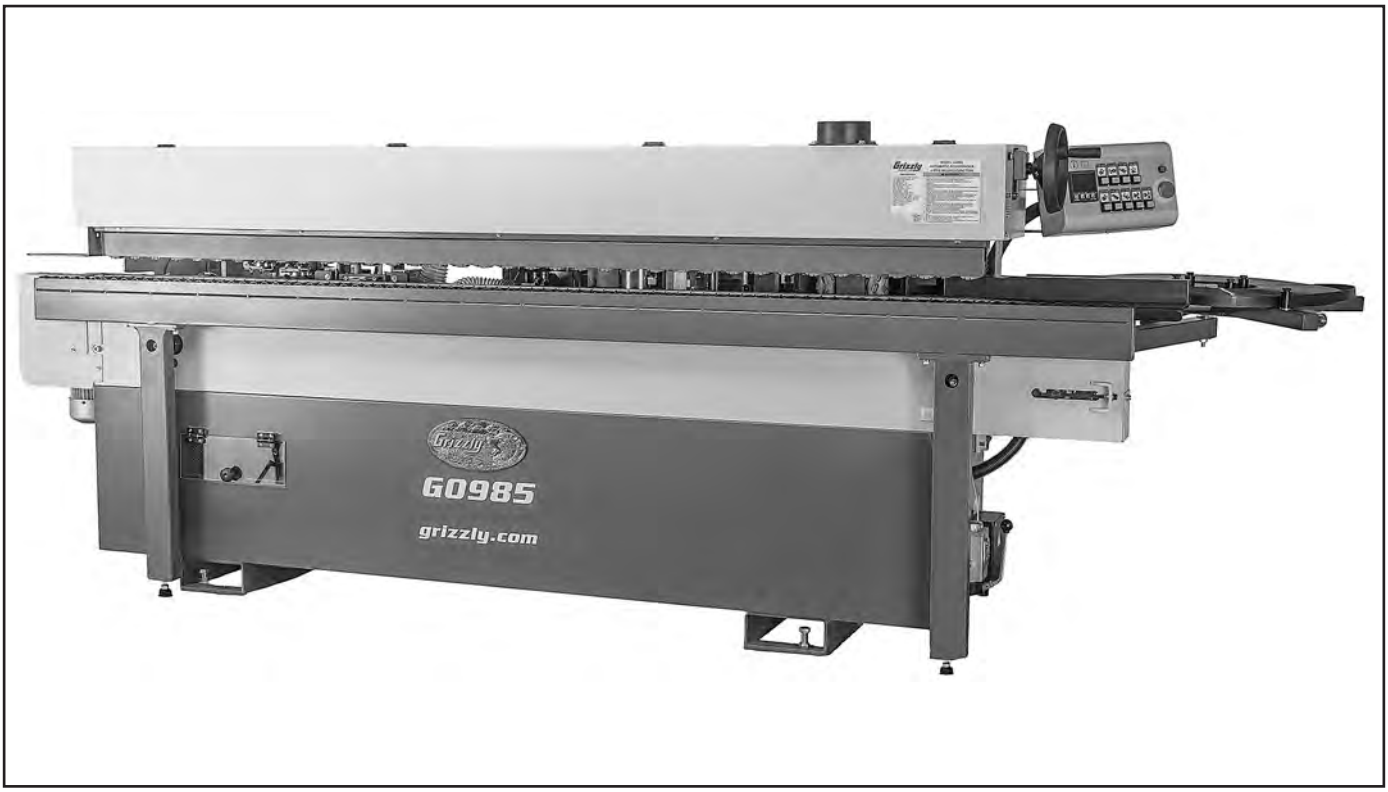
MODEL G0985
AUTOMATIC EDGEBANDER
w/PRE-MILLING FUNCTION

OWNER'S MANUAL

(For models manufactured since 04/24)



#JP23136 PRINTED IN TAIWAN V1.03.25

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

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

INTRODUCTION

Contact Info

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

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

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

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

⚠WARNING

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

⚠CAUTION

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

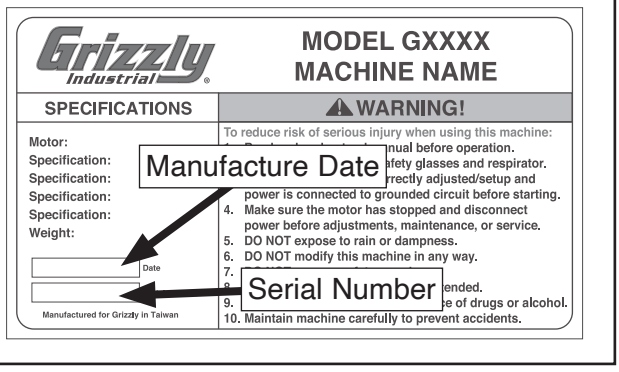
Manual Accuracy

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

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

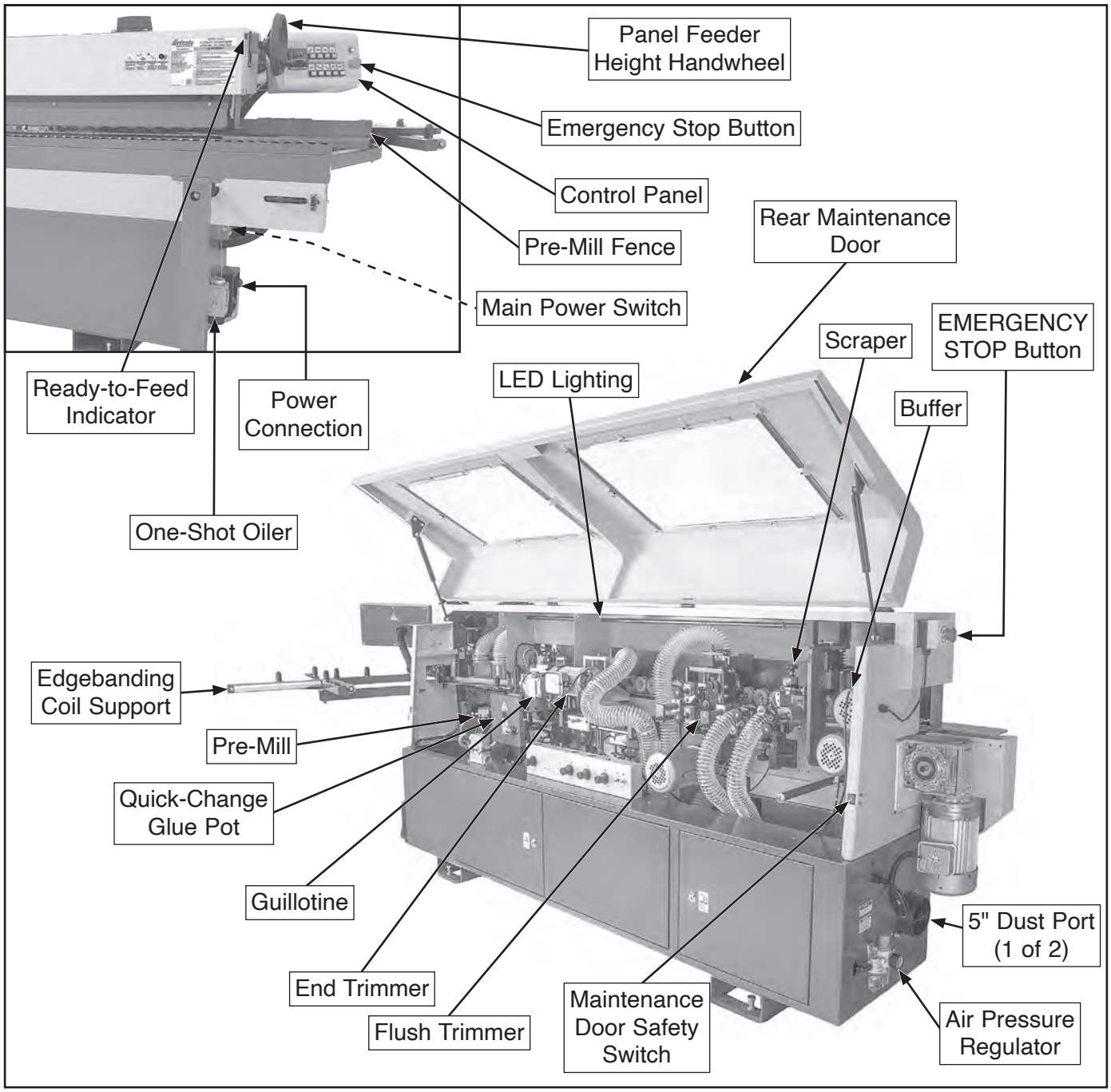
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

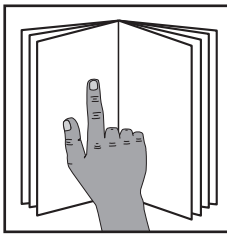
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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



Identification

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

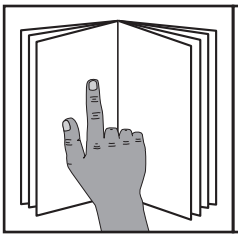




⚠WARNING

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

Controls & Components



⚠WARNING

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

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

Control Panel

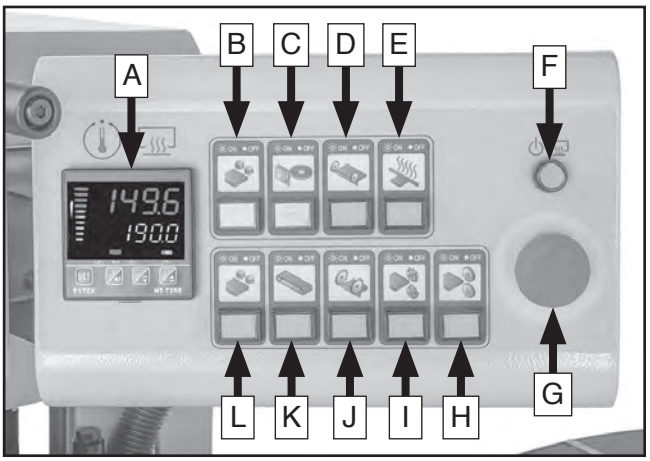


Figure 1. Control panel.

A. Thermoregulator Display: Displays current and set temperatures, and current state of glue pot and spindle. See **Thermoregulator** for more information.

B. Pre-Mill Sensor ON Button: Activates pneumatic solenoids and limit switch that control movement of pre-mill assembly.

C. Guillotine Sensor ON Button: Activates pneumatic solenoids and limit switch that control movement of guillotine blade.

D. End Trimmer ON Button: Activates pneumatic solenoids and limit switch that control movement of end trimmer assembly.

E. Pre-Heating Block ON Button: Activates power to pre-heating block. Allow 1–2 minutes to reach operating temperature.

F. Stand-By Mode Indicator Lamp: Illuminates when machine enters stand-by mode.

G. Emergency Stop Button: Stops all machine functions and deactivates all power, switches, and pneumatic solenoids when pressed. Power is still active to glue pot heating elements when depressed. Twist to reset.

H. Buffing Wheel Motors ON Button: Turns both buffing motors ***ON***.

I. Flush Trimmer Motor ON Button: Turns flush trimming motor ***ON***.

J. End Trimmer Motor ON Button: Turns end trimming motor ***ON***.

K. Conveyor Motor ON Button: Turns conveyor motor ***ON***.

L. Pre-Mill Motor ON Button: Turns pre-mill motor ***ON***.

Thermoregulator

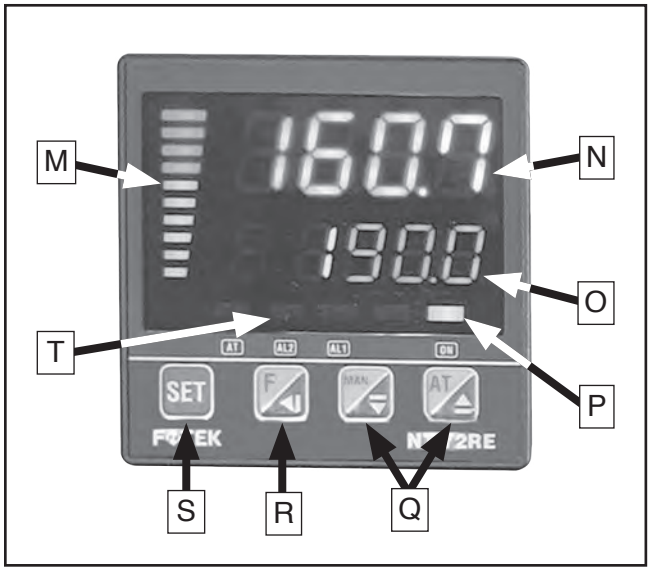


Figure 2. Thermoregulator.

M. Heat Output Level: Indicates output percentage level of glue pot heating rods.

N. Current Temperature: Indicates current temperature of glue pot in Celcius.

O. Set Temperature: Indicates temperature thermoregulator is set to (operating temperature).

P. Cycle *ON* Indicator Light: Illuminates when glue pot is actively heating.

Q. Cycle Up/Down Buttons: Press once, when control panel is in edit mode, to increase/decrease flashing digit by one; press again until desired number is reached.

R. Cycle Left Button: Press once, when control panel is in edit mode, to cycle cursor left one digit; press again until desired digit begins to flash.

Note: *Only press cycle buttons briefly (no more than 1 second). If button is held for 3 seconds or more, thermoregulator will enter programming mode. If programming mode is accidentally entered, briefly press SET button to exit.*

S. SET Button: Press once to enter edit mode; set temperature (C) digit will begin to flash. Press again to return to normal operating mode. Press and hold 4–5 seconds to show numerical percentage value of heat output level. Press and hold again to return to normal operating mode.

T. Glue Spindle Indicator Light: Illuminates when glue spindle is spinning.

Safety Controls & Air Regulator

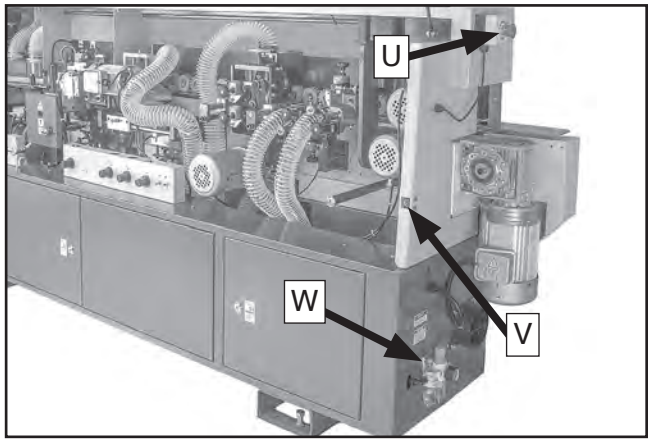


Figure 3. Safety controls and air regulator.

U. EMERGENCY STOP Button: Stops all machine functions and deactivates all controls, switches, and pneumatic solenoids when pressed. Twist to reset.

IMPORTANT: Power is still active to glue pot heating elements when EMERGENCY STOP button is depressed.

V. Rear Maintenance Door Safety Switch: Stops all machine functions and deactivates all controls, switches, and pneumatic solenoids when rear maintenance door is open.

W. Air Pressure Regulator: Adjusts incoming air pressure. Pressure should be set to 100 PSI. Lift knob and rotate *clockwise* to increase PSI; rotate *counterclockwise* to decrease PSI, then push knob down to secure setting.

Power & Lubrication

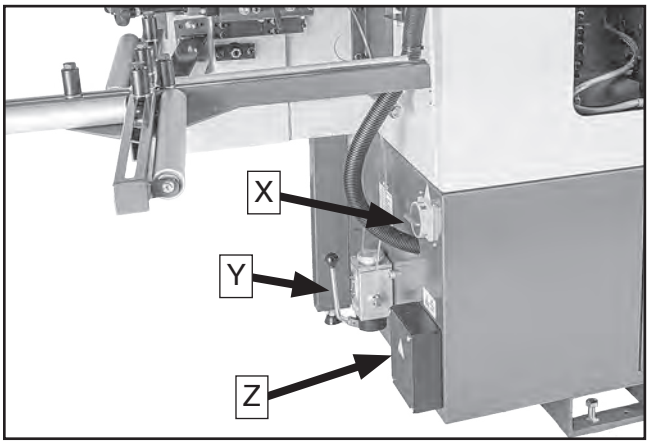


Figure 4. Power and lubrication.

X. Main Power Switch: Turns incoming power ***ON*** and ***OFF***.

Y. One-Shot Oiler: Lubricates conveyor chain. Slowly pull handle (approximately 20 seconds) all the way down with conveyor running to dispense oil.

Z. Incoming Power Junction Box: Connection point for incoming power.

Panel Feeder & Pre-Mill Fence

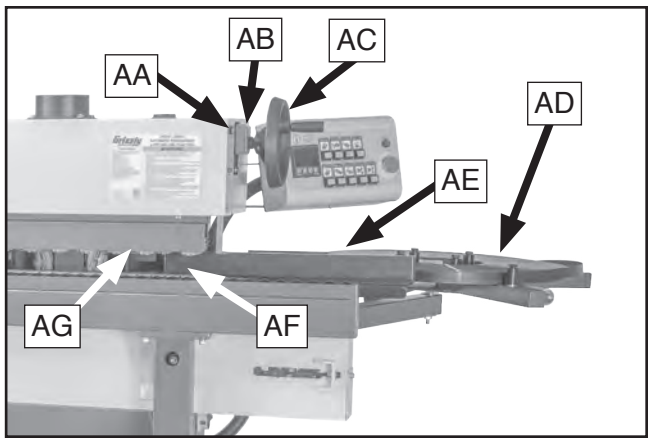


Figure 5. Panel feeder and pre-mill fence.

AA. Ready-to-Feed Indicator: Signals when safe to feed panel into machine. Turns off when panel is detected, then turns back on once panel moves forward, indicating next panel can be fed.

AB. Panel Feeder Height Indicator: Displays panel feeder height setting in millimeters. Decimal point is represented by yellow line.

AC. Panel Feeder Height Handwheel: Adjusts panel feeder height according to workpiece thickness. Rotate *clockwise* to raise panel feeder; rotate *counterclockwise* to lower.

AD. Coil Support: Holds edgebanding coil and allows coil to rotate as machine feeds edgebanding material.

AE. Pre-Mill Fence: Sets depth of cut for pre-milling station. Adjusts from 0–1.5mm.

AF. Conveyor: Advances workpiece from infeed end to outfeed end during operations.

AG. Panel Feeder (Upper): Holds workpiece securely against conveyor with tracking rollers to guide workpiece through work stations.

Pre-Mill Fence Controls

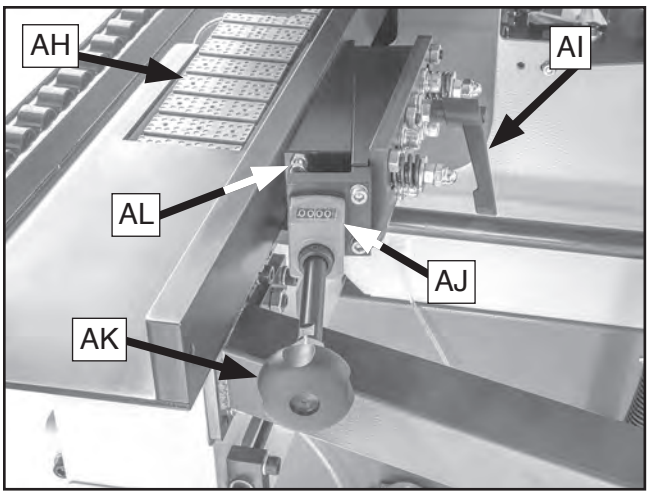


Figure 6. Pre-mill fence adjustment controls.

AH. Conveyor: Feeds through edgebanding stations at 23 FPM (feet per minute).

AI. Pre-Mill Fence Lock Handle: Locks pre-mill fence adjustment in place. Rotate *clockwise* to tighten; rotate *counterclockwise* to loosen.

AJ. Pre-Mill Depth-of-Cut Indicator: Displays pre-mill depth-of-cut setting in millimeters. Decimal point is represented by yellow line.

AK. Pre-Mill Fence Adjustment Knob: Adjusts pre-mill fence from 0–1.5mm to precisely remove edge roughness and face chips. Rotate *clockwise* to increase depth of cut; rotate *counterclockwise* to reduce depth of cut. See **Page 42** for more information.

Note: *When increasing depth of cut, rotate knob past desired measurement, then return to desired measurement to remove backlash.*

AL. Pre-Mill Fence Adjustment Stop Bolt: Preset at factory to stop fence position at 0°.

Edgebander Station Overview

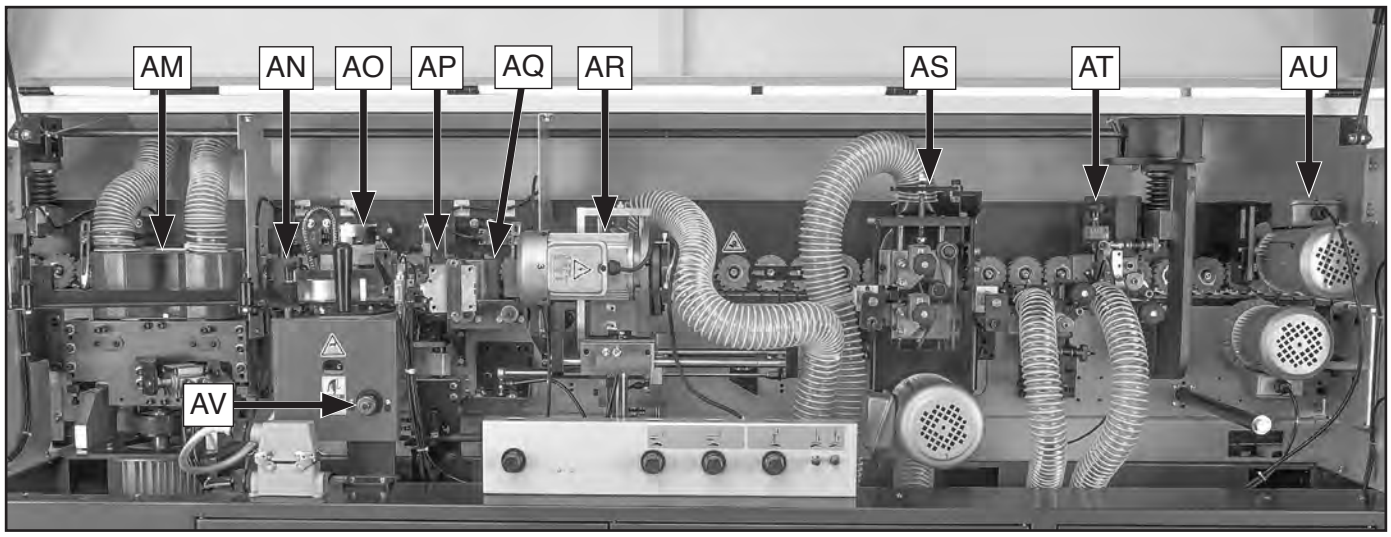


Figure 7. Edgebander station overview.

AM. Pre-Mill: Removes edge roughness and face chips from workpiece. Depth adjusts by rotating pre-mill fence adjustment knob.

AN. Pre-Heating Block: Preheats workpiece edge for optimum glue adhesion.

AO. Glue Pot & Spindle: Holds and heats glue; spindle rotates to draw melted glue from pot and apply to workpiece.

AP. Edgebanding Advancement & Guillotine: Advances edgebanding from coil; guillotine cuts edgebanding to approximate length of workpiece.

AQ. Pressure Rollers: Apply pressure to push out any trapped air between edgebanding and panel edge, ensuring a smooth and uniform bond.

AR. End Trimmers: Precisely trim edgebanding flush with each end of workpiece.

AS. Flush Trimmers: Trim excess edgebanding from top and bottom of workpiece edges.

AT. Scrapers: Scrape top and bottom edges of edgebanding and workpiece to remove excess glue and refine edge, adding a slight chamfer.

AU. Buffers: Remove scratches, imperfections, and glue residue left behind by trimmers and scrapers.

AV. Glue Spindle Adjustment Knob: Adjusts position of glue pot. Rotate *counterclockwise* all the way to ensure glue spindle is correctly positioned during operation. Rotate *clockwise* all the way when removing/replacing glue pot.

Glue Pot, Guillotine, & Pressure Rollers

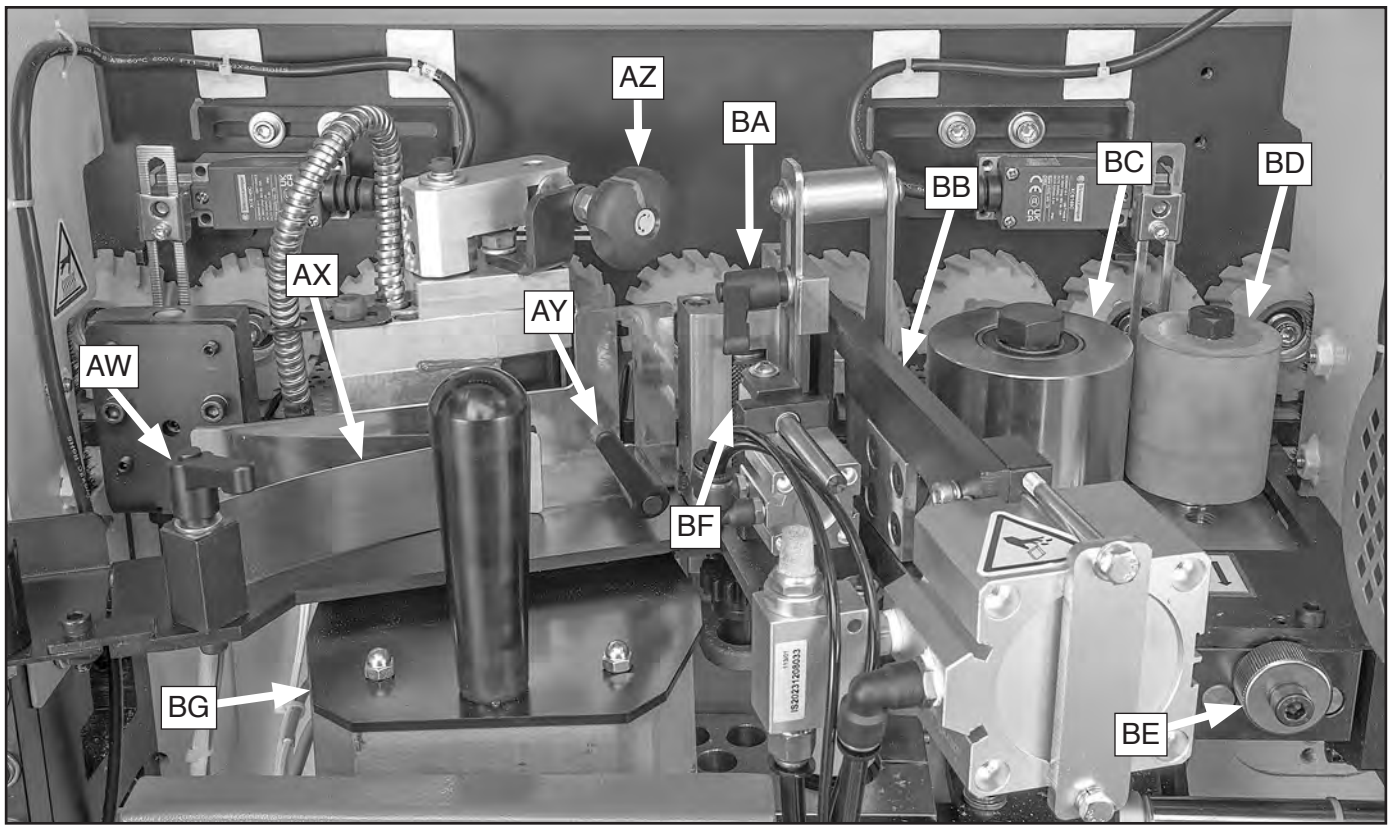


Figure 8. Glue pot, guillotine, and pressure rollers.

AW. Edgebanding Intake Pressure Plate Lock Handle: Adjusts to height of edgebanding width and helps keep edgebanding centered on workpiece edge.

AX. Edgebanding Intake Pressure Plate: Holds edgebanding firmly against intake guide as it advances into guillotine and onto workpiece edge.

AY. Edgebanding Guide Lock Handle: Adjusts to height of edgebanding width for proper feeding through advancement rollers.

AZ. Glue Flow Adjustment Knob: Adjusts amount of glue supplied to glue spindle. Rotate *clockwise* to decrease glue flow; rotate *counterclockwise* to increase glue flow.

BA. Edgebanding Guillotine Guide Lock Handle: Adjusts to height of edgebanding width and keeps edgebanding in place during cutting process.

BB. Guillotine: Cuts edgebanding as trailing end of workpiece passes.

BC. Stationary Pressure Roller: Presses edgebanding against workpiece after glue is applied.

BD. Adjustable Pressure Roller: Presses edgebanding against workpiece. Pressure roller is spring loaded to precisely follow workpiece edge with consistent pressure.

BE. Pressure Roller Adjustment Knob (1 of 2): Adjusts position of pressure roller assembly. Insert edgebanding piece and tighten knobs to set correct pressure roller depth.

BF. Edgebanding Advancement Rollers: Pneumatically pinches edgebanding between two rollers and advances edgebanding onto workpiece edge.

BG. Glue Pot: Stores and heats glue for bonding edgebanding to workpiece edge. Remove lid to inspect glue pot or add glue. Always leave lid closed during operations.

Flush Trimmer & Scraper Controls

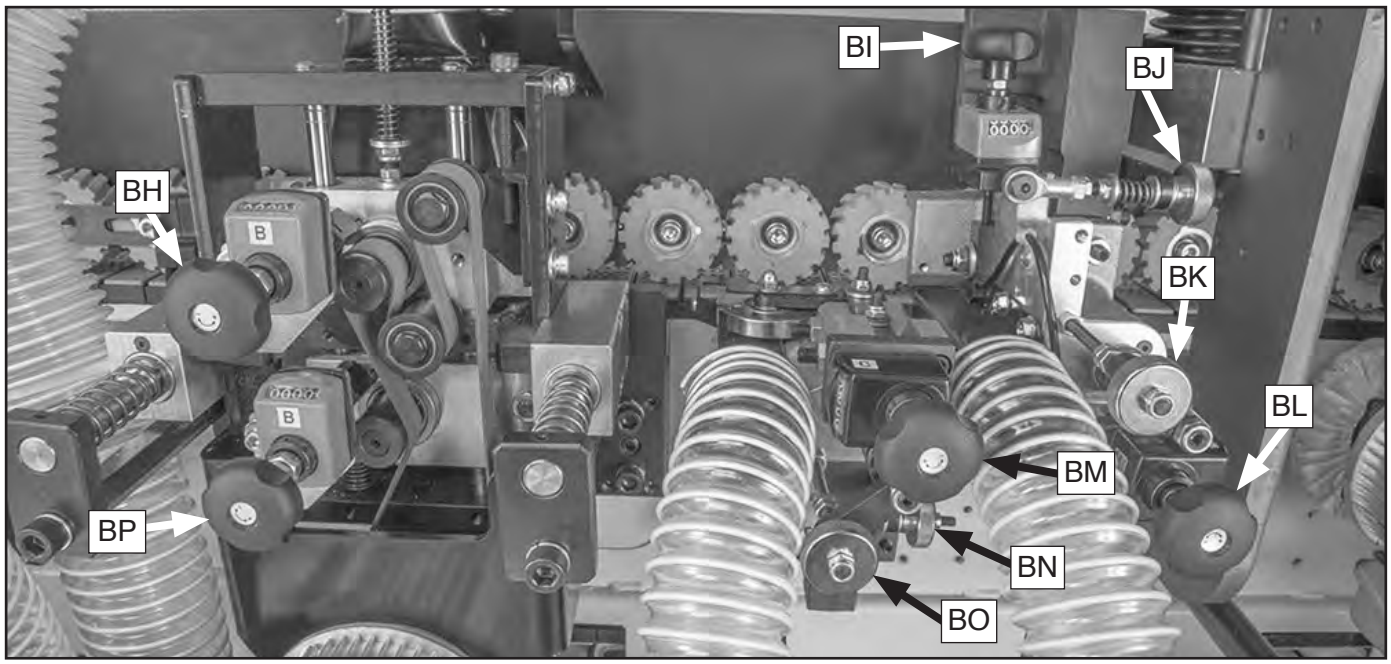


Figure 9. Flush trimmer and scraper controls.

BH. Upper Flush Trimmer Adjustment Knob w/ Dial Indicator: Rotates *counterclockwise* to decrease depth of cut; rotates *clockwise* to increase depth of cut. Dial indicator shows measurement in millimeters.

BI. Upper Scraper Height Adjustment Knob w/Dial Indicator: Rotates *clockwise* to move upper scraper away from top of workpiece; rotates *counterclockwise* to move scraper toward workpiece.

BJ. Upper Scraper Height Micro-Adjustment Knob: Rotates *clockwise* to move upper scraper assembly away from top of workpiece; rotates *counterclockwise* to move assembly toward workpiece.

BK. Upper Scraper Depth Micro-Adjustment Knob: Rotates *clockwise* to move upper scraper assembly away from edge of workpiece; rotates *counterclockwise* to move assembly toward workpiece.

BL. Upper Scraper Depth Adjustment Knob w/ Dial Indicator: Rotates *clockwise* to move upper scraper away from edge of workpiece; rotates *counterclockwise* to move scraper toward workpiece. Dial indicator shows measurement in millimeters.

BM. Lower Scraper Depth Adjustment Knob w/ Dial Indicator: Rotates *clockwise* to move lower scraper away from edge of workpiece; rotates *counterclockwise* to move scraper toward workpiece. Dial indicator shows measurement in millimeters.

BN. Lower Scraper Height Micro-Adjustment Knob: Rotates *clockwise* to move upper scraper assembly away from top of workpiece; rotates *counterclockwise* to move assembly toward workpiece.

BO. Lower Scraper Depth Height Micro-Adjustment Knob: Rotates *clockwise* to move upper scraper assembly away from edge of workpiece; rotates *counterclockwise* to move assembly toward workpiece.

BP. Lower Flush Trimmer Adjustment Knob w/ Dial Indicator: Rotates *counterclockwise* to decrease depth of cut; rotates *clockwise* to increase depth of cut. Dial indicator shows measurement in millimeters.

Note: *When using adjustment knobs to increase depth of cut, rotate knob past desired measurement, then return to desired measurement to remove backlash.*

MACHINE DATA SHEET

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

MODEL G0985
AUTOMATIC EDGEBANDER W/PRE-MILLING FUNCTION

Product Dimensions:

Weight	1,404 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	136 x 47-1/2 x 51-1/2 in.
Footprint (Length x Width)	66-1/2 x 18-1/2 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	1,841 lbs.
Length x Width x Height	127 x 29 x 58 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	220V, 3-Phase, 60 Hz
Full-Load Current Rating	20A
Minimum Circuit Size	30A
Connection Type	Cord & Plug
Power Cord Included	No
Recommended Power Cord	10 AWG
Plug Included	No
Recommended Plug Type	L15-30
Switch Type	Control Panel w/Magnetic Switch Protection

Motors:

Feed

Horsepower	1 HP
Phase	3-Phase
Amps	3.1A
Speed	1700 RPM
Type	TEFC Induction
Power Transfer	Gear
Bearings	Shielded & Permanently Lubricated

Pre-Mill

Horsepower	2 HP
Phase	3-Phase
Amps	5.8A
Speed	3400 RPM
Type	TEFC Induction
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Glue Spindle

Horsepower	1/3 HP
Phase	3-Phase
Amps	1.6A
Speed	1720 RPM
Type	TEFC Induction
Power Transfer	Gear
Bearings	Shielded & Permanently Lubricated

End Trim

Horsepower	1/4 HP
Phase	3-Phase
Amps	0.8A
Speed	3400 RPM
Type	TEFC Induction
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Flush Trim

Horsepower	3/4 HP
Phase	3-Phase
Amps	2A
Speed	3400 RPM
Type	TEFC Induction
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Buffing

Horsepower	1/6 HP
Phase	3-Phase
Amps	0.6A
Speed	3400 RPM
Type	TEFC Induction
Power Transfer	Direct
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Min. Panel Width	3-9/16 in.
Min. Panel Length	6-3/4 in.
Panel Thickness (Min.–Max.)	1/2–1-3/4 in.
Tape Thickness (Min.–Max.)	0.5–3 mm
Air Requirement	6 SCFM @ 100 PSI
Panel Feed Speed	23 FPM
Glue Pot Capacity	34 oz.
Roller Width	1 in.
Roller Diameter	2-7/16 in.
Max. Height of Rollers	1-3/4 in.
Edgebanding Coil Capacity	29-1/2 in.
Dust Collection Ports (2)	5 in.
Dust Collection Requirement (at Dust Port)	1100 CFM
Heating Element	1440W

Table Information

Work Table Length	120-5/8 in.
Work Table Width	3-1/8 in.
Work Table Height	33 in.

Construction

Housing	Steel
Frame	Steel
Rollers	Rubber
Finish	Powder Coated

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	2 Hours
Serial Number Location	Machine ID Label
Sound Rating	85 dB
ISO 9001 Factory	Yes

Features:

Adjustable Pre-Milling Function
Automatic Belt Feed with Adjustable Table Rollers
Edgebanding Thickness From 0.5mm–3mm
Panel Thickness From 1/2"–1-3/4"
23 FPM Feed Speed
Pre-Heating Station for Better Glue Dispersion
Pneumatic Edgebanding Guillotine
Double-Bladed End-Trimming Saw
Upper and Lower Trimming Units with Digital Readout
Upper and Lower Buffing Units
Extendable Side Bar to Accommodate Larger Panels
Control Panel Controls Each Element Individually
Teflon-Coated Glue Pot with 5 Heating Elements and Motorized Glue Spreader
29-1/2" Tape Coil Support
Two 5-inch Dust Ports
Built-In Air Regulator and Filter for Pneumatic System

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 Automatic Edgebanders

⚠WARNING

Serious injury can occur from getting fingers pinched or crushed between workpiece and conveyor belt, or getting hair/clothing entangled in conveyor belt. Touching hot parts can cause serious burns. Long-term respiratory damage can occur from using edgebander without a respirator and adequate dust collection system. To minimize risk of injury, anyone operating this machine MUST completely heed hazards and warnings below.

HAND PLACEMENT. The gap between the conveyor belt and support table increases risk of pinching or crushing injuries. Minimize this risk by keeping fingers clear of infeed area when feeding workpieces.

AVOIDING ENTANGLEMENT. Becoming entangled in conveyor belt can cause crushing injuries. To avoid these hazards, DO NOT wear loose clothing, gloves, or jewelry, and tie back long hair.

GLUE POT & GLUE SPINDLE. The glue pot and glue spindle get very hot and can cause serious burns. Always wear gloves when adding glue to glue pot. When servicing glue pot and spindle, make sure machine is turned ***OFF***, disconnected from air and power, and components have properly cooled before handling.

BLADE REPLACEMENT. When replacing blades, cutters, or guillotine, disconnect machine from power, wear gloves to protect hands, and wear safety glasses to protect eyes.

HEATED FENCE. Heated fence is very hot and can cause serious burns. Avoid touching fence, especially when feeding small workpieces.

WEAR PROPER PPE. Always wear safety glasses, respirator, and hearing protection when operating edgebander.

DUST COLLECTION. Never operate without adequate dust collection system in place and running. Proper dust collection reduces dust in work area, which decreases risk of long-term respiratory damage. However, a dust collector is not a substitute for using a respirator. Always wear a properly fitting respirator in addition to operating the dust collector.

POWER DISCONNECT. To reduce risk of electrocution or injury from unexpected startup, make sure machine is turned ***OFF***, disconnected from air and power, and all moving parts have come to a complete stop before changing cutting tools, or starting any inspection, adjustment, or maintenance procedure.

SAFETY DEVICES. Do not modify or disable any limit switches, guards, or other safety devices on this machine. Doing so will void the warranty and expose operator to serious injury from mechanical, electrical, and pneumatic components inside machine.

ADEQUATE VENTILATION. When melted, edgebanding glue pellets can produce vapors and fumes that may irritate the nose, throat, and respiratory tract. Only operate this machine with proper ventilation near work area.

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 ..... 20 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 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 208V, 220V, 230V, 240V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 30 Amps
Plug/Receptacle ..... NEMA L15-30
Cord ..... "S"-Type, 4-Wire, 10 AWG, 300 VAC

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.

IMPORTANT: This machine is designed to operate on a dedicated circuit. Sharing a circuit with other equipment can cause a surge and compromise circuit boards and other electrical components.

Grounding Instructions

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

The power cord and plug specified under "Circuit Requirements for 220V" on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

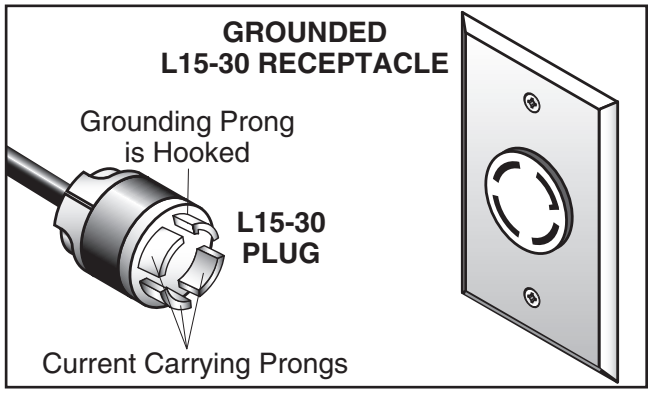
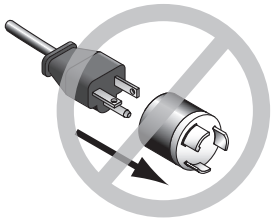


Figure 10. Typical L15-30 plug and receptacle.

⚠CAUTION



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

⚠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.

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

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

Extension Cords

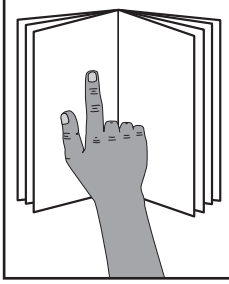
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

Minimum Gauge Size.....10 AWG
Maximum Length (Shorter is Better).....25 ft.

SECTION 3: SETUP

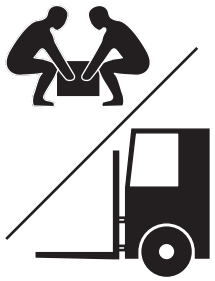


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

Items Needed	Qty
• Assistant	1
• Safety Glasses (for each person)	1
• Lifting Equipment (Rated for at least 2300 lbs.)	1
• Hex Wrenches 4, 6mm	1 Ea.
• Wrench or Socket 8mm	1
• Open-End Wrench 17mm	1
• Open-End Wrench 24mm	1
• Solvent/Cleaner	As Needed
• Shop Rags	As Needed
• Straightedge	1
• Wire Snips	1
• Level (6 ft.)	1
• Dust Hoses 5"	2
• Hose Clamps 5"	4
• Dust Collection System	1

Unpacking

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

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

Inventory

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

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

NOTICE

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

Box 1 Contents (Figure 11)	Qty
A. Coil Support Mounting Arm	1
B. Machine Leveling Pads	4
C. Spindle Lock Tool Kit	1
D. Grease Gun	1
E. Hex Wrench 5mm	1
F. Dust Port 5"	1
G. Glue Pot Lid	1
H. Panel Feeder Height Handwheel	1

Box 2 Contents (Figure 12)	Qty
I. Coil Support Assembly	1
J. Hardware Bag	1
• Hex Nuts M8-1.25 (Spindle Lock Tool)	2
• Cap Screws M8-1.25 x 20	2
• Flat Washers 8mm	2
• Lock Washers 8mm	2
• Adjustable Guide Roller Assemblies	
—Shoulder Bolts M8-1.25 x 12 x 52	5
—Coil Roller	5
—Flat Washers 8mm	5
—Roller Slide Nuts M8-1.25	5
• Coil Support Stud Assembly	
—Stud-FT M10-1.5 x 150	1
—Hex Nuts M10-1.5	4
—Fender Washers 10mm	4

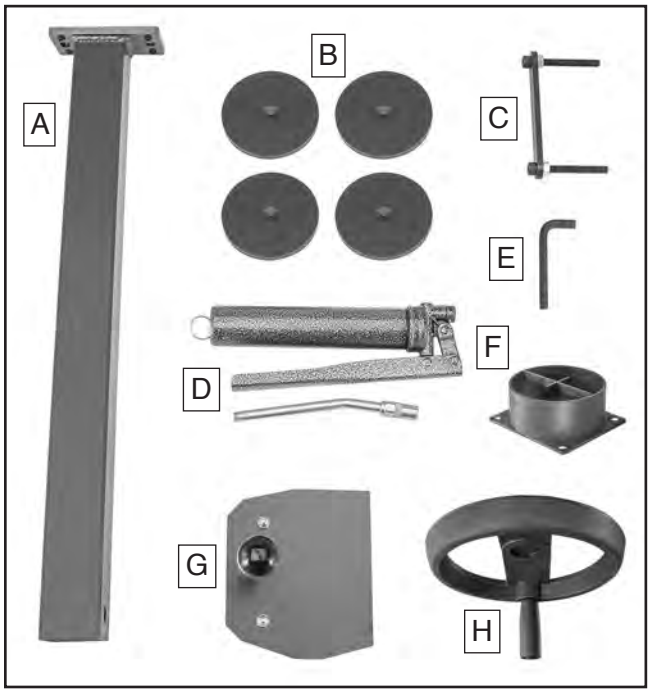


Figure 11. Box 1 contents.

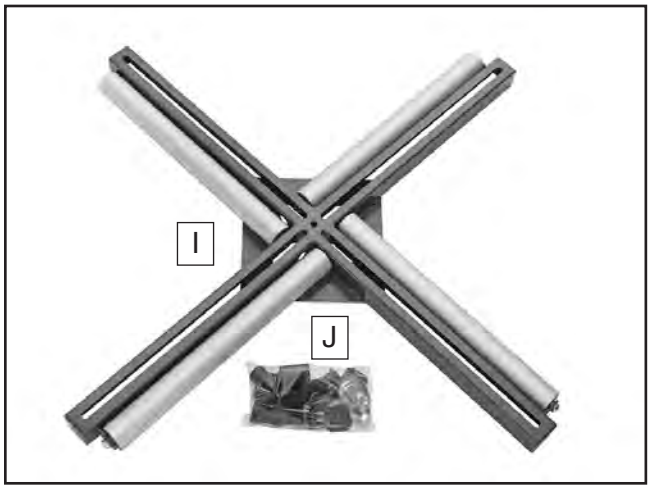


Figure 12. Box 2 contents.

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.

Order online at
www.grizzly.com
OR
Call 1-800-523-4777

Figure 13. T23692 Orange Power Degreaser.

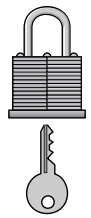
Site Considerations

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.

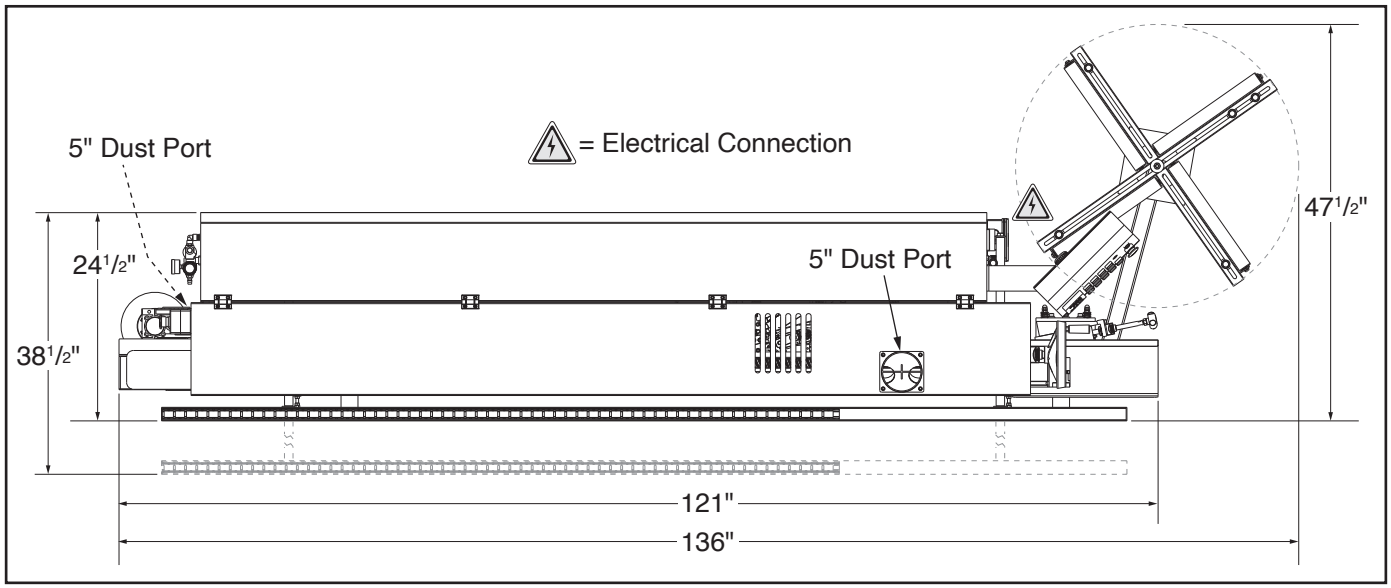
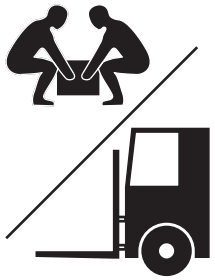


Figure 14. Minimum working clearances.

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.

To lift and place machine:

1. Position crate with machine as close to installation location as possible.

2. Remove top and sides of crate, then remove plastic wrap and small items packed around machine.

3. Position forklift forks as wide as possible while still fitting under center opening of edgebander cabinet (see **Figure 15**). Protect machine body from forks with cardboard.

Figure 15. Example of inserting forks for lifting edgebander.

4. Unbolt machine from pallet.

5. Lift machine with forklift enough to clear pallet, then have an assistant slide pallet out of the way.

6. Position machine as necessary, then gently lower it onto floor.

   Note: *Install leveling pads under adjustment bolts where necessary.*

7. Stabilize machine by loosening jam nuts and rotating leveling bolts (see **Figure 16**) until machine is level, then tighten jam nuts to secure. The leveling bolts are located at each corner of machine.

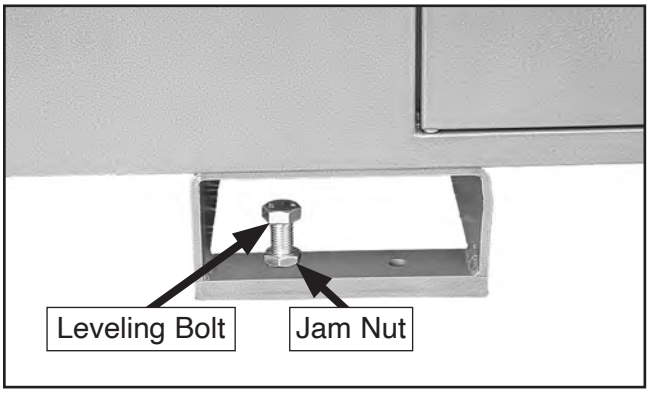


Figure 16. Location of leveling bolts with jam nuts (1 of 4).

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).

Assembling the Model G0985 requires installing the panel feeder height handwheel, coil support assembly, and aligning the table extension with the table.

To assemble machine:

1. Remove pre-installed M5-.8 x 55 cap screw and M5-.8 lock nut from panel feeder height handwheel (see **Figure 17**).

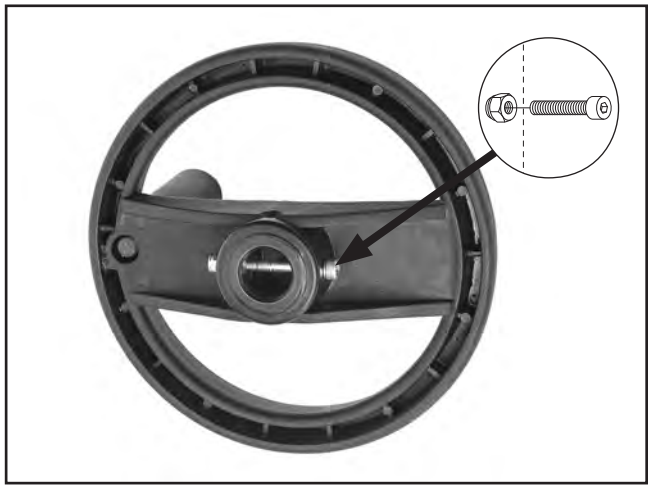


Figure 17. Location of pre-installed panel feeder height handwheel mounting hardware.

2. Install handwheel on panel feeder elevation shaft (see **Figure 18**), and secure with cap screw and lock nut removed in **Step 1**.

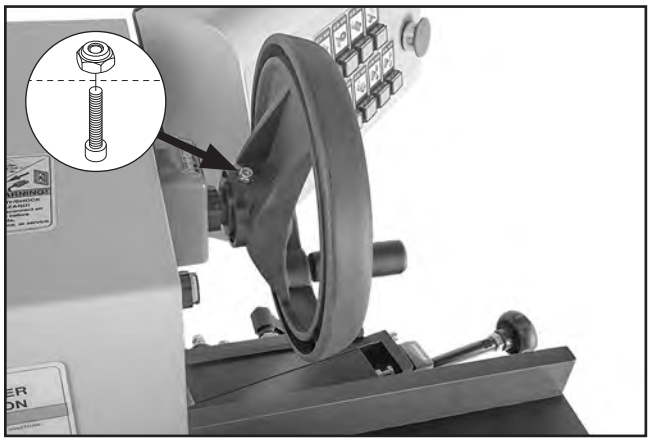


Figure 18. Panel feeder height handwheel installed.

3. Install coil support mounting arm with (2) M8-1.25 x 20 cap screws, (2) 8mm lock washers, and (2) 8mm flat washers, (see **Figure 19**). Use pre-installed set screws to level support arm, then tight cap screws.

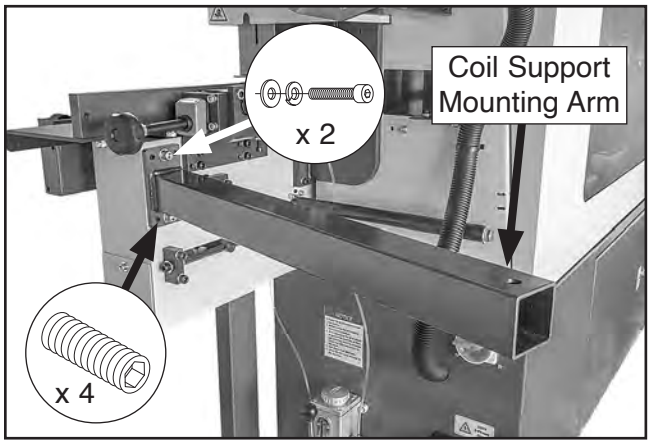


Figure 19. Coil support mounting arm installed.

4. Remove (3) pre-installed M10-1.5 hex nuts and (3) 10mm fender washers from coil support stud (see **Figure 20**).

   Note: *Leave (1) M10-1.5 hex nut and (1) 10mm fender washer installed.*

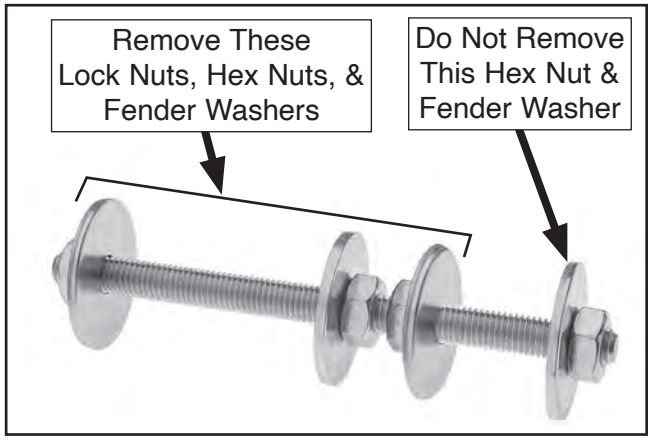


Figure 20. Coil support stud.

5. Install stud through bottom of coil support arm (see **Figure 21**) and secure with (1) M10-1.5 hex nut and (1) 10mm fender washer.

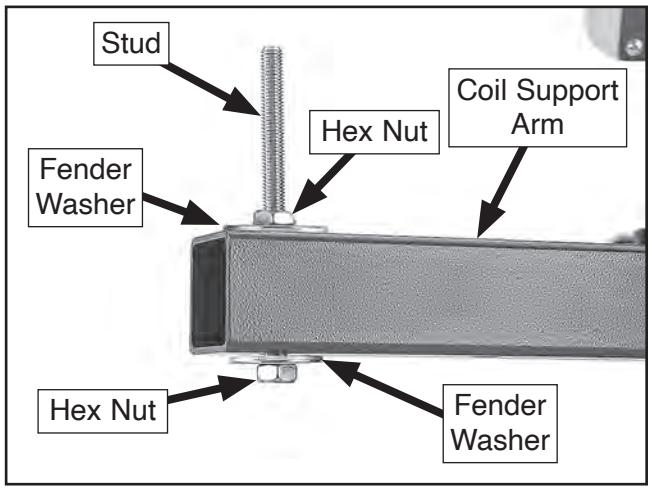


Figure 21. Stud installed into coil support arm.

6. Install (1) M10-1.5 hex nut and (1) 10mm fender washer on coil support stud (see **Figure 22**).

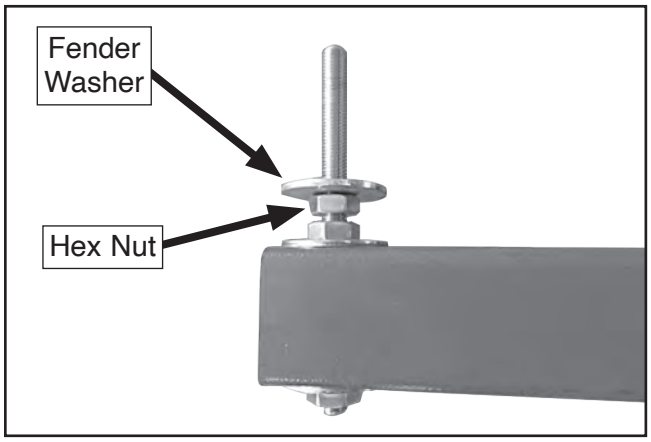


Figure 22. Fender washer installed on coil support stud.

7. Install coil support assembly on stud and secure with (1) M10-1.5 hex nut and 10mm fender washer (see **Figure 23**).

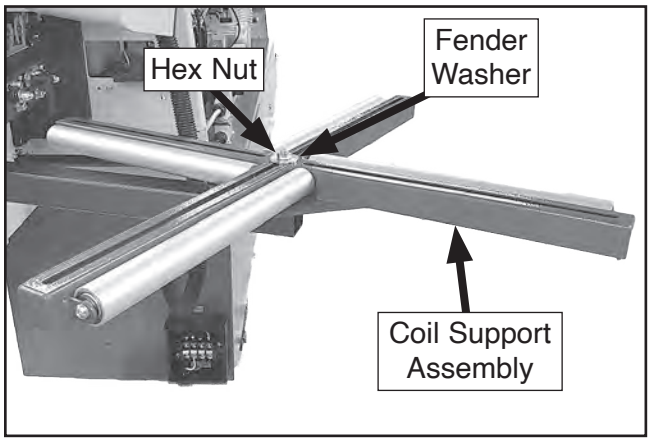


Figure 23. Coil support assembly installed.

8. Remove slide nut from each of (5) guide roller assemblies (see **Figure 24**).

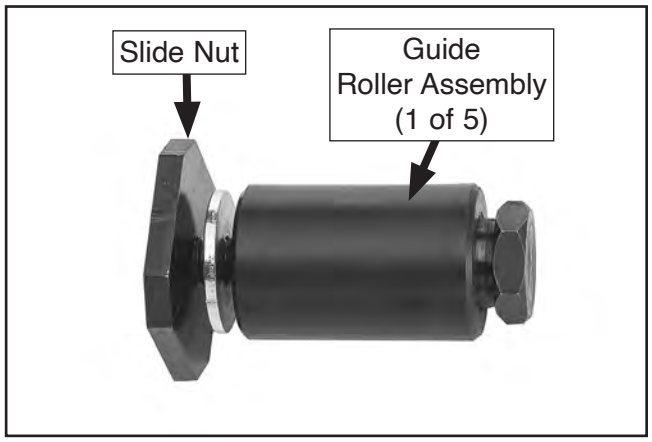


Figure 24. Guide roller assembly and slide nut (1 of 5).

9. Place slide nut under slot in coil support assembly, then thread guide roller with washers into nut from above and tighten, as shown in **Figure 25**. Repeat with remaining (4) guide roller assemblies in each of the remaining slots.

   Note: *One arm of coil support will have (2) guide rollers.*

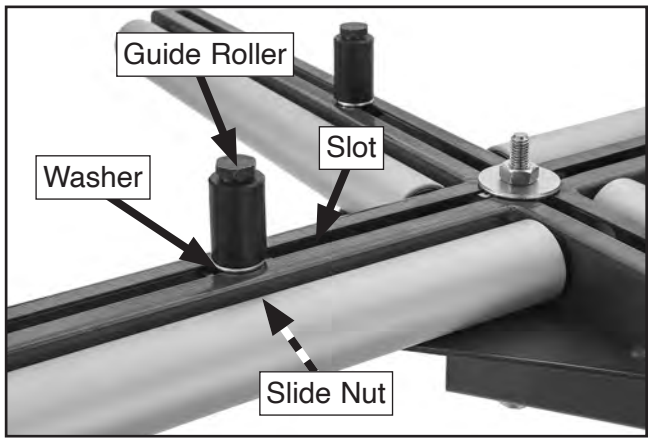


Figure 25. Guide roller installed in coil support slot.

10. Rotate panel feeder height handwheel *clockwise* to slightly raise panel feeder, then remove plastic sheet and wood shipping blocks from infeed and outfeed ends of panel feeder (see **Figure 26**).

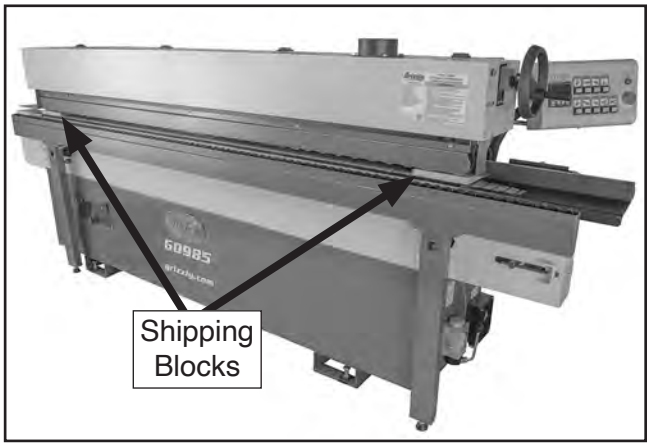


Figure 26. Location of shipping blocks.

11. Open rear maintenance door and install glue pot lid (see **Figure 28**).

Figure 27. Locations of glue pot lid.

12. Remove (2) shipping tags and zip-ties from pre-mill and end-trimming motors, as shown in **Figure 28**.

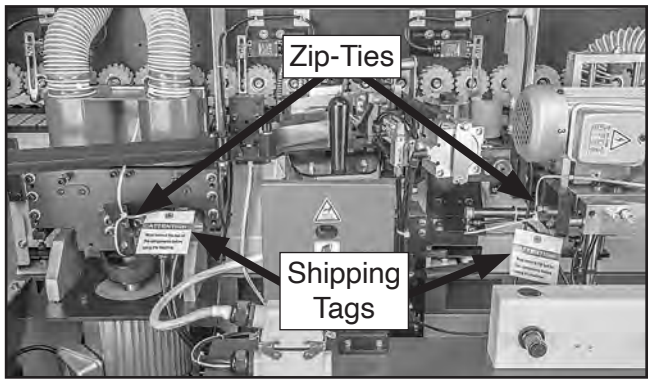


Figure 28. Locations of shipping tags to be removed.

13. Remove remaining shipping tag, and rotate glue spindle adjustment knob *counterclockwise* all the way to move glue spindle forward (see **Figure 29**).

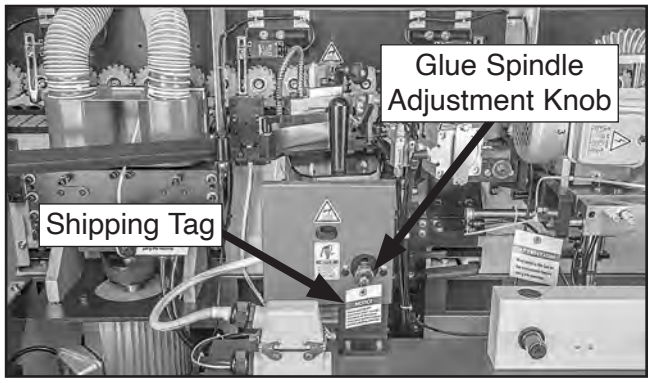


Figure 29. Location of glue spindle adjustment knob.

14. Pull support extension all the way out (see **Figure 30**).

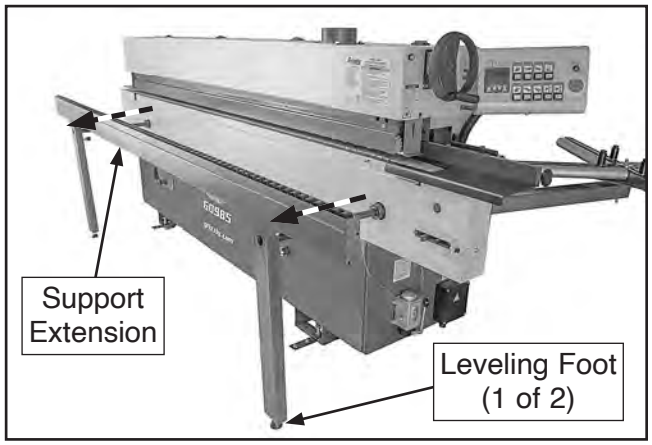


Figure 30. Support extension pulled out.

15. Place level over infeed table and support extension roller; use support extension leveling foot (see **Figure 30**) to raise or lower until level with infeed table (see **Figure 31**).

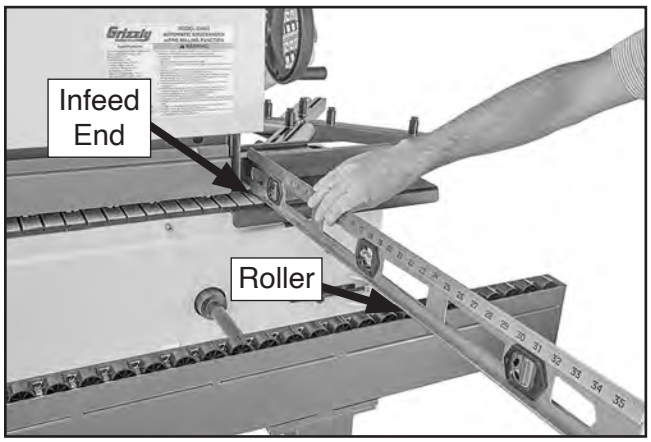


Figure 31. Leveling extension with conveyor.

16. Repeat **Step 15** at outfeed end, placing level on conveyor belt and support extension roller.

17. Install upper dust port using (4) pre-installed flange bolts (see **Figure 32**).

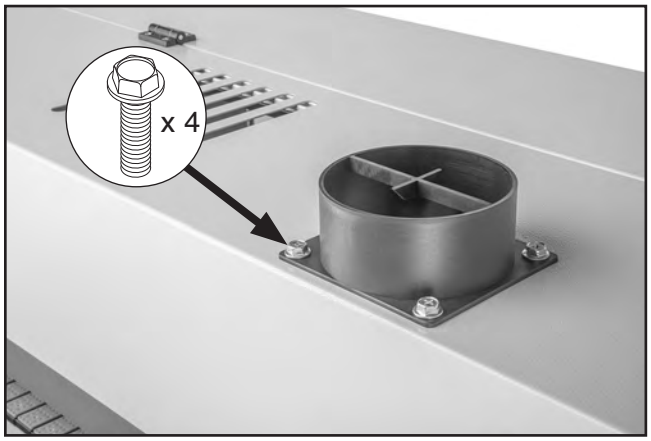


Figure 32. Upper dust port installed.

Dust Collection

⚠CAUTION

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

Minimum CFM at Each Dust Port: 600 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect dust collection system to machine:

1. Fit a 5" dust hose over each dust port, as shown in **Figure 33**, and secure them in place with hose clamps.

2. Tug the hoses to make sure they do not come off.

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

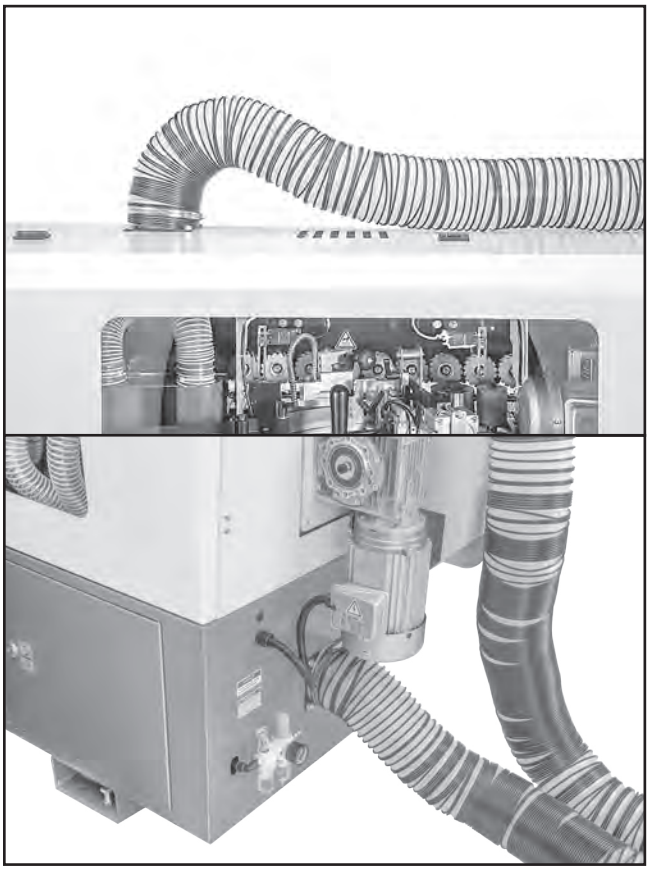


Figure 33. Dust hoses attached to dust ports.

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.

⚠WARNING

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

Phase Converters

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, use only a rotary or digital phase converter.

IMPORTANT: Ensure rotary is connected to **T** terminal and does not exceed 230V.

You can find the Model G7979, a compatible phase converter on our website at **www.grizzly.com.**

G7979—20 HP Rotary Phase Converter
This rotary phase converter allows you to operate 3-phase machinery from a single-phase poer source at 100% power and 95% efficiency.

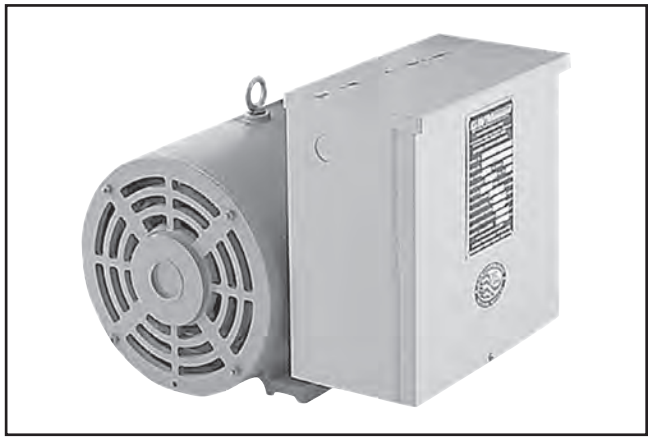


Figure 34. G7979 20 HP rotary phase converter.

Connecting Plug to Power Cord

To connect plug to power cord, install L15-30 plug to end of power cord per plug manufacturer's instructions.

Note About Extension Cords: Using an incorrectly sized extension cord may decrease the life of electrical components on your machine. If you must use an extension cord, refer to **Extension Cords** on **Page 17** for more information.

⚠WARNING

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

Correcting Phase Polarity

If you discover during the test run that the machine will not operate, or that the conveyor runs backwards, the plug may be wired "out of phase," meaning that the polarity is incorrectly wired. This is a common situation with 3-phase power and it is easy to correct.

To correct phase polarity:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open junction box and swap wires connected to **R** and **S** terminals (see **Figure 35**).

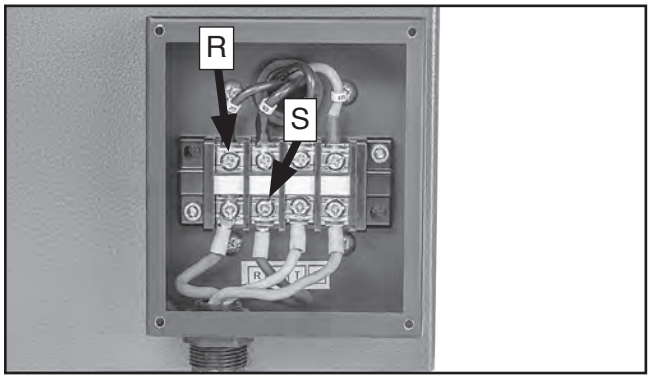


Figure 35. Location of **R** and **S** terminals.

3. Close and secure junction box.

4. Follow **Test Run** to ensure 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.

⚠WARNING

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

⚠WARNING

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

NOTICE

Ensure all shipping tags have been removed and glue spindle has been adjusted forward before operating machine.

The test run consists of verifying the following:

- Glue pot powers up and reaches operating temperature of 180° C.
- Pre-mill, guillotine, end trimmer, and pre-heating block sensors activate.
- Pre-mill, conveyor, end trimmer, flush trimmer, and buffing motors power up and run correctly.
- Emergency Stop buttons work correctly.
- Rear maintenance door safety switch operates correctly.

To test run machine:

1. Clear all setup tools away from machine.
2. Turn main power switch to **OFF** (0) position and press both Emergency Stop buttons in.
3. Ensure glue pot has adequate amount of glue added (refer to **Checking/Adding Glue** on **Page 36** for instructions).
4. Close rear maintenance door.
5. Connect machine to air and power; adjust air regulator to 100 PSI.
6. Turn main power switch to ON (I) position. Thermoregulator display (see **Figure 36**) will illuminate and glue pot will begin heating. Allow glue pot to reach operating temperature before continuing (refer to **Machine Startup** on **Page 34** for more information).

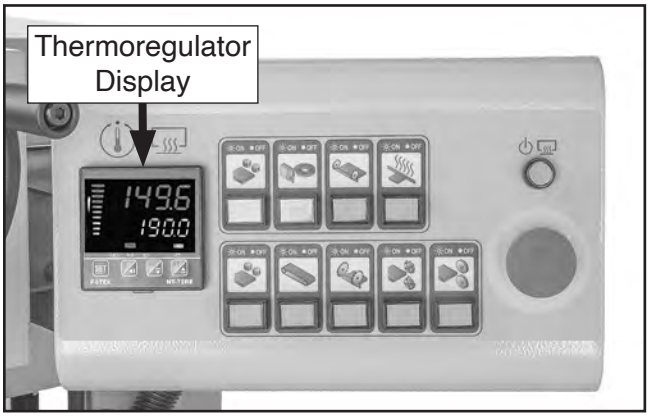


Figure 36. Location of thermoregulator display.

7. Twist each Emergency Stop button *clockwise* until it springs out (see **Figure 37**). This resets switches so machine can start.

Figure 37. Resetting Emergency Stop button.

8. Press pre-mill sensor ON/OFF button (see **Figure 38**); button will illuminate, indicating sensor is activated. Press button again; button will darken, indicating sensor is no longer activated.

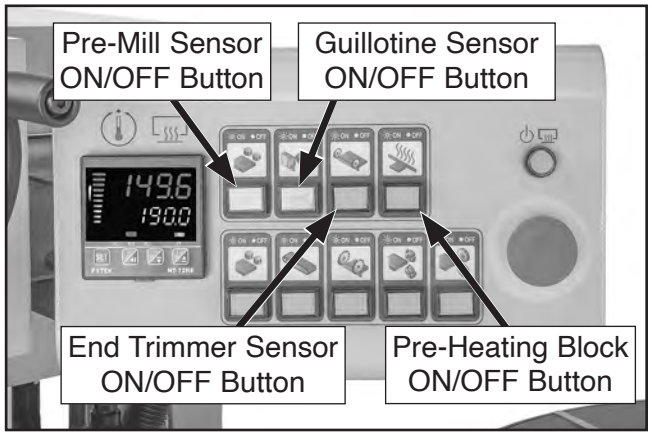


Figure 38. Location of ON/OFF buttons controlling pre-mill, guillotine, end trimmer, and pre-heating block sensor.

Note: *Sensors will not activate if air pressure supply is inadequate. Ensure air pressure supply is set to 100 PSI and machine air regulator is correctly adjusted.*

9. Repeat **Step 8** for guillotine and end trimmer sensors. Follow same procedure for pre-heating block; pre-heating block will begin to heat up when ***ON***, and cool down when ***OFF***.

10. Press conveyor motor ON/OFF button (see **Figure 39**); button will illuminate and conveyor motor will turn ***ON***. Conveyor should run smoothly without any unusual problems or noises.

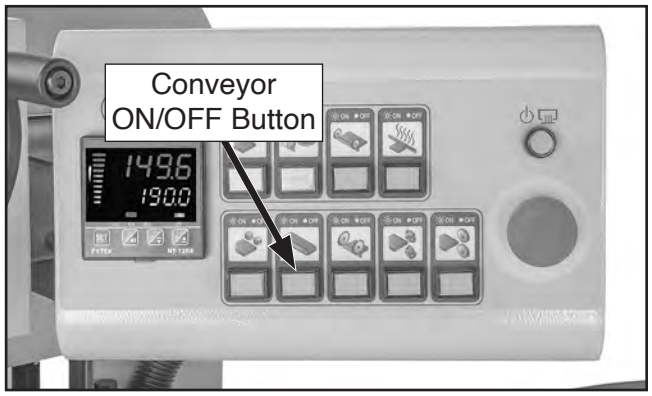


Figure 39. Location of conveyor ON/OFF button.

IMPORTANT: Verify conveyor direction is correct.

— If conveyor is running backwards, incoming power is wired out of phase. DISCONNECT POWER AND AIR, then refer to **Correcting Phase Polarity** on **Page 28** to correct wiring before continuing test run.

11. Press pre-mill motor ON/OFF button (see **Figure 40**); button will illuminate and motor will turn ***ON***. Motor should run smoothly without any unusual problems or noises. Press button again; button will darken and motor will turn ***OFF***.

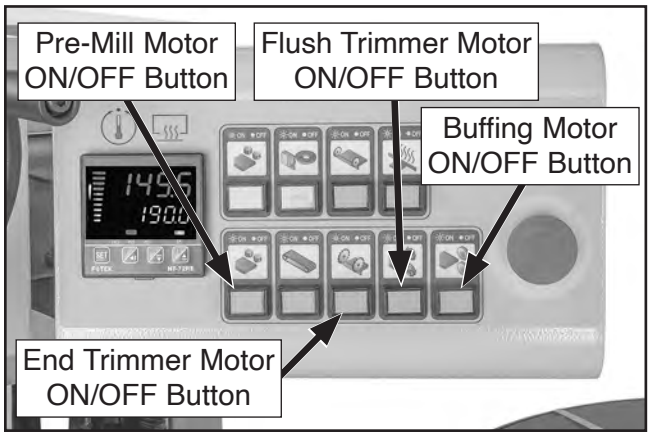


Figure 40. Location of pre-mill, end trimmer, flush trimmer, and buffing motor ON/OFF buttons.

12. Repeat **Step 11** for end trimmer, flush trimmer, and buffing motors.

13. Press all upper and lower ON/OFF buttons (see **Figure 41**) to turn pre-heating block and all sensors and motors ***ON***.

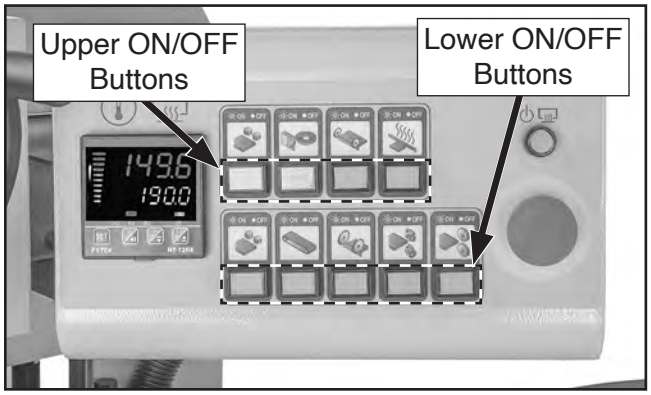


Figure 41. Upper and lower ON/OFF buttons.

14. Press control panel Emergency Stop button (see **Figure 42**). Pre-heating block and all sensors and motors should turn ***OFF***, and all buttons should darken.

Note: *Thermoregulator display will remain illuminated and glue pot will remain* ***ON****.*

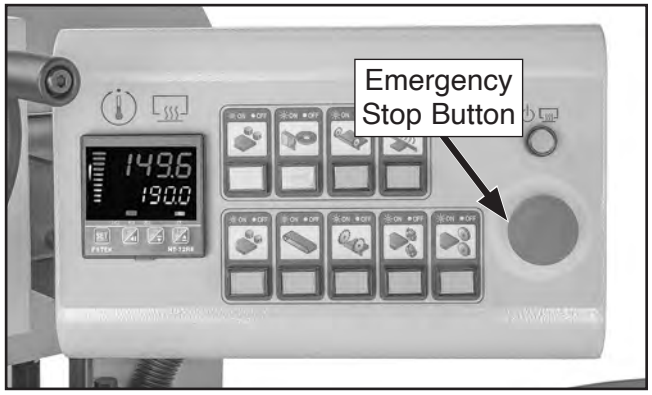


Figure 42. Location of control panel Emergency Stop button.

15. WITHOUT resetting Emergency Stop button, try starting machine by pressing each ON/OFF button on control panel. Buttons should not illuminate, sensors should not turn ***ON***, and motors should not start.

— If buttons *do not* illuminate, sensors *do not* turn ***ON***, and motors *do not* start, Emergency Stop safety feature is working correctly. Proceed to **Step 16**.

— If buttons *do* illuminate, sensors *do* turn ***ON***, and motors *do* start, Emergency Stop safety feature is not working correctly and must be replaced before beginning normal operations.

16. Reset Emergency Stop button, then press all upper and lower ON/OFF buttons to turn pre-heating block and all sensors and motors ***ON***.

17. Press outfeed EMERGENCY STOP button (see **Figure 43**). Pre-heating block and all sensors and motors should turn ***OFF***, and all buttons should darken.

Note: *Thermoregulator display will remain illuminated and glue pot will remain* ***ON****.*

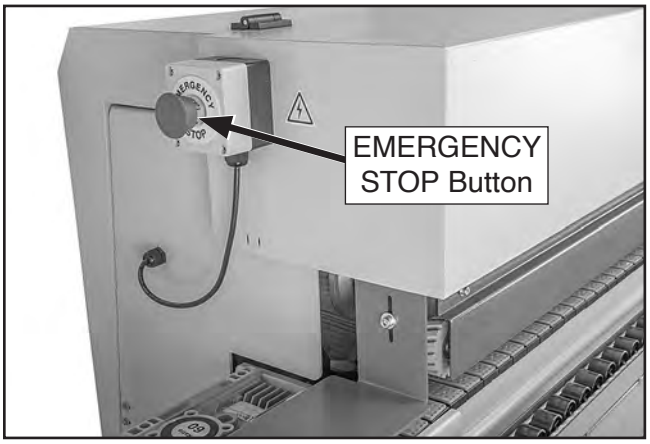


Figure 43. Location of outfeed EMERGENCY STOP button.

18. WITHOUT resetting EMERGENCY STOP button, try starting machine by pressing each ON/OFF button on control panel. Buttons should not illuminate, sensors should not turn ***ON***, and motors should not start.

— If buttons *do not* illuminate, sensors *do not* turn ***ON***, and motors *do not* start, EMERGENCY STOP safety feature is working correctly. Proceed to **Step 19**.

— If buttons *do* illuminate, sensors *do* turn ***ON***, and motors *do* start, EMERGENCY STOP safety feature is not working correctly and must be replaced before beginning normal operations.

19. Reset EMERGENCY STOP button, then press all upper and lower ON/OFF buttons to turn pre-heating block and all sensors and motors ***ON***.

20. Open rear maintenance door (see **Figure 44**). Pre-heating block and all sensors and motors should turn ***OFF***, and all buttons should darken.

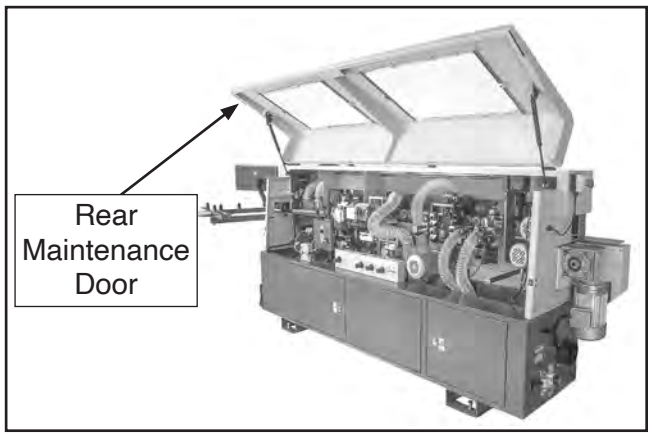


Figure 44. Rear maintenance door open.

21. WITHOUT closing rear maintenance door, try starting machine by pressing each ON/OFF button on control panel. Buttons should not illuminate, sensors should not turn ***ON***, and motors should not start.

— If buttons *do not* illuminate, sensors *do not* turn ***ON***, and motors *do not* start, maintenance door safety switch is working correctly. Congratulations! Test run is complete.

— If buttons *do* illuminate, sensors *do* turn ***ON***, and motors *do* start, maintenance door safety switch is not working correctly and must be replaced before beginning normal operations.

NOTICE

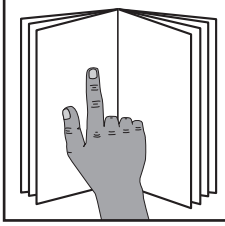
If either Emergency Stop button or rear maintenance door safety switch are not working correctly, DO NOT use machine! These safety features must work properly before proceeding with normal operations. Call Tech Support for help.

SECTION 4: OPERATIONS

Operation Overview

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

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

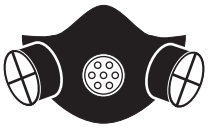


⚠WARNING

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

⚠WARNING

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



NOTICE

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

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

1. Examines workpiece to make sure it is suitable for edgebanding.
2. Checks to make sure there is enough glue in glue pot.
3. Connects machine to air and power, verifies air pressure regulator is set to 100 PSI, then turns main power ***ON***.
4. Sets glue temperature according to glue manufacturer's instructions.
5. Puts on personal safety equipment.
6. Installs correct size edgebanding coil.
7. Adjusts glue flow, flush trimmers, scrapers, pre-mill fence, and panel feeder height according to edgebanding and workpiece thicknesses.

   Note: *When using wood veneer edgebanding, or when workpiece surfaces are textured, it may be necessary to adjust or disengage scrapers (see **Adjusting Scrapers** on **Page 41**).*
8. Verifies glue pot is at operating temperature, then activates pneumatic sensors.
9. Starts dust collection system, then turns panel feeder, end trimmer, flush trimmer, and buffing motors ***ON***.
10. Places workpiece against pre-mill fence, and slides it under panel feeder, allowing panel feeder to take control of workpiece.

    Note: Use scrap workpiece to verify all adjustments are correct and finished workpiece is satisfactory before beginning normal operation.
11. Receives edgebanded workpiece at outfeed end of machine.
12. When finished, stops machine, turns it ***OFF***, and disconnects it from air and power.

Workpiece Inspection

- **Scrape all glue off the workpiece before edgebanding.** Glue deposits on the workpiece, hard or soft, will gum up the cutterheads and produce poor results.

- **Remove foreign objects from the workpiece.** Make sure that any workpiece you process with the edgebander is clean and free of dirt, nails, staples, tiny rocks, or any other foreign objects that could damage the cutterheads.

  IMPORTANT: Wood stacked on a concrete or dirt surface can have small pieces of concrete or stone pressed into the surface.

- **Make sure workpiece is sufficiently dried before edgebanding.** Wood with a moisture content over 20% will cause unnecessary wear on the cutterheads, produce poor cutting results, and insufficient glue adhesion. Excess moisture can also hasten rust and corrosion.

Edgebanding Tips

When determining the size of your workpiece, you need to account for two key factors:

- **Material removed during pre-milling.** This process removes material from each edge to remove imperfections in the workpiece face.

- **Thickness of edgebanding.** This adds material to the edges and affects the finished dimensions.

Other considerations for edgebanding:

- **Number of edges.** Decide which edges need edgebanding. For example, for shelving, you may only need to apply edgebanding to one long and two short edges.

- **Forward-facing edges.** Prioritize which edges are most visible. For instance, if the long edge faces forward, apply edgebanding to the short ends first. This ensures the joints are less visible from the front.

Machine Startup

Before turning the main power switch ***ON*** and beginning operation, open the rear maintenance door and panel feeder to visually inspect the machine for debris and glue that could have built up. Ensure all rollers, cutting tracers, and other surfaces are clean to help ensure free and smooth travel of moving parts and overall quality.

Air

Clean, dry air with consistent pressure is essential for smooth movement of the cutting assemblies. Always ensure machine is connected to an air supply capable of delivering at least 100 PSI consistently, and the machine air regulator is correctly adjusted.

Main Power

When the main power switch is turned ***ON***, power is applied to the main control panel and glue pot heating controls. The temperature display will illuminate and the glue pot will begin heating until the operating temperature is reached. Once the temperature is within 10° C of the operating temperature, the glue spindle power will turn ON.

Standby Mode

Standby mode is activated when the machine has been sitting idle, with the main power switch ***ON***, for 30 minutes. If any motor has been powered ***ON***, standby mode is activated after sitting idle for 20 minutes.

When machine enters standby mode, the power lamp will illuminate and the glue pot temperature will decrease by 40° C. To remove machine from standby mode, simply press any motor ON button. The power lamp will turn ***OFF*** and the glue temperature will increase until it reaches the set operating temperature. The glue spindle will not operate until operating temperature has been reached.

Glue Pot Temperature

Power to the glue pot is present when the main power switch is turned ***ON***. The glue pot temperature then can be adjusted, according to the glue manufacturer's recommendation, by using the buttons below the digital display. Refer to **Figure 45** to locate and understand the buttons and indicators of the glue pot thermoregulator.

Note: *The glue pot is at operating temperature when the current temperature is within 10° C of the set temperature, at which point the glue spindle will begin to rotate.*

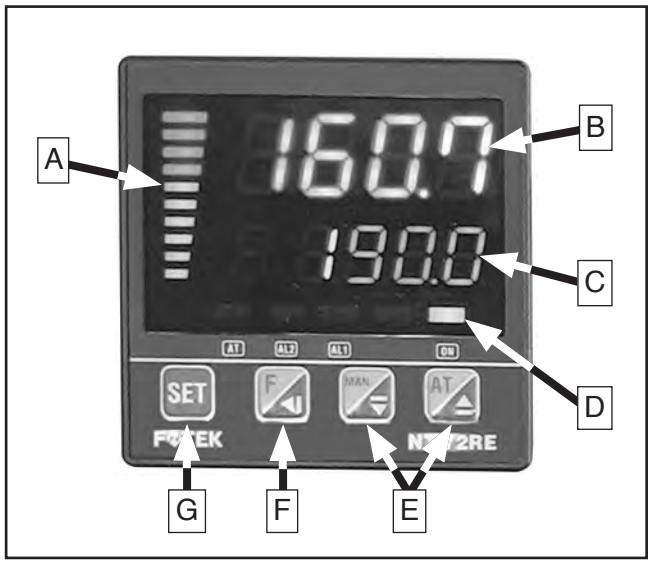


Figure 45. Thermoregulator controls.

A. Heat Output Level: Indicates percentage level of glue pot heating output.

B. Current Temperature: Indicates current temperature of glue pot.

C. Set Temperature: Indicates temperature controller is set to (operating temperature).

D. Cycle *ON* Indicator Light: Illuminates when when glue pot is actively heating.

E. Cycle Up/Down Buttons: Press once, when control panel is in edit mode, to increase/decrease flashing digit by one; press again until desired number is reached.

F. Cycle Left Button: Press once, when control panel is in edit mode, to cycle cursor left one digit; press again until desired digit begins to flash.

G. SET Button: Press once to enter edit mode; set temperature (C) digit will begin to flash. Press again to return to normal operating mode. Long press (4–5 seconds) to show numerical percentage value of heat output level. Long press again to return to normal operating mode.

⚠WARNING

Do not adjust glue pot temperature higher than glue manufacturer's recommendation. Setting temperature too high may create flammable vapors that could ignite.

To set glue pot temperature:

1. Turn main power switch ***ON***.
2. Press 'SET' button on control panel (see **Figure 45**). Lower (green) digits will begin to flash.

NOTICE

Only press 'SET' button briefly (no more than 1 second). If button is held for 3 seconds or more, thermoregulator will enter setup mode. If setup mode is accidentally entered, briefly press 'SET' button to exit.

3. Press left arrow button to cycle left until appropriate digit is flashing, then press up or down button to adjust to desired setting.
4. When finished, press 'SET' button to return to normal operating mode.

Checking/Adding Glue

The G0985 uses a glue pot system that melts glue pellets and dispenses the melted glue using a spindle.

We recommend only using EVA (Ethylene Vinyl Acetate) glue pellets in this machine. EVA adhesive can be re-melted, which makes it easy to refill and/or clean the glue pot. EVA works well as a multi-purpose glue melt for most edgebanding operations.

Avoid using PUR (Polyurethane) adhesive in this machine. PUR adhesive hardens when cured and cannot be re-melted, which makes cleaning the glue pot and spindle much more difficult.

Always follow the glue manufacturer's recommendation for setting the proper glue pot (working) temperature.

Note: *This procedure is best performed after glue pot has reached operating temperature.*

Always check the glue level before starting the edgebander and periodically during operations. The glue pot is full when the melted glue reaches ¾" (2cm) below the top of the pot. DO NOT overfill the glue pot.

Note: *For instructions on removing and changing glue, refer to* ***Removing/Changing Glue*** *on* ***Page 59****.*

Items Needed	**Qty**
Glue Pellets	As Needed

⚠CAUTION

This procedure requires user to work near parts that are hot. To reduce risk of burns, use extreme caution and wear leather gloves while performing this procedure.

To check/add glue:

1. Press Emergency Stop button.

2. Open rear maintenance door and remove glue pot lid (see **Figure 46**). Determine if pot needs glue pellets.

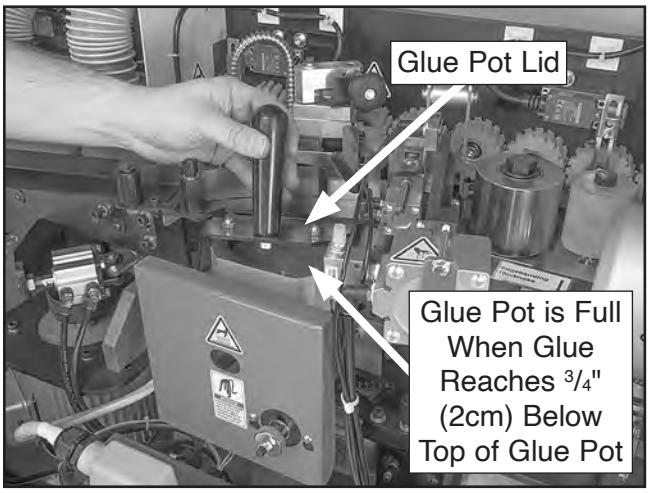


Figure 46. Checking glue level in glue pot.

3. Carefully add glue pellets until glue reaches ¾" (2cm) below top of glue pot, then close glue pot lid and close rear access cover.

   Tip: *Add small amounts of glue pellets frequently for better melting consistency.*

Adjusting Glue Spindle Position

The glue pot must be adjusted all the way forward to ensure glue spindle is in the correct position before operation, and all the way back for glue pot removal and replacement.

Adjusting Glue Spindle Position

To adjust the glue pot position, rotate glue pot adjustment knob (see **Figure 47**) all the way *counterclockwise* for machine operation; rotate all the way *clockwise* for glue pot removal/replacement.

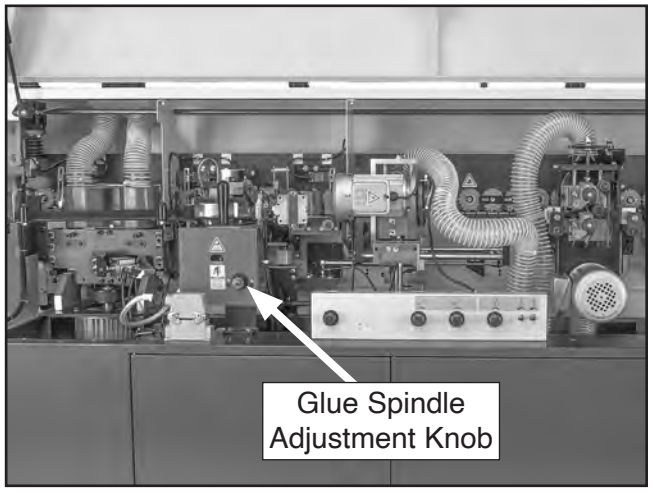


Figure 47. Location of glue spindle adjustment knob.

Adjusting Guide Plate

The glue spindle draws melted glue up from the glue pot and applies it to the workpiece edge just before the edgebanding is applied.

Pre-set at the factory, the guide plate keeps the workpiece the proper distance from the glue spindle to help control the amount of glue that is applied.

Items Needed	Qty
Workpiece at Least 27" Long	1
Hex Wrench 3mm	1
Feeler Gauge 0.5mm	1
Work Gloves	1 Pair

⚠CAUTION

This procedure must be done while the machine is connected to power and air, and while glue pot is very hot. Use extreme caution while making this adjustment to avoid burns or getting caught in moving parts.

To adjust guide plate:

1. Press Emergency Stop button.
2. Make sure glue pot has sufficient amount of glue (see **Page 36**) and is at operating temperature.
3. Set pre-mill fence to 0.
4. Adjust pressure rollers to edgebanding thickness (see **Step 4** of **Installing Edgebanding Coil** on **Page 39**).

5. Ensure spindle is all the way forward by turning glue spindle adjustment knob *counterclockwise* until it stops (see **Figure 48**).

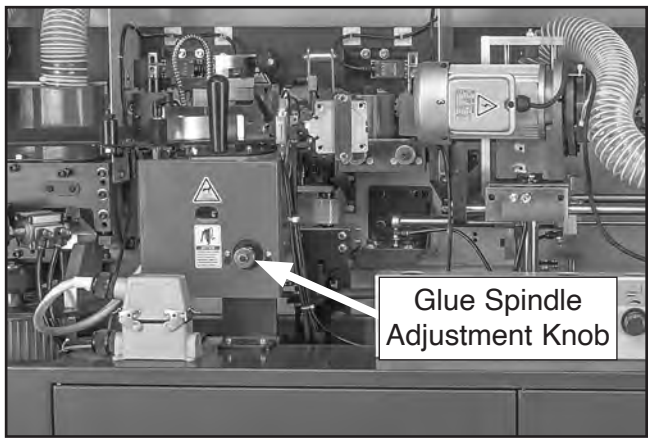


Figure 48. Location of glue spindle adjustment knob.

6. Fully raise panel feeder, then place straight edge of workpiece against infeed fence.

7. While maintaining inward pressure and keeping workpiece flat against infeed fence, slide workpiece across guide plate and over glue spindle (see **Figure 49**).

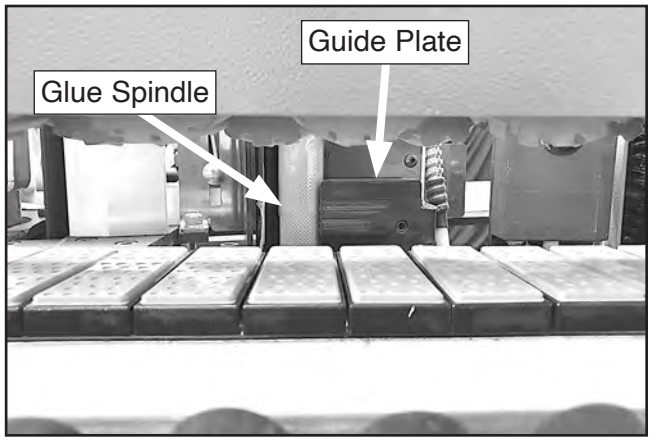


Figure 49. Location of glue spindle and guide plate.

— If workpiece edge *is* approximately 0.5mm away from glue spindle, no adjustments are necessary.

— If workpiece *is more than* 0.5mm away or touches glue spindle, the guide plate is not properly adjusted. Proceed to **Step 8.**

⚠CAUTION

Guide plate and spindle are very hot. To reduce risk of burns, wear work gloves and use extreme caution while performing the next step.

8. Turn set screw located in face of guide plate to adjust depth (see **Figure 50**).

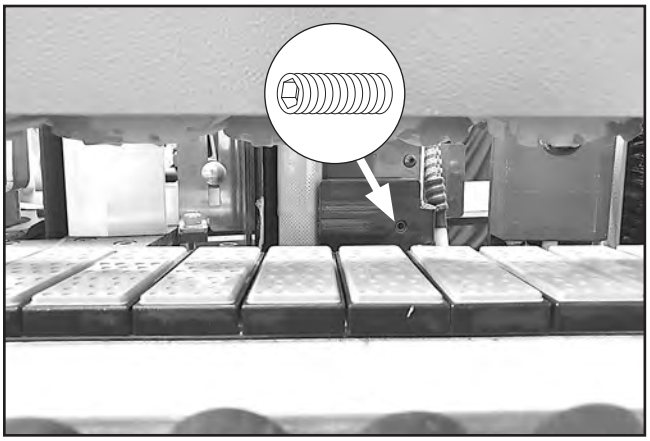


Figure 50. Location of guide plate set screw.

— Rotate set screw *clockwise* to move workpiece away from glue spindle.

— Rotate set screw *counterclockwise* to move workpiece toward glue spindle.

9. Repeat **Steps 7–8** until workpiece is approximately 0.5mm away from glue spindle.

Note: *When guide plate is properly adjusted, workpiece will pull glue off without touching spindle.*

Adjusting Glue Flow

Correctly adjusting the glue flow is essential in solid edgebanding adhesion and minimizes residual glue, preventing build-up on trimmer and buffing wheels. If the edgebanding is not adhering properly to the workpiece, or if there is excess glue residue on the finished workpiece, the glue flow may need to be adjusted.

⚠CAUTION

This procedure must be done while machine is connected to power and air, and while glue pot is hot. Use extreme caution while making this adjustment to avoid burns or getting caught in moving parts.

To adjust glue flow:

1. Press Emergency Stop button.

2. Open rear maintenance door.

3. Rotate glue flow adjustment knob *counterclockwise* to increase glue flow; rotate *clockwise* to decrease glue flow (see **Figure 51**).

   Note: *Make adjustments only ½ of a full turn at a time.*

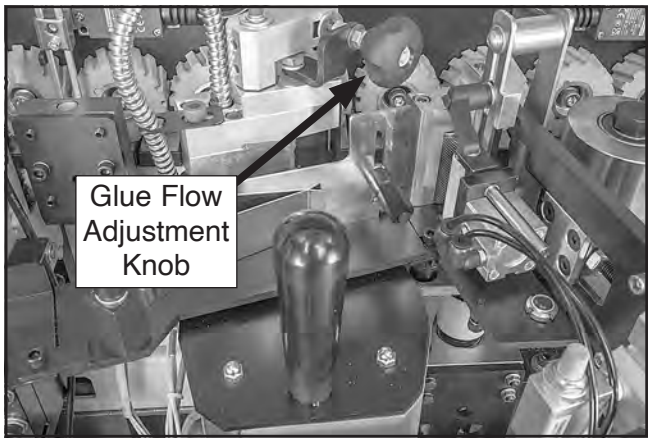


Figure 51. Location of glue flow adjustment knob.

Installing Edgebanding Coil

The Model G0985 uses edgebanding tape thickness from 0.5–3mm, in plastic or wood veneer that is automatically fed into the edgebander and glued to the workpiece edge during the edgebanding process.

For best results, the edgebanding *width* should be slightly greater than the workpiece thickness. The excess edgebanding is trimmed flush with the workpiece during operations.

The edgebanding *thickness* affects machine setup. It is important to follow these steps all the way through to ensure the edgebander is set up properly.

To install edgebanding coil:

1. Open rear maintenance door.

2. If necessary, loosen guide rollers on coil support (see **Figure 52**) and move them to allow room for edgebanding coil.

3. Center edgebanding coil on coil support, move (4) inside guide rollers so they just touch coil, then tighten to secure (see **Figure 52**), ensuring edgebanding coil can rotate freely.

4. Rotate coil support so outside guide roller directs edgebanding along a relatively straight path into feed guide as it is pulled from coil (see **Figure 52**).

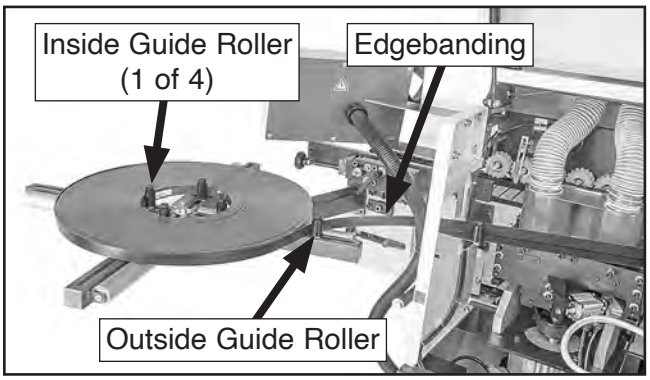


Figure 52. Location of edgebanding roll guide rollers.

5. Cut 4½" piece from end of edgebanding coil and insert behind pressure roller adjustment knobs (A), then tighten knobs so they are snug against edgebanding, as shown in **Figure 53**.

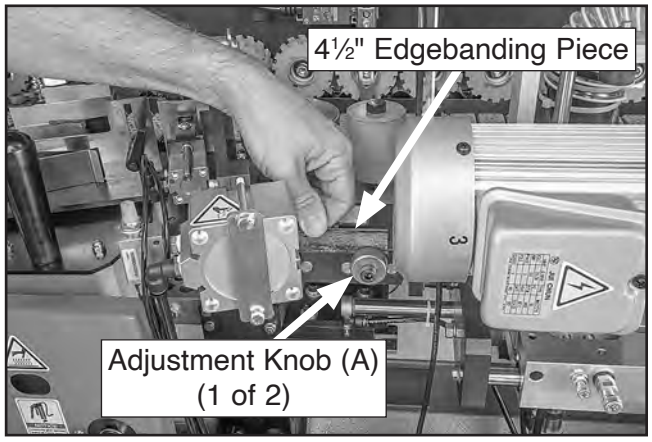


Figure 53. Installing edgebanding into pressure roller adjustment knobs.

IMPORTANT: Since edgebanding thickness may vary slightly from different manufacturers, always use a piece of edgebanding that is being installed, and not a pre-made gauge or edgebanding tape from a different coil.

6. Loosen edgebanding height adjustment lock handle (see **Figure 54**), raise handle above edgebanding tape, then tighten to secure.

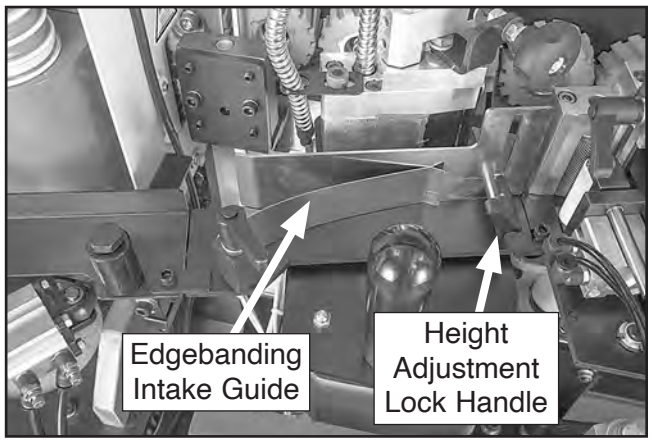


Figure 54. Location of edgebanding intake guide and height adjustment lock handle.

7. Insert end of edgebanding tape through intake guide and under height adjustment lock handle.

8. Lower adjustment handle to just above edgebanding, then tighten lock handle to secure.

Note: *Ensure edgebanding tape can move back and forth smoothly, without binding on adjustment bolt. Adjust height adjustment handle until there is minimal up-and-down movement, and allows smooth advancement.*

9. Advance edgebanding until end is just beyond guillotine (see **Figure 55**).

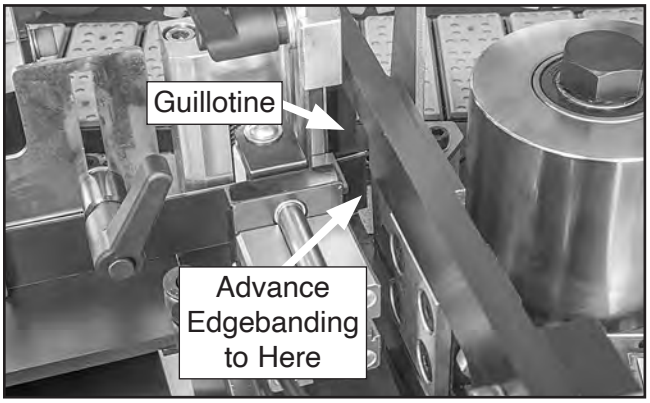


Figure 55. Edgebanding advanced to just beyond guillotine.

10. Rotate both flush trimmer (B) and both scraper (C) adjustment knobs to match edgebanding thickness.

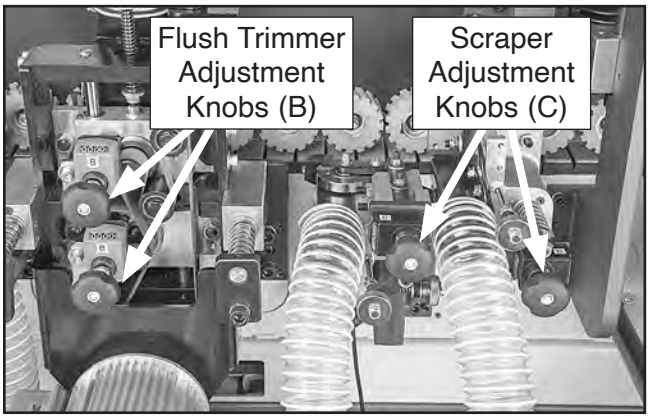


Figure 56. Location of flush trimmer and scraper adjustment knobs.

Note: *To remove gear backlash when adjusting to a smaller number, always rotate further than necessary, then adjust back up to desired measurement.*

11. Close rear maintenance door.

Adjusting Flush Trimmers & Scrapers

The flush trimmers trim excess edgebanding tape flush with the workpiece surfaces. The upper and lower cutterhead assemblies work independently and follow each surface using tracer wheels.

The scrapers precisely trim the edgebanding tape to leave a slight chamfer and a smooth finish. The upper and lower scraper assemblies also work independently and follow the workpiece surface using tracer wheels.

The upper and lower flush trimmers and scrapers are typically adjusted to the thickness of the edgebanding being used. However, it may be necessary to fine-tune or disengage the scrapers when using wood veneer edgebanding tape or when using a workpiece with a textured surface.

The dial indicator displays the current position of the cutterhead in millimeters (see **Figure 57**). The divider line represents a decimal point.

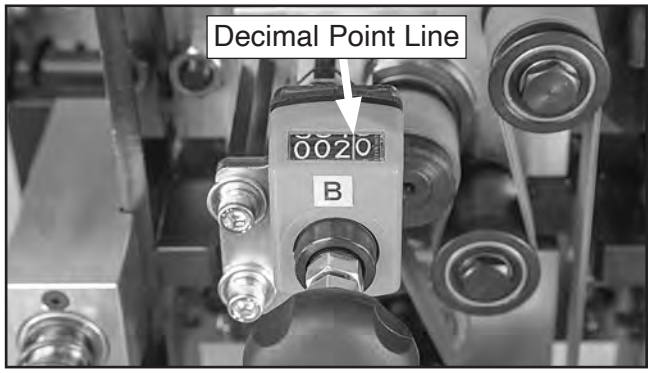


Figure 57. Flush trimmer dial indicator set to 2mm.

NOTICE

Flush trimmers and scrapers must be adjusted each time edgebanding tape is installed. Improperly adjusted flush trimmers and scrapers may damage workpiece surface.

Note: *To remove gear backlash when adjusting to a smaller number, always rotate further than necessary, then adjust back up to desired measurement.*

Adjusting Flush Trimmers

Adjust each flush trimmer by rotating the adjustment knob (see **Figure 58**) until the dial indicator reads the same measurement as the thickness of the edgebanding currently installed.

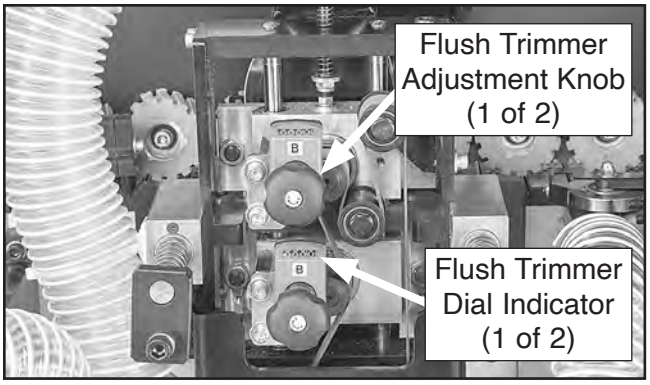


Figure 58. Location of flush trimmer adjustment controls.

Adjusting Scrapers

Similar to adjusting the flush trimmers, adjust each scraper by rotating the adjustment knobs (C) (see **Figure 59**) until the dial indicator reads the same measurement as the thickness of the edgebanding currently installed.

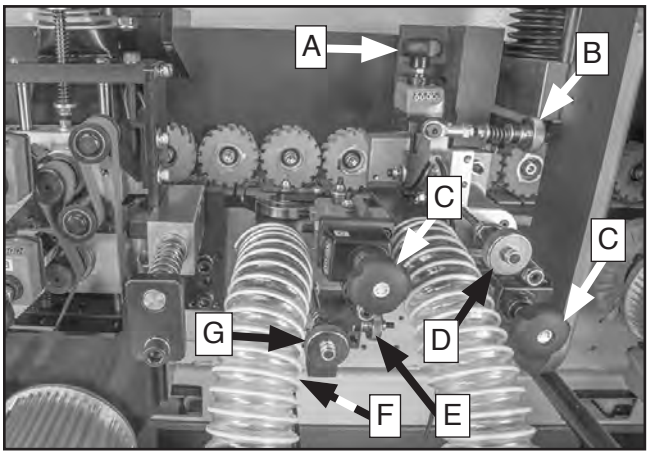


Figure 59. Location of scraper adjustment controls.

A. Upper Scraper Height Adjustment Knob
B. Upper Scraper Height Micro-Adjustment Knob
C. Scraper Adjustment Knobs
D. Upper Scraper Micro-Adjustment Knob
E. Lower Scraper Height Micro-Adjustment Knob
F. Lower Scraper Height Adjustment Knob
G. Upper Scraper Micro-Adjustment Knob

The upper scraper adjustment knobs do not normally need to be adjusted when using a smooth workpiece. However, when the workpiece has a textured surface, it may be necessary to raise the scraper slightly.

Fine Tuning Scrapers

Under normal circumstances, the scrapers should be adjusted to the thickness of the edgebanding being used. However, if the desired edge should be slightly more square, rotate each micro-adjustment knob *clockwise* to back the scraper away from the workpiece. Use trial-and-error to find the best settings for your desired results.

IMPORTANT: When making upper or lower scraper height adjustments, first loosen scraper lock nut (see **Figure 60**). Tighten lock nut after adjustments have been made.

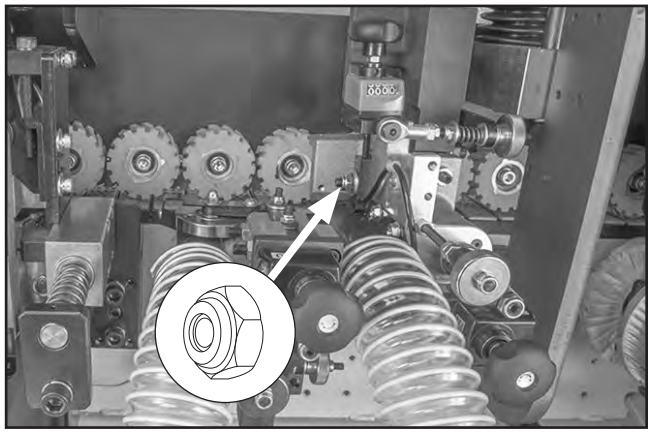


Figure 60. Location of scraper lock nut.

Disengaging Scrapers

When using wood veneer edgebanding tape, it may be necessary to disengage the scrapers to avoid a damaged edge. Simply pull back on the adjustment knob and rotate the micro-adjustment knob *clockwise* several turns (see **Figure 61**) to hold the scraper assembly away from the passing workpiece.

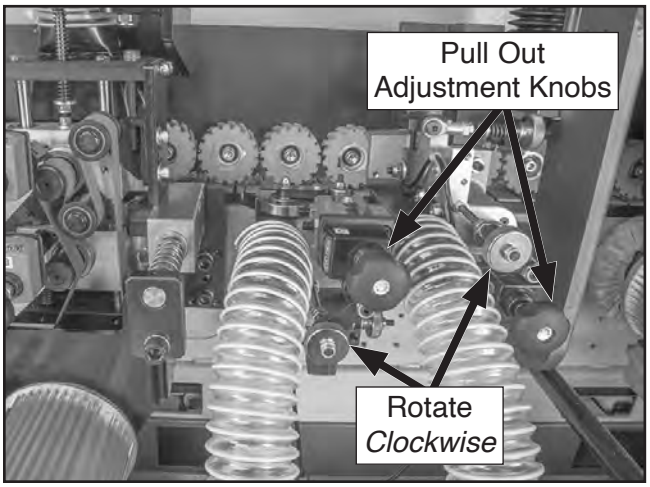


Figure 61. Disengaging scrapers.

Adjusting Pre-Mill Fence

The Model G0985 is equipped with a pre-milling function designed to remove surface chips and ensure a clean, square surface for optimal adhesion of the edgebanding tape. This process is crucial for achieving high-quality results in edgebanding applications.

During operation, the workpiece passes over two counter-rotating cutterheads situated within the pre-milling assembly, capable of removing between 0–1.5mm of material from the workpiece edge, depending on the requirements.

To address the common issue of tearout, the cutterhead assembly rotates slightly as the workpiece passes through the pre-milling station. Changing the position of the cutterheads to cut against the workpiece at both ends effectively minimizes tearout and improves overall finish quality.

The depth of cut is controlled by adjusting the pre-mill fence. The divider line represents a decimal point (see **Figure 62**).

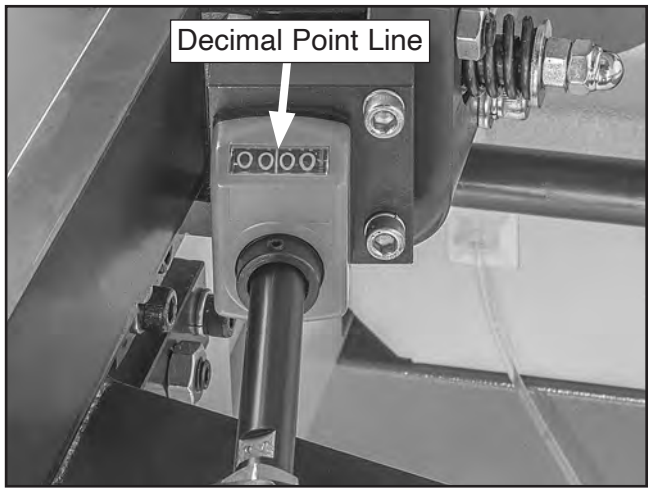


Figure 62. Pre-mill fence dial indicator.

To adjust pre-mill fence:

1. Loosen fence adjustment lock handle one full turn (see **Figure 63**).

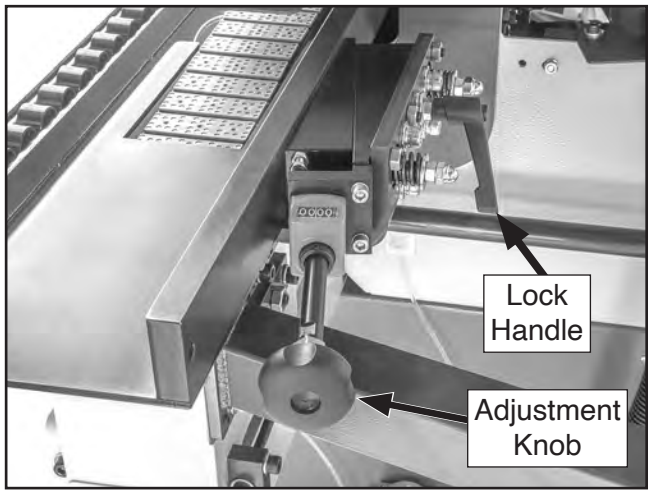


Figure 63. Location of pre-mill fence controls.

2. Rotate fence adjustment knob to desired pre-mill amount.

3. Tighten fence adjustment lock handle.

   Note: *When increasing depth-of-cut, rotate knob above desired measurement, then return to desired measurement to remove backlash.*

Adjusting Panel Feeder

The Model G0985 panel feeder advances the workpiece through the edgebanding process and will adjust to accommodate workpiece thicknesses from ½"–1¾". Adjust the panel feeder by rotating the handwheel until the height indicator (see **Figure 64**) matches the workpiece thickness in millimeters. The yellow divider line represents a decimal point.

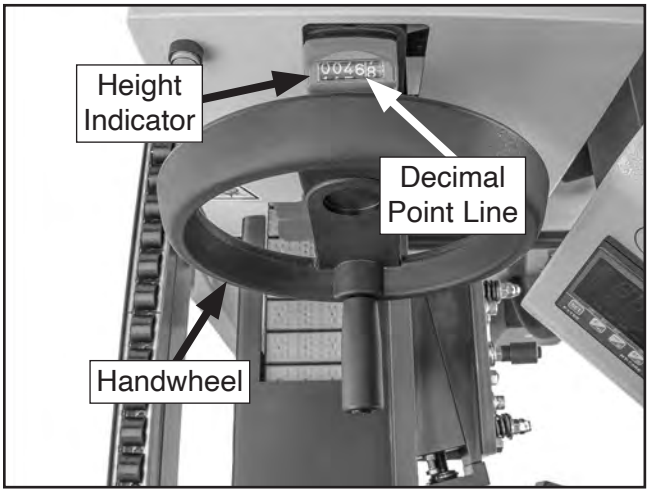


Figure 64. Panel feeder height handwheel.

To adjust panel feeder:

1. Measure workpiece thickness in millimeters.

2. Rotate panel feeder height handwheel to match workpiece thickness.

   Note: *To remove gear backlash when lowering panel feeder, always lower further than necessary, then raise back up to desired measurement.*

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.

Edgebanding

H9847—⅞" x 250' White Melamine
H9857—⅞" x 250' Maple Veneer
H9858—⅞" x 250' Red Oak Veneer
H9866—2" x 50' Pine Veneer

T27707—Edgebanding Glue Pellets, 44 lb.
We have combined the newest hot-melt technology with special additives to create low-density glue pellets with the highest possible bonding strength. This provides greater efficiency, higher productivity, and practically invisible glue lines! Great for PVC, ABS, veneer, solid wood, melamine, and polyester. These pellets come in a 44 lb. bag.

Figure 65. T27707 Edgebanding Glue Pellets.

T33302—30:1 Infrared/Contact Temp Gun
With stunning readability indoor and outdoor, this infrared temperature gun provides easier reading for professional, residential, and industrial users in any environment. Take measurements between -40°–1472° F from up to 30-feet away.

Figure 66. T33302 30:1 Infrared/Contact Temp Gun.

Lubrication

T26685—Moly-D Multi-Function Machine Oil
T26419—Syn-O-Gen Synthetic Grease
T34295—Type 200 Fluid Silicone Oil 1000 cSt

Figure 67. Recommended products for machine lubrication.

Replacement Flush Trimmer Blades

T28529—Upper Blades, Pack of 4
T28530—Lower Blades, Pack of 4
Keep your flush trimmer moving fast and smooth! These replacement blades are the perfect fit for the cutterheads on the Model G0985.

Figure 68. T28529 Upper Replacement Flush Trimmer Blades.

G0825—Portable Edgebander w/Case & Kit
Easily apply edgebanding from ⅜" to 2½" wide along straight runs, around bends, and inside corners! This machine combines the great features of a stationary edgebanding machine (hot melt glue application, speed feeding, and temperature control) with the convenience and portability of a handheld tool. Comes with a deluxe hard case with extension handle and roller wheels.

Figure 69. G0825 Portable Edgebander w/Case & Kit.

T1189—Dual End Cutter for G0825
The dual-support design of this cutter means greater stability for straight edgebanding seams. Cutter features line compensation adjustment for precise end seams, and the frame body pivots for sharp corner-cut alignment.

Figure 70. T1189 Dual End Cutter for G0825.

T1187—Stationary Work Table for G0825
Enjoy the benefits of a stationary edgebanding machine with the added convenience of the portable edgebander. Simply attach the Model G0825 edgebander to the table and accurately run straight or curved pieces. Includes built-in on/off button and magnetic switch.
Table size: 31½"W x 17"D x 11½"H.

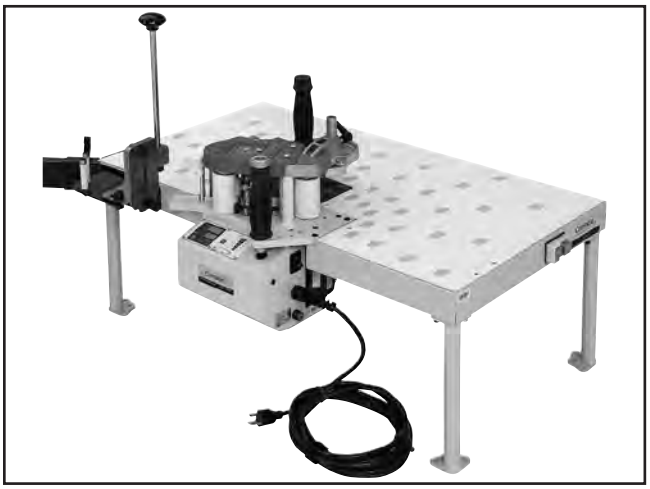
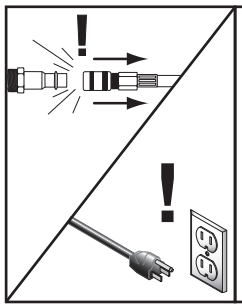


Figure 71. T1187 Stationary Work Table for G0825.

SECTION 6: MAINTENANCE



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from air and 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 bolts and fasteners.
- Worn or damaged wires.
- Any other unsafe condition.

Daily
- Remove sawdust and debris using soft brush and vacuum.
- Clean scraper chip bin.
- Lubricate conveyor (**Page 47**).
- Clean/lubricate end trimmer slides (**Page 47**).
- Clean/lubricate flush trimmer slides (**Page 48**).
- Check for dull or damaged end trimmer saw blades (**Page 63**).
- Check for dull or damaged flush trimmer inserts (**Page 69**).

Weekly
- Drain water in air filter/regulator collection cup.
- Lubricate glue spindle (**Page 48**).

Monthly
- Belt tension, damage, or wear (**Page 65**).
- Lubricate edgebanding advancement gears, chain, and sprocket (**Page 48**).

Cleaning & Protecting

Cleaning the Model G0985 daily is extremely important and is the first step in keeping your machine functioning properly, and is relatively easy. Open the rear maintenance door and use a vacuum and soft brush to clean sawdust and debris away from the cutters and slides, then wipe down the tracers, stationary pressure roller, and trimmer slides with a soft cloth and light spray lubricant.

Scraper Chip Bin

The scraper chip bin (see **Figure 72**) collects the excess banding that is removed by the scrapers. Empty the chip bin daily to avoid clogging the internal ducting. Under heavy use, periodically check the chip bin and empty as necessary.

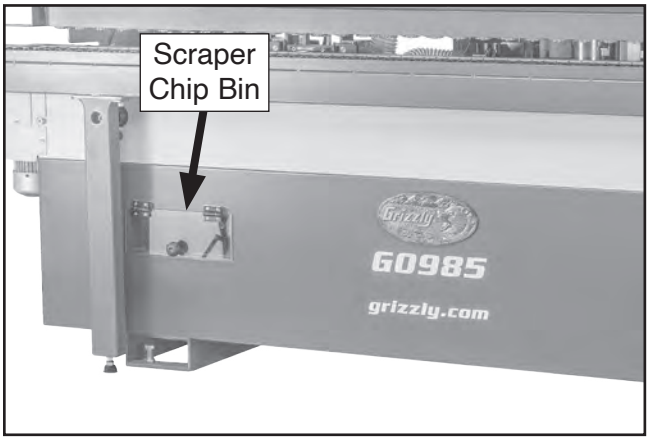


Figure 72. Location of scraper chip bin.

Lubrication

The Model G0985 relies on each assembly to be able to move freely to function properly. Ensuring the components are clean and lubricated is essential to keeping your machine operating correctly to produce a high quality edgebanding finish.

NOTICE

Recommended lubrication is based on light-to-medium usage. Keeping in mind that proper lubrication helps protect the value and operation of the machine, these lubrication tasks may need to be performed more frequently than recommended here, depending on usage. Failure to follow reasonable lubrication practices could lead to premature failure of machine components and will void the warranty.

Conveyor (One-Shot Oiler)

Lube Type.....T34295
Lube Amount.....1 Full Pull
Lube Frequency..... Daily

To lubricate the conveyor, with the conveyor motor running, pull the one-shot oiler handle (see **Figure 73**) slowly and steadily all the way down. Pull slowly enough that the entire pull takes about 20 seconds. Use the sight glass on the front of the oiler to know when to refill.

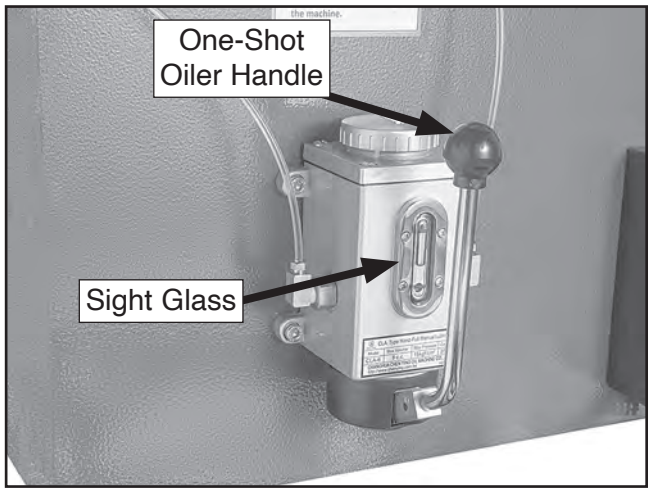


Figure 73. Location of one-shot oiler handle and sight glass.

End Trimmer Slides

Lube Type.....T26685 or ISO 32 Equivalent
Lube Amount..... As Needed
Lube Frequency..... Daily

To lubricate the end trimmer slides, open the rear maintenance door to access the slides (see **Figure 74**). Wipe the slides clean with a rag, then apply a light film of machine oil to the sliders. Manually move motor back and forth and up and down to evenly distribute the oil along the slides.

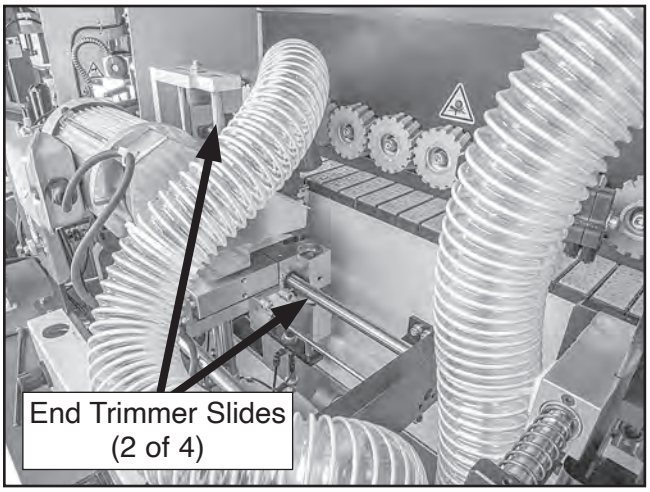


Figure 74. Location of end trimmer slides.

Glue Spindle

Lube Type..... T26419 or NLGI#2 Equivalent
Lube Amount ..... 1–2 Pumps
Lube Frequency..... 30 Hours of Use

To lubricate glue spindle:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Add 1–2 pumps of lubricant to glue spindle grease fitting (see **Figure 75**).

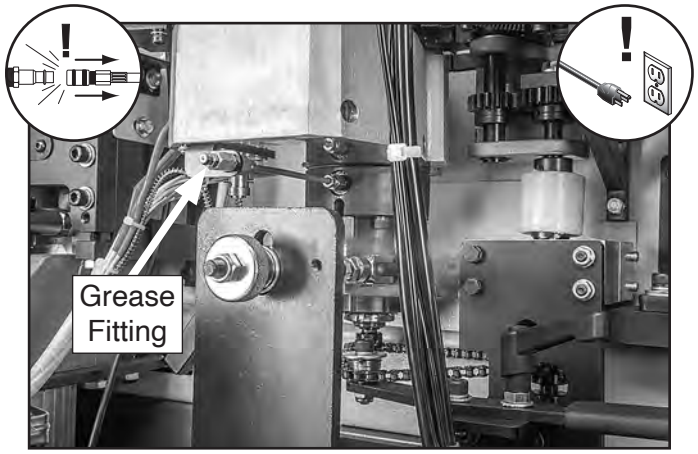


Figure 75. Location of glue spindle grease fitting (shield removed for clarity).

Flush Trimmer Slides

Lube Type.....T26685 or ISO 32 Equivalent
Lube Amount ..... As Needed
Lube Frequency..... Daily

To lubricate the flush trimmer slides, use a clean, lint-free cloth, and a small oil can or other means to add a couple of drops of machine oil to the slides (see **Figure 76**). Lubricate both top and bottom of each slide.

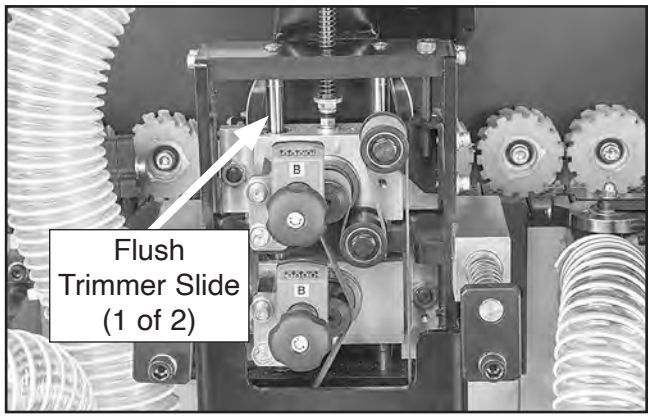


Figure 76. Location of flush trimmer slides.

Edgebanding Advancement Gears, Chain, and Sprocket

Lube Type..... T26419 or NLGI#2 Equivalent
Lube Amount ..... As Needed
Lube Frequency.....Monthly

To lubricate edgebanding advancement gears, chain, and sprocket:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Use a stiff wire brush to remove built-up grease and grime.

3. Add 1–2 pumps of lubricant to advancement gears, chain, and sprocket (see **Figure 77**).

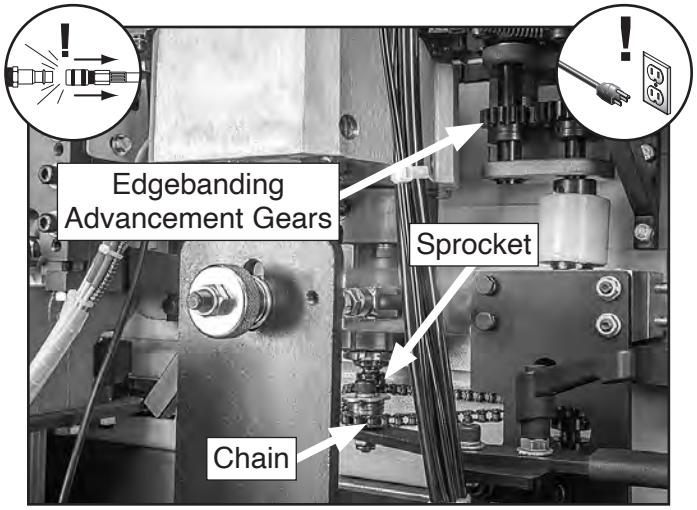
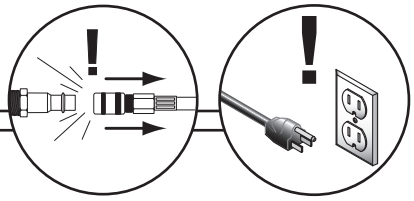


Figure 77. Location of edgebanding advancement gears, chain, and sprocket.

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, one or more motors do not start, or a breaker trips after startup.	1. Emergency Stop button(s) depressed. 2. Main power switch ***OFF***. 3. Rear maintenance door left open. 4. Plug/receptacle at fault/wired wrong. 5. Power supply circuit breaker tripped/fuse blown. 6. Incorrect power supply voltage/circuit size. 7. Inadequate air pressure. 8. Glue pot has not reached operating temperature. 9. Glue pot not heating. 10. Motor protector tripped (QM1–QM6). 11. Motor wires connected incorrectly. 12. Wiring open/has high resistance. 13. Motor(s) at fault.	1. Rotate Emergency Stop button(s) to reset. 2. Turn switch ***ON***. 3. Close rear maintenance door. 4. Test for good contacts; correct wiring. 5. Ensure circuit is sized correctly and free of shorts; reset circuit breaker/replace fuse. 6. Ensure correct power supply voltage/circuit size (**Page 16**). 7. Ensure incoming air pressure is at least 6 SCFM @ 100 PSI; adjust air pressure regulator to 100 PSI. 8. Allow glue pot to reach set operating temperature (**Page 35**). 9. Inspect/replace fuse FU5, verify contactor KM5 connections are secure/test all legs for power; replace contactor if at fault (**Page 81**). 10. Reset motor protector by pressing black ON button. 11. Correct motor wiring connections (**Page 79**). 12. Check/fix broken, disconnected, or corroded wires. 13. Verify all connections are secure; replace if at fault.
Machine stalls or is underpowered.	1. Motor(s) overheated. 2. Belt(s) slipping; oil/grease on belt(s). 3. Motor(s) wired incorrectly. 4. Plug/receptacle at fault. 5. Conveyor chain slipping. 6. Pulley/sprocket slipping on shaft. 7. Motor bearings at fault.	1. Allow motor(s) to cool; reset motor protector by pressing black ON button if necessary. 2. Clean/tension/replace belt(s). 3. Wire motor(s) correctly (**Page 79**). 4. Test for good contacts/correct wiring; replace if at fault. 5. Properly tension conveyor chain (**Page 54**). 6. Replace loose pulley/shaft. 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Motor & Electrical (Cont.)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component loose.	1. Inspect/replace damaged bolts/nuts, and retighten with thread locking fluid.
	2. Belt(s) worn or loose.	2. Inspect/tension/replace belts.
	3. Buffing wheel(s) incorrectly mounted or at fault.	3. Inspect buffing wheels; replace if at fault (**Page 72**).
	4. Conveyor chain not properly tensioned.	4. Properly tension conveyor chain (**Page 54**).
	5. Debris caught in motor fan cover.	5. Clean debris from fan cover.
	6. Motor fan rubbing on fan cover.	6. Fix/replace fan cover; replace loose/damaged fan.
	7. Pulley loose/damaged.	7. Re-align pulleys/replace shaft, pulley set screw, and key.
	8. Flush trimmer inserts dull/worn.	8. Sharpen/replace cutterhead inserts (**Page 69**).
	9. End trimmer blades dull/incorrectly mounted.	9. Inspect/sharpen/re-install/replace blades (**Page 63**).
	10. Spindle/arbor bearings at fault.	10. Test by rotating spindle/arbor; rotational grinding/loose shaft requires bearing replacement.
	11. Motor shaft bent.	11. Test with dial indicator and replace motor.
	12. Motor bearings at fault.	12. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Glue Spindle

Symptom	Possible Cause	Possible Solution
Glue spindle does not rotate.	1. Motor does not run.	1. Refer to **Motor & Electrical** table on **Page 49**.
	2. Glue pot has not reached operating temperature.	2. Allow glue pot to reach set operating temperature (**Page 35**).
	3. Chain not tensioned properly.	3. Properly tension chain (**Page 61**).
	4. Too much grease added to glue spindle.	4. Remove pressure-relief screw.
	5. Gear connection shaft stripped/broken.	5. Inspect/replace gear connection shaft.
	6. Gear connection shaft stuck.	6. Adjust motor reducer connection plate.
Glue spindle does not dispense enough glue.	1. Glue flow not adjusted properly.	1. Adjust glue flow (**Page 39**).
	2. Glue not fully melted, temperature setting too low.	2. Adjust glue pot temperature according to glue manufacturer's directions; confirm glue temperature using laser thermometer.
	3. Guide plate not adjusted properly.	3. Adjust guide plate (**Page 37**).
	4. Glue not fully melted/heater rod(s) at fault.	4. Verify heater rod connections are secure; replace if at fault.
	5. Debris in glue spindle.	5. Clean debris from glue spindle.
	6. Glue pot thermometer not accurate.	6. Inspect thermocouple connections and wires for damage/wear; repair/replace if at fault.
Glue not fully melted in glue pot.	1. Glue pot has not reached operating temperature.	1. Allow glue pot to reach set operating temperature (**Page 35**).
	2. Glue pot temperature is set too low.	2. Adjust glue pot temperature according to glue manufacturer's directions; confirm glue temperature using laser thermometer.
	3. Heater rod(s) at fault.	3. Verify heater rod connections are secure; replace if at fault.

Glue Spindle (Cont.)

Symptom	Possible Cause	Possible Solution
Glue only adheres to lower portion of workpiece edge.	1. Panel feeder not exerting enough downward force on workpiece. 2. Panel edge not cut 90°. 3. Glue flow not adjusted properly. 4. Guide plate not adjusted properly. 5. Pressure rollers not making full contact with workpiece. 6. Workpiece too wide or not properly supported. 7. Pre-mill cutterheads not adjusted to 90°.	1. Adjust panel feeder (**Page 43**). 2. Adjust pre-mill to square edge of panel (**Page 42**). 3. Adjust glue flow (**Page 39**). 4. Adjust guide plate (**Page 37**). 5. Ensure pressure rollers are adjusted by inserting edgebanding behind adjustment knobs (**Page 39**). 6. Pull out table extension/use additional support such as roller stands. 7. Adjust pre-mill cutterheads to 90° (**Page 56**).

End Trimmer

Symptom	Possible Cause	Possible Solution
Blades do not rotate.	1. Motor does not run. 2. Glue pot has not reached operating temperature. 3. Belt damaged/broken. 4. Obstruction preventing blades from rotating.	1. Refer to **Motor & Electrical** table on **Page 49**. 2. Allow glue pot to reach set operating temperature (**Page 35**). 3. Inspect/replace belt (**Page 66**). 4. Remove obstruction.
End cut not straight/ not parallel.	1. Tracers dirty with glue residue. 2. Tracers not adjusted properly. 3. Inadequate air pressure. 4. Tracer bent.	1. Clean tracers. 2. Properly adjust tracers (**Page 62**). 3. Ensure supply air at machine regulator is at 100 PSI; adjust component air pressure (**Page 76**). 4. Replace tracer.
Chips inside of panel.	1. End trimmer brushes worn/improperly adjusted.	1. Adjust/replace brushes (**Page 78**).
Saw blades lose RPM during operation.	1. Belt loose or damaged. 2. Saw blades are dull/broken.	1. Inspect/replace belt (**Page 66**). 2. Inspect/replace saw blades (**Page 63**).
End trimmer unit fails to slide on shafts.	1. Zip-tie used to secure unit during shipping is still attached. 2. Debris build-up on slides prevent unit from sliding properly. 3. Inadequate air pressure. 4. Air lines cracked/broken.	1. Remove zip-tie securing end trimmer. 2. Clean slides (**Page 47**). 3. Ensure supply air at machine regulator is at 100 PSI; adjust component air pressure (**Page 76**). 4. Inspect air lines; replace if damaged (**Page 94**).

Flush Trimmer

Symptom	Possible Cause	Possible Solution
Cutterheads do not rotate.	1. Motor does not run. 2. Drive belt is loose or damaged.	1. Refer to **Motor & Electrical** table on **Page 49**. 2. Inspect/replace drive belt (**Page 71**).
Flush trimmer does not trim proper amount of edgebanding.	1. Flush trimmer not adjusted properly. 2. Glue residue on tracer wheel. 2. Cutterheads not properly aligned.	1. Adjust flush trimmers (**Page 41**). 2. Thoroughly clean tracer wheel. 2. Adjust cutterhead alignment (**Page 67**).
Cutterheads lose RPM during operation.	1. Drive belt is loose or damaged. 2. Cutterhead inserts are dull/broken.	1. Inspect/replace drive belt (**Page 71**). 2. Inspect/replace cutterhead inserts (**Page 69**).
Cutterheads will not adjust in or out.	1. Flush trimmer shafts dirty.	1. Clean and lubricate flush trimmer shafts to free up movement.

Buffing Unit

Symptom	Possible Cause	Possible Solution
Buffing wheel(s) do not rotate.	1. Motor(s) do not run. 2. Buffing wheel(s) not properly secured.	1. Refer to **Motor & Electrical** table on **Page 49**. 2. Tighten arbor bolt(s) (**Page 72**).
Buffing wheel(s) spread glue on workpiece.	1. Too much glue applied. 2. Wrong glue for application.	1. Adjust glue flow (**Page 39**). 2. Use appropriate glue for application (**Page 36**), refer to glue manufacturer's instructions.
Buffing wheel(s) wear away corners of workpiece/ edgebanding.	1. Buffing wheel(s) not properly adjusted.	1. Properly adjust buffing wheel(s) (**Page 72**).

Panel Feeder

Symptom	Possible Cause	Possible Solution
Conveyor belt does not move.	1. Motor does not run. 2. Conveyor chain not properly tensioned.	1. Refer to **Motor & Electrical** table on **Page 49**. 2. Properly tension conveyor chain (**Page 54**).
Workpiece feeds erratically or stops feeding during operation.	1. Panel feeder not adjusted properly. 2. Conveyor chain not properly tensioned.	1. Adjust panel feeder (**Page 43**). 2. Properly tension conveyor chain (**Page 54**).

Edgebanding Results

Symptom	Possible Cause	Possible Solution
Edgebanding at guillotine cut too short (early) or too long (late).	1. Edgebanding coil support guide rollers not properly adjusted. 2. Dust buildup on edgebanding advancement rollers. 3. Glue spindle chain not tensioned properly. 4. Inadequate air supply. 5. Guillotine limit switch not properly adjusted.	1. Properly adjust guide rollers (**Page 39**). 2. Clean advancement rollers. 3. Tension glue spindle chain (**Page 61**). 4. Ensure supply air at machine regulator is at 100 PSI; adjust component air pressure (**Page 76**). 5. Properly adjust guillotine limit switch (**Page 75**).
Too much/ not enough edgebanding left on top or bottom of workpiece.	1. Flush trimmer tracers dirty. 2. Flush trimmer not properly adjusted. 3. Flush trimmer brushes worn/improperly adjusted. 4. Scrapers not properly adjusted.	1. Clean flush trimmer tracers. 2. Properly adjust flush trimmer (**Page 67**). 3. Adjust/replace brushes (**Page 78**). 4. Properly adjust scrapers (**Page 41**).
Scrape marks on face of edgebanding.	1. Pressure rollers dirty.	1. Clean pressure rollers.
Gaps in edgebanding on finished workpiece.	1. Panel not flat against pre-mill fence when entering machine. 2. Using wrong edgebanding piece for pressure rollers. 3. Panel feeder not exerting enough downward force on workpiece. 4. Pressure rollers dirty.	1. Feed panel with edge flat against pre-mill fence. 2. Install correct edgebanding piece for pressure rollers (**Page 39**). 3. Adjust panel feeder (**Page 43**). 4. Clean pressure rollers.
Ends not cleanly cut.	1. End trimmer saw blades dull. 2. Inadequate air pressure.	1. Sharpen/replace end trimmer saw blades (**Page 63**). 2. Ensure supply air at machine regulator is at 100 PSI; adjust component air pressure (**Page 76**).
Dust/chips between edgebanding and workpiece.	1. Inadequate dust collection. 2. Pre-mill brushes worn/improperly adjusted.	1. Ensure dust collection system is properly installed and meets CFM requirement (**Page 27**). 2. Adjust/replace brushes (**Page 78**).

Checking/Adjusting Conveyor Chain Tension

Chain stretch is a natural result of regular wear and tear, which can impact the performance of the conveyor. To minimize unnecessary wear on the chain and its components, it is essential to check the tension monthly and follow the recommended lubrication schedule. Regular maintenance helps ensure the longevity and smooth operation of the conveyor system.

Checking Conveyor Chain Tension

Checking the chain tension is performed by inspection through four holes which are accessible by opening the rear maintenance door, as shown in **Figure 78**, then lifting the chain to check the tension. With moderate force, the chain should lift 2"–3" and snap back when released. If the chain is easy to lift using very little force, or falls back down rather than snapping back, adjustment is required.

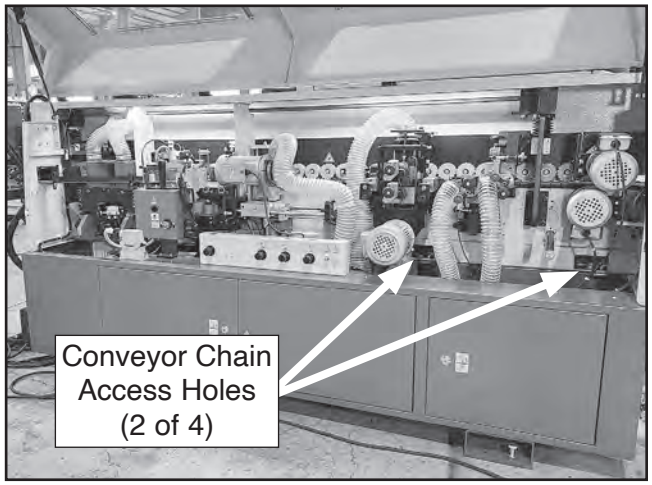


Figure 78. Location of conveyor chain access holes.

Adjusting Conveyor Chain Tension

Tools Needed	Qty
Open-End Wrench 10mm	1
Hex Wrench 6mm	1

To adjust conveyor chain tension:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Loosen both adjustment screw jam nuts (see **Figure 79**).

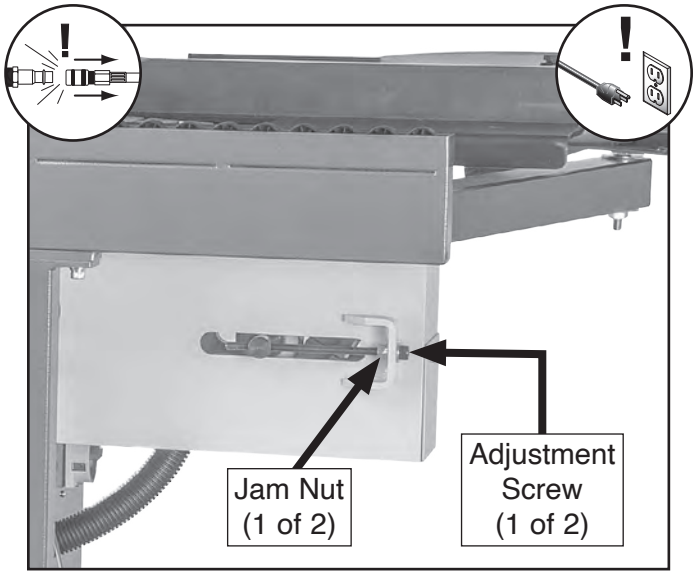


Figure 79. Location of jam nuts and adjustment screws.

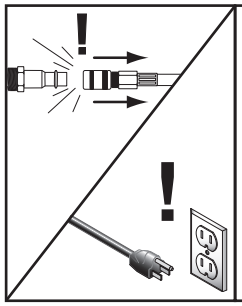
3. Rotate both adjustment screws *equally clockwise* to increase chain tension, and counterclockwise to decrease tension.

   IMPORTANT: Not rotating adjustment screws equally will cause the tension wheel to become misaligned and cause premature wear of chain.

4. Tighten both jam nuts, then turn conveyor ***ON*** and run for at least one full revolution of conveyor, then recheck tension.

5. If necessary, repeat **Steps 1–4**.

Pre-Mill



⚠WARNING

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

Adjusting Cutterhead Trim Amount

Over time, the pre-mill cutterheads may experience uneven wear, with one cutterhead potentially wearing down faster than the other. This can result in an uneven cut along the workpiece edge, where the material removed does not match the intended amount—such as when the fence is set to remove 1mm, but either the front or rear end of the workpiece has more or less than 1mm removed. In such cases, or after replacing the cutterheads, it is necessary to adjust the trim amount, which involves fine-tuning the cutterhead rotation. Proper adjustment ensures consistent cutting accuracy. Refer to **Figure 80** for location of cutterhead adjustment screws.

Items Needed	**Qty**
Open-End Wrench 10mm	1
Hex Wrench 4mm	1
Precision Ruler 12"	1
Test Workpiece at Least 4" x 8"	As Needed

To adjust cutterhead trim amount:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Loosen jam nut for appropriate adjustment screw (see **Figure 80**).

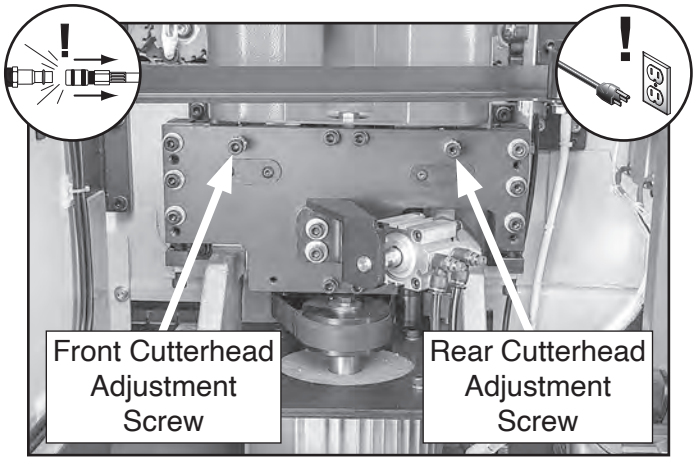


Figure 80. Location of cutterhead rotation adjustment screws.

   — Rotate adjustment screw *counterclockwise* to increase trim amount, and *clockwise* to decrease trim amount.

4. While keeping adjustment screw from moving, tighten jam nut.

5. Run test piece through machine, then measure each end to ensure trim amount is equal.

6. Repeat **Steps 1–5** as necessary.

Adjusting Cutterhead Height

During normal operation, only a limited section of the cutterheads comes into contact with the workpiece, leaving other portions of the cutterheads unused. Over time, the repeatedly used area of the cutterheads becomes dull, reducing the efficiency of the cutting process. By adjusting the cutterhead height, you can engage the sharper, unused sections of the cutterheads, thereby extending their overall lifespan and ensuring optimal cutting performance. This adjustment is crucial for maintaining the quality of your work while maximizing the utility of your cutterheads.

Items Needed	Qty
Open-End Wrench 10mm	1
Hex Wrench 4mm	1

To adjust cutterhead height:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Loosen (6) cutterhead height lock screws (see **Figure 81**).

3. Loosen (2) adjustment screw jam nuts, then rotate adjustment screws *clockwise* to raise cutterhead height, or *counterclockwise* to lower cutterhead height (see **Figure 81**).

   IMPORTANT: Rotate adjustment screws in equal amounts.

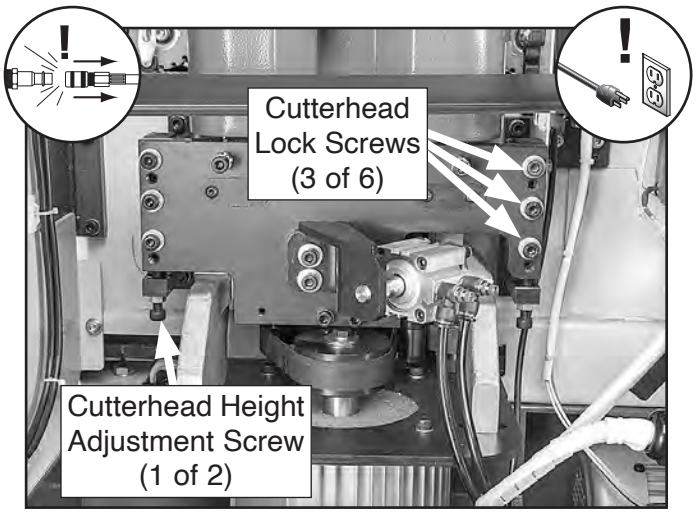


Figure 81. Location of cutterhead lock and adjustment screws.

4. While keeping adjustment screws from moving, tighten both jam nuts, then tighten (6) lock screws.

Adjusting Cutterheads to 90°

After prolonged use or following the replacement of cutterheads, the alignment of the cutterheads may deviate from a perfect 90° angle, resulting in inaccurate cuts on the workpiece. To restore precise cutting, it may be necessary to adjust the cutterheads to ensure they are positioned exactly at 90° relative to the workpiece edge. This adjustment is essential for maintaining the accuracy and quality of your work.

Items Needed	Qty
Hex Wrenches 3, 4mm	1 Ea.

To adjust cutterheads to 90°:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Loosen (6) cutterhead height lock screws (see **Figure 82**).

3. Rotate upper adjustment set screws to adjust top of cutterheads, and lower adjustment set screws to adjust bottom of cutterheads (see **Figure 82**).

   — Rotate adjustment screws *clockwise* to move toward workpiece and *counterclockwise* to move away from workpiece.

4. Tighten (6) lock screws.

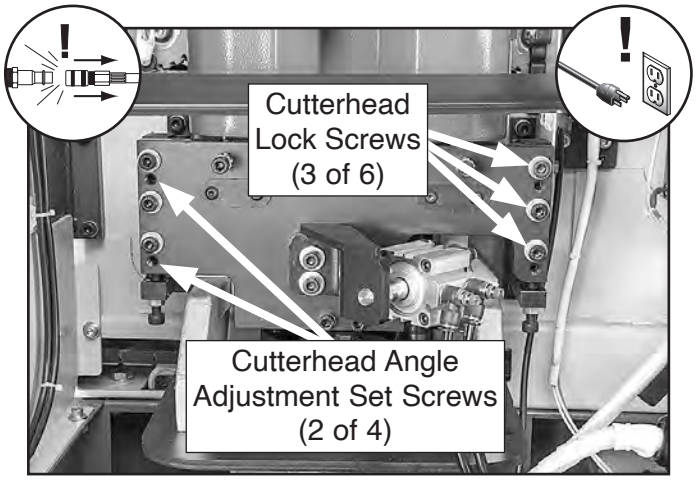


Figure 82. Location of cutterhead lock and angle adjustment screws.

Replacing Cutterheads

When the cutterheads no longer produce a quality edge, and adjustments no longer remedy the issue, the cutterheads need to be replaced.

Items Needed	Qty
Side Cutters	1
Hex Wrench T-Handle 5mm	1
Hex Wrench 8mm	1
Torque Wrench (0–30 ft. lbs.)	1
Spindle Locking Tool (P09851362)	1
Cutterhead, Front (P09851357)	1
Cutterhead, Rear (P09851358)	1
Zip Ties 18"	2
Work Gloves	1 Pr.

To replace pre-mill cutterheads:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Remove (2) dust hoses from top of cutterhead guard (see **Figure 83**).

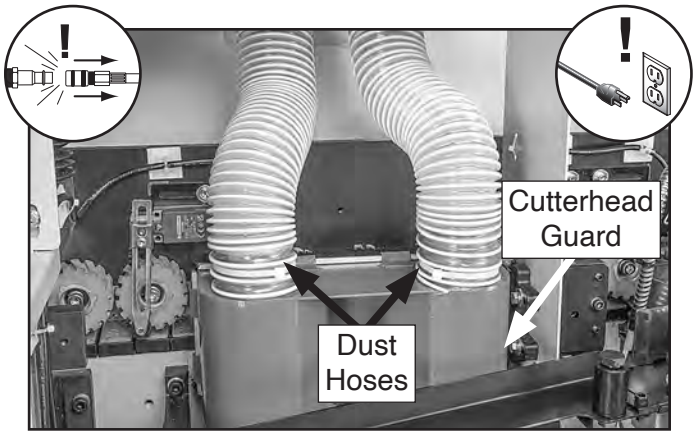


Figure 83. Location of cutterhead guard and dust hoses.

3. Remove (2) cap screws and flat washers (see **Figure 84**), then remove cutterhead guard.

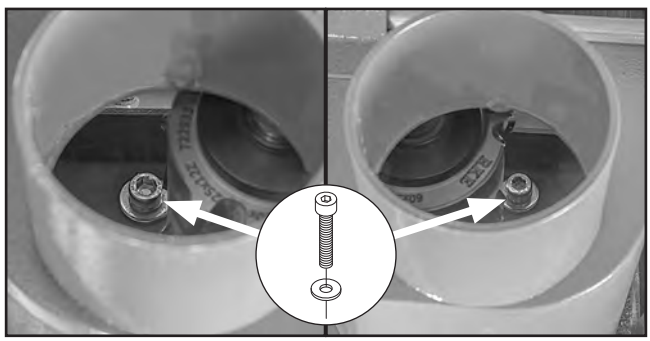


Figure 84. Location of cutterhead guard fasteners.

4. Insert spindle lock tool into spindle holes below cutterheads and remove (2) cap screws and flat washers, then remove cutterheads (see **Figure 85**).

   Tip: *Insert spindle lock tool by aligning with holes in each spindle. If they don't both align, insert tool into one, then rotate other cutterhead by hand until tool can be inserted into other hole. Thread nuts onto tool from back side. Do not tighten nuts, just thread them snug against cutterhead spindle.*

   — Front cutterhead has right-hand threads; turn *counterclockwise* to loosen.

   — Rear cutterhead has left-hand threads; turn *clockwise* to loosen.

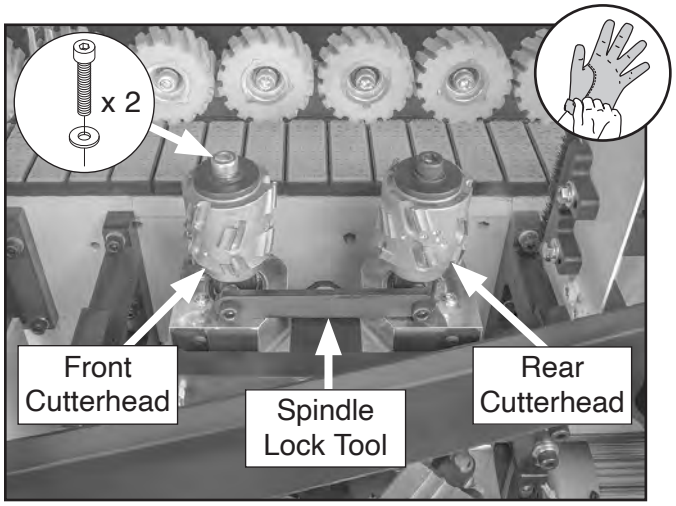


Figure 85. Cutterheads with spindle lock tool inserted.

5. Install new cutterheads, and secure with cap screws and washers removed in **Step 4**. Torque cap screw to 30 ft. lbs.

   IMPORTANT: Cutterheads are directional. Ensure each cutterhead is facing the proper direction when installing.

   — Front cutterhead blades should face *against* feed direction.

   — Rear cutterhead blades should face *with* feed direction.

6. Install cutterhead guard and secure with cap screws and washers removed in **Step 3**, then install dust hoses.

Tensioning/Replacing Drive Belt

The pre-mill motor transfers power through a serpentine drive belt, and is tensioned using an idler pulley and eccentric bolt, illustrated in **Figure 86**. If the belt becomes worn, cracked, frayed, broken, or otherwise damaged in any way, it will need to be replaced.

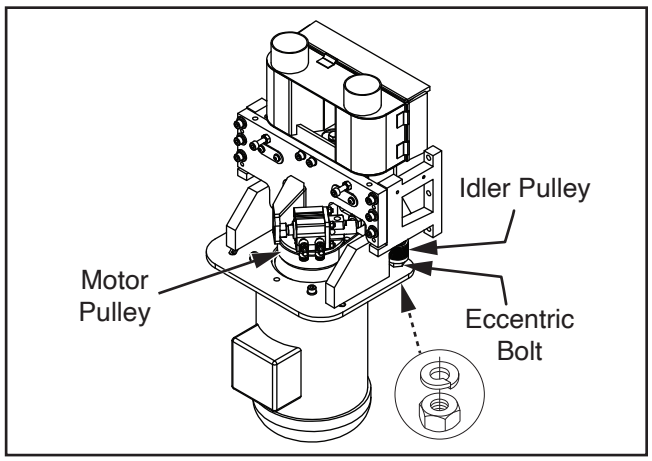


Figure 86. Pre-mill belt tensioning components.

Items Needed	Qty
Assistant	1
Open-End Wrenches 17, 21mm	1 Ea.
Drive Belt (P09851330)	1

Tensioning Drive Belt

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Press middle of pre-mill drive belt with moderate pressure. Proper tension is achieved when deflection is approximately ¼" as illustrated in **Figure 87**.

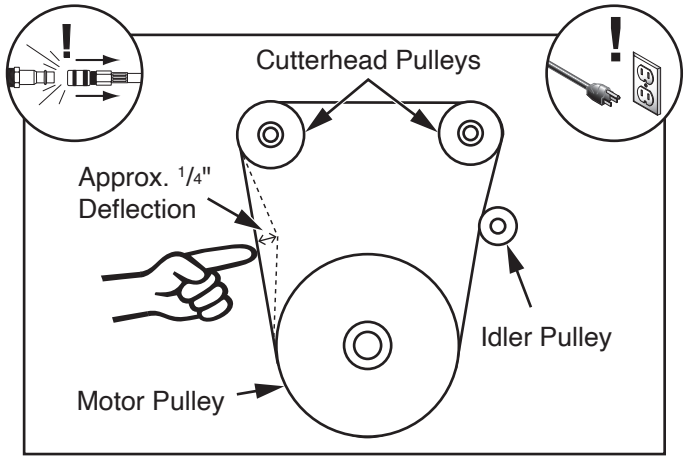


Figure 87. Pre-mill belt deflection.

— If belt deflection *is* approximately ¼", drive belt is properly tensioned. No adjustment is necessary.

— If belt deflection *is not* approximately ¼", tension must be adjusted. Proceed to **Step 4**.

4. Loosen hex nut below motor mount plate, securing idler pulley (see **Figure 88**) to release belt tension.

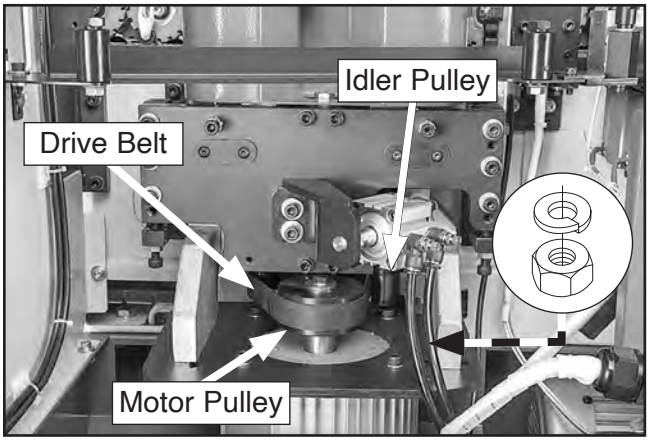


Figure 88. Location of pre-mill belt tensioning components.

Tip: *Rotate and inspect belt for signs of wear or damage.*

5. With assistant checking belt tension, rotate eccentric bolt *clockwise* until proper belt tension is achieved, then tighten hex nut.

6. Close rear maintenance door.

Replacing Drive Belt

1. Follow **Steps 1–4** of **Tensioning Drive Belt**, then remove belt.

2. Route new belt around pulleys (see **Figure 87**), then follow **Steps 5–6** of **Tensioning Drive Belt**.

Removing/Changing Glue

If your edgebanding operation requires a different type of glue, or if the glue becomes contaminated with debris, you will need to remove the old glue and replace it with new glue pellets.

IMPORTANT: Glue pot is Teflon-coated. Do not scratch surface when servicing.

Items Needed	Qty
Wood Sticks (Approximately 6" x 1" x ½")	2
Pliers	1
Glue Pellets	As Needed
Work Gloves	1 Pr.

To remove/change glue:

1. Turn main power ***OFF***, then remove glue pot lid and wait for glue pot to *completely* cool.

   Tip: *For a little extra leverage, insert one wood stick into center of hot glue and allow glue to cool around it.*

2. Turn main power ***ON*** and wait for glue pot to reach 80°–90° C.

3. Use wood stick to peel up one side of glue, as shown in **Figure 89**.

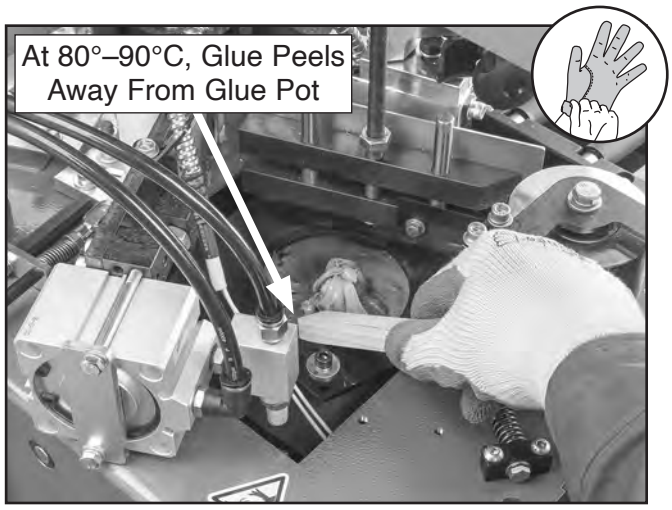


Figure 89. Example of using wood stick to peel glue away from glue pot for glue removal.

⚠CAUTION

Glue pot is very hot. To reduce risk of burns, wear work gloves and use extreme caution while performing this procedure.

4. Use pliers to grip peeled up portion of glue and pull block of glue out of glue pot (see **Figure 90**).

   IMPORTANT: Be careful not to scratch glue pot surface.

Figure 90. Example of using pliers to remove block of glue from glue pot.

5. Turn machine main power ***OFF***, and allow glue pot to completely cool.

6. Clean any remaining glue and debris from bottom and sides of glue pot.

   Tip: *As glue pot cools, scrape remaining glue from glue spindle to avoid contamination with new glue.*

7. Carefully add glue pellets until they reach ¾" (2cm) below top of glue pot.

8. Turn machine ***ON*** and allow glue pot to reach operating temperature.

9. When glue pellets are completely melted, check glue level and, if necessary, add additional glue (refer to **Checking/Adding Glue** on **Page 36**).

Removing/Installing Glue Pot

The Model G0985 is equipped with a quick-change glue pot, allowing users to switch between different types of glue without needing to thoroughly clean the glue pot each time.

⚠WARNING

To avoid risk of serious burns, allow glue pot to cool completely before performing this procedure.

Item Needed **Qty**
Quick-Change Glue Pot Assy (P09850900)..... 1

Removing Glue Pot

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Rotate glue pot adjustment knob (see **Figure 91**) all the way *clockwise* to adjust glue pot away from front of machine.

3. Disconnect quick-disconnect coupler (see **Figure 91**).

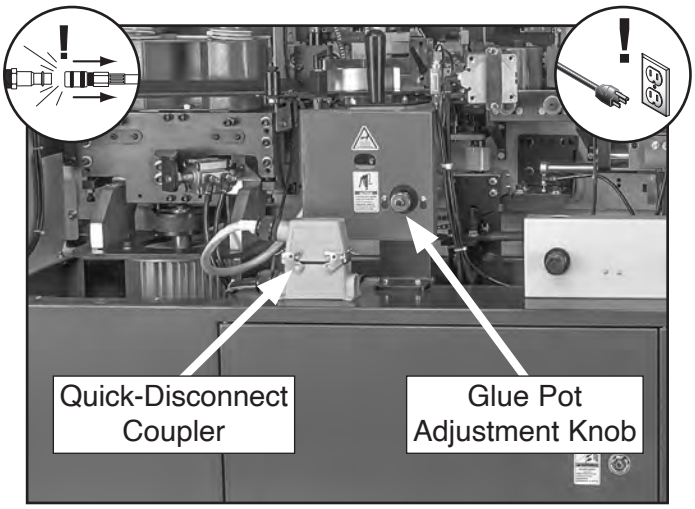


Figure 91. Location of quick-disconnect coupler.

4. Loosen (2) cap screws securing edgebanding intake guide (see **Figure 92**), then remove intake guide and glue pot lid.

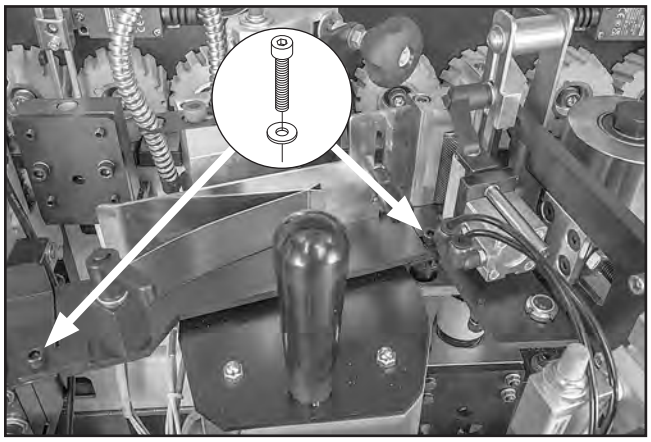


Figure 92. Location of edgebanding intake guide cap screws.

5. Loosen chain tension lock handle shown in **Figure 93**, pull tension lever out until chain is loose, then remove chain.

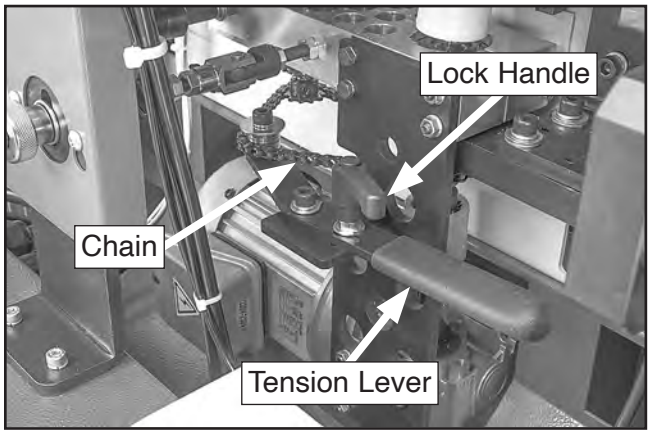


Figure 93. Location of glue pot chain tension lever and lock handle.

6. Loosen glue pot lock handle (see **Figure 94**).

Figure 94. Location of glue pot lock handle.

7. Carefully pull glue pot straight up, then remove from glue pot bracket.

   Tip: *While the glue pot and chain are removed, take advantage of the increased accessibility to other components. This is a great time to inspect, clean and lubricate other components before proceeding with reassembly.*

Installing Glue Pot

1. Install glue pot into glue pot bracket, then tighten lock handle.

   Note: *Ensure slot is aligned with alignment pin (see **Figure 95**).*

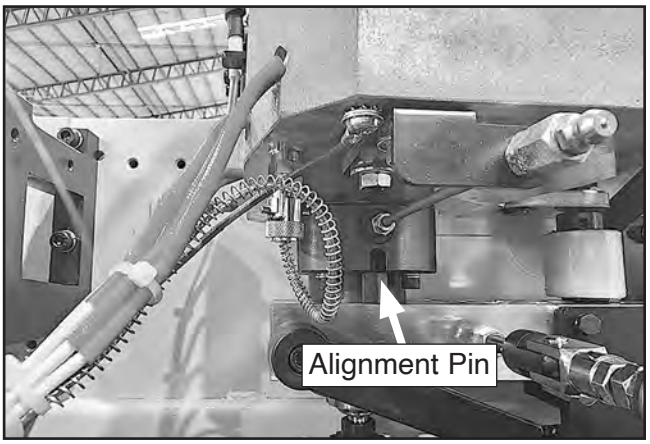


Figure 95. Location of glue pot alignment pin.

2. Install chain and push tension lever (see **Figure 96**) in to tension, then tighten tension lock handle.

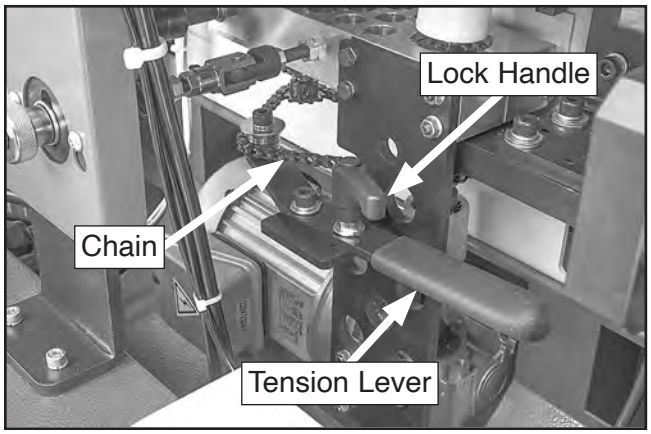


Figure 96. Location of glue pot chain tension lever and lock handle.

3. Connect quick-disconnect coupler (see **Figure 97**).

4. Rotate glue pot adjustment knob all the way *counterclockwise* to adjust glue pot to normal operating position (see **Figure 97**).

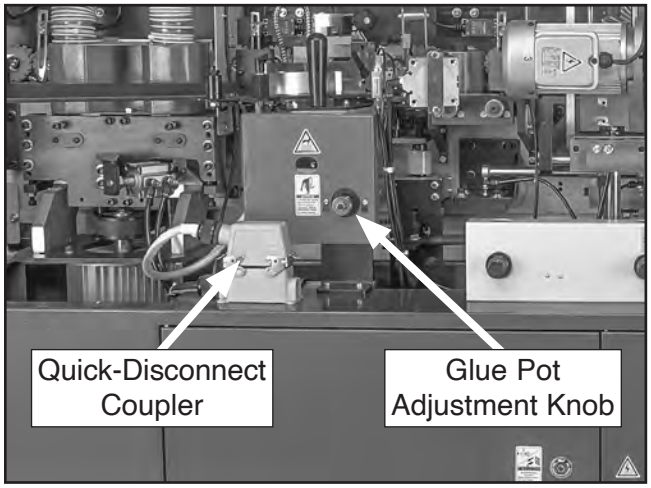


Figure 97. Location of quick-disconnect coupler and glue pot adjustment knob.

5. Follow instructions for **Checking/Adding Glue** on **Page 36**.

End Trimmers

NOTICE

Before making any adjustments, ensure all parts are clean and free of debris, glue, and residue.

Adjusting End Trimmer Tracers

The end trimmer tracers are factory set and should not require routine service. However, after prolonged use, or if the end trimmer fails to produce satisfactory results, you may need to adjust the end trimmer tracers.

Two end trimmer tracers (front and rear) orient the end trimmer blades to the workpiece in order to precisely trim the edgebanding flush with the leading and trailing ends of the workpiece (see **Figure 98**).

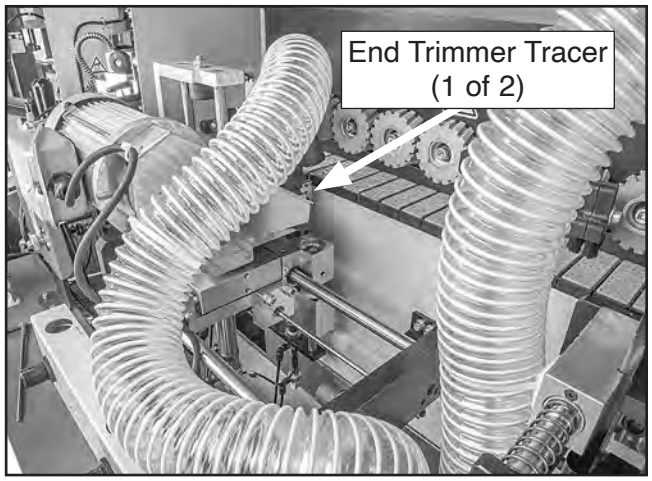


Figure 98. Location of end trimmer tracers.

When the length of the edgebanding is not cutting correctly, adjustments to the tracers may be necessary. If the leading end of the edgebanding is being cut too short or too long, the front tracer (see **Figure 99**) should be adjusted accordingly. Similarly, if the trailing end is being cut too long or too short, the rear tracer needs adjustment.

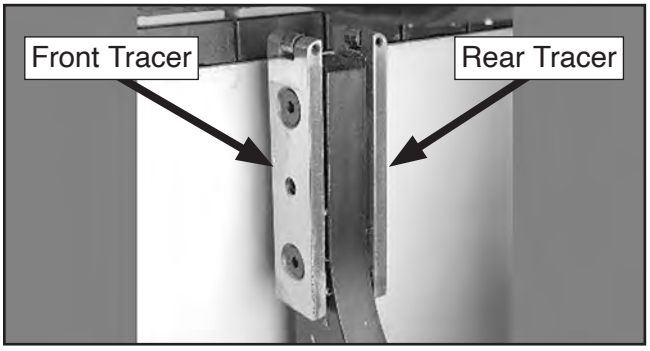


Figure 99. End trimmer tracer detail.

Items Needed	**Qty**
Hex Wrenches 2.5, 3mm	1
Test Workpiece at Least 4" x 8"	As Needed

To adjust end trimmer tracers:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Loosen set screw(s) shown in **Figure 100**, then rotate (2) adjustment screws in equal amounts to adjust tracer.

   — Rotate adjustment screws *counterclockwise* to decrease trimming amount; rotate adjustment screws *clockwise* to increase trimming amount.

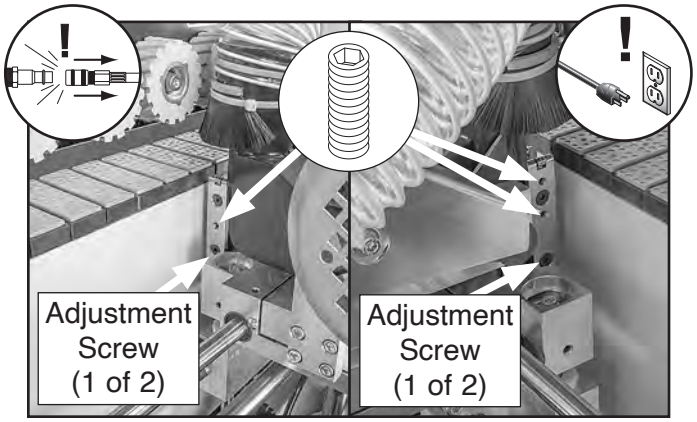


Figure 100. Location of tracer adjustment screws.

Checking/Adjusting Position Sensors

In situations where the trimming process is failing to cut through the edgebanding completely or inadvertently cutting the workpiece instead, the position sensor may require adjustment.

Items Needed	Qty
Assistant	1
Phillips Head Screwdriver #2	1

To check/adjust position sensors:

1. Press Emergency Stop button.

2. Open rear maintenance door.

3. Lift end trimmer motor all the way to top, and check upper position sensor (see **Figure 101**).

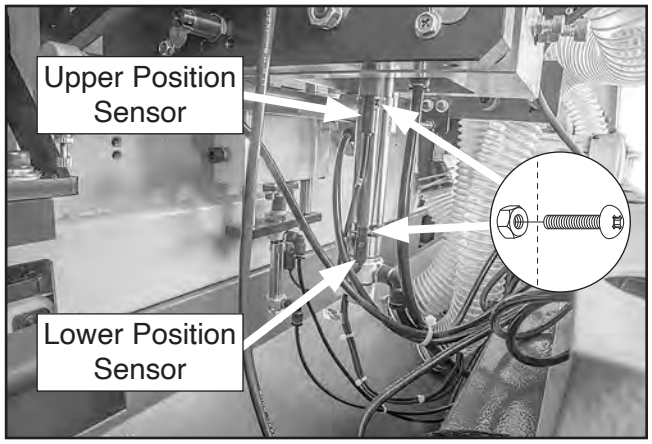


Figure 101. Location of end trimmer position sensors.

   — Upper position sensor LED should illuminate when end trimmer motor is raised all the way up.

   — Lower position sensor LED should illuminate when end trimmer motor is all the way down.

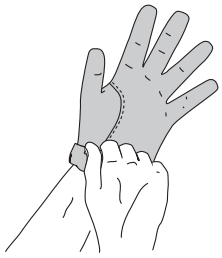
4. If necessary, loosen Phillips head screw and adjust position sensor up or down until LED illuminates.

   Tip: *Have assistant hold end trimmer motor up while adjusting position sensor.*

Replacing Blades

If, after cleaning and adjusting end trimmer tracers and sensors, the end trimmer fails to make clean, precise cuts, the blade(s) may be dull or damaged, requiring replacement.

Items Needed	Qty
Work Gloves	1 Pr.
Hex Wrenches 4, 6mm	1 Ea.
Wrench or Socket 10mm	1
Wood Block 2" x 4" x 5"	1
End Trimmer Blades (Part# P09851512)	2



⚠CAUTION

Blades are extremely sharp. Even dull blades can cause serious cuts when handled improperly. To reduce risk of injury, always wear work gloves when working around blades.

To remove blades:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Manually raise end trimmer unit and support it with wood block for best access to blades (see **Figure 102**).

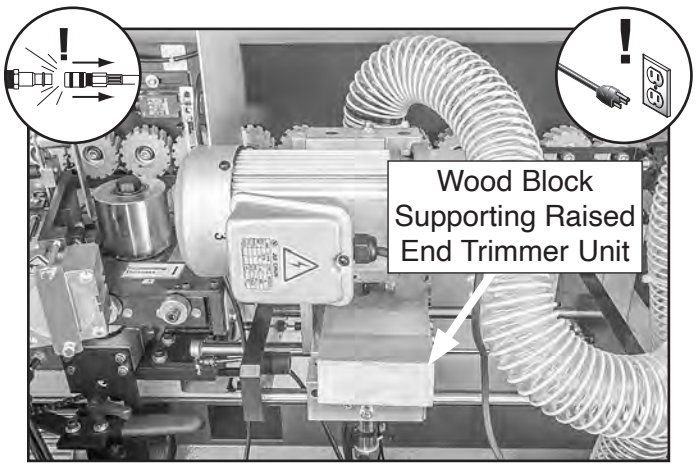


Figure 102. End trimmer unit raised and supported with wood block for access to blades.

4. Remove (2) cap screws and washer sets, then remove end trimmer dust shroud (see **Figure 103**).

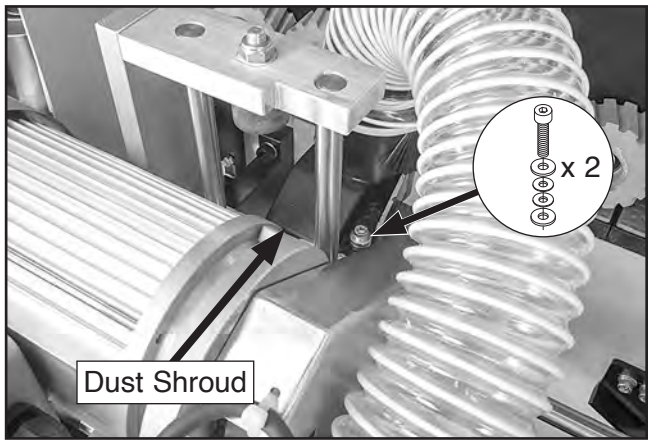


Figure 103. Location of dust shroud cap screw.

5. Use 6mm hex wrench to secure arbor pulley and 10mm wrench to remove arbor bolt and flange (see **Figure 104**), then remove outer blade.

   IMPORTANT: Do not remove arbor pulley.

   Note: *Arbor bolt has left-hand threads. Rotate bolt clockwise to loosen and counterclockwise to tighten.*

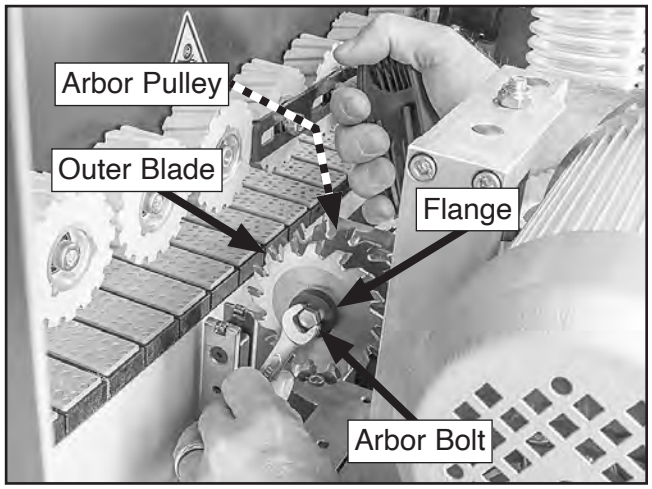


Figure 104. Loosening arbor bolt.

6. Remove spacer and inner blade (see **Figure 105**).

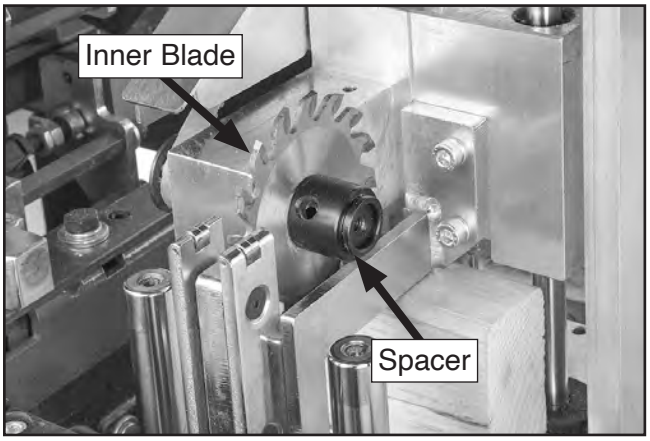


Figure 105. Location of inner trimmer blade components.

To install blades:

1. Install inner blade and spacer; rotate spacer hole to align with hole in arbor.

   Note: *Blade direction should cut in upward motion, as shown above in* ***Figure 105****.*

2. Install outer blade and flange, and secure with arbor bolt.

3. Install dust shroud and secure with cap screws and washer sets removed in **Step 4** of **Removing Blades**.

NOTICE

Before tightening dust shroud cap screws, use belt to rotate blades to ensure they do not contact dust shroud. Check again after fully tightened.

4. Close rear maintenance door.

Adjusting Drive Belt Tension

The end trimmer motor transfers power through a cogged drive belt. The belt should be periodically checked for proper tension and, if necessary, replaced.

Items Needed	Qty
Hex Wrench T-Handle 4mm	1
Hex Wrench 5mm	1

To adjust drive belt tension:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Follow **Steps 3–4** of **To remove blades:** on **Page 63** to remove dust shroud.

4. Remove (2) M5-.8 x 12 cap screws with flat washers from end trimmer belt cover, then remove cover (see **Figure 106**).

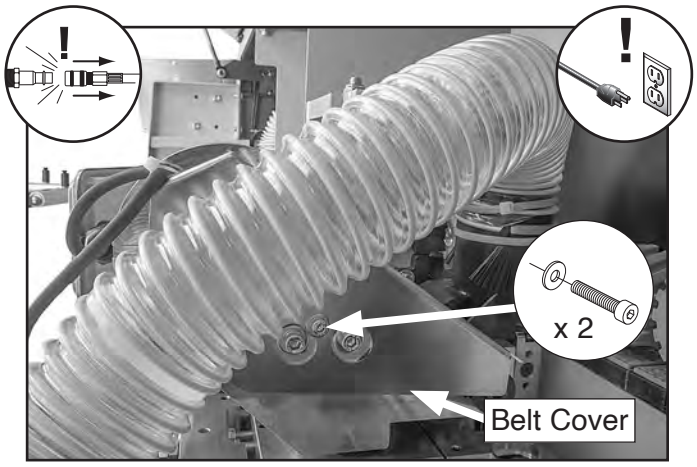


Figure 106. Location of belt cover cap screws.

5. Press middle of flush trimmer drive belt with moderate pressure. Proper tension is achieved when deflection is approximately ¼" as illustrated in **Figure 107**.

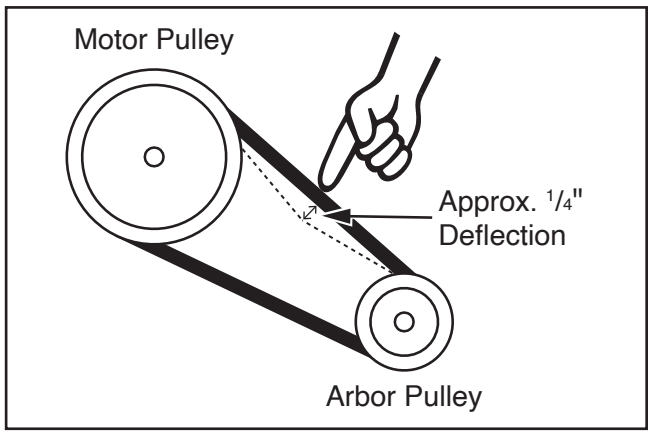


Figure 107. End trimmer belt deflection.

— If belt deflects approximately ¼", it is properly tensioned and no adjustment is necessary.

— If belt *does not* deflect approximately ¼", it *is not* properly tensioned and requires adjustment. Proceed to **Step 6**.

6. Loosen—but do not remove—cap screws that secure end trimmer belt tension plate (see **Figure 108**).

IMPORTANT: Do not remove these screws. If you do, it will be difficult to re-install end trimmer belt tension plate.

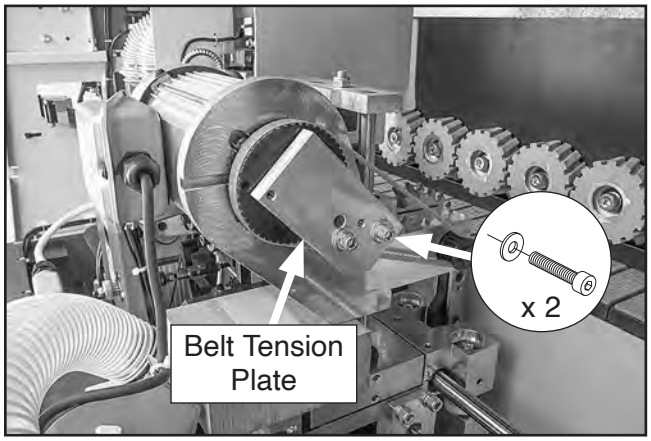


Figure 108. Location of tension plate cap screws.

7. Rotate end trimmer motor pulley by hand until access hole aligns with one of four motor mount cap screws (see **Figure 109**).

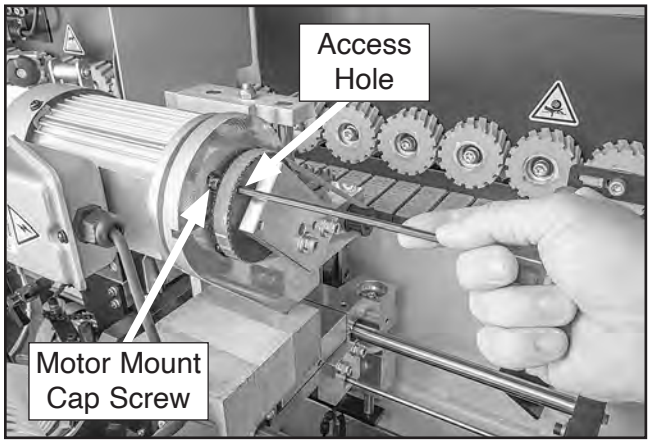


Figure 109. Loosening one of four end trimmer motor mount cap screws.

8. Insert T-handle hex wrench into access hole, as shown in **Figure 110**, and loosen—but do not remove—motor mount cap screw.

   IMPORTANT: Do not remove these screws. If you do, they will be very difficult to re-install.

9. Repeat **Steps 7–8** with remaining motor mount cap screws (see **Figure 110**).

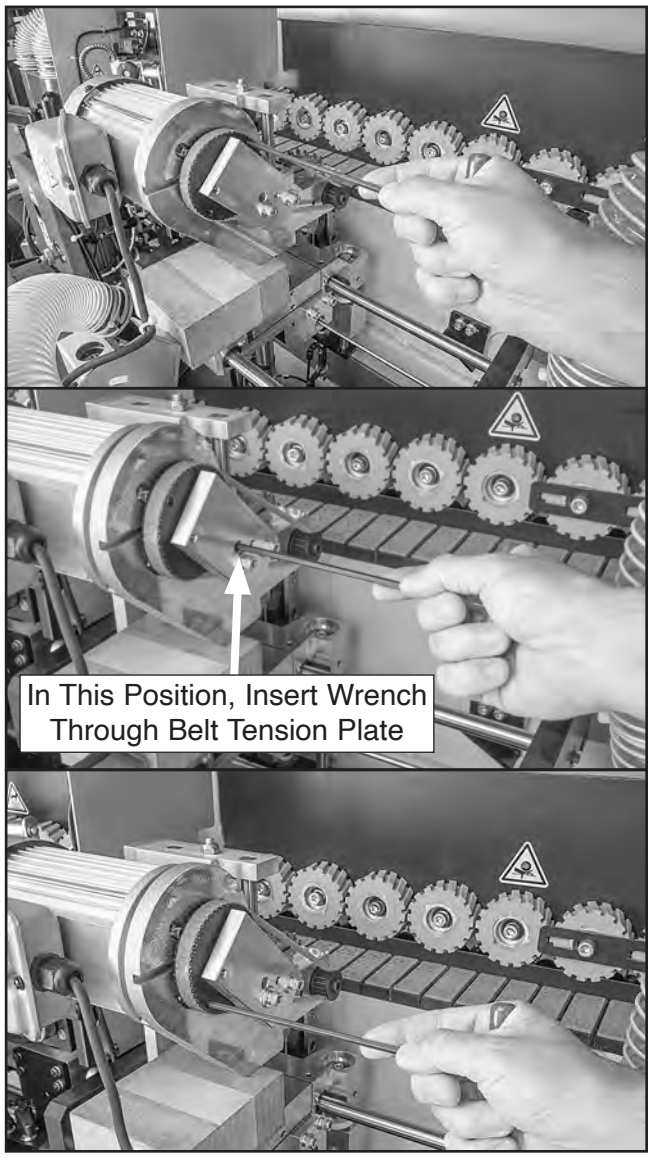


Figure 110. Loosening remaining end trimmer motor mount cap screws.

10. Shift motor up or down with one hand while checking belt deflection with other hand. When belt deflection is approximately ¼", tighten one of four motor mount cap screws from **Steps 7–9**.

11. Check belt deflection again and, if necessary, re-adjust it, then tighten remaining motor mount cap screws.

    Tip: *While the dust shroud and belt cover are removed, take advantage of the increased accessibility to other components. This is a great time to inspect and clean the end trimmer blades, tracers, and slides before proceeding with reassembly.*

12. Tighten cap screws from **Step 6**, then install belt cover and dust shroud.

NOTICE

Before tightening dust shroud cap screws, use belt to rotate blades to ensure they do not contact dust shroud. Check again after fully tightened.

Replacing Drive Belt

If the end trimmer drive belt becomes worn, cracked, frayed, broken, or otherwise damaged, it needs to be replaced.

Items Needed	Qty
Hex Wrench T-Handle 4mm	1
Hex Wrench 5mm	1
End Trimmer Drive Belt (Part# P09851511)	1

To replace drive belt:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Remove end trimmer belt cover, then refer to **Steps 3–8** of **Adjusting Drive Belt Tension** on **Page 64**) to remove belt.

3. Remove old belt and install new belt.

4. Proceed to **Adjusting Drive Belt Tension** on **Page 64** to tension drive belt and install belt cover.

Flush Trimmers

The flush trimmers trim the edgebanding flush with the top and bottom surfaces of the workpiece. The flush trimmer assembly moves vertically (1–3mm) on two steel rails. As the workpiece passes through the flush trimmers, the top and bottom tracer wheels (see **Figure 111**) adjust the cutterheads to the correct position to trim the excess banding from the top and bottom edge of the workpiece.

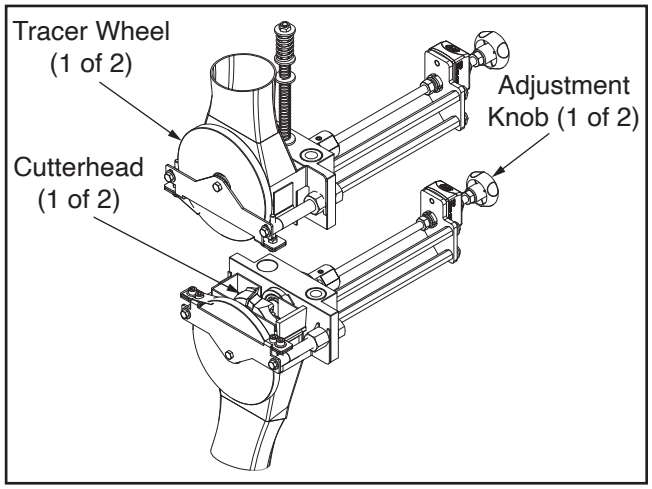


Figure 111. Flush trimmer components.

The required adjustment relies on identifying which surface exhibits an inadequate finish—whether it is the top or bottom, or the edge face of the workpiece. If the top or bottom is being trimmed too much or too little, the cutterhead alignment may need adjusting; if it is the edge of the workpiece that needs improvement, the adjustment knob may need to be calibrated.

NOTICE

Before making any adjustments, ensure all parts are clean and free of debris, glue, and residue.

Adjusting Cutterhead Alignment

If the flush trimmers are leaving too much or taking too much off the workpiece top or bottom, the flush trimmer tracer wheels may need to be adjusted to properly align the flush trimmer cutterhead. Adjustment may also be necessary after replacing the cutterhead inserts.

Items Needed	**Qty**
Open-End Wrench 8mm	1
Hex Wrench 4mm	1
Test Workpiece 24"	As Needed

To adjust cutterhead alignment:

1. Run test workpiece through machine to determine if cutterhead needs to move closer to or away from workpiece and how much.

2. DISCONNECT MACHINE FROM AIR AND POWER!

3. Open rear maintenance door.

4. Loosen (2) adjustment bolt lock nuts and (2) mounting plate hex nuts (see **Figure 112**).

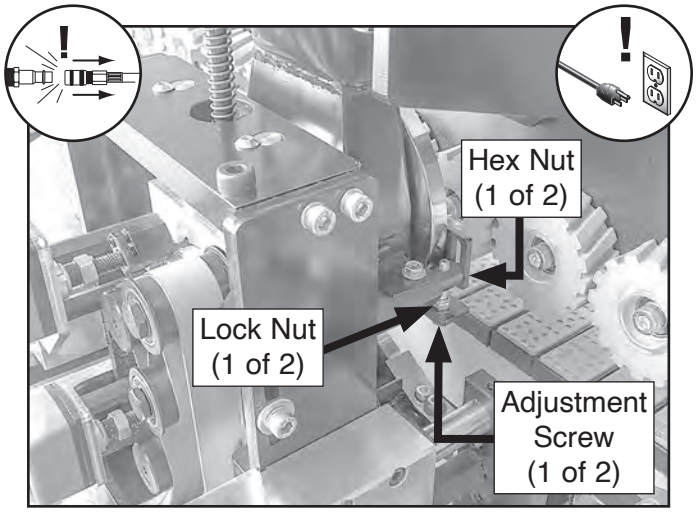


Figure 112. Location of flush trimmer adjustment components.

5. Rotate adjustment screw (see **Figure 113**) *clockwise* to move cutterhead away from tracer wheel; *counterclockwise* to move cutterhead closer.

   IMPORTANT: Make small adjustments, equal on both sides, no more than ¼ turn at a time.

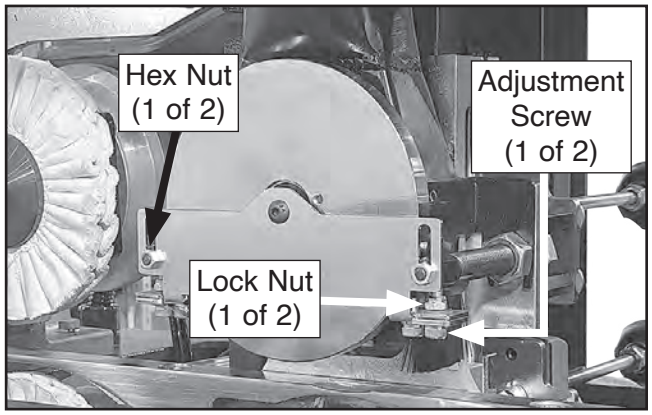


Figure 113. Detail of flush trimmer adjustment components.

6. Tighten all nuts loosened in **Step 4** on **Page 67** and close panel feeder.

7. Connect to power and air, and ensure glue pot reaches operating temperature.

8. Feed workpiece through machine, then inspect result of adjustment.

9. Repeat **Steps 1–7** until desired results are achieved.

   Note: *Follow same procedure for bottom flush trimmer.*

Calibrating Adjustment Knobs

Items Needed	**Qty**
Hex Wrench 4mm	1
Test Workpiece 24"	As Needed

Calibrating the flush trimmer adjustment knobs may be necessary if there is too much or not enough chamfer on the top and bottom of the workpiece. By calibrating the adjustment knobs, the in/out position of the cutterhead is being adjusted.

To calibrate adjustment knobs:

1. Measure thickness of edgebanding to be used in millimeters.

2. Run test workpiece through machine to determine if cutterhead needs to move closer to or away from workpiece.

3. Rotate top or bottom adjustment knob *clockwise* to move cutterhead toward workpiece; *counterclockwise* to move away.

   IMPORTANT: Make small adjustments, no more than ¼ turn at a time.

4. Feed workpiece through machine, then inspect result of adjustment.

5. Repeat **Steps 2–4** until desired results are achieved.

6. Loosen set screw in dial indicator collar (see **Figure 114**).

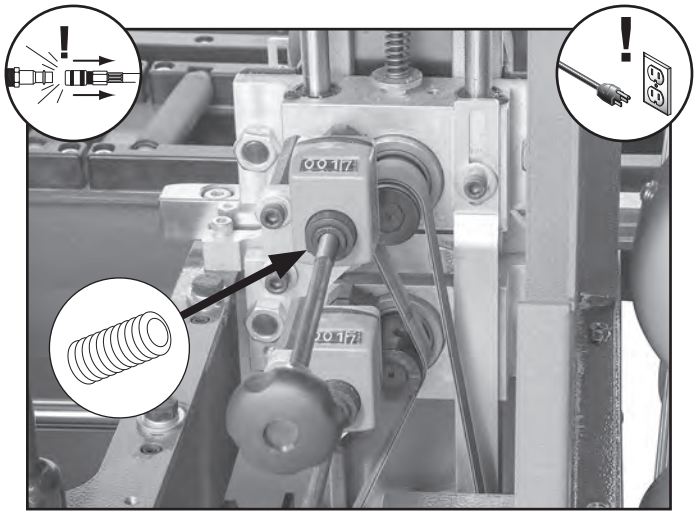


Figure 114. Location of dial indicator set screw.

7. Rotate collar until it reads same measurement of edgebanding from **Step 1**.

8. Tighten set screw.

Replacing Cutterhead Inserts

Items Needed	Qty
Side Cutter	1
Phillips Head Screwdriver #2	1
Hex Wrench T-Handle 3mm	1
Wrench Open-End Wrench 8mm	1
Wood Block 2" x 4" x 5"	1
Zip Tie 8"	1
Cutterhead Inserts	
—P09851672 (Upper)	4
—P09851762 (Lower)	4

If the flush trimmer fails to produce straight, clean upper and lower edges that are flush with the top and bottom surfaces of the workpiece, the flush trimmer cutterhead inserts may be dull or damaged, requiring replacement.

The upper and lower flush trimmer inserts are held in place by blocks and set screws (see **Figure 115**).

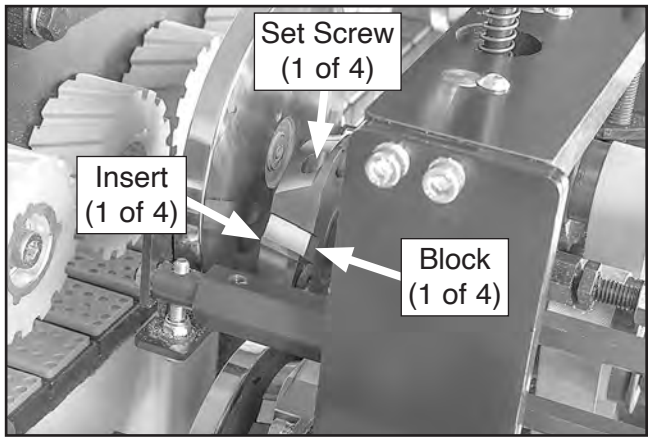


Figure 115. Flush trimmer insert components.

To replace cutterhead inserts:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Remove dust hose from upper flush trimmer dust shroud (see **Figure 116**).

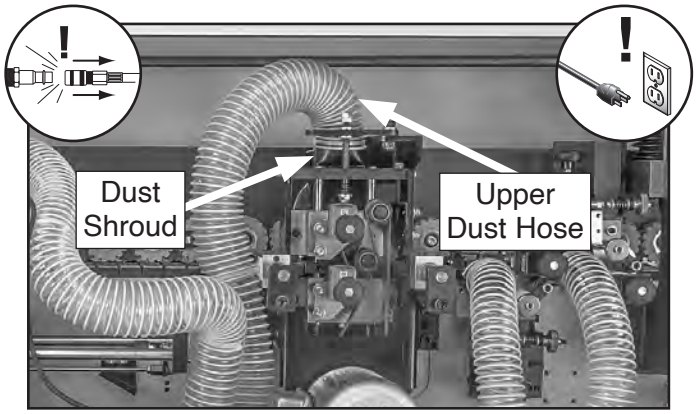


Figure 116. Location of upper dust hose.

4. Pull flush trimmer assembly back and place wood block between assembly frame and machine body, as shown in **Figure 117**. This will provide better access to components.

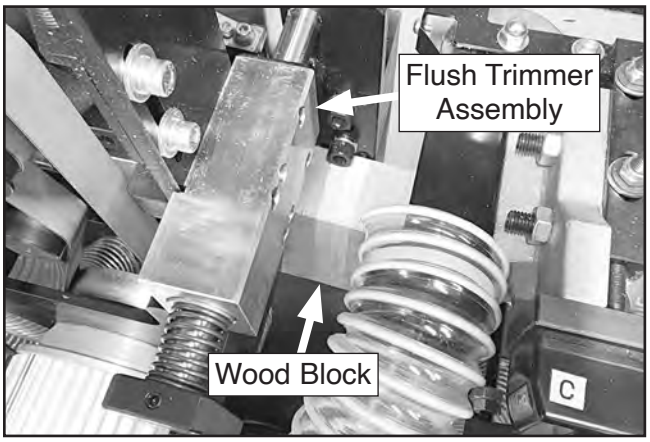


Figure 117. Wood block placed to support flush trimmer assembly.

5. Remove (2) flange bolts, then remove upper trimmer dust shroud (see **Figure 118**).

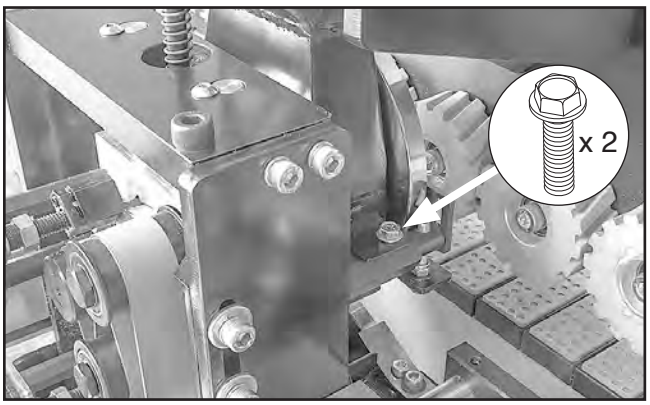


Figure 118. Location of upper trimmer dust shroud and flange bolts.

6. Loosen (2) flange screws, then remove lower dust shroud.

7. Remove (2) cap screws and lock washers (see **Figure 119**), then remove flush trimmer alignment block.

Tip: *Flush trimmer alignment block is easier to remove by raising panel feeder and accessing from front of machine.*

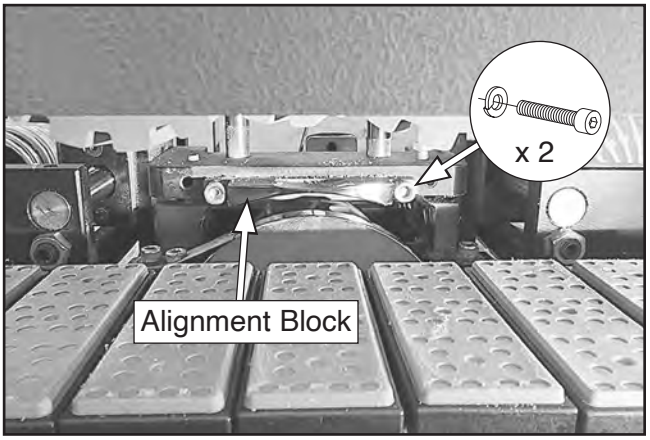


Figure 119. Location of flush trimmer alignment block.

Note: *Be aware of alignment block orientation during removal.*

8. Loosen set screw, then carefully remove trimmer insert and block as shown in **Figure 120**.

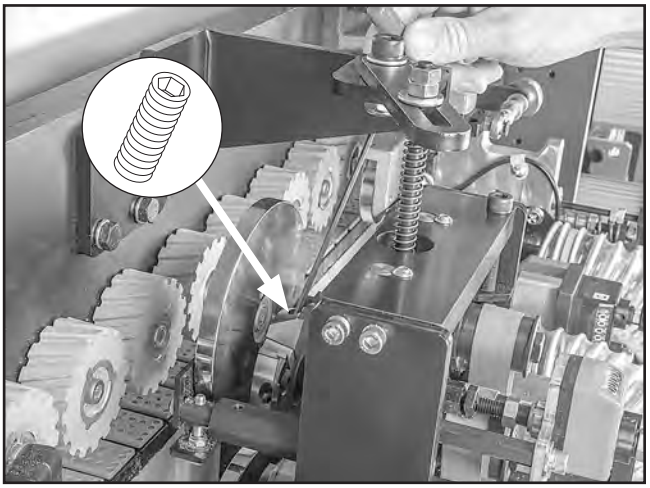


Figure 120. Loosening flush trimmer set screw (upper cutterhead shown).

9. Insert new insert with block, then tighten set screw.

IMPORTANT: Make sure insert and block are flush against stop screw before tightening set screw (see **Figure 121**).

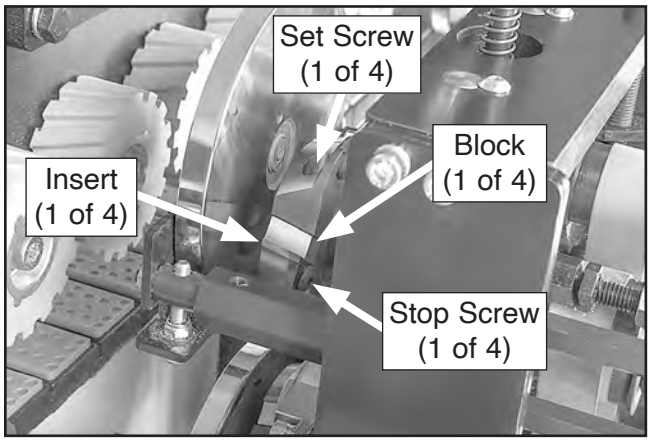


Figure 121. Flush trimmer insert components.

10. Rotate cutterhead and repeat **Steps 8–9** to replace remaining upper cutterhead inserts.

11. Repeat **Steps 8–10** to replace lower cutterhead inserts.

12. Install alignment block and upper and lower dust shrouds.

13. Remove wood block, then install upper dust hose.

14. Close rear maintenance door.

Tensioning/Replacing Drive Belt

The flush trimmer motor transfers power through a serpentine drive belt (see **Figure 122**). If it becomes worn, cracked, frayed, broken, or otherwise damaged in any way, it will need to be replaced.

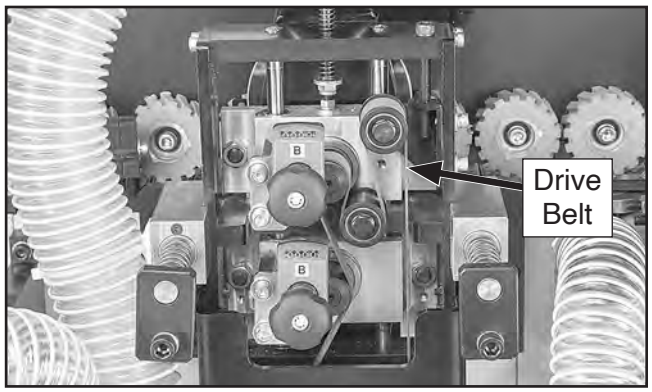


Figure 122. Location of flush trimmer drive belt.

Items Needed	Qty
Hex Wrench 5mm	1
Flush Trimmer Drive Belt (Part# P09851808)	1

Tensioning Drive Belt

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Press middle of flush trimmer drive belt with moderate pressure. Proper tension is achieved when deflection is approximately ¼" as illustrated in **Figure 123**.

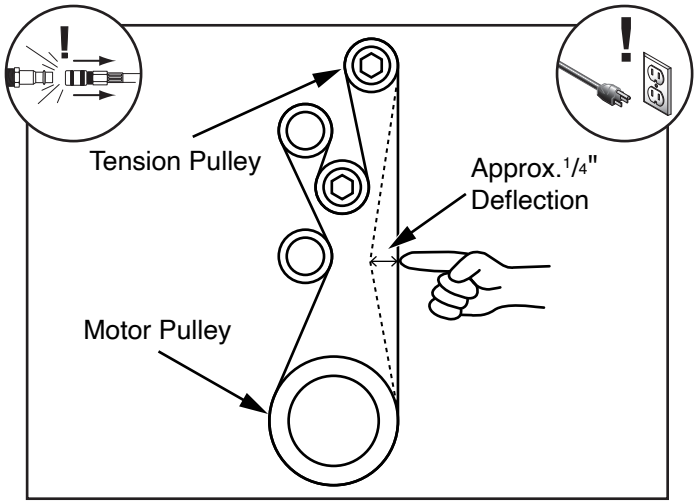


Figure 123. Flush trimmer belt deflection.

   — If belt deflection *is* approximately ¼", drive belt is properly tensioned. No adjustment is necessary.

   — If belt deflection is not approximately ¼", tension must be adjusted. Proceed to **Step 4**.

4. Loosen (2) adjustment locking cap screws shown in **Figure 124**.

5. Rotate belt tensioning screw *counterclockwise* to loosen belt (see **Figure 124**), *clockwise* to tighten belt.

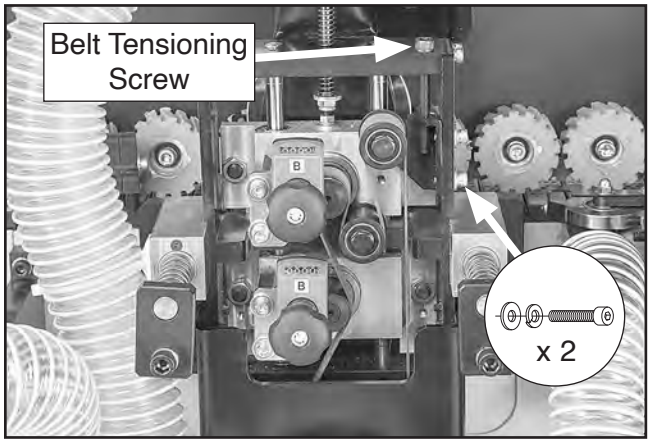


Figure 124. Location of drive belt adjustment screws.

Replacing Drive Belt

To replace the flush trimmer drive belt, simply loosen the belt tensioning screw until there is enough slack to remove the belt, then slip the belt off of the pulleys. Route the new belt around the pulleys as shown in **Figure 125**, then follow steps in **Tensioning Drive Belt**.

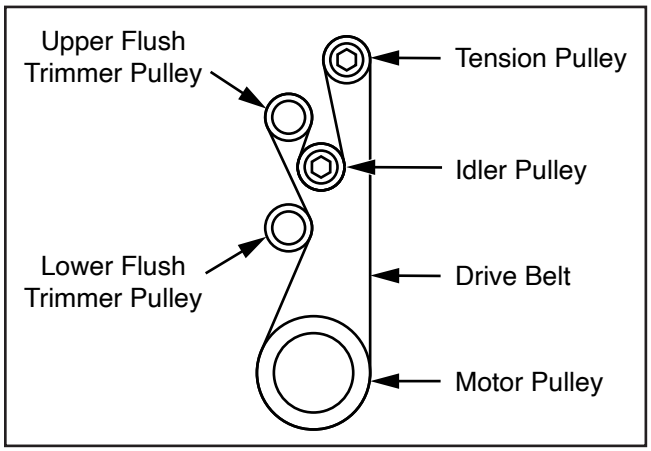


Figure 125. Flush trimmer belt routing.

Adjusting/Replacing Buffing Wheels

Two buffing wheels finish the workpiece to give the edges a smooth, polished appearance. Over time, the buffing wheels will wear and need to be adjusted and eventually replaced.

Adjusting Buffing Wheels

If the buffing wheels fail to produce smooth, polished upper and lower edges, the wheels may need to be adjusted.

Item(s) Needed	Qty
Wrench or Socket 13mm	1
Test Workpiece 27" Long	1

To adjust buffing wheels:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Place test workpiece between upper and lower buffing wheels, as shown in **Figure 126**, then adjust panel feeder height according to test workpiece being used.

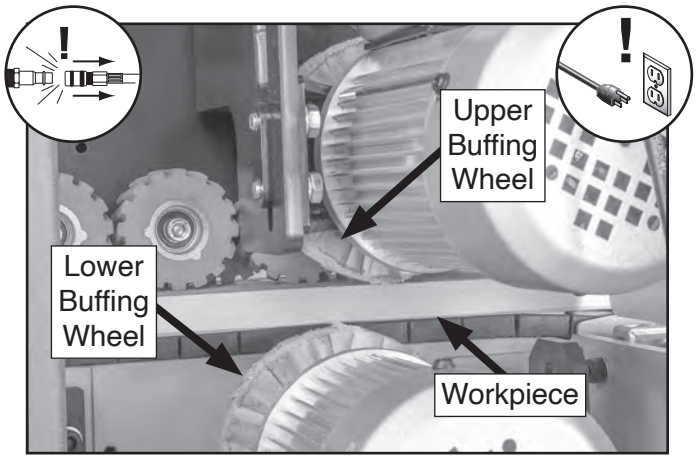


Figure 126. Workpiece between buffing wheels.

4. Loosen (2) upper buffing motor mounting bolts shown in **Figure 127**.

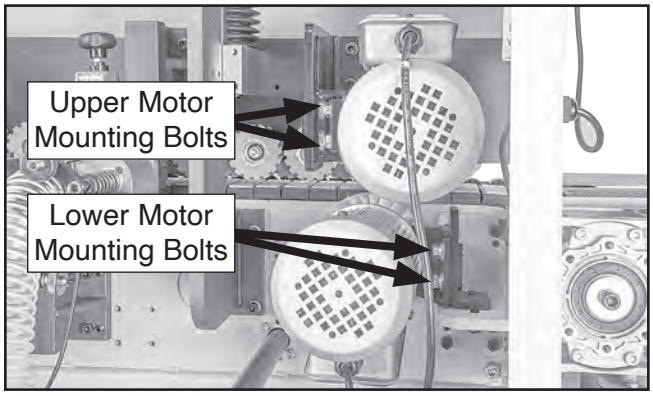


Figure 127. Buffing wheel adjustment bolt locations.

5. Lower motor so buffing wheel just barely touches workpiece, then tighten motor mounting bolts.

6. Follow **Steps 3–4** to adjust lower motor so lower buffing wheel is barely in contact with bottom surface of workpiece, then tighten lower motor mounting bolts.

   IMPORTANT: DO NOT adjust buffing wheels any closer to the workpiece than described in **Step 5**. Buffing wheels expand when motors are running and will create too much load on motors, which may cause premature failure of buffing motors and/or other components.

Replacing Buffing Wheels

Item(s) Needed	Qty
Wrench or Socket 13mm	1
Hex Wrench 5mm	1
Buffing Wheels (Part #P09852122)	1–2

If the buffing wheels are worn beyond adjustment or are damaged, they will need to be replaced.

To replace buffing wheels:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Remove arbor bolt securing upper buffing wheel (see **Figure 128**). Bolt has left-hand threads (rotate *clockwise* to loosen; *counter-clockwise* to tighten).

   Note: *If arbor spins, secure it by inserting a 5mm hex wrench into hole in arbor, behind buffing wheel.*

4. Remove lock washer, flange, and buffing wheel (see **Figure 128**).

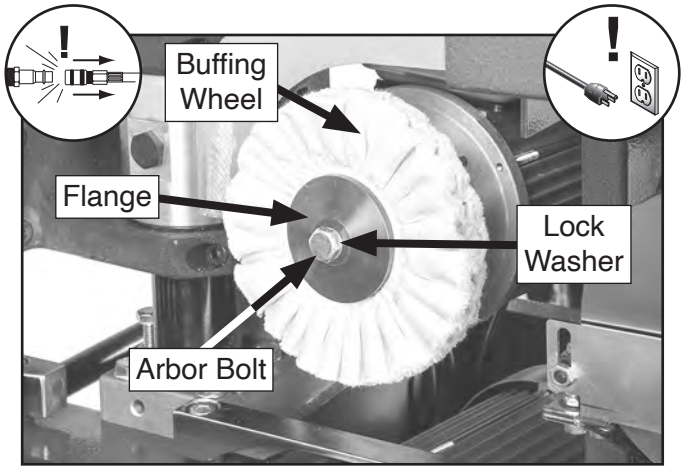


Figure 128. Example of buffing wheel components.

5. Install new buffing wheel, then install flange, lock washer, and arbor bolt, in reverse order from removal in **Step 4**.

   IMPORTANT: Orient components in same direction as they were before removal.

6. Repeat **Steps 3–5** with lower buffing wheel. Lower hex bolt has regular threads.

7. Follow steps in **Adjusting Buffing Wheels** on **Page 72**.

Adjusting Limit Switches

The Model G0985 is equipped with three adjustable limit switches that control critical operations: timing of pre-mill rotation, edgebanding advancement and guillotine, and end trimmer cutting. These switches are factory calibrated to ensure precise and consistent performance, and typically do not require routine adjustment. However, after extended use or if the edgebanding results become unsatisfactory, such as uneven trimming or misaligned cuts, the switches may need to be recalibrated. Signs that adjustment is necessary include inconsistent edgebanding application or variations in cut quality. In such cases, follow the adjustment instructions to fine tune the limit switches and restore optimal performance.

Items Needed	Qty
Hex Wrench 3mm	1
Test Workpiece 27" Long	As Needed

NOTICE

When making adjustments to limit switches, make only very small adjustments at a time. Feed workpiece through machine between each adjustment to inspect results.

Adjusting Pre-Mill Limit Switch

In the default position (OFF) of the pre-mill limit switch, the rear cutterhead is engaged with the workpiece. When the workpiece activates the pre-mill limit switch, the pre-mill assembly rotates slightly to position the front cutterhead for trimming the leading end of the workpiece. As the workpiece passes and the limit switch is deactivated, the cutterhead assembly rotates back to the default position and the rear cutterhead will trim the trailing end. Though extremely rare, if tearout is occurring on the trailing end of the workpiece, it may indicate that the cutterhead assembly is not rotating soon enough and the limit switch may need to be adjusted.

To adjust pre-mill limit switch:

1. Open rear maintenance door.

2. Loosen (2) adjustment screws shown in **Figure 129**.

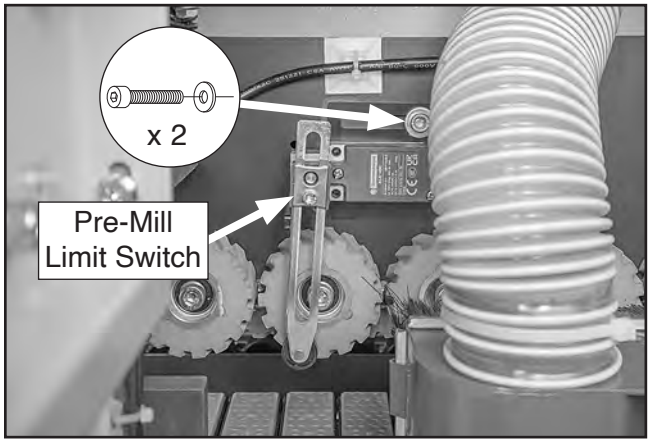


Figure 129. Location of pre-mill limit switch and adjustment screws.

   — Move limit switch toward outfeed end of machine to *increase* time rear cutterhead is engaged, move it toward infeed end of machine to *decrease*.

3. Tighten adjustment screws, then close rear maintenance door.

Adjusting Guillotine Limit Switch

When the workpiece activates the guillotine limit switch, it triggers the edgebanding advancement roller to feed the edgebanding material for application to the workpiece. Once the workpiece passes and the limit switch deactivates, the roller retracts, and the guillotine cuts the edgebanding to length. If the edgebanding is too short at either end of the workpiece, it may indicate that the limit switch requires adjustment to ensure proper timing of the roller and guillotine.

To adjust guillotine limit switch:

1. Open rear maintenance door.

2. Loosen (2) adjustment screws shown in **Figure 130**.

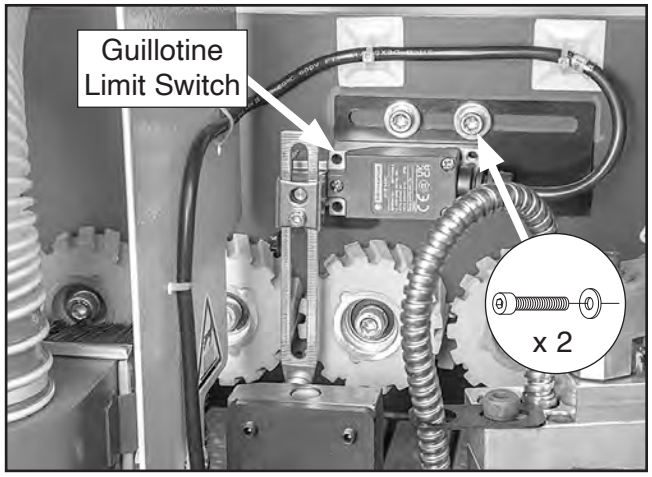


Figure 130. Location of guillotine limit switch and adjustment screws.

   — If edgebanding is short on *leading end* of workpiece, move switch toward infeed end of machine.

   — If edgebanding is short on *trailing end* of workpiece, move switch toward outfeed end of machine.

3. Tighten adjustment screws, then close rear maintenance door.

Adjusting End Trimmer Limit Switch

When the workpiece passes under the end trimmer switch, the end trimmer is activated and trims the leading and trailing ends of the glued edgebanding flush with the ends of the workpiece. If the end trimmer fails to trim the edgebanding flush with the ends of the workpiece, the end trimmer limit switch may need adjustment.

To adjust end trimmer limit switch:

1. Open rear maintenance door.

2. Loosen (2) adjustment screws shown in **Figure 131**.

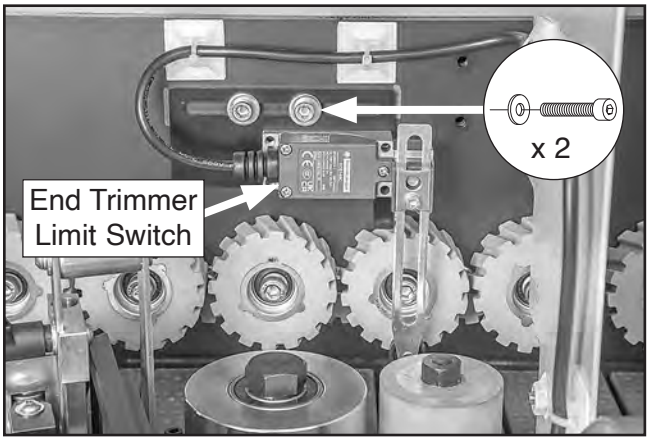


Figure 131. Location of end trimmer switch and adjustment screws.

   — If end trimmer leaves too much edgebanding on the *leading end* of workpiece edge and not enough on *trailing end*, move switch toward infeed end of machine.

   — If end trimmer leaves too much edgebanding on the *trailing end* of workpiece edge and not enough on *leading end*, move switch toward outfeed end of machine.

3. Tighten adjustment screws, then close rear maintenance door.

Adjusting Pneumatic Regulators & Valves

The movement of each station, including the pre-mill cutterhead rotation, edgeband feeding, guillotine, and end trimmer, is controlled pneumatically. The air pressure for these components is preset at the factory and typically does not require adjustment. However, if any of these components fail to operate correctly, it may be necessary to inspect and adjust the air pressure.

⚠WARNING

The following procedure requires rear maintenance door to be open, bypassing safety switch, with air and power connected, and pneumatic sensors activated. This exposes moving components that can cause serious injury. Stay clear of all moving parts, and proceed with extreme caution.

Each pneumatic component is activated by a solenoid. There are (6) solenoids located behind the lower right door at the rear of the machine, and (1) is located behind the regulator control panel (see **Figure 132**).

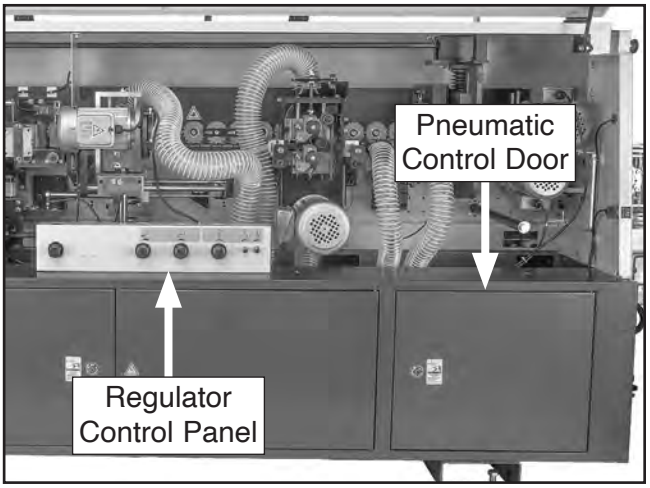


Figure 132. Location of pneumatic control door and regulator control panel.

Refer to the **Figures 133–134** to locate the solenoid and regulator associated with each pneumatic component.

Pneumatic Solenoids & Regulators

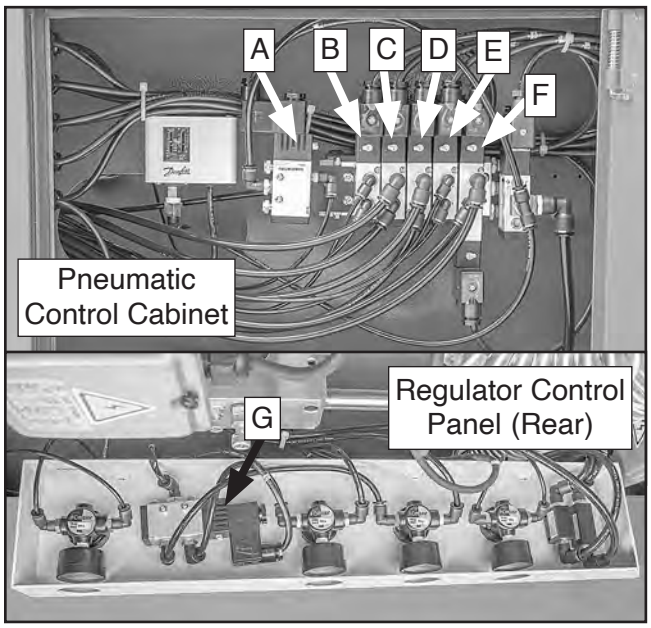


Figure 133. Location of pneumatic solenoids and regulators.

A. Scraper Blowers
B. End Trimmer Tracers (Up/Down)
C. End Trimmer Carriage (Up/Down)
D. Guillotine
E. Edgebanding Feed
F. Pre-Mill Cutterhead
G. End Trimmer (Left/Right)

Pneumatic Regulators & Valves

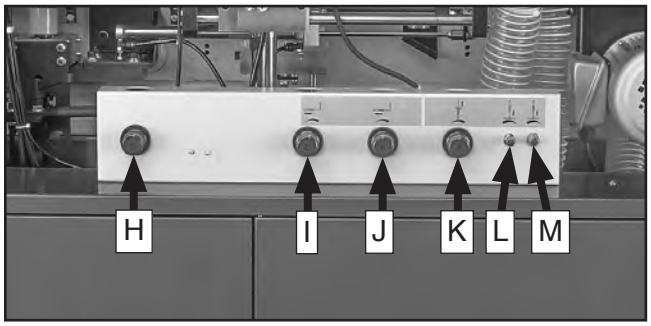


Figure 134. Pneumatic regulators and valves.

H. Edgeband Feeding
I. End Trimmer Carriage (Right)
J. End Trimmer Carriage (Left)
K. End Tracer (Up/Down)
L. End Trimmer (Down)
M. End Trimmer (Up)

The movement of each pneumatic component should be smooth, with no hesitation along its entire travel. However, the component should not slam into to the end with excessive force, just a firm bump. To increase the speed of the component, increase the air pressure at the corresponding regulator or valve; to decrease the speed, reduce air pressure.

Testing & Adjusting Pneumatic Components

Testing the pneumatic components requires the machine to be connected to power and air, having the rear maintenance door open, and having the maintenance door safety switch depressed.

Items Needed	Qty
Thin Metal Plate 3" x 3"	1
Strong Magnet	1

NOTICE

Before making adjustments to pneumatic components, verify that all components are clean and lubricated.

To test and adjust pneumatic components:

1. Open pneumatic control door, then open rear maintenance door.

2. Connect machine to power and air, and ensure connected air is set to 100 PSI at machine regulator.

3. With plate and magnet, press and hold maintenance door safety switch (see **Figure 135**).

Figure 135. Location of maintenance door safety switch.

4. Turn main power ***ON***.

5. Turn each sensor ***ON*** by pressing (upper) ON/OFF buttons (see **Figure 136**). DO NOT turn (lower) motors ***ON***.

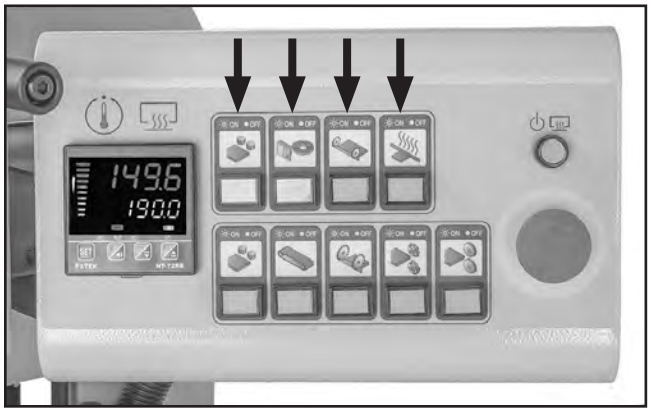


Figure 136. Location of sensor ON/OFF buttons.

6. Press and release button on appropriate solenoid to activate pneumatic component (see **Figure 137**).

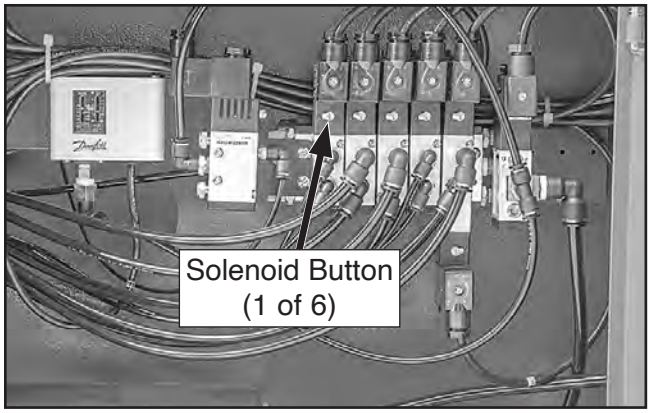


Figure 137. Location of solenoid button.

7. Observe movement of component as button is pressed and released.

   — If component movement is too *slow*, rotate regulator knob or valve *counterclockwise* to increase air pressure.

   — If component movement is too *fast*, rotate regulator knob or valve *clockwise* to decrease air pressure.

8. Repeat **Steps 6–7** until component movement is operating correctly.

9. Remove plate and magnet, then close rear maintenance and pneumatic panel doors.

Adjusting/Replacing Dust Brushes

The Model G0985 is equipped with brushes to sweep debris from the workpiece at critical points during operation. Over time, the brushes will wear and negatively affect edgebanding results.

Items Needed	Qty
Hex Wrench 4mm	1
Open-End Wrench 10mm	1
Test Workpiece 27" Long	1
Brushes (P09850151)	As Needed

To adjust/replace dust brushes:

1. DISCONNECT MACHINE FROM AIR AND POWER!

2. Open rear maintenance door.

3. Raise panel feeder and position workpiece so it spans across brushes.

4. Loosen fastener securing brush (see **Figures 138–140**), slide brush forward or backward until bristles overhang edge approximately 1/16", then tighten fastener.

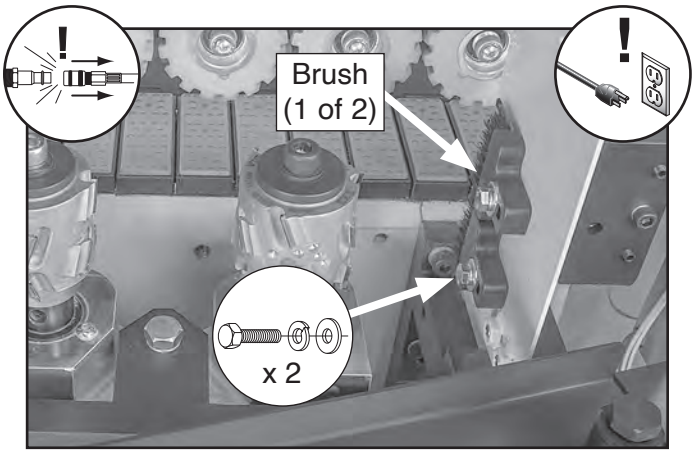


Figure 138. Location of cutterhead brushes (cutterhead guard removed for clarity).

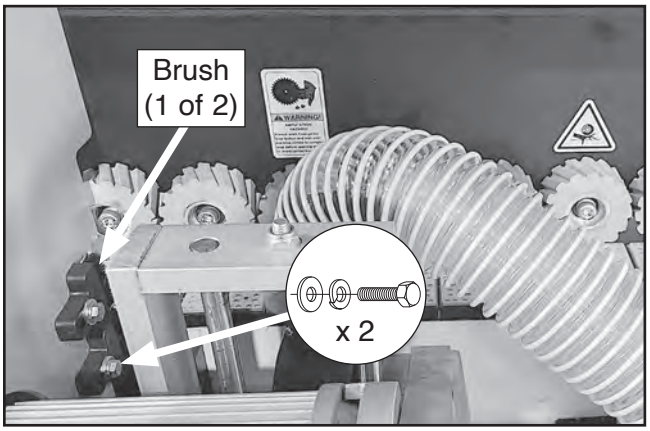


Figure 139. Location of end trimmer brushes.

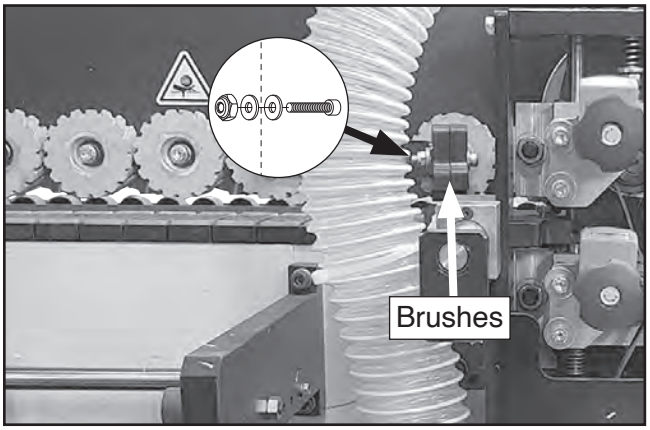


Figure 140. Location of flush trimmer brushes.

— Replace brushes when they become damaged or when length is approximately 1/8".

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.

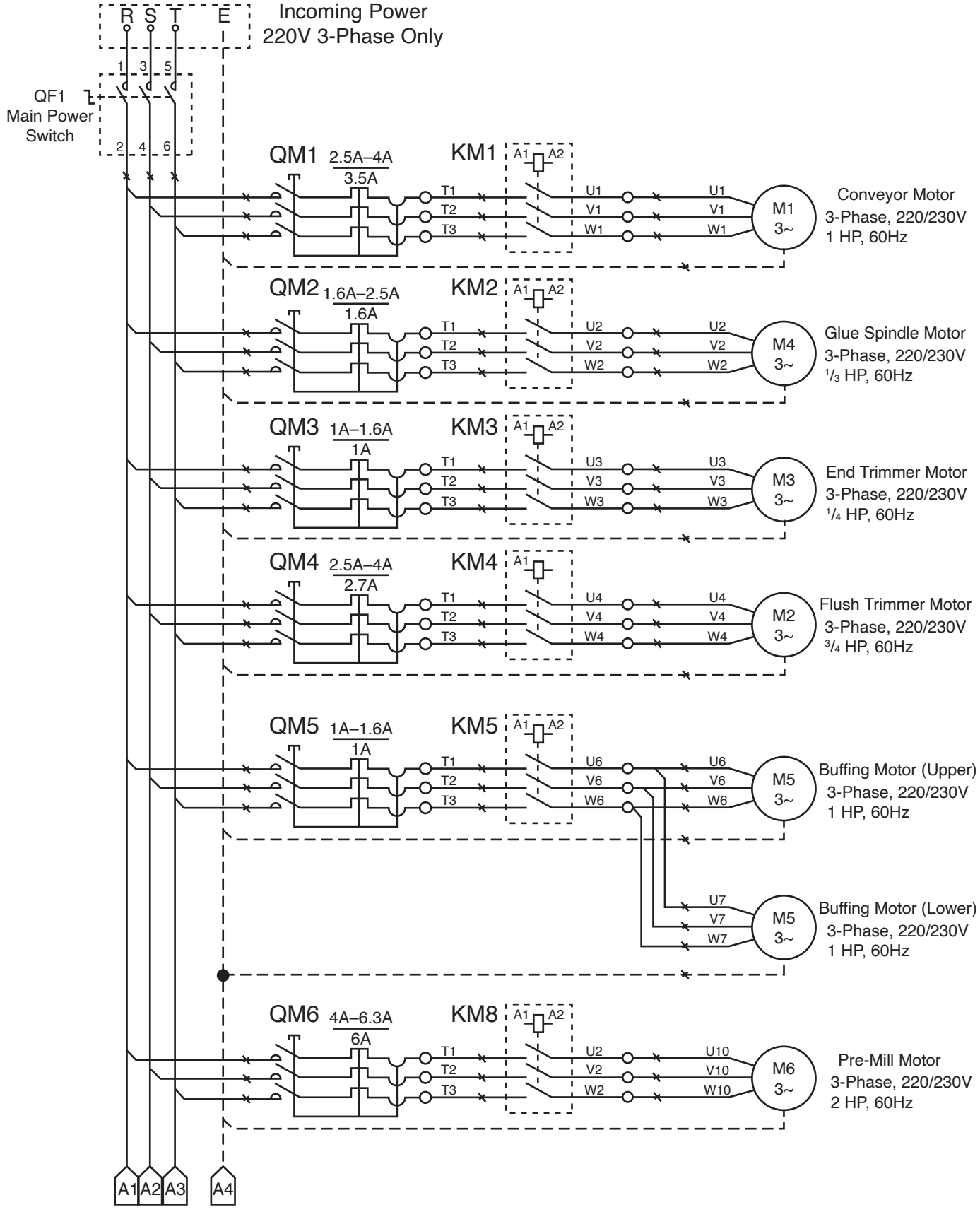
WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

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.

Contactors & Motor Starters



To Glue Pot Heater/Transformer/PLC

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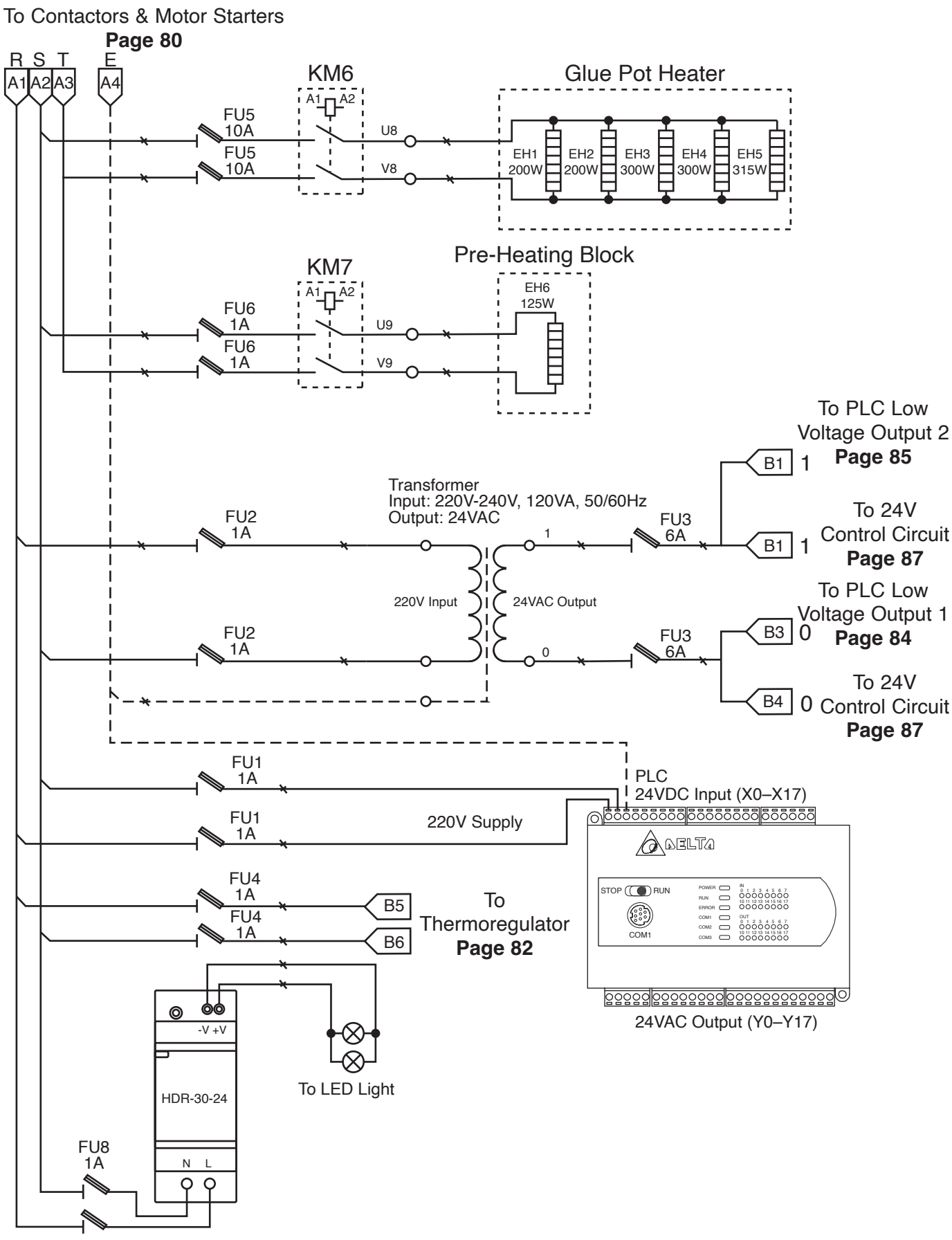
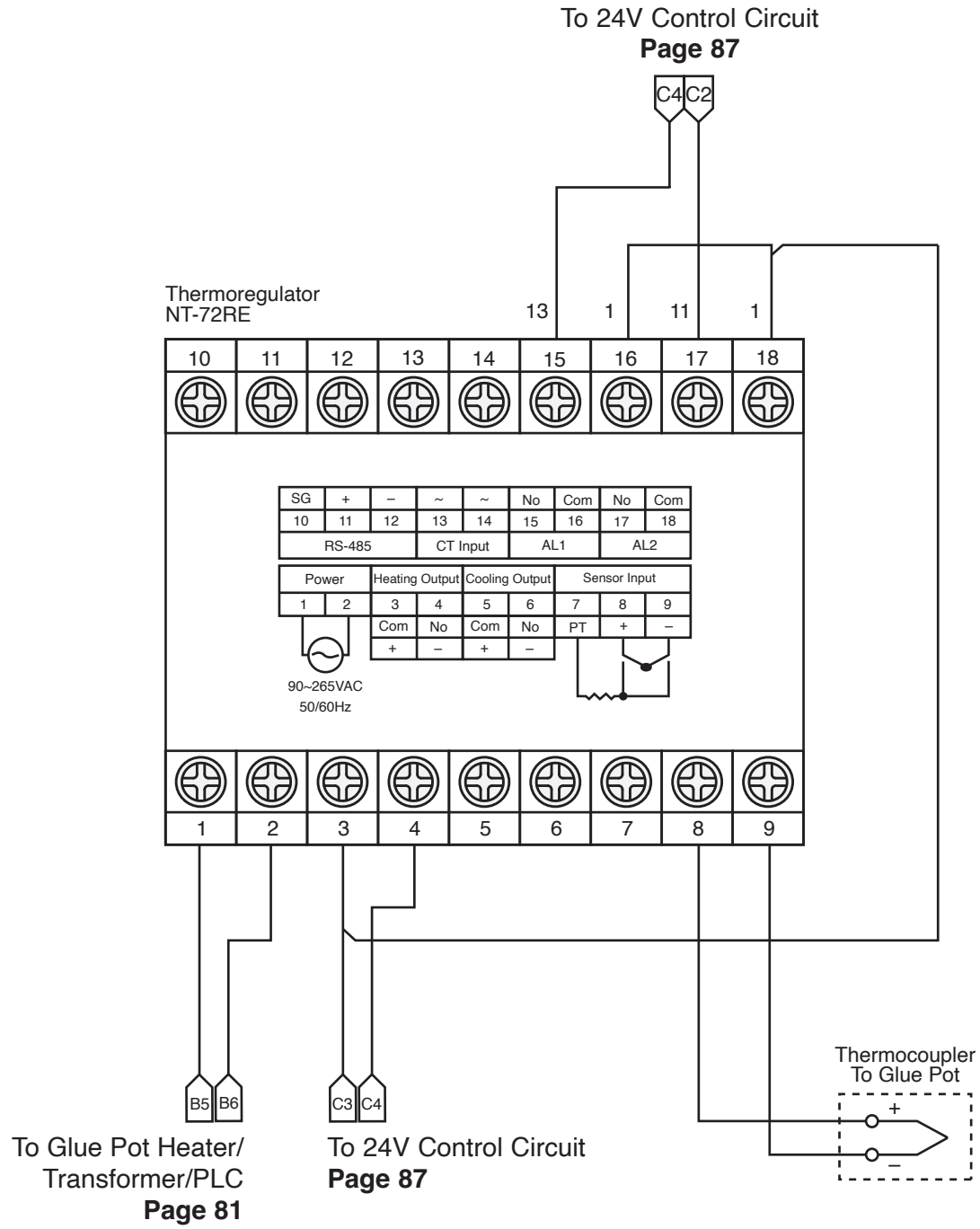
Glue Pot Heater/Transformer/PLC



Thermoregulator



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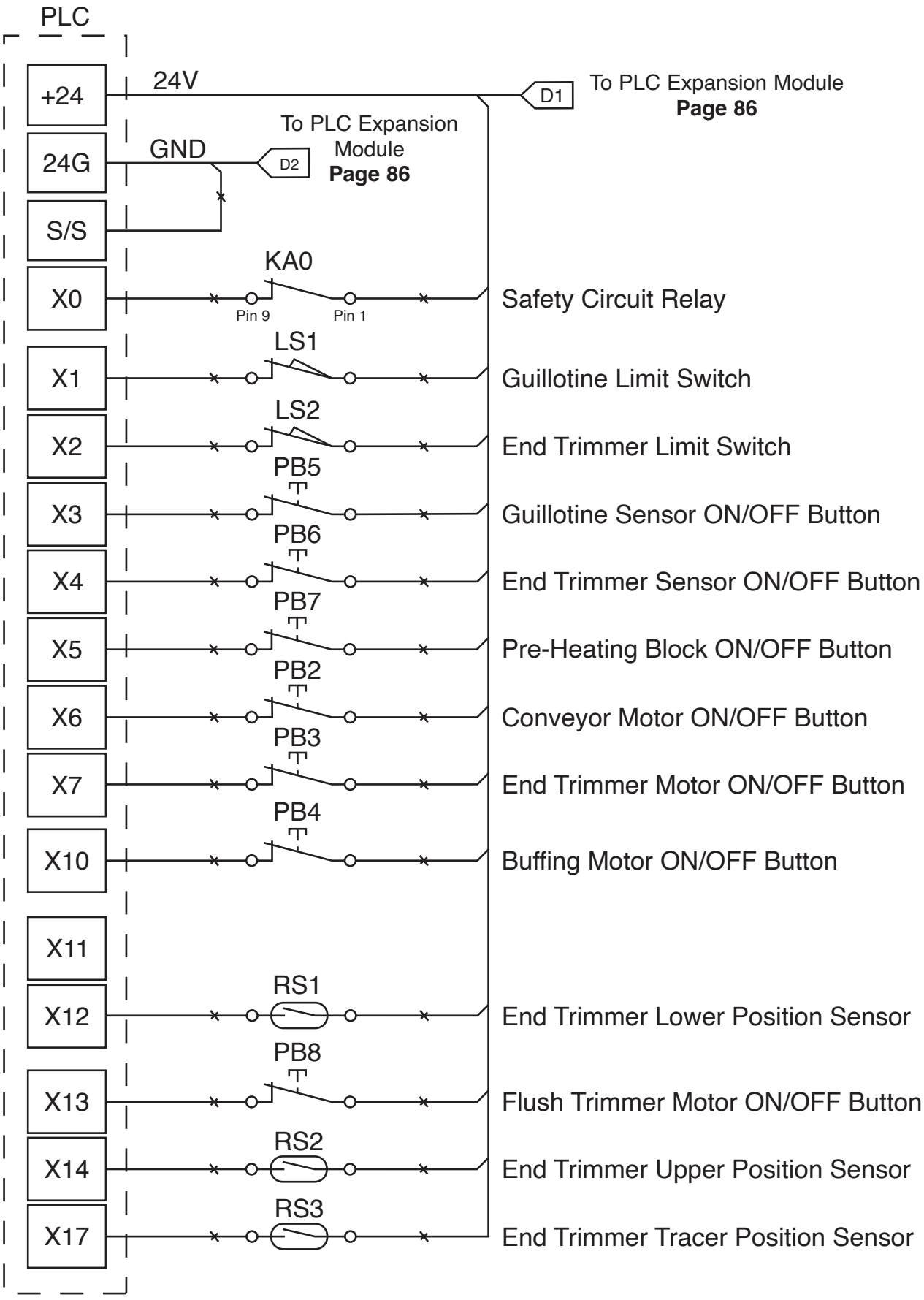
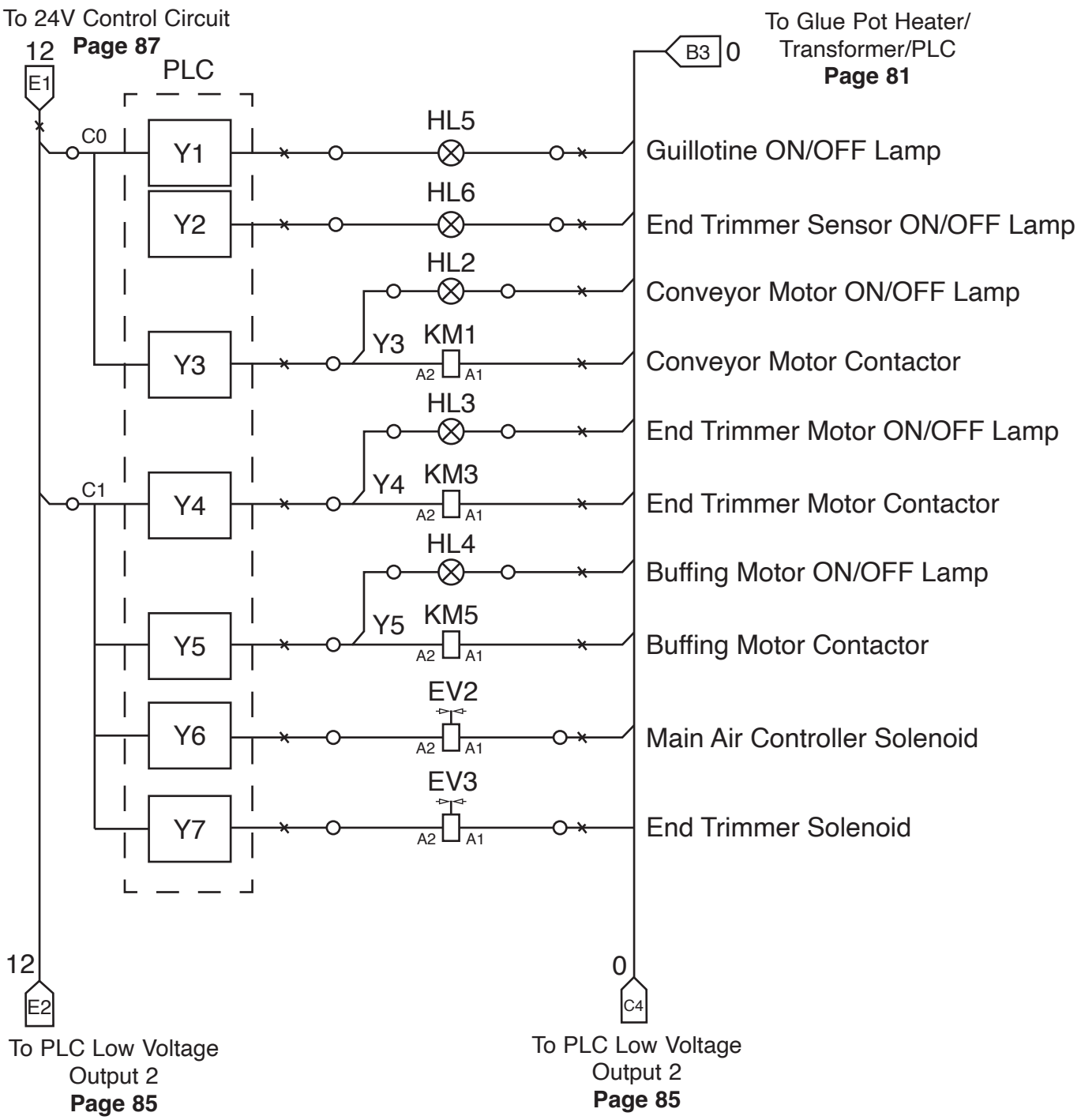
PLC Low Voltage Input



PLC Low Voltage Output Diagram 1



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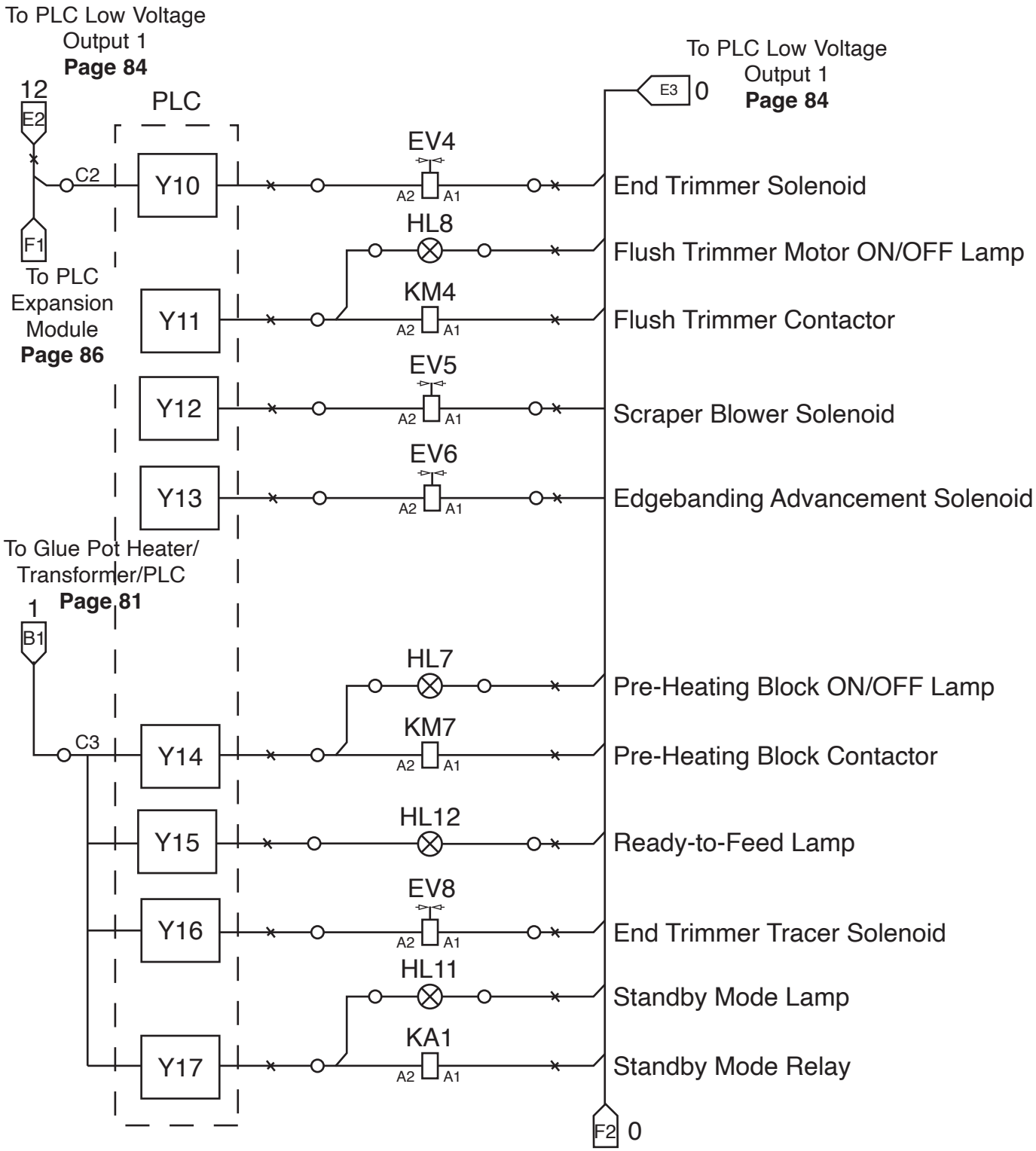
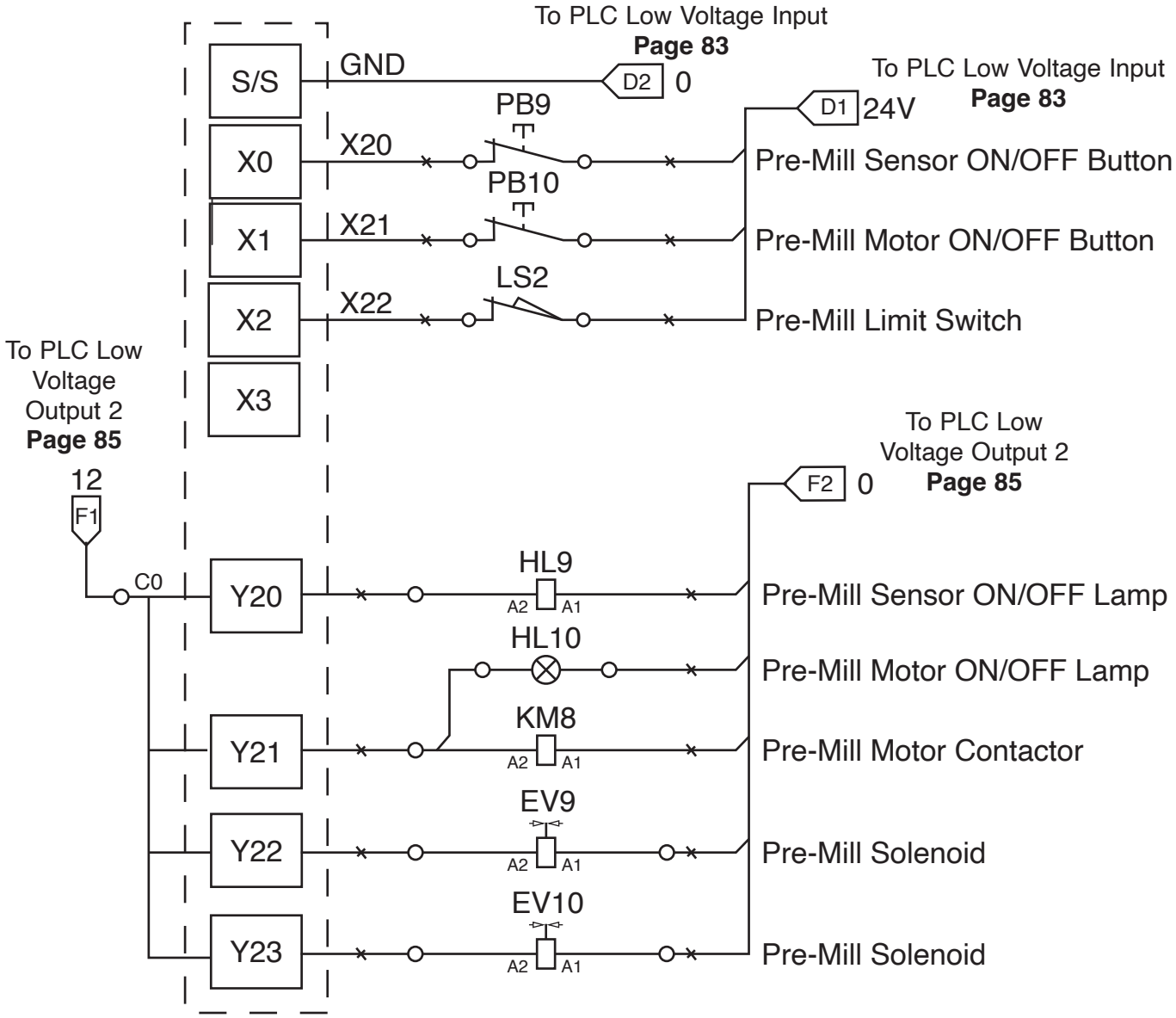
PLC Low Voltage Output Diagram 2



PLC Expansion Module



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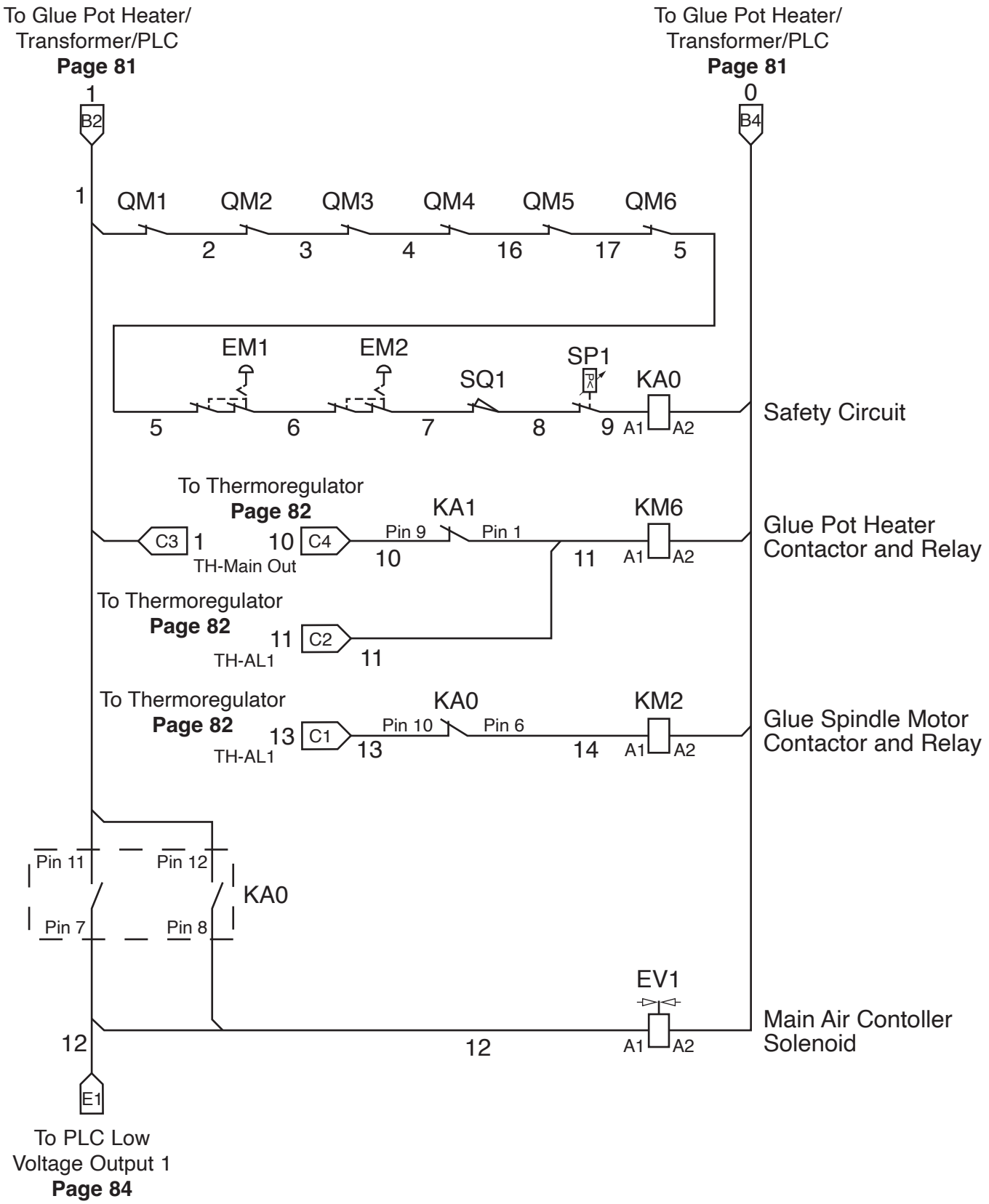
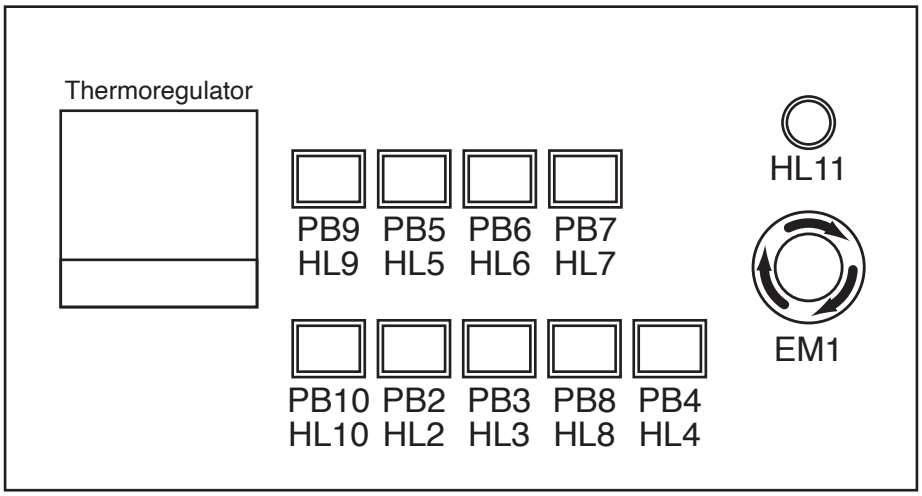
24V Control Circuit



Control Panel Button Legend



PB2	Conveyor Motor ON/OFF Button
PB3	End Trimmer Motor ON/OFF Button
PB4	Buffing Motor ON/OFF Button
PB5	Guillotine Sensor ON/OFF Button
PB6	End Trimmer Sensor ON/OFF Button
PB7	Pre-Heating Block ON/OFF Button
PB8	Flush Trimmer Motor ON/OFF Button
PB9	Pre-Mill Sensor ON/OFF Button
PB10	Pre-Mill Motor ON/OFF Button
EM1	Emergency Stop Button (Control Panel)
EM2	EMERGENCY STOP BUTTON (Outfeed)

HL2	Conveyor Motor ON/OFF Lamp
HL3	End Trimmer Motor ON/OFF Lamp
HL4	Buffing Motor ON/OFF Lamp
HL5	Guillotine Sensor ON/OFF Lamp
HL6	End Trimmer Sensor ON/OFF Lamp
HL7	Pre-Heating Block ON/OFF Lamp
HL8	Flush Trimmer Motor ON/OFF Lamp
HL9	Pre-Mill Sensor ON/OFF Lamp
HL10	Pre-Mill Motor ON/OFF Lamp
HL11	Standby Mode Lamp
HL12	Ready-to-Feed Lamp

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Switch/Relay Legend

QM1	Conveyor Motor Starter
QM2	Spindle Motor Starter
QM3	End Trimmer Motor Starter
QM4	Flush Trimmer Motor Starter
QM5	Buffing Motor Starter
QM6	Pre-Mill Motor Starter
KM1	Conveyor Motor Contactor
KM2	Spindle Motor Contactor
KM3	End Trimmer Motor Contactor
KM4	Flush Trimmer Motor Contactor
KM5	Buffing Motor Contactor
KM6	Glue Pot Heater Contactor
KM7	Pre-Heating Block Contactor
KM8	Pre-Mill Motor Contactor
EV1	Main Air Controller Solenoid
EV2	Guillotine Solenoid

EV3	End Trimmer Solenoid
EV4	End Trimmer Solenoid
EV5	Scraper Blower Solenoid
EV6	Edgebanding Advancement Solenoid
EV8	End Trimmer Tracer Solenoid
EV9	Pre-Mill Solenoid
EV10	Pre-Mill Solenoid
LS1	Guillotine Limit Switch
LS2	End Trimmer Limit Switch
LS3	Pre-Mill Limit Switch
RS1	End Trimmer Lower Position Sensor
RS2	End Trimmer Upper Position Sensor
RS3	End Trimmer Tracer Position Sensor
KA0	Safety Circuit Relay
KA1	Standby Mode Relay
SP1	Pressure Switch

Electrical Component Photos

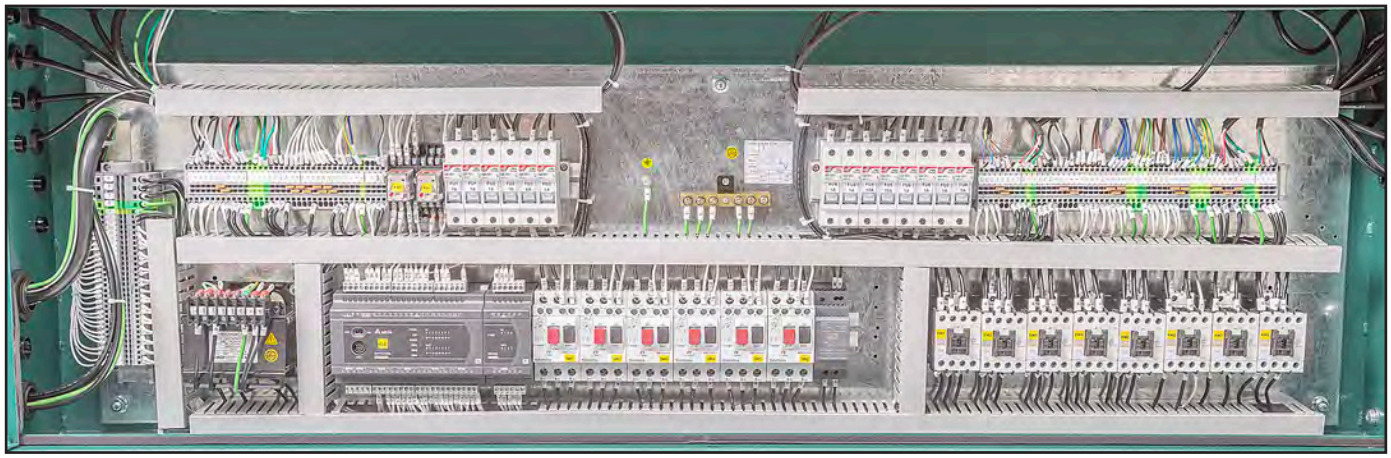

Figure 141. Electrical Cabinet.

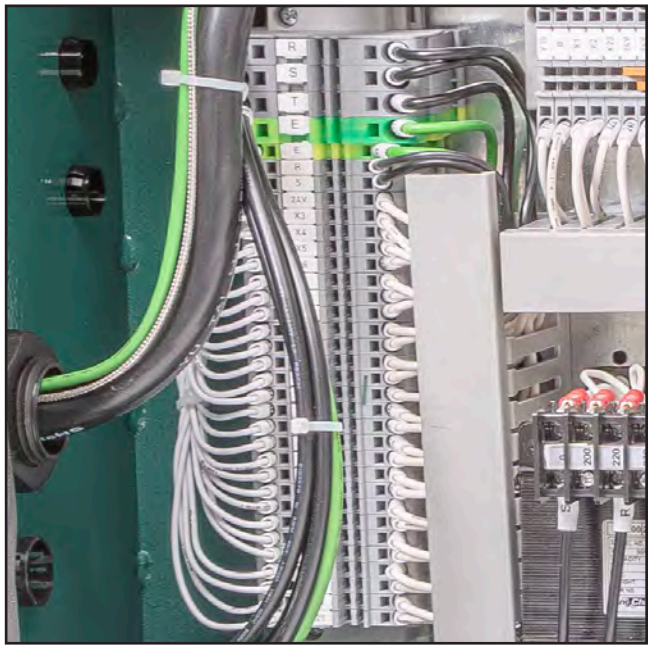

Figure 142. Terminal block (left).

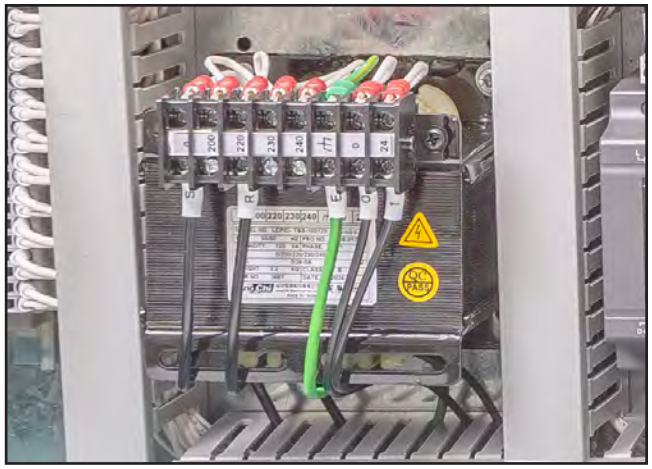

Figure 143. Transformer.

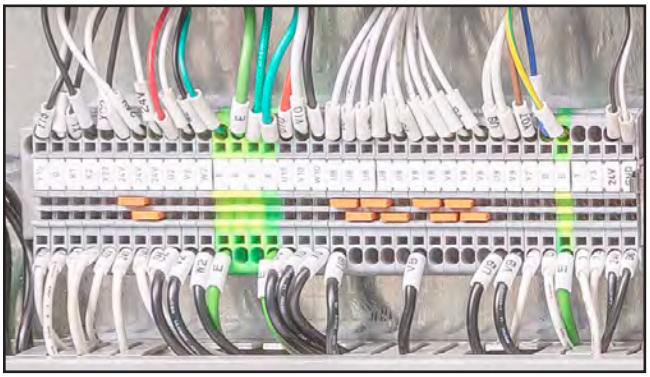

Figure 144. Terminal block (upper left).

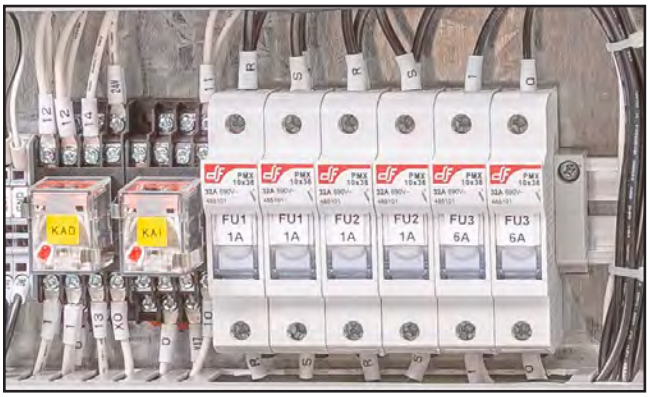

Figure 145. Relays and fuse holders (left).

Figure 146. Grounding terminal.

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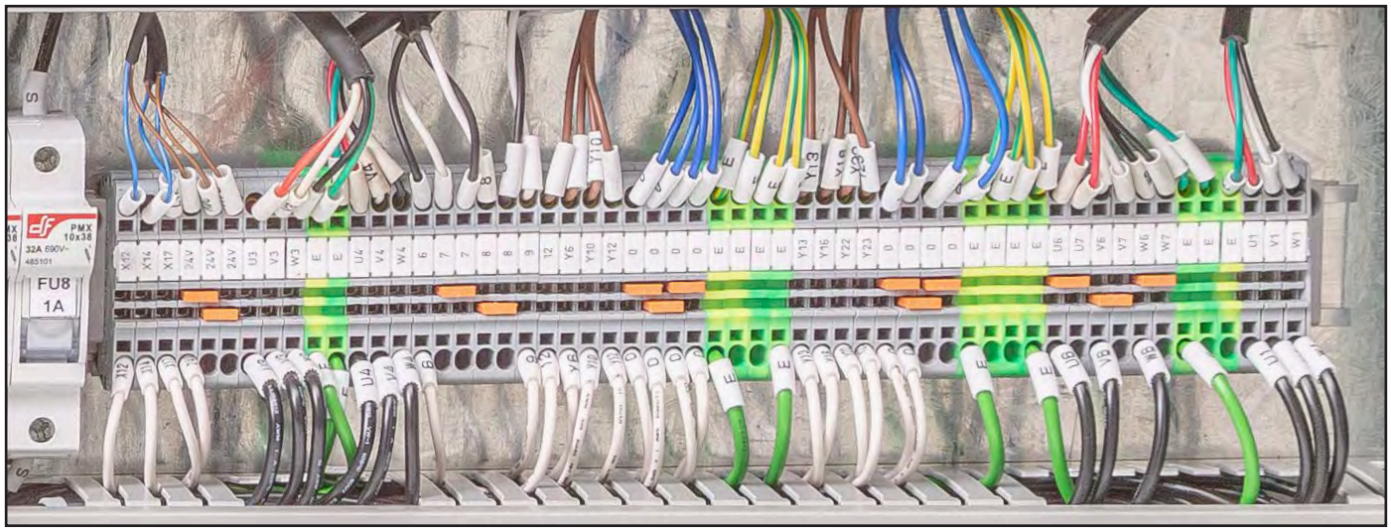


Figure 147. Terminal block (upper right).

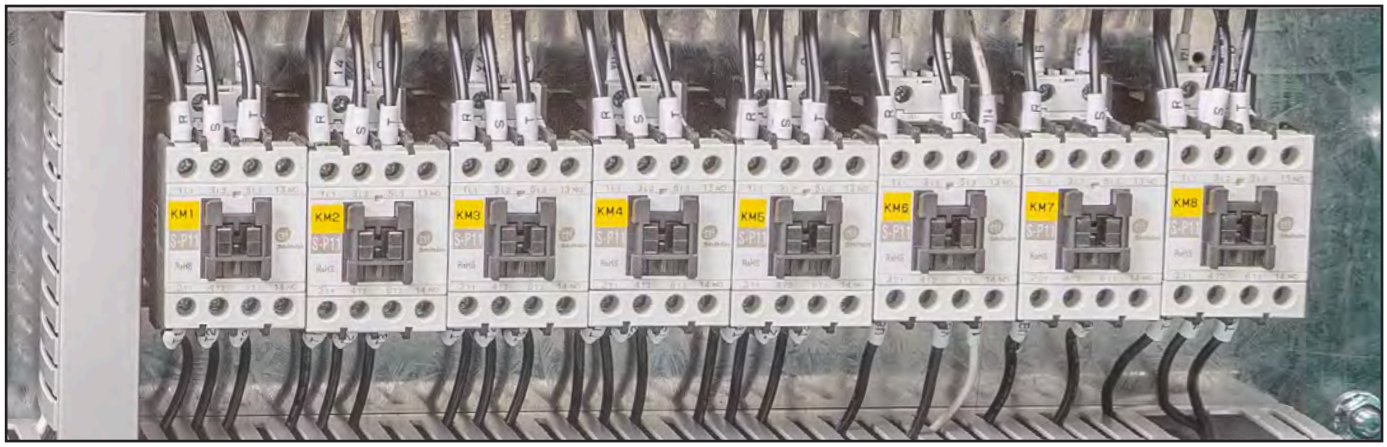


Figure 148. Contactors.

Figure 149. Fuse holders (right).

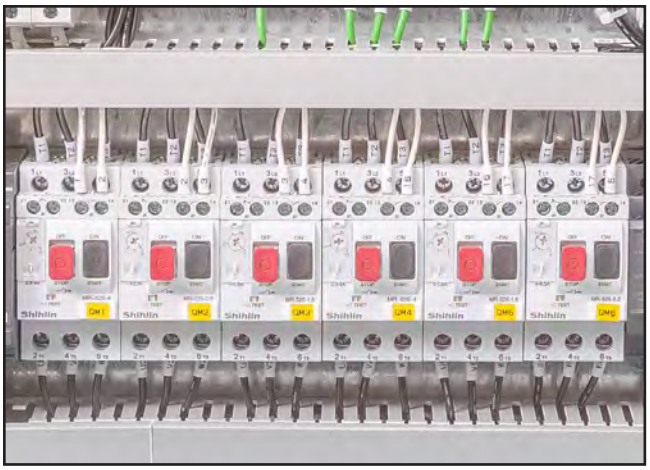


Figure 150. Motor starters.

Figure 151. PLC and PLC expansion module.

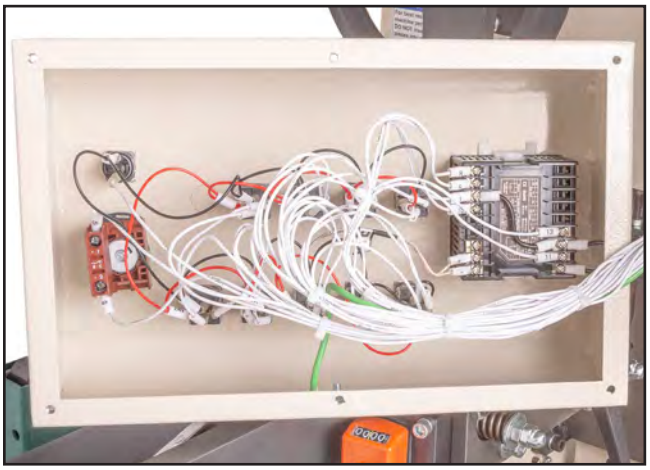


Figure 154. Control panel.

Figure 152. Pre-mill motor.

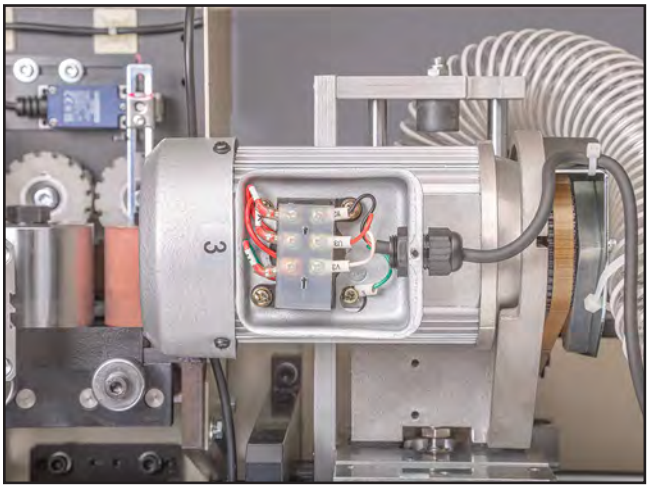


Figure 155. End trimmer motor.

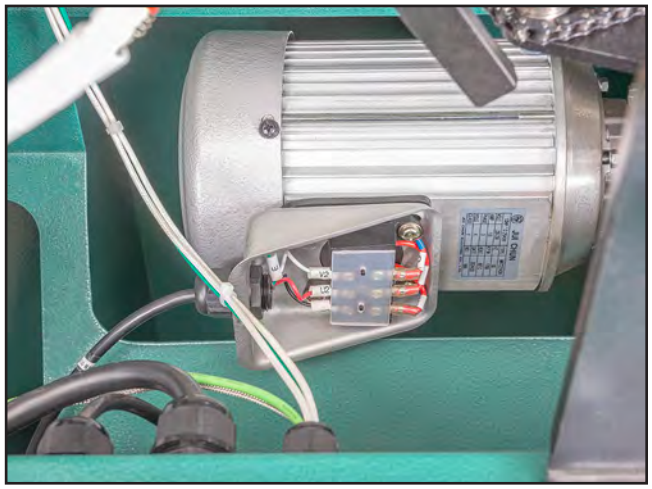


Figure 153. Glue spindle motor.

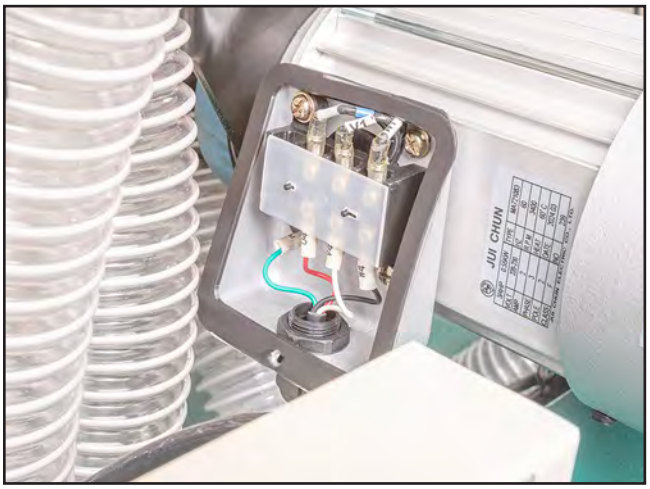


Figure 156. Flush trimmer motor.

STOP *READ ELECTRICAL SAFETY ON PAGE 79!*

Figure 157. Upper buffing motor.

Figure 158. Lower buffing motor.

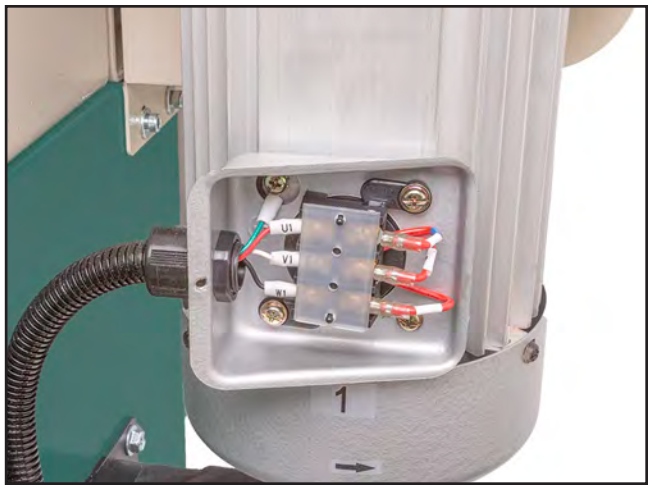


Figure 159. Conveyor motor.

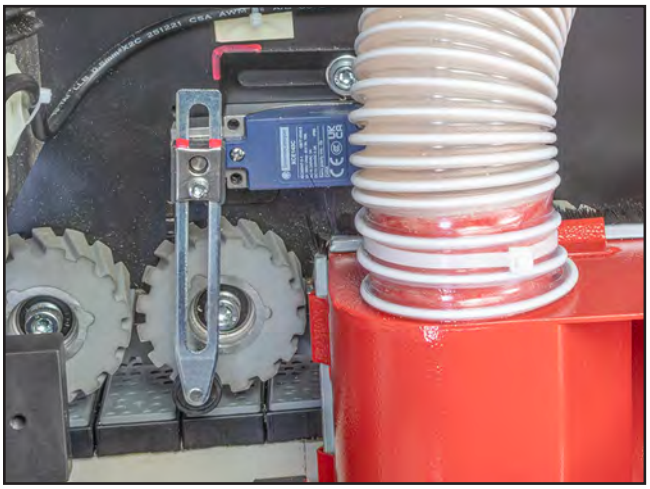


Figure 160. Pre-mill limit switch.

Figure 161. Edgebanding advancement/ guillotine limit switch.

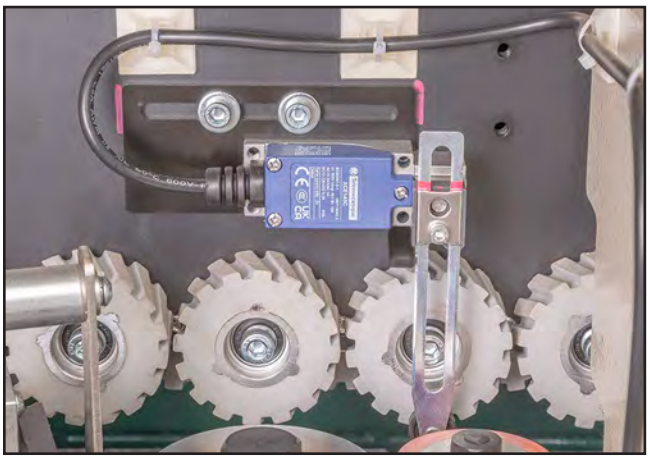
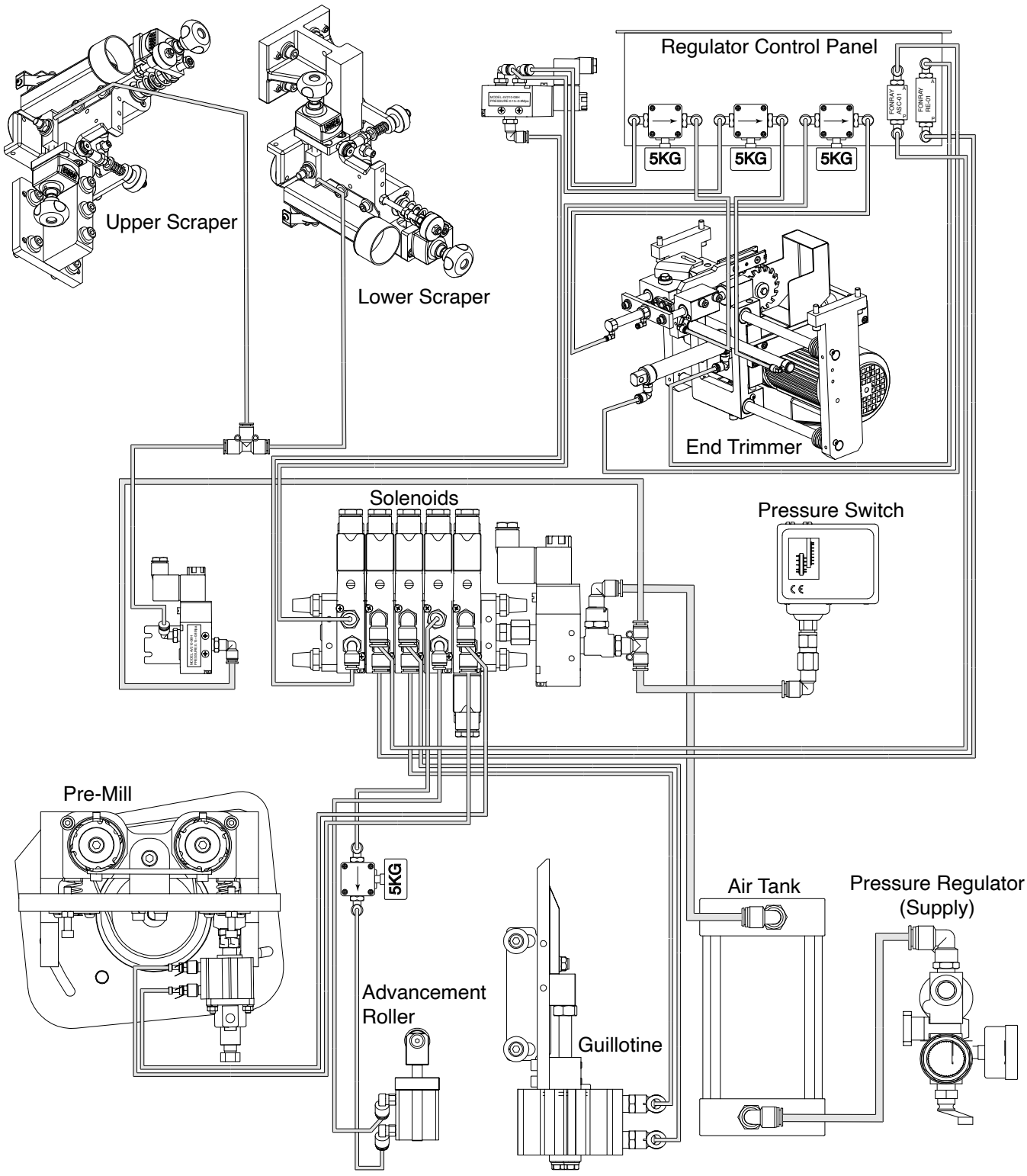


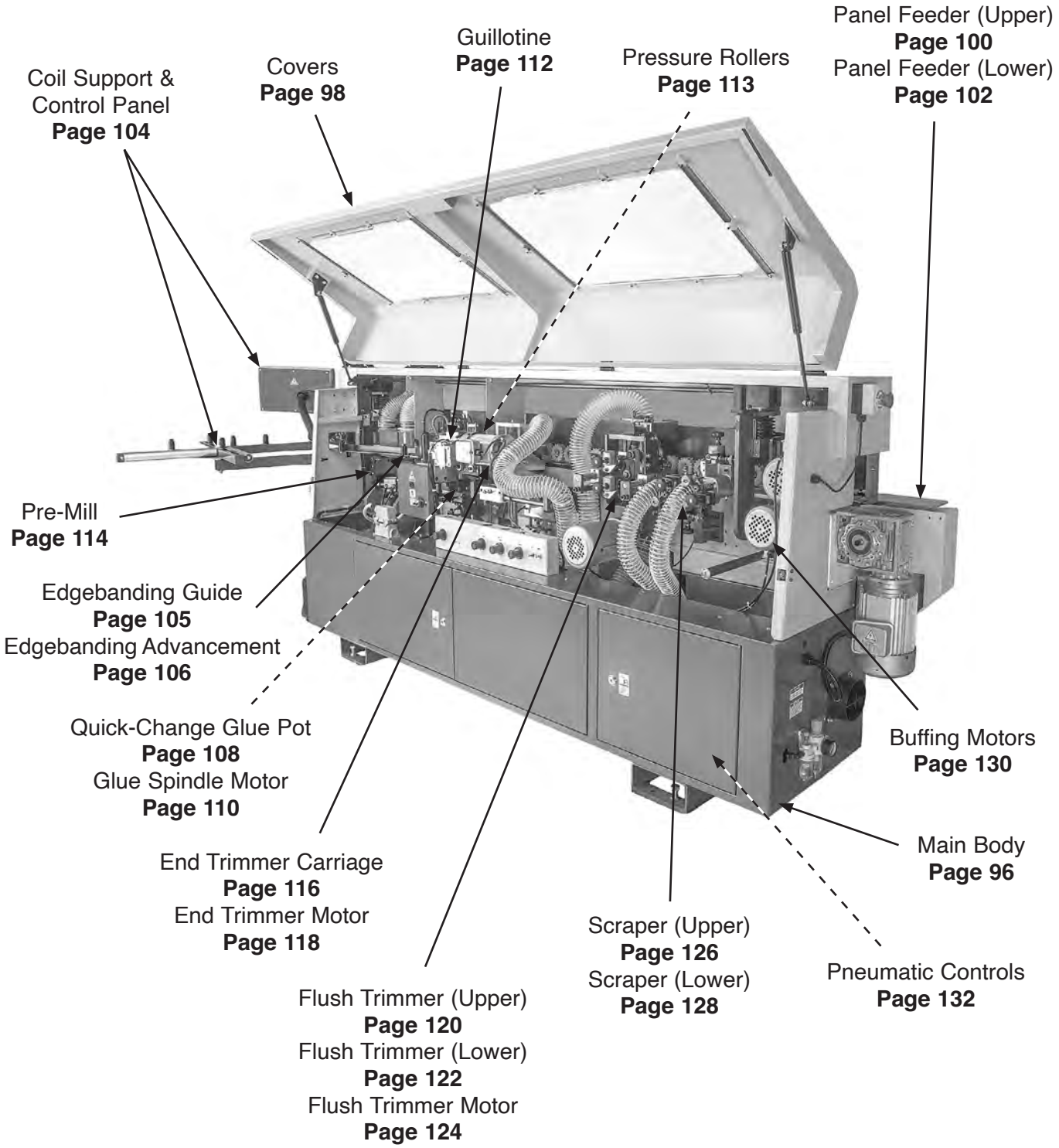
Figure 162. End trimmer limit switch.

Pneumatic Diagram

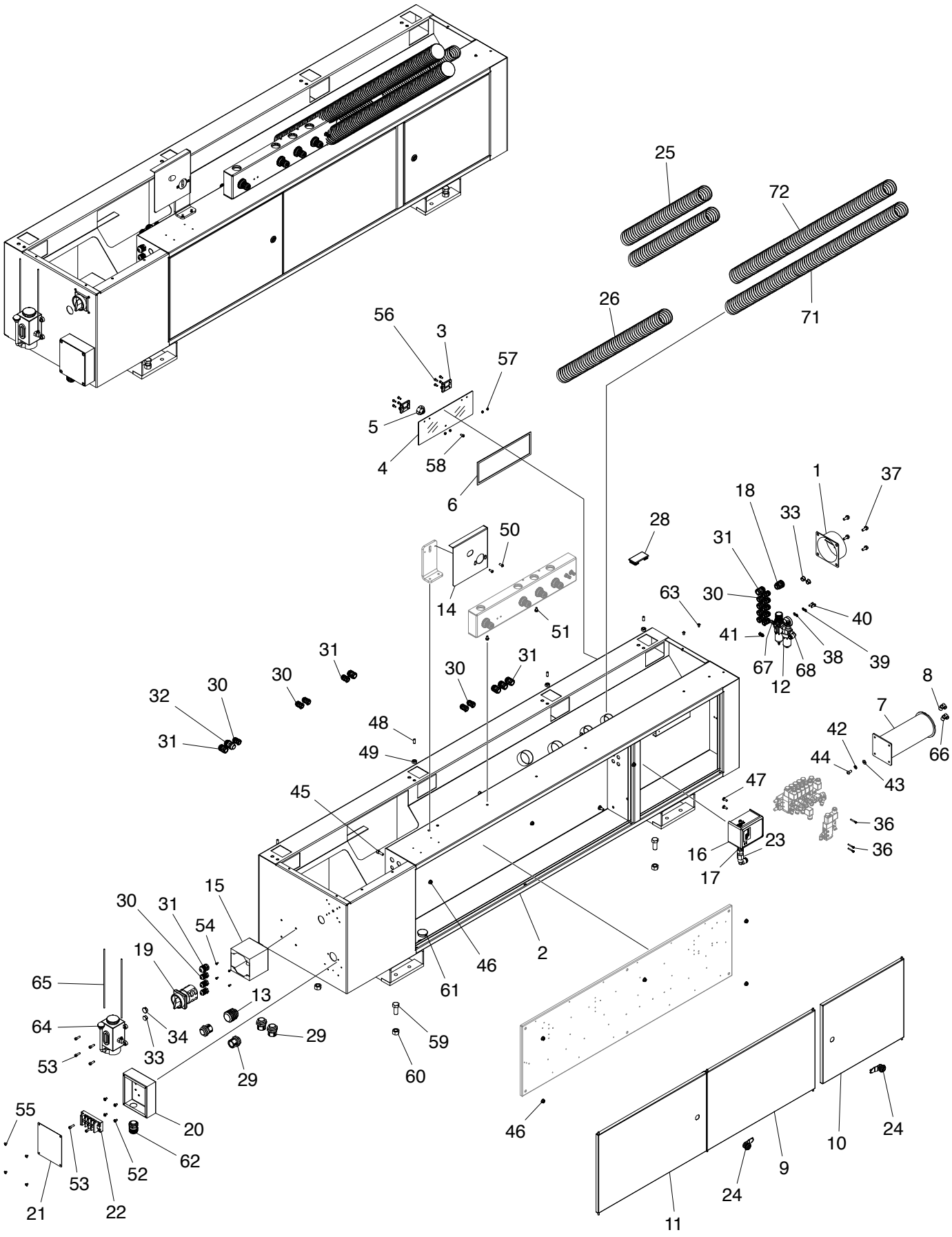


SECTION 9: PARTS

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.



Main Body

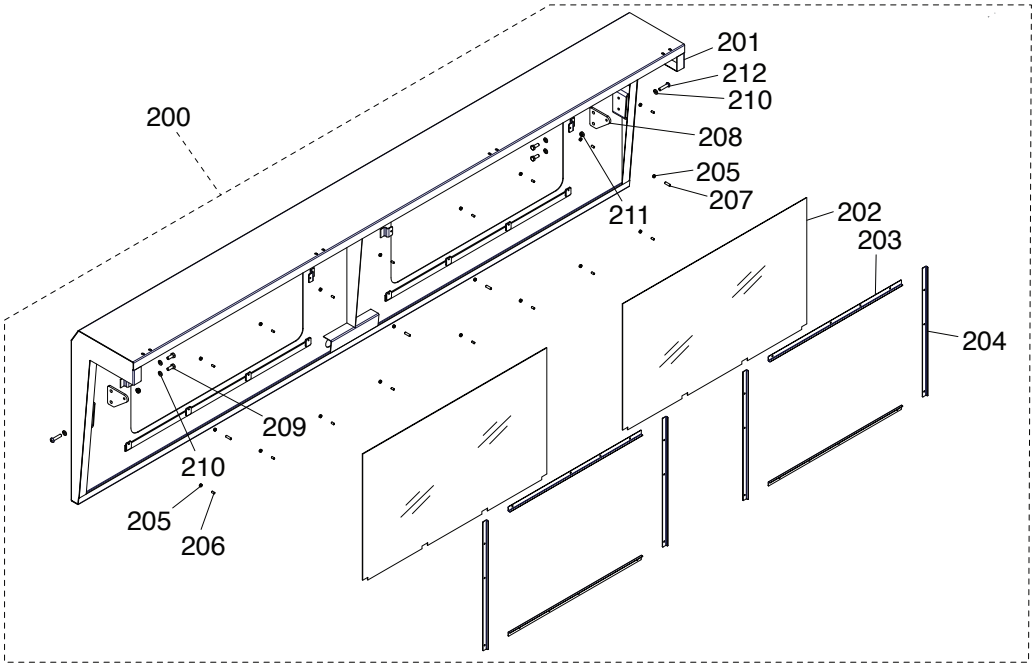


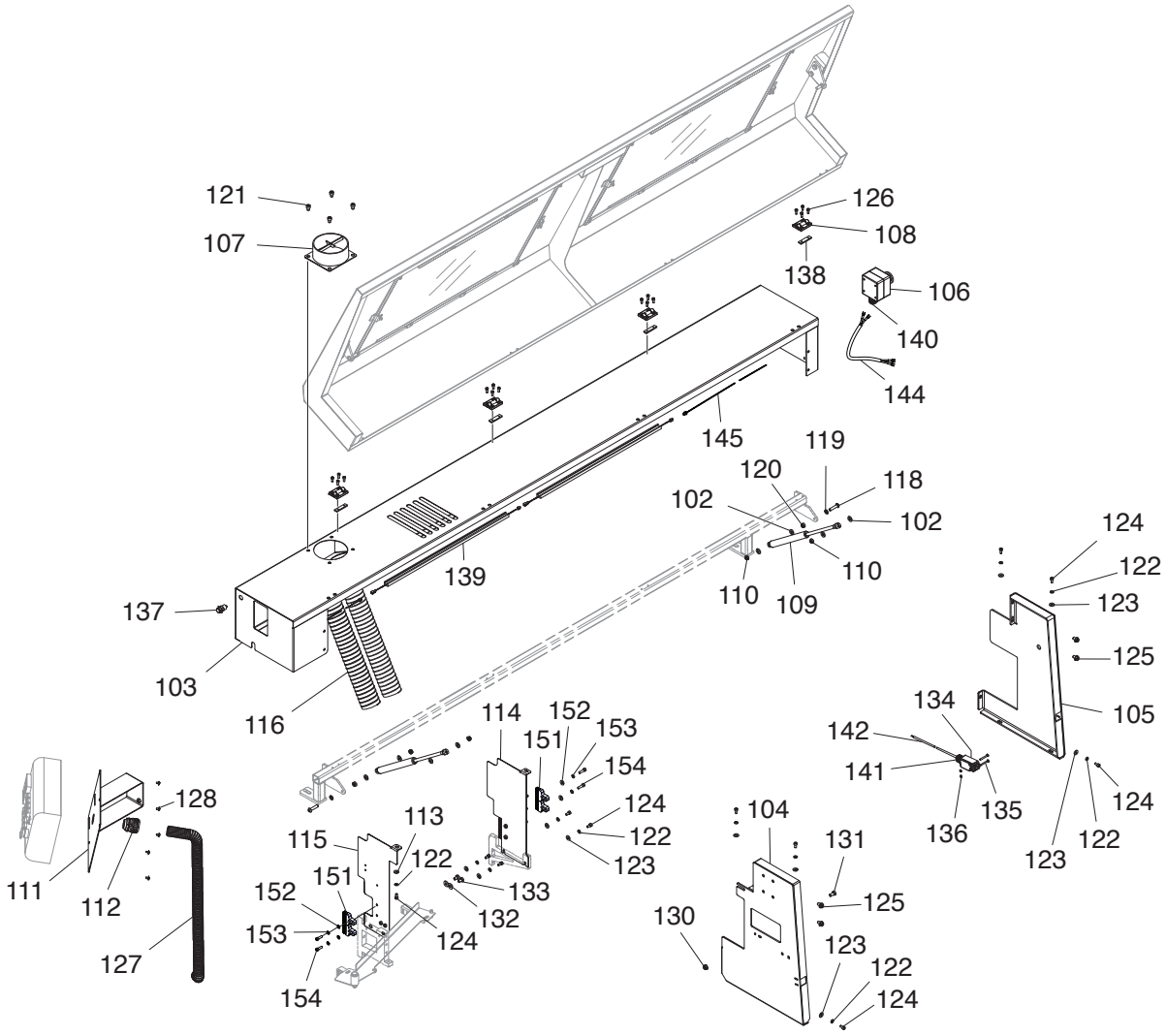
Main Body Parts List

REF	PART #	DESCRIPTION
1	P09850001	DUST PORT 5"
2	P09850002	CABINET BODY
3	P09850003	HINGE LY-4050
4	P09850004	COLLECTION DOOR, ACRYLIC
5	P09850005	KNOB M5-.8
6	P09850006	FOAM GASKET 2 X 7.5 X 300MM
7	P09850007	AIR TANK
8	P09850008	ELBOW PT3/8 37.4 X 45
9	P09850009	ELECTRICAL PANEL DOOR RIGHT
10	P09850010	PNEUMATIC CONTROL DOOR
11	P09850011	ELECTRICAL PANEL DOOR LEFT
12	P09850012	AIR REGULATOR ASSY FONRAY AFC2000A
13	P09850013	STRAIN RELIEF 32MM
14	P09850014	GLUE POT GUARD
15	P09850015	SWITCH BOX
16	P09850016	PRESSURE SWITCH ASSY DANFOSS KP36
17	P09850017	FITTING 7/16-20 UNF, PT1/4"
18	P09850018	STRAIN RELIEF 15MM
19	P09850019	ROTARY SWITCH AUSPICIOUS PS43
20	P09850020	MAIN POWER JUNCTION BOX
21	P09850021	COVER PLATE
22	P09850022	TERMINAL BAR 4P 60A
23	P09850023	ELBOW PT1/4 32.8 X 25.2
24	P09850024	DOOR LOCK
25	P09850025	DUST HOSE 2" X 27-1/2"
26	P09850026	DUST HOSE 2-1/2" X 19-5/8"
28	P09850028	SQUARE PLUG
29	P09850029	STRAIN RELIEF 25MM
30	P09850030	STRAIN RELIEF PG9
31	P09850031	STRAIN RELIEF PG13.5
32	P09850032	STRAIN RELIEF TYPE-3 M20
33	P09850033	HOLE PLUG 16MM
34	P09850034	HOLE PLUG 19MM
36	P09850036	PHLP HD SCR M4-.7 X 30

REF	PART #	DESCRIPTION
37	P09850037	FLANGE SCREW M8-1.25 X 20
38	P09850038	FLAT WASHER 6MM
39	P09850039	LOCK WASHER 6MM
40	P09850040	CAP SCREW M6-1 X 16
41	P09850041	FLANGE NUT M6-1
42	P09850042	LOCK WASHER 8MM
43	P09850043	FLAT WASHER 8MM
44	P09850044	BUTTON HD CAP SCR M8-1.25 X 16
45	P09850045	CAP SCREW M8-1.25 X 25
46	P09850046	FLANGE NUT M8-1.25
47	P09850047	PHLP HD SCR M4-.7 X 10
48	P09850048	SET SCREW M10-1.5 X 20
49	P09850049	HEX NUT M10-1.5
50	P09850050	BUTTON HD CAP SCR M6-1 X 16
51	P09850051	FLANGE SCREW M6-1 X 12
52	P09850052	PHLP HD SCR M6-1 X 10
53	P09850053	CAP SCREW M6-1 X 20
54	P09850054	PHLP HD SCR M4-.7 X 8
55	P09850055	PHLP HD SCR M5-.8 X 8
56	P09850056	CAP SCREW M5-.8 X 10
57	P09850057	LOCK NUT M5-.8
58	P09850058	CAP SCREW M5-.8 X 8
59	P09850059	HEX BOLT M16-2 X 40
60	P09850060	HEX NUT M16-2
61	P09850061	HOLE PLUG 38MM
62	P09850062	STRAIN RELIEF 21MM
63	P09850063	BUTTON HD CAP SCR M6-1 X 10
64	P09850064	ONE-SHOT OILER
65	P09850065	NYLON TUBE 4 X 2000MM
66	P09850066	ELBOW W/MESH PT3/8
67	P09850067	C-TYPE QUICK JOINT PT1/4
68	P09850068	ELBOW PT1/4 37.4 X 44
71	P09850071	DUST HOSE 2-1/2" X 57"
72	P09850072	DUST HOSE 2-1/2" X 49-1/8"

Covers



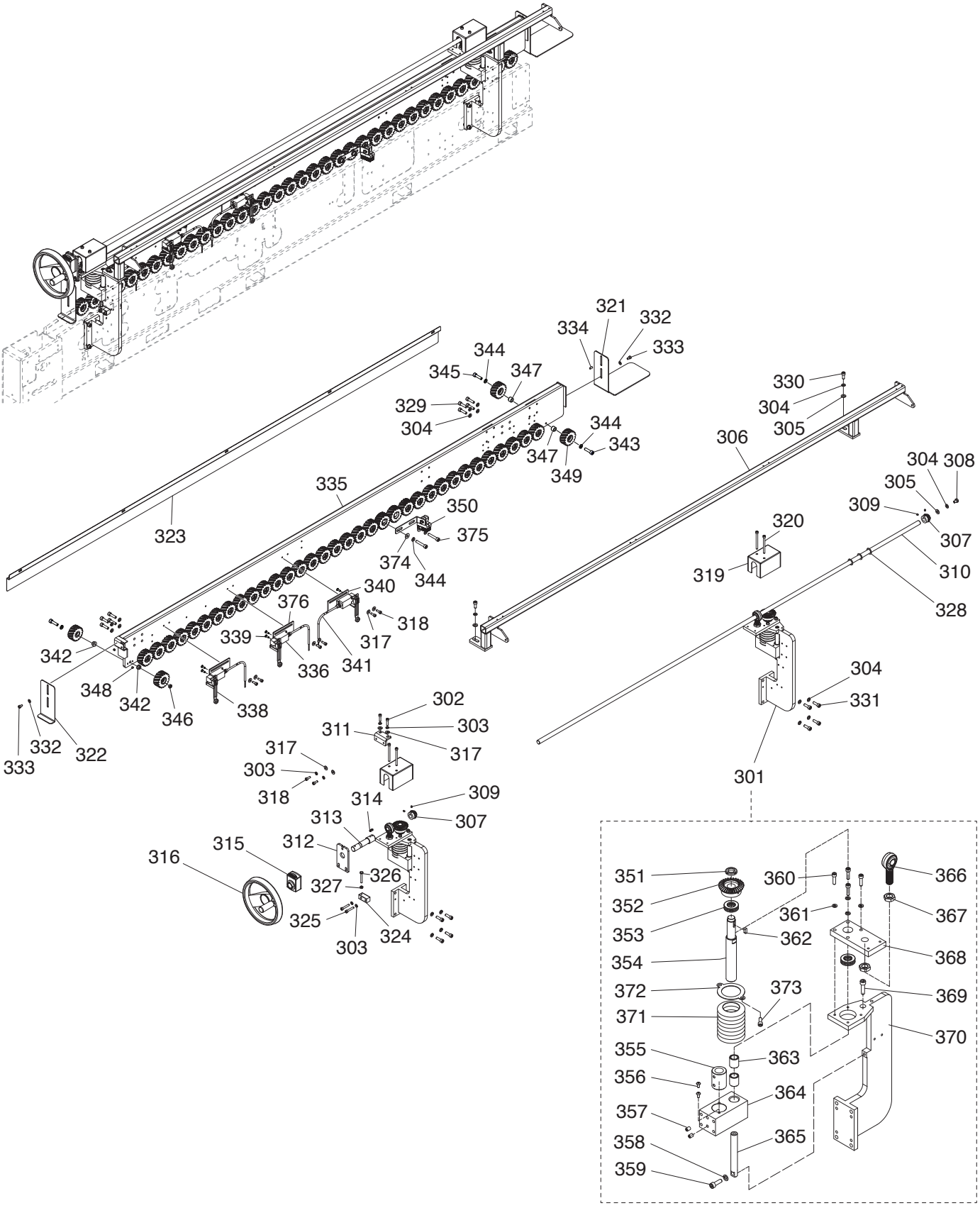


Covers Parts List

REF	PART #	DESCRIPTION
102	P09850102	FLAT WASHER 8MM
103	P09850103	TOP COVER
104	P09850104	SIDE PANEL, LEFT
105	P09850105	SIDE PANEL, RIGHT
106	P09850106	EMERGENCY STOP BUTTON SEB-E340
107	P09850107	DUST PORT 5"
108	P09850108	HINGE 40 X 50MM, ALUMINUM
109	P09850109	GAS STRUT 60KG
110	P09850110	LOCK NUT M8-1.25
111	P09850111	CONTROL PANEL MOUNTING BRACKET
112	P09850112	HOSE FITTING AVC N-MGQ32-34B
113	P09850113	FLAT WASHER 6MM
114	P09850114	DIVIDER PANEL, RIGHT
115	P09850115	DIVIDER PANEL, LEFT
116	P09850116	DUST HOSE 2-1/2" X 36"
118	P09850118	PHLP HD SCR M8-1.25 X 35
119	P09850119	LOCK WASHER 8MM
120	P09850120	HEX NUT M8-1.25
121	P09850121	FLANGE SCREW M8-1.25 X 10
122	P09850122	LOCK WASHER 6MM
123	P09850123	FLAT WASHER 6MM
124	P09850124	CAP SCREW M6-1 X 12
125	P09850125	PHLP HD SCR M8-1.25 X 12
126	P09850126	CAP SCREW M5-.8 X 12
127	P09850127	CORRUGATED TUBE 28 X 900MM
128	P09850128	PHLP HD SCR M5-.8 X 8
130	P09850130	FLANGE NUT M8-1.25
131	P09850131	HEX BOLT M8-1.25 X 16
132	P09850132	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
133	P09850133	HEX BOLT M8-1.25 X 12
134	P09850134	SAFETY SWITCH AZD-1001T
135	P09850135	PHLP HD SCR M4-.7 X 35
136	P09850136	HEX NUT M4-.7
137	P09850137	LED LAMP AH164-ZGE3 GRN
138	P09850138	HINGE MOUNTING PLATE
139	P09850139	LED LIGHT BAT090-101 24VDC
140	P09850140	STRAIN RELIEF PG11
141	P09850141	STRAIN RELIEF PG11
142	P09850142	CORD 24G 2W .5MM
144	P09850144	SWITCH CORD 24G 2W 75"
145	P09850145	LIGHT CORD W/CONNECTOR
151	P09850151	BRUSH
152	P09850152	CAP SCREW M6-1 X 20
153	P09850153	LOCK WASHER 6MM
154	P09850154	FLAT WASHER 6MM
200	P09850200	REAR COVER ASSEMBLY
201	P09850201	REAR COVER
202	P09850202	WINDOW, ACRYLIC
203	P09850203	WINDOW STOP, TOP/BOTTOM
204	P09850204	WINDOW STOP, SIDE
205	P09850205	HEX NUT M5-.8
206	P09850206	SET SCREW M5-.8 X 10
207	P09850207	SET SCREW M6-1 X 20
208	P09850208	STRUT SUPPORT BRACKET
209	P09850209	HEX BOLT M8-1.25 X 20
210	P09850210	LOCK WASHER 8MM
211	P09850211	LOCK NUT M8-1.25
212	P09850212	BUTTON HD CAP SCR M8-1.25 X 35

Panel Feeder (Upper)

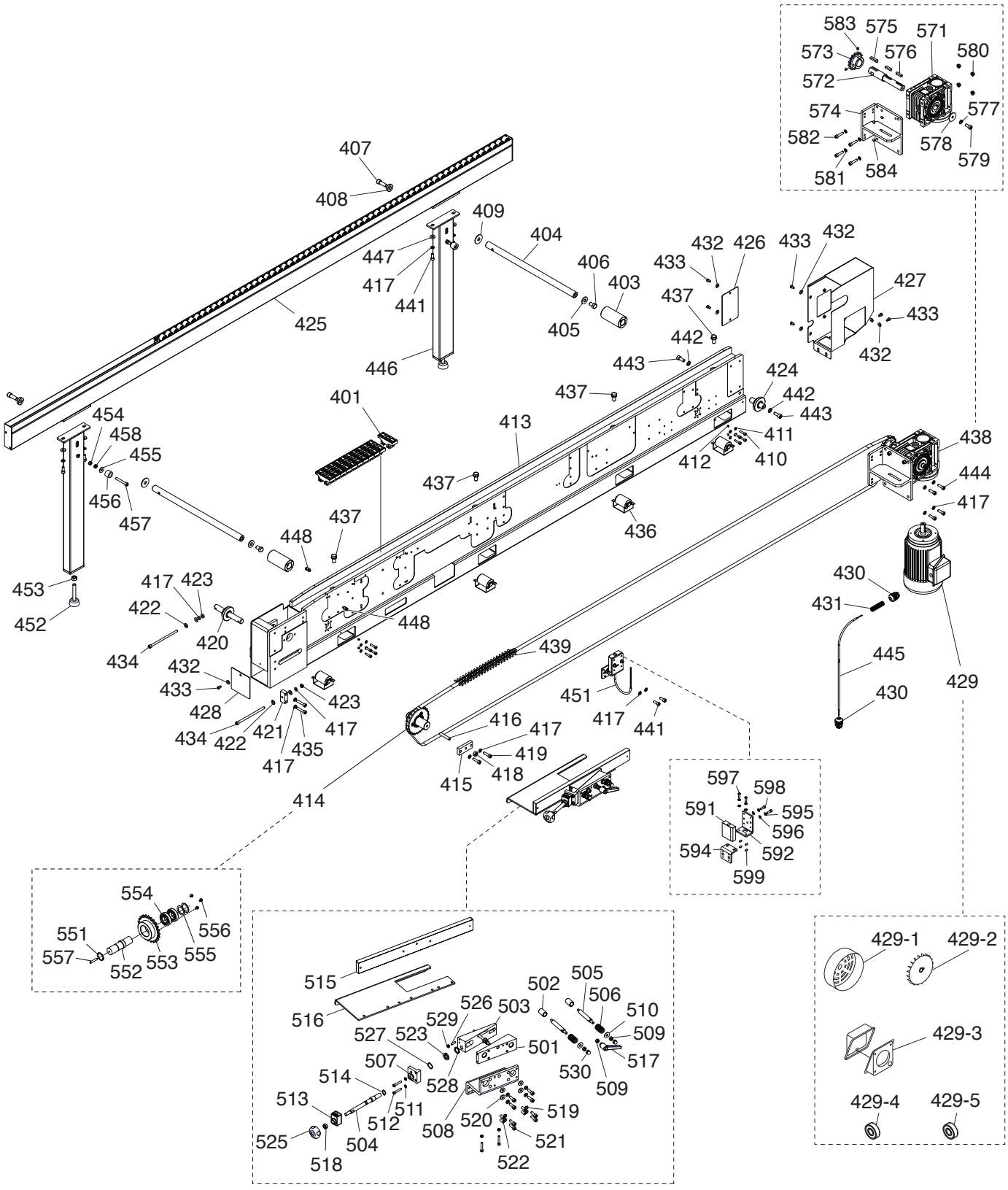


Panel Feeder (Upper) Parts List

REF	PART #	DESCRIPTION
301	P09850301	PRESSURE BEAM LIFTING ASSY
302	P09850302	CAP SCREW M6-1 X 25
303	P09850303	LOCK WASHER 6MM
304	P09850304	LOCK WASHER 8MM
305	P09850305	FLAT WASHER 8MM
306	P09850306	SUPPORT FRAME
307	P09850307	BEVEL GEAR 30T
308	P09850308	CAP SCREW M8-1.25 X 12
309	P09850309	SET SCREW M5-.8 X 6
310	P09850310	TRANSMISSION ROD
311	P09850311	L-BRACKET
312	P09850312	INDICATOR MOUNTING BRACKET
313	P09850313	CONNECTING SHAFT
314	P09850314	SET SCREW M6-1 X 5
315	P09850315	POSITION INDICATOR
316	P09850316	HANDWHEEL 8" W/HANDLE 20MM
317	P09850317	FLAT WASHER 6MM
318	P09850318	CAP SCREW M6-1 X 16
319	P09850319	GEAR COVER
320	P09850320	CAP SCREW M6-1 X 75
321	P09850321	SUPPORT PLATE, REAR
322	P09850322	SUPPORT PLATE, FRONT
323	P09850323	FRONT COVER PLATE
324	P09850324	STOP BLOCK
325	P09850325	CAP SCREW M6-1 X 35
326	P09850326	CAP SCREW M6-1 X 45
327	P09850327	HEX NUT M6-1
328	P09850328	FLAT WASHER 16MM
329	P09850329	CAP SCREW M8-1.25 X 30
330	P09850330	CAP SCREW M8-1.25 X 20
331	P09850331	CAP SCREW M8-1.25 X 25
332	P09850332	FLAT WASHER 6MM
333	P09850333	CAP SCREW M6-1 X 10
334	P09850334	SET SCREW M6-1 X 12
335	P09850335	PRESSURE BEAM
336	P09850336	LIMIT SWITCH XCE145C
338	P09850338	EXTENSION ARM W/WHEEL
339	P09850339	FLAT HD CAP SCR M5-.8 X 16

REF	PART #	DESCRIPTION
340	P09850340	ADJUSTABLE PLATE, RIGHT
341	P09850341	SWITCH CORD 24G 2W 82"
342	P09850342	FLANGE BUSHING 8 X 20 X 10.5MM
343	P09850343	CAP SCREW M8-1.25 X 30
344	P09850344	LOCK WASHER 8MM
345	P09850345	CAP SCREW M8-1.25 X 55
346	P09850346	LOCK NUT M8-1.25
347	P09850347	BUSHING 8 X 15 X 10.5
348	P09850348	SET SCREW M6-1 X 6
349	P09850349	ROLLER WHEEL 25 X 62MM
350	P09850350	BRUSH
351	P09850351	SPANNER NUT 0.664-32
352	P09850352	BEVEL GEAR 30T
353	P09850353	THRUST BEARING 51104
354	P09850354	ELEVATION SPINDLE
355	P09850355	SPINDLE BUSHING
356	P09850356	BUTTON HD CAP SCR M5-.8 X 10
357	P09850357	SET SCREW M8-1.25 X 8
358	P09850358	LOCK WASHER 8MM
359	P09850359	CAP SCREW M8-1.25 X 25
360	P09850360	CAP SCREW M6-1 X 25
361	P09850361	LOCK WASHER 6MM
362	P09850362	KEY 5 X 5 X 15
363	P09850363	BUSHING 16 X 22 X 25MM
364	P09850364	PRESSURE BEAM LIFTING BLOCK
365	P09850365	MANDREL
366	P09850366	TIE ROD END M16-1.25 X 45
367	P09850367	HEX NUT M16-1.25
368	P09850368	RISER BLOCK
369	P09850369	CAP SCREW M8-1.25 X 30
370	P09850370	COLUMN
371	P09850371	DUST COVER
372	P09850372	DUST COVER PLATE
373	P09850373	CAP SCREW M6-1 X 10
374	P09850374	FLAT WASHER 8MM
375	P09850375	CAP SCREW M8-1.25 X 45
376	P09850376	ADJUSTABLE PLATE, LEFT

Panel Feeder (Lower)

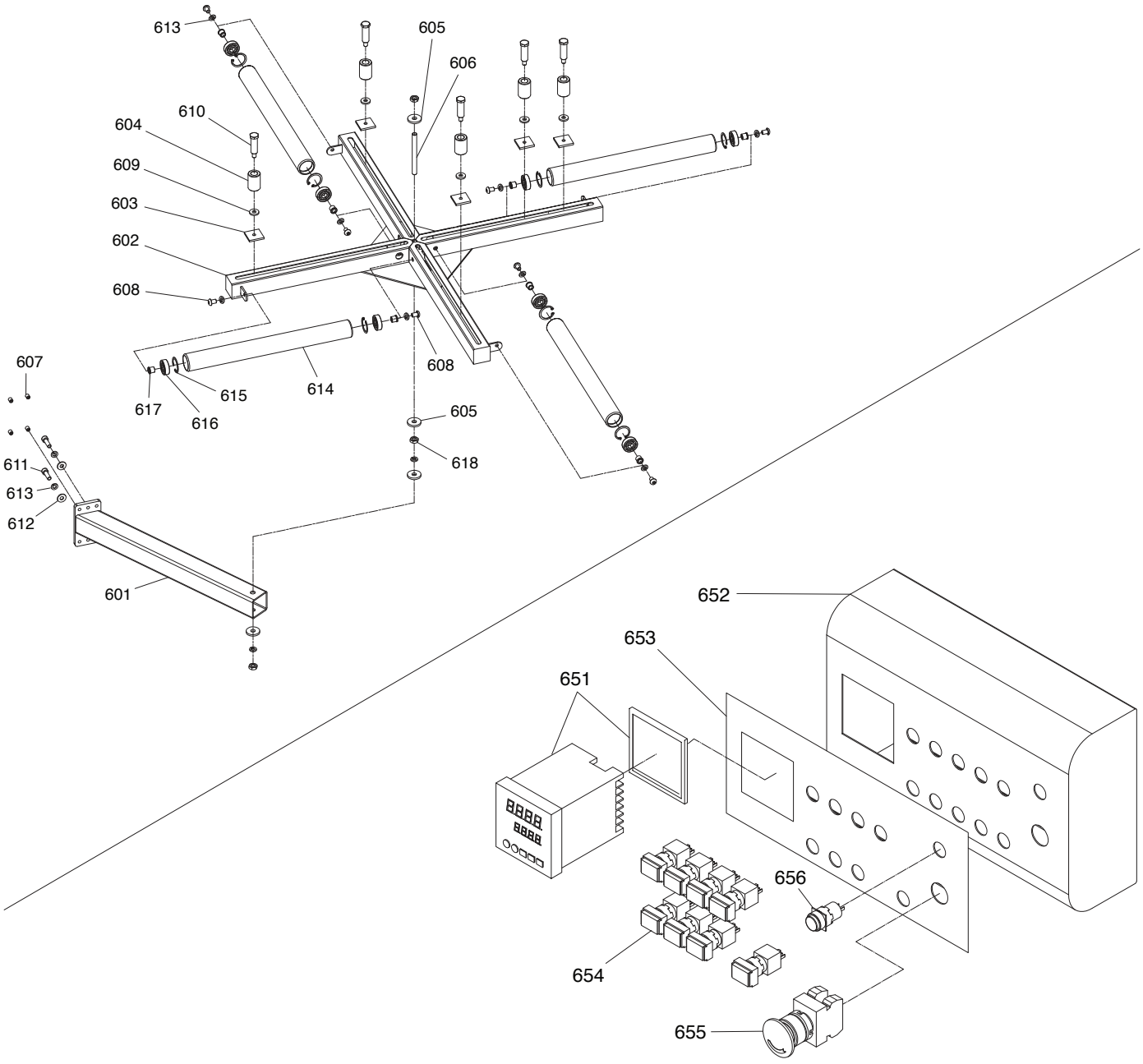


Panel Feeder (Lower) Parts List

REF	PART #	DESCRIPTION
401	P09850401	CONVEYOR LINK
403	P09850403	EXTENSION SLEEVE
404	P09850404	EXTENSION ROD
405	P09850405	FENDER WASHER 12MM
406	P09850406	HEX BOLT M12-1.75 X 20
407	P09850407	CAP SCREW M12-1.75 X 35
408	P09850408	SPACER 12 X 28 X 3MM
409	P09850409	FLAT WASHER 12MM
410	P09850410	CAP SCREW M6-1 X 25
411	P09850411	LOCK WASHER 6MM
412	P09850412	SET SCREW M6-1 X 6
413	P09850413	CONVEYOR BASE
414	P09850414	SPROCKET ASSEMBLY
415	P09850415	CHAIN ADJUSTMENT BLOCK
416	P09850416	SET SCREW M10-1.5 X 55
417	P09850417	LOCK WASHER 8MM
418	P09850418	HEX NUT M10-1.5
419	P09850419	CAP SCREW M8-1.25 X 30
420	P09850420	IDLER WHEEL, FRONT
421	P09850421	CHAIN ADJUSTMENT STOP BLOCK
422	P09850422	FLAT WASHER 8MM
423	P09850423	HEX NUT M8-1.25
424	P09850424	IDLER WHEEL, REAR
425	P09850425	EXTENSION FRAME
426	P09850426	ACCESS PLATE, REAR
427	P09850427	CONVEYOR END COVER
428	P09850428	ACCESS PLATE, FRONT
429	P09850429	MOTOR 1HP 220V 3-PH
429-1	P09850429-1	MOTOR FAN COVER
429-2	P09850429-2	MOTOR FAN
429-3	P09850429-3	MOTOR JUNCTION BOX
429-4	P09850429-4	BALL BEARING 6204ZZ, FRONT
429-5	P09850429-5	BALL BEARING 6203ZZ, REAR
430	P09850430	STRAIN RELIEF 16MM
431	P09850431	CONDUIT 12 X 1450MM
432	P09850432	FLAT WASHER 6MM
433	P09850433	CAP SCREW M6-1 X 10
434	P09850434	CAP SCREW M8-1.25 X 150
435	P09850435	CAP SCREW M8-1.25 X 40
436	P09850436	CONVEYOR ROLLER
437	P09850437	FLANGE BOLT M12-1.75 X 25
438	P09850438	GEAR REDUCER ASSEMBLY
439	P09850439	CONVEYOR CHAIN 10B-362
441	P09850441	CAP SCREW M8-1.25 X 20
442	P09850442	LOCK WASHER 10MM
443	P09850443	CAP SCREW M10-1.5 X 25
444	P09850444	CAP SCREW M8-1.25 X 25
445	P09850445	MOTOR CORD 20G 4W 57"
446	P09850446	EXTENSION LEG
447	P09850447	FLAT WASHER 8 X 20 X 3MM
448	P09850448	HOSE FITTING 4MM
451	P09850451	HEATING ROD 380V 125W
452	P09850452	ADJUSTABLE FOOT M12-1.75 X 75
453	P09850453	HEX NUT M12-1.75
454	P09850454	HEX NUT M8-1.25
455	P09850455	FLAT WASHER 8MM
456	P09850456	BUMPER, RUBBER
457	P09850457	CAP SCREW M8-1.25 X 55
458	P09850458	LOCK NUT M8-1.25

REF	PART #	DESCRIPTION
501	P09850501	WEDGE BLOCK, FIXED
502	P09850502	BUSHING 14 X 20 X 30
503	P09850503	WEDGE BLOCK, ADJUSTABLE
504	P09850504	ADJUSTMENT ROD
505	P09850505	FENCE DRAWBAR
506	P09850506	COMPRESSION SPRING 16 X 22 X 35
507	P09850507	FENCE INDICATOR MOUNTING BLOCK
508	P09850508	FENCE MOUNTING PLATE
509	P09850509	HEX NUT M8-1.25
510	P09850510	FLAT WASHER 8MM
511	P09850511	LOCK WASHER 6MM
512	P09850512	CAP SCREW M6-1 X 35
513	P09850513	FENCE POSITION INDICATOR
514	P09850514	EXT RETAINING RING 17MM
515	P09850515	FENCE
516	P09850516	TABLE
517	P09850517	ADJUSTABLE HANDLE 8MM
518	P09850518	HEX NUT M10-1.5
519	P09850519	LOCK WASHER 8MM
520	P09850520	FLAT WASHER 8 X 20 X 3MM
521	P09850521	CAP SCREW M8-1.25 X 25
522	P09850522	SET SCREW M8-1.25 X 20
523	P09850523	SPANNER NUT .664-32
525	P09850525	KNOB M10-1.5
526	P09850526	SET SCREW M6-1 X 25
527	P09850527	WAVY WASHER 20MM
528	P09850528	SPACER 20 X 30 X 0.5MM
529	P09850529	HEX NUT M6-1
530	P09850530	ACORN NUT M8-1.25
551	P09850551	INT RETAINING RING 30MM
552	P09850552	SHAFT
553	P09850553	SPROCKET 24T
554	P09850554	BALL BEARING 6006LLU
555	P09850555	SPACER
556	P09850556	FLANGE BOLT M5-.8 X 8
557	P09850557	SET SCREW M10-1.5 X 25
571	P09850571	GEAR REDUCER NMRV063
572	P09850572	GEAR REDUCER SHAFT
573	P09850573	SPROCKET 15T
574	P09850574	GEAR REDUCER MOUNTING BRACKET
575	P09850575	KEY 10 X 8 X 40
576	P09850576	KEY 8 X 7 X 35
577	P09850577	LOCK WASHER 10MM
578	P09850578	FLAT WASHER 10 X 40 X 3
579	P09850579	CAP SCREW M10-1.5 X 20
580	P09850580	FLANGE NUT M8-1.25
581	P09850581	LOCK WASHER 8MM
582	P09850582	CAP SCREW M8-1.25 X 35
583	P09850583	SET SCREW M8-1.25 X 8
584	P09850584	SET SCREW M8-1.25 X 10
591	P09850591	PREHEATING PLATE
592	P09850592	PREHEATING MOUNTING BRACKET, UPPER
594	P09850594	PREHEATING MOUNTING BRACKET, LOWER
595	P09850595	LOCK WASHER 6MM
596	P09850596	FLAT WASHER 6MM
597	P09850597	BUTTON HD CAP SCR M6-1 X 20
598	P09850598	CAP SCREW M6-1 X 20
599	P09850599	SET SCREW M6-1 X 10

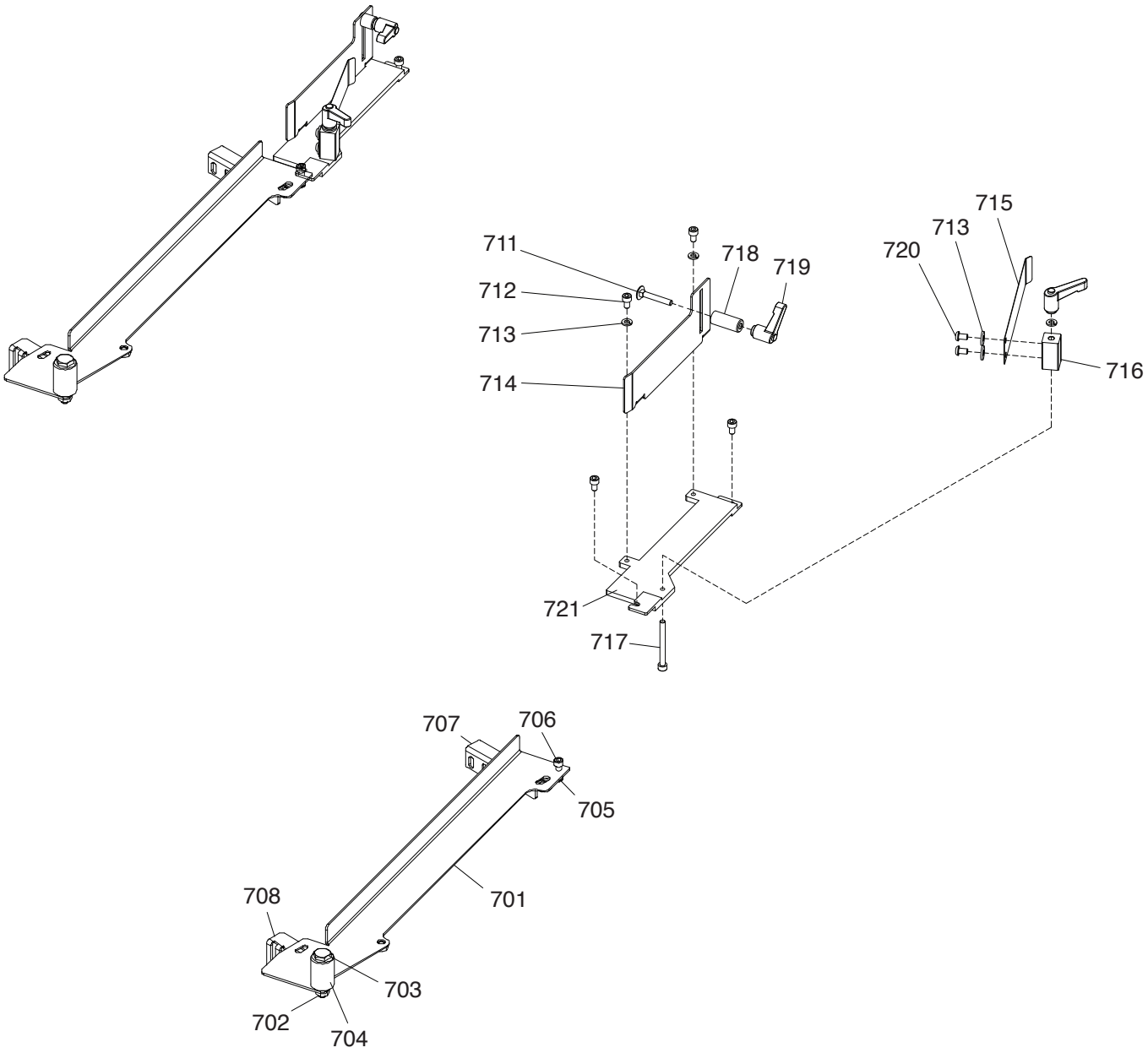
Coil Support & Control Panel



REF	PART #	DESCRIPTION
601	P09850601	SUPPORT ARM
602	P09850602	COIL SUPPORT
603	P09850603	T-SLOT NUT M8-1.25
604	P09850604	COIL GUIDE ROLLER 40 X 25MM
605	P09850605	FENDER WASHER 10MM
606	P09850606	STUD-FT M10-1.5 X 150
607	P09850607	SET SCREW M8-1.25 X 10
608	P09850608	BUTTON HD CAP SCR M8-1.25 X 16
609	P09850609	FLAT WASHER 8MM
610	P09850610	SHOULDER BOLT M8-1.25 X 12, 14 X 52MM
611	P09850611	CAP SCREW M8-1.25 X 20
612	P09850612	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
613	P09850613	LOCK WASHER 8MM
614	P09850614	COIL SUPPORT ROLLER
615	P09850615	INT RETAINING RING 32MM
616	P09850616	BALL BEARING 6201ZZ
617	P09850617	BEARING SPACER
618	P09850618	HEX NUT M10-1.5
651	P09850651	THERMOREGULATOR FOTEK NT-72RE
652	P09850652	CONTROL PANEL COVER
653	P09850653	CONTROL PANEL LABEL
654	P09850654	ON BUTTON FUJI AH164-TLG11E3 16MM
655	P09850655	E-STOP BUTTON REMY R2PNR4-1B-R 22MM
656	P09850656	STANDBY LIGHT FUJI AH164-ZRE3 16MM

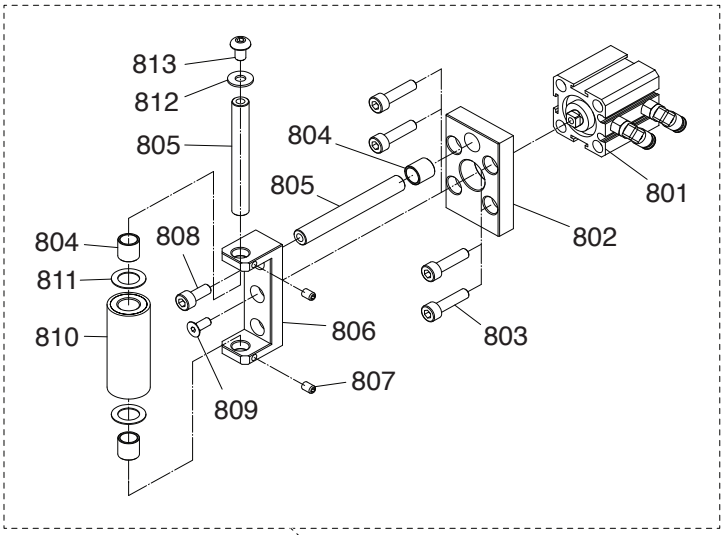
Edgebanding Guide

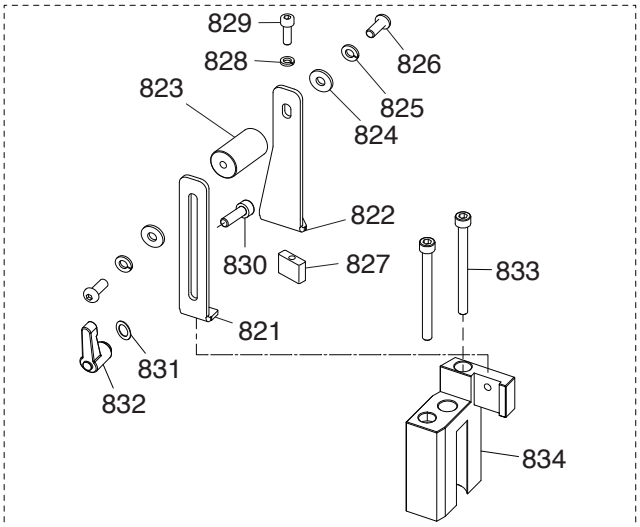


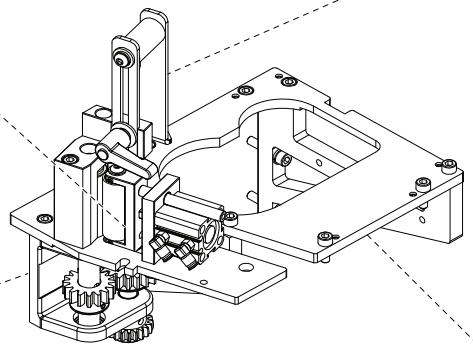
REF	PART #	DESCRIPTION
701	P09850701	GUIDE PLATE, LONG
702	P09850702	HEX NUT M8-1.25
703	P09850703	SHOULDER BOLT M8-1.25 X 12, 14 X 52MM
704	P09850704	COIL GUIDE ROLLER 40 X 25MM
705	P09850705	LOCK NUT M6-1
706	P09850706	CAP SCREW M6-1 X 20
707	P09850707	CONNECTING PLATE, LONG
708	P09850708	CONNECTING PLATE, SHORT
711	P09850711	CARRIAGE BOLT M6-1 X 25
712	P09850712	CAP SCREW M6-1 X 12

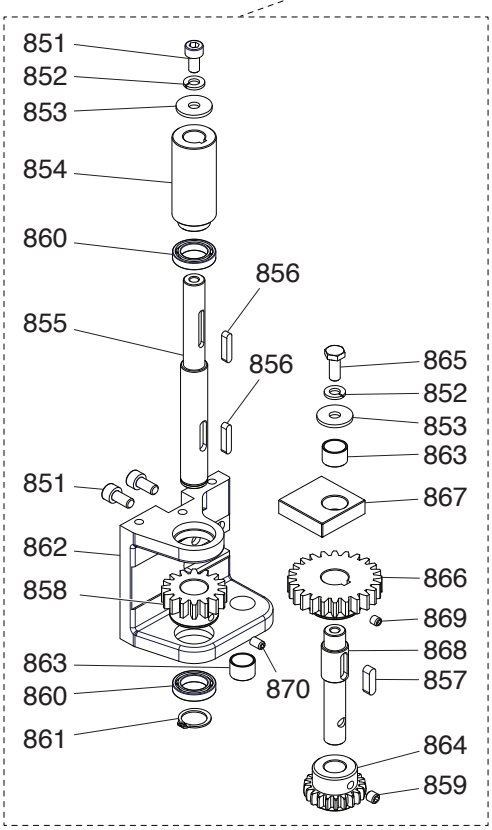
REF	PART #	DESCRIPTION
713	P09850713	LOCK WASHER 6MM
714	P09850714	GUIDE FENCE
715	P09850715	SPRING PLATE
716	P09850716	FIXED BLOCK
717	P09850717	CAP SCREW M6-1 X 55
718	P09850718	SPACER 6 X 15 X 15MM
719	P09850719	ADJUSTABLE HANDLE M6-1
720	P09850720	BUTTON HD CAP SCR M6-1 X 10
721	P09850721	GUIDE PLATE, SHORT

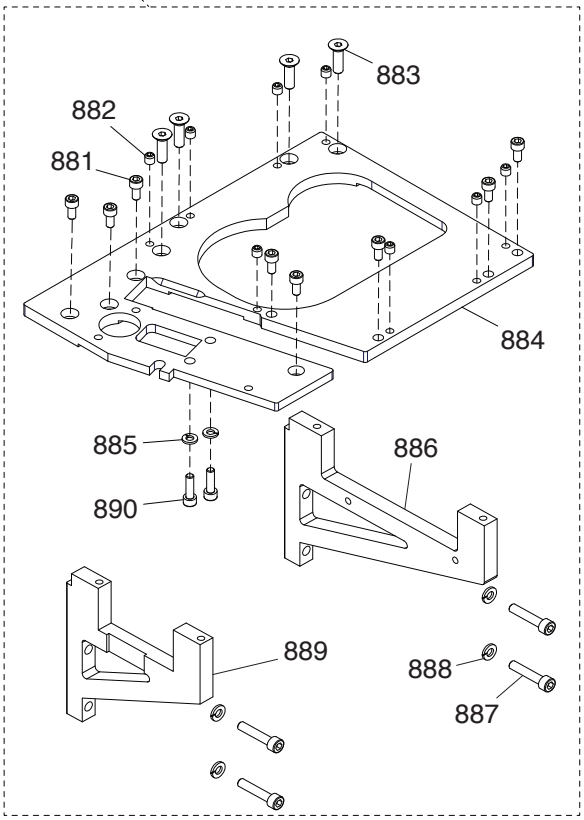
Edgebanding Advancement









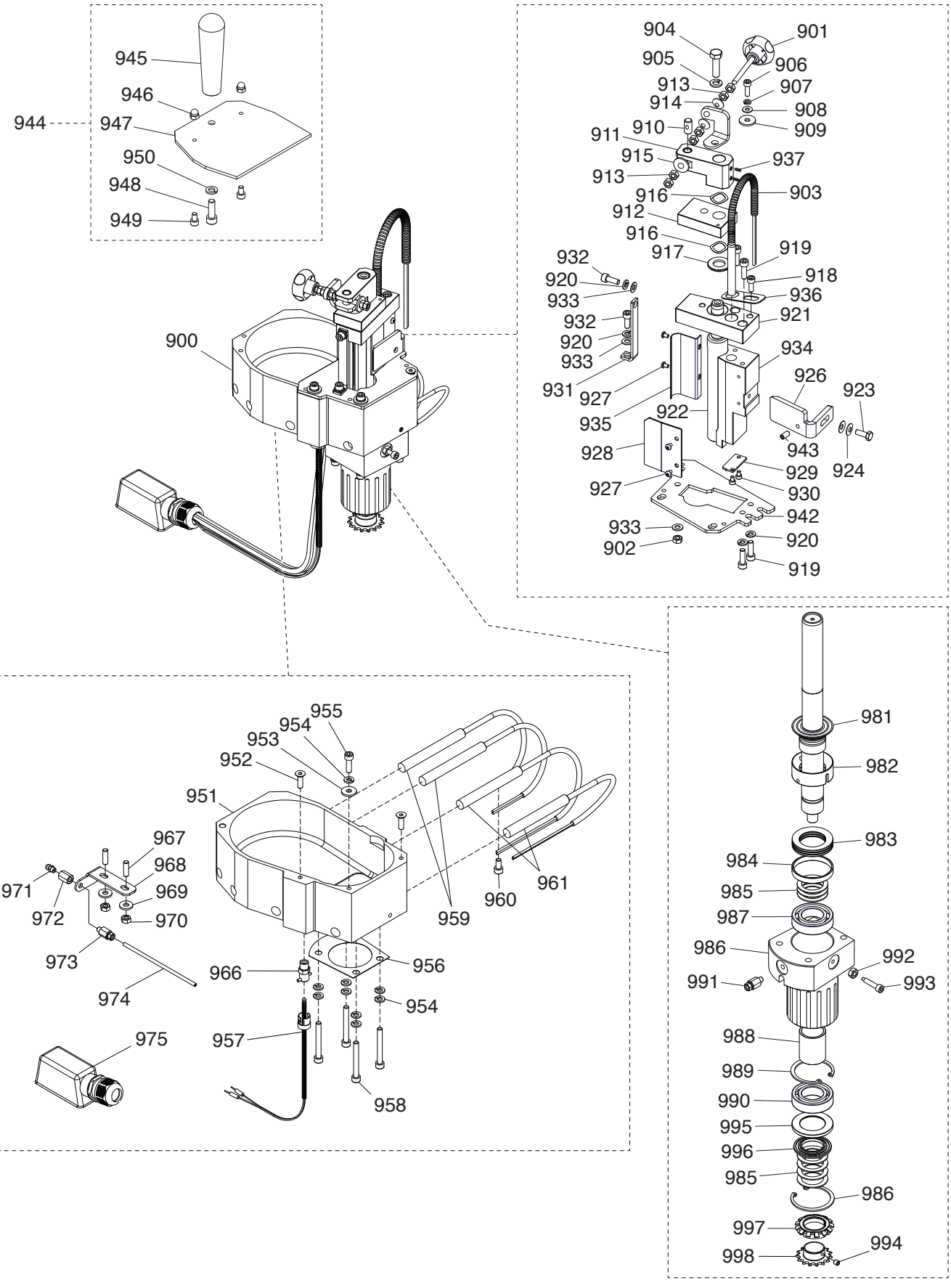


Edgebanding Advancement Parts List

REF	PART #	DESCRIPTION
801	P09850801	ADVANCEMENT CYLINDER
802	P09850802	CYLINDER MOUNTING BLOCK
803	P09850803	CAP SCREW M5-.8 X 16
804	P09850804	DRY BEARING 8 X 10MM, SLEEVE
805	P09850805	SLIDER SHAFT 8 X 65MM
806	P09850806	WHEEL BRACKET
807	P09850807	SET SCREW M4-.7 X 4
808	P09850808	CAP SCREW M5-.8 X 12
809	P09850809	FLAT HD CAP SCR M4-.7 X 10
810	P09850810	FEED ROLLER, NYLON
811	P09850811	FLAT WASHER 10 X 16 X 0.5MM
812	P09850812	FENDER WASHER 5 X 12 X 1MM
813	P09850813	BUTTON HD CAP SCR M5-.8 X 8
821	P09850821	ADJUSTMENT PLATE
822	P09850822	FIXED PLATE
823	P09850823	THREADED SPACER M6-1 X 20 X 36MM
824	P09850824	FLAT WASHER 6MM
825	P09850825	LOCK WASHER 6MM
826	P09850826	BUTTON HD CAP SCR M6-1 X 16
827	P09850827	EDGEBANDING LIMIT BLOCK
828	P09850828	LOCK WASHER 5MM
829	P09850829	CAP SCREW M5-.8 X 16
830	P09850830	CAP SCREW M6-1 X 20
831	P09850831	FLAT WASHER 6MM
832	P09850832	ADJUSTABLE HANDLE 6MM 42B
833	P09850833	CAP SCREW M6-1 X 70
834	P09850834	GUIDE BLOCK
851	P09850851	CAP SCREW M6-1 X 12
852	P09850852	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
853	P09850853	FLAT WASHER 6MM
854	P09850854	INFEED ROLLER, KNURLED
855	P09850855	INFEED ROLLER SHAFT
856	P09850856	KEY 4 X 4 X 20
857	P09850857	KEY 5 X 5 X 18
858	P09850858	GEAR 16T
859	P09850859	SET SCREW M6-1 X 6
860	P09850860	BALL BEARING 6802LLB
861	P09850861	EXT RETAINING RING 15MM
862	P09850862	INFEED ROLLER HOUSING
863	P09850863	BUSHING 12 X 10MM
864	P09850864	GEAR 21T
865	P09850865	HEX BOLT M6-1 X 16
866	P09850866	GEAR 24T
867	P09850867	FIXED BLOCK
868	P09850868	DRIVE SHAFT
869	P09850869	SET SCREW M5-.8 X 5
870	P09850870	SET SCREW M5-.8 X 8
881	P09850881	CAP SCREW M6-1 X 16
882	P09850882	SET SCREW M6-1 X 6
883	P09850883	FLAT HD CAP SCR M6-1 X 20
884	P09850884	INFEED PLATE
885	P09850885	LOCK WASHER 6MM
886	P09850886	INFEED PLATE BRACKET, SMALL
887	P09850887	CAP SCREW M6-1 X 30
888	P09850888	LOCK WASHER 6MM
889	P09850889	INFEED PLATE BRACKET, LARGE
890	P09850890	CAP SCREW M6-1 X 20

Quick-Change Glue Pot

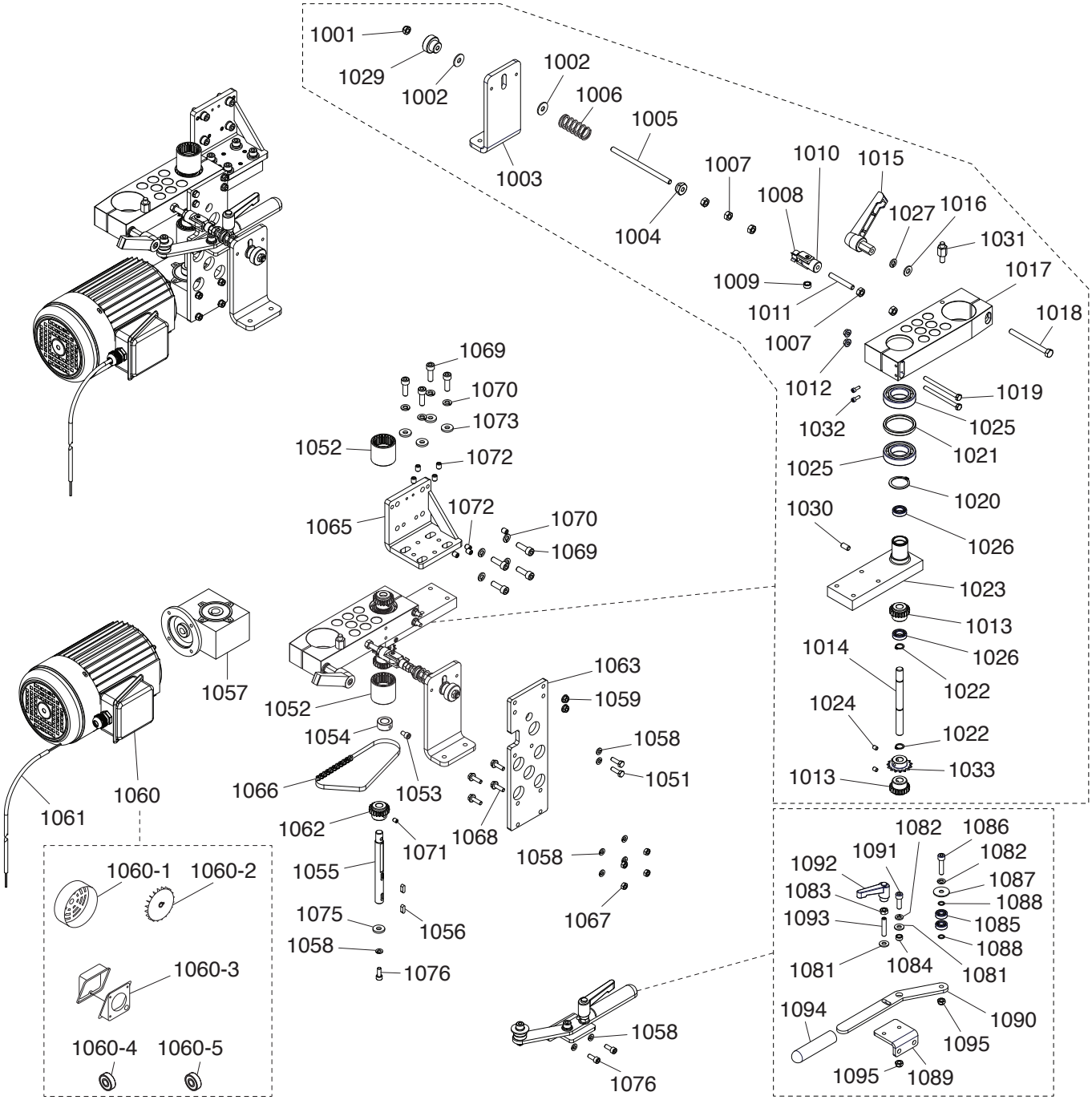


Quick-Change Glue Pot Parts List

REF	PART #	DESCRIPTION
900	P09850900	QUICK CHANGE GLUE POT ASSEMBLY
901	P09850901	KNOB BOLT M6-1 X 75
902	P09850902	HEX NUT M6-1
903	P09850903	GLUE SPINDLE HEATING ELEMENT
904	P09850904	HEX BOLT M8-1.25 X 30
905	P09850905	LOCK WASHER 8MM
906	P09850906	CAP SCREW M5-.8 X 16
907	P09850907	LOCK WASHER 5MM
908	P09850908	FLAT WASHER 5MM
909	P09850909	FLAT WASHER 6MM
910	P09850910	BLOCK PIN
911	P09850911	GLUE FLOW ADJUSTMENT BLOCK
912	P09850912	FIXED BLOCK
913	P09850913	HEX NUT M6-1
914	P09850914	BELLEVILLE WASHER 6MM
915	P09850915	FENDER WASHER 6MM
916	P09850916	WAVY WASHER 15 X 22MM
917	P09850917	SPACER 15 X 28 X 2.5MM
918	P09850918	CAP SCREW M8-1.25 X 10
919	P09850919	CAP SCREW M6-1 X 20
920	P09850920	LOCK WASHER 6MM
921	P09850921	GLUE SHAFT GUIDE BLOCK
922	P09850922	GLUE SHAFT
923	P09850923	HEX BOLT M6-1 X 16
924	P09850924	BELLEVILLE WASHER 6MM
926	P09850926	GUIDE PLATE
927	P09850927	BUTTON HD CAP SCR M4-.7 X 6
928	P09850928	COVER PLATE, FRONT
929	P09850929	COVER PLATE, BOTTOM
930	P09850930	CAP SCREW M4-.7 X 6
931	P09850931	SUPPORT BRACKET
932	P09850932	CAP SCREW M6-1 X 16
933	P09850933	FLAT WASHER 6MM
934	P09850934	ADJUSTMENT BASE
935	P09850935	COVER PLATE, SIDE
936	P09850936	HEATING ELEMENT MOUNTING PLATE
937	P09850937	SET SCREW M6-1 X 8
942	P09850942	GLUE POT COVER, FRONT
943	P09850943	SET SCREW M6-1 X 12
944	P09850944	GLUE POT LID ASSEMBLY
945	P09850945	HANDLE M8-1.25
946	P09850946	ACORN NUT M6-1
947	P09850947	GLUE POT LID

REF	PART #	DESCRIPTION
948	P09850948	CAP SCREW M8-1.25 X 25
949	P09850949	CAP SCREW M6-1 X 10
950	P09850950	LOCK WASHER 8MM
951	P09850951	GLUE POT
952	P09850952	FLAT HD CAP SCR M6-1 X 20
953	P09850953	FLAT WASHER 6MM
954	P09850954	LOCK WASHER 6MM
955	P09850955	CAP SCREW M6-1 X 20
956	P09850956	GASKET
957	P09850957	TEMPERATURE SENSOR WIRE K-TYPE 0.8MM
958	P09850958	CAP SCREW M6-1 X 50
959	P09850959	HEATING ELEMENT 722141B
960	P09850960	CAP SCREW M6-1 X 12
961	P09850961	HEATING ELEMENT 722140B
966	P09850966	CONNECTOR WY10
967	P09850967	SET SCREW M6-1 X 20
968	P09850968	GREASE FITTING MOUNTING PLATE
969	P09850969	FLAT WASHER 6MM
970	P09850970	HEX NUT M6-1
971	P09850971	GREASE FITTING 1/4-28 UNF STRAIGHT
972	P09850972	FITTING ADAPTER-FF 1/4-28 UNF
973	P09850973	HOSE FITTING 4MM
974	P09850974	TUBE 1/4OD X 12" COPPER
975	P09850975	QUICK CONNECTOR 16-PIN 400V 16A
981	P09850981	GLUE SPINDLE
982	P09850982	LOCK RING
983	P09850983	SPACER 46.5 X 3 X 0.6MM
984	P09850984	COLLAR
985	P09850985	SPACER 25 X 35 X 1MM
986	P09850986	GLUE SPINDLE BASE
987	P09850987	BALL BEARING 6005ZZ
988	P09850988	BUSHING
989	P09850989	EXT RETAINING RING 47MM
990	P09850990	BALL BEARING 6005ZZ
991	P09850991	HOSE FITTING 4MM
992	P09850992	HEX NUT M6-1
993	P09850993	CAP SCREW M6-1 X 25 DOG-PT
994	P09850994	SET SCREW M6-1 X 8
995	P09850995	EXTERNAL GASKET
996	P09850996	BEARING SEAL
997	P09850997	SPANNER NUT W/EXT TOOTH WASHER M25-1.5
998	P09850998	SPROCKET 10T

Glue Spindle Motor

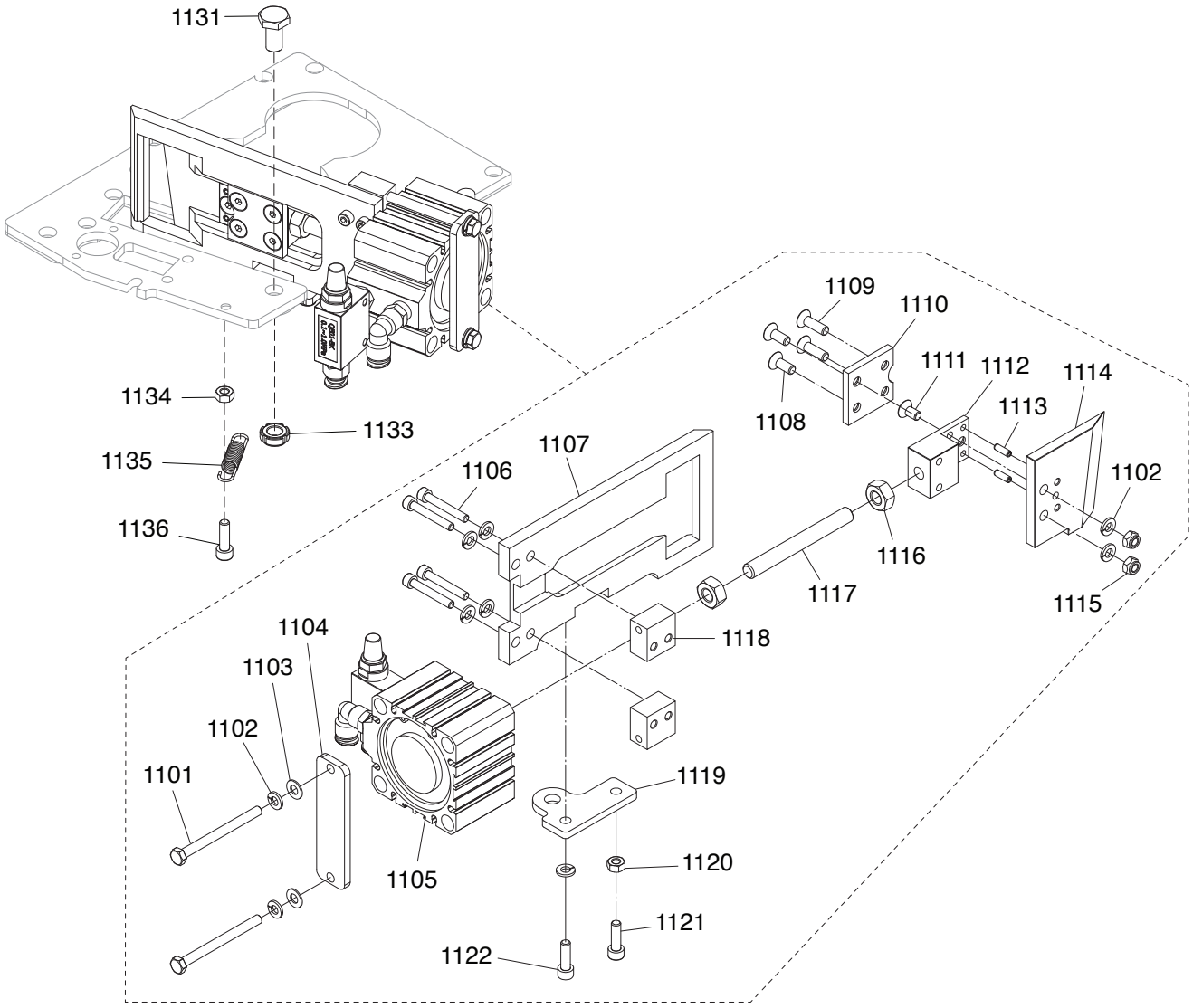


Glue Spindle Motor Parts List

REF	PART #	DESCRIPTION
1001	P09851001	LOCK NUT M8-1.25
1002	P09851002	FLAT WASHER 8MM
1003	P09851003	L-BRACKET
1004	P09851004	TENSION NUT M8-1.25
1005	P09851005	STUD-FT M8-1.25 X 140
1006	P09851006	COMPRESSION SPRING 1.7 X 18 X 45
1007	P09851007	HEX NUT M8-1.25
1008	P09851008	CLEVIS ROD END, DRIVING
1009	P09851009	BUSHING 8 X 12 X 6MM
1010	P09851010	CLEVIS ROD END
1011	P09851011	SET SCREW M8-1.25 X 25
1012	P09851012	FLANGE NUT M6-1
1013	P09851013	GEAR 21T
1014	P09851014	DRIVE SHAFT
1015	P09851015	ADJUSTABLE HANDLE M8-1.25 X 25
1016	P09851016	FLAT WASHER 8MM
1017	P09851017	GLUE POT BASE
1018	P09851018	HEX BOLT M8-1.25 X 90
1019	P09851019	HEX BOLT M6-1 X 80
1020	P09851020	EXT RETAINING RING 30MM
1021	P09851021	BEARING RING
1022	P09851022	EXT RETAINING RING 12MM
1023	P09851023	REDUCER BRACKET W/SHAFT
1024	P09851024	SET SCREW M6-1 X 8
1025	P09851025	BALL BEARING 6006ZZ
1026	P09851026	BALL BEARING 6901ZZ
1027	P09851027	LOCK WASHER 8MM
1029	P09851029	KNURLED KNOB 8MM
1030	P09851030	SET SCREW M8-1.25 X 16
1031	P09851031	STANDOFF-HEX MM M6-1 X 8
1032	P09851032	CAP SCREW M4-.7 X 12
1033	P09851033	SPROCKET 15T
1051	P09851051	HEX BOLT M6-1 X 20
1052	P09851052	SPINDLE CONNECTOR RING
1053	P09851053	CAP SCREW M6-1 X 10
1054	P09851054	BUSHING 14 X 25 X 12MM
1055	P09851055	DRIVE SHAFT
1056	P09851056	KEY 5 X 5 X 15

REF	PART #	DESCRIPTION
1057	P09851057	GEAR REDUCER
1058	P09851058	LOCK WASHER 6MM
1059	P09851059	FLANGE NUT M6-1
1060	P09851060	MOTOR 2HP 220V 3-PH
1060-1	P09851060-1	MOTOR FAN COVER
1060-2	P09851060-2	MOTOR FAN
1060-3	P09851060-3	MOTOR JUNCTION BOX
1060-4	P09851060-4	BALL BEARING 6203ZZ, FRONT
1060-5	P09851060-5	BALL BEARING 6202ZZ, REAR
1061	P09851061	MOTOR CORD 20G 4W 40"
1062	P09851062	GEAR 21T
1063	P09851063	CONNECTING PLATE
1065	P09851065	GLUE POT MOUNTING BRACKET
1066	P09851066	CHAIN 05B-54
1067	P09851067	HEX NUT M6-1
1068	P09851068	FLANGE BOLT M6-1 X 20
1069	P09851069	CAP SCREW M8-1.25 X 25
1070	P09851070	LOCK WASHER 8MM
1071	P09851071	SET SCREW M6-1 X 8
1072	P09851072	SET SCREW M8-1.25 X 10
1073	P09851073	FLAT WASHER 8 X 20 X 3MM
1075	P09851075	FLAT WASHER 6MM
1076	P09851076	CAP SCREW M6-1 X 16
1081	P09851081	FLAT WASHER 8MM
1082	P09851082	LOCK WASHER 8MM
1083	P09851083	HEX NUT M8-1.25
1084	P09851084	BUSHING 8 X 12 X 6MM
1085	P09851085	BALL BEARING 608ZZ
1086	P09851086	CAP SCREW M8-1.25 X 35
1087	P09851087	FENDER WASHER 8MM
1088	P09851088	FLAT WASHER 8 X 12 X 1MM
1089	P09851089	TENSION HANDLE MOUNTING PLATE
1090	P09851090	TENSION HANDLE
1091	P09851091	CAP SCREW M8-1.25 X 25
1092	P09851092	ADJUSTABLE HANDLE 8MM SS-160G
1093	P09851093	SET SCREW M8-1.25 X 40
1094	P09851094	HANDLE SLEEVE
1095	P09851095	LOCK NUT M8-1.25

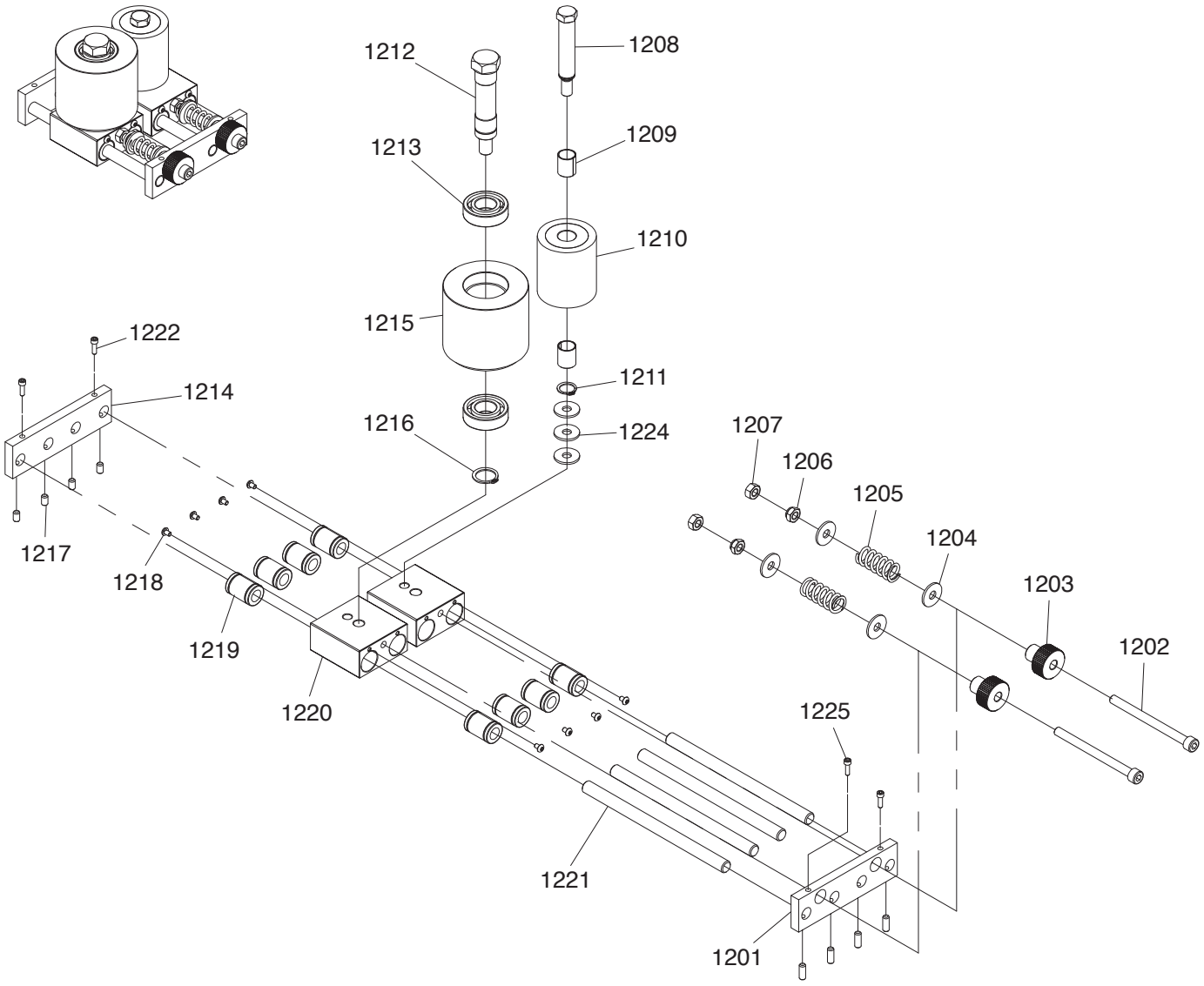
Guillotine



REF	PART #	DESCRIPTION
1101	P09851101	HEX BOLT M6-1 X 70
1102	P09851102	LOCK WASHER 6MM
1103	P09851103	FLAT WASHER 6MM
1104	P09851104	CYLINDER MOUNTING PLATE
1105	P09851105	PNEUMATIC CYLINDER ASSEMBLY
1106	P09851106	CAP SCREW M6-1 X 25
1107	P09851107	GUILLOTINE BLOCK
1108	P09851108	FLAT HD CAP SCR M6-1 X 20
1109	P09851109	FLAT HD CAP SCR M6-1 X 25
1110	P09851110	GUIDE
1111	P09851111	FLAT HD CAP SCR M6-1 X 12
1112	P09851112	BLADE BLOCK
1113	P09851113	ROLL PIN 4 X 12
1114	P09851114	GUILLOTINE BLADE

REF	PART #	DESCRIPTION
1115	P09851115	LOCK NUT M6-1
1116	P09851116	HEX NUT M10-1.5
1117	P09851117	SET SCREW M10-1.5 X 90
1118	P09851118	GUILLOTINE MOUNTING BLOCK
1119	P09851119	GUILLOTINE MOUNTING PLATE
1120	P09851120	HEX NUT M6-1
1121	P09851121	CAP SCREW M6-1 X 20
1122	P09851122	CAP SCREW M6-1 X 16
1131	P09851131	HEX BOLT M10-1.5 X 35
1133	P09851133	SPANNER LOCK NUT M10-1.75
1134	P09851134	HEX NUT M6-1
1135	P09851135	EXTENSION SPRING 1.6 X 10 X 41MM
1136	P09851136	CAP SCREW M6-1 X 20

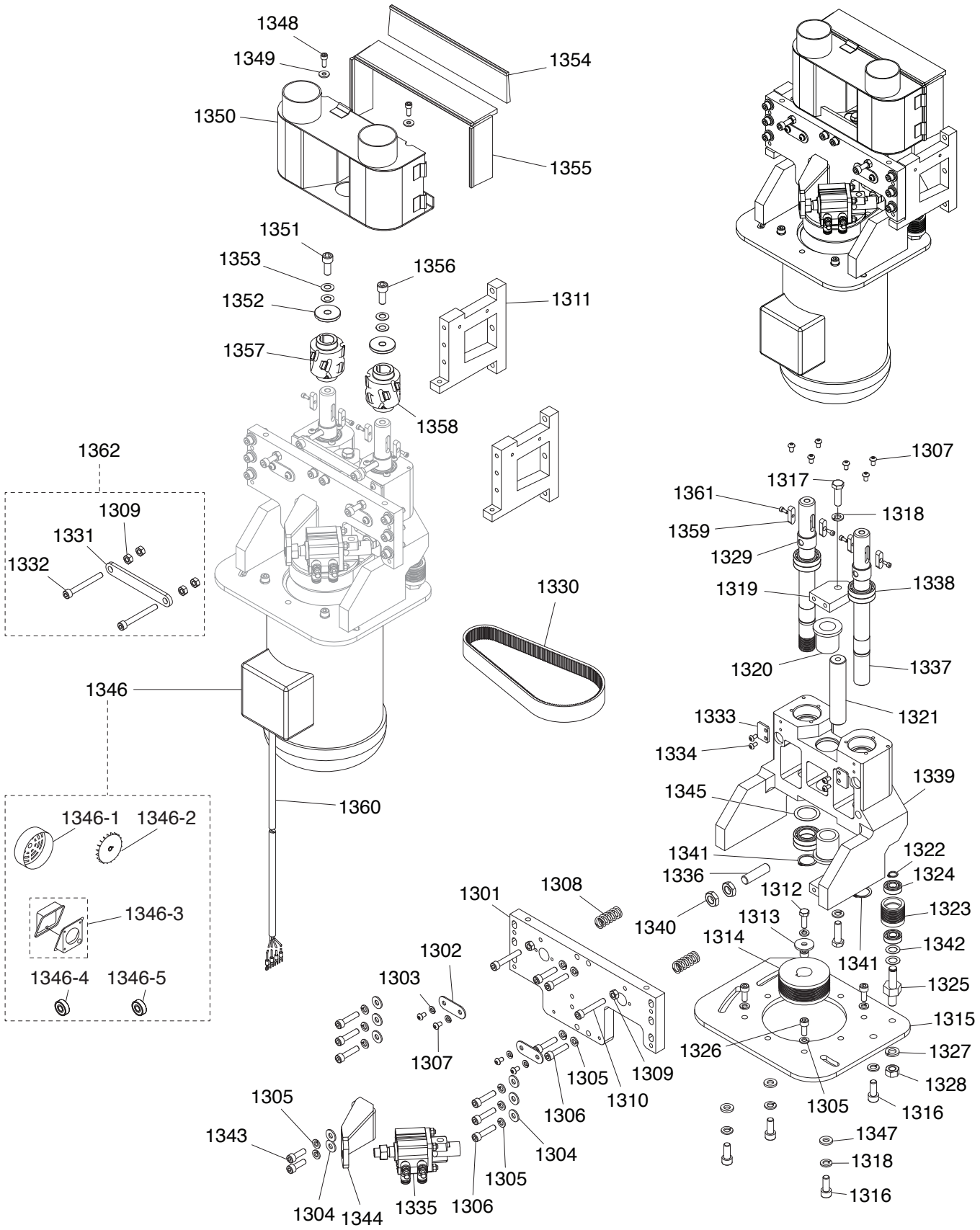
Pressure Rollers



REF	PART #	DESCRIPTION
1201	P09851201	SHAFT MOUNTING PLATE
1202	P09851202	CAP SCREW M8-1.25 X 100
1203	P09851203	KNURLED KNOB M8-1.25
1204	P09851204	FLAT WASHER 8MM
1205	P09851205	COMPRESSION SPRING 2.6 X 16 X 47MM
1206	P09851206	LOCK NUT M8-1.25
1207	P09851207	HEX NUT M8-1.25
1208	P09851208	ROLLER SHAFT M10-1.5 X 17, 15 X 66.5
1209	P09851209	DRY BEARING 15 X 20MM, SLEEVE
1210	P09851210	PRESSURE ROLLER, RUBBER
1211	P09851211	EXT RETAINING RING 15MM
1212	P09851212	ROLLER SHAFT M12-1.75 X 18, 19 X 76.5

REF	PART #	DESCRIPTION
1213	P09851213	BALL BEARING 6004LLU
1214	P09851214	MOUNTING PLATE
1215	P09851215	PRESSURE ROLLER, STEEL
1216	P09851216	EXT RETAINING RING 20MM
1217	P09851217	SET SCREW M6-1 X 10
1218	P09851218	BUTTON HD CAP SCR M6-.7 X 7
1219	P09851219	LINEAR BALL BEARING LM12UU
1220	P09851220	PRESSURE ROLLER MOUNTING BLOCK
1221	P09851221	SLIDER SHAFT 12 X 185MM
1222	P09851222	CAP SCREW M6-1 X 12
1224	P09851224	FLAT WASHER 10MM
1225	P09851225	CAP SCREW M6-1 X 16

Pre-Mill

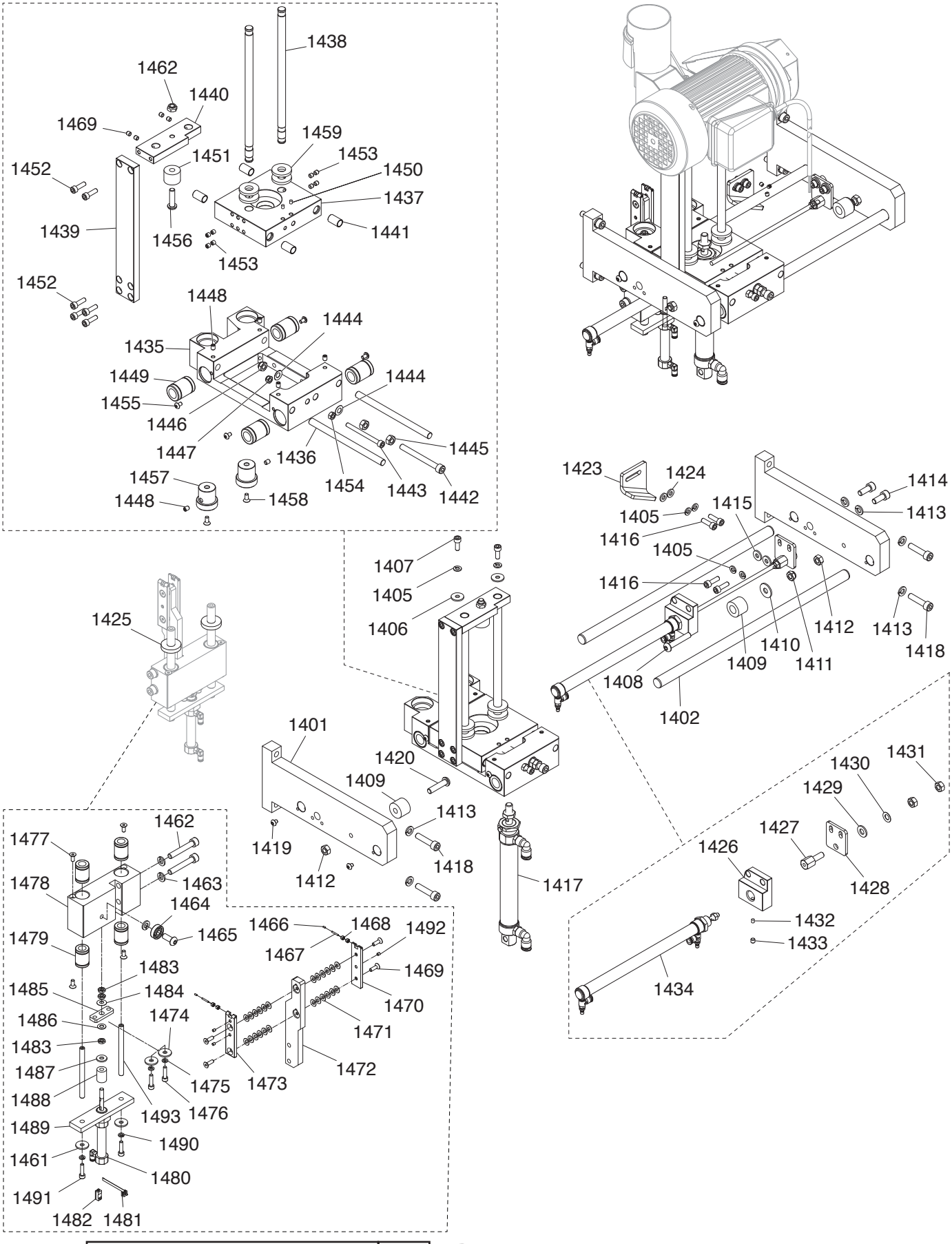


Pre-Mill Parts List

REF	PART #	DESCRIPTION
1301	P09851301	ADJUSTMENT PLATE
1302	P09851302	SPRING END PLATE
1303	P09851303	LOCK WASHER 6MM
1304	P09851304	FLAT WASHER 8MM
1305	P09851305	LOCK WASHER 8MM
1306	P09851306	CAP SCREW M8-1.25 X 35
1307	P09851307	BUTTON HD CAP SCR M6-1 X 10
1308	P09851308	COMPRESSION SPRING 2.6 X 16 X 47MM
1309	P09851309	HEX NUT M8-1.25
1310	P09851310	CAP SCREW M8-1.25 X 50
1311	P09851311	PRE-MILL ASSY MOUNTING BRACKET
1312	P09851312	HEX BOLT M8-1.25 X 25
1313	P09851313	FLAT WASHER 8MM
1314	P09851314	MOTOR PULLEY
1315	P09851315	MOTOR MOUNT
1316	P09851316	CAP SCREW M10-1.5 X 25
1317	P09851317	HEX BOLT M10-1.5 X 35
1318	P09851318	LOCK WASHER 10MM
1319	P09851319	ROTATION BLOCK
1320	P09851320	FLANGED BUSHING 25 X 35 X 40MM
1321	P09851321	ROTATION SHAFT
1322	P09851322	EXT RETAINING RING 12MM
1323	P09851323	IDLER PULLEY
1324	P09851324	BALL BEARING 6001LLU
1325	P09851325	IDLER PULLEY ECCENTRIC SHAFT
1326	P09851326	CAP SCREW M8-1.25 X 20
1327	P09851327	LOCK WASHER 12MM
1328	P09851328	HEX NUT M12-1.75
1329	P09851329	SPINDLE, FRONT
1330	P09851330	POLY RIBBED BELT 240J10
1331	P09851331	SPINDLE LOCK TOOL PLATE
1332	P09851332	CAP SCREW M8-1.25 X 70
1333	P09851333	STOP PLATE
1334	P09851334	BUTTON HD CAP SCR M5-.8 X 10

REF	PART #	DESCRIPTION
1335	P09851335	PNEUMATIC CYLINDER ASSEMBLY
1336	P09851336	STUD-FT M14-1.5 X 50
1337	P09851337	SPINDLE, REAR
1338	P09851338	BALL BEARING 6905LLB
1339	P09851339	PRE-MILL BASE
1340	P09851340	HEX NUT M14-1.5, THIN
1341	P09851341	EXT RETAINING RING 25MM
1342	P09851342	FLAT WASHER 13 X 22 X 0.5MM
1343	P09851343	CAP SCREW M8-1.25 X 25
1344	P09851344	PNUEMATIC CYLINDER BRACKET
1345	P09851345	WAVY WASHER 30.1 X 40.6 X 0.3MM
1346	P09851346	MOTOR 2HP 220V 3-PH
1346-1	P09851346-1	MOTOR FAN COVER
1346-2	P09851346-2	MOTOR FAN
1346-3	P09851346-3	MOTOR JUNCTION BOX
1346-4	P09851346-4	BALL BEARING 6205ZZ, FRONT
1346-5	P09851346-5	BALL BEARING 6203ZZ, REAR
1347	P09851347	FLAT WASHER 10MM
1348	P09851348	CAP SCREW M6-1 X 16
1349	P09851349	FLAT WASHER 6MM
1350	P09851350	CUTTERHEAD GUARD
1351	P09851351	CAP SCREW M10-1.5 X 25
1352	P09851352	FENDER WASHER 10 X 40 X 7MM
1353	P09851353	FLAT WASHER 10 X 20 X 1.35MM
1354	P09851354	DUST BRUSH 255MM
1355	P09851355	DUST BRUSH 112MM
1356	P09851356	CAP SCREW M10-1.5 X 25 LH
1357	P09851357	CUTTERHEAD, FRONT RKE J71019-67 L1082
1358	P09851358	CUTTERHEAD, REAR RKE J71019-67 R1065
1359	P09851359	KEY 8 X 7 X 30 W/HOLE
1360	P09851360	MOTOR CORD 20G 4W 40"
1361	P09851361	CAP SCREW M4-.7 X 10
1362	P09851362	SPINDLE LOCK TOOL KIT

End Trimmer Carriage

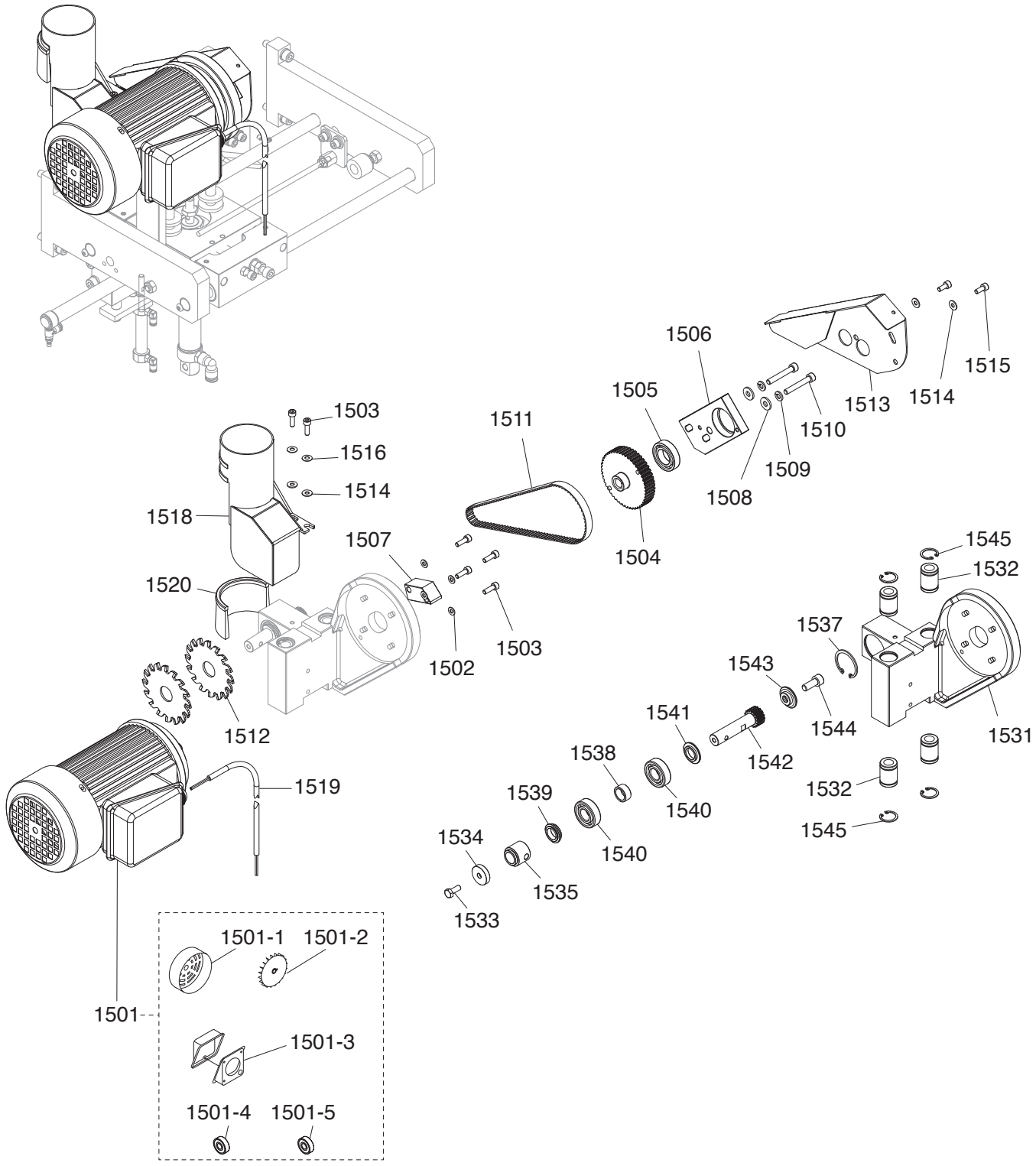


End Trimmer Carriage Parts List

REF	PART #	DESCRIPTION
1401	P09851401	END PLATE
1402	P09851402	SLIDER SHAFT 16 X 400MM
1405	P09851405	LOCK WASHER 6MM
1406	P09851406	FLAT WASHER 6MM
1407	P09851407	CAP SCREW M6-1 X 16
1408	P09851408	BUTTON HD CAP SCR M8-1.25 X 45
1409	P09851409	BUMPER, RUBBER
1410	P09851410	FENDER WASHER 8MM
1411	P09851411	LOCK NUT M8-1.25
1412	P09851412	HEX NUT M8-1.25
1413	P09851413	LOCK WASHER 8MM
1414	P09851414	CAP SCREW M8-1.25 X 20
1415	P09851415	FLAT WASHER 6MM
1416	P09851416	CAP SCREW M6-1 X 20
1417	P09851417	PNEUMATIC CYLINDER, VERTICAL
1418	P09851418	CAP SCREW M8-1.25 X 35
1419	P09851419	BUTTON HD CAP SCR M5-.8 X 6
1420	P09851420	BUTTON HD CAP SCR M8-1.25 X 35
1423	P09851423	STOP PLATE
1424	P09851424	FLAT WASHER 6MM
1425	P09851425	BUFFER PAD
1426	P09851426	CYLINDER MOUNTING BLOCK
1427	P09851427	CYLINDER CONNECTOR
1428	P09851428	FIXED PLATE
1429	P09851429	FLAT WASHER 8MM
1430	P09851430	BELLEVILLE WASHER 8MM
1431	P09851431	HEX NUT M8-1.25
1432	P09851432	DOWEL PIN 1 X 4MM
1433	P09851433	SET SCREW M6-1 X 6
1434	P09851434	PNEUMATIC CYLINDER, HORIZONTAL
1435	P09851435	RISER BASE
1436	P09851436	SLIDER SHAFT 10 X 155MM
1437	P09851437	LIFTING BLOCK
1438	P09851438	SLIDER SHAFT 12 X 246MM
1439	P09851439	FIXED PLATE, VERTICAL
1440	P09851440	FIXED PLATE, HORIZONTAL
1441	P09851441	BUSHING 10 X 12 X 20MM
1442	P09851442	CAP SCREW M8-1.25 X 80
1443	P09851443	CAP SCREW M6-1 X 70
1444	P09851444	BELLEVILLE WASHER 8MM
1445	P09851445	HEX NUT M8-1.25
1446	P09851446	LOCK NUT M8-1.25
1447	P09851447	LOCK NUT M6-1
1448	P09851448	SET SCREW M6-1 X 8

REF	PART #	DESCRIPTION
1449	P09851449	LINEAR BALL BEARING LME16UU
1450	P09851450	DOWEL PIN 1 X 4MM
1451	P09851451	BUMPER, RUBBER
1452	P09851452	CAP SCREW M6-1 X 20
1453	P09851453	SET SCREW M6-1 X 6
1454	P09851454	HEX NUT M6-1
1455	P09851455	BUTTON HD CAP SCR M5-.8 X 8
1456	P09851456	BUTTON HD CAP SCR M8-1.25 X 30
1457	P09851457	FLANGED BUSHING 26 X 33MM
1458	P09851458	FLAT HD CAP SCR M5-.8 X 12
1459	P09851459	BUFFER PAD 12 X 30 X 12MM
1461	P09851461	FLAT WASHER 6 X 16 X 2MM
1462	P09851462	CAP SCREW M8-1.25 X 55
1463	P09851463	LOCK WASHER 8MM
1464	P09851464	BALL BEARING 608ZZ
1465	P09851465	HEX BOLT M8-1.25 X 20
1466	P09851466	SET SCREW M3-.5 X 3
1467	P09851467	ROLL PIN 1 X 20
1468	P09851468	BALL BEARING 6902ZZ
1469	P09851469	FLAT HD CAP SCR M5-.8 X 16
1470	P09851470	TRACER PLATE, FRONT
1471	P09851471	FLAT WASHER 5 X 12 X 0.6MM
1472	P09851472	TRACER BRACKET
1473	P09851473	TRACER PLATE, REAR
1474	P09851474	FLAT WASHER 5 X 13 X 2MM
1475	P09851475	LOCK WASHER 5MM
1476	P09851476	CAP SCREW M5-.8 X 16
1477	P09851477	FLAT HD CAP SCR M5-.8 X 12
1478	P09851478	TRACER LIFT BLOCK
1479	P09851479	LINEAR BALL BEARING LM12UU
1480	P09851480	PNEUMATIC CYLINDER, VERTICAL
1481	P09851481	CABLE TIE
1482	P09851482	POSITION SENSOR FONRAY KT-73-RS
1483	P09851483	HEX NUT M6-1, THIN
1484	P09851484	BELLEVILLE WASHER 6MM
1485	P09851485	CONNECTING PLATE
1486	P09851486	FLAT WASHER 6MM
1487	P09851487	FENDER WASHER 6MM
1488	P09851488	BUMPER, RUBBER
1489	P09851489	CYLINDER MOUNTING PLATE
1490	P09851490	LOCK WASHER 6MM
1491	P09851491	CAP SCREW M6-1 X 25
1492	P09851492	SET SCREW M5-.8 X 5
1493	P09851493	SLIDER SHAFT 12 X 149MM

End Trimmer Motor

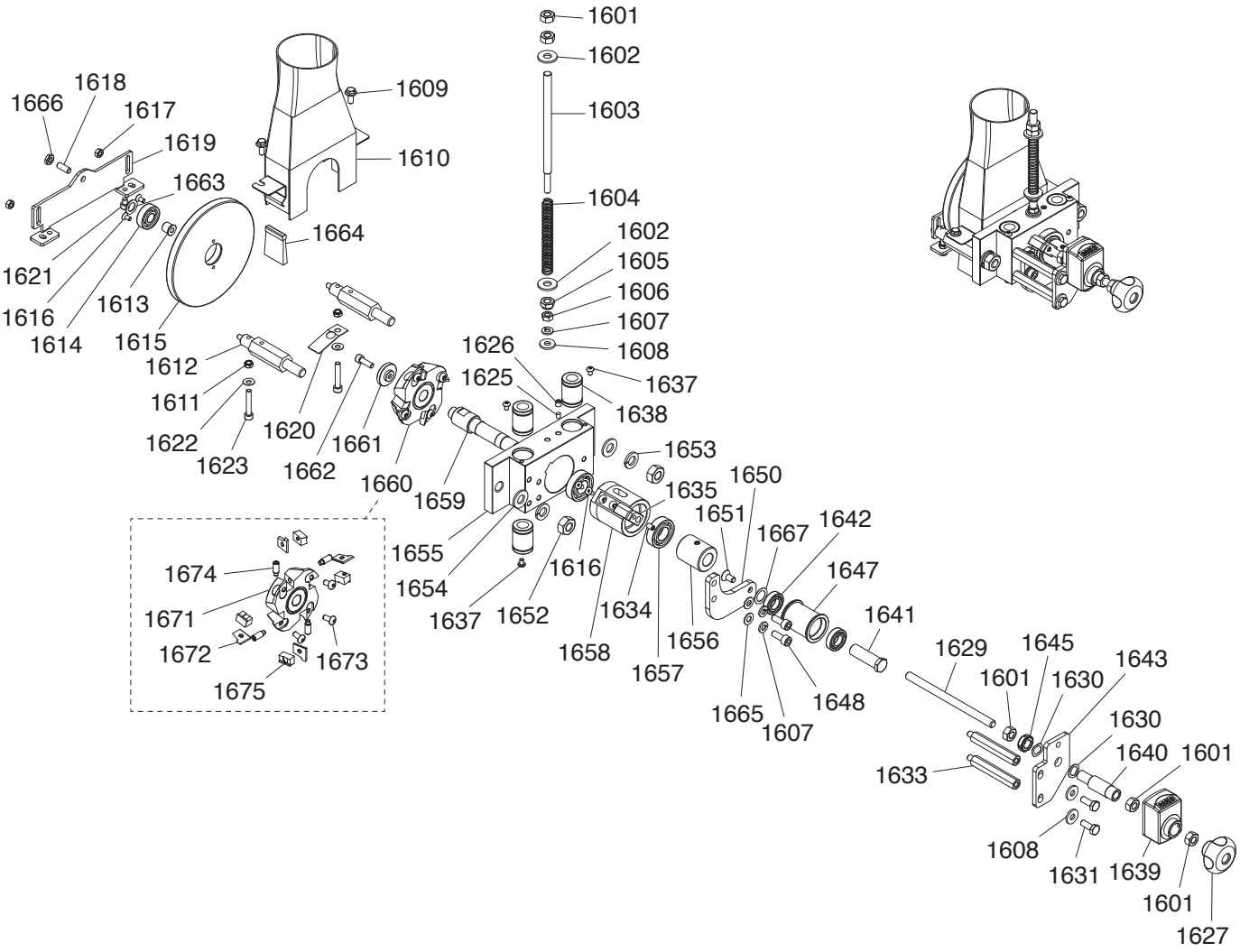


End Trimmer Motor Parts List

REF	PART #	DESCRIPTION
1501	P09851501	MOTOR 1/4HP 220V 3-PH
1501-1	P09851501-1	MOTOR FAN COVER
1501-2	P09851501-2	MOTOR FAN
1501-3	P09851501-3	MOTOR JUNCTION BOX
1501-4	P09851501-4	BALL BEARING 6202ZZ, FRONT
1501-5	P09851501-5	BALL BEARING 6200ZZ, REAR
1502	P09851502	FLAT WASHER 5MM
1503	P09851503	CAP SCREW M5-.8 X 16
1504	P09851504	MOTOR PULLEY
1505	P09851505	BALL BEARING 6904LLB
1506	P09851506	BELT ADJUSTMENT BLOCK
1507	P09851507	FIXED BLOCK
1508	P09851508	FLAT WASHER 6MM
1509	P09851509	LOCK WASHER 6MM
1510	P09851510	CAP SCREW M6-1 X 40
1511	P09851511	TIMING BELT T5 500 X 10MM
1512	P09851512	SAW BLADE 80MM 16T
1513	P09851513	BELT GUARD
1514	P09851514	FLAT WASHER 5MM

REF	PART #	DESCRIPTION
1515	P09851515	CAP SCREW M5-.8 X 12
1516	P09851516	FLAT WASHER 5 X 12 X 0.6MM
1518	P09851518	DUST GUARD
1519	P09851519	MOTOR CORD 16G 4W 36"
1520	P09851520	DUST BRUSH
1531	P09851531	MOTOR MOUNT
1532	P09851532	LINEAR BALL BEARING LM12UU
1533	P09851533	HEX BOLT M6-1 X 16
1534	P09851534	ARBOR FLANGE, OUTER
1535	P09851535	BLADE SPACER
1537	P09851537	EXT RETAINING RING 35MM
1538	P09851538	BEARING SPACER
1540	P09851540	BALL BEARING 6202LLB
1541	P09851541	PULLEY WASHER, INNER
1542	P09851542	BLADE ARBOR
1543	P09851543	PULLEY WASHER, OUTER
1544	P09851544	CAP SCREW M8-1.25 X 20
1545	P09851545	EXT RETAINING RING 21MM

Flush Trimmer (Upper)

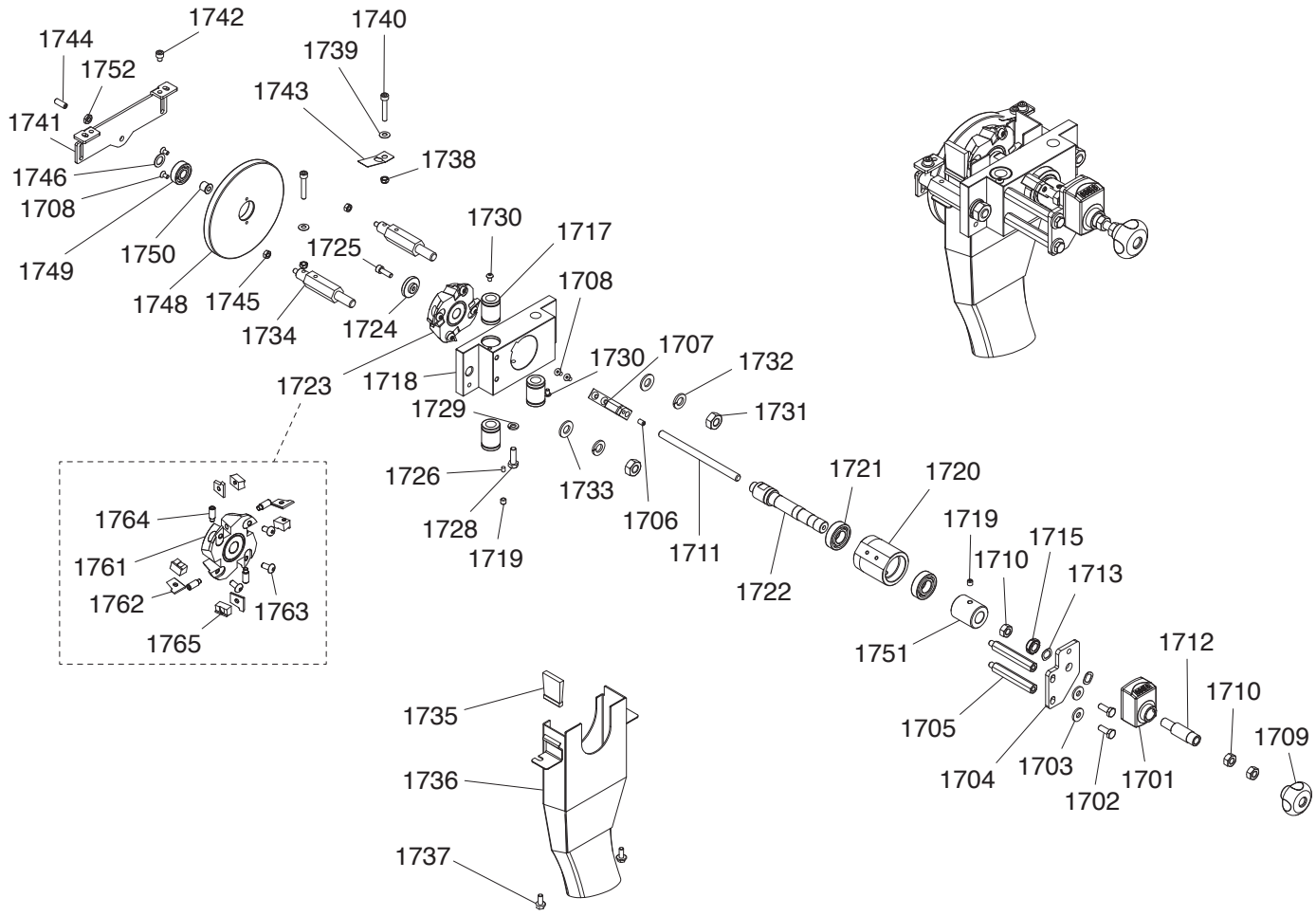


Flush Trimmer (Upper) Parts List

REF	PART #	DESCRIPTION
1601	P09851601	HEX NUT M8-1.25
1602	P09851602	FLAT WASHER 8MM
1603	P09851603	STUD-FT M8-1.25 X 150, M6-1
1604	P09851604	COMPRESSION SPRING 1.2 X 11.2 X 90MM
1605	P09851605	LOCK NUT M6-1.25
1606	P09851606	HEX NUT M6-1
1607	P09851607	LOCK WASHER 6MM
1608	P09851608	FLAT WASHER 6MM
1609	P09851609	FLANGE BOLT M5-.8 X 12
1610	P09851610	DUST COVER, UPPER
1611	P09851611	LOCK NUT M5-.8
1612	P09851612	STANDOFF-HEX MM M5-.8 X 8, 94, M10-1.5 X 25
1613	P09851613	FLANGED BUSHING 26MM
1614	P09851614	BALL BEARING 6000LLB
1615	P09851615	TRACER WHEEL
1616	P09851616	FLAT HD CAP SCR M4-.7 X 8
1617	P09851617	HEX NUT M5-.8
1618	P09851618	SET SCREW M6-1 X 16
1619	P09851619	TRACER MOUNTING PLATE
1620	P09851620	SCRAPER PLATE
1621	P09851621	CAP SCREW M5-.8 X 6
1622	P09851622	FLAT WASHER 5 X 12 X 0.6MM
1623	P09851623	CAP SCREW M5-.8 X 30
1625	P09851625	DOWEL PIN 1 X 4MM
1626	P09851626	SET SCREW M6-1 X 6
1627	P09851627	KNOB M8-1.25
1629	P09851629	STUD-FT M8-1.25 X 125
1630	P09851630	WAVY WASHER 10MM
1631	P09851631	HEX BOLT M6-1 X 16
1633	P09851633	STANDOFF-HEX MF M6-1 X 5, 70, M6-1
1634	P09851634	SET SCREW M5-.8 X 8
1635	P09851635	TAPER LOCK
1637	P09851637	BUTTON HD CAP SCR M4-.7 X 6

REF	PART #	DESCRIPTION
1638	P09851638	LINEAR BALL BEARING LM12UU
1639	P09851639	POSITION INDICATOR
1640	P09851640	ADJUSTMENT SHAFT
1641	P09851641	IDLER PULLEY SHAFT
1642	P09851642	BALL BEARING 6901LLB
1643	P09851643	INDICATOR MOUNTING PLATE
1645	P09851645	SPANNER LOCK NUT M10-1.75
1647	P09851647	IDLER PULLEY
1648	P09851648	CAP SCREW M6-1 X 16
1650	P09851650	IDLER PULLEY MOUNTING PLATE
1651	P09851651	FLAT HD CAP SCR M6-1 X 12
1652	P09851652	HEX NUT M10-1.5
1653	P09851653	LOCK WASHER 10MM
1654	P09851654	FLAT WASHER 10MM
1655	P09851655	SLIDE BRACKET, UPPER
1656	P09851656	TRIMMER PULLEY
1657	P09851657	BALL BEARING 6002LLB
1658	P09851658	TAPER-LOCK BUSHING, UPPER
1659	P09851659	CUTTERHEAD SPINDLE, UPPER
1660	P09851660	CUTTERHEAD, UPPER
1661	P09851661	CUTTERHEAD FLANGE
1662	P09851662	CAP SCREW M5-.8 X 16
1663	P09851663	FLAT WASHER 10MM
1664	P09851664	DUST BRUSH 30MM
1665	P09851665	FLAT WASHER 6MM
1666	P09851666	HEX NUT M6-1 X 3MM, THIN
1667	P09851667	RING SHIM 12 X 18 X 2MM, COPPER
1671	P09851671	CUTTERHEAD, UPPER
1672	P09851672	CUTTERHEAD KNIFE, UPPER
1673	P09851673	BUTTON HD CAP SCR M5-.8 X 10
1674	P09851674	SET SCREW M6-1 X 16
1675	P09851675	PRESSURE BLOCK

Flush Trimmer (Lower)

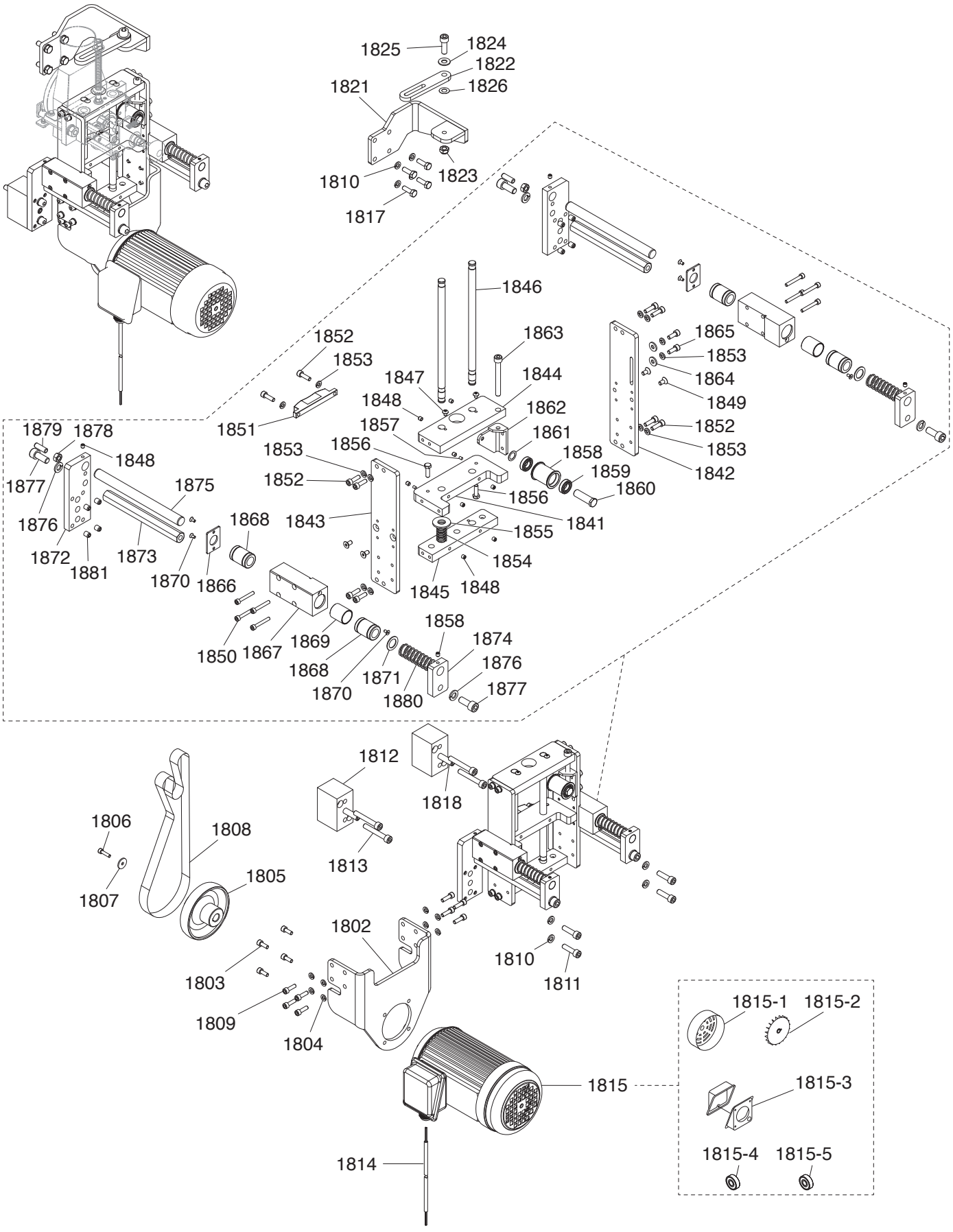


Flush Trimmer (Lower) Parts List

REF	PART #	DESCRIPTION
1701	P09851701	POSITION INDICATOR
1702	P09851702	HEX BOLT M6-1 X 16
1703	P09851703	FLAT WASHER 6MM
1704	P09851704	INDICATOR MOUNTING PLATE
1705	P09851705	STANDOFF-HEX MF M6-1 X 5, 70, M6-1
1706	P09851706	SET SCREW M5-.8 X 8
1707	P09851707	TAPER LOCK
1708	P09851708	FLAT HD CAP SCR M4-.7 X 8
1709	P09851709	KNOB M8-1.25
1710	P09851710	HEX NUT M8-1.25
1711	P09851711	STUD-FT M8-1.25 X 125
1712	P09851712	ADJUSTMENT SHAFT
1713	P09851713	WAVY WASHER 10MM
1715	P09851715	PRECISION NUT M10-.75
1717	P09851717	LINEAR BALL BEARING LM12UU
1718	P09851718	SLIDE BRACKET, LOWER
1719	P09851719	SET SCREW M6-1 X 6
1720	P09851720	TAPER-LOCK BUSHING, LOWER
1721	P09851721	BALL BEARING 6002LLB
1722	P09851722	CUTTERHEAD SPINDLE, LOWER
1723	P09851723	CUTTERHEAD, LOWER
1724	P09851724	CUTTERHEAD FLANGE
1725	P09851725	CAP SCREW M5-.8 X 16, LH
1726	P09851726	DOWEL PIN 1 X 4MM
1728	P09851728	HEX BOLT M6-1 X 20
1729	P09851729	LOCK WASHER 6MM
1730	P09851730	BUTTON HD CAP SCR M4-.7 X 6

REF	PART #	DESCRIPTION
1731	P09851731	HEX NUT M10-1.5
1732	P09851732	LOCK WASHER 10MM
1733	P09851733	FLAT WASHER 10MM
1734	P09851734	STANDOFF-HEX MM M5-.8 X 8, 94, M10-1.5 X 25
1735	P09851735	DUST BRUSH 30MM
1736	P09851736	DUST COVER, LOWER
1737	P09851737	FLANGE BOLT M5-.8 X 12
1738	P09851738	LOCK NUT M5-.8
1739	P09851739	FLAT WASHER 5 X 12 X .6MM
1740	P09851740	CAP SCREW M5-.8 X 30
1741	P09851741	TRACER MOUNTING PLATE
1742	P09851742	CAP SCREW M5-.8 X 6
1743	P09851743	SCRAPER PLATE
1744	P09851744	SET SCREW M6-1 X 16
1745	P09851745	HEX NUT M5-.8
1746	P09851746	FLAT WASHER 10MM
1748	P09851748	TRACER WHEEL
1749	P09851749	BALL BEARING 6000LLB
1750	P09851750	FLANGED BUSHING 26MM
1751	P09851751	TRIMMER PULLEY
1752	P09851752	HEX NUT M6-1 X 3MM, THIN
1761	P09851761	CUTTERHEAD, LOWER
1762	P09851762	CUTTERHEAD KNIFE, LOWER
1763	P09851763	BUTTON HD CAP SCR ,5-.8 X 10
1764	P09851764	SET SCREW M6-1 X 16
1765	P09851765	PRESSURE BLOCK

Flush Trimmer Motor

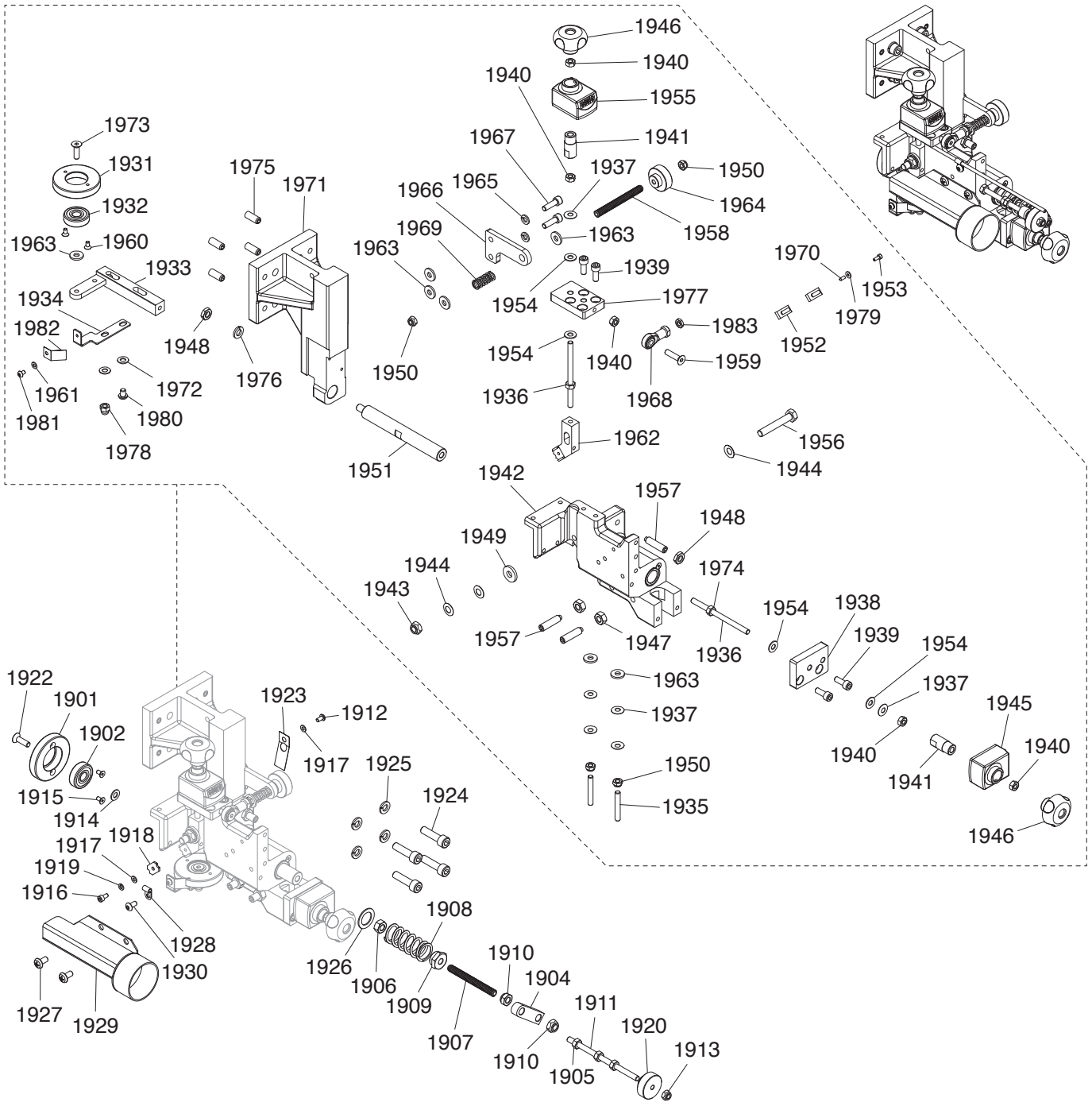


Flush Trimmer Motor Parts List

REF	PART #	DESCRIPTION
1802	P09851802	MOTOR MOUNT
1803	P09851803	CAP SCREW M6-1 X 16
1804	P09851804	LOCK WASHER 6MM
1805	P09851805	MOTOR PULLEY
1806	P09851806	CAP SCREW M5-.8 X 20
1807	P09851807	FENDER WASHER 5MM
1808	P09851808	FLAT BELT 20 X 900MM
1809	P09851809	CAP SCREW M6-1 X 20
1810	P09851810	LOCK WASHER 8MM
1811	P09851811	CAP SCREW M8-1.25 X 30
1812	P09851812	RISER BLOCK
1813	P09851813	CAP SCREW M8-1.25 X 55
1814	P09851814	MOTOR CORD 20G 4W 15-3/4"
1815	P09851815	MOTOR 3/4 HP 220V 3-PH
1815-1	P09851815-1	MOTOR FAN COVER
1815-2	P09851815-2	MOTOR FAN
1815-3	P09851815-3	MOTOR JUNCTION BOX
1815-4	P09851815-4	BALL BEARING 6203ZZ, FRONT
1815-5	P09851815-5	BALL BEARING 6202ZZ, REAR
1817	P09851817	HEX BOLT M8-1.25 X 25
1818	P09851818	SET SCREW M10-1.5 X 35
1821	P09851821	SUPPORT ARM
1822	P09851822	CONNECTING BRACKET
1823	P09851823	LOCK NUT M10-1.5
1824	P09851824	FLAT WASHER 10MM
1825	P09851825	CAP SCREW M10-1.5 X 30
1826	P09851826	RING SHIM 10 X 20 X 0.2MM, COPPER
1841	P09851841	BELT TENSION PLATE
1842	P09851842	SIDE PLATE, RIGHT
1843	P09851843	SIDE PLATE, LEFT
1844	P09851844	PLATE, TOP
1845	P09851845	PLATE, BOTTOM
1846	P09851846	SLIDER SHAFT 12 X 246MM
1847	P09851847	BUTTON HD CAP SCR M5-.8 X 6

REF	PART #	DESCRIPTION
1848	P09851848	SET SCREW M6-1 X 6
1849	P09851849	FLAT HD CAP SCR M6-1 X 12
1850	P09851850	CAP SCREW M5-.8 X 35
1851	P09851851	ALIGNMENT BLOCK
1852	P09851852	CAP SCREW M6-1 X 20
1853	P09851853	LOCK WASHER 6MM
1854	P09851854	COMPRESSION SPRING 2 X 17 X 32.5MM
1855	P09851855	FLAT WASHER 13 X 30 X 2.5MM
1856	P09851856	HEX BOLT M6-1 X 20
1857	P09851857	DOWEL PIN 1 X 4MM
1858	P09851858	IDLER PULLEY
1859	P09851859	BALL BEARING 6901LLB
1860	P09851860	IDLER PULLEY SHAFT
1861	P09851861	FLAT WASHER 12 X 18 X 2MM, COPPER
1862	P09851862	IDLER PULLEY MOUNTING PLATE
1863	P09851863	CAP SCREW M8-1.25 X 70
1864	P09851864	FLAT WASHER 6MM
1865	P09851865	CAP SCREW M6-1 X 16
1866	P09851866	BEARING PLATE
1867	P09851867	BEARING BLOCK
1868	P09851868	LINEAR BALL BEARING LME16UU
1869	P09851869	SPACER 22.4 X 25.4 X 28MM
1870	P09851870	FLAT HD CAP SCR M4.-7 X 8
1871	P09851871	FLAT WASHER 16 X 25 X 1.2MM
1872	P09851872	SLIDER END PLATE
1873	P09851873	STANDOFF-HEX FF M10-1.5 X 174
1874	P09851874	END PLATE
1875	P09851875	SLIDER SHAFT 16 X 198MM
1876	P09851876	LOCK WASHER 10MM
1877	P09851877	CAP SCREW M10-1.5 X 25
1878	P09851878	HEX NUT M8-1.25
1879	P09851879	SET SCREW M8-1.25 X 25
1880	P09851880	COMPRESSION SPRING 2 X 22 X 75
1881	P09851881	SET SCREW M8-1.25 X 10

Scraper (Upper)

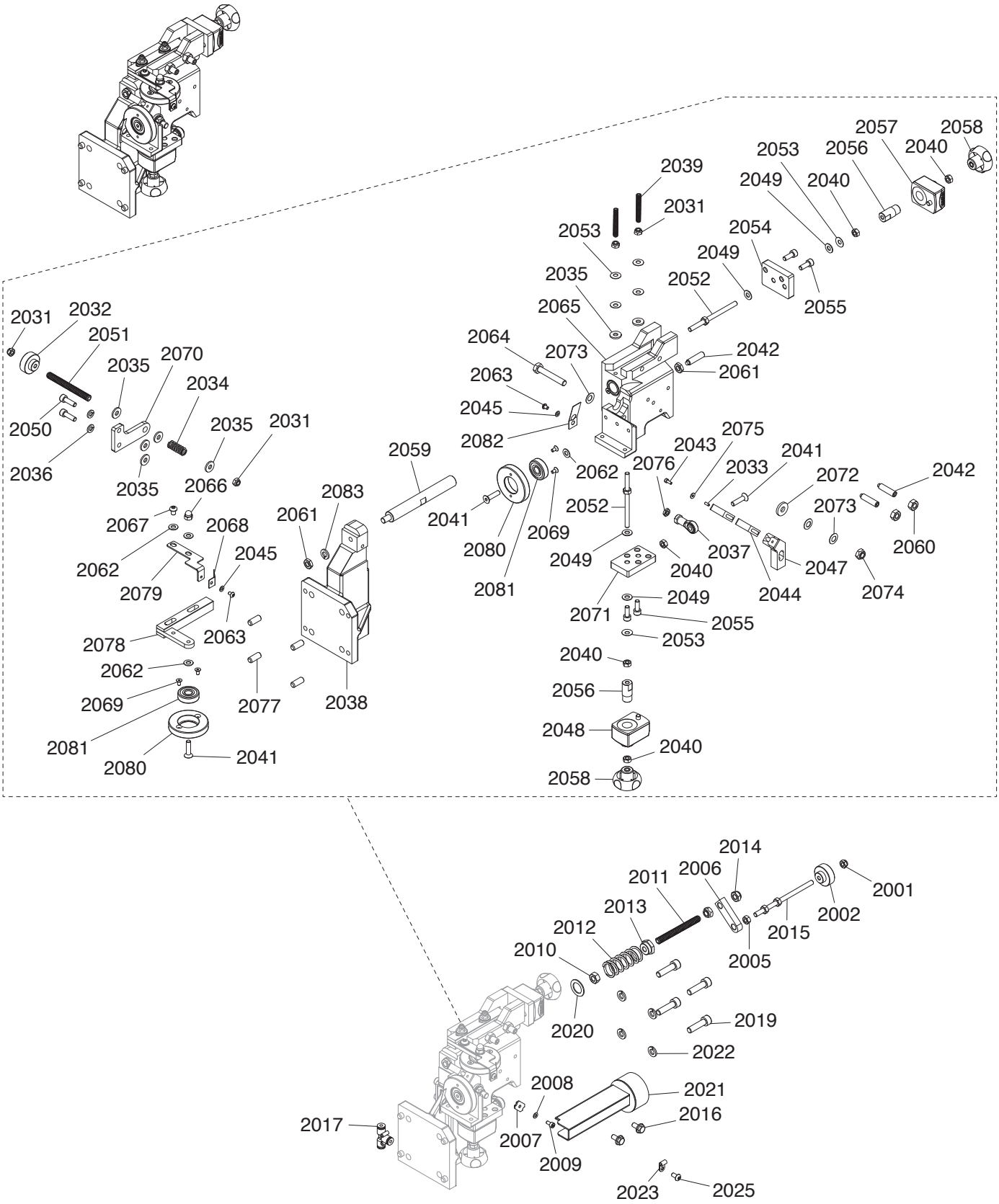


Scraper (Upper) Parts List

REF	PART #	DESCRIPTION
1901	P09851901	TRACER WHEEL
1902	P09851902	BALL BEARING 6200LLB
1904	P09851904	CONNECTING BLOCK
1905	P09851905	HEX NUT M6-1
1906	P09851906	HEX NUT M8-1.25
1907	P09851907	SET SCREW M8-1.25 X 65
1908	P09851908	COMPRESSION SPRING 1.7 X 18 X 45
1909	P09851909	TENSION NUT M8-1.25
1910	P09851910	LOCK NUT M8-1.25
1911	P09851911	STUD-FT M6-1 X 111MM
1912	P09851912	BUTTON HD CAP SCR M4-.7 X 8
1913	P09851913	LOCK NUT M6-1
1914	P09851914	FLAT WASHER 6MM
1915	P09851915	FLAT HD CAP SCR M4-.7 X 8
1916	P09851916	CAP SCREW M4-.7 X 8
1917	P09851917	FLAT WASHER 4MM
1918	P09851918	SCRAPER BLADE
1919	P09851919	LOCK WASHER 4MM
1920	P09851920	KNURLED KNOB M6-1
1922	P09851922	FLAT HD CAP SCR M6-1 X 20
1923	P09851923	SCRAPER PLATE
1924	P09851924	CAP SCREW M8-1.25 X 30
1925	P09851925	LOCK WASHER 8MM
1926	P09851926	FLAT WASHER 16 X 25 X 1.2MM
1927	P09851927	PHLP HD SCR M6-1 X 12
1928	P09851928	CORD CLIP 3/16"
1929	P09851929	DUST PORT 2", UPPER
1930	P09851930	BUTTON HD CAP SCR M5-.8 X 10
1931	P09851931	TRACER WHEEL
1932	P09851932	BALL BEARING 6200LLB
1933	P09851933	TRACER WHEEL BRACKET
1934	P09851934	CONNECTING PLATE
1935	P09851935	SET SCREW M6-1 X 40
1936	P09851936	STUD-FT M6-1 X 92MM
1937	P09851937	BELLEVILLE WASHER 6MM
1938	P09851938	INDICATOR MOUNTING PLATE
1939	P09851939	CAP SCREW M6-1 X 16
1940	P09851940	HEX NUT M6-1
1941	P09851941	INDICATOR SLEEVE M6-1 X 30MM
1942	P09851942	TRACER CHASSIS, UPPER
1943	P09851943	LOCK NUT M8-1.25

REF	PART #	DESCRIPTION
1944	P09851944	BELLEVILLE WASHER 8MM
1945	P09851945	POSITION INDICATOR
1946	P09851946	KNOB M6-1
1947	P09851947	HEX NUT M8-1.25
1948	P09851948	HEX NUT M8-1.25, THIN
1949	P09851949	FLAT WASHER 8 X 20 X 3MM
1950	P09851950	LOCK NUT M6-1
1951	P09851951	SLIDER SHAFT 16 X 138MM
1952	P09851952	SCRAPER BLADE
1953	P09851953	CAP SCREW M3-.7 X 8
1954	P09851954	RING SHIM 6 X 14 X 1MM, COPPER
1955	P09851955	POSITION INDICATOR
1956	P09851956	HEX BOLT M8-1.25 X 50
1957	P09851957	SET SCREW M8-1.25 X 32 DOG-PT, COPPER
1958	P09851958	SET SCREW M6-1 X 80
1959	P09851959	FLAT HD CAP SCR M6-1 X 25
1960	P09851960	FLAT HD CAP SCR M4-.7 X 8
1961	P09851961	FLAT WASHER 4MM
1962	P09851962	SCRAPER BLADE HOLDER, UPPER
1963	P09851963	FLAT WASHER 6 X 16MM
1964	P09851964	KNURLED KNOB M6-1
1965	P09851965	LOCK WASHER 6MM
1966	P09851966	CONNECTING PLATE
1967	P09851967	CAP SCREW M6-1 X 20
1968	P09851968	ROD END M6-1
1969	P09851969	COMPRESSION SPRING 1.6 X 11.4 X 27MM
1970	P09851970	SET SCREW M3-.5 X 8
1971	P09851971	SCRAPER BRACKET, UPPER
1972	P09851972	FLAT WASHER 6MM
1973	P09851973	FLAT HD CAP SCR M6-1 X 20
1974	P09851974	HEX NUT M6-1
1975	P09851975	SET SCREW M8-1.25 X 20
1976	P09851976	LOCK WASHER 8MM
1977	P09851977	INDICATOR MOUNTING PLATE
1978	P09851978	ACORN NUT M6-1
1979	P09851979	FLAT WASHER 3MM
1980	P09851980	BUTTON HD CAP SCR M6-1 X 8
1981	P09851981	BUTTON HD CAP SCR M4-.7 X 6
1982	P09851982	SCRAPER PLATE
1983	P09851983	HEX NUT M6-1, THIN

Scraper (Lower)

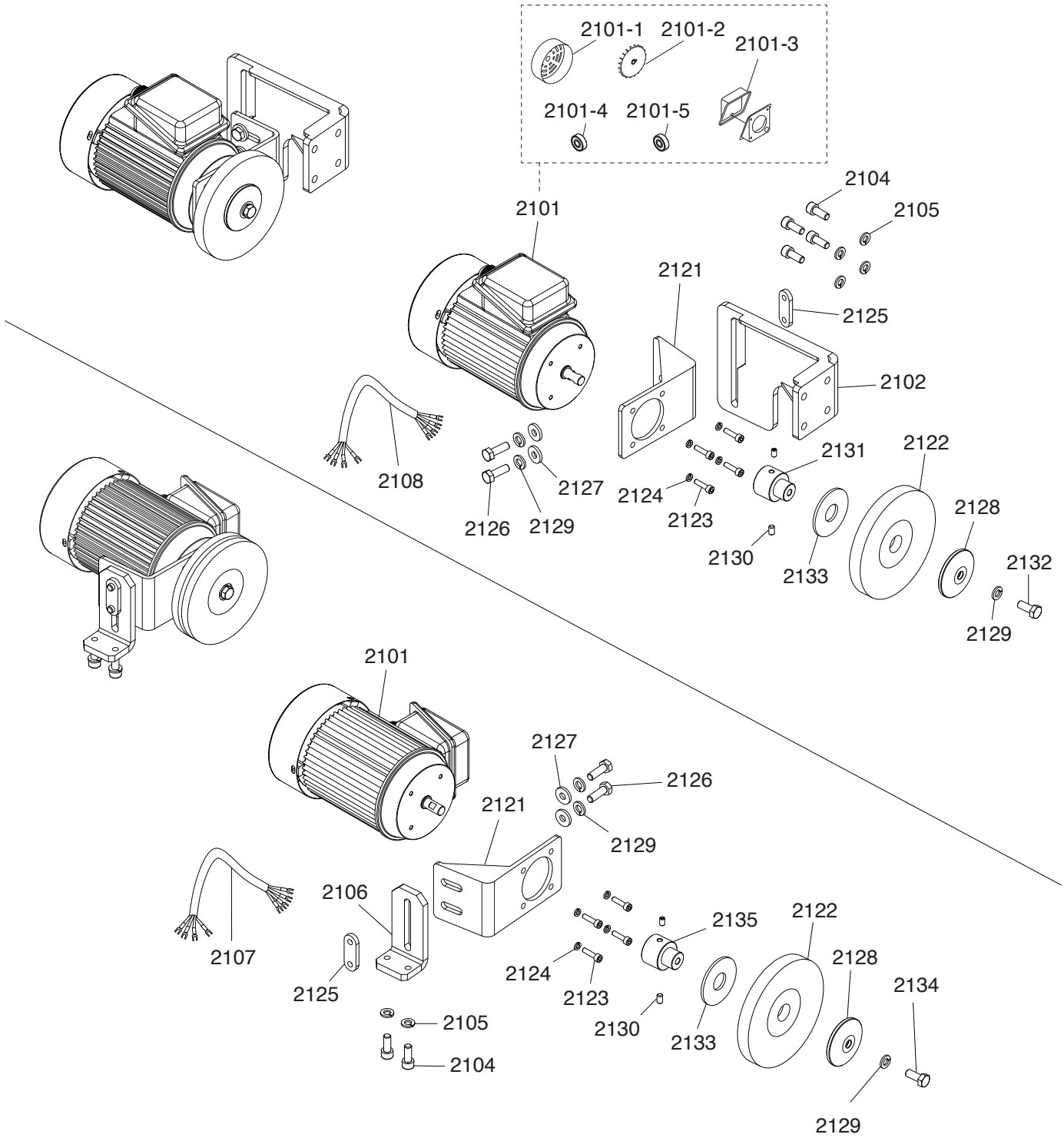


Scraper (Lower) Parts List

REF	PART #	DESCRIPTION
2001	P09852001	LOCK NUT M6-1
2002	P09852002	KNURLED KNOB M6-1
2003	P09852003	LOWER SCRAPER ASSEMBLY
2005	P09852005	HEX NUT M6-1
2006	P09852006	CONNECTING BLOCK
2007	P09852007	SCRAPER BLADE
2008	P09852008	FLAT WASHER 4MM
2009	P09852009	CAP SCREW M4-.7 X 8
2010	P09852010	HEX NUT M8-1.25
2011	P09852011	SET SCREW M8-1.25 X 65
2012	P09852012	COMPRESSION SPRING 1.7 X 18 X 45
2013	P09852013	TENSION NUT M8-1.25
2014	P09852014	LOCK NUT M8-1.25
2015	P09852015	STUD-FT M6-1 X 111
2016	P09852016	FLANGE BOLT M6-1 X 20
2017	P09852017	TEE HOSE FITTING 4MM
2019	P09852019	CAP SCREW M8-1.25 X 30
2020	P09852020	FLAT WASHER 16 X 25 X 1.2MM
2021	P09852021	DUST PORT 2", LOWER
2022	P09852022	LOCK WASHER 8MM
2023	P09852023	CORD CLIP 3/16"
2025	P09852025	BUTTON HD CAP SCR M5-.8 X 10
2031	P09852031	LOCK NUT M6-1
2032	P09852032	KNURLED KNOB M6-1
2033	P09852033	SET SCREW M3-.5 X 8
2034	P09852034	COMPRESSION SPRING 1.6 X 11.4 X 27MM
2035	P09852035	FLAT WASHER 6MM
2036	P09852036	LOCK WASHER 6MM
2037	P09852037	ROD END M6-1
2038	P09852038	SCRAPER BRACKET, LOWER
2039	P09852039	SET SCREW M6-1 X 35
2040	P09852040	HEX NUT M6-1
2041	P09852041	FLAT HD CAP SCR M6-1 X 25
2042	P09852042	SET SCREW M8-1.25 X 32 DOG-PT, COPPER
2043	P09852043	CAP SCREW M3-.7 X 8
2044	P09852044	SCRAPER BLADE
2045	P09852045	FLAT WASHER 4MM

REF	PART #	DESCRIPTION
2047	P09852047	SCRAPER BLADE HOLDER, LOWER
2048	P09852048	POSITION INDICATOR
2049	P09852049	RING SHIM 6 X 14 X 1MM, COPPER
2050	P09852050	CAP SCREW M6-1 X 20
2051	P09852051	SET SCREW M6-1 X 80
2052	P09852052	STUD-FT M6-1 X 92
2053	P09852053	BELLEVILLE WASHER 6MM
2054	P09852054	INDICATOR MOUNTING PLATE
2055	P09852055	CAP SCREW M6-1 X 16
2056	P09852056	INDICATOR SLEEVE M6-1 X 30MM
2057	P09852057	POSITION INDICATOR
2058	P09852058	KNOB M6-1
2059	P09852059	SLIDER SHAFT 16 X 138MM
2060	P09852060	HEX NUT M8-1.25
2061	P09852061	HEX NUT M8-1.25, THIN
2062	P09852062	FLAT WASHER 6 X 16MM
2063	P09852063	BUTTON HD CAP SCR M4-.7 X 6
2064	P09852064	HEX BOLT M8-1.25 X 50
2065	P09852065	TRACER CHASSIS, LOWER
2066	P09852066	ACORN NUT M6-1
2067	P09852067	BUTTON HD CAP SCR M6-1 X 8
2068	P09852068	SCRAPER PLATE
2069	P09852069	FLAT HD CAP SCR M4-.7 X 8
2070	P09852070	CONNECTING PLATE
2071	P09852071	INDICATOR MOUNTING PLATE
2072	P09852072	FLAT WASHER 8 X 20 X 3MM
2073	P09852073	BELLEVILLE WASHER 8MM
2074	P09852074	LOCK NUT M8-1.25
2075	P09852075	FLAT WASHER 3MM
2076	P09852076	THIN NUT M6-1 X 3MM
2077	P09852077	SET SCREW M8-1.25 X 20
2078	P09852078	TRACER WHEEL BRACKET
2079	P09852079	CONNECTING PLATE
2080	P09852080	TRACER WHEEL
2081	P09852081	BALL BEARING 6200LLB
2082	P09852082	SCRAPER PLATE
2083	P09852083	LOCK WASHER 8MM

Buffing Motors

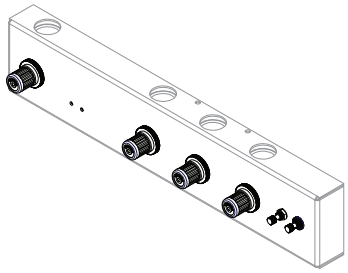


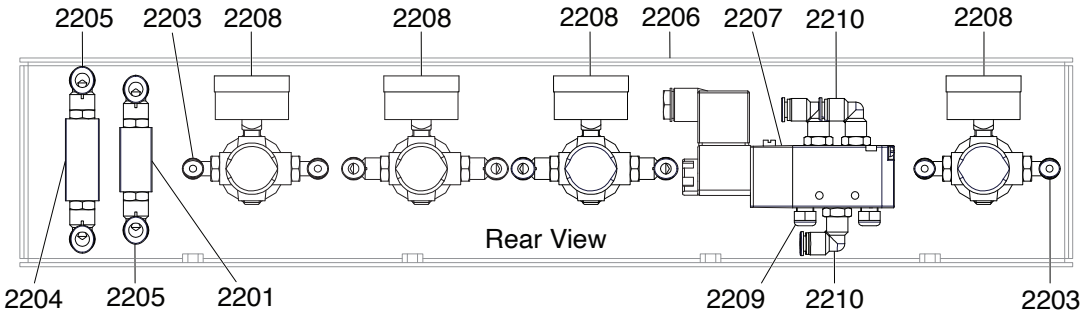
Buffing Motors Parts List

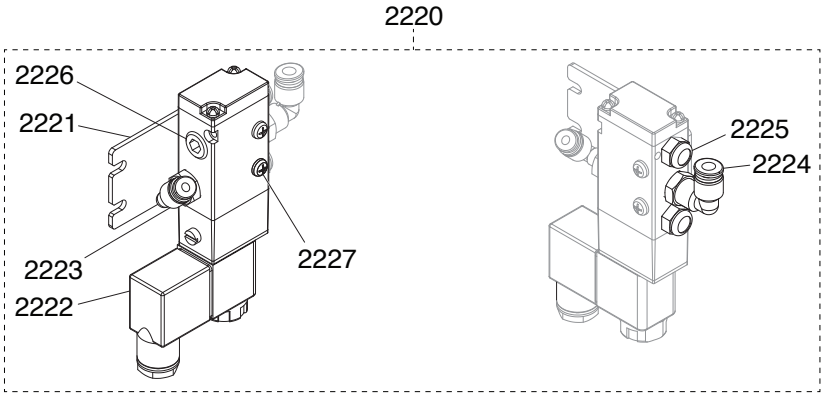
REF	PART #	DESCRIPTION
2101	P09852101	MOTOR 1/6 HP 220V 3-PH
2101-1	P09852101-1	MOTOR FAN COVER
2101-2	P09852101-2	MOTOR FAN
2101-3	P09852101-3	MOTOR JUNCTION BOX
2101-4	P09852101-4	BALL BEARING 6202ZZ, FRONT
2101-5	P09852101-5	BALL BEARING 6200ZZ, REAR
2102	P09852102	MOTOR MOUNTING PLATE, UPPER
2104	P09852104	CAP SCREW M8-1.25 X 20
2105	P09852105	LOCK WASHER 8MM
2106	P09852106	MOTOR MOUNTING PLATE, LOWER
2107	P09852107	MOTOR CORD 20G 4W 51"
2108	P09852108	MOTOR CORD 20G 4W 59"
2121	P09852121	MOTOR MOUNT
2122	P09852122	BUFFING WHEEL 5"

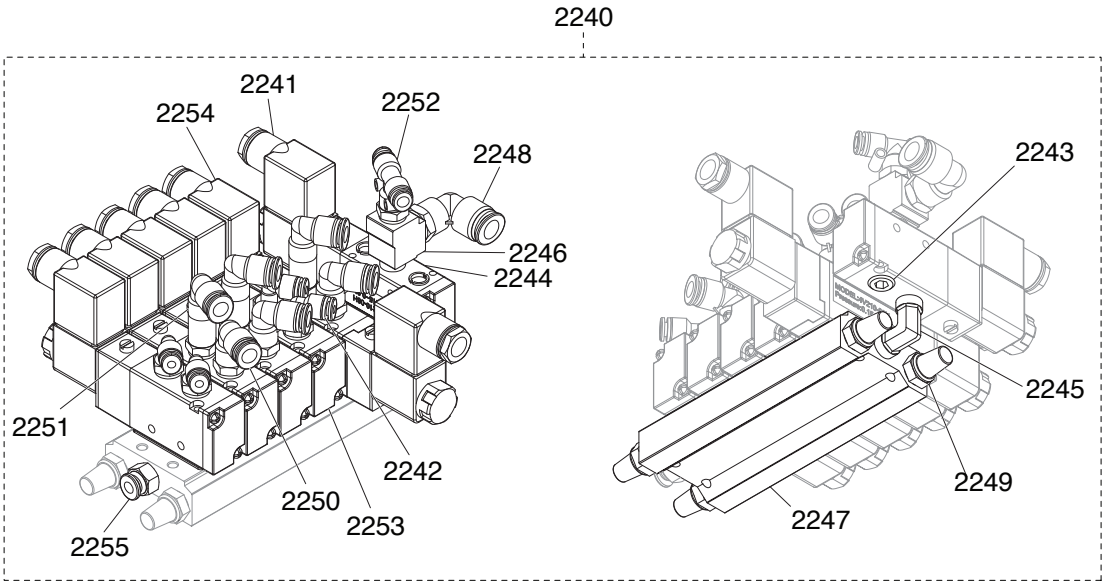
REF	PART #	DESCRIPTION
2123	P09852123	CAP SCREW M5-.8 X 16
2124	P09852124	LOCK WASHER 5MM
2125	P09852125	BACKING PLATE
2126	P09852126	HEX BOLT M8-1.25 X 25
2127	P09852127	FLAT WASHER 8 X 20 X 3MM
2128	P09852128	WHEEL FLANGE
2129	P09852129	LOCK WASHER 8MM
2130	P09852130	SET SCREW M6-1 X 10
2131	P09852131	WHEEL ARBOR
2132	P09852132	HEX BOLT M8-1.25 X 20
2133	P09852133	PAD 20 X 54 X 3MM
2134	P09852134	HEX BOLT M8-1.25 X 20 LH
2135	P09852135	WHEEL ARBOR LH

Pneumatic Controls







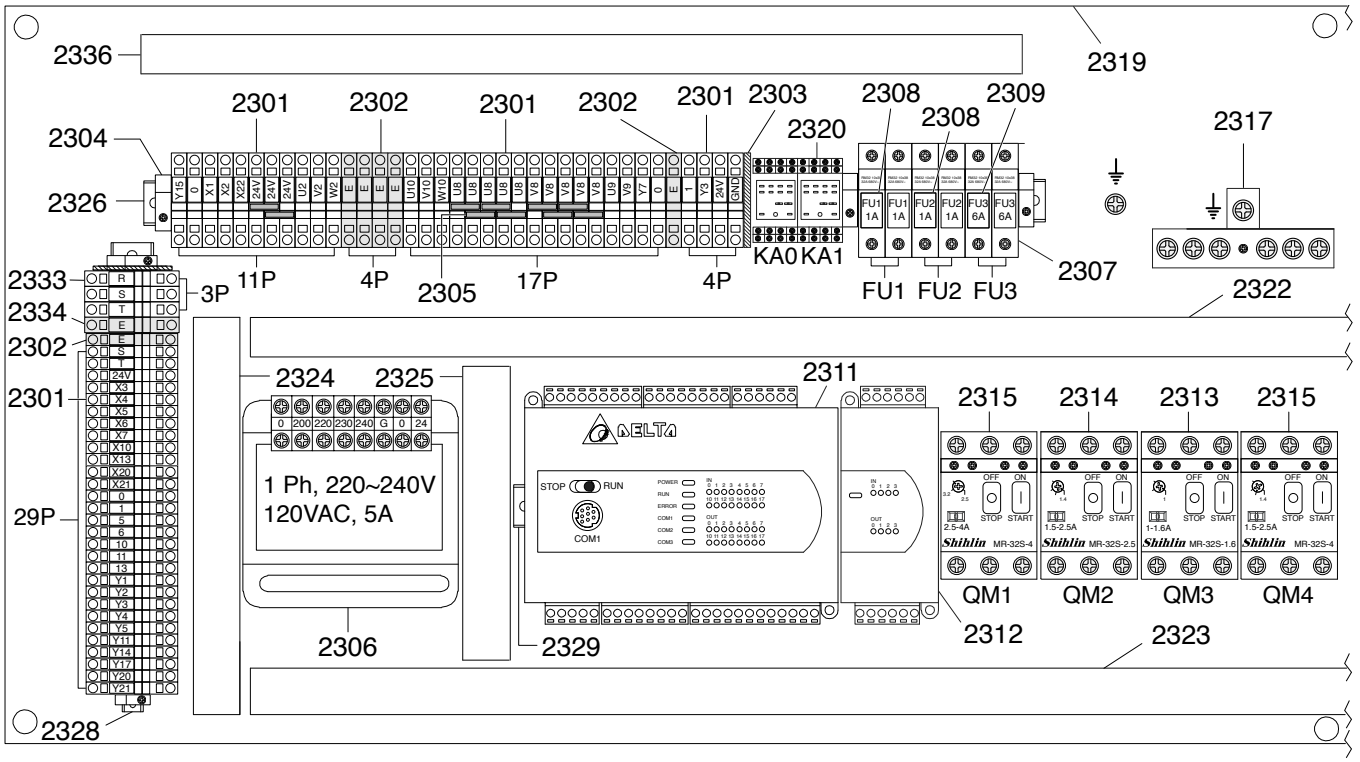


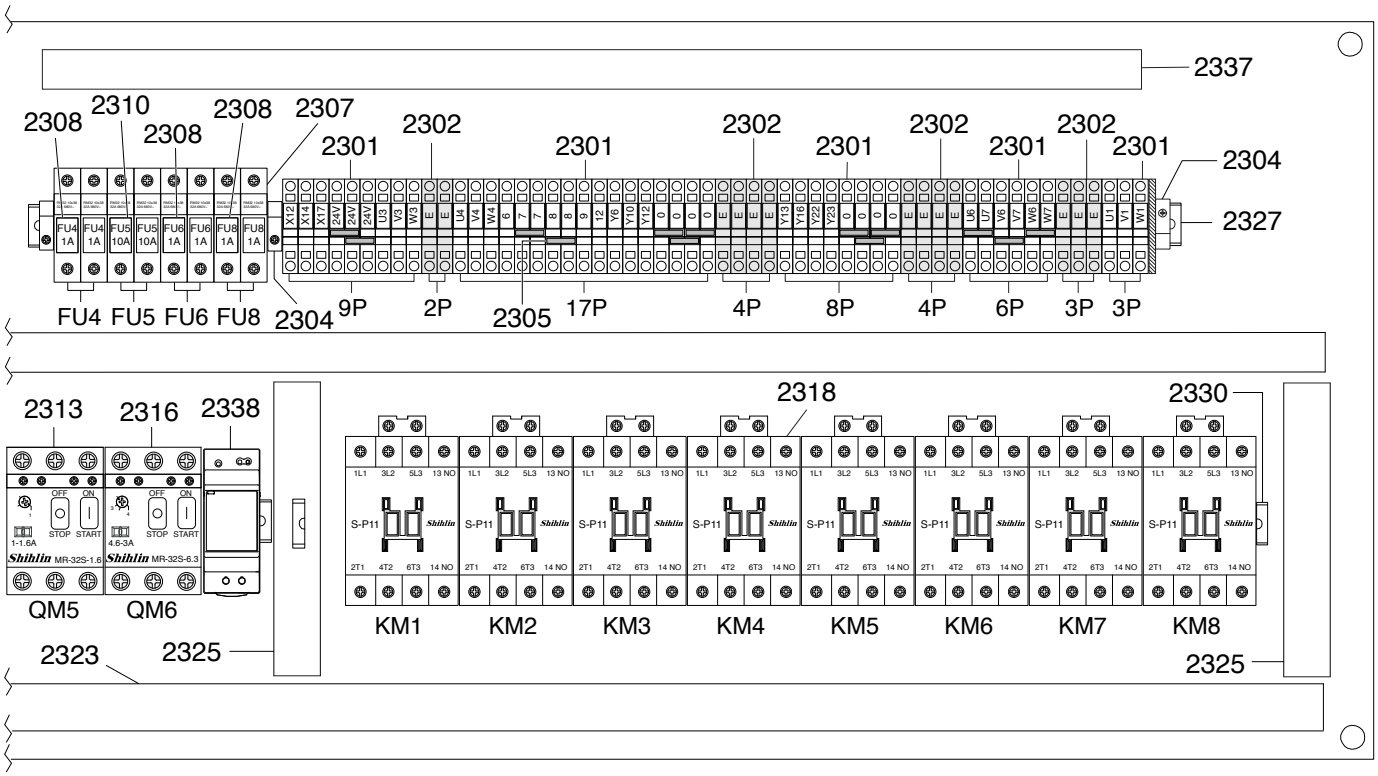
Pneumatic Controls Parts List

REF	PART #	DESCRIPTION
2201	P09852201	FLOW CONTROL VALVE ASC-01
2203	P09852203	ELBOW PT1/4 26.9 X 33.9
2204	P09852204	FLOW CONTROL VALVE RE-01
2205	P09852205	ELBOW PT1/8 FONRAY 30.5 X 35.4
2206	P09852206	REGULATOR HOUSING
2207	P09852207	SOLENOID VALVE AIRTAC 4V210-08-F 24VAC
2208	P09852208	PRESSURE REGULATOR NAR200-R-2 5KG
2209	P09852209	FLAT HEAD SILENCER PT1/8 FONRAY FSL-01
2210	P09852210	ELBOW PT1/4 26.9 X 33.9
2220	P09852220	SOLENOID VALVE EXTENSION ASSY (1-PC)
2221	P09852221	MOUNTING PLATE
2222	P09852222	SOLENOID VALVE AIRTAC 4V210-08-F 24VAC
2223	P09852223	ELBOW PT1/4
2224	P09852224	ELBOW PT1/4
2225	P09852225	FLAT HEAD SILENCER PT1/8 FVB-01
2226	P09852226	PLUG PT1/4
2227	P09852227	PHLP HD SCR M4-.7 X 25

REF	PART #	DESCRIPTION
2240	P09852240	SOLENOID VALVE ASSEMBLY
2241	P09852241	SOLENOID VALVE PT1/4
2242	P09852242	ELBOW PT1/4
2243	P09852243	PLUG PT1/4
2244	P09852244	FLAT HEAD SILENCER PT1/8
2245	P09852245	ELBOW PT1/4, COPPER
2246	P09852246	3-WAY ADAPTER
2247	P09852247	BASE
2248	P09852248	ELBOW PT1/4 37.4 X 44
2249	P09852249	CONICAL MUFFLER
2250	P09852250	ELBOW PT1/4 30.5 x 37.4
2251	P09852251	ELBOW PT1/4 30.5 x 18
2252	P09852252	FITTING PT1/4 33.9 x 37.8
2253	P09852253	SOLENOID VALVE AIRTAC 4V210-08-F 24VAC
2254	P09852254	SOLENOID VALVE AIRTAC 4V230E-08-F 12VDC
2255	P09852255	FITTING PT1/4

Electrical Components



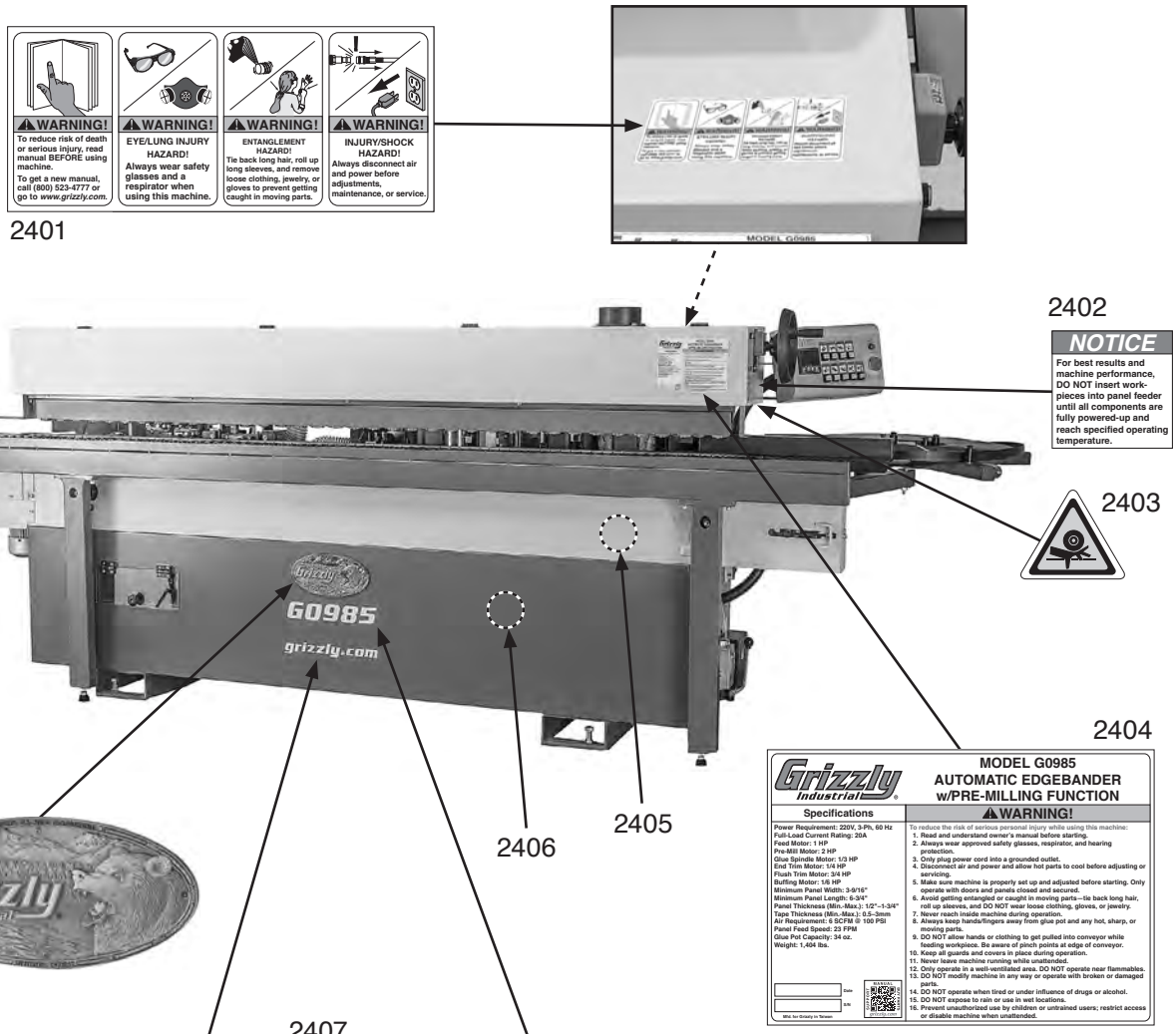


Electrical Components Parts List

REF	PART #	DESCRIPTION
2301	P09852301	TERMINAL BLOCK PYK2.5 (1PC)
2302	P09852302	GROUND TERMINAL BLOCK PYK2.5T (1PC)
2303	P09852303	TERMINAL END BLOCK PYK2.5
2304	P09852304	TERMINAL END BLOCK TE-002
2305	P09852305	TERMINAL JUMPER
2306	P09852306	TRANSFORMER 200-240V
2307	P09852307	FUSE HOLDER JR RM32 10X38
2308	P09852308	FUSE 1A CERAMIC
2309	P09852309	FUSE 6A CERAMIC
2310	P09852310	FUSE 10A CERAMIC
2311	P09852311	PLC DVP32ES200R
2312	P09852312	PLC EXPANSION MODULE DVP 08XP211R
2313	P09852313	MOTOR STARTER SHIHNLIN MR-32S-1.6
2314	P09852314	MOTOR STARTER SHIHNLIN MR-32S-2.5
2315	P09852315	MOTOR STARTER SHIHNLIN MR-32S-4
2316	P09852316	MOTOR STARTER SHIHNLIN MR-32S-6.3
2317	P09852317	GROUND TERMINAL BLOCK 6P

REF	PART #	DESCRIPTION
2318	P09852318	CONTACTOR S-P11
2319	P09852319	ELECTRICAL MOUNTING BOARD
2320	P09852320	RELAY OMRON MY4N-GS 24V
2322	P09852322	CABLE TRAY COVER 25 X 65MM
2323	P09852323	CABLE TRAY COVER 25 X 65MM
2324	P09852324	CABLE TRAY COVER 25 X 65MM
2325	P09852325	CABLE TRAY COVER 25 X 65MM
2326	P09852326	DIN RAIL 35 X 7.5MM
2327	P09852327	DIN RAIL 35 X 7.5MM
2328	P09852328	DIN RAIL 35 X 7.5MM
2329	P09852329	DIN RAIL 35 X 7.5MM
2330	P09852330	DIN RAIL 35 X 7.5MM
2333	P09852333	TERMINAL BLOCK PYK6 (1PC)
2334	P09852334	GROUNDING TERMINAL BLOCK PYK6T (1PC)
2336	P09852336	CABLE TRAY COVER 25 X 65MM
2337	P09852337	CABLE TRAY COVER 25 X 65MM
2338	P09852338	DIN RAIL POWER SUPPLY HDR-30-24

Labels & Cosmetics



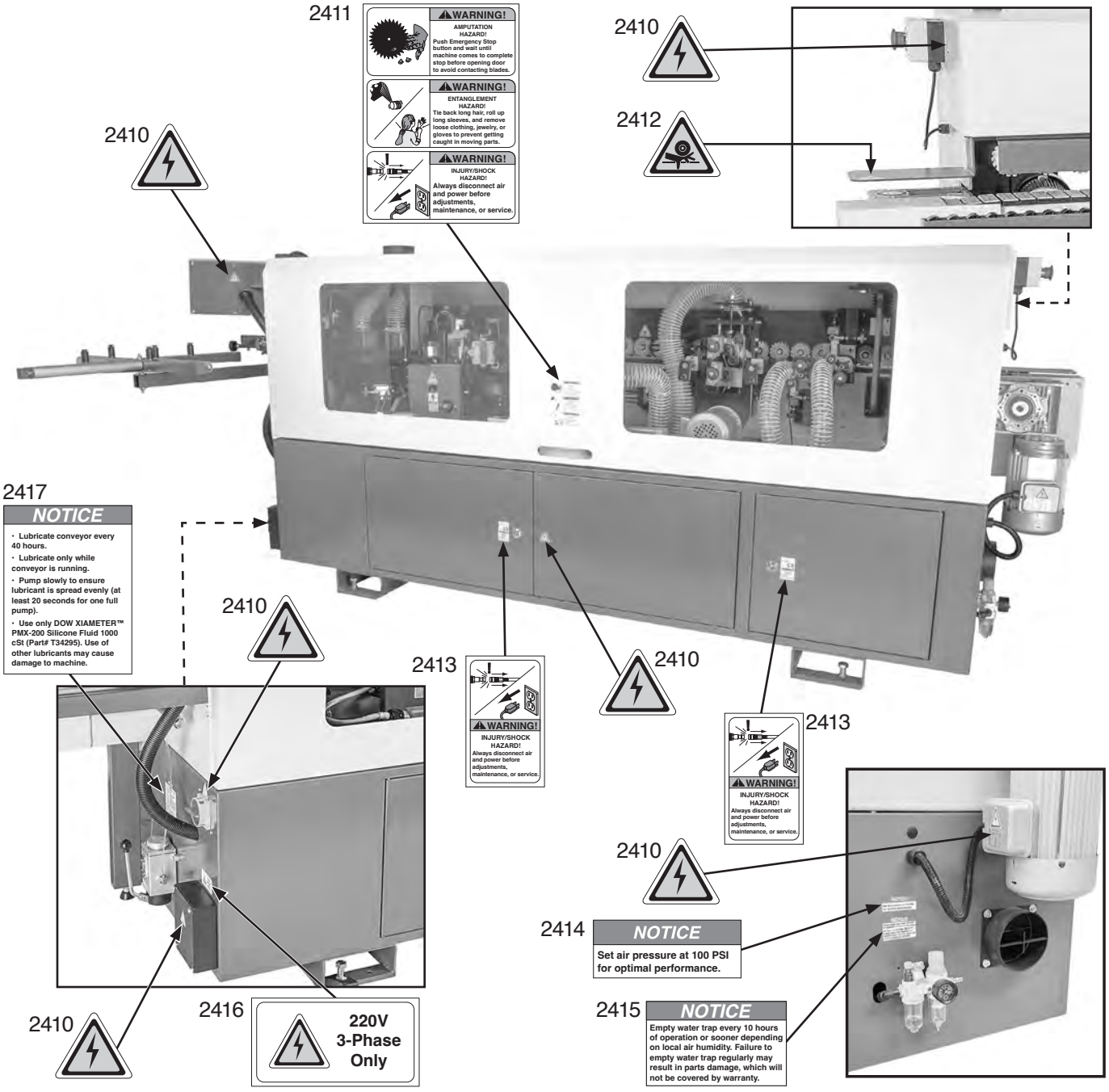
REF	PART #	DESCRIPTION
2401	P09852401	COMBO WARNING LABEL
2402	P09852402	NOTICE COMPONENTS POWERED UP LABEL
2403	P09852403	PINCH LABEL
2404	P09852404	MACHINE ID LABEL
2405	P09852405	TOUCH-UP PAINT, BEIGE

REF	PART #	DESCRIPTION
2406	P09852406	TOUCH-UP PAINT, GRIZZLY GREEN
2407	P09852407	MODEL NUMBER LABEL
2408	P09852408	GRIZZLY.COM LABEL
2409	P09852409	GRIZZLY NAMEPLATE-LARGE

⚠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.

Labels & Cosmetics (Cont.)



REF	PART #	DESCRIPTION
2410	P09852401	COMBO WARNING LABEL
2411	P09852402	NOTICE COMPONENTS POWERED UP LABEL
2412	P09852403	MACHINE ID LABEL
2413	P09852404	OILER LABEL

REF	PART #	DESCRIPTION
2414	P09852405	TOUCH-UP PAINT, BEIGE
2415	P09852406	TOUCH-UP PAINT, GRIZZLY GREEN
2416	P09852407	MODEL NUMBER LABEL
2417	P09852408	GRIZZLY.COM LABEL

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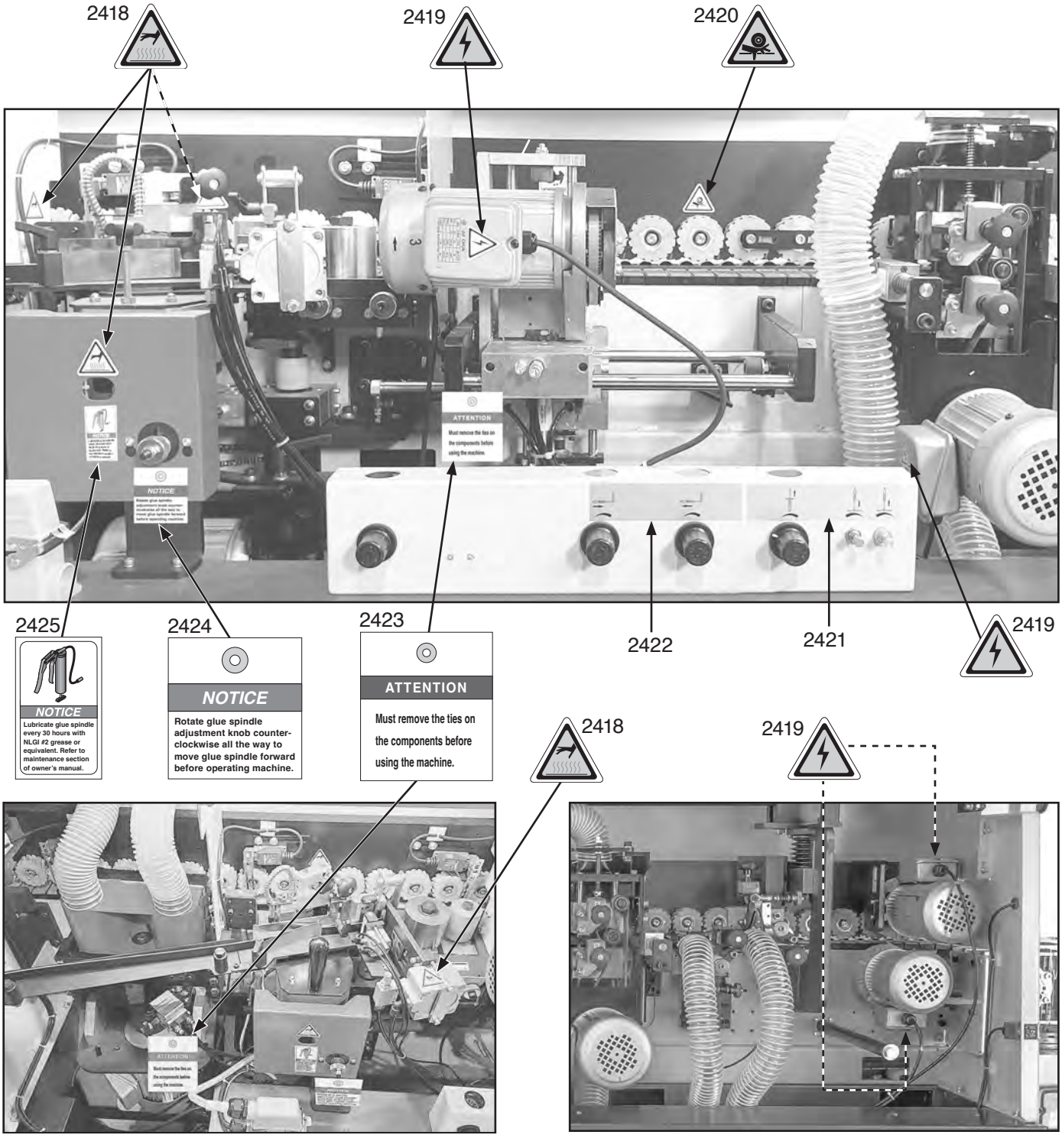
Labels & Cosmetics (Cont.)



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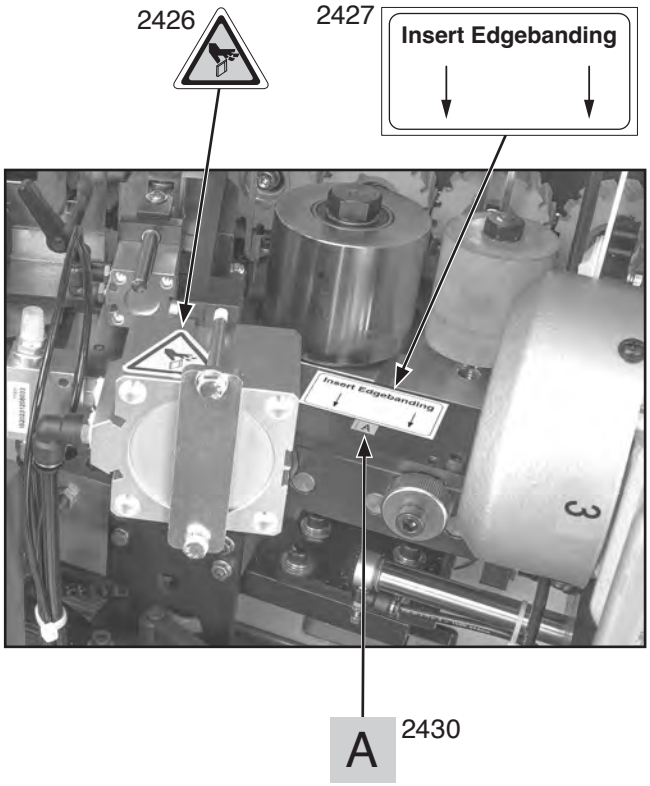
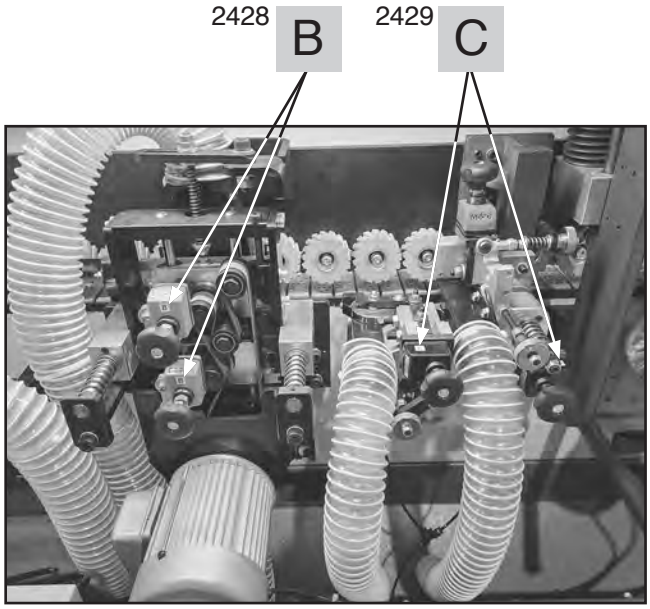
Labels & Cosmetics (Cont.)





REF	PART #	DESCRIPTION
2418	P09852418	HOT SURFACE LABEL
2419	P09852419	ELECTRICITY LABEL
2420	P09852420	PINCH LABEL
2421	P09852421	TRACER AIR CONTROL LABEL
2422	P09852422	CARRIAGE AIR CONTROL LABEL
2423	P09852423	REMOVE SHIPPING TIES HANG TAG
2424	P09852424	GLUE SPINDLE HANG TAG

REF	PART #	DESCRIPTION
2425	P09852425	LUBRICATION NOTICE LABEL
2426	P09852426	GUILLOTINE AMPUTATION LABEL
2427	P09852427	INSERT EDGEBANDING LABEL
2428	P09852428	FLUSH TRIMMER B LABEL
2429	P09852429	TRACER C LABEL
2430	P09852430	PRESSURE ROLLER A LABEL

⚠WARNING

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WARRANTY & RETURNS

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

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

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

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

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

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

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