MODEL G0866
37" WIDE BELT SANDER
w/INDUSTRIAL ROLLER
OWNER'S MANUAL
(For models manufactured since 11/18)

COPYRIGHT © MARCH, 2021 BY GRIZZLY INDUSTRIAL, INC.
WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.
#CS20266 PRINTED IN TAIWAN V1.03.21

⚠ 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 2
- Contact Info 2
- Manual Accuracy 2
- Identification 3
- Controls & Components 4
- Machine Data Sheet 7

SECTION 1: SAFETY 10
- Safety Instructions for Machinery 10
- Additional Safety for Wide Belt Sanders 12

SECTION 2: POWER SUPPLY 13
- Converting Voltage to 440V 15

SECTION 3: SETUP 18
- Needed for Setup 18
- Unpacking 18
- Inventory 19
- Cleanup 20
- Site Considerations 21
- Lifting & Placing 22
- Leveling 23
- Anchoring to Floor 23
- Assembly 24
- Dust Collection 26
- Power Connection 27
- Test Run 29

SECTION 4: OPERATIONS 31
- Operation Overview 31
- Sanding Workpieces 32
- Workpiece Inspection 33
- Sanding Tips 34
- Installing/Changing Sanding Belts 35
- Adjusting Platen 36
- Changing Feed Rate 37
- Reading Amp Load Meters 38
- Using EMERGENCY STOP! Plate 38

SECTION 5: ACCESSORIES 39

SECTION 6: MAINTENANCE 41
- Schedule 41
- Cleaning & Protecting 41
- Lubrication 41
- Emptying Dust and Water Traps 43
- Cleaning Sanding Belt 44
- Pneumatic System 44

SECTION 7: SERVICE 45
- Troubleshooting 45
- Calibrating Digital Display 48
- Adjusting Belt Tracking Limit Switches 48
- Adjusting Oscillation Timing & Speed 49
- Servicing Platen 51
- Checking/Replacing Brake Pads 52
- Checking/Adjusting Table Parallelism 55
- Checking/Adjusting Pressure Rollers 58
- Checking/Adjusting V-Belt Tension 59
- Changing V-Belts 60
- Adjusting Conveyor Belt Tension 62
- Adjusting Conveyor Belt Tracking 63
- Replacing Conveyor Belt 64
- Conveyor Belt Removal Sequence 65
- Pneumatic System Diagram 66
- Pneumatic System Component Photos 67

SECTION 8: WIRING 68
- Wiring Safety Instructions 68
- Component Locations 69
- Electrical Overview 70
- Electrical System Wiring Schematic 71
- Electrical Box 72
- Electrical Box Wiring Schematic (220V) 73
- Electrical Box Wiring Schematic (440V) 74
- Main Motor Wiring 75
- Table Elevation & Feed Motor Wiring 76
- Control Panel & Meters Wiring 77
- Limit Switches & Sensors Wiring 78
- Air Pressure Limit Switch Wiring 79

SECTION 9: PARTS 80
- Tool Box & Accessories 80
- Sanding Motor System 81
- Table Lift System 83
- Conveyor System 85
- Feed Roller 86
- Sanding Drum 87
- Upper Roller System 89
- Cabinet Assembly 91
- Main Wiring Panel & Controls 92
- Belt Oscillation System 94
- Labels & Cosmetics 96

WARRANTY & RETURNS 97

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

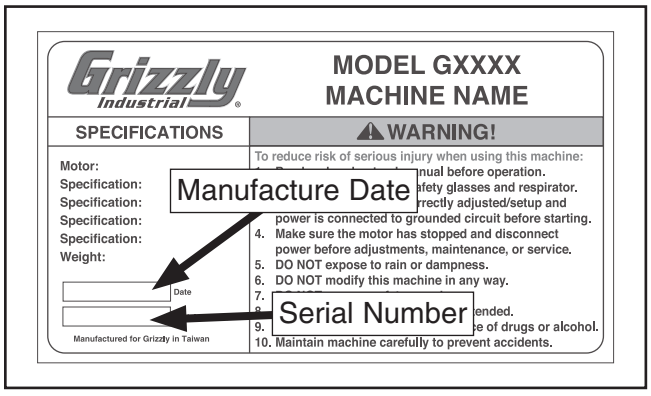
Manual Accuracy

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**.

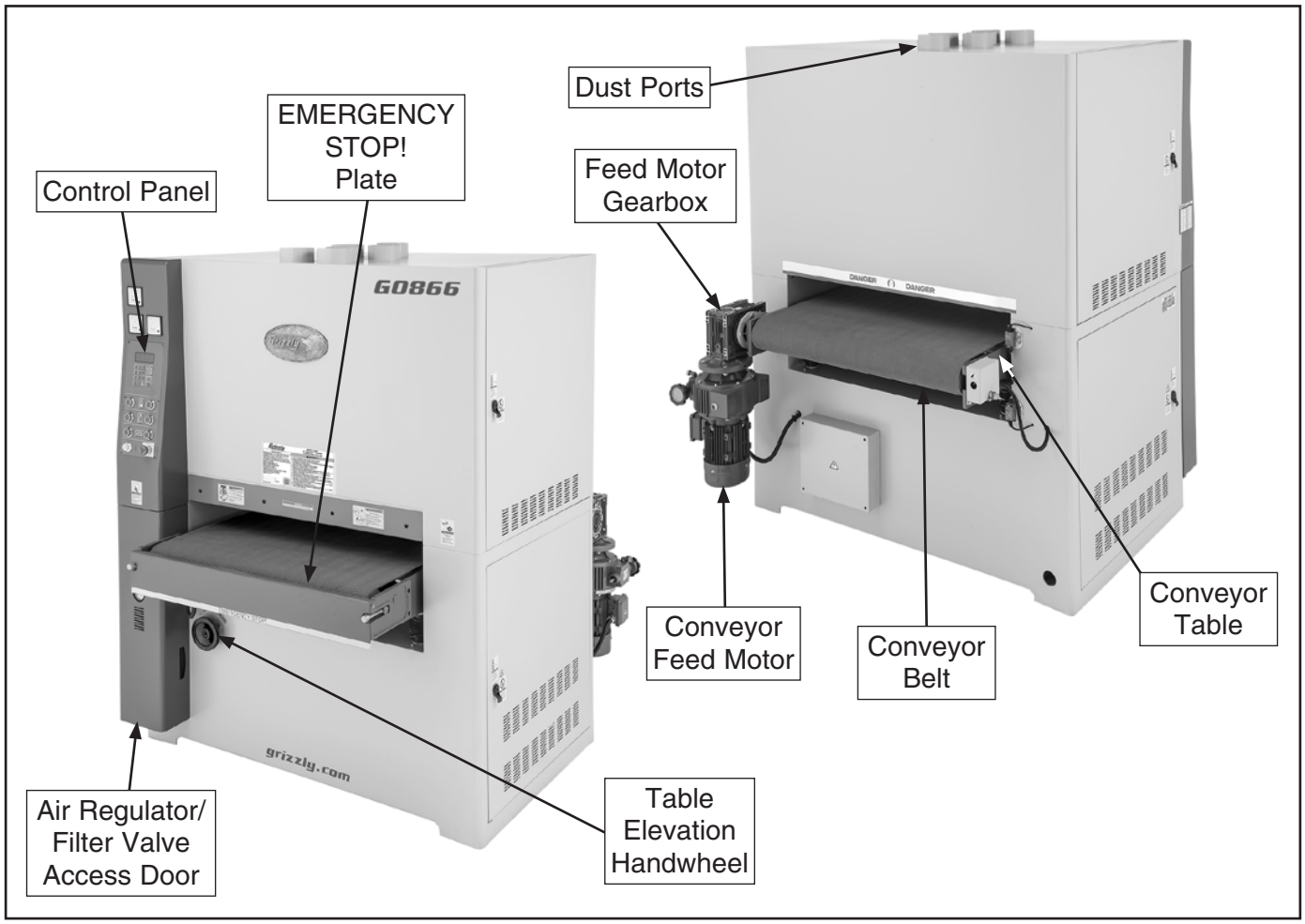
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

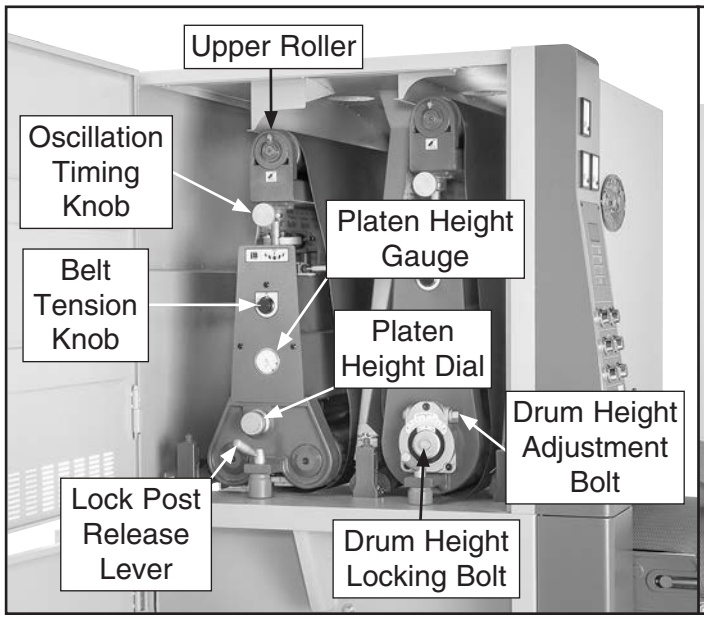
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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

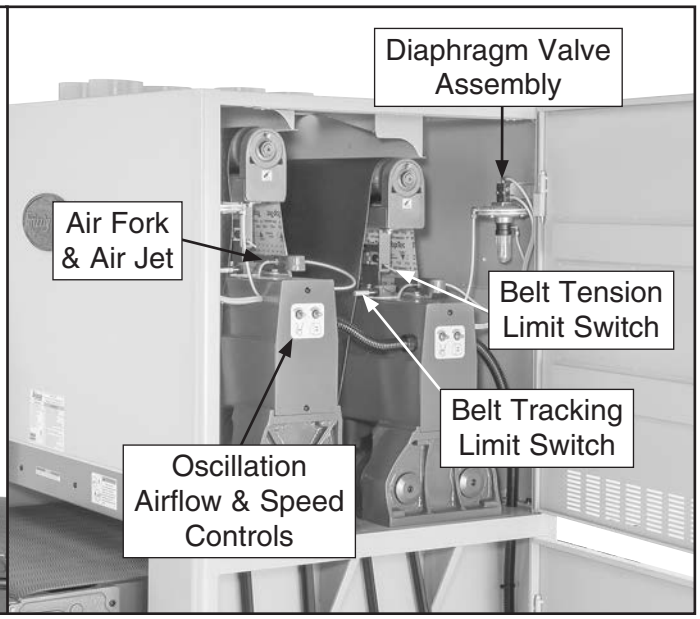


Identification

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

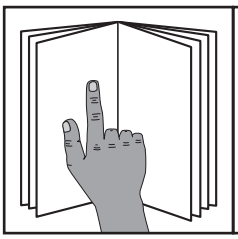






Controls & Components

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.

Meters

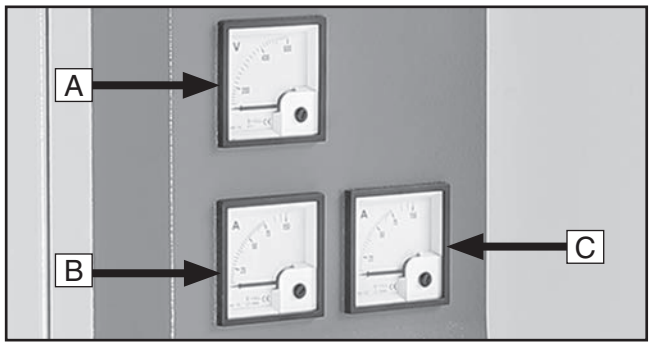


Figure 1. Amp and volt meters.

A. Volt Meter: Indicates voltage when a sanding operation is in progress.

B. Front Sanding Belt Amp Meter: Indicates amp load on the front sanding belt motor when a sanding operation is in progress.

C. Rear Sanding Belt Amp Meter: Indicates amp load on the rear sanding belt motor when a sanding operation is in progress.

Control Panel

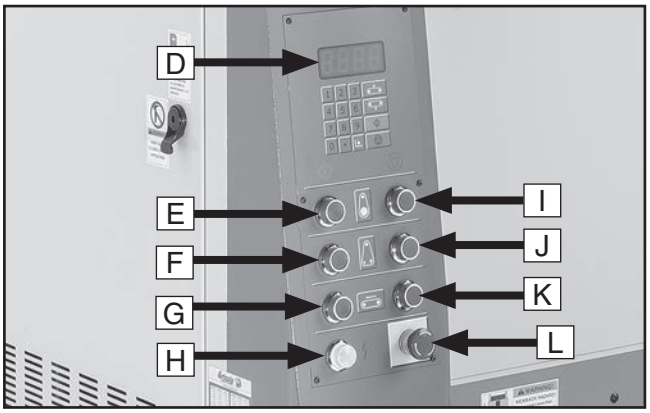


Figure 2. Control panel components.

D. Digital Display and Numerical Key Pad: Shows and sets table position in relation to drums (i.e., workpiece thickness).

E. Front Sanding Belt Start Button: Turns front sanding belt motor ***ON*** and illuminates when pressed.

F. Rear Sanding Belt Start Button: Turns rear sanding belt motor ***ON*** and illuminates when pressed.

G. Conveyor Belt Start Button: Turns feed motor ***ON*** and illuminates when pressed.

H. Power Indicator: Illuminates when machine is connected to power.

I. Front Sanding Belt Stop Button: Turns front sanding belt motor ***OFF*** when pressed.

J. Rear Sanding Belt Stop Button: Turns rear sanding belt motor ***OFF*** when pressed.

K. Conveyor Belt Stop Button: Turns feed motor ***OFF*** when pressed.

L. Emergency Stop Button: Turns all machine functions ***OFF*** when pressed; engages emergency brake to stop rotation of sanding drums. Twist clockwise to reset in order to start sander again.

Feed Rate Adjustment Knob

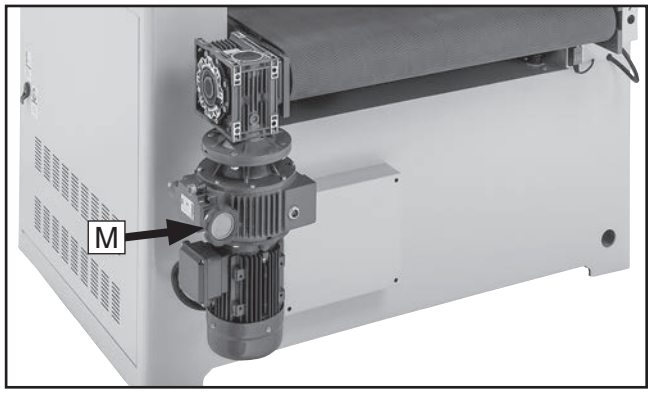


Figure 3. Feed rate adjustment knob location.

M. Feed Rate Adjustment Knob: While conveyor is moving, turn knob clockwise to speed up feed rate, and turn it counterclockwise to slow it down.

Table

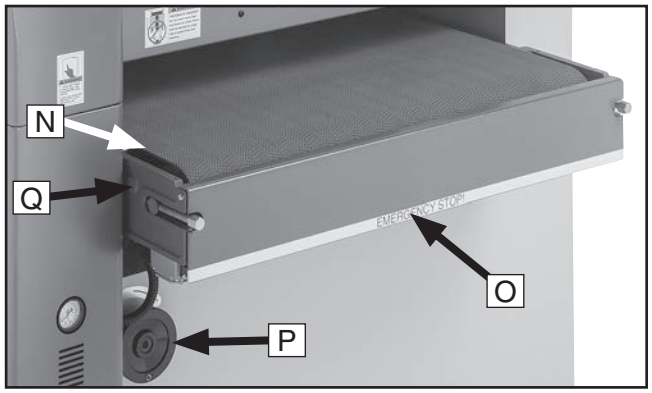


Figure 4. Table components.

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

O. EMERGENCY STOP! Plate: Stops all machine functions when pressed; engages emergency brake to stop rotation of sanding drums.

P. Table Elevation Handwheel: Manually raises and lowers conveyor table. Rotate clockwise to lower table; rotate counterclockwise to raise table. One full rotation moves the table approximately 0.20".

Q. Conveyor Table: Supports workpiece during operations; can be raised and lowered according to workpiece thickness.

Digital Controls

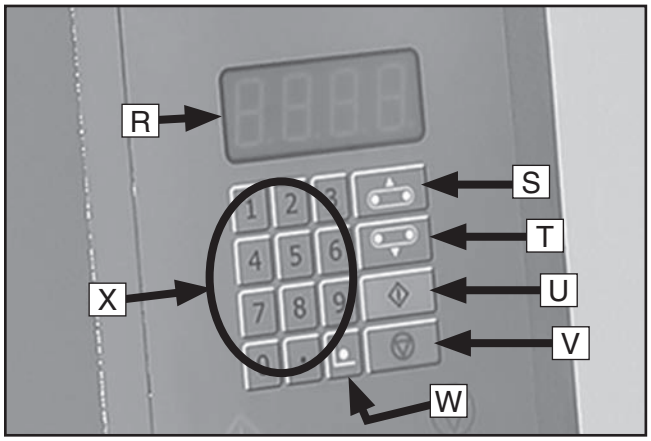


Figure 5. Digital table height key pad.

R. Digital Display: Shows current table position in relation to sanding drum (i.e., workpiece thickness).

S. Table Up Key : Raises table by 0.005" (0.125mm) increments.

T. Table Down Key : Lowers table by 0.005" (0.125mm) increments.

U. Table Start Key : Activates inputted table height/workpiece thickness.

V. Table Stop Key : Immediately stops table from moving up and down and cancels key pad entry.

W. Set Key : Calibrates table position (when pressed with Table Stop Key) and switches between standard/metric display.

X. Numerical Key Pad: Sets table height/workpiece thickness.

Platen

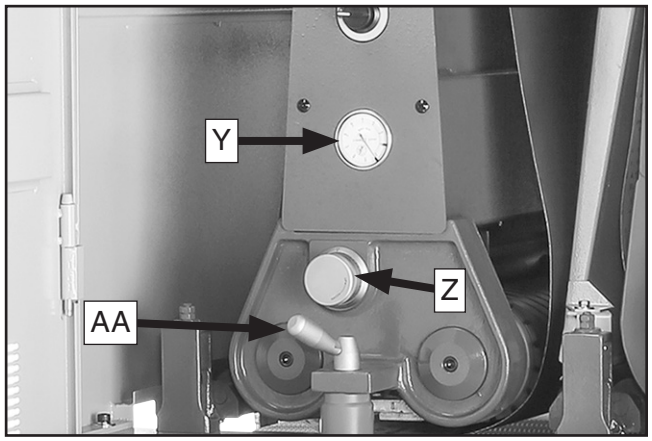


Figure 6. Platen height controls.

Y. Platen Height Gauge: Indicates height of platen above or below sanding drums.

Z. Platen Height Dial: Adjusts platen height for three basic types of sanding: the initial heavy sanding pass, the intermediate finishing pass, and the final sanding pass.

AA. Lock Post Release Lever: Unlocks to release spacer block that holds platen and sanding belt in place.

Belt Oscillation & Tension

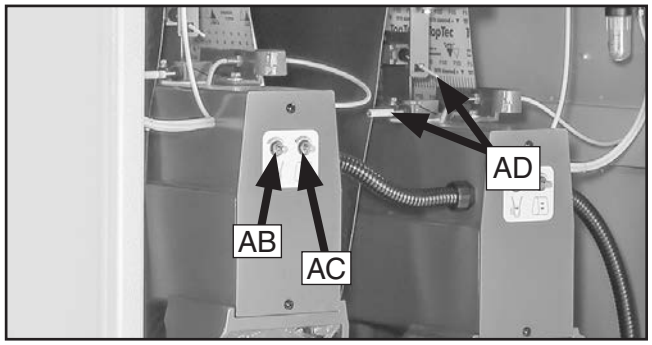


Figure 7. Oscillation and tension components on right side.

AB. Oscillation Airflow Adjustment Knob: Controls amount of airflow to pneumatic cylinder.

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

AD. Belt Limit Switches: Stop sanding drum motor if sanding belt tension or tracking is incorrect.

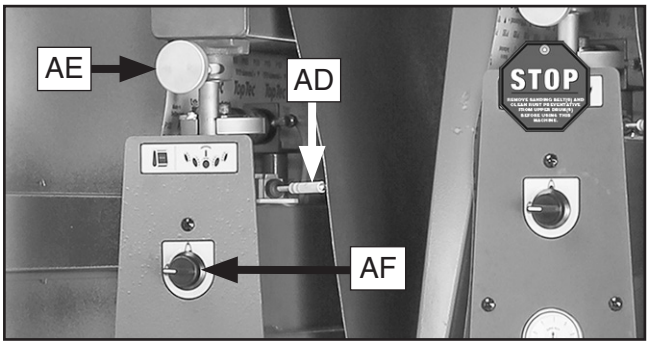


Figure 8. Oscillation and tension components on left side.

AD. Belt Limit Switches: Stop sanding drum motor if sanding belt tension or tracking is incorrect.

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

AF. Belt Tension Knob: Increases or decreases sanding belt tension.

Air Regulation

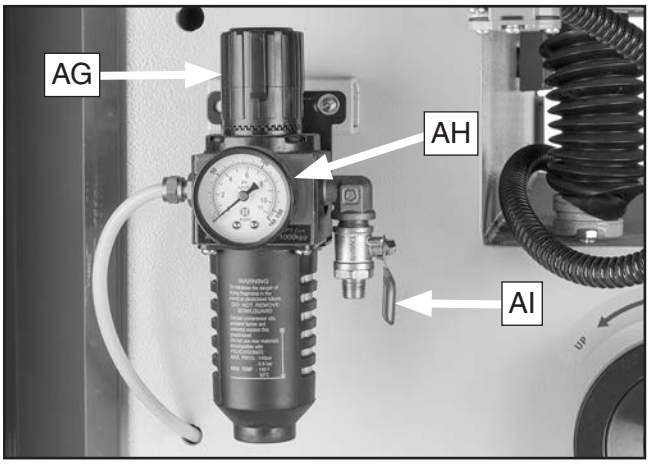


Figure 9. Air pressure regulator location.

AG. Air Regulator Knob: Adjusts incoming air pressure. Lift knob to rotate right/left to increase/decrease PSI shown on air regulator gauge.

AH. Air Regulator Gauge: Displays air pressure entering pneumatic system. Use air regulator knob to adjust pressure until gauge reads approximately 75 PSI.

AI. Air Inlet: Connects to compressed air supply of 75 PSI with a $^{5}/_{16}$" air hose. Regulates incoming air pressure for sanding belt oscillation when handle is in open position.

MACHINE DATA SHEET

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

MODEL G0866 37" 15 HP WIDE-BELT SANDER WITH INDUSTRIAL ROLLER

Product Dimensions:

Weight..... 3417 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 59 x 65 x 75 in.
Footprint (Length x Width)..... 37 x 57 in.
Space Required for Full Range of Movement (Width x Depth)..... 121 x 65 in.

Shipping Dimensions:

Type..... Wooden Crate
Content..... Machine
Weight..... 3968 lbs.
Length x Width x Height..... 72 x 63 x 85 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
Prewired Voltage..... 220V
Full-Load Current Rating..... 79.8A at 220V, 40.5A at 440V
Minimum Circuit Size..... 100A at 220V, 50A at 440V
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Switch Type..... Control Panel w/Magnetic Switch Protection
Voltage Conversion Kit..... G440VG0866

Motors:

Main Front

Horsepower..... 15 HP
Phase..... 3-Phase
Amps..... 36.7A/18.4A
Speed..... 1760 RPM
Type..... AEEF Induction
Power Transfer ..... Twin V-Belt
Bearings..... Sealed & Permanently Lubricated

Main Rear

Horsepower..... 15 HP
Phase..... 3-Phase
Amps..... 36.7A/18.4A
Speed..... 1760 RPM
Type..... AEEF Induction
Power Transfer ..... Triple V-Belt
Bearings..... Sealed & Permanently Lubricated

Feed

Horsepower..... 2 HP
Phase..... 3-Phase
Amps..... 6.4A/3.7A
Speed..... 1680 RPM
Type..... Induction
Power Transfer ..... Gear
Bearings..... Sealed & Permanently Lubricated

Table Elevation

Horsepower	1/4 HP
Phase	3-Phase
Amps	1.2A/0.6A
Speed	1650 RPM
Type	AEEF Induction
Power Transfer	Belt & Gear
Bearings	Sealed & Permanently Lubricated

Main Specifications:

Operation Information

Number of Sanding Heads	2
Maximum Board Width	36-1/2 in.
Minimum Board Width	2 in.
Maximum Board Thickness	6 in.
Minimum Board Thickness	3/16 in.
Minimum Board Length	12 in.
Sandpaper Speed	Front 3600, Rear 2800 FPM
Conveyor Feed Rate	7 – 68 FPM
Sandpaper Length	75 in.
Sandpaper Width	37 in.

Drum Information

Infeed Sanding Drum Type	Spiral Grooved Rubber Roller
Infeed Sanding Drum Size	Front 8.7, Rear 5 in.
Outfeed Sanding Drum Type	Steel
Outfeed Sanding Drum Size	5 in.
Shore Hardness (Durometer)	65D

Platen Information

Platen Type	Adjustable Graphite Pad
Platen Length	37-3/4 in.
Platen Width	1-3/4 in.

Construction

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

Other Related Information

Floor To Table Height	32 in.
Belt Tracking	Pneumatic
Sanding Belt Tension	Pneumatic
Number of Pressure Rollers	6
Pressure Roller Type	Rubber
Pressure Roller Size	2 in.
Conveyor Table Length	44-1/4 in.
Conveyor Belt Length	118-1/4 in.
Conveyor Belt Width	36-1/2 in.
Belt Roller Size	6-3/8, 5-7/8, 4-3/4 in.
Number of Dust Ports	6
Dust Port Size	5 in.
Air Requirement	57 – 75 PSI

Other Specifications:

Country of Origin ..... Taiwan
Warranty ..... 1 Year
Approximate Assembly & Setup Time ..... 2 Hours
Serial Number Location ..... Machine ID Label
ISO 9001 Factory ..... Yes

Features:

Dual Drum Motors
Amp Meter Load-Sensing System
Powered Table Elevation
Micro-Adjustable Graphite/Felt Platen
Variable Conveyor Feed Speeds From 7 – 68 FPM
Digital Readout Accurate to Within 0.005"
Six 5" Dust Ports

Accessories Included:

100-Grit and 180-Grit Sanding Belts
Spare Graphite Platen and Felt Pad
Tool Box w/Hex Wrench Set, Platen Removal Tool, Open-End Wrenches

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 clothing, apparel 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.

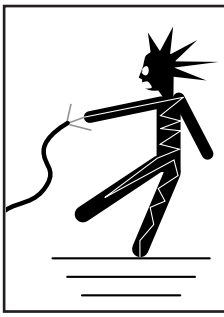
⚠CAUTION

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.

Full-Load Current Rating at 220V .. 79.8 Amps
Full-Load Current Rating at 440V .. 40.5 Amps

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

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

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.*

Circuit Requirements for 220V

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

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

Circuit Requirements for 440V

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

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

Grounding Instructions

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

⚠WARNING

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

Connection Type

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

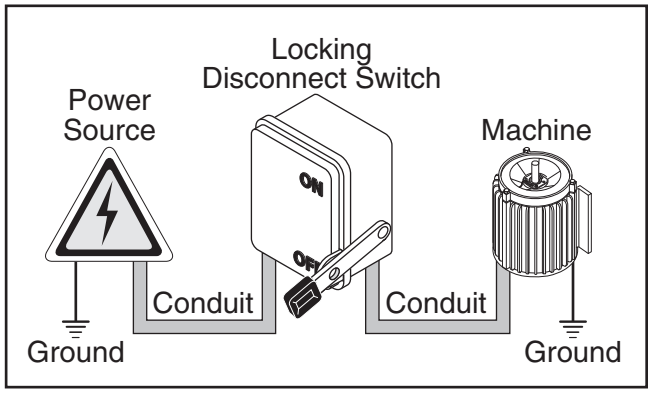


Figure 10. Typical setup of a permanently connected machine.

Extension Cords

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

Voltage Conversion

The voltage conversion MUST be performed by a qualified electrician. To perform the voltage conversion, rewire the motors to the new voltage, according to the provided wiring diagram. *If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor.*

Note About 3-Phase Power: DO NOT use a static phase converter to create 3-phase power—it can quickly decrease the life of electrical components on this machine. If you must use a phase converter, only use a rotary phase converter.

You can find the Model G7978, a compatible phase converter from on our website at **www.grizzly.com**.

G7978—15 HP Rotary Phase Converter

This rotary phase converter allows you to operate 3-phase machinery from a single-phase power source at 100% power and 95% efficiency.

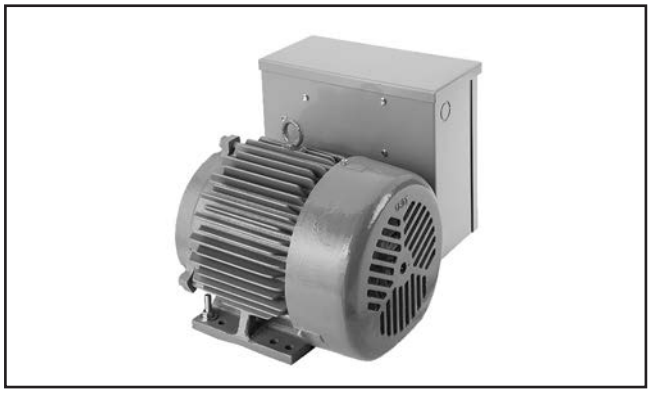


Figure 11. Model G7978 15 HP Rotary Phase Converter.

Converting Voltage to 440V

The Model G0866 is prewired to operate on 220V power, but it can be converted for 440V operation using the optional conversion kit (Model G440VG0866), which contains two replacement overload relays. 440V conversion consists of: 1) disconnecting the machine from the power source, 2) moving a wire on the transformer from the 220V to the 440V terminal, 3) replacing the main and feed motor overload relays, and 4) rewiring the motors for 440V operation. Wiring diagrams are provided in the back of this manual beginning on **Page 75** showing the Model G0866 wired for both 220V and 440V. Refer to these when following this procedure.

All wiring changes must be done by an electrician or qualified service personnel. If, at any time during this procedure assistance is needed, call Grizzly Tech Support at (570) 546-9663.

Items Needed	**Qty**
Phillips Head Screwdriver #2	1
Schneider LRD325 Overload Relays	2
Schneider LR3D08 Overload Relay	1
Wrench or Socket 7, 8, 10mm	1 Ea.

To convert voltage to 440V:

1. DISCONNECT MACHINE FROM POWER!

2. Open lower left access door, then open electrical box (see **Figure 12**).

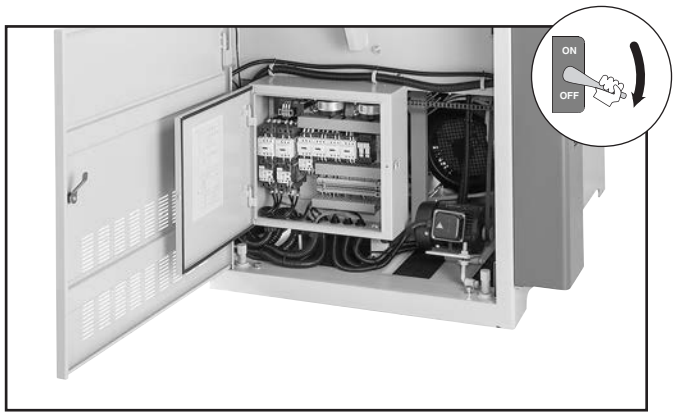


Figure 12. Lower left access and electrical box doors open.

3. Remove wire labeled "1" at 220V terminal of transformer (see **Figure 13**) and connect it to 440V terminal.

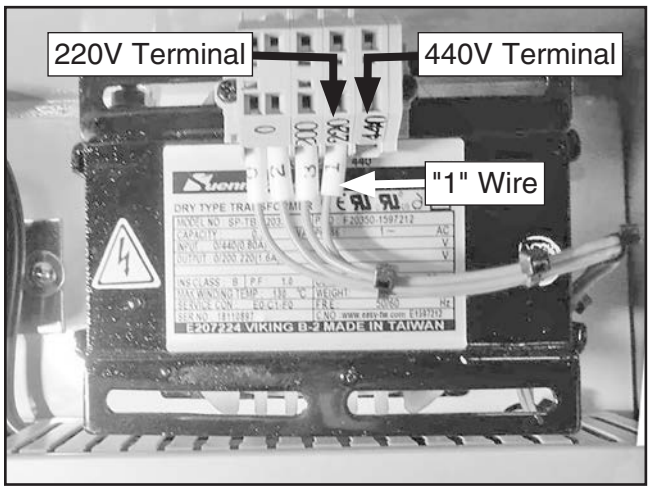


Figure 13. Location of "1" wire and terminals.

4. Remove main front motor overload relay (see **Figure 14**), and replace with Schneider LRD325 (17-25A) overload relay and set dial to 18.4A.

5. Remove main rear motor overload relay (see **Figure 14**), and replace with Schneider LRD325 (17-25A) overload relay and set dial to 18.4A.

6. Remove feed motor overload relay (see **Figure 14**), and replace with Schneider LR3D08 (2.5-4A) overload relay and set dial to 3.7A.

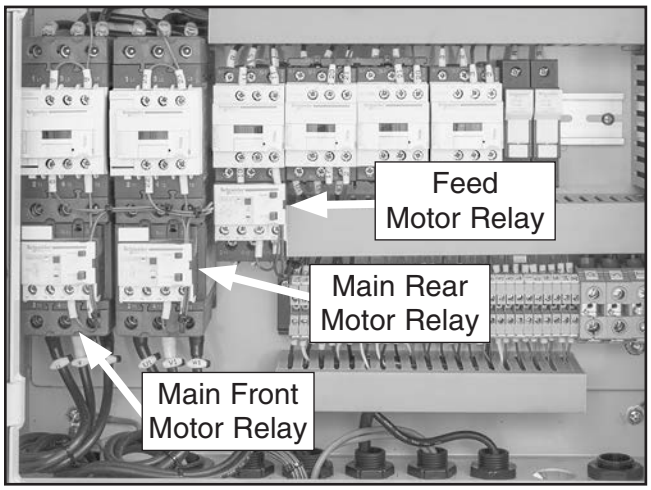


Figure 14. Location of overload relays.

7. Open both main motor junction boxes (see **Figure 15**).

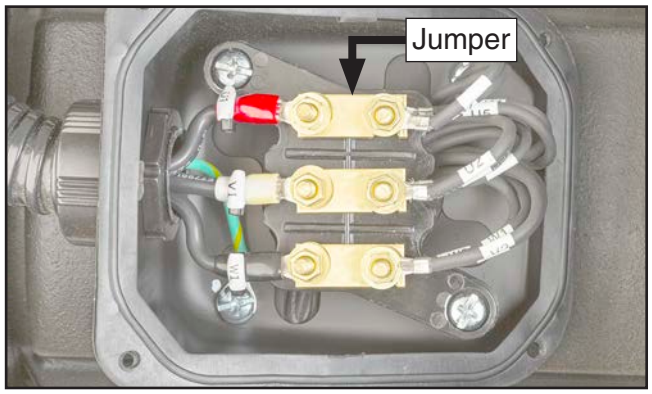


Figure 15. Main rear motor junction box.

8. Remove (3) jumpers from their terminals in each main motor junction box (see **Figure 16**).

9. Disconnect the U5, V5, W5, W6, U6, and V6 wires from their terminals in both main motor junction boxes (see **Figure 16**). Jumpers will not be reused.

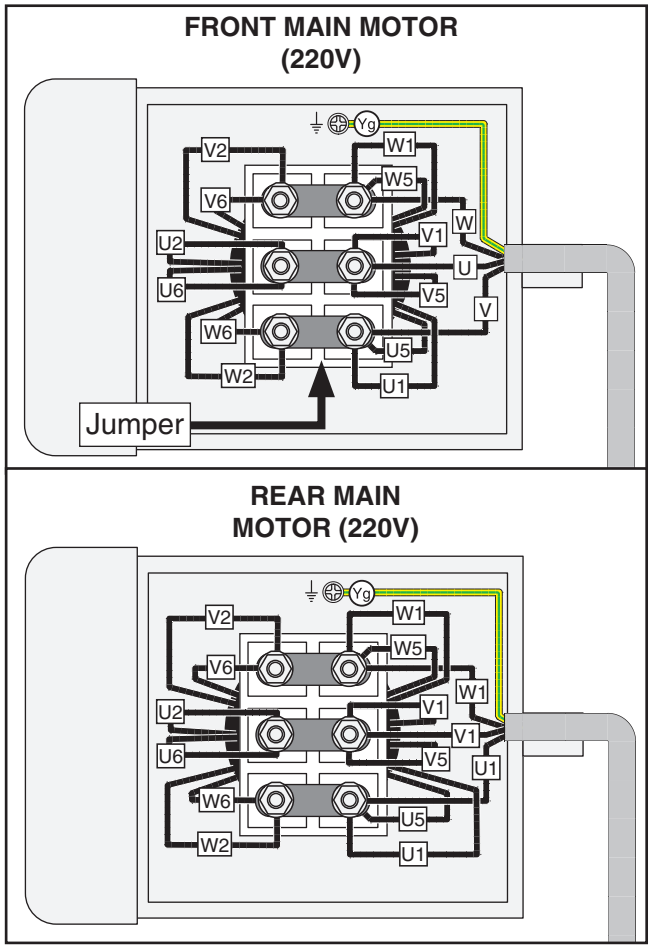


Figure 16. Main motors wired for 220V.

10. Connect wires U5, V5, W5, W6, U6, and V6 as shown in **Figure 17** in both main motor junction boxes.

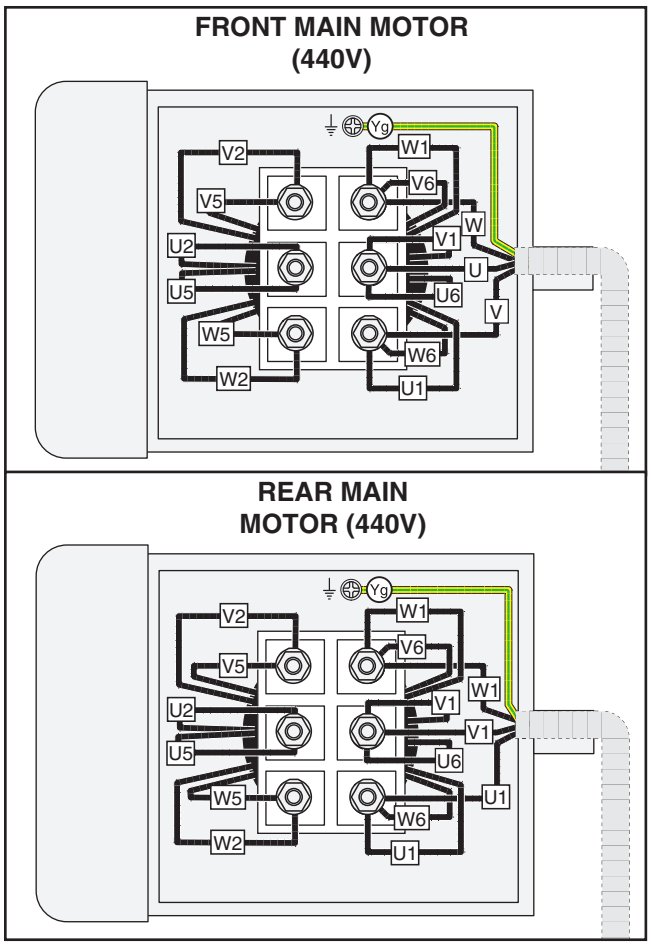


Figure 17. Main motors wired for 440V.

11. Close both main motor junction boxes.

12. Open table elevation motor junction box (see **Figure 18**).

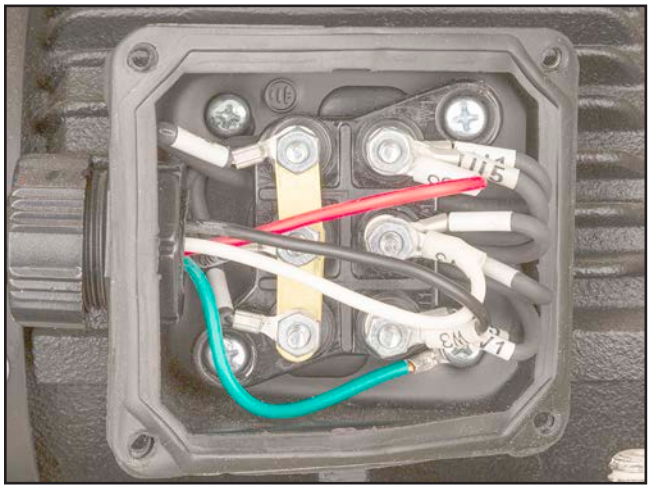


Figure 18. Table elevation motor junction box.

13. Remove (2) jumpers from their terminals (see **Figure 19**). Jumpers will not be reused.

14. Disconnect the U5, V5, and W5 wires from their terminals (see **Figure 19**).

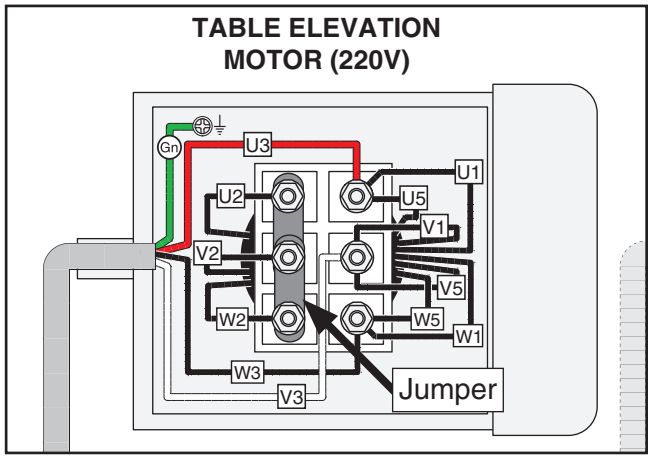


Figure 19. Table elevation motor wired for 220V.

15. Connect wires U5, V5, and W5 as shown in **Figure 20**.

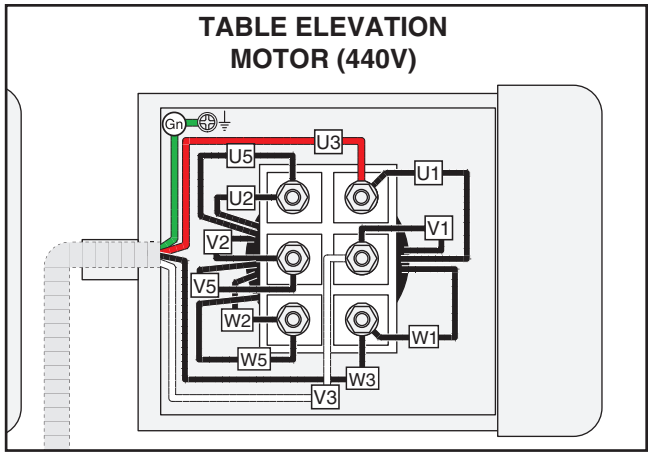


Figure 20. Table elevation motor wired for 440V.

16. Close table elevation motor junction box.

17. Open feed motor junction box (see **Figure 21**).

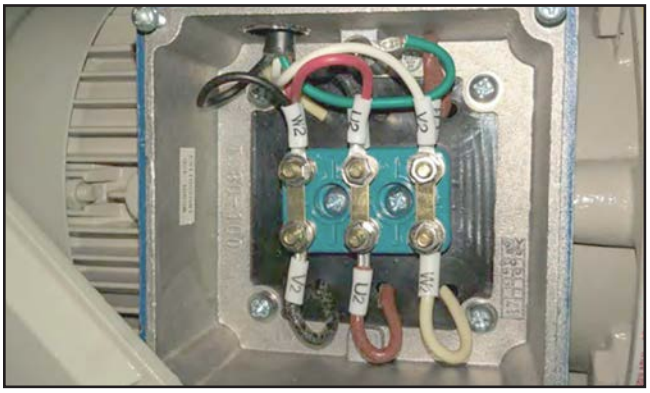


Figure 21. Feed motor junction box.

18. Remove (3) jumpers from their terminals (see **Figure 22**). One jumper will not be reused.

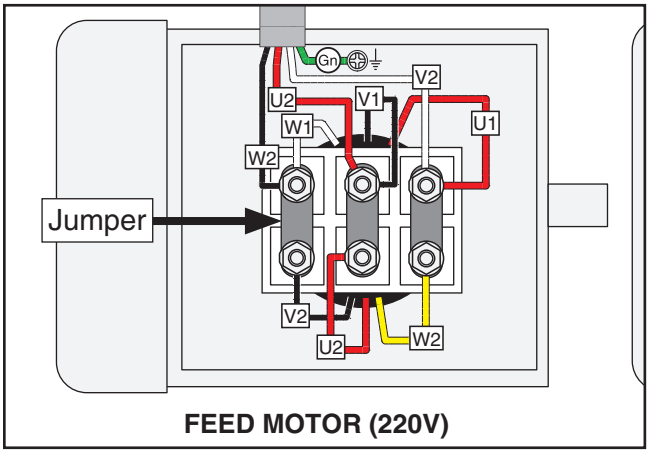


Figure 22. Feed motor wired for 220V.

19. Rearrange jumpers as shown in **Figure 23**.

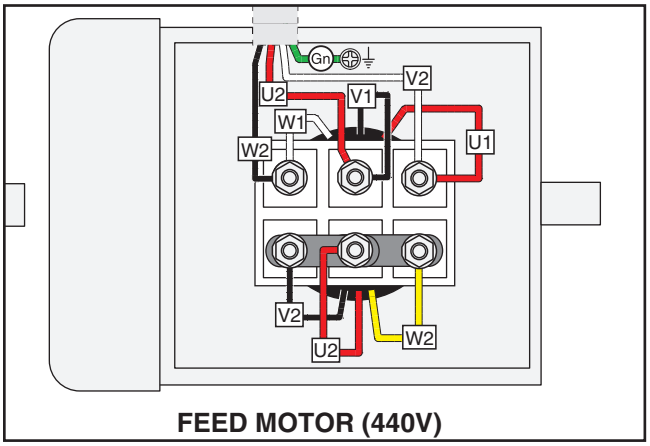
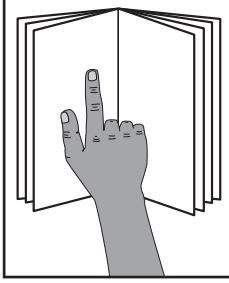


Figure 23. Feed motor wired for 440V.

20. Close feed motor junction box.

21. Close electrical box and lower left access door.

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
• Solvent/Cleaner	As Needed
• Shop Rags	As Needed
• Disposable Gloves	As Needed
• Lifting Equipment (Rated for at least 4000 lbs.)	1
• Machinist's Precision Level	1
• Floor Mounting Hardware	As Needed
• 42" Long 2x4	1
• Dust Hoses 5"	6
• Dust Hose Clamps 5"	6
• Dust Collection System	1
• Air Compressor (Minimum Rating 75 PSI)	1
• Compressed Air Hose $^{5}/_{16}$"	1
• Hose Clamp $^{5}/_{16}$"	1
• Gearbox Oil	As Needed

Unpacking

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

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

Inventory

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

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

NOTICE

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

Box Contents (Figure 24)	Qty
A. Flat Head Screwdriver #2	1
B. Phillips Screwdriver #2	1
C. Sanding Belt 37" x 75" 100-Grit	1
D. Sanding Belt 37" x 75" 180-Grit	1
E. Platen Removal Tool	1
F. Roller Extraction Bolt	1
G. Graphite Pads	2
H. Felt Pad	1
I. Limit Switch Tips	2
J. Combo Wrench 26mm	1
K. Open-End Wrench 21 x 23mm	1
L. Open-End Wrench 17 x 19mm	1
M. Open-End Wrench 12 x 14mm	1
N. Open-End Wrench 8 x 10mm	1
O. Hex Wrench Set (1.5–10mm)	1
P. Flexible Grease Gun Extension	1
Q. Door Keys	2
R. Tool Box (Not Pictured)	1

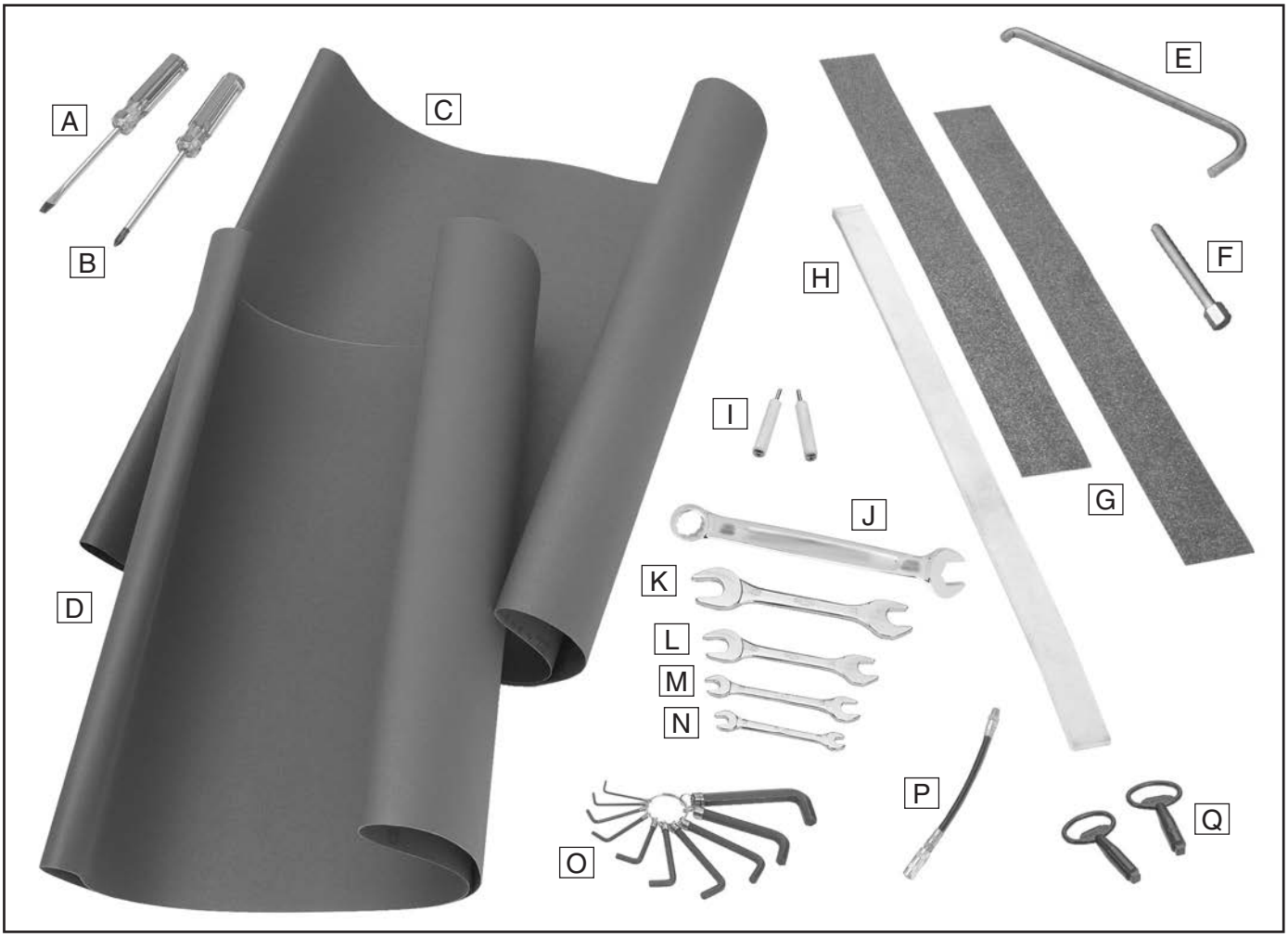


Figure 24. Loose item inventory.

Cleanup

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

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

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

Before cleaning, gather the following:
- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

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

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

⚠WARNING

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

⚠CAUTION

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

NOTICE

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

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Figure 25. T23692 Orange Power Degreaser.

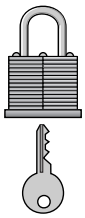
Site Considerations

Weight Load

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

Space Allocation

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



⚠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.

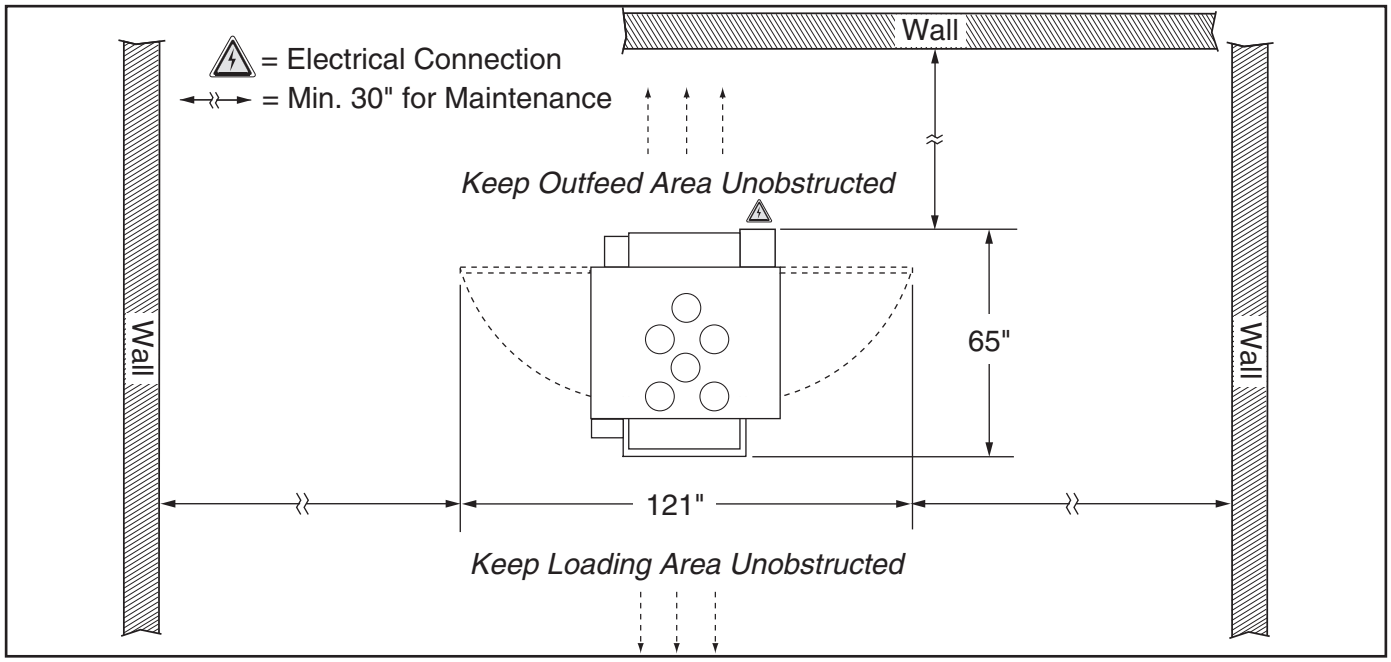
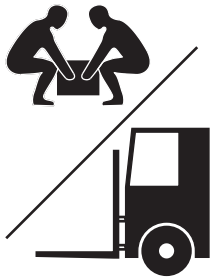


Figure 26. Minimum working clearances.

Lifting & Placing



⚠WARNING

HEAVY LIFT!

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

Do not attempt to lift or move this machine without using the proper lifting equipment (such as forklift or crane). Each piece of lifting equipment must be rated for at least 5000 lbs. to support dynamic loads that may be applied while lifting. Refer to **Needed for Setup** on **Page 18** for complete list of needed equipment for setup and installation.

To lift and move machine:

1. Remove shipping crate top and sides, then remove small components from shipping pallet.

2. Move machine to its prepared location while it is still attached to shipping pallet.

3. Open lower access panels and remove (4) lag screws and flat washers that secure machine to pallet (see **Figure 27**), then close panels.

   Note: *The holes these fasteners are removed from will later be used to anchor machine to floor.*

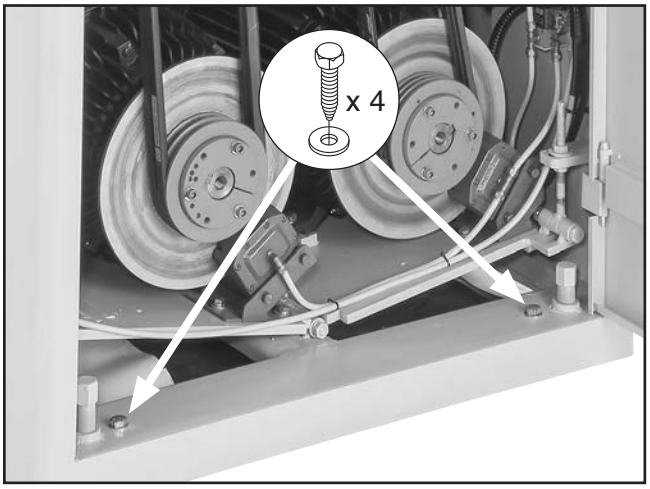


Figure 27. Mounting hardware and leveling bolts (right side shown).

4. Carefully place forklift forks under sander (see **Figure 28**).

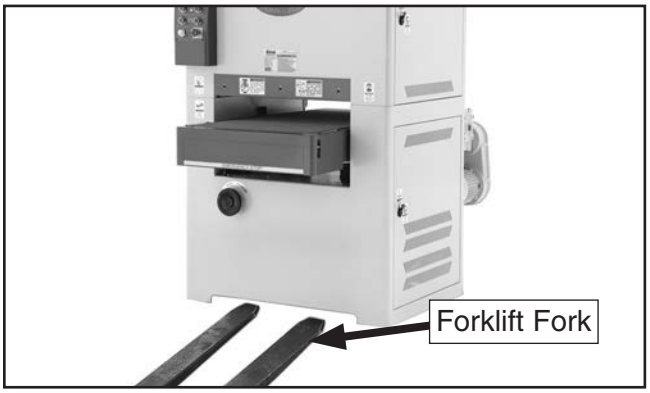


Figure 28. Example of lifting machine with forklift example.

5. Lift sander off pallet, remove pallet, then slowly lower sander into position.

Leveling

NOTICE

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

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

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

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

For best results, use a precision level that is at least 12" long and sensitive enough to show a distinct movement when a 0.003" shim (approximately the thickness of one sheet of standard newspaper) is placed under one end of the level.

To level machine:

1. Open lower access panels and use (2) leveling bolts in each lower cabinet to level machine (see **Figure 29**).

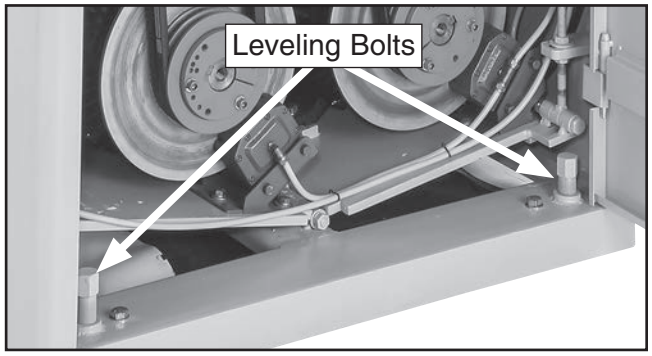


Figure 29. Leveling bolt locations.

2. Close access panels.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... ½"

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

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

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

Anchoring to Concrete Floors

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

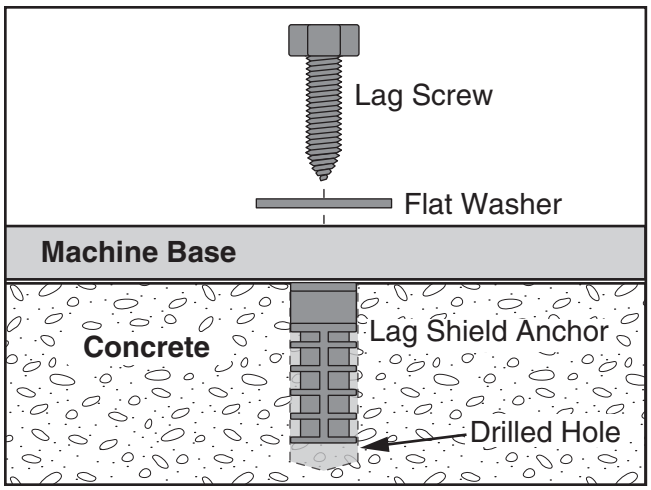


Figure 30. Popular method for anchoring machinery to a concrete floor.

Assembly

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

Assembly of the Model G0866 consists of installing the air line and the sanding belt, and verifying the factory-set pressure roller settings.

To assemble machine:

1. Connect compressed air line to air inlet on regulator (see **Figure 31**) and secure with hose clamp.

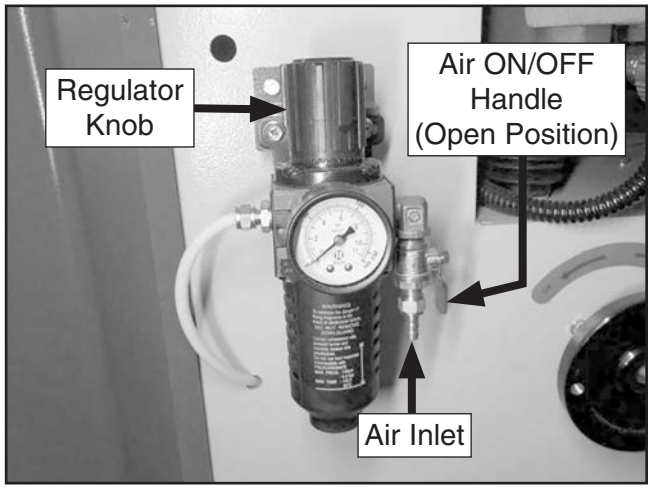


Figure 31. Air regulator inlet and ON/OFF handle.

2. Start air compressor or open air valve at compressor.

3. Make sure red ON/OFF handle on regulator is in open position (see **Figure 31**).

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

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

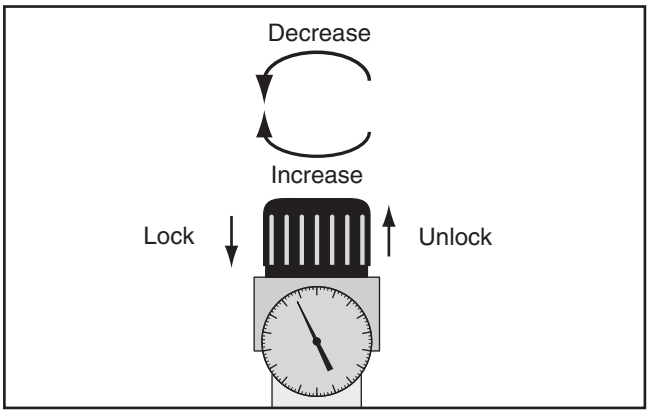


Figure 32. Regulator knob.

5. Push knob down until it snaps to lock knob.

6. With machine connected to air, open left door and turn belt tension knob to detensioned position (see **Figure 33**).

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

8. Remove spacer block (see **Figure 33**).

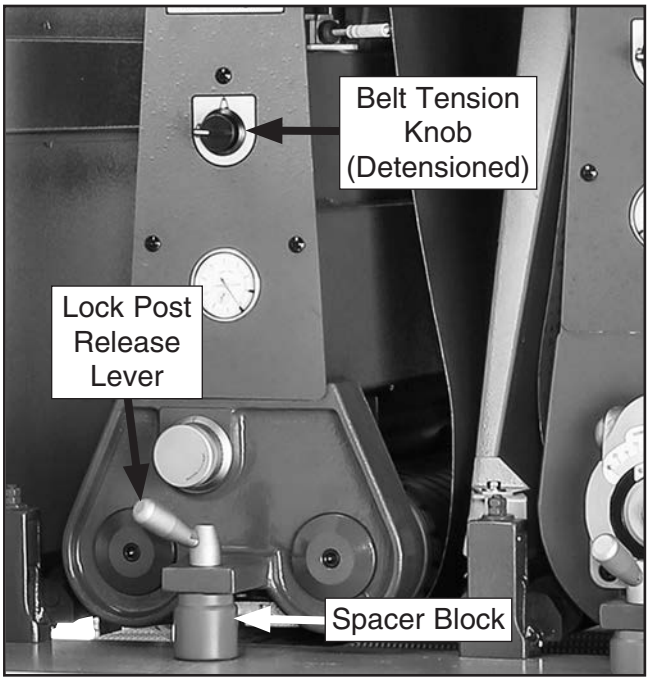


Figure 33. Components used when installing a sanding belt.

NOTICE

Directional arrows on back of sanding belt must be pointing in a counterclockwise direction during installation. Failure to install sanding belt correctly will result in damage to sanding belt.

9. Install sanding belt on upper roller and lower roller, starting with upper, making sure rotation arrows on sanding belt point in same direction as those shown in **Figure 34**.

Note: *Sanding belt must be centered between limit switch tips, and edge of sanding belt must be between tongs of belt oscillation controller fork, as shown in* ***Figures 34–35****. Damage to sanding belt and sander may occur if sander is tensioned and turned* ***ON*** *before sanding belt is correctly positioned.*

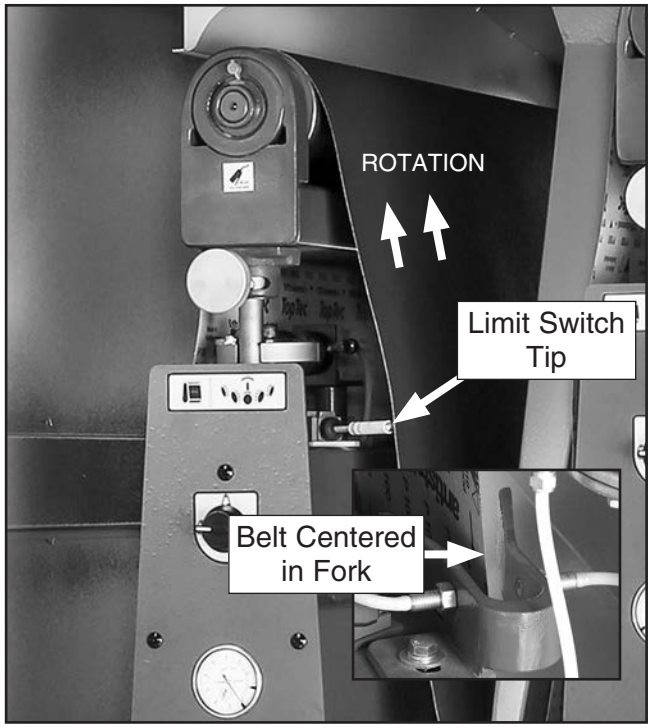


Figure 34. Sanding belt placement components.

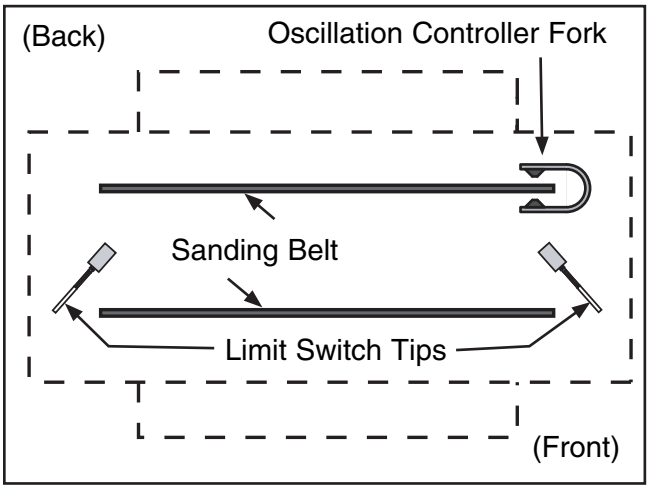


Figure 35. Sander outline (top view) of proper position of belt.

10. Replace spacer block and lock post release lever.

11. With hands clear of all moving parts, turn belt tension knob to 12 o'clock position to tension belt.

12. Repeat **Steps 6–11** with second sanding belt and drum.

⚠WARNING

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

13. Joint 42" 2x4 so one side is flat, then use flat side against table saw fence to cut opposite side of workpiece parallel.

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

14. Place 2x4 across one side of conveyer table so it spans both front and rear pressure rollers (see **Figure 36**).

Figure 36. 2x4 positioned to check pressure roller height.

15. Manually raise conveyer table and verify that board touches both pressure rollers before touching sanding belt.

16. Repeat **Steps 14–15** on other side of conveyor belt.

    Note: *If board did not touch both pressure rollers before touching sanding belt on either side, or if board was difficult to place between rollers and table, then pressure rollers MUST be adjusted before operation. See* ***Page 58*** *for instructions.*

17. Check sight glass shown in **Figure 37** to make sure gear oil is present.

Figure 37. Sight glass location on gearbox.

— If gearbox oil level is below sight glass level, refer to **Lubrication** on **Page 43** to add gear oil.

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 for Model G0866: 3600 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 a 5" dust hose over each dust port, and secure them in place with hose clamps (see **Figure 38**).

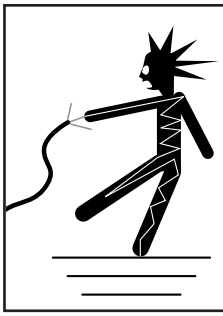
Figure 38. Dust hoses attached to dust ports.

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

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

Power Connection

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



⚠WARNING

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

⚠WARNING

We do not recommend connecting this machine to a phase converter to supply 3-Phase power as it could damage or decrease the life of sensitive electrical components.

NOTICE

The Model G0866 is prewired for 220V. If you plan to operate machine at 440V, you must refer to instructions on Page 15.

Connecting Power Supply Wires

⚠WARNING

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

To connect power supply wires to machine:

1. DISCONNECT POWER SUPPLY WIRES OR LOCK DISCONNECT SWITCH BOX IN OFF POSITION!

2. Open lower left access and electrical box doors.

3. Insert incoming power conduit through hole in back of machine shown in **Figure 39**, then through strain relief in electrical box.

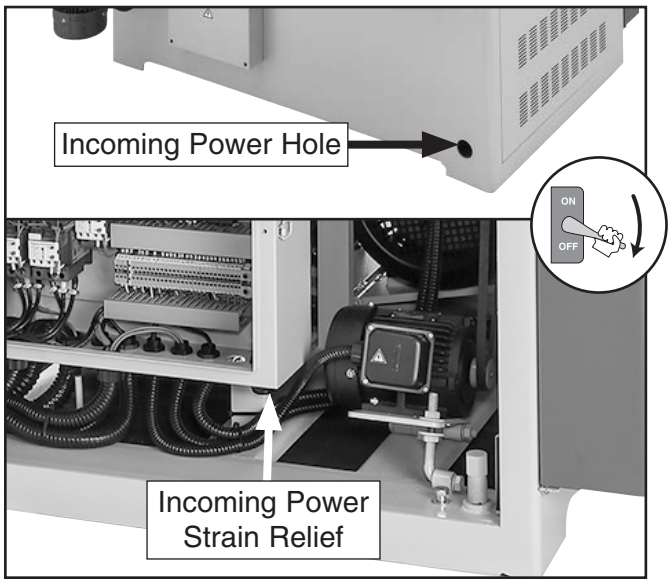


Figure 39. Power supply insertion locations.

⚠WARNING

During next step, make sure incoming ground wire is connected to correct terminal to ensure machine will be properly grounded (see "Ground Terminal" in Figure 40). An ungrounded or improperly grounded machine can cause electrocution if live electrical wires make contact with frame or other parts touched by operator.

4. Connect ground wire to bottom of ground terminal "E", then connect incoming power wires to bottom "R", "S", and "T" terminals shown in **Figure 40**. If using a phase converter, connect wild wire to "T" terminal.

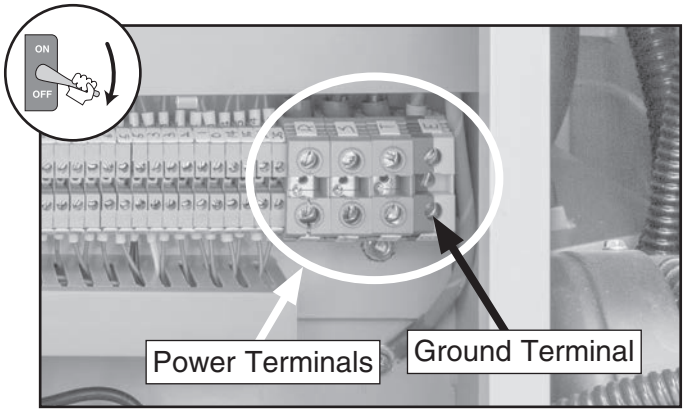


Figure 40. Ground and power wire terminals.

— Make sure wires have enough slack inside electrical box so they are not pulled tight or stretched.

5. Close electrical box and lower left access door, then proceed to **Test Run** (refer to **Page 29)**.

⚠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.

Connecting to Power Source

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

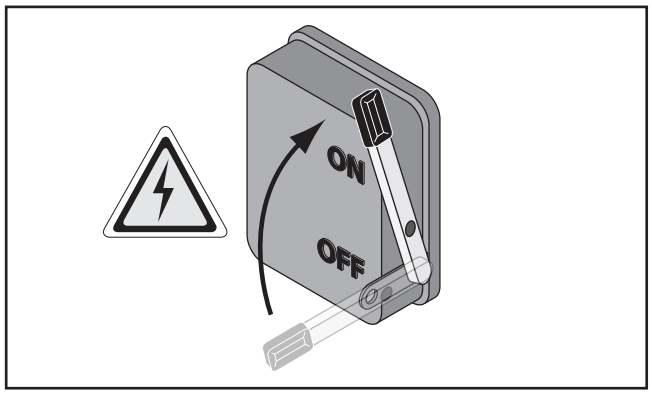


Figure 41. Connecting power to machine.

Disconnecting from Power Source

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

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

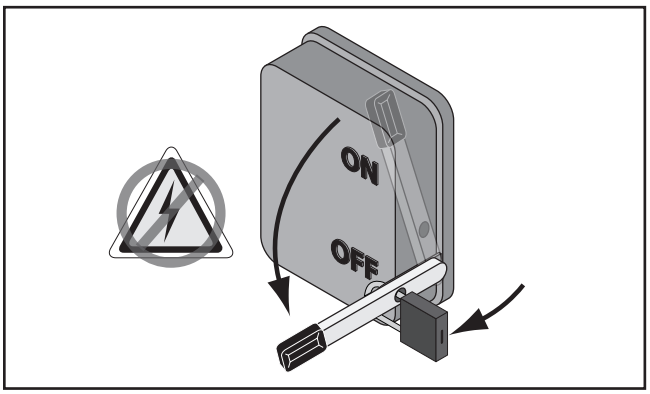


Figure 42. Disconnecting power from machine.

Correcting Phase Polarity

This sub-section is only provided for troubleshooting 3-phase power connections. If you discover during the test run that the machine will not operate, or that the motor runs backwards, the power supply connection may be wired "out of phase," meaning that the polarity is incorrect as wired. This is a common situation with 3-phase power, and it is easy to correct.

To correct polarity of incoming power supply connection:

1. DISCONNECT MACHINE FROM POWER!

2. Open lower left access and electrical box doors, and swap wires connected to "**R**" and "**S**" terminals (see **Figure 43**).

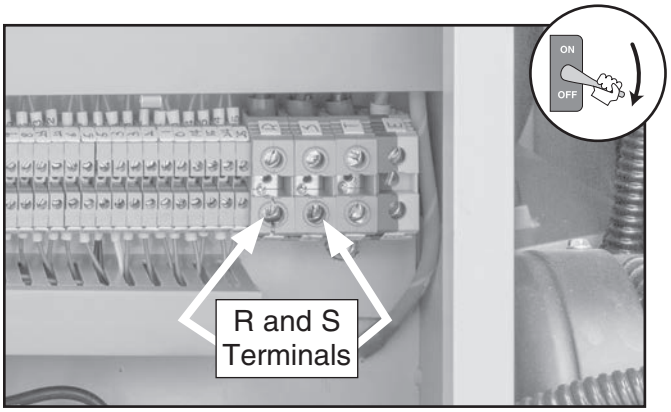


Figure 43. Location of "R" and "S" terminals.

3. Close and latch access and electrical box doors and reconnect machine to power.

4. Follow **Test Run** to ensure that machine functions properly.

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 sanding belts tension when the tension switch is turned ***ON***, 2) the power supply polarity is correct, 3) the motors power up and run correctly, 4) the Emergency Stop button works correctly, and 5) the EMERGENCY STOP! plate works correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Clear all setup tools away from machine.

2. Press Emergency Stop button on control panel (see **Figure 44**).

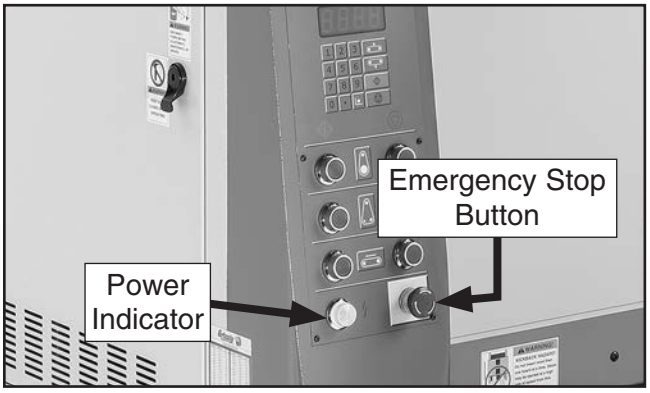


Figure 44. Emergency Stop button and power indicator.

3. Turn air compressor ***ON*** and verify pressure gauge on air regulator is set to approximately 75 PSI.

4. Connect machine to power. Power indicator should illuminate (see **Figure 44**).

5. Twist Emergency Stop button clockwise until it springs out. This resets the switch so the machine can start.

6. Verify power supply is connected to machine with correct polarity by pressing Table Up ( ) and Table Down ( ) keys, respectively (see **Figure 45**).

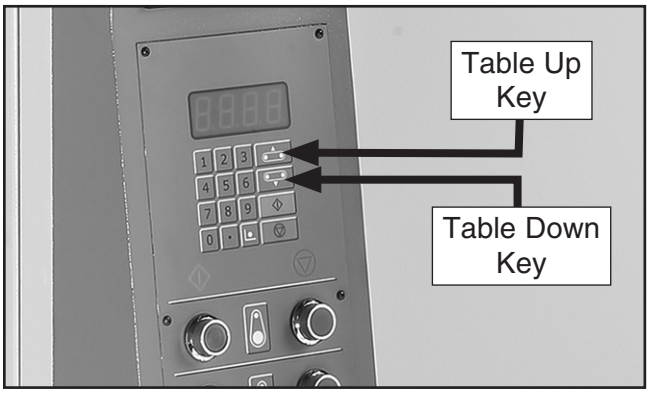


Figure 45. Table controls.

— If table moves in same direction as button description, power supply polarity is correct.

— If table moves in opposite direction to arrow on button, stop machine and DISCONNECT FROM POWER. Phase polarity of incoming power is reversed. Refer to **Correcting Phase Polarity** on **Page 28** before proceeding with remainder of **Test Run**.

⚠WARNING

You MUST verify that table moves in expected direction according to buttons pressed on control panel, otherwise all controls will function in reverse. Conveyer belt and sanding belts MUST rotate in the correct direction or serious personal injury could occur.

7. Press front sanding belt start button to turn front main motor ***ON*** (see **Figure 46**). Verify motor starts up and runs smoothly without any unusual problems or noises.

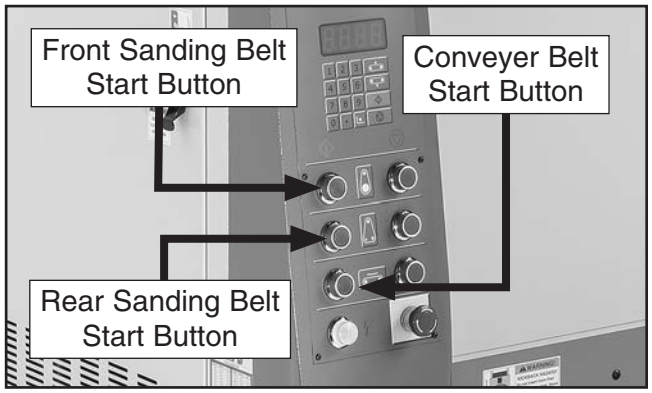


Figure 46. Control panel controls.

8. Press Emergency Stop button to turn machine ***OFF***.

9. WITHOUT resetting Emergency Stop button, try to start machine by pressing front sanding belt start button. The machine should not start.

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

— If the machine *does* start, immediately turn it ***OFF*** and disconnect power. The safety feature of the Emergency Stop button is NOT working properly and must be replaced before further using the machine.

10. Repeat **Steps 7–9** with the rear sanding belt start button and then the conveyor belt start button to test rear main motor and feed motor (see **Figure 46**). Both should run smoothly and without unusual problems or noises. Belt should move away from operator and toward sanding drums while feed motor is running.

11. Reset Emergency Stop button.

12. Press sanding belt and conveyor belt start buttons, then press EMERGENCY STOP! plate (see **Figure 47**).

Figure 47. EMERGENCY STOP! plate location.

— If sanding belts and conveyer belt *do not* come to a complete stop, immediately disconnect power. The safety feature of the EMERGENCY STOP! plate is NOT working properly. This must be fixed before machine can be used further.

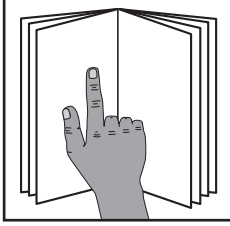
— If sanding belts and conveyer belt *do* come to a complete stop, the safety feature of the EMERGENCY STOP! plate is working correctly. Congratulations! The Test Run is complete.

SECTION 4: OPERATIONS

Operation Overview

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

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

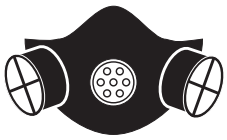


⚠WARNING

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

⚠WARNING

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



NOTICE

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

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

1. Examines workpiece to verify it is suitable for sanding and determines which sanding belt grit size to start with.
2. Installs and tensions sanding belts. Adjusts platen as necessary.
3. Checks pressure regulator is between 57-75 PSI.
4. Verifies outfeed clearance and support.
5. Adjusts conveyor table height to approximate thickness of workpiece.
6. Puts on safety glasses and respirator.
7. Connects machine to power, starts both sanding belt motors, and then feed motor.
8. Starts dust collector.
9. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.

   Note: *During initial pass with new workpiece, operator adjusts table height as necessary so workpiece only makes light contact with sanding belts and does not overload sander.*
10. Receives workpiece from outfeed side of conveyor table.
11. Raises height of conveyor table a small amount, then repeats feeding process of workpiece through sander.
12. Changes sandpaper to finer grit.
13. Repeats **Steps 9–12** as needed, turns all motors ***OFF***, disconnects machine from power, then turns ***OFF*** air compressor once machine is at rest.

Workpiece Inspection

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

Before sanding, inspect all workpieces for following:

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

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

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear sanding belt. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT sand workpiece.

- ***Wet or "Green" Stock:*** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on sanding belt, increases 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 unpredictable when being sanded. DO NOT use workpieces with these characteristics!

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if cupped side is facing table. On the contrary, a workpiece supported on bowed side will rock during sanding, and could cause kickback or severe injury.

Sanding Workpieces

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

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

Attempts to remove too much material at one time can cause jamming, wood burning, rapid sandpaper wear or tearing, poor finish, short motor life, and belt slippage. The operator usually makes a pass, raises the table a little, and repeats until the entire surface is sanded to satisfaction. Before sanding, ensure you review **Workpiece Inspection** on **Page 33** and put on the required safety glasses and respirator.

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

The overall sanding process consists of the operator starting sanding with the platen in the up position with a coarse grit sandpaper, such as #60, and then repeating this for subsequent grit sizes from #80–#100 until the workpiece is evenly smooth.

The operator then sets the platen level with the drums using the platen height components (see **Figure 48**) and performs intermediate sanding passes using #100–#150 grit sandpaper. For the final sanding pass, the operator sets the platen in the down position and sands the workpiece using #180 grit or finer sandpaper. Refer to **Adjusting Platen** on **Page 36** for more information about platen positions.

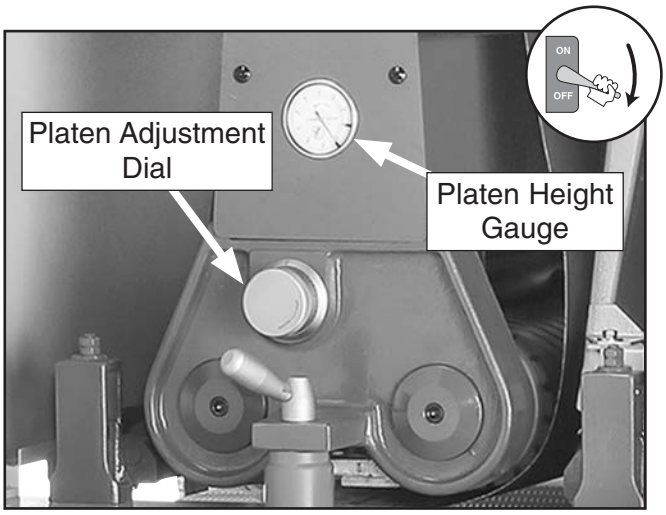


Figure 48. Platen height components.

IMPORTANT: As you sand, observe the amp load meter (see **Figure 49**). If the amp load meter indicates motor overload, lower the table slightly or reduce the feed rate.

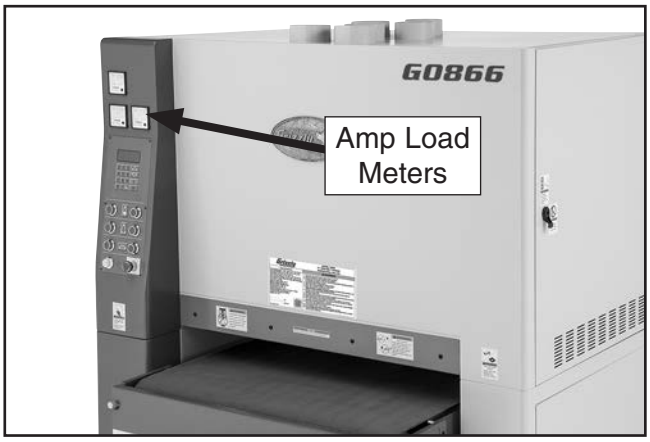


Figure 49. Location of amp load meters.

Use the following tables to determine the approximate maximum depth-of-cut (DOC) for relative conveyor feed rates. After selecting the appropriate feed rate chart, find the grit size you plan to use. Locate the correct DOC for that grit by selecting the correct wood hardness of the workpiece, and note the maximum DOC for the platen setting (up, even, or down).

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

Approximate Max Depth-of-Cut (DOC) for 15" Stock

16 FPM

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

23 FPM

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

33 FPM

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

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

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.

- 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 **Installing/ Changing Sanding Belts** on **Page 35**).

- When making multiple passes on the workpiece, avoid raising the conveyor table more than 0.015" (nearly one turn of the height handle or 3 touches of the Table Up key) 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 12" long, 2" wide and 3/16" thick to prevent damage to the workpiece and the sander (see **Figure 50**).

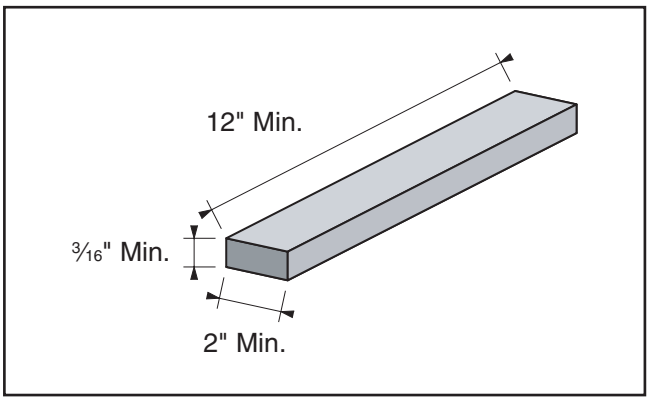


Figure 50. Minimum dimensions for sanding.

- Extend the life of the sandpaper by regularly cleaning the sanding belt (refer to **Cleaning Sanding Belt** on **Page 44**).

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

- Only use the amp load meter to keep the motor from overloading—that is its main purpose. Avoid using the amp load meter to monitor how much material is being removed, as this can lead to problems, including belts loading, burning, and poor quality sanding results.

- Make sure to adjust platen position accordingly when changing grit sizes.

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

Installing/Changing Sanding Belts

Required Sanding Belt Size .....37" x 75"

Included 37" x 75" Sanding Belts	**Qty**
100-Grit	1
180-Grit	1

The Model G0866 only accepts 37" wide by 75" long sanding belts. For additional sanding belt selections beyond those included with the machine, refer to **Accessories** on **Page 39**.

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

Grit	**Type**
60 or less	Coarse
80-100	Medium
120-150	Fine
180+	Finish

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

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

To install sanding belts:

1. Start air compressor.
2. DISCONNECT MACHINE FROM POWER!
3. Open upper left access door.
4. Turn belt tension knob to detensioned position (see **Figure 51**).

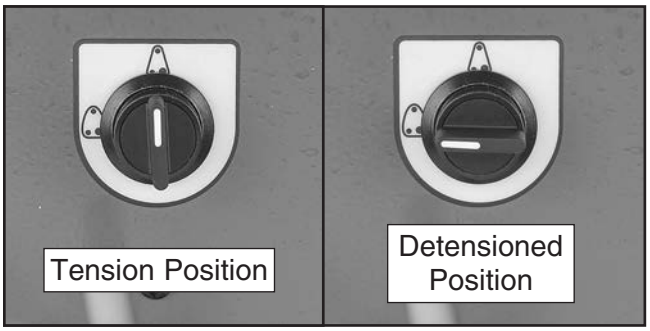


Figure 51. Sanding belt tension knob positions.

5. Remove lock post release lever (see **Figure 52**) by turning it counterclockwise a ½ turn and pulling it up and out of mounting hole.
6. Remove spacer block (see **Figure 52**).

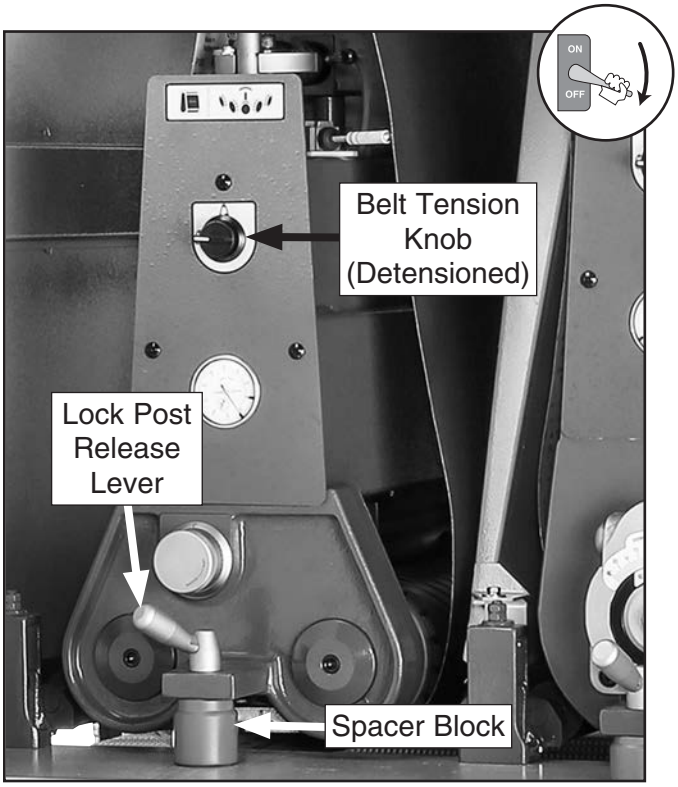


Figure 52. Components used when installing a sanding belt.

NOTICE

Directional arrows on back of sanding belt must be pointing in a counterclockwise direction during installation. Failure to install sanding belt correctly will result in damage to sanding belt.

7. Install sanding belt on upper roller and lower roller, starting with upper, making sure rotation arrows on sanding belt point in same direction as those shown in **Figure 53**.

   Note: *Sanding belt must be centered between limit switch tips, and edge of sanding belt must be between tongs of belt oscillation controller fork, as shown in* ***Figure 53****. Damage to sanding belt and sander may occur if sander is tensioned and turned* ***ON*** *before sanding belt is correctly positioned.*

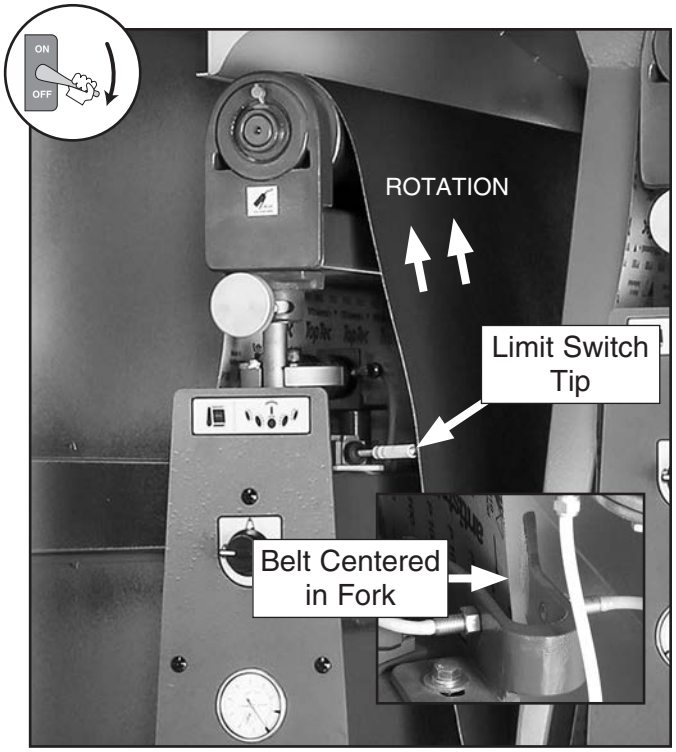


Figure 53. Sanding belt placement components.

8. Replace spacer block and lock post release lever.

9. With your hands clear of all moving parts, turn belt tension knob to 12 o'clock position to tension belt.

10. Repeat **Steps 4–9** with second sanding belt and drum.

11. Close upper left access door.

Adjusting Platen

This sander is equipped with an adjustable platen (see **Figure 54**) with a graphite pad that is designed to be used during finish sanding to create a polished-type finish and to prepare the workpiece for orbital sanding or a finish coat.

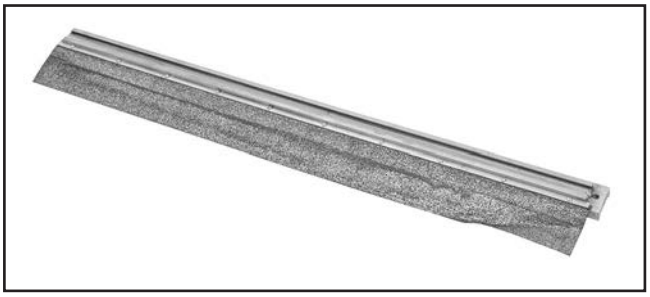


Figure 54. Platen removed from machine.

The platen position allows for 3 basic types of sanding: up, even, and down, which are adjusted by rotating the platen height dial (see **Figure 55**) to the desired position. The platen height gauge indicates the current position of the platen.

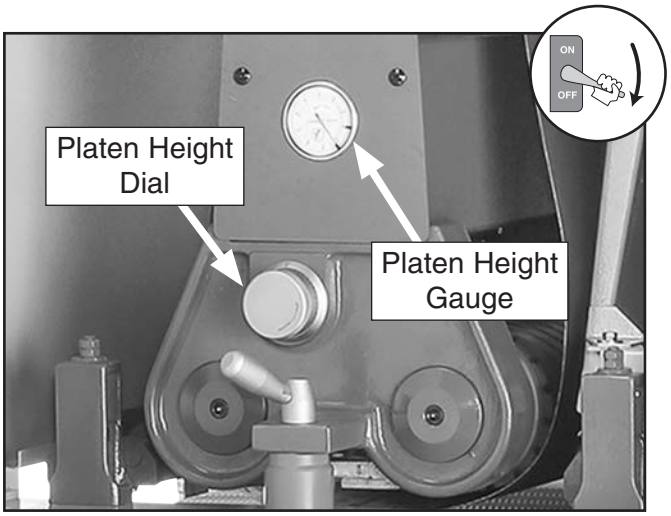


Figure 55. Platen height components.

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

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

Tip: *Given the short life-span of most graphite pads, it is a good idea to keep replacement pads on hand.*

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

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

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

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

It is not necessary to use the table height handwheel or Table Up button to adjust the sanding depth during the final sanding pass—the platen movement alone will take care of the depth of cut. *Typically the final-sanding pass position uses #180 or finer.*

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

NOTICE

If workpiece has straight notches across it, graphite cloth and felt have worn out and need to be replaced.

Changing Feed Rate

The conveyor belt is variable-speed, and is controlled by the knob located on the front of the feed belt gearbox (see **Figure 56**).

Conveyor Feed Rate..... 7-68 FPM

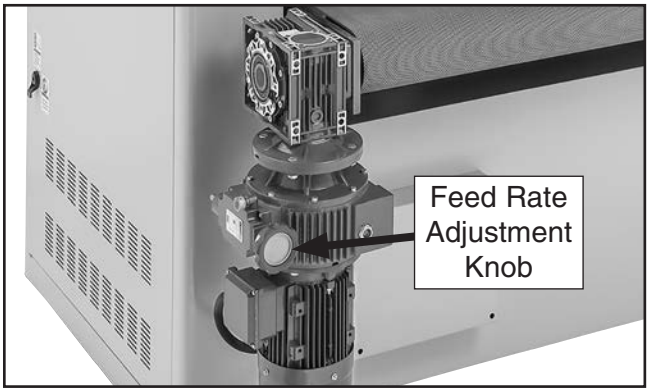


Figure 56. Feed rate adjustment knob.

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

Softwoods typically require a faster feed rate than hardwoods; however, there is no definitive rule to follow when determining the best feed rate to use for any type of wood.

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

To change feed rate:

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

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

   Note: *Turn knob in ¼" increments.*

Reading Amp Load Meters

The amp load meters (see **Figure 57**) are used to keep the motors from overloading during sanding operations. They should not be used as the main method for controlling sanding belt material removal rates—doing so can result in belt loading, burning, and even breaking—because there are many different variables that affect optimum removal rates and these will affect the amp load in different ways.

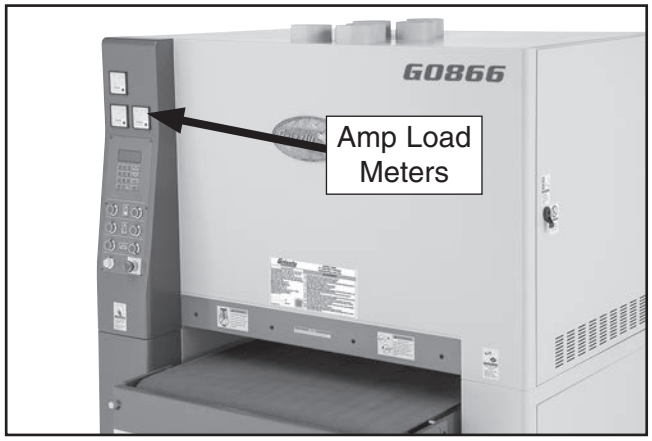


Figure 57. Location of amp load meters.

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

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

NOTICE

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

Using EMERGENCY STOP! Plate

The EMERGENCY STOP! plate can help reduce the amount of damage to internal components during an emergency and can prevent operator injury. Pushing the EMERGENCY STOP! plate (see **Figure 58**) causes the disc brakes to stop the sanding belt motors, immediately halting the sanding belts.

Figure 58. Location of EMERGENCY STOP! plate.

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

⚠CAUTION

Keep sanding drum V-belts correctly tensioned (refer to Page 59) to ensure proper functionality of EMERGENCY STOP! plate. Otherwise, pulleys can slip when emergency stop brake is applied and not immediately stop machine in the event of an emergency!

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.

Sanding Belts 37" x 75" X-Weight Aluminum-Oxide

T21047—60-Grit
T21048—80-Grit
T21049—100-Grit
T21050—120-Grit
T21051—150-Grit
T21097—60-Grit (5-Pk.)
T21098—80-Grit (5-Pk.)
T21099—100-Grit (5-Pk.)
T21100—120-Grit (5-Pk.)
T21101—150-Grit (5-Pk.)

These belts feature tough aluminum oxide grain on an “X” weight paper backing. This product has more “body” than other “X” weight products making it well suited for wide belts. While it will not take the abuse of the “Y” weight Aluminum Oxide Belts for Wide-Belt Sanders, the do-it-yourselfer will find it affordable and effective.

Figure 59. 37" x 75" X-weight sanding belts.

Sanding Belts 37" x 75" Y-Weight Aluminum-Oxide

H8846—60-Grit
H8847—80-Grit
H8848—100-Grit
H8849—120-Grit
H8850—150-Grit
H8835—60-Grit (3-Pk.)
H8836—80-Grit (3-Pk.)
H8837—100-Grit (3-Pk.)
H8838—120-Grit (3-Pk.)
H8839—150-Grit (3-Pk.)

These belts use tough Aluminum Oxide grain, open coated on a very heavy "Y" weight polyester backing with a Resin Bond system that no equivalent product can outperform. The superior backing more than justifies the additional cost over lesser "X" weight backings in their longer belt life and their ability to be washed… furthering the savings. Compare to Norton R215 or 3M™ 240D "X" weight belts!

Figure 60. 37" x 75" Y-weight sanding belts.

D2274—Shop Fox 5 Roller Stand
This super heavy-duty roller stand features convenient hand knobs for fast height adjustment. Invaluable for supporting work on machines of varying heights. Adjusts from 26" to 44 5/8". All-steel construction. 15 7/8" wide ball bearing rollers. 250 lb. capacity.

Figure 61. Model D2274 Shop Fox 5 Roller Stand.

H4228—Anti-Fatigue Mat 24" x 36"
Reduce work-related aches and pains by up to 50% with these closed-cell vinyl floor mats. These sure-grip ribbed foam mats insulate against heat and cold, while providing a 3/8" thick cushion. Beveled edges minimize tripping. Black. Made in the U.S.A.

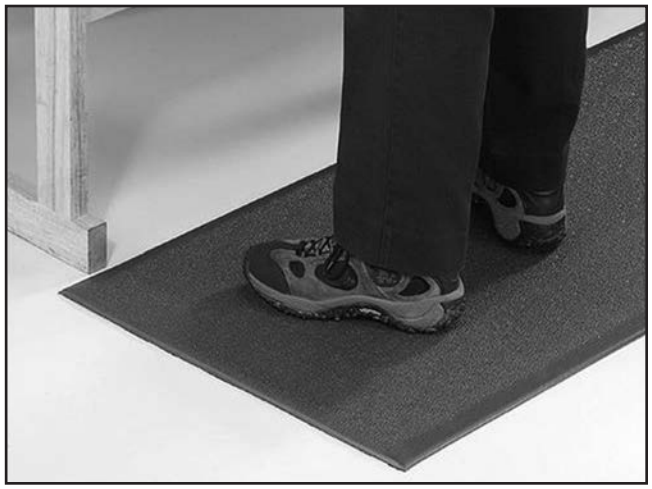


Figure 62. Model H4228 Anti-Fatigue Mat.

T28042—Primrose XHP ISO 320 Gear Oil
Armor Plate with Moly-D Industrial XHP 514M is an industrial gear oil from Primrose that has been developed specifically for the significantly higher temperatures and pressures typical of modern industrial applications. Transmissions systems are designed to convey greater energy through the gear train at increased speeds without a corresponding increase in oil pump size or cooling capacity. 1 gallon size.

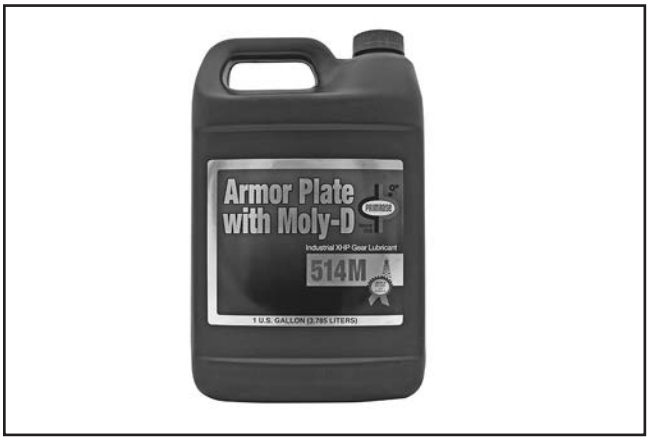


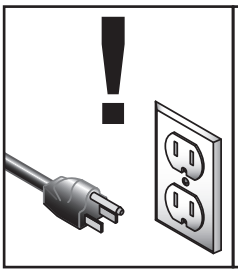
Figure 63. Model T28042 Primrose ISO 320 Gear Oil.

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 64. Model T26419 Syn-O-Gen Synthetic Grease.

order online at www.grizzly.com or call 1-800-523-4777

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.
- Worn or damaged sanding belts.
- Worn or damaged wires.
- Worn or damaged platen graphite pad.
- Any other unsafe condition.

Weekly Maintenance
- Drain water in air filter collection cups (**Page 43**).
- Empty and clean dust trap bowls (**Page 43**).
- Lubricate grease fittings on conveyor belt roller axles and sanding belt axles (**Page 42**).

Monthly Check
- V-belt tension, damage, or wear.
- Clean/vacuum dust build-up from inside cabinet and off motors.
- Grease table elevation chain, leadscrews, and sprockets (**Page 42**).
- Check gearbox sight glass for oil level. Fill gearbox if oil is below sight glass (**Page 42**).

Yearly Check:
- Replace white moisture filters in air regulator.

Cleaning & Protecting

Cleaning the Model G0866 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Lubrication

It is essential to clean the components before lubricating them, because dust and chips build up on lubricated components and make the components hard to move. Simply adding more grease to the components with built-up grime on them will not yield smooth moving components.

Clean the components in this section with mineral spirits.

All other bearings are internally lubricated and sealed at the factory. Simply leave them alone unless they need to be replaced.

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

- Grease Fittings
- Table Elevation Leadscrews, Chain and Sprockets
- Feed Motor Gearbox

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

DISCONNECT POWER TO MACHINE BEFORE CLEANING AND LUBRICATING COMPONENTS!

Grease Fittings

Oil Type ..... T26419 or NLGI#2 Equivalent
Oil Amount..... 1–2 Pumps from Grease Gun
Frequency..... Weekly

Items Needed	Qty
Rag	1
Grease Gun	1

Wipe the fittings clean with a rag. Attach a flexible grease gun extension to a grease gun. Add one or two pumps of grease to the grease fitting located on the conveyor belt roller axles and the sanding belt roller axles (see **Figures 65**–**66**). They are identified with yellow labels.

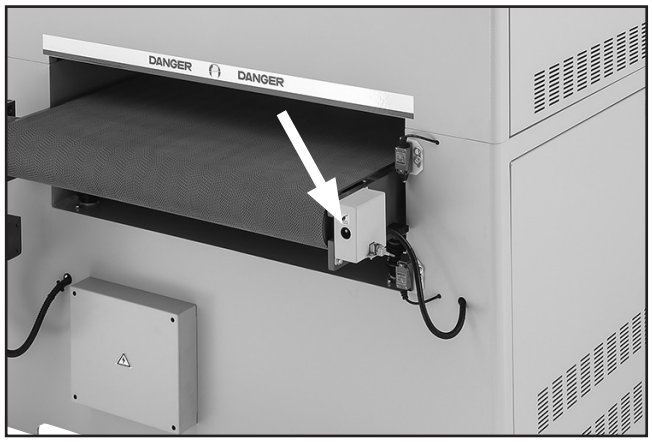


Figure 65. Location of conveyor belt roller axle grease fitting.

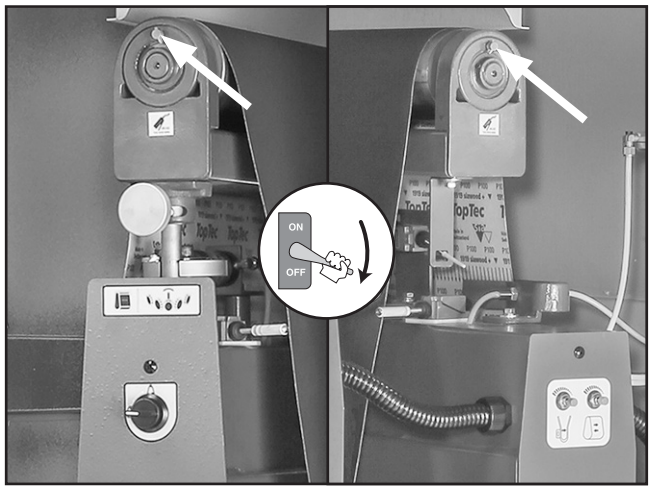


Figure 66. Locations of upper left/right sanding belt roller axle grease fittings.

Table Elevation Leadscrews, Chain & Sprockets

Oil Type ..... T26419 or NLGI#2 Equivalent
Oil Amount..... Thin Coat
Frequency..... Monthly

Items Needed	Qty
Rag	1
Mineral Spirits	As Needed
Wire Brush	1

Lower table all the way, then open lower right and left access doors. Use shop rag and mineral spirits to remove old lubricant and built-up grime from leadscrews, chain, and sprockets (see **Figure 67**). Brush grease onto leadscrews, chain, and sprockets, being careful to not get grease on V-belts. This could cause V-belts to slip on pulleys. If you do get grease on V-belts, replace them. Raise table up and down a few times to evenly distribute grease.

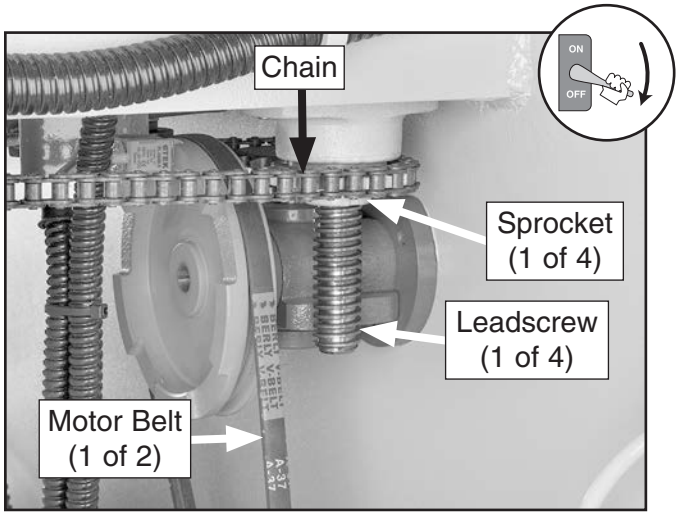


Figure 67. Location of table elevation leadscrews, chain, and sprockets.

Feed Belt Gearbox

Oil Type ..... T28042 or ISO-VG 320 Oil
Oil Amount..... As Needed
Frequency.... After first 300 hrs., every 2500 hrs.

Items Needed	Qty
Drain Pan	1
Wrench 14mm	1

If gearbox oil is low, remove fill plug (see **Figure 68**) and all new oil until sight glass is full, then re-install fill plug.

If gearbox oil needs to be changed, run machine to warm gearbox before removing fill plug and drain plug (see **Figure 68**), draining oil, then re-installing drain plug. Add new oil until sight glass is full, then re-install fill plug.

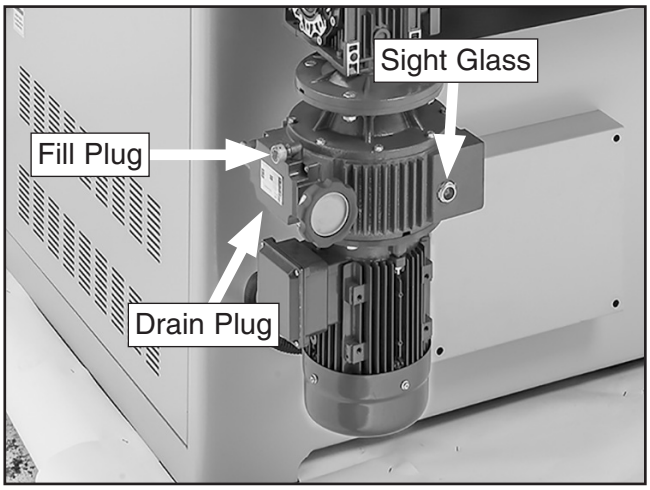


Figure 68. Gearbox lubrication components.

Emptying Dust and Water Traps

Three collection traps on this sander need to be emptied regularly. DO NOT allow any of these traps to become full or you risk serious damage to your machine.

The air pressure regulator water trap (see **Figure 69**) is attached to the air pressure regulator and traps condensation in the incoming air supply.

With the system under air pressure, push the lower drain valve and empty the regulator water trap (see **Figure 69**). Replace the internal white moisture filters annually.

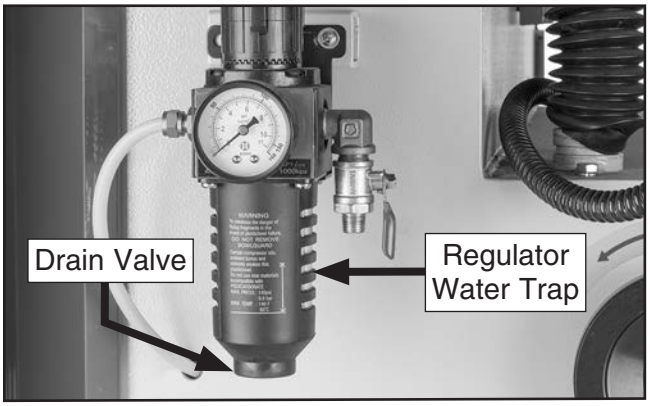


Figure 69. Location of regulator water trap and drain valve.

There are two dust trap bowls inside the upper right access panel (see **Figure 70**). To empty these, turn air pressure ***OFF***, allow pressure to bleed out, then unscrew and empty bowls.

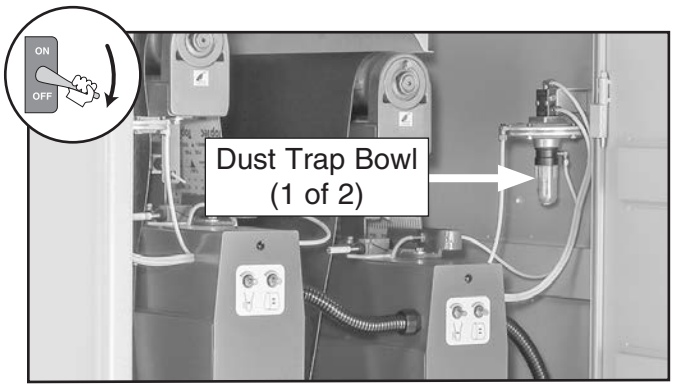


Figure 70. Location of dust cups.

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 71**.

Figure 71. PRO-STIK cleaning pad in use.

To clean sanding belt:

1. Set table 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.

Pneumatic System

The air system is durable and reliable; however, components do wear with age. If you suspect that an item in your pneumatic system may be having problems, see the **Pneumatic System Diagram** on **Page 66**.

- Adjust regulator to approximately 75 PSI.

- Carefully inspect all air lines for cracks, chafing, or hardening. Replace faulty hoses.

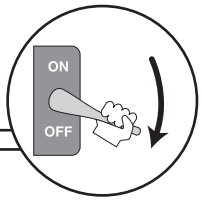
- Check air connections for leaks. A small amount of soapy water in a questionable area will bubble if there is a leak.

- Make sure lines are not clogged. Remove a questionable line and blow through it as a test.

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. Emergency Stop button depressed/at fault.	1. Rotate Emergency Stop button head to reset. Replace if at fault.
	2. Incorrect power supply voltage or circuit size.	2. Ensure correct power supply voltage and circuit size (**Page 13**).
	3. Machine fuse blown.	3. Replace fuse/ensure no shorts.
	4. Power supply circuit breaker tripped or fuse blown.	4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.
	5. EMERGENCY STOP! panel switch stuck/at fault.	5. Free stuck switch/replace.
	6. Table limit switch engaged/at fault.	6. Adjust table to correct height/replace switch.
	7. Sanding belt tracking limit switch engaged/at fault.	7. Center sanding belt so it is not touching limit switches/ adjust limit switch(es) (**Page 48**)/replace switch(es).
	8. Sanding belt tension limit switch engaged/at fault.	8. Turn on air pressure and tension sanding belt (**Page 35**)/replace switch.
	9. Motor wires connected incorrectly.	9. Correct motor wiring connections (**Page 75**).
	10. ON/OFF button at fault.	10. Replace button.
	11. Contactor not energized/at fault.	11. Test all legs for power; replace if necessary.
	12. Thermal overload relay has tripped/is at fault.	12. Reset. Adjust or replace if at fault.
	13. Wiring broken, disconnected, or corroded.	13. Fix broken wires, or disconnected/corroded connections (**Page 68**).
	14. Transformer at fault.	14. Inspect; replace if at fault.
	15. Motor or motor bearings at fault.	15. Replace motor.
Main motor stalls or is underpowered.	1. Workpiece material unsuitable for machine.	1. Only sand wood/ensure moisture is below 20%.
	2. Feed rate too fast/cutting depth too deep.	2. Decrease feed rate (**Page 37**)/cutting depth.
	3. V-belt(s) worn/loose.	3. Inspect/replace belt(s) (**Page 35**).
	4. Pulley/sprocket slipping on shaft or misaligned.	4. Tighten/replace loose pulley/shaft, check for/correct misalignment.
	5. Motor wired incorrectly.	5. Wire motor correctly (**Page 75**).
	6. Machine is undersized for task.	6. Clean/replace sandpaper; reduce feed rate/depth of cut.
	7. Motor overheated.	7. Clean motor/let cool, and reduce workload.
	8. Contactor not energized/at fault.	8. Test all legs for power; repair/replace if at fault.
	9. Motor or motor bearings at fault.	9. Replace motor.
Table moves up when it should move down and down when it should move up.	1. Power connections wired out of phase.	1. Correct phase polarity (**Page 28**).

Motor & Electrical (Cont.)

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	1. Feed rate too high. 2. Excessive depth of cut. 3. Sanding belt grit too fine for job.	1. Reduce feed rate (**Page 37**). 2. Reduce depth of cut. 3. Replace with coarser grit sanding belt (**Page 35**).
Machine has vibration or noisy operation.	1. Motor or component loose. 2. V-belt(s) worn, loose, pulleys misaligned, or belt slapping cover. 3. Machine not secured to floor. 4. Motor fan rubbing on fan cover. 5. Motor bearings at fault. 6. Conveyor gearbox at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Inspect/replace belts with a new matched set (**Page 60**). Realign pulley if necessary. 3. Tighten mounting bolts; relocate/shim machine. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Rebuild gearbox for bad gear(s)/bearing(s).

Operation

Symptom	Possible Cause	Possible Solution
Loud, repetitive noise coming from machine.	1. Pulley set screws or keys missing or loose. 2. Motor fan rubbing on fan cover. 3. V-belt(s) defective or damaged.	1. Inspect pulley keys and set screws. Replace or tighten if necessary. 2. Fix/replace fan cover; replace loose/damaged fan. 3. Replace V-belt(s) (**Page 60**).
Machine is loud, overheats or bogs down during operation.	1. Excessive depth of cut. 2. Sanding belt worn/clogged.	1. Decrease depth of cut. 2. Clean/replace sanding belt (**Page 35** & **44**).
Rounded workpiece edges.	1. Excessive depth of cut.	1. Reduce depth of cut.
Uneven thickness from left to right of board.	1. Sanding belt worn unevenly. 2. Feed table not parallel to upper frame. 3. Conveyor belt worn.	1. Replace sanding belt (**Page 35**). Feed workpieces evenly across sanding belt, not just on one side. 2. Adjust feed table (**Page 55**). 3. Replace conveyor belt (**Page 64**).
Workpiece slips on conveyor belt.	1. Pressure rollers set too high. 2. Dirty/worn conveyor belt.	1. Lower pressure rollers (**Page 58**). 2. Clean/replace conveyor belt (**Page 64**).
Grooves down length of workpiece.	1. Pressure rollers dirty/damaged. 2. Platen set too low. 3. Platen graphite pad damaged.	1. Clean/repair/replace pressure rollers. 2. Raise platen to reduce pressure (**Page 36**). 3. Replace graphite pad (**Page 51**).
Snake-shaped marks on workpiece.	1. Sanding belt dirty/damaged. 2. Pressure rollers dirty/damaged.	1. Clean/replace sanding belt (**Pages 35** & **44**). 2. Clean/repair pressure rollers.
Lines across width of workpiece.	1. Sanding belt seam open/damaged. 2. Platen set too low.	1. Replace sanding belt (**Page 35**). 2. Raise platen to reduce pressure (**Page 36**).
Glossy spots or streaks on workpiece.	1. Worn sanding belt. 2. Rear pressure roller too low. 3. Feed rate too low. 4. Platen set too low. 5. Graphite or felt pad worn/damaged. 6. Using amp load meter to establish material removal amount.	1. Replace sanding belt (**Page 35**). 2. Raise rear pressure roller (**Page 58**). 3. Increase feed rate (**Page 37**). 4. Raise platen to reduce pressure (**Page 36**). 5. Replace graphite or felt pad (**Page 51**). 6. Use alternate methods to establish material removal amount (**Page 34**).

Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Sanding belt clogs quickly.	1. Sanding belt grit too fine for particular job. 2. Excessive depth of cut. 3. Wood is too moist. 4. Using amp load meter to establish material removal amount.	1. Replace with coarser grit sanding belt (**Page 35**). 2. Reduce depth of cut. 3. Allow wood to dry to below 20% moisture content. 4. Use alternate methods to establish material removal amount (**Page 34**).
Sanding belt does not tension correctly; rollers slip under belt.	1. Low air pressure. 2. Air leaks in system. 3. Air cylinder shaft worn/damaged.	1. Adjust air pressure to 75 PSI at primary regulator (**Page 24**). 2. Inspect all hoses and connections for leaking air; use a water/soap mixture on suspected area to detect bubbles. 3. Repair/replace air cylinder.
Sanding belt runs off to one side, stopping sander.	1. Power connections wired out of phase. 2. Airflow adjustment knob closed. 3. Belt tracking incorrect. 4. Air fork gap/air lines clogged. 5. Solenoid valve/air manifold at fault.	1. Correct phase polarity (**Page 28**). 2. Turn valve all the way out, then back in 3½" turns. 3. Adjust belt tracking (**Page 48**). 4. Clean air fork gap/air lines. 5. Test/repair/replace.
Poor, non-aggressive sanding results.	1. Sanding belt worn/clogged. 2. Sanding belt grit too fine for particular job.	1. Clean/replace sanding belt (**Page 35** & **44**). 2. Replace with coarser grit.
Sanding belt will not start, but conveyor will.	1. No air pressure to sander. 2. Airflow adjustment valve closed. 3. Limit switches engaged. 4. Sanding belt not tensioned.	1. Connect sander to compressed air system (**Page 63**). 2. Open airflow adjustment valve. 3. Center sanding belt so it is not touching limit switches. 4. Tension sanding belt (**Page 35**).
Conveyor belt not tracking in center.	1. Conveyor belt moved out of adjustment.	1. Adjust conveyor adjustment bolts (**Page 62**).
Conveyor belt slipping.	1. Conveyor belt has incorrect tension. 2. Conveyor rollers contaminated with dirt or dust.	1. Adjust conveyor belt tension (**Page 62**). 2. Clean conveyor rollers.
Emergency brake stops slowly.	1. Low air pressure. 2. Air leaks in system. 3. Brake rotor contaminated with oil. 4. Brake pads worn.	1. Adjust incoming air pressure to 75 PSI (**Page 24**). 2. Inspect all hoses and connections for leaking air; use water on suspected area to detect bubbles. 3. Clean brake rotor with automotive brake parts cleaner. 4. Replace brake pads (**Page 52**).
Grinding noise when braking.	1. Brake pads severely worn.	1. Replace brake pads (**Page 52**), have rotor turned/trued by a machine shop. Replace rotor.
Air leaking from sander.	1. Air release sound is normal. 2. Water filter/trap drain cock left open. 3. Air line ruptured or air leaking at a connection point.	1. Unless there is clear evidence of an air leak or performance issue with belt oscillation or braking time, take no action. Air release sound is normal. 2. Ensure water filter/trap drain cock is tight. 3. Locate source of sound and determine likely cause based on visual evidence.

Calibrating Digital Display

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

Items Needed:	Qty
3' Long 2x4	1
Digital Calipers	1

To calibrate digital display:

1. Sand planed 2x4 and measure workpiece thickness.

2. Check digital display reading.

— If digital display matches measurement taken in **Step 1**, no calibration is required.

— If digital display *does not* match measurement taken in **Step 1**, proceed to **Step 3**.

3. Press any number button on keypad. Current height setting will blink on digital display.

4. Use keypad to enter measurement taken in **Step 1**, then hold both Table Stop Key and Set keys together for 3 seconds to set new input (see **Figure 72**).

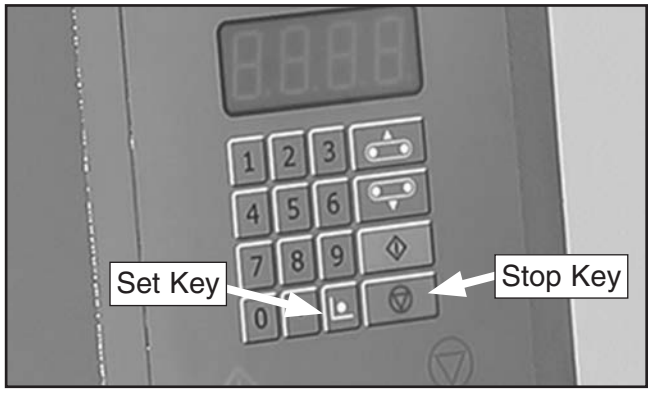


Figure 72. Digital display calibration keys.

Adjusting Belt Tracking Limit Switches

Sanding belt tracking limit switches are located on both sides of the sanding belts to act as emergency machine stops if the belt travels too far to one side during oscillation (see **Figure 73**).

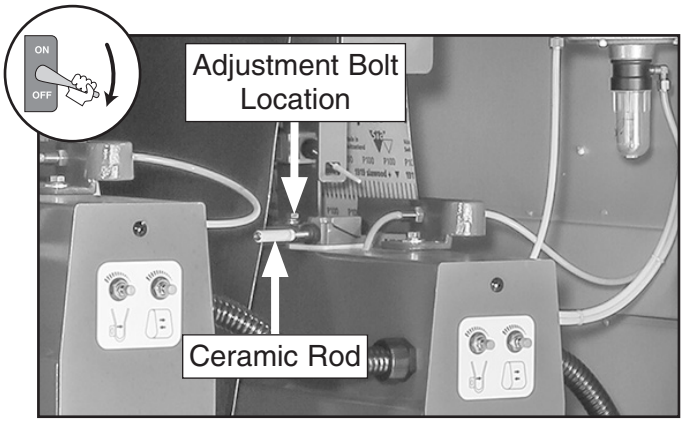


Figure 73. Tracking limit switch adjustment bolt (1 of 4).

Tools Needed:	Qty
Open-End Wrench 12mm	1

To adjust belt tracking limit switches:

1. Make sure sanding belts are tracking and oscillation is adjusted properly (refer to **Adjusting Oscillation Timing & Speed** on **Page 49**).

2. DISCONNECT MACHINE FROM POWER!

3. Release belt tension, center sanding belts on top rollers, then re-tension belts.

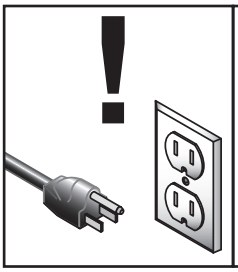
4. Measure distance from edge of sanding belts to ceramic rod protruding from switch (see **Figure 73**).

5. Loosen adjustment bolt shown in **Figure 73**, and move switch so belt and ceramic rod are approximately ¼" apart.

6. Tighten bolt and repeat adjustment with other side and other sanding belt if necessary.

7. Start machine and make sure it is working properly.

Adjusting Oscillation Timing & Speed



⚠WARNING

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

The oscillation adjustments have been performed at the factory and should require no further attention. However, we recommend verifying the settings.

When the oscillation is correctly adjusted, the sanding belt oscillates to the left and to the right at the same speed. If the sanding belt makes contact with a limit switch, as shown in **Figure 74**, the emergency braking system will activate and stop the sander immediately.

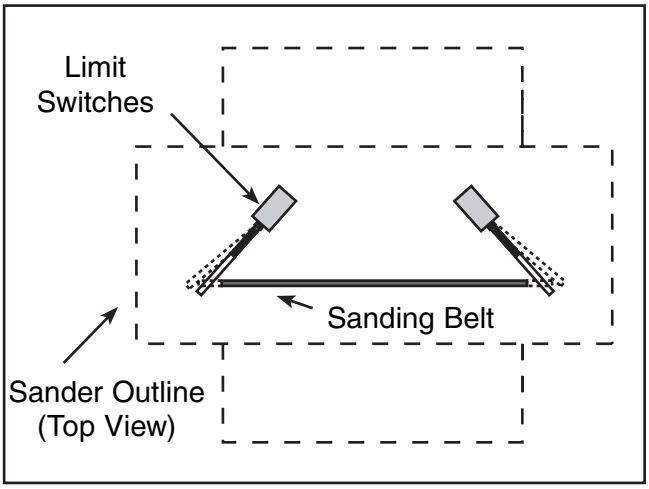


Figure 74. Improper oscillation.

⚠CAUTION

These adjustments should be made with care, as current sanding belt oscillation and timing settings can only be observed when doors are open and sanding belts are moving.

Checking Sanding Belt Oscillation

1. Confirm sanding belt is properly installed and tensioned and air supply is ***ON***.

2. Turn sanding belt ***ON***.

   — If belt oscillates without contacting limit switches, but oscillation time to left and right is not equal, proceed to **Equalizing Oscillation Speed**, on **Page 50**.

   — If belt tracks away from air fork and air jet, colliding into limit switch, proceed to **Setting Correct Airflow**.

Setting Correct Airflow

An adequate stream of air through the air fork gap is essential for proper oscillation (see **Figure 75**). If the jet of air is weak through the gap, the belt will track away from the controller and into the limit switch on the opposite end of the roller. The pivot action of the upper roller, and the resulting oscillation of the belt, are dependent upon adequate airflow through this air fork gap.

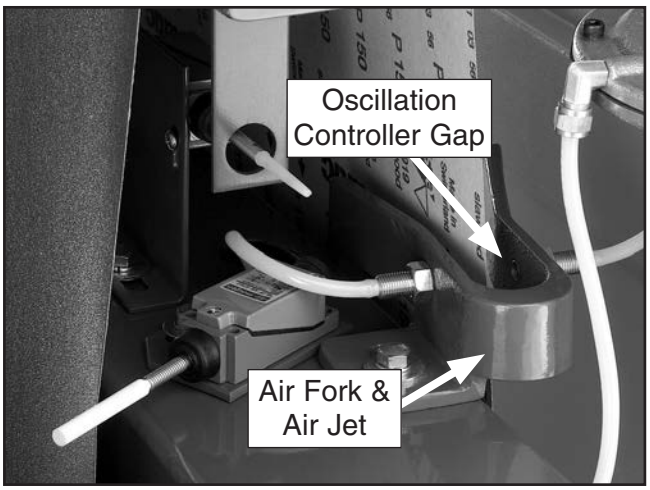


Figure 75. Oscillation components.

To set correct airflow through air fork:

1. Remove sanding belt and turn belt tension knob to tensioned position.

2. Loosen lock nut on airflow adjustment knob (see **Figure 76**).

3. Turn airflow adjustment knob (see **Figure 76**) clockwise until airflow is completely ***OFF***. Upper roller should pivot to the right.

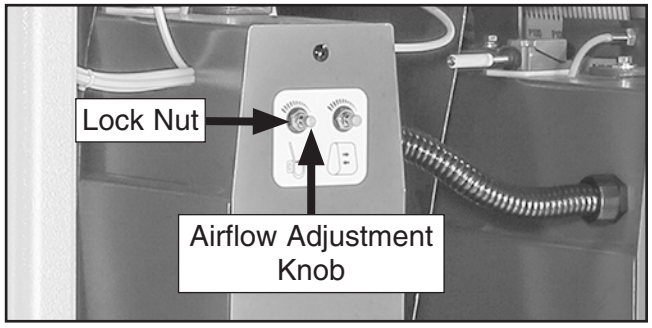


Figure 76. Airflow adjustment components.

4. Slowly turn airflow adjustment knob counterclockwise, and continue turning up air pressure until roller pivots left.

5. Tighten lock nut to secure airflow adjustment knob.

6. Restrict airflow across air fork gap with piece of cardboard. Roller should pivot to the right. When cardboard is removed, roller should pivot back to the left.

7. Proceed to **Equalizing Oscillation Speed** to ensure oscillation speed from left to right and right to left are the same.

Equalizing Oscillation Speed

1. Test oscillation by running sander. Make note of time it takes for belt to oscillate from left to right and from right to left. When correctly timed, oscillation should take similar amount of time to move in each direction.

   — If oscillation time to the **left** is longer than to the **right**, loosen oscillation tracking knob (see **Figure 77**) and move it **left** until proper tracking is achieved. Tighten down knob when satisfied.

   — If oscillation time to the **right** is longer than to the **left**, loosen oscillation tracking knob (see **Figure 77**) and move it **right** until proper tracking is achieved. Tighten down knob when satisfied.

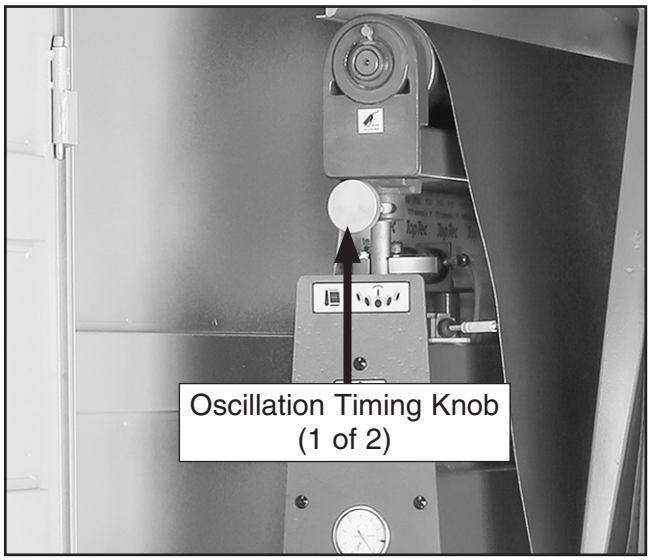


Figure 77. Location of oscillation timing knob.

Adjusting Oscillation Speed

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

To adjust oscillation speed:

1. Loosen lock nut on speed adjustment knob (see **Figure 78**).

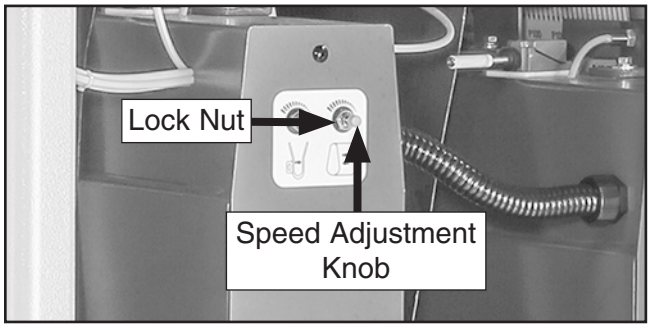


Figure 78. Speed adjustment components.

2. Turn speed adjustment knob clockwise to decrease oscillation speed and counterclockwise to increase.

3. Tighten lock nut to secure speed adjustment.

Servicing Platen

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

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

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

Items Needed	Qty
Platen Removal Tool	1
Hex Wrench 3mm	1
Graphite Pad	1
Felt Pad	1
Putty Knife	1
Contact Cement or Spray Adhesive	As Needed
Solvent Cleaner	As Needed
Drill	1
Drill Bit 1/8"	1

Replacing Graphite Pad

1. DISCONNECT MACHINE FROM POWER!

2. Open left access door and remove lock post release lever, stop block, and sanding belt from rear sanding drum. Keep lock post release lever and stop block removed (see **Figure 79**).

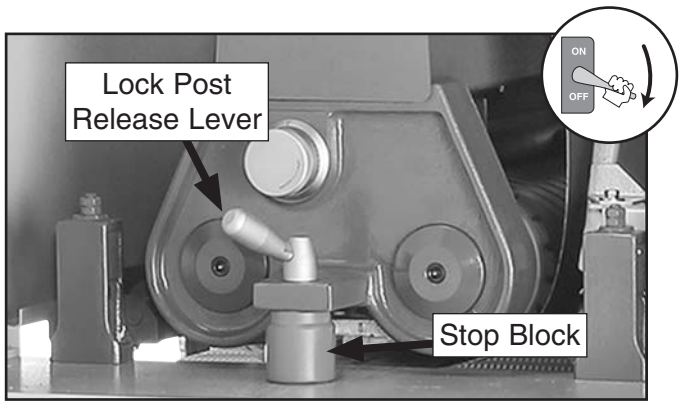


Figure 79. Lock post release lever and stop block locations.

3. Use platen removal tool, as shown in **Figure 80,** to remove platen from sander.

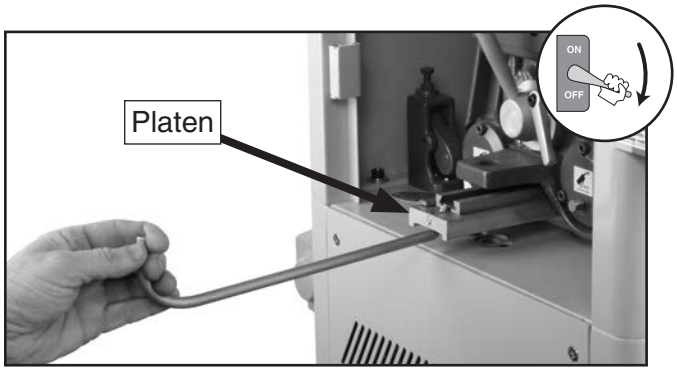


Figure 80. Removing platen.

4. Remove eight flat head cap screws and pressure plate that secure graphite pad (see **Figure 81**).

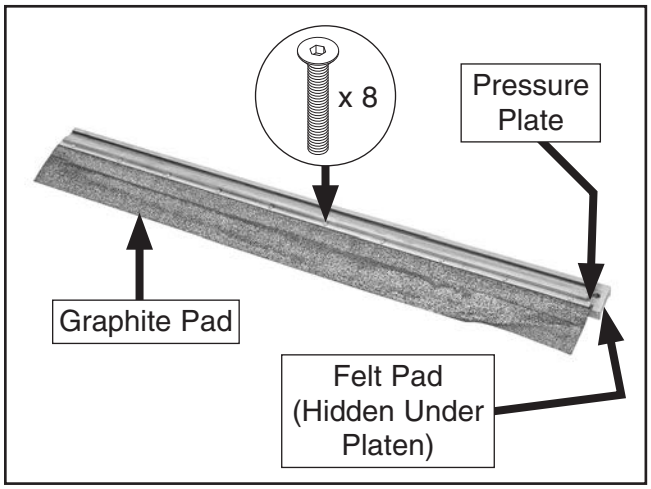


Figure 81. Platen components.

5. Install new graphite pad on platen, and secure pad with pressure plate and screws removed previously.

   Tip: *If new pad does not have any mounting holes, lay old pad over new pad, mark mounting holes, then drill holes into new pad.*

6. Insert platen in same manner it was removed until it stops in place, making sure graphite pad points towards front of machine.

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

Replacing Felt Pad

1. Follow **Steps 1–3** in **Replacing Graphite Pad** on **Page 51**.

2. Thoroughly soak felt pad in solvent to loosen glue securing pad to platen, then lift felt pad off and let platen dry. Use putty knife to scrape off any remaining felt and glue.

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

4. Follow **Steps 6–7** in **Replacing Graphite Pad** on **Page 51**.

Checking/Replacing Brake Pads

The disc brake assembly uses brake pads to stop the rotor (see **Figures 82–83**) when the Emergency Stop button or EMERGENCY STOP! plate is pressed. Eventually the brake pads will wear out. If you change the brake pads on one of the main motor brake assemblies, the other should be changed at the same time.

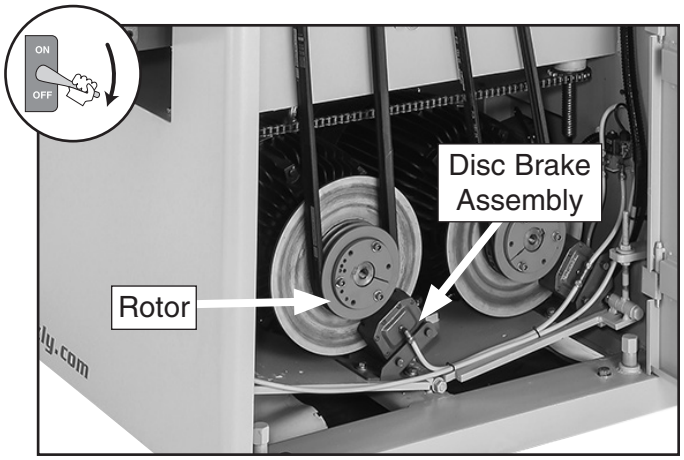


Figure 82. Location of disc brake assembly and rotor.

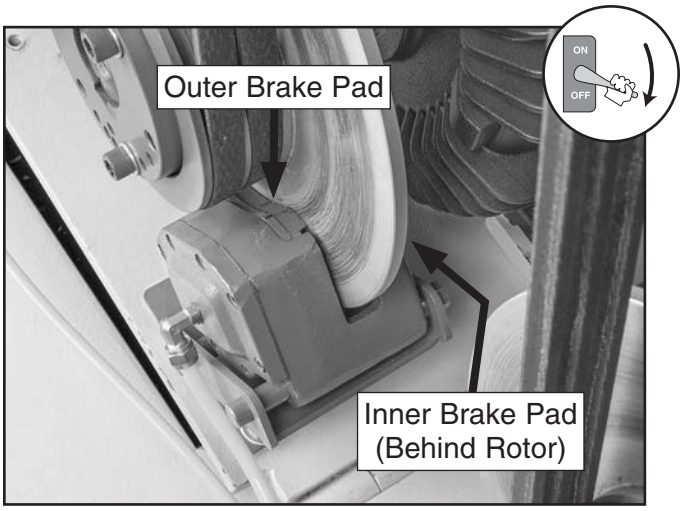


Figure 83. Locations of brake pads on disc brake assembly.

Checking and replacing these is a simple procedure that can be done in the shop.

Tools Needed:	**Qty**
Phillips Screwdriver #2	1
Fine Ruler	1
Open-End Wrench 14mm	1
Hex Wrench 4, 5mm	1 Ea.
Inner Brake Pads (#P08661302)	2
Outer Brake Pads (#P08661302-2)	2

To check/replace brake pads:

1. DISCONNECT MACHINE FROM POWER**!**

2. Disconnect machine from air, then release all air pressure in machine by opening air valve on regulator (see **Figure 84**). This will cause disc brake assembly to open, allowing removal.

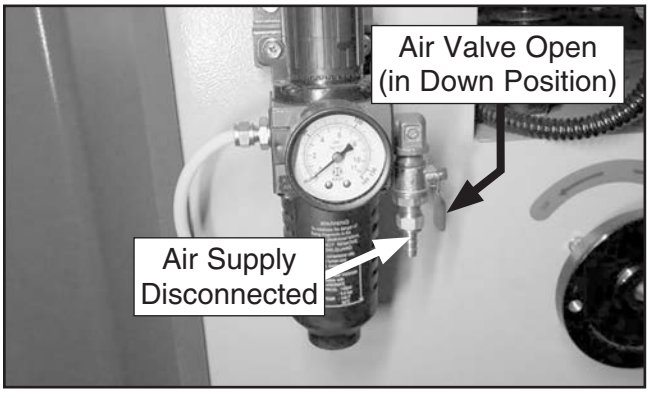


Figure 84. Air supply disconnected, and air valve opened for brake service.

3. Open lower right access panel.

4. Remove (2) mounting bolts, lock washers, and flat washers that secure disc brake assembly to machine motor plate (see **Figure 85**), then pull disc brake assembly away from rotor.

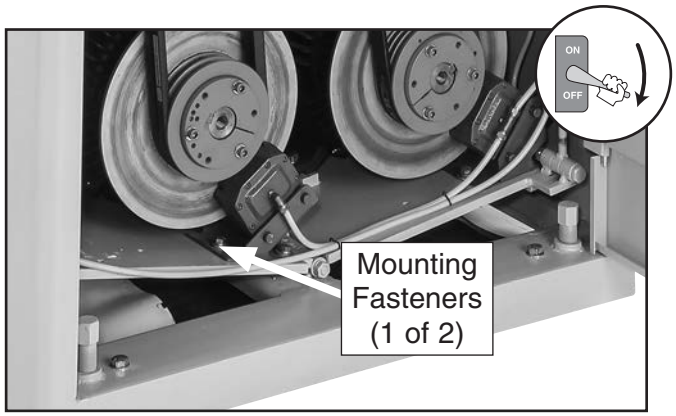


Figure 85. Location of disc brake assembly mounting fasteners.

5. Measure thickness of each brake pad. The brake pads consist of a metal plate with a composite pad. Measure thickness of composite pads only (see **Figure 86**).

   — If thickness of both pads is greater than 1/8" (see **Figure 86**), pads do not need to be replaced. Proceed to **Step 15.**

   — If thickness of either pad is less than 1/8" (see **Figure 86**), proceed to **Step 5** to replace both pads.

6. Loosen lock nut and remove air line connection (see **Figure 86**).

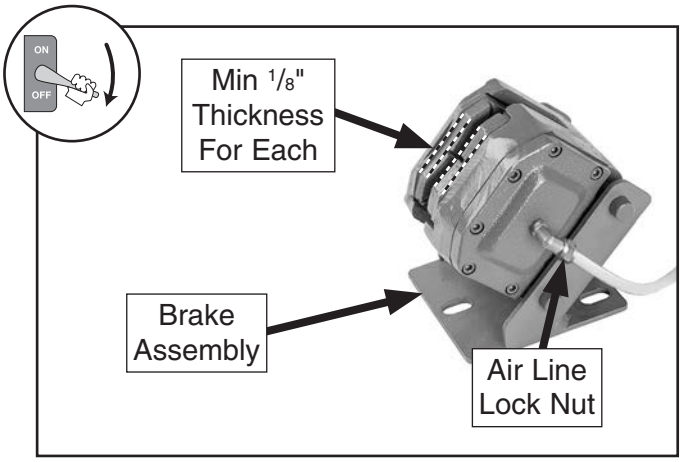


Figure 86. Brake pad measurement.

Note: *Rear motor brake assembly has two air connections to disconnect.*

7. Remove (1) cap screw, then remove inner brake pad (see **Figure 88**).

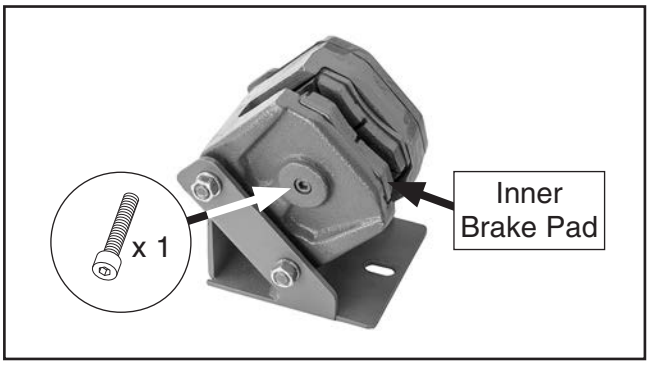


Figure 88. Location of inner brake pad and mounting cap screw.

8. Install new inner brake pad and replace cap screw.

9. Remove (1) brake mount stud by removing lock washer and hex nut (see **Figure 89**).

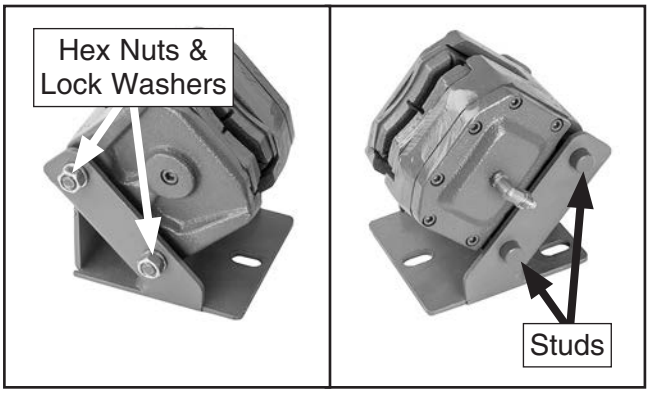


Figure 89. Location of brake mount studs and fasteners.

10. Remove (8) cap screws, front brake guard, and gasket (see **Figures 90**).

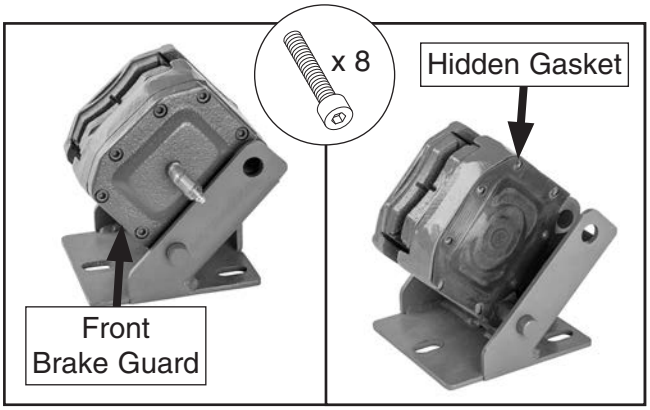


Figure 90. Location of front brake guard, cap screws, and gasket.

11. Remove (1) flat head screw, brake mounting plate, compression spring, bushing, and outer brake pad (see **Figure 91**).

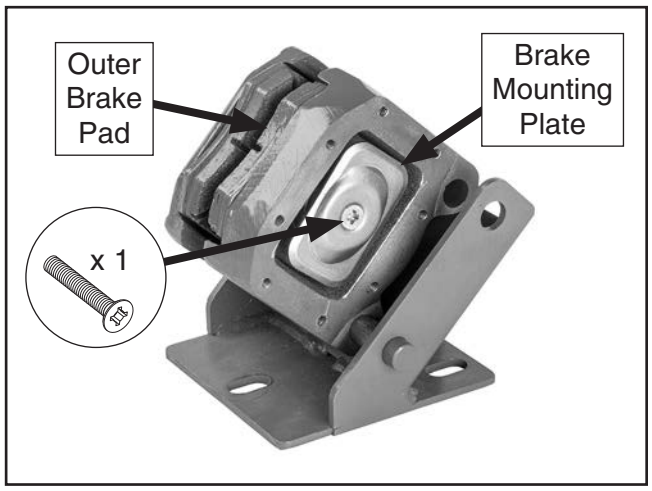


Figure 91. Location of brake mounting plate, mounting screw, and outer brake pad.

Note: *Be careful when removing these components. They are under pressure from the compression spring (see **Figure 92**), and could fly apart unexpectedly.*

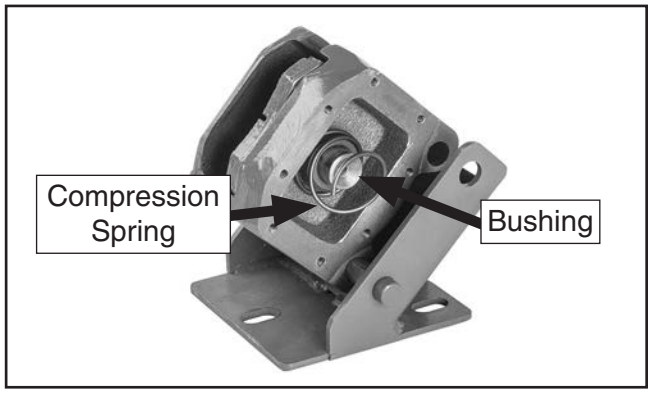


Figure 92. Location of compression spring and bushing.

12. Install new outer brake pad then secure with bushing, spring, mounting plate, and flat head screw. Make sure to re-install components in same order and orientation as they were removed (see **Figure 93**).

Note: *The countersunk end of the bushing faces the diaphragm plate (see **Figure 93**).*

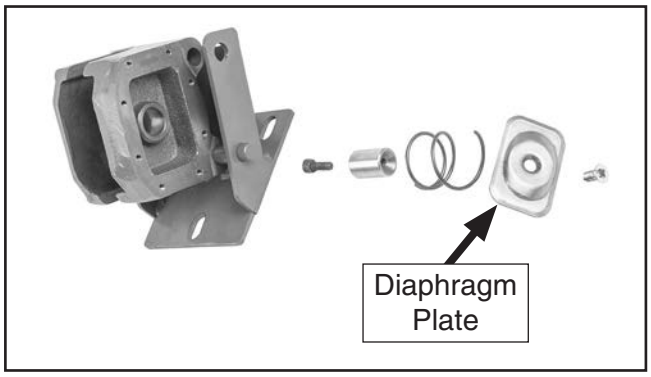


Figure 93. Order of assembly for outer brake pad components.

13. Install gasket, front brake guard, screws and stud removed in **Steps 9–10**.

14. Install lock washer and hex nut removed in **Step 9**.

15. Install disc brake assembly around rotor on motor base using (2) mounting bolts and washers removed in **Step 4**.

16. Connect air line removed in **Step 6** and secure with lock nut.

17. Replace brake pads on second brake assembly in same manner as the first.

18. Close lower right access door.

19. Connect air supply to air regulator and machine to power and start sander to test Emergency Stop system to make sure brake works.

Checking/Adjusting Table Parallelism

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

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

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

The four corners of the table can be independently adjusted up or down to achieve parallelism with the frame by adjusting the elevation leadscrew flanges (see **Figure 94**) or repositioning the table elevation sprockets (see **Figure 95**).

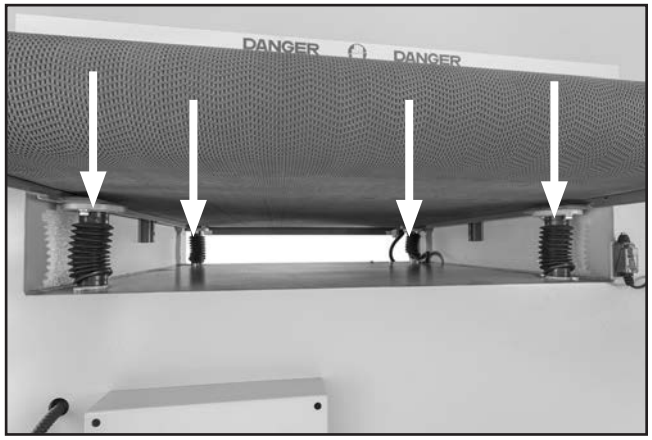


Figure 94. Table elevation leadscrew flanges located on underside of table.

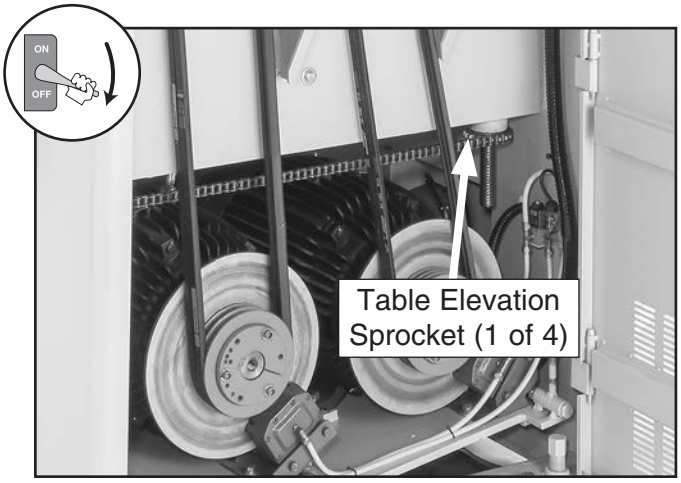


Figure 95. Location of table elevation sprockets (1 of 4 shown).

If a table adjustment is needed, take precise notes on the positioning of the table elevation flanges, sprockets, and leadscrews by marking them. This will allow the original setting to be restored if needed.

Tools Needed:	**Qty**
Vacuum Cleaner	1
Shop Rags	As Needed
Wood Block Approx. 4" Long	1
Fine Ruler	1
Open-End Wrench 12, 15, 18mm	1 Ea.
White Marker or Correction Fluid	As Needed

Checking Table Parallelism

1. DISCONNECT MACHINE FROM POWER!

2. Use vacuum cleaner and shop rag to clean table and frame at each corner so sawdust will not interfere with measurements during following steps.

3. Adjust table elevation until it is approximately 6" below sanding belt.

4. Take precise measurement of wood block (approx. 4" long) and record measurement.

5. Place wood block on edge of table, at rear left corner, then raise table until wood block just touches upper frame (see **Figure 96**). Do not allow table to squeeze or compress wood block.

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

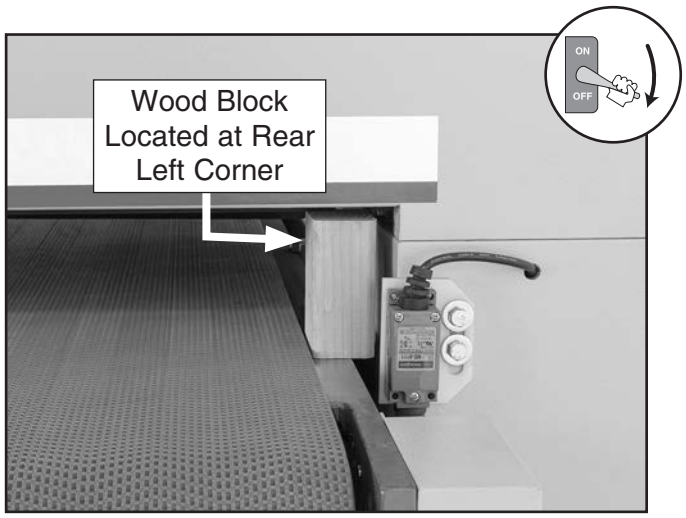


Figure 96. Wood block placed at rear left corner of conveyor table to check table parallelism.

6. Take precise measurements at each of the three remaining corners, between the conveyor table and the upper frame (see **Figure 97**).

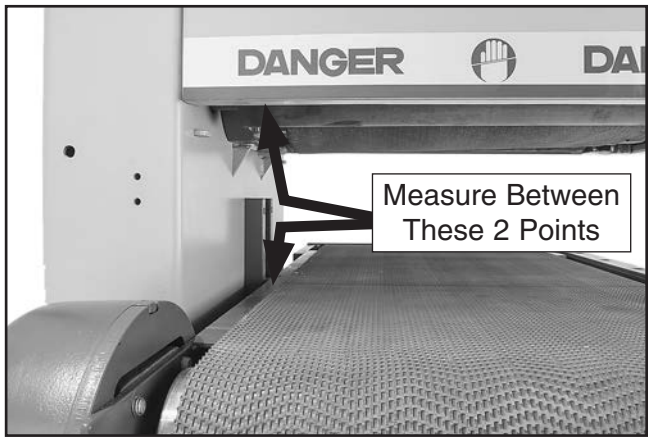


Figure 97. Measurement locations for checking table parallelism.

   — If the measurements from *all* corners in **Step 6** are exactly the same as the length of the wood block, measured in **Step 4**, the table is parallel to the frame and no adjustment is necessary. Remove wood block.

   — If the measurement of *any* corner from **Step 6** is *not* exactly the same as the length of the wood block, measured in **Step 4**, the table is not parallel to the frame. DO NOT remove wood block. Proceed to **Adjusting Table Parallelism**.

Adjusting Table Parallelism

1. DISCONNECT MACHINE FROM POWER!

2. With wood block still positioned at rear left corner of conveyor table, locate elevation leadscrew flange at corner that needs to be adjusted.

3. Loosen table mounting bolts on flange (see **Figure 98**). Rotate flange a small amount to adjust that corner of table until it is within 0.003" of measurement of wood block from **Step 3** of **Checking/Adjusting Table Parallelism** on **Page 55**.

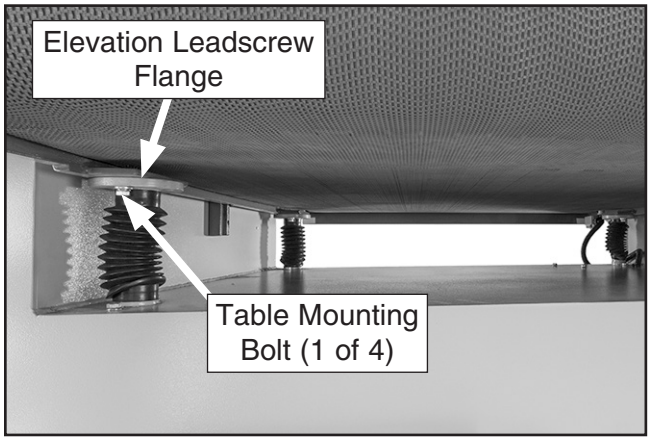


Figure 98. Location of table mounting bolts.

Note: *Each leadscrew flange can be adjusted up to 0.015" between the right and left sides. Rotating left will lower table and rotating right with raise table.*

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

4. Tighten table mounting bolts to secure adjustment.

5. Repeat **Steps 1–4** for any remaining corners that are not parallel with wood block corner.

   — If all corners of conveyor table are exactly same distance from upper frame, table is parallel and no further adjustment is necessary.

   — If any of corners are still higher or lower than corner with wood block by more than 0.003", you will need to adjust the elevation leadscrew sprocket at that specific corner of the table. Proceed to **Step 6**.

6. Open both lower access panels.

7. Mark one tooth of sprocket (see **Figure 99**) that you are adjusting, and its location on frame.

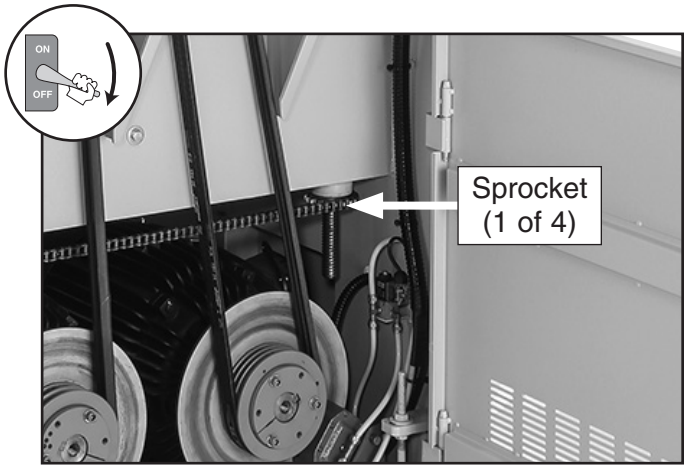


Figure 99. Sprocket location.

8. Loosen chain tensioner sprocket adjustment nut on sprocket wheel shaft and loosen jam nut on chain tensioner rod (see **Figure 100**).

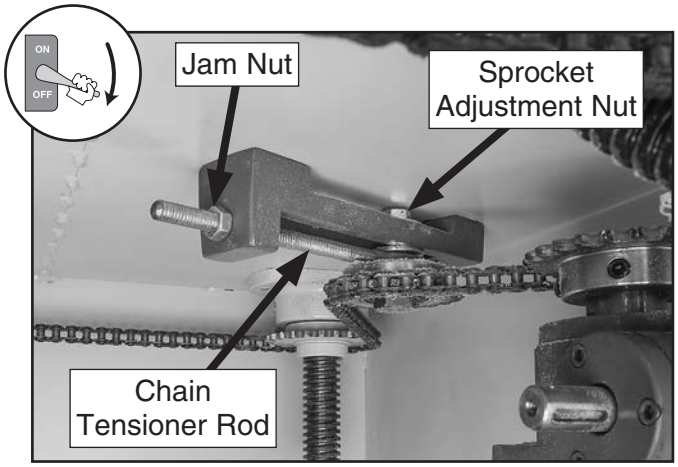


Figure 100. Table elevation chain tensioner components.

9. Push sprocket adjustment rod toward frame (away from you) to loosen chain tension.

10. Remove chain from sprocket you want to adjust so only that sprocket can be moved independent of chain.

11. Carefully rotate sprocket just enough to position next tooth at marked location from **Step 7**, then fit chain around sprocket again.

    Note: *Rotate sprocket counterclockwise to raise table; rotate sprocket clockwise to lower table.*

12. Pull chain tensioner rod toward you, tighten jam nut until chain is moderately tight, then tighten sprocket nut to secure (see **Figure 100**).

13. Check table parallelism (refer to **Checking Table Parallelism** on **Page 55**) and, if necessary, repeat **Steps 2–12** until all corners of table are the same distance from upper frame.

14. Remove wood block and close lower access panels.

Checking/Adjusting Pressure Rollers

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

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

Factory Settings

Pressure Roller Setting Below Bottom of Sanding Drum ..... 0.035"

Tools Needed	Qty
6' Long 2x4 Cut in Half	1
Open-End Wrench 15mm	2

To check/adjust pressure rollers:

1. DISCONNECT MACHINE FROM POWER!

2. Use jointer and table saw to cut 6' long 2x4 to uniform thickness then cut it in half. Place one board along length of conveyor belt on right-hand side, and place other board on left-hand side, as shown in **Figure 101**.

Figure 101. Example of 2x4s placed on conveyor belt under sanding drum.

3. Open upper right access door and remove V-belts from main motors and sanding drums (refer to **Changing V-Belts** on **Page 60** for more information).

4. Rotate a sanding drum by hand, and manually raise table until you hear sandpaper just contact surface of wood. DO NOT continue to raise table beyond this point.

5. Close upper right access door.

6. Connect machine to power and make note of workpiece thickness, then lower table 0.035". This is how much lower infeed and outfeed pressure rollers should be compared to sanding surface of sanding drum.

7. DISCONNECT MACHINE FROM POWER!

8. Open upper left and right access doors.

9. Loosen infeed pressure roller jam nuts on infeed pressure roller, rotate adjustment bolts (see **Figure 102**) to lower infeed pressure roller until it just touches boards, then retighten jam nuts to secure.

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

10. Repeat **Steps 8–9** for outfeed and center pressure rollers (see **Figure 102**).

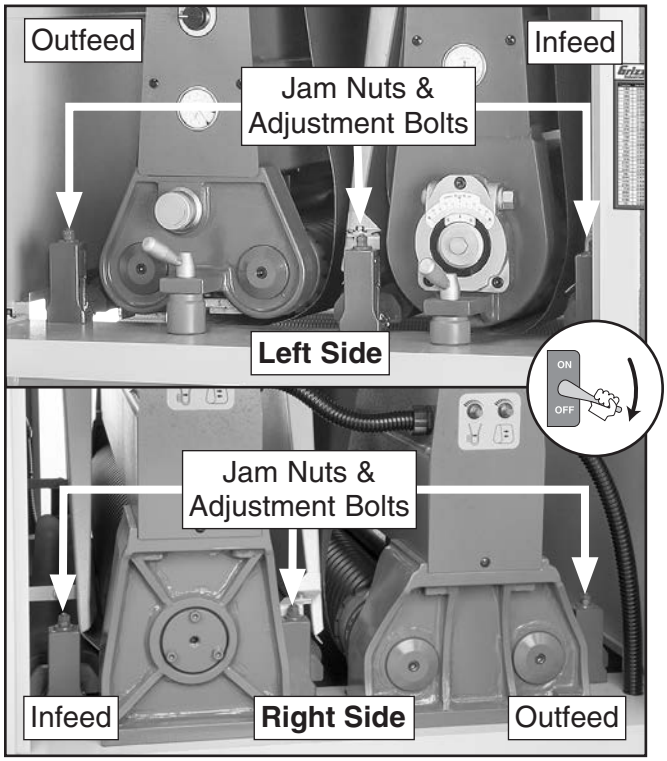


Figure 102. Locations of pressure roller adjustment components.

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

11. Install V-belts (refer to **Changing V-Belts** on **Page 60**).

12. Lower table and remove 2x4s.

13. Close and secure all access doors.

Checking/Adjusting V-Belt Tension

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

IMPORTANT: Loose belts will not allow the sanding drum to stop immediately if the EMERGENCY STOP! plate or Emergency Stop button is pushed.

Tool Needed	**Qty**
Open-End Wrench 12mm	1

To check/adjust V-belt tension:

1. DISCONNECT MACHINE FROM POWER!

2. Open lower left and right access panels.

3. Check belt tension: each belt is correctly tensioned when there is approximately ½"–¾" deflection when it is pushed with moderate pressure, as shown in **Figure 103**.

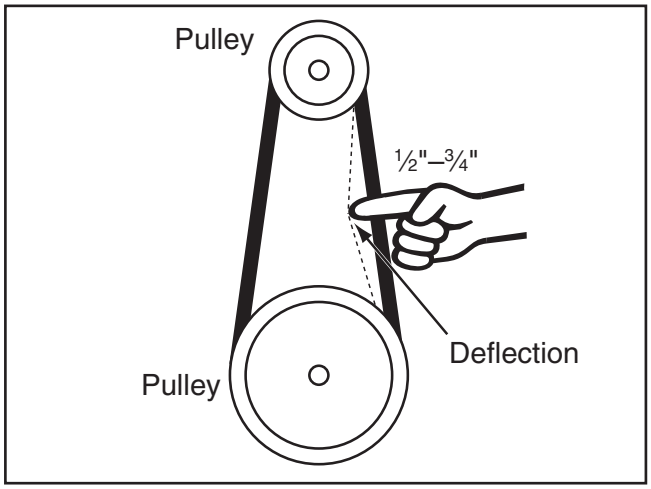


Figure 103. Checking V-belt deflection.

— If there *is* approximately ½"–¾" deflection when V-belts are pushed with moderate pressure, V-belts are properly tensioned, and no adjustment is necessary.

— If there *is not* approximately ½"–¾" deflection when V-belts are pushed with moderate pressure, V-belts are not properly tensioned. Proceed to **Step 4**.

4. Loosen applicable V-belt tension jam nuts to allow motors to raise or lower (see **Figure 104**).

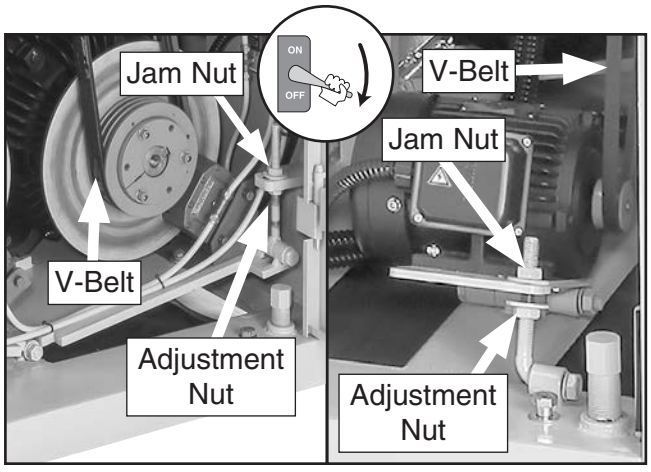


Figure 104. V-belt tension adjustment components.

5. Rotate V-belt tension adjustment nuts to raise or lower motors until there is approximately ½"–¾" deflection when V-belts are pushed with moderate pressure, then tighten jam nut to secure.

   — Rotate adjustment nuts clockwise to allow motors to drop and apply tension to V-belts.

   — Rotate adjustment nuts counterclockwise to raise motors and release V-belt tension.

6. Close and secure access panels.

Changing V-Belts

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

Changing Table Elevation V-Belt

Tools Needed	Qty
Open-End Wrench 12mm	1

To change table elevation V-belt:

1. DISCONNECT MACHINE FROM POWER!

2. Open lower left access panel.

3. Loosen V-belt tension jam nut to allow motor to raise or lower (see **Figure 105**).

4. Rotate V-belt tension adjustment nut counterclockwise to release V-belt tension (see **Figure 105**) until you can remove V-belt from pulleys

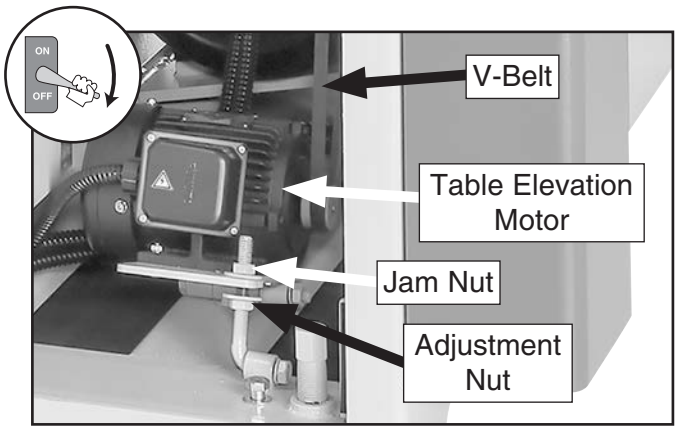


Figure 105. Table elevation motor V-belt tension components.

5. Place new V-belt onto table pulley and then loop other end of V-belt around motor pulley (see **Figure 106**).

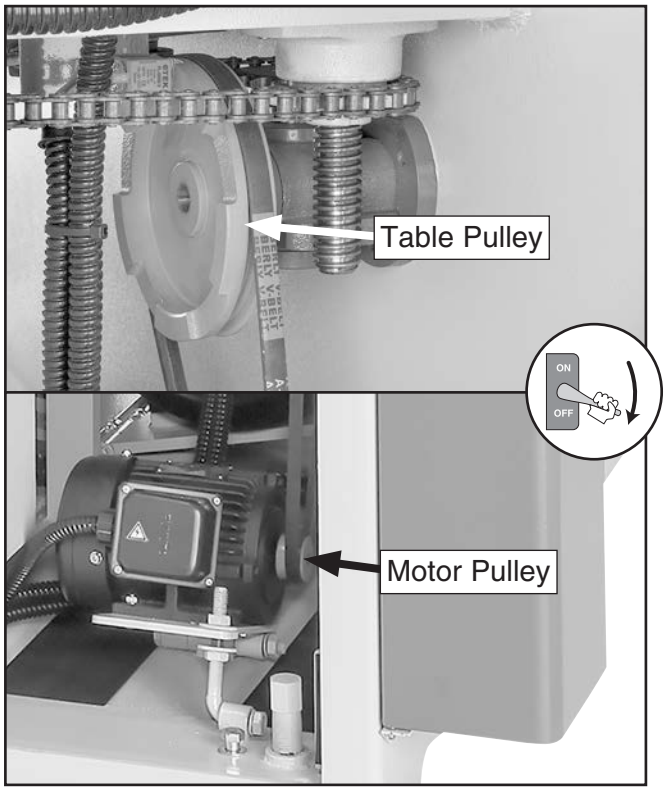


Figure 106. Location of table and motor pulleys.

6. Properly tension V-belt (refer to **Checking/ Adjusting V-Belt Tension** on **Page 59** for more information).

7. Close and secure lower left access panel.

Changing Main Motor V-Belts

Tools Needed	Qty
Open-End Wrench 12mm	1
Hex Wrench 6, 8mm	1 Ea.
2' Long 2x4 Cut in Half	1
Roller Extraction Bolt	1

To change main motor V-belts:

1. DISCONNECT MACHINE FROM POWER!

2. Open upper and lower right access panels.

3. Loosen V-belt tension jam nuts to allow motors to raise or lower (see **Figure 107**).

4. Rotate V-belt tension adjustment nuts counterclockwise to release V-belt tension (see **Figure 107**) until you can remove V-belts from motor pulleys.

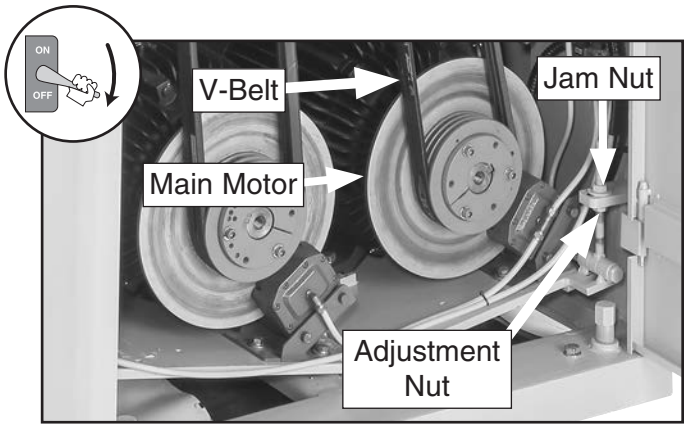


Figure 107. Main motor V-belt tension components.

5. Prepare two 12" long wood blocks of equal thickness and place them under rubber rollers for support.

6. Loosen (3) cap screws holding eccentric shaft and tube in place for front rubber roller (see **Figure 108**).

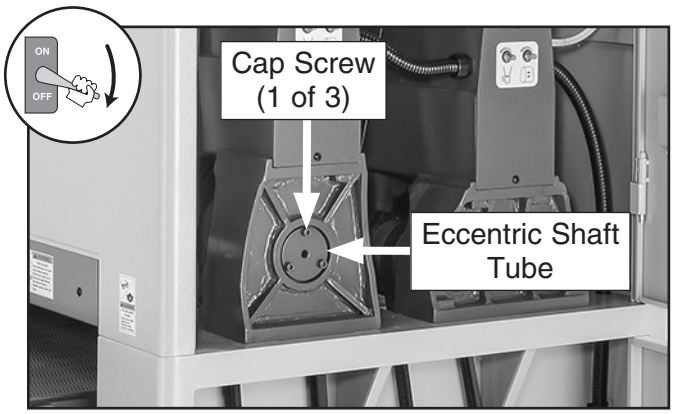


Figure 108. Eccentric tube cap screws location.

7. Thread roller extraction bolt into center of eccentric tube.

8. Use roller extraction bolt to pull eccentric tube out until belt can be taken off roller pulley.

9. Remove (2) cap screws holding roller centering washers (see **Figure 109**).

10. Remove (2) Phillips head screws shown in **Figure 109**, securing square frame end.

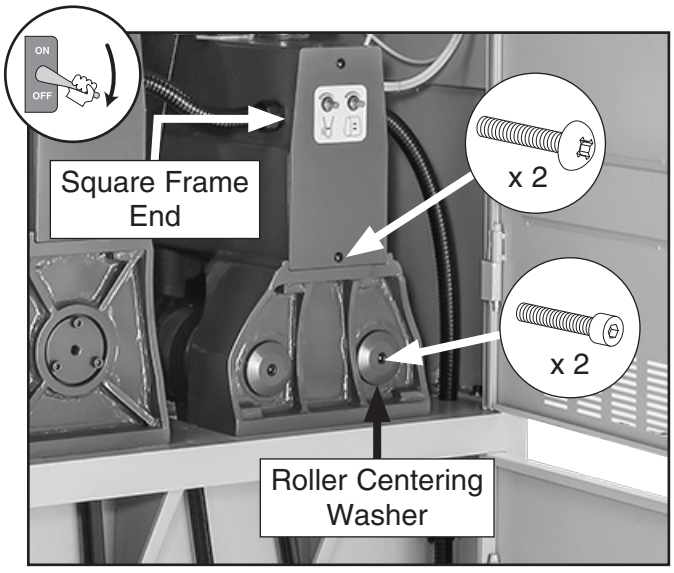


Figure 109. Location of centering washer cap screws and square frame end Phillips head screws.

11. Remove (8) hex bolts and flat washers securing bearing housing in place (see **Figures 110–111**).

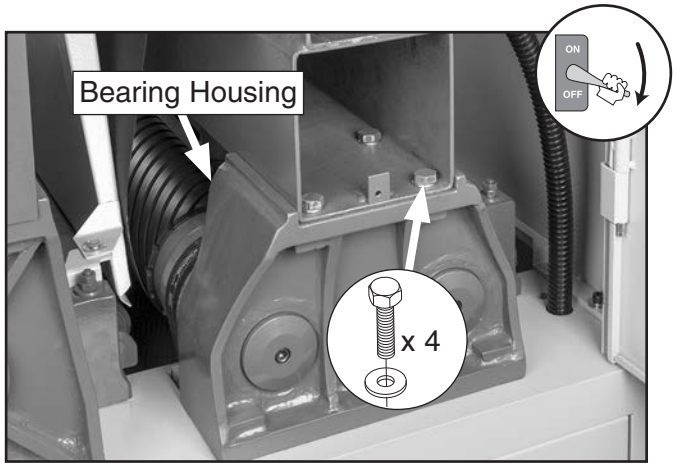


Figure 110. Location of top bearing housing hex bolts and washers.

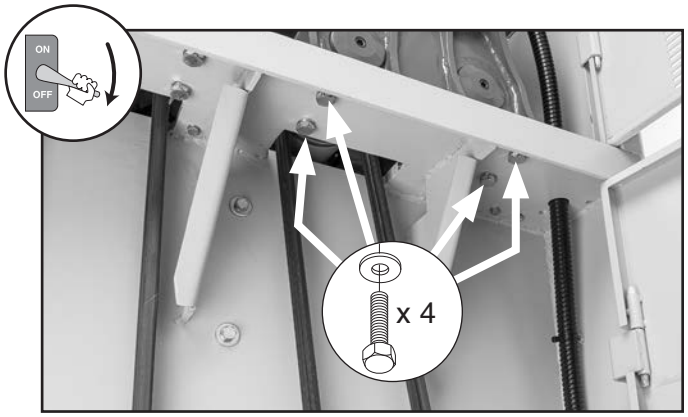


Figure 111. Location of bottom bearing housing hex bolts and washers.

12. Remove bearing housing to access right rubber roller pulley and remove old V-belt.

13. Place new set of V-belts onto rubber roller pulleys and then loop other end of V-belts around motor pulleys (see **Figure 112**).

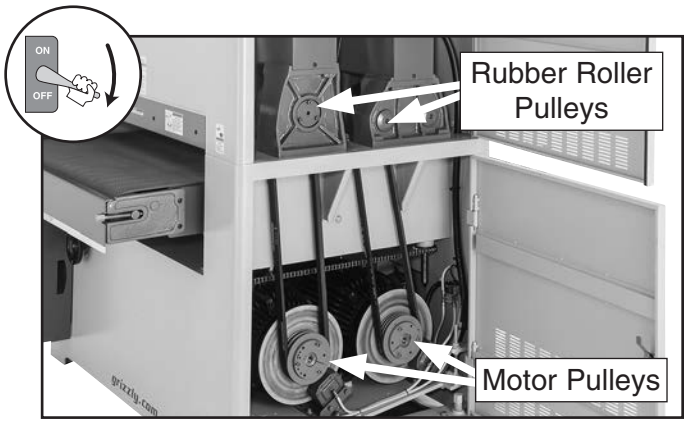


Figure 112. Location of drum and motor pulleys.

14. Install eccentric tube and tighten cap screws to secure.

15. Install bearing housing and secure with hex bolts and washers removed in **Step 11**.

16. Install square frame end and securing Phillips head screws, then replace cap screws removed in **Step 9**.

17. Remove wood blocks supporting rollers.

18. Properly tension V-belts (refer to **Checking/ Adjusting V-Belt Tension** on **Page 59** for more information).

19. Close and secure right access panels.

Adjusting Conveyor Belt Tension

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

The conveyor belt tension is adjusted by rotating two adjustment bolts, located on each side of the conveyor table (see **Figure 113**).

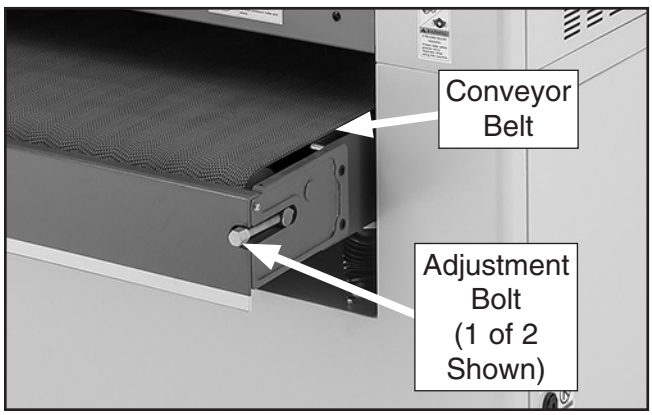


Figure 113. Location of conveyor belt adjustment bolts (1 of 2 shown).

Tool Needed:	**Qty**
Open-End Wrench 19mm	1

To adjust conveyor belt tension:

1. DISCONNECT MACHINE FROM POWER!

2. Rotate both left and right adjustment bolts (see **Figure 113** on **Page 62**) equally to adjust conveyor belt tension. When tensioned properly, you should not be able to lift the conveyor belt off of table surface or slide it back and forth.

   — Rotate adjustment bolts *clockwise* to *increase* conveyor belt tension.

   — Rotate adjustment bolts *counterclockwise* to *decrease* conveyor belt tension.

Adjusting Conveyor Belt Tracking

The conveyor belt is tracking properly when it stays centered on its rollers during operation and does not wander from side to side. The tracking is adjusted by rotating either the left or right conveyor belt tension adjustment bolt (see **Figure 114**), depending on the needs of the adjustment.

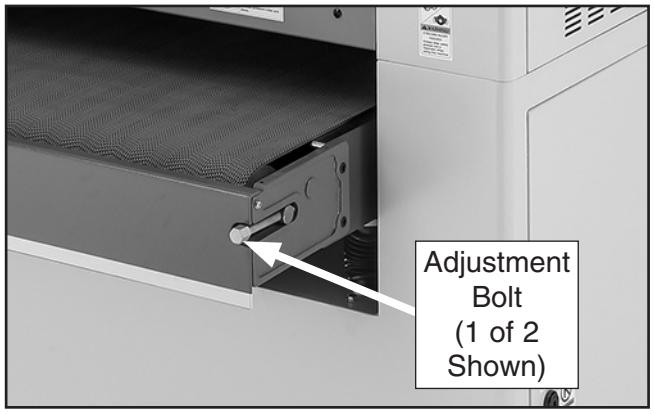


Figure 114. Location of conveyor belt adjustment bolts (1 of 2 shown).

In addition, two guide wheels (see **Figure 115**) protect the conveyor belt from damage if the tracking is out of adjustment, by preventing it from rubbing against the inside surfaces of the conveyor table.

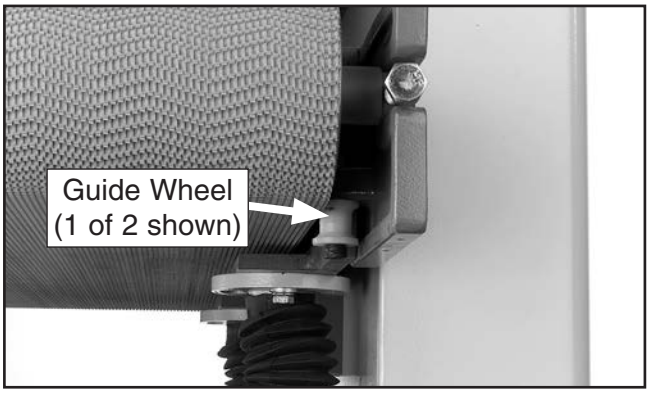


Figure 115. Conveyor belt guide wheels (EMERGENCY STOP! plate removed for clarity).

NOTICE

Always adjust conveyor belt tension before adjusting conveyor belt tracking.

Tool Needed:	**Qty**
Open-End Wrench 19mm	1

To adjust conveyor belt tracking:

1. Turn conveyor belt ***ON***.

   — If conveyor belt is tracking to the *right*, rotate the *right* adjustment bolt (see **Figure 114**) *clockwise*.

   — If conveyor belt is tracking to the *left*, rotate the *left* adjustment bolt (see **Figure 114**) *clockwise*.

2. Run conveyor belt for 3–5 minutes and recheck tracking.

3. Repeat **Steps 1–2**, as necessary, until conveyor belt is properly tracking.

   Note: *The edge of the conveyor belt should just touch the guide wheels as shown in* ***Figure 115****.*

Replacing Conveyor Belt

Replace the conveyor belt if it becomes damaged or you are not able to adjust the conveyor belt tracking due to excessive wear (refer to **Adjusting Conveyor Belt Tracking**, beginning on **Page 63**).

Tools Needed:	**Qty**
Phillips Screwdriver #2	1
Open-End Wrenches 10, 14, 26mm	1 Ea.
8' 2x4s	2
Permanent Marker	1
Lifting Assistants	As Needed

To remove conveyor belt, match steps below to Figure 117 on the following page:

1. Raise table up so conveyor belt is approximately two-inches away from sanding roller or platen, and then DISCONNECT MACHINE FROM POWER!

2. Remove gearbox mounting bracket nuts and washer, and with an assistant's help, slide motor and gearbox from roller shaft and lower it to the floor.

3. Remove two table height limit switches.

4. Open both lower access panels.

5. Remove left and right table guides.

6. Using permanent marker, mark all four leadscrew flange positions (see **Figure 116**), and remove all hex bolts from flanges. Try not to turn flanges during following steps.

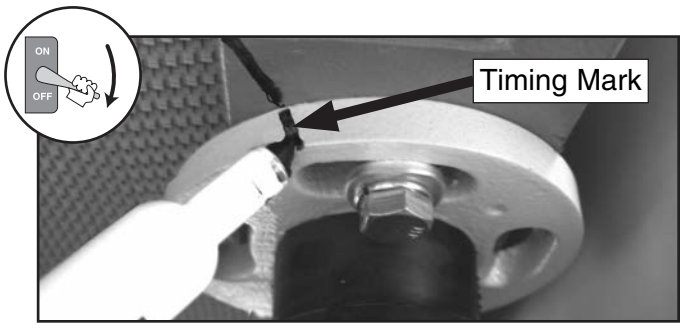


Figure 116. Example of marking leadscrew for re-assembly.

7. Remove EMERGENCY STOP! panel limit switch from table, remove all mounting screws, and remove EMERGENCY STOP! push panel assembly.

8. Insert two 8' 2x4s wooden studs under table for support, then have lifting assistant help lift table slightly and move it out of rear of machine.

9. Turn both tracking adjustment bolts counterclockwise five turns, remove one roller support, and slide drum out of table assembly.

10. Remove the old conveyor belt, inspect rollers, bearings, and table for wear and replace as required.

11. Install new conveyor belt.

    Note: *The belt is non-directional.*

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

13. With lifting assistant, install table from rear.

14. Install table guides and close access panels.

15. Align leadscrew flanges with marks made in **Step 6**, and install hex bolts.

16. Install table height limit switches so upper switch clicks when conveyor surface is ¼" away from sandpaper, and lower switch clocks when conveyor table is ¼" higher than its lowest position. Make sure to test settings with handwheel manually so table does not crash if incorrectly set at first use.

17. With assistant, install gearbox and mounting bracket.

18. Install EMERGENCY STOP! panel assembly and limit switch.

19. Refer to **Adjusting Conveyor Belt Tracking** on **Page 63** to adjust belt tracking.

Conveyor Belt Removal Sequence

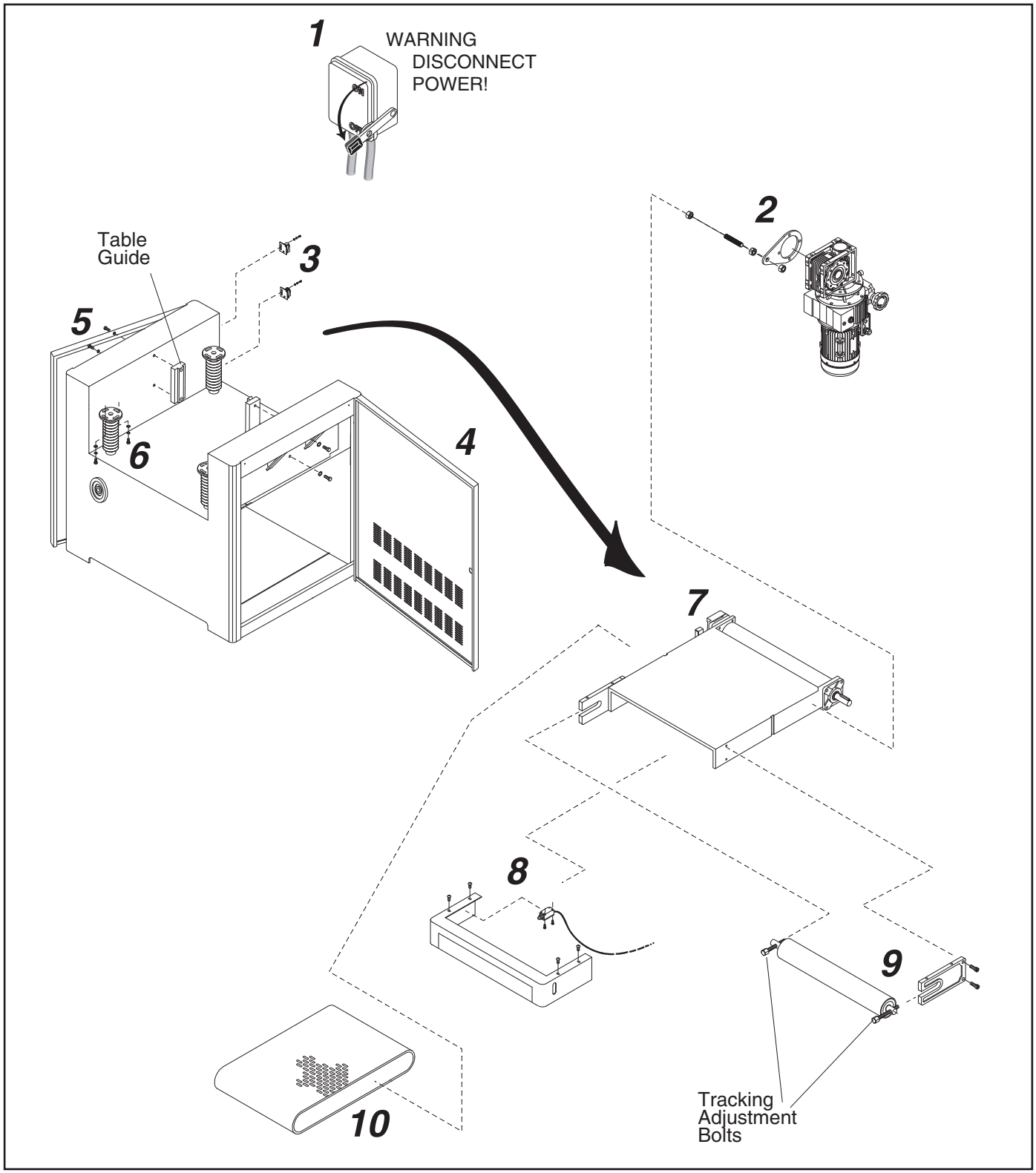
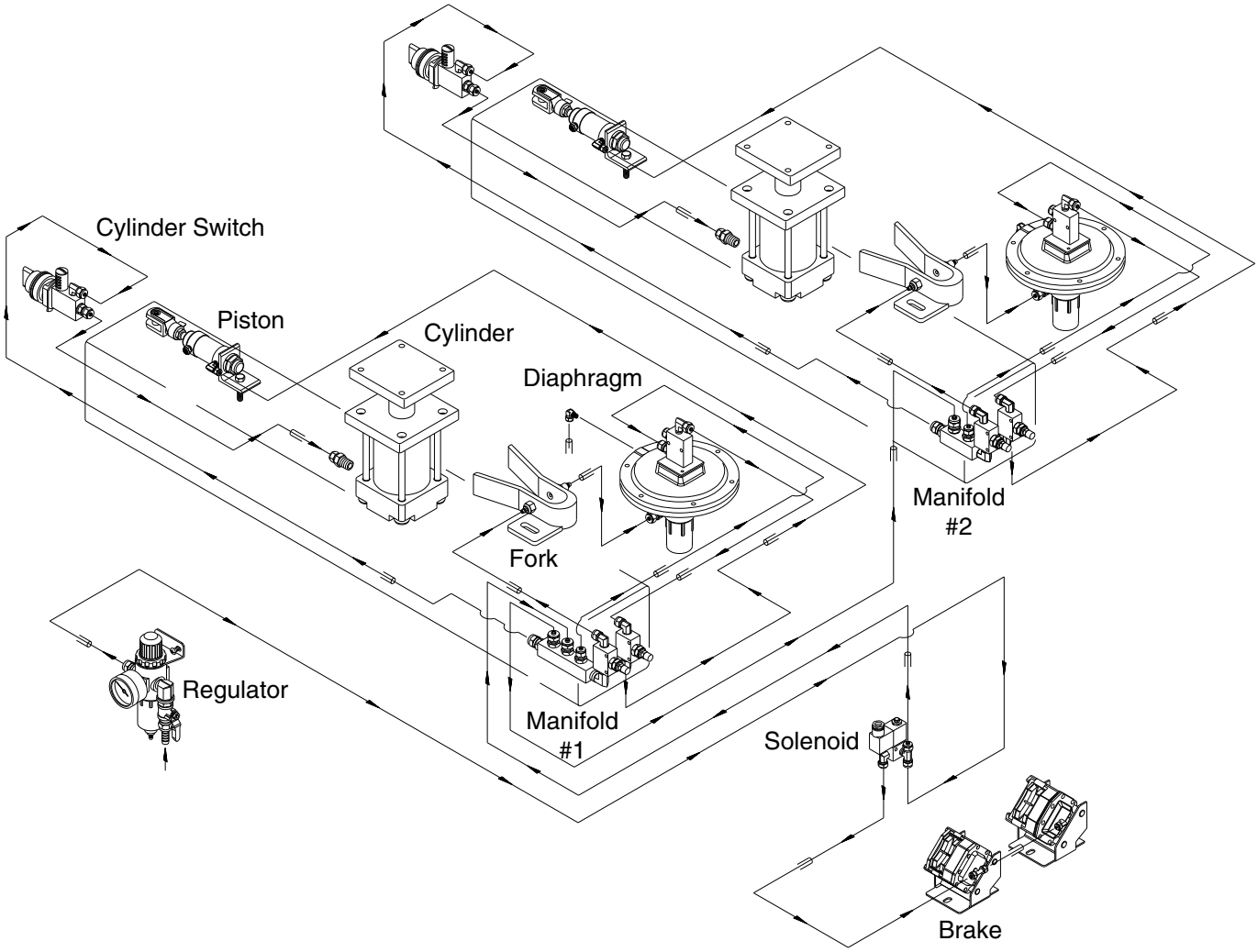


Figure 117. Conveyor belt removal sequence.

Pneumatic System Diagram



Pneumatic System Component Photos

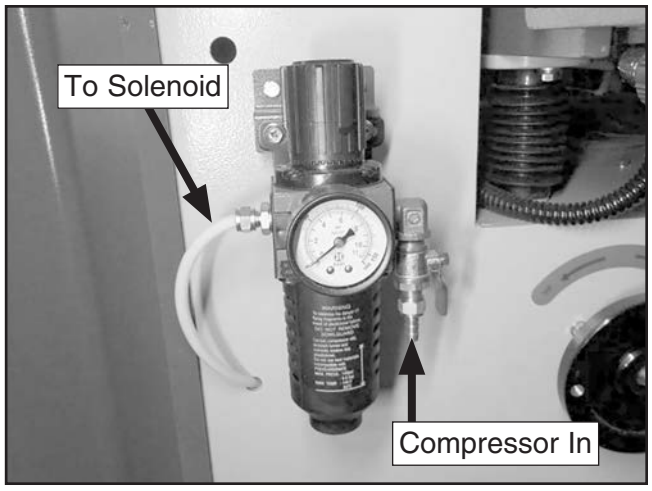


Figure 118. Regulator.

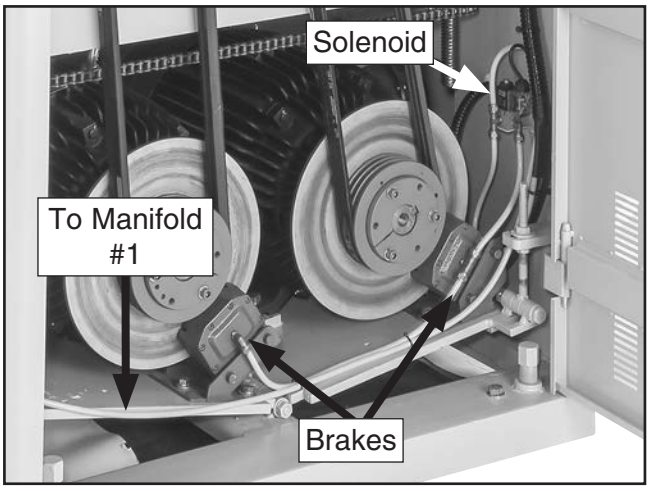


Figure 121. Brakes.

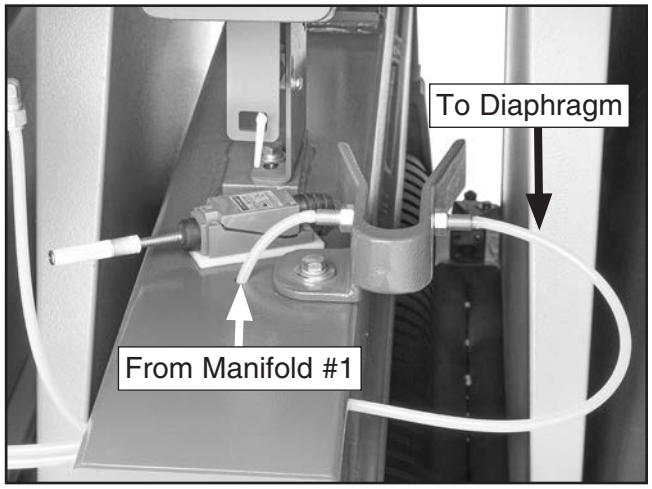


Figure 119. Fork.

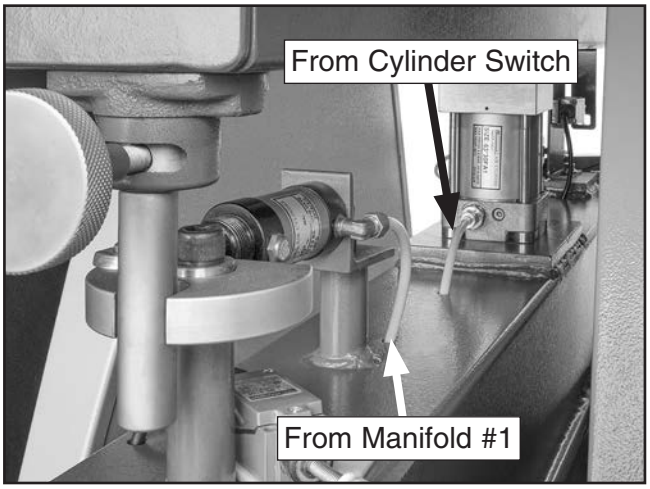


Figure 122. Piston and cylinder.

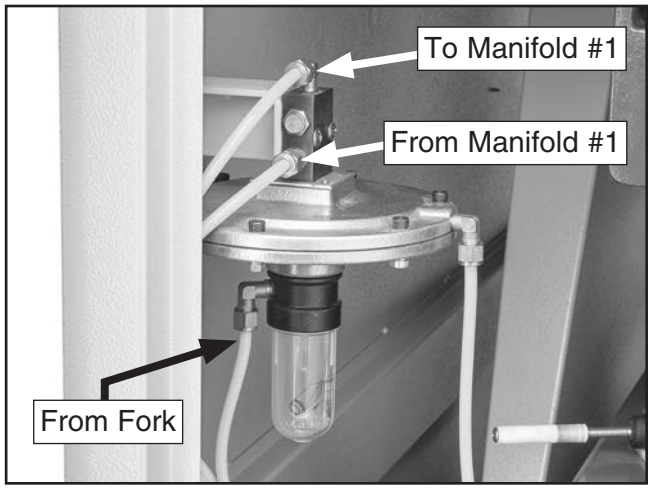


Figure 120. Diaphragm.

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.

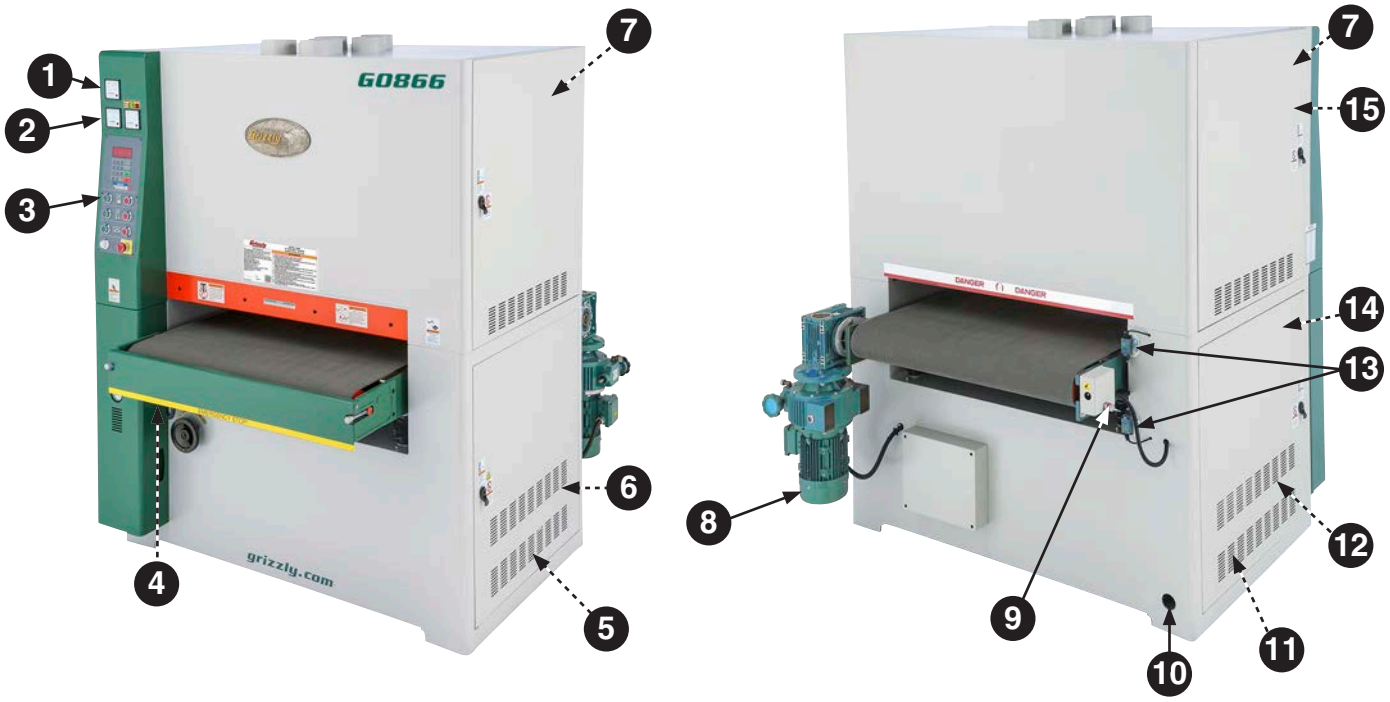
NOTICE

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		

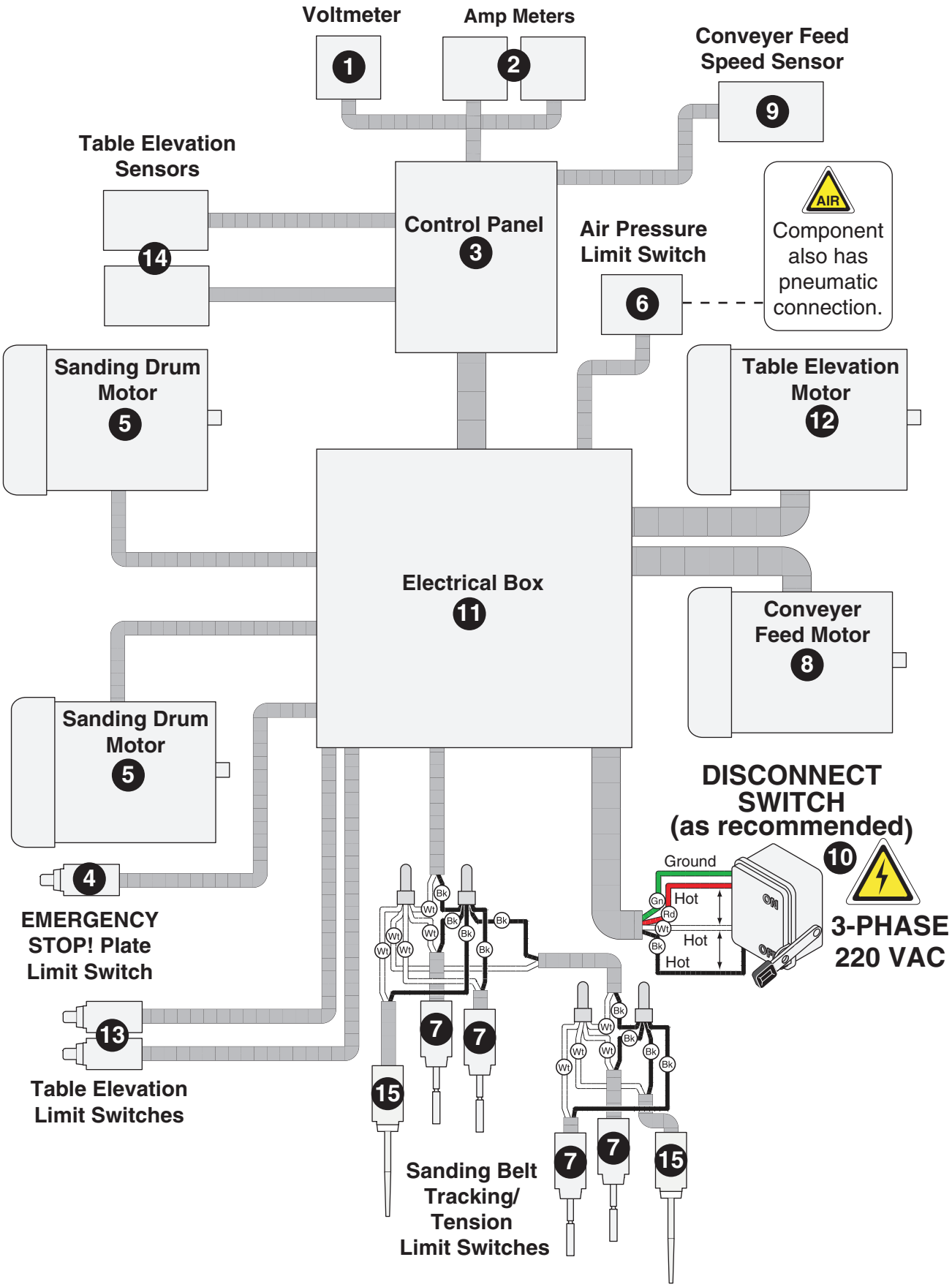
Component Locations



1	Voltmeter (**Page 77**)
2	Amp Meters (**Page 77**)
3	Control Panel (**Page 77**)
4	EMERGENCY STOP! Plate Limit Switch (**Page 78**)
5	Sanding Drum Motors (**Page 75**)
6	Air Pressure Limit Switch (**Page 79**)
7	Sanding Belt Tracking Limit Switches (**Page 78**)
8	Conveyor Feed Motor (**Page 76**)

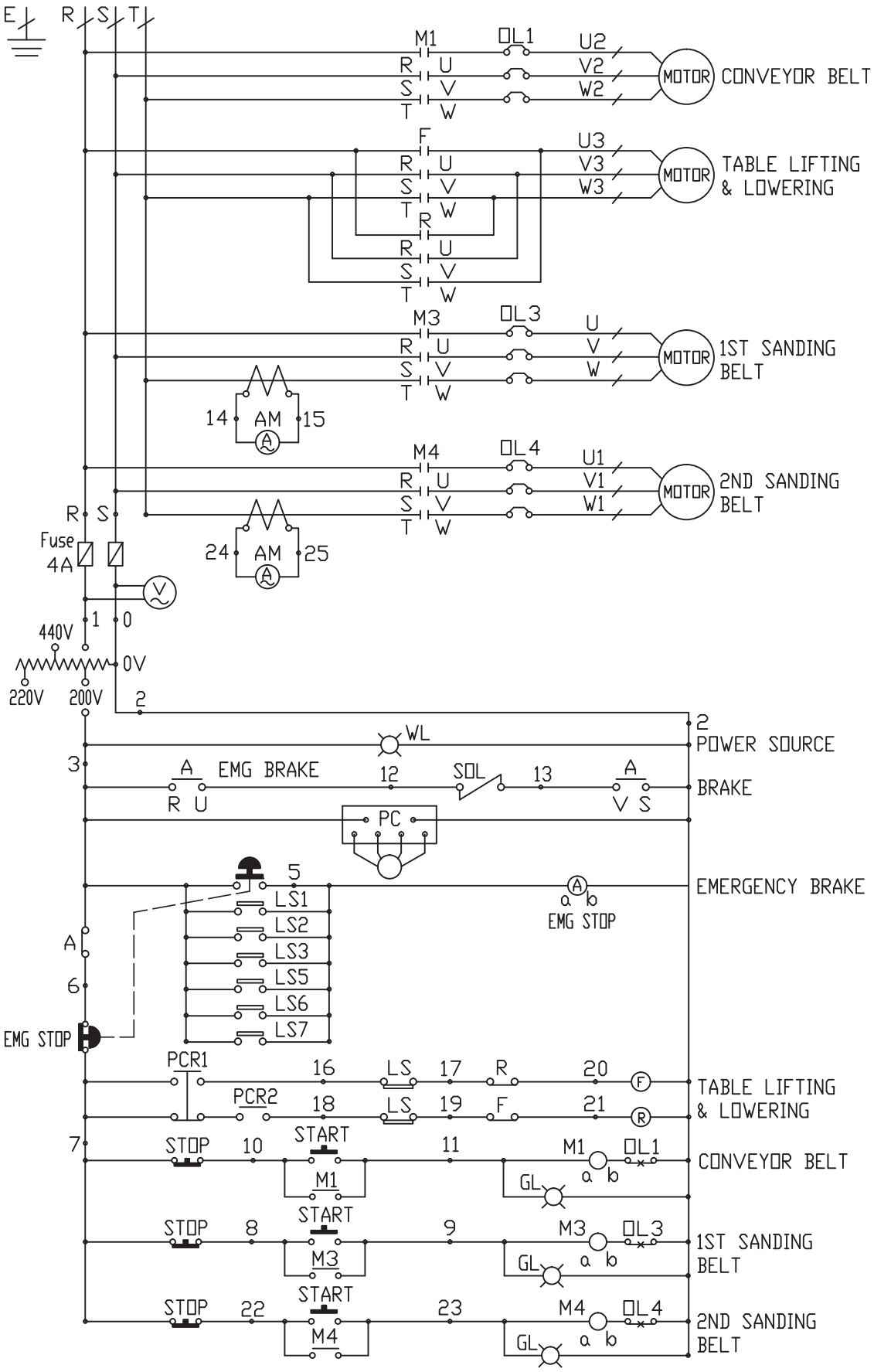
9	Conveyor Feed Speed Sensor (**Page 78**)
10	Power Supply Input (**Page 70**)
11	Electrical Box (**Page 73**)
12	Table Elevation Motor (**Page 76**)
13	Table Elevation Limit Switches (**Page 78**)
14	Table Elevation Sensors (**Page 78**)
15	Sanding Belt Tension Limit Switches (**Page 78**)

Electrical Overview



STOP *READ ELECTRICAL SAFETY ON PAGE 68!*

Electrical System Wiring Schematic



STOP *READ ELECTRICAL SAFETY ON PAGE 68!*

Electrical Box

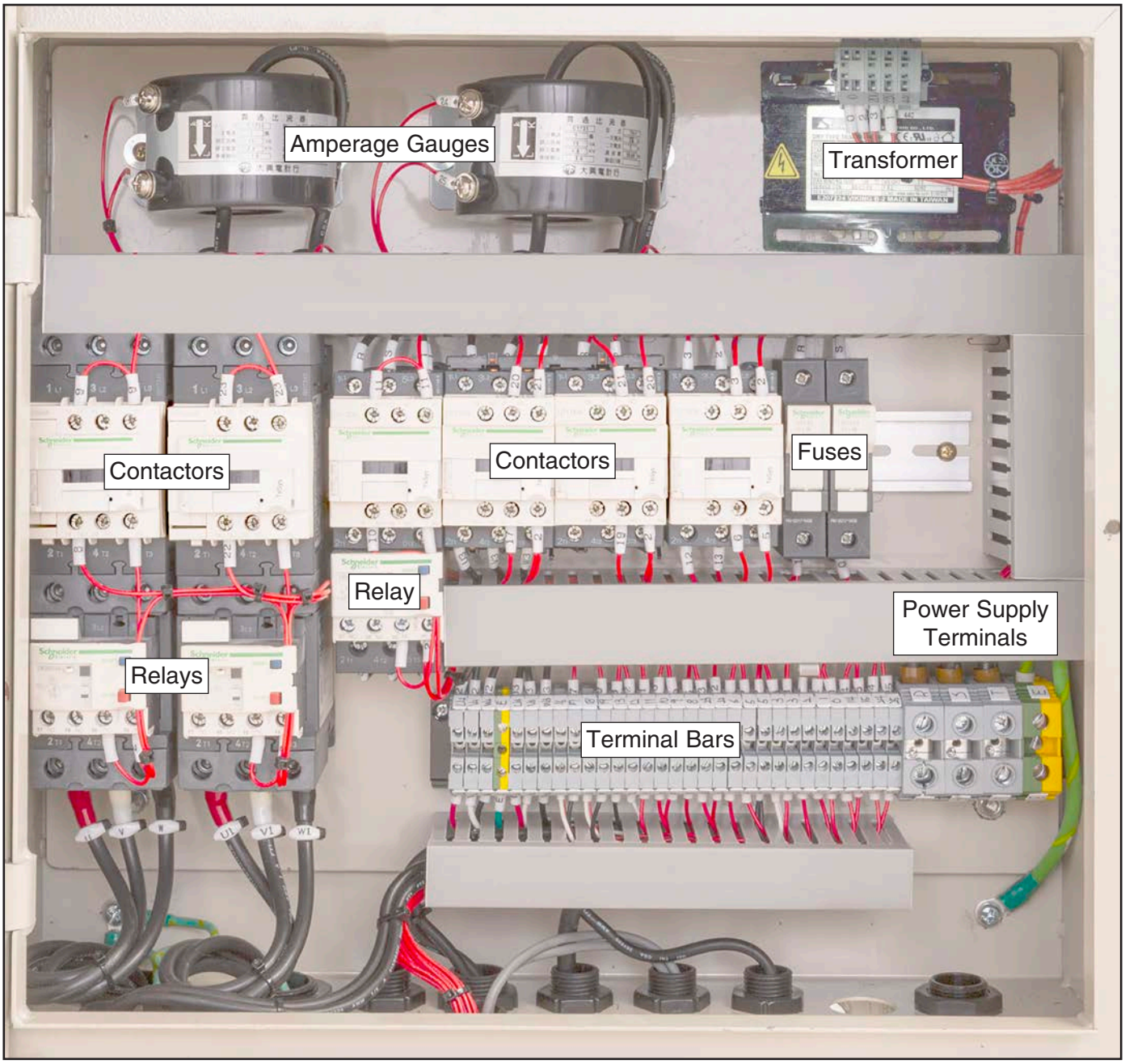
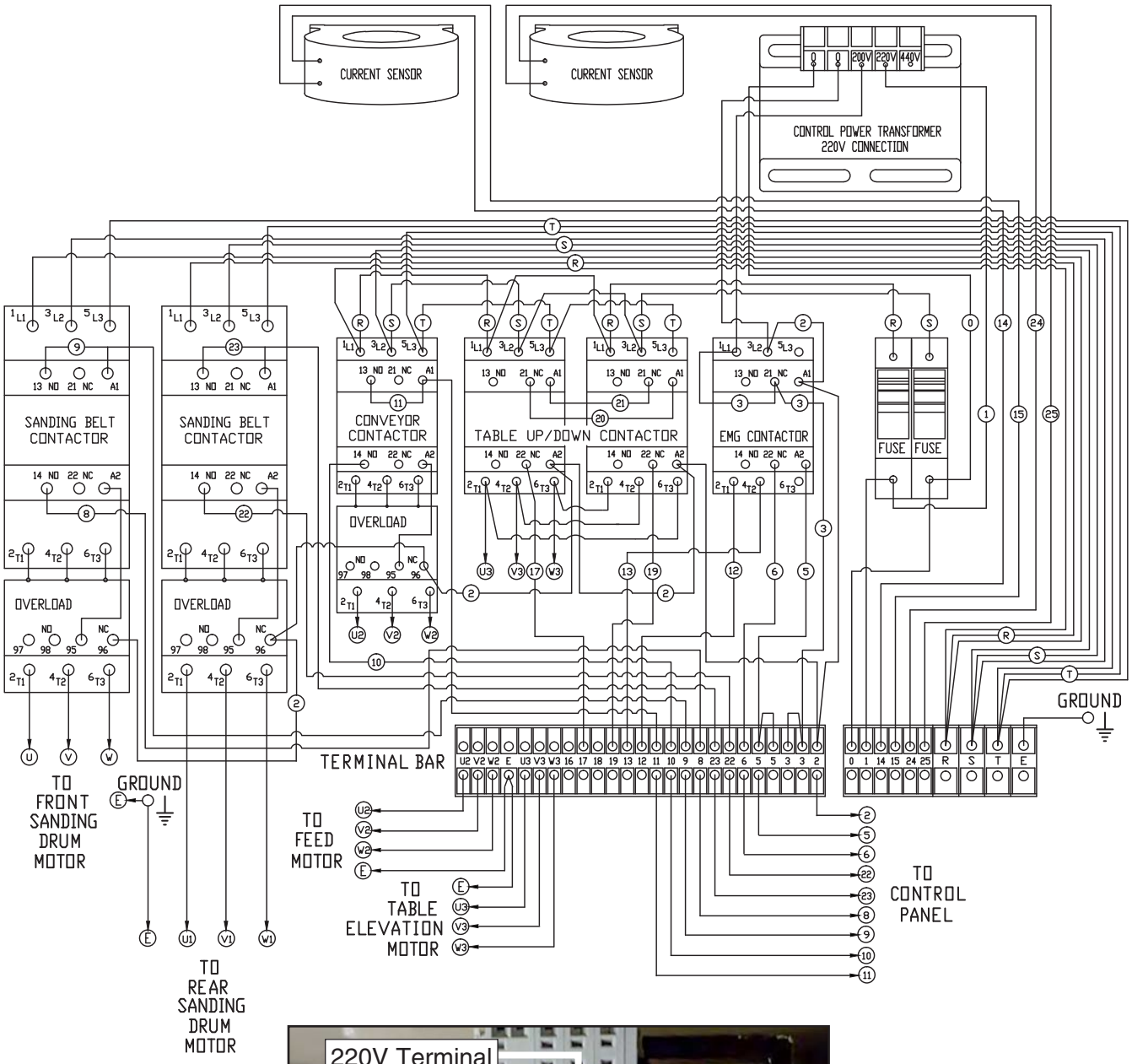


Figure 123. Inside electrical box.

STOP *READ ELECTRICAL SAFETY ON PAGE 68!*

Electrical Box Wiring Schematic (220V)



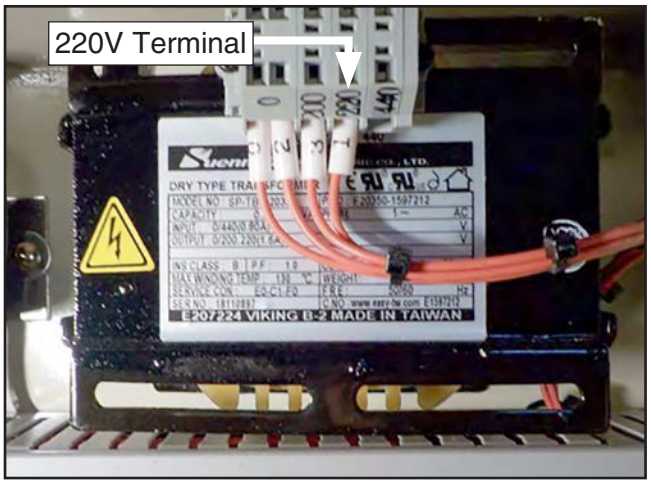
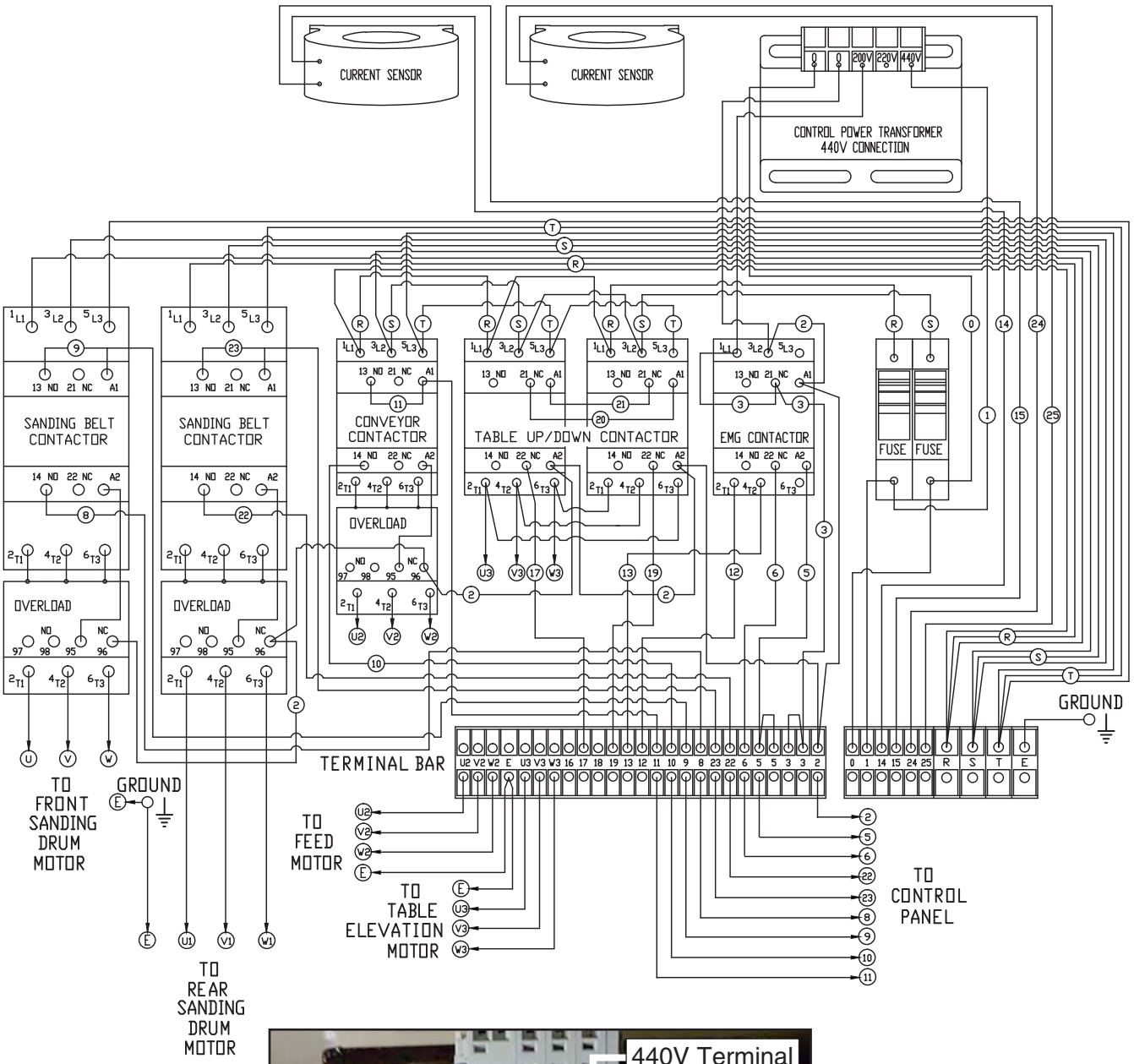


Figure 124. Location of 220V power supply terminal on transformer.

Electrical Box Wiring Schematic (440V)



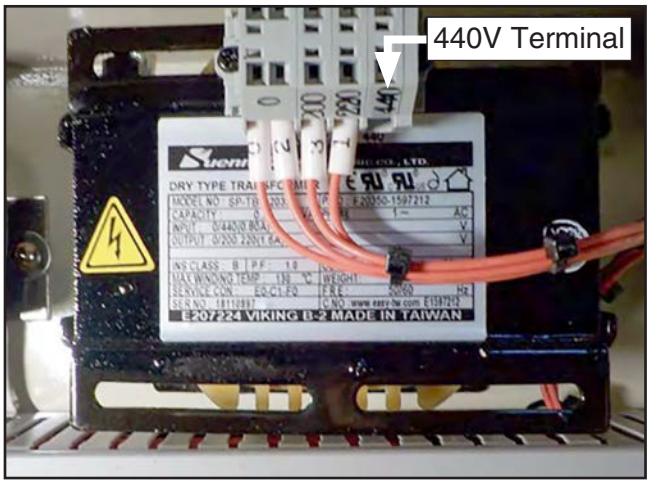
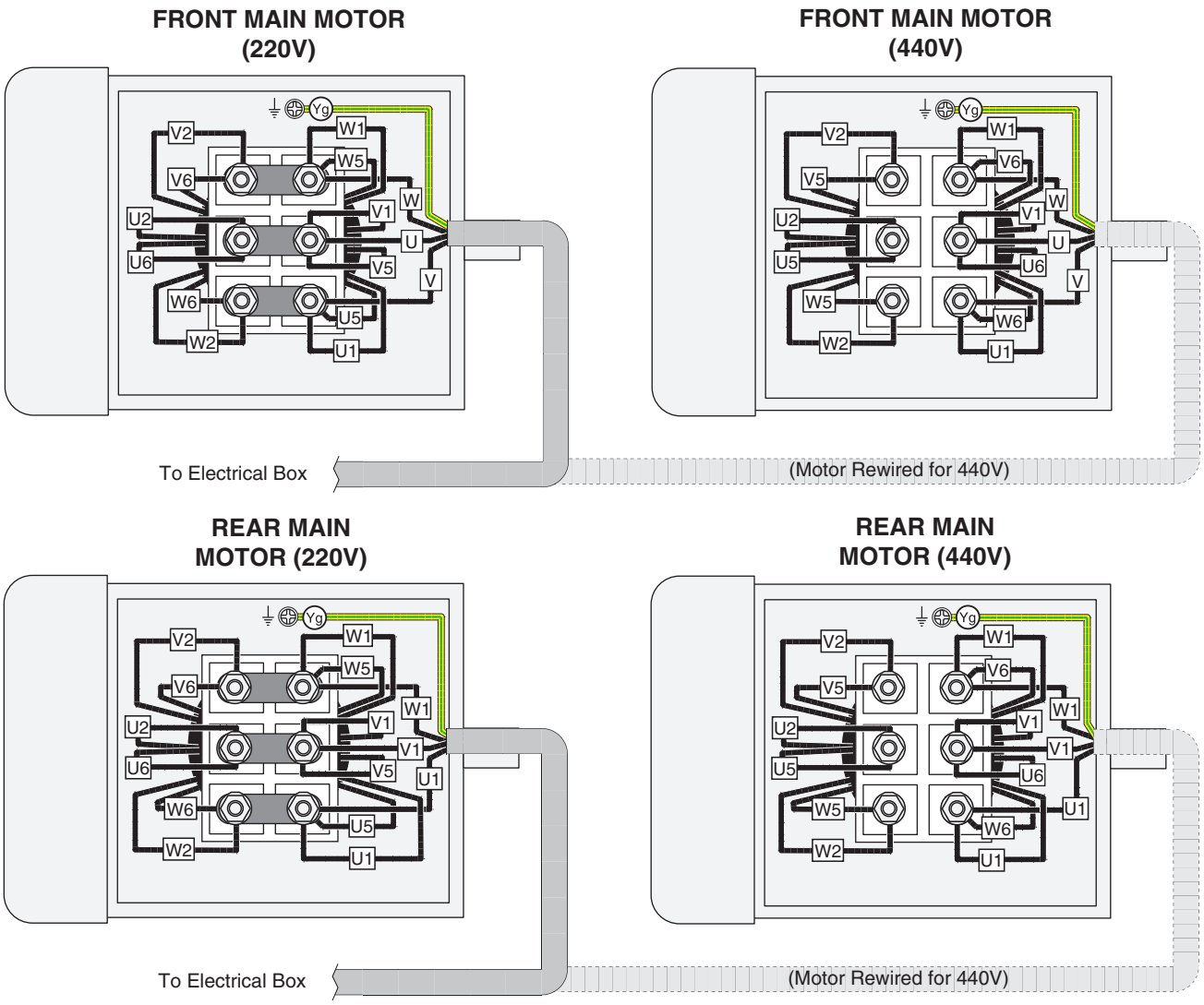


Figure 125. Location of 440V voltage conversion terminal on transformer.

Main Motor Wiring



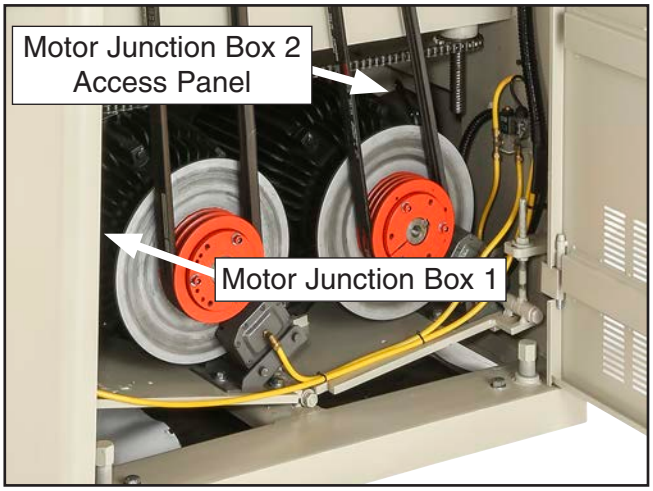
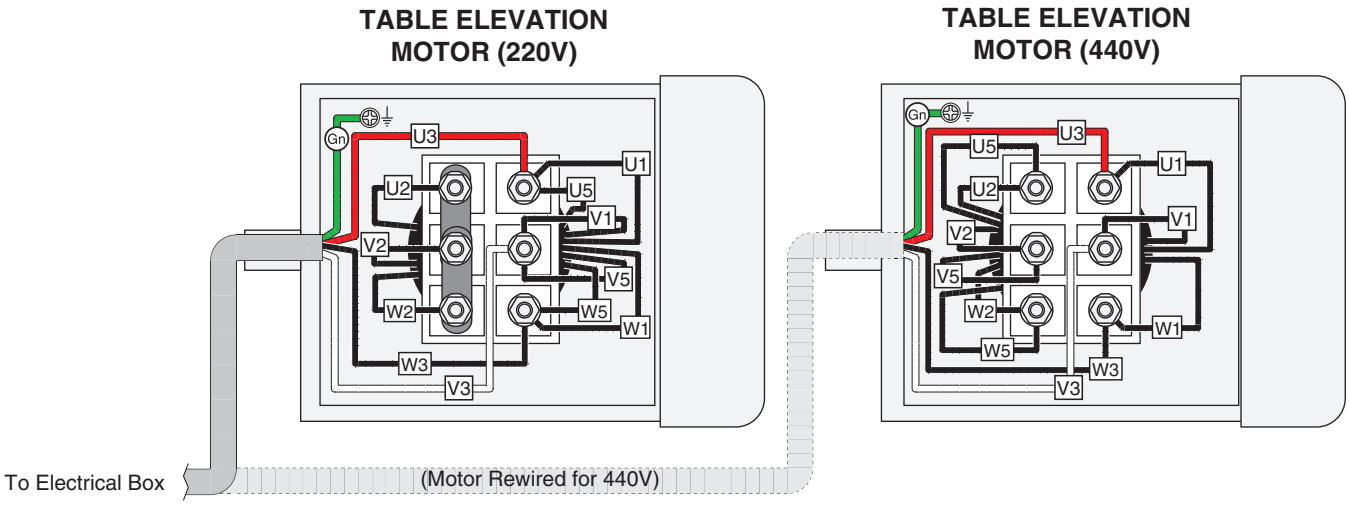


Figure 126. Motor junction box locations.

Figure 127. Main motor junction box.

Table Elevation & Feed Motor Wiring



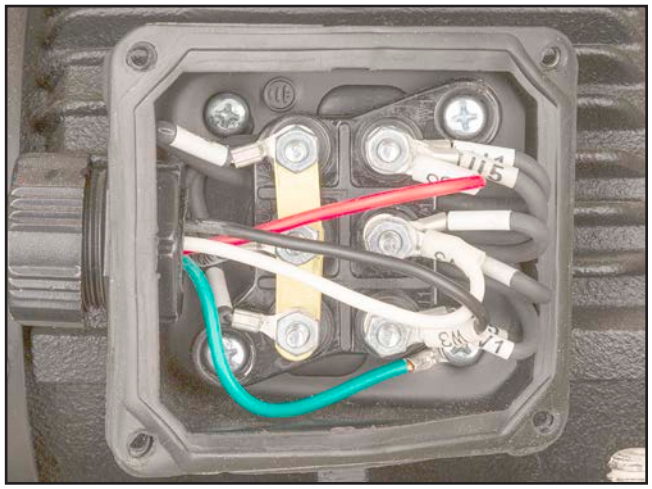


Figure 128. Table elevation motor junction box.

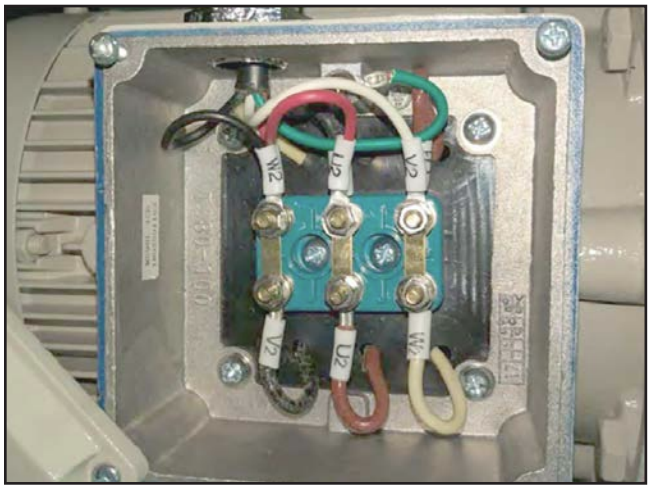
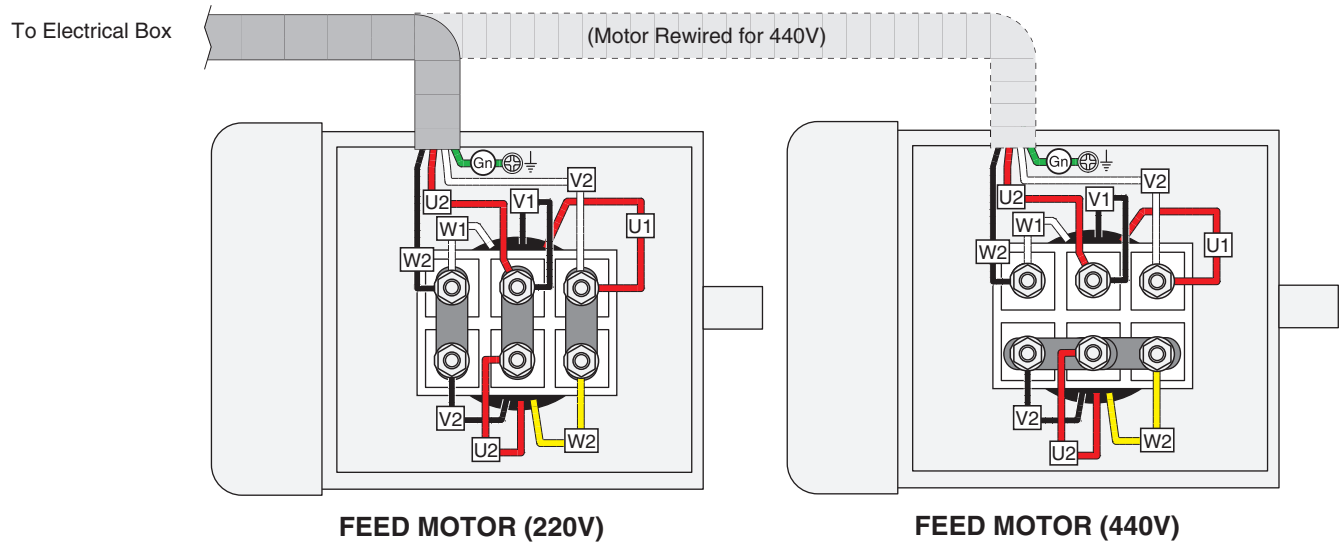
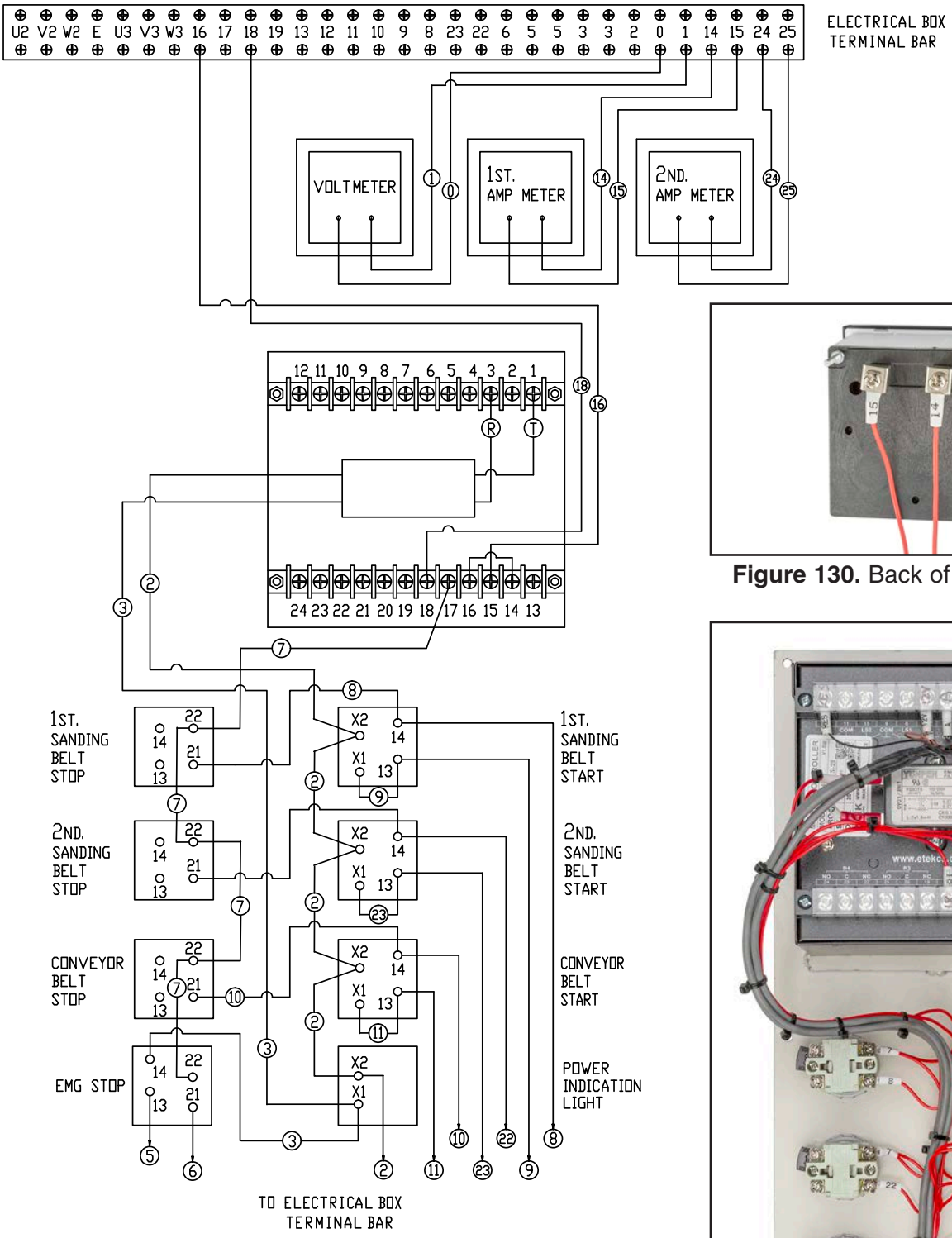


Figure 129. Feed motor junction box.



STOP *READ ELECTRICAL SAFETY ON PAGE 68!*

Control Panel & Meters Wiring



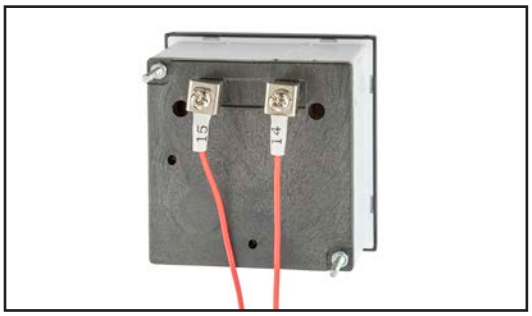


Figure 130. Back of 1st amp meter.

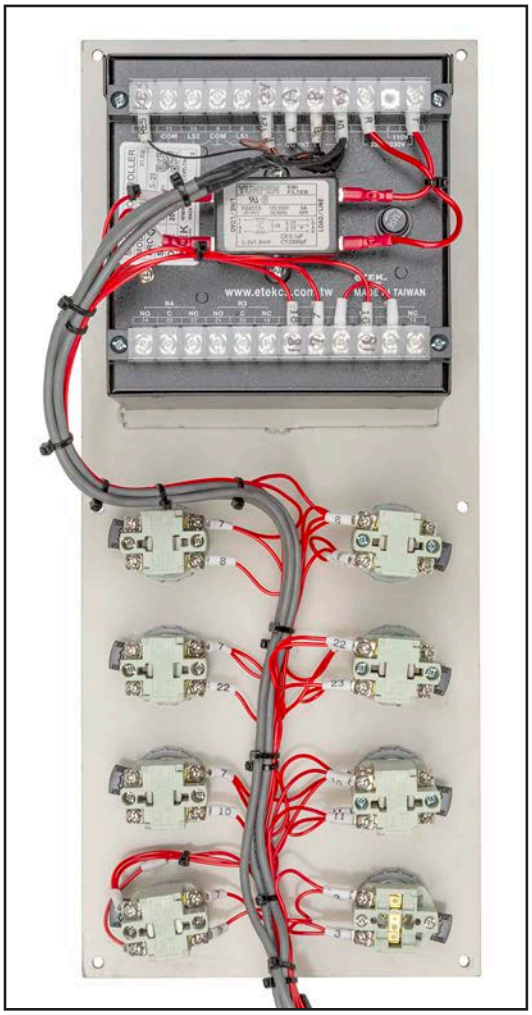
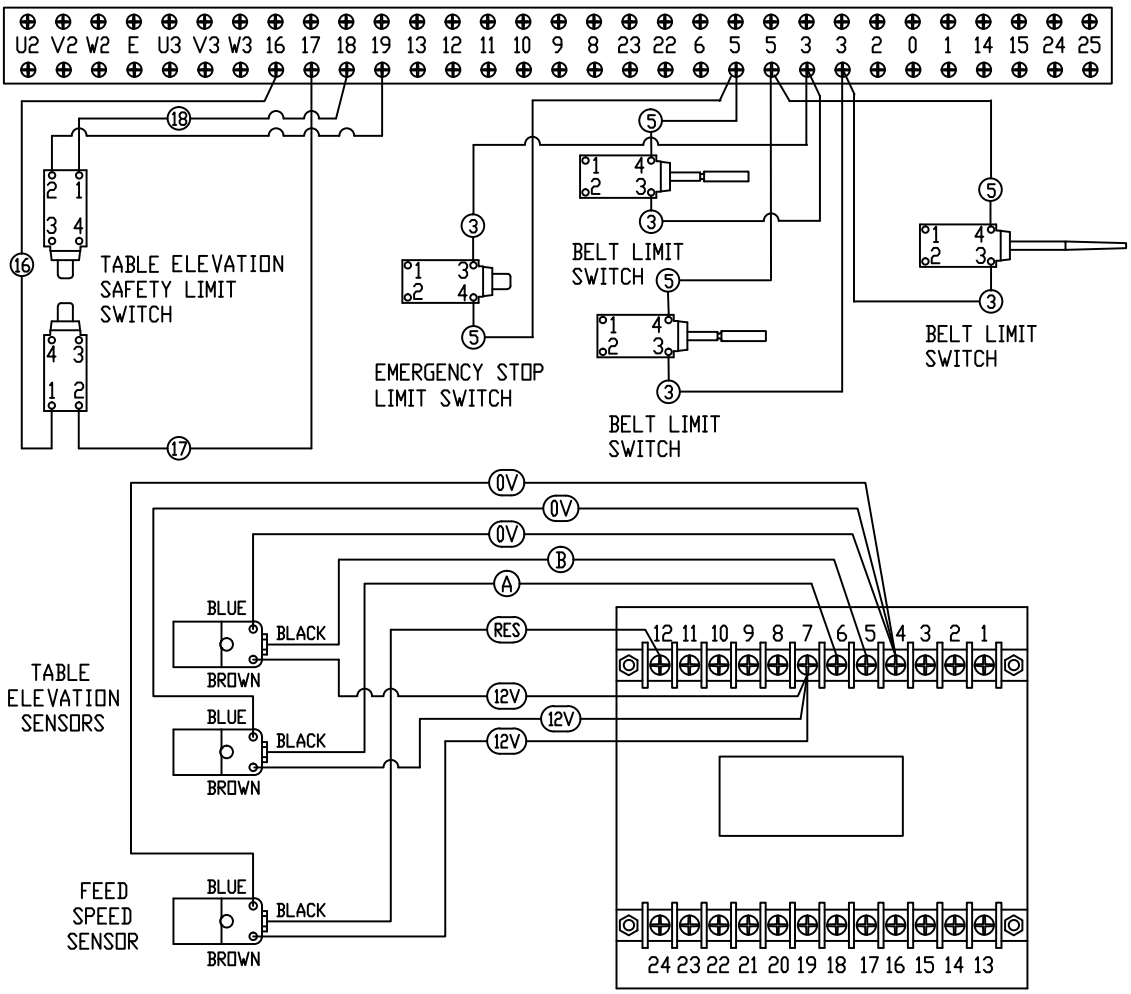


Figure 131. Back of control panel.

Limit Switches & Sensors Wiring



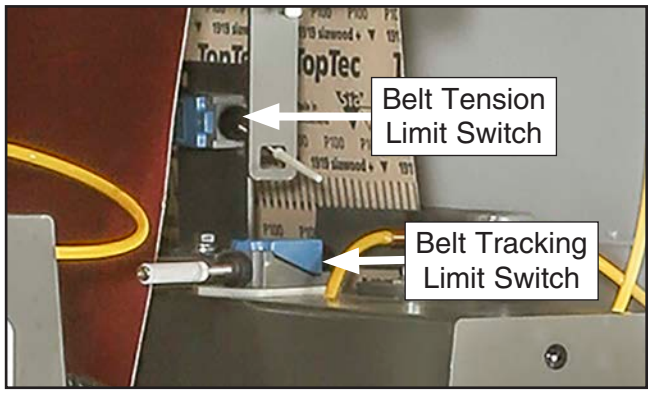


Figure 132. Belt tension and tracking limit switches.

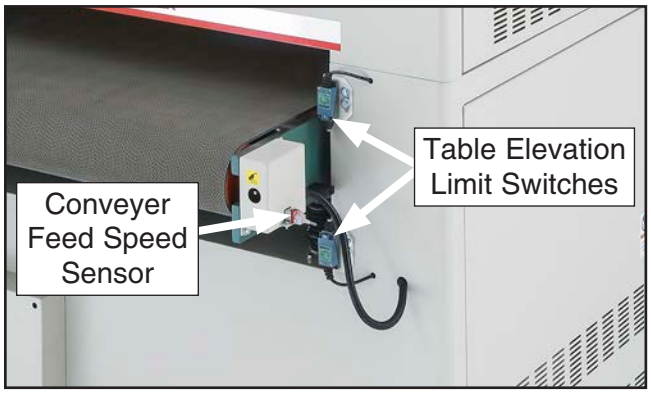


Figure 133. Table elevation limit switches and conveyer feed speed sensor.

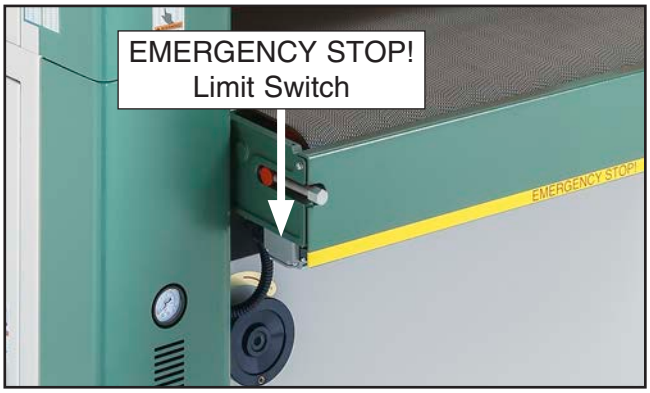


Figure 134. EMERGENCY STOP! plate limit switch.

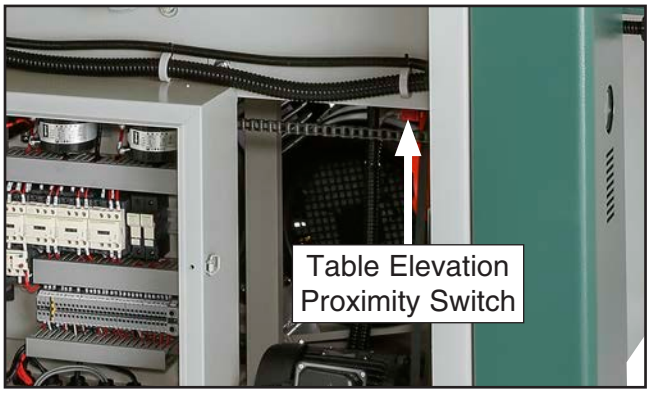


Figure 135. Table elevation proximity switch.

Air Pressure Limit Switch Wiring

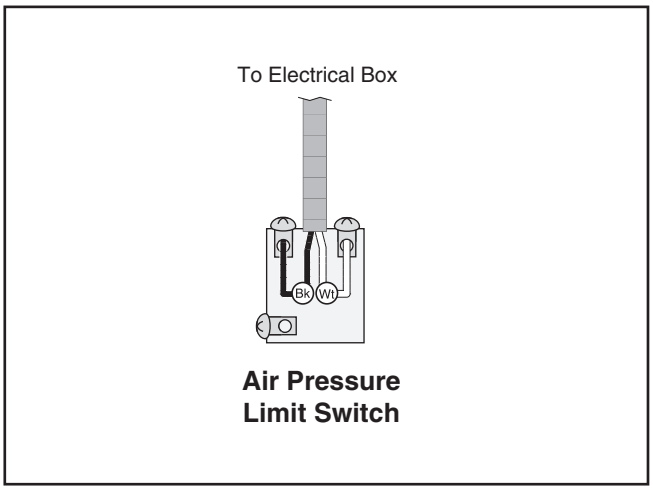
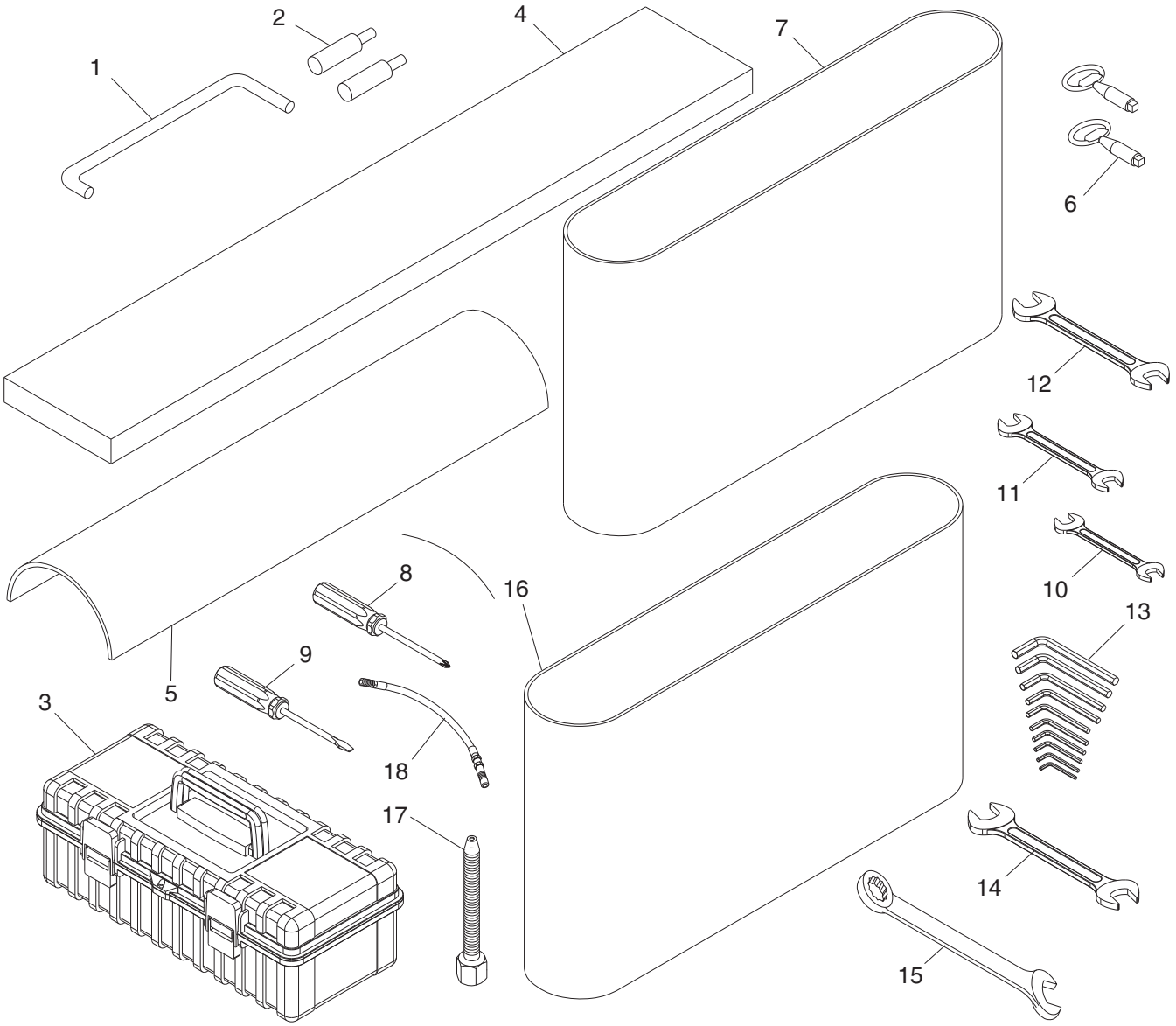


Figure 136. Air pressure limit switch wiring.

SECTION 9: PARTS

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

Tool Box & Accessories

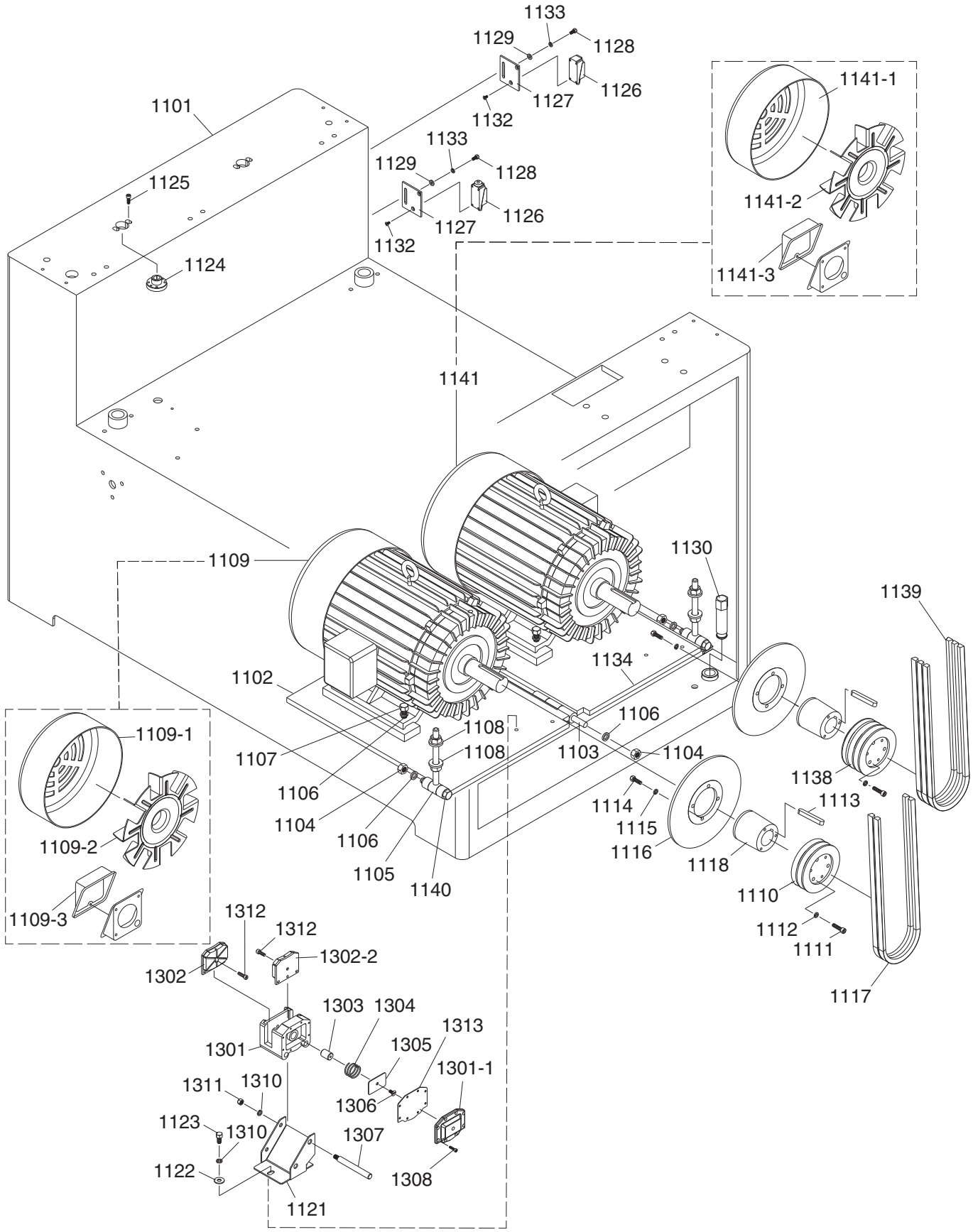


REF	PART #	DESCRIPTION
1	P08660001	PLATEN REMOVAL TOOL
2	P08660002	LIMIT SWITCH TIP (CERAMIC)
3	P08660003	TOOL BOX
4	P08660004	FELT PAD 37-1/4
5	P08660005	GRAPHITE PAD 37-3/4" X 3.54"
6	P08660006	DOOR KEY
7	P08660007	SANDING BELT 37" X 75" 100-GRIT
8	P08660008	PHILLIPS SCREWDRIVER #2
9	P08660009	FLAT SCREWDRIVER #2

REF	PART #	DESCRIPTION
10	P08660010	WRENCH 8 X 10MM OPEN-ENDS
11	P08660011	WRENCH 12 X 14MM OPEN-ENDS
12	P08660012	WRENCH 17 X 19MM OPEN-ENDS
13	P08660013	HEX WRENCH SET 1.5-10MM 10-PC
14	P08660014	WRENCH 21 X 23MM OPEN-ENDS
15	P08660015	WRENCH 26MM COMBO
16	P08660016	SANDING BELT 37" X 75" 180-GRIT
17	P08660017	ROLLER EXTRACTION BOLT 1/2-13 X 4-1/2
18	P08660018	FLEXIBLE GREASE GUN EXTENSION

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

Sanding Motor System



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

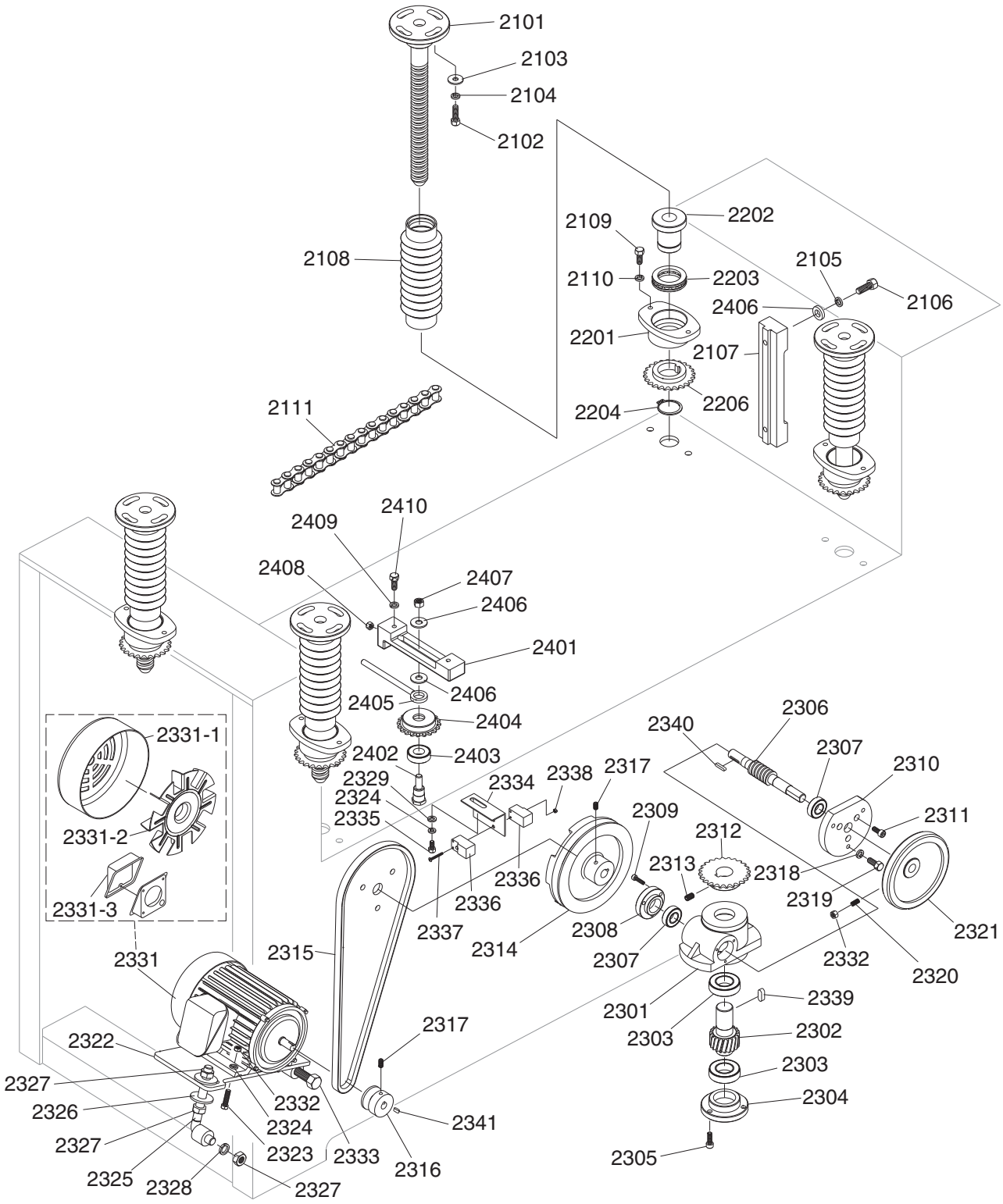
Sanding Motor System Parts List

REF	PART #	DESCRIPTION
1101	P08661101	MACHINE FRAME
1102	P08661102	MOTOR BASE (LEFT)
1103	P08661103	THREADED HINGE PIN 1/2-12
1104	P08661104	HEX NUT 1/2-12
1105	P08661105	MOTOR BASE ADJUSTMENT ROD
1106	P08661106	LOCK WASHER 1/2
1107	P08661107	HEX BOLT 1/2-12 X 1-1/2
1108	P08661108	FLAT WASHER 1/2
1109	P08661109	MOTOR 15HP 220V/440V 3-PH
1109-1	P08661109-1	MOTOR FAN COVER
1109-2	P08661109-2	MOTOR FAN
1109-3	P08661109-3	MOTOR JUNCTION BOX
1110	P08661110	PULLEY (2 GROOVE)
1111	P08661111	CAP SCREW 3/8-18 X 1-1/4
1112	P08661112	LOCK WASHER 3/8
1113	P08661113	KEY 12 X 8 X 105 RE
1114	P08661114	HEX BOLT 3/8-16 X 1
1115	P08661115	LOCK WASHER 3/8
1116	P08661116	BRAKE ROTOR
1117	P08661117	V-BELT 5V800
1118	P08661118	BUSHING 42ID X 80OD X 35L
1121	P08661121	BRAKE BRACKET
1122	P08661122	FLAT WASHER 3/8
1123	P08661123	HEX BOLT 3/8-16 X 3/4
1124	P08661124	FLANGED BUSHING 5/8ID X 2OD X 1L
1125	P08661125	CAP SCREW 1/4-20 X 3/4
1126	P08661126	LIMIT SWITCH MOUJEN ME-8111
1127	P08661127	LIMIT SWITCH PLATE

REF	PART #	DESCRIPTION
1128	P08661128	HEX BOLT 1/4-20 X 5/8
1129	P08661129	FLAT WASHER 1/4
1130	P08661130	LEVELING BOLT
1132	P08661132	FLAT HD SCR M5-.8 x 8
1133	P08661133	LOCK WASHER 1/4
1134	P08661134	MOTOR BASE (RIGHT)
1138	P08661138	PULLEY (3 GROOVE)
1139	P08661139	V-BELT 3V750
1140	P08661140	HEX BOLT 1/2-12 X 3
1141	P08661141	MOTOR 15HP 220/440V 3-PH
1141-1	P08661141-1	MOTOR FAN COVER
1141-2	P08661141-2	MOTOR FAN
1141-3	P08661141-3	MOTOR JUNCTION BOX
1301	P08661301	BRAKE CALIPER
1301-1	P08661301-1	BRAKE CALIPER FRONT GUARD
1302	P08661302	BRAKE PAD SET (INNER)
1302-2	P08661302-2	BRAKE PAD SET (OUTER)
1303	P08661303	BRAKE ARBOR
1304	P08661304	COMPRESSION SPRING 35 X 34
1305	P08661305	BRAKE MOUNTING PLATE
1306	P08661306	FLAT HD SCR 1/4-20 X 5/8
1307	P08661307	STUD-SE 3/8-16 X 1/2, 1/2 X 5
1308	P08661308	CAP SCREW 10-24 X 5/8
1310	P08661310	LOCK WASHER 3/8
1311	P08661311	HEX NUT 3/8-16
1312	P08661312	CAP SCREW 1/4-20 X 1/2
1313	P08661313	BRAKE GASKET 1 X 110 100

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

Table Lift System



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

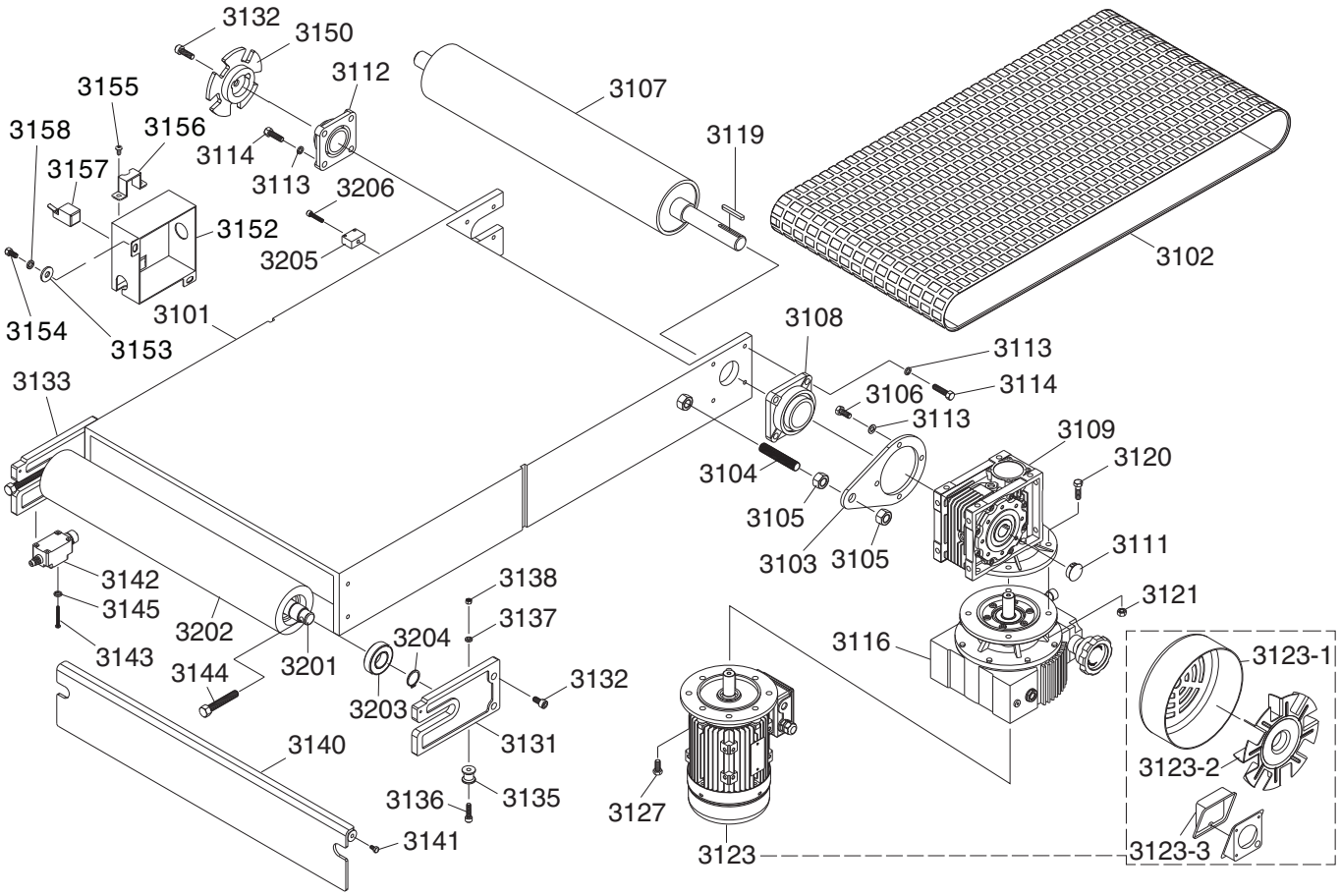
Table Lift System Parts List

REF	PART #	DESCRIPTION
2101	P08662101	ELEVATION SCREW 1-5 X 11-1/2
2102	P08662102	HEX BOLT 5/16-18 X 1
2103	P08662103	FLAT WASHER 5/16
2104	P08662104	LOCK WASHER 5/16
2105	P08662105	LOCK WASHER 3/8
2106	P08662106	HEX BOLT 3/8-16 X 1
2107	P08662107	ELEVATION SLIDE
2108	P08662108	ELEVATION SCREW DUST BOOT
2109	P08662109	HEX BOLT 5/16-18 X 3/4
2110	P08662110	LOCK WASHER 5/16
2111	P08662111	ELEVATION SCREW CHAIN
2201	P08662201	NUT HOUSING
2202	P08662202	COLUMN NUT
2203	P08662203	THRUST BEARING 51107
2204	P08662204	EXT RETAINING RING 35MM
2206	P08662206	SPROCKET WHEEL
2301	P08662301	ELEVATION GEARBOX
2302	P08662302	WORM GEAR WHEEL
2303	P08662303	BALL BEARING 6005-2RS
2304	P08662304	WORM GEAR BEARING CAP
2305	P08662305	PHLP HD SCR 1/4-20 X 3/4
2306	P08662306	WORM SHAFT
2307	P08662307	BALL BEARING 6002-2RS
2308	P08662308	GEARBOX BEARING CAP
2309	P08662309	CAP SCREW 10-24 X 5/8
2310	P08662310	HANDWHEEL BEARING CAP
2311	P08662311	CAP SCREW 1/4-20 X 5/8
2312	P08662312	SPROCKET 18T
2313	P08662313	SET SCREW 5/16-18 X 1/2
2314	P08662314	TABLE PULLEY
2315	P08662315	V-BELT A37
2316	P08662316	TABLE HEIGHT MOTOR PULLEY
2317	P08662317	SET SCREW 1/4-20 X 1/2
2318	P08662318	LOCK WASHER 5/16
2319	P08662319	HEX BOLT 5/16-18 X 3/4

REF	PART #	DESCRIPTION
2320	P08662320	SET SCREW 1/4-20 X 3/4
2321	P08662321	HANDWHEEL TYPE-10 14ID X 152.4OD
2322	P08662322	MOTOR BASE
2323	P08662323	HEX BOLT 1/4-20 X 1
2324	P08662324	LOCK WASHER 1/4
2325	P08662325	ADJUSTMENT ROD
2326	P08662326	FLAT WASHER 1/2
2327	P08662327	HEX NUT 1/2-12
2328	P08662328	LOCK WASHER 1/2
2329	P08662329	FLAT WASHER 1/4
2331	P08662331	MOTOR 1/4HP 220V/440V 3-PH
2331-1	P08662331-1	FAN COVER
2331-2	P08662331-2	FAN
2331-3	P08662331-3	JUNCTION BOX
2332	P08662332	HEX NUT 1/4-20
2333	P08662333	HEX BOLT 1/2-12 X 4-1/2
2334	P08662334	PROXIMITY SWITCH PLATE
2335	P08662335	HEX BOLT 1/4-20 X 1/2
2336	P08662336	PROXIMITY SWITCH ETEK PL-05NB-S
2337	P08662337	FLAT HD SCR M3-.5 X 40
2338	P08662338	HEX NUT M3-.5
2339	P08662339	KEY 8 X 8 X 20MM
2340	P08662340	KEY 4 X 4 X 20
2341	P08662341	KEY 4 X 4 X 16
2401	P08662401	SPROCKET WHEEL ADJUSTOR
2402	P08662402	SPROCKET WHEEL SHAFT
2403	P08662403	BALL BEARING 6003-2RS
2404	P08662404	SPROCKET WHEEL 14T
2405	P08662405	ADJUSTMENT ROD
2406	P08662406	FLAT WASHER 3/8
2407	P08662407	HEX NUT 3/8-16
2408	P08662408	HEX NUT 5/16-18
2409	P08662409	LOCK WASHER 5/16
2410	P08662410	HEX BOLT 5/16-18 X 3/4

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

Conveyor System

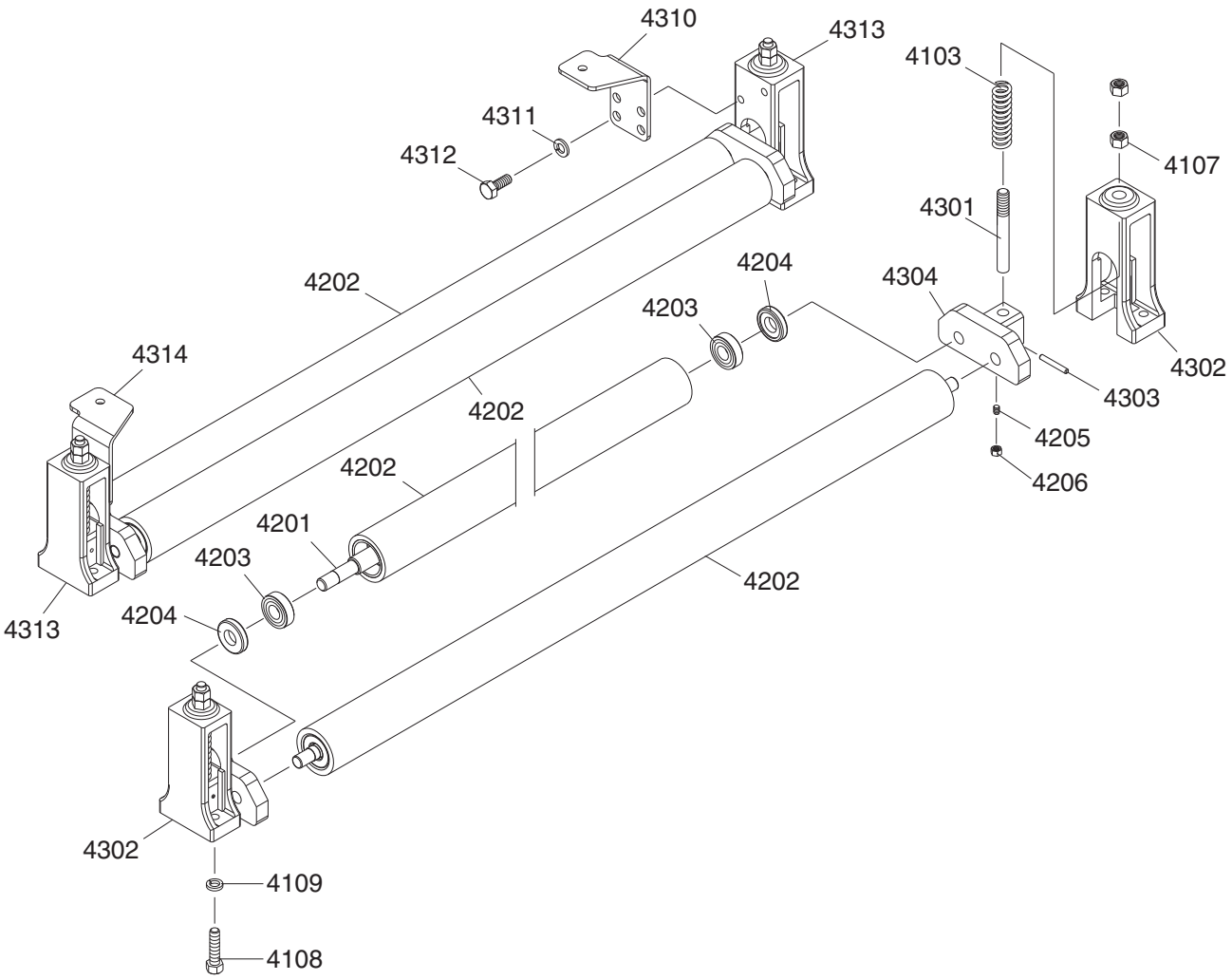


REF	PART #	DESCRIPTION
3101	P08663101	CONVEYOR TABLE
3102	P08663102	CONVEYOR BELT
3103	P08663103	GEARBOX MOUNTING PLATE
3104	P08663104	STUD-FT 3/4-10 X 3/4
3105	P08663105	HEX NUT 3/4-10
3106	P08663106	HEX BOLT M8-1.25 X 20
3107	P08663107	OUTFEED ROLLER
3108	P08663108	MOUNTED BEARING UCF206
3109	P08663109	GEARBOX
3111	P08663111	GEARBOX PLUG
3112	P08663112	MOUNTED BEARING UCF205
3113	P08663113	LOCK WASHER 3/8
3114	P08663114	HEX BOLT 3/8-16 X 1-1/4
3116	P08663116	VARIABLE SPEED TRANSFER CASE
3119	P08663119	MACHINE KEY 8 X 7 X 80 RE
3120	P08663120	HEX BOLT M10-1.5 X 30
3121	P08663121	HEX NUT M10-1.5
3123	P08663123	MOTOR 2HP 220/440V 3-PH
3123-1	P08663123-1	FAN COVER
3123-2	P08663123-2	FAN
3123-3	P08663123-3	JUNCTION BOX
3127	P08663127	HEX BOLT M10-1.5 X 25
3131	P08663131	INFEED ROLLER BRACKET (RIGHT)
3132	P08663132	CAP SCREW 3/8-16 X 3/4
3133	P08663133	INFEED ROLLER BRACKET (LEFT)

REF	PART #	DESCRIPTION
3135	P08663135	CONVEYOR BELT POSITION WHEEL
3136	P08663136	CAP SCREW 5/16-18 X 2
3137	P08663137	LOCK WASHER 5/16
3138	P08663138	HEX NUT 5/16-18
3140	P08663140	EMERGENCY BRAKE PUSH PLATE
3141	P08663141	PHLP HD SCR 1/4-20 X 3/4
3142	P08663142	LIMIT SWITCH TEND TZ-5101
3143	P08663143	PHLP HD SCR 10-24 X 1-1/2
3144	P08663144	HEX BOLT 1/2-13 X 5-5/16
3145	P08663145	LOCK WASHER #10
3150	P08663150	SENSOR PLATE
3152	P08663152	BEARING CAP
3153	P08663153	FLAT WASHER 1/4
3154	P08663154	HEX BOLT 1/4-20 X 1/2
3155	P08663155	PHLP HD SCR 8-32 X 3/8
3156	P08663156	SENSOR MOUNTING BRACKET
3157	P08663157	PROXIMITY SENSOR ETEK PL-05NB-S
3158	P08663158	LOCK WASHER 1/4
3201	P08663201	INFEED ROLLER SHAFT
3202	P08663202	INFEED ROLLER
3203	P08663203	BALL BEARING 6206-2RS
3204	P08663204	EXT RETAINING RING 30MM
3205	P08663205	ELEVATION LIMIT BLOCK
3206	P08663206	CAP SCREW 1/4-20 X 1-1/2

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

Feed Roller

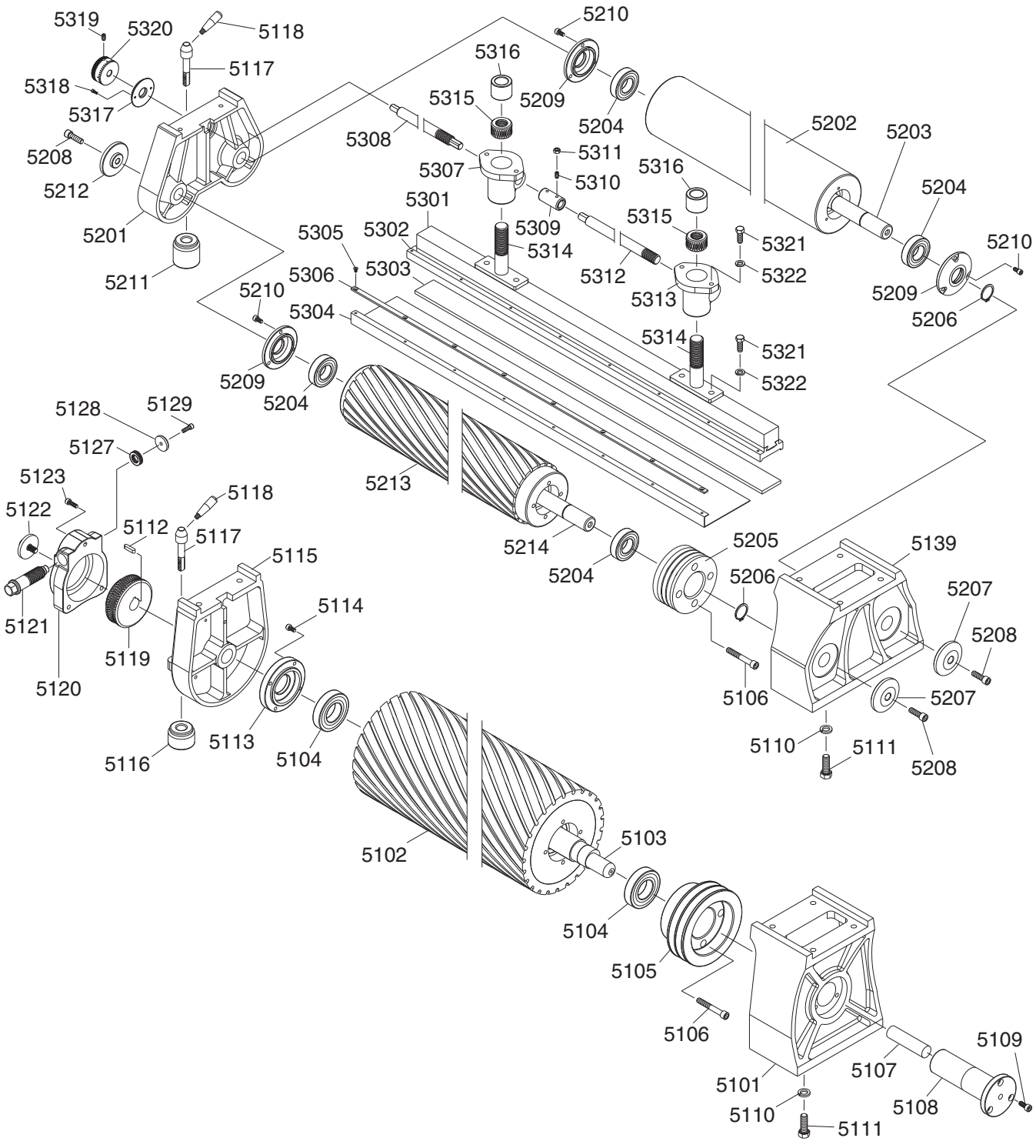


REF	PART #	DESCRIPTION
4103	P08664103	COMPRESSION SPRING 2 X 16 X 62
4107	P08664107	HEX NUT 5/16-18
4108	P08664108	HEX BOLT 5/16-18 X 1-1/4
4109	P08664109	LOCK WASHER 5/16
4201	P08664201	PRESSURE ROLLER SHAFT
4202	P08664202	PRESSURE ROLLER
4203	P08664203	BALL BEARING 6003-2RS
4204	P08664204	SHAFT BEARING COLLAR
4205	P08664205	SET SCREW 1/4-20 X 1/2
4206	P08664206	HEX NUT 1/4-20

REF	PART #	DESCRIPTION
4301	P08664301	STUD-SE 5/16-18, 35 X 110
4302	P08664302	PISTON BRACKET (OUTER)
4303	P08664303	ROLL PIN 3 X 27
4304	P08664304	PISTON BRACKET (INNER)
4310	P08664310	FIXED BRACKET (RIGHT)
4311	P08664311	LOCK WASHER 1/4
4312	P08664312	HEX BOLT 1/4-20 X 1/2
4313	P08664313	PISTON BRACKET (MIDDLE)
4314	P08664314	FIXED BRACKET (LEFT)

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

Sanding Drum



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

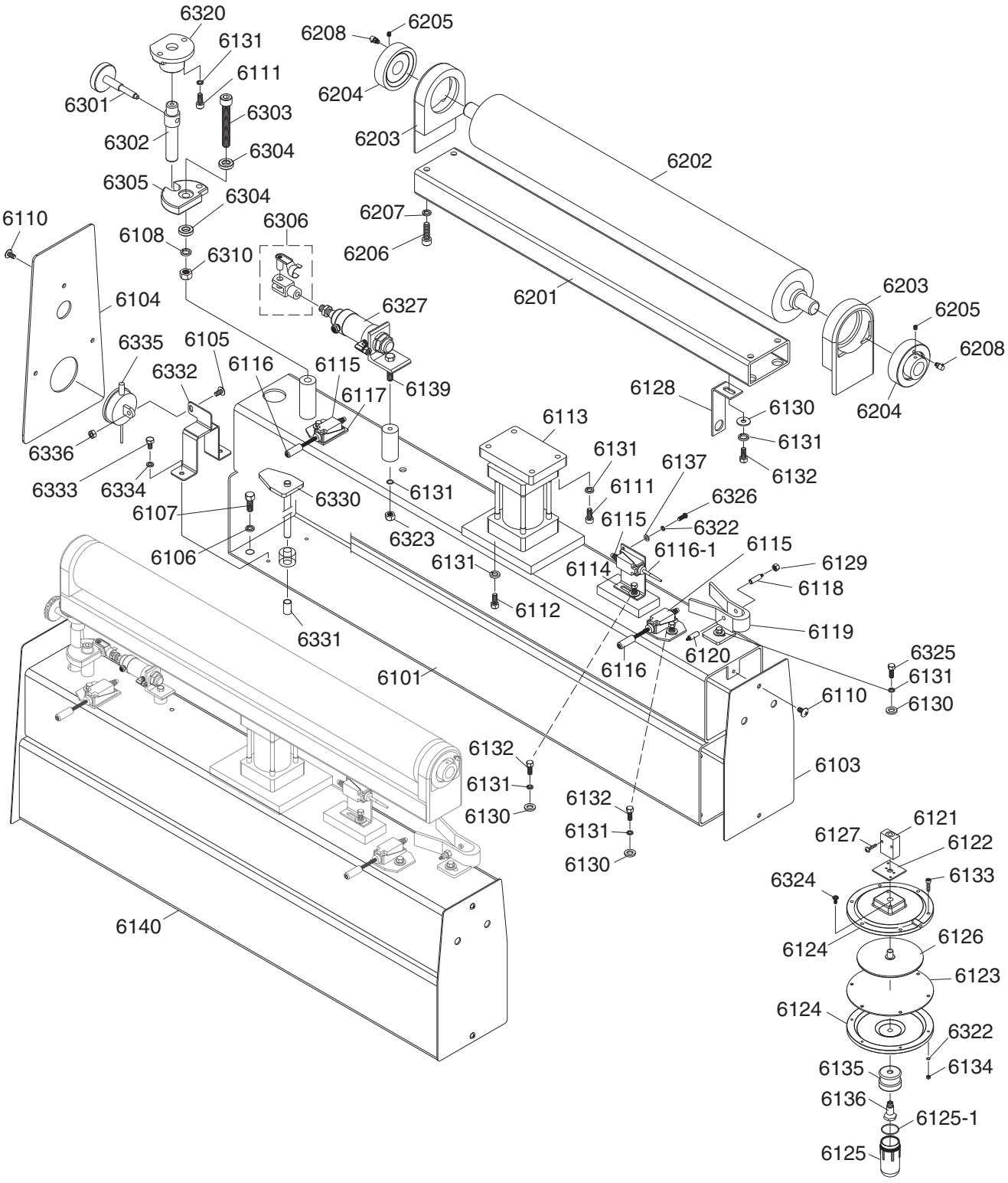
Sanding Drum Parts List

REF	PART #	DESCRIPTION
5101	P08665101	BEARING HOUSING (RIGHT FRONT)
5102	P08665102	RUBBER SANDING DRUM (FRONT)
5103	P08665103	SANDING DRUM SHAFT (FRONT)
5104	P08665104	BALL BEARING 6208ZZ
5105	P08665105	FRONT SANDING DRUM PULLEY
5106	P08665106	CAP SCREW 3/8-16 X 1-1/2
5107	P08665107	ECCENTRIC TUBE SHAFT
5108	P08665108	ECCENTRIC TUBE
5109	P08665109	CAP SCREW 5/16-18 X 3/4
5110	P08665110	LOCK WASHER 1/2
5111	P08665111	HEX BOLT 1/2-12 X 1-1/2
5112	P08665112	KEY 1/4 X 1/4 X 25
5113	P08665113	FRONT DRUM BEARING CAP
5114	P08665114	CAP SCREW 1/4-20 X 1/2
5115	P08665115	BEARING HOUSING (LEFT FRONT)
5116	P08665116	BEARING HOUSING PAD (RUBBER)
5117	P08665117	HANDLE SCREW 7/8OD X 70L
5118	P08665118	HANDLE 7/8OD X 70L
5119	P08665119	WORM WHEEL
5120	P08665120	WORM DRIVE GEARBOX
5121	P08665121	WORM GEAR
5122	P08665122	GEARBOX SCREW COVER 1/2-24 X 2-3/8
5123	P08665123	CAP SCREW 5/16-18 X 1
5127	P08665127	THRUST BEARING 51102
5128	P08665128	FENDER WASHER 1/4
5129	P08665129	CAP SCREW 1/4-20 X 5/8
5139	P08665139	BEARING HOUSING (RIGHT REAR)
5201	P08665201	BEARING HOUSING (LEFT REAR)
5202	P08665202	STEEL ROLLER
5203	P08665203	STEEL ROLLER SHAFT
5204	P08665204	BALL BEARING 6206-2RS
5205	P08665205	MIDDLE SANDING DRUM PULLEY

REF	PART #	DESCRIPTION
5206	P08665206	EXT RETAINING RING 30MM
5207	P08665207	CENTERING WASHER 3/8
5208	P08665208	CAP SCREW 3/8-16 X 1
5209	P08665209	BEARING CAP
5210	P08665210	CAP SCREW 1/4-20 X 1/2
5211	P08665211	BRACKET PAD 2"OD X 2"L (RUBBER)
5212	P08665212	CENTERING WASHER 3/8
5213	P08665213	RUBBER SANDING DRUM (MIDDLE)
5214	P08665214	SANDING DRUM SHAFT (MIDDLE)
5301	P08665301	PLATEN BAR (TOP)
5302	P08665302	PLATEN PLATE (BOTTOM)
5303	P08665303	FELT PLATEN PAD
5304	P08665304	PLATEN GRAPHITE
5305	P08665305	PHLP HD SCR 10-24 X 1/2
5306	P08665306	GRAPHITE RETAINER PLATE
5307	P08665307	PLATEN GEARBOX (LEFT)
5308	P08665308	WORM GEAR (FRONT)
5309	P08665309	WORM GEAR SHAFT COUPLER
5310	P08665310	SET SCREW 1/4-20 X 1/2
5311	P08665311	HEX NUT 1/4-20
5312	P08665312	WORM GEAR (RIGHT)
5313	P08665313	PLATEN GEARBOX (RIGHT)
5314	P08665314	THREADED STUD PLATE
5315	P08665315	WORM GEAR WHEEL
5316	P08665316	PLATEN WORM GEAR BUSHING
5317	P08665317	GRADUATED COLLAR PLATE
5318	P08665318	PHLP HD SCR 8-32 X 3/8
5319	P08665319	SET SCREW 1/4-20 X 3/4
5320	P08665320	GRADUATED COLLAR
5321	P08665321	HEX BOLT 1/2-12 X 1
5322	P08665322	LOCK WASHER 3/8

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

Upper Roller System



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

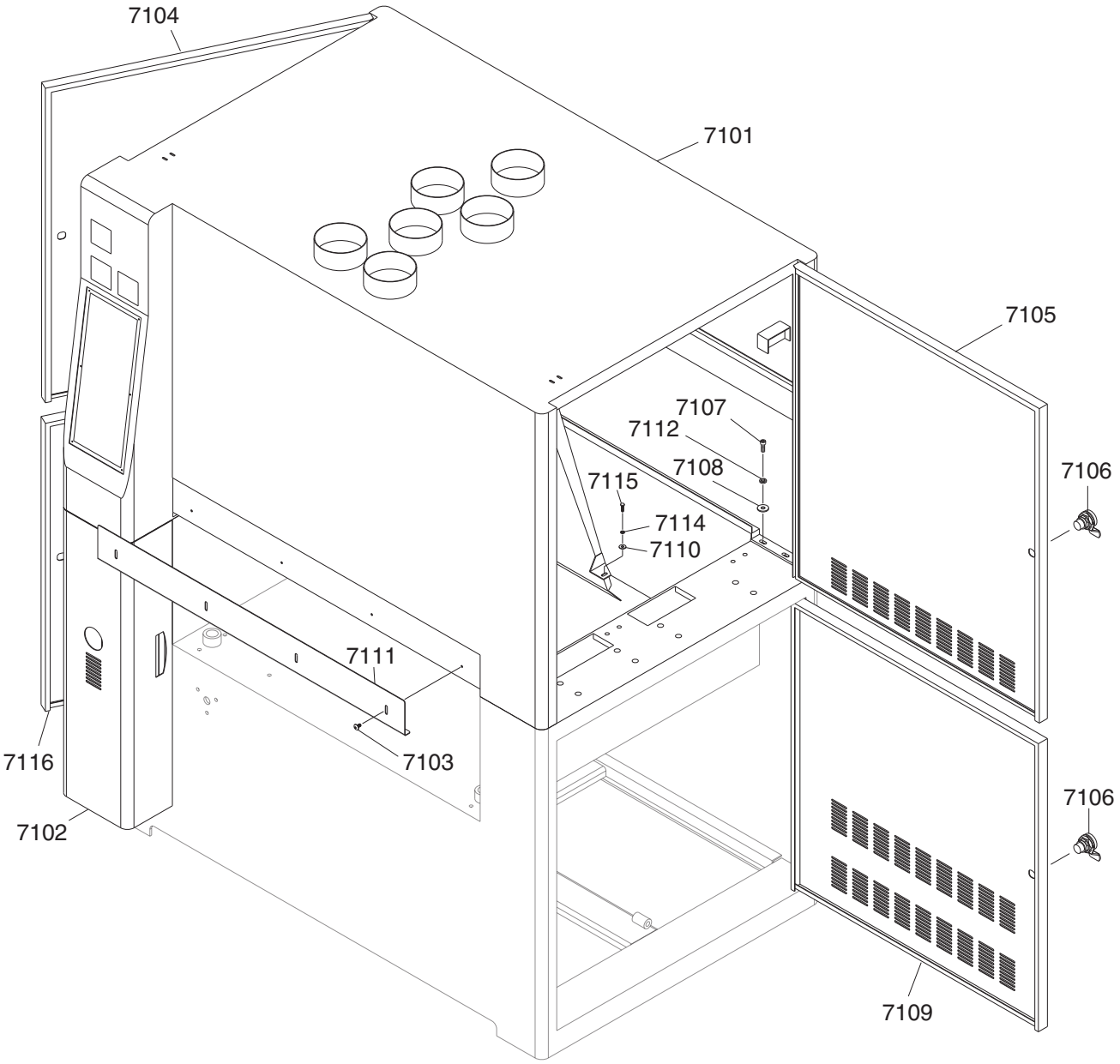
Upper Roller System Parts List

REF	PART #	DESCRIPTION
6101	P08666101	SQUARE FRAME
6103	P08666103	SQUARE FRAME END (RIGHT)
6104	P08666104	SQUARE FRAME END (LEFT)
6105	P08666105	BUTTON HD CAP SCR 1/4-20 X 5/8
6106	P08666106	LOCK WASHER 3/8
6107	P08666107	HEX BOLT 3/8-16 X 1-1/4
6108	P08666108	LOCK WASHER 1/2
6110	P08666110	PHLP HD SCR 1/4-20 X 1/2
6111	P08666111	CAP SCREW 5/16-18 X 3/4
6112	P08666112	HEX BOLT M8-1.25 X 20
6113	P08666113	BELT TENSION AIR CYLINDER
6114	P08666114	LIMIT SWITCH MOUNTING BRACKET
6115	P08666115	LIMIT SWITCH MOUJEN ME-8166
6116	P08666116	LIMIT SWITCH CERAMIC TIP
6116-1	P08666116-1	LIMIT SWITCH TUBE (PLASTIC)
6117	P08666117	LIMIT SWITCH MOUNTING BRACKET
6118	P08666118	AIR FORK JET
6119	P08666119	AIR FORK
6120	P08666120	AIR FORK RECEIVER
6121	P08666121	MECHANICAL VALVE POSU
6122	P08666122	THROTTLE VALVE BASE
6123	P08666123	DIAPHRAGM
6124	P08666124	HOUSING ASSEMBLY
6125	P08666125	DUST TRAP BOWL
6125-1	P08666125-1	O-RING 26.7 X 1.78
6126	P08666126	ALUMINUM PLATE
6127	P08666127	PHLP HD SCR M4-.7 X 20
6128	P08666128	LIMIT SWITCH SHUTDOWN BRACKET
6129	P08666129	HEX NUT 3/8-24
6130	P08666130	FLAT WASHER 5/16
6131	P08666131	LOCK WASHER 5/16
6132	P08666132	HEX BOLT 5/16-18 X 1/2
6133	P08666133	CAP SCREW 10-24 X 3/4
6134	P08666134	HEX NUT 10-24

REF	PART #	DESCRIPTION
6135	P08666135	DUST TRAP CONNECTOR
6136	P08666136	DUST TRAP SHAFT
6137	P08666137	FLAT WASHER 5MM
6139	P08666139	CAP SCREW 5/16-18 X 2-1/4
6140	P08666140	SQUARE FRAME
6201	P08666201	UPPER ROLLER MOUNTING BAR
6202	P08666202	UPPER ROLLER
6203	P08666203	UPPER ROLLER BRACKET
6204	P08666204	CARTRIDGE BEARING UCC205
6205	P08666205	SET SCREW M6-1 X 6
6206	P08666206	CAP SCREW 3/8-16 X 3/4
6207	P08666207	LOCK WASHER 3/8
6208	P08666208	GREASE FITTING 1/4-28 X 1/16
6301	P08666301	OSCILLATION ADJUSTMENT KNOB
6302	P08666302	ECCENTRIC ROD
6303	P08666303	CAP SCREW 1/2-12 X 3-1/2
6304	P08666304	FLAT WASHER 1/2
6305	P08666305	ECCENTRIC CAM
6306	P08666306	UNIVERSAL JOINT FORK ASSY
6310	P08666310	HEX NUT 1/2-13
6320	P08666320	ECCENTRIC SHAFT FRAME
6322	P08666322	LOCK WASHER #10
6323	P08666323	HEX NUT 5/16-18
6324	P08666324	PHLP HD SCR M4-.7 X 12
6325	P08666325	HEX BOLT 5/16-18 X 3/4
6326	P08666326	PHLP HD SCR M5-.8 X 10
6327	P08666327	OSCILLATION AIR CYLINDER 30 X 4
6330	P08666330	INDICATOR PLATE
6331	P08666331	BUSHING 10ID X 12OD X 15L
6332	P08666332	INDICATOR BRACKET
6333	P08666333	HEX BOLT 1/4-20 X 1/2
6334	P08666334	LOCK WASHER 1/4
6335	P08666335	PLATEN PRESSURE INDICATOR
6336	P08666336	HEX NUT 1/4-20

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

Cabinet Assembly

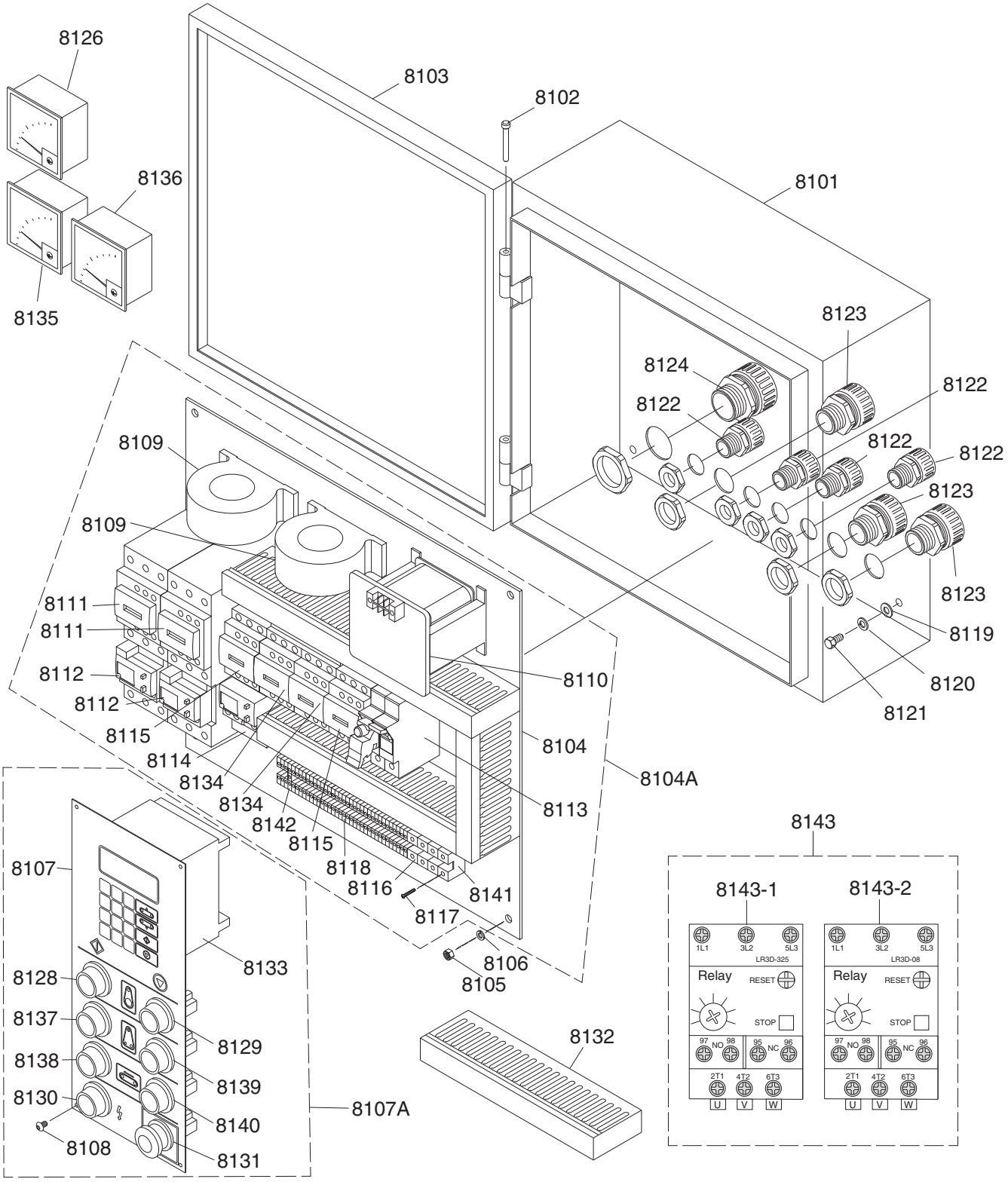


REF	PART #	DESCRIPTION
7101	P08667101	UPPER FRAME COVER
7102	P08667102	REGULATOR DOOR
7103	P08667103	PHLP HD SCR M6-1 X 12
7104	P08667104	DOOR (LEFT) UPPER FRAME
7105	P08667105	DOOR (RIGHT) UPPER FRAME
7106	P08667106	DOOR LOCK
7107	P08667107	CAP SCREW 5/16-18 X 3/4
7108	P08667108	FLAT WASHER 5/16

REF	PART #	DESCRIPTION
7109	P08667109	DOOR (RIGHT) LOWER FRAME
7110	P08667110	FLAT WASHER 1/4
7111	P08667111	FRONT PROTECTION PLATE
7112	P08667112	LOCK WASHER 5/16
7114	P08667114	LOCK WASHER 1/4
7115	P08667115	HEX BOLT M6-1 X 16
7116	P08667116	DOOR (LEFT) LOWER FRAME

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

Main Wiring Panel & Controls



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

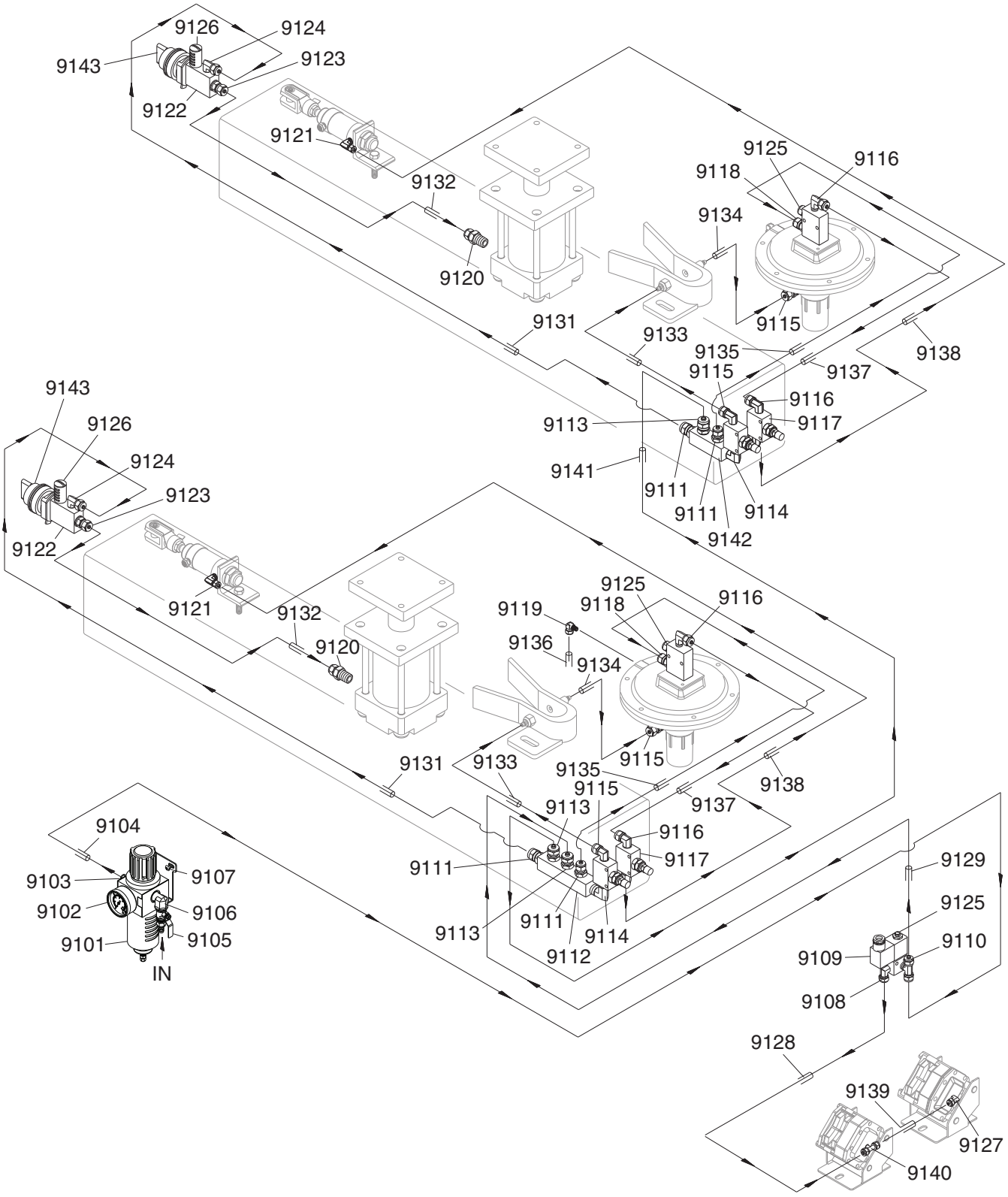
Main Wiring Panel & Controls Parts List

REF	PART #	DESCRIPTION
8101	P08668101	ELECTRICAL CONTROL BOX
8102	P08668102	HINGE PIN
8103	P08668103	ELECTRICAL BOX DOOR
8104	P08668104	ELECTRICAL COMPONENT BASE PLATE
8104A	P08668104A	ELECTRICAL COMPONENTS ASSEMBLY
8105	P08668105	HEX NUT 1/4-20
8106	P08668106	LOCK WASHER 1/4
8107	P08668107	CONTROL PANEL
8107A	P08668107A	CONTROL PANEL ASSEMBLY
8108	P08668108	PHLP HD SCR M4-.7 X 8
8109	P08668109	CURRENT SENSOR RCT75/5
8110	P08668110	TRANSFORMER 350VA-440
8111	P08668111	CONTACTOR SCHN LC1D40AM7 AC220V
8112	P08668112	OL RELAY SCHN LR3D340 30-40A
8113	P08668113	FUSE HOLDER SCHN DF101 10 X 38MM
8114	P08668114	OL RELAY SCHN LR3D12 5.5-8A
8115	P08668115	CONTACTOR SCHN LC1D09M7 220V
8116	P08668116	POWER TERMINAL BLOCK ABB M35/16
8117	P08668117	PHLP HD SCR M4-.7 X 30
8118	P08668118	TERMINAL BLOCK ABB M4/6P
8119	P08668119	FLAT WASHER 1/4
8120	P08668120	LOCK WASHER 1/4
8121	P08668121	HEX BOLT 1/4-20 X 1/2

REF	PART #	DESCRIPTION
8122	P08668122	STRAIN RELIEF TYPE-3 M21-1.5
8123	P08668123	STRAIN RELIEF TYPE-3 M25-1.5
8124	P08668124	STRAIN RELIEF TYPE-3 M33-2.0 90D
8126	P08668126	VOLT METER ANALOG 600V
8128	P08668128	BUTTON SWITCH YK A600 29MM GREEN
8129	P08668129	BUTTON SWITCH YK A600 29MM RED
8130	P08668130	BUTTON SWITCH YK A600 29MM WHITE
8131	P08668131	E-STOP BUTTON YK 91X7 22MM
8132	P08668132	WIRE LOOM
8133	P08668133	CIRCUIT BOARD DP-515
8134	P08668134	CONTACTOR SCHN LC1D09M7 AC220V
8135	P08668135	AMP METER ANALOG 75/5A
8136	P08668136	AMP METER ANALOG 75/5A
8137	P08668137	BUTTON SWITCH YK A600 29MM GREEN
8138	P08668138	BUTTON SWITCH YK A600 29MM GREEN
8139	P08668139	BUTTON SWITCH YK A600 29MM RED
8140	P08668140	BUTTON SWITCH YK A600 29MM RED
8141	P08668141	POWER TERMINAL BLOCK ABB M35/16
8142	P08668142	TERMINAL BLOCK ABB M4/6P
8143	P08668143	440V CONVERSION KIT
8143-1	P08668143-1	OL RELAY SCHN 440V 18.4A LR3D-325
8143-2	P08668143-2	OL RELAY SCHN 3.7A LR3D-08

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

Belt Oscillation System



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

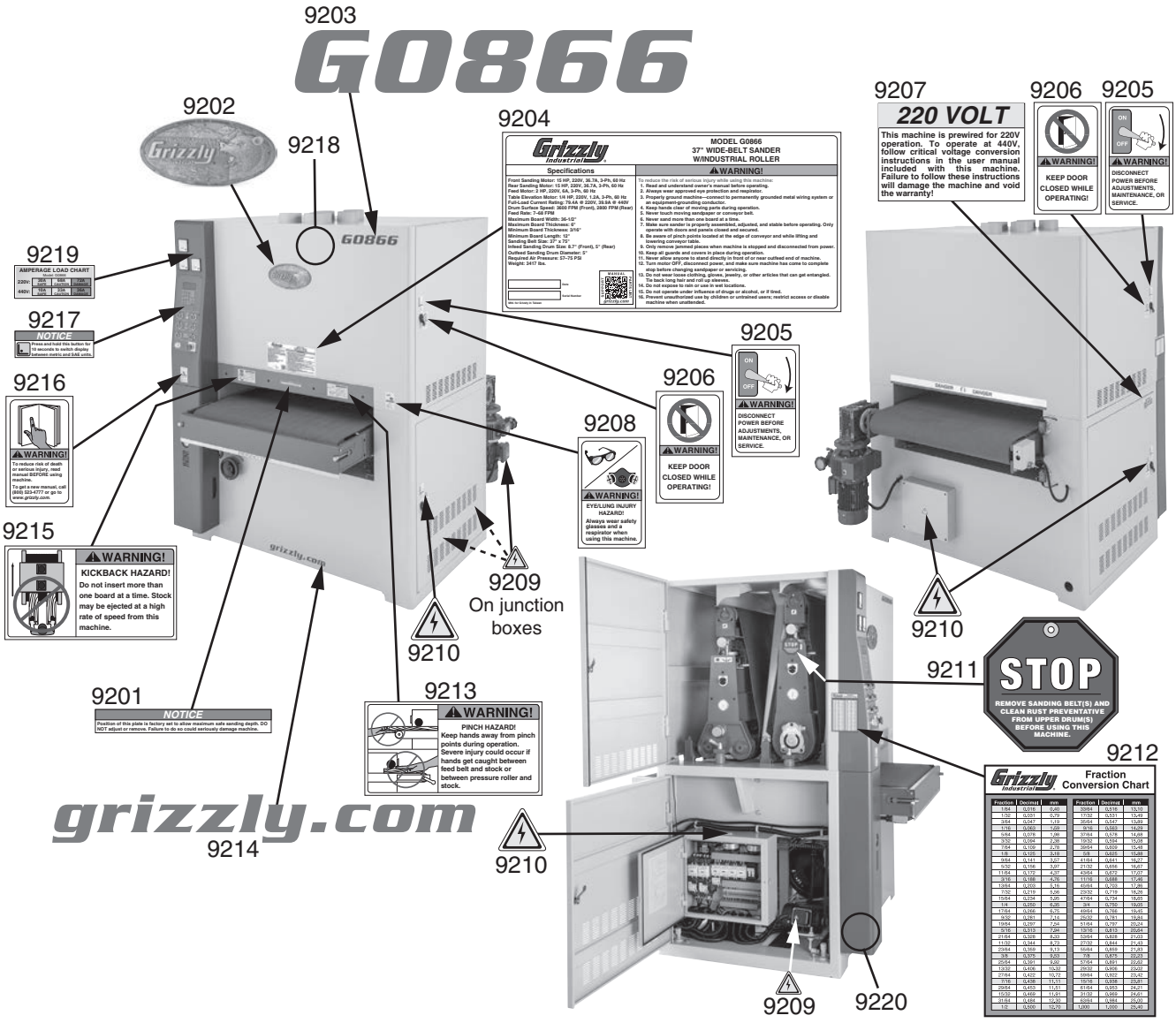
Belt Oscillation System Parts List

REF	PART #	DESCRIPTION
9101	P08669101	REGULATOR W/FILTER
9102	P08669102	PRESSURE GAUGE
9103	P08669103	CONNECTOR 5/16N X 3/8T (BRONZE)
9104	P08669104	FLEXIBLE HOSE 8MM
9105	P08669105	BALL VALVE
9106	P08669106	ELBOW 3/8T X 3/8T 90°
9107	P08669107	PHLP HD SCR 1/4-20 X 3/4
9108	P08669108	ELBOW 5/16N X 1/8T 90°
9109	P08669109	SOLENOID VALVE AMISCO EVI 7/9 220V
9110	P08669110	T-CONNECTOR 1/4N X 1/4T (MALE)
9111	P08669111	CONNECTOR
9112	P08669112	AIR MANIFOLD 5-PORT
9113	P08669113	CONNECTOR 5/16N X 1/4T
9114	P08669114	ELBOW 1/4T X 1/8T 90° (BRONZE)
9115	P08669115	CONNECTOR 1/4N X 1/8T 90°
9116	P08669116	CONNECTOR 1/4N X 1/8T 90°
9117	P08669117	FLOW CONTROL VALVE POSU GRO-1/8
9118	P08669118	CONNECTOR 1/4N X 1/8T (BRONZE)
9119	P08669119	CONNECTOR 1/4N X 1/4T 90° (BRONZE)
9120	P08669120	CONNECTOR 1/4N X 3/8T
9121	P08669121	CONNECTOR 1/4N X 1/8T 90°

REF	PART #	DESCRIPTION
9122	P08669122	MECHANICAL VALVE POSU
9123	P08669123	CONNECTOR 1/4N X 1/8T
9124	P08669124	CONNECTOR 1/4N X 1/8T 90°
9125	P08669125	BUFFER 1/8 (BRONZE)
9126	P08669126	BUFFER 1/8 (PLASTIC)
9127	P08669127	CONNECTOR 5/16N X 1/8T 90°
9128	P08669128	FLEXIBLE HOSE 8 X 900MM
9129	P08669129	FLEXIBLE HOSE 8 X 1600MM
9131	P08669131	FLEXIBLE HOSE 6 X 1600MM
9132	P08669132	FLEXIBLE HOSE 6 X 750MM
9133	P08669133	FLEXIBLE HOSE 6 X 650MM
9134	P08669134	FLEXIBLE HOSE 6 X 700MM
9135	P08669135	FLEXIBLE HOSE 6 X 800MM
9136	P08669136	FLEXIBLE HOSE 6 X 350MM
9137	P08669137	FLEXIBLE HOSE 6 X 800MM
9138	P08669138	FLEXIBLE HOSE 6 X 1400MM
9139	P08669139	FLEXIBLE HOSE 6 X 500MM
9140	P08669140	T-CONNECTOR 5/16N X 5/16N, BRASS (MALE)
9141	P08669141	FLEXIBLE HOSE 8 X 900MM
9142	P08669142	AIR MANIFOLD 4-PORT
9143	P08669143	AIR SWITCH 1/8

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

Labels & Cosmetics



REF	PART #	DESCRIPTION
9201	P08669201	POSITION PLATE NOTICE LABEL
9202	P08669202	GRIZZLY NAMEPLATE-LARGE
9203	P08669203	MODEL NUMBER LABEL
9204	P08669204	MACHINE ID LABEL
9205	P08669205	DISCONNECT POWER LABEL
9206	P08669206	KEEP DOOR CLOSED LABEL
9207	P08669207	PREWIRED 220V LABEL
9208	P08669208	RESPIRATOR/GLASSES LABEL
9209	P08669209	ELECTRICITY-SMALL LABEL
9210	P08669210	ELECTRICITY-LARGE LABEL

REF	PART #	DESCRIPTION
9211	P08669211	STOP REMOVE BELTS HANG TAG
9212	P08669212	CONVERSION FRACTION
9213	P08669213	SANDER BELT PINCH LABEL
9214	P08669214	GRIZZLY.COM LABEL
9215	P08669215	KICKBACK HAZARD LABEL
9216	P08669216	READ MANUAL LABEL
9217	P08669217	SWITCH DISPLAY NOTICE LABEL
9218	P08669218	TOUCH-UP PAINT, GRIZZLY PUTTY
9219	P08669219	AMPERAGE LOAD CHART LABEL
9220	P08669220	TOUCH-UP PAINT, GRIZZLY GREEN

⚠WARNING

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

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

WARRANTY & RETURNS

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

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

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

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

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

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

To take advantage of this warranty, you must register it at **https://www.grizzly.com/forms/warranty**, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.

grizzly.com®

TOOL WEBSITE

Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!

~Since 1983~

Visit Our Website Today For Current Specials!

ORDER

24 HOURS A DAY!

1-800-523-4777