MODEL G0408/G0409/G0411
EXTREME SERIES
WIDE-BELT SANDER
OWNER'S MANUAL
(For models manufactured since 05/26)

Model G0408



Model G0409



Model G0411



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#CS23893 PRINTED IN TAIWAN V2.06.26

******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.

Table of Contents

INTRODUCTION 3
Contact Info 3
Machine Differences 3
Manual Accuracy 3
Identification 4
Controls & Components 7
Machine Data Sheet 11

SECTION 1: SAFETY 14
Safety Instructions for Machinery 14
Additional Safety for Wide Belt Sanders 16
Additional Safety for Compressed Air 17

SECTION 2: POWER SUPPLY 18

SECTION 3: SETUP 23
Unpacking 23
Needed for Setup 23
Inventory 24
Cleanup 25
Site Considerations 26
Lifting & Placing 28
Leveling 29
Anchoring to Floor 29
Assembly 30
Dust Collection 33
Power Connection 33
Test Run 36
Recommended Adjustments 39

SECTION 4: OPERATIONS 40
Operation Overview 40
Sanding Workpieces 41
Workpiece Inspection 42
Sanding Tips 43
Changing Sanding Belt 44
Adjusting Platen (G0409/G0411 Only) 46
Adjusting Feed Rate 47
Reading Amp Draw Meter 47
Using EMERGENCY STOP! Bar 48
Using Workpiece Thickness Sensor 48
Safety Faults 49

SECTION 5: MAINTENANCE 50
Schedule 50
Cleaning & Protecting 50
Lubrication 50
Checking/Adjusting V-Belt Tension 54
Replacing V-Belts 56
Emptying Dust & Water Traps 59
Cleaning Sanding Belt 59

SECTION 6: SERVICE 60
Troubleshooting 60
Calibrating Workpiece Thickness Sensor 63
Calibrating Thickness Display 64
Adjusting Belt Tracking Limit Switches 65
Adjusting Oscillation Timing & Speed 65
Servicing Platen (G0409/G0411 Only) 68
Checking/Replacing Brake Pads 70
Checking/Adjusting Table Parallelism 74
Adjusting Pressure Rollers 77
Adjusting Conveyor Belt Tension 79
Adjusting Conveyor Belt Tracking 79
Replacing Conveyor Belt 80
Conveyor Belt Removal Sequence 83

SECTION 7: PNEUMATIC SYSTEM 84
G0408/G0409 Pneumatic Diagram 84
G0411 Pneumatic Diagram 85
Pneumatic System Component Photos 86

SECTION 8: WIRING 87
Wiring Safety Instructions 87
G0408/G0409 Wiring Overview 88
G0408/G0409 Electrical Cabinet Wiring 89
G0408/G0409 Control Box & Panel Wiring 90
G0408/G0409 Motor Wiring 92
G0408/G0409 Limit Switch Wiring 93
G0408/G0409 Solenoid Valve Coil Wiring 95
G0408/G0409 Sensor Wiring 95
G0411 Wiring Overview 96
G0411 Electrical Cabinet Wiring (220V) 97
G0411 Electrical Cabinet Wiring (440V) 98
G0411 Control Box & Panel Wiring 99
G0411 Main Motor Wiring 101
G0411 Feed Motor Wiring 102
G0411 Table Elevation Motor Wiring 103
G0411 Limit Switch Wiring 104
G0411 Solenoid Valve Coil Wiring 106
G0411 Sensor Wiring 106

SECTION 9: PARTS 107
G0408 Tool Box & Accessories 107
G0409/G0411 Tool Box & Accessories 108
G0408 Main Motor 109
G0409 Main Motor 111
G0411 Main Motor 113
G0408/G0409 Table Elevation 115
G0411 Table Elevation 117
G0408/G0409 Conveyor Table 119
G0411 Conveyor Table 121

G0408 Pressure Rollers 123
G0409/G0411 Pressure Rollers 124
G0408 Sanding Drum 125
G0409 Sanding Drums 126
G0411 Sanding Drums 128
G0408/G0409 Upper Roller 130
G0411 Upper Roller 132
G0408 Body 134
G0409 Body 136
G0411 Body 138
G0408/G0409 Main Electricals 140
G0411 Main Electricals 142
G0408/G0409 Pneumatic System 144
G0411 Pneumatic System 145
Labels & Cosmetics 146

WARRANTY & RETURNS 149

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

Machine Differences

The largest difference between the models covered in this manual is the overall machine size and workpiece capacity.

The Model G0408 has single-drum sanding head while the Model G0409 and Model G0411 are dual-drum, allowing for a platen that can be adjusted to provide additional workpiece support.

Additionally, the Model G0408 and Model G0409 operate on 220V single-phase power. The Model G0411 operates on 220V or 440V 3-phase power.

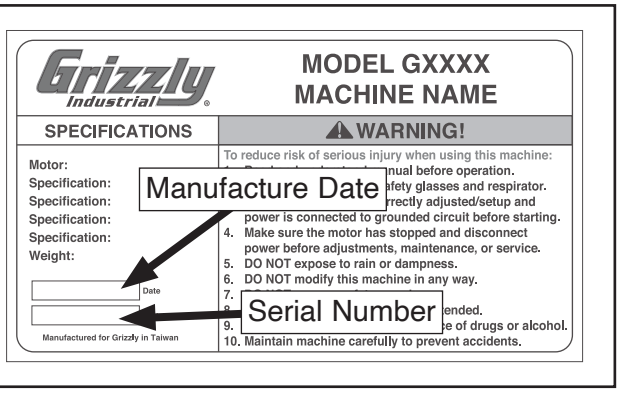
Manual Accuracy

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

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

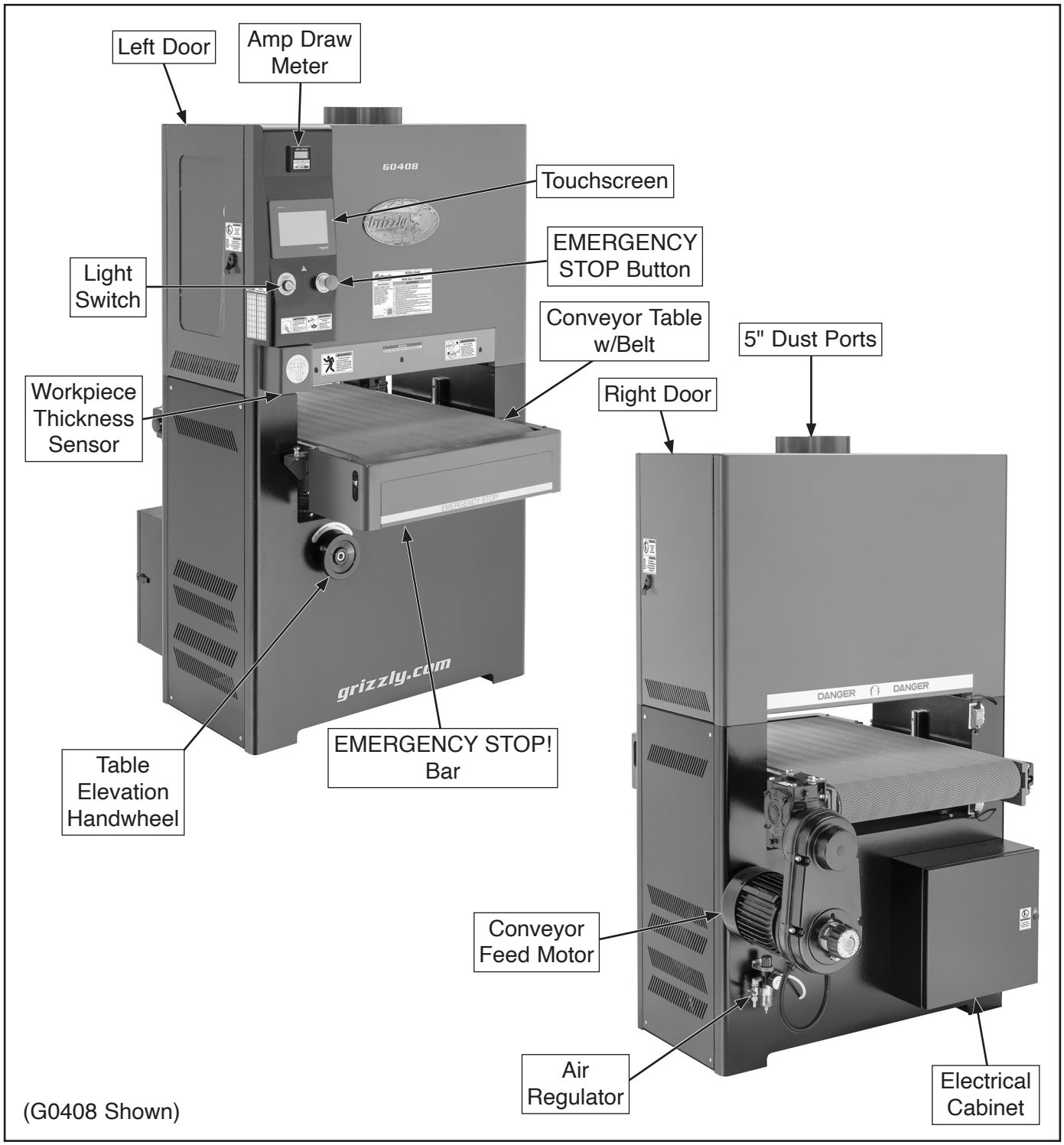
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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



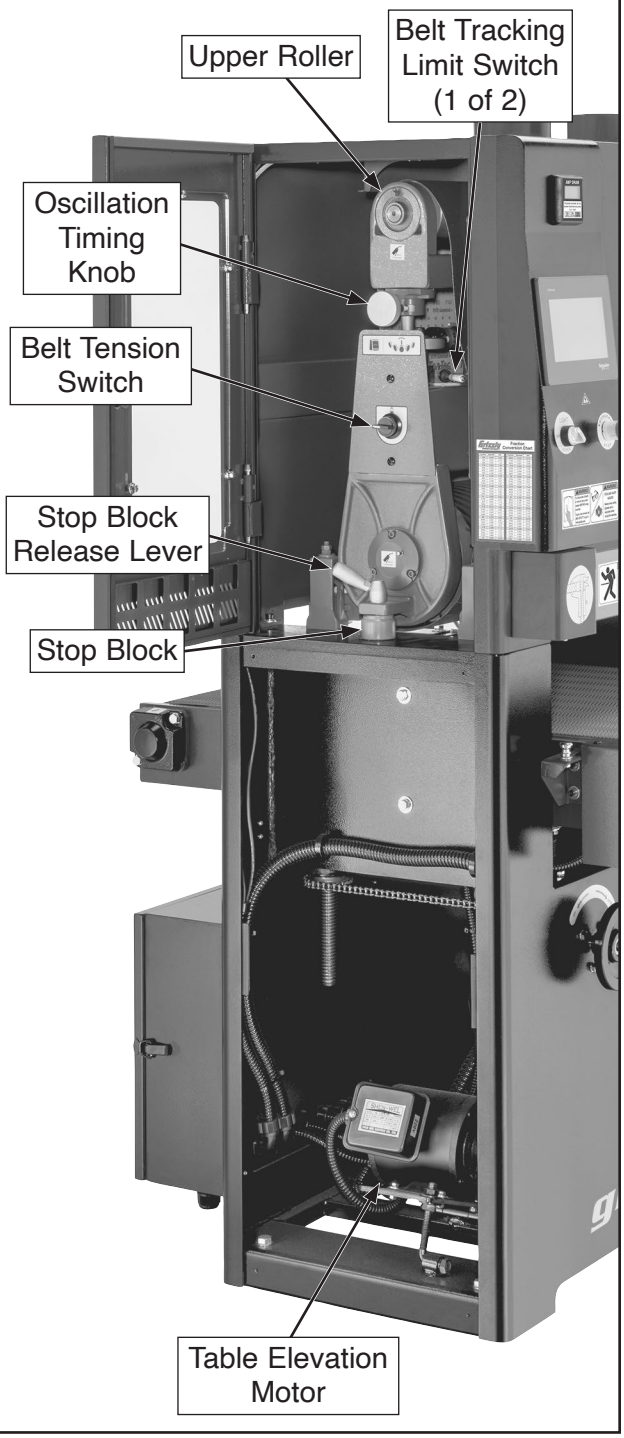
Identification

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

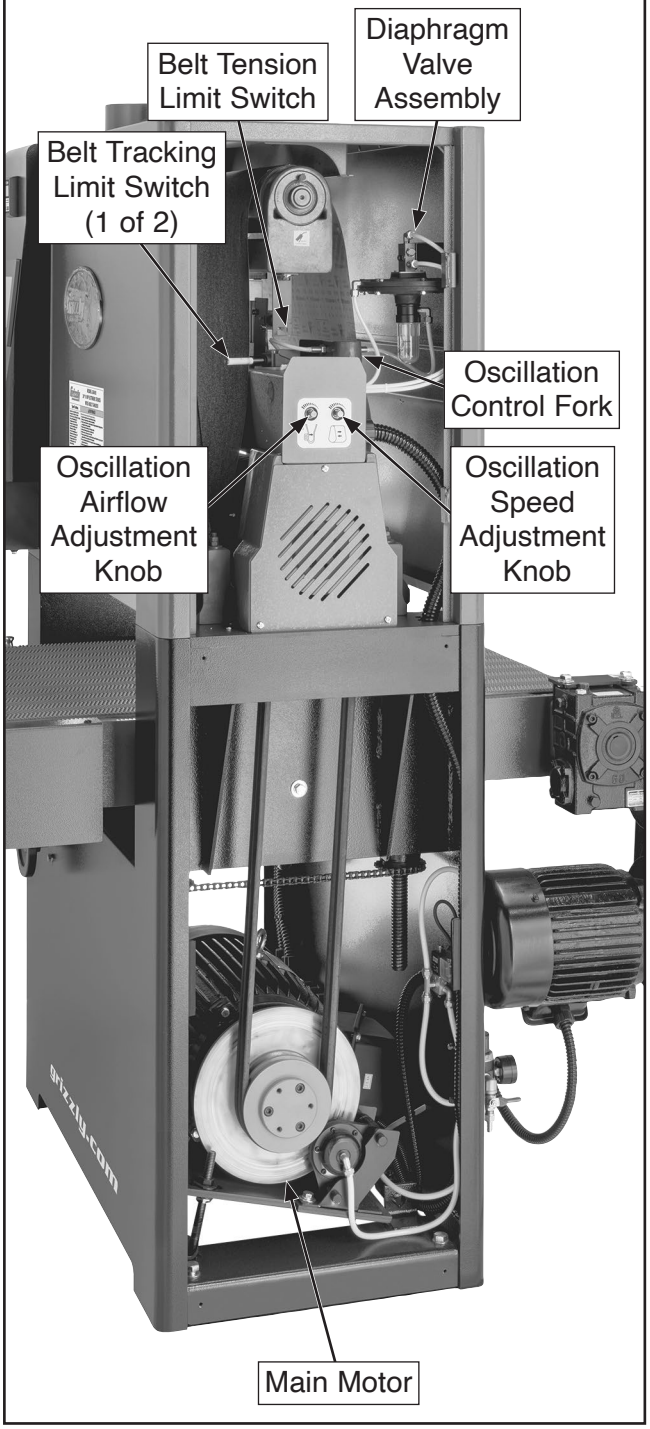


(G0408 Shown)

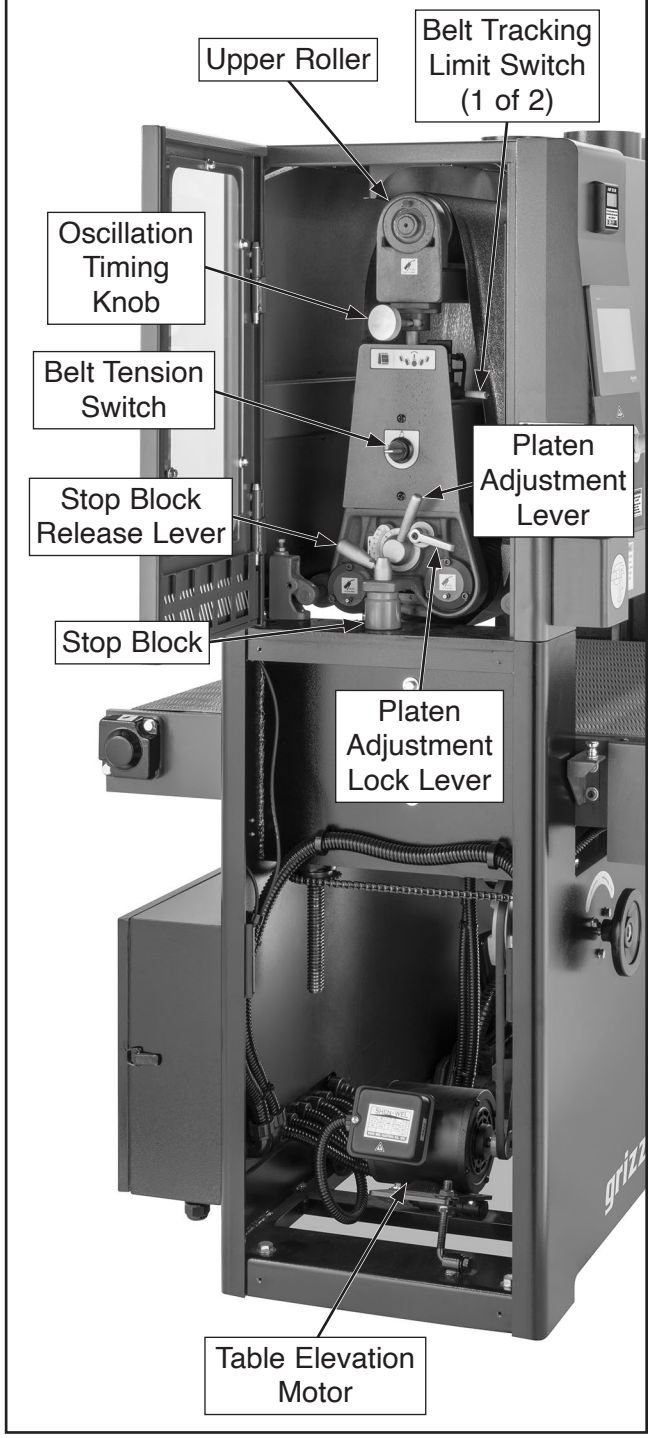
(G0408 Left Side Interior)



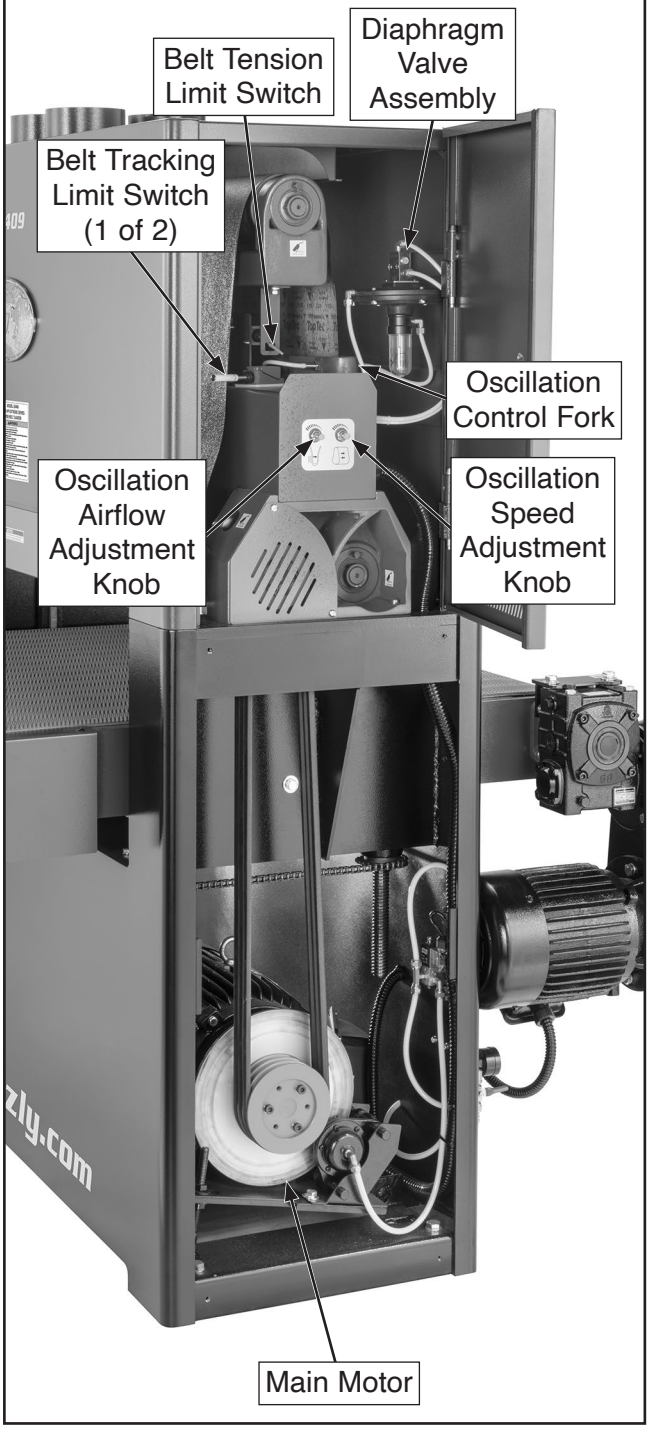
(G0408 Right Side Interior)



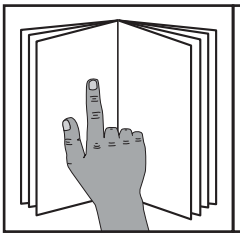
(G0409/G0411 Left Side Interior)



(G0409/G0411 Right Side Interior)



Controls & Components



⚠WARNING

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

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

Control Panel

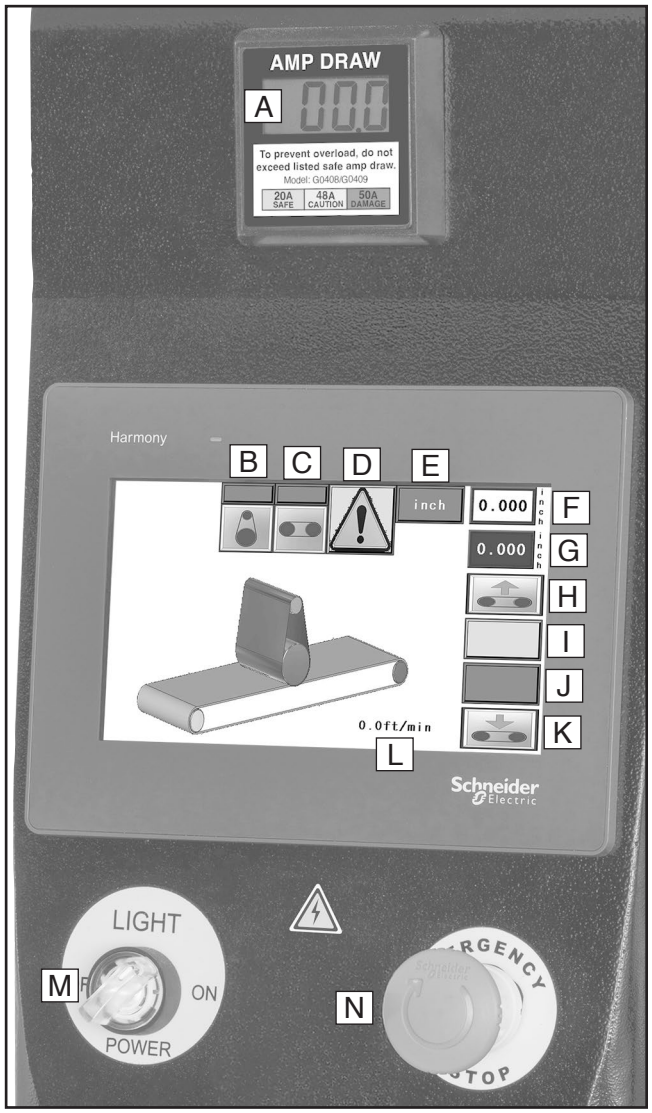


Figure 1. Control panel components.

A. Amp Draw Meter: Indicates amp load of main motor during sanding operations. Used to determine maximum depth of cut sander can handle.

B. Sanding Belt ON/OFF Button: Turns main motor ***ON*** or ***OFF***.

C. Conveyor Belt ON/OFF Button: Turns conveyor feed motor ***ON*** or ***OFF***.

D. Fault Indicator: Illuminates red when machine is engaged in a safety fault: motors will stop, interior lights will turn red, active fault log screen will appear, and table will automatically lower to prevent machine damage.

E. Inch/mm Button: Toggles display measurements between in./ft. or mm when held.

F. Thickness Display: Shows table position in relation to drum(s) (i.e., workpiece thickness).

G. Adjust Thickness Value: Shows desired table position (i.e., workpiece thickness). Table will move to entered value after 3–5 seconds.

H. Table Up Button: Decreases "adjust thickness value" by 0.005" (0.125mm) when pressed; continuously moves table up when held.

I. Cleared Fault Button: Returns table to last entered value when table has automatically lowered due to safety fault.

J. Calibration Button: Calibrates thickness display to same value as "adjust thickness" value when held.

K. Table Down Button: Increases "adjust thickness" value by 0.005" (0.125mm) when pressed; continuously moves table down when held.

L. Feed Rate Display: Shows conveyor feed rate in ft./min. or mm/min.

M. Light Switch: Turns machine interior light ***ON*** or ***OFF***.

N. EMERGENCY STOP Button: Turns all machine functions ***OFF***; engages emergency brake to stop drum(s). Twist clockwise to reset.

Sanding Belt

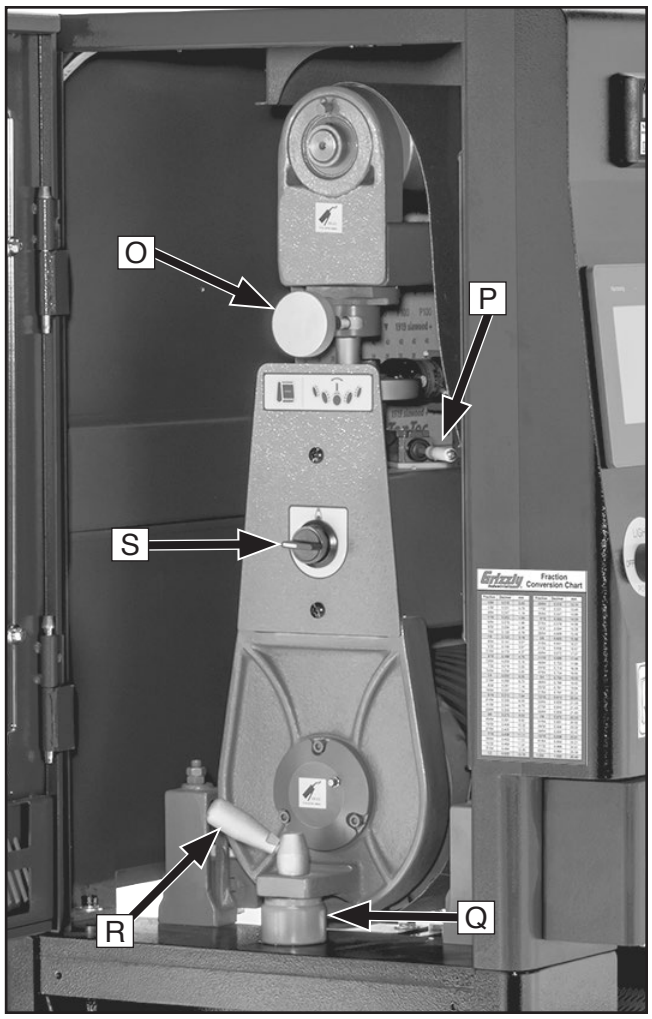


Figure 2. Left sanding belt components (G0408 shown).

O. Oscillation Timing Knob: Adjusts timing of sanding belt oscillation from left to right.

P. Belt Tracking Limit Switch (1 of 2): Stops main motor if sanding belt tracking is incorrect.

Q. Stop Block: Prevents sanding belt from oscillating off of drum(s) and roller.

R. Stop Block Release Lever: Unlocks to remove stop block.

S. Belt Tension Switch: Engages or disengages sanding belt tension.

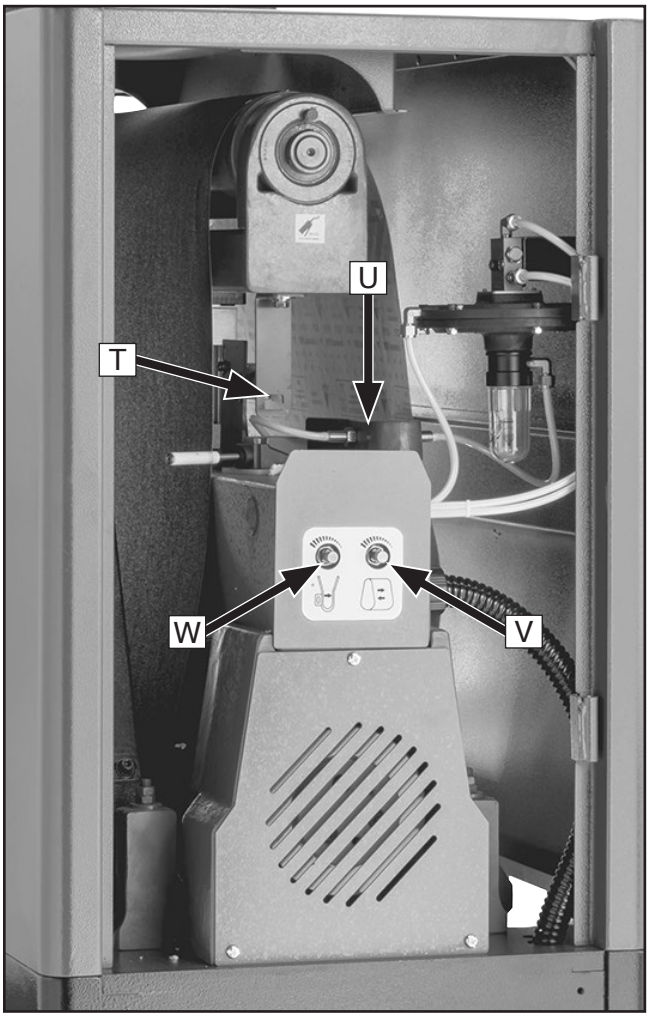


Figure 3. Right sanding belt components (G0408 shown).

T. Belt Tension Limit Switch: Stops main motor if sanding belt tension is incorrect.

U. Oscillation Control Fork: Directs sanding belt to reverse oscillation direction when it passes through air fork.

V. Oscillation Speed Adjustment Knob: Controls oscillation speed of sanding belt as it moves left and right.

W. Oscillation Airflow Adjustment Knob: Controls airflow to pneumatic cylinder.

Conveyor Table

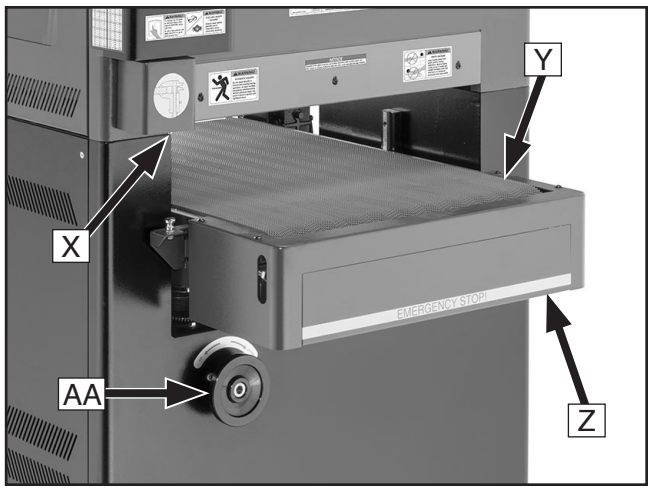


Figure 4. Front conveyor table components (G0408 shown).

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

Note: *While sensor is engaged, all touchscreen table 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.*

Y. Conveyor Table w/Belt: Supports and feeds workpiece during operations; can be raised or lowered according to workpiece thickness.

Z. EMERGENCY STOP! Bar: Stops all machine functions when pressed; engages emergency brake to stop rotating drum(s).

AA. 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).

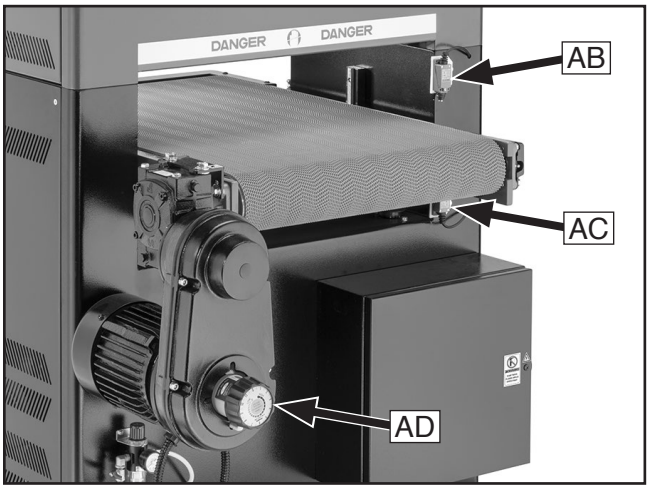


Figure 5. Rear conveyor table components (G0408 shown).

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

Note: *While switch is engaged, all touchscreen 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.*

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

Note: *While switch is engaged, all touchscreen 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.*

AD. Feed Rate Adjustment Knob: While conveyor is moving, turn knob clockwise to increase feed rate, and turn it counterclockwise to decrease feed rate.

Air Supply

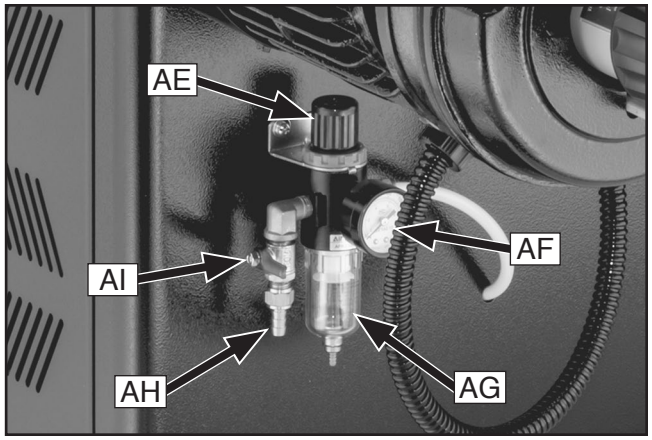


Figure 6. Air regulator components.

AE. Air Regulator Knob: Adjusts incoming air pressure. Lift knob and rotate clockwise to *increase* PSI; lift knob and rotate counterclockwise to *decrease* PSI.

AF. Air Regulator Gauge: Displays air pressure entering machine pneumatic system.

AG. Filter Trap: Filters water and dirt from incoming air and collects it for draining.

AH. Air Inlet: Connects to compressed air supply of 75 PSI with a ⅜" air hose.

AI. Air Supply Valve: Opens to pneumatically power sanding belt tracking and oscillation; closes to stop air from entering machine pneumatic system.

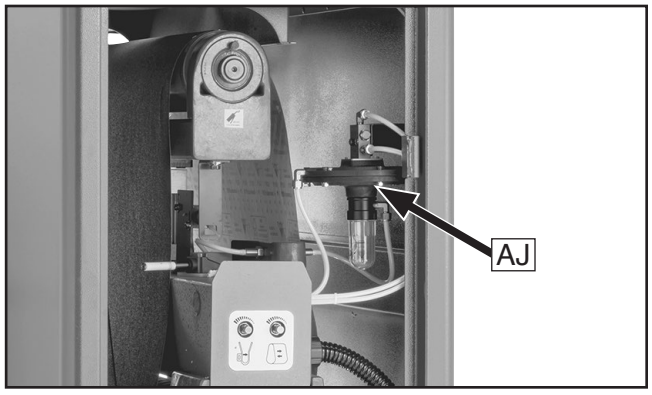


Figure 7. Diaphragm valve assembly.

AJ. Diaphragm Valve Assembly: Directs air for tracking and tension, and collects and traps dust within.

Platen (G0409/G0411 Only)

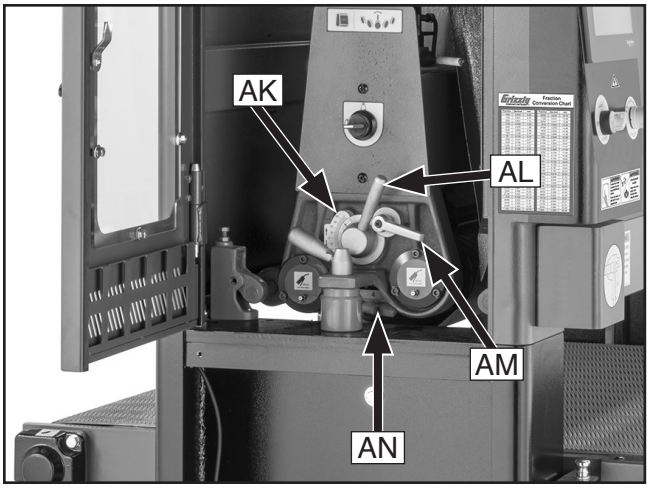


Figure 8. Platen components.

AK. Platen Scale: Indicates height of platen above or below sanding drums.

AL. Platen Adjustment Lever: Adjusts platen height for three basic types of sanding: initial heavy sanding pass, intermediate finishing pass, and final sanding pass.

AM. Platen Adjustment Lock Lever: Loosens to adjust platen height; tightens to secure.

AN. Platen: Adjusts up and down in relation to drums to provide belt support and achieve a smoother finish.

Grizzly Industrial, Inc.®

MACHINE DATA SHEET

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

EXTREME SERIES WIDE-BELT SANDERS

Model Number	G0408	G0409	G0411
Product Dimensions			
Weight	1345 lbs.	1533 lbs.	2535 lbs.
Width (side-to-side)/Depth (front-to-back)/Height	42 x 50 x 68 in.	53 x 50 x 66 in.	70 x 48 x 65 in.
Foot Print (Width/Depth)	39-1/2 x 19-1/2 in.	51 x 19 in.	68 x 20-1/2 in.
Shipping Dimensions			
Carton #1 Type	Wood Crate		
Content	Machine		
Weight	1533 lbs.	1808 lbs.	2822 lbs.
Width (side-to-side)/Depth (front-to-back)/Height	53 x 46 x 77 in.	58 x 53 x 77 in.	73 x 53 x 77 in.
Must Ship Upright	Yes		
Electrical			
Power Requirement	220V, Single-Phase, 60 Hz		220V or 440V, 3-Phase, 60 Hz
Prewired Voltage	N/A		220V
Full-Load Current Rating	57A		78A at 220V, 39A at 440V
Minimum Circuit Size	80A		100A at 220V, 50A at 440V
Connection Type	Permanent (Hardwire to Shutoff Switch)		
Switch Type	Control Panel w/Magnetic Switch Protection		
Main Motor			
Horsepower	10 HP		30 HP
Phase	Single-Phase		3-Phase
Amps	50A		72A/36A
Speed	1720 RPM		1750 RPM
Type	TEFC Capacitor-Start Induction		AEEF
Power Transfer	Belt		
Bearings	Shielded & Permanently Lubricated		
Centrifugal Switch/Contacts Type	Internal		N/A
Feed Motor			
Horsepower	1 HP		2 HP
Phase	Single-Phase		3-Phase
Amps	7A		6A/3A
Speed	1720 RPM		1710 RPM
Type	TEFC-Capacitor Start Induction		AEVF
Power Transfer	Belt		
Bearings	Shielded & Permanently Lubricated		

Model Number	G0408	G0409	G0411
Feed Motor (Cont.)			
Centrifugal Switch/Contacts Type	Internal		N/A
Table Elevation Motor			
Horsepower	1/3 HP		1/4 HP
Phase	Single-Phase		3-Phase
Amps	3A		1.2A/0.6A
Speed	1720 RPM		1650 RPM
Type	TEFC Capacitor-Start Induction		AEEF
Power Transfer	Belt		
Bearings	Shielded & Permanently Lubricated		
Centrifugal Switch/Contacts Type	Internal		N/A
Operation Information			
Number of Sanding Heads	1		
Maximum Board Width	24-3/8 in.	36-1/2 in.	51 in.
Minimum Board Width	2 in.		
Maximum Board Thickness	6 in.		
Minimum Board Thickness	1/8 in.		3/16 in.
Minimum Board Length	10 in.	14 in.	
Sandpaper Speed	3500 FPM	2565 FPM	
Sanding Belt Oscillations Per Minute	35–40 OPM		
Sanding Belt Oscillation Stroke Length	3/16–5/8 in.		
Conveyor Feed Rate	15–49 FPM		14–60 FPM
Sandpaper Length	60 in.		
Sandpaper Width	25 in.	37 in.	51 in.
Drum Information			
Infeed Sanding Drum Type	Spiral Grooved Rubber		
Infeed Sanding Drum Size	8 in.	4 in.	
Outfeed Sanding Drum Type	N/A	Steel	
Outfeed Sanding Drum Size	N/A	3 in.	
Shore Hardness (Durometer)	70 Shore	65 Shore	
Platen Information			
Platen Type	N/A	Adjustable Graphite Pad	
Platen Length	N/A	37-3/4 in.	52-1/2 in.
Platen Width	N/A	2-1/4 in.	
Platen Travel	N/A	0–3.5mm	
Construction			
Conveyor Belt	Rubber		
Body	Steel		
Paint Type/Finish	Powder Coated		
Other Related Information			
Floor To Table Height	32–37-9/16 in.	31-15/16–37-7/16 in.	30-3/4–36-1/4 in.
Belt Tracking	Pneumatic		
Sanding Belt Tension	Pneumatic		
Number of Pressure Rollers	4	2	

Model Number	G0408	G0409	G0411
Other Related Information (Cont.)			
Pressure Roller Type	Rubber		
Pressure Roller Size	1-9/16 in.		2 in.
Conveyor Table Length	41-1/2 in.	41-5/8 in.	39-1/2 in.
Conveyor Belt Length	82-11/16 in.		78-3/4 in.
Conveyor Belt Width	24-3/8 in.	36-1/2 in.	51-3/16 in.
Belt Roller Size	4 in.		
Number of Dust Ports	2	3	4
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	Yes		

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for 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.



⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 220V
—G0408/G0409.....57A
—G0411 ..... 78A
Full-Load Current Rating at 440V
—G0411 ..... 39A

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

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

Circuit Information

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

⚠CAUTION

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

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

G0408/G0409 Circuit Requirements

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle.....60 Hz
Phase..... Single-Phase
Power Supply Circuit ..... 80 Amps

G0411 Circuit Requirements

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 100 Amps

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Converting G0411 Voltage to 440V** instructions for details.)

Nominal Voltage 440V, 480V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 50 Amps

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.

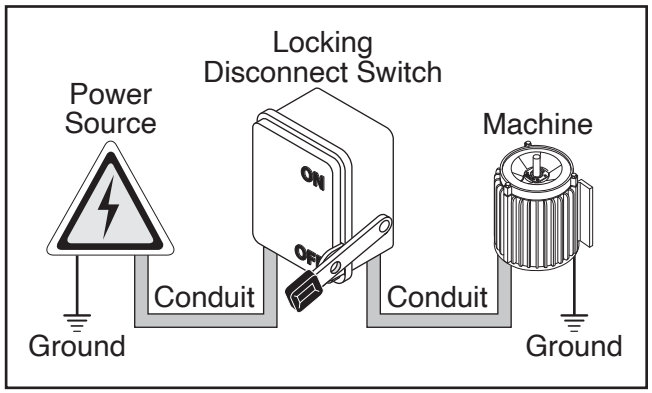


Figure 9. Typical setup of a permanently connected machine.

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.

NOTICE

DO NOT use a phase converter to supply 3-phase power, as it could damage or decrease life of electrical components. Damage caused by running this machine with a phase converter will not be covered under warranty.

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!

Converting G0411 Voltage to 440V

The Model G0411 is prewired to operate on 220V power, but it can be converted for 440V operation. This conversion must be done by an electrician or qualified service personnel before the machine has been connected to power. The procedure consists of: 1) moving a wire on the transformer from the 220V to the 440V terminal, 2) replacing the main and feed motor overload relays, and 3) rewiring the motors for 440V operation.

Wiring diagrams are provided in the back of this manual showing the Model G0411 wired for both 220V and 440V. Refer to these when following this procedure.

IMPORTANT: If the diagram included on any of the motors conflicts with the one shown in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Flat Head Screwdriver 1/16" (or Smaller)	1
Hex Wrenches 4, 5mm	1 Ea.
Wrenches 8, 10mm	1 Ea.
Schneider Overload Relays	
—LR3D325 (P04117112X)	1
—LR3D08 (P04117114X)	1
Phillips Head Screws M6-1 x 12	3
Hex Nuts M6-1	3
Transfer Tape	As Needed
Electrical Tape	As Needed

To convert G0411 voltage to 440V:

1. Remove Phillips head screw shown in **Figure 10**, then open electrical cabinet door.

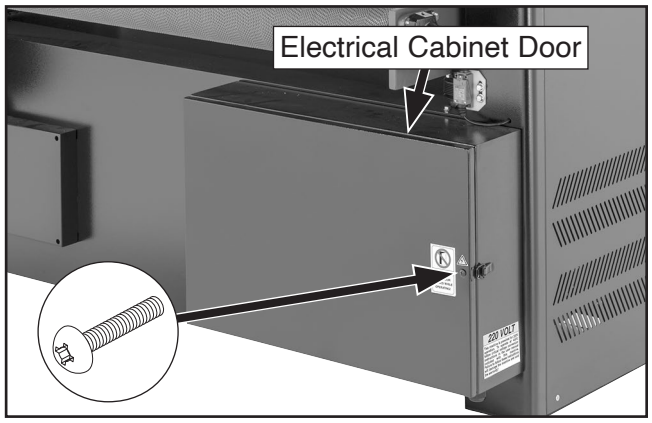


Figure 10. Electrical cabinet door and screw.

2. Remove wire labeled "1" at 220V terminal of transformer (see **Figure 11**) and connect it to 440V terminal.

   Note: *Press rear of terminal spring clamp to release/attach wire.*

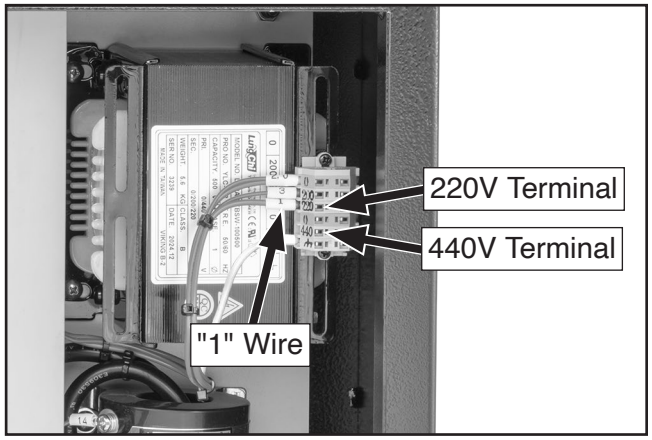


Figure 11. Location of "1" wire and supply voltage terminals on transformer.

3. Remove main motor overload relay (see **Figure 12**), replace it with LR3D325 (17–25A) relay, and set dial to 18A.

4. Remove feed motor overload relay (see **Figure 12**), replace it with LR3D08 (2.5–4A) relay, and set dial to 3A.

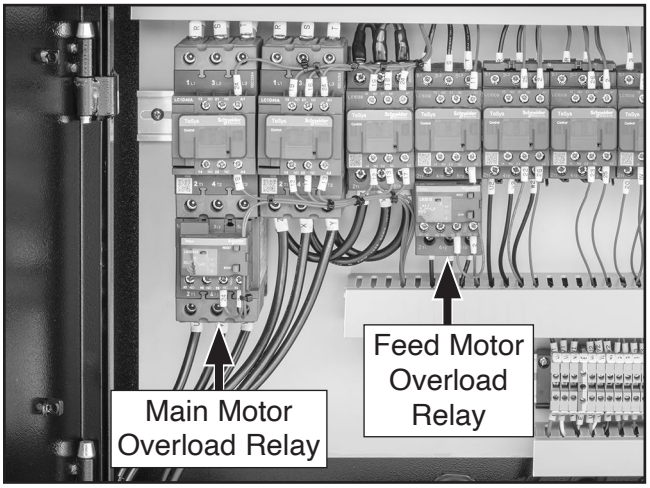


Figure 12. Location of main motor and feed motor overload relays.

5. Remove (4) cap screws shown in **Figure 13** to remove main motor access panel.

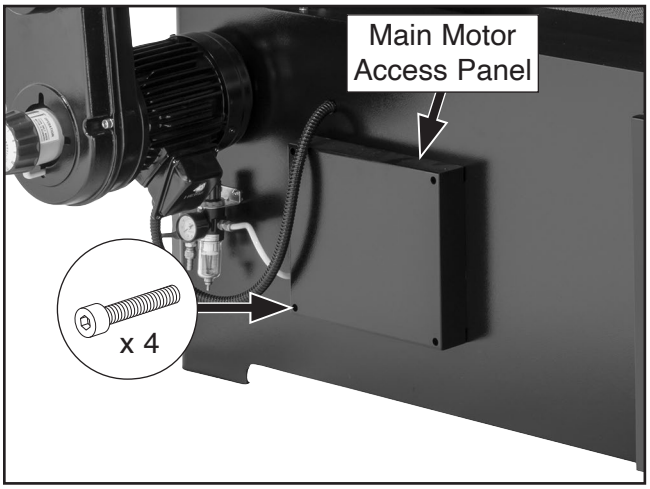


Figure 13. Location of main motor access panel and screws.

6. Open main motor junction box and remove (12) terminal hex nuts (see **Figure 14**) to disconnect motor wires.

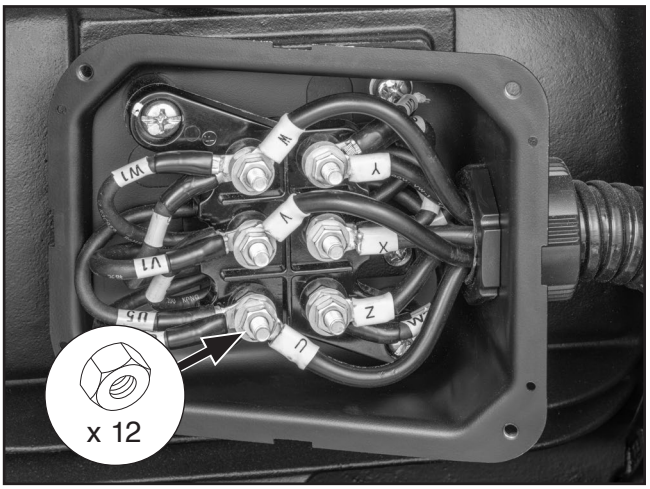


Figure 14. Location of terminal hex nuts in main motor junction box.

7. Connect "W2" wire to "W5" wire with (1) M6-1 x 12 Phillips head screw and M6-1 hex nut, as shown in **Figure 15**, then wrap screw and nut with heat transfer tape and electrical tape.

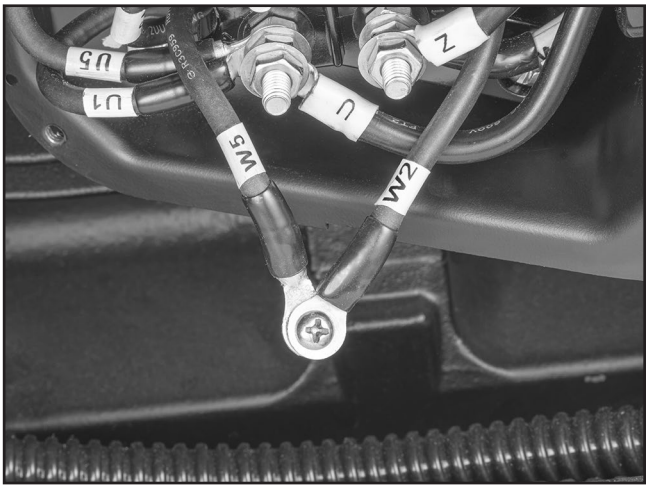


Figure 15. W2 and W5 wires connected with screw and nut.

8. Repeat **Step 7** to connect "U2" and "U5" wires.

9. Repeat **Step 7** to connect "V2" and "V5" wires.

10. Use hex nuts removed in **Step 6** to connect remaining main motor wires to terminals shown in **Figure 16**, then close main motor junction box.

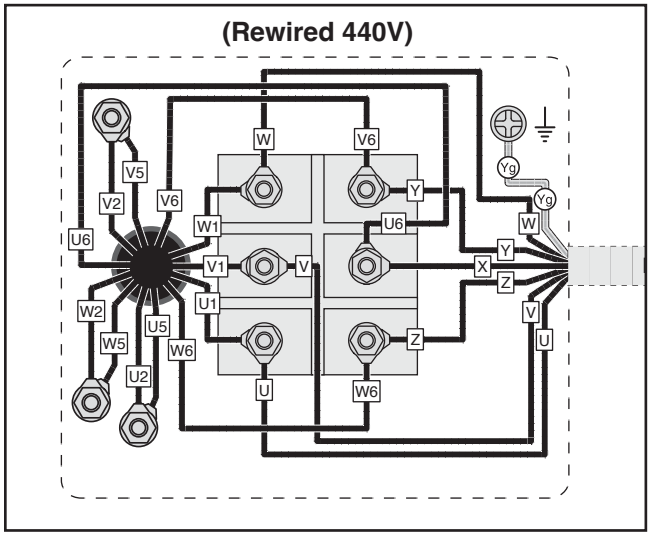


Figure 16. Main motor wired for 440V operation.

11. Remove (8) screws shown in **Figure 17** to remove left and right access panels.

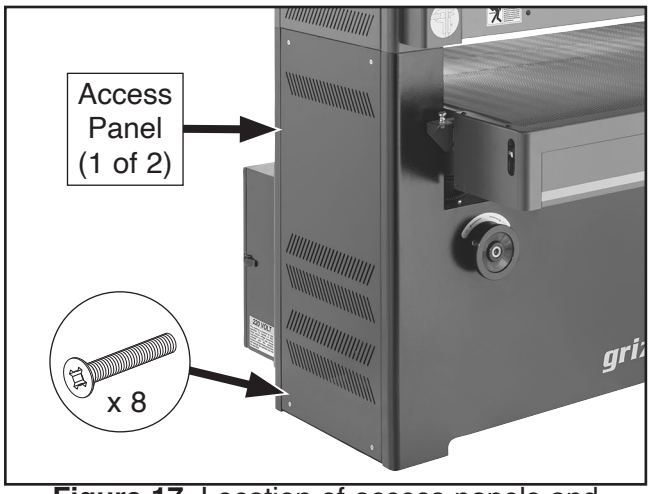


Figure 17. Location of access panels and screws.

12. Open feed motor junction box and remove (6) terminal hex nuts (see **Figure 18**) to disconnect motor wires.

13. Remove (2) jumpers from terminals (see **Figure 18**). Jumpers will not be reused.

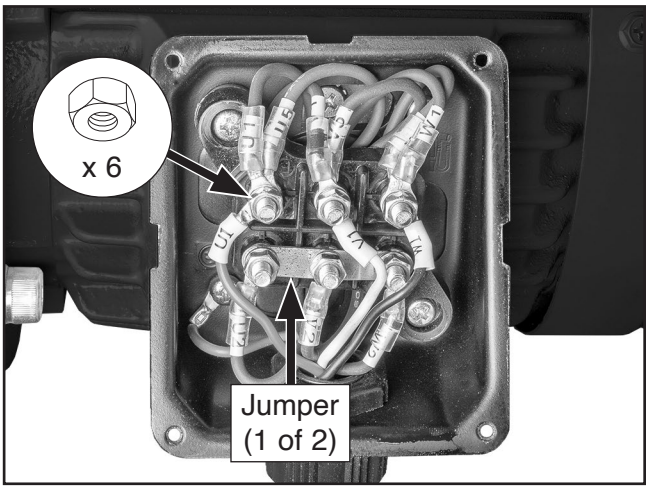


Figure 18. Location of terminal hex nuts and jumpers in feed motor junction box.

14. Use hex nuts removed in **Step 12** to connect feed motor wires to terminals shown in **Figure 19**, then close feed motor junction box.

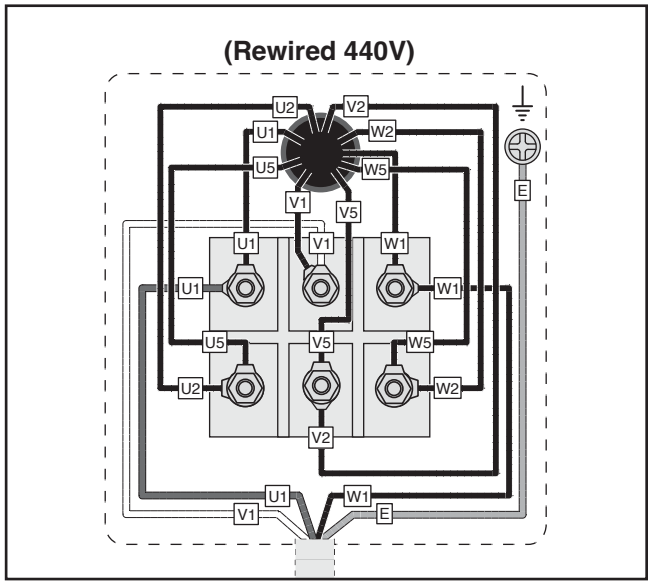


Figure 19. Feed motor wired for 440V operation.

15. Open table elevation motor junction box and remove (6) terminal hex nuts (see **Figure 20**) to disconnect motor wires.

16. Remove (2) jumpers from terminals (see **Figure 20**). Jumpers will not be reused.

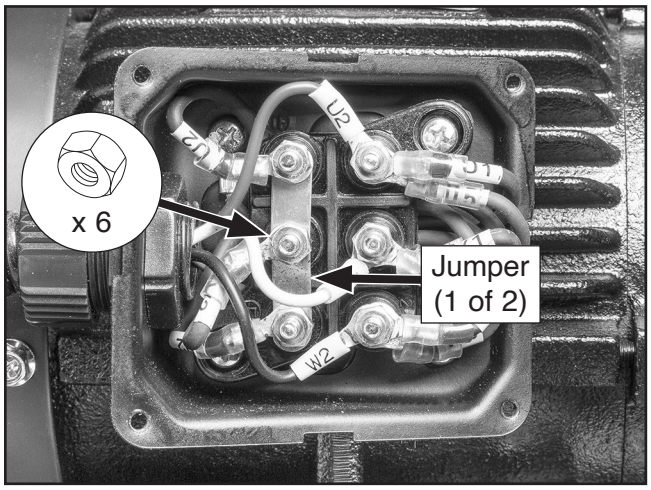


Figure 20. Location of terminal hex nuts and jumpers in table elevation motor junction box.

17. Use hex nuts removed in **Step 15** to connect table elevation motor wires to terminals shown in **Figure 21**, then close table elevation motor junction box.

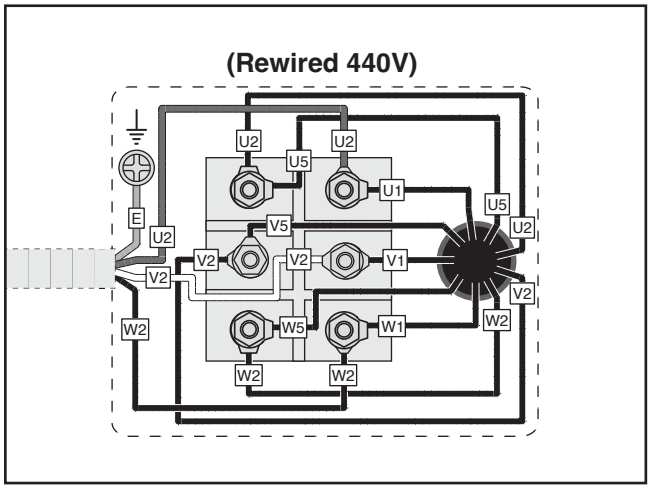
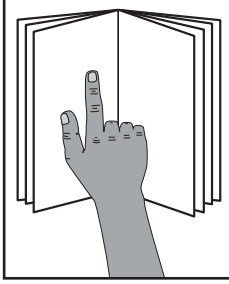


Figure 21. Table elevation motor wired for 440V operation.

18. Install access panels.

19. Close electrical cabinet door, then secure with screw removed in **Step 1**.

SECTION 3: SETUP



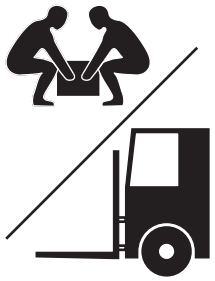
⚠WARNING

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.

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.*

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	
G0408 (Rated For at Least 2000 lbs.)	1
G0409 (Rated For at Least 2300 lbs.)	1
G0411 (Rated For at Least 3600 lbs.)	1
• Level	1
• Compressed Air Supply (Rated For at Least 75 PSI)	1
• Air Hose 3/8" (Rated For at Least 75 PSI)	1
• Hose Clamp 3/8"	1
• 2x4 (24" Long)	1
• Jointer	1
• Table Saw	1
• Dust Hoses 5"	
G0408	2
G0409	3
G0411	4
• Hose Clamps 5"	As Needed
• Dust Collection System	1
• Flat Head Screwdriver 1/8"	1
• Open-End Wrenches 33mm	2

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 22)	Qty
A. Door Keys	2
B. Sanding Belt 100-Grit	1
C. Sanding Belt	
150-Grit (G0408)	1
180-Grit (G0409/G0411)	1
D. Flexible Grease Gun Extension	1
E. Phillips Head Screwdriver #2	1
F. Flat Head Screwdriver ¼"	1
G. Tool Box	1
H. Hex Wrenches	
1.5, 2, 2.5, 3, 4, 5, 5.5, 6, 8, 10mm	1 Ea.
I. Open-End Wrenches	
8 x 10, 12 x 14, 17 x 19mm	1 Ea.
J. Spare Limit Switch Tips	2
K. Spare Fuses 4A 600V	2
L. Strain Relief	1

G0409/G0411 Only (Figure 23)	Qty
M. Platen Removal Tool	1
N. Platen Felt Pad	1
O. Platen Graphite Pads	2

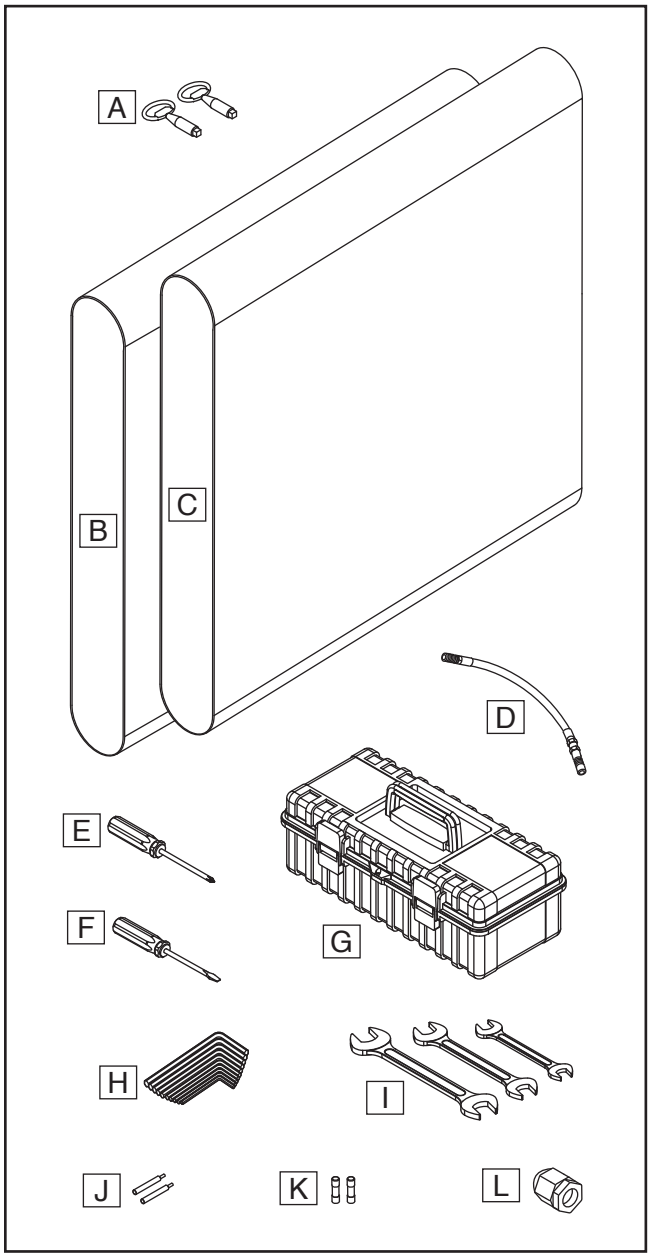


Figure 22. Loose inventory.

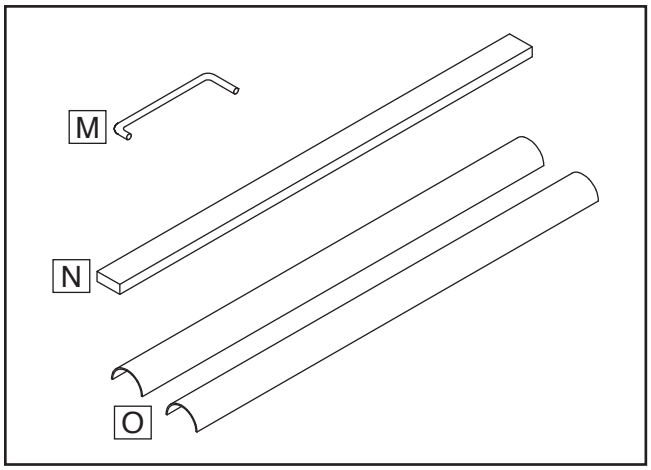


Figure 23. Additional inventory for G0409/G0411.

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.

Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.

2. Coat rust preventative with liberal amount of cleaner/degreaser (WD•40 works well), then let it soak for 5–10 minutes.

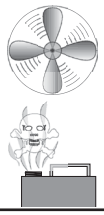
3. Wipe off surfaces. If cleaner/degreaser is effective, rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with a rag.

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



⚠WARNING

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



⚠CAUTION

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

NOTICE

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

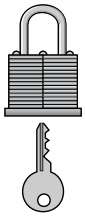
Site Considerations

Weight Load

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

Space Allocation

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



⚠CAUTION

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

Physical Environment

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

Electrical Installation

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

Lighting

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

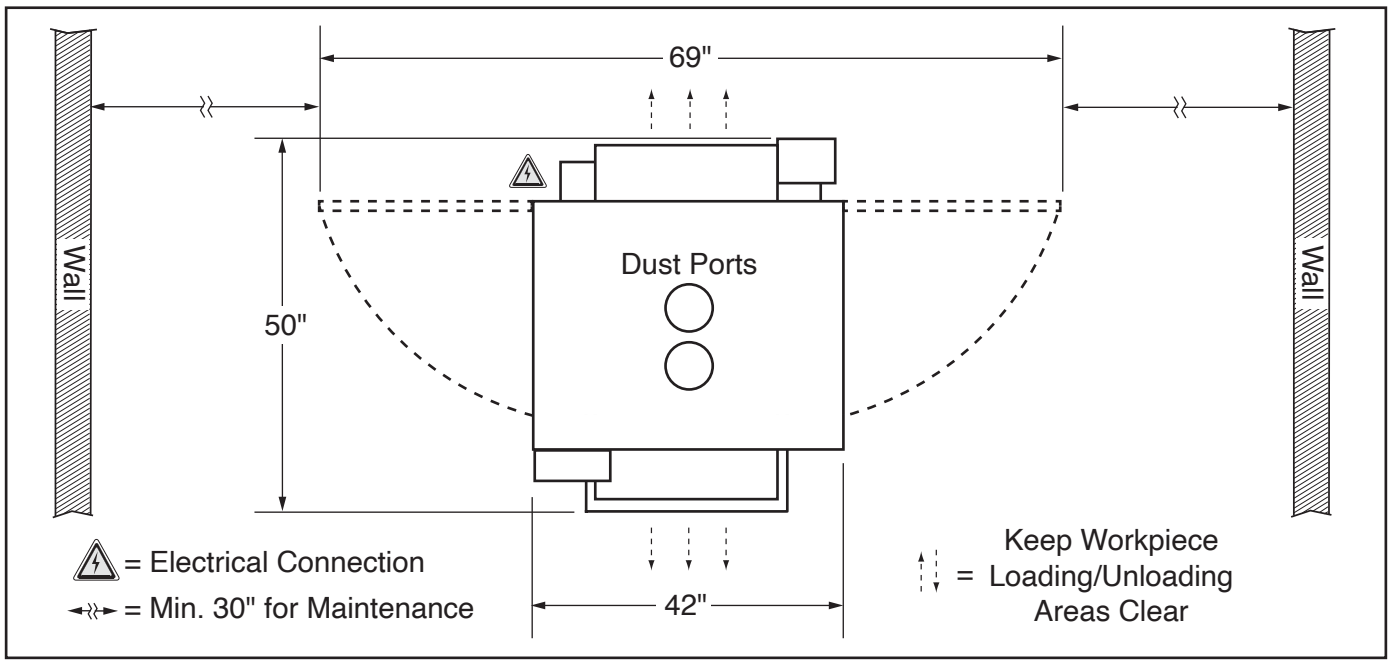


Figure 24. G0408 minimum working clearances.

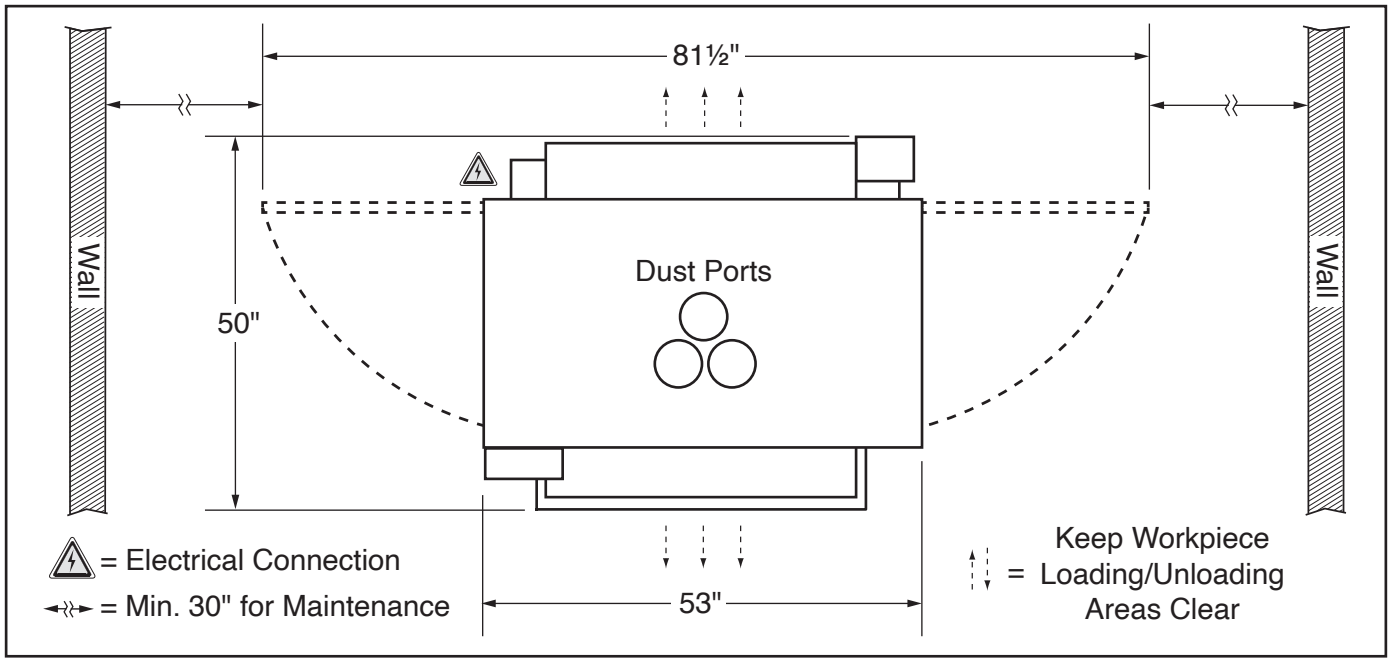


Figure 25. G0409 minimum working clearances.

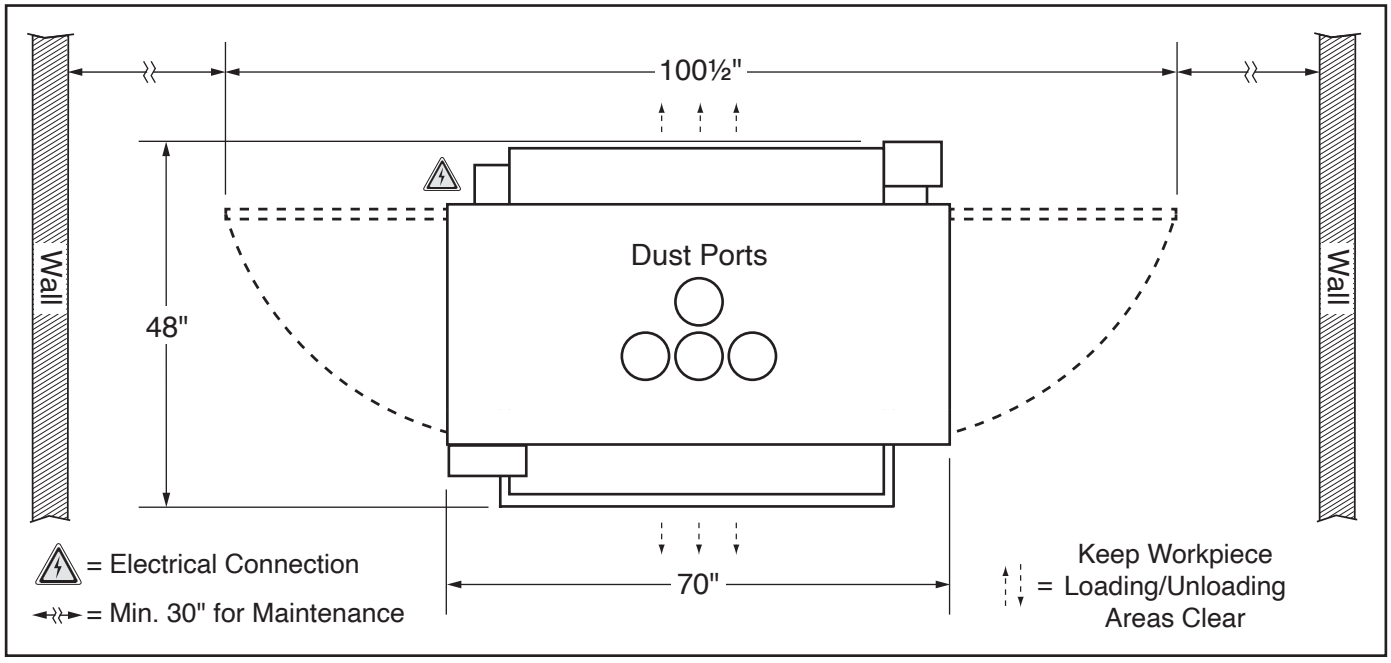
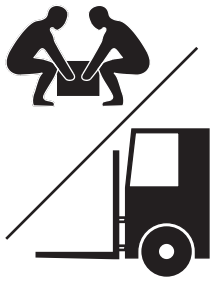


Figure 26. G0411 minimum working clearances.

Lifting & Placing



⚠WARNING

HEAVY LIFT!

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

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 the weight shown for your machine in **Needed for Setup** on **Page 23**. The listed weight accounts for the weight of the machine as well as 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 27**).

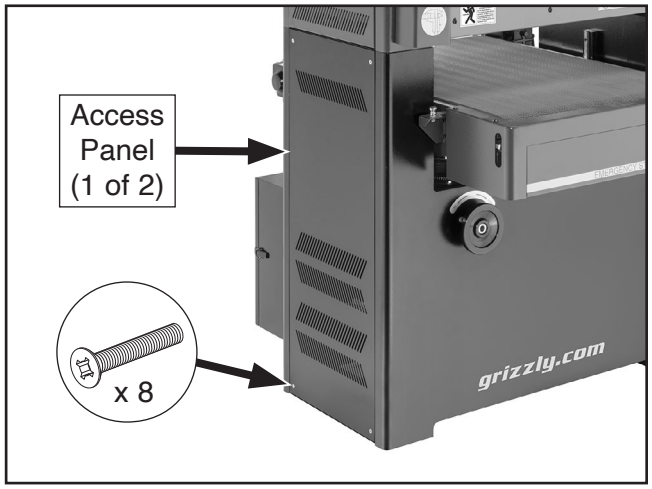


Figure 27. Location of access panels and screws (G0408 shown).

4. Remove (4) lag screws and flat washers securing machine to pallet (see **Figure 28**).

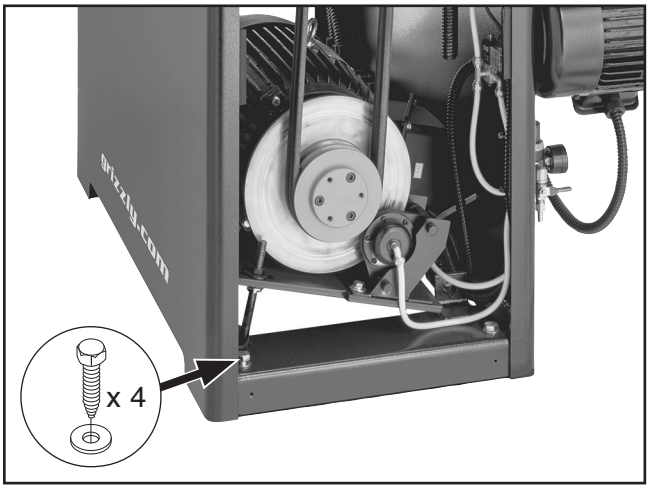


Figure 28. Location of lag screws and flat washers (G0408 shown).

5. Carefully place forklift forks under sander (see **Figure 29**).



Figure 29. Example of lifting machine with forklift.

6. Lift sander just enough to remove pallet, then slowly lower sander to floor.

7. Level (see **Leveling** on **Page 29**) and anchor machine (**Anchoring to Concrete Floors** on **Page 29**), if desired.

8. Install access panels and secure with screws removed in **Step 3**.

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 will 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 machine components 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..... ½"

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

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

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

Anchoring to Concrete Floors

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

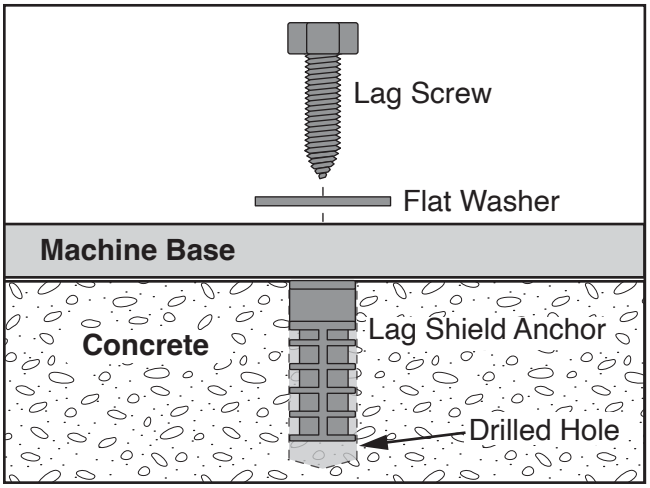


Figure 30. Popular method for anchoring machinery to a concrete floor.

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 machine 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 31**) and secure with hose clamp.

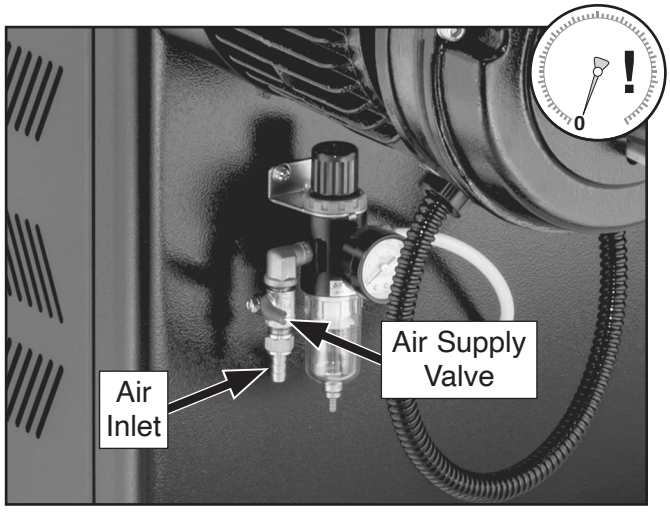


Figure 31. Location of air inlet and air supply valve on regulator.

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 31**) is in open position.

5. Lift regulator knob to unlock (see **Figure 32**) and rotate it until gauge reads 75 PSI.

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

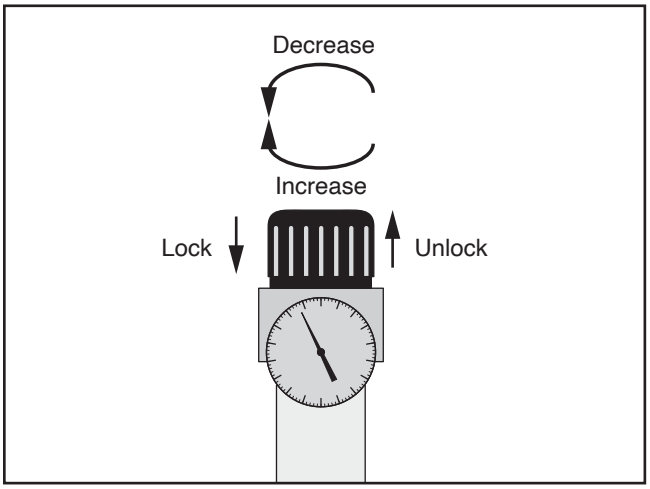


Figure 32. Regulator knob adjustment.

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 33**).

8. Remove stop block release lever by turning it counterclockwise a ½ turn and pulling it up and out of mounting hole (see **Figure 33**).

9. Remove stop block (see **Figure 33**).

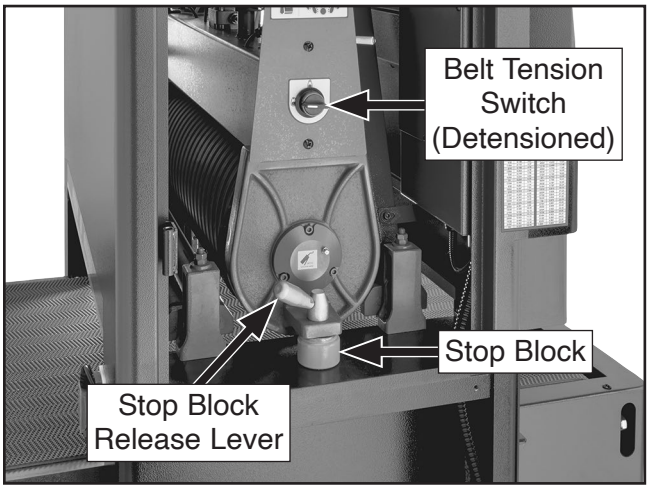


Figure 33. Sanding belt installation components (door removed for clarity; G0408 shown).

10. Install desired sanding belt over roller and drum(s), starting with roller (see **Figure 34–Figure 35**).

Note: *Sanding belt must be centered between limit switch tips and edge of sanding belt must be between tongs of belt oscillation control fork, as shown in **Figure 34–Figure 36**. Rotation arrows on sanding belt must also be pointing in a counterclockwise direction, as shown with dashed line in **Figure 34–Figure 35**.*

NOTICE

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

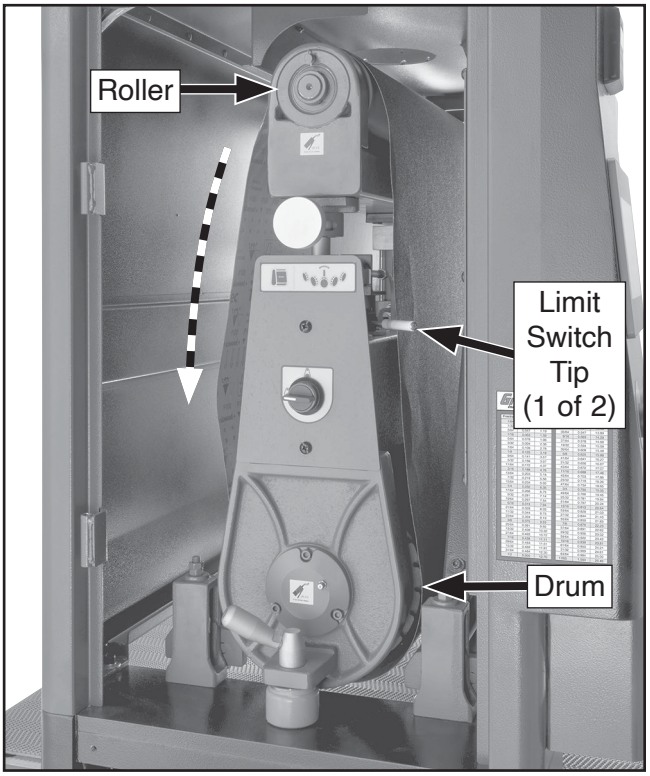


Figure 34. Model G0408 sanding belt installed correctly.

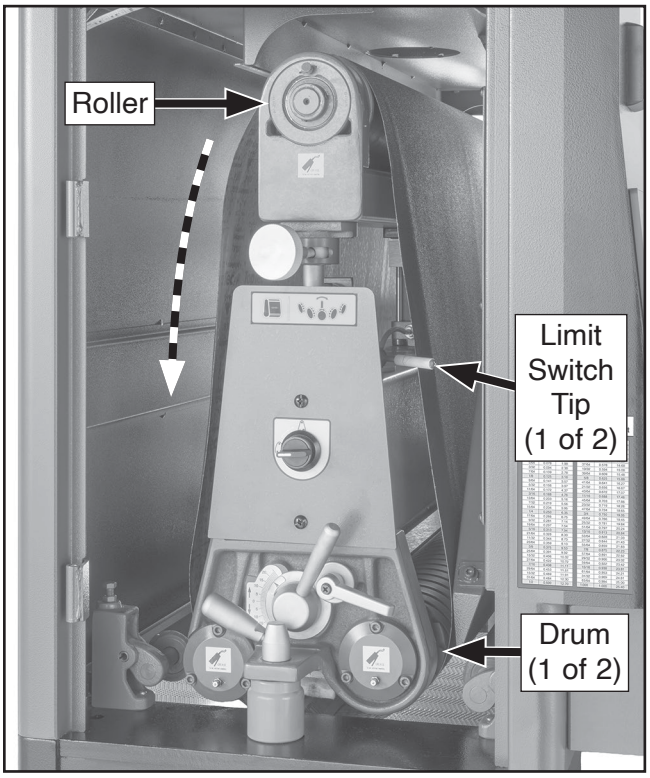


Figure 35. Model G0409/G0411 sanding belt installed correctly.

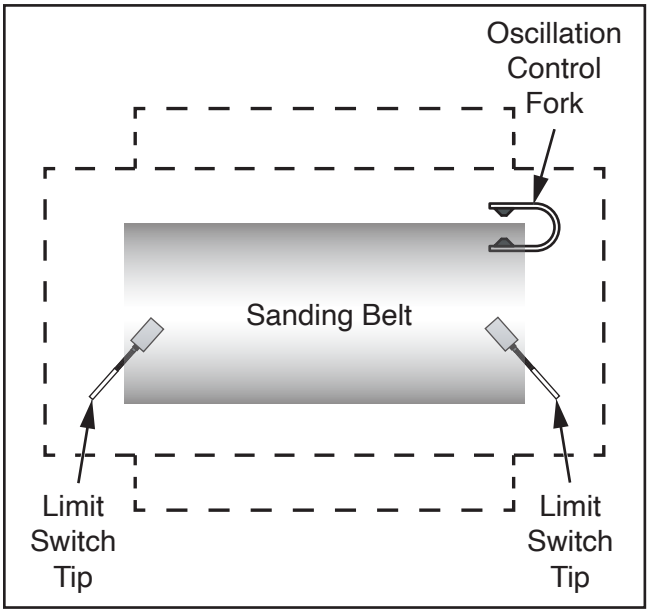


Figure 36. Sander outline (top view) of proper position of belt.

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(s). If pressure rollers are even with, or higher than sanding drum(s), wood WILL be propelled from machine at high rate of speed toward front of machine. This could cause serious kickback injury.

13. Joint 24" 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 37**).

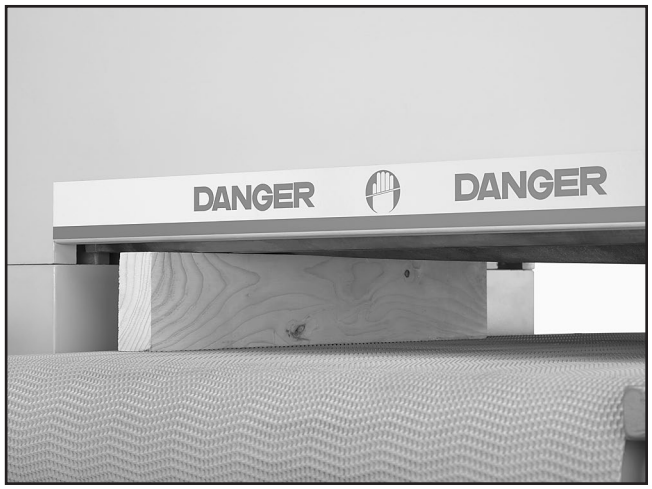


Figure 37. 2x4 positioned to check pressure roller height (example shown).

15. Use table elevation handwheel (see **Figure 38**) to manually raise conveyor table and verify that board touches both infeed and outfeed rollers before touching sanding belt.

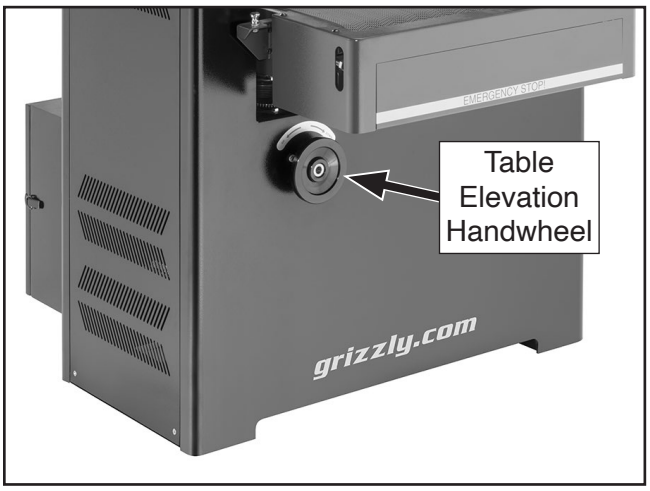


Figure 38. Location of table elevation handwheel (G0408 shown).

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 77** 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 Each 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 each dust port, as shown in **Figure 39**, and secure in place with hose clamps.



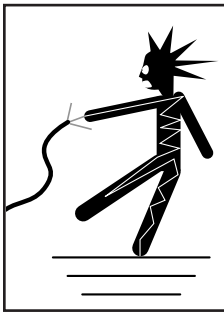
Figure 39. Dust hose attached to dust port (example shown).

2. Tug hoses to make sure they do 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.



⚠WARNING

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

⚠WARNING

Connecting power supply wires to machine without first disconnecting power supply may result in serious injury or death.

NOTICE

The Model G0411 is prewired for 220V. If you plan to operate machine at 440V, voltage conversion must be performed before connecting machine to power. Use instructions in Converting G0411 Voltage to 440V on Page 19 before proceeding with setup.

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

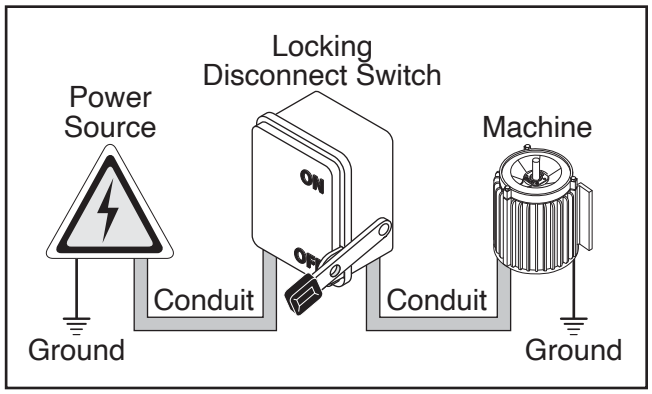


Figure 40. Typical setup of a locking disconnect switch.

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. Prepare hardwire power source according to circuit requirements specified in **G0408/G0409 Circuit Requirements** on **Page 18** or **G0411 Circuit Requirements** on **Page 19**.

2. DISCONNECT HARDWIRED POWER SOURCE OR LOCK DISCONNECT SWITCH IN OFF POSITION!

3. Remove screw shown in **Figure 41**, then open electrical cabinet door.

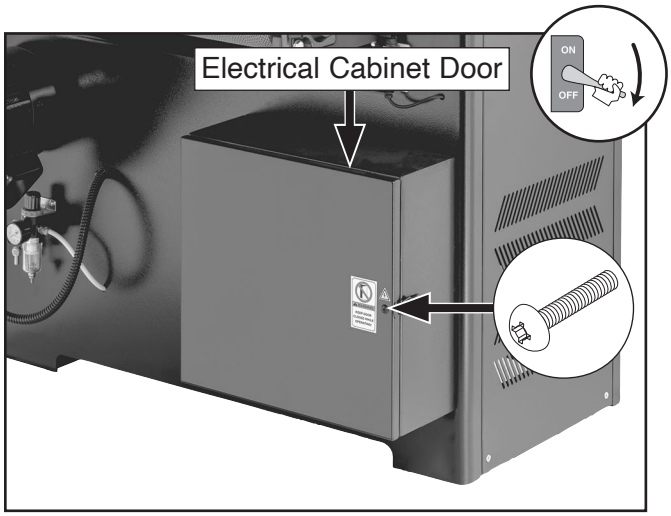


Figure 41. Location of electrical cabinet door and screw (G0408 shown).

4. Locate strain relief (see **Figure 42**) loose inside electrical cabinet and remove nut.

5. Insert strain relief into hole shown in **Figure 42**, then secure by loosely threading nut onto strain relief.

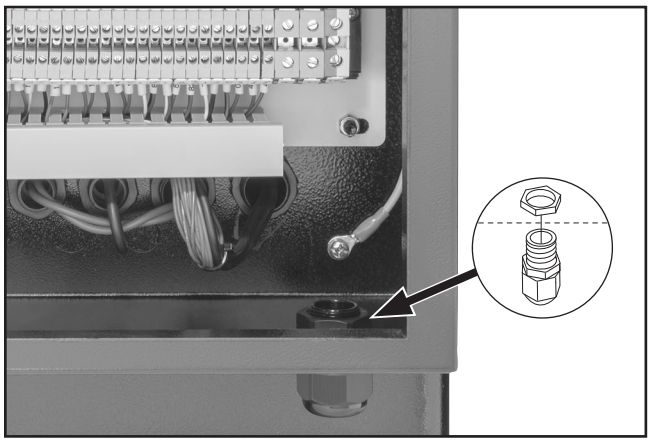


Figure 42. Power supply strain relief installed (G0408 shown).

6. 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. Ungrounded or improperly grounded machine can cause electrocution if live electrical wires make contact with frame or other parts touched by operator.

7. **Model G0408/G0409:** Connect ground wire to bottom of ground terminal "E", then connect incoming power wires to "R" and "S" terminals shown in **Figure 43**.

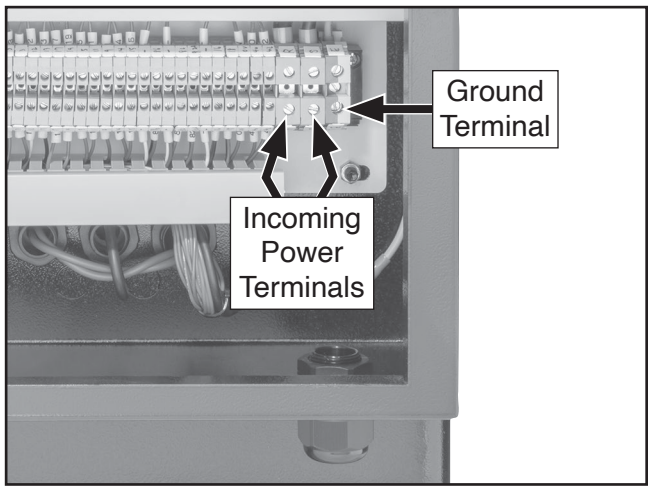


Figure 43. Location of G0408/G0409 ground and power wire terminals (G0408 shown).

Model G0411: Connect ground wire to bottom of ground terminal "E", then connect incoming power wires to "R," "S," and "T" terminals shown in **Figure 44**.

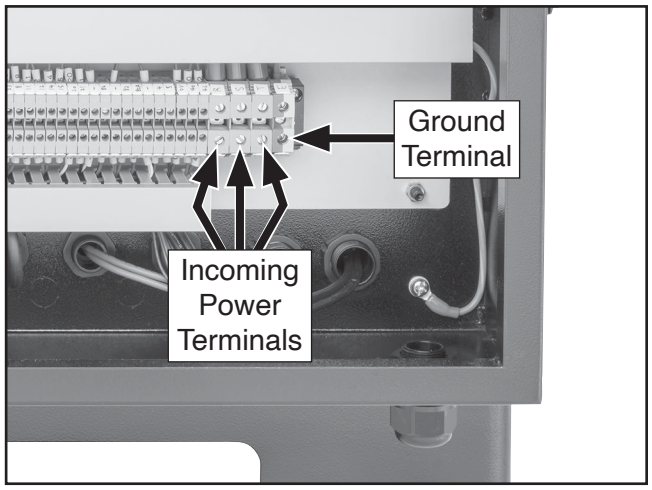


Figure 44. Location of G0411 ground and power wire terminals.

IMPORTANT: If connecting 4-wire delta (high-leg delta) 3-phase power supply to Model G0411, wild wire should attach to "T" terminal.

8. Make sure wires have enough slack inside electrical cabinet so they are not pulled tight or stretched, then tighten strain relief nut to secure.

9. Close electrical cabinet door, then secure with screw removed in **Step 3**.

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.

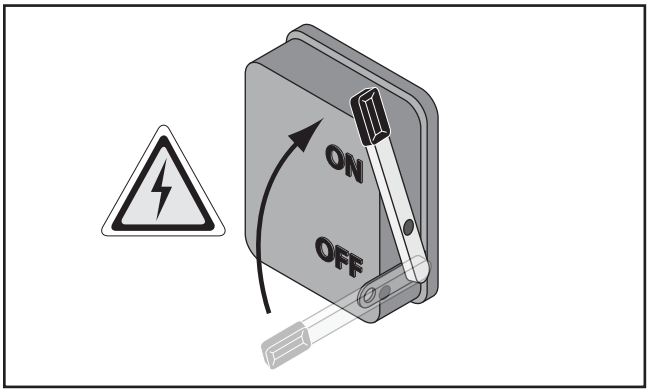


Figure 45. Connecting power to machine.

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.*

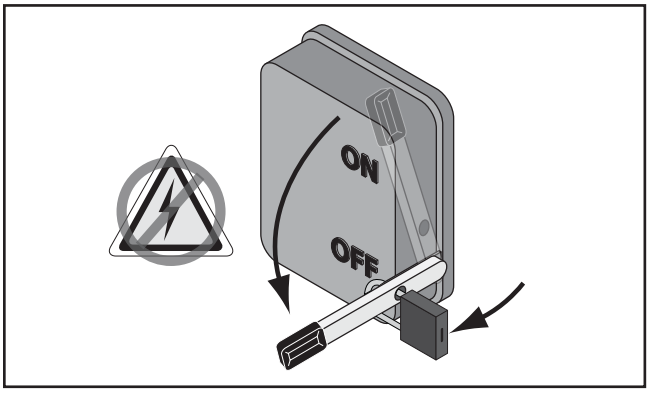


Figure 46. Disconnecting power from machine.

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) The power supply polarity is correct (G0411 only), 2) the motors power up and run correctly, 3) the EMERGENCY STOP button works correctly, 4) the EMERGENCY STOP! bar works correctly, 5) the workpiece thickness sensor works correctly, and 6) 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 touchscreen to display main menu screen (see **Figure 1** on **Page 7**).

3. Press EMERGENCY STOP button in. Touchscreen will show active fault log screen (see **Figure 47**) to indicate that EMERGENCY STOP safety feature or limit switch is preventing machine operation.

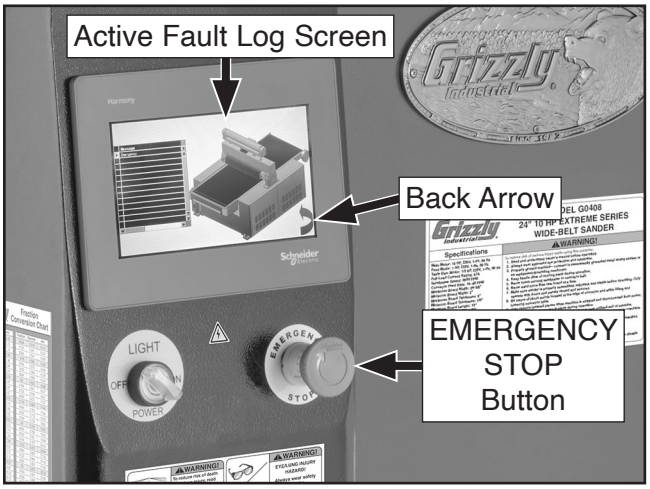


Figure 47. Active fault log screen and location of EMERGENCY STOP button (G0408 shown).

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 48**). This resets switch so machine can start.



Figure 48. Resetting switch.

6. Press back arrow shown in **Figure 47** to return to main menu screen.

   — For Model G0408/G0409, proceed to **Step 11**.

   — For Model G0411, proceed to **Step 7**.

7. Verify power supply polarity is correct by pressing and holding table up and down buttons, respectively (see **Figure 49**).

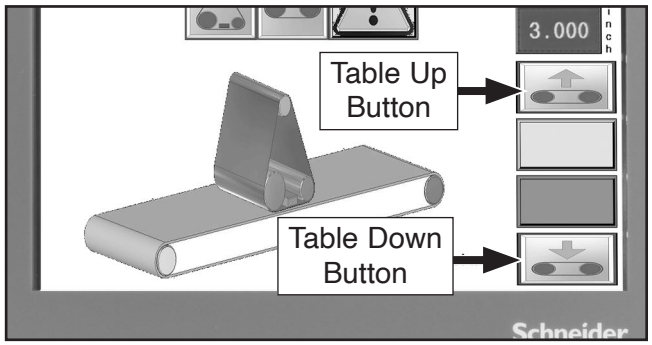


Figure 49. Location of Model G0411 table up/down buttons.

— If table moves in *same* direction as button description, power supply polarity is correct. Proceed to **Step 11**.

— If table moves in *opposite* direction as button description, stop machine and DISCONNECT FROM POWER. Phase polarity of incoming power is reversed. Proceed to **Step 8**.

⚠WARNING

You MUST verify that table moves in direction that button describes, otherwise controls will function in reverse. Conveyor/sanding belt MUST rotate in correct direction or personal injury and machine damage could occur.

8. Remove screw shown in **Figure 50**, then open electrical cabinet door.

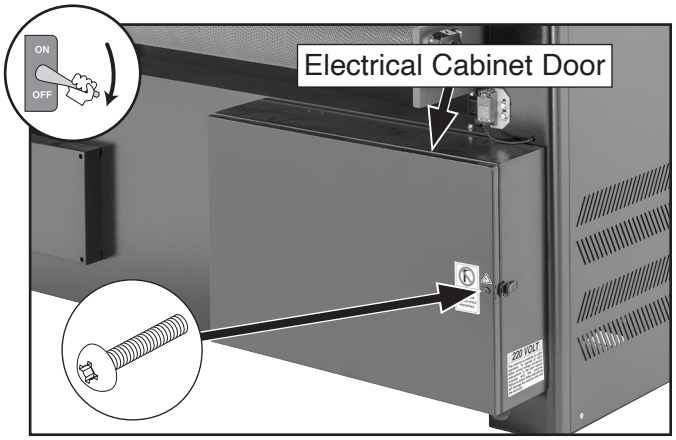


Figure 50. Location of Model G0411 electrical cabinet door and screw.

9. Swap wires connected to "R" and "S" power supply terminals (see **Figure 51**).

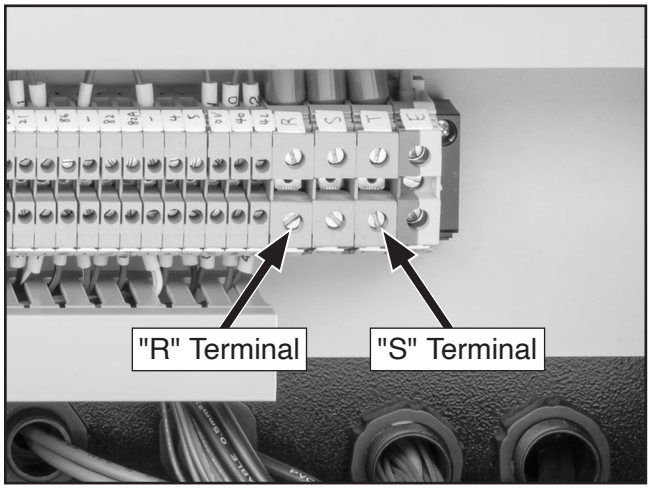


Figure 51. Location of Model G0411 "R" and "S" power supply terminals.

10. Close and latch electrical cabinet door, then perform **Test Run** from **Step 1**.

11. Press sanding belt ON/OFF button (see **Figure 52**). Verify main motor starts up and runs smoothly without any unusual problems or noises.

12. Press conveyor belt ON/OFF button (see **Figure 52**). Verify feed motor starts up and runs smoothly without any unusual problems or noises.

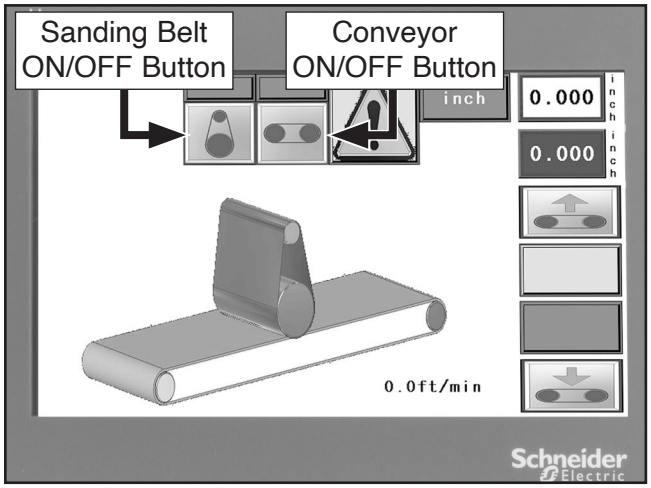


Figure 52. Location of sanding belt and conveyor ON/OFF buttons (G0408 shown).

13. Press EMERGENCY STOP button to turn motors ***OFF***.

14. 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.

15. Reset EMERGENCY STOP button.

16. Press back arrow to return to main menu screen and press sanding belt and conveyor ON/OFF buttons to start motors.

17. Press EMERGENCY STOP! bar (see **Figure 53**).

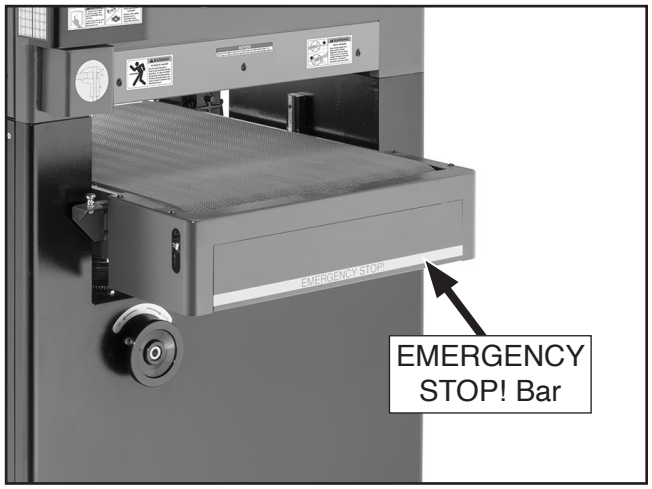


Figure 53. Location of EMERGENCY STOP! bar (G0408 shown).

— If sanding and conveyor belts come to a complete stop, safety feature of EMERGENCY STOP! bar is working correctly.

— If sanding and conveyor belts *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.

18. Press back arrow to return to main menu screen.

19. Place 2x4 on conveyor table so part of it extends under workpiece thickness sensor (see **Figure 54**).



Figure 54. Workpiece under workpiece thickness sensor (example shown).

20. Press and hold table up button (see **Figure 55**). When workpiece contacts workpiece thickness sensor, table should stop.

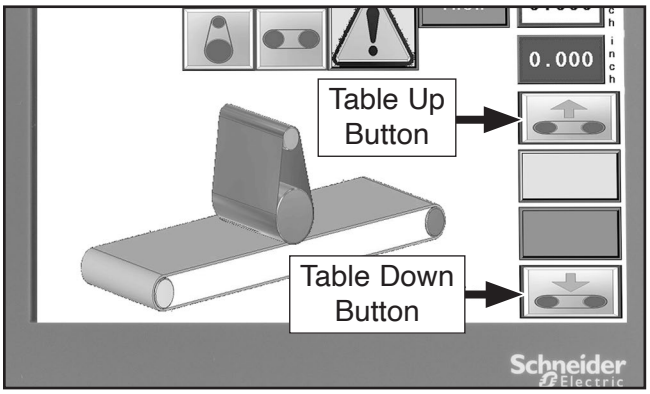


Figure 55. Location of table up and down buttons (G0408 shown).

— If table *does* stop, workpiece thickness sensor is working correctly.

— If table *does not* stop, refer to **Calibrating Workpiece Thickness Sensor** on **Page 63** to adjust sensor before proceeding with test run.

21. Remove workpiece from conveyor table.

22. Press and hold table up button. When table stop block (see **Figure 56**) presses upper table elevation limit switch, table should stop.

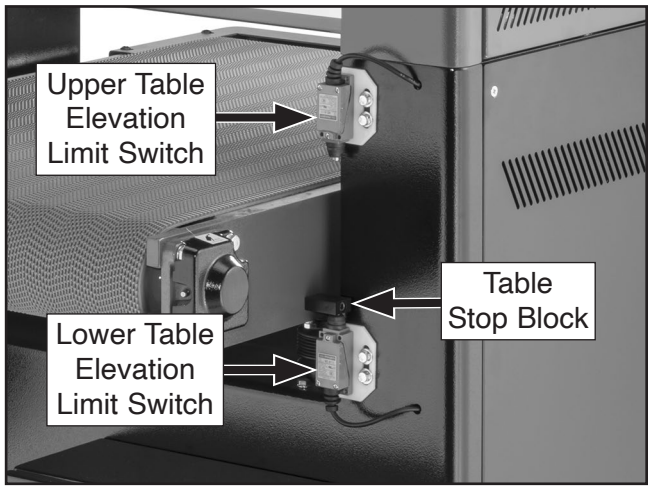


Figure 56. Location of table elevation limit switches and stop block.

— 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.

23 Press back arrow to return to main menu screen.

24. Press and hold table down button (see **Figure 55** on **Page 38**). When table stop block (see **Figure 56**) presses lower table elevation limit switch, table should stop.

— 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.

25. Press back arrow to return to main menu screen.

26. 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:

- V-belt adjustment (**Page 54**).
- Workpiece thickness sensor calibration (**Page 63**).
- Thickness display calibration (**Page 64**).
- Oscillation timing and speed (**Page 65**).
- Table parallelism (**Page 74**).
- Conveyor belt tension (**Page 79**).
- Conveyor belt tracking (**Page 79**).

Be aware that machine components can shift during the shipping process. Pay 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.

NOTICE

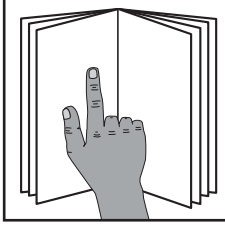
To prevent damage and unnecessary wear and tear to conveyor gearbox, change conveyor gearbox oil after first 100 hours of use (about 3 months). Refer to maintenance schedule for following oil changes.

SECTION 4: OPERATIONS

Operation Overview

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

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



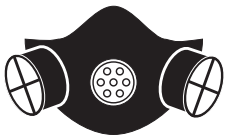
⚠WARNING

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

⚠WARNING

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





NOTICE

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

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

1. Examines workpiece to make sure it is suitable for sanding.
2. Connects 75 PSI air supply, then installs and tensions sanding belt of desired grit.
3. **G0409/G0411 Only:** Adjusts platen.
4. Connects machine to power.
5. Adjusts conveyor table height to approximate thickness of workpiece.
6. Puts on safety glasses and respirator, and starts dust collection.
7. Starts main motor, starts feed motor, then adjusts conveyor feed rate for operation.
8. Places front end of workpiece on infeed side of conveyor table and supports back end until it engages with infeed pressure roller(s).

   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.*
9. Receives workpiece from outfeed side of conveyor table.
10. Raises height of conveyor a small amount, then repeats feeding process of workpiece through sander.
11. Disconnects power to change sanding belt to finer grit.
12. **G0409/G0411 Only:** Adjusts platen.
13. Connects machine to power and repeats **Steps 7–12** 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. The Model G0409/G0411 has a platen that will also affect this process. 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, review **Workpiece Inspection** on **Page 42** and put on the required safety glasses and respirator.

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

IMPORTANT: As you sand, observe the amp draw meter (see **Page 47**). If the meter indicates motor overload, slightly lower the table or reduce the feed rate.

Note: *The tables provided in the following sections are approximate values only. These are intended to give you a "ballpark" idea of the machine material removal rates to expect. 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.*

G0408 Sanding

Sanding on the Model G0408 consists of the operator starting sanding with a coarse sandpaper (such as grit #60), and then repeating this for subsequent grit sizes (#80–#100) until the workpiece is evenly smooth. The operator then performs intermediate sanding passes using finer grit sandpaper (#100–#150). For the final sanding pass, the operator sands the workpiece with fine sandpaper (#180+).

The table below suggests a maximum depth of cut (DOC) for 15" stock at relative conveyor feed rates. After selecting the appropriate feed rate, find the grit size you plan to use. Locate the DOC for that grit according to the workpiece hardness.

		Wood Hardness	
Feed Rate	**Grit Size**	**Hard**	**Soft**
15 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"
33 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"

G0409/G0411 Sanding

Sanding on the Model G0409/G0411 consists of starting with a coarse sandpaper (such as grit #60) with the platen in the up position, and then repeatedly sanding for subsequent grit sizes (#80–#100) until the workpiece is evenly smooth. The platen is then set level with the drums and intermediate sanding passes are taken using finer grit sandpaper (#100–#150). The platen is then set in the down position for the final sanding pass, and the workpiece is sanded with fine sandpaper (#180+).

The tables below suggest a maximum depth of cut (DOC) for 15" stock at relative conveyor feed rates. After selecting the appropriate feed rate, find the grit size you plan to use. Locate the DOC for that grit according to the workpiece hardness, and note the DOC for the platen setting.

	15 FPM			
	Wood Hardness		Platen Settings	
Grit Size	Hard	Soft	Max DOC	Position
60	0.030"	0.040"	n/a	Up 1.5mm
80	0.025"	0.035"	n/a	Up 1.5mm
100	0.020"	0.030"	0.010"	Even
120	*0.015"	*0.020"	0.010"	Even
150	*0.010"	*0.015"	0.007"	Even
180	0.005"	*0.010"	0.005"	Down 0.5mm
240	*0.003"	*0.005"	0.002"	Down 1mm

	23 FPM			
	Wood Hardness		Platen Settings	
Grit Size	Hard	Soft	Max DOC	Position
60	0.025"	0.035"	n/a	Up 1.5mm
80	0.020"	0.030"	n/a	Up 1.5mm
100	0.015"	0.020"	0.007"	Even
120	*0.010"	*0.015"	0.007"	Even
150	0.005"	*0.010"	0.005"	Even
180	*0.003"	*0.005"	0.002"	Down 0.5mm
240	*0.002"	*0.004"	0.001"	Down 1mm

	33 FPM			
	Wood Hardness		Platen Settings	
Grit Size	Hard	Soft	Max DOC	Position
60	0.020"	0.030"	n/a	Up 1.5mm
80	0.015"	0.025"	n/a	Up 1.5mm
100	0.010"	0.015"	0.005"	Even
120	*0.007"	*0.010"	0.005"	Even
150	*0.005"	*0.007"	0.003"	Even
180	*0.003"	*0.005"	0.002"	Down 0.5mm
240	0.001"	*0.003"	0.001"	Down 1mm

**These numbers assume the platen is raised 1.5mm during the sanding pass.*

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.

- **Model G0409/G0411 Only:** as a general rule, use the sanding drums for the initial heavy sanding pass, then use a combination of the platen and the drums for the intermediate pass, and the platen alone for the final sanding pass.

- 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 44**).

- When making multiple passes on the workpiece, avoid raising the conveyor table more than 0.015" (a ¾ 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").

- 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 59**).

- **Model G0408 Only:** DO NOT sand boards with a length less than 10", a width less than 2", or a thickness less than ⅛" to prevent damage to the workpiece and the sander (see **Figure 57**).

- **Model G0409 Only:** DO NOT sand boards with a length less than 14", a width less than 2", or a thickness less than ⅛" to prevent damage to the workpiece and the sander (see **Figure 57**).

- **Model G0411 Only:** DO NOT sand boards with a length less than 14", a width less than 2", or a thickness less than 3/16" to prevent damage to the workpiece and the sander (see **Figure 57**).

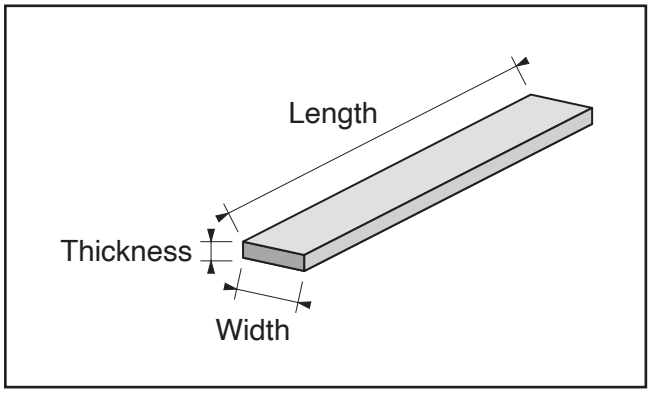


Figure 57. Minimum dimensions for sanding.

- 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.

- **Model G0409/G0411 Only:** Make sure to adjust platen position accordingly when changing grit sizes.

- The faster the feed rate you use, the faster your sanding belts will wear out.

Changing Sanding Belt

Required Sanding Belt Size
G0408..... 25" x 60"
G0409 ..... 37" x 60"
G0411 .....51" x 60"

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.

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.*

For additional sanding belt selections beyond those included with the machine, see the current selection of belts offered on our website.

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 58–Figure 59**).

5. Remove stop block release lever by turning it counterclockwise a ½ turn and pulling it up and out of mounting hole (see **Figure 58–Figure 59**).

6. Remove stop block (see **Figure 58–Figure 59**).

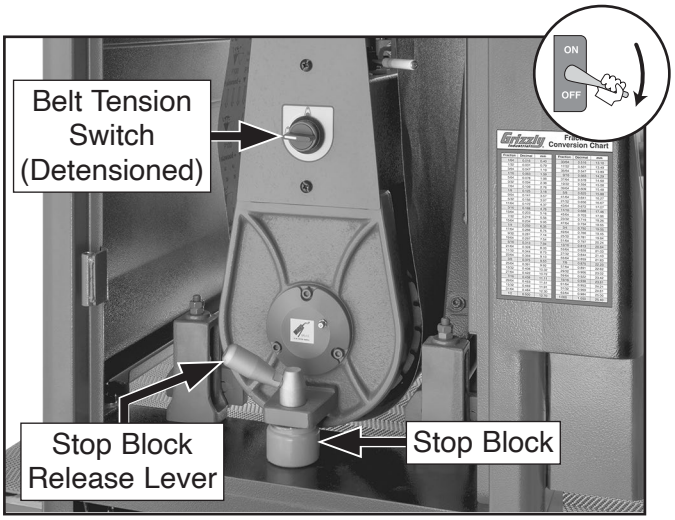


Figure 58. Components for changing Model G0408 sanding belt.

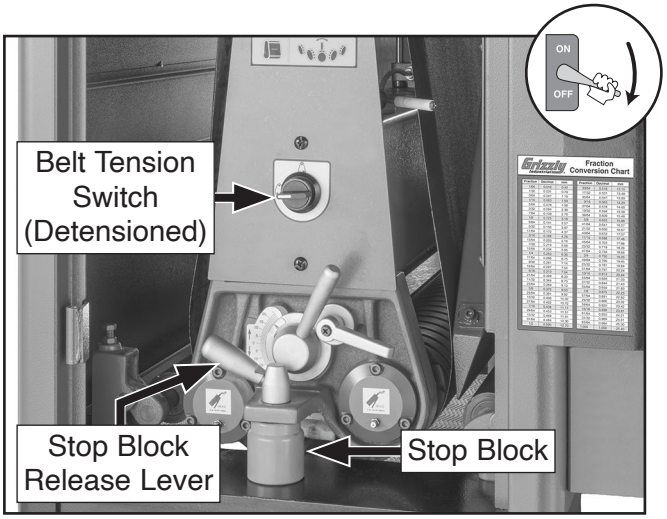


Figure 59. Components for changing Model G0409/G0411 sanding belt.

7. Remove existing sanding belt.

8. Install desired sanding belt over roller and drum(s), starting with roller (see **Figure 60–Figure 61**).

   Note: *Sanding belt must be centered between limit switch tips and edge of sanding belt must be between tongs of belt oscillation control fork, as shown in* ***Figure 60–Figure 62****. Rotation arrows on sanding belt must be pointing in a counterclockwise direction, as shown with dashed line in* ***Figure 60–Figure 61****.*

NOTICE

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

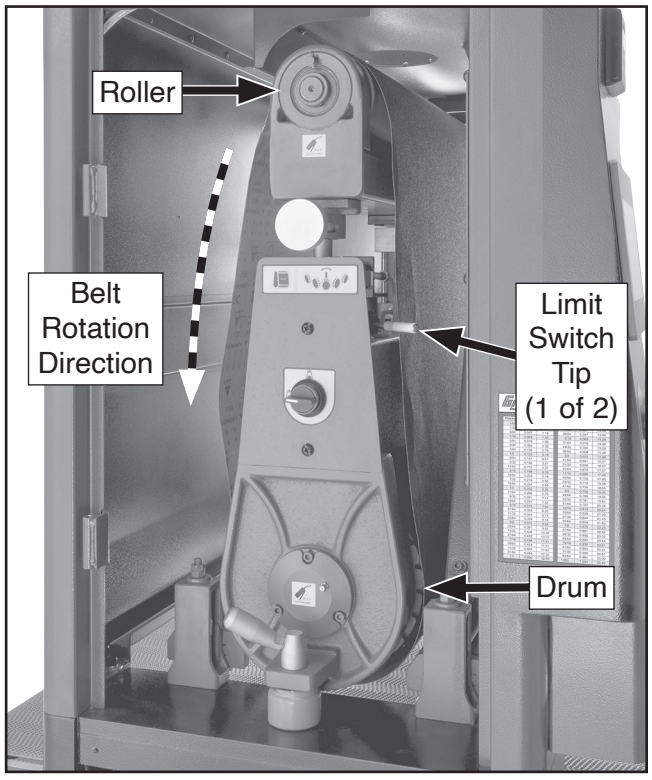


Figure 60. Model G0408 sanding belt installed correctly.

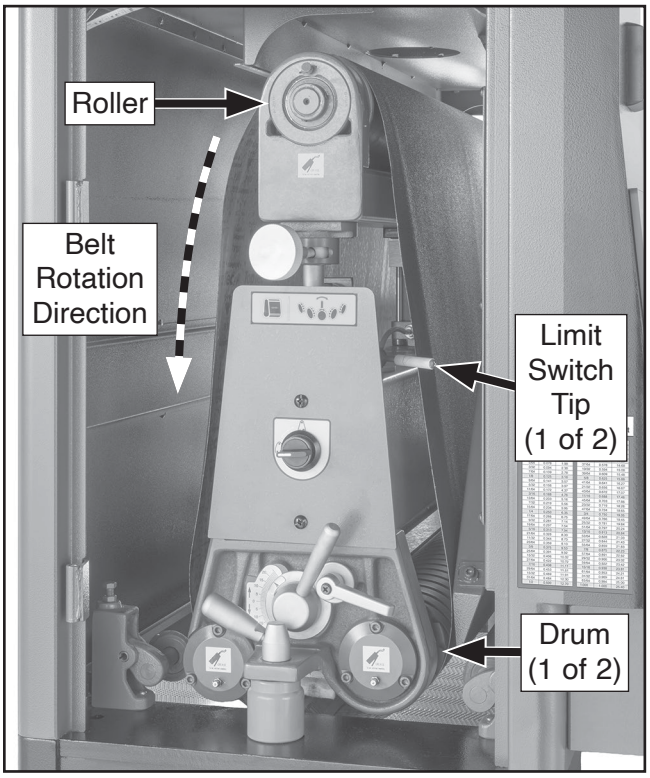


Figure 61. Model G0409/G0411 sanding belt installed correctly.

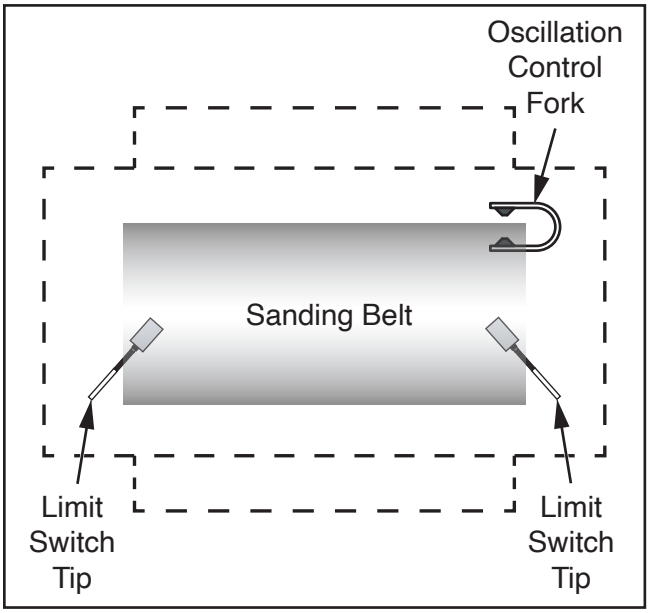


Figure 62. Sander outline (top view) of proper position of belt.

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.

Adjusting Platen (G0409/G0411 Only)

The Model G0409/G0411 is equipped with an adjustable platen (see **Figure 63**) with a graphite pad that is designed to be used during finish sanding to create a polished-type finish and to prepare the workpiece for orbital sanding or a finish coat.

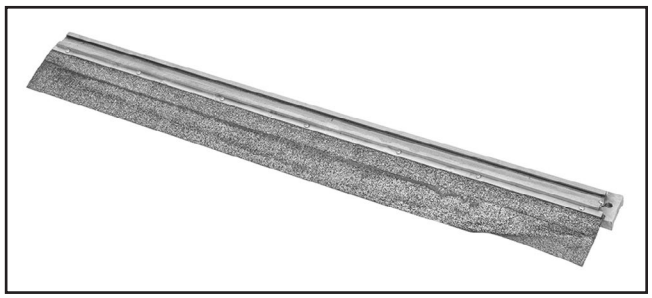


Figure 63. Platen removed from machine (example shown).

The platen position allows for three basic types of sanding: up, even, and down. Adjust the platen by loosening the platen adjustment lock lever and rotating the scale pointer arrow to the desired position with the platen adjustment lever (see **Figure 64**). Secure the setting for the sanding operation by tightening the lock lever.

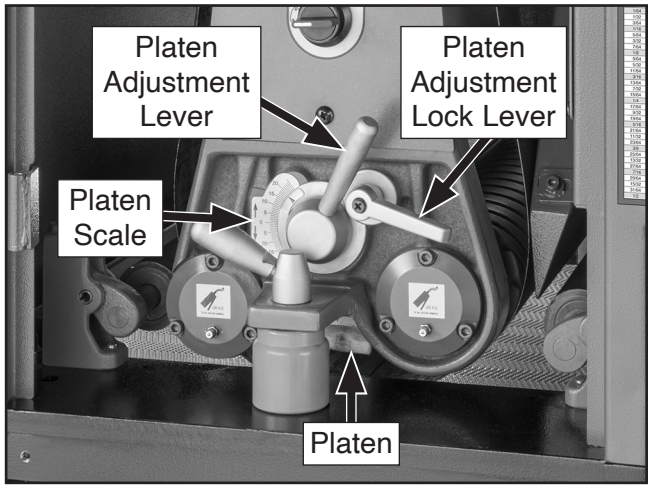


Figure 64. Platen height components.

Unlike the sanding drums alone, which typically produces short but deep scratch patterns, the platen produces long and shallow scratch patterns that create an overall smoother finish. Due to its cushioned-construction, the platen is less likely to leave belt-splice or chatter marks.

However, we do not recommend lowering the platen depth more than 2mm or over-using the platen by expecting it to remove marks beyond its ability to do so, since this can reduce the life of the sanding belt and platen, and result in premature streaking.

Tip: *Given the short life-span of most graphite pads, keep replacement pads on hand.*

Platen Up: The platen is raised above the level of the drums (typically set at 1.5mm up), so only the sanding drums are making contact with the workpiece. This position is typically used for heavy sanding passes or dimensioning. The drums do all the work, but you will have a rough finish. Typically platens are used in this position with #100 grit or coarser.

Platen Even: The platen is set level with the drums. This position is used for intermediate-finishing passes. The depth of cut should not exceed 0.010". This position typically uses #100–#150 grit.

Platen Down: The platen is set below the level of the drums so it is the primary contact point while performing finish sanding.

The platen should be lowered to 0.2–0.5mm (maximum) below the sanding drums, but not more than 0.2mm per pass. You can lower the platen up to 2mm below the drums for short intervals, but streaking, burn marks, and premature graphite/platen wear can occur if this setting is abused on over-used.

It is not necessary to use the table elevation handwheel or touchscreen buttons to adjust the sanding depth during the final sanding pass—the platen movement alone will take care of the depth of cut. Typically the final-sanding pass position uses #180 grit or finer.

Note: *The platen scale is broken down in 0.1mm increments (approximately 0.004").*

NOTICE

If workpiece has straight notches across it, graphite cloth and felt have worn out and need to be replaced immediately to prevent further damage to workpieces and platen.

Adjusting Feed Rate

Conveyor Feed Rate
G0408/G0409 ..... 15–49 FPM
G0411 ..... 14–60 FPM

The conveyer belt is variable-speed, which is controlled by the knob shown in **Figure 65**.

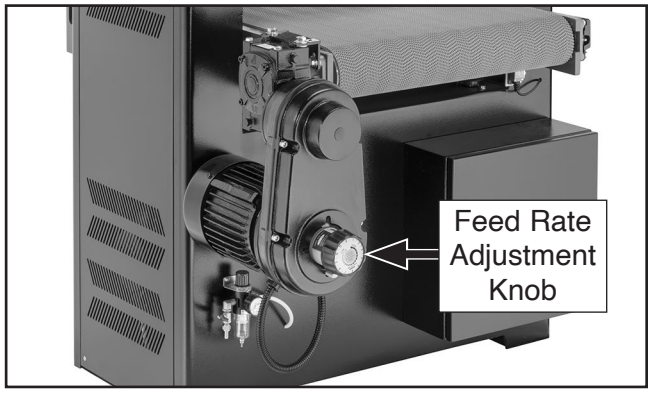


Figure 65. Location of feed rate adjustment knob (G0408 shown).

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 main motor.

To adjust feed rate:

1. Turn conveyor belt ***ON***. Conveyor belt must be running to adjust feed rate.

2. Turn knob counterclockwise to increase feed rate or clockwise to decrease feed rate.

   Note: *Turn knob in ⅛" increments.*

Reading Amp Draw Meter

The amp draw meter (see **Figure 66**) 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.

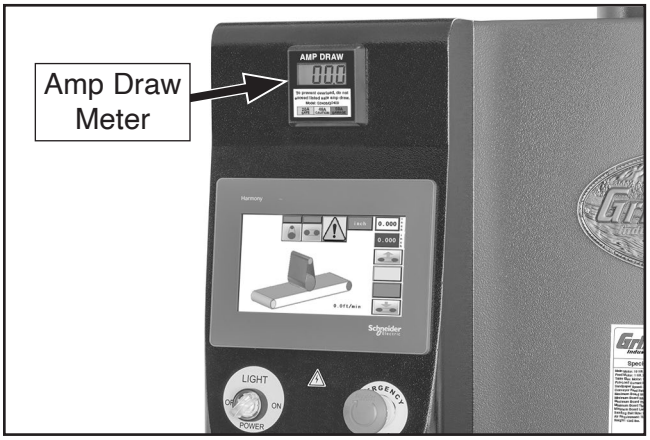


Figure 66. Location of amp draw meter (G0408 shown).

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 prevent operator injury during an emergency and reduce the amount of damage to internal components. Pushing the EMERGENCY STOP! bar (see **Figure 67**) causes the disc brake to stop the main motor, immediately stopping the sanding belt.

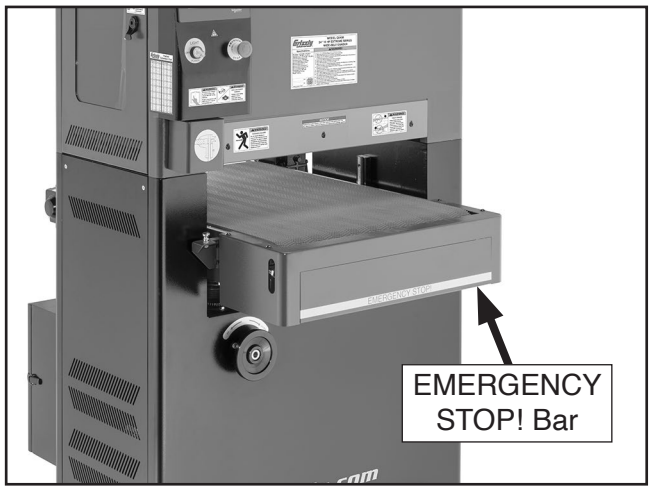


Figure 67. Location of EMERGENCY STOP! bar (G0408 shown).

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-belts correctly tensioned (see Page 54) 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 the operator to quickly adjust the table elevation according to the workpiece size.

To use workpiece thickness sensor:

1. Place workpiece on conveyor table so part of it extends under workpiece thickness sensor (see **Figure 68**).

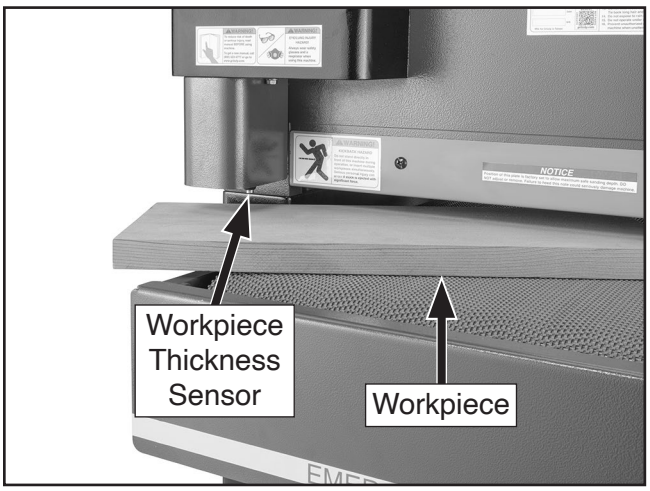


Figure 68. Workpiece under workpiece thickness sensor (example shown).

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 interior LED lights will illuminate red, and the touchscreen will open the active fault log screen (see **Figure 69**). Pressing the arrow on the bottom right corner of the screen will return the touchscreen to the main menu.

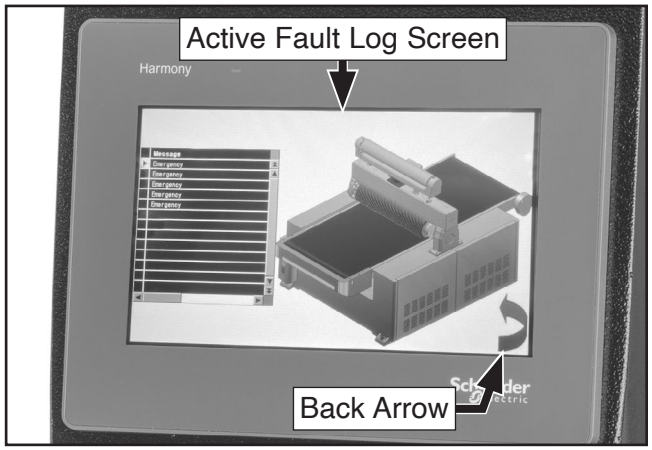


Figure 69. Active fault log screen.

If you return to the main menu without clearing the fault, the fault indicator shown in **Figure 70** 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 70** components.

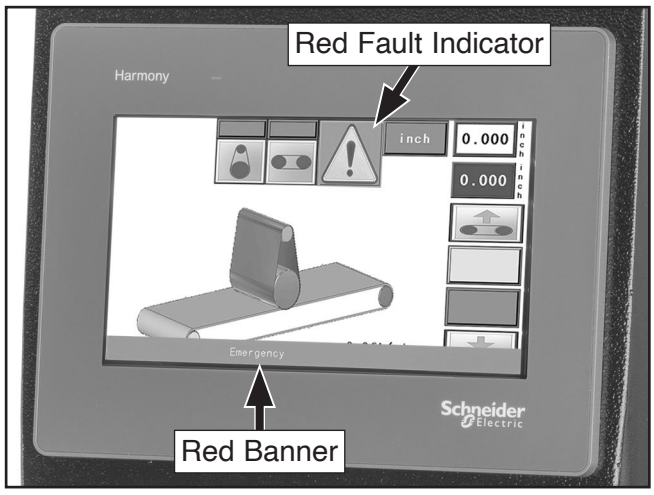


Figure 70. Main menu screen showing fault (G0408 shown).

If you wish to review the fault log, you can also press the fault indicator to display the fault log screen shown in **Figure 71**.

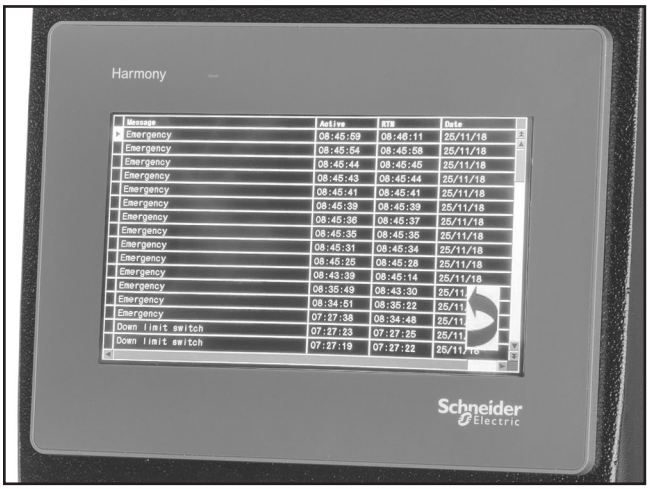


Figure 71. Fault log screen.

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 or tension limit switch is engaged. Make sure that sanding belt tension is engaged. If tension is engaged, release belt tension, and center belt on roller and drum to clear. Belt 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.

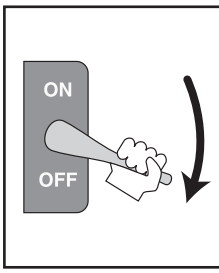
Ongoing
To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Worn or damaged sanding belt.
- Worn or damaged wires.
- Low conveyor gearbox oil.
- Worn or damaged platen graphite pad (G0409/G0411 only).
- Cracks, chafing, or hardening in air hoses.
- Leaks, cracks in air hoses or connections.
- Any other unsafe condition.

Weekly Maintenance
- Empty dust and water traps.
- Lubricate grease fittings.

Monthly Maintenance
- Clean/vacuum dust buildup from inside frame and off motors.
- Clean/lubricate table elevation chain, leadscrews, and sprockets.
- Check V-belts for correct tension, damage, or wear.
- Inspect/clean dust from electrical cabinet and control box.

Yearly Maintenance
- Replace air regulator filter.
- Check air hoses and connections for leaks or clogs. If soapy water at suspected leak creates bubbles, air is escaping. Repair or replace affected parts. Remove line with suspected clog and blow through it as a test.
- Change conveyor gearbox oil.



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

Cleaning & Protecting

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

Lubrication

An essential part of lubrication is cleaning the components with an oil/grease solvent 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.

The following are the main components that need to be lubricated:
- Grease fittings.
- Table elevation chain, leadscrews, and sprockets.
- Conveyor gearbox.

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

Grease Fittings

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

Items Needed	Qty
Phillips Head Screwdriver #2	1
Flat Head Screwdriver ¼" (G0409/G0411 Only)	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 left and right doors.

3. **Model G0408 Only:** Remove (3) screws shown in **Figure 72** to remove V-belt cover.

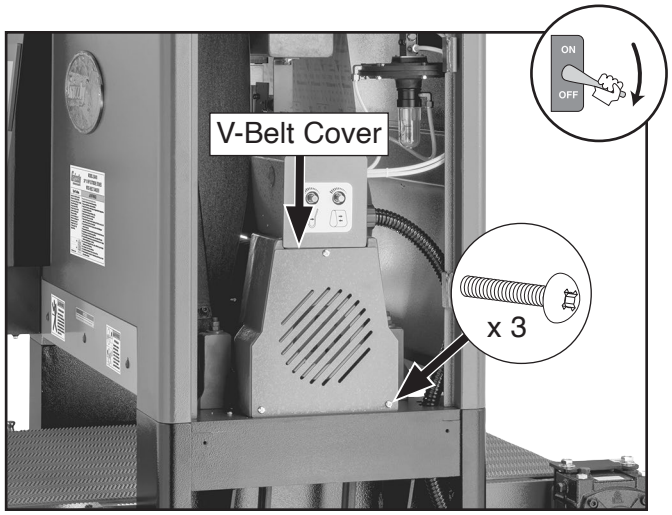


Figure 72. Location Model G0408 V-belt cover and screws.

4. Use shop rag and mineral spirits to clean (2) conveyor roller grease fittings (see **Figure 73**).

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

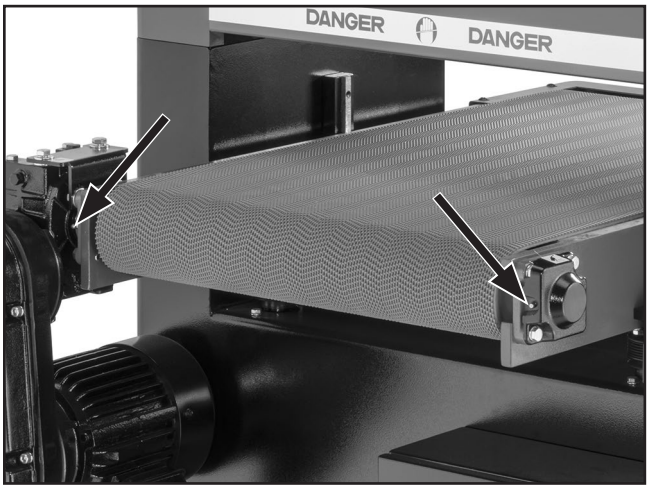


Figure 73. Location of conveyor belt roller grease fittings (G0408 shown).

5. **Model G0408:** Use shop rag and mineral spirits to clean (2) sanding belt roller, and (2) sanding belt drum grease fittings (see **Figure 74**).

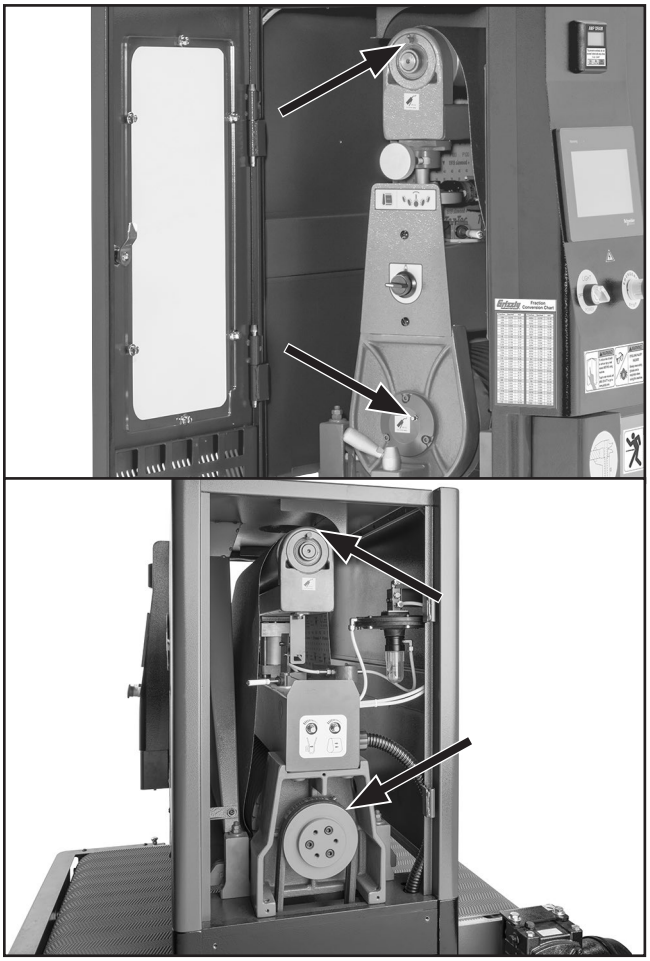


Figure 74. Location of Model G0408 sanding belt roller and drum grease fittings.

Model G0409/G0411: Use shop rag and mineral spirits to clean (2) sanding belt roller, and (4) sanding belt drum grease fittings (see **Figure 75**).

Note: *Dashed arrow (see **Figure 75**) indicates access plug that can be removed with flat head screwdriver to access grease fitting behind it.*

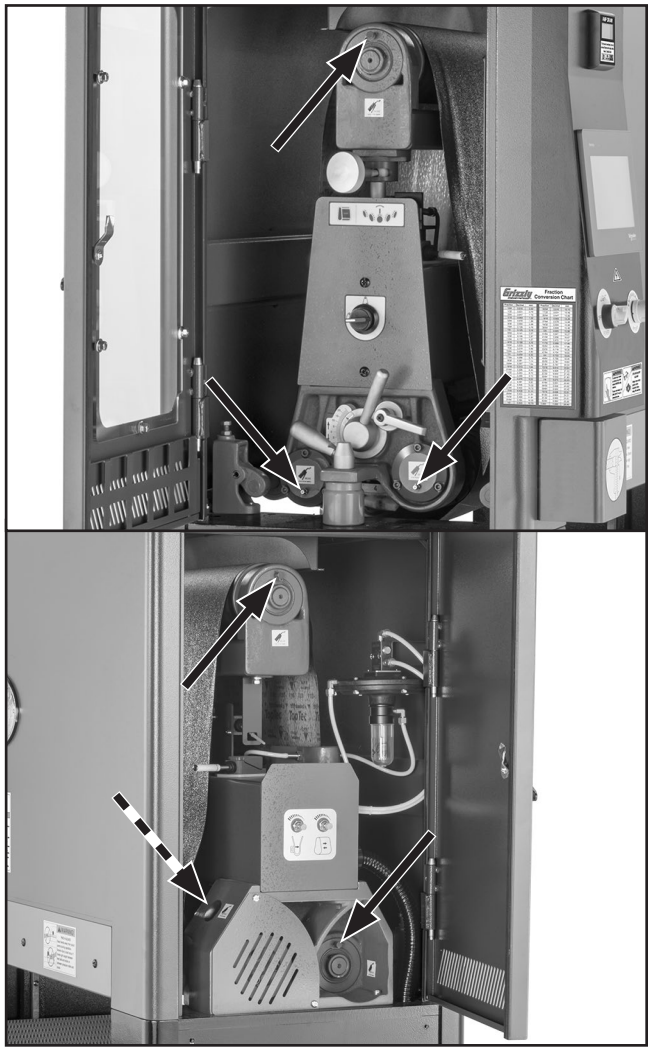


Figure 75. Location of Model G0409/G0411 sanding belt roller and drum grease fittings.

6. Add 1–2 pumps of grease to each grease fitting.

7. **Model G0408 Only:** Install V-belt cover.

8. 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
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 76** to remove left and right access panels.

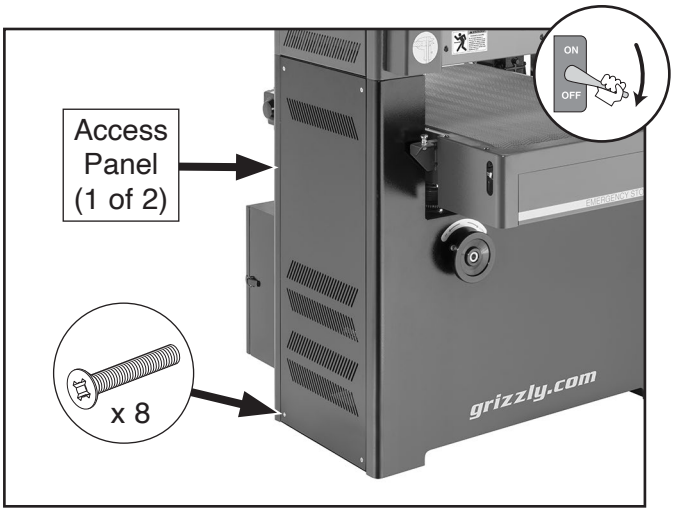


Figure 76. Location of access panels and screws (G0408 shown).

4. Use wire brush and mineral spirits to remove old lubricant and built-up grime from chain, exposed leadscrew teeth, and sprockets (see **Figure 77**).

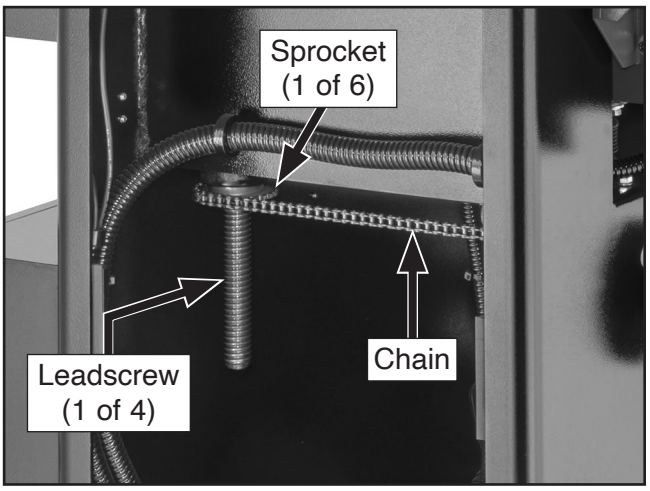


Figure 77. Location of table elevation chain, leadscrews, and sprockets.

5. When components are dry, brush grease onto chain, leadscrews, and sprockets, being careful not to get grease on V-belts.

6. Wipe off any excess or spilled grease.

7. Install left and right access panels and secure with screws removed in **Step 3**.

8. Connect machine to power, then raise and lower table through its full range of movement to evenly distribute grease.

Checking Conveyor Gearbox Oil

Lubrication Type ..... ISO-VG 460 Gear Oil
Amount ..... As Needed
Frequency..... Daily

The gearbox oil should fill the sight glass about halfway full. Use the following steps to check the gearbox oil level and add oil when needed.

Items Needed	**Qty**
Wrench or Socket 14mm	1

To check conveyor gearbox oil:

1. Run machine for 10 minutes to warm up oil in gearbox.

2. DISCONNECT MACHINE FROM POWER!

3. Check oil level in sight glass (see **Figure 78**).

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

   — If oil level fills less than half of sight glass, proceed to **Step 4**.

4. Remove fill plug (see **Figure 78**), add oil until it fills half of sight glass, then install fill plug.

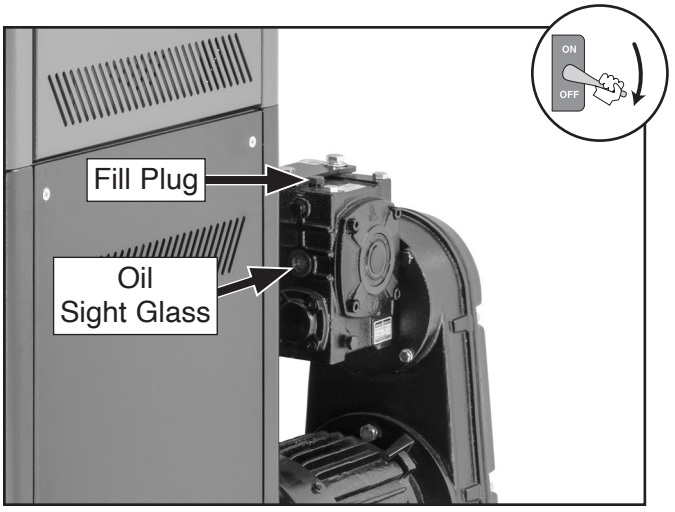


Figure 78. Conveyor gearbox oil filling components.

Changing Conveyor Gearbox Oil

Lubrication Type ..... ISO-VG 460 Gear Oil
Amount ..... As Needed
Frequency..... Yearly

The gearbox oil should be drained and refilled after the first 100 hours of use, then once every year.

Items Needed	Qty
Wrench or Socket 14mm	1
Drain Pan	1
Thread-Sealing Tape	As Needed

To change conveyor gearbox oil:

1. Run machine for 10 minutes to warm up oil in gearbox.
2. DISCONNECT MACHINE FROM POWER!
3. Remove fill plug (see **Figure 79**).
4. Place drain pan under drain plug (see **Figure 79**), then remove drain plug to drain oil.

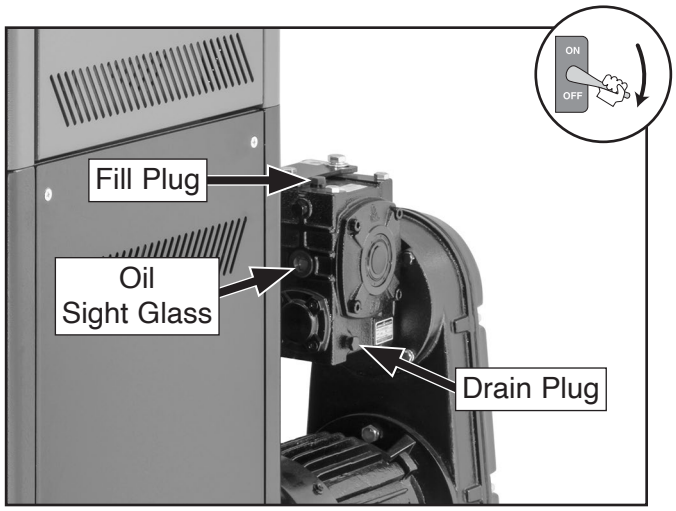


Figure 79. Conveyor gearbox oil components.

5. When oil is drained, clean threads of drain plug, wrap threads with thread-sealing tape, then install drain plug.
6. Fill gearbox with oil until oil level is at halfway point in sight glass (see **Figure 79**), then install fill cap.
7. Connect machine to power, then complete **Checking Conveyor Gearbox Oil** on **Page 53**.

Checking/Adjusting V-Belt Tension

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

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

⚠CAUTION

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

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 80** to remove left and right access panels.

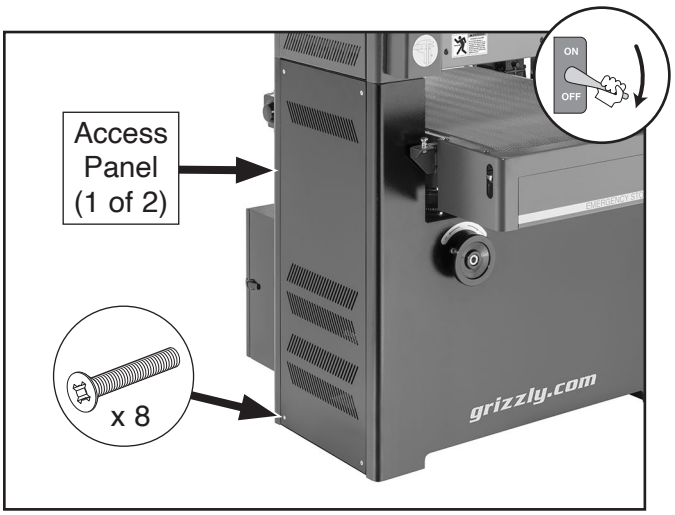


Figure 80. Location of access panels and screws (G0408 shown).

3. Check V-belt tension: each V-belt (see **Figure 81**–**Figure 83**) is correctly tensioned when there is approximately ½"–¾" deflection when it is pushed with moderate pressure, as shown in **Figure 84**.

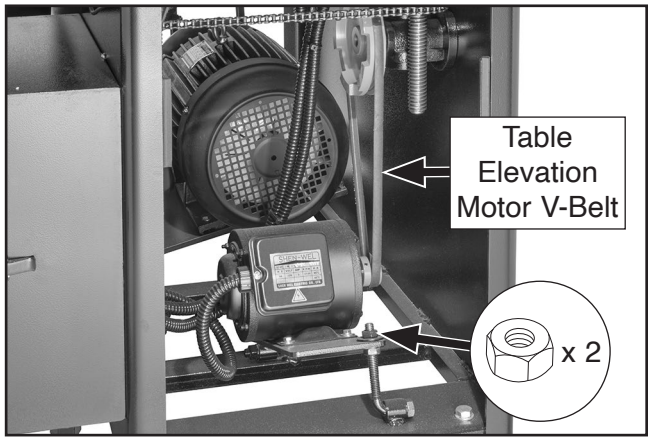


Figure 81. Location of table elevation motor V-belt components (G0408 shown).

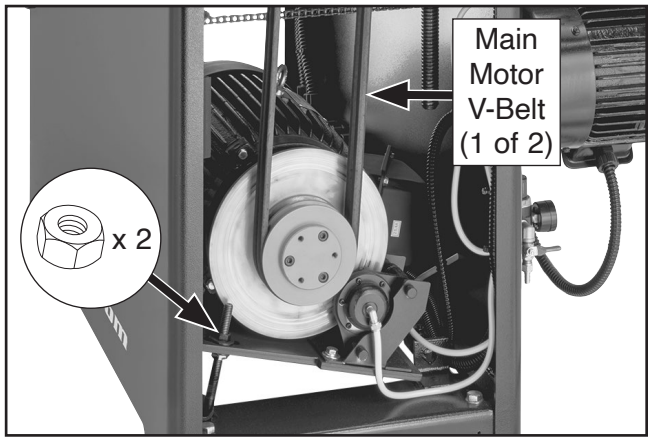


Figure 82. Location of Model G0408 main motor V-belt components.

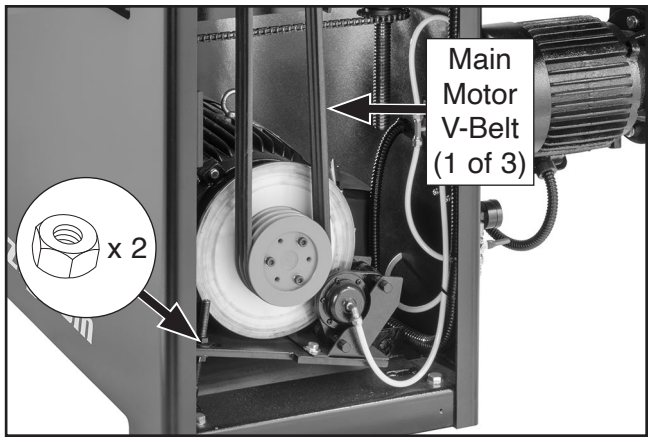


Figure 83. Location of Model G0409/G0411 main motor V-belt components (G0409 shown).

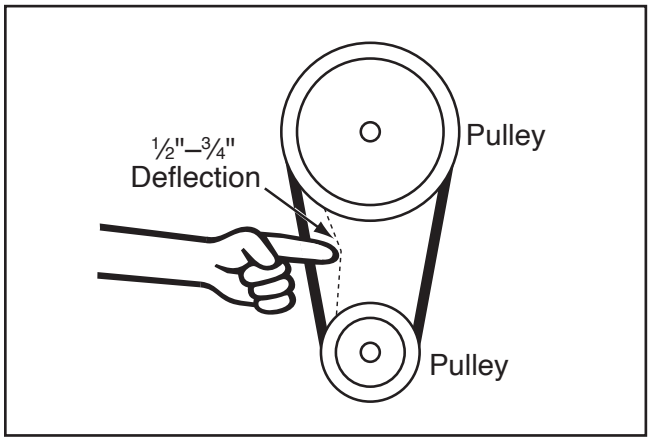


Figure 84. Checking V-belt tension.

— If there *is* approximately ½"–¾" 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 ½"–¾" 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 81**–**Figure 83**) to raise or lower motor until there is approximately ½"–¾" 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).

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

Replacing V-Belts

Check the V-belts monthly 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(s). If any of the main motor V-belts show these conditions, replace the V-belts as a matched set.

⚠CAUTION

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

Replacing Table Elevation Motor V-Belt

Items Needed	Qty
Phillips Head Screwdriver #2	1
Open-End Wrench 19mm	1
Replacement V-Belt	
—G0408/G0409 (P04081315)	1
—G0411 (P04111315)	1

To replace table elevation motor V-belt:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (4) screws shown in **Figure 85** to remove left access panel.

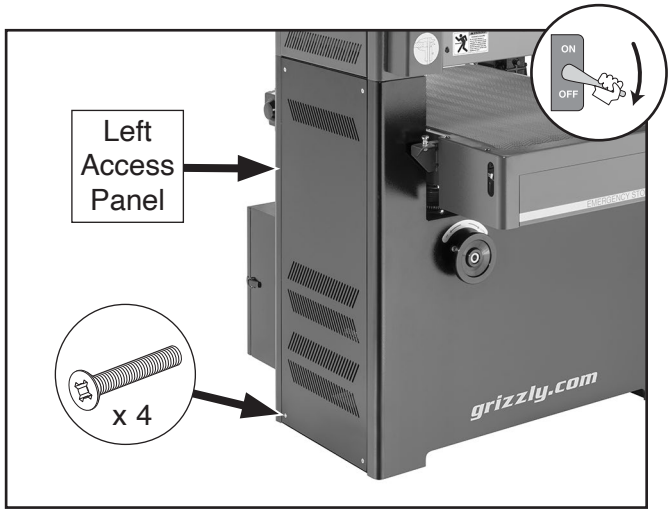


Figure 85. Location of left access panel and screws (G0408 shown).

3. Rotate (2) V-belt tension nuts (see **Figure 86**) counterclockwise to release V-belt tension until you can remove V-belt from pulleys.

4. Place new V-belt onto table pulley, then loop other end of V-belt around motor pulley (see **Figure 86**).

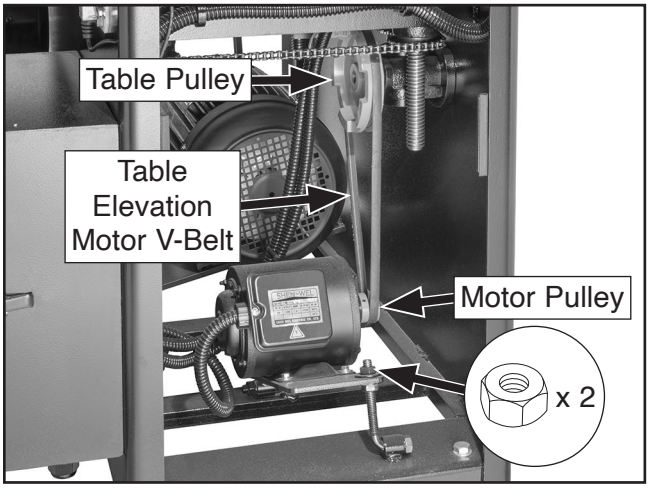


Figure 86. Table elevation motor V-belt components (G0408 shown).

5. Properly tension V-belt (refer to **Checking/ Adjusting V-Belt Tension** on **Page 54** for more information).

6. Install left access panel and secure with screws removed in **Step 2**.

Replacing Main Motor V-Belts

Items Needed	Qty
Phillips Head Screwdriver #2	1
Open-End Wrench 19mm	1
Replacement V-Belts	
—G0408 (P04080119)	2
—G0409 (P04090119)	3
—G0411 (P04110119)	3

To replace main motor V-belts:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (4) screws shown in **Figure 87** to remove right access panel.

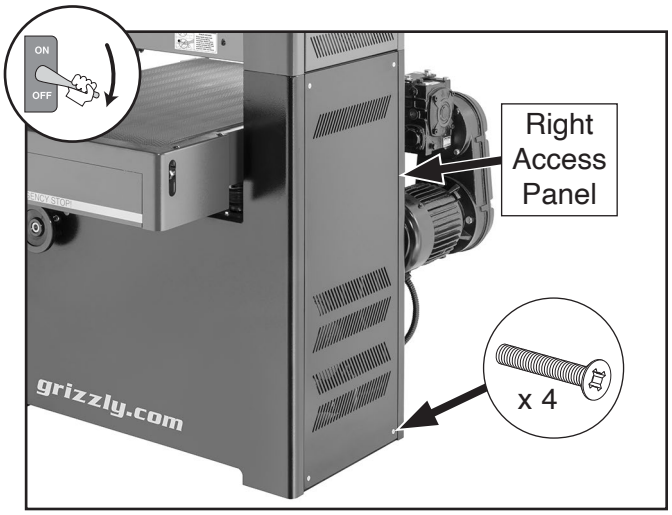


Figure 87. Location of right access panel and screws (G0408 shown).

3. Rotate (2) V-belt tension nuts (see **Figure 88–Figure 89**) counterclockwise to release V-belt tension until V-belts can be removed from motor pulley.

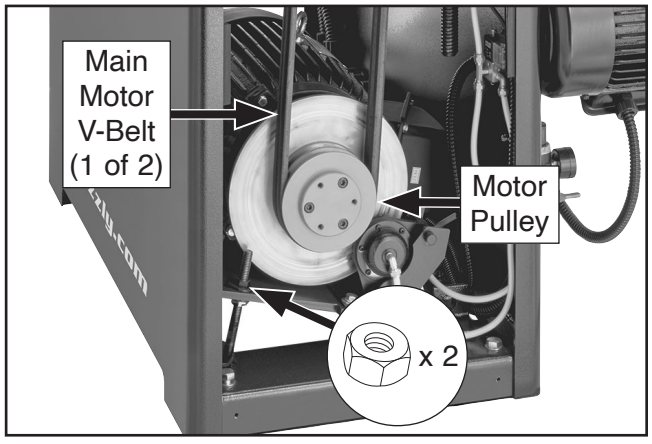


Figure 88. Model G0408 main motor V-belt components.

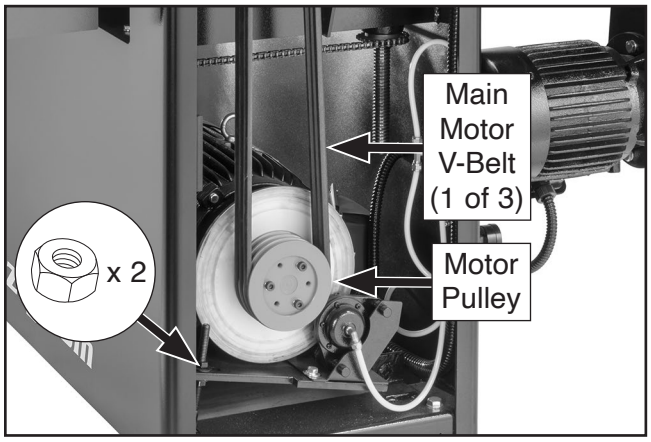


Figure 89. Model G0409/G0411 main motor V-belt components (G0409 shown).

Note: *If brake assembly prevents V-belt removal, refer to* ***Checking/Replacing Brake Pads*** *on* ***Page 70*** *for detailed instructions on how to remove brake assembly.*

4. Open right door.

5. **Model G0408:** Open right door, then remove (3) screws shown in **Figure 90** to remove V-belt cover.

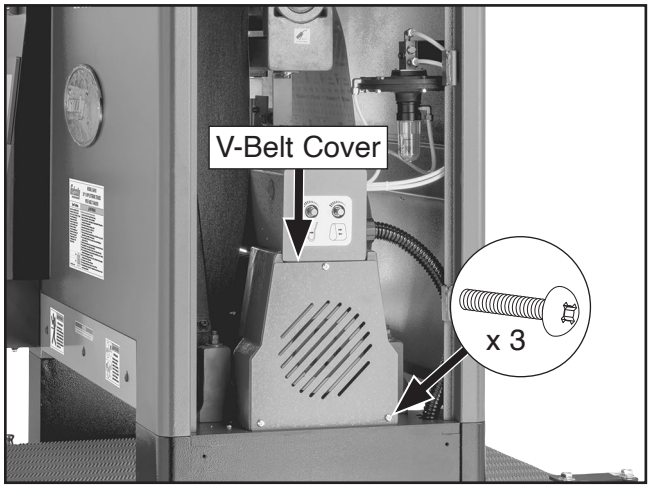


Figure 90. Location of Model G0408 V-belt cover and screws.

Model G0409/G0411: Open right door, then remove (2) screws shown in **Figure 91** to remove V-belt cover.

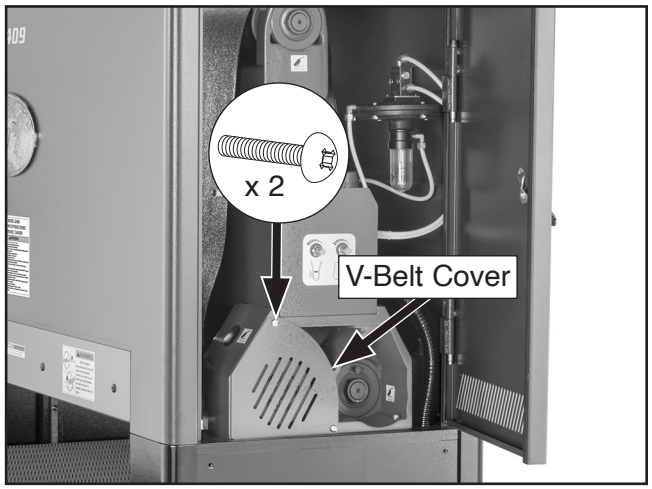


Figure 91. Location of G0409/G0411 V-belt cover and screws (G0409 shown).

6. Remove V-belts from sanding drum pulley (see **Figure 92**–**Figure 93**).

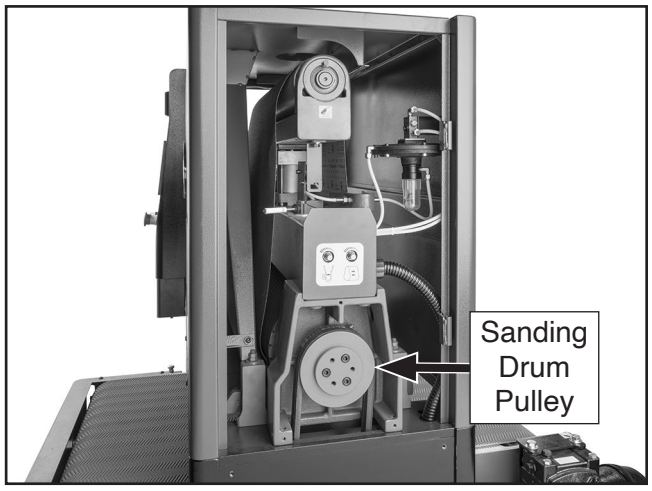


Figure 92. Location of Model G0408 sanding drum pulley.



Figure 93. Location of Model G0409/G0411 sanding drum pulley.

7. Place new set of V-belts onto sanding drum pulley and then loop other end of V-belts around motor pulley.

8. Install V-belt cover and screws from **Step 5**, then close right door.

9. Properly tension V-belt (refer to **Checking/ Adjusting V-Belt Tension** on **Page 54** for more information).

10. Install right access panel and secure with screws removed in **Step 2**.

Emptying Dust & Water Traps

Two collection traps on this sander need to be emptied regularly. DO NOT allow these traps to become full or you risk serious damage to the machine.

The regulator filter trap (see **Figure 94**) is attached to the air pressure regulator and traps condensation from the incoming air supply. With the system pressurized, pull the drain valve down to empty the collected water. Once a year, replace the internal white filter.

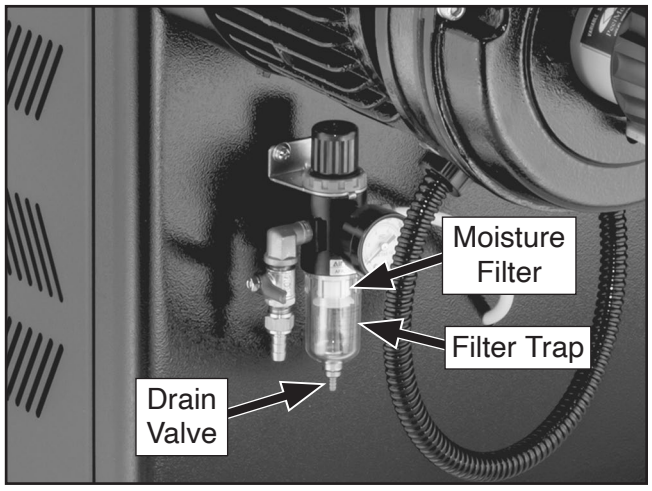


Figure 94. Regulator filter trap components.

There is a dust trap bowl inside the right door (see **Figure 95**). To empty this bowl, turn the incoming air OFF, allow the pressure to bleed out, then unscrew and empty the bowl.

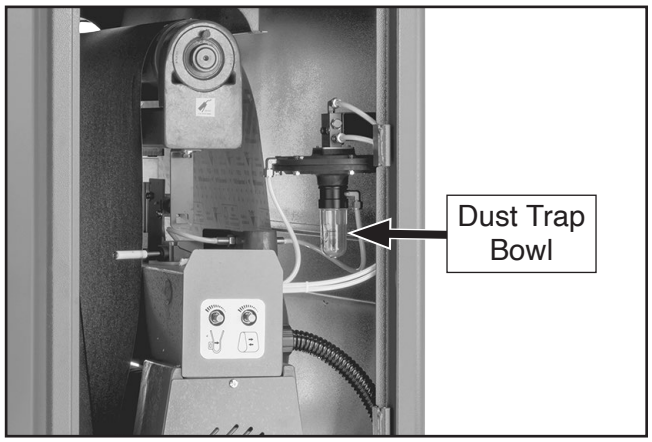


Figure 95. Location of dust trap bowl (G0408 shown).

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. ¾" thick.



Figure 96. D3003 PRO-STICK® 15" x 20" Sanding Pad.

To clean sanding belt:

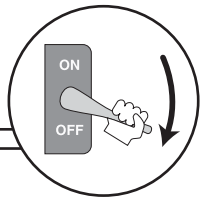
1. Set table elevation to thickness of cleaning pad.

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.	1. Power supply circuit breaker tripped or fuse blown. 2. Blown fuse. 3. Incorrect power supply voltage or circuit size. 4. Wiring broken, disconnected, or corroded.	1. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 2. Replace fuse/ensure no shorts. 3. Ensure correct power supply voltage and circuit size. 4. Fix broken wires or disconnected/corroded connections (**Page 87**).
Motors do not start, or power supply breaker immediately trips after startup.	1. Safety fault engaged. 2. Power supply circuit breaker tripped or fuse blown. 3. Thermal overload relay has tripped. 4. Blown fuse. 5. Incorrect power supply voltage or circuit size. 6. Motor wires connected incorrectly. 7. Centrifugal switch needs adjustment/contact points dirty (Model G0408/G0409 only). 8. Wiring broken, disconnected, or corroded. 9. Timer/start delay module adjusted incorrectly (Model G0411 only). 10. Motor or motor bearings at fault.	1. Use fault message to determine required action (**Page 49**). 2. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 3. Reset relay. 4. Replace fuse/ensure no shorts. 5. Ensure correct power supply voltage and circuit size. 6. Correct motor wiring connections (**Page 87**). 7. Adjust centrifugal switch/clean contact points. 8. Fix broken wires or disconnected/corroded connections (**Page 87**). 9. Adjust to correct delay. 10. Replace motor.
Machine stalls or is underpowered.	1. Motor wires connected incorrectly. 2. Motor overheated. 3. Centrifugal switch needs adjustment/contact points dirty (Model G0408/G0409 only). 4. Motor or motor bearings at fault. 5. Timer/start delay module adjusted incorrectly (Model G0411 only).	1. Correct motor wiring connections (**Page 87**). 2. Clean motor, let cool, and reduce workload. 3. Adjust centrifugal switch/clean contact points. 4. Replace motor. 5. Adjust to correct delay.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor mount loose/broken. 3. Motor fan rubbing on fan cover. 4. Centrifugal switch needs adjustment (Model G0408/G0409 only). 5. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Tighten/replace. 3. Fix/replace fan cover; replace loose/damaged fan. 4. Adjust switch. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Motor & Electrical (Cont.)

Symptom	Possible Cause	Possible Solution
Table does not move in direction of button description (Model G0411 only).	1. Phase polarity of incoming power is reversed.	1. Correct phase polarity (**Page 37**).
Interior light does not illuminate.	1. Wiring broken, disconnected, or corroded.	1. Fix broken wires or disconnected/corroded connections (**Page 87**).

Operation

Symptom	Possible Cause	Possible Solution
Machine slows or is underpowered; stops under load.	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 gearbox at fault.	1. Only sand wood/ensure moisture is below 20% (**Page 42**). 2. Reduce feed rate (**Page 47**). 3. Reduce depth of cut (**Page 41**). 4. Replace with coarser grit sanding belt (**Page 44**). 5. Clean (**Page 59**)/replace (**Page 44**) sanding belt. 6. Clean/tension/replace V-belts(s) (**Page 54**); 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.	1. Sanding belt seam open/damaged. 2. V-belt(s) worn, loose, pulleys misaligned or belt slapping cover. 3. Pulley loose. 4. Conveyor gearbox at fault.	1. Replace sanding belt (**Page 44**). 2. Inspect/replace belt(s) (**Page 54**). 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.	1. Excessive depth of cut.	1. Reduce depth of cut (**Page 41**).
Uneven thickness from left to right of board.	1. Conveyor belt worn. 2. Sanding belt worn unevenly. 3. Conveyor table not parallel to sanding drum.	1. Replace conveyor belt (**Page 80**). 2. Feed workpieces across sanding belt to distribute wear evenly, not just on one side. 3. Adjust conveyor table parallelism (**Page 75**).
Workpiece slips on conveyor belt.	1. Conveyor belt dirty. 2. Pressure rollers set too high. 3. Conveyor belt worn.	1. Clean conveyor belt. 2. Lower pressure rollers (**Page 77**). 3. Replace conveyor belt (**Page 80**).
Grooves down length of workpiece.	1. Platen felt/graphite damaged. 2. Sanding belt dirty/damaged.	1. Replace graphite pad or felt pad (**Page 68**). 2. Clean (**Page 59**)/replace (**Page 44**) sanding belt.
Lines across width of workpiece.	1. Sanding belt seam open/damaged.	1. Replace sanding belt (**Page 44**).
Glossy spots or streaks on workpiece.	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.	1. Increase feed rate (**Page 47**). 2. Use more accurate method to establish correct material removal amount (**Page 41**). 3. Replace sanding belt (**Page 44**). 4. Raise rear pressure roller (**Page 77**).

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Sanding belt clogs quickly.	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.	1. Replace with coarser grit sanding belt (**Page 44**). 2. Reduce depth of cut (**Page 41**). 3. Use more accurate method to establish correct material removal amount (**Page 41**). 4. Allow wood to dry to below 20% moisture content (**Page 42**).
Sanding belt does not tension correctly; drum(s)/roller(s) slip under belt.	1. Low air pressure. 2. Air leaks in system. 3. Belt tension cylinder shaft worn/damaged.	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.
Sanding belt runs off to one side, stopping sander.	1. Oscillation speed/timing not adjusted correctly. 2. Oscillation control fork gap/air lines clogged. 3. Solenoid valve/air manifold at fault.	1. Adjust oscillation speed/timing (**Page 65**). 2. Clean fork gap/air lines. 3. Test/repair/replace.
Poor, non-aggressive sanding results.	1. Sanding belt clogged/worn. 2. Sanding belt grit too fine for particular job. 3. Conveyor table not parallel to sanding drum.	1. Clean (**Page 59**) /replace (**Page 44**) sanding belt. 2. Replace with coarser grit (**Page 44**). 3. Adjust conveyor table parallelism (**Page 75**).
Sanding belt will not start, but table will move with power controls.	1. No air pressure to machine. 2. Sanding belt not tensioned.	1. Connect machine to compressed air system. 2. Tension sanding belt.
Conveyor belt runs off to one side.	1. Conveyor belt tracking not adjusted correctly.	1. Adjust conveyor belt tracking (**Page 79**).
Conveyor belt slipping.	1. Conveyor rollers contaminated with dirt/dust. 2. Conveyor belt has incorrect tension.	1. Clean conveyor rollers. 2. Adjust conveyor rollers to place more tension on conveyor belt (**Page 79**).
Emergency brake stops slowly.	1. Low air pressure. 2. Air leaks in system. 3. Main motor brake disc contaminated with oil. 4. Brake pads worn out or disc brake assembly is not functioning correctly.	1. Adjust incoming air pressure to 75 PSI at regulator. 2. Inspect hoses/connections for leaking air; use water/soap mixture on suspected area to detect bubbles. 3. Clean brake disc with automotive brake parts cleaner. 4. Take apart and inspect disc brake assembly. Replace brake pads (**Page 70**) and any other worn parts
Grinding noise when braking.	1. Brake pads worn out.	1. Replace brake pads (**Page 70**); have machine shop turn/true main motor brake disc; replace disc.
Air leaking from machine.	1. Compressed air release typical of pneumatic systems. 2. Water filter/trap drain valve open. 3. Air leaks in system.	1. 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. 2. Ensure water filter/trap drain valve is closed and tight (**Page 59**). 3. Inspect hoses/connections for leaking air; use water/soap mixture on suspected area to detect bubbles.
Poor dust collection.	1. Dust collection lines sized incorrectly or dust collector too far away from machine. 2. Dust collector underpowered.	1. Redesign dust collection system. 2. Upgrade dust collector.
Interior light does not illuminate.	1. LED strip covered with dust.	1. 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
Wrench or Socket 10mm	1

To calibrate workpiece thickness sensor:

1. Place workpiece across conveyor table so part of it rests over peg shown in **Figure 97**.

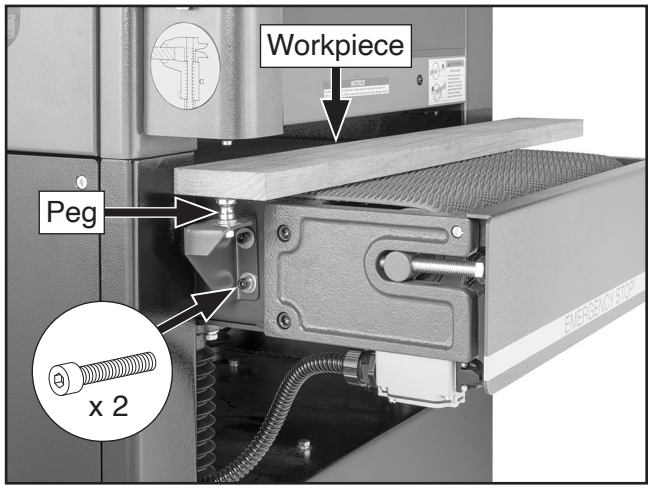


Figure 97. Workpiece resting on workpiece thickness peg (example shown).

— 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 97**, 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 under drum (see **Figure 98**).

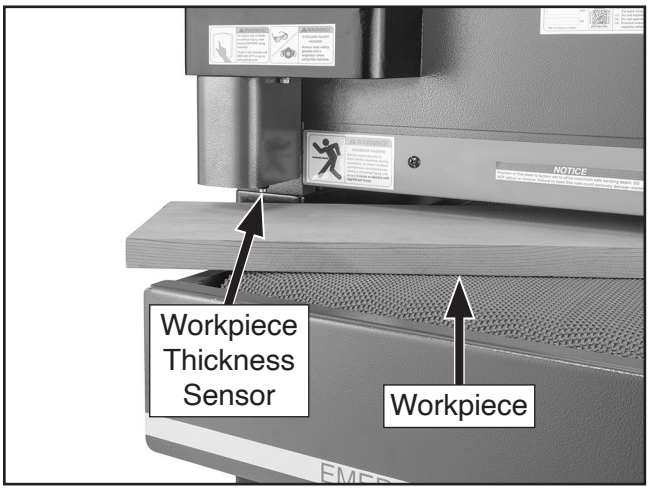


Figure 98. Workpiece under workpiece thickness sensor and sanding drum (example shown).

4. Press and hold table up button until workpiece triggers sensor or just touches sandpaper on sanding drum.

— If workpiece triggers sensor and contacts sandpaper at the same time, no further adjustment is required.

— If workpiece triggers sensor before it contacts sandpaper, or workpiece contacts sandpaper without triggering sensor, proceed to **Step 5**.

5. DISCONNECT MACHINE FROM POWER!

6. Open left door.

7. Remove (4) flange bolts shown in **Figure 99** to remove sensor cover.

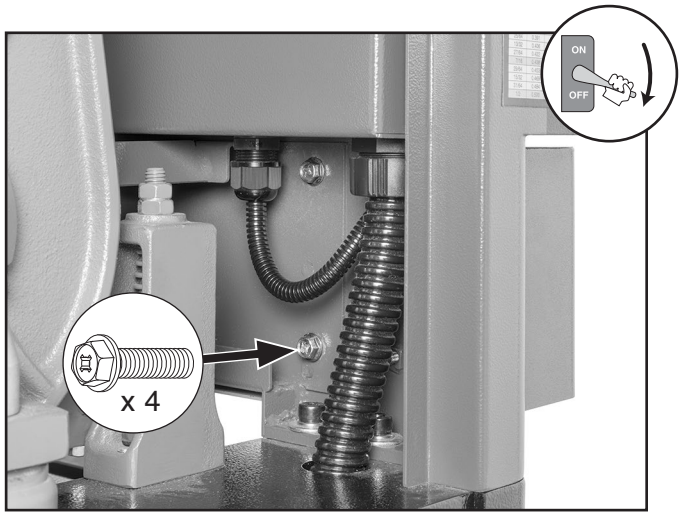


Figure 99. Location of sensor cover bolts (G0408 shown).

8. Loosen (2) hex bolts shown in **Figure 100**.

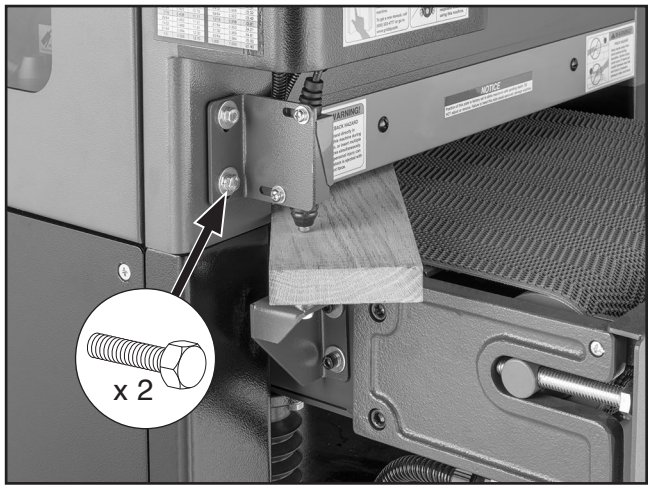


Figure 100. Workpiece thickness sensor calibration hex bolts (example shown).

9. Adjust table elevation until workpiece just contacts sandpaper.

10. Adjust workpiece thickness sensor until you hear it click against workpiece, then tighten hex bolts to secure position.

11. Lower table, then repeat **Step 4** to check adjustment. When sensor is correctly calibrated, install sensor cover and close left door.

Calibrating Thickness Display

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

Items Needed	**Qty**
2x4 (24" Long)	1
Digital Calipers	1

To calibrate thickness display:

1. Sand planed 2x4 multiple times at the same table elevation until no sanding occurs when workpiece goes through sander.

2. Measure workpiece thickness.

3. Check thickness display (see **Figure 101**).

   — 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**.

4. Use table up/down buttons to change "adjust thickness" value (see **Figure 101**) to match measurement taken in **Step 2**, then quickly hold calibration button until thickness display changes.

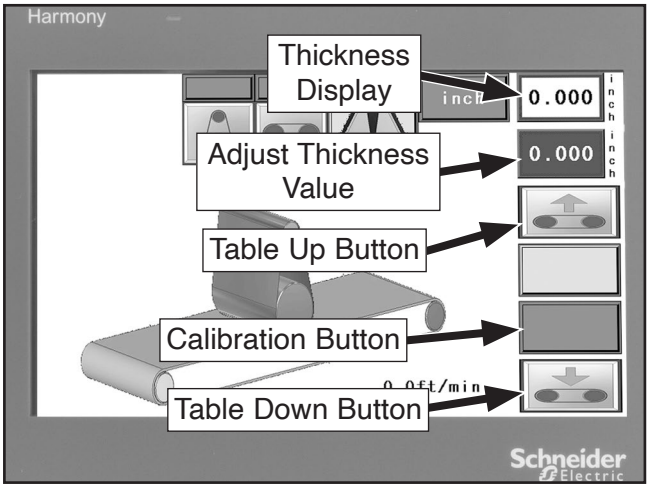


Figure 101. Location of thickness display calibration components (G0408 shown).

Adjusting Belt Tracking Limit Switches

Sanding belt tracking limit switches (see **Figure 102**) 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.

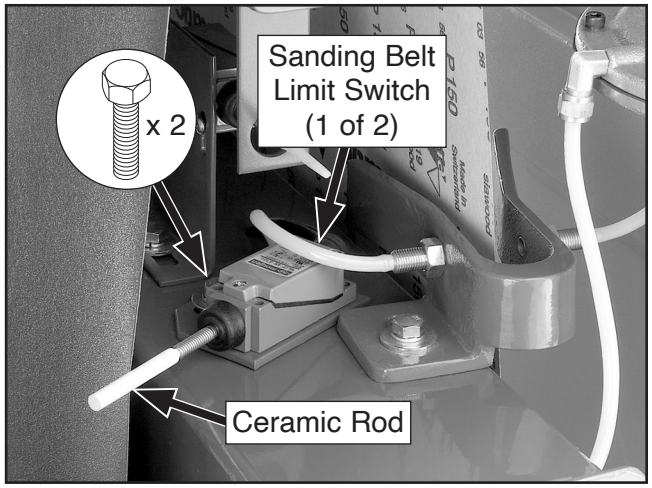


Figure 102. Limit switch adjustment components.

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 Timing & Speed** on **Page 65**).

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 102**).

5. Loosen adjustment bolts shown in **Figure 102**, move switches so belt and rods are about ¼" apart, then tighten bolts to secure.

6. Start machine and make sure limit switches are working properly.

Adjusting Oscillation Timing & Speed

When the oscillation is correctly adjusted, the sanding belt oscillates to the left and to the right at the same speed. If the sanding belt makes contact with a limit switch, as shown in **Figure 103**, the emergency braking system will activate and stop the sander immediately.

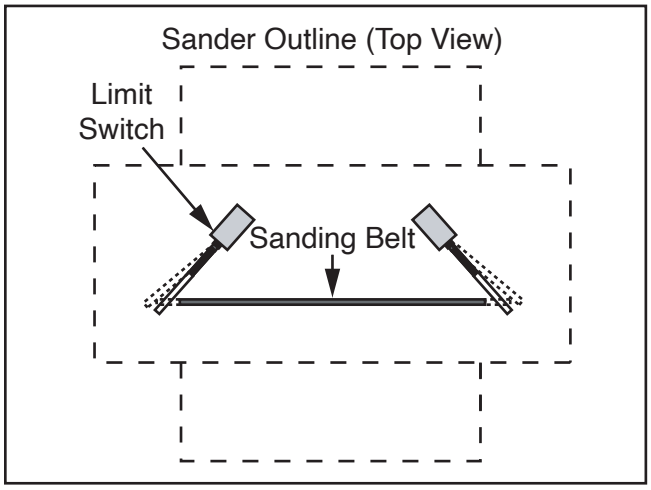


Figure 103. Improper oscillation.

Checking Oscillation

1. Confirm sanding belt is properly installed, belt tension knob is in tensioned position, and air supply is ***ON***.

2. Close left door and start sanding belt, watching through view window as belt tracks along upper roller.

   — If sanding belt oscillates without contacting limit switches, and oscillation time left and right is equal, no adjustment is required.

   — If sanding belt tracks away from air fork and air jet, colliding into left limit switch, proceed to **Adjusting Fork Airflow** on **Page 66**.

   — If sanding belt oscillates without contacting limit switches, but oscillation time left and right is not equal, proceed to **Equalizing Oscillation Speed** on **Page 67**.

Adjusting Fork Airflow

An adequate stream of air through the oscillation control fork gap is essential for proper oscillation (see **Figure 104**). If airflow is weak through the gap, the belt will track away from the fork and into the limit switch on the opposite end of the roller.

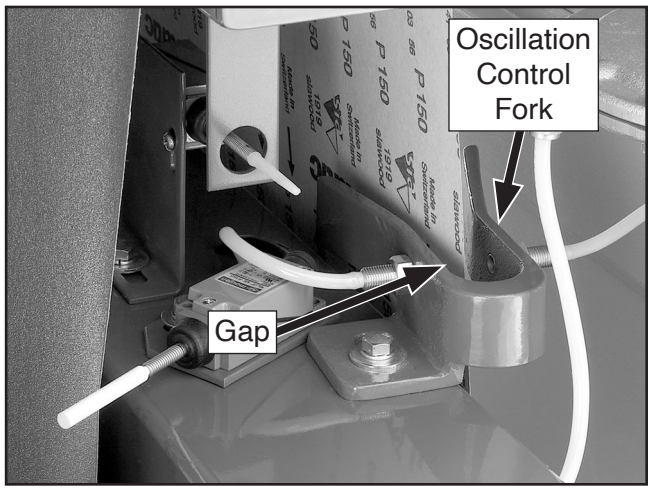


Figure 104. Oscillation control fork components.

Items Needed	Qty
Wrench 9mm	1
Scrap Cardboard Piece	1

To adjust fork airflow:

1. DISCONNECT MACHINE FROM POWER!

2. Remove sanding belt and move belt tension knob to tensioned position.

3. Open right door.

4. Loosen lock nut on airflow adjustment knob (see **Figure 105**).

5. Turn airflow adjustment knob (see **Figure 105**) clockwise until airflow is completely ***OFF***. Upper roller should swing right.

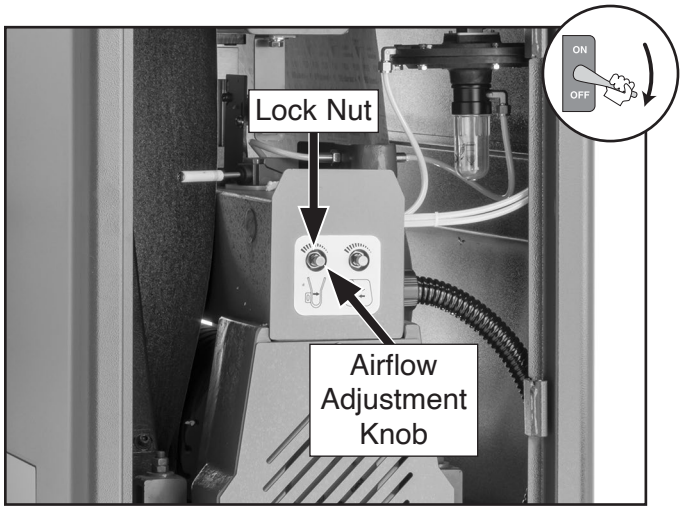


Figure 105. Airflow adjustment components (G0408 shown).

6. Slowly turn airflow adjustment knob counter-clockwise until airflow swings roller left.

7. Tighten lock nut to secure airflow adjustment.

8. Restrict airflow across fork gap with piece of cardboard. Roller should swing right. When cardboard is removed, roller should swing back left.

9. Install sanding belt, connect machine to power, then refer to **Checking Oscillation** on **Page 65** to determine if further adjustment is required.

Equalizing Oscillation Speed

⚠WARNING

Belt must be moving and door must be open during this adjustment. Keep away from moving sanding belt to avoid entanglement and abrasion injuries.

To equalize oscillation speed:

1. Open left door and start sanding belt. Make note of time it takes for belt to oscillate from left to right, and from right to left.

   — If oscillation time to *left* is longer than to *right*, loosen oscillation timing knob (see **Figure 106**) and move it left until timing is equalized. Tighten knob when satisfied.

   — If oscillation time to *right* is longer than to *left*, loosen oscillation timing knob (see **Figure 106**) and move it right until timing is equalized. Tighten knob when satisfied.

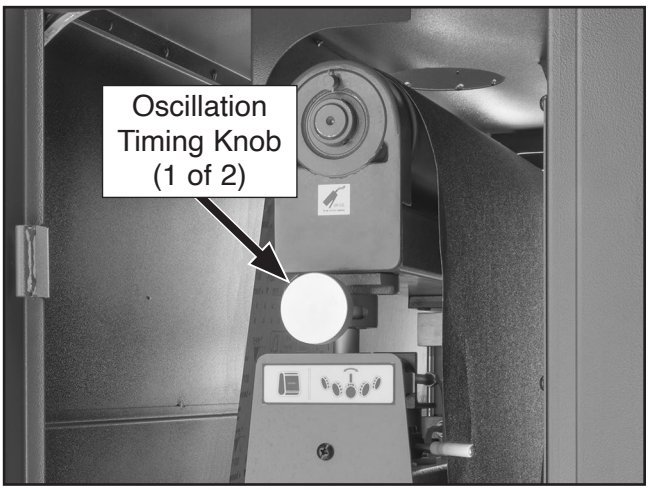


Figure 106. Location of oscillation timing knob.

Adjusting Oscillation Speed

The oscillation speed of the sanding belt is adjustable. Different oscillating speeds yield different sanding results. We recommend trying various speeds on a scrap piece of wood similar to the final workpiece.

Tool Needed	Qty
Wrench 9mm	1

⚠WARNING

Belt must be moving and door must be open during this adjustment. Keep away from moving sanding belt to avoid entanglement and abrasion injuries.

To adjust oscillation speed:

1. Open right door.
2. Loosen lock nut on speed adjustment knob (see **Figure 107**).
3. Start sanding belt. Make note of time it takes for belt to oscillate from one side to the other.
4. Turn speed adjustment knob (see **Figure 107**) clockwise to decrease oscillation speed or counterclockwise to increase oscillation speed.

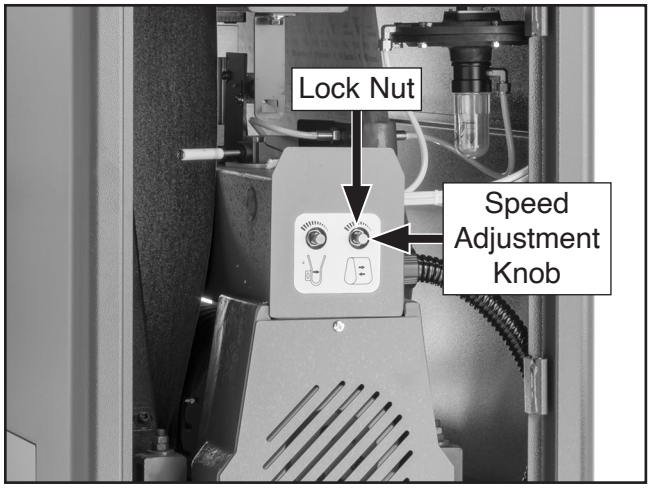


Figure 107. Oscillation speed adjustment components (G0408 shown).

5. When satisfied with adjustment, stop sanding belt and DISCONNECT MACHINE FROM POWER!
6. Tighten lock nut to secure speed adjustment.
7. Close right door.

Servicing Platen (G0409/G0411 Only)

The platen graphite pad and felt pad should be inspected on a daily basis and replaced when they become worn or damaged.

Due to its function, it is very important for the graphite pad to be flat, smooth, and free of grooves or low spots. It is also important that no dust or chips get trapped between the graphite pad and felt pad of the platen.

If surface defects are found, lightly hand-sand the platen to make the surface flat again. If surface defects are more serious, the graphite pad may need to be replaced. If you notice a lot of streaking, this can also be a sign that the graphite pad or felt pad needs to be replaced.

Replacing Graphite Pad

Items Needed	Qty
Platen Removal Tool	1
Phillips Head Screwdriver #2	1
Replacement Graphite Pad	
—G0409 (P04090005)	1
—G0411 (P04110005)	1
Drill	1
Drill Bit 3/16"	1

To replace graphite pad:

1. DISCONNECT MACHINE FROM POWER!

2. Open left door and remove sanding belt. Keep stop block and stop block release lever removed.

3. Use platen removal tool to pull platen from sanding head, as shown in **Figure 108**.

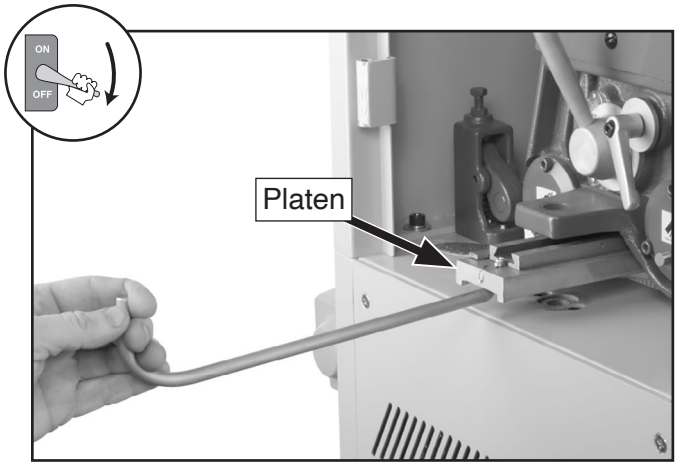


Figure 108. Removing platen (example shown).

4. **Model G0409:** Remove (10) screws shown in **Figure 109** to remove pressure plate that secures graphite pad.

   Model G0411: Remove (14) screws shown in **Figure 109** to remove pressure plate that secures graphite pad.

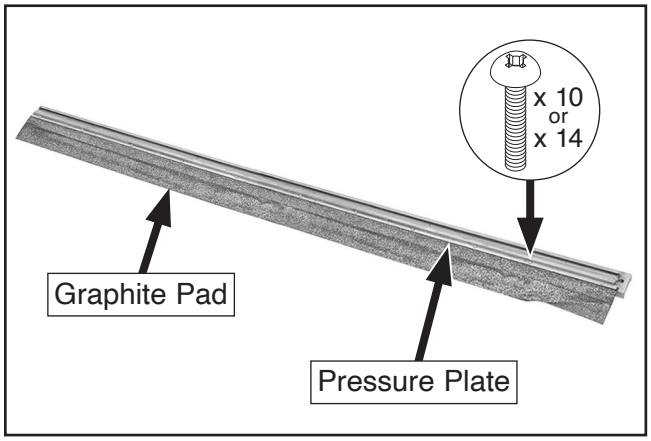


Figure 109. Typical platen components.

5. Install new graphite pad onto platen and secure pad with pressure plate and screws removed in **Step 4**.

   Tip: *If new pad does not have mounting holes, use old pad as template for drilling holes in new pad.*

6. Insert platen in same manner it was removed, making sure open end of graphite pad points toward front of machine.

7. Install sanding belt, stop block, and stop block release lever, then close left door.

Replacing Felt Pad

Items Needed	Qty
Platen Removal Tool	1
Solvent Cleaner	As Needed
Putty Knife	1
Replacement Felt Pad	
—G0409 (P04090004)	1
—G0411 (P04080004)	1
Spray Adhesive or Contact Cement	As Needed

To replace felt pad:

1. DISCONNECT MACHINE FROM POWER!

2. Open left door and remove sanding belt. Keep stop block and stop block release lever removed.

3. Use platen removal tool to pull platen from rear sanding head, as shown in **Figure 110**.

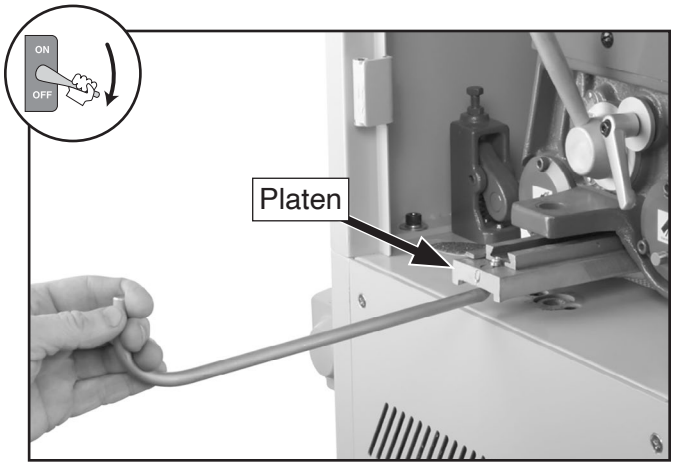


Figure 110. Removing platen (example shown).

4. Thoroughly soak felt pad (see **Figure 111**) in solvent to loosen glue securing pad to platen, then lift felt pad off and let platen dry. Use putty knife to scrape off any remaining felt and glue.

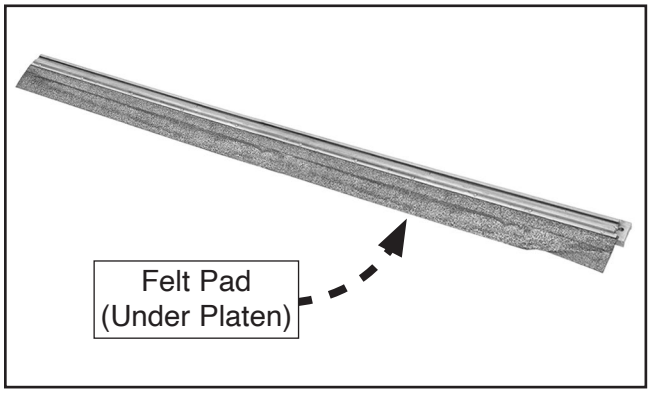


Figure 111. Location of felt pad.

5. Use spray adhesive or contact cement to secure new felt pad to platen.

6. Insert platen in same manner it was removed, making sure open end of graphite pad points toward front of machine.

7. Install sanding belt, stop block, and stop block release lever, then close left door.

Checking/Replacing Brake Pads

The disc brake assembly uses brake pads to stop the main motor (see **Figure 112–Figure 113**) when the EMERGENCY STOP button is pressed, the EMERGENCY STOP! bar is pressed, if the belt tension is disengaged, 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.

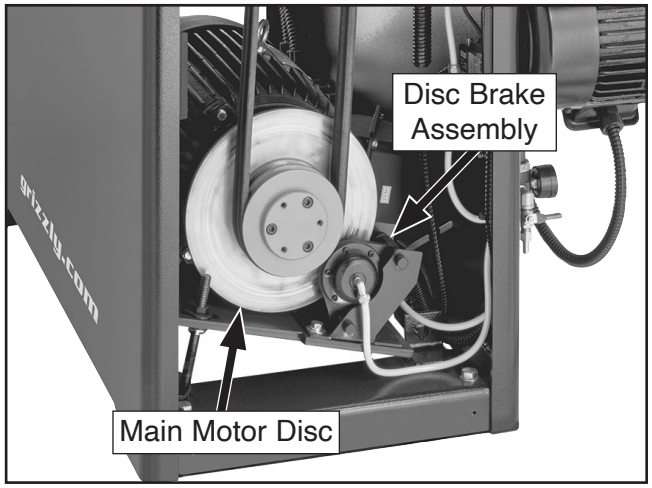


Figure 112. Location of Model G0408/G0409 main motor disc and disc brake assembly.

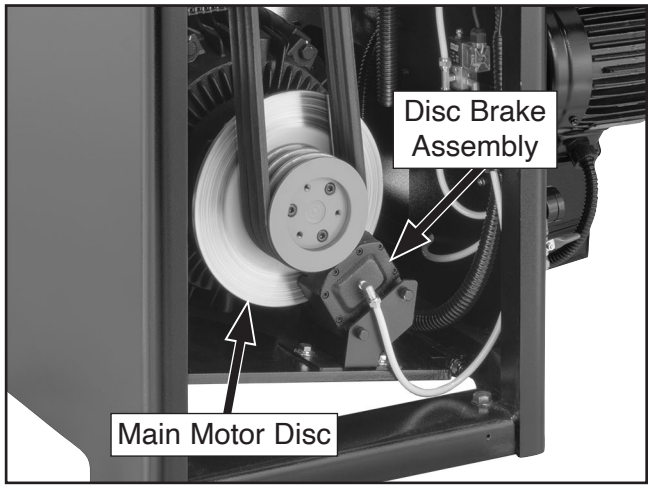


Figure 113. Location of Model G0411 main motor disc and disc brake assembly.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Fine Ruler	1
Wrench or Socket 14mm	1
Hex Wrenches 4, 5mm	1 Ea.
Brake Pads	
—G0408 Set (P04080302)	1
—G0409 Inner (P04090302)	1
—G0409 Outer (P04090315)	1
—G0411 Inner (P04110302)	1
—G0411 Outer (P04110316)	1

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 114**).

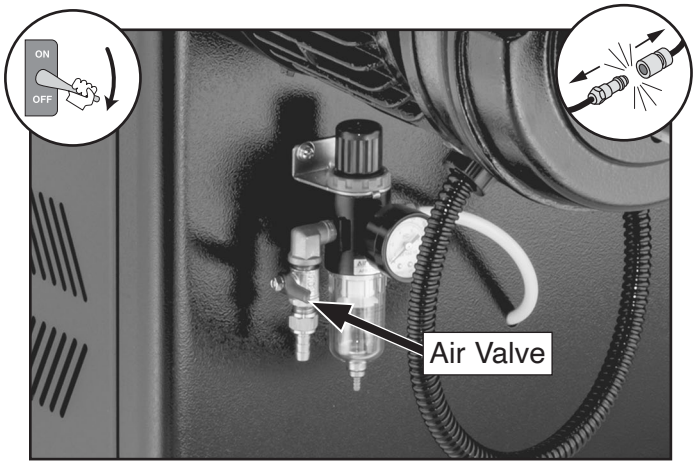


Figure 114. Location of air valve on regulator.

3. Remove (4) screws shown in **Figure 115** to remove right access panel.

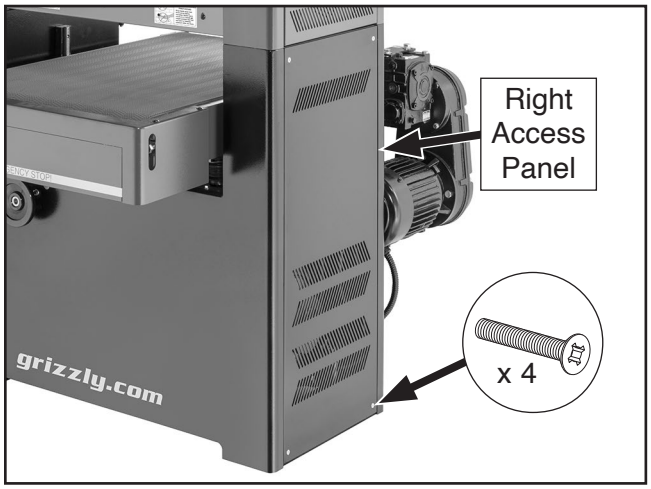


Figure 115. Location of right access panel and screws (G0408 shown).

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 116**).

   — If thickness of each pad is *greater than* ⅛", pads do not need to be replaced. Proceed to **Step 15**.

   — If thickness of either pad is *less than* ⅛", proceed to **Step 5** to replace both pads.

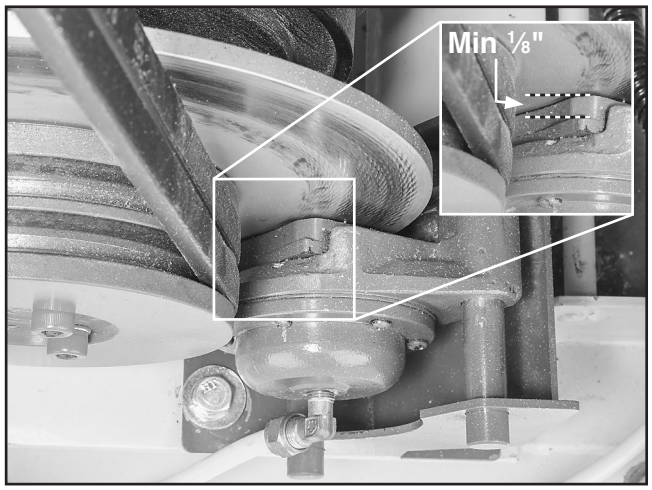


Figure 116. Measuring outer brake pad (example shown).

5. Remove (2) hex bolts, lock washers, and flat washers that secure disc brake assembly to machine motor plate (see **Figure 117**—**Figure 118**).

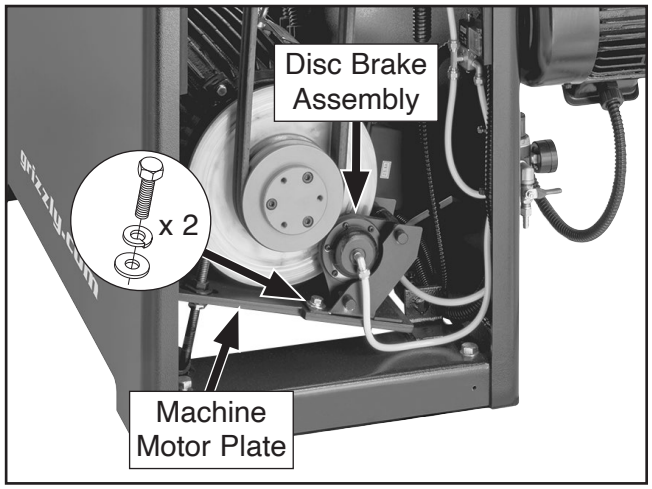


Figure 117. Model G0408/G0409 disc brake assembly removal components.

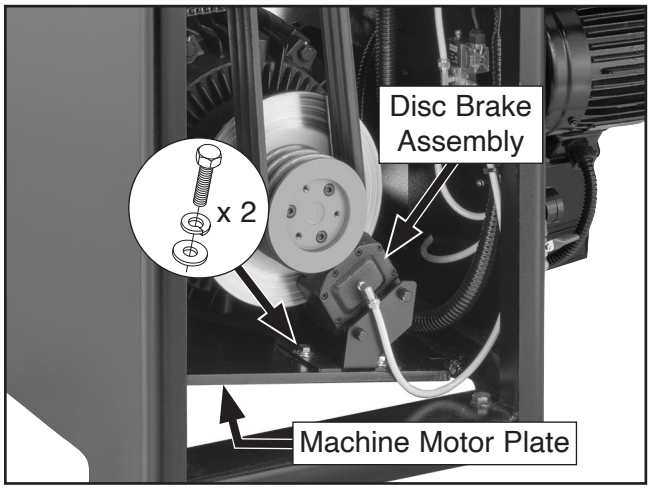


Figure 118. Model G0411 disc brake assembly removal components.

6. Pull disc brake assembly away from rotor.

7. **Model G0408/G0409:** Remove (6) Phillips head screws shown in **Figure 119** to remove diaphragm cover and diaphragm.

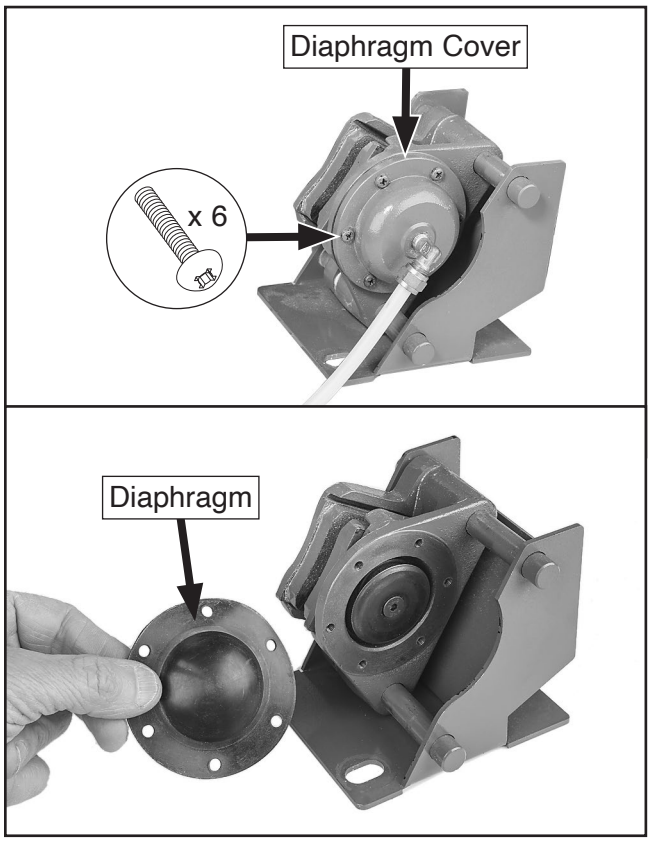


Figure 119. Location of Model G0408/G0409 diaphragm cover and diaphragm.

Model G0411: Remove (8) cap screws shown in **Figure 120** to remove diaphragm cover and diaphragm.

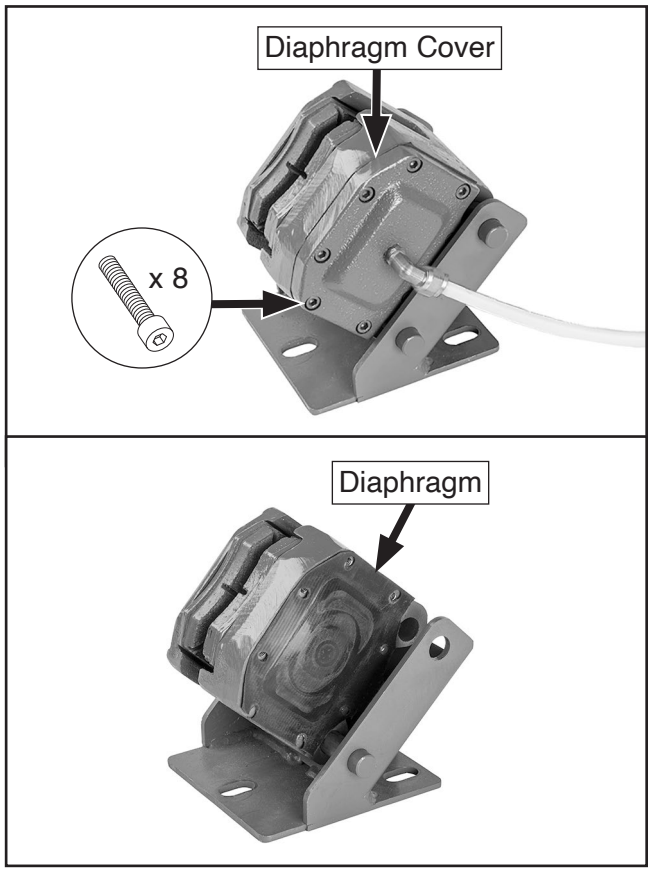


Figure 120. Location of Model G0411 diaphragm cover and diaphragm.

Note: *To access all Model G0411 diaphragm cover screws, remove (1) hex nut and (1) stud shown in* ***Figure 121****. This will allow caliper to pivot in mount as needed.*

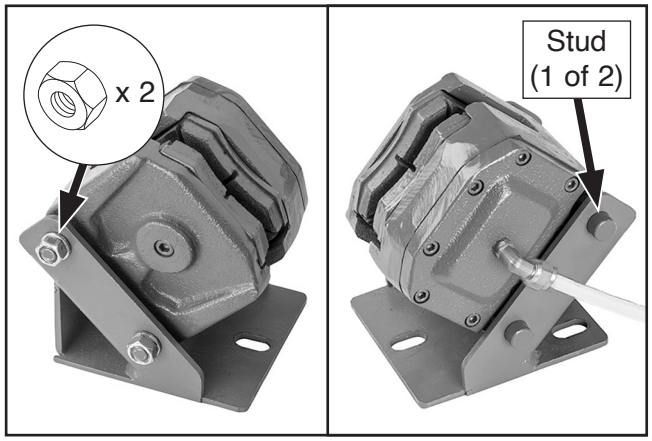


Figure 121. Location of Model G0411 caliper mounting studs and hex nuts.

8. Remove inner brake pad cap screw, then remove inner brake pad (see **Figure 122–Figure 123**).

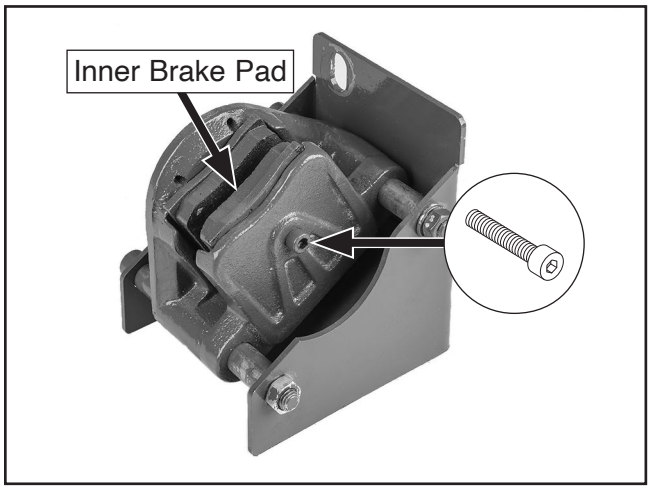


Figure 122. Location of Model G0408/G0409 inner brake pad and cap screw.

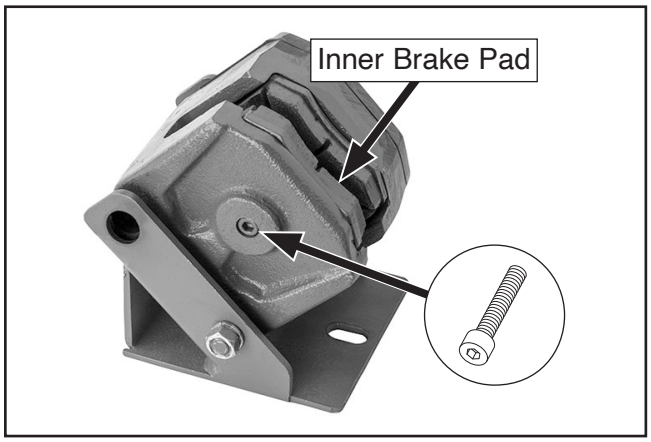


Figure 123. Location of Model G0411 inner brake pad and cap screw.

9. Remove flat head cap screw shown in **Figure 124—Figure 125** on **Page 73** to remove diaphragm plate, compression spring, bushing, and outer brake pad.

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

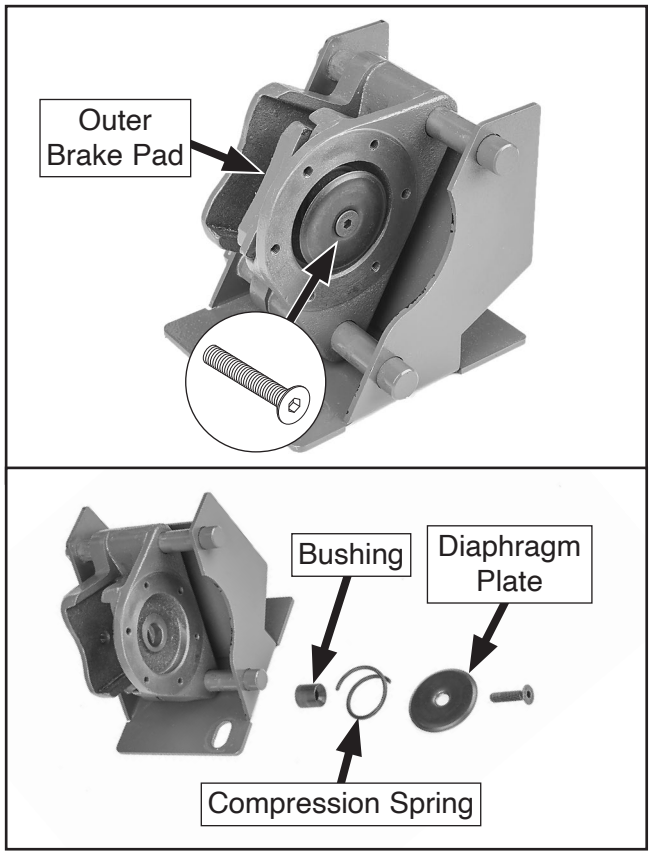


Figure 124. Model G0408/G0409 outer brake pad components.

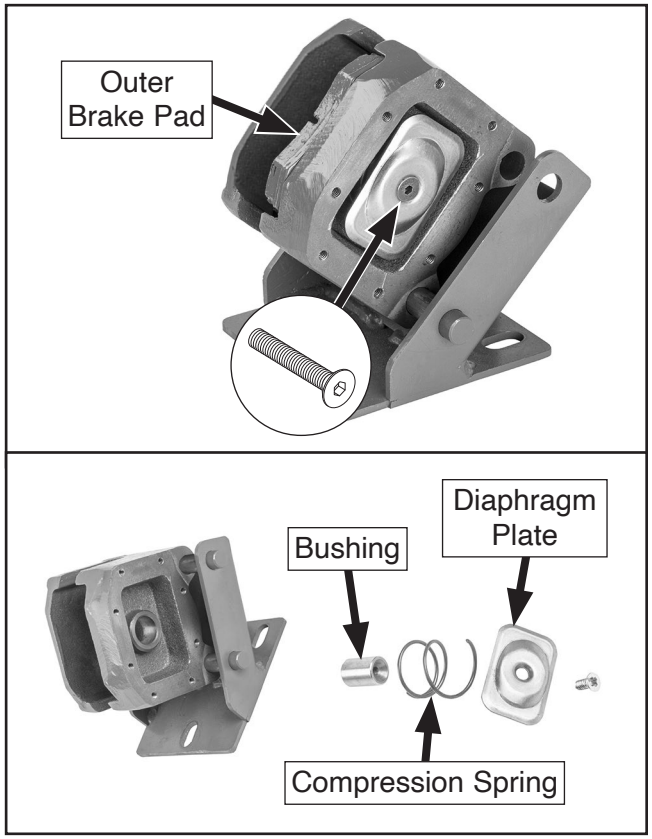


Figure 125. Model G0411 outer brake pad components.

10. 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.

Note: *Countersunk end of bushing should face diaphragm plate.*

11. Install new inner brake pad and secure with cap screw removed in **Step 8**.

12. Install diaphragm, diaphragm cover, and screws removed in **Step 7**.

13. **Model G0411 Only:** Install stud and hex nut removed in **Step 7**.

14. Place disc brake assembly so brake pads are around rotor, then secure with fasteners removed in **Step 5**.

15. Install right access panel and secure with screws removed in **Step 3**.

16. Connect machine to air and power, then start sander and test EMERGENCY STOP system to make sure brake functions properly.

Checking/Adjusting Table Parallelism

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 time and 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 126**).

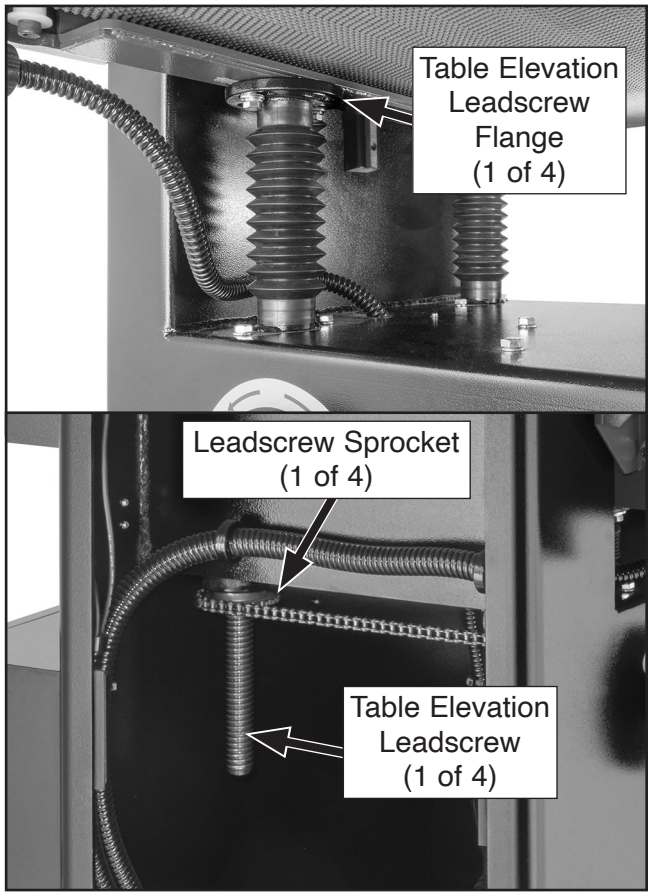


Figure 126. Location of table elevation adjustment components.

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 127**). Do not allow table to squeeze or compress wood block.

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

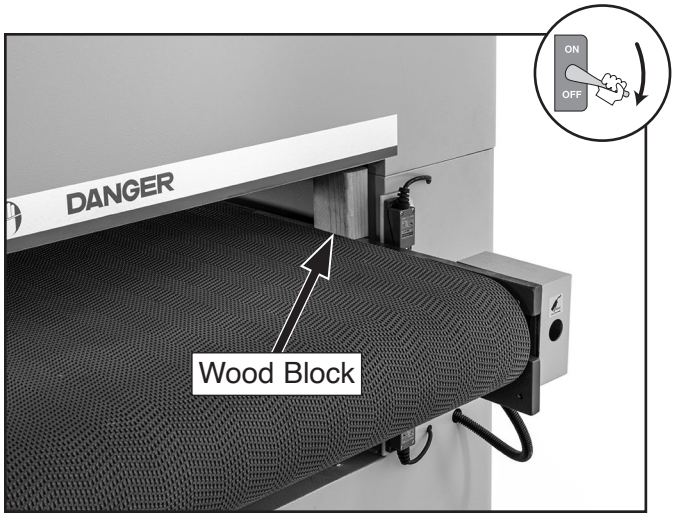


Figure 127. Wood block placed for checking table parallelism (example shown).

6. Take precise measurements between edge of conveyor table and upper frame at each of the remaining (3) corners (see **Figure 128**).

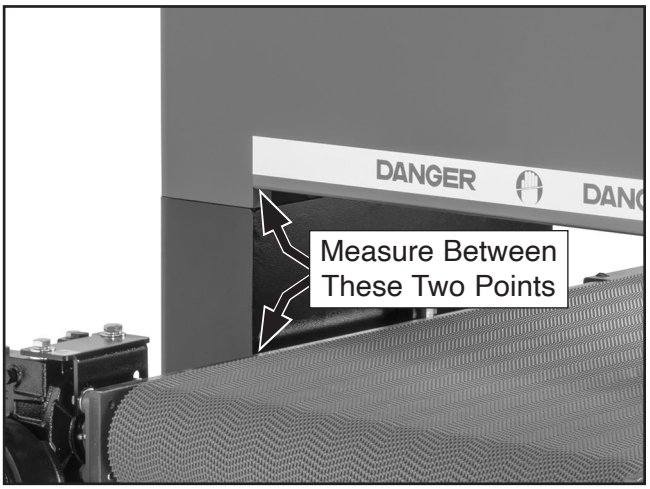


Figure 128. Distance to measure at rear right corner.

Note: *When measuring at front right and left corners, measure from upper frame; DO NOT measure from safety plate (see **Figure 129**).*

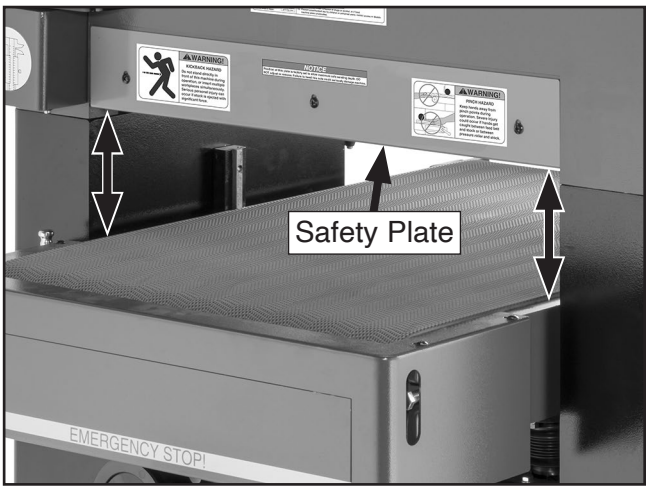


Figure 129. Distance to measure at front right and front left corners (G0408 shown).

— 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**.

Adjusting Table Parallelism

1. Check table parallelism (refer to **Checking Table Parallelism** on **Page 74**) 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 130**) at corner that needs to be adjusted.

4. Loosen (2) hex bolts on flange (see **Figure 130**). 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.*

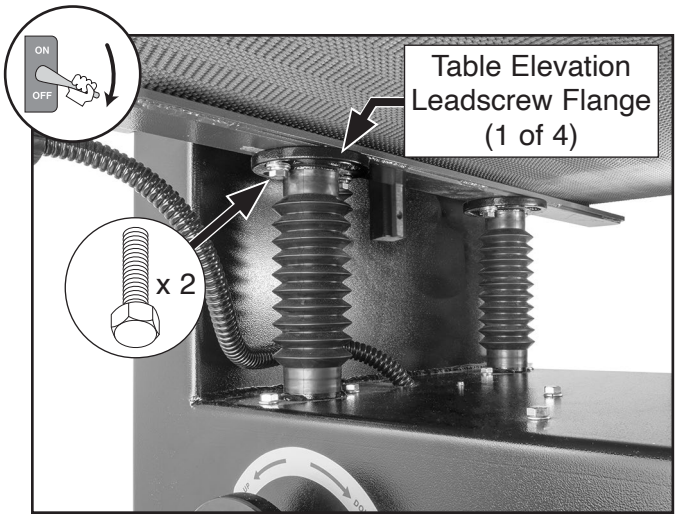


Figure 130. Table flange components (G0408 shown).

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 131** to remove left and right access panels.

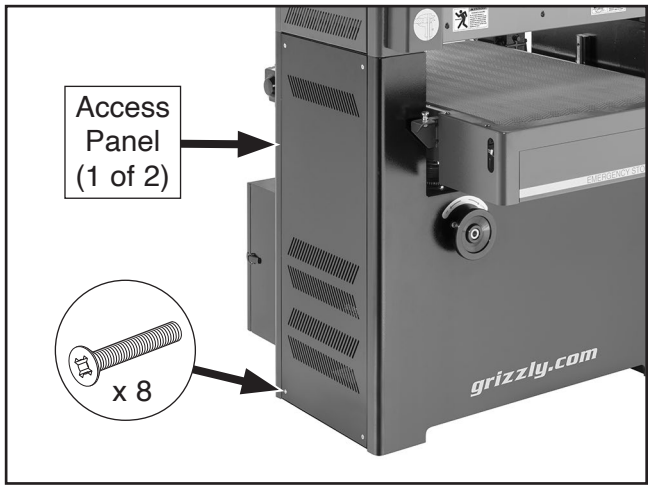


Figure 131. Location of access panels and securing screws (G0408 shown).

8. Mark one tooth of table elevation leadscrew sprocket (see **Figure 132**) that you need to adjust, and its location on frame.

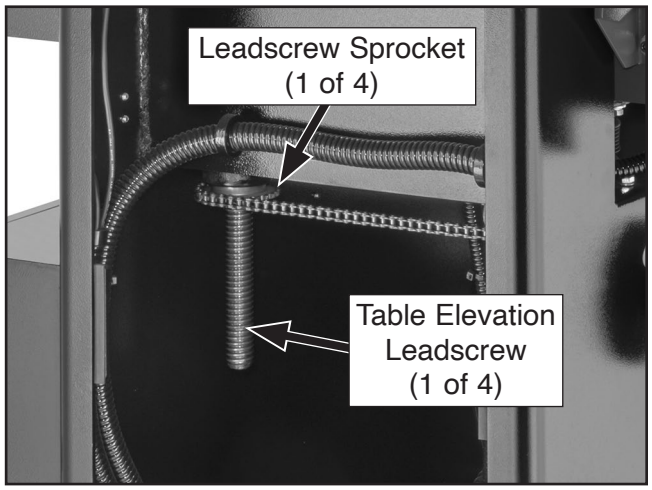


Figure 132. Location of table elevation leadscrew sprockets (G0408 shown).

9. On table elevation chain tensioner, loosen sprocket nut on sprocket wheel shaft, and jam nut (see **Figure 133**).

10. Push sprocket adjustment rod (see **Figure 133**) away from table elevation motor to loosen chain tension.

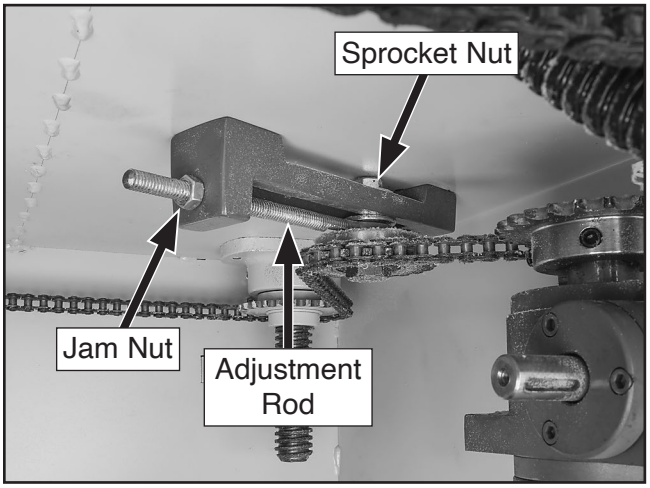


Figure 133. Table elevation chain tensioner components (example shown).

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 74**). 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 (4' Long)	1
Open-End Wrenches	
—G0408: 14mm	2
—G0409/G0411: 12mm	2

To adjust pressure rollers:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (4) screws shown in **Figure 134** to remove right access panel.

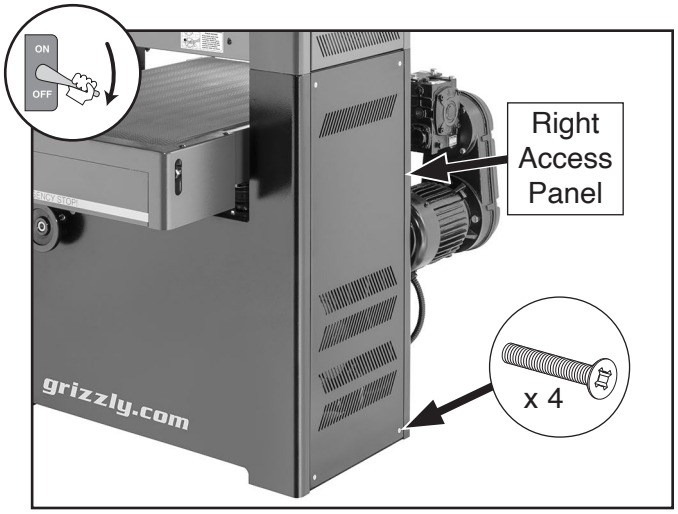


Figure 134. Location of right access panel and screws (G0408 shown).

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 54**).

6. Plane 4' long 2x4 to uniform thickness and cut it in half to make (2) 2' 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 135**.



Figure 135. 2x4s placed on conveyor belt under sanding drum (example shown).

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. **Model G0408:** Loosen (2) jam nuts on infeed pressure rollers, rotate adjustment (2) nuts (see **Figure 136**) to adjust infeed pressure rollers until they just touch boards, then tighten jam nuts to secure.

    — Rotate adjustment nuts clockwise (from above) to raise pressure rollers.

    — Rotate adjustment nuts counterclockwise (from above) to lower pressure rollers.

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

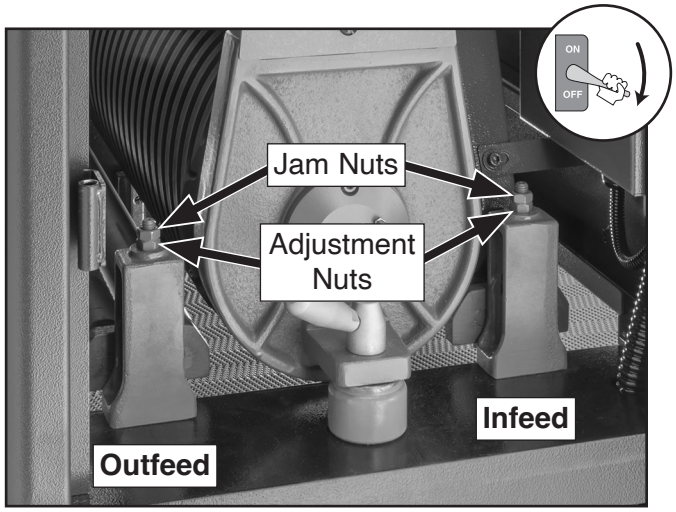


Figure 136. Location of Model G0408 pressure roller adjustment components (left side).

Model G0409/G0411: Loosen (2) jam nuts on infeed pressure roller, rotate (2) adjustment bolts (see **Figure 137**) to adjust infeed pressure rollers until they just touch boards, then tighten jam nuts to secure.

— Rotate adjustment bolts clockwise (from above) to raise pressure rollers.

— Rotate adjustment bolts counterclockwise (from above) to lower pressure rollers.

Note: *DO NOT lower pressure roller beyond this point.*

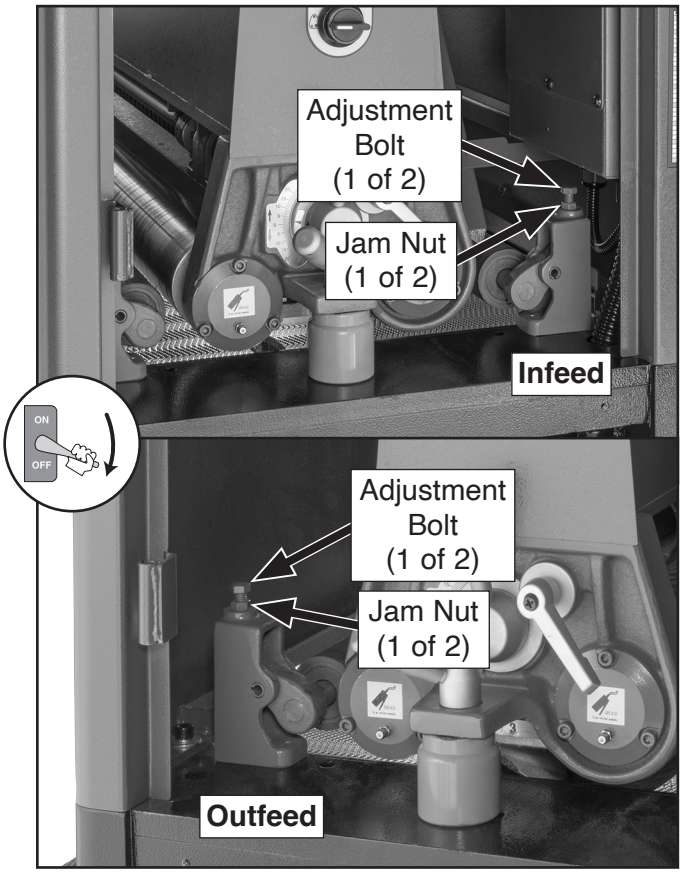


Figure 137. Location of Model G0409/G0411 pressure roller adjustment components (left side).

12. Repeat **Step 11** for outfeed pressure roller(s) (see **Figure 136**–**Figure 137**).

    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. Lower table and remove 2x4s.

14. Install V-belts and desired sanding belt.

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. 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 138**).

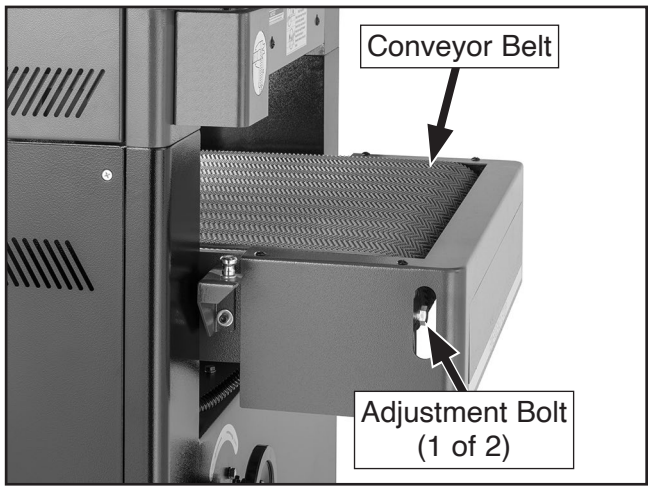


Figure 138. Location of conveyor belt adjustment bolts.

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 138**) 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 belt tension adjustment bolt (see **Figure 138**), depending on the needs of the adjustment.

Two guide wheels (see **Figure 139**) 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.

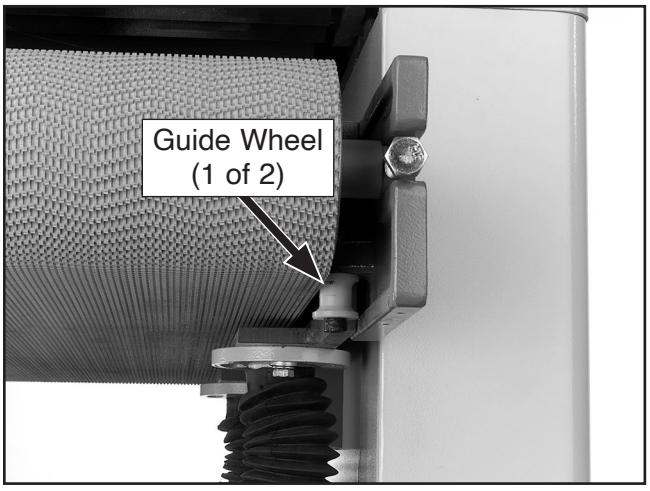


Figure 139. Location of conveyor belt guide wheels (safety guard removed for clarity).

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 140**) clockwise.

   — If conveyor belt is tracking *left*, rotate left adjustment bolt (see **Figure 140**) clockwise.

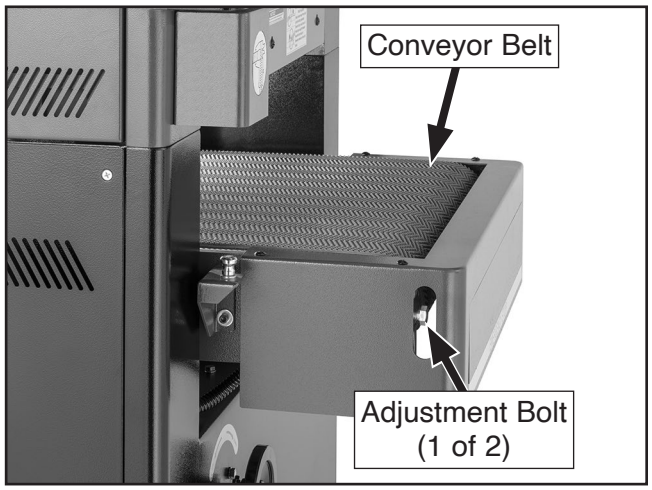


Figure 140. Location of conveyor belt adjustment bolts.

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 139*** *on* ***Page 79****.*

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 79**).

Note: *The diagram shown on* ***Page 83*** *illustrates the steps in the following procedure.*

Items Needed	**Qty**
Open-End Wrench 12mm	1
Additional Person	1
Wrenches or Sockets 10, 14, 17, 19mm	1 Ea.
Phillips Head Screwdriver #2	1
Hex Wrenches 5, 8mm	1 Ea.
Marker	1
2x4s (5' Long)	2
Cleaner/Degreaser	As Needed
Rags	As Needed
Replacement Conveyor Belt	
—G0408 (P04082102)	1
—G0409 (P04092102)	1
—G0411 (P04112102)	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 (2) hex bolts, (2) lock washers, (4) flat washers, and (2) vibration dampening washers securing motor and gearbox assembly to table, then have assistant help slide assembly from roller shaft and lower it to floor (see **Figure 141** on **Page 81**).

3. Remove (2) hex bolts, lock washers, and flat washers to remove gearbox mounting bracket (see **Figure 141** on **Page 81**).

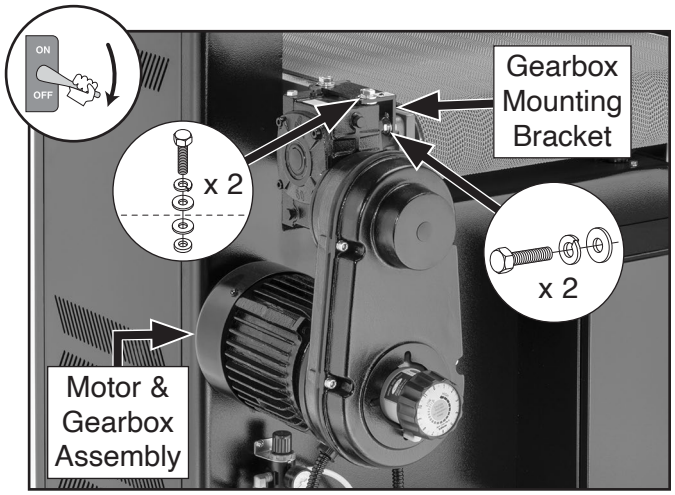


Figure 141. Motor and gearbox assembly components to remove (G0408 shown).

4. Remove (4) hex bolts, lock washers, and flat washers shown in **Figure 142** to remove table elevation limit switches.

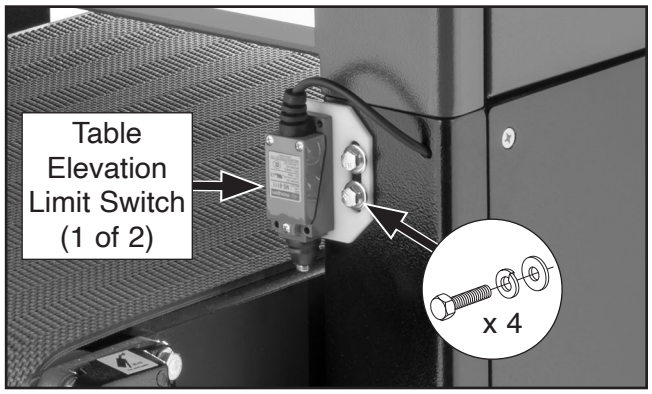


Figure 142. Location of table elevation limit switches and securing fasteners.

5. Remove (8) screws shown in **Figure 143** to remove access panels.

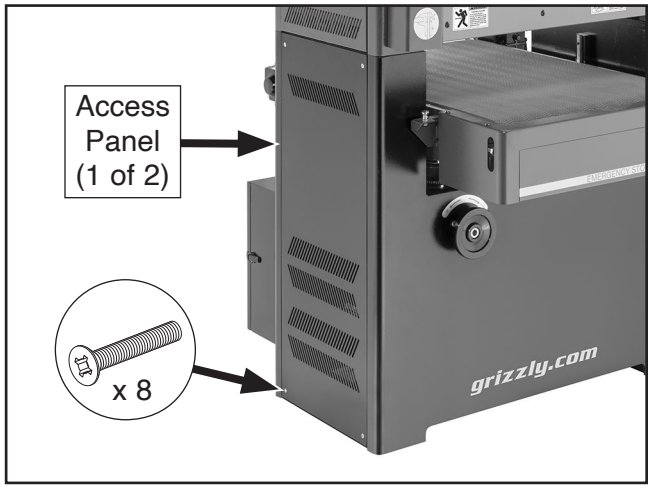


Figure 143. Location of access panels and securing screws (G0408 shown).

6. Remove (4) hex bolts and washers shown in **Figure 144** to remove left and right table guides (see **Figure 145**).

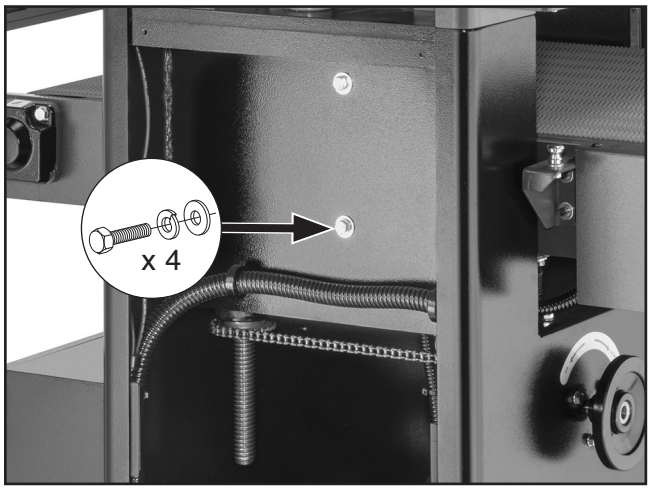


Figure 144. Location of table guide fasteners.

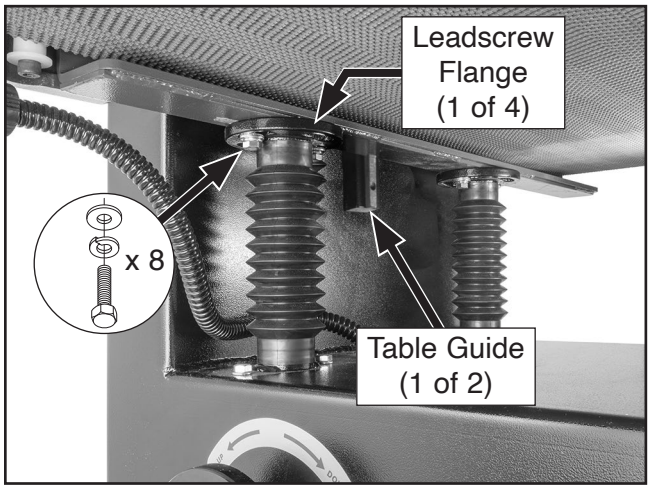


Figure 145. Location of table guides and leadscrew flanges (G0408 shown).

7. Mark all four leadscrew flange positions, then remove all hex bolts and washers from flanges (see **Figure 145**). Try not to turn flanges during following steps.

8. Remove (4) Phillips head screws shown in **Figure 146** to remove EMERGENCY STOP! bar assembly from front of conveyor table.

9. Remove (2) cap screws and washers shown in **Figure 146** to remove peg assembly.

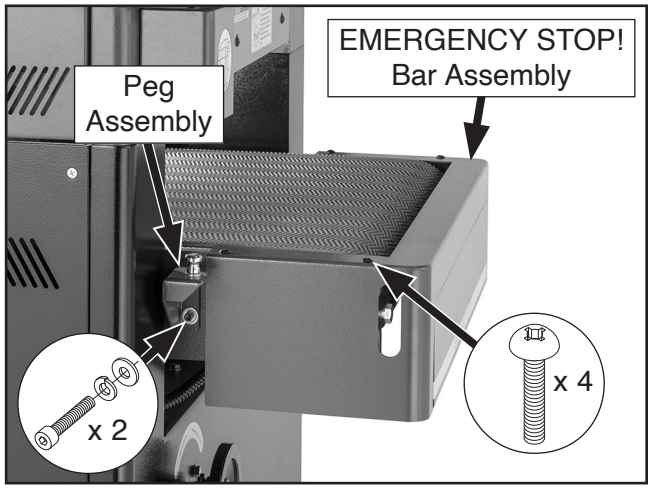


Figure 146. Peg and EMERGENCY STOP! bar assembly components.

10. Remove (2) Phillips head screws shown in **Figure 147** to remove EMERGENCY STOP! limit switch from front of conveyor table.

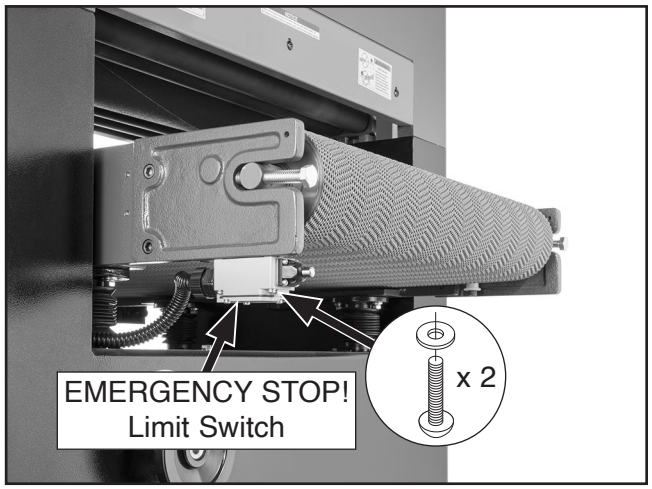


Figure 147. Location of EMERGENCY STOP! limit switch (G0408 shown).

11. Place (2) 5' long 2x4s under table for support, then have assistant help lift table slightly and move it out of rear of machine.

12. Turn both conveyor belt adjustment bolts counterclockwise five turns, remove one roller support, and slide front conveyor roller out of table assembly (see **Figure 148**).

13. Remove old conveyor belt (see **Figure 148**), clean rollers, and inspect rollers, bearings, and table for wear and replace as required.

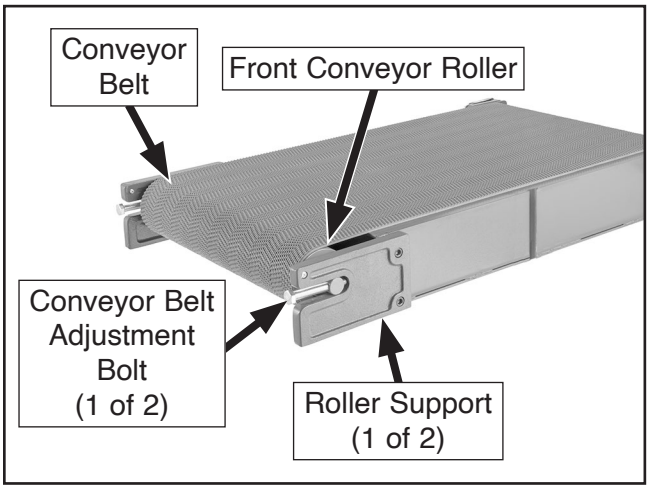


Figure 148. Location of conveyor belt components (G0408 shown).

14. Install new conveyor belt.

15. Install front conveyor roller and roller support, then turn both conveyor belt adjustment bolts clockwise equally so conveyor belt becomes taught and does not hang loose. DO NOT OVERTIGHTEN belt tension.

16. With lifting assistant, install table from rear, then remove 2x4s.

17. Install table guides and access panels.

18. Align leadscrew flanges with marks made in **Step 7**, then install hex bolts and washers.

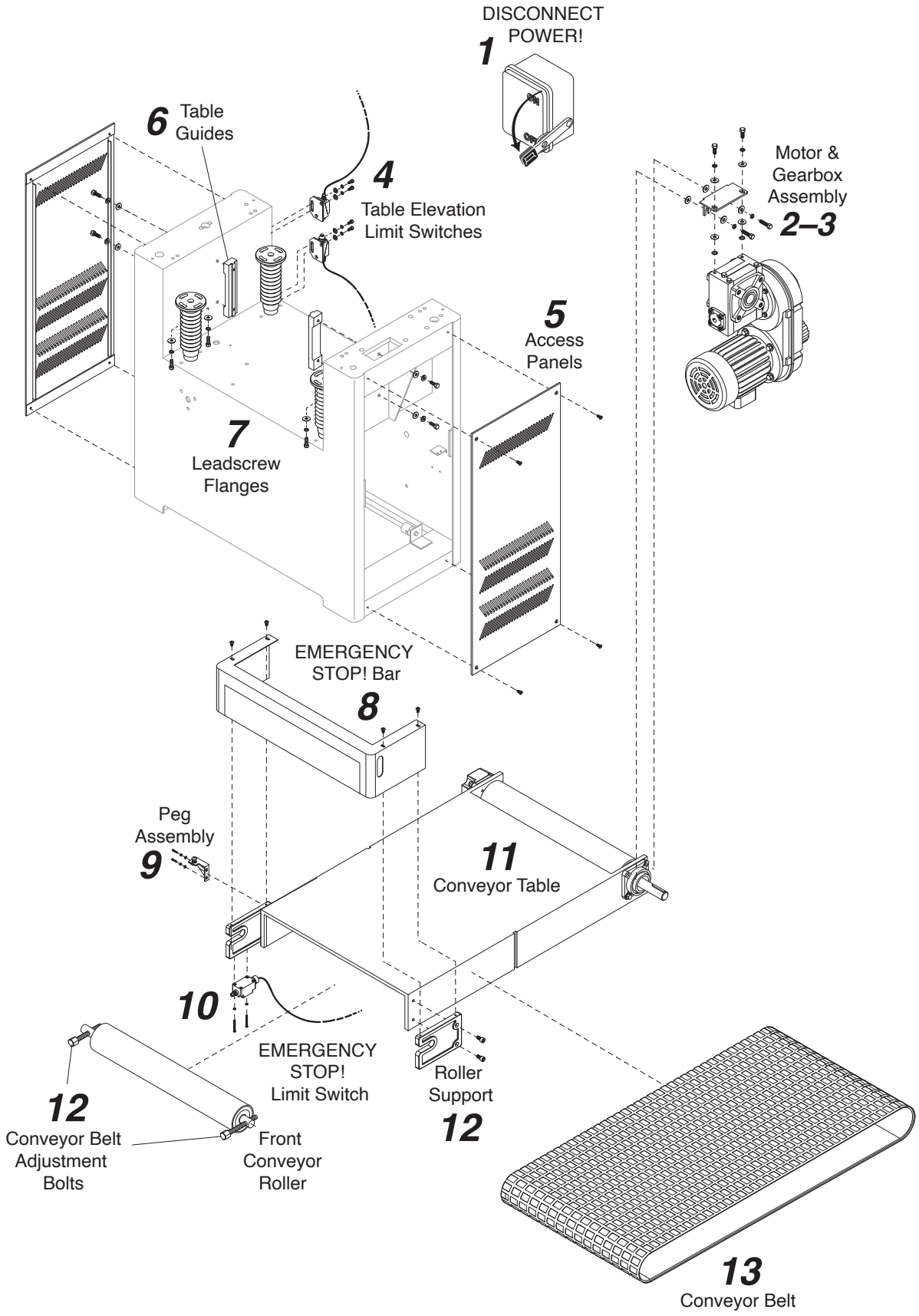
19. Install table elevation limit switches so upper switch clicks when conveyor surface is ⅛" away from sandpaper, and lower switch clicks when conveyor table is ⅛" higher than its lowest position. Make sure to test settings with handwheel manually so table does not crash if incorrectly set at first use.

20. With assistant, install feed motor assembly.

21. Install and calibrate workpiece thickness sensor peg assembly (see **Calibrating Workpiece Thickness Sensor** on **Page 63**), EMERGENCY STOP! limit switch, and EMERGENCY STOP! bar assembly.

22. Connect machine to power, and refer to **Adjusting Conveyor Belt Tracking** on **Page 79** to adjust belt tracking.

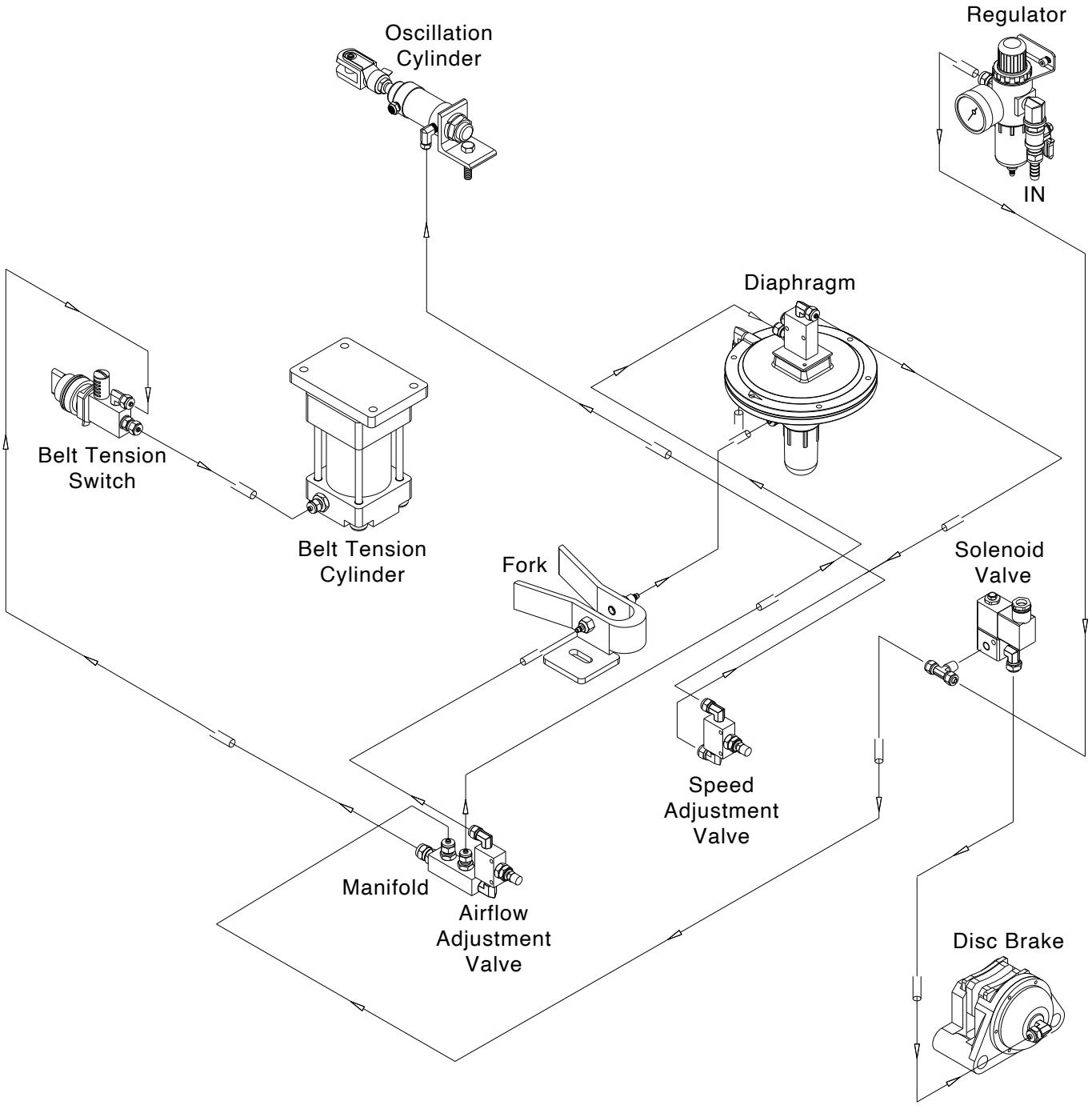
Conveyor Belt Removal Sequence



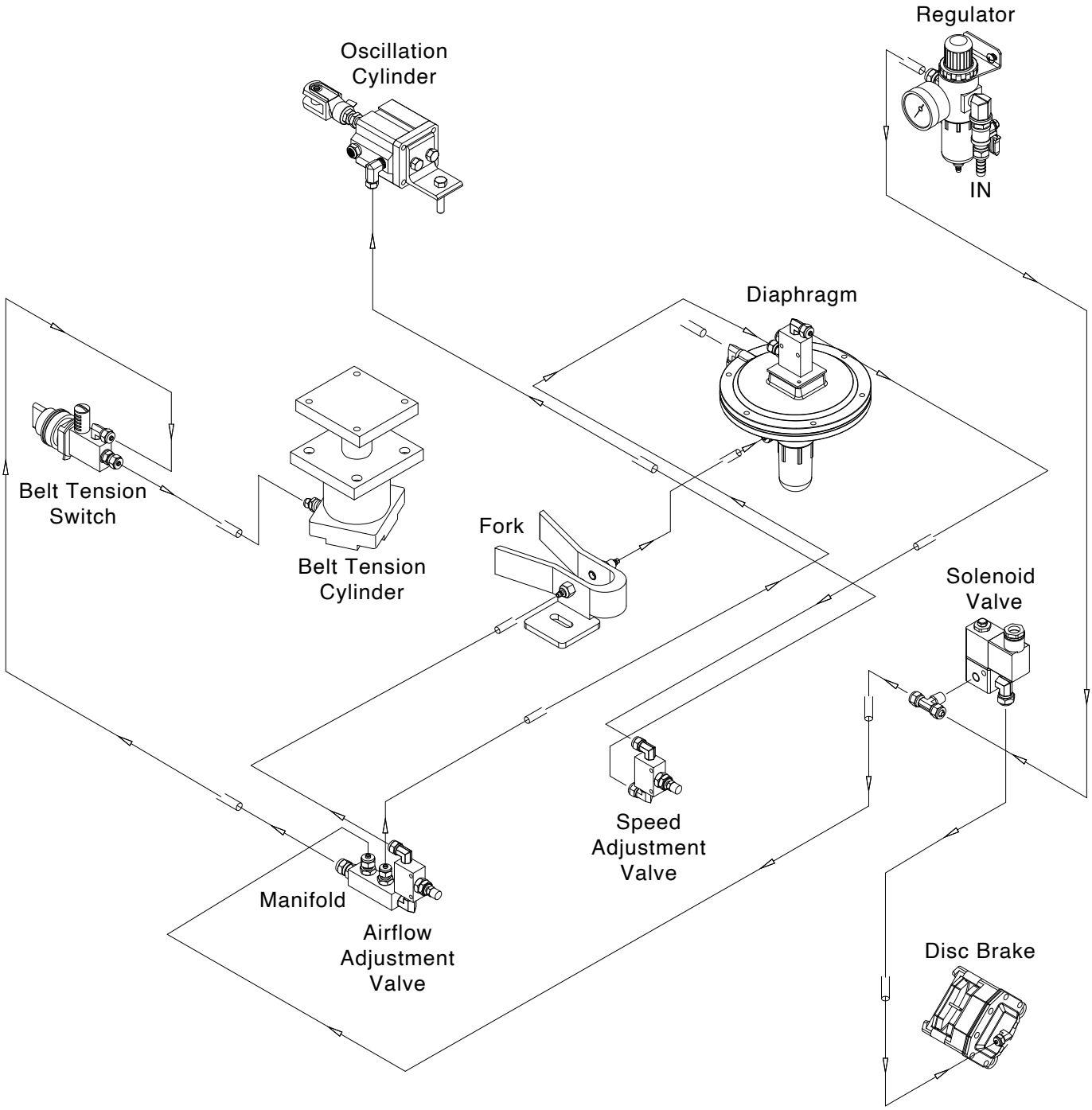
SECTION 7: PNEUMATIC SYSTEM

Before making any changes to the pneumatic system on your machine, refer to **Page 17** for safety information about compressed air to reduce your risk of injury.

G0408/G0409 Pneumatic Diagram



G0411 Pneumatic Diagram



Pneumatic System Component Photos

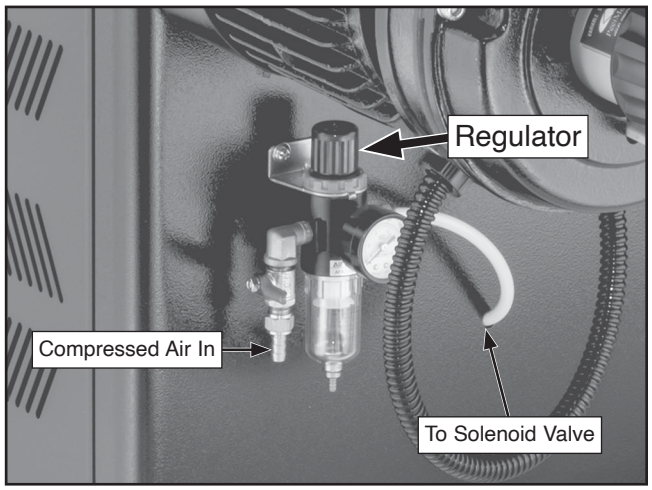


Figure 149. Regulator.

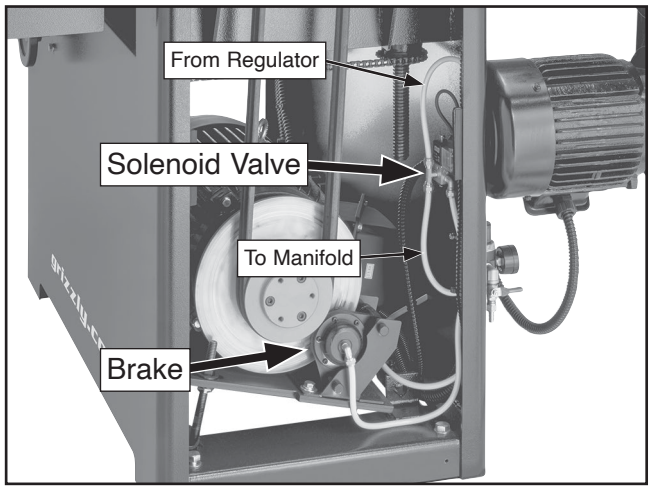


Figure 150. Model G0408/G0409 brake and solenoid valve.

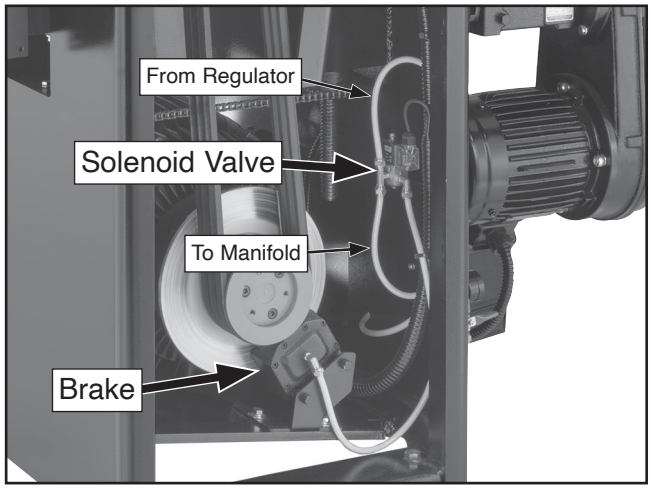


Figure 151. Model G0411 brake and solenoid valve.

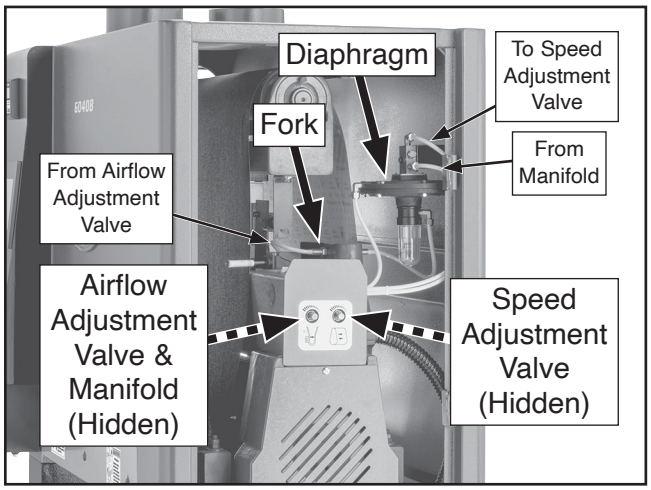


Figure 152. Manifold, diaphragm, and fork (G0408 shown).

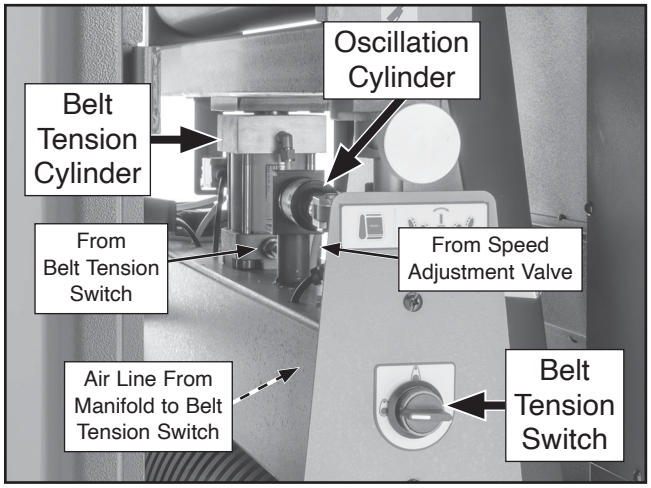


Figure 153. Model G0408/G0409 belt tension switch and cylinders.

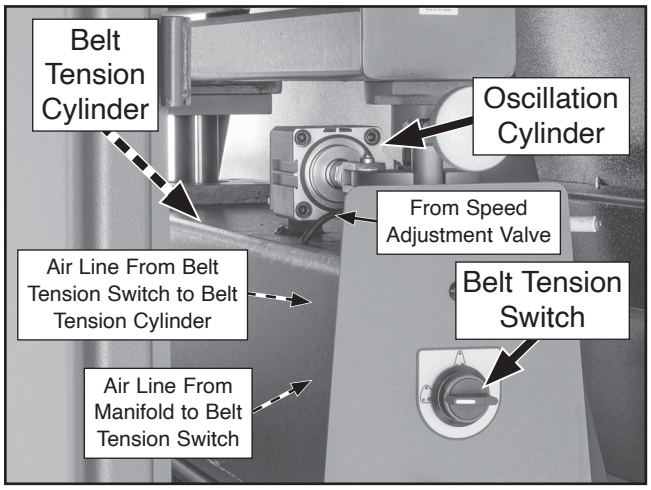


Figure 154. Model G0411 belt tension switch and cylinders.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

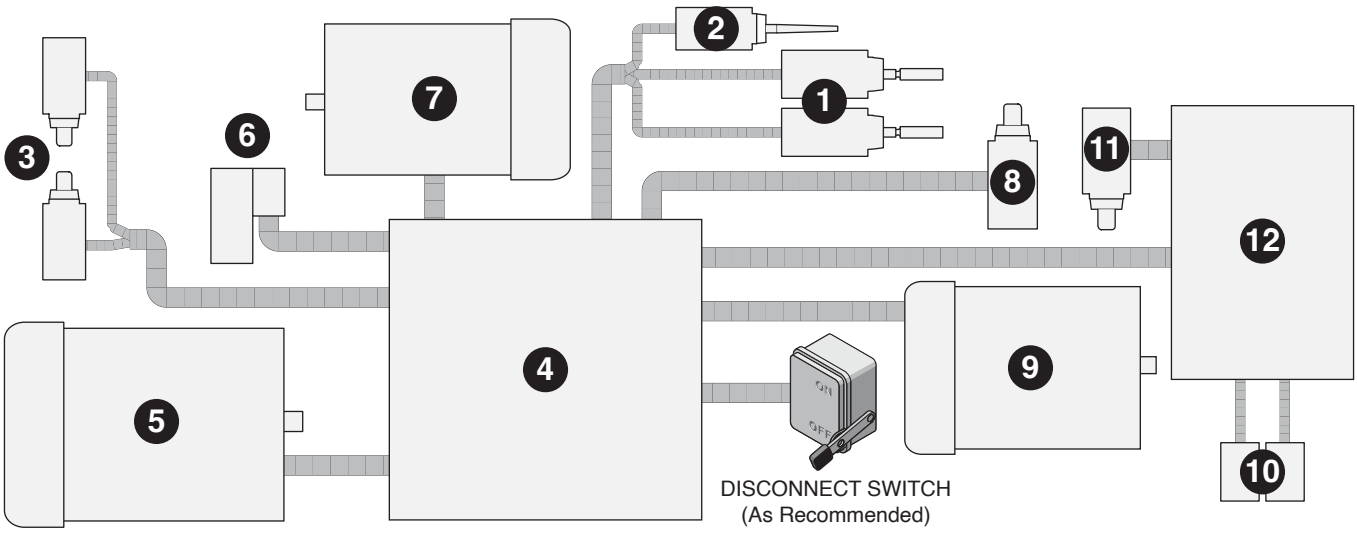
COLOR KEY

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

G0408/G0409 Wiring Overview



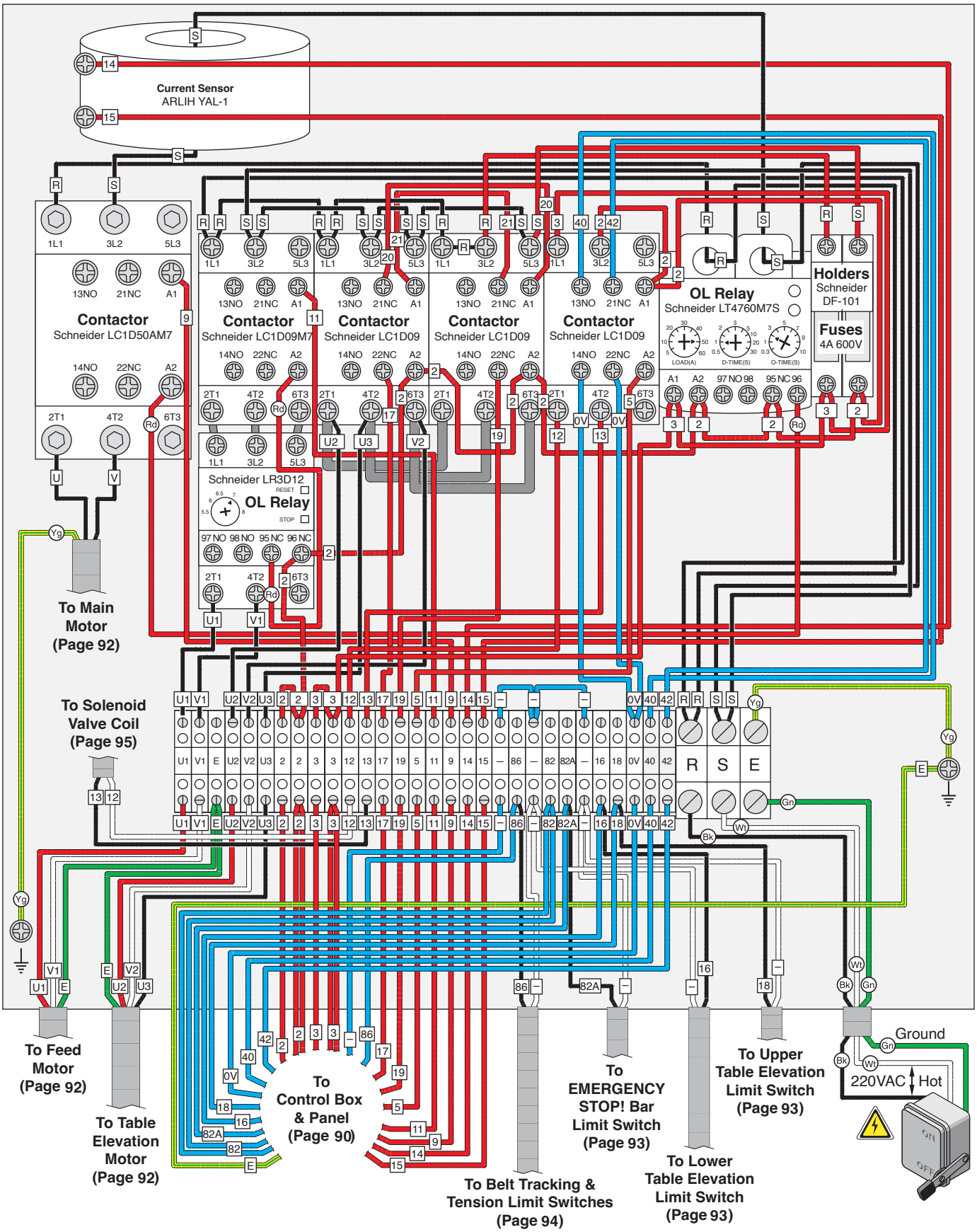
1	Belt Tracking Limit Switches (**Page 94**)	7	Feed Motor (**Page 92**)
2	Belt Tension Limit Switch (**Page 93**)	8	EMERGENCY STOP! Limit Switch (**Page 93**)
3	Table Elevation Limit Switches (**Page 93**)	9	Table Elevation Motor (**Page 92**)
4	Electrical Cabinet (**Page 89**)	10	Table Elevation Sensors (**Page 95**)
5	Main Motor (**Page 92**)	11	Workpiece Thickness Sensor (**Page 95**)
6	Solenoid Valve Coil (**Page 95**)	12	Control Box & Panel (**Page 90**)



READ WIRING SAFETY ON PAGE 87!

G0408/G0409 Electrical Cabinet Wiring

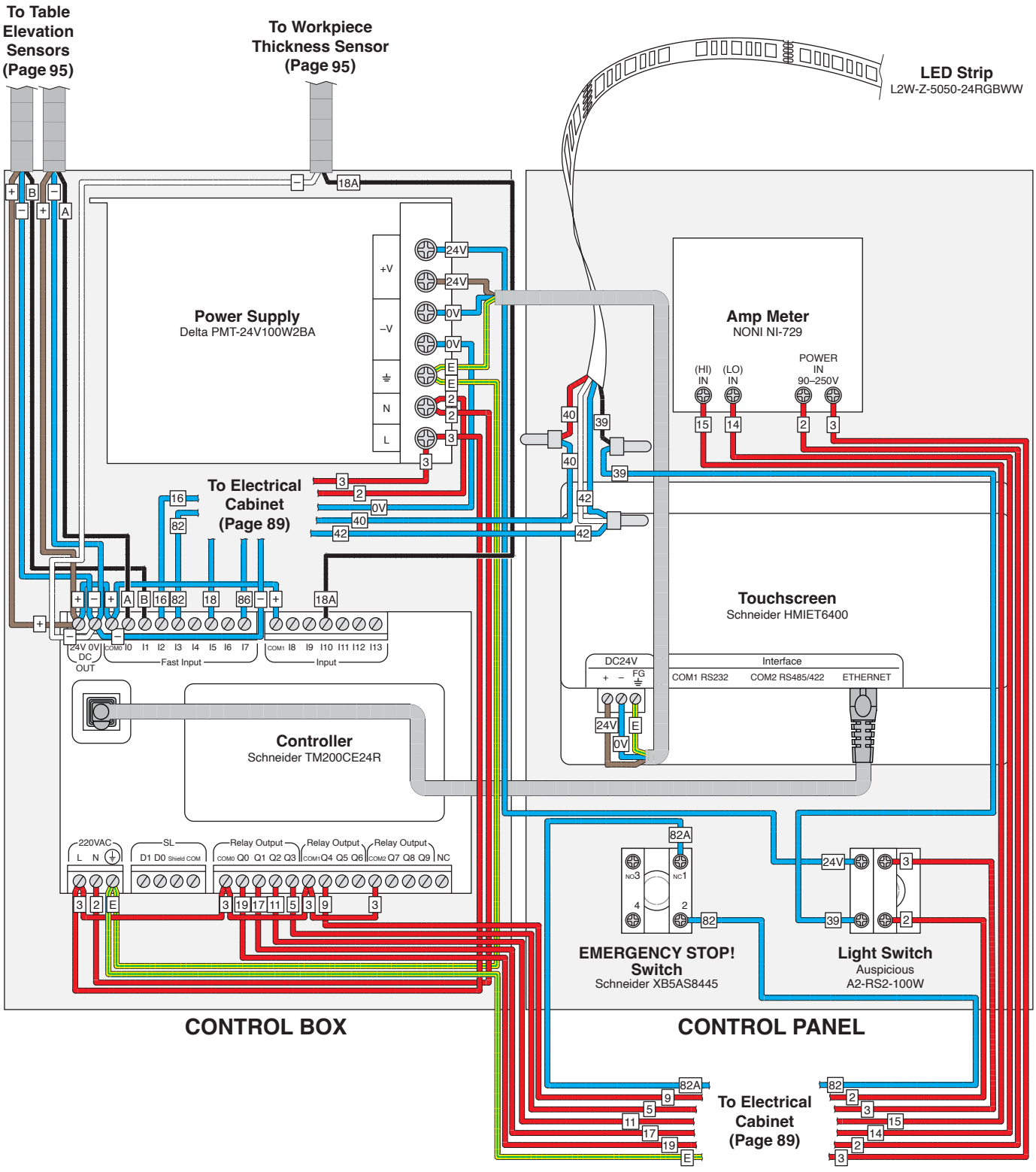
ELECTRICAL CABINET



STOP

READ WIRING SAFETY ON PAGE 87!

G0408/G0409 Control Box & Panel Wiring



READ WIRING SAFETY ON PAGE 87!

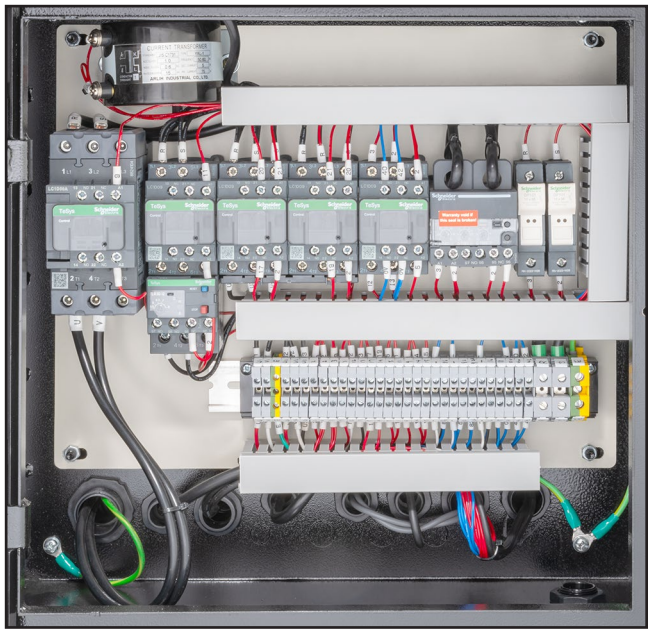


Figure 155. Model G0408/G0409 electrical cabinet wiring.

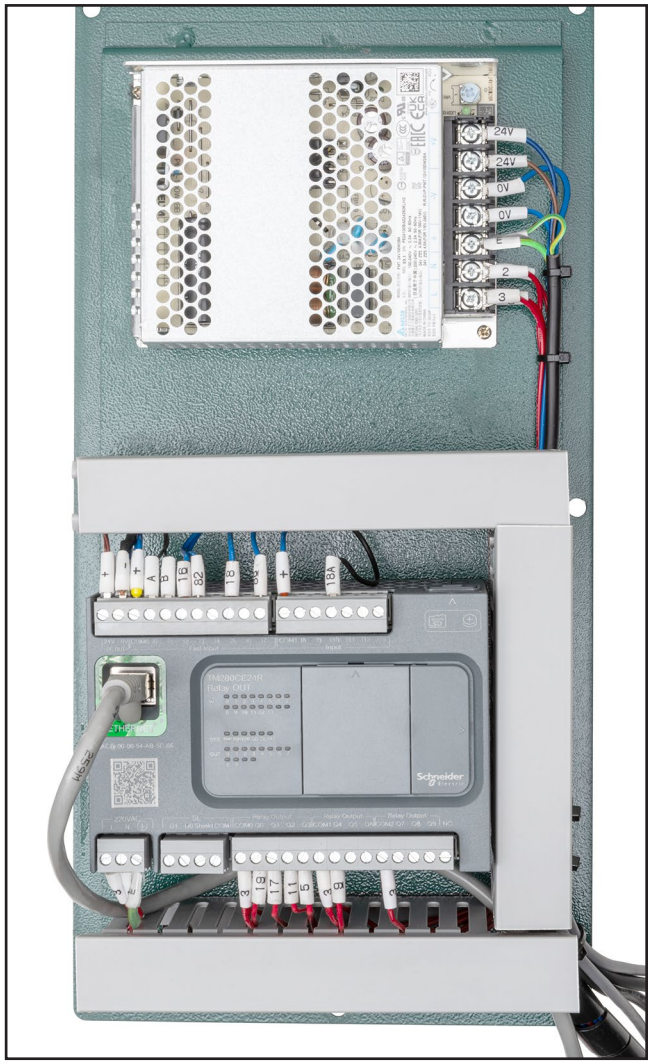


Figure 156. Model G0408/G0409 control box wiring.

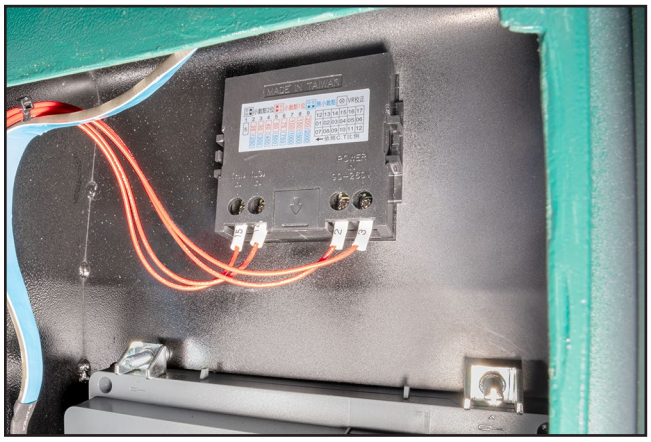


Figure 157. G0408/G0409 control panel upper wiring.

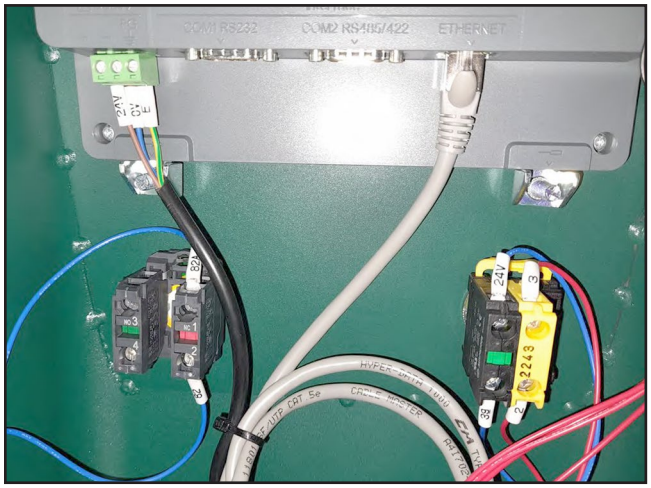
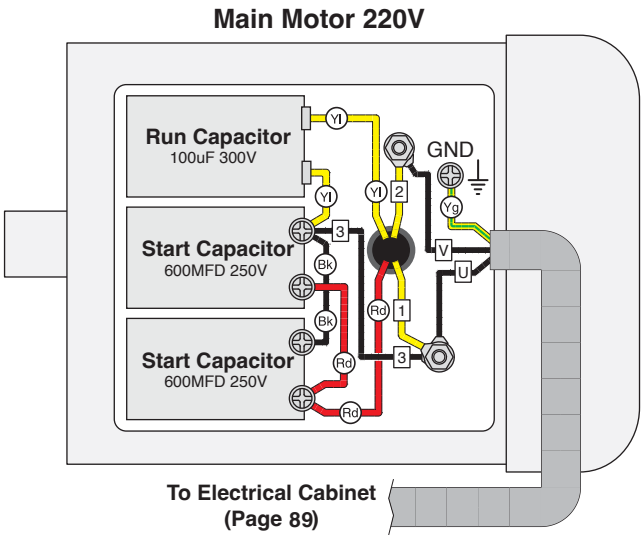


Figure 158. G0411 control panel touchscreen and switch wiring.

G0408/G0409 Motor Wiring



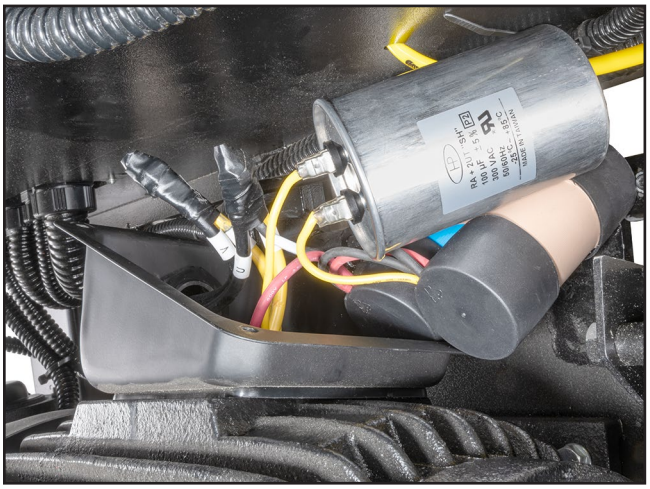
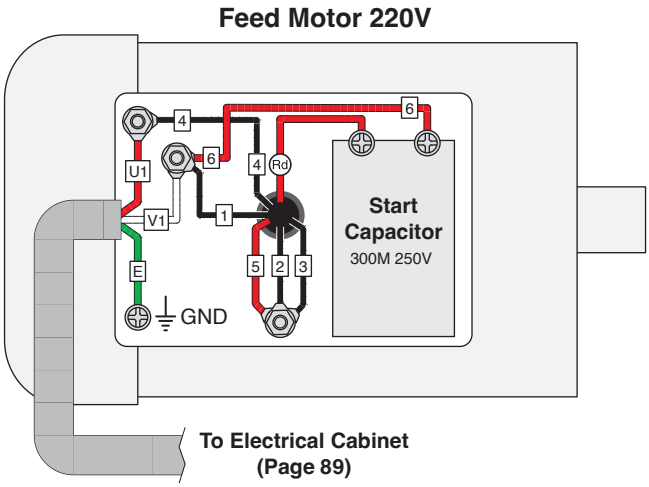


Figure 159. G0408/G0409 main motor junction box wiring.



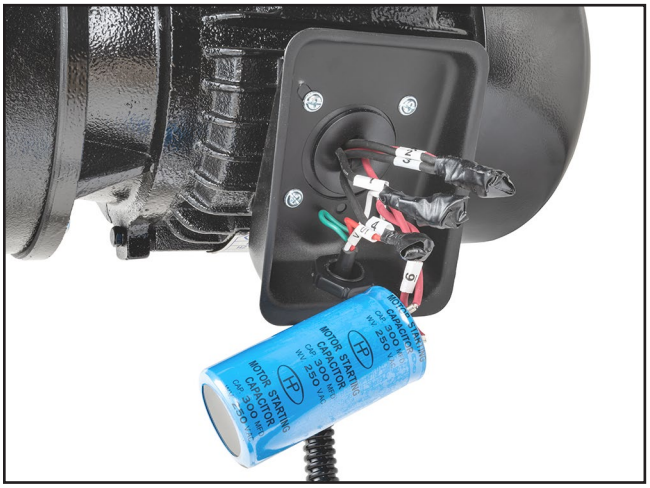


Figure 160. G0408/G0409 feed motor junction box wiring.

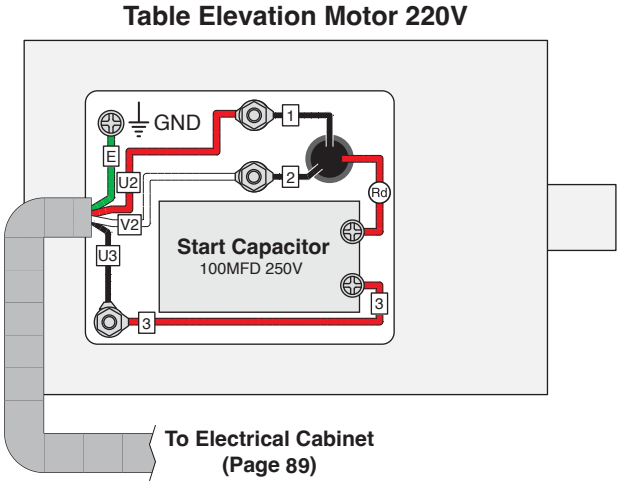
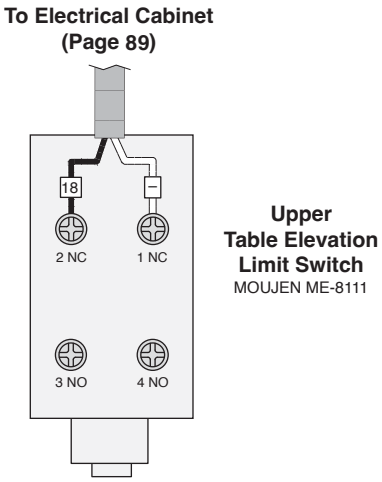




Figure 161. G0408/G0409 table elevation motor junction box wiring.

G0408/G0409 Limit Switch Wiring



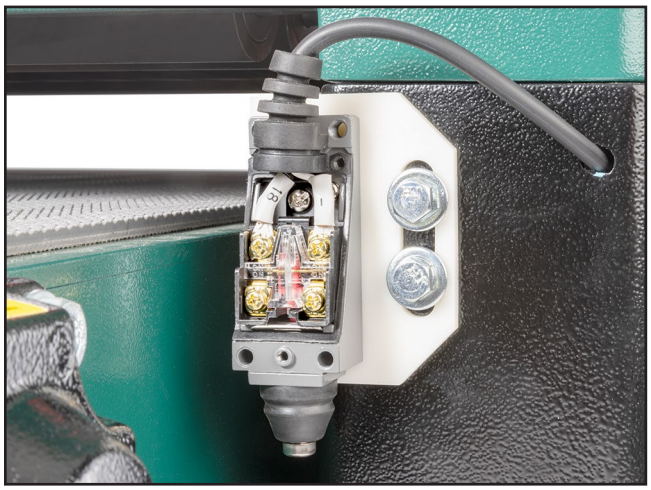
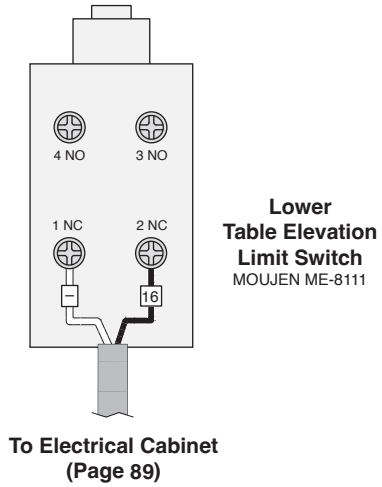


Figure 162. Upper table elevation limit switch wiring.



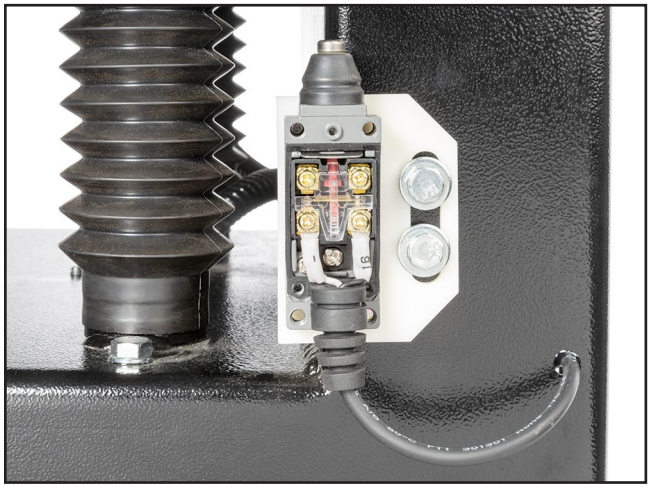
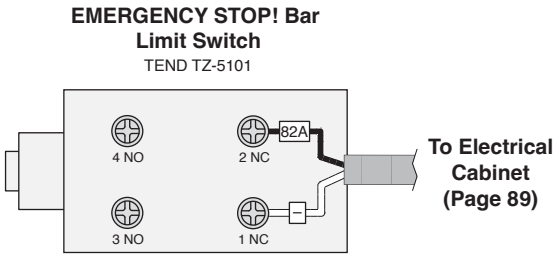


Figure 163. Lower table elevation limit switch wiring.



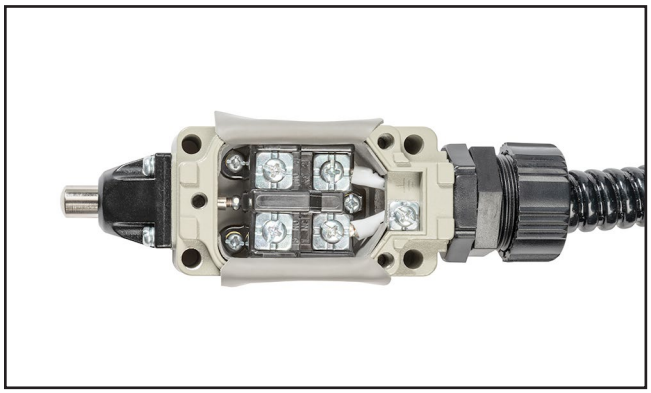
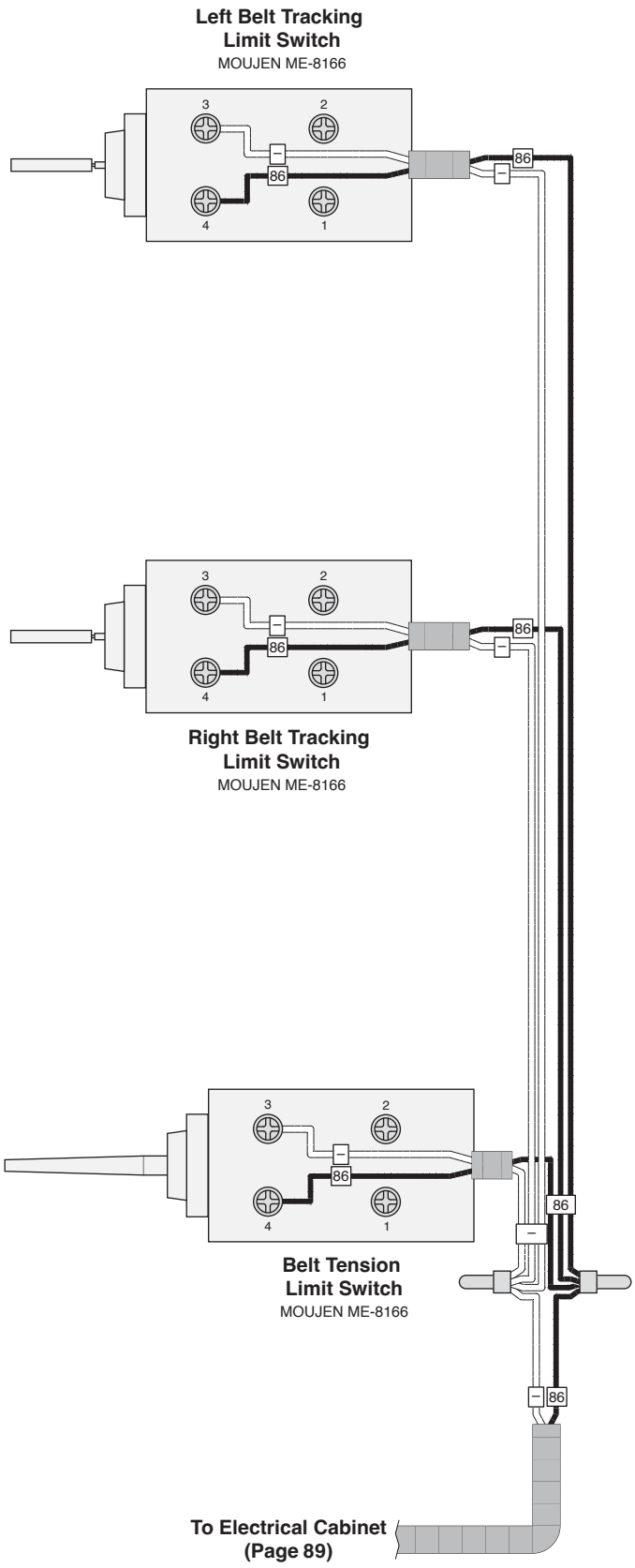


Figure 164. EMERGENCY STOP! bar limit switch wiring.



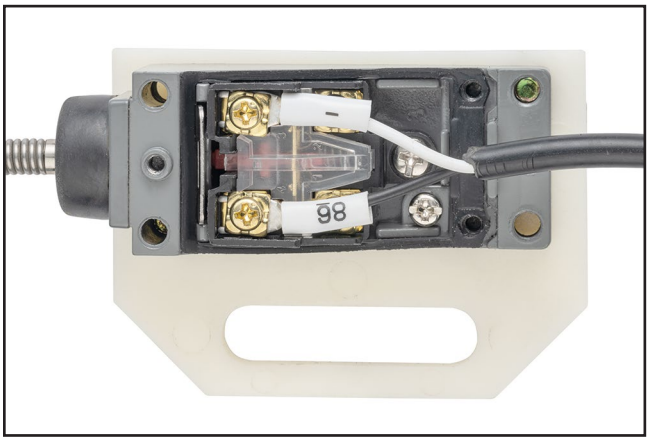


Figure 165. Left belt tracking limit switch wiring.

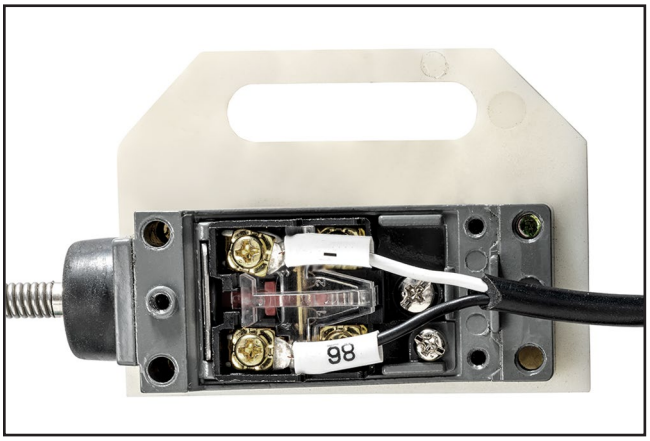


Figure 166. Right belt tracking limit switch wiring.

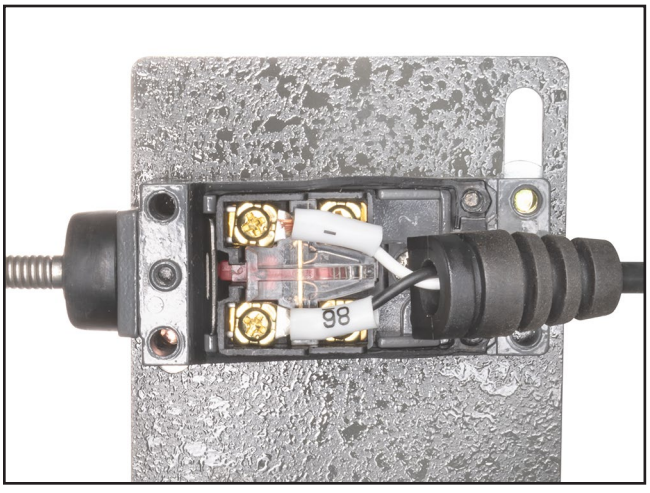
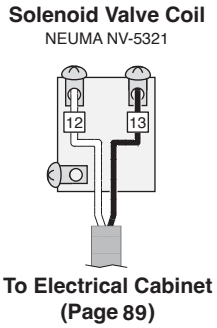


Figure 167. Belt tension limit switch wiring.

G0408/G0409 Solenoid Valve Coil Wiring



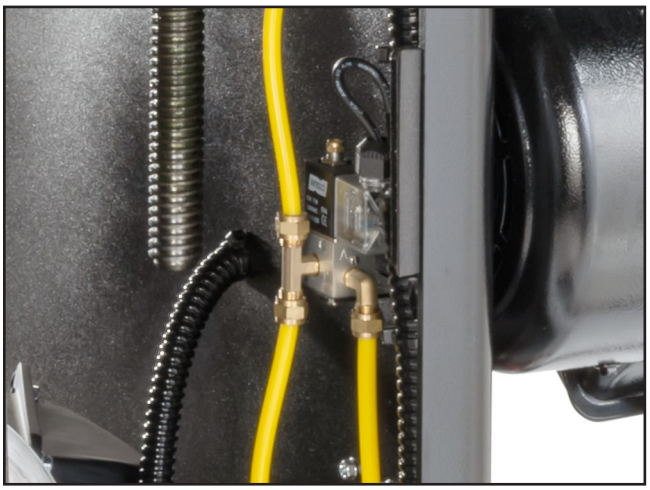
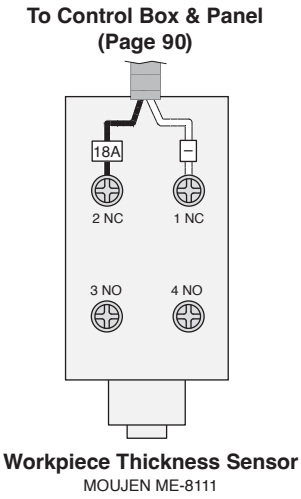


Figure 168. Solenoid valve coil.

G0408/G0409 Sensor Wiring



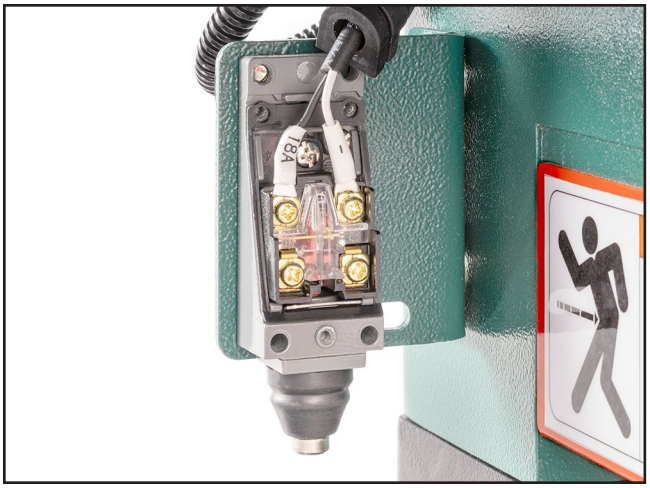
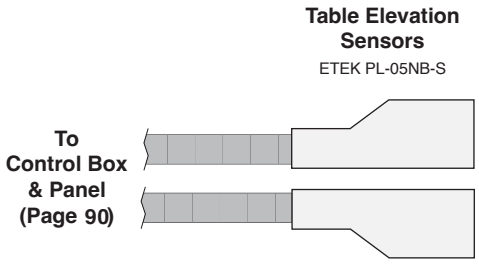


Figure 169. Workpiece thickness sensor wiring.



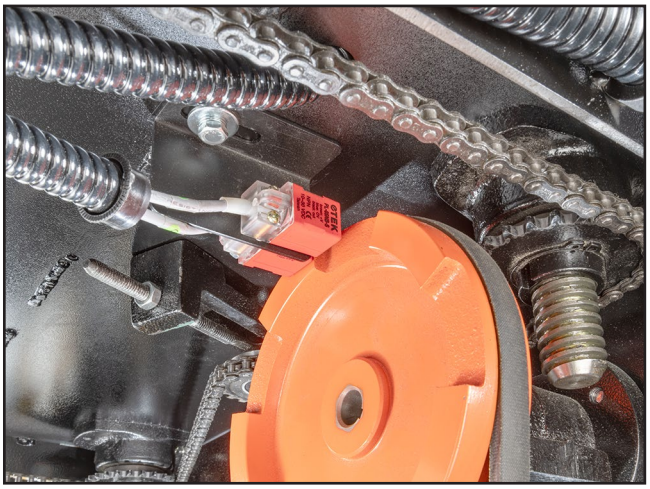
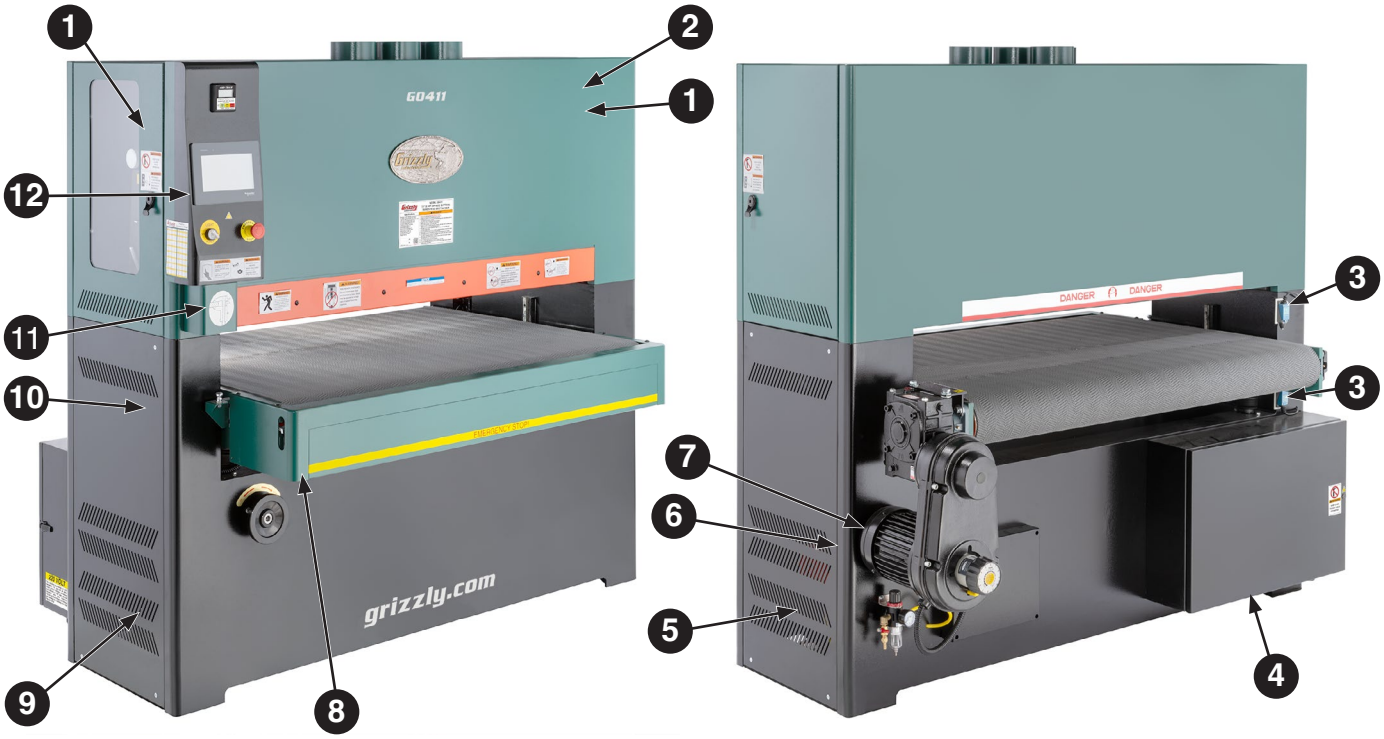
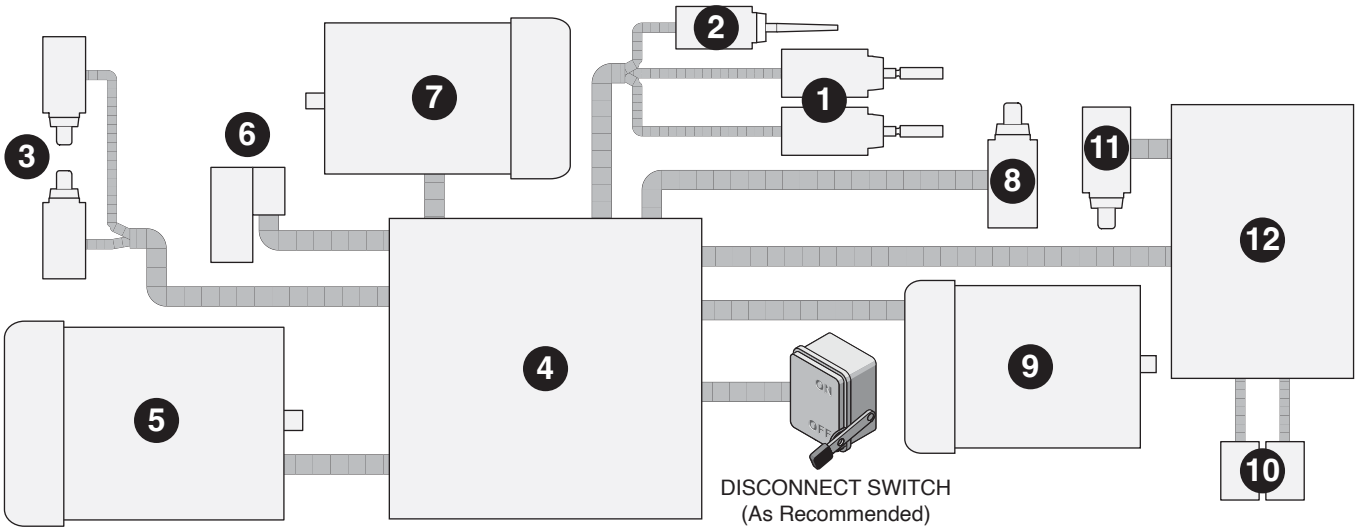


Figure 170. Table elevation sensors.

G0411 Wiring Overview



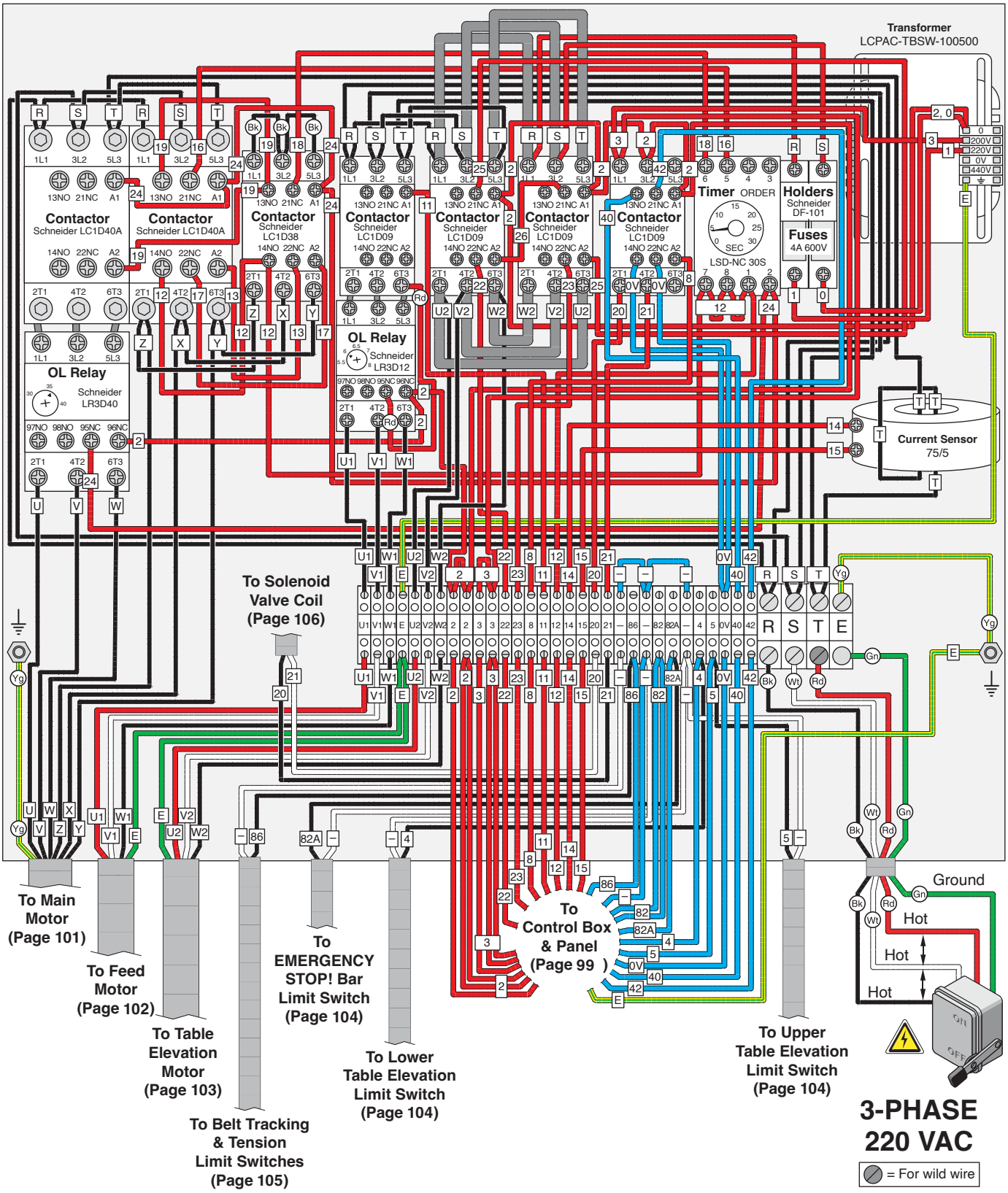
1	Belt Tracking Limit Switches (**Page 105**)	7	Feed Motor (**Page 102**)
2	Belt Tension Limit Switch (**Page 105**)	8	EMERGENCY STOP! Limit Switch (**Page 104**)
3	Table Elevation Limit Switches (**Page 104**)	9	Table Elevation Motor (**Page 103**)
4	Electrical Cabinet (**Page 97, 98**)	10	Table Elevation Sensors (**Page 106**)
5	Main Motor (**Page 101**)	11	Workpiece Thickness Sensor (**Page 106**)
6	Solenoid Valve Coil (**Page 106**)	12	Control Box & Panel (**Page 99**)



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G0411 Electrical Cabinet Wiring (220V)

ELECTRICAL CABINET

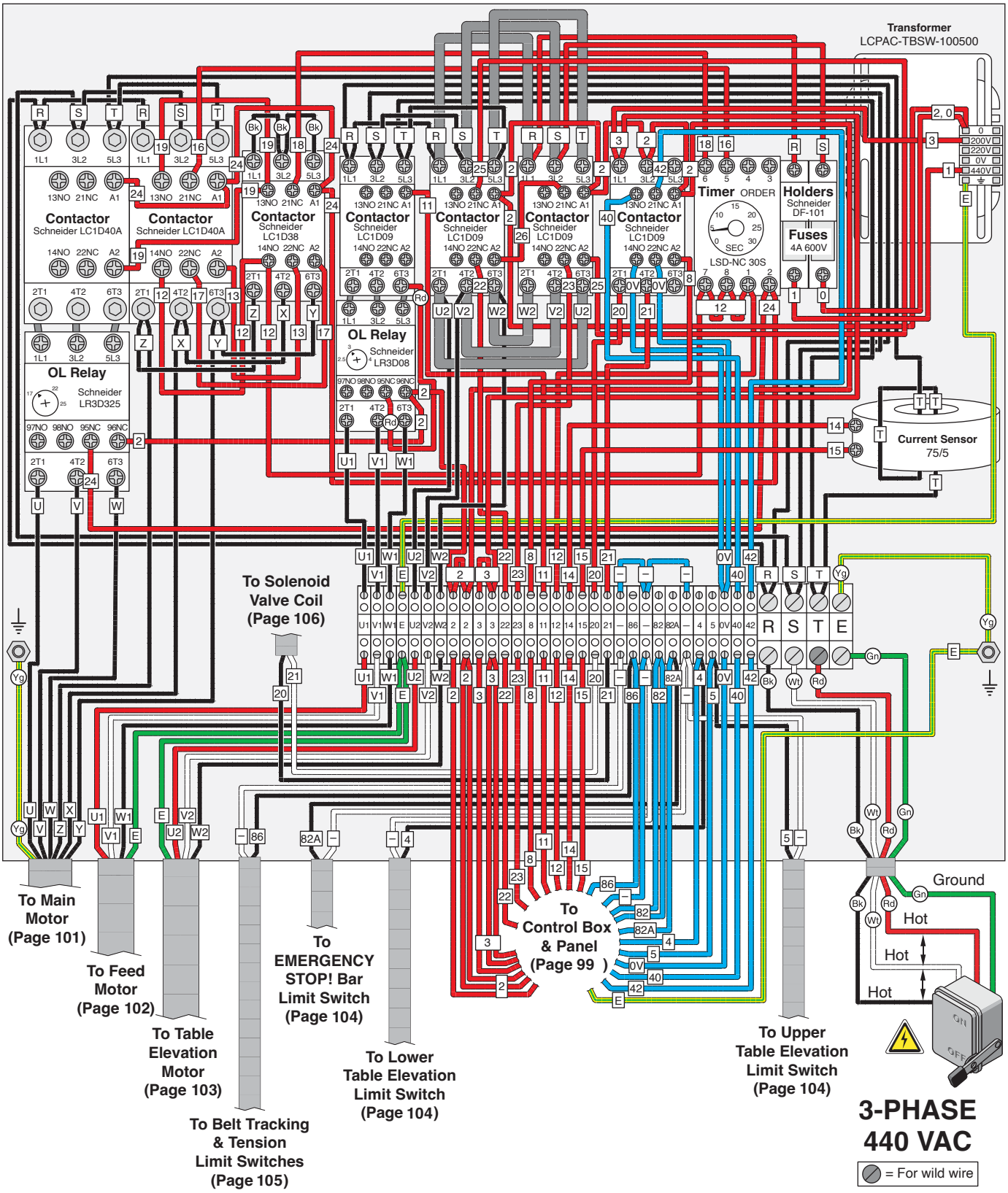


STOP

READ WIRING SAFETY ON PAGE 87!

G0411 Electrical Cabinet Wiring (440V)

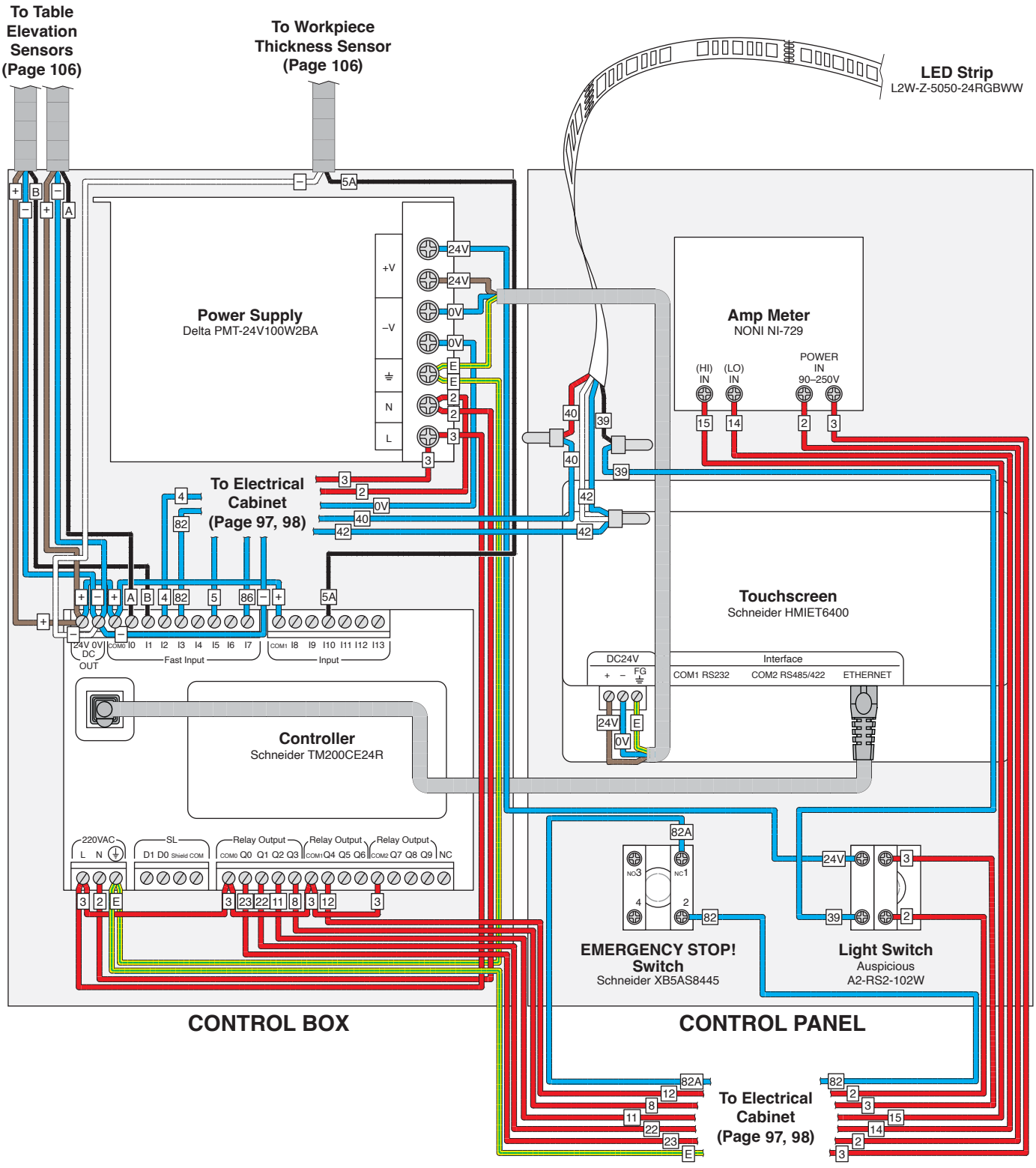
ELECTRICAL CABINET



STOP

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G0411 Control Box & Panel Wiring



READ WIRING SAFETY ON PAGE 87!

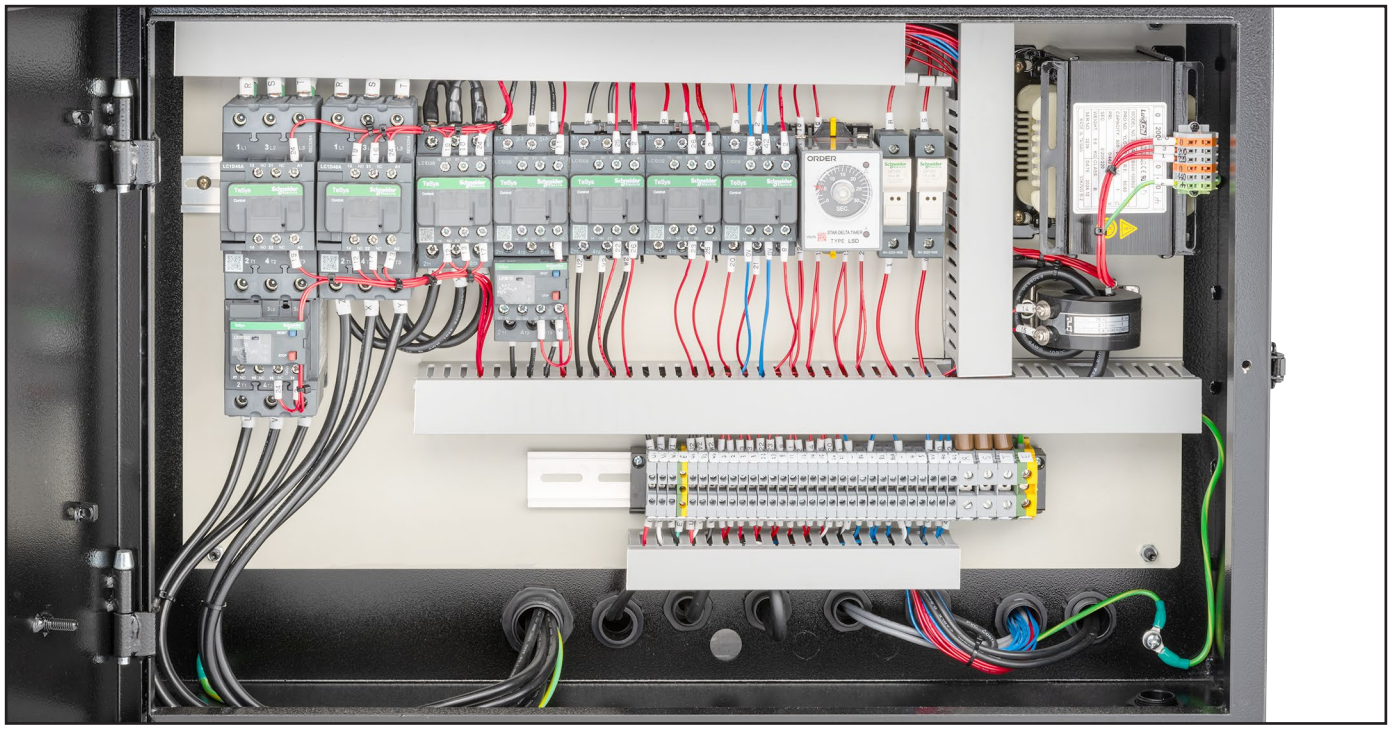


Figure 171. Model G0411 electrical cabinet wiring.

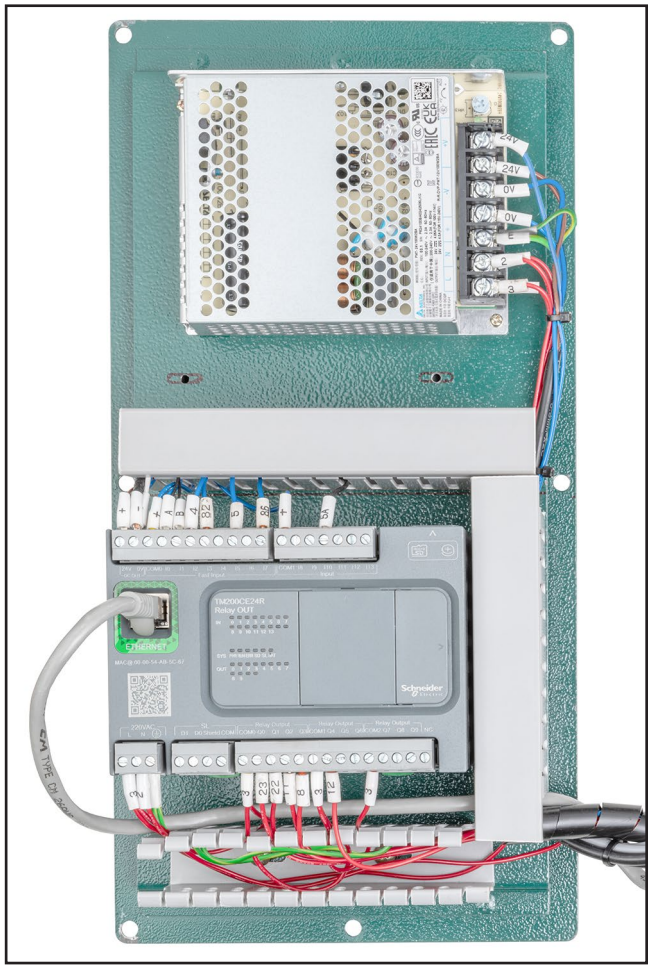


Figure 172. Model G0411 control box wiring.

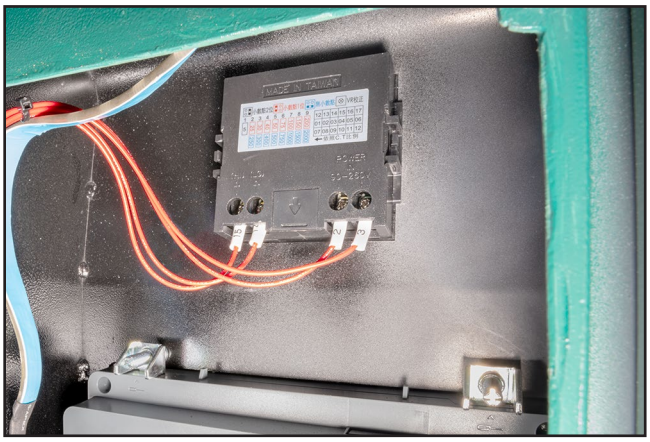


Figure 173. G0411 control panel upper wiring.

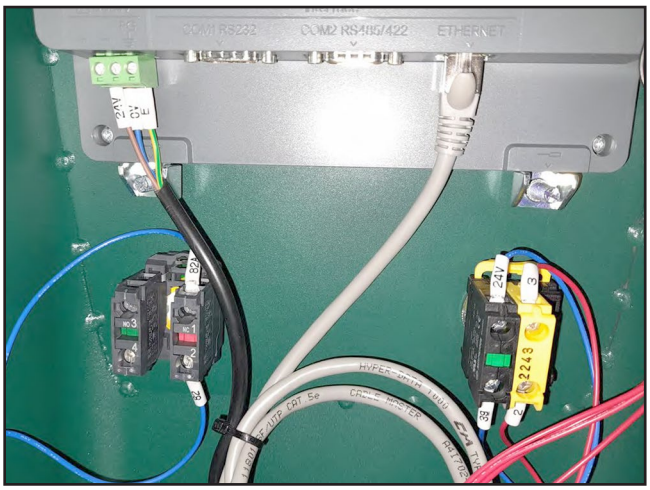


Figure 174. G0411 control panel touchscreen and switch wiring.



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G0411 Main Motor Wiring

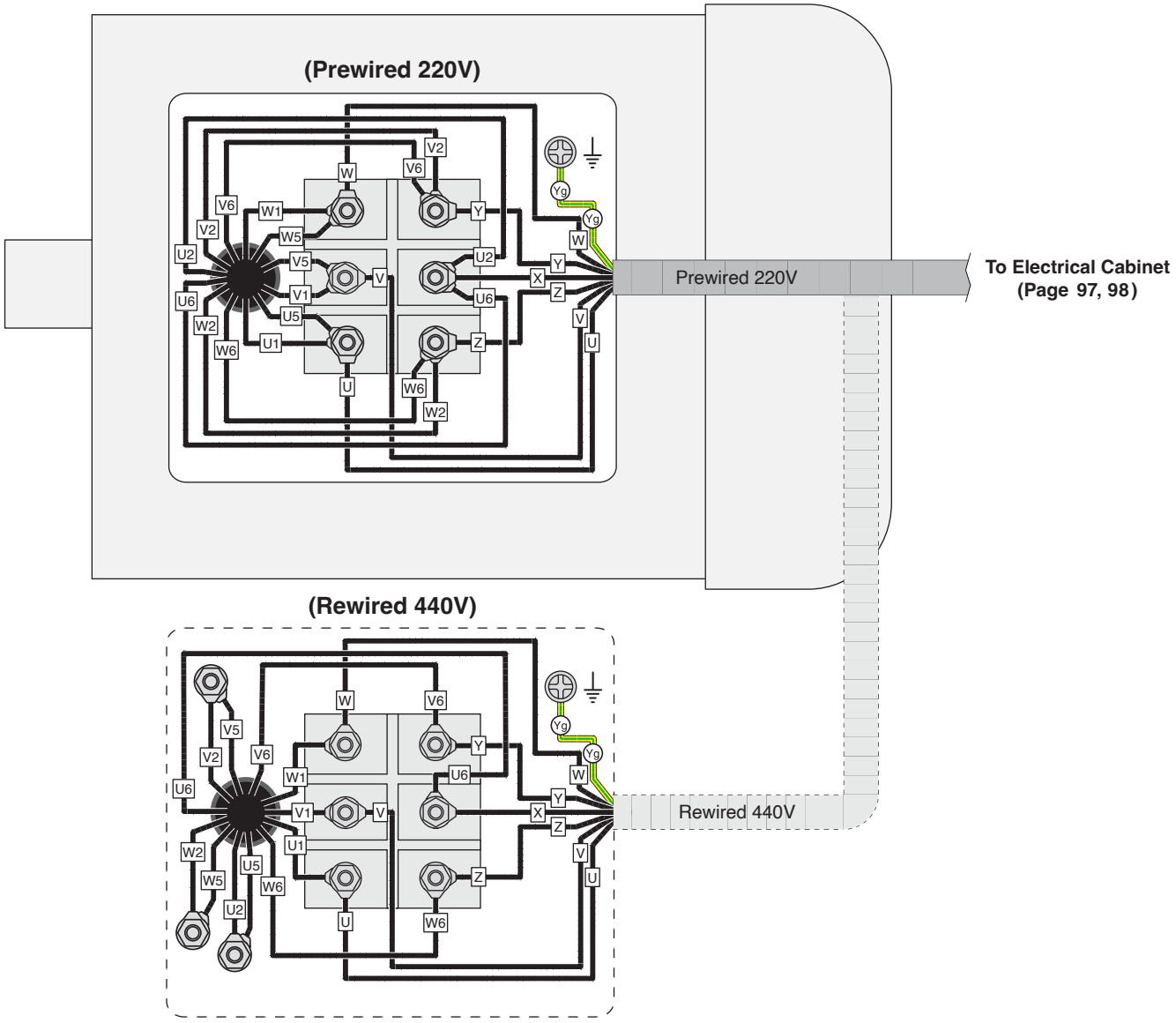




Figure 175. G0411 main motor junction box wiring (220V shown).

G0411 Feed Motor Wiring

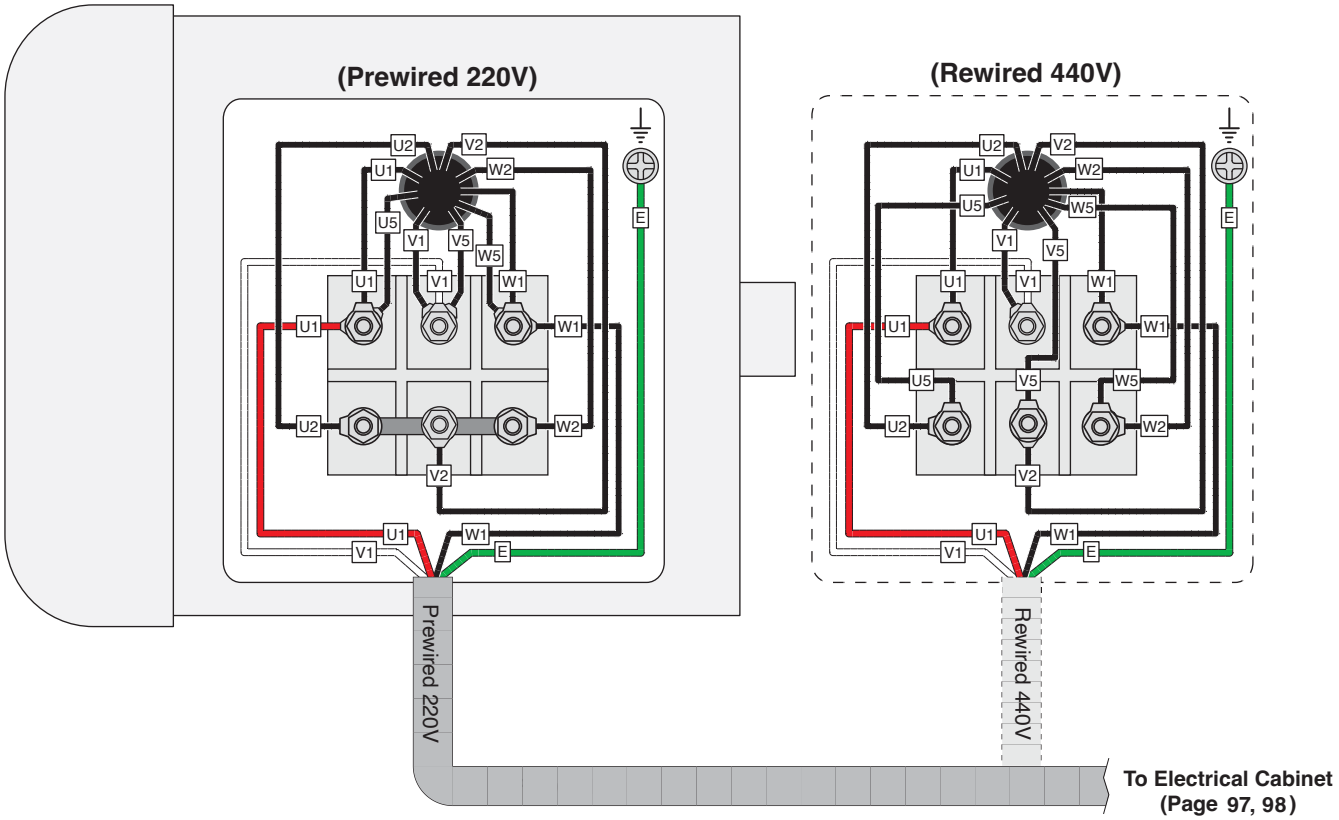




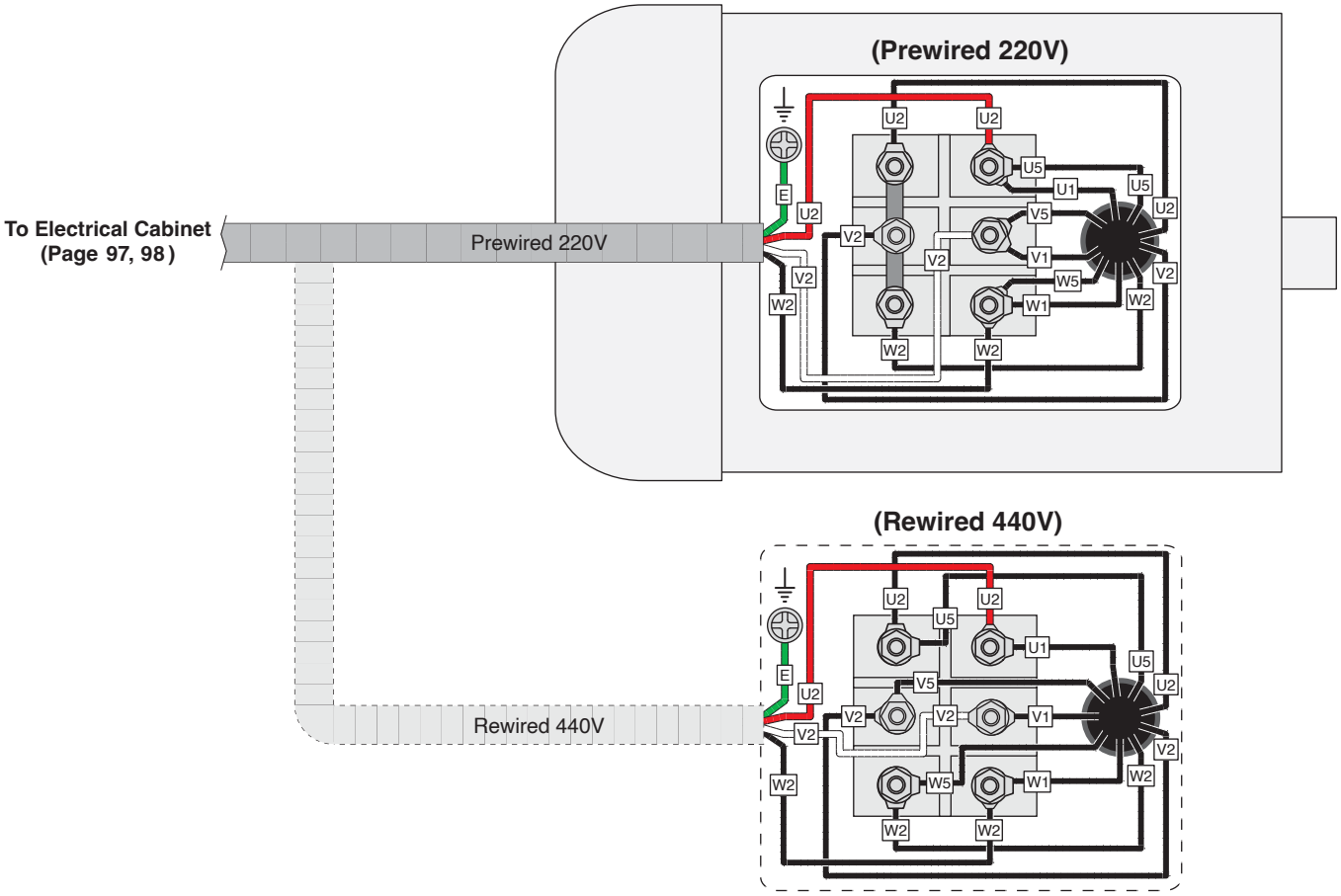
Figure 176. G0411 feed motor junction box wiring (220V shown).



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G0411 Table Elevation Motor Wiring



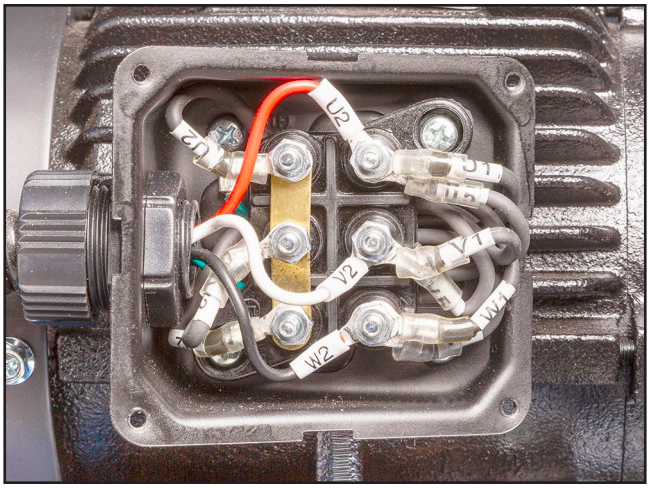
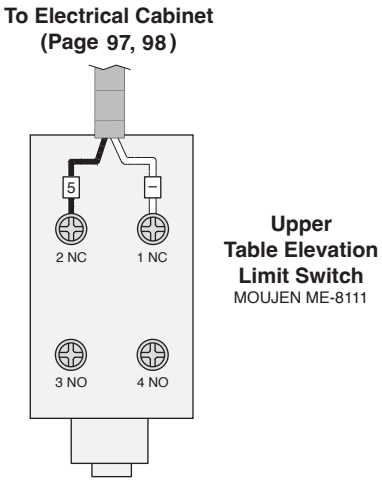


Figure 177. G0411 table elevation motor junction box wiring (220V shown).

G0411 Limit Switch Wiring



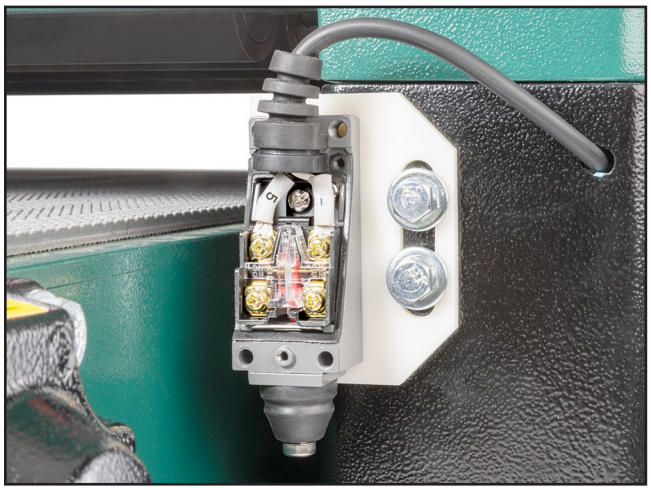
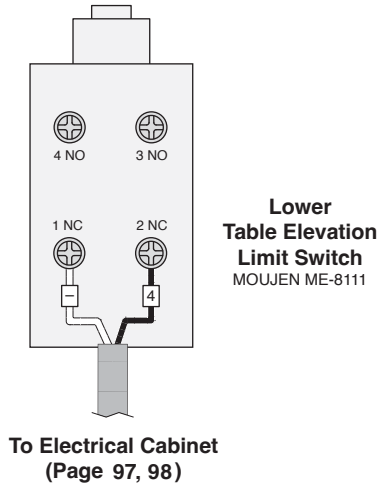


Figure 178. Upper table elevation limit switch wiring.



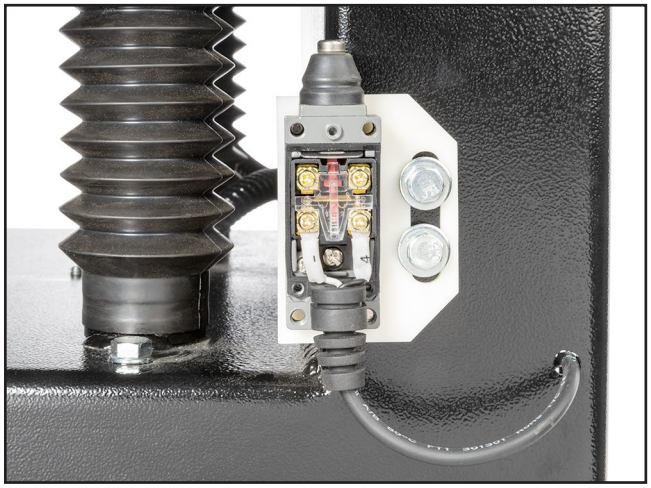
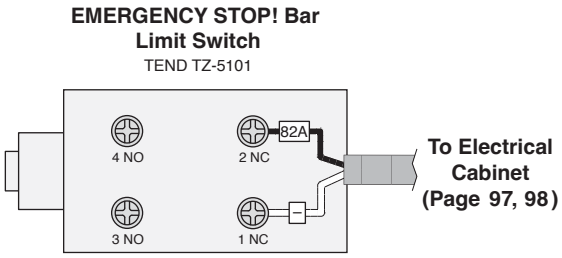


Figure 179. Lower table elevation limit switch wiring.



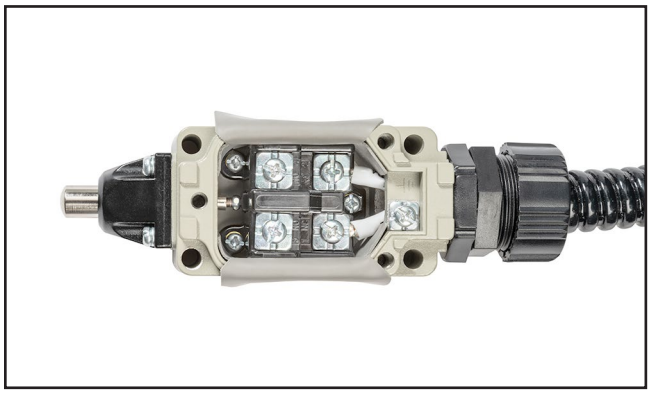
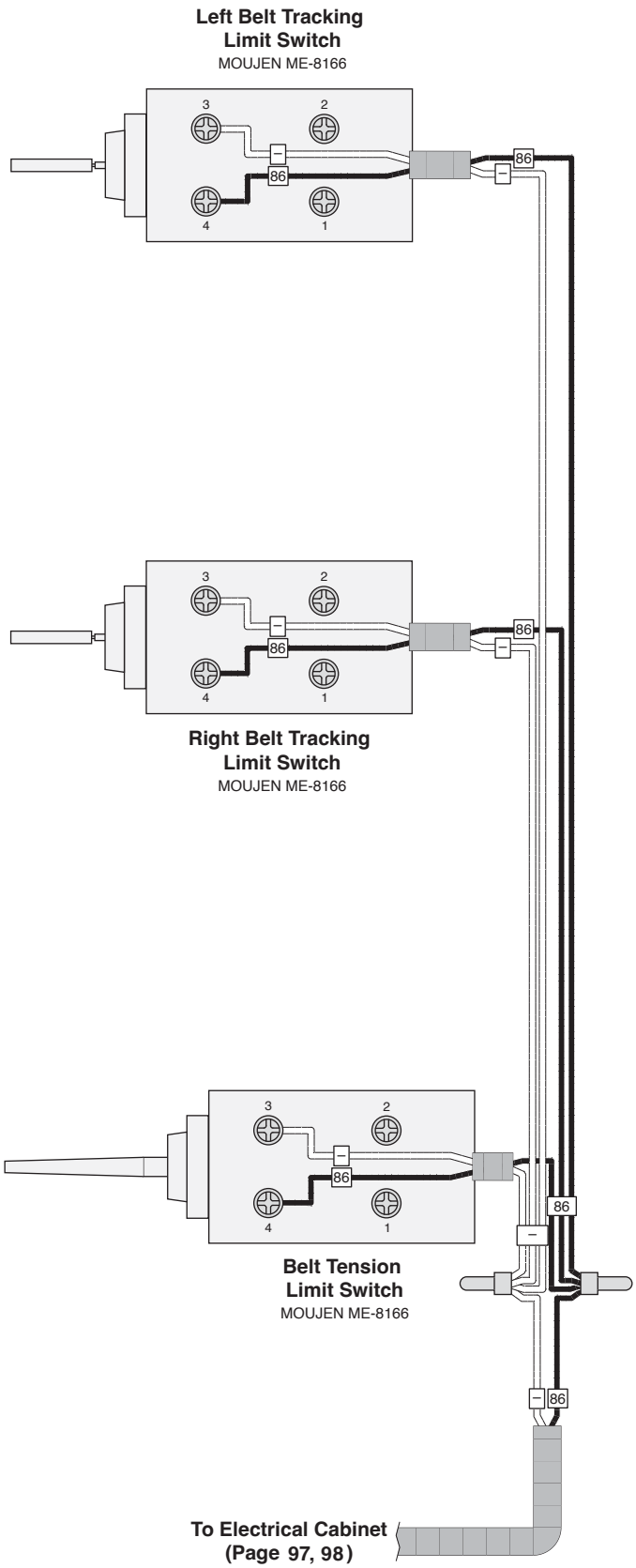


Figure 180. EMERGENCY STOP! bar limit switch wiring.



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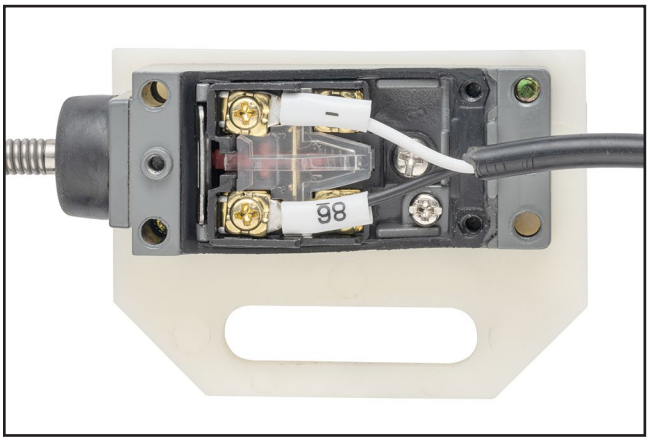


Figure 181. Left belt tracking limit switch wiring.

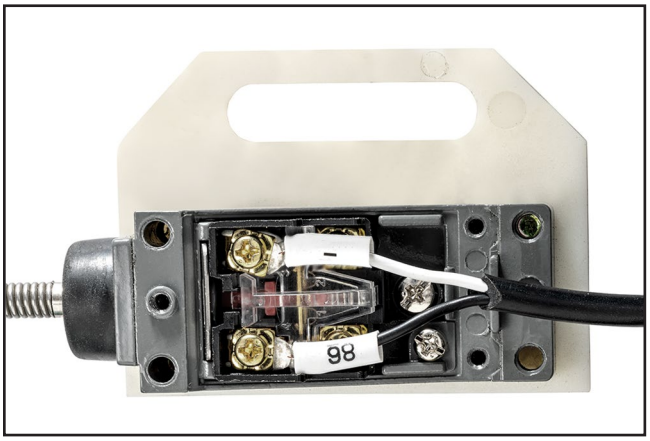


Figure 182. Right belt tracking limit switch wiring.

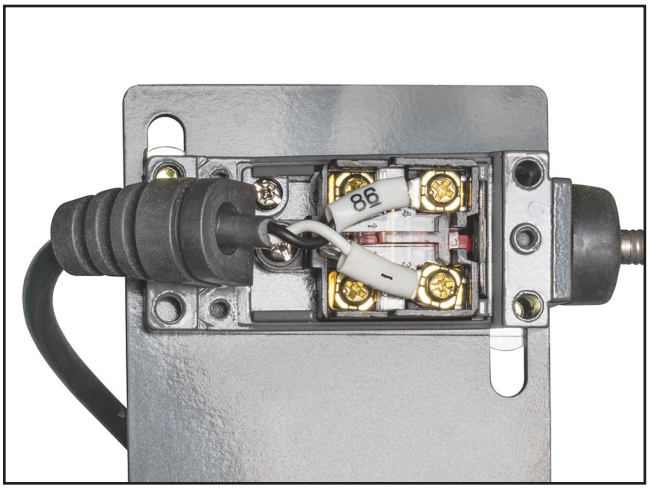
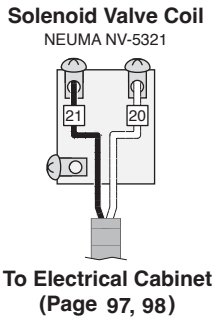


Figure 183. Belt tension limit switch wiring.

G0411 Solenoid Valve Coil Wiring



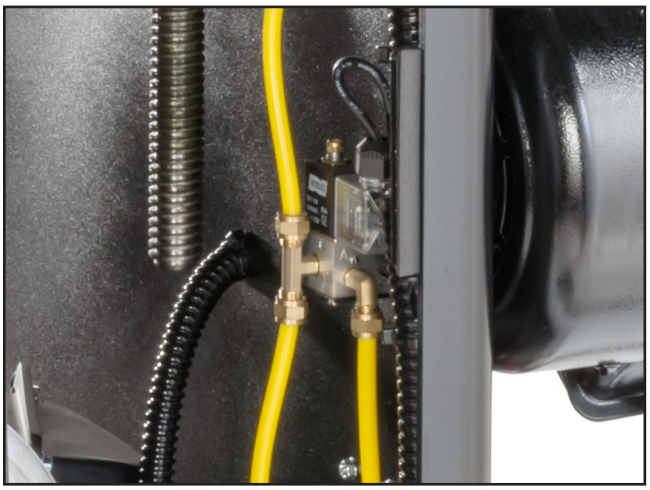
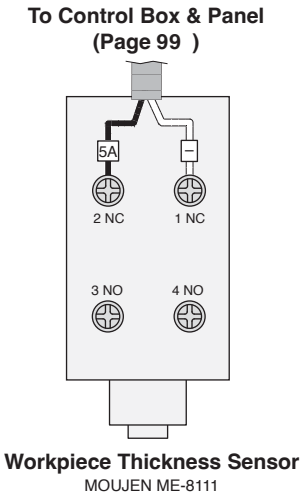


Figure 184. Solenoid valve coil.

G0411 Sensor Wiring



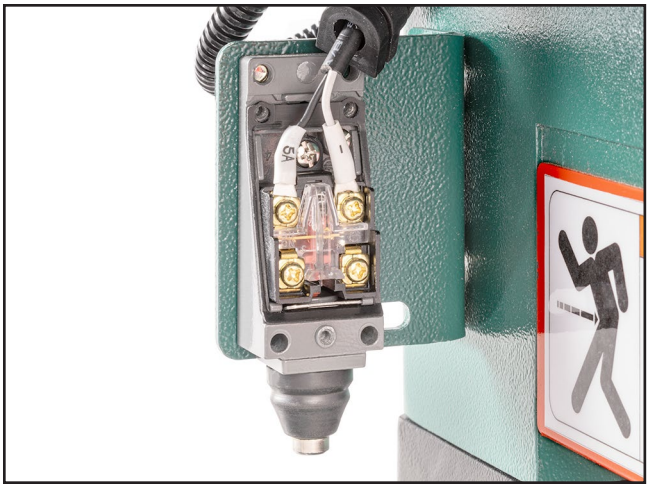
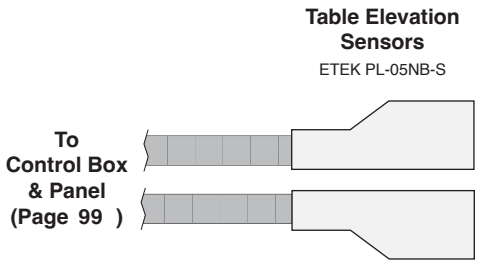


Figure 185. Workpiece thickness sensor wiring.



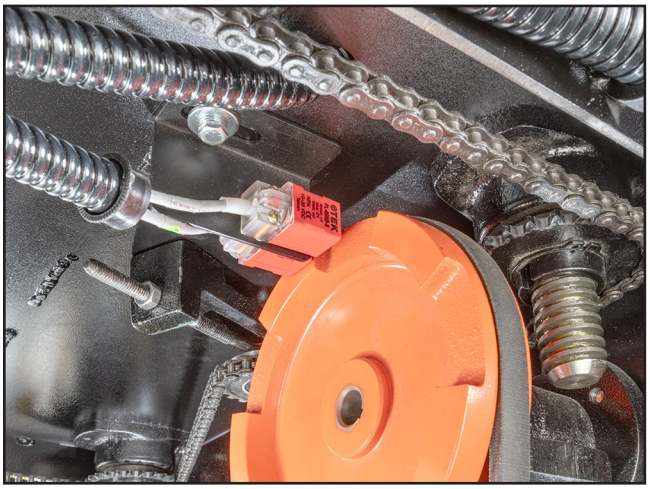


Figure 186. Table elevation sensors.



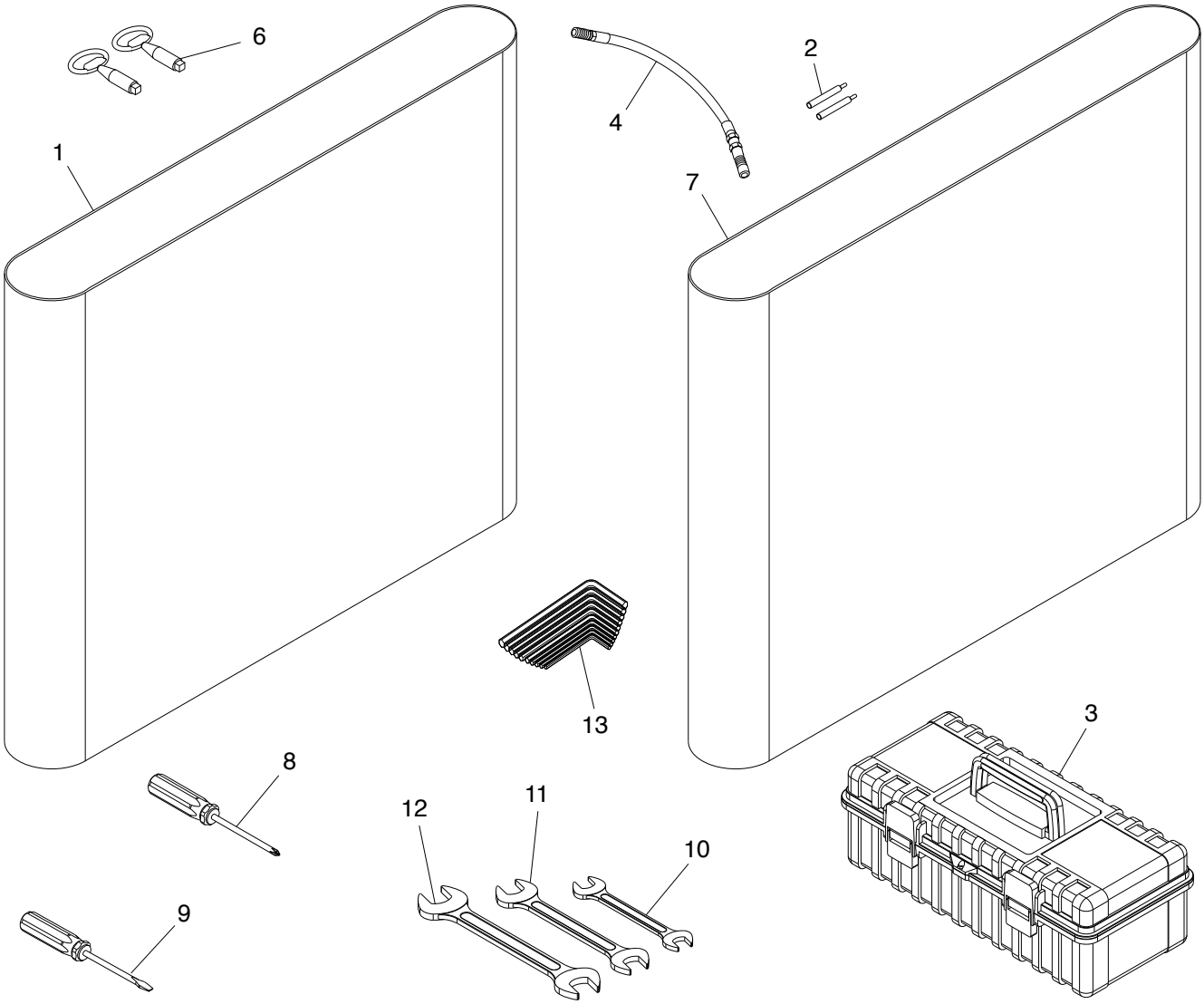
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SECTION 9: PARTS

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.

G0408 Tool Box & Accessories

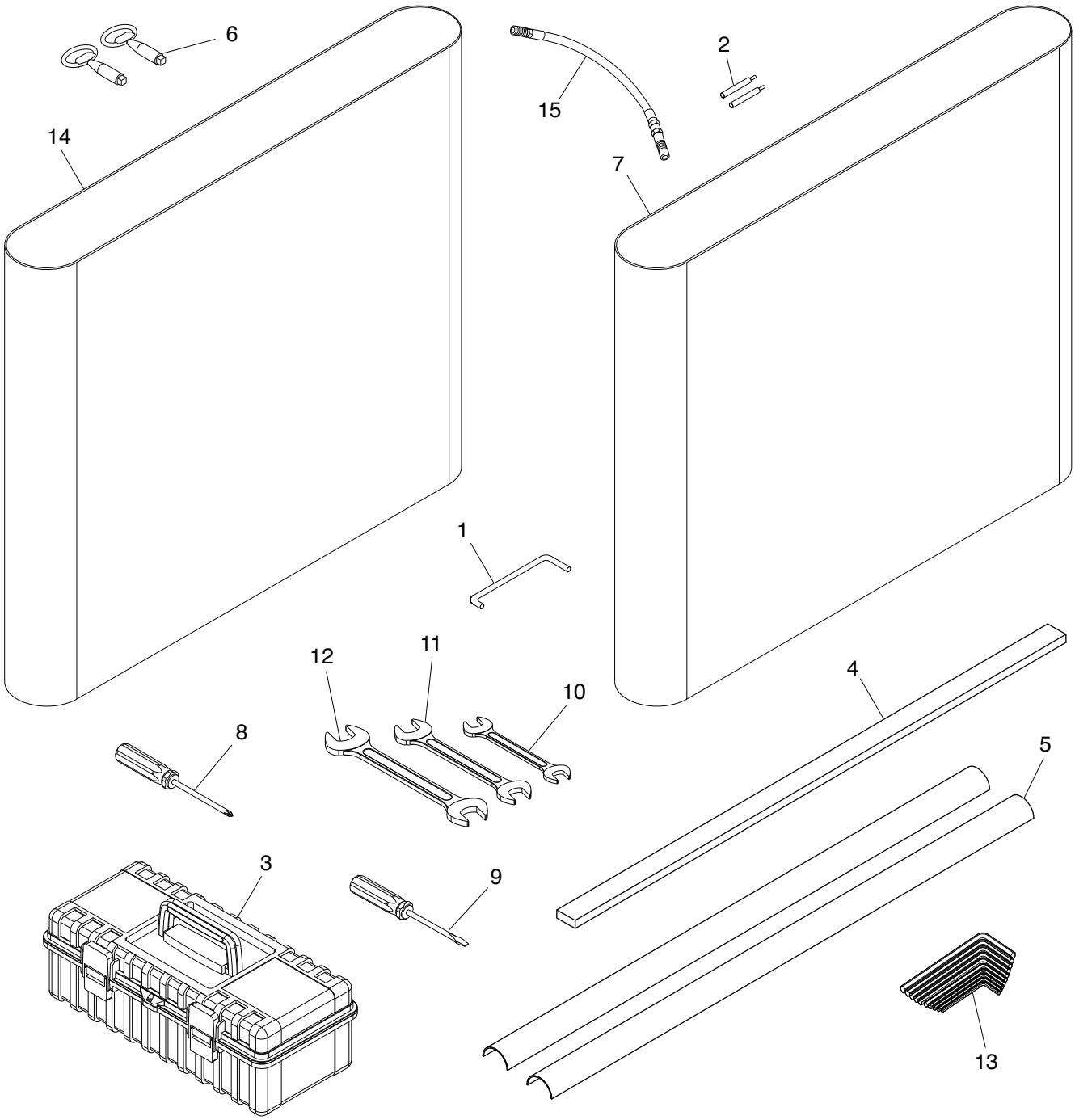


REF	PART #	DESCRIPTION
1	P04080001	SANDING BELT 25" X 60" 150-GRIT
2	P04080002	LIMIT SWITCH CERAMIC TIP
3	P04080003	TOOL BOX
4	P04080004	FLEXIBLE GREASE GUN EXTENSION
6	P04080006	DOOR KEY
7	P04080007	SANDING BELT 25" X 60" 100-GRIT

REF	PART #	DESCRIPTION
8	P04080008	SCREWDRIVER PHILLIPS #2
9	P04080009	SCREWDRIVER FLAT 1/4"
10	P04080010	WRENCH 8 X 10MM OPEN-ENDS
11	P04080011	WRENCH 12 X 14MM OPEN-ENDS
12	P04080012	WRENCH 17 X 19MM OPEN-ENDS
13	P04080013	HEX WRENCH SET (10-PC)

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G0409/G0411 Tool Box & Accessories

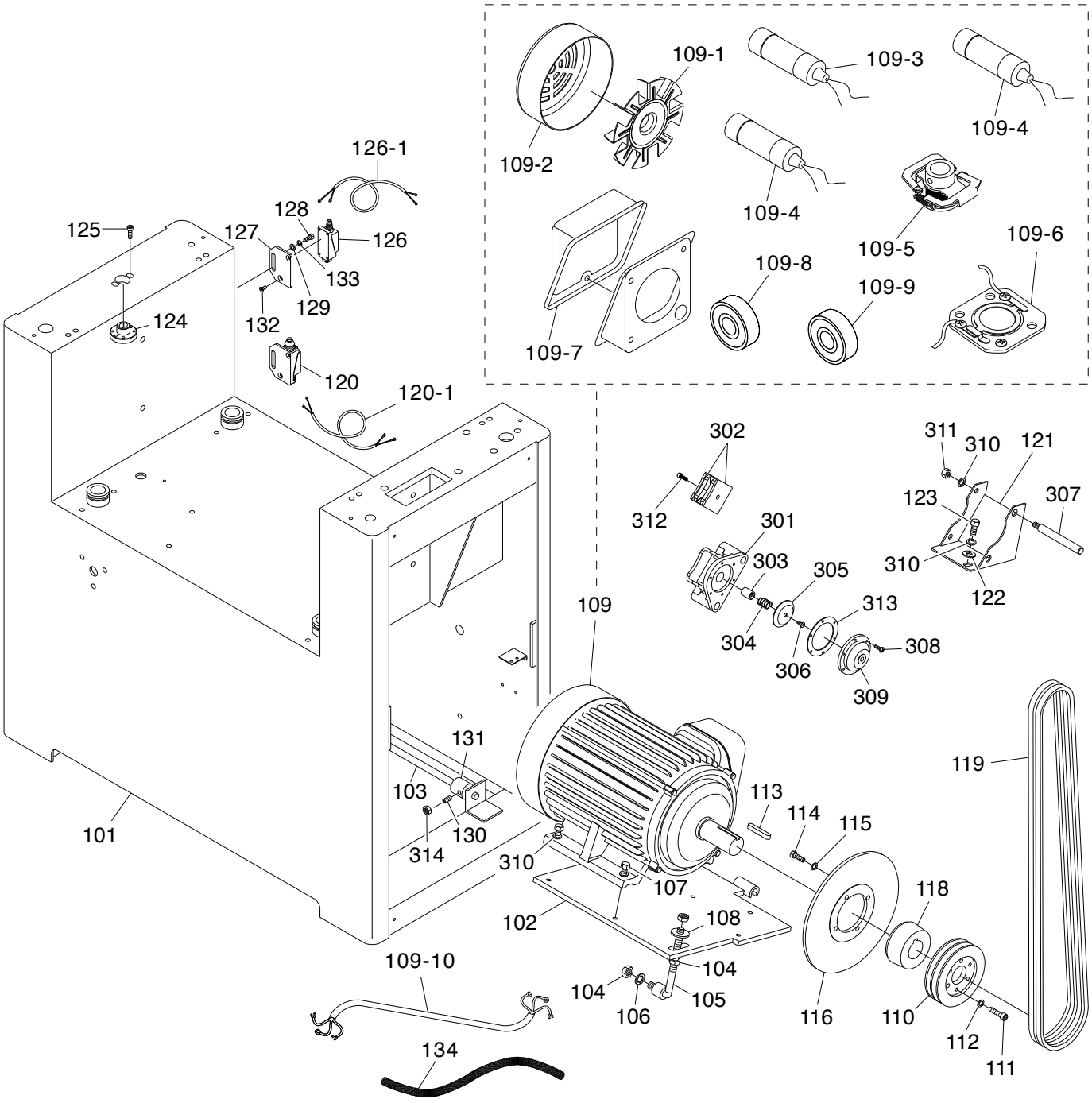


REF	PART #	DESCRIPTION
1	P04090001	PLATEN REMOVAL TOOL
2	P04090002	LIMIT SWITCH CERAMIC TIP
3	P04090003	TOOL BOX
4	P04090004	FELT PAD 3/8" X 1-3/4" X 37-13/16" (G0409)
4	P04110004	FELT PAD (G0411)
5	P04090005	GRAPHITE PAD 3-1/2" X 38-3/16" (G0409)
5	P04110005	GRAPHITE PAD (G0411)
6	P04090006	DOOR KEY
7	P04090007	SANDING BELT 37" X 60" 100-GRIT (G0409)
7	P04110007	SANDING BELT 51" X 60" 100-GRIT (G0411)

REF	PART #	DESCRIPTION
8	P04090008	SCREWDRIVER PHILLIPS #2
9	P04090009	SCREWDRIVER FLAT 1/4"
10	P04090010	WRENCH 8 X 10MM OPEN-ENDS
11	P04090011	WRENCH 12 X 14MM OPEN-ENDS
12	P04090012	WRENCH 17 X 19MM OPEN-ENDS
13	P04090013	HEX WRENCH SET (10-PC)
14	P04090014	SANDING BELT 37" X 60" 180-GRIT (G0409)
14	P04110014	SANDING BELT 51" X 60" 180-GRIT (G0411)
15	P04090015	FLEXIBLE GREASE GUN EXTENSION

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G0408 Main Motor



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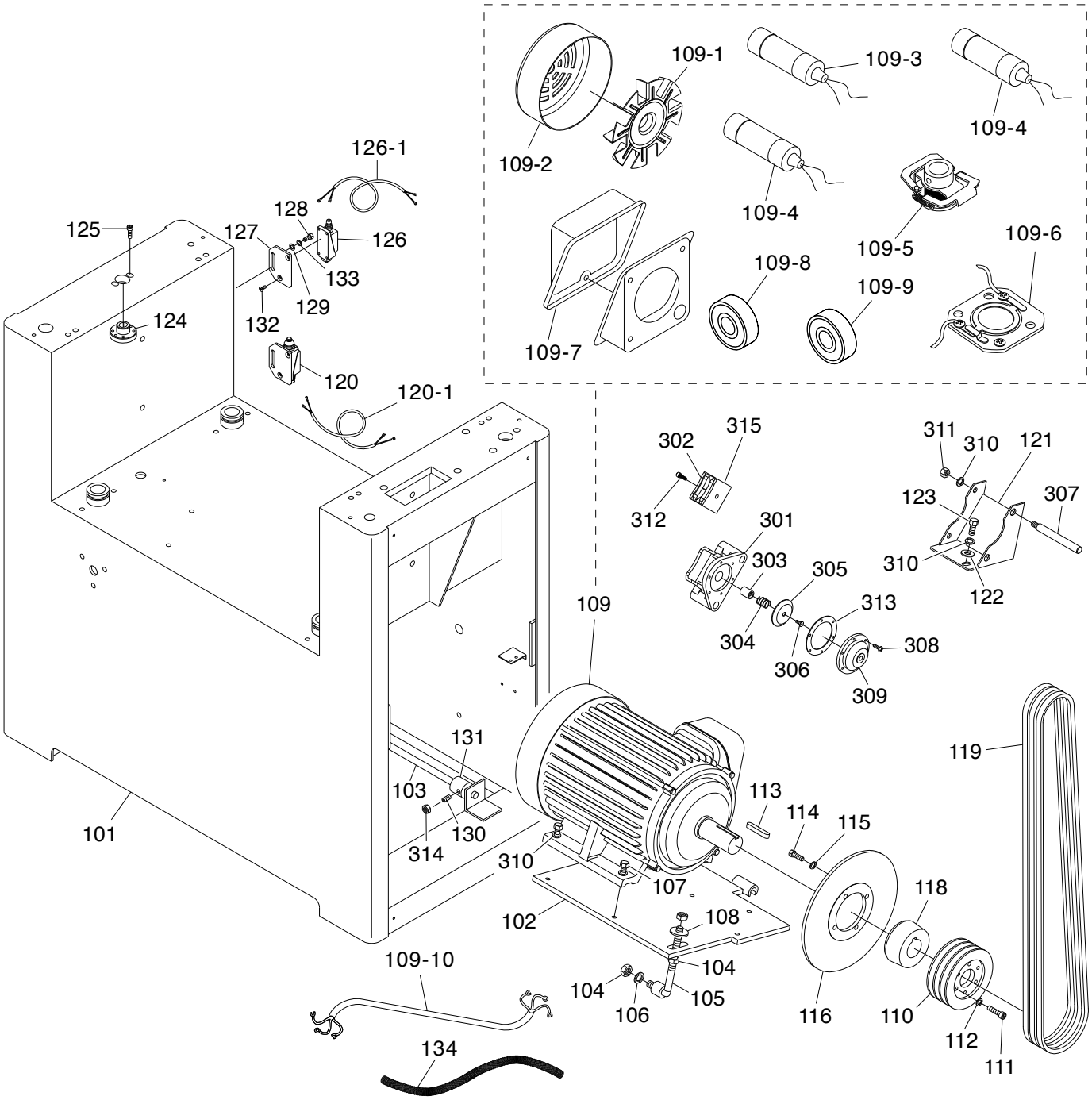
G0408 Main Motor Parts List

REF	PART #	DESCRIPTION
101	P04080101	MACHINE FRAME
102	P04080102	MOTOR MOUNTING PLATE
103	P04080103	PIVOT SHAFT
104	P04080104	HEX NUT 1/2-12
105	P04080105	BELT TENSION ADJUSTMENT ROD
106	P04080106	LOCK WASHER 1/2
107	P04080107	HEX BOLT 1/2-13 X 1-1/4
108	P04080108	FLAT WASHER 1/2
109	P04080109	MOTOR 10HP 220V 1-PH
109-1	P04080109-1	MOTOR FAN
109-2	P04080109-2	MOTOR FAN COVER
109-3	P04080109-3	R CAPACITOR 100M 300V
109-4	P04080109-4	S CAPACITOR 600M 250V
109-5	P04080109-5	CENTRIFUGAL SWITCH
109-6	P04080109-6	CONTACT PLATE 65 X 81 INT
109-7	P04080109-7	MOTOR JUNCTION BOX
109-8	P04080109-8	BALL BEARING 6208-2RS (FRONT)
109-9	P04080109-9	BALL BEARING 6206-2RS (REAR)
109-10	P04080109-10	MOTOR CORD 8G 3W 39"
110	P04080110	MOTOR PULLEY
111	P04080111	CAP SCREW 5/16-18 X 1-1/4
112	P04080112	LOCK WASHER 5/16
113	P04080113	KEY 10 X 8 X 75 RE
114	P04080114	HEX BOLT 5/16-18 X 1
115	P04080115	LOCK WASHER 5/16
116	P04080116	BRAKE DISC
118	P04080118	KEYED BUSHING 38 X 80MM
119	P04080119	V-BELT B77
120	P04080120	LIMIT SWITCH MOUJEN ME-8111
120-1	P04080120-1	CORD 20G 2W 28"

REF	PART #	DESCRIPTION
121	P04080121	BRAKE MOUNT
122	P04080122	FLAT WASHER 3/8
123	P04080123	HEX BOLT 3/8-16 X 3/4
124	P04080124	LOCK BLOCK NUT M16-2
125	P04080125	CAP SCREW 1/4-20 X 3/4
126	P04080126	LIMIT SWITCH MOUJEN ME-8111
126-1	P04080126-1	CORD 20G 2W 40"
127	P04080127	LIMIT SWITCH MOUNT
128	P04080128	HEX BOLT 1/4-20 X 5/8
129	P04080129	FLAT WASHER 1/4
130	P04080130	SET SCREW 5/16-18 X 3/4
131	P04080131	LOCK COLLAR
132	P04080132	FLAT HD SCR 1/4-20 X 1/2
133	P04080133	LOCK WASHER 1/4
134	P04080134	CONDUIT 1" X 1-1/8" X 40"
301	P04080301	BRAKE CALIPER
302	P04080302	BRAKE PAD SET (2-PC)
303	P04080303	COUNTERSUNK BUSHING 8 X 15 X 15MM
304	P04080304	COMPRESSION SPRING 2.5 X 34 X 15
305	P04080305	DIAPHRAGM PLATE
306	P04080306	FLAT HD CAP SCR 1/4-20 X 1/2
307	P04080307	SHOULDER STUD-SE 3/8-16 X 4-15/16, 1/2
308	P04080308	PHLP HD SCR M5-.8 X 15
309	P04080309	DIAPHRAGM COVER
310	P04080310	LOCK WASHER 3/8
311	P04080311	HEX NUT 3/8-16
312	P04080312	CAP SCREW M6-1 X 12
313	P04080313	DIAPHRAGM
314	P04080314	HEX NUT 5/16-18

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G0409 Main Motor



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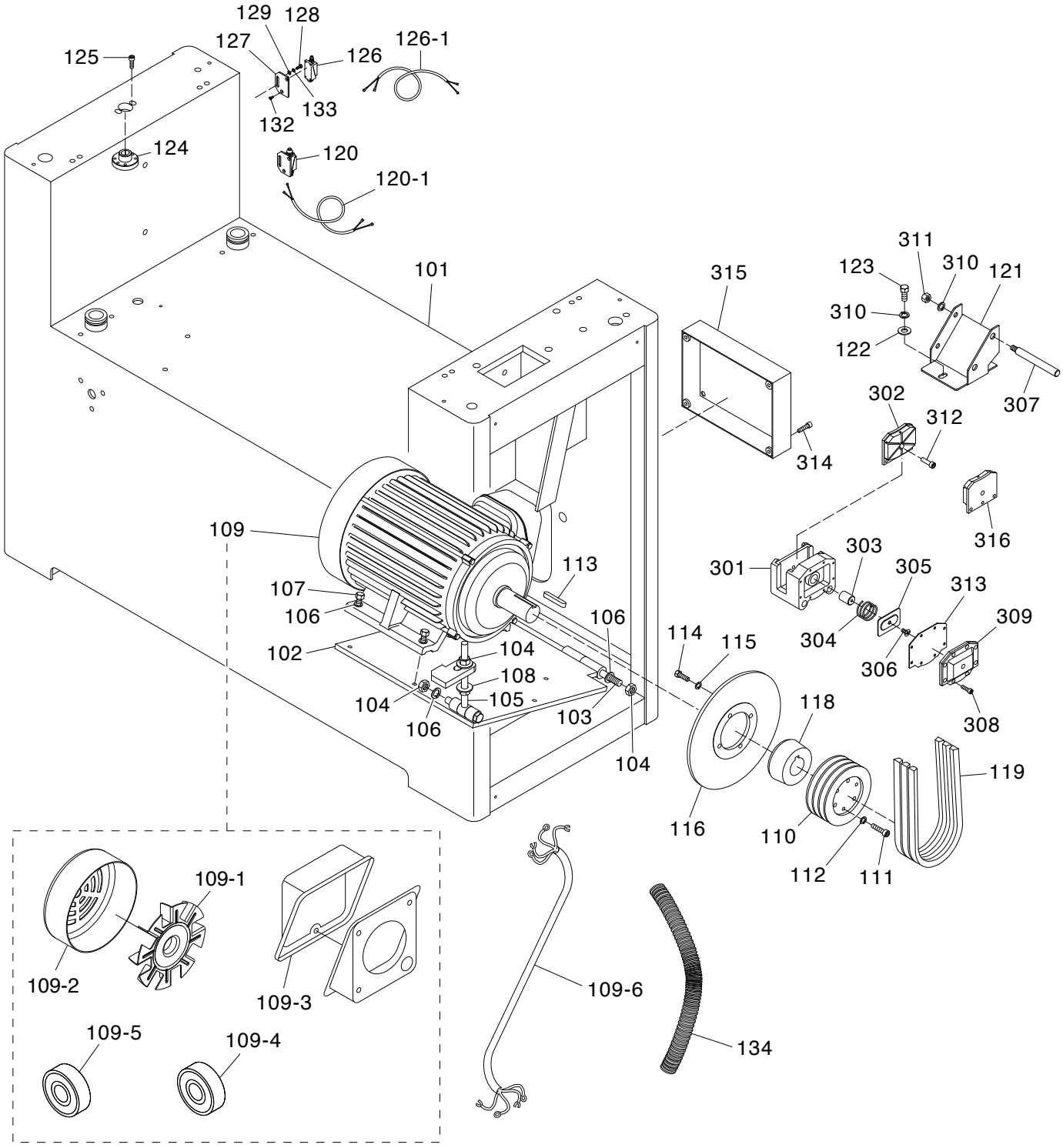
G0409 Main Motor Parts List

REF	PART #	DESCRIPTION
101	P04090101	MACHINE FRAME
102	P04090102	MOTOR MOUNTING PLATE
103	P04090103	PIVOT SHAFT
104	P04090104	HEX NUT 1/2-12
105	P04090105	BELT TENSION ADJUSTMENT ROD
106	P04090106	LOCK WASHER 1/2
107	P04090107	HEX BOLT 3/8-16 X 1-1/4
108	P04090108	FLAT WASHER 1/2
109	P04090109	MOTOR 10HP 220V 1-PH
109-1	P04090109-1	MOTOR FAN
109-2	P04090109-2	MOTOR FAN COVER
109-3	P04090109-3	R CAPACITOR 100M 300V
109-4	P04090109-4	S CAPACITOR 600M 250V
109-5	P04090109-5	CENTRIFUGAL SWITCH
109-6	P04090109-6	CONTACT PLATE 65 X 81 INT
109-7	P04090109-7	MOTOR JUNCTION BOX
109-8	P04090109-8	BALL BEARING 6208-2RS (FRONT)
109-9	P04090109-9	BALL BEARING 6206-2RS (REAR)
109-10	P04090109-10	MOTOR CORD 8G 3W 39"
110	P04090110	MOTOR PULLEY
111	P04090111	CAP SCREW 5/16-18 X 1-1/4
112	P04090112	LOCK WASHER 5/16
113	P04090113	KEY RE
114	P04090114	HEX BOLT 5/16-18 X 1
115	P04090115	LOCK WASHER 5/16
116	P04090116	BRAKE DISC
118	P04090118	KEYED BUSHING
119	P04090119	V-BELT A71
120	P04090120	LIMIT SWITCH MOUJEN ME-8111
120-1	P04090120-1	CORD 20G 2W

REF	PART #	DESCRIPTION
121	P04090121	BRAKE MOUNT
122	P04090122	FLAT WASHER 3/8
123	P04090123	HEX BOLT 3/8-16 X 3/4
124	P04090124	LOCK BLOCK NUT M16-2
125	P04090125	CAP SCREW 1/4-20 X 3/4
126	P04090126	LIMIT SWITCH MOUJEN ME-8111
126-1	P04090126-1	CORD 20G 2W
127	P04090127	LIMIT SWITCH MOUNT
128	P04090128	HEX BOLT 1/4-20 X 1/2
129	P04090129	FLAT WASHER 1/4
130	P04090130	SET SCREW 5/16-18 X 3/4
131	P04090131	LOCK COLLAR
132	P04090132	FLAT HD SCR M5-.8 X 15
133	P04090133	LOCK WASHER 1/4
134	P04090134	CONDUIT 1" X 1-1/8"
301	P04090301	BRAKE CALIPER
302	P04090302	BRAKE PAD INNER
303	P04090303	COUNTERSUNK BUSHING 8 X 15 X 15MM
304	P04090304	COMPRESSION SPRING 2.5 X 34 X 15
305	P04090305	DIAPHRAGM PLATE
306	P04090306	FLAT HD CAP SCR 1/4-20 X 1/2
307	P04090307	SHOULDER STUD-SE 3/8-16 X 4-15/16, 1/2
308	P04090308	PHLP HD SCR M5-.8 X 15
309	P04090309	DIAPHRAGM COVER
310	P04090310	LOCK WASHER 3/8
311	P04090311	HEX NUT 3/8-16
312	P04090312	CAP SCREW 1/4-20 X 5/8
313	P04090313	DIAPHRAGM
314	P04090314	HEX NUT 5/16-18
315	P04090315	BRAKE PAD OUTER

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G0411 Main Motor



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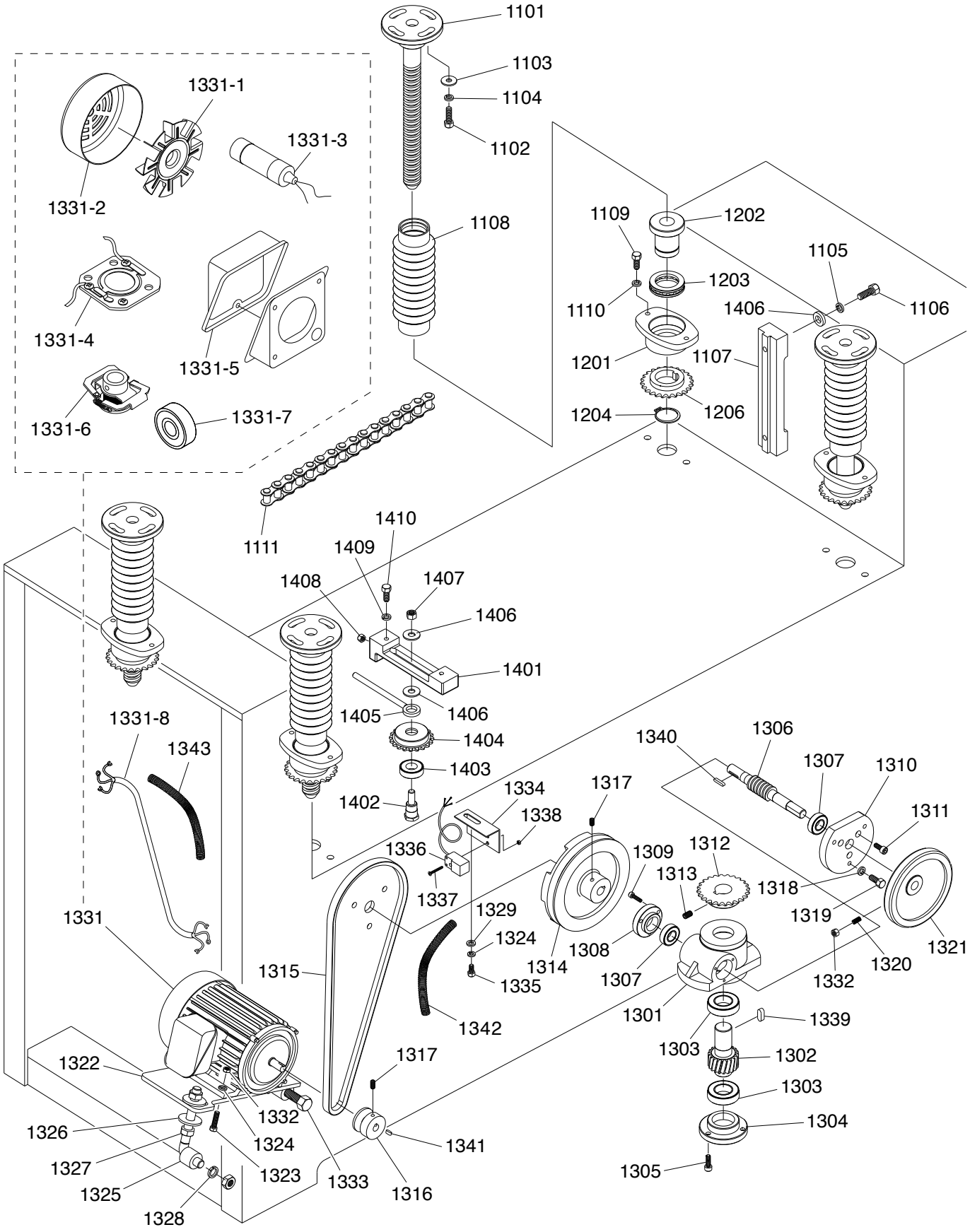
G0411 Main Motor Parts List

REF	PART #	DESCRIPTION
101	P04110101	MACHINE FRAME
102	P04110102	MOTOR MOUNTING PLATE
103	P04110103	PIVOT SHAFT
104	P04110104	HEX NUT 1/2-12
105	P04110105	BELT TENSION ADJUSTMENT ROD
106	P04110106	LOCK WASHER 1/2
107	P04110107	HEX BOLT 1/2-12 X 1-1/4
108	P04110108	FLAT WASHER 1/2
109	P04110109	MOTOR 30HP 220V/440V 3-PH
109-1	P04110109-1	MOTOR FAN
109-2	P04110109-2	MOTOR FAN COVER
109-3	P04110109-3	MOTOR JUNCTION BOX
109-4	P04110109-4	BALL BEARING 6311ZZ (FRONT)
109-5	P04110109-5	BALL BEARING 6310ZZ (REAR)
109-6	P04110109-6	MOTOR CORD 8G 7W 55"
110	P04110110	MOTOR PULLEY
111	P04110111	CAP SCREW 5/16-18 X 1-1/4
112	P04110112	LOCK WASHER 5/16
113	P04110113	KEY 10 X 8 X 75 RE
114	P04110114	HEX BOLT 5/16-18 X 1
115	P04110115	LOCK WASHER 5/16
116	P04110116	BRAKE DISC
118	P04110118	KEYED BUSHING 48 X 80 X 34MM
119	P04110119	V-BELT B68
120	P04110120	LIMIT SWITCH MOUJEN ME-8111
120-1	P04110120-1	CORD 2W
121	P04110121	BRAKE MOUNT
122	P04110122	FLAT WASHER 3/8

REF	PART #	DESCRIPTION
123	P04110123	HEX BOLT 3/8-16 X 3/4
124	P04110124	LOCK BLOCK NUT
125	P04110125	CAP SCREW 1/4-20 X 3/4
126	P04110126	LIMIT SWITCH MOUJEN ME-8111
126-1	P04110126-1	CORD 2W
127	P04110127	LIMIT SWITCH MOUNT
128	P04110128	HEX BOLT 1/4-20 X 5/8
129	P04110129	FLAT WASHER 1/4
132	P04110132	FLAT HD SCR M5-.8 X 8
133	P04110133	LOCK WASHER 1/4
134	P04110134	CONDUIT
301	P04110301	BRAKE CALIPER
302	P04110302	BRAKE PAD INNER
303	P04110303	COUNTERSUNK BUSHING 7 X 19 X 26MM
304	P04110304	COMPRESSION SPRING 2.5 X 36 X 41
305	P04110305	DIAPHRAGM PLATE 38 X 60 X 1.2MM
306	P04110306	FLAT HD CAP SCR 1/4-20 X 1/2
307	P04110307	SHOULDER STUD-SE 3/8-16
308	P04110308	CAP SCREW 10-24 X 3/8
309	P04110309	DIAPHRAGM COVER
310	P04110310	LOCK WASHER 3/8
311	P04110311	HEX NUT 3/8-16
312	P04110312	CAP SCREW 1/4-20 X 5/8
313	P04110313	DIAPHRAGM
314	P04110314	CAP SCREW 1/4-20 X 3/8
315	P04110315	MOTOR ACCESS COVER
316	P04110316	BRAKE PAD OUTER

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G0408/G0409 Table Elevation



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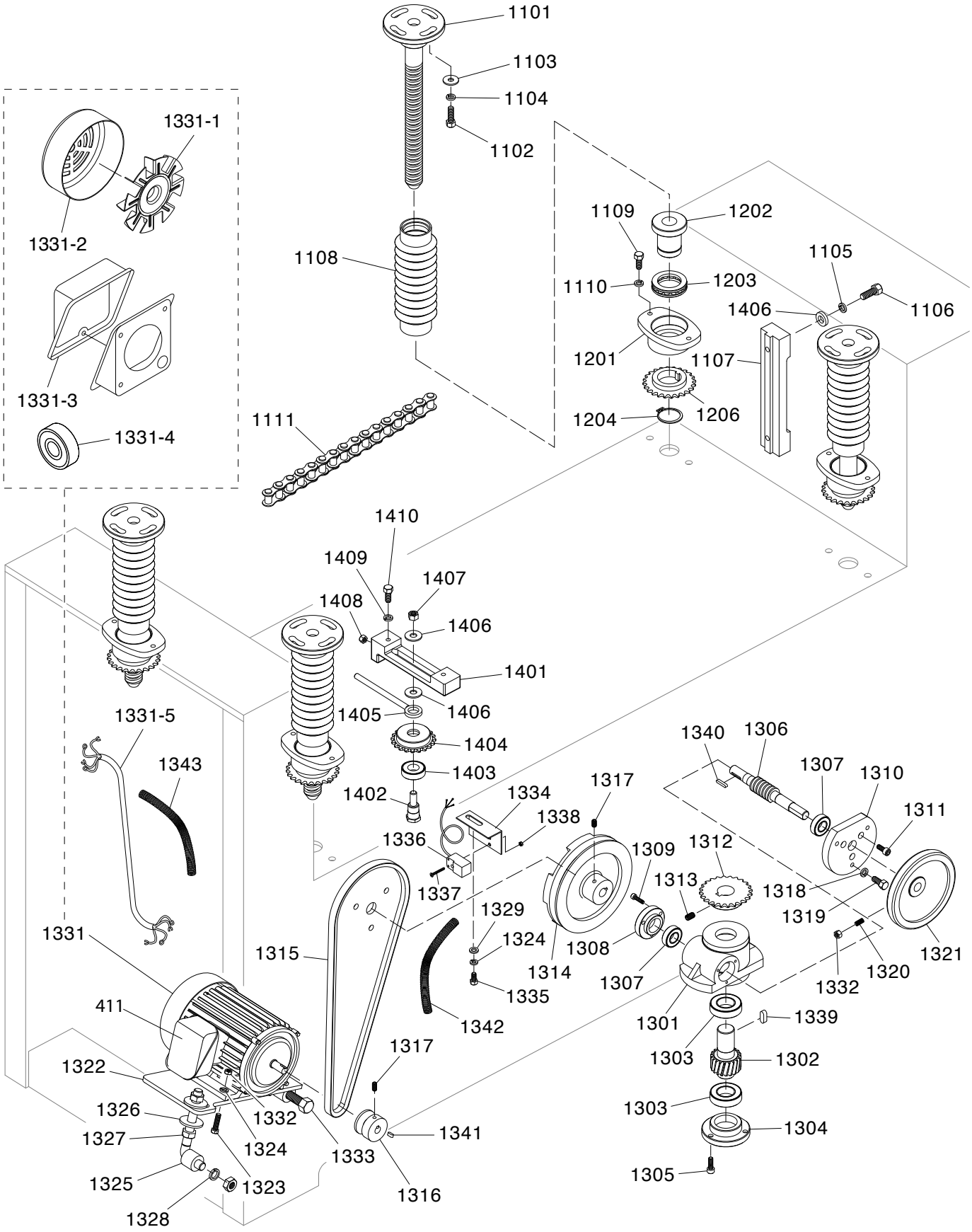
G0408/G0409 Table Elevation Parts List

REF	PART #	DESCRIPTION
1101	P04081101	LEADSCREW W/FLANGE
1102	P04081102	HEX BOLT 5/16-18 X 1
1103	P04081103	FLAT WASHER 5/16
1104	P04081104	LOCK WASHER 5/16
1105	P04081105	LOCK WASHER 3/8
1106	P04081106	HEX BOLT 3/8-16 X 1
1107	P04081107	TABLE GUIDE
1108	P04081108	DUST BELLOW
1109	P04081109	HEX BOLT 5/16-18 X 3/4
1110	P04081110	LOCK WASHER 5/16
1111	P04081111	ROLLER CHAIN #35 (G0408)
1111	P04091111	ROLLER CHAIN #35 X 296" (G0409)
1201	P04081201	LEADSCREW NUT HOUSING
1202	P04081202	LEADSCREW NUT
1203	P04081203	THRUST BEARING 51107
1204	P04081204	EXT RETAINING RING 35MM
1206	P04081206	SPROCKET 24T
1301	P04081301	ELEVATION GEARBOX
1302	P04081302	WORM GEAR SHAFT 20T 45 X 83MM
1303	P04081303	BALL BEARING 6005Z
1304	P04081304	BEARING CAP
1305	P04081305	CAP SCREW 1/4-20 X 3/4
1306	P04081306	WORM SHAFT 23 X 160
1307	P04081307	BALL BEARING 6002Z
1308	P04081308	BEARING CAP
1309	P04081309	CAP SCREW 10-24 X 5/8
1310	P04081310	HANDWHEEL BEARING CAP
1311	P04081311	CAP SCREW 1/4-20 X 5/8
1312	P04081312	SPROCKET 25T
1313	P04081313	SET SCREW 5/16-18 X 1/2
1314	P04081314	TABLE PULLEY
1315	P04081315	V-BELT A36
1316	P04081316	MOTOR PULLEY
1317	P04081317	SET SCREW 1/4-20 X 1/2
1318	P04081318	LOCK WASHER 5/16
1319	P04081319	HEX BOLT 5/16-18 X 3/4
1320	P04081320	SET SCREW 1/4-20 X 3/4
1321	P04081321	HANDWHEEL 14MM (G0408)
1321	P04091321	HANDWHEEL 13.2MM (G0409)
1322	P04081322	MOTOR MOUNTING PLATE

REF	PART #	DESCRIPTION
1323	P04081323	HEX BOLT 1/4-20 X 3/4
1324	P04081324	LOCK WASHER 1/4
1325	P04081325	BELT TENSION ADJUSTMENT ROD
1326	P04081326	FENDER WASHER 1/2
1327	P04081327	HEX NUT 1/2-12
1328	P04081328	LOCK WASHER 1/2
1329	P04081329	FLAT WASHER 1/4
1331	P04081331	MOTOR 1HP 220V 1-PH
1331-1	P04081331-1	MOTOR FAN
1331-2	P04081331-2	MOTOR FAN COVER
1331-3	P04081331-3	R CAPACITOR 100M 250V
1331-4	P04081331-4	CENTRIFUGAL SWITCH 7/8"
1331-5	P04081331-5	MOTOR JUNCTION BOX
1331-6	P04081331-6	CONTACT PLATE 42 X 55 INT
1331-7	P04081331-7	BALL BEARING 6202-2RS
1331-8	P04081331-8	CORD 16G 4W 40"
1332	P04081332	HEX NUT 1/4-20
1333	P04081333	HEX BOLT 1/2-1/2 X 4-1/2
1334	P04081334	SENSOR MOUNT
1335	P04081335	HEX BOLT 1/4-20 X 1/2
1336	P04081336	TABLE SENSOR W/CORD ETEK PL-05NB-S
1337	P04081337	PHLP HD SCR M3-.5 X 30
1338	P04081338	HEX NUT M3-.5
1339	P04081339	KEY 8 X 8 X 20 RE
1340	P04081340	KEY 4 X 4 X 20 RE
1341	P04081341	KEY 4 X 4 X 25 RE
1342	P04081342	CONDUIT 3/8" X 1/2" X 28" (G0408)
1342	P04091342	CONDUIT 3/8" X 1/2" (G0409)
1343	P04081343	CONDUIT 3/8" X 1/2" X 20" (G0408)
1343	P04091343	CONDUIT 3/8" X 1/2" (G0409)
1401	P04081401	CHAIN TENSION BLOCK
1402	P04081402	SPROCKET SHAFT
1403	P04081403	BALL BEARING 6003ZZ
1404	P04081404	SPROCKET 35T
1405	P04081405	TENSION ADJUSTMENT ROD
1406	P04081406	FLAT WASHER 3/8
1407	P04081407	HEX NUT 3/8-16
1408	P04081408	HEX NUT 5/16-18
1409	P04081409	LOCK WASHER 5/16
1410	P04081410	HEX BOLT 5/16-18 X 3/4

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G0411 Table Elevation



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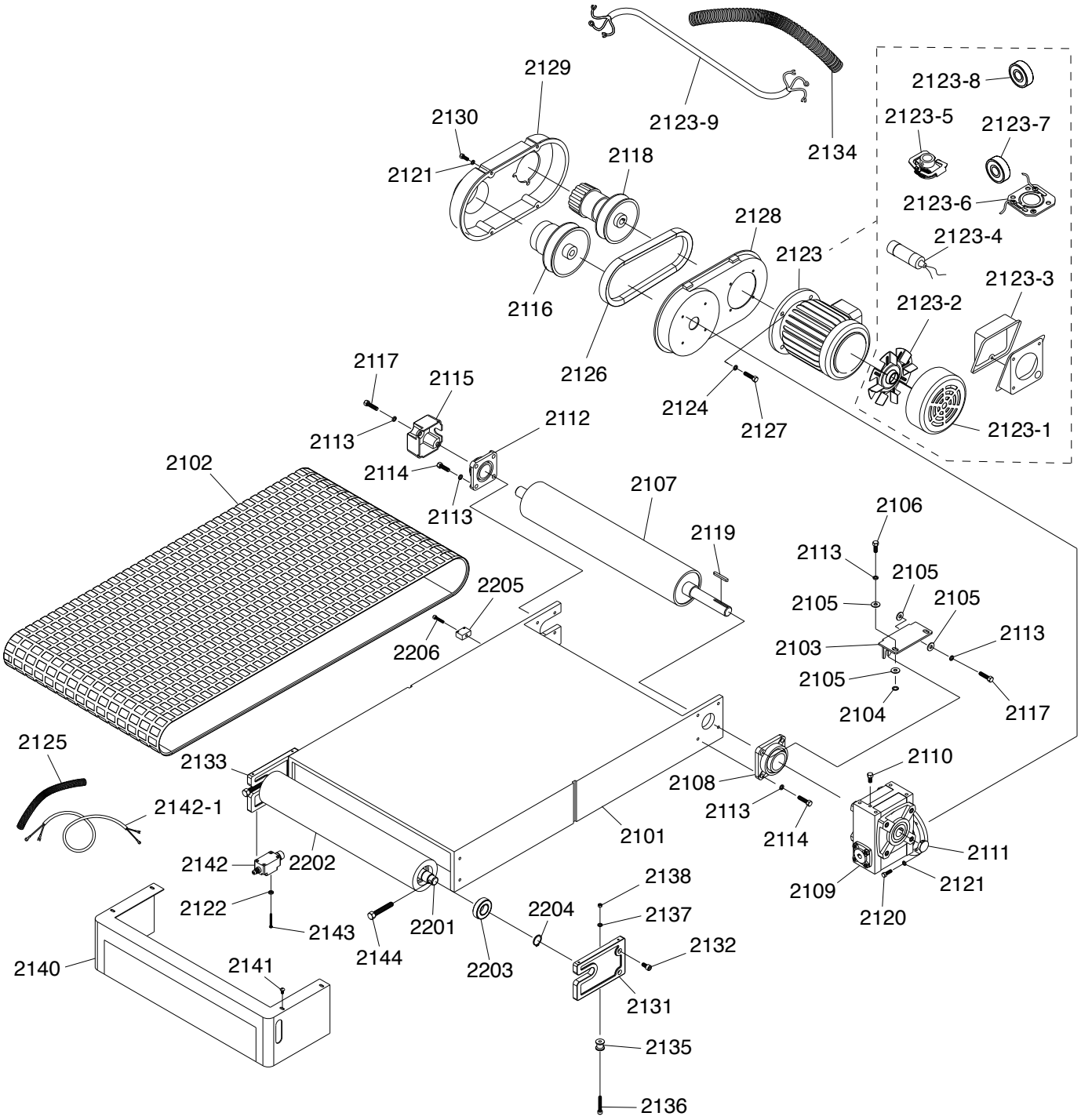
G0411 Table Elevation Parts List

REF	PART #	DESCRIPTION
1101	P04111101	LEADSCREW W/FLANGE
1102	P04111102	HEX BOLT 5/16-18 X 1
1103	P04111103	FLAT WASHER 5/16
1104	P04111104	LOCK WASHER 5/16
1105	P04111105	LOCK WASHER 3/8
1106	P04111106	HEX BOLT 3/8-16 X 1
1107	P04111107	TABLE GUIDE
1108	P04111108	DUST BELLOW
1109	P04111109	HEX BOLT 5/16-18 X 3/4
1110	P04111110	LOCK WASHER 5/16
1111	P04111111	ROLLER CHAIN #35 X 380"
1201	P04111201	LEADSCREW NUT HOUSING
1202	P04111202	LEADSCREW NUT
1203	P04111203	THRUST BEARING 51107
1204	P04111204	EXT RETAINING RING 35MM
1206	P04111206	SPROCKET
1301	P04111301	ELEVATION GEARBOX
1302	P04111302	WORM GEAR SHAFT 20T 45 X 83MM
1303	P04111303	BALL BEARING 6005Z
1304	P04111304	BEARING CAP
1305	P04111305	CAP SCREW 1/4-20 X 3/4
1306	P04111306	WORM SHAFT
1307	P04111307	BALL BEARING 6002Z
1308	P04111308	BEARING CAP
1309	P04111309	CAP SCREW 10-24 X 5/8
1310	P04111310	HANDWHEEL BEARING CAP
1311	P04111311	CAP SCREW 1/4-20 X 5/8
1312	P04111312	SPROCKET 24T
1313	P04111313	SET SCREW 5/16-18 X 1/2
1314	P04111314	TABLE PULLEY
1315	P04111315	V-BELT A34
1316	P04111316	MOTOR PULLEY
1317	P04111317	SET SCREW 1/4-20 X 1/2
1318	P04111318	LOCK WASHER 5/16
1319	P04111319	HEX BOLT 5/16-18 X 3/4
1320	P04111320	SET SCREW 1/4-20 X 1/2
1321	P04111321	HANDWHEEL

REF	PART #	DESCRIPTION
1322	P04111322	MOTOR MOUNTING PLATE
1323	P04111323	HEX BOLT 1/4-20 X 1
1324	P04111324	LOCK WASHER 1/4
1325	P04111325	BELT TENSION ADJUSTMENT ROD
1326	P04111326	FENDER WASHER 1/2
1327	P04111327	HEX NUT 1/2-12
1328	P04111328	LOCK WASHER 1/2
1329	P04111329	FLAT WASHER 1/4
1331	P04111331	MOTOR 1/4HP 220V/440V 3-PH
1331-1	P04111331-1	MOTOR FAN
1331-2	P04111331-2	MOTOR FAN COVER
1331-3	P04111331-3	MOTOR JUNCTION BOX
1331-4	P04111331-4	BALL BEARING 6201ZZ
1331-5	P04111331-5	CORD 16G 4W 39"
1332	P04111332	HEX NUT 1/4-20
1333	P04111333	HEX BOLT 1/2-12 X 4-1/2
1334	P04111334	SENSOR MOUNT
1335	P04111335	HEX BOLT 1/4-20 X 1/2
1336	P04111336	TABLE SENSOR W/CORD ETEK PL-05NB-S
1337	P04111337	PHLP HD SCR M3-.5 X 30
1338	P04111338	HEX NUT M3-.5
1339	P04111339	KEY 8 X 8 X 20 RE
1340	P04111340	KEY 4 X 4 X 20 RE
1341	P04111341	KEY 4 X 4 X 16 RE
1342	P04111342	CONDUIT 3/8" X 1/2"
1343	P04111343	CONDUIT 3/8" X 1/2"
1401	P04111401	CHAIN TENSION BLOCK
1402	P04111402	SPROCKET SHAFT
1403	P04111403	BALL BEARING 6003ZZ
1404	P04111404	SPROCKET 20T
1405	P04111405	TENSION ADJUSTMENT ROD
1406	P04111406	FLAT WASHER 3/8
1407	P04111407	HEX NUT 3/8-16
1408	P04111408	HEX NUT 5/16-18
1409	P04111409	LOCK WASHER 5/16
1410	P04111410	HEX BOLT 5/16-18 X 3/4

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G0408/G0409 Conveyor Table



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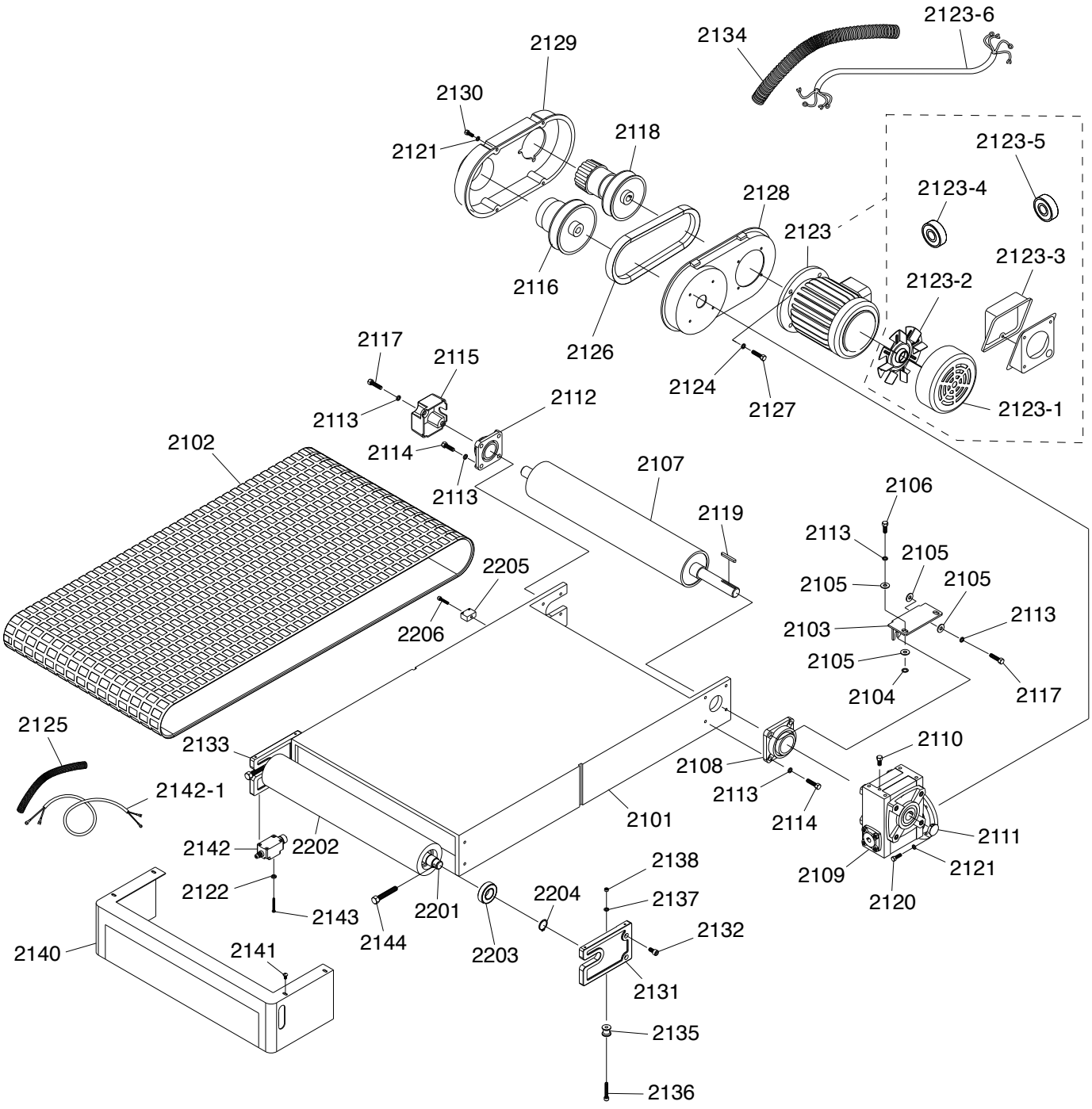
G0408/G0409 Conveyor Table Parts List

REF	PART #	DESCRIPTION
2101	P04082101	CONVEYOR TABLE (G0408)
2101	P04092101	CONVEYOR TABLE (G0409)
2102	P04082102	CONVEYOR BELT 24-3/8" X 82-11/16" (G0408)
2102	P04092102	CONVEYOR BELT 36-1/2" X 82-11/16" (G0409)
2103	P04082103	GEARBOX MOUNTING BRACKET
2104	P04082104	CUSHION 10 X 2MM (G0408)
2104	P04092104	CUSHION 10 X 13 X 1.5MM (G0409)
2105	P04082105	FLAT WASHER 10MM
2106	P04082106	HEX BOLT M10-1.5 X 25
2107	P04082107	OUTFEED ROLLER (G0408)
2107	P04092107	OUTFEED ROLLER (G0409)
2108	P04082108	FLANGE BEARING UCF205
2109	P04082109	GEARBOX REDUCER
2110	P04082110	PLUG BOLT 3/8-16 X 1/2 (G0408)
2110	P04092110	PLUG BOLT 1/4-20 X 3/8 (G0409)
2111	P04082111	GEARBOX PLUG
2112	P04082112	FLANGE BEARING UCF205
2113	P04082113	LOCK WASHER 10MM
2114	P04082114	HEX BOLT 3/8-16 X 1-1/4
2115	P04082115	BEARING COVER
2116	P04082116	IDLER PULLEY
2117	P04082117	HEX BOLT 3/8-16 X 1-1/2
2118	P04082118	DRIVE PULLEY
2119	P04082119	KEY 8 X 7 X 55 RE
2120	P04082120	HEX BOLT M8-1.25 X 20
2121	P04082121	LOCK WASHER 8MM
2122	P04082122	LOCK WASHER #10
2123	P04082123	MOTOR 1HP 220V 1-PH
2123-1	P04082123-1	MOTOR FAN COVER
2123-2	P04082123-2	MOTOR FAN
2123-3	P04082123-3	JUNCTION BOX
2123-4	P04082123-4	S CAPACITOR 300M 250V
2123-5	P04082123-5	CENTRIFUGAL SWITCH 11/16"
2123-6	P04082123-6	CONTACT PLATE 42 X 60MM INT
2123-7	P04082123-7	BALL BEARING 6205-2RS (FRONT)

REF	PART #	DESCRIPTION
2123-8	P04082123-8	BALL BEARING 6204-2RS (REAR)
2123-9	P04082123-9	CORD 18G 4W 79" (G0408)
2123-9	P04092123-9	CORD 16G 4W (G0409)
2124	P04082124	LOCK WASHER 10MM
2125	P04082125	CONDUIT 3/8" X 1/2" X 48" (G0408)
2125	P04092125	CONDUIT 3/8" X 1/2" (G0409)
2126	P04082126	TIMING BELT 1422V-290
2127	P04082127	HEX BOLT M10-1.5 X 25
2128	P04082128	SPEED UNIT BASE PLATE
2129	P04082129	SPEED UNIT COVER
2130	P04082130	HEX BOLT M8-1.25 X 20
2131	P04082131	INFEED ROLLER BRACKET R
2132	P04082132	CAP SCREW 3/8-16 X 3/4
2133	P04082133	INFEED ROLLER BRACKET L
2134	P04082134	CONDUIT 3/8" X 1/2" X 59" (G0408)
2134	P04092134	CONDUIT 3/8" X 1/2" (G0409)
2135	P04082135	GUIDE WHEEL
2136	P04082136	CAP SCREW 5/16-18 X 2
2137	P04082137	LOCK WASHER 5/16
2138	P04082138	HEX NUT 5/16-18
2140	P04082140	EMERGENCY STOP BAR ASSEMBLY (G0408)
2140	G04092140	EMERGENCY STOP BAR ASSEMBLY (G0409)
2141	P04082141	PHLP HD SCR 1/4-20 X 1/2
2142	P04082142	LIMIT SWITCH TEND TZ-5101
2142-1	P04082142-1	CORD 20G 2W 59" (G0408)
2142-1	P04092142-1	CORD 20G 2W (G0409)
2143	P04082143	PHLP HD SCR 10-24 X 1-1/2
2144	P04082144	HEX BOLT 1/2-13 X 3
2201	P04082201	INFEED ROLLER SHAFT
2202	P04082202	INFEED ROLLER (G0408)
2202	G04092202	INFEED ROLLER (G0409)
2203	P04082203	BALL BEARING 6206ZZ
2204	P04082204	EXT RETAINING RING 30MM
2205	P04082205	ELEVATION STOP BLOCK
2206	P04082206	CAP SCREW 1/4-20 X 1-1/2

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G0411 Conveyor Table



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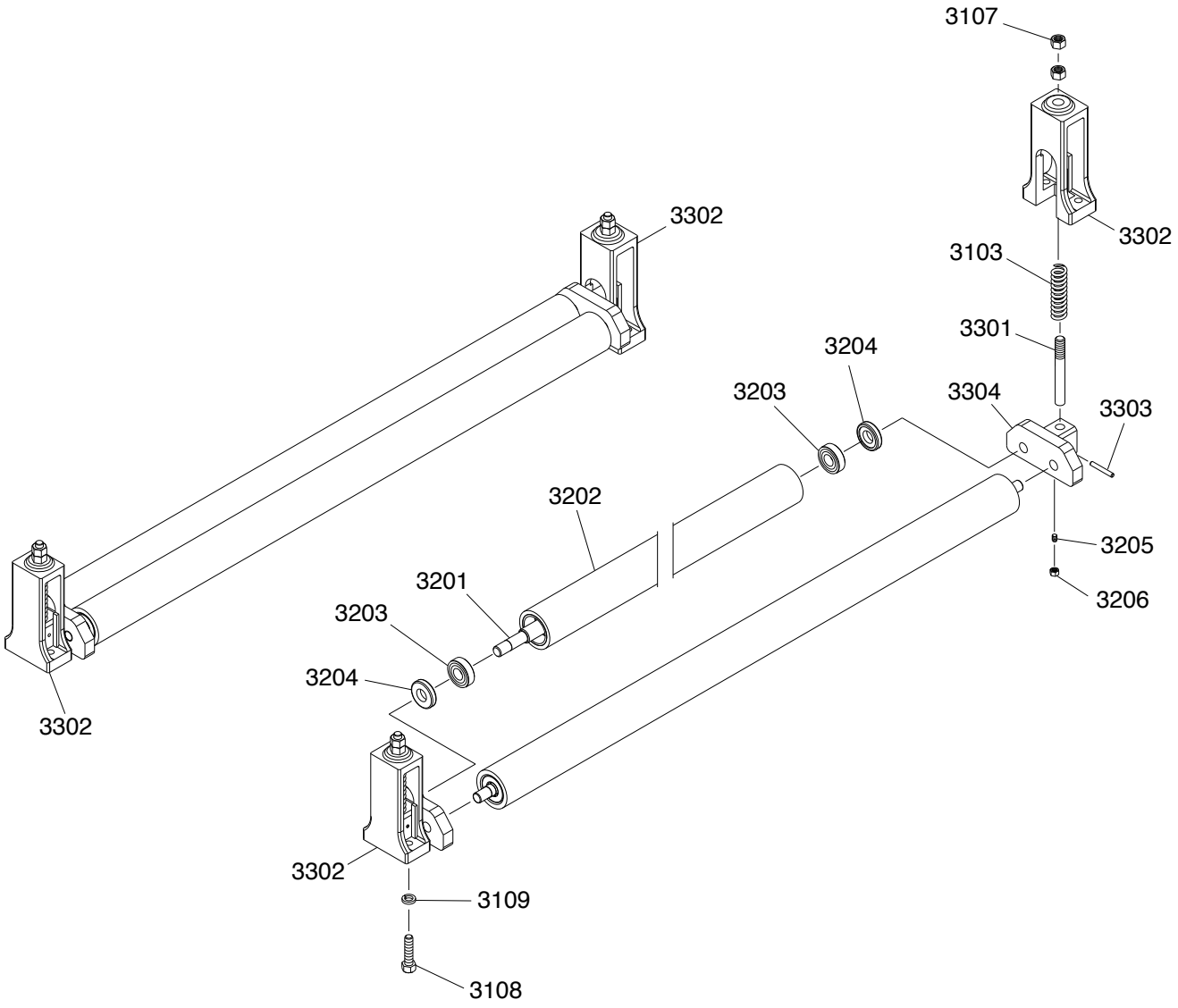
G0411 Conveyor Table Parts List

REF	PART #	DESCRIPTION
2101	P04112101	CONVEYOR TABLE
2102	P04112102	CONVEYOR BELT 51-3/16" X 78-3/4"
2103	P04112103	GEARBOX MOUNTING BRACKET
2104	P04112104	CUSHION 10 X 2MM
2105	P04112105	FLAT WASHER 10MM
2106	P04112106	HEX BOLT M10-1.5 X 25
2107	P04112107	OUTFEED ROLLER
2108	P04112108	FLANGE BEARING UCF205
2109	P04112109	GEARBOX REDUCER
2110	P04112110	PLUG BOLT 1/4-20 X 3/8
2111	P04112111	GEARBOX PLUG 30MM
2112	P04112112	FLANGE BEARING UCF205
2113	P04112113	LOCK WASHER 10MM
2114	P04112114	HEX BOLT 3/8-16 X 1-1/4
2115	P04112115	BEARING COVER
2116	P04112116	IDLER PULLEY
2117	P04112117	HEX BOLT 3/8-16 X 1-1/2
2118	P04112118	DRIVE PULLEY
2119	P04112119	KEY 8 X 7 X 55 RE
2120	P04112120	HEX BOLT M8-1.25 X 20
2121	P04112121	LOCK WASHER 8MM
2122	P04112122	LOCK WASHER #10
2123	P04112123	MOTOR 2HP 220V/440V 3-PH
2123-1	P04112123-1	MOTOR FAN COVER
2123-2	P04112123-2	MOTOR FAN
2123-3	P04112123-3	JUNCTION BOX
2123-4	P04112123-4	BALL BEARING 6203ZZ (FRONT)
2123-5	P04112123-5	BALL BEARING 6204ZZ (REAR)

REF	PART #	DESCRIPTION
2123-6	P04112123-6	CORD 16G 4W 98"
2124	P04112124	LOCK WASHER 10MM
2125	P04112125	CONDUIT 3/8" X 1/2" X 48"
2126	P04112126	TIMING BELT 1422V-290
2127	P04112127	HEX BOLT M10-1.5 X 25
2128	P04112128	SPEED UNIT BASE PLATE
2129	P04112129	SPEED UNIT COVER
2130	P04112130	HEX BOLT M8-1.25 X 20
2131	P04112131	INFEED ROLLER BRACKET R
2132	P04112132	CAP SCREW 3/8-16 X 3/4
2133	P04112133	INFEED ROLLER BRACKET L
2134	P04112134	CONDUIT 3/8" X 1/2" X 87"
2135	P04112135	GUIDE WHEEL
2136	P04112136	CAP SCREW 5/16-18 X 2
2137	P04112137	LOCK WASHER 5/16
2138	P04112138	HEX NUT 5/16-18
2140	P04112140	EMERGENCY STOP BAR ASSEMBLY
2141	P04112141	PHLP HD SCR 1/4-20 X 1/2
2142	P04112142	LIMIT SWITCH TEND TZ-5101
2142-1	P04112142-1	CORD 20G 2W 59"
2143	P04112143	PHLP HD SCR 10-24 X 1-1/2
2144	P04112144	HEX BOLT 1/2-13 X 3
2201	P04112201	INFEED ROLLER SHAFT
2202	P04112202	INFEED ROLLER
2203	P04112203	BALL BEARING 6206ZZ
2204	P04112204	EXT RETAINING RING 30MM
2205	P04112205	ELEVATION STOP BLOCK
2206	P04112206	CAP SCREW 1/4-20 X 1-1/2

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G0408 Pressure Rollers

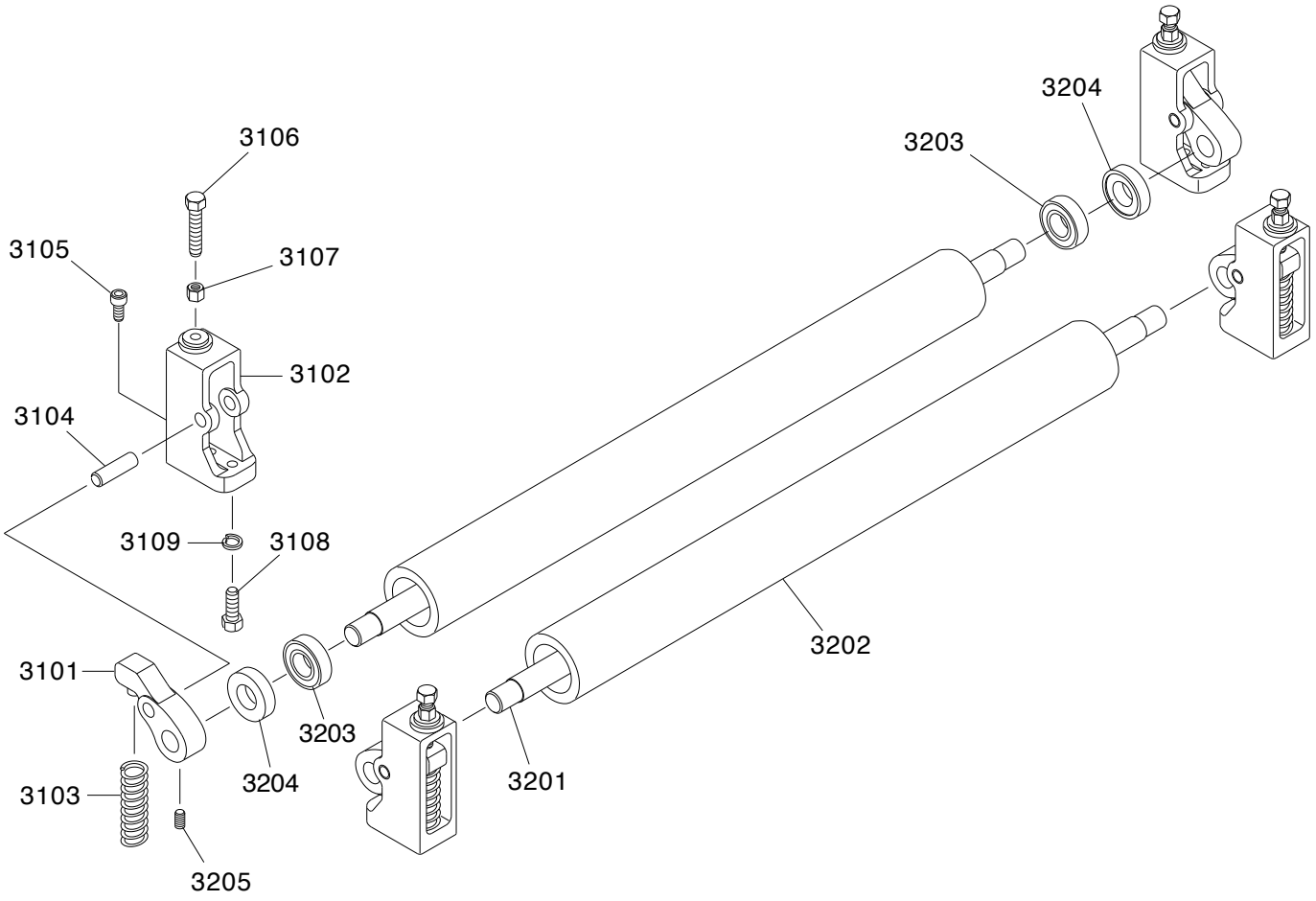


REF	PART #	DESCRIPTION
3103	P04083103	COMPRESSION SPRING 2 X 16 X 60
3107	P04083107	HEX NUT 3/8-16
3108	P04083108	HEX BOLT 5/16-18 X 1-1/4
3109	P04083109	LOCK WASHER 5/16
3201	P04083201	PRESSURE ROLLER SHAFT
3202	P04083202	PRESSURE ROLLER
3203	P04083203	BALL BEARING 6001ZZ

REF	PART #	DESCRIPTION
3204	P04083204	BEARING COLLAR
3205	P04083205	SET SCREW 1/4-20 X 3/4
3206	P04083206	HEX NUT 1/4-20
3301	P04083301	STUD-SE 3/8-16 X 4-5/16, 1-1/4
3302	P04083302	ROLLER ADJUSTMENT BRACKET
3303	P04083303	ROLL PIN 3 X 28
3304	P04083304	PRESSURE ROLLER MOUNT

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G0409/G0411 Pressure Rollers

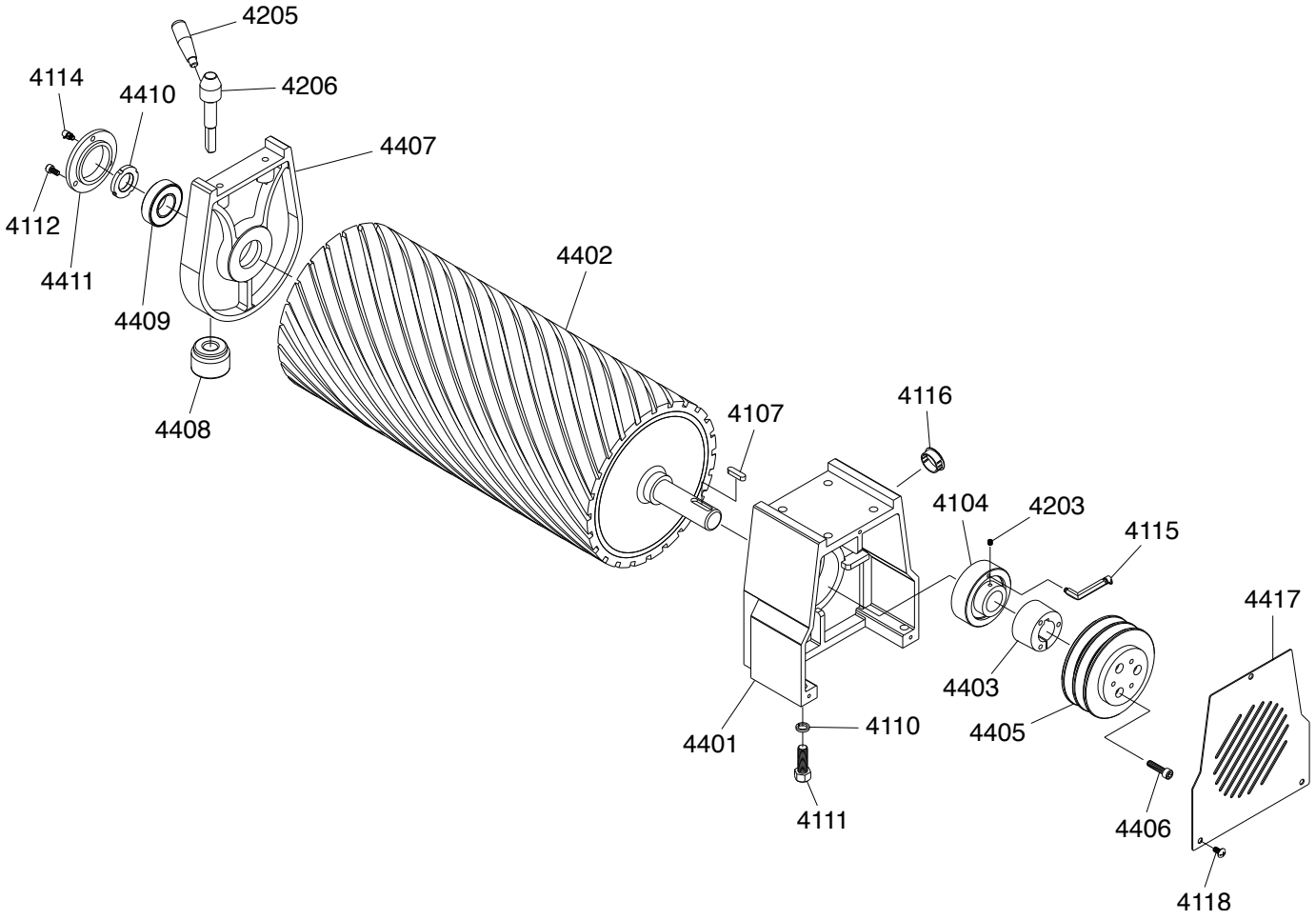


REF	PART #	DESCRIPTION
3101	P04093101	OUTER PISTON BRACKET
3102	P04093102	INNER PISTON BRACKET
3103	P04093103	COMPRESSION SPRING 3 X 15.7 X 57MM
3104	P04093104	DOWEL PIN 10 X 35MM
3105	P04093105	CAP SCREW 1/4-20 X 1/2
3106	P04093106	HEX BOLT 5/16-18 X 1-1/2
3107	P04093107	HEX NUT 5/16-18
3108	P04093108	HEX BOLT 5/16-18 X 1-1/4

REF	PART #	DESCRIPTION
3109	P04093109	LOCK WASHER 5/16
3201	P04093201	PRESSURE ROLLER SHAFT (G0409)
3201	P04113201	PRESSURE ROLLER SHAFT (G0411)
3202	P04093202	PRESSURE ROLLER (G0409)
3202	P04113202	PRESSURE ROLLER (G0411)
3203	P04093203	BALL BEARING 6003-2RS
3204	P04093204	SHAFT BEARING COLLAR
3205	P04093205	SET SCREW 1/4-20 X 3/8

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G0408 Sanding Drum

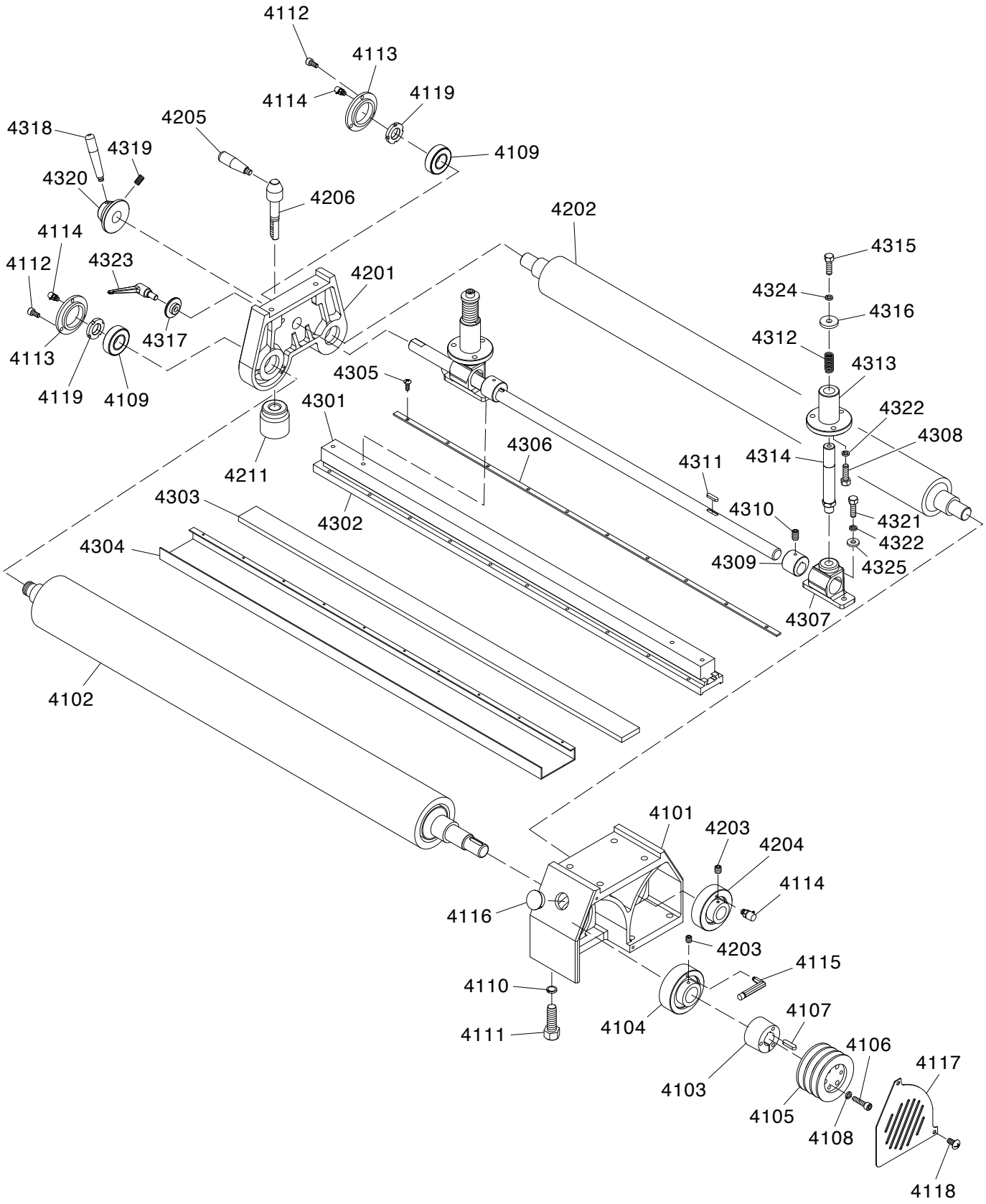


REF	PART #	DESCRIPTION
4104	P04084104	CARTRIDGE BEARING UCC206
4107	P04084107	KEY 8 X 8 X 30 RE
4110	P04084110	LOCK WASHER 1/2
4111	P04084111	HEX BOLT 1/2-12 X 1-1/2
4112	P04084112	CAP SCREW 1/4-20 X 1/2
4114	P04084114	GREASE FITTING 1/4"-28 SAE STRAIGHT
4115	P04084115	GREASE FITTING EXT 1/4"-28 SAE 90-DEG
4116	P04084116	BEARING HOUSING PLUG 30MM
4118	P04084118	PHLP HD SCR 1/4-20 X 1/4
4203	P04084203	SET SCREW M6-1 X 6
4205	P04084205	FIXED HANDLE 10-1.5 X 10
4206	P04084206	HANDLE SCREW M16-2 X 45

REF	PART #	DESCRIPTION
4401	P04084401	BEARING HOUSING R
4402	P04084402	SANDING DRUM
4403	P04084403	LOCK COLLAR
4405	P04084405	DRUM PULLEY
4406	P04084406	CAP SCREW 5/16-18 X 1-1/4
4407	P04084407	BEARING HOUSING L
4408	P04084408	STOP BLOCK
4409	P04084409	BALL BEARING 6206-2RS
4410	P04084410	SPANNER NUT M25-1.5
4411	P04084411	BEARING COVER
4417	P04084417	PULLEY COVER

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G0409 Sanding Drums



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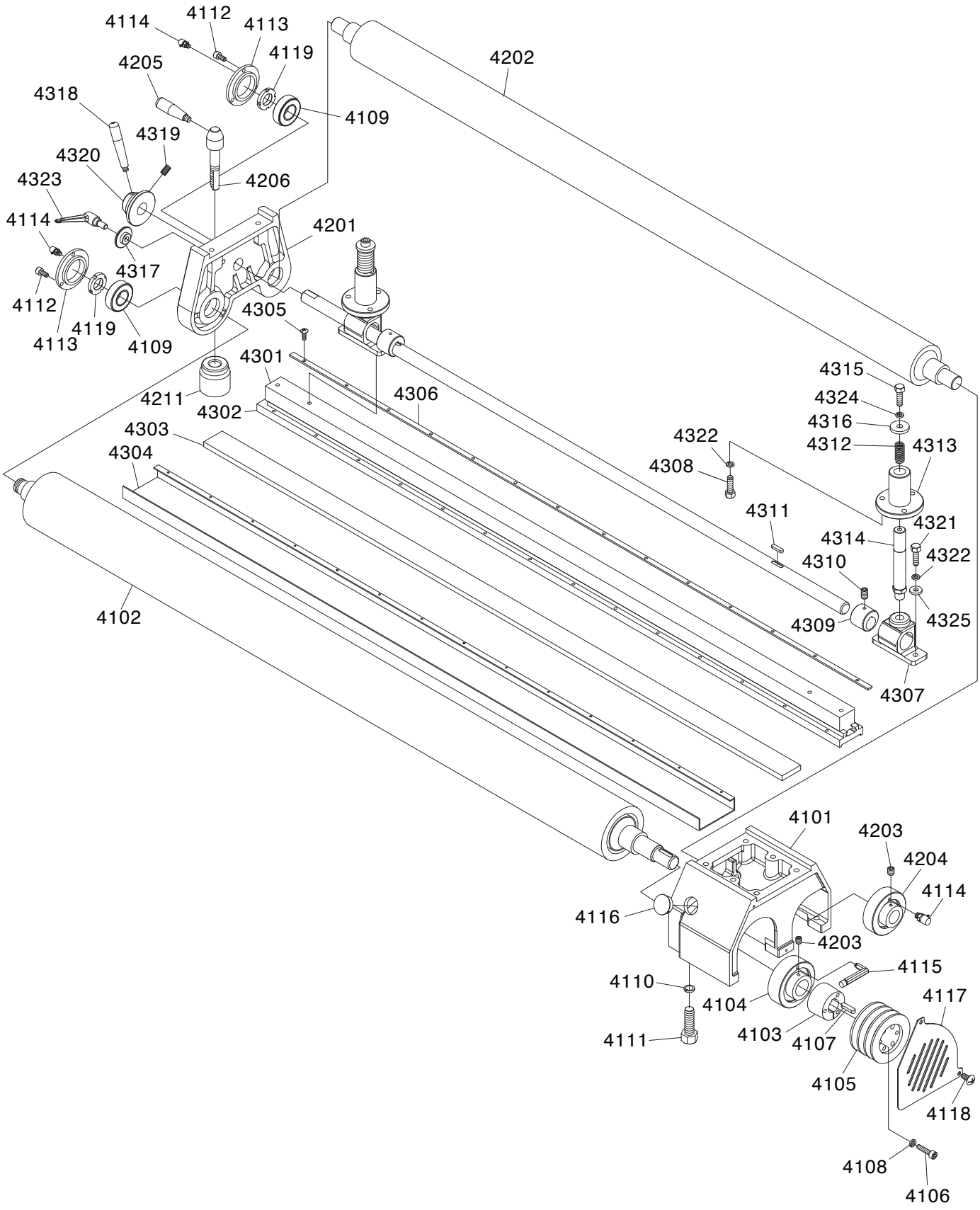
G0409 Sanding Drums Parts List

REF	PART #	DESCRIPTION
4101	P04094101	BEARING HOUSING R
4102	P04094102	DRUM RUBBER
4103	P04094103	LOCK COLLAR
4104	P04094104	CARTRIDGE BEARING UCC206
4105	P04094105	DRUM PULLEY
4106	P04094106	CAP SCREW 5/16-18 X 1-1/4
4107	P04094107	KEY 8 X 8 X 30 RE
4108	P04094108	LOCK WASHER 5/16
4109	P04094109	BALL BEARING 6205-2RS
4110	P04094110	LOCK WASHER 1/2
4111	P04094111	HEX BOLT 1/2-12 X 1-1/2
4112	P04094112	CAP SCREW 1/4-20 X 1/2
4113	P04094113	DRUM BEARING CAP
4114	P04094114	GREASE FITTING 1/4"-28 SAE STRAIGHT
4115	P04094115	GREASE FITTING EXT 1/4"-28 SAE 90-DEG
4116	P04094116	PLUG
4117	P04094117	V-BELT COVER
4118	P04094118	PHLP HD SCR 1/4-20 X 1/4
4119	P04094119	SPANNER NUT M25
4201	P04094201	BEARING HOUSING L
4202	P04094202	DRUM STEEL
4203	P04094203	SET SCREW M6-1 X 6
4204	P04094204	CARTRIDGE BEARING UCC205
4205	P04094205	HANDLE 3/8-16
4206	P04094206	HANDLE SCREW
4211	P04094211	STOP BLOCK

REF	PART #	DESCRIPTION
4301	P04094301	PLATEN RAIL MALE
4302	P04094302	PLATEN FEMALE
4303	P04094303	FELT PAD 3/8" X 1-3/4" X 37-13/16"
4304	P04094304	GRAPHITE PAD 3-1/2" X 38-3/16"
4305	P04094305	PHLP HD SCR 10-24 X 1/2
4306	P04094306	PRESSURE PLATE
4307	P04094307	PLATEN BRACKET
4308	P04094308	HEX BOLT 5/16-18 X 3/4
4309	P04094309	LOCK COLLAR
4310	P04094310	SET SCREW 1/4-20 X 3/8
4311	P04094311	KEY 1/4 X 1/4 X 1 RE
4312	P04094312	COMPRESSION SPRING 3 X 27 X 60
4313	P04094313	PLATEN HEIGHT FLANGE
4314	P04094314	PLATEN HEIGHT SHAFT
4315	P04094315	HEX BOLT 3/8-16 X 3/4
4316	P04094316	FLAT WASHER 3/8
4317	P04094317	FLANGE BUSHING
4318	P04094318	HANDLE
4319	P04094319	SET SCREW 5/16-18 X 1/2
4320	P04094320	GRADUATED COLLAR
4321	P04094321	HEX BOLT 5/16-18 X 1
4322	P04094322	LOCK WASHER 5/16
4323	P04094323	ADJUSTABLE HANDLE
4324	P04094324	LOCK WASHER 3/8
4325	P04094325	FLAT WASHER 5/16

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G0411 Sanding Drums



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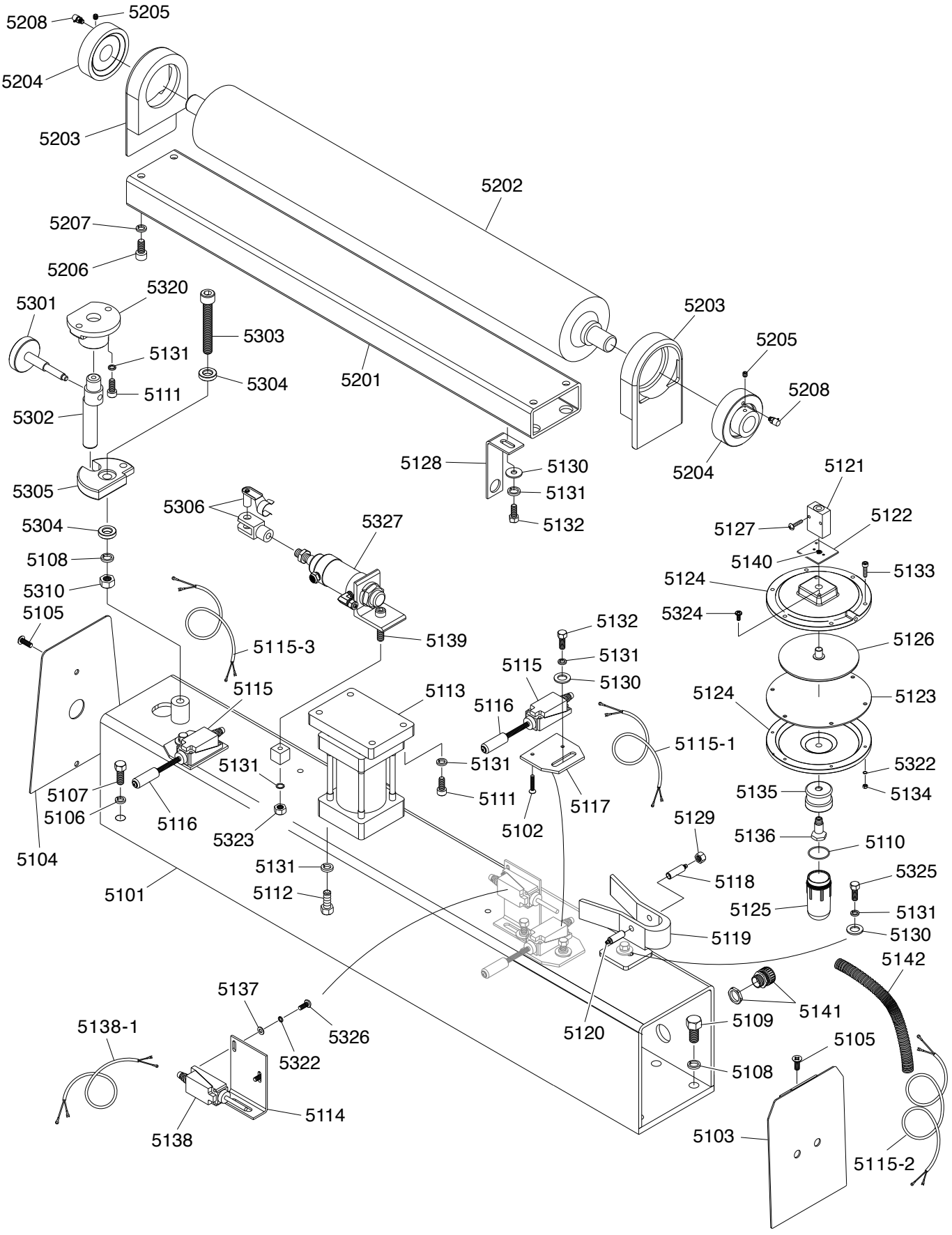
G0411 Sanding Drums Parts List

REF	PART #	DESCRIPTION
4101	P04114101	BEARING HOUSING R
4102	P04114102	DRUM RUBBER
4103	P04114103	LOCK COLLAR
4104	P04114104	CARTRIDGE BEARING UCC206
4105	P04114105	DRUM PULLEY
4106	P04114106	CAP SCREW 5/16-18 X 1-1/4
4107	P04114107	KEY 8 X 8 X 30 RE
4108	P04114108	LOCK WASHER 5/16
4109	P04114109	BALL BEARING 6205-2RS
4110	P04114110	LOCK WASHER 1/2
4111	P04114111	HEX BOLT 1/2-13 X 1-1/2
4112	P04114112	CAP SCREW 1/4-20 X 1/2
4113	P04114113	DRUM BEARING CAP
4114	P04114114	GREASE FITTING 1/4"-28 SAE STRAIGHT
4115	P04114115	GREASE FITTING EXT 1/4"-28 SAE 90-DEG
4116	P04114116	PLUG 30MM
4117	P04114117	V-BELT COVER
4118	P04114118	PHLP HD SCR 1/4-20 X 3/8
4119	P04114119	SPANNER NUT M25
4201	P04114201	BEARING HOUSING L
4202	P04114202	DRUM STEEL
4203	P04114203	SET SCREW M6-1 X 6
4204	P04114204	CARTRIDGE BEARING UCC205
4205	P04114205	HANDLE
4206	P04114206	HANDLE SCREW
4211	P04114211	STOP BLOCK

REF	PART #	DESCRIPTION
4301	P04114301	PLATEN RAIL MALE
4302	P04114302	PLATEN FEMALE
4303	P04114303	FELT PAD 3/8" X 1-3/4" X 52-1/8"
4304	P04114304	GRAPHITE PAD 3-1/2" X 52-5/16"
4305	P04114305	PHLP HD SCR 10-24 X 1/2
4306	P04114306	PRESSURE PLATE
4307	P04114307	PLATEN BRACKET
4308	P04114308	HEX BOLT 5/16-18 X 3/4
4309	P04114309	LOCK COLLAR
4310	P04114310	SET SCREW 1/4-20 X 3/8
4311	P04114311	KEY 1/4 X 1/4 X 1 RE
4312	P04114312	COMPRESSION SPRING 3 X 27 X 60
4313	P04114313	PLATEN HEIGHT FLANGE
4314	P04114314	PLATEN HEIGHT SHAFT
4315	P04114315	HEX BOLT 3/8-16 X 3/4
4316	P04114316	FLAT WASHER 3/8
4317	P04114317	FLANGE BUSHING
4318	P04114318	HANDLE
4319	P04114319	SET SCREW 5/16-18 X 1/2
4320	P04114320	GRADUATED COLLAR
4321	P04114321	HEX BOLT 5/16-18 X 1
4322	P04114322	LOCK WASHER 5/16
4323	P04114323	ADJUSTABLE HANDLE
4324	P04114324	LOCK WASHER 3/8
4325	P04114325	FLAT WASHER 5/16

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G0408/G0409 Upper Roller



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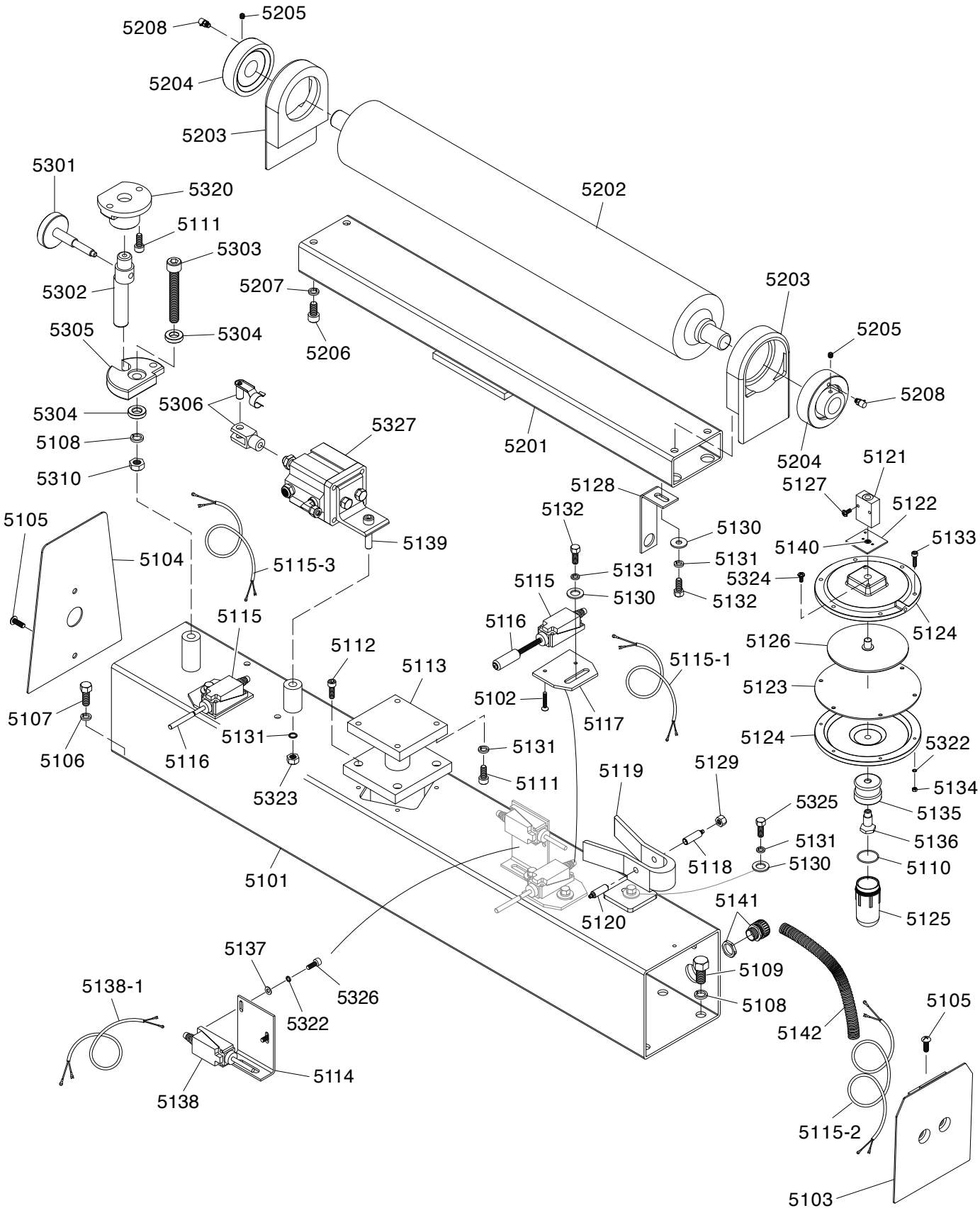
G0408/G0409 Upper Roller Parts List

REF	PART #	DESCRIPTION
5101	P04085101	SQUARE FRAME (G0408)
5101	P04095101	SQUARE FRAME (G0409)
5102	P04085102	FLAT HD SCR 1/4-20 X 1/2 (G0408)
5102	P04095102	FLAT HD SCR M4-.8 X 8 (G0409)
5103	P04085103	SQUARE FRAME COVER R
5104	P04085104	SQUARE FRAME COVER L
5105	P04085105	FLAT HD SCR 1/4-20 X 1/2
5106	P04085106	LOCK WASHER 3/8
5107	P04085107	HEX BOLT 3/8-16 X 1
5108	P04085108	LOCK WASHER 1/2
5109	P04085109	HEX BOLT 1/2-12 X 1
5110	P04085110	O-RING 26.7 X 1.78
5111	P04085111	CAP SCREW 5/16-18 X 3/4
5112	P04085112	HEX BOLT M8-1.25 X 20
5113	P04085113	BELT TENSION AIR CYLINDER
5114	P04085114	LIMIT SWITCH MOUNTING BRACKET
5115	P04085115	LIMIT SWITCH MOUJEN ME-8166
5115-1	P04085115-1	CORD 20G 2W 36" (G0408)
5115-1	P04095115-1	CORD 20G 2W (G0409)
5115-2	P04085115-2	CORD 20G 2W 118" (G0408)
5115-2	P04095115-2	CORD 20G 2W (G0409)
5115-3	P04085115-3	CORD 20G 2W 36" (G0408)
5115-3	P04095115-3	CORD 20G 2W (G0409)
5116	P04085116	LIMIT SWITCH CERAMIC TIP
5117	P04085117	LIMIT SWITCH MOUNT
5118	P04085118	AIR SENSOR NOZZLE FEMALE
5119	P04085119	AIR FORK
5120	P04085120	AIR SENSOR NOZZLE MALE
5121	P04085121	THROTTLE VALVE
5122	P04085122	THROTTLE VALVE BASE
5123	P04085123	DIAPHRAGM
5124	P04085124	DISC HOUSING ALUMINUM
5125	P04085125	DUST TRAP BOWL
5126	P04085126	PLATE ALUMINUM
5127	P04085127	PHLP HD SCR M4-.7 X 20
5128	P04085128	LIMIT SWITCH SHUTDOWN BRACKET
5129	P04085129	HEX NUT 3/8-24
5130	P04085130	FLAT WASHER 5/16
5131	P04085131	LOCK WASHER 5/16

REF	PART #	DESCRIPTION
5132	P04085132	HEX BOLT 5/16-18 X 3/4
5133	P04085133	CAP SCREW 10-24 X 3/4
5134	P04085134	HEX NUT 10-24
5135	P04085135	DUST TRAP CONNECTOR
5136	P04085136	DUST TRAP SHAFT
5137	P04085137	FLAT WASHER #10
5138	P04085138	LIMIT SWITCH MOUJEN ME-8166
5138-1	P04085138-1	CORD 20G 2W 39" (G0408)
5138-1	P04095138-1	CORD 20G 2W (G0409)
5139	P04085139	CAP SCREW 5/16-18 X 2-1/4
5140	P04085140	PHLP HD SCR M4-.7 X 20
5141	P04085141	STRAIN RELIEF 3/4 KO
5142	P04085142	CONDUIT 3/4" X 15/16" X 79" (G0408)
5142	P04095142	CONDUIT 3/4" X 15/16" (G0409)
5201	P04085201	ROLLER BEAM (G0408)
5201	P04095201	ROLLER BEAM (G0409)
5202	P04085202	UPPER ROLLER (G0408)
5202	P04095202	UPPER ROLLER (G0409)
5203	P04085203	UPPER ROLLER BRACKET
5204	P04085204	CARTRIDGE BEARING UCC205
5205	P04085205	SET SCREW M6-1 X 6
5206	P04085206	CAP SCREW 3/8-16 X 3/4
5207	P04085207	LOCK WASHER 3/8
5208	P04085208	GREASE FITTING 1/4"-28 SAE STRAIGHT
5301	P04085301	OSCILLATION ADJUSTMENT KNOB
5302	P04085302	ECCENTRIC ROD
5303	P04085303	CAP SCREW 1/2-12 X 3-1/2
5304	P04085304	FLAT WASHER 1/2 (G0408)
5304	P04095304	SPACER 12 X 25 X 6MM (G0409)
5305	P04085305	ECCENTRIC CAM
5306	P04085306	UNIVERSAL JOINT FORK ASSEMBLY
5310	P04085310	HEX NUT 1/2-13
5320	P04085320	ECCENTRIC SHAFT FRAME
5322	P04085322	LOCK WASHER #10
5323	P04085323	HEX NUT 5/16-18
5324	P04085324	FLAT HD SCR M4-.7 X 12
5325	P04085325	HEX BOLT 5/16-18 X 3/4
5326	P04085326	PHLP HD SCR M5-.8 X 10
5327	P04085327	OSCILLATION AIR CYLINDER

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G0411 Upper Roller



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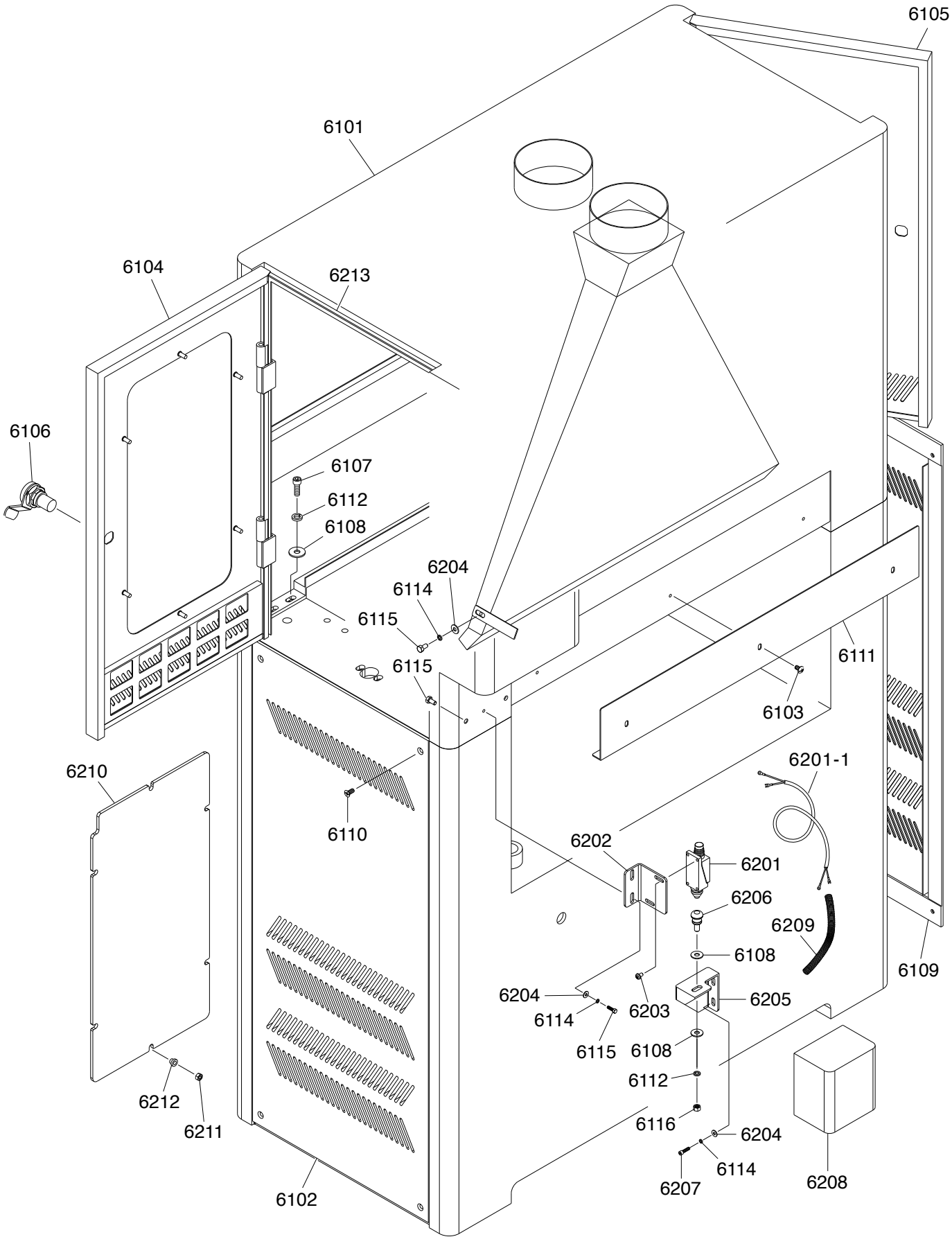
G0411 Upper Roller Parts List

REF	PART #	DESCRIPTION
5101	P04115101	SQUARE FRAME
5102	P04115102	FLAT HD SCR M5-.8 X 8
5103	P04115103	SQUARE FRAME COVER R
5104	P04115104	SQUARE FRAME COVER L
5105	P04115105	FLAT HD SCR 1/4-20 X 1/2
5106	P04115106	LOCK WASHER 3/8
5107	P04115107	HEX BOLT 3/8-16 X 1
5108	P04115108	LOCK WASHER 1/2
5109	P04115109	HEX BOLT 1/2-12 X 1
5110	P04115110	O-RING 26.7 X 1.78
5111	P04115111	CAP SCREW 5/16-18 X 3/4
5112	P04115112	CAP SCREW 5/16-18 X 1
5113	P04115113	BELT TENSION AIR CYLINDER
5114	P04115114	LIMIT SWITCH MOUNTING BRACKET
5115	P04115115	LIMIT SWITCH MOUJEN ME-8166
5115-1	P04115115-1	CORD 20G 2W
5115-2	P04115115-2	CORD 20G 2W
5115-3	P04115115-3	CORD 20G 2W
5116	P04115116	LIMIT SWITCH CERAMIC TIP
5117	P04115117	LIMIT SWITCH MOUNT
5118	P04115118	AIR SENSOR NOZZLE FEMALE
5119	P04115119	AIR FORK
5120	P04115120	AIR SENSOR NOZZLE MALE
5121	P04115121	THROTTLE VALVE
5122	P04115122	THROTTLE VALVE BASE
5123	P04115123	DIAPHRAGM
5124	P04115124	DISC HOUSING
5125	P04115125	DUST TRAP BOWL
5126	P04115126	PLATE ALUMINUM
5127	P04115127	PHLP HD SCR M4-.7 X 12
5128	P04115128	LIMIT SWITCH SHUTDOWN BRACKET
5129	P04115129	HEX NUT 3/8-24
5130	P04115130	FLAT WASHER 5/16
5131	P04115131	LOCK WASHER 5/16

REF	PART #	DESCRIPTION
5132	P04115132	HEX BOLT 5/16-18 X 1/2
5133	P04115133	CAP SCREW 10-24 X 3/4
5134	P04115134	HEX NUT 10-24
5135	P04115135	DUST TRAP CONNECTOR
5136	P04115136	DUST TRAP SHAFT
5137	P04115137	FLAT WASHER #10
5138	P04115138	LIMIT SWITCH MOUJEN ME-8166
5138-1	P04115138-1	CORD 20G 2W 39"
5139	P04115139	CAP SCREW 5/16-24 X 2
5140	P04115140	PHLP HD SCR M4-.7 X 12
5141	P04115141	STRAIN RELIEF 3/4 KO
5142	P04115142	CONDUIT 3/4" X 15/16" X 98"
5201	P04115201	ROLLER BEAM
5202	P04115202	UPPER ROLLER
5203	P04115203	UPPER ROLLER BRACKET
5204	P04115204	CARTRIDGE BEARING UCC205
5205	P04115205	SET SCREW M6-1 X 6
5206	P04115206	CAP SCREW 3/8-16 X 3/4
5207	P04115207	LOCK WASHER 3/8
5208	P04115208	GREASE FITTING 1/4"-28 SAE STRAIGHT
5301	P04115301	OSCILLATION ADJUSTMENT KNOB
5302	P04115302	ECCENTRIC ROD
5303	P04115303	CAP SCREW 1/2-12 X 3-1/2
5304	P04115304	SPACER 12 X 25 X 6MM
5305	P04115305	ECCENTRIC CAM
5306	P04115306	UNIVERSAL JOINT FORK ASSEMBLY
5310	P04115310	HEX NUT 1/2-12
5320	P04115320	ECCENTRIC SHAFT FRAME
5322	P04115322	LOCK WASHER #10
5323	P04115323	HEX NUT 5/16-18
5324	P04115324	PHLP HD SCR M4-.7 X 12
5325	P04115325	HEX BOLT 5/16-18 X 3/4
5326	P04115326	CAP SCREW M5-.8 X 10
5327	P04115327	OSCILLATION AIR CYLINDER

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G0408 Body



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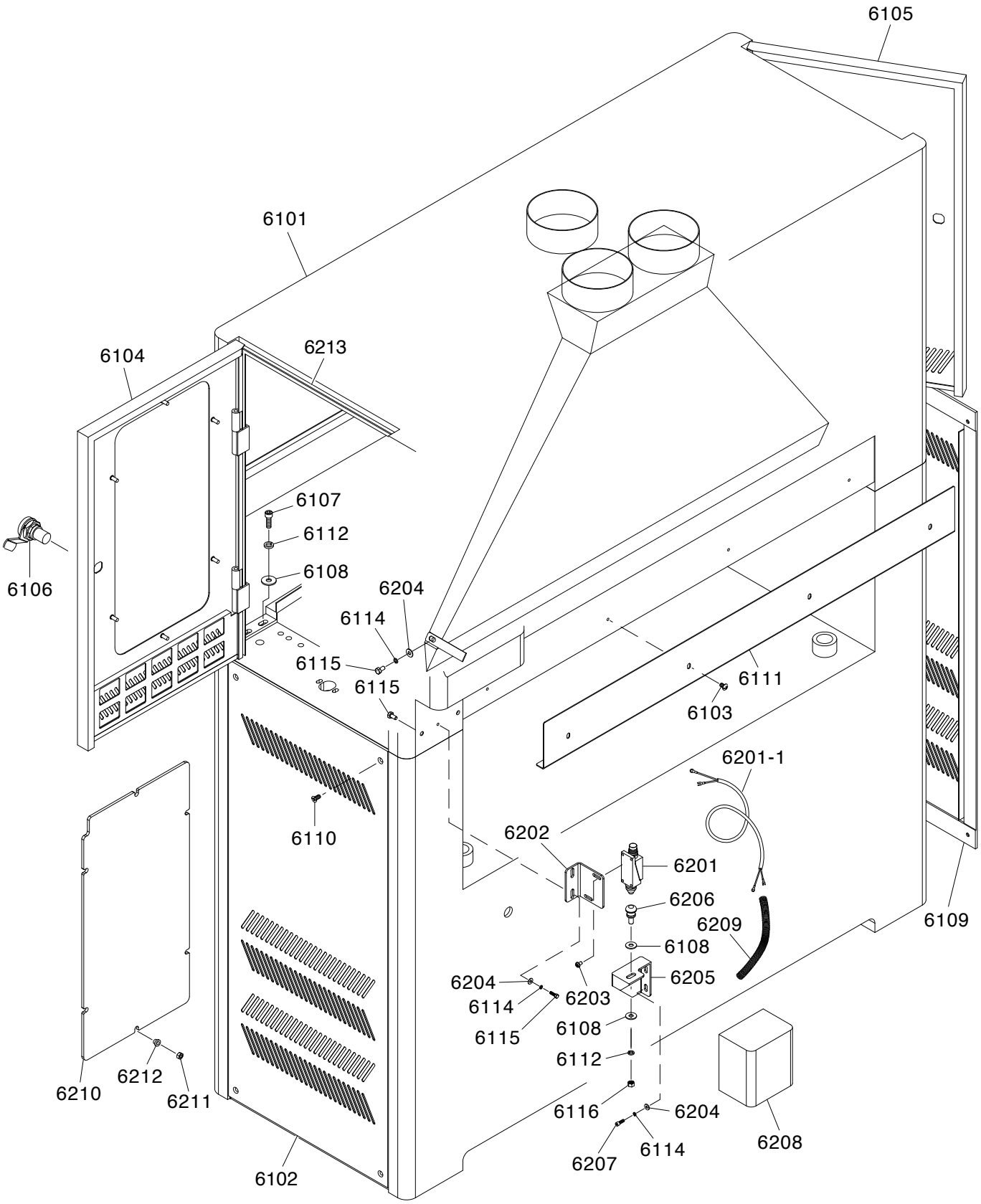
G0408 Body Parts List

REF	PART #	DESCRIPTION
6101	P04086101	UPPER FRAME COVER
6102	P04086102	ACCESS PANEL L
6103	P04086103	PHLP HD SCR M6-1 X 10
6104	P04086104	DOOR L
6105	P04086105	DOOR R
6106	P04086106	DOOR LOCK
6107	P04086107	CAP SCREW 5/16-18 X 3/4
6108	P04086108	FLAT WASHER 5/16
6109	P04086109	ACCESS PANEL R
6110	P04086110	FLAT HD SCR 1/4-20 X 1/2
6111	P04086111	DEPTH PLATE
6112	P04086112	LOCK WASHER 5/16
6114	P04086114	LOCK WASHER 1/4
6115	P04086115	HEX BOLT M6-1 X 16
6116	P04086116	HEX NUT 5/16-18

REF	PART #	DESCRIPTION
6201	P04086201	LIMIT SWITCH MOUJEN ME-8111
6201-1	P04086201-1	CORD 20G 2W 59"
6202	P04086202	LIMIT SWITCH MOUNT
6203	P04086203	PHLP HD SCR M5-.8 X 10
6204	P04086204	FLAT WASHER 1/4
6205	P04086205	PEG MOUNT
6206	P04086206	THICKNESS PEG 5/16-18 X 9/16
6207	P04086207	CAP SCREW 1/4-20 X 3/4
6208	P04086208	SENSOR COVER
6209	P04086209	CONDUIT 1/4" X 5/16" X 12"
6210	P04086210	PLEXIGLASS 20-3/8 X 10-3/8 X 3/16"
6211	P04086211	HEX NUT M6-1
6212	P04086212	SLEEVE WASHER 6MM
6213	P04086213	LED STRIP L2W-Z-5050-24RGBWW

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G0409 Body



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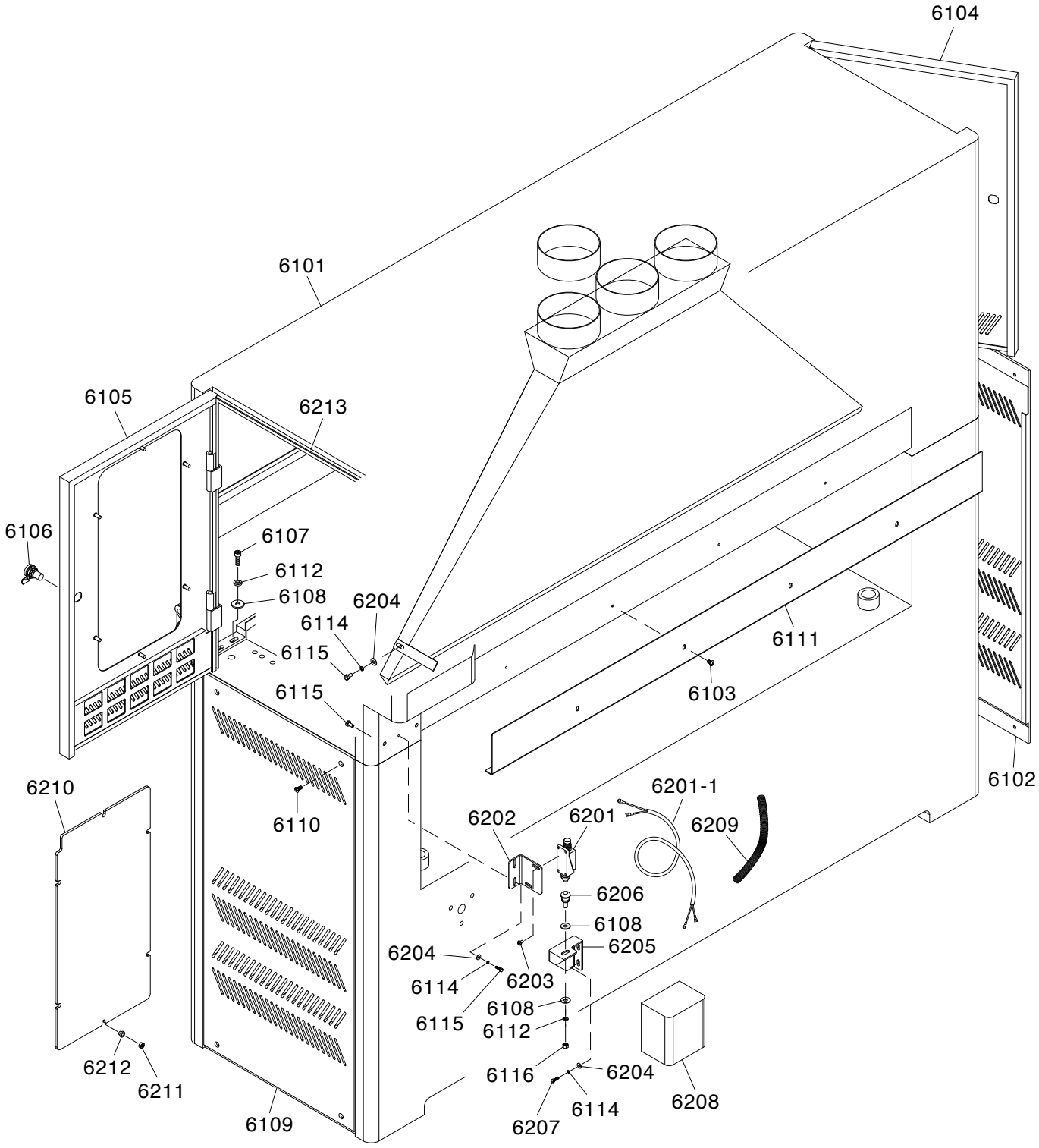
G0409 Body Parts List

REF	PART #	DESCRIPTION
6101	P04096101	UPPER FRAME COVER
6102	P04096102	ACCESS PANEL L
6103	P04096103	PHLP HD SCR M6-1 X 10
6104	P04096104	DOOR L
6105	P04096105	DOOR R
6106	P04096106	DOOR LOCK
6107	P04096107	CAP SCREW 5/16-18 X 3/4
6108	P04096108	FLAT WASHER 5/16
6109	P04096109	ACCESS PANEL R
6110	P04096110	FLAT HD SCR 1/4-20 X 1/2
6111	P04096111	DEPTH PLATE
6112	P04096112	LOCK WASHER 5/16
6114	P04096114	LOCK WASHER 1/4
6115	P04096115	HEX BOLT M6-1 X 16
6116	P04096116	HEX NUT 5/16-18

REF	PART #	DESCRIPTION
6201	P04096201	LIMIT SWITCH MOUJEN ME-8111
6201-1	P04096201-1	CORD 20G 2W
6202	P04096202	LIMIT SWITCH MOUNT
6203	P04096203	PHLP HD SCR M5-.8 X 10
6204	P04096204	FLAT WASHER 1/4
6205	P04096205	PEG MOUNT
6206	P04096206	THICKNESS PEG 5/16-18
6207	P04096207	CAP SCREW 1/4-20 X 3/4
6208	P04096208	SENSOR COVER
6209	P04096209	CONDUIT 1/4" X 3/8"
6210	P04096210	PLEXIGLASS 20-3/8" X 10-5/16" X 3/16"
6211	P04096211	HEX NUT M6-1
6212	P04096212	SLEEVE WASHER 6MM
6213	P04096213	LED STRIP L2W-Z-5050-24RGBWW

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G0411 Body



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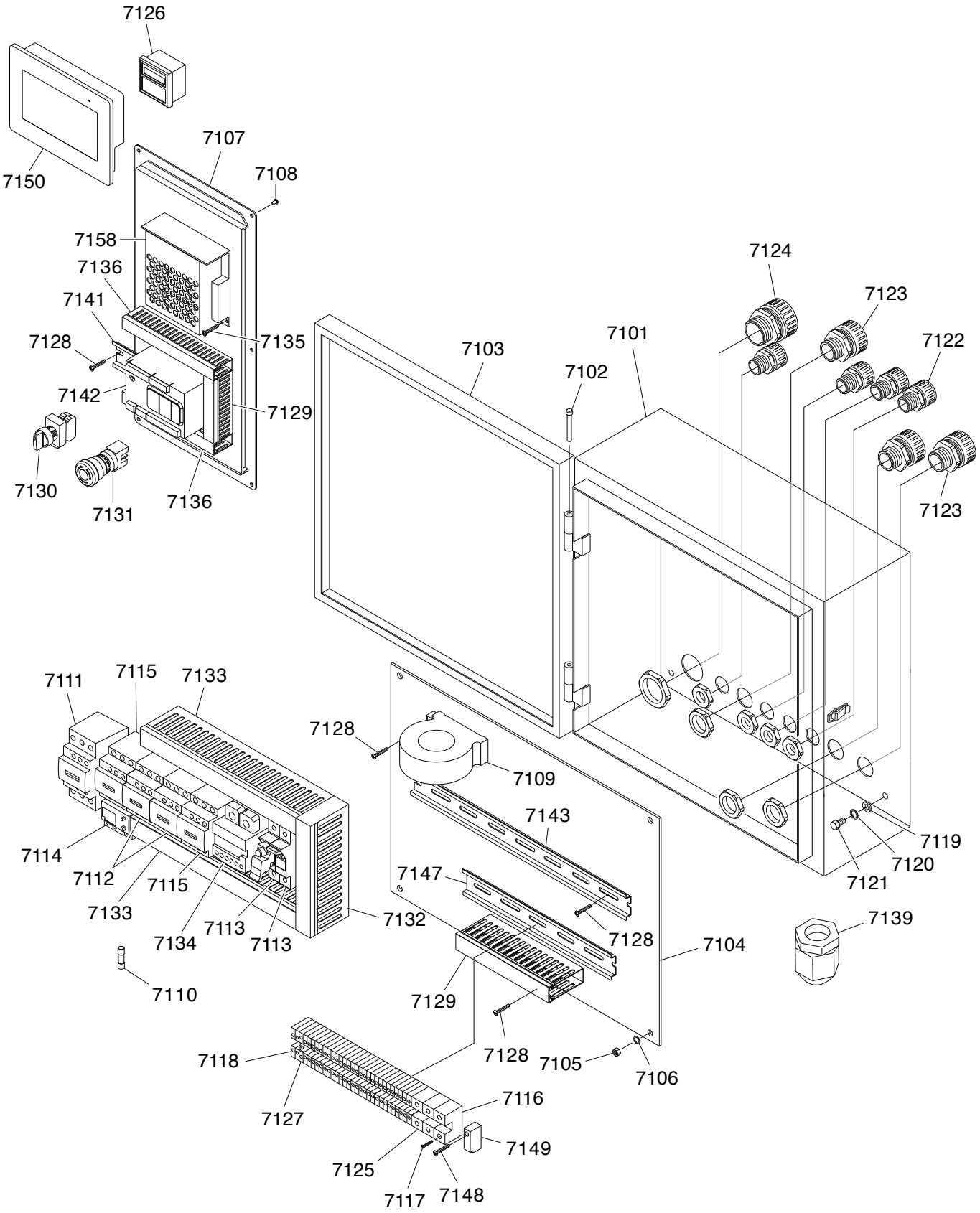
G0411 Body Parts List

REF	PART #	DESCRIPTION
6101	P04116101	UPPER FRAME COVER
6102	P04116102	ACCESS PANEL R
6103	P04116103	PHLP HD SCR M6-1 X 10
6104	P04116104	DOOR R
6105	P04116105	DOOR L
6106	P04116106	DOOR LOCK
6107	P04116107	CAP SCREW 5/16-18 X 3/4
6108	P04116108	FLAT WASHER 5/16
6109	P04116109	ACCESS PANEL L
6110	P04116110	FLAT HD SCR 1/4-20 X 1/2
6111	P04116111	DEPTH PLATE
6112	P04116112	LOCK WASHER 5/16
6114	P04116114	LOCK WASHER 1/4
6115	P04116115	HEX BOLT M6-1 X 16
6116	P04116116	HEX NUT 5/16-18

REF	PART #	DESCRIPTION
6201	P04116201	LIMIT SWITCH MOUJEN ME-8111
6201-1	P04116201-1	CORD 20G 2W
6202	P04116202	LIMIT SWITCH MOUNT
6203	P04116203	PHLP HD SCR M5-.8 X 10
6204	P04116204	FLAT WASHER 1/4
6205	P04116205	PEG MOUNT
6206	P04116206	THICKNESS PEG 5/16-18
6207	P04116207	CAP SCREW 1/4-20 X 3/4
6208	P04116208	SENSOR COVER
6209	P04116209	CONDUIT
6210	P04116210	PLEXIGLASS 20-7/16" X 10-5/16" X 3/16"
6211	P04116211	HEX NUT M6-1
6212	P04116212	SLEEVE WASHER 6MM
6213	P04116213	LED STRIP L2W-Z-5050-24RGBWW

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G0408/G0409 Main Electricals



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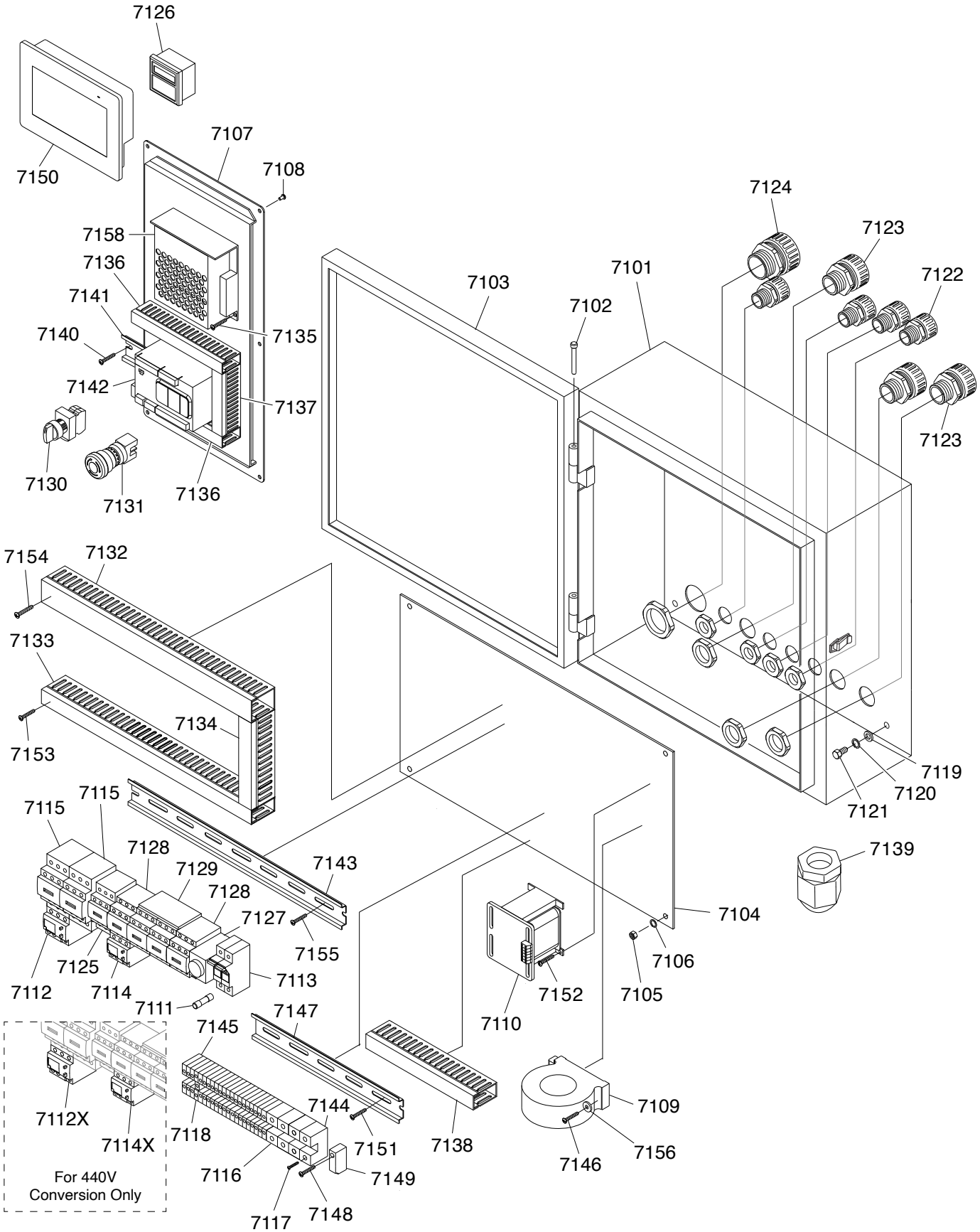
G0408/G0409 Main Electricals Parts List

REF	PART #	DESCRIPTION
7101	P04087101	ELECTRICAL CABINET
7102	P04087102	HEADED PIN 8 X 55MM (G0408)
7102	P04097102	HEADED PIN 8 X 65MM (G0409)
7103	P04087103	ELECTRICAL CABINET DOOR
7104	P04087104	CABINET MOUNTING PLATE
7105	P04087105	HEX NUT 1/4-20
7106	P04087106	LOCK WASHER 1/4
7107	P04087107	PANEL MOUNTING PLATE
7108	P04087108	BUTTON HD CAP SCR M4-.7 X 6
7109	P04087109	CURRENT SENSOR ARLIH YAL-1
7110	P04087110	FUSE 4A 600V FAST-ACTING
7111	P04087111	CONTACTOR SCHNEIDER LC1D50AM7
7112	P04087112	CONTACTOR SCHNEIDER LC1D09M7 ASSY
7113	P04087113	FUSE HOLDER W/FUSE SCHNEIDER DF101
7114	P04087114	OL RELAY SCHNEIDER LR3D12 5.5-8A
7115	P04087115	CONTACTOR SCHNEIDER LC1D09M7
7116	P04087116	GROUND TERMINAL BLOCK 1P 6-8G
7117	P04087117	PHLP HD SCR M4-.7 X 30
7118	P04087118	POWER TERMINAL BLOCK 1P 14-20G
7119	P04087119	FLAT WASHER 1/4
7120	P04087120	LOCK WASHER 1/4
7121	P04087121	HEX BOLT 1/4-20 X 1/2
7122	P04087122	STRAIN RELIEF 3/8" KO

REF	PART #	DESCRIPTION
7123	P04087123	STRAIN RELIEF 3/4" KO
7124	P04087124	STRAIN RELIEF 1" KO
7125	P04087125	POWER TERMINAL BLOCK 1P 6-8G
7126	P04087126	AMP METER NONI NI-729
7127	P04087127	GROUND TERMINAL BLOCK 1P 14-20G
7128	P04087128	PHLP HD SCR M4-.7 X 8
7129	P04087129	WIRE LOOM W/COVER 1" X 2-1/2" X 8"
7130	P04087130	LIGHT SWITCH AUSPICIOUS A2-RS2-100W
7131	P04087131	E-STOP SWITCH SCHNEIDER
7132	P04087132	WIRE LOOM W/COVER 1" X 2-1/2" X 6"
7133	P04087133	WIRE LOOM W/COVER 1" X 2-1/2" X 12"
7134	P04087134	OL RELAY SCHNEIDER LT4760M7S 5-60A
7135	P04087135	PHLP HD SCR M3-.5 X 6
7136	P04087136	WIRE LOOM W/COVER 1" X 2-1/2" X 7"
7139	P04087139	STRAIN RELIEF M25-1.5
7141	P04087141	DIN RAIL TH35 X 7.5 X 180MM
7142	P04087142	CONTROLLER SCHNEIDER TM200CE24R
7143	P04087143	DIN RAIL TH35 X 7.5 X 350MM
7147	P04087147	DIN RAIL TH35 X 7.5 X 280MM
7148	P04087148	TAP SCREW M4 X 9
7149	P04087149	TERMINAL END BLOCK DIN35
7150	P04087150	TOUCHSCREEN SCHNEIDER HMIET6400
7158	P04087158	POWER SUPPLY DELTA PMT-24V100W2BA

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G0411 Main Electricals



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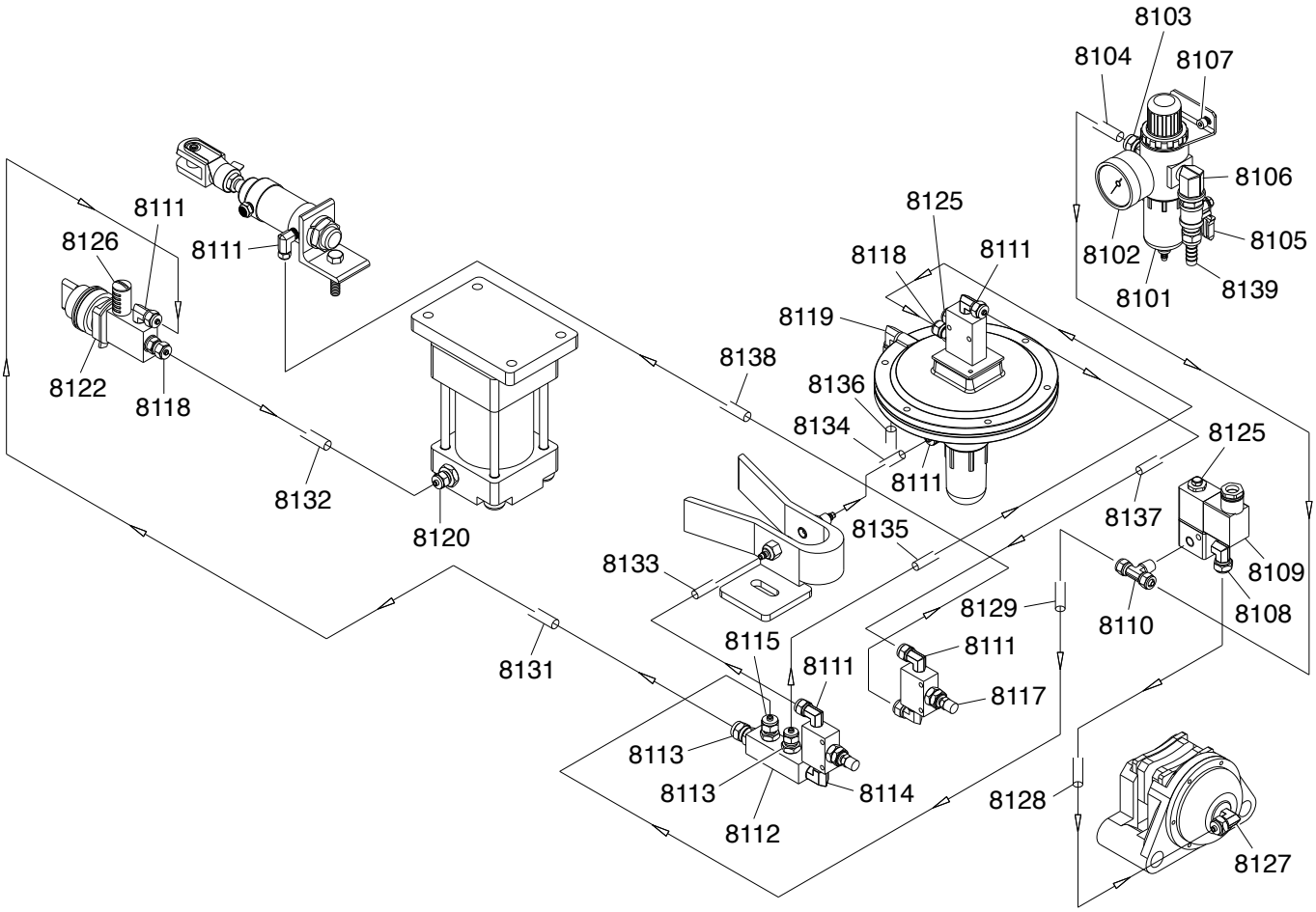
G0411 Main Electricals Parts List

REF	PART #	DESCRIPTION
7101	P04117101	ELECTRICAL CABINET
7102	P04117102	HEADED PIN 8 X 65MM
7103	P04117103	ELECTRICAL CABINET DOOR
7104	P04117104	CABINET MOUNTING PLATE
7105	P04117105	HEX NUT 1/4-20
7106	P04117106	LOCK WASHER 1/4
7107	P04117107	PANEL MOUNTING PLATE
7108	P04117108	BUTTON HD CAP SCR M4-.7 X 8
7109	P04117109	CURRENT SENSOR CT 75/5
7110	P04117110	TRANSFORMER LCPAC-TBSW-100500 440V
7111	P04117111	FUSE 4A 600V FAST-ACTING
7112	P04117112	OL RELAY SCHNEIDER LR3D340 30-40A
7112X	P04117112X	OL RELAY SCHNEIDER LR3D325 17-25A
7113	P04117113	FUSE HOLDER W/FUSE SCHNEIDER DF101
7114	P04117114	OL RELAY SCHNEIDER LR3D12 5.5-8A
7114X	P04117114X	OL RELAY SCHNEIDER LR3D08 2.5-4A
7115	P04117115	CONTACTOR SCHNEIDER LC1D40AM7
7116	P04117116	POWER TERMINAL BLOCK 1P 6-8G
7117	P04117117	PHLP HD SCR M4-.7 X 30
7118	P04117118	GROUND TERMINAL BLOCK 1P 14-20G
7119	P04117119	FLAT WASHER 5/16
7120	P04117120	LOCK WASHER 5/16
7121	P04117121	HEX BOLT 5/16-18 X 1/2
7122	P04117122	STRAIN RELIEF 1/2" KO
7123	P04117123	STRAIN RELIEF 3/4" KO
7124	P04117124	STRAIN RELIEF 1" KO
7125	P04117125	CONTACTOR SCHNEIDER LC1D38M7
7126	P04117126	AMP METER NONI NI-729
7127	P04117127	TIMER ORDER LSD-NC 30S
7128	P04117128	CONTACTOR SCHNEIDER LC1D09M7

REF	PART #	DESCRIPTION
7129	P04117129	CONTACTOR SCHNEIDER LC1D09M7 ASSY
7130	P04117130	LIGHT SWITCH AUSPICIOUS A2-RS2-102W
7131	P04117131	E-STOP SWITCH SCHNEIDER
7132	P04117132	WIRE LOOM W/COVER 1-1/2" X 2-1/2" X 24"
7133	P04117133	WIRE LOOM W/COVER 1-1/4" X 2-1/2" X 24"
7134	P04117134	WIRE LOOM W/COVER 1-1/4" X 2-1/2" X 12"
7135	P04117135	PHLP HD SCR M3-.5 X 6
7136	P04117136	WIRE LOOM W/COVER 1" X 2-1/2" X 7"
7137	P04117137	WIRE LOOM W/COVER 1" X 2-1/2" X 8"
7138	P04117138	WIRE LOOM W/COVER 1" X 2-1/2" X 12"
7139	P04117139	STRAIN RELIEF M25-1.5
7140	P04117140	PHLP HD SCR M4-.7 X 8
7141	P04117141	DIN RAIL TH35 X 7.5 X 180MM
7142	P04117142	CONTROLLER SCHNEIDER TM200CE24R
7143	P04117143	DIN RAIL TH35 X 7.5 X 600MM
7144	P04117144	GROUND TERMINAL BLOCK 1P 6-8G
7145	P04117145	POWER TERMINAL BLOCK 1P 14-20G
7146	P04117146	PHLP HD SCR M4-.7 X 8
7147	P04117147	DIN RAIL TH35 X 7.5 X 300MM
7148	P04117148	TAP SCREW M4 X 9
7149	P04117149	TERMINAL END BLOCK DIN35
7150	P04117150	TOUCHSCREEN SCHNEIDER HMIET6400
7151	P04117151	PHLP HD SCR M4-.7 X 8
7152	P04117152	PHLP HD SCR M4-.7 X 8
7153	P04117153	PHLP HD SCR M4-.7 X 8
7154	P04117154	PHLP HD SCR M4-.7 X 8
7155	P04117155	PHLP HD SCR M4-.7 X 8
7156	P04117156	FENDER WASHER 4MM
7158	P04117158	POWER SUPPLY DELTA PMT-24V100W2BA

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G0408/G0409 Pneumatic System

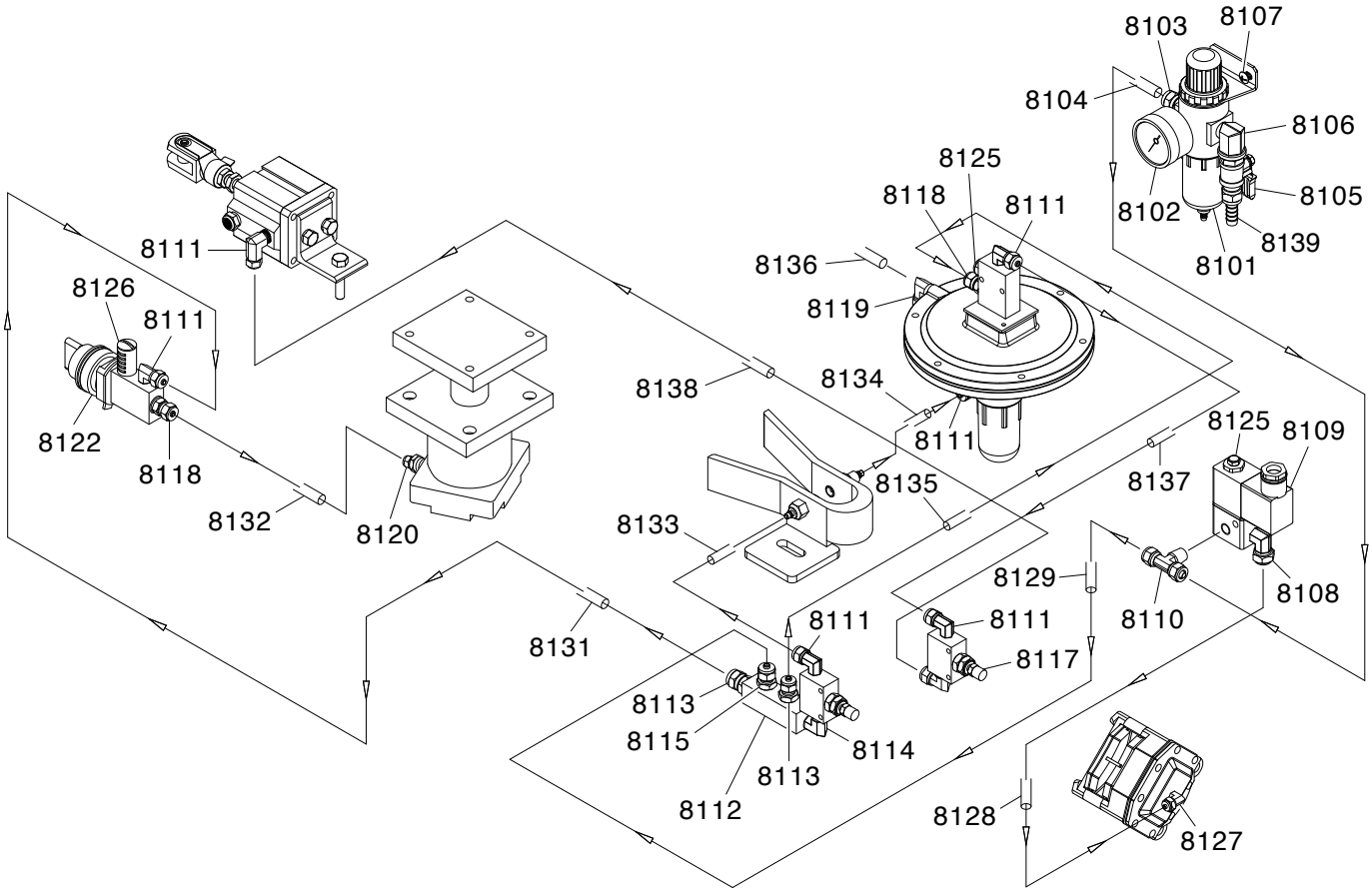


REF	PART #	DESCRIPTION
8101	P04088101	REGULATOR FILTER
8102	P04088102	PRESSURE REGULATOR
8103	P04088103	PIPE-HOSE ADAPTER 1/4 NPT X 8MM
8104	P04088104	FLEXIBLE HOSE 8 X 1180MM
8105	P04088105	BALL VALVE 1/4 NPT
8106	P04088106	PIPE FITTING 90-DEG 1/4 NPT
8107	P04088107	CAP SCREW 10-24 X 3/4
8108	P04088108	PIPE-HOSE ADAPTER 90-DEG 1/4 NPT X 8MM
8109	P04088109	SOLENOID VALVE NEUMA NV-5321
8110	P04088110	PIPE-TUBE ADAPTER 1/8 NPT X 8MM X 8MM
8111	P04088111	PIPE-TUBE ADAPTER 90-DEG 1/8 NPT X 6MM
8112	P04088112	AIR MANIFOLD 4-PORT
8113	P04088113	PIPE-HOSE ADAPTER 1/4 NPT X 6MM
8114	P04088114	PIPE FITTING 90-DEG 1/8 NPT X 1/4 NPT
8115	P04088115	PIPE-TUBE ADAPTER 1/4 NPT X 8MM
8117	P04088117	FLOW CONTROL VALVE POSU GRO-1/8
8118	P04088118	PIPE-HOSE ADAPTER 1/8 NPT X 6MM
8119	P04088119	PIPE-TUBE ADAPTER 90-DEG M5-.8 X 6MM (G0408)

REF	PART #	DESCRIPTION
8119	P04098119	PIPE-TUBE ADAPTER 90-DEG 1/4 NPT X 6MM (G0409)
8120	P04088120	PIPE-TUBE ADAPTER 3/8 NPT 6MM
8122	P04088122	MECHANICAL VALVE SWITCH POSU 1/8
8125	P04088125	MUFFLER 1/8 NPT COPPER
8126	P04088126	MUFFLER 1/8 NPT PLASTIC
8127	P04088127	PIPE-TUBE ADAPTER 90-DEG 1/8 NPT X 8MM
8128	P04088128	FLEXIBLE HOSE 8 X 700MM
8129	P04088129	FLEXIBLE HOSE 8 X 1400MM
8131	P04088131	FLEXIBLE HOSE 6 X 1100MM
8132	P04088132	FLEXIBLE HOSE 6 X 500MM
8133	P04088133	FLEXIBLE HOSE 6 X 570MM
8134	P04088134	FLEXIBLE HOSE 6 X 200MM
8135	P04088135	FLEXIBLE HOSE 6 X 650MM
8136	P04088136	FLEXIBLE HOSE 6 X 300MM
8137	P04088137	FLEXIBLE HOSE 6 X 650MM
8138	P04088138	FLEXIBLE HOSE 6 X 860MM
8139	P04088139	PIPE-HOSE ADAPTER 1/4 NPT X 3/8 PUSH-IN

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G0411 Pneumatic System

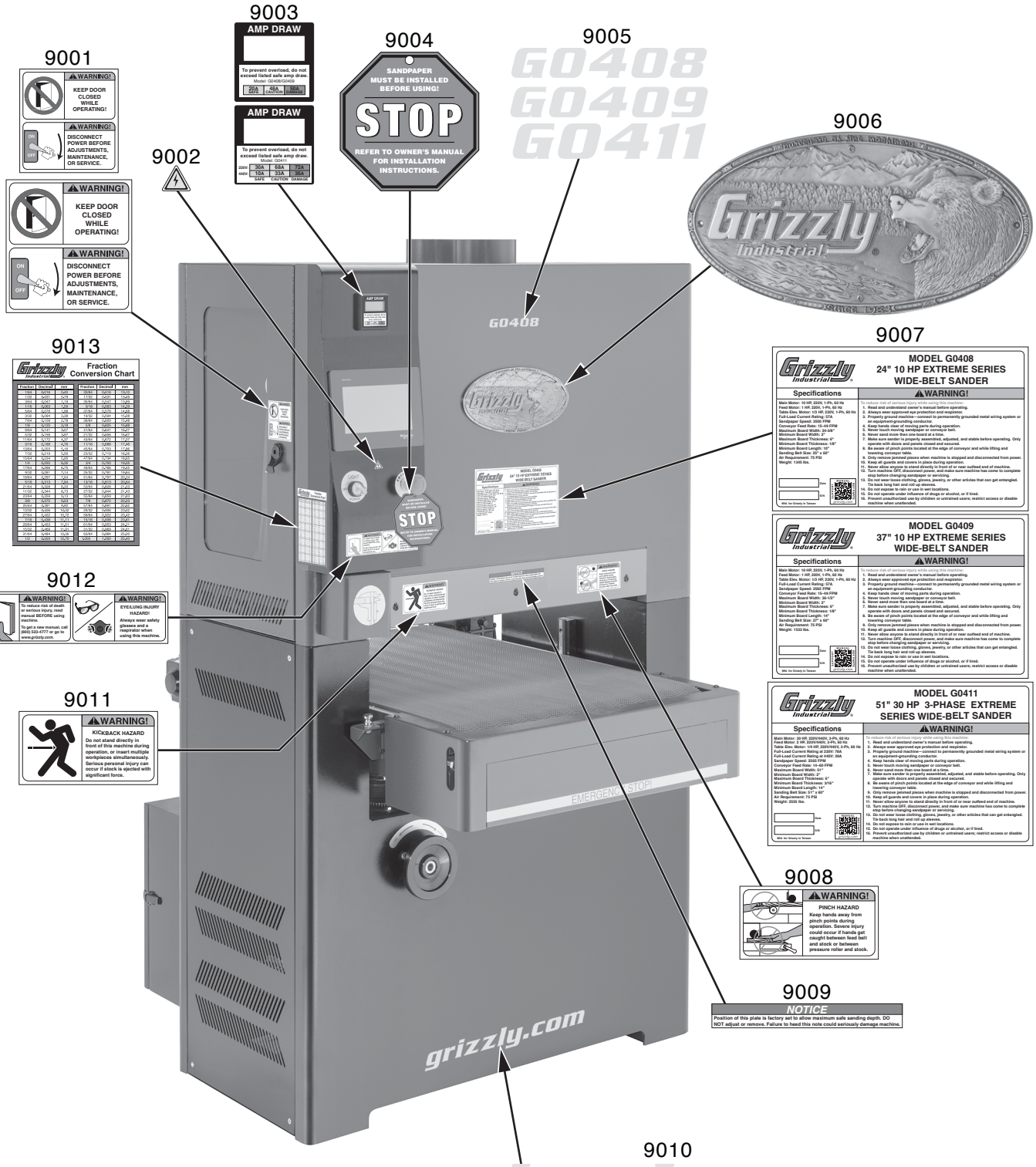


REF	PART #	DESCRIPTION
8101	P04118101	REGULATOR FILTER
8102	P04118102	PRESSURE REGULATOR
8103	P04118103	PIPE-HOSE ADAPTER 1/4 NPT X 8MM
8104	P04118104	FLEXIBLE HOSE 8 X 1180MM
8105	P04118105	BALL VALVE 1/4 NPT
8106	P04118106	PIPE FITTING 90-DEG 1/4 NPT
8107	P04118107	PHLP HD SCR 10-24 X 3/4
8108	P04118108	PIPE-HOSE ADAPTER 90-DEG 1/8 NPT X 8MM
8109	P04118109	SOLENOID VALVE NEUMA NV-5321
8110	P04118110	PIPE-TUBE ADAPTER 1/8 NPT X 8MM X 8MM
8111	P04118111	PIPE-TUBE ADAPTER 90-DEG 1/8 NPT X 6MM
8112	P04118112	AIR MANIFOLD 4-PORT
8113	P04118113	PIPE-HOSE ADAPTER 1/4 NPT X 6MM
8114	P04118114	PIPE FITTING 90-DEG 1/8 NPT X 1/4 NPT
8115	P04118115	PIPE-TUBE ADAPTER 1/4 NPT X 8MM
8117	P04118117	FLOW CONTROL VALVE POSU GRO-1/8
8118	P04118118	PIPE-HOSE ADAPTER 1/8 NPT X 6MM

REF	PART #	DESCRIPTION
8119	P04118119	PIPE-TUBE ADAPTER 90-DEG 1/4 NPT X 6MM
8120	P04118120	PIPE-TUBE ADAPTER 3/8 NPT X 6MM
8122	P04118122	MECHANICAL VALVE SWITCH POSU 1/8
8125	P04118125	MUFFLER 1/8 NPT COPPER
8126	P04118126	MUFFLER 1/8 NPT PLASTIC
8127	P04118127	PIPE-TUBE ADAPTER 90-DEG 1/8 NPT X 8MM
8128	P04118128	FLEXIBLE HOSE 8 X 700MM
8129	P04118129	FLEXIBLE HOSE 8 X 1400MM
8131	P04118131	FLEXIBLE HOSE 6 X 1100MM
8132	P04118132	FLEXIBLE HOSE 6 X 500MM
8133	P04118133	FLEXIBLE HOSE 6 X 570MM
8134	P04118134	FLEXIBLE HOSE 6 X 300MM
8135	P04118135	FLEXIBLE HOSE 6 X 650MM
8136	P04118136	FLEXIBLE HOSE 6 X 300MM
8137	P04118137	FLEXIBLE HOSE 6 X 650MM
8138	P04118138	FLEXIBLE HOSE 6 X 860MM
8139	P04118139	PIPE-HOSE ADAPTER 1/4 NPT X 3/8 PUSH-IN

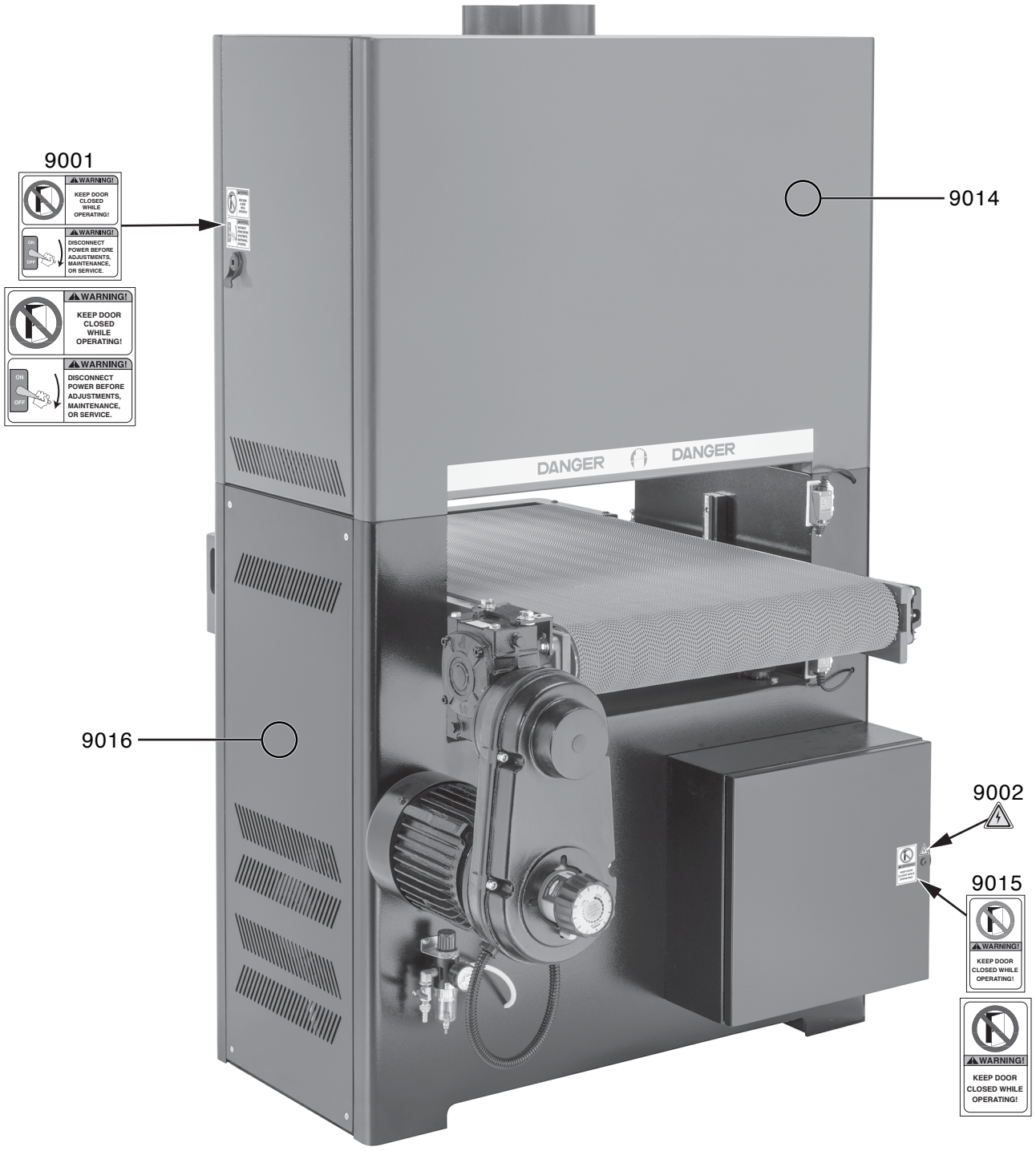
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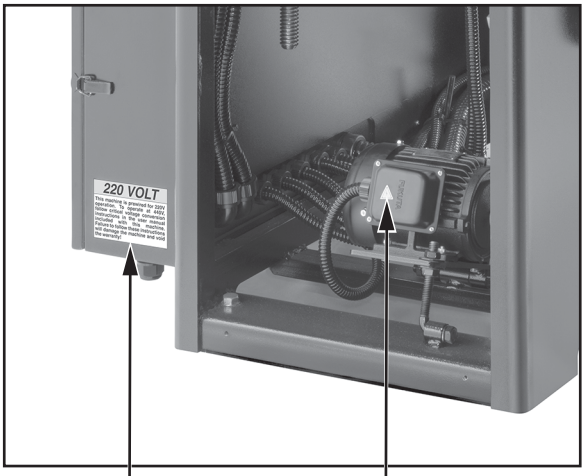
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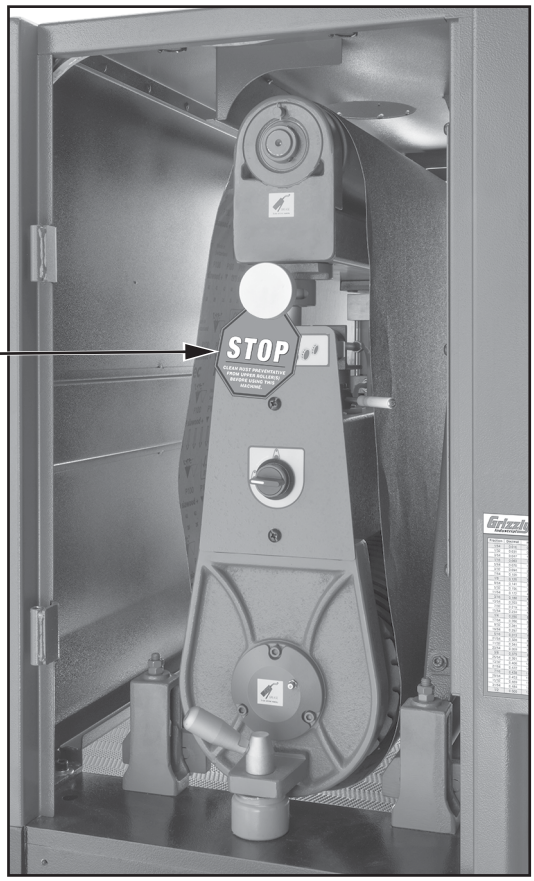
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9017



220 VOLT

This machine is prewired for 220V operation. To operate at 440V, follow critical voltage conversion instructions in the user manual included with this machine. Failure to follow these instructions will damage the machine and void the warranty!

9018
(G0411 Only)

9002

REF	PART #	DESCRIPTION
9001	P04089001	DOOR CLOSED COMBO LABEL (G0408/G0409)
9001	P04119001	DOOR CLOSED COMBO LABEL (G0411)
9002	P04089002	ELECTRICITY LABEL
9003	P04089003	AMP DRAW LABEL (G0408/G0409)
9003	P04119003	AMP DRAW LABEL (G0411)
9004	P04089004	SANDPAPER HANG TAG
9005	P04089005	MODEL NUMBER LABEL (G0408)
9005	P04099005	MODEL NUMBER LABEL (G0409)
9005	P04119005	MODEL NUMBER LABEL (G0411)
9006	P04089006	GRIZZLY NAMEPLATE
9007	P04089007	MACHINE ID LABEL (G0408)
9007	P04099007	MACHINE ID LABEL (G0409)
9007	P04119007	MACHINE ID LABEL (G0411)

REF	PART #	DESCRIPTION
9008	P04089008	PINCH HAZARD LABEL
9009	P04089009	DEPTH PLATE NOTICE LABEL
9010	P04089010	GRIZZLY.COM LABEL (G0408)
9010	P04099010	GRIZZLY.COM LABEL (G0409/G0411)
9011	P04089011	KICKBACK HAZARD LABEL
9012	P04089012	READ MANUAL COMBO LABEL
9013	P04089013	FRACTION CONVERSION LABEL
9014	P04089014	TOUCH-UP PAINT, GRIZZLY GREEN
9015	P04089015	CABINET DOOR CLOSED LABEL (G0408/G0409)
9015	P04119015	CABINET DOOR CLOSED LABEL (G0411)
9016	P04089016	TOUCH-UP PAINT, GLOSSY BLACK
9017	P04089017	RUST PREVENTATIVE HANG TAG
9018	P04119018	PREWIRED 220V LABEL (G0411)

⚠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.

BUY PARTS ONLINE AT GRIZZLY.COM!
Scan QR code to visit our Parts Store.

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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