MODEL G0415/G0416
15"/20" OPEN-END
WIDE-BELT SANDER
OWNER'S MANUAL
(For models manufactured since 03/26)

C US
175370

#RO23814 PRINTED IN TAIWAN V1.03.26

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

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

INTRODUCTION

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

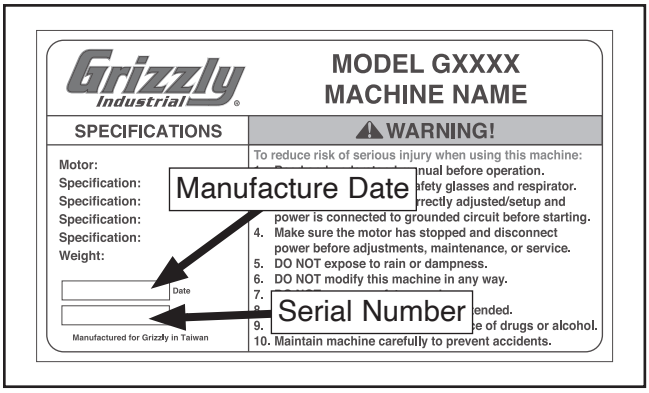
Manual Accuracy

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

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

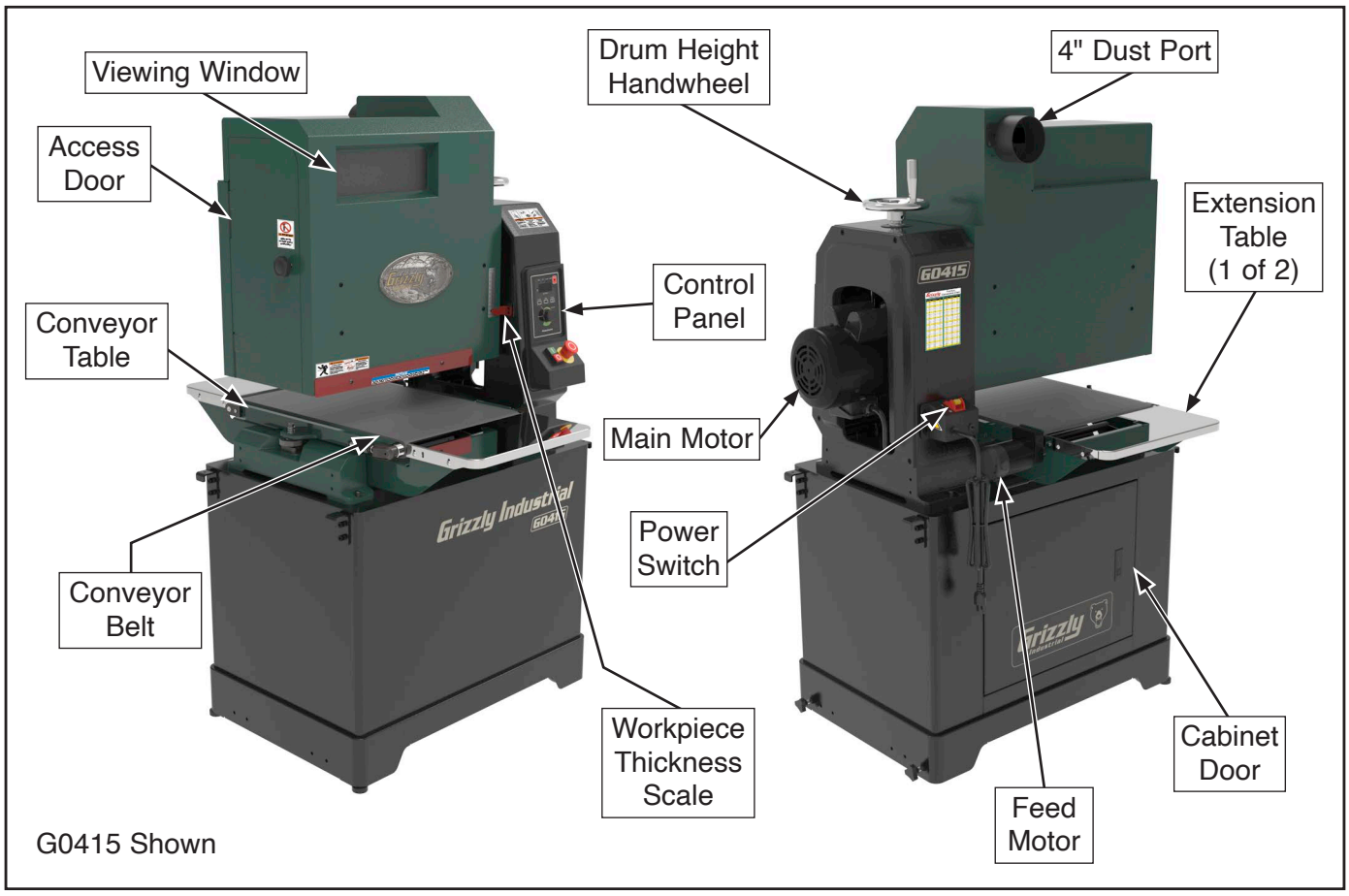
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

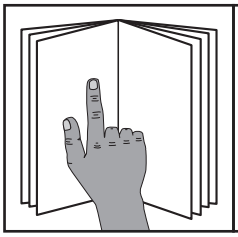
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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



Identification

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



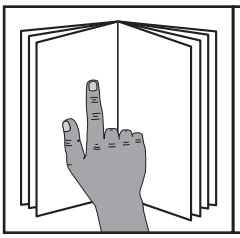


⚠WARNING

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

Controls & Components

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



⚠WARNING

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

Control Panel

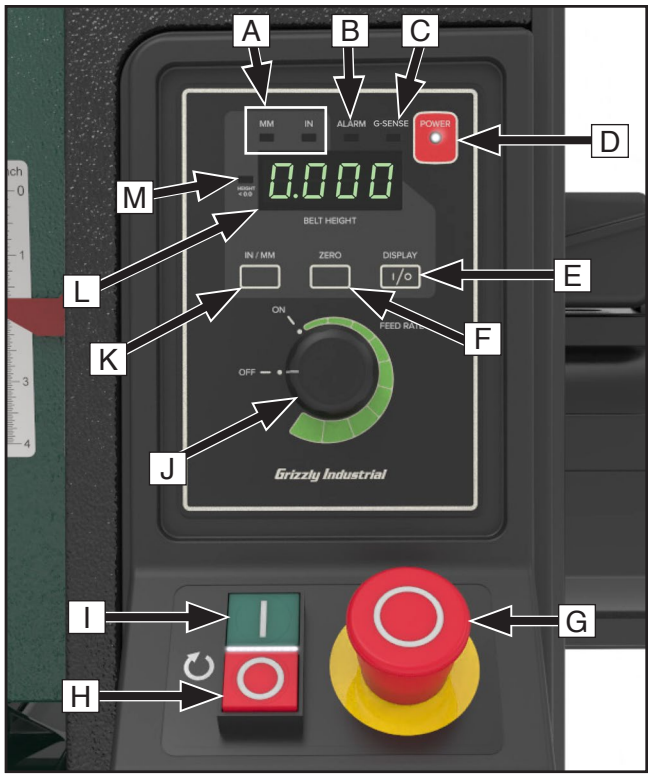


Figure 1. Control panel components.

A. MM/IN Indicators: Illuminate to indicate what measurement is being used on display screen.

B. ALARM Indicator: Illuminates when error occurs. See display screen for error type.

C. G-SENSE Indicator: Illuminates when machine has detected high amperage and has automatically adjusted feed rate to prevent overload.

D. POWER Indicator: Illuminates when machine is connected to power.

E. DISPLAY ON/OFF Button: Turns display ***ON*** or ***OFF*** when pressed.

F. ZERO Button: Resets digital display readout to 0 at current drum height when held for two seconds.

G. Emergency Stop Button: Turns all machine functions ***OFF*** when pressed. Pull out to reset. Alarm indicator will illuminate and error code "Enn9" will display when pressed.

H. Sanding Belt Stop Button: Turns main motor ***OFF*** when pressed.

I. Sanding Belt Start Button: Turns main motor ***ON*** when pressed.

J. Feed Rate Dial: Turns feed motor ***ON*** or ***OFF*** and adjusts conveyor belt speed. Turn dial clockwise to increase feed rate; turn dial counterclockwise to decrease feed rate.

K. IN/MM Button: Toggles display value between inch or millimeter measurements.

L. Display Screen: Displays current sanding depth, or distance between two sanding depths. Screen will also display machine voltage upon startup and specify error type when machine error occurs.

M. Negative Indicator: Illuminates when drum has been adjusted lower than current zero height setting.

Table & Hood

Figure 2. Table and hood components.

N. Viewing Window: Allows user to view sanding belt during use. Machine interior illuminated with LED.

O. Drum Height Handwheel: Raises and lowers sanding drum. Rotate clockwise to lower drum; rotate counterclockwise to raise drum. One full rotation moves drum approximately 1/16".

P. Workpiece Thickness Scale: Indicates approximate distance between sanding drum and conveyor belt (i.e., workpiece thickness).

Q. Extension Table (1 of 2): Supports large workpieces as they pass under sanding drum.

R. Conveyor Belt: Feeds workpiece across conveyor table during sanding operations.

S. Conveyor Table: Supports workpiece during operation.

Belt Oscillation & Tracking

Figure 3. Oscillation and tracking components.

T. Upper Drum: Oscillates sanding belt from left to right. Error code "OSC1," "OSC2," or "OSC3" will display if oscillation sensor is malfunctioning.

U. Sanding Belt Tension Lever: Rotate counterclockwise to remove belt tension, and clockwise to tension.

V. Sanding Drum: Rotates sandpaper against workpiece.

Power Switch

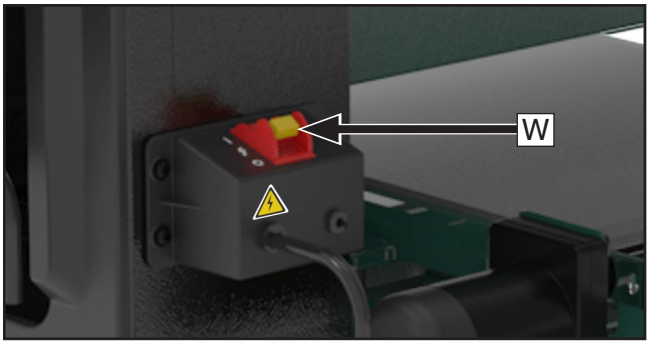


Figure 4. Power switch.

W. Power Switch w/Disabling Key: Turns incoming power ***ON*** or ***OFF***. Removal of key disables switch so machine cannot start.

MACHINE DATA SHEET

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

MODEL G0415 15" 1-3/4 HP OPEN-END WIDE-BELT SANDER

Product Dimensions:

Weight	440 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	39 x 40 x 60 in.
Footprint (Length x Width)	34 x 22 in.

Shipping Dimensions:

Type	Wooden Crate
Content	Machine
Weight	540 lbs.
Length x Width x Height	44 x 28 x 64 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	115V, Single-Phase, 60 Hz
Full-Load Current Rating	14.9A
Minimum Circuit Size	20A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	72 in.
Power Cord Gauge	14 AWG
Plug Included	Yes
Included Plug Type	5-15
Switch Type	ON/OFF Push Buttons

Motors:

Main

Horsepower	1-3/4 HP
Phase	Single-Phase
Amps	14A
Speed	1720 RPM
Type	TEFC Capacitor-Start Induction
Power Transfer	Direct
Bearings	Sealed & Permanently Lubricated
Centrifugal Switch/Contacts Type	External

Oscillating

Horsepower	25W
Phase	Single-Phase
Amps	0.45A
Speed	47 RPM
Type	Universal (DC)
Power Transfer	Gear
Bearings	Sealed & Permanently Lubricated

Feed

Horsepower	25W
Phase	Single-Phase
Amps	0.45A
Speed	47 RPM
Type	Universal (DC)
Power Transfer	Gear
Bearings	Sealed & Permanently Lubricated

Main Specifications:

Operation Information

Number of Sanding Heads	1
Maximum Board Width	15 in.
Minimum Board Width	2 in.
Maximum Board Thickness	4 in.
Minimum Board Thickness	1/16 in.
Minimum Board Length	8 in.
Sandpaper Speed	2800 FPM
Sanding Belt Oscillations per Minute	20 OPM
Sanding Belt Oscillation Stroke Length	5/8 in.
Conveyor Feed Rate	0 - 10 FPM
Sandpaper Length	48 in.
Sandpaper Width	15 in.

Drum Information

Infeed Sanding Drum Type	Aluminum
Infeed Sanding Drum Size	6 in.

Construction

Conveyor Belt	Rubber
Body	Steel
Base	Cast Iron
Paint Type/Finish	Powder Coated

Other Related Information

Floor To Table Height	31-1/2 in.
Belt Tracking	Universal (DC) Motor
Sanding Belt Tension	Spring-Loaded
Number of Pressure Rollers	2
Pressure Roller Type	Steel
Pressure Roller Size	3/4 in.
Conveyor Table Length	23-1/2 in.
Conveyor Belt Length	47 in.
Conveyor Belt Width	15 in.
Belt Roller Size	1-1/8 in.
Number of Dust Ports	1
Dust Port Size	4 in.
Mobile Base	Built-In

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Min.
Serial Number Location	Machine ID Label
Sound Rating	85 dB
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

MACHINE DATA SHEET

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

MODEL G0416 20" 3 HP OPEN-END WIDE-BELT SANDER

Product Dimensions:

Weight	547 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	43 x 40 x 60 in.
Footprint (Length x Width)	37-1/2 x 22 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	660 lbs.
Length x Width x Height	46 x 33 x 66 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	230V, Single-Phase, 60 Hz
Full-Load Current Rating	13.25A
Minimum Circuit Size	15A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	72 in.
Power Cord Gauge	14 AWG
Plug Included	Yes
Included Plug Type	6-15
Switch Type	ON/OFF Push Buttons

Motors:

Main

Horsepower	3 HP
Phase	Single-Phase
Amps	12.5A
Speed	1720 RPM
Type	TEFC Induction Capacitor-Start
Power Transfer	Direct
Bearings	Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type	External

Feed

Horsepower	65W
Phase	Single-Phase
Amps	0.48A
Speed	1800 RPM
Type	Universal (DC)
Power Transfer	Gear
Bearings	Shielded & Permanently Lubricated

Oscillating

Horsepower	25W
Phase	Single-Phase
Amps	0.27A
Speed	44 RPM
Type	Universal (DC)
Power Transfer	Gear
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Number of Sanding Heads	1
Maximum Board Width	20 in.
Minimum Board Width	2 in.
Maximum Board Thickness	4 in.
Minimum Board Thickness	1/16 in.
Minimum Board Length	8 in.
Sandpaper Speed	2800 FPM
Sanding Belt Oscillations per Minute	20 OPM
Sanding Belt Oscillation Stroke Length	5/8 in.
Conveyor Feed Rate	0 - 20 FPM
Sandpaper Length	48 in.
Sandpaper Width	21 in.

Drum Information

Infeed Sanding Drum Type	Aluminum
Infeed Sanding Drum Size	6 in.

Construction

Conveyor Belt	Rubber
Body	Steel
Base	Cast Iron
Paint Type/Finish	Powder Coated

Other Related Information

Floor To Table Height	31-1/2 in.
Belt Tracking	Universal (DC) Motor
Sanding Belt Tension	Spring Loaded
Number of Pressure Rollers	2
Pressure Roller Type	Steel
Pressure Roller Size	3/4 in.
Conveyor Table Length	21 in.
Conveyor Belt Length	48 in.
Conveyor Belt Width	20 in.
Belt Roller Size	1-1/8 in.
Number of Dust Ports	1
Dust Port Size	4 in.
Mobile Base	Built-In

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Min.
Serial Number Location	Machine ID Label
Sound Rating	85 dB
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	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.

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.

G0415.....14.9A
G0416.....13.25A

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.*

Grounding Requirements

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

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

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

⚠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.

G0415 Circuit Requirements

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

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 5-15

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

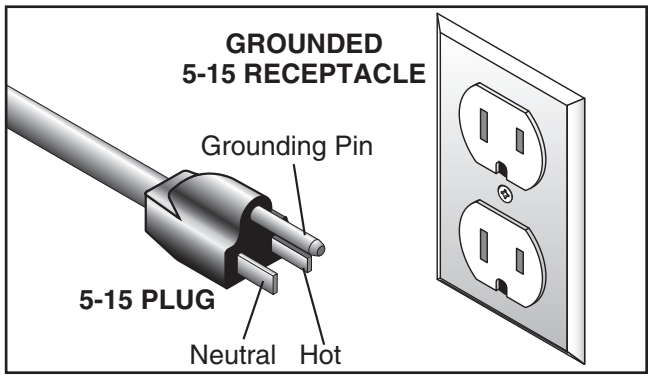
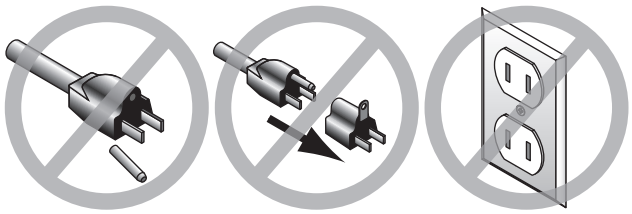


Figure 5. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

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

G0416 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 ..... 15 Amps
Plug/Receptacle ..... NEMA 6-15

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

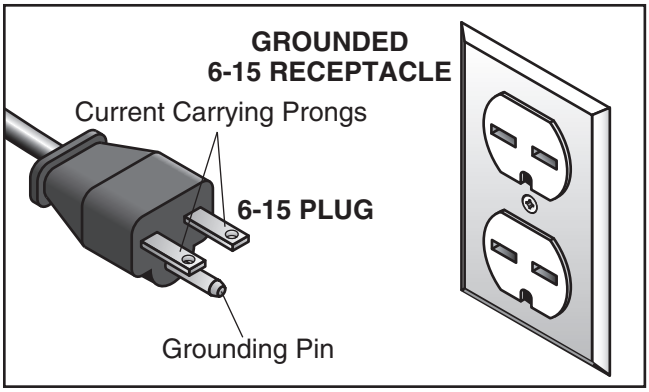
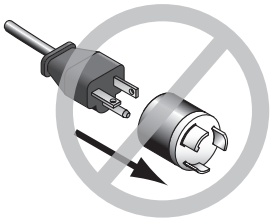


Figure 6. Typical 6-15 plug and receptacle.

⚠CAUTION



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

Extension Cords

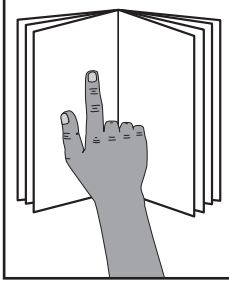
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

G0415 Minimum Gauge Size .....12 AWG
G0416 Minimum Gauge Size .....14 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

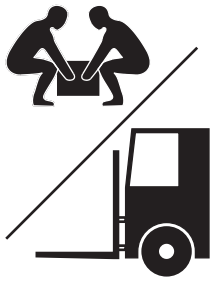


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Another Person	1
• Safety Glasses (For each person)	1
• Lifting Equipment (Rated for at least 850 lbs.)	1
• Wrench or Socket 13mm	1
• Phillips Head Screwdriver #2	1
• Hex Wrenches 4, 6mm	1 Ea.
• Straightedge 12"	1
• Dust Hose 4"	1
• Hose Clamps 4"	1
• Dust Collection System	1

Unpacking

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

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

Inventory

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

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

NOTICE

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

Inventory (Figure 7–Figure 8)	Qty
A. Extension Tables	2
B. Left Table Brackets	2
C. Right Table Brackets	2
D. Cap Screws M8-1.25 x 20 w/Washers, (P0415189, P0415293, P0415292)	8
E. Button Head Cap Screws M6-1 x 10 (P0415251)	8

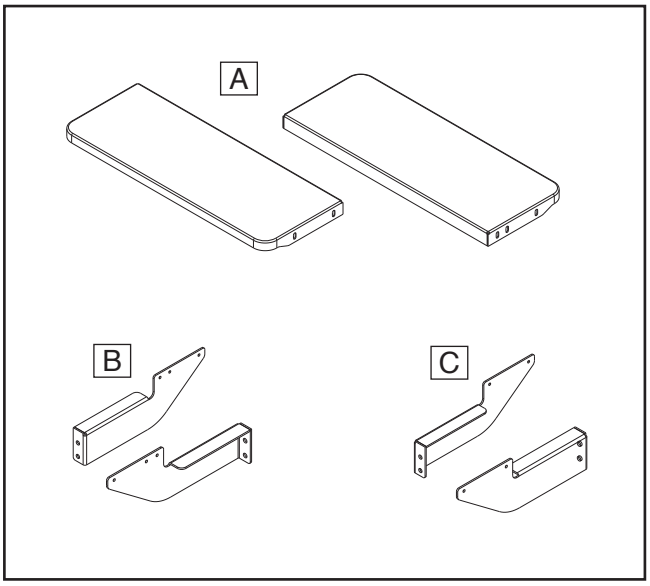


Figure 7. Loose item inventory.

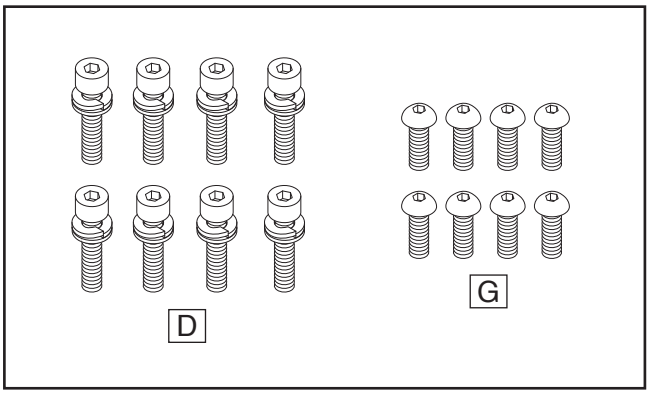


Figure 8. Loose fastener inventory.

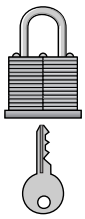
Site Considerations

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.

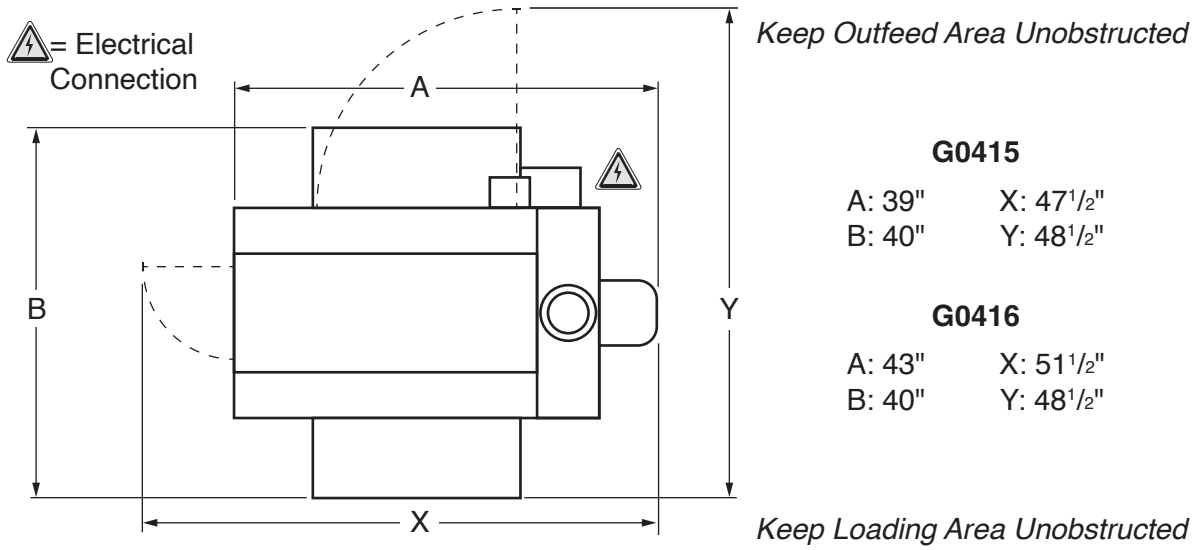
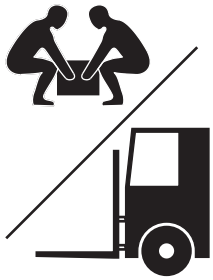


Figure 9. Machine clearances.

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 forklift or crane) or the necessary assistance from other people. Each piece of lifting equipment must be rated for at least 850 lbs. to support dynamic loads that may be applied while lifting. Refer to **Needed for Setup** on **Page 16** for complete list of needed equipment for setup and installation.

To lift and place machine:

1. Remove shipping crate top and sides, and remove shipping brackets holding machine to pallet.

2. Lift machine just enough to clear pallet, then move pallet out of the way, and gently lower machine onto floor.

   IMPORTANT: Only lift from base of machine (see **Figure 10**).

Figure 10. Location of machine lift points.

Assembly

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

To assemble machine:

1. Attach (1) left and (1) right table bracket to infeed end of conveyor base using (4) M8-1.25 x 20 cap screws w/washers (see **Figure 11**).

   Note: *Mounting tabs must face inward, as shown in* ***Figure 11****.*

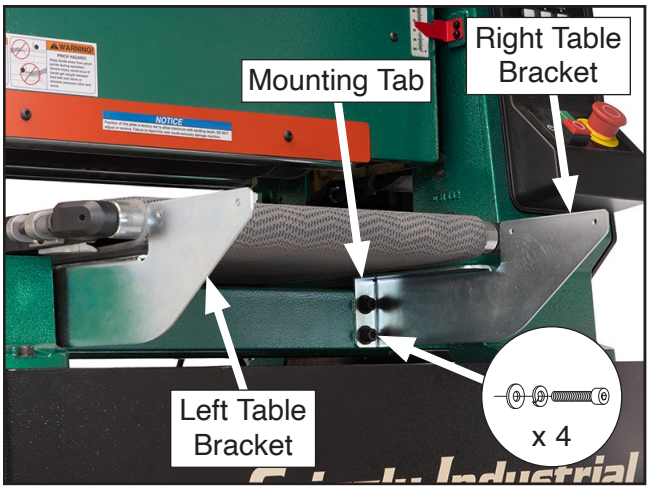


Figure 11. Table brackets attached to infeed end of conveyor base.

2. Place (1) extension table over table brackets, and secure with (4) M6-1 x 10 button head cap screws (see **Figure 12**).

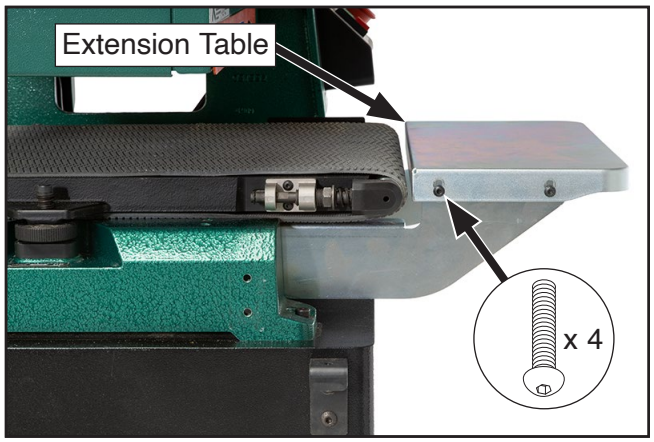


Figure 12. Front extension table attached to table brackets.

3. Place (1) extension table face down on flat, protected surface, then attach (1) left and (1) right table bracket using (4) M6-1 x 10 button head cap screws (see **Figure 13**).

Note: *Mounting tabs must face inward.*

Note: *Due to location of feed motor, extension table must be combined with brackets prior to attaching to machine.*

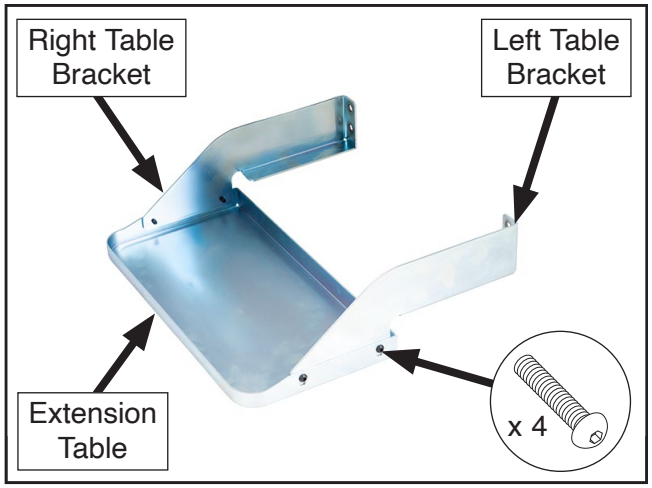


Figure 13. Table brackets attached to extension table.

4. Attach extension table assembly to outfeed end of conveyor base using (4) M8-1.25 x 20 cap screws w/washers (see **Figure 14**).

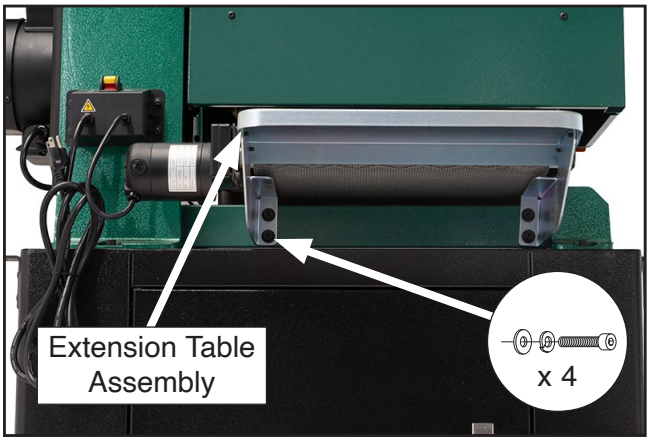


Figure 14. Extension table assembly attached to outfeed end of conveyor base.

5. Check each extension table for alignment with conveyor table (see **Figure 15**).

   — If straightedge is flat against conveyor table and extension table, no adjustment is required. Proceed to **Step 7**.

   — If straightedge is *not* flat against conveyor table and extension table, proceed to **Step 6**.

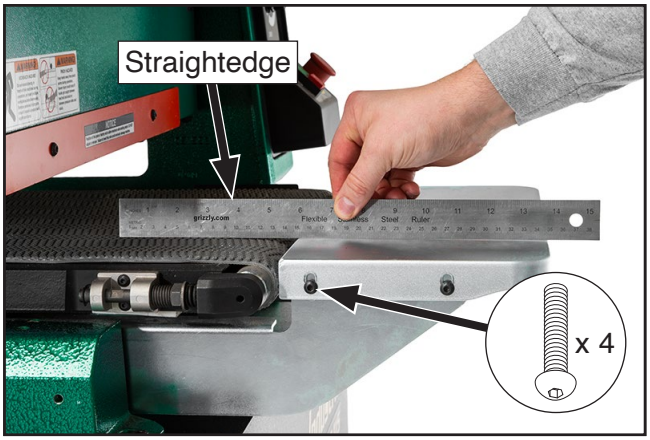


Figure 15. Checking extension table alignment.

6. For extension table(s) not aligned to conveyor table, loosen table button head cap screws (see **Figure 15**). Adjust table until it is aligned with conveyor table, then tighten screws to secure.

7. Twist adjustable feet counterclockwise (from above) to raise them off floor (see **Figure 16**).

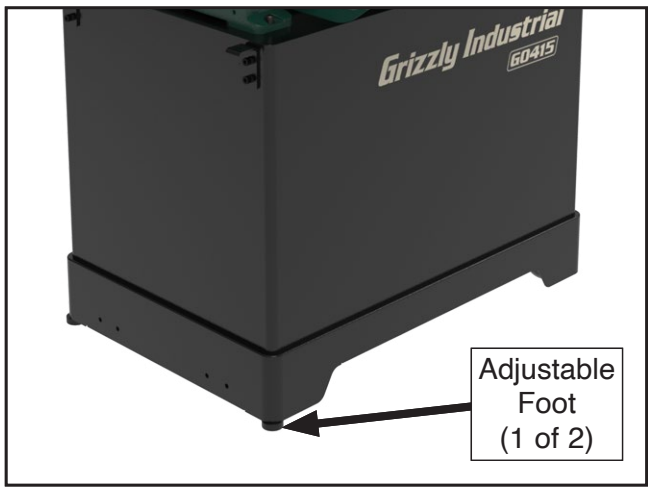


Figure 16. Location of adjustable feet.

8. Loosen caster lock knobs (see **Figure 17**) to unlock casters.

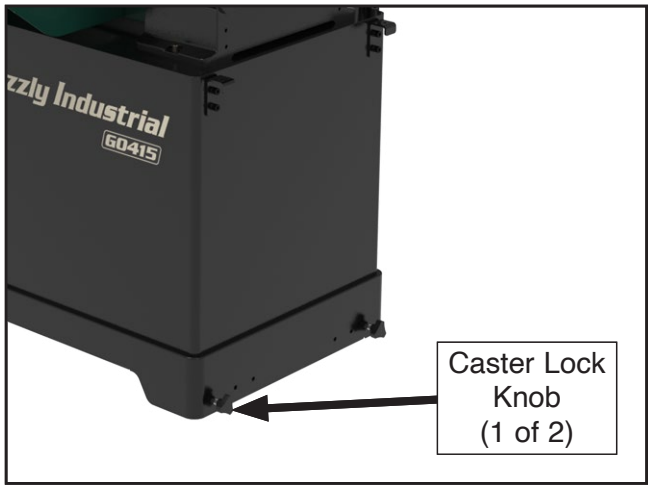


Figure 17. Location of caster lock knobs.

9. Move machine to desired location.

10. Tighten caster lock knobs and turn adjustable feet clockwise (from above) until they contact floor to secure machine.

Dust Collection

⚠ CAUTION

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

Minimum CFM at Dust Port: 400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect dust collection system to machine:

1. Fit 4" dust hose over dust port, as shown in **Figure 18**, and secure with a hose clamp.

Figure 18. Dust hose attached to dust port.

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

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

Test Run

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

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

The Test Run consists of verifying the following: 1) The motors power up and run correctly, 2) the Emergency Stop button safety feature works correctly, and 3) the switch disabling key disables the switch properly.

WARNING

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

WARNING

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

NOTICE

Do not turn power *OFF* before sanding belt stops completely. This will cause sanding belt misalignment.

To test run machine:

1. Clear all setup tools away from machine.

2. Press Emergency Stop button and rotate feed rate dial counterclockwise to OFF position (see **Figure 19**).

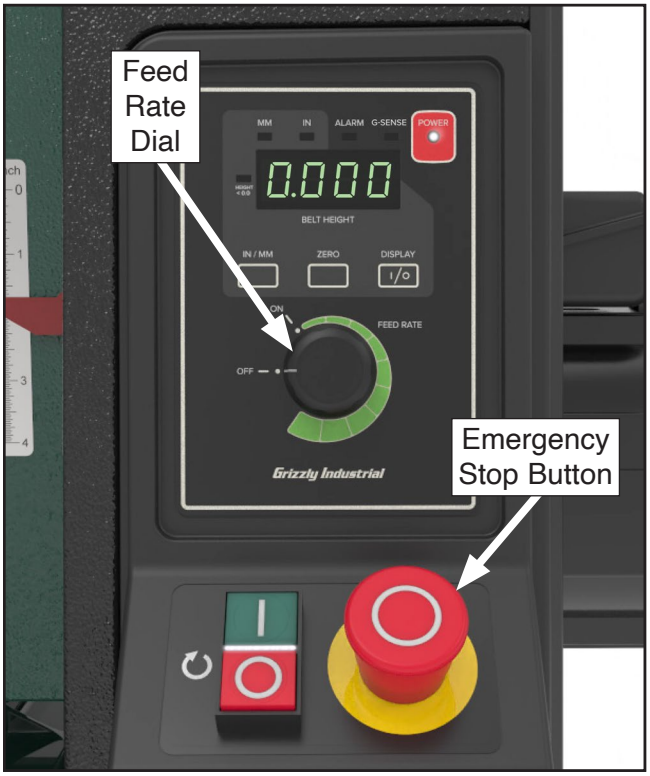


Figure 19. Control panel.

3. Connect machine to power by inserting power cord plug into a matching receptacle.

4. Pull Emergency Stop button out. This resets switch so machine can start.

5. Move power switch to ON position (see **Figure 20**). Drums will rotate once, power indicator will illuminate, and control panel will display machine-specific voltage code.

   — If machine does not complete these start-up procedures, turn machine ***OFF*** and disconnect it from power. Consult the troubleshooting table or contact Tech Support before proceeding.

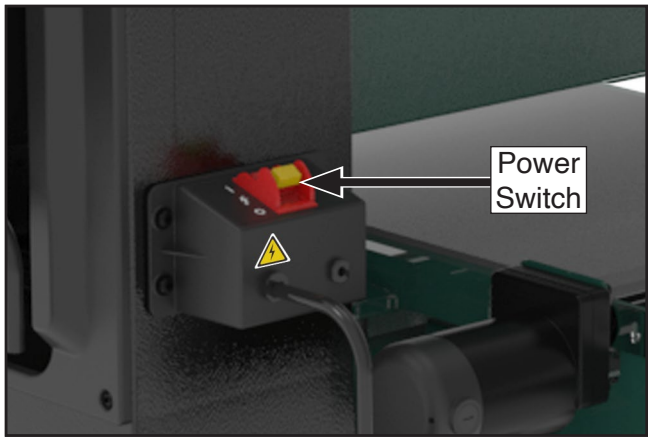


Figure 20. Location of power switch.

6. Press sanding belt start button to turn main motor ***ON*** (see **Figure 21**). Sanding belt power indicator will illuminate and display will show "On." Verify main motor and oscillating motor start up and run smoothly without any unusual problems or noises.

Figure 21. Control panel.

7. Verify feed motor operation by slowly turning feed rate dial clockwise. Rotate dial back and forth to test variable-speed function.

8. Press Emergency Stop button to turn machine ***OFF*** (see **Figure 21**).

9. Turn speed dial to OFF position.

10. WITHOUT resetting Emergency Stop button, try to start machine by pressing sanding belt start button. Machine should not start.

    — If machine *does not* start, safety feature of Emergency Stop button is working correctly. Proceed to **Step 11**.

    — If machine *does* start, immediately turn it ***OFF*** and disconnect power. Safety feature of Emergency Stop button is NOT working properly. This must be fixed before using machine. Call Tech Support for help.

11. Reset Emergency Stop button.

12. Move power switch to OFF position, then remove switch disabling key, as shown in **Figure 22**.

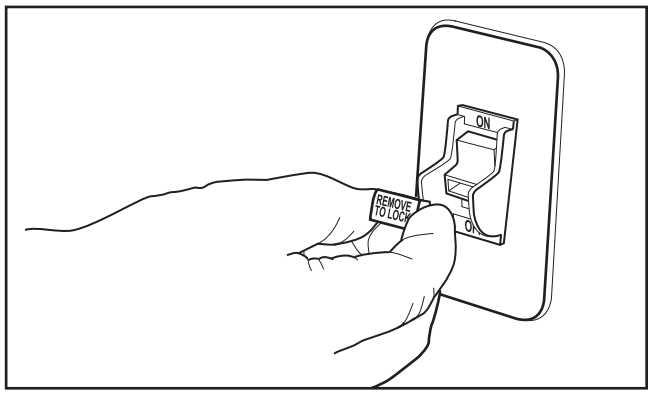


Figure 22. Removing disabling key from power switch.

13. Try to start machine with sanding belt start button and feed rate dial. Machine should not start.

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

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

Congratulations! The Test Run is complete.

Recommended Adjustments

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

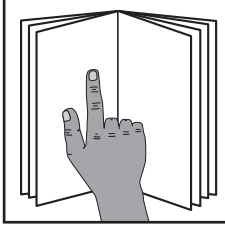
- Scale pointer calibration (see **Page 38**).
- Sanding depth calibration (see **Page 28**).
- Conveyor belt tension/tracking (see **Page 34**).
- Table alignment (see **Page 42**).
- Pressure roller adjustment (see **Page 40**).

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.

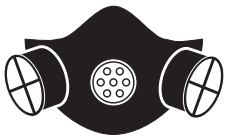


⚠WARNING

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 sanding operation, the operator does the following:

1. Examines workpiece to verify it is suitable for sanding and to determine which sanding belt grit size to start with.
2. Installs and tensions sanding belt.
3. Verifies workpiece will have necessary clearance and support. If workpiece is difficult to handle, operator uses a roller support stand to assist with feeding.
4. Adjusts drum height to approximate workpiece thickness.
5. Puts on required safety glasses and respirator.
6. Ensures dust collection system is connected to dust port, and starts dust collector.
7. Starts main motor, then feed motor.
8. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.
9. Receives workpiece from outfeed side of conveyor table. If workpiece is wider than conveyor table, operator rotates workpiece 180° and feeds workpiece back through sander.
10. Lowers drum ¼ to 1 full rotation of height handwheel, then repeats feeding process of workpiece through sander.
11. Disconnects machine from power, changes sandpaper to a finer grit, and connects to power to repeat sanding passes as needed.
12. Turns machine and dust collection system ***OFF,*** and disconnects machine from power.

Workpiece Inspection

Some workpieces are not safe to sand, or they 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, and laminate covered wood products. This machine is NOT designed to sand metal, glass, stone, tile, plastics, drywall, cementitious backer board, etc.

  Sanding improper materials increases the risk of respiratory harm to the operator and bystanders due to the especially fine dust inherently created by all types of sanding operations—even if a dust collector is used. Additionally, the life of the machine and sanding belts will be greatly reduced (or immediately damaged) from sanding improper materials or from exposure to the 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 the sanding belt. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT sand the workpiece.

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

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

- ***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 likely rock during sanding, which may result in the workpiece being ejected back toward the operator (i.e. kickback) with enough force to cause an impact injury.

Sanding Tips

- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.

- Only sand with as slow of feed speeds as necessary to meet your sanding goals. In other words, avoid running the sander faster than is necessary. Increasing feed speeds beyond the required level can decrease the quality of the finished product and the lifespan of sanding belts.

- As a general rule, use the sanding drum for the initial heavy sanding pass, then use a combination of the platen and drum for the intermediate pass, and the platen alone for the final sanding passes.

- 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 29**).

- When making multiple passes on the workpiece, avoid raising the conveyor table more than 0.015" 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 board touching the back end of the first board (aka "Butt Feeding").

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

- DO NOT sand boards less than 8" long, 2" wide, and 1/16" thick to prevent damage to the workpiece and the sander (see **Figure 23**).

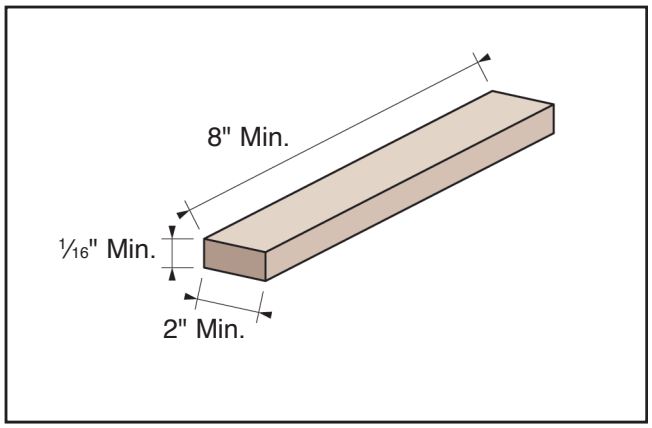


Figure 23. Minimum dimensions for sanding.

- Extend the life of the sandpaper by regularly cleaning the sanding belt (refer to **Cleaning Sanding Belt** on **Page 32**).

- DO NOT edge-sand boards. This can cause boards to kickback, causing serious personal injury, and cause damage to the conveyor belt and sanding belt.

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

Setting Depth of Cut

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

Generally, a ¼ turn of the drum height handwheel (1/64" or 0.4mm vertical movement) per pass is acceptable for coarser grits or softer woods. A ⅛ turn of the handwheel is recommended for finer grits or harder woods. However, use your best judgement to produce good sanding results for your operation.

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

The G-Sense function is a built in overload-prevention system. If the machine detects the current exceeding safe parameters, the machine will adjust the feed speed to lower amperage to acceptable levels, and the SENSE indicator light on the control panel will illuminate.

To set depth of cut:

1. Move power switch to ON position.

2. Rotate drum height handwheel (as shown in **Figure 24**) until sanding drum is well above conveyor table, then lower sanding drum, allowing a gap between workpiece and sanding drum.

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

Figure 24. Location of drum height handwheel.

3. Rotate feed rate dial clockwise to start feed table.

4. Press sanding belt start button to start sanding drum.

5. Feed workpiece into sander. SLOWLY lower sanding drum until workpiece makes light contact with sanding drum. This is correct height to begin sanding workpiece.

6. After initial pass, turn handwheel ¼ turn (1/64" or 0.4mm) or less; the maximum depth for most sanding conditions.

   Note: *Each full turn of drum height handwheel adjusts approximately 0.06" (1/16") or 1.6mm.*

Using Digital Display

The digital display offers a precise reading for drum height adjustments. Press the DISPLAY ON/OFF button to toggle display ***ON*** and ***OFF***, and the MM/IN button to the toggle between millimeters and inches (see **Figure 25**). Press the ZERO button (see **Figure 25**) to zero out the display at the current sanding height, then the display can be used to measure the distance between two depths. For instance, adjust the sanding drum down until it touches a workpiece, then zero the display so it will measure the precise depth of cut.

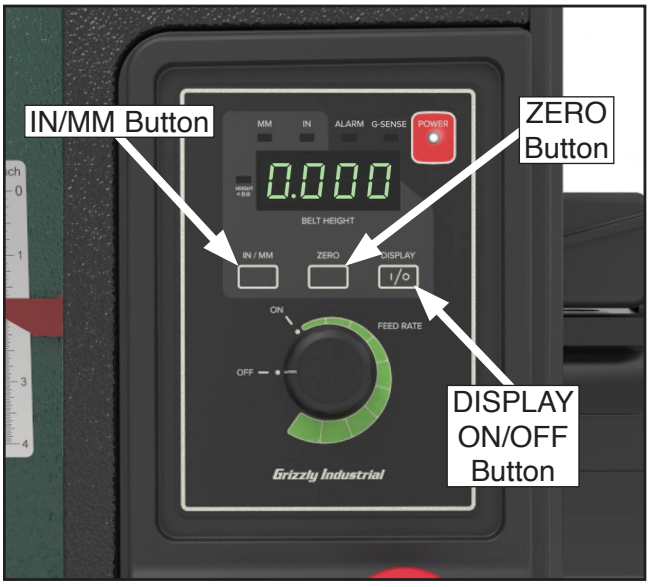


Figure 25. Digital display controls.

To calibrate the digital display so it shows the actual distance between the sanding drum and the table, install the desired sanding belt, ensure the sanding drum is turned ***OFF***, lower the sanding drum until it contacts the conveyor belt on the table, then hold the ZERO button for two seconds.

NOTICE

Raise sanding belt off conveyor table prior to turning the sanding drum on to prevent damage to conveyor belt and sanding belt.

Adjusting Conveyor Feed Rate

The conveyor feed rate dial (see **Figure 26**) allows you to adjust the feed rate from 0–10 FPM on the Model G0415, and 0–20 FPM on the Model G0416. The correct feed rate to use depends on the type of stock you are sanding (hardwood vs. softwood) and the stage of finish of the sandpaper.

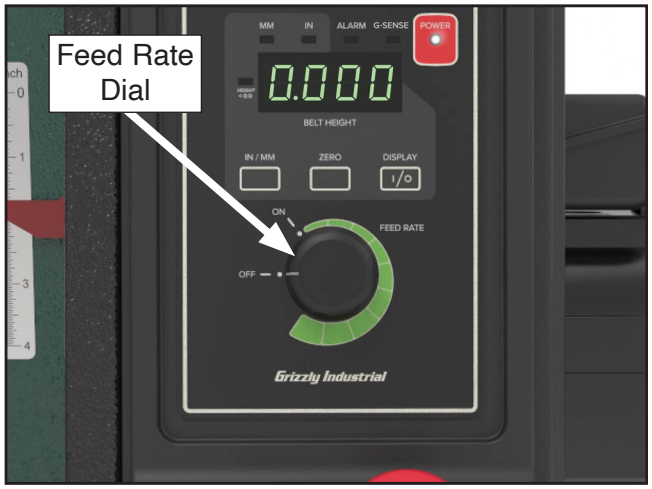


Figure 26. Location of feed rate dial.

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

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

The speed dial must be turned to the OFF position for the motor to start. If the speed dial has not been turned to the OFF position prior to startup, the alarm indicator will illuminate and error code "vr" will display on the DRO.

To adjust conveyor feed rate:

1. Rotate conveyor feed rate dial clockwise (see **Figure 26**) to start conveyor belt, then turn dial clockwise to increase feed rate or turn it counterclockwise to decrease feed rate. Turning dial all the way counterclockwise will turn conveyor motor ***OFF***.

Changing Sanding Belt

Machine	Required Belt Size
G0415	**15" x 48"**
G0416	**21" x 48"**

The Model G0415/G0416 only accepts sanding belts with the dimensions listed above. For additional sanding belt selections beyond those included with the machine, see the **Accessories** section, beginning on **Page 31.**

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

When choosing a sanding belt, 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 easily load up or burn workpieces.*

To change sanding belt:

1. DISCONNECT MACHINE FROM POWER!

2. Open access door.

3. Rotate sanding belt tension lever counter-clockwise to remove belt tension (shown in **Figure 27**), and remove existing belt.

4. Install sanding belt by starting on upper drum, then lower drum (see **Figure 27**).

NOTICE

Install sanding belt with directional arrows on sanding belt pointing in a counterclockwise direction. Failure to install sanding belt correctly could result in damage to sanding belt or machine itself.

5. Line up edge of sanding belt with left edge of drums so sanding belt edge is centered between tracking sensor LED screens shown in **Figure 27**.

   Note: *Damage to sanding belt and sander may occur if sander is turned **ON** before sanding belt is correctly positioned.*

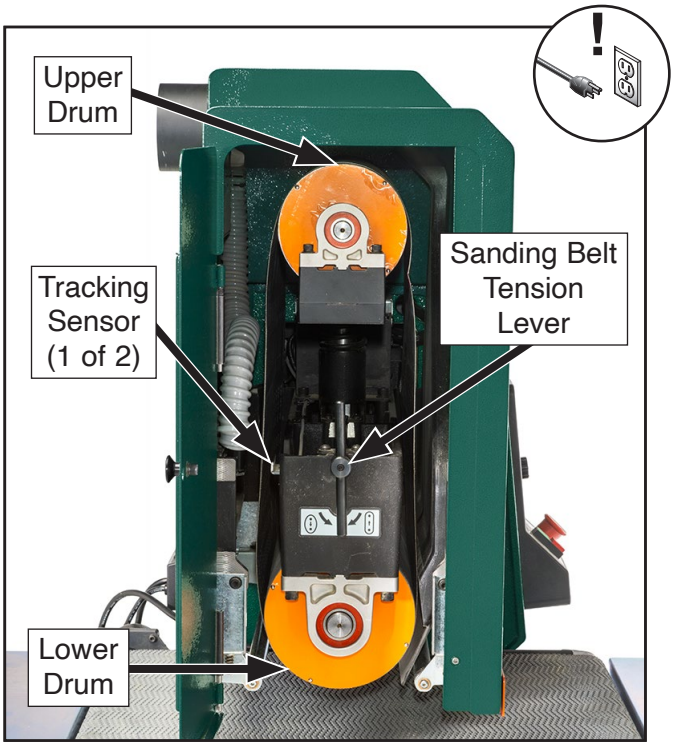


Figure 27. Location of drums, tension lever, and tracking sensors.

6. With hands clear of all moving parts, tension belt by rotating belt tension lever clockwise.

7. Close access door.

SECTION 5: ACCESSORIES

⚠WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

G0415 A/O Sanding Belts

T34707—60-Grit, X-Weight (3-Pk.)
T34708—80-Grit, X-Weight (3-Pk.)
T34709—100-Grit, X-Weight (3-Pk.)
T34710—120-Grit, X-Weight (3-Pk.)
T34711—150-Grit, X-Weight (3-Pk.)
T34712—180-Grit, X-Weight (3-Pk.)
T34713—220-Grit, X-Weight (3-Pk.)

These 15" × 48" sanding belts feature durable aluminum oxide grain on a heavy cloth backing, offering a reliable balance of cutting power, strength, and flexibility for wide-belt sanding from aggressive stock removal to final finishing.

Figure 28. Grizzly 15" x 48" sanding belt 5 pack.

G0416 A/O Sanding Belts

T34677—60-Grit, Y-Weight (3-Pk.)
T34678—80-Grit, Y-Weight (3-Pk.)
T34679—100-Grit, Y-Weight (3-Pk.)
T34680—120-Grit, Y-Weight (3-Pk.)
T34681—150-Grit, Y-Weight (3-Pk.)
T34682—Assorted Grit, Y-Weight (3-Pk.)

These 21" × 48" sanding belts feature durable aluminum oxide grain on a heavy cloth backing, offering a reliable balance of cutting power, strength, and flexibility for wide-belt sanding from aggressive stock removal to final finishing.

Figure 29. Grizzly 21" x 48" sanding belt 3 pack.

W1050—Dust Collection Basics Handbook
This inexpensive, 64-page book carefully guides you through setting up a quality dust collection system in your shop. Includes an easy-to-follow walk-through on designing the optimum dust collection system, and practical tips for minimizing cost and maximizing performance.

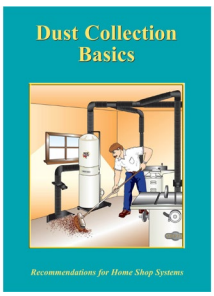
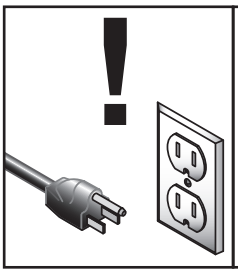


Figure 30. Dust Collection Basics Handbook.

SECTION 6: MAINTENANCE



⚠WARNING

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

Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

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

- Loose mounting bolts.
- Loaded/worn/damaged sanding belts.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance

- Lubricate conveyor and pressure roller bushings (**Page 33**).
- Lubricate drum elevation leadscrew and slots (**Page 34**).

Monthly Maintenance

- Clean/vacuum dust buildup from inside body/cabinet and off motors.

Cleaning

Cleaning the Model G0415/G0416 is relatively easy. Vacuum excess sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

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 Model D3003 PRO-STIK® Cleaning Pad, as shown in **Figure 31**.

Figure 31. Pro-Stik cleaning pad.

To clean sanding belt:

1. Set drum height 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.

Lubrication

Since all the bearings on the Model G0415/G0416 are sealed and permanently lubricated, simply leave them until they need to be replaced. DO NOT lubricate them.

The following section describes how to lubricate the components that require periodic lubrication. Do not over-lubricate these components. Large amounts of lubricant will attract sawdust, causing the metal components to gum up and bind.

Conveyor & Pressure Roller Bushings

Lubrication Type... T26685 or ISO 32 Equivalent
Lubrication Amount ..... 2-3 Drops
Frequency..... Weekly

Item Needed	Qty
Rag	1

T26419—Syn-O-Gen Synthetic Grease
Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water-resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.

Figure 32. Syn-O-Gen Synthetic Grease.

To lubricate conveyor and pressure roller bushings:

1. DISCONNECT MACHINE FROM POWER!
2. Open side door.
3. Add 2-3 drops of lubricant to conveyor and pressure roller bushings (see **Figure 33–Figure 34**).

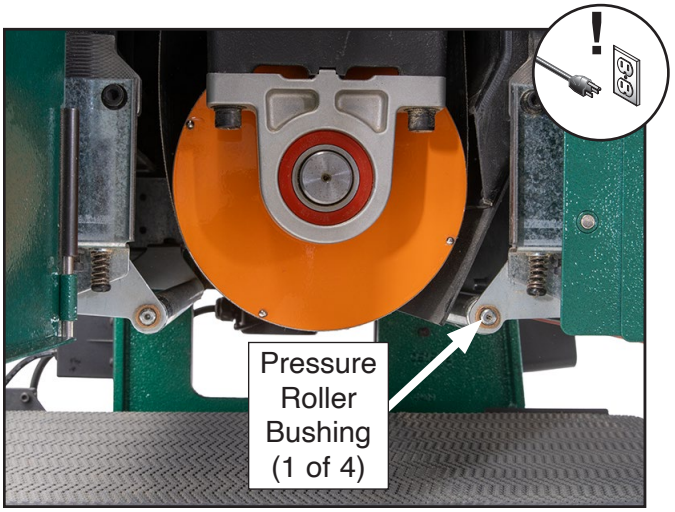


Figure 33. Location of pressure roller bushings.

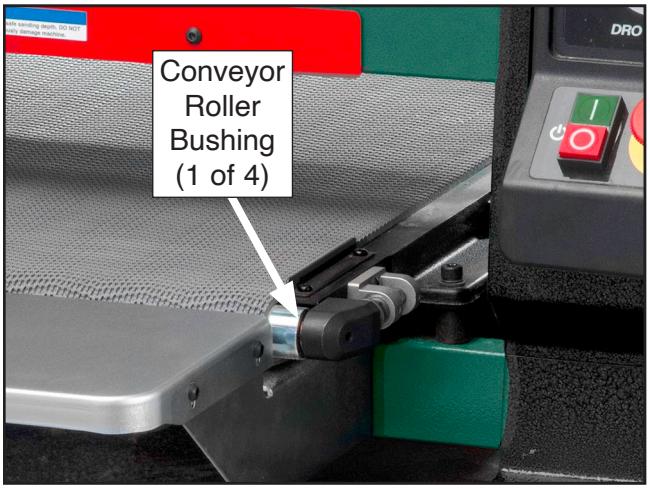


Figure 34. Location of conveyor roller bushings.

4. Close side door, then connect machine to power.
5. Start sanding belt and conveyor and let run or 30 seconds to distribute lubrication.

Drum Elevation Leadscrew & Slots

Lubrication Type .....T33964 or PTFE Dry Equiv.
Lubrication Amount .....Thin Coat
Frequency.....Weekly

Items Needed	Qty
Hex Wrench 4mm	1
Mineral Spirits	As Needed
Shop Rags	As Needed
Wire Brushes	2

T33964—Quest Micro-Dry PTFE Dry Lubricant & Release Agent

Micro-Dry PTFE Dry Lubricant & Release Agent is a no mess, non-staining dry lubricant. This lubricant has excellent anti-stick properties for effective lubrication of the G0415–G0416 leadscrew.

Figure 35. Quest Micro-Dry PTFE dry lubricant.

To lubricate drum elevation leadscrew and slots:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (4) M6-1 x 8 button head cap screws from right access panel and set panel aside (see **Figure 36**).

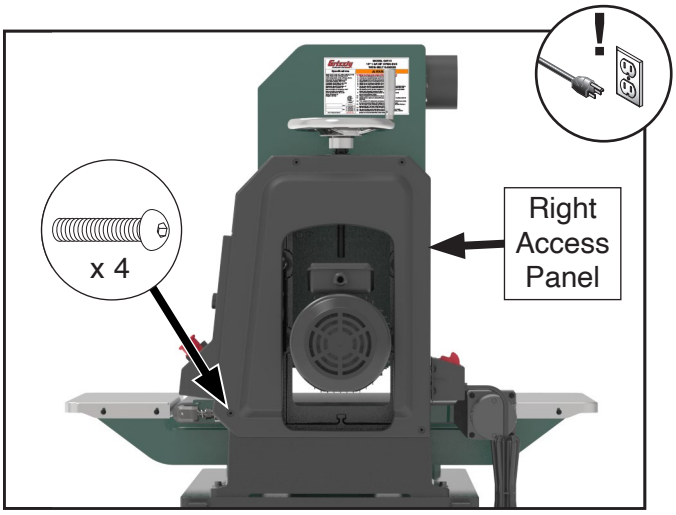


Figure 36. Location of right access panel and fasteners.

3. Thoroughly clean elevation leadscrew and (4) guide slots (see **Figure 37**).

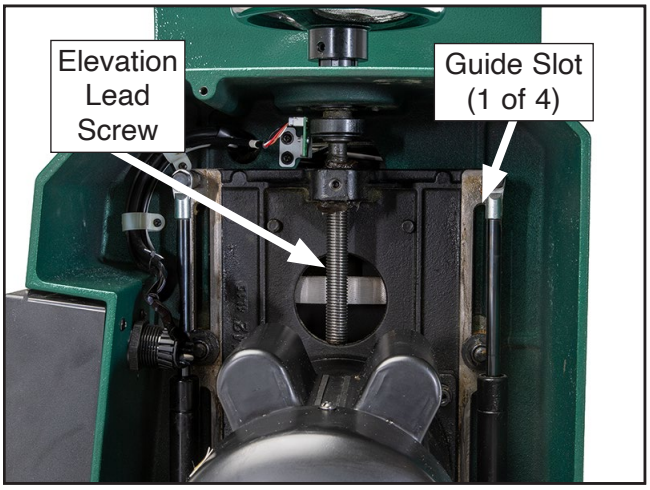


Figure 37. Location of guide slots and elevation leadscrew.

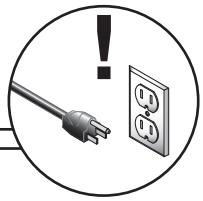
4. Apply a thin coat of dry lubricant to leadscrew and guide slots.

5. Install right access panel, then adjust drum up and down to distribute lubrication along leadscrew and guide slots.

SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Power switch in OFF position. 2. Emergency Stop button pressed. 3. Incorrect power supply voltage or circuit size. 4. Power supply circuit breaker tripped or fuse blown. 5. Centrifugal switch needs adjustment/contact points dirty. 6. Wiring broken, disconnected, or corroded. 7. Motor or motor bearings at fault.	1. Move power switch to ON position. 2. Pull Emergency Stop button out to reset. 3. Ensure correct power supply voltage and circuit size (**Page 16**). 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Adjust centrifugal switch/clean contact points. 6. Fix broken wires or disconnected/corroded connections (**Page 47**). 7 . Replace motor.
Main motor stalls or is underpowered.	1. Motor wires connected incorrectly. 2. Motor overheated. 3. Extension cord too long. 4. Centrifugal switch needs adjustment/contact points dirty. 5. Motor or motor bearings at fault.	1. Correct motor wiring connections (**Page 47**). 2. Clean motor, let cool, and reduce workload. 3. Move machine closer to power supply; use shorter extension cord. 4. Adjust centrifugal switch/clean contact points. 5. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor mount loose/broken. 3. Motor fan rubbing on cover. 4. Centrifugal switch needs adjustment. 5. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Tighten/replace. 3. Fix/replace fan cover; replace loose/damaged fan. 4. Adjust switch. 5. Replace motor.
LED does not illuminate.	1. Wiring broken, disconnected, or corroded.	1. Fix broken wires or disconnected/corroded connections (**Page 47**).
Digital readout does not work display is incorrect.	1. Sensor is not adjusted correctly. 2. Wiring broken, disconnected, or corroded.	1. Adjust position. 2. Fix broken wires or disconnected/corroded connections (**Page 47**).

Operation

Symptom	Possible Cause	Possible Solution
Machine slows or is underpowered; stops under load.	1. Workpiece material unsuitable for machine. 2. Machine undersized for task. 3. Too much pressure on pressure rollers.	1. Only sand wood/ensure moisture is below 20%. 2. Clean/replace sanding belt (**Page 32**); reduce feed rate (**Page 29**)/sanding depth (**Page 27**). 3. Reduce pressure roller pressure (**Page 40**).
Machine has vibration or noisy operation.	1. Mobile base lock knobs loose or stand feet not adjusted properly.	1. Tighten mobile base lock knobs or adjust stand feet to stabilize machine.
Burn marks on workpiece.	1. Using too fine of sanding grit for depth of cut. 2. Sanding belt loaded with sawdust and gum. 3. Feed rate too slow. 4. Sanding belt worn or damaged.	1. Use coarser grit sanding belt or decrease depth of cut (**Page 27**). 2. Clean (**Page 32**)/replace sanding belt (**Page 32**). 3. Increase feed rate (**Page 29**). 4. Replace sanding belt (**Page 29**).
Conveyor belt slips or does not track correctly.	1. Belt tension not properly adjusted. 2. Belt tracking not properly adjusted. 3. Conveyor belt loose or worn. 4. Workpiece too heavy.	1. Properly adjust belt tension (**Page 44**). 2. Properly adjust belt tracking (**Page 44**). 3. Properly tension (**Page 44**)/replace conveyor belt (**Page 45**). 4. Use lighter workpiece.
Elevation handwheel hard to rotate.	1. Elevation set screw and lock nuts too tight. 2. Leadscrew and nut clogged with sawdust.	1. Adjust elevation lock nuts (**Page 39**). 2. Clean and lubricate leadscrew and nut (**Page 34**).
Glazed workpiece surface after sanding.	1. Sanding wet stock. 2. Sanding belt loaded with sawdust and gum. 3. Sanding stock with high amount of applied finishes. 4. Sanding belt worn or damaged.	1. Only sand stock that has moisture content below 20%. 2. Clean (**Page 32**)/replace sanding belt (**Page 30**). 3. Use different stock, or accept characteristics of stock and plan on cleaning/replacing sanding belt frequently; remove applied finishes before sanding. 4. Replace sanding belt (**Page 29**).
Ripples or lines in workpiece.	1. Uneven feed rate. 2. Sanding drum deflecting from workpiece. 3. Conveyor belt flexing or vibrating.	1. Maintain even feed rate through entire sanding operation. 2. Make sure elevation lock nuts are tight (**Page 39**). 3. Reduce depth of cut (**Page 27**), or reduce feed rate (**Page 29**). Verify conveyor belt is tracking/tensioned correctly (**Page 44**).
Snipe marks on workpiece.	1. Improper pressure roller tension. 2. Workpiece too long to be supported without additional help.	1. Adjust pressure roller tension (**Page 40**). 2. Support workpiece.
Poor dust collection.	1. Dust collection lines incorrectly sized for machine. 2. Dust collector underpowered or too far from machine.	1. Use at least an 8" main line with two 6" branch lines that each Y into 4" dust ports at machine. 2. Upgrade dust collector or decrease distance from dust collector to machine.
Uneven workpiece thickness from side to side.	1. Elevation lock nuts not tight and sanding drum deflects up. 2. Conveyor not parallel to sanding drum. 3. Conveyor belt worn.	1. Correctly adjust elevation lock nuts (**Page 39**). 2. Align conveyor to sanding drum (**Page 42**). 3. Replace conveyor belt (**Page 45**).
Workpiece slips on conveyor or kicks out.	1. Sanding depth of cut or feed rate too high. 2. Conveyor belt dirty or worn. 3. Pressure rollers not properly adjusted.	1. Decrease feed rate (**Page 29**)/sanding depth (**Page 27**). 2. Clean (**Page 32**)/replace conveyor belt (**Page 45**). 3. Adjust pressure rollers (**Page 40**).

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Sanding belt slips during use.	1. Sanding belt is not tensioned properly. 2. Excessive workpiece pressure against belt.	1. Correctly tension sanding belt (**Page 29**). 2. Reduce sanding depth (**Page 27**).
Sanding belt runs off to one side.	1. Sanding belt is not tensioned properly. 2. Sanding belt is worn, damaged, or misshapen. 3. Oscillation motor at fault.	1. Correctly tension sanding belt (**Page 29**). 2. Replace sanding belt (**Page 29**). 3. Replace oscillation motor.
Sanding belt slaps or vibrates excessively.	1. Sanding belt is not tensioned properly. 2. Sanding belt is worn, damaged, or misshapen.	1. Correctly tension sanding belt (**Page 29**). 2. Replace sanding belt (**Page 29**).
Belt clogs quickly or excessive sanding belt replacement.	1. Excessive sanding speed. 2. Excessive workpiece pressure against belt. 3. Using too fine of sanding grit. 4. Sanding softwood. 5. Sanding wet stock; workpiece has high sap content. 6. Not using full width of sanding surface.	1. Decrease sanding speed (**Page 29**). 2. Reduce sanding depth (**Page 27**). 3. Use coarser grit sandpaper (**Page 29**). 4. Use different stock or accept characteristics and plan on cleaning (**Page 32**)/replacing sanding belt (**Page 29**) frequently. 5. Dry workpiece properly before sanding; use different stock or accept characteristics and plan on cleaning (**Page 32**)/replacing (**Page 29**) sanding belt frequently. 6. Position workpiece to use different locations to use full width of sanding surface; move workpiece back and forth across sanding surface if the operation allows.
Sanding grains easily rub off roll.	1. Sanding belt stored in improper environment. 2. Sanding belt has been damaged or folded.	1. Replace damaged sanding belt (**Page 29**); store sanding belt in cool, dry place. 2. Replace damaged sanding belt (**Page 29**); do not bend or fold sanding belt.
Vibration when sanding.	1. Worn pillow block bearings.	1. Replace pillow block bearings.
Grinding, screeching, or rubbing noise when sanding drum is powered up.	1. Worn pillow block bearings.	1. Replace pillow block bearings.

Replacing Conveyor Motor Brushes

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

Replace the carbon brushes at the same time when the motor no longer reaches full power, or when the brushes measure less than ¼" long (new brushes are ⅝" long).

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

Items Needed **Qty**
Flat Head Screwdriver ¼" 1
Motor Brushes
G0415 (P0415222-1) ..... 1 Set
G0416 (P0416255-1) ..... 1 Set

To replace conveyor motor brushes:

1. DISCONNECT MACHINE FROM POWER!

2. Remove brush cap and worn brush (see **Figure 38–Figure 39**) from conveyor motor.

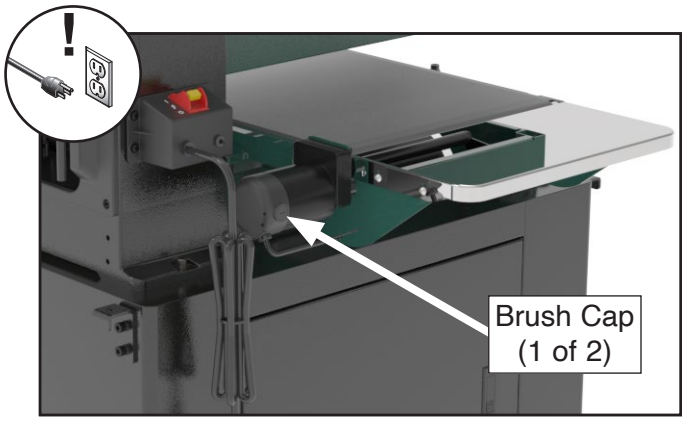


Figure 38. Location of conveyor motor brush cap (G0415 shown).

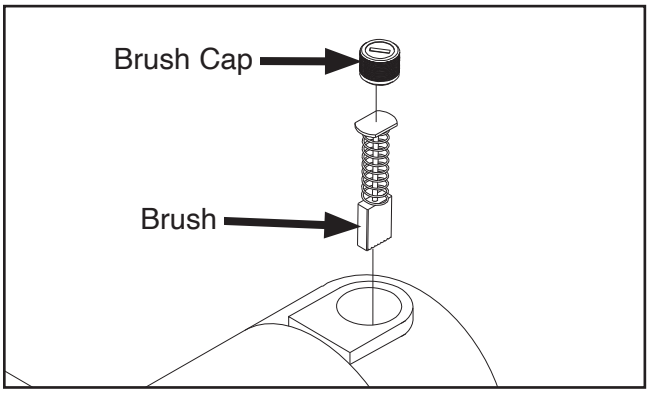


Figure 39. Location of brush under brush cap.

3. Replace motor brush and install brush cap.

4. Repeat for other motor brush.

Calibrating Scale Pointer

For the scale pointer to be accurate, it must be calibrated. We recommend calibrating your scale pointer anytime you adjust the table parallelism.

Tool Needed **Qty**
Hex Wrench ³⁄₃₂" 1

To calibrate scale pointer:

1. Install desired sanding belt and lower sanding drum until it contacts conveyor belt on table.

2. Loosen screws that secure scale pointer (see **Figure 40**), adjust it to zero, then tighten screws.

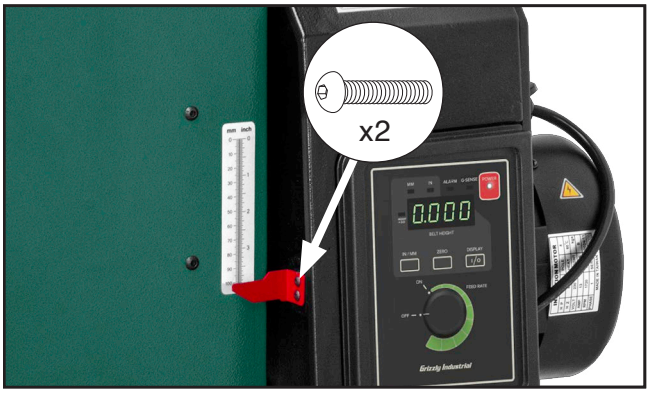


Figure 40. Location of scale pointer and fasteners.

Adjusting Elevation System

Headstock movement is guided by slots in the mounting bracket and held in place with four elevation lock nuts. Gas springs help lift the weight of the headstock to provide smooth movement (see **Figure 41**).

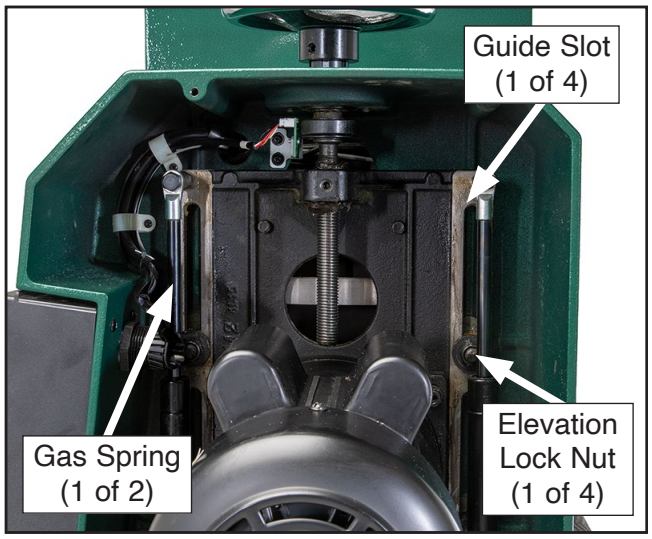


Figure 41. Elevation system.

If the elevation lock nuts are too loose, the sanding drum will deflect up during operation, which will result in poor sanding results.

If the elevation lock nuts are too tight, it will be difficult to adjust the sanding drum height, and will cause excessive wear on the parts of the elevation system.

The elevation set screw can be adjusted to tighten or loosen the elevation leadscrew backlash.

Tools Needed:	**Qty**
Open-End Wrench 17mm	1
Hex Wrench 4mm	1

Adjusting Elevation Lock Nuts

1. DISCONNECT MACHINE FROM POWER!
2. Remove right access panel.
3. Adjust elevation lock nuts shown in **Figure 41** on all (4) guide rails an equal amount, by 1/4 turns.
4. Rotate drum height handwheel to test drum movement.
5. Install right access panel.

Adjusting Elevation Set Screw

1. Tighten or loosen elevation set screw to adjust until height handwheel backlash is no more than 1/8 turn (see **Figure 42**).

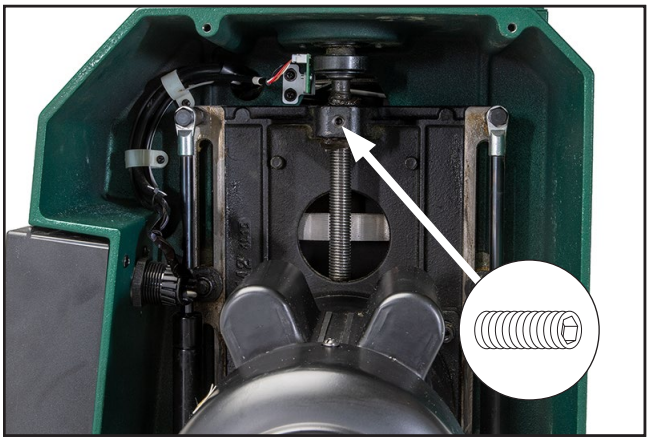


Figure 42. Location of elevation set screw.

Making Gauge Blocks

The blocks described here will be required to complete the remaining service procedures in this section.

Items Needed	Qty
6' Long 2x4	1
Miter Saw (or Circular Saw)	1
Jointer	1
Table Saw	1

To make gauge blocks:

1. Edge joint concave edge of 2x4 flat on jointer, as shown in **Figure 43**.

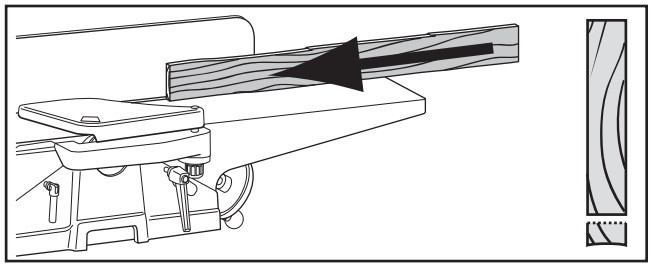


Figure 43. Edge jointing on jointer.

2. Place jointed edge of 2x4 against table saw fence and rip cut just enough off opposite side to square up two edges of 2x4, as shown in **Figure 44**.

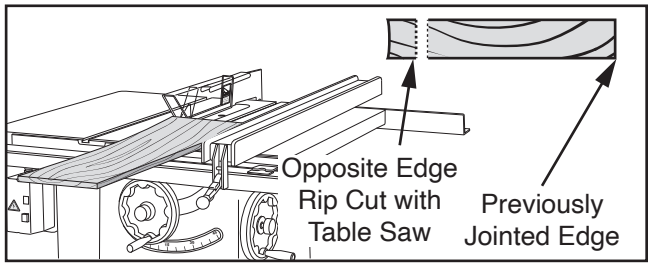


Figure 44. Rip cutting on table saw.

3. Cut 2x4 into two even pieces to make two 36" long wood gauge blocks.

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

Adjusting Pressure Rollers

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

When properly positioned, the pressure rollers should be approximately 0.035" lower than the sanding drum.

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

Items Needed	Qty
Gauge Blocks	2
Feeler Gauge Set	1
Hex Wrench 4mm	1
Phillips Head Screwdriver #2 (4" Length or Less)	1

To adjust pressure rollers:

1. DISCONNECT MACHINE FROM POWER!

2. Open access door and remove sanding belt.

3. Ensure conveyor table is properly aligned to sanding drum (refer to **Aligning Table to Sanding Drum** beginning on **Page 42**).

4. Raise drum so it is about four inches above table.

5. Remove (4) M6-1 x 8 button head cap screws to remove right access panel (as shown in **Figure 45**).

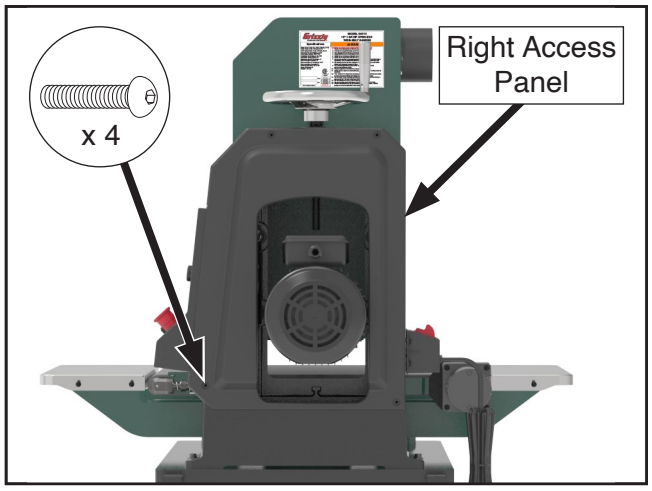


Figure 45. Location of right access panel and fasteners.

6. Place gauge blocks under drum (as shown in **Figure 46**).

Figure 46. Example of gauge blocks placed under drum.

7. Lower drum until gauge blocks just touch rear pressure roller (see **Figure 47**).

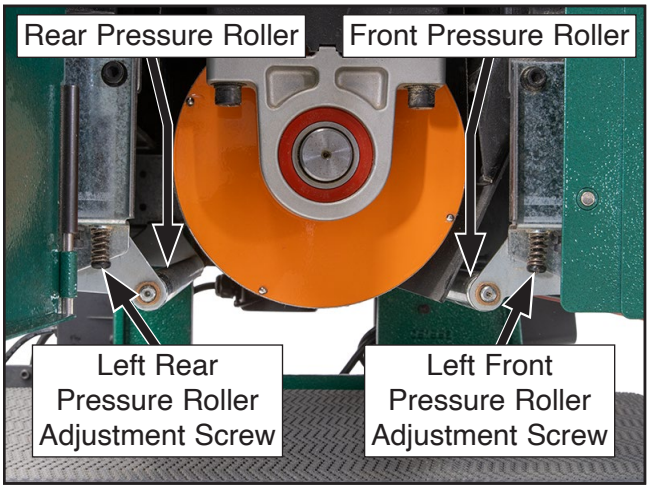


Figure 47. Location of left pressure roller adjustment screws.

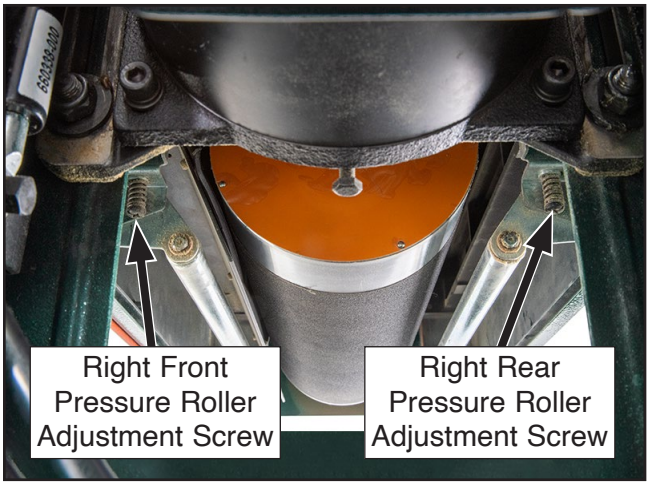


Figure 48. Location of right pressure roller adjustment screws.

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

   — If gap is 0.035" (0.9mm) at each gauge block, no adjustment of rear pressure roller is necessary. Proceed to **Step 10** to check front pressure roller.

   — If gap is *not* 0.035" (0.9mm) at either gauge block, rear pressure roller must be adjusted. Proceed to **Step 9**.

9. Adjust rear pressure roller adjustment screws (see **Figure 47**–**Figure 48**), repeating **Step 8** to test adjustment until rear pressure roller is 0.035" (0.9mm) below drum on either side.

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

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

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

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

— If gap is 0.035" (0.9mm) at each gauge block, no adjustment of front pressure roller is necessary. Proceed to **Step 13**.

— If gap is *not* 0.035" (0.9mm) at either gauge block, front pressure roller must be adjusted. Proceed to **Step 12**.

12. Adjust front pressure roller adjustment screws (see **Figure 47**–**Figure 48**), repeating **Step 11** to test adjustment until front pressure roller is 0.035" (0.9mm) below drum on either side.

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

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

13. Remove gauge blocks.

14. Close access door and secure right access panel.

Aligning Table to Sanding Drum

Aligning the conveyor table parallel to the sanding drum (see **Figure 49**) is critical for sanding accuracy. Care should be taken to make the tolerances as close as possible (within about 0.010" from one side to the other) when adjusting the conveyor table.

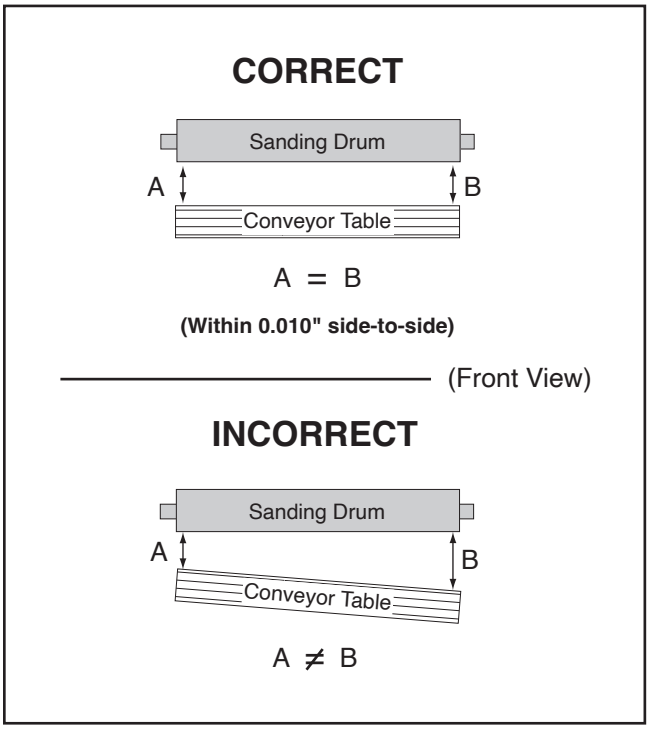


Figure 49. Conveyor table alignment to sanding drum.

Items Needed	Qty
Gauge Blocks (**Page 40**)	2
Feeler Gauge Set	1

To align table to sanding drum:

1. DISCONNECT MACHINE FROM POWER!

2. Open left access door and remove sanding belt.

3. Place gauge blocks under drum, as shown in **Figure 50**, then lower drum until gauge blocks just touch drum.

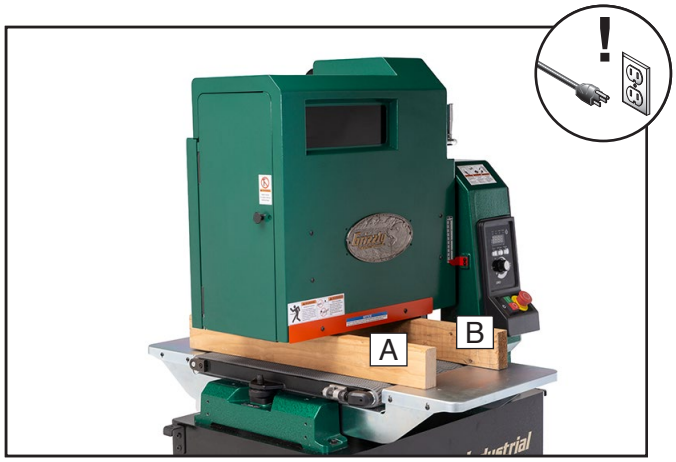


Figure 50. Example of gauge blocks placed under drum.

4. Raise drum one full revolution of height handwheel.

5. Starting at board A (see **Figure 50**), find largest size feeler gauge that can pass between drum and gauge block. Feeler gauge should slide with moderate resistance, without forcing drum to roll.

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

   — If difference between A and B is 0.010" or less, then no adjustment is necessary. Proceed to **Step 8**.

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

7. Adjust table alignment dial to raise or lower left side of table (see **Figure 51**), repeating **Steps 5–6** to test adjustment until difference between sides is 0.010" or less.

   — To raise left side of table, turn dial counterclockwise.

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

Figure 51. Location of table alignment dial.

8. Remove gauge blocks.

9. Install sanding belt, then close and secure access door.

Tensioning & Tracking Conveyor Belt

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

Items Needed	Qty
Pencil	1
Open End Wrench 17mm	1

⚠CAUTION

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

To track and tension conveyor belt:

1. Use pencil to make reference mark on each side of conveyor table where end of adjustment screws are positioned (see **Figure 52**). These reference marks will provide a visual aid in keeping track of adjustments.

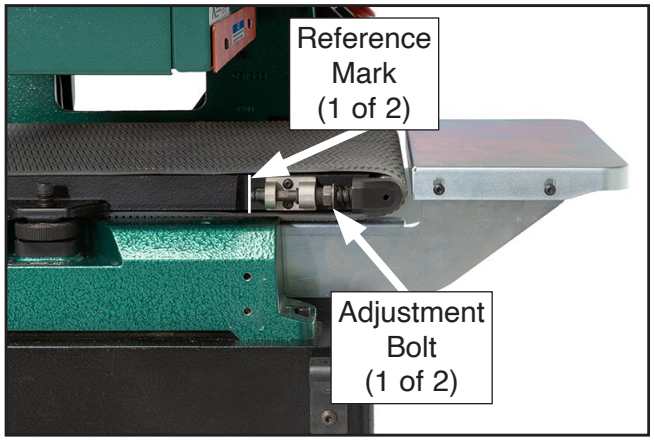


Figure 52. Location of conveyor belt adjustment bolts (left side shown).

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

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

   — If belt slips on rollers, rotate both roller adjustment bolts (see **Figure 53**) evenly counterclockwise to increase tension.

   — If belt tracks toward right, rotate right roller adjustment bolt (see **Figure 53**) counterclockwise to move belt left.

   — If belt tracks toward left, rotate left roller adjustment bolt (see **Figure 53**) counterclockwise to move belt right.

   Note: *Edge of conveyor belt should line up with conveyor guide rail (see* **Figure 53**).

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

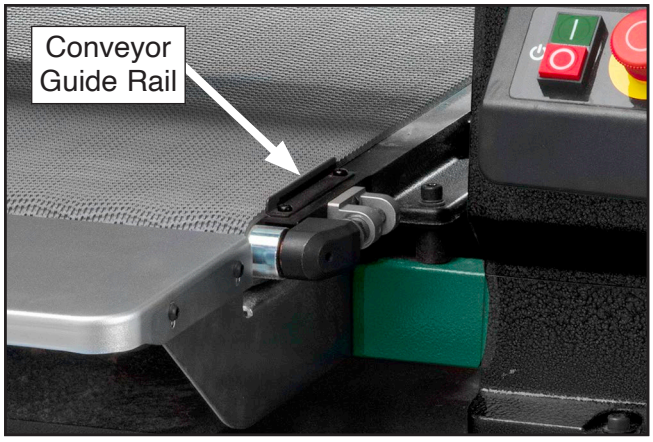


Figure 53. Location of conveyor guide rail.

NOTICE

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

Replacing Conveyor Belt

Replacing the conveyor belt is a relatively simple process, but it will require tensioning and tracking once the new conveyor belt is installed. This process is easier with two people, but directions are provided to accommodate solo belt installation.

Items Needed	Qty
Pencil	1
Tape	As Needed
Hex Wrenches 4, 6mm	1 Ea.
Open-End Wrench 17mm	1
Cleaner/Degreaser	As Needed
Disposable Rags	As Needed
Block 2" x 4" x 24"	1
Replacement Conveyor Belt	
G0415 (P0415162)	1
G0416 (P0416162)	1

To replace conveyor belt:

1. DISCONNECT MACHINE FROM POWER!

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

3. Remove front extension table and brackets for ease of access (see **Assembly** section on **Page 19**).

4. Use pencil to make reference mark on each side of conveyor table where end of adjustment bolts are positioned (see **Figure 54**). These reference marks will provide a visual aid in keeping track of adjustments.

5. Rotate (2) adjustment bolts counterclockwise and slide front roller as far back is it will go (see **Figure 54**).

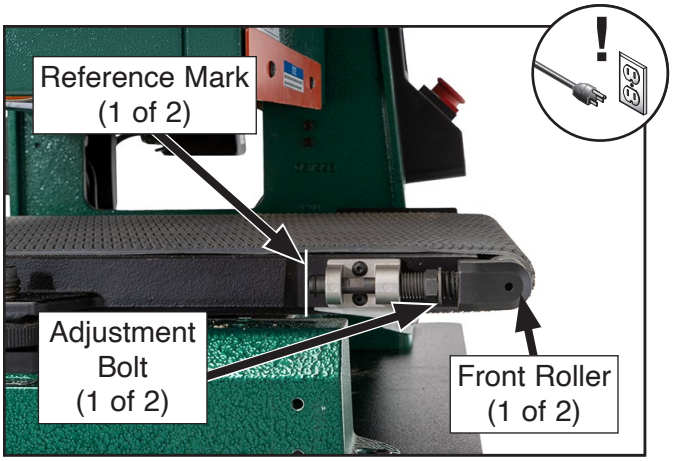


Figure 54. Location of adjustment bolt, reference mark, and front roller (left side shown).

6. Remove cap screw, washer, compression spring, and bushing from table alignment dial (See **Figure 55**).

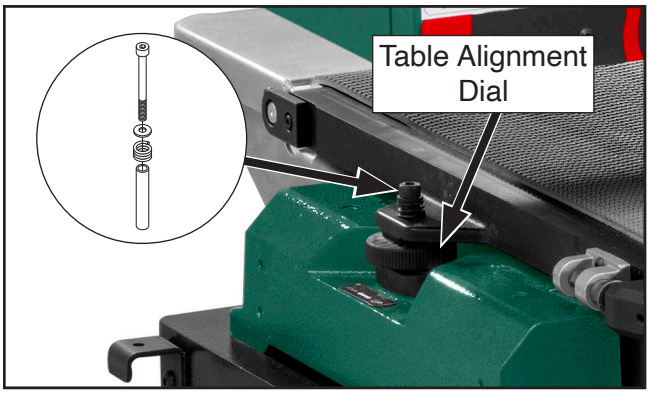


Figure 55. Location of table alignment dial and fasteners.

7. Tape over thrust bearing at center of alignment dial to ensure security during conveyor belt removal (see **Figure 56**).

Figure 56. Thrust bearing secured with tape.

8. Loosen, but do not remove, (2) cap screws to right of conveyor table (see **Figure 57**).

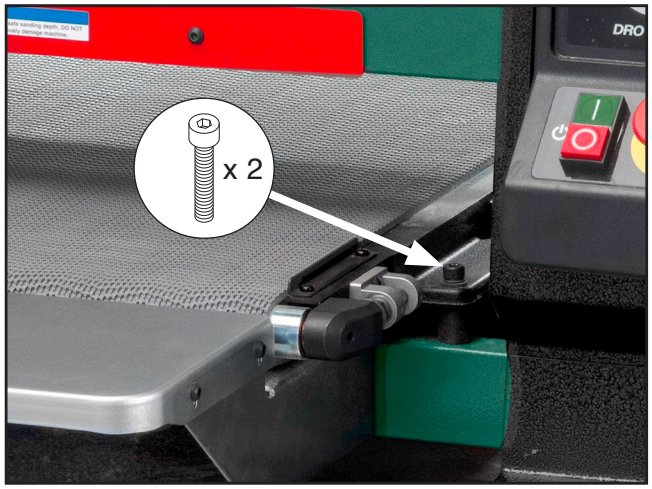


Figure 57. Location of cap screws.

9. Lift open side of conveyor table and slide conveyor belt off of table.

10. Clean and inspect table and rollers.

11. Lift open side of conveyor table and place 2" x 4" x 24" block under conveyor table to keep table elevated (see **Figure 58**).

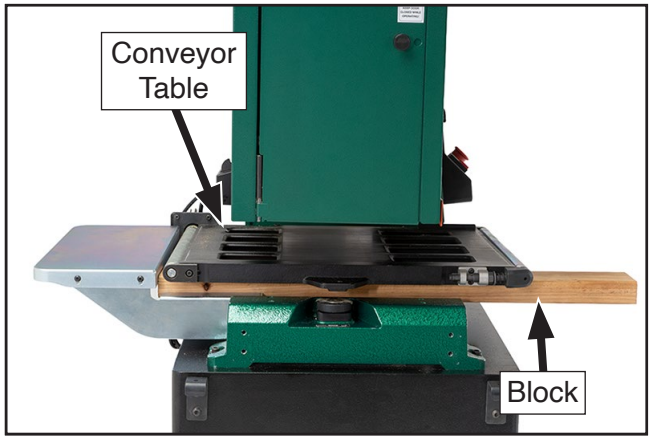


Figure 58. Block placed under conveyor table.

12. Slide new conveyor belt halfway onto table. Remove block, then slide conveyor belt fully onto conveyor table.

    Note: *If conveyor belt has directional arrows on backing (see **Figure 59**), install belt with arrow facing rear of machine from top of table.*

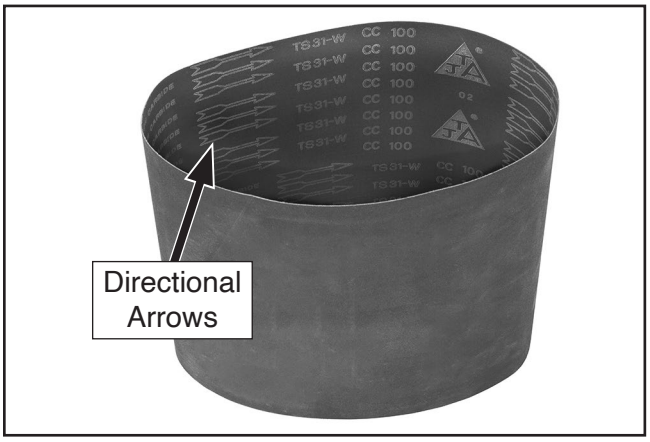


Figure 59. Example of conveyor belt directional arrows.

13. Remove tape from top of thrust bearing.

14. Install fasteners removed in **Step 6**, and tighten cap screws loosened in **Step 8**.

15. Refer to **Lubrication** on **Page 34** to make adjustments for new belt.

17. Refer to **Assembly** on **Page 19** to install front extension table and brackets.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

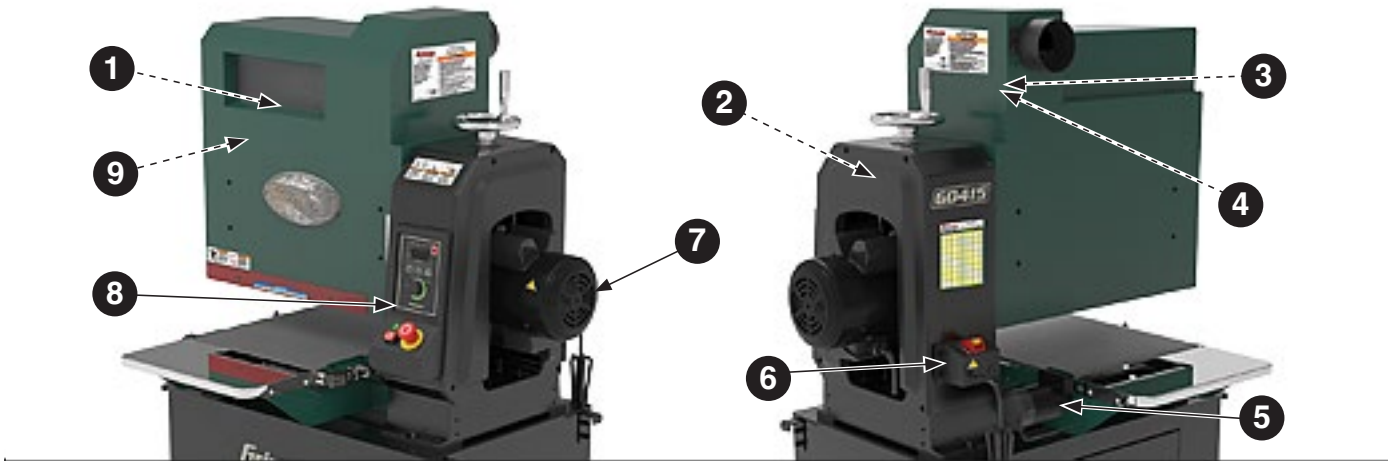
NOTICE

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

COLOR KEY

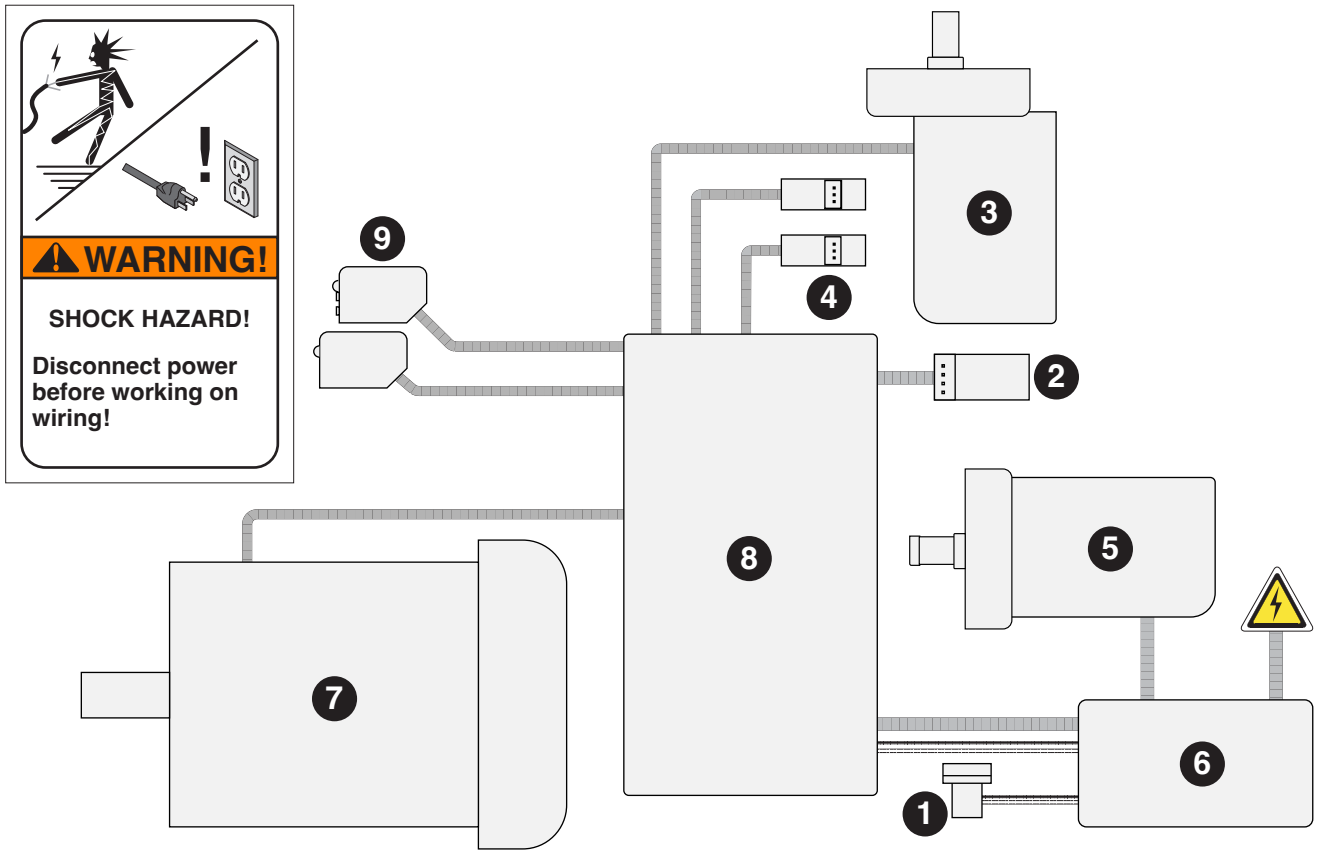
BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Overview



1	LED (**Page 49, Page 52**)
2	Height Sensor (**Page 49, Page 52**)
3	Oscillating Motor (**Page 49, Page 52**)
4	Oscillating Sensors (**Page 49, Page 52**)
5	Feed Motor (**Page 49, Page 52**)

6	Power Switch Box (**Page 49, Page 52**)
7	Main Motor (**Page 51, Page 54**)
8	Control Panel (**Page 49, Page 52**)
9	Tracking Sensors (**Page 49, Page 52**)



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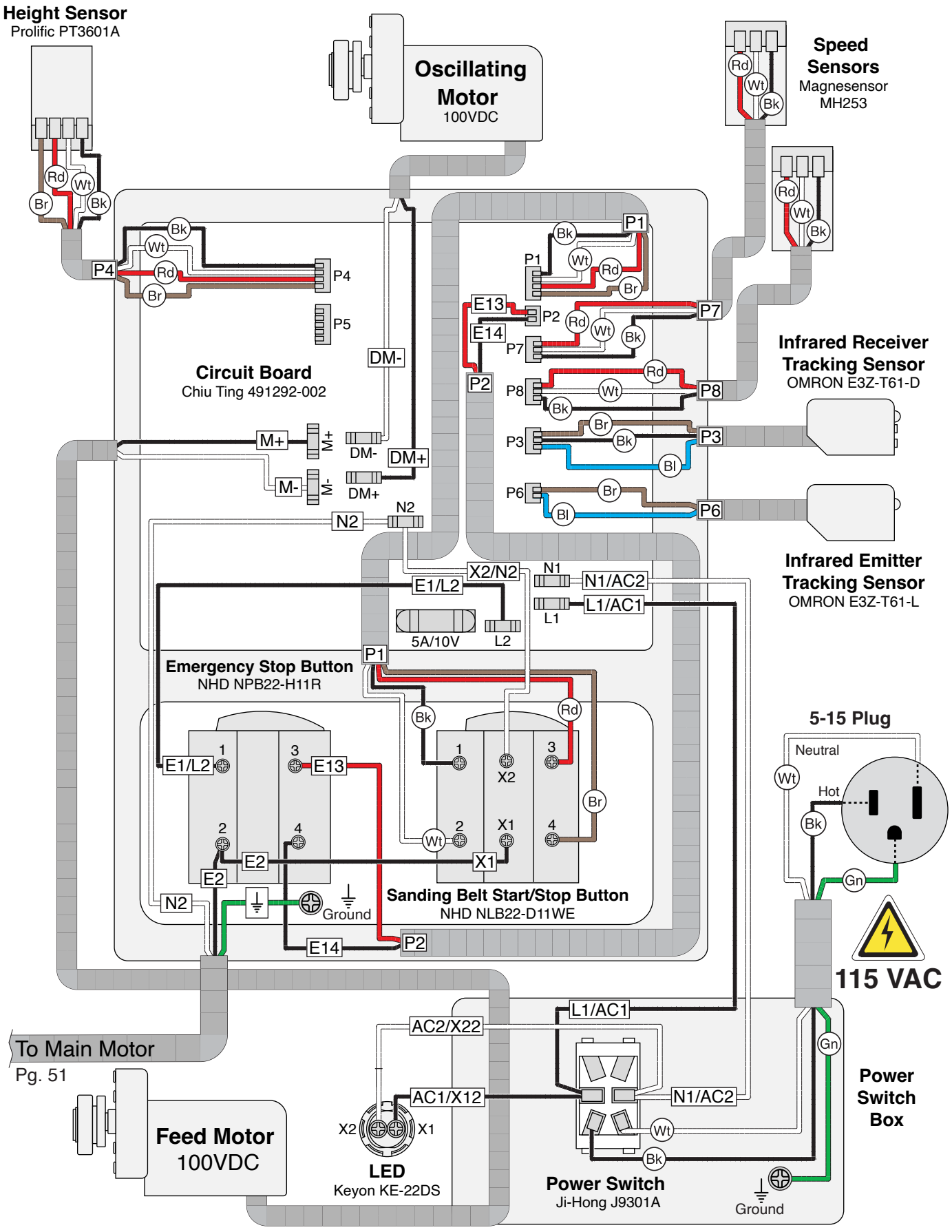
G0415 Control Panel Wiring



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G0415 Wiring Photos

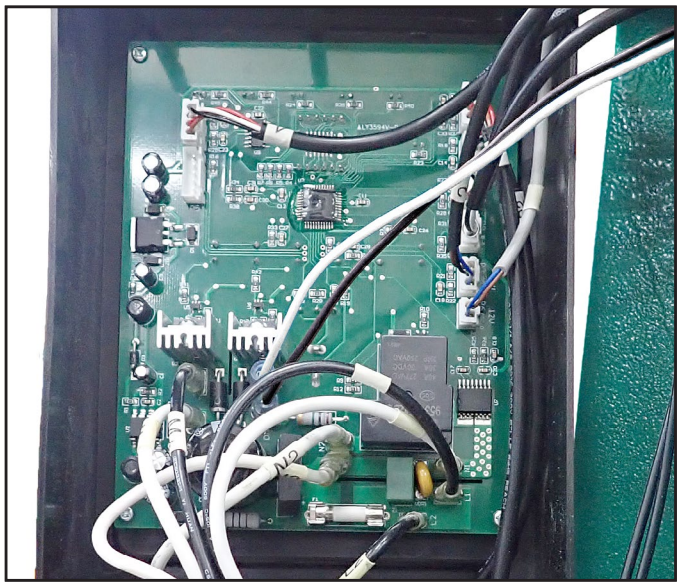


Figure 60. Control panel circuit board wiring.

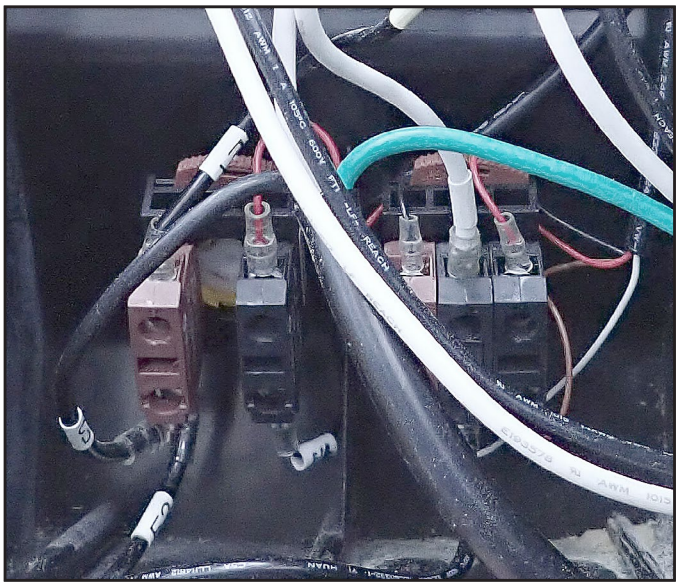


Figure 61. Control panel button wiring.

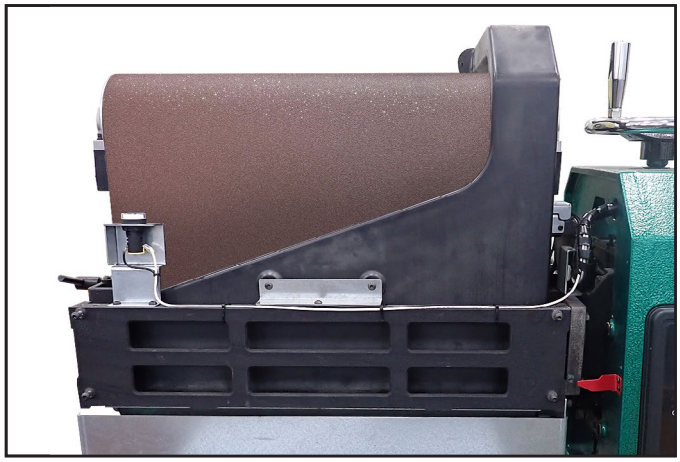


Figure 62. LED wiring.

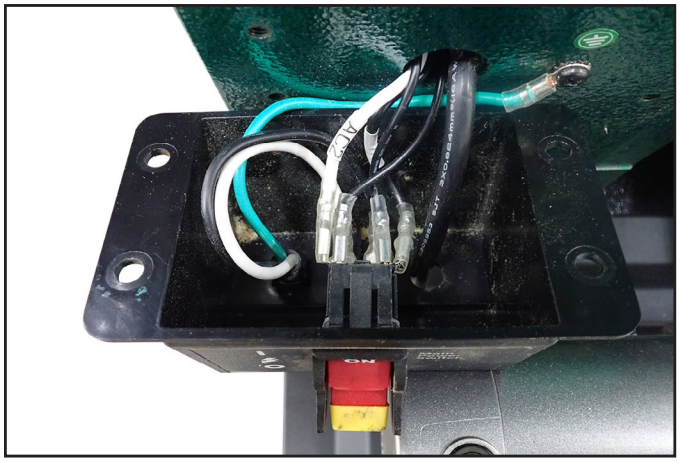


Figure 63. Power switch wiring.

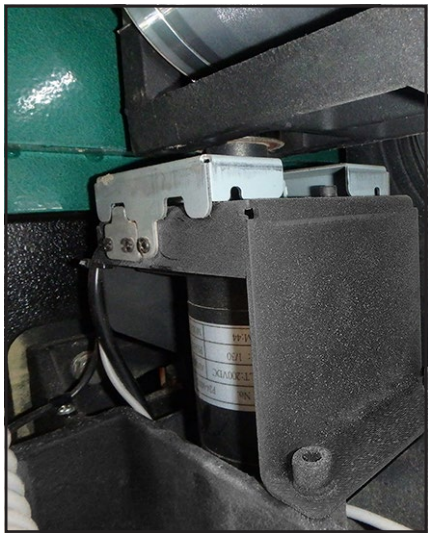


Figure 64. Oscillation motor & oscillation sensors.

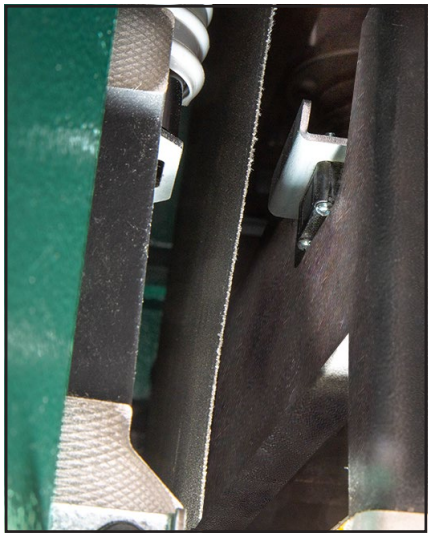


Figure 65. Tracking sensors.

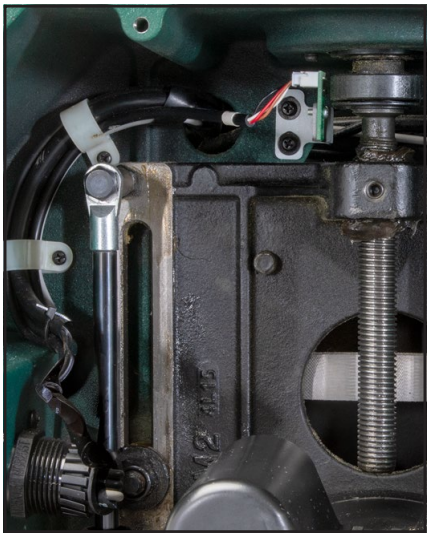
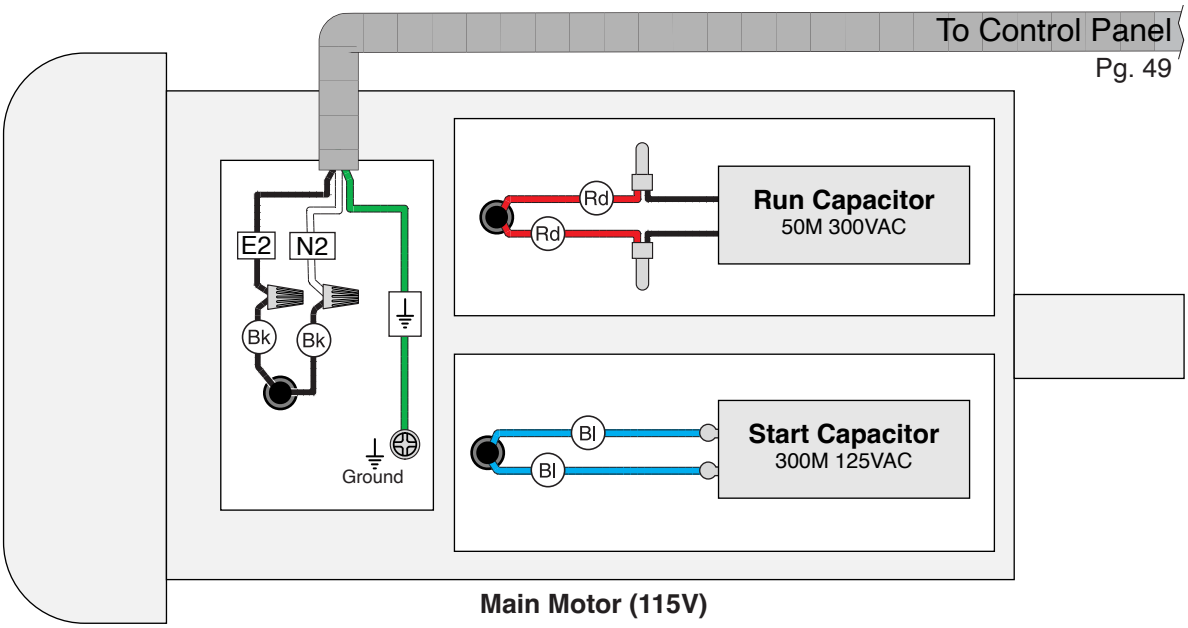


Figure 66. Height sensor.

READ WIRING SAFETY ON PAGE 48!

G0415 Main Motor Wiring

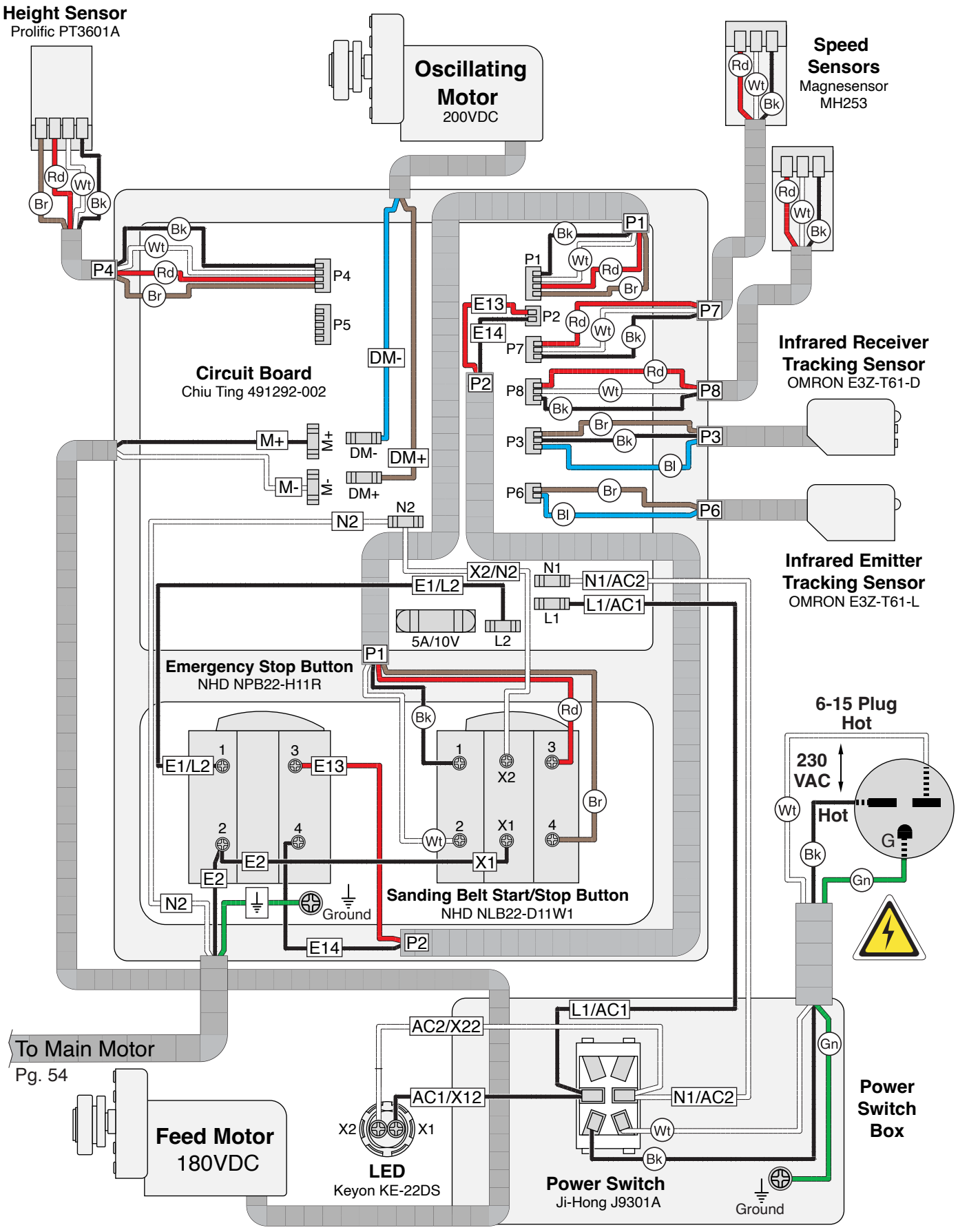


Main Motor (115V)

Figure 67. Main motor junction box wiring.

Figure 68. Main motor capacitor wiring.

G0416 Control Panel Wiring



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G0416 Wiring Photos

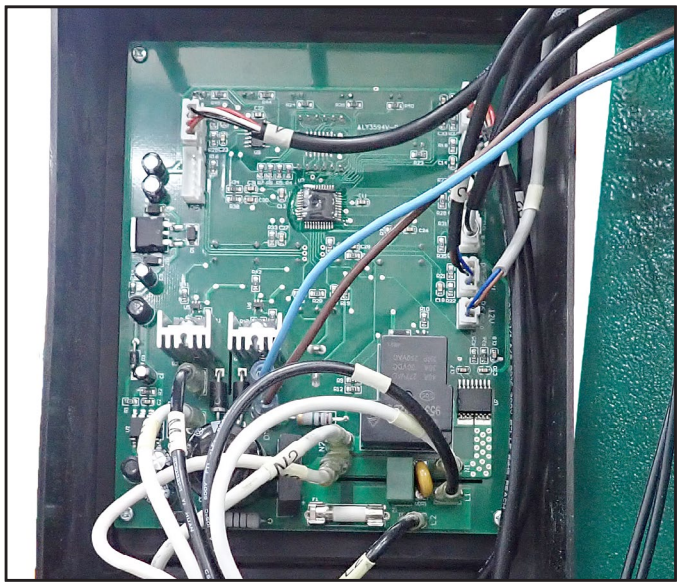


Figure 69. Control panel circuit board wiring.

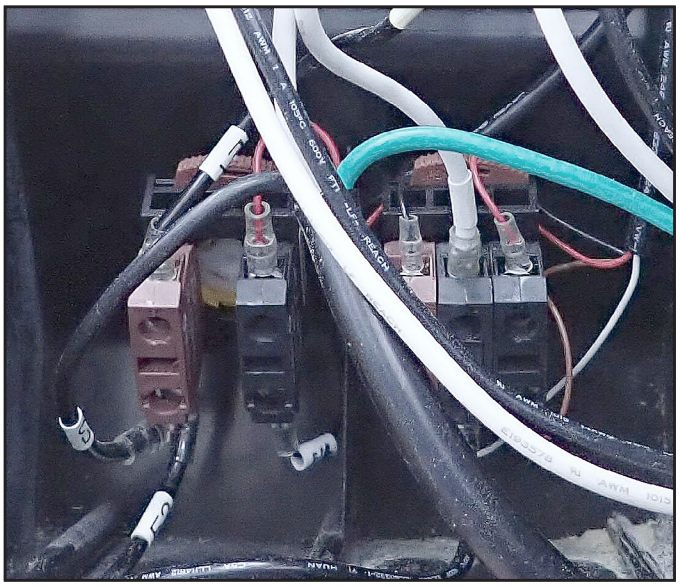


Figure 70. Control panel button wiring.

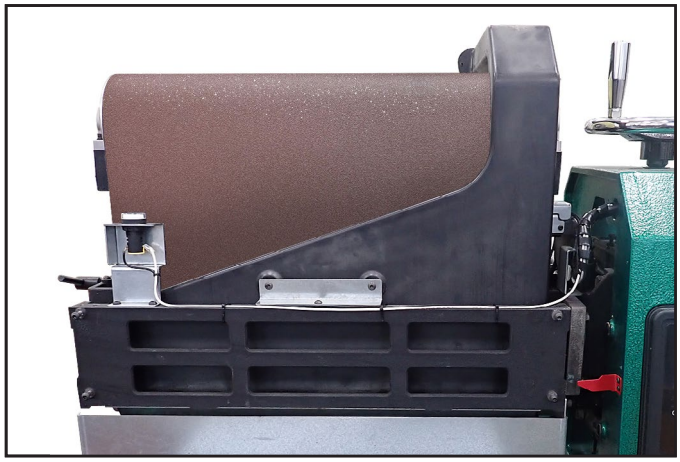


Figure 71. LED wiring.

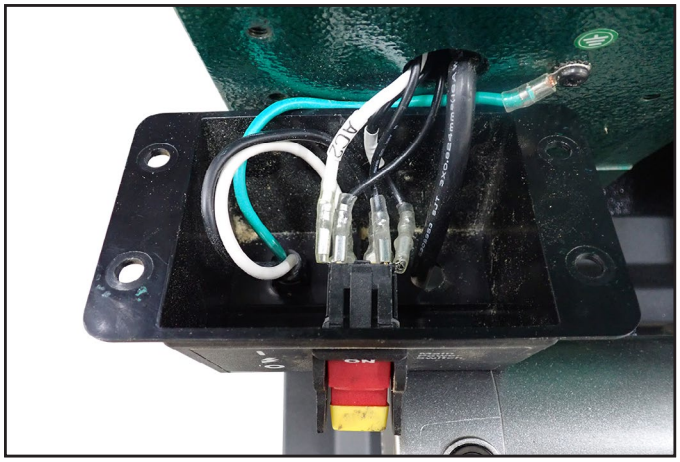


Figure 72. Power switch wiring.

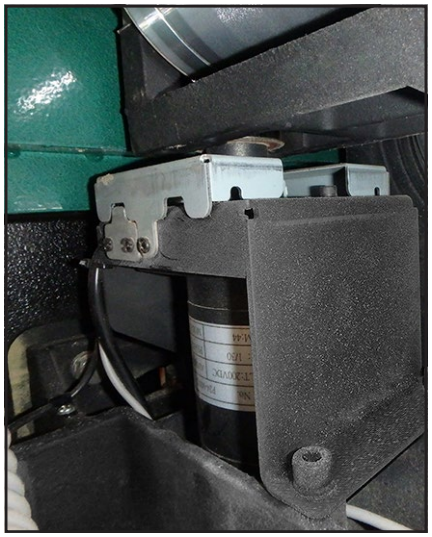


Figure 73. Oscillation motor & oscillation sensors.

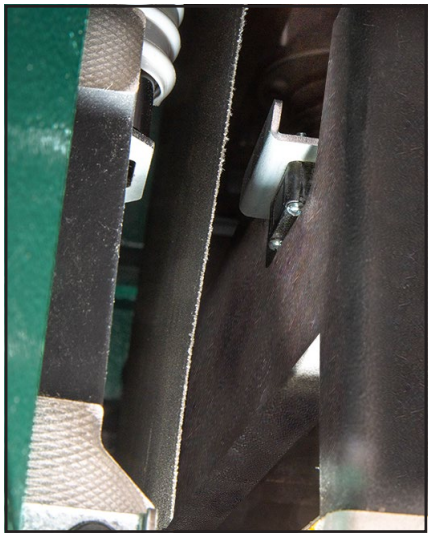


Figure 74. Tracking sensors.

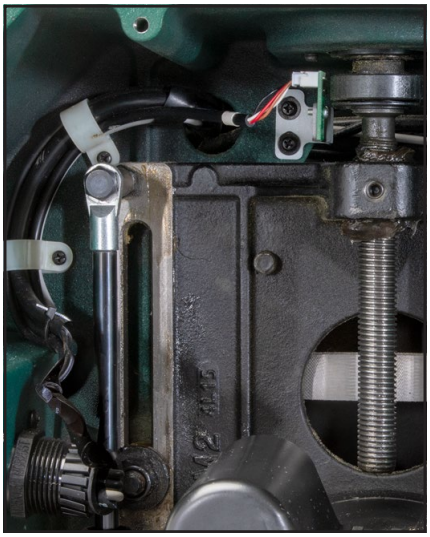
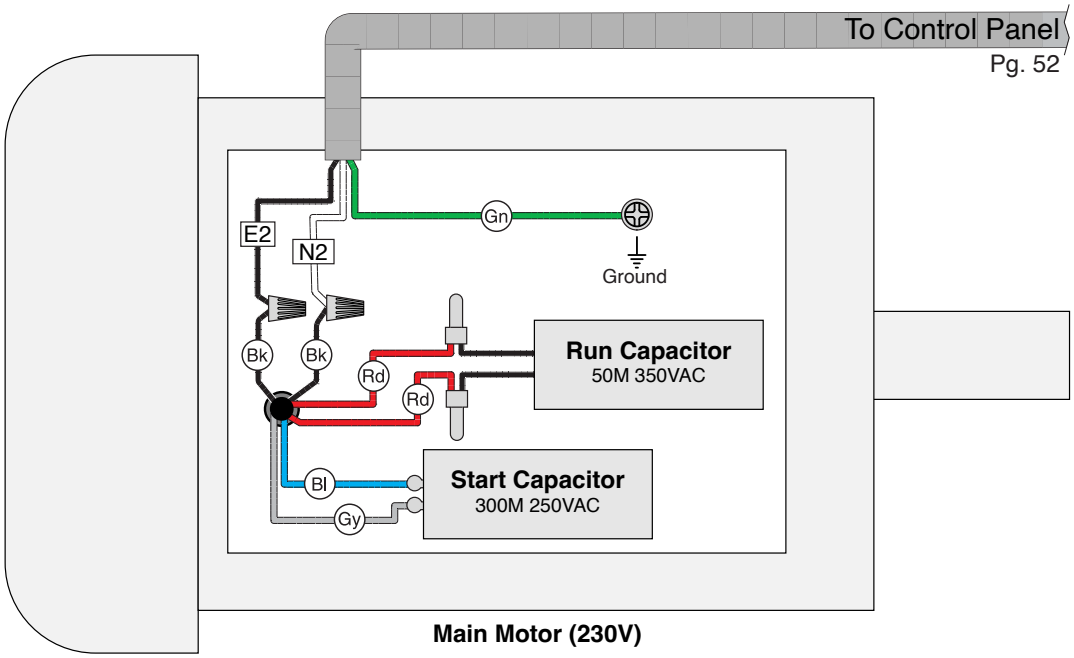


Figure 75. Height sensor.

G0416 Main Motor Wiring



Main Motor (230V)

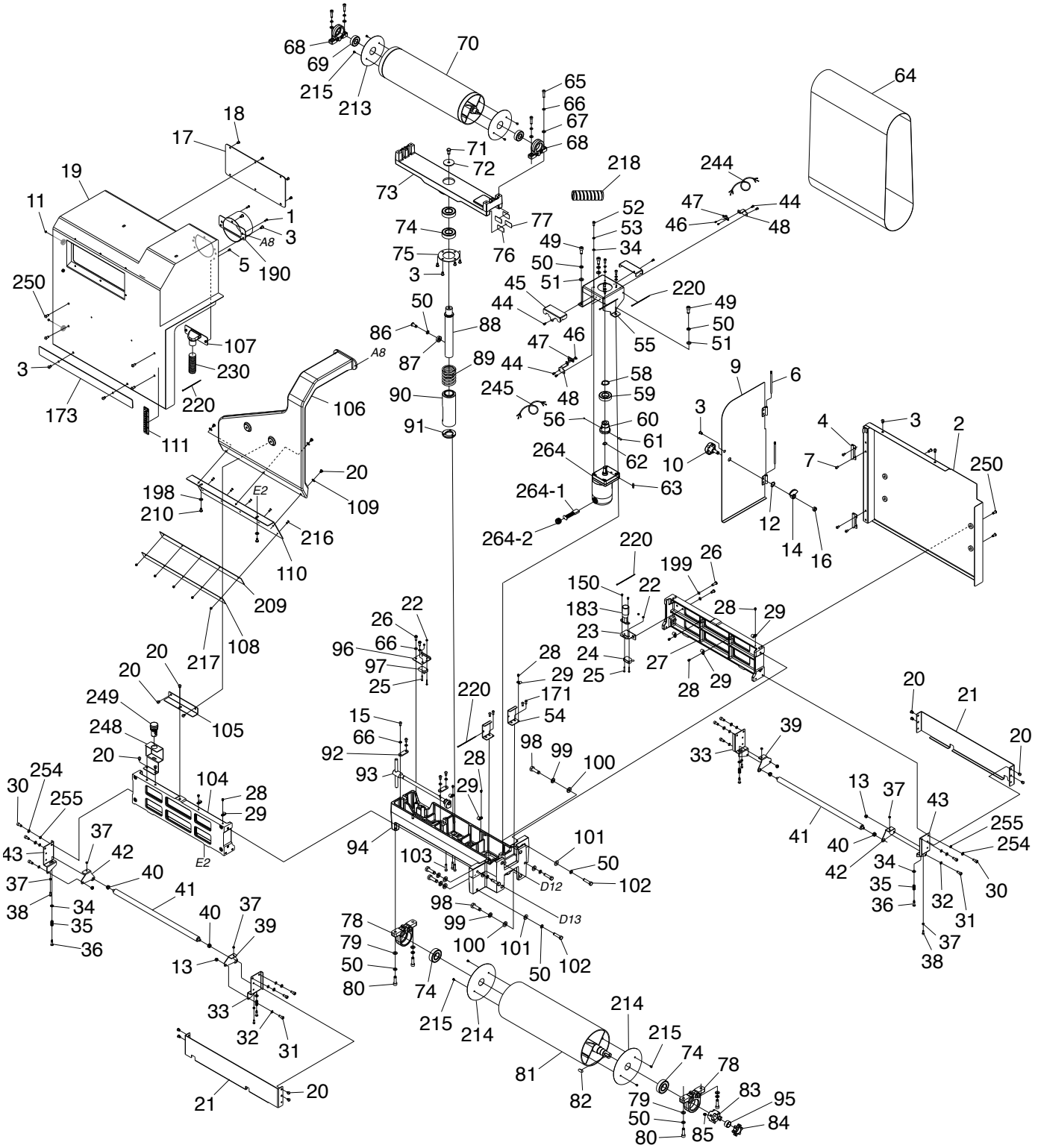
Figure 76. Main motor capacitor wiring.

STOP *READ WIRING SAFETY ON PAGE 48!*

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.

G0415 Sanding Drums



G0415 Sanding Drums Parts List

REF	PART #	DESCRIPTION
1	P0415001	TAP SCREW M4 X 12
2	P0415002	REAR COVER
3	P0415003	BUTTON HD CAP SCR M6-1 X 10
4	P0415004	HINGE PLATE
5	P0415005	TAP SCREW M4 X 8
6	P0415006	HINGE PIN 5 X 100MM
7	P0415007	BUTTON HD CAP SCR M5-.8 X 10
9	P0415009	MAINTENANCE DOOR
10	P0415010	KNOB BOLT 3/8-16 X 25MM
11	P0415011	MAGNET 6.1 X 4MM
12	P0415012	WAVY WASHER 14.5MM
13	P0415013	LOCK NUT M6-1
14	P0415014	LATCH
15	P0415015	BUTTON HD CAP SCR M6-1 X 12
16	P0415016	LOCK NUT 3/8-16
17	P0415017	WINDOW PANEL 12.75 X 5.5"
18	P0415018	BUTTON HD CAP SCR M5-.8 X 8
19	P0415019	COVER, UPPER
20	P0415020	BUTTON HD CAP SCR M6-1 X 8
21	P0415021	PRESSURE ROLLER COVER PLATE
22	P0415022	LOCK NUT M3-.5
23	P0415023	RECEIVER SENSOR BRACKET
24	P0415024	SENSOR RECEIVER OMRON E3Z-T61-D
25	P0415025	PHLP HD SCR M3-.5 X 20
26	P0415026	PHLP HD SCR M6-1 X 15
27	P0415027	FRAME BRACKET, REAR
28	P0415028	PHLP HD SCR M4-.7 X 6
29	P0415029	CORD CLAMP 5MM
30	P0415030	CAP SCREW M6-1 X 16
31	P0415031	CAP SCREW M6-1 X 15
32	P0415032	FLAT WASHER 6MM
33	P0415033	PRESSURE ROLLER MOUNT, FR/RL
34	P0415034	FLAT WASHER 5MM
35	P0415035	COMPRESSION SPRING 1.2 X 8.4 X 14
36	P0415036	SHOULDER SCREW M4-.7 X 7.7, 5 X 14.3
37	P0415037	HEX NUT M4-.7
38	P0415038	CAP SCREW M4-.7 X 12
39	P0415039	PRESSURE ROLLER PIVOT PLATE, FR/RL
40	P0415040	FLANGED BUSHING 8ID X 12OD X 7L
41	P0415041	PRESSURE ROLLER
42	P0415042	PRESSURE ROLLER PIVOT PLATE, FL/RR
43	P0415043	PRESSURE ROLLER MOUNT, FL/RR
44	P0415044	PHLP HD SCR M4-.7 X 8
45	P0415045	SPEED SENSOR COVER
46	P0415046	PHLP HD SCR M3-.5 X 4
47	P0415047	SPEED SENSOR MST MH253
48	P0415048	SPEED SENSOR BRACKET
49	P0415049	CAP SCREW M8-1.25 X 20
50	P0415050	LOCK WASHER 8MM

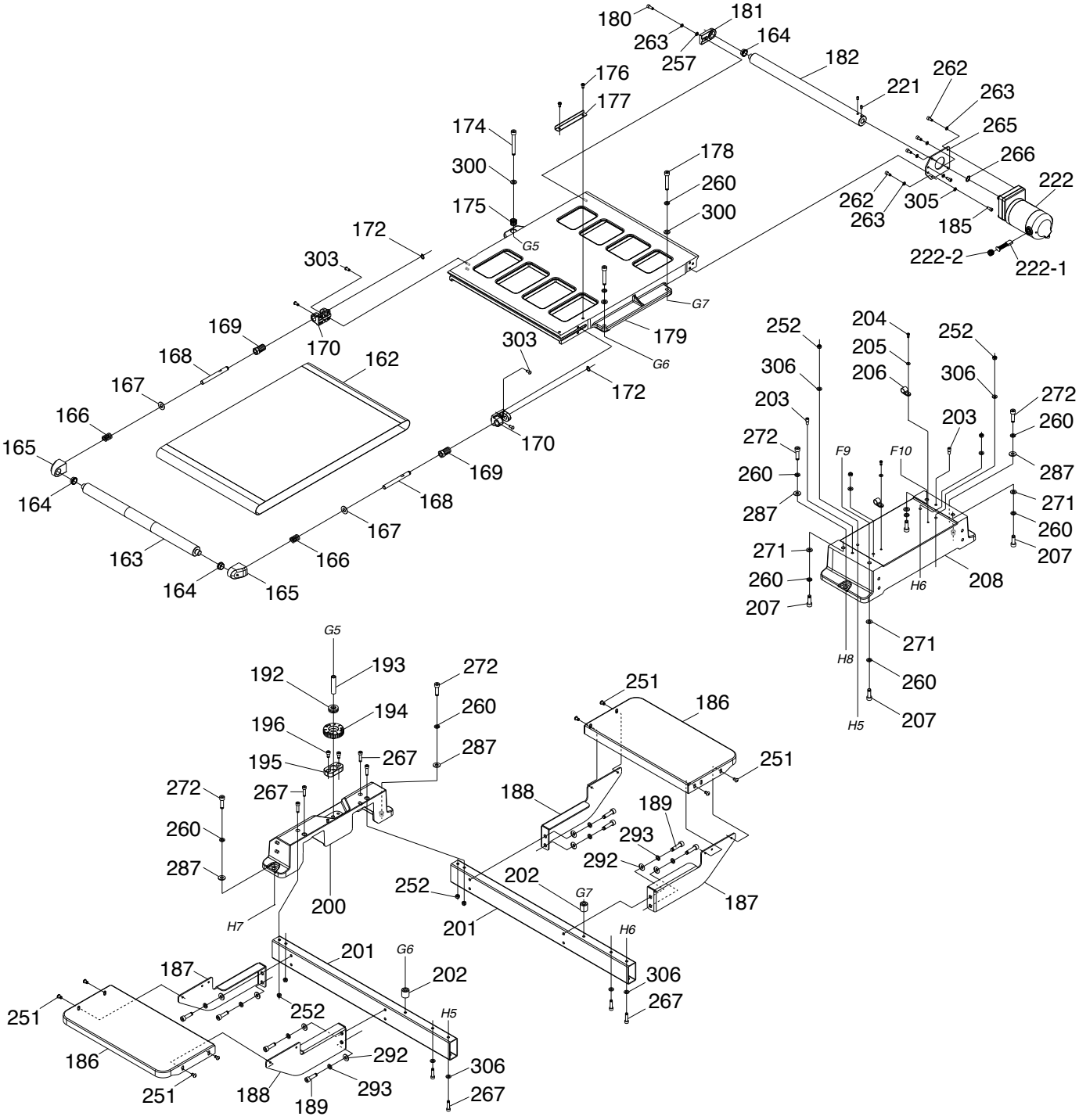
REF	PART #	DESCRIPTION
51	P0415051	FLAT WASHER 8MM
52	P0415052	CAP SCREW M5-.8 X 12
53	P0415053	LOCK WASHER 5MM
54	P0415054	BRACKET
55	P0415055	OSCILLATION MOTOR MOUNT
56	P0415056	MAGNET 4 X 4MM
58	P0415058	EXT RETAINING RING 25MM
59	P0415059	BALL BEARING 6005-2NSE
60	P0415060	ECCENTRIC MOTOR COUPLER
61	P0415061	SET SCREW M5-.8 X 12
62	P0415062	EXT RETAINING RING 12MM
63	P0415063	KEY 4 X 4 X 20 RE
64	P0415064	SANDING BELT 16" X 48" 80-GRIT
65	P0415065	CAP SCREW M6-1 X 25
66	P0415066	LOCK WASHER 6MM
67	P0415067	FLAT WASHER 6MM
68	P0415068	BEARING BLOCK, UPPER
69	P0415069	BALL BEARING 6203-2NSE
70	P0415070	DRUM, UPPER
71	P0415071	HEX BOLT M8-1.25 X 16
72	P0415072	FENDER WASHER 8 X 40 X 3MM
73	P0415073	UPPER ROLLER BRACKET
74	P0415074	BALL BEARING 6205-2NSE
75	P0415075	BEARING CAP
76	P0415076	DOUBLE SIDED TAPE 19 X .25 X 34MM
77	P0415077	PLATE
78	P0415078	BEARING BLOCK, LOWER
79	P0415079	FLAT WASHER 8.5 X 16 X 1.5MM
80	P0415080	CAP SCREW M8-1.25 X 30
81	P0415081	SANDING DRUM, LOWER
82	P0415082	KEY 8 X 7 X 16
83	P0415083	COUPLING HUB
84	P0415084	SPIDER INSERT, RUBBER
85	P0415085	SET SCREW M8-1.25 X 8
86	P0415086	BUTTON HD CAP SCR M8-1.25 X 20
87	P0415087	BALL BEARING 608ZZ
88	P0415088	CENTRAL SHAFT
89	P0415089	COMPRESSION SPRING 5.5 X 51.5 X 60
90	P0415090	SUPPORT COLUMN
91	P0415091	COLUMN END PLATE
92	P0415092	PRESSURE PLATE
93	P0415093	CAM LEVER ASSEMBLY
94	P0415094	HEADSTOCK
95	P0415095	BUSHING 20 X 23.9 X 12MM
96	P0415096	EMITTER SENSOR BRACKET
97	P0415097	SENSOR EMITTER OMRON E3Z-T61-L
98	P0415098	HEX BOLT M10-1.5 X 30
99	P0415099	LOCK WASHER 10MM
100	P0415100	FLAT WASHER 10MM

G0415 Sanding Drums Parts List (Cont.)

101	P0415101	FLAT WASHER 8.5 X 19 X 2MM
102	P0415102	HEX BOLT M8-1.25 X 35
103	P0415103	CAP SCREW M5-.8 X 25
104	P0415104	FRAME BRACKET, FRONT
105	P0415105	MOUNTING BRACKET
106	P0415106	DUST SCOOP
107	P0415107	AUXILARY DUST PORT, UPPER
108	P0415108	PRESSURE BAR
109	P0415109	FLAT WASHER 6.4 X 16 X 1MM
110	P0415110	CHIP BREAKER
111	P0415111	SCALE
150	P0415150	BUTTON HD CAP SCR M4-.7 X 6
171	P0415171	BUTTON HD CAP SCR M5-.8 X 12
173	P0415173	DEPTH LIMITER
183	P0415183	AUXILARY DUST PORT, LOWER
190	P0415190	DUST PORT 4"
198	P0415198	FLAT WASHER 6MM
199	P0415199	FLAT WASHER 6MM
209	P0415209	RUBBER PAD 17.2 X 1.6 X .06"

210	P0415210	PHLP HD SCR M6-1 X 10
213	P0415213	UPPER DRUM END COVER
214	P0415214	LOWER DRUM END COVER
215	P0415215	BUTTON HD CAP SCR M4-.7 X 6
216	P0415216	BUTTON HD CAP SCR M4-.7 X 10
217	P0415217	LOCK NUT M4-.7
218	P0415218	CONDUIT 350MM
220	P0415220	CABLE TIE 104MM
230	P0415230	DUST HOSE 1" X 26.7"
244	P0415244	CORD 24G 3W 33" P7
245	P0415245	CORD 24G 3W 35" P8
248	P0415248	LIGHT BRACKET
249	P0415249	LED LIGHT, WHITE
250	P0415250	BUTTON HD CAP SCR M6-1 X 16
254	P0415254	LOCK WASHER 6MM
255	P0415255	FLAT WASHER 6MM
264	P0415264	MOTOR 1/30HP 100V DC
264-1	P0415264-1	MOTOR BRUSH
264-2	P0415264-2	BRUSH CAP

G0415 Feed Table

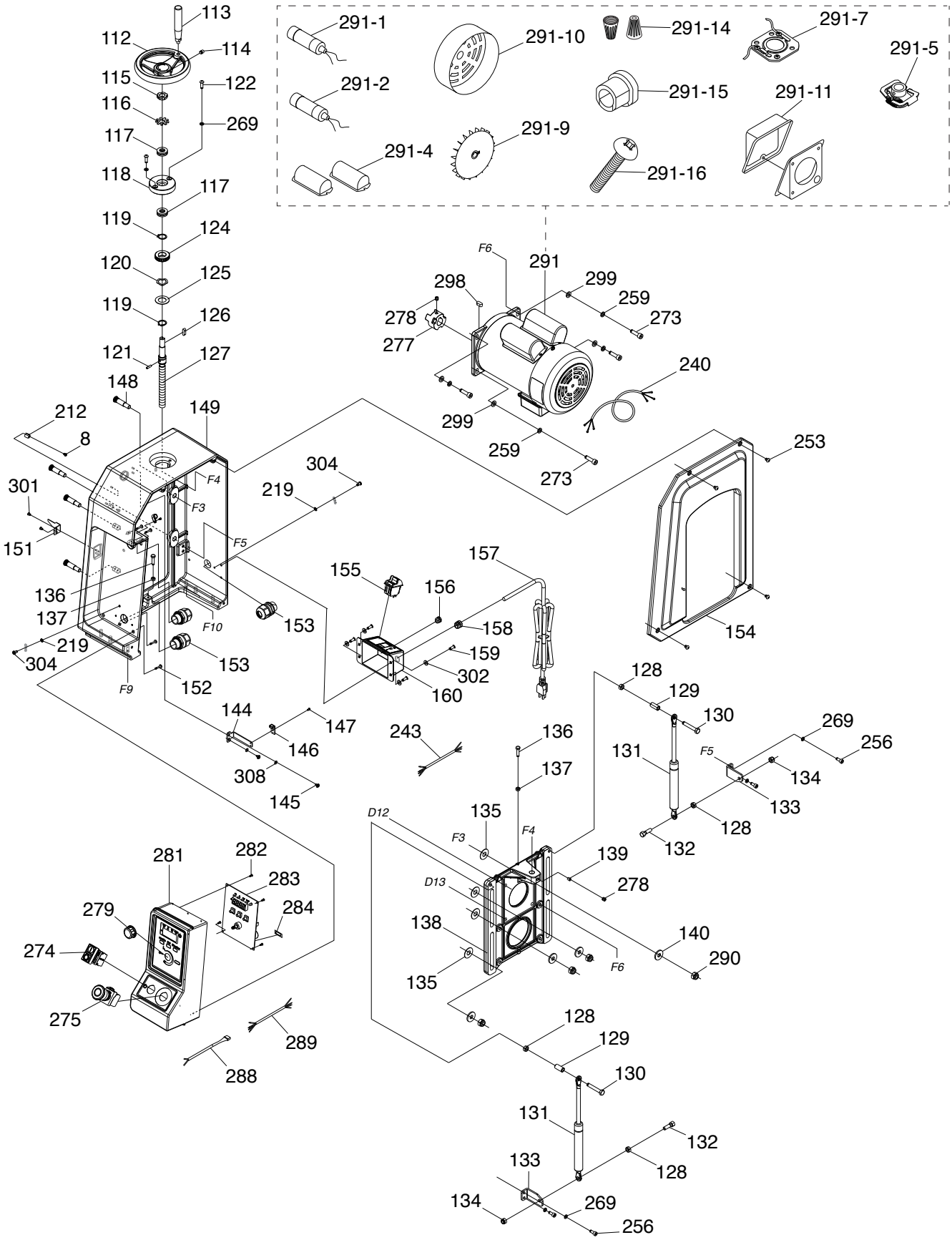


G0415 Feed Table Parts List

REF	PART #	DESCRIPTION
162	P0415162	FEED BELT 15" X 47"
163	P0415163	FEED BELT ROLLER, FRONT
164	P0415164	BUSHING 14ID X 17OD X 6L
165	P0415165	TENSION ROLLER BLOCK
166	P0415166	COMPRESSION SPRING 2.4 X 16.2 X 22MM
167	P0415167	FLAT WASHER 10MM
168	P0415168	TENSION SHAFT
169	P0415169	ADJUST BOLT M16-2 X 24
170	P0415170	TENSION ROLLER BRACKET
172	P0415172	EXT. RETAINING RING 10MM
174	P0415174	CAP SCREW M8-1.25 X 70
175	P0415175	COMPRESSION SPRING 1.6 X 16.6 X 14MM
176	P0415176	PHLP HD SCR M5-.8 X 10
177	P0415177	GUIDE RAIL
178	P0415178	CAP SCREW M8-1.25 X 50
179	P0415179	TABLE
180	P0415180	CAP SCREW M5-.8 X 15
181	P0415181	FIXED ROLLER BLOCK
182	P0415182	FEED BELT ROLLER, REAR
185	P0415185	CAP SCREW M5-.8 X 12
186	P0415186	EXTENSION TABLE
187	P0415187	TABLE BRACKET, LEFT
188	P0415188	TABLE BRACKET, RIGHT
189	P0415189	CAP SCREW M8-1.25 X 20
192	P0415192	THRUST BEARING 51101
193	P0415193	BUSHING 8.2 X 11.9 X 54MM
194	P0415194	LEVELING DIAL
195	P0415195	TABLE ELEVATION BRACKET
196	P0415196	CAP SCREW M6-1 X 12
200	P0415200	TABLE BASE, LEFT

REF	PART #	DESCRIPTION
201	P0415201	TABLE MOUNT
202	P0415202	BUSHING 9 X 20 X 21.5 MM
203	P0415203	SHOULDER BOLT M6-1 X 10, 7.95 X 9MM
204	P0415204	PHLP HD SCR M4-.7 X 10
205	P0415205	FLAT WASHER 4MM
206	P0415206	CORD CLAMP 19MM
207	P0415207	CAP SCREW M8-1.25 X 25
208	P0415208	SWEEP 14 X 7 X 3.5" RUBBER
221	P0415221	SET SCREW M4-.7 X 8
222	P0415222	MOTOR 1/30HP 100V DC
222-1	P0415222-1	MOTOR BRUSH
222-2	P0415222-2	BRUSH CAP
251	P0415251	BUTTON HD CAP SCR M6-1 X 10
252	P0415252	LOCK NUT M6-1
257	P0415257	FLAT WASHER 5MM
260	P0415260	LOCK WASHER 8MM
262	P0415262	CAP SCREW M5-.8 X 12
263	P0415263	LOCK WASHER 5MM
265	P0415265	MOTOR PLATE
266	P0415266	EXT RETAINING RING 12MM
267	P0415267	CAP SCREW M6-1 X 25
271	P0415271	FLAT WASHER 8.5 X 16 X 1.5MM
272	P0415272	CAP SCREW M8-1.25 X 30
287	P0415287	FLAT WASHER 8.5 X 19 X 2MM
292	P0415292	FLAT WASHER 8MM
293	P0415293	LOCK WASHER 8MM
300	P0415300	FLAT WASHER 8MM
303	P0415303	BUTTON HD CAP SCR M5-.8 X 12
305	P0415305	LOCK WASHER 5MM
306	P0415306	FLAT WASHER 6MM

G0415 Main Motor & Control Panel

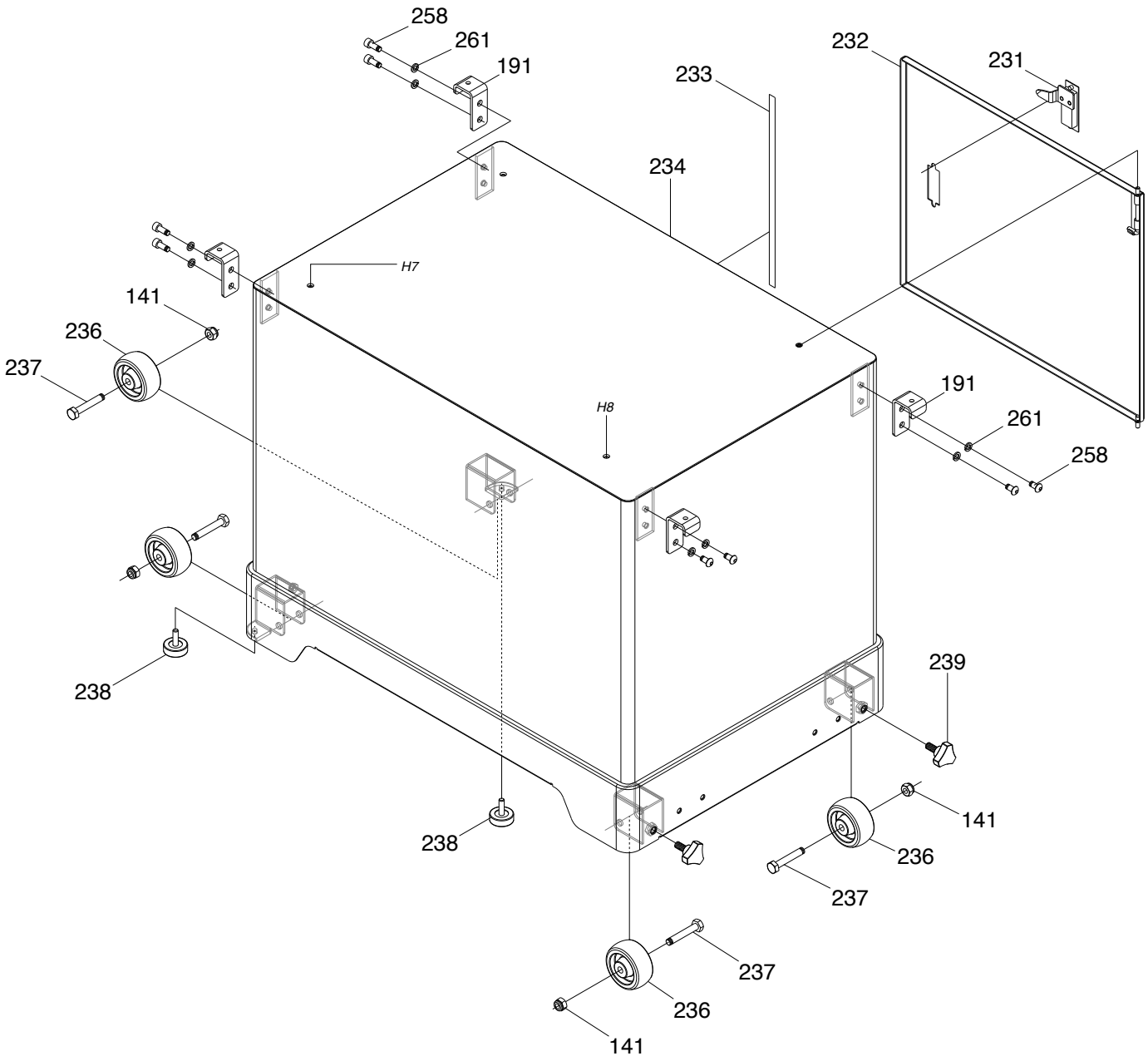


G0415 Main Motor & Control Panel Parts List

REF	PART #	DESCRIPTION
8	P0415008	PHLP HD SCR M4-.7 X 8
112	P0415112	HANDWHEEL 13.05 X 150MM, 3/8-16 X 10
113	P0415113	REVOLVING HANDLE 3/8-16 X 10
114	P0415114	SET SCREW M8-1.25 X 10
115	P0415115	SPANNER NUT M15-1
116	P0415116	EXT TOOTH WASHER 15MM
117	P0415117	THRUST BEARING 51102
118	P0415118	LEADSCREW NUT FLANGE
119	P0415119	EXT RETAINING RING 20MM
120	P0415120	WAVY WASHER 20MM
121	P0415121	ROLL PIN 4 X 16
122	P0415122	BUTTON HD CAP SCR M6-1 X 20
124	P0415124	MAGNETIC SPACER 20.1 X 38 X 10MM
125	P0415125	FLAT WASHER 21 X 37 X 1MM
126	P0415126	KEY 6 X 6 X 20
127	P0415127	ELEVATION LEADSCREW 5/8-12 X 9"
128	P0415128	HEX NUT M8-1.25
129	P0415129	SPACER 12OD X 8.2ID X 25MM
130	P0415130	HEX BOLT M8-1.25 X 50
131	P0415131	GAS SPRING W/EYELET FITTING
132	P0415132	HEX BOLT M8-1.25 X 20
133	P0415133	SPRING BRACKET
134	P0415134	LOCK NUT M8-1.25
135	P0415135	FLAT WASHER 12.2 X 28 X 1MM, BRASS
136	P0415136	HEX BOLT M6-1 X 25
137	P0415137	HEX NUT M6-1
138	P0415138	MOTOR BRACKET
139	P0415139	THREAD INSERT 6.7 X 8 POLYURETHANE
140	P0415140	FENDER WASHER 10.5 X 28 X 3MM
144	P0415144	HEIGHT SENSOR BRACKET
145	P0415145	PHLP HD SCR M4-.7 X 9
146	P0415146	HEIGHT SENSOR PROLIFIC PT3601A
147	P0415147	PHLP HD SCR M3-.5 X 6
148	P0415148	SHOULDER BOLT M10-1.5 X 18, 12 X 33
149	P0415149	ELEVATION HOUSING
151	P0415151	SCALE POINTER
152	P0415152	TAP SCREW M4 X 20
153	P0415153	STRAIN RELIEF 1/2"
154	P0415154	CONTROL ACCESS PANEL
155	P0415155	POWER SWITCH KEDU HY7
156	P0415156	STRAIN RELIEF SBR5-2
157	P0415157	POWER CORD 14G 3W 102" 5-15P

REF	PART #	DESCRIPTION
158	P0415158	STRAIN RELIEF 9/16"
159	P0415159	PHLP HD SCR M6-1 X 10
160	P0415160	POWER SWITCH JUNCTION BOX
212	P0415212	CORD CLAMP 5/8"
219	P0415219	EXT TOOTH WASHER 5MM
240	P0415240	MAIN MOTOR CORD 14G 3W 35"
243	P0415243	CORD 24G 4W 26" P4
253	P0415253	BUTTON HD CAP SCR M6-1 X 8
256	P0415256	CAP SCREW M6-1 X 15
259	P0415259	LOCK WASHER 8MM
269	P0415269	LOCK WASHER 6MM
273	P0415273	CAP SCREW M8-1.25 X 30
274	P0415274	ON/OFF SWITCH NHD NLB22-D11WE
275	P0415275	EMERGENCY STOP SWITCH NHD NPB22-H11R
277	P0415277	COUPLING HUB
278	P0415278	SET SCREW M8-1.25 X 8
279	P0415279	FEED RATE DIAL
281	P0415281	CONTROL PANEL
282	P0415282	TAP SCREW M3 X 8
283	P0415283	DC DRIVER BOARD CHIU TING 491292-002
284	P0415284	FUSE 10A 250VAC
288	P0415288	CORD 24G 2W 12" CONTROL PANEL
289	P0415289	CORD 24G 4W 12" CONTROL PANEL
290	P0415290	LOCK NUT M10-1.5
291	P0415291	MAIN MOTOR 1.75HP 115V 1-PH
291-1	P0415291-1	S CAPACITOR 300M 125V 1-9/16 X 3-9/16
291-2	P0415291-2	R CAPACITOR 50M 300V 1-9/16 X 3-3/8
291-4	P0415291-4	CAPACITOR COVER
291-5	P0415291-5	CENT SWITCH 5/8 1350RPM
291-7	P0415291-7	CONTACT PLATE 24.8 X 37.5MM
291-9	P0415291-9	MOTOR FAN
291-10	P0415291-10	FAN COVER
291-11	P0415291-11	JUNCTION BOX
291-14	P0415291-14	WIRE NUT 22-10AWG
291-15	P0415291-15	STRAIN RELIEF PG16
291-16	P0415291-16	PHLP HD SCR 10-24 X 3/8
298	P0415298	KEY 8 X 7 X 18 RE
299	P0415299	FLAT WASHER 8MM
301	P0415301	BUTTON HD CAP SCR M4-.7 X 6
302	P0415302	FLAT WASHER 6MM
304	P0415304	PHLP HD SCR M5-.8 X 10
308	P0415308	FLAT WASHER 4MM

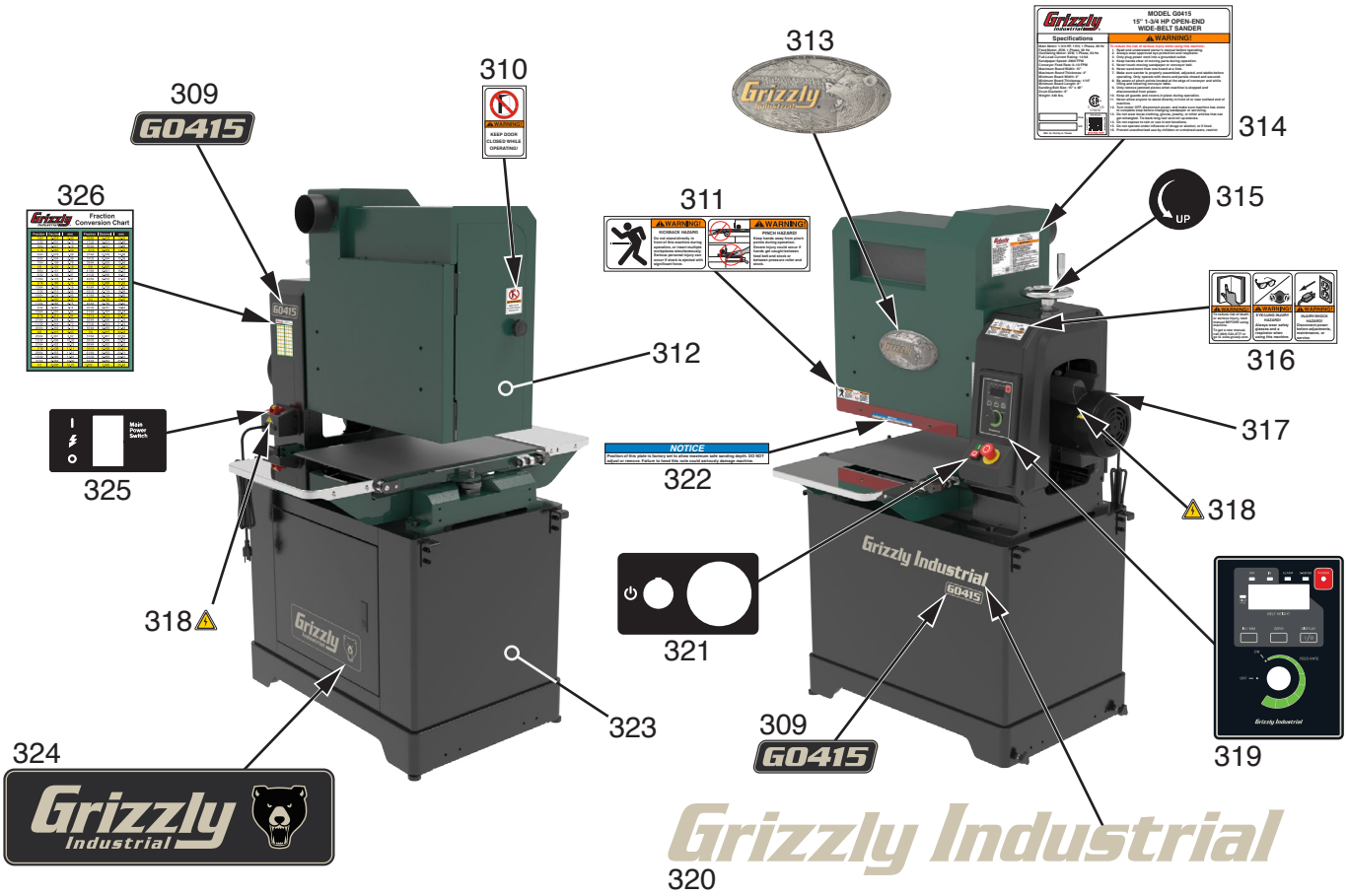
G0415 Base



REF	PART #	DESCRIPTION
141	P0415141	LOCK NUT M10-1.5
191	P0415191	LIFTING HOOK
231	P0415231	DOOR LATCH
232	P0415232	CABINET DOOR
233	P0415233	CUSHION STRIP 16.5 X .5"
234	P0415234	CABINET

REF	PART #	DESCRIPTION
236	P0415236	WHEEL 10.4 X 75 X 33.5MM
237	P0415237	HEX BOLT M10-1.5 X 60
238	P0415238	FOOT M8-1.25 X 26
239	P0415239	KNOB BOLT M10-1.5 X 22
258	P0415258	CAP SCREW M8-1.25 X 20
261	P0415261	LOCK WASHER 8MM

G0415 Labels & Cosmetics



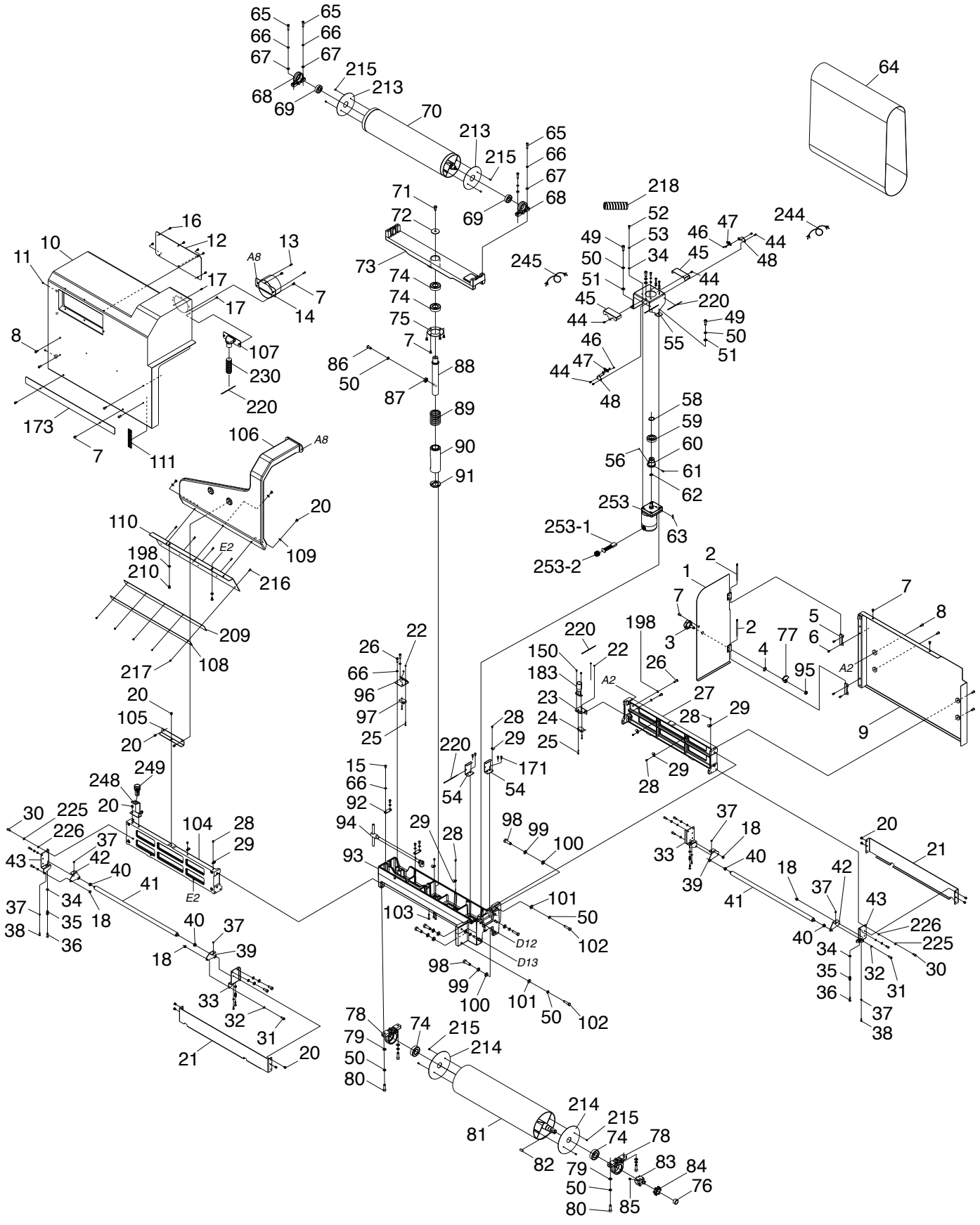
REF	PART #	DESCRIPTION
309	P0415309	MODEL NUMBER LABEL
310	P0415310	DOOR CLOSED LABEL
311	P0415311	COMBO HAZARD LABEL
312	P0415312	TOUCH-UP PAINT, GRIZZLY GREEN
313	P0415313	GRIZZLY NAMEPLATE
314	P0415314	MACHINE ID LABEL
315	P0415315	HANDWHEEL DIRECTION LABEL
316	P0415316	READ MANUAL COMBO LABEL
317	P0415317	MAIN MOTOR LABEL

REF	PART #	DESCRIPTION
318	P0415318	ELECTRICITY LABEL
319	P0415319	CONTROL PANEL LABEL
320	P0415320	GRIZZLY INDUSTRIAL LABEL
321	P0415321	ON/OFF SWITCH LABEL
322	P0415322	NOTICE SAFETY PLATE LABEL
323	P0415323	TOUCH-UP PAINT, GLOSSY BLACK
324	P0415324	GRIZZLY IND W/ BEAR HD LABEL
325	P0415325	REAR CONTROL BOX NAMEPLATE
326	P0415326	FRACTION CONVERSION LABEL

⚠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.

G0416 Sanding Drums



G0416 Sanding Drums Parts List

REF	PART #	DESCRIPTION
1	P0416001	MAINTENANCE DOOR
2	P0416002	HINGE PIN 5 X 100MM
3	P0416003	KNOB BOLT 3/8-16 X 25MM
4	P0416004	WAVY WASHER 14.5MM
5	P0416005	HINGE PLATE
6	P0416006	BUTTON HD CAP SCR M5-.8 X 10
7	P0416007	BUTTON HD CAP SCR M6-1 X 10
8	P0416008	BUTTON HD CAP SCR M6-1 X 14
9	P0416009	COVER, REAR
10	P0416010	COVER, UPPER
11	P0416011	MAGNET 6.1 X 4MM
12	P0416012	WINDOW PANEL 12.75 X 5.5"
13	P0416013	TAP SCREW M4 X 12
14	P0416014	DUST PORT 4"
15	P0416015	BUTTON HD CAP SCR M6-1 X 12
16	P0416016	BUTTON HD CAP SCR M5-.8 X 8
17	P0416017	TAP SCREW M4 X 10
18	P0416018	LOCK NUT M6-1
20	P0416020	BUTTON HD CAP SCR M6-1 X 8
21	P0416021	BRACKET COVER PLATE
22	P0416022	LOCK NUT M3-.5
23	P0416023	RECEIVER SENSOR BRACKET
24	P0416024	SENSOR RECEIVER OMRON E3Z-T61-D
25	P0416025	PHLP HD SCR M3-.5 X 20
26	P0416026	PHLP HD SCR M6-1 X 15
27	P0416027	PRESSURE ROLLER BRACKET, REAR
28	P0416028	PHLP HD SCR M4-.7 X 6
29	P0416029	CORD CLAMP 5MM
30	P0416030	CAP SCREW M6-1 X 16
31	P0416031	CAP SCREW M6-1 X 15
32	P0416032	FLAT WASHER 6MM
33	P0416033	PRESSURE ROLLER MOUNTING PLATE, FR/RL
34	P0416034	FLAT WASHER 5MM
35	P0416035	COMPRESSION SPRING 1.2 X 8.4 X 14
36	P0416036	SHOULDER SCREW M4-.7 X 7.7, 5 X 14.3
37	P0416037	HEX NUT M4-.7
38	P0416038	CAP SCREW M4-.7 X 12
39	P0416039	PRESSURE ROLLER PIVOT PLATE, FR/RL
40	P0416040	FLANGED BUSHING 8ID X 12OD X 7L
41	P0416041	TENSION ROLLER
42	P0416042	PRESSURE ROLLER PIVOT PLATE, FL/RR
43	P0416043	PRESSURE ROLLER MOUNT, FL/RR
44	P0416044	PHLP HD SCR M4-.7 X 8
45	P0416045	SPEED SENSOR COVER
46	P0416046	PHLP HD SCR M3-.5 X 4
47	P0416047	SPEED SENSOR MST MH253
48	P0416048	SPEED SENSOR BRACKET
49	P0416049	CAP SCREW M8-1.25 X 20
50	P0416050	LOCK WASHER 8MM

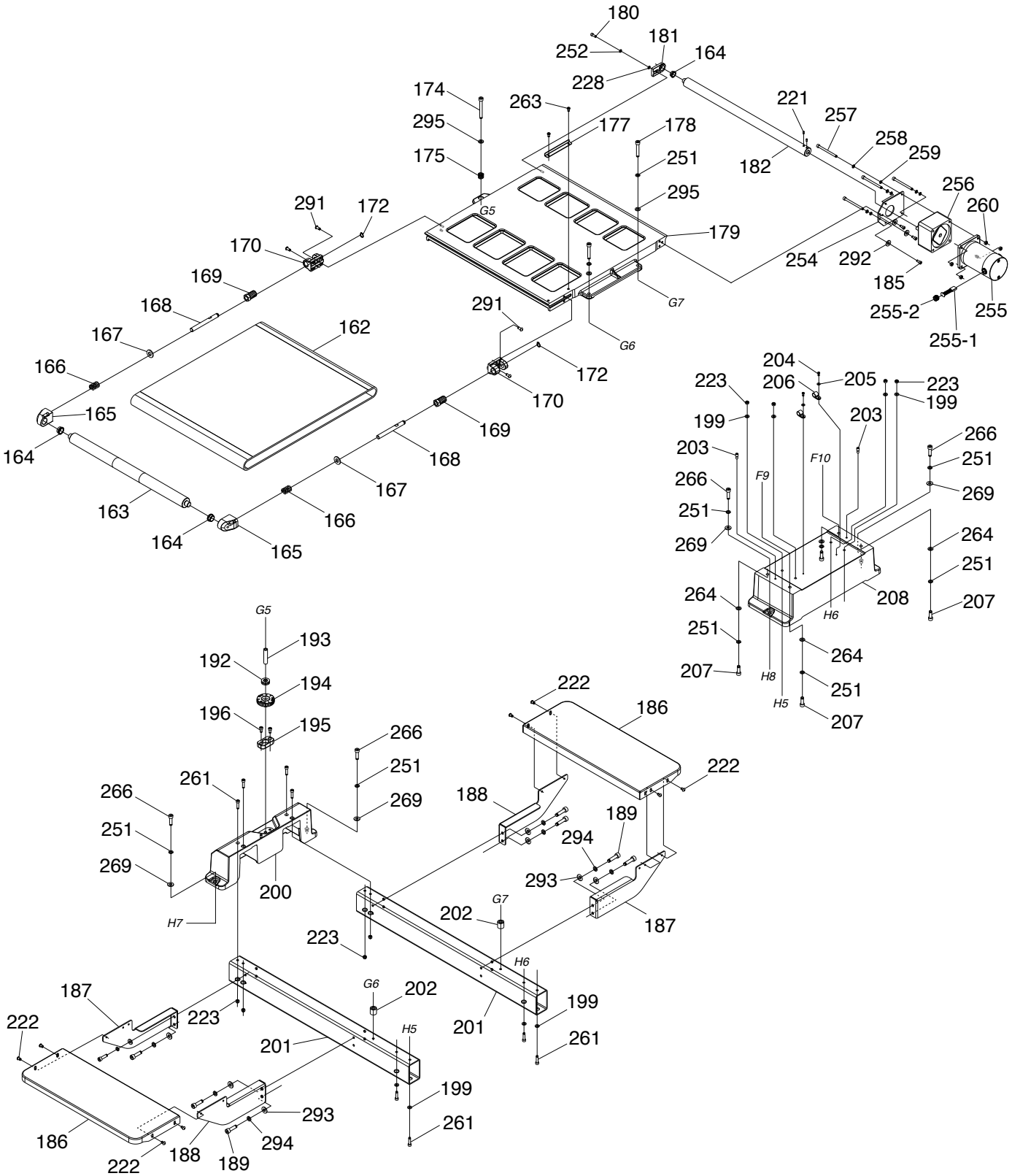
REF	PART #	DESCRIPTION
51	P0416051	FLAT WASHER 8MM
52	P0416052	CAP SCREW M5-.8 X 12
53	P0416053	LOCK WASHER 5MM
54	P0416054	HEADSTOCK BRACKET
55	P0416055	OSCILLATION MOTOR MOUNT
56	P0416056	MAGNET 4 X 4MM
58	P0416058	EXT RETAINING RING 25MM
59	P0416059	BALL BEARING 6005-2NSE
60	P0416060	ECCENTRIC MOTOR COUPLER
61	P0416061	SET SCREW M5-.8 X 12
62	P0416062	EXT RETAINING RING 12MM
63	P0416063	KEY 4 X 4 X 20
64	P0416064	SANDING BELT 16" X 48" 80-GRIT
65	P0416065	CAP SCREW M6-1 X 25
66	P0416066	LOCK WASHER 6MM
67	P0416067	FLAT WASHER 6MM
68	P0416068	BEARING BLOCK, UPPER
69	P0416069	BALL BEARING 6203-2NSE
70	P0416070	DRUM, UPPER
71	P0416071	HEX BOLT M8-1.25 X 16
72	P0416072	FLAT WASHER 8MM
73	P0416073	UPPER ROLLER BRACKET
74	P0416074	BALL BEARING 6205-2NSE
75	P0416075	BEARING CAP
76	P0416076	BUSHING 20 X 23.9 X 12MM
77	P0416077	DOOR LATCH
78	P0416078	BEARING BLOCK, LOWER
79	P0416079	FLAT WASHER 8.5 X 16 X 1.5MM
80	P0416080	CAP SCREW M8-1.25 X 30
81	P0416081	SANDING DRUM, LOWER
82	P0416082	KEY 8 X 7 X 16 RE
83	P0416083	COUPLING HUB
84	P0416084	SPIDER INSERT, RUBBER
85	P0416085	SET SCREW M8-1.25 X 8
86	P0416086	BUTTON HD CAP SCR M8-1.25 X 20
87	P0416087	BALL BEARING 608-ZZ
88	P0416088	CENTRAL SHAFT
89	P0416089	SPRING 5.5 X 40.5 X 60
90	P0416090	SUPPORT COLLUMN
91	P0416091	COLUMN END PLATE
92	P0416092	COLUMN PRESSURE PLATE
93	P0416093	CAM LEVER ASSEMBLY
94	P0416094	HEADSTOCK
95	P0416095	LOCK NUT M10-1.5
96	P0416096	SENSOR BRACKET
97	P0416097	SENSOR EMITTER OMRON E3Z-T61-L
98	P0416098	HEX BOLT M10-1.5 X 30
99	P0416099	LOCK WASHER 10MM
100	P0416100	FLAT WASHER 10MM

G0416 Sanding Drums Parts List (Cont.)

101	P0416101	FLAT WASHER 8.5 X 19 X 2MM
102	P0416102	HEX BOLT M8-1.25 X 35
103	P0416103	CAP SCREW M5-.8 X 25
104	P0416104	PRESSURE ROLLER BRACKET, FRONT
105	P0416105	MOUNTING BRACKET
106	P0416106	DUST SCOOP
107	P0416107	AUX DUST COLLECTOR, UPPER
108	P0416108	PRESSURE BAR
109	P0416109	FLAT WASHER 6.4 X 16 X 1MM
110	P0416110	CHIP BREAKER
111	P0416111	SCALE
150	P0416150	BUTTON HD CAP SCR M4-.7 X 6
171	P0416171	BUTTON HD CAP SCR M5-.8 X 12
173	P0416173	LIMITER PLATE
183	P0416183	AUXILIARY DUST PORT, LOWER
198	P0416198	FLAT WASHER 6MM
209	P0416209	RUBBER PAD 22.2 X 1.6 X 0.06"
210	P0416210	PHLP HD SCR M6-1 X 10

213	P0416213	UPPER DRUM END COVER
214	P0416214	LOWER DRUM END COVER
215	P0416215	BUTTON HD CAP SCR M4-.7 X 6
216	P0416216	BUTTON HD CAP SCR M4-.7 X 10
217	P0416217	LOCK NUT M4-.7
218	P0416218	CONDUIT 350MM
220	P0416220	CABLE TIE 104MM
225	P0416225	LOCK WASHER 6MM
226	P0416226	FLAT WASHER 6MM
230	P0416230	DUST HOSE 1" X 33.8"
244	P0416244	CORD 24G 3W 33" P7
245	P0416245	CORD 24G 3W 35" P8
248	P0416248	LIGHT BRACKET
249	P0416249	LED LIGHT, WHITE
253	P0416253	MOTOR 1/30HP 200V DC 1-PH
253-1	P0416253-1	MOTOR BRUSH
253-2	P0416253-2	BRUSH CAP

G0416 Feed Table

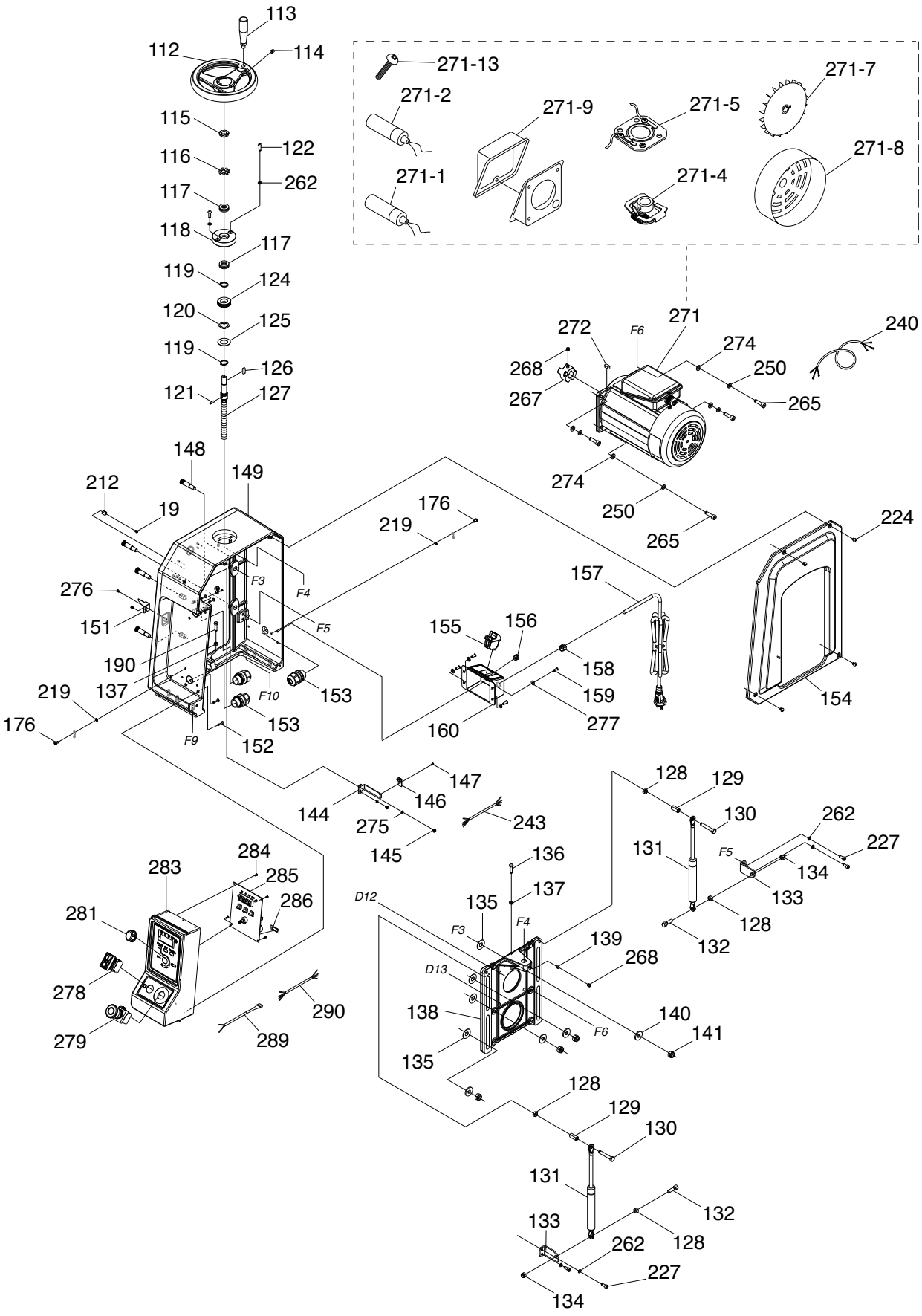


G0416 Feed Table Parts List

REF	PART #	DESCRIPTION
162	P0416162	RUBBER BELT
163	P0416163	FEED BELT ROLLER, FRONT
164	P0416164	BUSHING 14ID X 17OD X 6L
165	P0416165	TENSION ROLLER BLOCK
166	P0416166	COMPRESSION SPRING 2.4 X 16.2 X 22MM
167	P0416167	FLAT WASHER 10MM
168	P0416168	SHAFT
169	P0416169	ADJUST BOLT M16-2 X 24
170	P0416170	BRACKET
172	P0416172	EXT. RETAINING RING 10MM
174	P0416174	CAP SCREW M8-1.25 X 70
175	P0416175	COMPRESSION SPRING 1.6 X 16.6 X 14MM
177	P0416177	GUIDE RAIL
178	P0416178	CAP SCREW M8-1.25 X 50
179	P0416179	BASE PLATE
180	P0416180	CAP SCREW M5-.8 X 15
181	P0416181	FIXED ROLLER BLOCK
182	P0416182	FEED BELT ROLLER, REAR
185	P0416185	CAP SCREW M5-.8 X 12
186	P0416186	EXTENSION TABLE
187	P0416187	TABLE BRACKET, LEFT
188	P0416188	TABLE BRACKET, RIGHT
189	P0416189	CAP SCREW M8-1.25 X 20
192	P0416192	THRUST BEARING 51101
193	P0416193	BUSHING 8.2ID X 11.9OD X 54L
194	P0416194	LEVELING DIAL
195	P0416195	ELEVATION BRACKET
196	P0416196	CAP SCREW M6-1 X 12
199	P0416199	FLAT WASHER 6MM
200	P0416200	BASE
201	P0416201	BASE CONNECTING PIPE
202	P0416202	BUSHING 9ID X 20OD X 21.5L

REF	PART #	DESCRIPTION
203	P0416203	SHOULDER BOLT M6-1 X 10, 7.95 X 9MM
204	P0416204	PHLP HD SCR M4-.7 X 10
205	P0416205	FLAT WASHER 4MM
206	P0416206	CORD CLAMP 19MM
207	P0416207	CAP SCREW M8-1.25 X 25
208	P0416208	SWEEP 17 X 7 X 4.3" RUBBER
221	P0416221	SET SCREW M4-.7 X 8
222	P0416222	BUTTON HD CAP SCR M6-1 X10
223	P0416223	LOCK NUT M6-1
228	P0416228	FLAT WASHER 5MM
251	P0416251	LOCK WASHER 8MM
252	P0416252	LOCK WASHER 5MM
254	P0416254	MOTOR PLATE
255	P0416255	MOTOR 1/30HP 180V DC 1-PH
255-1	P0416255-1	MOTOR BRUSH
255-2	P0416255-2	BRUSH CAP
256	P0416256	GEAR BOX
257	P0416257	CAP SCREW M6-1 X 80
258	P0416258	LOCK WASHER 6MM
259	P0416259	FLAT WASHER 6MM
260	P0416260	HEX NUT M6-1
261	P0416261	CAP SCREW M6-1 X 25
263	P0416263	PHLP HD SCR M5-.8 X 10
264	P0416264	FLAT WASHER 8.5 X 16 X 1.5MM
266	P0416266	CAP SCREW M8-1.25 X 30
269	P0416269	FLAT WASHER 8.5 X 19 X 2MM
291	P0416291	BUTTON HD CAP SCR M5-.8 X 12
292	P0416292	LOCK WASHER 5MM
293	P0416293	FLAT WASHERS 8MM
294	P0416294	LOCK WASHER 8 MM
295	P0416295	FLAT WASHER 8 X 16 X 2MM

G0416 Main Motor & Control Panel

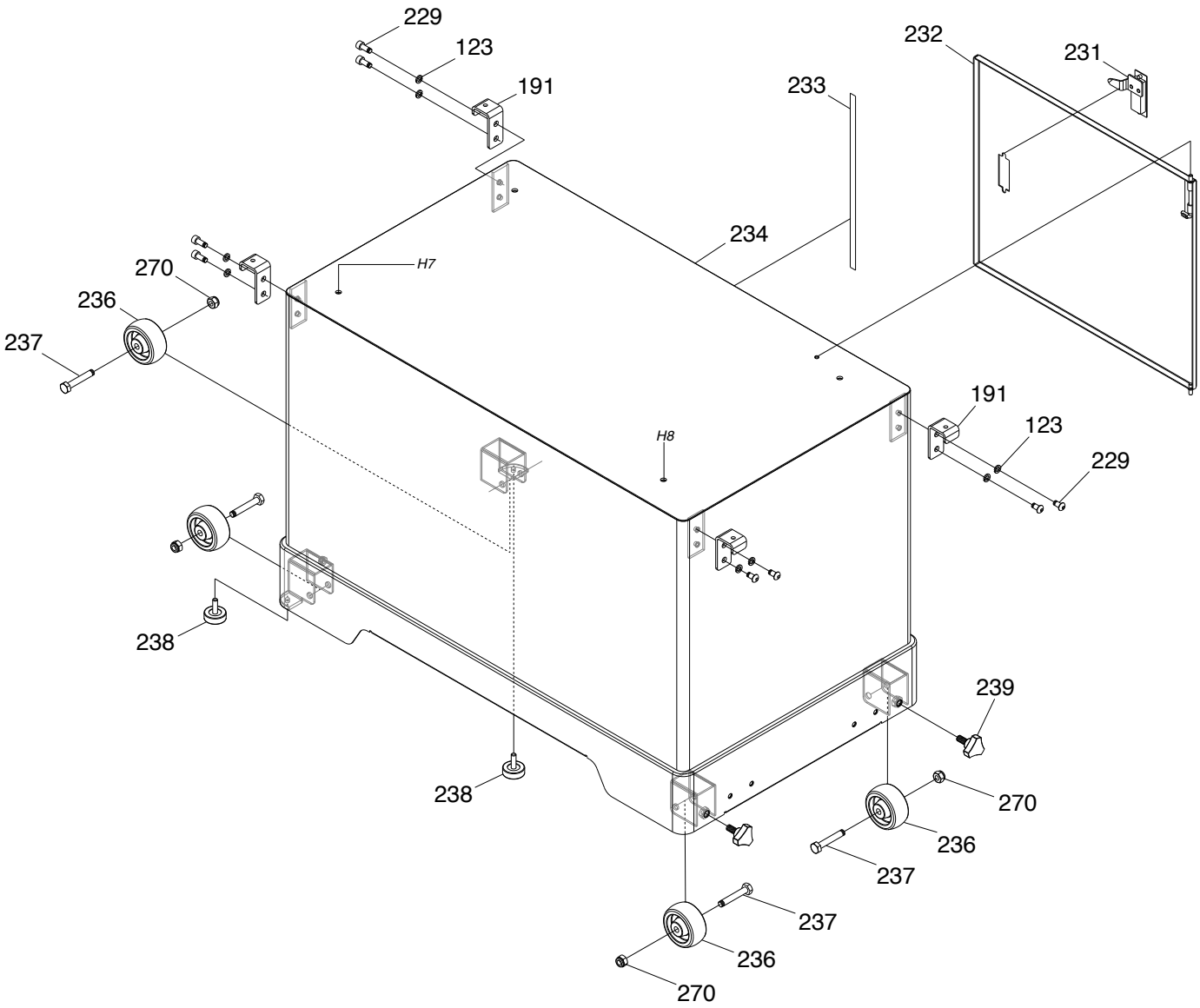


G0416 Main Motor & Control Panel Parts List

REF	PART #	DESCRIPTION
19	P0416019	PHLP HD SCR M4-.7 X 8
112	P0416112	HANDWHEEL 7.75D X M10-1.5
113	P0416113	FIXED HANDLE M10-1.5 X 10
114	P0416114	SET SCREW M8-1.25 X 10
115	P0416115	SPANNER NUT M15-1
116	P0416116	EXT TOOTH WASHER 15MM
117	P0416117	THRUST BEARING 51102
118	P0416118	LEADSCREW NUT FLANGE
119	P0416119	EXT RETAINING RING 10MM
120	P0416120	WAVY WASHER 20MM
121	P0416121	ROLL PIN 4 X 16
122	P0416122	BUTTON HD CAP SCR M6-1 X 20
124	P0416124	MAGNETIC SPACER 20.1 X 38 X 10MM
125	P0416125	FLAT WASHER 21 X 37 X 1MM
126	P0416126	KEY 6 X 6 X 20
127	P0416127	ELEVATION LEADSCREW 5/8-12 X 9"
128	P0416128	HEX NUT M8-1.25
129	P0416129	SPACER 12OD X 8.2ID X 25MM
130	P0416130	HEX BOLT M8-1.25 X 50
131	P0416131	GAS SPRING W/EYELET FITTING
132	P0416132	HEX BOLT M8-1.25 X 20
133	P0416133	STRUT BRACKET
134	P0416134	LOCK NUT M8-1.25
135	P0416135	FLAT WASHER 12.2 X 28 X 1MM, BRASS
136	P0416136	HEX BOLT M6-1 X 20
137	P0416137	HEX NUT M6-1
138	P0416138	MOTOR BRACKET
139	P0416139	THREADED INSERT 6.7 X 8, POLYURETHANE
140	P0416140	FENDER WASHER 10.5 X 28 X 3MM
141	P0416141	LOCK NUT M10-1.5
144	P0416144	HEIGHT SENSOR BRACKET
145	P0416145	PHLP HD SCR M4-.7 X 8
146	P0416146	HEIGHT SENSOR PROLIFIC PT3601A
147	P0416147	PHLP HD SCR M3-.5 X 6
148	P0416148	SHOULDER BOLT M10-1.5 X 18, 12 X 33
149	P0416149	ELEVATION HOUSING
151	P0416151	POINTER
152	P0416152	TAP SCREW M4 X 20
153	P0416153	STRAIN RELIEF 1/2"
154	P0416154	CONTROL ACCESS PANEL
155	P0416155	POWER SWITCH KEDU HY7

REF	PART #	DESCRIPTION
156	P0416156	STRAIN RELIEF 1/2"
157	P0416157	POWER CORD 14G 3W 102" 6-15P
158	P0416158	STRAIN RELIEF 5/8"
159	P0416159	PHLP HD SCR M6-1 X 10
160	P0416160	POWER SWITCH JUNCTION BOX
176	P0416176	PHLP HD SCR M5-.8 X 10
190	P0416190	HEX BOLT M6-1 X 30
212	P0416212	CORD CLAMP 5/8"
219	P0416219	EXT TOOTH WASHER 5MM
224	P0416224	BUTTON HD CAP SCR M6-1 X 8
227	P0416227	CAP SCREW M6-1 X 15
240	P0416240	MAIN MOTOR CORD 14G 3W 35"
243	P0416243	CORD 24G 4W 26" P4
250	P0416250	LOCK WASHER 8MM
262	P0416262	LOCK WASHER 6MM
265	P0416265	CAP SCREW M8-1.25 X 30
267	P0416267	COUPLING HUB
268	P0416268	SET SCREW M8-1.25 X 8
271	P0416271	MAIN MOTOR 3HP 220V 1-PH
271-1	P0416271-1	S CAPACITOR 400M 125V 1-9/16 X 3-9/16
271-2	P0416271-2	R CAPACITOR 50M 350V 1-3/4 X 3-3/8
271-4	P0416271-4	CENTRIFUGAL SWITCH
271-5	P0416271-5	CONTACT PLATE
271-7	P0416271-7	MOTOR FAN
271-8	P0416271-8	MOTOR FAN COVER
271-9	P0416271-9	JUNCTION BOX
271-13	P0416271-13	PHLP HD SCR 10-24 X 3/8
272	P0416272	KEY 8 X 7 X 18
274	P0416274	FLAT WASHER 8.5MM
275	P0416275	FLAT WASHER 4MM
276	P0416276	BUTTON HD CAP SCR M4-.7 X 6
277	P0416277	FLAT WASHER 6MM
278	P0416278	ON/OFF SWITCH NLB22-D11WI
279	P0416279	EMERGENCY STOP SWITCH NPB22-H11R
281	P0416281	FEED RATE DIAL
283	P0416283	CONTROL PANEL
284	P0416284	TAP SCREW M3 X 8
285	P0416285	DC DRIVER BOARD CHIU TING 491292-002
286	P0416286	FUSE 10A 250V
289	P0416289	CORD 24G 2W 12" CONTROL PANEL
290	P0416290	CORD 24G 4W 12" CONTROL PANEL

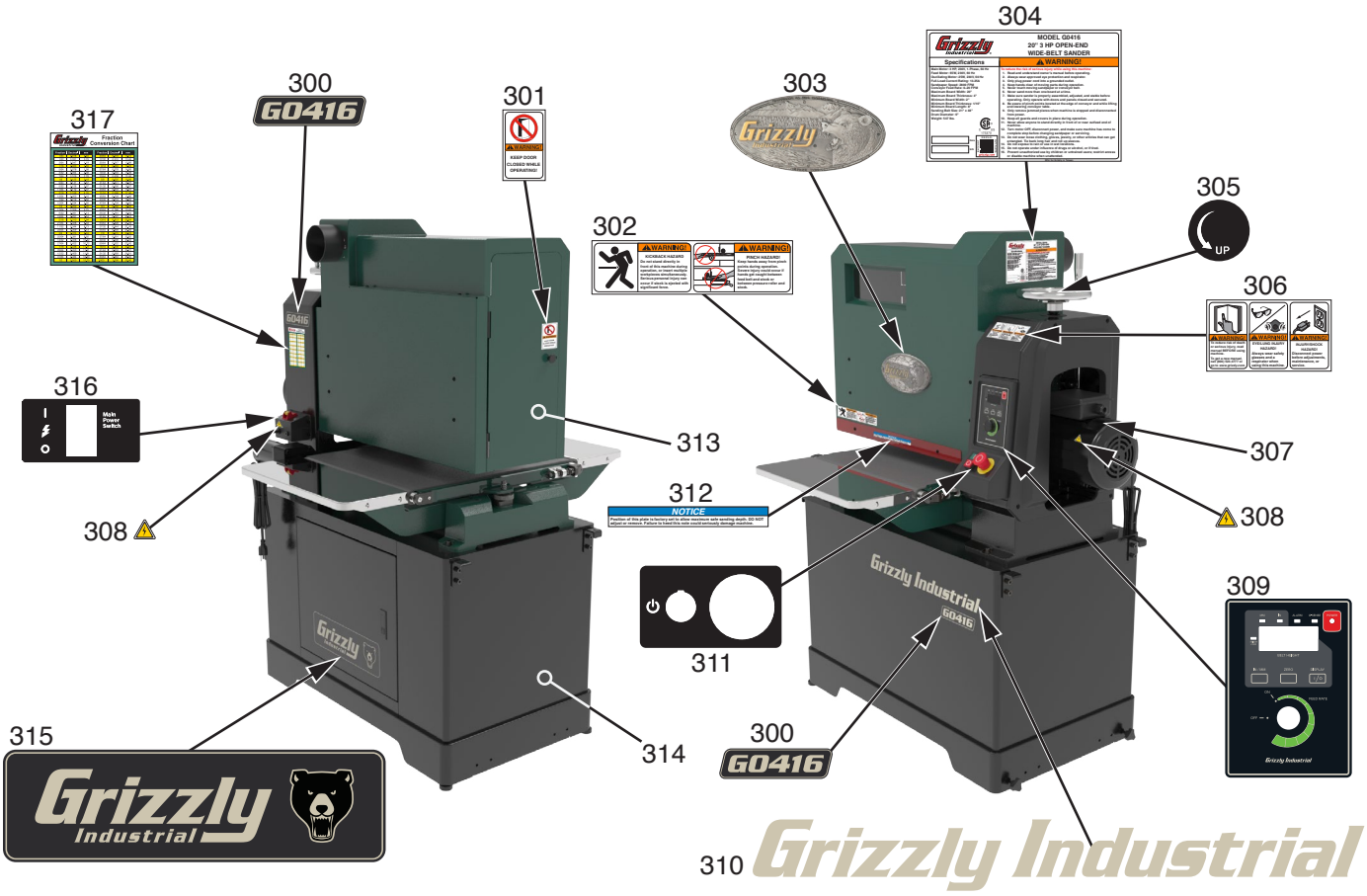
G0416 Base



REF	PART #	DESCRIPTION
123	P0416123	LOCK WASHER 8MM
191	P0416191	LIFTING HOOK
229	P0416229	CAP SCREW M8-1.25 X 20
231	P0416231	DOOR LATCH
232	P0416232	CABINET DOOR
233	P0416233	CUSHION STRIP 16.5 X .5"

REF	PART #	DESCRIPTION
234	P0416234	CABINET
236	P0416236	WHEEL 10.4 X 75 X 33.5MM
237	P0416237	HEX BOLT M10-1.5 X 60
238	P0416238	ADJUSTABLE FOOT M8-1.25 X 26
239	P0416239	KNOB BOLT M10-1.5 X 22
270	P0416270	LOCK NUT M10-1.5

G0416 Labels & Cosmetics



REF	PART #	DESCRIPTION
300	P0416300	MODEL NUMBER LABEL
301	P0416301	DOOR CLOSED LABEL
302	P0416302	COMBO HAZARD LABEL
303	P0416303	GRIZZLY NAMEPLATE
304	P0416304	MACHINE ID LABEL
305	P0416305	HANDWHEEL DIRECTION LABEL
306	P0416306	COMBO READ MANUAL LABEL
307	P0416307	MOTOR LABEL
308	P0416308	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
309	P0416309	CONTROL PANEL LABEL
310	P0416310	GRIZZLY INDUSTRIAL LABEL
311	P0416311	ON/OFF SWITCH LABEL
312	P0416312	NOTICE SAFETY PLATE LABEL
313	P0416313	TOUCH-UP PAINT, GRIZZLY GREEN
314	P0416314	TOUCH-UP PAINT, GLOSSY BLACK
315	P0416315	GRIZZLY IND W/ BEAR HD LABEL
316	P0416316	REAR CONTROL BOX NAMEPLATE
317	P0416317	FRACTION CONVERSION LABEL

⚠WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.

WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

In the event you need to use this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

For further information about the warranty, visit **https://www.grizzly.com/forms/warranty** or scan the QR code below to be automatically directed to our warranty page.