MODEL G0404
11" BENCHTOP OSCILLATING DRUM SANDER
OWNER'S MANUAL
(For models manufactured since 05/25)

#CS23667 PRINTED IN TAIWAN V1.07.25

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

⚠ WARNING!

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

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

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

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

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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.

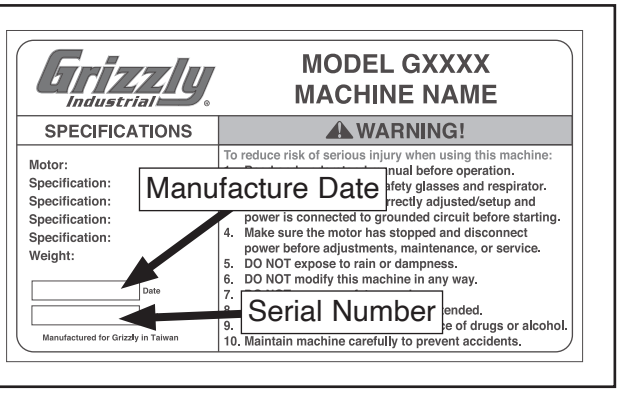
Manual Accuracy

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**.

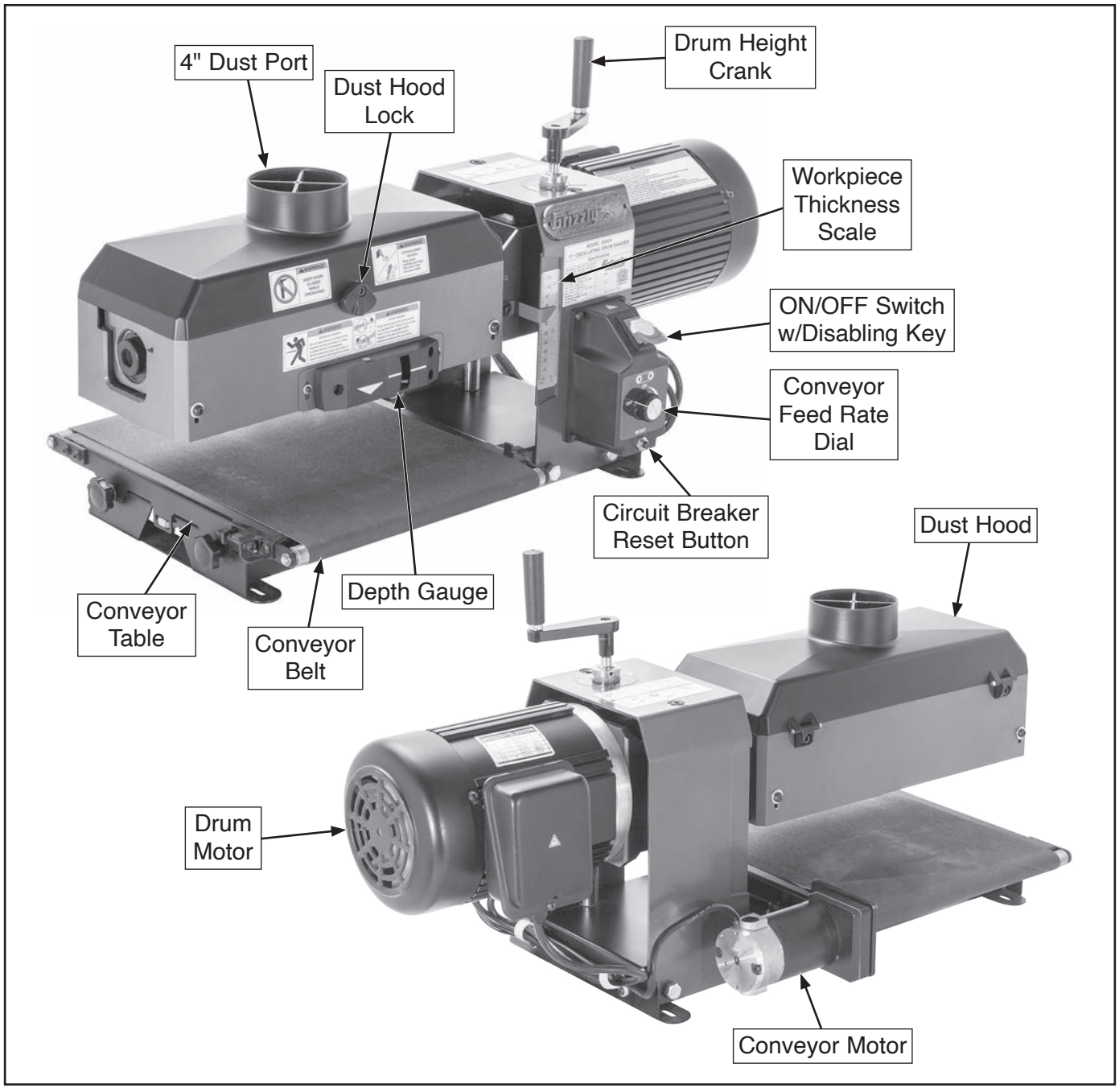
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

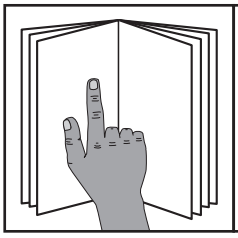
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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

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

Controls & Components

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

Power Controls

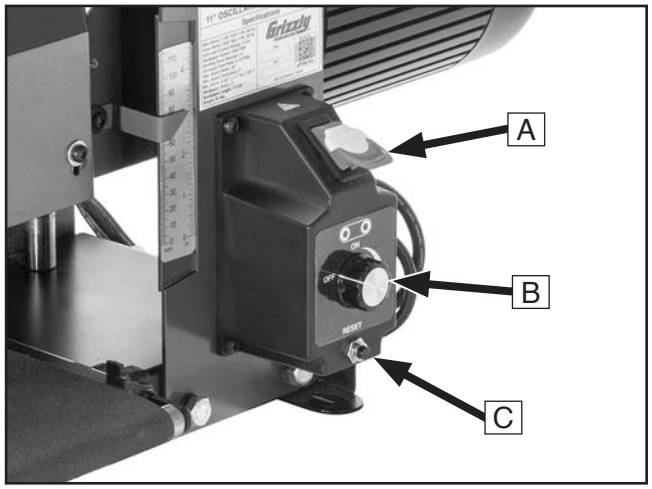


Figure 1. Power controls.

A. ON/OFF Switch w/Disabling Key: Turns machine ***ON*** when moved up; turns machine ***OFF*** when moved down. Removal of yellow key disables switch so machine cannot start.

B. Conveyor Feed Rate Dial: Adjusts conveyor belt feed rate between 0–15 FPM. Turn dial clockwise to increase feed rate; turn dial counterclockwise to decrease feed rate.

C. Circuit Breaker Reset Button: Allows machine to be restarted after thermal overload protection has tripped. To reset, move ON/OFF switch down, wait a few minutes for machine to cool, then press reset button. If button does not stay depressed, allow motor to cool longer, then try again.

Drum Height

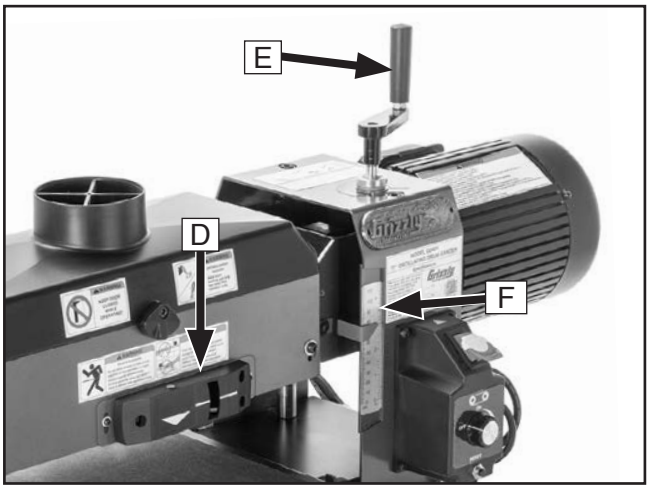


Figure 2. Drum height components.

D. Depth Gauge: Suggests ideal workpiece sanding depth per pass.

E. Drum Height Crank: Raises and lowers drum. One full rotation moves drum approximately 1/16".

F. Workpiece Thickness Scale: Displays approximate distance between sanding drum and conveyor belt.

Conveyor

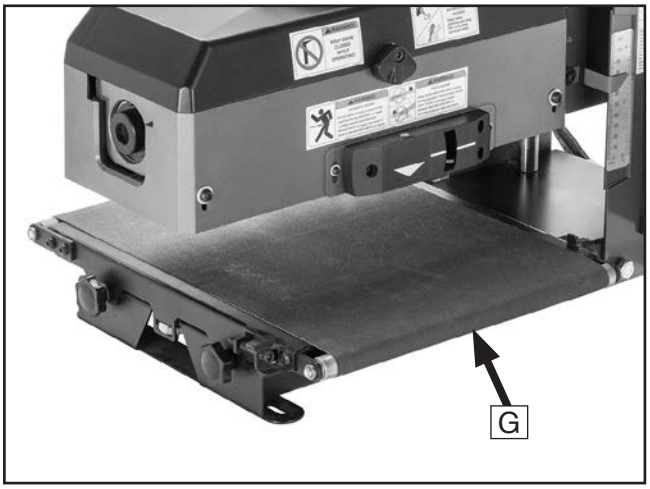


Figure 3. Conveyor components.

G. Conveyor Table w/Belt: Feeds workpiece across conveyor table during sanding operations.

MACHINE DATA SHEET

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

MODEL G0404 11" BENCHTOP OSCILLATING DRUM SANDER

Product Dimensions:

Weight..... 87 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 33-1/2 x 17 x 18 in.
Footprint (Length x Width)..... 11-1/2 x 22 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 100 lbs.
Length x Width x Height..... 37 x 21 x 18 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Full-Load Current Rating..... 11.3A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Paddle Safety Switch w/Disabling Key

Motors:

Main

Horsepower..... 1 HP
Phase..... Single-Phase
Amps..... 11A
Speed..... 1720 RPM
Type..... TEFC Induction
Power Transfer ..... Direct
Bearings..... Shielded & Permanently Lubricated

Conveyor

Horsepower..... 25W
Phase..... Single-Phase
Amps..... 0.3A
Speed..... 4500 RPM
Type..... Universal
Power Transfer ..... Gear
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Number of Sanding Heads	1
Maximum Board Width	22 in.
Minimum Board Width	1 in.
Maximum Board Thickness	3 in.
Minimum Board Thickness	1/8 in.
Minimum Board Length	2-3/8 in.
Sandpaper Speed	2250 FPM
Sanding Belt Oscillations per Minute	29 OPM
Sanding Belt Oscillation Stroke Length	1 in.
Conveyor Feed Rate	0–15 FPM
Sandpaper Length	77-1/4 in.
Sandpaper Width	3 in.

Drum Information

Infeed Sanding Drum Type	Aluminum
Infeed Sanding Drum Size	5 in.

Construction

Conveyor Belt	Sandpaper
Body	Steel
Base	Steel
Paint Type/Finish	Enamel

Other Related Information

Floor To Table Height	3 in.
Sanding Belt Tension	Hook & Loop
Number of Pressure Rollers	2
Pressure Roller Type	Steel
Pressure Roller Size	3/4 in.
Conveyor Table Length	13-3/4 in.
Conveyor Belt Length	32-1/2 in.
Conveyor Belt Width	11-3/4 in.
Belt Roller Size	3/4 in.
Number of Dust Ports	1
Dust Port Size	4 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 min.
Serial Number Location	ID Label
Sound Rating	85 dB
ISO 9001 Factory	Yes

Features:

Open-End Design Accomodates Workpieces up to 22" Wide
Hook & Loop Sanding Belt
Sandpaper Conveyor Belt
4" Dust Port
Variable-Speed Conveyor Motor
5" Sanding Drum w/1" Oscillations
Paddle Switch with Disabling Key
Easy Access for Sandpaper Changes

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 Drum Sanders

⚠WARNING

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

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

SANDING DUST. Sanding creates large amounts of fine airborne dust that can lead to eye injury or serious respiratory illness. Reduce your risk by always wearing approved eye and respiratory protection when sanding. Never operate without adequate dust collection system in place and running. However, dust collection is not a substitute for using a respirator.

POWER DISCONNECT. An accidental startup while changing sanding belts or performing adjustments or maintenance can result in serious entanglement or abrasion injuries. Make sure machine is turned ***OFF***, disconnected from power and air, and all moving parts are completely stopped before changing belts, doing adjustments, or performing maintenance.

SANDPAPER CONTACT. Rotating sandpaper can remove a large amount of flesh quickly. Keep hands away from rotating sanding drum(s) during operation. Never touch moving sandpaper.

AVOIDING ENTANGLEMENT. Tie back long hair, remove jewelry, and do not wear loose clothing or gloves. These can easily get caught in moving parts. Never reach inside machine or try to clear jammed workpiece while machine is operating. Keep all guards in place and secure.

WORKPIECE MATERIAL. This sander is designed to sand only natural wood products or man-made products made from natural wood fiber. DO NOT sand any metal products.

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.

KICKBACK. Occurs when a workpiece is ejected out the front of sander at a high rate of speed toward operator or bystanders. To reduce risk of kickback-related injuries, always stay out of workpiece path, only feed one board at a time, and always make sure pressure rollers are properly adjusted below sanding roller. Never sand workpieces below minimum specifications listed in **Machine Data Sheet**.

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 110V ...11.3 Amps

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

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

⚠WARNING

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

110V Circuit Requirements

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

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

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

⚠CAUTION

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

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

Grounding & Plug Requirements

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

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

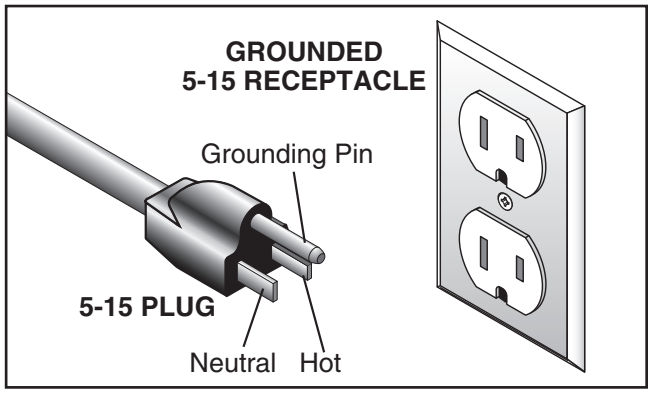
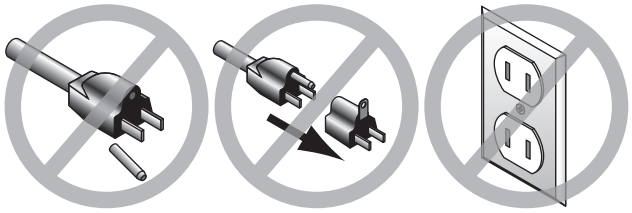


Figure 4. Typical 5-15 plug and receptacle.

⚠CAUTION



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

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

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

Extension Cords

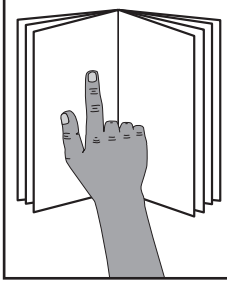
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

Minimum Gauge Size.....16 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP



⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!

⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Safety Glasses (for each person)	1
• Mounting Hardware	As Needed
• Dust Hose 4"	1
• Hose Clamps 4"	2
• Dust Collection System	1
• Additional Person	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.

Box Inventory (Figure 5)	Qty
A. Drum Height Crank	1
B. Cap Screw M5-.8 x 25 (P0404241)	1
C. Drum Sander	1
D. T-Handle Hex Wrench 2.5mm	1
E. Hex Wrenches 4, 5mm	1 Ea.

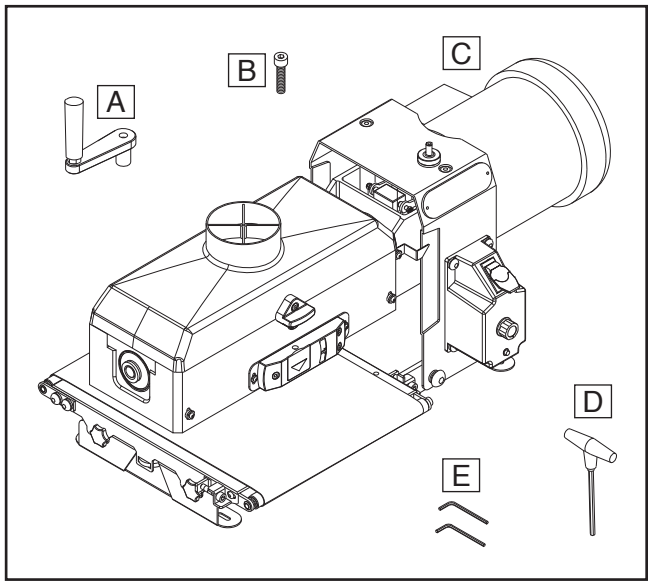


Figure 5. Inventory.

Site Considerations

Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

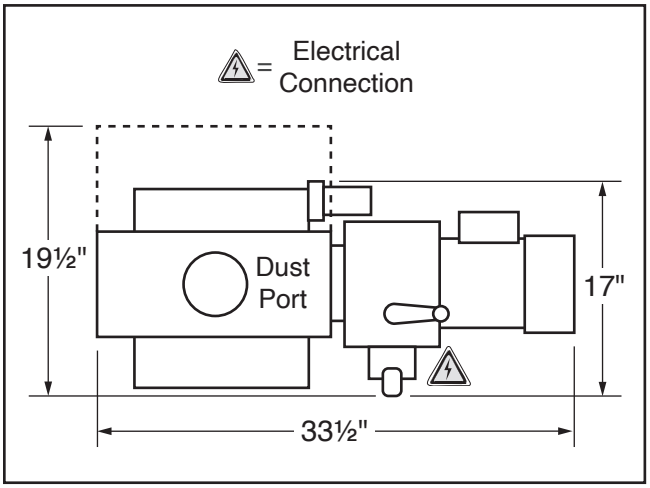
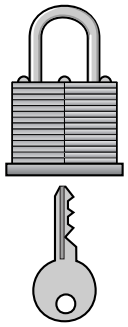


Figure 6. Minimum working clearances.



⚠CAUTION

Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.

Bench Mounting

Number of Mounting Holes 4
Dia. of Mounting Hardware Needed ..... 5/16"

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

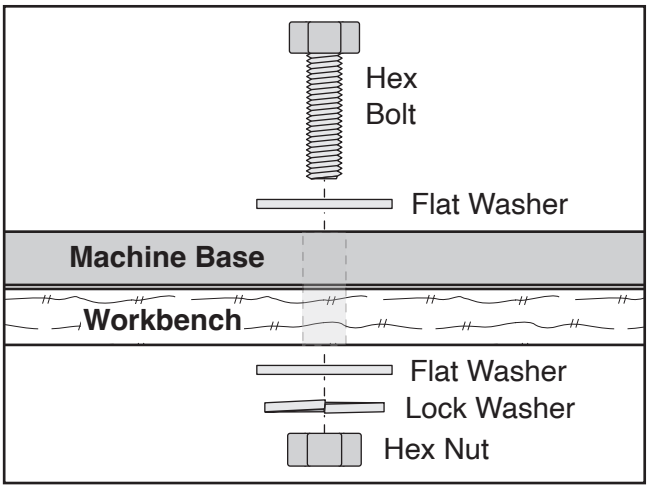


Figure 7. "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

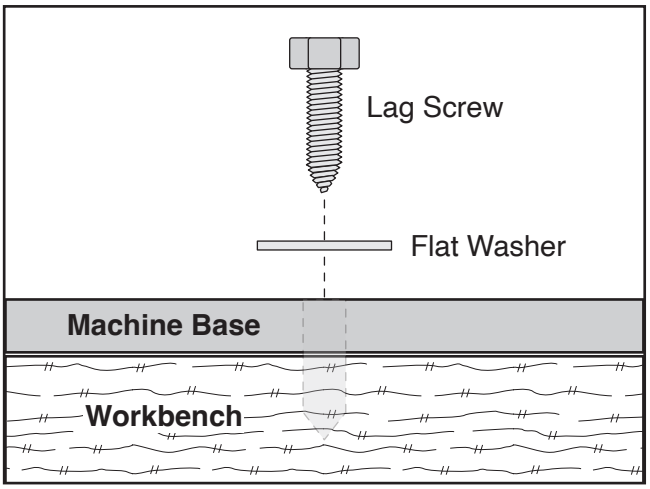


Figure 8. "Direct Mount" setup.

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).

Place the drum height crank over the drum height shaft, then secure with a M5-.8 x 25 cap screw (see **Figure 9**).

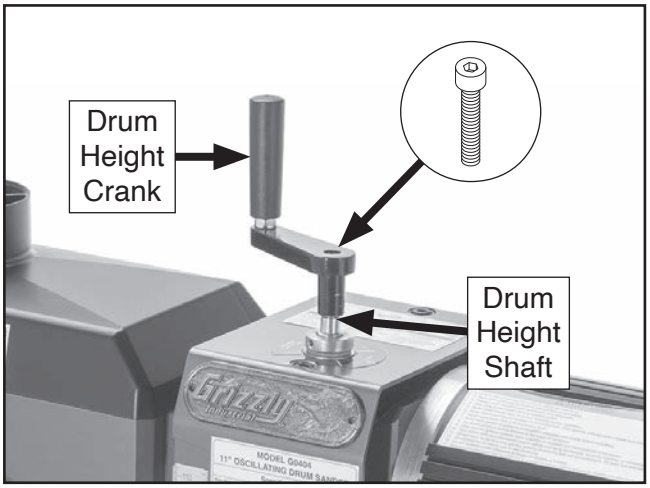


Figure 9. Drum height crank secured to drum height shaft.

Dust Collection

⚠CAUTION

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

Minimum CFM at Dust Port: 400 CFM

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

To connect dust collection system to machine:

1. Fit 4" dust hose over dust port, as shown in **Figure 10**, and secure in place with hose clamp.

Figure 10. Dust hose attached to dust port.

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

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

Test Run

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

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

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the ON/OFF switch disabling key disables the switch properly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Clear all setup tools away from machine.

2. Connect machine to power supply.

3. Turn conveyor feed rate dial all the way counterclockwise (see **Figure 11**).

4. Move ON/OFF switch up to turn machine ***ON*** (see **Figure 11**).

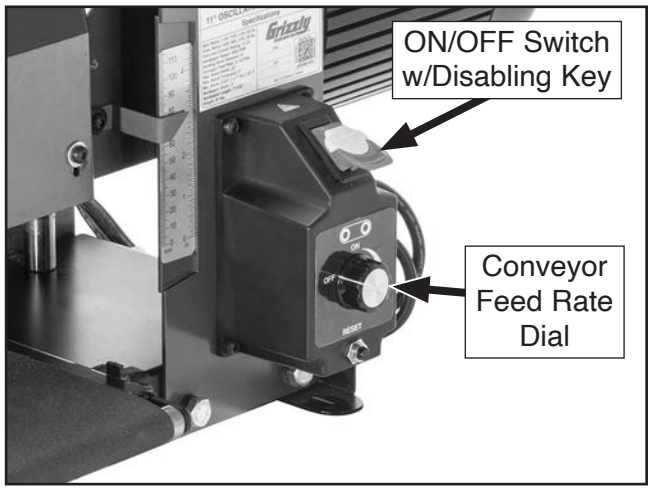


Figure 11. Power controls.

5. Slowly turn conveyor feed rate dial clockwise to start conveyor belt. Rotate dial back and forth to test variable-speed function.

Drum and conveyor motor should run smoothly and without unusual vibrations or noises.

6. Turn variable-speed dial all the way counterclockwise, then move ON/OFF switch down to turn motors ***OFF***.

7. Remove switch disabling key from ON/OFF switch, as shown in **Figure 12**.

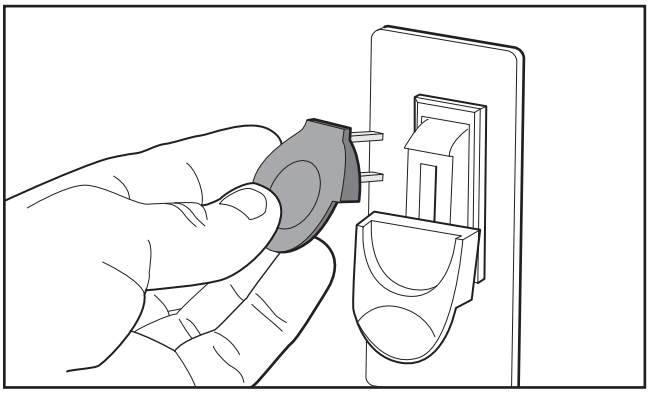


Figure 12. Removing switch key from ON/OFF switch.

8. Try to start machine with ON/OFF switch and conveyor feed rate dial. Machine should not start.

— If machine *does not* start, switch disabling feature is working correctly.

— If machine *does start*, immediately stop machine. Switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Recommended Adjustments

The following adjustments have been made at the factory. However, because of the many variables involved with shipping, we recommend you verify these adjustments to ensure the best results:

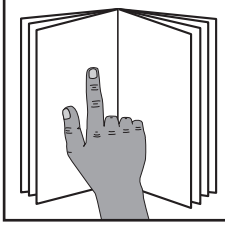
- Workpiece thickness scale calibration (**Page 30**).
- Depth gauge calibration (**Page 31**).
- Conveyor belt tracking and tension (**Page 31**).
- Drum alignment (**Page 35**).
- Pressure roller adjustment (**Page 36**).

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.

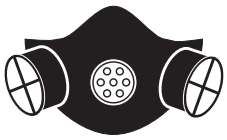


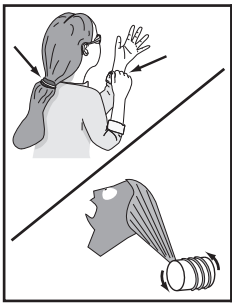
⚠WARNING

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!

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

1. Examines workpiece to verify it is suitable for sanding and to determine which sandpaper grit to use.
2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is wider than conveyor table, operator supports workpiece full width. If workpiece is overly long and difficult to handle, operator uses a roller support stand to assist with feeding.
3. Adjusts drum height to approximate workpiece thickness, then uses depth gauge to finalize drum height.
4. Puts on required safety glasses and respirator, and ensures dust collection is connected to dust port.
5. Starts dust collection system, then turns machine ***ON*** and waits for sanding drum to reach full speed.
6. Starts conveyor belt and adjusts feed rate as desired.
7. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.
8. Stands to side of machine and receives workpiece from outfeed side of table. If workpiece is wider than conveyor table, operator rotates workpiece 180º and feeds workpiece back through sander.
9. Lowers height of drum a small amount (typically ¼ of a full rotation of height crank), then repeats **Steps 7–8**.
10. DISCONNECTS MACHINE FROM POWER, changes sandpaper to finer grit, and connects to power to repeat sanding as needed.
11. Turns sander and dust collector ***OFF***.

Stock Inspection & Requirements

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

Before sanding, inspect all workpieces for the following:

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

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

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear the sandpaper. Always visually inspect your workpiece for these items. If they can't 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 sandpaper, increases the risk of kickback, and yields poor results.

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

Sanding Tips

⚠WARNING

Kickback can cause serious personal injury. Avoid kickback by heeding following precautions:

— DO NOT edge sand boards. This can also damage conveyor belt and sandpaper.
— DO NOT sand more than one board at a time side by side. Minor variations in thickness can cause one board to be propelled by rapidly spinning drum and ejected from machine.
— NEVER stand directly in front of infeed area of machine.

NOTICE

Avoid the following practices to prevent damage to machine or components:

— Overloading motors or pushing sander to failure. Repeatedly doing so is abuse to the machine and will cause damage that is not covered under warranty.
— Sanding boards less than 2⅜" long or less than ⅛" thick.

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

- Replace coarse grit sandpaper with a finer grit to achieve a smoother finish.

- Lower the drum a maximum of ¼ turn of the handwheel until the workpiece is the desired thickness.

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

- Feed boards into the sander at different places on the conveyor to maximize sandpaper life and prevent uneven conveyor belt wear.

- Extend the life of the sandpaper by regularly using a PRO-STIK® sanding pad (see **Page 24**).

- Run wide stock through two or three times without adjusting drum height. Turn stock 180° between passes to ensure an evenly sanded surface.

- When sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When the drum moves from sanding a wide surface to sanding a narrow surface, the load on the motor will be reduced, and the drum will speed up, causing a gouge.

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

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

Choosing Sandpaper

There are many types of sandpaper to choose from. We recommend aluminum oxide for general workshop environments (see **Figure 13**).

Aluminum Oxide H&L Sanding Rolls 3" x 50'
H4422—60-Grit
H4779—80-Grit
H4423—100-Grit
H4780—120-Grit
H4424—150-Grit
T21255—180-Grit
T21256—220-Grit

Figure 13. 3" x 50' A/O H&L sanding roll.

Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

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

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

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

Replacing Sandpaper

The Model G0404 is designed for 3" wide sandpaper rolls. **Page 19** shows available grit sizes.

Items Needed	**Qty**
Sandpaper Roll, Hook-and-Loop 3" x 77¼"	1
Utility Knife	1

To replace sandpaper:

1. DISCONNECT MACHINE FROM POWER!

2. Rotate dust hood lock counterclockwise, then open dust hood (see **Figure 14**).

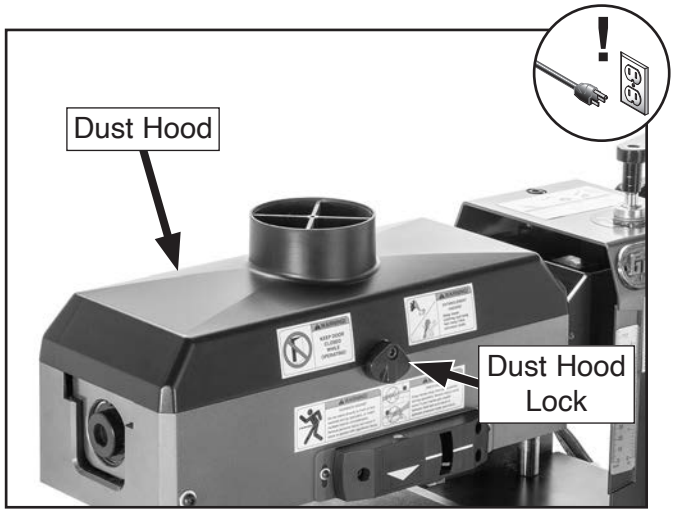


Figure 14. Location of dust hood and lock.

3. Squeeze left clamp and remove sandpaper end from clamp (see **Figure 15**).

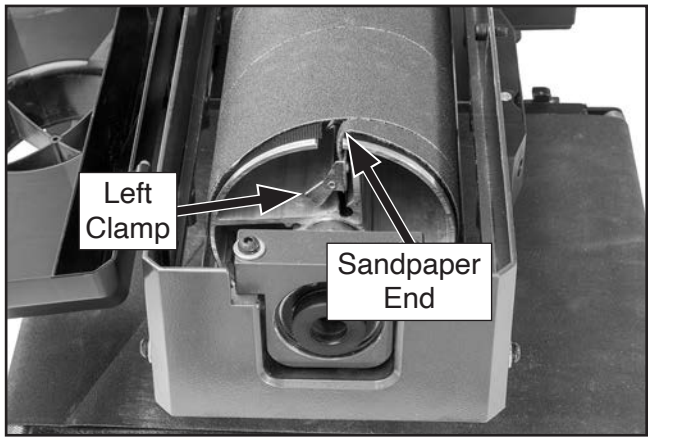


Figure 15. Location of left clamp.

4. Rotate drum to carefully remove sandpaper strip until you reach right clamp.

   Note: *Take care not to rip or tear old sandpaper, so it can be used as template when cutting replacement sandpaper strip.*

5. Squeeze right clamp to release remaining sandpaper end.

6. Use old sandpaper strip as pattern, if possible. Otherwise, use pattern in **Figure 16** to cut new piece of sandpaper to necessary shape.

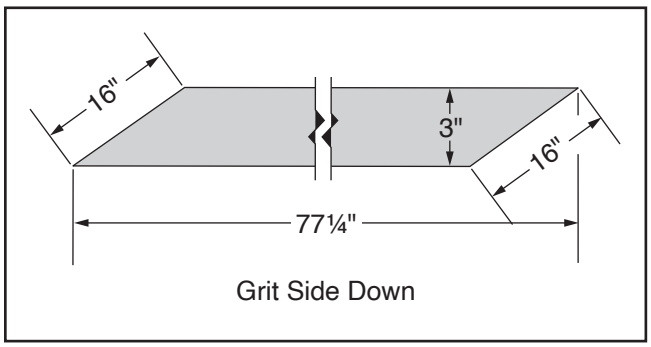


Figure 16. Sandpaper pattern for drum.

7. Insert corner of new sandpaper in slot at left side of drum and clamp with left clamp, as shown in **Figure 17**.

   Note: *Angled side of sandpaper should be flush with left drum edge.*

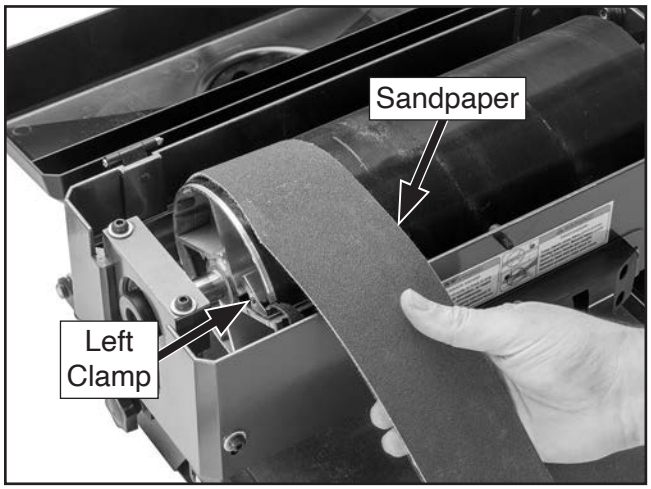


Figure 17. New sandpaper clamped to drum on left side.

8. Wrap sandpaper around drum (see **Figure 18**), ensuring there are no bubbles or overlapping edges.

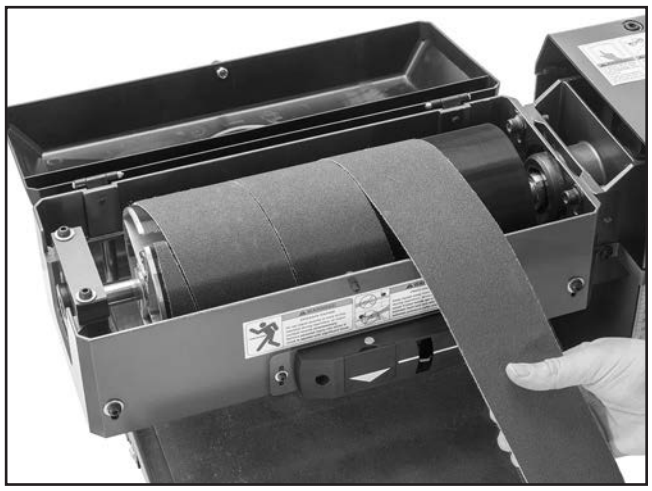


Figure 18. Wrapping sandpaper around drum.

9. When sandpaper reaches right side of drum, tuck sandpaper into right slot and clamp with right clamp. Sandpaper should sit flat against drum and not overlap at any point.

   — If sandpaper *does not reach* right slot and clamp, you may have inserted sandpaper too deeply into left slot and clamp. Unwrap sandpaper and repeat **Steps 7–9**.

   — If sandpaper *does not fit* into slot, you may have placed too little sandpaper into left slot and clamp. Unwrap sandpaper and repeat **Steps 7–9**.

10. When sandpaper sits flat against drum, does not overlap at any point, and is secured in both clamps evenly, close dust hood and secure with dust hood lock.

⚠WARNING

If sandpaper strip comes loose during operation, it could cause workpiece to bind and kickback at operator, which could result in serious personal injury. Always make sure sandpaper strip is properly installed and firmly secured by clamping devices before connecting sander to power.

Setting Depth of Cut

The depth of cut is set by adjusting the distance of the sanding drum above the conveyor table using the drum height crank (see **Figure 19**).

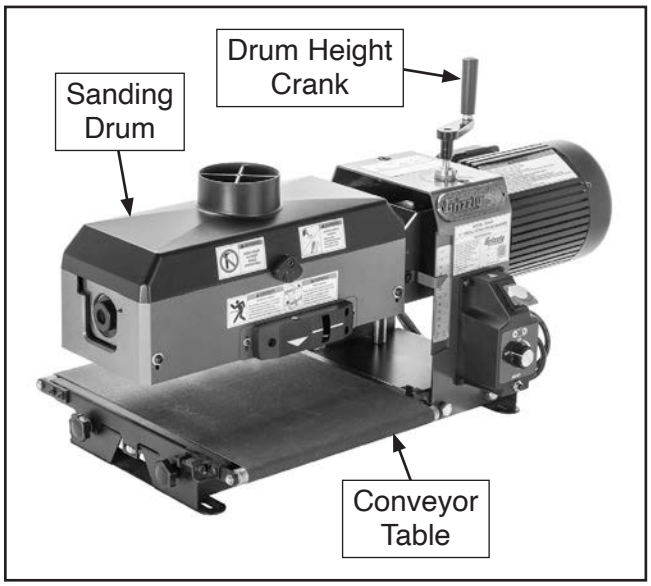


Figure 19. Drum height components.

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

Generally, a ¼ turn of the drum height crank (1/64" or 0.4mm of vertical movement) per pass is acceptable for coarser grits or softer woods. A ⅛ turn of the crank is recommended for finer grits or harder woods. The depth gauge indicates a good depth-of-cut starting point, however, use your best judgement and make adjustments as needed to produce good sanding results for your operation.

IMPORTANT: Keep in mind that, although the thickness of the workpiece is reduced during sanding, this process is not a replacement for thickness planing, which should be done with a planer or other acceptable tool/machine before beginning the sanding process.

Workpiece Thickness Scale

The thickness scale (see **Figure 20**) on the front of the machine shows the approximate workpiece thickness. The thickness measurement is indicated by the top edge of the pointer.

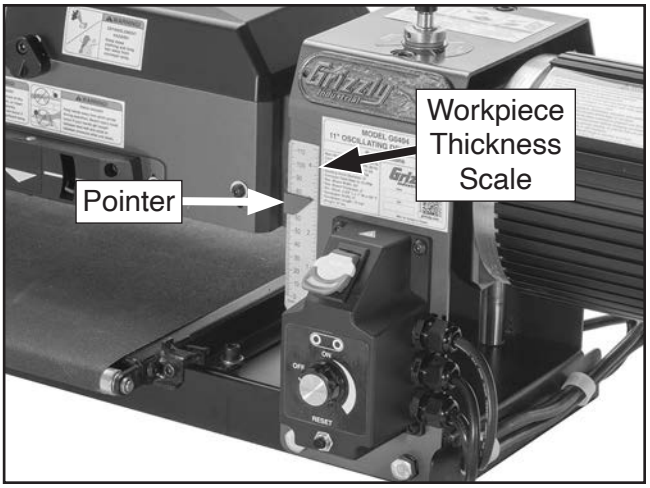


Figure 20. Workpiece thickness scale.

Depth Gauge

The depth gauge functions as a general guide for the ideal sanding depth per pass. When the indicator aligns with the gauge line on either side of it (see **Figure 21**), the drum height is set correctly for most operations.

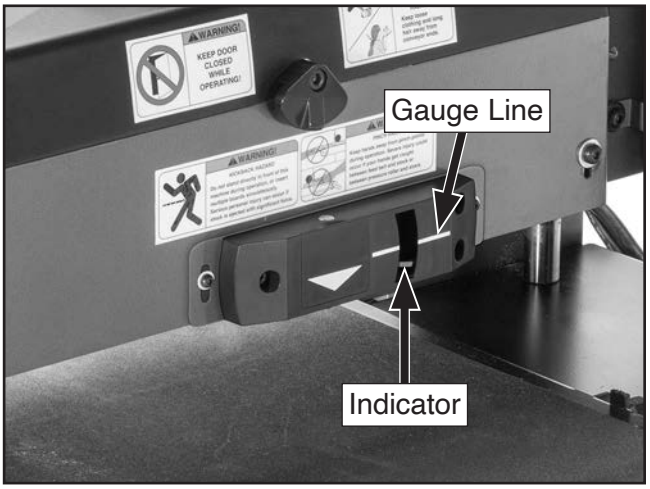


Figure 21. Depth gauge components.

To set depth of cut:

1. Rotate drum height crank until sanding drum is well above conveyor table.

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

2. Place workpiece on conveyor table, under sanding drum, then lower drum until workpiece thickness scale displays approximate workpiece thickness.

3. Use drum height crank and depth gauge to finalize drum height adjustment.

   Note: *Each full turn of drum height crank lowers sanding drum approximately 0.06" (1/16" or 1.5mm).*

4. Take note of value on workpiece thickness scale, then raise drum so you can remove workpiece from machine.

5. Adjust drum back to value noted in **Step 4**, then proceed with operation.

NOTICE

Taking excessive depth of cut could cause main motor to exceed available power source amperage. In this case, motor or power source circuit breaker will trip. If this should happen, disconnect machine from power, allow motor to cool, reset circuit breaker, then take smaller depth of cut.

Adjusting Conveyor Feed Rate

The conveyor feed rate dial (see **Figure 22**) allows you to adjust the feed rate from 0–15 FPM. The correct feed rate to use depends on the type stock you are sanding (hardwood vs. softwood) and the stage of finish of the sandpaper.

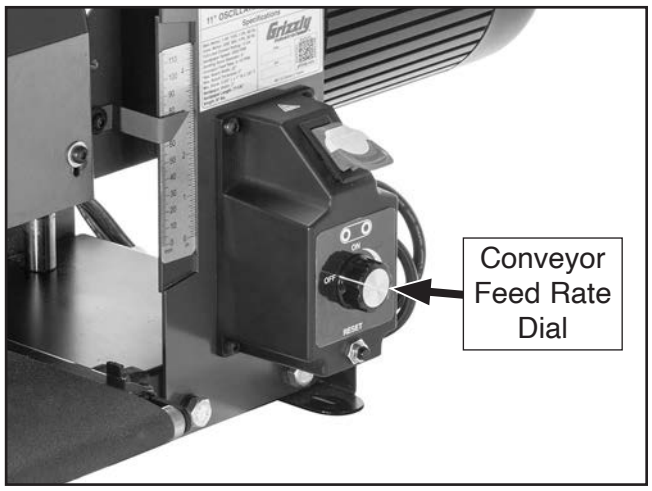


Figure 22. Location of conveyor feed rate dial.

As a general rule, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove material faster, but runs the risk of overloading the motor or damaging the sandpaper.

Use trial-and-error to determine the best settings for your specific applications.

To adjust conveyor feed rate:

1. Turn machine ***ON***.

2. Rotate conveyor feed rate dial (see **Figure 22**) clockwise to turn conveyor belt ***ON***, then turn dial clockwise to increase feed rate or turn it counterclockwise to decrease feed rate. Turning dial all the way counterclockwise will turn conveyor belt ***OFF***.

Engaging/ Disengaging Oscillation

While the oscillation feature of the Model G0404 helps to reduce sandpaper clogging, heat buildup and scratches in the finish, some projects might not benefit from this feature (i.e., extra wide or narrow workpieces that may catch on sandpaper edge).

Tool Needed	**Qty**
Hex Wrench 2.5mm	1

To engage/disengage oscillation:

1. Lower drum almost all the way. Drum *should not* touch conveyor table because machine will be turned ***ON*** in next step.

2. Use ON/OFF switch to jog machine until set screws shown in **Figure 23** are facing up where they can be accessed.

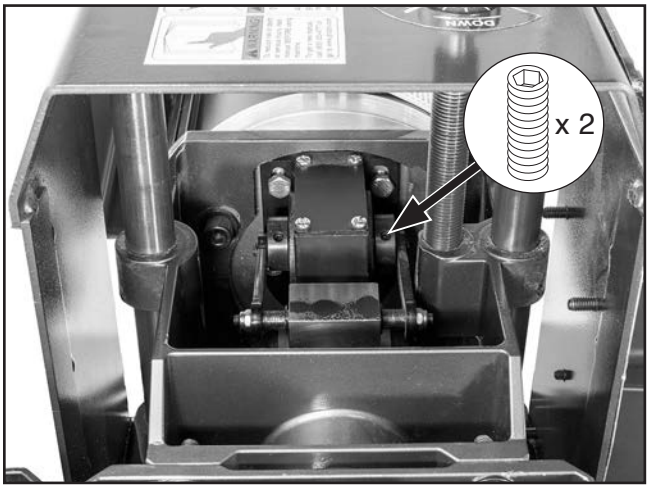
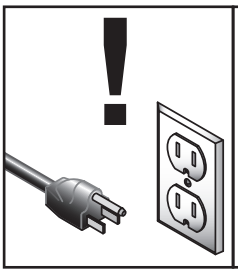


Figure 23. Location of oscillation set screws.

3. DISCONNECT MACHINE FROM POWER!

4. Loosen set screws to *disengage* oscillation; tighten set screws to *engage* oscillation.

SECTION 5: 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.
- Loaded sandpaper or conveyor belt.
- Damaged sandpaper.
- Worn ON/OFF switch or feed rate dial.
- Worn or damaged wires.
- Any other unsafe condition.

Daily Maintenance
- Lubricate conveyor roller bushings.

Weekly Maintenance
- Clean/vacuum dust buildup off of machine and motor and from inside dust hood.

Biannual Maintenance
- Lubricate leadscrew and guide bars.

Cleaning Machine

Cleaning the Model G0404 is relatively easy. Vacuum excess sawdust, and wipe off the remaining dust with a dry cloth.

Cleaning Sandpaper/ Conveyor Belt

To increase the working life of your sandpaper, clean it whenever you notice a decrease in performance due to heavy loading of material. Use the same technique to clean the conveyor belt if it is dirty or you notice the workpiece slipping between the sanding drum and the conveyor belt. Use a cleaning pad like the one shown in **Figure 24**.

D3003—PRO-STIK® Cleaning Pad
Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your sander to remove the dust build-up from the sandpaper without damage. Measures 15" x 20" x ¾".

Figure 24. D3003 PRO-STIK® Cleaning Pad.

To clean sandpaper/conveyor belt:

1. Use workpiece thickness scale to set sanding drum height for thickness of cleaning pad.

2. Run cleaning pad through sander two or three times. DO NOT take too deep of a cut—sandpaper should barely touch cleaning pad!

Lubrication

The bearings on the Model G0404 have been lubricated and sealed at the factory. No other care is needed unless they need replacement.

The conveyor roller bushings should be lubricated daily while the sanding drum height leadscrew and guide bars should be lubricated twice a year. See below for some of the lubrication products that Grizzly offers.

T26685—ISO 32 Moly-D Machine Oil, 1 Gal.
Moly-D oils are some of the best we have found for maintaining the critical components of machinery because they tend to resist run-off and maintain their lubricity under a variety of conditions.

Figure 25. T26685 ISO 32 Moly-D Machine Oil.

T33964—Quest Micro-Dry PTFE Dry Lubricant
Spray on saw blades, router bits, shaper cutters—even table tops—to form a low-friction coating that works great, even under high temperature and pressure. Contains no silicone or oil, so it will not stain or damage paint or wood finishes. 10 oz.

Figure 26. T33964 Quest Micro-Dry PTFE Dry Lubricant.

Conveyor Roller Bushings

Lubrication Type .....T26685 or ISO 32 Equiv.
Lubrication Amount ..... As Needed
Lubrication Frequency ..... Daily

To lubricate the conveyor roller bushings, add a couple drops of lubricant to the conveyor roller bushings (see **Figure 27**). Run the conveyor for a couple of minutes to spread the oil.

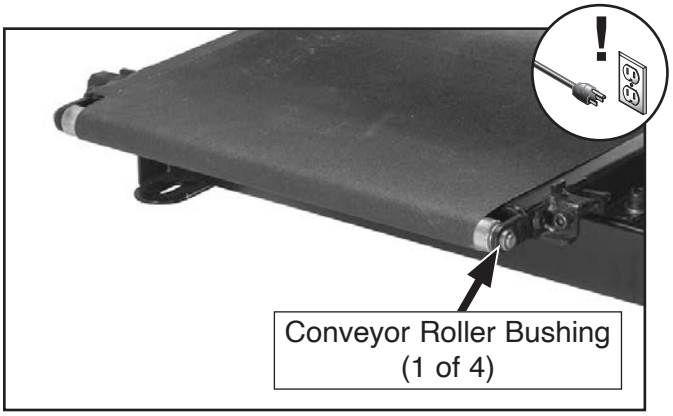


Figure 27. Location of conveyor roller bushings.

Leadscrew & Guide Bars

Lubrication Type ..... T33964 or Dry Lube Equiv.
Lubrication Amount ..... As Needed
Lubrication Frequency ..... 6 Months

Items Needed	Qty
Shop Rags	As Needed
Soft Wire Brush	1
Mineral Spirits	As Needed

Lubricate the sanding drum height leadscrew and guide bars with dry lube every six months. Clean the exposed leadscrew teeth and surface of the guide bars (see **Figure 28**). When components are dry, apply the lubricant. Move the sanding drum up and down to spread the lubricant.

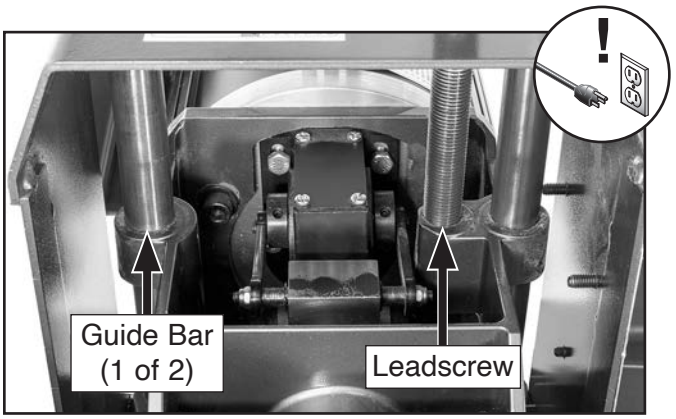
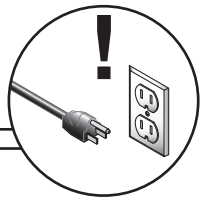


Figure 28. Location of leadscrew and guide bars.

SECTION 6: 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.*

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Switch disabling key removed. 2. Machine circuit breaker tripped. 3. Incorrect power supply voltage or circuit size. 4. Power supply circuit breaker tripped or fuse blown. 5. Main motor wires connected incorrectly. 6. Wiring broken, disconnected, or corroded. 7. Main motor or motor bearings at fault.	1. Install switch disabling key. 2. Reset circuit breaker. 3. Ensure correct power supply and circuit size (**Page 10**). 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Correct motor wiring connections (**Page 38**). 6. Fix broken wires or disconnected/corroded connections (**Page 38**). 7. Replace motor.
Machine turns ***ON*** but conveyor belt does not start/ stalls.	1. Wiring broken, disconnected, or corroded. 2. Conveyor motor brushes worn out. 3. Conveyor motor overheated. 4. Conveyor motor, gearbox, or motor bearings at fault.	1. Fix broken wires or disconnected/corroded connections (**Page 38**). 2. Remove/replace brushes (**Page 29**). 3. Clean motor, let cool, and reduce workload. 4. Replace motor.
Machine stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Main motor wires connected incorrectly. 3. Machine undersized for task. 4. Machine overheated, tripping machine circuit breaker. 5. Extension cord too long. 6. Main motor or motor bearings at fault.	1. Only cut wood and ensure moisture content is below 20% (**Page 18**). 2. Correct main motor wiring connections (**Page 38**). 3. Clean (**Page 24**)/replace (**Page 20**) sandpaper; reduce feed rate (**Page 23**)/sanding depth (**Page 21**). 4. Clean motor, let cool, and reduce workload. Reset breaker. 5. Move machine closer to power supply; use shorter extension cord (**Page 11**). 6. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor mount loose/broken. 3. Motor fan rubbing on fan cover. 4. Conveyor motor gearbox at fault. 5. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Tighten/replace. 3. Fix/replace fan cover; replace loose/damaged fan. 4. Replace motor. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operation

Symptom	Possible Cause	Possible Solution
Vibration when sanding.	1. Incorrectly mounted to workbench. 2. Loose pillow block bearings. 3. Worn pillow block bearings.	1. Shim or tighten mounting hardware. 2. Tighten pillow block bearings. 3. Replace pillow block bearings.
Grinding, screeching, or rubbing noise when drum is powered up.	1. Worn pillow block bearings.	1. Replace pillow block bearings.
Sandpaper clogs quickly.	1. Sanding depth of cut too much or feed rate too slow. 2. Workpiece has high moisture content or sap. 3. Incorrect sandpaper grit. 4. Poor dust collection. 5. Sandpaper loaded with sawdust and gum. 6. Worn sandpaper.	1. Reduce depth of cut (**Page 21**) or increase feed rate (**Page 23**). 2. Use different stock, or accept characteristics of stock and plan on cleaning (**Page 24**)/replacing (**Page 20**) sandpaper frequently; remove applied finishes before sanding. 3. Use correct sandpaper grit for operation (**Page 19**). 4. Unclog ducts; close gates to improve suction; re-design dust collection system. 5. Clean (**Page 24**)/replace (**Page 20**) sandpaper. 6. Replace (**Page 20**) sandpaper.
Sandpaper comes off drum (without tearing) or is loose.	1. Sandpaper not properly wrapped onto drum or not fastened correctly. 2. Sandpaper not cut to correct dimensions. 3. Torn or damaged sandpaper. 4. Foreign object in workpiece. 5. Table not parallel with sanding drum.	1. Install sandpaper correctly (**Page 20**). 2. Cut sandpaper to correct dimensions (**Page 20**). 3. Replace sandpaper (**Page 20**). 4. Sand only clean workpiece (**Page 18**). 5. Adjust table parallel with sanding drum (**Page 35**).
Sandpaper tears off drum.	1. Sandpaper overlapping. 2. Depth of cut too much. 3. Table not parallel with sanding drum.	1. Install sandpaper correctly (**Page 20**). 2. Reduce depth of cut (**Page 21**). 3. Adjust table parallel with sanding drum (**Page 35**).
Burn marks on workpiece.	1. Using too fine of sanding grit for depth of cut. 2. Feed rate too slow. 3. Sandpaper loaded with sawdust and gum. 4. Sandpaper not properly wrapped in drum. 5. Sandpaper worn or damaged.	1. Use coarser grit sandpaper (**Page 19**) or decrease depth of cut (**Page 21**). 2. Increase feed rate (**Page 23**). 3. Clean (**Page 24**)/replace (**Page 20**) sandpaper. 4. Install sandpaper correctly (**Page 20**). 5. Replace sandpaper (**Page 20**).
Glazed workpiece surface after sanding.	1. Sanding wet stock. 2. Sandpaper loaded with sawdust and gum. 3. Sanding stock with high amount of applied finishes. 4. Sandpaper worn or damaged.	1. Only sand stock that has moisture content below 20% (**Page 18**). 2. Clean (**Page 24**)/replace (**Page 20**) sandpaper. 3. Use different stock, or accept characteristics of stock and plan on cleaning (**Page 24**)/replacing (**Page 20**) sandpaper frequently; remove applied finishes before sanding. 4. Replace sandpaper (**Page 20**).
Workpiece slips on conveyor or kicks out.	1. Sanding depth of cut or feed rate too high. 2. Conveyor belt dirty or worn. 3. Pressure rollers not properly adjusted.	1. Reduce depth of cut (**Page 21**) or reduce feed rate (**Page 23**). 2. Clean (**Page 24**)/replace (**Page 32**) belt. 3. Properly adjust pressure roller height (**Page 36**).
Uneven workpiece thickness from side to side.	1. Table not parallel with sanding drum. 2. Conveyor belt worn.	1. Adjust table parallel with sanding drum (**Page 35**). 2. Replace conveyor belt (**Page 32**).

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Conveyor belt slips or does not track correctly.	1. Belt tension not properly adjusted. 2. Conveyor belt worn. 3. Workpiece too heavy.	1. Properly adjust belt tension (**Page 31**). 2. Replace belt (**Page 31**). 3. Use lighter workpiece.
Machine lacks power; drums stop turning under load.	1. Too much pressure on sanding drum. 2. Too much pressure on pressure rollers.	1. Reduce depth of cut (**Page 21**). 2. Reduce pressure roller pressure (**Page 36**).
Drum height crank hard to rotate.	1. Drum height leadscrew and columns are clogged with sawdust.	1. Clean and lubricate drum height leadscrew and columns (**Page 25**).
Ripples or lines in workpiece.	1. Uneven feed rate. 2. Conveyor belt flexing or vibrating.	1. Maintain even feed rate through entire sanding operations. 2. Reduce depth of cut (**Page 21**) or reduce feed rate (**Page 23**). Tighten loose fasteners.
Snipe marks in workpiece.	1. Improper pressure roller pressure. 2. Workpiece too long to be supported without additional help.	1. Adjust pressure roller pressure (**Page 36**). 2. Use assistant or roller stand/tables on infeed and outfeed ends of conveyor to keep workpiece from bending.
Workpiece pulls to one side during sanding operations.	1. Table not parallel with sanding drum.	1. Adjust table parallel with sanding drum (**Page 35**).
Poor dust collection.	1. Dust collection line incorrectly sized for machine. 2. Dust collector underpowered or too far from machine.	1. Size the dust collection line correctly for machine dust port (**Page 15**). 2. Upgrade dust collector or decrease distance from dust collector to machine.
Sanding grains easily rub off.	1. Sandpaper stored in improper environment. 2. Sandpaper has been damaged or folded.	1. Replace damaged sandpaper; store sandpaper in cool, dry place. 2. Replace damaged sandpaper; do not bend or fold sandpaper.

Replacing Conveyor Motor Brushes

The conveyor belt is driven by a universal motor that uses two carbon brushes to transmit electrical current inside the motor. These brushes are considered to be a regular wear item or "consumable," and will need to be replaced during the life of the motor. The frequency of required replacement is often related to how much the motor is used and how hard it is pushed.

Replace both carbon brushes as a set when the motor no longer reaches full power, or when the brushes measure less than 9mm long (new brushes are 15mm long).

If your machine is used frequently, we recommend keeping an extra set of these replacement brushes on-hand to avoid any downtime.

Items Needed	**Qty**
Flat Head Screwdriver ¼"	1
Replacement Brush Pair (P0404214-2)	1

To replace conveyor motor brushes:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (2) brush caps and worn brushes (see **Figures 29**–**30**) from motor.

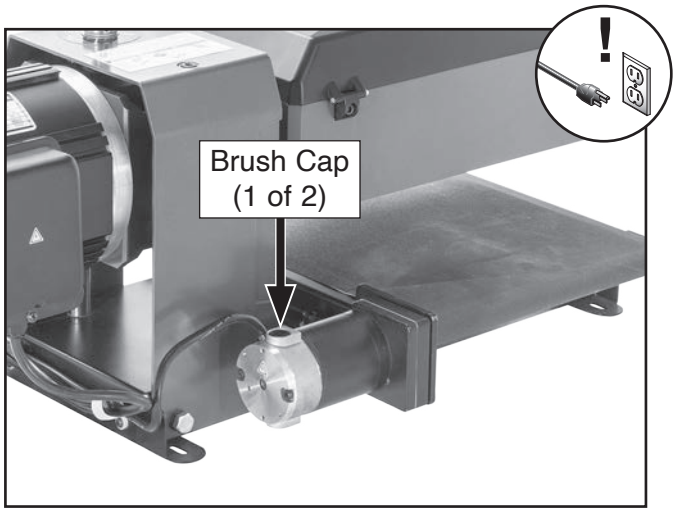


Figure 29. Location of brush caps.

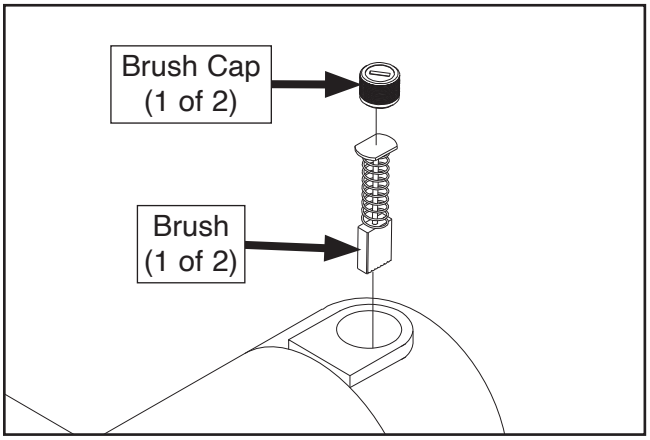


Figure 30. Location of brushes under brush caps.

3. Replace both motor brushes and install brush caps.

Calibrating Workpiece Thickness Scale

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

Tools Needed	Qty
Hex Wrench 4mm	1

To calibrate workpiece thickness scale:

1. DISCONNECT MACHINE FROM POWER!

2. Lower sanding drum until sandpaper on drum contacts conveyor belt.

Note: *Drum must contact conveyor belt, not just pressure rollers.*

— If pointer points to 0" on workpiece thickness scale (see **Figure 31**), no adjustment is required.

— If pointer *does not* point to 0" on workpiece thickness scale (see **Figure 31**), proceed to **Step 3**.

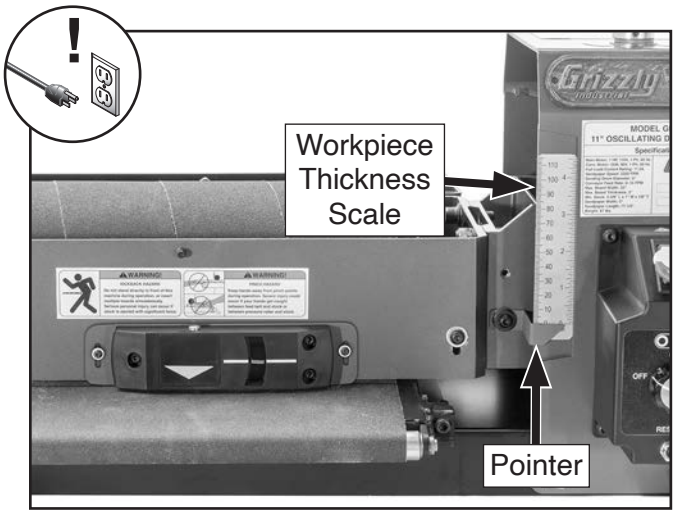


Figure 31. Sanding drum adjusted down to zero workpiece thickness scale.

3. Loosen button head cap screw shown in **Figure 32**, adjust pointer to 0", then tighten screw.

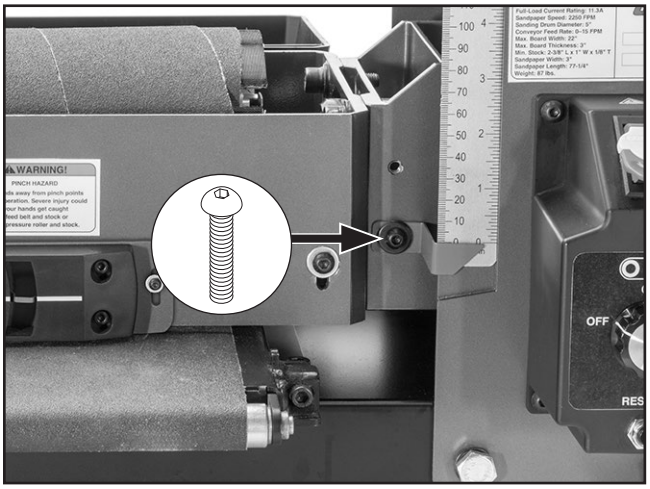


Figure 32. Location of workpiece thickness scale pointer screw.

Calibrating Depth Gauge

Use the following steps to calibrate the position of the depth gauge if it is not indicating correctly.

Tool Needed	Qty
Hex Wrench 2.5mm	1

To calibrate depth gauge:

1. DISCONNECT MACHINE FROM POWER!

2. Open dust hood.

3. Lower sanding drum until sandpaper contacts conveyor belt and drum cannot be turned by hand.

— If indicator *is* aligned with gauge line on either side of it (see **Figure 33**), no adjustment is required.

— If indicator *is not* aligned with gauge line on either side of it (see **Figure 33**), proceed to **Step 4**.

4. Loosen (2) button head cap screws shown in **Figure 33**, adjust depth gauge assembly up or down until indicator is aligned with gauge line, then tighten screws.

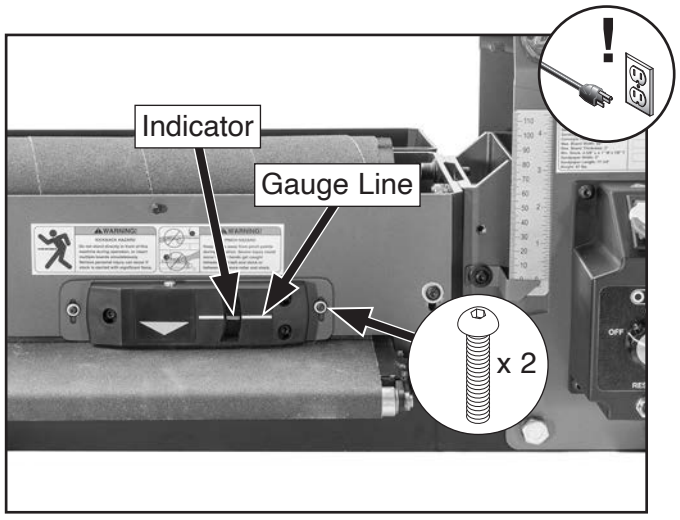


Figure 33. Indicator aligned with gauge line.

Tracking & Tensioning Conveyor Belt

The conveyor belt tension and tracking is controlled by the adjustment screws at the end of the front conveyor roller. If the conveyor is too loose or tracks to one side, it must be adjusted.

Items Needed	Qty
Pencil or Tape	1
Hex Wrenches 4, 5mm	1 Ea.
Wrench or Socket 10mm	1

⚠CAUTION

Working around moving conveyor and parts presents pinch/entanglement hazards that can cause personal injury. Use extreme care to keep hands clear of in-running pinch points while adjusting tracking when machine is running. Roll up sleeves and do not wear gloves or other apparel that could become entangled in moving parts.

To track and tension conveyor belt:

1. Use pencil or tape to make reference mark on each side of conveyor table where end of adjustment screws are positioned (see **Figure 34**). These reference marks will provide a visual aid in keeping track of adjustments.

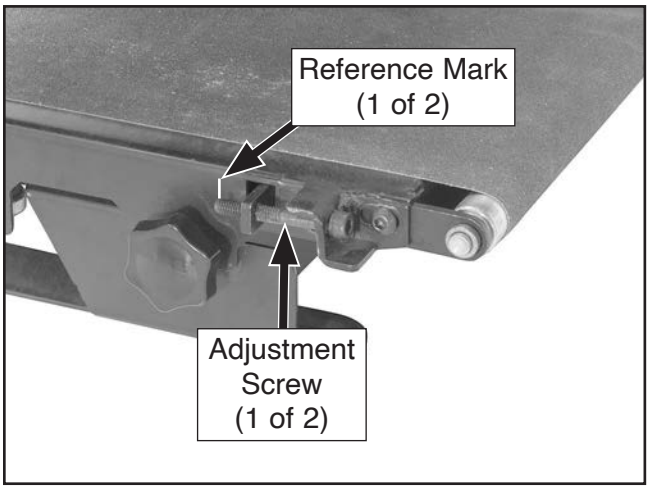


Figure 34. Reference mark location (left side shown).

2. Raise sanding drum as high as it will go.

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

   — If belt slips on rollers, rotate both roller adjustment screws (see **Figure 35**) evenly counterclockwise to increase tension.

   — If belt tracks toward right, rotate right roller adjustment screw (see **Figure 35**) counterclockwise to move belt left.

   — If belt tracks toward left, rotate left roller adjustment screw (see **Figure 35**) counterclockwise to move belt right.

   Note: *If roller does not move, (4) lock nuts on button head cap screws shown in **Figure 35** may need to be loosened.*

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

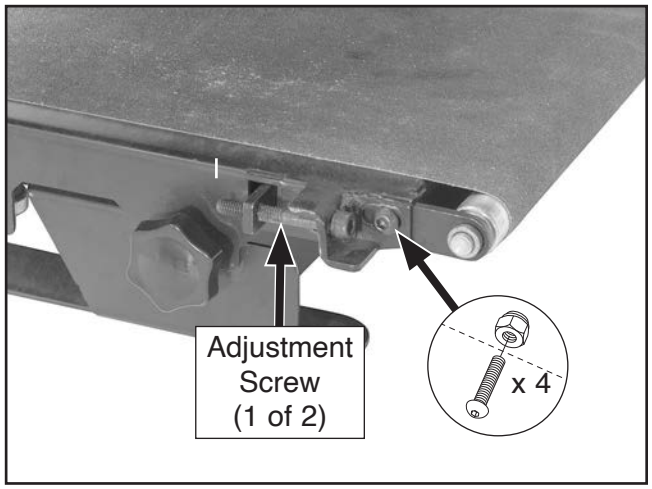


Figure 35. Conveyor belt adjustment components (left side shown).

NOTICE

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

Replacing Conveyor Belt

Replacing the conveyor belt is a relatively simple process, but it will require tensioning and tracking once the new conveyor belt is installed.

Items Needed	**Qty**
Pencil or Tape	1
Hex Wrenches 4, 5, 6mm	1 Ea.
Wrench or Socket 10mm	1
Cleaner/Degreaser	As Needed
Disposable Rags	As Needed
Replacement Conveyor Belt (P0404249)	1 Ea.

To replace conveyor belt:

1. DISCONNECT MACHINE FROM POWER!

2. Raise sanding drum as high as it will go.

3. Use pencil or tape to make reference mark on each side of conveyor table where end of adjustment screws are positioned (see **Figure 36**). These reference marks will provide a visual aid in keeping track of adjustments.

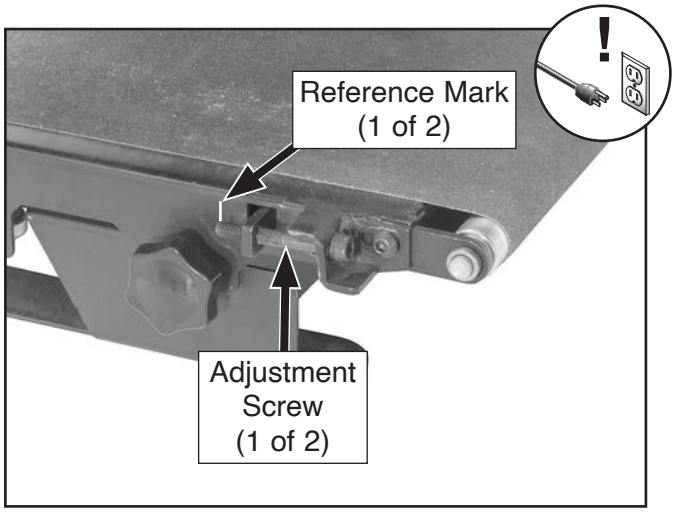


Figure 36. Location of adjustment screw reference mark (left side shown).

4. Rotate (2) adjustment screws (see **Figure 37**) counterclockwise to slide front roller as far back is it will go.

   Note: *If roller does not move, (4) lock nuts on button head cap screws shown in **Figure 37** may need to be loosened.*

5. Remove lock knobs and flat washers shown in **Figure 37**.

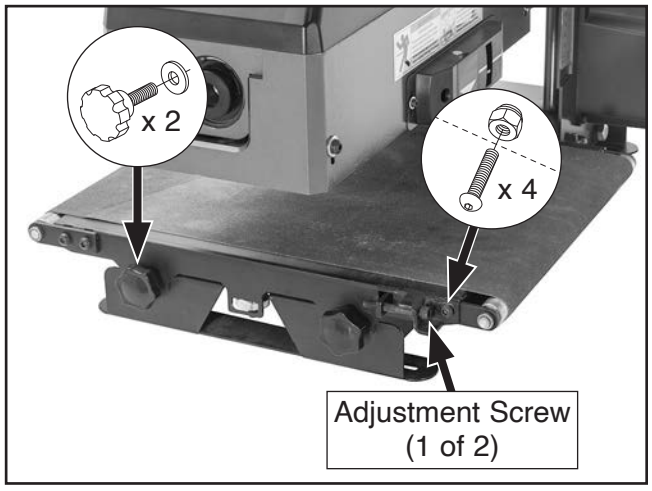


Figure 37. Location of left table adjustment components.

6. Remove (2) cap screws, lock washers, and flat washers shown in **Figure 38**, then lift conveyor table out from under drum.

Figure 38. Location of conveyor table cap screws and washers.

7. Slide conveyor belt off of table (see **Figure 39**).

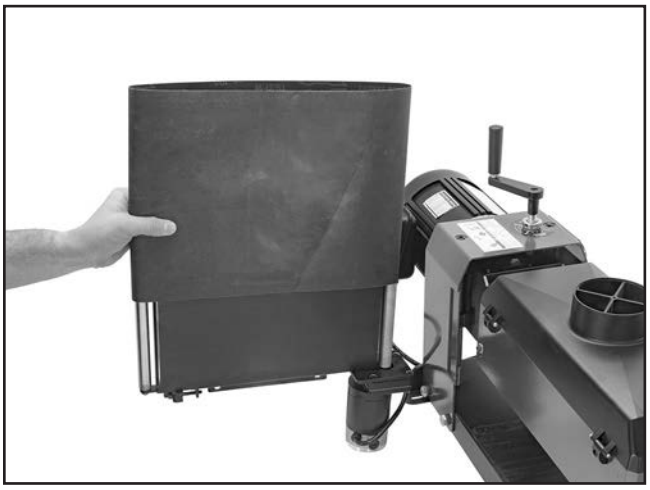


Figure 39. Sliding conveyor belt off of table.

8. Clean table and rollers, then install new conveyor belt, centering it on table and rollers.

   Note: *If conveyor belt has directional arrows on backing (see **Figure 40**), install belt with arrow facing rear of machine from top of table.*

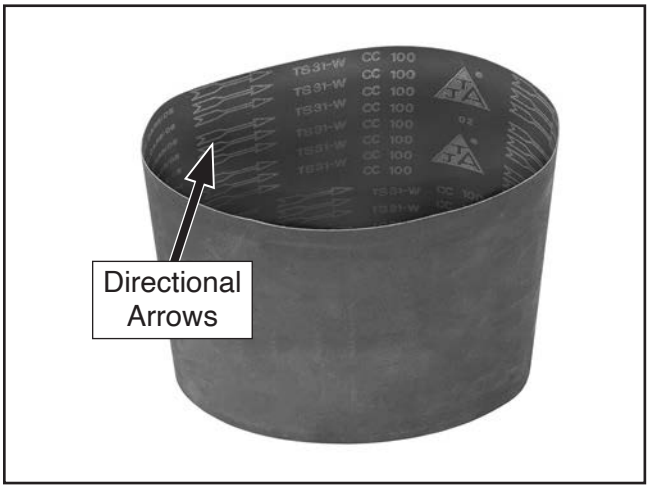


Figure 40. Example of conveyor belt directional arrows.

9. Place table back under drum, aligning table adjustment nut (see **Figure 41**), with slot in table, then secure with fasteners removed in **Step 6**.

10. Install table lock knobs and flat washers (see **Figure 41**).

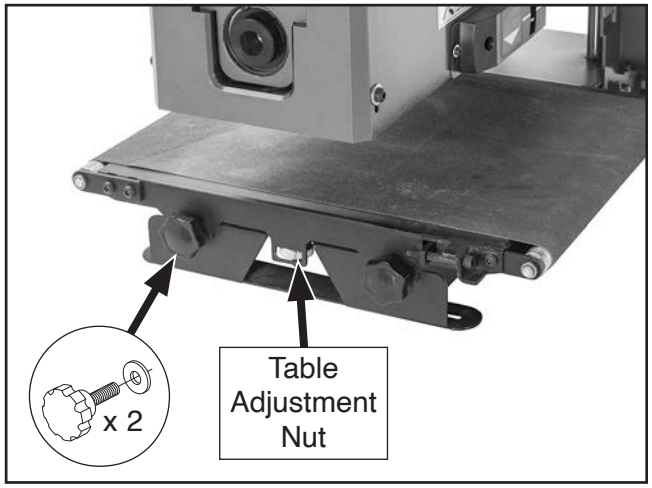


Figure 41. Table slot aligned with table adjustment nut.

11. Rotate (2) adjustment screws clockwise until end of screws are aligned with marks made in **Step 3**.

12. Refer to **Tracking & Tensioning Conveyor Belt** on **Page 31** to make adjustments for new belt.

Making Gauge Blocks

The blocks described below are required to complete the alignment procedures in the following service sections.

Note: ***Steps 1–2*** *below can be skipped, but having two gauge blocks of equal height is critical to the accuracy of the adjustments.*

Items Needed	**Qty**
2x3 (32"+ Length)	1
Miter Saw or Circular Saw	1
Jointer	1
Table Saw	1

To make gauge blocks:

1. Edge joint concave edge of 2x3 flat on jointer, as shown in **Figure 42**.

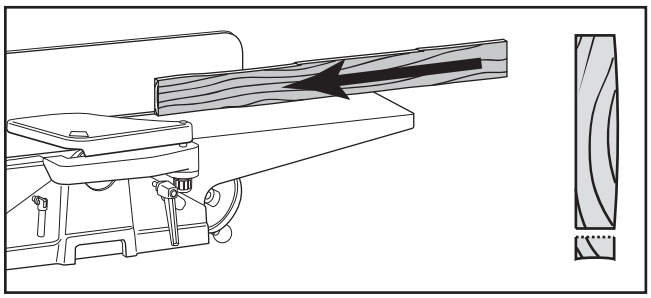


Figure 42. Edge jointing on jointer.

2. Place jointed edge of 2x3 against table saw fence and rip cut just enough off opposite side to square up two edges of 2x3, as shown in **Figure 43**.

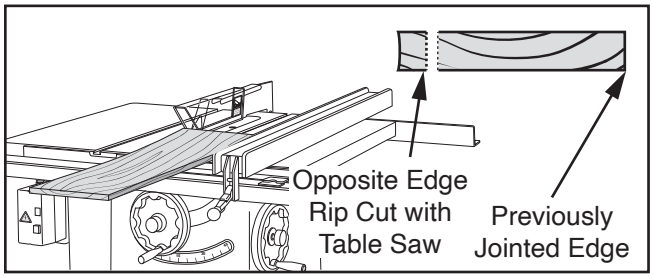


Figure 43. Rip cutting on table saw.

3. Cut 2x3 into two even pieces to make two wood gauge blocks that are at least 16" long.

Aligning Table to Sanding Drum

Aligning the conveyor table parallel to the sanding drum (see **Figure 44**) is critical for sanding accuracy. Care should be taken to make the tolerances as close as possible (within about 0.010" from one side to the other) when adjusting the conveyor table.

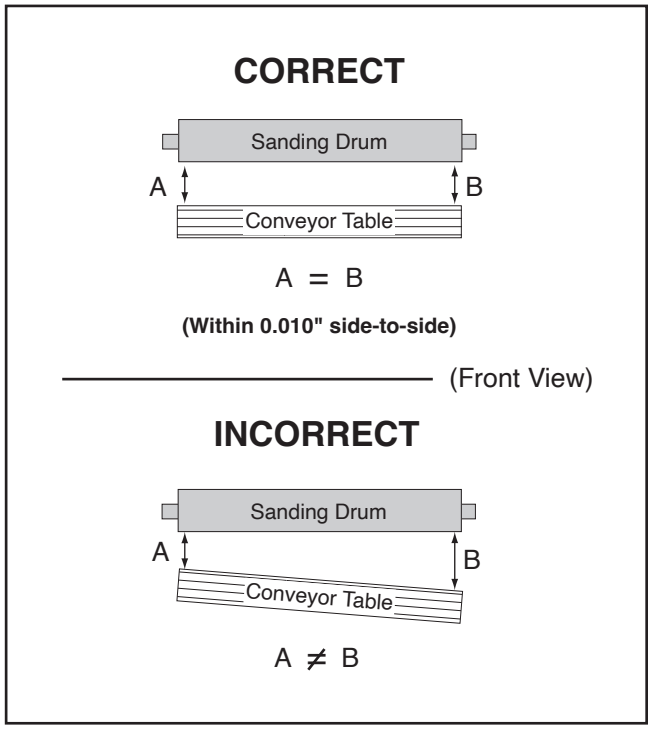


Figure 44. Conveyor table alignment to sanding drum.

Items Needed	Qty
Gauge Blocks 2" x 3" x 16"	1
Feeler Gauge Set	1

To align table to sanding drum:

1. DISCONNECT MACHINE FROM POWER!

2. Open dust hood and remove sandpaper from drum.

3. Place gauge blocks under drum (see **Figure 45**), then lower drum until gauge blocks just touch drum.

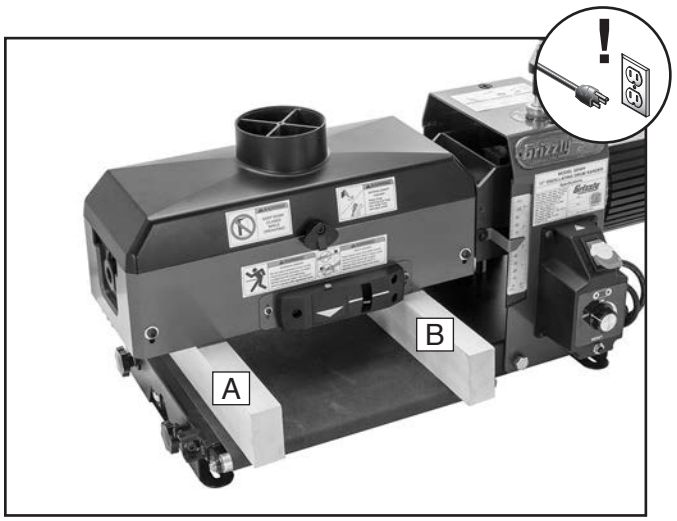


Figure 45. Example of gauge blocks placed under drum.

4. Raise drum one full revolution of height crank.

5. Starting at board A (see **Figure 45**), find largest size feeler gauge that can pass between drum and gauge block. Feeler gauge should slide with moderate resistance, without forcing drum to roll.

6. Repeat **Step 5** at board B.

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

   — If difference between A and B is *more than* 0.010", proceed to **Step 7**.

7. Loosen table lock knobs shown in **Figure 46**.

8. Adjust nut shown in **Figure 46** to raise or lower left side of table, repeating **Steps 5–6** to test adjustment until difference between sides is 0.010" or less.

   — To raise left side of table, turn nut counter-clockwise.

   — To lower left side of table, turn nut clockwise.

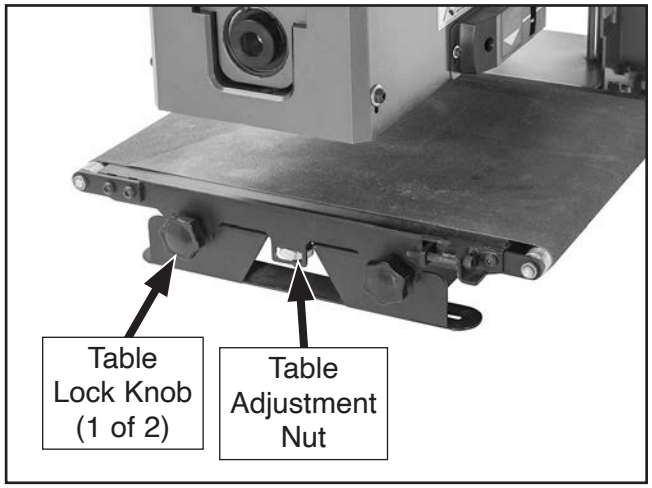


Figure 46. Location of table lock knobs and adjustment nut.

9. Tighten table lock knobs.

10. Remove gauge blocks.

11. Install sandpaper, then close and secure dust hood.

Adjusting Pressure Rollers

Two spring-loaded pressure rollers help maintain consistent pressure on the workpiece as it passes the sanding drum. The pressure rollers have been set correctly at the factory. DO NOT adjust the pressure rollers unless absolutely necessary.

When properly positioned, the pressure rollers should be approximately 0.004" lower than the sanding drum.

Adjusting the pressure rollers is a fine balance between too much pressure and not enough. Too much pressure can overload the motor or cause snipe. Not enough pressure may allow the workpiece to kick out of the sander toward the operator.

Items Needed	**Qty**
Gauge Blocks 2" x 3" x 16"	1
Feeler Gauge Set	1
Phillips Head Screwdriver #2	1

To adjust pressure rollers:

1. DISCONNECT MACHINE FROM POWER!

2. Ensure conveyor table is properly aligned to sanding drum (refer to **Aligning Table to Sanding Drum** beginning on **Page 35**).

3. Open dust hood.

4. Place gauge blocks under drum (see **Figure 47**).

Figure 47. Example of gauge blocks placed under drum.

5. Lower drum until gauge blocks just touch rear pressure roller.

6. Find largest size feeler gauge that can pass between sanding drum and gauge block. Feeler gauge should slide with moderate resistance, without forcing drum to roll.

   — If gap is 0.004" (0.1mm) or less at each gauge block, then no adjustment of rear pressure roller is necessary. Proceed to **Step 8** to check front pressure roller.

   — If gap is *more than* 0.004" (0.1mm) at either gauge block, then rear pressure roller must be adjusted. Proceed to **Step 7**.

7. Adjust rear pressure roller adjustment screws (see **Figure 48**), repeating **Steps 5–6** to test adjustment until rear pressure roller is 0.004" (0.1mm) below drum on either side.

   — To lower side of pressure roller, turn screws clockwise.

   — To raise side of pressure roller, turn screws counterclockwise.

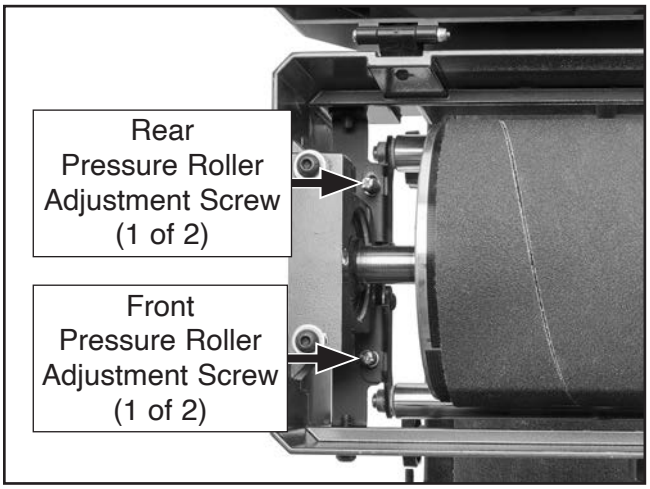


Figure 48. Location of pressure roller adjustment screws (left side shown).

8. Raise and then lower drum until gauge blocks just touch front pressure roller.

9. Find largest size feeler gauge that can pass between sanding drum and gauge block.

   — If gap is 0.004" (0.1mm) or less at each gauge block, then no adjustment of front pressure roller is necessary. Proceed to **Step 11**.

   — If gap is *more than* 0.004" (0.1mm) at either gauge block, then front pressure roller must be adjusted. Proceed to **Step 10**.

10. Adjust front pressure roller adjustment screws (see **Figure 48**), repeating **Steps 8–9** to test adjustment until front pressure roller is 0.004" (0.1mm) below drum on either side.

    — To lower side of pressure roller, turn screws clockwise.

    — To raise side of pressure roller, turn screws counterclockwise.

11. Remove gauge blocks.

12. Close and secure dust hood.

SECTION 7: 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.

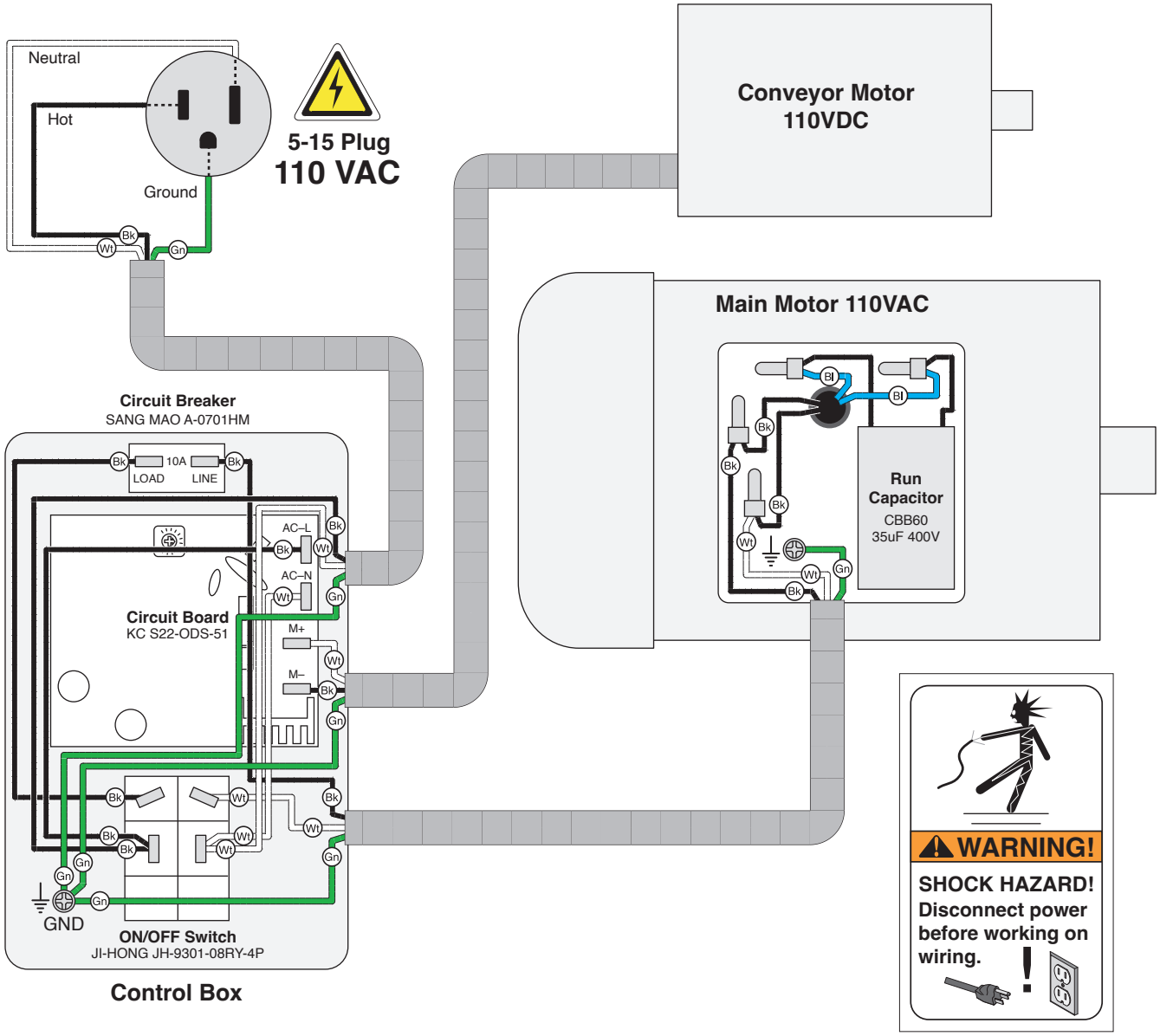
NOTICE

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



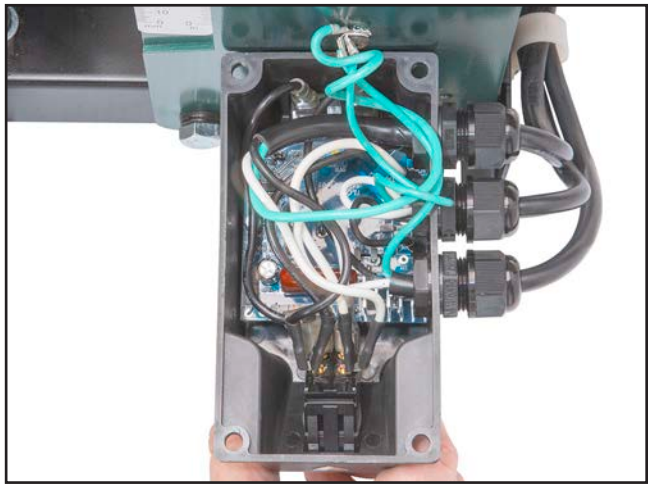


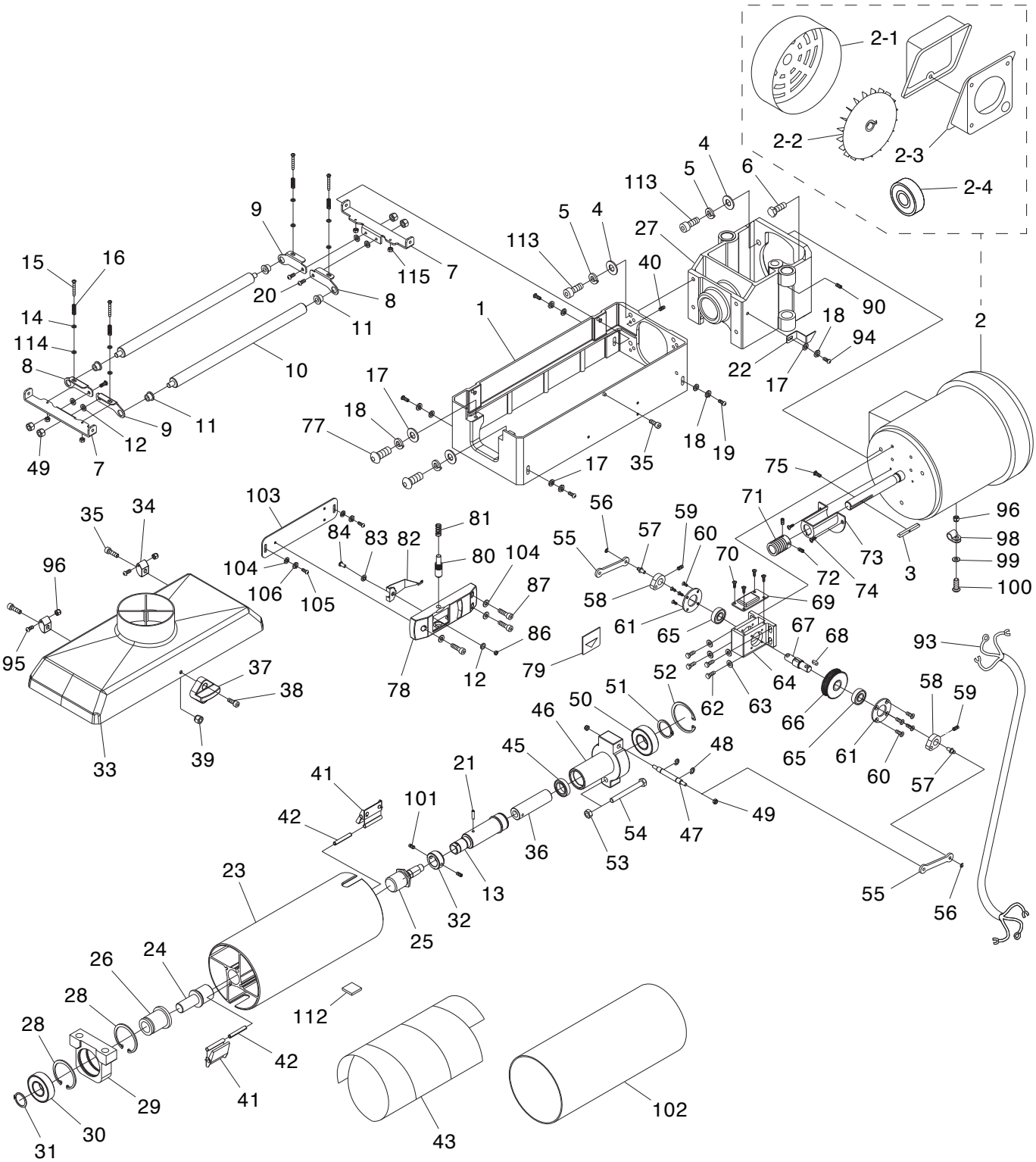
Figure 49. Control box wiring.

Figure 50. Main motor wiring.

SECTION 8: 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.

Drum

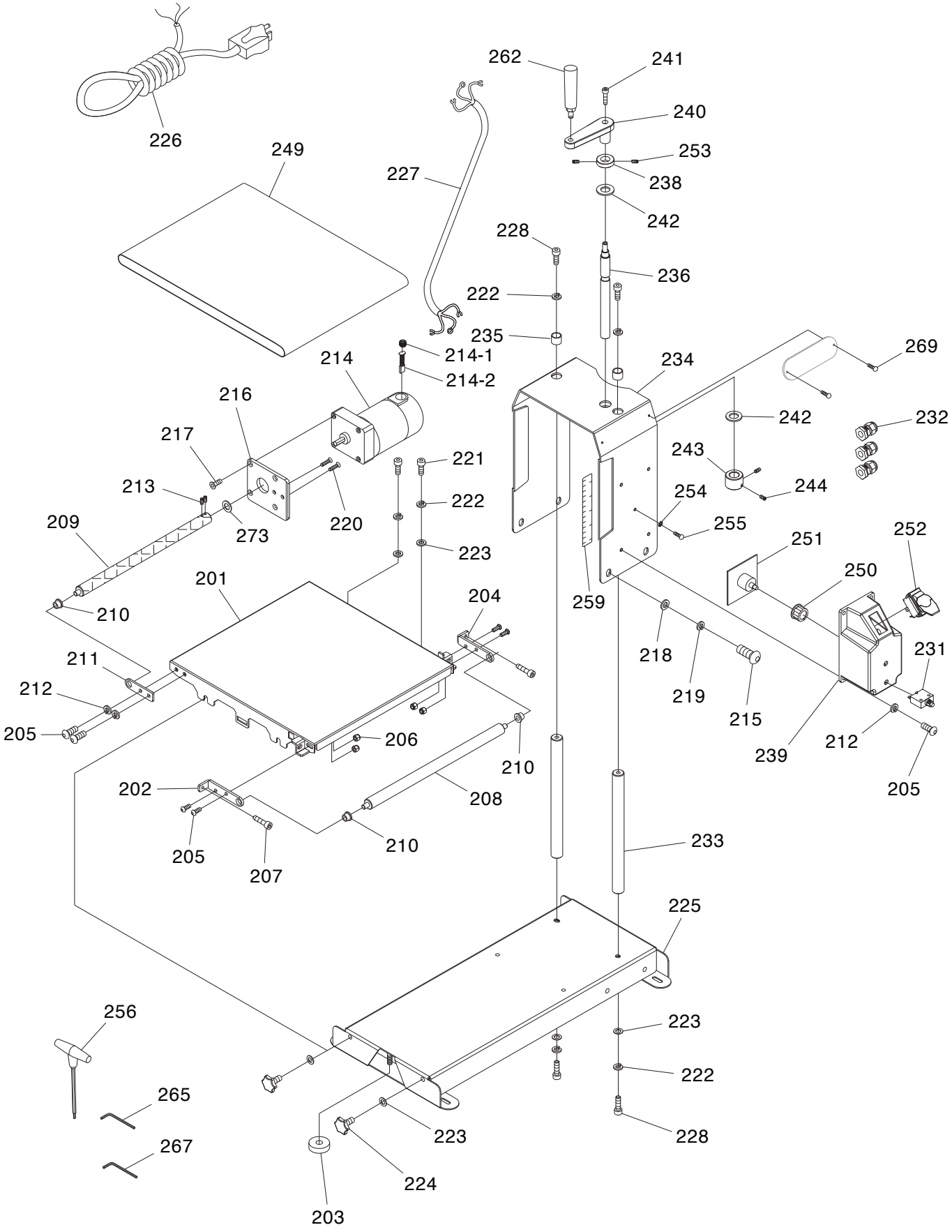


Drum Parts List

REF	PART #	DESCRIPTION
1	P0404001	HEADSTOCK
2	P0404002	MOTOR 1HP 110V 1-PH
2-1	P0404002-1	MOTOR FAN COVER
2-2	P0404002-2	MOTOR FAN
2-3	P0404002-3	MOTOR JUNCTION BOX
2-4	P0404002-4	BALL BEARING 6203ZZ
3	P0404003	KEY W/HOLE 5 X 5 X 50 RE
4	P0404004	FLAT WASHER 8MM
5	P0404005	LOCK WASHER 8MM
6	P0404006	HEX BOLT M8-1.25 X 30
7	P0404007	PRESSURE ROLLER BRACKET
8	P0404008	ROLLER MOUNT FRONT RIGHT
9	P0404009	ROLLER MOUNT FRONT LEFT
10	P0404010	PRESSURE ROLLER
11	P0404011	FLANGED BUSHING
12	P0404012	FENDER WASHER 5MM
13	P0404013	ECCENTRIC SHAFT
14	P0404014	FLAT WASHER 6MM
15	P0404015	PHLP HD SCR M6-1 X 40
16	P0404016	COMPRESSION SPRING 1 X 8.8 X 19.5
17	P0404017	FLAT WASHER 6MM
18	P0404018	LOCK WASHER 6MM
19	P0404019	BUTTON HD CAP SCR M6-1 X 20
20	P0404020	BUTTON HD CAP SCR M5-.8 X 10
21	P0404021	ROLL PIN 4 X 28
22	P0404022	SCALE INDICATOR
23	P0404023	DRUM
24	P0404024	SPINDLE LEFT
25	P0404025	SPINDLE RIGHT
26	P0404026	FLANGED BUSHING
27	P0404027	DRUM MOUNT
28	P0404028	INT RETAINING RING 52MM
29	P0404029	BEARING HOUSING
30	P0404030	BALL BEARING 6205LLB
31	P0404031	EXT RETAINING RING 25MM
32	P0404032	LOCK COLLAR 20.1 X 31 X 14MM
33	P0404033	DUST HOOD
34	P0404034	HINGE
35	P0404035	CAP SCREW M6-1 X 12
36	P0404036	BUSHING 16 X 22.5 X 80MM
37	P0404037	LATCH LOCK
38	P0404038	CAP SCREW M6-1 X 16
39	P0404039	LOCK NUT M6-1
40	P0404040	SET SCREW M6-1 X 6
41	P0404041	SANDPAPER CLIP
42	P0404042	ROLL PIN 6 X 10
43	P0404043	SANDING ROLL 3" X 50' 120-GRIT
45	P0404045	BALL BEARING 6804LLB
46	P0404046	ECCENTRIC BASE
47	P0404047	CONNECTING ROD AXLE
48	P0404048	E-CLIP 6MM
49	P0404049	LOCK NUT M5-.8
50	P0404050	BALL BEARING 6006LLB

REF	PART #	DESCRIPTION
51	P0404051	EXT RETAINING RING 30MM
52	P0404052	INT RETAINING RING 55MM
53	P0404053	HEX NUT M8-1.25
54	P0404054	HEX BOLT M8-1.25 X 75
55	P0404055	CONNECTING ROD
56	P0404056	E-CLIP 4MM
57	P0404057	CRANK AXLE
58	P0404058	CRANK
59	P0404059	SET SCREW M5-.8 X 8
60	P0404060	FLAT HD CAP SCR M4-.7 X 6
61	P0404061	BEARING COVER
62	P0404062	HEX BOLT M6-1 X 16
63	P0404063	FLAT WASHER 6MM
64	P0404064	WORM WHEEL BRACKET
65	P0404065	BALL BEARING 6001-2RS
66	P0404066	WORM WHEEL
67	P0404067	WORM WHEEL SHAFT
68	P0404068	KEY 4 X 4 X 10 RE
69	P0404069	WORM WHEEL COVER
70	P0404070	PHLP HD SCR M4-.7 X 6
71	P0404071	WORM GEAR
72	P0404072	SET SCREW M6-1 X 5
73	P0404073	WORM GEAR COVER
74	P0404074	PHLP HD SCR M4-.7 X 8
75	P0404075	PHLP HD SCR M4-.7 X 12
77	P0404077	BUTTON HD CAP SCR M6-1 X 30
78	P0404078	DEPTH GAUGE
79	P0404079	ARROW PLATE
80	P0404080	DEPTH GAUGE SHAFT
81	P0404081	COMPRESSION SPRING 0.6 X 9.5 X 19
82	P0404082	DEPTH INDICATOR
83	P0404083	SPACER 4.2 X 11 X 2.6MM
84	P0404084	BUTTON HD CAP SCR M4-.7 X 12
86	P0404086	LOCK NUT M4-.7
87	P0404087	CAP SCREW M4-.7 X 10
90	P0404090	SET SCREW M6-1 X 6
93	P0404093	MAIN MOTOR CORD 14G 3W 24"
94	P0404094	BUTTON HD CAP SCR M6-1 X 10
95	P0404095	BUTTON HD CAP SCR M3-.5 X 40
96	P0404096	LOCK NUT M3-.5
98	P0404098	CORD CLAMP
99	P0404099	FLAT WASHER 3MM
100	P0404100	BUTTON HD CAP SCR M3-.5 X 10
101	P0404101	SET SCREW M6-1 X 6
102	P0404102	HOOK-AND-LOOP TAPE
103	P0404103	DEPTH GAUGE REAR COVER
104	P0404104	FLAT WASHER 4MM
105	P0404105	BUTTON HD CAP SCR M4-.7 X 10
106	P0404106	LOCK WASHER 4MM
112	P0404112	BALANCING WEIGHT
113	P0404113	CAP SCREW M8-1.25 X 30
114	P0404114	FLAT WASHER 6MM NYLON
115	P0404115	HEX NUT M5-.8

Conveyor

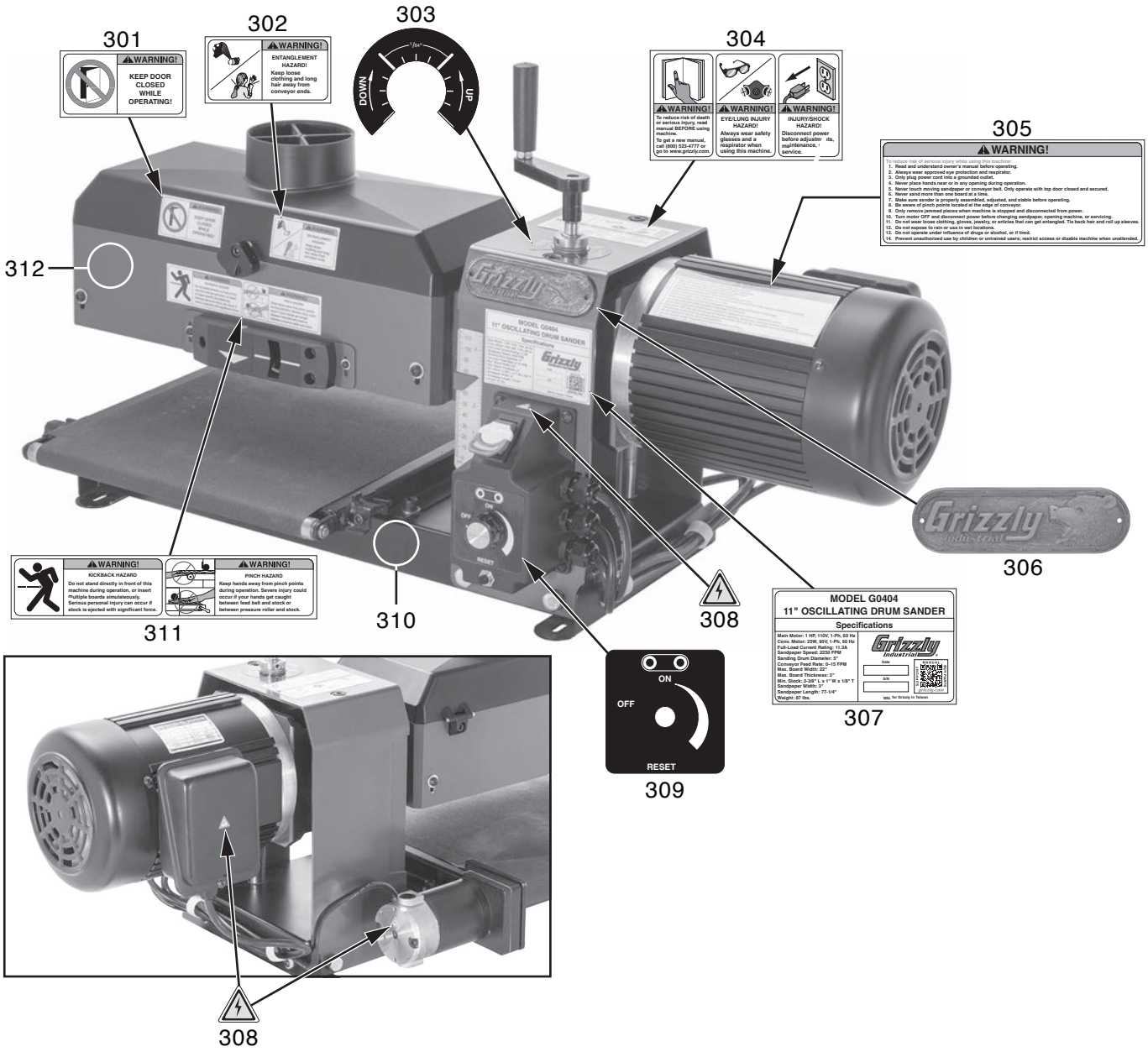


Conveyor Parts List

REF	PART #	DESCRIPTION
201	P0404201	CONVEYOR TABLE
202	P0404202	TENSION ROLLER BRACKET LEFT
203	P0404203	THUMB NUT M8-1.25
204	P0404204	TENSION ROLLER BRACKET RIGHT
205	P0404205	BUTTON HD CAP SCR M6-1 X 20
206	P0404206	LOCK NUT M6-1
207	P0404207	CAP SCREW M6-1 X 45
208	P0404208	IDLER ROLLER
209	P0404209	DRIVE ROLLER
210	P0404210	ROLLER BUSHING
211	P0404211	ROLLER BRACKET
212	P0404212	LOCK WASHER 6MM
213	P0404213	SET SCREW M5-.8 X 5
214	P0404214	MOTOR W/GEARBOX 25W 110VDC
214-1	P0404214-1	BRUSH CAP
214-2	P0404214-2	CARBON BRUSH (2-PC SET)
215	P0404215	BUTTON HD CAP SCR M10-1.5 X 20
216	P0404216	MOTOR MOUNT
217	P0404217	FLAT HD CAP SCR 10-32 X 1/2
218	P0404218	FLAT WASHER 10MM
219	P0404219	LOCK WASHER 10MM
220	P0404220	FLAT HD CAP SCR M6-1 X 35
221	P0404221	CAP SCREW M8-1.25 X 16
222	P0404222	LOCK WASHER 8MM
223	P0404223	FLAT WASHER 8MM
224	P0404224	KNOB BOLT M8-1.25 X 16
225	P0404225	MACHINE BASE
226	P0404226	POWER CORD 14G 3W 72" 5-15
227	P0404227	CONVEYOR MOTOR CORD 14G 3W 24"

REF	PART #	DESCRIPTION
228	P0404228	CAP SCREW M8-1.25 X 20
231	P0404231	CIRCUIT BREAKER SANG MAO A-0701HM
232	P0404232	STRAIN RELIEF M16-1.5
233	P0404233	GUIDE BAR
234	P0404234	MAIN COVER
235	P0404235	SPACER 8.5 X 17 X 13.7MM
236	P0404236	DRUM HEIGHT LEADSCREW
238	P0404238	LOCK COLLAR 16 X 30 X 7.6MM
239	P0404239	CONTROL BOX
240	P0404240	DRUM HEIGHT CRANK
241	P0404241	CAP SCREW M5-.8 X 25
242	P0404242	FLAT WASHER 17 X 28 X 3MM PLASTIC
243	P0404243	LOCK COLLAR 16 X 30 X 25MM
244	P0404244	SET SCREW M6-1 X 8
249	P0404249	CONVEYOR BELT
250	P0404250	SPEED DIAL
251	P0404251	CIRCUIT BOARD W/POTENTIOMETER B20K
252	P0404252	ON/OFF SWITCH JI-HONG JH-9301-08RY-4P
253	P0404253	SET SCREW M4-.7 X 12
254	P0404254	EXT TOOTH WASHER 5MM
255	P0404255	PHLP HD SCR M5-.8 X 10
256	P0404256	T-HANDLE HEX WRENCH 2.5MM
259	P0404259	THICKNESS SCALE
262	P0404262	REVOLVING HANDLE 3/8-16 X 9/16
265	P0404265	HEX WRENCH 4MM
267	P0404267	HEX WRENCH 5MM
269	P0404269	PHLP HD SCR M3-.5 X 6
273	P0404273	FLAT WASHER 8 X 15 X 0.6MM

Labels & Cosmetics



REF	PART #	DESCRIPTION
301	P0404301	KEEP DOOR CLOSED LABEL
302	P0404302	ENTANGLEMENT HAZARD LABEL
303	P0404303	HEIGHT CRANK LABEL
304	P0404304	COMBO WARNING LABEL
305	P0404305	MACHINE WARNING LABEL
306	P0404306	GRIZZLY OBLONG NAMEPLATE

REF	PART #	DESCRIPTION
307	P0404307	MACHINE ID LABEL
308	P0404308	ELECTRICITY LABEL
309	P0404309	CONTROL PANEL LABEL
310	P0404310	TOUCH-UP PAINT, GLOSSY BLACK
311	P0404311	KICKBACK/PINCH HAZARD LABEL
312	P0404312	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

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