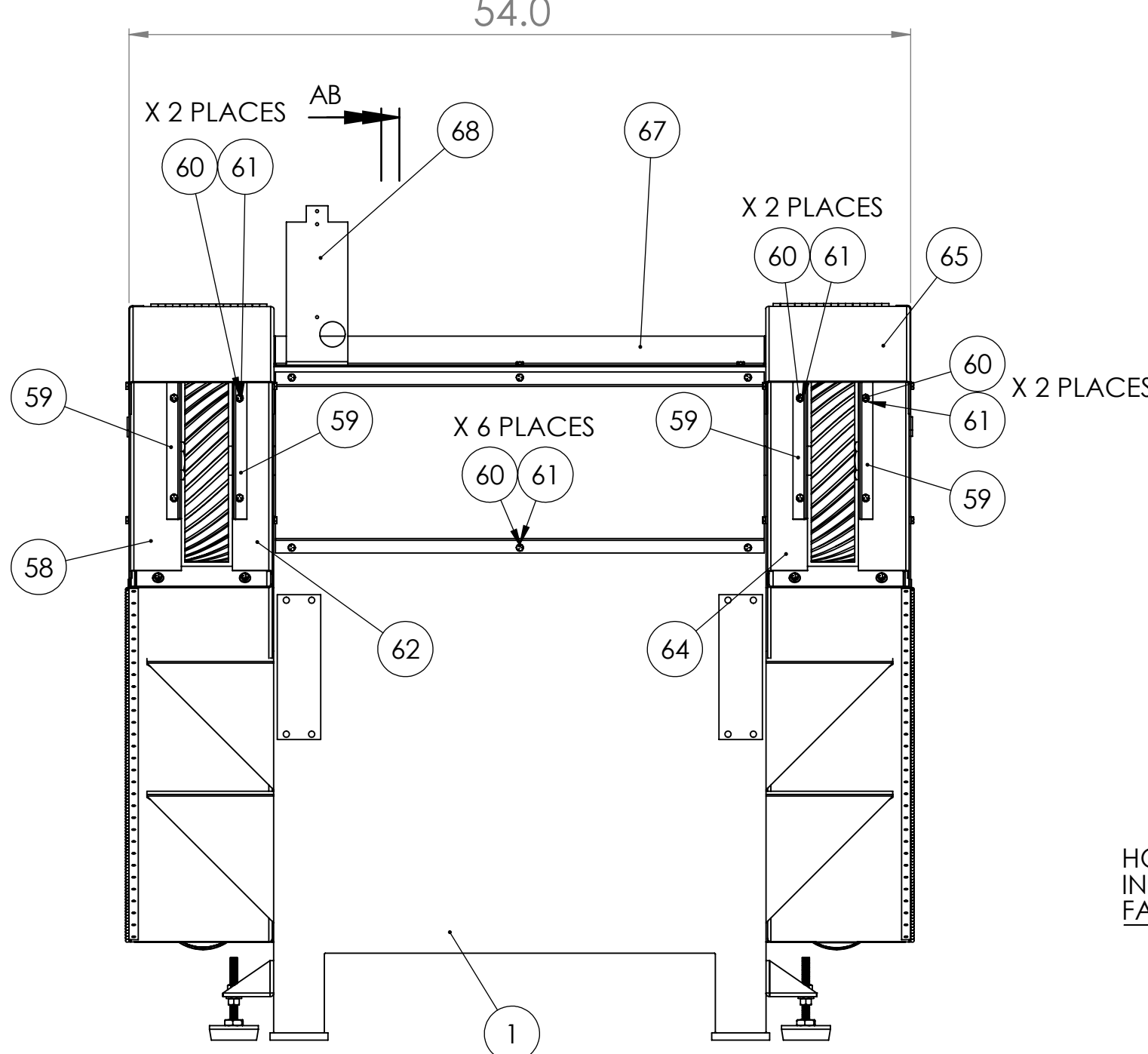
DETAIL E  
TRACKING HEAD DETAILS  
PARTS ARE COMMON TO  
BOTH SIDES



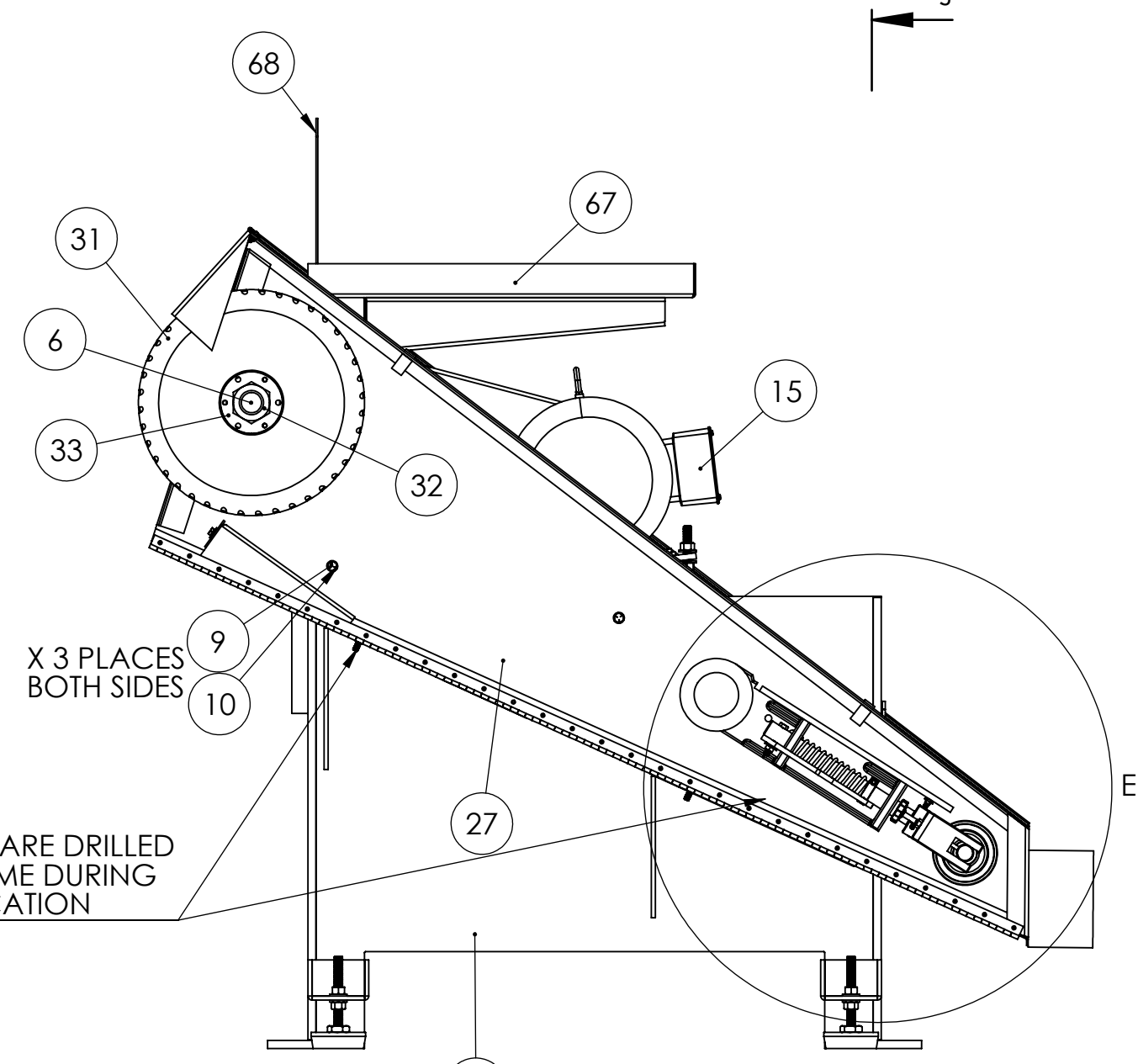
DETAIL G  
TOP VIEW OF TRACKING HEAD  
COMMON TO BOTH SIDES



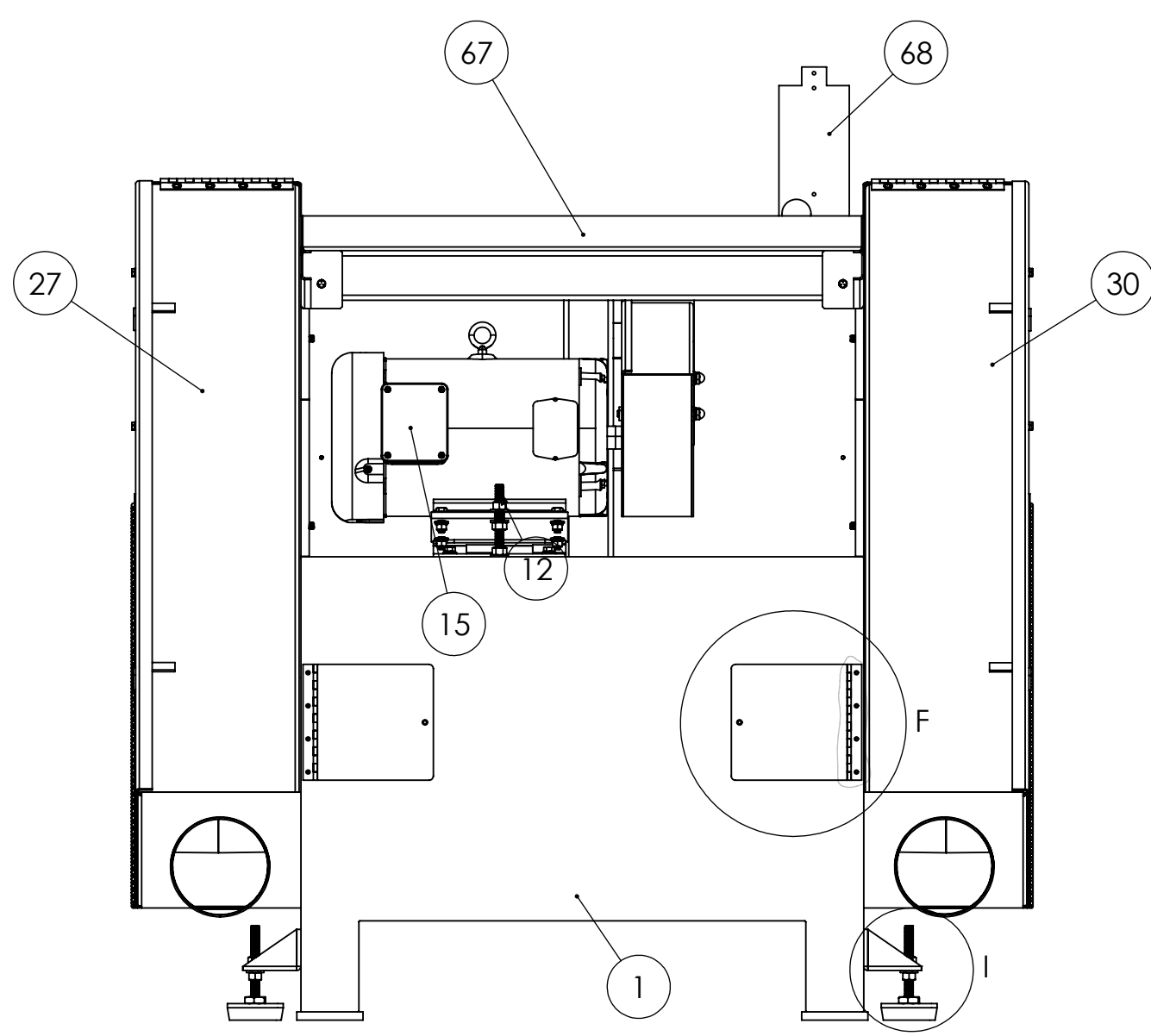
LEFT SIDE VIEW



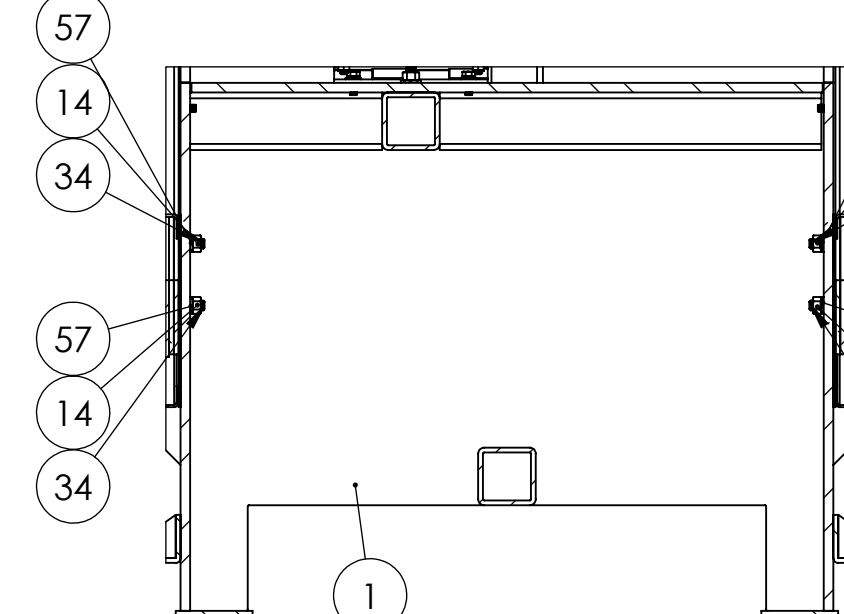
FRONT VIEW



RIGHT SIDE VIEW




BACK VIEW



SECTION J-J  
SCALE 1 : 10  
INTERNAL VIEW OF  
IDLER HEAD ASSEMBLY  
ATTACHMENT STUDS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	716-031PLATE	BG214 STAND ASSEMBLY, MADE FROM 1/2 INCH PLATE	1
2	044-037	PILOW BLOCK BEARING	3
3	HHC8076032	3/4-16 X 2 HHCS GR8 YL/ZN	6
4	SLW8075	3/4 L/W GR8 YL/ZN	6
5	SFW8075	3/4 SAE F/W GR8 YL/ZN	6
6	701-107	DRIVE SPINDLE FOR BG214	1
7	SC200D	SC200D 2" SPLIT COLLAR	2
8	484-078	MOTOR MOUNT ASSEMBLY FOR BG14 AND BG214	1
9	HHC5037016	3/8-16 X 1 HHCS GR5 Z	11
10	SLW2037	3/8 SPLIT L/W Z	17
11	UFW2037	3/8 USS F/W Z	11
12	RND0.5-13THRDRODX5.0	5 INCHES OF RND-1/2-13 THRD ROD	1
13	UFW2050	1/2 USS F/W Z	11
14	FHN5050	1/2-13 FHN GR5 Z	19
15	484-020	15HP MOTOR FOR K20SSP-15, K20SW-15, K20Z-22/15, K20FS, K20E	1
16	HHC5037020	3/8-16 X 1-1/4 HHCS GR5 Z	4
17	FHN5037	3/8-16 FHN GR5 Z	10
18	342-094	INNER V-BELT GUARD FOR BG214	1
19	BUCKQN3316	3/8-16 WELD NUT STEEL TAB PROJECTION	1
20	RND0.375-16THRDRODX5.	5 INCHES OF RND-3/8-16 THRD ROD	2
21	560-106	BROWNING SNEAVE FOR BG14, BG214 MOTOR AND SPINDLE, K26S-30HP	2
22	049-072	MOTOR PULLEY BUSHING FOR BG214	1
23	049-117	SPINDLE PULLEY BUSHING FOR BG14	1
24	051-133	V-BELT FOR BG14 AND BG214	3
25	342-095	OUTER V-BELT GUARD FOR BG214	1
26	CPN2037	3/8-16 CAP NUT NICKEL	2
27	342-110	BELT GUARD FOR BG14	1
28	HHC5031016	5/16-18 X 1 HHCS GR5 Z	8
29	SLW2031	5/16 SPLIT L/W Z	8
30	342-110LH	LEFT SIDE BELT GUARD FOR BG214	1
31	936-027	14 DIA X 3 WIDE X 1.25 BORE C130 STYLE CONTACT WHEEL	2
32	FHN5151	1-1/2-12 FHN Z	2
33	049-011	BUSHING FOR K20FS AND K26 SPINDLE PULLEY	2
34	IDLER ASSEMBLY STUD	4 INCHES OF 1/2-13 THREADED ROD TO ATTACH IDLER ASSEMBLY TO BG214 STAND	4
35	IDLER ASSEMBLY SPACER	SPACER FOR IDLER ASSEMBLY FOR BG14 AND BG214	4
36	291-004	CAST IRON FRAME WITH BUSHINGS FOR S6 SERIES SANDERS	2
37	960-006YA	YOKE WITH TENSION SHAFT FOR S6 SANDERS	2
38	697-035	BG14 IDLER BELT TENSION SPRING	2
39	HHT5031032	5/16-18X2 HEX HEAD TAP BOLT GR5 ZINC	2
40	UFW2031	5/16 USS F/W Z	2
41	455-002	TENSION RELEASE LEVER FOR BG14 TRACKING HEAD	2
42	BWWA031	5/16 BOWED SPRING WASHER 21/64	2
43	STNZ031	5/16-18 STOVER LOCK NUT ZINC-WAX	2
44	CRB2025032	1/4-20 X 2 CARRIAGE BOLT ZINC PLATED	4
45	FHN5025	1/4-20 FHN GR5 Z	4
46	563-002	PLATEN FOR S6M SANDERS	2
47	560-016S	ALUMINIUM IDLER PULLEY W STEEL JACKET FOR 6" SANDER. INCLUDES PULLEY AND BEARINGS	2
48	701-019N	S6 IDLER SPINDLE, NEW STYLE	2
49	123-016	S6 IDLER PULLEY LOCK COLLAR	4
50	SSKA025004	1/4-20 X 1/4 SOC SET KNURL PT.	4
51	ROLA018032	3/16 X 2 ROLL PIN	2
52	DOWA025032	1/4 X 2 DOWEL PIN	2
53	FHN5031	5/16-18 FHN GR5 ZINC	2
54	441-014	TRACKING KNOB ASSEMBLY	2
55	FSCA031016	5/16-18 X 1 FSHCS	4
56	SC100D	SC100D 1" 2PC SPLIT COLLAR	2
57	SLW2050	1/2 SPLIT L/W Z	8
58	BG214LH-THROAT-LH-3INCH	L.H. THROAT GUARD (3 INCH WHEEL) FOR BG214 L.H. BELT GUARD	1
59	342-110B	WHEEL, SIDE GUARD (UNIVERSAL) FOR BG14 BELT GUARD	4
60	HHC5025008	1/4-20 X 1/2 HHCS GR5 Z	28
61	SLW2025	1/4 SPLIT L/W Z	28
62	BG214RH-THROAT-RH-3INCH	R.H. THROAT GUARD (3 INCH WHEEL) FOR BG214 R.H. BELT GUARD	1
63	BUCKSN2113	1/4-20 TAB WELD SPOT NUT OFFSET	8
64	BG214RH-THROAT-LH-3INCH	L.H. THROAT GUARD (3 INCH WHEEL) FOR BG214 R.H. BELT GUARD	1
65	BG214RH-THROAT-RH-3INCH	R.H. THROAT GUARD (3 INCH WHEEL) FOR BG214 R.H. BELT GUARD	1
66	342-109	BG214 SPINDLE BEARING GUARD	1
67	716-031-TRAY	TOP TRAY FOR BG214	1
68	041-092	SWITCH BRACKET FOR MAG SWITCH ON K20 ARM	1
69	455-016	LEVELER PAD ASSEMBLY	4

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE		
		DIMENSIONS ARE IN INCHES		DRAWN		TITLE:	
		TOLERANCES:		CHG		BG214 W FRAME MADE FROM	
		FRACTIONS: 1/16, 1/8, 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1 1/8, 1 1/4, 1 1/2, 1 3/4, 2, 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30, 30 1/4, 30 1/2, 30 3/4, 31, 31 1/4, 31 1/2, 31 3/4, 32, 32 1/4, 32 1/2, 32 3/4, 33, 33 1/4, 33 1/2, 33 3/4, 34, 34 1/4, 34 1/2, 34 3/4, 35, 35 1/4, 35 1/2, 35 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