MODEL G0400
17" BRUSH SANDER
OWNER'S MANUAL
(For models manufactured since 03/25)

#CS23513 PRINTED IN TAIWAN V1.06.25

******Keep for Future Reference******

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. 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, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

⚠CAUTION

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.

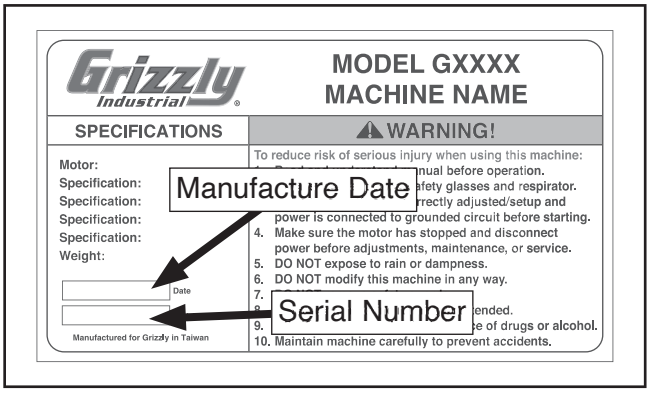
Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual**.

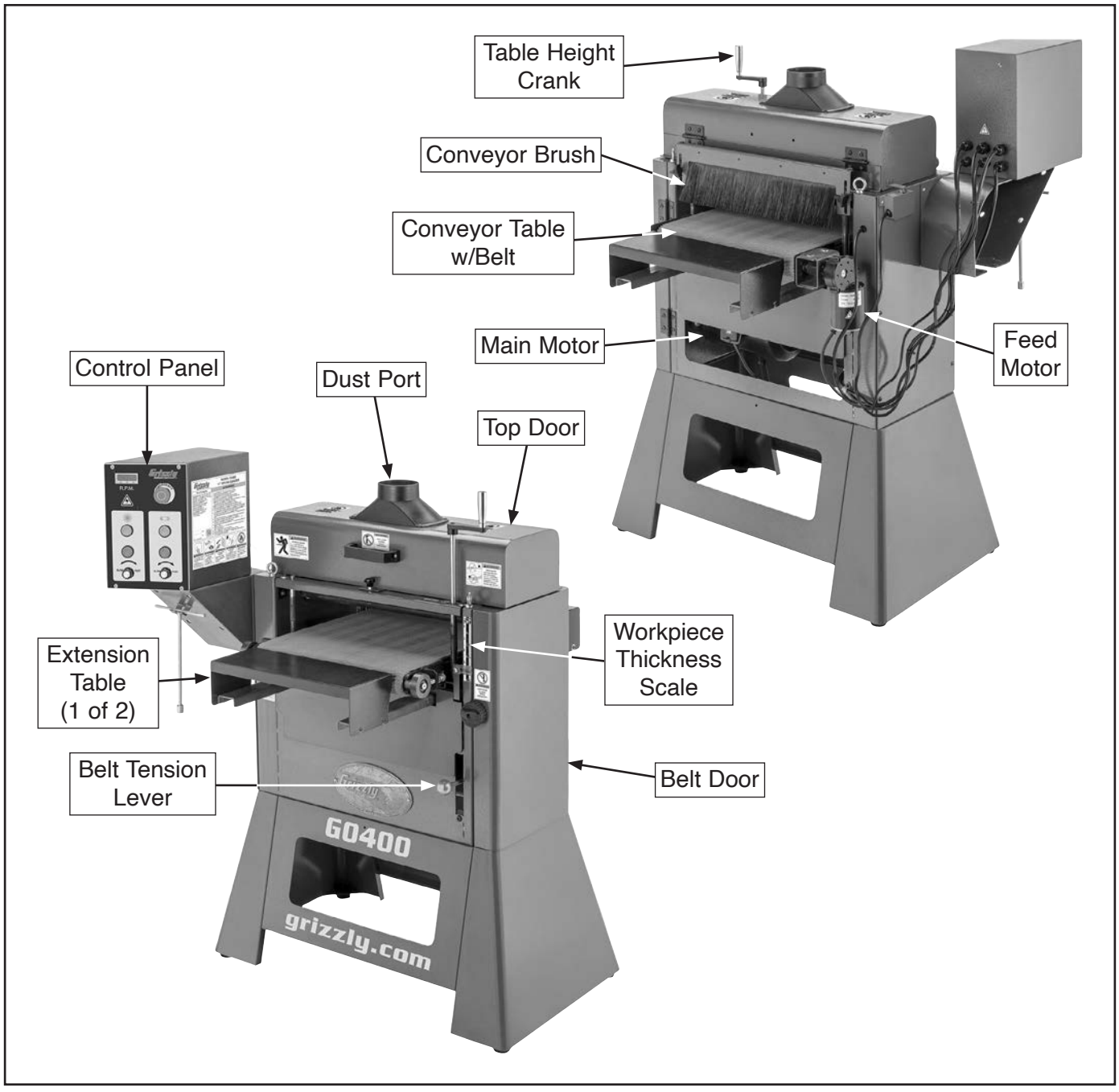
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

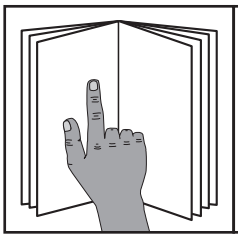
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.





⚠WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

Controls & Components

Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

Control Panel

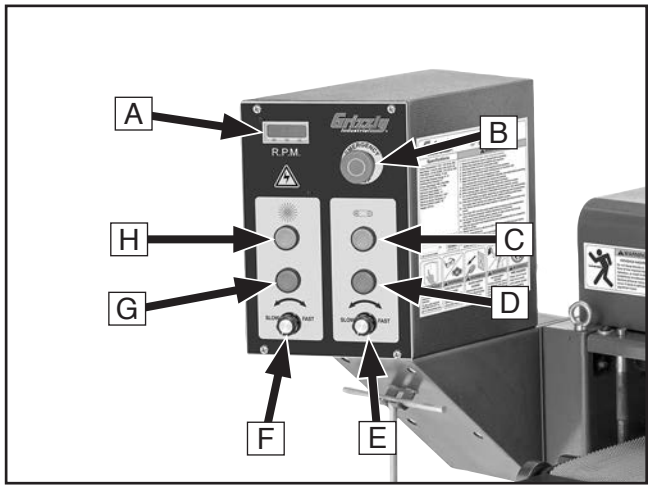


Figure 1. Control panel components.

A. Speed Digital Readout: Displays current sanding head speed (RPM).

B. EMERGENCY STOP Button: Turns machine ***OFF*** and disables power when pressed. Twist clockwise to reset.

C. Conveyor ON Button: Turns feed motor ***ON***.

D. Conveyor OFF Button: Turns feed motor ***OFF***.

E. Conveyor Speed Dial: Rotates to adjust conveyor speed between 4–17 FPM.

F. Sanding Head Speed Dial: Rotates to adjust sanding head speed between 400–1700 RPM.

G. Sanding Head OFF Button: Turns main motor ***OFF*** and illuminates white service light.

H. Sanding Head ON Button: Turns main motor and illuminates red/orange danger light.

Sanding Head

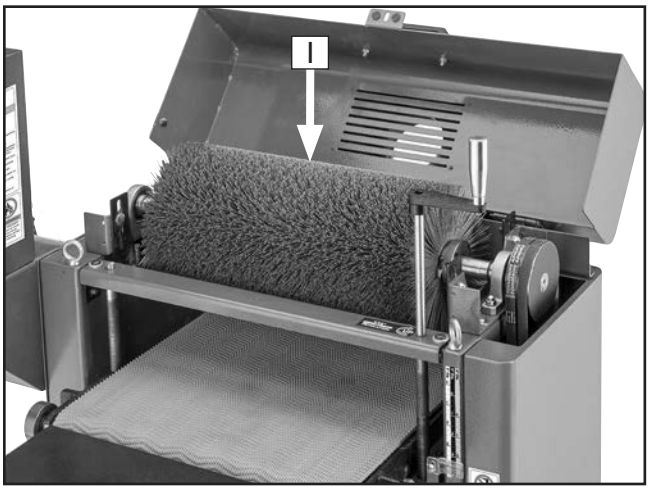


Figure 2. Sanding head.

I. Sanding Head: Rotates against incoming workpiece to sand or restore surface.

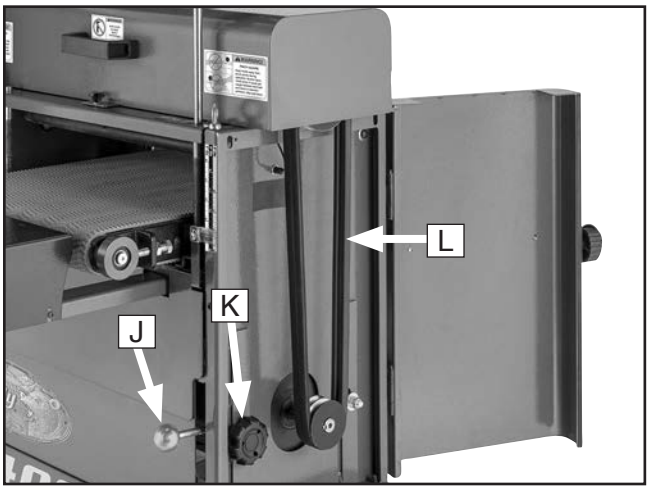


Figure 3. Sanding head adjustment components.

J. Belt Tension Lever: Increases/decreases V-belt tension for sanding head removal or adjustment.

K. Belt Tension Lock Knob: Secures V-belt tension setting.

L. V-Belt: Transfers power from main motor to installed sanding head.

Conveyor Table

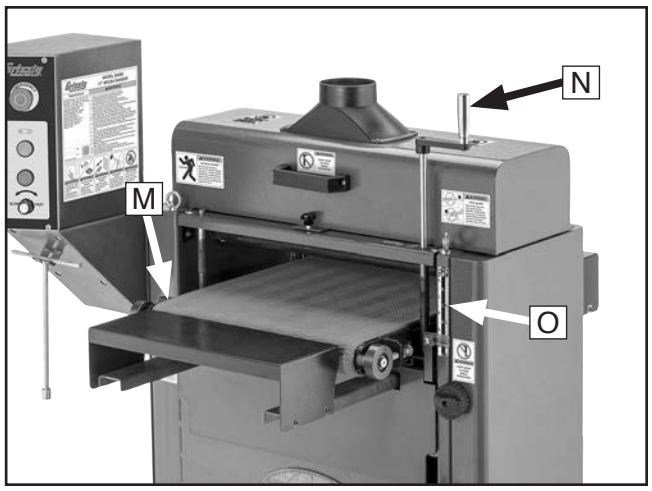


Figure 4. Conveyor table components.

M. Conveyor Table w/Belt: Adjusts up and down and feeds workpiece under sanding head.

N. Table Height Crank: Rotates to raise or lower conveyor table according to workpiece thickness.

O. Workpiece Thickness Scale: Indicates distance between conveyor table and sanding head. White scale is for use with 5" diameter brush head or sanding drum, black scale is for use with 6" diameter brush heads, and yellow scale is for use with 8" diameter brush heads.

Note: *This scale is meant only as a reference for setting distance between table and sanding head. Distance is also highly dependent on desired brush penetration/depth of cut.*

Other

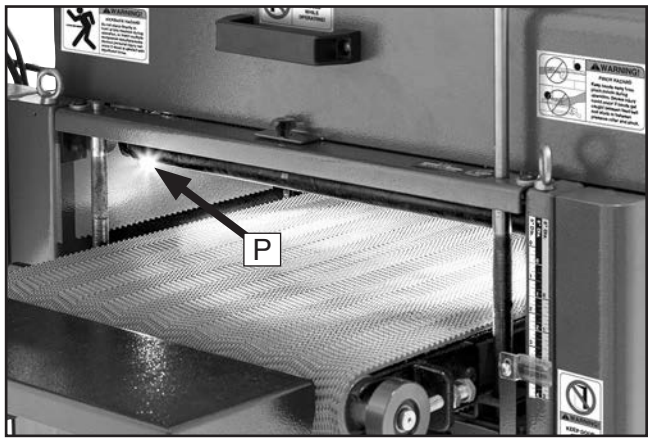


Figure 5. LED light.

P. LED Light (1 of 2): Illuminates white when sanding head is ***OFF*** to aid in visibility for depth of cut and brush penetration adjustments; illuminates red/orange to indicate sanding head is ***ON***.

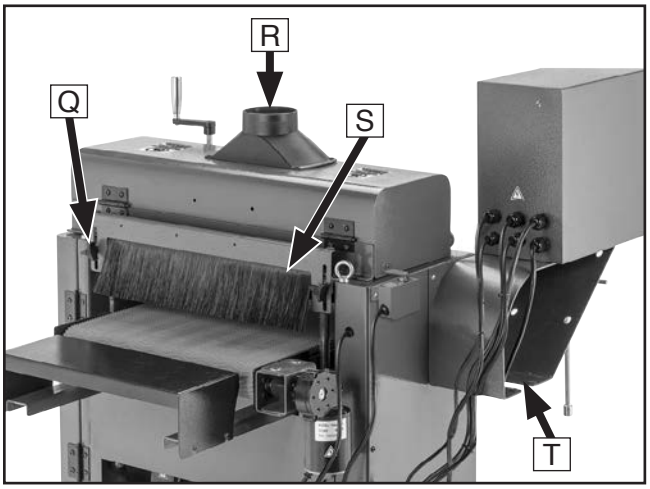


Figure 6. Other components.

Q. Conveyor Brush Lock Knob (1 of 2): Secures conveyor brush height setting.

R. Dust Port: Attaches to dust collection system to expel dust created during operations.

S. Conveyor Brush: Manually adjusts up and down according to table height to help catch dust particles.

T. Spare Sanding Head Hanger: Stores spare sanding heads when not in use.

Note: *When storing sanding head in hanger, rest sanding head on pulley, not pillow block bearings. Bearings are not designed for axial loads.*

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0400
17" BRUSH SANDER

Product Dimensions:

Weight	276 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	37 x 37-1/2 x 50 in.
Footprint (Length x Width)	34 x 20 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	320 lbs.
Length x Width x Height	32 x 30 x 39 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	110V, Single-Phase, 60 Hz
Full-Load Current Rating	17.32A
Minimum Circuit Size	20A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	74 in.
Power Cord Gauge	14 AWG
Plug Included	Yes
Included Plug Type	5-15
Switch Type	Push Buttons
Inverter (VFD) Type	RHYMEBUS RM6S2-1002E1
Inverter (VFD) Size	2 HP

Motors:

Main

Horsepower	1-3/4 HP
Phase	—An inverter converts the 3-Phase motor into a single-phase input.
Amps	5A
Speed	1720 RPM
Type	Induction
Power Transfer	Belt
Bearings	Sealed & Permanently Lubricated

Feed

Horsepower	1/4 HP
Phase	Single-Phase
Amps	0.6A
Speed	60 RPM
Type	DC
Power Transfer	Gear
Bearings	Sealed & Permanently Lubricated

Main Specifications:

Operation Information

Number of Sanding Heads	1
Sanding Head Diameter Range	5 - 8 in.
Maximum Board Width	17 in.
Minimum Board Width	1 in.
Maximum Board Thickness	3 in.
Minimum Board Thickness	1/32 in.
Minimum Board Length	10 in.
Sanding Head Speed	400 - 1700 RPM
Conveyer Feed Rate	4 - 17 FPM
Included Sanding Head Type	Nylon #240
Included Sanding Head Diameter	8 in.
Included Sanding Head Length	17 in.

Table Information

Floor to Table Height	32 - 36 in.
Table Travel	4 in.
Conveyor Belt Length	48-5/16 in.
Conveyor Belt Width	17 in.
Table Length w/Extension Tables	36-3/8 in.
Extension Table Width	16 in.
Extension Table Thickness	1/16 in.

Construction

Conveyor Belt	Rubber
Body	Steel
Base	Steel
Paint Type/Finish	Powder Coated

Other Related Information

Number of Pressure Rollers	2
Pressure Roller Type	Steel & Rubber
Pressure Roller Diameter	1 in.
Pressure Roller Length	18 in.
Number of Dust Ports	1
Dust Port Size	4 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	2 Hours
Serial Number Location	ID Label

Features:

Variable-Speed Conveyor Belt Feeds from 4–17 FPM
Table Lifting and Lowering System
Surface-Mount Pillow Blocks Allow for Easy Head Changes
Work Area Has Setup & Awareness Lights
Spare Sanding Head Hanger
Outfeed Conveyor Brush for Dust Control

SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **Alerts the user to useful information about proper operation of the machine to avoid machine damage.**

Safety Instructions for Machinery

⚠WARNING

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-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.

⚠WARNING

WEARING PROPER APPAREL. Do not wear loose clothing, gloves, neckties, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine ***OFF*** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

Additional Safety for Brush Sanders

⚠WARNING

Serious injury or death can occur from getting hands trapped between workpiece and conveyor table and being pulled into machine, or becoming entangled in rotating parts inside machine. Workpieces thrown by sander can strike nearby operator or bystanders with significant force. Long-term respiratory damage can occur from using sander without proper use of a respirator. Sanding metal increases the risk of fire. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

WEAR PROPER PPE. Sanding creates large amounts of fine airborne dust that can lead to eye injury, cancer, birth defects, and long-term respiratory damage. Be aware of dust hazards, exposure limits, and toxicity associated with each type of workpiece material being sanded. Anyone present in work area MUST wear NIOSH-approved respirator and eye protection rated for workpiece material to reduce this risk when sanding. Never operate without adequate dust collection system in place and running. However, dust collection is not a substitute for using a respirator.

WORKPIECE MATERIAL. This sander is designed to sand natural wood, lacquered wood, wood veneers, man-made wood products, laminate-covered wood products, and metal, provided the correct brush head or drum is installed. DO NOT sand glass, stone, tile, plastics, drywall, cementitious backer board, etc. Sanding improper materials increases risk of respiratory harm due to fine dust created by sanding operations.

SANDING METAL. Metal can produce sparks or flammable dust particles when sanded. These dust particles can ignite, depending on material type and circumstances. Learn fire hazards of any metal you intend to sand, remove combustible materials, and take any necessary precautions to prevent fire. Protect skin from sparks and hot workpieces. When switching from wood to metal workpiece, thoroughly clean inside and outside of machine to remove all wood dust, then connect machine to dedicated metal dust collection system. When switching from sanding one metal type to another, thoroughly clean inside and outside of machine to prevent adverse chemical reactions.

WORKPIECE INSPECTION. Sanding wood with high moisture content or exposed end grain, or metal coated with lubricant, increases risk of kickback. Sanding workpieces with excessive cupping, bowing, or twisting is dangerous because they are unstable and unpredictable. When drum sanding, nails, staples, knots, or other imperfections in workpiece can be dislodged and thrown from sander at high rate of speed into operator or bystanders, or cause damage to sandpaper or sander.

KICKBACK. Kickback occurs when workpiece is ejected out of front of sander at high rate of speed toward operator or bystanders. To reduce risk of kickback-related injuries, always stay out of workpiece path, only feed one board at a time, and always make sure pressure rollers are properly adjusted. Never sand workpieces below minimum specifications listed in **Machine Data Sheet**. If brush sanding tapered workpiece, ALWAYS feed large end first. DO NOT edge sand workpieces.

FEEDING WORKPIECE. Placing fingers between workpiece and conveyor, or between workpiece and pressure roller, can result in pinching injuries, or possibly getting trapped and pulled into machine. DO NOT place fingers under bottom of workpiece while feeding it into sander and DO NOT put hands near pressure roller.

BRUSH HEAD/SANDPAPER CONTACT. Rotating brush heads/sandpaper can remove a large amount of flesh quickly. Keep hands away from rotating brush head/drum during operation. Never touch moving brush head or drum.

SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.

⚠WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 110V 17.32A

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

⚠WARNING

Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.

110V Circuit Requirements

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 5-15

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

Grounding & Plug Requirements

This machine MUST be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

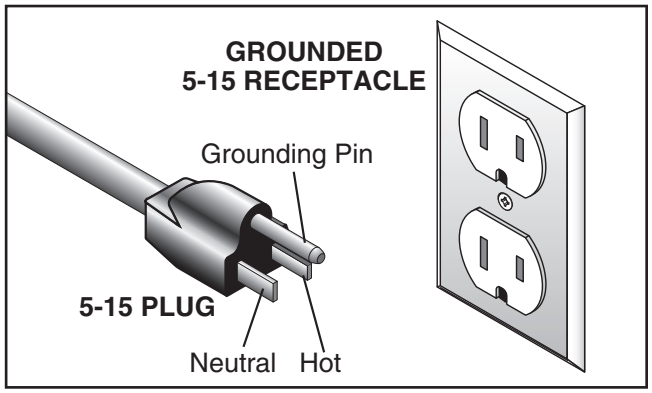
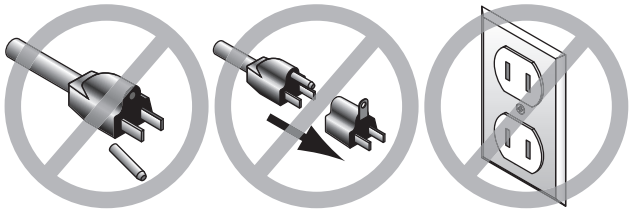


Figure 7. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!
Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the machine is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

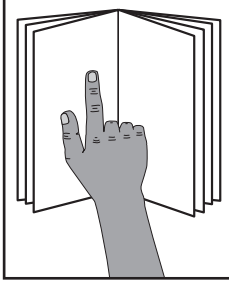
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size.....12 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

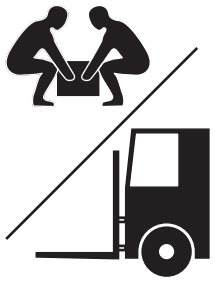


⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Safety Glasses (for each person)	1
• Lifting Straps w/Hooks (Rated for at least 400 lbs.)	2
• Lifting Equipment (Rated for at least 400 lbs.)	1
• Open-End Wrench 12mm	1
• Straightedge 36"	1

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. *You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.*

Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Main Inventory (Figure 8)		Qty
A.	Machine	1
B.	Extension Tables	2
C.	Stand Braces	2
D.	Stand Legs	2
E.	T-Handle Socket Wrench ½"	1
F.	Extension Table Mounting Brackets	2
G.	Dust Port	1
H.	Control Box	1
I.	Rubber Feet	4
J.	Control Box Mounting Bracket	1

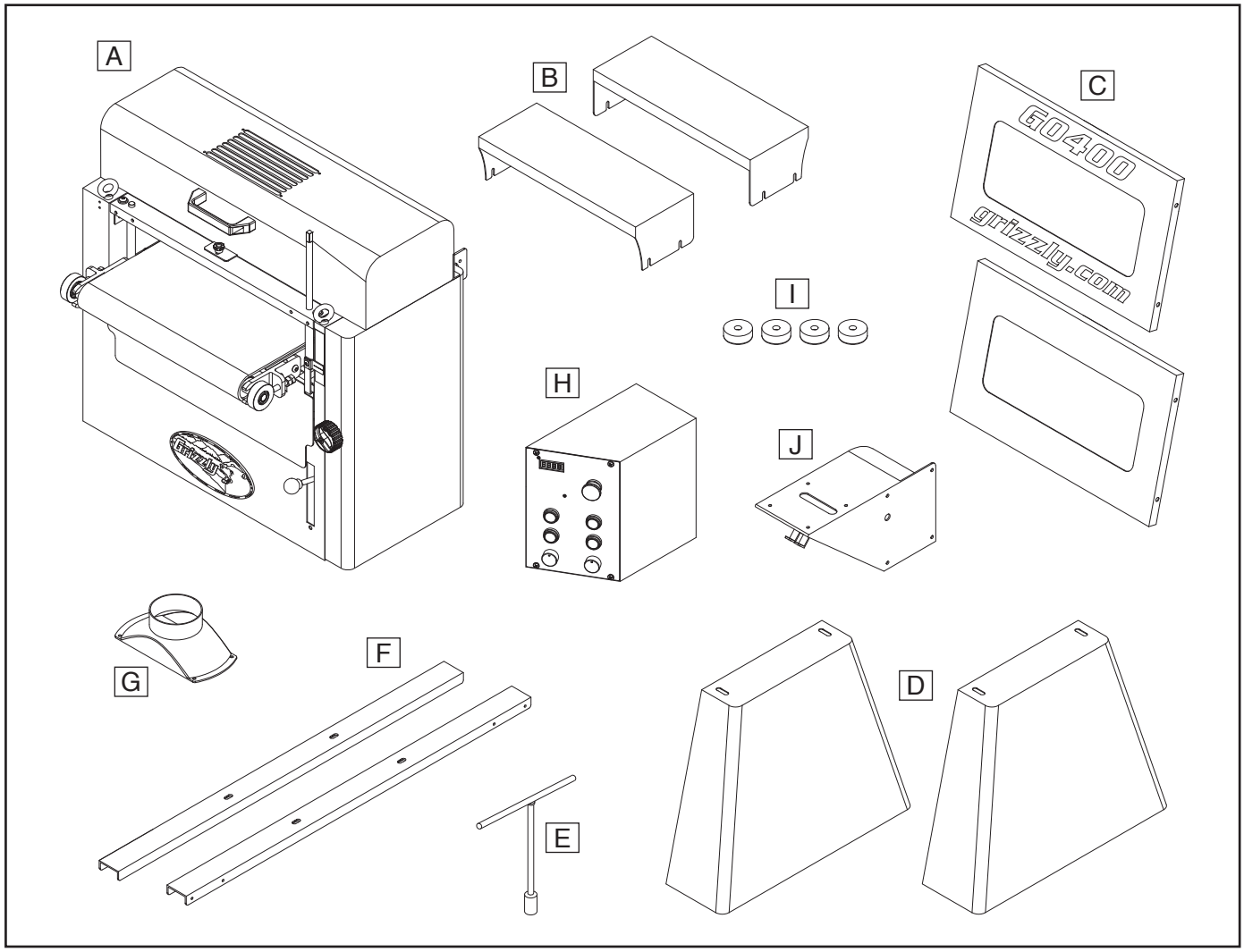


Figure 8. Main inventory.

Hardware (Figure 9) **Qty**

K. Table Height Crank..... 1
L. Table Height Crank Handle 1
M. Button Head Cap Screws M5-.8 x 8 (P0400129) 8
N. Button Head Cap Screws M6-1 x 8 (P0400619) 12
O. Button Head Cap Screws M8-1.25 x 16 (P0400314) 20
P. Flat Washers 8mm (P0400325) 12
Q. Lock Washers 8mm (P0400611) 4
R. Hex Nuts M8-1.25 (P0400305)..... 8
S. Open-End Wrench 13mm..... 1
T. Hex Wrenches 3, 4, 5, 6mm.....1 Ea.

NOTICE

If you cannot find an item on this list, 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.

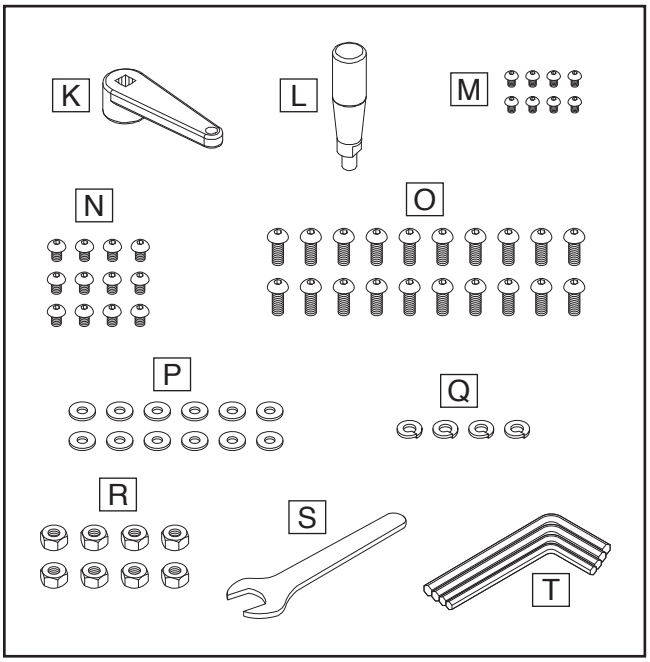


Figure 9. Hardware inventory.

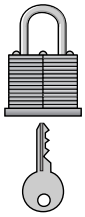
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

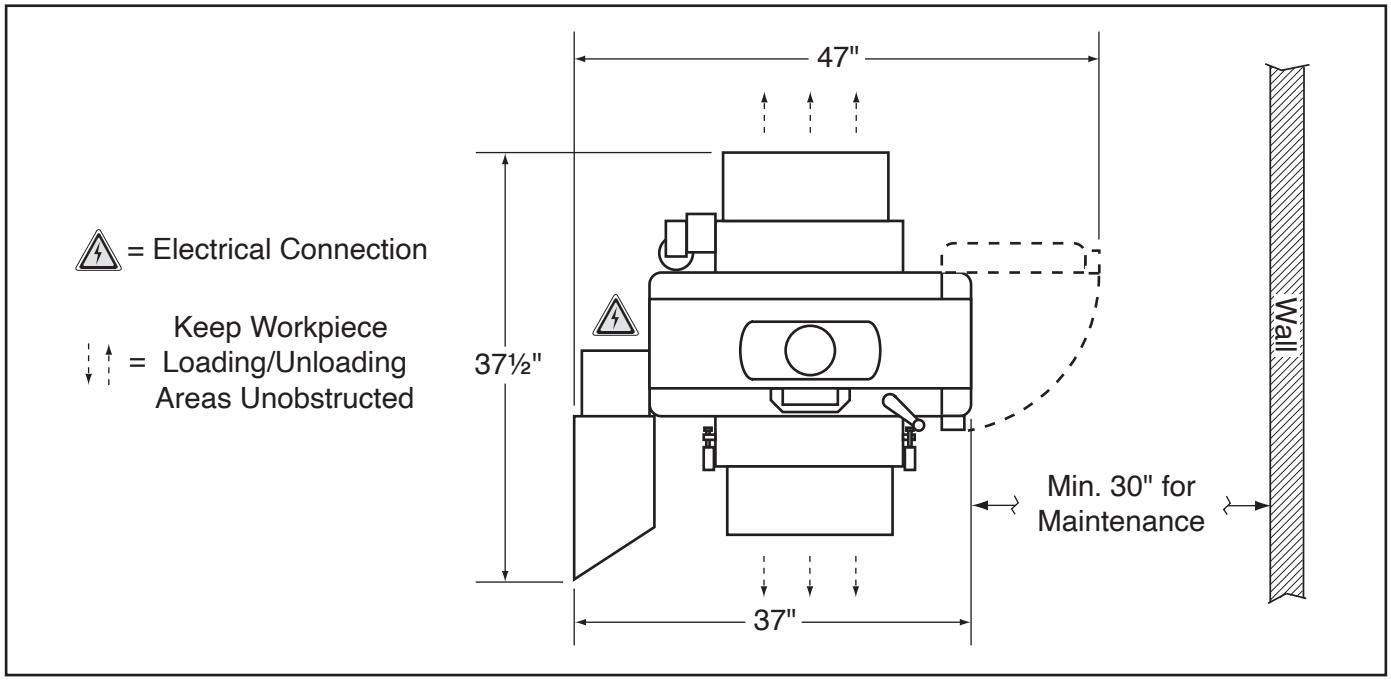


Figure 10. Minimum working clearances.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... ¼"

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly more quietly and feels more solid.

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you MUST follow the anchoring methodology specified by the code.

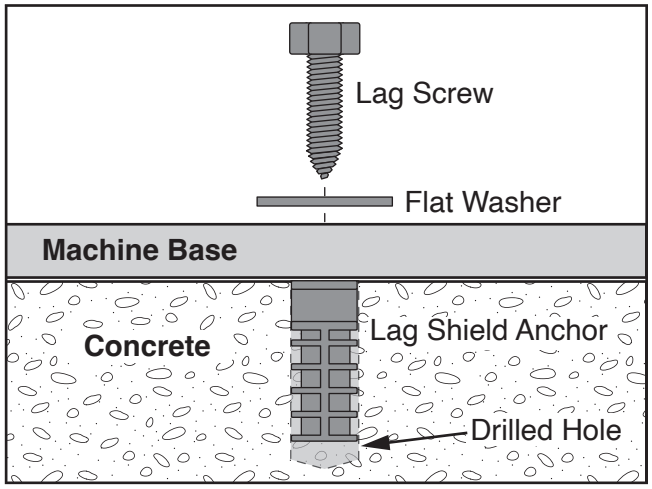


Figure 11. Popular method for anchoring machinery to a concrete floor.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

To assemble machine:

1. Attach (4) rubber feet to (2) stand legs with (4) M8-1.25 x 16 button head cap screws and 8mm flat washers (see **Figure 12**).

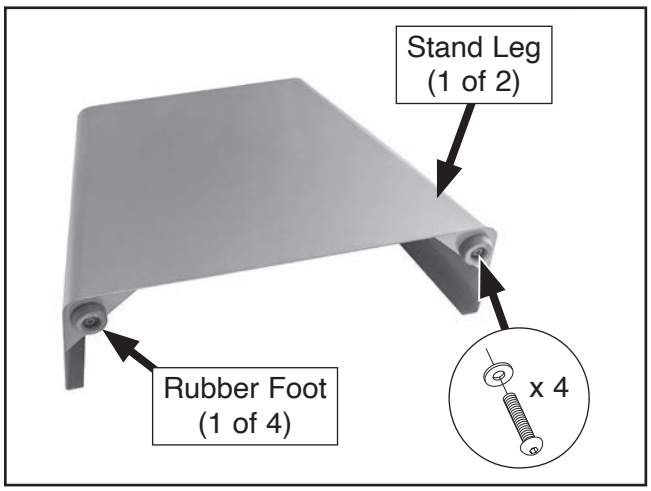


Figure 12. Rubber feet attached to stand leg.

2. Attach (2) stand braces to (1) stand leg with (4) M8-1.25 x 16 button head cap screws and M8-1.25 hex nuts, as shown in **Figure 13**.

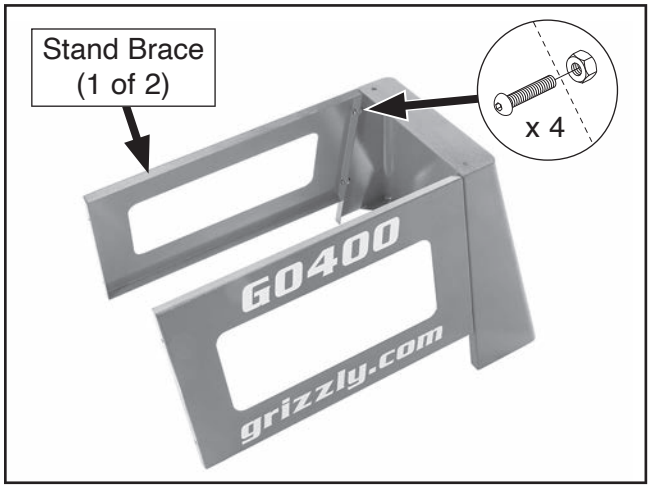


Figure 13. Stand braces attached to stand leg.

3. Attach remaining stand leg to other side of stand braces with (4) M8-1.25 x 16 button head cap screw and M8-1.25 hex nuts.

4. Place machine stand constructed in **Steps 1–3** in desired machine location.

   Note: *Stand brace with model number label will be front of machine.*

5. Attach control box mounting bracket to left side of machine with (4) M6-1 x 8 button head cap screws (see **Figure 14**).

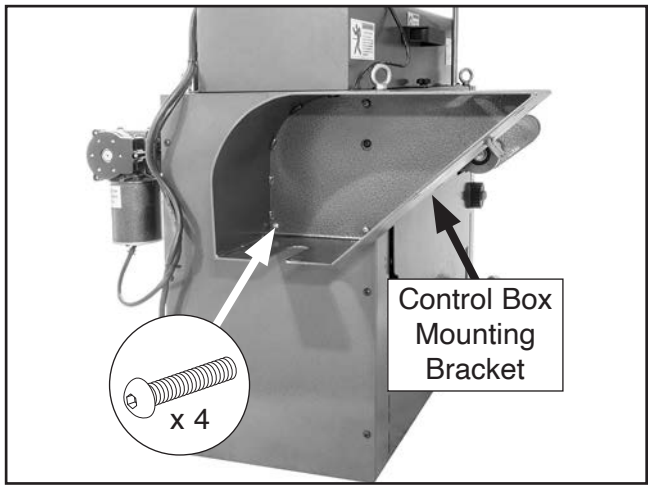


Figure 14. Example of control box mounting bracket attached to machine.

6. Attach control box to mounting bracket with (4) M5-.8 x 8 button head cap screws (see **Figure 15**).

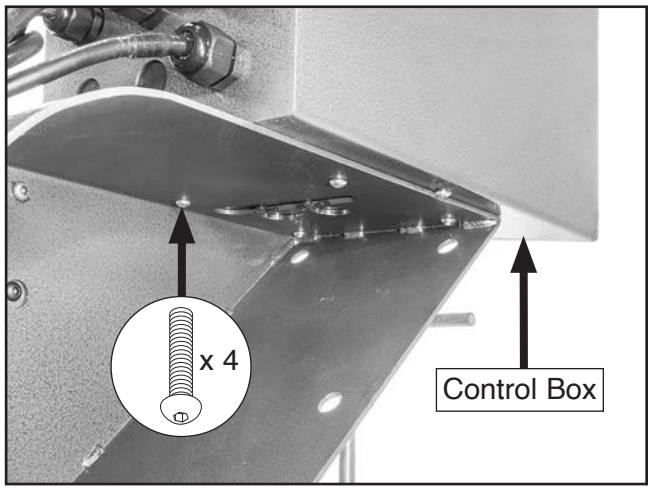


Figure 15. Control box attached to mounting bracket.

⚠WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

7. Attach (2) lifting straps with hook ends to (4) machine eye bolts shown in **Figure 16**, and attach straps securely to forklift or other power lifting equipment.

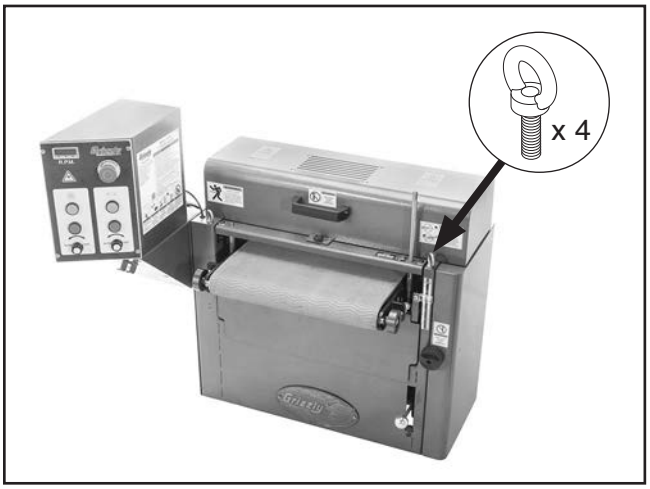


Figure 16. Location of machine eye bolts.

8. Remove bolts securing machine to pallet, then use lifting equipment to lift machine onto stand from **Step 4** (see **Figure 17**).

Figure 17. Machine lifted onto stand.

9. Attach machine to stand with (4) M8-1.25 x 16 button head cap screws and 8mm flat washers (see **Figure 18**), then remove lifting straps from machine.

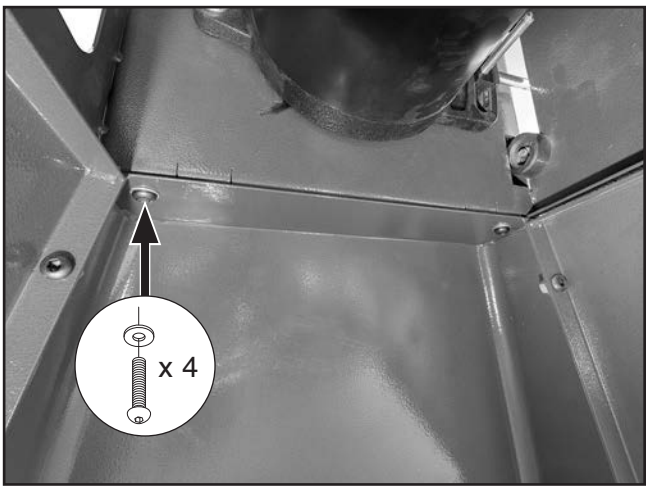


Figure 18. Machine attached to stand.

10. Place table height crank onto shaft shown in **Figure 19**, then thread table height crank handle into crank.

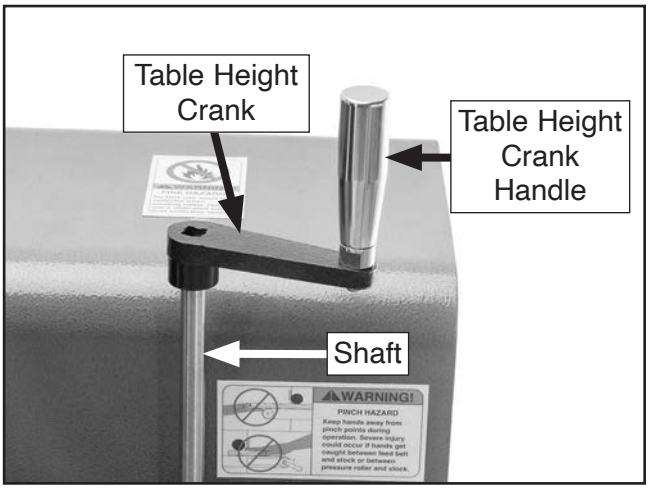


Figure 19. Table height crank and handle installed.

11. Loosen (2) conveyor brush lock knobs (see **Figure 20**).

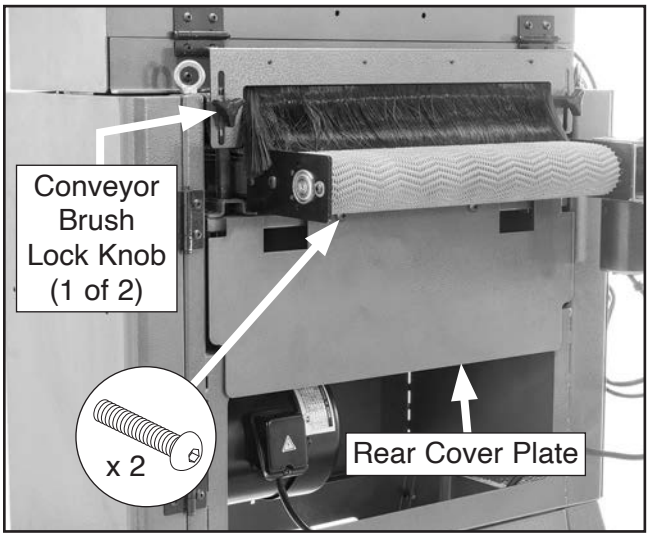


Figure 20. Location of conveyor brush lock knobs and cover plates (rear cover plate shown).

12. Turn table height crank clockwise to raise table as far as it will go.

13. Remove (2) button head cap screws shown in **Figure 20** to remove rear cover plate.

14. Repeat **Step 13** for front cover plate.

15. Attach (2) extension table mounting brackets to underside of conveyor table, as shown in **Figure 21**, with (4) M8-1.25 x 16 button head cap screws, 8mm lock washers, and 8mm flat washers.

Note: *Side holes in brackets must be oriented outward, as shown in* ***Figure 21****.*

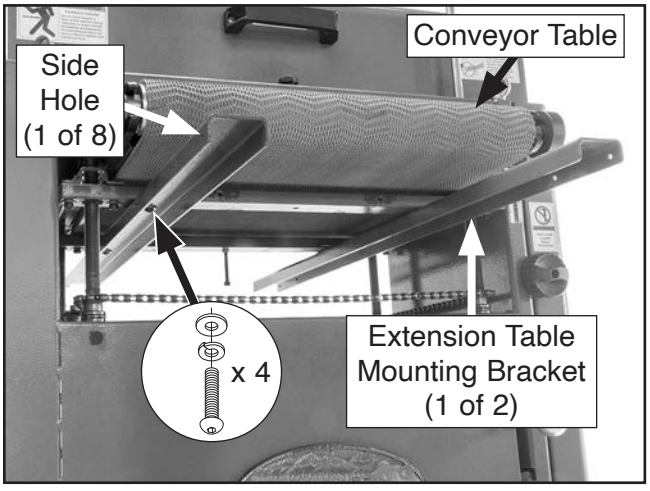


Figure 21. Extension table mounting brackets attached to conveyor table.

16. Install front and rear cover plates with button head cap screws removed in **Steps 13–14**.

17. Attach (2) extension tables to mounting brackets at front and rear of machine with (8) M6-1 x 8 button head cap screws (see **Figure 22**).

IMPORTANT: Ensure conveyor belt does not contact extension tables.

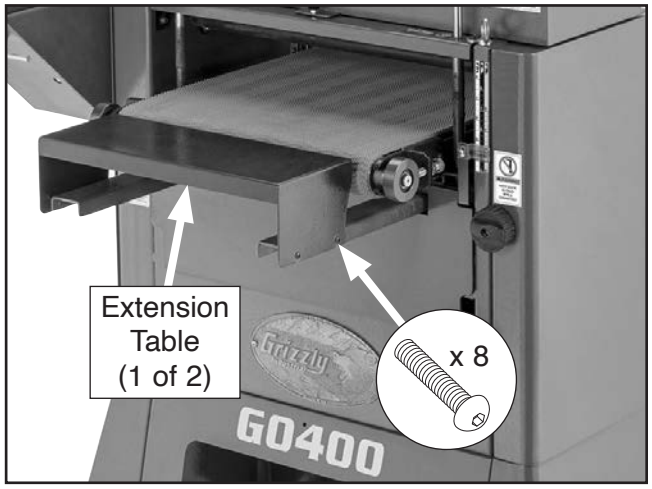


Figure 22. Extension tables attached to mounting brackets (front of machine shown).

18. Lower table enough so you can use straightedge to check extension table alignment with conveyor table (see **Figure 23**).

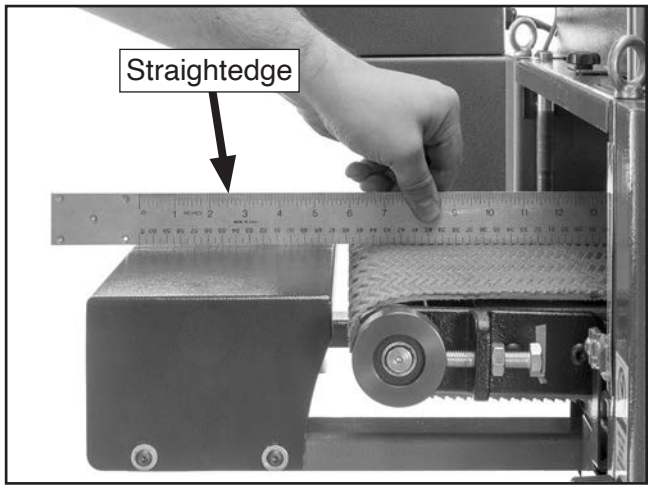


Figure 23. Checking extension table alignment.

— If straightedge is flat against conveyor table and both extension tables, no adjustment is required. Proceed to **Step 20**.

— If straightedge is *not* flat against conveyor table and both extension tables, proceed to **Step 19**.

19. For extension table(s) not aligned to conveyor table, loosen button head cap screws from **Step 17**, adjust table until it is aligned with conveyor table, then tighten screws to secure.

20. Attach dust port to top door with (4) M5-.8 x 8 button head cap screws (see **Figure 24**).

21. Place ½" T-handle socket wrench in holder shown in **Figure 24** for easy access.

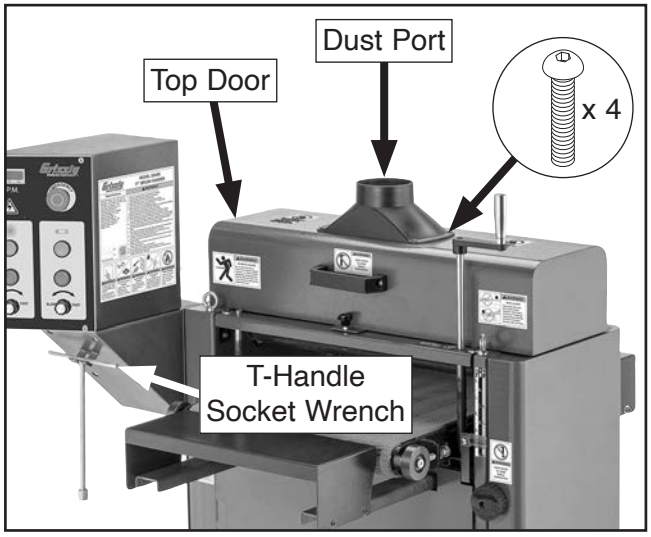


Figure 24. Dust port and T-handle socket wrench installed.

Dust Collection

⚠CAUTION

This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

Minimum CFM at Dust Port: 400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect dust collection system to machine:

1. Fit 4" dust hose over dust port, as shown in **Figure 25**, and secure in place with hose clamp.

Figure 25. Dust hose attached to dust port.

2. Tug hose to make sure it does not come off.

   Note: *A tight fit is necessary for proper performance.*

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

For issues concerning the VFD, refer to the Rhymebus RM6S2 series manual found at **https://www.rhymebus.com.tw/en**. All VFD servicing should be done by an authorized and trained technician. The VFD parameters have been set at the factory to optimize the performance of the machine and should not be adjusted unless instructed by Grizzly Tech Support. Improper adjustments can cause machine damage, disable important safety features, and may void the warranty.

The Test Run consists of verifying the following: 1) The motors power up and run correctly, 2) the EMERGENCY STOP button disables the machine properly, and 3) the door safety switches function correctly.

⚠WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

⚠WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.

2. Press EMERGENCY STOP button in (see **Figure 26**).

3. Turn sanding head speed dial and conveyor speed dial all the way counterclockwise (see **Figure 26**).

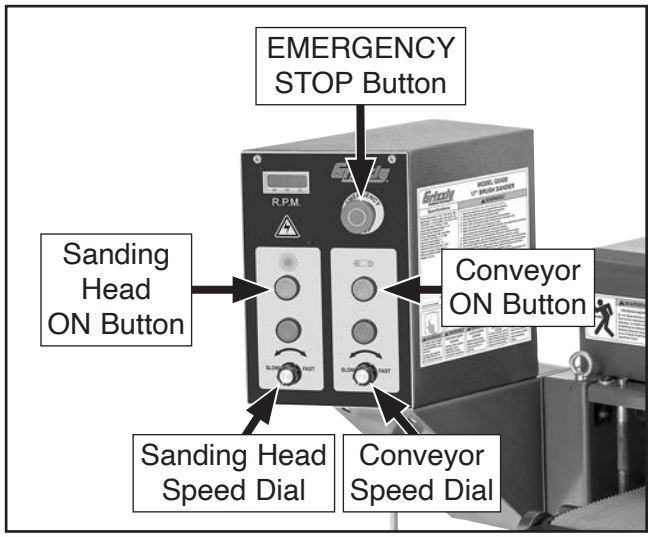


Figure 26. Control panel controls.

4. Connect machine to power.

5. Twist EMERGENCY STOP button clockwise until it springs out (see **Figure 27**). This resets button so machine can start. LED light inside machine will illuminate white.

Figure 27. Resetting button.

6. Press sanding head ON button and conveyor ON button (see **Figure 26**) to turn machine ***ON***. LED light will change to red/orange.

7. Verify sanding head motor operation by slowly turning sanding head speed dial clockwise. Rotate dial back and forth to test variable-speed function.

   Motor should run smoothly without any unusual problems or noises.

8. Repeat **Step 7** with conveyor speed dial to test feed motor operation.

9. Press EMERGENCY STOP button to turn machine ***OFF***.

10. WITHOUT resetting EMERGENCY STOP button, try to start machine by pressing sanding head ON button. Machine should not start.

    — If machine *does not* start, safety feature of EMERGENCY STOP button is working correctly.

    — If machine *does* start, immediately turn it ***OFF*** and disconnect power. Safety feature of EMERGENCY STOP button is NOT working properly and must be replaced before further using machine.

11. Reset EMERGENCY STOP button.

12. Remove knob shown in **Figure 28**, and open top door.

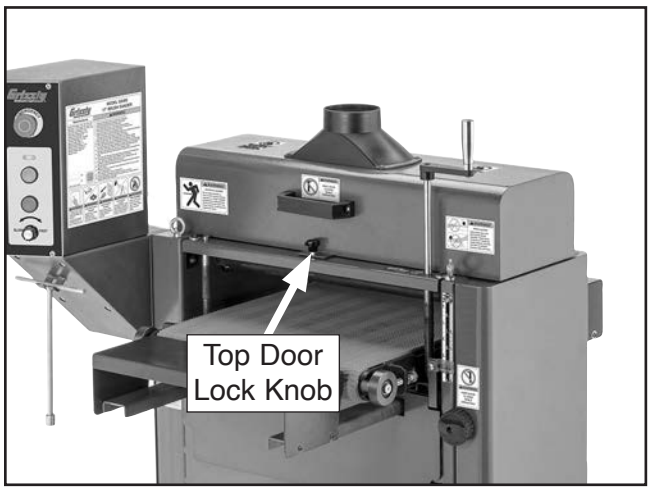


Figure 28. Location of top door lock knob.

13. While staying safely away from sanding head, press sanding head and conveyor ON buttons.

— If machine *does not* start, top door safety switch is working correctly. Proceed to **Step 14**.

— If machine *does* start, immediately turn it ***OFF*** and disconnect power. Top door safety switch is *not* working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

14. Close top door and secure with knob removed in **Step 12**.

15. Turn belt door lock knob clockwise to open belt door (see **Figure 29**).

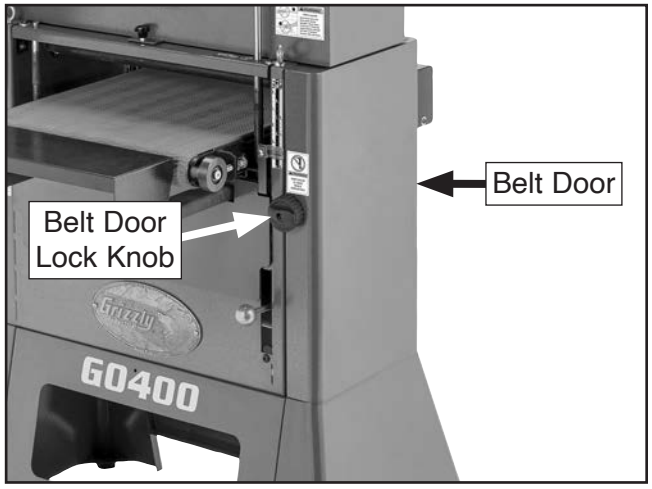


Figure 29. Location of belt door and lock knob.

16. While staying safely away from V-belt, press sanding head and conveyor ON buttons.

— If machine *does not* start, belt door safety switch is working correctly. Proceed to **Step 17**.

— If machine *does* start, immediately turn it ***OFF*** and disconnect power. Belt door safety switch is *not* working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

17. Close belt door and turn door lock knob counterclockwise to secure.

Congratulations! The Test Run is complete.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine. However, because of the many variables involved with shipping, some of these adjustments may need to be repeated to ensure optimum results.

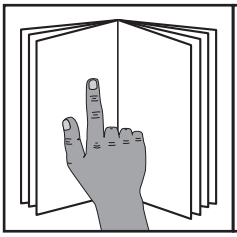
- **Tracking & Tensioning Conveyor Belt** (**Page 42**).
- **Aligning Pulleys** (**Page 50**).

SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

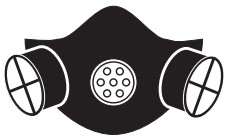


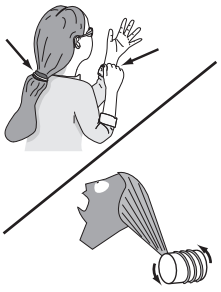
⚠WARNING

To reduce your risk of serious injury, read this entire manual BEFORE using machine.

⚠WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.





⚠WARNING

Keep hair, clothing, and jewelry away from moving parts at all times. Entanglement can result in death, amputation, or severe crushing injuries!

Typical Brush Sanding Operation

The Model G0400 comes with a 240-grit nylon brush head for brush sanding. There are also a number of other brush head accessories listed on **Page 27**.

To complete a typical brush sanding operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for sanding and to determine which brush head to use.
2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is overly long and difficult to handle, operator uses a roller support stand or additional person to assist with feeding.
3. Places workpiece on conveyor table under brush head and adjusts table height to desired brush penetration.
4. Removes workpiece from conveyor table.
5. Puts on safety glasses and respirator.
6. Starts dust collection system, then turns machine ***ON***.
7. Sets sanding head and conveyor speeds, as desired.
8. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.
9. Receives workpiece from outfeed side of conveyor table.
10. Turns machine and dust collection system ***OFF*** and disconnects machine from power.

Typical Drum Sanding Operation

If using the sanding drum accessory shown on **Page 28**, refer to the typical operation steps below.

To complete a typical drum sanding operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for sanding and to determine which sandpaper grit size to use.

2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is overly long and difficult to handle, operator uses a roller support stand or additional person to assist with feeding.

3. Adjusts table height to approximate workpiece thickness.

4. Puts on safety glasses and respirator.

5. Starts dust collection system, then turns machine ***ON***.

6. Sets sanding head and conveyor speeds, as desired.

7. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.

   Note: *During initial pass with a new workpiece, operator adjusts table height as necessary so workpiece only makes light contact with sandpaper and does not overload sander.*

8. Receives workpiece from outfeed side of conveyor table.

9. Raises table a small amount (typically ¼ of a full rotation of handwheel), then repeats **Steps 7–8** to feed workpiece through sander.

10. Turns machine and dust collection system ***OFF*** and disconnects machine from power.

Stock Inspection & Requirements

Some workpieces are not safe to sand, or may require further preparation before they can be safely sanded without increasing the risk of injury to the operator or damaging the brush head, drum sandpaper, or the sander.

Before sanding, inspect all workpieces for the following:

- ***Material Type:*** This machine is intended for sanding natural wood, lacquered wood, wood veneers, man-made wood products, laminate-covered wood products, and metal, provided the correct brush head or drum is installed. This machine is NOT designed to sand glass, stone, tile, plastics, drywall, cementitious backer board, etc.

  Sanding metal objects can increase risk of fire. Sanding improper materials increases risk of respiratory harm to operator and bystanders due to especially fine dust inherently created by all type of sanding operations—even if dust collector is used. Additionally, life of machine and brush heads/drums may be greatly reduced (or immediately damaged) from sanding improper materials.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding with drum, these objects can become dislodged and tear sandpaper. Protruding objects can damage conveyor belt and brush heads. Always visually inspect workpiece for these items.

- ***Wet or "Green" Stock:*** Sanding wood with moisture content over 20% increases risk of kickback. Wet stock causes unnecessary clogging and wear on flatter brush heads and sandpaper, and yields poor results. Wet stock can rust wire steel brush head.

- ***Oiled Metal Stock:*** Metal workpieces are often coated with lubricant to prevent rust. Introducing oil to conveyor belt increases risk of kickback. Clean metal workpiece and allow it to dry before attempting to sand.

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

- ***Wedges:*** Workpieces that are tapered along their length (i.e., thickness is thicker on one end than the other) can be brush sanded, but they greatly increase risk of kickback and will likely bog down machine. NEVER feed small end of tapered workpiece into machine first—large end must be fed first. NEVER attempt to sand wedge shapes with sanding drum installed.

Sanding Tips

- DO NOT edge sand workpieces. This can cause workpieces to kickback, causing serious personal injury. Edge sanding workpieces also can cause damage to conveyor belt and brush head or sandpaper.

- DO NOT sand more than one workpiece at a time side by side. Minor variations in thickness can cause one workpiece to be propelled by rapidly spinning brush head or drum and ejected from machine.

- NEVER stand directly in front of infeed area of machine. Failure to do so could result in severe personal injury.

- Do not switch from sanding wood to metal, or between metal types, without thoroughly cleaning machine to prevent fire.

- DO NOT brush sand workpieces that are less than 10" long or less than 1/32" thick to prevent damage to workpiece and sander.

- DO NOT drum sand workpieces that are less than 10" long or less than 1/8" thick to prevent damage to workpiece and sander.

- Replace coarse grit brush heads or sandpaper with finer grit to achieve smoother finish.

- Sanding workpieces with high-resin content or with applied finishes can quickly contaminate drum sandpaper/flatter brush strips beyond point where they can be properly cleaned. This will produce poor sanding results. In this case, use different workpiece, remove applied finishes, or frequently clean/replace sandpaper strips.

- When drum sanding, raise conveyor table a maximum of 1/4 turn of handwheel until workpiece is desired thickness. When drum sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When drum moves from sanding wide surface to sanding narrow surface, load on motor will be reduced, and drum will speed up, causing a gouge.

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

- Feed workpieces into sander at different places on conveyor to maximize brush head and sandpaper life and to prevent uneven conveyor belt wear.

- Extend life of sandpaper or flatter brush strips by regularly using PRO-STIK® sanding pad (see **Page 36**).

- When sanding workpieces with a bow or crown, place high point up or cupped side down to prevent workpiece from rocking and take very light passes.

- Feed workpiece at an angle to maximize stock removal and sanding effectiveness, but feed workpiece straight to reduce grit scratches for finish passes.

- Overloading motors or pushing sander to failure weakens electrical system. Repeatedly doing so is abuse to machine that will cause electrical damage, which is not covered under warranty.

Choosing Sanding Heads

The Model G0400 is designed for 5"–8" diameter brush heads and a 5" diameter sanding drum. We offer three different types of brush heads: flatter, nylon, and steel wire. For information regarding what sandpaper to use with the sanding drum, refer to **Choosing Sandpaper for Sanding Drum** on **Page 28**.

Flatter and nylon brush heads come in a number of different grit sizes. Coarser brush head grits prep workpieces by smoothing profiles, removing defects, and accentuating wood grain. Finer grits refine edges and contours for finishing.

Use flatter brush heads (see **Figure 30**) on flat or contoured workpieces to smooth imperfections, restore molding, or prepare surfaces for finishing. These brushes leave a uniform finish that mimics hand sanding.

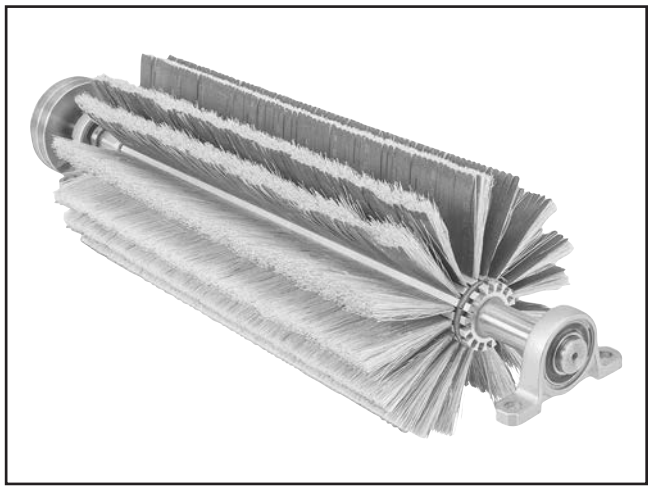


Figure 30. Example of flatter brush head.

The fingers on flatter brush heads are organized in separate rows that can be replaced individually. This keeps you from needing to replace the entire brush head in the case of uneven wear or damage. This also provides the option to remove half of the 16 rows to increase the depth of sanding and decrease the amount of consumables being used.

Nylon brush heads (see **Figure 31**) are more aggressive than flatter brush heads, and remove material quicker. They refresh surfaces and accentuate the natural wood grain by removing softer summer wood.

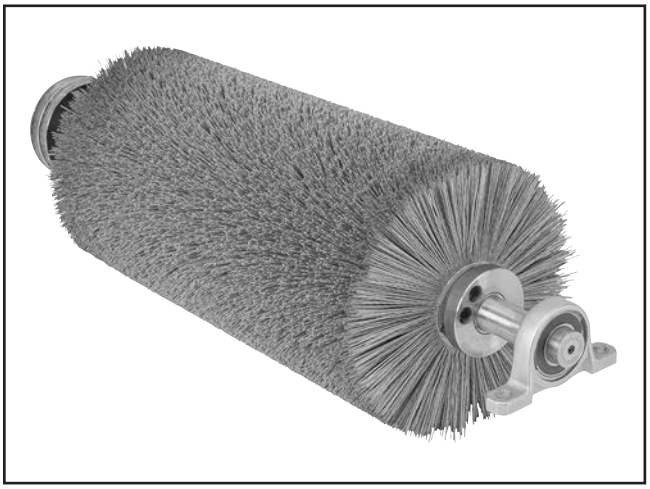


Figure 31. Example of nylon brush head.

The steel wire brush head (see **Figure 32**) produces the most aggressive results. When used with wood, the steel wire brush head gives wood texture, reclaims old wood, and removes paint or varnish. When used with metal, the brush head creates a brushed finish, cleans up welds and rust, removes coatings, and removes surface imperfections.

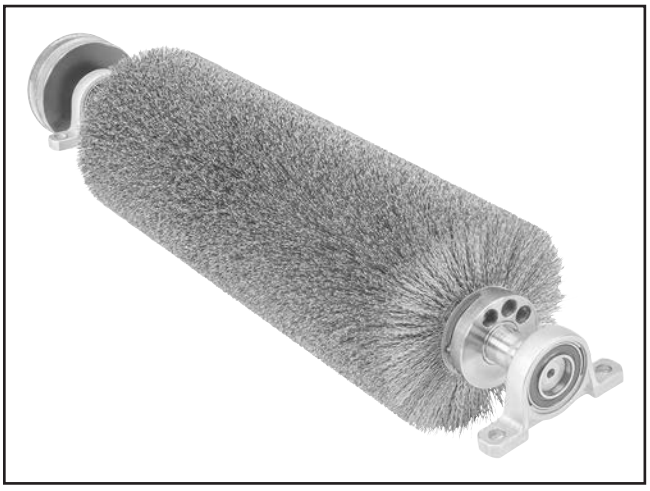


Figure 32. Steel wire brush head.

Choosing Sandpaper for Sanding Drum

There are many types of sandpaper to choose from for the optional Model T34388 5" sanding drum accessory (see **Figure 33**).

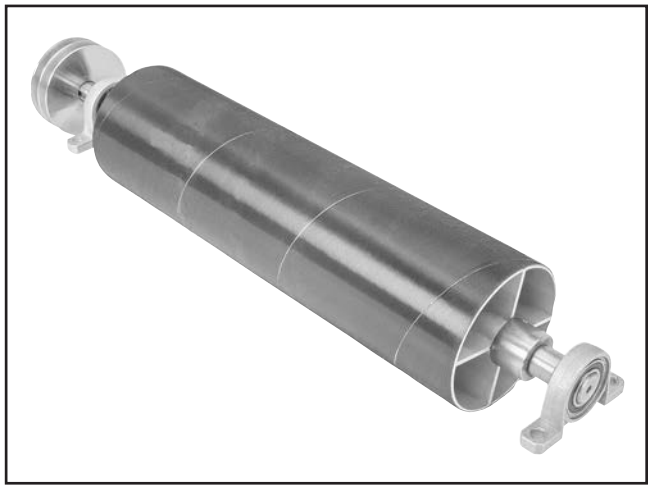


Figure 33. T34388 5" Sanding Drum.

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	Class	Usage
60	Coarse	Fast sanding and glue removal.
80–100	Medium	Removing planer marks and initial finish sanding.
120–180	Fine	Finish sanding.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers, with no one grit increase of more than 50. Avoid skipping grits; the larger the grit increase, the harder it will be to remove the scratches from the previous grit.

Ultimately, the type of wood you use and your stage of finish will determine the best grit types to install on your sander.

Changing Sanding Head

Refer to **Choosing Sanding Heads** on **Page 27** or **Choosing Sandpaper for Sanding Drum** to determine the best sanding head and abrasive grit for your operation. To change the installed sanding head, use the steps below.

Tool Needed	Qty
Wrench or Socket ½"	1

To change sanding head:

1. DISCONNECT MACHINE FROM POWER!

2. Turn belt door lock knob clockwise to open belt door (see **Figure 34**).

3. Remove knob bolt shown in **Figure 34** and open top door.

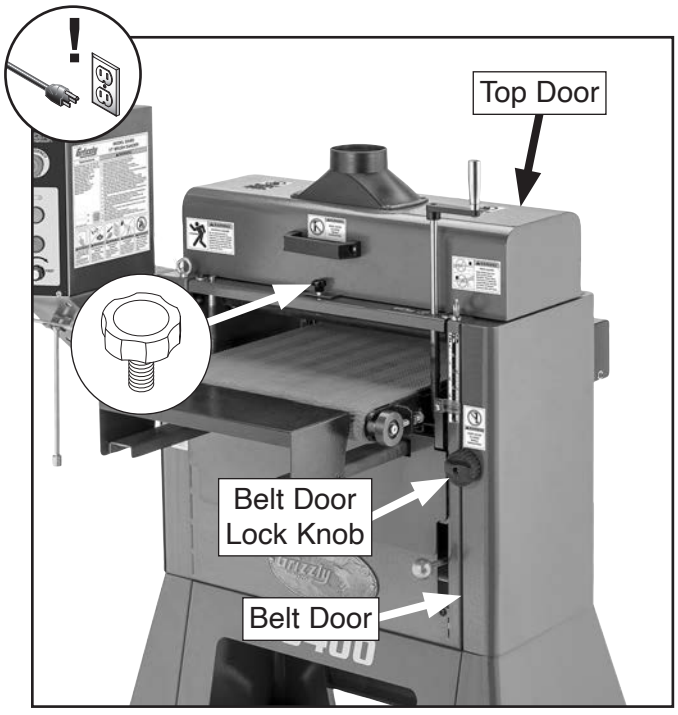


Figure 34. Belt and top door components.

4. Loosen belt tension lock knob, then lift belt tension lever to release V-belt tension (see **Figure 35**).

5. Remove V-belts from sanding head and motor pulleys (see **Figure 35**).

   — If either V-belt is cracked, torn, excessively worn, or damaged, replace V-belts as a matched set.

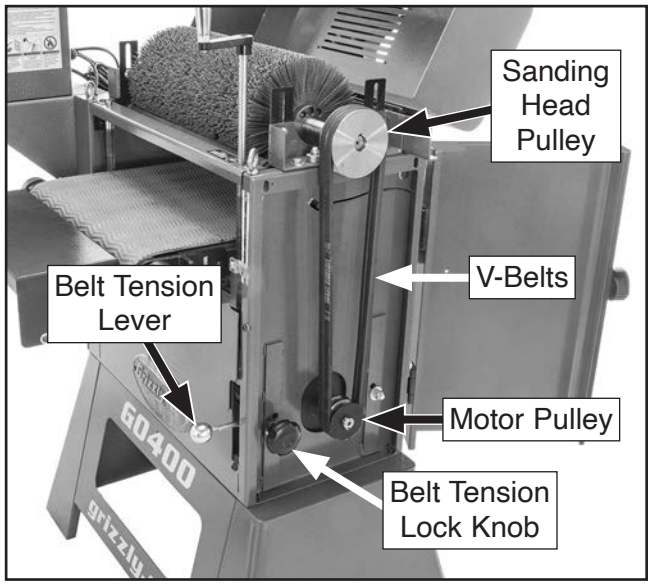


Figure 35. V-belt tension components.

6. Remove (4) acorn nuts securing sanding head to machine frame (see **Figure 36**).

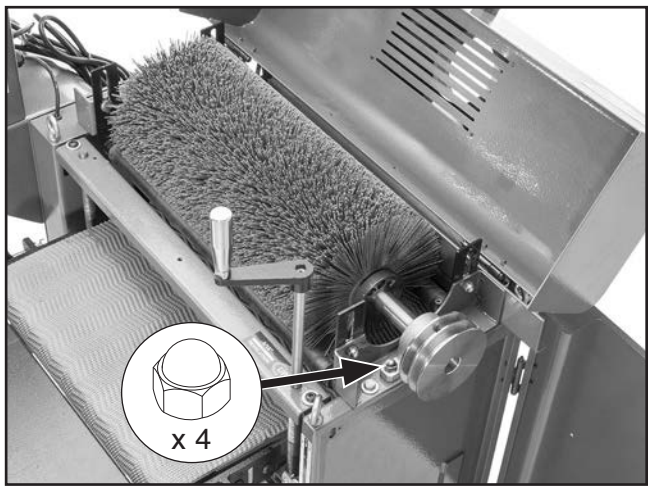


Figure 36. Location of sanding head acorn nuts.

7. Replace sanding head with desired sanding head.

8. Secure new sanding head to machine frame with (4) acorn nuts removed in **Step 6**.

9. Check pulley alignment (see **Aligning Pulleys** on **Page 50**).

10. Install V-belts on pulleys.

11. Move belt tension lever down, then tighten belt tension knob to secure.

    Note: *Correct V-belt tension is set if belts deflect ¼" when pressure is applied at mid-point of belts between pulleys (see **Figure 37**).*

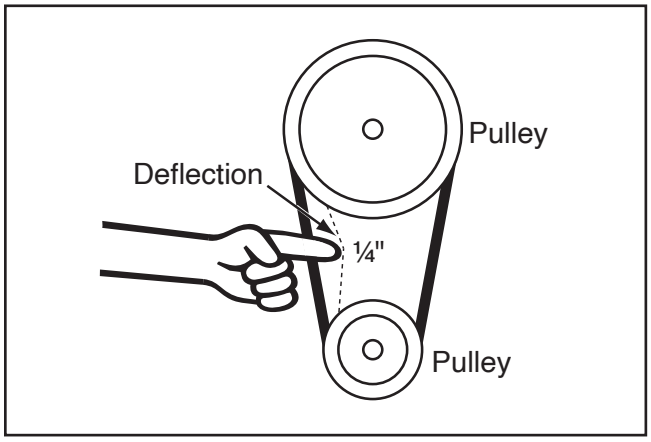


Figure 37. Checking belt tension.

   — If either V-belt has more than ¼" deflection when lever is moved fully down, replace V-belts as a matched set.

12. Close and secure belt door.

13. Adjust pressure rollers before proceeding with operation. Proceed to **Adjusting Table Height** on **Page 30**.

Adjusting Table Height

The conveyor table height, controlled by the table height crank (see **Figure 38**), determines how much stock is removed during a single pass.

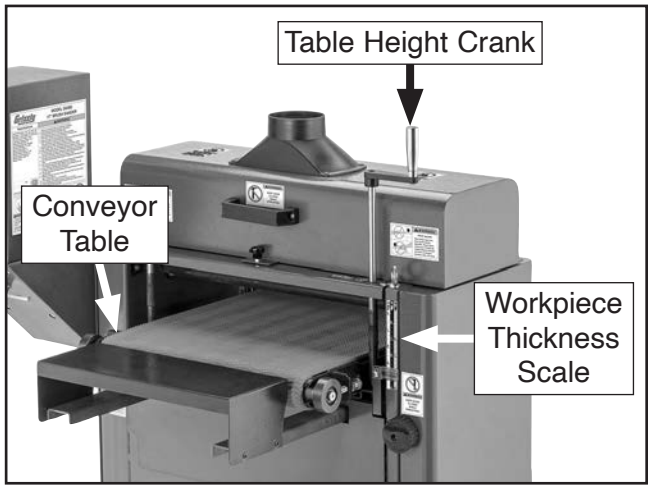


Figure 38. Table height components.

When a sanding drum is installed, this is called the "depth of cut," because the drum is sanding a consistent depth across the workpiece, parallel to the conveyor table.

When a brush head is installed, the results more closely resemble what is achieved through hand sanding, and is referred to as "brush penetration." The table is adjusted up until the brush fingers/bristles press against the workpiece to the desired degree. A higher brush penetration will remove larger imperfections, reveal more wood grain, and remove thicker varnish or other coatings.

The workpiece thickness scale (see **Figure 38**) can be used as a reference to set the table height for both drum and brush sanding operations, but it is not meant for exact thickness adjustments.

The white scale indicates the distance between the conveyor table and the surface of a 5" sanding drum or the bristles of a 5" brush head. The black scale indicates the distance between the conveyor table and the bristles of a 6" brush head. The yellow scale indicates the distance between the conveyor table and the bristles of an 8" brush head.

Depth of Cut (Drum Sanding Only)

The optimum depth of cut will vary based on the type of wood, feed rate, and sandpaper grit. Attempts to remove too much material can cause jamming, wood burning, rapid paper wear or tearing, poor finish, and belt slippage.

Generally, a ¼ turn of the table height crank (1/64" or 0.4mm vertical movement) per pass is acceptable for coarser grit or softer woods. A ⅛ turn of the crank is recommended for finer grits or harder woods. However, use your best judgement to produce good sanding results for your operation.

NOTICE

Taking excessive depth of cut could overload main motor. If this should happen, disconnect machine from power, allow motor to cool, then take smaller depth of cut.

Tool Needed	Qty
Wrench or Socket ½"	1

To set depth of cut:

1. DISCONNECT MACHINE FROM POWER!
2. Install sanding drum (see **Changing Sanding Head** on **Page 28**).
3. Connect machine to power.
4. Loosen (4) pressure roller acorn nuts (see **Figures 39–40**).

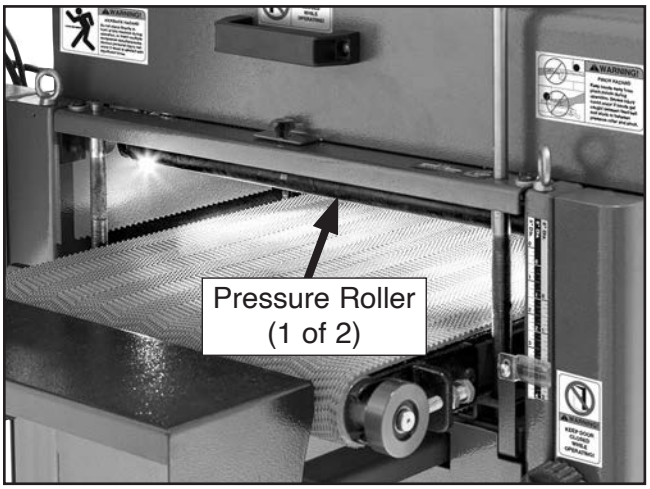


Figure 39. Location of pressure rollers.

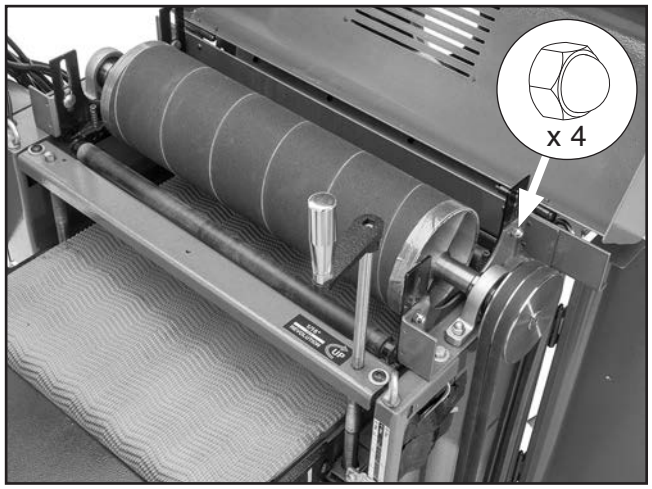


Figure 40. Location of pressure roller acorn nuts.

5. Place workpiece on conveyor table, under installed brush head and pressure rollers.

6. Use table height crank to adjust conveyor table until workpiece *just* contacts sanding drum (and white workpiece thickness scale displays workpiece thickness).

   Note: *When adjusting table to sand workpiece, lower and then raise table to remove backlash from adjustment mechanism.*

7. Turn table height crank counterclockwise (2) full turns, tighten (4) pressure roller acorn nuts from **Step 4**, then turn table height crank clockwise (2) full turns. This sets correct pressure roller height for your workpiece.

8. Close and secure top door.

9. Move workpiece to front of conveyor table.

10. Start sanding drum, then conveyor, and slowly feed workpiece into sander. SLOWLY raise conveyor table until workpiece makes light contact with sanding drum. This is correct height to begin sanding workpiece.

Brush Penetration (Brush Sanding Only)

The optimum brush penetration will vary based on the type of wood, the feed rate, and the installed brush head.

Generally, 1/8"–3/4" of brush penetration is acceptable when a flatter brush head is installed, 0"–3/4" is acceptable for a nylon brush head, and 0"–1/4" is acceptable for a wire brush head. However, use a test workpiece and your best judgement to determine which brush penetration produces the desired results for your operation.

Tool Needed	**Qty**
Wrench or Socket 1/2"	1

To set brush penetration:

1. DISCONNECT MACHINE FROM POWER!

2. Install desired brush head (see **Changing Sanding Head** on **Page 28**).

3. Connect machine to power.

4. Loosen (4) pressure roller acorn nuts (see **Figures 41–42**).

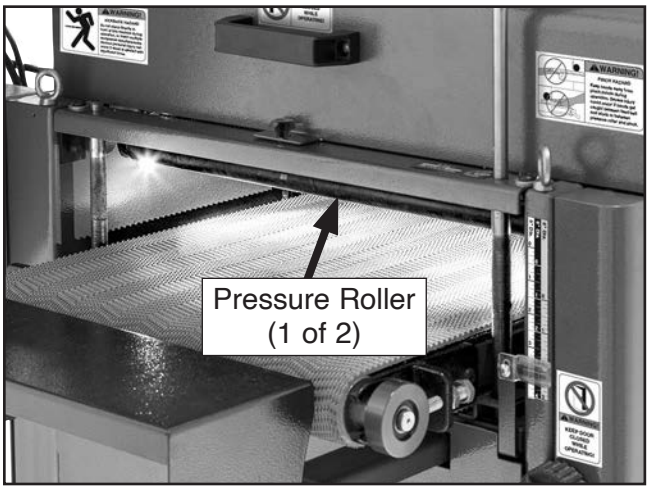


Figure 41. Location of pressure rollers.

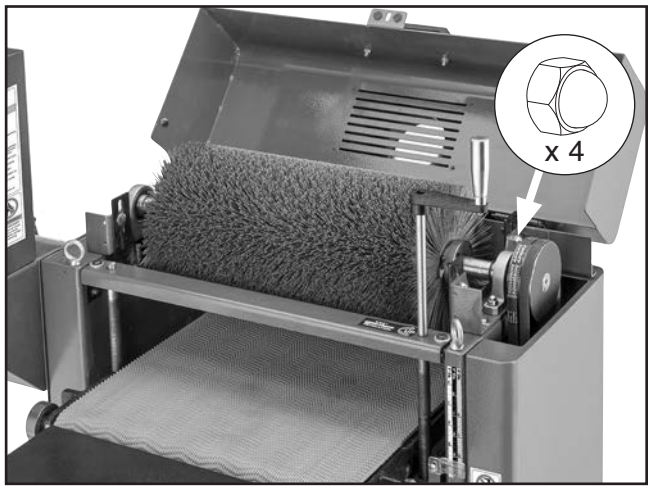


Figure 42. Location of pressure roller acorn nuts.

5. Place workpiece on conveyor table, under installed brush head and pressure rollers.

6. Use table height crank to adjust conveyor table until workpiece *just* contacts brush bristles (and workpiece thickness scale displays workpiece thickness for diameter of installed brush head).

   Note: *When adjusting table to sand workpiece, lower and then raise table to remove backlash from adjustment mechanism.*

7. Adjust table height crank until brush bristles press against workpiece with desired brush penetration. Each revolution of crank is equal to 1/16" of table movement.

8. Turn table height crank counterclockwise (2) full turns, tighten (4) pressure roller acorn nuts from **Step 4**, then turn table height crank clockwise (2) full turns. This sets correct pressure roller height for your workpiece.

9. Close and secure top door.

10. Remove workpiece from conveyor table and proceed with sanding operation.

Adjusting Sanding Head Speed

The sanding head speed dial (see **Figure 43**) allows you to adjust the sanding head from 400–1700 RPM. The current speed is displayed in the speed digital readout (see **Figure 43**).

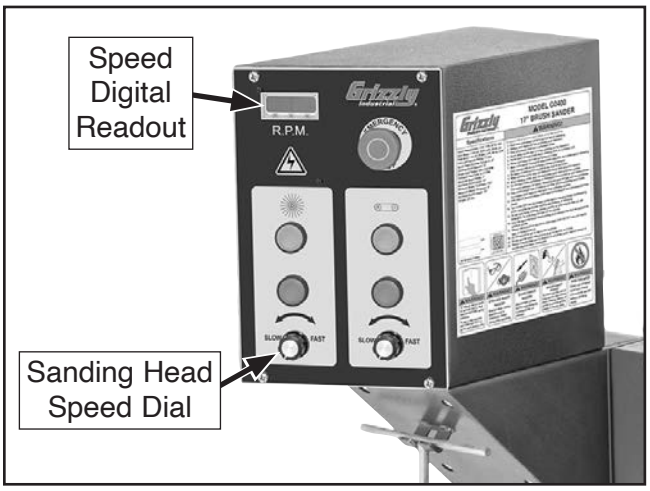


Figure 43. Location of sanding head speed dial and speed digital readout.

To adjust sanding head speed:

1. Start sanding head.

2. Rotate sanding head speed dial (see **Figure 43**) *clockwise* to increase sanding head speed or *counterclockwise* to decrease sanding head speed.

Adjusting Conveyor Feed Rate

The conveyor speed dial (see **Figure 44**) allows you to adjust the feed rate from 4–17 FPM. The correct speed to use depends on the type of stock you are sanding (hardwood vs. softwood), the stage of finish with the workpiece, and the depth of cut/brush penetration.

Figure 44. Location of conveyor speed dial.

At a given sanding head speed, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove a greater area of material faster, but runs the risk of overloading the motor or damaging the sandpaper/bristles.

Use trial-and-error to determine the best setting for your specific application.

To adjust conveyor feed rate:

1. Start conveyor belt.

2. Rotate conveyor speed dial (see **Figure 44**) *clockwise* to increase feed rate or *counter-clockwise* to decrease feed rate.

Replacing Flatter Brush Head Strip

To replace a row of fingers on a flatter brush head, use the following steps.

Items Needed	**Qty**
Hex Wrench 2.5mm	1
Pick or Screwdriver	1
Replacement Flatter Strip(s)	As Needed

To replace flatter brush head strip:

1. DISCONNECT MACHINE FROM POWER!

2. Remove sanding head from machine (see **Changing Sanding Head** on **Page 28**).

3. Place sanding head on flat, stable surface.

4. Loosen (2) inner race set screws (see **Figure 45**) on left pillow block bearing, then remove pillow block bearing assembly from shaft.

   Tip: *An external gear/bearing puller can help remove a stuck pillow block bearing.*

5. Use pick or screwdriver to carefully pry retaining spring out of its slot on brush head (see **Figure 45**).

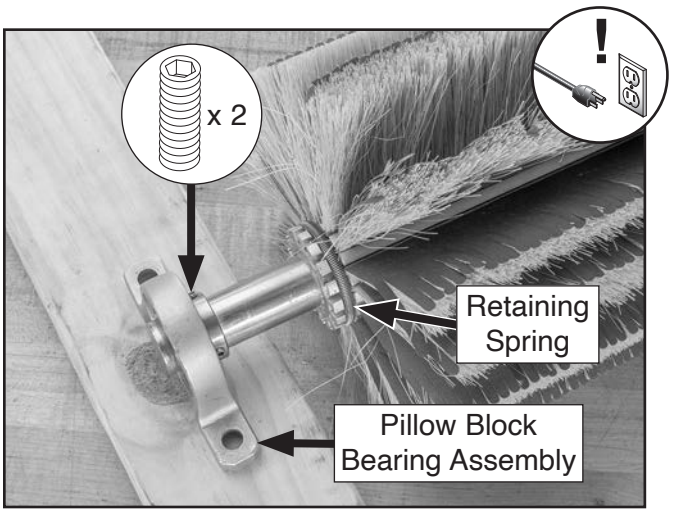


Figure 45. Flatter strip removal components.

6. Slide flatter brush strip out of slot (see **Figure 46**), then replace with new strip.

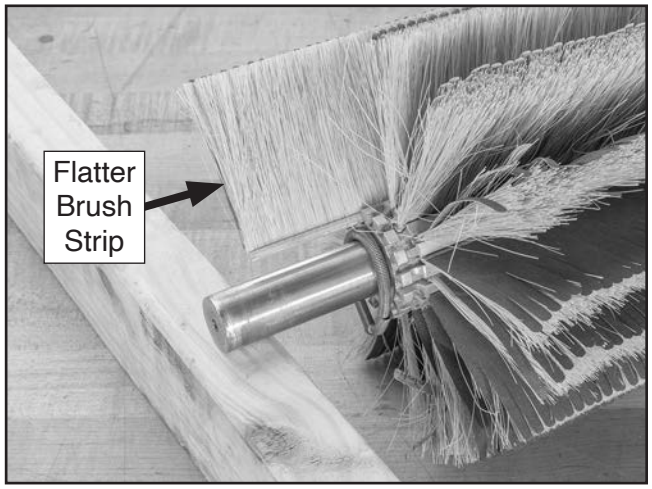


Figure 46. Sliding flatter brush strip out of slot.

7. Pry retaining spring back into slot.

8. Clean bore of left pillow block bearing assembly and sanding head shaft with cleaner/degreaser.

NOTICE

DO NOT hammer bearing assembly onto shaft, as you WILL damage these precision parts. Bearings and shaft are slip fit, but if bearing assembly will not slide onto shaft, a press can be used to press bearing assembly onto shaft.

9. After bearing bore and shaft are dry, slide bearing assembly back onto shaft.

   Note: *Side of bearing with inner race set screws should go on shaft first (see **Figure 45** on **Page 33**). Bearing position will be adjusted in following steps.*

10. Install sanding head on machine.

    Note: *Align right bearing assembly with right studs first, then move left bearing assembly on shaft as needed to align it with left studs (see **Figure 47**).*

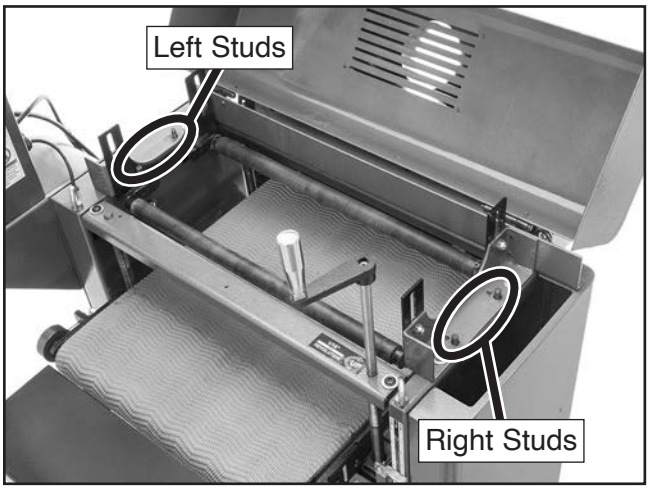


Figure 47. Location of right and left sanding head studs.

11. When left bearing assembly is aligned with studs, tighten bearing set screws to secure position.

12. Perform **Steps 8–13** of **Changing Sanding Head** section beginning on **Page 28**.

Installing/Replacing Drum Sandpaper

The Model T34388 sanding drum accessory is designed for 3" wide sandpaper rolls. See **ACCESSORIES** on **Page 36** for grit selection and model numbers.

Items Needed	**Qty**
Sandpaper Roll, Hook-and-Loop, 3" x 111"	1
Carton Cutter or Utility Knife	1
Strapping Tape ½"	As Needed

To install/replace drum sandpaper:

1. DISCONNECT MACHINE FROM POWER!

2. Install sanding drum (see **Changing Sanding Head** on **Page 28**).

   — If there is sandpaper on drum, proceed to **Step 3**.

   — If sandpaper is not yet installed on drum, proceed to **Step 5**.

3. Remove strapping tape from drum ends, grip end of sandpaper, then rotate drum to carefully remove old sandpaper (see **Figure 48**).

   Note: *Take care not to tear old sandpaper so it can be used as template for replacement.*

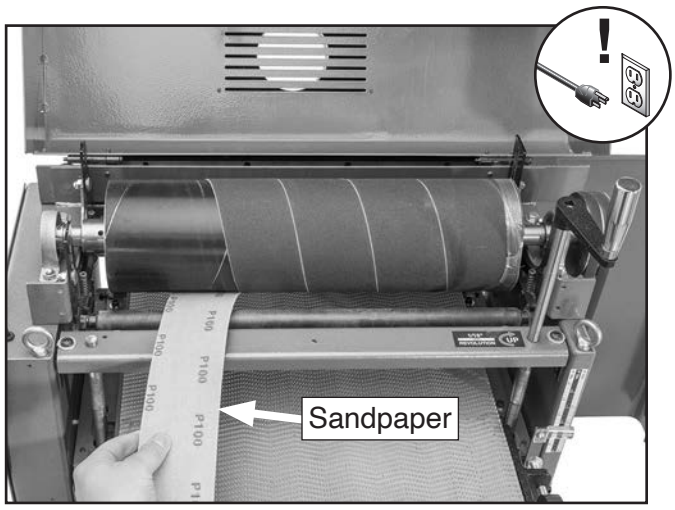


Figure 48. Example of removing old sandpaper.

4. Use old sandpaper strip as pattern to cut new sandpaper to fit drum.

   — If you can use old sandpaper as pattern, cut replacement sandpaper to size and proceed to **Step 6**.

   — If old sandpaper was torn, or cannot be used as pattern, proceed to **Step 5**.

5. Use pattern in **Figure 49** to cut new piece of sandpaper to necessary shape. Cut 111" of sandpaper from roll, then cut 15⅞" angled sides.

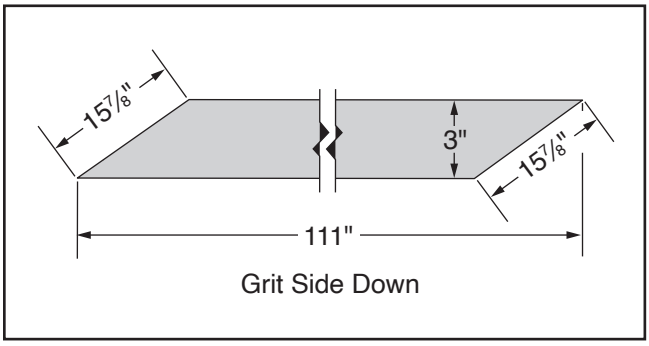


Figure 49. Sandpaper pattern for drum.

6. Align edge of sandpaper with drum, then carefully wrap sandpaper around drum (see **Figure 50**), ensuring there are no bubbles or overlapping edges.

7. When you have aligned trailing end of sandpaper with drum edge, tightly wrap 2–3 layers of strapping tape around ends of drum (see **Figure 50**) to secure ends of sandpaper.

   Note: *Drum is 18" long, allowing for a maximum board width of 17" when ends are taped.*

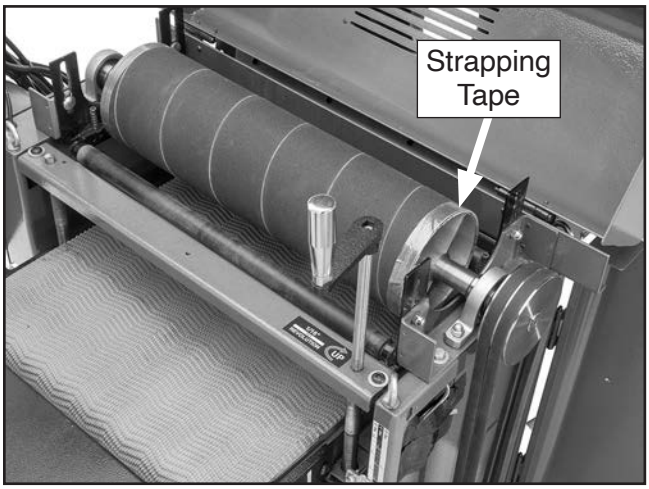


Figure 50. Example of sandpaper installed.

SECTION 5: ACCESSORIES

⚠WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

8" Flatter Brush Sanding Heads

T34377—150 Grit
T34378—180 Grit
T34379—240 Grit

Flatter Brush Strips (16-Pc.)

T34380—150 Grit
T34381—180 Grit
T34382—240 Grit

8" Nylon Brush Sanding Heads

T34383—80 Grit
T34384—120 Grit
T34385—180 Grit
T34386—240 Grit
T34387—320 Grit

5" Sanding Drum Head

T34388—18" Hook-and-Loop

6" Steel Brush Sanding Head

T34389—0.4mm Coppered Steel Wire

D3003—PRO-STIK® Cleaning Pad

Extend the life of your sandpaper or flatter brushes! Just feed this crepe-rubber cleaning pad through your sander to remove the dust build-up from the abrasive without damage. Measures 15" x 20" x ¾".

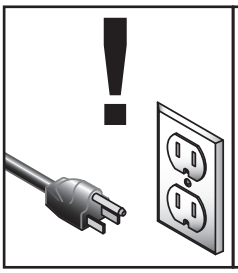
Figure 51. D3003 PRO-STIK® Cleaning Pad.

SB1365—South Bend Way Oil-ISO 68

Engineered for the high pressure exerted on horizontal or vertical ways and slides. Protects against rust and corrosion. Ensures stick-free, smooth motion which maximizes finishes and extends the life of your machine. 12 oz. AMGA#2 (ISO 68 Equivalent).

Figure 52. SB1365 Way Oil.

SECTION 6: MAINTENANCE



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing
To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Sandpaper or flatter strips loaded with material.
- Damaged sandpaper, flatter strips, bristles, or sanding head.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Maintenance
- Check V-belt for correct tension, damage, or wear.
- Clean/vacuum dust buildup from inside compartments and off motor.
- Clean and lubricate table height components.

Cleaning Machine

Cleaning the Model G0400 is relatively easy.

After sanding wood, wear protective safety glasses and a respirator to protect eyes and lungs against airborne dust while cleaning. Vacuum excess wood dust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

After sanding metal, wear protective gloves, safety goggles, and a respirator when cleaning the machine to protect hands against sharp metal shavings and protect against any airborne particles disturbed by cleaning. Allow shavings to cool, use a dedicated vacuum to collect excess shavings, and wipe off any remaining dust with a disposable cloth that has been wet with water. Never used compressed air to blow away dust—especially if indoors—as it will likely cause unnecessary dust to become airborne.

Thoroughly clean inside and outside of machine before switching material types in order to prevent fire and adverse chemical reactions.

⚠WARNING

Wear personal protective equipment while cleaning machine to prevent eye and lung injury.

Cleaning Sandpaper/ Flatter Brush Strips

Increase the working life of sandpaper or flatter brush strips by cleaning them whenever they decrease in performance due to heavy loading of material. Use a cleaning pad like the one shown in **Figure 51** on **Page 36**.

To clean sandpaper/flatter brush strips:

1. DISCONNECT MACHINE FROM POWER!
2. Set depth of cut or brush penetration.

   Note: *We recommend ¼" or less for depth of cut and ½" or less for brush penetration.*

3. Connect machine to power, then run pad through sander two or three times.

Lubrication

The bearings on the Model G0400 and the accessory sanding heads have been lubricated and sealed at the factory. No other care of these bearings is necessary unless they need replacement.

The table height components should be lubricated monthly. An essential part of lubrication is cleaning the components before lubricating them. This step is critical because dust builds up on lubricated components, which makes them hard to move. Simply adding more grease to built-up grime will not result in smooth-moving parts. Clean the table height components with a cleaner/degreaser or mineral spirits before applying lubrication.

Items Needed	Qty
Hex Wrench 4mm	1
Cleaner/Degreaser	As Needed
Disposable Rags	As Needed
Small Brushes	2
ISO 68 or Equivalent	As Needed

To lubricate table height components:

1. DISCONNECT MACHINE FROM POWER!
2. Raise table all the way.
3. Remove (4) button head cap screws shown in **Figure 53** to remove front and rear cover plates.

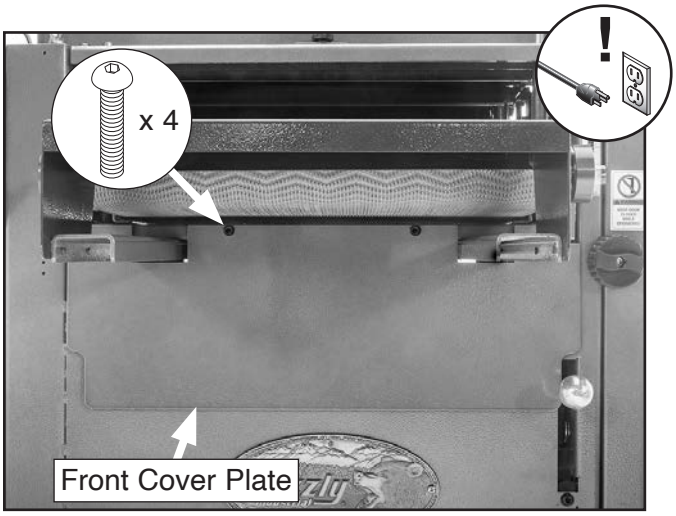


Figure 53. Location of cover plates and screws (front cover shown).

4. Clean chain, sprockets, and leadscrews (see **Figure 54**).

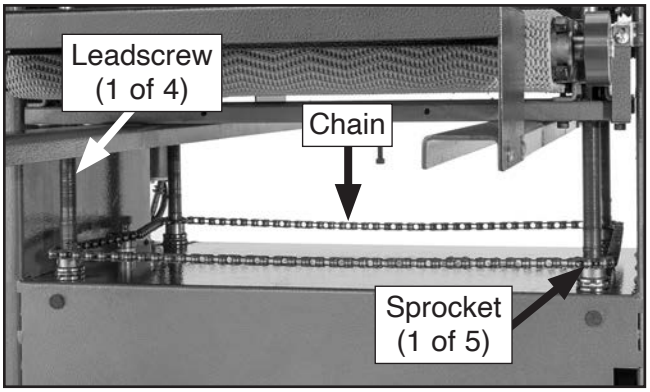


Figure 54. Location of chain, sprockets, and leadscrews.

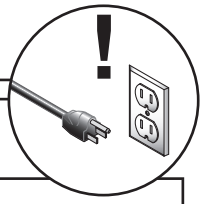
5. Use small brush to apply light machine oil to chain, sprockets, and leadscrews.
6. Install front and rear cover plates, then move table up and down to evenly distribute lubricant.

SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Use the table below for general troubleshooting of the Model G0400. For issues concerning the VFD, contact Rhymebus to obtain a RM6S2 series manual (or visit **https://www.rhymebus.com.tw/en**). All VFD servicing should be done by an authorized and trained technician. The VFD parameters have been set at the factory to optimize the performance of the machine and should not be adjusted unless instructed by Grizzly Tech Support. Improper adjustments can cause machine damage, disable important safety features, and may void the warranty.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. EMERGENCY STOP button depressed. 2. Top door open/limit switch engaged. 3. Belt door open/limit switch engaged. 4. Incorrect power supply voltage or circuit size. 5. Power supply circuit breaker tripped or fuse blown. 6. Motor wires connected incorrectly. 7. Wiring broken, disconnected, or corroded. 8. Motor or motor bearings at fault.	1. Rotate EMERGENCY STOP button head to reset. 2. Close door. 3. Close door. 4. Ensure correct power supply voltage and circuit size (**Page 11**). 5. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 6. Correct motor wiring connections (**Page 52**). 7. Fix broken wires or disconnected/corroded connections (**Page 52**). 8. Replace motor.
Machine stalls or is underpowered.	1. Motor wires connected incorrectly. 2. Motor overheated. 3. Extension cord too long. 4. Motor or motor bearings at fault.	1. Correct motor wiring connections (**Page 52**). 2. Clean motor, let cool, and reduce workload. 3. Move machine closer to power supply; use shorter extension cord (**Page 12**). 4. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor mount loose/broken. 3. Motor fan rubbing on fan cover. 4. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Tighten/replace. 3. Fix/replace fan cover; replace loose/damaged fan. 4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
LED does not illuminate.	1. Lens covered with dust. 2. Wiring broken, disconnected, or corroded.	1. Clean lens. 2. Fix broken wires or disconnected/corroded connections (**Page 52**).

Operation

Symptom	Possible Cause	Possible Solution
Vibration when sanding.	1. Stand feet loose or not installed properly. 2. Loose pillow block bearings. 3. Worn pillow block bearings. 4. V-belt(s) worn, loose, pulleys misaligned or belt slapping door. 5. Pulley loose.	1. Tighten/reinstall stand feet to stabilize machine. 2. Tighten pillow block bearings. 3. Replace pillow block bearings (**Page 47**). 4. Inspect/replace belt(s) with a new matched set (**Page 28**). Realign pulleys if necessary. 5. Secure pulley on shaft.
Grinding, screeching, or rubbing noise when sanding head is powered up.	1. Worn pillow block bearings.	1. Replace pillow block bearings (**Page 47**).
Abrasive clogs quickly.	1. Depth of cut/brush penetration too much or feed rate too slow. 2. Workpiece has high moisture content or sap. 3. Incorrect abrasive grit. 4. Poor dust collection. 5. Abrasive loaded with material or worn.	1. Reduce depth of cut/brush penetration (**Page 30**) or increase feed rate. 2. Use different stock, or accept characteristics of stock and plan on cleaning/replacing abrasive frequently. 3. Use correct grit for operation (**Page 27**/**Page 28**). 4. Unclog ducts; close gates to improve suction; re-design dust collection system. 5. Clean/replace abrasive.
Sanding drum sandpaper comes off drum (without tearing) or is loose.	1. Sandpaper not properly wrapped onto drum. 2. Sandpaper not cut to correct dimensions. 3. Slack in sanding strip. 4. Torn or damaged sandpaper. 5. Foreign object in workpiece. 6. Sandpaper not tightened/fastened correctly.	1. Re-install sandpaper (**Page 35**). 2. Use template to cut sandpaper to correct dimensions (**Page 35**). 3. Properly wrap sandpaper and make sure ends are fully secured by tape (**Page 35**). 4. Replace sandpaper (**Page 35**). 5. Sand only clean workpieces. 6. Re-install sandpaper (**Page 35**).
Sanding drum sandpaper tears off drum.	1. Sanding drum not parallel with table. 2. Sandpaper overlapping. 3. Depth of cut too much.	1. Adjust sanding drum parallel to table (**Page 45**). 2. Re-install sandpaper (**Page 35**). 3. Reduce depth of cut (**Page 30**).
Burn marks on workpiece.	1. Using too fine of grit for depth of cut/brush penetration. 2. Abrasive loaded with material. 3. Feed rate too slow. 4. Drum sanding with sandpaper installed incorrectly. 5. Abrasive worn or damaged.	1. Use coarser grit abrasive (**Page 27**/**Page 28**) or decrease depth of cut/brush penetration (**Page 30**). 2. Clean/replace abrasive. 3. Increase feed rate. 4. Re-install sandpaper (**Page 35**). 5. Replace abrasive.
Glazed workpiece surface after sanding.	1. Sanding wet stock. 2. Abrasive loaded with material. 3. Sanding stock with high amount of applied finishes. 4. Abrasive worn or damaged.	1. Only sand wood that has moisture content below 20%; do not sand wet metal. 2. Clean/replace abrasive. 3. Use different stock, or accept characteristics of stock and plan on cleaning/replacing abrasive frequently. 4. Replace abrasive.
Deep sanding groove or scar in workpiece.	1. Abrasive grit too coarse. 2. Workpiece sanded across grain. 3. Sanding depth of cut/brush penetration or feed rate too high. 4. Feed rate too low. 5. Sanding head speed too high.	1. Use finer grit abrasive (**Page 27**/**Page 28**). 2. Sand with grain. 3. Reduce depth of cut/brush penetration (**Page 30**) or reduce feed rate. 4. Increase feed rate. 5. Reduce sanding head speed.

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Workpiece slips on conveyor or kicks out.	1. Sanding depth of cut/brush penetration or feed rate too high. 2. Conveyor belt dirty, oily, or worn. 3. Pressure rollers not adjusted properly.	1. Reduce depth of cut/brush penetration (**Page 30**) or reduce feed rate. 2. Clean/replace conveyor belt (**Page 43**). 3. Properly adjust pressure roller height (**Page 28**).
Uneven workpiece thickness from side to side.	1. Sanding head not parallel to conveyor belt. 2. Conveyor belt worn.	1. Align sanding head to conveyor belt (**Page 45**). 2. Replace conveyor belt (**Page 43**).
Conveyor belt slips or does not track correctly.	1. Belt tension not properly adjusted. 2. Belt tracking not properly adjusted. 3. Conveyor belt loose or worn. 4. Workpiece too heavy.	1. Properly adjust belt tension (**Page 42**). 2. Properly adjust belt tracking (**Page 42**). 3. Properly tension (**Page 42**)/replace conveyor belt (**Page 43**). 4. Use lighter workpiece.
Machine lacks power; sanding head stops turning under load.	1. Workpiece material not suitable for machine. 2. V-belt(s) slipping/pulleys misaligned. 3. Pulley slipping on shaft. 4. Machine undersized for task. 5. Too much pressure on pressure rollers. 6. Too much pressure on sanding head.	1. Only sand wood or metal (**Page 25**). Ensure moisture content of wood is below 20%. 2. Clean/tension/replace belt(s) (**Page 28**); ensure pulleys are aligned (**Page 50**). 3. Tighten/replace loose pulley/shaft. 4. Clean/replace abrasive; reduce feed rate; reduce depth of cut/brush penetration (**Page 30**). 5. Reduce pressure roller pressure (**Page 28**). 6. Reduce depth of cut/brush penetration (**Page 30**).
Table height crank hard to rotate.	1. Leadscrews clogged with sawdust. 2. Chain tension too tight.	1. Clean and lubricate leadscrews (**Page 38**). 2. Adjust chain tension (**Page 44**).
Ripples or lines in workpiece.	1. Uneven feed rate. 2. Conveyor belt flexing or vibrating.	1. Maintain even feed rate through entire sanding operation. 2. Reduce depth of cut/brush penetration (**Page 30**) or reduce feed rate. Tighten loose fasteners.
Snipe marks in workpiece.	1. Improper pressure roller pressure. 2. Workpiece too long to be supported without additional help.	1. Adjust pressure roller pressure (**Page 28**). 2. Use assistant or roller stands/tables on infeed and outfeed ends of conveyor to keep workpiece from bending.
Short V-belt life span.	1. Pulleys not aligned correctly. 2. V-belts improperly tensioned.	1. Align pulleys (**Page 50**). 2. Properly tension V-belts (**Page 28**).
Workpiece pulls to one side during sanding operations.	1. Sanding head not parallel to table.	1. Adjust sanding drum parallel to table (**Page 45**).
Abrasive grain easily rubs off.	1. Abrasive stored in improper environment. 2. Abrasive has been damaged or crushed.	1. Replace damaged abrasive; store abrasive in cool, dry place. 2. Replace damaged abrasive; do not store abrasive where it can be crushed.

Tracking & Tensioning Conveyor Belt

If the conveyor belt tracks to either side, then the tracking must be corrected or the conveyor belt will become damaged and have to be replaced. The tracking was properly set at the factory, but wear may cause it to track unevenly eventually.

Conveyor belt tracking is a balancing process that takes patience and some trial-and-error. Usually you must tighten the loose side to make the belt move to the middle of the rollers, then loosen the same side to make the belt stay in position. If an adjustment bolt is overly adjusted, then the process will need to be repeated until the belt stays in the middle.

The conveyor belt will stretch when new and will eventually need to be tensioned. This is more obvious if the conveyor belt starts slipping on the rollers.

When adjusting the conveyor belt tension, focus on adjusting the adjustment bolts in even increments. Adjusting one side more than the other will cause tracking problems, which will require you to make additional adjustments to get the sander tracking correctly again.

Tools Needed	**Qty**
Pencil	1
Open-End Wrenches 17mm	2

⚠CAUTION

Moving belt presents pinch/entanglement hazards that can cause personal injury. Use care to keep hands clear of in-running pinch points while adjusting tracking/tension when belt is feeding. Do not wear clothes that could become entangled.

NOTICE

DO NOT over-tension conveyor belt. This may cause premature wearing of belt and bushings, and cause strain on motor.

To track and tension conveyor belt:

1. Use pencil to make reference marks on roller brackets where head of adjustment bolts are positioned (see **Figure 55**). These reference points will provide a visual aid in keeping track of adjustments.

2. Loosen jam nuts on adjustment bolts without moving adjustment bolts (see **Figure 55**).

3. Turn conveyor belt ***ON*** and watch conveyor belt track.

   — If belt slips on rollers, rotate both roller adjustment bolts (see **Figure 55**) evenly clockwise to increase tension.

   — If belt tracks toward right, rotate right roller adjustment bolt (see **Figure 55**) clockwise to move belt left.

   — If belt tracks toward left, rotate left roller adjustment bolt (see **Figure 55**) clockwise to move belt right.

   Note: *Make adjustments in small increments. Let conveyor run at about 50% speed and watch conveyor belt behavior between each adjustment.*

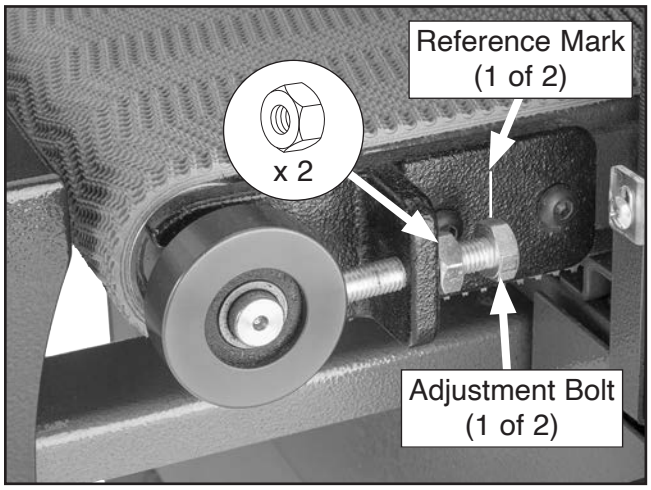


Figure 55. Conveyor belt adjustment components (right roller bracket shown).

4. Tighten jam nuts from **Step 2** without moving bolts to secure adjustment.

Replacing Conveyor Belt

Replace the conveyor belt if it becomes damaged or you are not able to adjust the conveyor belt tracking due to excessive wear.

Items Needed	Qty
Wrench or Socket ½"	1
Hex Wrench 5mm	1
Pencil or Tape Roll	1
Open-End Wrenches 17mm	2
Replacement Conveyor Belt (#P0400514)	1

To replace conveyor belt:

1. DISCONNECT MACHINE FROM POWER!

2. Remove sanding head from machine (see **Changing Sanding Head** on **Page 28**).

3. Remove table height crank from shaft (see **Figure 56**).

4. Remove (4) hex bolts and flat washers that secure sanding head mounts to machine (see **Figure 56**).

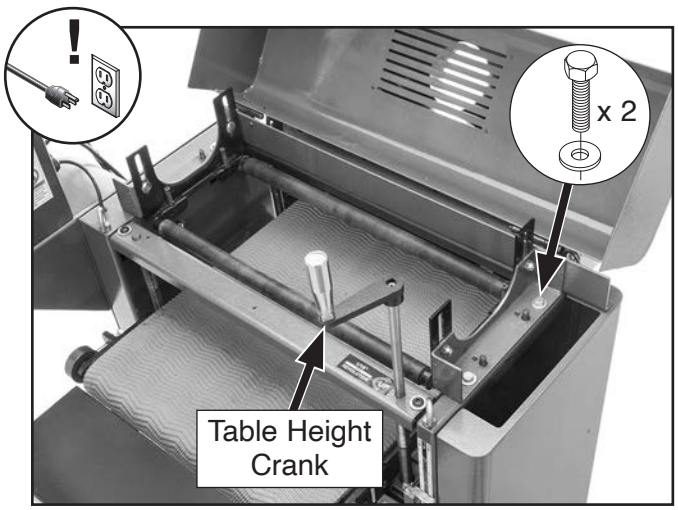


Figure 56. Location of table height crank and sanding head mount fasteners.

5. Close top door and remove sanding head mount assembly from machine.

6. Remove (4) button head cap screws and flat washers shown in **Figure 57**, then remove front and rear cross braces.

Note: *You may need to loosen conveyor brush lock knobs to remove rear cross brace.*

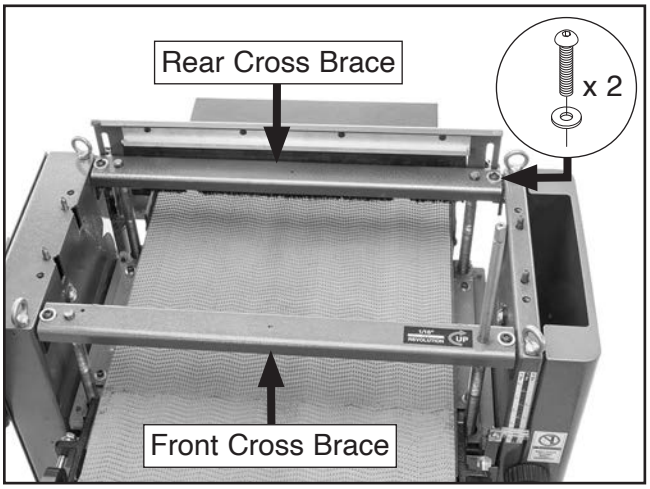


Figure 57. Front and rear cross braces and fasteners.

7. Remove (4) cap screws, lock washers, and flat washers securing conveyor table to machine (see **Figure 58**).

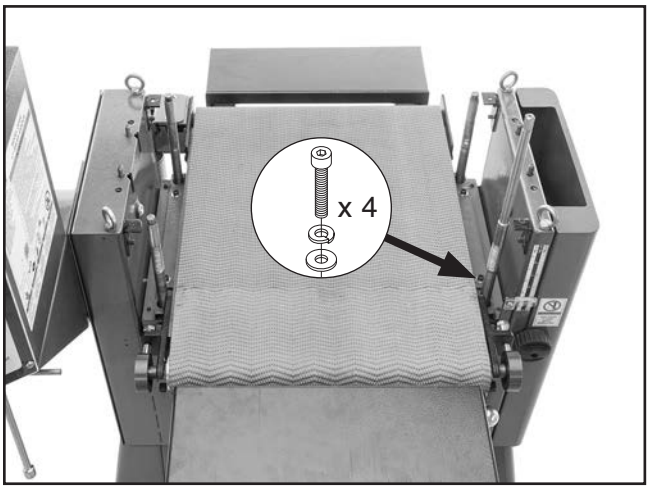


Figure 58. Conveyor table fasteners.

8. Lift conveyor table out of machine and set on a flat surface.

9. Use pencil or tape to make reference mark on front right roller bracket where head of adjustment bolt is positioned (see **Figure 59**). This reference will allow you to minimize belt tracking adjustments later.

10. Loosen adjustment bolt jam nut (see **Figure 59**), then fully loosen and remove adjustment bolts from front right roller bracket.

11. Remove (2) button head cap screws shown in **Figure 59** to remove front right roller bracket.

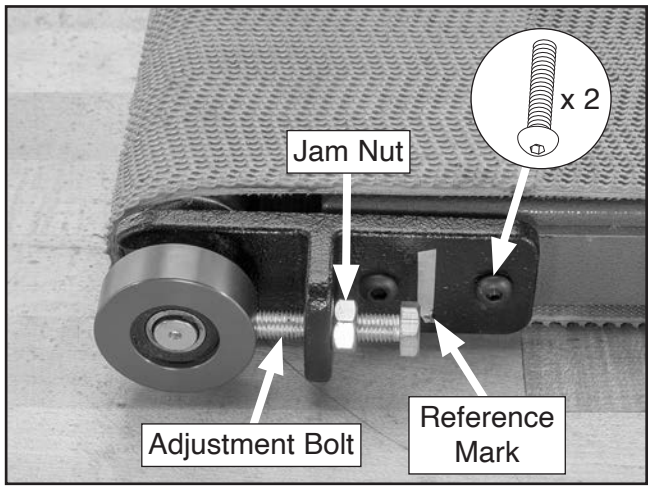


Figure 59. Front right roller bracket removal components.

12. Remove (2) button head cap screws shown in **Figure 60** to remove rear right roller bracket.

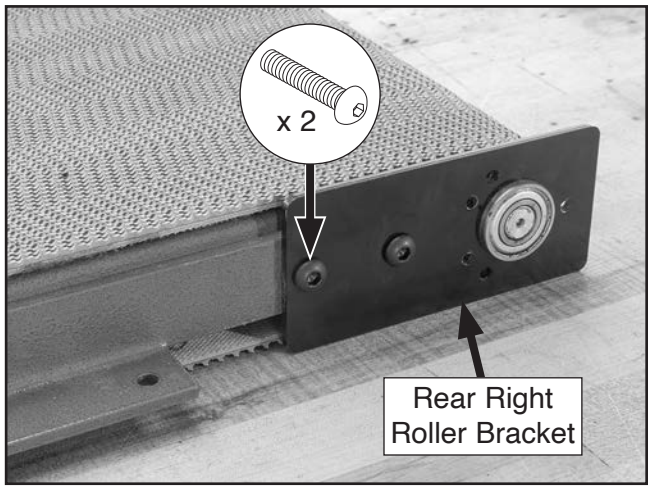


Figure 60. Rear right roller bracket screws.

13. Slide conveyor belt off of table, clean any dirt or dust off of table and rollers, then slide new conveyor belt on.

14. Install front and rear right roller brackets removed in **Steps 11–12**.

15. Install adjustment bolt removed in **Step 10**. Tighten bolt until hex bolt head aligns with reference mark (see **Figure 59**).

16. Place conveyor table back in machine, and secure with fasteners removed in **Step 7**.

17. Install front and rear cross braces with fasteners removed in **Step 6**.

18. Install sanding head mount assembly with fasteners removed in **Step 4**.

19. Install table height crank.

20. Connect machine to power and refer to **Tracking & Tensioning Conveyor Belt** on **Page 42** to adjust for new belt.

Tensioning Table Height Chain

The table height chain transfers movement from the handwheel to the leadscrews that control the table height. The chain drive can be adjusted to remove slack if the chain stretches over time.

Tools Needed	**Qty**
Hex Wrench 4mm	1
Wrench or Socket 13mm	1

To tension table height chain:

1. DISCONNECT MACHINE FROM POWER!

2. Raise table all the way.

3. Remove (4) button head cap screws shown in **Figure 61** to remove front and rear cover plates.

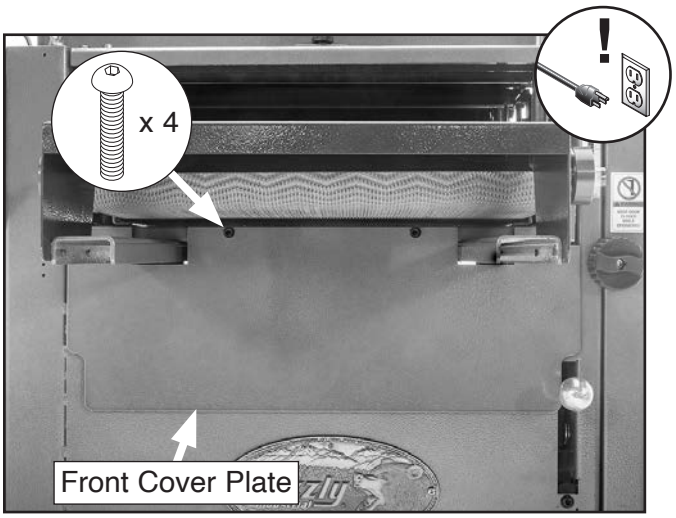


Figure 61. Location of cover plates and screws (front cover shown).

4. Locate chain tension sprocket (see **Figure 62**), then loosen chain tension sprocket hex nut (see **Figure 63**).

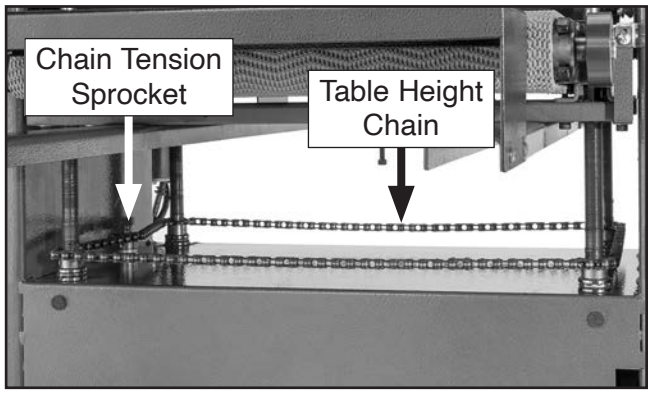


Figure 62. Location of chain tension sprocket.

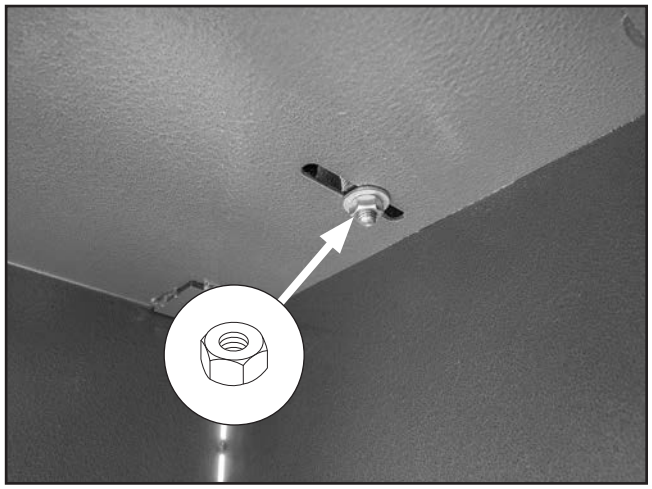


Figure 63. Chain tension sprocket hex nut.

5. Push tension sprocket against chain with moderate pressure to eliminate slack in chain. While maintaining pressure on sprocket, tighten hex nut from **Step 4**.

6. Install front and rear cover plates.

Aligning Sanding Drum to Table

Aligning a sanding drum parallel to the conveyor belt (see **Figure 64**) is critical for sanding accuracy. Care should be taken to make the tolerances as close as possible (within 0.010" from one side to the other) when adjusting the sanding drum alignment.

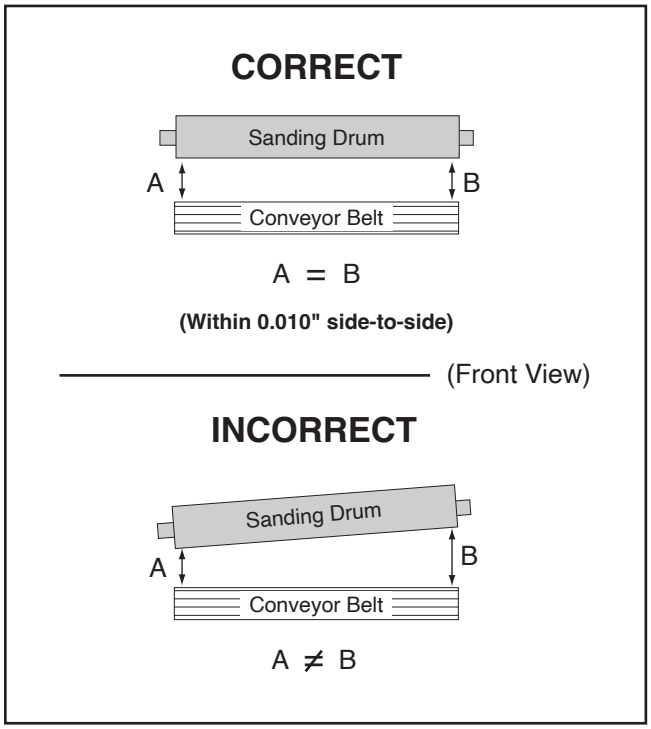


Figure 64. Sanding drum parallel to conveyor belt.

Items Needed	Qty
2x4 (6' Long)	1
Jointer	1
Table Saw	1
Feeler Gauge Set	1
Wrench or Socket ½"	1
Another Person	1
Paper Shims	As Needed

Note: ***Steps 1–2 o****f the following procedure can be skipped, but having gauge blocks of an equal height is critical to the accuracy of the adjustment.*

To align sanding drum to table:

1. Edge joint concave edge of 2x4 on jointer, as shown in **Figure 65**.

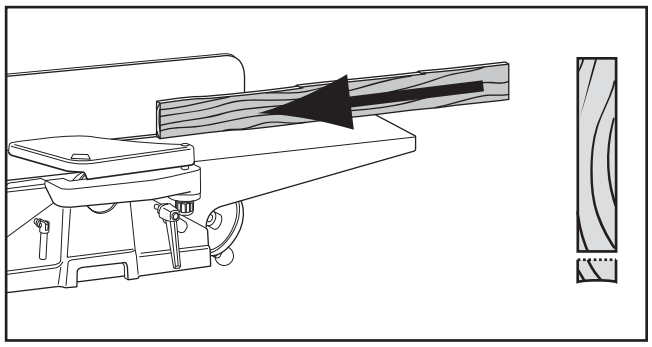


Figure 65. Edge jointing on jointer.

2. Place jointed edge of 2x4 against table saw fence and rip cut just enough off opposite side to square up two edges of 2x4, as shown in **Figure 66**.

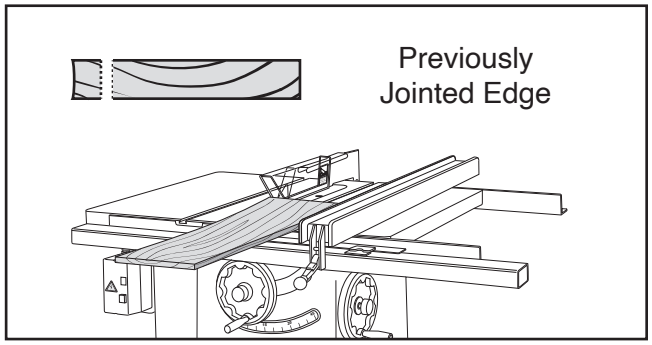


Figure 66. Rip cutting on table saw.

3. Cut 2x4 into two even pieces to make (2) 36" long wood gauge blocks.

4. DISCONNECT MACHINE FROM POWER!

5. Install sanding drum (see **Changing Sanding Head** on **Page 28**).

6. Remove sandpaper from drum and place gauge blocks as shown in **Figure 67**.

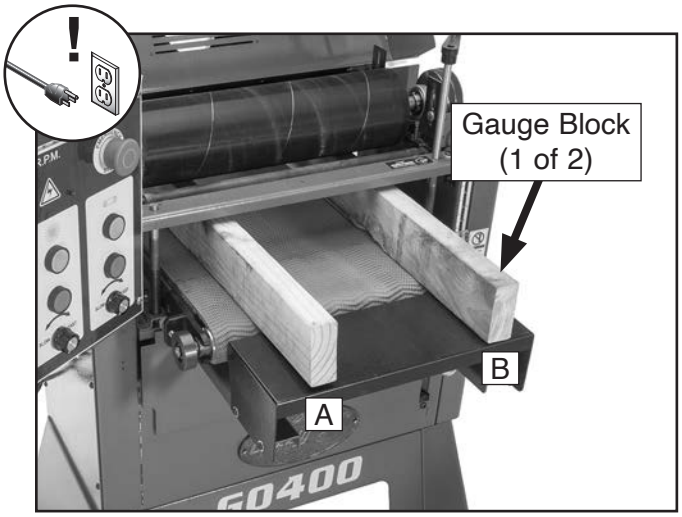


Figure 67. Example of gauge blocks placed under drum.

7. Raise table until gauge blocks just touch drum.

8. Lower table one full crank of handwheel.

9. Starting at **A** board (see **Figure 67**), find largest size feeler gauge that can pass between drum and gauge block. (Feeler gauge should slide with moderate resistance, without forcing drum to roll).

10. Repeat **Step 9** at **B** board (see **Figure 67**).

    — If difference between **A** and **B** is 0.010" or less, then no adjustment is necessary.

    — If difference between **A** and **B** is *more than* 0.010", then one end must be adjusted to within 0.010" of other. Proceed to **Step 11**.

11. On side of drum that had less clearance in **Step 10**, remove (2) hex bolts and flat washers shown in **Figure 68** and remove (2) sanding head acorn nuts.

Note: *If right side of drum has less clearance, also remove V-belts (see **Changing Sanding Head** on **Page 28**).*

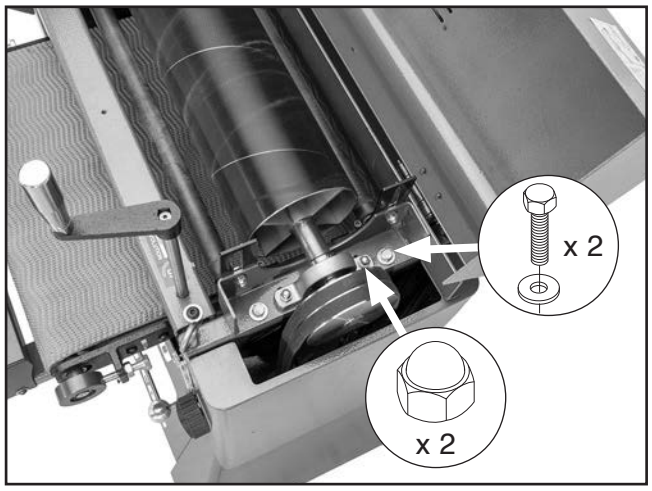


Figure 68. Location of fasteners to remove for drum alignment (right side shown).

12. Have assistant lift side of drum that had less clearance in **Step 10** just enough so you can insert paper shim(s) between sanding head mount and machine frame (see **Figure 69**).

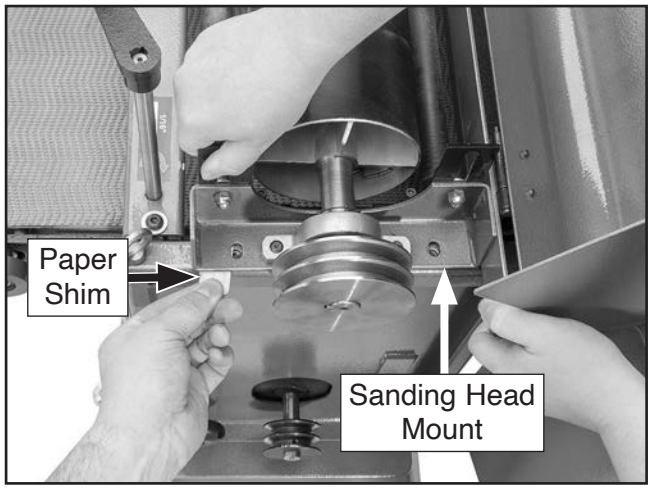


Figure 69. Inserting shim between sanding head mount and machine frame (right side shown).

13. Install fasteners removed in **Step 11**.

14. Repeat **Steps 7–10** to check adjustment. Add more shims, as needed, to bring drum into alignment.

Replacing Sanding Head Bearings

After long periods of heavy use, it may be necessary to replace the pillow block bearing assemblies. Always replace both bearing assemblies on the same sanding head at the same time.

NOTICE

DO NOT hammer pillow block bearings assemblies onto shafts, as you WILL damage these precision parts. Bearings and shaft are slip fit, but a press can be used if necessary.

Note: *The pillow block bearing housings on the Model G0400 have bearing clearance slots (see **Figure 70**) that allow for slight misalignment of the sanding head shaft. If a bearing gets knocked out of the housing, you can use a vise and a screwdriver, pipe, or other round tool to swivel the bearing back into place (see **Figure 71**).*

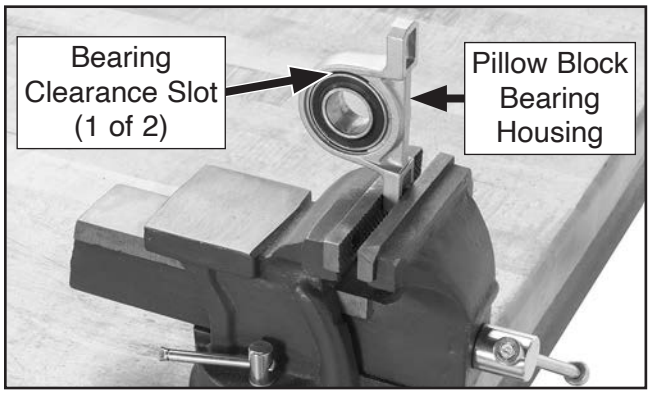


Figure 70. Location of bearing clearance slots.

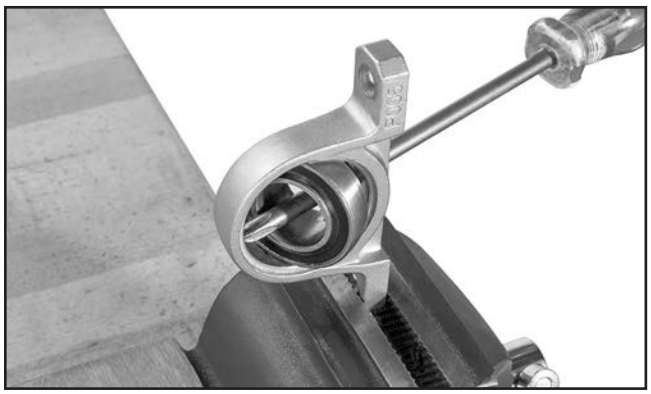


Figure 71. Leveraging bearing into housing.

Items Needed	Qty
Hex Wrenches 2.5, 3mm	1 Ea.
Ball Bearing Assemblies (P0400032)	2
Cleaner/Degreaser	As Needed
Disposable Rags	As Needed
Retaining Ring Pliers	1

To replace sanding head bearings:

1. DISCONNECT MACHINE FROM POWER!

2. Remove V-belts from pulleys (see **Changing Sanding Head** on **Page 28**).

3. Loosen set screw shown in **Figure 72**, then remove sanding head pulley from shaft.

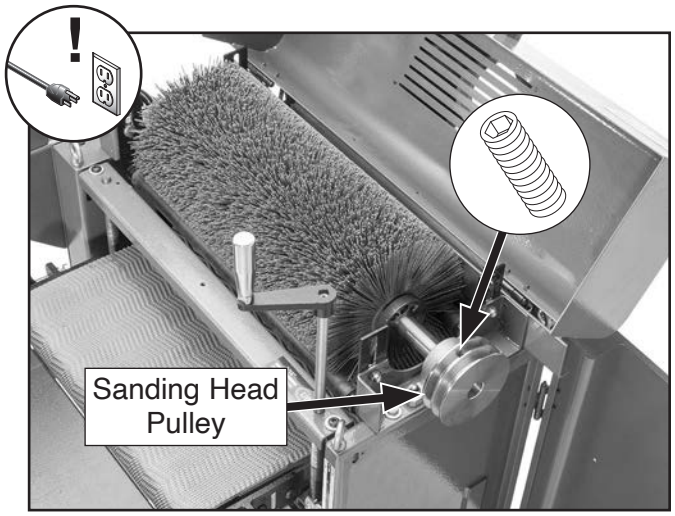


Figure 72. Location of sanding head pulley and set screw (nylon brush head shown).

4. Remove sanding head from machine, and place it on flat, stable surface.

5. Loosen (2) inner race set screws (see **Figure 73**) on left pillow block bearing, then remove and discard pillow block bearing assembly.

   Tip: *An external gear/bearing puller can help remove a stuck pillow block bearing.*

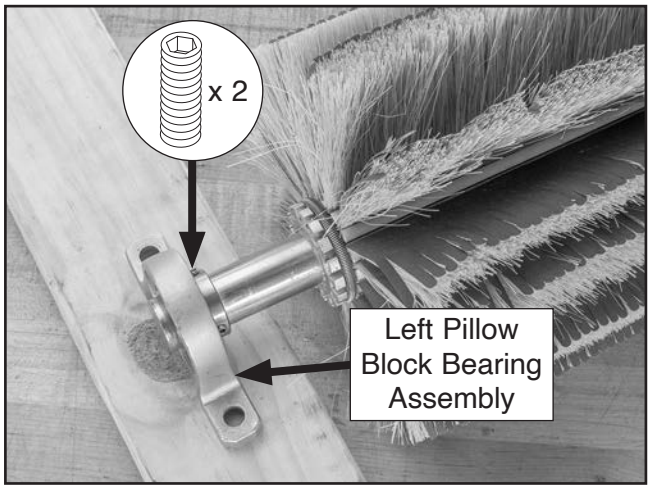


Figure 73. Location of left pillow block bearing assembly (flatter brush head shown).

6. Clean bore of new pillow block bearing assembly and sanding head shaft with cleaner/degreaser.

7. After bearing bore and shaft are dry, slide bearing assembly onto shaft, then finger tighten bearing set screws (see **Figure 74**) to keep bearing from sliding off shaft in the following steps.

   Note: *Side of bearing with inner race set screws should go on shaft first (see **Figure 74**). Bearing position will be adjusted in later steps.*

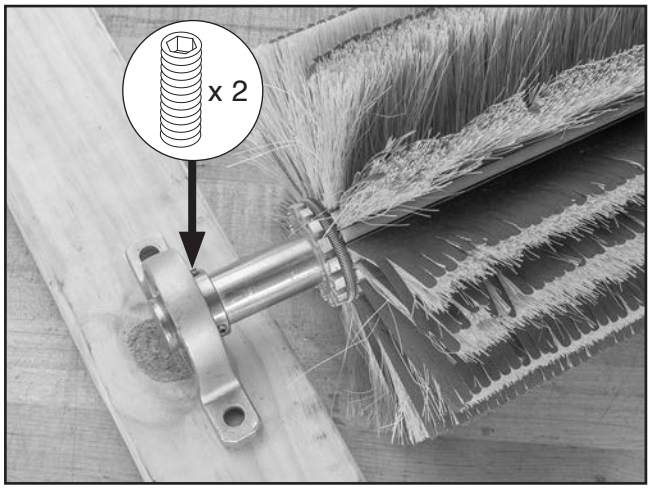


Figure 74. Left bearing correctly oriented on shaft.

8. Remove external retaining ring on outside of right bearing assembly (see **Figure 75**).

9. Loosen (2) inner race set screws (see **Figure 75**) on right pillow block bearing, then remove and discard pillow block bearing assembly.

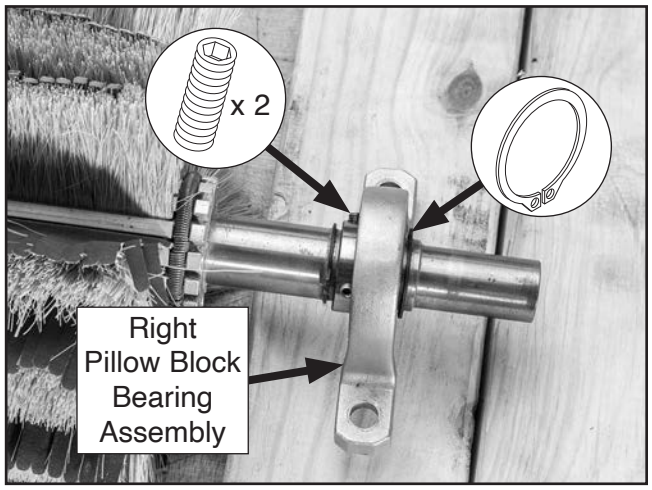


Figure 75. Right bearing assembly removal components (flatter brush head shown).

10. Clean bore of new pillow block bearing assembly and sanding head shaft with cleaner/degreaser.

11. After bearing bore and shaft are dry, slide bearing assembly onto sanding head shaft.

    Note: *Side of pillow block bearing with inner race set screws should go on shaft first. Bearing position will be adjusted in later steps.*

12. Install external retaining ring from **Step 8** on outside of right bearing assembly.

13. Loosen left bearing set screws, then install sanding head on machine.

    Note: *Align right bearing assembly with right studs first, then move left bearing assembly on shaft as needed to align it with left studs (see **Figure 76**).*

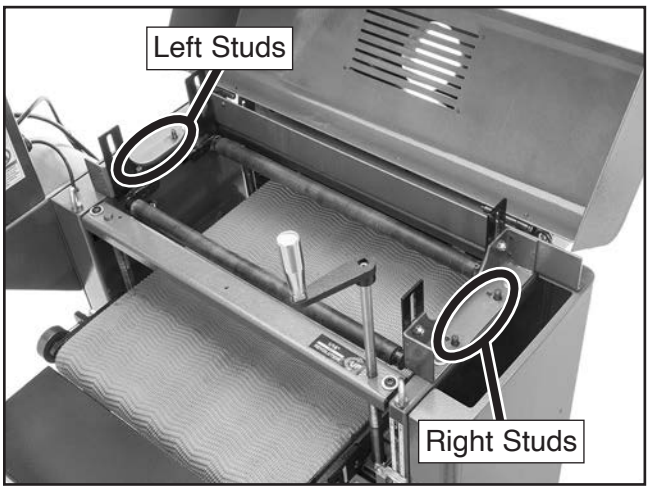


Figure 76. Location of right and left sanding head studs.

14. When bearing assemblies are aligned with studs, tighten bearing set screws to secure position.

15. Secure sanding head to machine frame with (4) acorn nuts.

16. Slide sanding head pulley onto shaft, then refer to **Aligning Pulleys** on **Page 50** to position pulley. Tighten pulley set screw to secure.

17. Perform **Steps 10–13** of **Changing Sanding Head** section beginning on **Page 28**.

Aligning Pulleys

Pulley alignment is an important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplanar) for optimum performance.

Use a straightedge to check the pulley alignment, as shown in **Figure 77**. Both the motor pulley and the sanding head pulley position can be adjusted on their shafts.

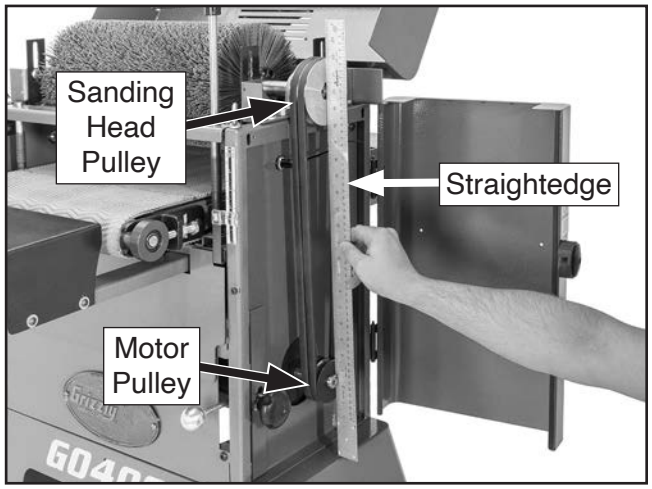


Figure 77. Checking pulley alignment.

Items Needed	**Qty**
Hex Wrench 3mm	1
Straightedge 24"	1

To align pulleys:

1. DISCONNECT MACHINE FROM POWER!

2. Turn belt door lock knob clockwise to open belt door (see **Figure 78**).

3. Remove knob bolt shown in **Figure 78** and open top door.

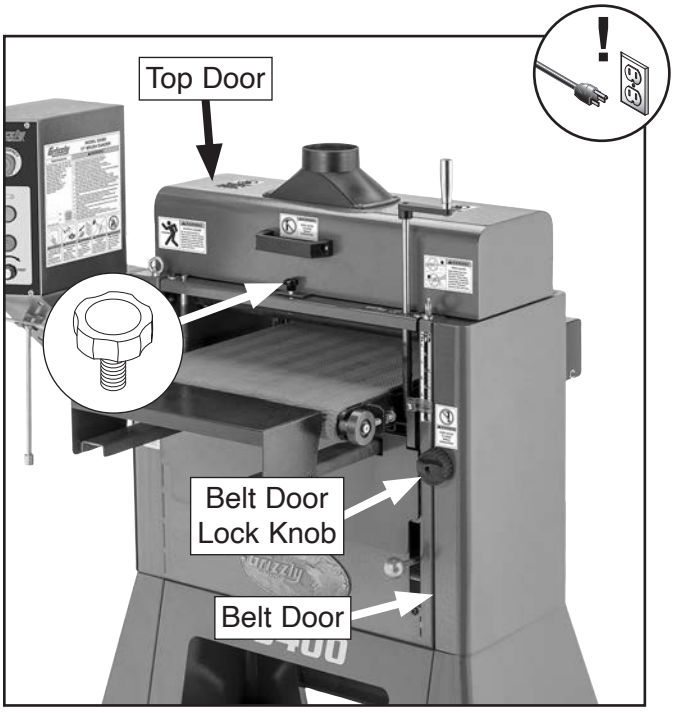


Figure 78. Belt and top door components.

4. Place straightedge against sanding head and motor pulleys (see **Figure 77**) and check that they are aligned. There should be no space anywhere between straightedge and pulleys.

— If pulleys *are* aligned, no adjustment is necessary. Proceed to **Step 9**.

— If pulleys *are not* aligned, proceed to **Step 5**.

⚠CAUTION

Use care when handling V-belts, as they can pinch your fingers. They may also be hot after extended use, so wait to touch V-belts if machine has been in use.

5. Remove V-belts from pulleys (see **Changing Sanding Head** on **Page 28**).

6. Loosen set screw on sanding head pulley and set screw motor pulley (see **Figure 79**).

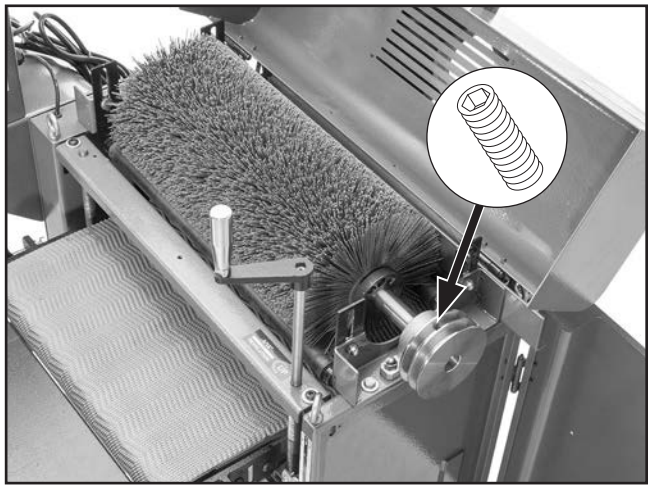


Figure 79. Location of pulley set screws (sanding head pulley shown).

7. Adjust pulleys on shafts until they are aligned, then tighten set screws.

   Note: *Ensure that no part of either pulley extends past end of shaft.*

8. Install V-belts.

9. Close and secure top door and belt door.

Calibrating Workpiece Thickness Scale

Although set at the factory, the workpiece thickness scale can be adjusted for accuracy if it becomes necessary.

Tools Needed	**Qty**
Phillips Head Screwdriver #2	1

To calibrate table height scale:

1. Use table height crank to adjust conveyor table until table *just* contacts brush bristles and drum sandpaper.

   — If workpiece thickness scale displays 0" for installed sanding head diameter (see **Figure 80**), no adjustment is required.

   — If workpiece thickness scale *does not* display 0" for installed sanding head diameter (see **Figure 80**), proceed to **Step 2**.

2. Loosen screw shown in **Figure 80**, adjust scale indicator so it points to 0", then tighten screw to secure.

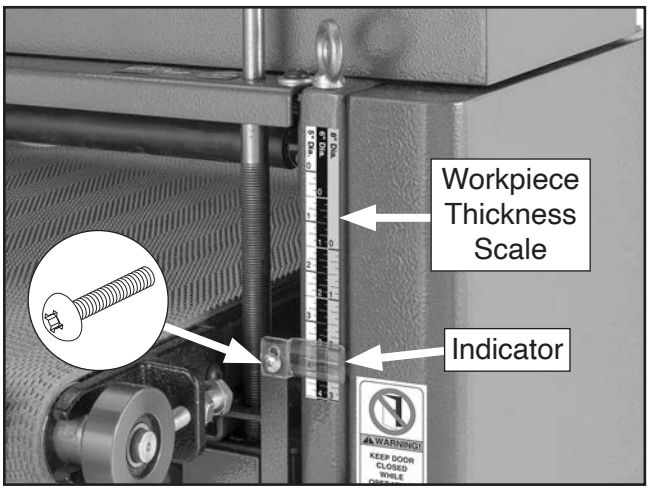


Figure 80. Workpiece thickness scale calibration components.

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

⚠WARNING
Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

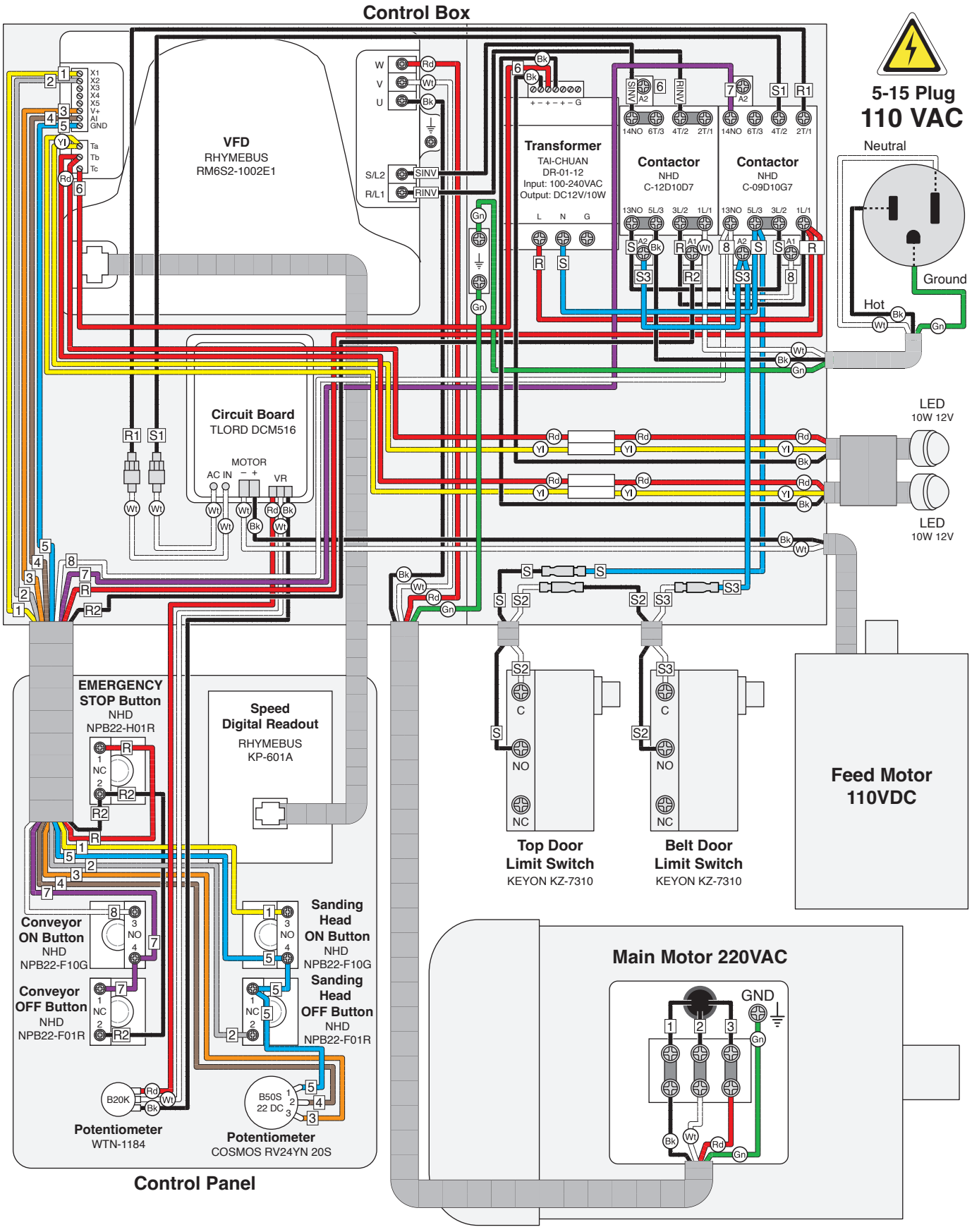
NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram



Electrical Components

Figure 81. Control box wiring.

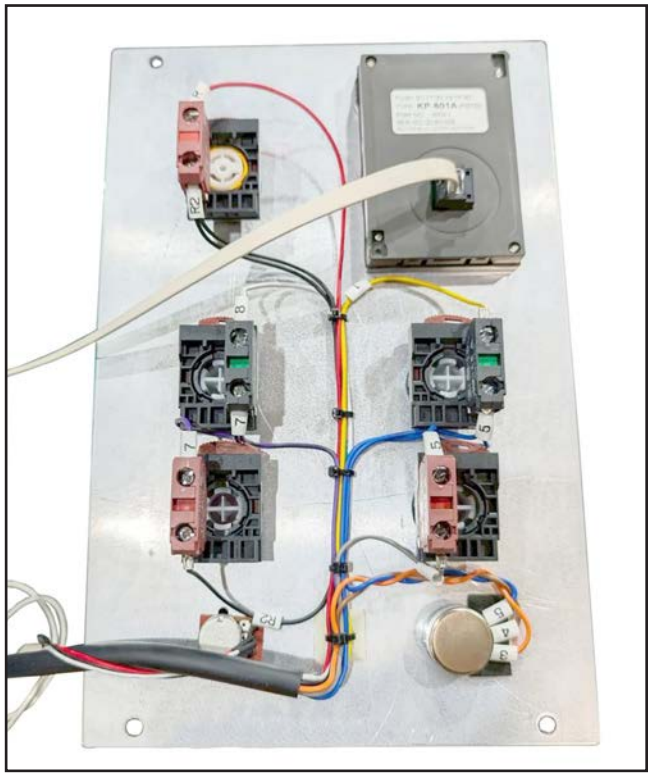


Figure 82. Control box wiring.

Figure 83. Top door limit switch wiring.

Figure 84. Belt door limit switch wiring.

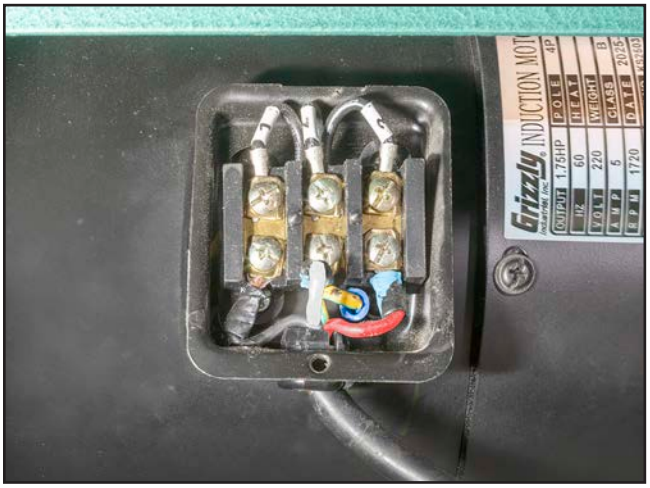


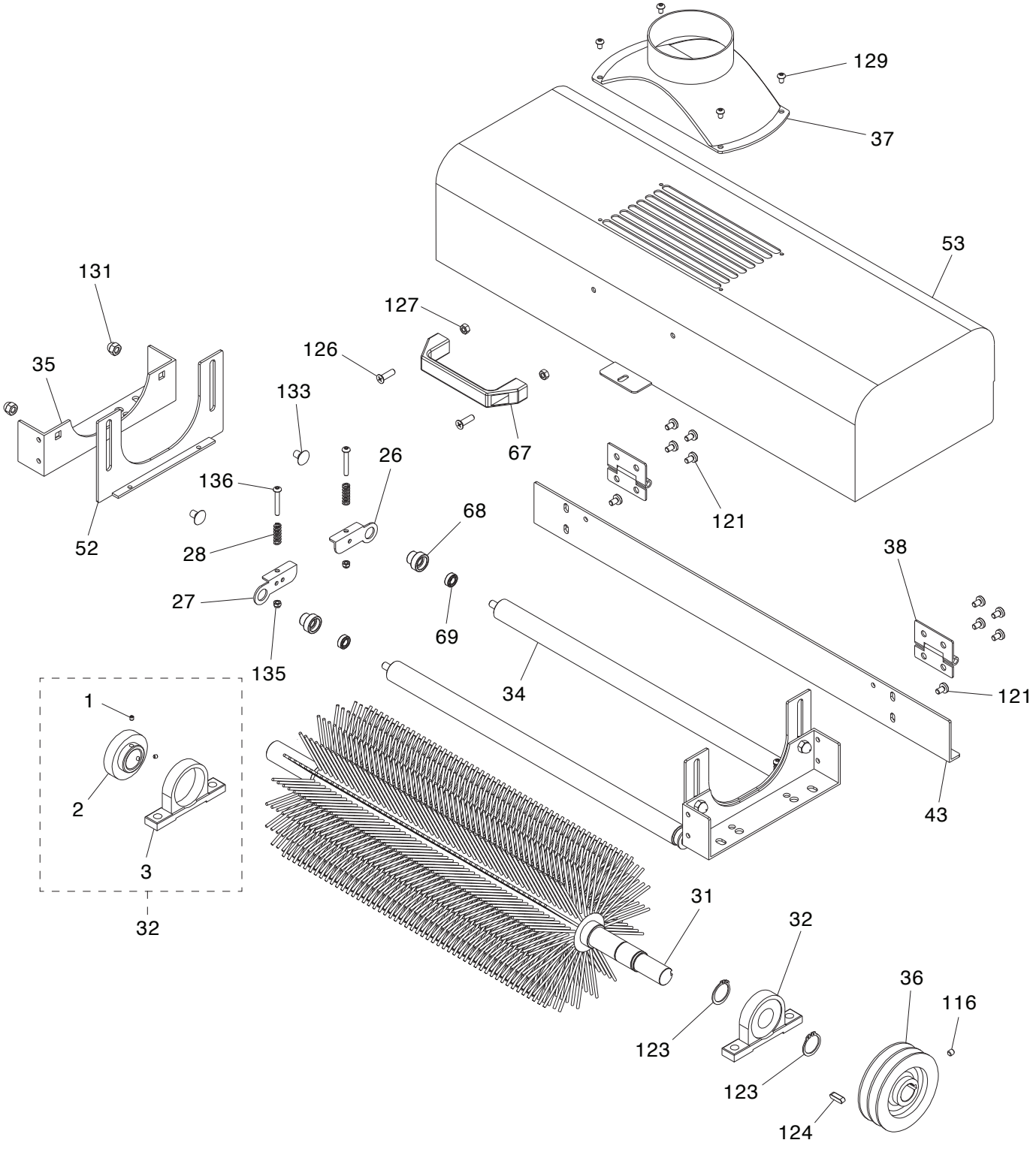
Figure 85. Main motor wiring.

STOP *READ ELECTRICAL SAFETY ON PAGE 52!*

SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call **(800) 523-4777** or visit **www.grizzly.com/parts** to check for availability.

Sanding Head

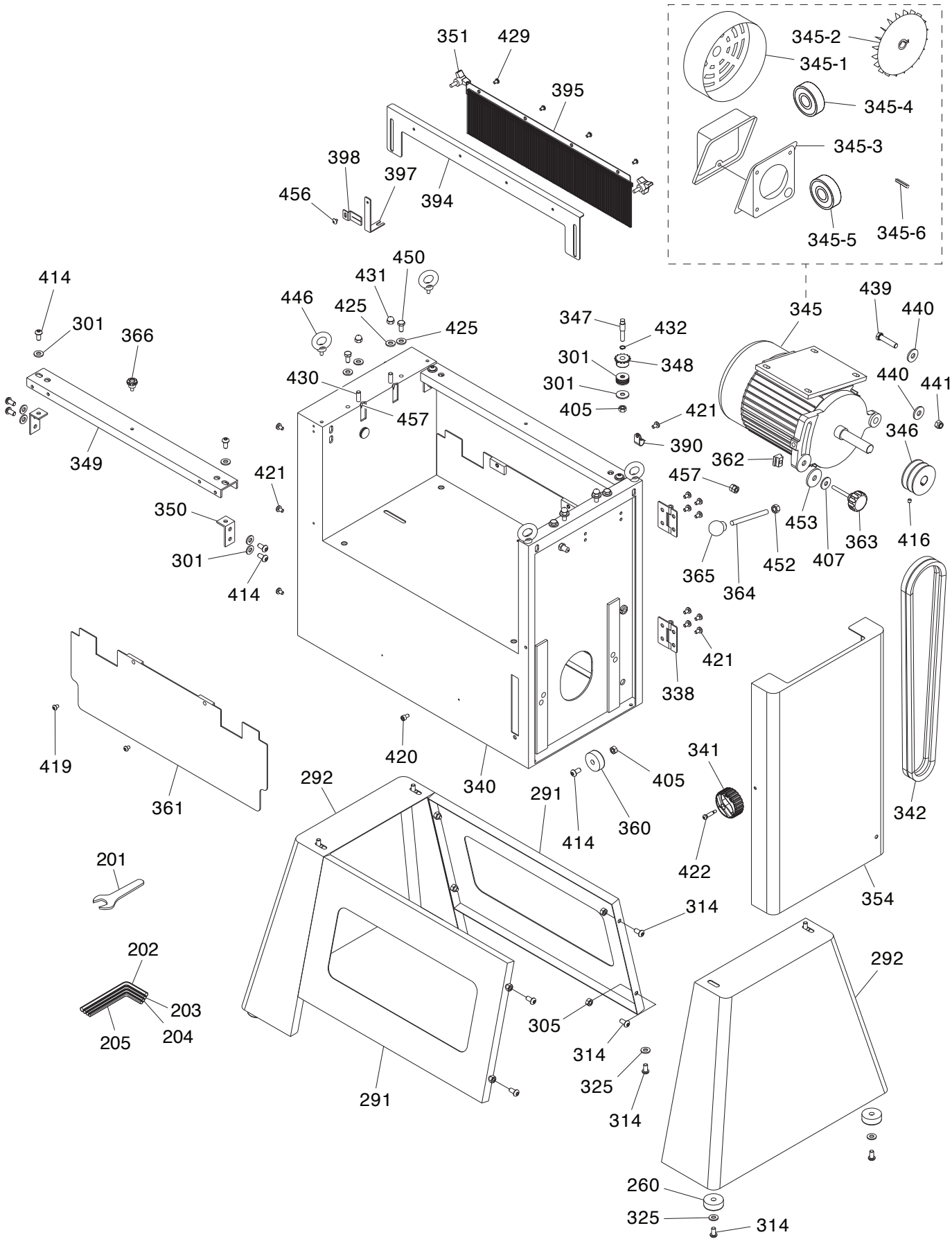


Sanding Head Parts List

REF	PART #	DESCRIPTION
1	P0400001	SET SCREW M5-.8 X 5 KNURLED-PT
2	P0400002	INSERT MOUNTED BALL BEARING K005
3	P0400003	PILLOW BLOCK MOUNT P005
26	P0400026	ROLLER MOUNT REAR LEFT
27	P0400027	ROLLER MOUNT FRONT LEFT
28	P0400028	COMPRESSION SPRING 1.5 X 8 X 25
31	P0400031	NYLON BRUSH HEAD 8" 240-GRIT
32	P0400032	PILLOW BLOCK BEARING KP005
34	P0400034	PRESSURE ROLLER
35	P0400035	SANDING HEAD MOUNT
36	P0400036	SANDING HEAD PULLEY
37	P0400037	DUST PORT 4"
38	P0400038	HINGE
43	P0400043	CROSS BRACE REAR
52	P0400052	PRESSURE ROLLER BRACKET

REF	PART #	DESCRIPTION
53	P0400053	TOP DOOR
67	P0400067	DOOR HANDLE
68	P0400068	FLANGED BUSHING
69	P0400069	BALL BEARING 688ZZ
116	P0400116	SET SCREW 1/4-20 X 1/4
121	P0400121	PHLP HD SCR M6-1 X 10
123	P0400123	EXT RETAINING RING 25MM
124	P0400124	KEY 6 X 6 X 20MM RE
126	P0400126	FLAT HD SCR 1/4-20 X 7/8
127	P0400127	HEX NUT 1/4-20
129	P0400129	BUTTON HD CAP SCR M5-.8 X 8
131	P0400131	ACORN NUT 5/16-18
133	P0400133	CARRIAGE BOLT 5/16-18 X 1/2
135	P0400135	LOCK NUT M5-.8
136	P0400136	BUTTON HD CAP SCR M5-.8 X 35

Frame

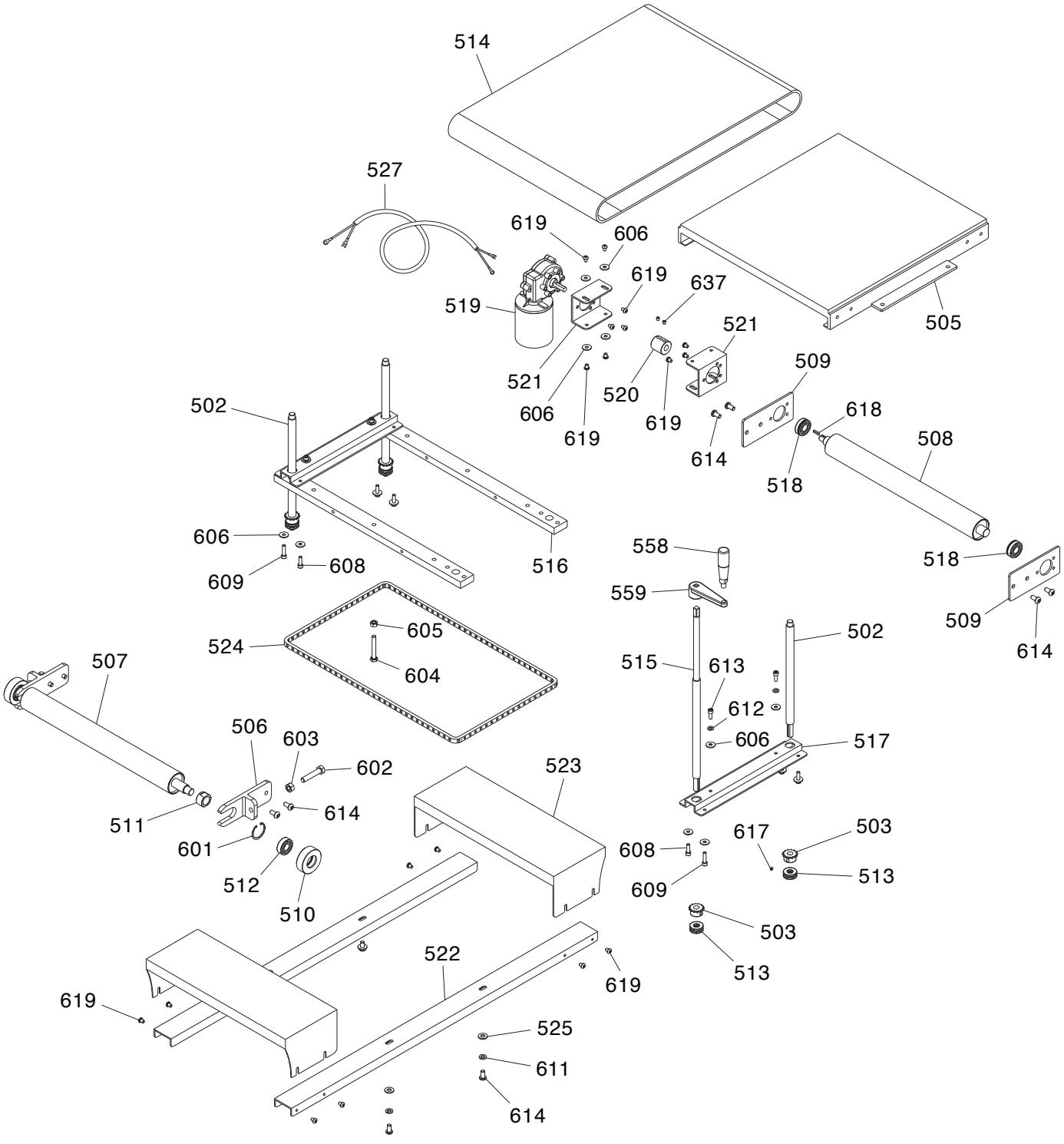


Frame Parts List

REF	PART #	DESCRIPTION
201	P0400201	WRENCH 13MM OPEN-END
202	P0400202	HEX WRENCH 6MM
203	P0400203	HEX WRENCH 5MM
204	P0400204	HEX WRENCH 4MM
205	P0400205	HEX WRENCH 3MM
260	P0400260	BUMPER
291	P0400291	STAND BRACE
292	P0400292	STAND LEG
301	P0400301	FLAT WASHER 8MM
305	P0400305	HEX NUT M8-1.25
314	P0400314	BUTTON HD CAP SCR M8-1.25 X 16
325	P0400325	FLAT WASHER 5/16
338	P0400338	HINGE
340	P0400340	BODY
341	P0400341	CAM LOCK KNOB
342	P0400342	V-BELT A44
345	P0400345	MOTOR 1.75HP 110V 3-PH
345-1	P0400345-1	MOTOR FAN COVER
345-2	P0400345-2	MOTOR FAN
345-3	P0400345-3	JUNCTION BOX
345-4	P0400345-4	BALL BEARING 6205ZZ (FRONT)
345-5	P0400345-5	BALL BEARING 6203ZZ (REAR)
345-6	P0400345-6	KEY 5 X 5 X 35 RE
346	P0400346	MOTOR PULLEY
347	P0400347	SPROCKET SHAFT
348	P0400348	SPROCKET 8T M10
349	P0400349	CROSS BRACE
350	P0400350	L-BRACKET
351	P0400351	KNOB BOLT 1/4-20 X 1/2
354	P0400354	BELT DOOR
360	P0400360	BUMPER
361	P0400361	COVER PLATE

REF	PART #	DESCRIPTION
362	P0400362	T-SLOT NUT 5/16, 5/16-18
363	P0400363	KNOB BOLT 5/16-18 X 2
364	P0400364	STUD-DE 3/8-16 X 4, 5/8
365	P0400365	KNOB 3/8-16
366	P0400366	KNOB BOLT 1/4-20 X 3/8
390	P0400390	CORD CLAMP
394	P0400394	BRUSH HEIGHT BRACKET
395	P0400395	CONVEYOR BRUSH
397	P0400397	INDICATOR BRACKET
398	P0400398	INDICATOR
405	P0400405	HEX NUT M8-1.25
407	P0400407	FLAT WASHER 5/16
414	P0400414	BUTTON HD CAP SCR M8-1.25 X 16
416	P0400416	SET SCREW 1/4-20 X 1/4
419	P0400418	BUTTON HD CAP SCR M6-1 X 8
420	P0400420	CAP SCREW 1/4-20 X 3/8
421	P0400421	PHLP HD SCR M6-1 X 10
422	P0400422	SHOULDER SCREW 1/4-20 X 1/4, 1/4 X 1/2
425	P0400425	FLAT WASHER 5/16
429	P0400429	BUTTON HD CAP SCR M5-.8 X 8
430	P0400430	CAP SCREW 5/16-18 X 1-9/16
431	P0400431	ACORN NUT 5/16-18
432	P0400432	EXT RETAINING RING 10MM
439	P0400439	HEX BOLT 3/8-16 X 1-3/4
440	P0400440	FLAT WASHER 3/8
441	P0400441	LOCK NUT 3/8-16
446	P0400446	EYE BOLT 3/4", M6-1 X 15
450	P0400450	HEX BOLT 5/16-18 X 5/8
452	P0400452	HEX NUT 3/8-16
453	P0400453	FENDER WASHER 5/16
456	P0400456	PHLP HD SCR 10-24 X 1-1/2
457	P0400457	HEX NUT 5/16-18

Conveyor Table

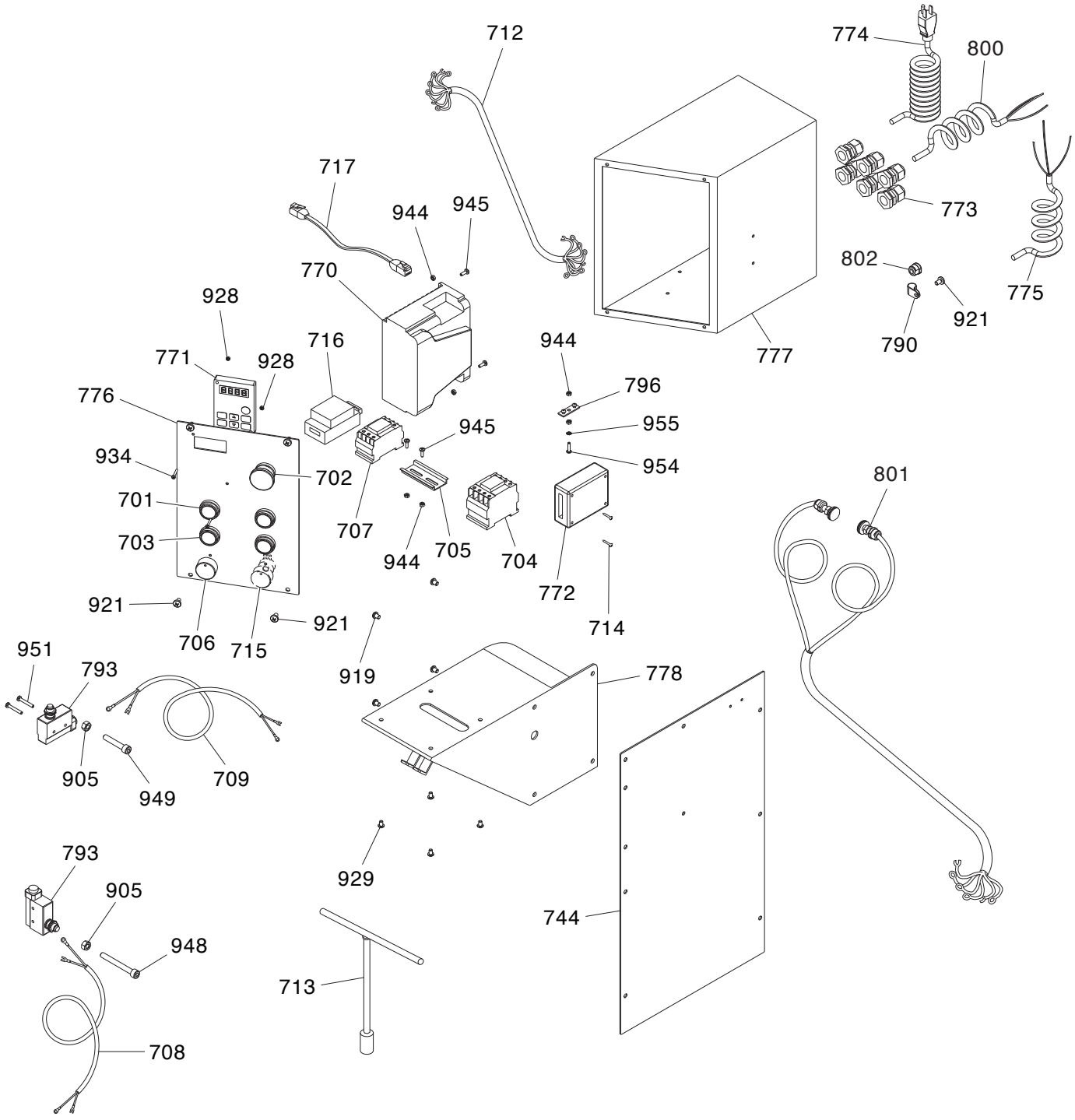


Conveyor Table Parts List

REF	PART #	DESCRIPTION
502	P0400502	LEADSCREW SHORT
503	P0400503	SPROCKET 8T M12
505	P0400505	TABLE
506	P0400506	ROLLER BRACKET FRONT
507	P0400507	ROLLER IDLER
508	P0400508	ROLLER DRIVE
509	P0400509	ROLLER BRACKET REAR
510	P0400510	BEARING HOUSING
511	P0400511	BUSHING 18.9 X 31 X 20MM
512	P0400512	BALL BEARING 6202VV-N
513	P0400513	THRUST BEARING 51201
514	P0400514	CONVEYOR BELT
515	P0400515	LEADSCREW LONG
516	P0400516	LEADSCREW BLOCK
517	P0400517	TABLE BRACKET
518	P0400518	BALL BEARING W/SNAP RING 6202ZZNR
519	P0400519	MOTOR 1/4HP 110VDC W/GEARBOX
520	P0400520	MOTOR COUPLER
521	P0400521	MOTOR MOUNT
522	P0400522	EXTENSION TABLE MOUNTING BRACKET
523	P0400523	EXTENSION TABLE

REF	PART #	DESCRIPTION
524	P0400524	CHAIN 1/2"P X 126
525	P0400525	FLAT WASHER 8MM
527	P0400527	FEED MOTOR CORD 18G 2W 39"
558	P0400558	REVOLVING HANDLE 3/8-16 X 13
559	P0400559	TABLE HEIGHT CRANK
601	P0400601	INT RETAINING RING 35MM
602	P0400602	HEX BOLT M10-1.5 X 50
603	P0400603	HEX NUT M10-1.5
604	P0400604	HEX BOLT M8-1.25 X 55
605	P0400605	HEX NUT M8-1.25
606	P0400606	FENDER WASHER 6MM
608	P0400608	CAP SCREW M6-1 X 20
609	P0400609	CAP SCREW M6-1 X 25
611	P0400611	LOCK WASHER 8MM
612	P0400612	LOCK WASHER 6MM
613	P0400613	CAP SCREW M6-1 X 16
614	P0400614	BUTTON HD CAP SCR M8-1.25 X 16
617	P0400617	SET SCREW M5-.8 X 5
618	P0400618	KEY 4 X 4 X 16 RE
619	P0400619	BUTTON HD CAP SCR M6-1 X 8
637	P0400637	SET SCREW M6-1 X 6

Electrical Components

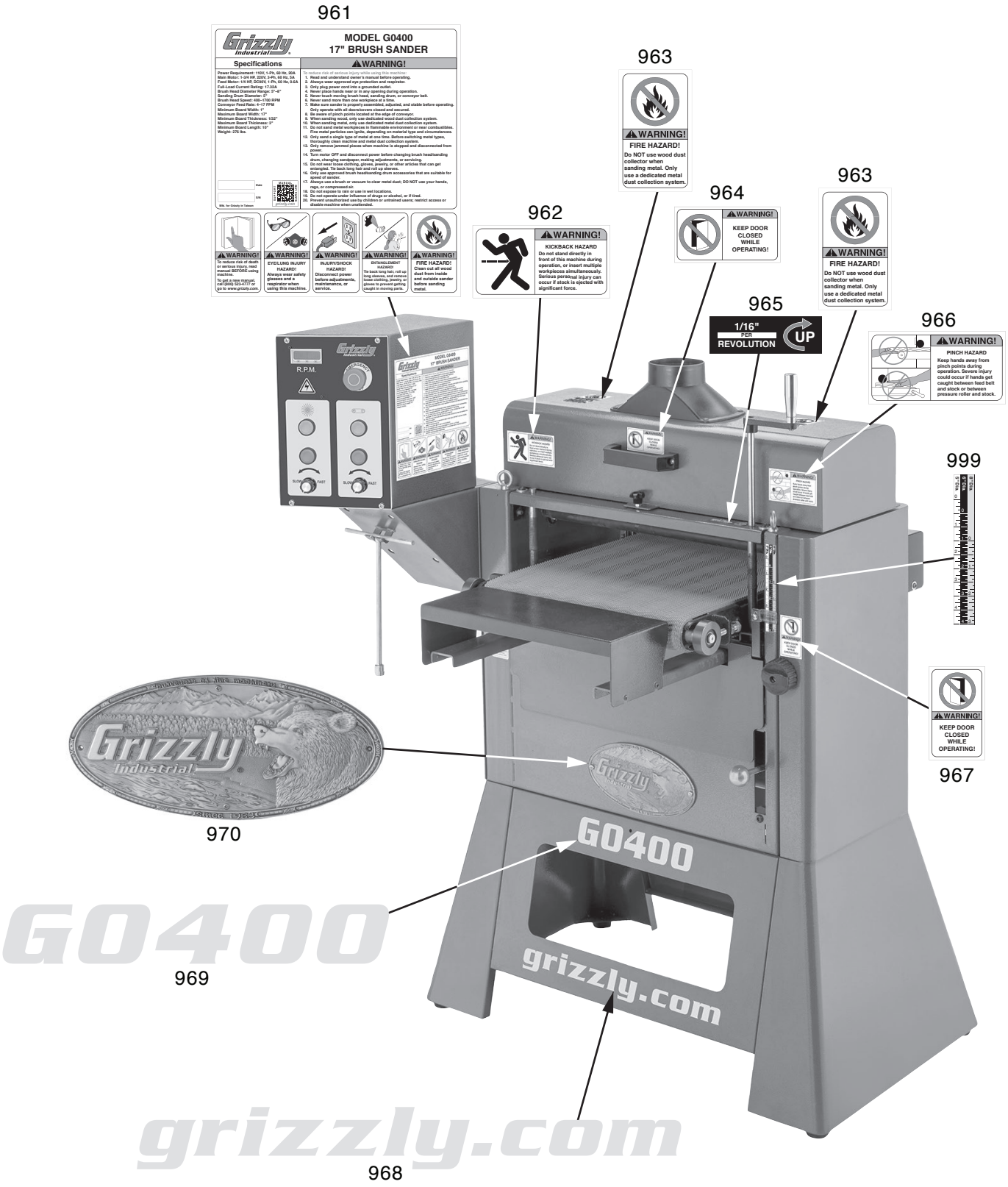


Electrical Components Parts List

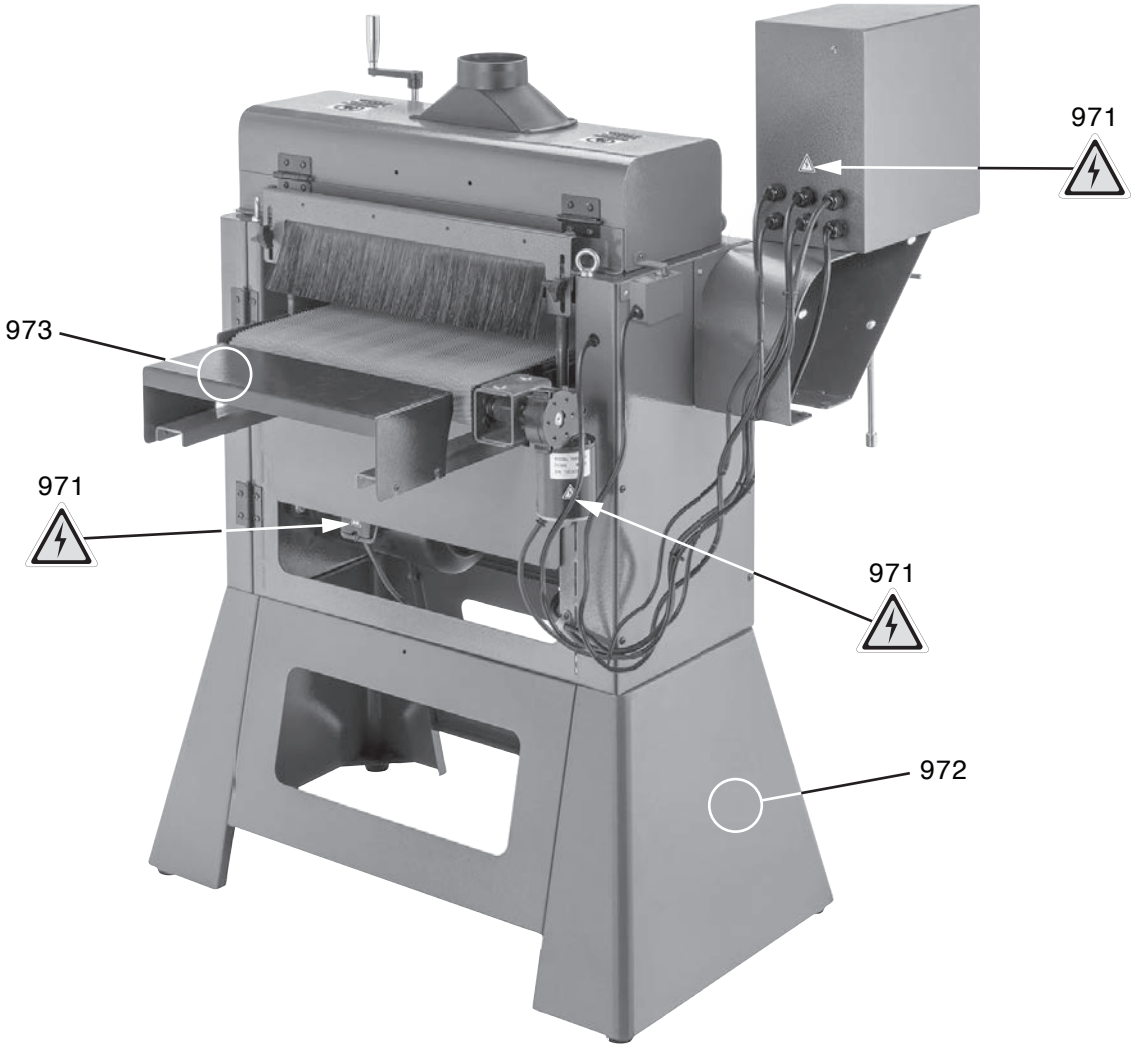
REF	PART #	DESCRIPTION
701	P0400701	ON BUTTON NHD NPB22-F10G
702	P0400702	E-STOP BUTTON NHD NPB22-H01R
703	P0400703	OFF BUTTON NHD NPB22-F01R
704	P0400704	CONTACTOR NHD C-09D10G7 110V
705	P0400705	DIN RAIL 35 X 7 X 180MM
706	P0400706	DIAL W/POTENTIOMETER COSMOS RV24YN
707	P0400707	CONTACTOR NHD C-12D10D7 110V
708	P0400708	BELT DOOR LIMIT SWITCH CORD 20G 2W 83"
709	P0400709	TOP DOOR LIMIT SWITCH CORD 20G 2W 51"
712	P0400712	CONTROL PANEL CORD 20G 9W 8"
713	P0400713	SOCKET WRENCH 1/2" T-HANDLE
714	P0400714	TAP SCREW M3 X 10
715	P0400715	DIAL W/POTENTIOMETER WTN-1184
716	P0400716	TRANSFORMER TAI-CHUAN DR-01-12
717	P0400717	ETHERNET CORD 26G 8W 57"
744	P0400744	PLATE LEFT
770	P0400770	VFD RHYMEBUS RM6S2-1002E1
771	P0400771	KEY PAD RHYMEBUS KP-601A
772	P0400772	CIRCUIT BOARD TLORD DCM516
773	P0400773	STRAIN RELIEF PG13.5
774	P0400774	POWER CORD 14G 3W 74" 5-15P
775	P0400775	MAIN MOTOR CORD 14G 4W 71"

REF	PART #	DESCRIPTION
776	P0400776	CONTROL PANEL
777	P0400777	CONTROL BOX
778	P0400778	CONTROL BOX MOUNTING BRACKET
790	P0400790	CORD CLAMP
793	P0400793	LIMIT SWITCH KEYON KZ-7310
796	P0400796	GROUND PLATE
800	P0400800	VFD CORD 14G 3W 16"
801	P0400801	LEDS W/CORD 10W 12V 23MM
802	P0400802	STRAIN RELIEF 5/8
905	P0400905	HEX NUT M8-1.25
919	P0400919	BUTTON HD CAP SCR M6-1 X 8
921	P0400921	PHLP HD SCR M6-1 X 10
928	P0400928	HEX NUT M3-.5
929	P0400929	BUTTON HD CAP SCR M5-.8 X 8
934	P0400934	PHLP HD SCR M3-.5 X 20
944	P0400944	HEX NUT M4-.7
945	P0400945	PHLP HD SCR M4-.7 X 12
948	P0400948	CAP SCREW M8-1.25 X 70
949	P0400949	CAP SCREW M8-1.25 X 45
951	P0400951	FLAT HD SCR M4-.7 X 15
954	P0400954	FLAT HD SCR M4-.7 X 15
955	P0400955	EXT TOOTH WASHER 4MM

Labels & Cosmetics



Labels & Cosmetics (Cont.)



REF	PART #	DESCRIPTION
961	P0400961	MACHINE ID LABEL
962	P0400962	KICKBACK HAZARD LABEL
963	P0400963	FIRE HAZARD LABEL
964	P0400964	KEEP DOOR CLOSED HOR LABEL
965	P0400965	TABLE HEIGHT CRANK LABEL
966	P0400966	PINCH HAZARD LABEL
967	P0400967	KEEP DOOR CLOSED VERT LABEL

REF	PART #	DESCRIPTION
968	P0400968	GRIZZLY.COM LABEL 16", GRAY
969	P0400969	MODEL NUMBER LABEL
970	P0400970	GRIZZLY NAMEPLATE SMALL
971	P0400971	ELECTRICITY LABEL
972	P0400972	TOUCH-UP PAINT, GRIZZLY GREEN
973	P0400973	TOUCH-UP PAINT, GLOSSY BLACK
999	P0400999	SCALE LABEL

⚠WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.

WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We 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.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

In the event you need to use this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

For further information about the warranty, visit **https://www.grizzly.com/forms/warranty** or scan the QR code below to be automatically directed to our warranty page.

WARRANTY

grizzly.com