MODEL G0449/G0450
37" DRUM SANDER
OWNER'S MANUAL
(For models manufactured since 06/25)

C US
177335

#TREWPCBL7210 PRINTED IN TAIWAN V5.08.25

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

Machine Differences

Models G0449 and G0450 are heavy-duty drum sanders with the following differences:

— **Model G0449** is a 37" Single-Phase, 10 HP drum sander.

— **Model G0450** is a 37" 3-Phase, 15 HP drum sander.

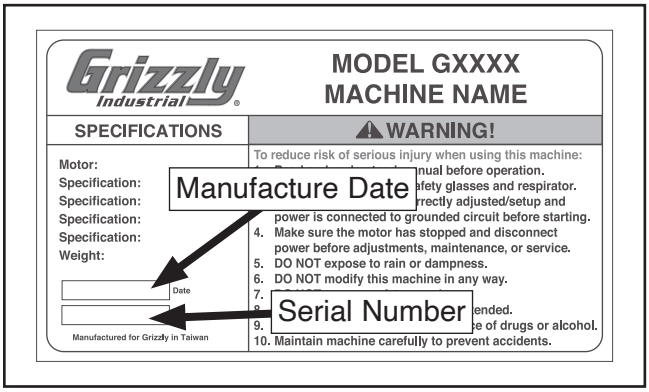
Manual Accuracy

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

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

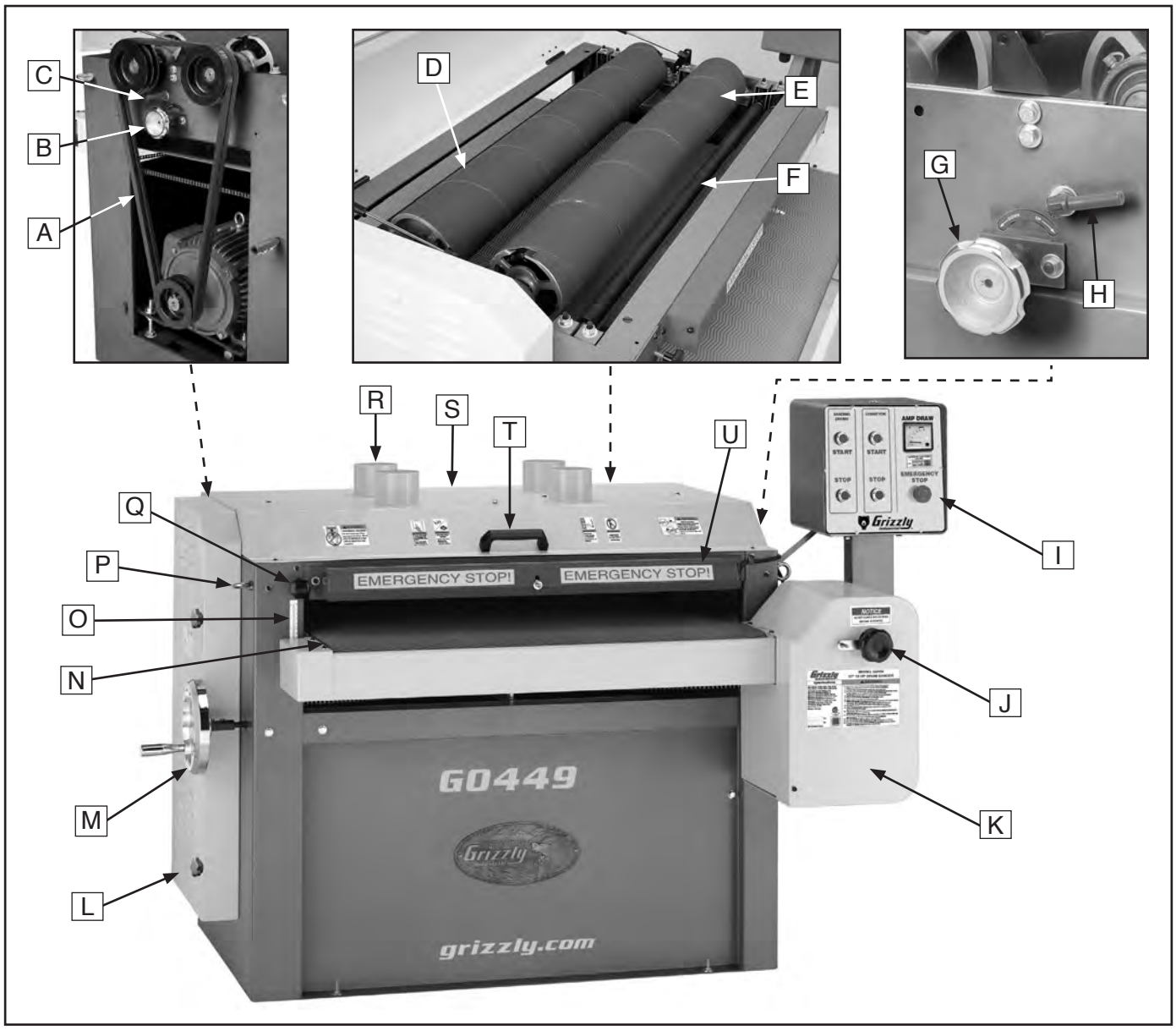
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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



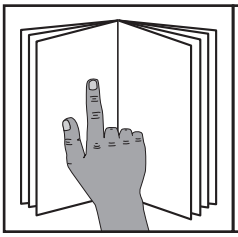
Identification

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



A. V-Belts
B. Micro-Adjust Knob (Left Side)
C. Micro-Adjust Lock Bolt (Left Side)
D. Rear Drum
E. Front Drum
F. Pressure Roller (1 of 2)
G. Micro-Adjust Knob (Right Side)
H. Micro-Adjust Lock Lever (Right Side)
I. Control Panel
J. Conveyor Speed Control
K. Conveyor Motor and Pulley Cover
L. Sanding Motor and Pulley Cover
M. Conveyor Table Height Handwheel
N. Conveyor
O. Depth-of-Cut Scale
P. Lifting Eye
Q. Table Height Lock Knob
R. 4" Dust Port (1 of 4)
S. Top Cover
T. Top Cover Handle
U. Emergency Stop Bar

Controls & Components



⚠WARNING

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

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

Control Panel

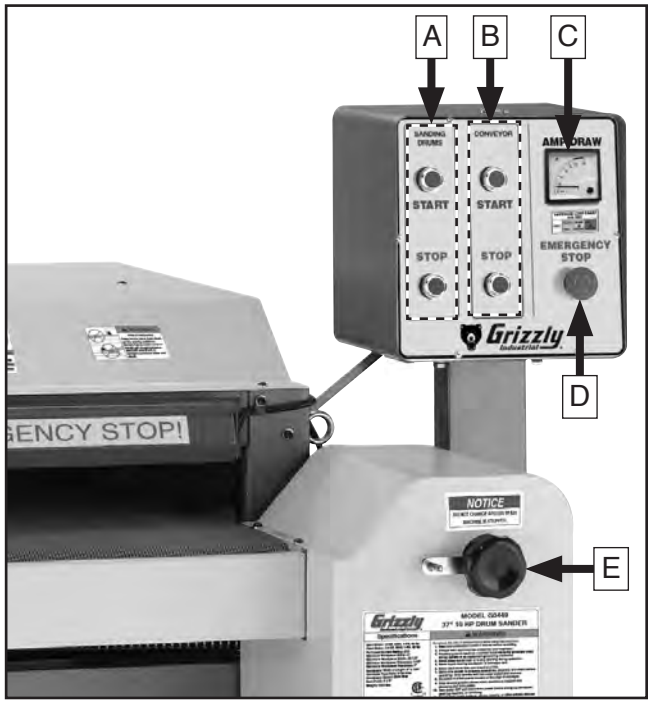


Figure 1. Control panel.

A. SANDING DRUMS START/STOP Buttons: Turn sanding drum motor ***ON*** and ***OFF***.

B. CONVEYOR START/STOP Buttons: Turn conveyor motor ***ON*** and ***OFF***.

C. AMP DRAW Meter: Displays combined amperage draw of sanding drum and conveyor motors.

D. EMERGENCY STOP Button: Stops motors when pressed and disables ON buttons. Remains in depressed position until manually reset. Reset by twisting button clockwise until it springs outward.

E. Conveyor Speed Control: Rotates to adjust conveyor belt speed between 8–20 FPM.

Conveyor Table Height Controls

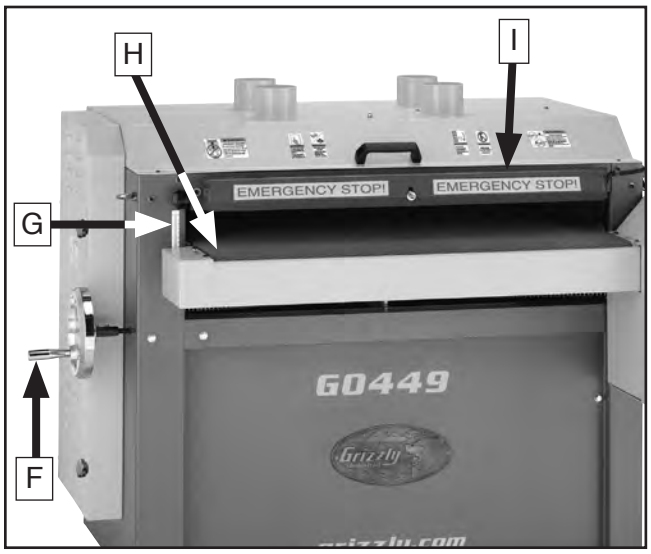


Figure 2. Conveyor table height controls.

F. Conveyor Table Height Handwheel: Rotates *counterclockwise* to raise or *clockwise* to lower conveyor table according to workpiece thickness. One full turn of the handwheel changes the height of the table 0.020".

G. Depth-of-Cut Scale: Indicates distance between conveyor table and sanding drums.

H. Conveyor Table w/Belt: Feeds workpiece toward sanding drums.

I. EMERGENCY STOP Bar: Stops motors when pressed. ON buttons remain enabled after bar is depressed.

Sanding Drums

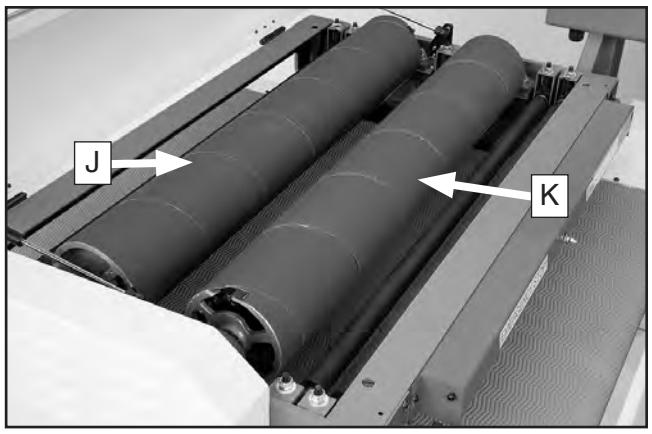


Figure 3. Sanding drums.

J. Rear Sanding Drum: Rotates against incoming workpiece, using finer sandpaper to create smooth finish.

K. Front Sanding Drum: Rotates against incoming workpiece, using coarser sandpaper to prepare surface for finish sanding.

Micro-Adjustment Controls

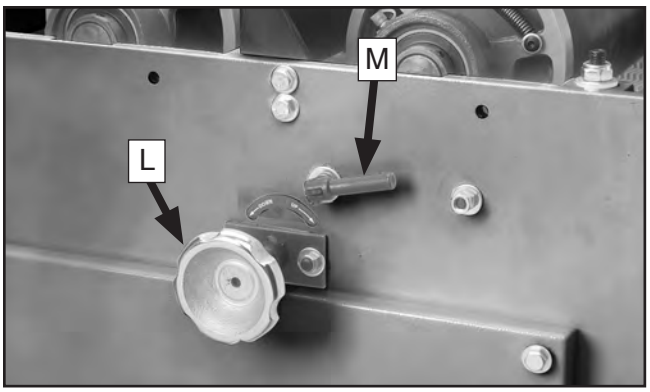


Figure 4. Micro-adjustment controls.

L. Micro-Adjustment Knob (1 of 2): Rotates to make fine height adjustments of outfeed (rear) sanding drum.

M. Micro-Adjustment Lock Lever (1 of 2): Rotates *clockwise* to lock micro-adjustment knob in place, *counterclockwise* to unlock.

MACHINE DATA SHEET

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

MODEL G0449 37" 10 HP DRUM SANDER

Product Dimensions:

Weight..... 1213 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 68 x 50-1/2 x 49 in.
Footprint (Length x Width)..... 45-1/2 x 28-1/2 in.

Shipping Dimensions:

Type..... Wood Slat Crate
Content..... Machine
Weight..... 1383 lbs.
Length x Width x Height..... 55 x 60 x 45 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 240V, Single-Phase, 60 Hz
Full-Load Current Rating..... 47A
Minimum Circuit Size..... 60A
Connection Type..... Permanent Hardwire
Switch Type..... Control Panel w/Magnetic Switch Protection

Motors:

Main

Horsepower..... 10 HP
Phase..... Single-Phase
Amps..... 44.5A
Speed..... 1725 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer ..... Dual Belt Drive
Bearings..... Sealed & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Feed

Horsepower..... 1/3 HP
Phase..... Single-Phase
Amps..... 2.5A
Speed..... 1175 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer ..... Chain Drive
Bearings..... Sealed & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Operation Information

Number of Sanding Heads	2
Maximum Board Width	36-1/2 in.
Minimum Board Width	2 in.
Maximum Board Thickness	4 in.
Minimum Board Thickness	1/16 in.
Minimum Board Length	9 in.
Sandpaper Speed	2800 FPM
Conveyor Feed Rate	8 – 20 FPM
Sandpaper Length	138 in.
Sandpaper Width	6 in.

Drum Information

Infeed Sanding Drum Type	Steel/Rubber
Infeed Sanding Drum Size	6 in.
Outfeed Sanding Drum Type	Rubber
Outfeed Sanding Drum Size	6 in

Construction

Conveyor Belt	Rubber
Body	Steel
Paint Type/Finish	Powder Coated

Other Related Information

Floor To Table Height	29 - 33 in.
Sanding Belt Tension	Spring Loaded
Number of Pressure Rollers	5
Pressure Roller Type	Rubber
Pressure Roller Size	1-17/32 in.
Conveyor Belt Length	90-1/2 in.
Conveyor Belt Width	36-1/2 in.
Belt Roller Size	2.67 in.
Number of Dust Ports	4
Dust Port Size	4 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label on Control Box
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features:

Spring-Loaded Sanding Belt Tension/Sandpaper
Industrial-Duty Rubber Conveyor Belt
Four 4" Dust Ports
Variable Speed Conveyor
Twin V-Belt Main Motor; V-Belt Feed Motor
6" Steel/Rubber Sanding Drums
Green and Putty Powder Coated Paint
Easy Access Control Panel with Load Meter
Advanced Dust Collection
Hinged Hood with Gas Struts for Easy Drum Access
State of the Art Computer Balanced Drums
0.020" Table Lift with 360 degree Handwheel Turn

MACHINE DATA SHEET

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

MODEL G0450 37" 15 HP 3-PHASE DRUM SANDER

Product Dimensions:

Weight..... 1204 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 68 x 50-1/2 x 49 in.
Footprint (Length x Width)..... 45-1/8 x 28-1/2 in.

Shipping Dimensions:

Type..... Wood Slat Crate
Content..... Machine
Weight..... 1374 lbs.
Length x Width x Height..... 55 x 60 x 45 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 240V or 480V, 3-Phase, 60 Hz
Prewired Voltage..... 240V
Full-Load Current Rating..... 43A at 240V, 21.5A at 480V
Minimum Circuit Size..... 60A at 240V, 30A at 480V
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Switch Type..... On/Off Emergency Stop
Voltage Conversion Kit..... P0450753 for 440V
Recommended Phase Converter..... H3741

Motors:

Main

Horsepower..... 15 HP
Phase..... 3-Phase
Amps..... 41.3A/20.65A
Speed..... 1725 RPM
Type..... TEFC Induction
Power Transfer ..... Twin V-Belt Drive
Bearings..... Sealed & Permanently Lubricated
Centrifugal Switch/Contacts Type..... N/A

Feed

Horsepower..... 1/3 HP
Phase..... 3-Phase
Amps..... 1.64A/0.82A
Speed..... 1175 RPM
Type..... TEFC Induction
Power Transfer ..... Belt and Chain Drive
Bearings..... Sealed & Permanently Lubricated
Centrifugal Switch/Contacts Type..... N/A

Main Specifications:

Operation Information

Number of Sanding Heads	2
Maximum Board Width	36-1/2 in.
Minimum Board Width	2 in.
Maximum Board Thickness	4 in.
Minimum Board Thickness	1/16 in.
Minimum Board Length	9 in.
Sandpaper Speed	2800 FPM
Conveyor Feed Rate	8 – 20 FPM
Sandpaper Length	138 in.
Sandpaper Width	6 in.

Drum Information

Infeed Sanding Drum Type	Steel/Rubber
Infeed Sanding Drum Size	6 in.
Outfeed Sanding Drum Type	Rubber
Outfeed Sanding Drum Size	6 in.

Construction

Conveyor Belt	Rubber
Body	Steel
Paint Type/Finish	Powder Coated

Other Related Information

Floor To Table Height	29 - 33 in.
Sanding Belt Tension	Spring Loaded
Number of Pressure Rollers	5
Pressure Roller Type	Rubber
Pressure Roller Size	1-17/32 in.
Conveyor Belt Length	90-1/2 in.
Conveyor Belt Width	36-1/2 in.
Belt Roller Size	2.67 in.
Number of Dust Ports	4
Dust Port Size	4 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label on Control Box
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features:

Spring-Loaded Sanding Belt Tension/Sandpaper
Industrial-Duty Rubber Conveyor Belt
Four 4" Dust Ports
Variable Speed Conveyor
Twin V-Belt Main Motor; V-Belt Feed Motor
6" Steel/Rubber Sanding Drums
Green and Putty Powder Coated Paint
Easy Access Control Panel with Load Meter
Advanced Dust Collection
Hinged Hood with Gas Struts for Easy Drum Access
State of the Art Computer Balanced Drums
0.020" Table Lift with 360 degree Handwheel Turn

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Drum 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 serious 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.

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.

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.

WORKPIECE MATERIAL. This sander is designed to sand only natural wood products or man-made products made from natural wood fiber. DO NOT sand any metal products.

WORKPIECE INSPECTION. Nails, staples, knots, or other imperfections in workpiece can be dislodged and thrown from sander at high rate of speed into operator or bystanders, or cause damage to sandpaper or sander. Never try to sand stock that has embedded foreign objects or questionable imperfections.

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**.

⚠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.

⚠WARNING

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

G0449
Full-Load Current Rating at 240V ..... 47 Amps

G0450
Full-Load Current Rating at 240V ..... 43 Amps
Full-Load Current Rating at 480V ...21.5 Amps

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

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

Circuit Information

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

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

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

G0449 240V Circuit Requirements

This machine is prewired to operate on a 240V power supply circuit that has a verified ground and meets the following requirements:

Acceptable Voltage Range 216V–264V
Cycle .....60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 60 Amps
Connection Type .....Hardwired

G0450 240V Circuit Requirements

This machine is prewired to operate on a 240V power supply circuit that has a verified ground and meets the following requirements:

Acceptable Voltage Range 216V–264V
Cycle .....60 Hz
Phase 3-Phase
Power Supply Circuit ..... 60 Amps
Connection Type .....Hardwired

Circuit Requirements for 480V

This machine can be converted to operate on a 480V power supply (refer to Voltage Conversion instructions) that has a verified ground and meets the following requirements:

Acceptable Voltage Range 432V–528V
Cycle ..... 60 Hz
Phase 3-Phase
Power Supply Circuit ..... 30 Amps
Connection Type ..... Hardwired

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.

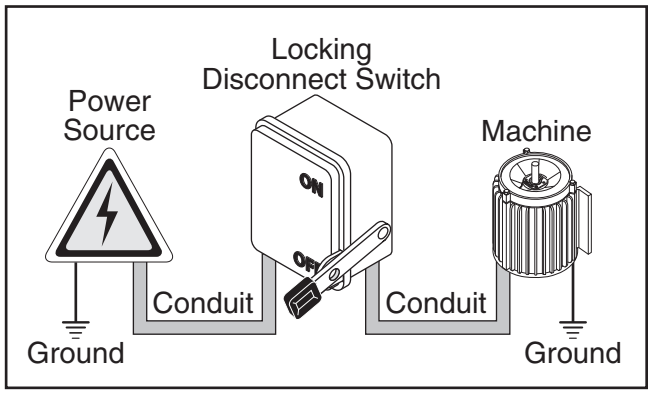


Figure 5. Typical setup of a permanently connected machine.

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.

480V Conversion

The Model G0450 can be converted for 480V operation. This conversion job consists of disconnecting the sander from the power source, replacing the existing control box 240V main panel with a 480V main panel and rewiring the sanding motor and feed motor.

The G0450 480V Conversion Kit (Part Number P0450753), which includes the necessary 480V main panel, can be purchased by calling Grizzly Customer Service at (800) 523-4777.

All wiring changes must be performed by an electrician or qualified service personnel. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

To convert Model G0450 for 480V operation:

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

2. Rewire both sanding drum and feed motors according to diagrams on inside of junction box covers.

   Note: *These drawings are also shown on* ***Pages 69–71*** *for your reference, but always use drawings in junction box cover, as they will reflect any changes to machine since this manual was printed.*

3. Remove control panel cover.

4. Keeping track of wire locations, disconnect all power and motor wires, so main panel can be completely removed (main panel is board that all electrical components are mounted to).

5. Remove (4) cap screws (one in each corner) that secure the 240V main panel and replace it with main panel from 480V conversion kit (see **Figure 6**).

6. Connect power and motor wires to 480V main panel in same manner they were removed from 240V main panel (see **Figure 6**).

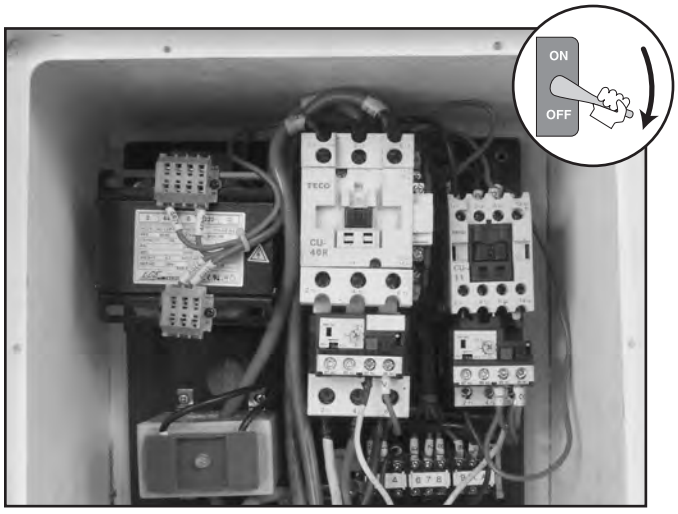


Figure 6. G0450 480V control box main panel.

7. Make sure thermal overload relays are set to following values for 480V (see **Figure 7**.)

   — Feed Motor Relay = 0.8A
   — Sanding Motor Relay = 20.7A

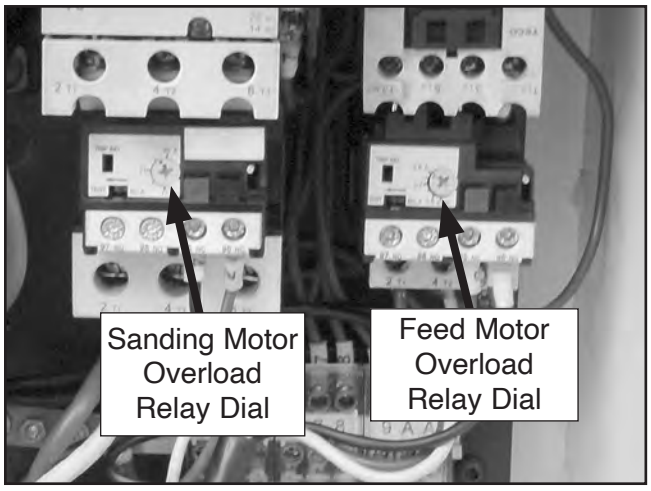
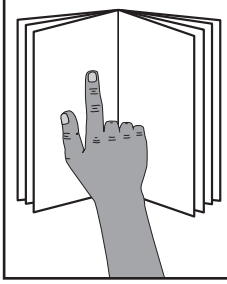


Figure 7. Location of 480V thermal overload relay dials.

8. Replace control panel cover.

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 are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Additional Person	1
• Safety Glasses (For Each Person)	1
• Forklift	1
• Lifting Straps w/Safety Hooks (min. 2000 lb capacity)	2
• Power Cord (length as needed)	1
• Power Disconnect Box	1
• Dust Collection System	1
• Dust Hoses 4"	4
• Hose Clamps 4"	4
• Phillips Head Screwdriver #2	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

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.

Wood Crate (**Figure 8**) **Qty**

A. Drum Sander 1
B. Control Panel 1
C. Handwheel 1
D. Top Cover 1

Boxed Inventory (Not Shown)

—Hex Wrenches 4, 5mm ..... 1 Ea
—Wrench 12/14 1
—Phillips Head Screwdriver 1
—Knob Bolts M6-1 x 12 2
—Tension Tools 2
—Sandpaper Clips 2
—Rubber Plates (Dust Scoops) 2

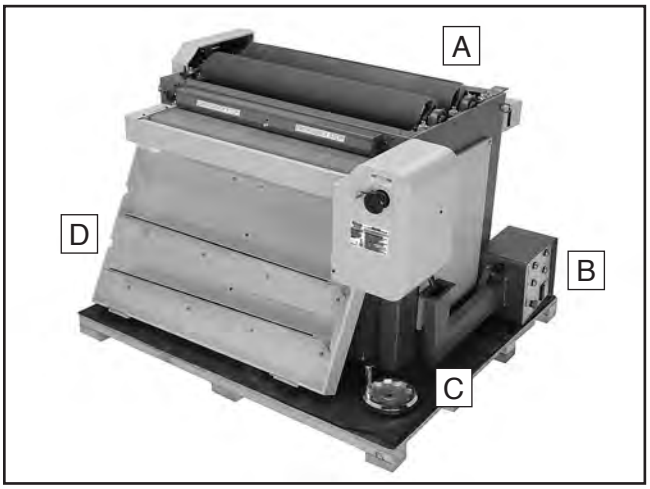


Figure 8. G0449/G0450 inventory.

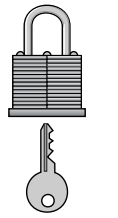
Site Considerations

Weight Load

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

Space Allocation

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



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

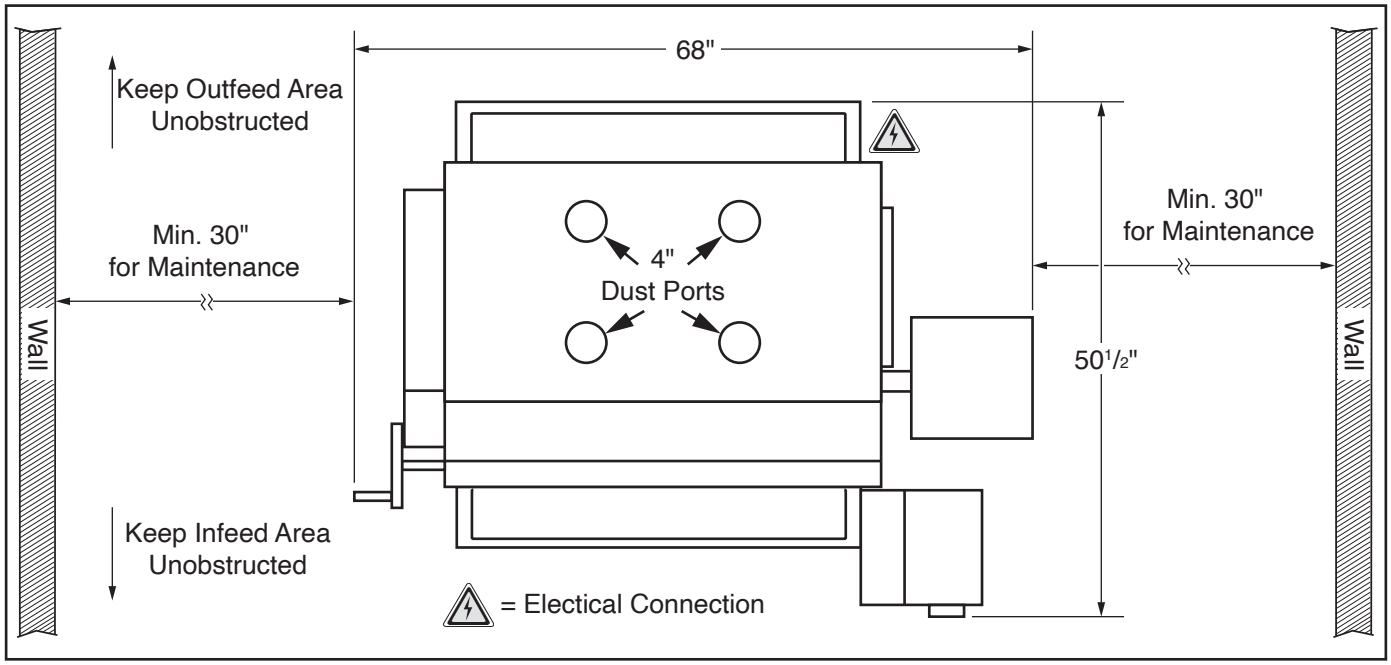
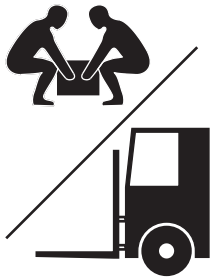


Figure 9. Minimum working clearances.

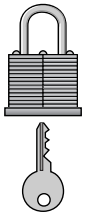
Lifting & Placing



⚠WARNING

HEAVY LIFT!

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



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Do not attempt to lift or move this machine without using the proper lifting equipment (such as forklift or crane). Each piece of lifting equipment must be rated for at least 2000 lbs. to support dynamic loads that may be applied while lifting. Refer to **Needed for Setup** on **Page 16** for complete list of needed equipment for setup and installation.

To lift and place machine:

1. Move machine near its prepared location while still inside shipping crate.

2. Remove top and sides of shipping crate, then place small items aside in safe location.

3. Unbolt machine from pallet.

4. Position forklift forks directly above sander. Place two lifting straps with hooks over the forklift forks and insert hooks into lifting eyes (see **Figure 10**).

Figure 10. Example of lifting sander.

5. Lift sander and move it to prepared location. DO NOT lift it any higher than is necessary to clear pallet.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 3/8"

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.

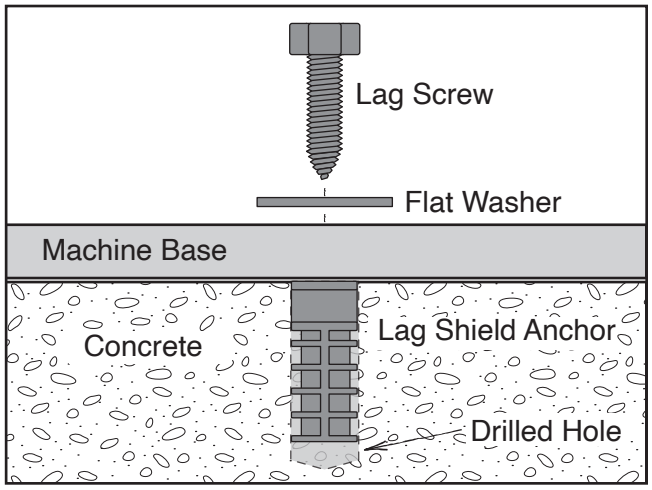


Figure 11. Popular method for anchoring machinery to a concrete floor.

Assembly

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

To assemble machine:

1. Remove (6) pre-installed button head cap screws from top cover (see **Figure 12**).

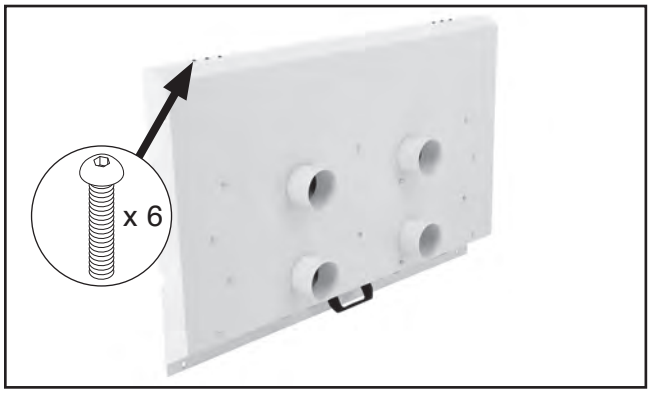


Figure 12. Location of hinge fasteners.

2. Place top cover on sander, align hinges (see **Figure 13**) with holes in cover, then secure with screws removed in **Step 1**.

Note: *To close top cover fully, tuck gas struts under cover.*

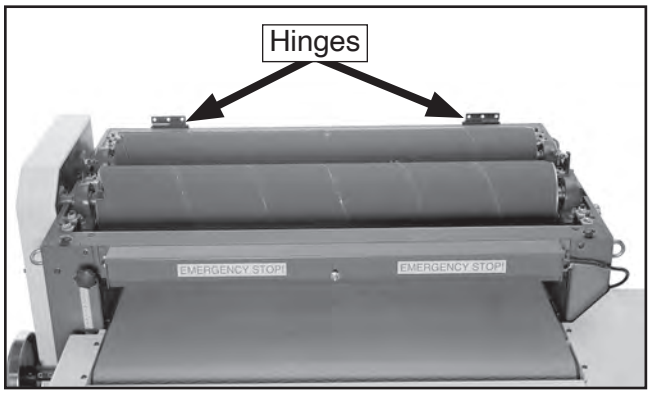


Figure 13. Location of hinges.

3. Hold top cover open and attach each gas strut to bracket and secure with jam nut, as shown in **Figure 14**.

Note: *Thread each pivot screw until bottom of screw is flush with outside of bracket.*

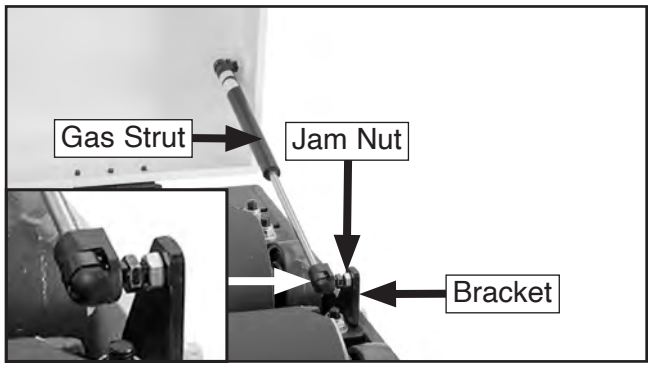


Figure 14. Gas strut installed (right side shown).

4. Remove (2) knob bolts and flat washers, then open sanding motor cover, shown in **Figure 15**.

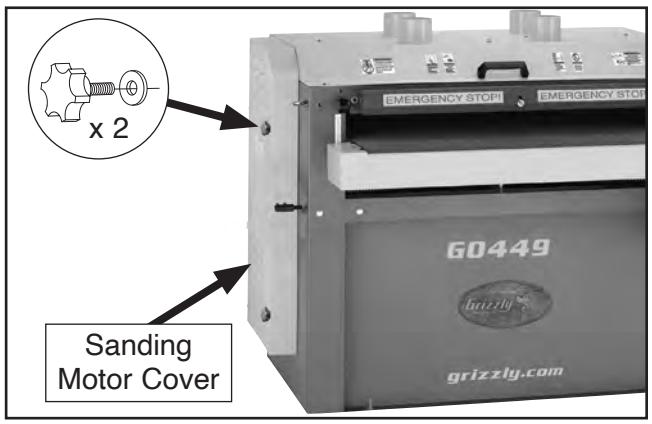


Figure 15. Location of sanding motor cover and knob bolts.

5. Pull V-belts down to rotate sanding drums, and listen for any scraping sounds.

   — If sanding drum(s) scrape plastic dust scoop or metal dust scoop plates on top cover, refer to **Adjusting Dust Scoops** on **Page 54** for adjustment instructions.

   — If sanding drum(s) do not scrape dust scoops, proceed to **Step 6**.

6. Close sanding motor cover and secure with knob bolts and flat washers removed in **Step 4**, then secure top cover with (2) M6-1 x 12 knob bolts.

7. Remove hex bolts, flat washers, and hex nuts from control panel support arm, as shown in **Figure 16**.

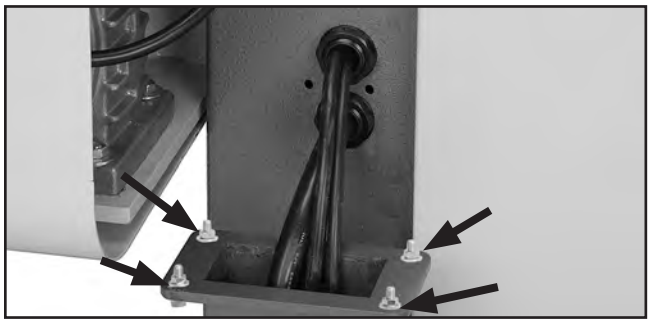


Figure 16. Location of control panel fasteners.

8. Remove right access panel to gain access for attaching control panel support arm.

9. With help of assistant, lift control panel into place and secure with hex bolts, flat washers, and hex nuts removed in **Step 8**.

10. Attach control panel brace to sander, (see **Figure 17**), then install right access panel.

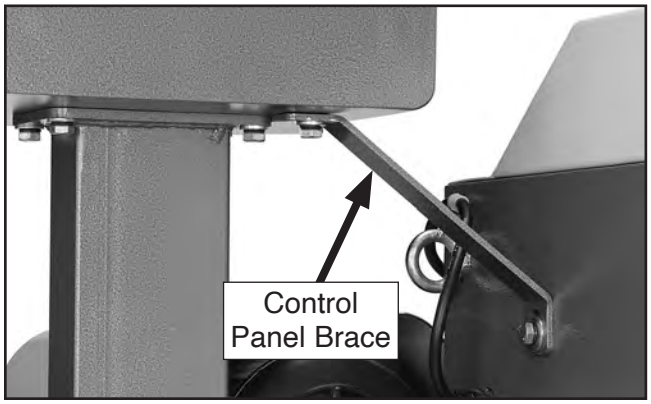


Figure 17. Location of control panel brace.

11. Place handwheel over shaft (see **Figure 18**) and tighten set screw in handwheel hub.

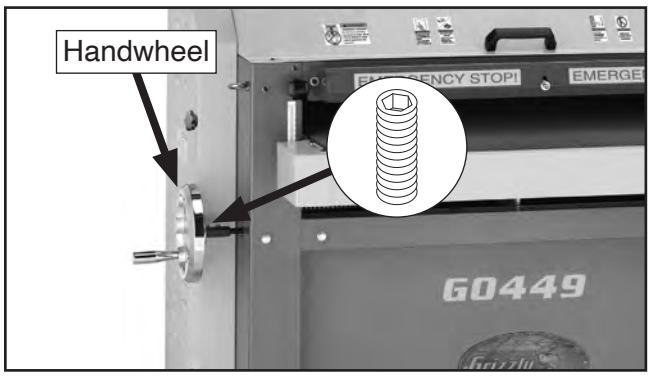


Figure 18. Handwheel installed.

Dust Collection

⚠CAUTION

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

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

To connect dust collection system to machine:

1. Fit (4) 4" dust hoses over dust ports (see **Figure 19**), and secure in place with hose clamps.

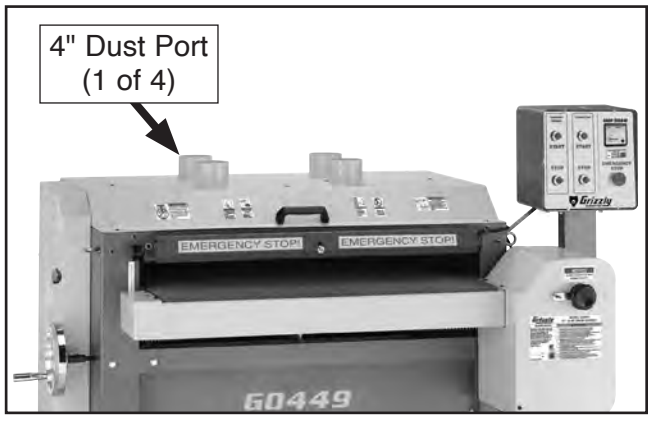


Figure 19. Location of dust ports.

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

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

Power Connection

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

⚠WARNING

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

Phase Converters (G0450 Only)

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

You can find the Model H3741, a compatible phase converter on our website at **www.grizzly.com.**

H3741—30 HP Rotary Phase Converter
This rotary phase converter allows you to operate 3-phase machinery from a single-phase power source at 100% power and 95% efficiency.

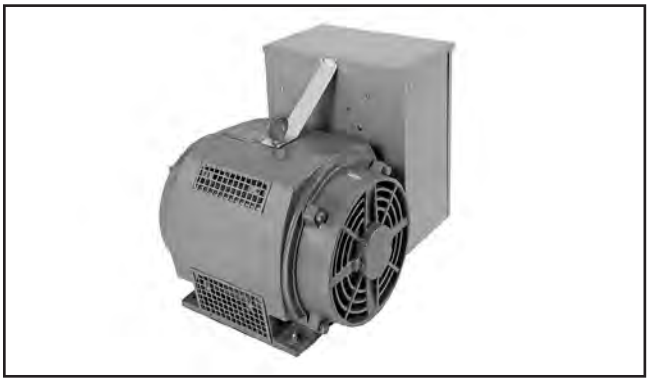


Figure 20. H3741 30 HP Rotary Phase Converter.

Connecting Incoming Power Wires

⚠WARNING

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

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

2. Remove cover from power connection junction box on rear of frame (see **Figure 21**).

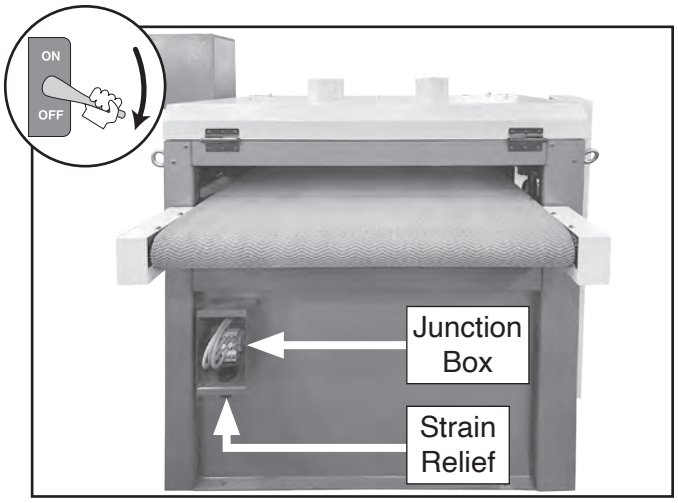


Figure 21. Location of power connection junction box.

⚠WARNING

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

2. Feed power wires through strain relief on bottom of junction box, connect cord to terminals, (see **Figures 22–23**), then tighten strain relief.

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

   IMPORTANT (**Model G0450 Only**)**:** When using a phase converter, connect manufactured power leg or "wild wire" to L2 terminal (**Figure 23**). L2 terminal can handle power fluctuation because it is wired directly to motor. Other wires connect to controls and must have consistent power to prevent damage.

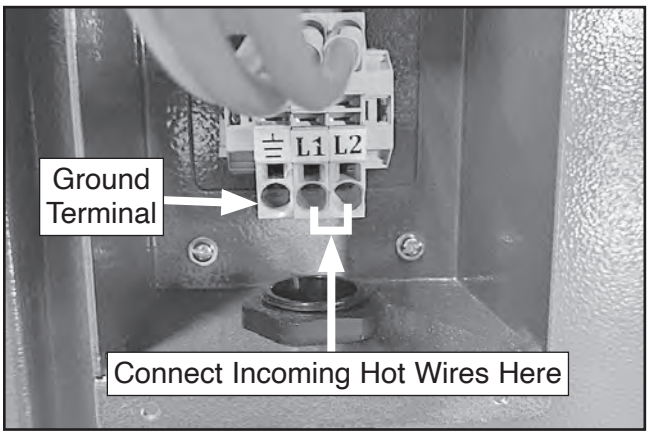


Figure 22. G0449 junction box wiring.

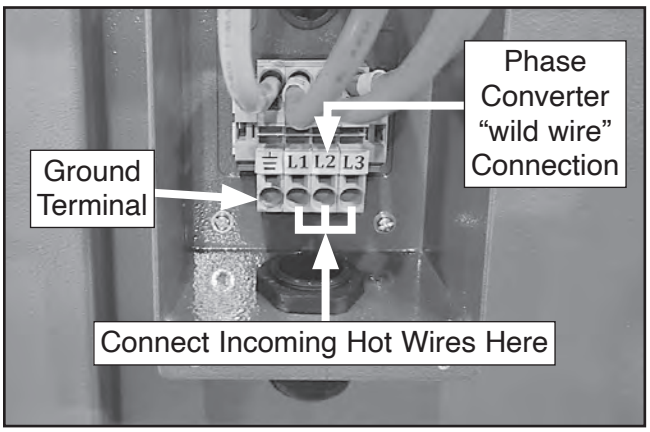


Figure 23. G0450 junction box wiring.

3. Install junction box cover.

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.

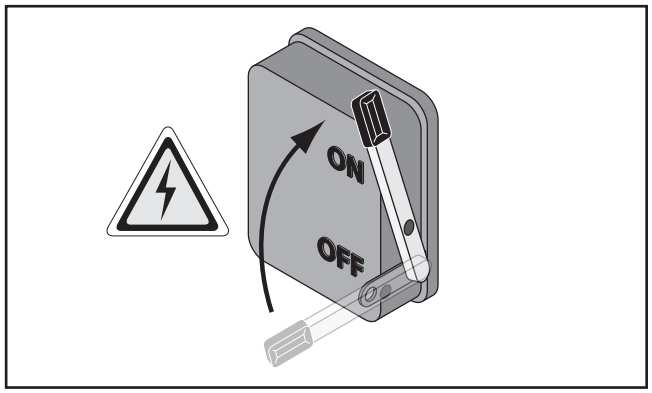


Figure 24. Connecting power to machine.

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.*

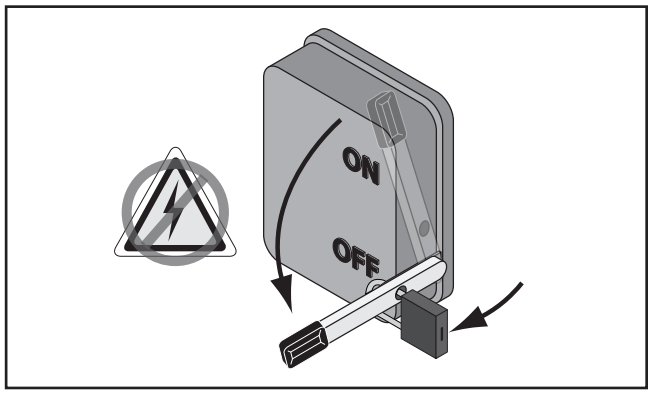


Figure 25. Disconnecting power from machine.

Correcting Phase Polarity (G0450 Only)

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

To correct phase polarity:

1. DISCONNECT MACHINE FROM POWER!

2. Open junction box and swap incoming wires connected to **L1** and **L3** terminals (see **Figure 26**).

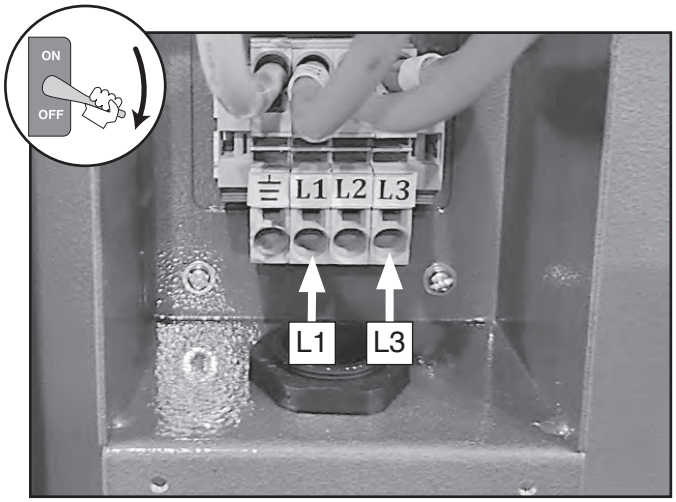


Figure 26. Location of L1 and L3 terminals.

3. Close and secure junction box.

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

Checking Speed Reducer Oil

Before starting your machine for the first time, check the speed reducer oil level. The proper oil level is achieved when the sight glass shows half full. See **Speed Reducer** on **Page 40** for more information. DO NOT mix oil types.

To check speed reducer oil:

1. Remove conveyor motor cover and check sight glass on back of speed reducer (see **Figure 27**) to check oil level.

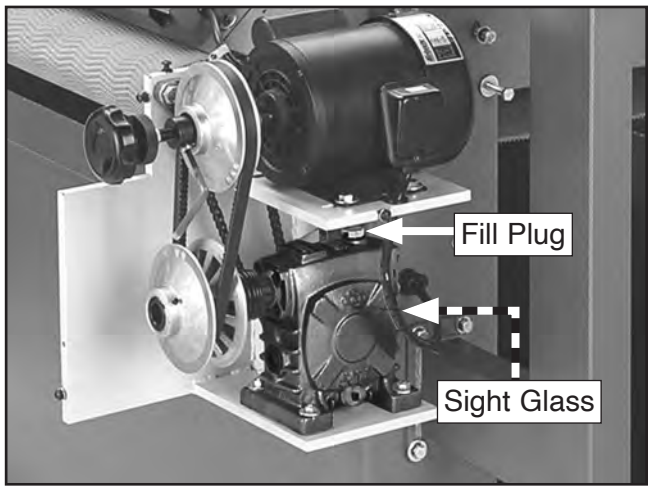


Figure 27. Location of speed reducer sight glass and fill plug.

   — If oil level is low, remove fill plug and add oil until sight glass is half full. Refer to **Speed Reducer** on **Page 40** for oil type information.

NOTICE

Change speed reducer gear oil after first 100 hours of operation (see Page 40).

Test Run

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

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

⚠WARNING

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

⚠WARNING

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

The test run consists of verifying the following: 1) The motors power up and run correctly, 2) the motors turn the correct direction (G0450 only), 3) the EMERGENCY STOP button safety feature works correctly, and 4) the EMERGENCY STOP bar safety feature works correctly.

To test run machine:

1. Clear all setup tools away from machine.

2. Press Emergency Stop button in.

3. Connect machine to power by turning main power ***ON*** at power source.

4. Twist EMERGENCY STOP button clockwise until it springs out (see **Figure 28**). This resets switch so machine can start.

Figure 28. Resetting the switch.

5. Press conveyor START button to turn conveyor ***ON***. Conveyor should run smoothly without any unusual problems or noises.

   IMPORTANT (Model G0450 Only): Verify conveyor belt on top of table is moving toward rear of machine. If conveyor is running backwards, incoming power is wired out of phase. DISCONNECT MACHINE FROM POWER!, then refer to **Correcting Phase Polarity** on **Page 24** to correct wiring before continuing test run.

6. Press sanding drum START button to turn sanding drum motor ***ON***. Sanding drums should run smoothly without any unusual problems or noises.

7. Press EMERGENCY STOP button to turn machine ***OFF***.

8. WITHOUT resetting EMERGENCY STOP button, press each START button. The machine should not start.

   — If machine *does not* start, EMERGENCY STOP button safety feature is working correctly. Proceed to **Step 9**.

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

9. Reset EMERGENCY STOP button. Press conveyor START and sanding drum START buttons to turn machine ***ON***.

10. Press EMERGENCY STOP bar to immediately turn machine ***OFF***.

    — If machine does not turn ***OFF***, immediately turn it ***OFF*** with control panel and disconnect power. The safety feature of the EMERGENCY STOP bar is NOT working properly and must be replaced before further using the machine. Call Tech Support for help.

    IMPORTANT: Stop bar should only be used during emergencies. EMERGENCY STOP bar switch will wear quicker if this feature is used for regular shut down.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping, some of these adjustments may need to be repeated to ensure optimum results. Keep this in mind as you start to use your new drum sander.

Factory adjustments that should be verified:

Tensioning V-Belts

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belts will stretch and seat into the pulley grooves. After this time, you must re-tension the belts to avoid slippage and burn out. Refer to **Page 44** when you are ready to perform this important adjustment.

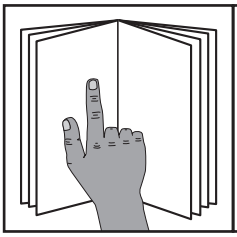
Note: *A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate a problem with the machine or belt.*

⚠CAUTION

Pulleys and belts can get hot. Allow them to cool before making adjustments.

SECTION 4: OPERATIONS

Operation Overview

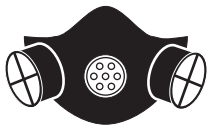


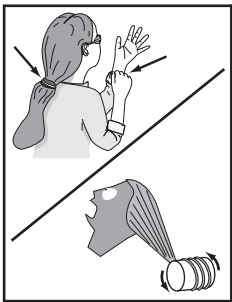
⚠WARNING

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

⚠WARNING

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





⚠WARNING

Keep hair, clothing, and jewelry away from moving parts at all times. Entanglement can result in death, amputation, or severe crushing injuries!

NOTICE

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

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

1. Examines workpiece to verify it is suitable for sanding and determines which sandpaper grit size to use.

2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is overly long and difficult to handle, operator uses a roller support stand or an assistant to assist with feeding.

3. Adjusts conveyor table height to approximate workpiece thickness.

   Note: *During initial pass with a new workpiece, operator adjusts conveyor table height as necessary so workpiece only makes light contact with sanding belt and does not overload sander.*

4. Puts on safety glasses, respirator, and any other required protective equipment.

5. Starts dust-collection system, then drum sander. Waits for sanding drums to reach full speed and sets conveyor speed for the specific type and finish of workpiece.

6. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.

7. Receives workpiece from outfeed side of conveyor table.

8. Raises height of conveyor table a small amount (typically ¼ of a full rotation of handwheel), then repeats the feeding process of workpiece through sander.

9. Changes sandpaper to a finer grit, as needed.

10. Repeats **Steps 6–9** as needed, turns sander and dust collection system ***OFF,*** and disconnects sander from power.

Stock Inspection & Requirements

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 glass, stone, tile, plastics, drywall, cementitious backer board, metal, etc.

  Sanding metal objects can increase the risk of fire. 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 may be greatly reduced (or immediately damaged) from sanding improper materials.

- ***Foreign Objects:*** Tramp metal, nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear the sandpaper. 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 sandpaper, 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!

- ***Excessive Glue or Finish:*** Sanding workpieces with excess glue or finish will load up the abrasive, reducing its usefulness and lifespan.

- ***Minimum Stock Dimensions:*** DO NOT sand boards less than 9" long, 2" wide, and 1/16" thick to prevent damage to the workpiece and to reduce the risk of your hands contacting the sandpaper (see **Figure 29**).

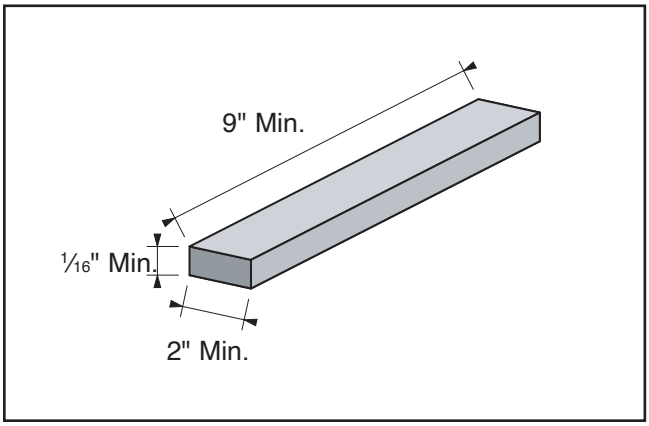


Figure 29. Minimum dimensions for sanding.

Setting Depth of Cut

The optimum depth of cut will vary based on the type of wood, feed rate, and sandpaper grit. Under most sanding conditions, the depth should not exceed 1/64" (approx. 3/4 turn of the handwheel). Each full turn of the table height handwheel raises the conveyor table approximately 0.020". Attempts to remove too much material can cause jamming, wood burning, rapid paper wear or tearing, poor finish and belt slippage.

To set depth of cut:

1. Rotate conveyor table height handwheel, shown in **Figure 30**, until conveyor table is well below sanding drum, then raise conveyor table, allowing a gap between workpiece and sanding drum.

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

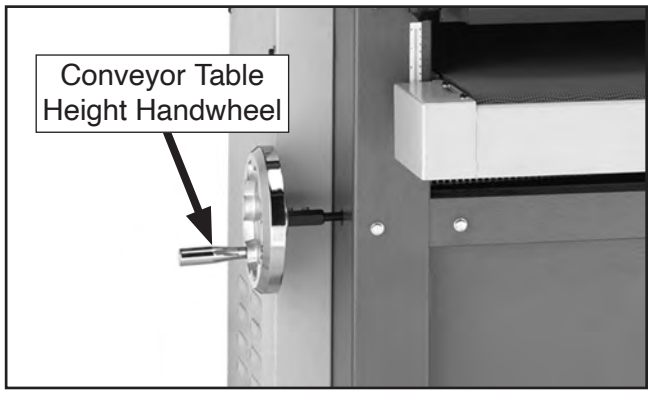


Figure 30. Conveyor table height handwheel.

2. Turn sanding drums and conveyor ***ON***, then feed workpiece into sander. SLOWLY raise conveyor until workpiece makes light contact with sanding drums. This is the correct height to begin sanding workpiece.

3. After initial pass, rotate handwheel 3/4 turn (1/64" or 0.4mm) or less; the maximum depth for most sanding conditions.

   Note: *Each full rotation of conveyor elevation handwheel raises conveyor table approximately 0.020" or 0.5mm.*

Setting Conveyor Speed

The variable speed knob allows you to increase the feed rate from 6–18 FPM. The correct speed to use depends on the type of stock you are using (hardwood vs. softwood) and the stage of finish you are at with that workpiece.

As a general rule, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove material faster, but runs the risk of overloading the motor. Use trial-and-error to determine the best settings for your specific applications.

To set conveyor speed:

1. Start conveyor (DO NOT adjust conveyor speed when conveyor motor is ***OFF***).

NOTICE

Adjusting variable speed when conveyor motor is *OFF* can damage V-belt and adjusting mechanism.

2. Rotate knurled collar *clockwise* to release variable speed knob (see **Figure 31**), then rotate knob *counterclockwise* to increase feed speed or *clockwise* to decrease feed speed.

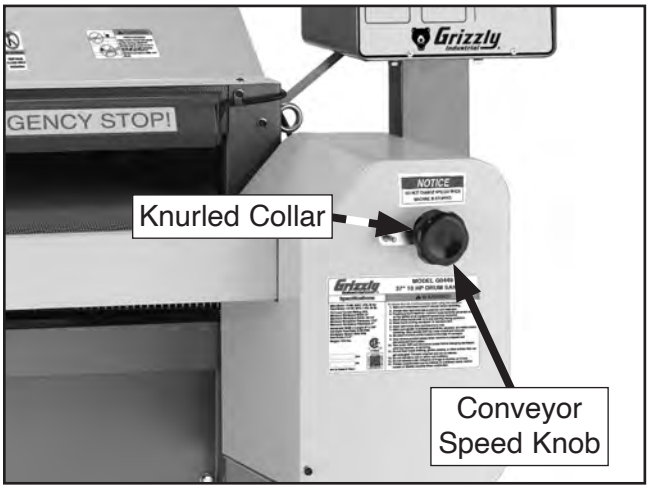


Figure 31. Variable speed knob.

Monitoring Sanding Load

The AMP DRAW meter (see **Figure 32**) displays the combined amperage draw of the sanding drum and conveyor motors. The needle moves to the right when you increase the load on the machine, and to the left when you decrease the load. Use this meter to avoid overloading your machine with too heavy of a cut.

Figure 32. Location of AMP DRAW meter.

The type of stock used will affect the amperage load on the machine. Use trial-and-error to determine the best settings for your applications. As a general rule, always start with a small load and work your way up. We recommend that you do not push your machine to its maximum load; instead, make multiple passes or install a coarser grit paper.

NOTICE

Overloading motor or pushing sander to failure weakens electrical system. Repeatedly doing so is abuse to machine that will cause motor, capacitor, or circuit breaker damage, which is not covered under warranty.

Sanding Tips

- DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury. Edge sanding boards also can cause damage to the conveyor belt and sandpaper.
- DO NOT sand more than one board at a time side by side. Minor variations in thickness can cause one board to be propelled by the rapidly spinning sanding drum and ejected from the machine.
- NEVER stand directly in front of the infeed area of the machine. Failure to do so could result in severe personal injury.
- DO NOT sand boards less than 9" long, 2" wide, and 1/16" thick to prevent damage to the workpiece and to reduce the risk of your hands contacting the sandpaper.
- Sanding workpieces with high-resin content or with applied finishes can quickly contaminate sandpaper beyond the point where it can be properly cleaned. This will produce poor sanding results. In this case, use a different workpiece, remove the applied finishes, or frequently clean/replace the sandpaper strip.
- Replace coarse grit sandpaper with a finer grit to achieve a smoother finish.
- Raise the conveyor table a maximum of ¼ turn of the handwheel until the workpiece is the desired thickness.
- Reduce snipe when sanding more than one board of the same thickness by feeding them into the sander with the front end of the second board touching the back end of the first board.
- Feed boards into the sander at different places on the conveyor to maximize sandpaper life and prevent uneven conveyor belt wear.
- Extend the life of the sandpaper by regularly using a PRO-STIK® sanding pad (see **Page 35**).

- Run wide stock through two or three times without adjusting table height. Turn stock 180° between passes to ensure an evenly sanded surface.

- When sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When the drum moves from sanding a wide surface to sanding a narrow surface, the load on the motor will be reduced, and the drum will speed up, causing a gouge.

- When sanding workpieces with a bow or crown, place the high point up or cupped side down to prevent the workpiece from rocking and take very light passes.

- Feed the workpiece at an angle to maximize stock removal and sandpaper effectiveness, but feed the workpiece straight to reduce sandpaper grit scratches for the finish passes.

⚠WARNING

DO NOT sand more than one board at a time. Minor variations in thickness can cause one board to be propelled by the rapidly spinning sanding drum and ejected from the machine. NEVER stand directly in front of the infeed area of the machine. Doing so could result in severe personal injury.

Choosing Sandpaper

The Model G0449/G0450 allows you to place a different grit sandpaper on each drum. The front drum should have a coarser grit than the rear. Usually this translates into combinations of successive group types. A common selection for stock that is planed before being sanded is a 100/150 grit combination.

Ultimately, the type of wood you use and your stage of finish will determine the best grit types to install on your sander.

There are many types of sandpaper rolls to choose from. We recommend Aluminum Oxide for general workshop environments. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

Grit	Class	Usage
36	Extra Coarse	Rough sawn boards, thickness sanding, and glue removal.
60	Coarse	Thickness sanding and glue removal.
80–100	Medium	Removing planer marks and initial finish sanding.
120–180	Fine	Finish sanding.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers, with no single grit increase of more than 50. Avoid skipping grits; the larger the grit increase, the harder it will be to remove the scratches from the previous grit.

Installing/Replacing Sandpaper

The Model G0449/G0450 is designed for 6" wide sandpaper rolls.

Items Needed	Qty
Straightedge 24"	1
Razor Knife	1
Sandpaper (for each drum)	6" x 138"

To install/replace sandpaper:

1. DISCONNECT MACHINE FROM POWER!

2. Lift top cover and place Phillips screwdriver through right side of frame and into side of drum, as shown in **Figure 33**.

3. Rotate sanding drum to stretch tension spring. Fit end of spring tension tool shaft through hole in tension wheel arm (see **Figure 33**) and into head of cap screw securing spring.

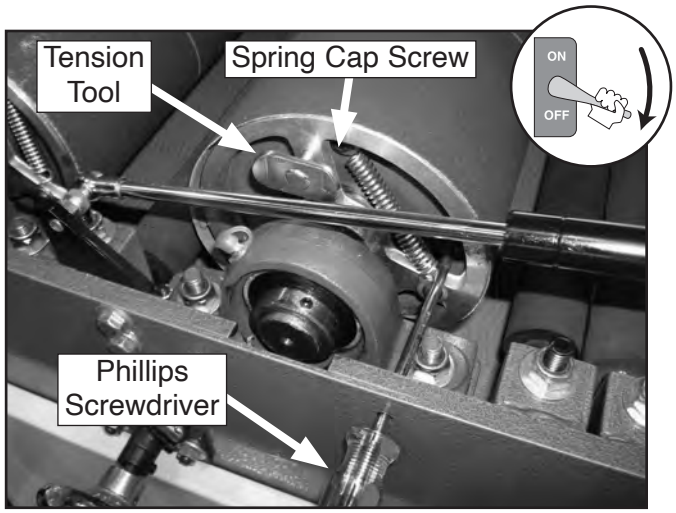


Figure 33. Tension wheel components.

4. Remove screwdriver.

5. Repeat **Steps 2–4** on opposite end of sanding drum, then remove spring clips.

   Note: *Replace sandpaper on each drum individually. Once sandpaper is removed drums can be slippery and hard to rotate.*

6. Unwind old sandpaper and use it as a pattern, or use pattern in **Figure 34** to cut sandpaper to the necessary shape.

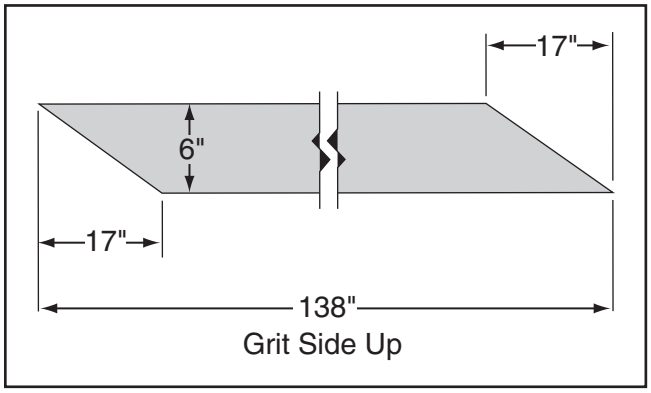


Figure 34. Sandpaper pattern.

— If using a different sandpaper with different width than 6", use pattern example in **Figure 35**.

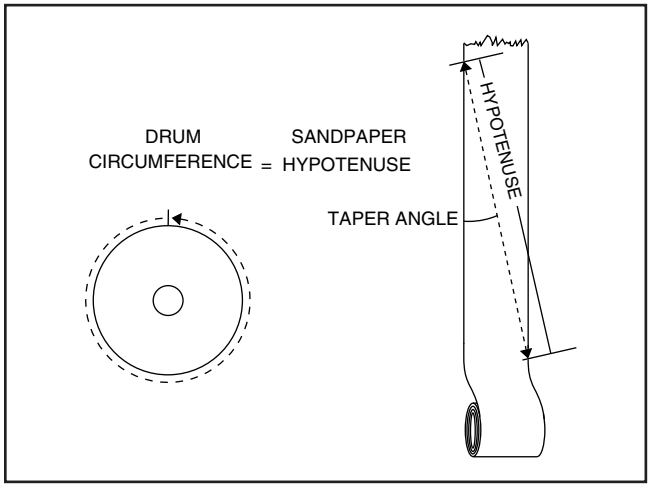


Figure 35. Finding sandpaper hypotenuse.

7. Starting with left side of drum, fold corner of sandpaper into spring clip, then install clip onto tension wheel. Tap clip with hammer or mallet to ensure it is seated.

   Note: *It is not necessary to drive clip completely on, just make sure it is secure. Too much force will break clip.*

8. Tightly spiral paper onto drum, ensuring there are no bubbles or overlapping edges, leaving a uniform 3⁄16" gap between spirals as you wind paper around drum.

9. Fold corner of loose end into spring clip, then install clip onto right tension wheel.

10. Remove spring tension tool from ends of sanding drum to tension paper, and repeat **Steps 2–10** for other drum.

Cleaning Sandpaper

To increase the working life of your sandpaper, clean it whenever you notice a decrease in performance due to heavy loading of material. Use a Model D3003 PRO-STIK® Cleaning Pad, as shown in **Figure 36**.

To clean sandpaper:

1. Set conveyor table height to thickness of cleaning pad.

2. Run pad through sander two or three times, as shown in **Figure 36**. DO NOT take too deep of a cut—sandpaper should barely touch cleaning pad!

Figure 36. Example of using D3003 PRO-STIK® Cleaning Pad to clean sandpaper.

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.

Aluminum Oxide Sanding Rolls, 6" x 50'

H4776—36 Grit: Use for rough sawn boards, thickness sanding, and glue removal.

G2787—60 Grit: Use for thickness sanding and glue removal.

H4777—80 Grit: Use for removing planer marks and initial finish sanding.

G2788—100 Grit: Use for removing planer marks and initial finish sanding.

H4778—120 Grit: Use for finish sanding.

G2789—150 Grit: Use for finish sanding.

Figure 37. H4776 6" sandpaper roll.

D3003—PRO-STIK® Cleaning Pad

Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your drum sander to remove dust build-up from the sandpaper without damage. Measures 15" x 20" x ¾".

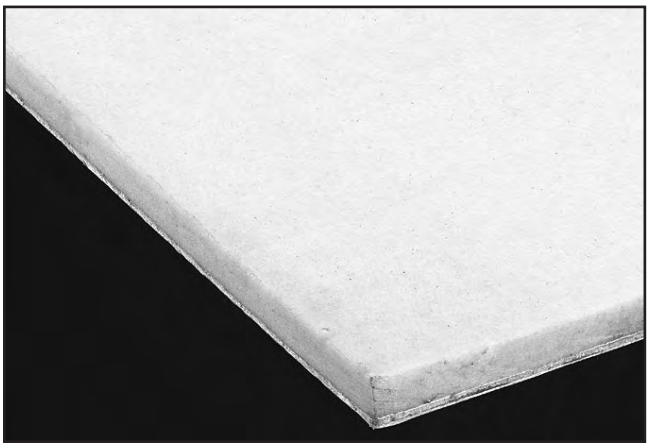


Figure 38. D3003 PRO-STIK® Cleaning Pad.

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 39. T26419 Syn-O-Gen Synthetic Grease.

T28172—14" x 39" Heavy-Duty Roller Table
T28369—14" x 78" Heavy-Duty Roller Table
T28370—14" x 118" Heavy-Duty Roller Table
Increase material handling and processing efficiency with one or more of these Heavy-Duty Roller Tables. Ideal for easily positioning of material into sander. Simply place a roller table on one or both sides of your sander and production time is automatically improved!

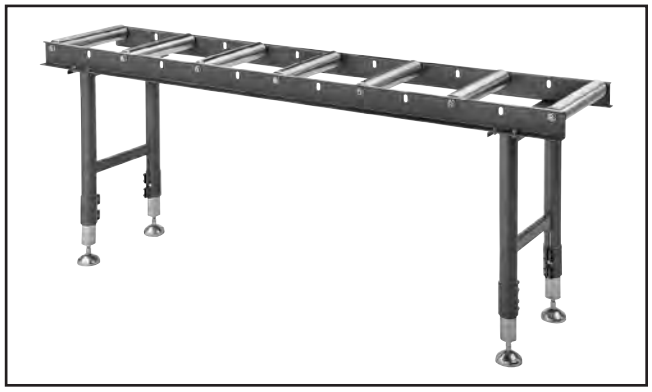


Figure 40. Heavy-duty roller table.

T23557 — IP54 6" EZ View Digital Caliper
The EZ View Digital Caliper offers a large LCD display. The hardened stainless steel construction sports a precision ground finish. The accuracy is within 0.001"/6" and the readings are available in inches, millimeters, and fraction with increments of 0.0005", 0.01mm, and 1/128". Powered by a 3V CR2032 battery, included. Measures from 0-6".

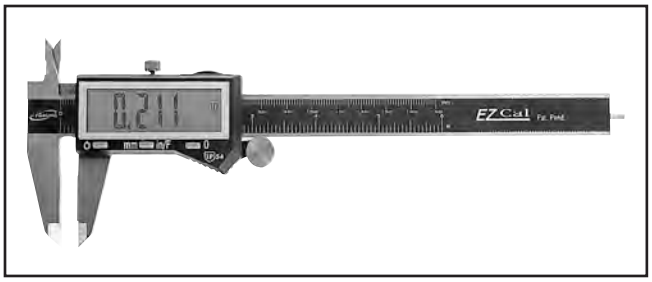
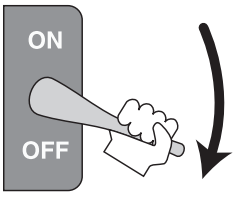


Figure 41. T23557 IP54 6" EZ View digital caliper.

SECTION 6: MAINTENANCE



⚠WARNING
To reduce risk of shock or accidental start-up, always disconnect machine from power and lock switch box in OFF position before adjustments, maintenance, or service.

Schedule

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

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

- Loose mounting bolts.
- Worn or damaged sandpaper.
- Worn switch or buttons.
- Worn or damaged V-belts.
- Any other unsafe condition.

Weekly
- Clean/vacuum dust buildup from underneath top cover.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Lubricate pillow bearings every 20 hours of operation.
- Lubricate conveyor drive chain and sprockets.

Monthly
- Check V-belt tension.
- Check speed reducer oil level.

Every 6 Months
- Lubricate conveyor table lift screws.
- Lubricate table height chain and sprockets
- Lubricate worm gear.

Yearly+
- Replace speed reducer oil every 2,500 hours of operation.

Cleaning Machine

Cleaning the Model G0449/G0450 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

Keeping the moving components clean and lubricated is crucial for smooth operation and a long working life. This reduces wear and keeps dust from building up and causing issues. Lubricate the pillow bearings every 20 hours. Other components, like the conveyor table lift screws, require less frequent maintenance depending on usage.

Pillow Bearings

Lubricant Type ..... T26419 or NLGI#2 Equivalent
Lubricant Amount ..... 1–2 Pumps
Frequency ..... 20 Hours of Operation

Items Needed	Qty
Grease Gun	1
Shop Rags	As Needed

To lubricate the pillow bearings, remove the grease fitting cap (see **Figure 42**), use a grease gun to pump a small amount of grease into the fittings, then attach the cap. DO NOT over lubricate.

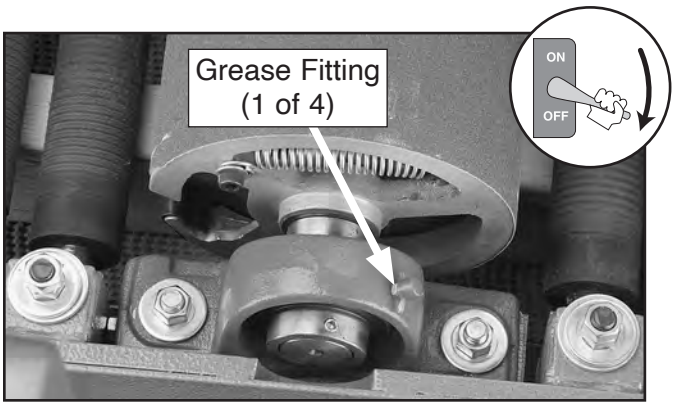


Figure 42. Location of grease fittings.

Conveyor Drive Chain, Sprockets, & Roller Bearings

Lubricant Type ..... T26419 or NLGI#2 Equivalent
Lubricant Amount
— Chain and Sprockets ..... As Needed
— Conveyor Bearings ..... 1 Pump
Frequency..... Weekly

Items Needed	Qty
Soft Wire Brush	1
Mineral Spirits	As Needed
Grease Gun	1
Shop Rags	As Needed

To lubricate the conveyor drive chain and sprockets (see **Figure 43**), remove feed motor cover, then clean the chain and sprockets with mineral spirits and a soft wire brush. Apply grease to the chain and sprockets. The grease will distribute when conveyor is running.

To lubricate the conveyor roller bearings, at each end of the front conveyor roller, remove the grease fitting cap (see **Figure 43**), use a grease gun to pump a small amount of grease into the fittings, then attach the cap. DO NOT over lubricate.

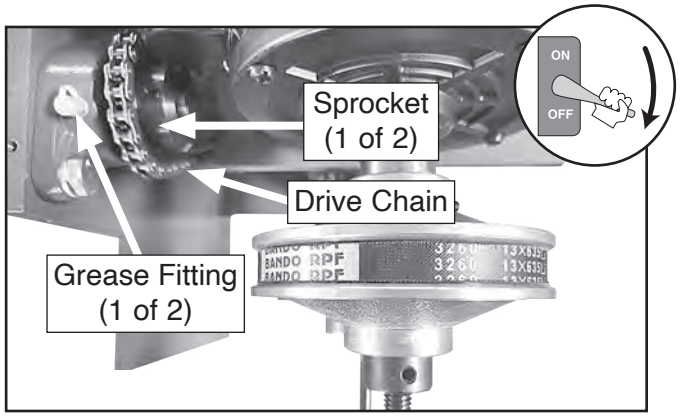


Figure 43. Location of conveyor drive chain, sprocket, and bearing grease fitting.

The rear roller bearings are sealed and do not need to be lubricated.

IMPORTANT: Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the components.

Conveyor Table Lift Screws

Lubricant Type ..... T26419 or NLGI#2 Equivalent
Lubricant Amount ..... As Needed
Frequency..... 6 Months

Items Needed	Qty
Soft Wire Brush	1
Mineral Spirits	As Needed
Grease Gun	1
Shop Rags	As Needed

To lubricate the conveyor table lift screws (see **Figure 44**), lower table completely, then clean the lift screws with mineral spirits and a soft wire brush. Apply grease to the lift screw threads, then adjust the table up and down to distribute the grease.

IMPORTANT: Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the components.

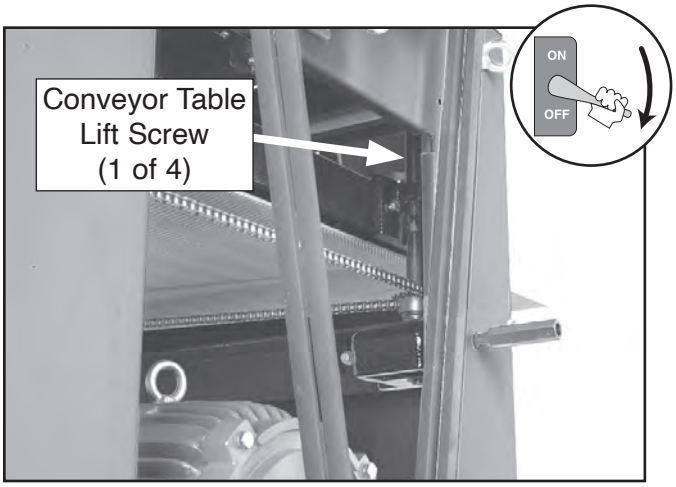


Figure 44. Location of conveyor table lift screws (top removed for clarity).

Table Height Chain & Sprockets

Lubricant Type ..... T26419 or NLGI#2 Equivalent
Lubricant Amount ..... As Needed
Frequency..... 6 Months

Items Needed	Qty
Soft Wire Brush	1
Mineral Spirits	As Needed
Grease Gun	1
Shop Rags	As Needed

To lubricate the table height chain and sprockets (see **Figure 45**), raise conveyor table completely, then clean the chain and sprockets with mineral spirits and a soft wire brush. Apply grease to the chain and sprockets, then adjust the table up and down to distribute the grease.

IMPORTANT: Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the components.

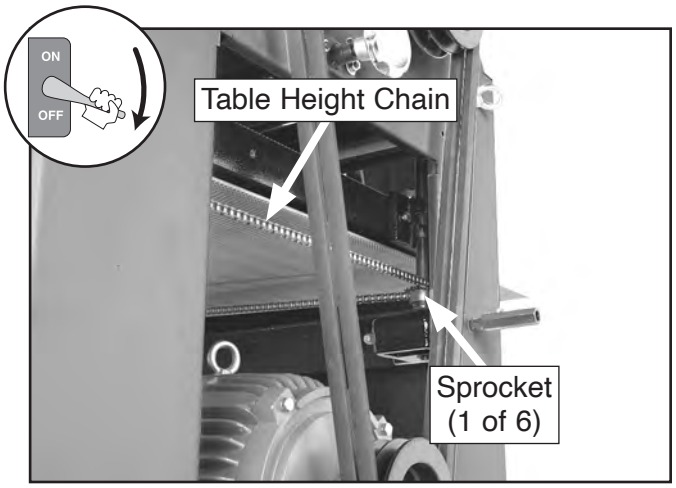


Figure 45. Location of table height chain and sprocket.

Worm Gear

Lubricant Type ..... T26419 or NLGI#2 Equivalent
Lubricant Amount ..... As Needed
Frequency..... 6 Months

Items Needed	Qty
Soft Wire Brush	1
Mineral Spirits	As Needed
Grease Gun	1
Shop Rags	As Needed

To lubricate the worm gear (see **Figure 46**), clean gear teeth with mineral spirits and a soft wire brush, then apply a small amount of grease. Adjust the table up and down to distribute the grease.

IMPORTANT: Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the components.

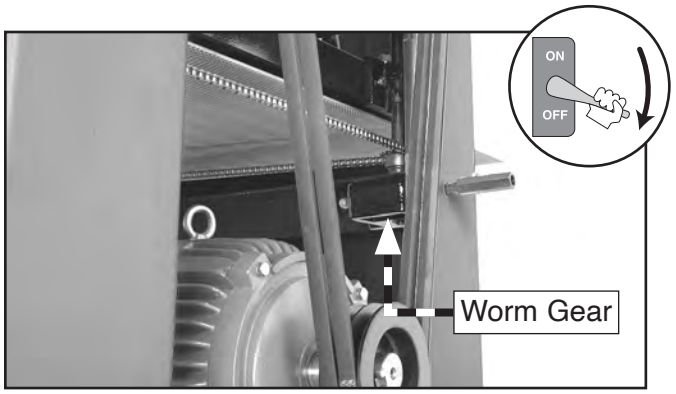


Figure 46. Location of worm gear.

Speed Reducer

Lubricant Type ..... SAE 90 or 80w-90 Gear Oil
Lubricant Amount ..... 12 fl. oz.
Frequency.....2,500 Hours of Operation

Items Needed	Qty
Safety Glasses	1 Pair
Work Gloves	1 Pair
Hex Wrenches 3, 4mm, ¼"	1 Ea.
Wrench Open-End 13, 22mm	1 Ea.
Wrenches or Sockets 17mm	2
Drain Pan	1
Funnel	1
Shop Rags	As Needed

IMPORTANT: To ensure the gear oil drains completely, turn conveyor ***ON*** and allow it to run for several minutes to warm the oil.

To change speed reducer gear oil:

1. DISCONNECT MACHINE FROM POWER!

2. Remove conveyor speed knob, hex nut, knurled knob, and support plate, shown in **Figure 47**.

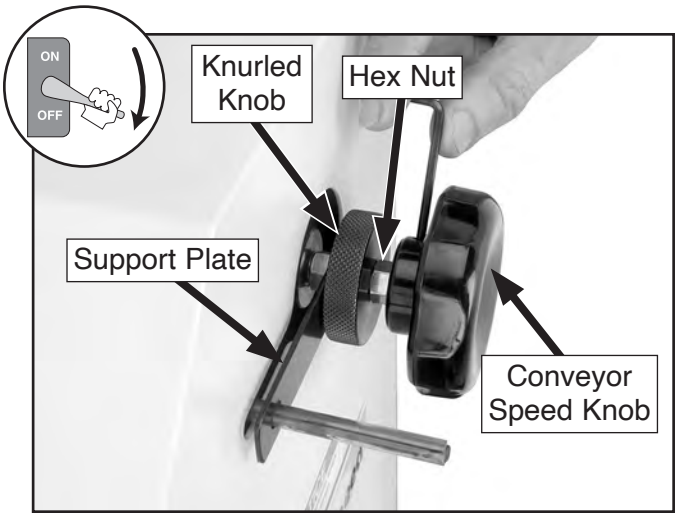


Figure 47. Removing variable speed knob.

3. Remove (4) button head cap screws securing feed motor cover, then remove cover.

4. Remove (4) hex bolts, flat washers, and hex nuts securing speed reducer to mounting plate (see **Figure 48**), then lift speed reducer and remove V-belt.

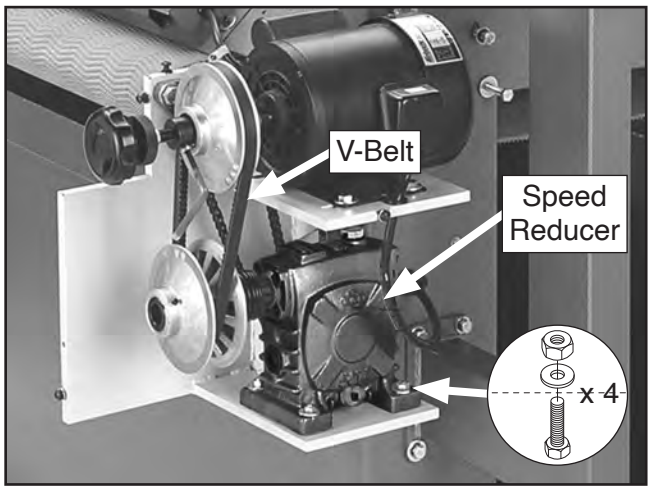


Figure 48. Location of speed reducer fasteners.

5. Slide the speed reducer to edge of mounting plate, then remove fill and drain plugs (see **Figure 49**) to drain oil.

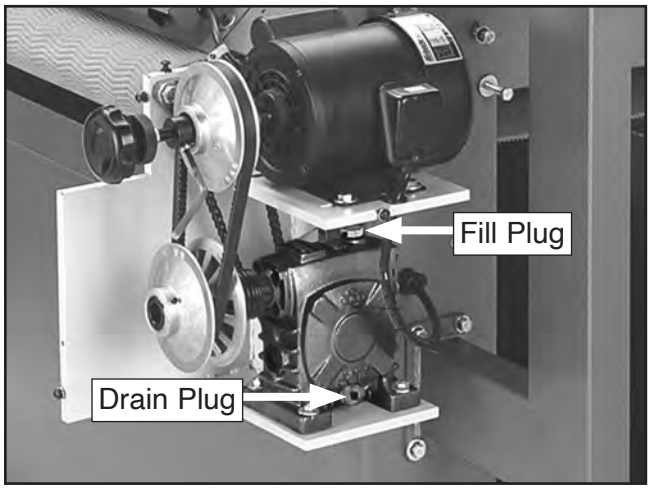


Figure 49. Location of fill and drain plugs.

6. Install drain plug, add oil until sight glass is half full, then install fill plug.

7. Slide speed reducer back into place, then install V-belt.

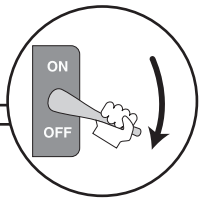
8. Secure speed reducer to mounting plate with fasteners removed in **Step 4**, then install feed motor cover.

9. Install conveyor speed knob, hex nut, knurled knob, and support plate (see **Figure 47**).

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 a breaker trips.	1. Power supply switched OFF. 2. EMERGENCY STOP button depressed. 3. Motor connection wired incorrectly. 4. Thermal overload relay has tripped. 5. Wall fuse/circuit breaker is blown/tripped. 6. Wiring is open/has high resistance. 7. EMERGENCY STOP bar is stuck. 8. Motor or motor bearings at fault.	1. Ensure power supply is switched ***ON***. 2. Rotate EMERGENCY STOP button clockwise to reset. 3. Correct motor wiring connections (**Page 59**). 4. Reset relay. 5. Ensure circuit size is suitable for this machine; replace weak breaker. 6. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 7. Free EMERGENCY STOP bar from binding. 8. Replace motor.
Machine stalls or is overloaded.	1. Workpiece material not suitable. 2. Feed rate too fast. 3. V-belts loose or worn. 4. Motor connection is wired incorrectly. 5. Motor bearings are at fault. 6. Machine is undersized for the task. 7. Motor has overheated. 8. Motor is at fault. 9. Air circulation through the motor restricted.	1. Ensure workpiece is suitable for sanding (**Page 29**). 2. Reduce feed rate (**Page 30**). 3. Tension/replace belts (**Page 44**). 4. Correct motor wiring connections. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Use new sandpaper with appropriate grit; reduce the feed rate/depth of sanding. 7. Clean off motor, let cool, and reduce workload. 8. Test/repair/replace. 9. Clean off motor to provide normal air circulation.
Conveyor belt runs backwards (G0450 only).	1. Machine is wired out of phase.	1. Correct phase polarity (**Page 24**) .

Operations

Symptom	Possible Cause	Possible Solution
Machine slows when sanding, making squealing noise, especially on start-up.	1. V-belts loose or worn.	1. Tension/replace V-belts (**Page 44**).
Loud repetitious noise coming from machine.	1. Pulley set screws or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective.	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belts (**Page 44**).
Vibration when sanding.	1. Loose drum pillow bearings. 2. Worn drum pillow bearings.	1. Tighten drum pillow bearings. 2. Replace drum pillow bearings (**Page 46**).
Grinding, screeching, or rubbing noise from sanding drums.	1. Drum scraping on dust scoops. 2. Pillow bearings need lubrication. 3. Pillow bearings worn.	1. Adjust dust scoops (**Page 54**). 2. Lubricate pillow bearings (**Page 37**). 3. Replace pillow bearings (**Page 46**).
Short V-belt lifespan.	1. Pulleys not aligned correctly. 2. V-belts not properly tensioned.	1. Align pulleys (**Page 45**). 2. Properly tension V-belts (**Page 44**).
Machine lacks power; drums stop turning under load.	1. Depth of cut is too much. 2. V-belts not properly tensioned. 3. Too much pressure on pressure rollers.	1. Reduce depth of cut (**Page 30**). 2. Properly tension V-belts (**Page 44**). 3. Reduce pressure roller pressure (**Page 46**).
Conveyor belt slips or does not track correctly.	1. Conveyor is too loose. 2. Too much load.	1. Tension conveyor (**Page 40**). 2. Decrease load.
Conveyor tracks to one side; conveyor hits the roller cover.	1. Conveyor tracking is incorrect.	1. Track the conveyor so it runs straight (**Page 41**).
Workpiece pulls to one side during sanding operations.	1. Sanding drum(s) not perpendicular to feed direction. 2. Sanding drum(s) not parallel with conveyor.	1. Adjust sanding drum(s) perpendicular to feed (**Page 49**). 2. Adjust sanding drum(s) parallel to conveyor (**Page 51**).
Excessive snipe.	1. Lack of outfeed support. 2. Too much pressure from pressure rollers. 3. Too much pressure from rear pressure roller.	1. Set up outfeed table or have someone catch workpiece as it comes out. 2. Raise pressure rollers (**Page 53**). 3. Raise rear pressure roller (**Page 53**).

Operations (Cont.)

Symptom	Possible Cause	Possible Solution
Workpiece kicks out of sander.	1. Not enough pressure from pressure rollers. 2. Sanding drum(s) not properly aligned.	1. Lower pressure rollers (**Page 53**). 2. Adjust sanding drum(s) alignment (**Page 48**).
Sandpaper tears off drums during operation.	1. Nail/staple in workpiece. 2. Sandpaper not fastened correctly. 3. Drums not perpendicular to feed direction.	1. Sand only clean workpieces. 2. Install the sandpaper correctly (**Page 33**). 3. Adjust drums perpendicular to feed direction (**Page 49**).
Table elevation controls are stiff and hard to adjust.	1. Table lock is engaged. 2. Conveyor table leadscrews dirty or loaded with sawdust. 3. Chain idler roller sprocket lock nuts have been tightened against roller. 4. Elevation handle worm gear is dirty or loaded with sawdust.	1. Disengage table lock. 2. Clean and lubricate conveyor table leadscrews (**Page 38**). 3. Adjust the lock nuts on the idler roller sprocket so roller can spin freely. 4. Clean and lubricate worm gear (**Page 39**).
Poor dust collection.	1. Dust collection lines incorrectly sized for this machine. 2. Dust collector underpowered or too far away from this machine.	1. Use at least an 8" main line with two 6" branch lines that each Y into 4" at the machine. 2. Upgrade your dust collector or decrease the distance from the dust collector to the machine.

Making Gauge Blocks

The gauge blocks described below will be required to complete most of the service procedures in this section. After you have made them, they can be conveniently stored inside of the sander cabinet for future use.

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

To make gauge blocks:

1. Edge joint concave edge of 7' long 2x4 flat on jointer, as shown in **Figure 50**.

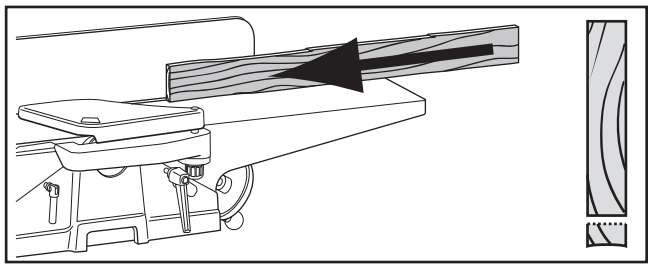


Figure 50. Edge jointing on jointer.

2. Place jointed edge of 2x4 against table saw fence and rip cut just enough off opposite side to square two edges of 2x4, as shown in **Figure 51**.

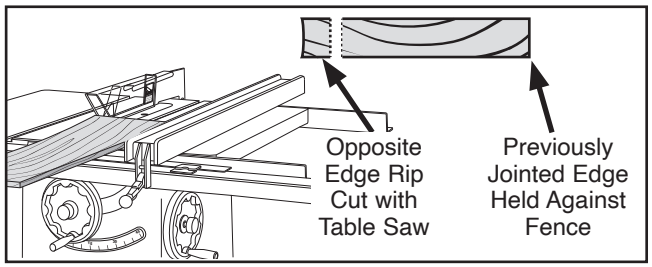


Figure 51. Rip cutting on a table saw.

3. Using a miter saw or circular saw, cut 6" off each end of board to remove any portions with slight snipe from jointing. Cut 2x4 into two even pieces to make two 36" long wood gauge blocks.

Note: *Save one of the 6" pieces for making a small gauge block in* ***Aligning Drums*** *on* ***Page 48****.*

Steps 1 & 2 *can be skipped, but having these wood gauge blocks at even height is critical to accuracy of overall adjustments.*

Adjusting V-Belts

Tools Needed	Qty
Hex Wrench 5mm	1
Open-End Wrenches 19mm	2
Straightedge (at least 24")	1
Ruler	1

V-Belt Tension

New V-belts often stretch and loosen up during the first 16 hours of use. After this period, they should be inspected and re-tensioned.

Proper tension is important for optimum power transmission. However, too much tension may cause premature bearing failure.

The correct V-belt tension is achieved when the V-belts can be deflected ½"–¾" when pushed in the middle with moderate pressure. See **Figure 52** for an example of how to perform a V-belt deflection test with a straightedge and ruler.

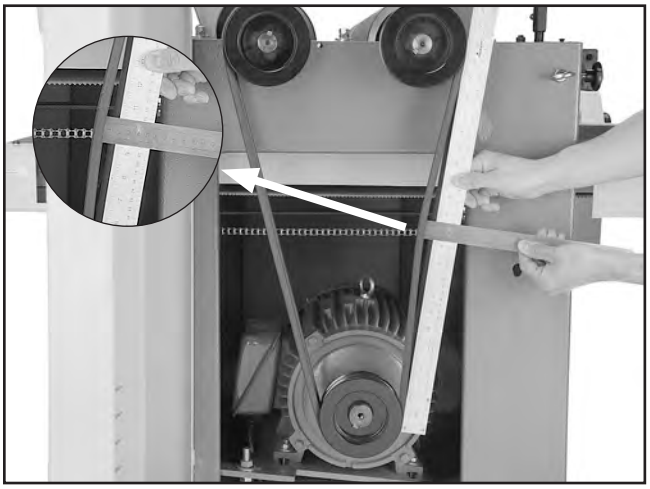


Figure 52. Checking V-belt tension with a straightedge and a ruler.

To adjust V-belt tension:

1. DISCONNECT MACHINE FROM POWER**!**

2. Remove table height handwheel and open pulley cover.

3. Rotate motor mount hex nuts (see **Figure 53**) *counterclockwise* to loosen or *clockwise* tighten V-belts.

4. Close pulley cover and install handwheel.

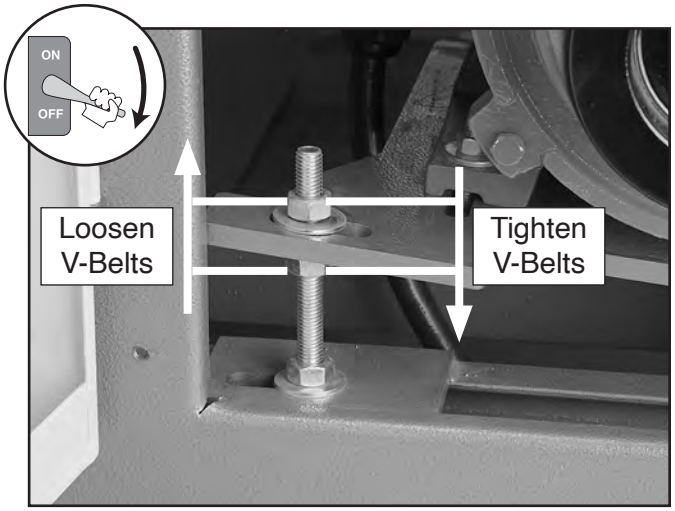


Figure 53. V-belt tension controls.

V-Belt Removal/Replacement

Replace the V-belt if you notice fraying, cracking, glazing, or any other damage. A worn/damaged V-belt will not provide optimum power transmission from the motor to the drums.

V-belt removal and replacement is simply a matter of loosening the V-belts until you can roll them off the pulleys, replacing them with a MATCHED set, then re-tensioning them.

Note: *A matched set means both the V-belts are the same size and also have the same serial number.*

Pulley Alignment

Pulley alignment is another important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplaner) for optimum performance.

Each pulley can be adjusted by loosening the set screw that secures the pulley to the shaft, sliding the pulley in/out, and retightening the set screw to lock the pulley in place.

To align pulleys:

1. DISCONNECT MACHINE FROM POWER**!**

2. Remove table height handwheel, open pulley cover, and remove V-belts.

3. Place straightedge across face of motor pulley and front drum pulley to check alignment. Straightedge should sit evenly on top and bottom of both pulleys (see **Figure 54**).

Figure 54. Checking pulley alignment with straightedge.

4. Repeat **Step 3** with straightedge placed against motor pulley and rear drum pulley.

5. Loosen pulleys and adjust as necessary until they are all coplanar with each other.

6. Install and tension V-belts, close pulley cover and install handwheel.

Replacing Pillow Bearings

The Model G0449/G0450 is designed for many years of reliable service. But after long periods of heavy use, it may be necessary to replace the pillow block bearings. Always replace both bearings on the same drum at the same time.

Items Needed	Qty
Wrench or Socket 17mm	1
Hex Wrench 3mm	1
Bearing Blocks (P0449488)	2 Per Drum
Grease Gun	1
T26419 or NLGI#2 Equivalent	As Needed
Shop Rags	As Needed

To replace pillow bearings:

1. DISCONNECT MACHINE FROM POWER!

2. Remove V-belts (see **V-Belt Removal/ Replacement** on **Page 45**).

3. Remove lock nuts and flat washers from bearing block assembly on each side of drum, shown in **Figure 55**.

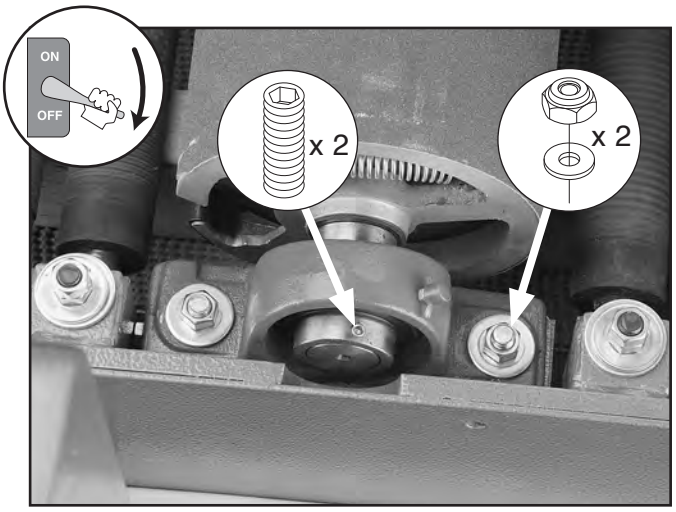


Figure 55. Location of bearing fasteners.

4. Carefully lift drum up and out of machine and place on flat, stable surface.

5. Loosen (2) bearing set screws (see **Figure 55**) on each side of drum, then remove bearing assemblies from drum shaft.

6. Clean and inspect drum shaft for damage or unusual wear.

7. Slide new bearing assemblies into place on drum shaft. Do not tighten set screws at this time.

NOTICE

Do not hammer on the bearing or housing, as you WILL damage these precision parts.

8. Install drum into machine, then secure with lock nuts and flat washers removed in **Step 3**.

9. Lubricate each bearing by adding 2–3 pumps of grease with a grease gun.

   IMPORTANT: Stop pumping when grease just begins to seep from seal.

10. Follow instructions for **Pulley Alignment** on **Page 45** before tightening bearing set screws.

11. Follow instructions for **Aligning Drums** on **Page 48**.

12. Follow instructions for **Adjusting V-Belts** on **Page 44**.

13. Secure all doors and guards, and install handwheel.

NOTICE

Lubricate bearings sparingly every 20 hours of sander operation. Bearings require very little grease, so avoid temptation to over-lubricate.

Tracking/Tensioning Conveyor Belt

⚠CAUTION

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

The conveyor belt must track straight. If the belt tracks to either side, then the tracking must be corrected or the conveyor belt will become damaged and have to be replaced. The tracking was properly set at the factory, but eventually, wear may cause it to track unevenly.

Tracking the conveyor belt is a balancing process that takes patience and some trial and error. Usually, you must over-tighten the loose side to make the belt move to center of the rollers, then loosen that same side to make the conveyor belt stay in position. If the tracking bolt is over-adjusted, the process will need to be repeated until the conveyor belt stays centered on the rollers.

The conveyor belt will naturally stretch over time, especially when new. This stretching can cause the belt to slip on the rollers, indicating it needs to be tensioned.

When adjusting conveyor belt tension, focus on adjusting the tension bolts in even increments. Adjusting one side more than the other will cause tracking problems, which will require additional adjustments to get the conveyor belt tracking correctly again.

Tools Needed	Qty
Open-End Wrenches 19mm	2

Tracking Conveyor Belt

To determine which side of the conveyor belt needs to be adjusted, first turn the machine ***ON*** and observe the direction that the conveyor belt is tracking toward. This is the loose side and needs adjustment.

To adjust conveyor belt tracking:

1. On loose side of conveyor, loosen jam nut (see **Figure 56**) and tighten adjustment bolt to increase conveyor belt tension.

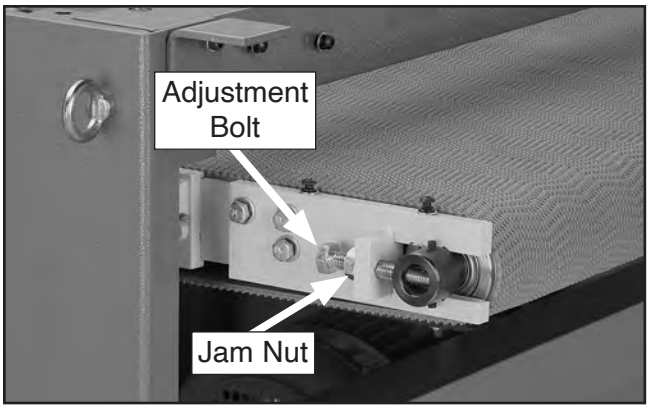


Figure 56. Conveyor tensioning & tracking controls (guard removed for clarity).

Note: *Tracking changes may take a couple of minutes before they are noticeable, so be patient.*

2. As conveyor reaches center of roller, *slightly* loosen bolt to stop tracking movement. Allow conveyor to run for several minutes to ensure tracking is correct.

3. Tighten jam nut.

Tensioning Conveyor Belt

1. Ensure belt is tracking correctly. Refer to **Tracking Conveyor Belt** on **Page 47** if adjustment is necessary.

2. On each side of conveyor, loosen jam nut (see **Figure 57**), then rotate adjustment bolt *clockwise* to tighten and *counterclockwise* to loosen conveyor belt tension.

   Note: *Evenly adjust both sides to maintain tracking.*

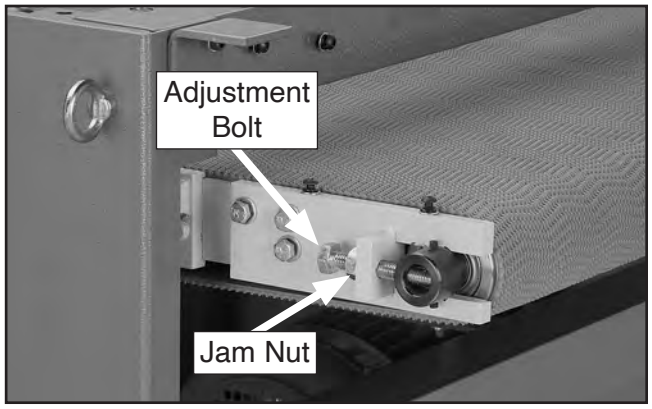


Figure 57. Conveyor tensioning & tracking controls (guard removed for clarity).

   Note: *When tensioned properly, conveyor belt should not lift off table, slide back and forth, or slip.*

NOTICE

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

3. Allow conveyor to run for several minutes to ensure tracking is correct.

4. Tighten jam nuts.

Aligning Drums

⚠CAUTION

Improper drum alignment could cause an uncontrolled exit of material from the machine—which could result in personal injury, damage to property, premature wear, and failure of sandpaper.

There are three adjustments for the sanding drums: 1) the drums must be perpendicular to the feed direction (parallel with the conveyor roller, (see **Figure 58**); 2) the drums must be parallel to the top of the conveyor belt (see **Figure 64** on **Page 51**); 3) the rear drum must be set approximately 0.007" to 0.015" below the front drum (see **Figure 67** on **Page 53**).

At some point, you may need to readjust the rear drum parallel to the conveyor if you change the rear drum height to accomodate for different sandpaper thicknesses or finish requirements. Make sure the rear drum does not sit lower than 0.015" below the front drum.

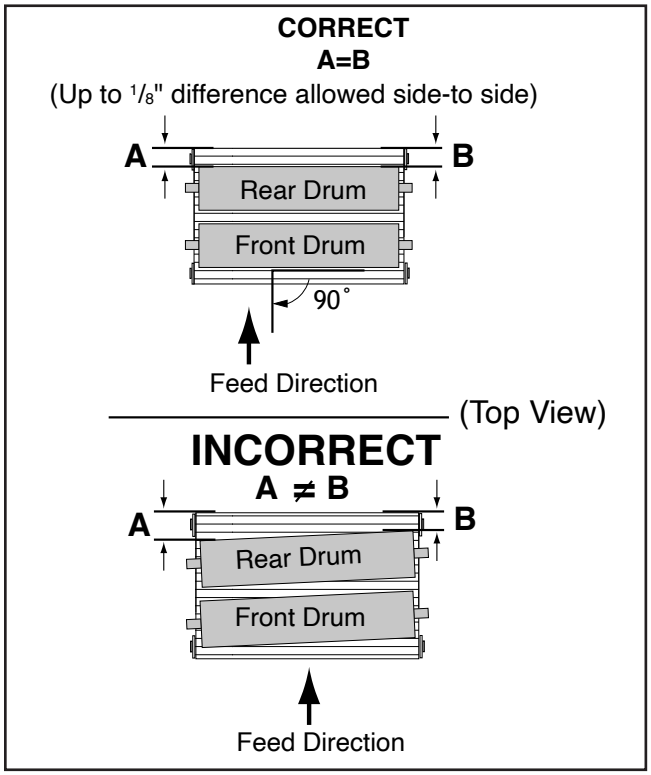


Figure 58. Drum perpendicular to feed direction.

Adjusting Drums Perpendicular to Feed Direction

The tolerances for having the drum perpendicular to the feed direction allow up to ⅛" difference from one side to the other (see **Figure 58** on **Page 48**). If the drums are not perpendicular to the feed direction, they may put a side load on the conveyor belt during operation, forcing the conveyor to track off to the side and possibly causing damage.

Items Needed	Qty
Tape Measure	1
Open-End Wrench or Socket 17mm	1
Wood Blocks (2" x 4" x 8")	2

To adjust drums perpendicular to feed direction:

1. DISCONNECT MACHINE FROM POWER**!**

2. Open top and pulley covers and remove V-belts (see **V-Belt Removal/Replacement** on **Page 45**).

3. Remove sandpaper from both drums (see **Installing/Replacing Sandpaper** on **Page 33**).

4. At each end of rear drum, measure distance between edge of rear drum and rear upper frame, as shown in **Figure 59**. Difference between measurements will tell how close drum is to being perpendicular to feed direction.

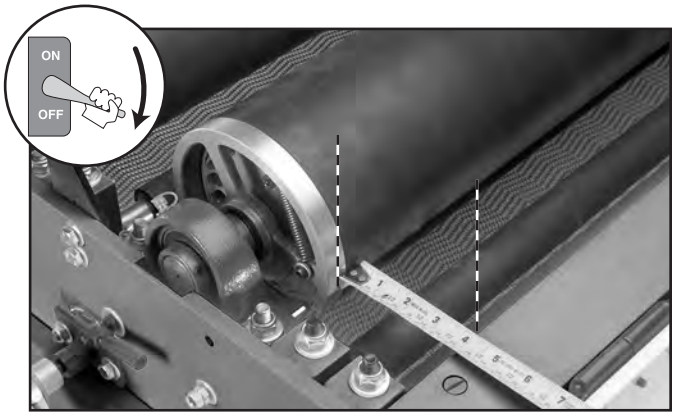


Figure 59. Measuring distance between edge of rear drum and the upper frame.

   — If difference between measurements *is within* ⅛", no adjustment is needed. Proceed to **Step 7**.

   — If difference between measurements *is more than* ⅛", proceed to **Step 5**.

5. Loosen rear drum pillow bearing lock nuts, shown in **Figure 60**.

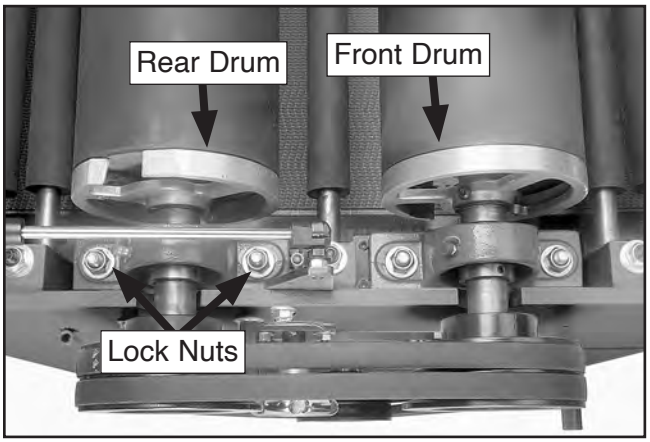


Figure 60. Location of rear drum bearing lock nuts.

6. Move one end of drum forward or backward as needed until distance between rear upper frame and drum is within ⅛" at each end, then tighten rear drum pillow bearing lock nuts.

7. Measure distance between rear and front drum, as shown in **Figure 61**, on both sides.

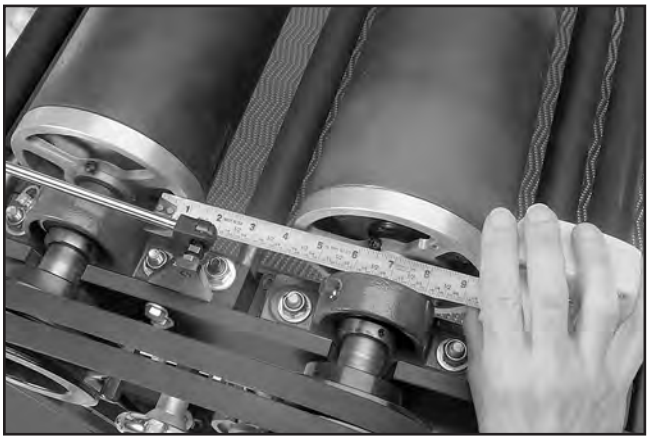


Figure 61. Measuring distance between rear and front drums.

— If difference between measurements *is within* ⅛", no adjustment is needed. Proceed to **Step 13**.

— If difference between measurements *is more than* ⅛", proceed to **Step 8**.

8. Make two gauge blocks same length as measurement between drums on pulley side.

9. Place gauge blocks between drums at each end, as shown in **Figure 62**.

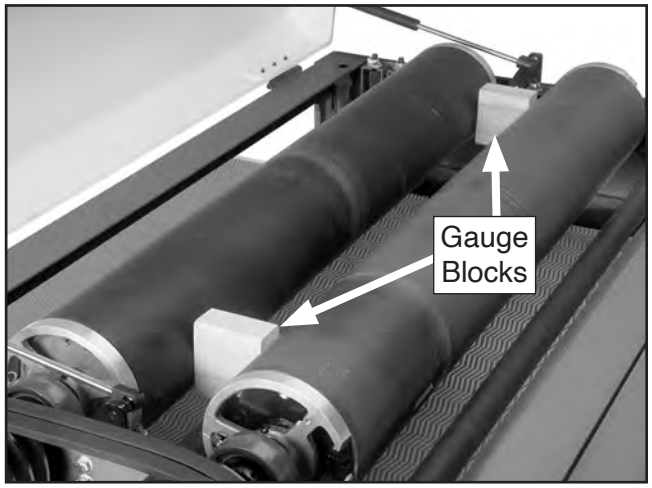


Figure 62. Example of small gauge block positioned between front and rear drums.

10. Loosen front drum pillow bearing lock nuts (see **Figure 63**).

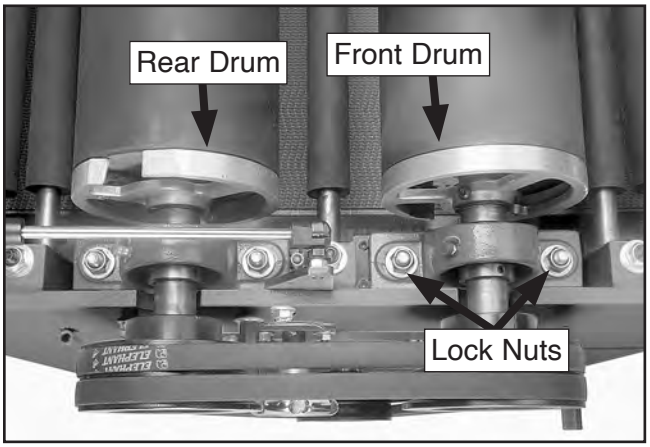


Figure 63. Location of front drum bearing lock nuts.

11. Slide front drum against gauge blocks until they are snug between front and rear drums.

12. Tighten front drum pillow bearing lock nuts.

13. Install sandpaper and V-belts, then close and secure pulley cover and top cover.

Adjusting Drums Parallel to Conveyor Belt

The rear drum can be adjusted parallel to the conveyor belt in fine increments at the pillow bearings with the micro-adjust knobs, or the front drum can be adjusted parallel to the conveyor with the set screws on the pillow bearings. If, after performing the following procedure, you cannot adjust the drums parallel to the conveyor belt, it is possible that the conveyor table needs further adjustment. In that case, refer to **Adjusting Conveyor Table Lift Screws** on **Page 55**.

Keep in mind that having the drums parallel to the top of the conveyor belt (see **Figure 64**) is critical to the sanding operation. Take care to adjust the drums parallel to the conveyor surface within 0.002" from one side to the other.

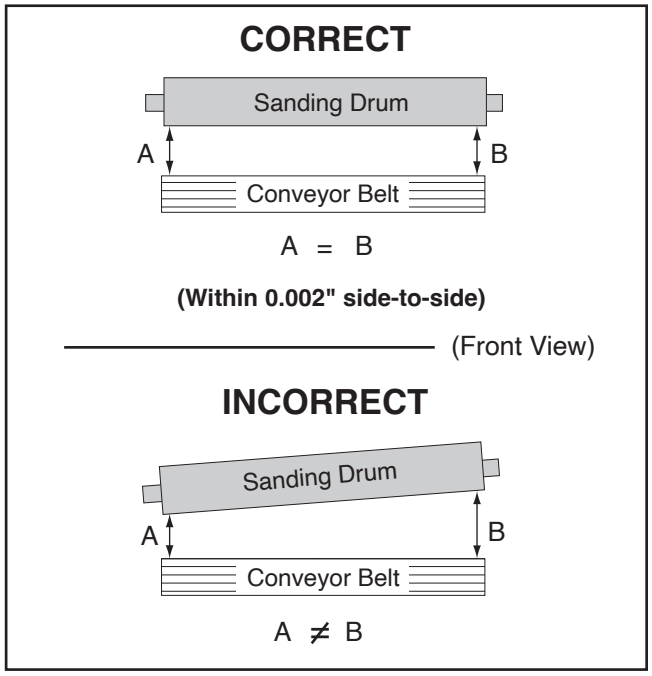


Figure 64. Drum parallel to conveyor belt.

Items Needed	Qty
Hex Wrench 5mm	1
Wrench/Socket 17mm	1
Feeler Gauge Set	1
Gauge Blocks (see **Page 44**)	2

To adjust drums parallel to conveyor belt:

1. DISCONNECT MACHINE FROM POWER!

2. Open top and pulley covers, remove V-belts, and remove sandpaper from drums.

3. Place gauge blocks on conveyor table under drums, as shown in **Figure 65**.

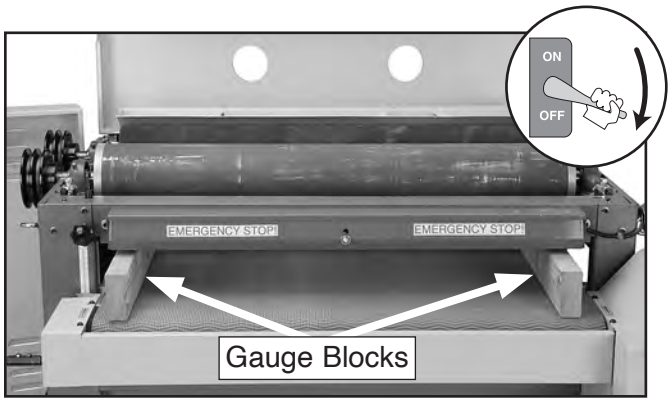


Figure 65. Example of gauge blocks positioned under drums.

4. Raise table until gauge blocks are approximately 0.010" below rear drum. This setting will be used to determine rear drum-conveyor bed parallelism.

   Note: *Each full turn of table height handwheel raises conveyor table approximately 0.020".*

5. Loosen lock lever and lock bolt (see **Figure 66**) at ends of rear drum.

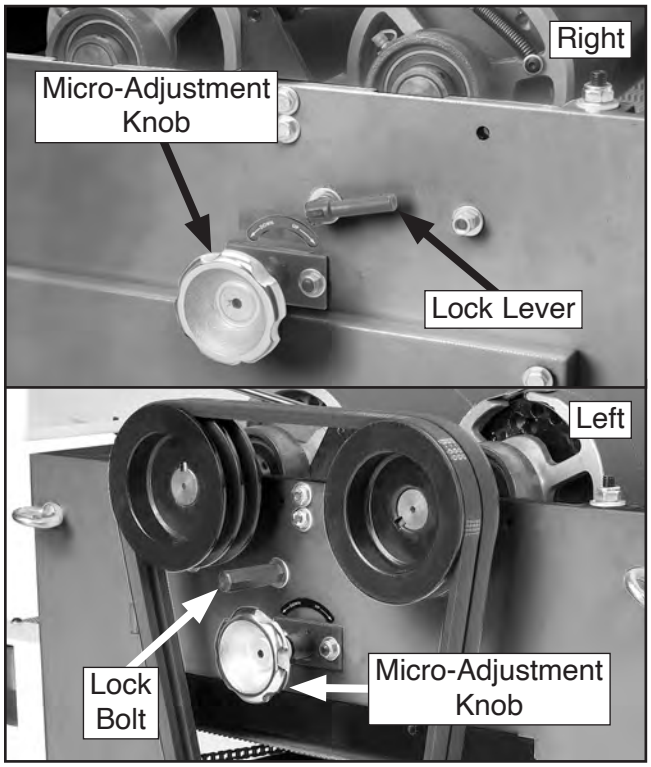


Figure 66. Location of rear sanding drum micro-adjustment knobs and locks.

6. On one side of rear drum, rotate micro-adjustment knob until a 0.010" feeler gauge fits between drum and gauge block (see **Figure 67**).

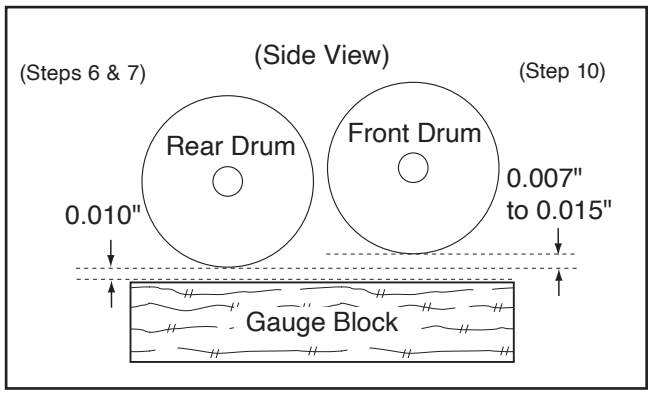


Figure 67. Rear drum set below front drum.

7. Repeat **Step 6** on other side of rear drum until height difference between both ends is 0.002" or less.

8. Tighten micro-adjustment lock lever and lock bolt.

9. Loosen front drum pillow bearing lock nuts (see **Figure 68**).

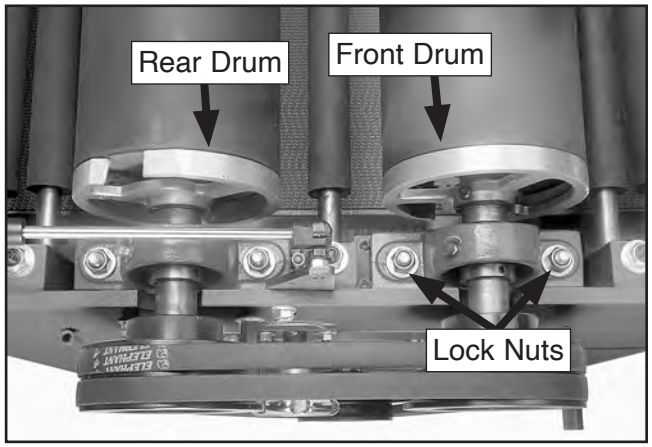


Figure 68. Location of front drum bearing lock nuts.

10. Adjust height of front drum by adjusting set screws (see **Figure 69**) on pillow bearing up or down until largest size feeler gauge you can fit between front drum and gauge blocks (at both ends) is 0.017"–0.025.

Note: *The 0.017"–0.025" setting is a recommended range and includes the 0.010" setting on the rear drum and the additional 0.007" to 0.015" height from* ***Step 6*** *(see* ***Figure 67****). Some trial-and-error may be needed to find the optimal setting based upon the sandpaper grit size you use (ie, coarse grit = smaller number; fine grit = larger number).*

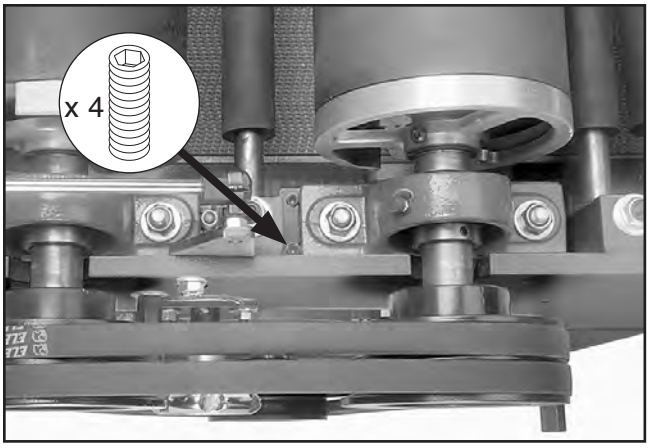


Figure 69. Location of front drum set screws.

IMPORTANT: Ensure sanding drums remain perpendicular to feed direction when making adjustments. Refer to **Adjusting Drums Perpendicular to Feed Direction** on **Page 49**.

11. Tighten front pillow bearing lock nuts.

12. Remove gauge blocks, then install sandpaper (see **Installing/Replacing Sandpaper** on **Page 33**).

13. Install and tension V-belts (see **Adjusting V-Belts** on **Page 44**), then close and secure pulley cover and top cover.

14. Calibrate scale pointer (see **Calibrating Scale Pointer** on **Page 54**).

Adjusting Pressure Roller Height

Proper pressure on the workpiece helps avoid kickback and keeps the workpiece from slipping. However, as pressure increases on the workpiece, snipe also increases (snipe is normal with all brands of drum sanders).

If snipe becomes a problem, you can minimize it by reducing pressure (raising pressure roller height). However, you can only minimize it so much before the workpiece will slip or kick out, causing a hazard to the operator. If this happens, you have raised the pressure rollers too high for them to function as intended—the pressure rollers MUST then be lowered to prevent injury.

The pressure rollers are factory set at 0.039"–0.078" below the bottom of the rear sanding drum and are fully adjustable either up/down with the lock nuts shown in **Figure 70**.

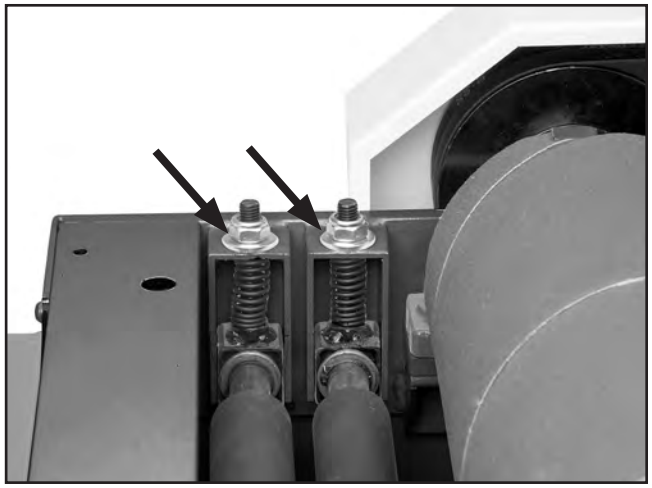


Figure 70. Location of pressure roller adjustment nuts.

Items Needed **Qty**
Wrenches/Sockets 17mm 1
Gauge Blocks (see **Page 44**) 2

Factory Setting:
Distance Below Rear Drum .....0.039"–0.078"

Tip: *One method of eliminating snipe is to slightly reduce pressure only on rear pressure rollers. Conditions will vary with wood types, so use trial-and-error to find best results for your application.*

To adjust pressure roller height:

1. DISCONNECT MACHINE FROM POWER!

2. Open top cover and remove sandpaper from drums.

3. Position gauge blocks on each side of conveyor table and under all pressure rollers, as shown in **Figure 71**.

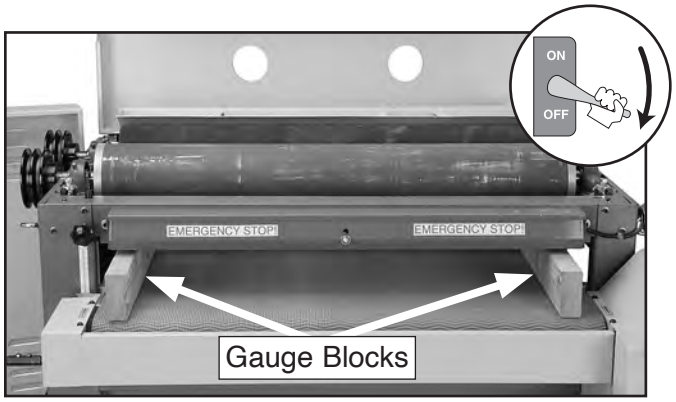


Figure 71. Example of gauge blocks in position for adjusting pressure roller height.

4. Adjust conveyor table so gauge blocks just touch bottom of rear drum.

5. Rotate handwheel 2–4 full turns *clockwise* to lower conveyor, counting from point of actual table movement so handwheel free-play does not affect count.

6. For all pressure rollers: 1) Raise one end off of gauge block, then move it back down until it just touches gauge block; 2) repeat with other side; 3) tighten lock nuts together to make sure adjustments are locked in place.

Calibrating Scale Pointer

For the scale pointer to be accurate, it must be calibrated.

We recommend calibrating your scale pointer any time you adjust the drum heights or table lift screws.

Tool Needed	Qty
Phillips Head Screwdriver	1

To calibrate scale pointer:

1. Sand workpiece with drum sander and measure thickness of sanded workpiece.

2. Loosen Phillips head screw securing scale pointer (see **Figure 72**), adjust pointer to thickness of sanded workpiece, then tighten.

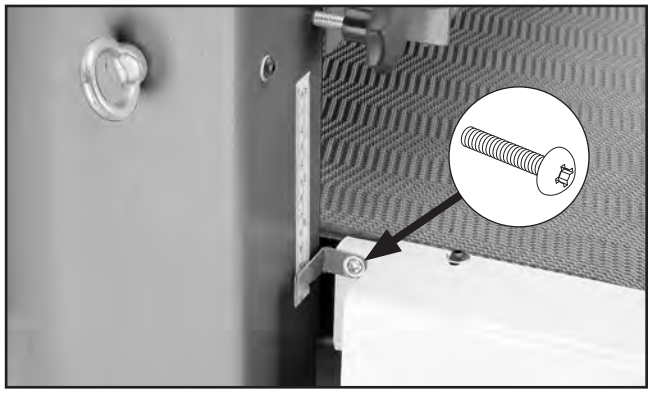


Figure 72. Scale pointer fastener.

Adjusting Dust Scoops

Tools Needed	Qty
Hex Wrench 4mm	1
Wrench/Socket 10mm	1

The dust scoops and metal scoop plates are correctly positioned on the top cover at the factory, however these may loosen and move during shipping. Some trial and error will be needed to adjust the dust scoops so they do not contact the sanding drums.

To adjust dust scoops:

1. DISCONNECT MACHINE FROM POWER!

2. Remove handwheel and open pulley cover.

3. Loosen button head cap screws and acorn nuts securing metal scoop plate to top cover (see **Figure 73**), move scoop up a little, tighten button head cap screws and nuts, close top cover, and rotate V-belt to see if drum contacts scoop.

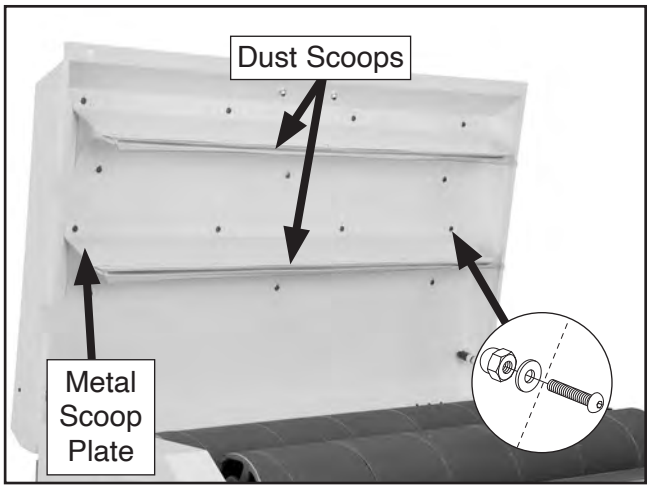


Figure 73. Location of dust scoop components.

4. Adjust each scoop in this manner until sanding drums do not scrape scoops, then close pulley cover and install handwheel.

Adjusting Conveyor Table Lift Screws

The table lift screws are connected by a chain and driven by the conveyor table height handwheel. When the chain is removed from a sprocket on one of the lift screws, that lift screw can adjust that portion of the table up/down independently to assist in setting the table parallel to the drums.

Adjusting the table lift screws will only be necessary if you need to adjust the drum heights more than allowed at the pillow bearing adjustments, or if you have removed the table or chain during a service procedure and you need to reset the drums parallel to the table.

Each tooth on the sprocket represents 0.006" of table elevation movement. For example, if the rear of the table was 0.006" low, rotate both rear table lift screws to the next sprocket tooth in the same chain position. You can easily rotate the sprockets from the top of the table lift screws with a flat head screwdriver.

After adjusting the table lift screws, check to make sure the drums and conveyor are parallel within 0.002" from one side to the other. If they are not within this range, then additional fine adjustments should be made at the drum pillow bearings.

Items Needed	**Qty**
Wrench/Socket 14mm	2
Flat Head Screwdriver	1
Chalk, White-out, or Paint	As Needed

To adjust conveyor table lift screws:

1. DISCONNECT MACHINE FROM POWER!

2. Open side cover.

3. Raise table up to at least 1" mark on depth-of-cut scale.

4. At lift screw that needs to be adjusted, mark end of tooth and chain hole where that tooth is meshed, as shown in **Figure 74**.

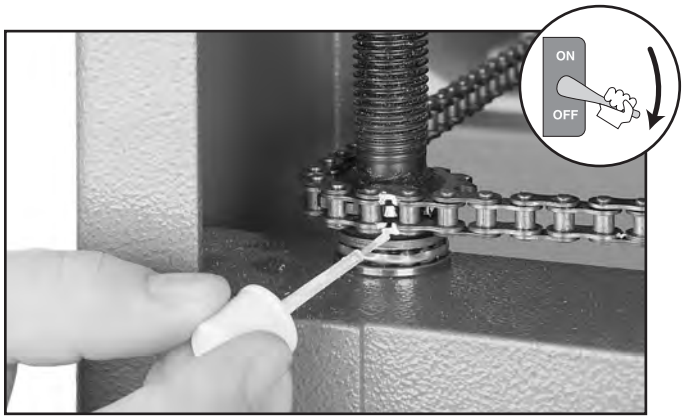


Figure 74. Marking sprocket tooth and chain.

5. Using two 14mm wrenches, loosen adjustable idler sprocket (see **Figure 75**).

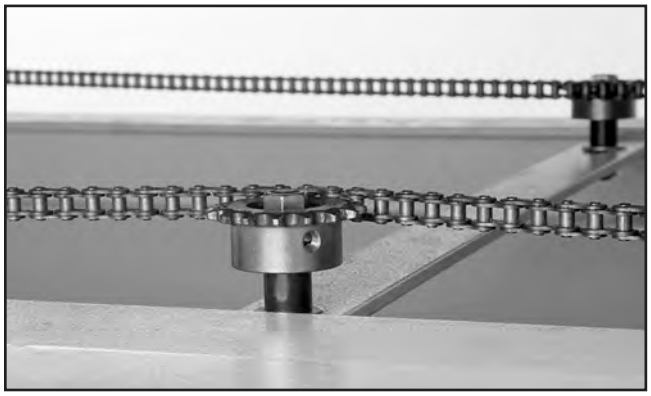


Figure 75. Adjustable idler sprocket.

6. Carefully move chain off marked sprocket only.

7. Keep track of marked chain hole and rotate sprocket necessary number of teeth away from marked one to meet difference in height needed.

8. Fit chain back over sprocket, making sure new sprocket tooth is inserted into marked chain hole.

9. Tension chain and check new height setting.

10. Repeat **Steps 5–9** as needed until table height is parallel to drums at all four corners.

11. Calibrate scale pointer (see **Calibrating Scale Pointer** on **Page 54**).

12. Refer to **Adjusting Drums Parallel to Conveyor Belt** on **Page 51**.

Replacing Conveyor Belt

Replacing the conveyor belt is a big job and requires moderate mechanical skill and a fair amount of patience. For planning purposes, expect to have your machine out of operation for at least a few hours.

As you remove hardware to complete these instructions, we recommend putting all the bolts, screws, washers, etc. back into the holes from which they came. This simple habit will take slightly longer when disassembling the machine, but it will save you a lot of time and reduce frustration during reassembly.

Items Needed	Qty
Additional People	3
Safety Glasses (For Each Person)	1 Ea.
Flashlight or Work Light	1
Hex Wrenches 3, 4, 5, 8mm	1 Ea.
Wrench/Sockets 12, 19mm	1 Ea.
Wrenches/Sockets 14mm	2
Wrenches 10, 13mm	1 Ea.
Phillips Head Screwdriver	1
Measuring Tape	1
Gauge Blocks (see **Page 44**)	2
Feeler Gauge Set	1
Conveyor Belt (P0449405)	1

To replace conveyor belt:

1. DISCONNECT MACHINE FROM POWER!

2. Remove top cover and table height handwheel, then open pulley cover.

3. Remove V-belts. Drum sander should now look similar to **Figure 76**.

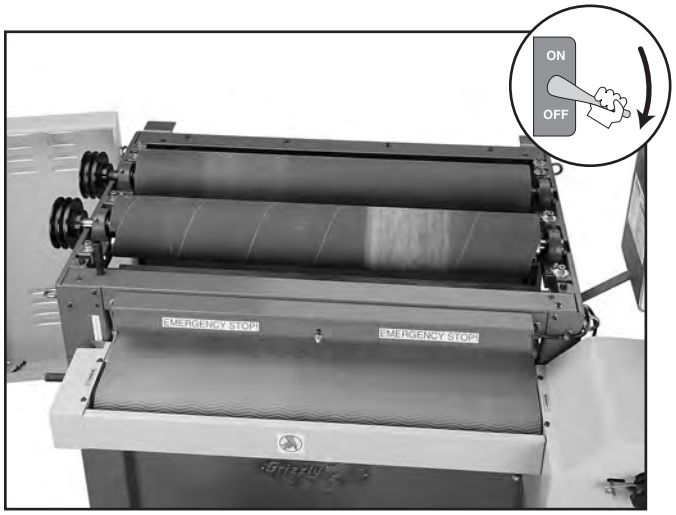


Figure 76. Drum sander with handwheel, top cover, and V-belts removed.

4. Remove sanding drums (4 lock nuts and flat washers on each drum).

5. Place gauge blocks face down, as shown in **Figure 77**, raise table to relieve spring pressure on pressure rollers, remove pressure roller nuts, then lower table to remove pressure rollers.

6. Remove front and rear upper frame angles (see **Figure 77**).

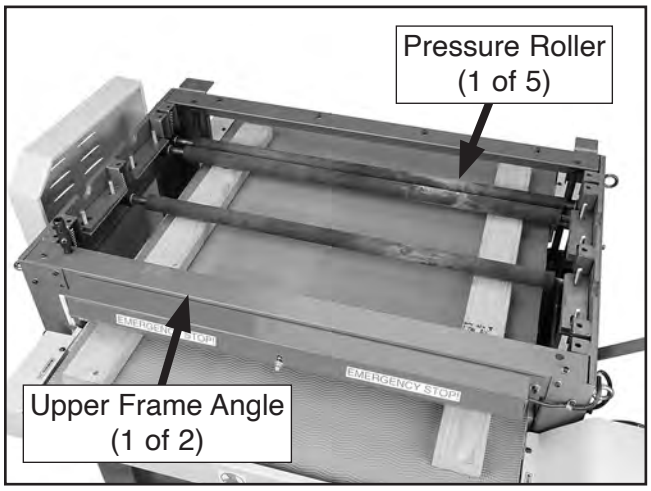


Figure 77. Gauge blocks set under pressure rollers to relieve spring tension.

7. Remove table height lock knob.

8. Remove feed motor cover (4 button head screws and set screw on knob).

9. Remove front conveyor guard (4 button head screws) and cord clamp, and set front conveyor guard off to side of machine.

10. Remove rear conveyor end guards (4 button head screws). Drum sander should now look similar to **Figure 78**.

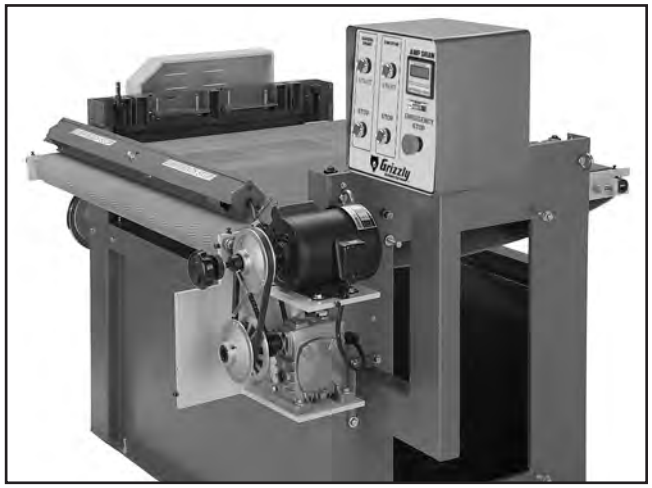


Figure 78. Example of frame supports and guards removed.

11. Raise table up to 1" mark on scale.

12. Mark position of chain and sprockets.

13. Loosen chain idler sprocket, carefully pull chain off all sprockets, and remove it from cabinet by removing chain master link, as shown in **Figure 79**.

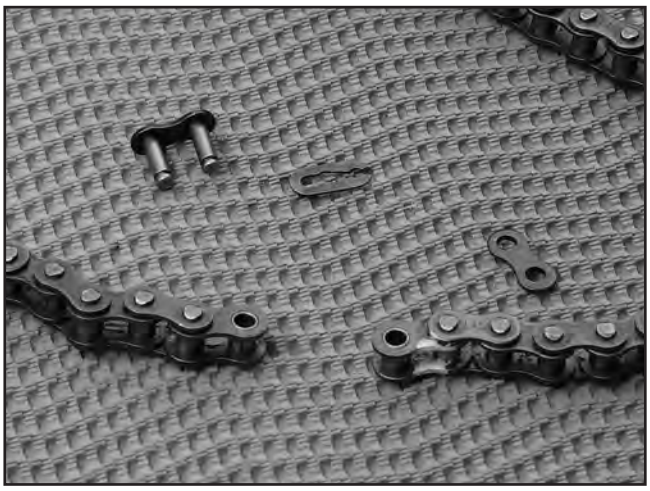


Figure 79. Chain removed from table.

14. Loosen conveyor belt from rear adjustments, as shown in **Figure 80**.

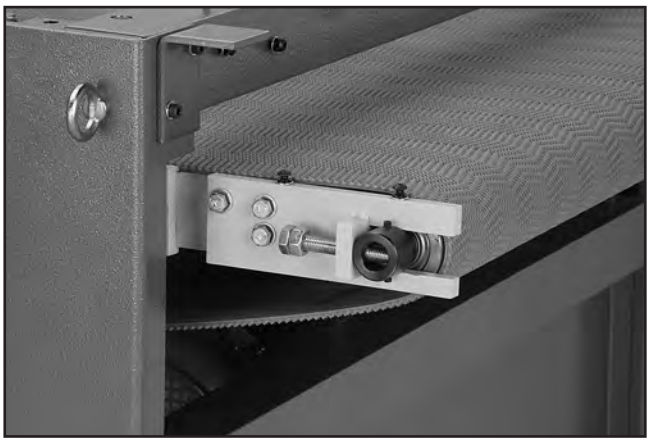


Figure 80. Conveyor belt loosened.

15. Remove control panel and set it to side without disconnecting any wiring.

16. Loosen strain relief on conveyor motor cord, and disconnect wiring inside conveyor motor junction box.

17. Remove conveyor feed motor. Sander should now be disassembled as shown in **Figure 81**.

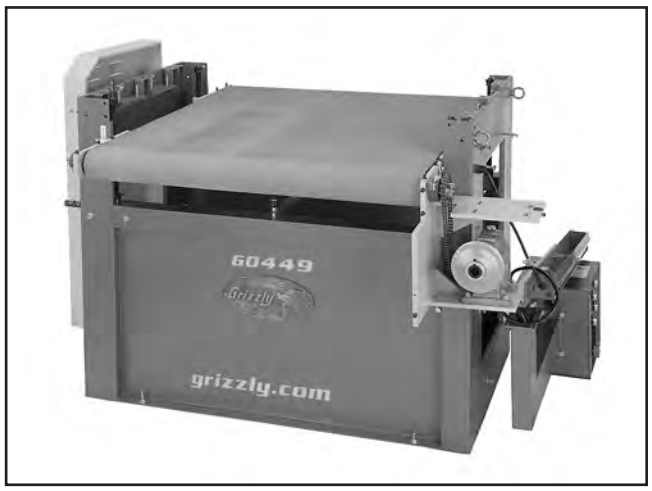


Figure 81. Drum sander disassembled for table removal.

18. With help, carefully lift table off of drum sander cabinet, as shown in **Figure 82**.

Note: *When removing table, be careful with ball thrust bearings located under table lift screws (part #378 in parts drawing), as they can be easily knocked onto ground.*

Figure 82. Lifting table off drum sander cabinet.

19. Remove brackets from left side of table and remove conveyor belt (see **Figure 83**).

Note: *Leave front pillow bearing connected to bracket, but disconnect bracket from table.*

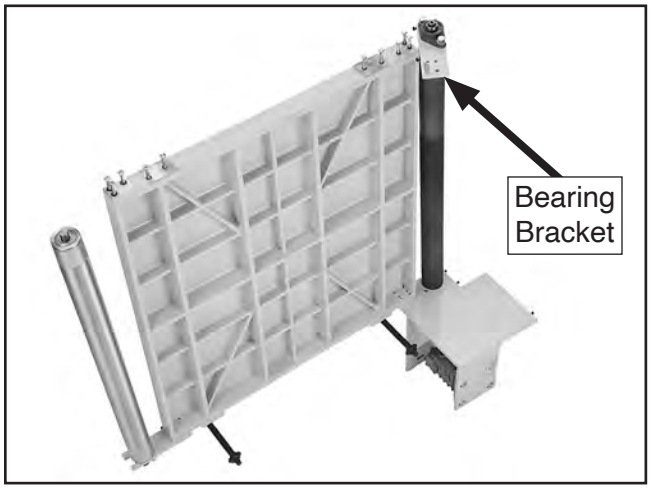


Figure 83. Conveyor belt removed from table.

20. Install new conveyor belt and reassemble drum sander by reversing disassembly steps.

21. After reassembly, adjust drums and pressure rollers to their proper settings. See **Aligning Drums** on **Page 48** and **Adjusting Pressure Roller Height** on **Page 53**.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

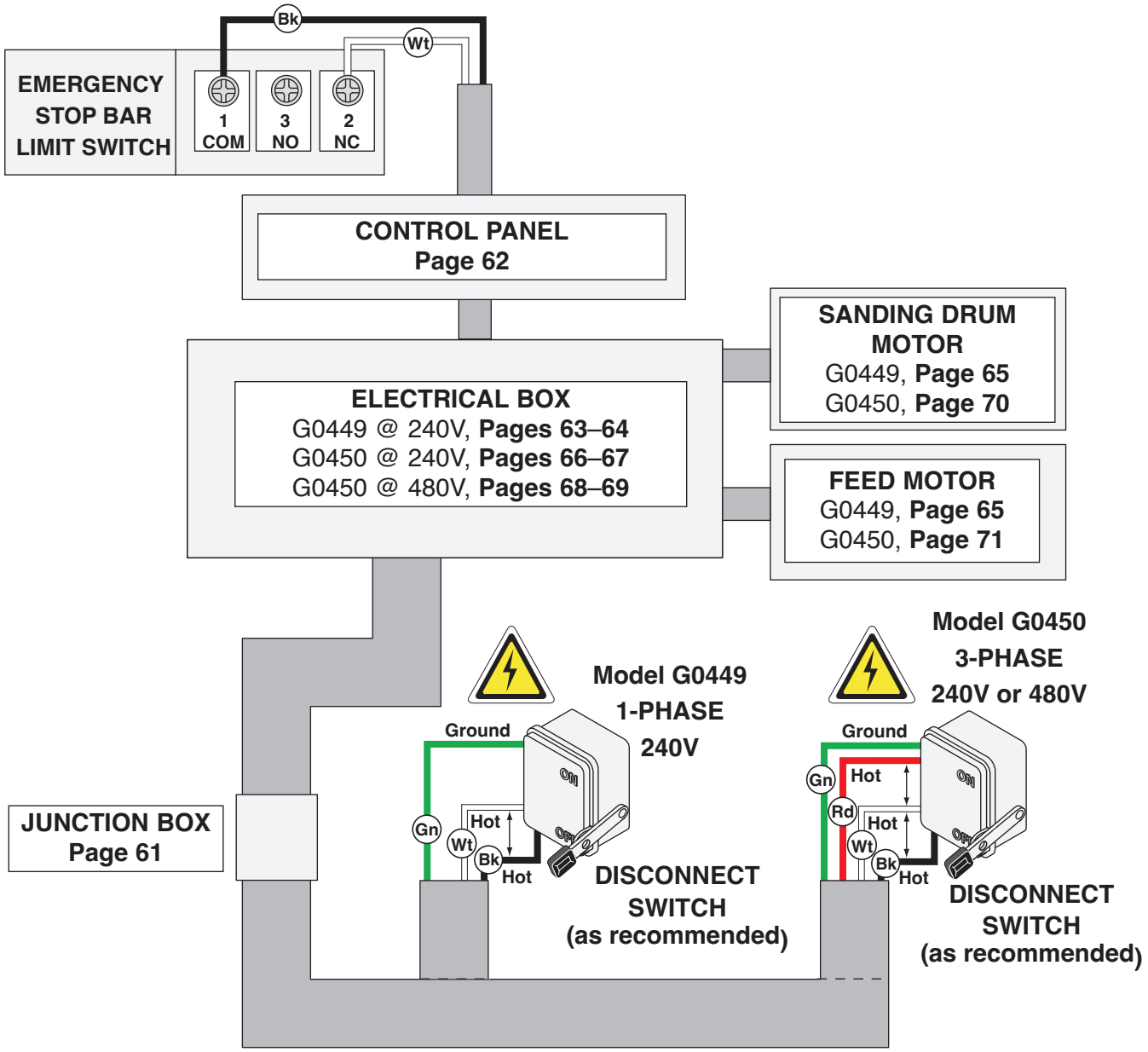
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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

G0449/G0450 Wiring Overview

Figure 84. Emergency stop bar limit switch.



G0449 Junction Box

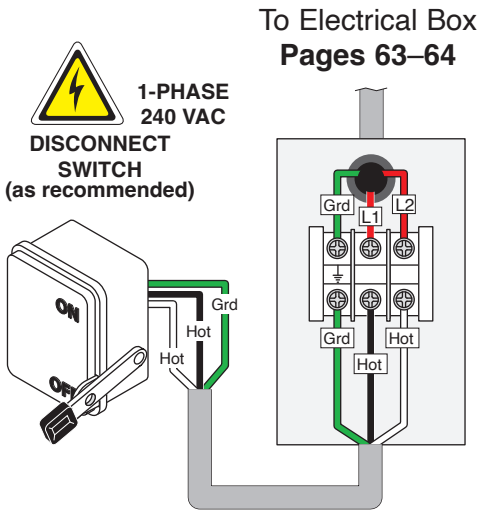
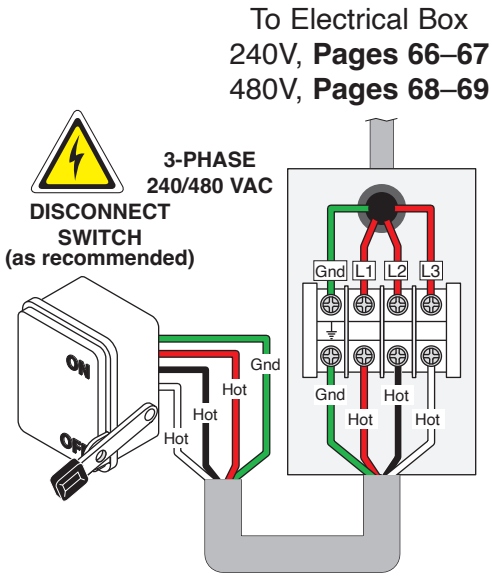


Figure 85. G0449 power junction box.

G0450 Junction Box



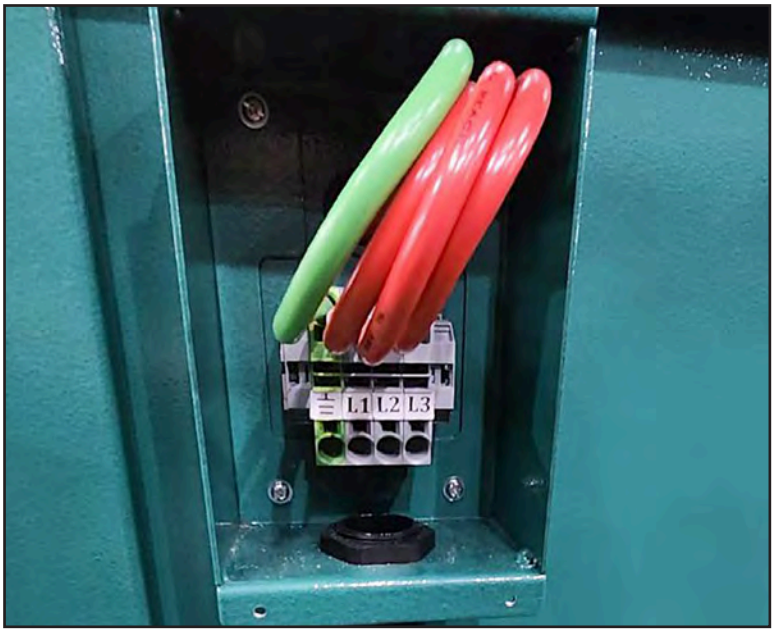
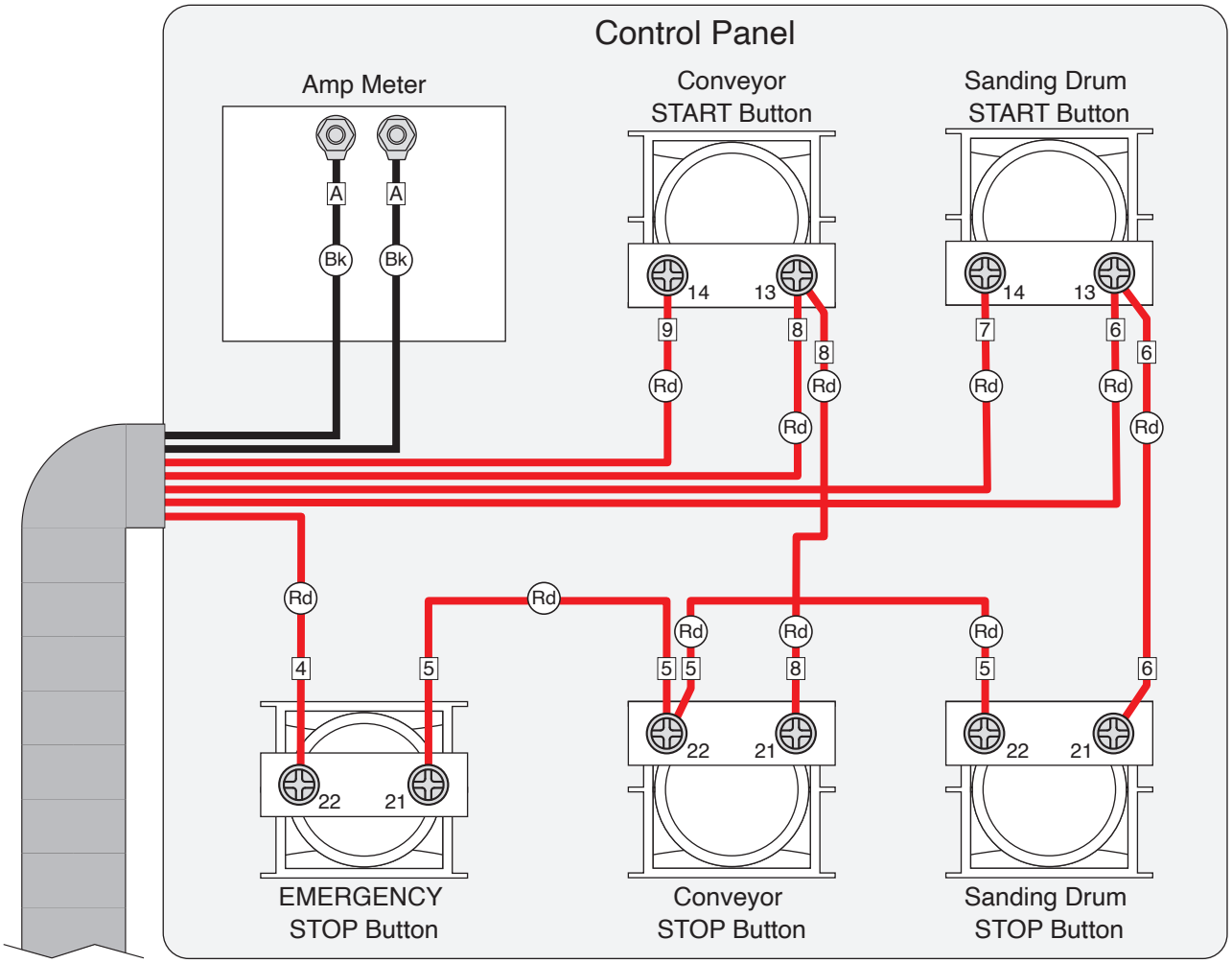


Figure 86. G0450 power junction box.

G0449/G0450 Control Panel



To Electrical Box
G0449 @ 240V, **Pages 63–64**
G0450 @ 240V, **Pages 66–67**
G0450 @ 480V, **Pages 68–69**

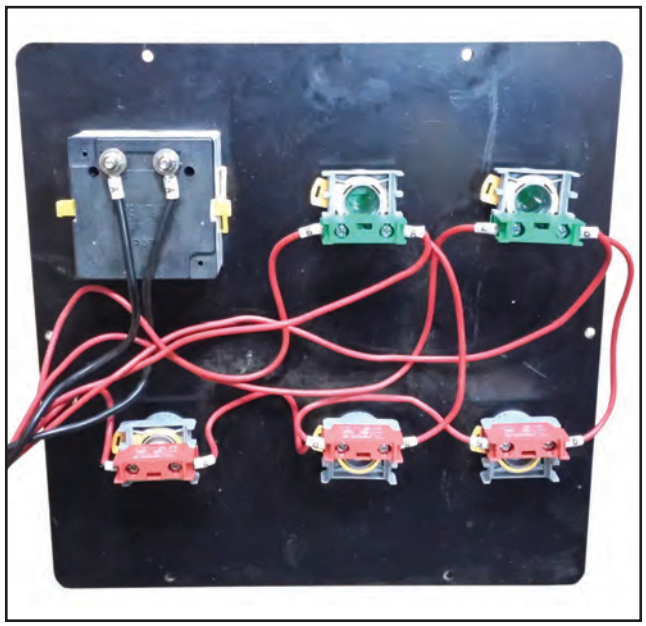


Figure 87. G0449/G0450 control panel.

READ ELECTRICAL SAFETY ON PAGE 59!

G0449 Electrical Box 240V

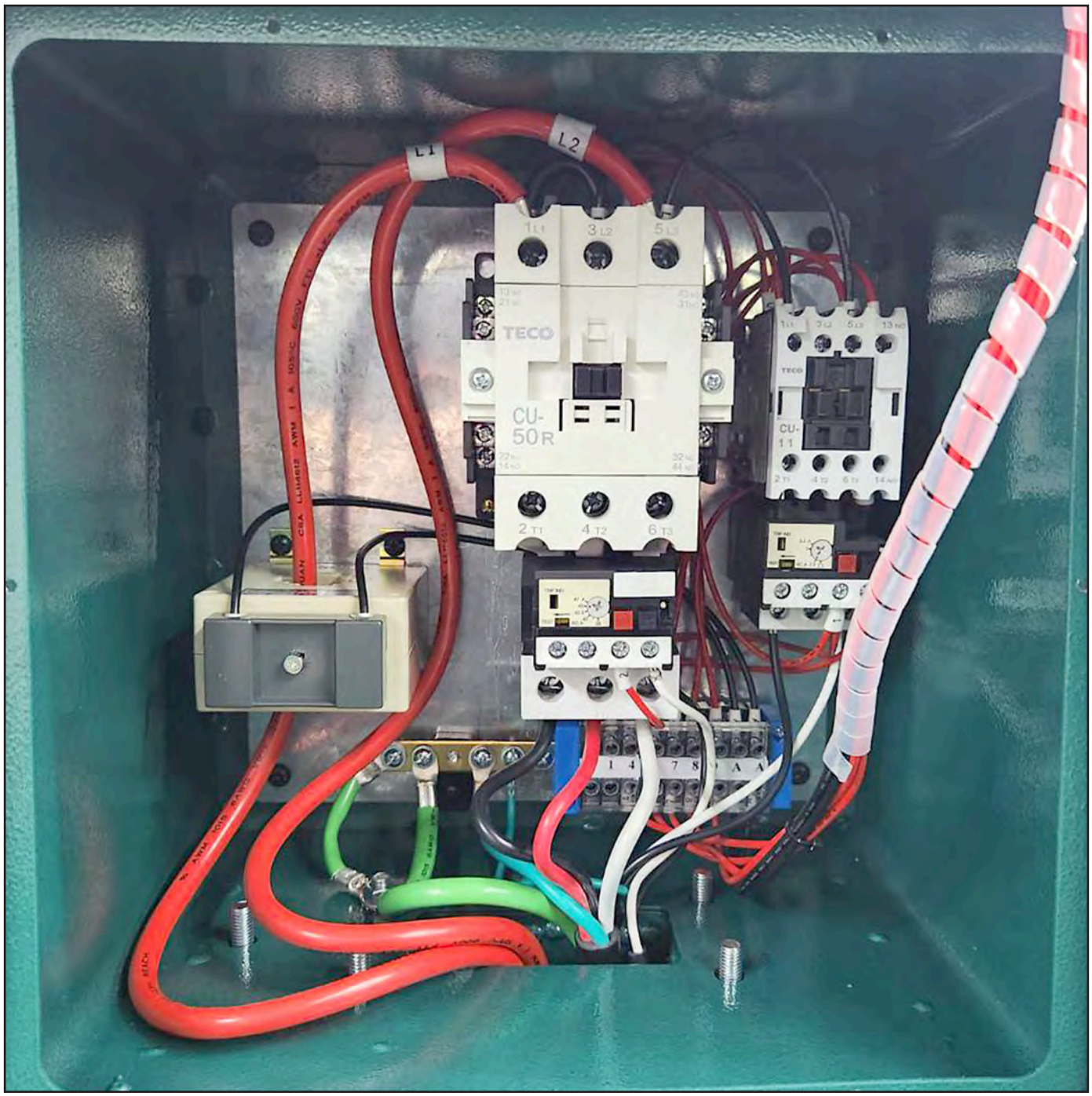
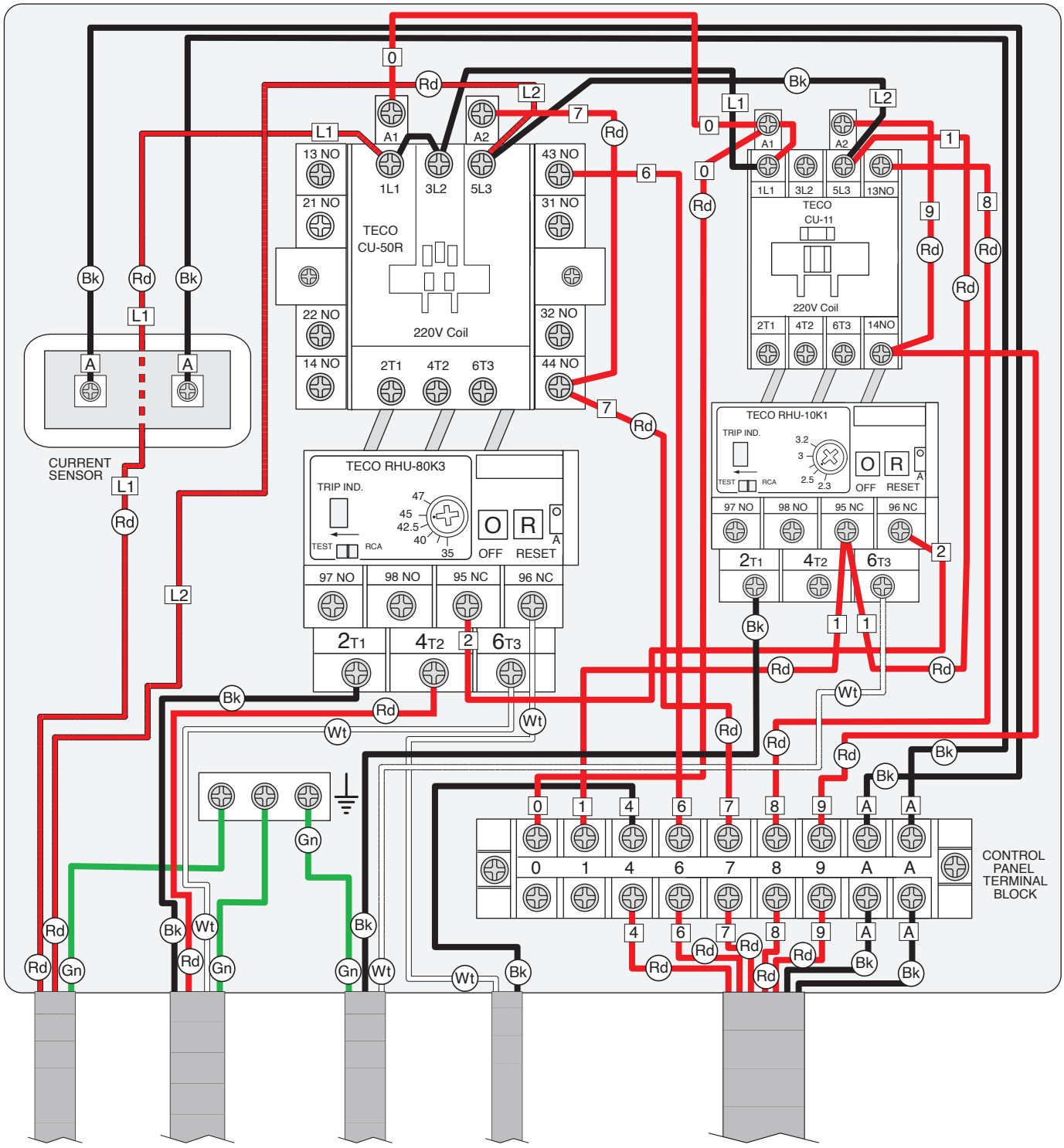


Figure 88. G0449 electrical box.

G0449 Electrical Box Wiring 240V



READ ELECTRICAL SAFETY ON PAGE 59!

G0449 Sanding & Feed Motors

Figure 89. G0449 sanding drum motor wiring and start capacitors.

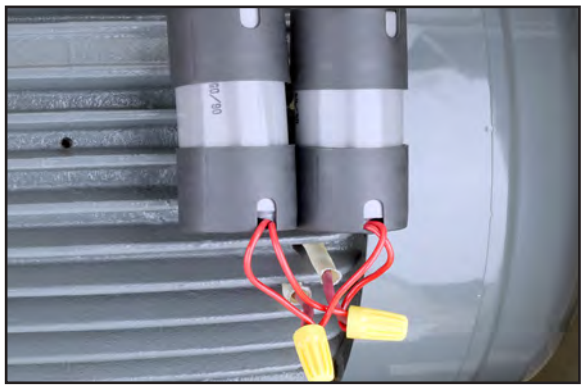


Figure 90. G0449 sanding drum motor run capacitors.

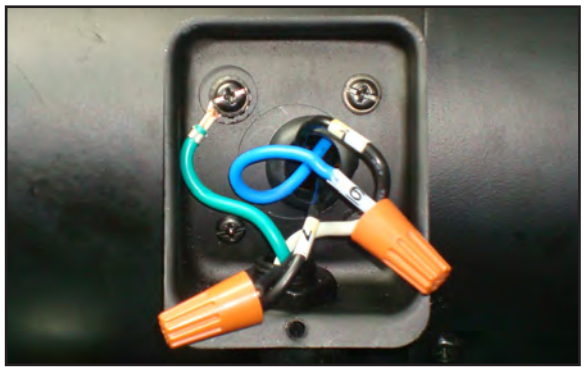


Figure 91. G0449 feed motor wiring.

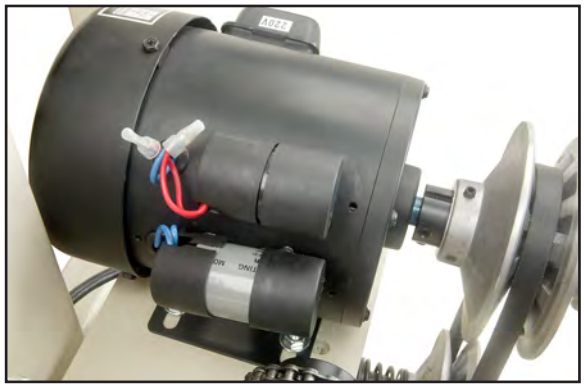
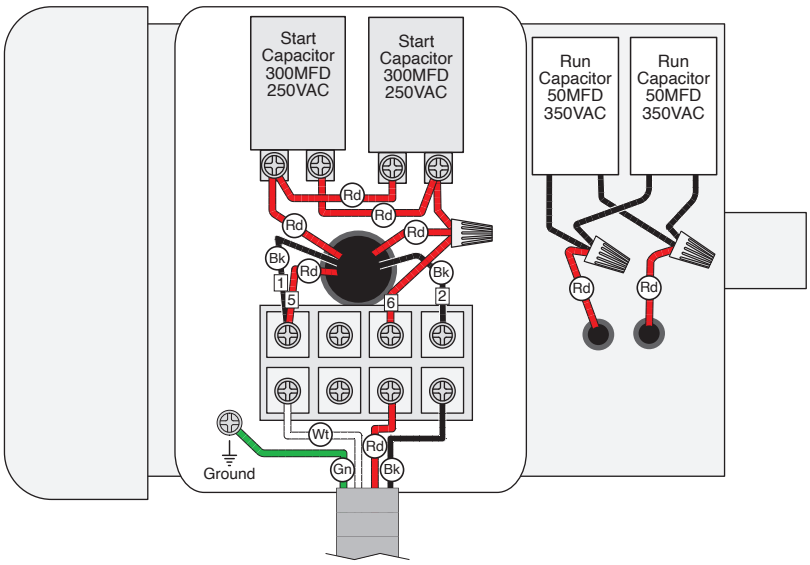
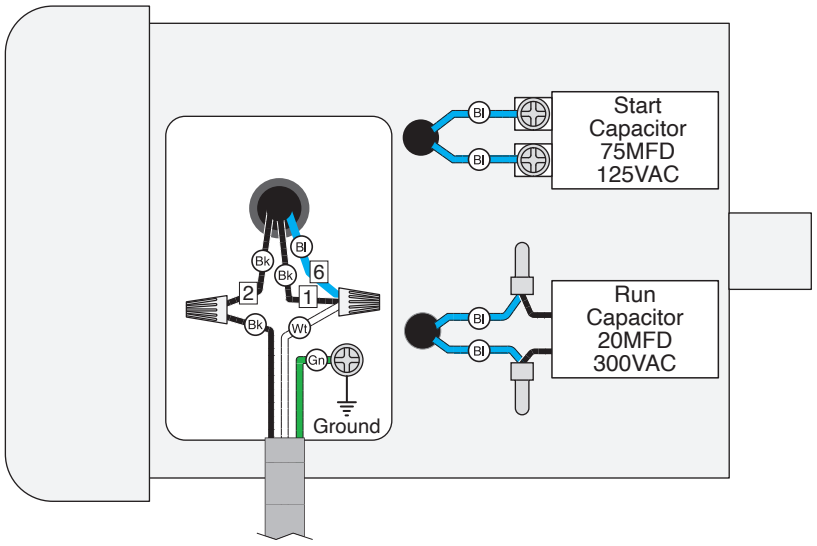


Figure 92. G0449 feed motor capacitors.



To Electrical Box
Page 64



To Electrical Box
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G0450 Electrical Box 240V

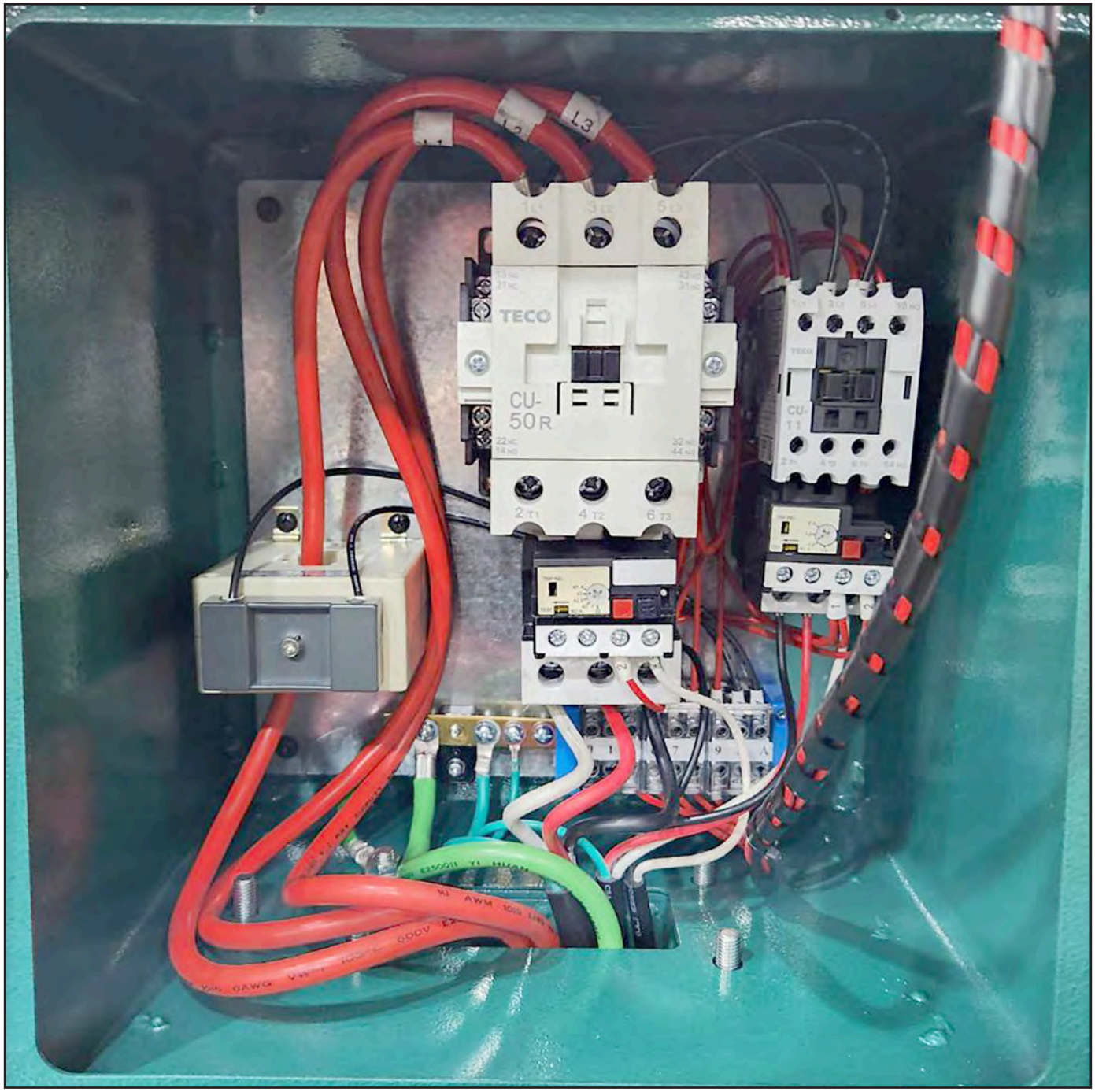
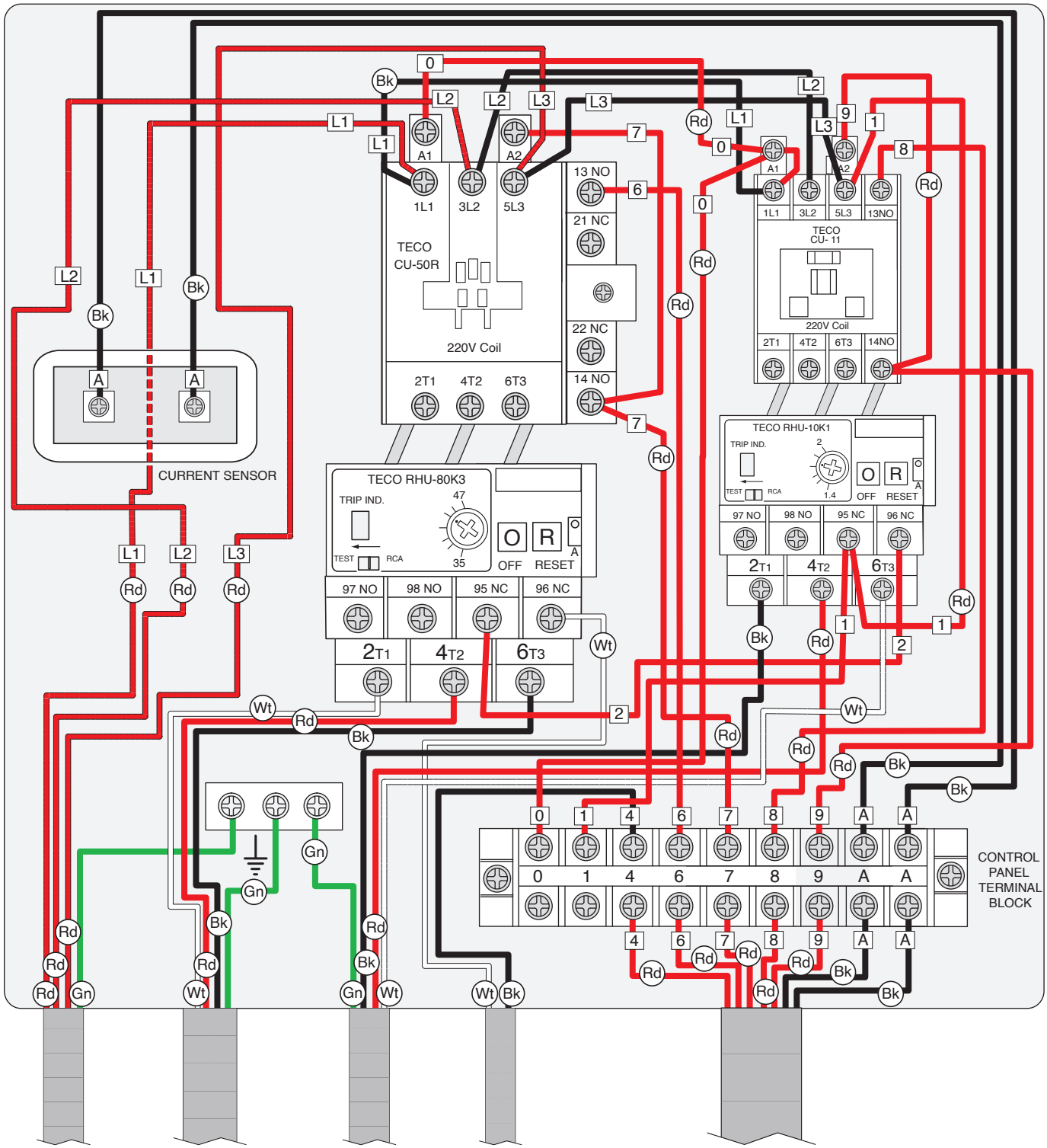


Figure 93. G0450 240V 3-phase electrical box wiring.

READ ELECTRICAL SAFETY ON PAGE 59!

G0450 Electrical Box Wiring 240V



G0450 Electrical Box 480V

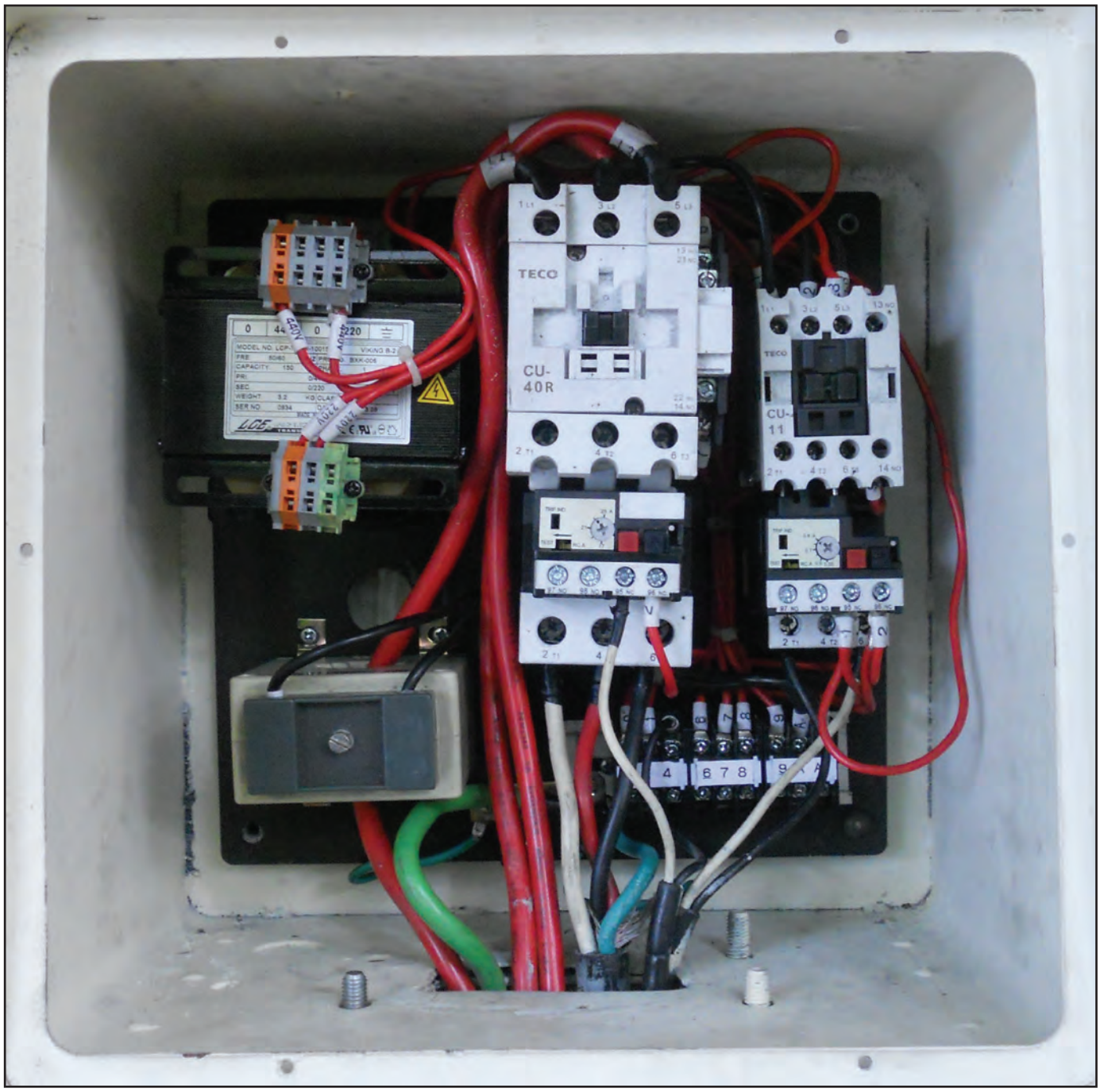
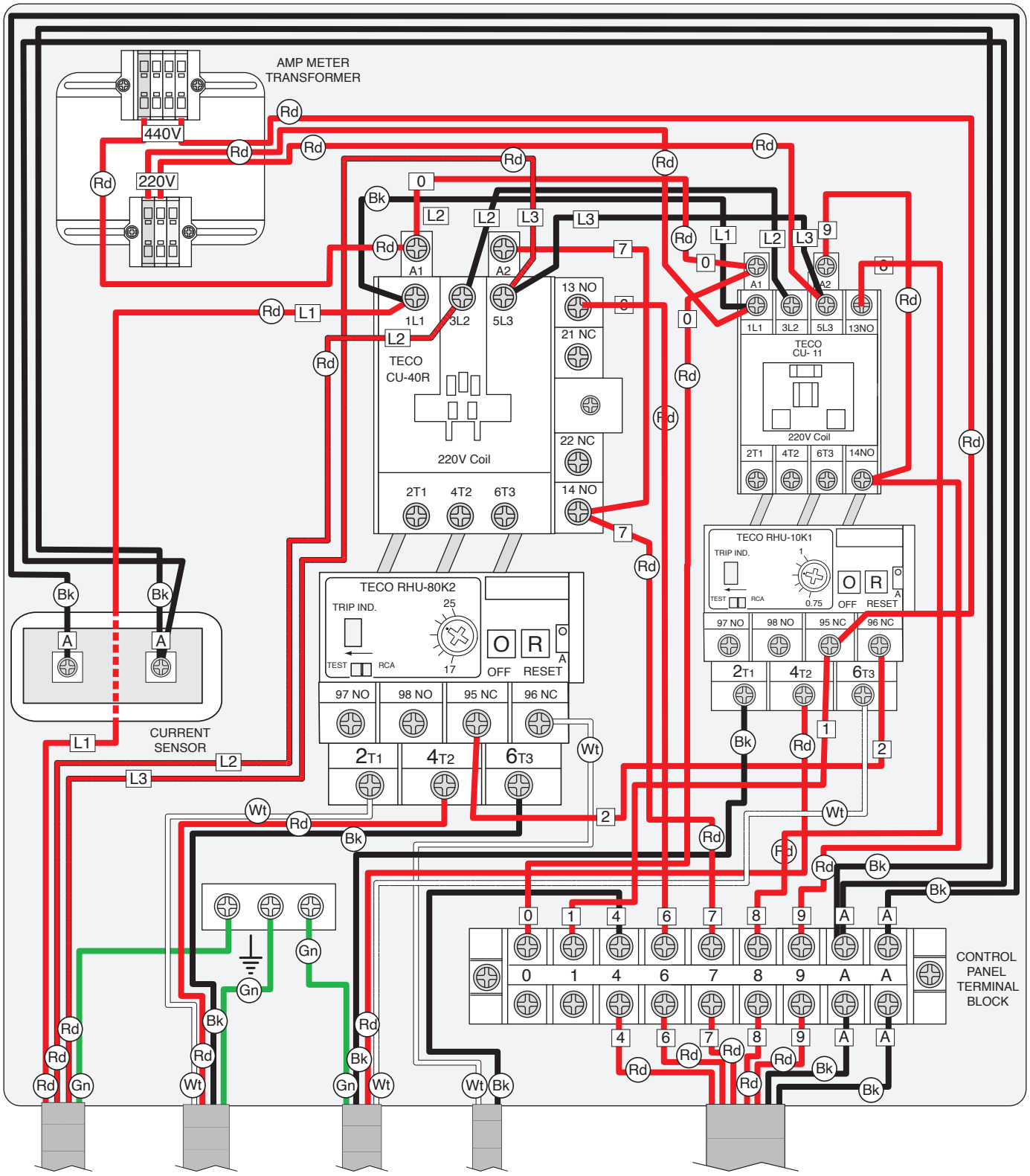


Figure 94. G0450 480V 3-phase electrical box wiring.

G0450 Electrical Box Wiring 480V



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To Sanding Drum Motor **Page 70**

To Feed Motor **Page 71**

To Emergency Stop Bar Limit Switch **Page 60**

To Control Panel **Page 62**

READ ELECTRICAL SAFETY ON PAGE 59!

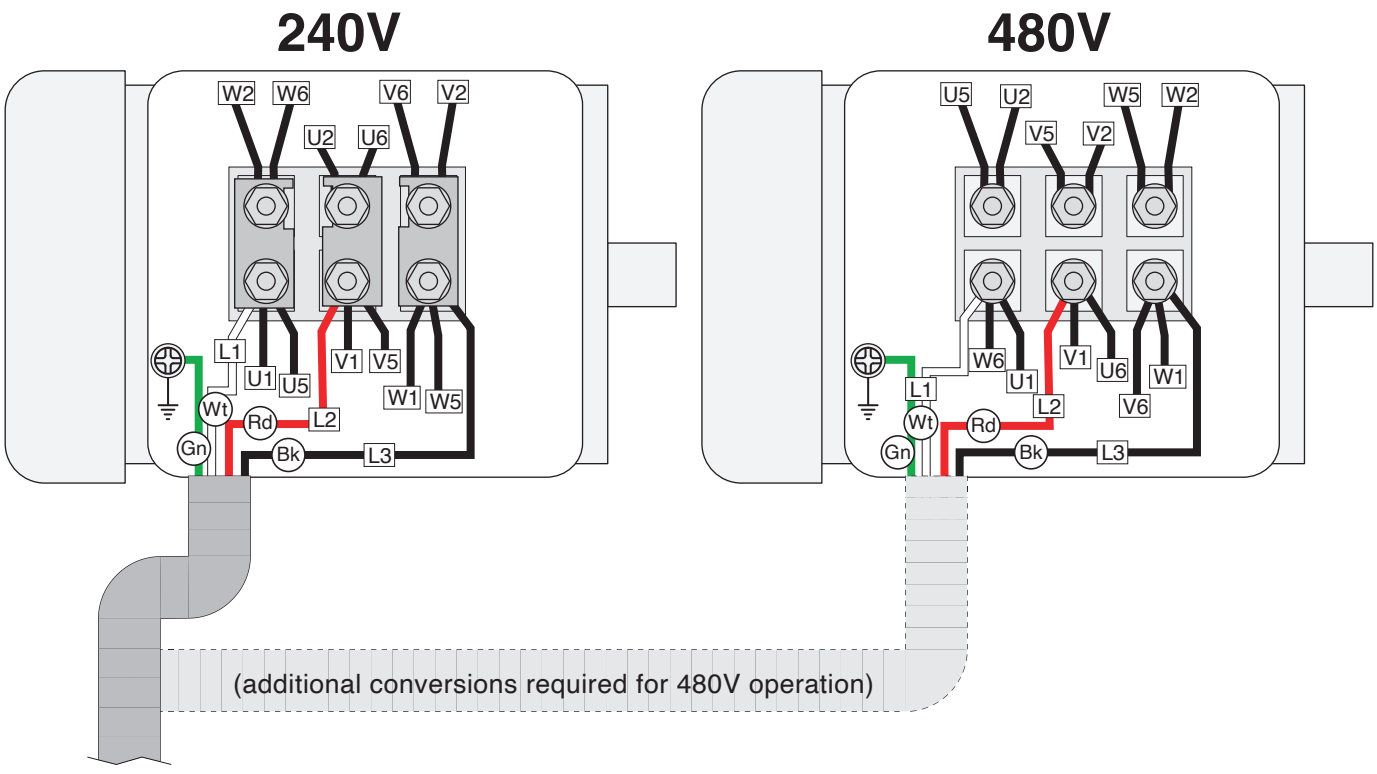
G0450 Sanding Drum Motor

Figure 95. G0450 240V sanding drum motor wiring.

Figure 96. G0450 480V sanding drum motor wiring.

NOTICE

The motor wiring shown here is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.



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480V **Page 69**

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G0450 Feed Motor

Figure 97. G0450 240V feed motor wiring.

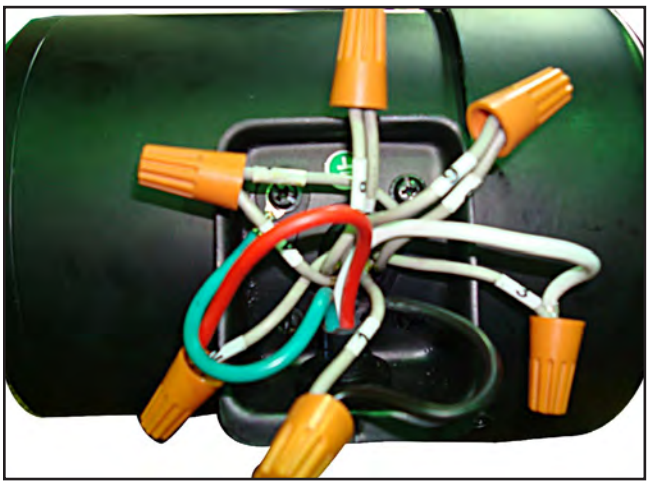
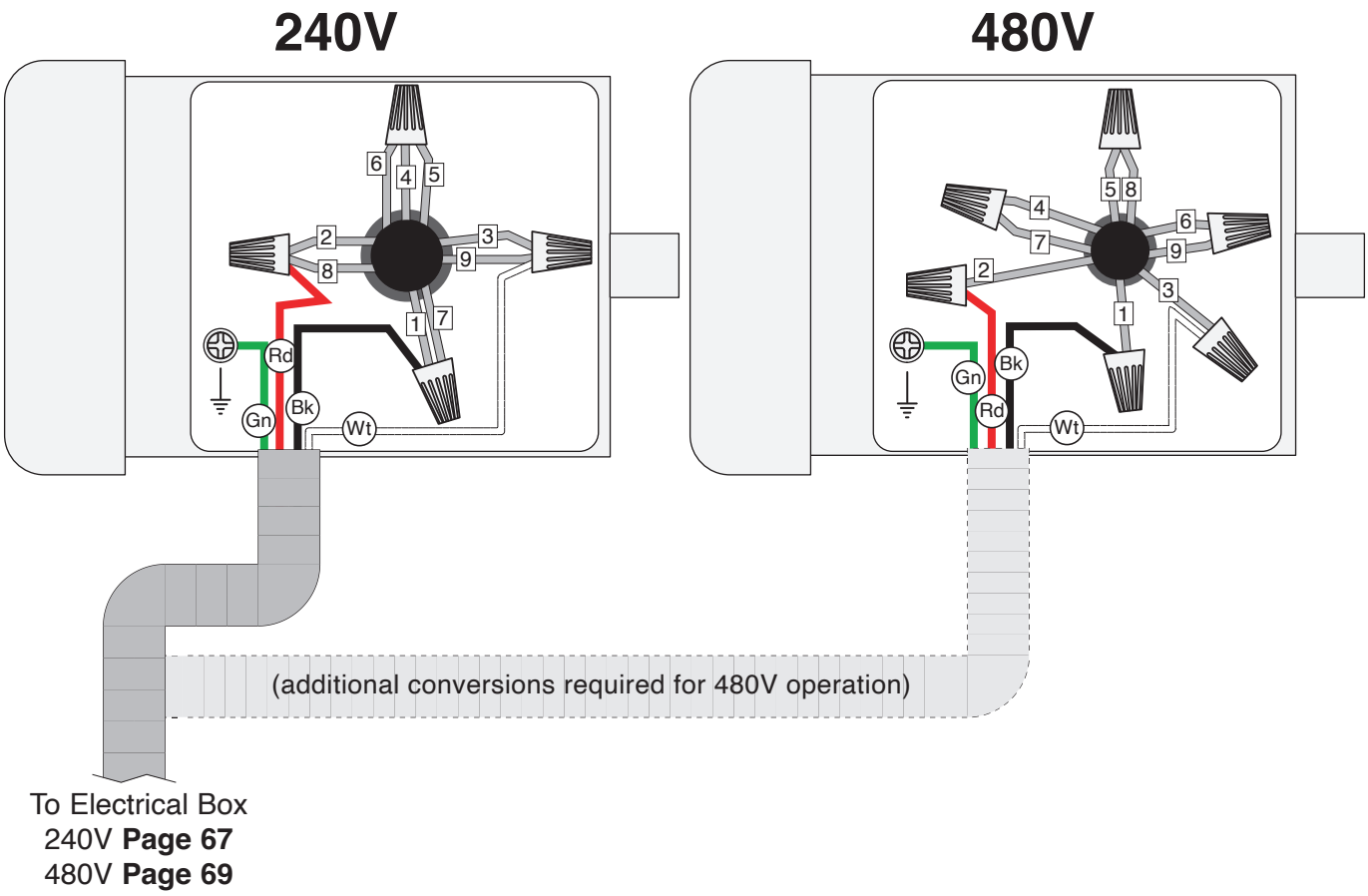


Figure 98. G0450 480V feed drum motor wiring.

NOTICE

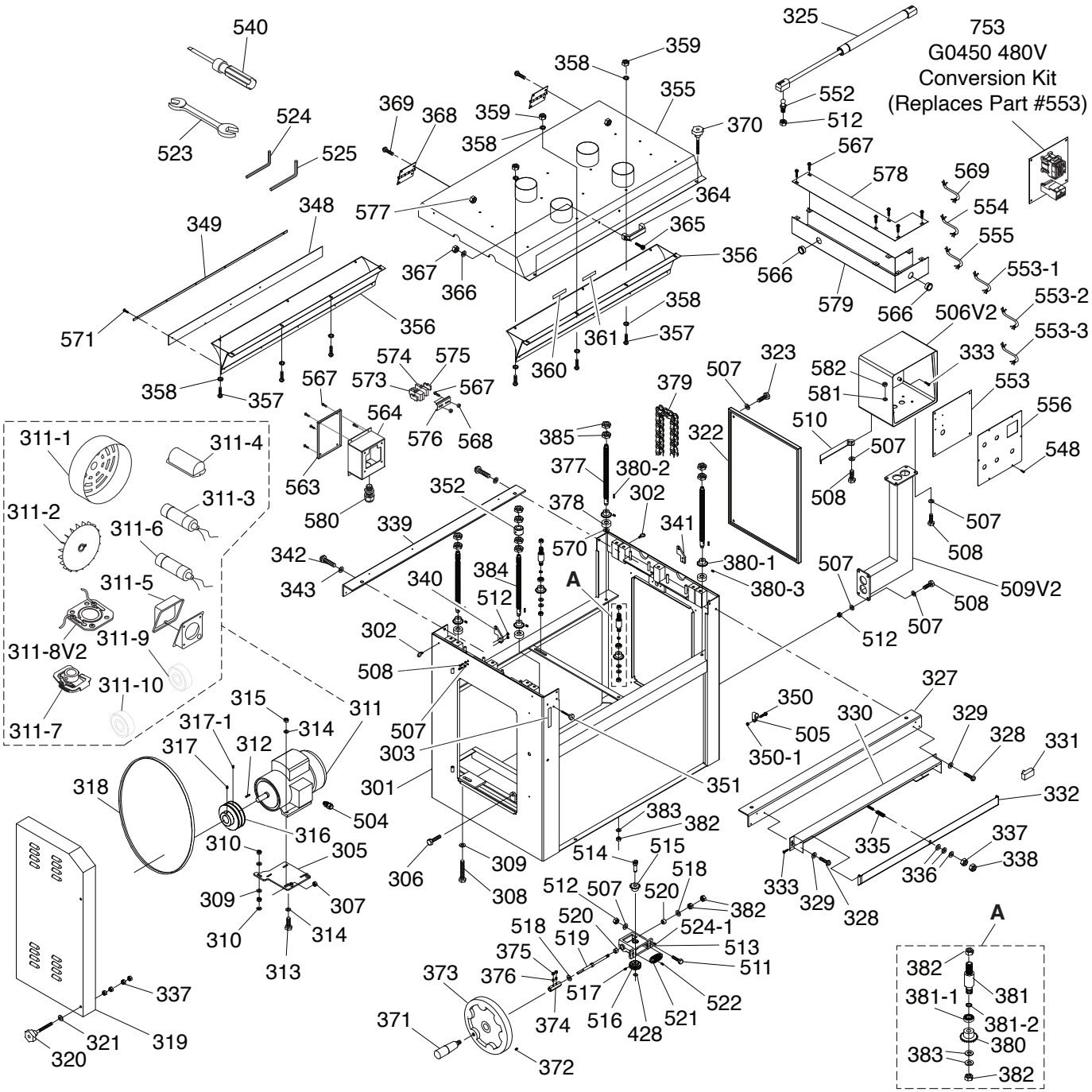
The motor wiring shown here is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.



SECTION 9: PARTS

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

Frame



Frame Parts List

REF	PART #	DESCRIPTION
301	P0449301	FRAME
302	P0449302	LIFTING EYE BOLT 1/2-13
303	P0449303	ELEVATION SCALE
305	P0449305	MOTOR MOUNT
306	P0449306	HEX BOLT M12-1.75 X 35
307	P0449307	HEX NUT M12-1.75
308	P0449308	HEX BOLT M12-1.75 X 120
309	P0449309	FLAT WASHER 12MM
310	P0449310	HEX NUT M12-1.75
311	P0449311	SANDING MOTOR 10HP 240V 1-PH (G0449)
311	P0450311	SANDING MOTOR 15HP 240/480V 3-PH (G0450)
311-1	P0449311-1	MOTOR FAN COVER (G0449)
311-1	P0450311-1	MOTOR FAN COVER (G0450)
311-2	P0449311-2	MOTOR FAN (G0449)
311-2	P0450311-2	MOTOR FAN (G0450)
311-3	P0449311-3	R CAPACITOR 50M 350V 1-3/4 X 3-5/16 (G0449)
311-4	P0449311-4	CAPACITOR COVER (G0449)
311-5	P0449311-5	MOTOR JUNCTION BOX (G0449)
311-5	P0450311-5	MOTOR JUNCTION BOX (G0450)
311-6	P0449311-6	S CAPACITOR 300M 250V 1-3/4 X 3-3/4 (G0449)
311-7	P0449311-7	CENTRIFUGAL SWITCH (G0449)
311-8V2	P0449311-8V2	CONTACT POINTS 2PC V2.08.07 (G0449)
311-9	P0449311-9	BALL BEARING 6308-2RS
311-10	P0449311-10	BALL BEARING 6206-2RS
312	P0449312	KEY 8 X 10 X 75
313	P0449313	HEX BOLT M10-1.5 X 45
314	P0449314	FLAT WASHER 10MM
315	P0449315	HEX NUT M10-1.5
316	P0449316	SANDING MOTOR PULLEY
317	P0449317	SET SCREW M8-1.25 X 10
317-1	P0449317-1	SET SCREW M8-1.25 X 20
318	P0449318	V-BELT B69
319	P0449319	BELT COVER
320	P0449320	KNOB BOLT M6-1 X 105
321	P0449321	FLAT WASHER 6MM
322	P0449322	SIDE PANEL
323	P0449323	HEX BOLT M8-1.25 X 30
325	P0449325	GAS STRUT
327	P0449327	FRONT UPPER FRAME ANGLE
328	P0449328	BUTTON HD CAP SCR M6-1 X 12
329	P0449329	FLAT WASHER 6MM
330	P0449330	MOUNTING BRACKET
331	P0449331	EMERGENCY STOP SWITCH MJ2-1307
332	P0449332	EMERGENCY STOP BAR
333	P0449333	BUTTON HD CAP SCR M6-1 X 10
335	P0449335	COMPRESSION SPRING
336	P0449336	FLAT WASHER 6MM
337	P0449337	HEX NUT M6-1
338	P0449338	HEX NUT M6-1
339	P0449339	REAR UPPER FRAME ANGLE
340	P0449340	SUPPORT PLATE (LH)
341	P0449341	SUPPORT PLATE (RH)

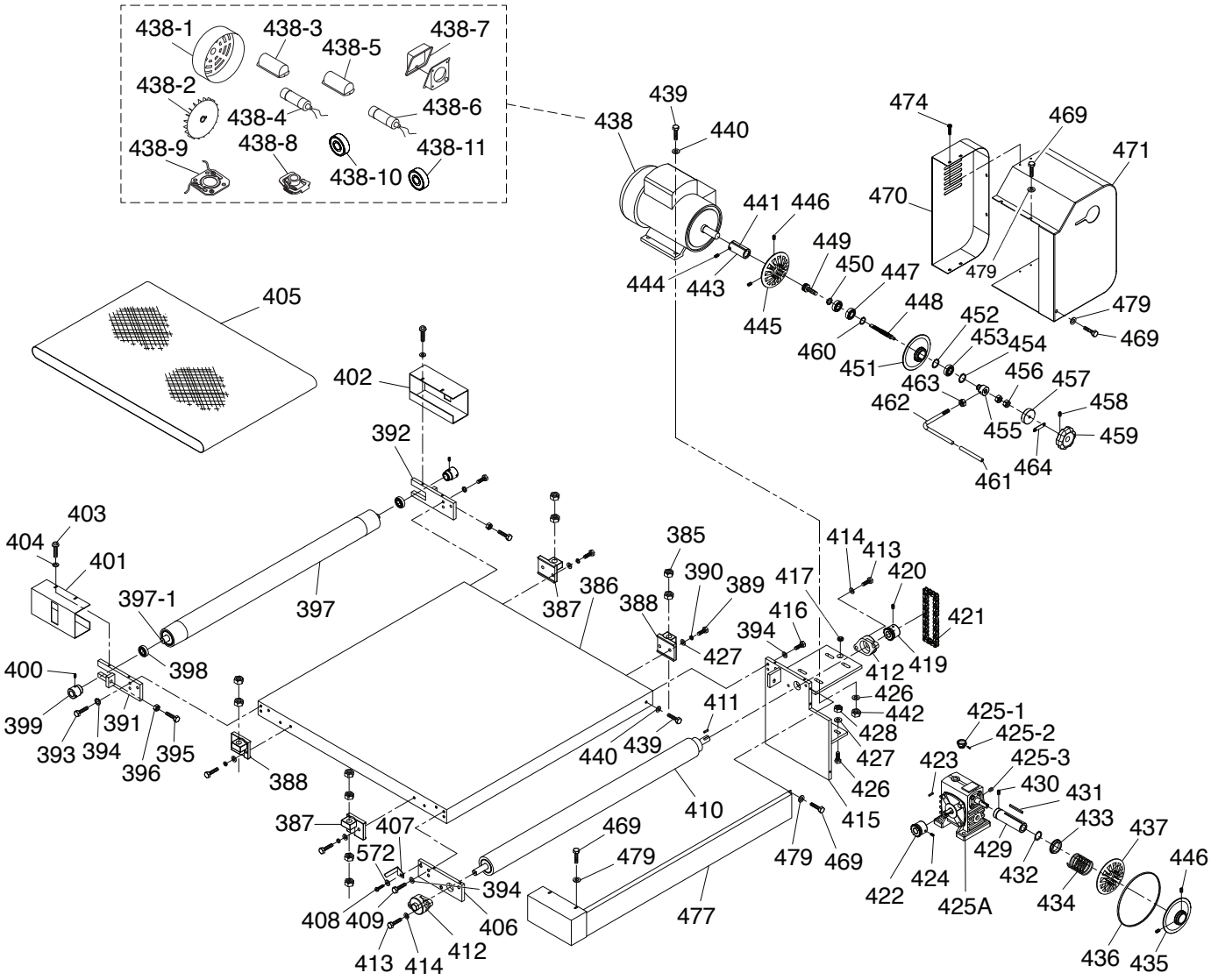
REF	PART #	DESCRIPTION
342	P0449342	CAP SCREW M6-1 X 12
343	P0449343	FLAT WASHER 6MM
348	P0449348	RUBBER PLATE 1005 X 65 X 2MM
349	P0449349	PLATE
350	P0449350	PHLP HD SCR 10-24 X 1/2
350-1	P0449350-1	HEX NUT 10-24
351	P0449351	KNOB M8-1.25 X 55
352	P0449352	LOCK BUSHING
355	P0449355	TOP COVER
356	P0449356	FRONT DUST SCOOP
357	P0449357	BUTTON HD CAP SCR M6-1 X 10
358	P0449358	FLAT WASHER 6MM
359	P0449359	ACORN NUT M6-1
360	P0449360	ADHESIVE FOAM STRIP 15 X 95
361	P0449361	ADHESIVE FOAM STRIP 15 X 130
364	P0449364	HANDLE
365	P0449365	CAP SCREW 5/16-18 X 3/4
366	P0449366	FLAT WASHER 5/16
367	P0449367	HEX NUT 5/16-18
368	P0449368	HINGE
369	P0449369	BUTTON HD CAP SCR M6-1 X 12
370	P0449370	KNOB BOLT M6-1 X 12
371	P0449371	HANDWHEEL HANDLE
372	P0449372	SET SCREW 3/8-16 X 1/2
373	P0449373	HANDWHEEL
374	P0449374	HANDWHEEL SLEEVE
375	P0449375	SET SCREW M6-1 X 10
376	P0449376	HEX NUT M6-1
377	P0449377	LIFT SCREW M20-2.5
378	P0449378	THRUST BEARING 51103
379	P0449379	CHAIN 3/8" PITCH
380	P0449380	SPROCKET
380-1	P0449380-1	SPROCKET
380-2	P0449380-2	KEY 5 X 5 X 20
380-3	P0449380-3	SET SCREW 1/4-20 X 1/4
381	P0449381	SHAFT
381-1	P0449381-1	BALL BEARING 6000-2RS
381-2	P0449381-2	INT RETAINING RING 10MM
382	P0449382	HEX NUT M10-1.5
383	P0449383	FLAT WASHER 10MM
384	P0449384	DRIVING LIFT SCREW M20-2.5
385	P0449385	HEX NUT M20-2.5
428	P0449428	EXT RETAINING RING 11MM
504	P0449504	MOTOR JUNCTION BOX STRAIN RELIEF
505	P0449505	CABLE CLAMP
506V2	P0449506V2	ELECTRICAL BOX V2.08.13
507	P0449507	FLAT WASHER 8MM
508	P0449508	HEX BOLT M8-1.25 X 25
509V2	P0449509V2	CONTROL PANEL PEDESTAL ARM V2.08.13
510	P0449510	SUPPORT STRAP
511	P0449511	HEX BOLT M8-1.25 X 30
512	P0449512	HEX NUT M8-1.25

Frame Parts List (Cont.)

REF	PART #	DESCRIPTION
513	P0449513	GEARBOX
514	P0449514	CONNECTING SHAFT
515	P0449515	BUSHING
516	P0449516	GEAR 20T
517	P0449517	SET SCREW M6-1 X 10
518	P0449518	FLAT WASHER 10MM
519	P0449519	WORM SHAFT
520	P0449520	BUSHING
521	P0449521	WORM GEAR
522	P0449522	SET SCREW M6-1 X 6
523	P0449523	WRENCH 12 X 14MM OPEN-ENDS
524	P0449524	HEX WRENCH 4MM
524-1	P0449524-1	SET SCREW M6-1 X 10
525	P0449525	HEX WRENCH 5MM
540	P0449540	SCREWDRIVER PHILLIPS #2
548	P0449548	PHLP HD SCR M4-.7 X 10
552	P0449552	GAS STRUT PIVOT SCREW
553	P0449553	ELECTRICAL PANEL
553-1	P0449553-1	SANDING MOTOR CORD 10G 4W 98"
553-2	P0449553-2	FEED MOTOR CORD 14G 3W 79"
553-3	P0449553-3	CORD 16G 2W 98"
554	P0449554	CORD 6G 3W 98"

REF	PART #	DESCRIPTION
555	P0449555	GROUND WIRE 8G 1C 2.5" (GREEN)
556	P0449556	CONTROL PANEL PLATE
563	P0449563	POWER JUNCTION BOX COVER
564	P0449564	POWER JUNCTION BOX
566	P0449566	STRAIN RELIEF LT STRAIGHT
567	P0449567	FLANGE SCREW M5-.8 X 10
568	P0449568	HEX NUT M5-.8
569	P0449569	CORD 6G 3W 86"
570	P0449570	FLAT WASHER 16MM
571	P0449571	BUTTON HD CAP SCR M6-1 X 10
573	P0449573	TERMINAL BAR 1P
574	P0449574	GROUND TERMINAL BAR 1P
575	P0449575	TERMINAL BAR LOCKING SEGMENT
576	P0449576	TERMINAL BAR MOUNT
577	P0449577	HEX NUT M6-1
578	P0449578	POWER CORD CONDUIT COVER
579	P0449579	POWER CORD CONDUIT
580	P0449580	STRAIN RELIEF PGB 29-25 ST PLASTIC
581	P0449581	EXT TOOTH WASHER 5/16
582	P0449582	HEX NUT 5/16
753	P0450753	480V CONVERSION KIT (G0450)

Conveyor

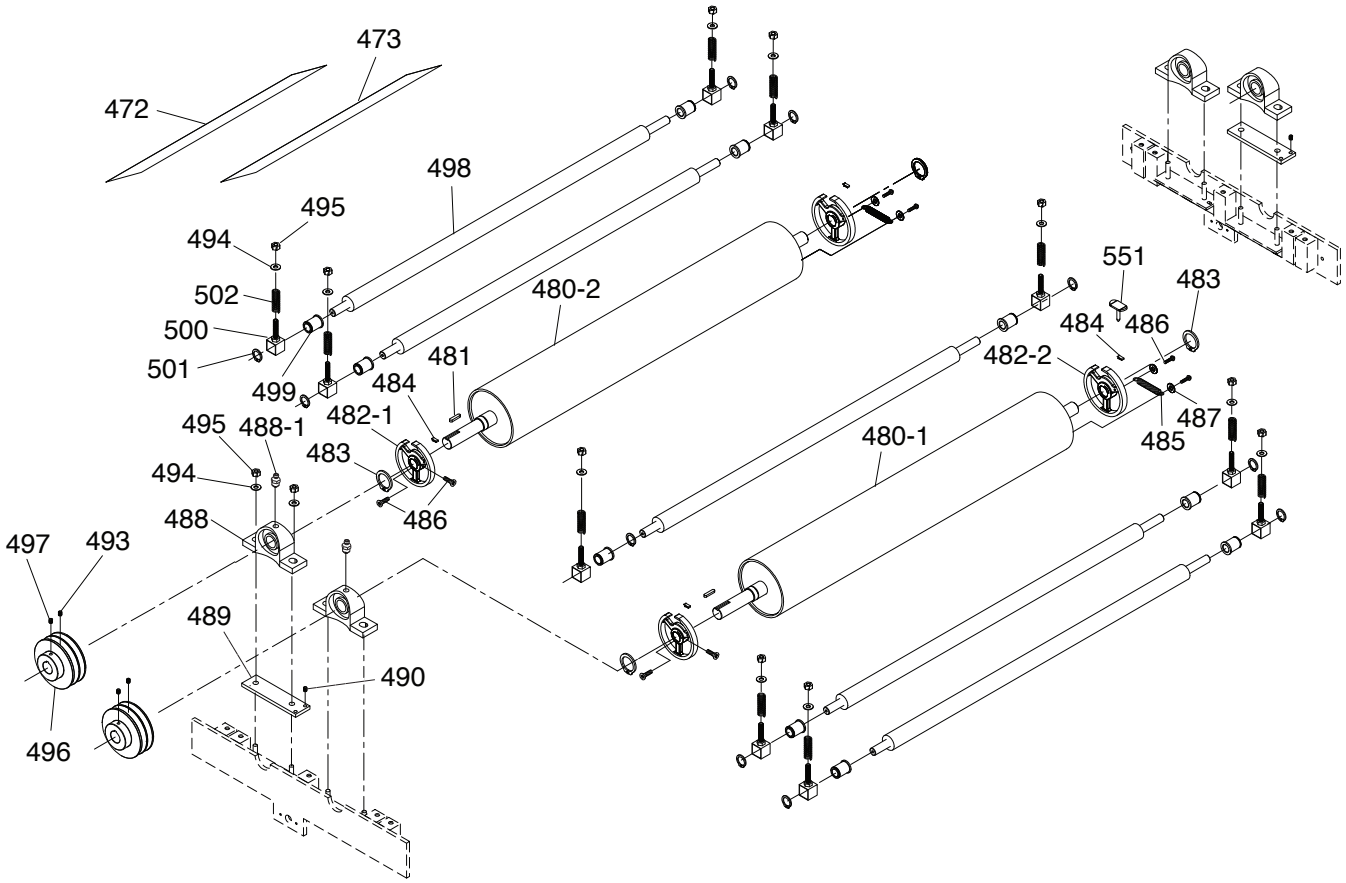


Conveyor Parts List

REF	PART #	DESCRIPTION
385	P0449385	HEX NUT M20-2.5
386	P0449386	TABLE
387	P0449387	TABLE SUPPORT (FL, RR)
388	P0449388	TABLE SUPPORT (FR, RL)
389	P0449389	HEX BOLT M8-1.25 X 30
390	P0449390	LOCK WASHER 8MM
391	P0449391	OUTFEED ROLLER SUPPORT BRACKET (LH)
392	P0449392	OUTFEED ROLLER SUPPORT BRACKET (RH)
393	P0449393	HEX BOLT M8-1.25 X 30
394	P0449394	LOCK WASHER 8MM
395	P0449395	HEX BOLT M12-1.75 X 80
396	P0449396	HEX NUT M12-1.75
397	P0449397	OUTFEED ROLLER
397-1	P0449397-1	OUTFEED ROLLER SHAFT
398	P0449398	BALL BEARING 6204-2RS
399	P0449399	LOCK COLLAR
400	P0449400	SET SCREW M6-1 X 10
401	P0449401	OUTFEED ROLLER COVER (LH)
402	P0449402	OUTFEED ROLLER COVER (RH)
403	P0449403	BUTTON HD CAP SCR M6-1 X 12
404	P0449404	FLAT WASHER 6MM
405	P0449405	CONVEYOR BELT 930 X 2290MM
406	P0449406	INFEED ROLLER SUPPORT BRACKET (LH)
407	P0449407	POINTER
408	P0449408	PHLP HD SCR M5-.8 X 10
409	P0449409	HEX BOLT M8-1.25 X 30
410	P0449410	INFEED ROLLER
411	P0449411	KEY 5 X 5 X 25
412	P0449412	FLANGE BEARING UCFL204
413	P0449413	HEX BOLT M10-1.5 X 25
414	P0449414	FLAT WASHER 10MM
415	P0449415	INFEED ROLLER SUPPORT BRACKET (RH)
416	P0449416	HEX BOLT M8-1.25 X 30
417	P0449417	GROMMET
419	P0449419	ROLLER SPROCKET
420	P0449420	SET SCREW M8-1.25 X 10
421	P0449421	CHAIN 3/8
422	P0449422	MOTOR SPROCKET
423	P0449423	KEY 5 X 5 X 35
424	P0449424	SET SCREW M8-1.25 X 10
425A	P0449425A	COMPLETE SPEED REDUCER ASSEMBLY
425-1	P0449425-1	OIL FILL PLUG 5/8-18
425-2	P0449425-2	PHLP HD SCR M3-.5 X 10
425-3	P0449425-3	DRAIN PLUG 1/4PT
426	P0449426	HEX BOLT M8-1.25 X 40
427	P0449427	FLAT WASHER 8MM
428	P0449428	EXT RETAINING RING 11MM
429	P0449429	GEARBOX SHAFT SLEEVE
430	P0449430	SET SCREW M8-1.25 X 10
431	P0449431	KEY 5 X 5 X 80
432	P0449432	EXT RETAINING RING 32MM
433	P0449433	COLLAR
434	P0449434	COMPRESSION SPRING

REF	PART #	DESCRIPTION
435	P0449435	GEARBOX OUTSIDE PULLEY
436	P0449436	V-BELT AX23
437	P0449437	GEARBOX INSIDE PULLEY
438	P0449438	FEED MOTOR 1/3HP 240V 1-PH (G0449)
438	P0450438	FEED MOTOR 1/3HP 240/480V 3-PH (G0450)
438-1	P0449438-1	MOTOR FAN COVER (G0449)
438-1	P0450438-1	MOTOR FAN COVER (G0450)
438-2	P0449438-2	MOTOR FAN (G0449)
438-2	P0450438-2	MOTOR FAN (G0450)
438-3	P0449438-3	CAPACITOR COVER
438-4	P0449438-4	S CAPACITOR 75M 125V (G0449)
438-5	P0449438-5	CAPACITOR COVER
438-6	P0449438-6	R CAPACITOR 20M 300V 1-5/16 X 2 (G0449)
438-7	P0449438-7	MOTOR JUNCTION BOX (G0449)
438-7	P0450438-7	MOTOR JUNCTION BOX (G0450)
438-8	P0449438-8	CENTRIFUGAL PLATE (G0449)
438-9	P0449438-9	CONTACT PLATE (G0449)
438-10	P0449438-10	BALL BEARING 6203-2RS (G0449)
438-10	P0450438-10	BALL BEARING 6203-2RS (G0450)
438-11	P0449438-11	BALL BEARING 6202-2RS (G0449)
438-11	P0450438-11	BALL BEARING 6202-2RS (G0450)
439	P0449439	HEX BOLT M8-1.25 X 25
440	P0449440	FLAT WASHER 8MM
441	P0449441	KEY 5 X 5 X 55
442	P0449442	HEX NUT M8-1.25
443	P0449443	MOTOR SHAFT SLEEVE
444	P0449444	SET SCREW M8-1.25 X 10
445	P0449445	VS INSIDE PULLEY
446	P0449446	SET SCREW M6-1 X 10
447	P0449447	BALL BEARING 608-2RS
448	P0449448	SHAFT
449	P0449449	HEX BOLT M6-1 X 12
450	P0449450	LOCK WASHER 6MM
451	P0449451	VS OUTSIDE PULLEY
452	P0449452	EXT RETAINING RING 17MM
453	P0449453	BALL BEARING 6003ZZ
454	P0449454	EXT RETAINING RING 35MM
455	P0449455	PULLEY NUT 1/2-12
456	P0449456	HEX NUT M10-1.5
457	P0449457	KNURLED COLLAR
458	P0449458	SET SCREW M6-1 X 10
459	P0449459	HANDWHEEL
460	P0449460	INT RETAINING RING 10MM
461	P0449461	SLEEVE
462	P0449462	L-BAR
463	P0449463	LOCK NUT M6-1
464	P0449464	KNOB SUPPORT PLATE
469	P0449469	BUTTON HD CAP SCR M6-1 X 12
470	P0449470	CONVEYOR MOTOR COVER DOOR
471	P0449471	CONVEYOR MOTOR COVER
474	P0449474	PHLP HD SCR M5-.8 X 6
477	P0449477	INFEED GUARD
479	P0449479	FLAT WASHER 6MM

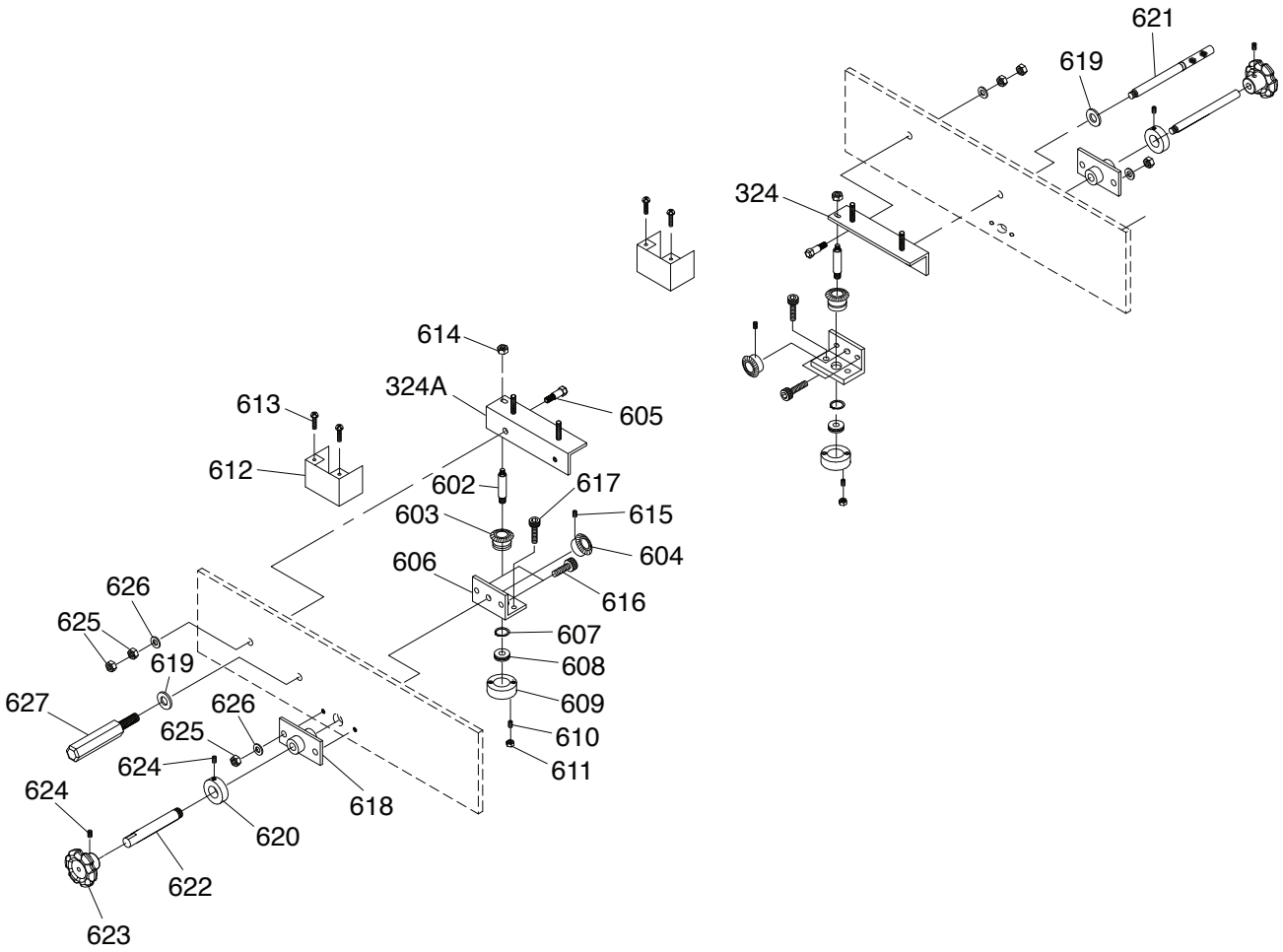
Roller & Drum



REF	PART #	DESCRIPTION
472	P0449472	SANDING PAPER ROLLS #60
473	P0449473	SANDING PAPER ROLLS #100
480-1	P0449480-1	SANDING DRUM (FRONT)
480-2	P0449480-2	SANDING DRUM (REAR)
481	P0449481	KEY 7 X 7 X 40
482-1	P0449482-1	SANDPAPER TENSIONING WHEEL (LH)
482-2	P0449482-2	SANDPAPER TENSIONING WHEEL (RH)
483	P0449483	EXT RETAINING RING 34MM
484	P0449484	SANDPAPER HOLDING CLIP
485	P0449485	EXTENSION SPRING
486	P0449486	BUTTON HD CAP SCR M6-1 X 12
487	P0449487	FLAT WASHER 6MM
488	P0449488	PILLOW BEARING UCP206
488-1	P0449488-1	GREASE FITTING 1/8" NPT STRAIGHT

REF	PART #	DESCRIPTION
489	P0449489	ADJUSTMENT PLATE
490	P0449490	SET SCREW 5/16-24 X 1/2
493	P0449493	SET SCREW M8-1.25 X 20
494	P0449494	FLAT WASHER 10MM
495	P0449495	LOCK NUT M10-1.5
496	P0449496	SANDING DRUM PULLEY
497	P0449497	SET SCREW M8-1.25 X 15
498	P0449498	HOLD DOWN ROLLER
499	P0449499	HOLD DOWN ROLLER BUSHING
500	P0449500	ROLLER BUSHING SUPPORT
501	P0449501	EXT RETAINING RING 19MM
502	P0449502	ROLLER COMPRESSION SPRING
551	P0449551	SPRING TENSION TOOL

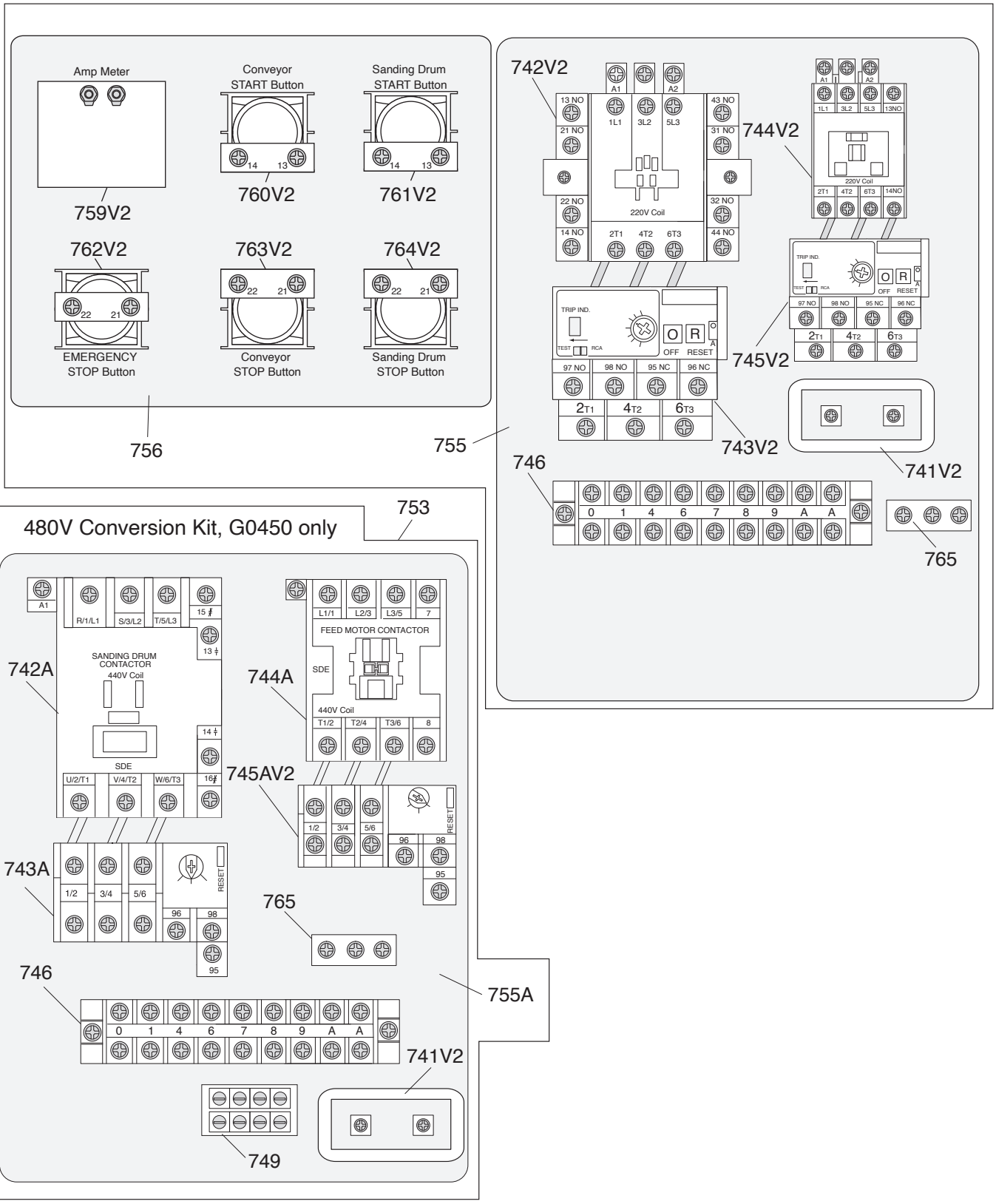
Micro-Adjust



REF	PART #	DESCRIPTION
324	P0449324	BEVEL GEAR COVER (RH)
324A	P0449324A	BEVEL GEAR COVER (LH)
602	P0449602	MICRO-ADJUST SCREW 1/4-20
603	P0449603	BEVEL GEAR A 25T
604	P0449604	BEVEL GEAR B 25T
605	P0449605	STEP BOLT 5/16-18
606	P0449606	MOUNTING BRACKET
607	P0449607	EXT RETAINING RING 20MM
608	P0449608	THRUST BEARING 51101
609	P0449609	THRUST BEARING SEAT
610	P0449610	SET SCREW 10-24 X 1/4
611	P0449611	HEX NUT 10-24
612	P0449612	DUST COVER
613	P0449613	TAP SCREW #10 X 3/8

REF	PART #	DESCRIPTION
614	P0449614	LOCK NUT 1/4-20
615	P0449615	SET SCREW 10-24 X 1/4
616	P0449616	CAP SCREW 5/16-18 X 1-1/4
617	P0449617	CAP SCREW 1/4-20 X 5/8
618	P0449618	DRIVE SHAFT BRACKET
619	P0449619	FLAT WASHER 5/16
620	P0449620	LOCK COLLAR
621	P0449621	LOCK LEVER
622	P0449622	DRIVE SHAFT
623	P0449623	CONTROL KNOB
624	P0449624	SET SCREW 1/4-20 X 5/16
625	P0449625	HEX NUT 5/16-18
626	P0449626	FLAT WASHER 5/16
627	P0449627	LOCK HANDLE

Electrical

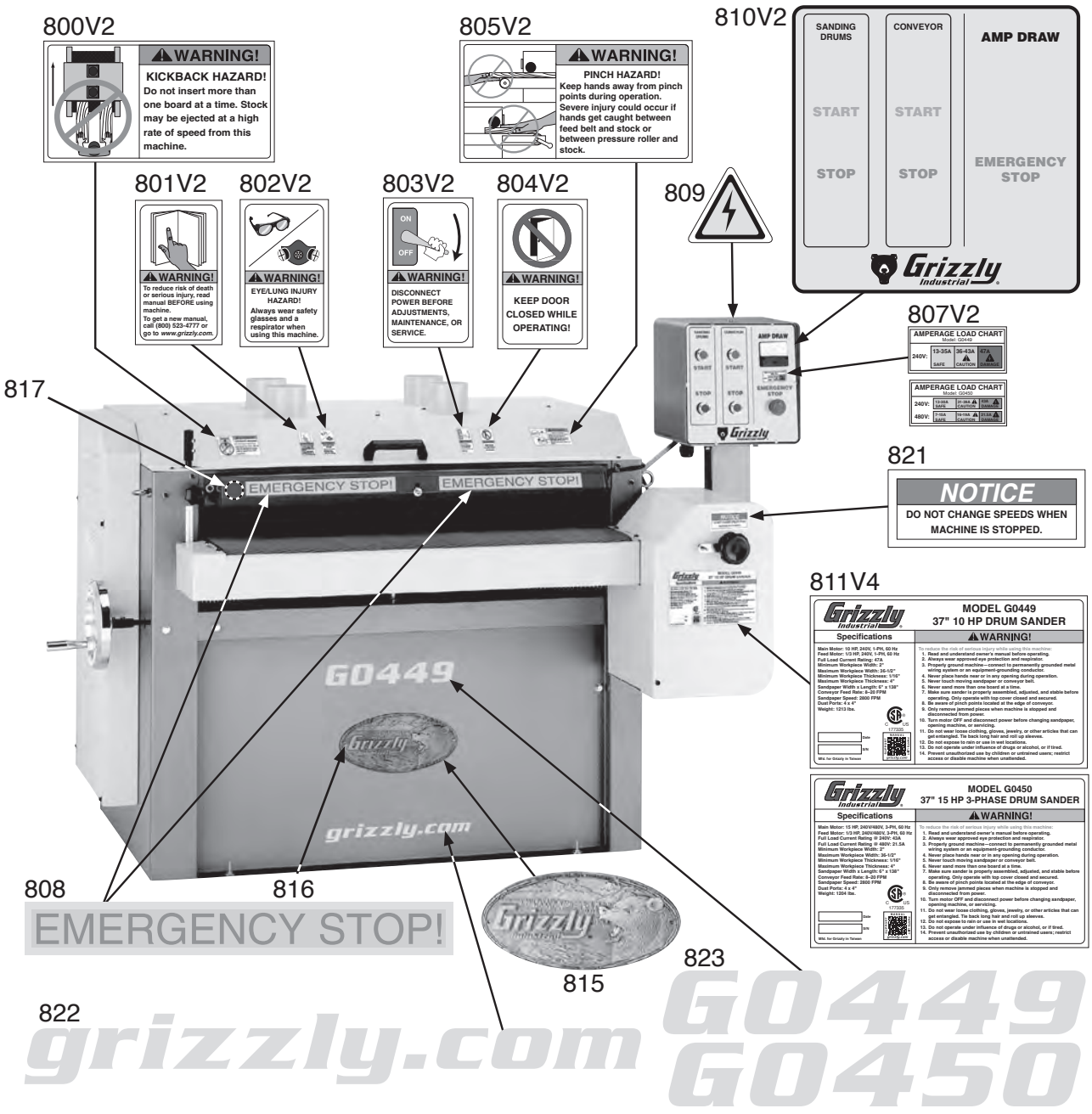


Electrical Parts List

REF	PART #	DESCRIPTION
741V2	P0449741V2	CURRENT COIL TH30 100/5A
742V2	P0449742V2	CONTACTOR TECO CU-50R 220V (G0449 240V)
742V3	P0450742V3	CONTACTOR TECO CU-50R 220V (G0450 240V)
742AV2	P0450742AV2	CONTACTOR TECO CU-40R 440V (G0450 480V)
743V2	P0449743V2	OL RELAY TECO RHU-80K3 (G0449, G0450 240V)
743AV2	P0450743AV2	OL RELAY TECO RHU-80K2 (G0450 480V)
744V2	P0449744V2	CONTACTOR TECO CU-11 220V (G0449, G0450 240V)
744AV2	P0450744AV2	CONTACTOR TECO CU-11 440V (G0450 480V)
745V2	P0449745V2	OL RELAY TECO RHU-10K1 2.3-3.2A (G0449 240V)
745V2	P0450745V2	OL RELAY TECO RHU-10K1 1.4-2A (G0450 240V)
745AV3	P0450745AV3	OL RELAY TECO RHU-10K1 0.75-1A (G0450 480V)
746	P0449746	TERMINAL BAR 9P

REF	PART #	DESCRIPTION
749	P0450749	AMP METER TRANSFORMER (G0450 480V)
753	P0450753	480V CONVERSION KIT (G0450)
755	P0449755	ELECTRICAL PANEL (G0449, G0450 240V)
755A	P0450755A	ELECTRICAL PANEL (G0450 480V)
756	P0449756	CONTROL PANEL PLATE
759V2	P0449759V2	ANALOG AMP METER 100/5A V2.11.13
760V2	P0449760V2	START BUTTON GBF-221 22MM GRN V2.11.13
761V2	P0449761V2	START BUTTON GBF-221 22MM GRN V2.11.13
762V2	P0449762V2	E-STOP BUTTON GLEB-221 22MM V2.11.13
763V2	P0449763V2	STOP BUTTON GBF-221 22MM RED V2.11.13
764V2	P0449764V2	STOP BUTTON GBF-221 22MM RED V2.11.13
765	P0449765	GROUND TERMINAL

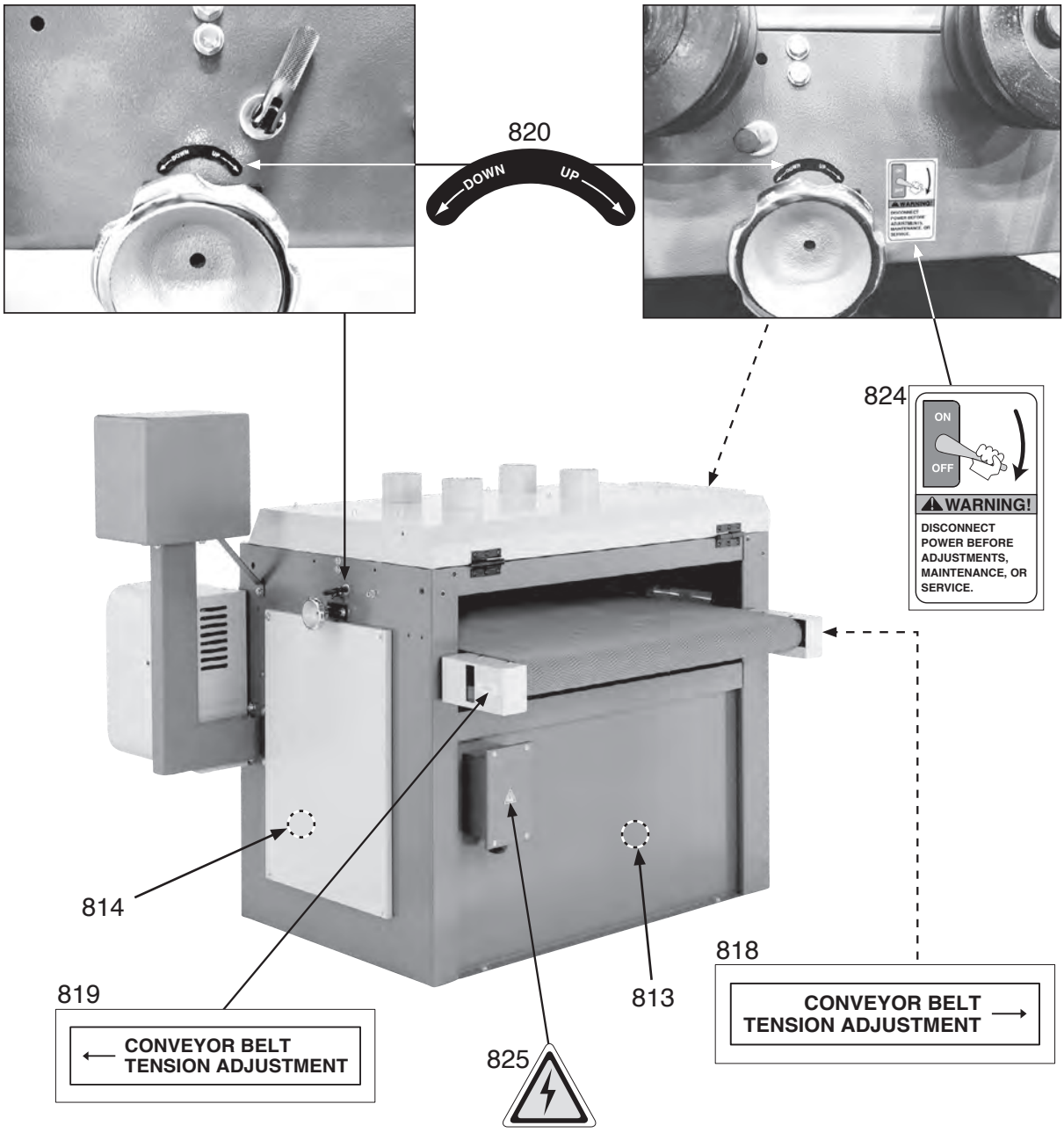
Labels & Cosmetics



REF	PART #	DESCRIPTION
800V2	P0449800V2	KICKBACK LABEL V2.12.24
801V2	P0449801V2	READ MANUAL LABEL V2.12.24
802V2	P0449802V2	GLASSES/RESPIRATOR LABEL V2.12.24
803V2	P0449803V2	DISCONNECT LABEL V2.12.24
804V2	P0449804V2	KEEP DOOR CLOSED LABEL V2.12.24
805V2	P0449805V2	PINCH HAZARD LABEL V2.12.24
807V2	P0449807V2	AMP LOAD LABEL CSA (G0449) V2.08.13
807V2	P0450807V2	AMP LOAD LABEL CSA (G0450) V2.08.13
808	P0449808	EMERGENCY STOP LABEL
809	P0449809	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
810V2	P0449810V2	CONTROL PANEL PLATE LABEL V2.12.24
811V4	P0449811V4	MACHINE ID LABEL (G0449) V4.12.24
811V4	P0450811V4	MACHINE ID LABEL (G0450) V4.12.24
815	P0449815	GRIZZLY NAMEPLATE-LARGE
816	P0449816	PHLP HD SCR M3-.5 X 10
817	P0449817	TOUCH-UP PAINT, RED
821	P0449821	DO NOT CHANGE SPEEDS LABEL
822	P0449822	MODEL NUMBER LABEL (G0449)
822	P0450822	MODEL NUMBER LABEL (G0450)
823	P0449823	GRIZZLY.COM LABEL 12", BEIGE

Labels & Cosmetics (Cont.)



REF	PART #	DESCRIPTION
813	P0449813	TOUCH-UP PAINT, GRIZZLY GREEN
814	P0449814	TOUCH-UP PAINT, GRIZZLY PUTTY
818	P0449818	BELT TENSION ADJUST LABEL (LH)
819	P0449819	BELT TENSION ADJUST LABEL (RH)

REF	PART #	DESCRIPTION
820	P0449820	MICRO-ADJUST KNOB LABEL
824	P0449824	DISCONNECT POWER LABEL
825	P0449825	ELECTRICITY LABEL

WARRANTY & RETURNS

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

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

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

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

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

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

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