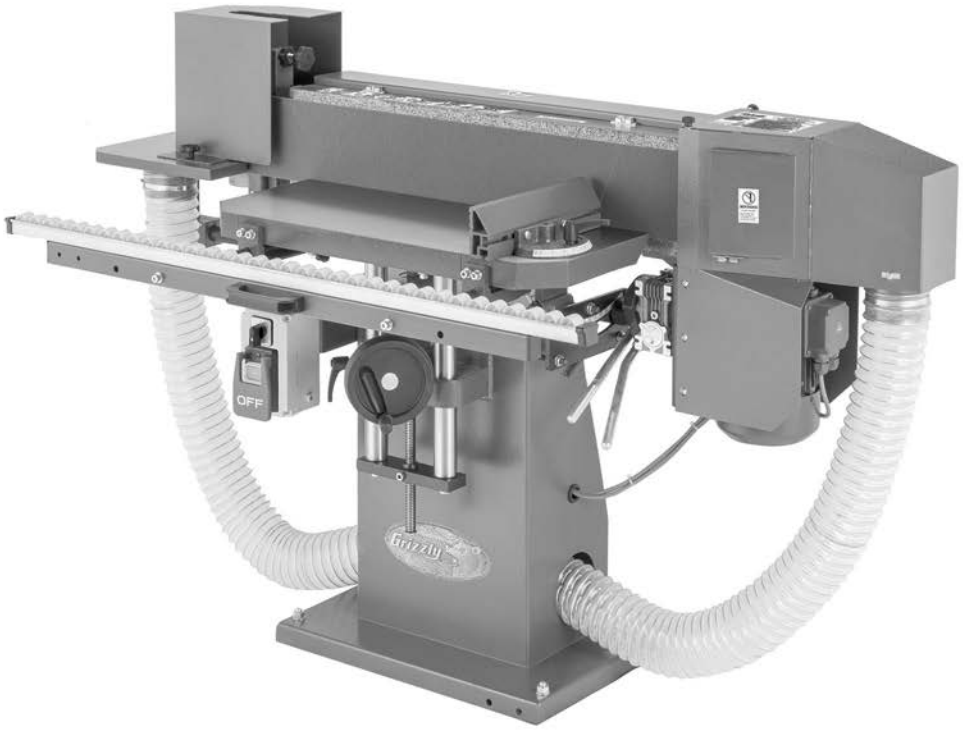
MODEL G0401
6" X 102" OSCILLATING EDGE SANDER
OWNER'S MANUAL
(For models manufactured since 12/24)



#CS23432 PRINTED IN BULGARIA V1.11.24

******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.

Table of Contents

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.

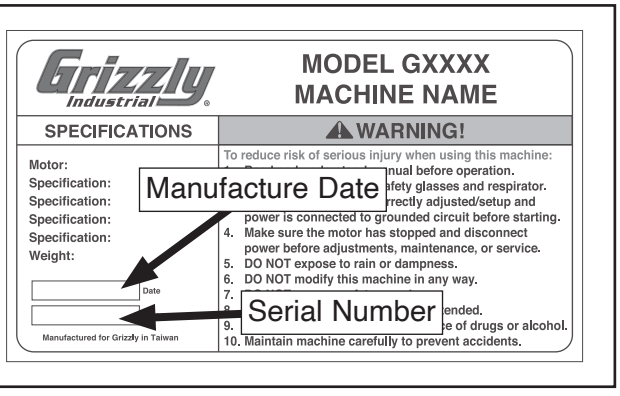
Manual Accuracy

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**.

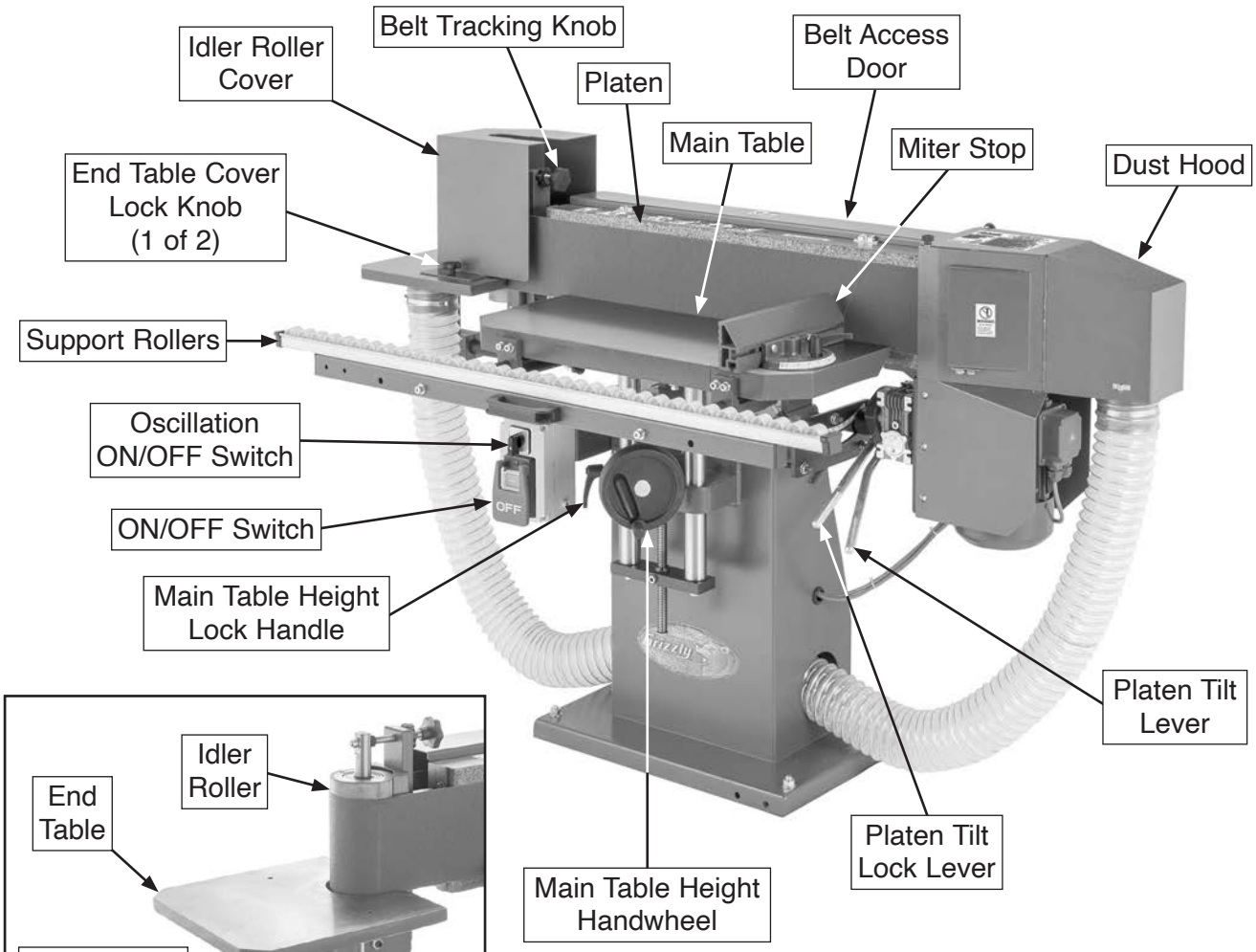
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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

For Your Own Safety Read Instruction Manual Before Operating Sander

a) Wear eye protection.
b) Support workpiece with miter gauge, backstop, or worktable.
c) Maintain 1/16 in. maximum clearance between table and sanding belt.
d) Avoid kickback by sanding in accordance with the directional arrows.

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.

Power Controls

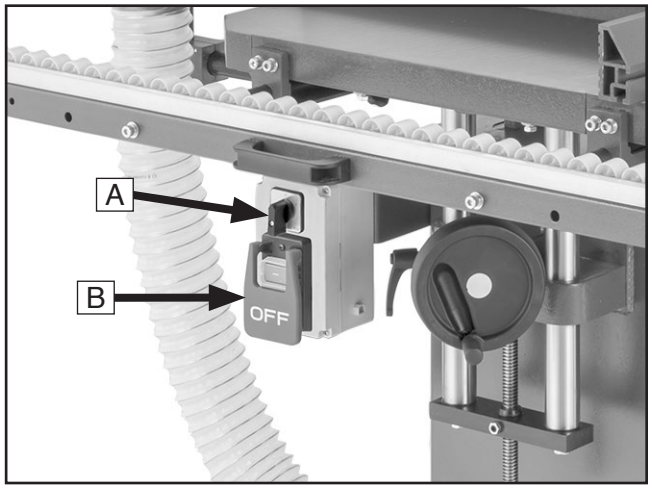


Figure 1. Power controls.

A. Oscillation ON/OFF Switch: Turns sanding belt oscillation ***ON*** or ***OFF***.

B. ON/OFF Switch: Turns main motor ***ON*** or ***OFF***. Switch can be disabled for safety by inserting a padlock (not included).

Sanding Belt

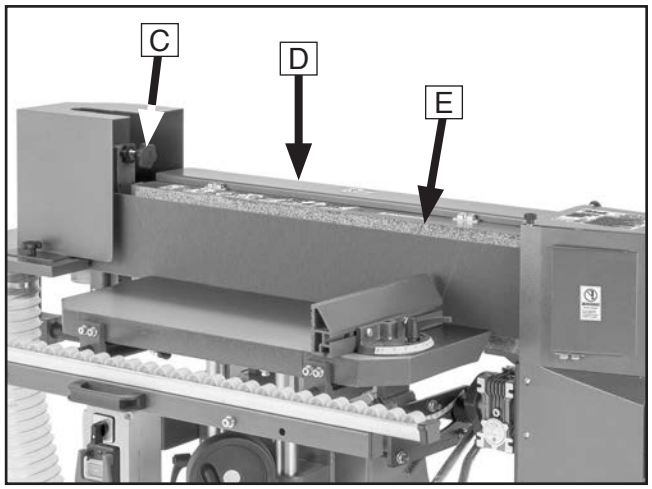


Figure 2. Sanding belt components.

C. Belt Tracking Knob: Adjusts sanding belt tracking.

D. Belt Access Door: Opens and closes to allow for sanding belt replacement and maintenance.

E. Platen: Provides flat sanding surface for end and edge sanding.

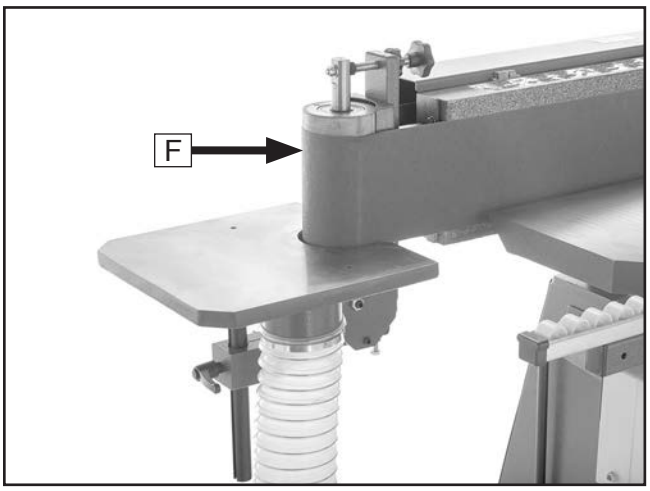


Figure 3. Idler roller.

F. Idler Roller: Provides curved sanding surface for contour sanding.

Platen

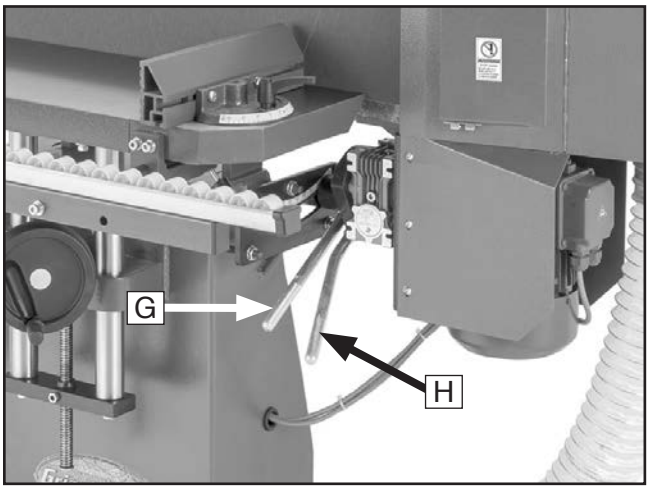


Figure 4. Platen components.

G. Platen Tilt Lock Lever: Moves toward rear of machine to allow platen to be tilted; moves toward front of machine to lock platen tilt.

H. Platen Tilt Lever: Adjusts platen tilt angle.

Tables

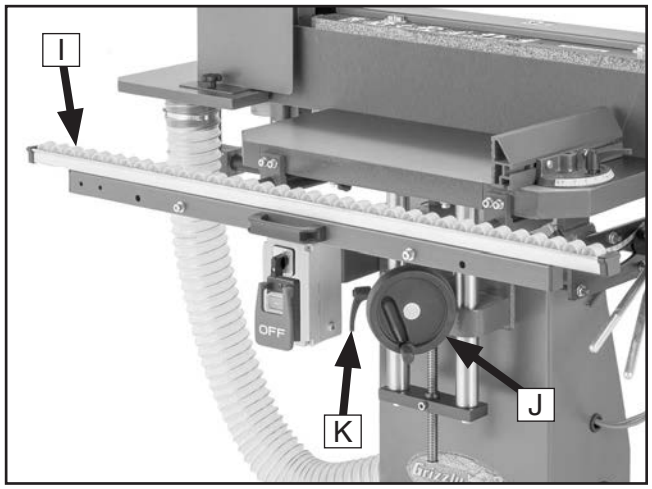


Figure 5. Main table height components and support rollers.

I. Support Rollers: Adjust toward or away from main table to support large workpieces.

J. Main Table Height Handwheel: Adjusts main table height. Each revolution of handwheel produces 0.08" (2mm) of table travel.

K. Main Table Height Lock Handle: Loosens to allow for table height adjustment; tightens to lock table height.

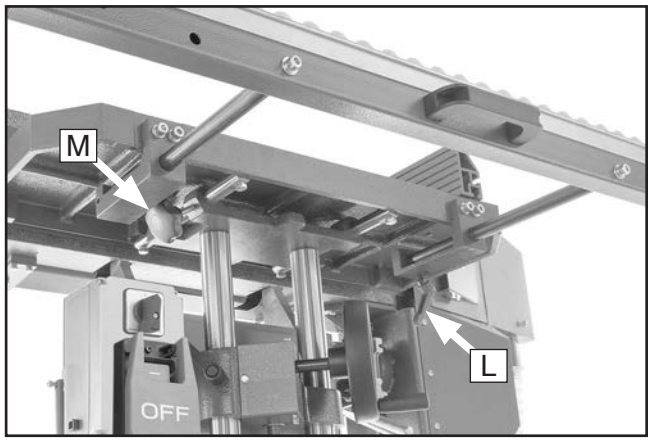


Figure 6. Main table clearance and support roller controls.

L. Support Roller Lock Handle: Loosens to adjust support rollers; tightens to lock position.

M. Main Table Clearance Lock Knob: Loosens to adjust distance between main table and platen; tightens to lock main table position.

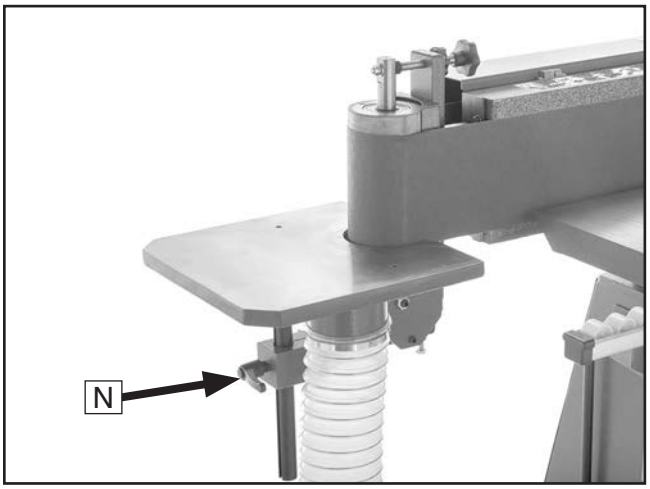


Figure 7. End table components.

N. End Table Height Lock Handle: Tightens to lock end table height; loosens to adjust end table height.

Miter Stop

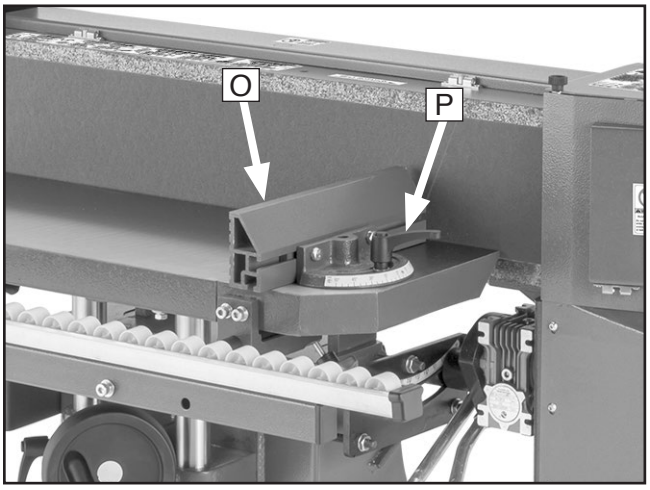


Figure 8. Miter stop components.

O. Miter Gauge w/Fence: Adjusts from 0º–60º to support workpiece against sanding belt and table.

P. Miter Gauge Lock Handle: Tightens to lock miter gauge angle; loosens to adjust miter gauge angle.

MACHINE DATA SHEET

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

MODEL G0401 6" X 102" OSCILLATING EDGE SANDER

Product Dimensions:

Weight..... 439 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 67 x 41 x 52 in.
Footprint (Length x Width)..... 23 x 16 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 611 lbs.
Length x Width x Height..... 66 x 30 x 49 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 230V, Single-Phase, 60 Hz
Full-Load Current Rating..... 15.33A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 106 in.
Power Cord Gauge..... 12 AWG
Plug Included..... Yes
Included Plug Type..... 6-20
Switch Type..... ON/OFF Push Buttons w/OFF Paddle
Inverter (VFD) Type..... MITSUBISHI FR-CS82S
Inverter (VFD) Size..... 3 HP

Motors:

Main

Horsepower..... 3 HP
Phase..... 3-Phase
Amps..... 7.62A
Speed..... 3500 RPM
Type..... Induction
Power Transfer ..... Direct
Bearings..... Shielded & Permanently Lubricated

Oscillation

Horsepower..... 1/4 HP
Phase..... 3-Phase
Amps..... 1.23A
Speed..... 1630 RPM
Type..... Induction
Power Transfer ..... Gear
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Sanding Belt Speed	3939 FPM
Sanding Belt Oscillations	3/4 in.
Sanding Belt Length	102 in.
Sanding Belt Width	6 in.
Sanding Belt Tilt	0 - 45 deg.

Table Information

Table Length	29-3/8 in.
Table Width	11-5/8 in.
Table Thickness	1-11/16 in.
Table Travel	7-1/2 in.
Floor To Table Height	28-1/2 - 36 in.
End Table Length	13 in.
End Table Width	13 in.
End Table Thickness	7/8 in.
End Table Travel	8-1/2 in.

Platen Information

Platen Type	Graphite Coated
Platen Length	33-5/8 in.
Platen Width	7-7/8 in.

Construction

Table	Cast Iron
Frame	Steel
Base	Steel
Drive Roller	Aluminum
Idler Roller	Aluminum & Rubber
Miter Block	Cast Iron & Aluminum
Paint Type/Finish	Enamel & Powder Coated

Other Related Information

Number of Dust Ports	1
Dust Port Size	6 in.
Belt Release	Quick-Release
Drive Roller Size	5-1/4 in.
Idler Roller Size	3-7/8 in.

Other Specifications:

Country of Origin	Bulgaria
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Features:

Quick-Release Belt Lever
Graphite-Coated Platen
Miter Stop Adjusts 60 Degrees L/R and Includes Adjustable Aluminum Fence
Adjustable Support Rollers on Main Table
End Table Floor-to-Table Height is 28-1/4" - 36-3/4"
Table Height Handwheel for Easy Adjustment and Maximum Use of Sanding Surface Area
Platen Tilts 0–45 Degrees

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 Oscillating Edge Sanders

⚠WARNING

Serious injury or death can occur if fingers, clothing, jewelry, or hair get entangled in moving components. Impact injuries can occur from kickback if workpiece is improperly fed into moving sandpaper. Serious pinch injuries can occur from touching in-running nip point between table and sanding surface. Long-term respiratory damage can occur from using sander without proper use of a respirator. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

AVOIDING ENTANGLEMENT. Becoming entangled in moving parts of this machine can cause pinching and crushing injuries. To avoid these hazards, DO NOT wear loose clothing, gloves, or jewelry, and tie back long hair. Keep all guards in place and secure.

IN-RUNNING NIP POINTS. The gap between moving sandpaper and fixed table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater risk of fingers or workpieces getting caught in it. Minimize this risk by adjusting table no more than 1/16" away from sandpaper.

SANDPAPER DIRECTION. Feeding workpiece incorrectly can cause it to be thrown from machine, striking operator or bystanders, or causing your hands to slip into the moving sandpaper. To reduce these risks, only sand against direction of sandpaper travel, ensure workpiece is properly supported, and avoid introducing sharp edges into moving sandpaper on leading side of workpiece.

WORKPIECE SUPPORT & HAND PLACEMENT. Rotating sandpaper can remove a large amount of skin quickly, and kickback can occur with violent force if workpiece is not properly supported during operation. Always sand with workpiece firmly against table or another support device. Never touch moving sandpaper on purpose.

WORKPIECE INTEGRITY. Only sand solid workpieces that can withstand power sanding forces. Make sure shape of workpiece is properly supported on table; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.

FEEDING WORKPIECE. Forcefully jamming workpiece into sanding surface could cause workpiece to be aggressively grabbed and pull your hands into sanding surface. Firmly grasp workpiece in both hands and ease it into sandpaper using light pressure.

SMALL WORKPIECES. Small workpieces are difficult to control and require close support near sanding surface. Always use a jig or other holding device when sanding small workpieces, and keep hands and fingers at least 2" away from sanding surface.

WORKPIECE INSPECTION. 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. Never try to sand stock that has embedded foreign objects or questionable imperfections.

SANDPAPER CONDITION. Worn or damaged sandpaper not only produces poor sanding results, but could fly apart, aggressively grab workpiece, and throw debris at the operator. Always inspect sandpaper before operation and replace if worn or damaged.

SANDING DUST & DUST COLLECTION. Sanding creates large amounts of dust and flying particles that can lead to eye injury or respiratory illness. Reduce risk by wearing approved eye and respiratory protection when using sander. Never operate without adequate dust-collection system in place and running. Proper dust collection reduces dust in work area, decreasing risk of long-term respiratory damage, but it is not a substitute for using a respirator.

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 230V 15.33A

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.

Circuit Information

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.)

⚠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.

⚠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.*

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 208V, 220V, 230V, 240V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 6-20

Grounding 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!

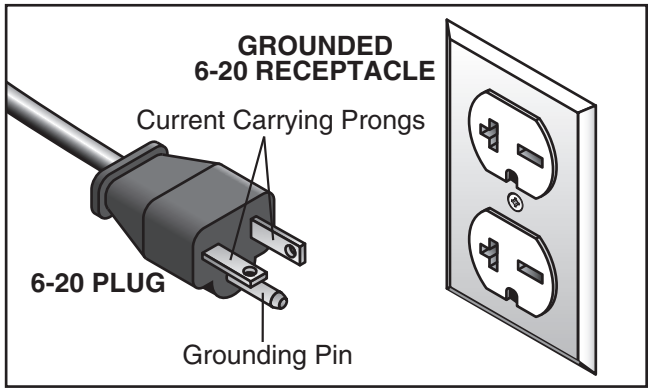


Figure 9. Typical 6-20 plug and receptacle.

⚠CAUTION

No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by electrician or qualified personnel, and it must comply with all local codes and ordinances.

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.

Sanders generate a lot of static electricity that can charge the machine housing with micro voltages. These voltages must be allowed to dissipate through a separate, physical earth ground connection than what is provided by the power cord.

⚠CAUTION

Prepare appropriate physical earth ground as required by local codes and ordinances, and connect 6 AWG grounding wire between physical ground and earth ground bolt shown in Figure 10.

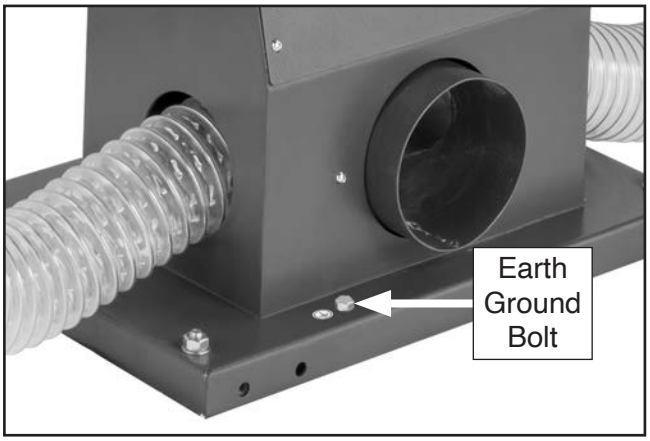


Figure 10. Location of earth ground bolt.

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

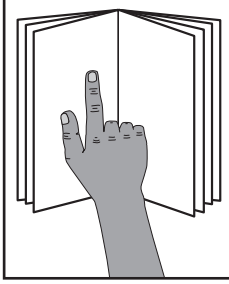
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

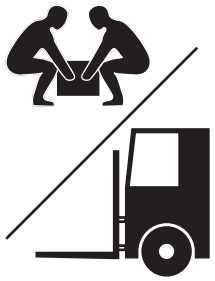


⚠WARNING

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
• Another Person	1
• Safety Glasses (for each person)	1 Pr.
• Cleaner/Degreaser	1
• Disposable Rags	1
• Disposable Gloves	1
• Lifting Straps (Rated for at least 775 lbs.)	2
• Lifting Equipment (Rated for at least 775 lbs.)	1
• Mounting Hardware	As Needed
• Wrenches or Sockets 19mm	2
• Hex Wrench 6mm	1
• Calipers or Measuring Tape	1
• Phillips Head Screwdriver #2	1
• Dust Hose 6"	1
• Hose Clamp 6"	1
• Dust Collection System	1
• T28042 or ISO 68 Equiv.	As Needed
• Grounding Conductor 6 AWG	1
• Physical Earth Ground	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.

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.

Loose Inventory (Figure 11)	Qty
A. Idler Roller Cover	1
B. Knob Bolts M8-1.25 x 16	2
C. Support Roller Assembly Handle	1
D. Lock Handle M8-1.25 x 20	1
E. End Table	1
F. Sanding Belt 6" x 102" 100-Grit	1
G. Open-End Wrench 13 x 17mm	1
H. Hex Wrench 5mm	1
I. Eye Bolt M12-1.75 x 20	1

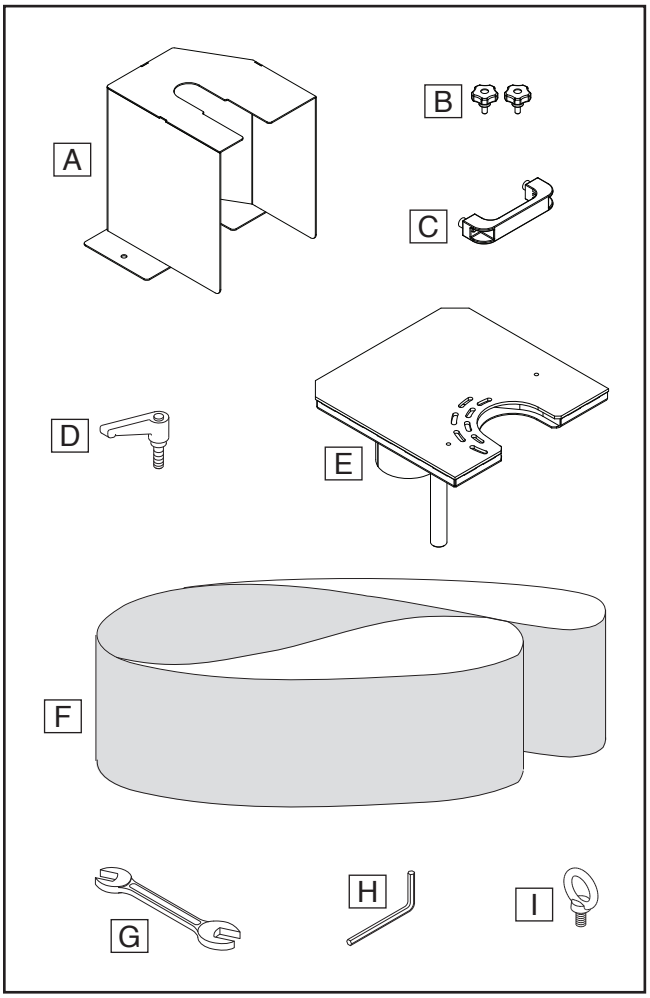


Figure 11. Loose inventory.

Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:
- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Order online at www.grizzly.com OR Call 1-800-523-4777

Figure 12. T23692 Orange Power Degreaser.

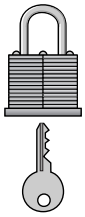
Site Considerations

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.

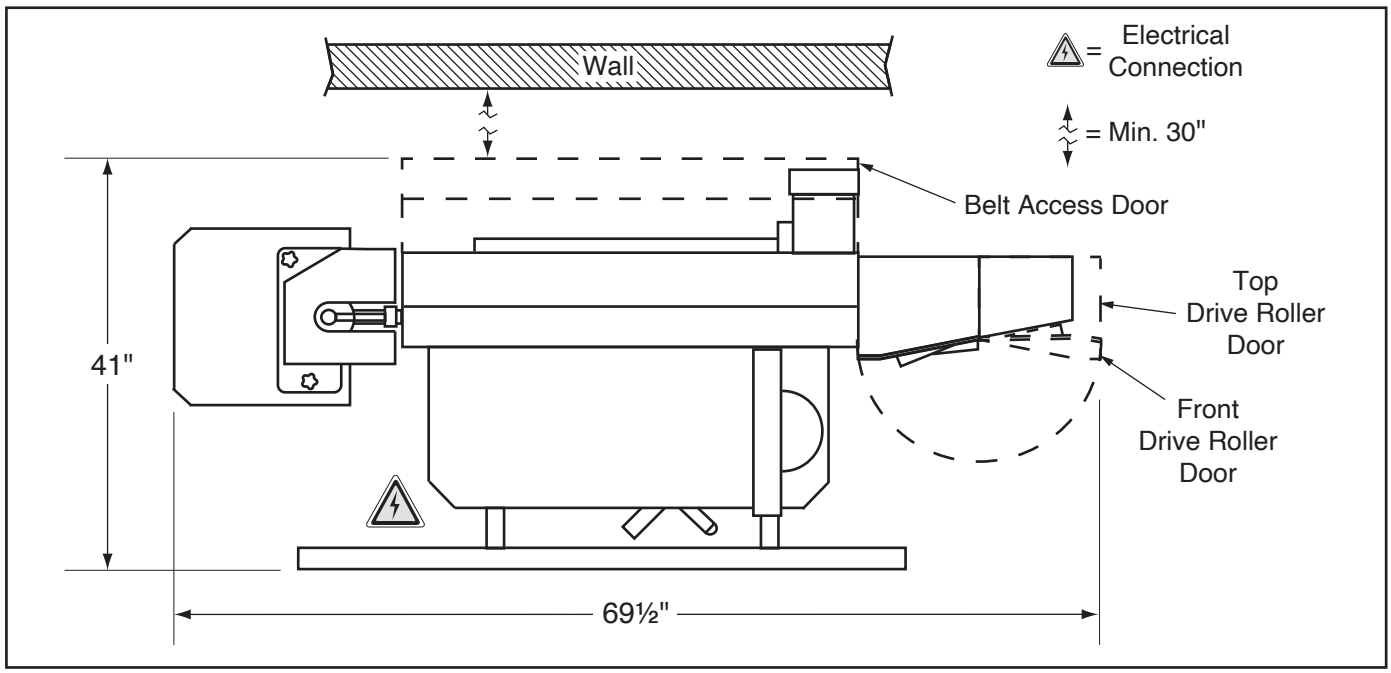
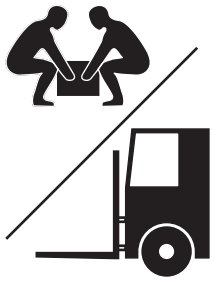


Figure 13. Minimum working clearances.

Lifting & Placing



⚠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.

The Model G0401 requires the use of lifting equipment such as a forklift, engine hoist, or boom crane. DO NOT attempt to lift or move the machine without the necessary assistance from other people. Each piece of lifting equipment must be rated for at least 775 lbs. to support the dynamic loads that may be applied while lifting.

Review the **POWER SUPPLY** section beginning on **Page 11**, then prepare a permanent location for the machine.

To lift and place machine:

1. Move pallet to suitable location.

2. Remove top and sides of shipping crate, remove any loose items and packing materials from machine.

   Note: *Do not discard shipping crate and packaging until after Test Run.*

3. Remove hardware that secures machine to pallet.

4. Thread eye bolt included with machine into platen, as shown in **Figure 14**.

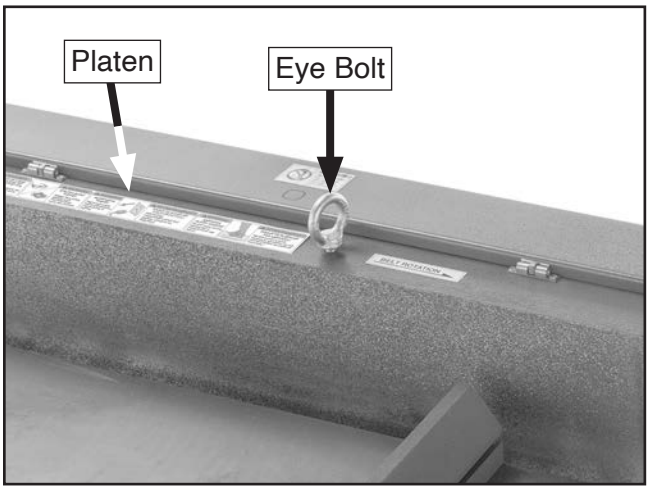


Figure 14. Eye bolt installed in platen.

5. Attach lifting strap with hook to eye bolt and lifting equipment, then use power lifting equipment to lift machine just enough so pallet can be removed.

6. Remove pallet, then lower machine into its final location.

7. Refer to **Anchoring to Floor** on **Page 18** to mount machine securely.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... ½"

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.

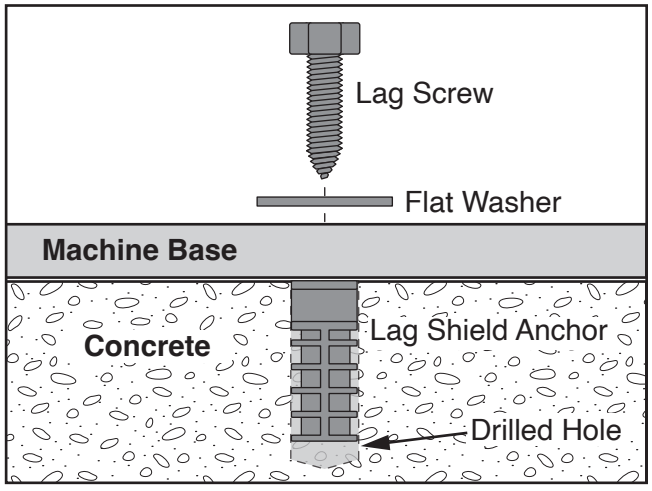


Figure 15. Popular method for anchoring machinery to a concrete floor.

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. Loosen main table clearance lock knob (see **Figure 16**), then move main table all the way forward, away from platen.

2. Loosen support roller lock handle (see **Figure 16**), then move support rollers all the way forward, away from main table.

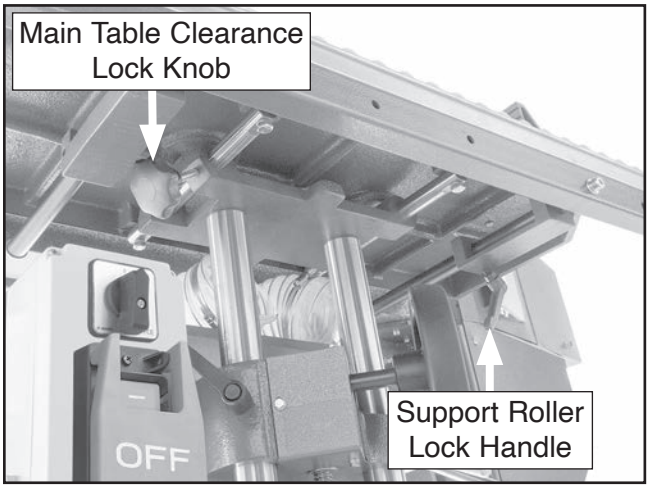


Figure 16. Main table and support roller position controls.

3. Install support roller assembly handle at location shown in **Figure 17** with pre-installed cap screws, flat washers, and lock washers.

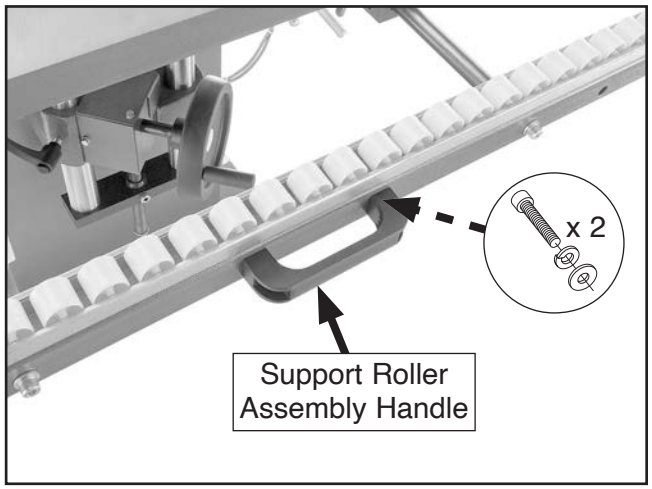


Figure 17. Support roller assembly handle installed.

4. Push belt access door toward rear of machine to open it (see **Figure 18**).

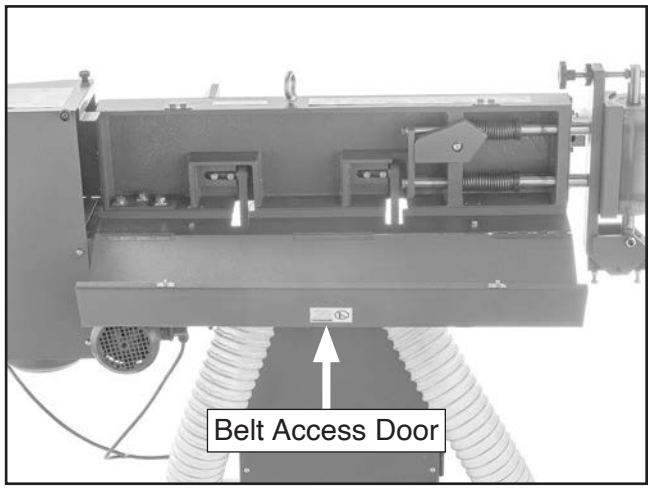


Figure 18. Belt access door pushed open.

5. Loosen (2) knobs shown in **Figure 19**, then open drive roller doors.

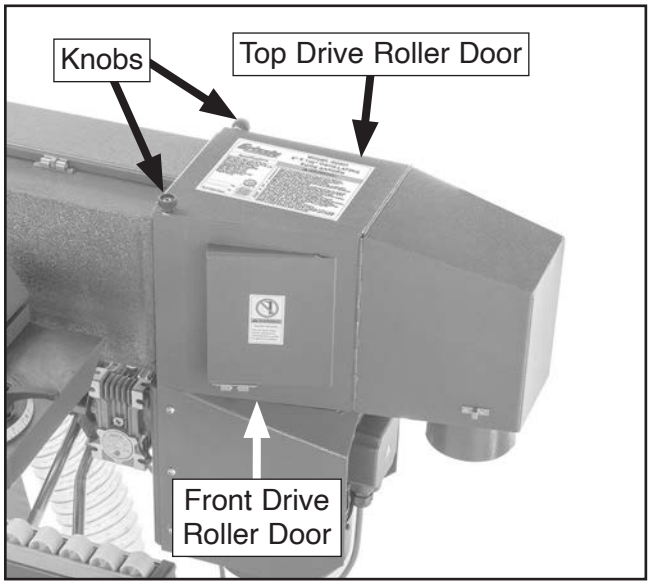


Figure 19. Location of drive roller doors and securing knobs.

6. Remove belt tension lever from cap screw shown in **Figure 20**.

Note: *Belt tension lever is stored on screw shown in **Figure 20** for shipping. Store lever in this location when not in use.*

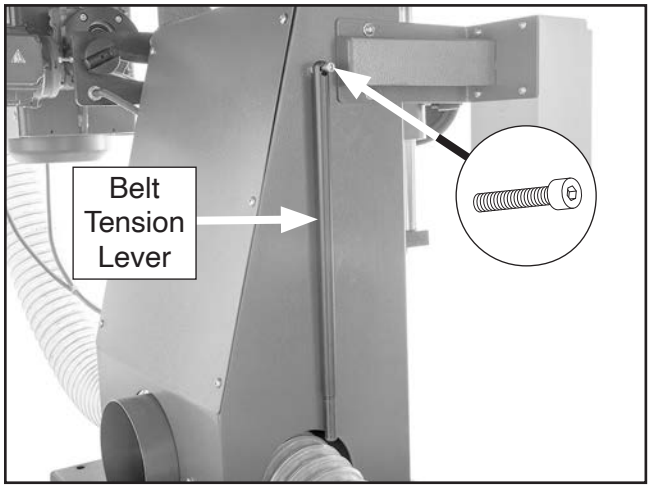


Figure 20. Belt tension lever hanging on stand screw for storage.

7. Insert belt tension lever into cam arm shown in **Figure 21**, then move belt tension lever toward idler roller until arm locks in place.

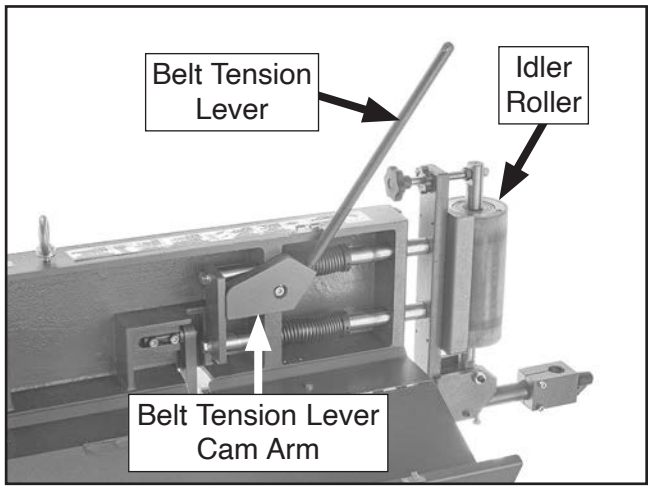


Figure 21. Belt tension lever installed and moved toward idler roller.

8. Install and center sanding belt around rollers (see **Figure 22**), being sure arrows on belt match belt rotation arrow label on machine.

9. Move belt tension lever away from idler roller to tension sanding belt (see **Figure 22**), then remove belt tension lever and hang lever on storage screw.

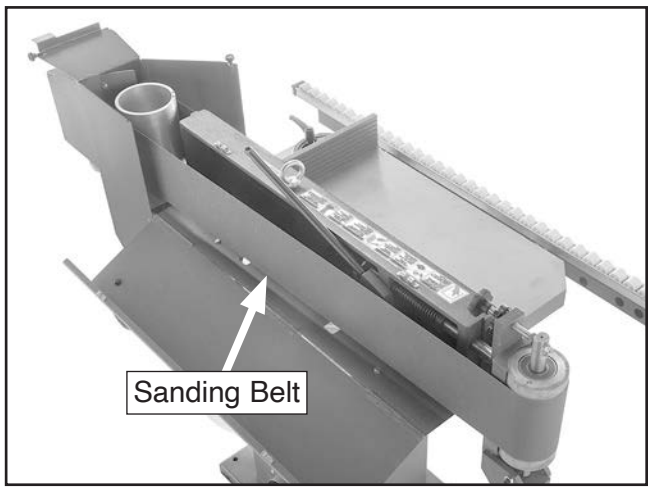


Figure 22. Belt installed around rollers tensioned.

10. Insert end table shaft in bracket shown in **Figure 23**, lower table until table surface is just above bottom edge of sanding belt, then secure table with M8-1.25 x 20 lock handle.

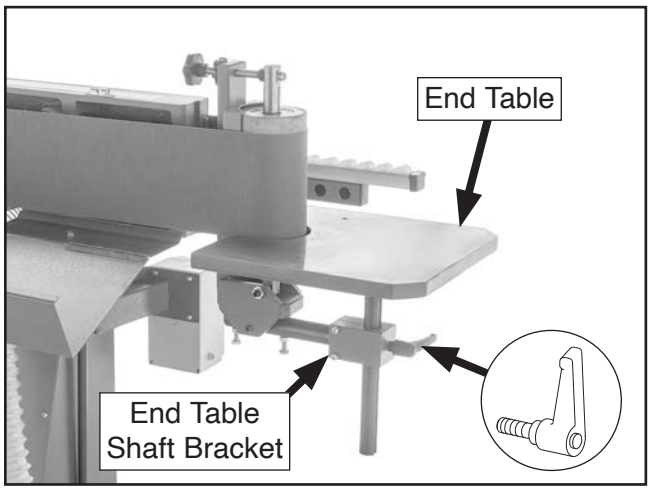


Figure 23. End table installed.

11. Install loose end of (1) 4" dust hose on drive roller dust port shown in **Figure 24**, then secure in place with pre-installed hose clamp.

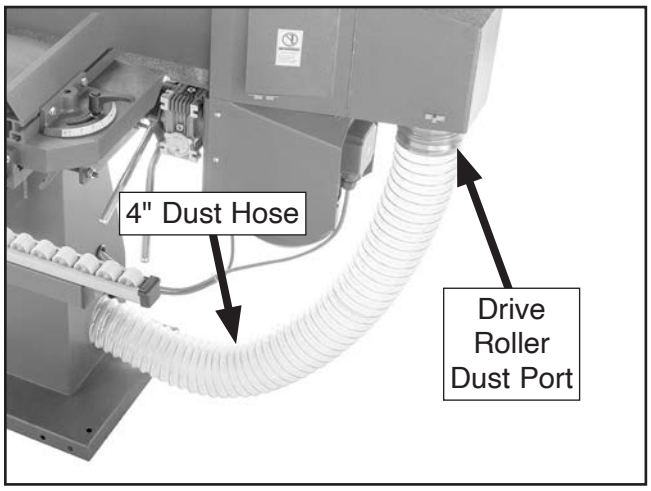


Figure 24. Dust hose installed on drive roller dust port (drive roller doors closed for clarity).

12. Install loose ends of remaining 4" dust hose on idler roller dust port shown in **Figure 25**, then secure in place with pre-installed hose clamp.

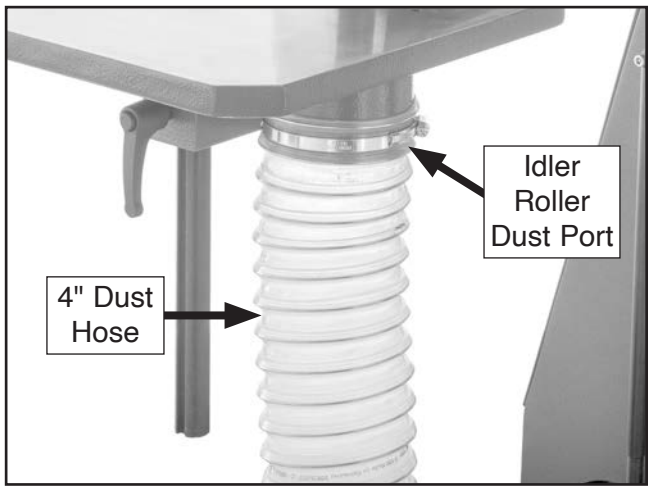


Figure 25. Dust hose installed on idler roller dust port.

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: 850 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 6" dust hose over 6" dust port, as shown in **Figure 26**, and secure in place with hose clamp.

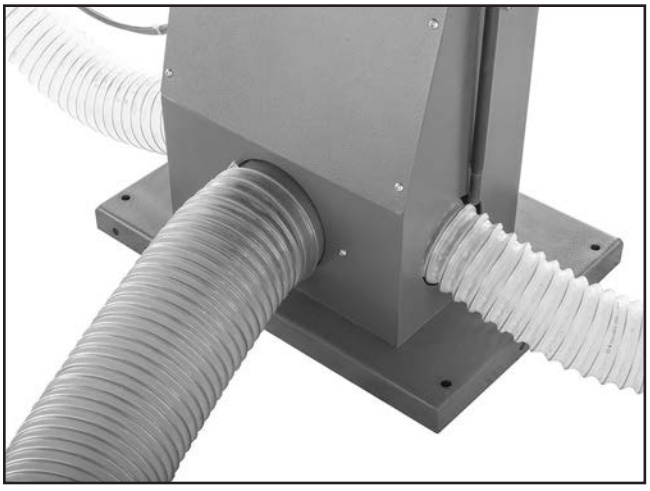


Figure 26. Dust hose attached to 6" dust port.

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, contact Mitsubishi to obtain a FR-CS82S-100-60 manual (or visit **https://emea.mitsubishielectric.com/**). All VFD servicing should be done by an authorized and trained technician. The machine operator will never need to adjust the VFD parameters and tampering with the VFD setting can void the warranty.

The Test Run consists of verifying the following: 1) The sanding belt tracks properly and will not come off rollers during initial startup, and 2) the motors power up and run 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. Check gearbox oil level in sight glass (see **Figure 27**).

   — If oil level fills about half of sight glass, no oil needs to be added. Proceed to **Step 3**.

   — If oil level fills *less than* half of sight glass, proceed to **Step 2**.

2. Remove fill cap (see **Figure 27**), add oil until it fills half of sight glass, then install fill cap.

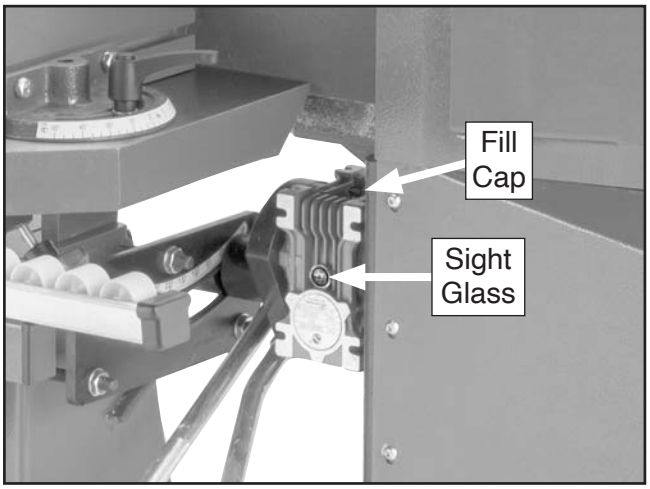


Figure 27. Location of gearbox sight glass and fill cap.

3. Clear all setup tools away from machine.

4. Move oscillation ON/OFF switch to OFF (0) position (see **Figure 28**).

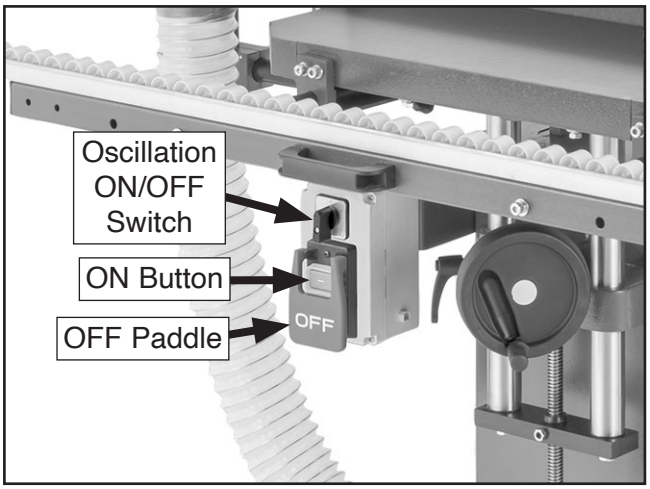


Figure 28. Power controls.

5. Standing in front of sander, manually turn drive roller counterclockwise to move sanding belt in direction of operation (counterclockwise on rollers, as viewed from above), then watch how belt tracks on rollers (see **Figure 29**).

6. Loosen belt tracking lock knob, then adjust belt tracking knob (see **Figure 29**) while continuing to rotate sanding belt by hand until sanding belt stays centered on rollers.

   — Turn knob clockwise to adjust tracking downward or counterclockwise to adjust tracking upward.

   Note: *Adjust knob in about ¼-turn increments.*

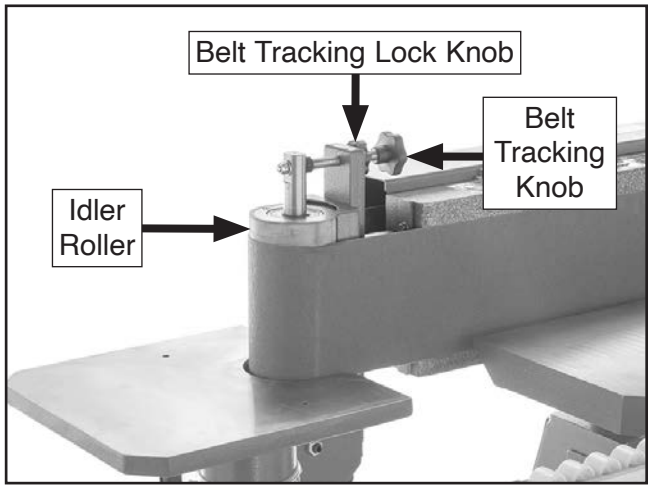


Figure 29. Belt tracking components.

⚠WARNING

Only make initial tracking adjustments with machine disconnected from power. Belt MUST track centered on rollers before machine is connected to power to make final tracking adjustments. DO NOT attempt to touch sanding belt while machine is connected to power.

7. Connect machine to power supply.

8. Use ON button (–) and OFF paddle (see **Figure 28** on **Page 22**) to start and immediately stop machine, while watching how sanding belt tracks on rollers. "Tracking" refers to sanding belt positioning on rollers when sanding belt rotates. When tracking properly, sanding belt remains centered on rollers as they rotate.

   Note: *When sanding belt oscillation is turned **ON**, sanding belt will oscillate up and down on rollers, but will ultimately stay centered on rollers so it does not wander off of rollers. Do not confuse sanding belt oscillation with poor sanding belt tracking.*

   — If sanding belt tracks centered on rollers, no adjustment is necessary. Proceed to **Step 11**.

   — If sanding belt *does not* track centered on rollers, proceed to **Step 9**.

9. Use belt tracking knob to adjust belt tracking.

   Note: *Adjust knob in about ¼-turn increments.*

10. Repeat **Steps 8–9** until sanding belt tracks in center of rollers.

11. Tighten belt tracking lock knob without moving belt tracking knob to secure setting.

12. Start machine and allow it to run while ensuring sanding belt tracks properly.

    Sanding belt motor should run smoothly and without unusual problems or noises, and sanding belt MUST rotate in same direction as arrow of belt rotation on machine.

    — If motor runs smoothly and sanding belt rotates in correct direction, proceed to **Step 13**.

    — If motor *does not* run smoothly, or sanding belt *does not* rotate in correct direction, turn machine ***OFF*** and disconnect power. Contact Technical Support before proceeding.

13. Move oscillating ON/OFF switch clockwise to ON position (1) to start sanding belt oscillation.

Oscillation motor should run smoothly and without unusual problems or noises.

— If motor runs smoothly, proceed to **Step 14**.

— If motor *does not* run smoothly, turn machine ***OFF*** and disconnect power. Contact Technical Support before proceeding.

14. Press OFF paddle to turn machine ***OFF***, then DISCONNECT MACHINE FROM POWER!

15. Close drive roller doors and secure with lock knobs, then close belt access door.

16. Place idler roller cover on end table, then secure with (2) M8-1.25 x 16 knob bolts (see **Figure 30**).

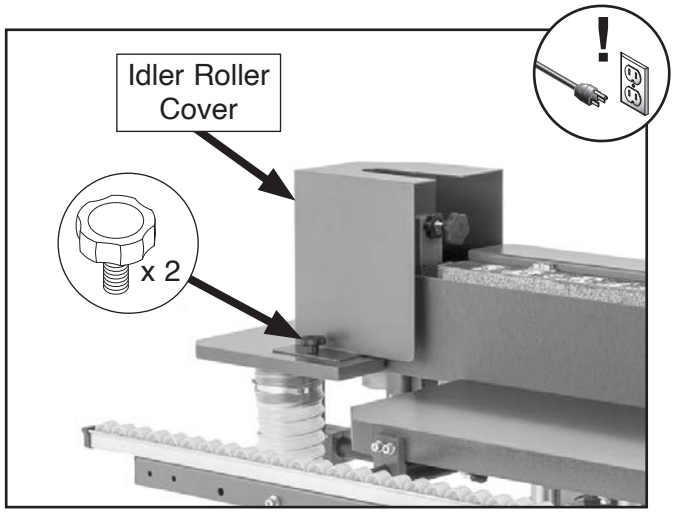


Figure 30. Idler roller cover installed on end table.

17. Push main table closer to sanding belt until table is within 1/16" of sanding belt without touching (see **Figure 31**), then tighten main table clearance lock knob (see **Figure 32**).

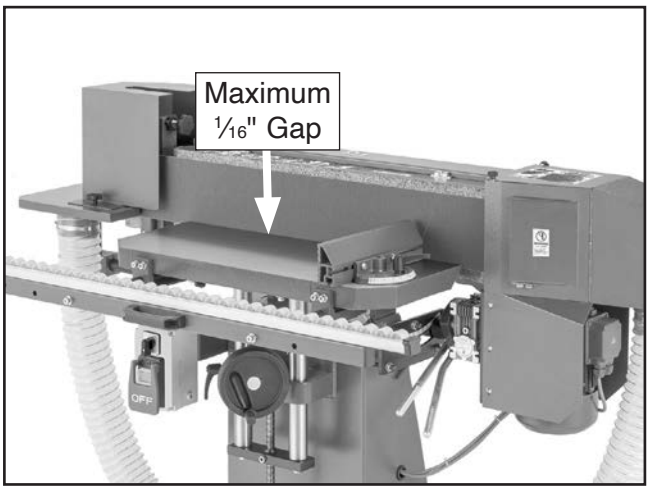


Figure 31. Main table adjusted to within 1/16" of sanding belt without touching.

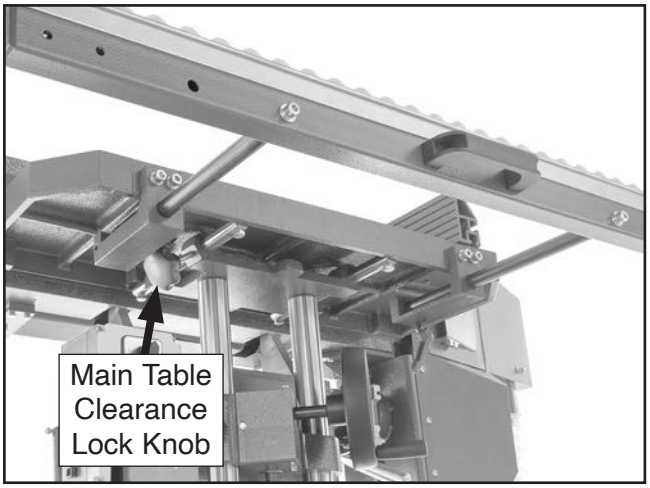


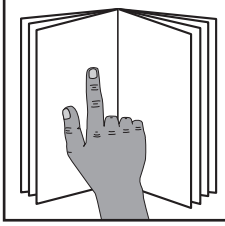
Figure 32. Location of main table clearance lock knob.

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.

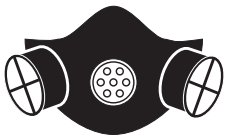


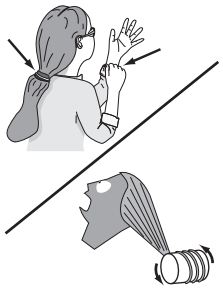
⚠WARNING

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!

NOTICE

If you are not experienced with this type of machine, WE STRONGLY RECOMMEND that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

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

1. Examines workpiece to make sure it is suitable for sanding. No extreme bows, knots, or cracks should exist.
2. Prepares and trims workpiece as necessary.
3. Installs sanding belt with appropriate grit for operation.
4. Adjusts platen tilt and table height as desired, then adjusts table clearance to allow maximum of 1/16" clearance between table and sanding belt.
5. Ties back loose hair and clothing, and puts on safety glasses and respirator. Takes all other required safety precautions.
6. Starts dust collector and sander.
7. With both hands, holds workpiece firmly and flatly against table (and miter stop, if using main table), and gradually eases workpiece into sanding belt.
8. Stops machine and dust collection system.

Disabling & Locking Switch

The switch can be disabled and locked by inserting a padlock through the ON/START button, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

IMPORTANT: Locking the switch with a padlock only restricts its function. It is not a substitute for disconnecting power from the machine when adjusting or servicing.

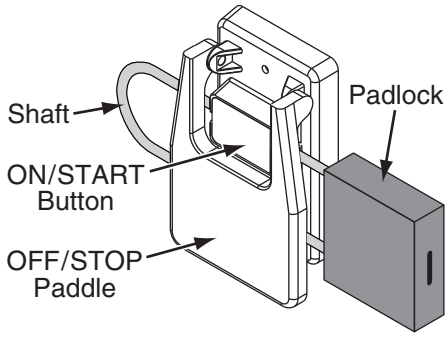


Figure 33. Switch disabled by padlock.

⚠WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, disable and lock the switch before leaving machine unattended! Place key in a well-hidden or secure location.

NOTICE

The padlock shaft diameter is important to the disabling function of the switch. With any padlock used to lock the switch, test the switch after installation to ensure that it is properly disabled.

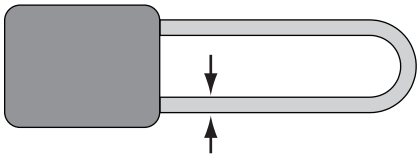


Figure 34. Minimum lock shaft requirements.

Workpiece Inspection

Some workpieces are not safe to sand or may require modification before they are safe to sand.

Before sanding, inspect all workpieces for the following:

- ***Material Type:*** This machine is intended for sanding natural and man-made wood products. This machine is NOT designed to sand metal, glass, stone, tile, plastics, drywall, cement backer board, laminate products, etc.

  Sanding improper materials increases risk of respiratory harm to operator and bystanders due to especially fine dust inherently created by all types of sanding operations—even if a dust collector is used. Additionally, life of machine and sanding belts will be greatly reduced (or immediately damaged) from sanding improper materials or from exposure to fine dust created when doing so.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear sanding belt. Always visually inspect your workpiece for these items. If they cannot be removed, DO NOT sand the workpiece.

- ***Wet or "Green" Stock:*** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding belt, increases the risk of kickback, and yields poor results.

Sanding Tips

- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.
- Extend the life of sanding belts by regularly using a PRO-STIK® abrasive surface cleaner (see **Cleaning Sanding Belt** on **Page 38**).
- As a rule-of-thumb, sand with progressively higher grit numbers in increments of 50 or less.
- Replace sandpaper with a higher grit to achieve a finer finish (refer to **Installing/ Changing Sanding Belts** on **Page 28**).
- Hold the workpiece securely with both hands. Use the table and back stop whenever possible to support workpieces. Do not force the workpiece against the belt.
- When sanding workpieces with a bow or crown, place the high point up on the table to prevent the workpiece from rocking, then take very light passes.
- Use the full width of the sanding belt by adjusting the table height or workpiece position so sanding is not always done in just one area.
- Make sure belt access and drive roller doors are closed and secured during operation.
- Belts clog and wear. Change belts whenever you notice a difference in sanding quality/ performance.

⚠WARNING

Moving belt can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Always support workpiece against table and back stop when sanding. Use extreme care to provide a safe distance between belt and any body parts.

Choosing Sanding Belts

The Model G0401 uses a 6" x 102" sanding belt.

We recommend using aluminum-oxide sanding belts for best results. The grit you choose will depend on the condition and species of wood, and the level of finish you wish to achieve.

Grit	Class	Usage
36	Extra Coarse	Rough sawn boards, thickness sanding, and glue removal.
60	Coarse	Thickness sanding and glue removal.
80–100	Medium	Removing 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—in increments of 50 or less. Avoid skipping grits; the larger the grit increase at one time, the harder it will be to remove the scratches from the previous grit.

Note: *Sandpaper finer than 180-grit will easily load up or burn the workpiece.*

Installing/Changing Sanding Belts

The sanding belt should be replaced whenever there is a noticeable change in sanding quality/performance. You may also need to change grit sizes of sanding belt for quick material removal or finer finishes.

Required Sanding Belt Size .....6" x 102"

To install/change sanding belt:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (2) knobs bolts shown in **Figure 35** to remove idler roller cover.

3. While holding end table, loosen end table height lock handle (see **Figure 35**), and lower end table all the way to move it out of the way for the following steps.

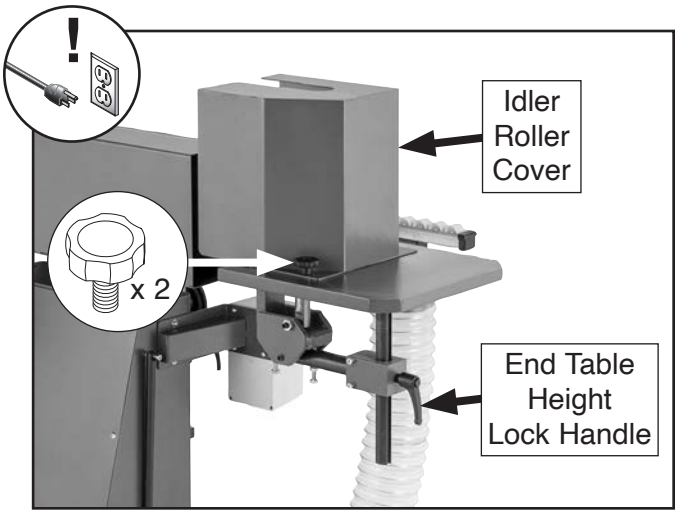


Figure 35. Location of idler roller cover knob bolts and end table height lock handle.

4. Loosen main table clearance lock knob (see **Figure 36**), then move main table away from platen.

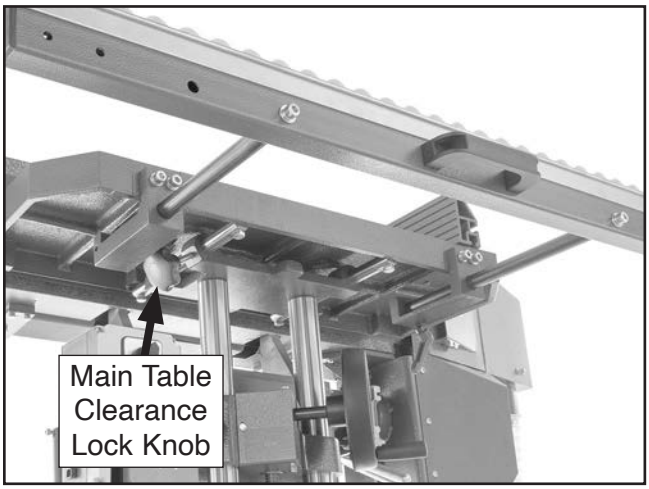


Figure 36. Location of main table clearance lock knob.

5. Push belt access door toward rear of machine to open it (see **Figure 37**).

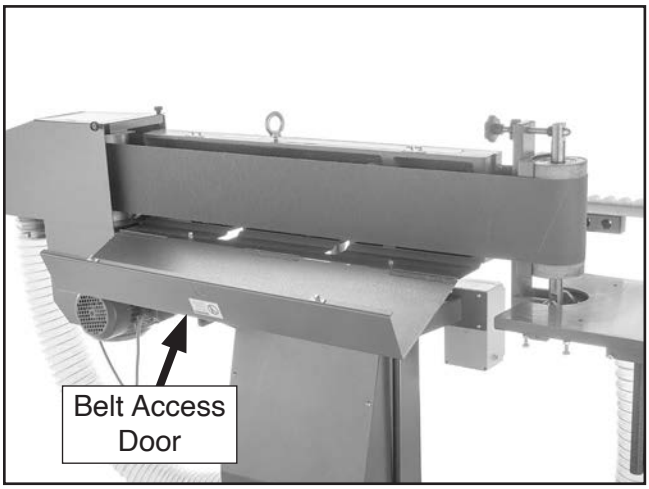


Figure 37. Belt access door pushed open.

6. Loosen (2) knobs shown in **Figure 38**, then open drive roller doors.

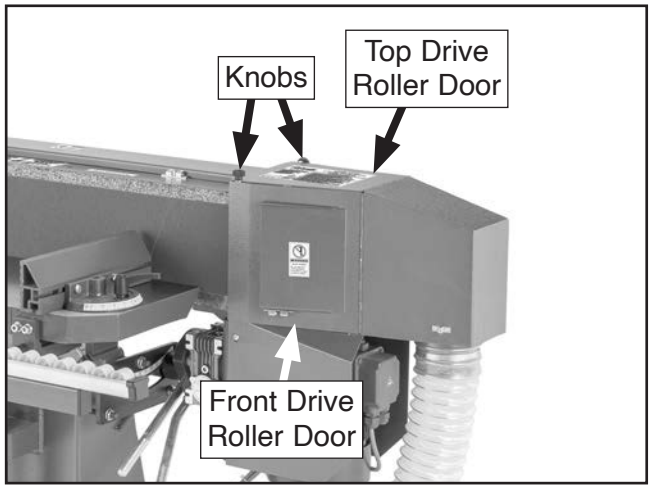


Figure 38. Drive roller doors and knobs.

7. Insert belt tension lever into cam arm shown in **Figure 39**, then move belt tension lever toward idler roller until arm locks in place.

8. Remove old sanding belt and replace with new one (see **Figure 39**), being sure arrows on belt match belt rotation arrow label on machine.

9. Move belt tension lever away from idler roller to tension sanding belt (see **Figure 39**), store belt tension lever on storage screw.

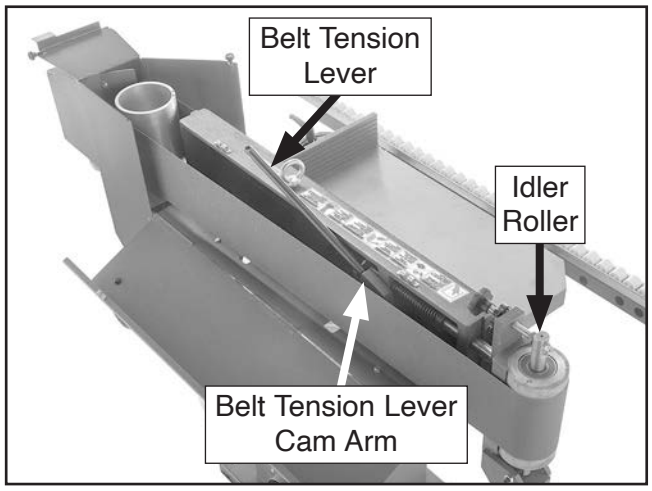


Figure 39. Belt installed and tensioned.

10. Proceed to **Checking/Adjusting Sanding Belt Tracking.**

Checking/Adjusting Sanding Belt Tracking

The purpose of belt tracking is to make sure the belt stays centered on the rollers and platen during sanding operations. The belt tracking needs to be checked any time you change or replace the belt.

If belt tracking is not adjusted properly, the belt can be damaged and presents a serious safety hazard if it moves off of the rollers and throws material when it contacts the belt guard and other components.

To check/adjust sanding belt tracking:

1. DISCONNECT MACHINE FROM POWER!

2. Standing in front of sander, manually turn drive roller counterclockwise to move sanding belt in direction of operation (counterclockwise on rollers, as viewed from above), then watch how belt tracks on rollers (see **Figure 40**).

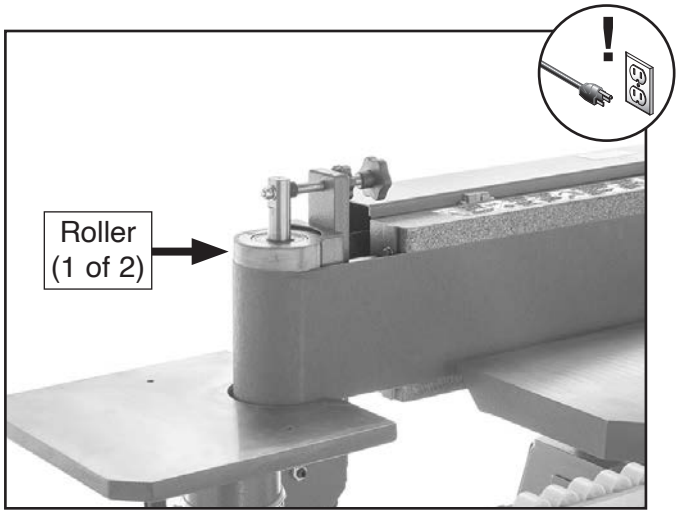


Figure 40. Location of rollers.

3. Loosen belt tracking lock knob, then adjust belt tracking knob while continuing to rotate sanding belt by hand until sanding belt stays centered on rollers (see **Figure 41**).

   — Turn knob clockwise to adjust tracking downward or counterclockwise to adjust tracking upward.

   Note: *Adjust knob in about ¼-turn increments.*

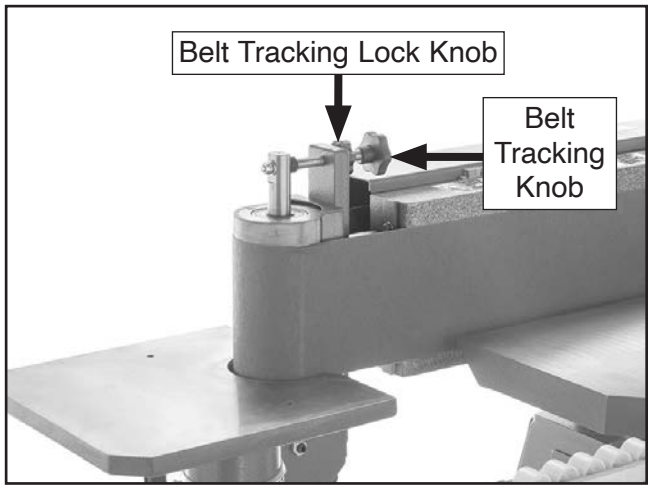


Figure 41. Belt tracking components.

⚠WARNING

Only make initial tracking adjustments with machine disconnected from power. Belt MUST track centered on rollers before machine is connected to power to make final tracking adjustments. DO NOT attempt to touch sanding belt while machine is connected to power.

4. Connect machine to power.

5. Press ON button (–), then press OFF paddle immediately after. Sander should run just long enough to observe sanding belt tracking across rollers and platen.

   Note: *When sanding belt oscillation is turned **ON**, sanding belt will oscillate up and down on rollers, but will ultimately stay centered on rollers so it does not wander off of rollers. Do not confuse sanding belt oscillation with poor sanding belt tracking.*

   — If sanding belt tracks centered on rollers, no adjustment is necessary. Proceed to **Step 8**.

   — If sanding belt *does not* track centered on rollers, proceed to **Step 6**.

6. Use belt tracking knob to adjust sanding belt tracking.

   Note: *Adjust knob in about ¼-turn increments.*

7. Repeat **Steps 5–6** until sanding belt tracks in center of rollers.

8. Tighten belt tracking lock knob (see **Figure 41**) without moving belt tracking knob to secure setting.

9. Install idler roller cover.

10. Close drive roller doors and secure with lock knobs, then close belt access door.

11. Adjust main table height and clearance (see **Adjusting Main Table** on **Page 33**) and end table height (see **Adjusting End Table Height** on **Page 34**) before proceeding with operations.

Adjusting Platen Tilt

The platen adjusts from 0º–45º for beveled workpieces.

Note: *A stop bolt stops the platen at 0º (90º in relation to main table). Refer to* ***Squaring Platen to Main Table*** *on* ***Page 44*** *if this stop bolt requires adjustment.*

When adjusting the platen tilt to an angle other than 0º, be advised that the existing miter fence cannot be adjusted to within 1/16" of the entire platen. Consider using an auxiliary fence that conforms to the angle of the platen to reduce the pinch risk this presents.

Adjusting Platen Tilt

1. DISCONNECT MACHINE FROM POWER!

2. Loosen main table clearance lock knob (see **Figure 42**), then move main table away from platen.

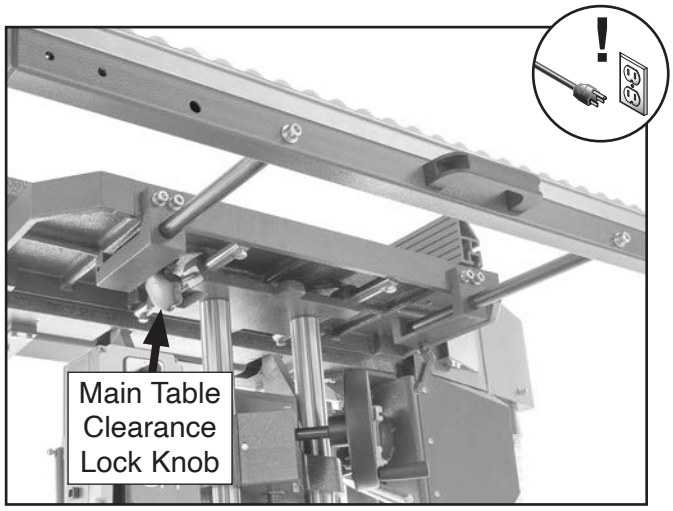


Figure 42. Location of main table clearance lock knob.

3. While holding platen tilt lever, push platen tilt lock lever toward rear of machine to unlock it, then use platen tilt lever to adjust platen tilt until tilt block aligns with desired angle on tilt scale (see **Figure 43**).

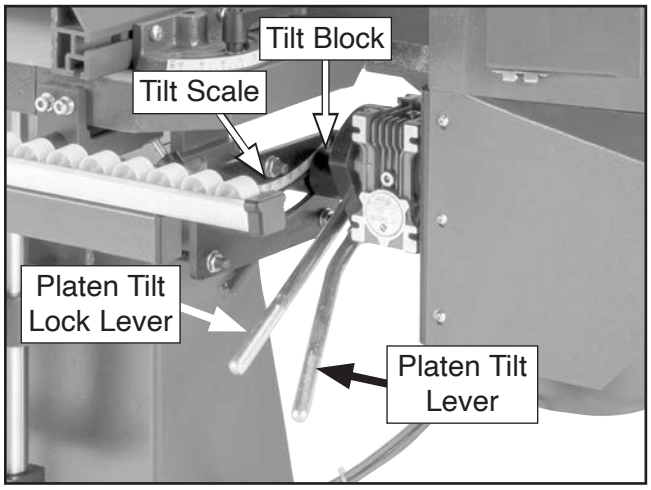


Figure 43. Platen tilt components.

4. Pull platen tilt lock lever toward front of machine to lock platen tilt.

5. Adjust main table height, then adjust main table clearance to within 1/16" of sanding belt (see **Adjusting Main Table** on **Page 33**).

Making an Auxiliary Fence

Any support fixture close to the platen that is more than 1/16" from the sanding belt results in an in-running nip point that could pull fingers or workpieces into the open space.

A shop-made auxiliary fence will allow you to use the installed miter stop for operations where the platen has been tilted, instead of removing it and installing some other jig or fixture. This fence should be cut to the same angle as the platen tilt in order to minimize the risk of pinch points for fingers or workpieces.

Items Needed	**Qty**
Hardwood 3/4" x 3" x 14"	1
Calipers or Measuring Tape	1
Marker	1
Drill	1
Drill Bits for Countersinking	As Needed
Hex Nuts M8-1.25	2

To make an auxiliary fence:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust platen tilt to desired bevel angle (see **Adjusting Platen Tilt**).

3. Cut piece of hardwood stock at least ¾" thick to same height as existing miter fence, and at least 14" long (see **Figure 44**).

   Note: *We recommend cutting hardwood board oversize, then jointing/planing it to size to make sure board is square and flat.*

4. Mark and cut desired bevel angle (same as platen tilt angle) on one edge of board (see **Figure 44**).

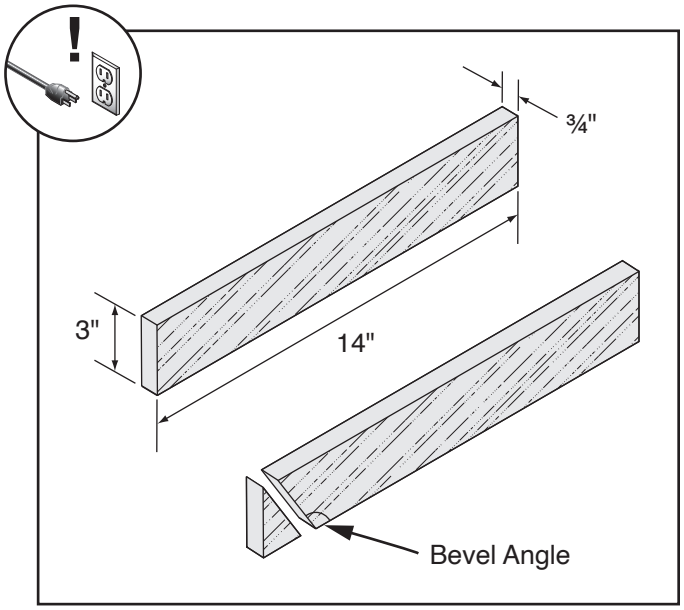


Figure 44. Auxiliary fence dimensions.

5. Adjust main table height as desired (see **Adjusting Main Table** on **Page 33**).

6. Remove (2) hex bolts and lock washers shown in **Figure 45** to remove fence from miter stop.

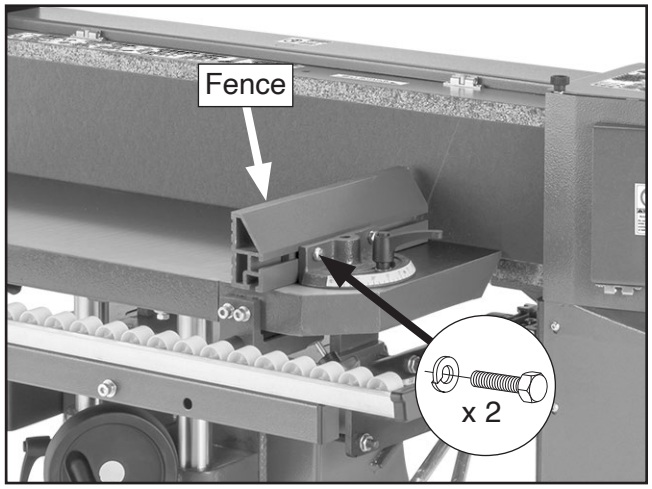


Figure 45. Location of miter fence and securing fasteners.

7. Place board in miter fence position against table so angled edge is within 1/16" of sanding belt (see **Figure 46**).

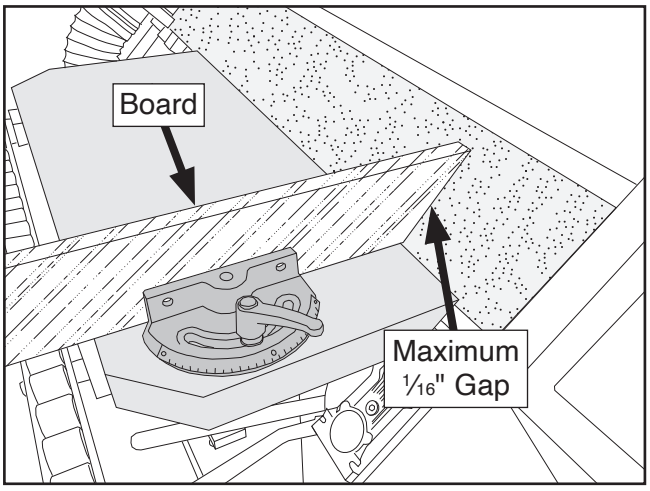


Figure 46. Board in miter fence position.

8. Use miter fence hex bolt holes to mark (2) mounting holes on board.

9. Drill countersunk mounting holes in auxiliary fence so hex nuts can be used with miter fence hex bolts and flat washers to secure auxiliary fence to miter stop (see **Figure 47**).

   Note: *Drilling these holes is a two-step process. Drill first holes all the way through board with a diameter a little larger than shaft of hex bolt. Drill second holes 9/16" through board with a diameter a little larger than hex nut outer width. Second holes must be deep enough that hex nut and hex bolt threads will be well below surface of board.*

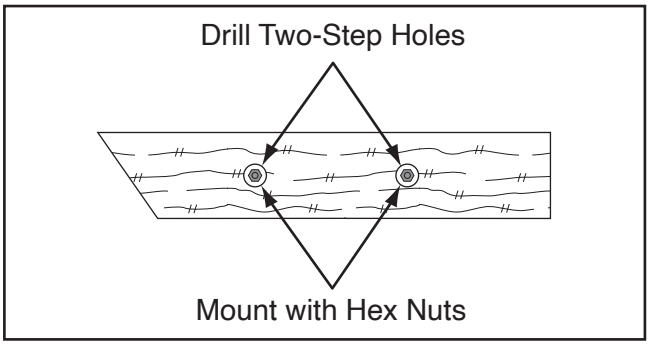


Figure 47. Example of auxiliary fence mounting holes.

10. Secure auxiliary fence to miter stop with miter fence hex bolts and lock washers removed in **Step 6**, and (2) M8-1.25 hex nuts.

Adjusting Main Table

The main table height and clearance are adjustable to accommodate a wide range of sanding operations and to prolong sanding belt life.

Adjusting Main Table Height

1. DISCONNECT MACHINE FROM POWER!

2. Loosen main table height lock handle (see **Figure 48**).

3. Adjust main table height handwheel (see **Figure 48**) as desired.

   — Turn handwheel clockwise to move table up.

   — Turn handwheel counterclockwise to move table down.

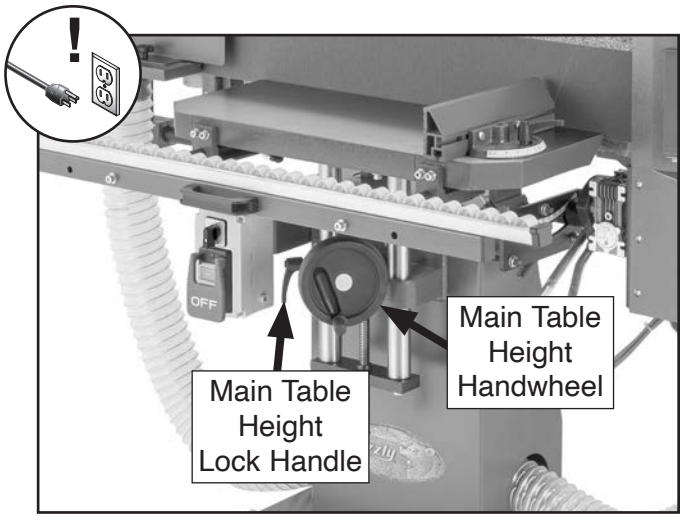


Figure 48. Main table height adjustment components.

4. Tighten main table height lock handle to secure.

5. Main table clearance MUST be adjusted to within 1/16" of sanding belt before platen sanding. Proceed to **Adjusting Main Table Clearance** before proceeding with platen sanding operation.

Adjusting Main Table Clearance

The clearance between the main table and the sanding belt must never exceed 1/16" to minimize the risk of pinch points for fingers or workpieces. Check the main table clearance any time the main table height or the platen tilt has been adjusted.

Items Needed	**Qty**
Calipers or Measuring Tape	1

To adjust main table clearance:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen main table clearance lock knob (see **Figure 49**).

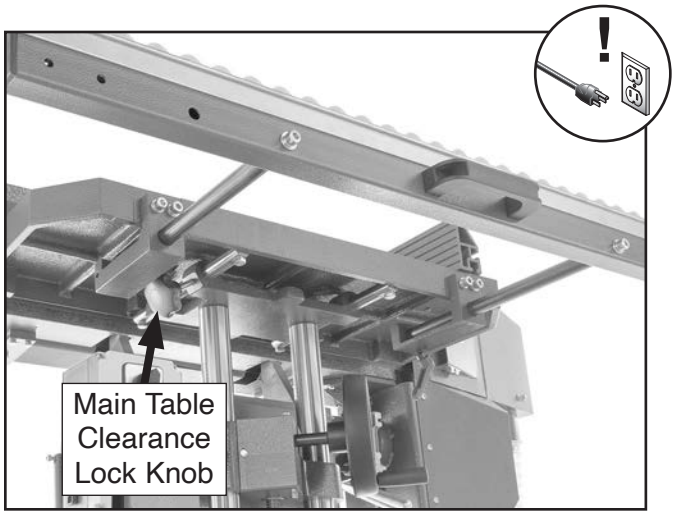


Figure 49. Location of main table clearance lock knob.

3. Push main table closer to sanding belt until table is within 1/16" of sanding belt without touching (see **Figure 50**), then tighten main table clearance lock knob.

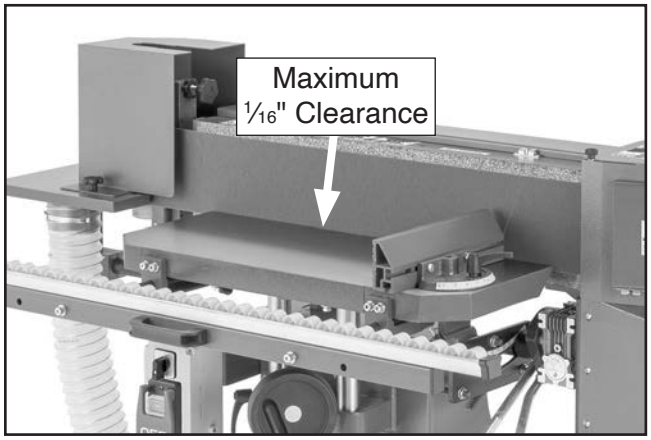


Figure 50. Main table adjusted to within 1/16" of sanding belt without touching.

Adjusting End Table Height

The end table has 8½" of vertical travel to accommodate a wide range of workpieces and to prolong sanding belt life.

To adjust end table height:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (2) knob bolts shown in **Figure 51** to remove idler roller cover.

3. While holding end table, loosen end table lock handle, adjust end table height as desired, then tighten lock handle to secure (see **Figure 51**).

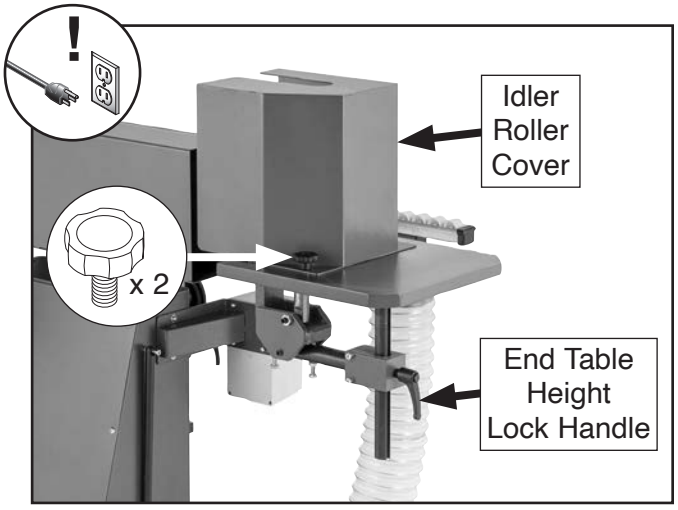


Figure 51. Location of idler roller cover knob bolts and end table height lock handle.

Adjusting Miter Stop

The main table has a miter stop that adjusts between 0°–60° and has an adjustable fence (see **Figure 52**) for supporting the workpiece against the platen when it is perpendicular to the table.

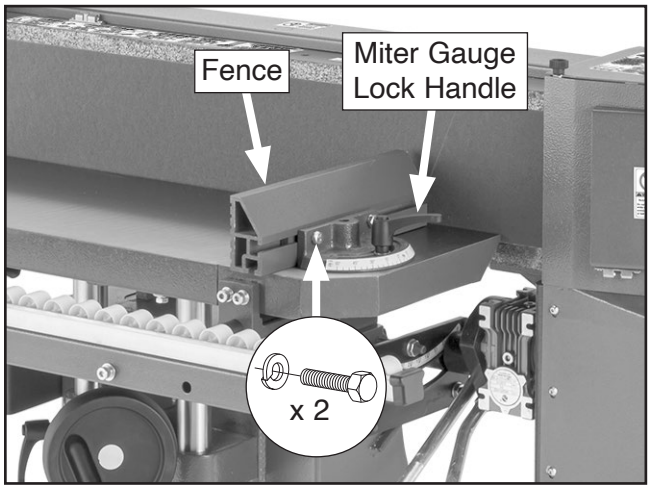


Figure 52. Main table miter stop.

The existing adjustable fence is most effective when the platen and miter gauge are adjusted to 0°. For operations that require a tilted platen, and more information on the risks angled operations presnt, see **Making an Auxiliary Fence** on **Page 31** to replace the existing fence with a shop-made one.

If adjusting the miter stop angle for your operation requires the existing fence to be more than 1/16" from the sanding belt anywhere along its height, consider making a miter angle auxiliary fence that will minimize the pinch point (similar to the one described in **Making an Auxiliary Fence**).

Items Needed	**Qty**
Wrench or Socket 13mm	1
Calipers or Measuring Tape	1

To adjust miter stop:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen miter gauge lock handle and (2) fence hex bolts (see **Figure 52**).

3. Rotate miter stop until indicator displays desired angle, then lock handle to secure angle setting.

4. Adjust fence until there is a gap of no more than 1/16" between fence and sanding belt (see **Figure 52**), then tighten fence hex bolts.

Edge & End Sanding

Proper use of the oscillating edge sander will yield excellent sanding results due to the oscillating movement. Always use the miter stop to support the workpiece whenever possible. Edge and end sanding operations are performed on the main table against the platen.

⚠WARNING

Moving sanding belt can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Make sure workpiece is always supported against table. Use extreme care to provide safe distance between sanding belt and any part of your body.

⚠WARNING

If you must feed workpiece into sanding belt corner first, feed trailing corner first. Feeding leading corner first could cause sanding belt to grab workpiece and jerk it out of your hands.

To edge or end sand:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust main table height as desired, then adjust main table clearance to 1/16" or less (see **Adjusting Main Table** on **Page 33**).

3. Connect machine to power, turn it ***ON***, and allow it to reach full speed.

4. Support workpiece against miter stop and slowly feed workpiece into moving sanding belt with light, even pressure. Maintain control of workpiece, as shown in **Figures 53–54**. DO NOT force workpiece against sanding belt.

Figure 53. Typical edge sanding operation.

Figure 54. Typical end sanding operation.

Bevel Sanding

Adjust the platen tilt to match the angle you wish to sand on a workpiece, then use two hands to sand the workpiece on the main table against the platen.

See **Making an Auxiliary Fence** on **Page 31** to replace the existing fence with a shop-made one for operations that require a tilted platen, and for information on the risks angled operations present.

To bevel sand:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust platen tilt to desired bevel angle of workpiece (see **Adjusting Platen Tilt** on **Page 31**).

3. Adjust main table height as desired, then adjust main table clearance to 1/16" or less (see **Adjusting Main Table** on **Page 33**).

4. Connect machine to power, turn it ***ON***, and allow it to reach full speed.

5. Support workpiece with table (and miter stop if operation allows) and slowly feed workpiece into moving sanding belt with light, even pressure (see **Figure 55**). DO NOT force workpiece against sanding belt.

Figure 55. Typical bevel sanding operation.

Contour Sanding

Contour sanding operations are performed on the end table with the workpiece pressing against the idler roller. Always use two hands to maintain the best control.

To contour sand:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust end table height as desired (see **Adjusting End Table Height** on **Page 34**).

3. Connect machine to power, turn it ***ON***, and allow it to reach full speed.

4. While securely holding workpiece, slowly feed workpiece into moving sanding belt with light, even pressure. Maintain control of workpiece, as shown in **Figure 56**. DO NOT force workpiece against sanding belt.

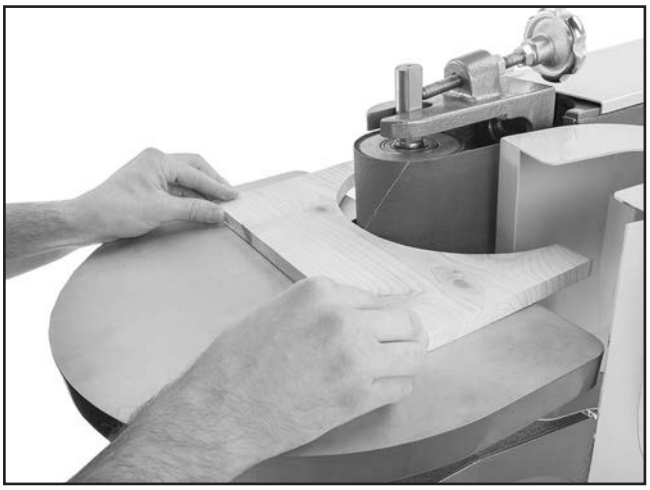


Figure 56. Typical contour sanding operation.

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.

A/O Sanding Belts 6" x 102"

T34394—60-Grit
T34395—80-Grit
T34396—100-Grit
T34397—120-Grit
T34398—150-Grit

These belts feature tough aluminum oxide grain and are sized for the Model G0401.

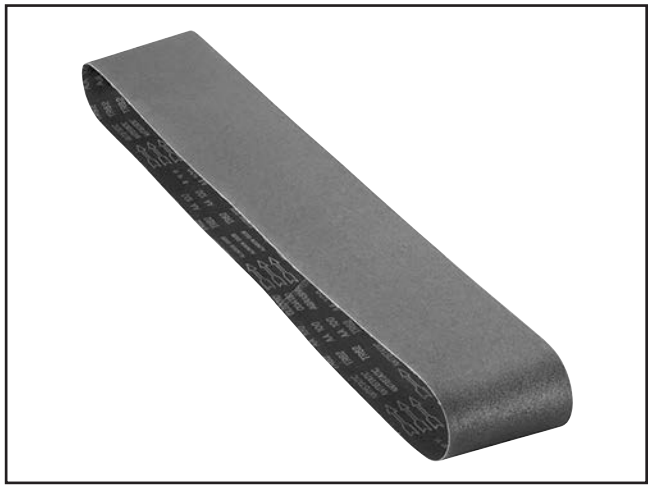


Figure 57. T34396 100-Grit Sanding Belt.

PRO-STIK® Abrasive Surface Cleaners

W1306—1½" x 1½" x 8½"
W1307—2" x 2" x 12"

Extend the life of your sanding belts! Choose the PRO-STIK® with a handle for greater control or without a handle for more usable area.

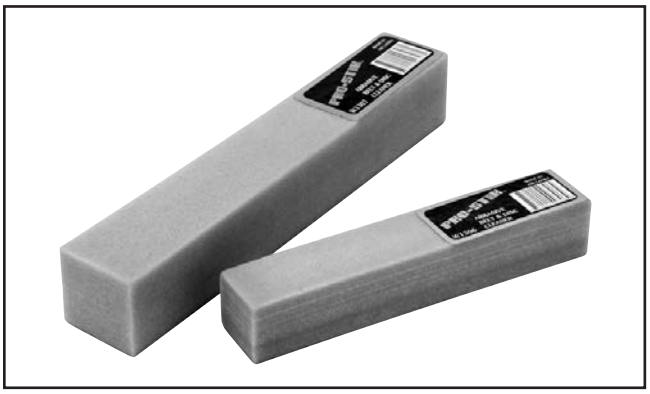


Figure 58. PRO-STIK® abrasive surface cleaners.

Recommended Lubricants

SB1365—South Bend Way Oil-ISO 68
T26419—Syn-O-Gen Synthetic Grease
T28042—Moly-D XHP Gear Oil-ISO 320

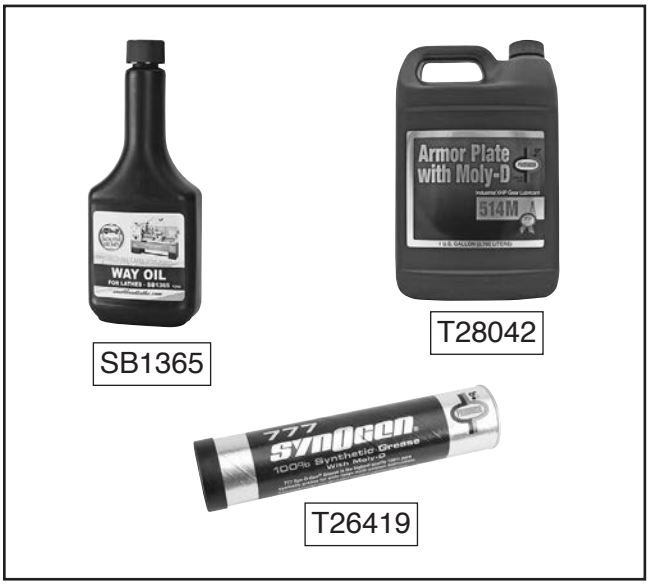
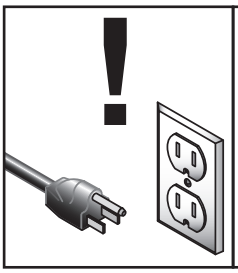


Figure 59. Recommended lubrication products.

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.
- Damaged or dirty sanding belt.
- Worn or damaged wires.
- Dirty or unprotected cast iron surfaces.
- Any other unsafe condition.

Weekly Maintenance
- Clean/vacuum dust buildup from inside belt compartment and off of motors.

Monthly Maintenance
- Lubricate main table height components (**Page 39**).
- Lubricate main table clearance and support roller components (**Page 39**).
- Check gearbox oil level (**Page 40**).

Annual Maintenance
- Change gearbox oil (**Page 40**).

Cleaning & Protecting

Cleaning the Model G0401 is relatively easy. Vacuum excess sawdust and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron tables by wiping them clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the tables rust-free with regular applications of quality metal protectants.

Cleaning Sanding Belt

As sanding belts are used, they will quickly become "loaded" with sawdust. If not removed, this sawdust will harden on the abrasive surface, rendering the sanding belt useless. Routinely clean the sanding belts with a rubber gum abrasive surface cleaner (see **Figure 58** on **Page 37**).

Always discard worn sanding belts. As abrasive belts begin to wear, grit will begin to fall off, causing deep gouges in the workpiece. The glue used to hold the grit to the sanding belt will rub off onto the workpiece, causing burns and interference with final finishing.

NOTICE
Contrary to some beliefs, worn abrasive belts are not equivalent to next finer grit abrasive. Discard worn sanding belts and avoid temptation to use them beyond their usable life.

Lubrication

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 components mentioned in this section with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

Main Table Height Components

Items Needed	Qty
Disposable Rags	As Needed
Stiff Brushes	2
Mineral Spirits	As Needed
T26419 or NLGI#2 Equivalent	Thin Coat
SB1365 or ISO 68 Equivalent	Thin Coat

To lubricate main table height components:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust main table as high as it will go.

3. Clean main table height leadscrew and columns (see **Figure 60**) with rags, brush, and mineral spirits to remove grime and old lubrication.

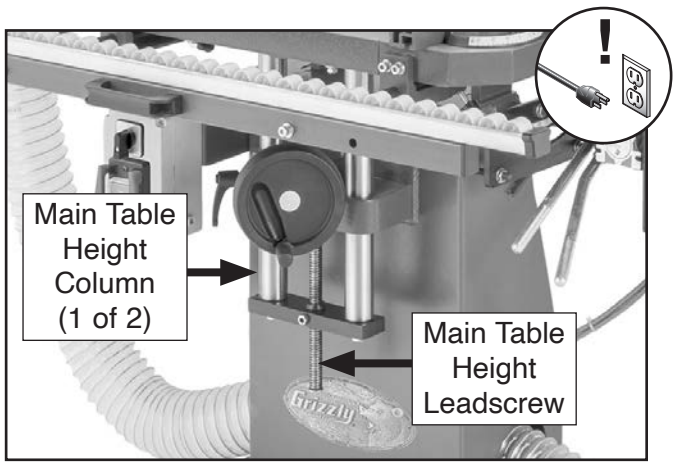


Figure 60. Location of main table height leadscrew and columns.

4. Use clean brush to wipe leadscrew threads with thin coat of NLGI#2 grease.

5. Use clean rags to wipe columns with thin coat of ISO 68 way oil.

6. Adjust main table height through its full range of travel to spread lubricants and ensure smooth movement.

Main Table Clearance & Support Roller Components

Items Needed	Qty
Disposable Rags	As Needed
Mineral Spirits	As Needed
SB1365 or ISO 68 Equivalent	Thin Coat

To lubricate main table clearance and support roller components:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust main table as far away from platen as possible and adjust support rollers all the way away from main table.

3. Clean main table clearance and support roller rods shown in **Figure 61** with rags and mineral spirits to remove grime and old lubrication.

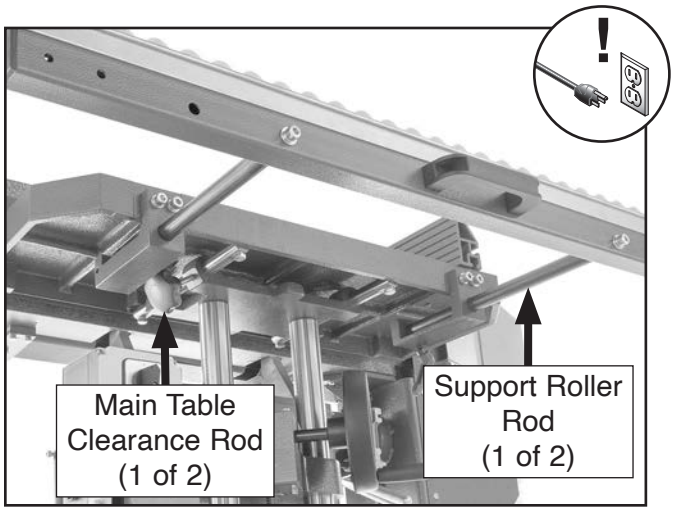


Figure 61. Main table clearance and support roller rods.

4. Use clean rags to wipe rods with thin coat of ISO 68 way oil.

5. Adjust main table and support rollers through their full range of travel to spread lubricants and ensure smooth movement.

6. Main table clearance MUST be adjusted within 1/16" of sanding belt before operating. Refer to **Adjusting Main Table** on **Page 33** to adjust clearance.

Checking Gearbox Oil

Items Needed	Qty
T28042 or ISO 68 Equivalent	As Needed

To check gearbox oil:

1. Run machine for 10 minutes to warm up oil in gearbox.
2. DISCONNECT MACHINE FROM POWER!
3. Adjust platen tilt to 0°.
4. Check oil level in sight glass (see **Figure 62**).
   - If oil level fills about half of sight glass, no oil needs to be added.
   - If oil level fills *less than* half of sight glass, proceed to **Step 5**.
5. Remove fill cap (see **Figure 62**), add oil until it fills half of sight glass, then install fill cap.

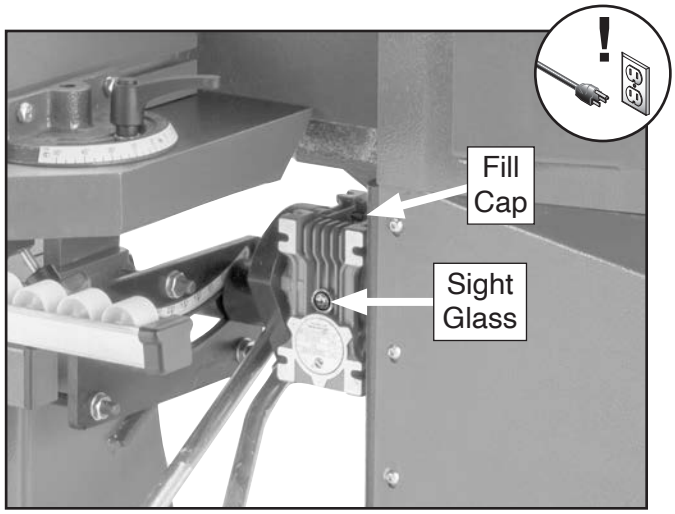


Figure 62. Location of gearbox sight glass and fill cap.

Changing Gearbox Oil

Items Needed	Qty
Disposable Rags	As Needed
Drain Pan	1
Hex Wrench 5mm	1
T28042 or ISO 68 Equivalent	0.8 L
Thread-Sealing Tape	As Needed

The gearbox oil should be drained and refilled after the first 150 hours (about three months) of use, then once every year.

To change gearbox oil:

1. Run machine for 10 minutes to warm up oil in gearbox.
2. DISCONNECT MACHINE FROM POWER!
3. Adjust platen tilt to 0°.
4. Remove fill cap (see **Figure 62**).
5. Place drain pan under drain plug (see **Figure 63**), then remove drain plug to drain oil.

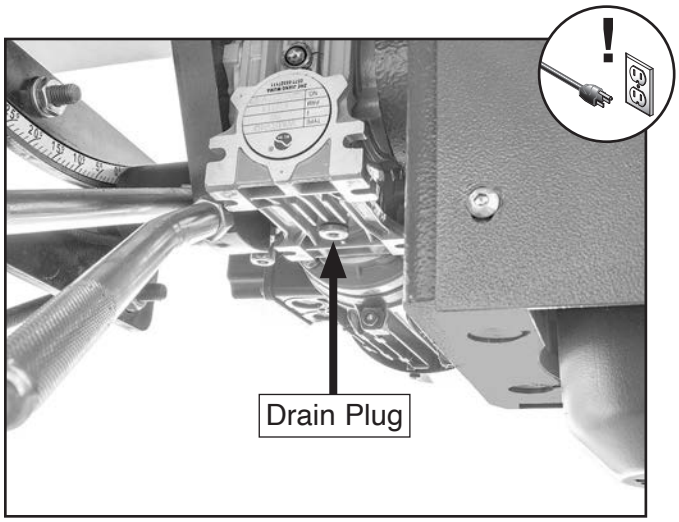


Figure 63. Location of gearbox drain plug.

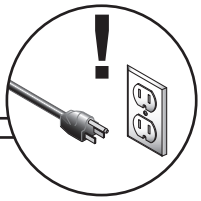
6. When oil is drained, clean threads of drain plug, wrap threads with thread-sealing tape, then install drain plug.
7. Fill gearbox with oil until oil level is at halfway point in sight glass (see **Figure 62**), then install fill cap.
8. Connect machine to power, then complete **Checking Gearbox Oil**.

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 G0401. For issues concerning the VFD, contact Mitsubishi to obtain a FR-CS82S-100-60 manual (or visit **https://emea.mitsubishielectric.com/**).

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Switch disabling pin or lock installed. 2. OFF (0) button not reset. 3. Machine circuit breaker tripped. 4. Incorrect power supply voltage or circuit size. 5. Power supply circuit breaker tripped or fuse blown. 6. Main motor wires connected incorrectly. 7. Wiring broken, disconnected, or corroded. 8. Main motor or motor bearings at fault.	1. Remove switch disabling pin/lock. 2. Press OFF button (0) completely until it clicks. 3. Reset circuit breaker on switch. 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 45**). 7. Fix broken wires or disconnected/corroded connections (**Page 45**). 8. Replace main motor.
Main motor starts, but oscillation motor does not.	1. Oscillation motor wires connected incorrectly. 2. Wiring broken, disconnected, or corroded. 3. Oscillation motor or motor bearings at fault.	1. Correct motor wiring connections (**Page 45**). 2. Fix broken wires or disconnected/corroded connections (**Page 45**). 3. Replace oscillation motor.
Main motor stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Main motor wires connected incorrectly. 3. Machine undersized for task. 4. Motor overheated, tripping machine circuit breaker. 5. Extension cord too long. 6. Main motor or motor bearings at fault.	1. Only cut wood/ensure moisture is below 20% (**Page 26**). 2. Correct motor wiring connections (**Page 45**). 3. Clean (**Page 38**)/replace (**Page 28**) sandpaper; reduce feed rate/sanding depth. 4. Clean motor, let cool, and reduce workload. Reset breaker. 5. Move machine closer to power supply; use shorter extension cord (**Page 12**). 6. Replace main motor.
Oscillation motor stalls or is underpowered.	1. Oscillation motor wires connected incorrectly. 2. Motor overheated, tripping machine circuit breaker. 3. Oscillation motor, motor bearings, or gearbox at fault.	1. Correct motor wiring connections (**Page 45**). 2. Clean motor, let cool, and reduce workload. Reset breaker. 3. Replace oscillation motor.

Motor & Electrical (Cont.)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Drive roller hex bolt is missing or loose. 3. Motor mount loose/broken. 4. Motor fan rubbing on fan cover. 5. Motor bearings at fault.	1. Replace damaged or missing bolt/nuts or tighten if loose. 2. Inspect key. Replace or tighten hex bolt if necessary. 3. Tighten/replace. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operation

Symptom	Possible Cause	Possible Solution
Sanding belt slaps or vibrates excessively.	1. Incorrect sanding belt tension. 2. Belt tracking needs adjustment. 3. Broken/defective sanding belt. 4. Idler or drive roller is loose. 5. Weak or broken tension spring(s).	1. Make sure belt tension is engaged (**Page 28**). 2. Adjust sanding belt tracking (**Page 29**). 3. Replace sanding belt (**Page 28**). 4. Tighten idler or drive roller. 5. Replace spring(s).
Sanding surface not square when platen tilt is set to 0°.	1. Platen is not perpendicular to main table.	1. Square platen to main table (**Page 44**).
Sanding belt does not track correctly.	1. Belt tracking needs adjustment. 2. Incorrect sanding belt tension. 3. Belt damaged, worn, or misshapen.	1. Adjust sanding belt tracking (**Page 29**). 2. Make sure belt tension is engaged (**Page 28**). 3. Replace sanding belt (**Page 28**).
Deep sanding grooves or scores in workpiece.	1. Using too coarse of sanding grit. 2. Workpiece sanded across grain. 3. Too much pressure against belt. 4. Workpiece held still for too long. 5. Graphite pad on platen damaged.	1. Use finer grit sanding belt (**Page 27**). 2. Sand with workpiece grain. 3. Reduce pressure on workpiece when sanding. 4. Do not keep workpiece in one place for too long. 5. Replace graphite pad.
Abrasive grit rubs off sanding belt easily.	1. Sanding belt has been stored in an incorrect environment. 2. Sanding belt has been folded or crushed.	1. Replace sanding belt (**Page 28**). Store sanding belt in a cool, dry area. 2. Replace sanding belt (**Page 28**). Store sanding belt flat, not folded or bent.
Sanding belt surfaces clog quickly or burn.	1. Worn sanding belt. 2. Too much pressure against belt. 3. Sanding softwood. 4. Workpiece has high moisture content or sap. 5. Using too fine of sanding grit. 6. Poor dust collection.	1. Replace sanding belt (**Page 28**). 2. Reduce pressure on workpiece when sanding. 3. Use different stock or accept characteristics of workpiece and plan on cleaning (**Page 38**)/replacing (**Page 28**) belt frequently. 4. Use different stock or accept characteristics of workpiece and plan on cleaning (**Page 38**)/replacing (**Page 28**) belt frequently. 5. Use coarser grit sanding belt (**Page 27**). 6. Unclog ducts; close gates to improve suction; redesign dust collection system.
Burn marks on workpiece.	1. Using too fine of sanding grit. 2. Too much pressure against belt. 3. Workpiece held still for too long. 4. Sanding belt loaded with sawdust, resin, and/or pitch.	1. Use coarser grit sanding belt (**Page 27**). 2. Reduce pressure on workpiece when sanding. 3. Do not keep workpiece in one place for too long. 4. Clean (**Page 38**) or replace (**Page 28**) sanding belt.

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Glazed sanding surfaces.	1. Sanding wet stock. 2. Sanding stock with high pitch/residue. 3. Belt worn or filled with pitch/residue.	1. Dry properly before sanding (**Page 26**). 2. Use different stock or accept characteristics of workpiece and plan on cleaning (**Page 38**)/replacing (**Page 28**) belt frequently. 3. Clean (**Page 38**)) or replace (**Page 28**) sanding belt.
Workpiece frequently gets pulled out of your hand.	1. Not supporting workpiece properly. 2. Starting workpiece on a leading corner.	1. Use miter stop to support workpiece. 2. Start workpiece on a trailing corner.
Snake-shaped marks on workpiece.	1. Sanding belt loaded with sawdust, resin, and/or pitch. 2. Sanding belt damaged.	1. Clean (**Page 38**) or replace (**Page 28**) sanding belt. 2. Replace sanding belt (**Page 28**).

Squaring Platen to Main Table

The Model G0401 features a stop bolt that stops the platen exactly at 0º (90º in relation to the sanding belt) during platen tilt adjustments. The stop has been set at the factory and should not require adjustment unless you notice that workpieces are not square after being sanded.

Items Needed	**Qty**
Square 90º	1
Wrench or Socket 5/16"	1
Open-End Wrench 5/16"	1

To square platen to main table:

1. DISCONNECT MACHINE FROM POWER!

2. Remove sanding belt.

3. Adjust platen tilt to 0º.

4. Adjust table clearance so table is within 1/16" of platen.

5. Place 90º square against table and platen, as shown in **Figure 64**.

— If platen *is* 90º to table, no adjustment is required.

— If platen *is not* 90º to table, proceed to **Step 6**.

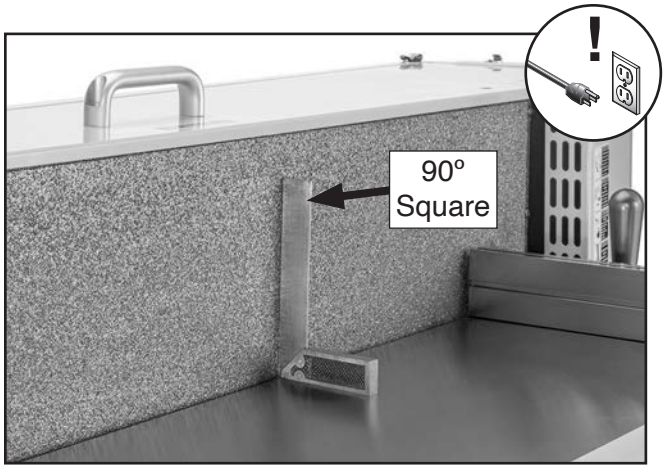


Figure 64. Example of checking platen with 90º square.

6. Loosen jam nut on 0º stop bolt shown in **Figure 65**, and adjust 0º stop bolt until platen is 90º to table when bolt contacts tilt block.

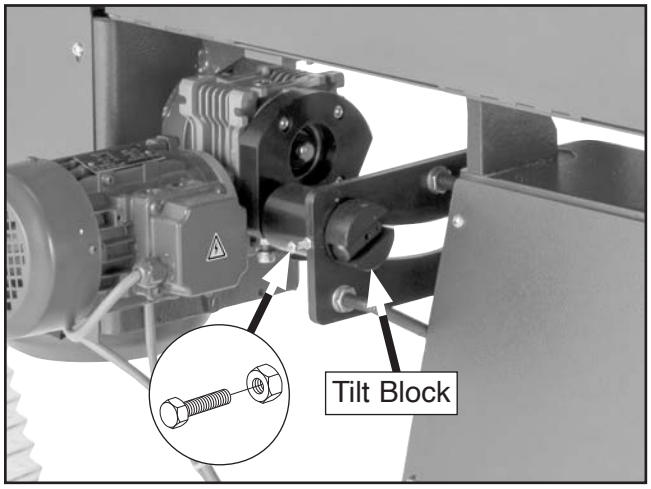


Figure 65. Location of 0º stop bolt and jam nut.

7. Tighten jam nut without turning stop bolt to secure setting.

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.

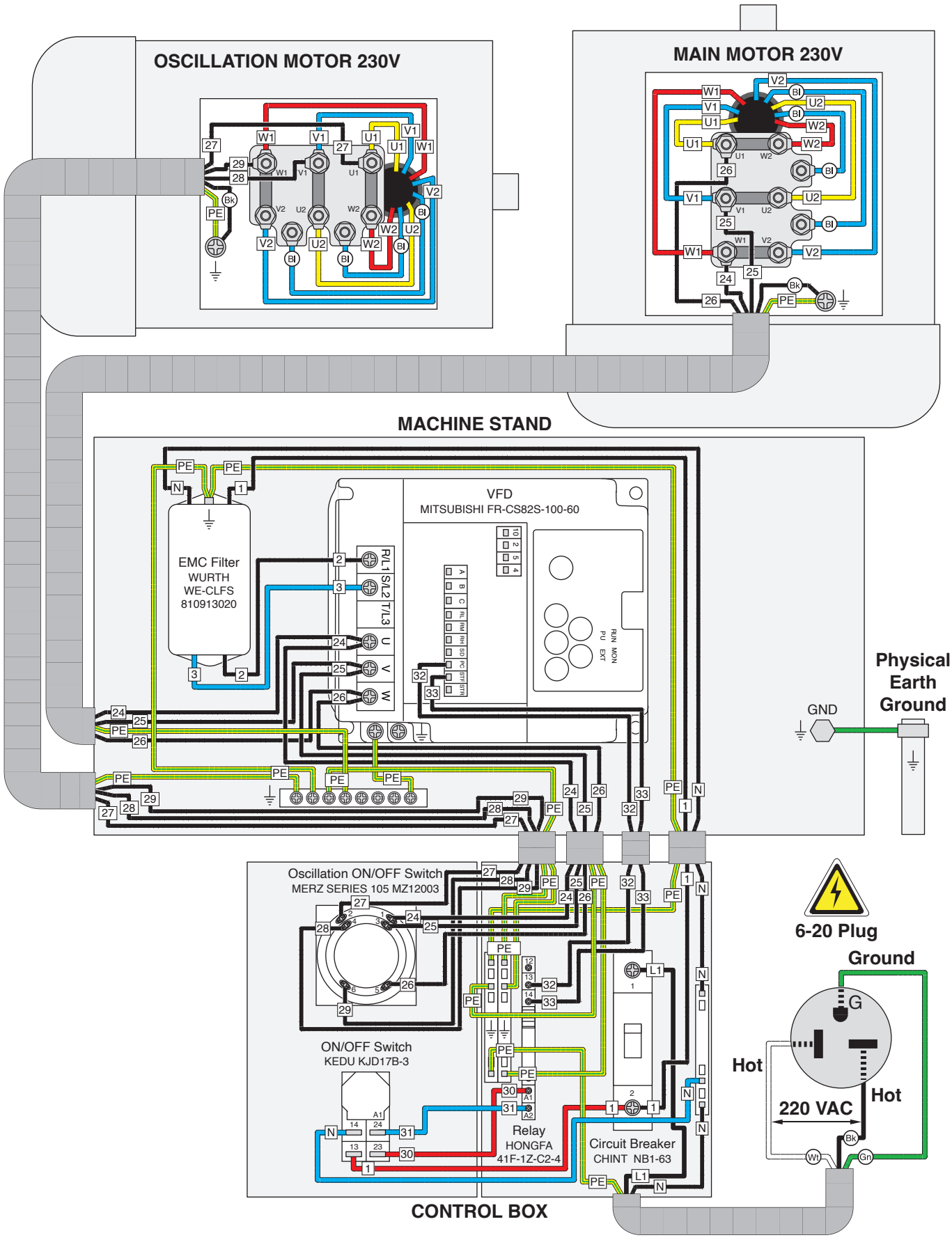
NOTICE

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



STOP *READ ELECTRICAL SAFETY ON PAGE 45!*

Electrical Components

Figure 66. Control box cover wiring.

Figure 67. Control box wiring.

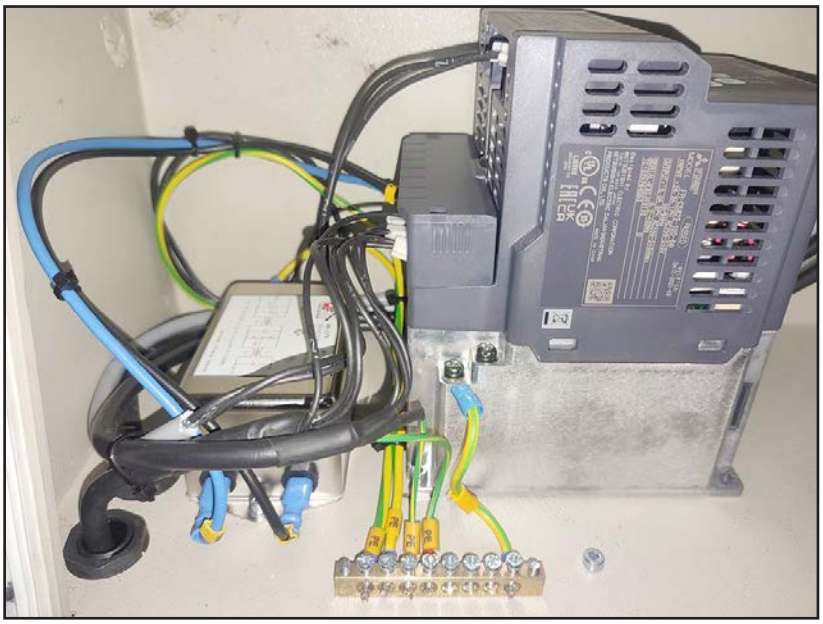


Figure 68. VFD and EMC filter wiring.

Electrical Components (Cont.)

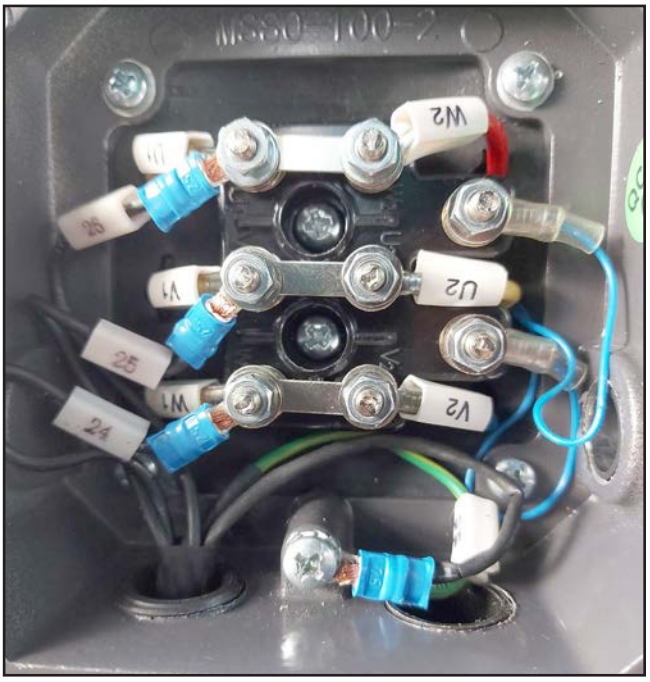


Figure 69. Main motor wiring.

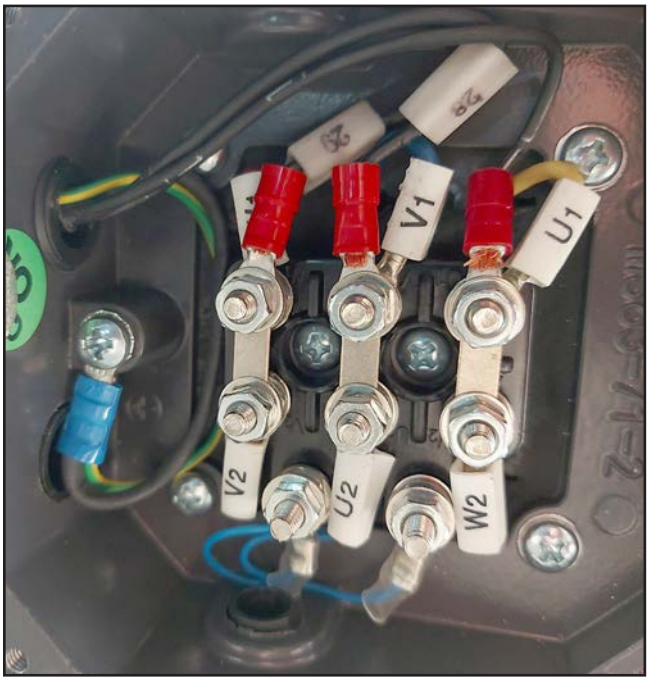


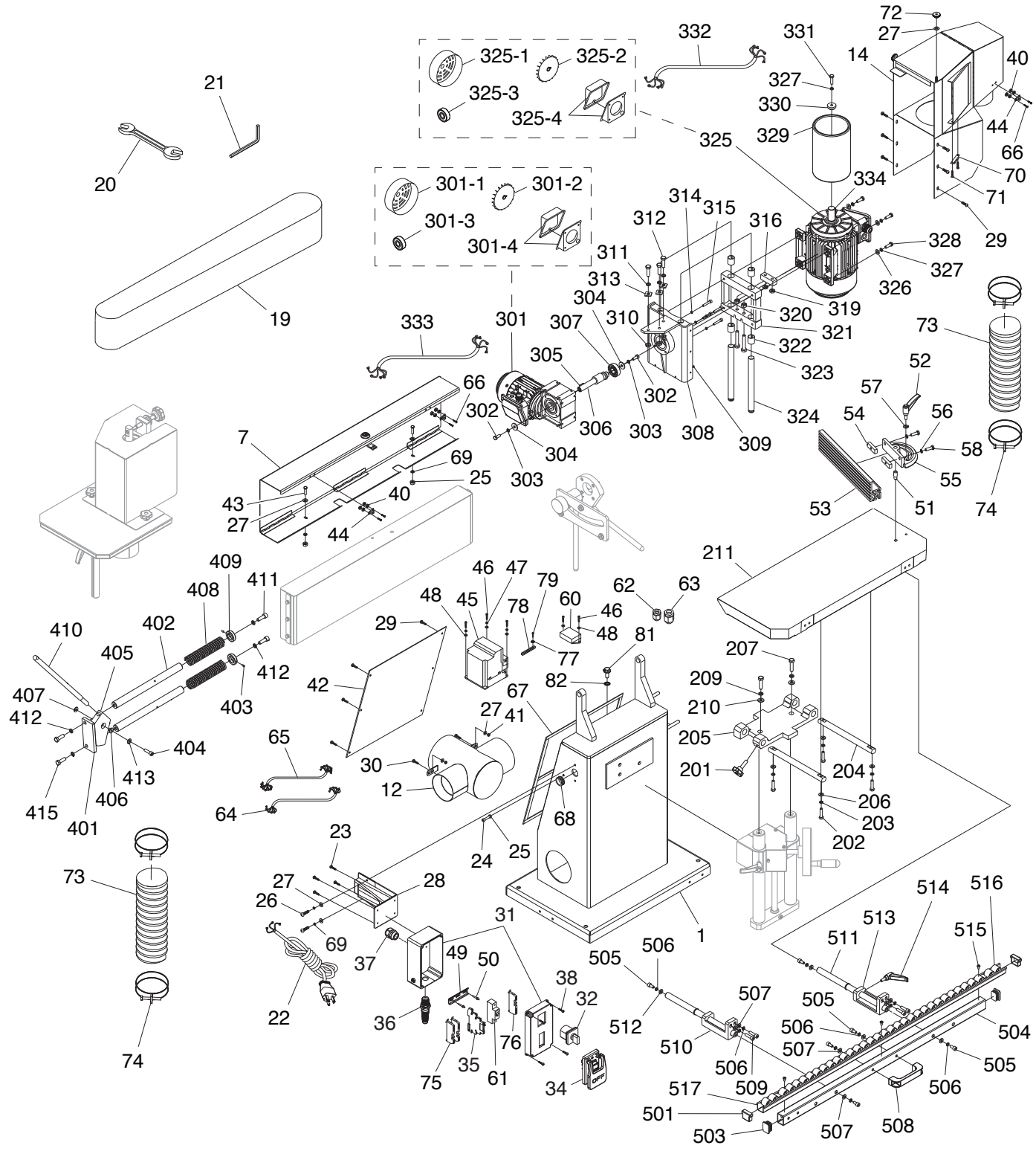
Figure 70. Oscillation motor wiring.

STOP *READ ELECTRICAL SAFETY ON PAGE 45!*

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.

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0401001	STAND
7	P0401007	BELT COVER
12	P0401012	DUST PORT
14	P0401014	DUST HOOD
19	P0401019	SANDING BELT 6" X 102" 100-GRIT
20	P0401020	WRENCH 13 X 17MM OPEN-ENDS
21	P0401021	HEX WRENCH 5MM
22	P0401022	POWER CORD 12G 3W 106" 6-20P
23	P0401023	BUTTON HD CAP SCR M5-.8 X 10
24	P0401024	SHOULDER SCREW M6-1 X 26, 6 X 24
25	P0401025	HEX NUT M6-1
26	P0401026	BUTTON HD CAP SCR M6-1 X 12
27	P0401027	FLAT WASHER 6MM
28	P0401028	CONTROL BOX MOUNTING BRACKET
29	P0401029	BUTTON HD CAP SCR M6-1 X 8
30	P0401030	BUTTON HD CAP SCR M6-1 X 16
31	P0401031	CONTROL BOX
32	P0401032	ON/OFF SWITCH MERZ SERIES 105 MZ12003
34	P0401034	ON/OFF SWITCH W/PADDLE KEDU KJD17B-3
35	P0401035	RELAY HONGFA 41F-1Z-2C-1
36	P0401036	STRAIN RELIEF M20-1.5
37	P0401037	STRAIN RELIEF M25-1.5
38	P0401038	TAP SCREW M4.2 X 16
40	P0401040	HEX NUT M3-.5
41	P0401041	LOCK NUT M6-1
42	P0401042	STAND COVER
43	P0401043	HEX BOLT M6-1 X 20
44	P0401044	STRIKE PLATE
45	P0401045	VFD MITSUBISHI FR-CS82S-100-60
46	P0401046	CAP SCREW M4-.7 X 10
47	P0401047	LOCK WASHER 4MM
48	P0401048	FLAT WASHER 4MM
49	P0401049	DIN RAIL 35 X 80MM
50	P0401050	RIVET 4 X 8MM BLIND, ALUMINUM
51	P0401051	PIVOT PIN
52	P0401052	FIXED HANDLE M8-1.25 X 20
53	P0401053	MITER FENCE
54	P0401054	T-SLOT NUT M8-1.25
55	P0401055	MITER GAUGE
56	P0401056	LOCK WASHER 8MM
57	P0401057	FLAT WASHER 8MM
58	P0401058	HEX BOLT M8-1.25 X 25
60	P0401060	EMI FILTER WURTH WE-CLFS 810913020
61	P0401061	CIRCUIT BREAKER CHINT NB1-63
62	P0401062	STRAIN RELIEF PG8
63	P0401063	STRAIN RELIEF PG11
64	P0401064	VFD CORD I 14G 5W 47"
65	P0401065	VFD CORD II 18G 7W 41"
66	P0401066	FLAT HD SCR M3-.5 X 10 SLOTTED
67	P0401067	FOAM TAPE 8 X 2.6MM
68	P0401068	GROMMET 20MM
69	P0401069	LOCK WASHER 6MM
70	P0401070	BALL GRAB LATCH
71	P0401071	FLAT HD SCR M4-.7 X 8 SLOTTED
72	P0401072	KNOB M6-1
73	P0401073	HOSE 4" X 47"

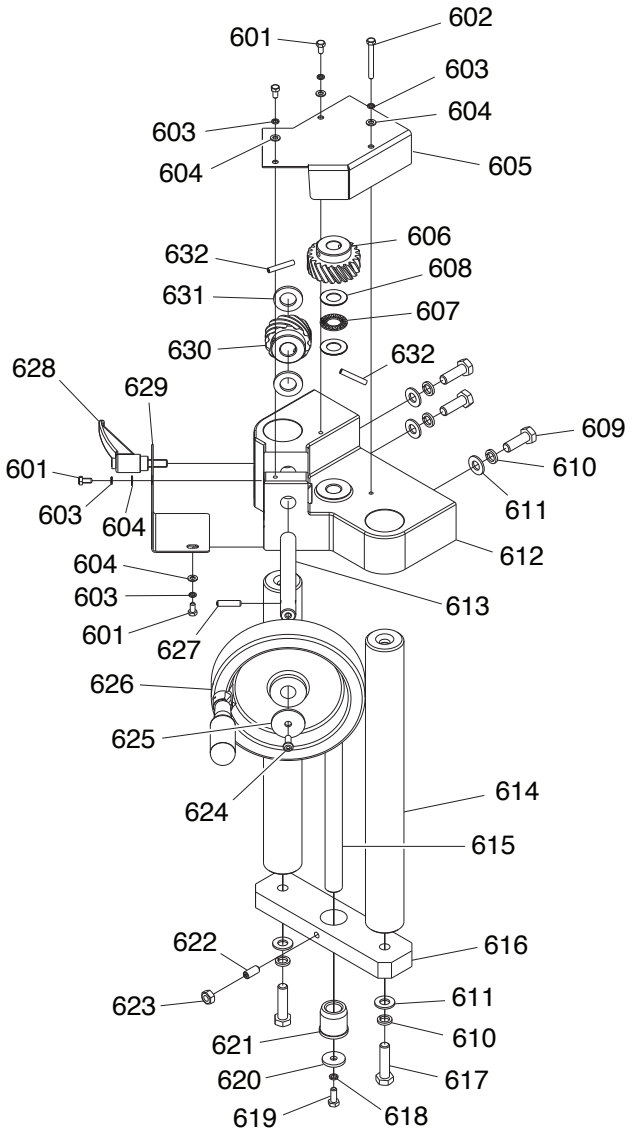
REF	PART #	DESCRIPTION
74	P0401074	HOSE CLAMP 4"
75	P0401075	TERMINAL BLOCK A3C 2.5 PE
76	P0401076	TERMINAL BLOCK A3C 2.5 BU
77	P0401077	EXT TOOTH WASHER 4MM
78	P0401078	GROUND TERMINAL BAR 8P
79	P0401079	PHLP HD SCR M4-.7 X 10
81	P0401081	FLANGE BOLT M8-1.25 X 20
82	P0401082	EXT TOOTH WASHER 8MM
201	P0401201	KNOB BOLT M8-1.25 X 20
202	P0401202	HEX BOLT M8-1.25 X 35
203	P0401203	LOCK WASHER 8MM
204	P0401204	TABLE CLEARANCE ROD
205	P0401205	TABLE CLEARANCE BLOCK
206	P0401206	FLAT WASHER 8MM
207	P0401207	HEX BOLT M10-1.5 X 40
209	P0401209	LOCK WASHER 10MM
210	P0401210	FLAT WASHER 10MM
211	P0401211	TABLE
301	P0401301	MOTOR W/GEAR REDUCER 1/4HP 230V 3-PH
301-1	P0401301-1	MOTOR FAN COVER
301-2	P0401301-2	MOTOR FAN
301-3	P0401301-3	BALL BEARING 6201-2RS
301-4	P0401301-4	MOTOR JUNCTION BOX
302	P0401302	HEX BOLT M8-1.25 X 20
303	P0401303	LOCK WASHER 8MM
304	P0401304	FLAT WASHER 8.5 X 26 X 3MM
305	P0401305	KEY 6 X 6 X 20
306	P0401306	ECCENTRIC SHAFT
307	P0401307	BALL BEARING 6204ZZ
308	P0401308	MOTOR MOUNT
309	P0401309	SET SCREW M6-1 X 8 CONE-PT
310	P0401310	HEX NUT M10-1.5 THIN
311	P0401311	LOCK WASHER 10MM
312	P0401312	HEX BOLT M10-1.5 X 35
313	P0401313	SQUARE WASHER 10MM TAPERED
314	P0401314	LOCK WASHER 6MM
315	P0401315	CAP SCREW M6-1 X 35
316	P0401316	SUPPORT BLOCK
319	P0401319	HEX NUT M10-1.5 THIN
320	P0401320	LOCK NUT M10-1.5
321	P0401321	FRAME
322	P0401322	BUSHING
323	P0401323	HEX BOLT M10-1.5 X 60
324	P0401324	MOUNTING SHAFT
325	P0401325	MOTOR 3HP 230V 3-PH
325-1	P0401325-1	MOTOR FAN COVER
325-2	P0401325-2	MOTOR FAN
325-3	P0401325-3	BALL BEARING 6205-2RS
325-4	P0401325-4	MOTOR JUNCTION BOX
326	P0401326	FLAT WASHER 8MM
327	P0401327	LOCK WASHER 8MM
328	P0401328	HEX BOLT M8-1.25 X 25
329	P0401329	DRIVE ROLLER
330	P0401330	BUSHING 12 X 30MM
331	P0401331	HEX BOLT M8-1.25 X 30
332	P0401332	MAIN MOTOR CORD 16G 4W 49"

Main Parts List (Cont.)

REF	PART #	DESCRIPTION
333	P0401333	OSC MOTOR CORD 18G 4W 81"
334	P0401334	KEY 8 X 7 X 40 RE
401	P0401401	TENSION BRACKET
402	P0401402	BELT TENSION ROD
403	P0401403	SET SCREW M5-.8 X 10 CONE-PT
404	P0401404	CAP SCREW M8-1.25 X 30
405	P0401405	CAM ARM
406	P0401406	BUSHING
407	P0401407	FLAT WASHER 8MM
408	P0401408	COMPRESSION SPRING 4 X 36 X 160MM
409	P0401409	LOCK COLLAR
410	P0401410	TENSION LEVER
411	P0401411	CAP SCREW M10-1.5 X 30
412	P0401412	LOCK WASHER 10MM
413	P0401413	FLAT WASHER 8MM
415	P0401415	HEX BOLT M10-1.25 X 30

REF	PART #	DESCRIPTION
501	P0401501	END CAP
503	P0401503	PLUG
504	P0401504	ROLLER FRAME
505	P0401505	CAP SCREW M8-1.25 X 16
506	P0401506	LOCK WASHER 8MM
507	P0401507	FLAT WASHER 8MM
508	P0401508	HANDLE
509	P0401509	CAP SCREW M8-1.25 X 30
510	P0401510	EXTENSION ROD GUIDE LEFT
511	P0401511	EXTENSION ROD
512	P0401512	FLAT WASHER 8MM
513	P0401513	EXTENSION ROD GUIDE RIGHT
514	P0401514	FIXED HANDLE M8-1.25 X 20
515	P0401515	PHLP HD SCR M6-1 X 10
516	P0401516	ROLLER
517	P0401517	ROLLER TRACK

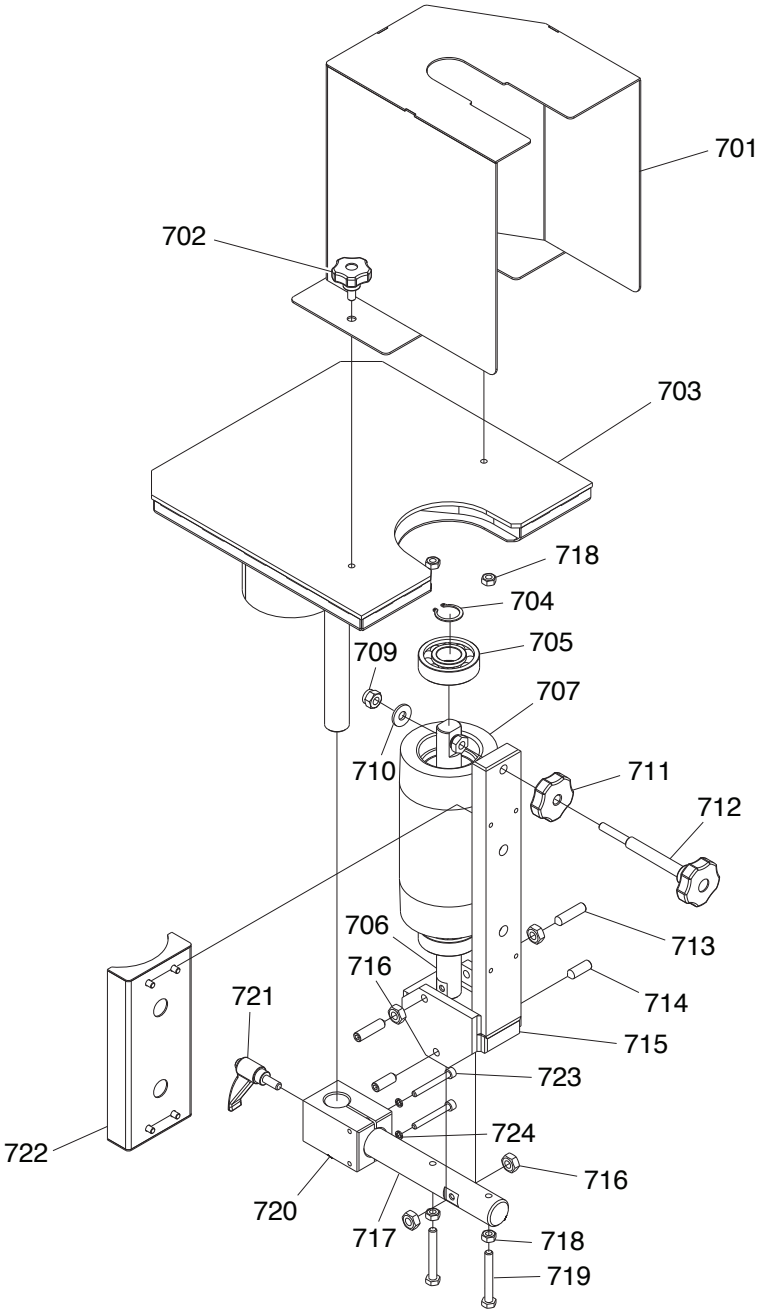
Main Table Height Mechanism



REF	PART #	DESCRIPTION
601	P0401601	HEX BOLT M5-.8 X 10
602	P0401602	HEX BOLT M5-.8 X 45
603	P0401603	LOCK WASHER 5MM
604	P0401604	FLAT WASHER 5MM
605	P0401605	COVER UPPER
606	P0401606	BEVEL GEAR 22T
607	P0401607	NEEDLE ROLLER BEARING AXK-1528
608	P0401608	BEARING WASHER AS-1528
609	P0401609	HEX BOLT M10-1.5 X 30
610	P0401610	LOCK WASHER 10MM
611	P0401611	FLAT WASHER 10MM
612	P0401612	HEIGHT BLOCK
613	P0401613	HANDWHEEL SHAFT
614	P0401614	HEIGHT COLUMN
615	P0401615	LEADSCREW TR18 X 4
616	P0401616	LIMIT PLATE

REF	PART #	DESCRIPTION
617	P0401617	HEX BOLT M10-1.5 X 40
618	P0401618	LOCK WASHER 6MM
619	P0401619	HEX BOLT M6-1 X 16
620	P0401620	FLAT WASHER 8.4 X 24 X 3MM
621	P0401621	LEADSCREW NUT TR18 X 4
622	P0401622	SET SCREW M8-1.25 X 20 CONE-PT
623	P0401623	HEX NUT M8-1.25
624	P0401624	BUTTON HD CAP SCR M6-1 X 16
625	P0401625	FLAT WASHER 7 X 35 X 2.5MM
626	P0401626	HEIGHT HANDWHEEL 160 W/HANDLE
627	P0401627	DOWEL PIN 6 X 25MM
628	P0401628	FIXED HANDLE M8-1.25 X 20
629	P0401629	COVER LOWER
630	P0401630	BEVEL GEAR 11T
631	P0401631	FLAT WASHER 16MM
632	P0401632	ROLL PIN 5 X 30

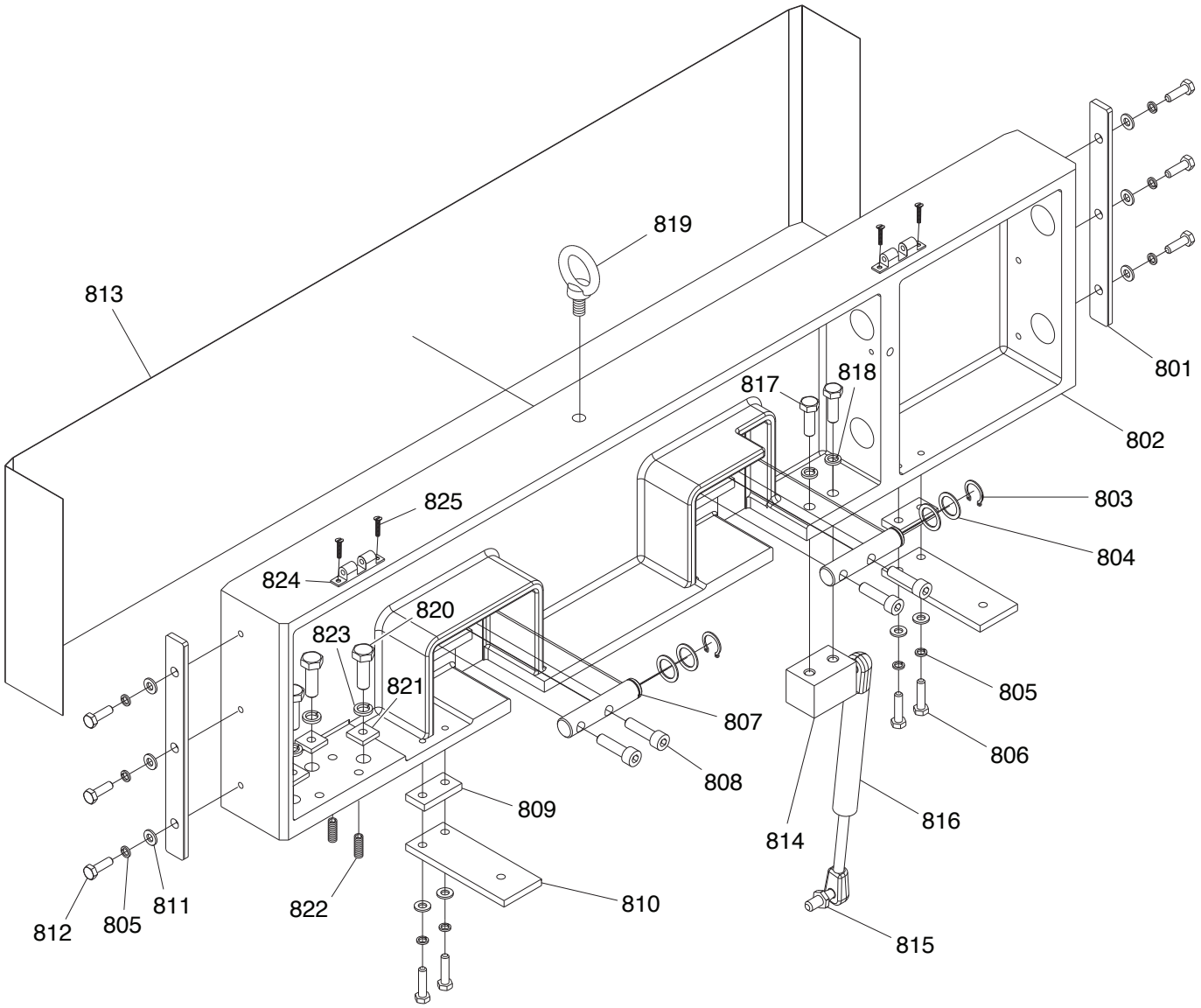
End Table



REF	PART #	DESCRIPTION
701	P0401701	IDLER ROLLER COVER
702	P0401702	KNOB BOLT M8-1.25 X 16
703	P0401703	END TABLE
704	P0401704	EXT RETAINING RING 25MM
705	P0401705	BALL BEARING 6305-2RS
706	P0401706	ROLLER SHAFT
707	P0401707	IDLER ROLLER
709	P0401709	LOCK NUT M8-1.25
710	P0401710	FLAT WASHER 8MM
711	P0401711	KNOB M12-1.75
712	P0401712	TRACKING KNOB W/SHAFT
713	P0401713	SET SCREW M10-1.5 X 40 CONE-PT

REF	PART #	DESCRIPTION
714	P0401714	SET SCREW M10-1.5 X 30 CONE-PT
715	P0401715	ROLLER MOUNT
716	P0401716	HEX NUT M10-1.25
717	P0401717	ROLLER MOUNTING SHAFT
718	P0401718	HEX NUT M8-1.25
719	P0401719	HEX BOLT M8-1.25 X 60
720	P0401720	HEIGHT BLOCK
721	P0401721	FIXED HANDLE M8-1.25 X 20
722	P0401722	BAFFLE
723	P0401723	CAP SCREW M6-1 X 50
724	P0401724	LOCK WASHER 6MM

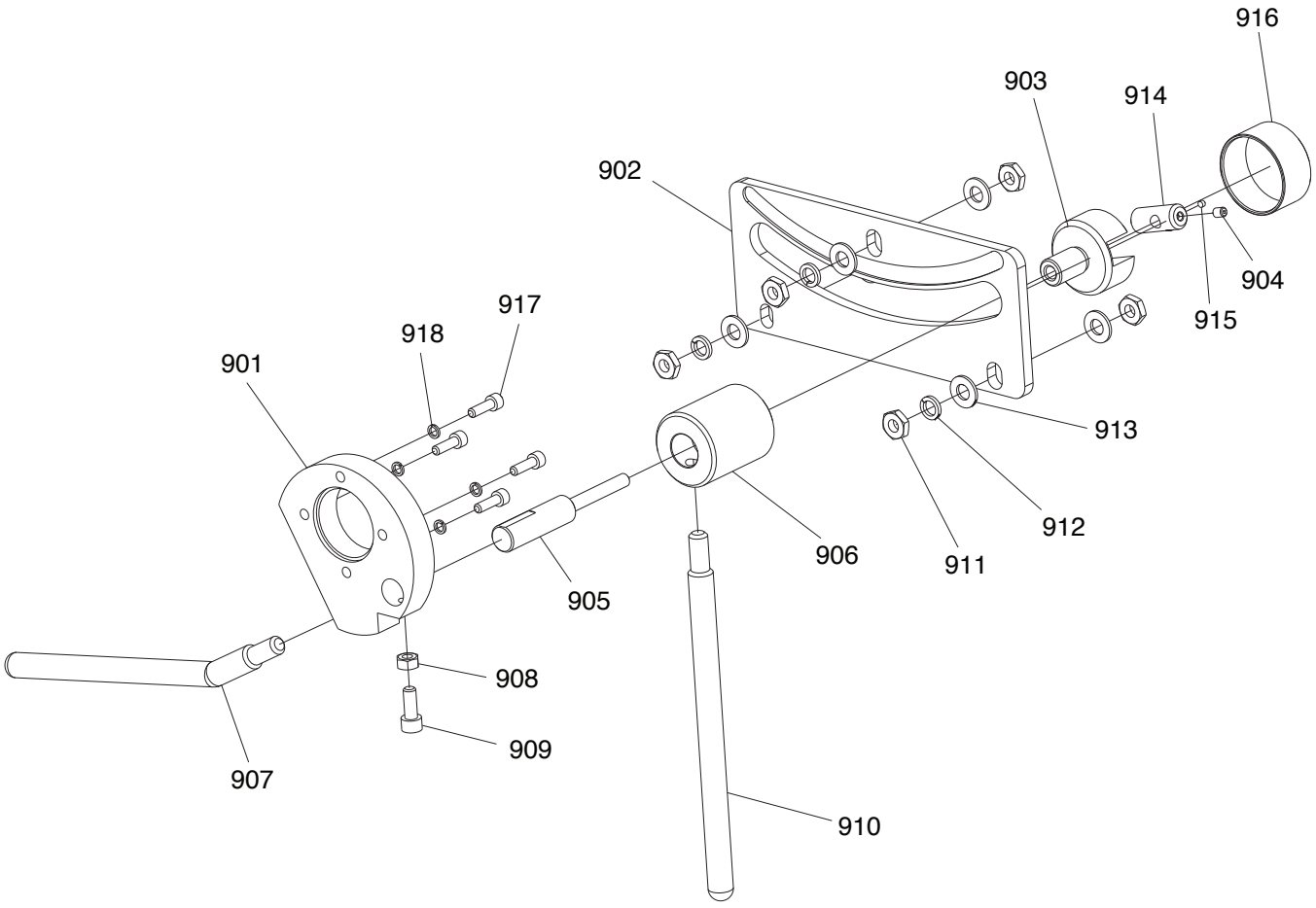
Platen



REF	PART #	DESCRIPTION
801	P0401801	RETAINER PLATE
802	P0401802	PLATEN
803	P0401803	EXT RETAINING RING 16MM
804	P0401804	FLAT WASHER 16 X 22 X 1MM
805	P0401805	LOCK WASHER 6MM
806	P0401806	HEX BOLT M6-1 X 25
807	P0401807	MOUNTING SHAFT
808	P0401808	CAP SCREW M8-1.25 X 30
809	P0401809	VIBRATION PAD
810	P0401810	MOUNTING ARM
811	P0401811	FLAT WASHER 6MM
812	P0401812	HEX BOLT M6-1 X 20
813	P0401813	GRAPHITE PAD 33-1/2 X 7-7/8 X 1/16"

REF	PART #	DESCRIPTION
814	P0401814	SPRING MOUNTING BLOCK
815	P0401815	BALL STUD M8-1.25 X 13, 34
816	P0401816	GAS SPRING 300N 240MM
817	P0401817	HEX BOLT M8-1.25 X 25
818	P0401818	LOCK WASHER 8MM
819	P0401819	EYE BOLT 1-3/16", M12-1.75 X 20
820	P0401820	HEX BOLT M10-1.5 X 35
821	P0401821	SQUARE WASHER 10MM
822	P0401822	SET SCREW M8-1.25 X 20
823	P0401823	LOCK WASHER 10MM
824	P0401824	BALL GRAB LATCH
825	P0401825	FLAT HD SCR M4-.7 X 12 SLOTTED

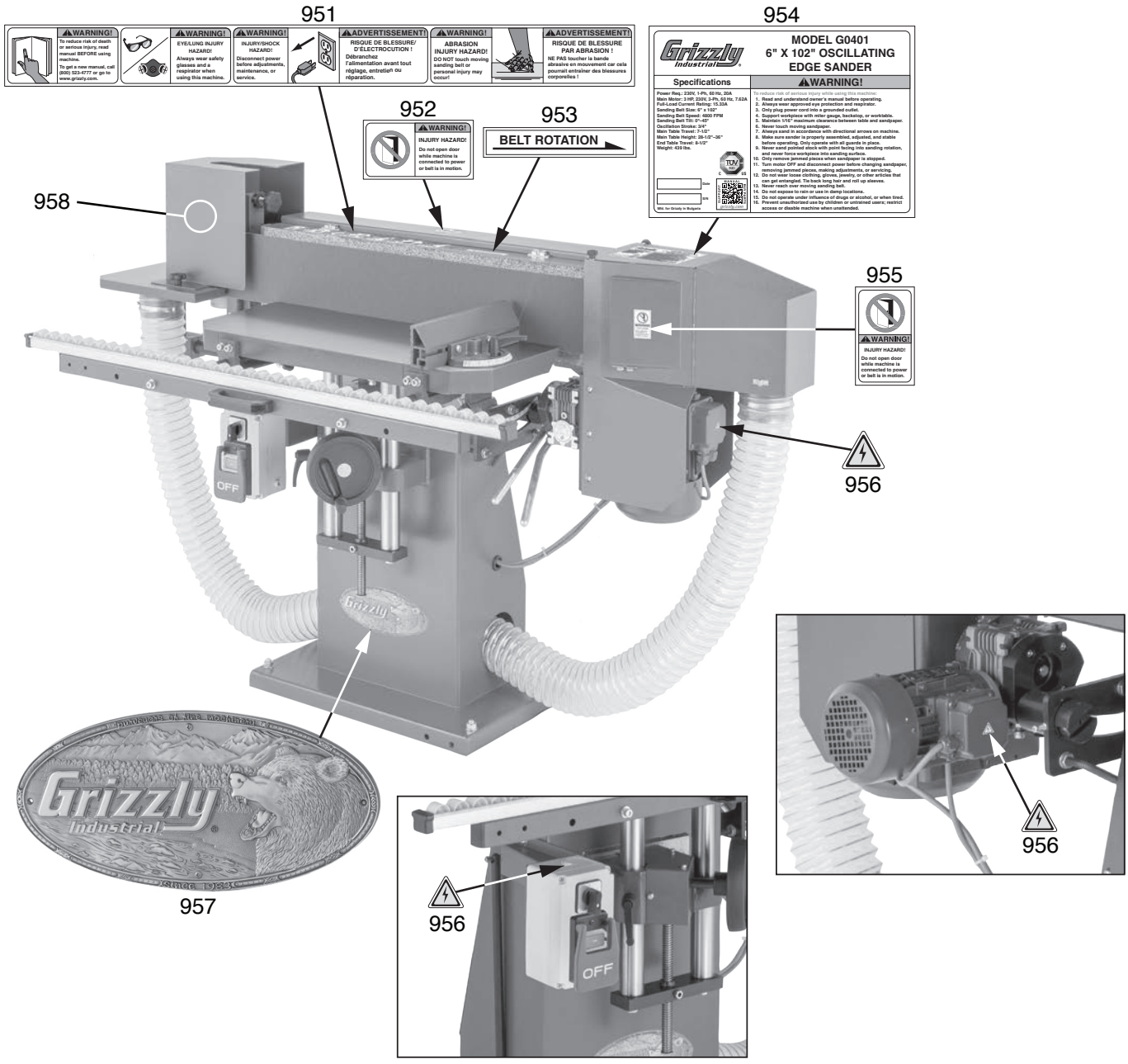
Platen Trunnion



REF	PART #	DESCRIPTION
901	P0401901	FLANGE
902	P0401902	TRUNNION
903	P0401903	TILT BLOCK
904	P0401904	SET SCREW M6-1 X 10 CONE-PT
905	P0401905	MOUNTING SHAFT
906	P0401906	LOCK BLOCK
907	P0401907	PLATEN TILT LEVER
908	P0401908	HEX NUT M8-1.25
909	P0401909	CAP SCREW M8-1.25 X 20

REF	PART #	DESCRIPTION
910	P0401910	PLATEN TILT LOCK LEVER
911	P0401911	HEX NUT M10-1.5 THIN
912	P0401912	LOCK WASHER 10MM
913	P0401913	FLAT WASHER 10MM
914	P0401914	LOCK PIN
915	P0401915	SET SCREW M4-.7 X 5 CONE-PT
916	P0401916	COVER
917	P0401917	CAP SCREW M6-1 X 20
918	P0401918	LOCK WASHER 6MM

Labels & Cosmetics



REF	PART #	DESCRIPTION
951	P0401951	COMBO WARNING LABEL
952	P0401952	DO NOT OPEN LABEL VERT
953	P0401953	BELT ROTATION LABEL
954	P0401954	MACHINE ID LABEL

REF	PART #	DESCRIPTION
955	P0401955	DO NOT OPEN LABEL HOR
956	P0401956	ELECTRICITY LABEL
957	P0401957	GRIZZLY NAMEPLATE SMALL
958	P0401958	TOUCH-UP PAINT, GRIZZLY GREEN

⚠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