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

# ⚠ WARNING!

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

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

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

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

# ⚠ WARNING!

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

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

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

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# INTRODUCTION

## Contact Info

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

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

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

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

## 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.

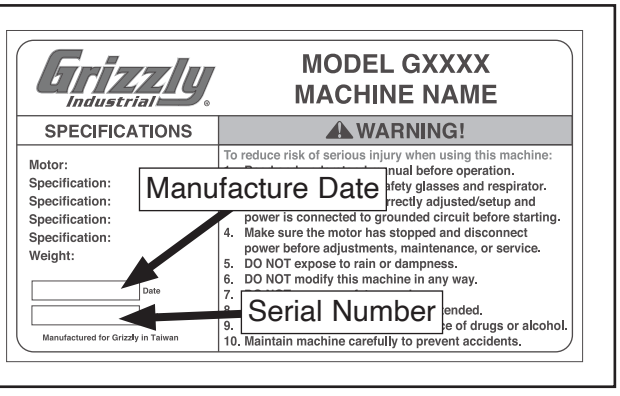
## Manual Accuracy

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**.

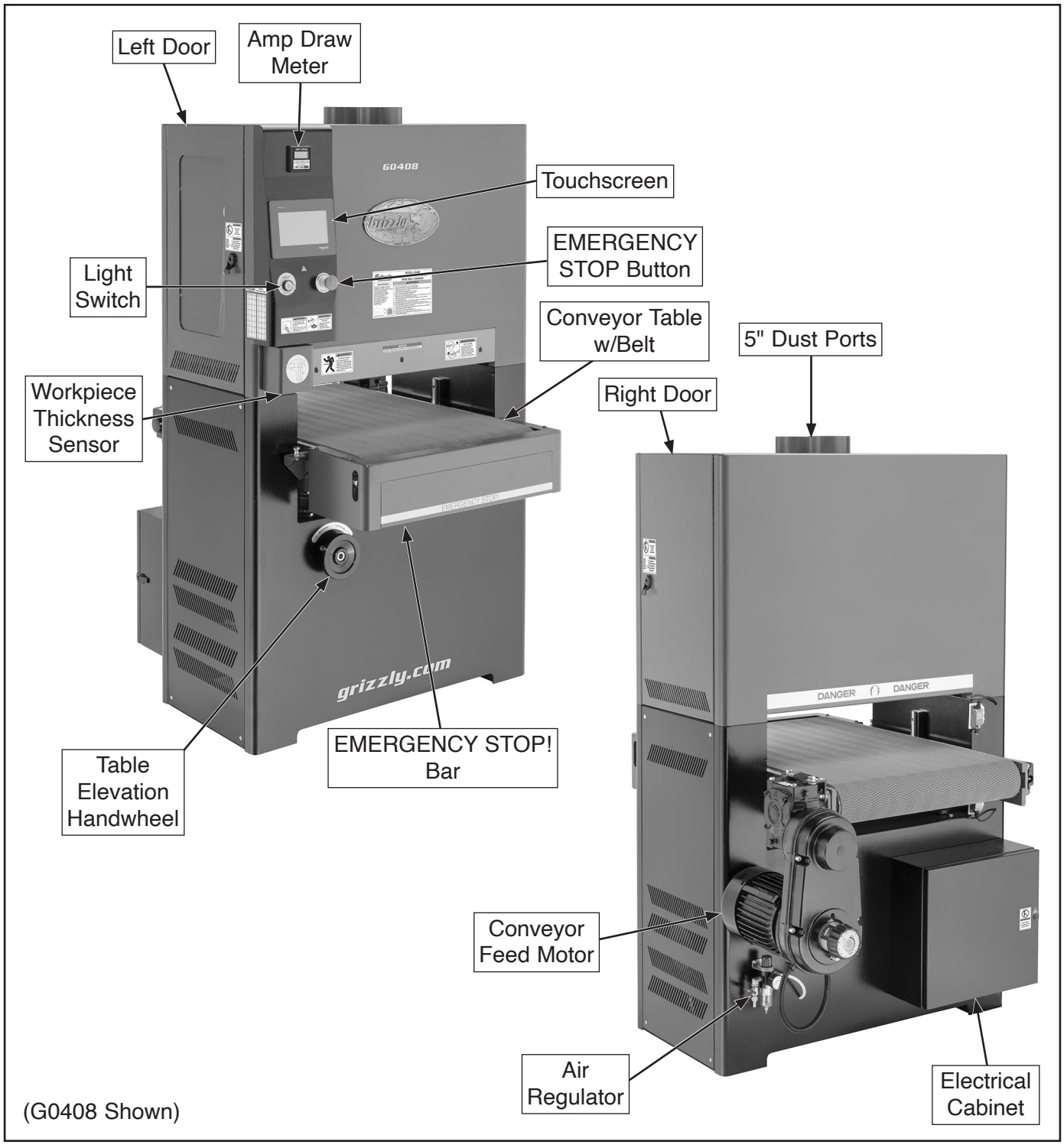
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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.



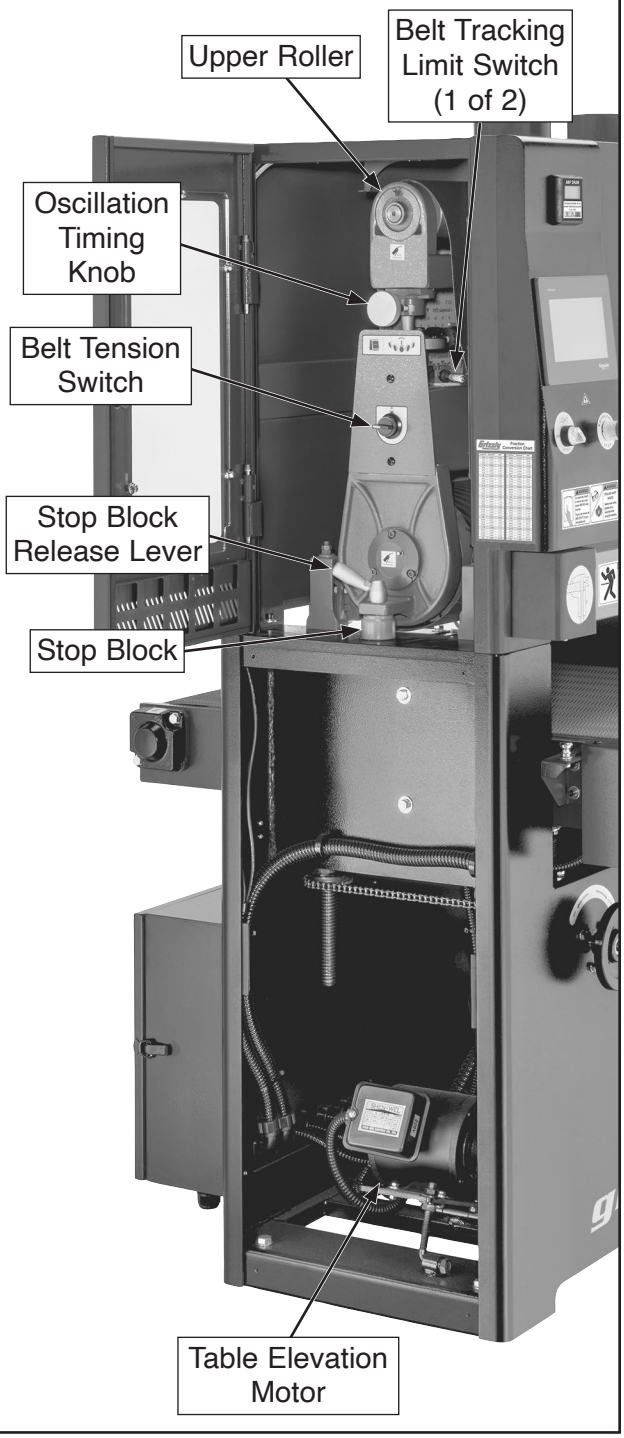
# Identification

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.

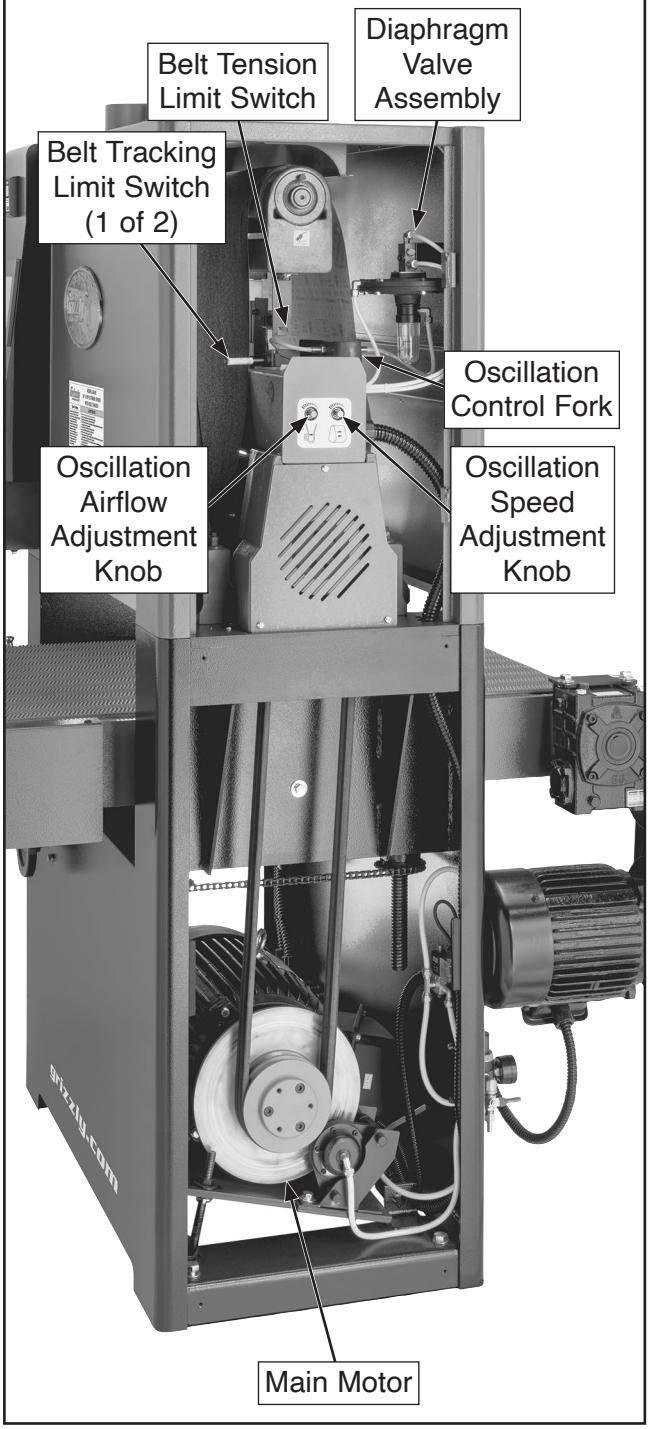



(G0408 Shown)

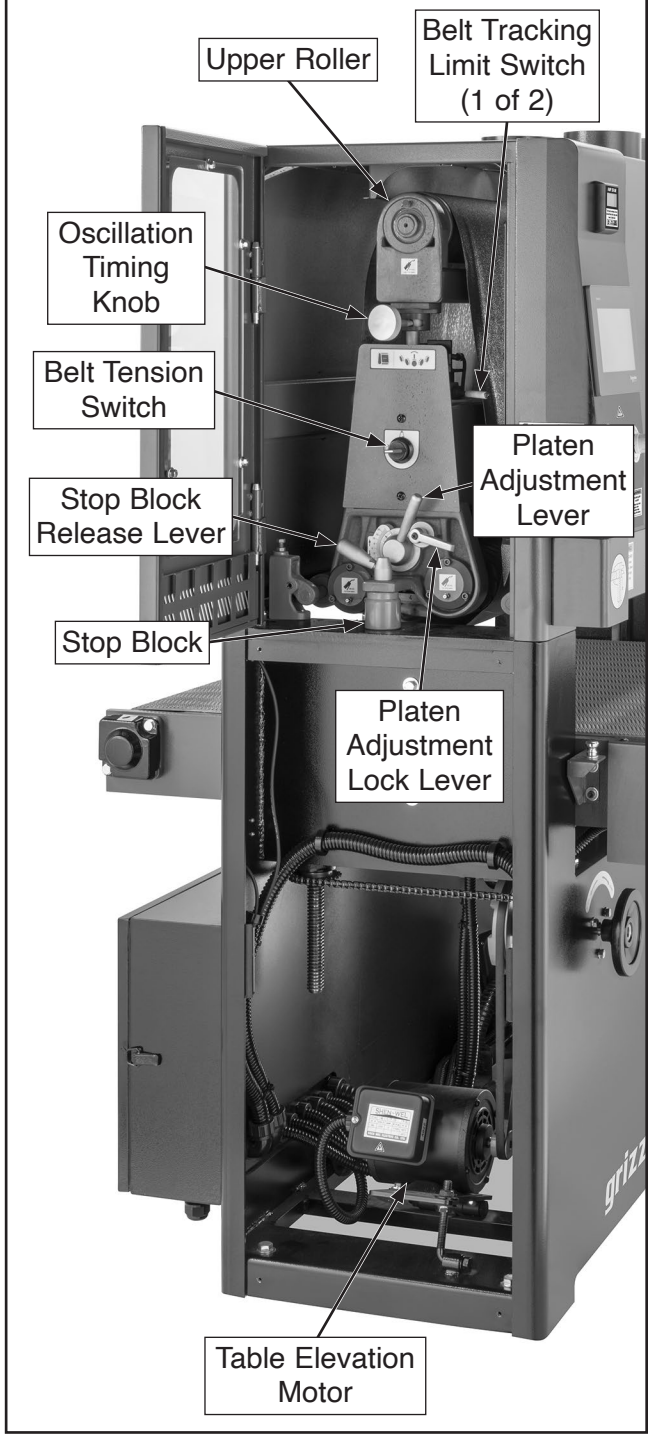
(G0408 Left Side Interior)



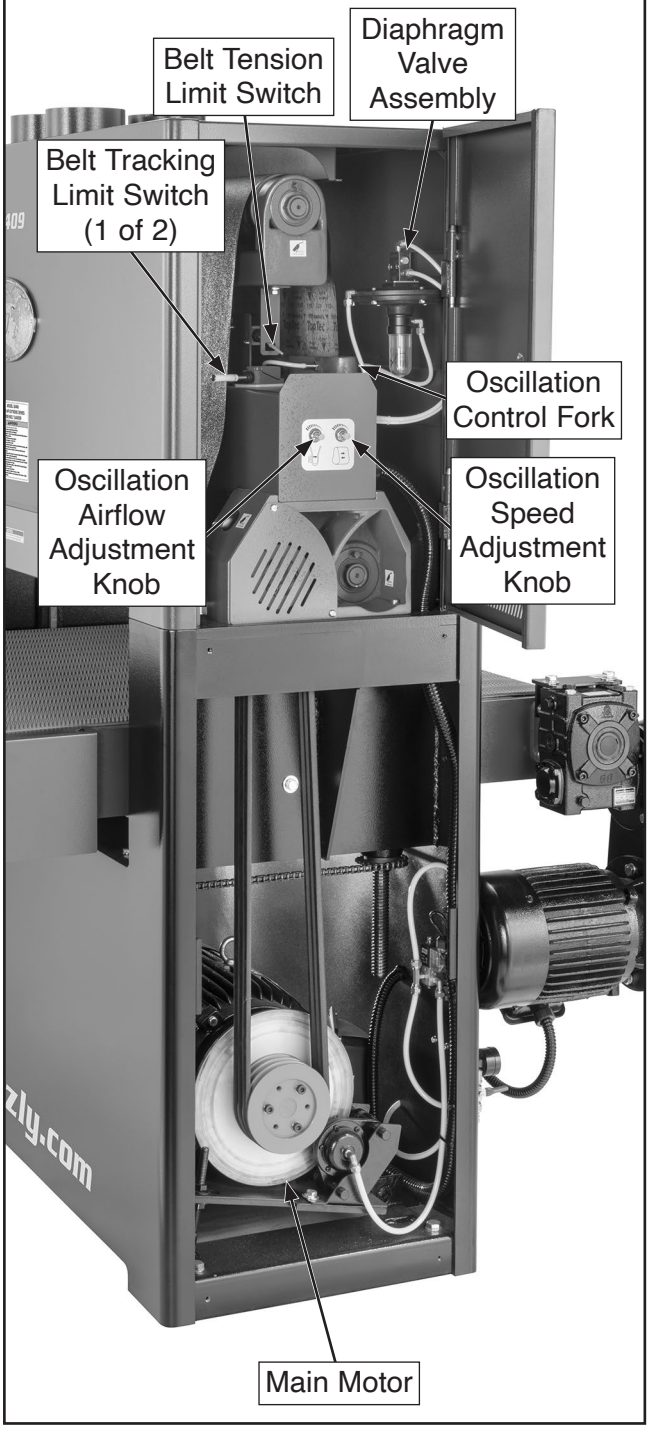

(G0408 Right Side Interior)



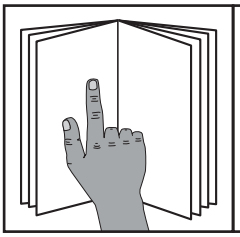
(G0409/G0411 Left Side Interior)




(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

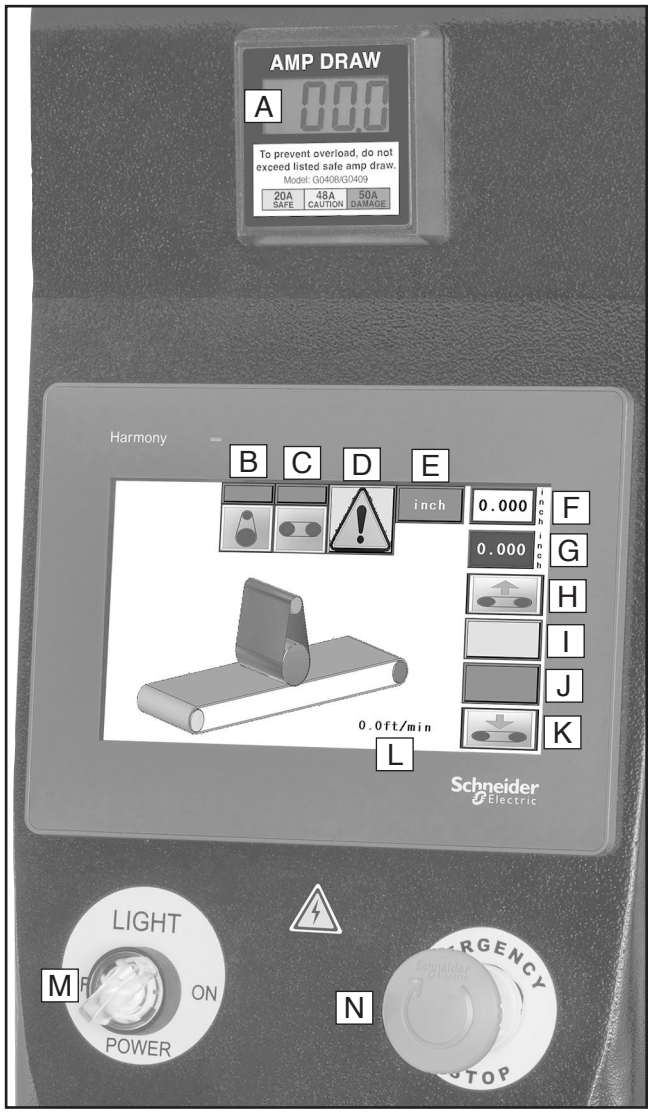



**Figure 1.** Control panel components.

**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

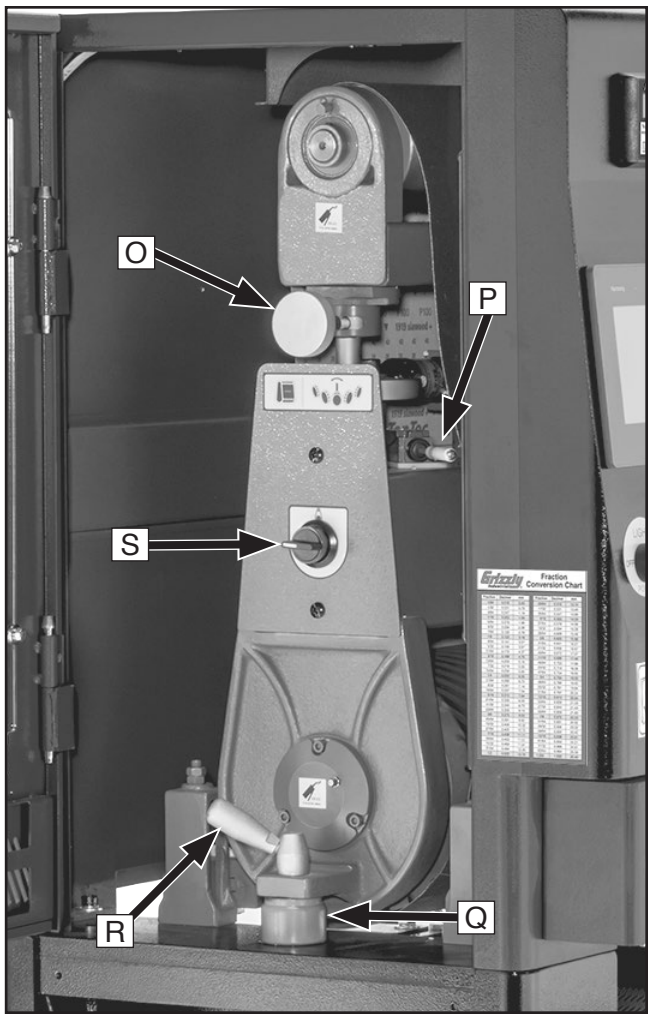



**Figure 2.** Left sanding belt components (G0408 shown).

**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.

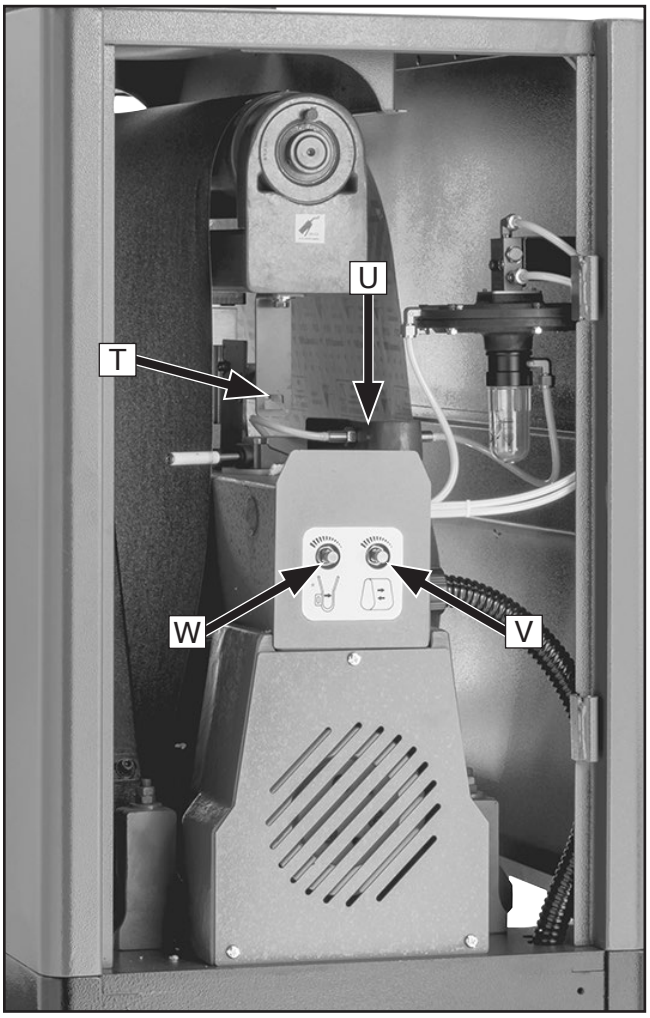



**Figure 3.** Right sanding belt components (G0408 shown).

**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

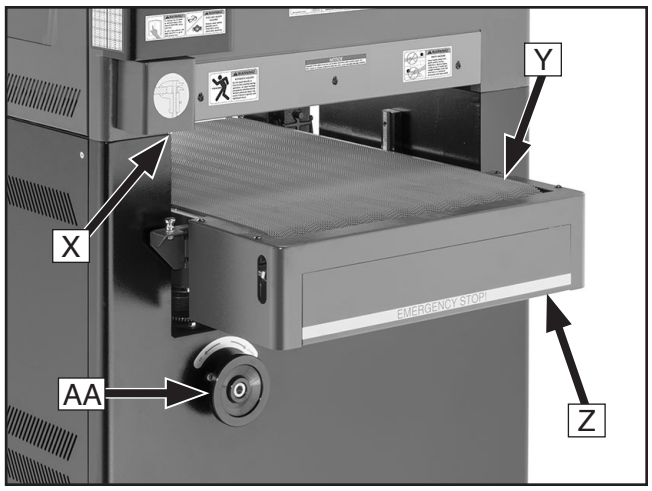



**Figure 4.** Front conveyor table components (G0408 shown).

**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).

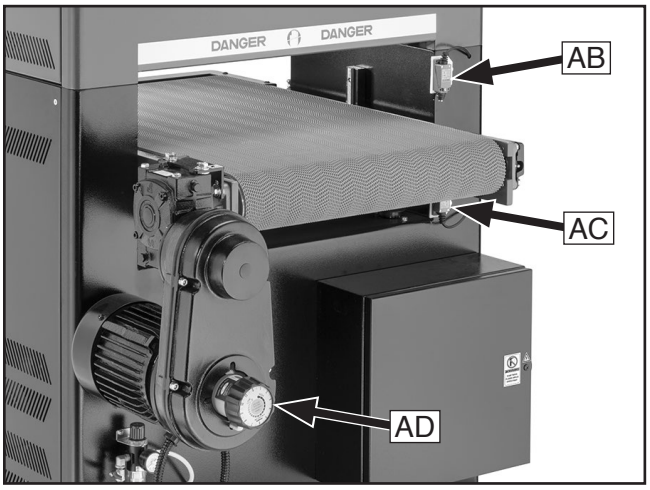



**Figure 5.** Rear conveyor table components (G0408 shown).

**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

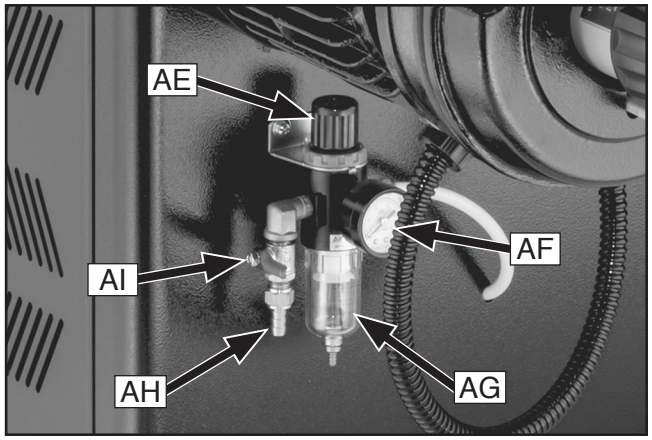



**Figure 6.** Air regulator components.

**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.

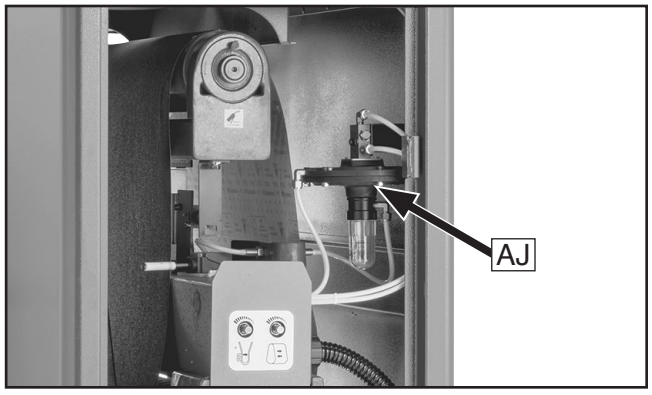



**Figure 7.** Diaphragm valve assembly.

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

## Platen (G0409/G0411 Only)

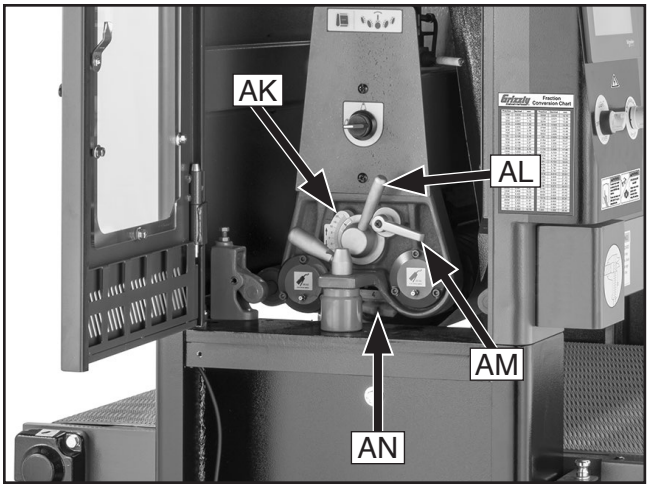



**Figure 8.** Platen components.

**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.

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# 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.

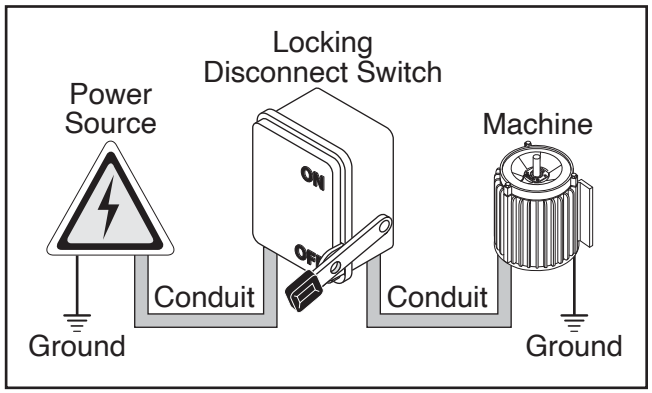



**Figure 9.** Typical setup of a permanently connected machine.

**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.

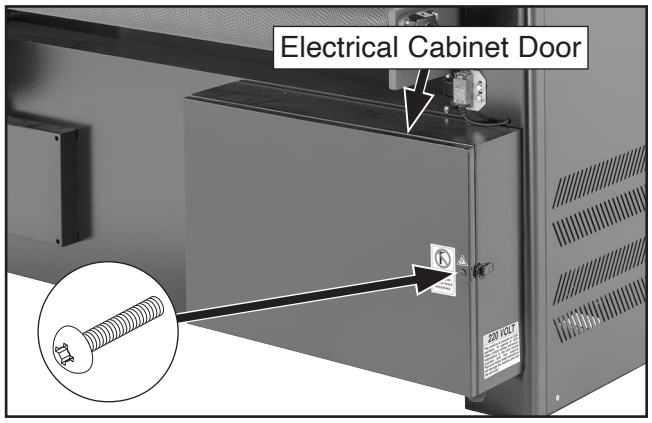



**Figure 10.** Electrical cabinet door and screw.

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.*

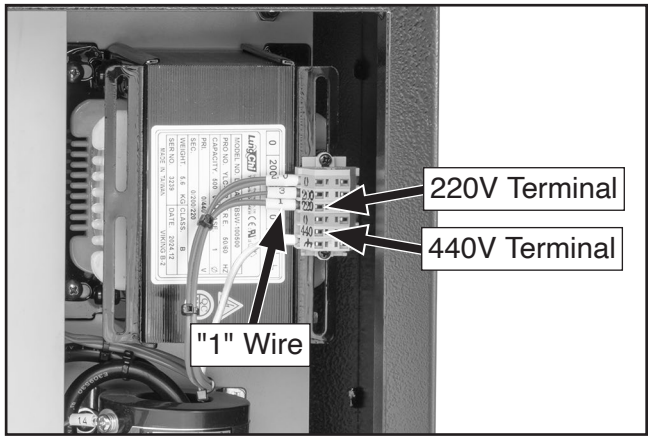



**Figure 11.** Location of "1" wire and supply voltage terminals on transformer.

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.

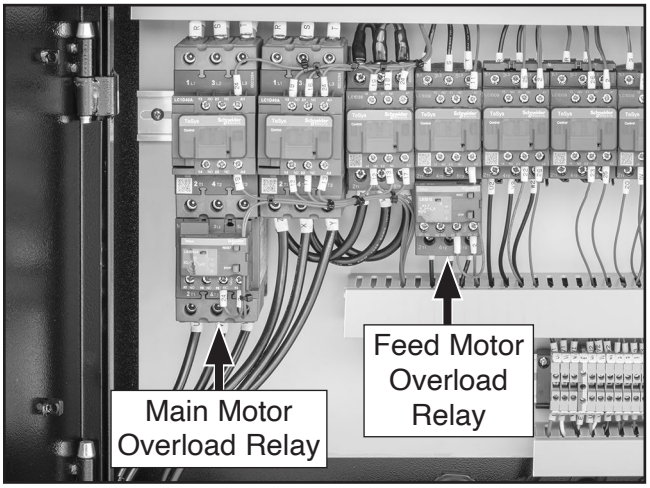



**Figure 12.** Location of main motor and feed motor overload relays.

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

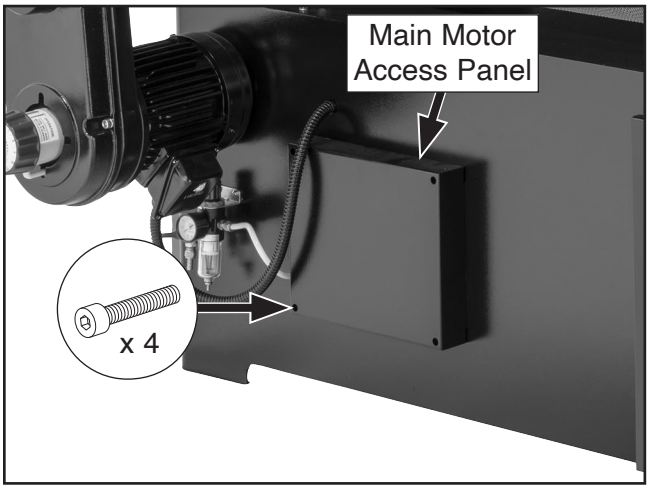



**Figure 13.** Location of main motor access panel and screws.

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

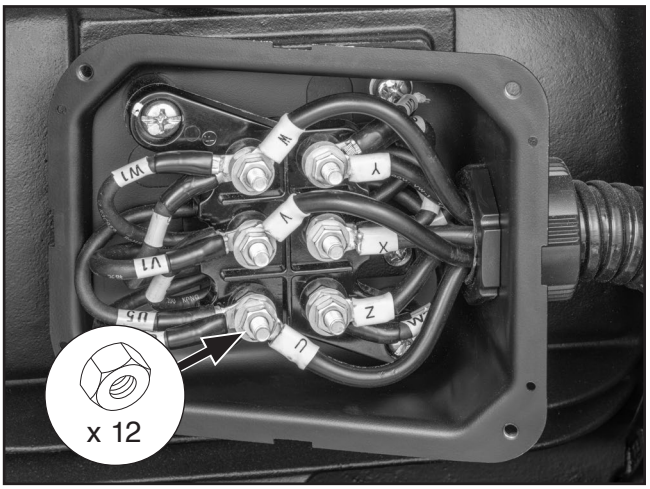



**Figure 14.** Location of terminal hex nuts in main motor junction box.

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.

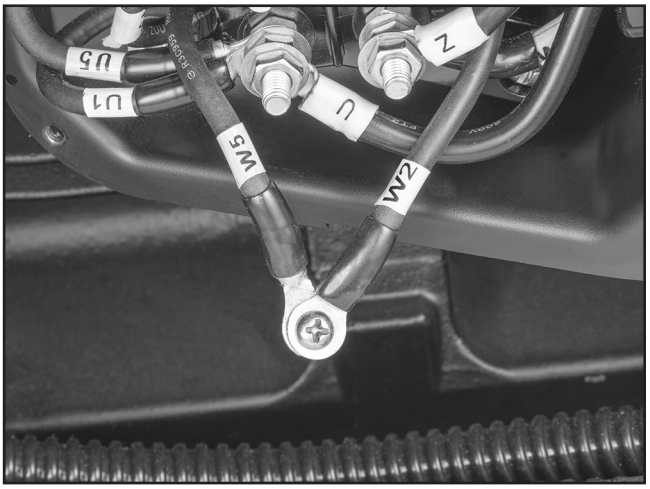


**Figure 15.** W2 and W5 wires connected with screw and nut.

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.

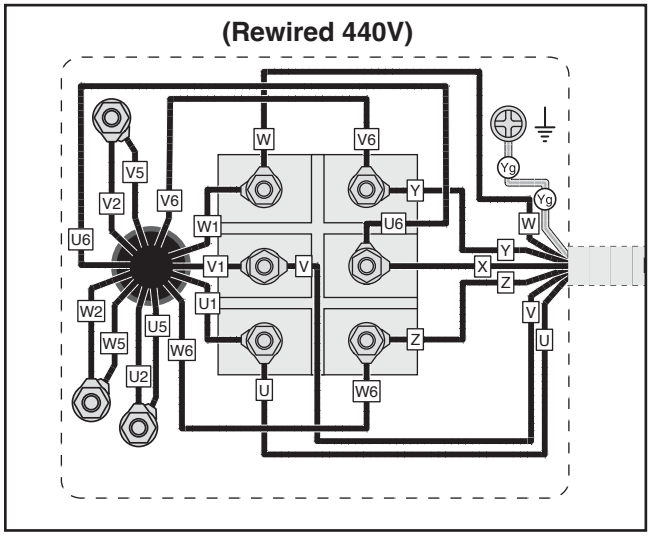



**Figure 16.** Main motor wired for 440V operation.

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

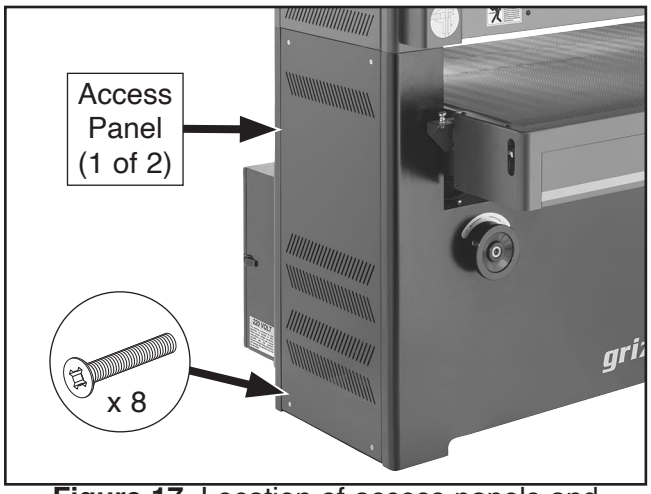



**Figure 17.** Location of access panels and screws.

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.

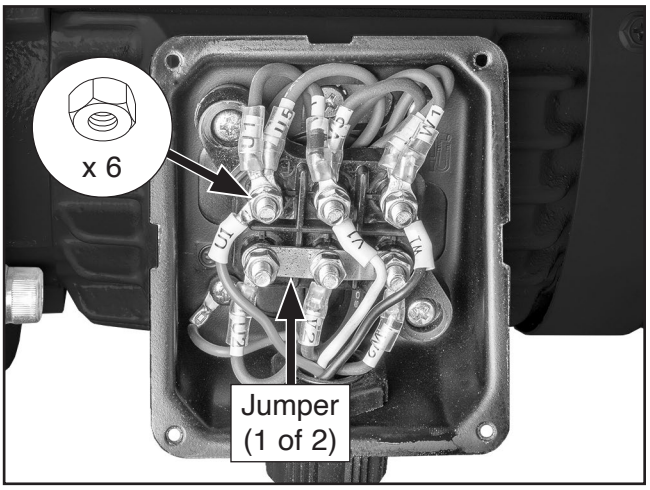



**Figure 18.** Location of terminal hex nuts and jumpers in feed motor junction box.

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.

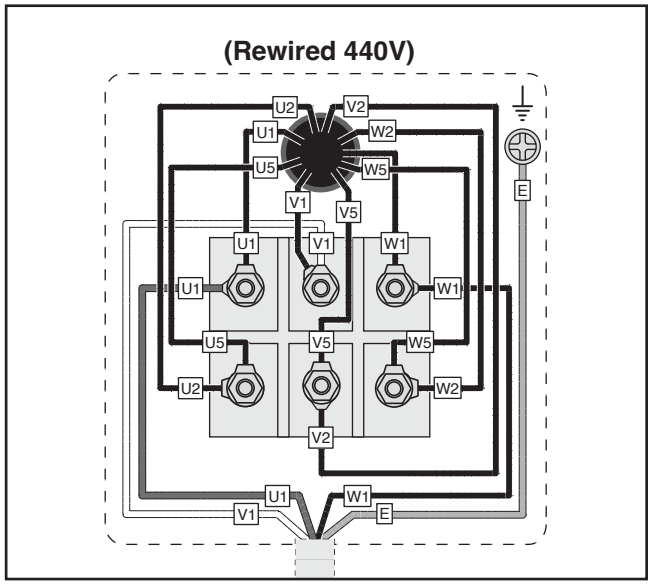



**Figure 19.** Feed motor wired for 440V operation.

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.

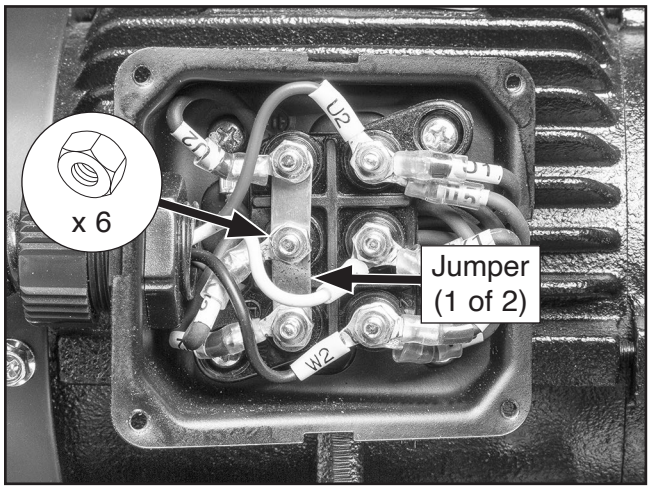



**Figure 20.** Location of terminal hex nuts and jumpers in table elevation motor junction box.

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.

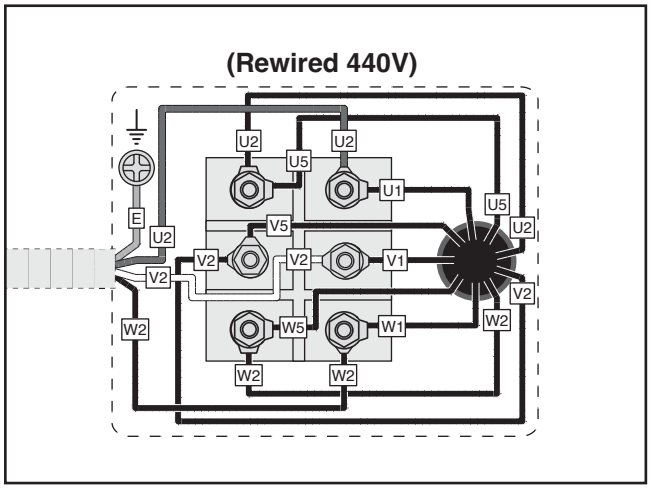
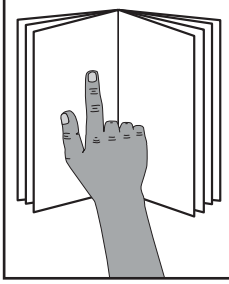



**Figure 21.** Table elevation motor wired for 440V operation.

18. Install access panels.

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

# SECTION 3: SETUP



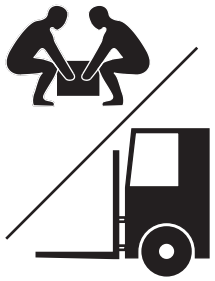
**⚠WARNING**

**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 |

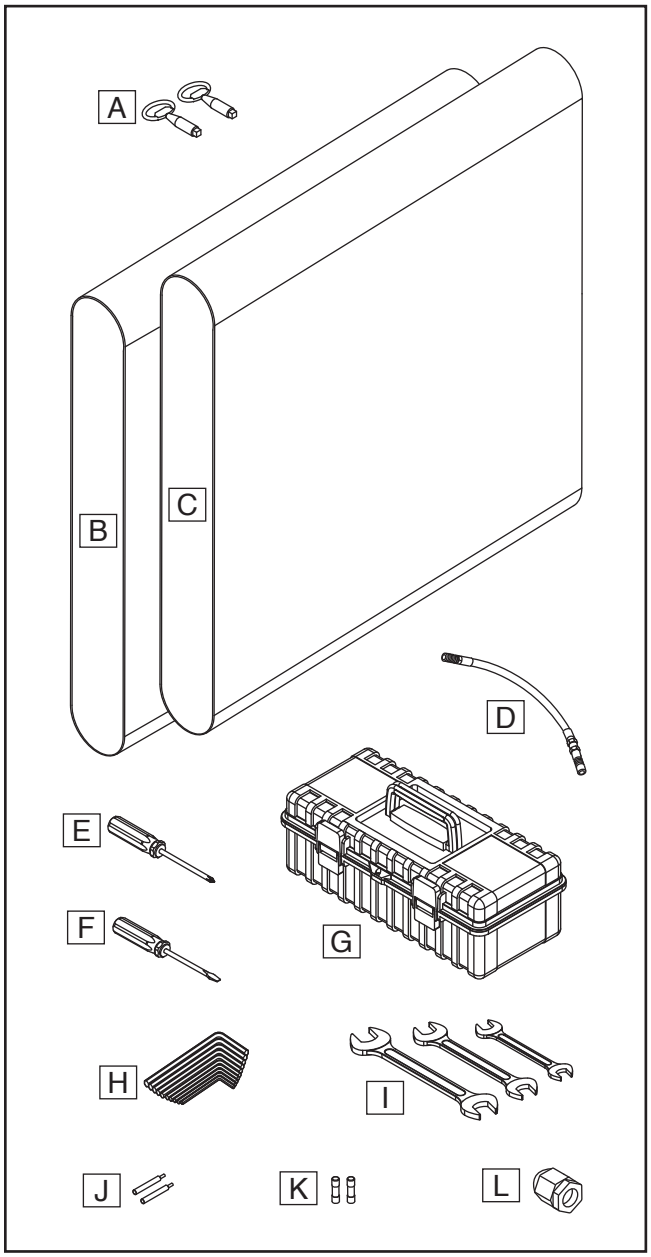



**Figure 22.** Loose inventory.

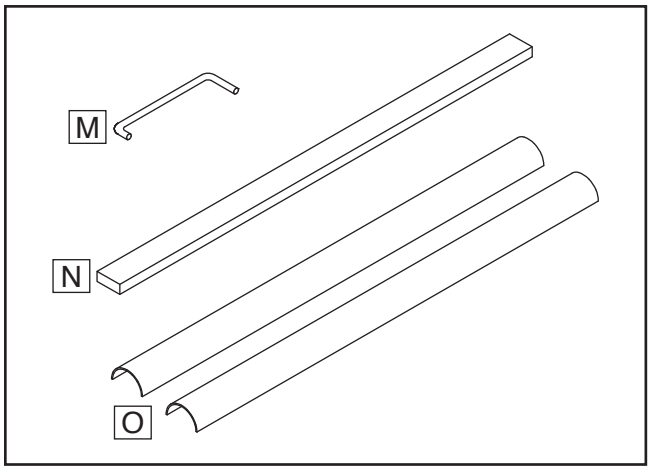



**Figure 23.** Additional inventory for G0409/G0411.

# 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.

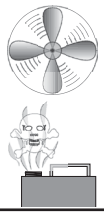
3. Wipe off surfaces. If cleaner/degreaser is effective, rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with a rag.

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.**

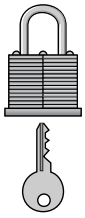
# Site Considerations

## 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.

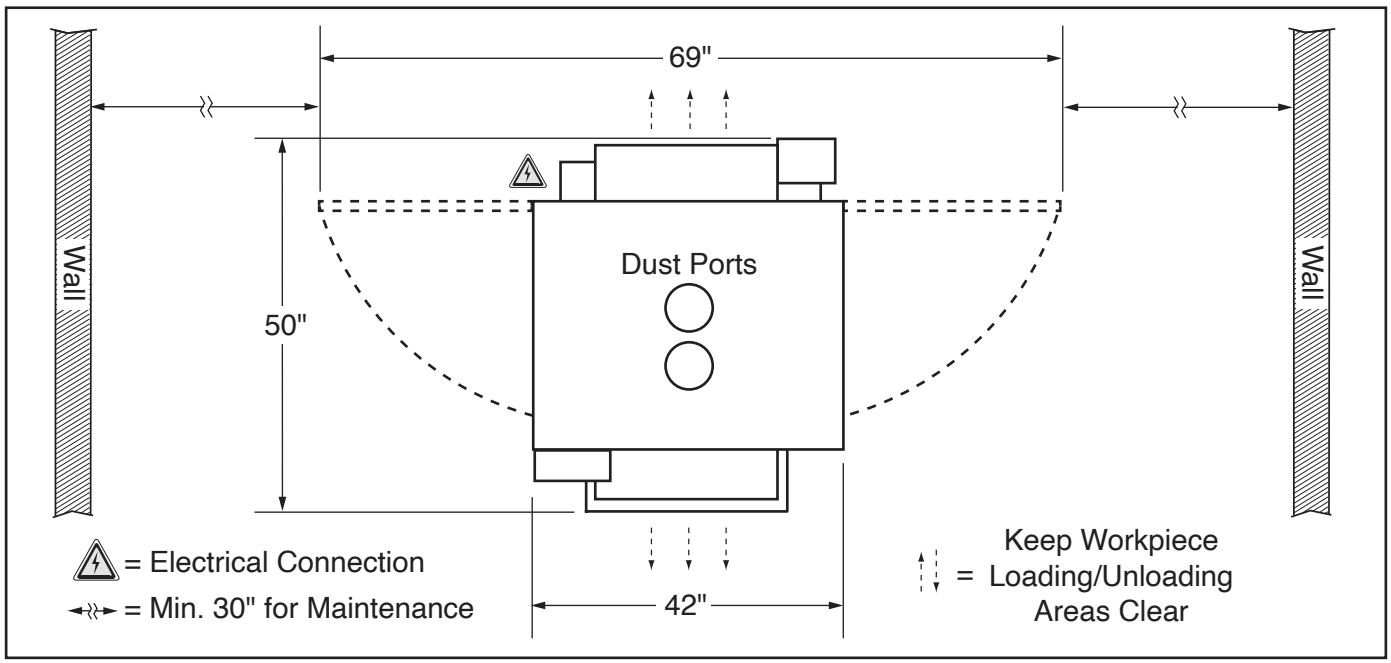



**Figure 24.** G0408 minimum working clearances.

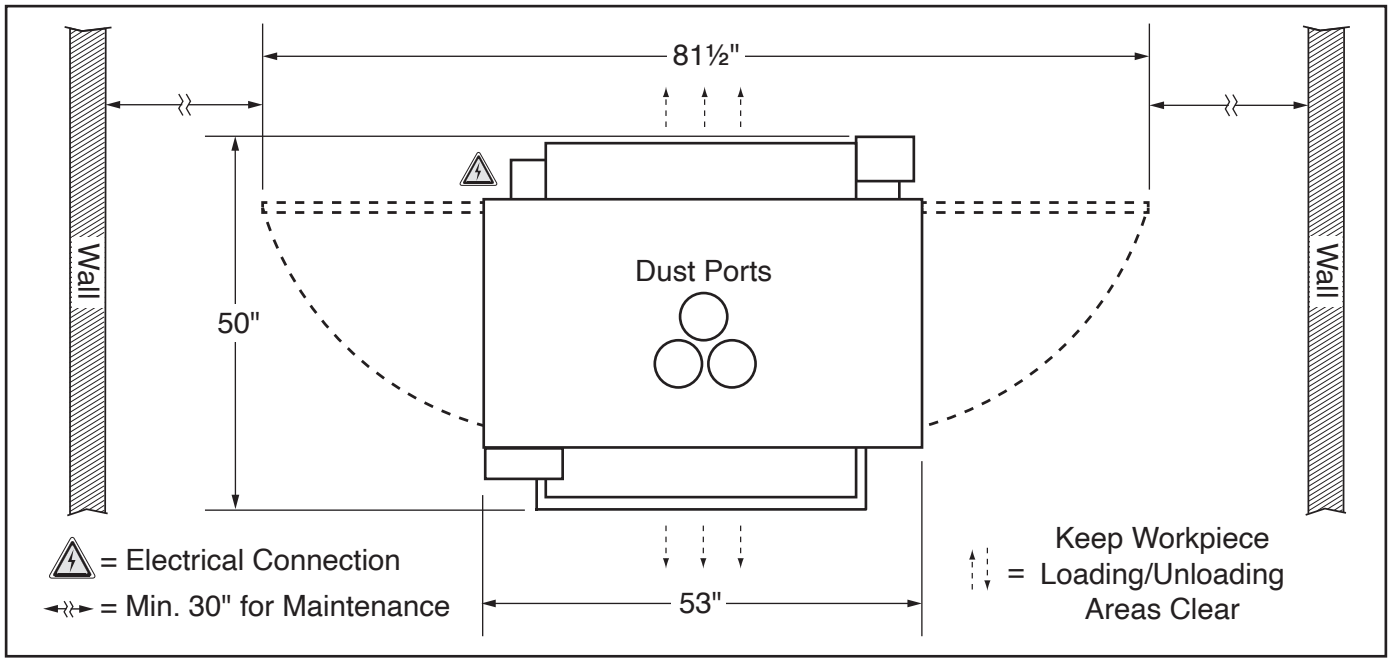



**Figure 25.** G0409 minimum working clearances.

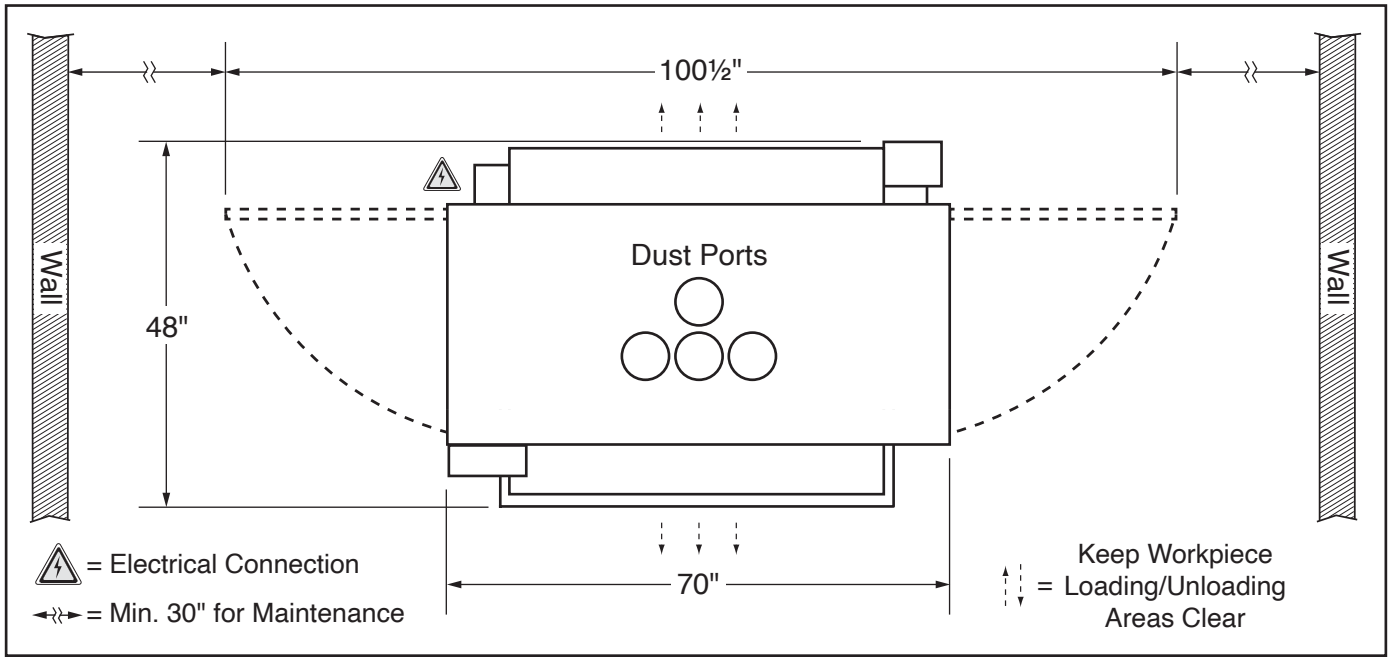
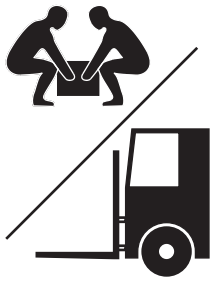



**Figure 26.** G0411 minimum working clearances.

# 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**).

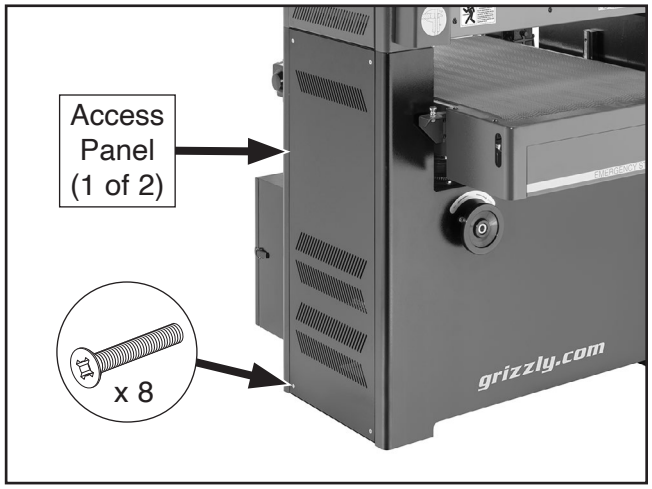



**Figure 27.** Location of access panels and screws (G0408 shown).

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

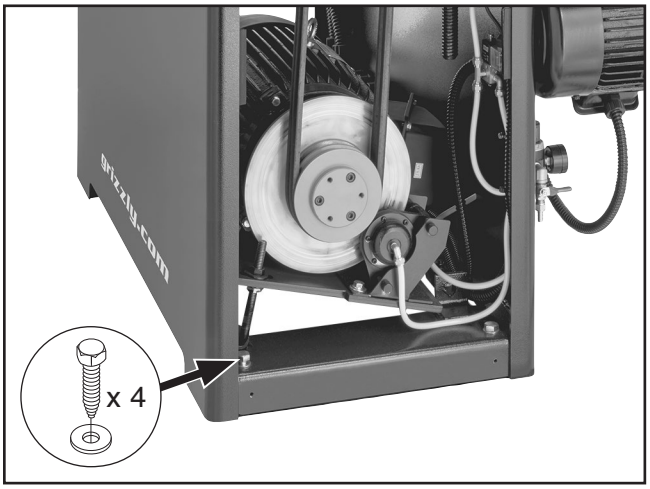



**Figure 28.** Location of lag screws and flat washers (G0408 shown).

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.

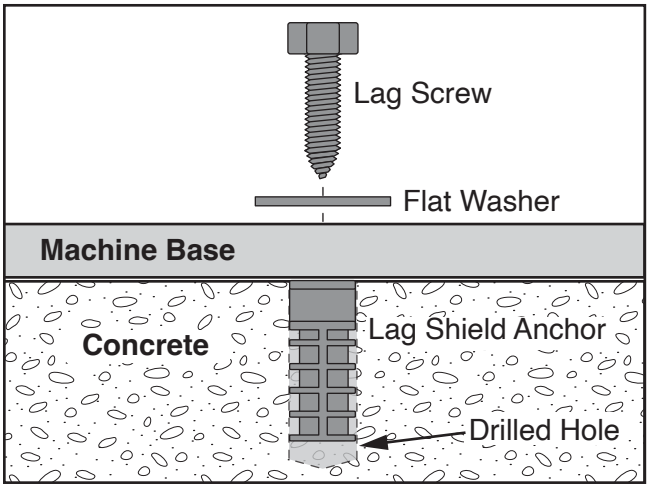



**Figure 30.** Popular method for anchoring machinery to a concrete floor.

# 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.

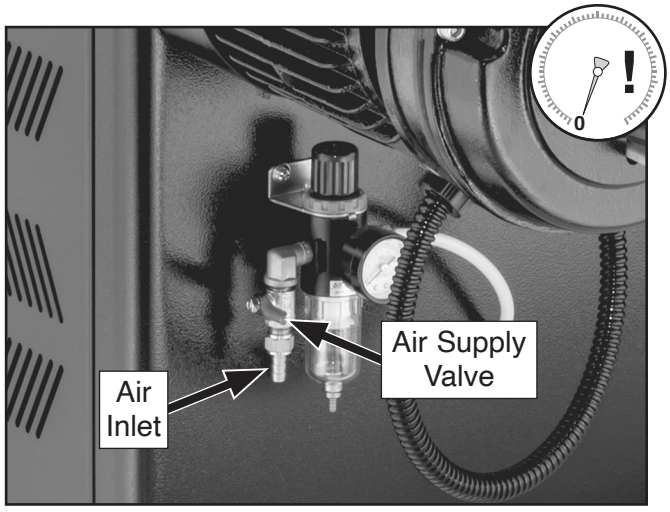



**Figure 31.** Location of air inlet and air supply valve on regulator.

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.

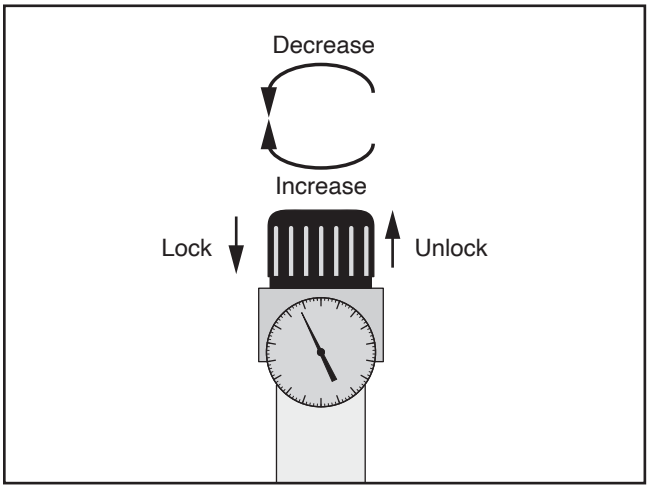



**Figure 32.** Regulator knob adjustment.

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**).

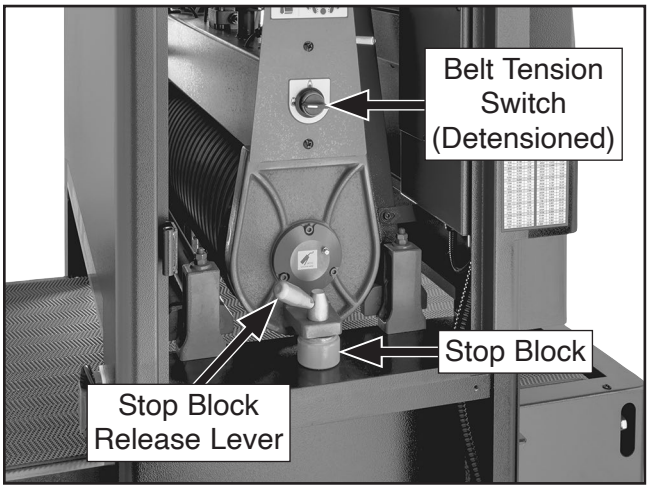



**Figure 33.** Sanding belt installation components (door removed for clarity; G0408 shown).

**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.**

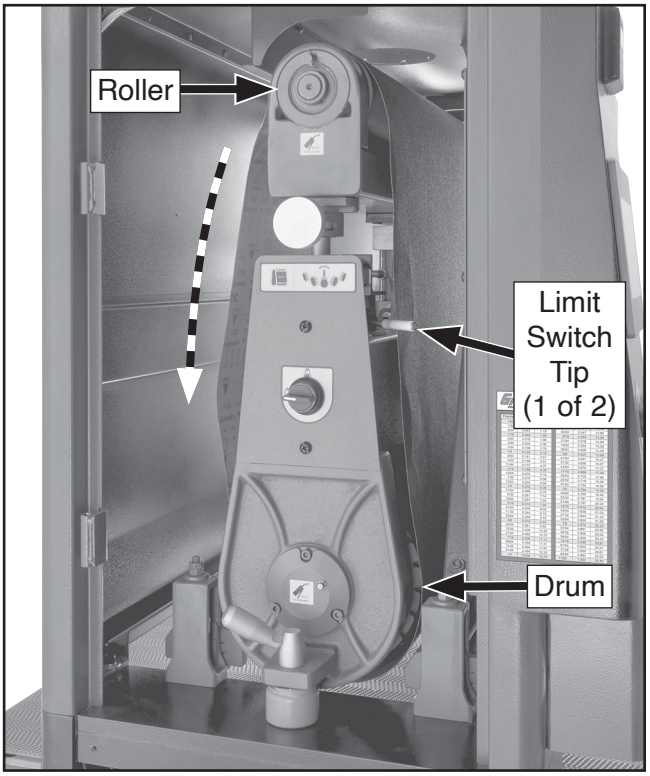



**Figure 34.** Model G0408 sanding belt installed correctly.

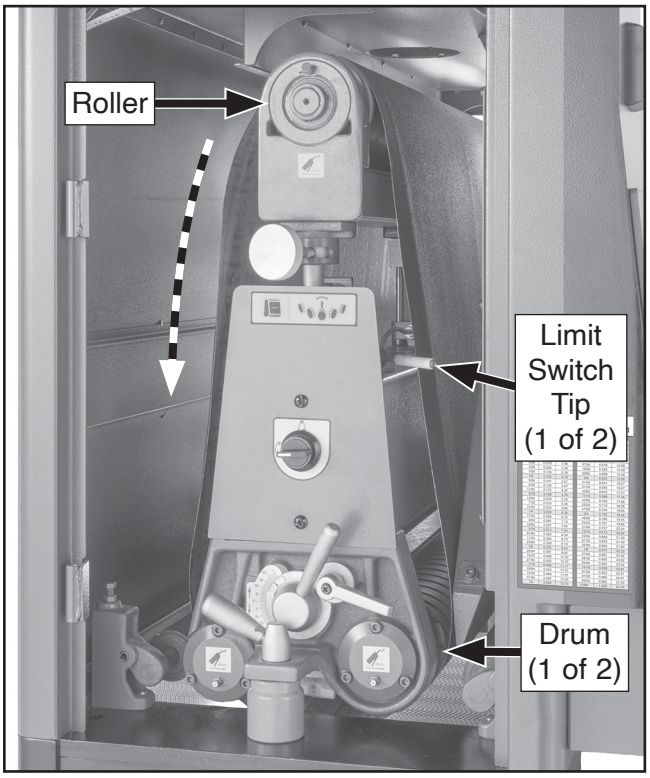



**Figure 35.** Model G0409/G0411 sanding belt installed correctly.

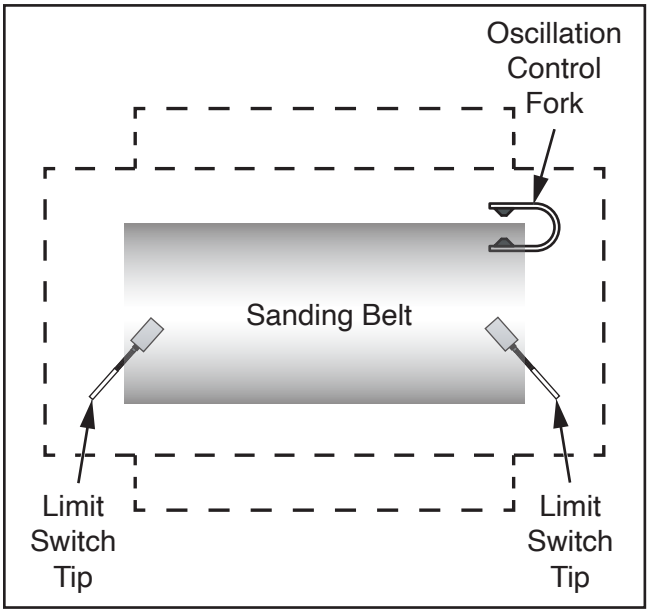



**Figure 36.** Sander outline (top view) of proper position of belt.

**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**).

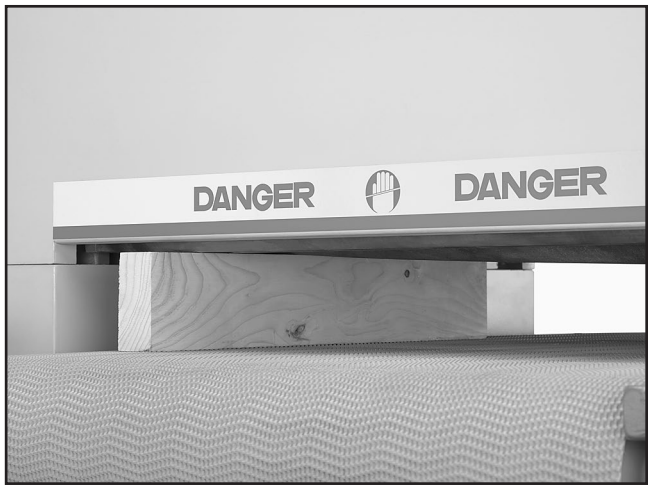



**Figure 37.** 2x4 positioned to check pressure roller height (example shown).

**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.

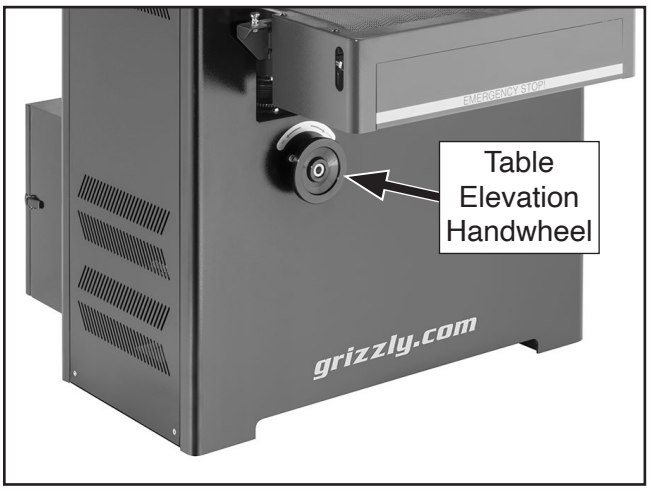



**Figure 38.** Location of table elevation handwheel (G0408 shown).

**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.



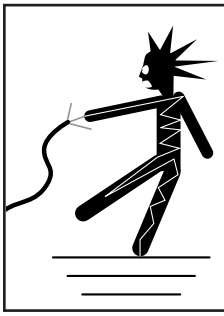

**Figure 39.** Dust hose attached to dust port (example shown).

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.

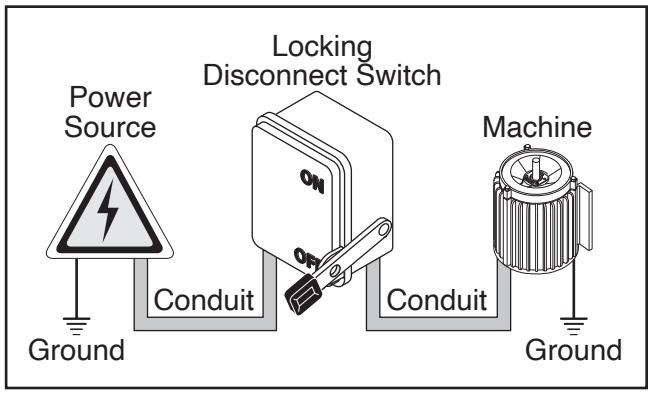



**Figure 40.** Typical setup of a locking disconnect switch.

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.

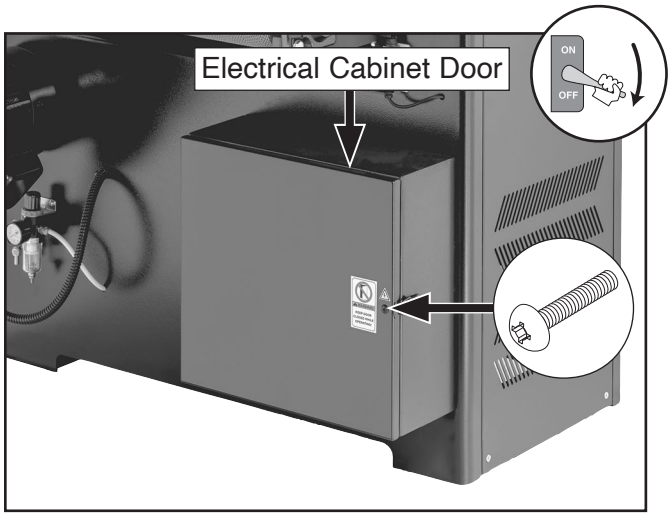



**Figure 41.** Location of electrical cabinet door and screw (G0408 shown).

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.

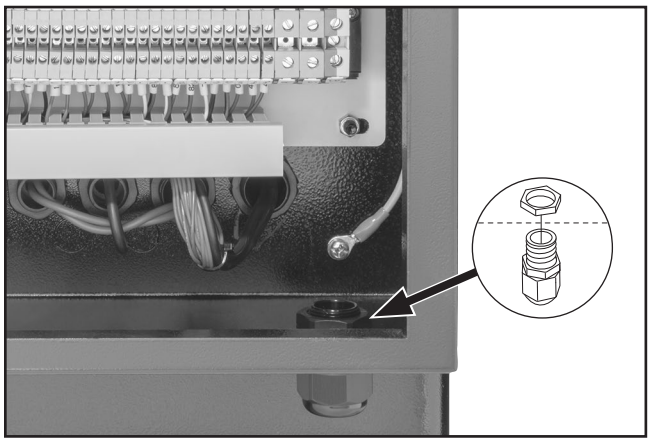


**Figure 42.** Power supply strain relief installed (G0408 shown).

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**.

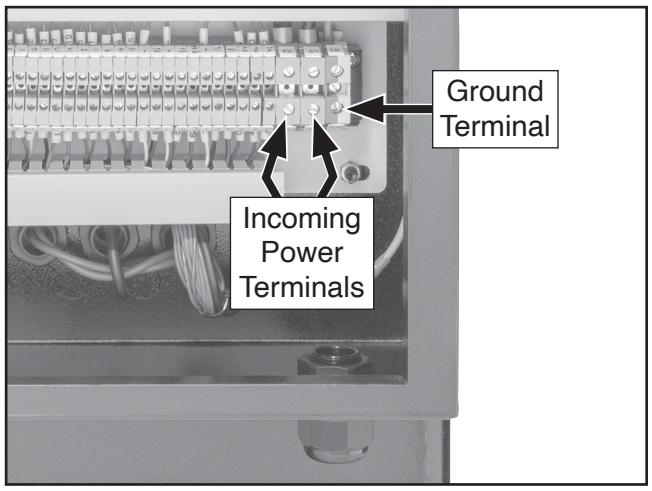



**Figure 43.** Location of G0408/G0409 ground and power wire terminals (G0408 shown).

**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**.

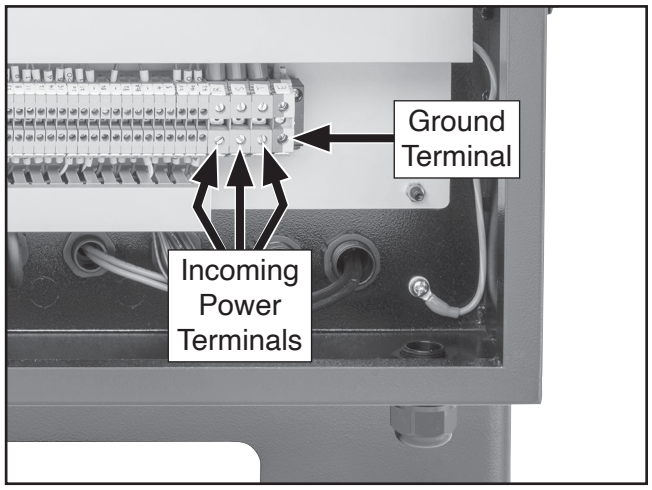



**Figure 44.** Location of G0411 ground and power wire terminals.

**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.

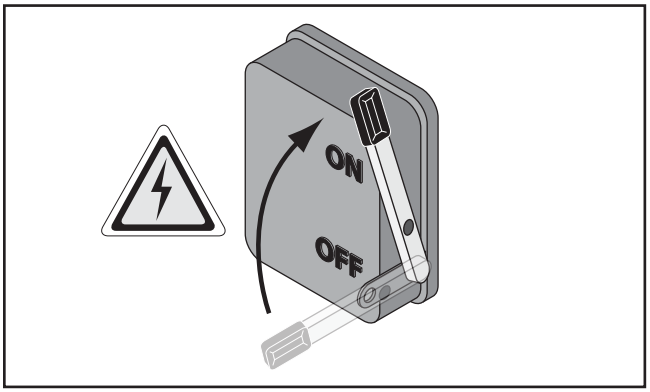



**Figure 45.** Connecting power to machine.

## 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.*

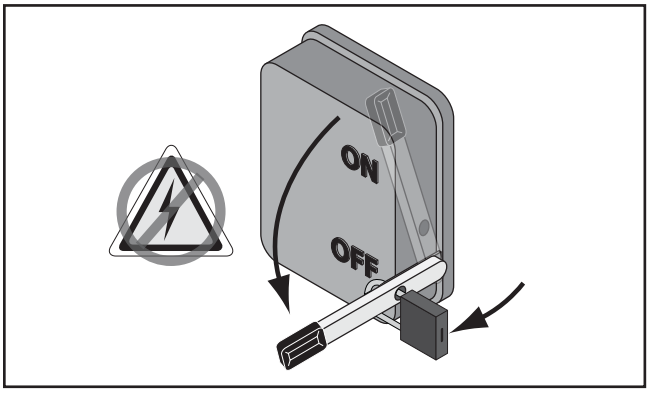



**Figure 46.** Disconnecting power from machine.

# 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.

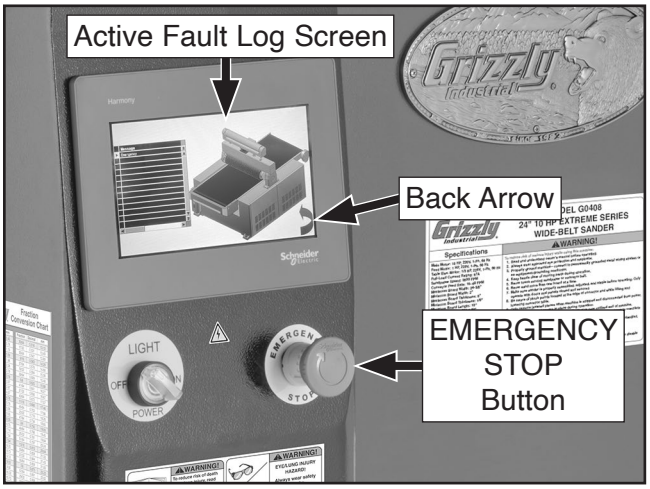



**Figure 47.** Active fault log screen and location of EMERGENCY STOP button (G0408 shown).

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**).

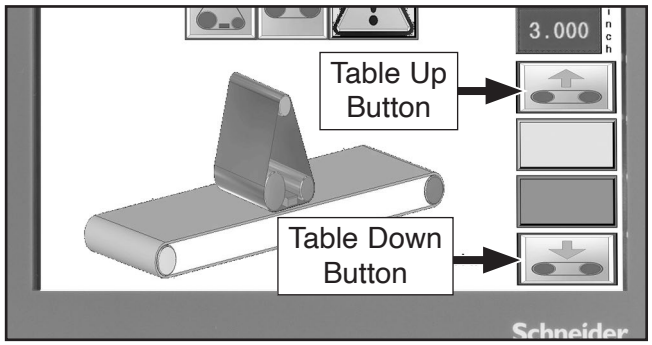



**Figure 49.** Location of Model G0411 table up/down buttons.

— 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.

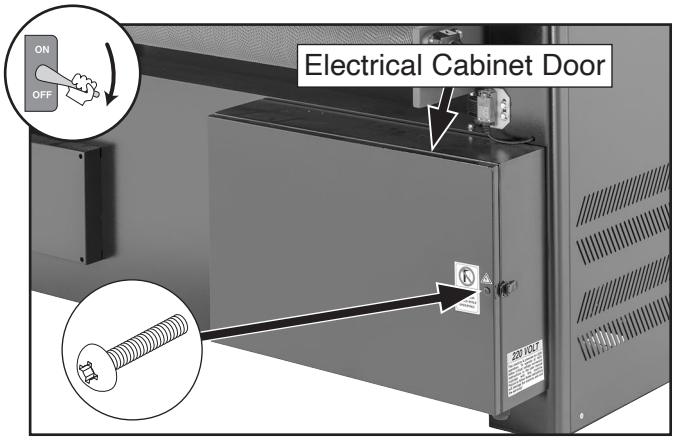



**Figure 50.** Location of Model G0411 electrical cabinet door and screw.

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

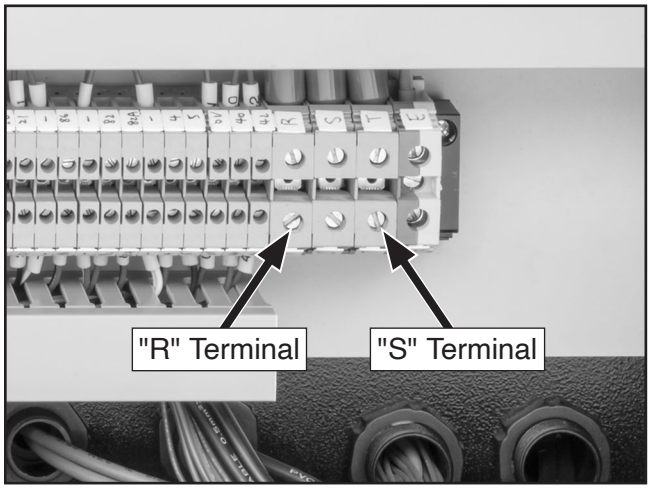



**Figure 51.** Location of Model G0411 "R" and "S" power supply terminals.

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.

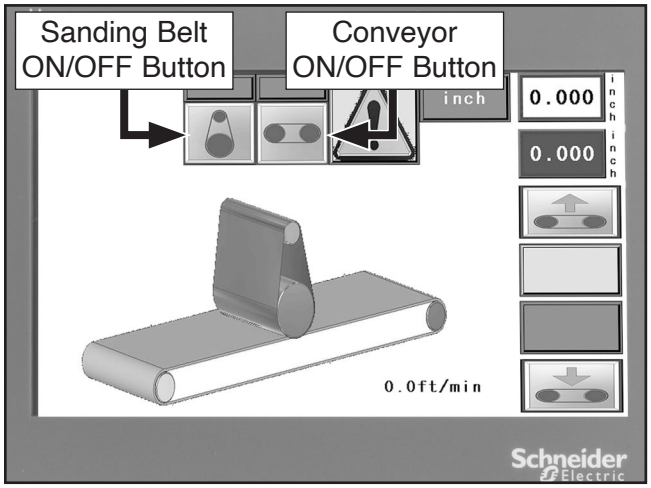



**Figure 52.** Location of sanding belt and conveyor ON/OFF buttons (G0408 shown).

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**).

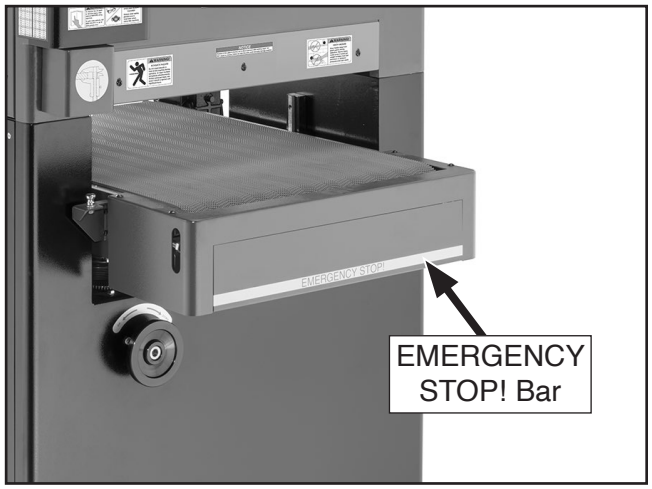



**Figure 53.** Location of EMERGENCY STOP! bar (G0408 shown).

— 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.

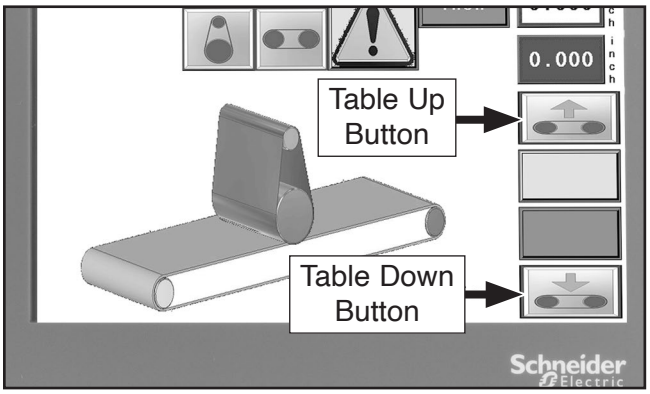



**Figure 55.** Location of table up and down buttons (G0408 shown).

— 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.

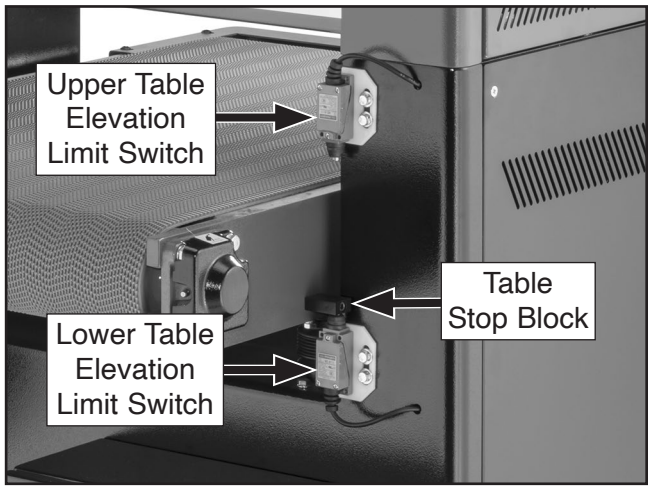



**Figure 56.** Location of table elevation limit switches and stop block.

— 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*

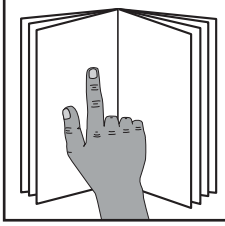
**To prevent damage and unnecessary wear and tear to conveyor gearbox, change conveyor gearbox oil after first 100 hours of use (about 3 months). Refer to maintenance schedule for following oil changes.**

# 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.



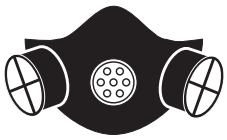
**⚠WARNING**

**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**).

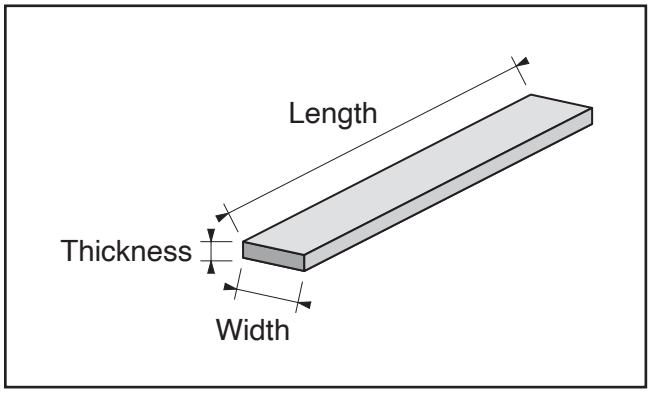



**Figure 57.** Minimum dimensions for sanding.

- 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**).

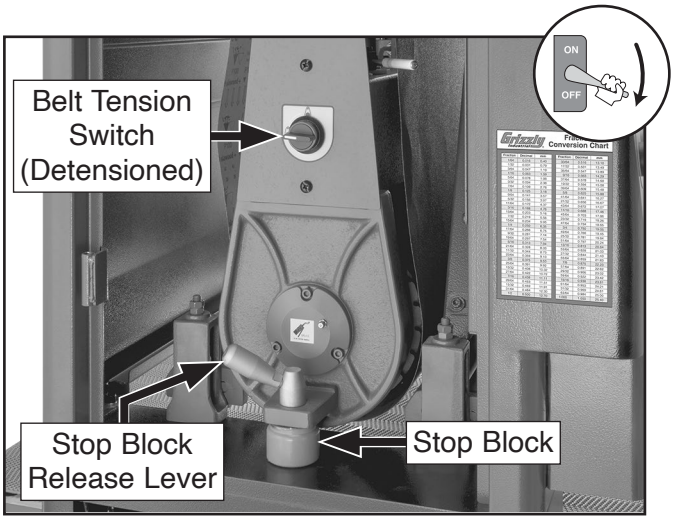



**Figure 58.** Components for changing Model G0408 sanding belt.

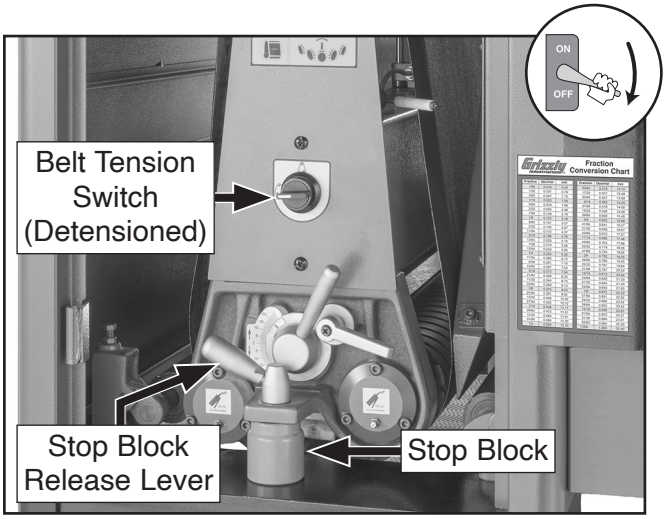



**Figure 59.** Components for changing Model G0409/G0411 sanding belt.

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.**

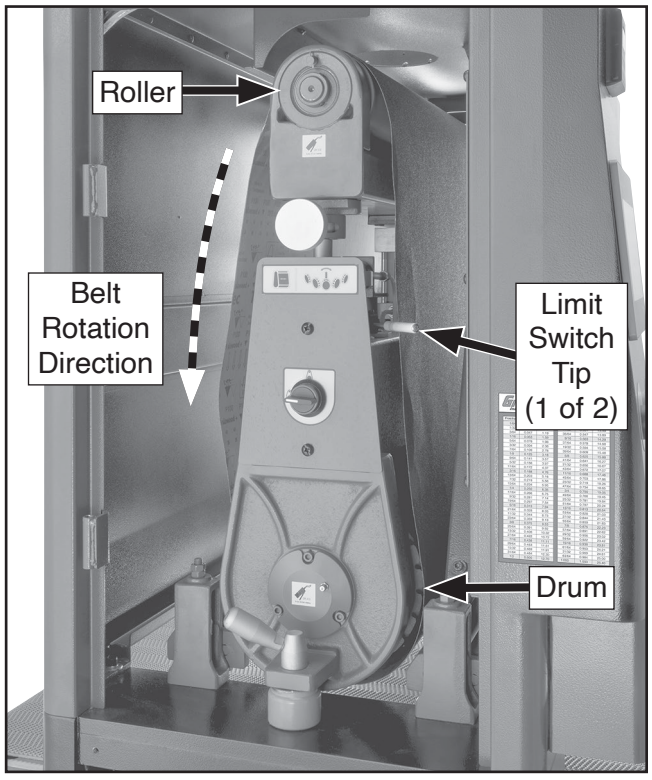



**Figure 60.** Model G0408 sanding belt installed correctly.

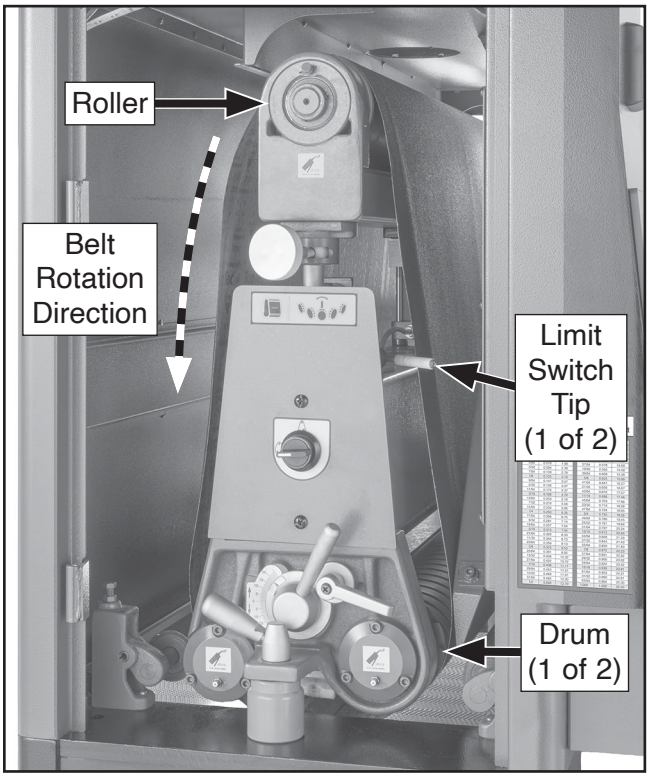



**Figure 61.** Model G0409/G0411 sanding belt installed correctly.

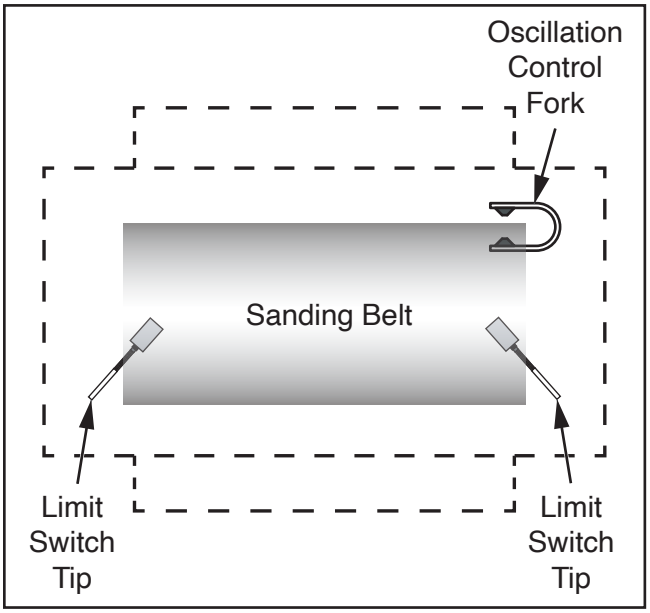



**Figure 62.** Sander outline (top view) of proper position of belt.

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.

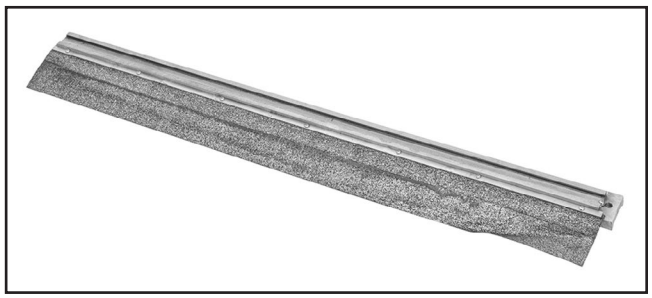


**Figure 63.** Platen removed from machine (example shown).

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.

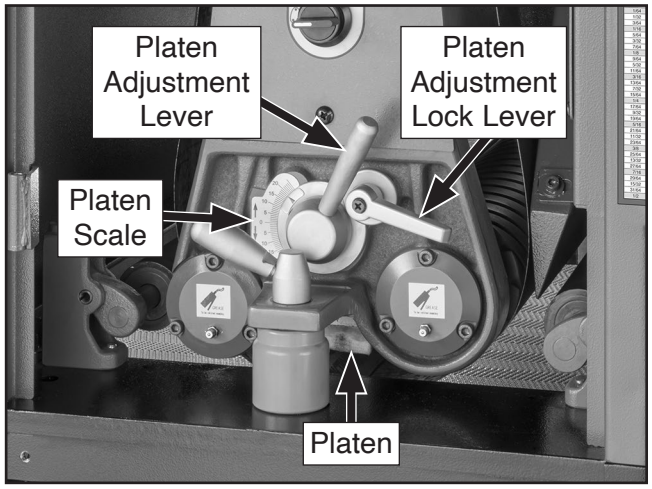



**Figure 64.** Platen height components.

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**.

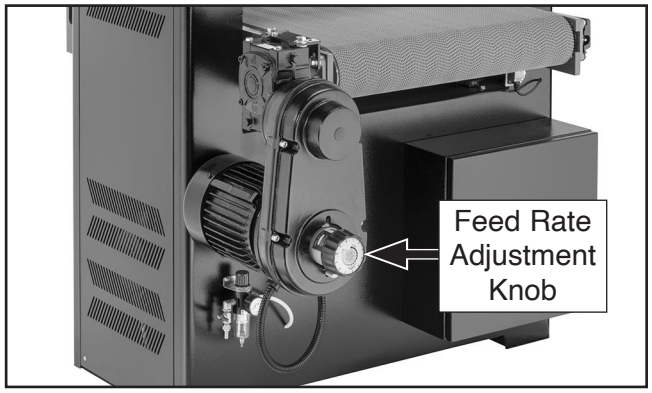



**Figure 65.** Location of feed rate adjustment knob (G0408 shown).

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.

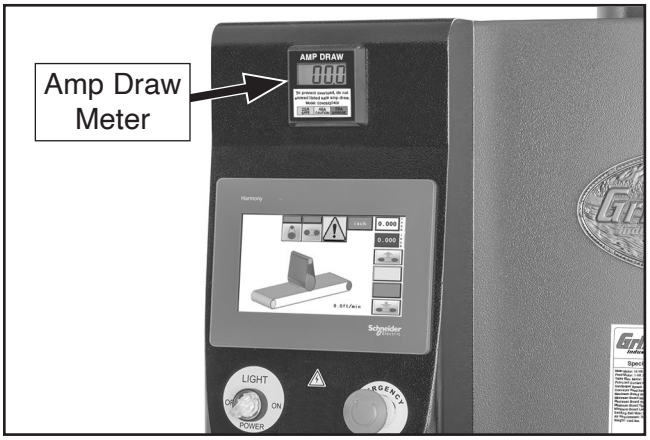



**Figure 66.** Location of amp draw meter (G0408 shown).

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.

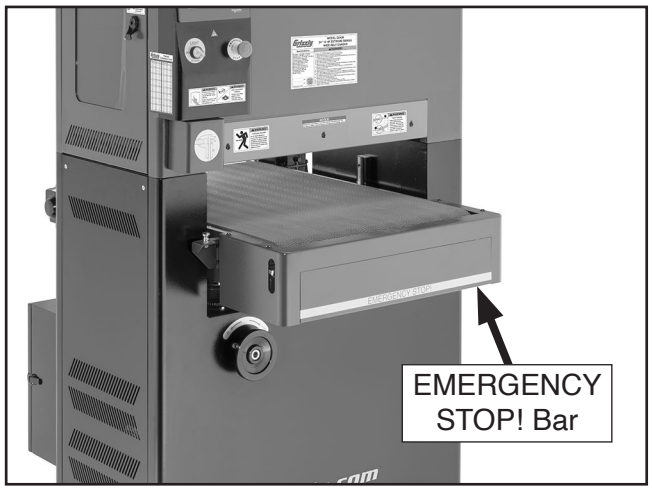



**Figure 67.** Location of EMERGENCY STOP! bar (G0408 shown).

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**).

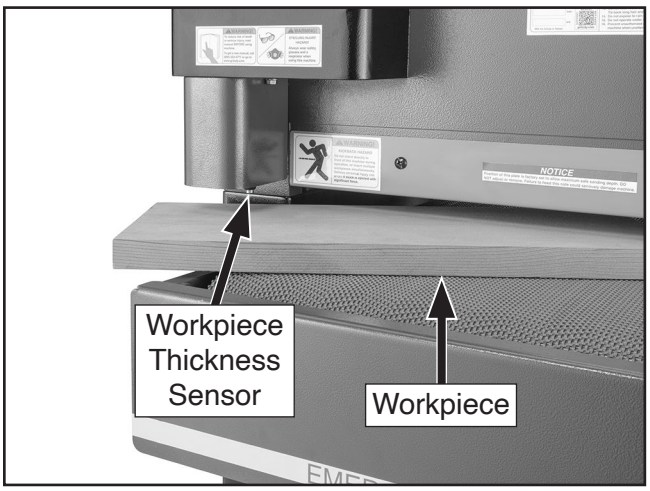



**Figure 68.** Workpiece under workpiece thickness sensor (example shown).

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.

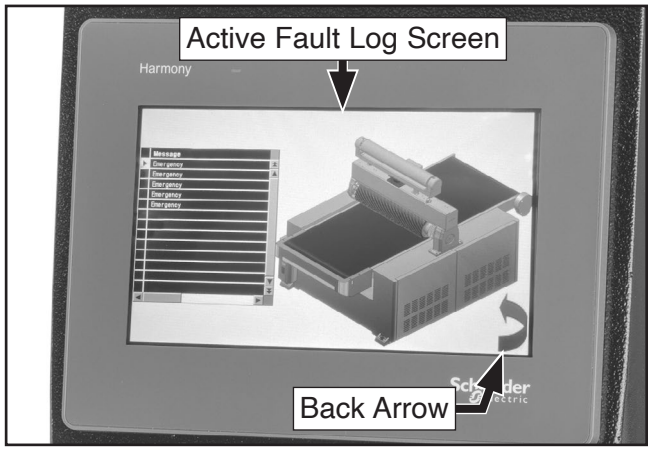



**Figure 69.** Active fault log screen.

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.

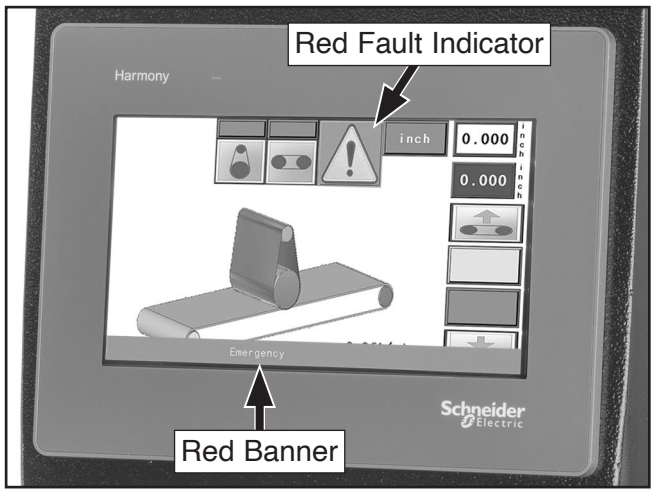



**Figure 70.** Main menu screen showing fault (G0408 shown).

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**.

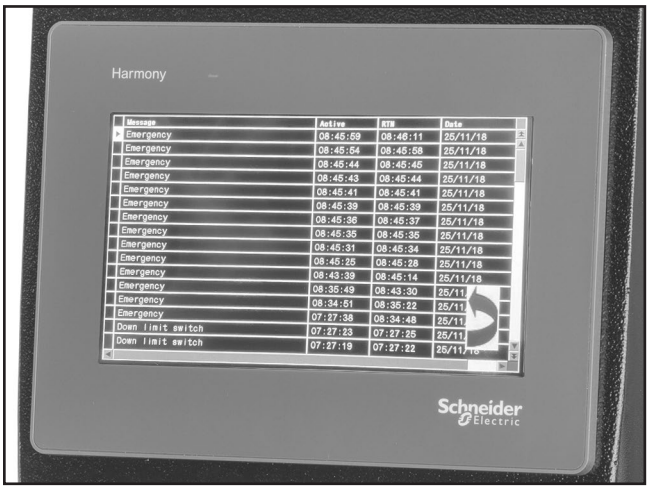



**Figure 71.** Fault log screen.

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.

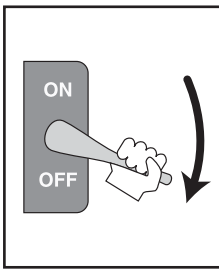
**Ongoing**
To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- 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.

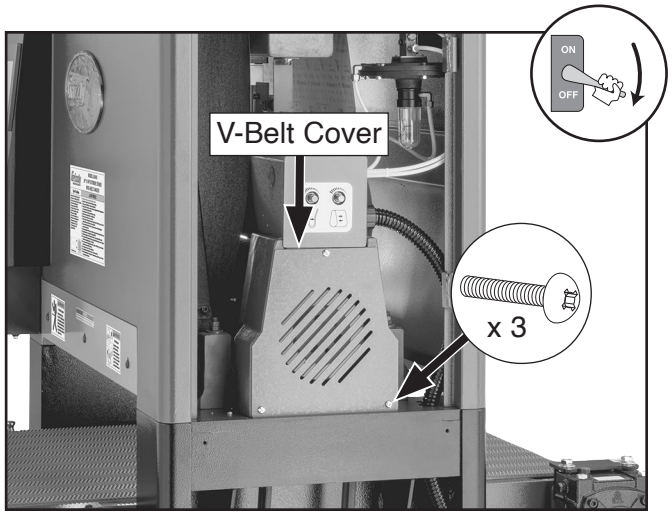



**Figure 72.** Location Model G0408 V-belt cover and screws.

**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.*

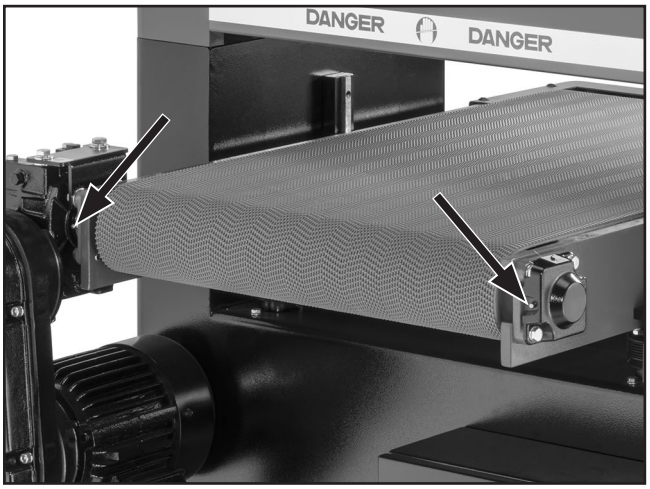



**Figure 73.** Location of conveyor belt roller grease fittings (G0408 shown).

**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**).

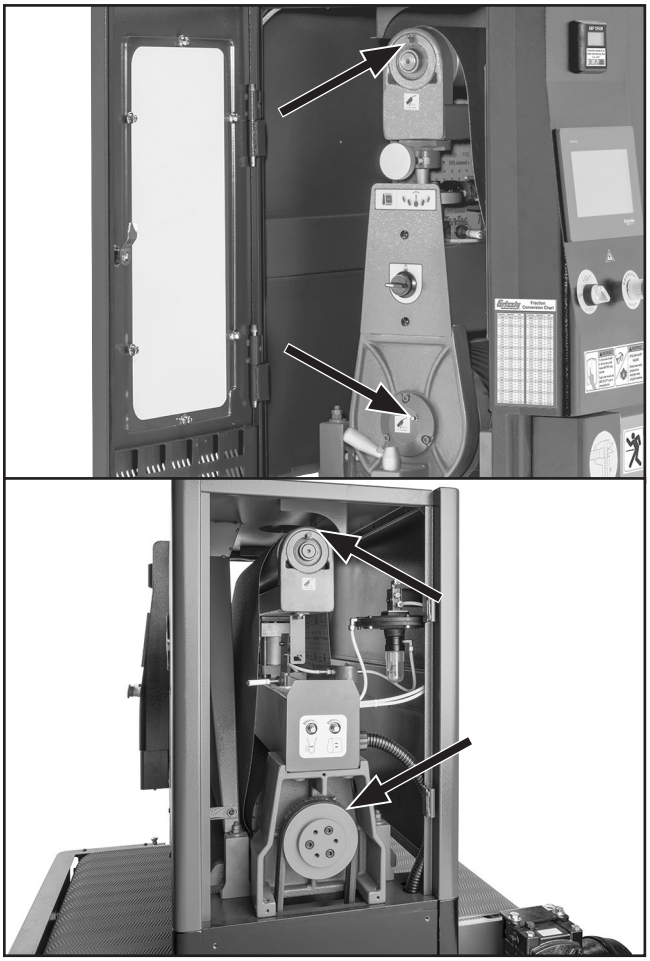


**Figure 74.** Location of Model G0408 sanding belt roller and drum grease fittings.

**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.*

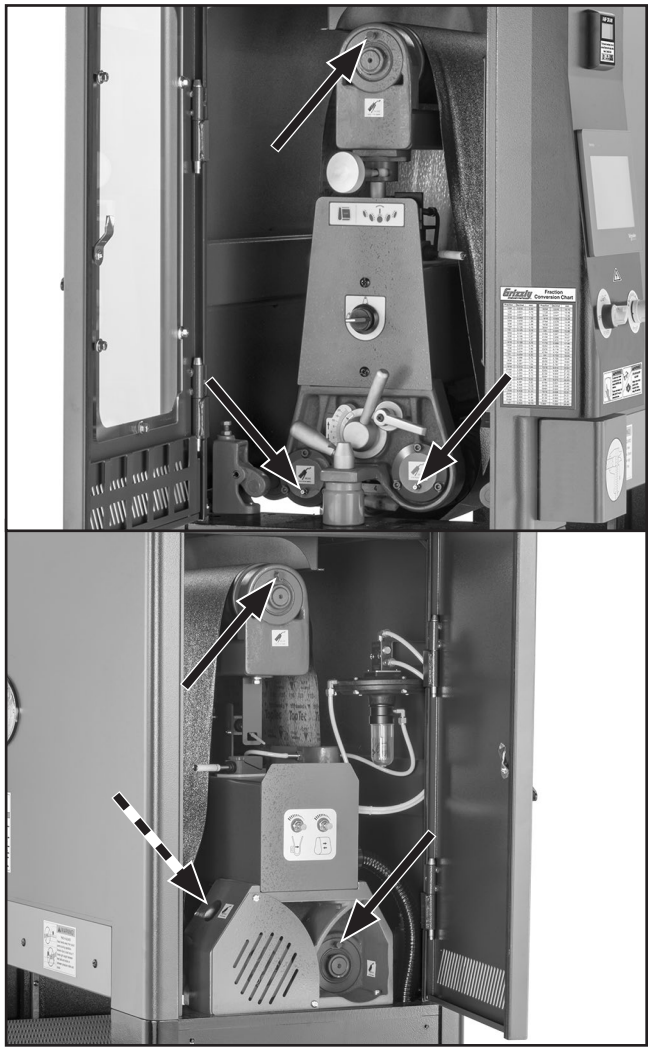


**Figure 75.** Location of Model G0409/G0411 sanding belt roller and drum grease fittings.

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.

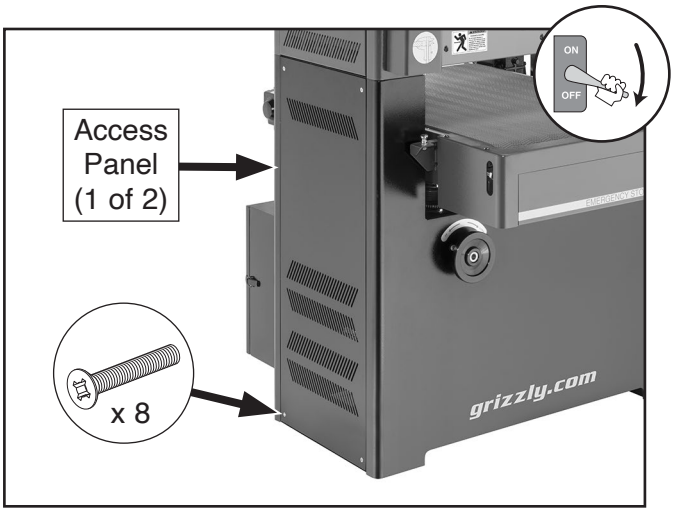



**Figure 76.** Location of access panels and screws (G0408 shown).

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**).

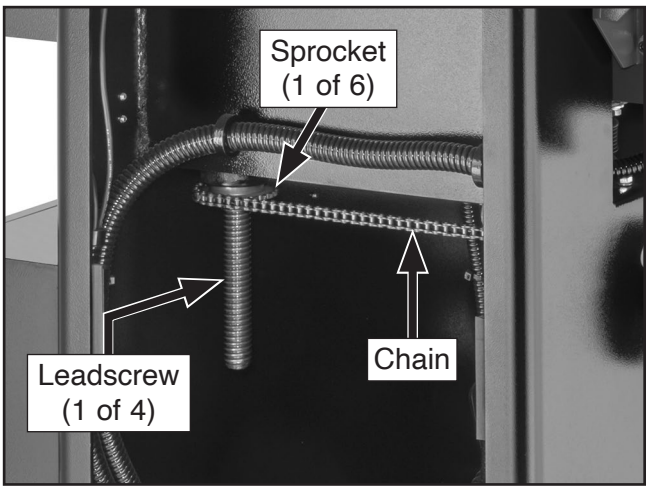



**Figure 77.** Location of table elevation chain, leadscrews, and sprockets.

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.

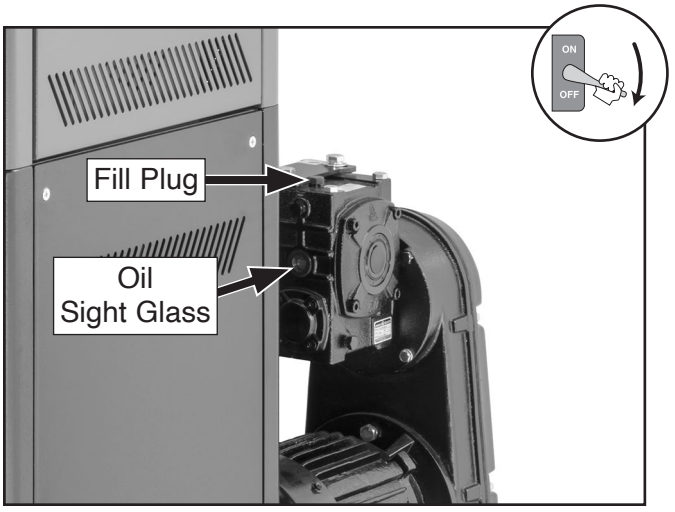



**Figure 78.** Conveyor gearbox oil filling components.

## 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.

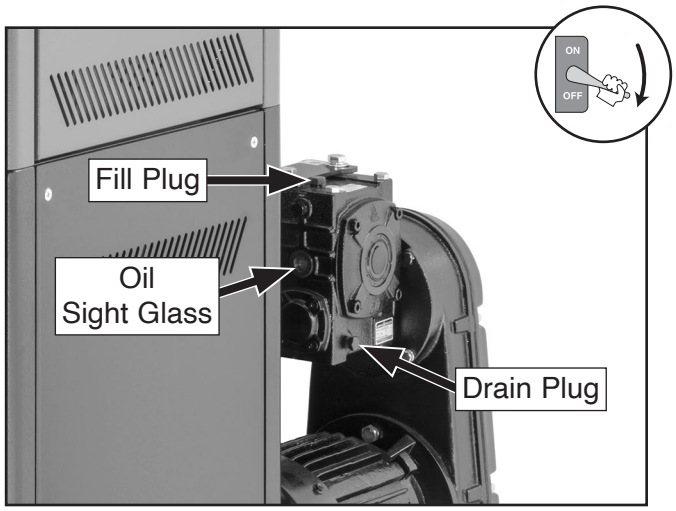



**Figure 79.** Conveyor gearbox oil components.

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.

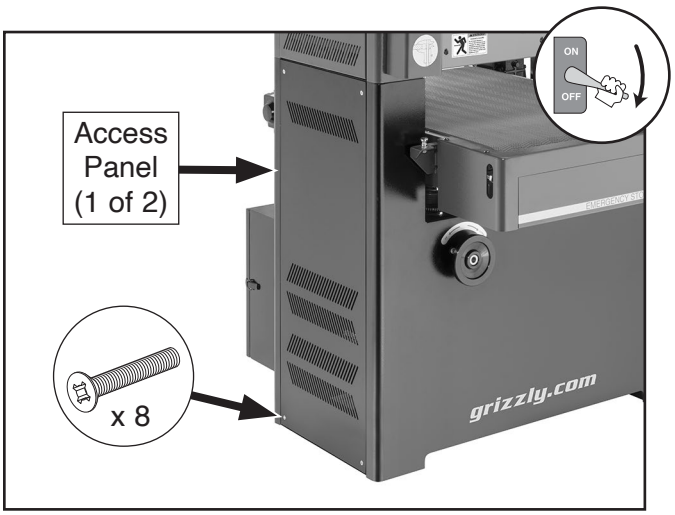



**Figure 80.** Location of access panels and screws (G0408 shown).

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**.

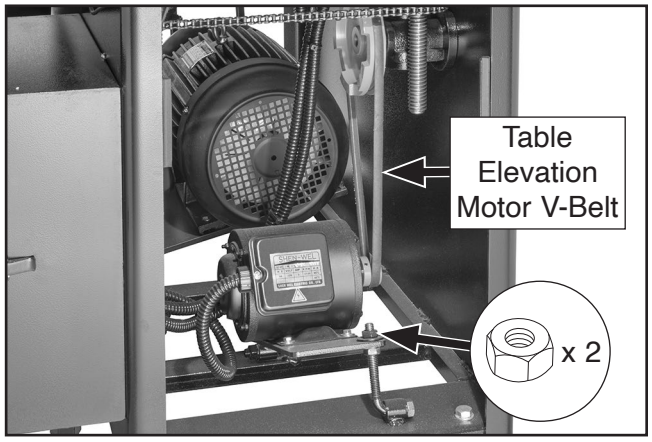



**Figure 81.** Location of table elevation motor V-belt components (G0408 shown).

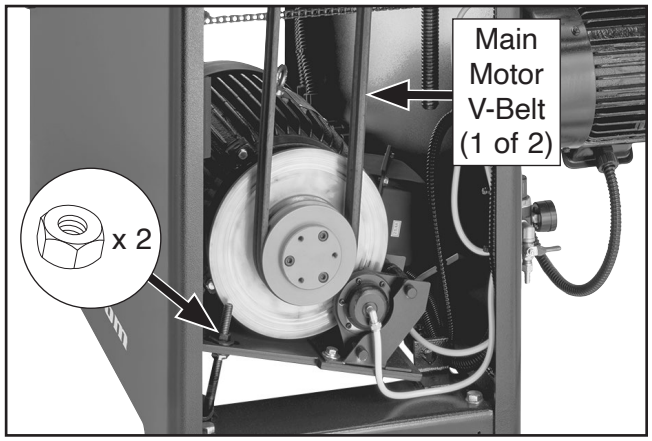



**Figure 82.** Location of Model G0408 main motor V-belt components.

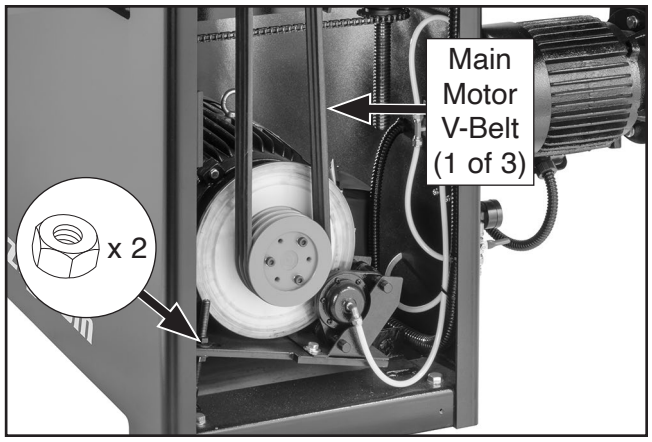



**Figure 83.** Location of Model G0409/G0411 main motor V-belt components (G0409 shown).

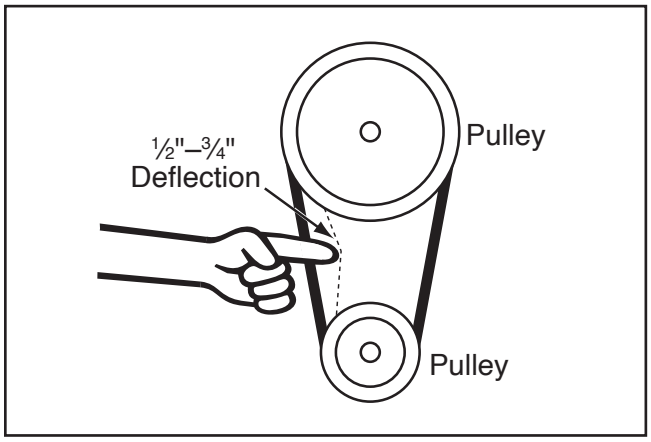



**Figure 84.** Checking V-belt tension.

— 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.

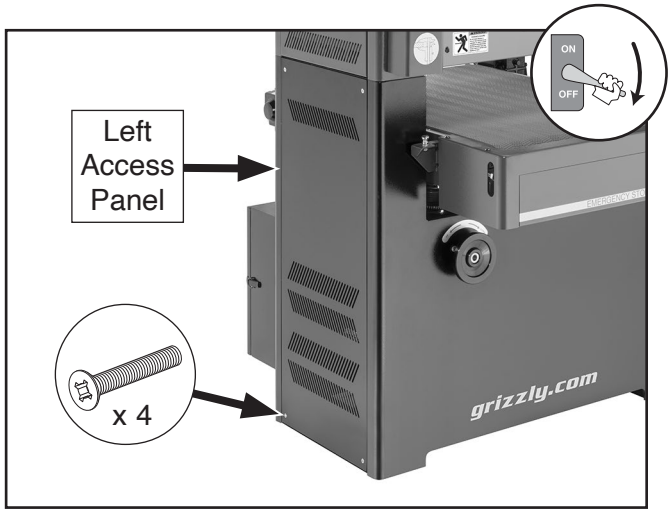



**Figure 85.** Location of left access panel and screws (G0408 shown).

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**).

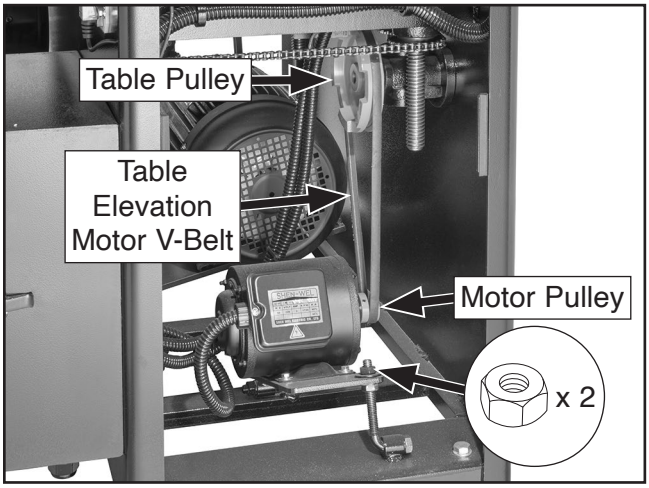



**Figure 86.** Table elevation motor V-belt components (G0408 shown).

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.

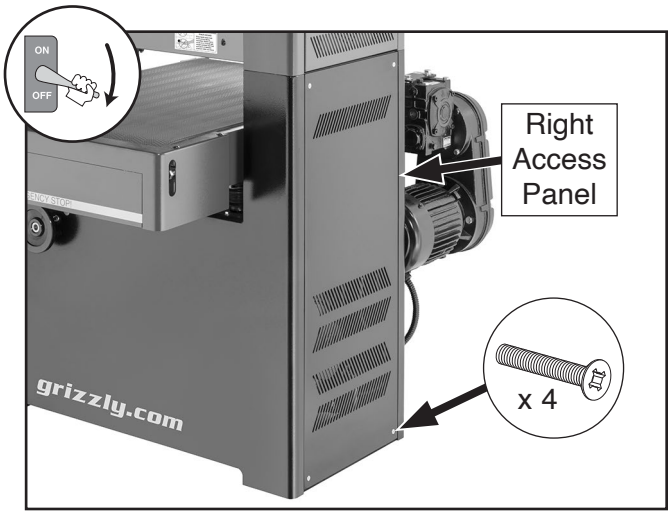



**Figure 87.** Location of right access panel and screws (G0408 shown).

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.

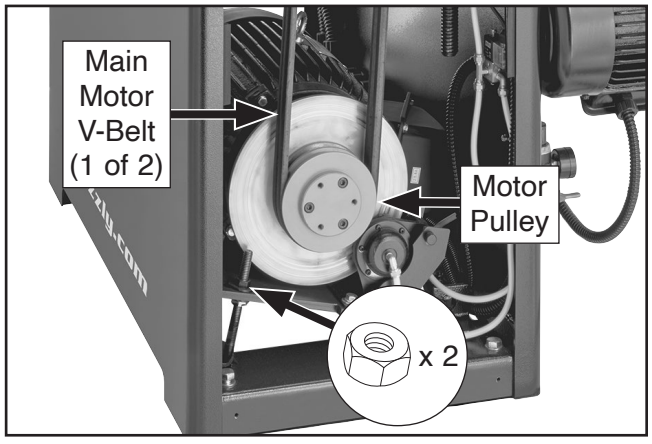



**Figure 88.** Model G0408 main motor V-belt components.

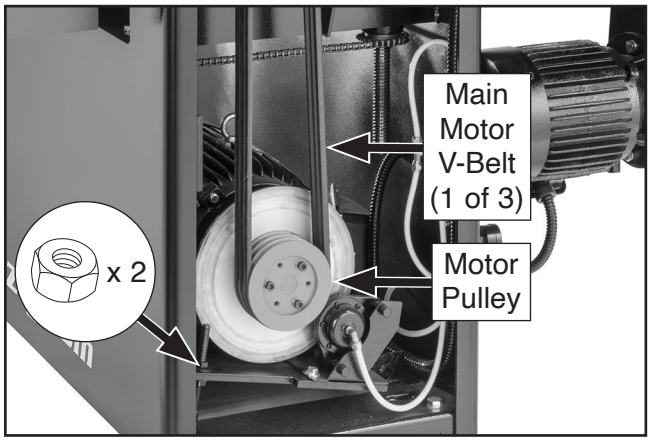



**Figure 89.** Model G0409/G0411 main motor V-belt components (G0409 shown).

**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.

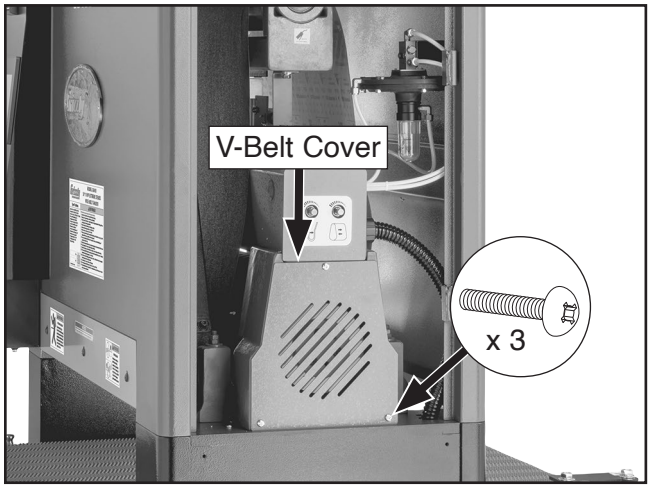



**Figure 90.** Location of Model G0408 V-belt cover and screws.

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

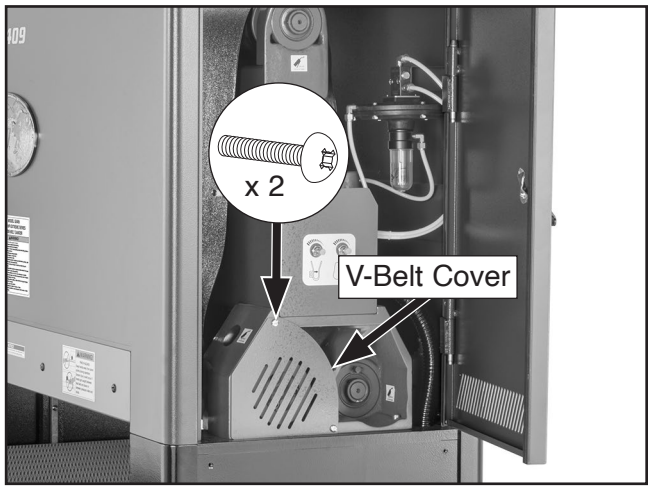



**Figure 91.** Location of G0409/G0411 V-belt cover and screws (G0409 shown).

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

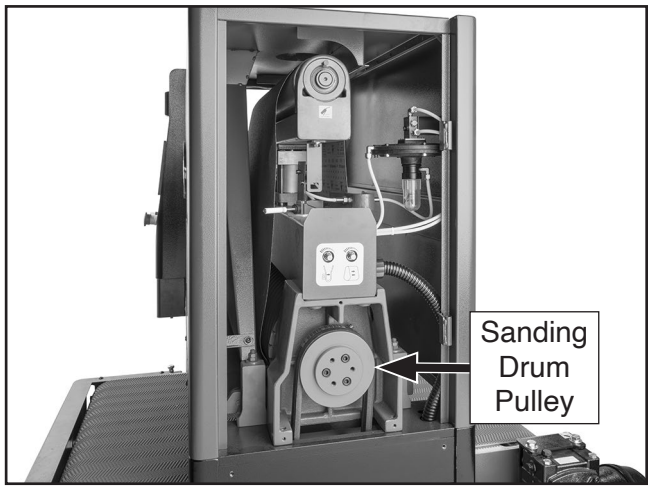



**Figure 92.** Location of Model G0408 sanding drum pulley.




**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.

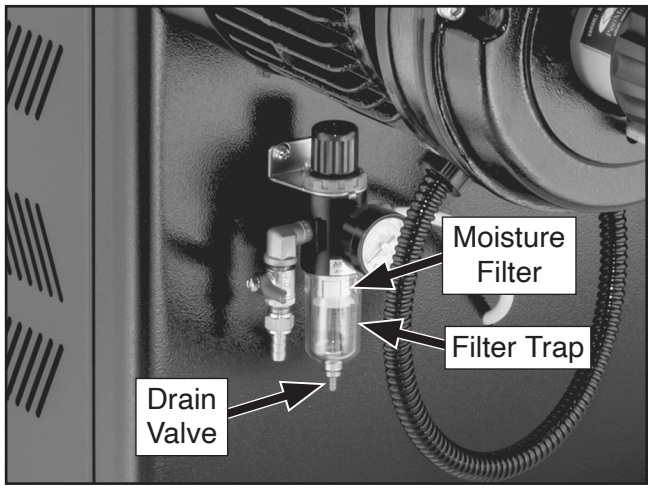



**Figure 94.** Regulator filter trap components.

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.

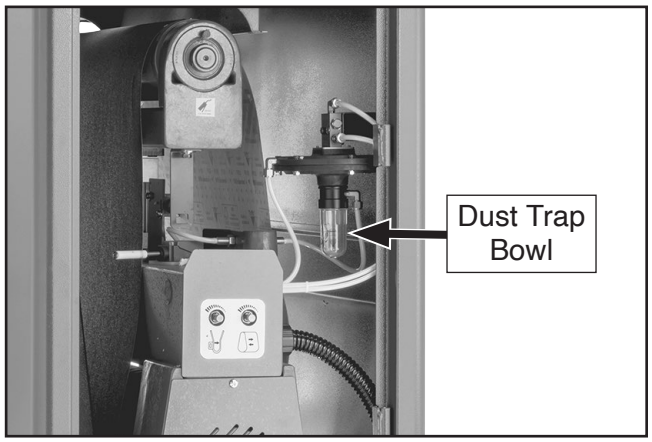



**Figure 95.** Location of dust trap bowl (G0408 shown).

# 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:**

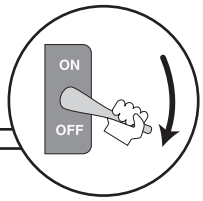
1. Set table elevation to thickness of cleaning pad.

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.<br>2. Blown fuse.<br>3. Incorrect power supply voltage or circuit size.<br>4. Wiring broken, disconnected, or corroded. | 1. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.<br>2. Replace fuse/ensure no shorts.<br>3. Ensure correct power supply voltage and circuit size.<br>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.<br>2. Power supply circuit breaker tripped or fuse blown.<br>3. Thermal overload relay has tripped.<br>4. Blown fuse.<br>5. Incorrect power supply voltage or circuit size.<br>6. Motor wires connected incorrectly.<br>7. Centrifugal switch needs adjustment/contact points dirty (Model G0408/G0409 only).<br>8. Wiring broken, disconnected, or corroded.<br>9. Timer/start delay module adjusted incorrectly (Model G0411 only).<br>10. Motor or motor bearings at fault. | 1. Use fault message to determine required action (**Page 49**).<br>2. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.<br>3. Reset relay.<br>4. Replace fuse/ensure no shorts.<br>5. Ensure correct power supply voltage and circuit size.<br>6. Correct motor wiring connections (**Page 87**).<br>7. Adjust centrifugal switch/clean contact points.<br>8. Fix broken wires or disconnected/corroded connections (**Page 87**).<br>9. Adjust to correct delay.<br>10. Replace motor. |
| Machine stalls or is underpowered. | 1. Motor wires connected incorrectly.<br>2. Motor overheated.<br>3. Centrifugal switch needs adjustment/contact points dirty (Model G0408/G0409 only).<br>4. Motor or motor bearings at fault.<br>5. Timer/start delay module adjusted incorrectly (Model G0411 only). | 1. Correct motor wiring connections (**Page 87**).<br>2. Clean motor, let cool, and reduce workload.<br>3. Adjust centrifugal switch/clean contact points.<br>4. Replace motor.<br>5. Adjust to correct delay. |
| Machine has vibration or noisy operation. | 1. Motor or component loose.<br>2. Motor mount loose/broken.<br>3. Motor fan rubbing on fan cover.<br>4. Centrifugal switch needs adjustment (Model G0408/G0409 only).<br>5. Motor bearings at fault. | 1. Replace damaged or missing bolts/nuts or tighten if loose.<br>2. Tighten/replace.<br>3. Fix/replace fan cover; replace loose/damaged fan.<br>4. Adjust switch.<br>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.<br>2. Feed rate too high.<br>3. Excessive depth of cut.<br>4. Sanding belt grit too fine for particular job.<br>5. Sanding belt clogged/worn.<br>6. V-belt(s) slipping/pulleys misaligned.<br>7. Pulley/sprocket slipping on shaft.<br>8. Conveyor gearbox at fault. | 1. Only sand wood/ensure moisture is below 20% (**Page 42**).<br>2. Reduce feed rate (**Page 47**).<br>3. Reduce depth of cut (**Page 41**).<br>4. Replace with coarser grit sanding belt (**Page 44**).<br>5. Clean (**Page 59**)/replace (**Page 44**) sanding belt.<br>6. Clean/tension/replace V-belts(s) (**Page 54**); ensure pulleys are aligned.<br>7. Tighten/replace loose pulley/shaft.<br>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.<br>2. V-belt(s) worn, loose, pulleys misaligned or belt slapping cover.<br>3. Pulley loose.<br>4. Conveyor gearbox at fault. | 1. Replace sanding belt (**Page 44**).<br>2. Inspect/replace belt(s) (**Page 54**). Realign pulleys if necessary.<br>3. Inspect pulleys. Replace or tighten if necessary.<br>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.<br>2. Sanding belt worn unevenly.<br>3. Conveyor table not parallel to sanding drum. | 1. Replace conveyor belt (**Page 80**).<br>2. Feed workpieces across sanding belt to distribute wear evenly, not just on one side.<br>3. Adjust conveyor table parallelism (**Page 75**). |
| Workpiece slips on conveyor belt. | 1. Conveyor belt dirty.<br>2. Pressure rollers set too high.<br>3. Conveyor belt worn. | 1. Clean conveyor belt.<br>2. Lower pressure rollers (**Page 77**).<br>3. Replace conveyor belt (**Page 80**). |
| Grooves down length of workpiece. | 1. Platen felt/graphite damaged.<br>2. Sanding belt dirty/damaged. | 1. Replace graphite pad or felt pad (**Page 68**).<br>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.<br>2. Using amp draw meter to establish material removal amount.<br>3. Worn sanding belt.<br>4. Rear pressure roller too low. | 1. Increase feed rate (**Page 47**).<br>2. Use more accurate method to establish correct material removal amount (**Page 41**).<br>3. Replace sanding belt (**Page 44**).<br>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.<br>2. Excessive depth of cut.<br>3. Using amp draw meter to establish material removal amount.<br>4. Wood is too moist. | 1. Replace with coarser grit sanding belt (**Page 44**).<br>2. Reduce depth of cut (**Page 41**).<br>3. Use more accurate method to establish correct material removal amount (**Page 41**).<br>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.<br>2. Air leaks in system.<br>3. Belt tension cylinder shaft worn/damaged. | 1. Adjust air pressure to 75 PSI at regulator.<br>2. Inspect all hoses and connections for leaking air; use water/soap mixture on suspected area to detect bubbles.<br>3. Repair/replace belt tension cylinder. |
| Sanding belt runs off to one side, stopping sander. | 1. Oscillation speed/timing not adjusted correctly.<br>2. Oscillation control fork gap/air lines clogged.<br>3. Solenoid valve/air manifold at fault. | 1. Adjust oscillation speed/timing (**Page 65**).<br>2. Clean fork gap/air lines.<br>3. Test/repair/replace. |
| Poor, non-aggressive sanding results. | 1. Sanding belt clogged/worn.<br>2. Sanding belt grit too fine for particular job.<br>3. Conveyor table not parallel to sanding drum. | 1. Clean (**Page 59**) /replace (**Page 44**) sanding belt.<br>2. Replace with coarser grit (**Page 44**).<br>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.<br>2. Sanding belt not tensioned. | 1. Connect machine to compressed air system.<br>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.<br>2. Conveyor belt has incorrect tension. | 1. Clean conveyor rollers.<br>2. Adjust conveyor rollers to place more tension on conveyor belt (**Page 79**). |
| Emergency brake stops slowly. | 1. Low air pressure.<br>2. Air leaks in system.<br>3. Main motor brake disc contaminated with oil.<br>4. Brake pads worn out or disc brake assembly is not functioning correctly. | 1. Adjust incoming air pressure to 75 PSI at regulator.<br>2. Inspect hoses/connections for leaking air; use water/soap mixture on suspected area to detect bubbles.<br>3. Clean brake disc with automotive brake parts cleaner.<br>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.<br>2. Water filter/trap drain valve open.<br>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.<br>2. Ensure water filter/trap drain valve is closed and tight (**Page 59**).<br>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.<br>2. Dust collector underpowered. | 1. Redesign dust collection system.<br>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**.

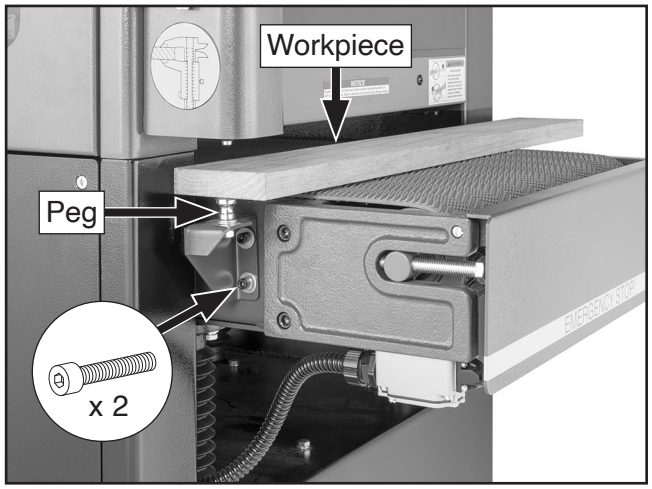



**Figure 97.** Workpiece resting on workpiece thickness peg (example shown).

— 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**).

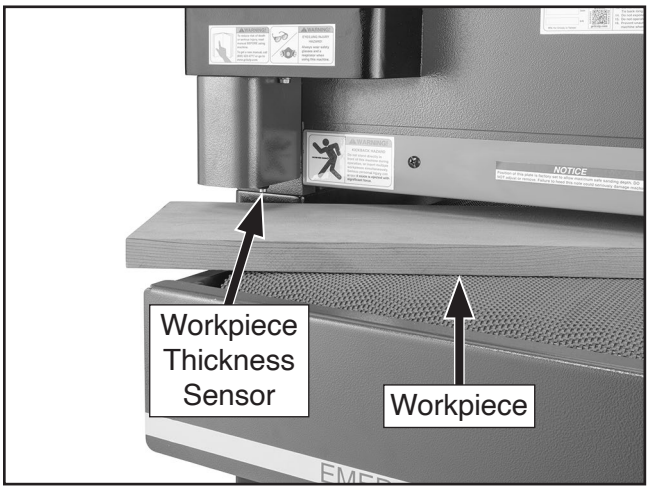



**Figure 98.** Workpiece under workpiece thickness sensor and sanding drum (example shown).

**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.

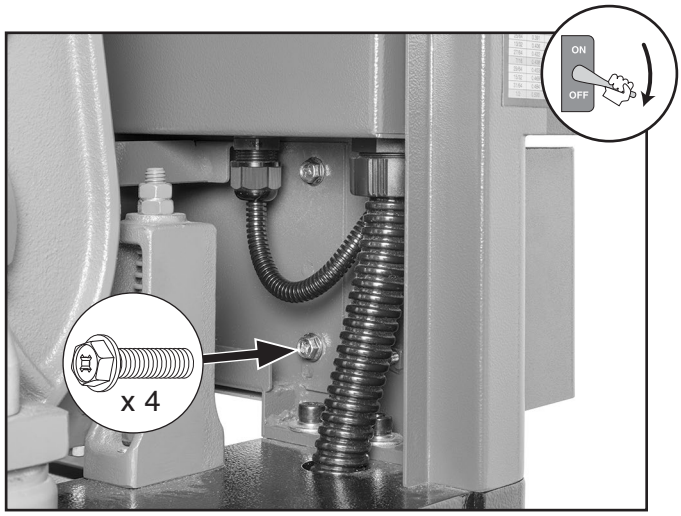



**Figure 99.** Location of sensor cover bolts (G0408 shown).

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

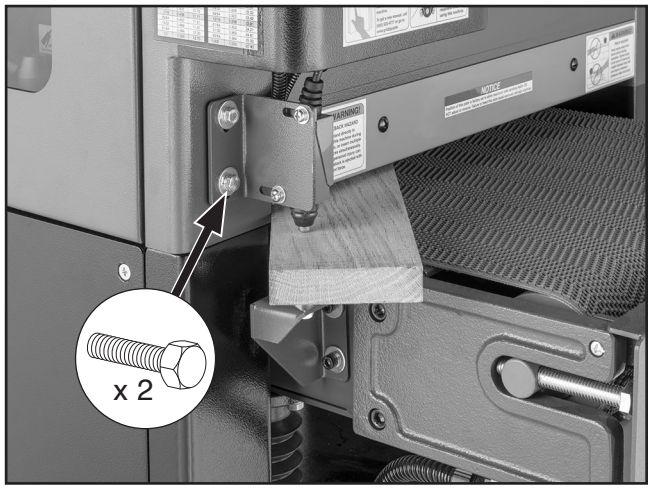



**Figure 100.** Workpiece thickness sensor calibration hex bolts (example shown).

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.

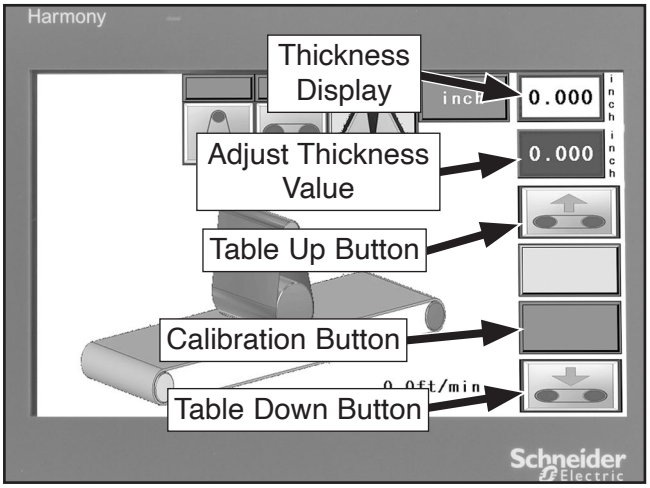



**Figure 101.** Location of thickness display calibration components (G0408 shown).

# 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.

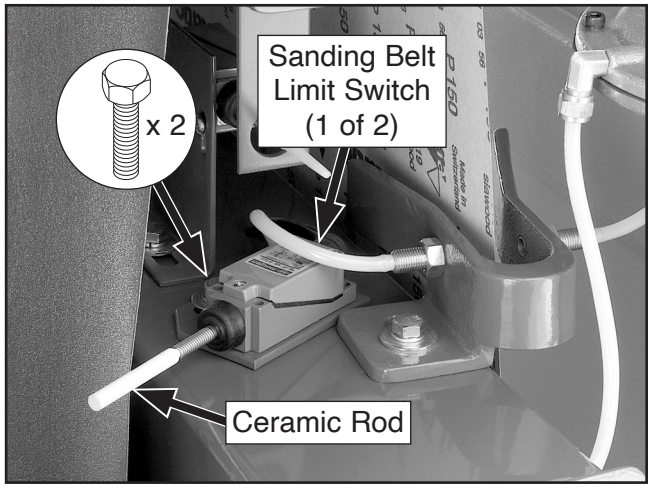



**Figure 102.** Limit switch adjustment components.

| 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.

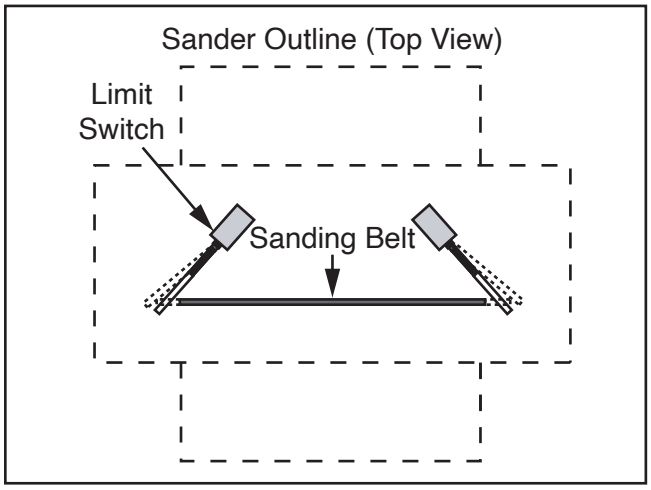



**Figure 103.** Improper oscillation.

## 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.

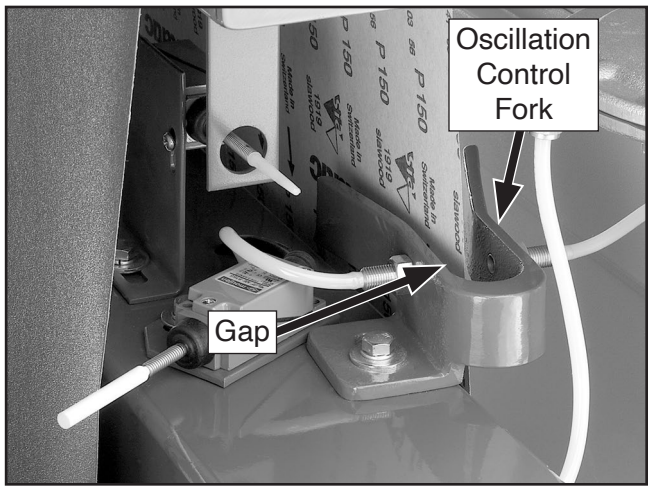



**Figure 104.** Oscillation control fork components.

| 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.

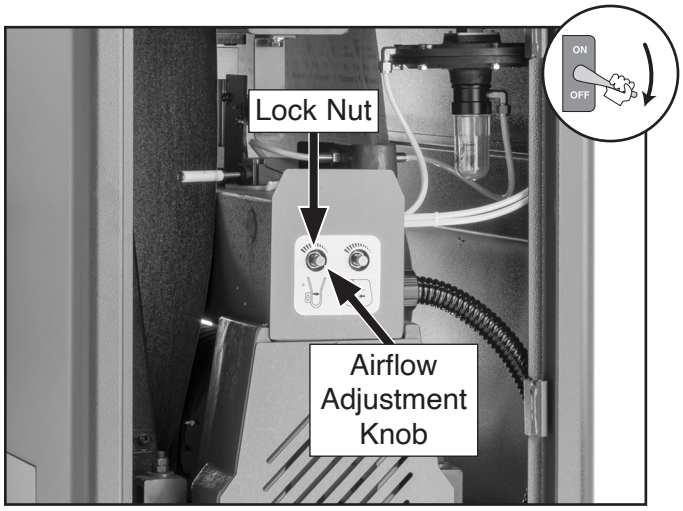



**Figure 105.** Airflow adjustment components (G0408 shown).

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.

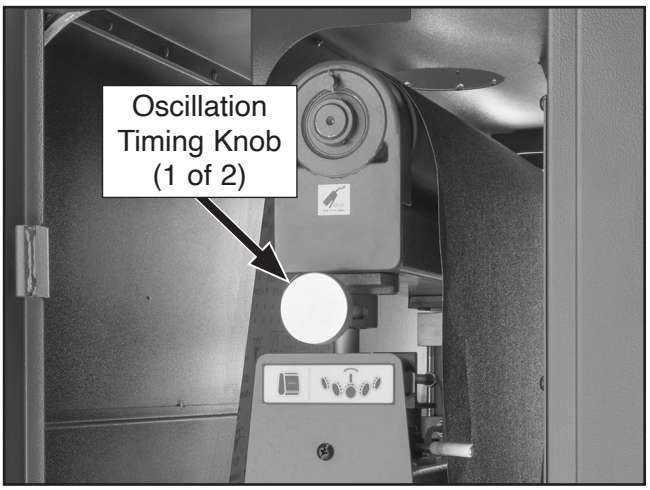



**Figure 106.** Location of oscillation timing knob.

## 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.

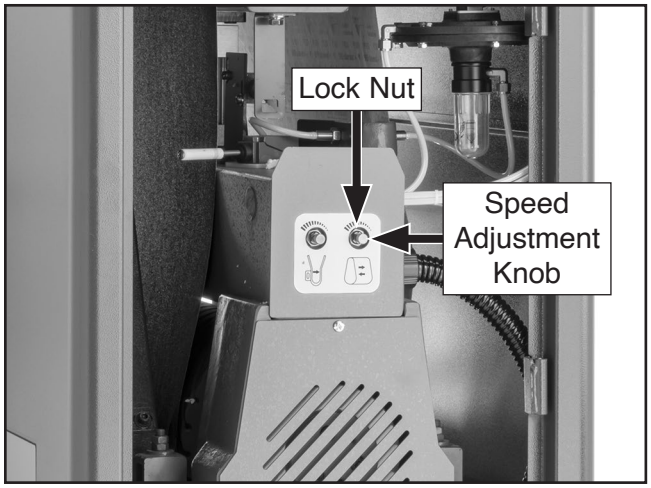



**Figure 107.** Oscillation speed adjustment components (G0408 shown).

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**.

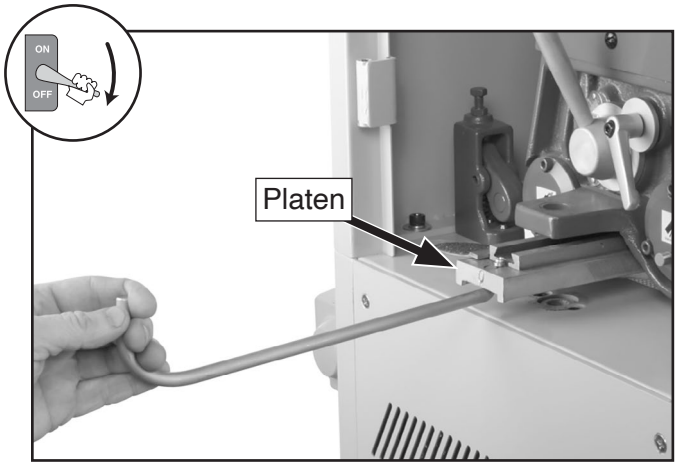



**Figure 108.** Removing platen (example shown).

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.

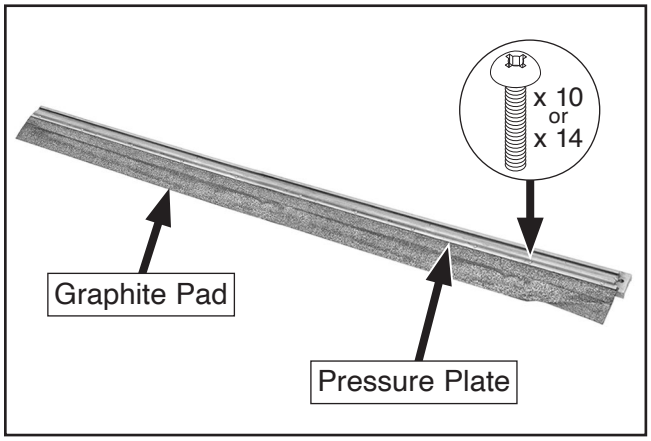



**Figure 109.** Typical platen components.

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**.

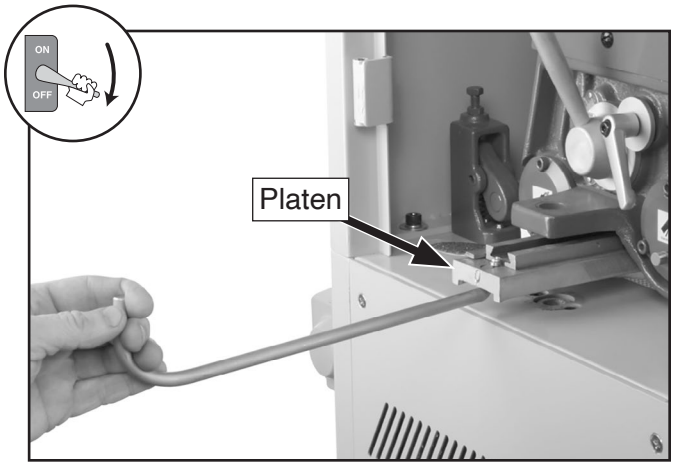



**Figure 110.** Removing platen (example shown).

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.

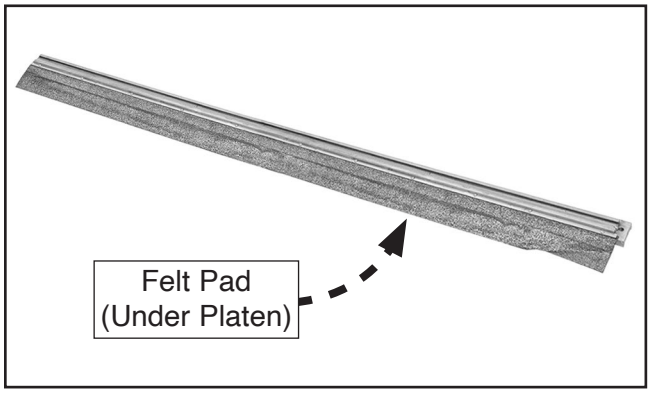



**Figure 111.** Location of felt pad.

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.

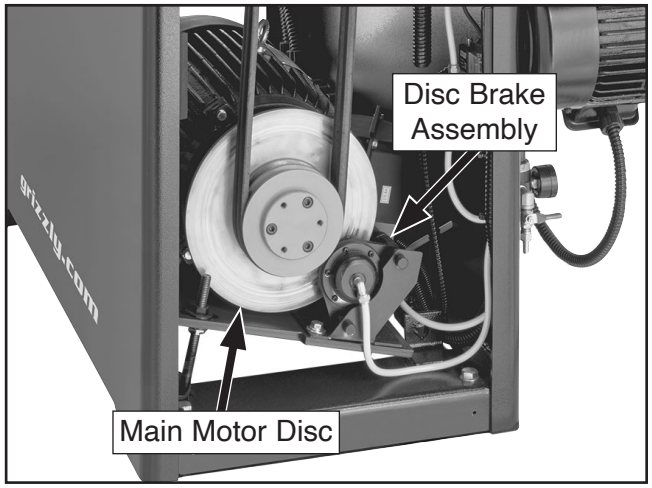



**Figure 112.** Location of Model G0408/G0409 main motor disc and disc brake assembly.

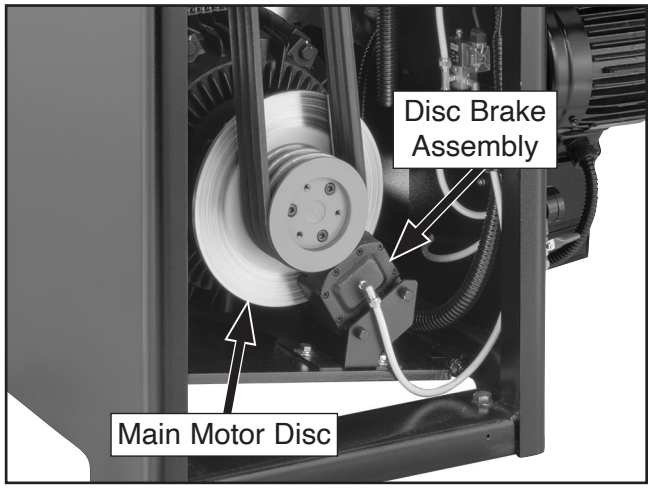



**Figure 113.** Location of Model G0411 main motor disc and disc brake assembly.

| 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**).

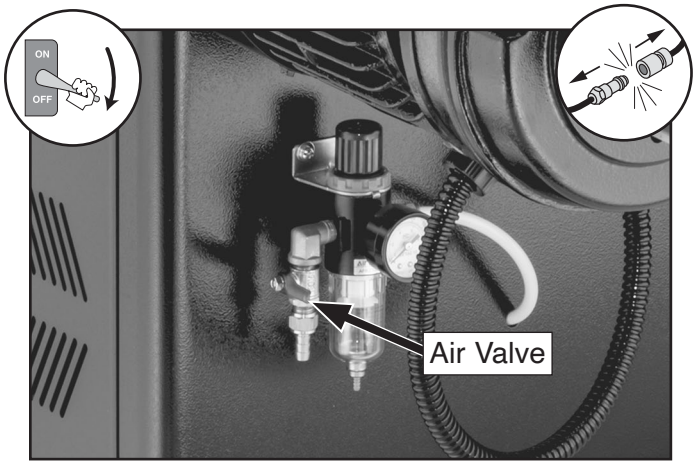



**Figure 114.** Location of air valve on regulator.

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

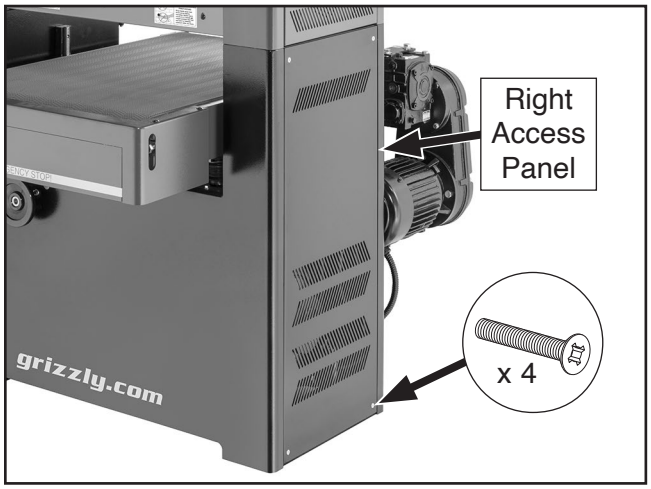



**Figure 115.** Location of right access panel and screws (G0408 shown).

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.

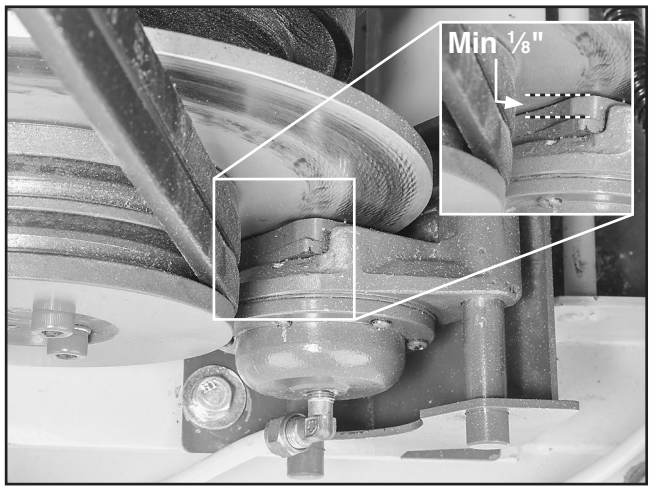



**Figure 116.** Measuring outer brake pad (example shown).

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

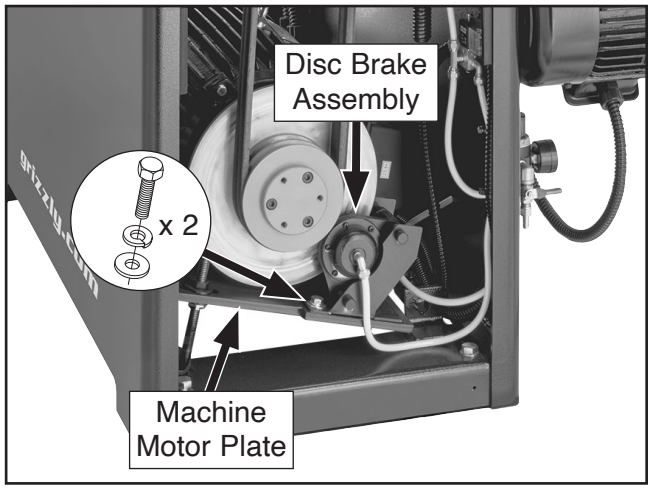



**Figure 117.** Model G0408/G0409 disc brake assembly removal components.

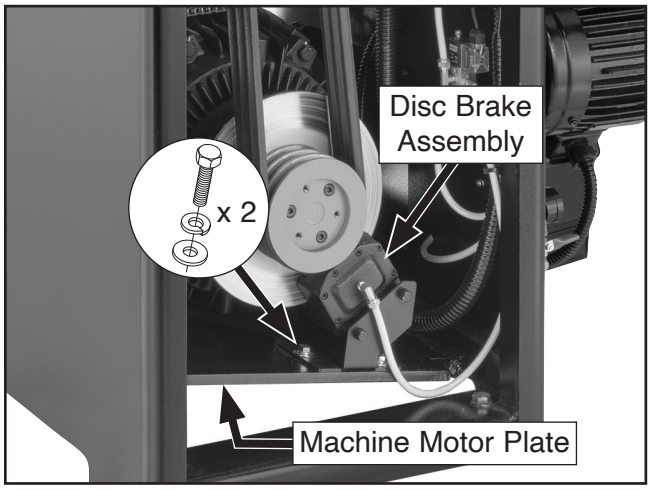



**Figure 118.** Model G0411 disc brake assembly removal components.

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.

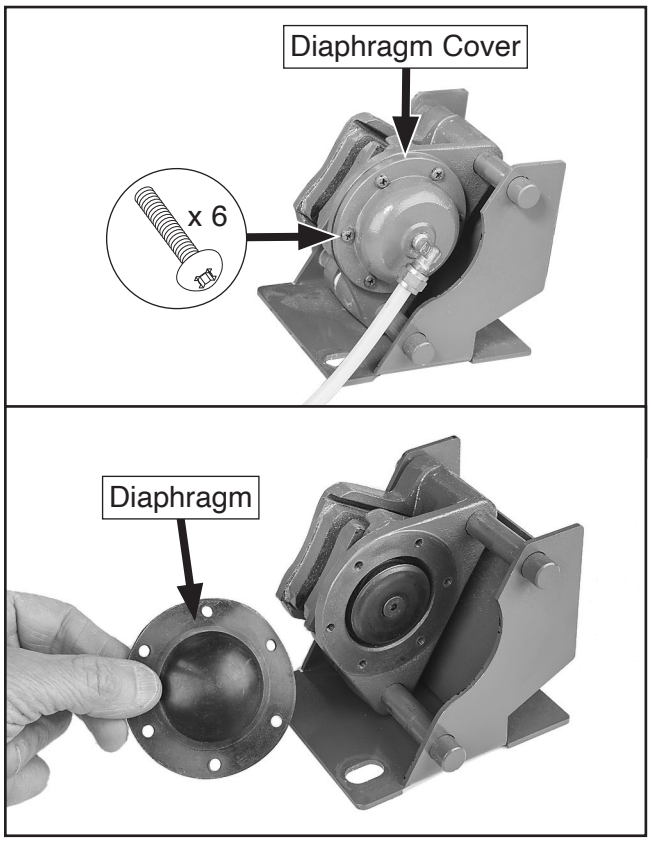



**Figure 119.** Location of Model G0408/G0409 diaphragm cover and diaphragm.

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

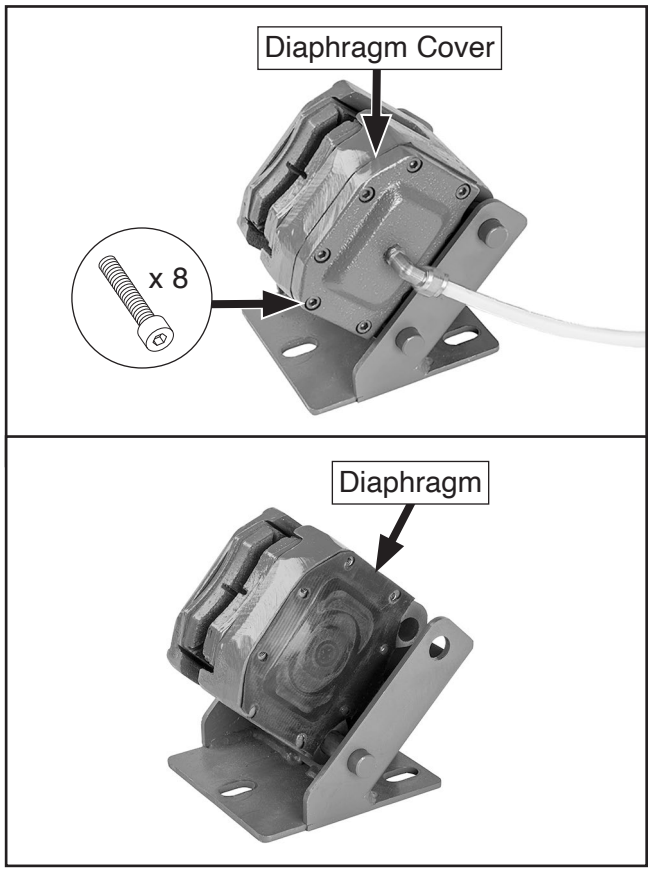



**Figure 120.** Location of Model G0411 diaphragm cover and diaphragm.

**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.*

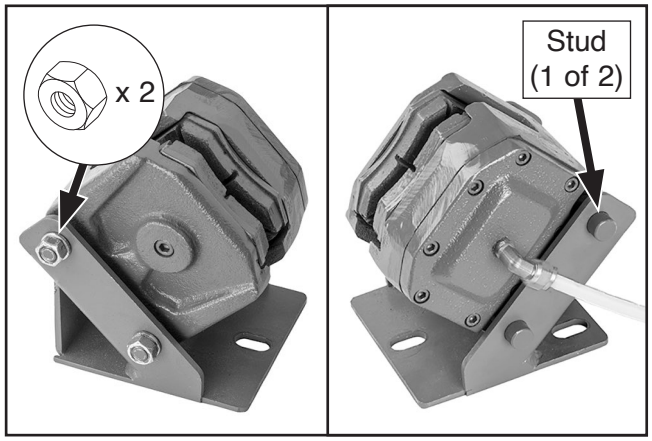



**Figure 121.** Location of Model G0411 caliper mounting studs and hex nuts.

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

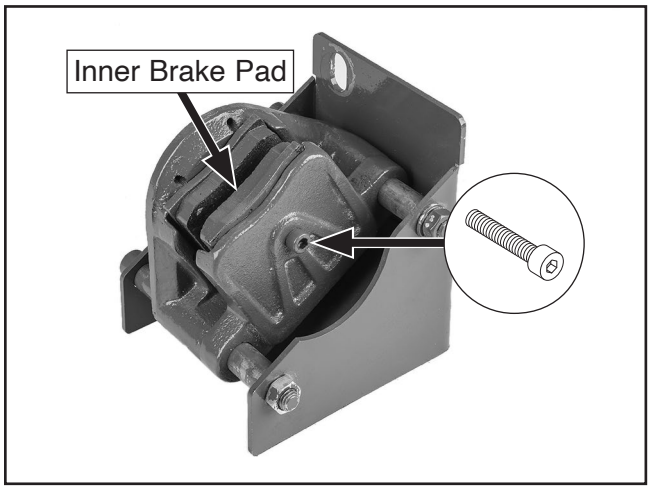



**Figure 122.** Location of Model G0408/G0409 inner brake pad and cap screw.

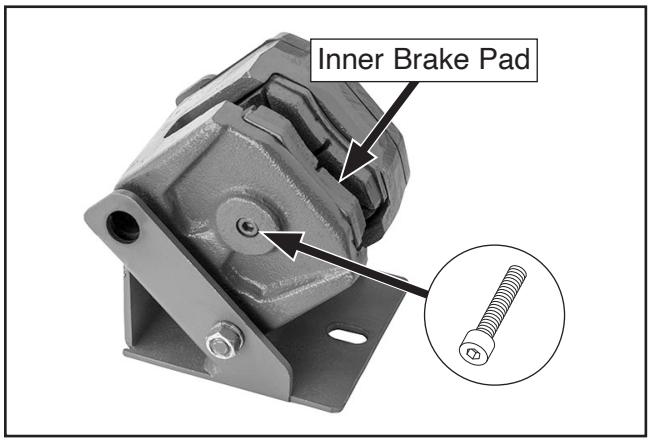



**Figure 123.** Location of Model G0411 inner brake pad and cap screw.

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.*

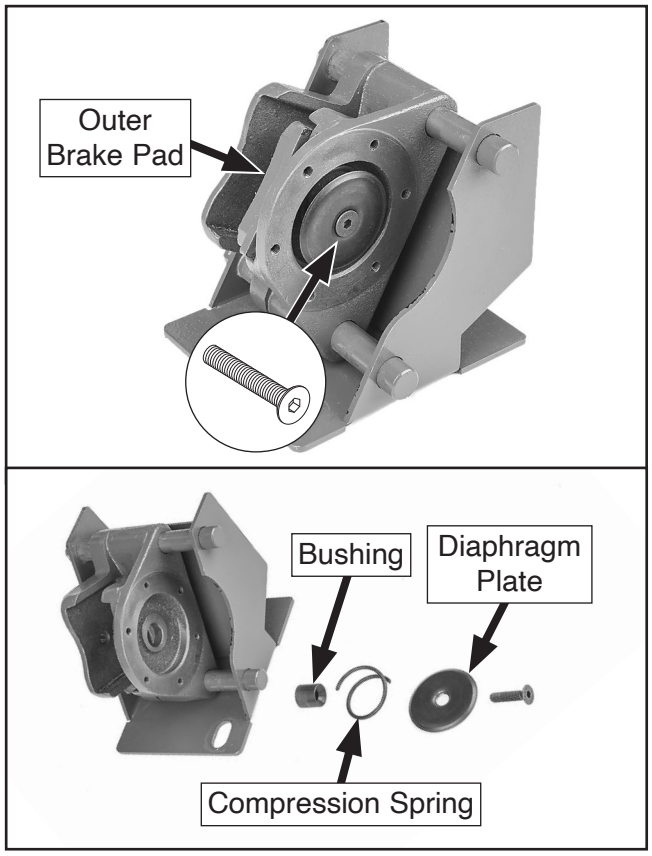



**Figure 124.** Model G0408/G0409 outer brake pad components.

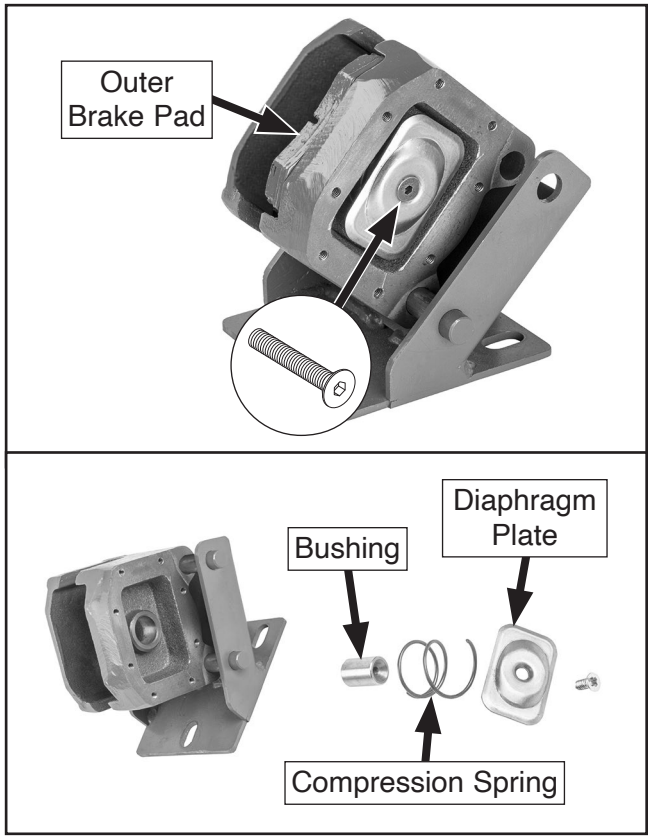



**Figure 125.** Model G0411 outer brake pad components.

**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**).

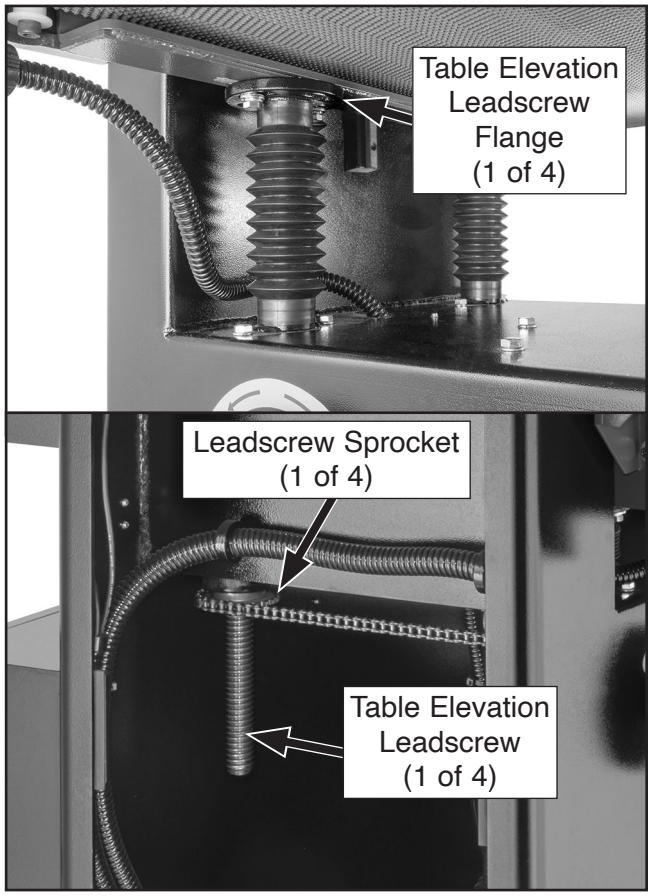



**Figure 126.** Location of table elevation adjustment components.

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.*

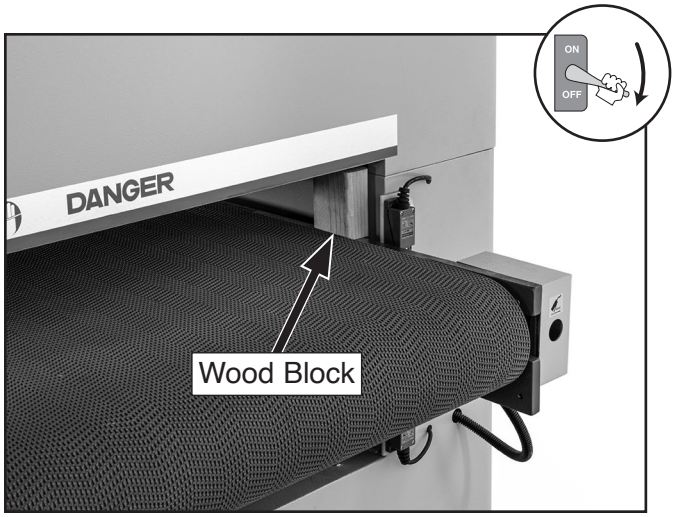



**Figure 127.** Wood block placed for checking table parallelism (example shown).

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

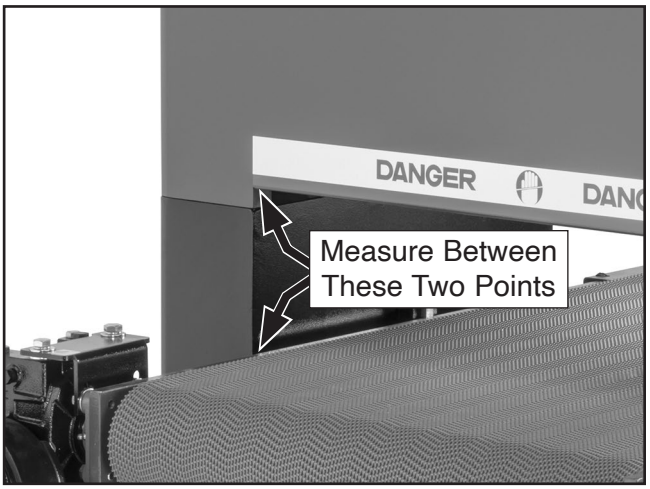



**Figure 128.** Distance to measure at rear right corner.

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

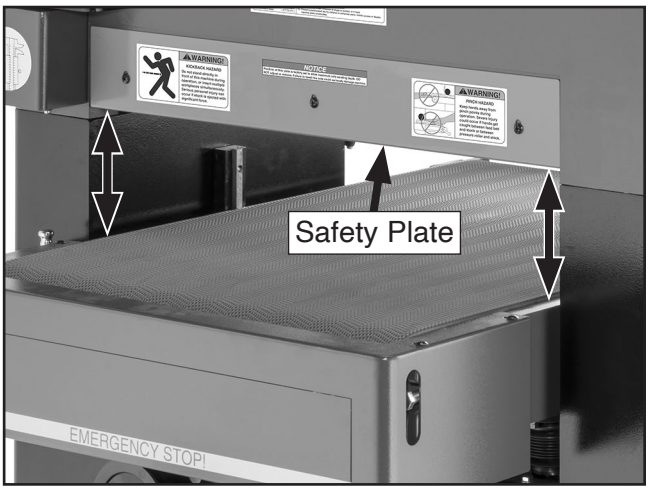



**Figure 129.** Distance to measure at front right and front left corners (G0408 shown).

— 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.*

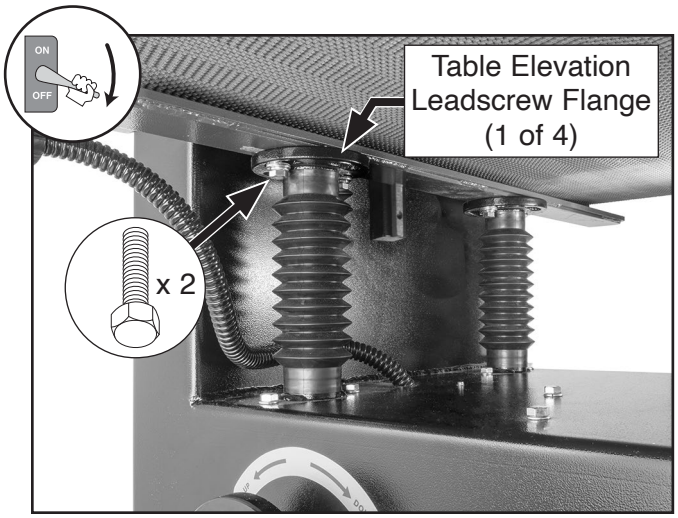



**Figure 130.** Table flange components (G0408 shown).

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.

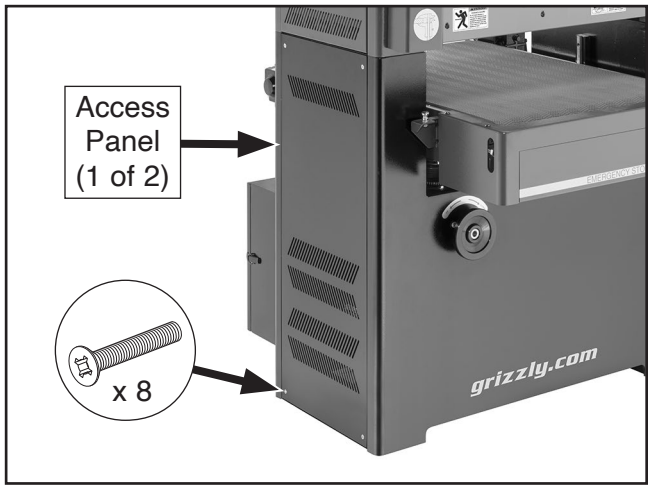



**Figure 131.** Location of access panels and securing screws (G0408 shown).

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

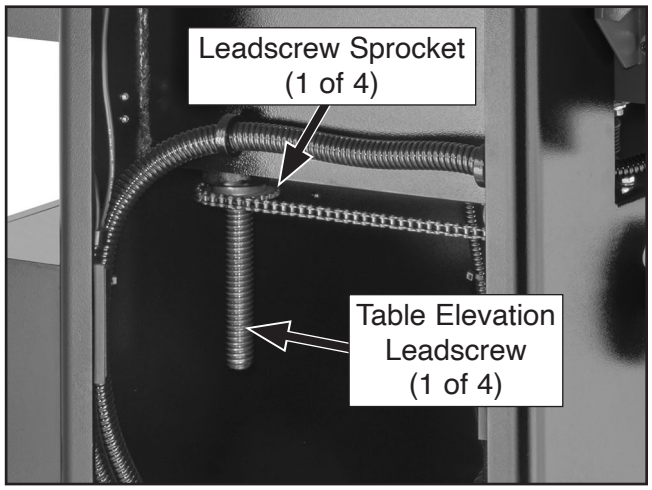



**Figure 132.** Location of table elevation leadscrew sprockets (G0408 shown).

**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.

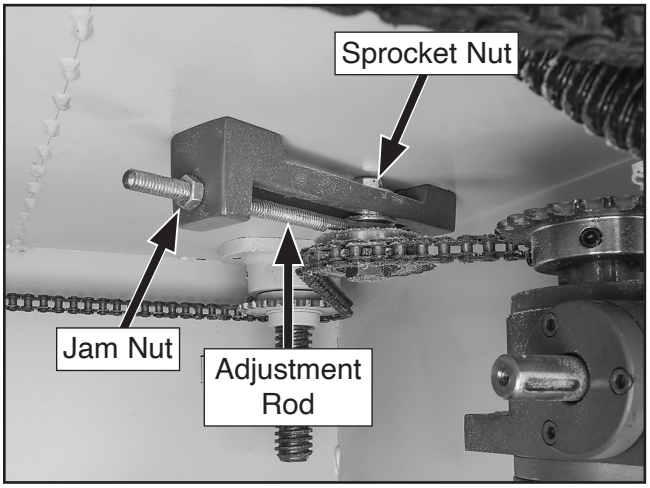



**Figure 133.** Table elevation chain tensioner components (example shown).

**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.

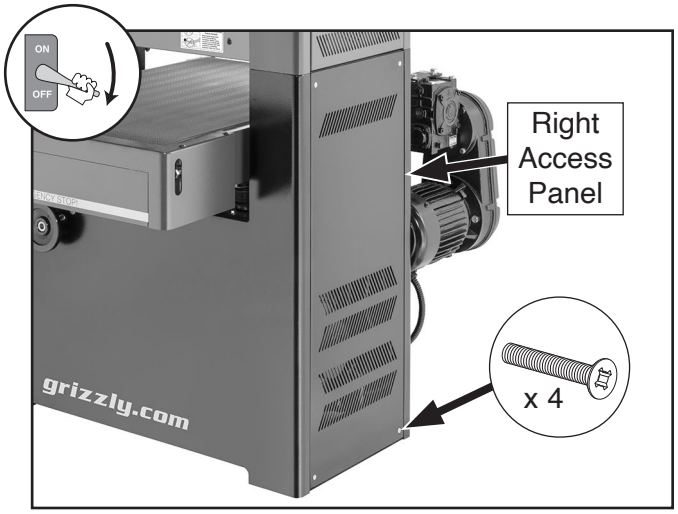



**Figure 134.** Location of right access panel and screws (G0408 shown).

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.*

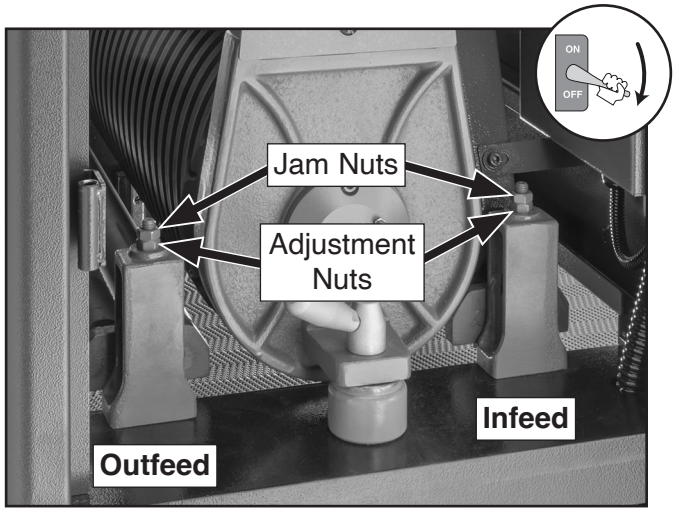



**Figure 136.** Location of Model G0408 pressure roller adjustment components (left side).

**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.*

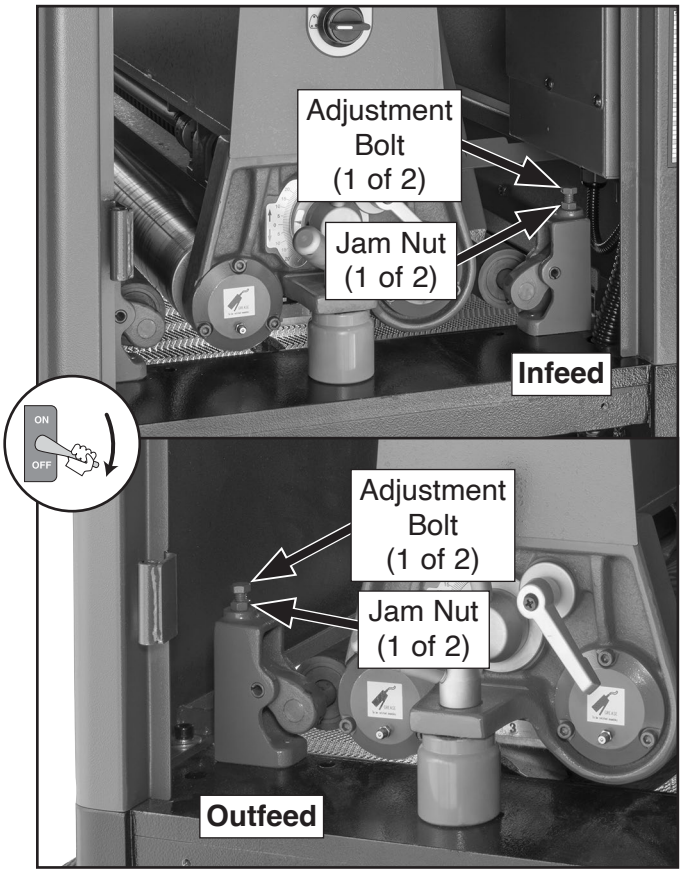



**Figure 137.** Location of Model G0409/G0411 pressure roller adjustment components (left side).

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**).

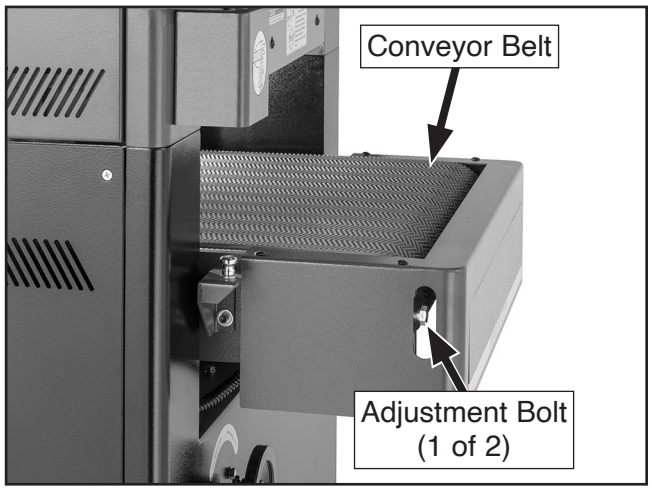



**Figure 138.** Location of conveyor belt adjustment bolts.

| **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.

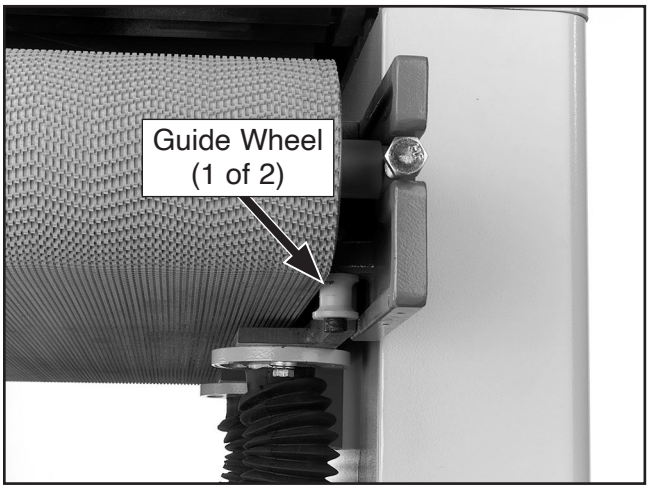



**Figure 139.** Location of conveyor belt guide wheels (safety guard removed for clarity).

***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.

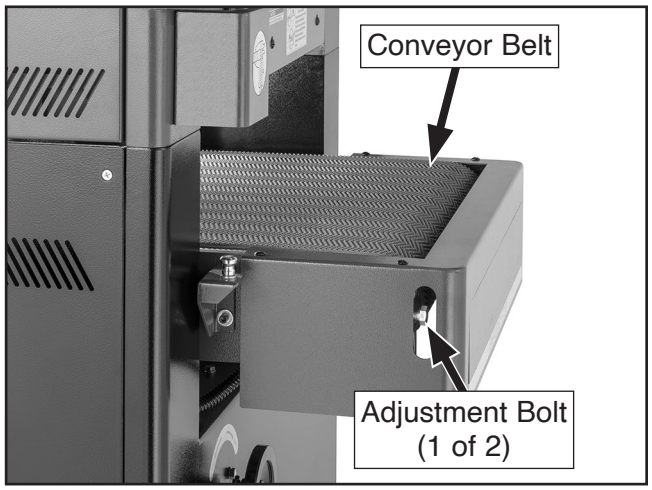



**Figure 140.** Location of conveyor belt adjustment bolts.

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**).

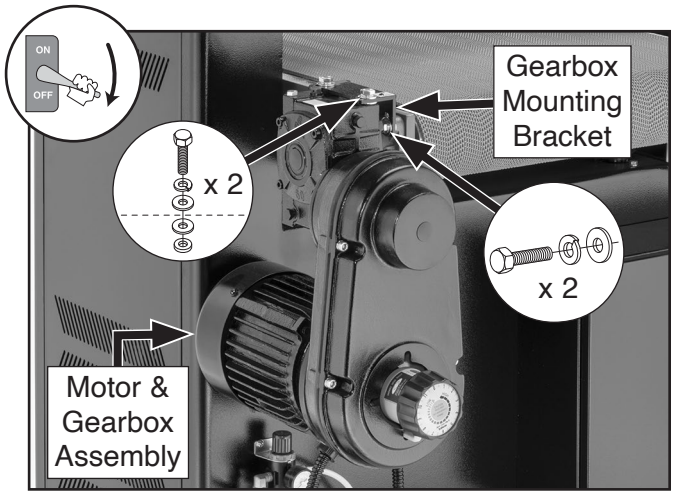



**Figure 141.** Motor and gearbox assembly components to remove (G0408 shown).

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

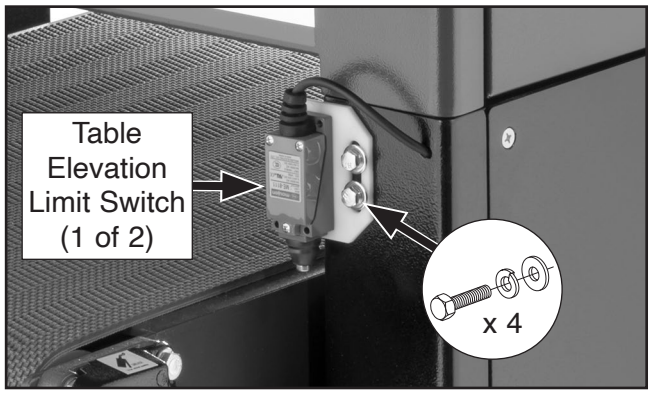



**Figure 142.** Location of table elevation limit switches and securing fasteners.

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

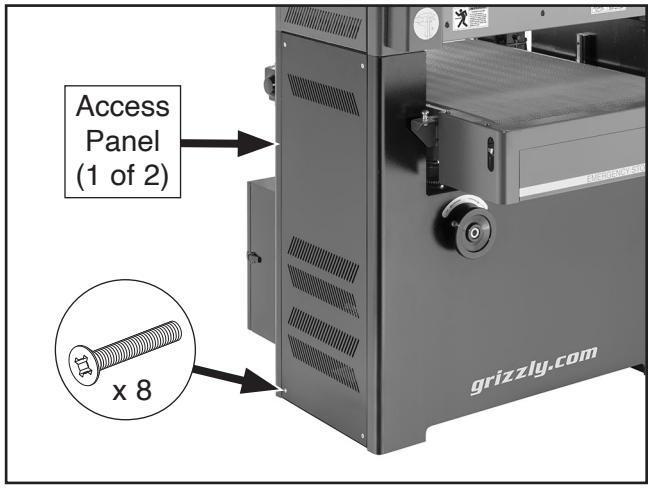



**Figure 143.** Location of access panels and securing screws (G0408 shown).

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

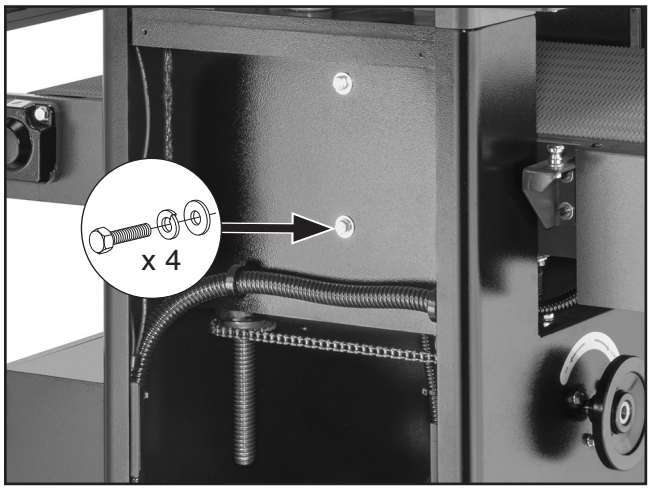



**Figure 144.** Location of table guide fasteners.

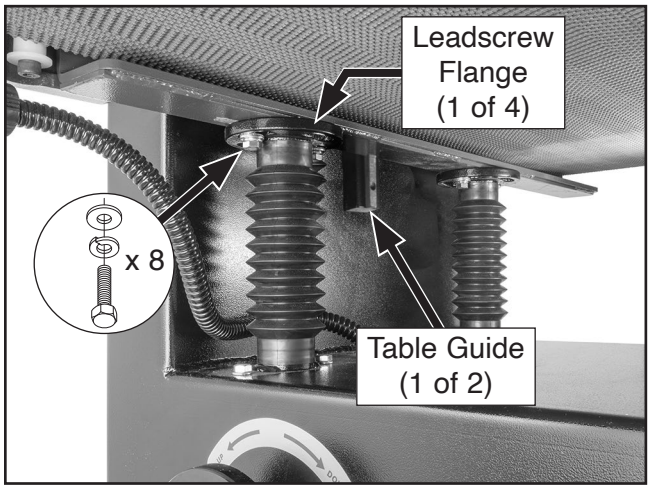



**Figure 145.** Location of table guides and leadscrew flanges (G0408 shown).

**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.

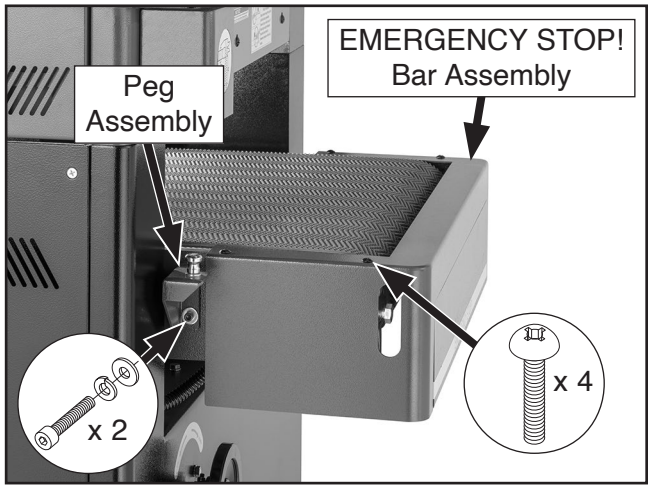



**Figure 146.** Peg and EMERGENCY STOP! bar assembly components.

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

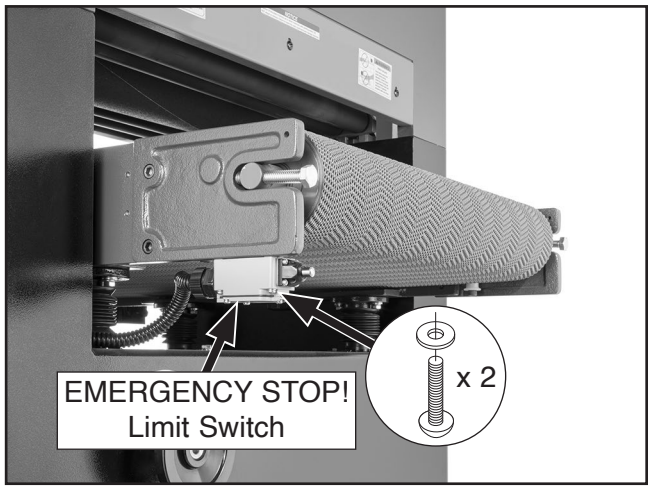



**Figure 147.** Location of EMERGENCY STOP! limit switch (G0408 shown).

**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.

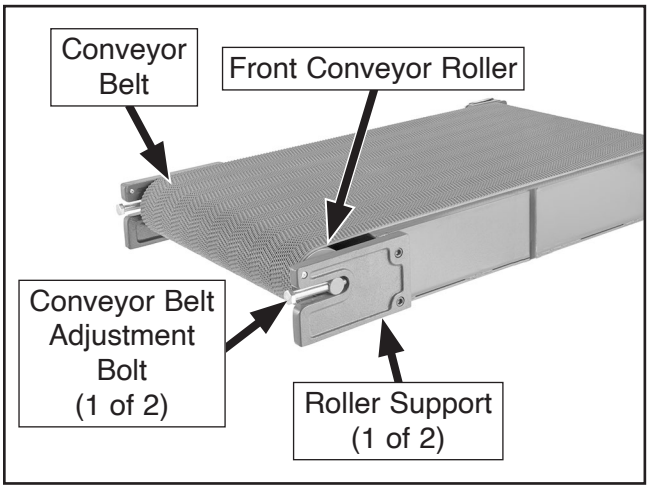



**Figure 148.** Location of conveyor belt components (G0408 shown).

**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.

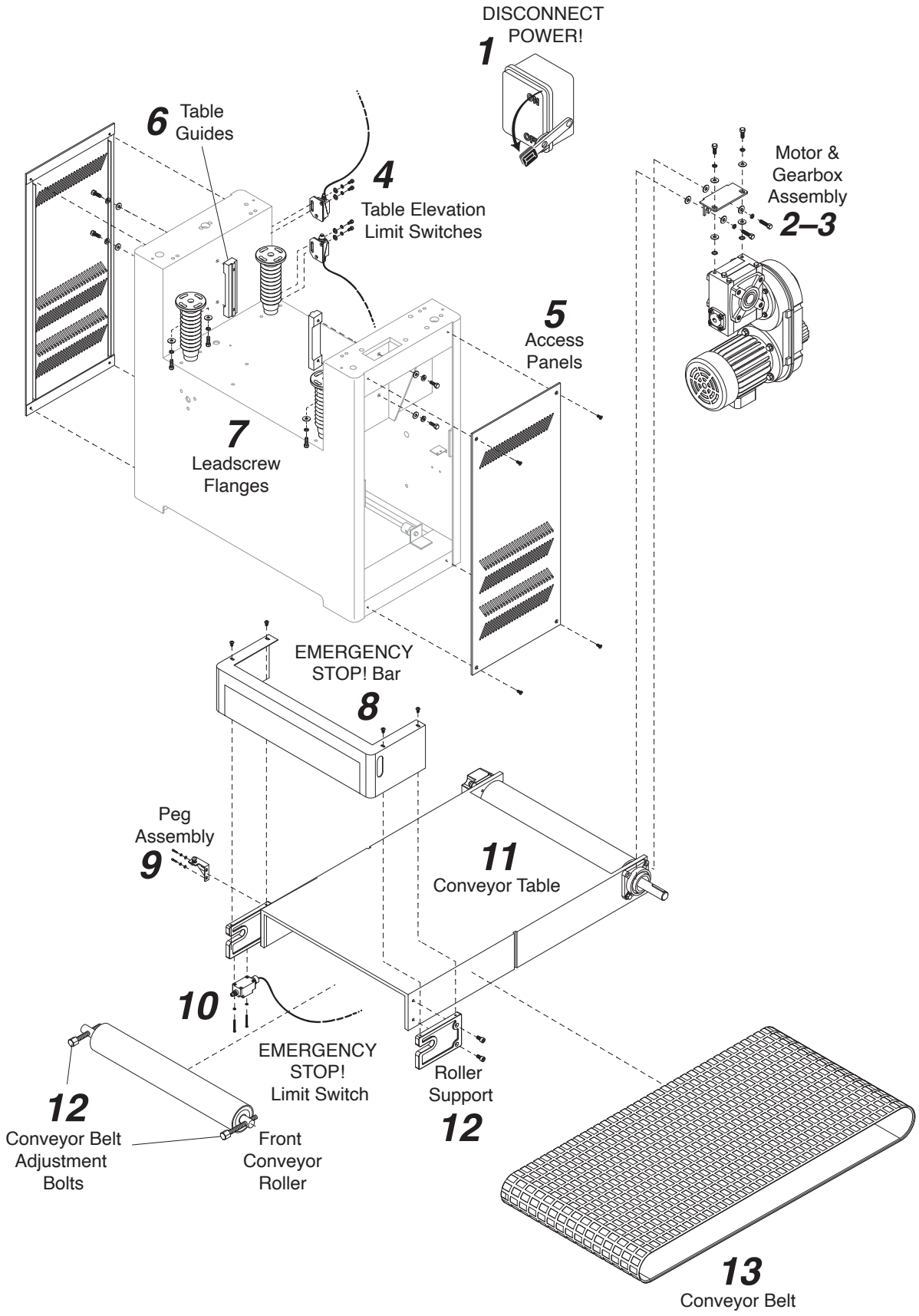
**19.** Install table elevation limit switches so upper switch clicks when conveyor surface is ⅛" away from sandpaper, and lower switch clicks when conveyor table is ⅛" higher than its lowest position. Make sure to test settings with handwheel manually so table does not crash if incorrectly set at first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

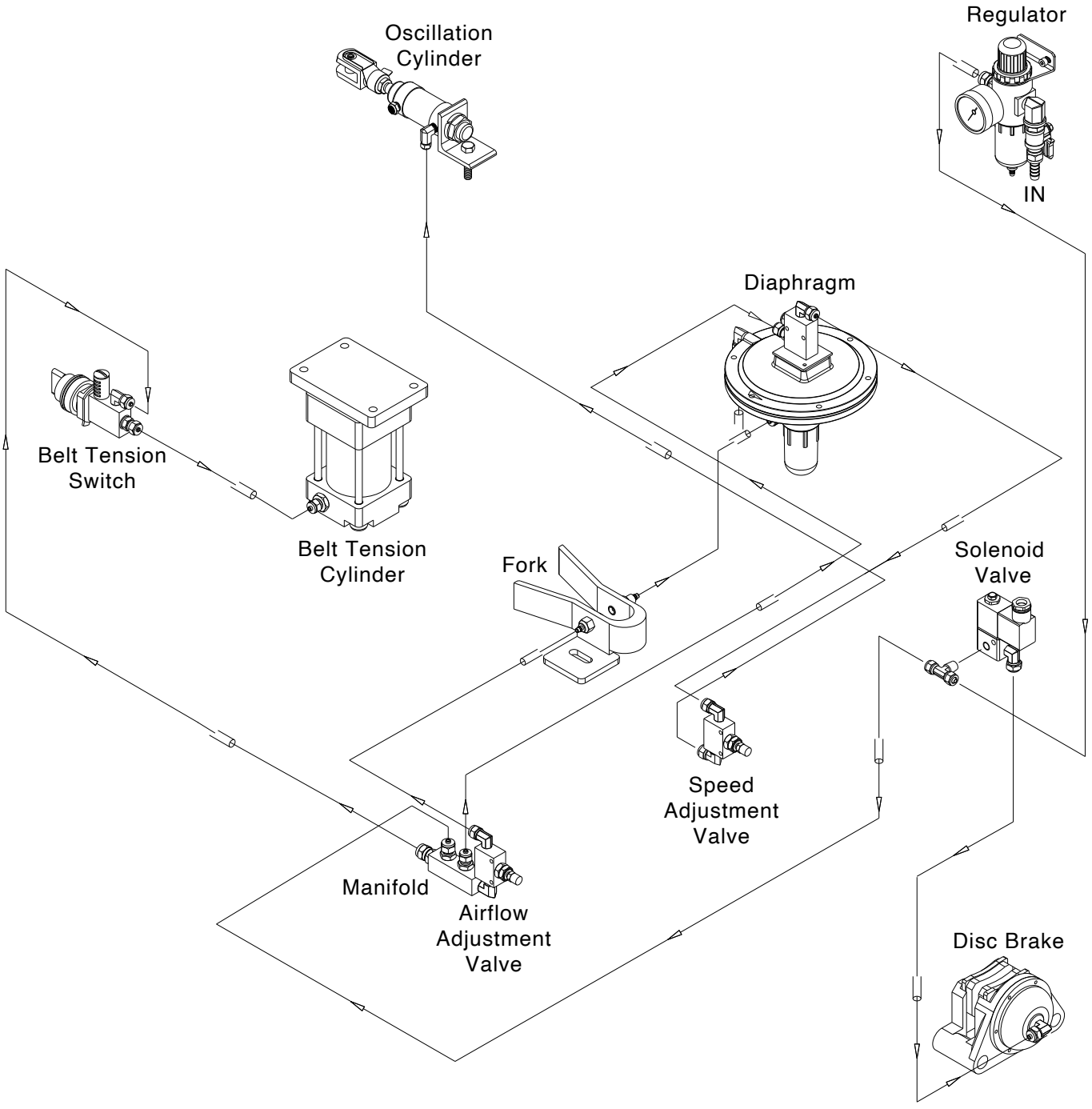
# Conveyor Belt Removal Sequence



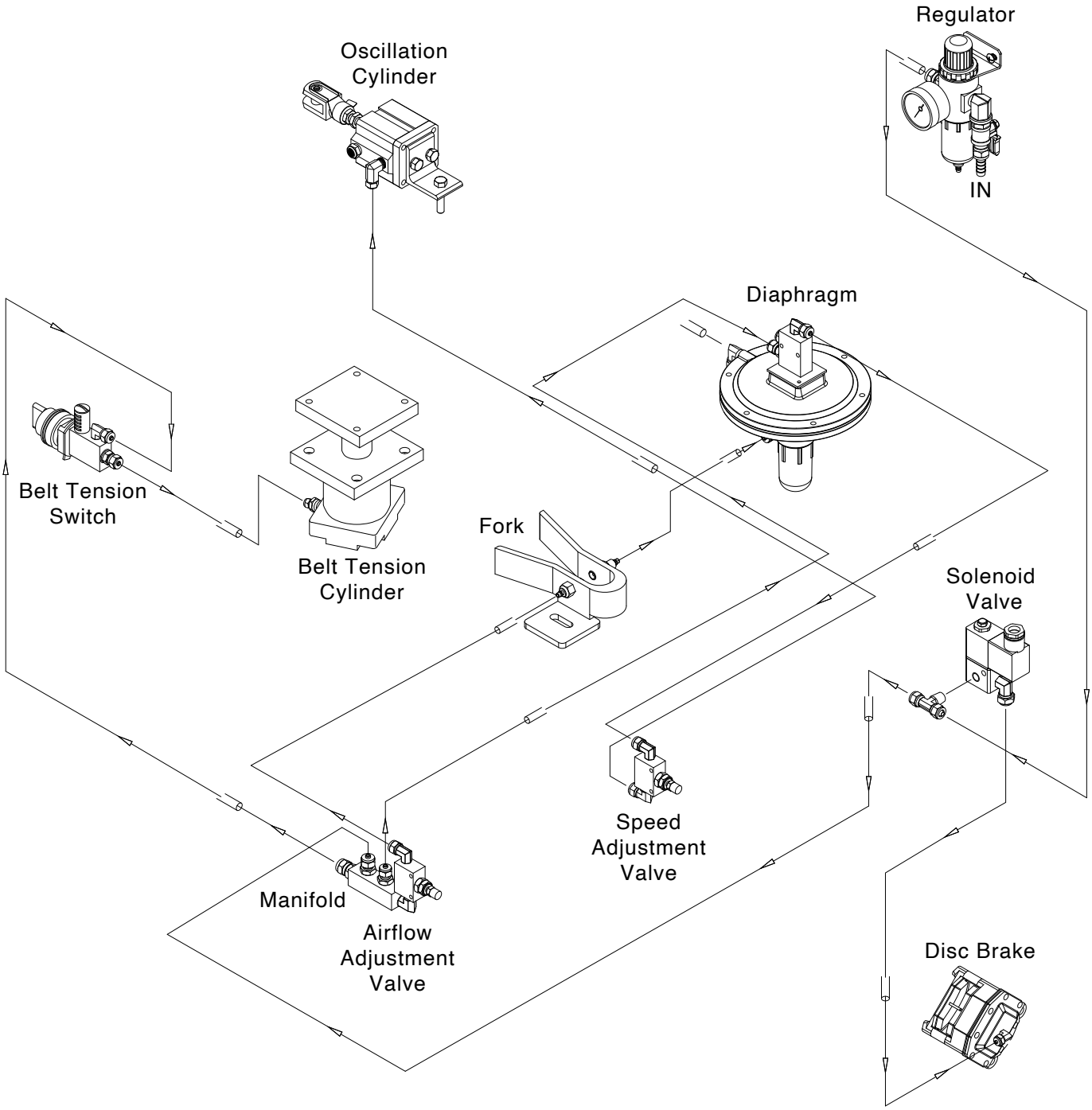
# SECTION 7: PNEUMATIC SYSTEM

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

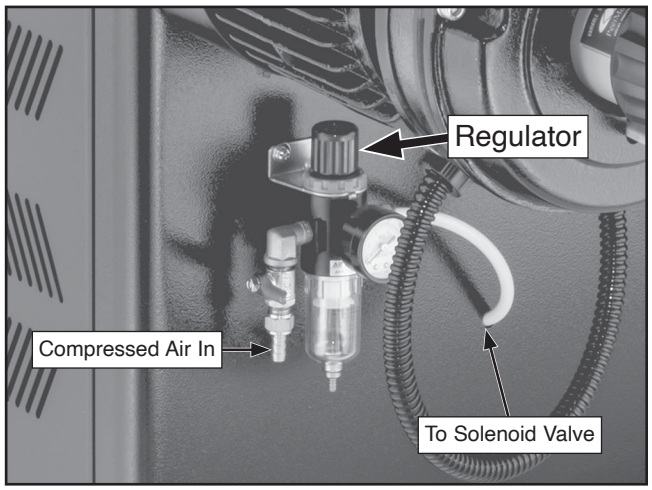



**Figure 149.** Regulator.

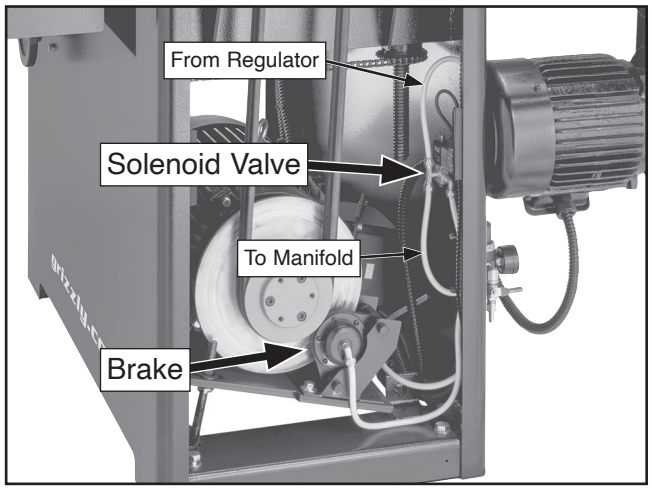



**Figure 150.** Model G0408/G0409 brake and solenoid valve.

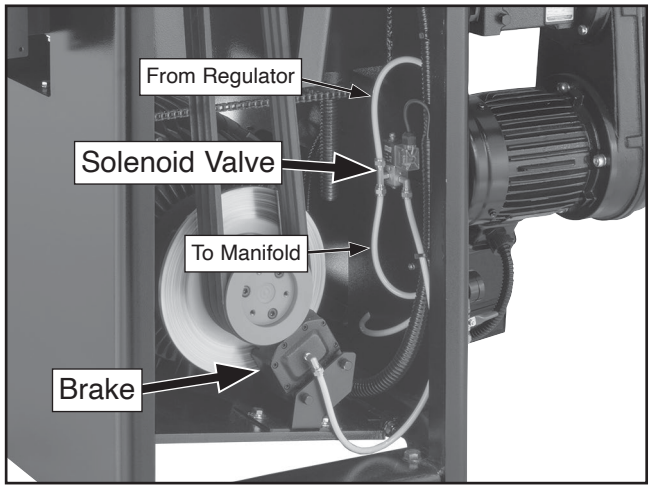



**Figure 151.** Model G0411 brake and solenoid valve.

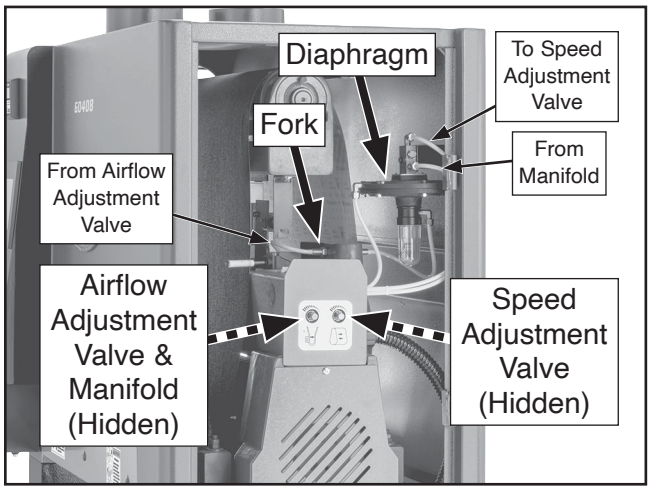



**Figure 152.** Manifold, diaphragm, and fork (G0408 shown).

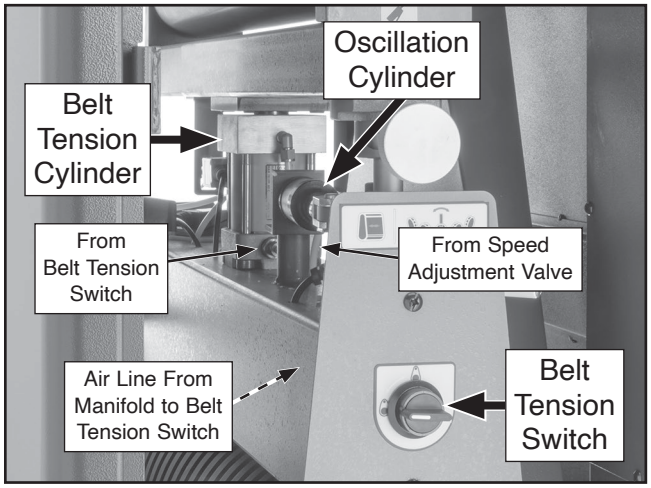



**Figure 153.** Model G0408/G0409 belt tension switch and cylinders.

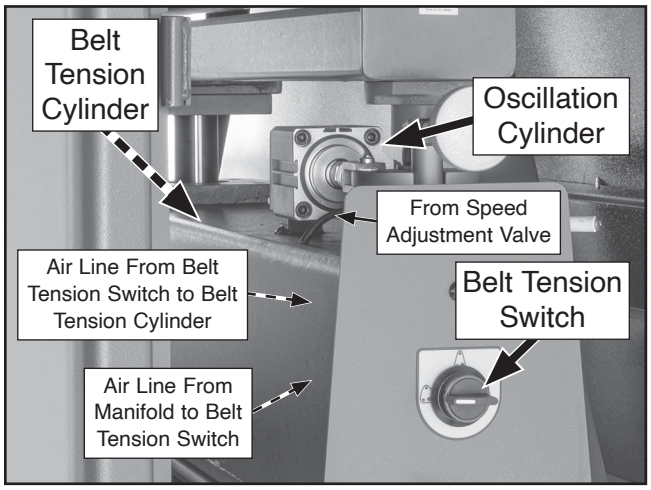



**Figure 154.** Model G0411 belt tension switch and cylinders.

# 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.**

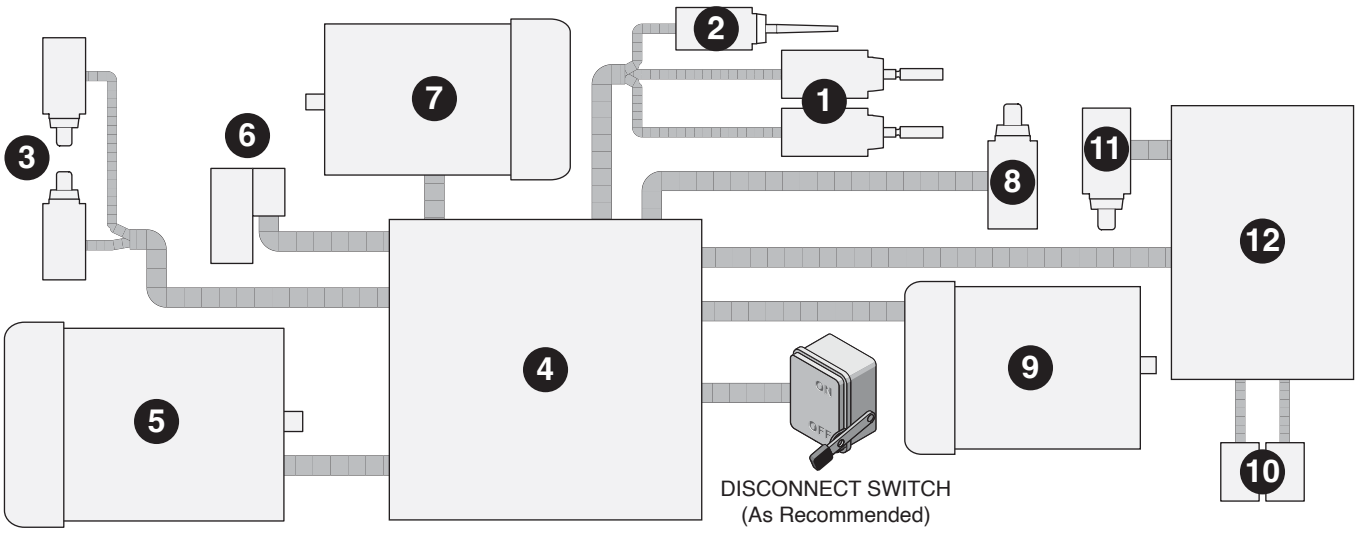
**COLOR KEY**

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| 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**) |

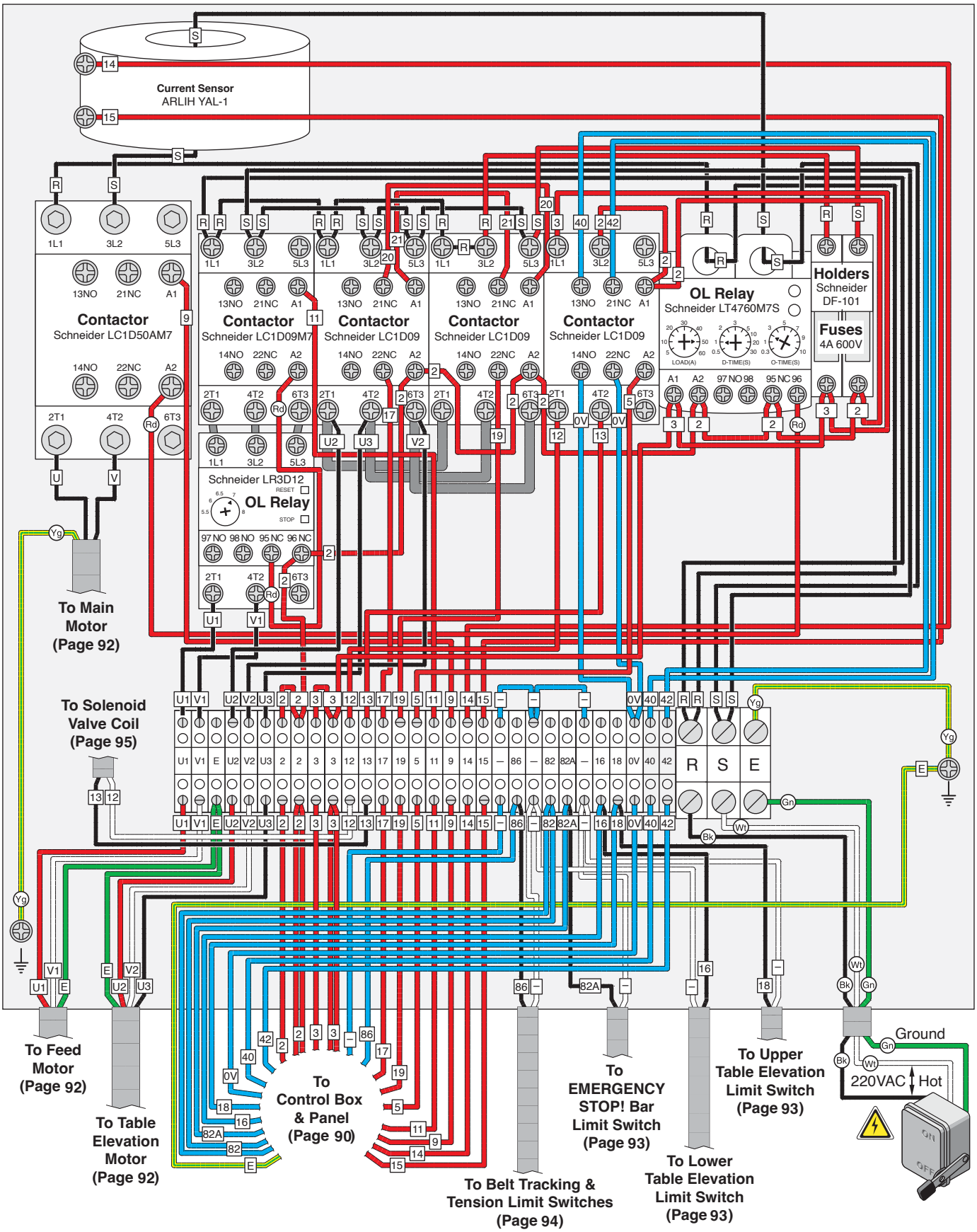





***READ WIRING SAFETY ON PAGE 87!***

# G0408/G0409 Electrical Cabinet Wiring

## ELECTRICAL CABINET

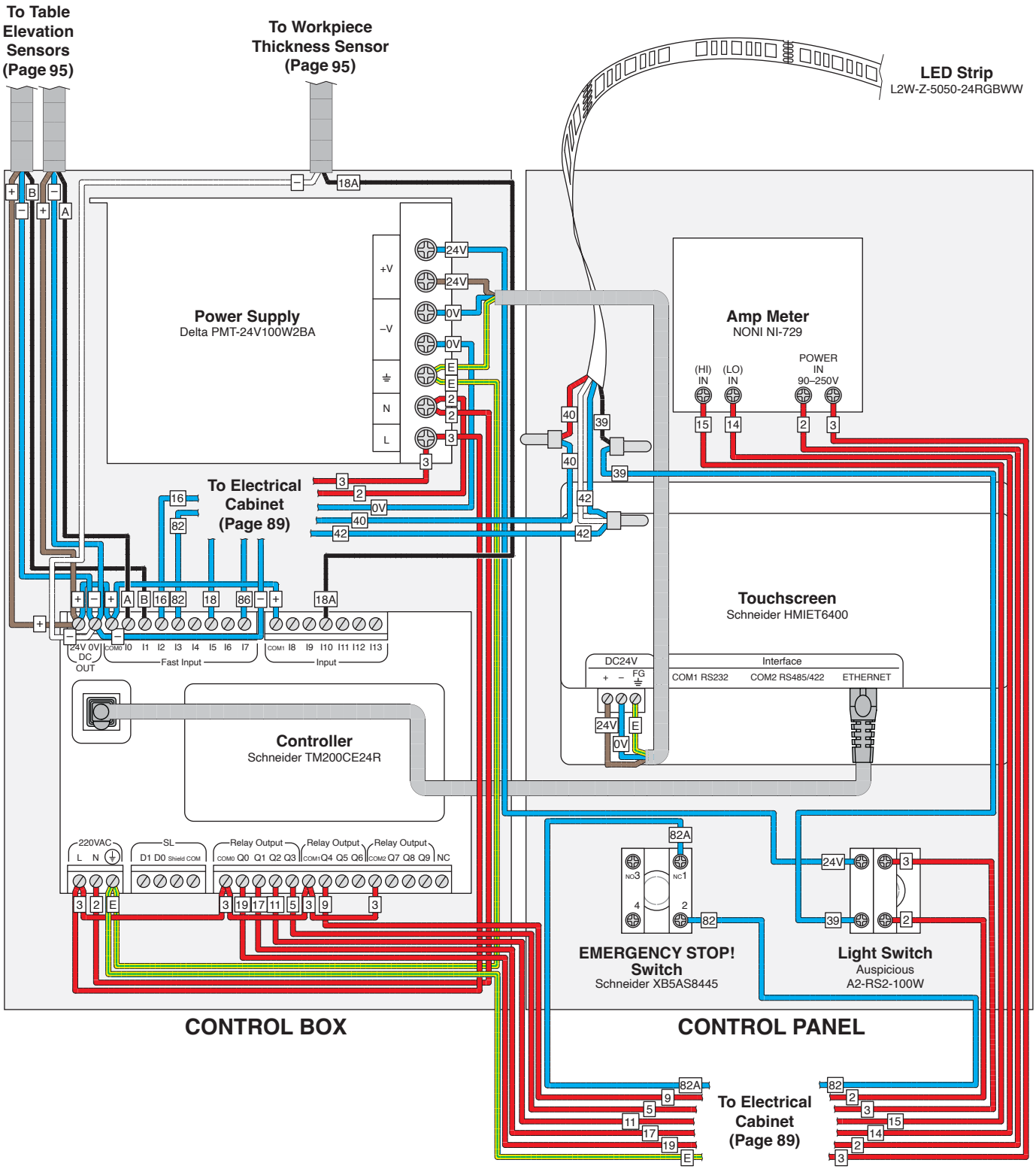





STOP

***READ WIRING SAFETY ON PAGE 87!***

# G0408/G0409 Control Box & Panel Wiring






***READ WIRING SAFETY ON PAGE 87!***

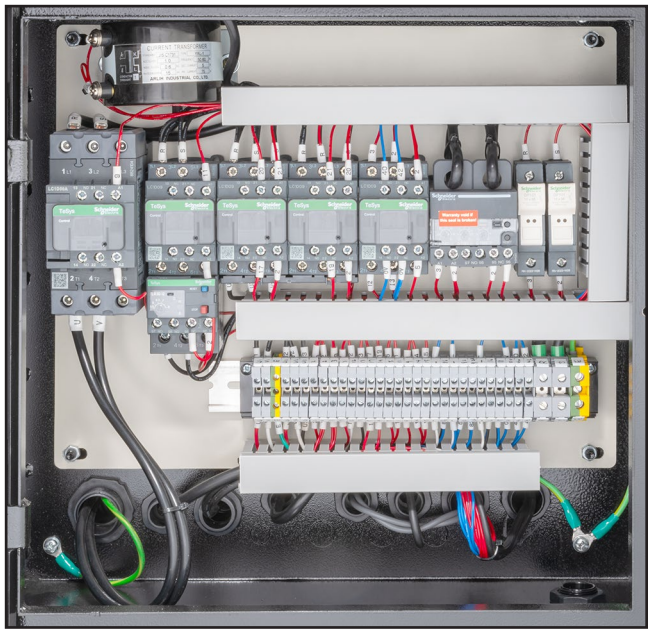


**Figure 155.** Model G0408/G0409 electrical cabinet wiring.

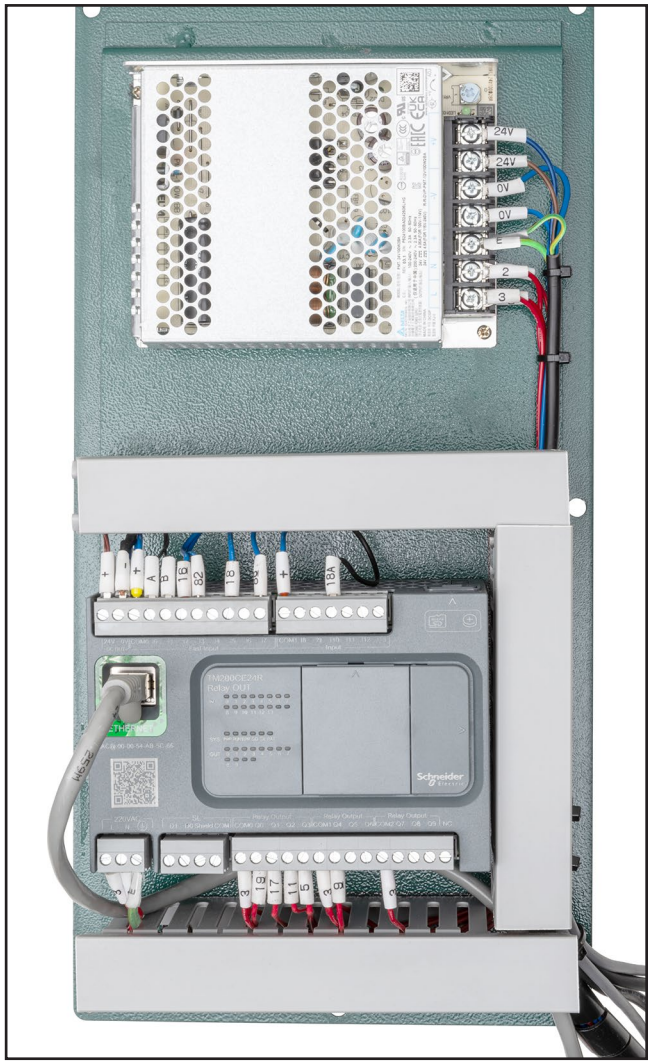


**Figure 156.** Model G0408/G0409 control box wiring.

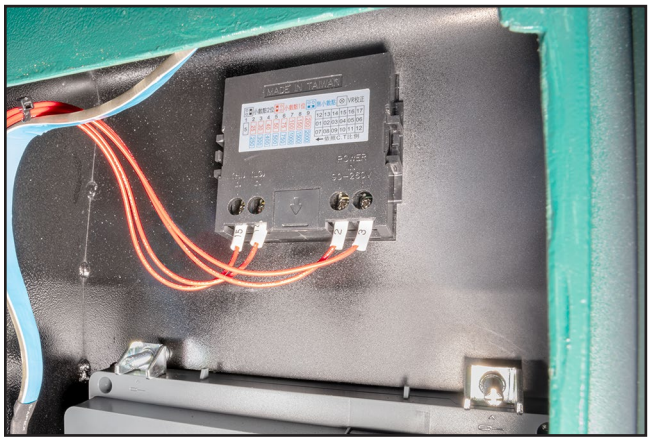


**Figure 157.** G0408/G0409 control panel upper wiring.

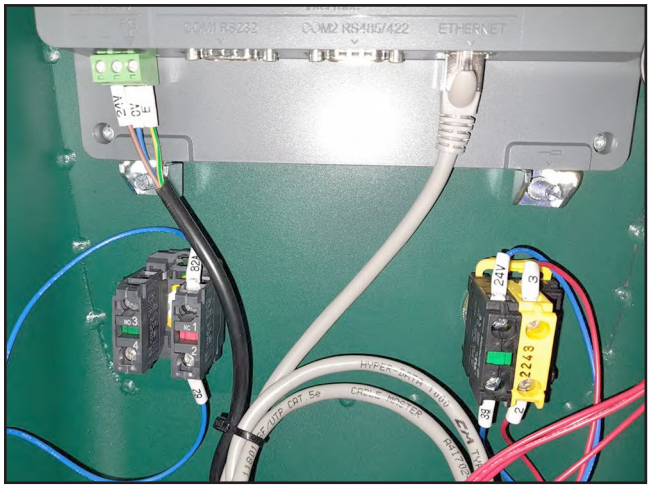
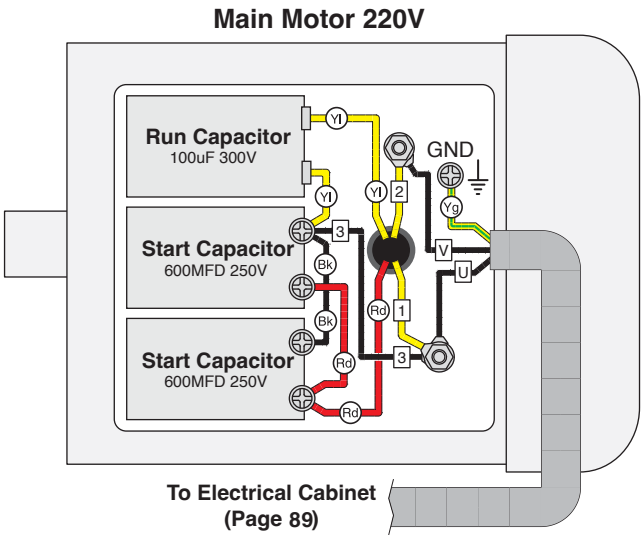


**Figure 158.** G0411 control panel touchscreen and switch wiring.

# G0408/G0409 Motor Wiring



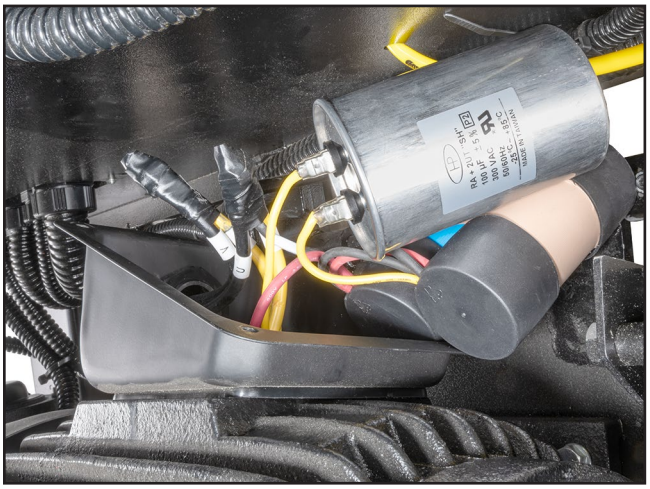
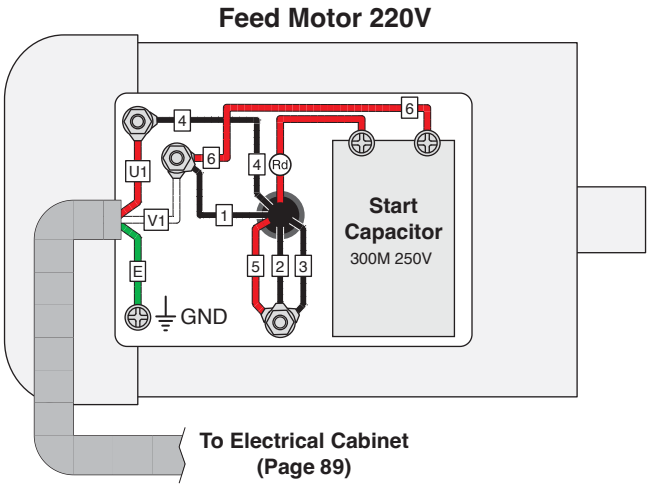



**Figure 159.** G0408/G0409 main motor junction box wiring.



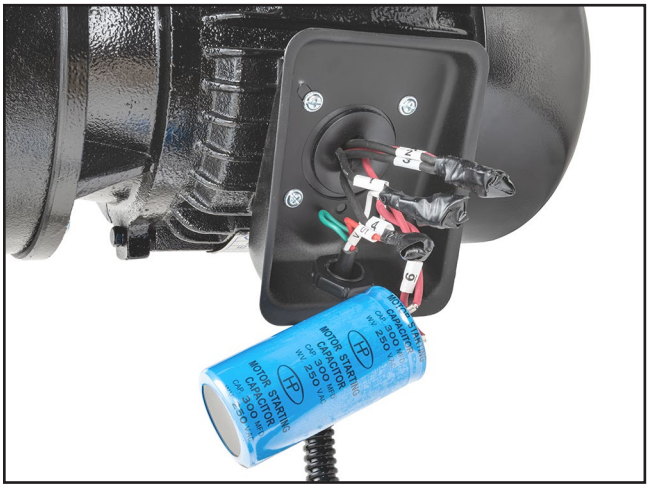



**Figure 160.** G0408/G0409 feed motor junction box wiring.

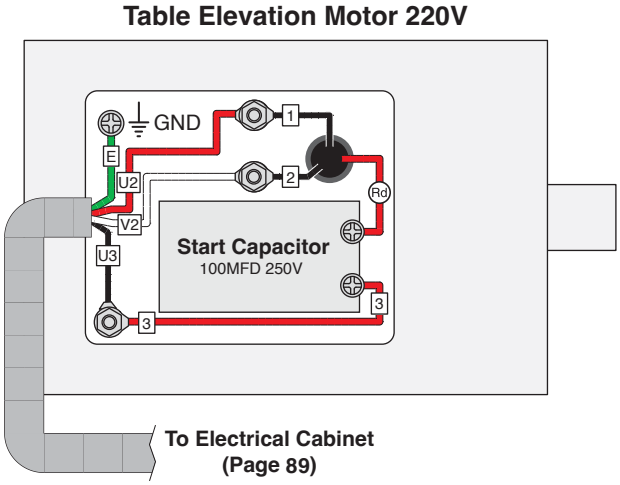
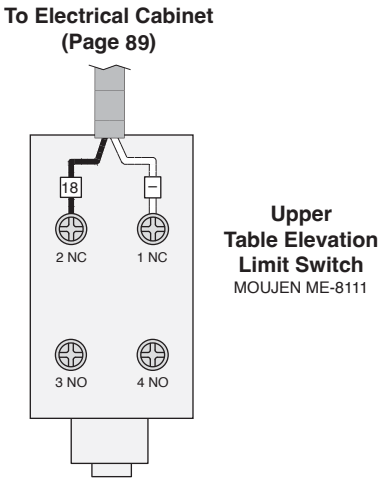





**Figure 161.** G0408/G0409 table elevation motor junction box wiring.

# G0408/G0409 Limit Switch Wiring



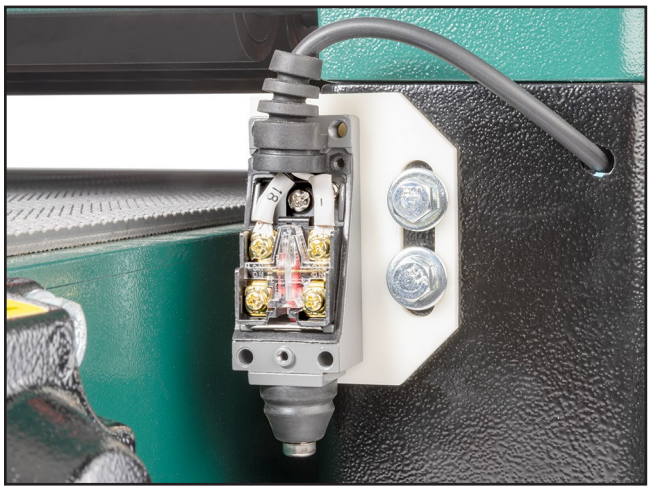
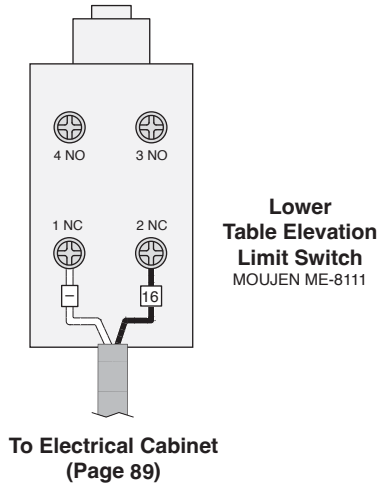



**Figure 162.** Upper table elevation limit switch wiring.



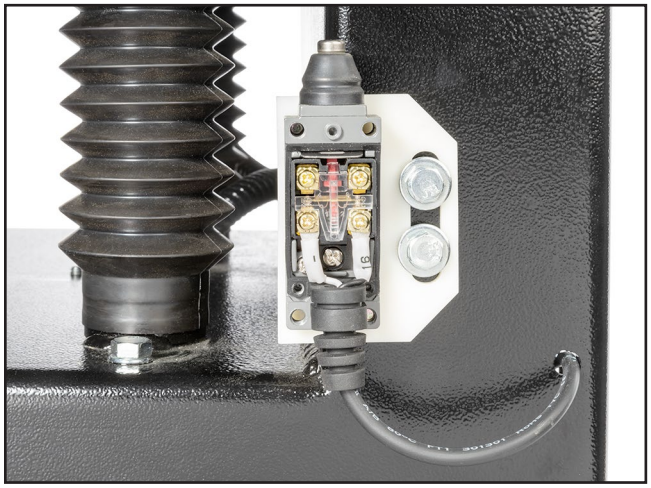
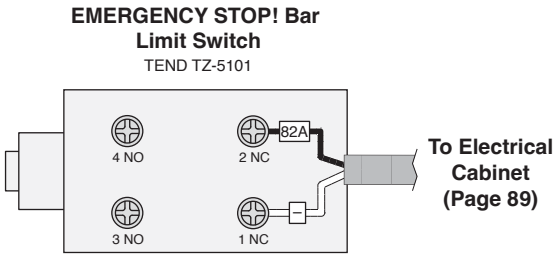



**Figure 163.** Lower table elevation limit switch wiring.



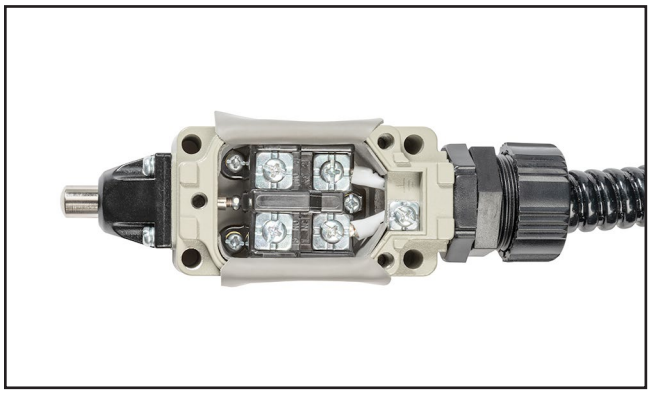
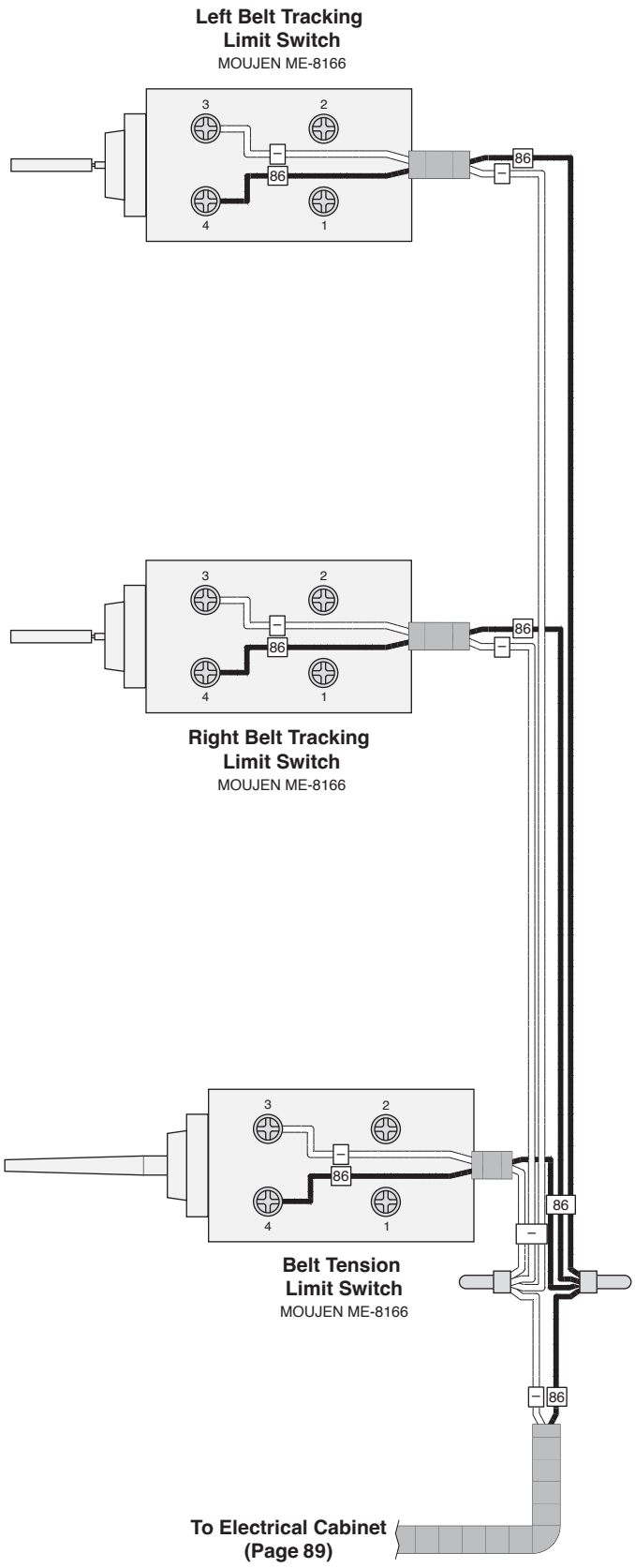



**Figure 164.** EMERGENCY STOP! bar limit switch wiring.



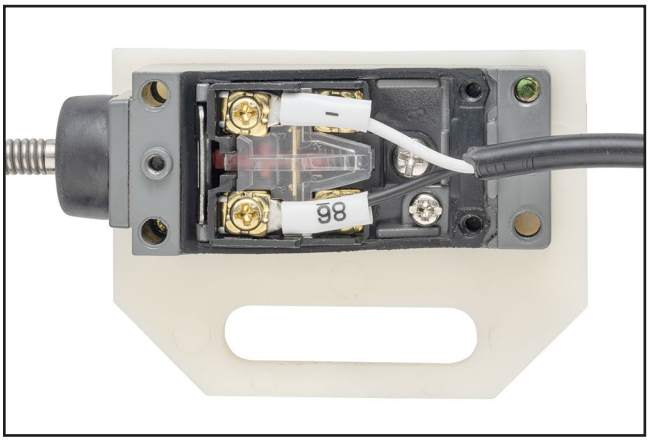




**Figure 165.** Left belt tracking limit switch wiring.

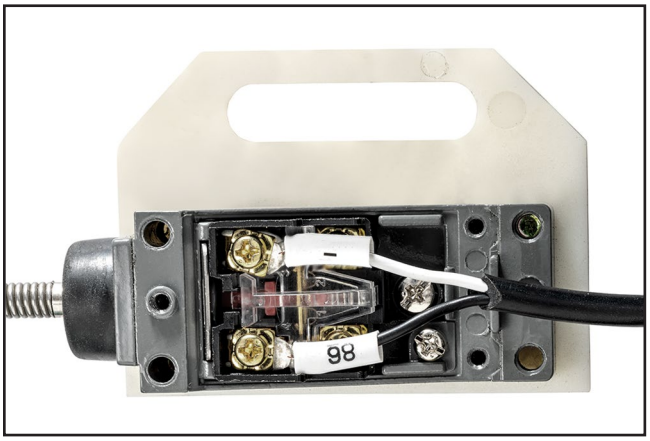



**Figure 166.** Right belt tracking limit switch wiring.

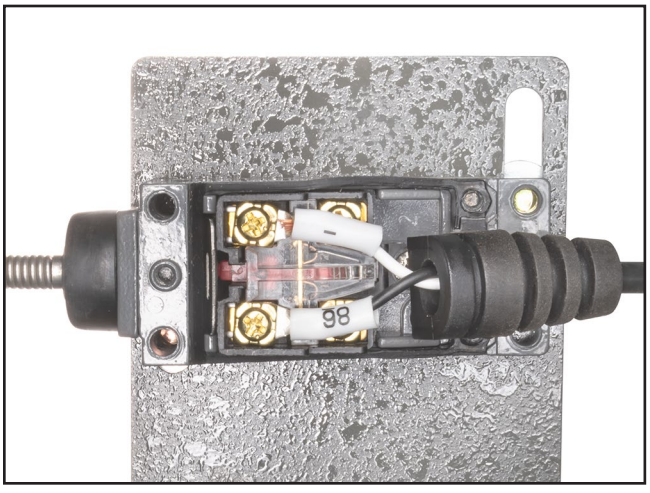
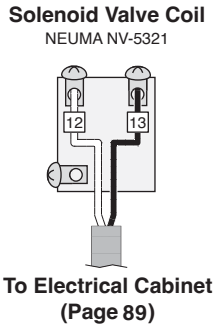



**Figure 167.** Belt tension limit switch wiring.

# G0408/G0409 Solenoid Valve Coil Wiring



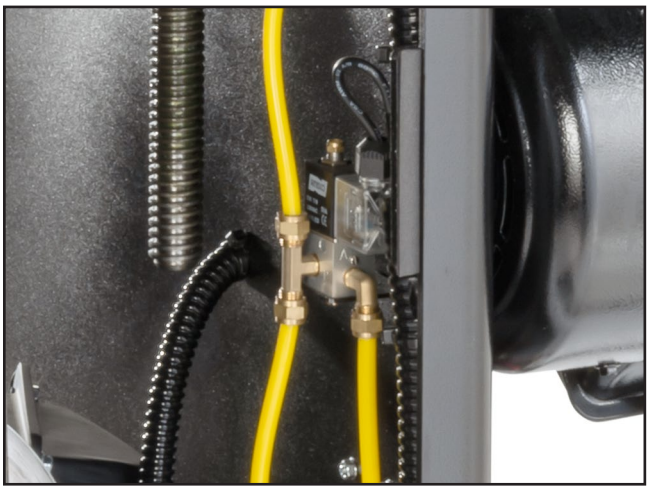
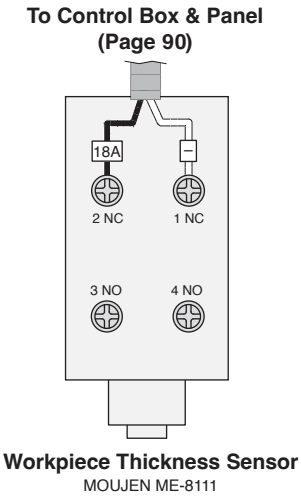



**Figure 168.** Solenoid valve coil.

# G0408/G0409 Sensor Wiring



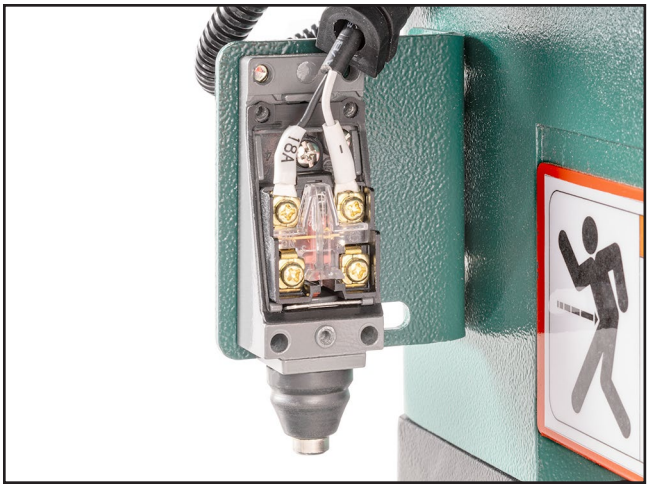
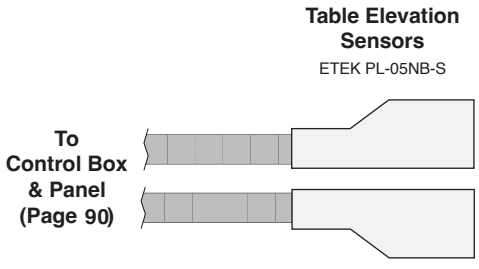



**Figure 169.** Workpiece thickness sensor wiring.



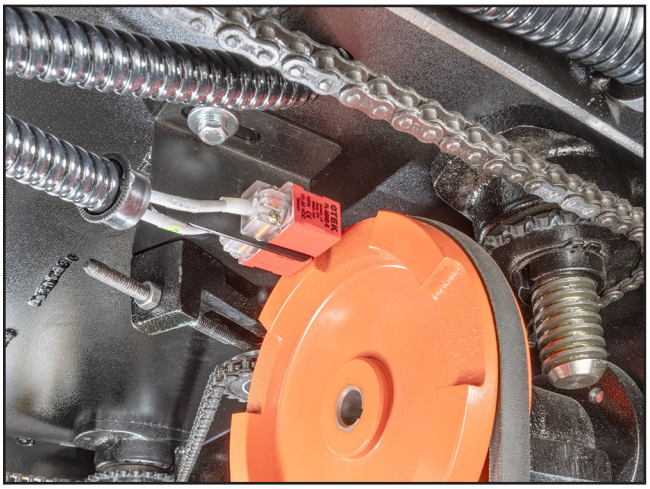
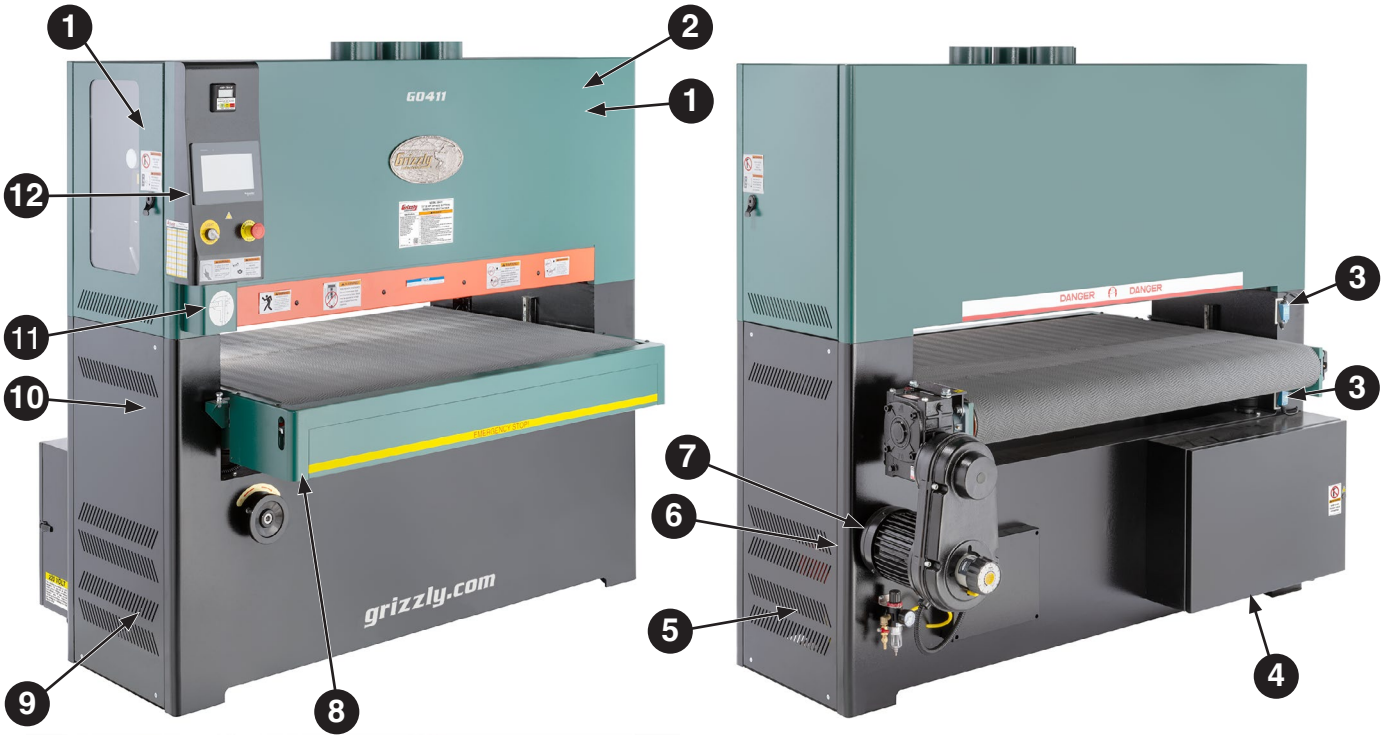
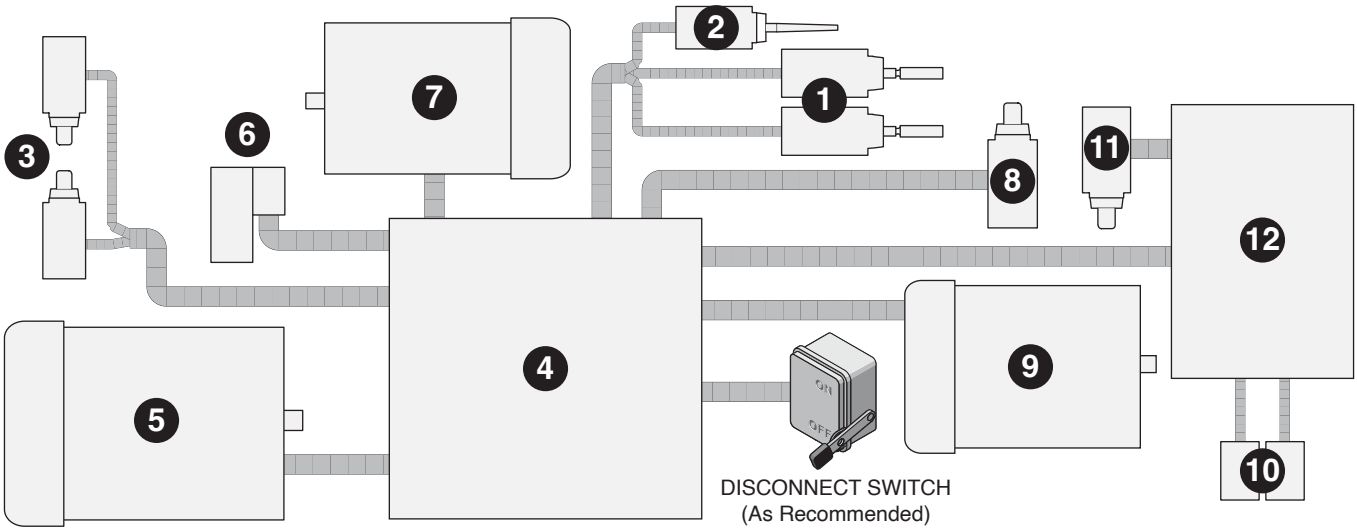



**Figure 170.** Table elevation sensors.

# 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**) |

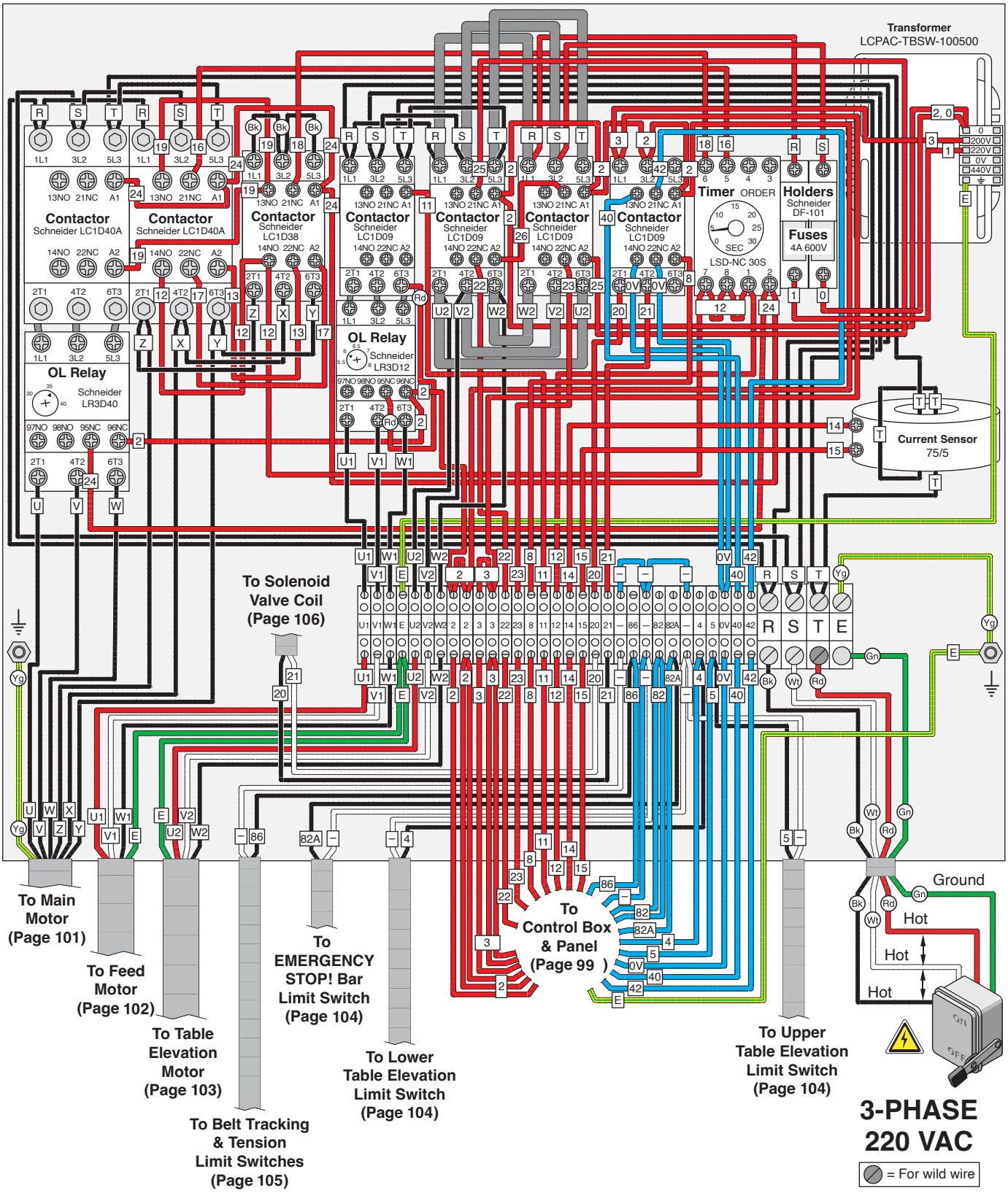





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# G0411 Electrical Cabinet Wiring (220V)

## ELECTRICAL CABINET



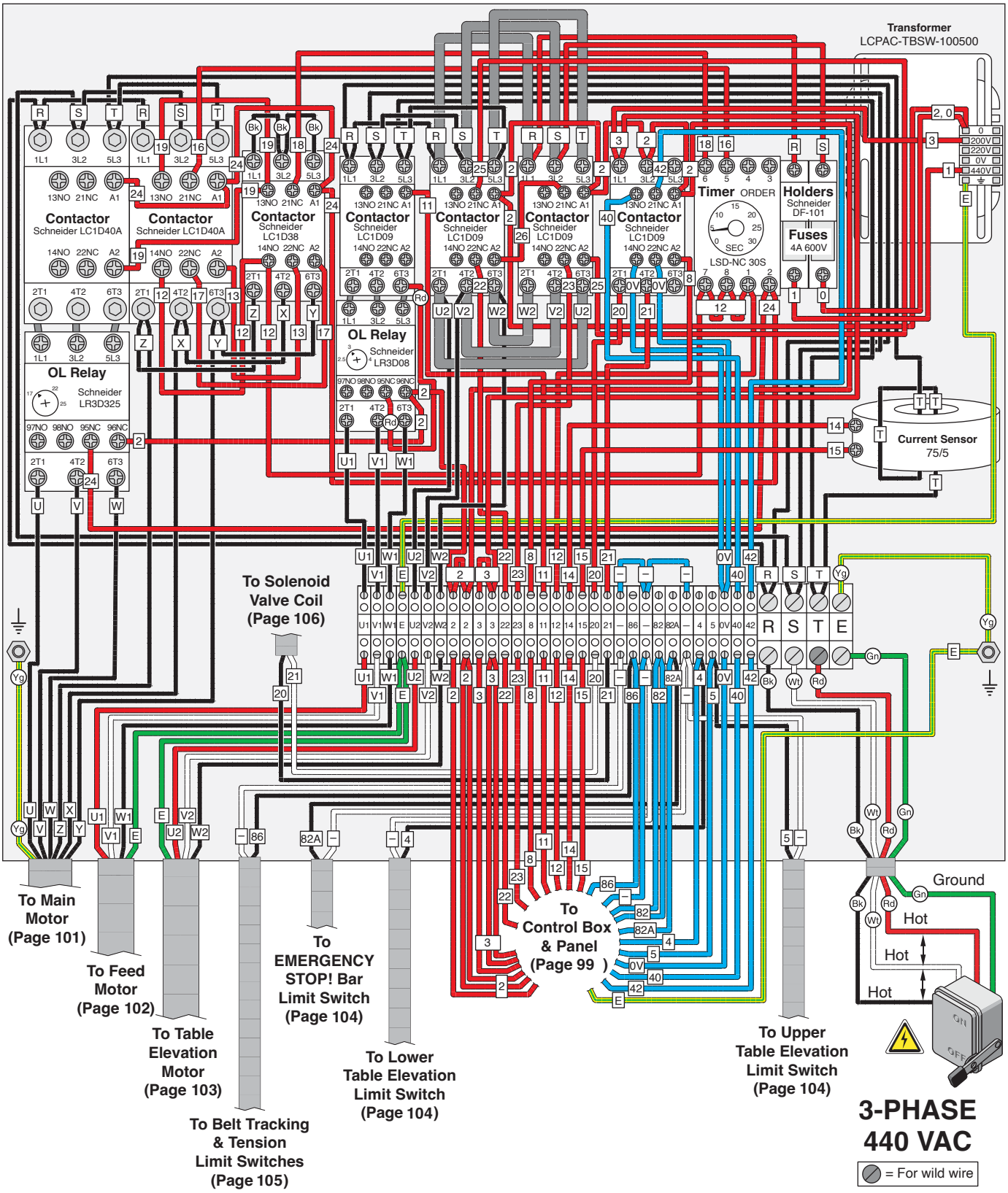



STOP

***READ WIRING SAFETY ON PAGE 87!***

# G0411 Electrical Cabinet Wiring (440V)

## ELECTRICAL CABINET

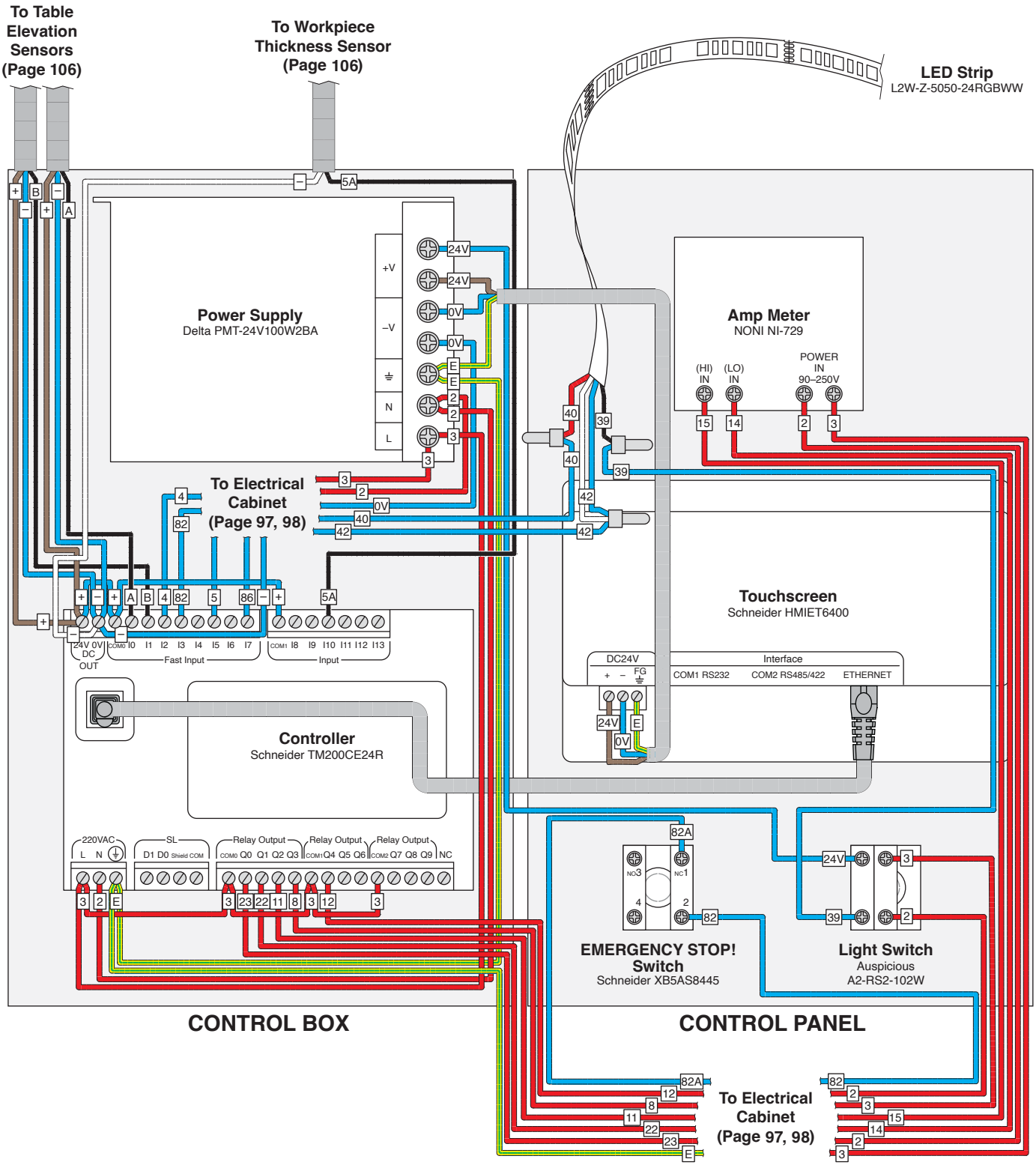





STOP

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# G0411 Control Box & Panel Wiring






*READ WIRING SAFETY ON PAGE 87!*

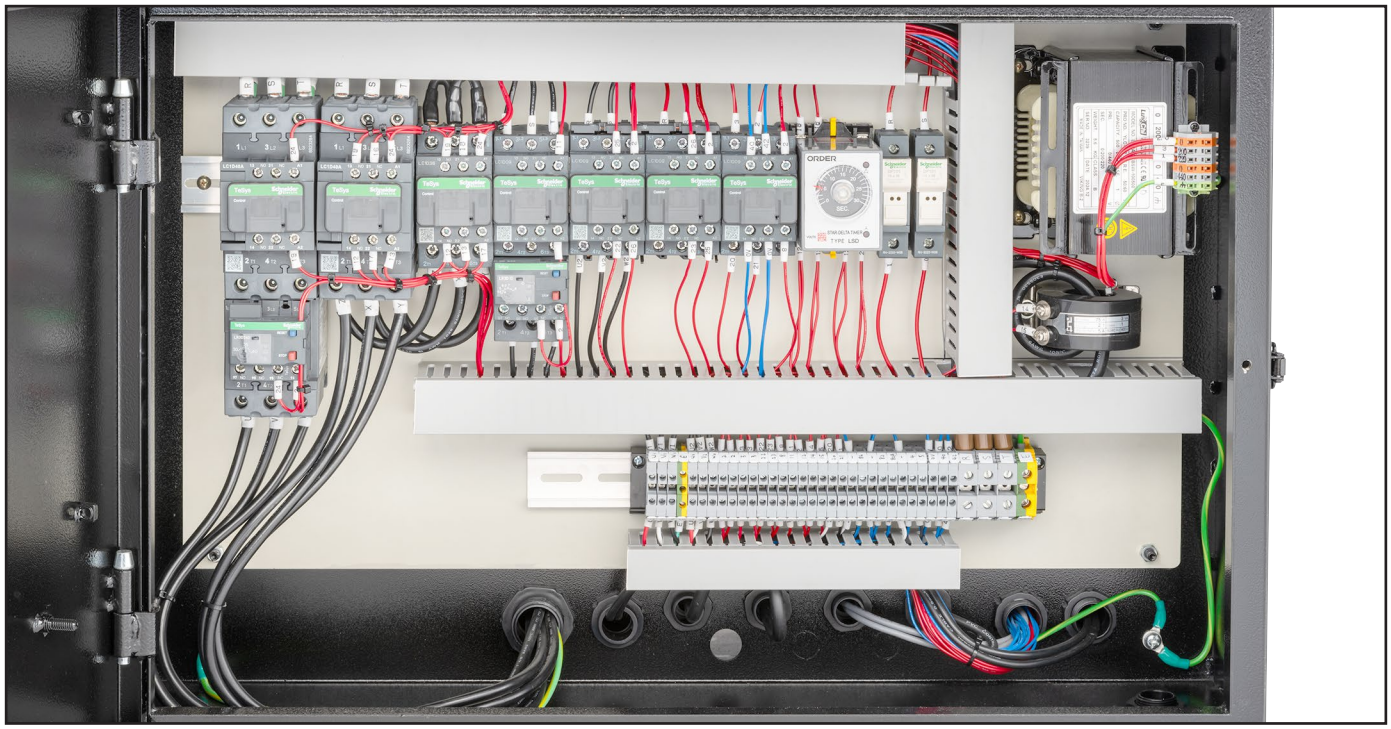


**Figure 171.** Model G0411 electrical cabinet wiring.

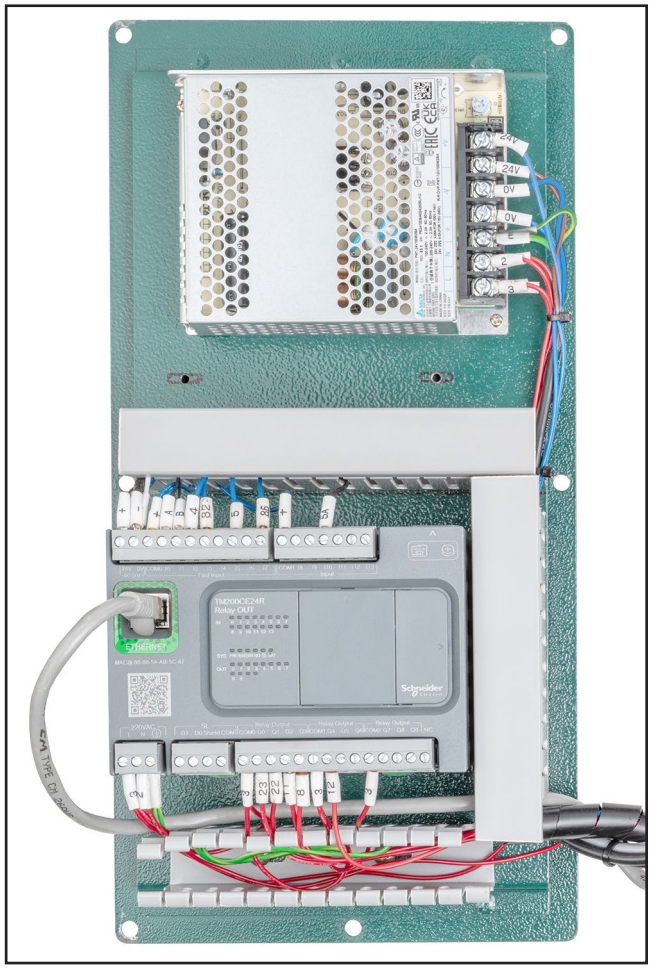


**Figure 172.** Model G0411 control box wiring.

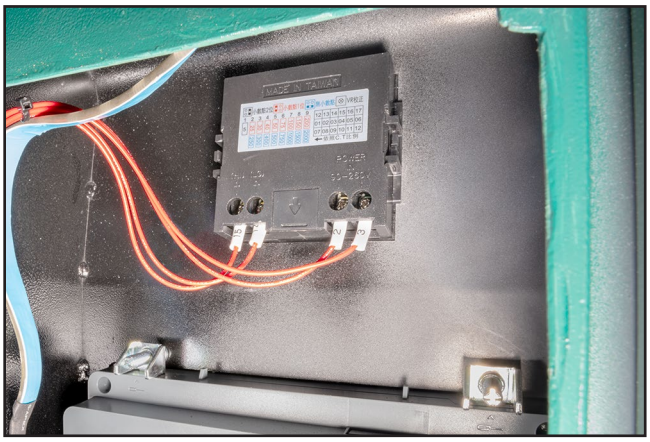


**Figure 173.** G0411 control panel upper wiring.

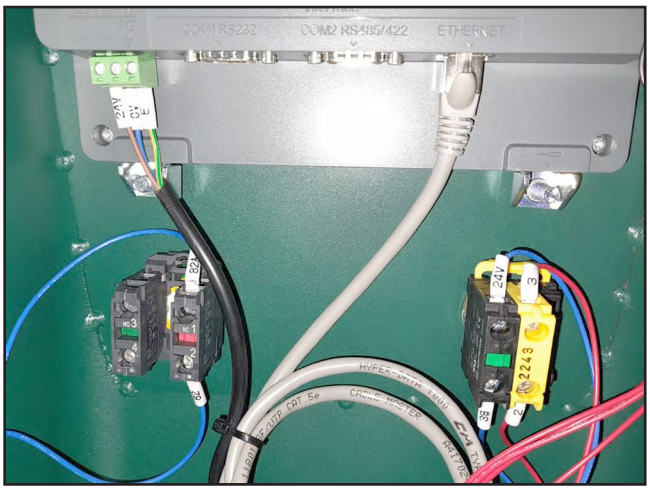


**Figure 174.** G0411 control panel touchscreen and switch wiring.






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# G0411 Main Motor Wiring

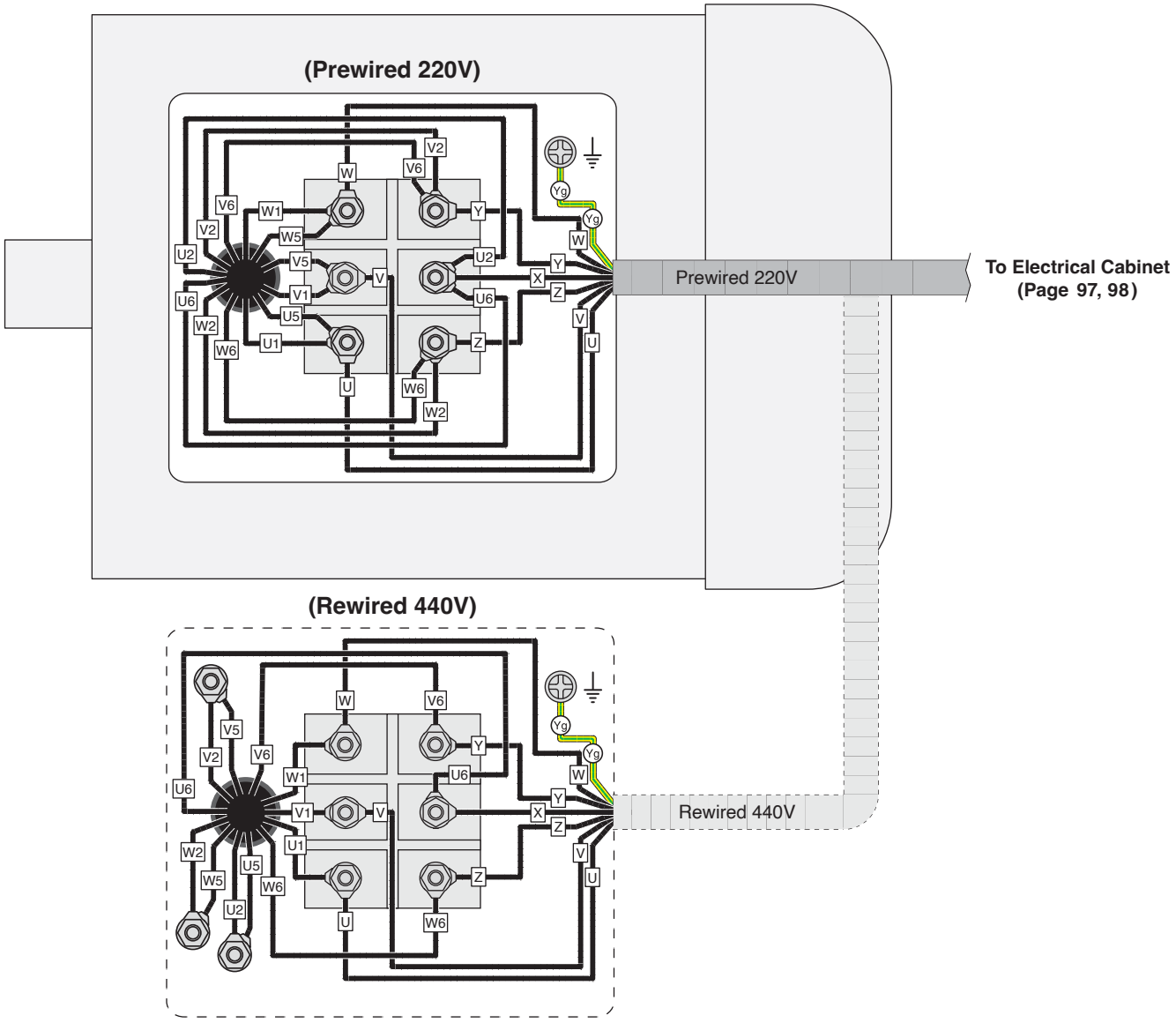





**Figure 175.** G0411 main motor junction box wiring (220V shown).

# G0411 Feed Motor Wiring

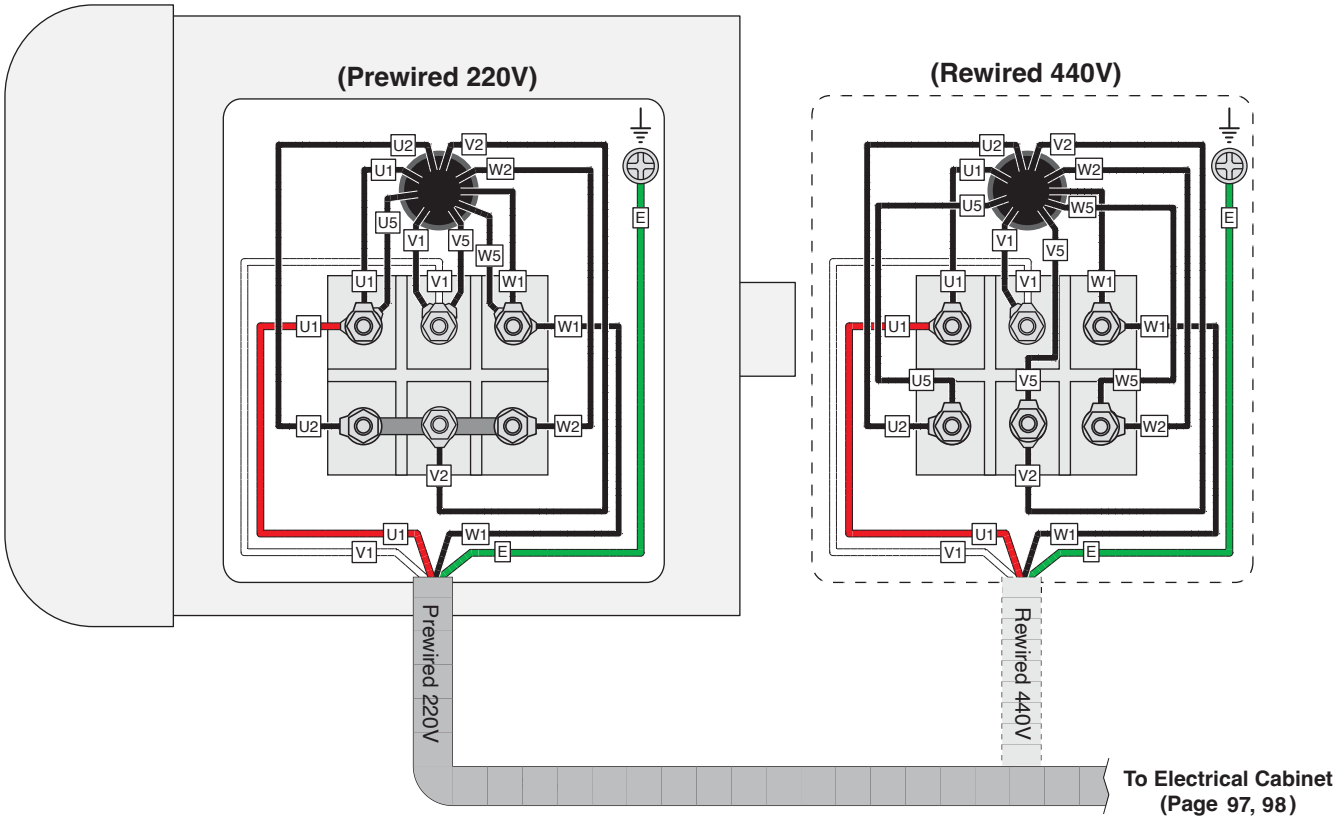





**Figure 176.** G0411 feed motor junction box wiring (220V shown).

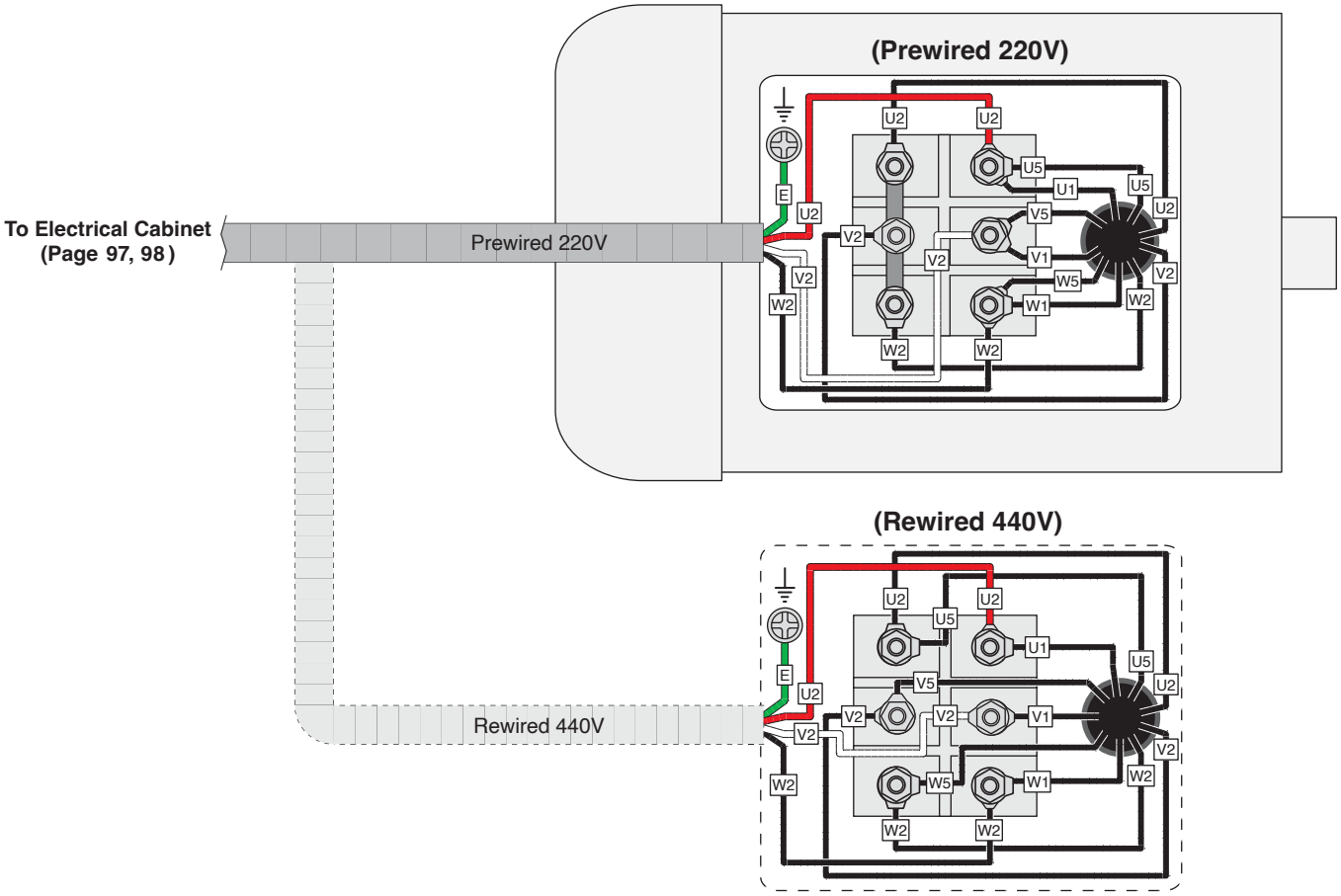





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# G0411 Table Elevation Motor Wiring



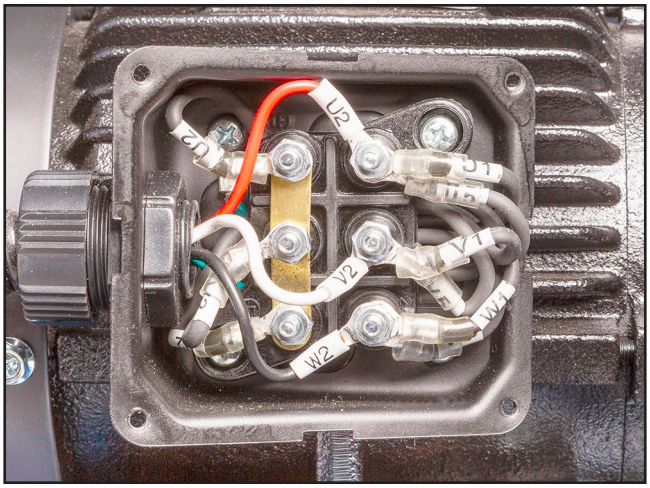
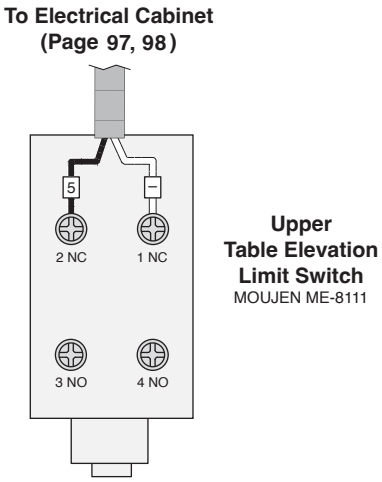




**Figure 177.** G0411 table elevation motor junction box wiring (220V shown).

# G0411 Limit Switch Wiring



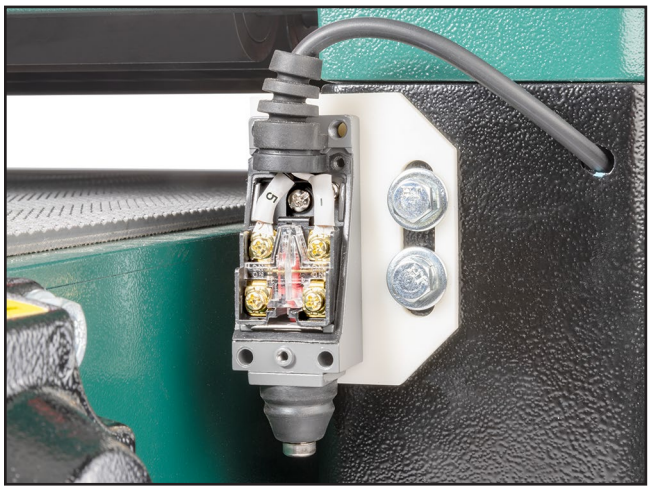
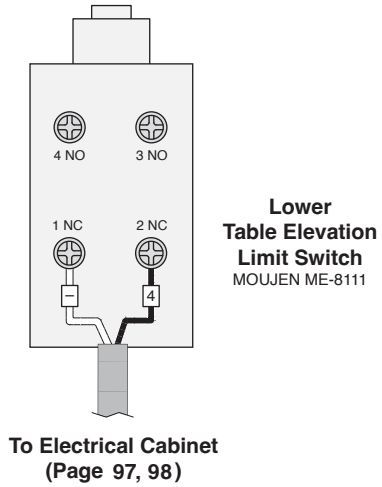



**Figure 178.** Upper table elevation limit switch wiring.



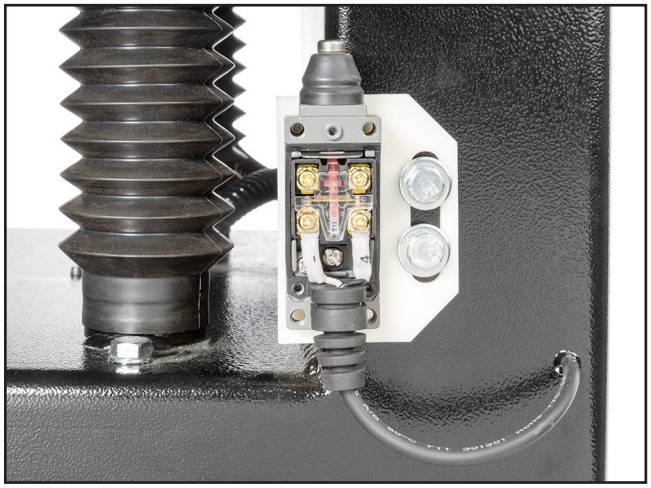
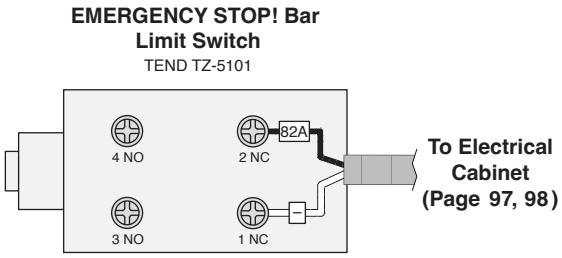



**Figure 179.** Lower table elevation limit switch wiring.



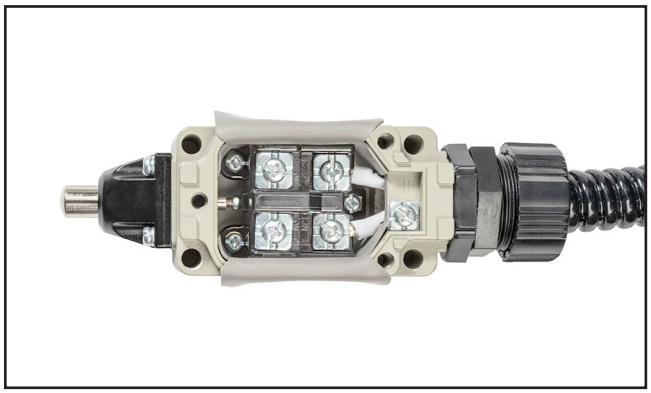



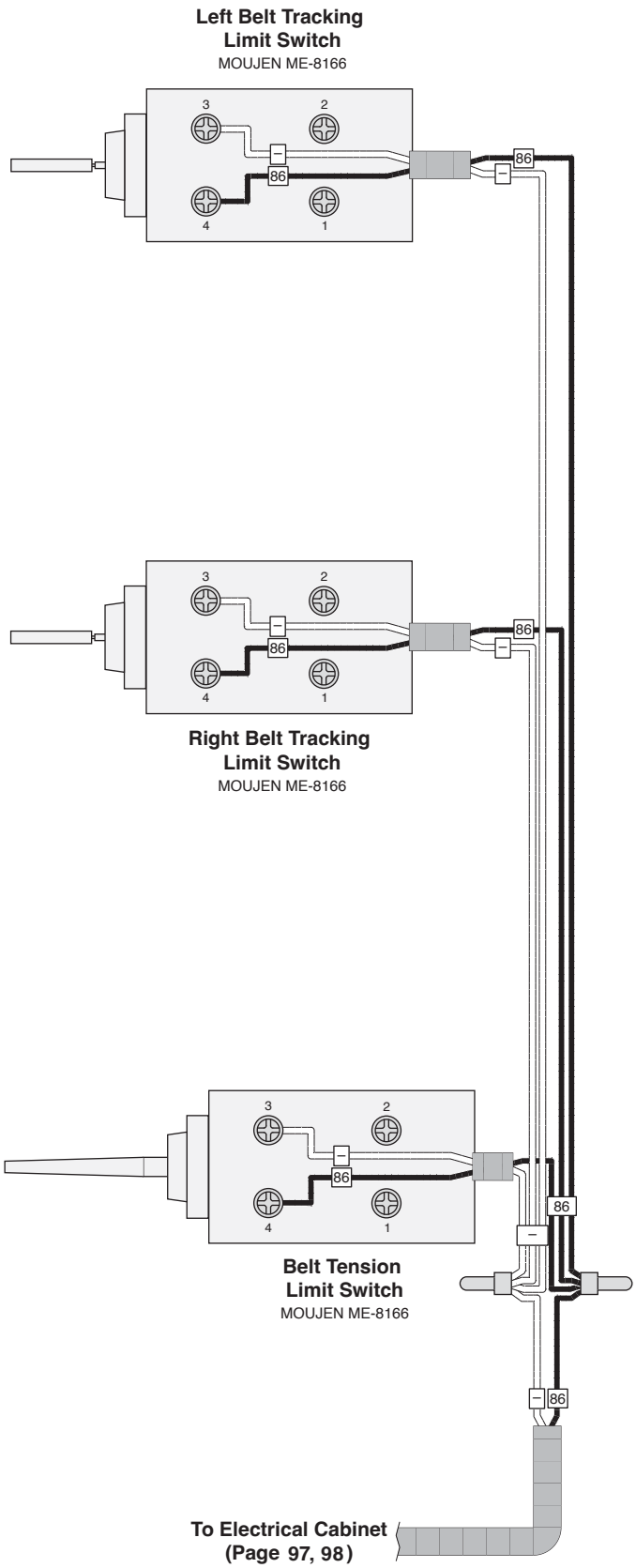
**Figure 180.** EMERGENCY STOP! bar limit switch wiring.






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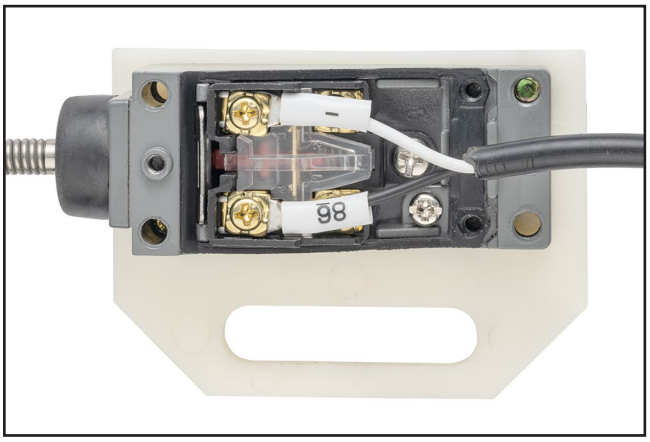




**Figure 181.** Left belt tracking limit switch wiring.

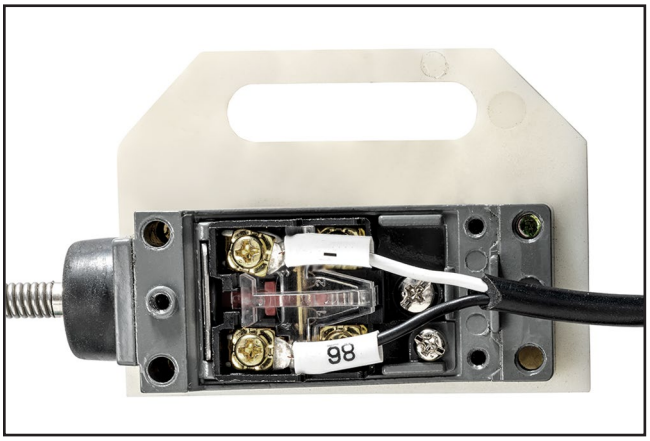



**Figure 182.** Right belt tracking limit switch wiring.

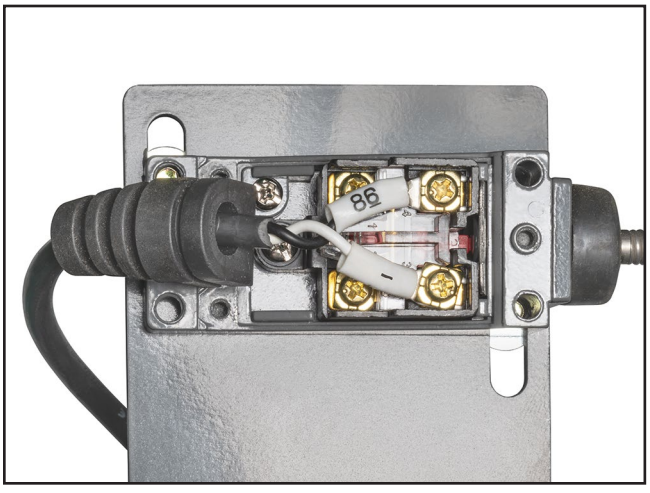
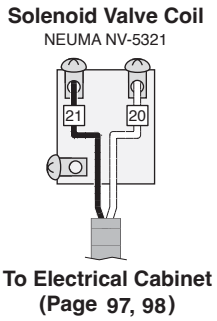



**Figure 183.** Belt tension limit switch wiring.

# G0411 Solenoid Valve Coil Wiring



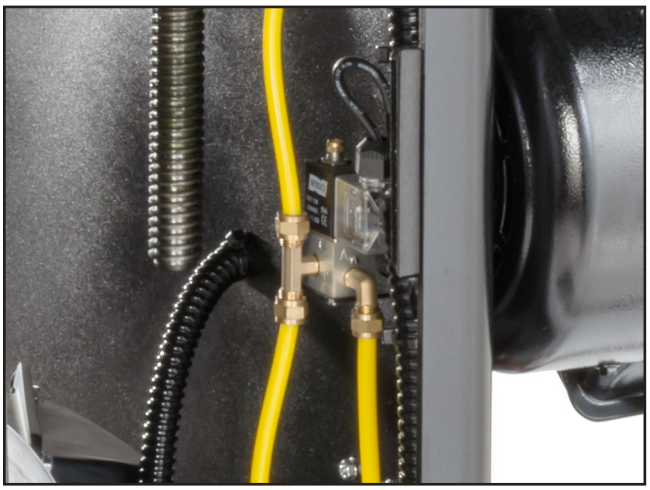
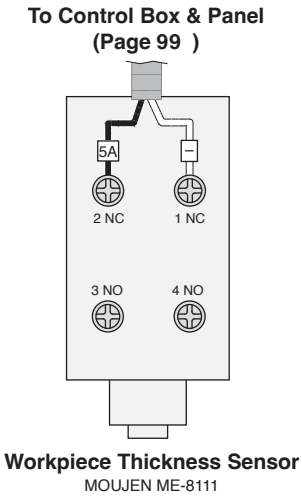



**Figure 184.** Solenoid valve coil.

# G0411 Sensor Wiring



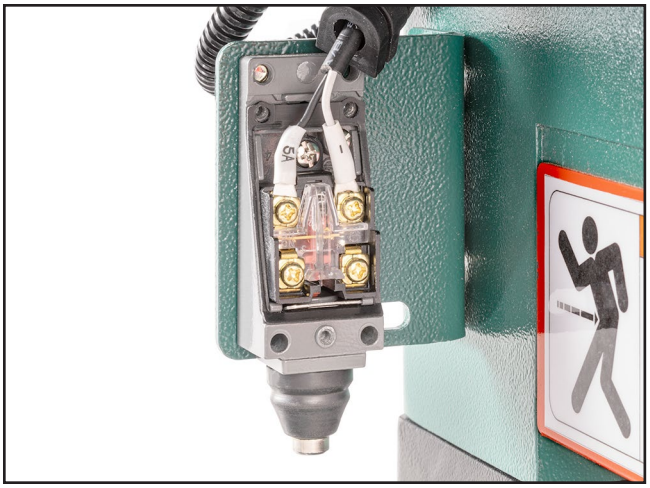
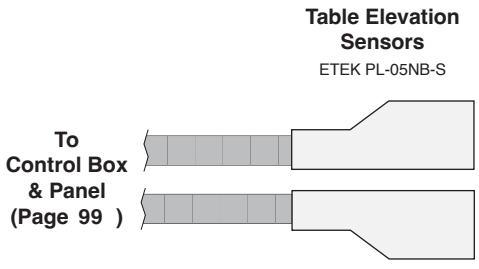



**Figure 185.** Workpiece thickness sensor wiring.



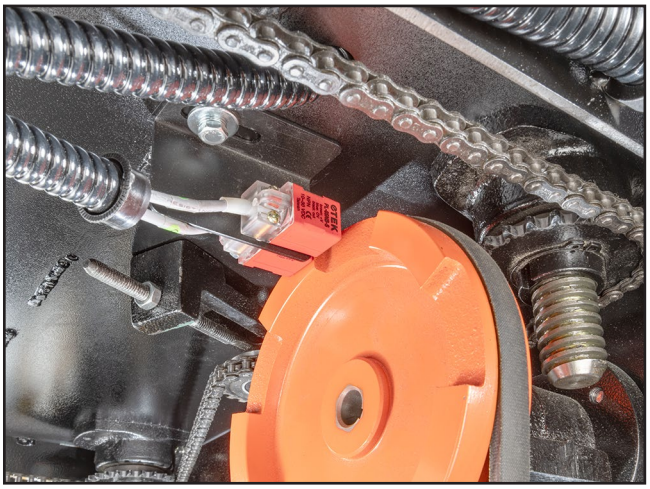



**Figure 186.** Table elevation sensors.





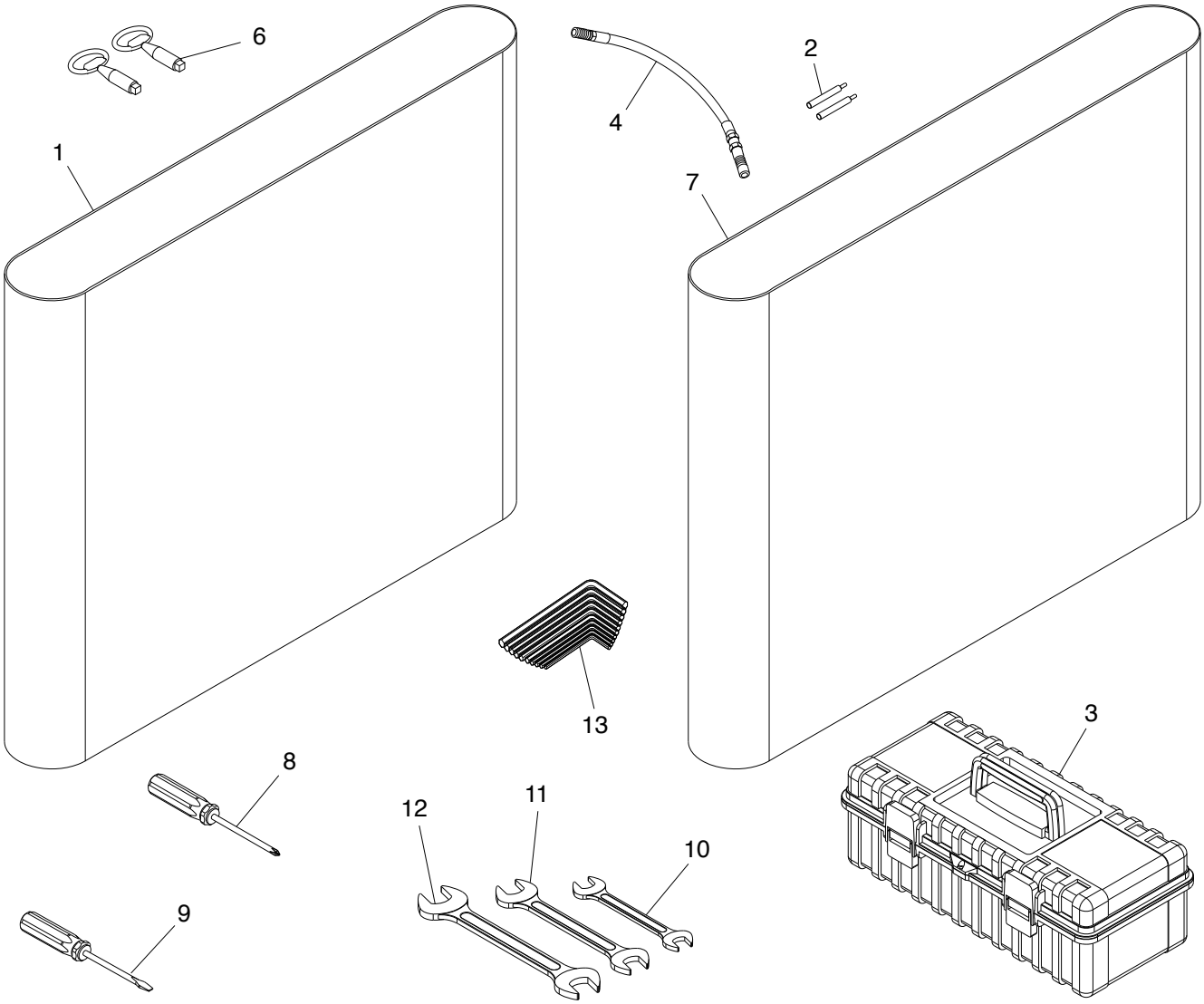

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# SECTION 9: PARTS

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



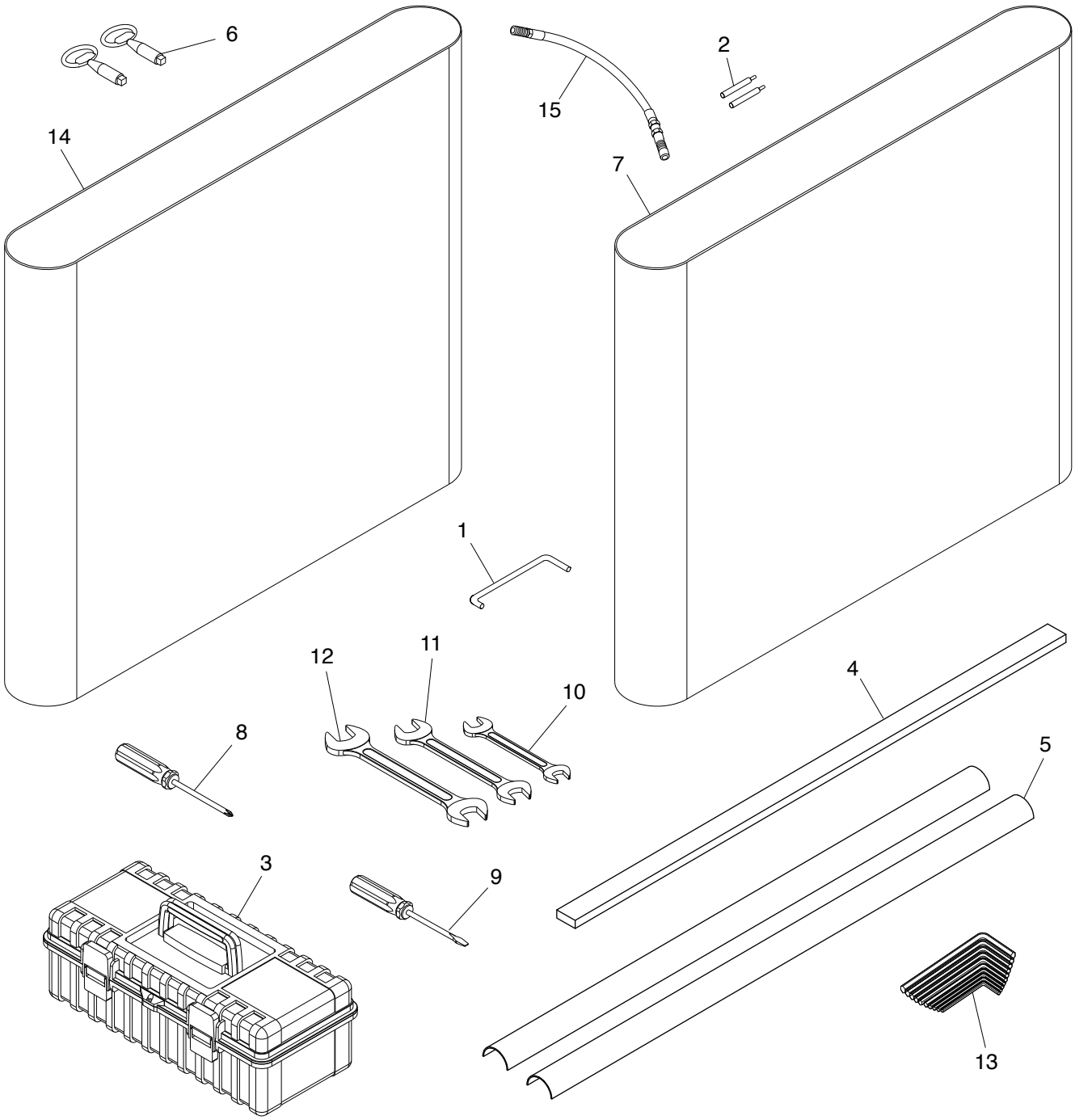

| REF | PART # | DESCRIPTION |
|---|---|---|
| 1 | P04080001 | SANDING BELT 25" X 60" 150-GRIT |
| 2 | P04080002 | LIMIT SWITCH CERAMIC TIP |
| 3 | P04080003 | TOOL BOX |
| 4 | P04080004 | FLEXIBLE GREASE GUN EXTENSION |
| 6 | P04080006 | DOOR KEY |
| 7 | P04080007 | SANDING BELT 25" X 60" 100-GRIT |

| 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



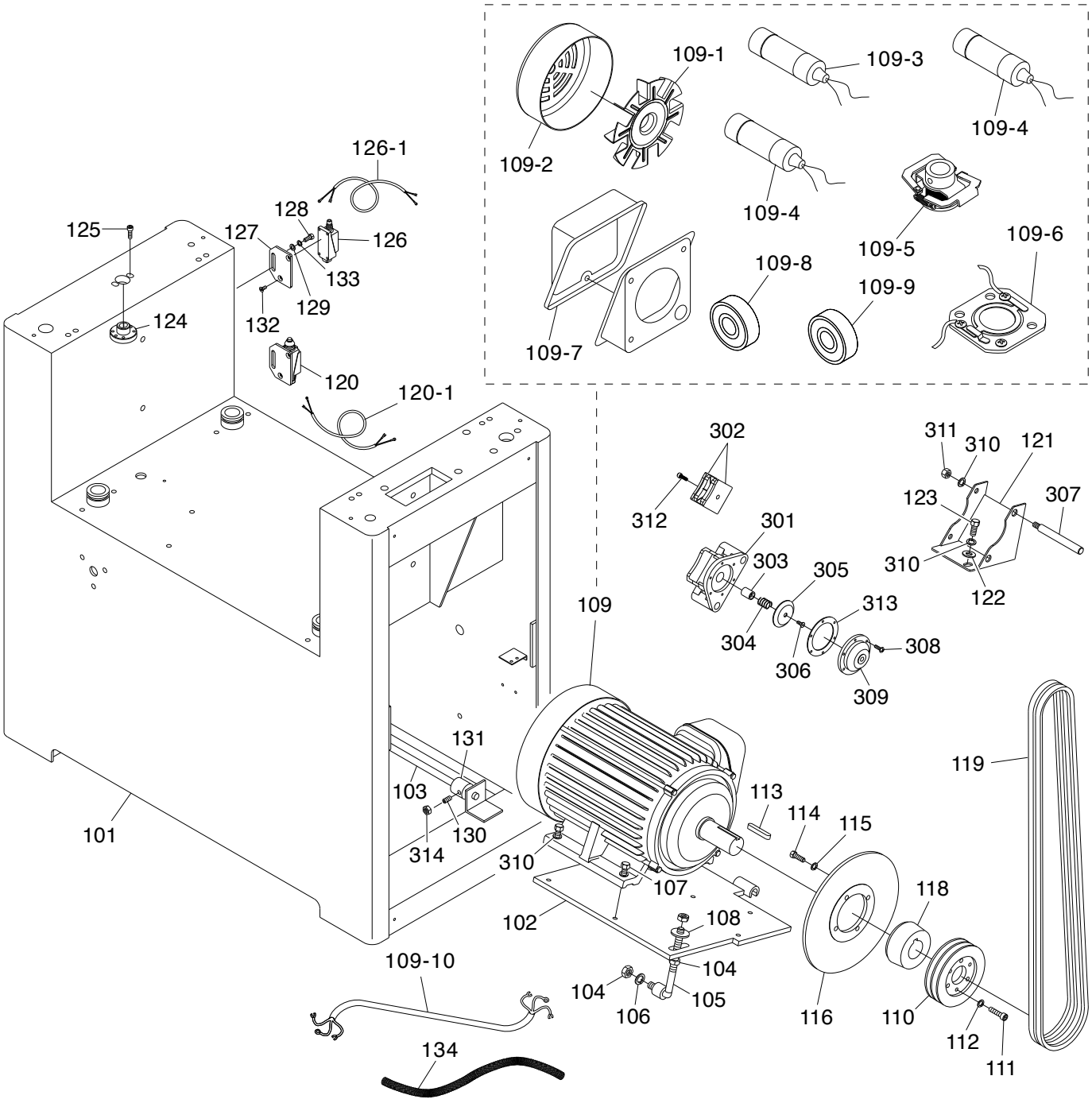

| REF | PART # | DESCRIPTION |
|---|---|---|
| 1 | P04090001 | PLATEN REMOVAL TOOL |
| 2 | P04090002 | LIMIT SWITCH CERAMIC TIP |
| 3 | P04090003 | TOOL BOX |
| 4 | P04090004 | FELT PAD 3/8" X 1-3/4" X 37-13/16" (G0409) |
| 4 | P04110004 | FELT PAD (G0411) |
| 5 | P04090005 | GRAPHITE PAD 3-1/2" X 38-3/16" (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

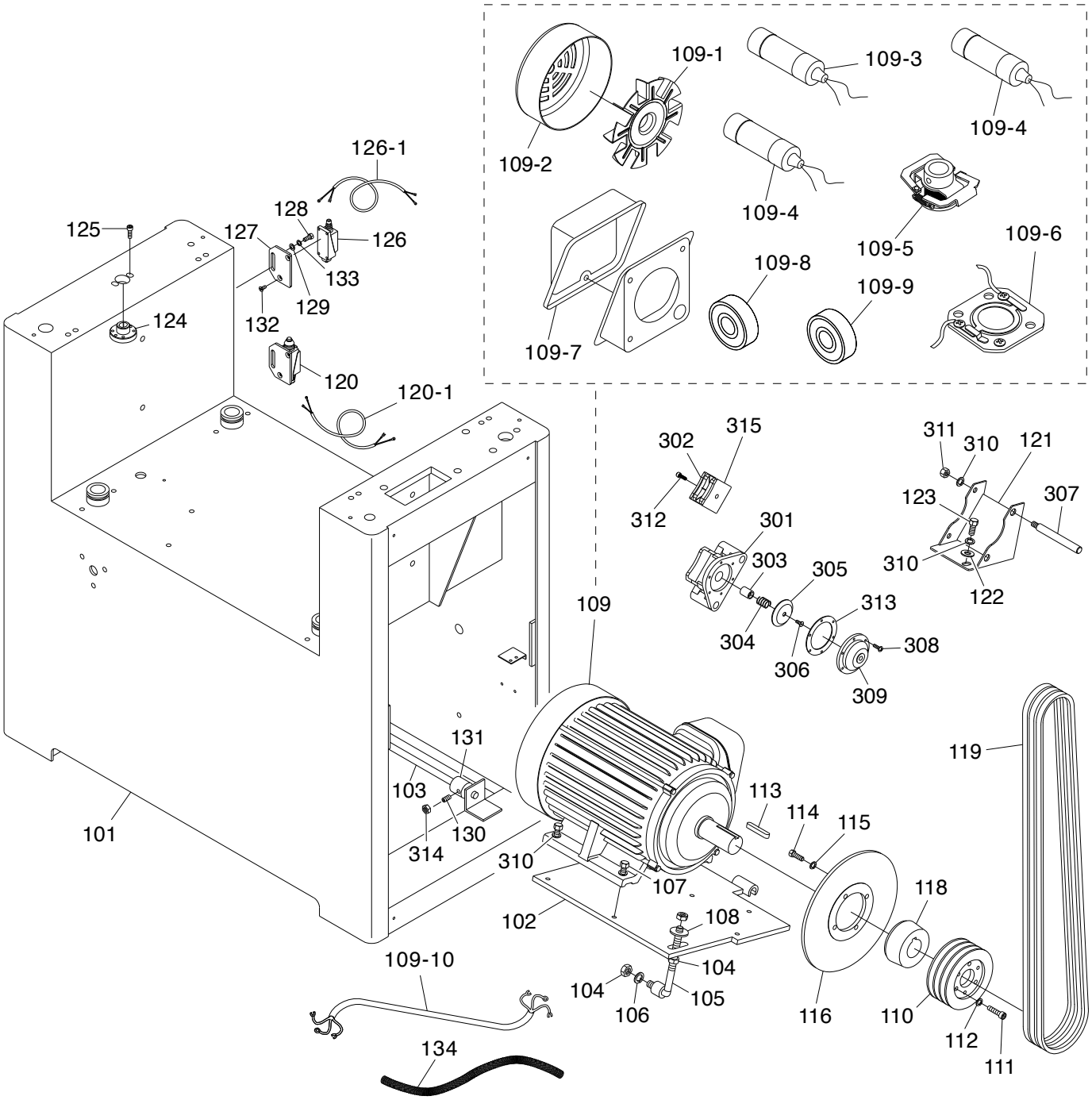
| REF | PART # | DESCRIPTION |
|---|---|---|
| 101 | P04080101 | MACHINE FRAME |
| 102 | P04080102 | MOTOR MOUNTING PLATE |
| 103 | P04080103 | PIVOT SHAFT |
| 104 | P04080104 | HEX NUT 1/2-12 |
| 105 | P04080105 | BELT TENSION ADJUSTMENT ROD |
| 106 | P04080106 | LOCK WASHER 1/2 |
| 107 | P04080107 | 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

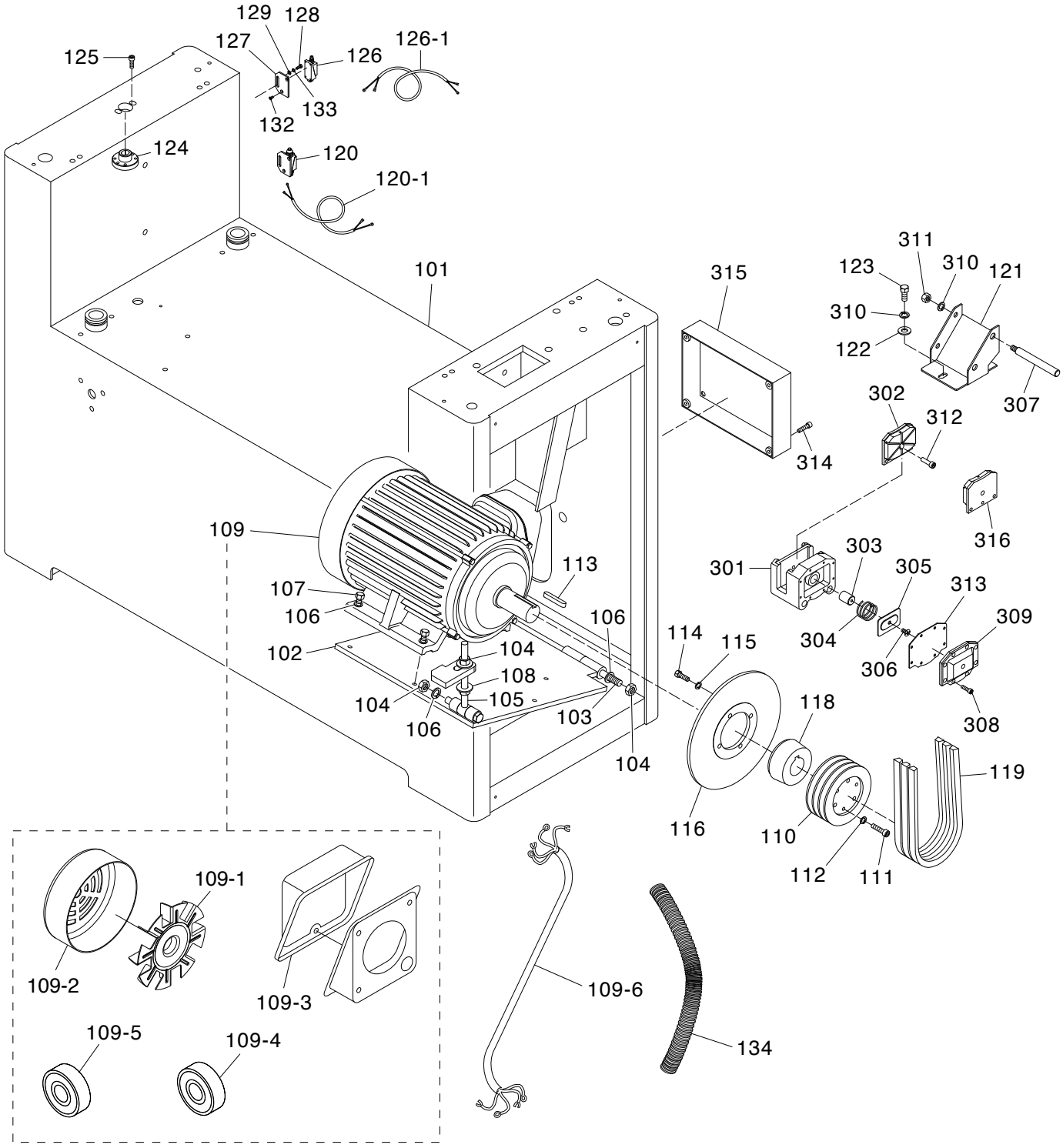
| REF | PART # | DESCRIPTION |
|---|---|---|
| 101 | P04090101 | MACHINE FRAME |
| 102 | P04090102 | MOTOR MOUNTING PLATE |
| 103 | P04090103 | PIVOT SHAFT |
| 104 | P04090104 | HEX NUT 1/2-12 |
| 105 | P04090105 | BELT TENSION ADJUSTMENT ROD |
| 106 | P04090106 | LOCK WASHER 1/2 |
| 107 | P04090107 | 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

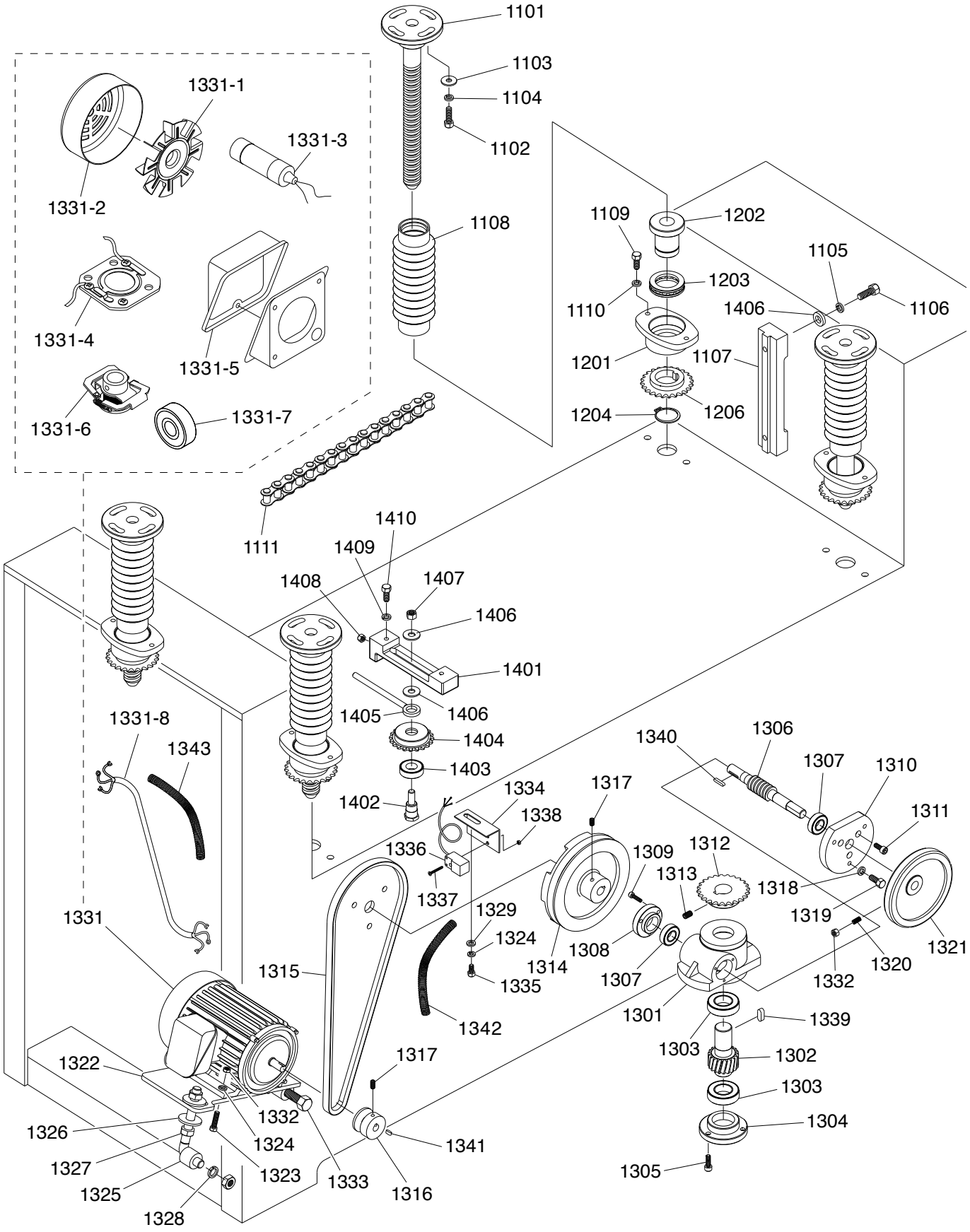
| REF | PART # | DESCRIPTION |
|---|---|---|
| 101 | P04110101 | MACHINE FRAME |
| 102 | P04110102 | MOTOR MOUNTING PLATE |
| 103 | P04110103 | PIVOT SHAFT |
| 104 | P04110104 | HEX NUT 1/2-12 |
| 105 | P04110105 | BELT TENSION ADJUSTMENT ROD |
| 106 | P04110106 | LOCK WASHER 1/2 |
| 107 | P04110107 | 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

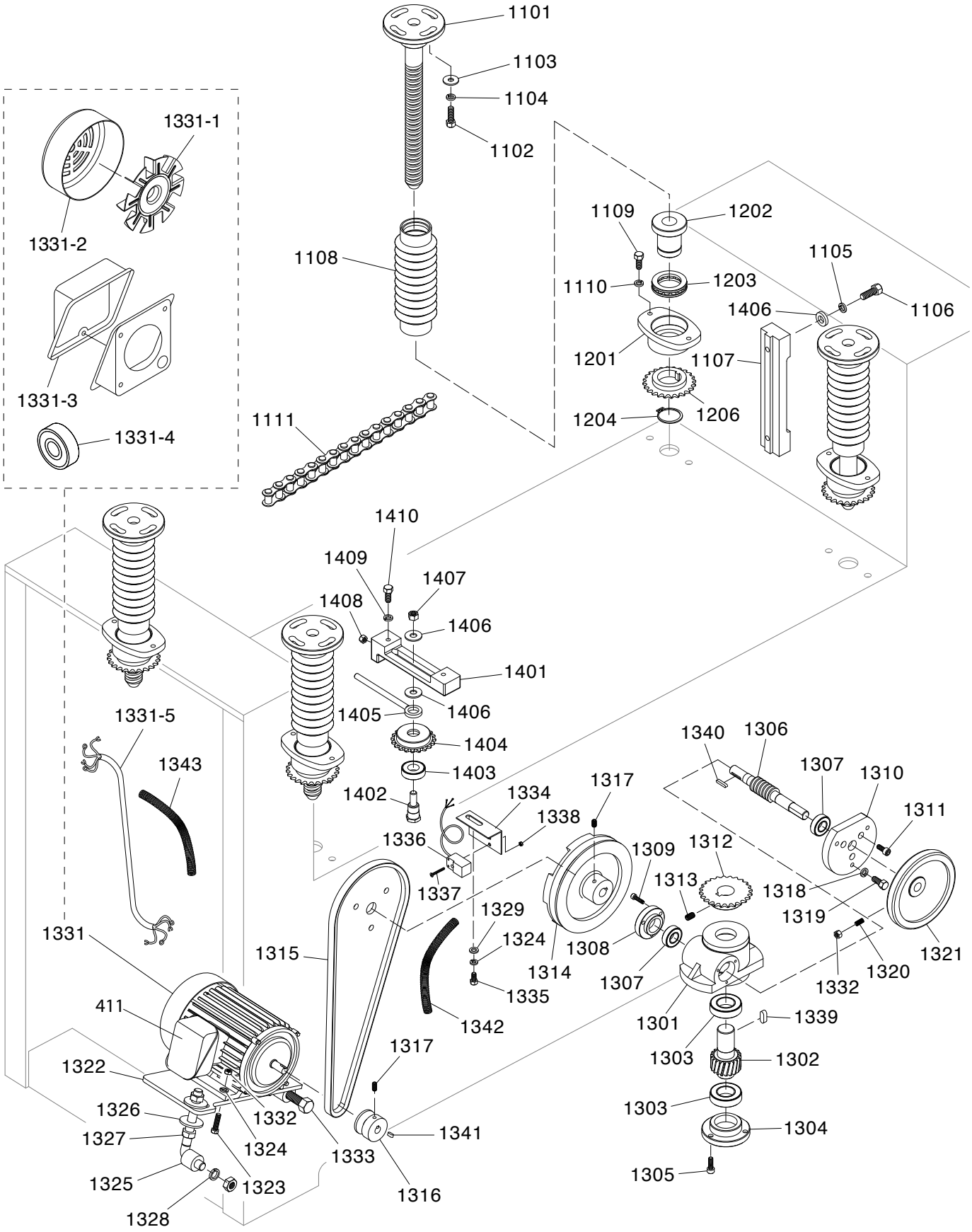
| REF | PART # | DESCRIPTION |
|---|---|---|
| 1101 | P04081101 | LEADSCREW W/FLANGE |
| 1102 | P04081102 | HEX BOLT 5/16-18 X 1 |
| 1103 | P04081103 | FLAT WASHER 5/16 |
| 1104 | P04081104 | LOCK WASHER 5/16 |
| 1105 | P04081105 | LOCK WASHER 3/8 |
| 1106 | P04081106 | HEX BOLT 3/8-16 X 1 |
| 1107 | 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

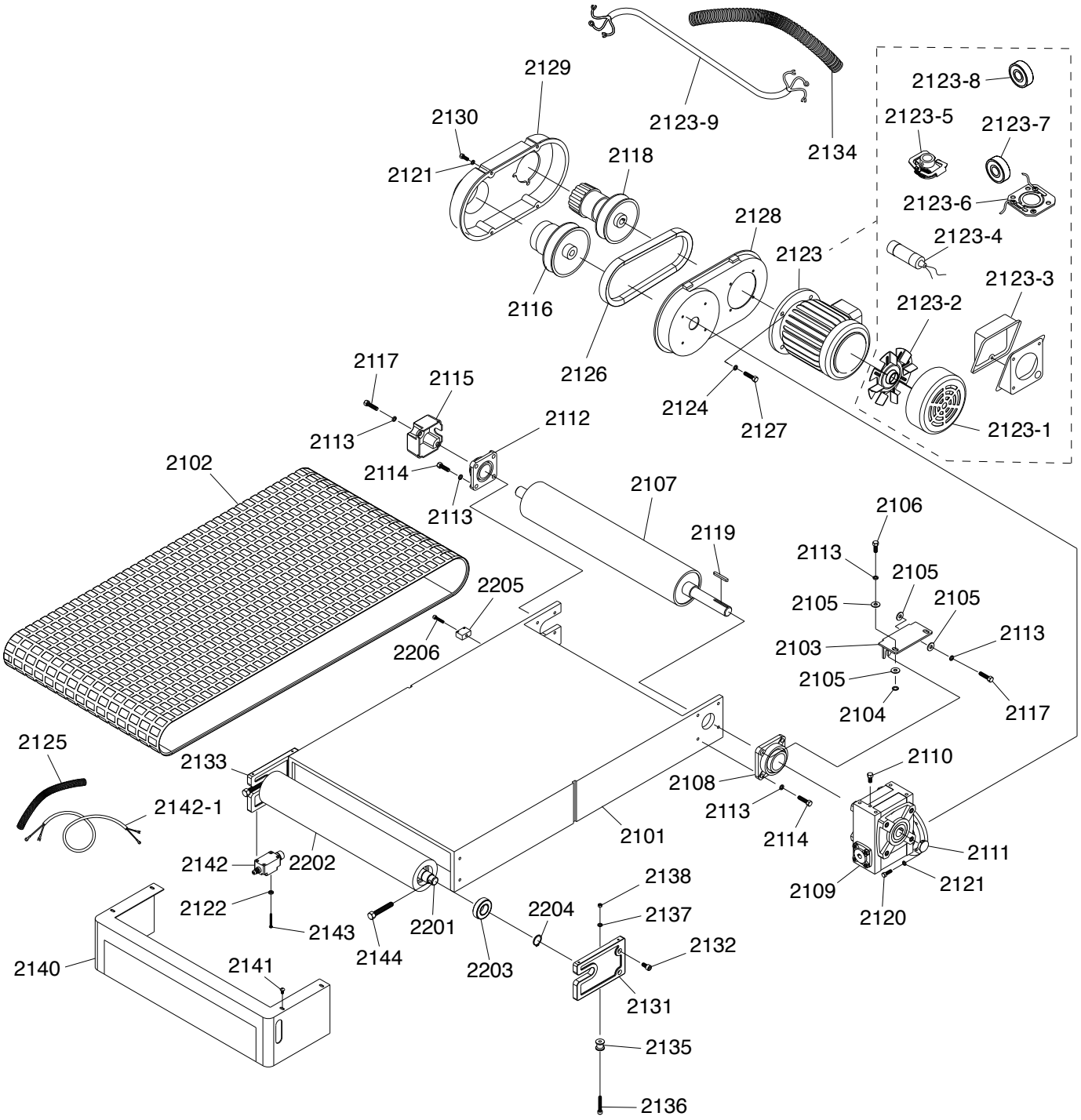
| REF | PART # | DESCRIPTION |
|---|---|---|
| 1101 | P04111101 | LEADSCREW W/FLANGE |
| 1102 | P04111102 | HEX BOLT 5/16-18 X 1 |
| 1103 | P04111103 | FLAT WASHER 5/16 |
| 1104 | P04111104 | LOCK WASHER 5/16 |
| 1105 | P04111105 | LOCK WASHER 3/8 |
| 1106 | P04111106 | HEX BOLT 3/8-16 X 1 |
| 1107 | 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

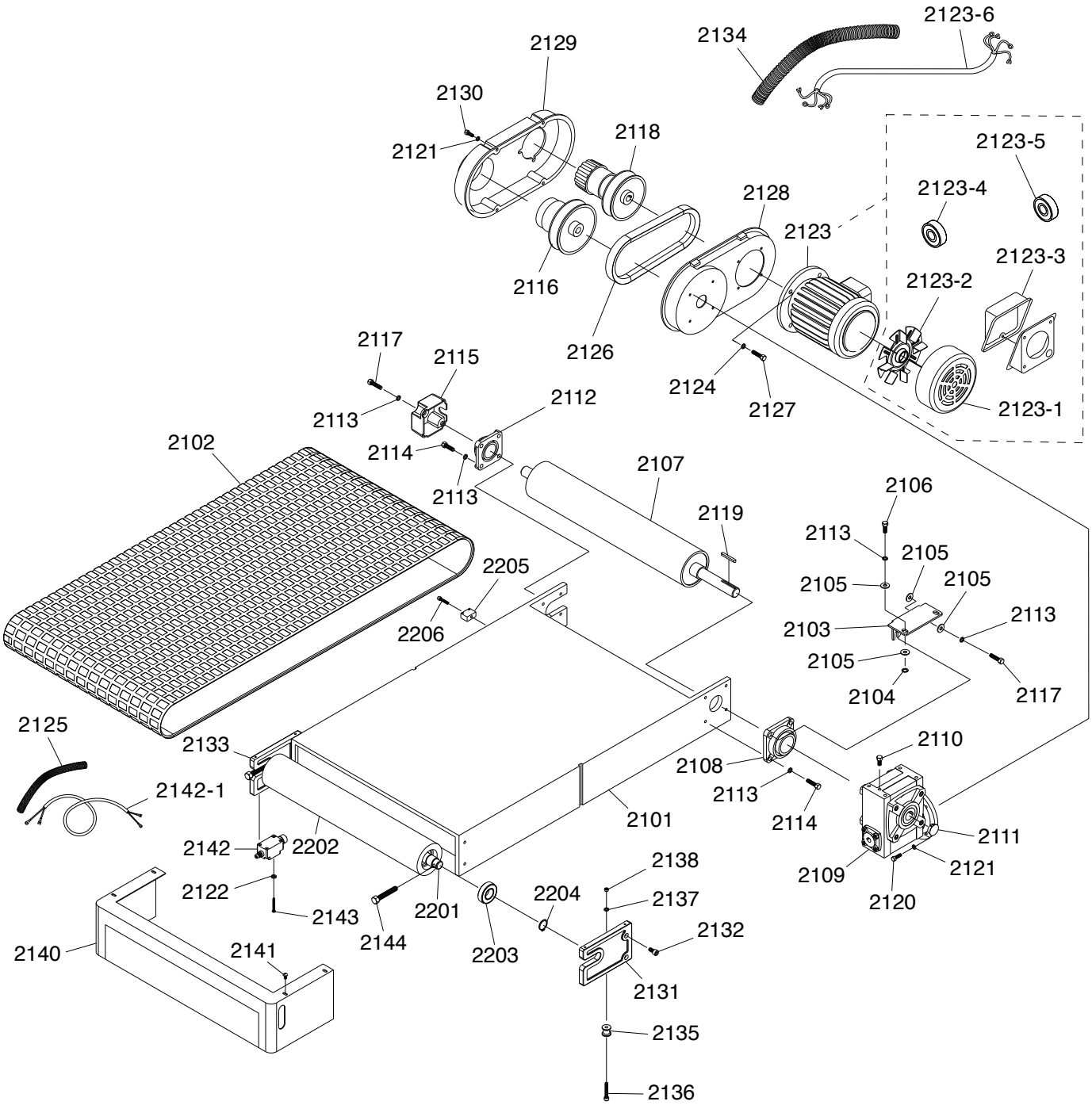
| REF | PART # | DESCRIPTION |
|---|---|---|
| 2101 | P04082101 | CONVEYOR TABLE (G0408) |
| 2101 | P04092101 | CONVEYOR TABLE (G0409) |
| 2102 | P04082102 | CONVEYOR BELT 24-3/8" X 82-11/16" (G0408) |
| 2102 | P04092102 | CONVEYOR BELT 36-1/2" X 82-11/16" (G0409) |
| 2103 | P04082103 | GEARBOX MOUNTING 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

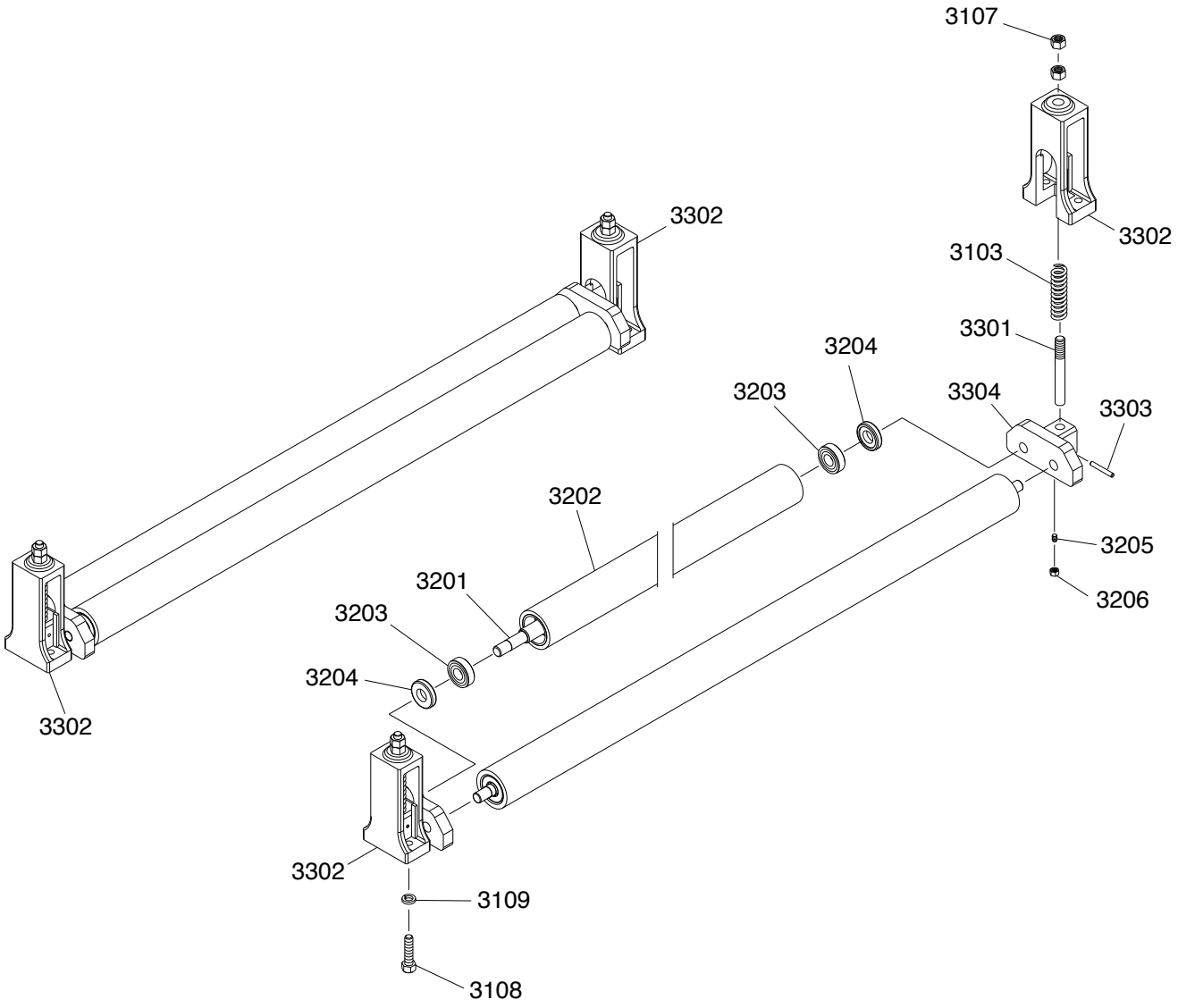
| REF | PART # | DESCRIPTION |
|---|---|---|
| 2101 | P04112101 | CONVEYOR TABLE |
| 2102 | P04112102 | CONVEYOR BELT 51-3/16" X 78-3/4" |
| 2103 | P04112103 | GEARBOX MOUNTING BRACKET |
| 2104 | P04112104 | CUSHION 10 X 2MM |
| 2105 | P04112105 | FLAT WASHER 10MM |
| 2106 | P04112106 | HEX BOLT M10-1.5 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



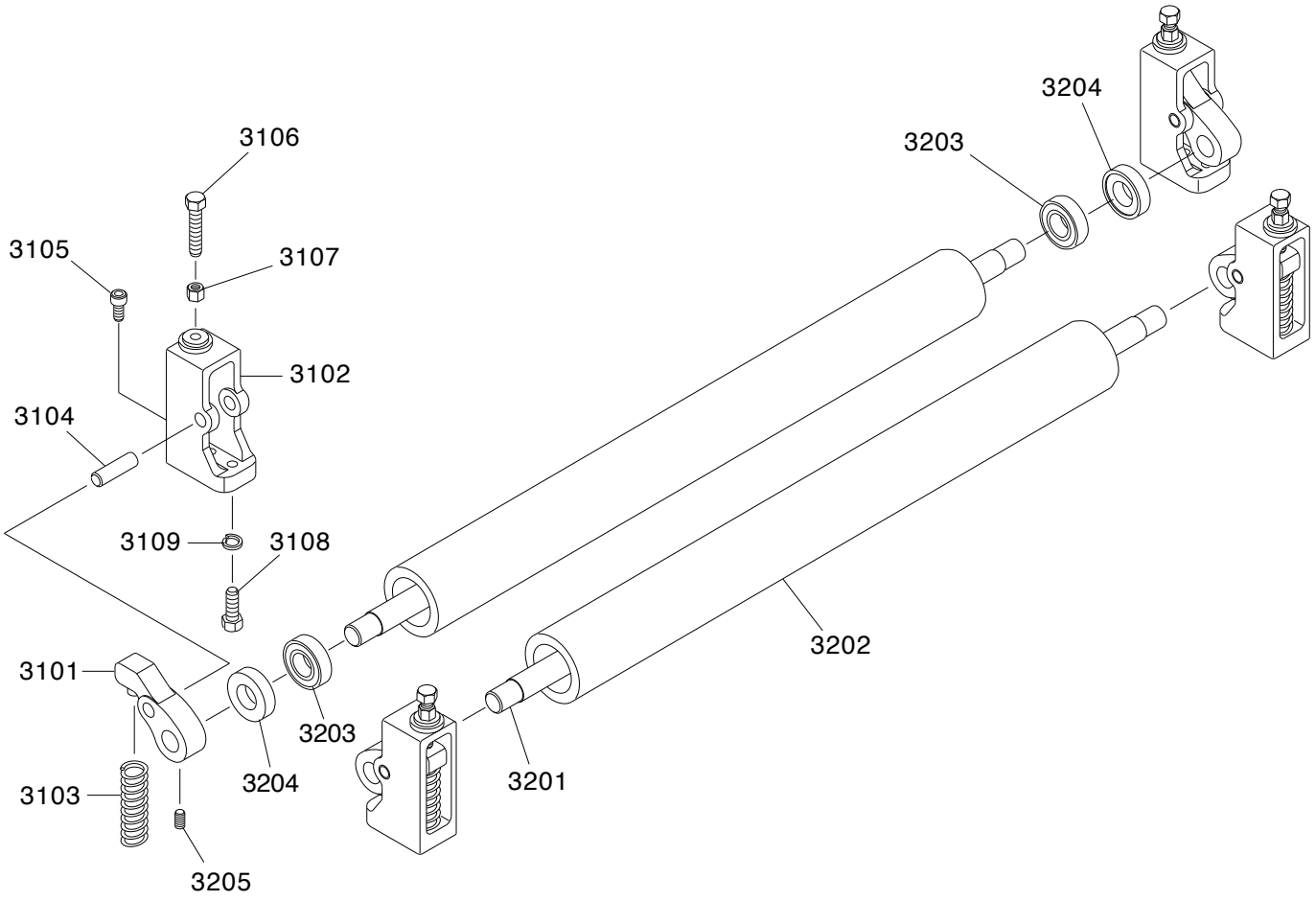

| REF | PART # | DESCRIPTION |
|---|---|---|
| 3103 | P04083103 | COMPRESSION SPRING 2 X 16 X 60 |
| 3107 | P04083107 | HEX NUT 3/8-16 |
| 3108 | P04083108 | HEX BOLT 5/16-18 X 1-1/4 |
| 3109 | P04083109 | LOCK WASHER 5/16 |
| 3201 | P04083201 | PRESSURE ROLLER SHAFT |
| 3202 | P04083202 | PRESSURE ROLLER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



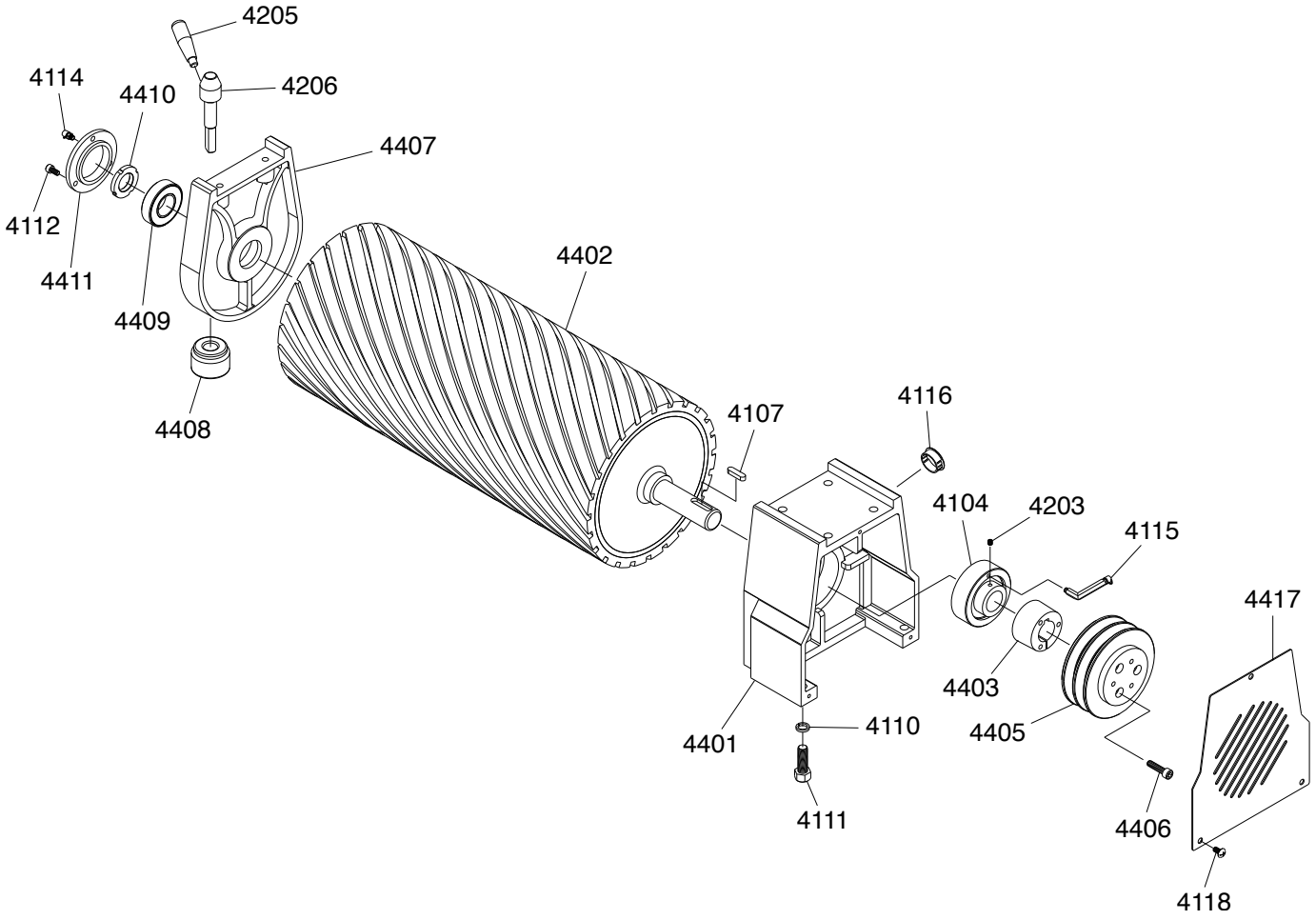

| REF | PART # | DESCRIPTION |
|---|---|---|
| 3101 | P04093101 | OUTER PISTON BRACKET |
| 3102 | P04093102 | INNER PISTON BRACKET |
| 3103 | P04093103 | COMPRESSION SPRING 3 X 15.7 X 57MM |
| 3104 | P04093104 | DOWEL PIN 10 X 35MM |
| 3105 | P04093105 | CAP SCREW 1/4-20 X 1/2 |
| 3106 | P04093106 | 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



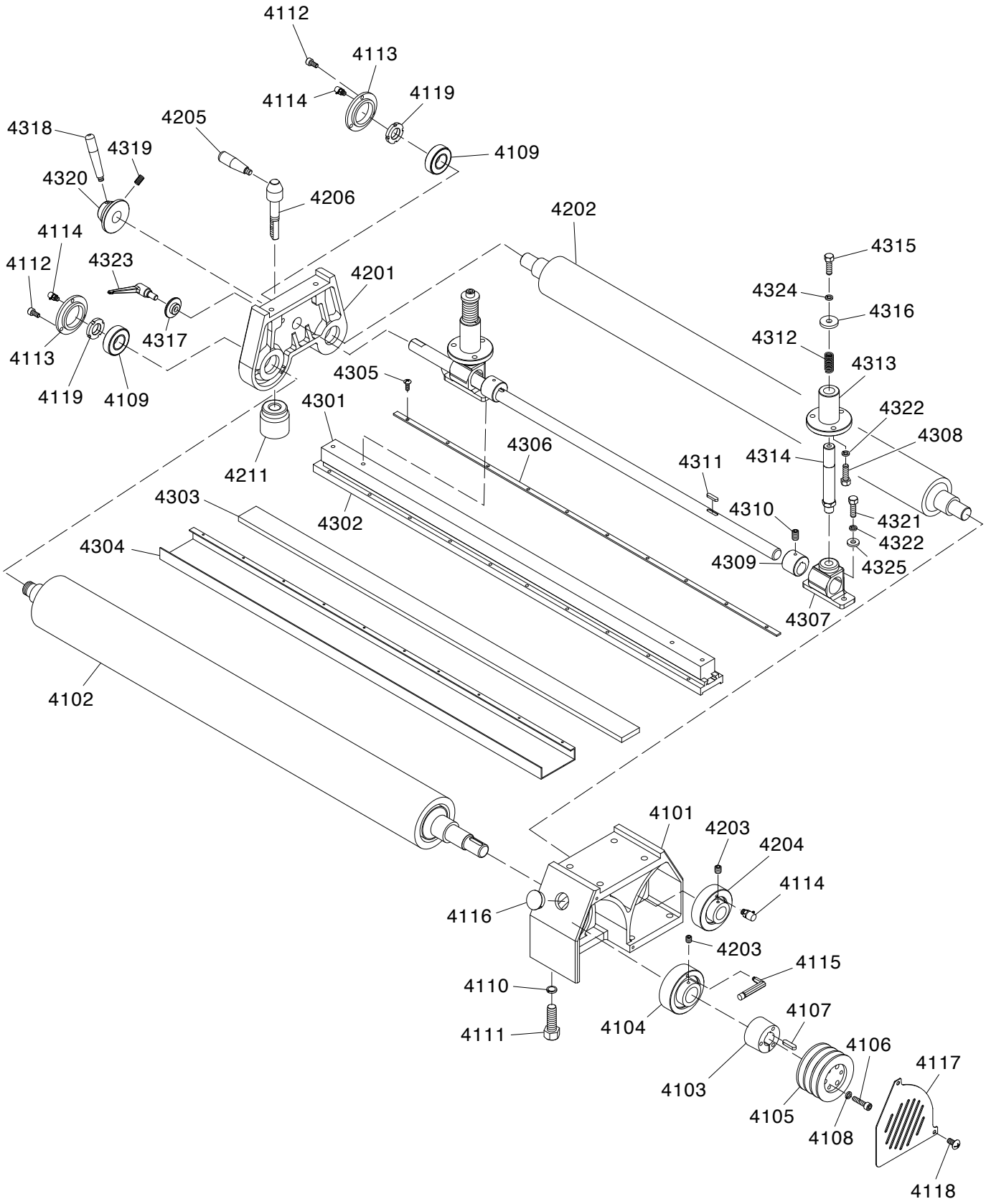

| REF | PART # | DESCRIPTION |
|---|---|---|
| 4104 | P04084104 | CARTRIDGE BEARING UCC206 |
| 4107 | P04084107 | KEY 8 X 8 X 30 RE |
| 4110 | P04084110 | LOCK WASHER 1/2 |
| 4111 | P04084111 | HEX BOLT 1/2-12 X 1-1/2 |
| 4112 | P04084112 | CAP SCREW 1/4-20 X 1/2 |
| 4114 | P04084114 | GREASE FITTING 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

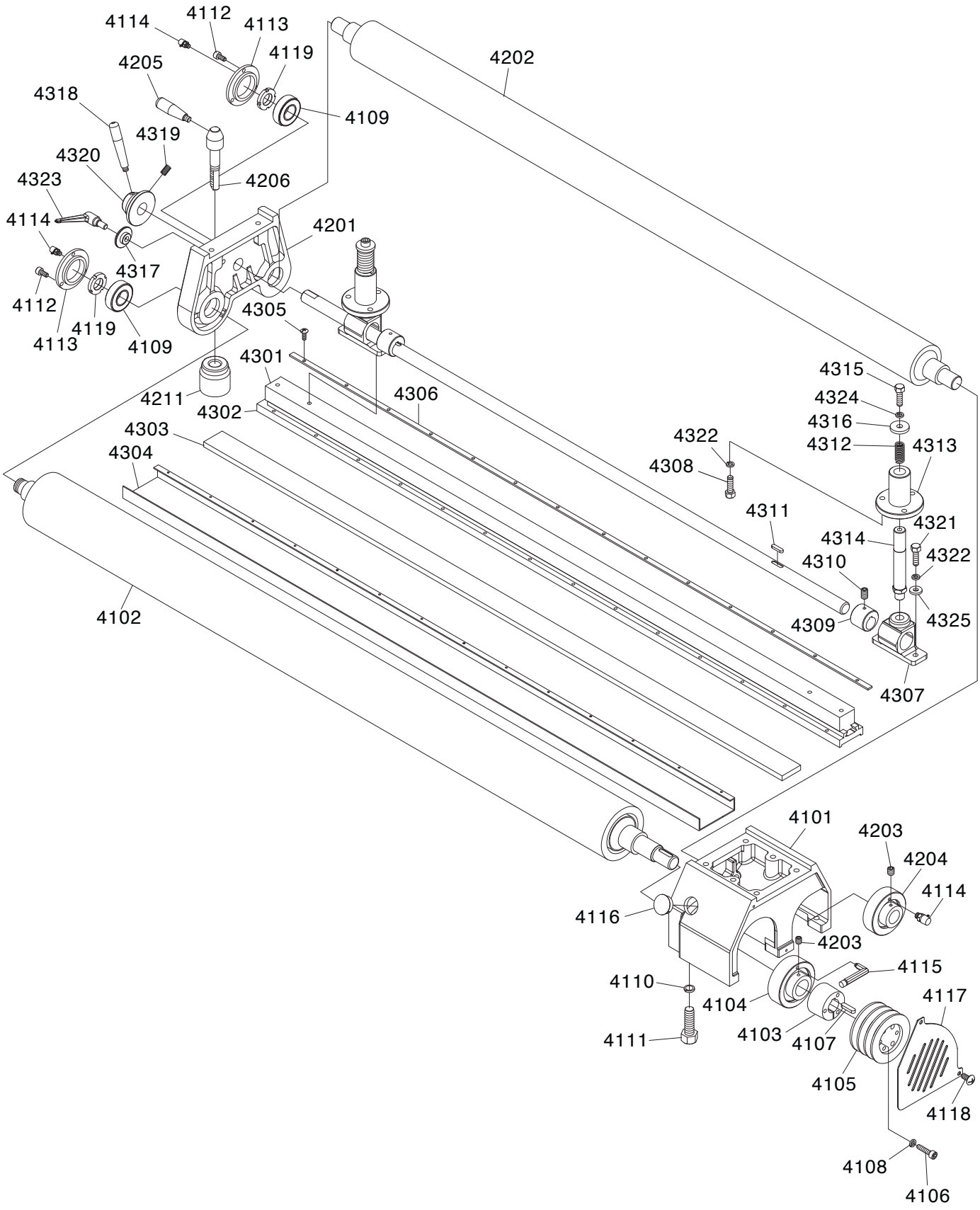
| REF | PART # | DESCRIPTION |
|---|---|---|
| 4101 | P04094101 | BEARING HOUSING R |
| 4102 | P04094102 | DRUM RUBBER |
| 4103 | P04094103 | LOCK COLLAR |
| 4104 | P04094104 | CARTRIDGE BEARING UCC206 |
| 4105 | P04094105 | DRUM PULLEY |
| 4106 | P04094106 | CAP SCREW 5/16-18 X 1-1/4 |
| 4107 | P04094107 | 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

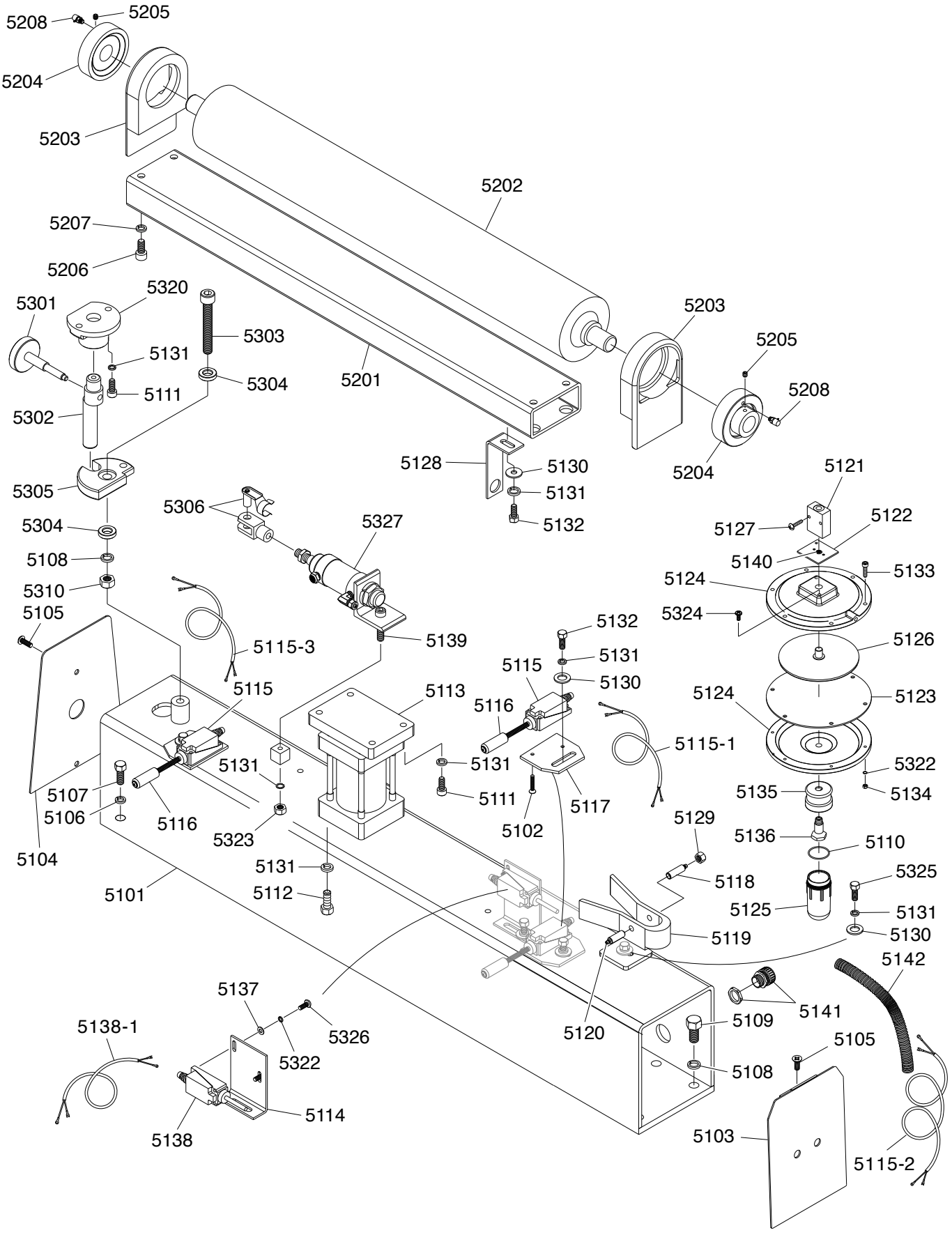
| REF | PART # | DESCRIPTION |
|---|---|---|
| 4101 | P04114101 | BEARING HOUSING R |
| 4102 | P04114102 | DRUM RUBBER |
| 4103 | P04114103 | LOCK COLLAR |
| 4104 | P04114104 | CARTRIDGE BEARING UCC206 |
| 4105 | P04114105 | DRUM PULLEY |
| 4106 | P04114106 | CAP SCREW 5/16-18 X 1-1/4 |
| 4107 | P04114107 | 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

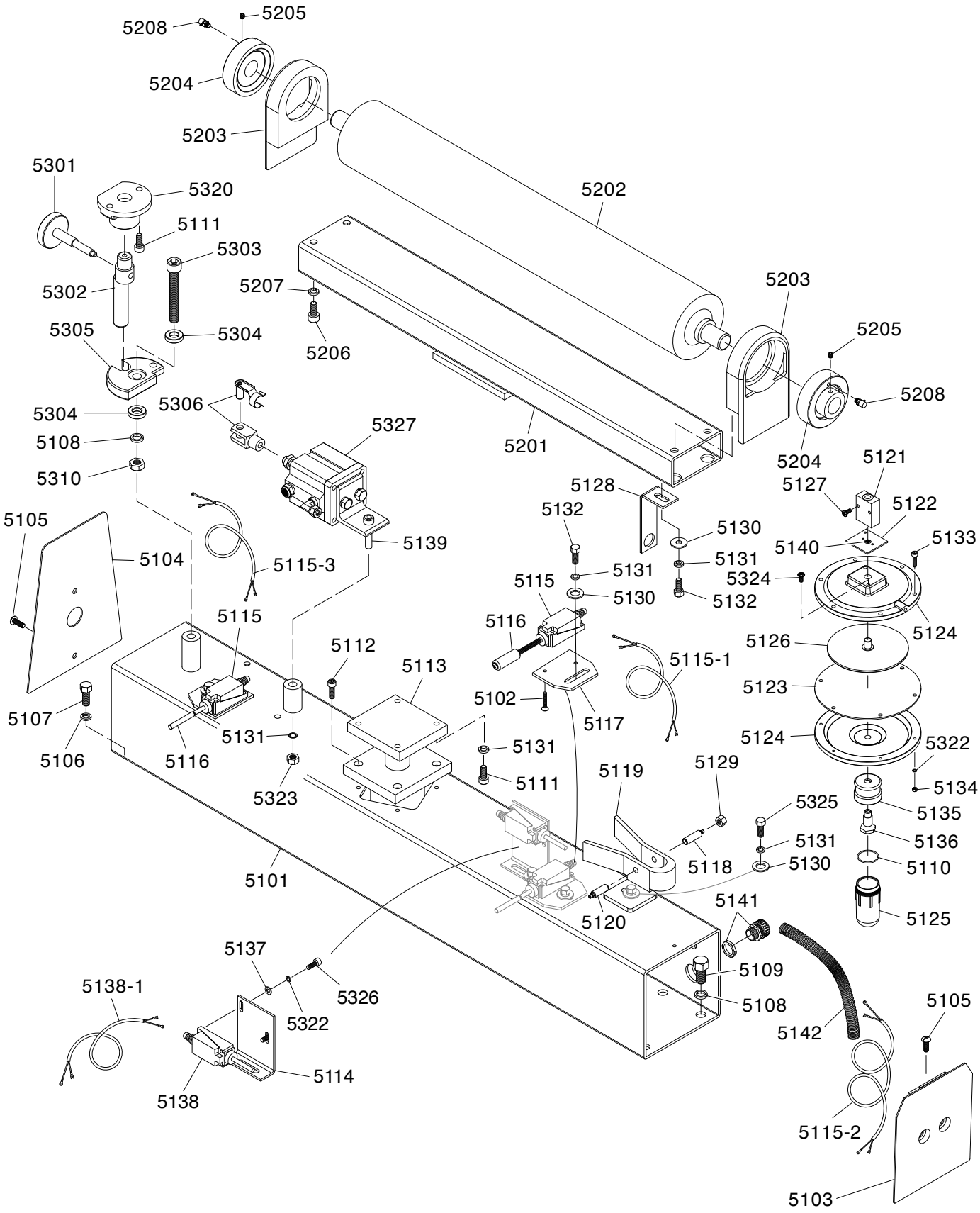
| REF | PART # | DESCRIPTION |
|---|---|---|
| 5101 | P04085101 | SQUARE FRAME (G0408) |
| 5101 | P04095101 | SQUARE FRAME (G0409) |
| 5102 | P04085102 | FLAT HD SCR 1/4-20 X 1/2 (G0408) |
| 5102 | P04095102 | FLAT HD SCR M4-.8 X 8 (G0409) |
| 5103 | P04085103 | SQUARE FRAME COVER R |
| 5104 | P04085104 | 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

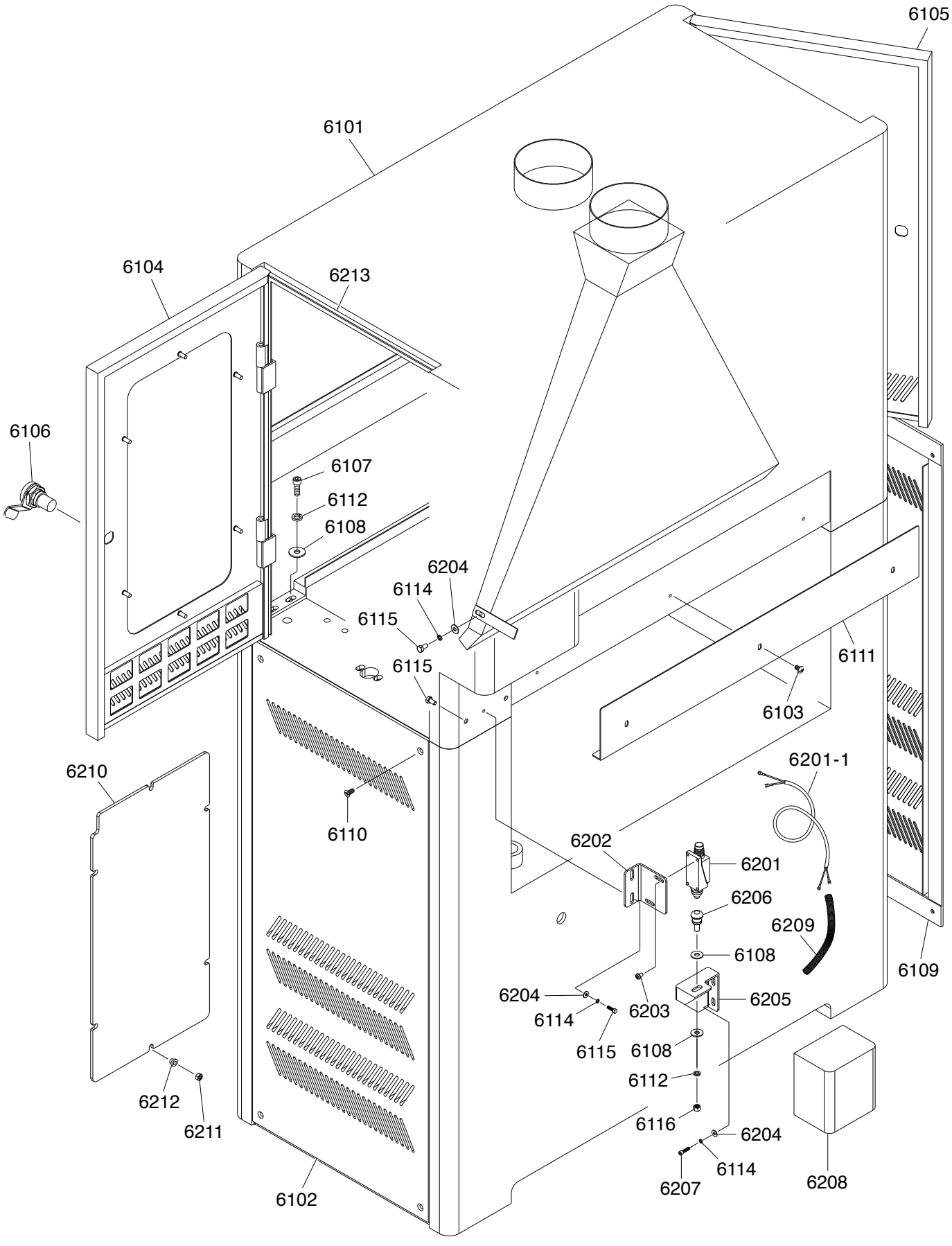
| REF | PART # | DESCRIPTION |
|---|---|---|
| 5101 | P04115101 | SQUARE FRAME |
| 5102 | P04115102 | FLAT HD SCR M5-.8 X 8 |
| 5103 | P04115103 | SQUARE FRAME COVER R |
| 5104 | P04115104 | SQUARE FRAME COVER L |
| 5105 | P04115105 | FLAT HD SCR 1/4-20 X 1/2 |
| 5106 | P04115106 | LOCK WASHER 3/8 |
| 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

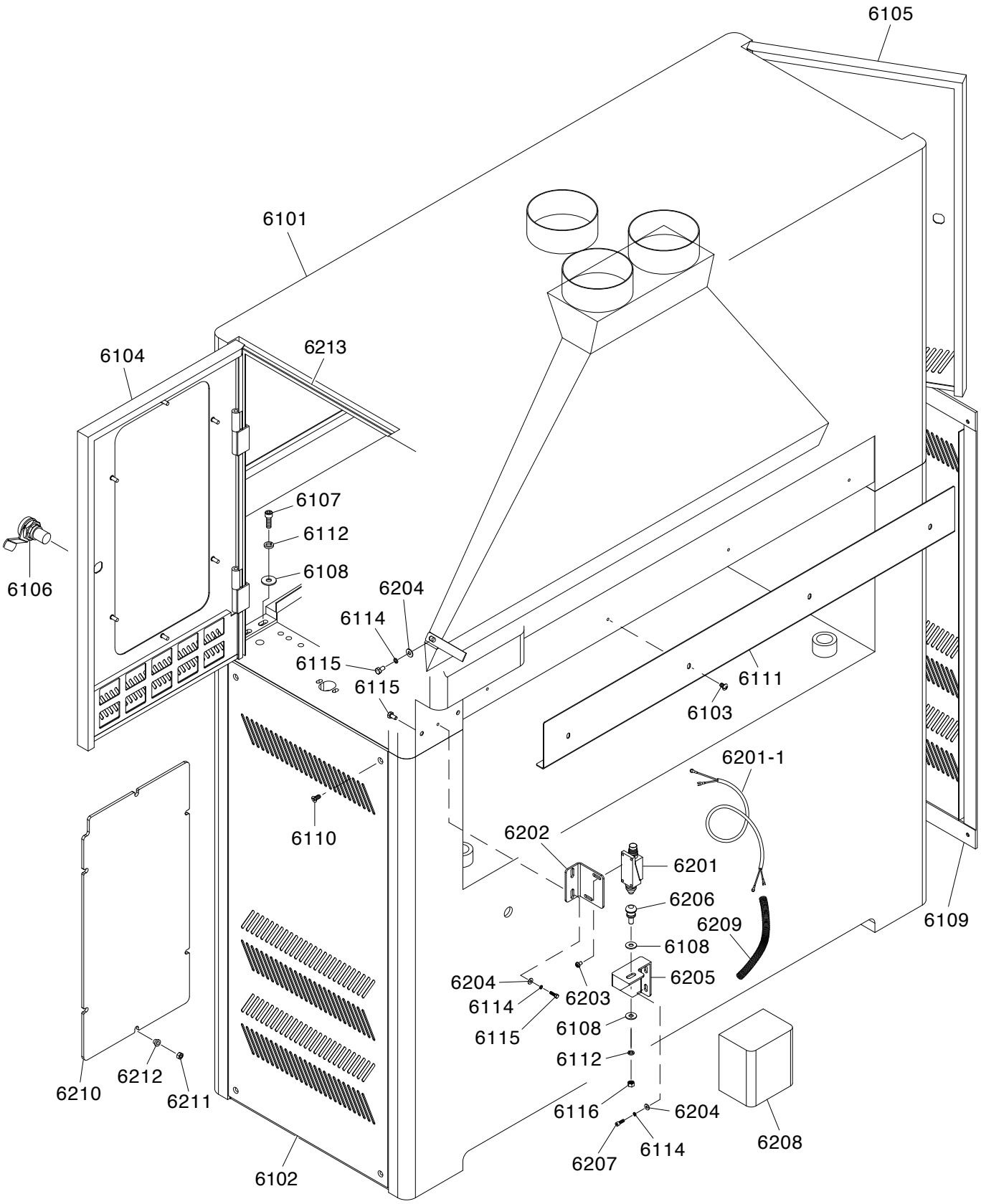
| REF | PART # | DESCRIPTION |
|---|---|---|
| 6101 | P04086101 | UPPER FRAME COVER |
| 6102 | P04086102 | ACCESS PANEL L |
| 6103 | P04086103 | PHLP HD SCR M6-1 X 10 |
| 6104 | P04086104 | DOOR L |
| 6105 | P04086105 | DOOR R |
| 6106 | P04086106 | DOOR LOCK |
| 6107 | P04086107 | CAP SCREW 5/16-18 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

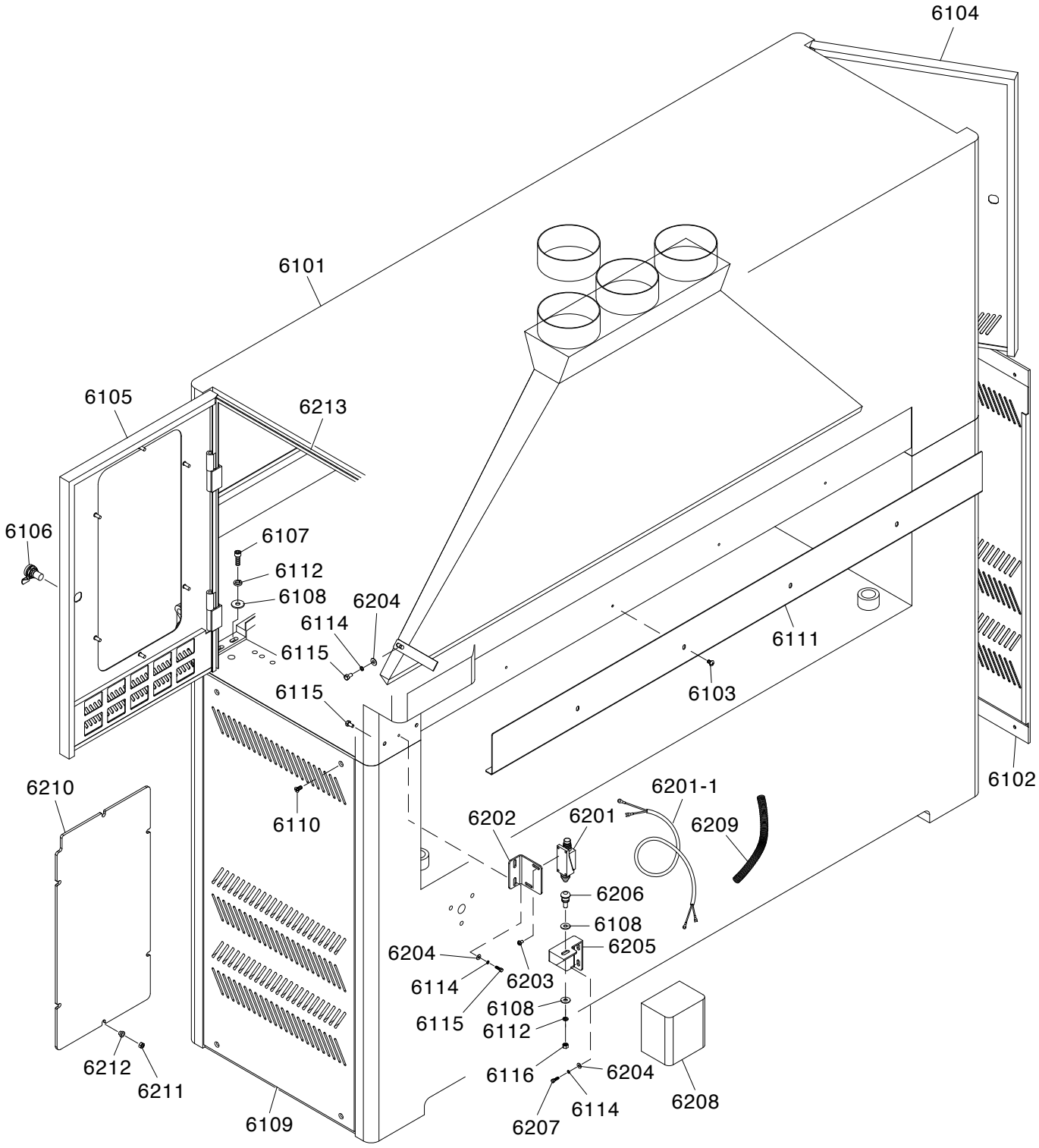
| REF | PART # | DESCRIPTION |
|---|---|---|
| 6101 | P04096101 | UPPER FRAME COVER |
| 6102 | P04096102 | ACCESS PANEL L |
| 6103 | P04096103 | PHLP HD SCR M6-1 X 10 |
| 6104 | P04096104 | DOOR L |
| 6105 | P04096105 | DOOR R |
| 6106 | P04096106 | DOOR LOCK |
| 6107 | P04096107 | CAP SCREW 5/16-18 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

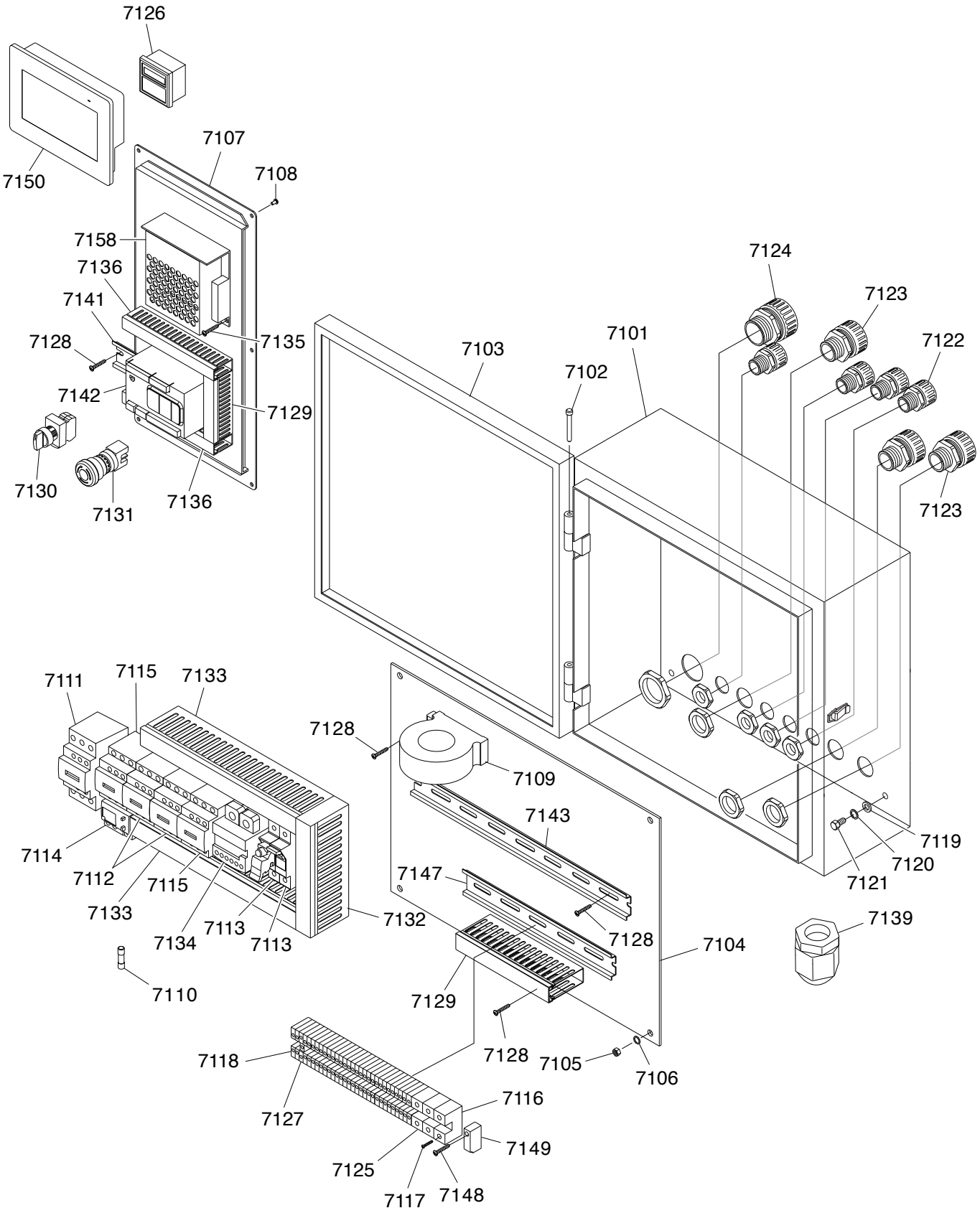
| REF | PART # | DESCRIPTION |
|---|---|---|
| 6101 | P04116101 | UPPER FRAME COVER |
| 6102 | P04116102 | ACCESS PANEL R |
| 6103 | P04116103 | PHLP HD SCR M6-1 X 10 |
| 6104 | P04116104 | DOOR R |
| 6105 | P04116105 | DOOR L |
| 6106 | P04116106 | DOOR LOCK |
| 6107 | P04116107 | CAP SCREW 5/16-18 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

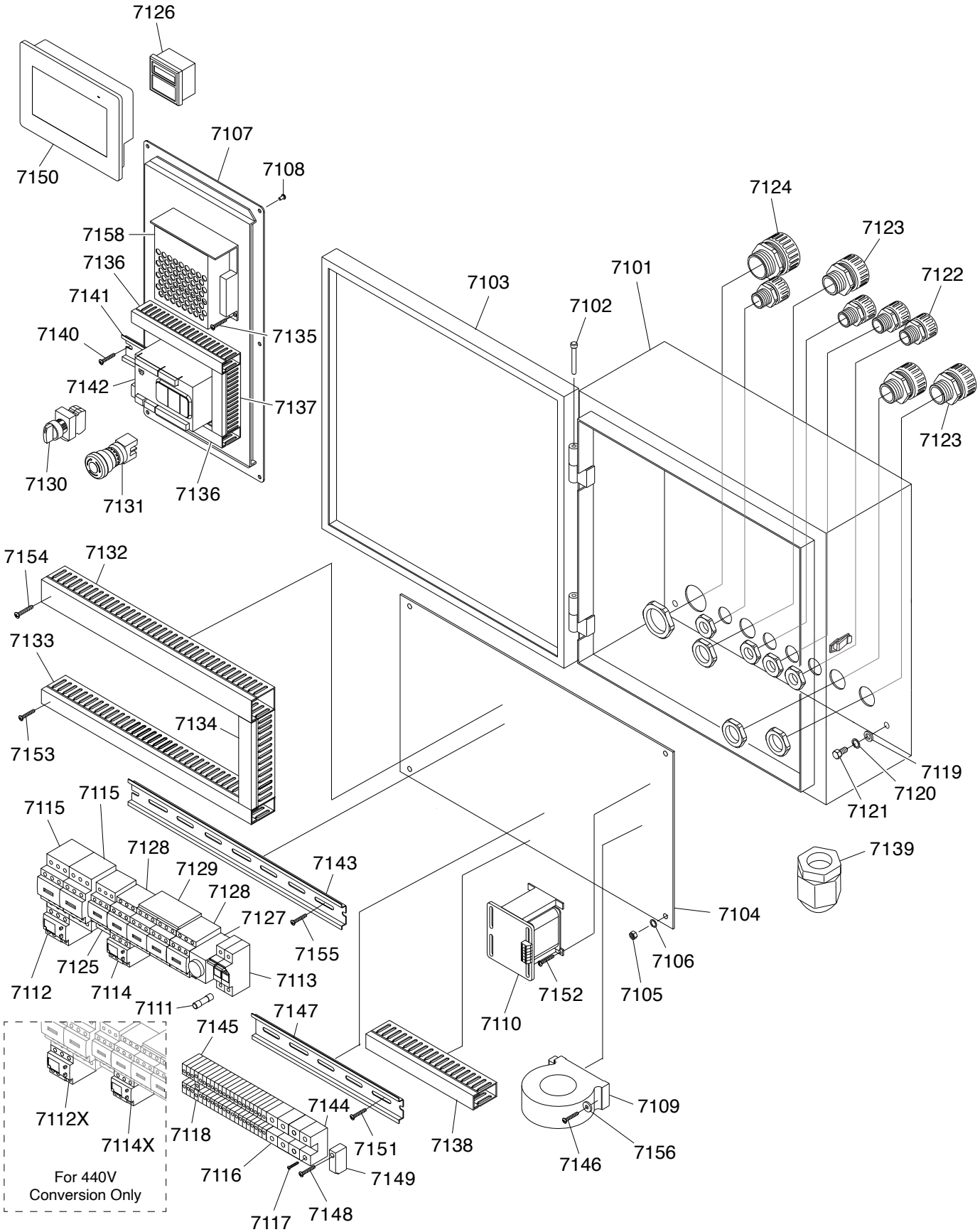
| REF | PART # | DESCRIPTION |
|---|---|---|
| 7101 | P04087101 | ELECTRICAL CABINET |
| 7102 | P04087102 | HEADED PIN 8 X 55MM (G0408) |
| 7102 | P04097102 | HEADED PIN 8 X 65MM (G0409) |
| 7103 | P04087103 | ELECTRICAL CABINET DOOR |
| 7104 | P04087104 | CABINET MOUNTING PLATE |
| 7105 | P04087105 | 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 |

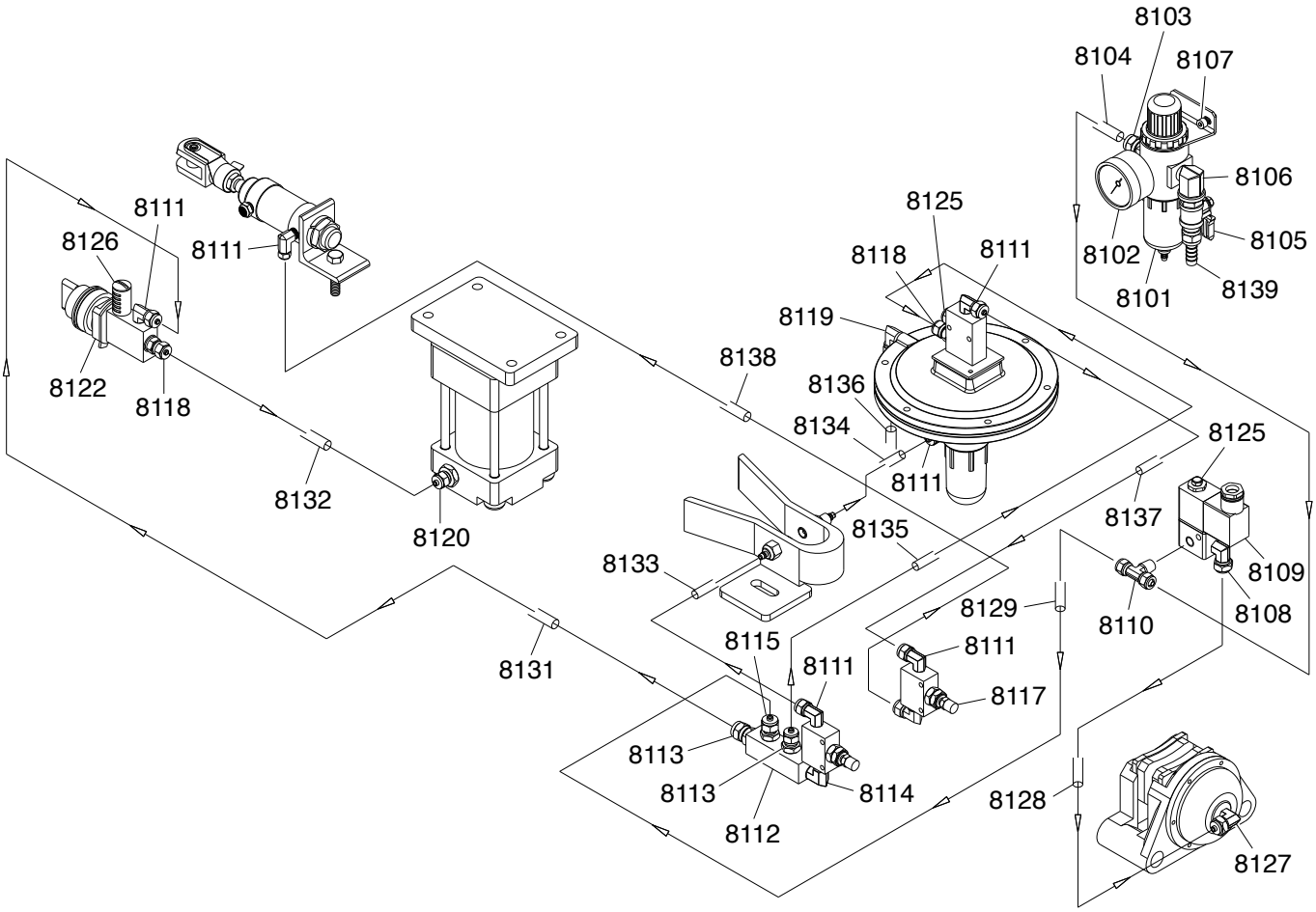




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# G0408/G0409 Pneumatic System



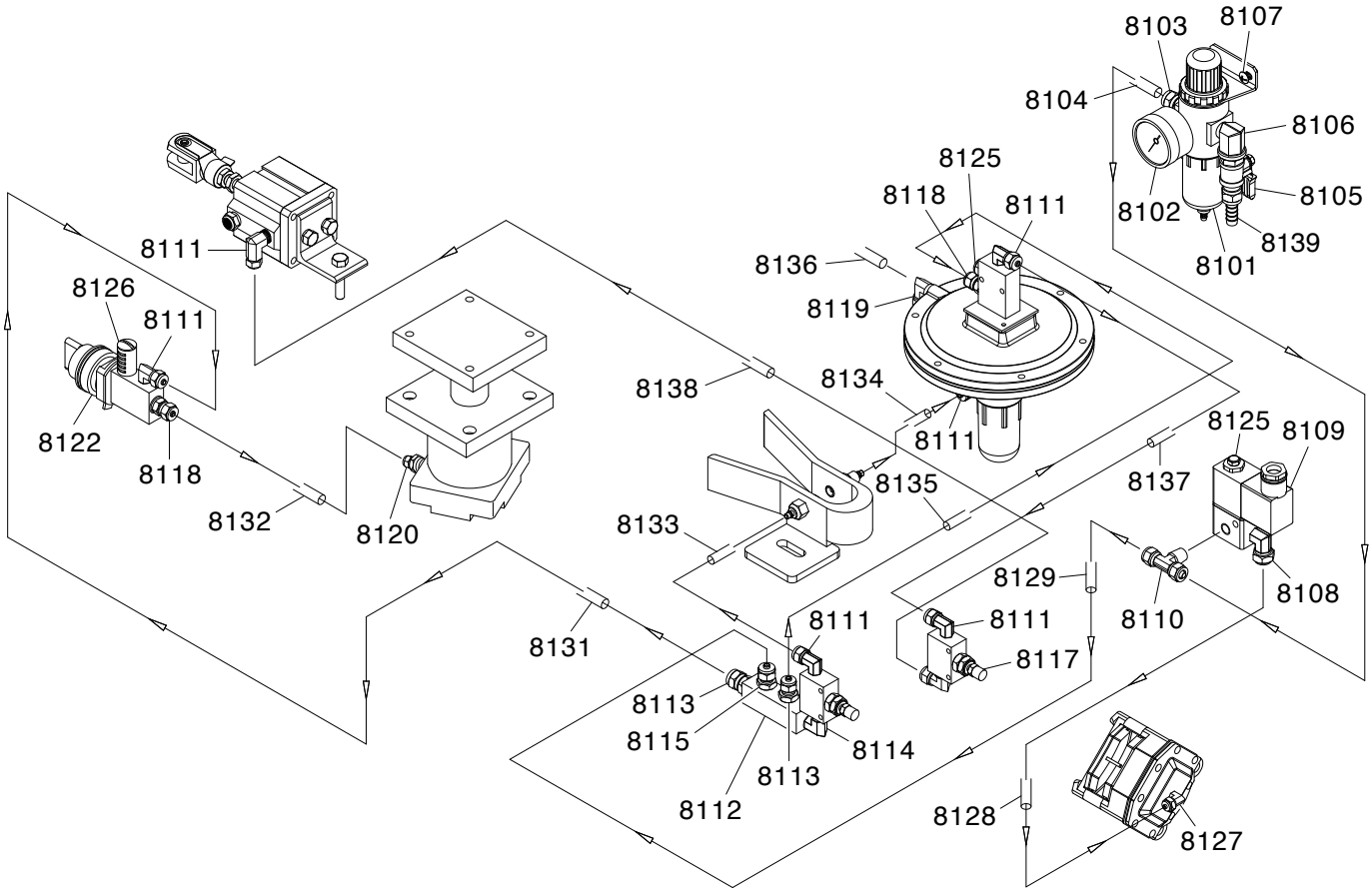

| REF | PART # | DESCRIPTION |
|---|---|---|
| 8101 | P04088101 | REGULATOR FILTER |
| 8102 | P04088102 | PRESSURE REGULATOR |
| 8103 | P04088103 | PIPE-HOSE ADAPTER 1/4 NPT X 8MM |
| 8104 | P04088104 | FLEXIBLE HOSE 8 X 1180MM |
| 8105 | P04088105 | BALL VALVE 1/4 NPT |
| 8106 | P04088106 | PIPE FITTING 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



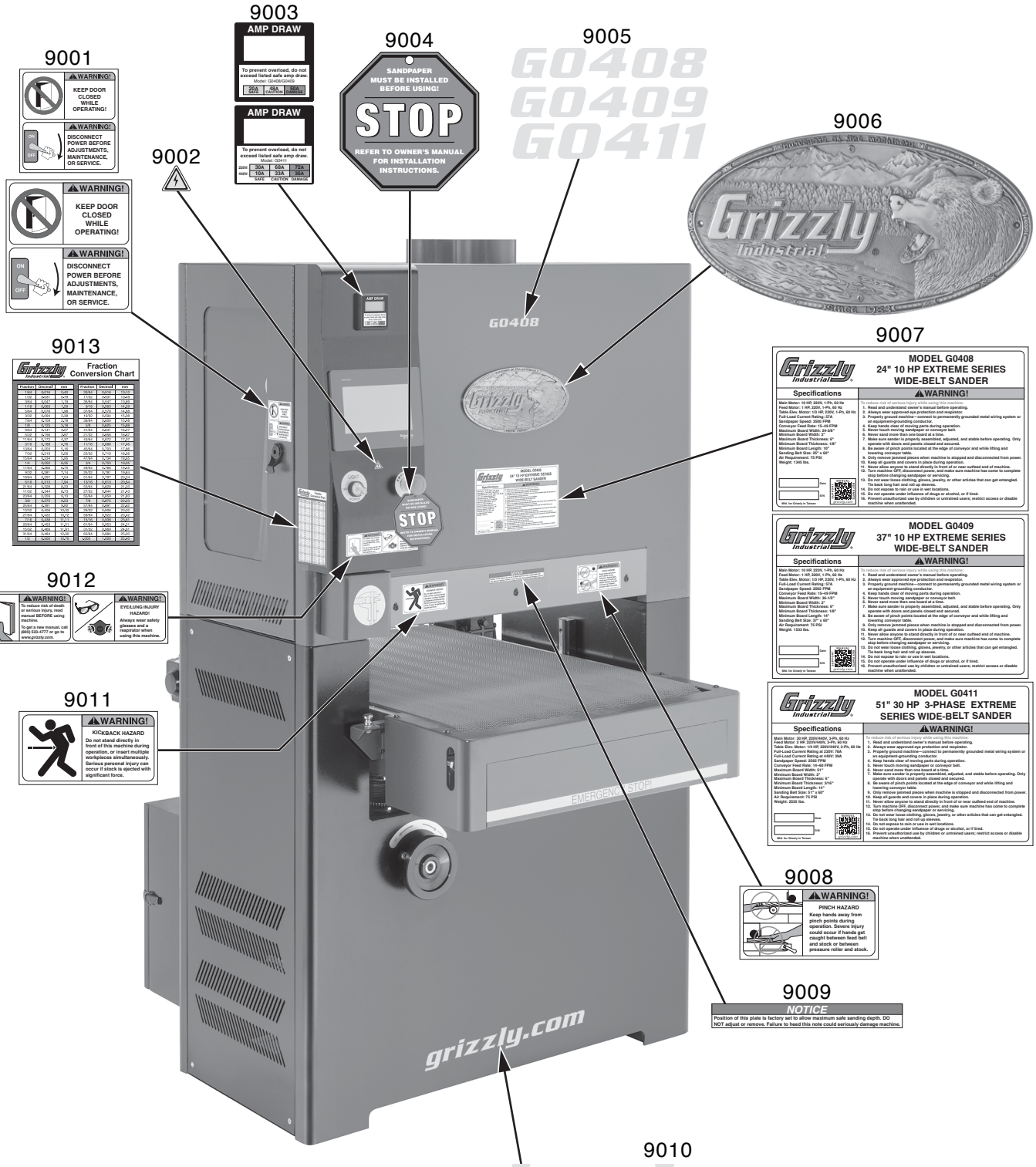

| REF | PART # | DESCRIPTION |
|---|---|---|
| 8101 | P04118101 | REGULATOR FILTER |
| 8102 | P04118102 | PRESSURE REGULATOR |
| 8103 | P04118103 | PIPE-HOSE ADAPTER 1/4 NPT X 8MM |
| 8104 | P04118104 | FLEXIBLE HOSE 8 X 1180MM |
| 8105 | P04118105 | BALL VALVE 1/4 NPT |
| 8106 | P04118106 | PIPE FITTING 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 |



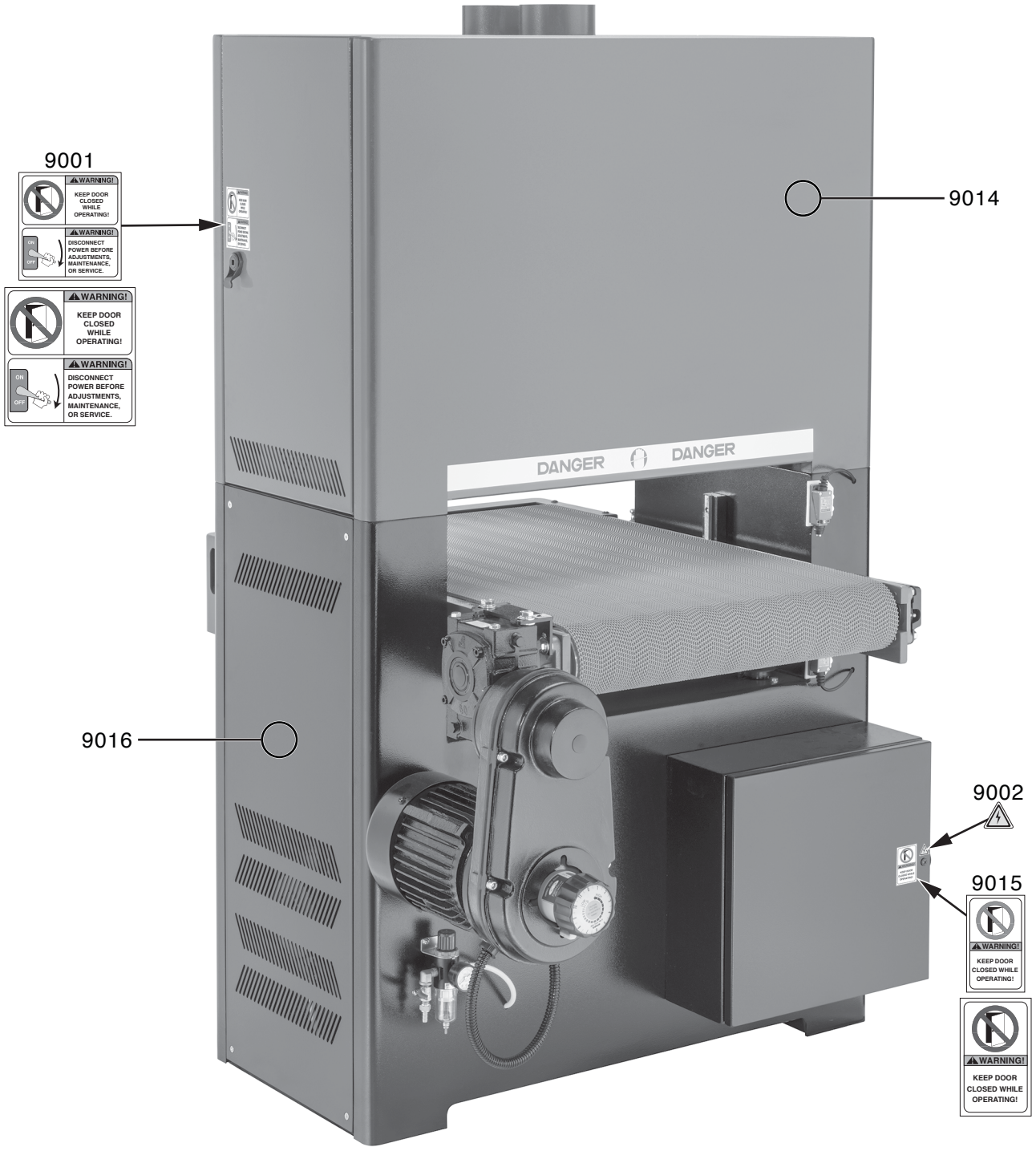
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# Labels & Cosmetics




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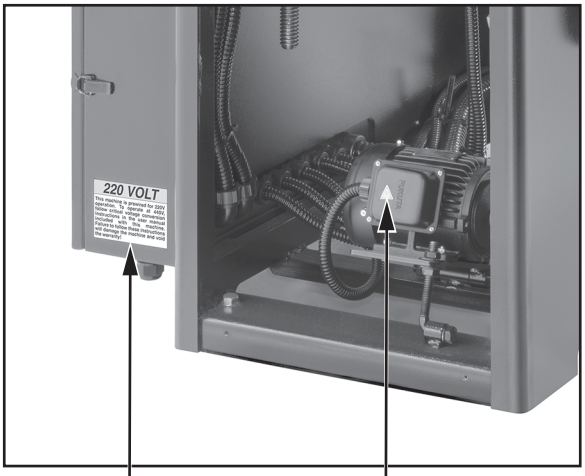
# Labels & Cosmetics (Cont.)






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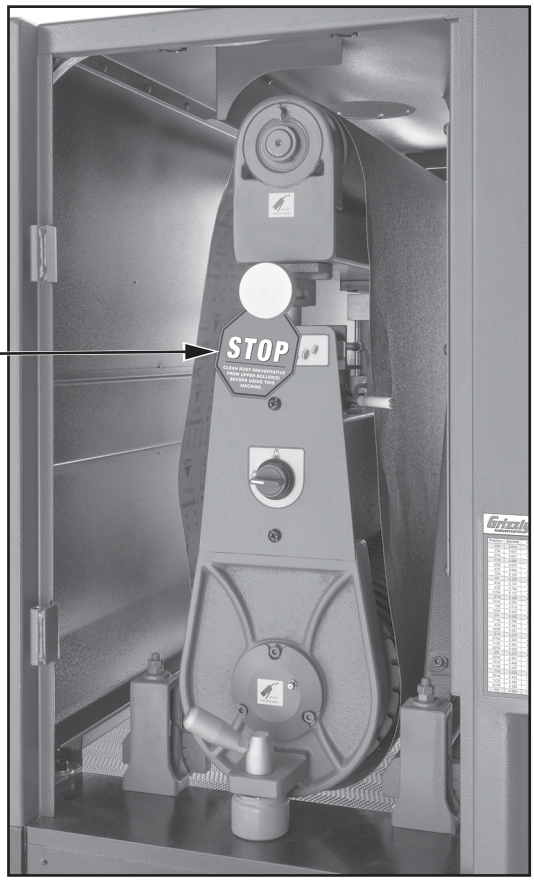
# Labels & Cosmetics (Cont.)







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.**



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# 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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