

# *Grizzly* **Industrial, Inc.**®

## **MODEL G0819** **15" OPEN-END WIDE BELT SANDER** **OWNER'S MANUAL** *(For models manufactured since 09/16)*



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#BLWK18649 PRINTED IN TAIWAN

V1.08.23

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



# **WARNING!**

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

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

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

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



# **WARNING!**

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

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

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

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# INTRODUCTION

## Contact Info

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

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

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

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


## 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](http://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.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Adjust safety devices correctly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not operate if you are tired, drowsy, or under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
	Manufactured for Grizzly in Taiwan		

Manufacture Date

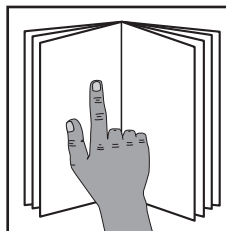
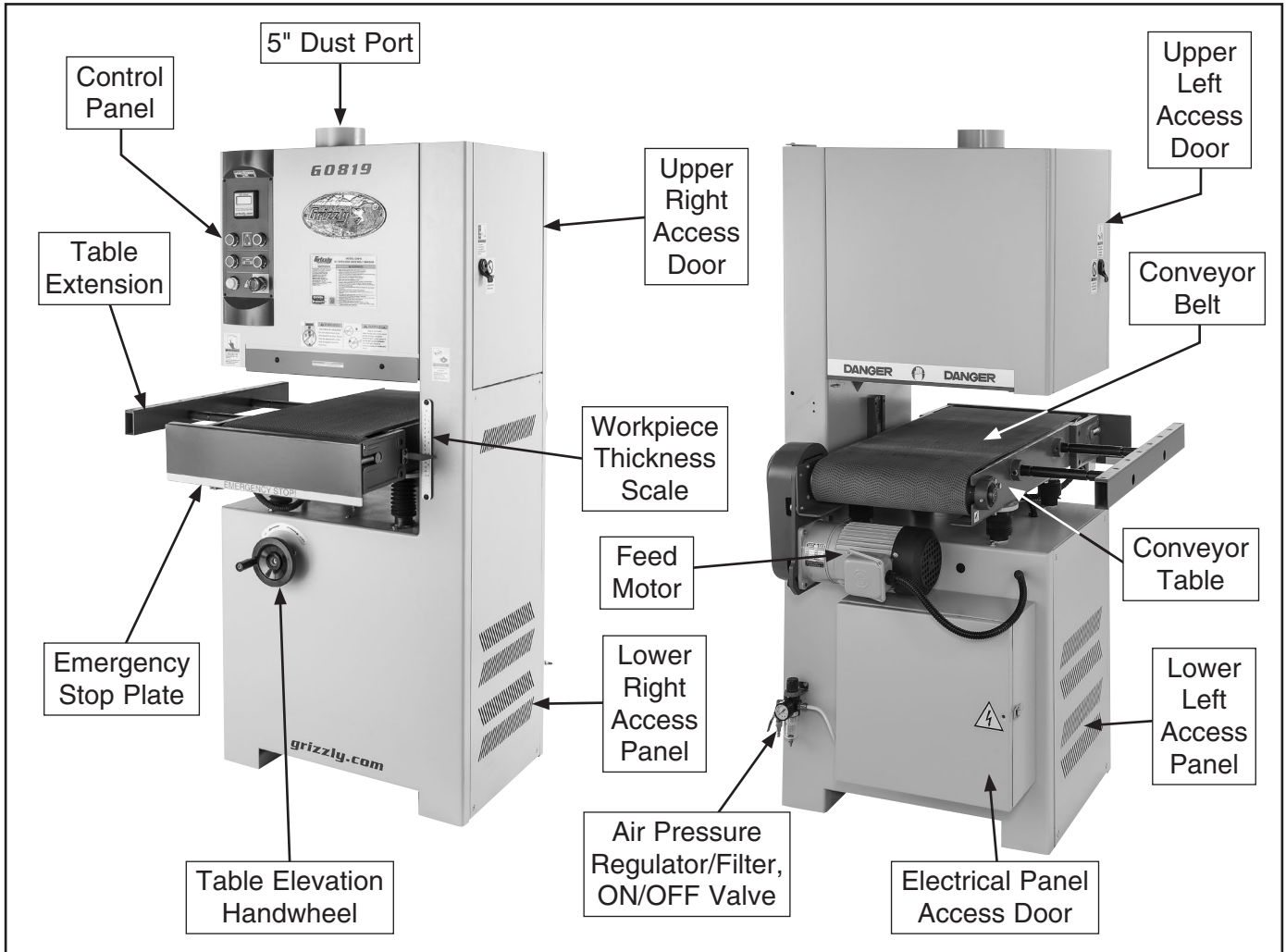
Serial Number





# Identification

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

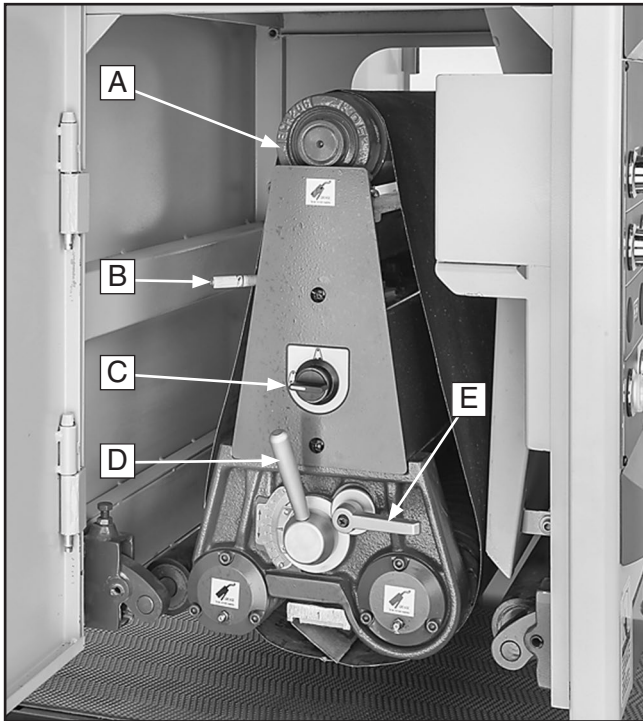


## **! WARNING**

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

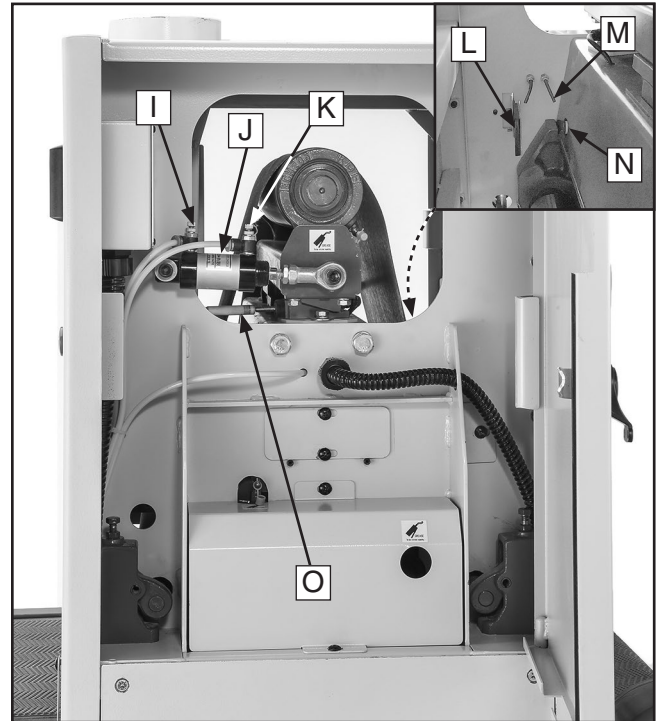


# Internal Features



**Figure 1.** Inside upper left access door.

- A. Upper Roller
- B. Left Limit Switch
- C. Belt Tension Knob
- D. Platen Adjustment Lever
- E. Platen Adjustment Lock Lever



**Figure 2.** Inside upper right access door.

- I. Left Speed Control Knob
- J. Pneumatic Cylinder
- K. Right Speed Control Knob
- L. Mirror
- M. Pneumatic Pulse-Jets
- N. Electronic Eye Sensor
- O. Right Limit Switch



# Controls & Components



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

## Control Panel

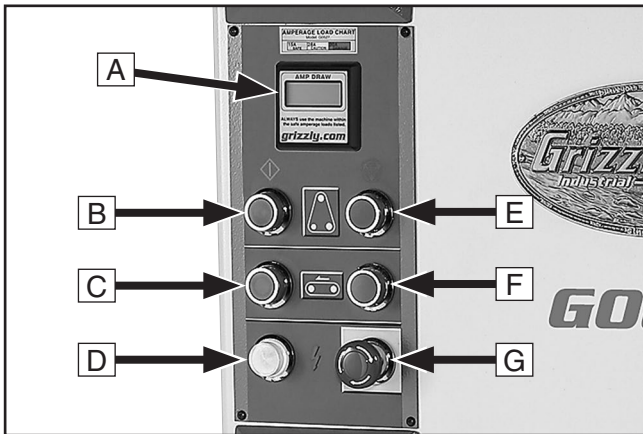


Figure 3. Control panel components.

- A. **Amp Load Meter:** Indicates current amp load on main motor during sanding operation.
- B. **Sanding Belt Start Button:** Turns main motor **ON** when pressed.
- C. **Conveyor Belt Start Button:** Turns feed motor **ON** when pressed.
- D. **Power Indicator:** Illuminates when machine is connected to power.
- E. **Sanding Belt Stop Button:** Turns main motor **OFF** when pressed.
- F. **Conveyor Belt Stop Button:** Turns feed motor **OFF** when pressed.

- G. **Emergency Stop Button:** Turns all machine functions **OFF** when pressed; engages emergency brake to stop rotation of sanding drum. Twist clockwise to reset.

## Table

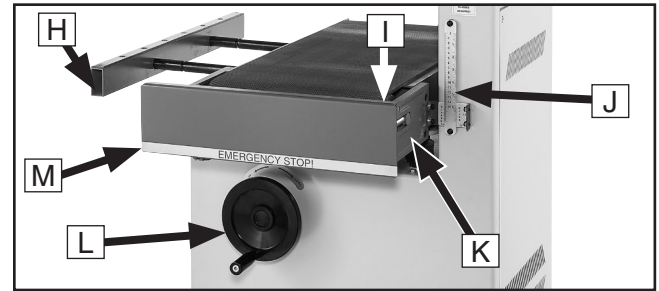


Figure 4. Table components.

- H. **Table Extension:** Adjusts in and out to provide additional support for workpieces that are wider than conveyor table.
- I. **Conveyor Belt:** Feeds workpiece across conveyor table during sanding operations.
- J. **Workpiece Thickness Scale:** Indicates thickness of finished workpiece.
- K. **Conveyor Table:** Supports workpiece during operations; can be raised and lowered according to workpiece thickness.
- L. **Table Elevation Handwheel:** Raises and lowers conveyor table (K). Rotate clockwise to lower table; rotate counterclockwise to raise table. One full rotation moves the table approximately 0.20".
- M. **Emergency Stop Plate:** Stops all machine functions when pressed; engages emergency brake to stop rotation of sanding drum.

## Feed Rate Chain

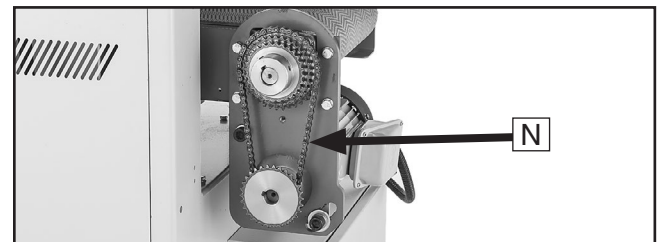


Figure 5. Feed rate chain location.

- N. **Feed Rate Pressure Chain:** Enables one of three feed rates: 16.4, 23, and 32.8 FPM.



## Belt Oscillation

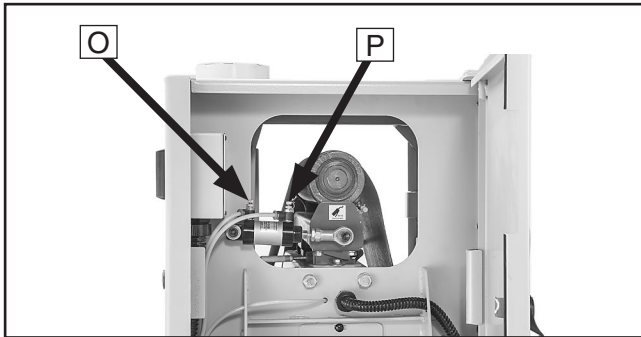


Figure 6. Oscillation speed controls.

- O. **Left Speed Control Knob:** Controls oscillation speed as belt moves *away from* you when facing the pneumatic cylinder.
- P. **Right Speed Control Knob:** Controls oscillation speed as belt moves *toward* you when facing the pneumatic cylinder.

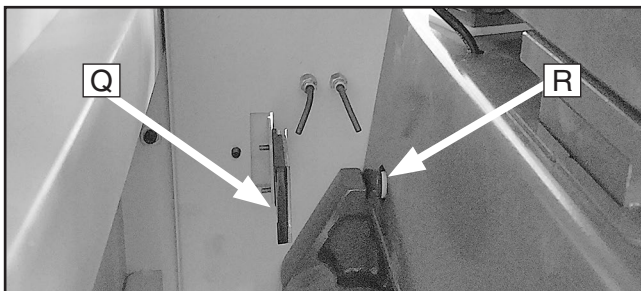


Figure 7. Location of electronic eye and mirror.

- Q. **Electronic Eye:** Works with mirror to control drum oscillation. When sanding belt passes between these it breaks signal, causing drum to rotate.
- R. **Mirror:** Receives signal from electronic eye.

## Belt Tension

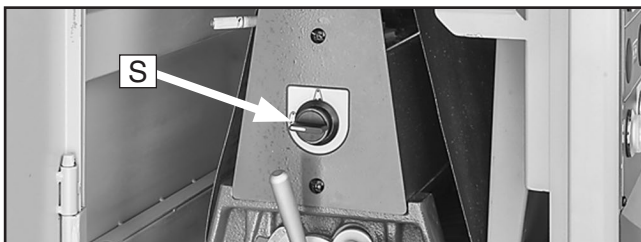


Figure 8. Sanding belt tension knob location.

- S. **Sanding Belt Tension Knob:** Increases or decreases sanding belt tension. Rotate counterclockwise to remove old sanding belt. Rotate clockwise to tension new sanding belt.

## Air Regulation

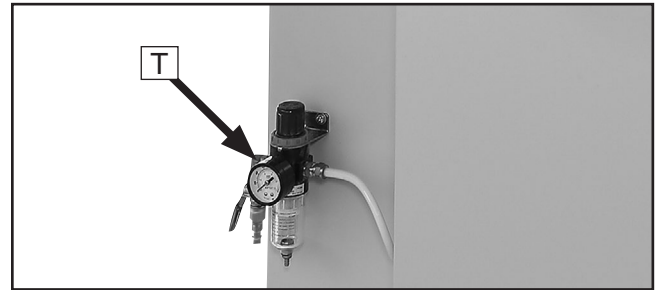


Figure 9. Air pressure regulator location.

- T. **Air Pressure Regulator:** Regulates incoming air pressure for sanding belt oscillation when ON/OFF handle is in OPEN position. Connect air inlet to compressed air supply of at least 75 PSI, with a 1/4" NPT female connector. Set needle on air pressure gauge to approximately 75 PSI using regulator knob.

## Platen

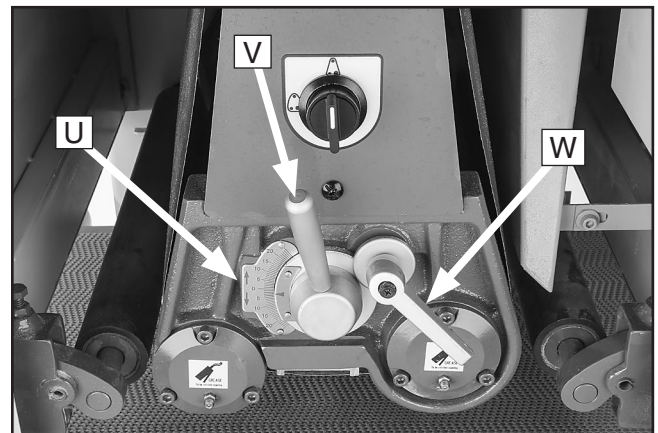


Figure 10. Platen height controls.

- U. **Platen Scale:** Indicates height of platen above or below sanding drums.
- V. **Platen Height Lever:** Adjusts platen height for three basic types of sanding: the initial heavy sanding pass, the intermediate finishing pass, and the final sanding pass.
- W. **Platen Adjustment Lock Lever:** Locks platen height setting.





# MACHINE DATA SHEET

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

## MODEL G0819 15" OPEN-END WIDE BELT SANDER

### Product Dimensions:

Weight..... 794 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 29-1/8 x 38-1/2 x 64-1/2 in.  
Footprint (Length x Width)..... 19-1/2 x 27-1/2 in.

### Shipping Dimensions:

Type..... Wooden Crate  
Content..... Machine  
Weight..... 930 lbs.  
Length x Width x Height..... 45 x 33 x 75 in.  
Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 32.8A  
Minimum Circuit Size..... 50A  
Connection Type..... Permanent (Hardwire to Shutoff Switch)  
Switch Type..... Control Panel w/Magnetic Switch Protection

### Motors:

#### Main

Horsepower..... 5 HP  
Phase..... Single-Phase  
Amps..... 30A  
Speed..... 1720 RPM  
Type..... TEFC Capacitor-Start Induction  
Power Transfer ..... Belt Drive  
Bearings..... Sealed & Permanently Lubricated  
Centrifugal Switch/Contacts Type..... External

#### Feed

Horsepower..... 1/2 HP  
Phase..... Single-Phase  
Amps..... 2.8A  
Speed..... 34 RPM  
Type..... TEFC Induction w/50:1 Gear Reducer  
Power Transfer ..... Chain Drive  
Bearings..... Sealed & Permanently Lubricated  
Centrifugal Switch/Contacts Type..... N/A





**Main Specifications:**

**Operation Information**

Number of Sanding Heads.....	1
Maximum Board Width.....	15 in.
Minimum Board Width.....	2 in.
Maximum Board Thickness.....	6 in.
Minimum Board Thickness.....	5/32 in.
Minimum Board Length.....	12-5/8 in.
Sandpaper Speed.....	2300 FPM
Conveyor Feed Rate.....	16.4, 23, 32.8 FPM
Sandpaper Length.....	48 in.
Sandpaper Width.....	16 in.

**Drum Information**

Infeed Sanding Drum Type.....	Spiral Grooved Rubber
Infeed Sanding Drum Size.....	4 in.
Outfeed Sanding Drum Type.....	Steel
Outfeed Sanding Drum Size.....	3 in.
Shore Hardness (Durometer).....	65 Shore

**Platen Information**

Platen Type.....	Graphite Pad
Platen Length.....	15-3/8 in.
Platen Width.....	1-3/4 in.

**Construction**

Conveyor Belt.....	Rubber
Body.....	Cast Iron

**Other Related Information**

Floor To Table Height.....	34-1/4 – 40-1/8 in.
Sanding Belt Tension.....	Pneumatic
Number of Pressure Rollers.....	2
Pressure Roller Type.....	Rubber Coated
Pressure Roller Size.....	2 x 15-3/4 in.
Conveyor Table Length.....	24 in.
Conveyor Belt Length.....	69-5/8 in.
Conveyor Belt Width.....	15 in.
Belt Roller Size.....	4 in.
Number of Dust Ports.....	1
Dust Port Size.....	5 in.
Air Requirement.....	75 PSI

**Other Specifications:**

Country of Origin .....	Taiwan
Warranty .....	1 Year
Serial Number Location .....	ID Label
ISO 9001 Factory .....	Yes



# SECTION 1: SAFETY

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

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



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



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



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

**NOTICE**

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

## Safety Instructions for Machinery

### **WARNING**

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

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

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

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

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

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

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



# WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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





# Additional Safety for Wide Belt Sanders

## WARNING

Serious injury or death can occur from getting hands trapped between workpiece and conveyor table and being pulled into machine, or becoming entangled in rotating parts inside machine. Workpieces thrown by sander can strike nearby operator or bystanders with significant force. Long-term respiratory damage can occur from using sander without proper use of a respirator. To reduce the risk of these hazards, operator and bystanders **MUST** completely heed the hazards and warnings below.

**FEEDING WORKPIECE.** Placing fingers between workpiece and conveyor can result in pinching injuries, or possibly getting trapped and pulled into sanding area of machine. **DO NOT** place fingers under bottom of workpiece while feeding it into sander.

**SANDING DUST.** Sanding creates large amounts of fine airborne dust that can lead to eye injury or serious respiratory illness. Reduce your risk by always wearing approved eye and respiratory protection when sanding. Never operate without adequate dust collection system in place and running. However, dust collection is not a substitute for using a respirator.

**POWER DISCONNECT.** An accidental startup while changing sanding belts or performing adjustments or maintenance can result in entanglement or abrasion injuries. Make sure machine is turned **OFF**, disconnected from power and air, and all moving parts are completely stopped before changing belts, doing adjustments, or performing maintenance.

**KICKBACK.** Occurs when a workpiece is ejected out the front of sander at a high rate of speed toward operator or bystanders. To reduce risk of kickback-related injuries, always stay out of workpiece path, only feed one board at a time, and always make sure pressure rollers are properly adjusted below sanding roller. Never sand workpieces below minimum specifications listed in **Machine Data Sheet**.

**AVOIDING ENTANGLEMENT.** Tie back long hair, remove jewelry, and do not wear loose clothing or gloves. These can easily get caught in moving parts. Never reach inside machine or try to clear jammed workpiece while machine is operating. Keep all guards in place and secure.

**SANDPAPER CONTACT.** Rotating sandpaper can remove a large amount of flesh quickly. Keep hands away from rotating sanding drum(s) during operation. Never touch moving sandpaper.

## WARNING

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

## CAUTION

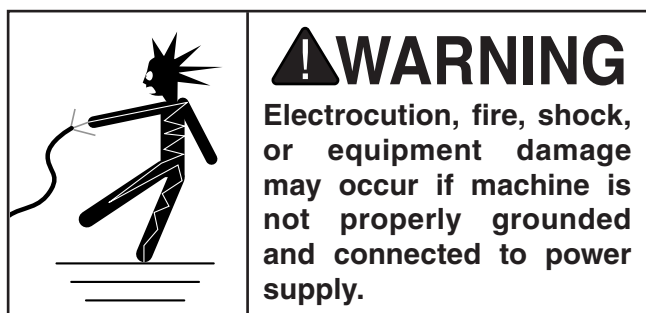
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



# SECTION 2: POWER SUPPLY

## Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



## Full-Load Current Rating

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

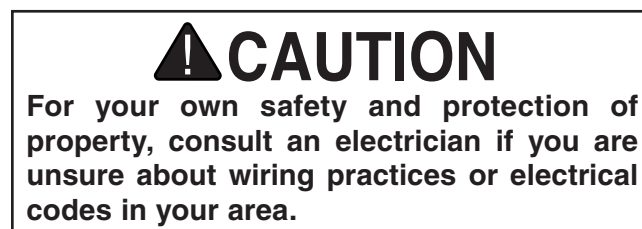
**Full-Load Current Rating ..... 32.8 Amps**

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

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

## Circuit Information

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



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

## Circuit Requirements

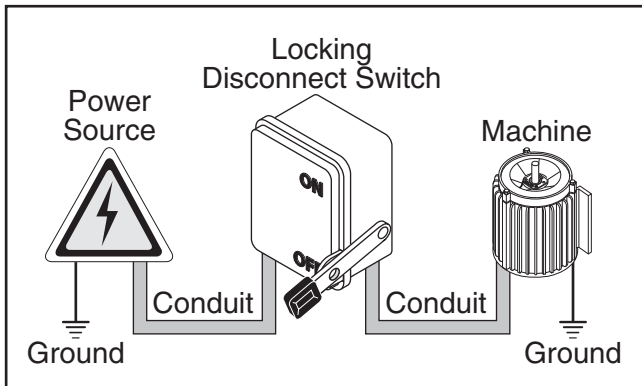
This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

**Nominal Voltage ..... 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 50 Amps**



## Connection Type

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



**Figure 11.** Typical setup of a permanently connected machine.

## Grounding Instructions

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

### **!WARNING**

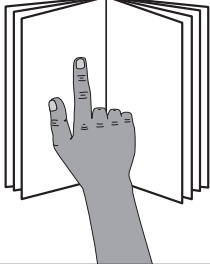
**Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.**

## Extension Cords

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



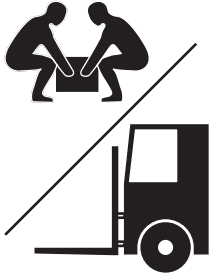
# SECTION 3: SETUP



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



**!WARNING**  
 Wear safety glasses during the entire setup process!



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

## Needed for Setup

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

Description	Qty
• Another Person .....	1
• Safety Glasses (for each person).....	1
• Lifting Equipment (Rated for at least 1000 lbs.) .....	1
• Wrench or Socket 14mm .....	1
• Solvent/Cleaner .....	As Needed
• Shop Rags.....	As Needed
• Air Compressor (Minimum Rating 75 PSI) .	1
• Airline Hose Fitting .....	1
• Airline (Rated for 75 PSI).....	1
• ¼ NPT Female Connector .....	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.

<b>Loose Item Inventory (Figure 12)</b>	<b>Qty</b>
<b>A.</b> Sanding Belts 16" x 48": 100-Grit & 180-Grit.....	1 Ea.
<b>B.</b> Tool Box.....	1
<b>C.</b> Platen Graphite Pads .....	2
<b>D.</b> Platen Felt Pads .....	1
<b>E.</b> Door Latch Keys 8mm.....	2
<b>F.</b> Open-End Wrenches: 8/10, 12/14, 17/19mm.....	1 Ea.
<b>G.</b> Platen Removal Tool .....	1
<b>H.</b> Screwdrivers: Phillips #2, Flat Head....	1 Ea.
<b>I.</b> Belt Oscillation Limit Switch Shafts.....	2
<b>J.</b> Hex Wrenches: 1.5, 2, 2.5, 3, 4, 5, 5.5, 6, 8, 10mm .....	1 Ea.

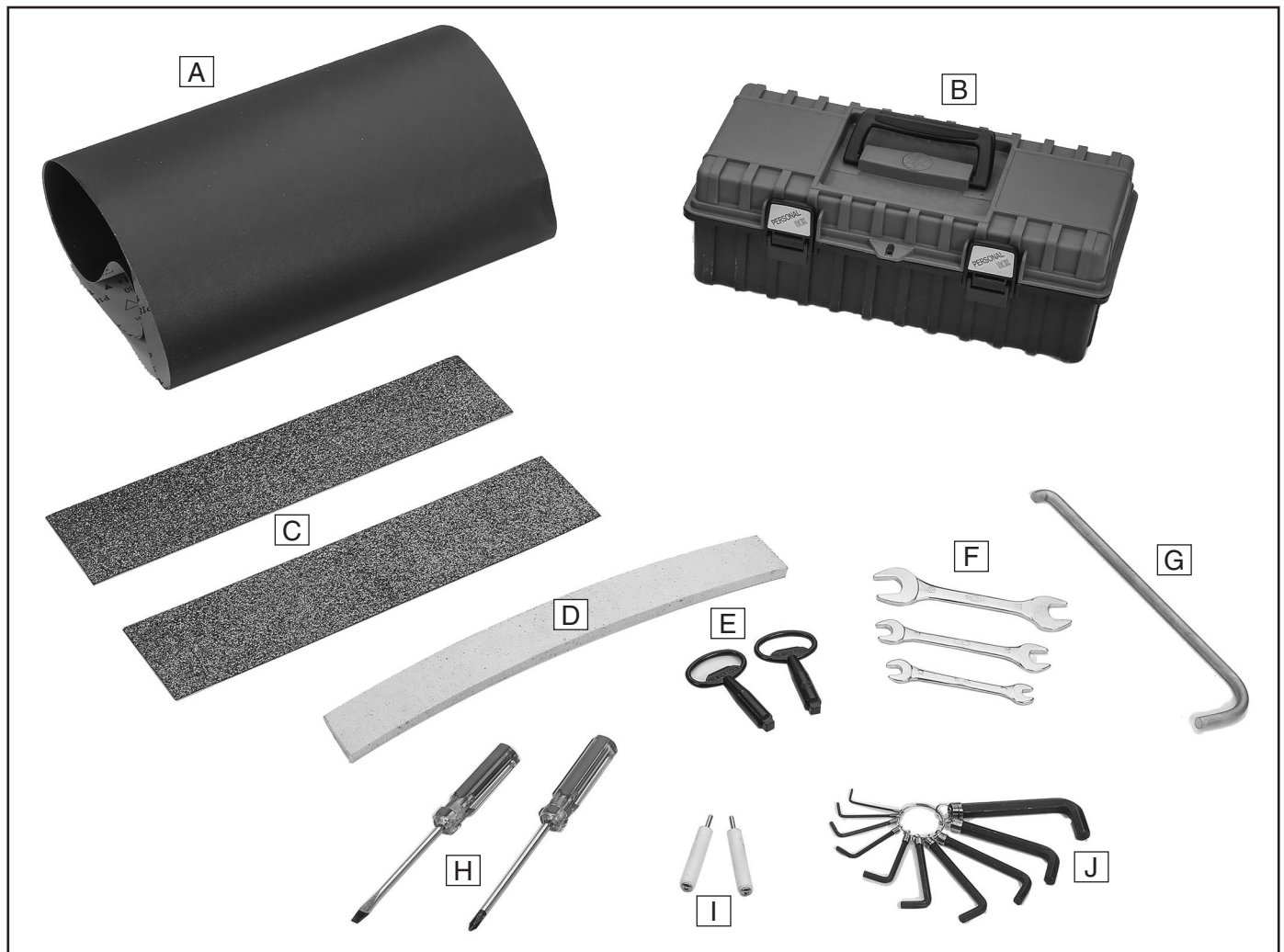


Figure 12. Loose item inventory.



# Cleanup

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

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

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

## Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

## Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

## NOTICE

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

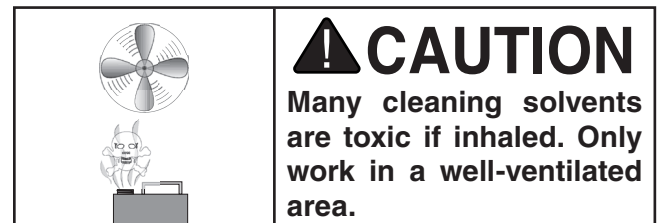
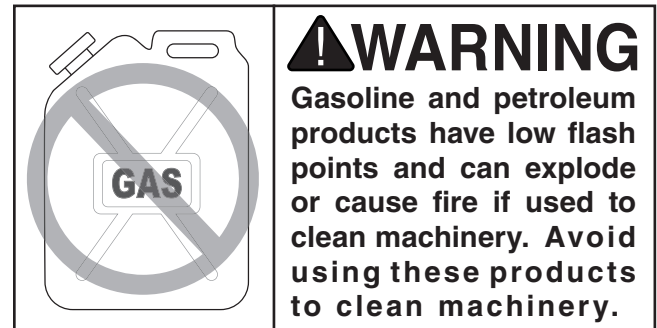
## The following surface needs to be cleaned:

- Upper steel sanding belt roller

To access the steel sanding belt roller (see **Figure 13**), unlock the right or left access doors, and clean as needed.



**Figure 13.** Steel sanding belt roller that must be cleaned thoroughly before using machine.



## T23692—Orange Power Degreaser

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



**Figure 14.** T23692 Orange Power Degreaser.





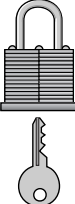
# Site Considerations

## 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.**

	<p><b>CAUTION</b> Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
---	---

## 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.

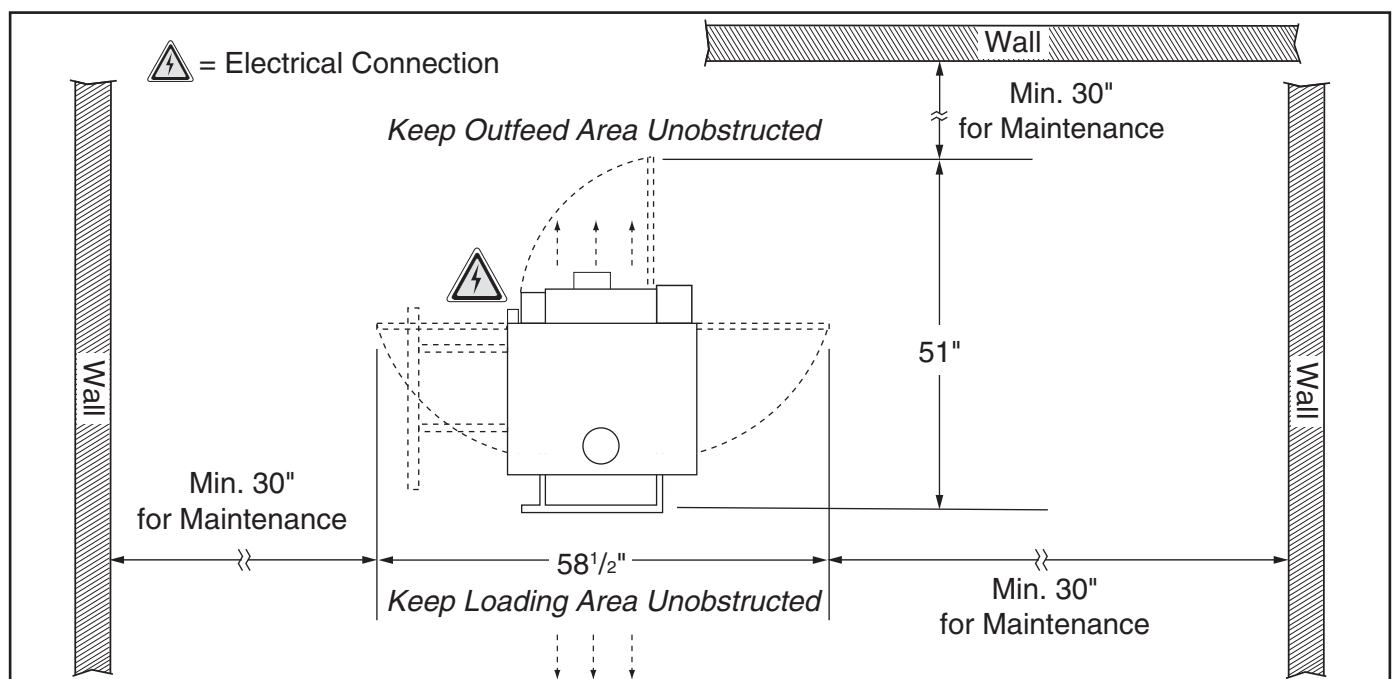
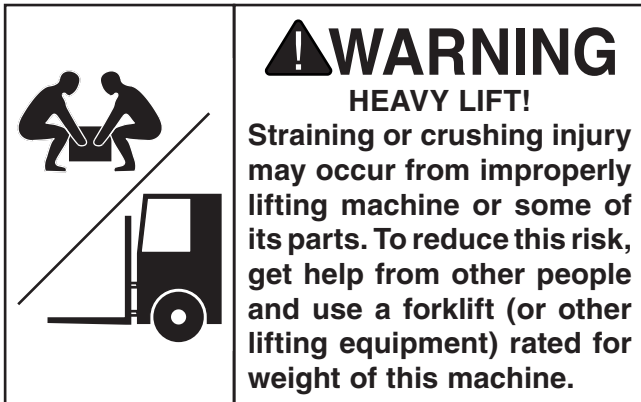


Figure 15. Minimum working clearances.



# Lifting & Placing



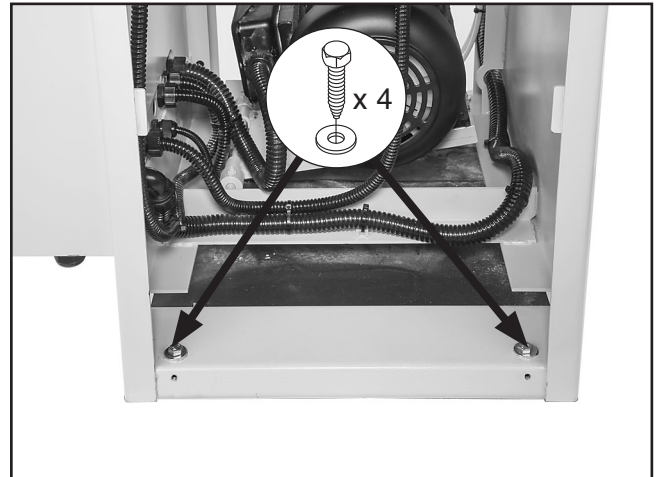
Do not attempt to lift or move this machine without using the proper lifting equipment (such as forklift or crane) or the necessary assistance from other people. Each piece of lifting equipment must be rated for at least 1000 lbs. to support dynamic loads that may be applied while lifting. Refer to **Needed for Setup** on **Page 14** for complete list of needed equipment for setup and installation.

## To lift and move machine:

1. Remove shipping crate top and sides, then remove small components from shipping pallet.
2. Move machine to its prepared location while it is still attached to shipping pallet.

3. Open lower access panels, and remove (4) lag screws and flat washers that secure machine to pallet (see **Figure 16**).

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



**Figure 16.** Access panel removed to expose mounting hardware (left side shown).

4. Use forklift (see **Figure 17**) to lift machine just enough to clear pallet, then move pallet out of the way, and gently lower machine onto floor.



**Figure 17.** Lifting machine with forklift.





# Anchoring to Floor

Number of Mounting Holes ..... 4  
 Diameter of Mounting Hardware..... 1/2"

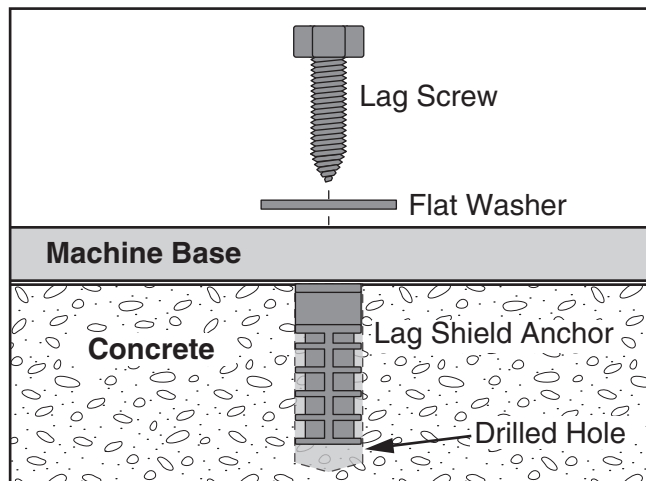
Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

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

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

## Anchoring to Concrete Floors

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



**Figure 18.** Popular method for anchoring machinery to a concrete floor.

# Dust Collection

## ⚠ CAUTION

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

### Minimum CFM at Dust Port: 650 CFM

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

### To connect dust collection system to machine:

1. Fit 5" dust hose over dust port, as shown in **Figure 19**, and secure with a hose clamp.



**Figure 19.** Dust hose attached to dust port.

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

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



# Air Connection

The Model G0819 uses compressed air to control belt tension and oscillation. Before starting the machine, connect it to a compressed air supply that can deliver 75 PSI.

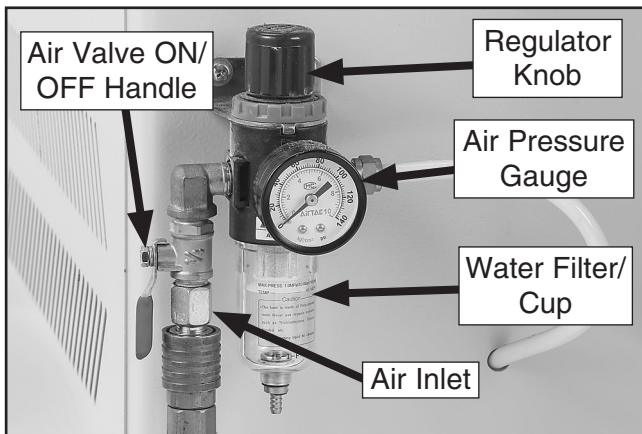
**Note:** *The machine will not run unless properly connected to an air supply.*

## To connect air supply to sander:

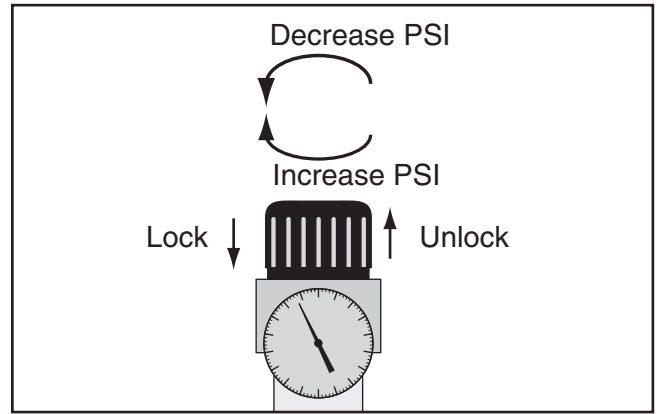
1. Connect air supply to air inlet (see **Figure 20**) on regulator with a ¼" NPT female connector.
2. Move red ON/OFF valve handle to down (OPEN) position (see **Figure 20**).

**Note:** *It is normal to hear a small amount of air releasing from machine when air supply is connected and machine is not running.*

3. Pull regulator knob up to unlock it (see **Figures 20–21**) and rotate it until air pressure gauge reads approximately 75 PSI. Then push knob down until it snaps into position to lock setting in place.



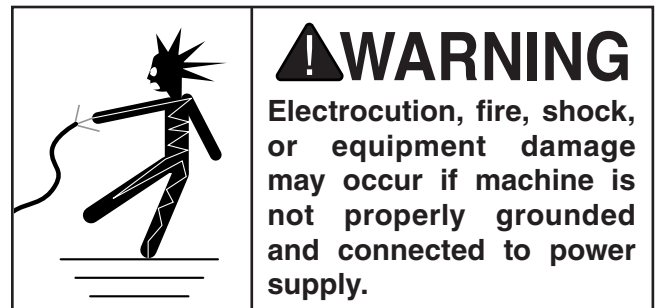
**Figure 20.** Air hose attached to regulator.



**Figure 21.** Regulator knob controls/functions.

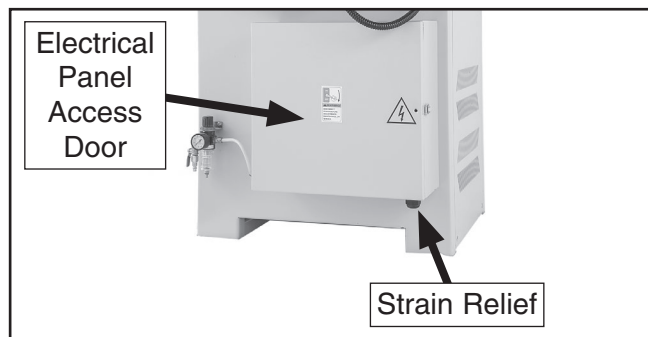
# Power Connection

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



## Connecting Power Supply Wires

1. Unlatch and open electrical panel access door (see **Figure 22**).
2. Insert incoming power wires where strain relief is located on cabinet next to electrical panel access door (see **Figure 22**).

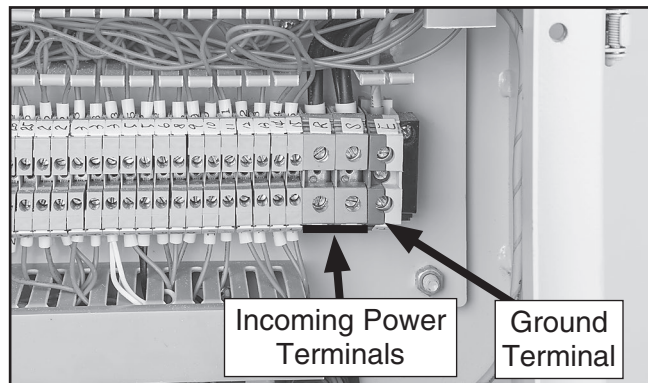


**Figure 22.** Location of electrical panel and strain relief.

## **!WARNING**

During next step, make sure incoming ground wire is connected to right-most terminal (see "Ground Terminal" in Figure 23 to ensure machine will be properly grounded). An ungrounded or improperly grounded machine could cause electrocution if live electrical wires make contact with the frame or other parts touched by the operator.

3. Connect ground wire to bottom of ground terminal **E**, then connect incoming power wires to bottom **R** and **S** terminals shown in **Figure 23**.

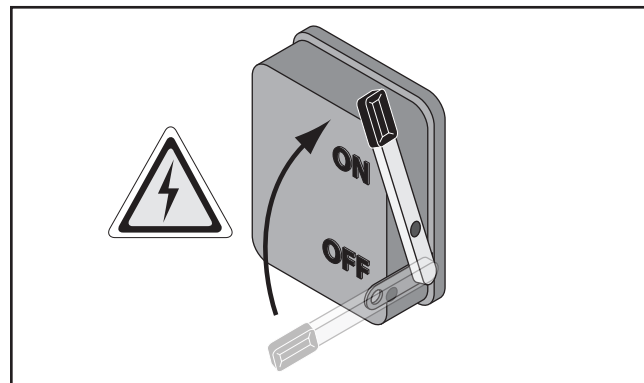


**Figure 23.** Terminal locations to connect incoming power wires and ground wire.

4. Make sure wires have enough slack inside electrical panel so they are not pulled tight or stretched.
5. Close and secure electrical panel door, then perform **Test Run**.

## Connecting to Power Source

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

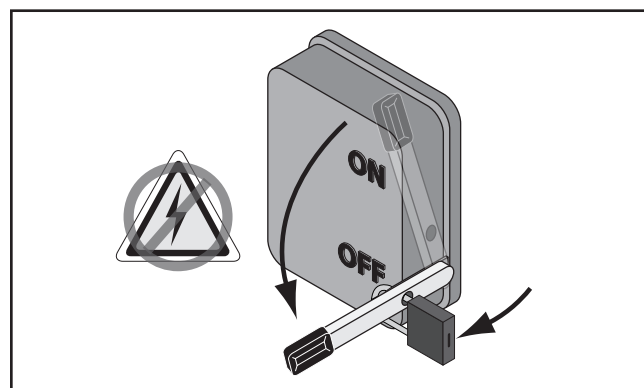


**Figure 24.** Connecting power to machine.

## Disconnecting from Power Source

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

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



**Figure 25.** Disconnecting power from machine.



# Test Run

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

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

The test run consists of verifying the following: 1) the main motor powers up and runs correctly, 2) the Emergency Stop button works correctly, 3) the feed motor powers up and runs correctly, and 4) the Emergency Stop Plate works correctly.

## **! WARNING**

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

## **! WARNING**

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

### To test run machine:

1. Clear all setup tools away from machine.
2. Press Emergency Stop button on control panel (see **Figure 26**).

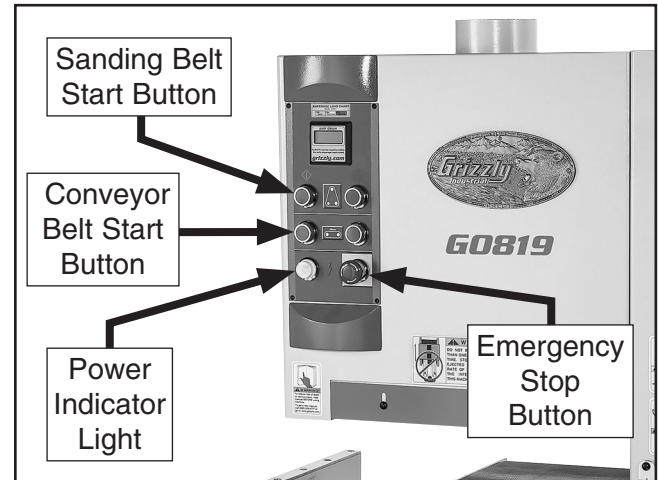


Figure 26. Location of control panel controls.

3. Open air valve so machine is getting proper air supply (refer to **Page 20**).

**Note:** It is normal to hear a small amount of air releasing from machine when air supply is connected and machine is not running.

4. Install sanding belt (refer to instructions on **Page 26**).
5. Connect machine to power supply. Power indicator light should illuminate (see **Figure 26**).
6. Twist Emergency Stop button clockwise until it springs out (see **Figure 27**). This resets switch so machine can start.

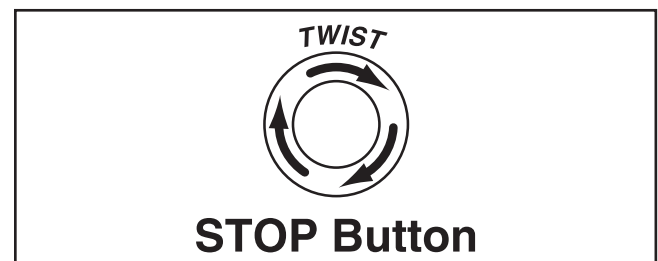


Figure 27. Resetting Emergency Stop button.



7. Press sanding belt start button (see **Figure 26** on **Page 22**) to turn main motor **ON**. Verify motor starts up and runs smoothly without any unusual problems or noises.

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

9. WITHOUT resetting Emergency Stop button, try to start main motor by pressing Sanding Belt Start button. Main motor should not start.

— If the main motor *does not* start, the safety feature of Emergency Stop button is working correctly. Proceed to **Step 10**.

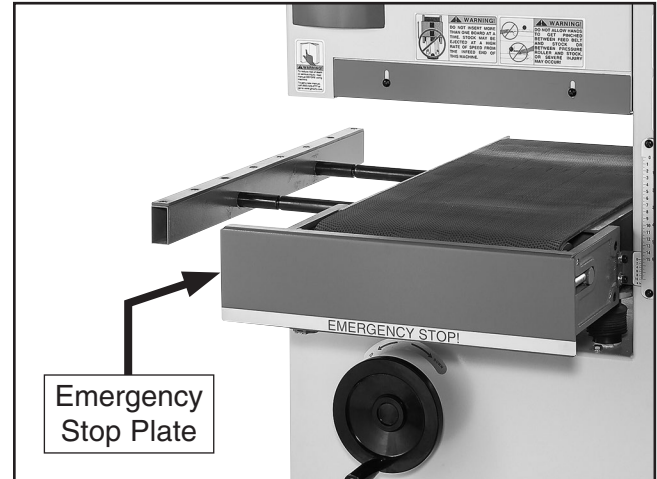
— If the main motor *does* start, immediately turn it **OFF** and disconnect power. The safety feature of the Emergency Stop button is NOT working properly. This must be troubleshot and fixed before using the machine further. (Refer to **Troubleshooting** on **Page 38**).

10. Repeat **Steps 6–9** with conveyor belt start button (see **Figure 26** on **Page 22**) to test feed motor.

The conveyor motor should run smoothly and without unusual problems or noises, and the belt should move away from the operator and toward the sanding drums.

11. Reset Emergency Stop button.

12. Press sanding belt start button and conveyor belt start button, then press Emergency Stop plate (see **Figure 28**).



**Figure 28.** Location of Emergency Stop Plate.

— If the sanding belt and conveyor belt come to a complete stop, the safety feature of the Emergency Stop plate is working correctly.

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

Congratulations! The Test Run is complete.



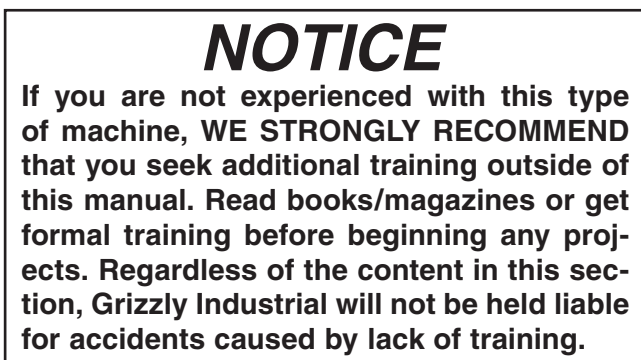
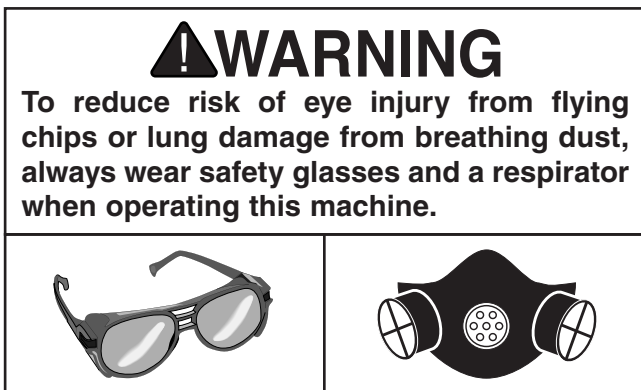


# SECTION 4: OPERATIONS

## Operation Overview

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

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



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

1. Examines workpiece to verify it is suitable for sanding and to determine which sanding belt grit size to start with.
2. Installs and tensions sanding belt. Adjusts platen position as necessary.
3. Verifies workpiece will have necessary outfeed clearance and support. If workpiece is wider than conveyor table, operator adjusts table extension for workpiece width.
4. Adjusts table height to approximate workpiece thickness.
5. Puts on required safety glasses and respirator.
6. Ensures dust collection system is connected to dust port, and starts dust collector.
7. Starts main sanding motor, then feed motor.
8. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers. **Note:** During initial pass with a new workpiece, operator adjusts table height as necessary so workpiece only makes light contact with sanding belt and does not overload sander.
9. Receives workpiece from outfeed side of conveyor table. If workpiece is wider than conveyor table, operator rotates workpiece 180° and feeds workpiece back through sander.
10. Raises height of conveyor table a small amount ( $\frac{1}{4}$  to 1 full rotation of handwheel), then repeats the feeding process of workpiece through sander.
11. Changes sandpaper to a finer grit.
12. Repeats **Steps 8–11** as needed, turns sander **OFF**, and disconnects it from power.



# Workpiece Inspection

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Some workpieces are not safe to sand, or they may require further preparation before they can be safely sanded without increasing risk of injury to the operator or damaging the sanding belt or the sander.

**Before sanding, inspect all workpieces for the following:**

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

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

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear the sanding belt. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT sand the workpiece.
- **Wet or "Green" Stock:** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding belt, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to sand because they are unstable and often unpredictable when being sanded. DO NOT use workpieces with these characteristics!

- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side is facing the table. On the contrary, a workpiece supported on the bowed side will likely rock during sanding, which may result in the workpiece being ejected back toward the operator (i.e. kickback) with enough force to cause an impact injury.

## Installing/Changing Sanding Belt

---

**Required Sanding Belt Size** ..... 16" x 48"

Included 16" x 48" Sanding Belts	Qty
100-Grit.....	1
180-Grit.....	1

The Model G0819 only accepts 16" wide by 48" long sanding belts. For additional sanding belt selections beyond those included with the machine, see the **Accessories** section, beginning on **Page 33**.

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

**When choosing a sanding belt, use these grit numbers as a general guide:**

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

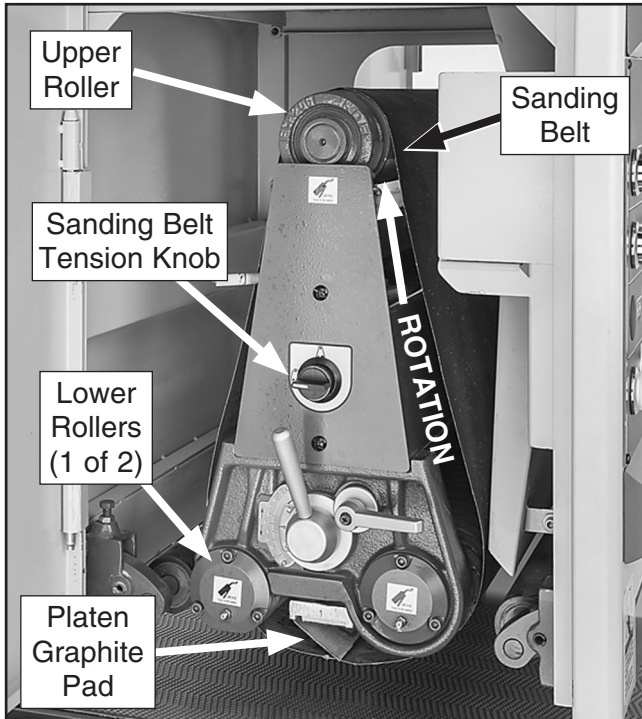
The general rule of thumb is to sand a workpiece with progressively higher grit numbers—in increments of 50 or less.

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

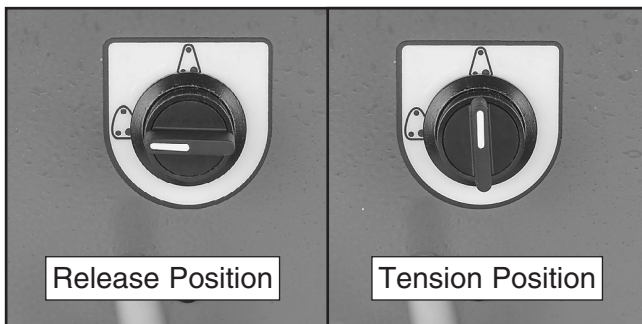


### To install sanding belt:

1. Connect machine to compressed air (see **Page 20**), open air valve, then open upper left access door.
2. Rotate sanding belt tension knob (see **Figure 29**) to "Release" position (see **Figure 30**), and remove existing belt (if installed).



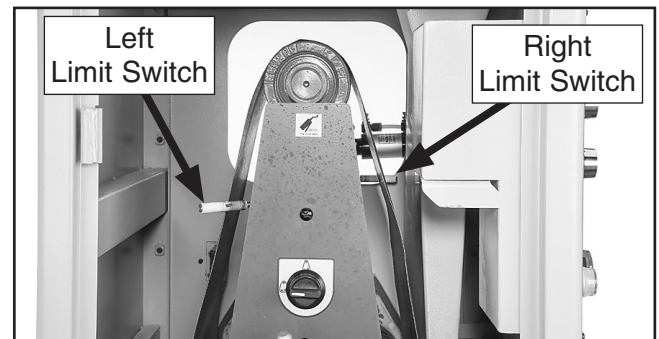
**Figure 29.** Sanding belt installation components.



**Figure 30.** Sanding belt tension knob positions.

3. Make sure rotation arrows on sanding belt point in same direction as belt rotation (see **Figure 29**), install sanding belt by starting first on the upper roller and then the lower rollers. Make sure the platen graphite pad points towards the front of the machine.

**Note:** The sanding belt must be centered between the limit switches, as shown in **Figure 31**, before the belt is tensioned. Damage to the sanding belt and sander may occur if the sander is turned **ON** before the sanding belt is correctly positioned.



**Figure 31.** Identification of sanding belt limit switches.

## **NOTICE**

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

4. With hands clear of all moving parts, tension belt by rotating belt tension knob to "Tension" position (see **Figure 29**), then close and secure upper left access door.

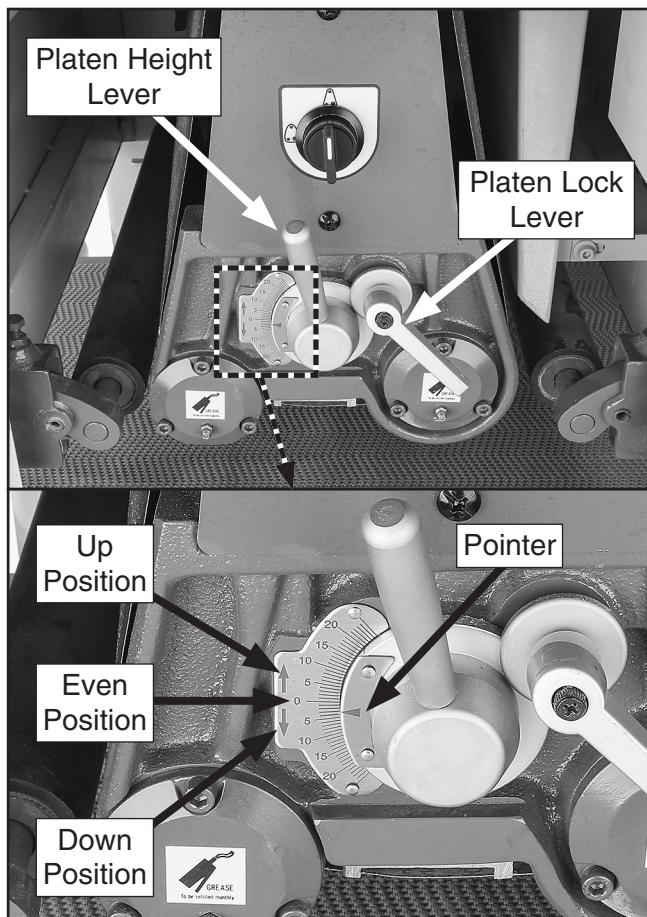




# Adjusting Platen

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

The platen position allows for 3 basic types of sanding: up, even, and down, which are adjusted by unlocking the platen lock lever and rotating the scale pointer arrow with the height lever shown in **Figure 32** to the desired position. The setting is secured for the sanding operation with the lock lever.



**Figure 32.** Platen height scale controls and positions.

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

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

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

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

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

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

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

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

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

## NOTICE

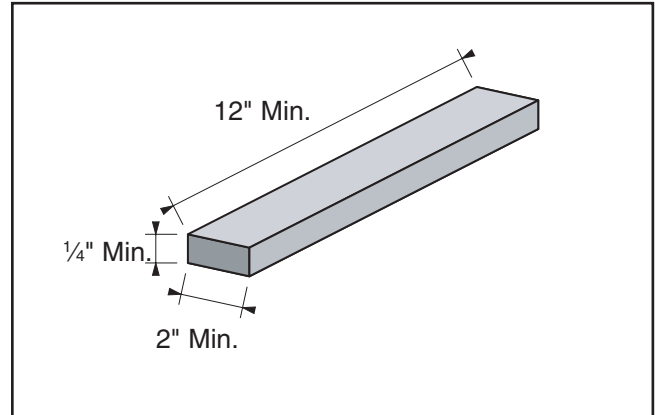
If workpiece has straight notches across it, graphite cloth and felt have worn out and need to be replaced immediately.



# Sanding Tips

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- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.
  - Only sand with as slow of feed speeds as necessary to meet your sanding goals. In other words, avoid running the sander faster than is necessary. Increasing feed speeds beyond the required level can decrease the quality of the finished product.
  - As a general rule, use the sanding drum for the initial heavy sanding pass, then use a combination of the platen and drum for the intermediate pass, and the platen alone for the final sanding passes.
  - As a rule-of-thumb, sand with progressively higher grit numbers in increments of 50 or less.
  - Replace sandpaper with a higher grit to achieve a finer finish (refer to **Choosing Sandpaper** on **Page 25**).
  - When making multiple passes on the workpiece, avoid raising the conveyor table more than 0.015" (nearly one turn of the height handle) per each pass.
  - Reduce snipe when sanding more than one board of the same thickness by feeding them into the machine with the front end of the second board touching the back end of the first board (aka "Butt Feeding").
  - Feed boards into the machine at different points on the conveyor to maximize sandpaper life and prevent uneven belt wear.
- DO NOT sand boards less than 12" long, 2" wide and 1/4" thick to prevent damage to the workpiece and the sander (see **Figure 33**).



**Figure 33.** Minimum dimensions for sanding.

- Extend the life of the sandpaper by regularly cleaning the sanding belt (see **Page 37**).
- DO NOT edge-sand boards. This can cause boards to kickback, causing serious personal injury, and cause damage to the conveyor belt and sanding belt.
- Only use the amp load meter to keep the motor from overloading—that is its main purpose. Avoid using the amp load meter to monitor how much material is being removed, as this can lead to problems, including belts loading, burning, and poor quality sanding results.
- Make sure to adjust platen position accordingly when changing grit sizes.
- The faster the feed rate you use, the faster your sanding belts will wear out.



# Amp Load Meter

The amp load meter (see **Figure 34**) is used to keep the motor from being overloaded during sanding operations. It should not be used as the main method for controlling sanding belt material removal rates—doing so can result in many problems, including belts loading, burning, and even breaking—because there are many different variables that affect optimum removal rates and these will affect the amp load in different ways.

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



**Figure 34.** Location of amp load meter.

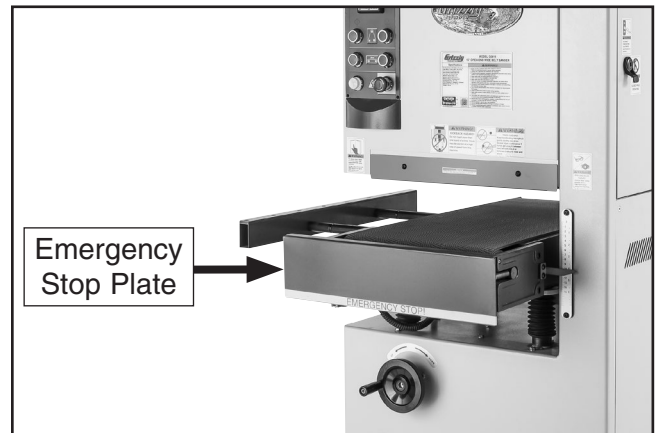
As a general rule, always start with a small load and work your way up. DO NOT work the machine to its maximum load, or to where you can hear the motor lose RPM; instead, make multiple light passes or install a coarser grit sandpaper.

## **NOTICE**

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

# Using EMERGENCY STOP Plate

The emergency stop plate can help reduce the amount of damage to internal components during an emergency. Pushing the emergency stop plate (see **Figure 35**) causes the disc brake to stop the motor, immediately halting all moving components, including the sanding belt and conveyor belt.



**Figure 35.** Location of emergency stop plate.

## **CAUTION**

**Keep sanding drum V-belts correctly tensioned (refer to Page 51) to ensure proper functionality of emergency stop plate. Otherwise, pulleys can slip when emergency stop brake is applied and not immediately stop machine in the event of an emergency!**



# Sanding Workpieces

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

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

Attempts to remove too much material at one time can cause jamming, wood burning, rapid sandpaper wear or tearing, poor finish, short motor life, and belt slippage. The operator usually makes a pass, raises the table a little, and repeats until the entire surface is sanded to satisfaction. Before sanding, ensure you review **Workpiece Inspection** on **Page 25** and put on the required safety glasses and respirator.

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

The overall sanding process consists of the operator starting sanding with the platen in the up position with a coarse grit sandpaper, such as #60, and then repeating this for subsequent grit sizes from #80–#100 until the workpiece is evenly smooth. The operator then sets the platen level with the drums and performs intermediate sanding passes using #100–#150 grit sandpaper. For the final sanding pass, the operator sets the platen in the down position and sands the workpiece using #180 grit or finer sandpaper. Refer to **Adjusting Platen** on **Page 27** for more information about platen positions.

**Important:** *As you sand, observe the amp load meter (see **Figure 34**) on **Page 29**. If the amp load meter indicates motor overload, slightly lower the table with the handwheel or reduce the feed rate (refer to **Page 31**).*

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

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

## Approximate Max Depth-of-Cut for 15" Stock

### 16 FPM

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

### 23 FPM

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

### 33 FPM

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

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

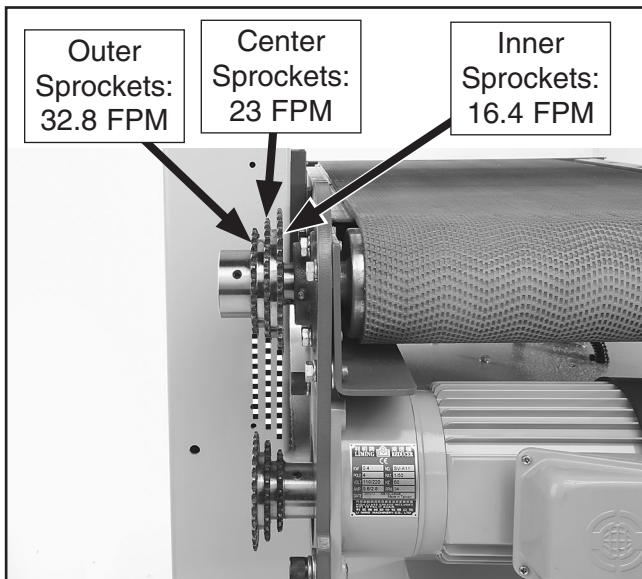




# Changing Feed Rate

The conveyor belt has three feed rates, which are controlled by the chain position on the sprockets of the feed motor and conveyor roller (see **Figure 36**).

**Conveyor Feed Rates..... 16.4, 23, 32.8 FPM**



**Figure 36.** Chain positions for setting conveyor belt feed rate.

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

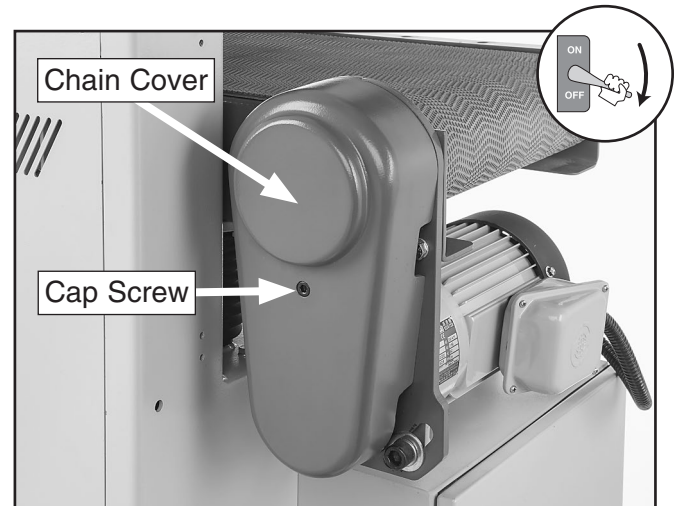
Softwoods typically require a faster feed rate than hardwoods; however, there is no definitive rule to follow when determining the best feed rate to use for any type of wood.

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

Tools Needed	Qty
Hex Wrench 6mm.....	1
Hex Wrench 12mm.....	1

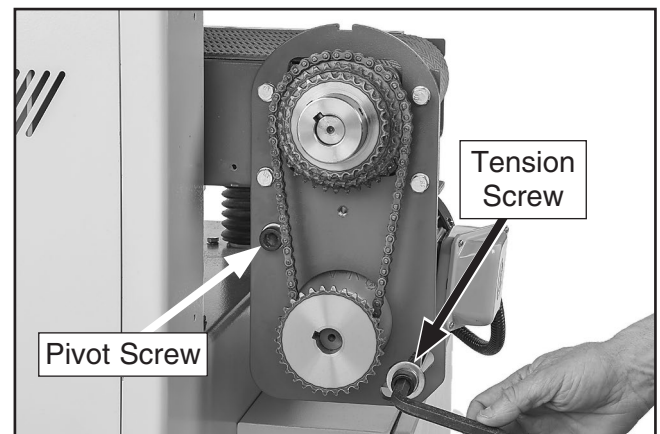
To change feed rate:

1. DISCONNECT MACHINE FROM POWER!
2. Remove cap screw and chain cover shown in **Figure 37**.



**Figure 37.** Chain cover and cap screw that must be removed to adjust the feed rate.

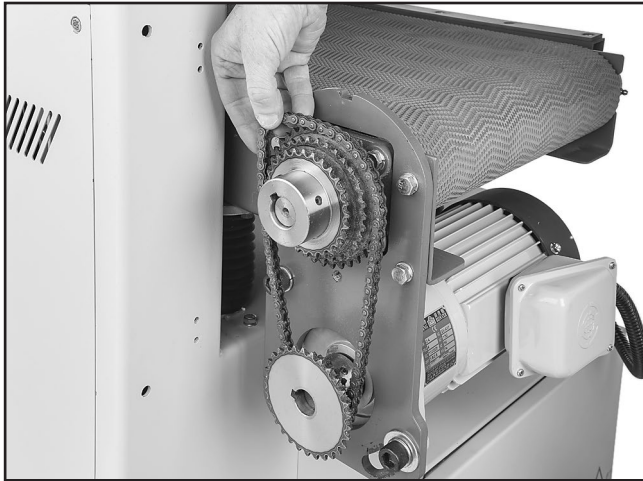
3. Loosen pivot screw and tension screw (see **Figure 38**), lift motor to release chain tension, then tighten tension screw to secure motor in place.



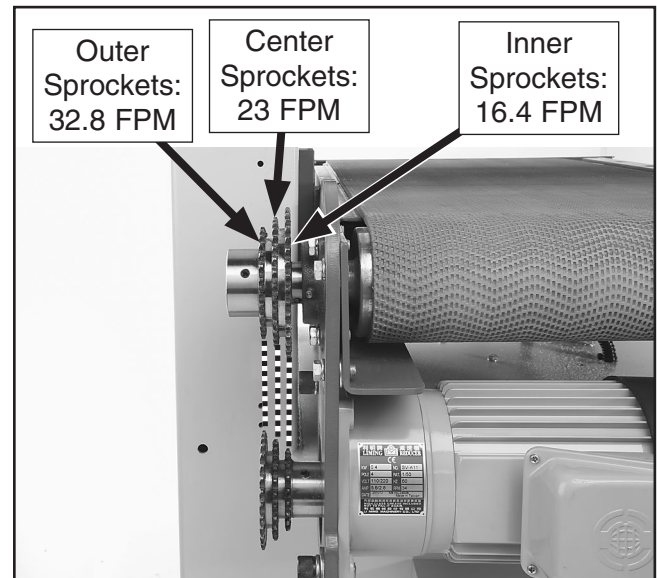
**Figure 38.** Screws used to loosen chain tension when changing feed rate.



4. Reposition chain onto set of sprockets that correspond to desired feed rate (see **Figures 39–40**).



**Figure 39.** Repositioning chain on sprockets to change feed rate.



**Figure 40.** Chain positions for available feed rates.

5. Loosen tension screw from **Step 3**, move motor down to re-tension chain, then tighten tension screw motor position and pivot screw to secure (see **Figure 38** on **Page 31**).
6. Re-install chain cover and cap screw removed during **Step 2**.



# 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.

### **Pasco Sanding Belts 16" x 48" X-Weight Aluminum-Oxide**

T21022—60-Grit  
T21023—80-Grit  
T21024—100-Grit  
T21025—120-Grit  
T21026—150-Grit  
T21072—60-Grit (5-Pk.)  
T21073—80-Grit (5-Pk.)  
T21074—100-Grit (5-Pk.)  
T21075—120-Grit (5-Pk.)  
T21076—150-Grit (5-Pk.)

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



**Figure 41.** Pasco 16" x 48" X-weight sanding belts.

### **Pasco Sanding Belts 16" x 48" Y-Weight Aluminum-Oxide**

H4173—60-Grit  
H4174—80-Grit  
H4175—100-Grit  
H4176—120-Grit  
H4177—150-Grit  
H8792—60-Grit (5-Pk.)  
H8793—80-Grit (5-Pk.)  
H8794—100-Grit (5-Pk.)  
H8795—120-Grit (5-Pk.)  
H8796—150-Grit (5-Pk.)

These 16" x 48" belts use tough Aluminum Oxide grain, open coated on a very heavy "Y" weight polyester backing with a Resin Bond system that no equivalent product can outperform. The superior backing more than justifies the additional cost over lesser "X" weight backings in their longer belt life and their ability to be washed... furthering the savings. Compare to Norton R215 or 3M™ 240D "X" weight belts!



**Figure 42.** Pasco 16" x 48" Y-weight sanding belts.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



## Steelex Sanding Belts 16" x 48" X-Weight Aluminum-Oxide

- H7875—60-Grit (5-Pk.)
- H7876—80-Grit (5-Pk.)
- H7877—100-Grit (5-Pk.)
- H7878—120-Grit (5-Pk.)
- H7879—150-Grit (5-Pk.)
- H7880—180-Grit (5-Pk.)
- H7881—240-Grit (5-Pk.)



**Figure 43.** Steelex 16" x 48" X-weight sanding belts.

## D3378—Pro-Stik 12" x 15" Cleaning Pad

## D3003—Pro-Stik 15" x 20" Cleaning Pad

The perfect accessory for wide-belt sanders, just set your table and feed this cleaning pad through for longer lasting abrasive belts. Pads are  $\frac{3}{4}$ " thick.



**Figure 44.** Pro-Stik cleaning pad.

## T26419—Syn-O-Gen Synthetic Grease

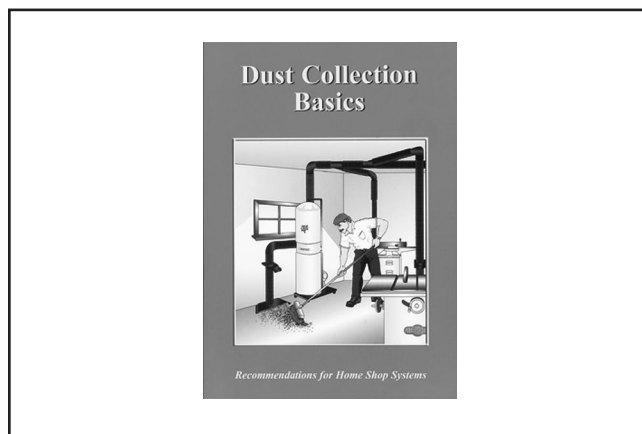
Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water-resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.



**Figure 45.** T26419 Syn-O-Gen Synthetic Grease.

## W1050—Dust Collection Basics Handbook

This inexpensive, 64-page book carefully guides you through setting up a quality dust collection system in your shop. Includes an easy-to-follow walk-through on designing the optimum dust collection system, and practical tips for minimizing cost and maximizing performance. A must have for beginners!



**Figure 46.** Dust Collection Basics handbook.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**

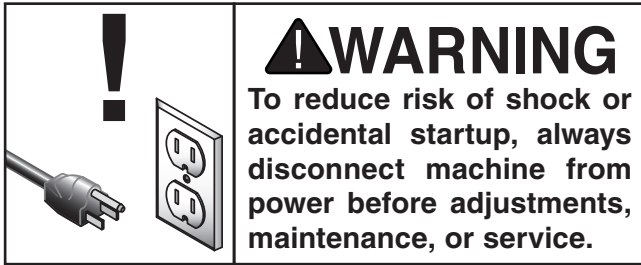




# SECTION 6: MAINTENANCE

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## Schedule

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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:

- Check/tighten loose mounting bolts.
- Check/replace worn/damaged sanding belts.
- Check for worn or damaged wires.
- Check safety features.
- Check for any unsafe condition.
- Check condition of platen graphite pad.

### Weekly Maintenance:

- Drain water in regulator water trap (**Page 37**).
- Lubricate grease fittings on conveyor belt roller axles and sanding belt axles (**Page 36**).

### Monthly Check:

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Grease table elevation chain, leadscrews, and sprockets (**Page 36**).
- Grease feed chain and sprockets (**Page 37**).

### Yearly Check:

- Replace white moisture filters on air regulator.

## Cleaning & Protecting

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Cleaning the Model G0819 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it.

## Lubrication

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

Clean the components in this section with mineral spirits.

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

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

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

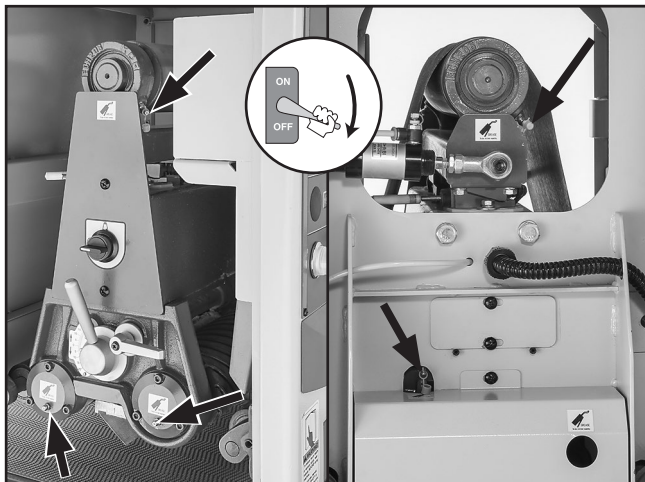
Schedules are based on average use. Adjust lubrication according to your level of use.



## Grease Fittings

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

Wipe the fittings clean with a rag. Attach a flexible grease gun extension to a grease gun. Add one or two pumps of grease to the grease fittings located on the conveyor belt roller axles and the sanding belt roller axles (see **Figures 47–48**). They are identified with yellow labels.



**Figure 47.** Locations of upper left/right sanding belt roller axle grease fittings.

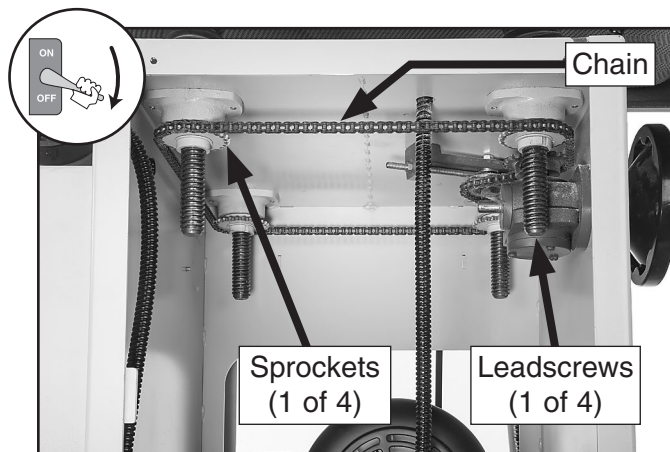


**Figure 48.** Locations of conveyor belt roller axle grease fittings (chain cover removed for access).

## Table Elevation Leadscrews, Chain & Sprockets

Lube Type ..... T26419 or NLGI#2 Equivalent  
 Oil Amount..... Thin Coat  
 Check/Add Frequency..... Monthly

Lower table all the way, then remove the lower left access panel. Use a shop rag and mineral spirits to remove the old lubricant and built-up grime from the leadscrews, chain, and sprockets (see **Figure 49**). Brush grease onto the leadscrews, chain, and sprockets, being careful to not get grease on the V-belts. This could cause the V-belts to slip on the pulleys. If you do get grease on the V-belts, replace them. Raise the table up and down a few times to evenly distribute the grease.



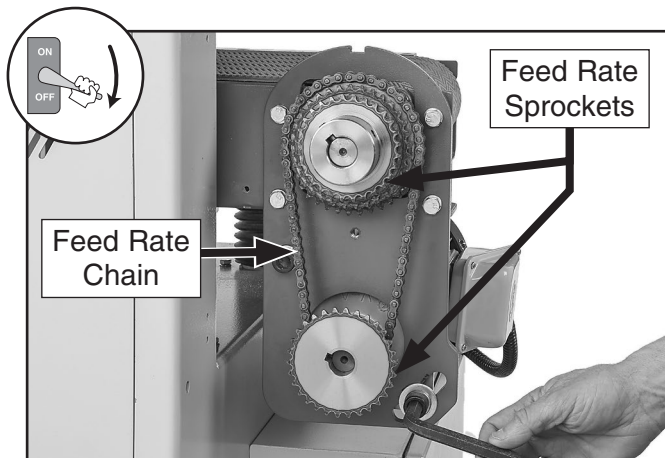
**Figure 49.** Location of table elevation leadscrews, chain, and sprockets (lower left access panel removed).



## Feed Chain & Sprockets

Lube Type ..... T26419 or NLGI#2 Equivalent  
Oil Amount.....Thin Coat  
Check/Add Frequency.....Monthly

Remove feed chain cover (refer to **Page 31** for detailed instructions), then use a shop rag and mineral spirits to remove the old lubricant and built-up grime from the chain and sprockets (see **Figure 50**). Brush grease onto the chain and sprockets, then re-install chain cover.



**Figure 50.** Lubrication locations for feed rate chain and sprockets.

## Cleaning Sanding Belt

To increase the working life of your sanding belts, clean them whenever they decrease in performance due to heavy loading of material. Use a Model D3003 Pro-Stik® Cleaning Pad as shown in **Figure 44** in **Accessories** on **Page 34**.

### To clean sanding belt:

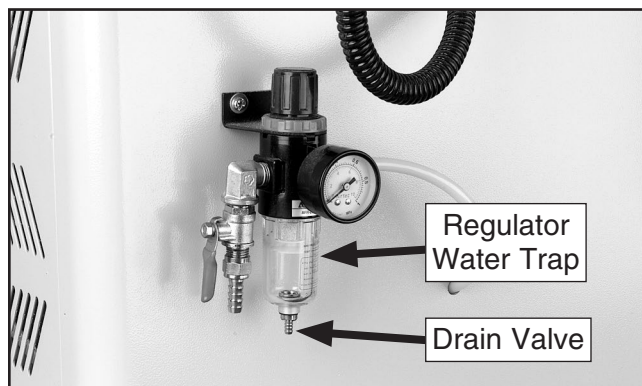
1. DISCONNECT MACHINE FROM POWER!
2. Set table to thickness of cleaning pad.
3. Connect machine to power, then run pad through sander two or three times. DO NOT take too deep of a cut—the belt should barely touch cleaning pad!

## Regulator Water Trap

The air pressure regulator water trap (see **Figure 51**) is attached to the air pressure regulator and traps condensation in the incoming air supply. The water trap must be emptied when it becomes half full. DO NOT allow the water trap to become full, or you risk serious damage to your machine.

### To empty regulator water trap:

With the system under air pressure, push the lower drain valve and empty the regulator water trap (see **Figure 51**). Also, replace the internal white moisture filters annually.



**Figure 51.** Location of regulator water trap and drain valve.

## Air System

The air system is durable and reliable; however, components do wear with age. If you suspect that an item in your air system may be having problems, see the **Air System Diagram** on **Page 58**.

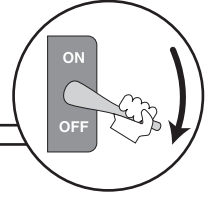
- Adjust regulator to approximately 75 PSI.
- Carefully inspect all air lines for cracks, chafing, or hardening. Replace faulty hoses.
- Check the air connections for leaks. A small amount of soapy water in a questionable area will bubble if there is a leak.
- Make sure lines are not clogged. Remove a questionable line and blow through it as a test.



# SECTION 7: SERVICE

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

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> <li>Emergency stop button depressed/at fault.</li> <li>Emergency stop panel depressed/at fault.</li> <li>Incorrect power supply voltage or circuit size.</li> <li>Power supply circuit breaker tripped or fuse blown.</li> <li>Motor wires connected incorrectly.</li> <li>Wiring open/has high resistance.</li> <li>Sanding belt position limit switch engaged/at fault.</li> <li>ON/OFF switch at fault.</li> <li>Start capacitor at fault.</li> <li>Thermal overload relay has tripped.</li> <li>Contactor not energized/has poor contacts.</li> <li>Motor at fault.</li> <li>Sanding depth too great.</li> </ol>	<ol style="list-style-type: none"> <li>Rotate button clockwise to reset. Replace if at fault.</li> <li>Disengage stop panel. Replace if at fault.</li> <li>Ensure correct power supply voltage and circuit size (<b>Page 12</b>).</li> <li>Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.</li> <li>Correct motor wiring connections (<b>Page 65</b>).</li> <li>Check/fix broken, disconnected, or corroded wires.</li> <li>Correct sanding belt oscillation (<b>Page 41</b>); replace faulty switch.</li> <li>Replace switch.</li> <li>Test/replace.</li> <li>Allow to cool, then reset; replace.</li> <li>Test all legs for power/replace if at fault.</li> <li>Test/repair/replace.</li> <li>Reduce sanding depth.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>Feed rate/cutting speed too fast for task.</li> <li>Workpiece material is not suitable for this machine.</li> <li>Belt(s) slipping; oil/grease on belt(s).</li> <li>Motor overheated.</li> <li>Motor wired incorrectly.</li> <li>Motor bearings at fault.</li> <li>Contactor not energized/has poor contacts.</li> <li>Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Decrease feed rate/cutting speed.</li> <li>Only sand wood; ensure moisture is below 20% and there are no foreign materials in the workpiece.</li> <li>Clean/tension/replace belt(s); align pulleys.</li> <li>Clean motor, let cool, reduce workload.</li> <li>Wire motor correctly (<b>Page 65</b>).</li> <li>Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>Test all legs for power/replace.</li> <li>Test/repair/replace.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>Motor or component is loose.</li> <li>V-belt(s) worn or loose.</li> <li>Motor fan rubbing on fan cover.</li> <li>Pulley is loose.</li> <li>Machine incorrectly mounted to floor.</li> <li>Motor mount loose/broken.</li> <li>Motor bearings at fault.</li> <li>Centrifugal switch is at fault.</li> <li>Conveyor belt gearbox at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Retighten/replace damaged bolts/nuts.</li> <li>Inspect/replace belts with a new matched set (<b>Page 52</b>).</li> <li>Fix/replace fan cover; replace loose/damaged fan.</li> <li>Re-align/replace shaft, pulley, set screw, &amp; key.</li> <li>Tighten mounting bolts; relocate/shim machine.</li> <li>Tighten/replace.</li> <li>Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>Replace.</li> <li>Rebuild gearbox for bad gear(s)/bearing(s).</li> </ol>



## Operation

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"> <li>1. Feed rate too high.</li> <li>2. Excessive depth of cut.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate (<b>Page 31</b>).</li> <li>2. Reduce depth of cut (<b>Page 30</b>).</li> </ol>
Loud, repetitious noise coming from machine.	<ol style="list-style-type: none"> <li>1. Pulley set screws or keys are missing or loose.</li> <li>2. Motor fan rubbing on fan cover.</li> <li>3. V-belt(s) is defective.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect pulley keys and set screws. Replace or tighten if necessary.</li> <li>2. Fix/replace fan cover; replace loose/damaged fan.</li> <li>3. Replace V-belt(s) (<b>Page 52</b>).</li> </ol>
Machine is loud, overheats or bogs down during operation.	<ol style="list-style-type: none"> <li>1. Excessive depth of cut.</li> <li>2. Sanding belt worn/clogged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease depth of cut (<b>Page 30</b>).</li> <li>2. Clean/replace sanding belt (<b>Pages 26 &amp; 37</b>).</li> </ol>
Rounded workpiece edges.	<ol style="list-style-type: none"> <li>1. Excessive depth of cut.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce depth of cut (<b>Page 30</b>).</li> </ol>
Uneven thickness from left to right of board.	<ol style="list-style-type: none"> <li>1. Feed table not parallel to upper frame.</li> <li>2. Conveyor belt worn.</li> <li>3. Sanding belt worn unevenly.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust feed table (<b>Page 48</b>).</li> <li>2. Replace conveyor belt (<b>Page 56</b>).</li> <li>3. Feed workpieces across sanding belt, not just on one side.</li> </ol>
Workpiece slips on conveyor belt.	<ol style="list-style-type: none"> <li>1. Pressure rollers set too high.</li> <li>2. Dirty conveyor belt.</li> <li>3. Conveyor belt worn.</li> </ol>	<ol style="list-style-type: none"> <li>1. Lower pressure rollers (<b>Page 49</b>).</li> <li>2. Clean conveyor belt.</li> <li>3. Replace conveyor belt (<b>Page 56</b>).</li> </ol>
Grooves down length of workpiece.	<ol style="list-style-type: none"> <li>1. Pressure rollers dirty/damaged.</li> <li>2. Platen set too low.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean/repair/replace pressure rollers.</li> <li>2. Raise platen to reduce pressure (<b>Page 27</b>).</li> </ol>
Snake-shaped marks on workpiece.	<ol style="list-style-type: none"> <li>1. Sanding belt dirty/damaged.</li> <li>2. Pressure rollers dirty/damaged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean/replace sanding belt (<b>Pages 37 &amp; 25</b>).</li> <li>2. Clean/repair pressure rollers.</li> </ol>
Lines across width of workpiece.	<ol style="list-style-type: none"> <li>1. Sanding belt seam open/damaged.</li> <li>2. Platen set too low.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace sanding belt (<b>Page 25</b>).</li> <li>2. Raise platen to reduce pressure (<b>Page 27</b>).</li> </ol>
Glossy spots or streaks on workpiece.	<ol style="list-style-type: none"> <li>1. Worn sanding belt.</li> <li>2. Rear pressure roller too low.</li> <li>3. Graphite pad or felt pad worn/damaged.</li> <li>4. Platen set too low.</li> <li>5. Using amp load meter to establish material removal amount.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace sanding belt (<b>Page 25</b>).</li> <li>2. Raise rear pressure roller (<b>Page 49</b> and heed note in <b>Pressure Roller</b> section <b>Page 49</b>).</li> <li>3. Replace graphite pad or felt pad (<b>Page 42</b>).</li> <li>4. Raise platen to reduce pressure (<b>Page 27</b>).</li> <li>5. Use other methods to establish material removal amount.</li> </ol>
Sanding belt clogs quickly.	<ol style="list-style-type: none"> <li>1. Sanding belt grit too small for particular job.</li> <li>2. Excessive depth of cut.</li> <li>3. Wood is too moist.</li> <li>4. Using amp load meter to establish material removal amount.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace with coarser grit sanding belt (<b>Page 25</b>).</li> <li>2. Reduce depth of cut (<b>Page 30</b>).</li> <li>3. Allow wood to dry to below 20% moisture content.</li> <li>4. Use other methods to establish material removal amount.</li> </ol>
Sanding belt does not tension correctly; rollers slip under belt.	<ol style="list-style-type: none"> <li>1. Low air pressure.</li> <li>2. Air leaks in system.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust air pressure to 75 PSI at primary regulator (<b>Page 20</b>).</li> <li>2. Inspect all hoses and connections for leaking air; use a water/soap mixture on suspected area to detect bubbles.</li> </ol>
Sanding belt runs off to one side, stopping the sander.	<ol style="list-style-type: none"> <li>1. Airflow adjustment knob closed.</li> <li>2. Belt tracking incorrect.</li> <li>3. Electronic eye or mirror dirty; pulse jets incorrectly positioned.</li> </ol>	<ol style="list-style-type: none"> <li>1. Turn valve all the way out, then back in 3½" turns.</li> <li>2. Adjust belt tracking (<b>Page 54</b>).</li> <li>3. Clean electronic eye, mirror; adjust pulse jet positions (<b>Page 53</b>).</li> </ol>
Poor, non-aggressive sanding results.	<ol style="list-style-type: none"> <li>1. Sanding belt worn/clogged.</li> <li>2. Sanding belt grit too fine for particular job.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean/replace sanding belt (<b>Pages 25 &amp; 37</b>).</li> <li>2. Replace with coarser grit.</li> </ol>





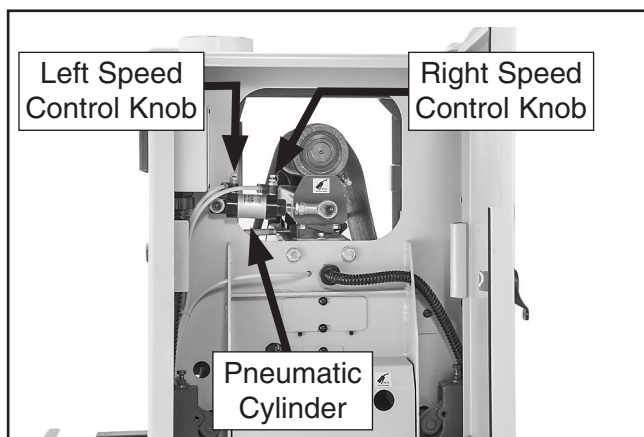
## Operation Continued

Symptom	Possible Cause	Possible Solution
Sanding belt will not start, but conveyor will.	<ol style="list-style-type: none"> <li>1. No air pressure to sander.</li> <li>2. Airflow adjustment valve closed.</li> <li>3. Limit switches engaged.</li> <li>4. Emergency stop plate engaged.</li> <li>5. Sanding belt not tensioned.</li> </ol>	<ol style="list-style-type: none"> <li>1. Connect sander to compressed air system (<b>Page 20</b>).</li> <li>2. Open airflow adjustment valve.</li> <li>3. Center sanding belt so it is not touching limit switches (<b>Page 55</b>).</li> <li>4. Make sure emergency stop plate is released (<b>Page 29</b>).</li> <li>5. Tension sanding belt (<b>Page 26</b>).</li> </ol>
Conveyor belt not tracking in center.	<ol style="list-style-type: none"> <li>1. Conveyor belt moved out of adjustment.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust conveyor adjustment bolts (<b>Page 53</b>).</li> </ol>
Conveyor belt slipping.	<ol style="list-style-type: none"> <li>1. Conveyor rollers have incorrect tension.</li> <li>2. Conveyor rollers contaminated with dirt or dust.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust conveyor rollers to place more tension on conveyor belt (see <b>Page 53</b>).</li> <li>2. Clean conveyor rollers.</li> </ol>
Emergency brake stops slowly.	<ol style="list-style-type: none"> <li>1. Low air pressure.</li> <li>2. Air leaks in system.</li> <li>3. Brake rotor contaminated with oil.</li> <li>4. Brake pads worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust incoming air pressure to 75 PSI (<b>Page 20</b>).</li> <li>2. Inspect all hoses and connections for leaking air; use water on suspected area to detect bubbles.</li> <li>3. Clean brake rotor with automotive brake parts cleaner.</li> <li>4. Replace brake pads (<b>Page 43</b>).</li> </ol>
Grinding noise when braking.	<ol style="list-style-type: none"> <li>1. Brake pads worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace brake pads (<b>Page 43</b>), have rotor turned/trued by a machine shop. Replace rotor.</li> </ol>
Air leaking from sander.	<ol style="list-style-type: none"> <li>1. There is no problem. It is normal to hear an air leaking sound coming from the machine.</li> <li>2. Water filter/trap drain cock left open.</li> <li>3. Air line ruptured or air leaking at a connection point.</li> </ol>	<ol style="list-style-type: none"> <li>1. Unless there is clear evidence of an air leak or a performance problem with belt oscillation or braking time, take no action.</li> <li>2. Ensure water filter/trap drain cock is tight.</li> <li>3. Find source of sound and determine likely cause based on what you see.</li> </ol>



# Adjusting Oscillation Speed/Timing

The sanding belt oscillation speed/timing is adjustable and controlled by control knobs on a pneumatic cylinder (see **Figure 52**). The control knob on the right affects the sanding belt travel as it moves toward you (when facing the pneumatic cylinder), and the control knob on the left affects belt travel as it moves away from you. The goal is to adjust these knobs so it takes the same amount of time (approximately 2–3 seconds) for the sanding belt to travel in each direction as it oscillates.



**Figure 52.** Location of oscillation speed pneumatic cylinder (upper right access door opened).

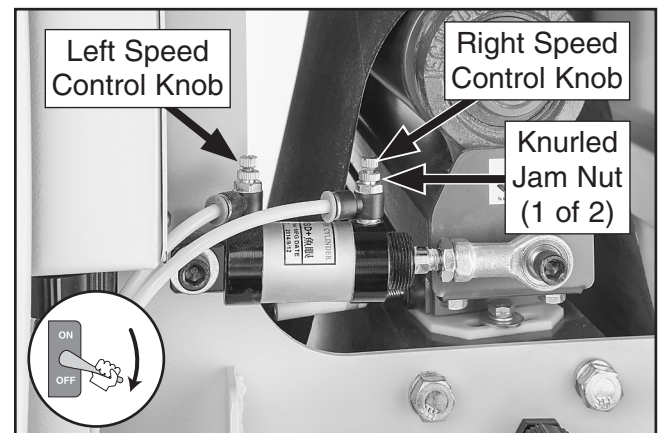
## Adjusting Oscillation Speed/Timing

Different oscillation speeds yield different sanding results. We recommend trying various speeds on a scrap piece of wood similar to the workpiece being used. The oscillation speed is measured by how long it takes the belt to move from one side to the other.

Tools Needed	Qty
Flat Head Screwdriver #2.....	1
Door Latch Key 8mm.....	1

### To adjust oscillation timing/speed:

1. DISCONNECT MACHINE FROM POWER!
2. Open upper right access door.
3. Loosen knurled jam nut (see **Figure 53**) that corresponds to the oscillation direction you intend to adjust.
  - The *right* jam nut and speed control knob control oscillation speed as belt moves *toward* you (when facing the pneumatic cylinder).
  - The *left* jam nut and speed control knob control oscillation speed as belt moves *away from* you (when facing the pneumatic cylinder).
4. Rotate speed control knob (see **Figure 53**) clockwise to decrease oscillation speed, or counterclockwise to increase oscillation speed, then tighten jam nut to secure.



**Figure 53.** Location of oscillation speed controls.

5. Repeat **Steps 3–4** for other speed control knob, making sure to adjust both knobs equally.
6. Connect machine to power and test oscillation speed, then repeat **Steps 1–5** as needed until you are satisfied.



# Servicing Platen

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

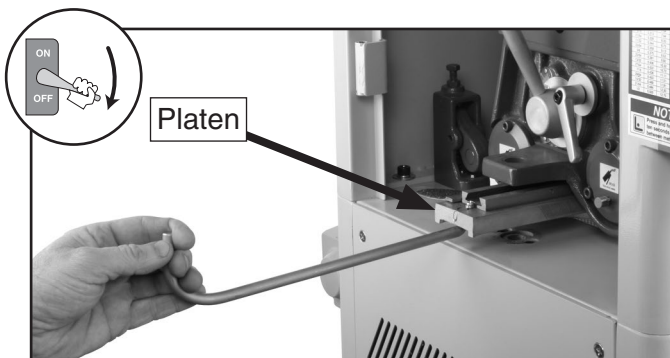
Due to its function, it is very important for the graphite pad to be flat and smooth and free of grooves or low spots. It is also important that no dust or chips get trapped between the graphite pad and felt pad of the platen.

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

Items Needed	Qty
Platen Tool.....	1
Door Latch Key.....	1
Graphite Pad .....	1
Felt Pad .....	1
Putty Knife .....	1
Contact Cement or Spray Adhesive..	As Needed
Solvent Cleaner .....	As Needed
Drill .....	1
Drill Bit 1/8" .....	1

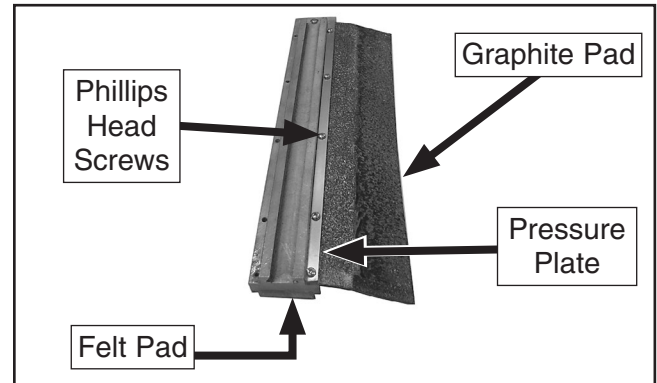
## Replacing Graphite Pad

1. Open left access door and remove sanding belt.
2. DISCONNECT MACHINE FROM POWER!
3. Use platen tool, as shown in **Figure 54**, to remove platen from sander.



**Figure 54.** Example of removing platen.

4. Remove five Phillips head screws and pressure plate that secure graphite pad (see **Figure 55**).



**Figure 55.** Platen components.

5. Install new graphite pad onto same side of platen as old graphite pad, and secure pad with pressure plate and screws removed previously.

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

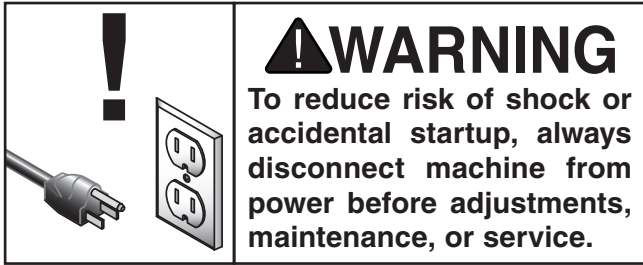
6. Re-insert platen in same manner it was removed until it stops in place, making sure graphite pad points towards front of machine.
7. Re-install sanding belt, then close left access door.

## Replacing Felt Pad

1. DISCONNECT MACHINE FROM POWER!
2. Follow **Steps 1–2** in **Replacing Graphite Pad**.
3. Thoroughly soak felt pad in solvent to loosen glue securing pad to platen, then lift felt pad off and let platen it dry. Use a putty knife to scrape off any remaining felt and glue.
4. Use spray adhesive or contact cement to secure new felt pad to platen.
5. Follow **Steps 6–7** in **Replacing Graphite Pad**.

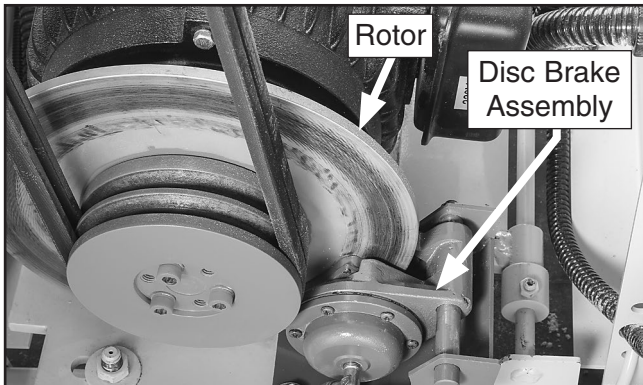


# Checking/Replacing Brake Pads

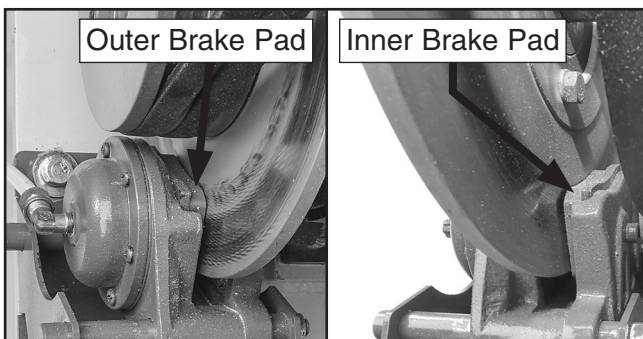


The disc brake assembly uses brake pads to stop the rotor (see **Figures 56–57**) when the Emergency Stop button or Emergency Stop plate is pressed. Eventually the brake pads will wear out.

Checking and replacing these is a simple procedure that can be done in the shop, with the exception of having the rotor resurfaced on a lathe. Contact Grizzly Customer Service at (570) 546-9963 to order replacement brake pads (Part #P08190212).



**Figure 56.** Location of disc brake assembly (lower right access panel removed for access).

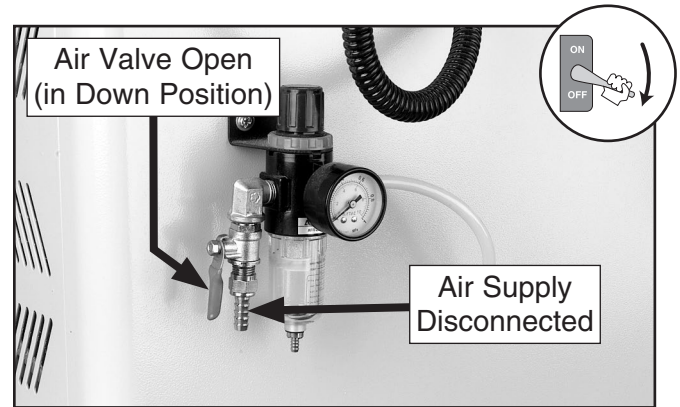


**Figure 57.** Locations of brake pads on disc brake assembly.

Tools Needed:	Qty
Phillips Screwdriver #2 .....	1
Fine Ruler.....	1
Open-End Wrench 14mm.....	1
Hex Wrench 4, 5mm.....	1 Ea.

## To check/replace brake pads:

1. DISCONNECT MACHINE FROM POWER!
2. Disconnect machine from air, then release all air pressure in machine by opening air valve on regulator (see **Figure 58**). This will cause disc brake assembly to open, allowing removal of the assembly.



**Figure 58.** Air supply disconnected, and air valve opened for brake service.

3. Remove lower right access panel.



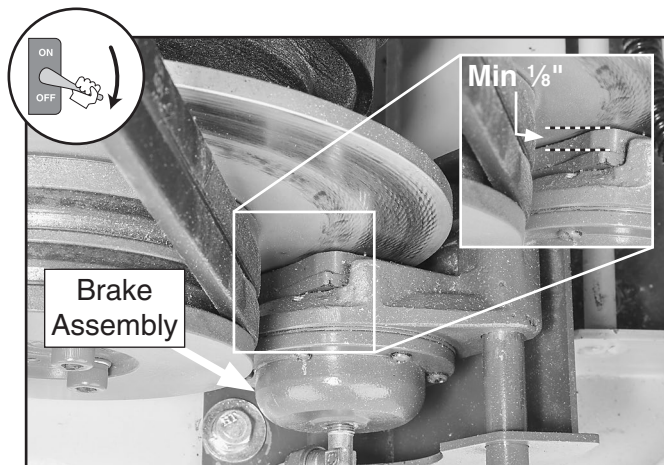


- Using a fine ruler, measure thickness of each brake pad. The brake pads consist of a metal plate with a composite pad. Measure thickness of composite pads only (see **Figure 59**).

**Note:** If you have difficulty measuring the brake pads while the disc brake assembly is mounted to the machine, proceed to **Step 5**, and then measure the brake pads after removing the disc brake assembly.

— If both of the pads are greater than  $\frac{1}{8}$ " (see **Figure 59**), the pads do not need to be replaced. Proceed to **Step 12**.

— If one of the pads is less than  $\frac{1}{8}$ " (see **Figure 59**), replace both pads. Proceed to **Step 5**.



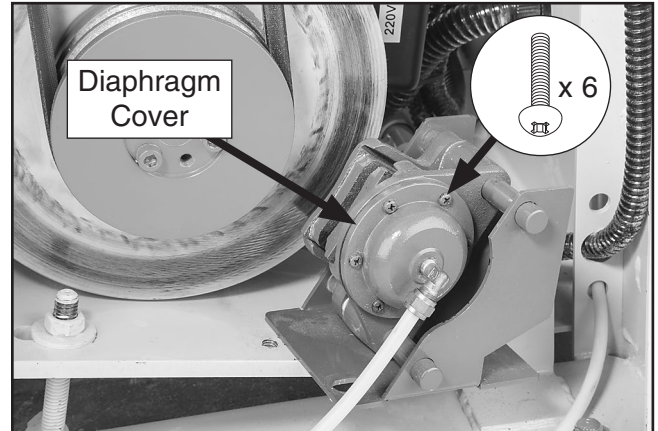
**Figure 59.** Brake pad detail.

- Remove two mounting bolts that secure disc brake assembly to machine (see **Figure 60**), then pull disc brake assembly away from rotor. If you have not done so already, follow **Step 4** to measure brake pads.

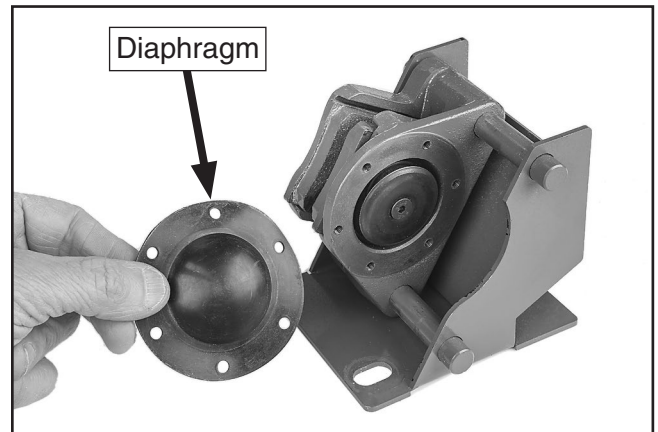


**Figure 60.** Location of disc brake assembly mounting bolts (1 of 2 shown).

- Remove (6) M5-.8 x 15 Phillips head screws, diaphragm cover, and diaphragm (see **Figures 61–62**).

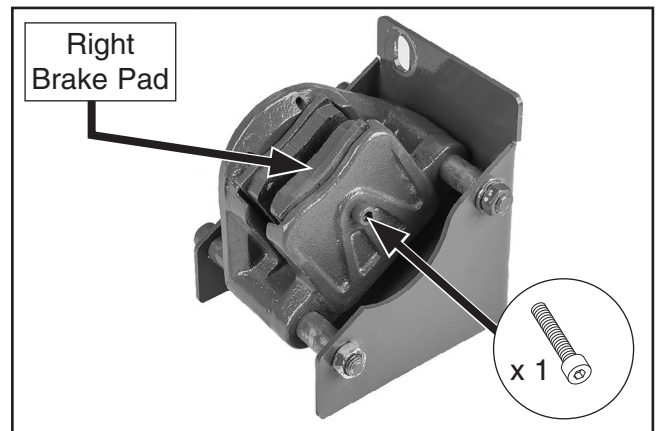


**Figure 61.** Location of diaphragm cover.



**Figure 62.** Diaphragm removed from disc brake assembly.

- Remove (1) M6-1 x 12 cap screw, then remove right brake pad (see **Figure 63**).



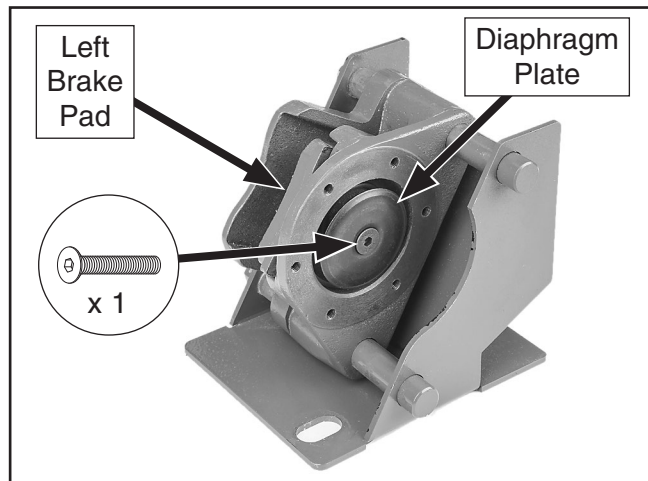
**Figure 63.** Location of right brake pad and mounting cap screw.



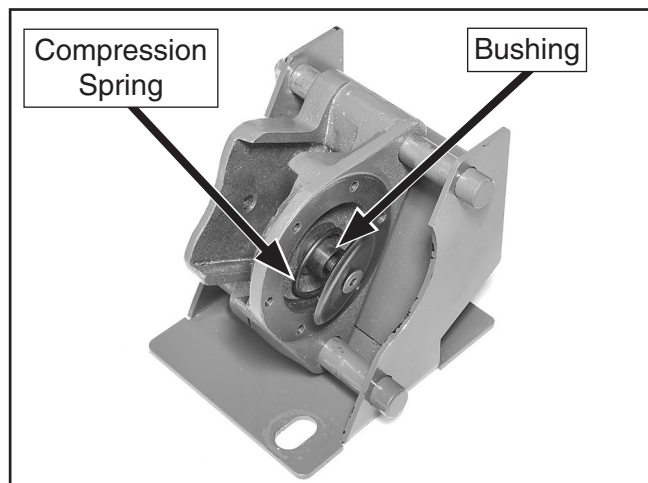


- Remove (1) M6-1 x 25 flat head cap screw, diaphragm plate, compression spring, bushing, and left brake pad (see **Figures 64–65**).

**Note:** Be careful when removing these components. They are under pressure from the compression spring (see **Figure 65**), and could fly apart unexpectedly.



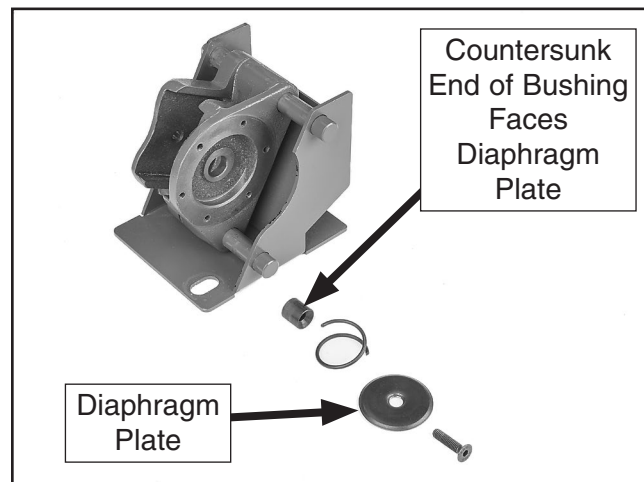
**Figure 64.** Location of diaphragm plate and mounting screw, and left brake pad.



**Figure 65.** Location of disc brake assembly compression spring and bushing.

- Install new left brake pad in reverse order from **Step 8**. Make sure to re-install components in same order and orientation as they came from factory (see **Figure 66**).

**Note:** The countersunk end of the bushing faces the diaphragm plate (see **Figure 66**).



**Figure 66.** Order of assembly for left brake pad components.

- Install new right brake shoe in reverse order from **Step 7**.
- Re-assemble and install disc brake assembly in reverse order from **Steps 5–6**.
- Re-install lower right access panel.
- Reconnect air line.
- Start sander and test Emergency Stop system to make sure brake works.

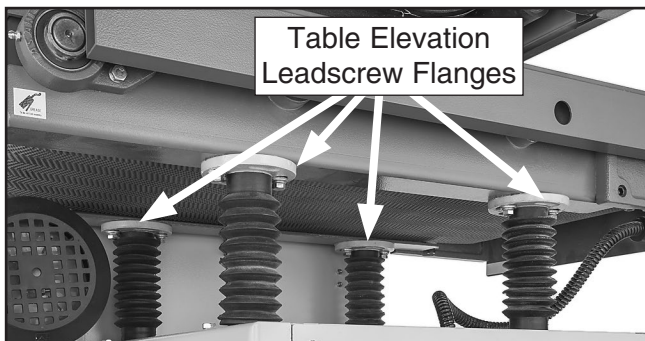


# Checking/Adjusting Table Parallelism

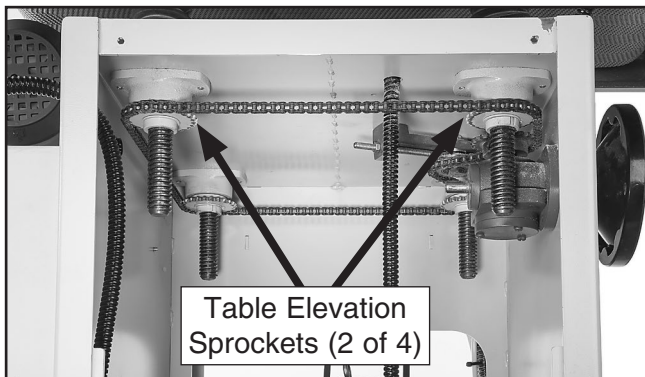
Table parallelism has been adjusted at the factory and should not require adjustment when the machine is new.

We only recommend adjusting table parallelism if absolutely necessary due to factors that may cause the factory setting to change. Adjusting the table parallelism can take a fair amount of patience. **DO NOT adjust the table unless you are having trouble sanding your workpiece to a uniform thickness and have eliminated all other possible causes.**

The four corners of the table can be independently adjusted up or down to achieve parallelism with the frame by adjusting the elevation leadscrew flanges (see **Figure 67**) or repositioning the table elevation sprockets (see **Figure 68**).



**Figure 67.** Table elevation leadscrew flanges located on underside of table.



**Figure 68.** Location of table elevation sprockets (2 of 4 shown).

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

<b>Tools Needed:</b>	<b>Qty</b>
Vacuum Cleaner.....	1
Shop Rags.....	As Needed
Wood Block Approx. 4" Long .....	1
Fine Ruler.....	1
Phillips Screwdriver #2 .....	1
Open-End Wrench 12mm.....	1
White Marker or Correction Fluid .....	As Needed

## Checking Table Parallelism

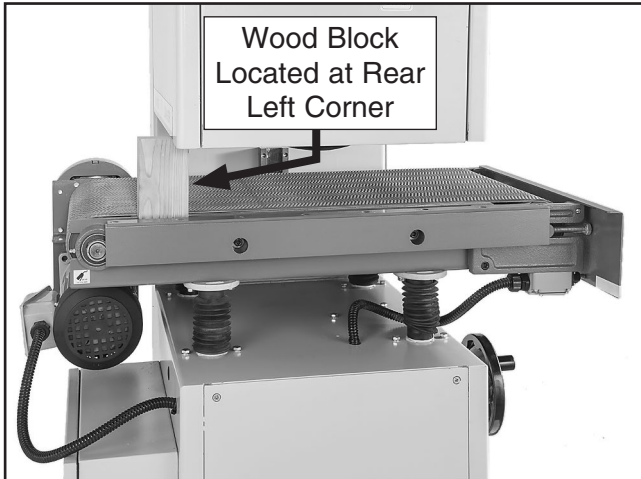
1. Use a vacuum cleaner and shop rag to clean table and frame at each corner so sawdust will not interfere with measurements during following steps.
2. Adjust table elevation until it is approximately 6" below sanding belt.
3. Take precise measurement of wood block (approx. 4" long) and record measurement.

*Continued on next page* →



- Place wood block on edge of table, at rear left corner, then raise table until wood block just touches upper frame (see **Figures 69–70**). Do not allow table to squeeze or compress wood block.

**Note:** Make sure wood block does not touch conveyor belt (see **Figure 70**).



**Figure 69.** Wood block placed at rear left corner of conveyor table to check table parallelism.



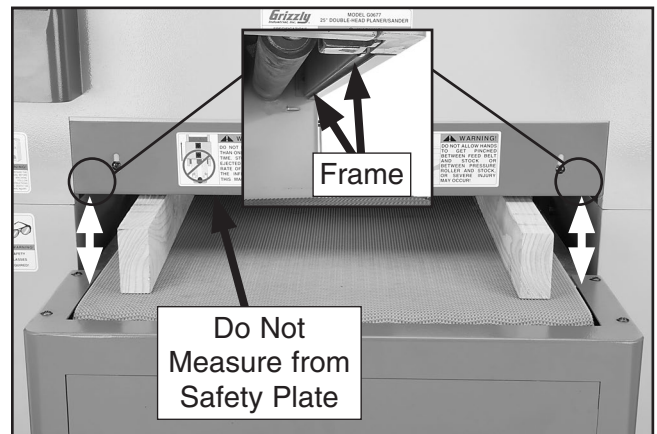
**Figure 70.** Position of wood block on conveyor table.

- Take precise measurements at each of the three remaining corners, between the conveyor table and the upper frame (see **Figures 71–72**).

**Note:** When measuring at front right and left corners, measure from the upper frame; **DO NOT** measure from the safety plate (see **Figure 72**).



**Figure 71.** Rear right measurement location for checking table parallelism.



**Figure 72.** Front measurement locations for checking table parallelism.



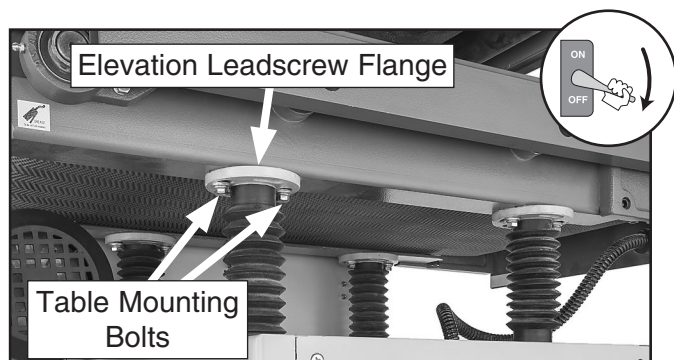
- If the measurements from *all* corners in **Step 5** are exactly the same as the length of the wood block, measured in **Step 3**, the table is parallel to the frame and no adjustment is necessary. Remove wood block.
- If the measurement of *any* corner from **Step 5** is *not* exactly the same as the length of the wood block, measured in **Step 3**, the table is not parallel to the frame. DO NOT remove wood block. Proceed to **Adjusting Table Parallelism**.

## Adjusting Table Parallelism

1. DISCONNECT MACHINE FROM POWER!
2. With wood block still positioned at rear left corner of conveyor table, locate elevation leadscrew flange at corner that needs to be adjusted.
3. Loosen table mounting bolts on flange (see **Figure 73**). Rotate flange a small amount to right to raise or to left to lower that corner of table until it is within 0.003" of measurement of wood block from **Step 3** of **Checking/Adjusting Table Parallelism** on **Page 46**.

**Note:** Each leadscrew flange can be adjusted up to 0.015" between the right and left sides.

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



**Figure 73.** Location of table mounting bolts.

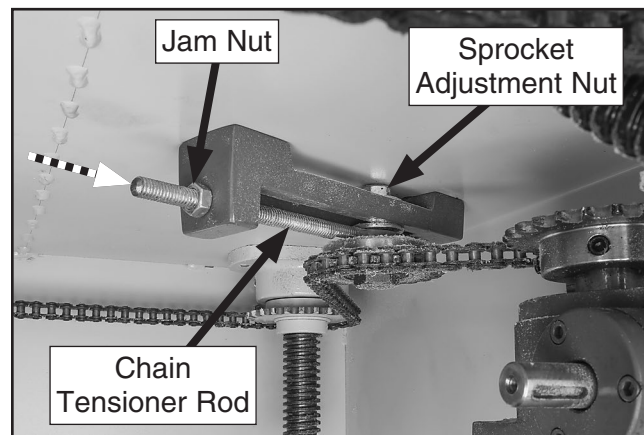
4. Retighten table mounting bolts to secure adjustment.

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

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

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

6. Remove lower left access panel.
7. Mark one tooth of sprocket that you are adjusting, and its location on frame.
8. Loosen chain tensioner sprocket adjustment nut on sprocket wheel shaft and loosen jam nut on chain tensioner rod (see **Figure 74**).



**Figure 74.** Table elevation chain tensioner components.

9. Push sprocket adjustment rod toward frame (or away from you) to loosen chain tension.
10. Remove chain from sprocket you want to adjust so only that sprocket can be moved independent of chain.
11. Carefully rotate sprocket just enough to position next tooth at marked location from **Step 7**, then fit chain around sprocket again. Rotate sprocket counterclockwise to raise table; rotate sprocket clockwise to lower table.





12. Pull chain tensioner rod toward you, tighten jam nut until chain is moderately tight, then tighten sprocket nut to secure (see **Figure 74** on **Page 48**).
13. Check table parallelism (refer to **Checking Table Parallelism** on **Page 46**) and, if necessary, repeat **Steps 2–12** until all corners of table are the same distance from upper frame.
14. Remove wood block and re-install lower left access panel.

## Checking/Adjusting Pressure Rollers

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

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

### Factory Settings

Infeed & Outfeed Pressure Roller Setting Below Sanding Drum ..... 0.035"

Tools Needed	Qty
6' Long 2x4 Cut in Half .....	1
Open-End Wrench 12mm.....	2

### To adjust pressure rollers:

1. DISCONNECT MACHINE FROM POWER!
2. Plane a 6' long 2x4 to a uniform thickness and cut it in half. Place one board along the length of the conveyor belt on the right-hand side, and place the other board on the left-hand side, as shown in **Figure 75**.



**Figure 75.** Example of 2x4s placed on conveyor belt under sanding drum.

3. Open upper right access door and remove V-belts (refer to **Page 52** for more information).
4. Move sanding drum by hand, and manually raise table until you hear sandpaper just contact surface of wood. DO NOT continue to raise table beyond this point.





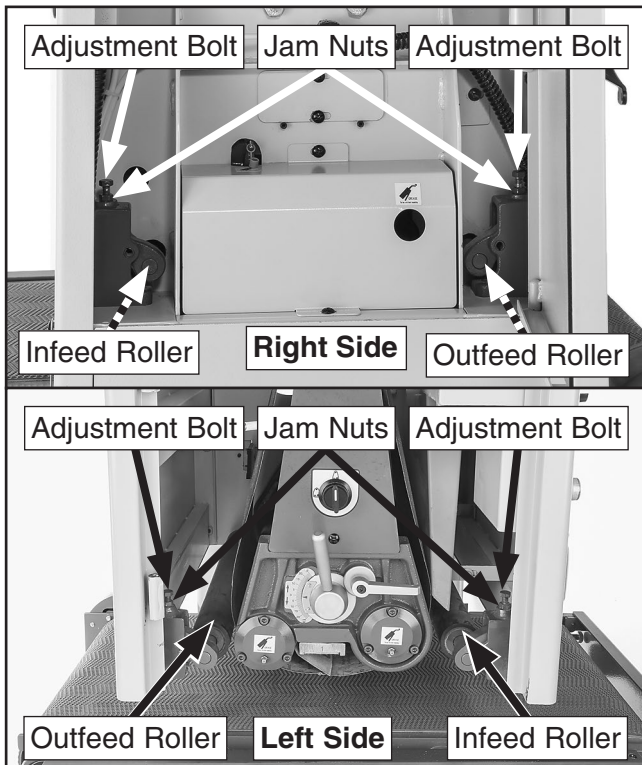
5. Make note of the reading on workpiece thickness scale, then lower table 0.035". This is how much lower infeed and outfeed pressure rollers should be compared to sanding surface of sanding drum.
6. Open upper right and left access doors.
7. Loosen infeed pressure roller jam nuts on infeed pressure roller, rotate adjustment bolts (see **Figure 76**) to lower infeed pressure roller until it just touches boards, then retighten jam nuts to secure.

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

8. Repeat **Steps 6–7** for outfeed pressure roller (see **Figure 76**).

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

9. Re-install V-belts (refer to **Page 52**).
10. Lower table and remove 2x4s.
11. Close and secure upper right and left access doors.



**Figure 76.** Locations of pressure roller adjustment components.



# Checking/Adjusting V-Belt Tension

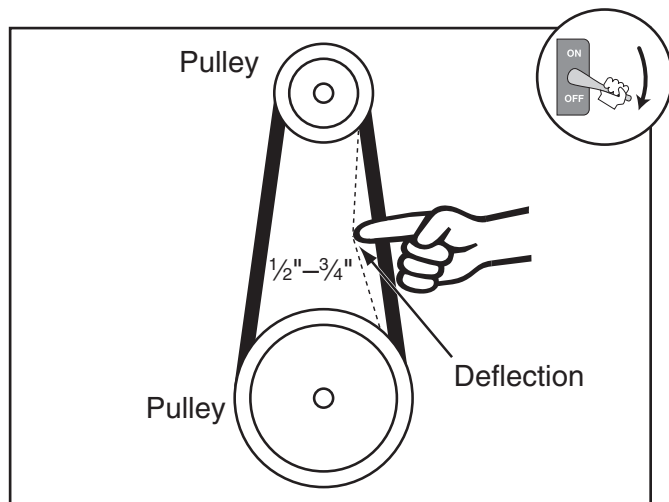
The V-belts must be tensioned properly for best performance, and to ensure the sanding drum stops when the emergency brake is applied. Always replace both V-belts as a matched set.

**Important:** Loose belts will not allow the sanding drum to stop immediately if the Emergency Stop plate or Stop/Reset button is pushed.

<b>Tool Needed</b>	<b>Qty</b>
Open-End Wrench 19mm.....	1

## To check/adjust V-belt tension:

1. DISCONNECT MACHINE FROM POWER!
2. Remove lower right access panel.
3. Check belt tension: Each belt is correctly tensioned when there is approximately  $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when it is pushed with moderate pressure, as shown in **Figure 77**.



**Figure 77.** Checking V-belt deflection.

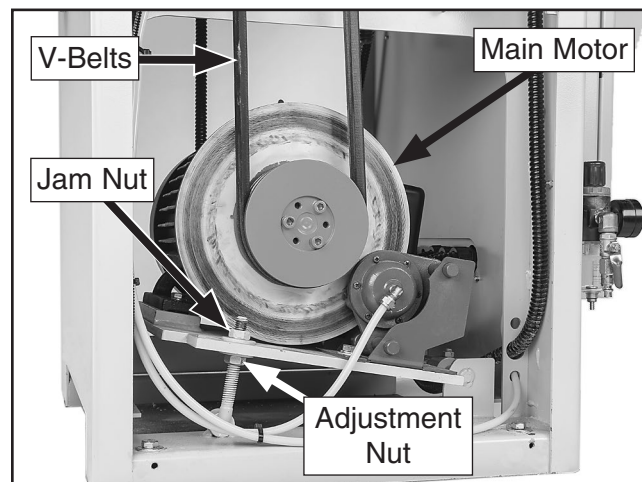
— If there *is* approximately  $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when V-belts are pushed with moderate pressure, V-belts are properly tensioned, and no adjustment is necessary.

— If there is *not* approximately  $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when V-belts are pushed with moderate pressure, V-belts are not properly tensioned. Proceed to **Step 4**.

4. Loosen V-belt tension jam nut to allow main motor to raise or lower (see **Figure 78**).
5. Rotate V-belt tension adjustment nut to raise or lower main motor (see **Figure 78**) until there is approximately  $\frac{1}{2}$ "– $\frac{3}{4}$ " deflection when V-belts are pushed with moderate pressure, then tighten jam nut to secure.

— Rotate adjustment nut *clockwise* to allow main motor to drop and apply tension to V-belts.

— Rotate adjustment nut *counterclockwise* to raise main motor and release V-belt tension.



**Figure 78.** V-belt tension adjustment components.

6. Re-install lower right access panel.



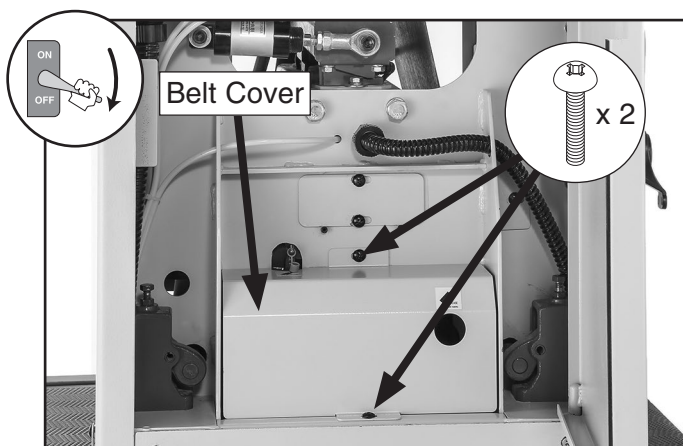
# Changing V-Belts

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

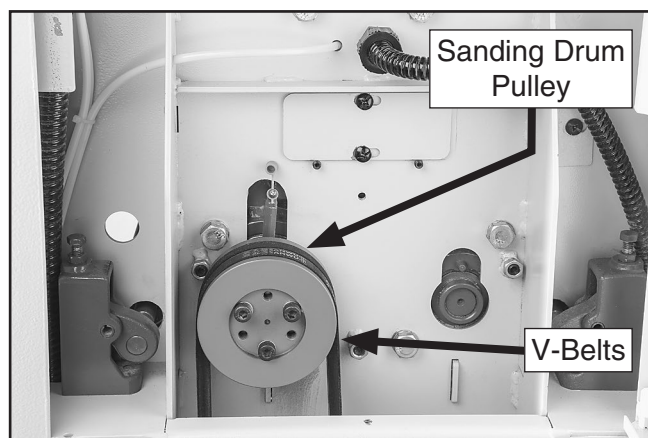
Tools Needed	Qty
Screwdriver Phillips #2 .....	1
Open-End Wrench 19mm.....	1

## To change V-belts:

1. DISCONNECT MACHINE FROM POWER!
2. Open upper right access door and remove lower right access panel.
3. Remove V-belt cover located inside upper right access door (see **Figures 79–80**).

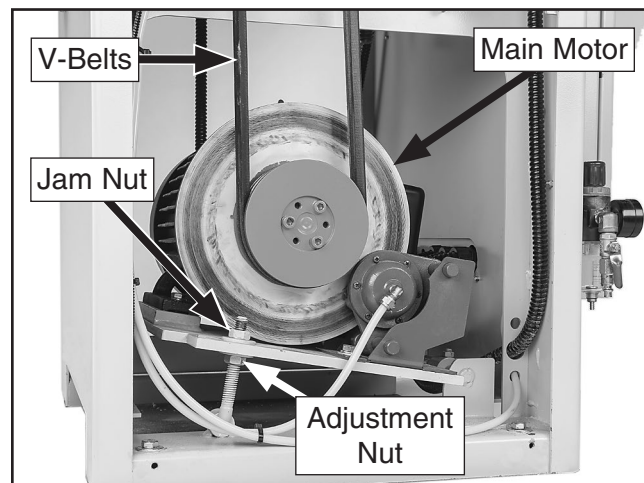


**Figure 79.** Location of V-belt cover.



**Figure 80.** V-belt cover removed to expose V-belts and sanding drum pulley.

4. Loosen V-belt tension jam nut several turns (see **Figure 81**) to allow main motor to raise as much as possible.
5. Rotate V-belt tension adjustment nut to raise or lower main motor (see **Figure 81**) until V-belts are loose enough to be removed from main motor pulley.



**Figure 81.** V-belt removal/installation components.

6. Remove V-belts from main motor pulley (see **Figure 81**), then remove V-belts from sanding drum pulley (see **Figure 80**).
7. Place a new matching pair of V-belts onto sanding drum pulley (see **Figure 80**), and then loop other end of V-belts around main motor pulley (see **Figure 81**).
8. Properly tension V-belts (refer to **Checking/Adjusting V-Belt Tension** on **Page 51** for more information).
9. Re-install V-belt cover from **Step 3**, close and secure upper right access door, and re-install lower right access panel.



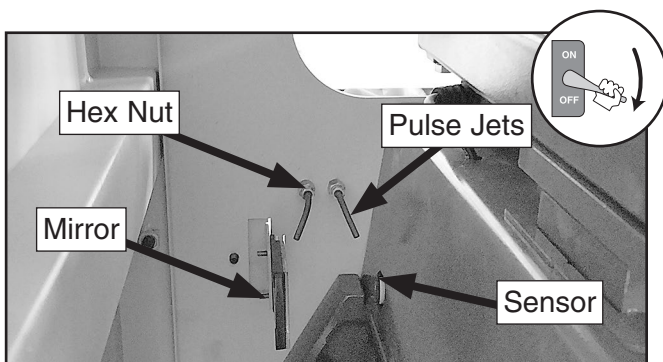
# Adjusting Pneumatic Pulse Jets

The pneumatic pulse-jet cleaning system is designed to keep the oscillation system electronic eye and mirror dust free. However, if the pulse jets are knocked out of position (most likely by the operator or by a loose sanding belt), they will stop automatically cleaning the sensor and mirror, causing the sensor to stop getting the signal to actuate. This causes the belt to track toward the sensor and into the limit switch without switching directions while oscillating.

Tools Needed	Qty
Open-End Wrench 10mm.....	1
Open-End Wrench 12mm.....	1
Soft Cloth.....	1

## To adjust pneumatic pulse jets:

1. DISCONNECT MACHINE FROM POWER!
2. Open right access door to access pneumatic pulse jets.
3. Loosen hex nuts on each of pulse jet shown in **Figure 82**.
4. Wipe off sensor and mirror, and adjust aim of right pulse jet so it points directly at electronic eye sensor and adjust left pulse jet so it points at center of mirror (see **Figure 82**).



**Figure 82.** Pulse jets aiming at sensor and mirror (belt removed for clarity).

5. Tighten hex nuts to secure pulse jets, then close right access door.

# Adjusting Conveyor Belt Tension

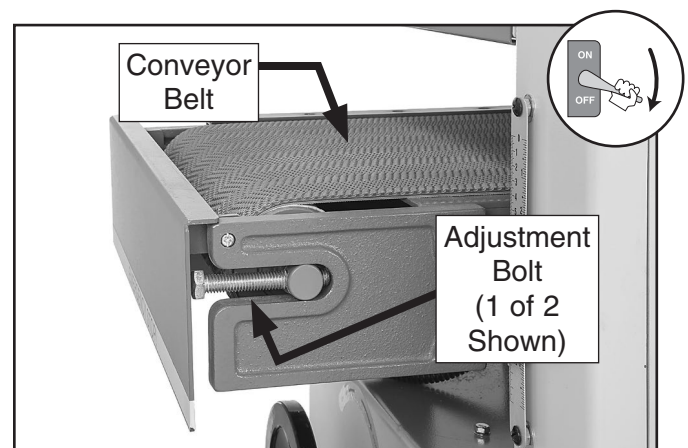
The conveyor belt tension has been adjusted at the factory and should require no further attention. However, adjust the conveyor belt tension if you notice that your conveyor belt is slipping or is tracking off center.

The conveyor belt tension is adjusted by rotating two adjustment bolts, located on each side of the conveyor table (see **Figure 83**).

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

## To adjust conveyor belt tension:

1. DISCONNECT MACHINE FROM POWER!
2. Rotate both left and right adjustment bolts (see **Figure 83**) equally to adjust conveyor belt tension. When tensioned properly, you should not be able to lift the conveyor belt off of table surface or slide it back and forth.
  - Rotate adjustment bolts *clockwise* to *increase* conveyor belt tension.
  - Rotate adjustment bolts *counterclockwise* to *decrease* conveyor belt tension.



**Figure 83.** Location of conveyor belt adjustment bolts (1 of 2 shown).





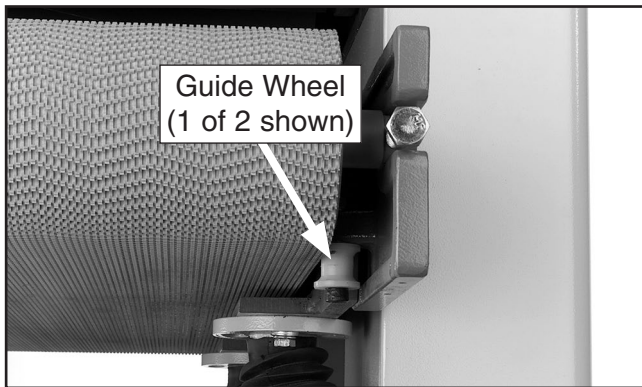
# Adjusting Conveyor Belt Tracking

## NOTICE

Adjust conveyor belt tension before adjusting conveyor belt tracking.

The conveyor belt is tracking properly when it stays centered on its rollers during operation and does not wander from side to side. The tracking is adjusted by rotating either the left or right conveyor belt tension adjustment bolt (see **Figure 83**), depending on the needs of the adjustment.

In addition, two guide wheels (see **Figure 84**) protect the conveyor belt from damage if the tracking is out of adjustment, by preventing it from rubbing against the inside surfaces of the conveyor table.



**Figure 84.** Conveyor belt guide wheels (Emergency Stop plate removed for clarity).

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

### To adjust conveyor belt tracking:

1. Turn conveyor belt **ON**.
  - If conveyor belt is tracking to the *right*, rotate the *right* adjustment bolt (see **Figure 83**) *clockwise*.
  - If conveyor belt is tracking to the *left*, rotate the *left* adjustment bolt (see **Figure 83**) *clockwise*.

2. Run conveyor belt for 3–5 minutes and recheck tracking.
3. Repeat **Steps 1–2**, as necessary, until conveyor belt is properly tracking.

**Note:** The edge of the conveyor belt should just touch the guide wheels as shown in **Figure 84** on This Page.

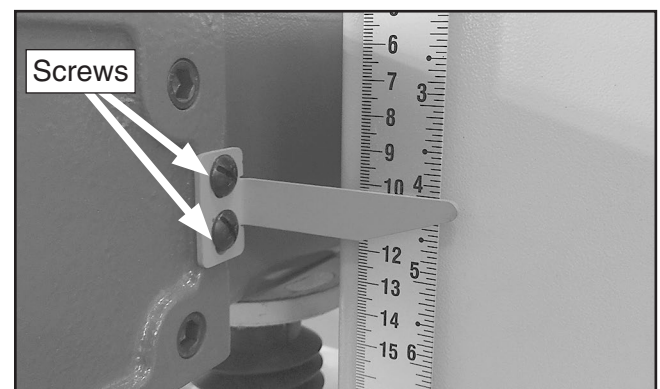
# Calibrating Scale Pointer

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

**Tools Needed:** Qty  
Phillips Head Screwdriver #2 ..... 1

### To calibrate scale pointer:

1. Sand workpiece and measure workpiece thickness.
2. Loosen screws that secure scale pointer (see **Figure 85**), adjust it to thickness of workpiece, then tighten it.



**Figure 85.** Scale pointer screws location.

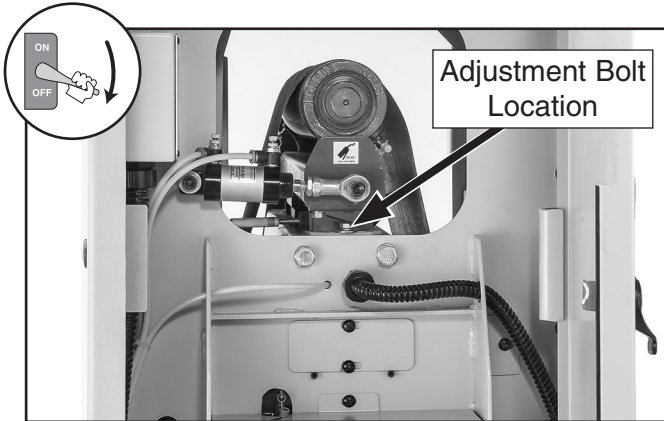




# Sanding Belt Limit Switches

Sanding belt tracking limit switches are placed on both sides of the belt to act as emergency machine stops if the belt travels too far to one side or the other during oscillation (see **Figure 86**).

Tools Needed:	Qty
Open-End Wrench 12mm.....	1



**Figure 86.** Tracking limit switch adjustment bolt (right side shown).

## To adjust belt tracking limit switches:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure sanding belt tracking and oscillation is adjusted properly (refer to **Page 41**).
3. Release belt tension, center sanding belt on top roller, then re-tension belt.
4. Measure distance from edge of sanding belt to ceramic rod protruding from switch.
5. Loosen adjustment bolt shown in **Figure 86**, and move switch so belt and ceramic rod are approximately  $\frac{1}{4}$ " apart.
6. Tighten bolt and repeat adjustment with other side if necessary.
7. Start machine and make sure it is working properly.



# Replacing Conveyor Belt

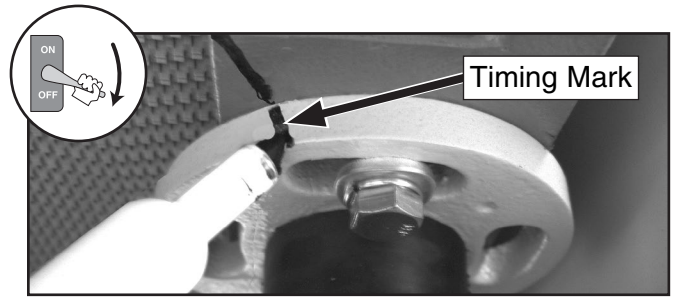
Replace the conveyor belt if it becomes damaged or you are not able to adjust the conveyor belt tracking due to excessive wear (refer to **Adjusting Conveyor Belt Tracking**, beginning on **Page 54**).

Tools Needed:	Qty
Phillips Screwdriver #2 .....	1
Combination Wrench 12mm .....	1
Combination Wrench 14mm .....	1
Combination Wrench 19mm .....	1
Hex Wrench 4, 6, 8, 12mm .....	1 Ea.
Ruler .....	1
8' 2x4s .....	2
Permanent Marker .....	1
Lifting Assistants .....	As Needed

**To remove conveyor belt, use Figure 88 on the following page and match number with steps below:**

1. Adjust table so conveyor belt is approximately four inches away from sanding roller, then **DISCONNECT MACHINE FROM POWER!**
2. Remove lower left access panel.
3. Remove (1)  $\frac{5}{16}$ "-18 x  $\frac{5}{8}$ " hex bolt that secures idler sprocket bracket, loosen the second hex bolt, then slide idler sprocket support forward and loosen chain.
4. Remove limit switch, remove all mounting screws, and remove emergency stop plate.
5. Turn both tracking adjustment bolts counter-clockwise five turns, remove left roller support, slide infeed drum out of table assembly, remove table extension, and remove workpiece thickness scale pointer.
6. Remove gearbox cover, loosen (2) M14-2 x 30 cap screws to remove chain, then tighten lower cap screw. Remove set screws that secure upper and lower sprockets, then remove sprockets. Remove conveyor motor and motor bracket.

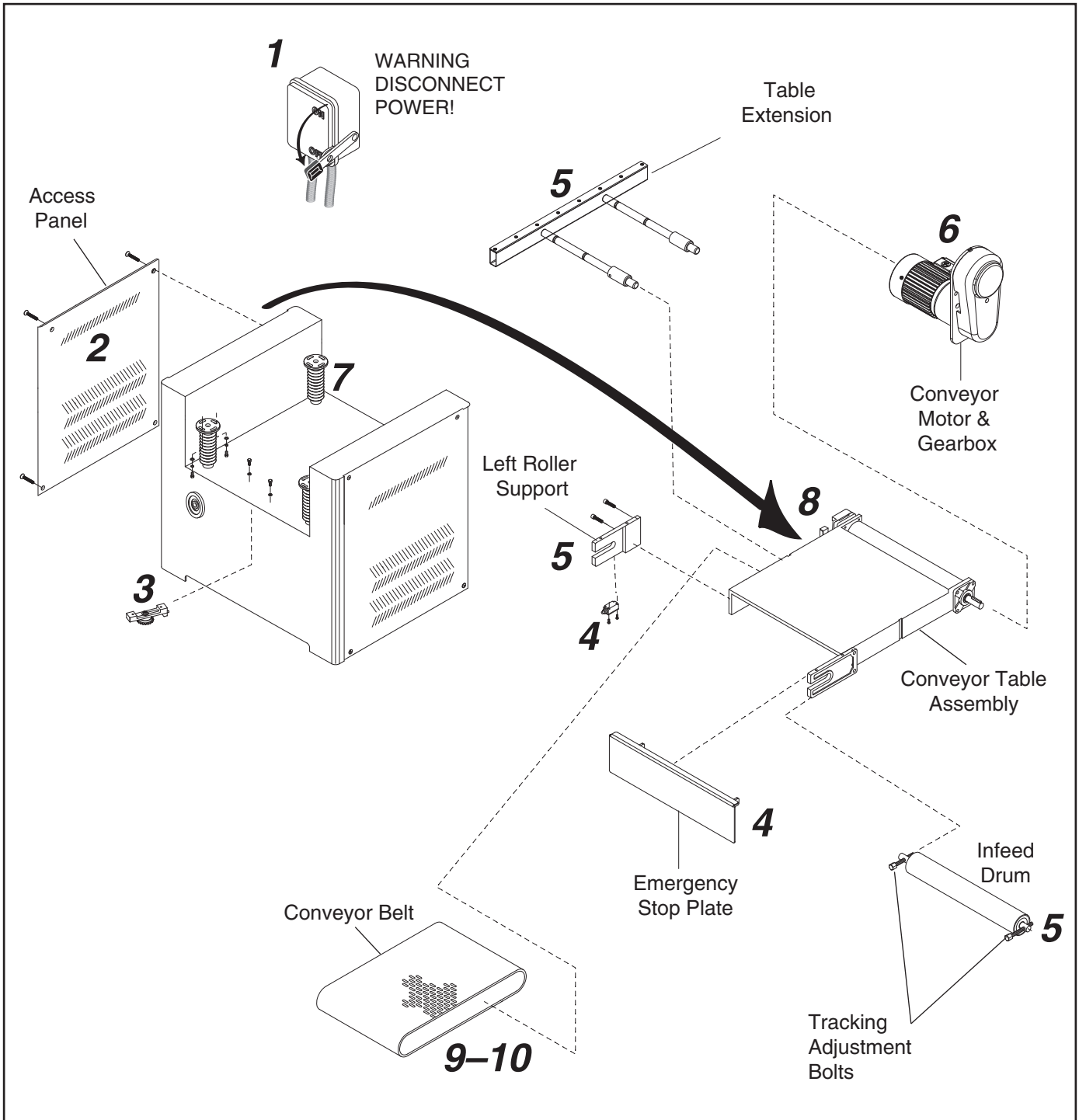
7. Using permanent marker, mark all four leadscrew flange positions (see **Figure 87**), and remove all bolts from the flanges. Try not to turn the flanges during the following steps.



**Figure 87.** Example of marking leadscrew for re-assembly.

8. Remove conveyor table from left side of machine, then place two 2x4 x 8' wooden studs on ground and under table to support table.
9. Remove old conveyor belt, inspect rollers, bearings, and table for wear and replace as required.
10. Install new conveyor belt. **Note:** *The belt is non-directional.*
11. With a helper, install table from left side of machine in similar fashion as it was removed.
12. Align leadscrew flanges with marks made in **Step 7**, and install hex bolts.
13. Re-install conveyor motor bracket, conveyor motor (with help of assistant), and upper and lower sprockets and chain. Ensure gears are aligned, then re-install gearbox cover.
14. Re-install front roller and roller support, and turn both tracking adjustment bolts clockwise equally so conveyor belt becomes taught and does not hang loose. **DO NOT OVERTIGHTEN** belt.
15. Re-install emergency stop plate and limit switch, workpiece thickness pointer, table extension, and idler sprocket support.
16. Re-install lower left access panel.
17. Start conveyor motor and turn conveyor tracking bolts as required until conveyor belt tracks straight without loading up on one side of table.

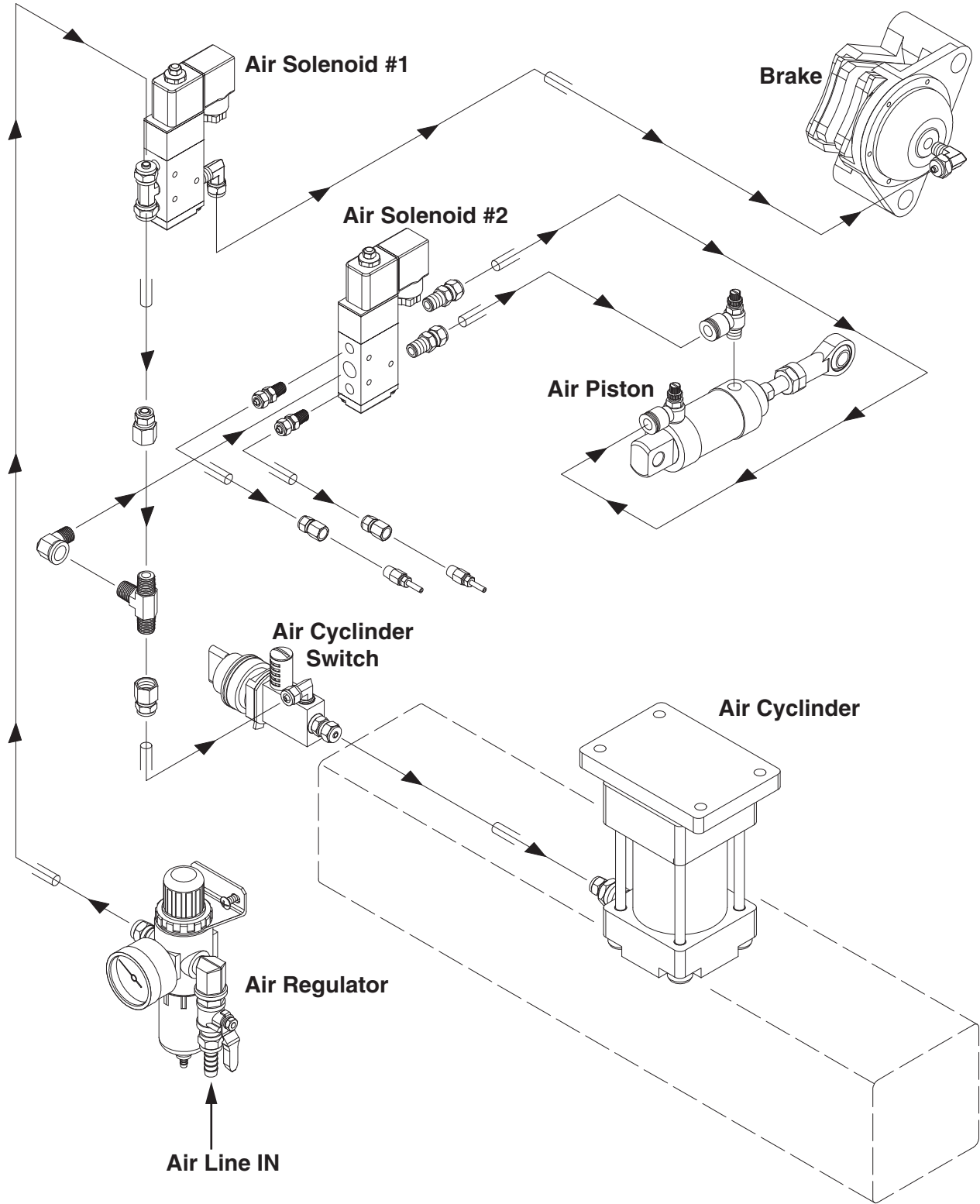




**Figure 88.** Conveyor belt removal sequence.



# Air System Diagram



# 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 after-market parts.

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

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

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

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


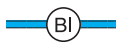
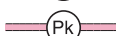







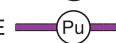

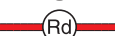
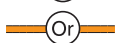
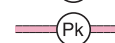
**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

#### NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

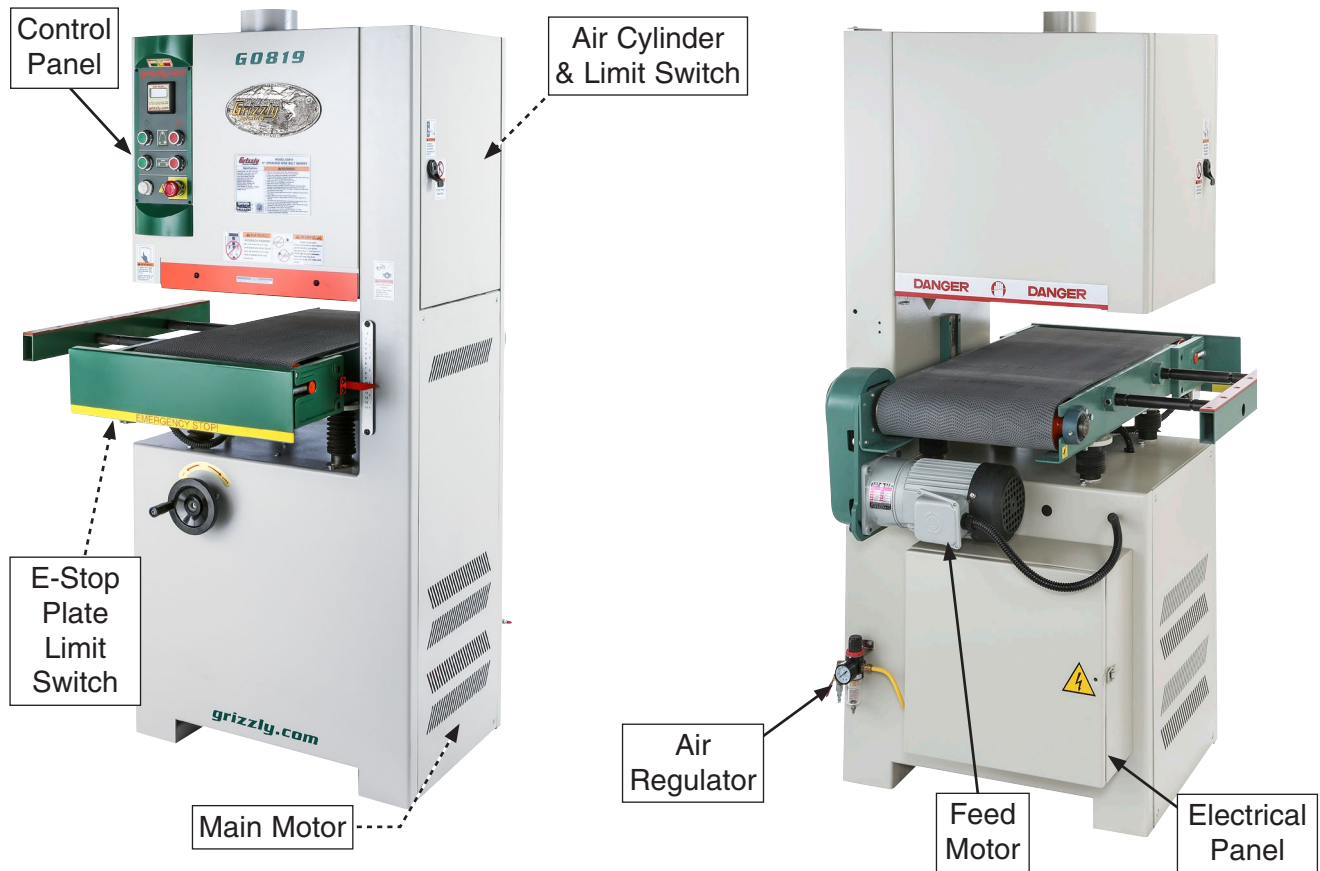
#### COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	

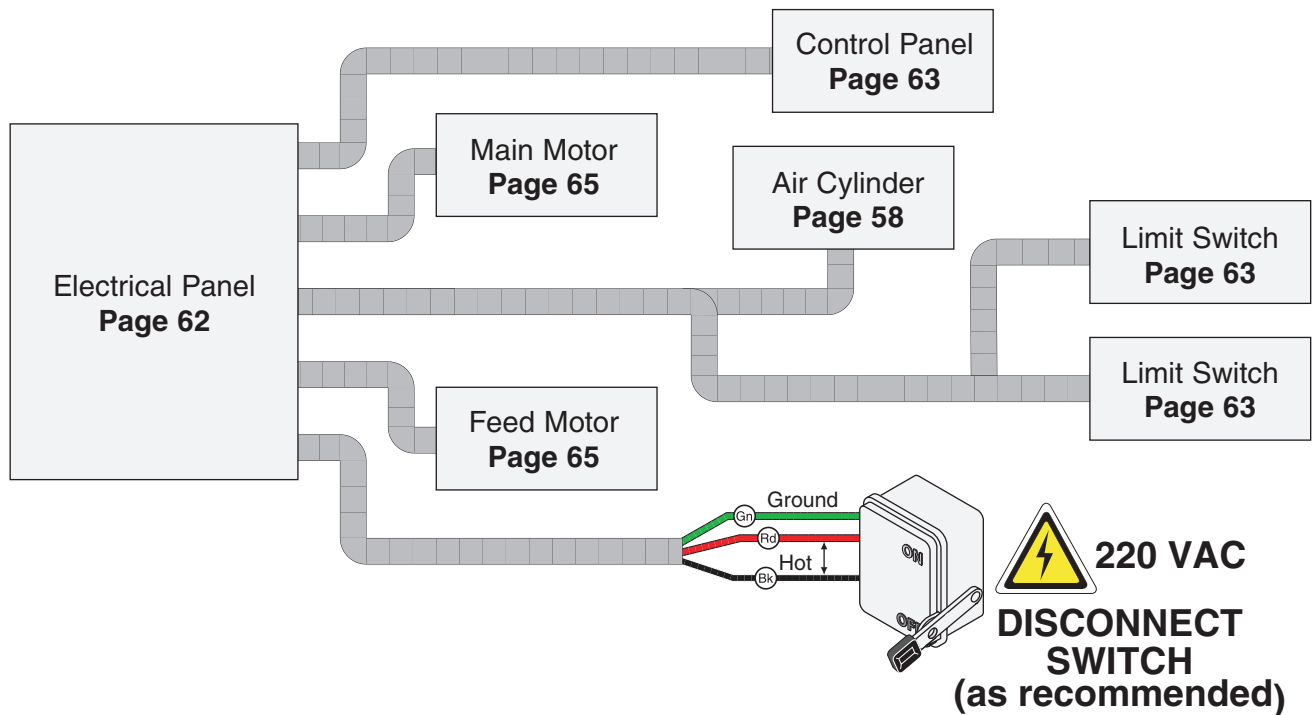




# Component Locations



# Electrical Overview



# Electrical Cabinet

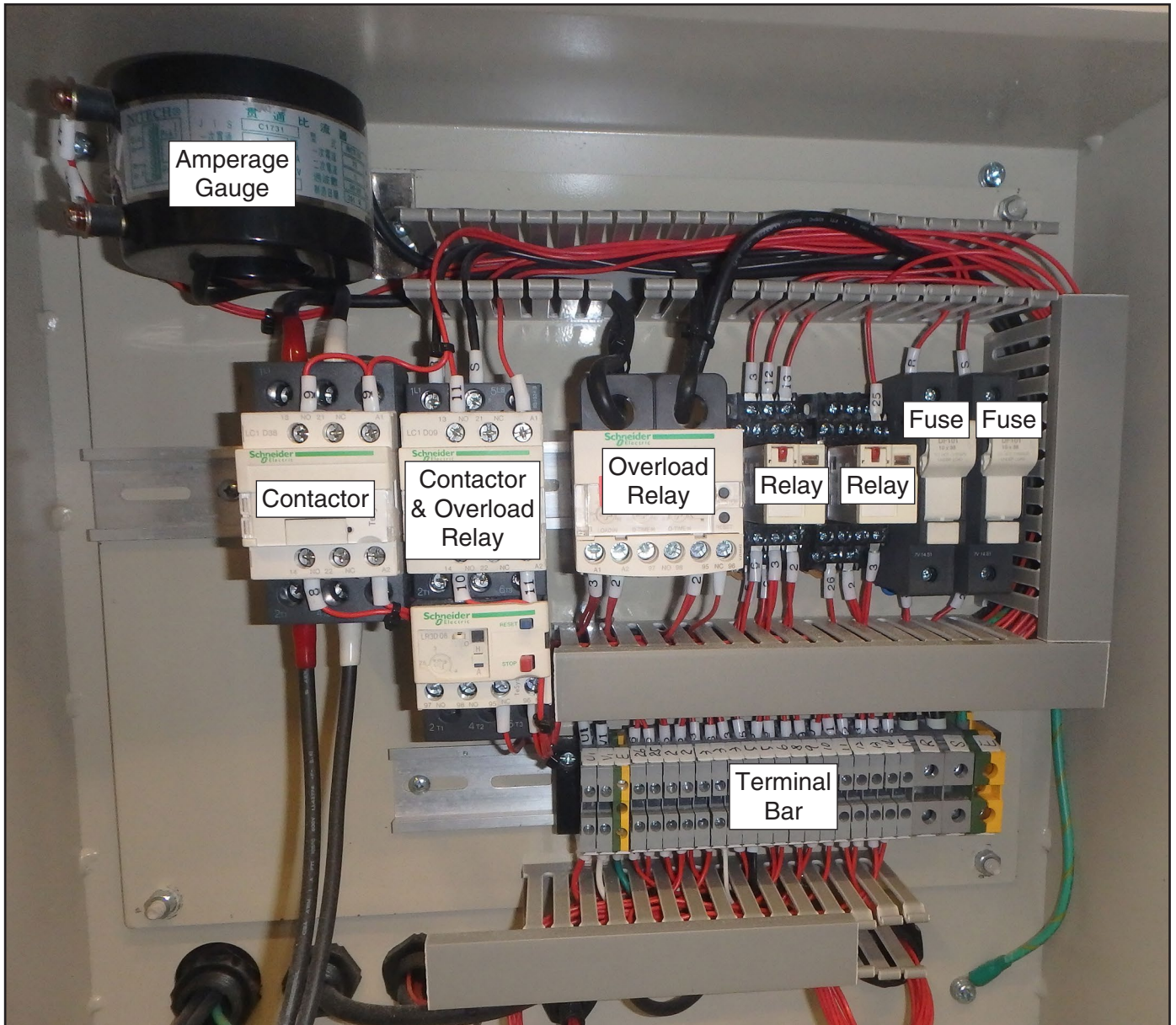


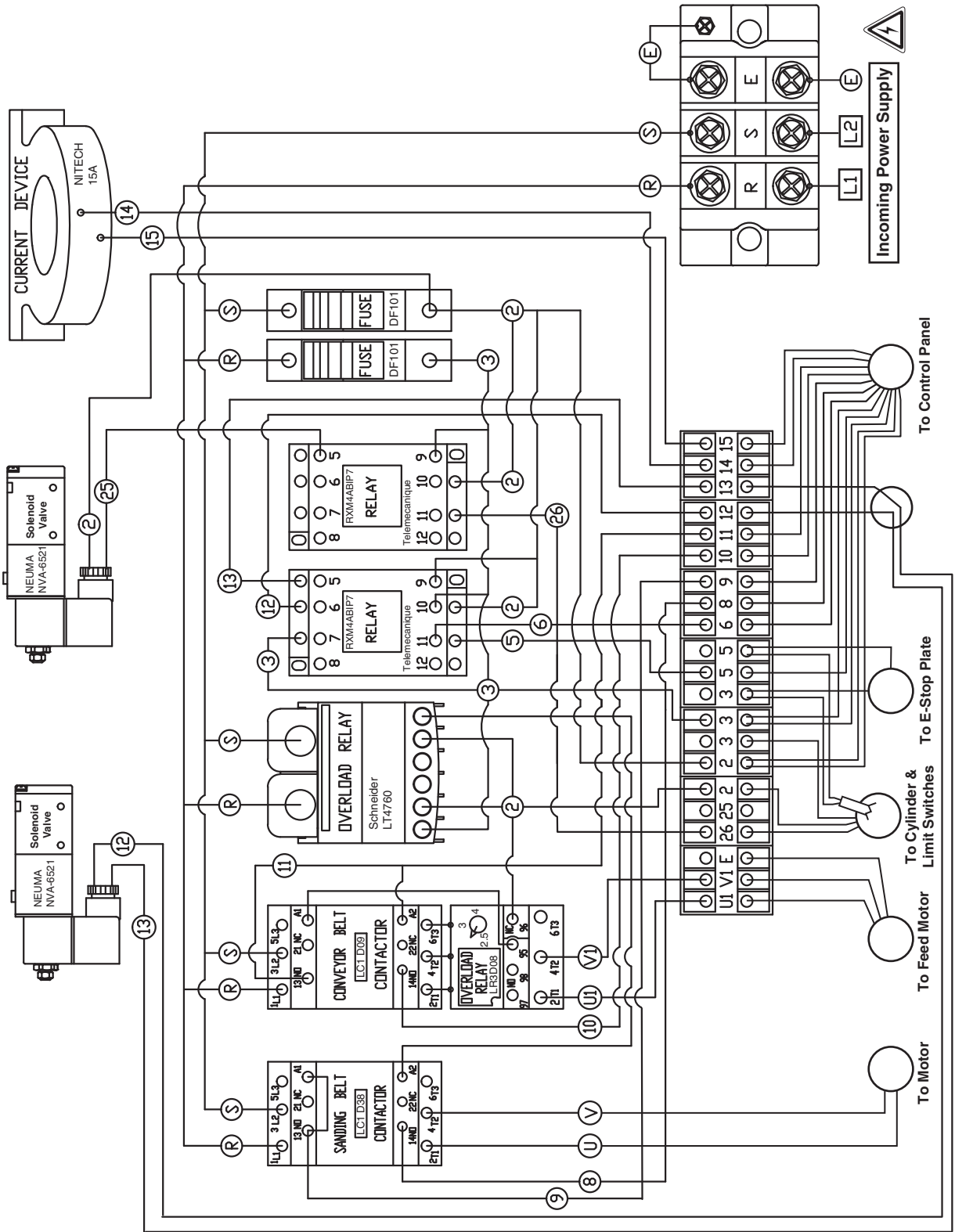
Figure 89. Electrical cabinet wiring.



Figure 90. Pneumatic solenoids.



# Electrical Box Diagram





# Control Panel Wiring

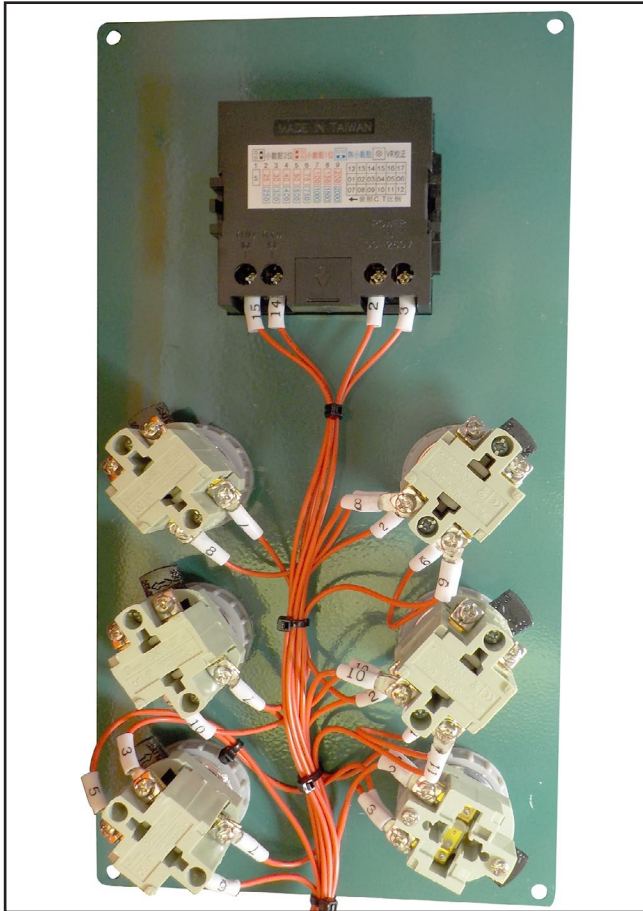


Figure 91. Control panel wiring.

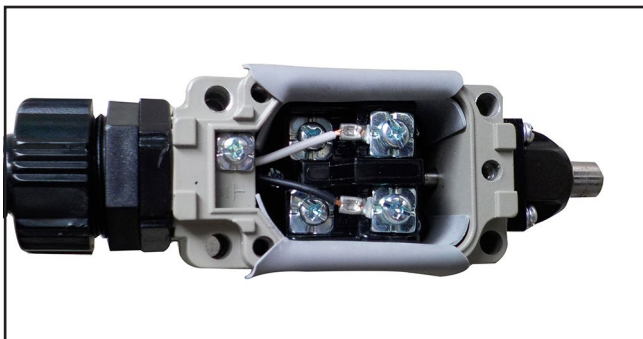
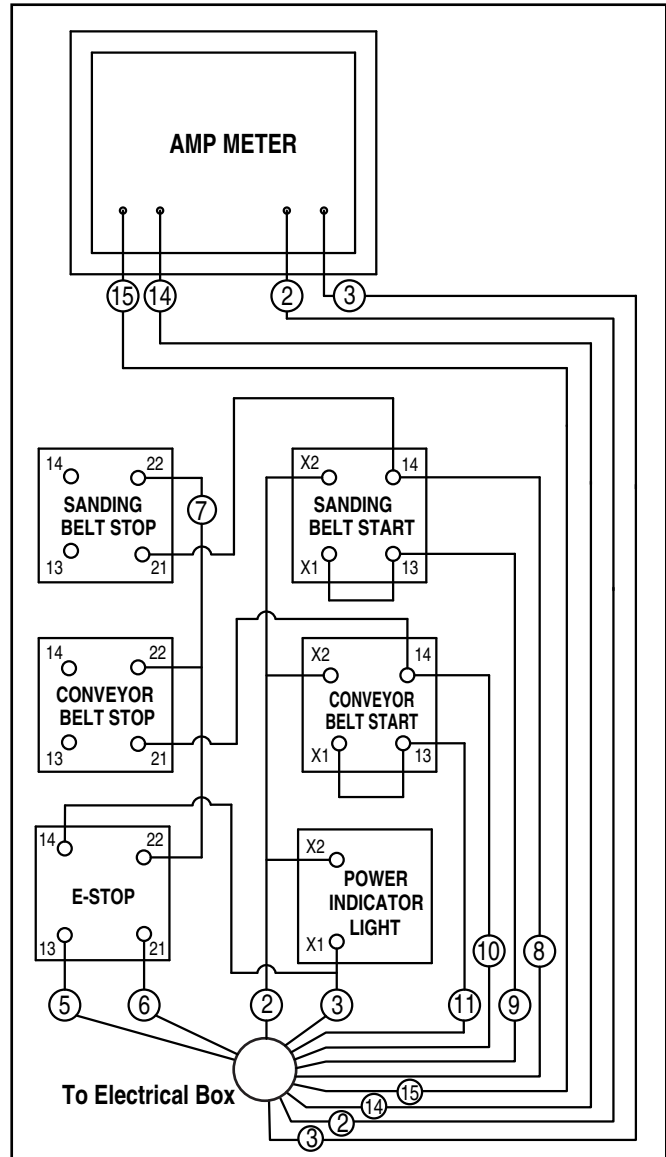


Figure 92. E-Stop panel limit switch.

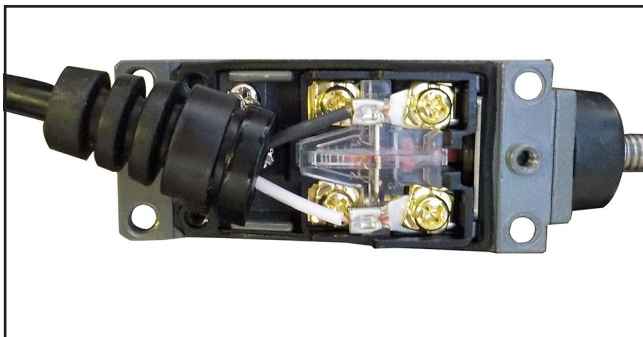
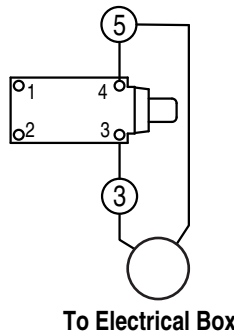
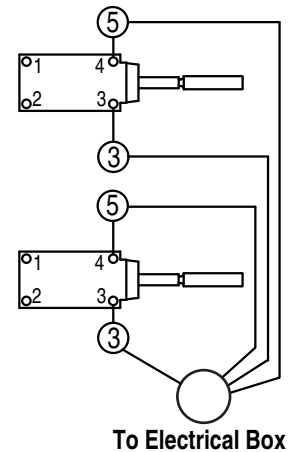


Figure 93. Belt limit switch (1 of 2).

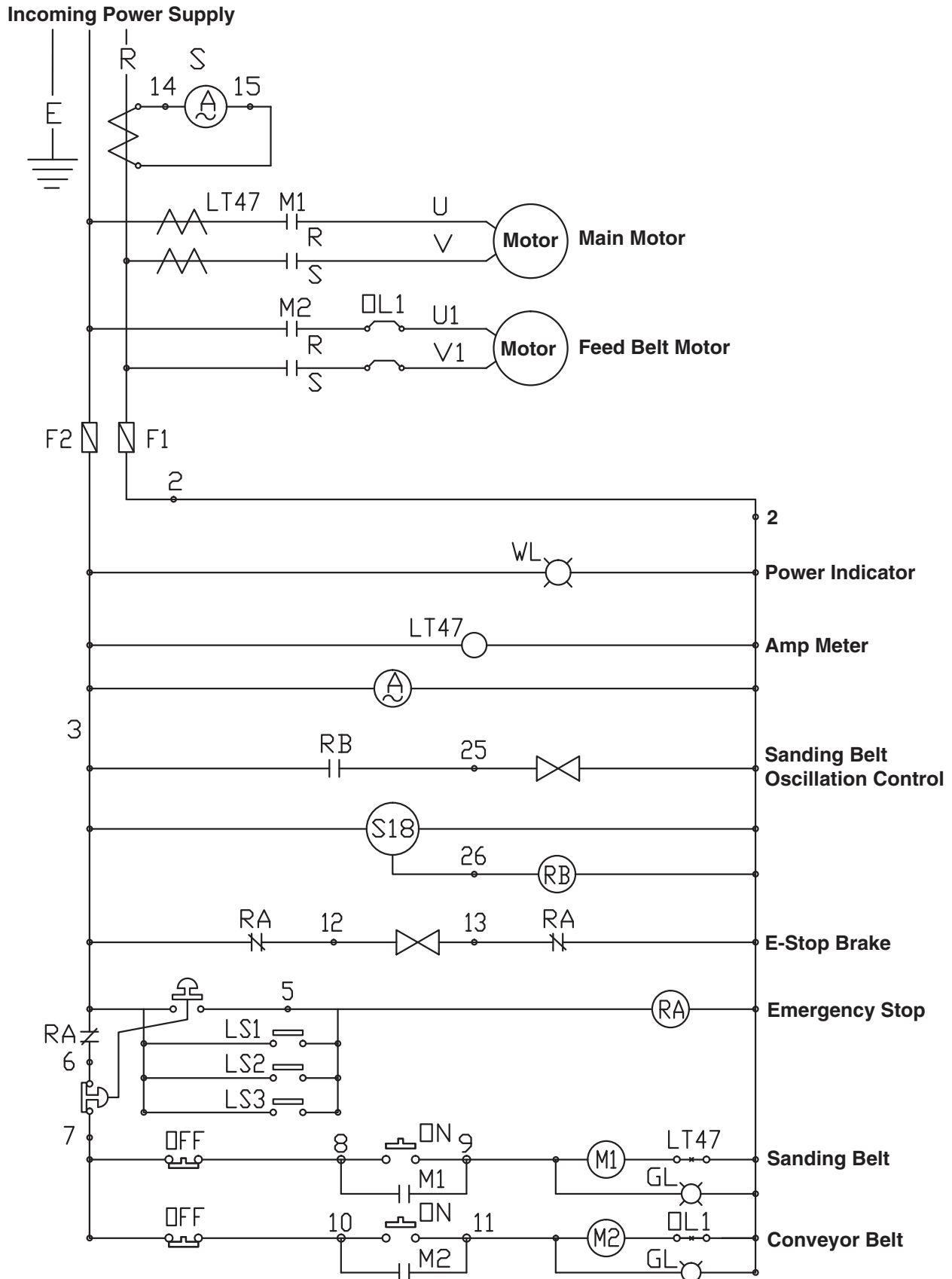
EMERGENCY STOP  
LIMIT SWITCH



BELT LIMIT  
SWITCHES



# Control Panel Wiring Schematic





# Motor Wiring

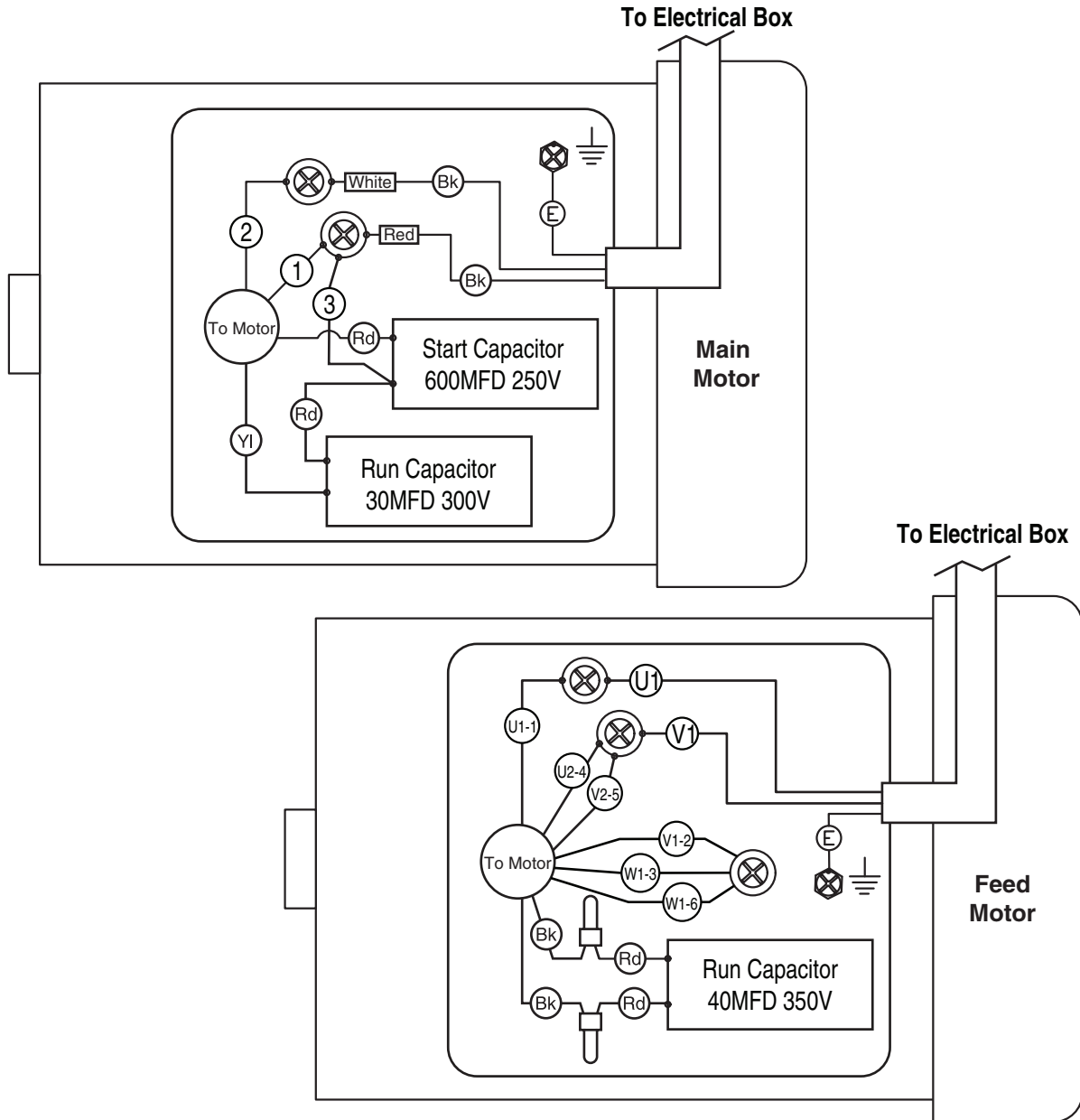


Figure 94. Main motor wiring.

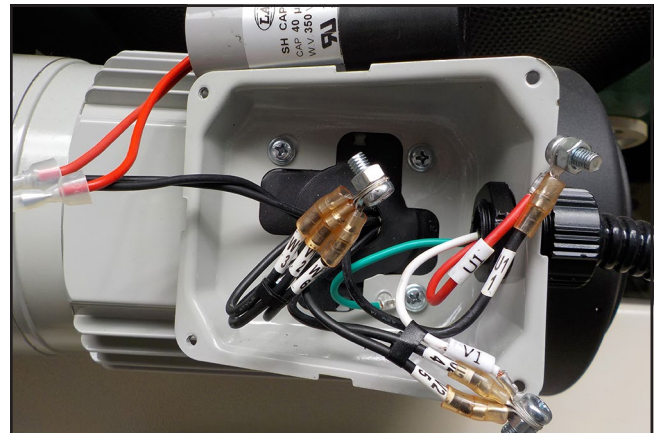
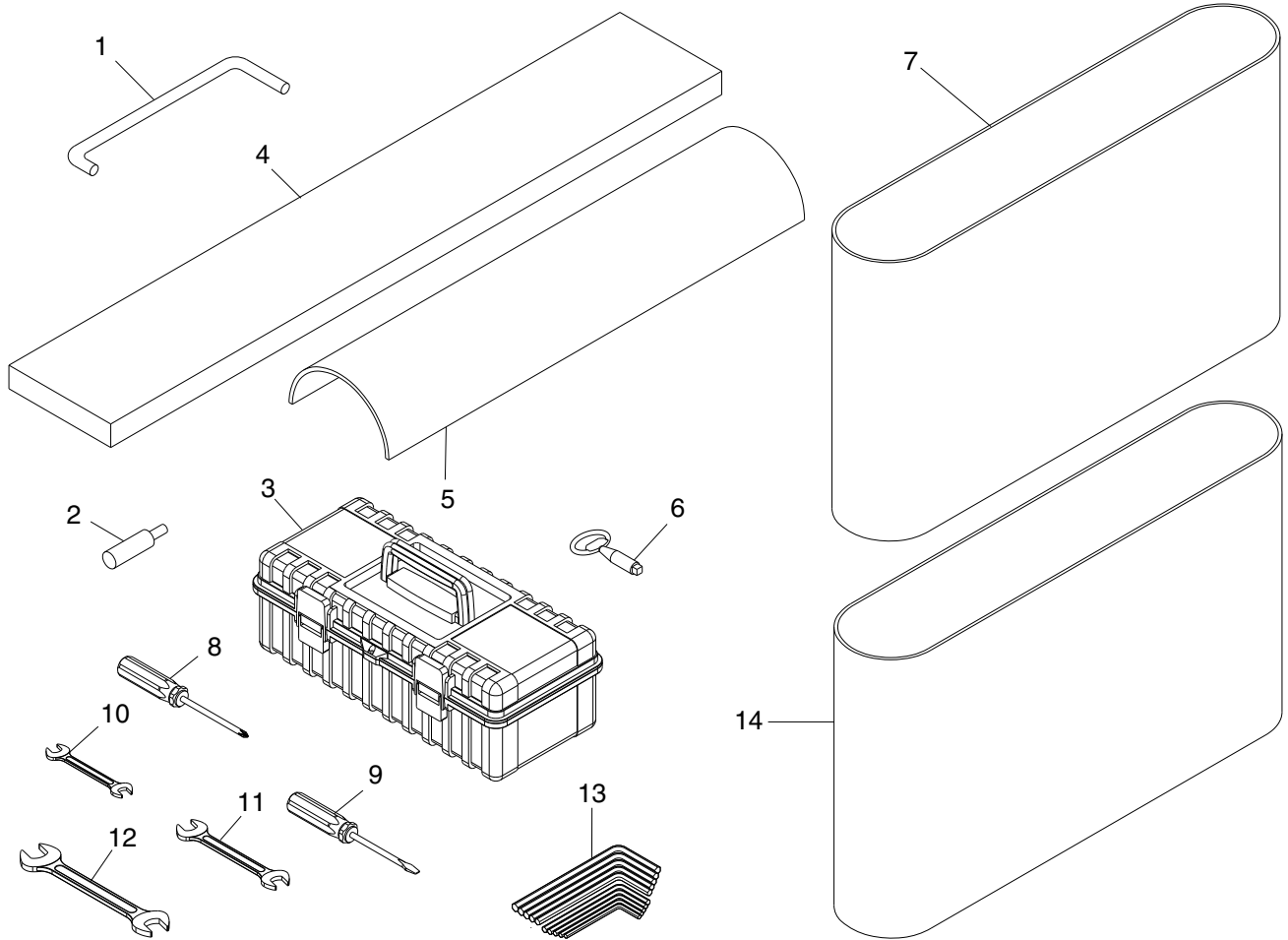


Figure 95. Feed motor wiring.



# SECTION 9: PARTS

## Tools and Accessories



REF PART #	DESCRIPTION
1	P08190001 PLATEN REMOVAL TOOL
2	P08190002 LIMIT SWITCH CERAMIC TIP COVER
3	P08190003 TOOL BOX
4	P08190004 FELT PAD 16 X 1-3/4 X 1/2
5	P08190005 GRAPHITE PAD 16 X 3-1/2
6	P08190006 DOOR KEY
7	P08190007 SANDING BELT 16" X 48" #100

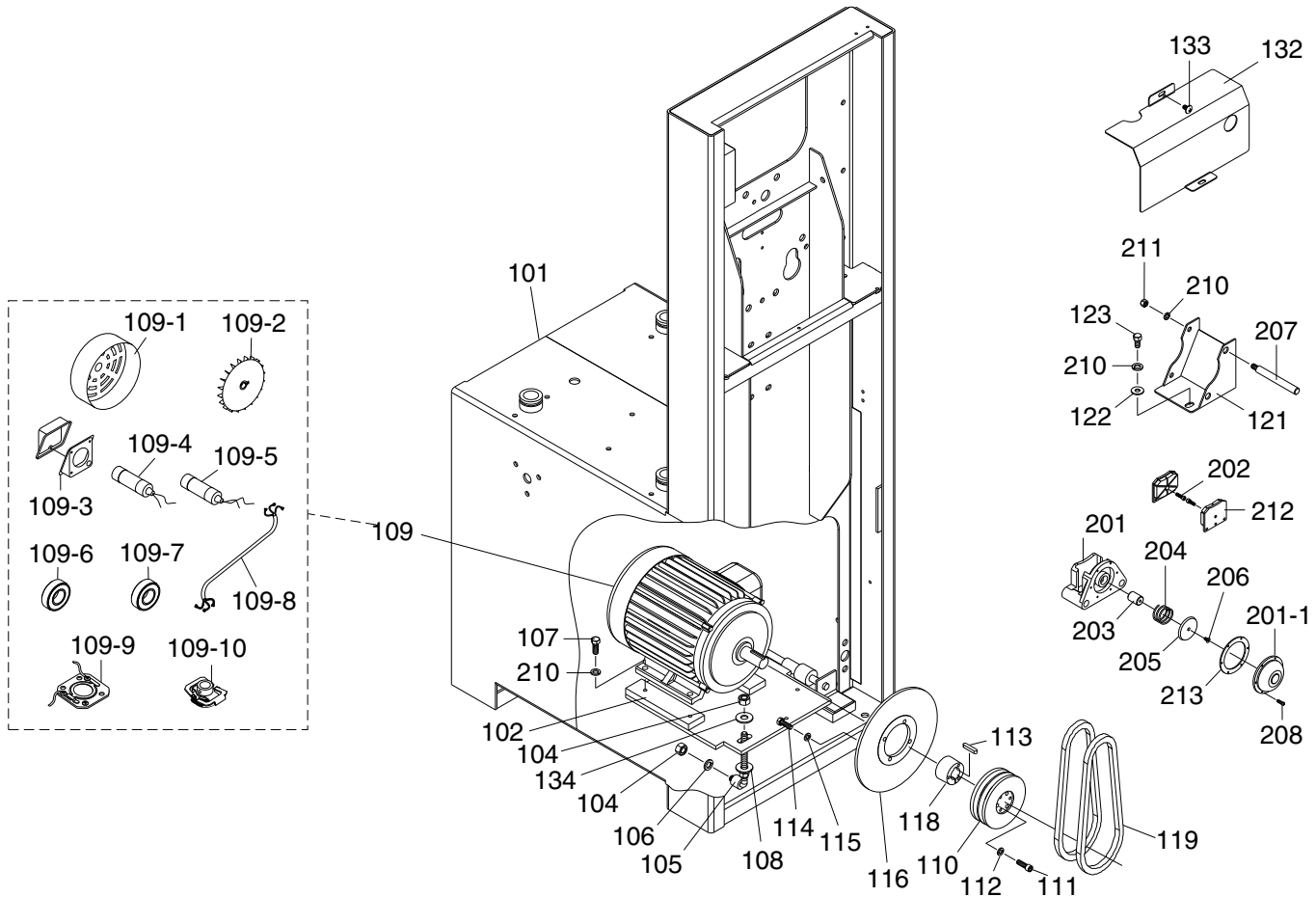
REF PART #	DESCRIPTION
8	P08190008 PHILLIPS SCREWDRIVER #2
9	P08190009 FLAT SCREWDRIVER #2
10	P08190010 WRENCH 8 X 10MM OPEN-ENDS
11	P08190011 WRENCH 12 X 14MM OPEN-ENDS
12	P08190012 WRENCH 17 X 19MM OPEN-ENDS
13	P08190013 HEX WRENCH SET 1.5-10MM 10-PC
14	P08190014 SANDING BELT 16" X 48" #180

### NOTICE

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](http://www.grizzly.com/parts) to check for availability.



# Main Motor & Frame

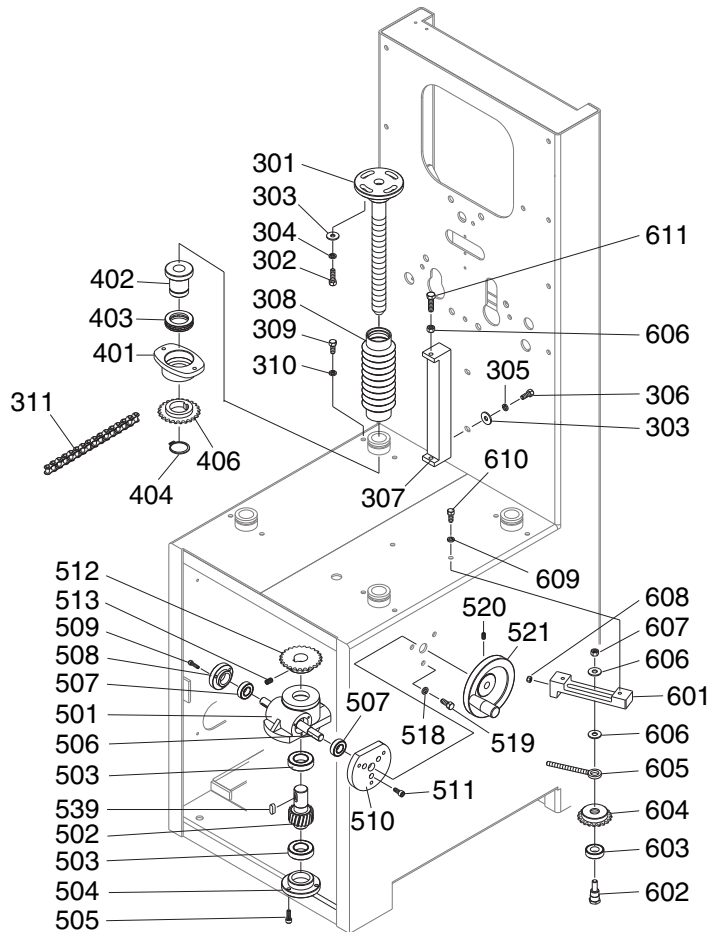


REF	PART #	DESCRIPTION
101	P08190101	MACHINE FRAME
102	P08190102	MOTOR BASE
104	P08190104	HEX NUT 1/2-12
105	P08190105	TENSION ADJUSTMENT ROD 1/2-12 X 3-1/2
106	P08190106	LOCK WASHER 1/2
107	P08190107	HEX BOLT 3/8-16 X 1-1/4
108	P08190108	FLAT WASHER 1/2
109	P08190109	MAIN MOTOR 5HP 220V 1-PH
109-1	P08190109-1	MOTOR FAN COVER
109-2	P08190109-2	MOTOR FAN
109-3	P08190109-3	MOTOR JUNCTION BOX
109-4	P08190109-4	S CAPACITOR 600M 250V 1-13/16 X 3-1/2
109-5	P08190109-5	R CAPACITOR 30M 300V 1-13/16 X 4
109-6	P08190109-6	BALL BEARING 6204-2RS
109-7	P08190109-7	BALL BEARING 6206-2RS
109-8	P08190109-8	MOTOR CORD 10G 3W 24"
109-9	P08190109-9	CONTACT PLATE
109-10	P08190109-10	CENTRIFUGAL SWITCH
110	P08190110	PULLEY
111	P08190111	CAP SCREW 5/16-18 X 1-1/4
112	P08190112	LOCK WASHER 5/16
113	P08190113	KEY 8 X 7 X 40
114	P08190114	HEX BOLT 5/16-18 X 1

REF	PART #	DESCRIPTION
115	P08190115	LOCK WASHER 5/16
116	P08190116	DISC BRAKE
118	P08190118	PULLEY BUSHING
119	P08190119	V-BELT A78
121	P08190121	BRAKE BRACKET
122	P08190122	FLAT WASHER 3/8
123	P08190123	HEX BOLT 3/8-16 X 3/4
132	P08190132	PULLEY COVER
133	P08190133	PHLP HD SCR 1/4-20 X 1/2
134	P08190134	FLAT WASHER 1/2
201	P08190201	BRAKE BRACKET
201-1	P08190201-1	BRAKE BRACKET COVER
202	P08190202	CAP SCREW M6-1 X 12
203	P08190203	BRAKE ARBOR
204	P08190204	BRAKE COMPRESSION SPRING
205	P08190205	BRAKE ARBOR PLATE
206	P08190206	FLAT HD SCR M6-1 X 25
207	P08190207	STUD SE 3/8-16 X 1/2, 5"L
208	P08190208	CAP SCREW M5-.8 X 15
210	P08190210	LOCK WASHER 3/8
211	P08190211	HEX NUT 3/8-16
212	P08190212	BRAKE LINING
213	P08190213	BRAKE BRACKET GASKET



# Table Lift System

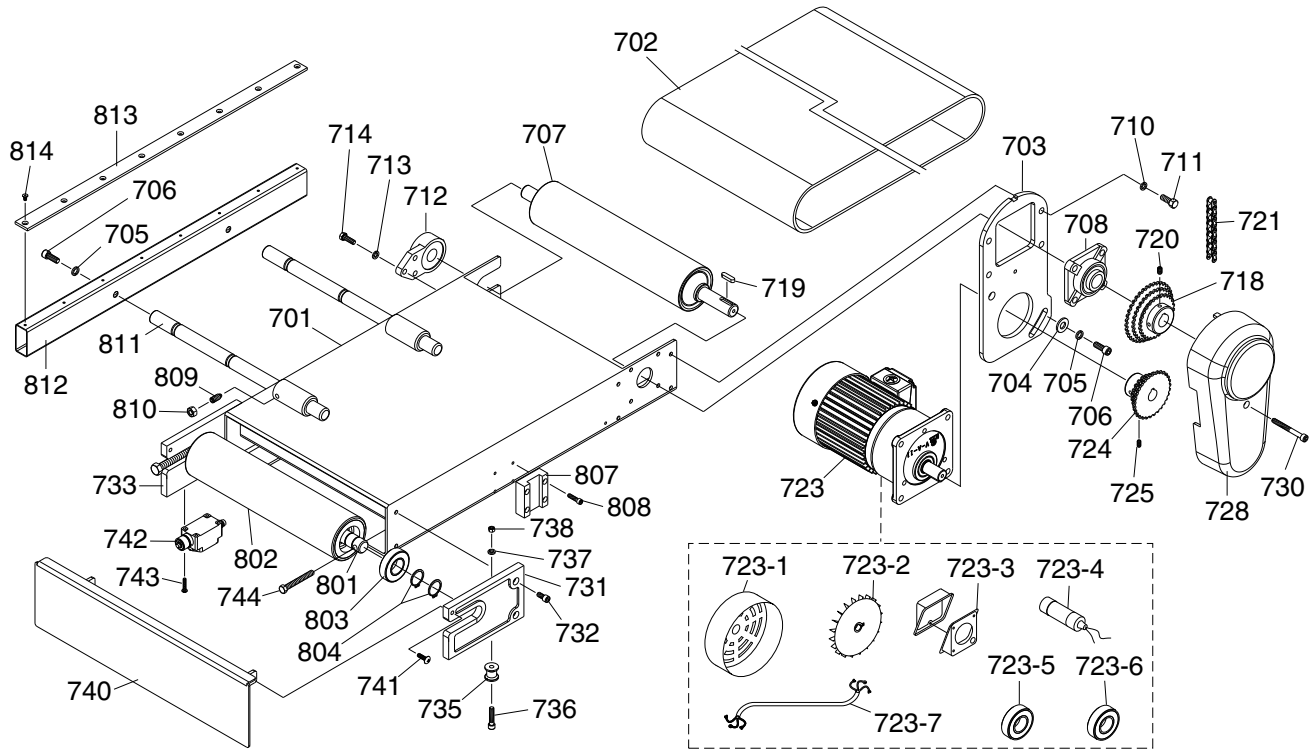


REF	PART #	DESCRIPTION
301	P08190301	TABLE ELEVATION LEADSCREW
302	P08190302	HEX BOLT 5/16-18 X 1
303	P08190303	FLAT WASHER 5/16
304	P08190304	LOCK WASHER 5/16
305	P08190305	LOCK WASHER 5/16
306	P08190306	HEX BOLT 5/16-18 X 3/4
307	P08190307	ELEVATION SLIDE
308	P08190308	LEADSCREW RUBBER BOOT
309	P08190309	HEX BOLT 5/16-18 X 3/4
310	P08190310	LOCK WASHER 5/16
311	P08190311	CHAIN 3/8" X 60"
401	P08190401	SPROCKET SHAFT HOUSING
402	P08190402	SPROCKET SHAFT
403	P08190403	THRUST BEARING 51107
404	P08190404	EXT RETAINING RING 35MM
406	P08190406	LEADSCREW SPROCKET 24T
501	P08190501	ELEVATION GEARBOX
502	P08190502	WORM GEAR
503	P08190503	BALL BEARING 6005-2RS
504	P08190504	BEARING CAP (BOTTOM)
505	P08190505	PHLP HD SCR 1/4-20 X 3/4
506	P08190506	WORM SHAFT
507	P08190507	BALL BEARING 6002-2RS

REF	PART #	DESCRIPTION
508	P08190508	BEARING CAP (L)
509	P08190509	CAP SCREW #10-24 X 5/8
510	P08190510	BEARING CAP (R)
511	P08190511	CAP SCREW 1/4-20 X 5/8
512	P08190512	DRIVE SPROCKET 24T
513	P08190513	SET SCREW 5/16-18 X 1/2
518	P08190518	LOCK WASHER 5/16
519	P08190519	HEX BOLT 5/16-18 X 5/8
520	P08190520	SET SCREW 1/4-20 X 3/4
521	P08190521	HANDWHEEL TYPE-9 125D X 14B-S X M10-1.5
539	P08190539	KEY 8 X 8 X 20 RE
601	P08190601	CHAIN TENSIONER BRACKET
602	P08190602	SPROCKET SHAFT
603	P08190603	BALL BEARING 6003-2RS
604	P08190604	TENSIONER SPROCKET 20T
605	P08190605	ADJUSTMENT ROD
606	P08190606	HEX NUT 3/8-16
607	P08190607	HEX NUT 3/8-16
608	P08190608	HEX NUT 5/16-18
609	P08190609	LOCK WASHER 5/16
610	P08190610	HEX BOLT 5/16-18 X 5/8
611	P08190611	HEX BOLT 3/8-16 X 1-1/4



# Conveyor Belt & Table



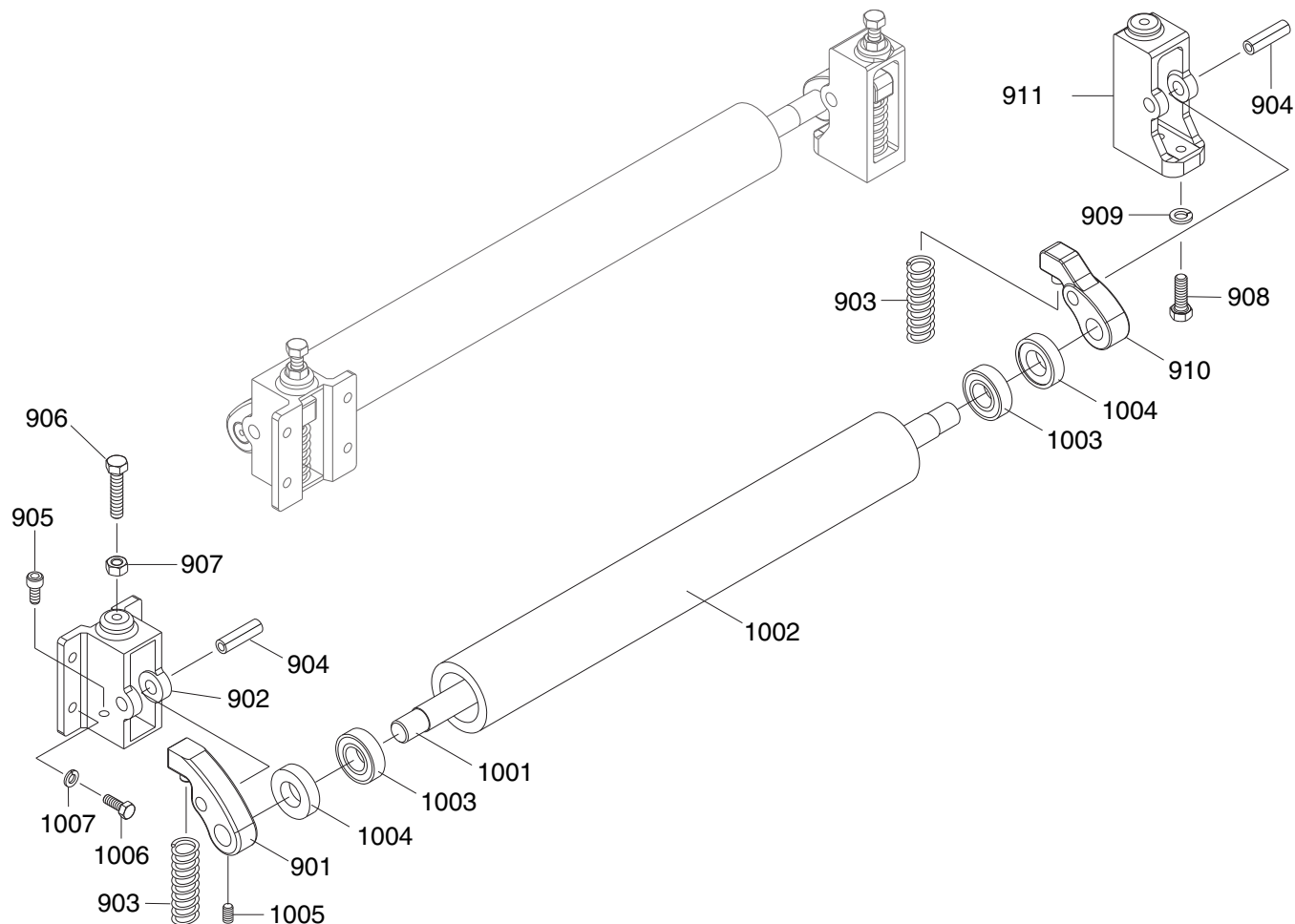
REF	PART #	DESCRIPTION
701	P08190701	CONVEYOR TABLE
702	P08190702	CONVEYOR BELT
703	P08190703	FEED MOTOR MOUNTING PLATE
704	P08190704	FLAT WASHER 14MM
705	P08190705	LOCK WASHER 14MM
706	P08190706	CAP SCREW M14-2 X 30
707	P08190707	OUTFEED ROLLER
708	P08190708	PILLOW BEARING UCF205
710	P08190710	LOCK WASHER 3/8
711	P08190711	HEX BOLT 3/8-16 X 1
712	P08190712	PILLOW BEARING UCFK205
713	P08190713	LOCK WASHER 5/16
714	P08190714	HEX BOLT 5/16-18 X 3/4
718	P08190718	FEED ROLLER SPROCKET
719	P08190719	KEY 8 X 8 X 30
720	P08190720	SET SCREW 5/16-18 X 1/2
721	P08190721	CHAIN 3/8" X 28"
723	P08190723	FEED MOTOR 1/2HP 220V 1-PH
723-1	P08190723-1	MOTOR FAN COVER
723-2	P08190723-2	MOTOR FAN
723-3	P08190723-3	MOTOR JUNCTION BOX
723-4	P08190723-4	R CAPACITOR 40M 350V 1-5/8 X 3-1/2
723-5	P08190723-5	BALL BEARING 6202ZZ (FRONT)
723-6	P08190723-6	BALL BEARING 6202ZZ (REAR)
723-7	P08190723-7	MOTOR CORD 18G 3W 72"
724	P08190724	FEED MOTOR SPROCKET
725	P08190725	SET SCREW 5/16-18 X 1/2

REF	PART #	DESCRIPTION
728	P08190728	CHAIN COVER
730	P08190730	CAP SCREW 5/16-18 X 3-1/2
731	P08190731	INFEED ROLLER BRACKET (R)
732	P08190732	CAP SCREW 3/8-16 X 3/4
733	P08190733	INFEED ROLLER BRACKET (L)
735	P08190735	CONVEYOR BELT EDGE ROLLER
736	P08190736	CAP SCREW 5/16-18 X 2
737	P08190737	LOCK WASHER 5/16
738	P08190738	HEX NUT 5/16-18
740	P08190740	EMERGENCY STOP COVER
741	P08190741	PHLP HD SCR 1/4-20 X 1
742	P08190742	LIMIT SWITCH TEND TZ-5101
743	P08190743	PHLP HD SCR #10-24 X 1-1/2
744	P08190744	HEX BOLT 1/2-12 X 3-1/2
801	P08190801	INFEED ROLLER SHAFT
802	P08190802	INFEED ROLLER
803	P08190803	BALL BEARING 6205-2RS
804	P08190804	EXT RETAINING RING 25MM
807	P08190807	ELEVATION SLIDE BRACKET
808	P08190808	CAP SCREW 5/16-18 X 3/4
809	P08190809	SET SCREW M10-1.5 X 20
810	P08190810	HEX NUT M10-1.5
811	P08190811	EXTENSION SHAFT
812	P08190812	TABLE EXTENSION SUPPORT
813	P08190813	TABLE EXTENSION COVER
814	P08190814	FLAT HD SCR M5-.8 X 8





# Pressure Roller

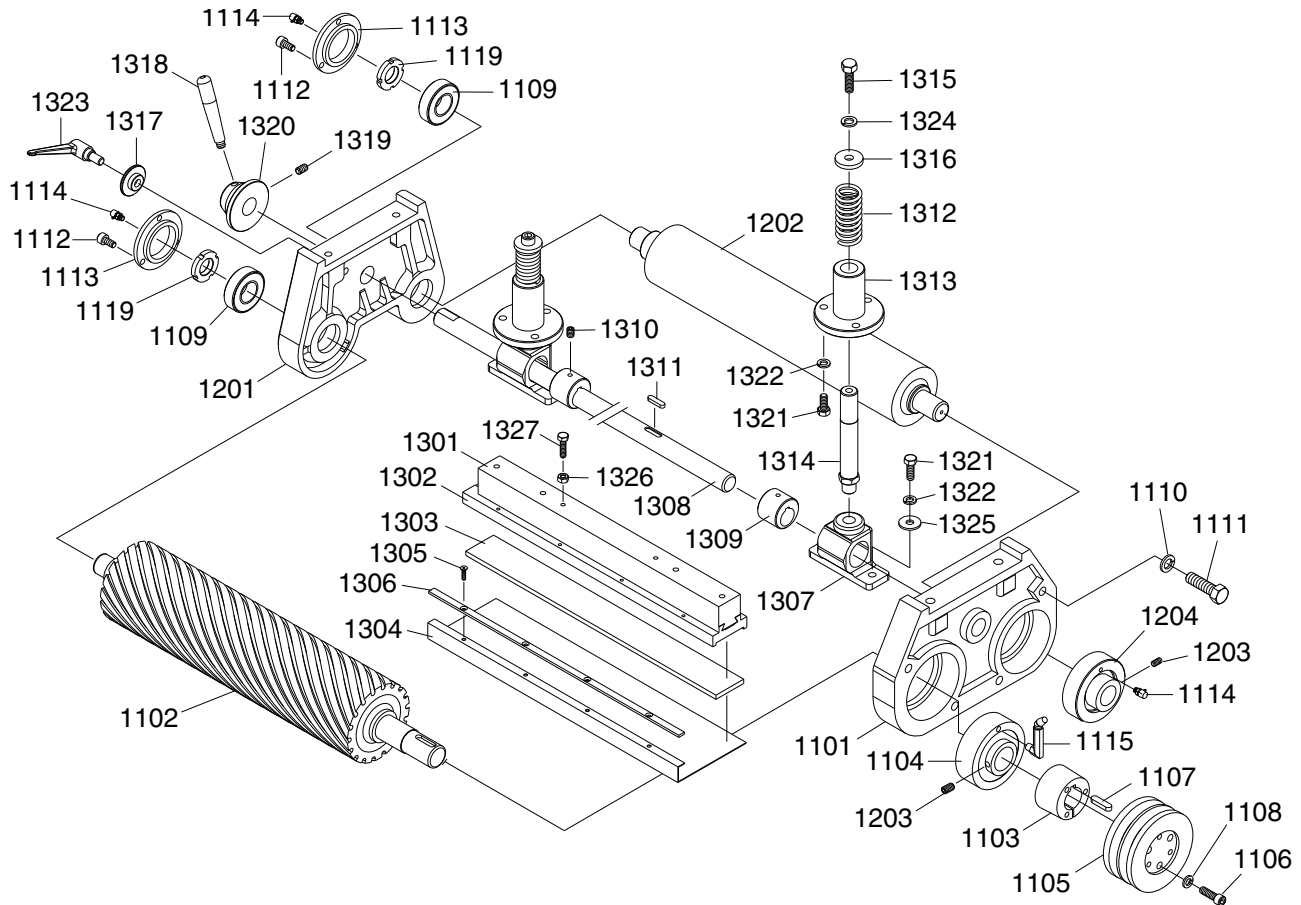


REF	PART #	DESCRIPTION
901	P08190901	ROCKER ARM (LEFT)
902	P08190902	ROCKER ARM BRACKET (LEFT)
903	P08190903	COMPRESSION SPRING 50 X 16 X 2MM
904	P08190904	ROLL PIN 10 X 36
905	P08190905	CAP SCREW 1/4-20 X 1/2
906	P08190906	HEX BOLT 5/16-18 X 1-1/2
907	P08190907	HEX NUT 5/16-18
908	P08190908	HEX BOLT 5/16-18 X 3/4
909	P08190909	LOCK WASHER 5/16

REF	PART #	DESCRIPTION
910	P08190910	ROCKER ARM (RIGHT)
911	P08190911	ROCKER ARM BRACKET (RIGHT)
1001	P08191001	PRESSURE ROLLER SHAFT
1002	P08191002	PRESSURE ROLLER
1003	P08191003	BALL BEARING 6003-2RS
1004	P08191004	SHAFT BEARING SPACER 18ID
1005	P08191005	SET SCREW 1/4-20 X 3/8
1006	P08191006	HEX BOLT M6-1 X 16
1007	P08191007	LOCK WASHER 6MM



# Sanding Drum & Platen

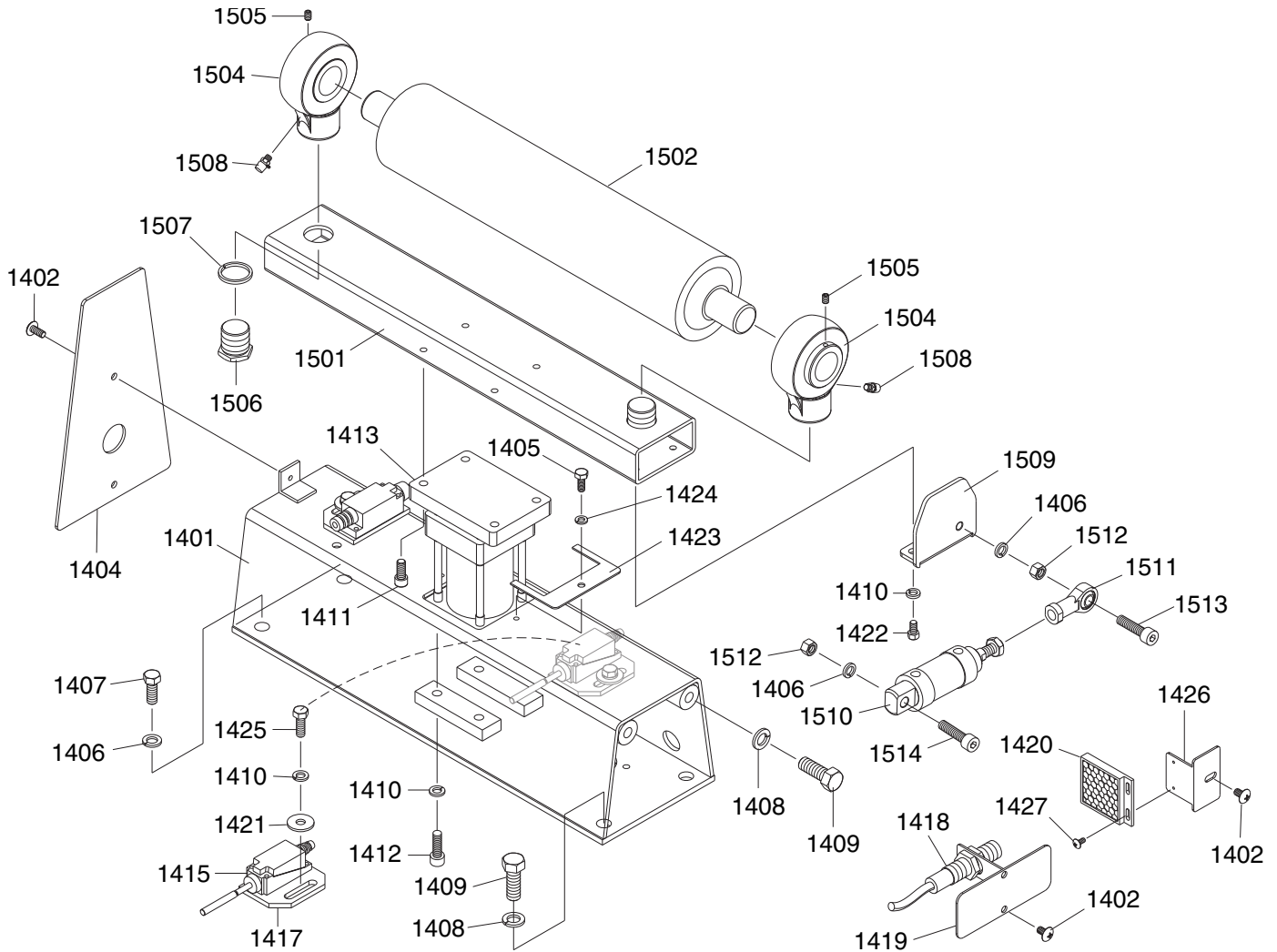


REF	PART #	DESCRIPTION
1101	P08191101	ROLLER HOUSING (RIGHT)
1102	P08191102	RUBBER SANDING DRUM
1103	P08191103	KEYED PULLEY TUBE
1104	P08191104	CARTRIDGE BEARING UCC205
1105	P08191105	DRUM PULLEY
1106	P08191106	CAP SCREW 5/16-18 X 1-1/4
1107	P08191107	KEY 8 X 8 X 30
1108	P08191108	LOCK WASHER 5/16
1109	P08191109	BALL BEARING 6205-2RS
1110	P08191110	LOCK WASHER 1/2
1111	P08191111	HEX BOLT 1/2-13 X 1
1112	P08191112	CAP SCREW 1/4-20 X 1/2
1113	P08191113	BEARING CAP
1114	P08191114	GREASE FITTING 1/4-28 STRAIGHT
1115	P08191115	GREASE FITTING 1/4-28 45-DEG
1119	P08191119	SPANNER NUT M25-2
1201	P08191201	ROLLER HOUSING (LEFT)
1202	P08191202	STEEL SANDING DRUM
1203	P08191203	SET SCREW M6-1 X 6
1204	P08191204	CARTRIDGE BEARING UCC205
1301	P08191301	PLATEN MOUNTING BLOCK
1302	P08191302	PLATEN HOUSING
1303	P08191303	FELT PAD 16 X 1-3/4 X 1/2
1304	P08191304	GRAPHITE PAD 16 X 3-1/2

REF	PART #	DESCRIPTION
1305	P08191305	PHLP HD SCR #10-24 X 1/2
1306	P08191306	PRESSURE PLATE
1307	P08191307	PLATEN MOUNTING BRACKET
1308	P08191308	PLATEN ADJUSTMENT SHAFT
1309	P08191309	ECCENTRIC LOCK COLLAR
1310	P08191310	SET SCREW 1/4-20 X 1/4
1311	P08191311	KEY 1/4 X 1/4 X 1
1312	P08191312	COMPRESSION SPRING
1313	P08191313	SPRING HOUSING
1314	P08191314	PLATEN SPRING SHAFT
1315	P08191315	HEX BOLT 3/8-16 X 3/4
1316	P08191316	FLAT WASHER 3/8
1317	P08191317	PLATEN LOCK RING 10 X 38
1318	P08191318	HANDLE 3/8-16 X 5/8 X 3-1/2
1319	P08191319	SET SCREW 5/16-18 X 1/2
1320	P08191320	PLATEN ADJUSTMENT HUB
1321	P08191321	HEX BOLT 5/16-18 X 1
1322	P08191322	LOCK WASHER 5/16
1323	P08191323	ADJUSTABLE HANDLE 2-3/4" X 1/4"-20
1324	P08191324	LOCK WASHER 3/8
1325	P08191325	FLAT WASHER 5/16
1326	P08191326	HEX NUT 5/16-18
1327	P08191327	HEX BOLT 5/16-18 X 3/4



# Upper Belt Roller System

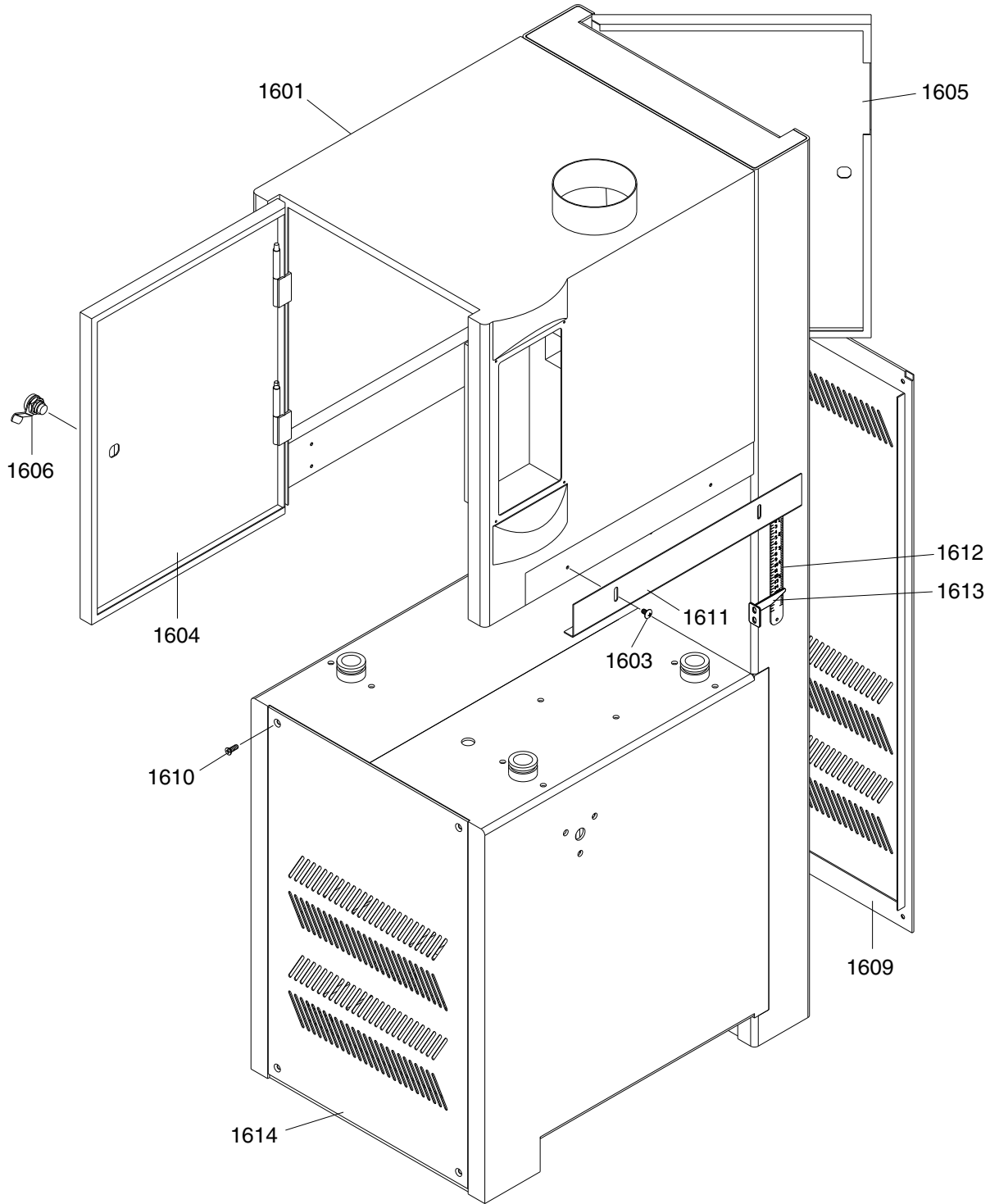


REF	PART #	DESCRIPTION
1401	P08191401	UPPER ROLLER BASE FRAME
1402	P08191402	FLAT HD SCR 1/4-20 X 1/2
1404	P08191404	FRAME SEAL (LEFT)
1405	P08191405	HEX BOLT 1/4-20 X 1/2
1406	P08191406	LOCK WASHER 3/8
1407	P08191407	HEX BOLT 3/8-16 X 1
1408	P08191408	LOCK WASHER 1/2
1409	P08191409	HEX BOLT 1/2-12 X 1
1410	P08191410	LOCK WASHER 5/16
1411	P08191411	CAP SCREW 5/16-18 X 3/4
1412	P08191412	CAP SCREW M8-1.25 X 35
1413	P08191413	BELT TENSION AIR CYLINDER
1415	P08191415	LIMIT SWITCH MOUJEN ME-8166
1417	P08191417	LIMIT SWITCH MOUNTING BRACKET
1418	P08191418	SENSOR (BANNER ELECTRONIC EYE)
1419	P08191419	SENSOR MOUNTING PLATE
1420	P08191420	SENSOR MIRROR
1421	P08191421	FLAT WASHER 5/16
1422	P08191422	HEX BOLT 5/16-18 X 1/2

REF	PART #	DESCRIPTION
1423	P08191423	AIR CYLINDER COVER
1424	P08191424	LOCK WASHER 1/4
1425	P08191425	HEX BOLT 5/16-18 X 3/4
1426	P08191426	MIRROR MOUNTING BRACKET
1427	P08191427	PHLP HD SCR M4-.7 X 12
1501	P08191501	UPPER ROLLER BRACKET
1502	P08191502	UPPER ROLLER
1504	P08191504	ROD END BEARING UCECH206
1505	P08191505	SET SCREW M6-1 X 6
1506	P08191506	HEX BOLT 1"-14 X 1"
1507	P08191507	LOCK WASHER 1"
1508	P08191508	GREASE FITTING 1/8-27 45 DEG
1509	P08191509	UPPER ROLLER COVER (RIGHT)
1510	P08191510	AIR CYLINDER E:30 5SD+ 9.9 BAR
1511	P08191511	ROD END BEARING PHS-10, FEMALE
1512	P08191512	HEX NUT 3/8-16
1513	P08191513	CAP SCREW 3/8-16 X 1-1/4
1514	P08191514	CAP SCREW 3/8-16 X 2



# Frame Covers and Doors

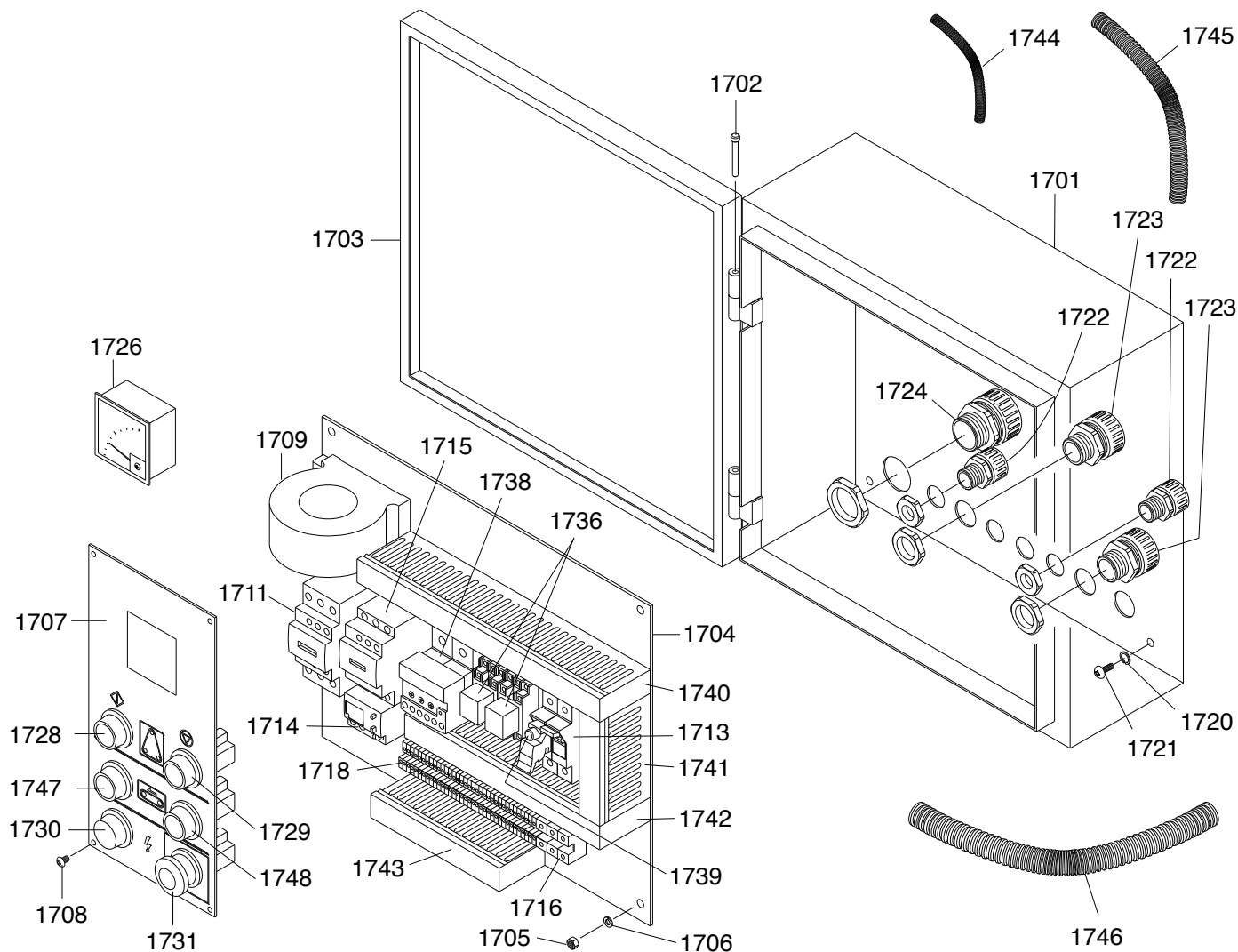


REF	PART #	DESCRIPTION
1601	P08191601	UPPER FRAME COVER
1603	P08191603	PHLP HD SCR M6-1 X 10
1604	P08191604	UPPER FRAME, LEFT DOOR
1605	P08191605	UPPER FRAME, RIGHT DOOR
1606	P08191606	DOOR LOCK (SQUARE KEY)
1609	P08191609	LOWER FRAME, RIGHT DOOR

REF	PART #	DESCRIPTION
1610	P08191610	FLAT HD SCR 1/4-20 X 1/2
1611	P08191611	PROTECTIVE PLATE
1612	P08191612	THICKNESS SCALE
1613	P08191613	THICKNESS SCALE INDICATOR
1614	P08191614	LOWER FRAME, LEFT DOOR



# Electrical Components



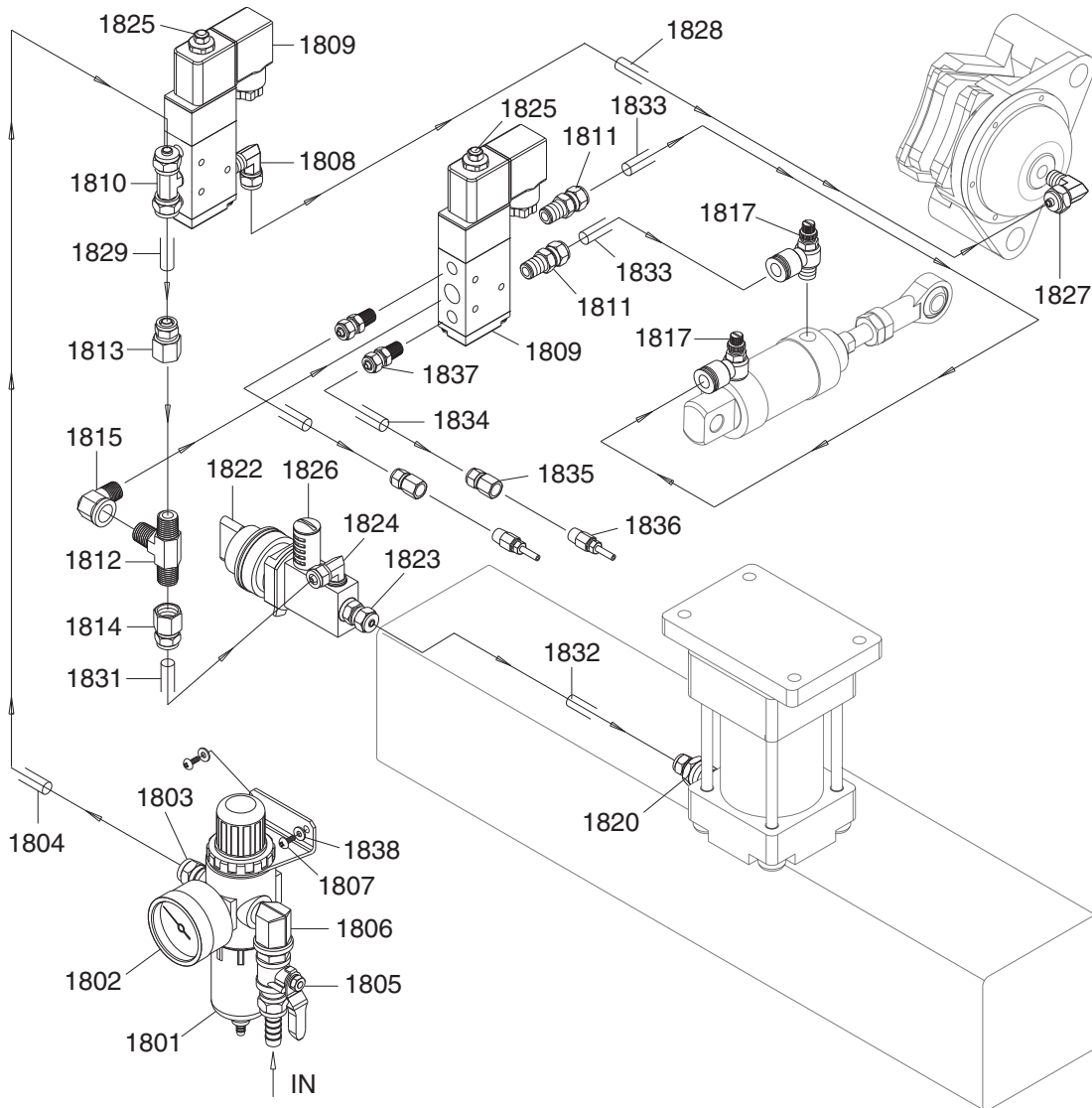
REF	PART #	DESCRIPTION
1701	P08191701	ELECTRICAL CONTROL BOX
1702	P08191702	HINGE PIN 8 X 64MM
1703	P08191703	CONTROL BOX DOOR
1704	P08191704	ELEC CONTROLS MOUNTING PLATE
1705	P08191705	HEX NUT 1/4-20
1706	P08191706	LOCK WASHER 1/4
1707	P08191707	CONTROL PANEL
1708	P08191708	PHLP HD SCR M4-.7 X 8
1709	P08191709	TRANSFORMER NITECH C1731 15A
1711	P08191711	CONTACTOR SCHN LC1D38 220V
1713	P08191713	FUSE HOLDER SCHN DF101 10 X 38
1714	P08191714	OL RELAY SCHN LR3D08 2.5-4A
1715	P08191715	CONTACTOR SCHN LC1D09 220V
1716	P08191716	POWER WIRE TERMINAL BLOCK 3P
1718	P08191718	TERMINAL BLOCK 21P
1720	P08191720	LOCK WASHER 1/4
1721	P08191721	PHLP HD SCR 1/4-20 X 1/2
1722	P08191722	STRAIN RELIEF 1/2" TYPE-3
1723	P08191723	STRAIN RELIEF 3/4" TYPE-1

REF	PART #	DESCRIPTION
1724	P08191724	CABLE CONNECTOR 1" PLASTIC 90-DEG
1726	P08191726	DIGITAL AMP METER
1728	P08191728	BUTTON SWITCH, YK 10A/250V 22MM RED
1729	P08191729	BUTTON SWITCH, YK 10A/250V 22MM GRN
1730	P08191730	PWR INDICATOR LIGHT 250V 22MM CLR
1731	P08191731	E-STOP BUTTON JSE SKB2-BE102 22MM
1736	P08191736	RELAY TELEM 6A 230V RXM4AB1P7
1738	P08191738	OL RELAY SCHN LT4760MTS 5-60A
1739	P08191739	FUSE BUSSMAN KTK-4 FA 100KA 600V
1740	P08191740	WIRE LOOM 9"
1741	P08191741	WIRE LOOM 5"
1742	P08191742	WIRE LOOM 7"
1743	P08191743	WIRE LOOM 6"
1744	P08191744	CONDUIT 3/8"
1745	P08191745	CONDUIT 5/8"
1746	P08191746	CONDUIT 1"
1747	P08191747	BUTTON SWITCH, YK 10A 250V RED
1748	P08191748	BUTTON SWITCH, YK 10A 250V GRN





# Belt Oscillator Pneumatics

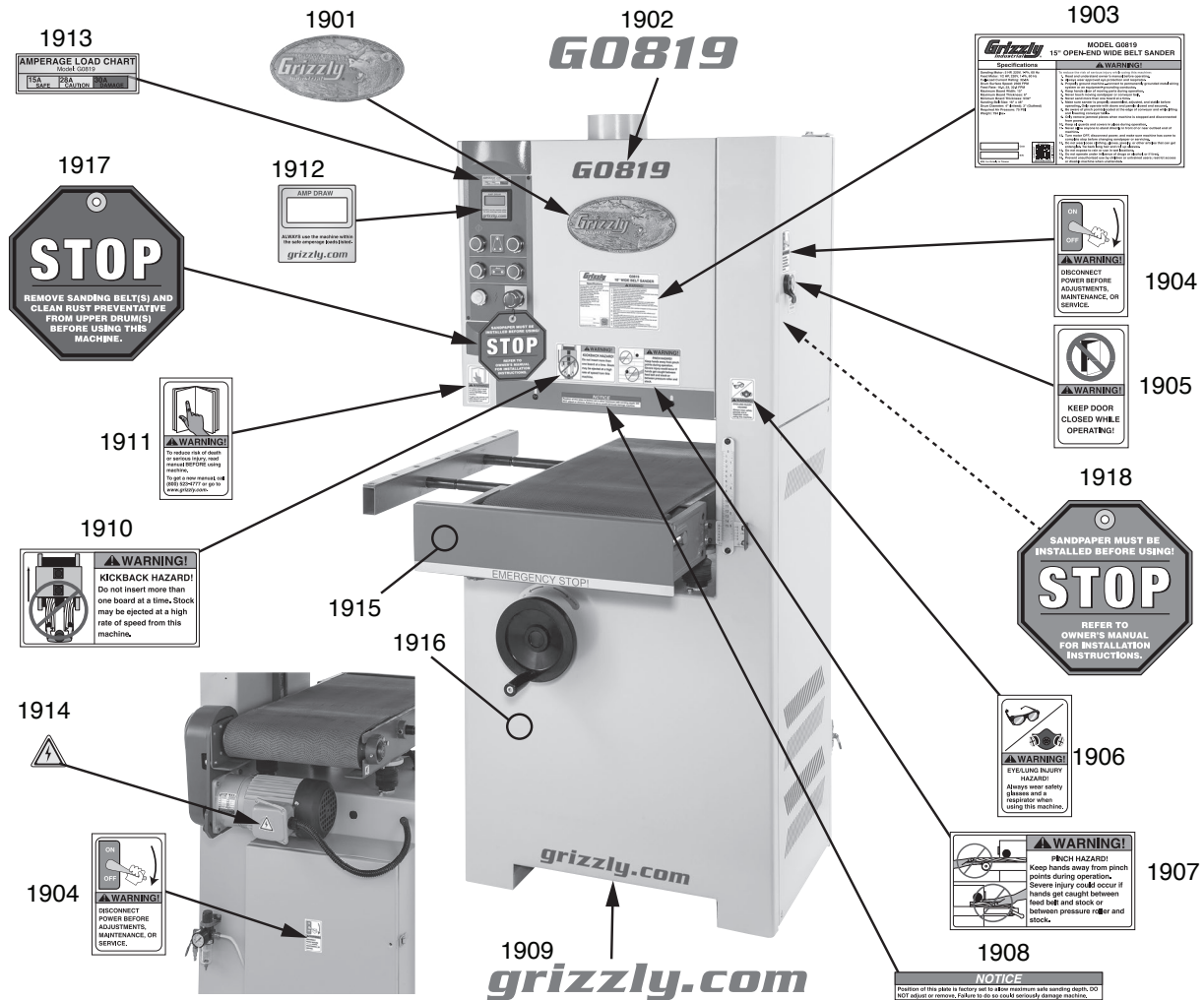


REF	PART #	DESCRIPTION
1801	P08191801	PRESSURE REGULATOR/FILTER 1/4" NPT
1802	P08191802	AIR PRESSURE GAUGE
1803	P08191803	CONNECTOR 1/4T X 5/16N BRONZE
1804	P08191804	FLEXIBLE HOSE 8MM
1805	P08191805	AIR SWITCH VALVE 1/4
1806	P08191806	ELBOW 1/4T X 1/4T
1807	P08191807	PHLP HD SCR #10-24 X 5/8
1808	P08191808	ELBOW 1/4N X 1/8T
1809	P08191809	SOLENOID VALVE NEUMA NVA-6521
1810	P08191810	T-JOINT 5/16N X 1/8T X 5/16N
1811	P08191811	CONNECTOR 1/4N X 1/4T
1812	P08191812	T-JOINT 1/4T X 1/4T X 1/4T
1813	P08191813	CONNECTOR 5/16N X 1/4T
1814	P08191814	CONNECTOR 1/4N X 1/4T
1815	P08191815	ELBOW 1/4T X 1/4T
1817	P08191817	THROTTLE VALVE 1/8
1820	P08191820	CONNECTOR 1/4N X 3/8T

REF	PART #	DESCRIPTION
1822	P08191822	AIR SWITCH 1/8
1823	P08191823	CONNECTOR 1/4N X 1/8T
1824	P08191824	CONNECTOR 1/4N X 1/8T-90-DEG
1825	P08191825	BUFFER 1/8 BRONZE
1826	P08191826	BUFFER 1/8 PLASTIC
1827	P08191827	CONNECTOR 5/16N X 1/8T-90-DEG
1828	P08191828	FLEXIBLE HOSE 8MM
1829	P08191829	FLEXIBLE HOSE 8MM
1831	P08191831	FLEXIBLE HOSE 6MM
1832	P08191832	FLEXIBLE HOSE 6MM
1833	P08191833	FLEXIBLE HOSE 6MM
1834	P08191834	FLEXIBLE HOSE 4MM
1835	P08191835	CONNECTOR 1/8T X 1/4N
1836	P08191836	CONNECTOR 1/8 X 4 W/CASING
1837	P08191837	CONNECTOR 1/4N X 1/8T
1838	P08191838	FLAT WASHER #10



# Labels & Cosmetics



REF	PART #	DESCRIPTION
1901	P08191901	GRIZZLY LOGO
1902	P08191902	MODEL NUMBER LABEL
1903	P08191903	MACHINE ID LABEL
1904	P08191904	DISCONNECT POWER LABEL
1905	P08191905	KEEP DOOR CLOSED LABEL
1906	P08191906	GLASSES/RESPIRATOR LABEL
1907	P08191907	PINCH HAZARD LABEL
1908	P08191908	PLATE POSITION NOTICE LABEL
1909	P08191909	GRIZZLY.COM LABEL

REF	PART #	DESCRIPTION
1910	P08191910	KICKBACK HAZARD LABEL
1911	P08191911	READ MANUAL LABEL
1912	P08191912	AMPERAGE DRAW LABEL
1913	P08191913	AMPERAGE LOAD CHART LABEL
1914	P08191914	ELECTRICITY LABEL
1915	P08191915	TOUCH-UP PAINT, GRIZZLY GREEN
1916	P08191916	TOUCH-UP PAINT, GRIZZLY PUTTY
1917	P08191917	STOP REMOVE BELTS HANG TAG
1918	P08191918	STOP INSTALL SANDPAPER HANG TAG

## 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](http://www.grizzly.com).



# WARRANTY & RETURNS

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

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

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

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

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

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

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



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