



MODEL G0407
18" 5 HP EXTREME SERIES
WIDE BELT SANDER
OWNER'S MANUAL
(For models manufactured since 01/26)



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#CS23828 PRINTED IN TAIWAN

V1.01.26

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



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

WARNING

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

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

Manual Accuracy

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

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

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

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

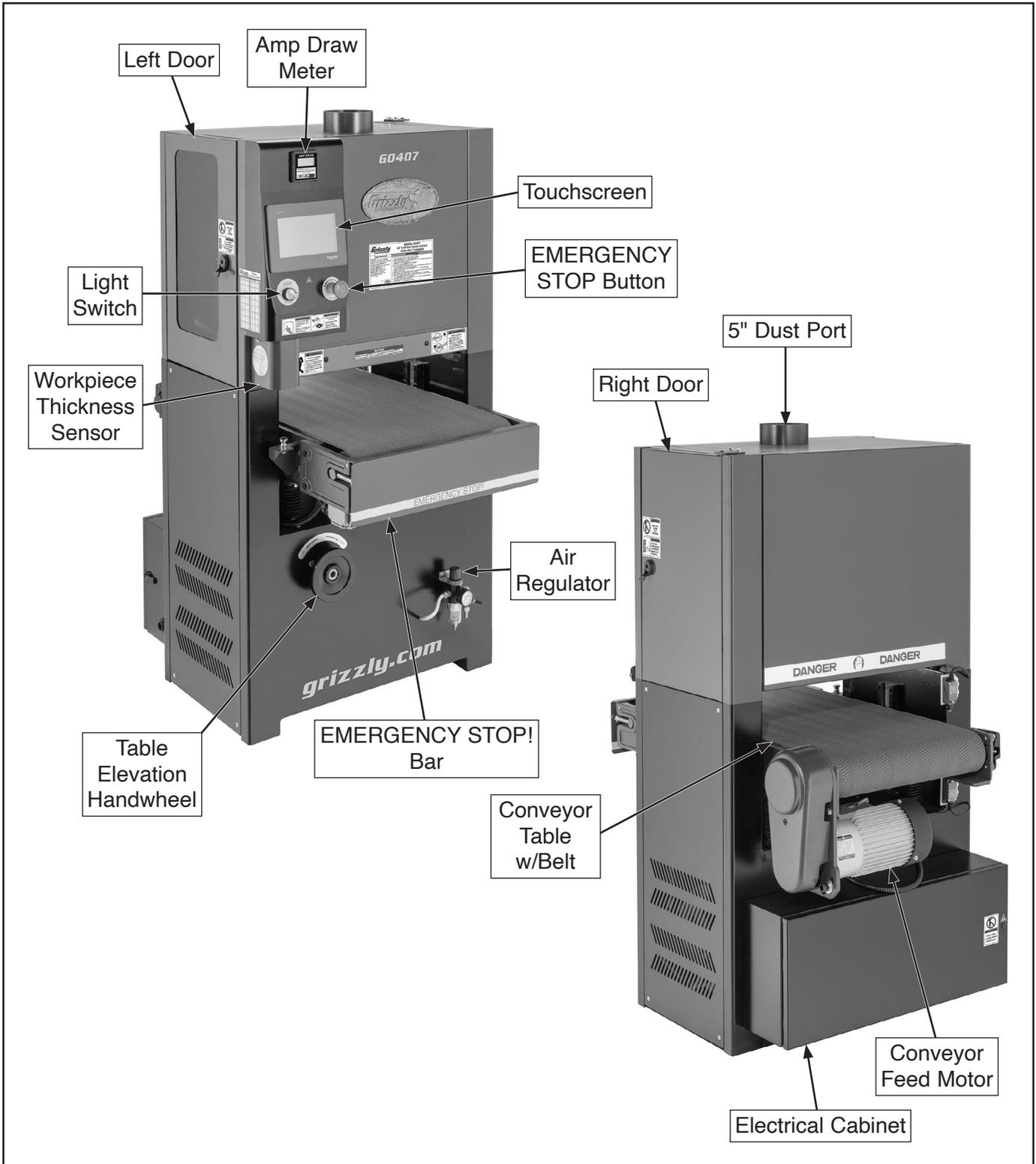
		MODEL GXXXX MACHINE NAME
SPECIFICATIONS		 WARNING!
Motor:	To reduce risk of serious injury when using this machine:	
Specification:	Manual before operation.	
Specification:	Safety glasses and respirator.	
Specification:	Correctly adjusted/setup and	
Weight:	power is connected to grounded circuit before starting.	
	Manufacture Date	4. Make sure the motor has stopped and disconnect
		power before adjustments, maintenance, or service.
		5. DO NOT expose to rain or dampness.
		6. DO NOT modify this machine in any way.
		7.
		8.
	Serial Number	9. ended.
		10. Maintain machine carefully to prevent accidents.

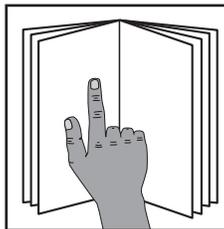
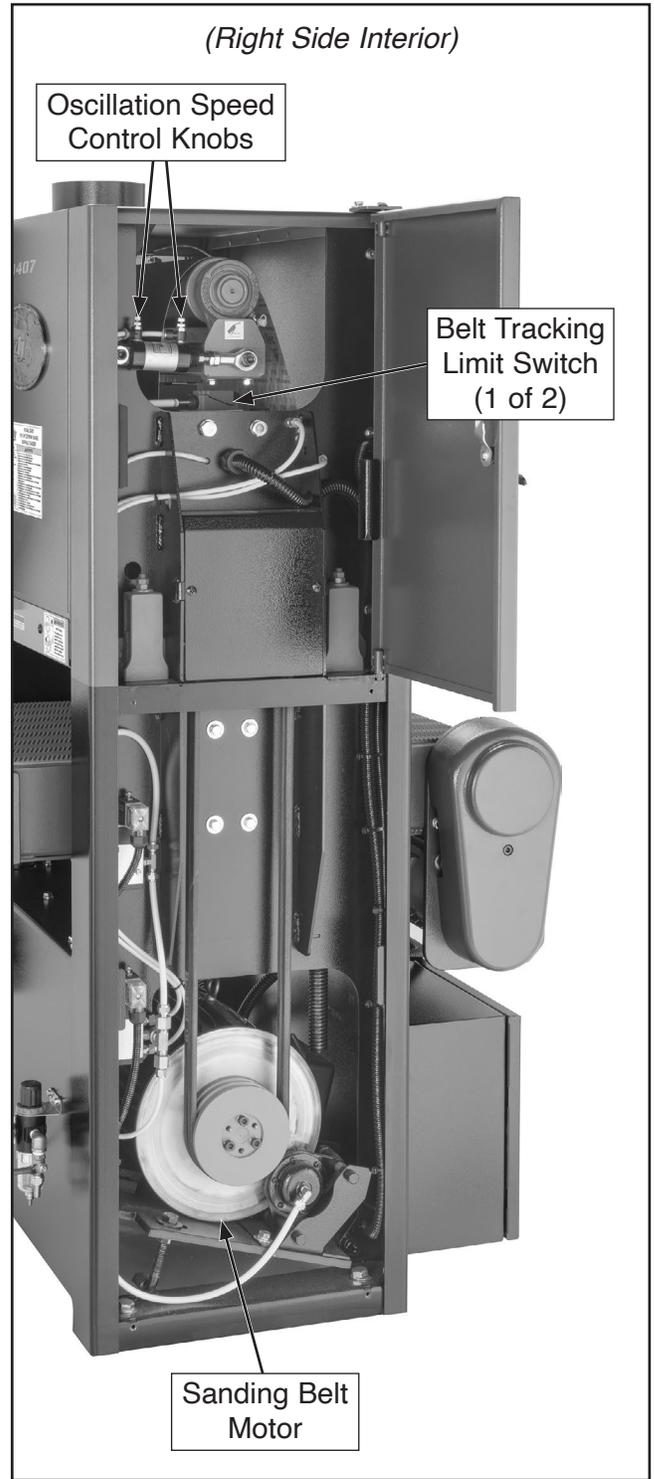
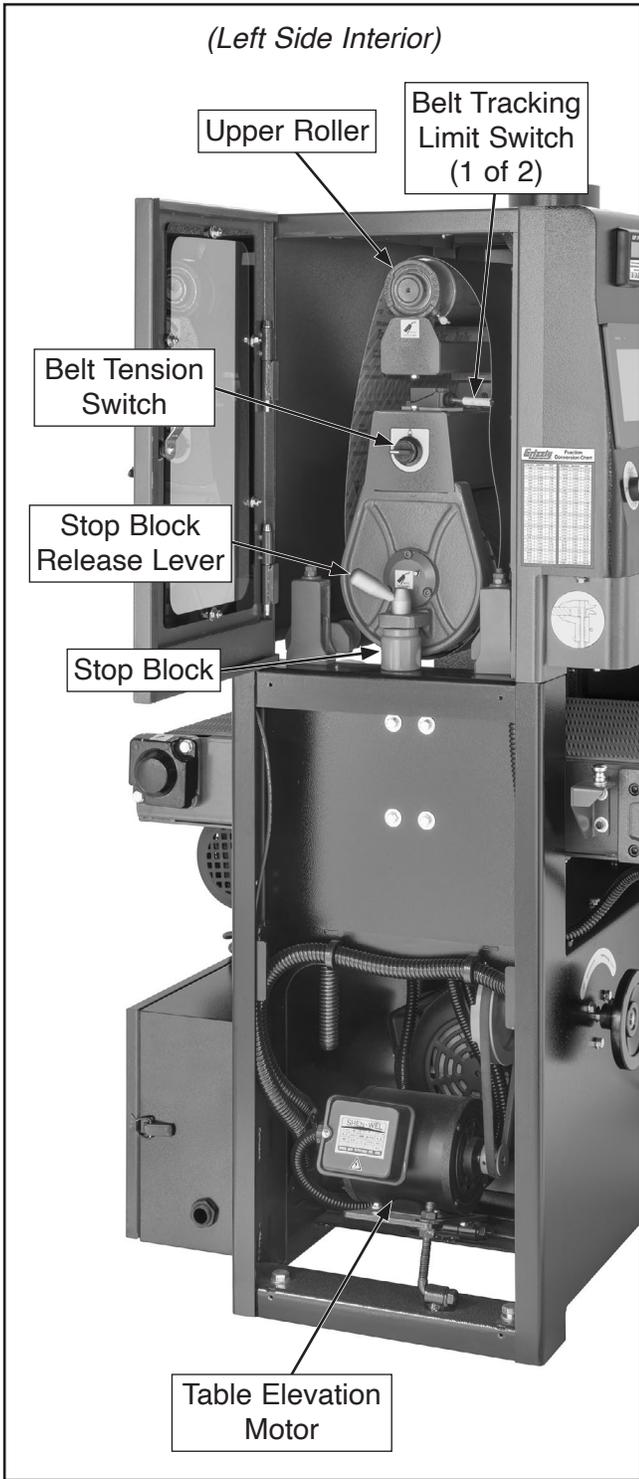
Manufactured for Grizzly in Taiwan



Identification

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





! WARNING

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



Controls & Components



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

Control Panel

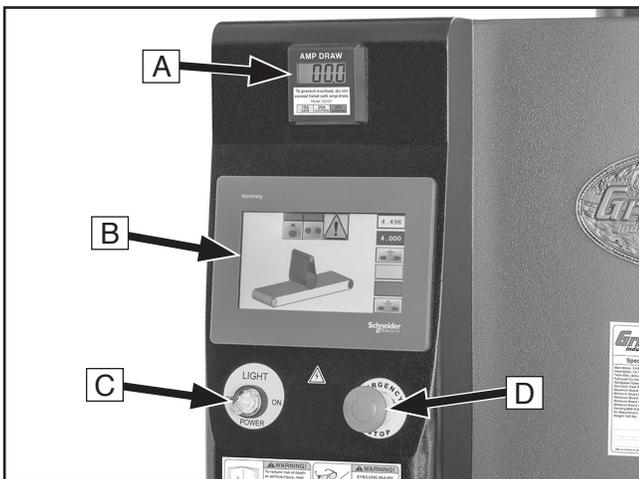


Figure 1. Control panel components.

- A. Amp Draw Meter:** Indicates amp load of sanding belt motor during sanding operations. Used to determine maximum depth of cut sander can handle.
- B. Touchscreen:** Controls sanding belt, conveyor belt, and motorized table elevation.
- C. Light Switch:** Turns machine interior light **ON** or **OFF**.
- D. EMERGENCY STOP Button:** Turns all machine functions **OFF** when pressed; engages emergency brake to stop rotation of sanding drum. Twist clockwise to reset.

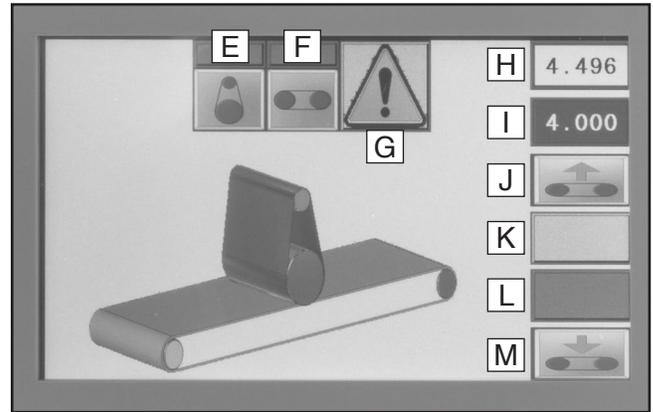


Figure 2. Touchscreen components.

- E. Sanding Belt ON/OFF Button:** Turns sanding belt motor **ON** or **OFF**.
- F. Conveyor Belt ON/OFF Button:** Turns conveyor feed motor **ON** or **OFF**.
- G. Fault Indicator:** Illuminates red when machine is engaged in a safety fault. When engaged, motors will stop, machine interior lights will turn red, active fault log screen will appear on touchscreen, and table will automatically lower to prevent machine damage.
- H. Thickness Display:** Shows table position in relation to drum (i.e., workpiece thickness).
- I. Adjust Thickness Value:** Shows desired table position (i.e., workpiece thickness). Table will move to entered value after 3–5 seconds.
- J. Table Up Button:** Decreases adjust thickness value by 0.005" (0.125mm) when pressed; continuously moves table up when held.
- K. Cleared Fault Button:** When safety fault has been engaged and table has automatically lowered, button will return table to last entered value.
- L. Calibration Button:** Calibrates thickness display to same value as adjust thickness value when held.
- M. Table Down Button:** Increases adjust thickness value by 0.005" (0.125mm) when pressed; continuously moves table down when held.



Sanding Belt

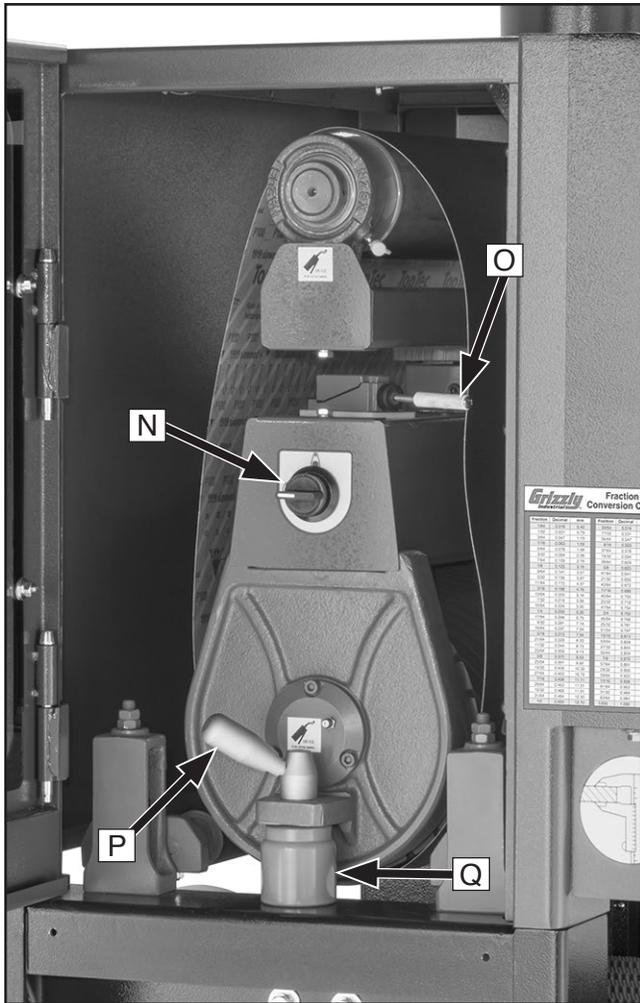


Figure 3. Left sanding belt components.

- N. Belt Tension Switch:** Engages or disengages sanding belt tension.
- O. Belt Tracking Limit Switch (1 of 2):** Stops sanding drum motor if sanding belt tracking is incorrect.
- P. Stop Block Release Lever:** Unlocks to remove stop block.
- Q. Stop Block:** Prevents sanding belt from oscillating off of drum and roller.

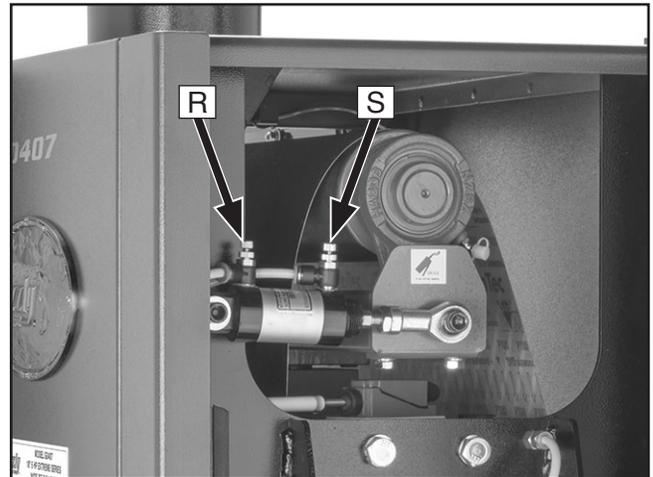


Figure 4. Right sanding belt components.

- R. Left Oscillation Speed Control Knob:** Controls oscillation speed of belt moving left.
- S. Right Oscillation Speed Control Knob:** Controls oscillation speed of belt moving right.

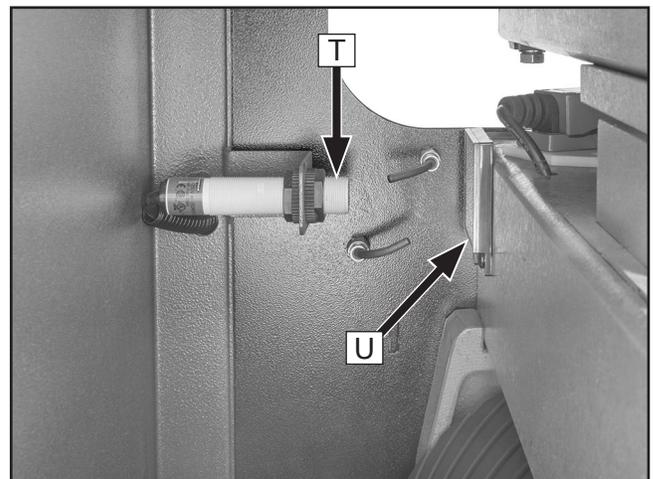


Figure 5. Electronic eye and mirror.

- T. Electronic Eye:** Automatically adjusts sanding belt oscillation. When sanding belt passes between eye and mirror, eye rotates roller.
- U. Mirror:** Receives signal from electronic eye.



Conveyor Table

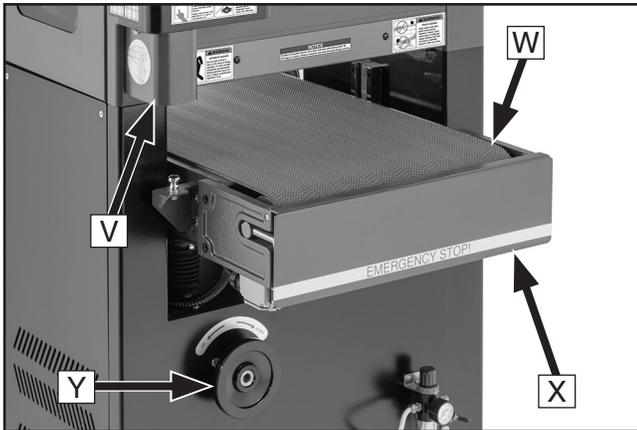


Figure 6. Front conveyor table components.

- V. Workpiece Thickness Sensor:** Stops table from raising past workpiece thickness. To function, workpiece must be positioned under sensor.

Note: While sensor is engaged, all touch-screen table elevation controls will be disabled except for table down button. Remove workpiece or press and hold table down button to disengage sensor and enable other table controls.

- W. Conveyor Table w/Belt:** Supports and feeds workpiece during operations; can be raised or lowered according to workpiece thickness.
- X. EMERGENCY STOP! Bar:** Stops all machine functions when pressed; engages emergency brake to stop rotating drum.
- Y. Table Elevation Handwheel:** Manually raises and lowers conveyor table. Rotate clockwise to lower table; rotate counterclockwise to raise table. One full rotation moves table approximately 0.020" (0.5mm).

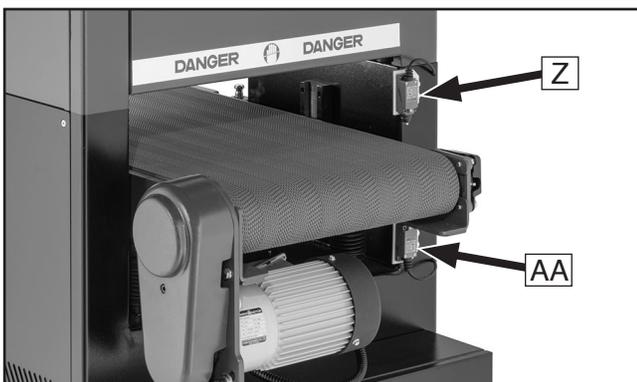


Figure 7. Rear conveyor table components.

- Z. Upper Table Elevation Limit Switch:** Stops control panel controls from raising table to prevent machine damage.

Note: While switch is engaged, all touch-screen table elevation controls will be disabled except for table down button. Press and hold table down button to disengage switch and enable other table controls.

- AA. Lower Table Elevation Limit Switch:** Stops control panel controls from lowering table to prevent machine damage.

Note: While switch is engaged, all touch-screen table elevation controls will be disabled except for table up button. Press and hold table up button to disengage switch and enable other table controls.

Air Supply

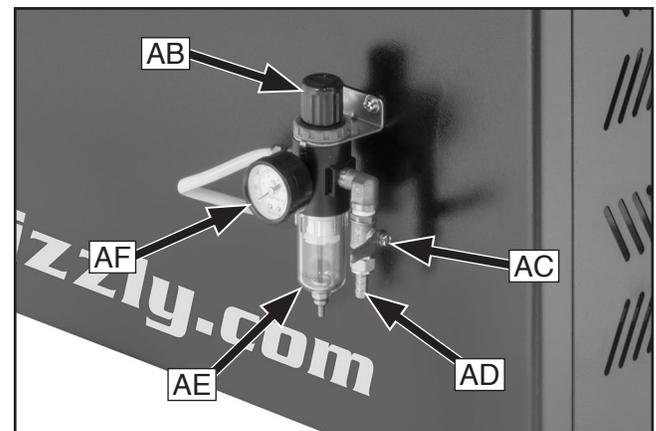


Figure 8. Air regulator components.

- AB. Air Regulator Knob:** Adjusts incoming air pressure. Lift knob and rotate clockwise to *increase* PSI; lift knob and rotate counterclockwise to *decrease* PSI.
- AC. Air Supply Valve:** Opens to pneumatically power sanding belt tracking and oscillation; closes to stop air from entering machine pneumatic system.
- AD. Air Inlet:** Connects to compressed air supply of 75 PSI with a 3/8" air hose.
- AE. Filter Trap:** Filters water and dirt from incoming air and collects it for draining.
- AF. Air Regulator Gauge:** Displays air pressure entering machine pneumatic system.





MACHINE DATA SHEET

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

MODEL G0407 18" 5 HP EXTREME SERIES WIDE BELT SANDER

Product Dimensions:

Weight..... 849 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 31-1/2 x 38 x 57 in.
Footprint (Length x Width)..... 29-1/2 x 16-1/2 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 993 lbs.
Length x Width x Height..... 40 x 33 x 63 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
Full-Load Current Rating..... 32.73A
Minimum Circuit Size..... 40A
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Switch Type..... Control Panel w/Magnetic Switch Protection

Motors:

Main

Horsepower..... 5 HP
Phase..... Single-Phase
Amps..... 30A
Speed..... 1720 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Belt
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... Internal

Feed

Horsepower..... 1/2 HP
Phase..... Single-Phase
Amps..... 2.73A
Speed..... 34 RPM
Type..... TEFC Induction
Power Transfer Chain
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... Internal

Table Elevation

Horsepower..... 1/3 HP
Phase..... Single-Phase
Amps..... 3A
Speed..... 1720 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Belt
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... Internal



Main Specifications:

Operation Information

Number of Sanding Heads.....	1
Maximum Board Width.....	17-1/2 in.
Minimum Board Width.....	2 in.
Maximum Board Thickness.....	6 in.
Minimum Board Thickness.....	1/8 in.
Minimum Board Length.....	10 in.
Sandpaper Speed.....	3500 FPM
Sanding Belt Oscillations per Minute.....	35 - 40 OPM
Sanding Belt Oscillation Stroke Length.....	3/16 - 5/8 in.
Conveyor Feed Rate.....	16.4, 23, 32.8 FPM
Sandpaper Length.....	48 in.
Sandpaper Width.....	18-1/2 in.

Drum Information

Infeed Sanding Drum Type.....	Spiral Grooved Rubber
Infeed Sanding Drum Size.....	8 in.
Shore Hardness (Durometer).....	70 Shore

Construction

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

Other Related Information

Floor To Table Height.....	26-3/4 - 32-3/4 in.
Belt Tracking.....	Pneumatic
Sanding Belt Tension.....	Pneumatic
Number of Pressure Rollers.....	4
Pressure Roller Type.....	Rubber
Pressure Roller Size.....	1-9/16 in.
Conveyor Table Length.....	35-1/2 in.
Conveyor Belt Length.....	70-7/8 in.
Conveyor Belt Width.....	18 in.
Belt Roller Size.....	3-1/2 in.
Number of Dust Ports.....	1
Dust Port Size.....	5 in.
Air Requirement.....	75 PSI

Other Specifications:

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

Features:

- Pneumatic Belt Tracking & Tensioning
- Includes 100-Grit & 150-Grit Sanding Belts
- Amp/Load Meter
- Built-In Air Regulator
- Disc Brake
- Emergency Stop Bar
- Adjustable Conveyor Speed & Sanding Belt Oscillation Speed
- Touchscreen Controls w/Powered Table Elevation
- Lighted View Window
- Workpiece Thickness Sensor



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.



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



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



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



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 Wide Belt 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 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.

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**.

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.

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.

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.



Additional Safety for Compressed Air

WARNING

Serious impact injuries can occur from bursting air components. Eyes and other soft tissues can be easily injured by air streams and debris projected by compressed air. To reduce these risks, operator and bystanders MUST completely heed the warnings below.

PROPER PPE. Always wear ANSI-approved eye and hearing protection. Pneumatic components can propel objects and debris at high speeds or even explode. Air escaping from pneumatic components and connections can exceed safe noise exposure limits and may cause hearing damage with prolonged exposure.

AIR SUPPLY. Only supply clean, dry, regulated compressed air for operations. Never exceed maximum operating pressure or components may burst and cause injury. Never use oxygen, carbon dioxide, combustible gases, or any bottled gas as air source, as these can explode.

INTEGRITY OF AIR COMPONENTS. Inspect air tank, attachment connections, hoses, fittings, and valves for rust, damage, leaks, weakness, looseness, or excessive wear and repair/replace damaged components before operating. Do not attempt to modify, weld on, or repair tank because doing so could cause it to burst. Replace a damaged tank immediately.

AIR ATTACHMENTS. Never use damaged components—they are more likely to rupture. Use proper air hose for connections and confirm air hose is long enough to reach work area without stretching. Always relieve line pressure before connecting or disconnecting air supply or tools. Disconnect air supply when not in use.

MODIFICATIONS. DO NOT adjust or remove safety relief valve. Safety relief valve is designed and adjusted for correct tolerances and abilities of air supply to keep tank and other components from bursting.

INTENDED USE. DO NOT use compressed air as breathable air supply, and DO NOT aim compressed air or air tools at body parts or people. Compressed air can injure or propel debris into eyes or other soft tissues.

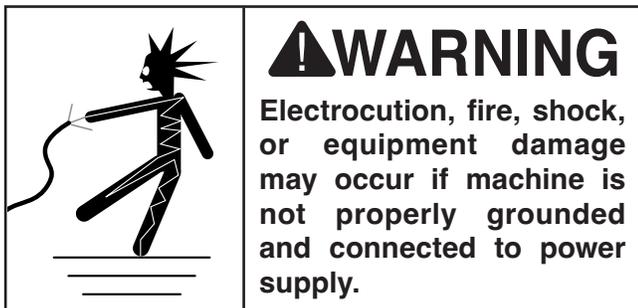
DAILY MAINTENANCE. Drain moisture from air supply tank daily to prevent internal corrosion that will weaken tank.



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.



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 220V32.73A

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

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

Circuit Requirements for 220V

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

Nominal Voltage208V, 220V, 230V, 240V
Cycle.....60 Hz
Phase..... Single-Phase
Power Supply Circuit 40 Amps

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.)



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.*



Connection Type

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

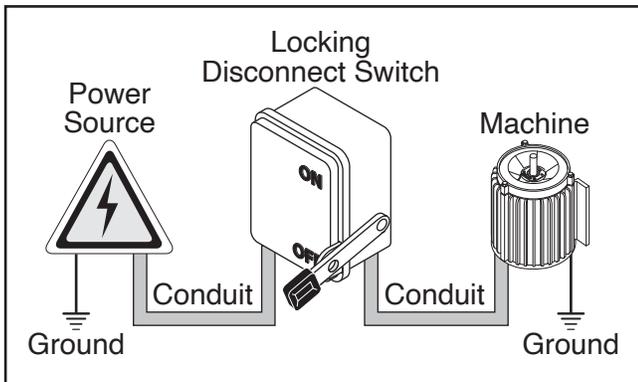


Figure 9. Typical setup of a permanently connected machine.

Extension Cords

Since this machine must be permanently connected to the power supply, an extension cord cannot be used.

Grounding Instructions

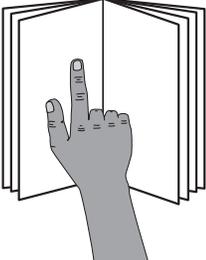
In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

! 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.



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
• Disposable Rags	As Needed
• Cleaner/Degreaser	As Needed
• Disposable Gloves	As Needed
• Lifting Equipment (Rated For at Least 1250 Lbs.).....	1
• Level	1
• Compressed Air Supply (Rated For at Least 75 PSI)	1
• Air Hose $\frac{3}{8}$ " (Rated For at Least 75 PSI)	1
• Hose Clamp $\frac{3}{8}$ "	1
• 2x4 (18" Long)	1
• Jointer.....	1
• Table Saw.....	1
• Dust Hose 5"	1
• Hose Clamps 5"	2
• Dust Collection System	1
• Flat Head Screwdriver $\frac{1}{8}$ "	1
• Open-End Wrenches 33mm.....	2

Unpacking

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

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



Inventory

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

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

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Loose Inventory (Figure 10)	Qty
A. Door Keys.....	2
B. Sanding Belts 18½" x 48" 100-Grit, 150-Grit	1 Ea.
C. Flexible Grease Gun Extension	1
D. Phillips Head Screwdriver #2	1
E. Flat Head Screwdriver ¼".....	1
F. Tool Box	1
G. Hex Wrenches 1.5, 2, 2.5, 3, 4, 5, 5.5, 6, 8, 10mm	1 Ea.
H. Open-End Wrenches 8 x 10, 12 x 14, 17 x 19mm	1 Ea.
I. Spare Limit Switch Tips.....	2
J. Spare Fuses 4A 600V	2
K. Strain Relief.....	1

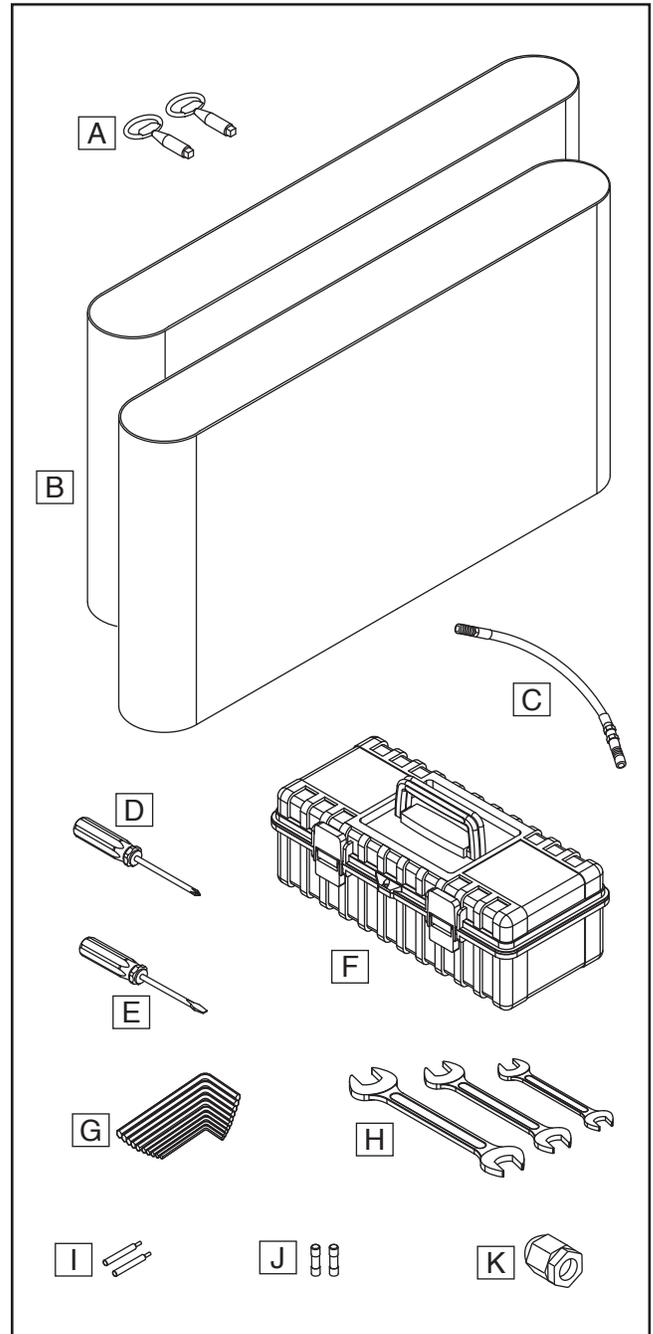


Figure 10. Loose inventory.



Cleanup

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

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

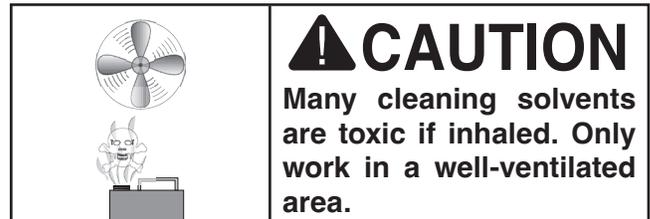
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



T23692—Orange Power Degreaser

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



Figure 11. T23692 Orange Power Degreaser.



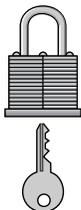
Site Considerations

Weight Load

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

Space Allocation

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

	<p>CAUTION</p> <p>Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
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Physical Environment

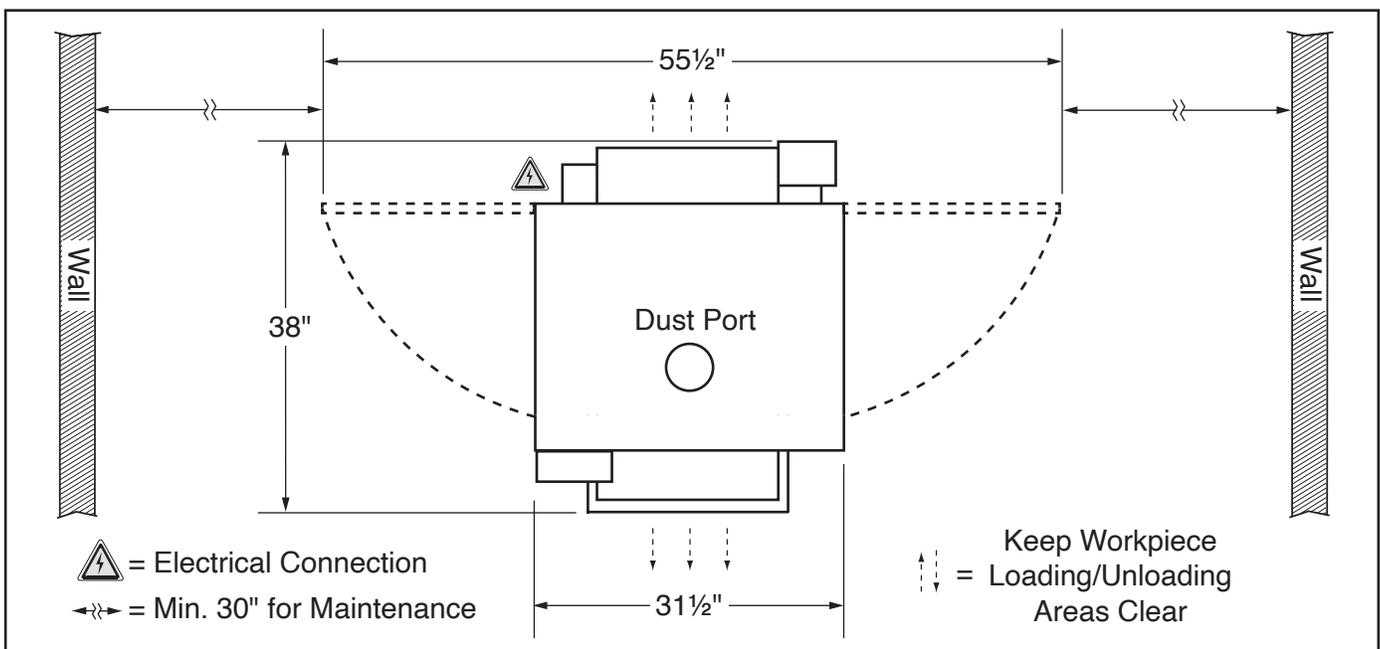
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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

Electrical Installation

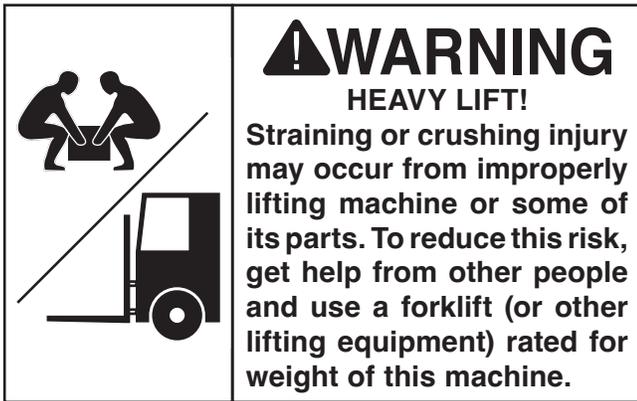
Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

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



Lifting & Placing



Do not attempt to lift or move this machine without using the proper lifting equipment (such as a forklift or crane). Each piece of lifting equipment must be rated for at least 1250 lbs. to support the dynamic loads that may be applied while lifting.

To lift and place machine:

1. Remove shipping crate top and sides, then remove toolbox and sanding belts from shipping pallet.
2. Move machine to prepared location while it is still attached to shipping pallet.
3. Remove (8) flat head screws and (2) access panels (see **Figure 13**).

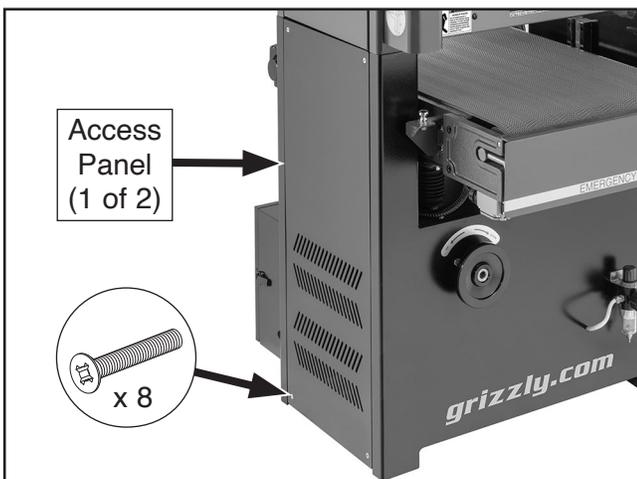


Figure 13. Location of access panels and screws.

4. Remove (4) lag screws and flat washers securing machine to pallet (see **Figure 14**).

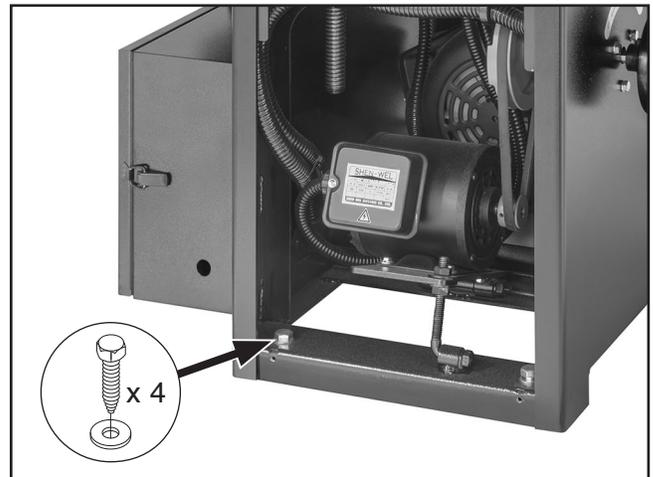


Figure 14. Location of lag screws and flat washers.

5. Carefully place forklift forks under sander (see **Figure 15**).



Figure 15. Example of lifting machine with forklift.

6. Lift sander just enough so you can remove pallet, then slowly lower sander into position.



Leveling

NOTICE

For accurate sanding results and to prevent warping conveyor table, sander frame **MUST** be leveled from side to side and from front to back on both ends.

Re-check sander frame 24 hours after installation, two weeks after that, and then annually to make sure it remain level.

Leveling machinery helps precision components, such as conveyor tables, remain straight and flat during the lifespan of the machine. Components on a machine that is not level may slowly twist due to the dynamic loads placed on the machine during operation.

IMPORTANT: Use only hand tools to secure machine to floor. Do not tighten with impact tools, which can permanently twist and bend components and pull a level machine out of alignment.

If needed, use metal shims between the sander frame and the ground when leveling the machine.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 1/2"

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

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

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

Anchoring to Concrete Floors

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

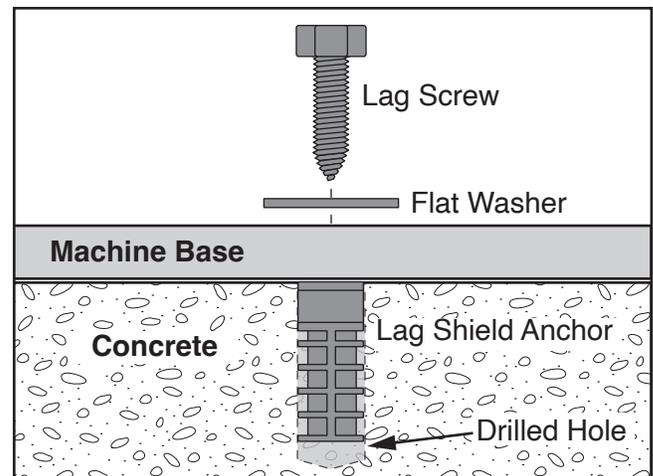


Figure 16. Popular method for anchoring machinery to a concrete floor.



Assembly

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

Assembly of the Model G0407 consists of installing an air supply line, installing a sanding belt, and verifying the factory-set pressure roller settings.

To assemble machine:

1. VERIFY INCOMING AIR SUPPLY IS **OFF** OR SET TO 0 PSI!
2. Connect air supply hose to air inlet on regulator (see **Figure 17**) and secure with hose clamp.

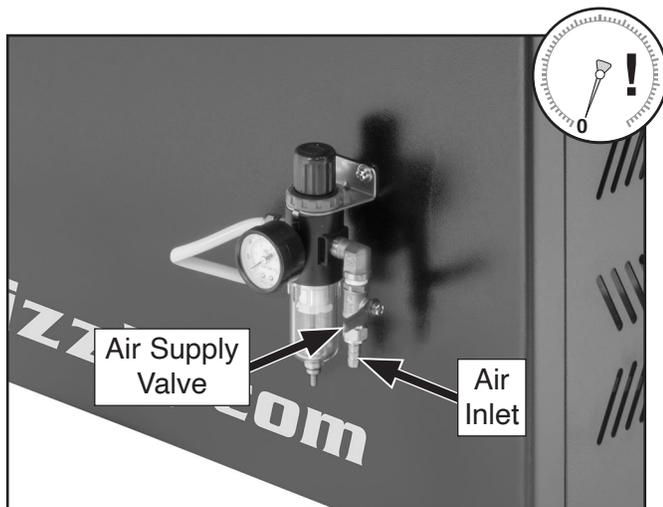


Figure 17. Location of air inlet and air supply valve on regulator.

3. Open air supply valve or turn air compressor **ON**, and verify incoming air pressure is set to at least 75 PSI.
4. Make sure red air supply valve on regulator (see **Figure 17**) is in open position.

5. Lift regulator knob to unlock (see **Figure 18**) and rotate it until gauge reads 75 PSI.

Note: Rotate knob clockwise to increase air pressure and counterclockwise to decrease.

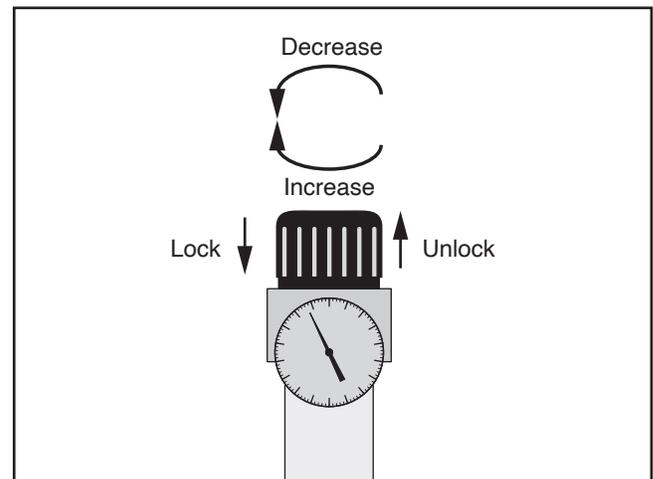


Figure 18. Regulator knob adjustment.

6. Push knob down until it clicks to lock knob.
7. With machine connected to air, open left door and turn belt tension switch counterclockwise to detensioned position (see **Figure 19**).
8. Remove stop block release lever by turning it counterclockwise a $\frac{1}{2}$ turn and pulling it up and out of mounting hole (see **Figure 19**).
9. Remove stop block (see **Figure 19**).

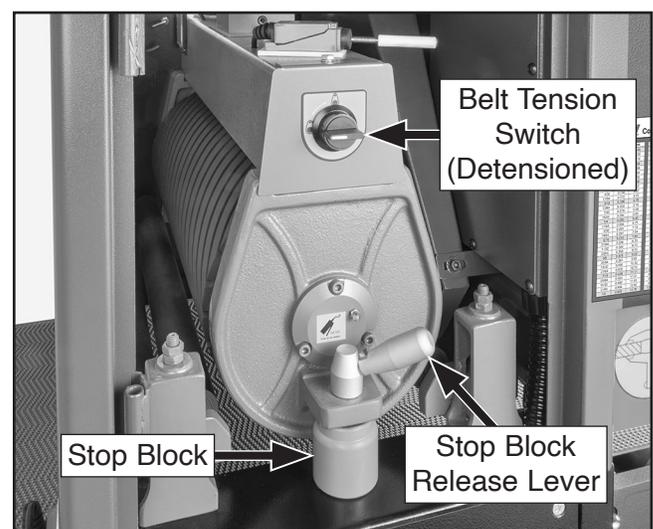


Figure 19. Sanding belt installation components.



10. Install desired sanding belt over roller and drum, starting with roller (see **Figure 20**).

Note: Sanding belt must be centered between limit switch tips (see **Figure 20–Figure 21**) and rotation arrows on sanding belt must be pointing in a counterclockwise direction, as shown with dashed line in **Figure 20**.

NOTICE

Failure to install and position sanding belt correctly will result in damage to sanding belt and sander.

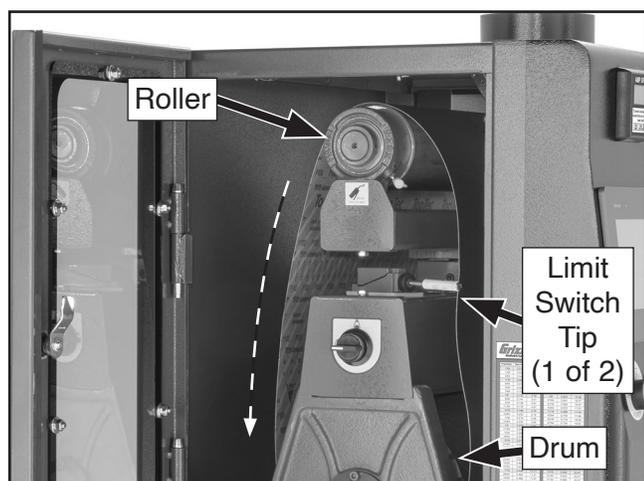


Figure 20. Sanding belt installed correctly.

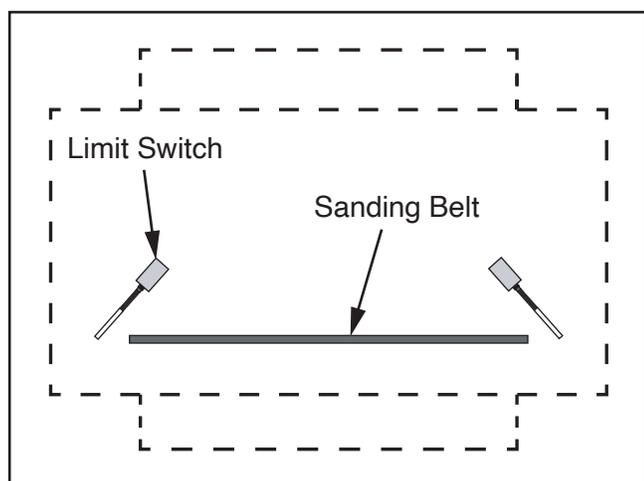


Figure 21. Sander outline (top view) of proper position of belt.

11. Install stop block and stop block release lever.
12. With hands clear of all moving parts, turn belt tension switch clockwise to tension belt.

! WARNING

Pressure rollers must be set below level of sanding drum. If pressure rollers are even with, or higher than sanding drum, wood **WILL** be propelled from machine at high rate of speed toward front of machine. This could cause serious kickback injury.

13. Joint 18" 2x4 so one side is flat, then use flat side against table saw fence to cut opposite side of workpiece parallel.

IMPORTANT: 2x4 **MUST** have uniform thickness for following steps to be completed accurately.

14. Place 2x4 across one side of conveyor table so it spans both front and rear pressure rollers (see **Figure 22**).



Figure 22. Example of 2x4 positioned to check pressure roller height.



15. Use table elevation handwheel (see **Figure 23**) to manually raise conveyor table and verify that board touches both pressure rollers before touching sanding belt.



Figure 23. Location of table elevation handwheel.

16. Repeat **Steps 14–15** on opposite side of conveyor belt.
 - If board touched pressure rollers before touching sanding belt on both sides, no adjustment is required. Proceed to **Step 17**.
 - If board *did not* touch pressure rollers before touching sanding belt on both sides, or if board was difficult to place between rollers and table, then refer to **Adjusting Pressure Rollers** on **Page 60** to adjust pressure rollers before proceeding with operations.
17. Close and secure left door.
18. Turn **OFF** air compressor or close air valve at compressor.

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: 600 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 5" dust hose over dust port, as shown in **Figure 24**, and secure in place with hose clamp.



Figure 24. Dust hose attached to dust port.

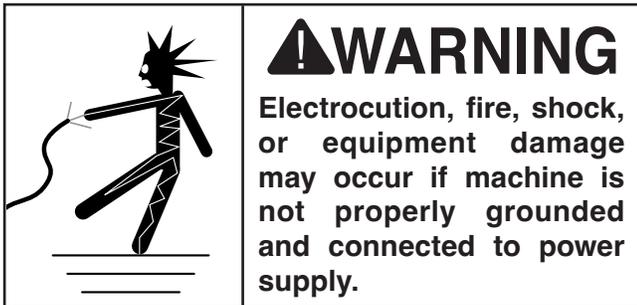
2. Tug hose to make sure it does not come off.

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



Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.



Hardwiring to Power Supply

Hardwire setups require the power supply lines to be enclosed inside of conduit, which is securely mounted and constructed in adherence to applicable electrical codes.

A hardwire setup for this machine must be equipped with a locking disconnect switch as a means to disconnect power during adjustments or maintenance, which is a typical requirement for many lock-out/tag-out safety programs.

Figure 25 shows a simple diagram of a hardwire setup with a locking disconnect switch between the power supply and the machine.

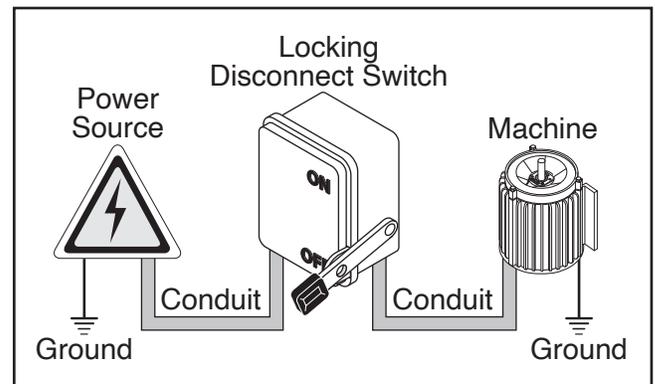


Figure 25. Typical setup of a locking disconnect switch.

Due to the complexity required for planning, bending, and installing the conduit necessary for a code-compliant hardware setup, an electrician or other qualified personal **MUST** perform this type of installation.



Connecting Power Supply Wires

1. DISCONNECT POWER SUPPLY WIRES OR LOCK DISCONNECT SWITCH BOX IN OFF POSITION!
2. Remove Phillips head screw shown in **Figure 26**, then open electrical cabinet door.

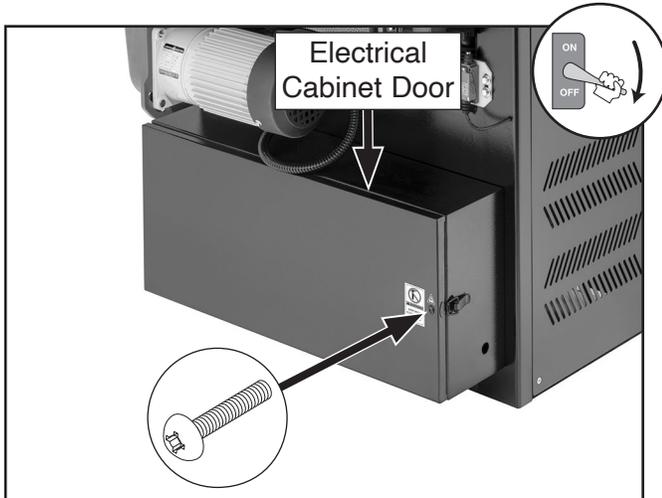


Figure 26. Location of electrical cabinet door and screw.

3. Locate strain relief (see **Figure 27**) loose inside electrical cabinet and remove nut.
4. Insert strain relief into hole shown in **Figure 27**, then secure by loosely threading nut onto strain relief.

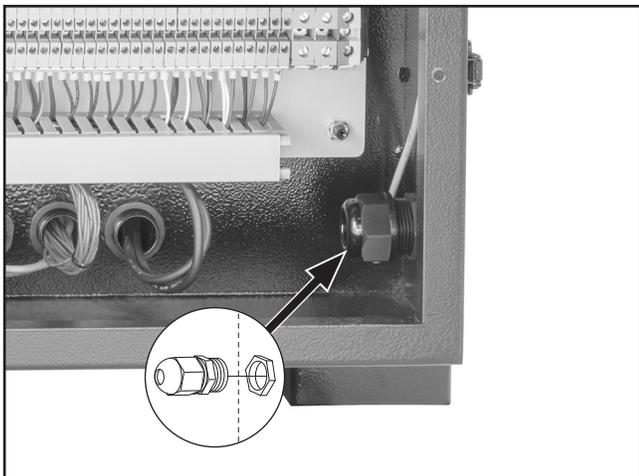


Figure 27. Power supply strain relief installed on electrical cabinet.

5. Insert incoming power wires through strain relief.

!WARNING

During next step, incoming ground wire **MUST** be connected to correct terminal to ensure machine will be properly grounded (see "Ground Terminal" in **Figure 28**). Ungrounded or improperly grounded machine can cause electrocution if live electrical wires make contact with frame or other parts touched by operator.

6. Connect ground wire to bottom of ground terminal "E", then connect incoming power wires to "R" and "S" terminals shown in **Figure 28**.

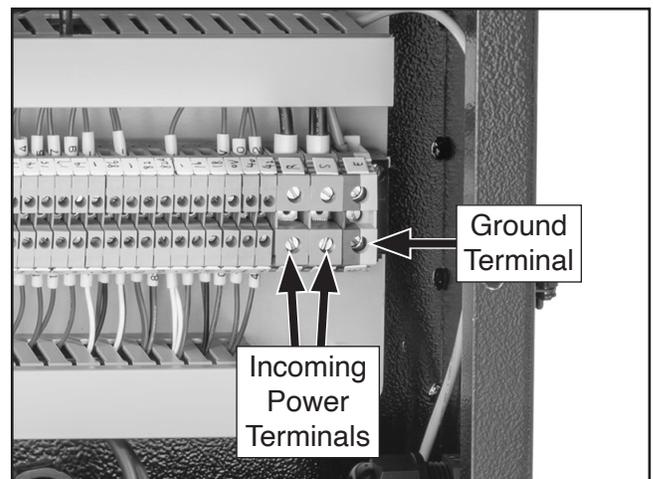


Figure 28. Ground and power wire terminals.

7. Make sure wires have enough slack inside electrical cabinet so they are not pulled tight or stretched, then tighten strain relief nut to secure.
8. Close electrical cabinet door, then secure with screw removed in **Step 2**.



Connecting to Power Source

Move the disconnect switch handle to the ON position, as illustrated below. The machine is now connected to the power source.

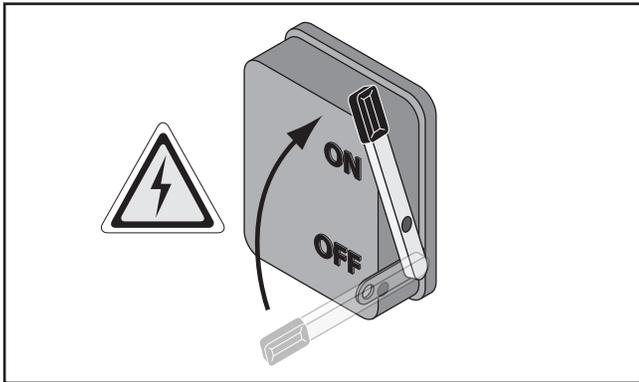


Figure 29. Connecting power to machine.

Disconnecting from Power Source

Move the disconnect switch handle to the OFF position, as illustrated below. The machine is now disconnected from the power source.

Note: Lock the switch in the OFF position to restrict others from starting the machine.

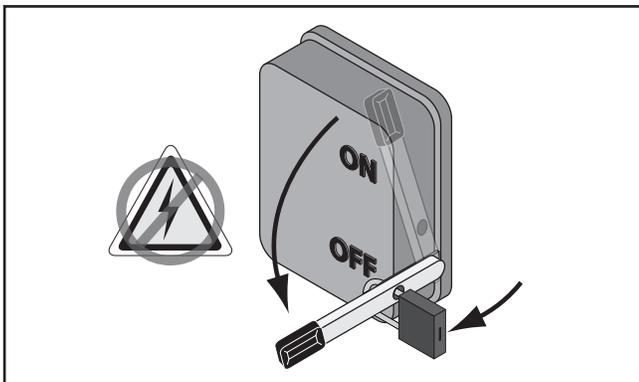


Figure 30. Disconnecting power from machine.

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) motors power up and run correctly, 2) EMERGENCY STOP button works correctly, 3) EMERGENCY STOP! bar works correctly, 4) the workpiece thickness sensor works correctly, and 5) the conveyor table elevation limit switches work correctly.

!WARNING

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

!WARNING

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



To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power and wait for touch screen to display main menu screen (see **Figure 31**).

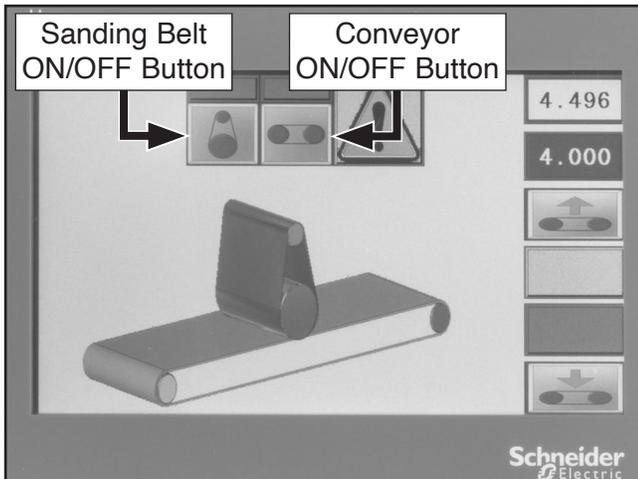


Figure 31. Location of sanding belt and conveyor ON/OFF button on main menu screen.

3. Press EMERGENCY STOP button in. Touchscreen will show active fault log screen (see **Figure 32**) to indicate that EMERGENCY STOP safety feature or limit switch is preventing machine operation.

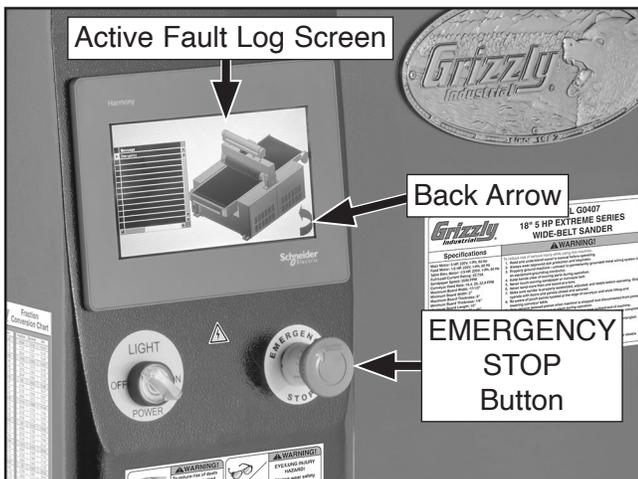


Figure 32. Active fault log screen and location of EMERGENCY STOP button.

4. Open air supply valve or turn air compressor **ON**, and verify pressure gauge on air regulator is set to 75 PSI.

5. Twist EMERGENCY STOP button clockwise until it springs out (see **Figure 33**). This resets switch so machine can start.



Figure 33. Resetting switch.

6. Press back arrow shown in **Figure 32** to return to main menu screen.
7. Press sanding belt ON/OFF button (see **Figure 31**). Verify main motor starts up and runs smoothly without any unusual problems or noises.
8. Press conveyor belt ON/OFF button (see **Figure 31**). Verify feed motor starts up and runs smoothly without any unusual problems or noises.
9. Press EMERGENCY STOP button to turn motors **OFF**.
10. WITHOUT resetting EMERGENCY STOP button, try to start machine by returning to main menu screen and pressing sanding belt and conveyor belt ON/OFF buttons. Motors should not start.

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

— If one or both motors *do* start, immediately turn it **OFF** and disconnect power. Safety feature of EMERGENCY STOP button is NOT working properly and must be corrected before further using machine. Contact Tech Support.

11. Reset EMERGENCY STOP button.
12. Press sanding belt and conveyor ON/OFF buttons to start motors.



13. Press EMERGENCY STOP! bar (see **Figure 34**).

- If sanding and conveyor belt come to a complete stop, safety feature of EMERGENCY STOP! bar is working correctly.
- If sanding and conveyor belt *do not* come to complete stop, immediately disconnect power. Safety feature of EMERGENCY STOP! bar is NOT working correctly and must be corrected before further using machine. Contact Tech Support.



Figure 34. Location of EMERGENCY STOP! bar.

14. Press touchscreen back arrow to return to main menu screen.

15. Place scrap workpiece on conveyor table so part of it extends under workpiece thickness sensor (see **Figure 35**).



Figure 35. Workpiece under workpiece thickness sensor.

16. Press and hold table up button (see **Figure 36**). When workpiece contacts workpiece thickness sensor, table should stop.

- If table *does* stop, workpiece thickness sensor is working correctly.
- If table *does not* stop, refer to **Calibrating Workpiece Thickness Sensor** on **Page 51** to adjust sensor before proceeding with test run.

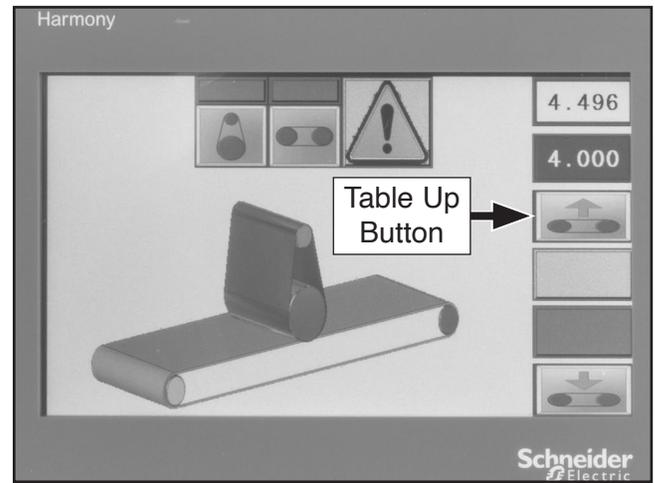


Figure 36. Location of table up button.

17. Remove workpiece from conveyor table.

18. Press and hold table up button. When stop block shown in **Figure 37** presses upper table elevation limit switch, table should stop.

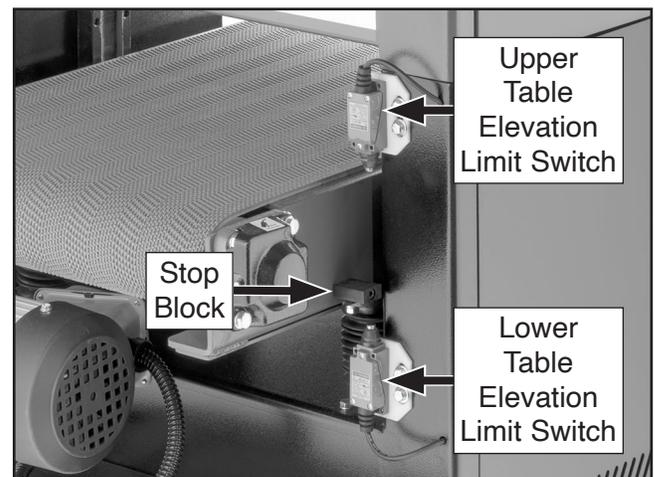


Figure 37. Location of table elevation limit switches and stop block.



- If table *does* stop, upper limit switch is working correctly.
- If table *does not* stop, immediately disconnect power. Upper limit switch is not working correctly and must be adjusted before further using machine. Contact Tech Support.

19. Press touchscreen back arrow to return to main menu screen.
20. Press and hold table down button (see **Figure 38**). When stop block shown in **Figure 37** on **Page 29** presses lower table elevation limit switch, table should stop.

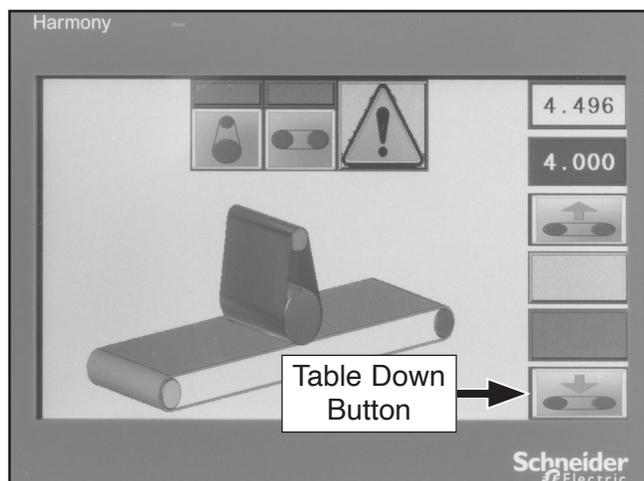


Figure 38. Location of table down button.

- If table *does* stop, lower limit switch is working correctly.
- If table *does not* stop, immediately disconnect power. Lower limit switch is not working correctly and must be adjusted before further using machine. Contact Tech Support.

21. Press touchscreen back arrow to return to main menu screen.
22. Press and hold table up button to raise table until limit switch is no longer engaged.

Congratulations! The test run is complete.

Recommended Adjustments

The following list of adjustments were performed at the factory before your machine was shipped:

- Thickness display calibration (**Page 52**).
- Workpiece thickness sensor calibration (**Page 51**).
- Oscillation timing and speed (**Page 53**).
- Table parallelism (**Page 57**).
- V-belt adjustment (**Page 43**).
- Conveyor belt tension (**Page 62**).
- Conveyor belt tracking (**Page 62**).

Be aware that machine components can shift during the shipping process. Pay careful attention to these adjustments as you test run your machine. If you find that the adjustments are not set according to the procedures in this manual or your personal preference, re-adjust them.

NOTICE

V-belts will stretch and seat into pulley grooves. After about 16 hours of use, adjust tension to ensure good power transfer from motors and avoid reducing life of V-belts.

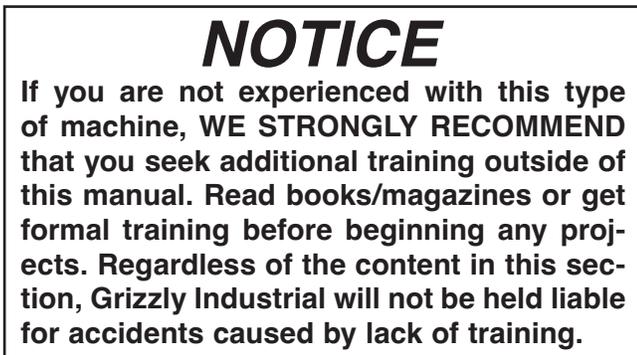
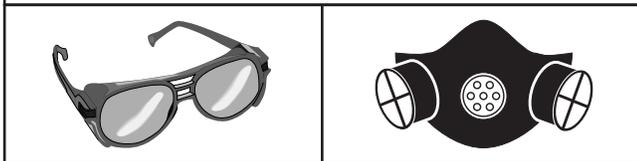


SECTION 4: OPERATIONS

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.



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

1. Examines workpiece to make sure it is suitable for sanding and determines which sanding belt grit size to start with.
2. Adjust conveyor feed rate for operation.
3. Connects air supply, verifies pressure regulator is set to 75 PSI, then installs and tensions sanding belt.
4. Connects machine to power.
5. Adjusts conveyor table height to approximate thickness of workpiece.
6. Puts on safety glasses and respirator.
7. Starts dust collection.
8. Starts sanding belt motor, then starts feed motor.
9. Feeds workpiece into sanding belt by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.
Note: During initial pass with new workpiece, operator adjusts table height as necessary so workpiece only makes light contact with sanding belt and does not overload sander.
10. Receives workpiece from outfeed side of conveyor table.
11. Raises height of conveyor a small amount, then repeats feeding process of workpiece through sander.
12. Changes sandpaper to finer grit.
13. Repeats **Steps 9–12** as needed, then turns machine **OFF** and disconnects it from power.
14. When motors have come to complete stop, turns **OFF** air supply and dust collection.



Sanding Workpieces

The sanding process is influenced by the feed rate, sanding depth, grit size and material type of sandpaper, and oscillation speed. We strongly recommend that you experiment with these variables, or research best practices for achieving your desired sanding results with the type of material you have. Also, to avoid unnecessary wear on belts, always make sure the workpiece has been surface planed with a jointer or planer before sanding.

Typically, no more than 0.020" (one full rotation of the handwheel or four touches of the table up button) of material should be removed during a single sanding pass. The maximum sanding depth can also be influenced by the thickness of the sanding belt, which can vary from 0.010" (fine sandpaper) to 0.060" (coarse sandpaper).

Attempts to remove too much material at one time can cause jamming, wood burning, rapid sandpaper wear or tearing, poor finish, short motor life, and belt slippage. The operator usually makes a pass, raises the table a little, and repeats until the entire surface is sanded to satisfaction. Before sanding, ensure you review **Workpiece Inspection** and put on the required safety glasses and respirator.

Note: *It may take more than one pass to achieve the full sanding depth.*

The overall sanding process consists of the operator starting sanding with a coarse grit sandpaper, such as #60, and then repeating this for subsequent grit sizes from #80–#100 until the workpiece is evenly smooth. The operator then performs intermediate sanding passes using #100–#150 grit sandpaper. For the final sanding pass, the operator sands the workpiece using #180 grit or finer sandpaper.

IMPORTANT: As you sand, observe the amp draw meter (see **Figure 1** on **Page 5**). If the meter indicates motor overload, slightly lower the table or reduce the feed rate.

Use the below table to determine the approximate maximum depth of cut (DOC) for relative conveyor feed rates. After selecting the appropriate feed rate value, find the grit size you plan to use. Locate the correct DOC for that grit by selecting the correct wood hardness of the workpiece.

Note: *These numbers are approximate values only. They are provided with the intent of giving you a "ballpark" idea of what to expect for material removal rates from this machine. Many additional factors can influence the maximum depth-of-cut or removal rates that can be achieved with each pass (i.e., oscillation speed settings, depth of cut taken on previous pass, actual hardness of workpiece, etc.), so do not be surprised if you experience slightly different results.*

Approximate Max Depth of Cut for 15" Stock

Feed Rate	Grit Size	Wood Hardness	
		Hard	Soft
16.4 FPM	60	0.030"	0.040"
	80	0.025"	0.035"
	100	0.020"	0.030"
	120	0.015"	0.020"
	150	0.010"	0.015"
	180	0.005"	0.010"
	240	0.003"	0.005"
23 FPM	60	0.025"	0.035"
	80	0.020"	0.030"
	100	0.015"	0.020"
	120	0.010"	0.015"
	150	0.005"	0.010"
	180	0.003"	0.005"
	240	0.002"	0.004"
32.8 FPM	60	0.020"	0.030"
	80	0.015"	0.025"
	100	0.010"	0.015"
	120	0.007"	0.010"
	150	0.005"	0.007"
	180	0.003"	0.005"
	240	0.001"	0.003"



Workpiece Inspection

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

Before sanding, inspect all workpieces for the following:

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

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

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear sanding belt. Always visually inspect your workpiece for these items. If they cannot be removed, DO NOT sand the workpiece.
- **Wet or "Green" Stock:** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on sanding belt, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting can be dangerous to sand because they are unstable and unpredictable when being sanded. DO NOT use workpieces with these characteristics!
- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side is facing the table. On the contrary, a workpiece supported on the bowed side will rock during sanding and could cause kickback injury.

Sanding Tips

- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.
- Only sand with as slow of feed speeds as necessary to meet your sanding goals. In other words, avoid running the sander faster than is necessary. Increasing feed speeds beyond the required level can decrease the quality of the finished product and the lifespan of sanding belts.
- As a rule-of-thumb, sand with progressively higher grit numbers in increments of 50 or less.
- Replace sandpaper with a higher grit to achieve a finer finish (refer to **Changing Sanding Belt** on **Page 34**).
- When making multiple passes on the workpiece, avoid raising the conveyor table more than 0.015" (a $\frac{3}{4}$ turn of the elevation handwheel or three touches of the table up button) per each pass.
- Reduce snipe when sanding more than one board of the same thickness by feeding them into the machine with the front end of the second touching the back end of the first board (a.k.a. "butt feeding").
- DO NOT sand boards smaller than 10" long, 2" wide, and $\frac{1}{8}$ " thick to prevent damage to the workpiece and the sander (see **Figure 39**).

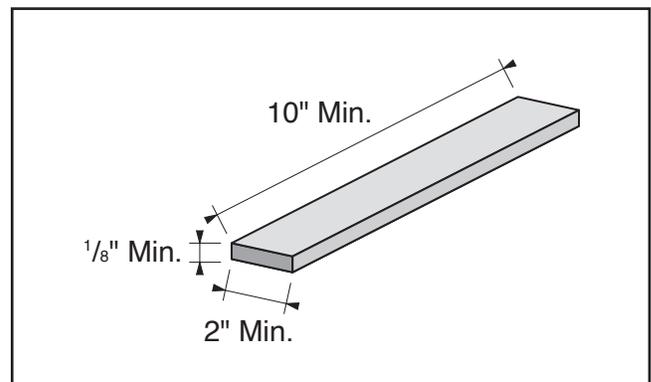


Figure 39. Minimum dimensions for sanding.



- Feed boards into the machine at different points on the conveyor to maximize sandpaper life and prevent uneven belt wear.
- Extend the life of the sandpaper by regularly cleaning the sanding belt (refer to **Cleaning Sanding Belt** on **Page 47**).
- DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury, or damage to the conveyor and sanding belt.
- Only use the amp draw meter to keep the motor from overloading—that is its main purpose. Avoid using the amp draw meter to monitor how much material is being removed, as this can lead to problems, including belts loading, burning, and poor quality sanding results.
- The faster the feed rate you use, the faster your sanding belts will wear out.

- H5222—60-Grit**
- H5223—80-Grit**
- H5224—100-Grit**
- H5225—120-Grit**
- H5226—150-Grit**

These belts use tough aluminum oxide grain, open coated on a very heavy "Y" weight polyester backing provides longer belt life.



Figure 40. H5225 18" x 48" A/O Sanding Belt 120-Grit.

Changing Sanding Belt

Required Sanding Belt Size 18½" x 48"

Included 18½" x 48" Belts	Qty
100-Grit	1
150-Grit.....	1

The Model G0407 only accepts 18½" wide by 48" long sanding belts.

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

For additional sanding belt selections beyond those included with the machine, see the following belts of the correct size offered by Grizzly.

When choosing sanding belts, use these grit numbers as a general guide:

Grit	Type
60 or less.....	Coarse
80–100.....	Medium
120–150.....	Fine
180+.....	Finish

The general rule of thumb is to sand a workpiece with progressively higher grit numbers—in increments of 50 or less.

Note: Sandpaper finer than 180-grit will quickly load up or burn workpieces.

To change sanding belt:

1. DISCONNECT MACHINE FROM POWER!
2. Open air supply valve or turn air compressor **ON**, and verify pressure gauge on air regulator is set to 75 PSI.



3. Open left door.
4. Turn belt tension switch counterclockwise to release sanding belt tension (see **Figure 41**).
5. Remove stop block release lever by turning it counterclockwise a 1/2 turn and pulling it up and out of mounting hole (see **Figure 41**).
6. Remove stop block (see **Figure 41**).

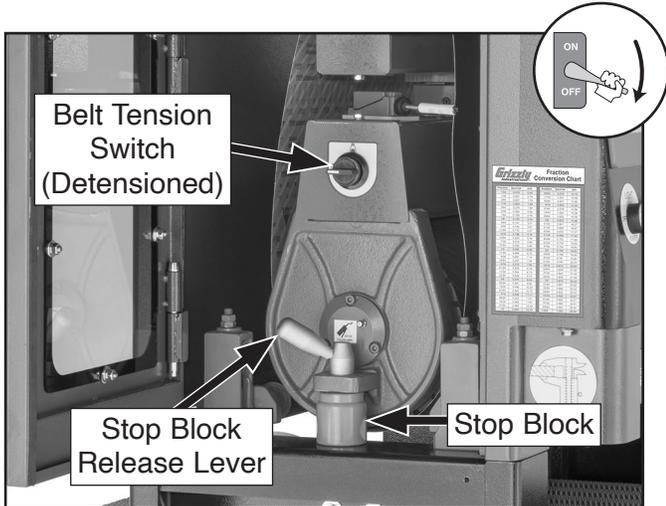


Figure 41. Components for changing sanding belt.

7. Remove existing sanding belt.
8. Install desired sanding belt over roller and drum, starting with roller (see **Figure 42**).

Note: Sanding belt must be centered between limit switch tips (see **Figure 42–Figure 43**) and rotation arrows on sanding belt must be pointing in a counterclockwise direction, as shown in **Figure 42**.

NOTICE

Failure to install and position sanding belt correctly will result in damage to sanding belt and sander.

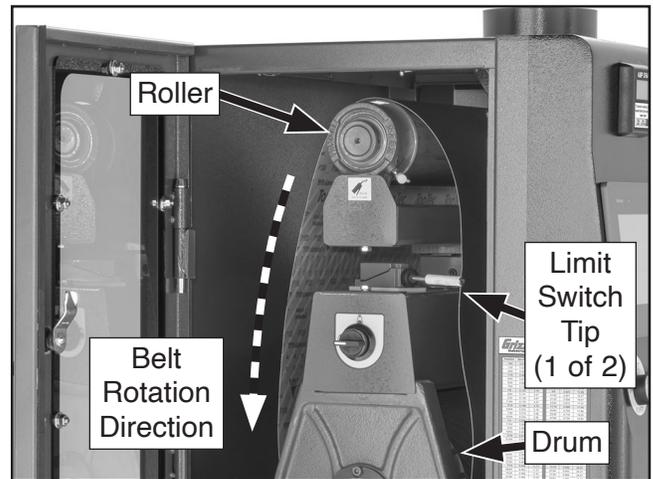


Figure 42. Sanding belt installed correctly.

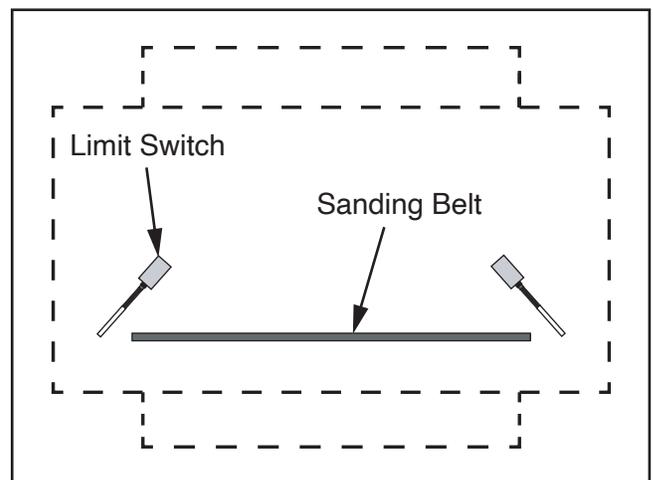


Figure 43. Sander outline (top view) of proper position of belt.

9. Install stop block and stop block release lever.
10. With hands clear of all moving parts, turn belt tension switch clockwise to tension belt.
11. Close and secure left door.



Changing Feed Rate

The conveyor belt has three feed rates, which are controlled by the chain position on the sprockets of the feed motor and conveyor roller (see **Figure 44**).

Conveyor Feed Rates..... 16.4, 23, 32.8 FPM

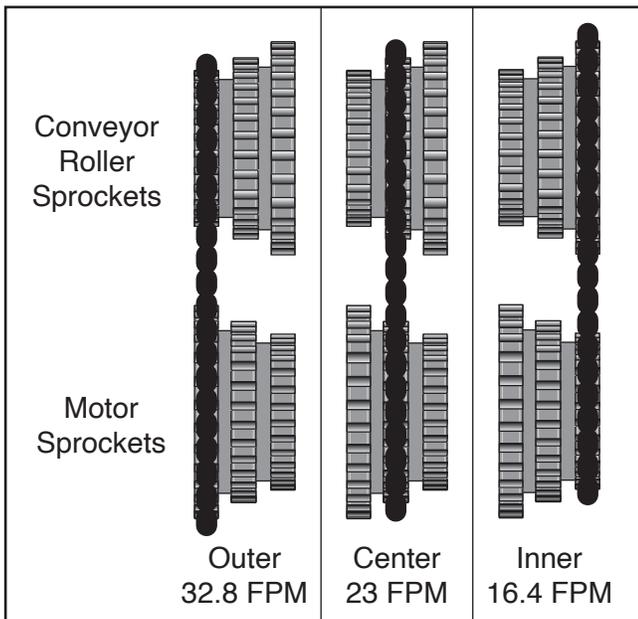


Figure 44. Chain positions for setting conveyor belt feed rate.

As a general rule, slower feed rates are more beneficial than faster feed rates since they allow the sanding belt to remove more material. We recommend you always start with the slowest feed rate and only increase the feed speed as needed to meet your sanding goals. Be sure to always test the feed rate using scrap wood similar to your workpiece.

Softwoods typically require a faster feed rate than hardwoods; however, there is not a definitive rule to follow when determining the best feed rate to use for any type of wood.

Also, keep in mind that an increase in feed rate will increase the amperage load for a given sanding depth. This means you need to use shallower sanding depths at higher feed rates to avoid overloading the sanding motor.

Tools Needed
Hex Wrenches 6, 12mm 1 Ea.

To change feed rate:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cap screw shown in **Figure 45** to remove chain cover.

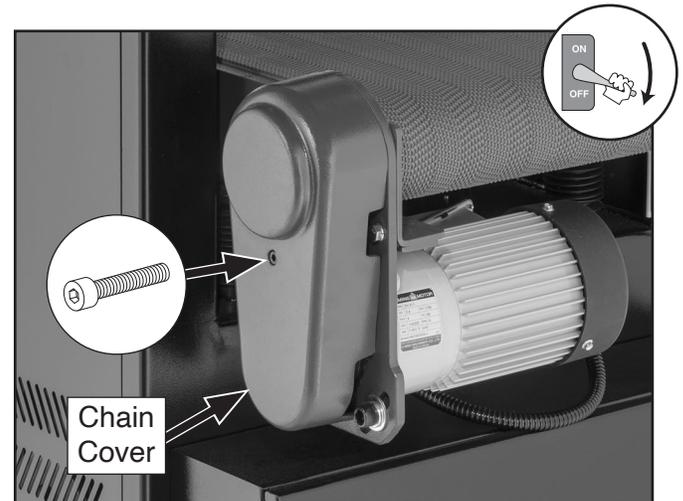


Figure 45. Location of chain cover and securing screw.

3. Loosen pivot screw and tension screw shown in **Figure 46**, lift motor to release chain tension, then tighten tension screw to secure motor in place.

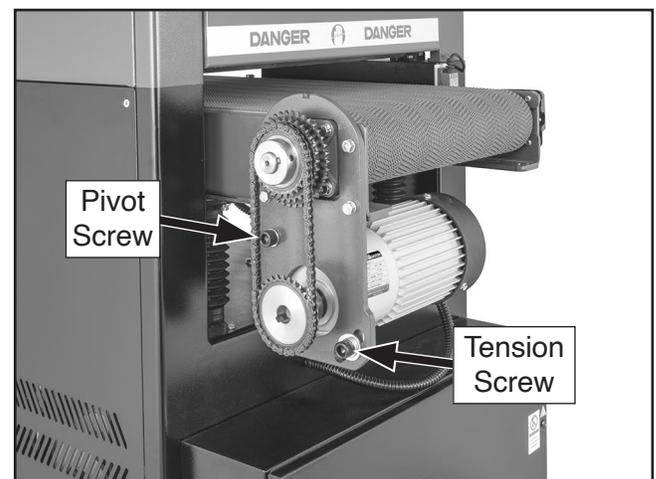


Figure 46. Location of pivot and tension screws.



4. Move chain onto set of sprockets (see **Figure 47**) that correspond to desired feed rate (see **Figure 44** on **Page 36**).

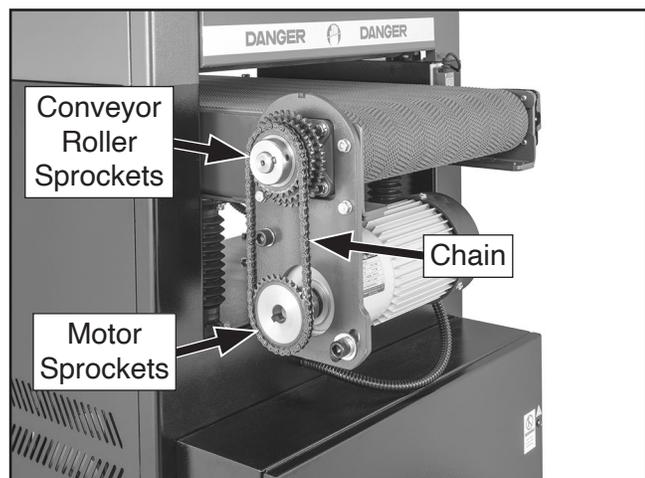


Figure 47. Location of chain and sprockets.

5. Loosen tension screw, move motor down to tension chain, then tighten tension screw and pivot screw to secure motor position.
6. Install chain cover and secure with screw removed in **Step 2**.

Reading Amp Draw Meter

The amp draw meter (see **Figure 48**) is used to keep the machine from overloading during sanding operations. It should not be used as the main method for controlling material removal rates—doing so can result in belt loading, burning, and even breaking—because there are many different variables that affect optimum removal rates and these will affect the amp load in different ways.

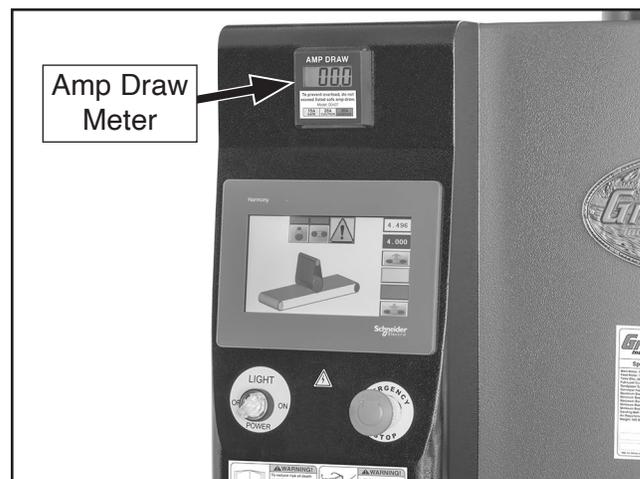


Figure 48. Location of amp draw meter.

Amp load is directly affected by factors such as feed rate, depth of cut, wood type, sandpaper grit, and workpiece width. If the amp load is in the red load range, the machine is overloaded and motor damage may soon occur. Adjust the table elevation accordingly to reduce the load, and use the amp draw chart on the meter to keep the amp load in the green, SAFE range during operation.

As a general rule, always start with a small load and work your way up. DO NOT work the machine to its maximum load, or to where you can hear the motors lose RPM; instead, make multiple light passes or install a coarser grit sanding belt.

NOTICE

Keep amp draw within GREEN load range shown on chart on meter. If you operate machine in RED load range, motor damage may occur and it will not be covered under warranty.



Using EMERGENCY STOP! Bar

The EMERGENCY STOP! bar can help reduce the amount of damage to internal components during an emergency and can prevent operator injury. Pushing the EMERGENCY STOP! bar (see **Figure 49**) causes the disc brake to stop the sanding belt motor, immediately stopping the sanding belt.



Figure 49. Location of EMERGENCY STOP! bar.

An operator should be careful when loading a workpiece not to trap fingers between workpiece and conveyor table, but if it should happen, the EMERGENCY STOP! bar can be pressed by the operator while their hands are otherwise engaged.

⚠️ WARNING

Keep sanding drum V-belt correctly tensioned (see Page 43) to ensure proper functionality of EMERGENCY STOP! bar. Otherwise, pulleys can slip when brake is applied and not immediately stop machine during emergency!

Using Workpiece Thickness Sensor

The workpiece thickness sensor allows you to quickly adjust the table elevation according to the size of your workpiece.

On a typical wide-belt sander, you must measure your workpiece, adjust the table elevation to the approximate thickness, then dial-in the depth of cut. The workpiece thickness sensor automates the bulk of this process to save both time and effort.

To use workpiece thickness sensor:

1. Place workpiece on conveyor table so part of it extends under workpiece thickness sensor (see **Figure 50**).



Figure 50. Workpiece under workpiece thickness sensor.

2. Press and hold table up button. Table will adjust up until workpiece contacts sensor.
3. Remove workpiece from conveyor table.
4. Adjust table up according to your desired depth of cut, then proceed with operation.



Safety Faults

The machine is equipped with a safety fault system that helps prevent unsafe operation and machine damage. Should one of these features be engaged, such as a limit switch or an EMERGENCY STOP, the LED lights inside the viewing window will illuminate red, and the touchscreen will open the active fault log screen, as shown in **Figure 51**. Pressing the back arrow on the bottom right corner of the screen will return the touchscreen to the main menu.

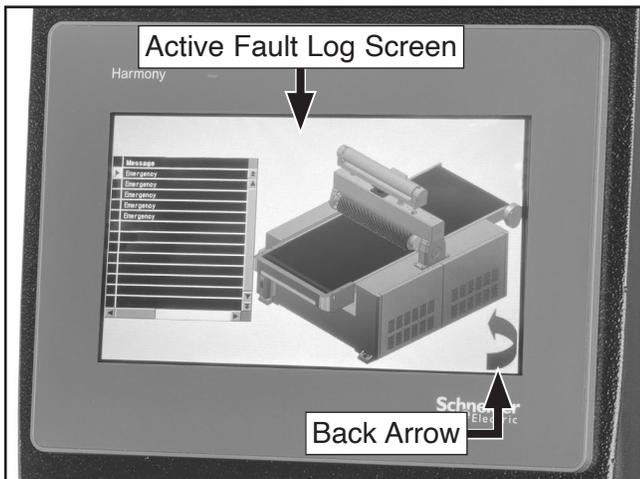


Figure 51. Active fault log screen.

If you return to the main menu without clearing the fault, the fault indicator shown in **Figure 52** will turn red and a red banner will move across the screen with the fault description. If a fault occurs after another safety feature has been too recently engaged, the touchscreen may stay on the main menu and show the **Figure 52** components.

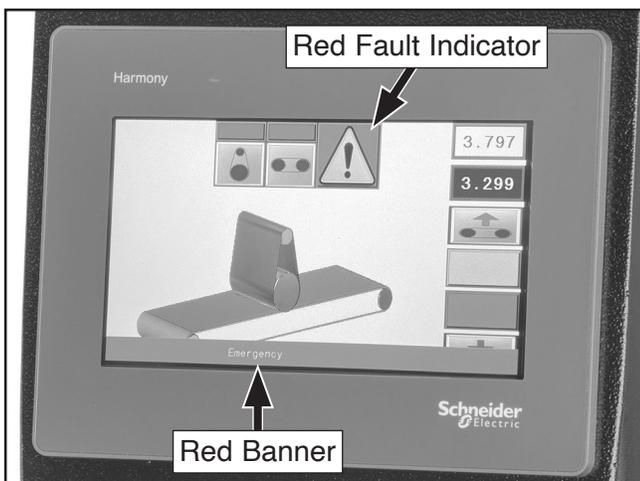


Figure 52. Main menu screen showing fault.

If you wish to review the fault log, you can also press the fault indicator to display the fault log screen shown in **Figure 53**.



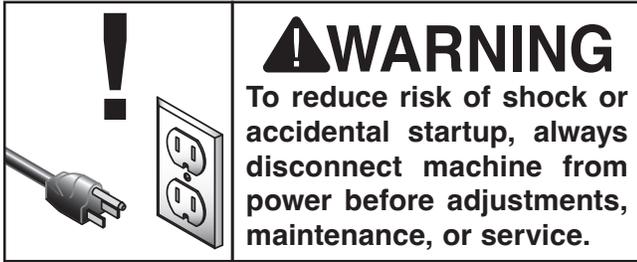
Figure 53. Fault log screen.

Below is a list of the most common fault messages and what they mean. Take the described action to clear the fault and continue with operation.

- **1st Shaft Belt Limit Switch:** Belt tracking limit switch is engaged. Release belt tension, and center sanding belt on roller and drum to clear. Belt tracking or oscillation may need to be adjusted.
- **Down Limit Switch:** Lower table elevation limit switch is engaged. Raise table to clear.
- **Emergency:** EMERGENCY STOP button or EMERGENCY STOP! bar has been pressed. Twist to reset button or release bar to clear.
- **Encoder Error:** Proximity switch has detected table elevation motor rotating in incorrect direction. To clear, disconnect machine from power, check/correct table elevation motor wiring connections, then connect machine to power.
- **R.S.T Phase Error:** Incoming power wires are connected incorrectly or electrical system needs to be reset. To clear, disconnect machine from power, check/connect incoming power wires correctly, then connect machine to power.
- **Up Limit Switch:** Upper table elevation limit switch is engaged. Lower table to clear.



SECTION 5: MAINTENANCE



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.
- Worn or damaged sanding belts.
- Worn or damaged wires.
- Cracks, chafing, or hardening in air hoses.
- Leaks, cracks in air hoses or connections.
- Any other unsafe condition.

Weekly Maintenance

- Empty water in air filter trap.
- Lubricate grease fittings.

Monthly Maintenance

- Clean/vacuum dust buildup from inside frame and off motors.
- Lubricate table elevation chain, leadscrews, and sprockets.
- Lubricate conveyor belt chain and sprockets.
- Check V-belts for correct tension, damage, or wear.

Yearly Maintenance

- Replace air regulator filter.
- Check air hoses and connections inside machine for leaks or clogs. If soapy water at suspected leak creates bubbles, air is escaping. Disconnect air supply and repair/replace affected parts. Remove a line with suspected clog and blow through it as a test.

Cleaning & Protecting

Cleaning the Model G0407 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Lubrication

An essential part of lubrication is cleaning the components before lubricating them. This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more grease to built-up grime will not result in smooth-moving parts. Clean the components in this section with an oil/grease solvent before applying lubrication.

All other bearings are sealed and permanently lubricated. Leave them alone until they need to be replaced.

The following are the main components that need to be lubricated:

- Grease fittings.
- Table elevation chain, leadscrews, and sprockets.
- Conveyor belt chain.

Schedules are based on average use. Adjust lubrication according to your level of use.

DISCONNECT POWER TO MACHINE BEFORE CLEANING AND LUBRICATING COMPONENTS!



Grease Fittings

Lubrication Type T26419 or NLGI#2 Equiv.
 Amount 1–2 Pumps
 Frequency Weekly

Items Needed	Qty
Phillips Head Screwdriver #2	1
Rag	1
Mineral Spirits.....	As Needed
Grease Gun.....	1
Flexible Grease Gun Extension	1

To lubricate grease fittings:

1. DISCONNECT MACHINE FROM POWER!
2. Open right door, then remove (2) Phillips head screws shown in **Figure 54** to remove V-belt cover.

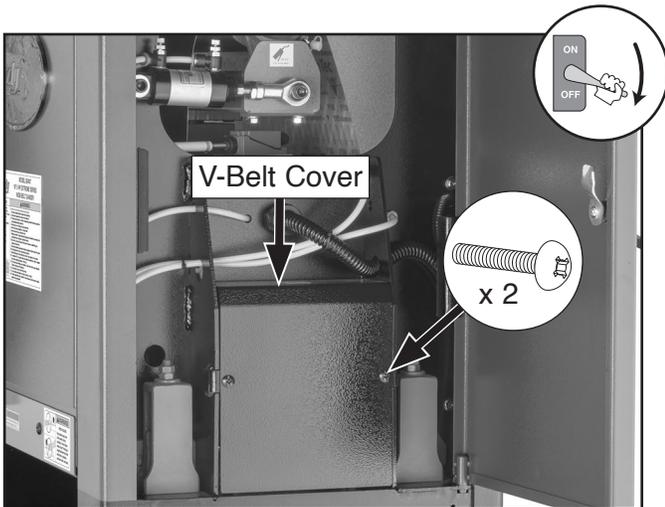


Figure 54. Location V-belt cover and screws.

3. Open left door.
4. Use shop rag and mineral spirits to clean (1) conveyor roller, (2) sanding belt roller, and (2) sanding belt drum grease fittings (see **Figure 55–Figure 56**).

Note: Each grease fitting is identified with a yellow label.

5. Add 1–2 pumps of grease to each grease fitting (see **Figure 55–Figure 56**).

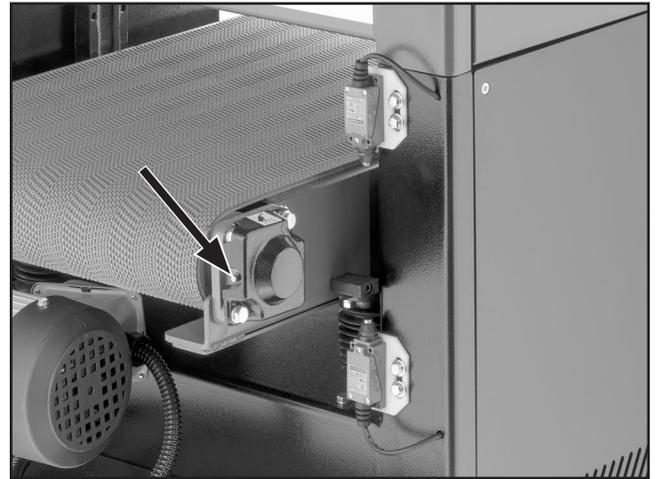


Figure 55. Location of conveyor belt roller grease fitting.

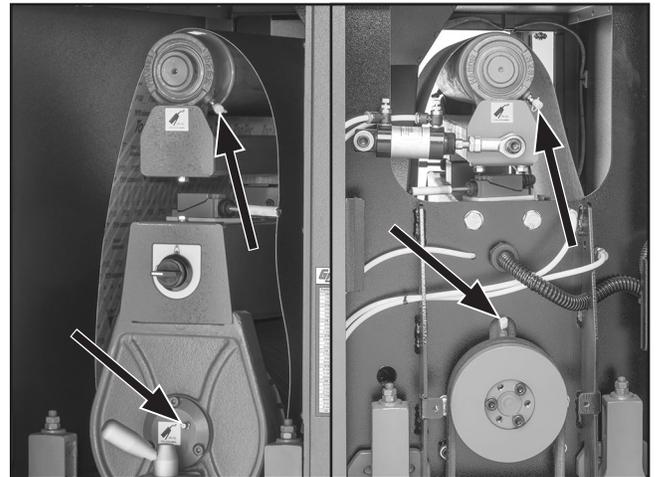


Figure 56. Location of sanding belt roller and drum grease fittings.

6. Install V-belt cover.
7. Close left and right doors.



Table Elevation Chain, Leadscrews, & Sprockets

Lubrication Type T26419 or NLGI#2 Equiv.
 Amount Thin Coat
 Frequency Monthly

Items Needed	Qty
Phillips Head Screwdriver #2	1
Rags	As Needed
Wire Brush.....	1
Mineral Spirits.....	As Needed

Note: In the following steps, be careful not to get any grease on the exposed V-belts. This could cause the V-belts to slip on the pulleys. If you do get grease on the V-belts, thoroughly clean or replace them.

To lubricate table elevation chain, leadscrews, and sprockets:

1. Lower conveyor table all the way.
2. DISCONNECT MACHINE FROM POWER!
3. Remove (8) screws shown in **Figure 57** to remove left and right access panels.

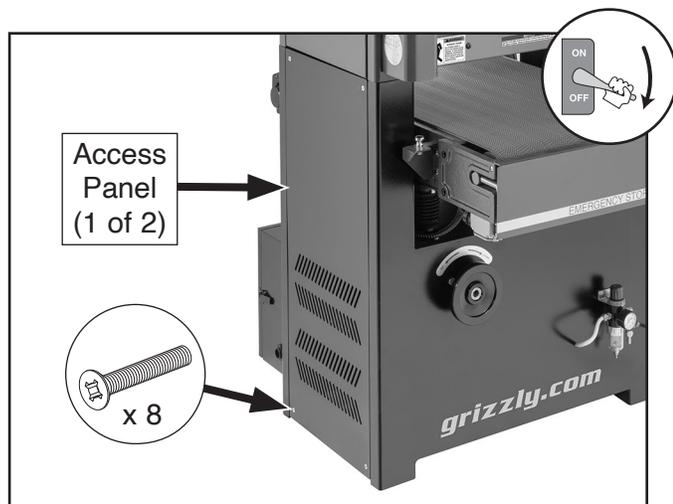


Figure 57. Location of access panels and screws.

4. Use shop rag and mineral spirits to remove old lubricant and built-up grime from chain, exposed leadscrew teeth, and sprockets (see **Figure 58**).

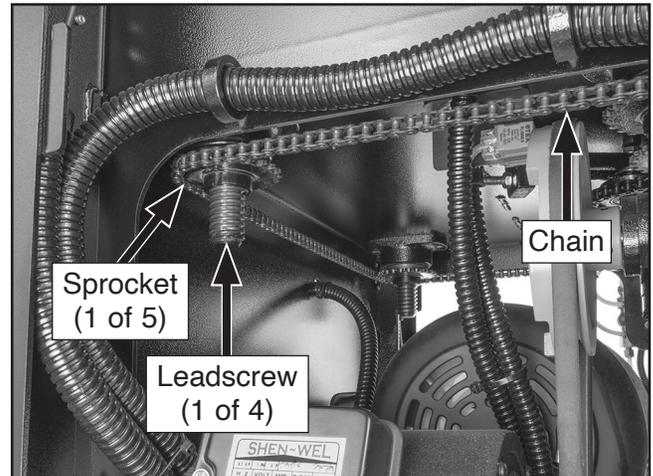


Figure 58. Location of table elevation chain, leadscrews, and sprockets.

5. When components are dry, brush grease onto chain, leadscrews, and sprockets, being careful not to get grease on V-belts.
6. Install left and right access panels and secure with screws removed in **Step 3**.
7. Connect machine to power, then raise and lower table through its full range of movement to evenly distribute grease.

Conveyor Belt Chain & Sprockets

Lubrication Type T26419 or NLGI#2 Equiv.
 Amount Thin Coat
 Frequency Monthly

Items Needed	Qty
Hex Wrench 6mm.....	1
Rags	As Needed
Wire Brush.....	1
Mineral Spirits.....	As Needed



To lubricate conveyor belt chain and sprockets:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cap screw shown in **Figure 59** to remove chain cover.

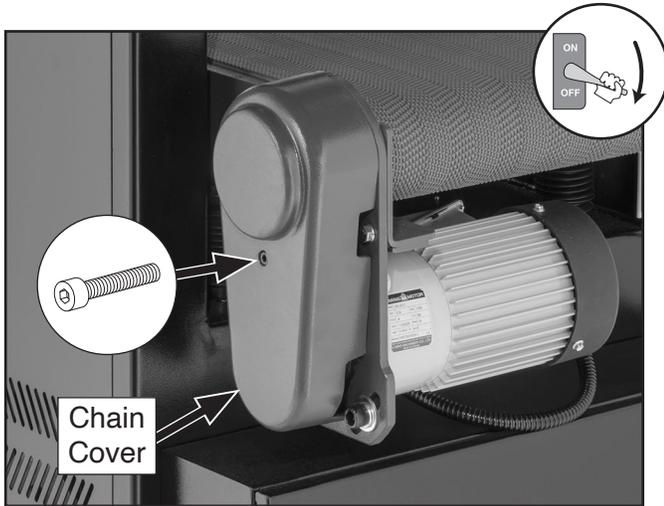


Figure 59. Location of chain cover and screw.

3. Use shop rag and mineral spirits to remove old lubricant and built-up grime from chain and sprockets (see **Figure 60**).

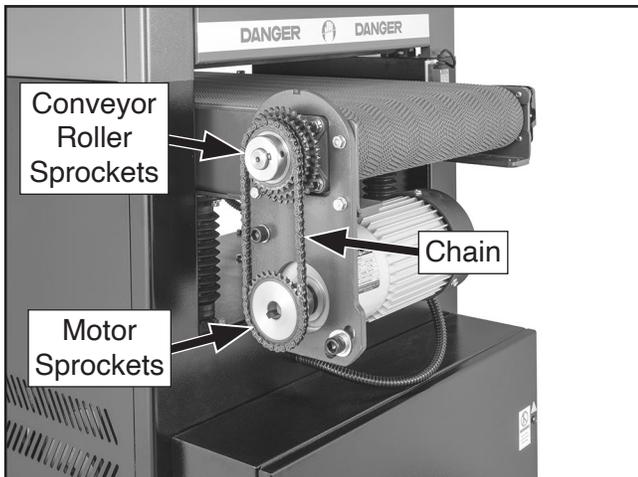


Figure 60. Example of exposed conveyor belt chain and sprockets.

4. When components are dry, brush grease onto chain and sprockets.
5. Install chain cover and secure with screw removed in **Step 2**.
6. Connect machine to power, then run conveyor belt for a few minutes to evenly distribute grease.

Checking/Adjusting V-Belt Tension

The V-belts must be tensioned properly for best performance, and to ensure the sanding drum stops when the emergency brake is applied.

IMPORTANT: Loose belts will not allow the sanding drum to stop immediately if the EMERGENCY STOP! bar or EMERGENCY STOP button is pressed.

Tools Needed	Qty
Phillips Head Screwdriver #2	1
Open-End Wrench 19mm.....	1

To check/adjust V-belt tension:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (8) screws shown in **Figure 61** to remove left and right access panels.

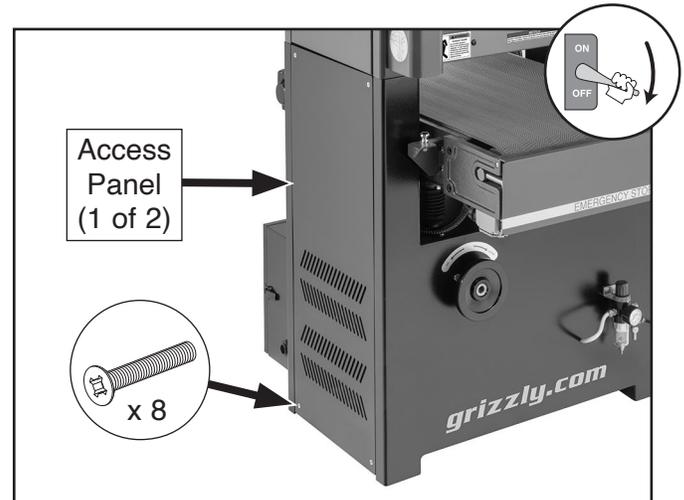


Figure 61. Location of access panels and screws.



3. Check V-belt tension: each V-belt is correctly tensioned when there is approximately $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when it is pushed with moderate pressure, as shown in **Figure 62**.

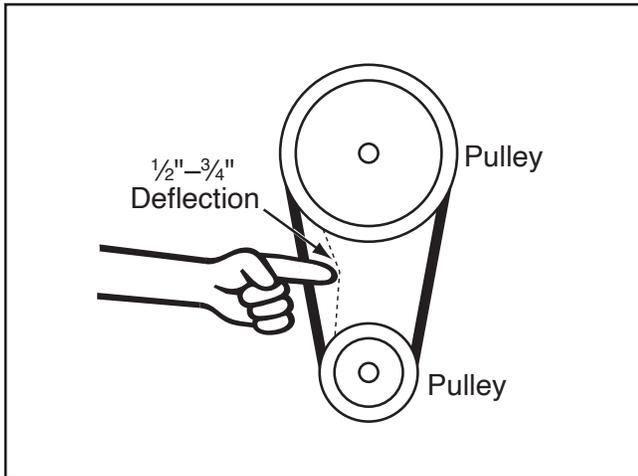


Figure 62. Checking V-belt tension.

- If there is approximately $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when V-belts are pushed with moderate pressure, V-belts are properly tensioned and no adjustment is necessary. Proceed to **Step 5**.
 - If there *is not* approximately $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when V-belts are pushed with moderate pressure, V-belts are not properly tensioned. Proceed to **Step 4**.
4. On V-belt(s) that needs adjustment, rotate (2) V-belt tension nuts (see **Figure 63–Figure 64**) to raise or lower motor until there is approximately $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when V-belt(s) is pushed with moderate pressure.
 - Rotate nuts clockwise to lower motor and apply tension to V-belt(s).
 - Rotate nuts counterclockwise to raise motor and release tension from V-belt(s).

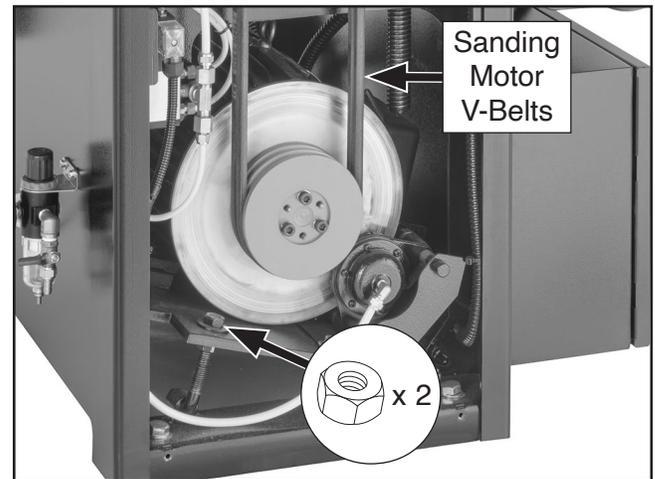


Figure 63. Sanding motor V-belt adjustment components.

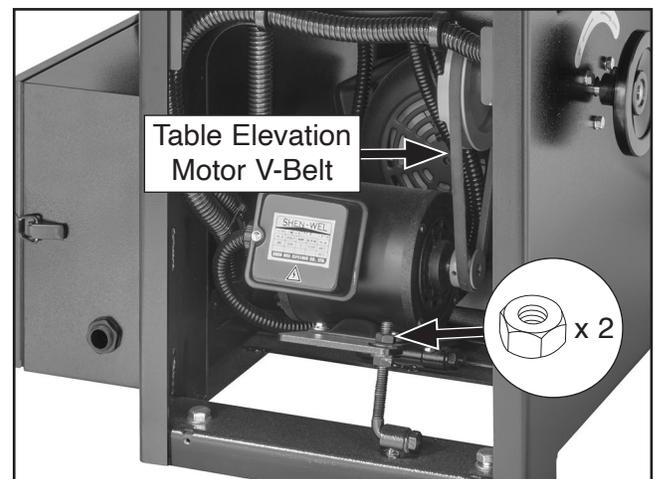


Figure 64. Table elevation motor V-belt adjustment components.

5. Install access panels and secure with screws removed in **Step 2**.



Replacing V-Belts

Check the V-belts periodically for signs of glazing, cracking, fraying, oil/grease, or any other evidence of damage or wear. If any of these conditions are present, replace the V-belt. If any of the main motor V-belts show these conditions, replace the V-belts as a matched set.

Replacing Table Elevation V-Belt

Items Needed	Qty
Phillips Head Screwdriver #2	1
Open-End Wrench 19mm.....	1
Replacement V-Belt (P04071315)	1

To replace table elevation V-belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (4) screws shown in **Figure 65** to remove left access panel.

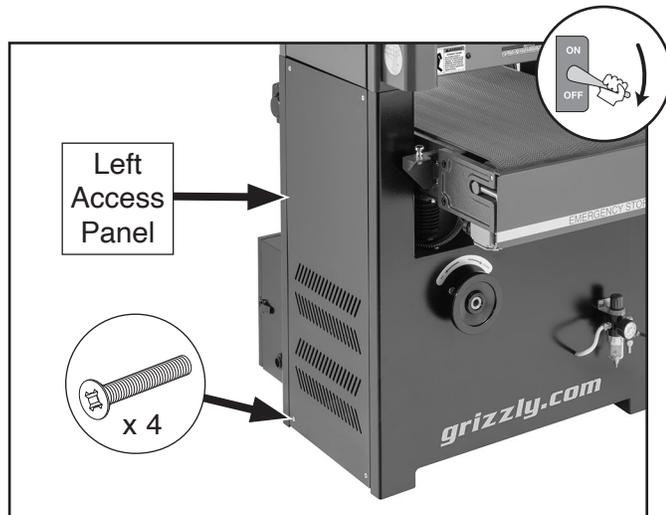


Figure 65. Location of left access panel and screws.

3. Rotate (2) V-belt tension nuts (see **Figure 66**) counterclockwise to release V-belt tension until you can remove V-belt from pulleys.

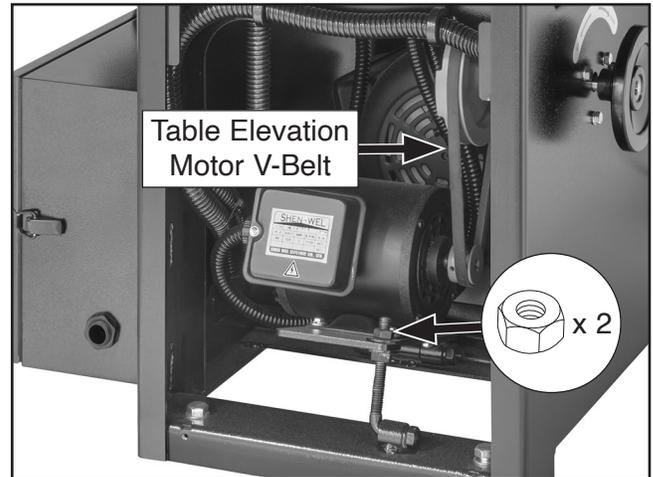


Figure 66. Table elevation motor V-belt components.

4. Place new V-belt onto table pulley, then loop other end of V-belt around motor pulley (see **Figure 67**).

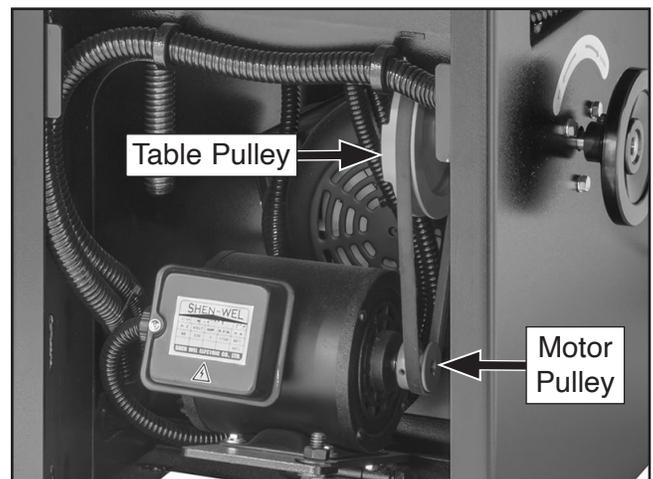


Figure 67. Location of table and motor pulleys.

5. Properly tension V-belt (refer to **Checking/Adjusting V-Belt Tension** on **Page 43** for more information).
6. Install left access panel and secure with screws removed in **Step 2**.

Replacing Sanding V-Belts

Items Needed	Qty
Phillips Head Screwdriver #2	1
Open-End Wrench 19mm.....	1
Replacement V-Belts (P04070119).....	2



To replace sanding V-belts:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (4) screws shown in **Figure 68** to remove right access panel.

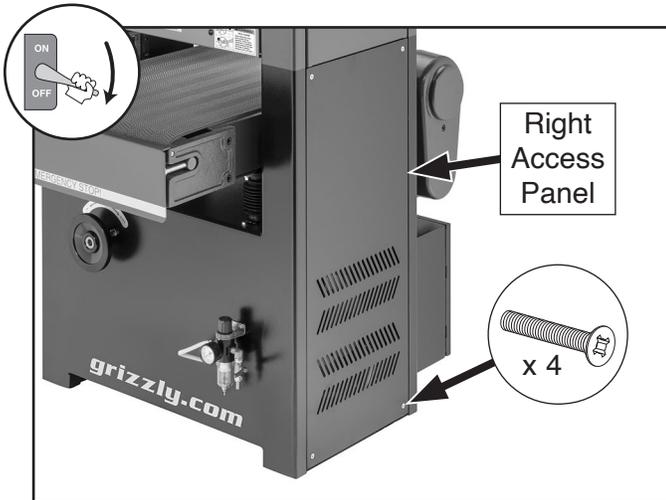


Figure 68. Location of right access panel and screws.

3. Rotate (2) V-belt tension nuts (see **Figure 69**) counterclockwise to release V-belt tension until you can remove V-belts from motor pulley.

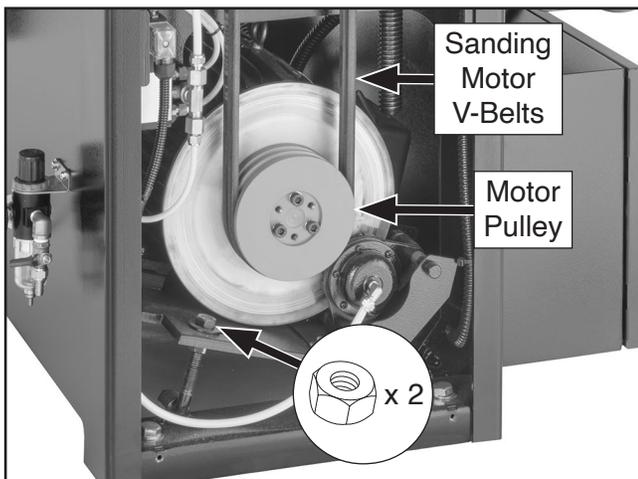


Figure 69. Sanding motor V-belt components.

Note: If brake assembly prevents you from removing V-belts, refer to **Checking/Replacing Brake Pads** on **Page 55** for detailed instructions on how to remove brake assembly.

4. Open right door, then remove (2) Phillips head screws shown in **Figure 70** to remove V-belt cover.

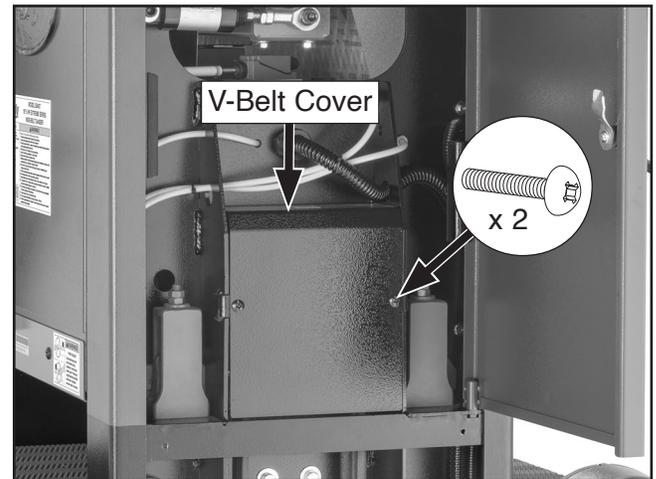


Figure 70. Location of V-belt cover and screws.

5. Remove V-belts from sanding drum pulley (see **Figure 71**).

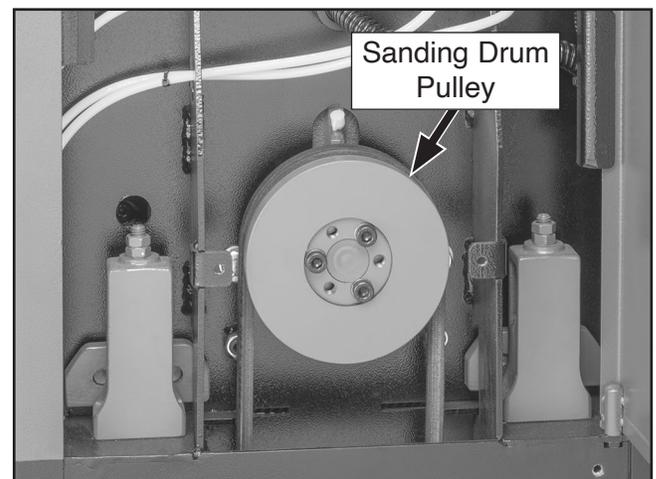


Figure 71. Location of sanding drum pulley.

6. Place new set of V-belts onto sanding drum pulley and then loop other end of V-belts around motor pulley.
7. Install pulley cover and screws from **Step 4**, then close right door.
8. Properly tension V-belt (refer to **Checking/Adjusting V-Belt Tension** on **Page 43** for more information).
9. Install right access panel and secure with screws removed in **Step 2**.



Emptying Filter Trap

The air pressure regulator filter trap (see **Figure 72**) is attached to the air pressure regulator and traps condensation from the incoming air supply. The trap must be emptied when it becomes half full. DO NOT allow the trap to become full, or you risk serious damage to your machine.

With the system pressurized, pull the drain valve (see **Figure 72**) down to empty the collected water. Once a year, replace the internal white moisture filter.

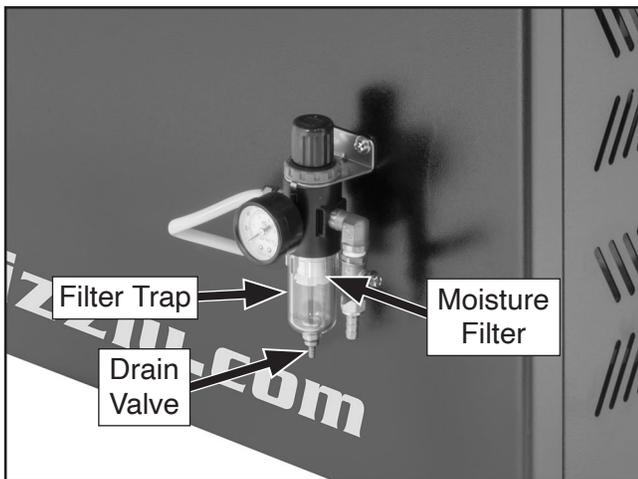


Figure 72. Filter trap components.

Cleaning Sanding Belt

To increase the working life of your sanding belts, clean them whenever they decrease in performance due to heavy loading of material. Use a cleaning pad like the one shown below.

D3003—PRO-STICK® 15" x 20" Sanding Pad

Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your sander to remove dust build-up from the sandpaper without damage. $\frac{3}{4}$ " thick.



Figure 73. D3003 PRO-STICK® 15" x 20" Sanding Pad.

To clean sanding belt:

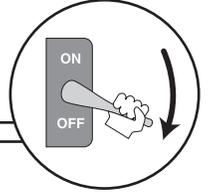
1. Set table elevation to thickness of cleaning pad.
2. Run pad through sander two or three times. DO NOT take too deep of a cut—belt should barely touch cleaning pad.



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
Touchscreen does not illuminate, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> Blown fuse. Incorrect power supply voltage or circuit size. Power supply circuit breaker tripped or fuse blown. Wiring broken, disconnected, or corroded. 	<ol style="list-style-type: none"> Replace fuse/ensure no shorts. Ensure correct power supply voltage and circuit size . Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. Fix broken wires or disconnected/corroded connections (Page 69).
Motors do not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> Safety fault engaged. Blown fuse. Incorrect power supply voltage or circuit size. Power supply circuit breaker tripped or fuse blown. Motor wires connected incorrectly. Thermal overload relay has tripped. Centrifugal switch needs adjustment/contact points dirty. Wiring broken, disconnected, or corroded. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> Use fault message to determine required action (Page 39). Replace fuse/ensure no shorts. Ensure correct power supply voltage and circuit size . Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. Correct motor wiring connections (Page 69). Reset relay. Adjust centrifugal switch/clean contact points. Fix broken wires or disconnected/corroded connections (Page 69). Replace motor.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> Motor wires connected incorrectly. Motor overheated. Centrifugal switch needs adjustment/contact points dirty. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> Correct motor wiring connections (Page 69). Clean motor, let cool, and reduce workload. Adjust centrifugal switch/clean contact points. Replace motor.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> Motor or component loose. Motor mount loose/broken. Motor fan rubbing on fan cover. Centrifugal switch needs adjustment. Motor bearings at fault. 	<ol style="list-style-type: none"> Replace damaged or missing bolts/nuts or tighten if loose. Tighten/replace. Fix/replace fan cover; replace loose/damaged fan. Adjust switch. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
View window light does not illuminate.	<ol style="list-style-type: none"> Wiring broken, disconnected, or corroded. 	<ol style="list-style-type: none"> Fix broken wires or disconnected/corroded connections (Page 69).



Operation

Symptom	Possible Cause	Possible Solution
Machine slows or is underpowered; stops under load.	<ol style="list-style-type: none"> 1. Workpiece material unsuitable for machine. 2. Feed rate too high. 3. Excessive depth of cut. 4. Sanding belt grit too fine for particular job. 5. Sanding belt clogged/worn. 6. V-belt(s) slipping/pulleys misaligned. 7. Pulley/sprocket slipping on shaft. 8. Conveyor gear or bearing at fault. 	<ol style="list-style-type: none"> 1. Only sand wood/ensure moisture is below 20% (Page 33). 2. Reduce feed rate (Page 36). 3. Reduce depth of cut (Page 32). 4. Replace with coarser grit sanding belt (Page 34). 5. Clean (Page 47)/replace (Page 34) sanding belt. 6. Clean/tension/replace V-belts(s) (Page 43); ensure pulleys are aligned. 7. Tighten/replace loose pulley/shaft. 8. Select appropriate gear ratio and replace broken or slipping gears; replace broken or slipping bearing.
Loud, repetitious noise/vibration coming from machine.	<ol style="list-style-type: none"> 1. Sanding belt seam open/damaged. 2. V-belt(s) worn, loose, pulleys misaligned or belt slapping cover. 3. Pulley loose. 4. Conveyor gear or bearing at fault. 	<ol style="list-style-type: none"> 1. Replace sanding belt (Page 34). 2. Inspect/replace belt(s) (Page 43). Realign pulleys if necessary. 3. Inspect pulleys. Replace or tighten if necessary. 4. Select appropriate gear ratio and replace broken or slipping gears; replace broken or slipping bearing.
Rounded workpiece edges.	<ol style="list-style-type: none"> 1. Excessive depth of cut. 	<ol style="list-style-type: none"> 1. Reduce depth of cut (Page 32).
Uneven thickness from left to right of board.	<ol style="list-style-type: none"> 1. Conveyor belt worn. 2. Sanding belt worn unevenly. 3. Conveyor table not parallel to sanding drum. 	<ol style="list-style-type: none"> 1. Replace conveyor belt (Page 63). 2. Feed workpieces across sanding belt to distribute wear evenly, not just on one side. 3. Adjust conveyor table parallelism (Page 59).
Workpiece slips on conveyor belt.	<ol style="list-style-type: none"> 1. Conveyor belt dirty. 2. Pressure rollers set too high. 3. Conveyor belt worn. 	<ol style="list-style-type: none"> 1. Clean conveyor belt. 2. Lower pressure rollers (Page 60). 3. Replace conveyor belt (Page 63).
Grooves down length of workpiece.	<ol style="list-style-type: none"> 1. Sanding belt dirty/damaged. 	<ol style="list-style-type: none"> 1. Clean (Page 47)/replace (Page 34) sanding belt.
Lines across width of workpiece.	<ol style="list-style-type: none"> 1. Sanding belt seam open/damaged. 	<ol style="list-style-type: none"> 1. Replace sanding belt (Page 34).
Glossy spots or streaks on workpiece.	<ol style="list-style-type: none"> 1. Feed rate too slow. 2. Using amp draw meter to establish material removal amount. 3. Worn sanding belt. 4. Rear pressure roller too low. 	<ol style="list-style-type: none"> 1. Increase feed rate (Page 36). 2. Use more accurate method to establish correct material removal amount (Page 32). 3. Replace sanding belt (Page 34). 4. Raise rear pressure roller (Page 60).
Sanding belt clogs quickly.	<ol style="list-style-type: none"> 1. Sanding belt grit too fine for particular job. 2. Excessive depth of cut. 3. Using amp draw meter to establish material removal amount. 4. Wood is too moist. 	<ol style="list-style-type: none"> 1. Replace with coarser grit sanding belt (Page 34). 2. Reduce depth of cut (Page 32). 3. Use more accurate method to establish correct material removal amount (Page 32). 4. Allow wood to dry to below 20% moisture content (Page 33).
Sanding belt does not tension correctly; drums slip under belt.	<ol style="list-style-type: none"> 1. Low air pressure. 2. Air leaks in system. 3. Belt tension cylinder shaft worn/damaged. 	<ol style="list-style-type: none"> 1. Adjust air pressure to 75 PSI at regulator. 2. Inspect all hoses and connections for leaking air; use water/soap mixture on suspected area to detect bubbles. 3. Repair/replace belt tension cylinder.



Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Sanding belt runs off to one side, stopping sander.	<ol style="list-style-type: none"> Oscillation speed/timing not adjusted correctly. Oscillation eye sensor or mirror dirty; pulse jet(s) incorrectly positioned. Solenoid valve/air manifold at fault. 	<ol style="list-style-type: none"> Adjust oscillation speed/timing (Page 53). Clean oscillation eye, mirror; adjust pulse jet positions (Page 54). Test/repair/replace.
Poor, non-aggressive sanding results.	<ol style="list-style-type: none"> Sanding belt clogged/worn. Sanding belt grit too fine for particular job. Conveyor table not parallel to sanding drum. 	<ol style="list-style-type: none"> Clean (Page 47) /replace (Page 34) sanding belt. Replace with coarser grit (Page 34). Adjust conveyor table parallelism (Page 59).
Sanding belt will not start, but table will move with power controls.	<ol style="list-style-type: none"> No air pressure to machine. Sanding belt not tensioned. 	<ol style="list-style-type: none"> Connect machine to compressed air system. Tension sanding belt.
Conveyor belt runs off to one side.	<ol style="list-style-type: none"> Conveyor belt tracking not adjusted correctly. 	<ol style="list-style-type: none"> Adjust conveyor belt tracking (Page 62).
Conveyor belt slipping.	<ol style="list-style-type: none"> Conveyor rollers contaminated with dirt or dust. Conveyor belt has incorrect tension. 	<ol style="list-style-type: none"> Clean conveyor rollers. Adjust conveyor rollers to place more tension on conveyor belt (Page 62).
Emergency brake stops slowly.	<ol style="list-style-type: none"> Low air pressure. Air leaks in system. Brake rotor contaminated with oil. Brake pads worn out. 	<ol style="list-style-type: none"> Adjust incoming air pressure to 75 PSI at regulator. Inspect hoses/connections for leaking air; use water/soap mixture on suspected area to detect bubbles. Clean brake rotor with automotive brake parts cleaner. Replace brake pads (Page 55).
Grinding noise when braking.	<ol style="list-style-type: none"> Brake pads worn out. 	<ol style="list-style-type: none"> Replace brake pads (Page 55); have machine shop turn/true rotor; replace rotor.
Air leaking from machine.	<ol style="list-style-type: none"> Compressed air release typical of pneumatic systems. Water filter/trap drain valve open. Air leaks in system. 	<ol style="list-style-type: none"> Unless there is clear evidence of air leak or performance problem with belt oscillation or braking speed, take no action. Air release sound is normal. Ensure water filter/trap drain valve is closed and tight (Page 47). Inspect hoses/connections for leaking air; use water/soap mixture on suspected area to detect bubbles.
Poor dust collection.	<ol style="list-style-type: none"> Dust collection lines sized incorrectly or dust collector too far away from machine. Dust collector underpowered. 	<ol style="list-style-type: none"> Redesign dust collection system. Upgrade dust collector.
Machine interior does not illuminate.	<ol style="list-style-type: none"> LED strip covered with dust. 	<ol style="list-style-type: none"> Clean LED strip.



Calibrating Workpiece Thickness Sensor

If the workpiece thickness sensor fails to adjust the table elevation to the thickness of your workpiece, the sensor may need to be calibrated.

Items Needed	Qty
Workpiece of Uniform Thickness	1
Hex Wrench 5mm.....	1
Open-End Wrench 10mm.....	1

To calibrate workpiece thickness sensor:

1. Place workpiece across conveyor table so part of it rests over peg shown in **Figure 74**.

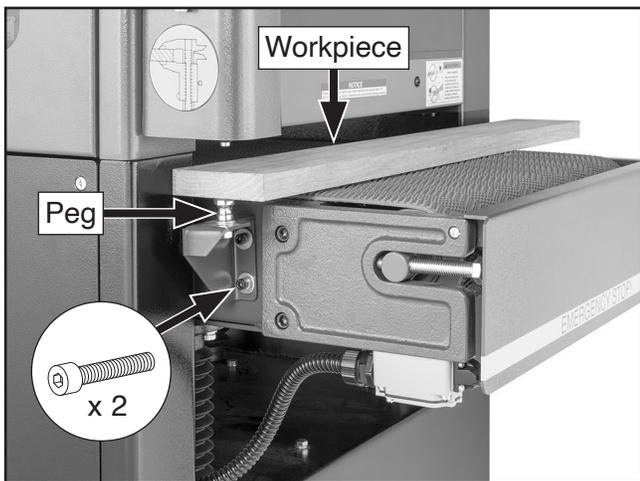


Figure 74. Workpiece resting on workpiece thickness peg.

- If workpiece is touching peg, and entire workpiece length is flat against conveyor belt, peg is even with conveyor table. Proceed to **Step 3**.
- If workpiece does not contact peg, or workpiece contacts peg, but entire workpiece length is not flat against conveyor belt, peg needs to be adjusted. Proceed to **Step 2**.

2. Loosen (2) cap screws shown in **Figure 74**, adjust peg so it touches workpiece without lifting any part of workpiece off of conveyor belt, then tighten cap screws to secure.
3. Reposition workpiece on conveyor table so part of it extends under workpiece thickness sensor and part of it extends under sanding drum (see **Figure 75**).

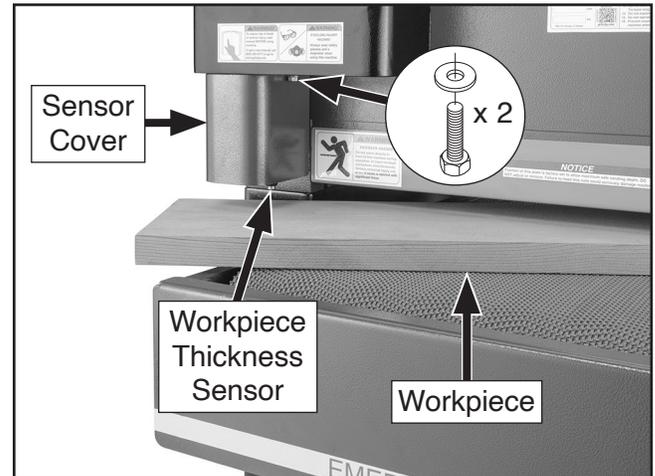


Figure 75. Workpiece under workpiece thickness sensor and sanding drum.

4. Press and hold table up button until workpiece triggers sensor or just touches sandpaper on sanding drum.
 - If workpiece triggers sensor and sandpaper *at the same time*, no further adjustment is required.
 - If workpiece triggers sensor *before* it contacts sandpaper, or workpiece contacts sandpaper *triggering sensor*, proceed to **Step 5**.
5. Remove (2) hex bolts and washers shown in **Figure 75** to remove sensor cover.



- Loosen (2) hex bolts shown in **Figure 76**.

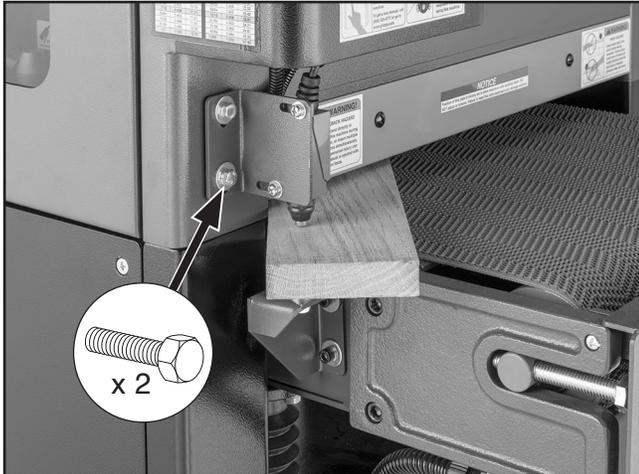


Figure 76. Workpiece thickness sensor calibration hex bolts.

- Adjust table elevation until workpiece just contacts sandpaper.
- Adjust workpiece thickness sensor (see **Figure 76**) until you hear it click against workpiece, then tighten hex bolts to secure position.
- Lower table, then repeat **Step 4** to check adjustment. When sensor is correctly calibrated, install sensor cover.

Calibrating Thickness Display

For the digital display to be accurate, it must be calibrated. We recommend calibrating the thickness display anytime you adjust the table elevation leadscrews.

Items Needed	Qty
2x4 (18" Long)	1
Digital Calipers	1

To calibrate thickness display:

- Sand planed 2x4 multiple times at the same table elevation until no sanding occurs when workpiece goes through sander.
- Measure workpiece thickness.
- Check thickness display (see **Figure 77**).
 - If display matches measurement taken in **Step 2**, no calibration is required.
 - If display *does not* match measurement taken in **Step 2**, proceed to **Step 4**.
- Use table up/down buttons to change adjust thickness value (see **Figure 77**) to match measurement taken in **Step 2**, then quickly hold calibration button.

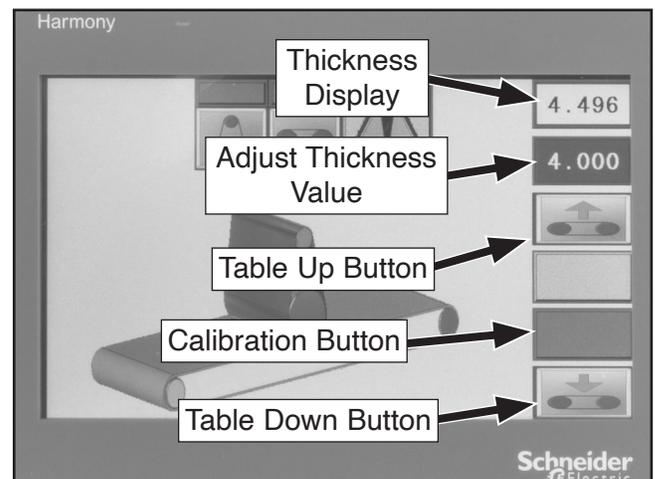


Figure 77. Location of thickness display calibration components.



Adjusting Belt Tracking Limit Switches

Sanding belt tracking limit switches are positioned on both sides of the sanding belt to act as emergency machine stops if the belt travels too far to one side or the other during oscillation (see **Figure 78**).

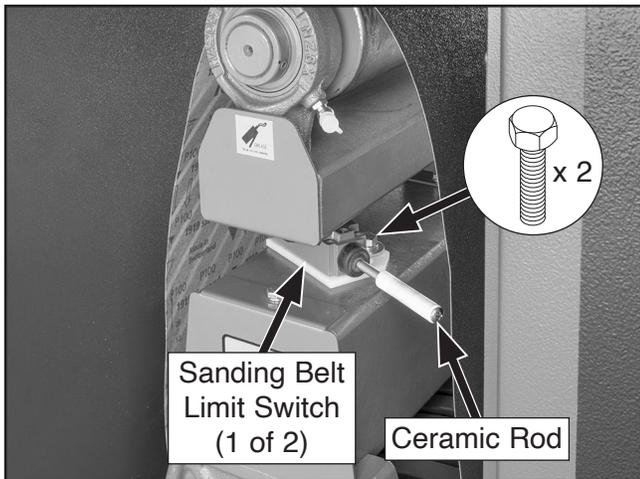


Figure 78. Limit switch adjustment components.

Tool Needed	Qty
Wrench or Socket 12mm	1

To adjust belt tracking limit switches:

1. Make sure sanding belt oscillation is adjusted properly (see **Adjusting Oscillation Speed/Timing** on **Page 53**).
2. **DISCONNECT MACHINE FROM POWER!**
3. Release belt tension, center sanding belt on roller, then apply tension to belt.
4. Measure distance between edge of sanding belt to limit switch ceramic rods (see **Figure 78**).
5. Loosen adjustment bolts shown in **Figure 78**, move switches so belt and rods are about 1/4" apart, then tighten bolts to secure.
6. Start machine and make sure limit switches are working properly.

Adjusting Oscillation Speed/Timing

The sanding belt oscillation speed/timing is adjustable and controlled by knobs on a pneumatic cylinder (see **Figure 79**). The control knob on the right affects the sanding belt travel as it moves right, and the control knob on the left affects the belt travel as it moves left. The goal is to adjust these knobs so it takes the same amount of time (approximately 2–3 seconds) for the sanding belt to travel in each direction as it oscillates.

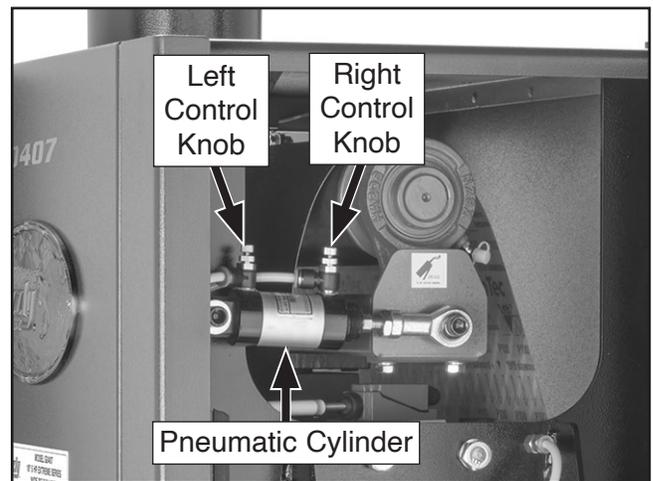


Figure 79. Oscillation adjustment components.

Different oscillation speeds yield different sanding results. We recommend trying various speeds on a scrap piece of wood similar to the workpiece being used. The oscillation speed is measured by how long it takes the belt to move from one side to the other.

Tool Needed	Qty
Flat Head Screwdriver 1/4"	1



To adjust oscillation speed/timing:

1. DISCONNECT MACHINE FROM POWER!
2. Open right door.
3. Loosen knurled jam nut (see **Figure 80**) that corresponds to oscillation direction you wish to adjust.
 - Right speed control knob and jam nut control oscillation speed as belt moves right.
 - Left speed control knob and jam nut control oscillation speed as belt moves left.
4. Rotate speed control knob (see **Figure 80**) clockwise to decrease oscillation speed, or counterclockwise to increase oscillation speed, then tighten jam nut to secure.

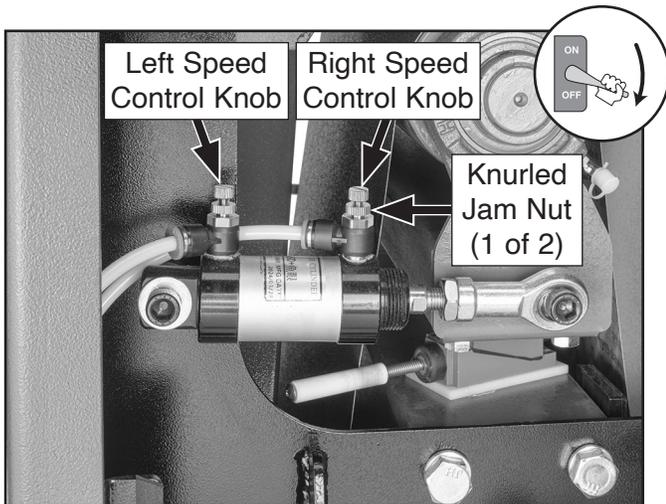


Figure 80. Oscillation speed controls.

5. Repeat **Steps 3–4** for other speed control knob.
6. Close and secure right door.
7. Connect machine to power, turn **ON** sanding belt, and watch oscillation settings through view window. Repeat **Steps 1–5** as needed until oscillation speed is equal in both directions and you are satisfied.

Adjusting Pneumatic Pulse Jets

The pneumatic pulse-jet cleaning system is designed to keep the oscillation system electronic eye and mirror dust-free. However, if the pulse jets are knocked out of position (most likely by the operator or by a loose sanding belt), they will stop automatically cleaning the sensor and the mirror. A dirty eye or mirror could cause the belt to track toward the sensor and into the limit switch without switching directions while oscillating.

Items Needed

Qty

Open-End Wrench 8mm.....	1
Soft Cloth.....	1

To adjust pneumatic pulse jets:

1. DISCONNECT MACHINE FROM POWER!
2. Open right door.
3. Loosen hex nut on each pulse jet shown in **Figure 81**.
4. Wipe off eye and mirror, and adjust aim of upper pulse jet so it points directly at electronic eye sensor and adjust lower pulse jet so it points at center of mirror (see **Figure 81**).

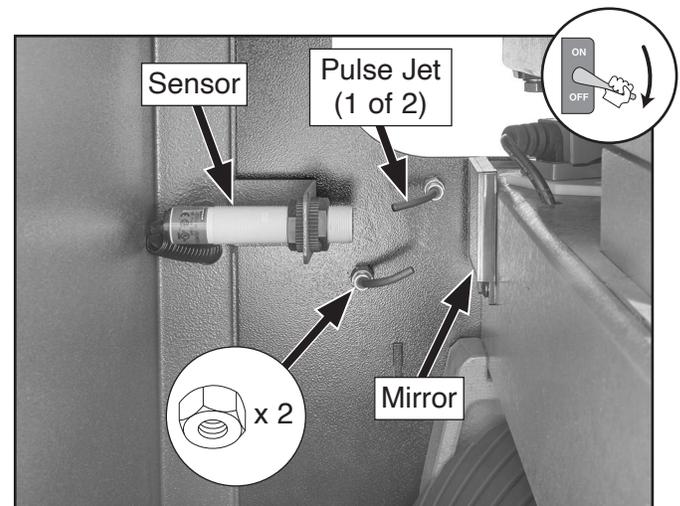


Figure 81. Pulse jets aimed correctly at eye and mirror.

5. Tighten hex nuts without moving pulse jets, then close and secure right door.



Checking/Replacing Brake Pads

The disc brake assembly uses brake pads to stop the rotor (see **Figure 82**) when the EMERGENCY STOP button is pressed, the EMERGENCY STOP! bar is pressed, or if one of the belt tracking limit switches is activated. Eventually, the brake pads will wear out. Both the inner and outer brake pads should be changed at the same time.

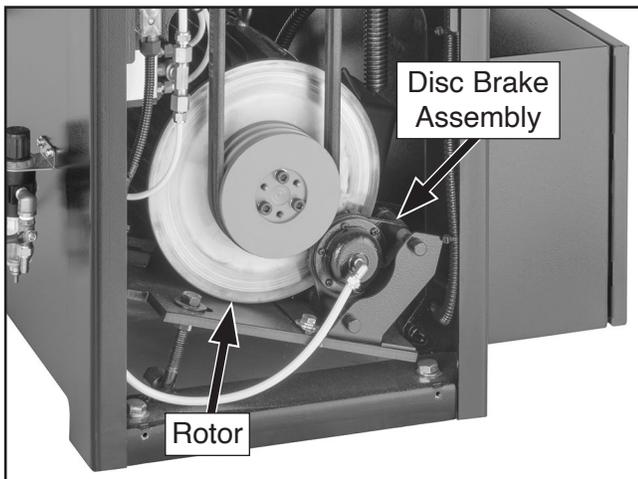


Figure 82. Location of disc brake assembly and rotor.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Fine Ruler	1
Open-End Wrench 14mm.....	1
Hex Wrenches 4, 5mm.....	1 Ea.
Brake Pads (P04070302)	2

To check/replace brake pads:

1. DISCONNECT MACHINE FROM POWER!
2. Disconnect machine from air, then release all air pressure in machine by opening air valve on regulator (see **Figure 83**). This will cause disc brake assembly to open, allowing removal.

3. Remove (4) screws shown in **Figure 83** to remove right access panel.

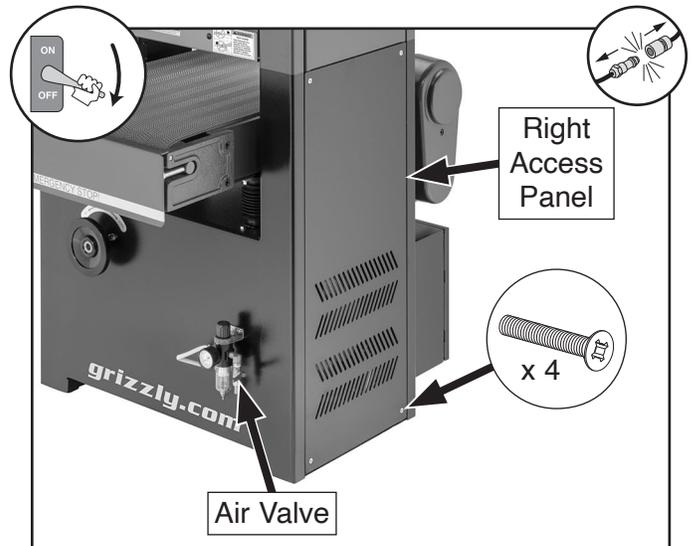


Figure 83. Location of air valve and right access panel.

4. Measure thickness of each brake pad. Brake pads consist of a metal plate with a composite pad. Measure thickness of composite pads only (see **Figure 84**).
 - If thickness of each pad is greater than $\frac{1}{8}$ ", pads do not need to be replaced. Proceed to **Step 14**.
 - If thickness of either pad is less than $\frac{1}{8}$ ", proceed to **Step 5** to replace both pads.

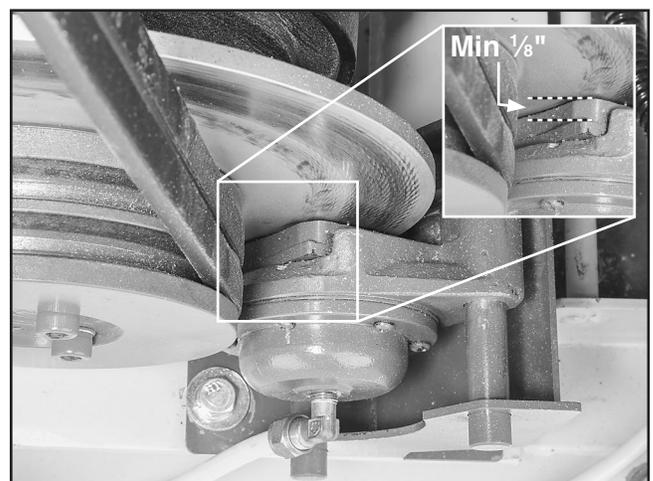


Figure 84. Example of brake pad to measure (outer brake pad shown).



- Loosen compression nut shown in **Figure 85**, then remove air line.
- Remove (2) hex nuts, lock washers, and studs that secure disc brake assembly to mount (see **Figure 85**).

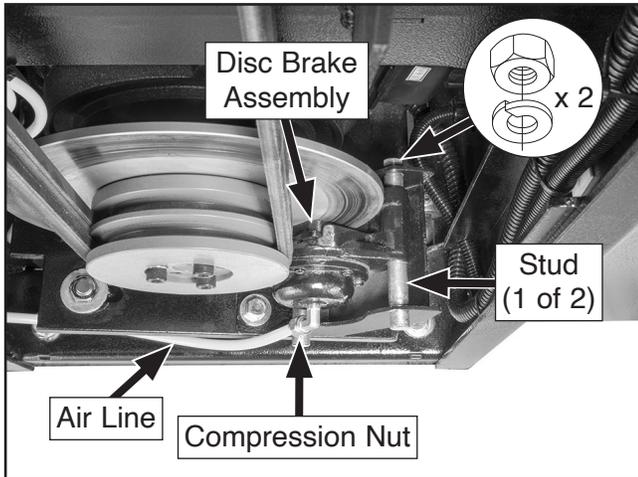


Figure 85. Disc brake assembly removal components.

- Lift disc brake assembly out of mount.
- Remove (6) Phillips head screws shown in **Figure 86** to remove diaphragm cover and diaphragm (see **Figure 87**) from disc brake assembly.

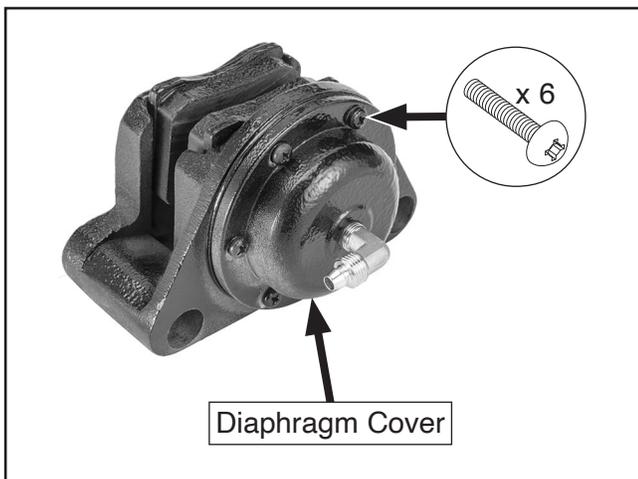


Figure 86. Location of diaphragm cover and screws.

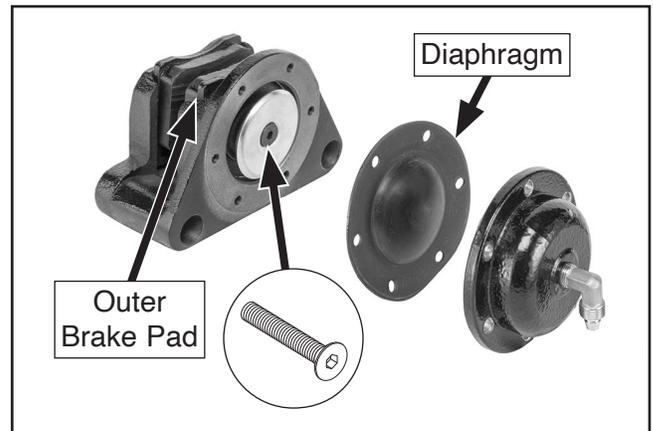


Figure 87. Diaphragm removed from disc brake assembly.

- Remove diaphragm plate flat head cap screw (see **Figure 87**) to remove diaphragm plate, compression spring, bushing, and outer brake pad (see **Figure 87–Figure 88**).

Note: *Be careful when removing these components. They are under pressure from compression spring and could fly apart unexpectedly.*

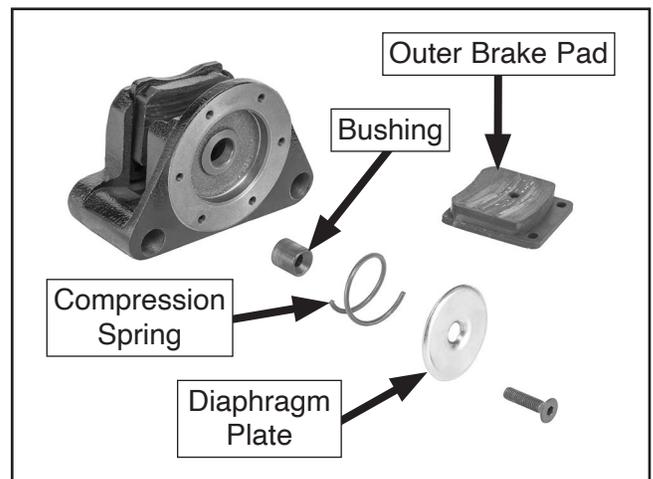


Figure 88. Outer brake pad components.

- Install new outer brake pad and secure with bushing, spring, diaphragm plate, and flat head cap screw. Make sure to install components in same order and orientation as they were removed (see **Figure 88**).

Note: *Countersunk end of bushing should face diaphragm plate (see **Figure 88**).*



11. Install diaphragm, diaphragm cover, and screws removed in **Step 8**.
12. Remove inner brake pad cap screw, then remove inner brake pad (see **Figure 89**).

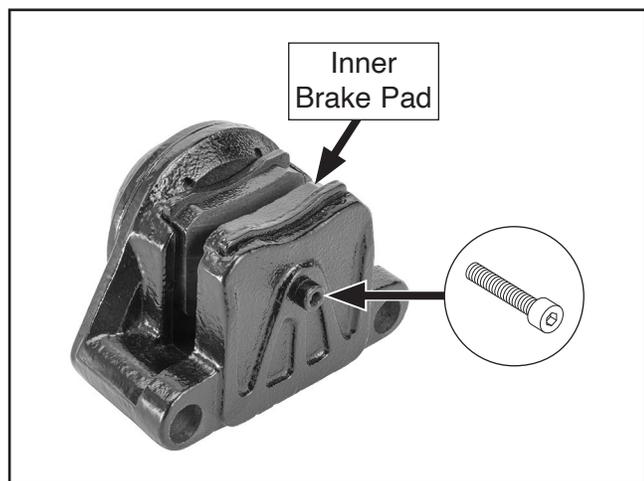


Figure 89. Location of inner brake pad and cap screw.

13. Install new inner brake pad and secure with cap screw removed in **Step 12**.
14. Place disc brake assembly back in mount, placing brake pads around rotor (see **Figure 85** on **Page 56**), then secure with studs, lock washers, and hex nuts removed in **Step 6**.
15. Install air line, then secure with compression nut from **Step 5**.
16. Install right access panel and secure with screws removed in **Step 3**.
17. Connect air supply to air regulator and machine to power, then start sander and test EMERGENCY STOP system to make sure brake functions properly.

Checking/Adjusting Table Parallelism

Table parallelism has been adjusted at the factory and should not require adjustments when the machine is new.

We only recommend adjusting table parallelism if absolutely necessary due to factors that may cause the factory settings to change. Adjusting the table parallelism can take a fair amount of patience.

IMPORTANT: DO NOT adjust the table unless you are having trouble sanding your workpiece to a uniform thickness and have eliminated all other possible causes. For instance, a sanding or conveyor belt that is unevenly worn should be replaced before adjusting table parallelism.

The four corners of the table can be independently adjusted up or down to achieve parallelism with the frame by adjusting the elevation leadscrew flanges or repositioning the table elevation leadscrew sprockets (see **Figure 90**).

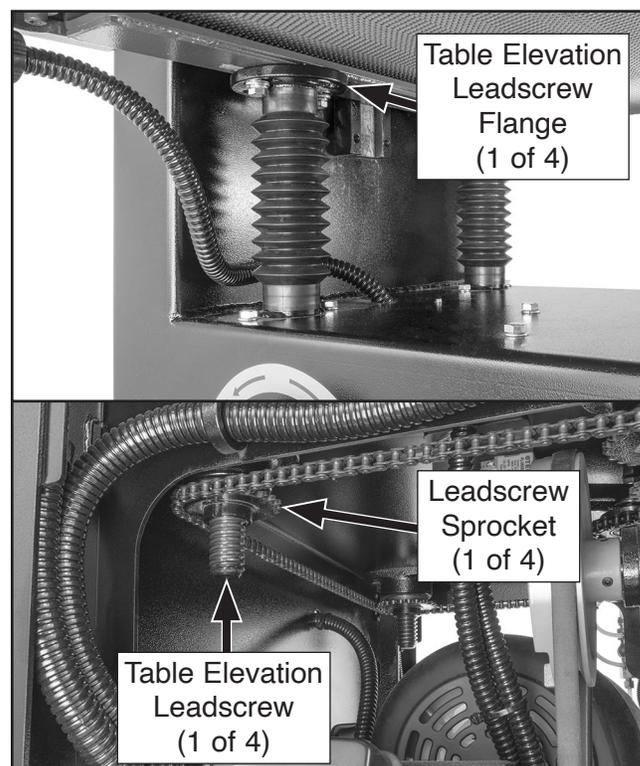


Figure 90. Location of table elevation adjustment components.



If a table adjustment is needed, mark the original positions of the table elevation flanges, sprockets, and leadscrews. This will allow the original setting to be restored if needed.

Items Needed	Qty
Vacuum Cleaner.....	1
Shop Rags.....	As Needed
Wood Block (Approx. 4" Long)	1
Fine Ruler or Calipers	1
Open-End Wrenches 12, 14mm	1 Ea.
Phillips Head Screwdriver #2	1
White Marker or Correction Fluid	As Needed

Checking Table Parallelism

1. DISCONNECT MACHINE FROM POWER!
2. Clean table and frame at each corner so sawdust will not interfere with measurements during following steps.
3. Connect machine to power, then adjust table elevation until table is approximately 6" below sanding belt.
4. Take precise measurement (within 0.001") of 4" long wood block and record measurement.
5. Place wood block on edge of table at rear left corner, then raise table until wood block just touches upper frame (see **Figure 91**). Do not allow table to squeeze or compress wood block.

Note: Make sure wood block does not touch conveyor belt.

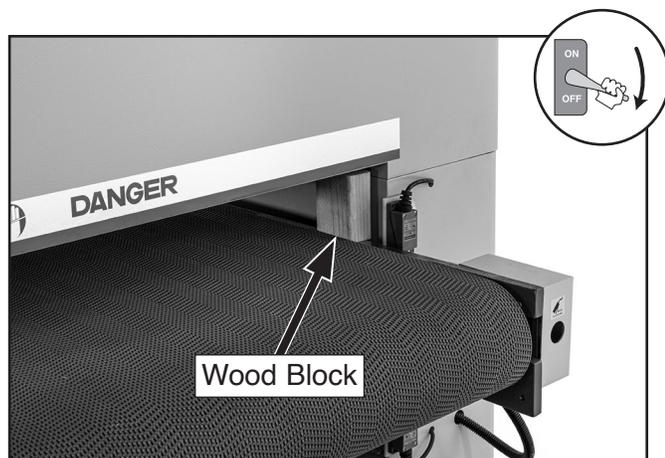


Figure 91. Example of wood block placed for checking table parallelism.

6. Take precise measurements between edge of conveyor table and upper frame at each of the remaining (3) corners (see **Figure 92**).

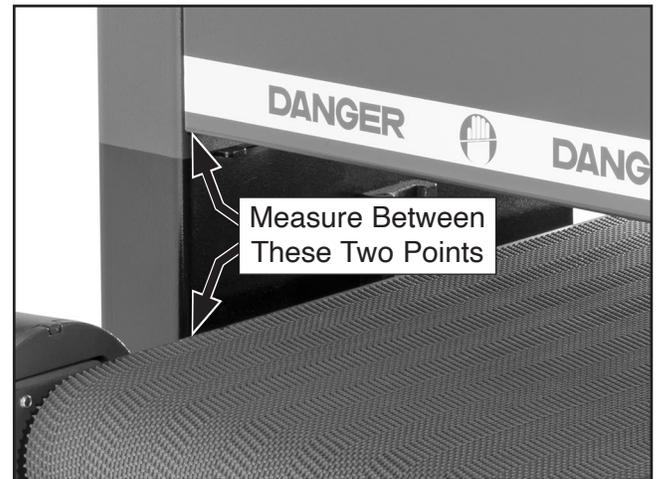


Figure 92. Distance to measure at rear right corner.

Note: When measuring at front right and left corners, measure from upper frame; DO NOT measure from safety plate (see **Figure 93**).

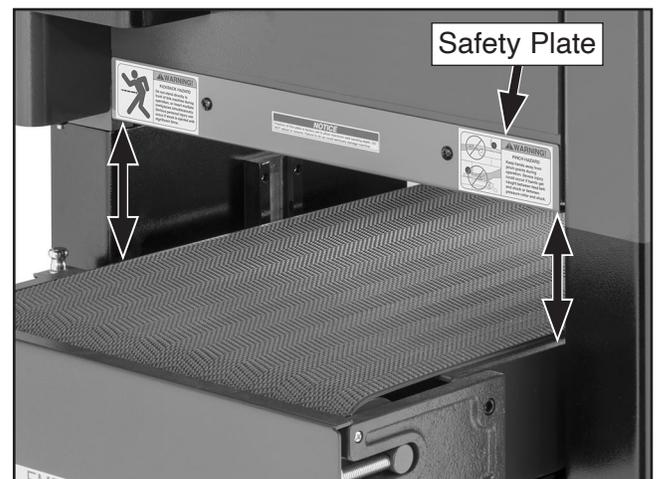


Figure 93. Distance to measure at front right and front left corners.

- If measurement at each corner is exactly the same as measurement of wood block taken in **Step 4**, table is parallel to frame and no adjustment is necessary. Remove wood block.
- If measurement at *any* corner is *not* exactly the same as measurement of wood block taken in **Step 4**, table is not parallel to frame. DO NOT remove wood block and proceed to **Adjusting Table Parallelism** on **Page 59**.



Adjusting Table Parallelism

1. Check table parallelism (refer to **Checking Table Parallelism**) to confirm table needs adjustment before proceeding.

2. DISCONNECT MACHINE FROM POWER!

3. With wood block still positioned at rear left corner of conveyor table, locate elevation leadscrew flange (see **Figure 94**) at corner that needs to be adjusted.

4. Loosen (2) hex bolts on flange (see **Figure 94**). Rotate flange a small amount to adjust that corner of table until it is within 0.003" of measurement of wood block taken in **Checking Table Parallelism**.

— Rotate flange clockwise (from below) to raise corner.

— Rotate flange counterclockwise (from below) to lower corner.

Note: Each flange can be adjusted for up to 0.015" of table height adjustment.

Tip: It may help to rotate flange with vise grip if it is difficult to move.

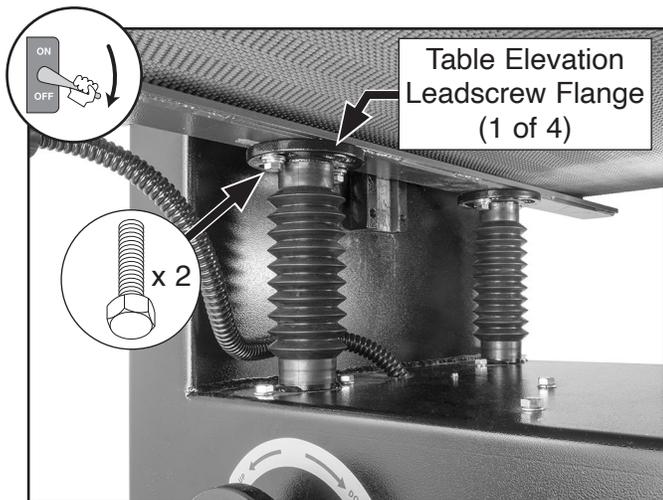


Figure 94. Example of table flange components.

5. Tighten hex bolts to secure adjustment.

6. Repeat **Steps 3–5** for any remaining corners that need adjustment.

— If adjusting flanges brought all table corners to same distance from upper frame, table is parallel and no further adjustment is necessary. Remove wood block.

— If any corner is still higher or lower than corner with wood block by more than 0.003", you will need to adjust elevation leadscrew sprocket for that corner. Proceed to **Step 7**.

7. Remove (8) screws shown in **Figure 95** to remove left and right access panels.

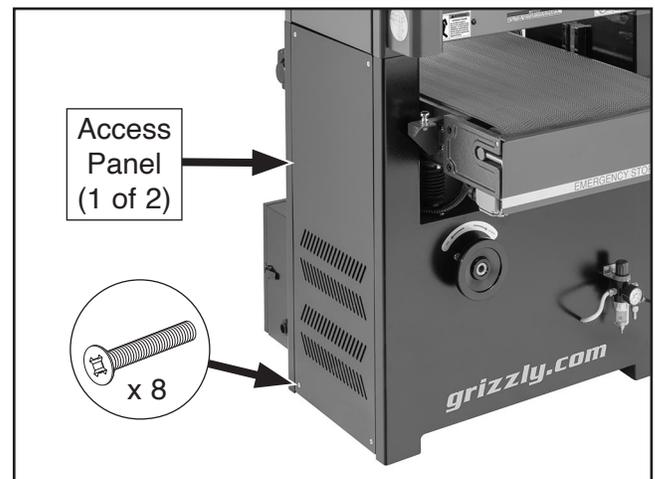


Figure 95. Location of access panels and securing screws.

8. Mark one tooth of table elevation leadscrew sprocket (see **Figure 96**) that you need to adjust, and its location on frame.

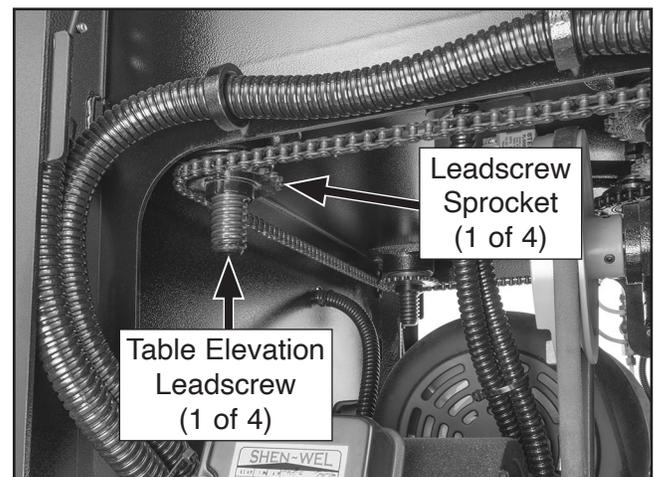


Figure 96. Location of table elevation leadscrew sprockets.



9. On table elevation chain tensioner, loosen sprocket nut on sprocket wheel shaft, and jam nut (see **Figure 97**).
10. Push sprocket adjustment rod (see **Figure 97**) away from table elevation motor to loosen chain tension.

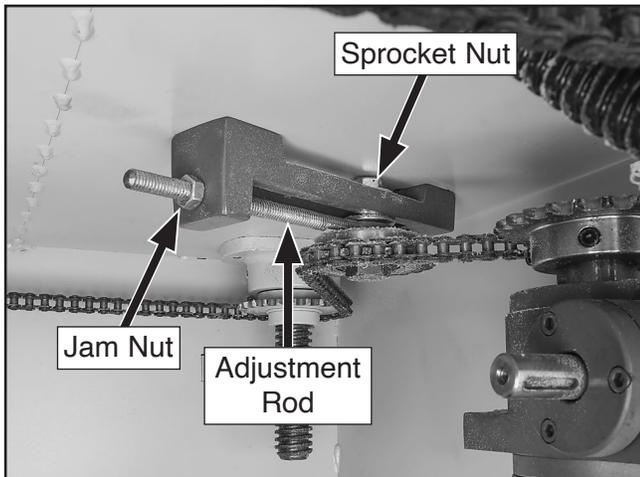


Figure 97. Table elevation chain tensioner components.

11. Remove chain from sprocket you want to adjust so only that sprocket can be moved independent of chain.
12. Carefully rotate sprocket just enough to position next tooth at marked location from **Step 8**, then fit chain around sprocket again.
 - Rotate sprocket clockwise (from below) to raise corner of table.
 - Rotate sprocket counterclockwise (from below) to lower corner of table.
13. Pull sprocket adjustment rod toward table elevation motor until chain is moderately tight, then tighten sprocket nut and jam nut to secure.
14. Check table parallelism (refer to **Checking Table Parallelism** on **Page 58**). If necessary, repeat these steps to further adjust table elevation leadscrew sprockets until all corners of table are same distance from upper frame.
15. Install access panels and remove wood block.

Adjusting Pressure Rollers

The pressure rollers have been adjusted at the factory and should not require routine adjustments.

Ideally, the pressure rollers should be positioned slightly lower than the sanding drum. However, we recommend verifying this setting. If the pressure rollers are incorrectly adjusted, you can end up with burned sanding belts, streaking, and poor workpiece results.

Pressure Roller Setting Below Sanding Drum

Infeed.....	0.035"
Outfeed.....	0.035"

Items Needed

	Qty
Phillips Head Screwdriver #2	1
2x4 (3' Long).....	1
Open-End Wrenches 14mm.....	2

To adjust pressure rollers:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (4) screws shown in **Figure 98** to remove right access panel.

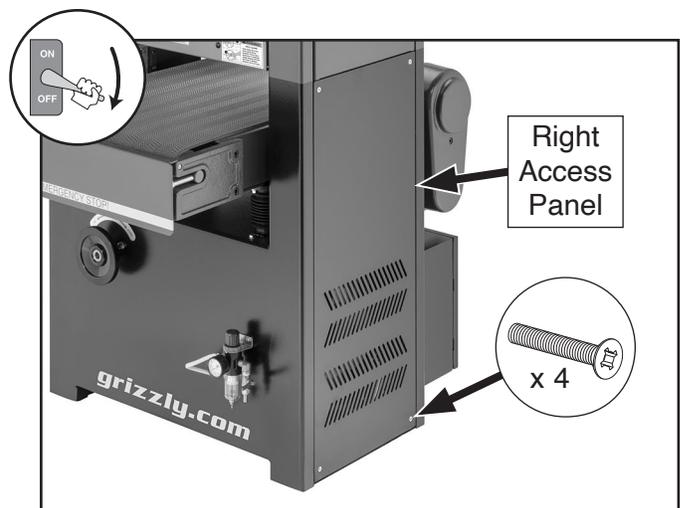


Figure 98. Location of right access panel and screws.

3. Open left and right doors.
4. Remove sanding belt.



5. Remove V-belts from sanding belt pulley (refer to **Checking/Adjusting V-Belt Tension** on **Page 43**).
6. Plane 3' long 2x4 to uniform thickness and cut it in half to make (2) 18" long pieces.
7. Place one board along length of conveyor belt on right side, and place other board on left side, as shown in **Figure 99**.



Figure 99. Example of 2x4s placed on conveyor belt under sanding drum.

8. Move sanding drum by hand, and use handwheel to raise table until you hear wood just contact surface of drum.

Note: *DO NOT continue to raise table beyond this point.*

9. Connect machine to power, and press table down button seven times to lower table 0.035". This is how much lower infeed and outfeed pressure rollers should be compared to sanding surface of sanding drum.

10. DISCONNECT MACHINE FROM POWER!

11. Loosen jam nuts on infeed pressure rollers, rotate adjustment nuts (see **Figure 100–Figure 101**) to adjust infeed pressure rollers until they just touch boards, then tighten jam nuts to secure.

- Rotate adjustment nut clockwise (from above) to raise pressure rollers.
- Rotate adjustment nut counterclockwise (from above) to lower pressure rollers.

Note: *DO NOT continue to lower pressure rollers beyond this point.*

12. Repeat **Step 11** for outfeed pressure rollers (see **Figure 100–Figure 101**).

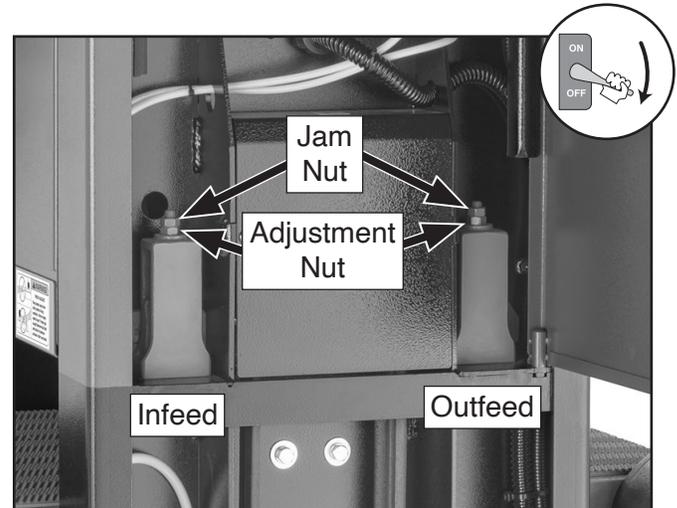


Figure 100. Location of pressure roller adjustment components (right side).

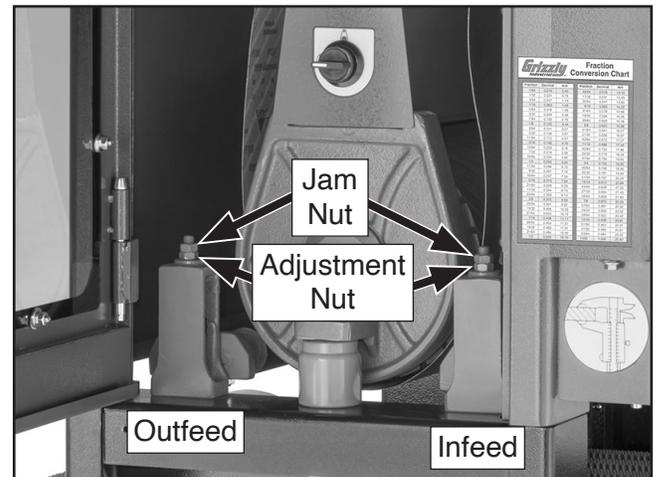


Figure 101. Location of pressure roller adjustment components (left side).

Note: *Variables such as feed rate, depth of cut, and type of sanding belt can play a part in determining proper amount of downward pressure exerted by rollers. Some experimentation may be necessary to achieve desired results. However, under no circumstances should pressure rollers be set even with, or higher than, sanding drum.*

13. Install V-belts and desired sanding belt.
14. Lower table and remove 2x4s.
15. Close left and right door and install right access panel.



Adjusting Conveyor Belt Tension

The conveyor belt tension has been adjusted at the factory and should require no further attention. However, over time the belt will stretch, so adjust the conveyor belt tension if you notice that your conveyor belt is slipping or is tracking off center.

The conveyor belt tension is adjusted by rotating two adjustment bolts, located on each side of the conveyor table (see **Figure 102**).

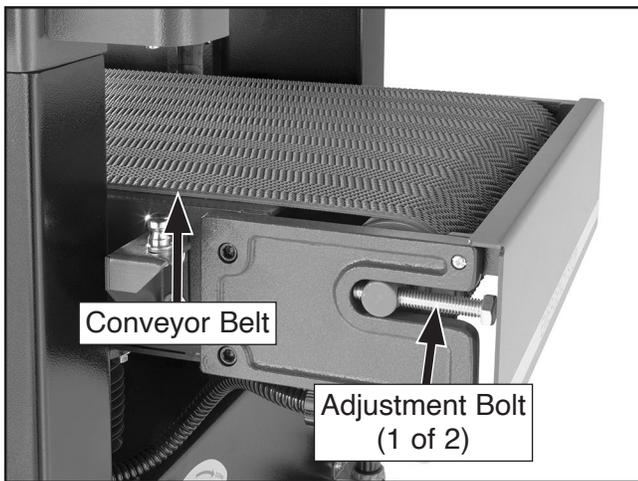


Figure 102. Location of conveyor belt adjustment bolts.

Tool Needed	Qty
Open-End Wrench 19mm.....	1

To adjust conveyor belt tension:

1. DISCONNECT MACHINE FROM POWER!
2. Rotate both left and right adjustment bolts (see **Figure 102**) equally to adjust conveyor belt tension. When tensioned properly, you should not be able to lift conveyor belt off of table or slide it back and forth.
 - Rotate adjustment bolts clockwise to *increase* conveyor belt tension.
 - Rotate adjustment bolts counterclockwise to *decrease* conveyor belt tension.

Adjusting Conveyor Belt Tracking

The conveyor belt is tracking properly when it stays centered on its rollers during operation and does not wander from side to side. The tracking is adjusted by rotating either the left or right conveyor or belt tension adjustment bolt (see **Figure 102**), depending on the needs of the adjustment.

In addition, two guide wheels (see **Figure 103**) protect the conveyor belt from damage if the tracking is out of adjustment, by preventing it from rubbing against the inside surfaces of the conveyor table.

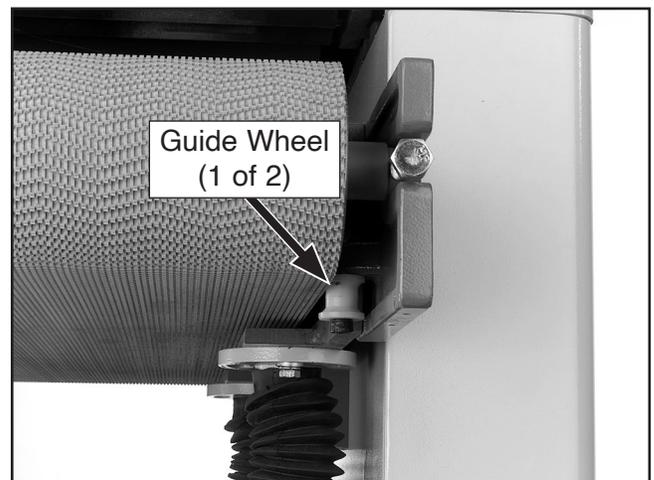


Figure 103. Location of conveyor belt guide wheels (safety guard removed for clarity).

NOTICE

Adjust conveyor belt tension before adjusting conveyor belt tracking.

Tool Needed	Qty
Open-End Wrench 19mm.....	1



To adjust conveyor belt tracking:

1. Turn conveyor belt **ON**.
 - If conveyor belt is tracking *right*, rotate right adjustment bolt (see **Figure 104**) clockwise.
 - If conveyor belt is tracking *left*, rotate left adjustment bolt (see **Figure 104**) clockwise.

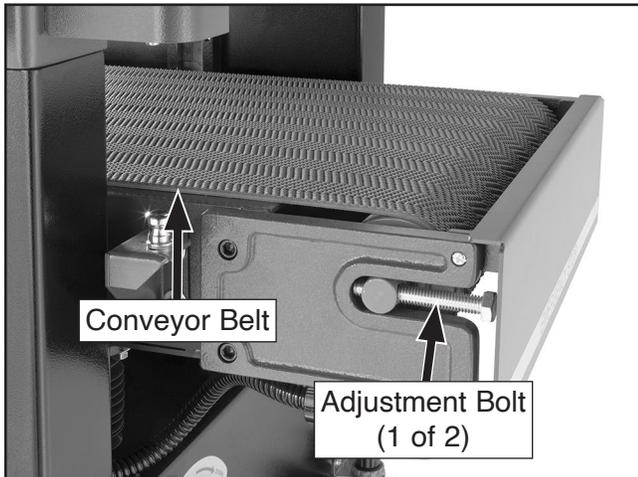


Figure 104. Location of conveyor belt adjustment bolts.

2. Run conveyor belt for 3–5 minutes while you observe tracking.
3. Repeat **Steps 1–2** as necessary until conveyor belt is properly tracking.

Note: Edge of conveyor belt should just touch guide wheels shown in **Figure 103** on **Page 62**.

Replacing Conveyor Belt

Replace the conveyor belt if it becomes damaged or you are not able to adjust the conveyor belt tracking due to excessive wear (refer to **Adjusting Conveyor Belt Tracking**, beginning on **Page 62**).

Note: The diagram shown on **Page 66** illustrates the steps in the following procedure.

Items Needed	Qty
Hex Wrenches 4, 5, 8, 12mm	1 Ea.
Wrenches or Sockets 10, 12, 14, 19mm.....	1 Ea.
Additional Person	1
Phillips Head Screwdriver #2	1
Marker	1
2x4 (4' Long).....	2
Replacement Conveyor Belt (P04072102)	1

To replace conveyor belt:

1. Adjust table elevation so conveyor belt is approximately 2" away from sanding drum, then **DISCONNECT MACHINE FROM POWER!**
2. Remove cap screw shown in **Figure 105** to remove chain cover.

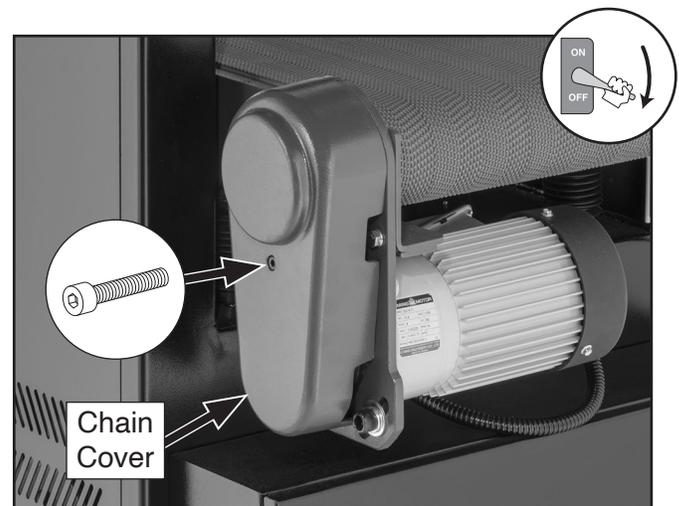


Figure 105. Location of chain cover and screw.



- Remove chain from sprockets (see **Figure 106**) (refer to **Changing Feed Rate** on **Page 36**).
- Loosen (2) set screws shown in **Figure 106**, then slide conveyor roller sprockets off of shaft.
- With help from an assistant, remove (4) hex bolts and lock washers shown in **Figure 106** to remove feed motor assembly from conveyor table.

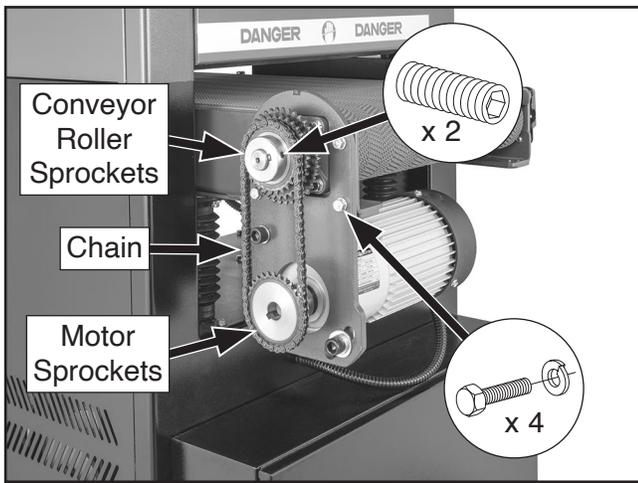


Figure 106. Feed motor assembly removal components.

- Remove (4) hex bolts, lock washers, and flat washers shown in **Figure 107** to remove table elevation limit switches.

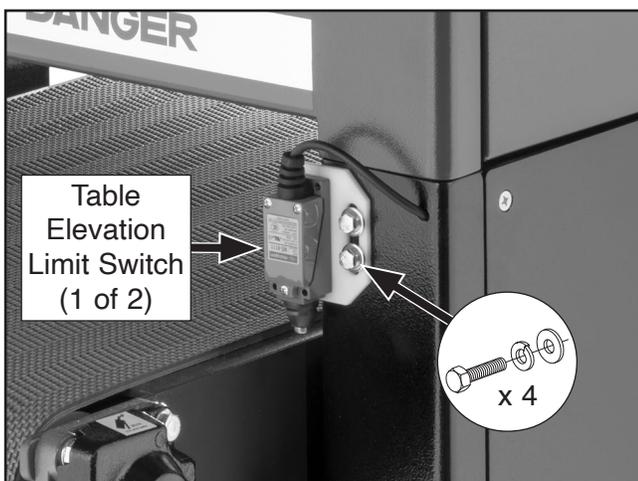


Figure 107. Location of table elevation limit switches and securing fasteners.

- Remove (8) screws shown in **Figure 108** to remove access panels.

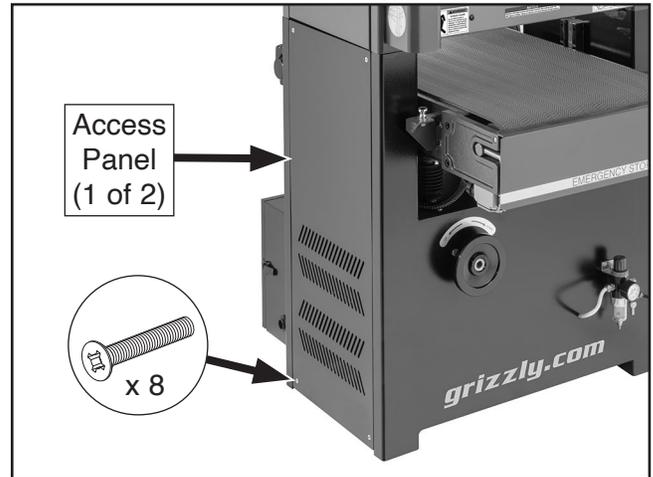


Figure 108. Location of access panels and securing screws.

- Remove (8) hex bolts and washers shown in **Figure 109** to remove left and right table guides (see **Figure 110**).

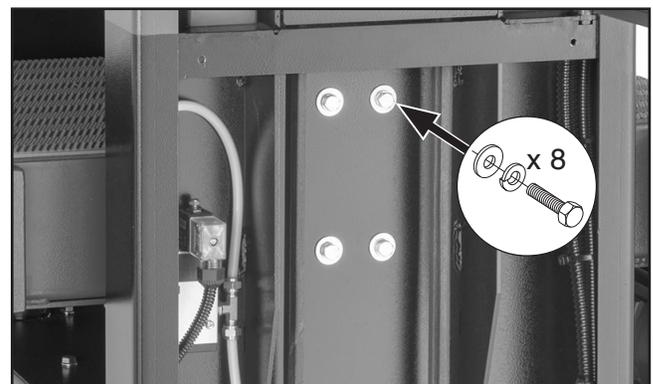


Figure 109. Location of table guide hex bolts and lock washers.

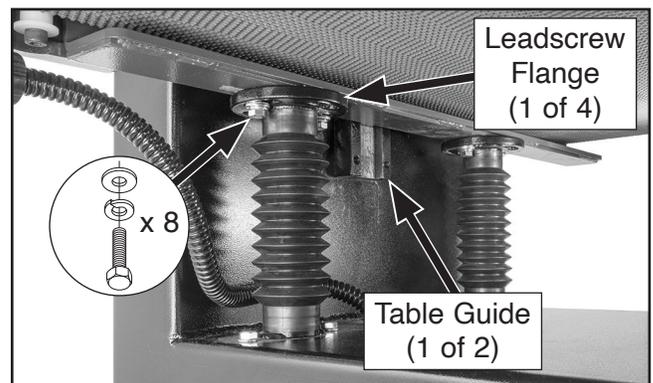


Figure 110. Location of table guides and leadscrew flanges.

- Mark all four leadscrew flange positions, then remove all hex bolts and washers from flanges (see **Figure 110**). Try not to turn flanges during following steps.



10. Remove (4) Phillips head screws shown in **Figure 111** to remove EMERGENCY STOP! bar and limit switch from front of conveyor table.
11. Remove (2) cap screws and washers shown in **Figure 111** to remove peg assembly.

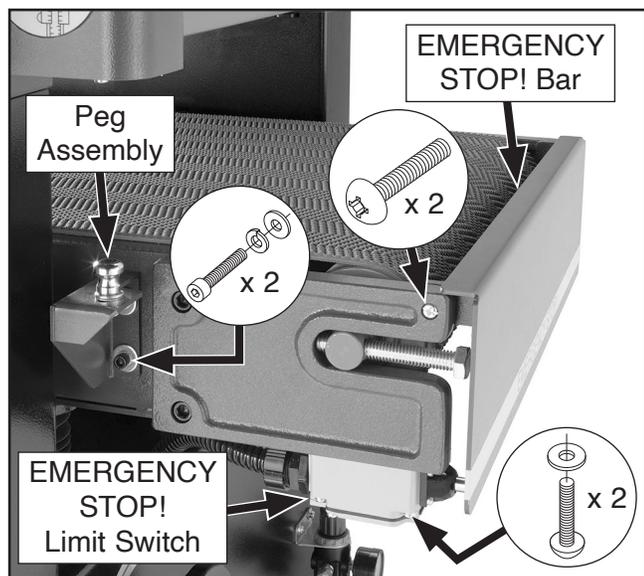


Figure 111. Front table components to remove.

12. Place (2) 4' long 2x4s under table for support, then have assistant help lift table slightly and move it out of rear of machine.
13. Turn both conveyor belt adjustment bolts counterclockwise five turns, remove one roller support, and slide front conveyor roller out of table assembly (see **Figure 112**).

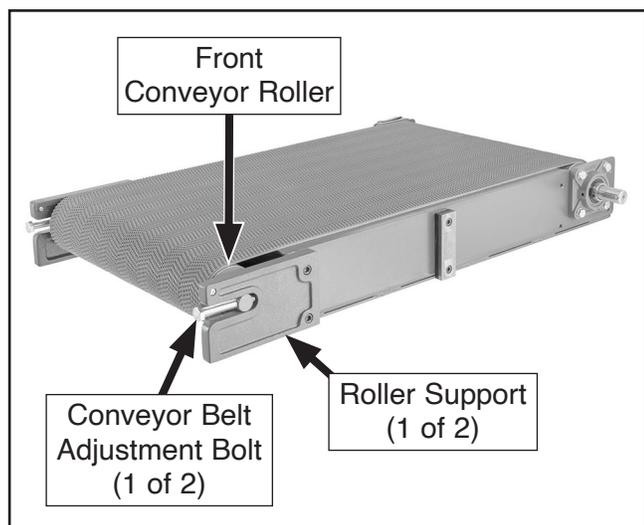
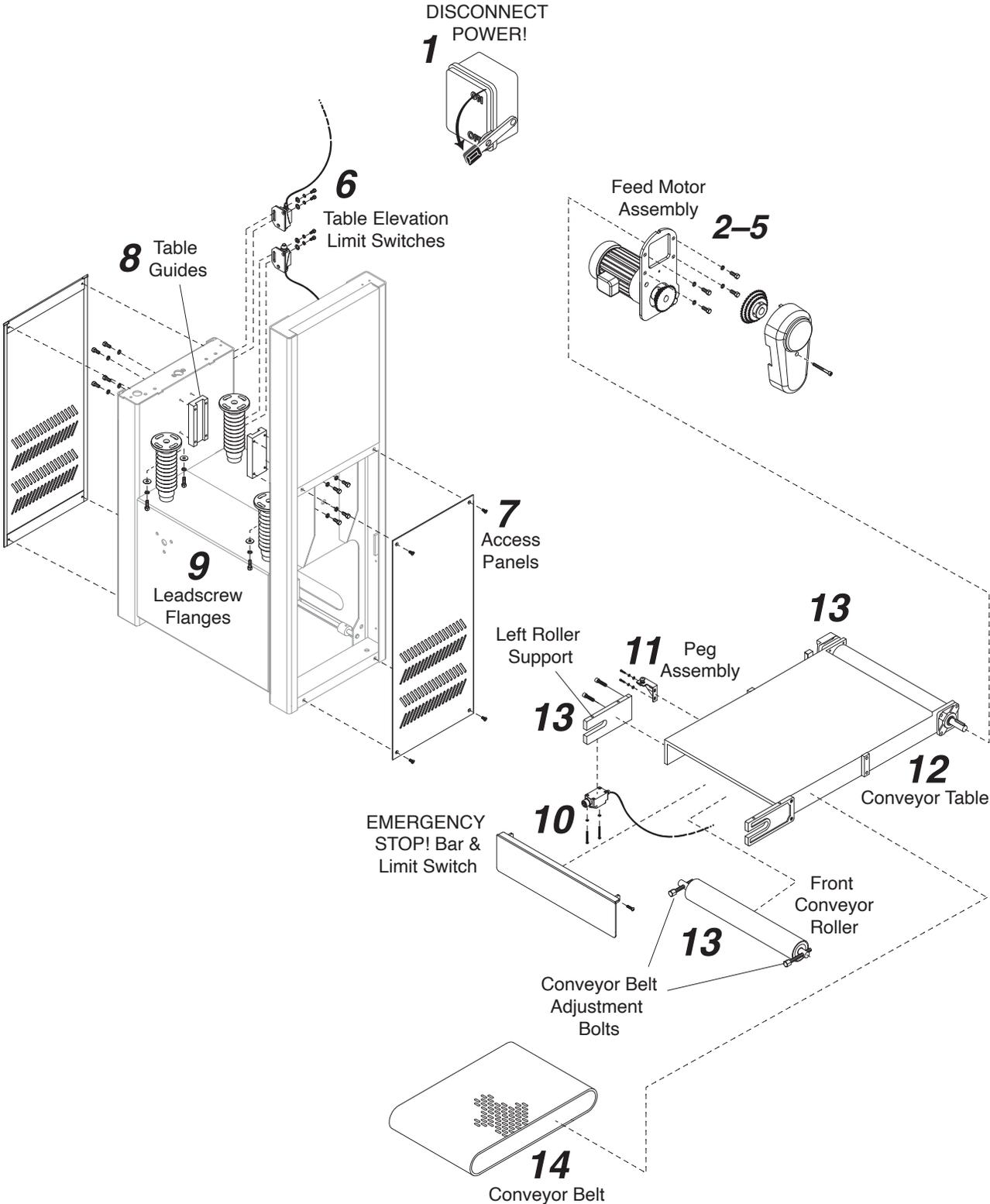


Figure 112. Location of conveyor belt adjustment bolts, roller supports, and conveyor roller.

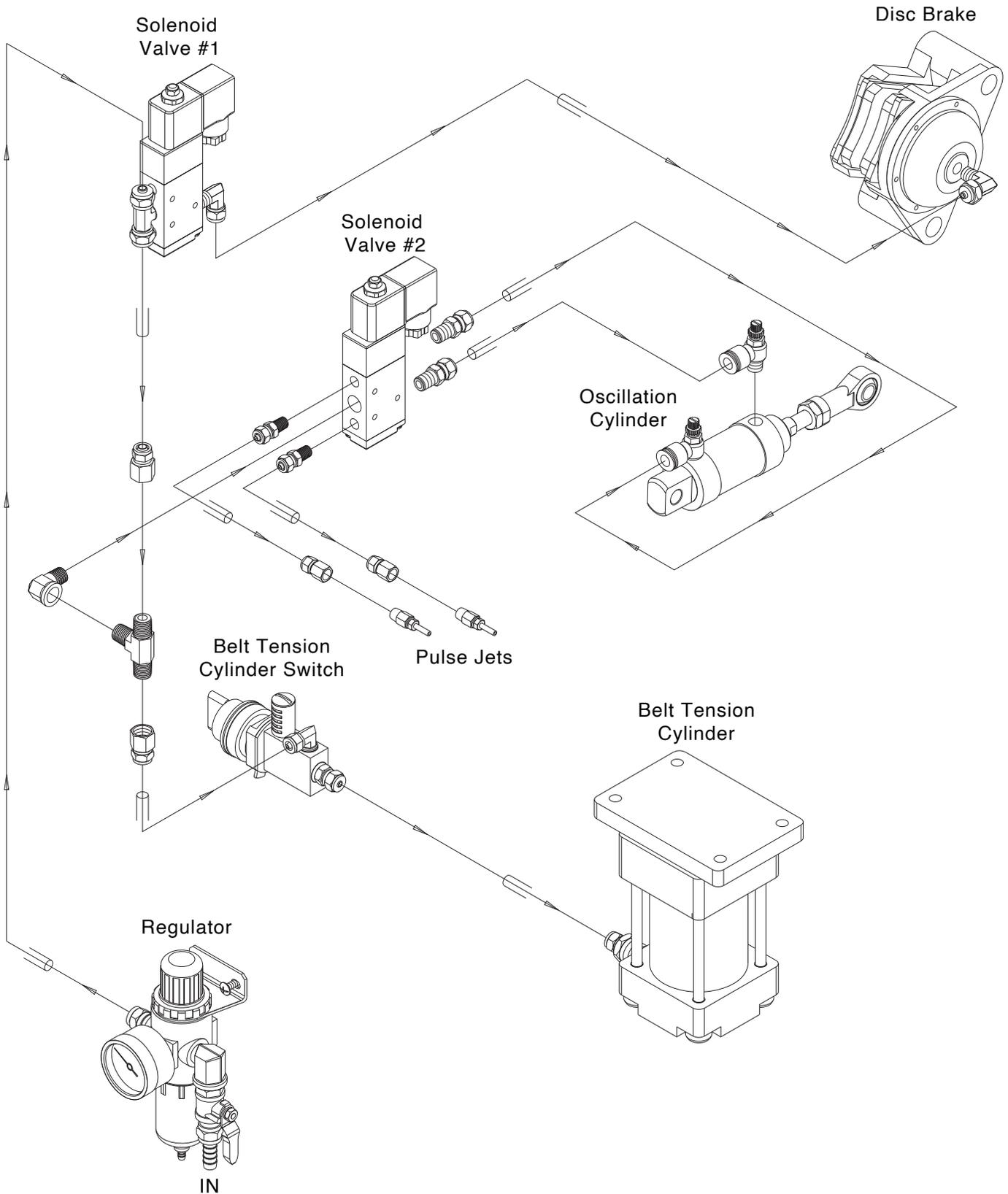
14. Remove old conveyor belt, clean rollers, and inspect rollers, bearings, and table for wear and replace as required.
15. Install new conveyor belt.
16. Install front conveyor roller and roller support, and turn both conveyor belt adjustment bolts clockwise equally so conveyor belt becomes taut and does not hang loose. **DO NOT OVERTIGHTEN** belt tension.
17. With lifting assistant, install table from rear, then remove 2x4s.
18. Install table guides and access panels.
19. Align leadscrew flanges with marks made in **Step 9**, then install hex bolts and washers.
20. Install table elevation limit switches so upper switch clicks when conveyor surface is $\frac{1}{8}$ " away from sandpaper, and lower switch clicks when conveyor table is $\frac{1}{8}$ " higher than its lowest position. Make sure to test settings with handwheel manually so table does not crash if incorrectly set at first use.
21. With assistant, install feed motor assembly.
22. Install workpiece thickness sensor peg assembly, EMERGENCY STOP! bar, and EMERGENCY STOP! limit switch.
23. Connect machine to power, and refer to **Adjusting Conveyor Belt Tracking** on **Page 62** to adjust belt tracking.



Conveyor Belt Removal Sequence



SECTION 7: PNEUMATIC SYSTEM



Pneumatic System Component Photos

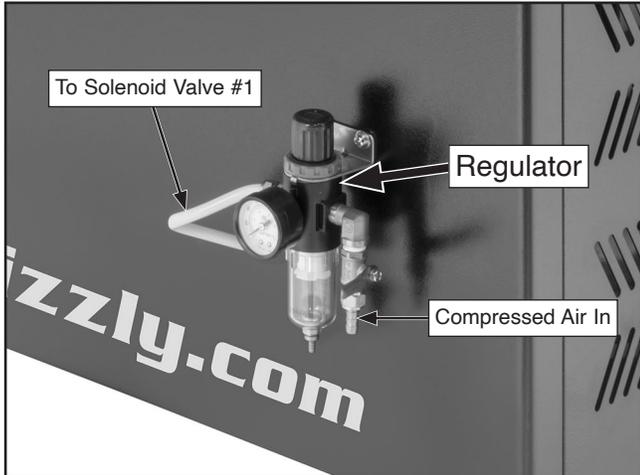


Figure 113. Regulator.

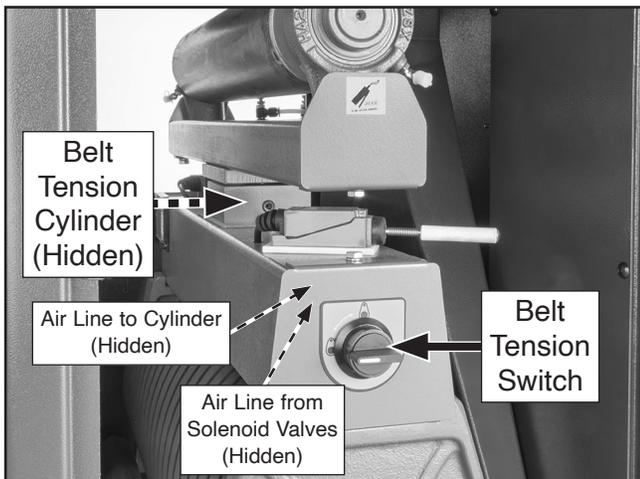


Figure 114. Belt tension switch and cylinder.

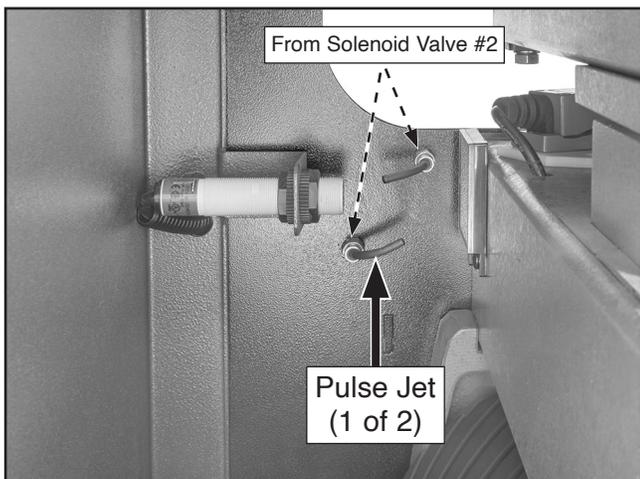


Figure 115. Pulse jets.

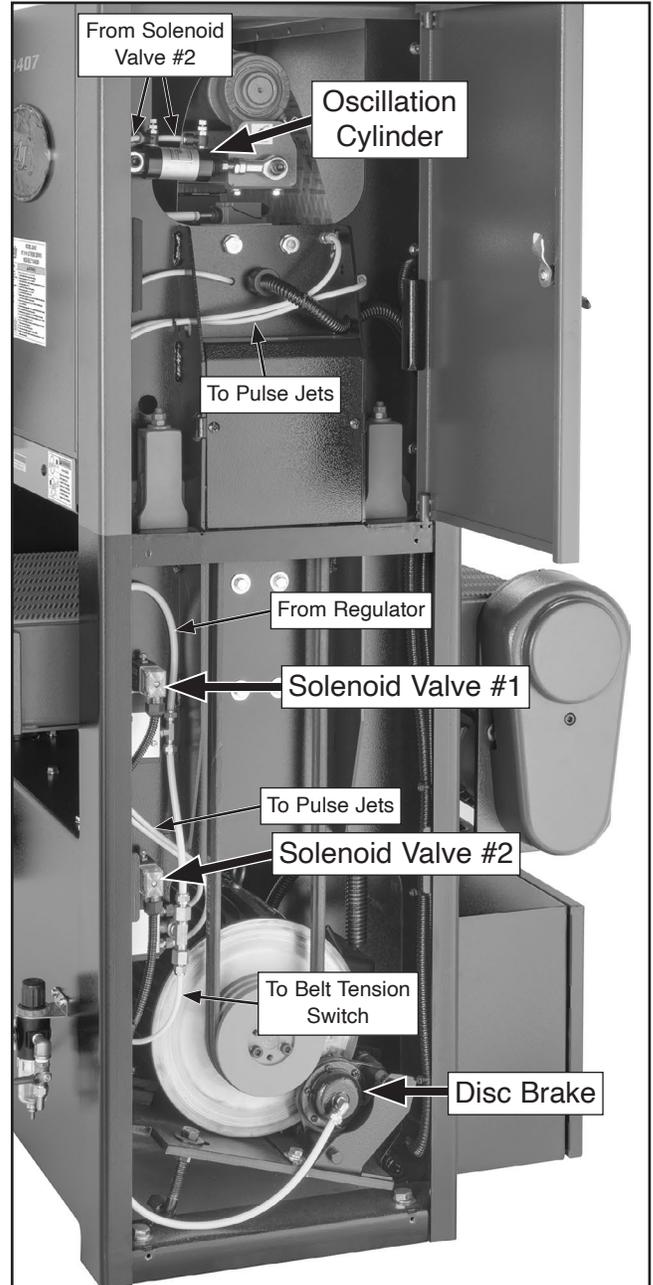


Figure 116. Disc brake and solenoid valves.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

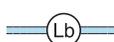
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

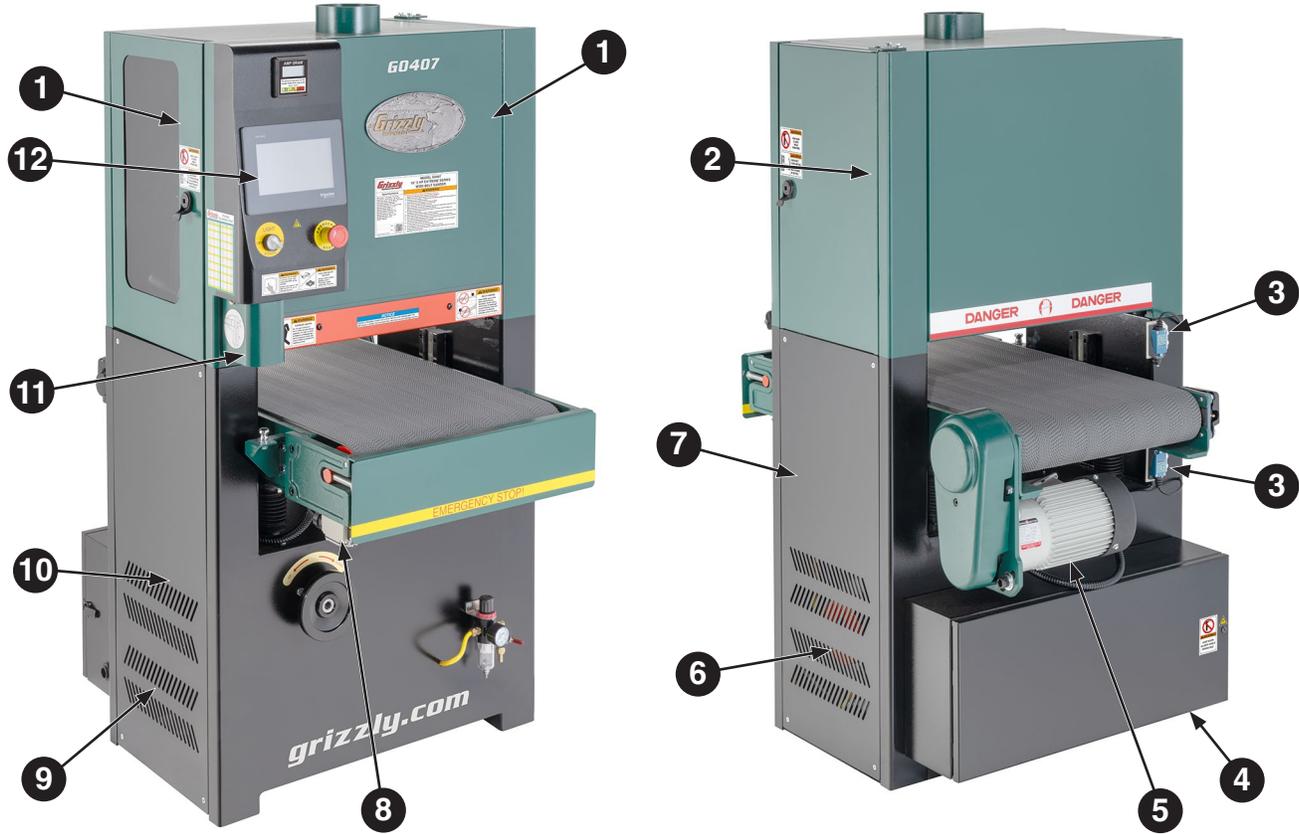
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

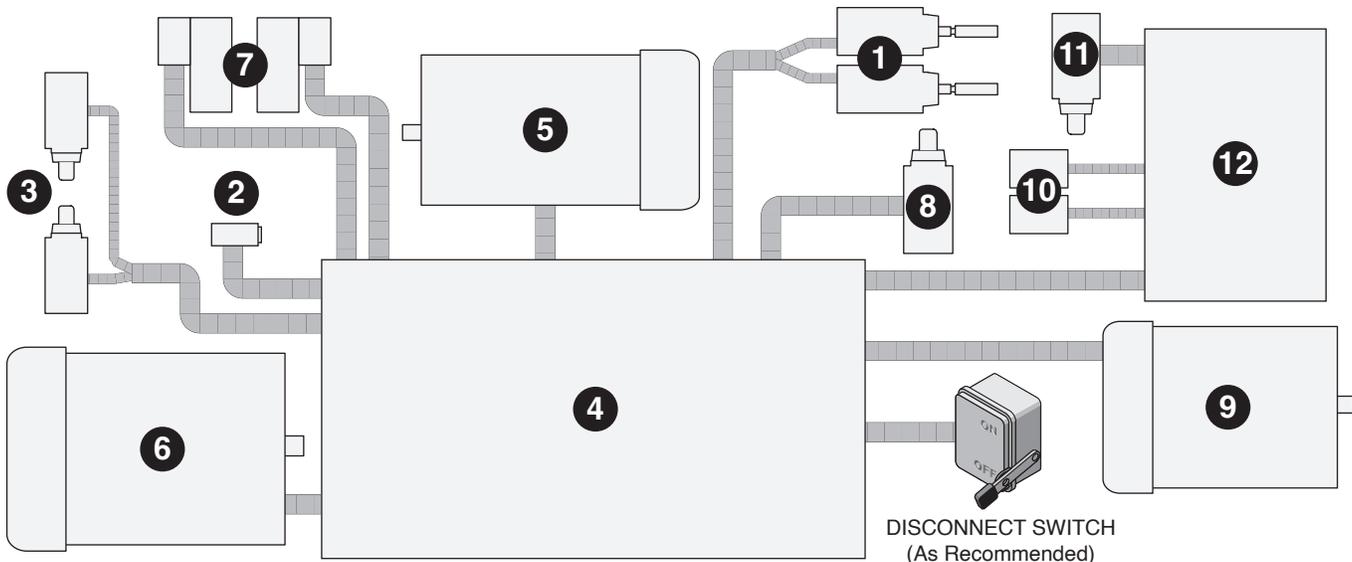
BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



Wiring Overview

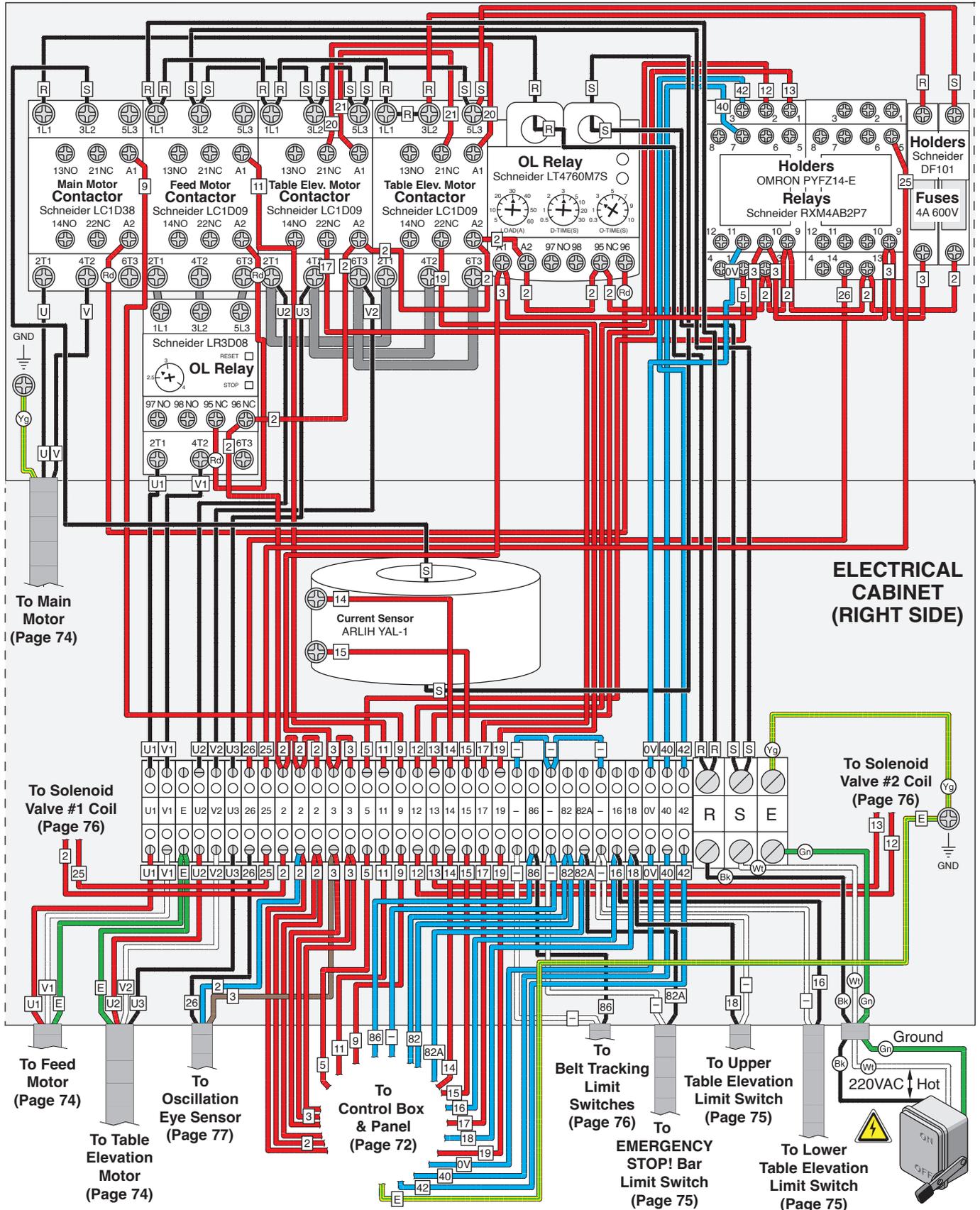


1	Belt Tracking Limit Switches (Page 76)	7	Solenoid Valve Coils (Page 76)
2	Oscillation Eye Sensor (Page 77)	8	EMERGENCY STOP! Limit Switch (Page 75)
3	Table Elevation Limit Switches (Page 75)	9	Table Elevation Motor (Page 74)
4	Electrical Cabinet (Page 71)	10	Table Elevation Sensors (Page 77)
5	Feed Motor (Page 74)	11	Workpiece Thickness Sensor (Page 77)
6	Main Motor (Page 74)	12	Control Box & Panel (Page 72)



Electrical Cabinet Wiring Diagram

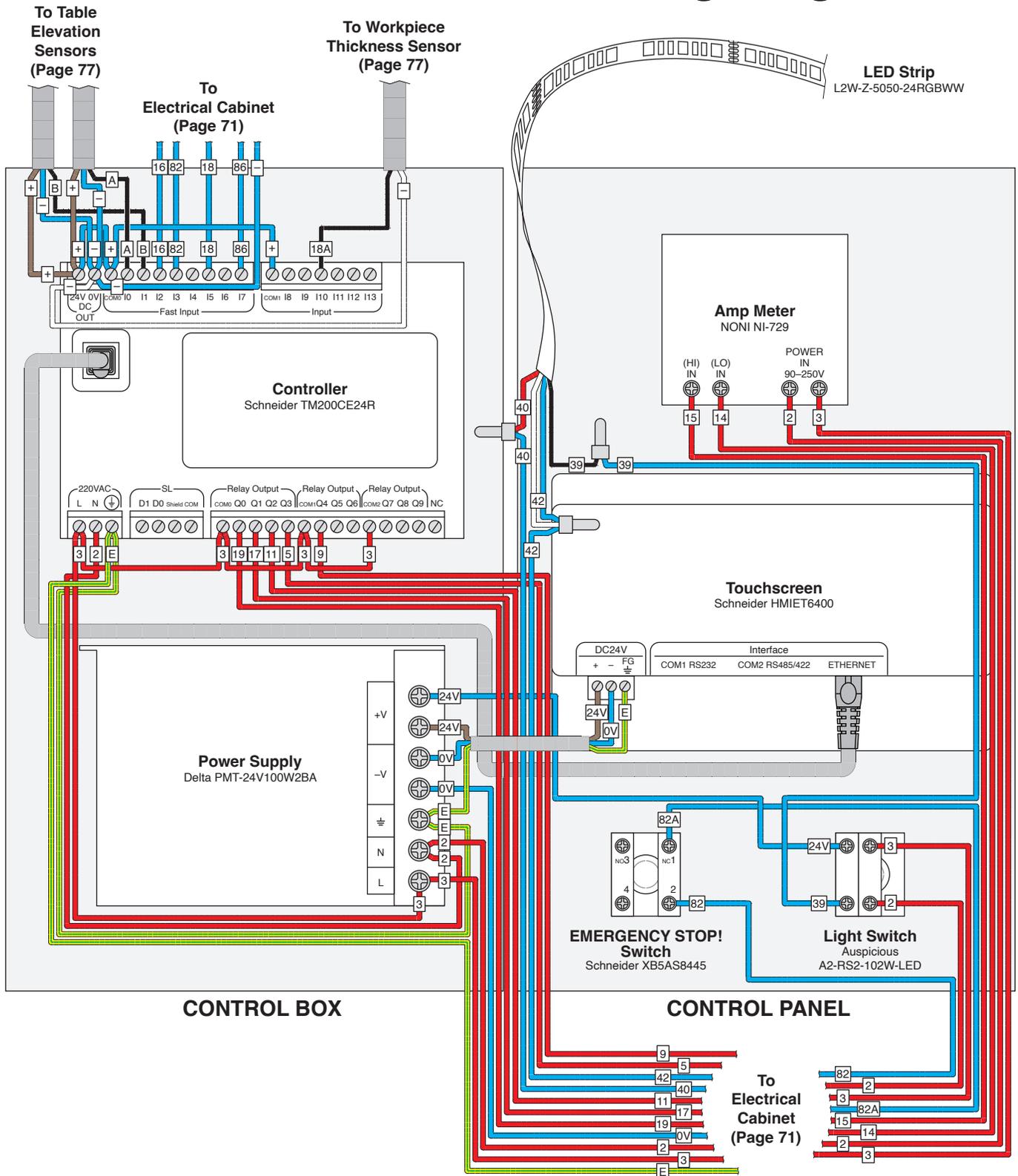
ELECTRICAL CABINET (LEFT SIDE)



ELECTRICAL CABINET (RIGHT SIDE)



Control Box & Panel Wiring Diagram



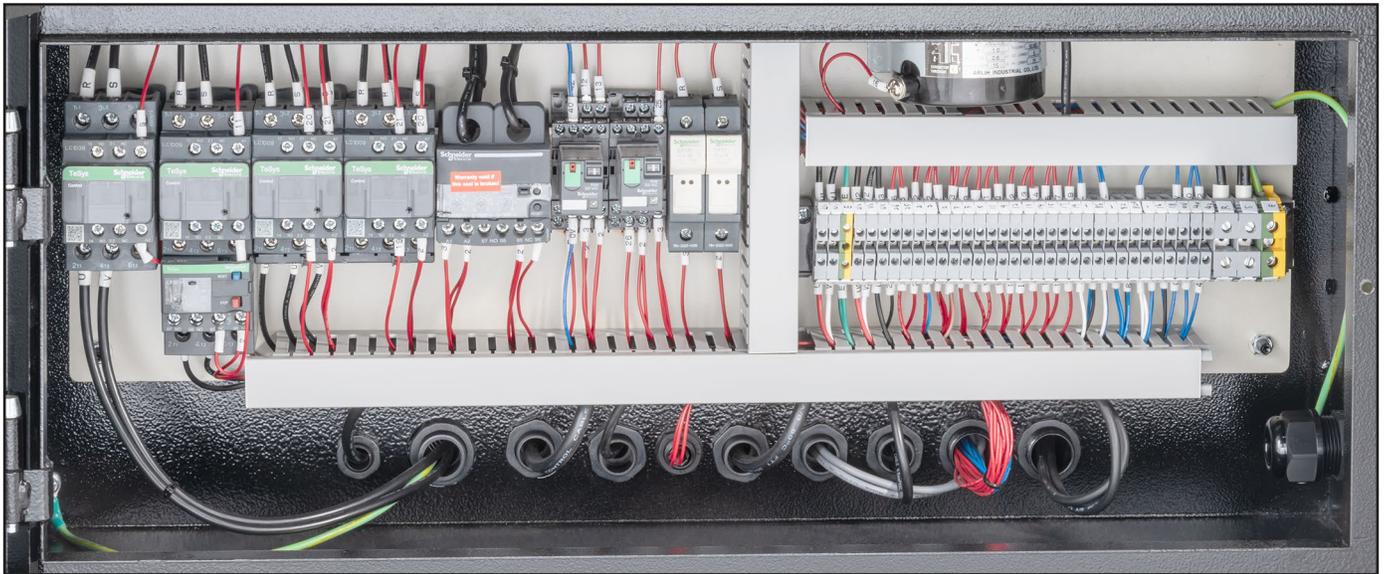


Figure 117. Electrical cabinet wiring.

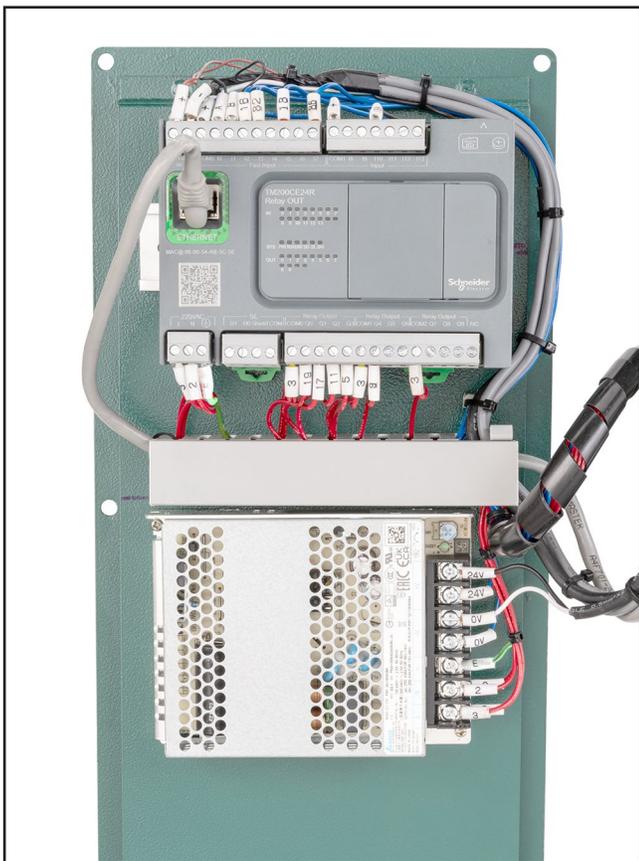


Figure 118. Control box wiring.

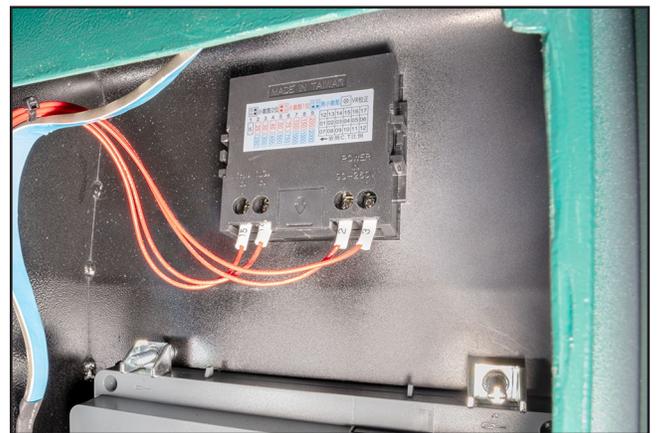


Figure 119. Amp meter wiring.



Figure 120. Control panel touchscreen and switch wiring.



Motor Wiring Diagrams

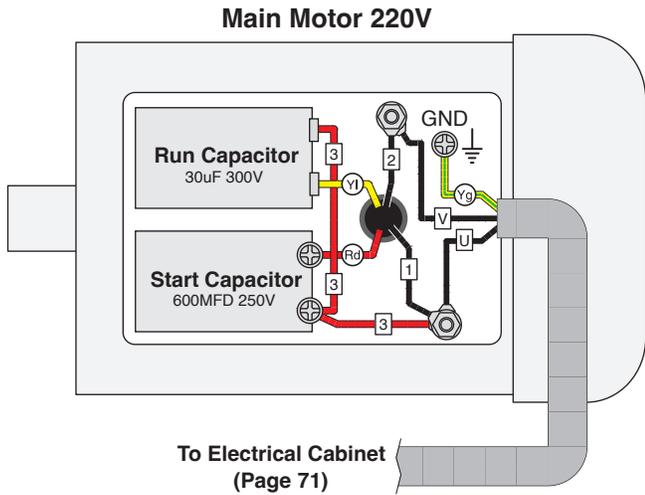


Figure 121. Main motor junction box wiring.

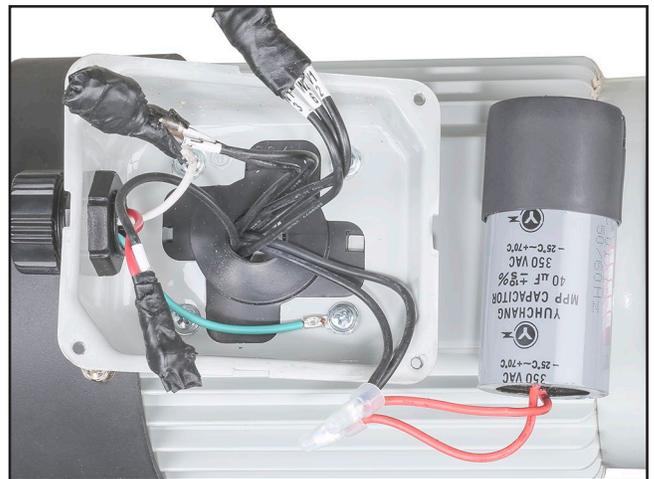
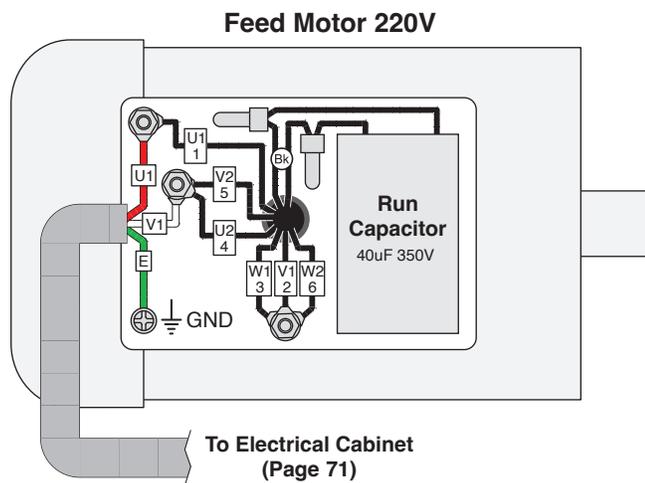


Figure 122. Feed motor junction box wiring.

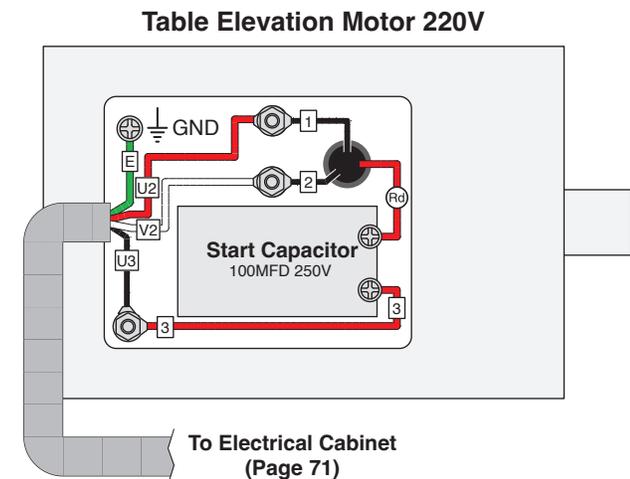
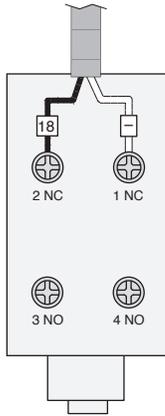


Figure 123. Table elevation motor junction box wiring.



Limit Switch Wiring Diagrams

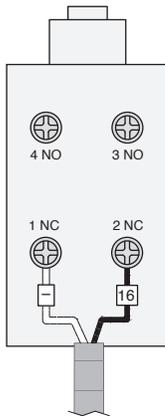
To Electrical Cabinet
(Page 71)



**Upper
Table Elevation
Limit Swith**
MOUJEN ME-8111



Figure 124. Upper table elevation limit switch wiring.



**Lower
Table Elevation
Limit Swith**
MOUJEN ME-8111



Figure 125. Lower table elevation limit switch wiring.

**EMERGENCY STOP! Bar
Limit Swith**
TEND TZ-5101

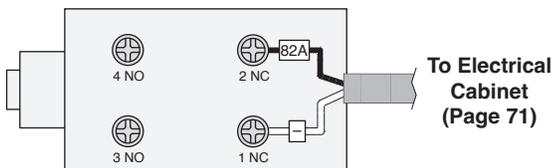


Figure 126. EMERGENCY STOP! bar limit switch wiring.



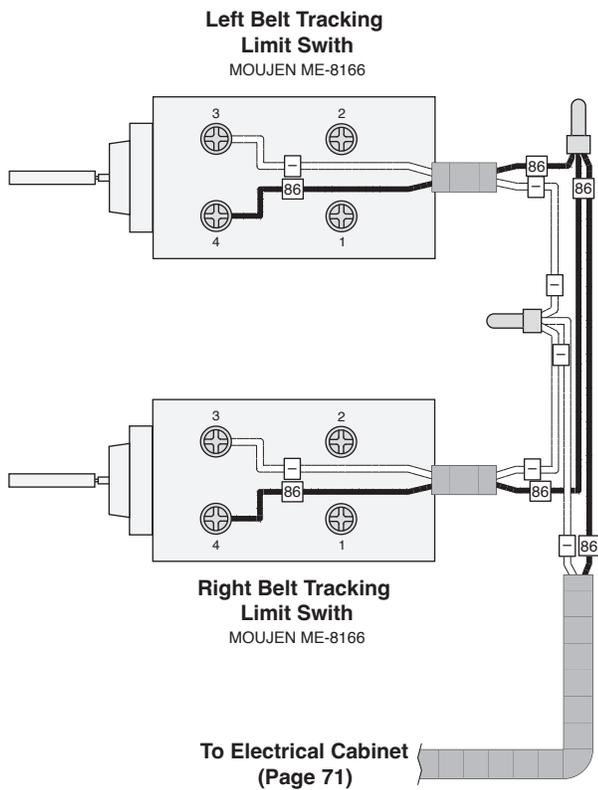


Figure 127. Left belt tracking limit switch wiring.

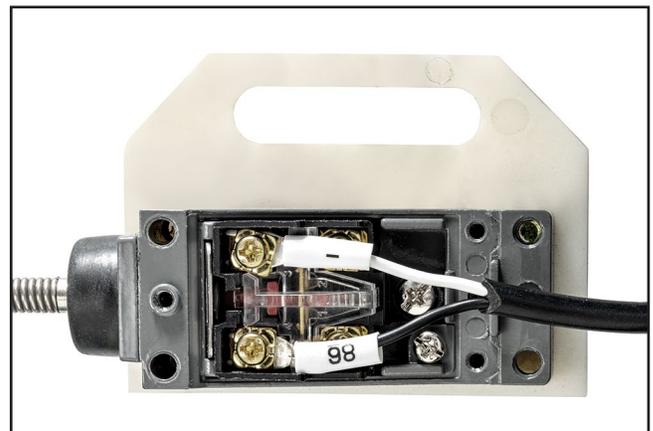
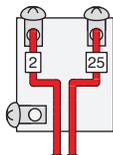


Figure 128. Right belt tracking limit switch wiring.

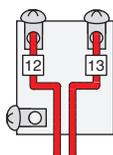
Solenoid Valve Coil Wiring Diagrams

Solenoid Valve #1 Coil
NEUMA NVA-6521



To Electrical Cabinet (Page 71)

Solenoid Valve #2 Coil
NEUMA NVA-6521



To Electrical Cabinet (Page 71)



Figure 129. Solenoid valve coils.



Sensor Wiring Diagrams

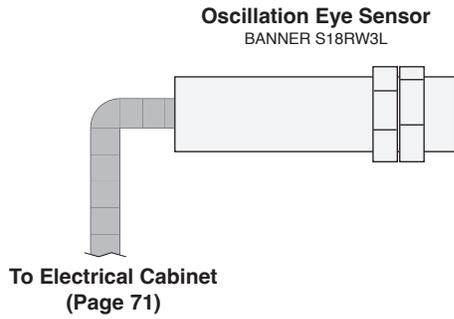


Figure 130. Oscillation eye sensor.

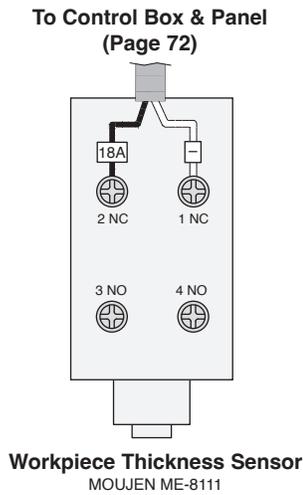


Figure 131. Workpiece thickness sensor wiring.

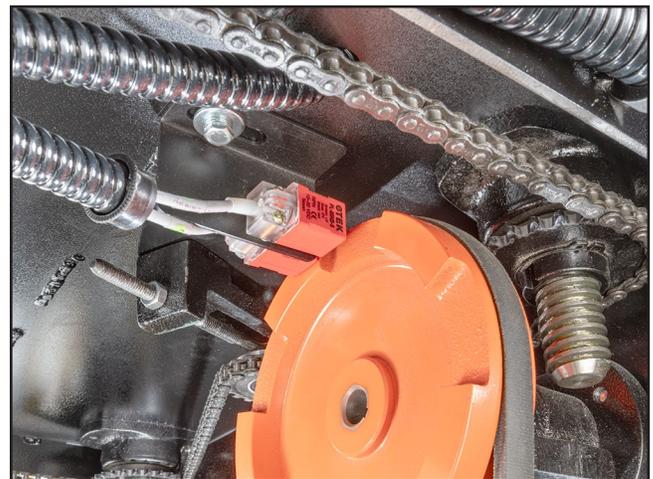
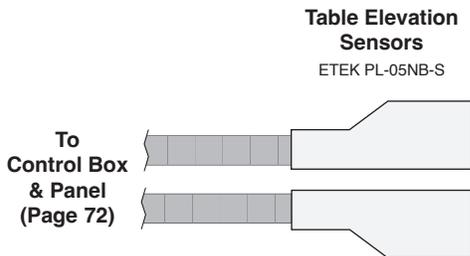


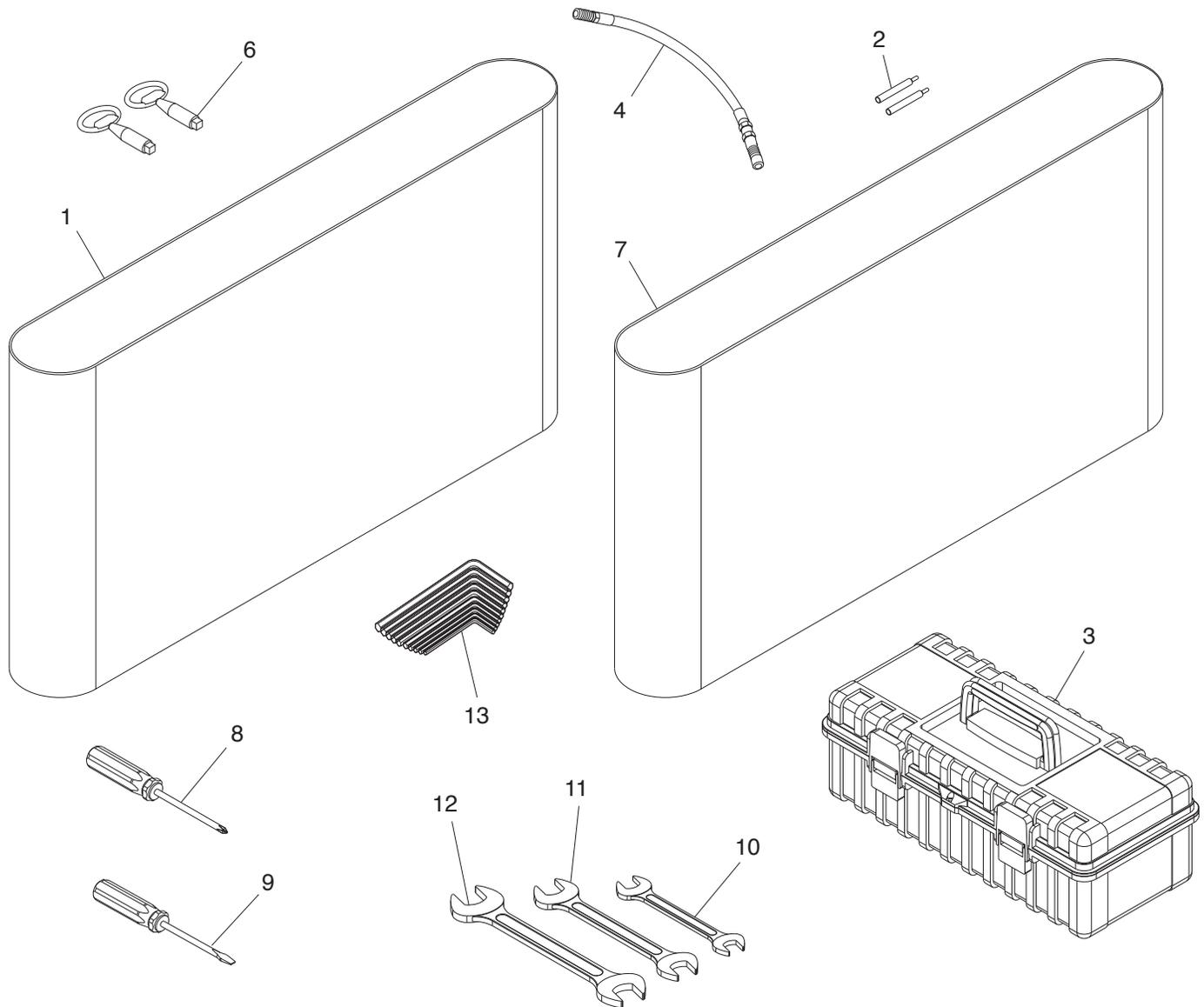
Figure 132. Table elevation sensors.



SECTION 9: PARTS

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

Tool Box & Accessories

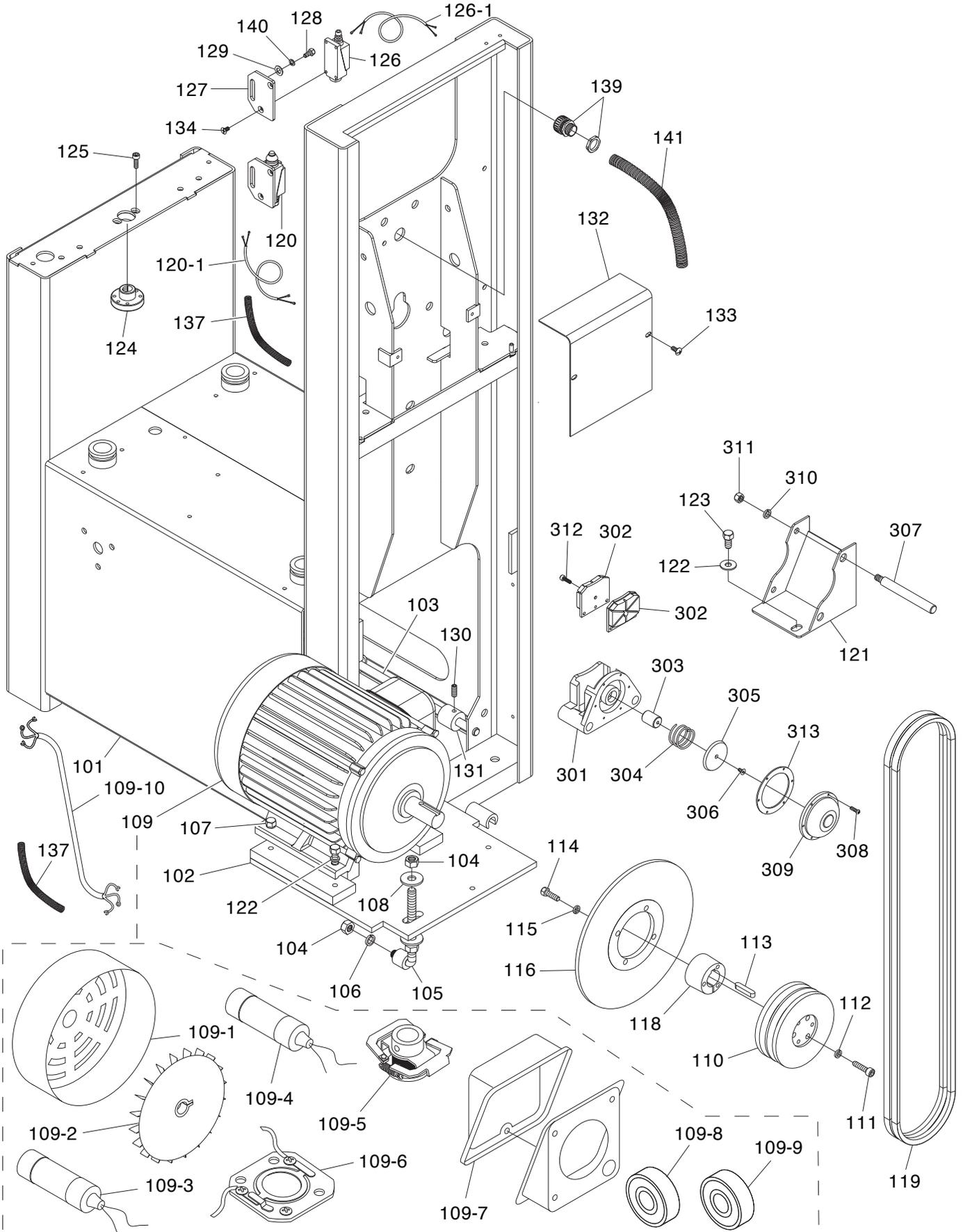


REF PART #	DESCRIPTION
1	P04070001 SANDING BELT 18" X 48" 150-GRIT
2	P04070002 LIMIT SWITCH CERAMIC TIP
3	P04070003 TOOL BOX
4	P04070004 FLEXIBLE GREASE GUN EXTENSION
6	P04070006 DOOR KEY
7	P04070007 SANDING BELT 18-1/2" X 48" 100-GRIT

REF PART #	DESCRIPTION
8	P04070008 SCREWDRIVER PHILLIPS #2
9	P04070009 SCREWDRIVER FLAT 1/4"
10	P04070010 WRENCH 8 X 10MM OPEN-ENDS
11	P04070011 WRENCH 12 X 14MM OPEN-ENDS
12	P04070012 WRENCH 17 X 19MM OPEN-ENDS
13	P04070013 HEX WRENCH SET (10-PC)



Sanding Motor



Sanding Motor Parts List

REF	PART #	DESCRIPTION
101	P04070101	MACHINE FRAME
102	P04070102	MOTOR MOUNTING PLATE
103	P04070103	PIVOT SHAFT
104	P04070104	HEX NUT 1/2-12
105	P04070105	BELT TENSION ADJUSTMENT ROD
106	P04070106	LOCK WASHER 1/2
107	P04070107	HEX BOLT 3/8-16 X 1-1/4
108	P04070108	FLAT WASHER 1/2
109	P04070109	MOTOR 5HP 220V 1-PH
109-1	P04070109-1	MOTOR FAN COVER
109-2	P04070109-2	MOTOR FAN
109-3	P04070109-3	S CAPACITOR 600M 250V 1-13/16 X 3-1/2
109-4	P04070109-4	R CAPACITOR 30M 300V 1-13/16 X 4
109-5	P04070109-5	CENTRIFUGAL SWITCH
109-6	P04070109-6	CONTACT PLATE INT
109-7	P04070109-7	MOTOR JUNCTION BOX
109-8	P04070109-8	BALL BEARING 6206-2RS (FRONT)
109-9	P04070109-9	BALL BEARING 6204-2RS (REAR)
109-10	P04070109-10	CORD 10G 3W 12"
110	P04070110	MOTOR PULLEY
111	P04070111	CAP SCREW 5/16-18 X 1-1/4
112	P04070112	LOCK WASHER 5/16
113	P04070113	KEY 8 X 7 X 55 RE
114	P04070114	HEX BOLT 5/16-18 X 1
115	P04070115	LOCK WASHER 5/16
116	P04070116	ROTOR
118	P04070118	KEYED BUSHING 28 X 55 X 34MM
119	P04070119	V-BELT A69
120	P04070120	LIMIT SWITCH MOUJEN ME-8111
120-1	P04070120-1	CORD 20G 2W 28"
121	P04070121	BRAKE MOUNT

REF	PART #	DESCRIPTION
122	P04070122	FLAT WASHER 3/8
123	P04070123	HEX BOLT 3/8-16 X 3/4
124	P04070124	LEADSCREW MOUNT LOWER
125	P04070125	CAP SCREW 1/4-20 X 3/4
126	P04070126	LIMIT SWITCH MOUJEN ME-8111
126-1	P04070126-1	CORD 20G 2W 40"
127	P04070127	LIMIT SWITCH MOUNT
128	P04070128	HEX BOLT 1/4-20 X 1/2
129	P04070129	FLAT WASHER 1/4
130	P04070130	SET SCREW 5/16-18 X 3/4
131	P04070131	LOCK COLLAR
132	P04070132	PULLEY COVER
133	P04070133	PHLP HD SCR 1/4-20 X 1/2
134	P04070134	FLAT HD SCR M5-.8 X 8
137	P04070137	CONDUIT 13/16" X 1" X 15"
139	P04070139	STRAIN RELIEF PG42
140	P04070140	LOCK WASHER 1/4
141	P04070141	CONDUIT 1/2" X 11/16" X 64"
301	P04070301	BRAKE CALIPER
302	P04070302	BRAKE PAD SET (2-PC)
303	P04070303	COUNTERSUNK BUSHING 8 X 15 X 15MM
304	P04070304	COMPRESSION SPRING 2.5 X 34 X 15MM
305	P04070305	DIAPHRAGM PLATE
306	P04070306	FLAT HD CAP SCR M6-1 X 25
307	P04070307	SHOULDER STUD-SE 3/8-16 X 4-15/16, 1/2
308	P04070308	PHLP HD SCR M5-.8 X 15
309	P04070309	DIAPHRAGM COVER
310	P04070310	LOCK WASHER 3/8
311	P04070311	HEX NUT 3/8-16
312	P04070312	CAP SCREW M6-1 X 12
313	P04070313	DIAPHRAGM



Table Elevation

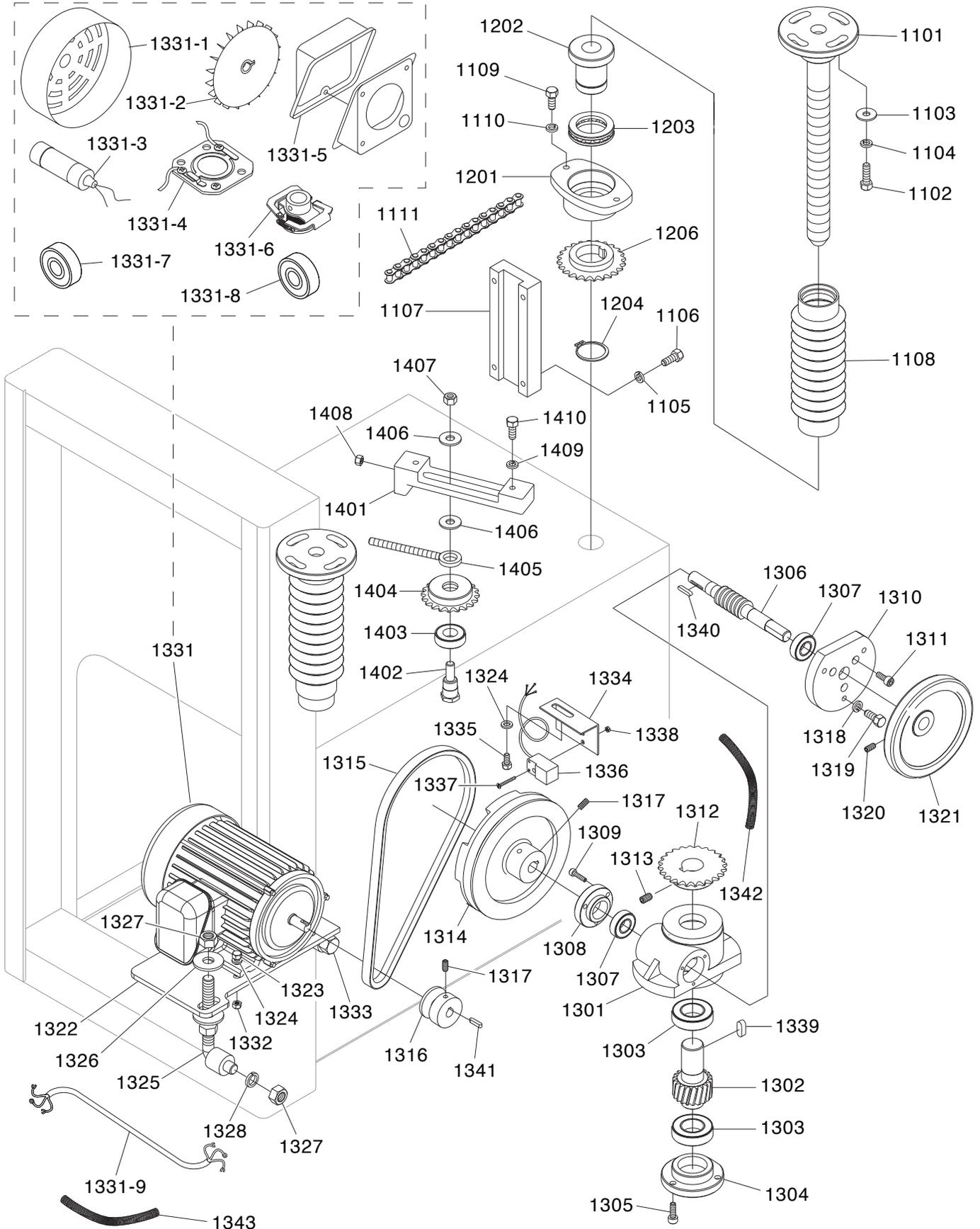


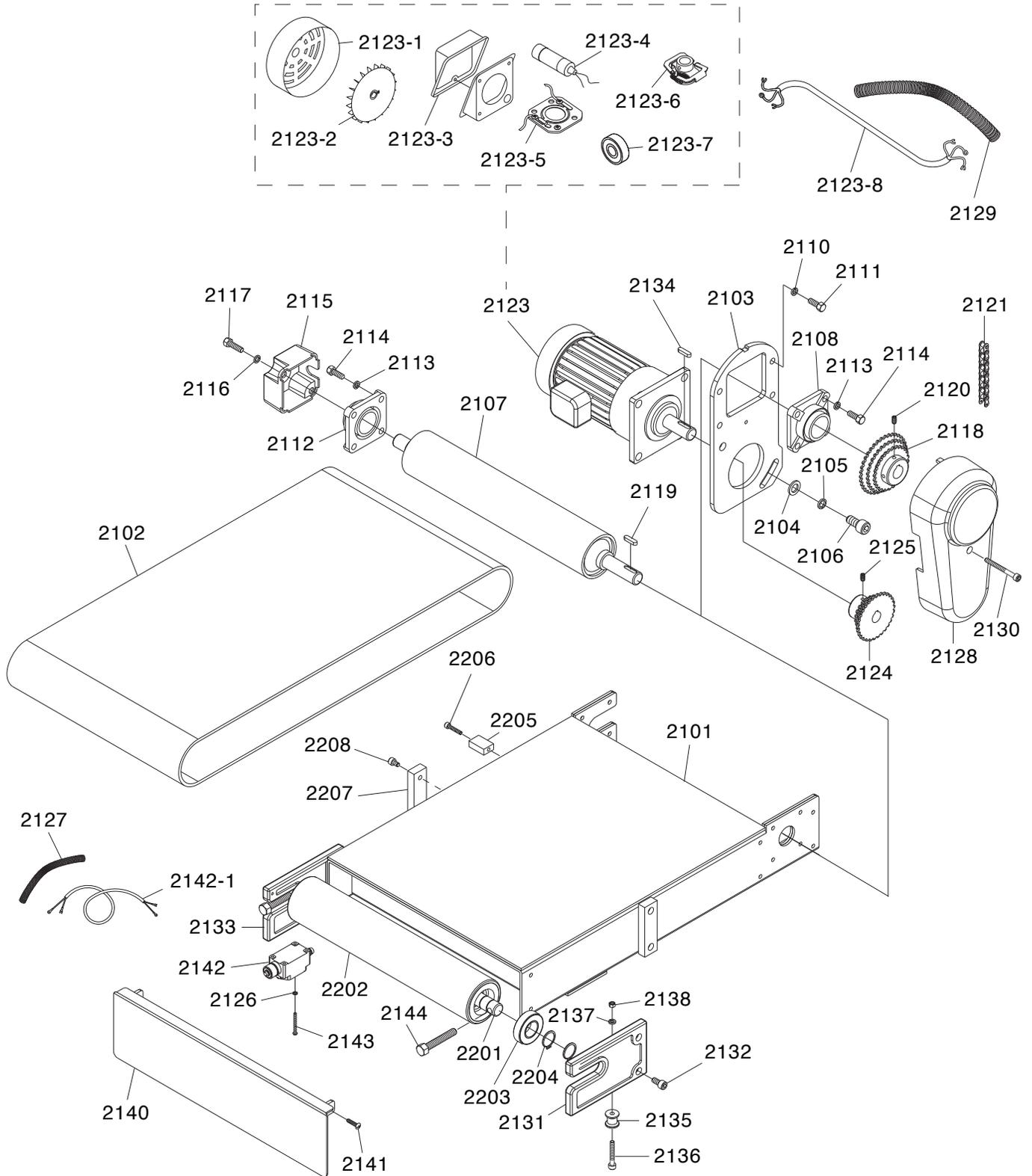
Table Elevation Parts List

REF	PART #	DESCRIPTION
1101	P04071101	LEADSCREW W/FLANGE
1102	P04071102	HEX BOLT 5/16-18 X 1
1103	P04071103	FLAT WASHER 5/16
1104	P04071104	LOCK WASHER 5/16
1105	P04071105	LOCK WASHER 3/8
1106	P04071106	HEX BOLT 3/8-16 X 1
1107	P04071107	TABLE GUIDE
1108	P04071108	DUST BELLOW
1109	P04071109	HEX BOLT 5/16-18 X 3/4
1110	P04071110	LOCK WASHER 5/16
1111	P04071111	ROLLER CHAIN #35 X 1780MM
1201	P04071201	LEADSCREW NUT HOUSING
1202	P04071202	LEADSCREW NUT
1203	P04071203	THRUST BEARING 51107
1204	P04071204	EXT RETAINING RING 35MM
1206	P04071206	SPROCKET 24T
1301	P04071301	ELEVATION GEARBOX
1302	P04071302	WORM GEAR SHAFT 20T 45 X 83MM
1303	P04071303	BALL BEARING 6005Z
1304	P04071304	BEARING CAP
1305	P04071305	CAP SCREW 1/4-20 X 3/4
1306	P04071306	WORM SHAFT
1307	P04071307	BALL BEARING 6002Z
1308	P04071308	BEARING CAP
1309	P04071309	CAP SCREW 10-24 X 3/4
1310	P04071310	HANDWHEEL BEARING CAP
1311	P04071311	CAP SCREW 1/4-20 X 5/8
1312	P04071312	SPROCKET 25T
1313	P04071313	SET SCREW 5/16-18 X 1/2
1314	P04071314	TABLE PULLEY
1315	P04071315	V-BELT A27
1316	P04071316	MOTOR PULLEY
1317	P04071317	SET SCREW 1/4-20 X 1/2
1318	P04071318	LOCK WASHER 5/16
1319	P04071319	HEX BOLT 5/16-18 X 5/8
1320	P04071320	SET SCREW 1/4-20 X 1/2
1321	P04071321	HANDWHEEL 13.2MM
1322	P04071322	MOTOR MOUNTING PLATE

REF	PART #	DESCRIPTION
1323	P04071323	HEX BOLT 1/4-20 X 1
1324	P04071324	LOCK WASHER 1/4
1325	P04071325	BELT TENSION ADJUSTMENT ROD
1326	P04071326	FENDER WASHER 1/2
1327	P04071327	HEX NUT 1/2-13
1328	P04071328	LOCK WASHER 1/2
1331	P04071331	MOTOR 1/3HP 220V 1-PH
1331-1	P04071331-1	MOTOR FAN COVER
1331-2	P04071331-2	MOTOR FAN
1331-3	P04071331-3	S CAPACITOR 100M 250V 1-3/8 X 3
1331-4	P04071331-4	CONTACT PLATE INT
1331-5	P04071331-5	MOTOR JUNCTION BOX
1331-6	P04071331-6	CENTRIFUGAL SWITCH
1331-7	P04071331-7	BALL BEARING 6206-2RS (FRONT)
1331-8	P04071331-8	BALL BEARING 6204-2RS (REAR)
1331-9	P04071331-9	CORD 16G 4W 20"
1332	P04071332	HEX NUT 1/4-20
1333	P04071333	HEX BOLT 1/2-13 X 4-1/2
1334	P04071334	SENSOR MOUNT
1335	P04071335	HEX BOLT 1/4-20 X 1/2
1336	P04071336	TABLE SENSOR W/CORD ETEK PL-05NB-S
1337	P04071337	PHLP HD SCR M3-.5 X 35
1338	P04071338	HEX NUT M3-.5
1339	P04071339	KEY 5/16 X 5/16 X 3/4 RE
1340	P04071340	KEY 4 X 4 X 20
1341	P04071341	KEY 4 X 4 X 23
1342	P04071342	CONDUIT 9/16" X 11/16" X 24"
1343	P04071343	CONDUIT 9/16" X 11/16" X 20"
1401	P04071401	CHAIN TENSION BLOCK
1402	P04071402	SPROCKET SHAFT
1403	P04071403	BALL BEARING 6003ZZ
1404	P04071404	SPROCKET 35T
1405	P04071405	TENSION ADJUSTMENT ROD
1406	P04071406	FLAT WASHER 3/8
1407	P04071407	HEX NUT 3/8-16
1408	P04071408	HEX NUT 5/16-18
1409	P04071409	LOCK WASHER 5/16
1410	P04071410	HEX BOLT 5/16-18 X 3/4



Conveyor Table



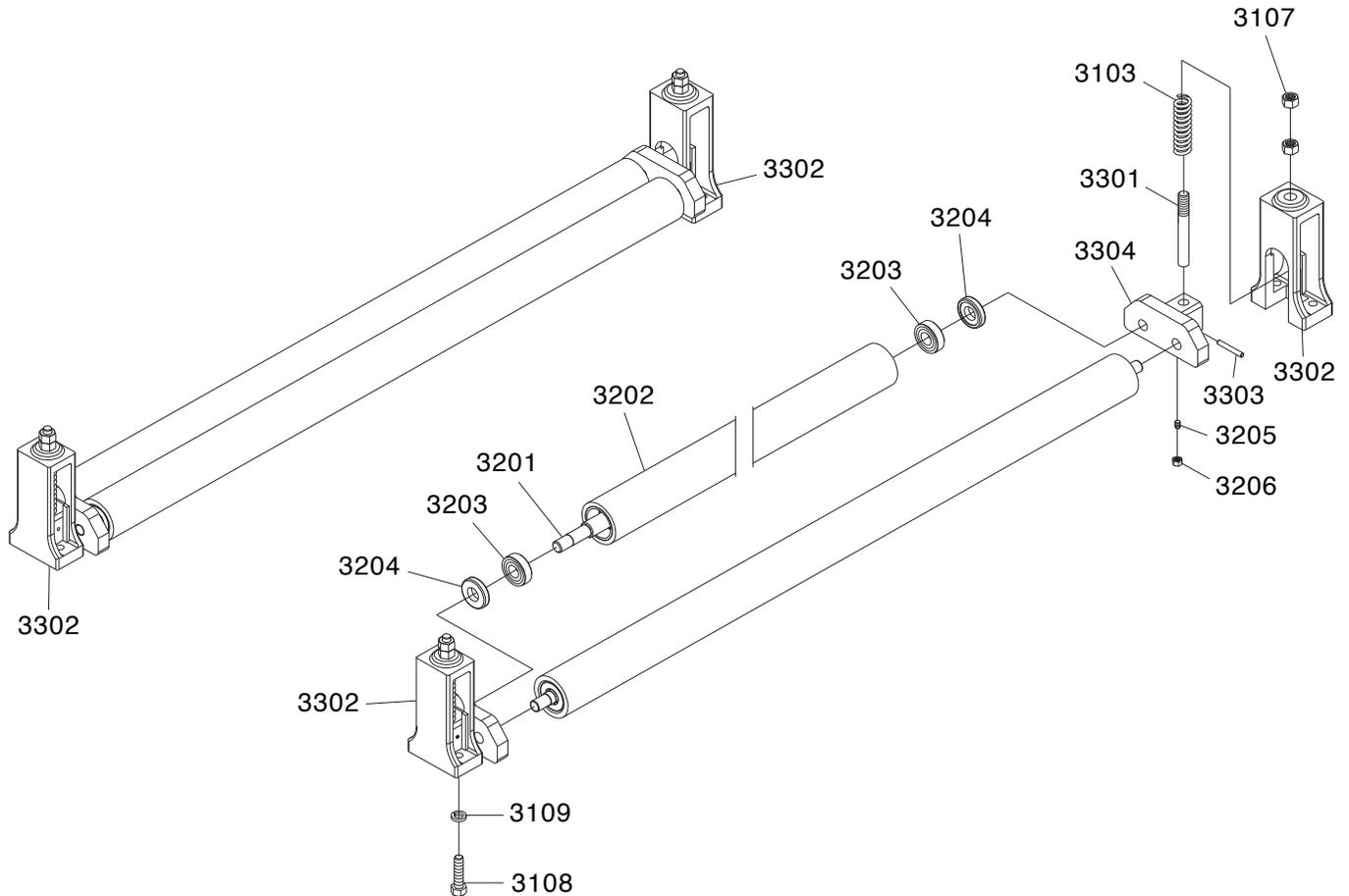
Conveyor Table Parts List

REF	PART #	DESCRIPTION
2101	P04072101	CONVEYOR TABLE
2102	P04072102	CONVEYOR BELT 18" X 70-7/8"
2103	P04072103	MOTOR MOUNTING PLATE
2104	P04072104	FLAT WASHER 14MM
2105	P04072105	LOCK WASHER 14MM
2106	P04072106	CAP SCREW M14-2 X 30
2107	P04072107	OUTFEED ROLLER
2108	P04072108	FLANGE BEARING UCF205
2110	P04072110	LOCK WASHER 3/8
2111	P04072111	HEX BOLT 3/8-16 X 1
2112	P04072112	FLANGE BEARING UCF205
2113	P04072113	LOCK WASHER 3/8
2114	P04072114	HEX BOLT 3/8-16 X 1
2115	P04072115	BEARING COVER
2116	P04072116	LOCK WASHER 3/8
2117	P04072117	HEX BOLT 3/8-16 X 1-1/4
2118	P04072118	IDLER SPROCKET TRIPLE
2119	P04072119	KEY 5/16 X 5/16 X 13/16
2120	P04072120	SET SCREW 5/16-18 X 1/2
2121	P04072121	ROLLER CHAIN #35 X 670MM
2123	P04072123	MOTOR 1/2HP 220V 1-PH
2123-1	P04072123-1	MOTOR FAN COVER
2123-2	P04072123-2	MOTOR FAN
2123-3	P04072123-3	MOTOR JUNCTION BOX
2123-4	P04072123-4	R CAPACITOR 40M 350V 1-5/8 X 3-1/2
2123-5	P04072123-5	CONTACT PLATE INT
2123-6	P04072123-6	CENTRIFUGAL SWITCH
2123-7	P04072123-7	BALL BEARING 6202-2RS
2123-8	P04072123-8	CORD 16G 3W 48"

REF	PART #	DESCRIPTION
2124	P04072124	DRIVE SPROCKET TRIPLE 20T/25T/30T
2125	P04072125	SET SCREW 5/16-18 X 1/2
2126	P04072126	LOCK WASHER #10
2127	P04072127	CONDUIT 3/8" X 11/16" X 48"
2128	P04072128	CHAIN COVER
2129	P04072129	CONDUIT 1/2" X 11/16" X 48"
2130	P04072130	CAP SCREW 5/16-18 X 3
2131	P04072131	ROLLER SUPPORT RIGHT
2132	P04072132	CAP SCREW 3/8-16 X 3/4
2133	P04072133	ROLLER SUPPORT LEFT
2134	P04072134	KEY 5/16 X 5/16 X 1-3/16 RE
2135	P04072135	BELT GUIDE WHEEL
2136	P04072136	CAP SCREW 5/16-18 X 2
2137	P04072137	LOCK WASHER 5/16
2138	P04072138	HEX NUT 5/16-18
2140	P04072140	EMERGENCY STOP BAR
2141	P04072141	PHLP HD SCR 1/4-20 X 1
2142	P04072142	LIMIT SWITCH TEND TZ-5101
2142-1	P04072142-1	CORD 20G 2W 48"
2143	P04072143	PHLP HD SCR 10-24 X 1-3/4
2144	P04072144	HEX BOLT 1/2-13 X 3
2201	P04072201	INFEED ROLLER SHAFT
2202	P04072202	INFEED ROLLER
2203	P04072203	BALL BEARING 6206ZZ
2204	P04072204	EXT RETAINING RING 35MM
2205	P04072205	ELEVATION STOP BLOCK
2206	P04072206	CAP SCREW 1/4-20 X 1-1/4
2207	P04072207	TABLE GUIDE RAIL
2208	P04072208	CAP SCREW 5/16-18 X 1/2



Pressure Rollers

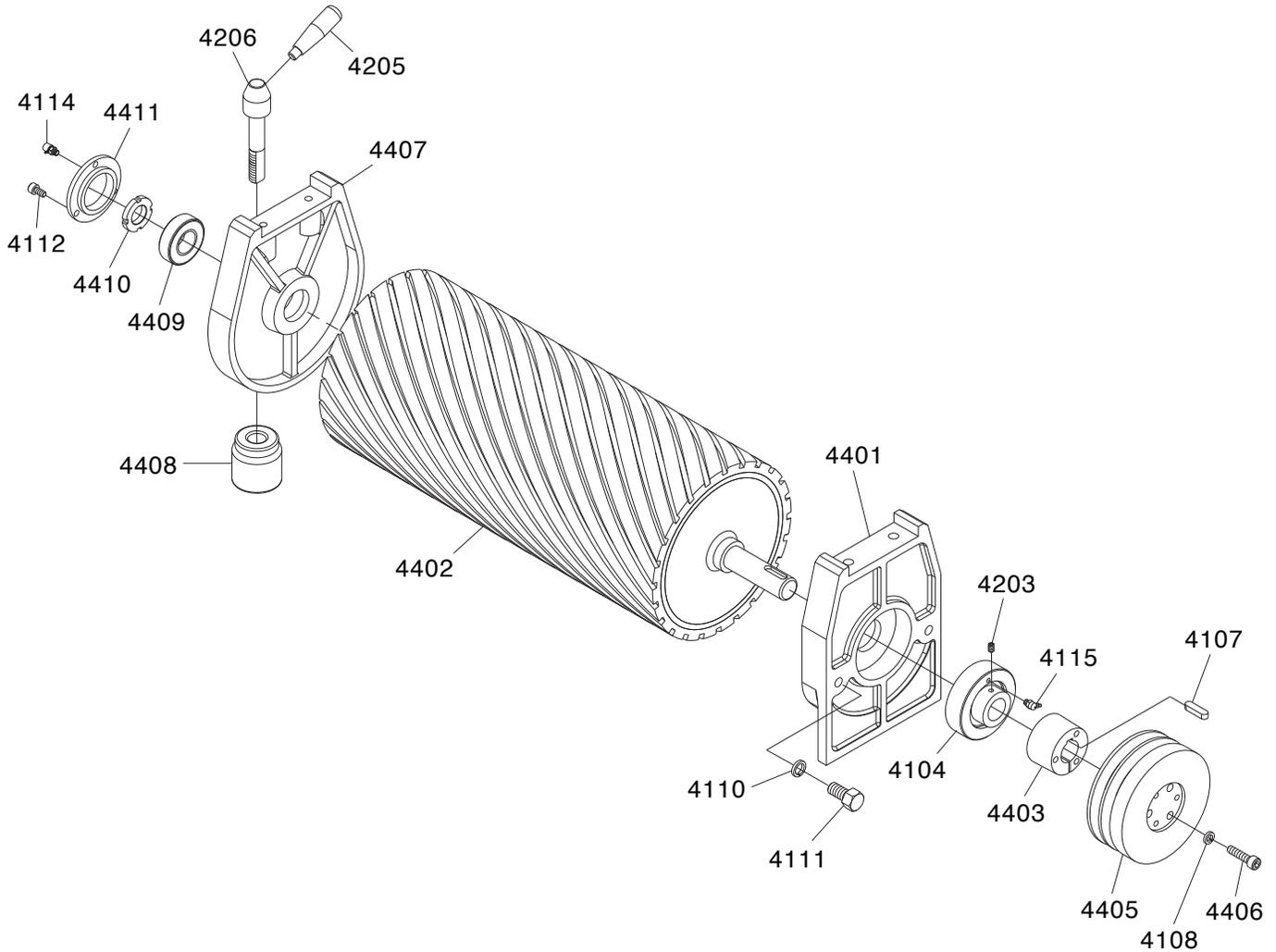


REF	PART #	DESCRIPTION
3103	P04073103	COMPRESSION SPRING 3 X 15.6 X 57
3107	P04073107	HEX NUT 3/8-16
3108	P04073108	HEX BOLT 5/16-18 X 1-1/4
3109	P04073109	LOCK WASHER 5/16
3201	P04073201	PRESSURE ROLLER SHAFT
3202	P04073202	PRESSURE ROLLER
3203	P04073203	BALL BEARING 6001-2RS

REF	PART #	DESCRIPTION
3204	P04073204	BEARING COLLAR
3205	P04073205	SET SCREW 1/4-20 X 3/4
3206	P04073206	HEX NUT 1/4-20
3301	P04073301	STUD-SE 3/8-16 X 4-5/16, 1-1/4"
3302	P04073302	ROLLER ADJUSTMENT BRACKET
3303	P04073303	ROLL PIN 3 X 27
3304	P04073304	PRESSURE ROLLER MOUNT



Sanding Drum

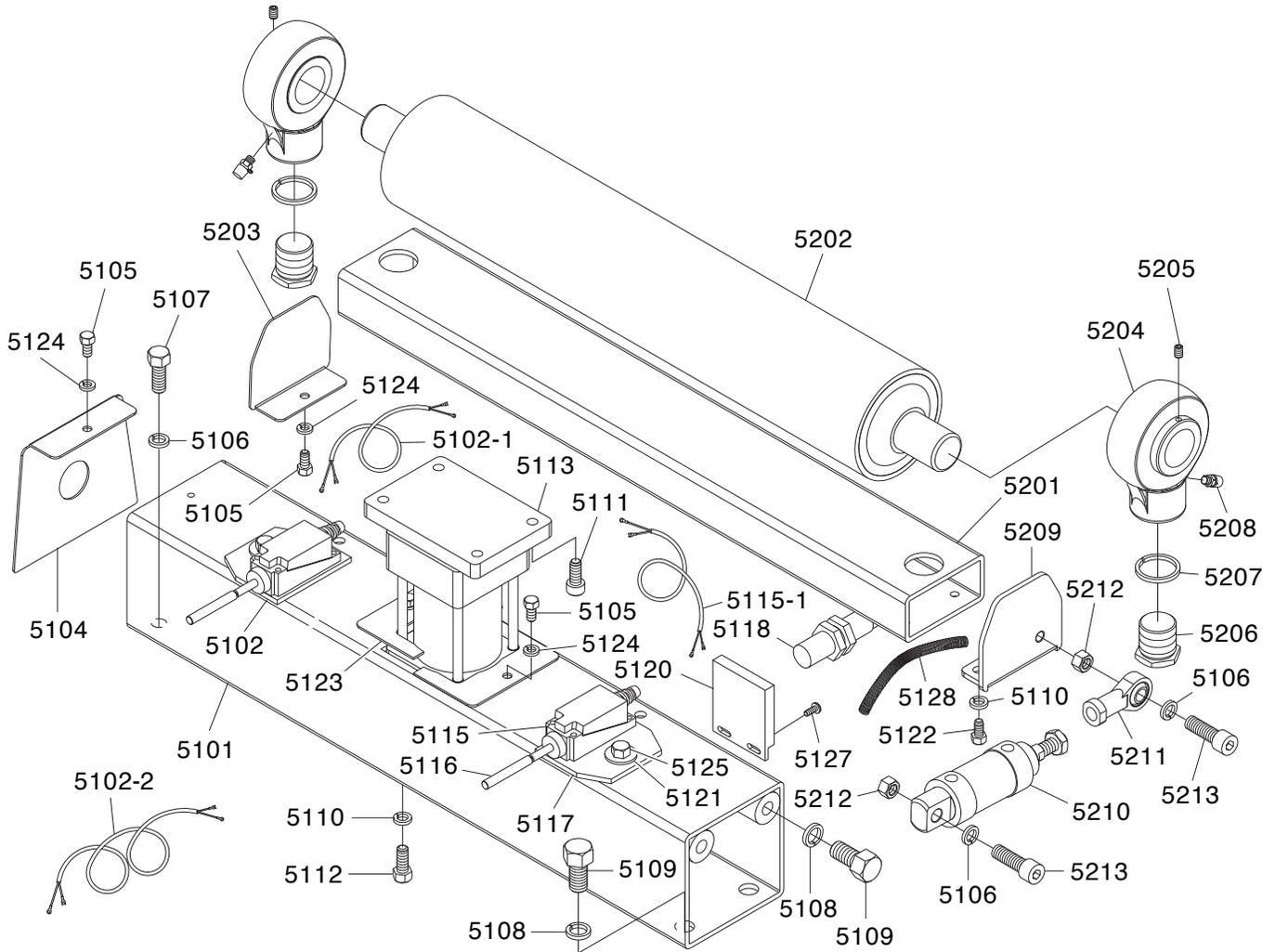


REF	PART #	DESCRIPTION
4104	P04074104	CARTRIDGE BEARING UCC205
4107	P04074107	KEY 5/16 X 5/16 X 1-3/16 RE
4108	P04074108	LOCK WASHER 5/16
4110	P04074110	LOCK WASHER 1/2
4111	P04074111	HEX BOLT 1/2-13 X 1-1/4
4112	P04074112	CAP SCREW 1/4-20 X 1/2
4114	P04074114	GREASE FITTING 1/4"-28 SAE STRAIGHT
4115	P04074115	GREASE FITTING 1/4"-28 SAE 45-DEG
4203	P04074203	SET SCREW M6-1 X 6
4205	P04074205	FIXED HANDLE M10-1.5 X 10
4206	P04074206	HANDLE SCREW M16-2 X 45

REF	PART #	DESCRIPTION
4401	P04074401	BEARING HOUSING RIGHT
4402	P04074402	SANDING DRUM
4403	P04074403	LOCK COLLAR
4405	P04074405	DRUM PULLEY
4406	P04074406	CAP SCREW 5/16-18 X 1-1/4
4407	P04074407	BEARING HOUSING LEFT
4408	P04074408	STOP BLOCK
4409	P04074409	BALL BEARING 6205-2RS
4410	P04074410	SPANNER NUT M25-1.5
4411	P04074411	BEARING COVER



Upper Roller

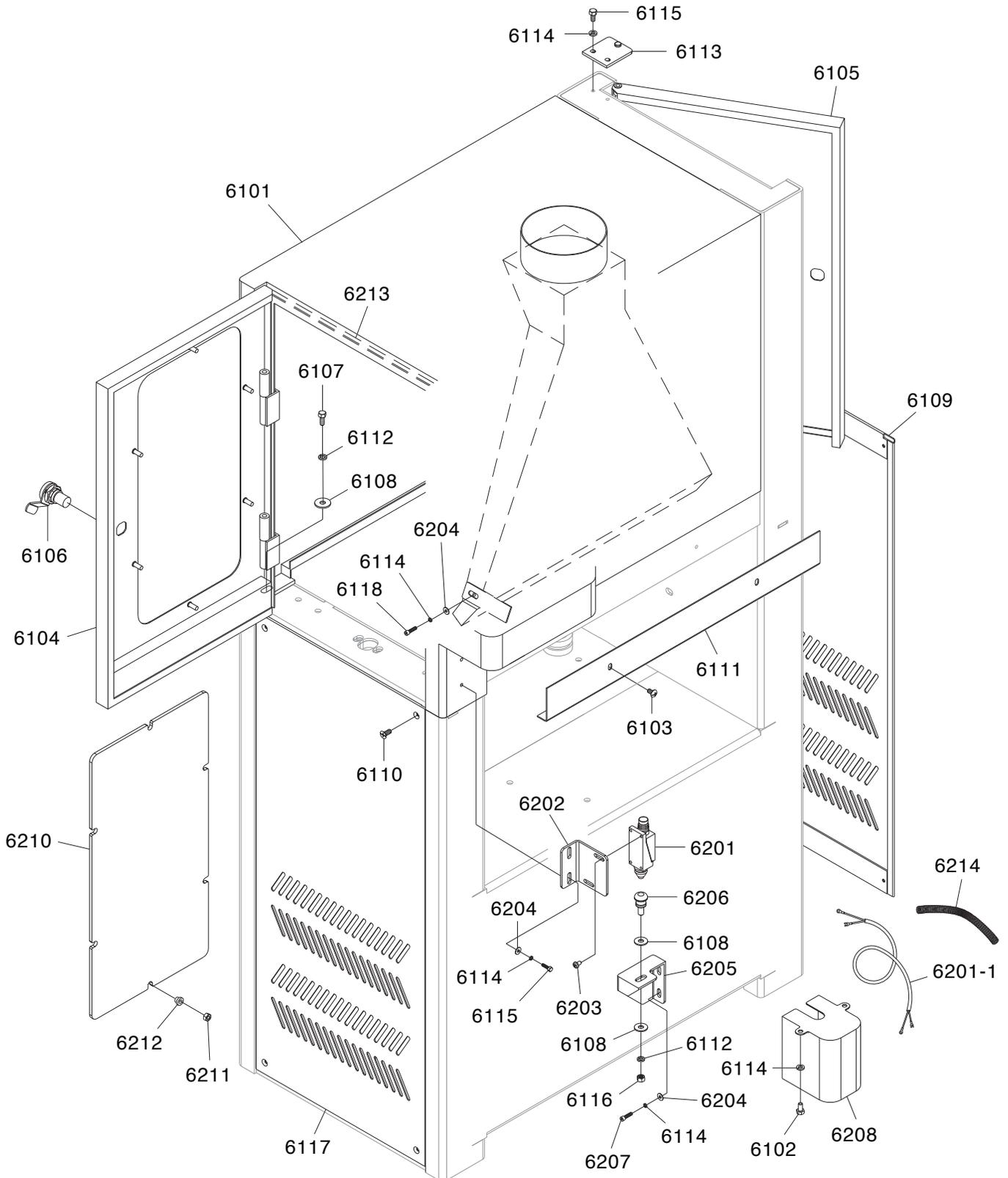


REF	PART #	DESCRIPTION
5101	P04075101	SQUARE FRAME
5102	P04075102	LIMIT SWITCH MOUJEN ME-8166
5102-1	P04075102-1	CORD 20G 2W 36"
5102-2	P04075102-2	CORD 20G 2W 96"
5104	P04075104	SQUARE FRAME COVER
5105	P04075105	HEX BOLT 1/4-20 X 1/2
5106	P04075106	LOCK WASHER 3/8
5107	P04075107	HEX BOLT 3/8-16 X 1
5108	P04075108	LOCK WASHER 1/2
5109	P04075109	HEX BOLT 1/2-12 X 1
5110	P04075110	LOCK WASHER 5/16
5111	P04075111	CAP SCREW 5/16-18 X 3/4
5112	P04075112	HEX BOLT M8-1.25 X 20
5113	P04075113	BELT TENSION AIR CYLINDER
5115	P04075115	LIMIT SWITCH MOUJEN ME-8166
5115-1	P04075115-1	CORD 20G 2W 18"
5116	P04075116	LIMIT SWITCH TIP
5117	P04075117	LIMIT SWITCH MOUNT
5118	P04075118	EYE SENSOR W/CORD BANNER S18RW3L
5120	P04075120	SENSOR MIRROR

REF	PART #	DESCRIPTION
5121	P04075121	FLAT WASHER 5/16
5122	P04075122	HEX BOLT 5/16-18 X 1/2
5123	P04075123	AIR CYLINDER COVER
5124	P04075124	LOCK WASHER 1/4
5125	P04075125	HEX BOLT 5/16-18 X 3/4
5127	P04075127	PHLP HD SCR M4-.7 X 8
5128	P04075128	CONDUIT 7/16" X 9/16" X 52"
5201	P04075201	ROLLER BEAM
5202	P04075202	UPPER ROLLER
5203	P04075203	BEAM COVER LEFT
5204	P04075204	ROD END BEARING UCECH206
5205	P04075205	SET SCREW M6-1 X 6
5206	P04075206	HEX BOLT 3/4-16 X 1
5207	P04075207	LOCK WASHER 1"
5208	P04075208	GREASE FITTING 1/4"-28 SAE STRAIGHT
5209	P04075209	BEAM COVER RIGHT
5210	P04075210	OSCILLATION AIR CYLINDER
5211	P04075211	ROD END BEARING PHS-10 FEMALE
5212	P04075212	HEX NUT 3/8-16
5213	P04075213	CAP SCREW 3/8-16 X 1-1/4



Body



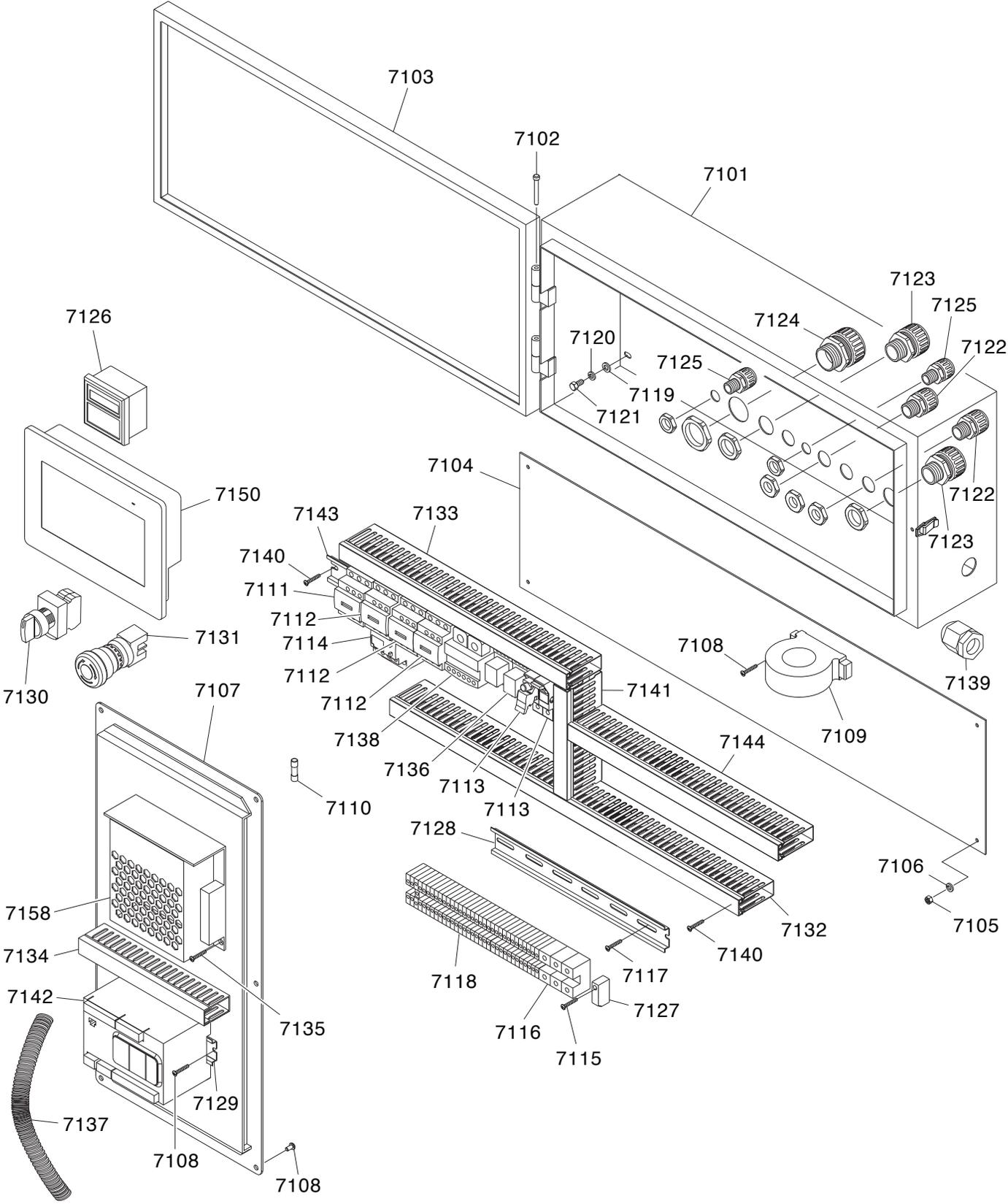
Body Parts List

REF	PART #	DESCRIPTION
6101	P04076101	UPPER FRAME COVER
6102	P04076102	HEX BOLT M6-1 X 12
6103	P04076103	PHLP HD SCR M6-1 X 10
6104	P04076104	DOOR LEFT
6105	P04076105	DOOR RIGHT
6106	P04076106	DOOR LOCK
6107	P04076107	HEX BOLT 5/16-18 X 3/4
6108	P04076108	FLAT WASHER 5/16
6109	P04076109	ACCESS PANEL RIGHT
6110	P04076110	FLAT HD SCR 1/4-20 X 1/2
6111	P04076111	DEPTH PLATE
6112	P04076112	LOCK WASHER 5/16
6113	P04076113	PIVOT PLATE
6114	P04076114	LOCK WASHER 1/4
6115	P04076115	HEX BOLT 1/4-20 X 3/4
6116	P04076116	HEX NUT 5/16-18

REF	PART #	DESCRIPTION
6117	P04076117	ACCESS PANEL LEFT
6118	P04076118	CAP SCREW M6-1 X 8
6201	P04076201	LIMIT SWITCH MOUJEN ME-8111
6201-1	P04076201-1	CORD 20G 2W 18"
6202	P04076202	LIMIT SWITCH MOUNT
6203	P04076203	PHLP HD SCR M5-.8 X 10
6204	P04076204	FLAT WASHER 1/4
6205	P04076205	PEG MOUNT
6206	P04076206	THICKNESS PEG 5/16-18 X 5/8
6207	P04076207	CAP SCREW 1/4-20 X 3/4
6208	P04076208	SENSOR COVER
6210	P04076210	PLEXIGLASS WINDOW 18-1/2" X 9-1/2"
6211	P04076211	HEX NUT 1/4-20
6212	P04076212	SLEEVE WASHER 6MM
6213	P04076213	LED STRIP L2W-Z-5050-24RGBWW 36"
6214	P04076214	CONDUIT 1/4" X 3/8" X 5"



Electrical Cabinet & Control Panel



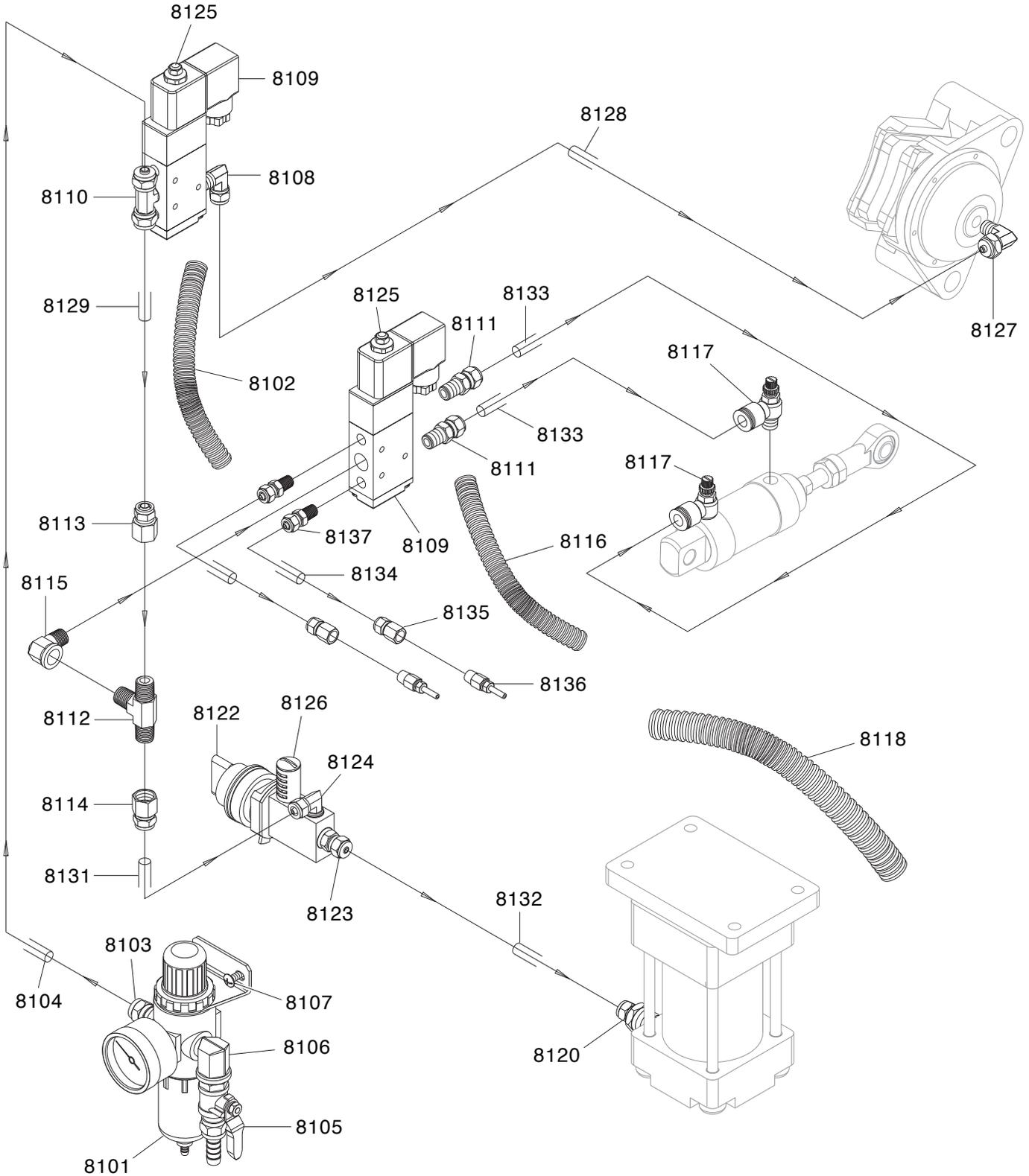
Electrical Cabinet & Control Panel Parts List

REF	PART #	DESCRIPTION
7101	P04077101	ELECTRICAL CABINET
7102	P04077102	HEADED PIN 8 X 55MM
7103	P04077103	ELECTRICAL CABINET DOOR
7104	P04077104	CABINET MOUNTING PLATE
7105	P04077105	HEX NUT 1/4-20
7106	P04077106	LOCK WASHER 1/4
7107	P04077107	PANEL MOUNTING PLATE
7108	P04077108	PHLP HD SCR M4-.7 X 8
7109	P04077109	CURRENT SENSOR ARLIH YAL-1
7110	P04077110	FUSE 4A 600V FAST-ACTING
7111	P04077111	CONTACTOR SCHNEIDER LC1D38M7 220V
7112	P04077112	CONTACTOR SCHNEIDER LC1D09M7 220V
7113	P04077113	FUSE HOLDER W/FUSE SCHNEIDER DF101
7114	P04077114	OL RELAY SCHNEIDER LR3D08 2.5-4A
7115	P04077115	TAP SCREW M4 X 9
7116	P04077116	TERMINAL BAR 3P DIN35 6G
7117	P04077117	PHLP HD SCR M4-.7 X 30
7118	P04077118	TERMINAL BAR 33P DIN35 12G
7119	P04077119	FLAT WASHER 1/4
7120	P04077120	LOCK WASHER 1/4
7121	P04077121	HEX BOLT 1/4-20 X 1/2
7122	P04077122	STRAIN RELIEF 1/2" KO
7123	P04077123	STRAIN RELIEF 3/4" KO

REF	PART #	DESCRIPTION
7124	P04077124	STRAIN RELIEF 1" KO
7125	P04077125	STRAIN RELIEF 3/8" KO
7126	P04077126	AMP METER NONI NI-729
7127	P04077127	TERMINAL END BLOCK DIN35
7128	P04077128	DIN RAIL TH35 X 7.5 X 255MM
7129	P04077129	DIN RAIL TH35 X 7.5 X 178MM
7130	P04077130	LIGHT SWITCH AUSPICIOUS A2-RS2-102W-LED
7131	P04077131	E-STOP SWITCH SCHNEIDER XB5AS8445
7132	P04077132	WIRE LOOM W/COVER 1" X 2-1/2" X 19"
7133	P04077133	WIRE LOOM W/COVER 1" X 2-1/2" X 14"
7134	P04077134	WIRE LOOM W/COVER 1" X 2-1/2" X 7"
7135	P04077135	PHLP HD SCR M3-.5 X 5
7136	P04077136	RELAY W/HOLDER
7137	P04077137	CONDUIT 7/8" X 1" X 50"
7138	P04077138	OL RELAY SCHNEIDER LT4760M7S 5-60A
7139	P04077139	STRAIN RELIEF M25-1.5
7140	P04077140	PHLP HD SCR M4-.7 X 8
7141	P04077141	WIRE LOOM W/COVER 1" X 2-1/2" X 6"
7142	P04077142	CONTROLLER SCHNEIDER TM200CE24R
7143	P04077143	DIN RAIL TH35 X 7.5 X 355MM
7144	P04077144	WIRE LOOM W/COVER 1" X 2-1/2" X 10"
7150	P04077150	TOUCHSCREEN SCHNEIDER HMIET6400
7158	P04077158	POWER SUPPLY DELTA PMT-24V100W2BA



Pneumatic System



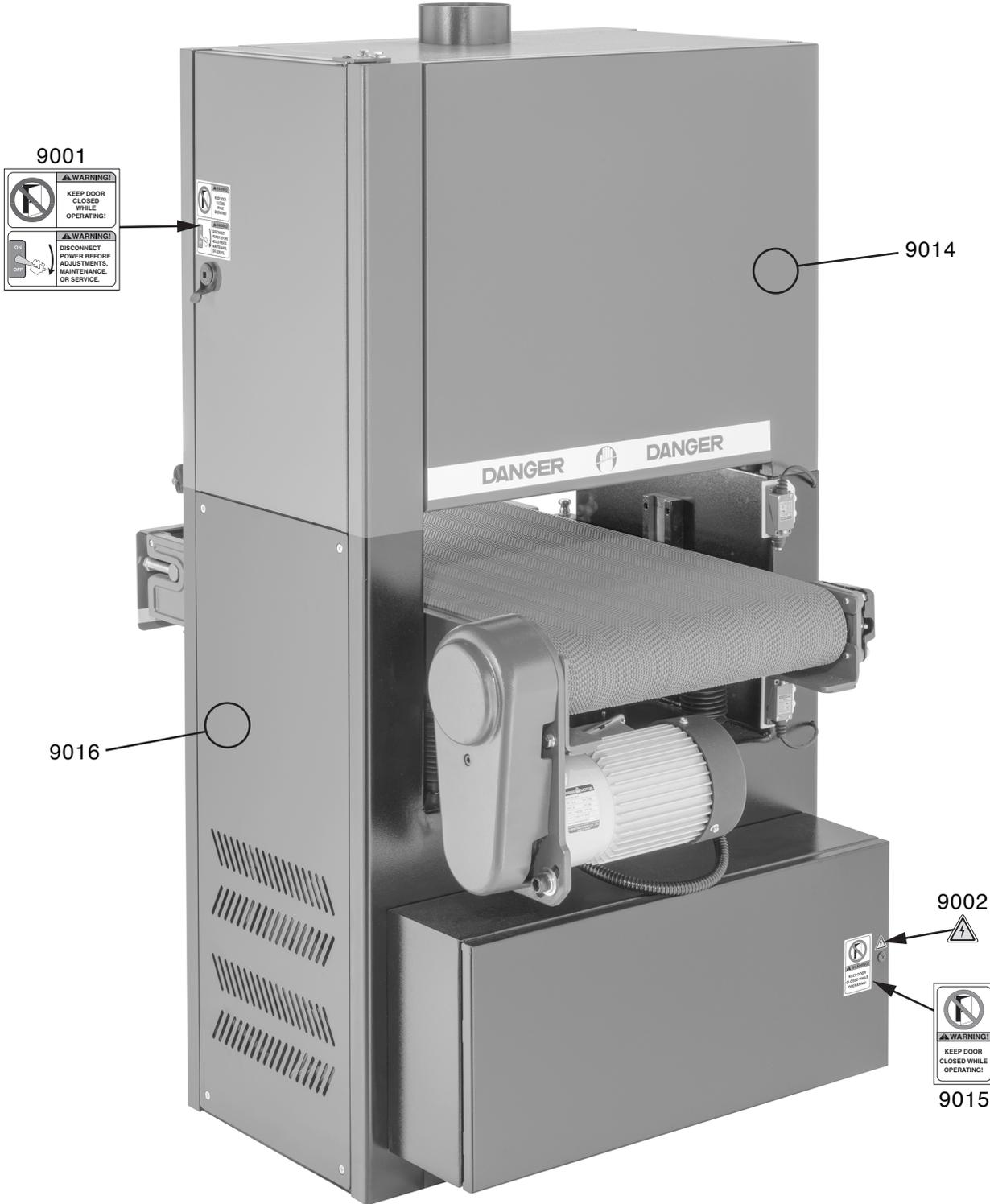
Pneumatic System Parts List

REF	PART #	DESCRIPTION
8101	P04078101	REGULATOR W/FILTER
8102	P04078102	CONDUIT 1/4" X 3/8" X 16"
8103	P04078103	PIPE-HOSE ADAPTER 1/4 NPT X 5/16"
8104	P04078104	FLEXIBLE HOSE 5/16" X 51-1/2"
8105	P04078105	BALL VALVE 1/4 NPT
8106	P04078106	PIPE FITTING 90-DEG 1/4 NPT
8107	P04078107	PHLP HD SCR 10-24 X 5/8
8108	P04078108	PIPE-TUBE ADAPTER 1/4 NPT X 5/16"
8109	P04078109	SOLENOID VALVE NEUMA NVA-6521
8110	P04078110	PIPE-TUBE ADAPTER 1/4 NPT X 5/16" X 5/16"
8111	P04078111	PIPE-TUBE ADAPTER 1/4 NPT X 1/4"
8112	P04078112	PIPE TEE-FITTING 1/4 NPT
8113	P04078113	PIPE-TUBE ADAPTER 1/4 NPT X 5/16"
8114	P04078114	PIPE-TUBE ADAPTER 1/4 NPT X 1/4"
8115	P04078115	PIPE FITTING 90-DEG 1/4 NPT
8116	P04078116	CONDUIT 1/4" X 3/8" X 6"
8117	P04078117	FLOW ADJ VALVE 1/8 NPT X 1/4"

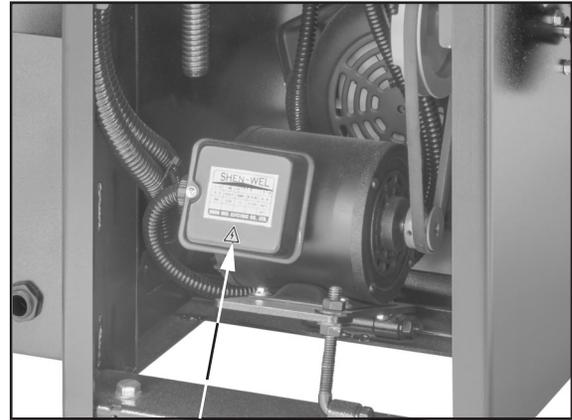
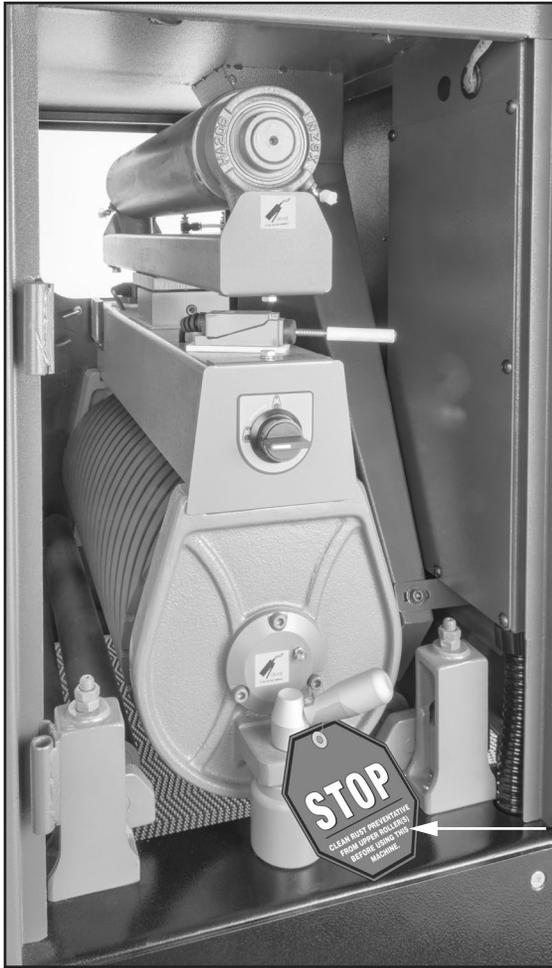
REF	PART #	DESCRIPTION
8118	P04078118	CONDUIT 1/4" X 3/8" X 36"
8120	P04078120	PIPE-TUBE ADAPTER 3/8 NPT X 1/4"
8122	P04078122	MECHANICAL VALVE SWITCH POSU 1/8 NPT
8123	P04078123	PIPE-TUBE ADAPTER 1/8 NPT X 1/4"
8124	P04078124	PIPE-TUBE ADAPTER 90-DEG 1/8 NPT X 1/4"
8125	P04078125	MUFFLER 1/8 NPT
8126	P04078126	MUFFLER 1/8 NPT PLASTIC
8127	P04078127	PIPE-TUBE ADAPTER 90-DEG 1/8 NPT X 5/16"
8128	P04078128	FLEXIBLE HOSE 5/16" X 31"
8129	P04078129	FLEXIBLE HOSE 5/16" X 6-1/2"
8131	P04078131	FLEXIBLE HOSE 1/4" X 77"
8132	P04078132	FLEXIBLE HOSE 1/4" X 17-1/2"
8133	P04078133	FLEXIBLE HOSE 1/4" X 40"
8134	P04078134	FLEXIBLE HOSE 1/4" X 49"
8135	P04078135	PIPE-TUBE ADAPTER 1/8 NPT X 1/4"
8136	P04078136	PIPE NOZZLE 1/8 NPT
8137	P04078137	PIPE-TUBE ADAPTER 1/8 NPT X 1/4"



Labels & Cosmetics (Cont.)



Labels & Cosmetics (Cont.)



9002

9017



REF	PART #	DESCRIPTION
9001	P04079001	DOOR CLOSED COMBO LABEL
9002	P04079002	ELECTRICITY LABEL
9003	P04079003	AMP DRAW LABEL
9004	P04079004	SANDPAPER HANG TAG
9005	P04079005	MODEL NUMBER LABEL
9006	P04079006	GRIZZLY NAMEPLATE
9007	P04079007	MACHINE ID LABEL
9008	P04079008	PINCH HAZARD LABEL
9009	P04079009	DEPTH PLATE NOTICE LABEL

REF	PART #	DESCRIPTION
9010	P04079010	GRIZZLY.COM LABEL
9011	P04079011	KICKBACK HAZARD LABEL
9012	P04079012	READ MANUAL COMBO LABEL
9013	P04079013	FRACTION CONVERSION LABEL
9014	P04079014	TOUCH-UP PAINT, GRIZZLY GREEN
9015	P04079015	KEEP CABINET DOOR CLOSED LABEL
9016	P04079016	TOUCH-UP PAINT, GLOSSY BLACK
9017	P04079017	RUST PREVENTATIVE HANG TAG

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.



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