

READ THIS FIRST



Model G0774

*****IMPORTANT UPDATE*****

For Machines Mfd. Since 02/15
and Owner's Manual Printed 02/18

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

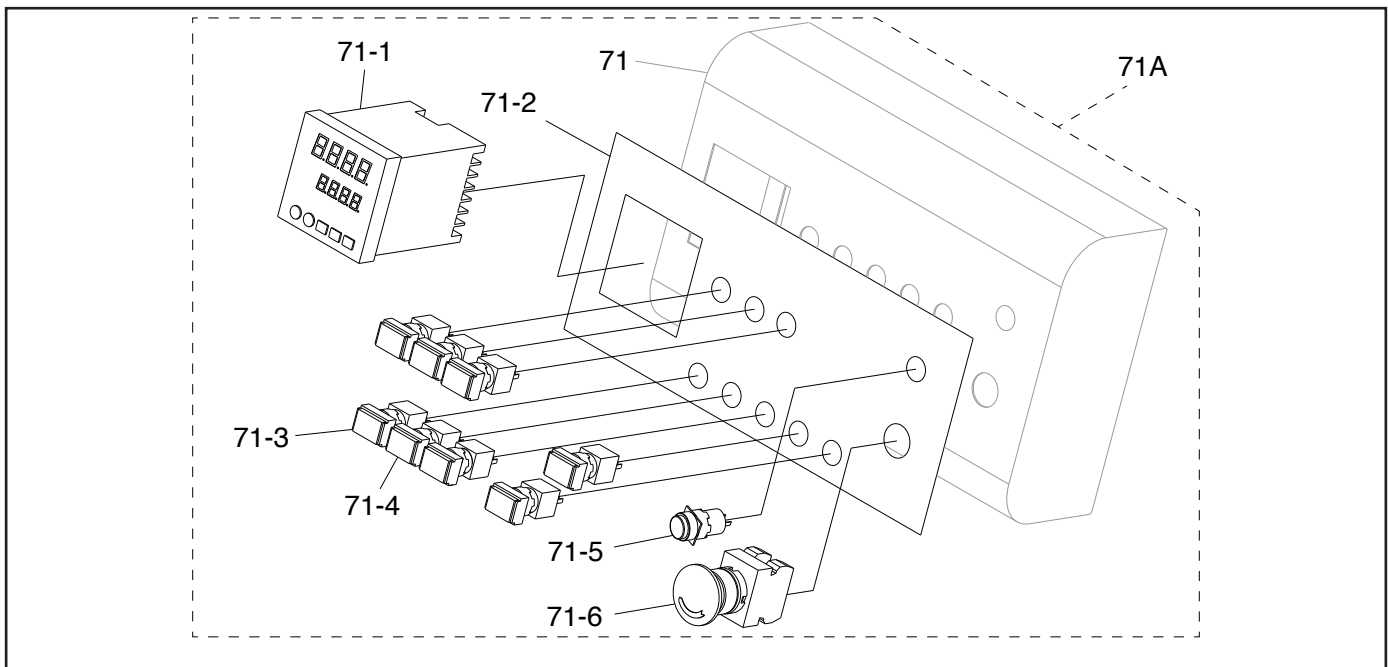
The following change was made since the owner's manual was printed:

- Control panel components have been added to main table parts.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Control Panel



REF	PART #	DESCRIPTION
71A	P07740071A	CONTROL PANEL ASSEMBLY
71	P07740071	CONTROL PANEL COVER
71-1	P07740071-1	TEMPERATURE CONTROLLER FOTEK NT-72RE
71-2	P07740071-2	CONTROL PANEL LABEL

REF	PART #	DESCRIPTION
71-3	P07740071-3	OFF BUTTON FUJI AH164-TFR11 16MM
71-4	P07740071-4	ON BUTTON FUJI AH164-TLG11E3 16MM
71-5	P07740071-5	POWER LIGHT FUJI AH164-ZRE3 16MM
71-6	P07740071-6	E-STOP BUTTON RENY R2PNR4-1B-R 22MM

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 #JP22325 PRINTED IN TAIWAN

Grizzly **Industrial, Inc.**®

MODEL G0774 **AUTOMATIC EDGEBANDER** **OWNER'S MANUAL** *(For models manufactured since 1/21)*



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V4.11.21



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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


Manual Accuracy

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

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

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

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

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure safety glasses and respirator are properly adjusted/setup and	
Weight:		4. power is connected to grounded circuit before starting.	
		5. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.	
		6. DO NOT expose to rain or dampness.	
		7. DO NOT modify this machine in any way.	
		8. Make sure power is disconnected.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
		Manufactured for Grizzly in Taiwan	

Manufacture Date

Serial Number



Identification (Front)

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

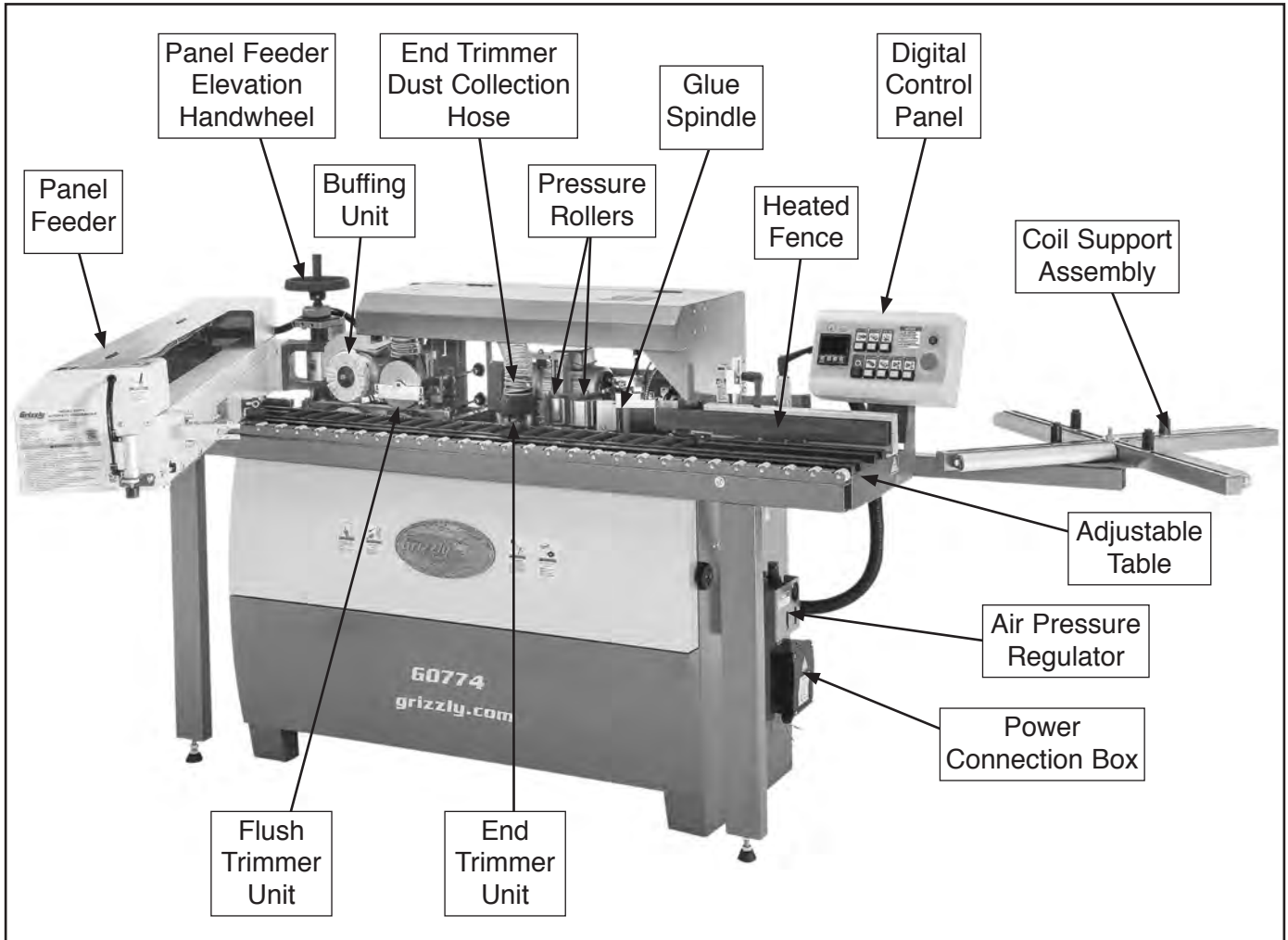


Figure 1. Component identification—front.

	<p>⚠ WARNING To reduce your risk of serious injury, read this entire manual BEFORE using machine.</p>
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Identification (Rear)

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

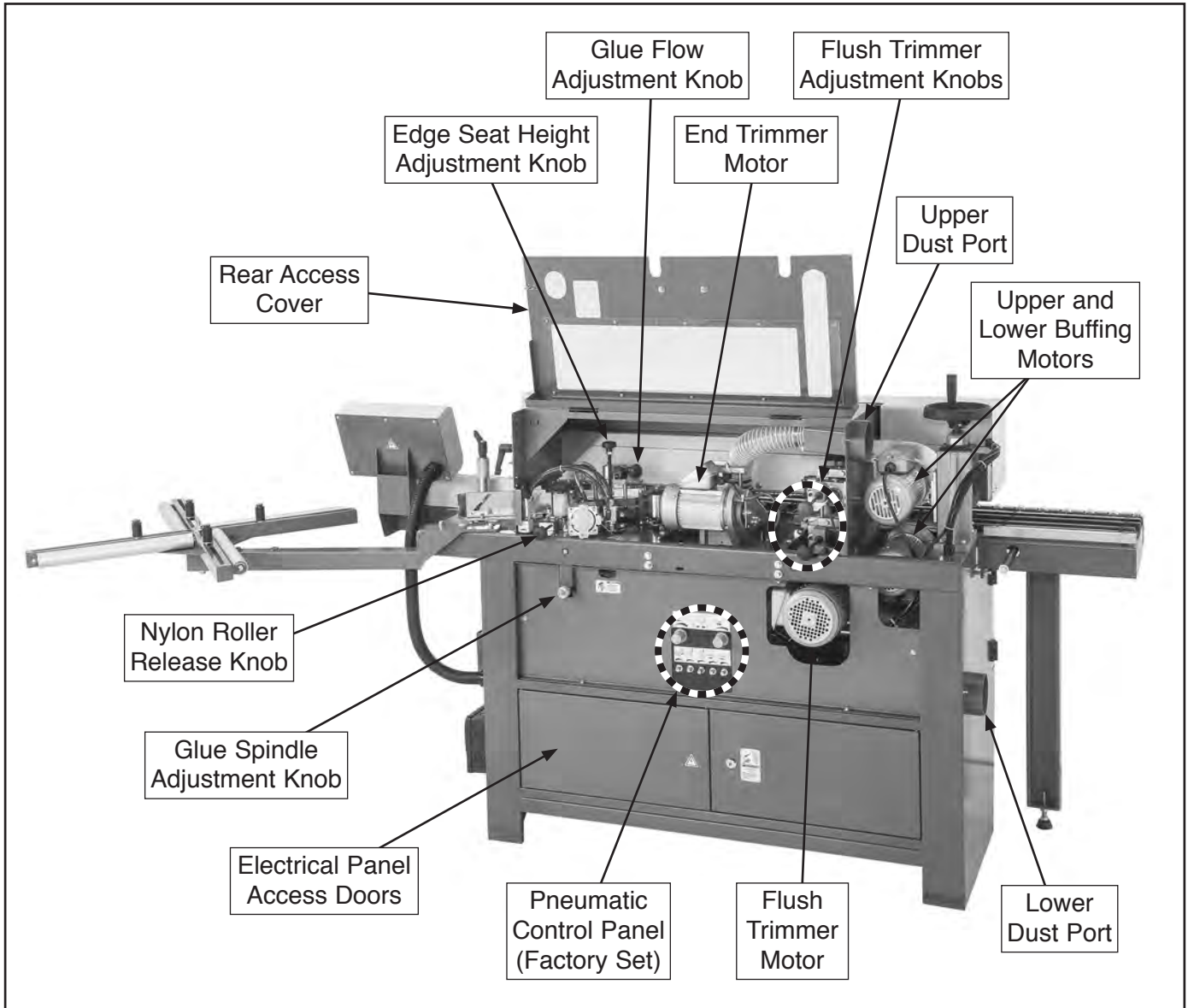


Figure 2. Component identification—rear.

	<p>⚠ WARNING</p> <p>To reduce your risk of serious injury, read this entire manual BEFORE using machine.</p>
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Controls & Components



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

Control Panel

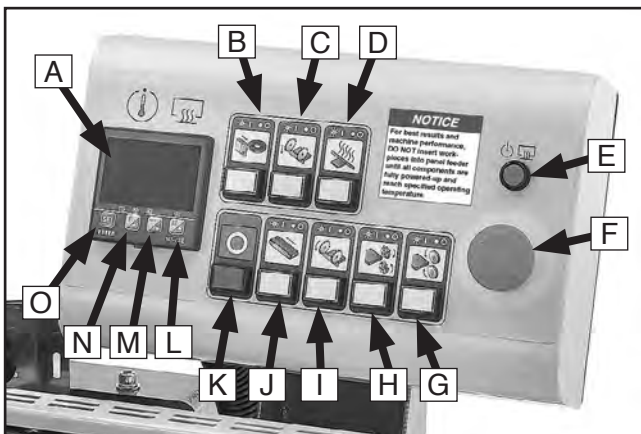


Figure 3. Control panel.

- A. **Thermoregulator Display:** Displays actual and set temperatures of glue pot.
- B. **Guillotine Sensor ON/OFF Button:** Activates sensor for guillotine pneumatic control (see Page 6).
- C. **End Trimmer Sensor ON/OFF Button:** Activates sensor for end trimmer pneumatic control (see Page 7).
- D. **Infeed Fence Heat ON/OFF Button:** Controls infeed fence heating element. Allow 12–14 minutes to reach working temperature.
- E. **Power Lamp:** Illuminates when machine is in standby mode.

- F. **Emergency Stop/Reset Button:** Stops all machine functions except for glue pot. Twist clockwise to reset.
- G. **Buffing Unit ON/OFF Button:** Controls buffing motors (see Page 9).
- H. **Flush Trimmer ON/OFF Button:** Controls flush trimmer motor (see Page 8).
- I. **End Trimmer ON/OFF Button:** Controls end trimmer motor (see Page 7).
- J. **Panel Feeder ON/OFF Button:** Controls panel feeder conveyor belt (see Page 9).
- K. **Motor OFF Button:** Turns **OFF** all motors and motor-driven functions (except for glue spindle motor).
- L. **Temperature UP Key:** Incrementally raises temperature of glue pot when pressed.
- M. **Temperature DOWN Key:** Incrementally lowers temperature of glue pot when pressed.
- N. **Thermoregulator Function Key:** Only used for initial factory programming of thermoregulator. Not intended for end-user adjustment. *Qualified service personnel only!*
- O. **Temperature SET Key:** Saves temperature setting after user input from Temperature UP/DOWN key(s).

Coil Support

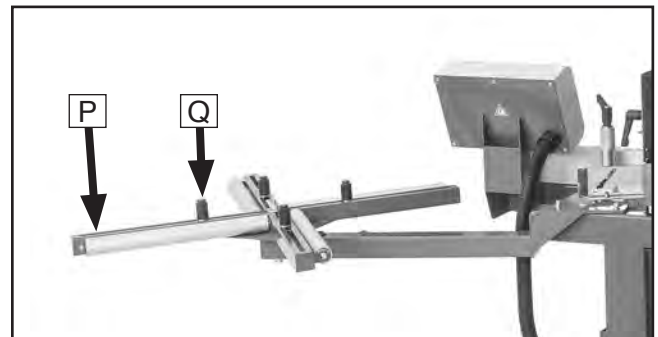


Figure 4. Coil support components.

- P. **Coil Support Assembly:** Supports edge-banding coil during operation.
- Q. **Adjustable Guide Rollers (4):** Holds edge-banding coil in place during operation. Adjust as needed according to size of coil.



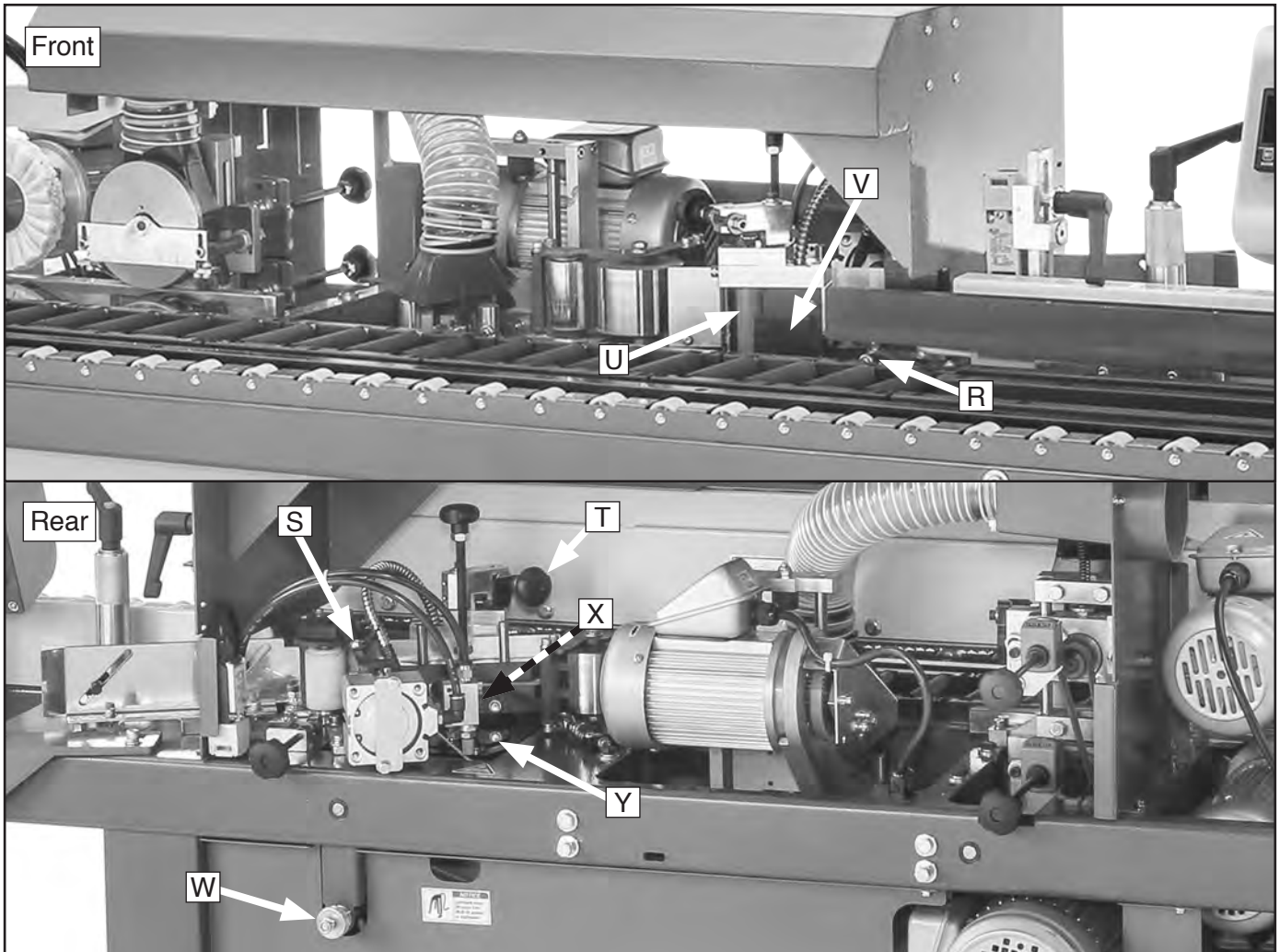


Figure 5. Guillotine and glue system controls & components.

Guillotine

- R. Guillotine Limit Switch:** When trailing end of workpiece passes over and releases switch, switch activates pneumatic guillotine to sever edgeband.
- S. Pneumatic Guillotine:** Severs trailing end of glued edgeband.

Glue System

- T. Glue Flow Adjustment Knob:** Rotate counterclockwise to increase glue flow; rotate clockwise to decrease glue flow.
- U. Glue Spindle:** Applies melted glue to workpiece edge.
- V. Guide Plate:** Maintains proper distance between workpiece and glue spindle to control amount of glue that is applied.
- W. Glue Spindle Adjustment Knob:** Rotate counterclockwise to move spindle all the way forward into working position.
- X. Glue Pot Lid:** Remove to inspect glue pot or to add glue. Leave closed during operations.
- Y. Glue Pot:** Stores and heats glue for bonding edgeband to workpiece.



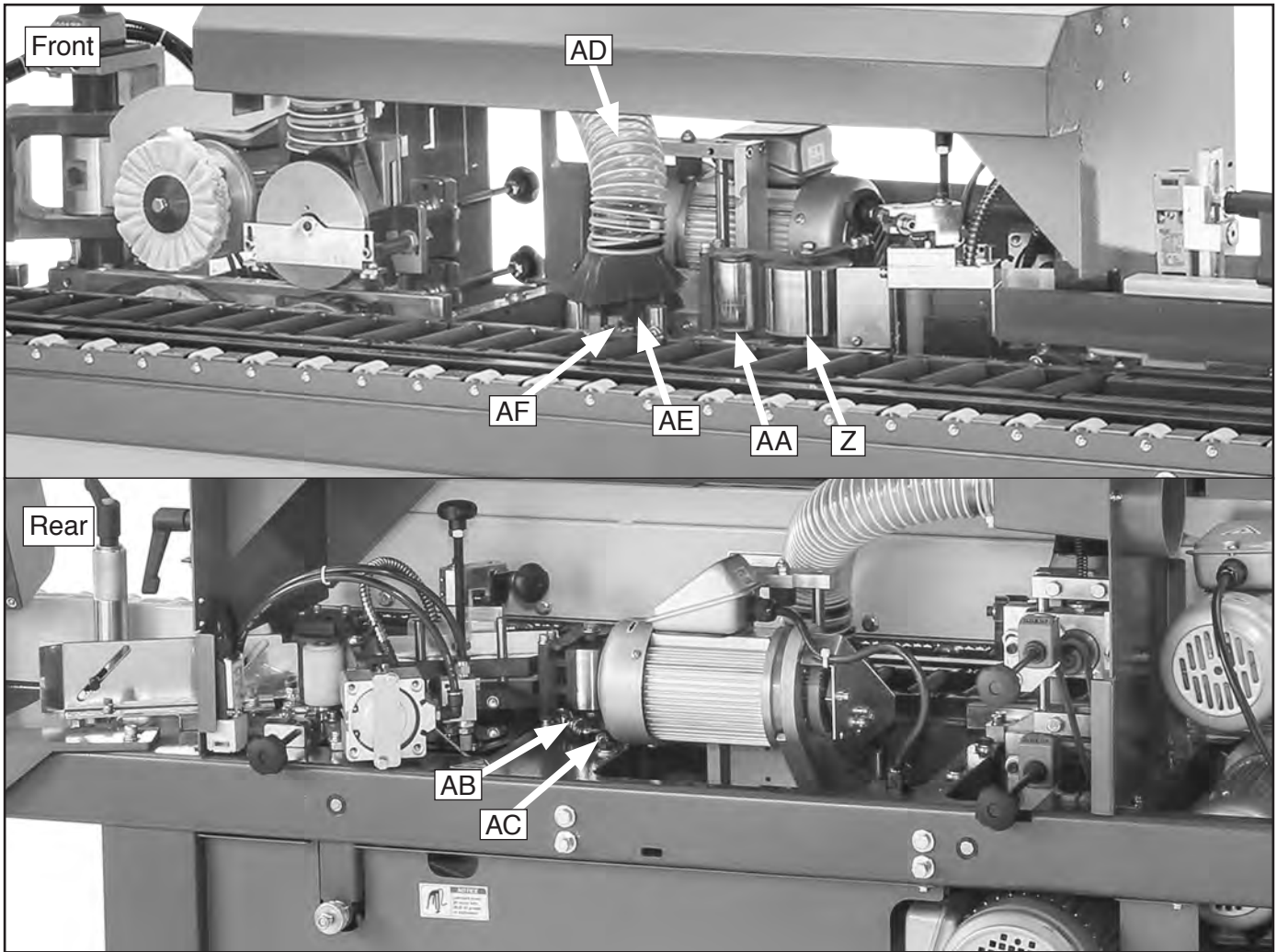


Figure 6. Pressure rollers and end trimming system controls & components.

Pressure Rollers

- Z. Stationary Pressure Roller:** Presses edgeband against workpiece after glue is applied. Position is not adjustable.

- AA. Adjustable Pressure Roller:** Presses edgeband against workpiece after glue is applied. Position can be adjusted to increase or decrease pressure as necessary (refer to **Page 62** for more information).

- AB. Adjustable Pressure Roller Jam Nut:** Loosen to rotate adjustable pressure roller bolt. Tighten to secure setting.

- AC. Adjustable Pressure Roller Bolt:** Loosen to increase pressure of adjustable pressure roller against edgeband and workpiece. Tighten to decrease pressure.

End Trimmer

- AD. End Trimmer Dust Collection Hose:** Removes sawdust and debris caused by end trimming operation.

- AE. End Trimmer Blades (Right and Left):** Rotate at approximately 9000 RPM and follow workpiece to trim leading and trailing ends of glued edgeband.
 - *Right* end trimmer blade trims *leading* end of edgeband.
 - *Left* end trimmer blade trims *trailing* end of edgeband.

- AF. End Trimmer Tracer:** Guides end trimmer blades.



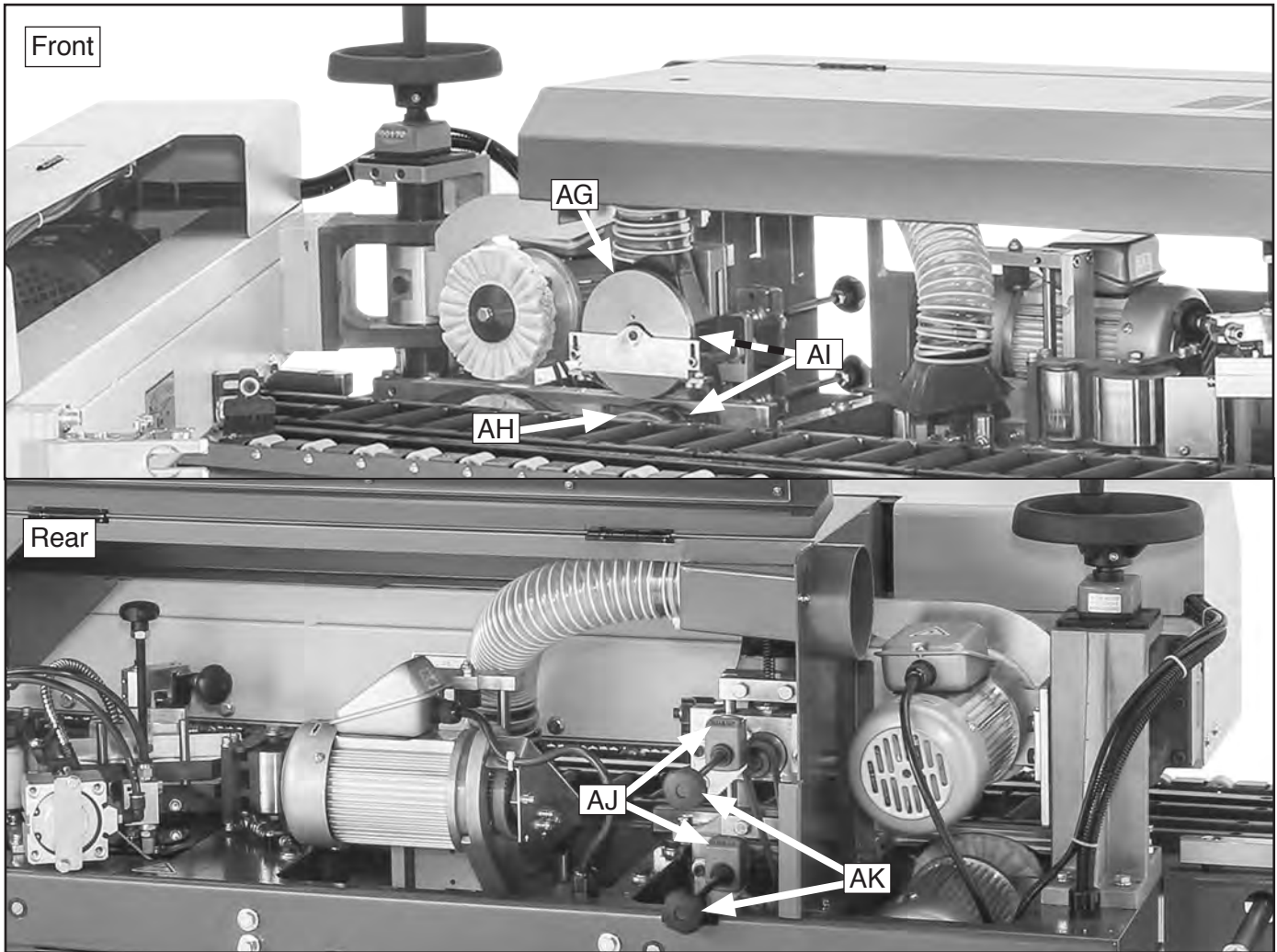


Figure 7. Flush trimming system controls & components.

Flush Trimmer

AG. Adjustable Flush Trimmer Tracer:

Guides upper flush trimmer cutter. Height adjusts simultaneously with panel feeder elevation adjustment (see **Page 9** for more information).

AH. Stationary Flush Trimmer Tracer: Guides lower flush trimmer cutter.

AI. Flush Trimmer Cutters (Upper and Lower):

Rotates at approximately 10,000 RPM and trims height of glued edgeband, making it flush with top and bottom of workpiece.

AJ. Flush Trimmer Axial Indicators (Upper and Lower):

Displays numerical distance of flush trimmer cutters from workpiece edge in millimeters.

AK. Flush Trimmer Axial Adjustment Knobs (Upper and Lower):

Rotates counterclockwise to move flush trimmer cutters closer to workpiece edge; rotates clockwise to move cutters farther away.

Note: For best results, always adjust upper and lower flush trimmer cutters equally.



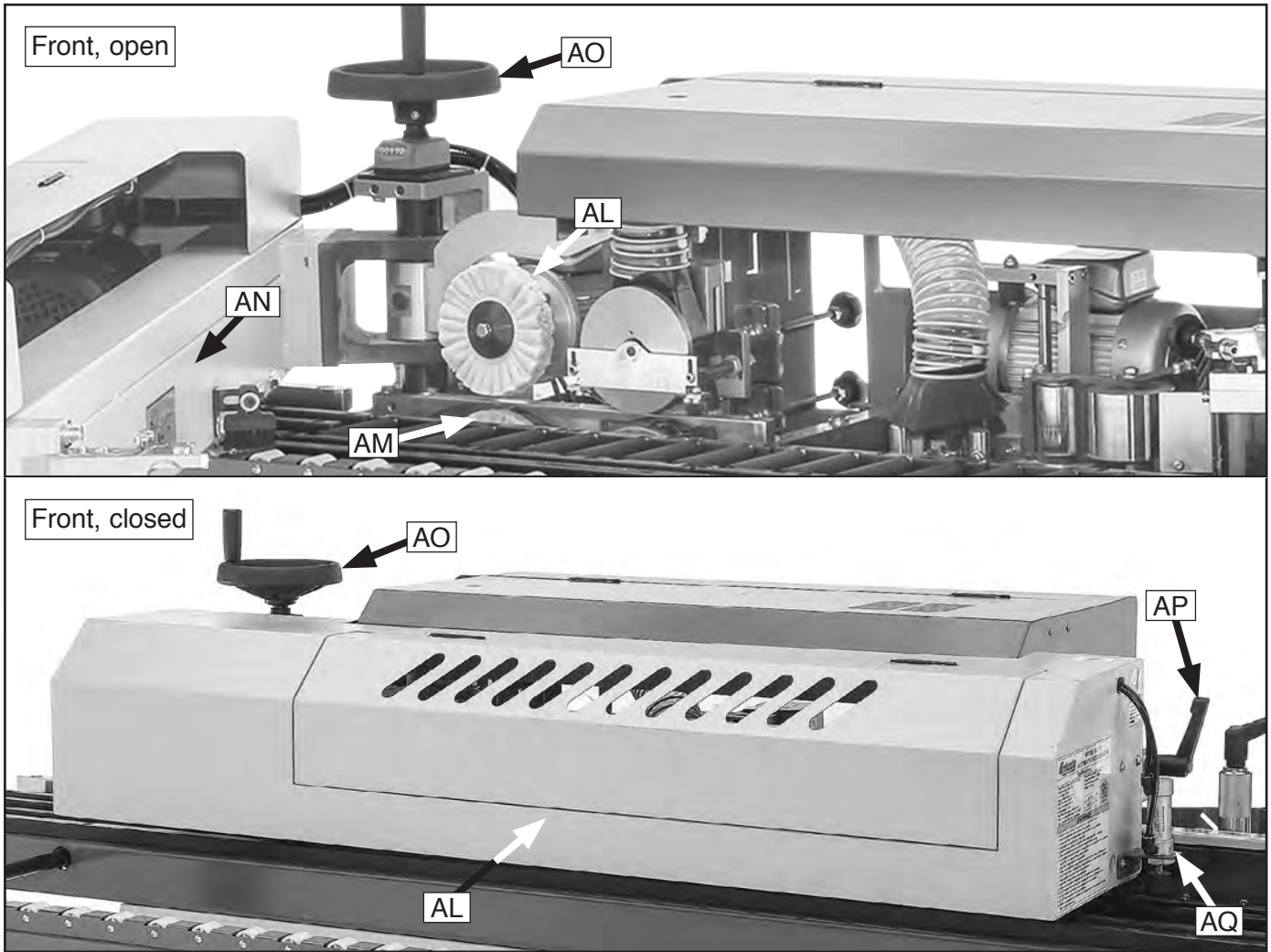


Figure 8. Buffing system and panel feeder controls & components.

Buffing Unit

AL. Adjustable Buffing Wheel: Rotates at approximately 3000 RPM and polishes upper surface of glued and trimmed edgeband. Height adjusts simultaneously with panel feeder elevation adjustment (see **This Page** for more information).

AM. Stationary Buffing Wheel: Rotates at approximately 3000 RPM and polishes lower surface of glued and trimmed edgeband. Height is not adjustable.

Panel Feeder

AN. Panel Feeder: Uses conveyor belt to advance workpiece from infeed end of table to outfeed end of table during edgebanding operation. Height is adjustable according to workpiece thickness.

AO. Panel Feeder Elevation Handwheel: Raises and lowers panel feeder according to workpiece thickness. Rotate clockwise to raise panel feeder; rotate counterclockwise to lower it. Handwheel base features a readout that displays height in millimeters.

Note: Panel feeder elevation handwheel also raises and lowers upper portions of flush trimming and buffing units (see **Page 8** and **This Page** for more information).

AP. Panel Feeder Lock: Locks panel feeder in position during edgebanding operations.

AQ. Pneumatic Panel Stop: Automatically lowers during operation to prevent multiple workpieces from entering panel feeder at same time. Automatically raises when workpiece exits panel feeder, to allow next operation.



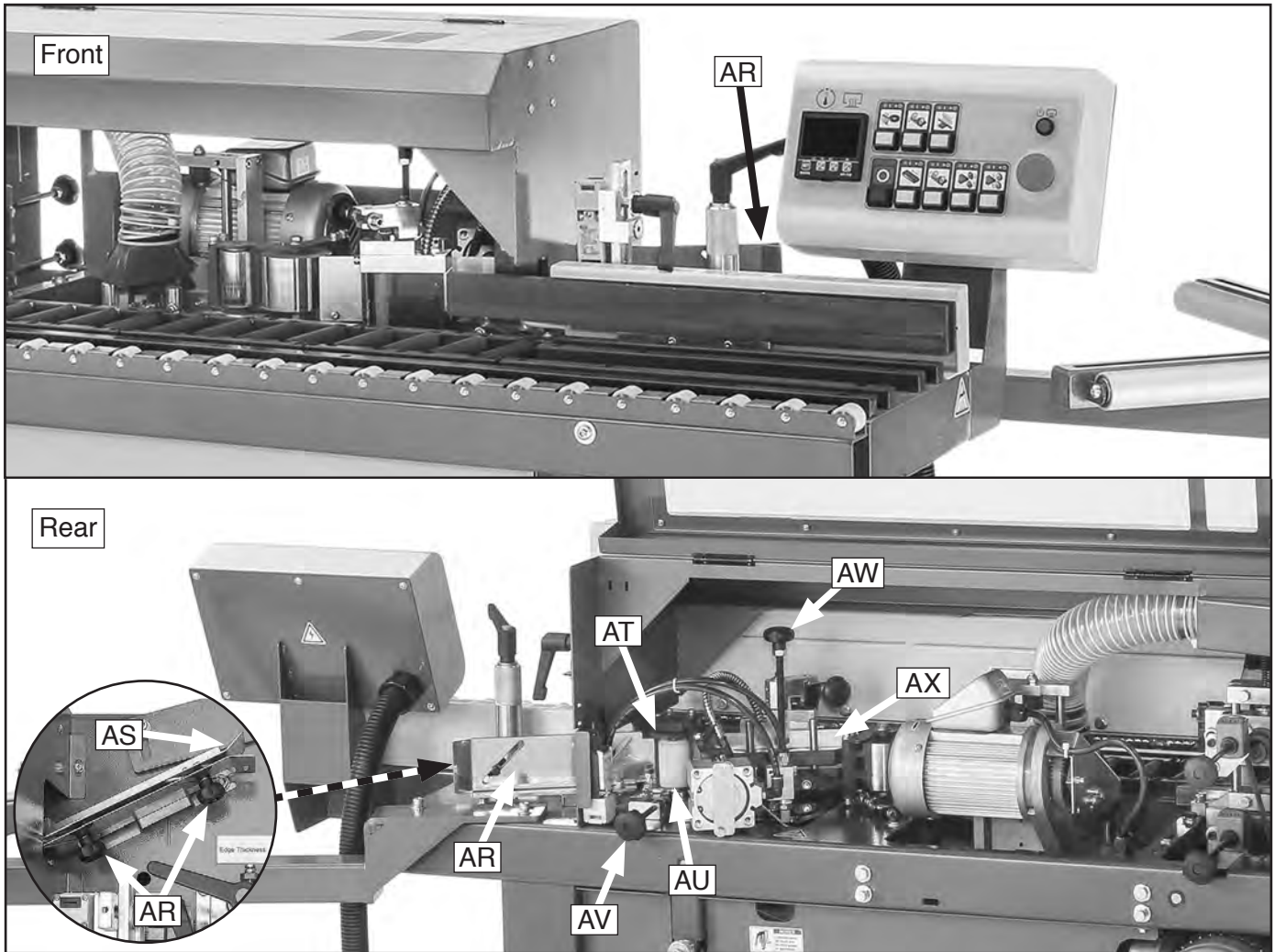


Figure 9. Edgeworking feeder controls & components.

Edgeworking Feeder

AR. Edgebanding Height Knobs (2): Secures edgebanding vertically within edgebanding intake guides. Loosen to adjust according to edgebanding width; tighten to secure setting.

Note: Leave approximately 0.2mm vertical play when setting knobs.

AS. Edgebanding Intake Guides (2): Guides edgebanding as it feeds into machine.

AT. Rubber Drive Roller: Advances edgebanding until it is severed by guillotine.

AU. Nylon Roller: Forces edgebanding against rubber drive roller, providing necessary friction to advance edgeband.

AV. Nylon Roller Release Knob: Pull knob to the right to release nylon roller pressure when removing or loading edgeband. Release knob to apply pressure after edgebanding is properly loaded.

AW. Edgebanding Seat Adjustment Knob: Rotate clockwise to raise upper section of edgebanding seat; rotate counterclockwise to lower upper section. Adjust as necessary according to edgebanding width.

Note: Leave approximately 1/32" vertical play when adjusting upper section height.

AX. Edgebanding Seat: Vertically supports edgebanding just prior to making contact with glued edge of workpiece. Use Edgebanding Seat Adjustment Knob (**AU**) to adjust seat according to edgebanding width.



Infeed Fence

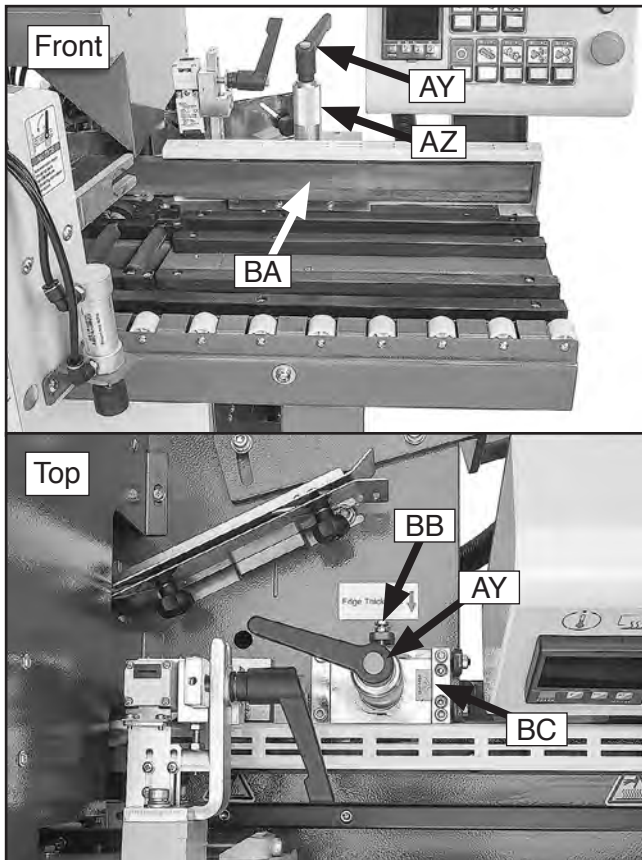


Figure 10. Infeed fence controls & components.

AY. Fence Adjustment Lock Lever: Tighten to secure fence position; loosen to allow fence adjustment.

AZ. Fence Adjustment Knurled Cylinder: Rotate to adjust fence position according to edgework thickness. Rotate counterclockwise for greater edgework thickness; rotate clockwise for less edgework thickness.

BA. Heated Infeed Fence: Guides workpiece during operation while also heating workpiece edge for better glue adhesion.

BB. Fence Stop: Allows you to quickly and easily set the infeed fence position without having to use the scale (refer to **Page 37** for details).

BC. Fence Adjustment Scale: Indicates position of fence relative to edgework thickness in millimeter increments.

Power & Air

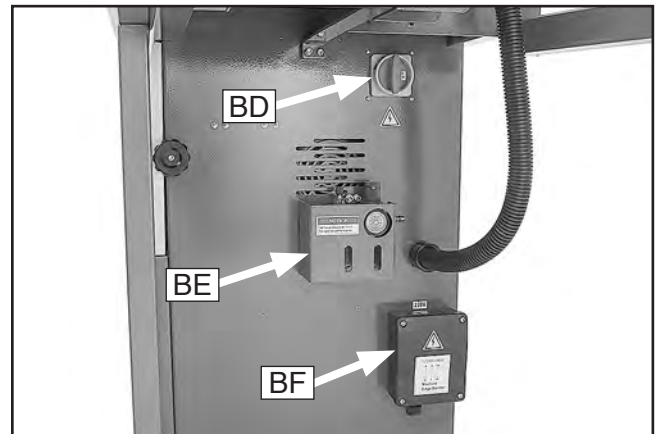


Figure 11. Power and air fence controls & components.

BD. Master Power ON/OFF Switch: Turns incoming power **ON** and **OFF**.

BE. Main Pressure Regulator: Adjusts incoming air pressure. Pressure should be set to 100 PSI. Lift knob up and rotate clockwise to increase PSI/counterclockwise to decrease PSI, then push knob down to secure setting.

BF. Wiring Box: Location to permanently connect (hardwire) machine to power supply.





MACHINE DATA SHEET

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

MODEL G0774 AUTOMATIC EDGE BANDER

Product Dimensions:

Weight 754 lbs.
Width (side-to-side) x Depth (front-to-back) x Height 109-1/2 x 60-1/2 x 49-1/2 in.
Footprint (Length/Width) 57-3/4 x 22-3/4 in.

Shipping Dimensions:

Type Wood Crate
Weight 970 lbs.
Length/Width/Height 83 x 29 x 53 in.
Must Ship Upright Yes

Electrical:

Power Requirement 220V, Single-Phase, 60 Hz
Full-Load Current Rating 19A
Minimum Circuit Size 30A
Connection Type Cord & Plug
Power Cord Included Yes
Power Cord Gauge 12 AWG
Plug Included Yes
Plug Type L6-30
Switch Type Control Panel w/Magnetic Switch Protection

Motors:

Feed

Type TEFC Capacitor-Start Induction
Horsepower 3/4 HP
Voltage 220V
Phase Single-Phase
Amps 3.6A
Speed 1700 RPM
Power Transfer Gear Drive
Bearings Shielded & Permanently Sealed

Glue Spindle

Type TEFC Capacitor-Start Induction
Horsepower 1/3 HP
Voltage 220V
Phase Single-Phase
Amps 1.7A
Speed 1720 RPM
Power Transfer Gear Drive
Bearings Shielded & Permanently Sealed



End Trim

Type..... TEFC Capacitor-Start Induction
Horsepower 1/4 HP
Voltage 220V
Phase Single-Phase
Amps 1.6A
Speed 3400 RPM
Power Transfer..... Timing Belt
Bearings Shielded & Permanently Sealed

Flush Trim

Type..... TEFC Capacitor-Start Induction
Horsepower 3/4 HP
Voltage 220V
Phase Single-Phase
Amps 3.5A
Speed 3400 RPM
Power Transfer..... Flat Belt
Bearings Shielded & Permanently Sealed

Buffing

Type..... TEFC Capacitor-Start Induction
Horsepower 1/4 HP
Voltage 220V
Phase Single-Phase
Amps 1.6A
Speed 3400 RPM
Power Transfer..... Direct Drive
Bearings Shielded & Permanently Sealed

Main Specifications:

Operation Information

Min. Panel Width 4-3/4 in.
Min. Panel Length 9-1/2 in.
Panel Thickness (Min. – Max.)..... 1/2 – 1-3/4 in.
Tape Thickness (Min. – Max.)..... 0.5 – 3 mm
Air Requirement 6 SCFM @ 100 PSI
Panel Feed Speed..... 16 FPM
Glue Pot Capacity 34 oz.
Roller Width..... 3-3/4 in.
Roller Diameter 13/16 in.
Max. Height of Rollers..... 0.8 – 1.0 mm
Edgebanding Coil Capacity 31-1/2 in.
Dust Collection Ports (2) 4 in.
Dust Collection Requirement (at Dust Port)..... 700 CFM
Heating Element..... 1535W (t)

Table Information

Work Table Length..... 78-3/4 in.
Work Table Width..... 10-1/2 in.

Construction

Housing Aluminum
Frame Steel
Rollers Rubber
Paint Powder Coated



Other Specifications:

Country of Origin..... Taiwan
Warranty..... 1 Year
Approximate Assembly & Setup Time 2 Hours
Serial Number LocationMachine ID Label on Right Side
Sound Rating 80 dB
ISO 9001 Factory.....Yes
CSA Certified No

Features:

- Automatic belt feed with adjustable table rollers
- Edgebanding from 0.5mm – 3mm
- Panel thickness from 1/2" – 1-3/4"
- 16 FPM feed speed
- Heated infeed fence for better glue dispersion
- Pneumatic edgebanding guillotine
- Double-bladed end-trimming saw
- Upper and lower trimming units with digital readout
- Upper and lower buffing units
- Adjustable infeed fence for different edgebanding thicknesses
- Extendable side bar to accommodate larger panels
- Digital control panel controls each element individually
- Teflon-coated glue pot with 5 heating elements and motorized glue spreader
- 31-1/2" tape coil support
- Two 4-inch dust ports
- Built-in air regulator and filter for pneumatic system



SECTION 1: SAFETY

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

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



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



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



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

NOTICE

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

Safety Instructions for Machinery

WARNING

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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Automatic Edgebanders

WARNING

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

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

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

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

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

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

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

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

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

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

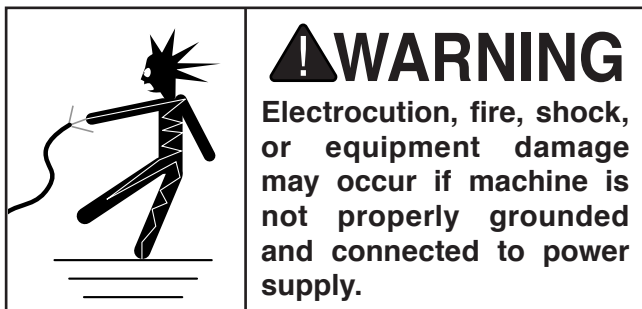
ADEQUATE VENTILATION. When melted, edgebanding glue pellets can produce vapors and fumes that may irritate the nose, throat, and respiratory tract. Only operate this machine with proper ventilation near work area.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 220V 19 Amps

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

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

Circuit Information

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

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

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

Circuit Requirements

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

- Nominal Voltage 220V, 230V, 240V
- Cycle 60 Hz
- Phase Single-Phase
- Power Supply Circuit 30 Amps
- Plug/Receptacle NEMA L6-30



Grounding Requirements

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

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

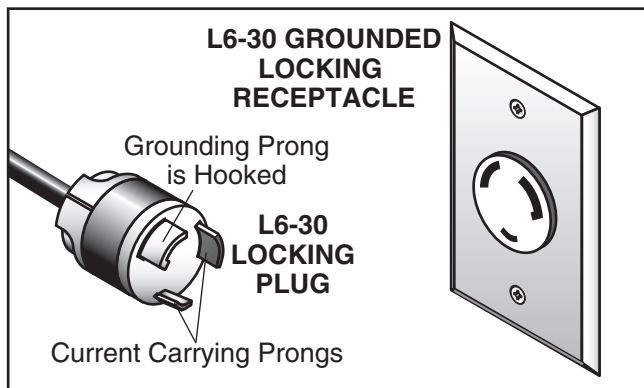
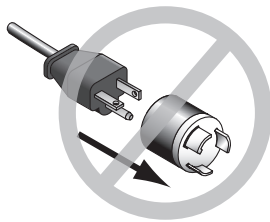


Figure 12. Typical L6-30 plug and receptacle.

!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.

!CAUTION



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

!WARNING

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

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

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

Extension Cords

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

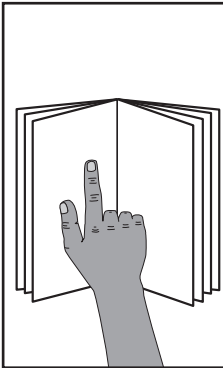
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

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

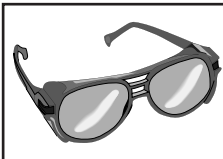


SECTION 3: SETUP



!WARNING

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



!WARNING

Wear safety glasses during the entire setup process!



!WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Another Person	1
• Safety Glasses (for each person).....	1
• Lifting Equipment (Rated for at least 1000 lbs.).....	1
• Hex Wrench 4, 6, 8mm	1 Ea.
• Wrench or Socket 8mm.....	1
• Open-End Wrench 17mm.....	1
• Open-End Wrench 24mm.....	1
• Solvent/Cleaner	1
• Shop Rags.....	1
• Straightedge	1
• Wire Snips	1

Unpacking

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

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



Inventory

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

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

NOTICE

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

Loose Item Inventory (Figure 13)		Qty
A.	Coil Support Mounting Arm.....	1
B.	Panel Feeder Elevation Handwheel.....	1
C.	Glue Pot Lid.....	1
D.	Grease Gun (Not Shown).....	1

Shipping Box Contents (Figure 14)		Qty
E.	Coil Support Assembly.....	1
F.	Hardware Bag	1

Hardware Bag Contents (Figure 15)		Qty
G.	Adjustable Guide Roller Assemblies.....	4
	—Threaded Roller Shafts	
	M8-1.25 x 12 x 52L	4
	—Bushings	4
	—Flat Washers 8mm.....	4
	—Roller Slide Nuts M8-1.25	4
H.	Coil Support Stud Assembly	1
	—Stud-FT M10-1.5 x 150	1
	—Lock Nut M10-1.5.....	1
	—Hex Nuts M10-1.5.....	2
	—Fender Washers 10mm	3

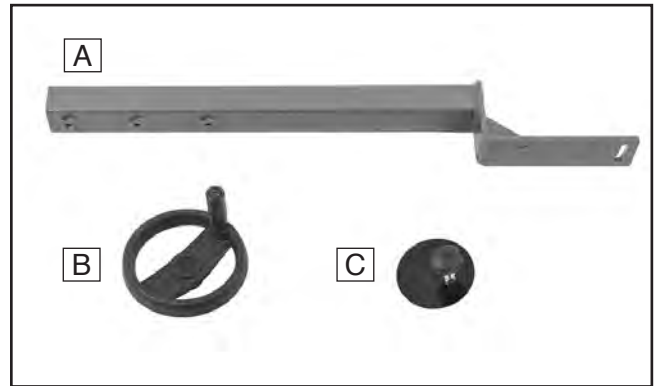


Figure 13. Loose item inventory.

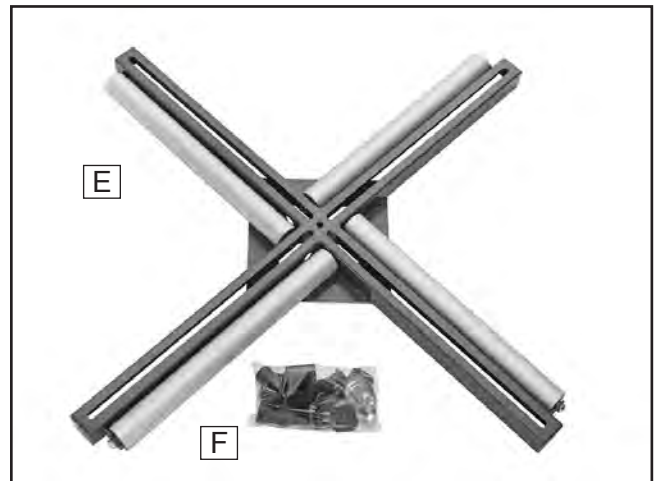


Figure 14. Shipping box contents.



Figure 15. Hardware bag contents.



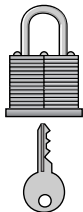
Site Considerations

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.
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Physical Environment

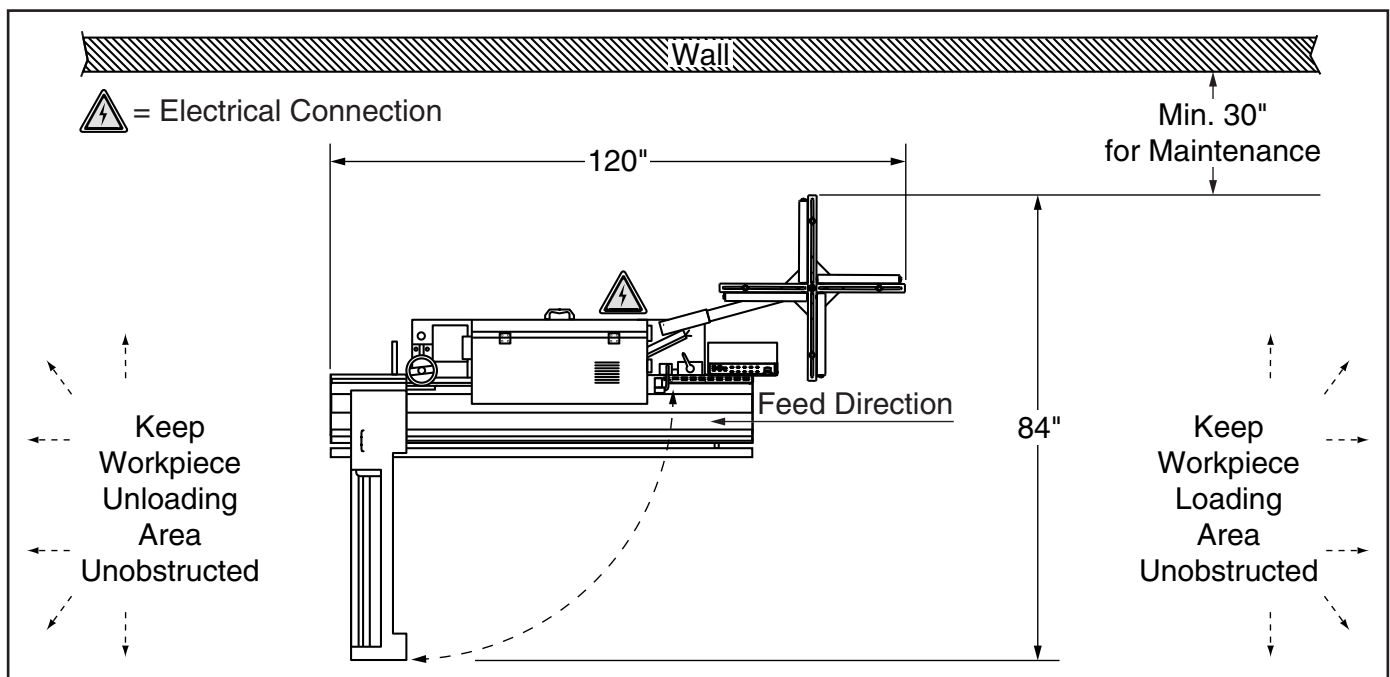
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions 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.

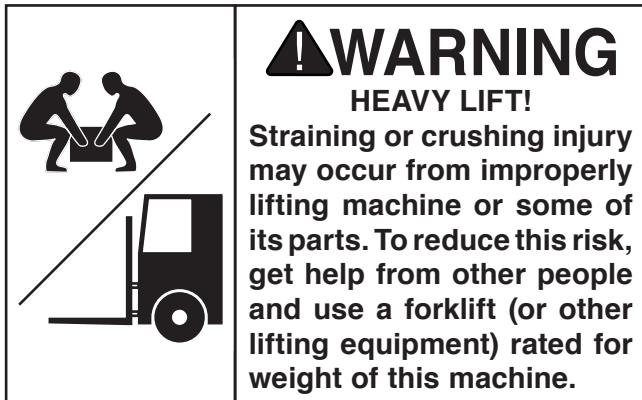
Lighting

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.



Lifting & Placing

It is always best to place machine on as flat a surface as possible to prevent tipping and rocking during operation. If the machine tips or rocks, and there is no other suitable location to place it, you will need to stabilize it, using the leveling bolts.



To lift and place machine:

1. Position crate with machine as close to installation location as possible.
2. Remove top of crate, then remove plastic wrap and small items packed around machine.
3. Position forklift forks as wide as possible while still fitting under center opening of edge-bander cabinet (see **Figure 17**). Protect machine body from forks with cardboard.



Figure 17. Inserting forks for lifting edgebander.

4. Unbolt machine from pallet.
5. Lift machine with forklift enough to clear pallet, then have an assistant slide pallet out of the way.
6. Position machine as necessary, then gently lower it onto floor.
7. Stabilize machine by loosening jam nuts and rotating leveling bolts (see **Figure 18**) until machine is level, then tighten jam nuts to secure. The leveling bolts are located at rear left and right corners of machine.

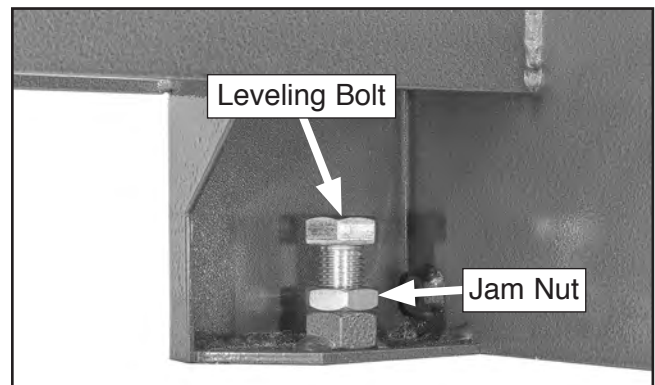


Figure 18. Location of (1 of 2) leveling bolts with jam nuts.



Assembly

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

Assembling the Model G0774 requires repositioning the control panel, installing the coil support assembly, installing the panel feeder elevation handwheel, and aligning the table extension with the table.

To assemble machine:

1. Remove (2) pre-installed M8-1.25 x 16 cap screws, (2) 8mm lock washers, and (2) 8mm flat washers that secure control panel in shipping position (see **Figure 19**).

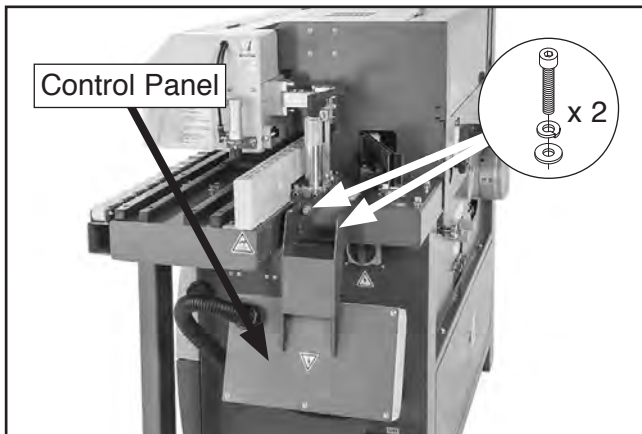


Figure 19. Location of cap screws and washers securing control panel upside-down for shipping.

2. Mount control panel upright with fasteners removed during **Step 1** (see **Figure 20**).

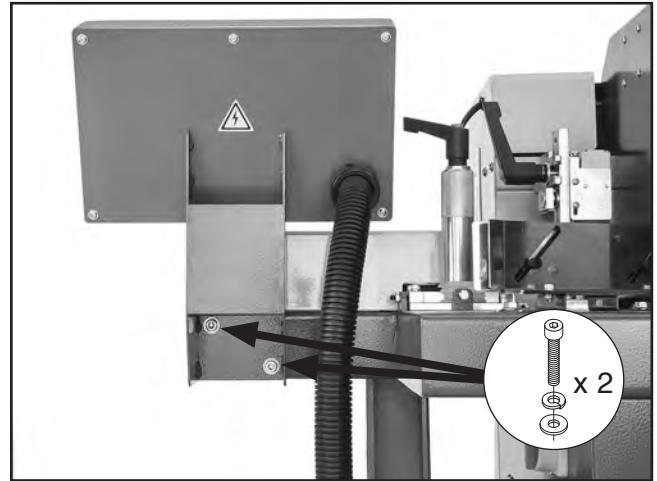


Figure 20. Control panel mounted in proper upright position (viewed from rear of machine).

3. Remove pre-installed M5-.8 x 45 cap screw and M5-.8 lock nut from panel feeder elevation handwheel (see **Figure 21**).



Figure 21. Location of pre-installed panel feeder elevation handwheel mounting hardware.



4. Install handwheel on panel feeder elevation shaft (see **Figure 22**), and secure with fasteners removed in previous step.

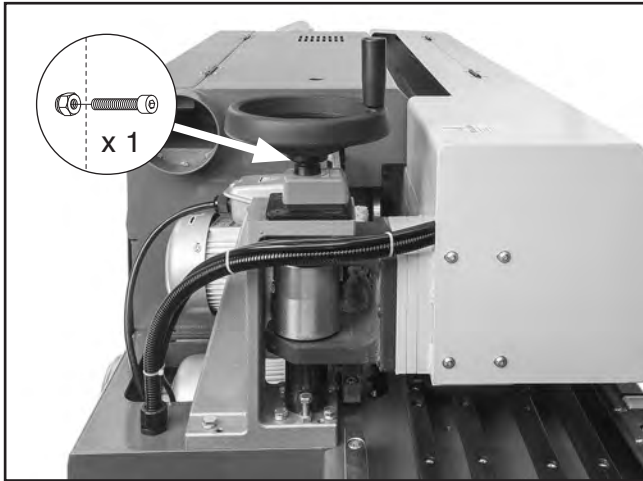


Figure 22. Panel feeder elevation handwheel installed.

5. Remove (2) pre-installed M8-1.25 x 20 cap screws, (2) 8mm lock washers, and (2) 8mm flat washers, then use them to install coil support arm (see **Figure 23**).

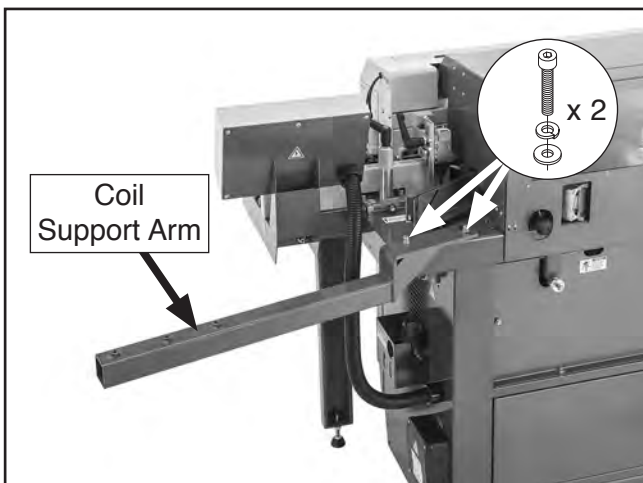


Figure 23. Coil support arm installed.

6. Remove (2) pre-installed M10-1.5 hex nuts and (2) 10mm fender washers from coil support stud (see **Figure 24**).

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

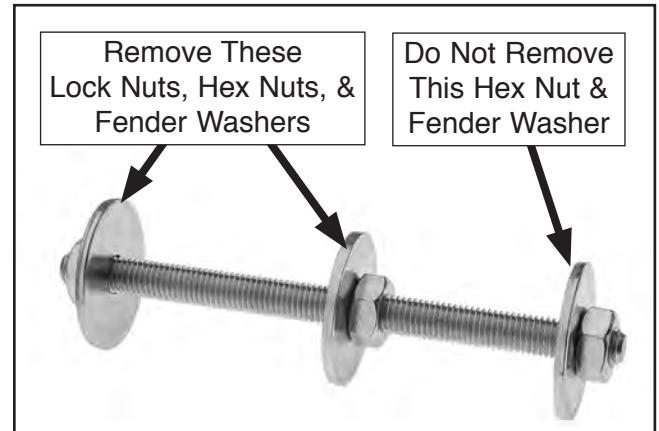


Figure 24. Coil support stud.

7. Thread stud up through bottom of coil support arm (see **Figure 25**).

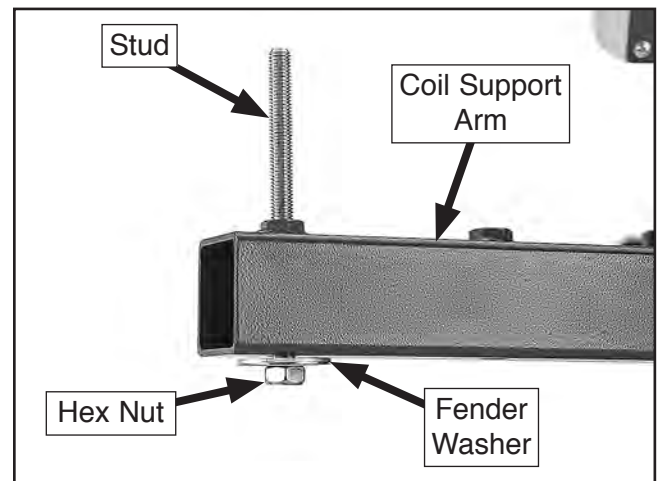


Figure 25. Stud threaded into coil support arm.



- Install (1) M10-1.5 hex nut and (1) 10mm fender washer on coil support stud (see **Figure 26**), and tighten hex nut against top of coil support arm, then tighten hex nut against bottom of support arm (see **Figure 26**).

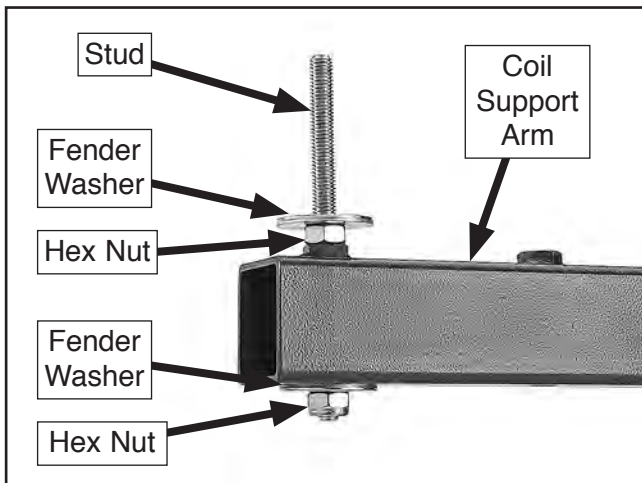


Figure 26. Stud secured against coil support arm.

- Install coil support assembly on stud and secure with remaining M10-1.5 lock nut and 10mm fender washer (see **Figure 27**).

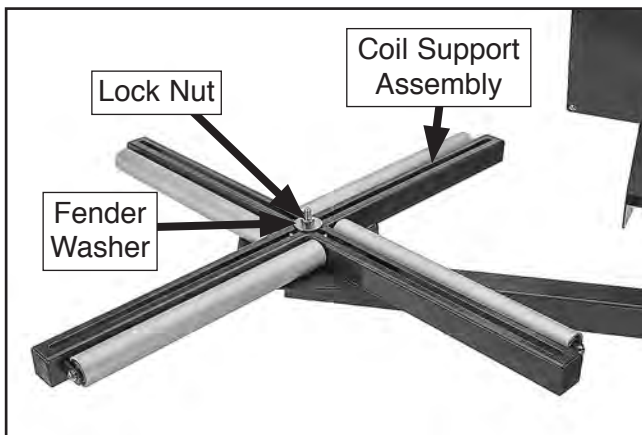


Figure 27. Coil support assembly installed.

- Remove slide nut from each of four guide roller assemblies (see **Figure 28**).

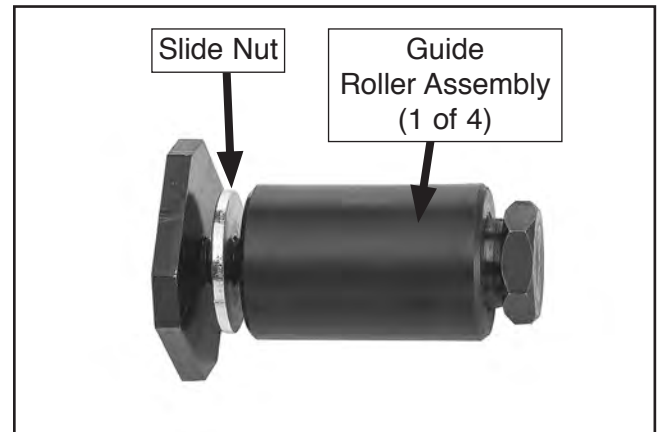


Figure 28. Guide roller assembly and slide nut (1 of 4).

- Place slide nut under slot in coil support assembly, then thread guide roller with washers into nut from above and tighten, as shown in **Figure 29**. Repeat with remaining three guide roller assemblies in each of the remaining slots.

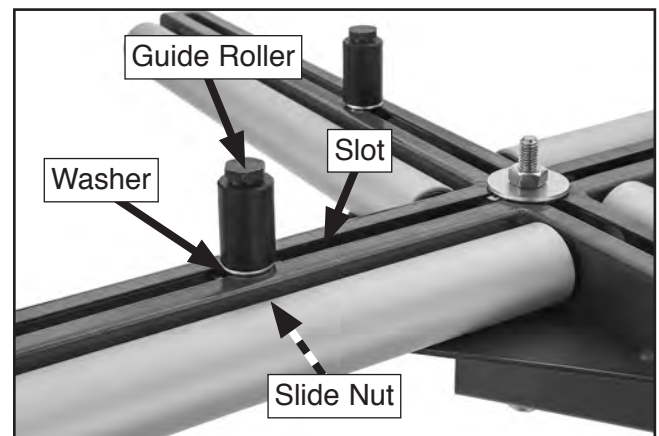


Figure 29. Guide roller installed in coil support slot.



12. Loosen panel feeder lock lever (see **Figure 30**).



Figure 30. Location of panel feeder lock lever.

13. Rotate panel feeder elevation handwheel clockwise to slightly raise panel feeder, then remove wood shipping blocks from infeed and outfeed ends of table (see **Figure 31**).

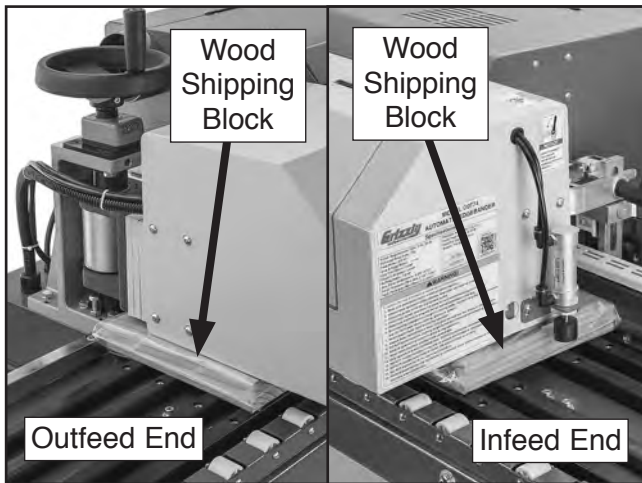


Figure 31. Location of wood shipping blocks to be removed.

14. Remove shipping tag from rear access cover, then open cover and remove shipping tag from end-trimming motor (see **Figures 32–33**).

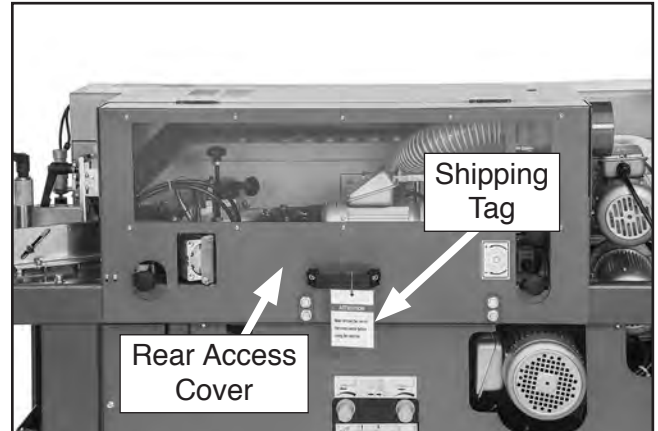


Figure 32. Location of rear access cover shipping tag to be removed.

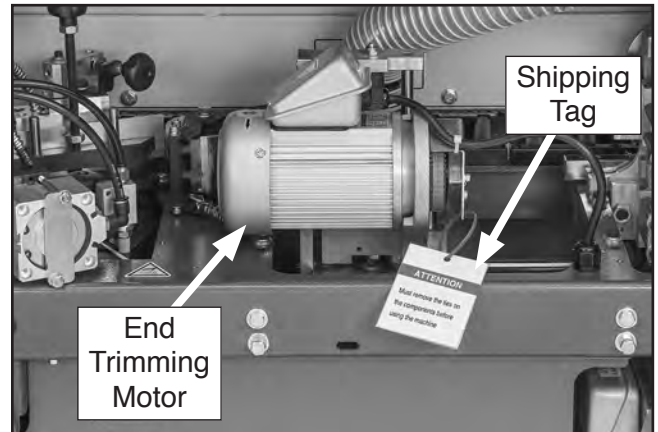


Figure 33. Location of end-trimming motor shipping tag to be removed.

15. Pull out extension table (see **Figure 34**) as far as it goes.



Figure 34. Extension table extended.



Cleanup

16. Place straightedge over infeed (right) end of main table and extension table. Make sure straightedge touches top of extension table roller above leg (see **Figure 34**).

- If straightedge makes solid contact across entire infeed end of main table and top of extension table roller, no adjustment is necessary. Proceed to **Step 18**.
- If straightedge does not make solid contact across entire infeed end of main table and top of extension table roller, extension table is not aligned with main table and must be adjusted. Proceed to **Step 17**.

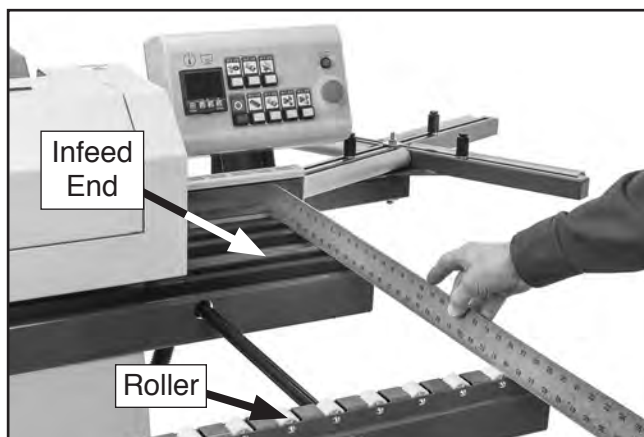


Figure 35. Checking extension table to see if it is aligned with main table.

17. Loosen jam nut at bottom of extension table leg, rotate adjustable foot nut until extension table is aligned with main table, then tighten jam nut against bottom of leg to secure setting (see **Figure 36**).

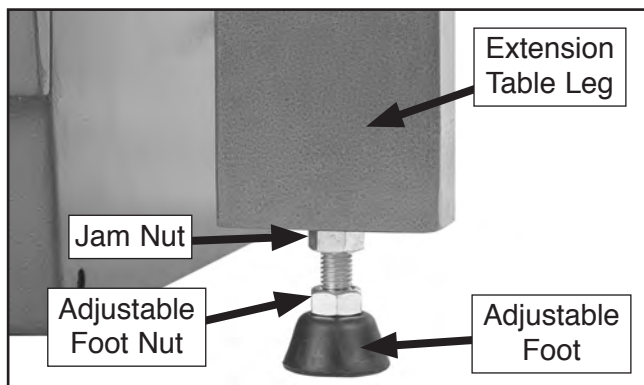


Figure 36. Location of extension table alignment components.

18. Repeat **Steps 16–17** for outfeed (left) end of table.

The heated infeed fence is coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning. The infeed fence gets extremely hot during operations, and could create harmful fumes if any residue is left on the fence.

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


Before cleaning, gather the following:

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


Basic steps for removing rust preventative:

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





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



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

NOTICE
Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.



Call
1-800-523-4777
To Order

Figure 37. T23692 Orange Power Degreaser.

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.

Recommended CFM at Dust Port: 800 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 hoses:

1. Fit a 4" dust hose over each dust port, as shown in **Figure 38**, and secure in place with hose clamps.
2. Tug hoses to make sure they do not come off. **Note:** A tight fit is necessary for proper performance.



Figure 38. Dust hoses attached to dust ports.



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:

- Glue pot powers up and reaches working temperature of 356° F (180° C)
- Heated infeed fence powers-up
- Guillotine and edge trimmer sensors power-up
- Each motor powers-up and runs correctly
- Emergency Stop button works correctly
- Safety limit switches work correctly

To test run machine:

1. Read and follow safety instructions at beginning of manual, take all required safety precautions, and make sure all previous setup/assembly steps in this manual have been followed and completed.

2. Ensure panel feeder is closed and locked, and rear access cover is closed. If either of these items is not properly closed, machine will not function.
3. Clear all setup tools and loose items away from machine.
4. Turn master power switch **OFF** and press Emergency Stop button in.
5. Connect machine to power by inserting power cord plug into a matching receptacle, then connect machine to an air supply and adjust air regulator to 100 PSI.
6. Twist Emergency Stop button clockwise until it springs out (see **Figure 39**). This resets switch so machine can start.

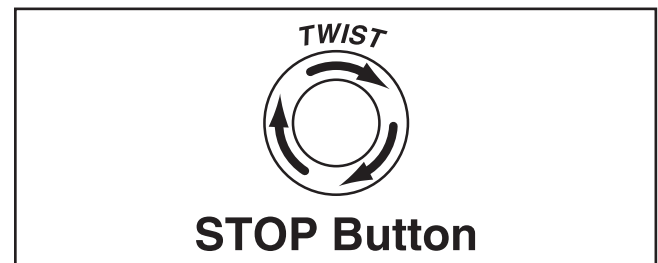


Figure 39. Resetting the switch.

7. Turn master power switch **ON**. Thermoregulator display on control panel should illuminate (see **Figure 40**).

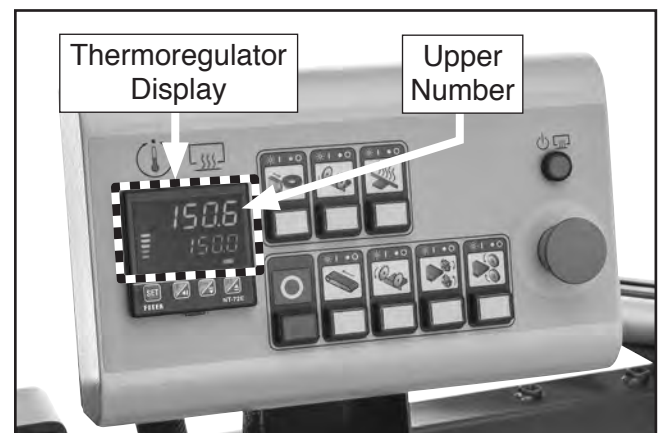


Figure 40. Thermoregulator display illuminated after master power switch turned **ON**.



8. Watch thermoregulator display and listen for glue spindle motor to start. When upper number (see **Figure 40** on **Page 30**) reaches 180° C, glue spindle motor should turn **ON**.

Note: Spindle motor won't turn **ON** if Emergency Stop Button is in.

9. Press guillotine sensor ON/OFF button (see **Figure 41**); button should illuminate, indicating sensor is activated. Press button again; button should darken, indicating sensor is no longer activated.

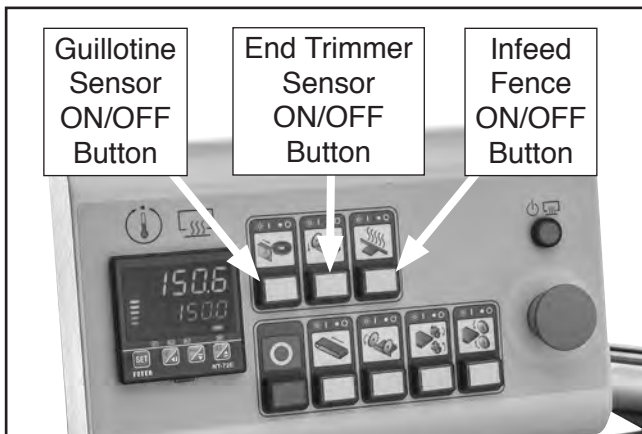


Figure 41. Guillotine sensor, end trimmer sensor, and infeed fence ON/OFF buttons.

10. Perform same activation test (**Step 9**) for end trimmer sensor (see **Figure 41**).
11. Press infeed fence ON/OFF button (see **Figure 41**); button should illuminate, indicating fence is heating up. Press button again; button should darken, indicating fence is no longer heating and has begun to cool down.

! WARNING

Fence gets extremely hot—up to 410°F (210°C). To avoid serious burns, **DO NOT** touch fence while it is turned **ON** or while still hot after being turned **OFF**.

12. Press panel feeder ON/OFF button (see **Figure 42**). Button should illuminate. Panel feeder motor should start up and run smoothly without any unusual problems or noises.

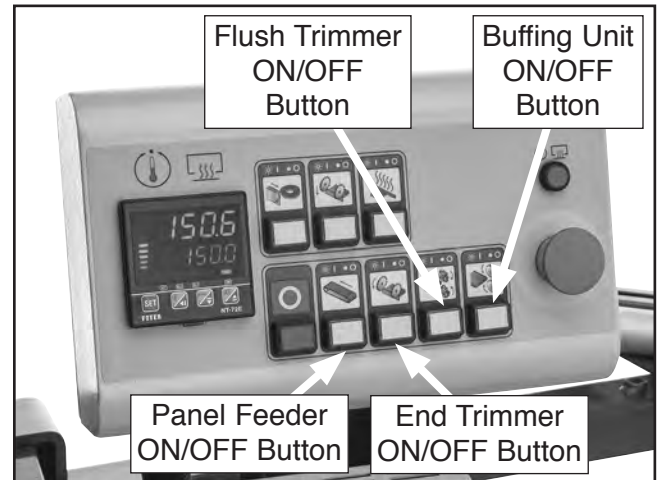


Figure 42. Panel feeder, end trimmer, flush trimmer, and buffering unit ON/OFF buttons.

13. Perform same motor test (**Step 12**) for end-trimmer, flush trimmer, and buffering unit motors (see **Figure 42**).
14. Turn all upper and lower green ON/OFF buttons **ON** (see **Figure 43**).

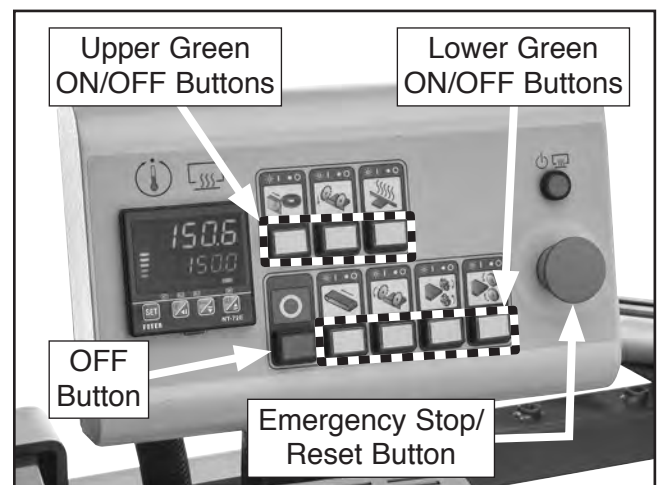


Figure 43. Upper and lower green ON/OFF buttons, OFF button, and Emergency Stop/Reset button.



15. Press OFF button (see **Figure 43** on **Page 31**). All *upper* green ON/OFF buttons should *remain illuminated*. All *lower* green ON/OFF buttons should *darken*, and the following motors should turn **OFF**.

- panel feeder
- end trimmer
- flush trimmer
- buffing unit

16. Press all lower green ON/OFF buttons again. They should illuminate and their respective motors should turn **ON**.

17. Press Emergency Stop button (see **Figure 43** on **Page 31**). All upper *and* lower green ON/OFF buttons should darken, and their respective components and motors should turn **OFF**.

Note: *The only machine functions that should still be in operation are glue pot heating element and thermoregulator display.*

18. WITHOUT resetting Emergency Stop button, press each green ON/OFF button one at a time.

- If *no* green ON/OFF buttons illuminate and *no* sensors activate or motors turn **ON**, the Emergency Stop button safety feature is working correctly. Proceed to **Step 19**.
- If *any* green ON/OFF buttons illuminate and *any* sensors activate or motors turn **ON**, immediately turn master power switch **OFF** and disconnect machine from power. The Emergency Stop button safety feature is not working correctly. This safety feature must work correctly before proceeding with regular operations. Call Tech Support for help.

19. Twist Emergency Stop button to reset it.

20. Open rear access cover, then press each green ON/OFF button one at a time.

- If *no* green ON/OFF buttons illuminate and *no* sensors activate or motors turn **ON**, the rear access cover safety limit switch is working correctly. Proceed to **Step 21**.
- If *any* green ON/OFF buttons illuminate and *any* sensors activate or motors turn **ON**, immediately turn master power switch **OFF** and disconnect machine from power. The rear access cover safety limit switch is not working correctly. This safety feature must work correctly before proceeding with regular operations. Call Tech Support for help.

21. Open panel feeder, then press each green ON/OFF button one at a time.

- If *no* green ON/OFF buttons illuminate and *no* sensors activate and *no* motors turn **ON**, the feeder panel safety limit switch is working correctly. Congratulations! The Test Run is complete.
- If *any* green ON/OFF buttons illuminate and *any* sensors activate or motors turn **ON**, immediately turn master power switch **OFF** and disconnect machine from power. The feeder panel safety limit switch is not working correctly. This safety feature must work correctly before proceeding with regular operations. Call Tech Support for help.




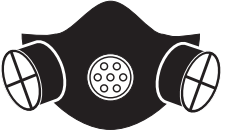
SECTION 4: OPERATIONS

Operation Overview

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

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

	<p>!WARNING To reduce your risk of serious injury, read this entire manual BEFORE using machine.</p>
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<p>!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.</p>	
	

<p>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.</p>
--

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

1. Checks to make sure there is enough glue in the glue pot.
2. Examines workpiece to make sure it is suitable for edgebanding.
3. Sets panel feeder height according to workpiece thickness.
4. Adjusts positions of infeed fence, glue spindle guide plate, glue flow, and flush trimmers according to edgebanding thickness.
5. Installs correct size of edgebanding coil for workpiece thickness.
6. Puts on safety glasses and a respirator.
7. Connects machine to air and power, verifies air pressure is set to 100 PSI, and waits for glue pot to reach at least 180°C.
8. Activates guillotine and end-trimmer sensors and turns infeed fence **ON**. Waits for infeed fence to heat up.
9. Sets glue temperature according to glue manufacturer's instructions, then waits for glue pot to reach that temperature.
10. Turns **ON** panel feeder, end trimmer, flush trimmer, and buffing unit.
11. Places workpiece against heated infeed fence, and slides it under panel feeder, allowing panel feeder to take control of workpiece.
12. Receives edgebanded workpiece at outfeed end of machine.
13. When finished, stops machine, turns it **OFF**, and disconnects it from power.



Setting Glue Pot Temperature

The glue pot ON/OFF is controlled by the master power switch. The glue pot temperature can be adjusted, according to the glue manufacturer's recommendation, by using the buttons on the digital display.

The glue pot will reach working temperature when the actual temperature is within 10° of the set temperature, at which point the glue spindle will begin to spin.

To set glue pot temperature:

1. Turn master power switch **ON**.
2. Press 'Set' button on control panel (see **Figure 44**). Lower (green) digit will begin to flash.

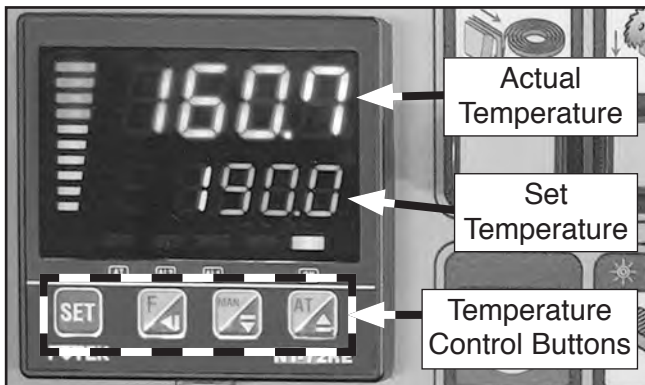


Figure 44. Temperature control panel.

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

Standby Mode

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

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



Checking/Adding Glue

The G0774 uses a glue pot system that melts glue pellets and dispenses the melted glue using a spindle.

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

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

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

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

Always check the glue level before starting the edgebander and periodically during operations. The glue pot is full when the melted glue reaches $\frac{3}{4}$ " (2cm) below the top of the pot. DO NOT overfill the glue pot.

Note: For instructions on removing and changing glue, refer to **Removing/Changing Glue** on **Page 55** of the **Service** section.

Items Needed	Qty
Glue Pellets	As Needed



To check/add glue:

1. Press Emergency Stop/Reset button.
2. Open rear access cover and remove glue pot lid (see **Figure 45**). Determine if pot needs glue pellets (see **Figure 45**).

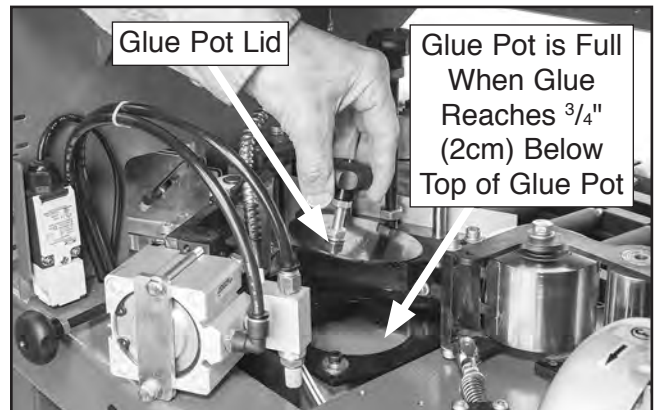


Figure 45. Checking glue level in glue pot.

3. Carefully add glue pellets until glue reaches $\frac{3}{4}$ " (2cm) below top of glue pot, then close glue pot lid and close rear access cover.

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



Setting Panel Feeder Height

The panel feeder must be set to match the workpiece thickness. The height adjusts with a handwheel and locks in place with a lock lever. Below the panel feeder elevation handwheel is a numerical display that shows the height of the panel feeder in millimeters.

To set panel feeder height:

1. Measure workpiece thickness in millimeters.
2. Loosen panel feeder lock lever (see **Figure 46**).



Figure 46. Location of panel feeder lock lever.

3. Rotate panel feeder elevation handwheel until numerical display on base of handwheel matches measurement from **Step 1** (see **Figure 47**). Rotate handwheel *clockwise* to raise panel feeder; rotate handwheel *counterclockwise* to lower panel feeder.

Note: When adjusting panel feeder down, lower 3–4 digits past desired position and then raise back up to desired position to eliminate backlash in the worm gear.

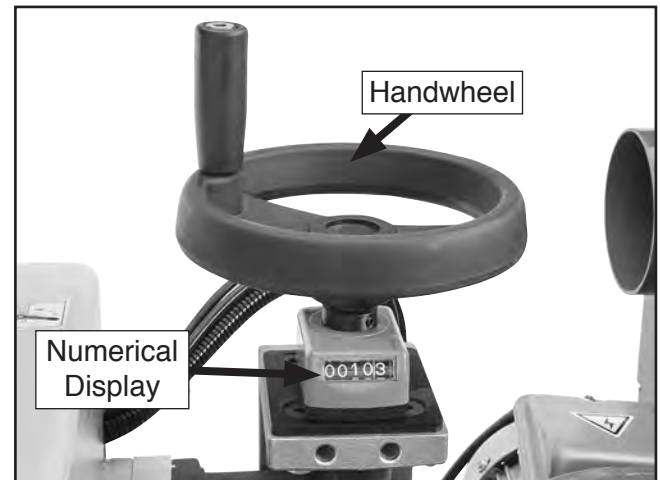


Figure 47. Panel feeder elevation handwheel with numerical display.

4. Retighten panel feeder lock lever (see **Figure 46**) to secure panel feeder.



Setting Infeed Fence Position

The infeed fence position is set according to the edgebanding thickness.

There are two methods for setting the infeed fence position: 1) using the infeed fence scale, and 2) using the infeed fence stop (see **Figure 48**).

Use whichever method best suits your needs and situation.

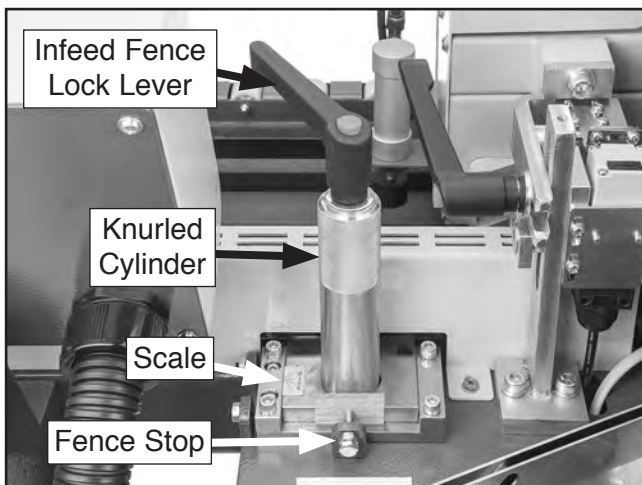


Figure 48. Infeed fence adjustment components.

Using Infeed Fence Scale

The numbers on the infeed scale correspond to the edgebanding thickness (in millimeters). When using the infeed scale, simply adjust the fence until the scale indicates the correct edgebanding thickness.

To set infeed fence position using scale:

1. Carefully measure thickness of edgebanding to be used.
2. Loosen infeed fence adjustment lock lever, rotate knurled cylinder until number indicating thickness of edgebanding aligns with mark on scale (see **Figure 48**), then retighten lock lever.

Using Infeed Fence Stop

The infeed fence stop allows you to quickly and easily set the infeed fence position without having to use the scale. It is particularly useful when switching back and forth between different edgebanding thicknesses, or when the thickness of the edgebanding cannot be expressed in whole millimeters.

With this method, you place a scrap piece of the edgebanding you intend to use between the stop bolt and stop plate (see **Figure 49**), then adjust the fence until the stop plate presses firmly against the scrap piece.

Note: For best results, the infeed fence stop should be periodically checked for accuracy and, if necessary, calibrated (see **Checking/Calibrating Infeed Fence Stop** on **Page 54** for details).

To set infeed fence position using stop:

1. Cut a 1"–3" long section from edgebanding you intend to use.
2. Loosen infeed fence adjustment lock lever, then rotate knurled cylinder to create a gap between stop plate and stop bolt (see **Figure 49**).
3. Place scrap piece from **Step 1** between stop bolt and stop plate, as shown in **Figure 49**.

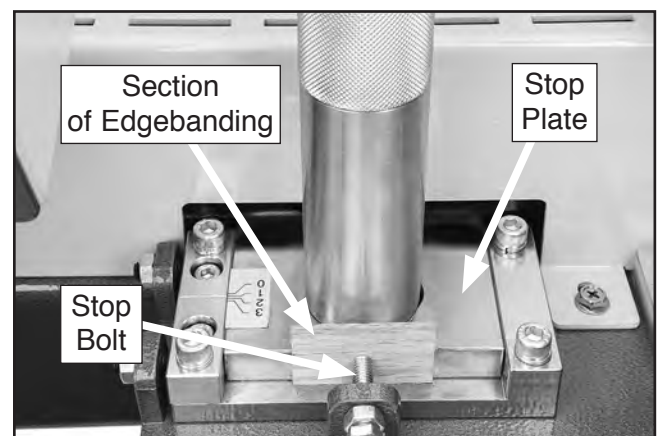


Figure 49. Using infeed fence stop to set infeed fence position.

4. Rotate knurled cylinder until stop plate presses firmly against scrap piece, then tighten infeed fence lock lever to secure setting.



Checking/Adjusting Guide Plate

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

The guide plate keeps the workpiece the proper distance from the glue spindle to help control the amount of glue that is applied.

Items Needed	Qty
Workpiece at Least 27" Long	1
Hex Wrench 3mm.....	1
Leather Gloves	1 Pair

⚠ CAUTION

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

To check/adjust guide plate:

1. Press Emergency Stop/Reset button.
2. Make sure glue pot has sufficient amount of glue (see **Page 35**) and is at working temperature.
3. Set infeed fence to desired position (see **Page 37**).

4. Move spindle all the way forward by turning glue spindle adjustment knob counterclockwise until it stops (see **Figure 50**).



Figure 50. Location of glue spindle adjustment knob.

5. Open panel feeder, then place straight edge of workpiece against infeed fence.
6. While maintaining inward pressure and keeping workpiece flat against infeed fence, slide workpiece across guide plate and over glue spindle, as shown in **Figure 51**.

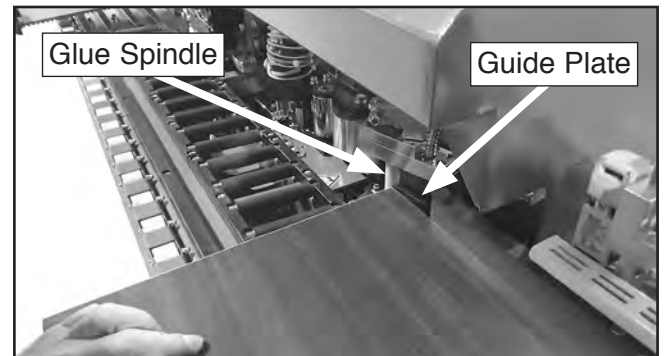
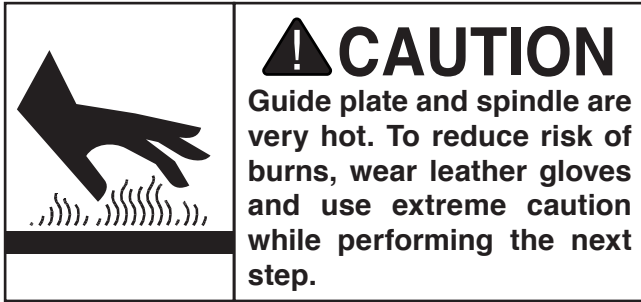


Figure 51. Checking guide plate position.

- If workpiece edge is approximately 0.5mm away from glue spindle, no adjustments are necessary. Close panel feeder.
- If workpiece is more than 0.5mm away or touches the glue spindle, the guide plate is not properly adjusted. Proceed to **Step 6**.





- Turn set screw located in face of guide plate to adjust depth (see **Figure 52**).

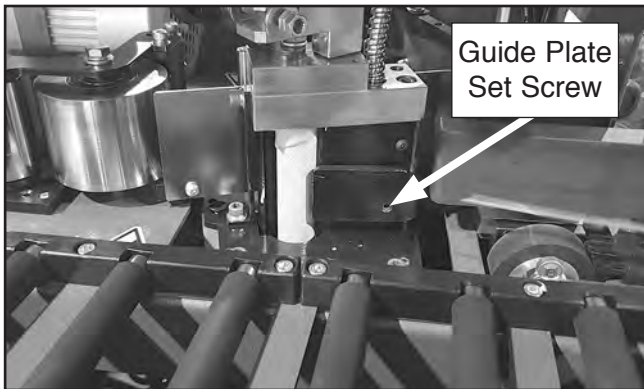


Figure 52. Location of guide plate set screw.

- Turn set screw *clockwise* to move workpiece away from glue spindle.
- Turn set screw *counterclockwise* to move workpiece closer to glue spindle.

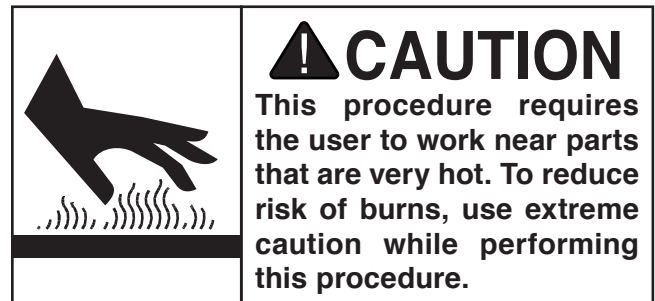
- Repeat **Steps 6–7** until workpiece is about 0.5mm away from glue spindle.

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

- Close panel feeder.

Adjusting Glue Flow

Excess glue can cause build-up on flush trimmer blades and buffing wheels. Adjusting the glue flow so that the residual amount is minimal will increase the life of the finishing blades and wheels, as well as reduce clean-up of the finished product.



To adjust glue flow:

- Press Emergency Stop/Reset button.
- Open rear access cover.
- Rotate glue flow adjustment knob counterclockwise to increase glue flow; rotate clockwise to decrease glue flow (see **Figure 53**).

Note: Make adjustments only $\frac{1}{2}$ of a full turn at a time.

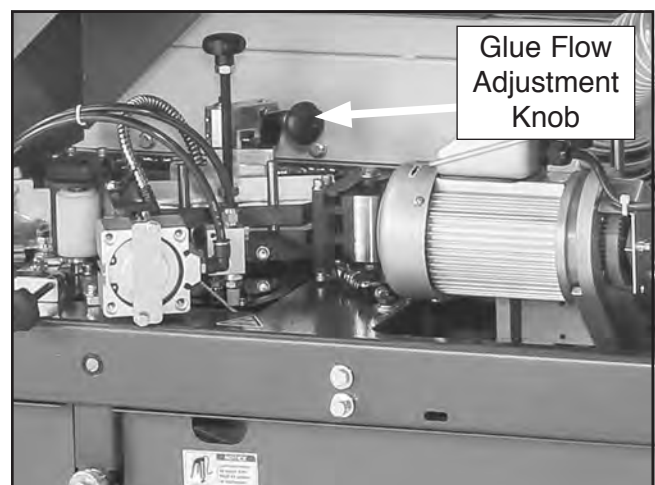


Figure 53. Location of glue flow adjustment knob.



Adjusting Flush Trimmer

The flush trimmer trims excess height off of the upper and lower edges of newly applied edgebanding, making it flush with the top and bottom of the workpiece.

The flush trimmer consists of two cutterheads (one upper and one lower) that must each be separately adjusted toward or away from the workpiece, according to the edgebanding thickness. Always adjust upper and lower cutterheads equally.

To adjust flush trimmer:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Carefully measure thickness (in millimeters) of edgebanding you intend to use.
3. Rotate each flush trimmer adjustment knob until number displayed in readout equals thickness of edgebanding (see **Figure 54**).

Note: Rotate knobs counterclockwise to move flush trimmers closer to workpiece; rotate knobs clockwise to move them farther away. When adjusting down, lower past desired position by 3–4 digits and then raise back up to desired position to eliminate backlash in the worm gear.

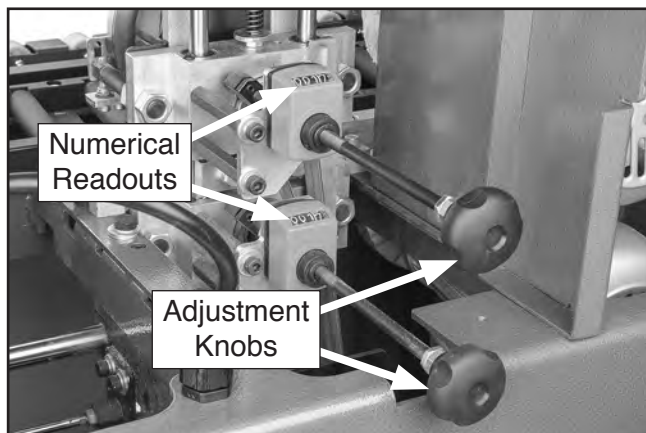


Figure 54. Location of flush trimmer adjustment knobs (rear access cover opened for illustration purposes).

Installing Edgebanding Coil

The edgebanding coil (not included) is a coiled strip of wood or plastic veneer that is automatically fed into the edgebander and glued to the workpiece edge during the edgebanding process. The Model G0774 Automatic Edgebander uses edgebanding tape from 1/2"–1 3/4" wide.

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

The edgebanding tape *thickness* affects machine setup. Before installing the edgebanding coil, the following components should be checked and, if necessary, adjusted, depending on the edgebanding tape thickness:

- Heated infeed fence position (see **Page 37**)
- Guide plate position (see **Page 38**)
- Upper and lower flush trimmer positions

To install edgebanding coil:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Loosen edgebanding height knobs on intake guides (see **Figure 55**), raise knobs to allow room for edgebanding tape, then tighten to secure.

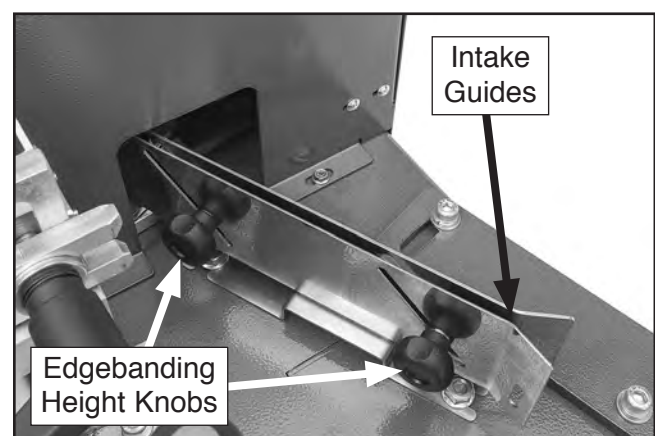


Figure 55. Location of edgebanding height knobs.



3. Loosen guide rollers on coil support (see **Figure 56**) and move them out to allow room for edgebanding coil.
4. Center edgebanding coil on coil support. Move guide rollers so they just touch coil, then tighten to secure (see **Figure 56**).

Note: Ensure coil can rotate freely. If coil cannot rotate freely, re-adjust guide rollers until it can.

5. Insert end of edgebanding tape into intake guides (see **Figures 55–56**).

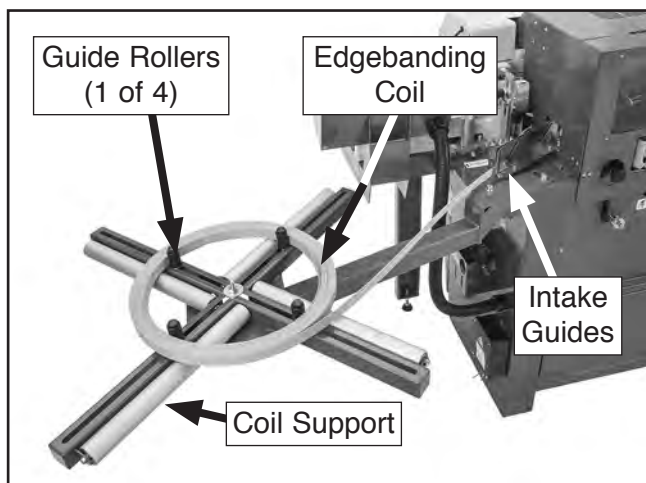


Figure 56. Edgebanding coil installed on coil support.

6. Rotate edgebanding seat adjustment knob (see **Figure 57**) clockwise to raise upper portion of seat and allow room for edgebanding tape.
7. Move nylon roller release knob to the right and manually advance edgebanding tape all the way forward, past nylon roller, to end of edgebanding seat (see **Figure 57**).

Note: Nylon roller release knob is spring-loaded. Hold it in released position (to the right) while you manually move edgebanding tape past roller.

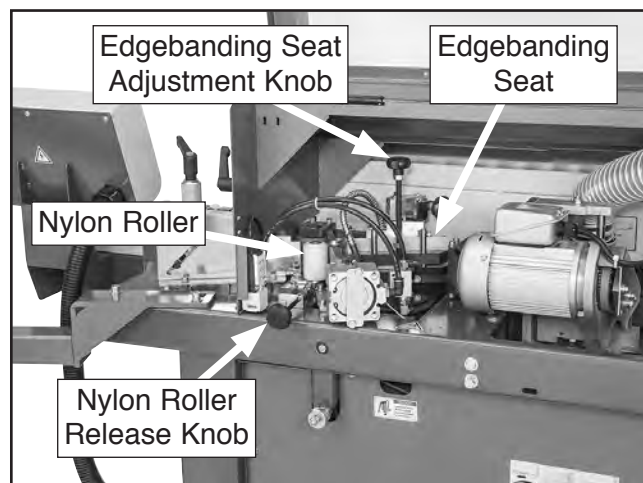


Figure 57. Edgebanding tape advanced to forward end of edgebanding seat (viewed from rear of machine).

8. Rotate edgebanding seat adjustment knob counterclockwise to lower upper portion of seat until edgebanding tape has just enough room to move freely back and forth. Leave approximately $\frac{1}{32}$ " vertical play.



9. Loosen edgebanding height knobs from **Step 2** on **Page 40**, adjust knobs until edgebanding tape has just enough room to move freely back and forth, then tighten to secure. Leave approximately $\frac{1}{32}$ " vertical play.
10. Move nylon roller release knob to the right, then manually move edgebanding tape back, until its end is just in front of nylon roller (see **Figure 58**). The edgebanding tape is now properly set up in starting position for operations.

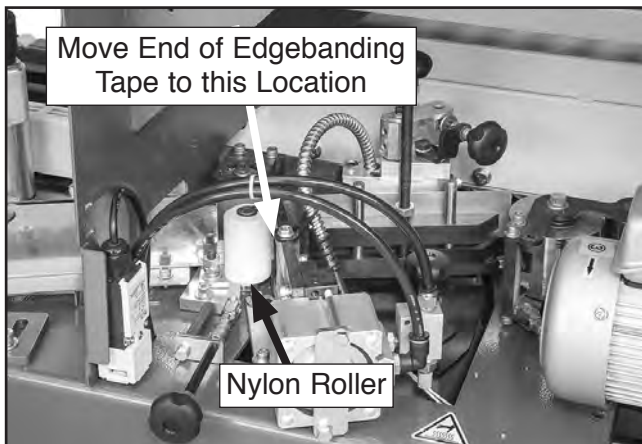


Figure 58. Starting position for edgebanding tape (viewed from rear of machine).

Performing Edgebanding Operation

Once all of the initial setup is complete, performing the edgebanding operation is a relatively simple and quick procedure.

Any workpiece you intend to edgeband with the G0774 must have at least one straight and square edge that is at least $9\frac{1}{2}$ " long.

It is always best to start with a test piece of the same material and dimensions as your intended workpiece, in order to verify all of your settings are correct.

Note: *Spindle motor won't turn **ON** if emergency stop button is pressed.*

For long workpieces that extend beyond the length of the table, it may be helpful to set up roller stands at either end of the table to add additional workpiece support during operations.

To perform edgebanding operations:

1. Read and follow all safety and initial setup instructions described earlier in this manual.
2. Inspect workpiece to make sure it is suitable for edgebanding.
3. Properly adjust panel feeder elevation (refer to **Page 36**), infeed fence position (refer to **Page 37**), and flush trimmer (refer to **Page 40**).
4. Properly install edgebanding coil (refer to **Page 40**).
5. Press Emergency Stop button, turn master power switch **ON**.

IMPORTANT: *In **Steps 5–9**, Emergency Stop button must be released before spindle motor will turn.*



6. Rotate Emergency Stop button to reset it, then press lower green ON/OFF buttons to start machine (see **Figure 59**).
7. Use Temperature UP/DOWN keys to set glue pot temperature according to glue manufacturer's instructions. Wait for glue pot to reach at least 180°C, then glue spindle motor will start (see **Figure 59**).

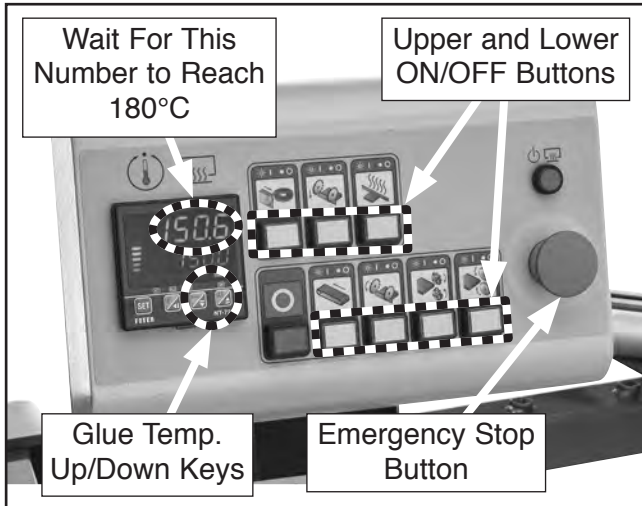


Figure 59. Location of edgework controls.

8. Press upper green ON/OFF buttons, shown in **Figure 59**, to activate pneumatic guillotine sensor, end trimmer sensor, and heated infeed fence.
9. Wait for glue pot (see glue manufacturer's instructions) and infeed fence to reach working temperatures. Machine is now ready to begin edgeworking.
10. Place straight edge of workpiece on infeed end of table and press it firmly against infeed fence, as shown in **Figure 60**.

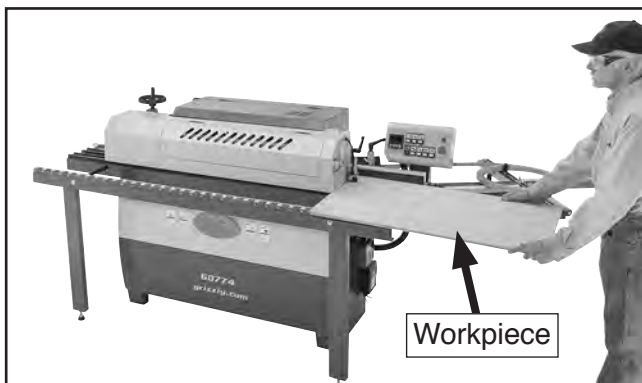


Figure 60. Placing workpiece on table in preparation for edgeworking.

11. Carefully slide workpiece under panel feeder, making sure to keep hands and fingers away from moving conveyor belt. When you feel panel feeder grab workpiece, allow panel feeder to advance workpiece through to outfeed end of table (see **Figures 61–62**).

Note: For long workpieces, it may be necessary to support trailing end of workpiece with your hands or a roller stand until it begins to move across table.

Then, as workpiece begins to exit outfeed end of table, support leading end of workpiece with hands or roller stand while panel feeder continues to feed workpiece through.



Figure 61. Panel feeder advancing workpiece.



Figure 62. Location of conveyor belt (panel feeder shown in open position for illustration purposes).

12. Receive edgeworked workpiece at outfeed end of table (see **Figure 61**). Allow panel feeder to completely finish feeding workpiece, then remove workpiece from table.



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.

Replacement Flush Trimmer Blades

T28529—Upper Blades, Pack of 4

T28530—Lower Blades, Pack of 4

Keep your flush trimmer moving fast and smooth! These replacement blades are the perfect fit for the cutterheads on the G0774.



Figure 63. T28529 Upper Replacement Flush Trimmer Blades.

T27707—Edgebanding Glue Pellets, 44 lb.

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

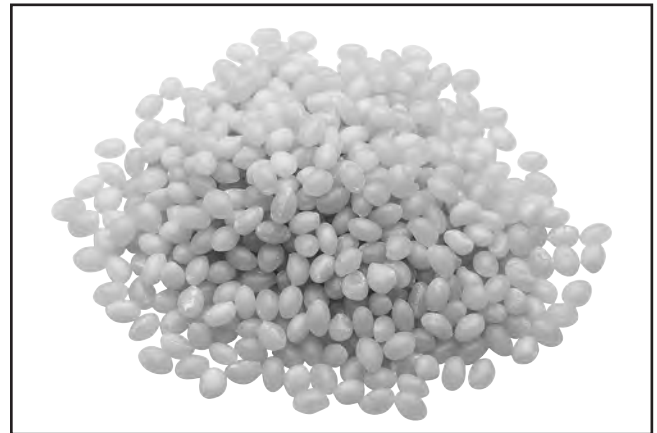


Figure 64. T27707 Edgebanding Glue Pellets.

Lubrication

T26685—Moly-D Multi-Function Machine Oil

T26419—Syn-O-Gen Synthetic Grease



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



G0825—Portable Edgebander w/Case & Kit

Easily apply edgework from 3/8" to 2 1/2" wide along straight runs, around bends, and inside corners! This machine combines the great features of a stationary edgeworking machine (hot melt glue application, speed feeding, and temperature control) with the convenience and portability of a handheld tool. Comes with a deluxe hard case with extension handle and roller wheels.



Figure 65. G0825 Portable Edgebander w/Case & Kit.

T1189—Dual End Cutter for G0825

The dual-support design of this Cutter means greater stability for straight edgeworking seams. Cutter features line compensation adjustment for precise end seams, and the frame body pivots for sharp corner-cut alignment.



Figure 66. T1189 Dual End Cutter for G0825.

T1188—Edgebander Trimmer for G0825

This trimmer features a micro-adjustment scale for precision edging and is designed to take on the tight 1" inner radius of the G0825 Edgebander for a perfect finish. Also included is a built-in dual-purpose razor for removing banding edge by hand. And the built-in dust collection cover keeps clean-up to a minimum.



Figure 67. T1188 Edgebander Trimmer.

T1187—Stationary Work Table for G0825

Enjoy the benefits of a stationary edgeworking machine with the added convenience of the Portable Edgebander. Simply attach the G0825 Edgebander to the table and accurately run straight or curved pieces. Includes built-in on/off button and magnetic switch.

Table size: 31 1/2"W x 17"D x 11 1/2"H.

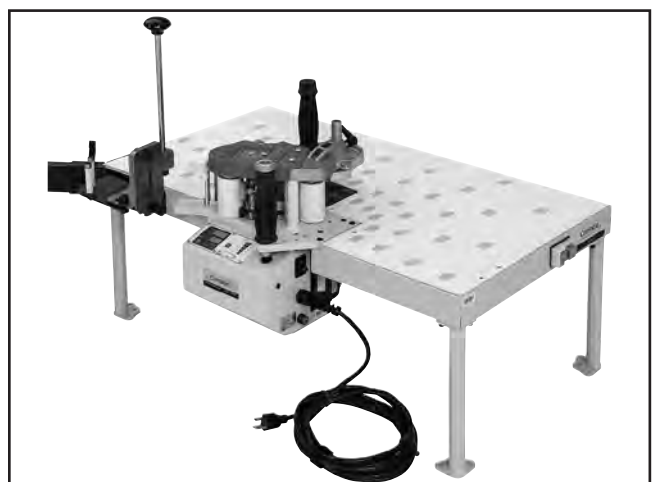


Figure 68. T1187 Stationary Work Table for G0825.

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



Basic Eye Protection

- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20451—"Kirova" Clear Safety Glasses
- T20452—"Kirova" Anti-Reflective S. Glasses
- T20456—DAKURA Safety Glasses, Black/Clear



Figure 69. Assortment of basic eye protection.

Basic Respirators

- H3631—Low Maintenance Respirator, Med
- H3632—Low Maintenance Respirator, Large
- H2499—Low Maintenance Respirator, Small



Figure 70. H3631 Low Maintenance Respirator.

G1029Z2P—2HP Dust Collector

The great combination of price and performance make this one of the most popular dust collectors we sell. Perfect for use as a central dust collector in a small shop or as a "dedicated" dust collector next to an industrial machine. Features 240V single-phase power, 1550 CFM, 2.5 micron filtration, and a 6" main inlet w/included 4" x 2" "Y" fitting.



Figure 71. G1029Z2P 2HP Dust Collector.

H7978—Fractional Digital Caliper.

Large LCD readout converts to decimal inch, fractional inch and millimeters with the push of a button. Measure internal, external dimensions, depth, steps and differential measurements. Features thumb roll and stainless steel construction. Range: 0-6", 0-150mm. Resolution: 0.0005", 0.01mm, $\frac{1}{128}$."

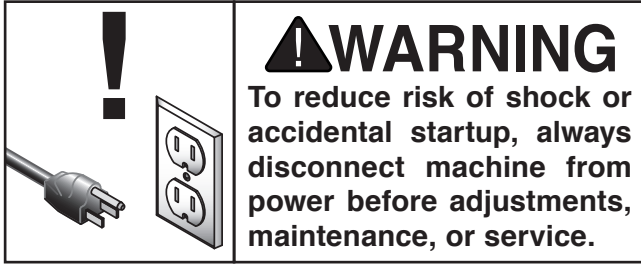


Figure 72. H7978 Fractional Digital Caliper.

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



SECTION 6: MAINTENANCE



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:

- Lubricate glue spindle (see **Page 48**).
- Clean/Lubricate end-trimming motor sliders (see **Page 48**).
- Check for dull or damaged end-trimming saw blade(s) (see **Page 56**).
- Check for dull or damaged flush-trimmer knives (see **Page 57**).
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance

- Clean off any glue residue on machine.
- Drain water in air filter collection cups.
- Lubricate flush-trimmer adjustment shafts (see **Page 49**).
- Clean and lubricate guillotine assembly.
- Blow dust out of motor fans with compressed air.

Monthly Check

- Clean/vacuum dust buildup from all edge-banding components and motors.
- Lubricate edgebanding feed gears (see **Page 49**).
- Lubricate flush-trimmer adjustment shafts
- Motor belt tension, damage, or wear.
- Conveyor belt tension, damage, or wear.
- Inspect entire machine for loose parts or signs of abnormal wear.

Cleaning & Protecting

Cleaning the Model G0774 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth, or blow off with compressed air. If any resin has built up, use a resin-dissolving cleaner to remove it.

Protect the unpainted cast-iron infeed fence by wiping it clean after every use and after it cools—this ensures moisture from wood dust does not remain on the bare metal surface. Keep the infeed fence rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray

H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 73. Recommended products for protecting unpainted cast iron infeed fence.



Lubrication

NOTICE

The recommended lubrication is based on light-to-medium usage. Keeping in mind that lubrication helps to protect the value and operation of the machine, these lubrication tasks may need to be performed more frequently than recommended here, depending on usage.

Failure to follow reasonable lubrication practices as instructed in this manual could lead to premature failure of machine components and will void the warranty.

Glue Spindle

Lube Type T26419 or NLGI#2 Equivalent
Lube Amount As Needed
Lube Frequency 30 Hours of Use

The glue spindle is lubricated by a grease fitting on the back of the machine (see **Figure 74**).

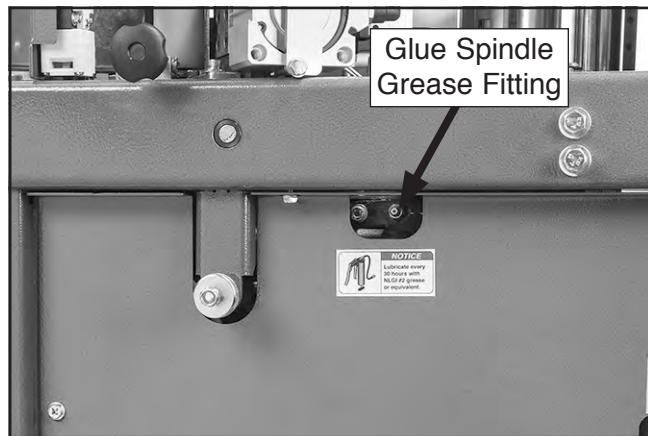


Figure 74. Location of glue spindle grease fitting.

To lubricate the glue spindle, use the included grease gun to squirt a small amount of grease into fitting, then wipe away any excess grease with a rag.

End-Trimmer Motor Sliders

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

The end trimmer motor sliders must be kept clean and lubricated to allow the smoothest possible movement of the end trimmer motor.

To lubricate the end trimmer motor sliders, open the rear access cover to access the sliders (see **Figure 75**). Wipe the sliders clean with a rag, then apply a light film of machine oil to the sliders. Manually move motor back and forth and up and down to evenly distribute the oil along the sliders.

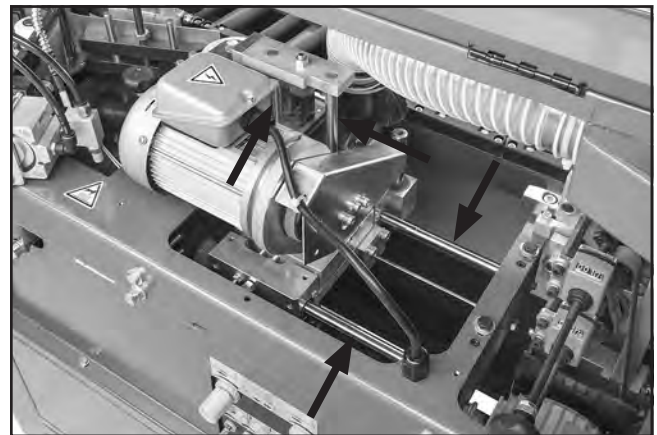


Figure 75. Location of end trimmer motor sliders.



Flush Trimmer Adjustment Shafts

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

The flush trimmer adjustment shafts (see **Figure 76**) require a small amount of lubrication to allow smooth adjustment and prevent the shafts from seizing up.

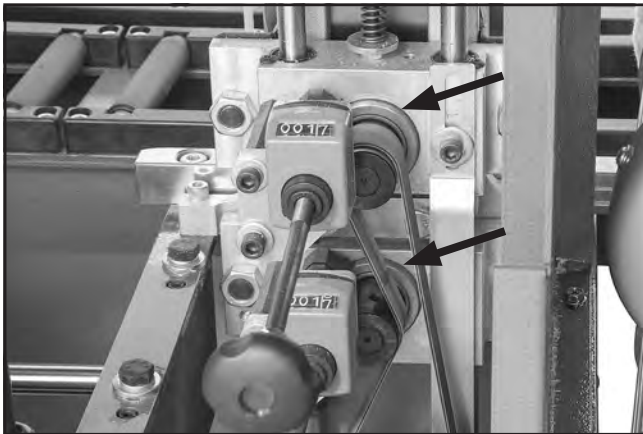


Figure 76. Lubrication points on the flush trimmer adjustment shafts.

To lubricate the flush trimmer adjustment shafts, use a cotton swab, small oil can, or other means to apply a light film of machine oil to the shafts, then adjust the upper and lower cutterheads in and out a few times to evenly distribute the oil.

Edgebanding Feed Gears

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

The edgebanding feed gears (see **Figure 77**) should be checked and, if necessary, lubricated periodically to ensure proper feeding of edgebanding during operations.



Figure 77. Location of edgebanding feed gears.

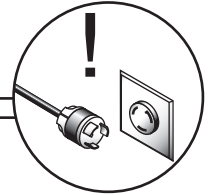
To lubricate the gears, remove the rear access panel, apply a small amount of grease to the teeth, wipe away any excess grease with a rag, then re-install the rear access panel.



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 turn on, one or more motors do not start, or a breaker trips.	<ol style="list-style-type: none"> Emergency Stop button depressed/at fault. Master power switch off/at fault. Panel feeder/rear access panel left open. Plug/receptacle at fault/wired wrong. Power supply circuit breaker tripped/fuse blown. Incorrect power supply voltage/circuit size. Inadequate air pressure. Glue pot has not reached working temperature. Blown fuse on machine. Thermal overload relay(s) tripped. Motor wires connected incorrectly. Wiring open/has high resistance. Start capacitor(s) at fault. Contactors not energized/has poor contacts. Centrifugal switch at fault. Circuit board at fault. Motor(s) at fault. 	<ol style="list-style-type: none"> Rotate button head to reset. Replace. Turn switch ON; test/replace switch. Close and secure panel feeder/rear access panel. Test for good contacts; correct wiring. Ensure circuit is sized correctly and free of shorts; reset circuit breaker/replace fuse. Ensure correct power supply voltage/circuit size. Ensure incoming air pressure is at least 6 SCFM @ 100 PSI; adjust air pressure regulator to 100 PSI. Allow glue pot to reach 180°C. Check/replace blown fuses. Reset; contact tech support if relay frequently trips. Correct motor wiring connections. Check/fix broken, disconnected, or corroded wires. Test/replace. Test all legs for power/replace. Test/replace. Inspect/replace. Test/repair/replace.
One or more motors stall or are underpowered.	<ol style="list-style-type: none"> Motor(s) overheated. Belt(s) slipping; oil/grease on belt(s). Motor(s) wired incorrectly. Plug/receptacle at fault. Conveyor belt slipping/at fault. Run capacitor at fault. Pulley/sprocket slipping on shaft. Centrifugal switch at fault. Motor bearings at fault. 	<ol style="list-style-type: none"> Allow motor(s) to cool; reset overload if necessary. Clean/tension/replace belt(s) (Pages 66–69). Wire motor(s) correctly. Test for good contacts/correct wiring. Tension belt (Page 61); replace if faulty. Test/repair/replace. Replace loose pulley/shaft. Adjust/replace centrifugal switch if available. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Motor & Electrical (Continued)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Belt(s) worn or loose. 3. Buffing wheel(s) at fault/incorrectly mounted. 4. Motor fan rubbing on fan cover. 5. Pulley loose. 6. Machine incorrectly mounted. 7. Motor bearings at fault. 8. Belt(s) slapping cover/components. 9. Flush trimmer knives at fault. 10. End-trimmer blades dull/incorrectly mounted. 11. Spindle/arbor bearings at fault. 12. Centrifugal switch is at fault. 13. Motor shaft bent. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and retighten with thread locking fluid. 2. Inspect belts; tension/replace belts (Pages 66–69). 3. Inspect/reinstall buffing wheel(s); replace. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Re-align/replace shaft, pulley set screw, and key. 6. Tighten mounting bolts; relocate/shim machine. 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 8. Replace/realign belt(s) (Pages 66–69). 9. Resharpener/replace knives; set knife alignment/height correctly (Page 57). 10. Inspect/resharpen/re-install/replace blades (Page 56). 11. Test by rotating spindle/arbor; rotational grinding/loose shaft requires bearing replacement. 12. Replace. 13. Test with dial indicator and replace motor.

Glue Spindle

Symptom	Possible Cause	Possible Solution
Glue spindle does not rotate.	<ol style="list-style-type: none"> 1. Motor does not run. 2. Too much grease added to glue spindle. 3. Gear connection shaft stripped/broken. 4. Gear connection shaft stuck. 	<ol style="list-style-type: none"> 1. Refer to Page 50. 2. Remove pressure-relief set screw. 3. Inspect/replace gear connection shaft. 4. Adjust motor reducer connection plate.
Glue spindle does not dispense enough glue.	<ol style="list-style-type: none"> 1. Glue flow out of adjustment. 2. Glue not fully melted, temperature setting too low. 3. Glue not fully melted, heater rods not working correctly. 4. Guide plate not adjusted properly. 5. Obstruction in glue shaft. 6. Burnt glue in glue spindle. 7. Glue pot thermometer not accurate. 	<ol style="list-style-type: none"> 1. Adjust glue flow (Page 39). 2. Adjust glue pot temperature according to glue manufacturer's directions; confirm glue temperature using laser thermometer. 3. Inspect heater rod connections; tighten if necessary. Test heater rod amperage (top: 315W, 1.0A; lower large: 250W, 0.9A; lower small: 160W, 0.6A); replace if necessary. 4. Adjust guide plate (Page 38). 5. Remove obstruction from glue shaft. 6. Remove burnt glue from glue spindle. 7. Inspect thermocouple connections and wires for damage/wear; repair/replace if necessary.
Glue not fully melted in glue pot.	<ol style="list-style-type: none"> 1. Glue pot still heating. 2. Glue pot temperature is set too low. 3. Heater rods at fault. 	<ol style="list-style-type: none"> 1. Wait until glue reaches working temperature. 2. Adjust glue pot temperature according to glue manufacturer's directions; confirm glue temperature using laser thermometer. 3. Inspect heater rod connections; tighten if necessary. Test heater rod amperage (top: 315W, 1.0A; lower large: 250W, 0.9A; lower small: 160W, 0.6A); replace if necessary.



Glue Spindle (Continued)

Symptom	Possible Cause	Possible Solution
Glue only adheres to lower portion of workpiece edge.	<ol style="list-style-type: none"> 1. Panel feeder not exerting enough downward force on workpiece. 2. Panel feeder lifts up when closed and latched. 3. Guide plate not adjusted properly. 4. Adjustable pressure roller not making full contact with workpiece. 5. Pressure roller tilted. 6. Glue spindle tilted. 7. Workpiece too wide, not properly supported. 	<ol style="list-style-type: none"> 1. Lower panel feeder to 0.5mm below actual workpiece thickness (Page 36). 2. Adjust panel feeder latch. 3. Adjust guide plate (Page 38). 4. Check/adjust pressure roller (Page 62). 5. Adjust pressure roller so it is 90° to table. 6. Adjust glue spindle so it is 90° to table. 7. Pull out table extension/use additional support, such as roller stands.

End Trimmer

Symptom	Possible Cause	Possible Solution
Blades do not rotate.	<ol style="list-style-type: none"> 1. Motor does not run. 2. Belt damaged/broken. 3. Obstruction preventing blades from rotating. 	<ol style="list-style-type: none"> 1. Refer to Page 50. 2. Inspect/replace belt (Pages 66–68). 3. Remove obstruction.
End cut not straight/not parallel.	<ol style="list-style-type: none"> 1. Tracer pads out of adjustment. 2. Copy plate bent. 3. Inadequate air pressure. 	<ol style="list-style-type: none"> 1. Properly adjust tracer pads (Page 64). 2. Repair/replace copy plate. 3. Check/remedy air pressure.
Chips inside of panel.	<ol style="list-style-type: none"> 1. Tracer pads out of adjustment. 2. Copy plate bent. 	<ol style="list-style-type: none"> 1. Properly adjust tracer pads (Page 64). 2. Repair/replace copy plate.
Saw blades lose RPM during operation.	<ol style="list-style-type: none"> 1. Belt is loose/damaged/broken. 2. Saw blades are dull/broken. 	<ol style="list-style-type: none"> 1. Inspect/replace belt (Pages 66–68). 2. Inspect/sharpen/replace saw blades (Page 56).
End trimmer unit fails to slide on shafts.	<ol style="list-style-type: none"> 1. Zip-tie used to secure unit during shipping still attached. 2. Build-up on shafts prevent unit from sliding properly. 3. Inadequate air supply. 	<ol style="list-style-type: none"> 1. Remove zip-tie. 2. Clean shafts. 3. Check air lines for leaks/check air valves for blockages; repair.

Flush Trimmer

Symptom	Possible Cause	Possible Solution
Cutterheads do not rotate.	<ol style="list-style-type: none"> 1. Motor does not run. 2. Belt is loose/damaged/broken. 	<ol style="list-style-type: none"> 1. Refer to Page 50. 2. Inspect/replace belt (Page 68).
Flush trimmer does not trim proper amount of edgebanding.	<ol style="list-style-type: none"> 1. Cutterheads not properly adjusted. 	<ol style="list-style-type: none"> 1. Properly adjust cutterheads (Page 40).
Cutterheads lose RPM during operation.	<ol style="list-style-type: none"> 1. Belt is loose/damaged/broken. 2. Cutterhead knives are dull/broken. 	<ol style="list-style-type: none"> 1. Inspect/replace belt (Page 68). 2. Inspect/replace knives (Page 57).
Cutterheads will not adjust in or out.	<ol style="list-style-type: none"> 1. Debris stuck between cylinder and housing. 2. Burrs preventing movement. 	<ol style="list-style-type: none"> 1. Lubricate flush trimmer shafts to free up movement. 2. Remove cylinder, inspect/clean and lightly sand both surfaces, then re-install cylinder.



Panel Feeder

Symptom	Possible Cause	Possible Solution
Conveyor belt does not move.	<ol style="list-style-type: none"> 1. Motor does not run. 2. Conveyor belt not properly tensioned. 	<ol style="list-style-type: none"> 1. Refer to Page 50. 2. Properly tension conveyor belt (Page 61).
Workpiece feeds erratically or stops feeding during operation.	<ol style="list-style-type: none"> 1. Conveyor belt not properly tensioned. 2. Panel feeder height not properly adjusted. 	<ol style="list-style-type: none"> 1. Properly tension conveyor belt (Page 61). 2. Properly adjust panel feeder height (Page 36).

Buffing Unit

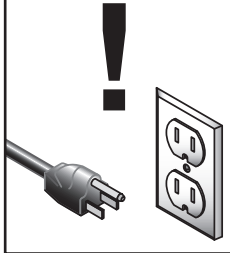
Symptom	Possible Cause	Possible Solution
Buffing wheel(s) do not rotate.	<ol style="list-style-type: none"> 1. Motor(s) do not run. 2. Buffing wheel(s) not properly secured. 	<ol style="list-style-type: none"> 1. Refer to Page 50. 2. Tighten bolt(s) that secure wheel(s) (Page 58).
Buffing wheel(s) spread glue on workpiece.	<ol style="list-style-type: none"> 1. Too much glue applied. 2. Wrong glue for application. 	<ol style="list-style-type: none"> 1. Adjust glue flow (Page 39). 2. Use appropriate glue for application, refer to glue manufacturer's instructions.
Buffing wheel(s) wear away corners of workpiece/ edgebanding.	<ol style="list-style-type: none"> 1. Buffing wheel(s) not properly adjusted. 	<ol style="list-style-type: none"> 1. Properly adjust buffing wheel(s) (Page 58).

Edgebanding Results

Symptom	Possible Cause	Possible Solution
Edgebanding moves up or down relative to workpiece.	<ol style="list-style-type: none"> 1. Pressure roller angle out of adjustment. 	<ol style="list-style-type: none"> 1. Adjust pressure roller so it is 90° to table.
Edgebanding cut too short (early) or too long (late).	<ol style="list-style-type: none"> 1. Inadequate workpiece support. 2. Guillotine limit switch out of adjustment. 3. Copy plate bent. 	<ol style="list-style-type: none"> 1. Pull out table extension. 2. Properly adjust guillotine limit switch (Page 60). 3. Repair/replace copy plate.
Too much/ not enough edgebanding left on top or bottom.	<ol style="list-style-type: none"> 1. Flush trimmer cutterheads not properly adjusted. 	<ol style="list-style-type: none"> 1. Properly adjust flush trimmer cutterheads (Page 40).
Scrape marks on face of edgebanding.	<ol style="list-style-type: none"> 1. Debris/sharp edges/burrs/extra glue obstructing path of edgebanding. 	<ol style="list-style-type: none"> 1. Inspect entire path of edgebanding; clean away debris; sand/file sharp edges/burrs.
Gaps in edgebanding on finished workpiece.	<ol style="list-style-type: none"> 1. Guillotine limit switch set too low. 2. Panel feeder not exerting enough downward force on workpiece. 	<ol style="list-style-type: none"> 1. Raise position of guillotine limit switch. 2. Lower panel feeder to 0.5mm below actual workpiece thickness (Page 36).
Ends not cleanly cut.	<ol style="list-style-type: none"> 1. End trimmer saw blades dull. 	<ol style="list-style-type: none"> 1. Sharpen/replace end trimmer saw blades (Page 56).



Checking/Calibrating Infeed Fence Stop

	<p>WARNING To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.</p>
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For best results, the infeed fence stop should be periodically checked for accuracy and, if necessary, calibrated.

Item(s) Needed	Qty
Open-End Wrench 10mm.....	2

To check/calibrate infeed fence stop:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Loosen infeed fence lock lever, rotate knurled cylinder clockwise until stop plate contacts stop bolt, then retighten lock lever (see **Figure 78**).
3. Check fence scale (see **Figure 78**).
 - If fence scale reads "0," infeed fence stop is calibrated and no adjustment is necessary.
 - If fence scale does *not* read "0," infeed fence stop is not calibrated. Proceed to **Step 4**.

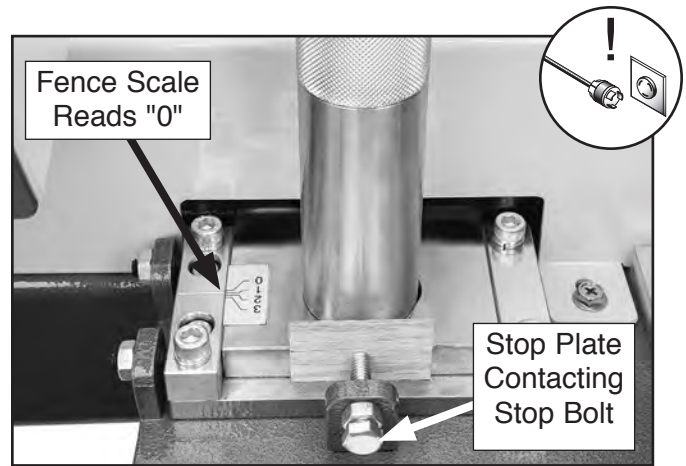


Figure 78. Checking infeed fence stop calibration.

4. Loosen jam nut (see **Figure 79**).
5. Loosen stop bolt a few turns (see **Figure 79**).
6. Loosen infeed fence lock lever, rotate knurled cylinder until fence scale reads "0."
 - Rotate cylinder *clockwise* to move fence *toward* stop bolt.
 - Rotate cylinder *counterclockwise* to move fence *away* from stop bolt.

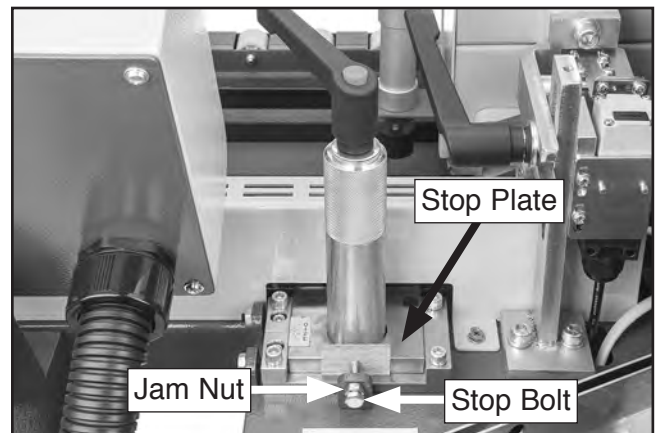


Figure 79. Calibrating infeed fence stop.

7. If necessary, repeat **Steps 5–6** until you can adjust fence to "0."
8. Retighten lock lever.
9. Tighten stop bolt until it contacts stop plate, then tighten jam nut to secure stop bolt. Infeed fence stop is now calibrated (see **Figure 79**).



Removing/Changing Glue

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

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

Item(s) Needed	Qty
Wood Stick Approximately 6" x 1" x 1/2"	1
Pliers.....	1
Glue Pellets	As Needed

To remove/change glue:

1. Turn machine **OFF** and wait for glue pot to *completely cool*.
2. Turn machine **ON** and wait for glue pot to reach 80°–90° C.
3. Use wood stick (approximately 6" x 1" x 1/2") to peel up one side of glue, as shown in **Figure 80**.

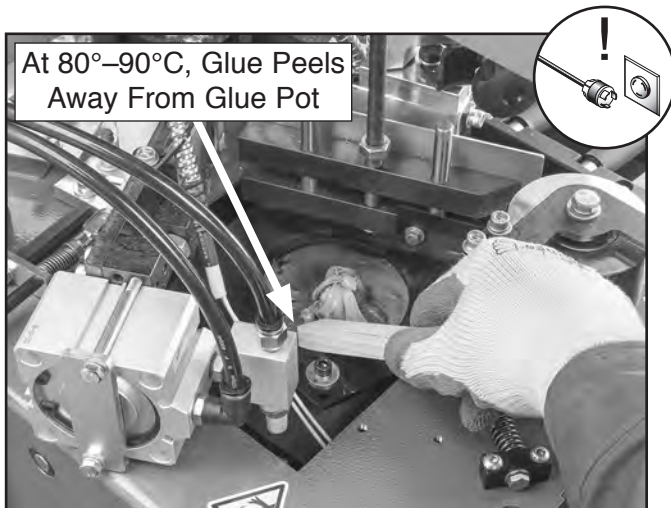


Figure 80. Using wood stick to peel glue away from glue pot for glue removal.

4. Use pliers to grip peeled up portion of glue and pull block of glue out of glue pot (see **Figure 81**).

Important: *Be careful not to scratch glue pot surface.*

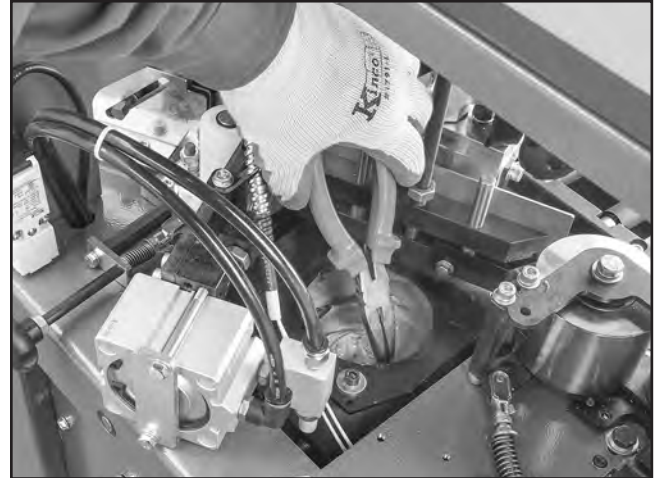
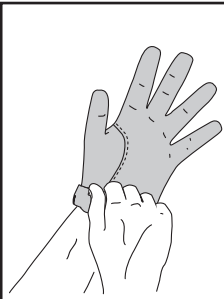


Figure 81. Using pliers to remove block of glue from glue pot.

5. Turn machine **OFF**, and allow glue pot to completely cool.
6. Clean any remaining glue and debris from bottom and sides of glue pot.
7. Carefully add glue pellets until they reach 3/4" (2cm) below top of glue pot.
8. Turn machine **ON** and allow glue pot to reach working temperature.
9. When glue pellets are completely melted, check glue level and, if necessary, add proper amount of glue (refer to **Page 35** for more information).



Replacing End Trimmer Blades



⚠ CAUTION

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

If the end-trimmer fails to make clean, precise cuts, the blades (**Grizzly Part #P07741318**) may be dull or damaged, requiring replacement.

Item(s) Needed	Qty
Leather Gloves	1 Pair
Hex Wrenches 4, 6mm.....	1 Ea.
Wrench or Socket 10mm.....	1
Wood Block Approximately 1" x 3".....	1

To replace end trimmer saw blades:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Manually raise end trimmer unit and support it with wood block for best access to blades (see **Figure 82**).

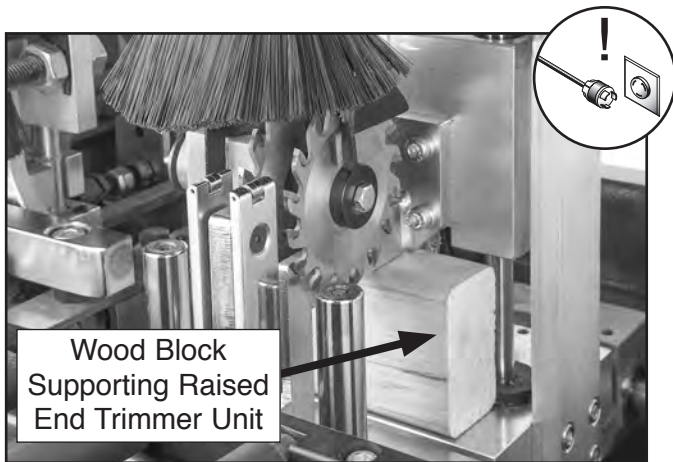


Figure 82. End trimmer unit raised and supported with wood block for access to blades.

3. Use 4mm hex wrench to remove end trimmer dust shroud assembly (see **Figure 83**).

4. Use 6mm hex wrench to secure end trimmer spindle, and use 10mm wrench to remove hex bolt that secures end trimmer blades (see **Figure 83**). Alternatively, secure end trimmer by inserting a hex wrench through hole in spindle (see **Figure 84**).

Note: Hex bolt has left-hand threads. Rotate bolt clockwise to loosen; rotate bolt counter-clockwise to tighten.

5. Remove blade flange, outer blade, spacer, and inner blade (see **Figures 83–84**).

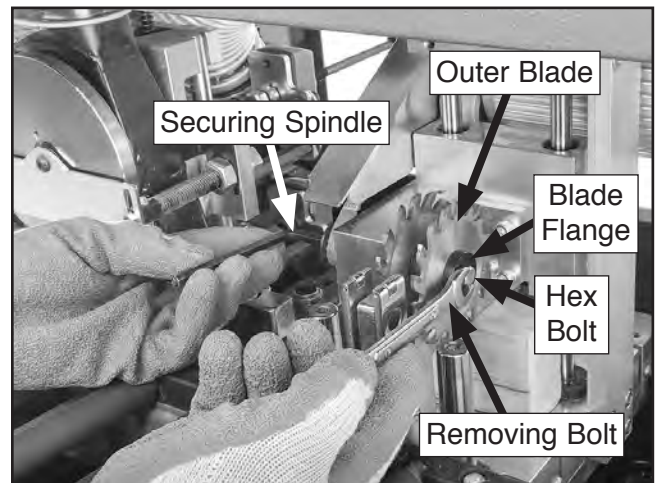


Figure 83. Removing end trimmer blades with dust shroud removed.

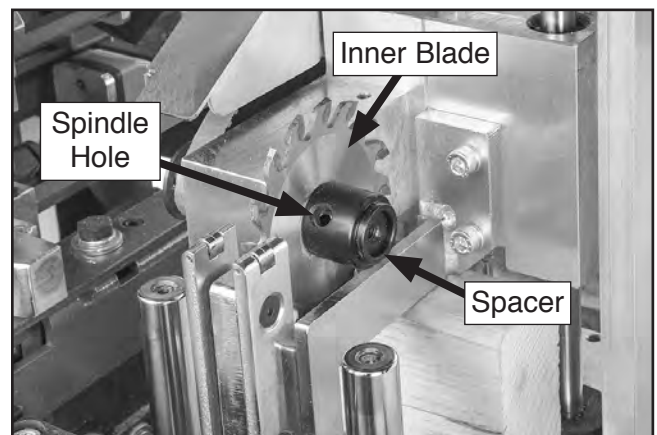


Figure 84. Location of inner end trimmer blade and spacer.

6. Install new blades with spacer, flange, and hex bolt removed in **Steps 4–5** in reverse order from removal.

Important: Make sure to orient components (see **Figure 84**) in same direction as they were before removal.



Replacing Flush Trimmer Cutterhead Knives

If the flush trimmer fails to produce straight, clean upper and lower edges that are flush with the top and bottom surfaces of the workpiece, the flush trimmer cutterhead knives (**Grizzly Part #P07742144-3** (upper) and **#P07742235-3** (lower)) may be dull or damaged requiring replacement.

The disposable upper and lower flush trimmer knives are held in place by blocks and set screws (see **Figures 85–86**).

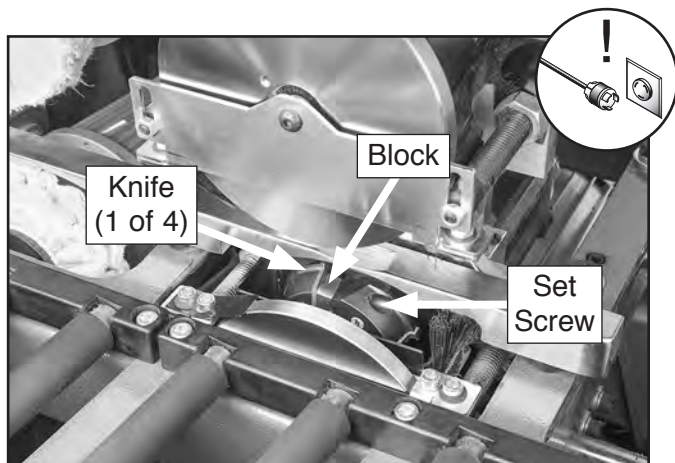


Figure 85. Lower flush trimmer knife components.

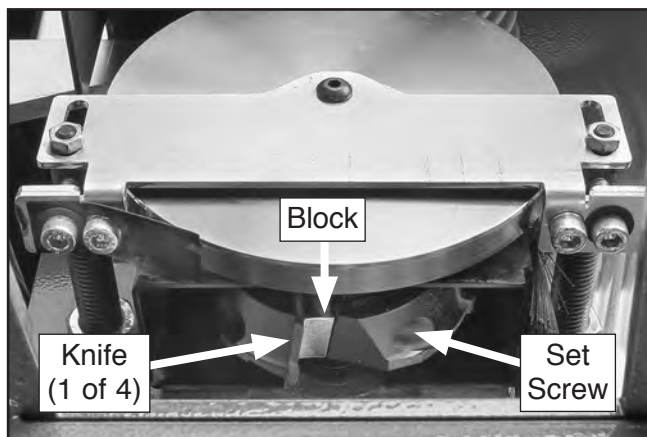


Figure 86. Upper flush trimmer knife components.

Item(s) Needed	Qty
Hex Wrench 4mm.....	1

To replace flush trimmer cutterhead knives:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Unlock and open panel feeder, then raise it all the way up.
3. Rotate upper or lower cutterhead until knife, lock, and set screw are accessible, as shown in **Figures 85–86**.
4. Loosen set screw (see **Figure 87**), remove knife, being careful not to drop or misplace block, install new knife, then retighten set screw.



Figure 87. Loosening gib screw to change flush-trimmer knife.

5. Repeat **Steps 3–4** with remaining knives on cutterhead.
6. If necessary, repeat **Steps 3–5** with knives of other cutterhead.
7. Close and lock panel feeder.



Adjusting/Replacing Buffing Wheels

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

Adjusting Buffing Wheels

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

Item(s) Needed	Qty
Wrench or Socket 13mm.....	1
Sample Workpiece 27".....	1

To adjust buffing wheels:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Adjust panel feeder height (see **Page 36**) according to sample workpiece being used, then open panel feeder and place sample workpiece between upper and lower buffing wheels, as shown in **Figure 88**.

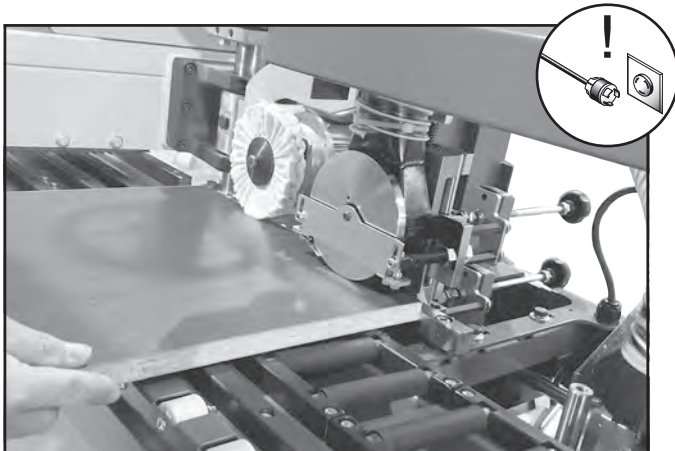


Figure 88. Placing workpiece between buffing wheels.

3. Open rear access cover, then loosen (2) upper buffing motor mounting bolts shown in **Figure 89**.

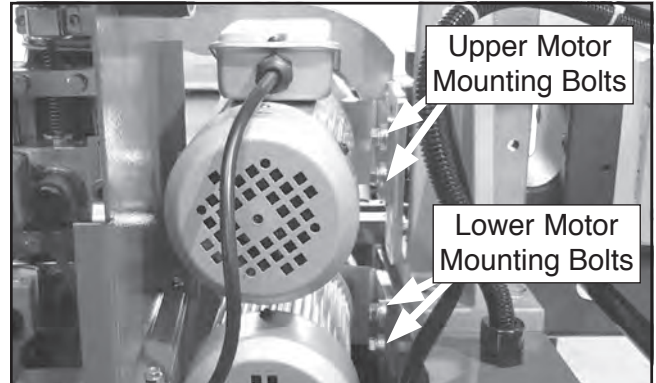


Figure 89. Buffing wheel adjustment bolt locations.

4. Lower motor so buffing wheel just barely touches the workpiece, then tighten motor mounting bolts.
5. Use **Steps 3–4** as a guide to raise or lower motor so lower buffing wheel is barely in contact with bottom surface of workpiece, then tighten lower motor mounting bolts.

IMPORTANT: *DO NOT* adjust buffing wheels any closer to the workpiece than described in **Steps 4 and 5**. The buffing wheels increase in diameter when motors are running and will create too much load on motors, which may cause premature failure of the buffing motors and/or other components.



Replacing Buffing Wheels

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

Item(s) Needed	Qty
Wrench or Socket 13mm.....	1
Hex Wrench 5mm.....	1
Buffing Wheels (Part #P07741903)	1-2

To replace buffing wheels:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Remove hex bolt securing upper buffing wheel (see **Figure 90**). Bolt has left-hand threads (*clockwise to loosen; counterclockwise to tighten*).

Note: If arbor spins, secure it by inserting a 5mm hex wrench into arbor cap screw.

3. Remove lock washer, flange, and buffing wheel (see **Figure 90**).

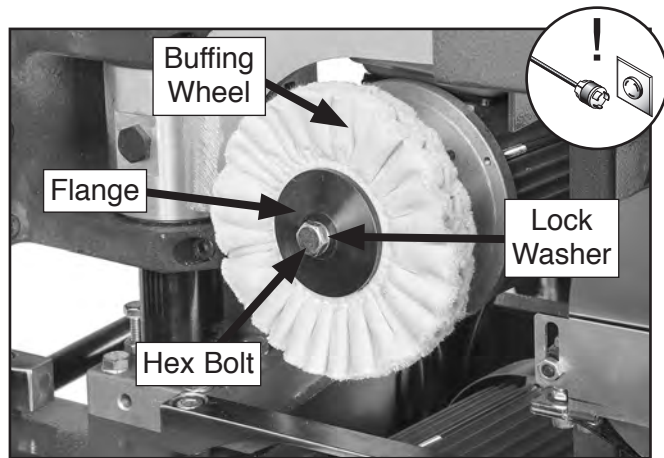


Figure 90. Buffing wheel removal components.

4. Install new buffing wheel and re-install flange, lock washer, and hex bolt, in reverse order from removal.

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

5. Repeat **Steps 2-4** with lower buffing wheel. Lower hex bolt has regular threads.
6. Follow steps in **Adjusting Buffing Wheels** section on **Page 58**.



Adjusting Limit Switches

Two adjustable limit switches trigger the guillotine and the end trimmer. The switches are factory set, and should not require routine adjustment. However, after prolonged use, or if your edgebanding results are unsatisfactory, the switches may need to be adjusted.

Item(s) Needed	Qty
Hex Wrench 3mm.....	1

Adjusting Guillotine Limit Switch

When the workpiece passes over the guillotine limit switch (see **Figure 91**), the guillotine severs the edgebanding, leaving a portion of excess that is then trimmed flush by the flush trimmer. If the guillotine leaves too much or too little excess edgebanding, you will need to adjust the switch.

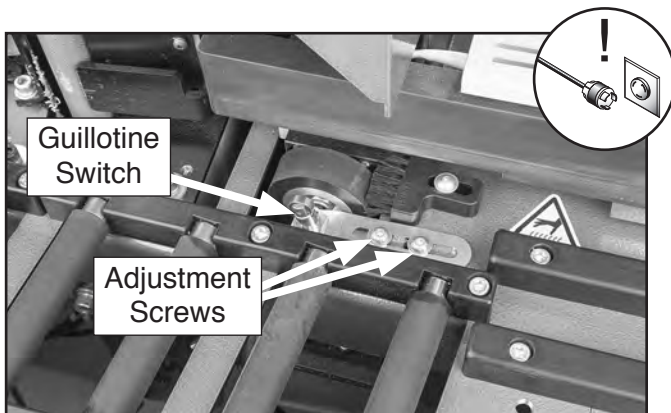


Figure 91. Location of guillotine limit switch and adjustment screws.

To adjust guillotine limit switch:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Loosen adjustment screws (see **Figure 91**).
 - If guillotine *does not leave enough* excess edgebanding, move switch toward *infeed* table, then retighten adjustment screws.
 - If guillotine leaves *too much* excess edgebanding, move switch toward *outfeed* table, then retighten adjustment screws.

Adjusting End Trimmer Switch

When the workpiece passes over the end trimmer switch (see **Figure 92**), the end trimmer trims the leading and trailing ends of the glued edgebanding flush with the ends of the workpiece. If the end trimmer fails to trim the edgebanding flush with the ends of the workpiece, you will need to adjust the switch.

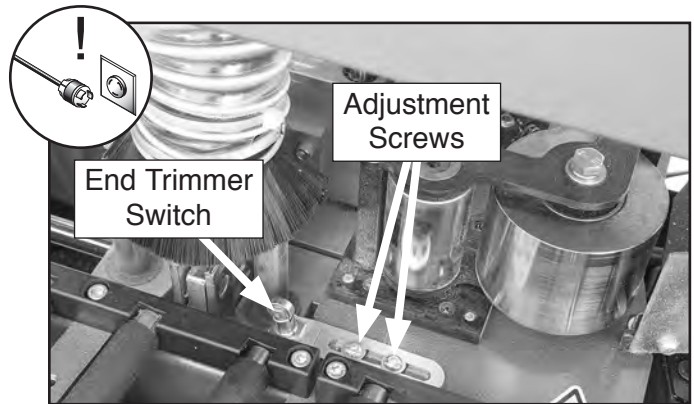


Figure 92. Location of end trimmer switch and adjustment screws.

To adjust end trimmer switch:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Loosen adjustment screws (see **Figure 92**).
 - If end trimmer leaves *too much* edgebanding on the *leading* end of workpiece edge and *not enough* on the *trailing* end, move switch toward *infeed* table, then retighten adjustment screws.
 - If end trimmer leaves *too much* edgebanding on the *trailing* end of workpiece edge and *not enough* on the *leading* end, move switch toward *outfeed* table, then retighten adjustment screws.



Checking/Adjusting Conveyor Belt Tension

The conveyor belt must be properly tensioned for the panel feeder to properly feed workpieces during operations. The conveyor belt tension is factory set and should not require routine adjustment. However, after prolonged use, or if the panel feeder fails to adequately feed workpieces, you will need to adjust the conveyor belt tension.

Item(s) Needed	Qty
Hex Wrench 6mm.....	1

To check/adjust conveyor belt tension:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Unlock and open panel feeder.
3. Place 8kg (17½ lbs.) of downward force on conveyor belt, as illustrated in label on panel feeder (see **Figure 93**).
 - If there *is* 3cm (1½") of deflection, conveyor belt is properly tensioned and no adjustment is necessary.
 - If there is *not* 3cm (1½") of deflection, conveyor belt is not properly tensioned and requires adjustment. Proceed to **Step 4**.

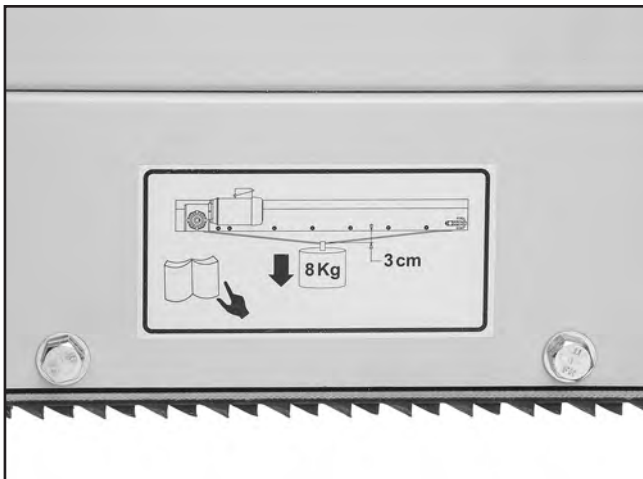


Figure 93. Conveyor belt tension label, located on inside of panel feeder.

4. Rotate conveyor belt tension screws, shown in **Figure 94**, to adjust belt tension.
 - Rotate screws *clockwise* to *tighten* conveyor belt.
 - Rotate screws *counterclockwise* to *loosen* conveyor belt.

Note: Both tension screws must be adjusted equally to maintain proper belt tracking.



Figure 94. Location of conveyor belt tension screw.

5. Repeat **Steps 3–4**, as necessary, until conveyor belt is properly tensioned.
6. Close and lock panel feeder.



Checking/Adjusting Pressure Roller Unit

The pressure roller unit consists of two rollers — one fixed and one adjustable—that apply pressure to the edgebanding against the workpiece immediately after the glue is applied (see **Figure 95**).

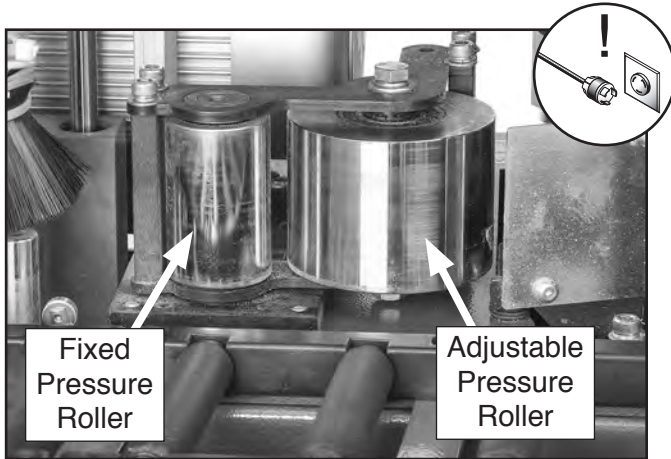


Figure 95. Location of fixed and adjustable pressure rollers

The fixed, non-adjustable roller applies constant pressure to the edgebanding, while the adjustable roller is spring-loaded, allowing for pressure adjustment.

The adjustable pressure roller is set at the factory and should not require routine service. However, if the pressure roller unit causes too much glue to squeeze out during operations, or if you are getting poor bonding results, you may need to adjust the pressure roller.

Properly adjusting the pressure roller unit is largely a matter of trial and error. Your results may vary depending on the glue type, glue temperature, workpiece thickness, and edgebanding thickness. Always use a test piece to verify your settings after adjusting the pressure roller unit.

Item(s) Needed	Qty
Open-End Wrench 10mm.....	1
Scrap Workpiece at Least 35" Long.....	1

To check/adjust pressure roller unit:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Set infeed fence to "0" (refer to **Page 37**).
3. Rotate glue spindle adjustment knob clockwise several turns to move glue spindle out of the way (see **Figure 96**).

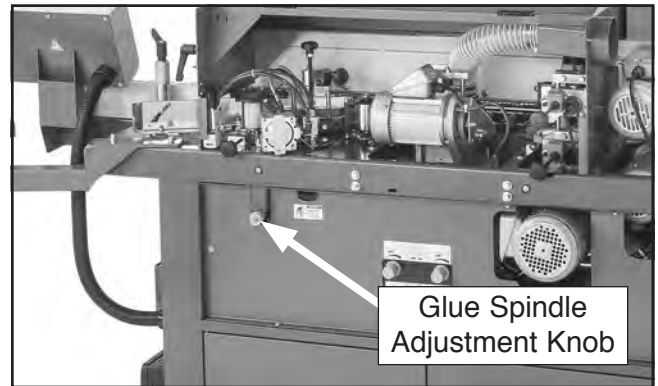


Figure 96. Location of glue spindle adjustment knob.

4. Open panel feeder.
5. Place straight edge of workpiece against fence and adjustable pressure roller. Adjustable pressure roller should keep workpiece approximately 0.040" (1mm) away from fixed pressure roller.



6. Push workpiece against adjustable pressure roller, toward back of machine, until workpiece contacts both pressure rollers and entire fence along its length (see **Figure 97**). Because adjustable pressure roller is spring-loaded, this should require moderate force.

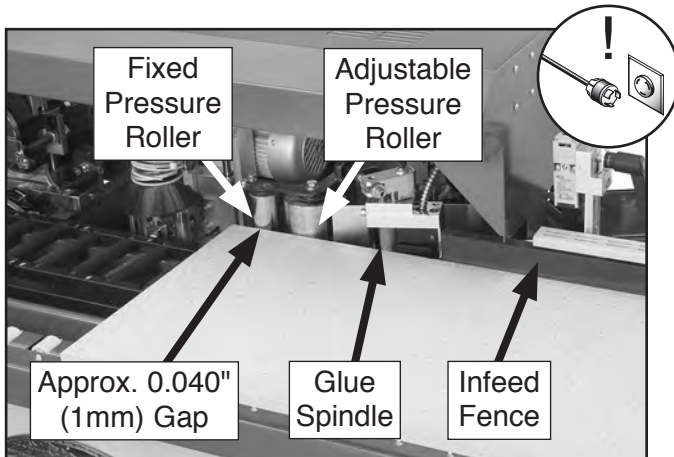


Figure 97. Workpiece placed against infeed fence and pressure roller unit.

- If **Step 6** requires moderate force, pressure roller unit is properly adjusted and no further steps are necessary.
- If **Step 6** requires excessive force, or if workpiece does not contact adjustable pressure roller at all, pressure roller unit is not properly adjusted. Proceed to **Step 7**.

7. Open rear access cover.
8. Loosen jam nut shown in **Figure 98**.
9. Rotate pressure roller adjustment bolt shown in **Figure 98**.

- Rotate bolt *clockwise* to move pressure roller *away* from workpiece and *reduce* pressure.
- Rotate bolt *counterclockwise* to move pressure roller *toward* workpiece and *increase* pressure.

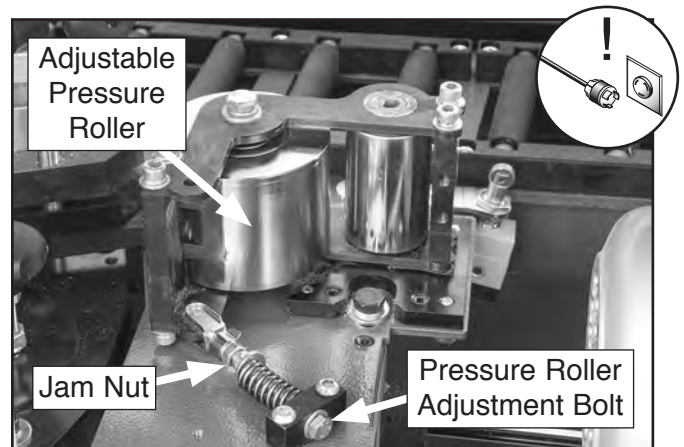


Figure 98. Pressure roller adjustment components (viewed from rear of machine).

10. Repeat **Steps 6 & 9** until satisfied with adjustment, then retighten jam nut from **Step 8** to secure setting, and close rear access cover.
11. Rotate glue spindle adjustment knob counterclockwise all the way to move glue spindle forward to working position.
12. Close and lock panel feeder, then run a test piece of the same material and thickness as your intended workpiece through edgebander to verify satisfactory results. If necessary, repeat **Steps 1–12**.



Checking/Adjusting End Trimmer Tracers

Two end trimmer tracers (left and right) orient the end trimmer blades to the workpiece in order to precisely trim the edgework flush with the leading and trailing ends of the workpiece (see **Figure 99**).

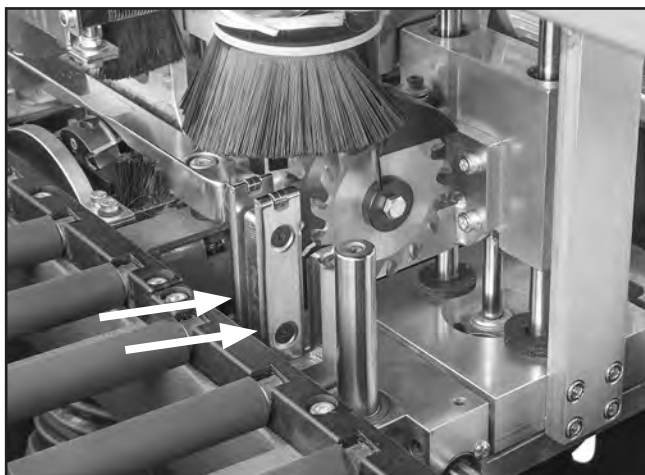


Figure 99. Location of end trimmer tracers.

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

Item(s) Needed	Qty
Hex Wrench 3mm.....	1
Scrap Workpiece at Least 35" Long.....	1

To check/adjust end trimmer tracers:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Open panel feeder.
3. Place straight edge of workpiece on infeed table, making sure workpiece contacts entire infeed fence along its length, as shown in **Figure 100**.



Figure 100. Workpiece placed on infeed table.

4. Manually raise and move end trimmer so right end trimmer tracer contacts leading edge of workpiece, as shown in **Figures 101–102**, then raise and lower end trimmer to verify right end trimmer blade is aligned with right tracer (see **Figure 102**).



Figure 101. Checking alignment of right end trimmer blade.



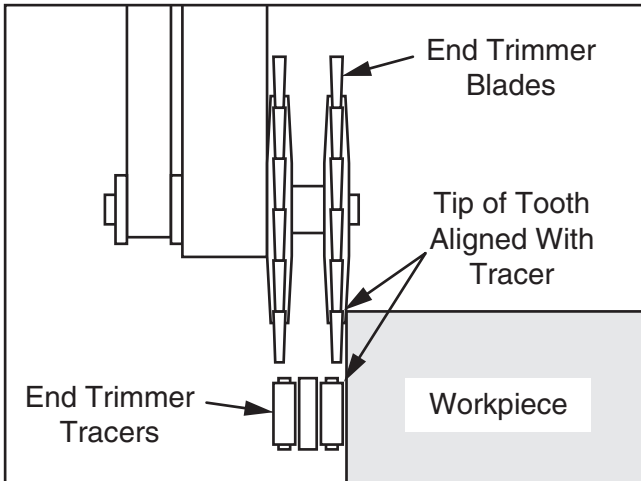


Figure 102. End trimmer alignment.

- If blade *is* aligned to tracer, then no adjustment is necessary.
- If blade is *not* aligned with tracer, then tracer must be adjusted. Proceed to **Step 5**.

5. Rotate both screws shown in **Figure 103** in or out, in equal amounts to bring tracer into alignment with blade.

- For *right* end trimmer tracer, *tighten* screws to move tracer left; *loosen* screws to move tracer right.
- For *left* end trimmer tracer, *loosen* screws to move tracer left; *tighten* screws to move tracer right.



Figure 103. Location of right end trimmer tracer adjustment screws.

6. Place workpiece on table to left of end trimmer unit, then repeat **Steps 4–5** for left end trimmer tracer.

Note: *Belleville disc washers provide spring tension between tracers and copy plate bracket. **DO NOT** back screw all the way out or it may shoot out and get lost.*

7. Run a test piece through edgebander to verify adjustment. Repeat **Steps 1–7** until satisfied with results.



Checking/Adjusting End Trimmer Drive Belt Tension

The end trimmer motor transfers power through a cogged drive belt (**Grizzly Part #P07741329**). The belt should be periodically checked for proper tension and, if necessary, replaced.

Item(s) Needed	Qty
Hex Wrench 4mm (Long Handle).....	1
Hex Wrench 5mm.....	1

To check/adjust end trimmer drive belt tension:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Open rear access cover.
3. Remove (2) M5-.8 x 12 cap screws with flat washers from end-trimmer belt cover, then remove cover (see **Figure 104**).

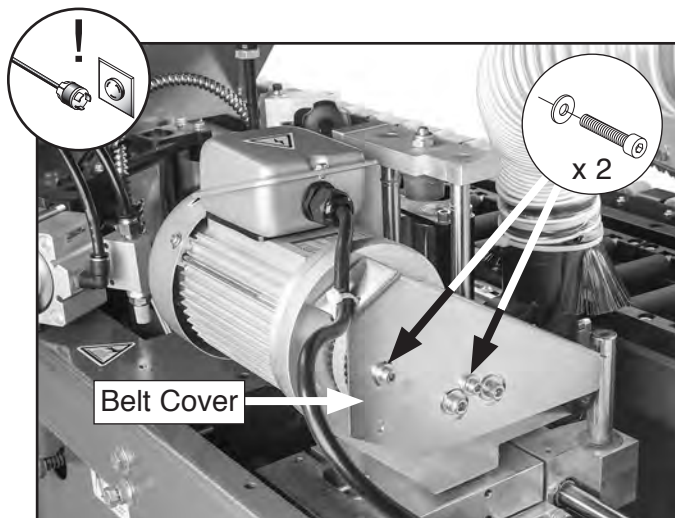


Figure 104. Location of cap screws that secure end trimmer belt cover.

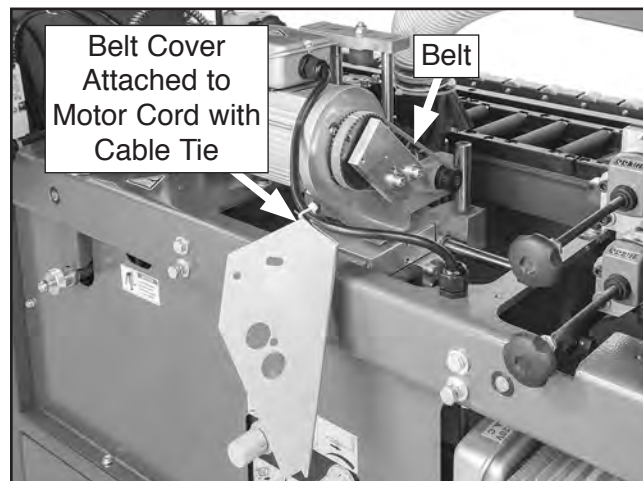


Figure 105. End trimmer belt cover removed.

4. Apply moderate pressure to belt to see how much it deflects (see **Figure 106**).
 - If belt deflects approximately $\frac{1}{4}$ ", it is properly tensioned and no adjustment is necessary.
 - If belt does *not* deflect approximately $\frac{1}{4}$ ", it is *not* properly tensioned and requires adjustment proceed to **Step 6**.

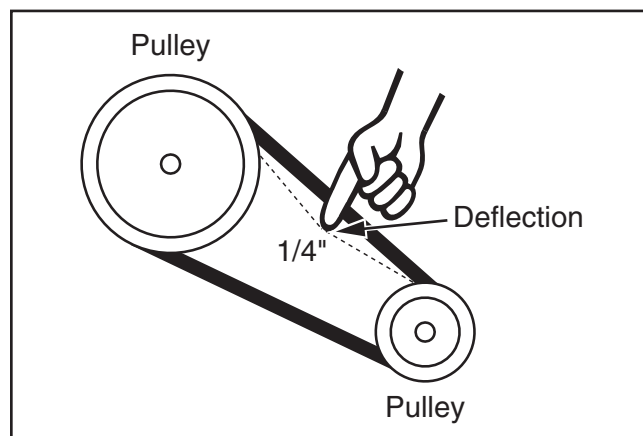


Figure 106. End trimmer belt deflection.



- Loosen—but do not remove—cap screws that secure end trimmer belt tension plate (see **Figure 107**).

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

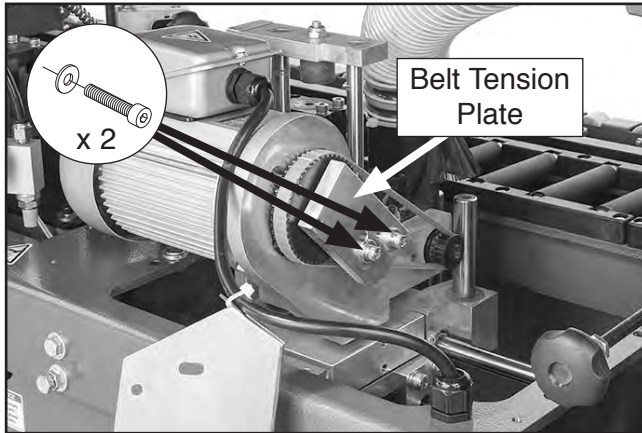


Figure 107. Location of cap screws that secure end trimmer belt tension plate.

- Rotate end trimmer motor pulley by hand until adjustment hole aligns with one of four motor mount cap screws (see **Figure 108**).
- Insert long-handled hex wrench into adjustment hole, as shown in **Figure 108**, and loosen—but do not remove—motor mount cap screw.

IMPORTANT: Do not remove this screw. If you do it will be very difficult to re-install.

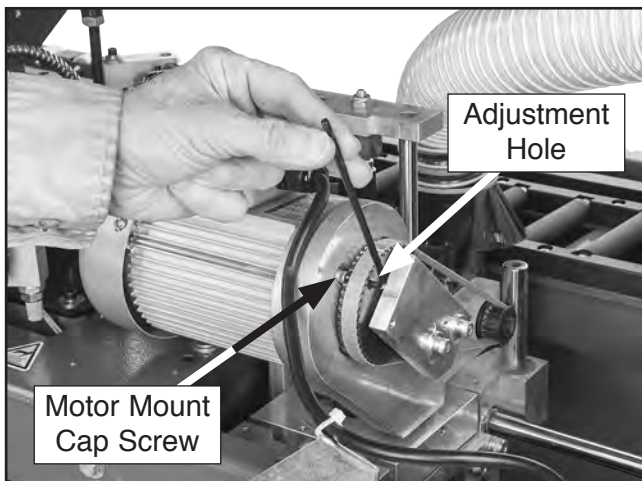


Figure 108. Loosening one of four end trimmer motor mount cap screws.

- Repeat **Steps 5–6** with remaining motor mount cap screws (see **Figure 109**).

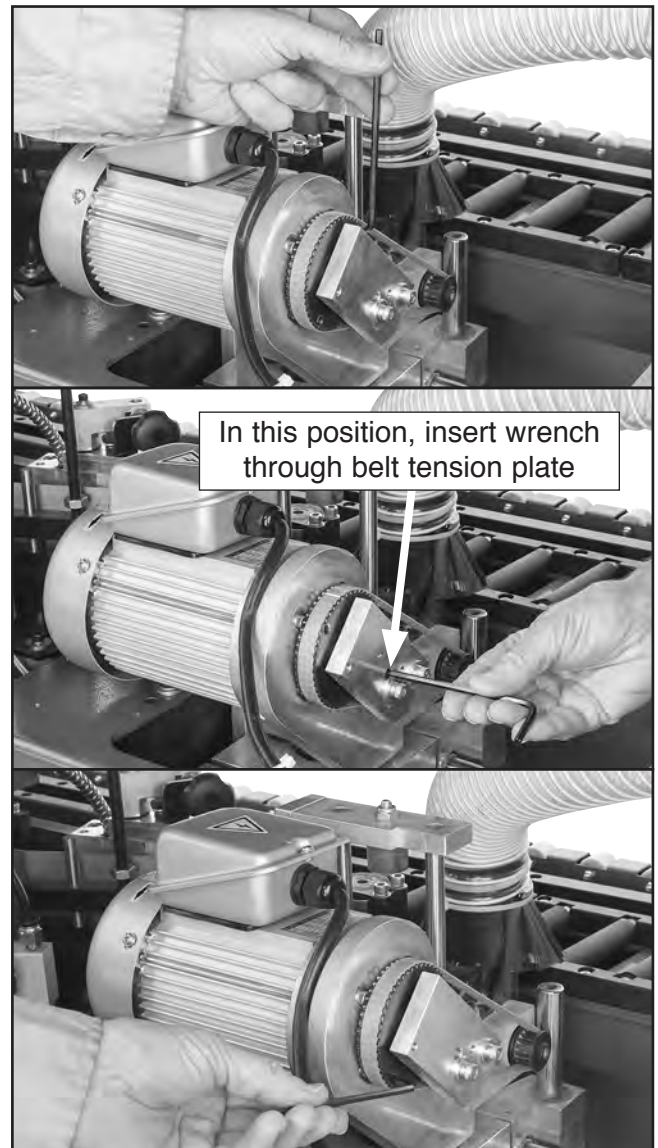


Figure 109. Loosening remaining end trimmer motor mount cap screws.

- Shift motor up or down with one hand while checking belt deflection with other hand. When belt deflection is approximately $\frac{1}{4}$ ", tighten one of four motor mount cap screws from **Steps 6–7**.
- Check belt deflection again and, if necessary, re-adjust it, then tighten remaining motor mount cap screws from **Steps 6–7**.
- Retighten cap screws from **Step 5**, then re-install belt cover, and close rear access cover.



Replacing End Trimmer Drive Belt

If the end trimmer drive belt becomes worn, cracked, frayed, broken, or otherwise damaged, you will need to replace it with a new one (**Grizzly Part #P07741329**).

Item(s) Needed	Qty
Hex Wrench 4mm (Long Handle).....	1
Hex Wrench 5mm.....	1

To replace end trimmer drive belt:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Remove end trimmer belt cover and adjust motor to loosen belt (refer to **Steps 3–7** of **Checking/Adjusting End Trimmer Belt Tension**, beginning on **Page 66**).
3. Remove old belt and install new belt.
4. Properly tension belt and re-install belt cover (refer to **Steps 9–11** of **Checking/Adjusting End Trimmer Belt Tension**, on **Page 67**).

Replacing Flush Trimmer Drive Belt

The flush trimming motor transfers power through a serpentine drive belt (see **Figure 110**). The belt is tensioned automatically by the weight of the motor and does not require adjustment. However, if it becomes worn, cracked, frayed, broken, or otherwise damaged in any way, you will need to replace it with a new one (**Grizzly Part #P07740627**).

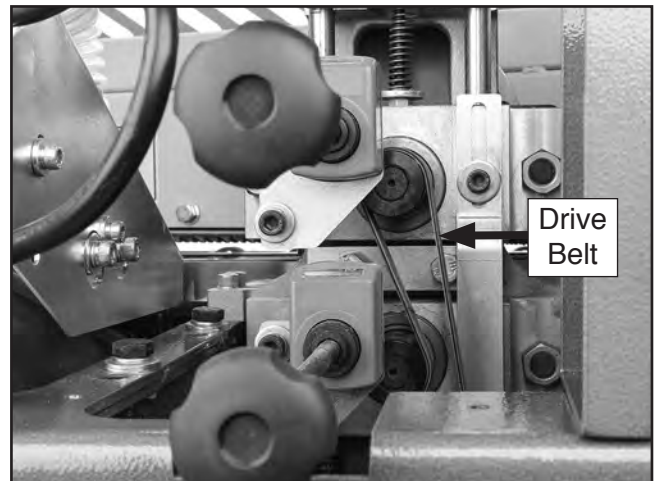


Figure 110. Location of flush trimmer drive belt.

Item(s) Needed	Qty
Hex Wrench 5mm.....	1
Wood Block 4" x 4" x 6"	1

To replace flush trimmer drive belt:

1. DISCONNECT MACHINE FROM POWER AND AIR!
2. Lower panel feeder all the way (see **Page 36**).



3. Open rear access cover.
4. Loosen cap screw shown in **Figure 111**.

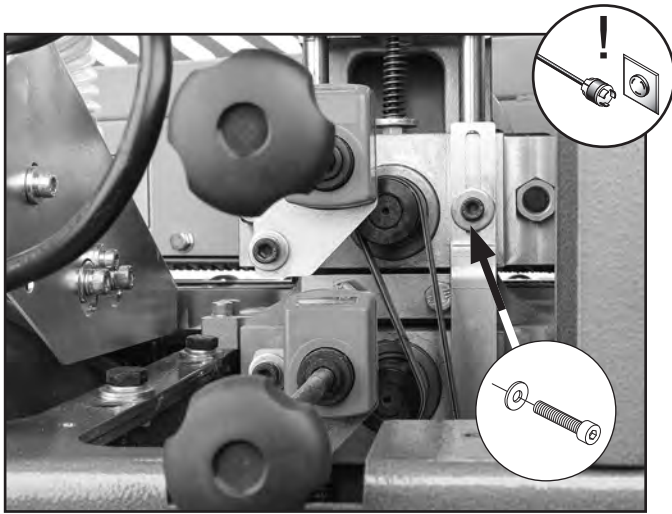


Figure 111. Location of cap screw to loosen when changing flush trimmer drive belt.

5. Raise motor by hand, then support it with a 4" x 4" x 6" wood block to release belt tension (see **Figure 112**).

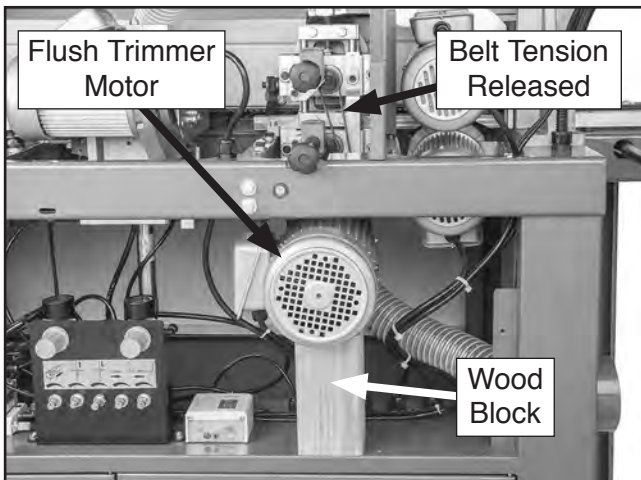


Figure 112. Flush trimmer motor raised and supported on wood block to release belt tension.

6. Remove old belt and install a new one, making sure to properly route it around pulleys, as shown in **Figure 113**.

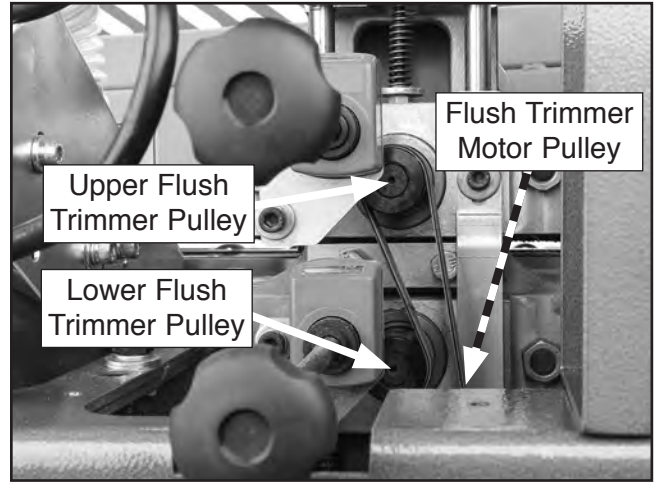


Figure 113. Flush trimmer drive belt properly routed around pulleys.

7. Raise motor by hand, then remove wood block from **Step 5**.
8. Press down on motor slightly, making sure motor contact bar shown in **Figure 114** drops down and contacts motor, then tighten cap screw from **Step 4**.

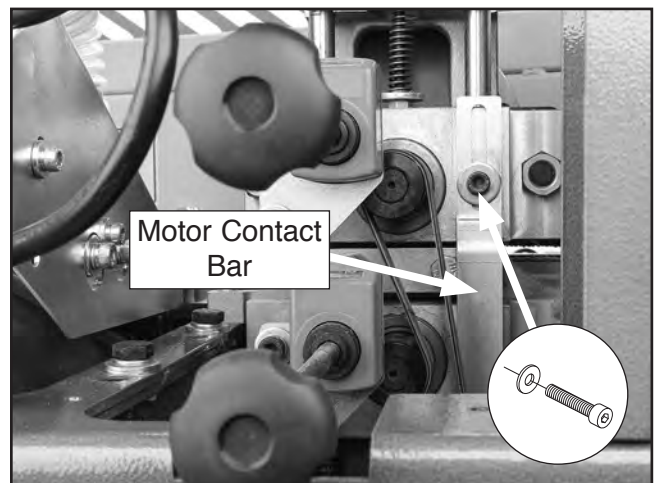


Figure 114. Location of motor contact bar.

9. Close rear access cover.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

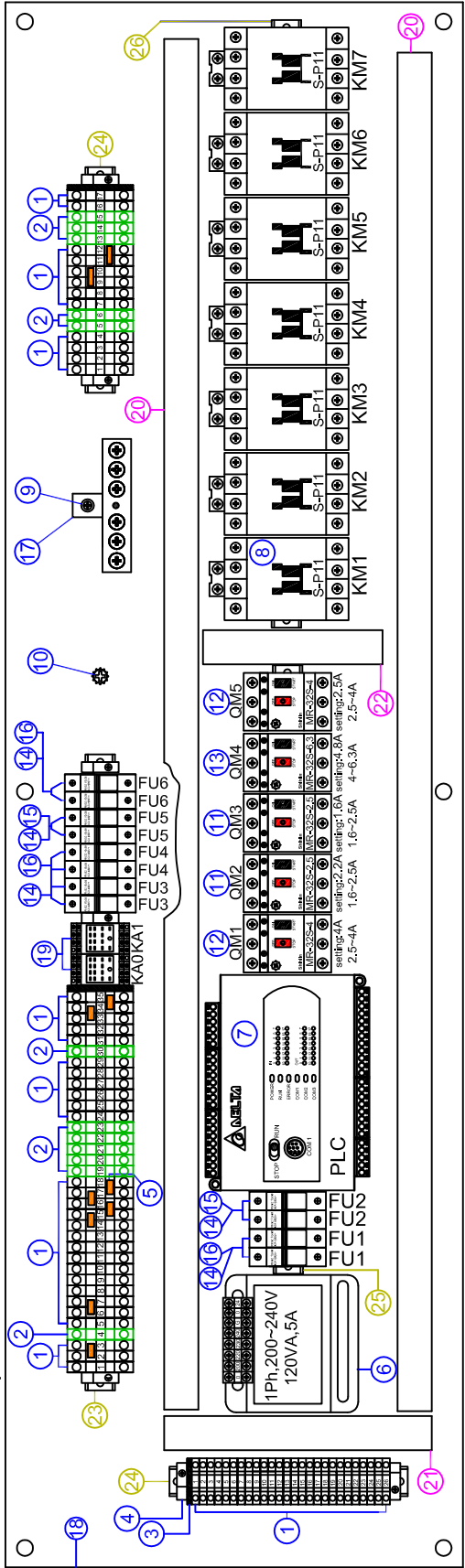
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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



Electrical Panel Wiring Diagram

SEB-E330G Specification : 1Ph 220V 60Hz Code : AB721339A-CG



Item	Part No.	Part Name	Specification	Q'TY	Item	Part No.	Part Name	Specification	Q'TY
1	203755	Klemisan Terminal Blocks	PYK2.5(GREY)	66	14	994945	DF Electric Fuse holders	PMX-10X38 1Pole	12
2	205364	Klemisan Earth Terminal	PYK2.5T	12	15	994946	Bussmann FUSE	KTK-6 6A(FU2,FU5)	4
3	203757	Klemisan End Plate	NPP PYK2.5	3	16	994950	Bussmann FUSE	KTK-3 3A(FU1,FU3,FU4,FU6)	8
4	203756	DIN Rail End Bracket	ZGX TBR-F	7	17	721386	Grounding Terminal	6-Pole ,20A	1
5	203760	Klemisan Cross Connection	UK 2,5/2	10	18	721339	Circuit plate	Galvanized iron sheet	1
6	207217-1	T-supply Transformer	Input : 220~240V 50/60Hz Output : 24V ,Cap.:120VA	1	19	721385	OMRON Relay	MY4N-J 24VAC	2
7	721415	Delta PLC	DVP32ES200R	1	20	205180-01	Wiring Duct	25(W)x65(H)x870(L) Unit:mm	2
8	994761	Shihlin Electric Contactor	S-P11S,AC24V	7	21	205180-01	Wiring Duct	25(W)x65(H)x180(L) Unit:mm	1
9	SP059200	Pan Head Screw	M5x10L	1	22	205180-01	Wiring Duct	25(W)x65(H)x130(L) Unit:mm	2
10	SF059200	Pan Head Screw (W/Flange)	M5x10L	1	23	205186	35mm DIN Rail	35(W)x7.5(H)x430(L) Unit:mm	1
11	721389A	Shihlin Electric Motor Circuit Breaker	MR-32S-2.5 1.6~2.5A	2	24	205186	35mm DIN Rail	35(W)x7.5(H)x160(L) Unit:mm	2
12	721390A	Shihlin Electric Motor Circuit Breaker	MR-32S-4 2.5~4A	2	25	205186	35mm DIN Rail	35(W)x7.5(H)x440(L) Unit:mm	1
13	721391A	Shihlin Electric Motor Circuit Breaker	MR-32S-6.3 4~6.3A	1	26	205186	35mm DIN Rail	35(W)x7.5(H)x310(L) Unit:mm	1



Electrical Panel Photos

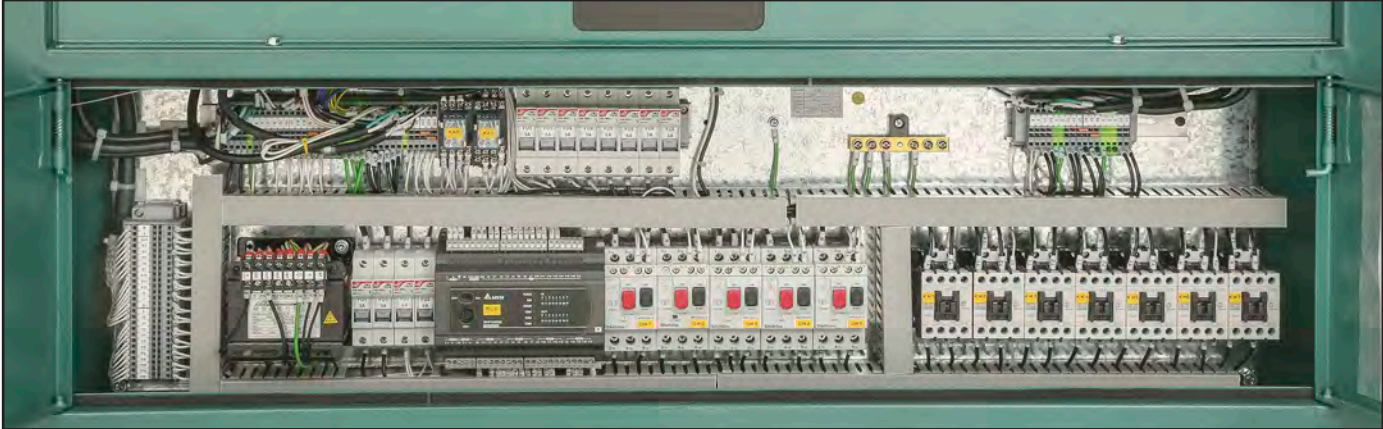


Figure 115. Electrical panel.

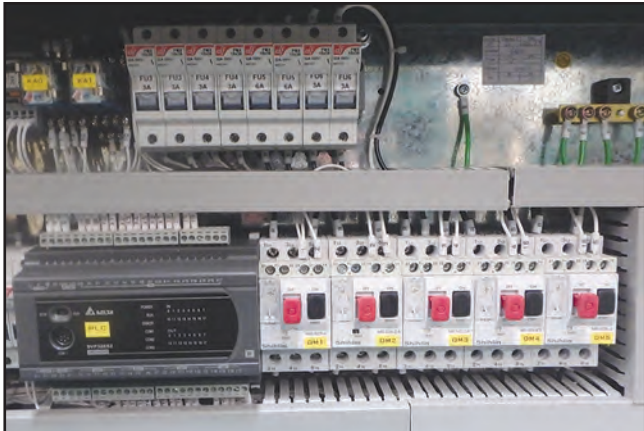


Figure 116. Electrical panel detail—center.

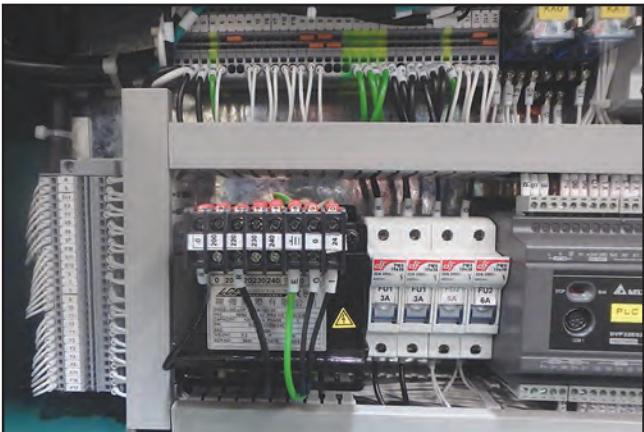


Figure 117. Electrical panel detail—leftside.

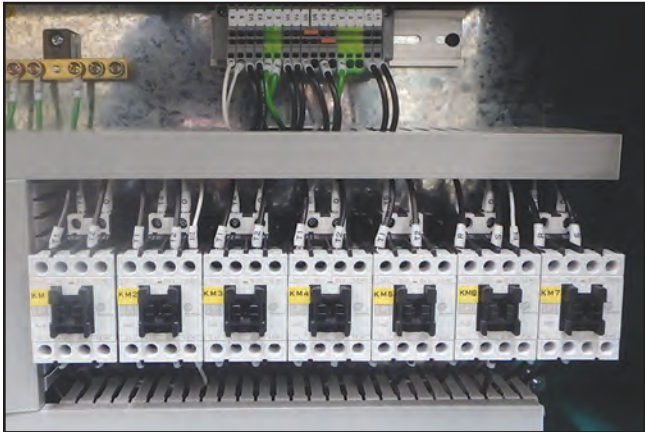
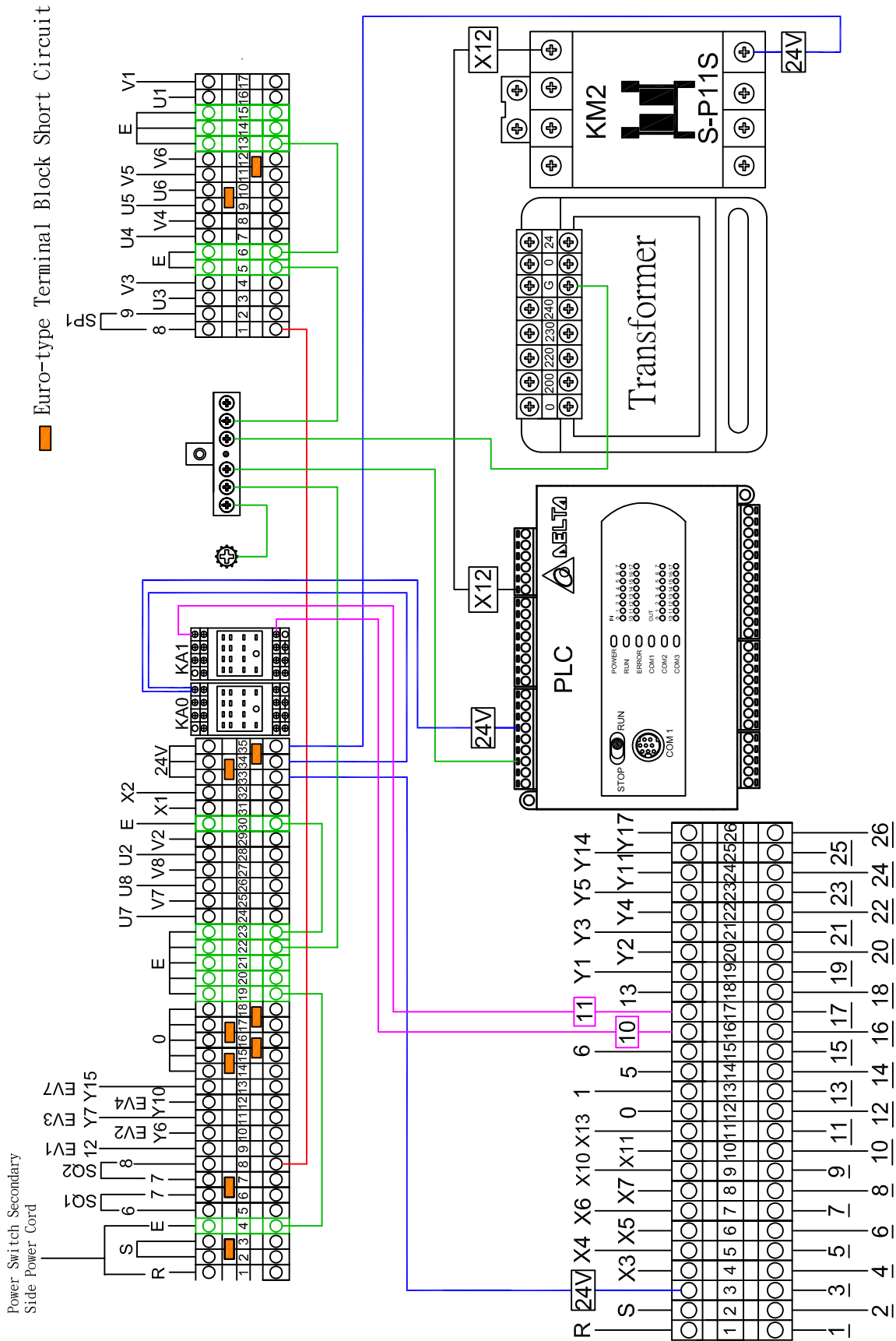


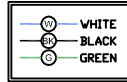
Figure 118. Electrical panel detail—rightside.



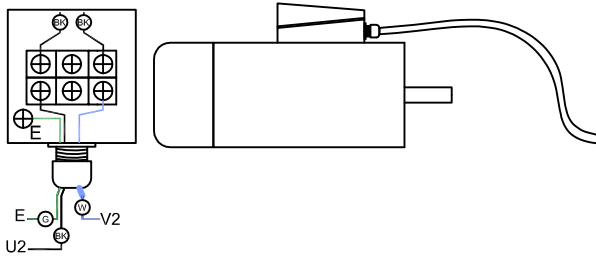
Terminal Block Wiring Diagram



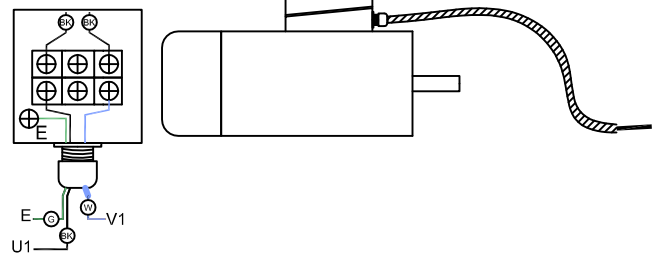
Motor Wiring Diagram



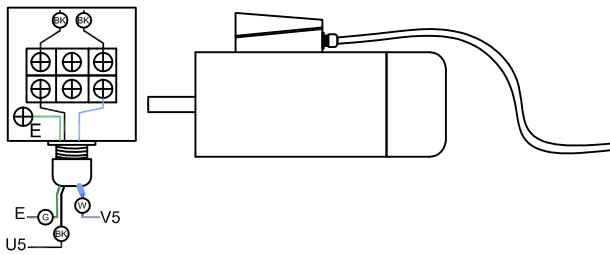
Glue Spindle Motor 220V 1-Phase



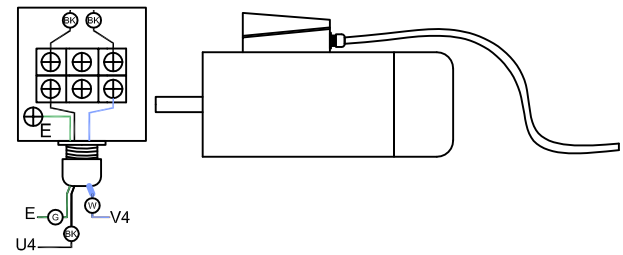
Conveyor Motor 220V 1-Phase



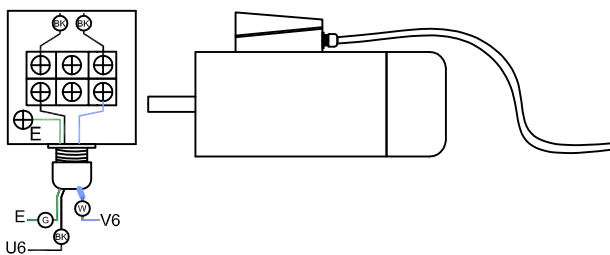
Upper Buffing Motor 220V 1-Phase



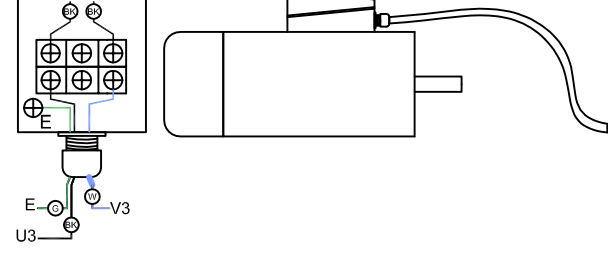
Flush Trimmer Motor 220V 1-Phase



Lower Buffing Motor 220V 1-Phase



End Trimmer Motor 220V 1-Phase



Motor Photos

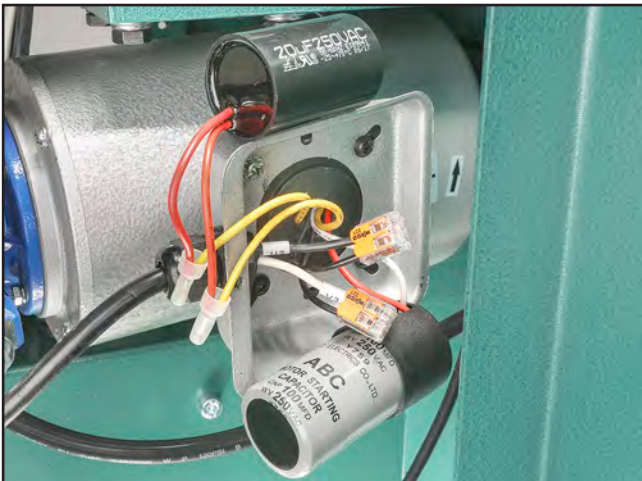


Figure 119. Glue spindle motor wiring.



Figure 122. Conveyor motor wiring.



Figure 120. Upper buffing motor wiring.

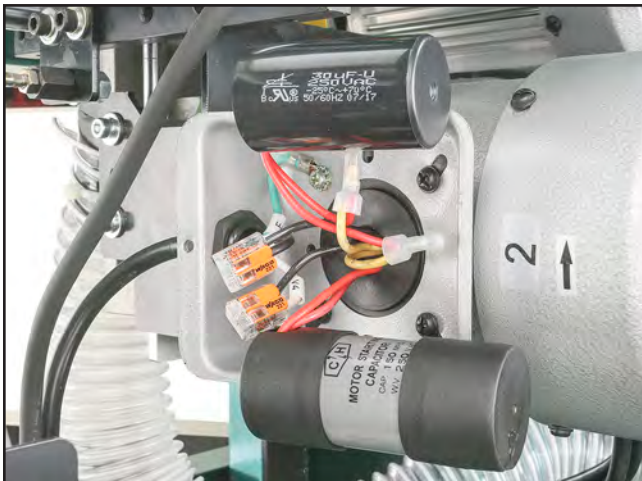


Figure 123. Flush trimmer motor wiring.

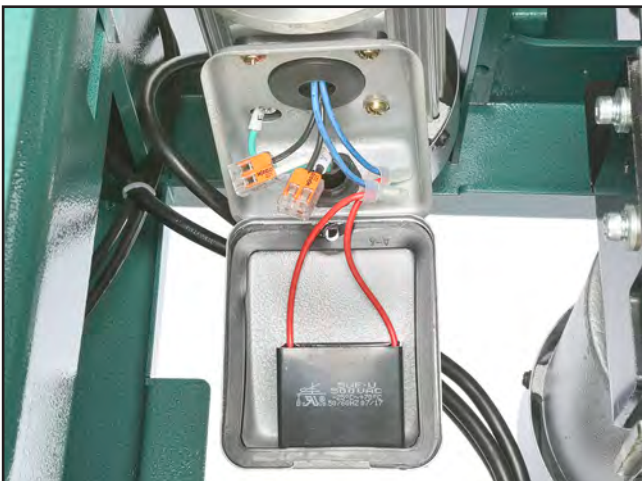


Figure 121. Lower buffing motor wiring.

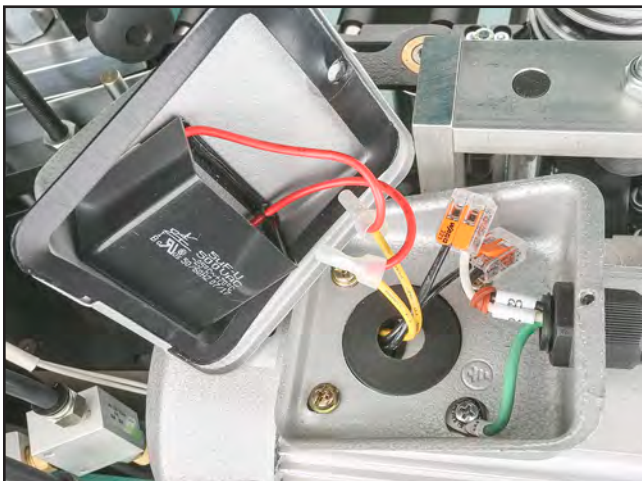
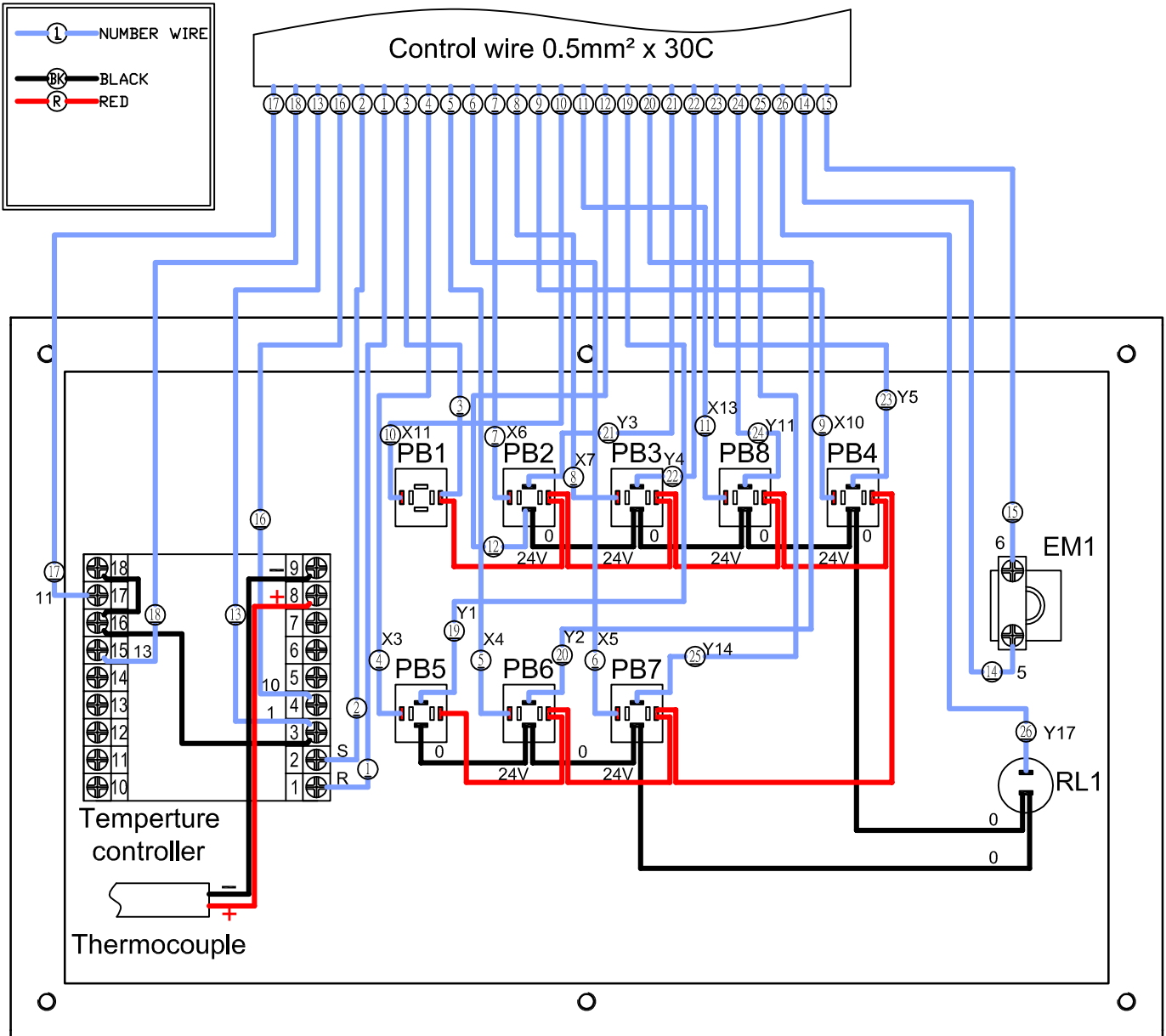


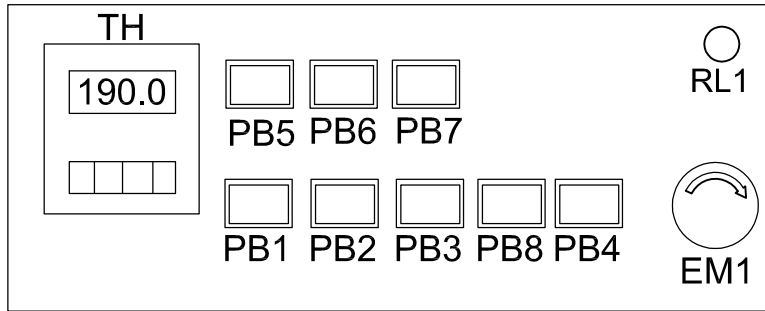
Figure 124. End trimmer motor wiring.



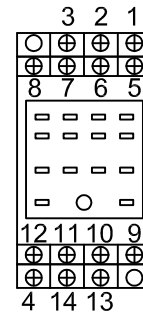
Control Panel Wiring Diagram



Control Panel SEB-E330 Component Key

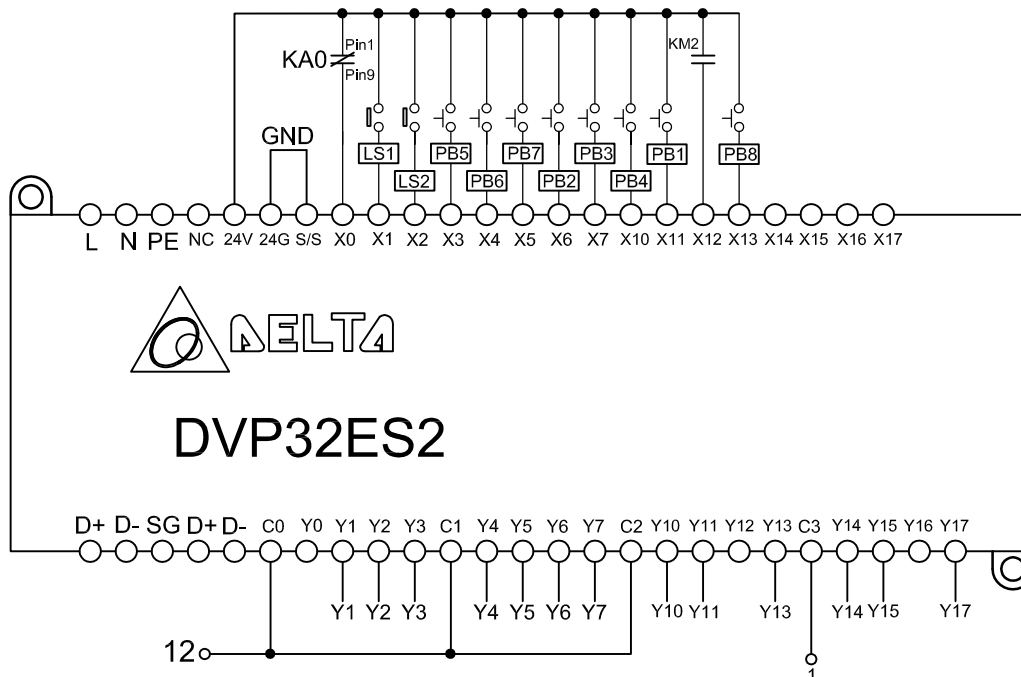


Relay Contact Position

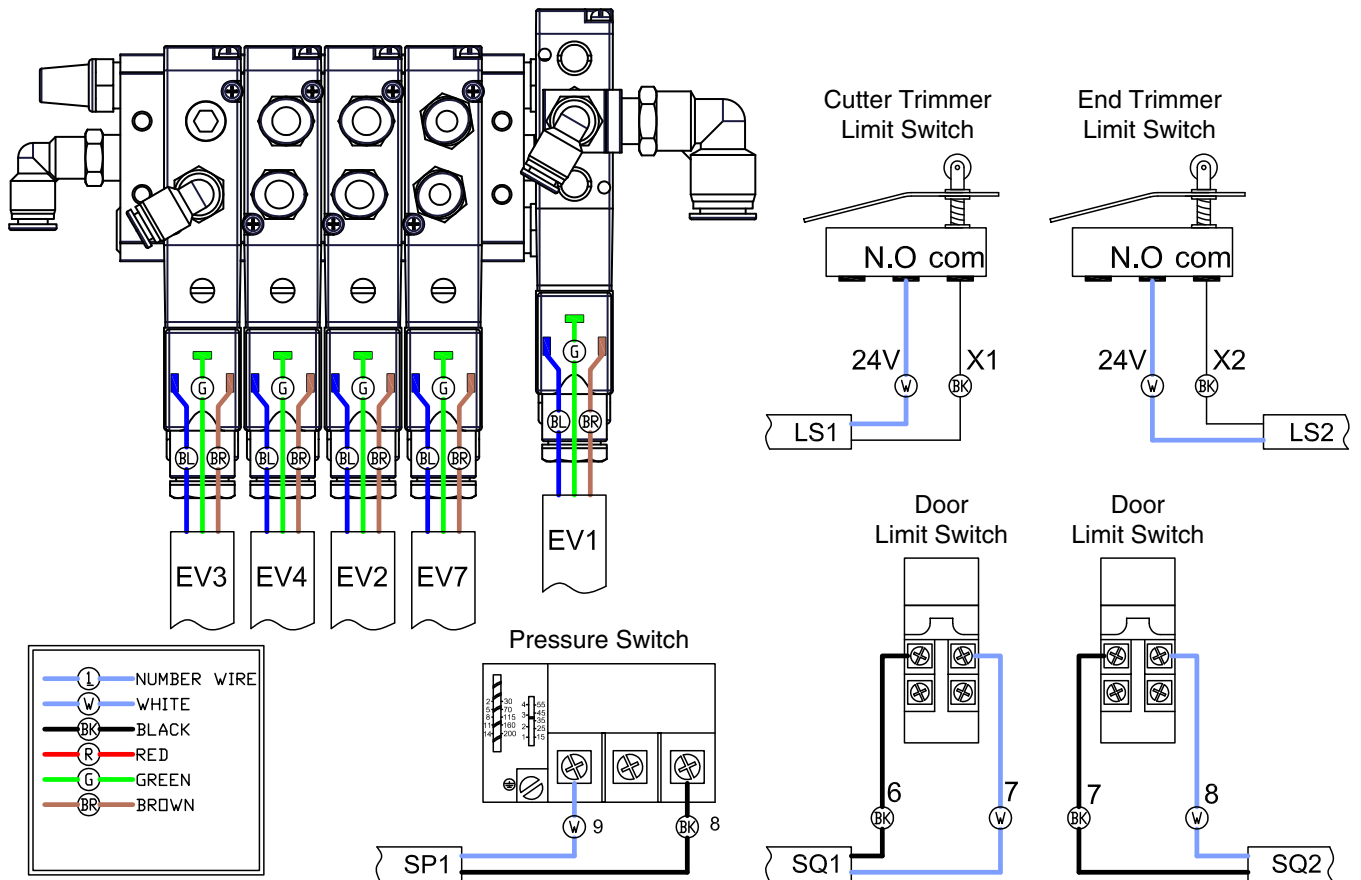


- | | | |
|---|---|--|
| X0 Safety Start | Y1 Cutter function on | LS1:Cutter limit switch |
| X1 Cutter limit switch | Y2 Front/rear trimming function on | S2:Front/rear trimming limit switch |
| X2 Front/rear trimming limit switch | Y3 Conveyor motor start | KA0:MY-4N safety start relay |
| X3 Cutter start button | Y4 Front/rear trimming motor start | TH:Temperture controller |
| X4 Front/rear trimming start button | Y5 Buffing motor start | PB1: All motors stop button |
| X5 Pre-heat start button | Y6 Cutter cylinders EV2 | PB2:Conveyor motor start button |
| X6 Conveyor motor start button | Y7 Front/rear trimming cylinders EV3 (left & right) | PB3:Front/rear trimming motor start button |
| X7 Front/rear trimming motor start button | Y10 Front/rear trimming cylinders EV4 (up & down) | PB4:Buffing motor start button |
| X10 Buffing motor start button | Y11 Flush trimming motor start | PB5:Cutter start button |
| X11 All motors stop button | Y14 Pre-heat start | PB6:Front/rear trimming start button |
| X12 Stop cylinders Control circuit | Y15 Stop cylinders EV7 | PB7:Pre-heat start button |
| X13 Flush trimming motor start button | Y17 stand by mode | PB8:Flush trimming motor start button |
| | | EM1:Emergency Stop button |
| | | RL1:stand by mode lamp |

Control Panel SEB-E330 (Standby Mode)



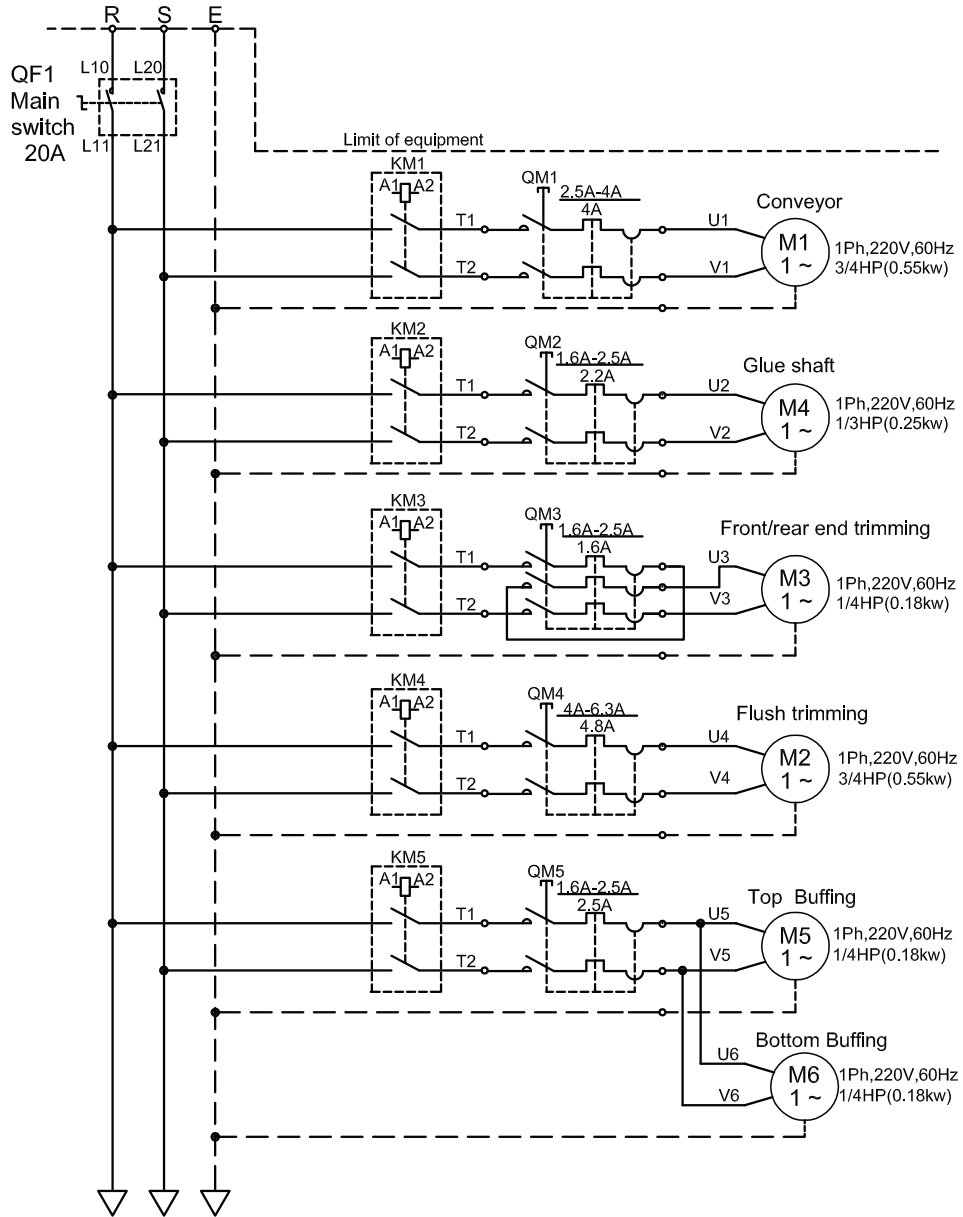
Pneumatic Valve & Limit Switch Wiring Diagram



Power Supply—Main Control Circuit

*electrical power supply:
 1~,220V 60Hz CSA
 *recommend breaker capacity:
 16A<fuse<20A, 12AWG

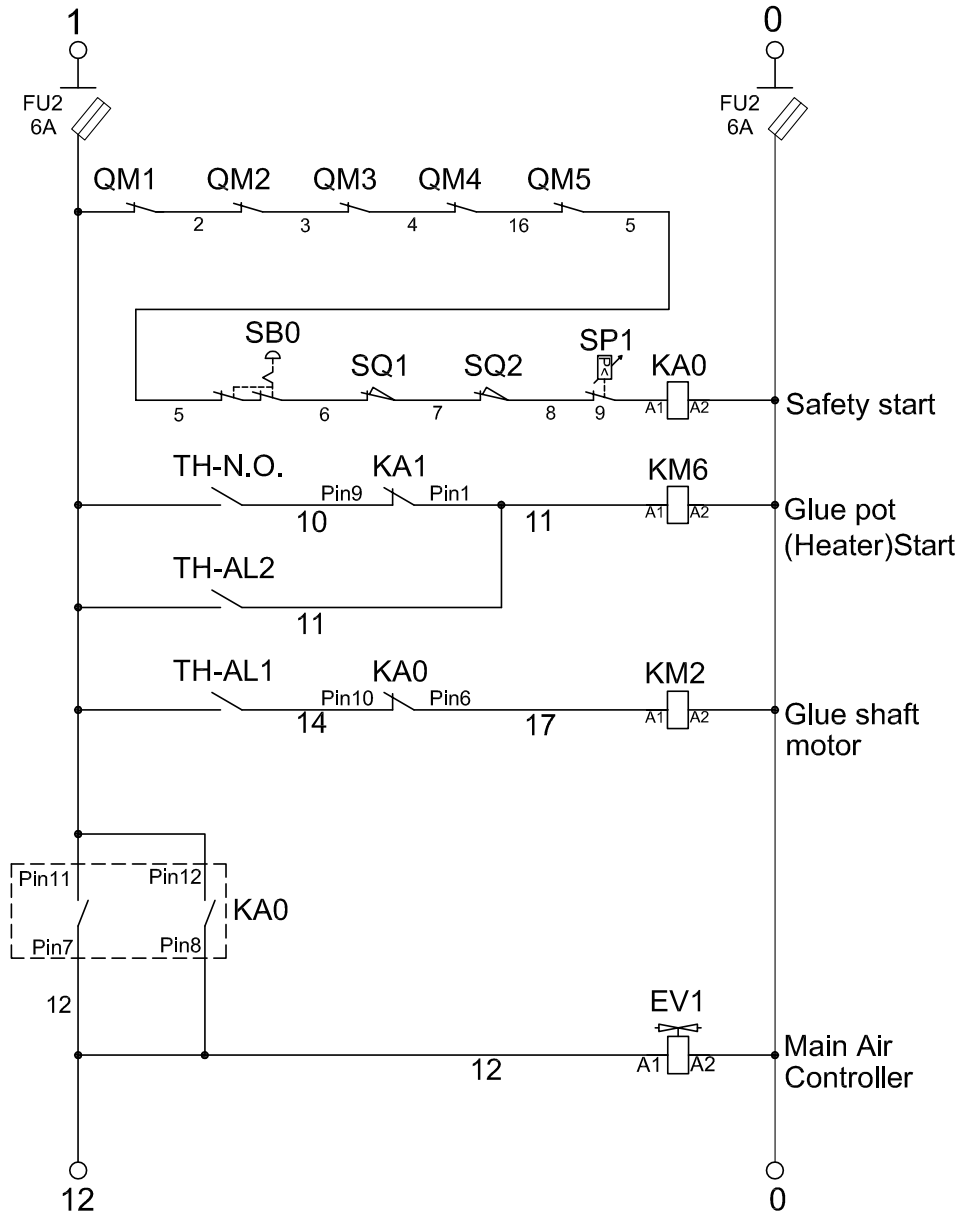
1Ph,220V,60Hz,CSA



Main Control Circuit



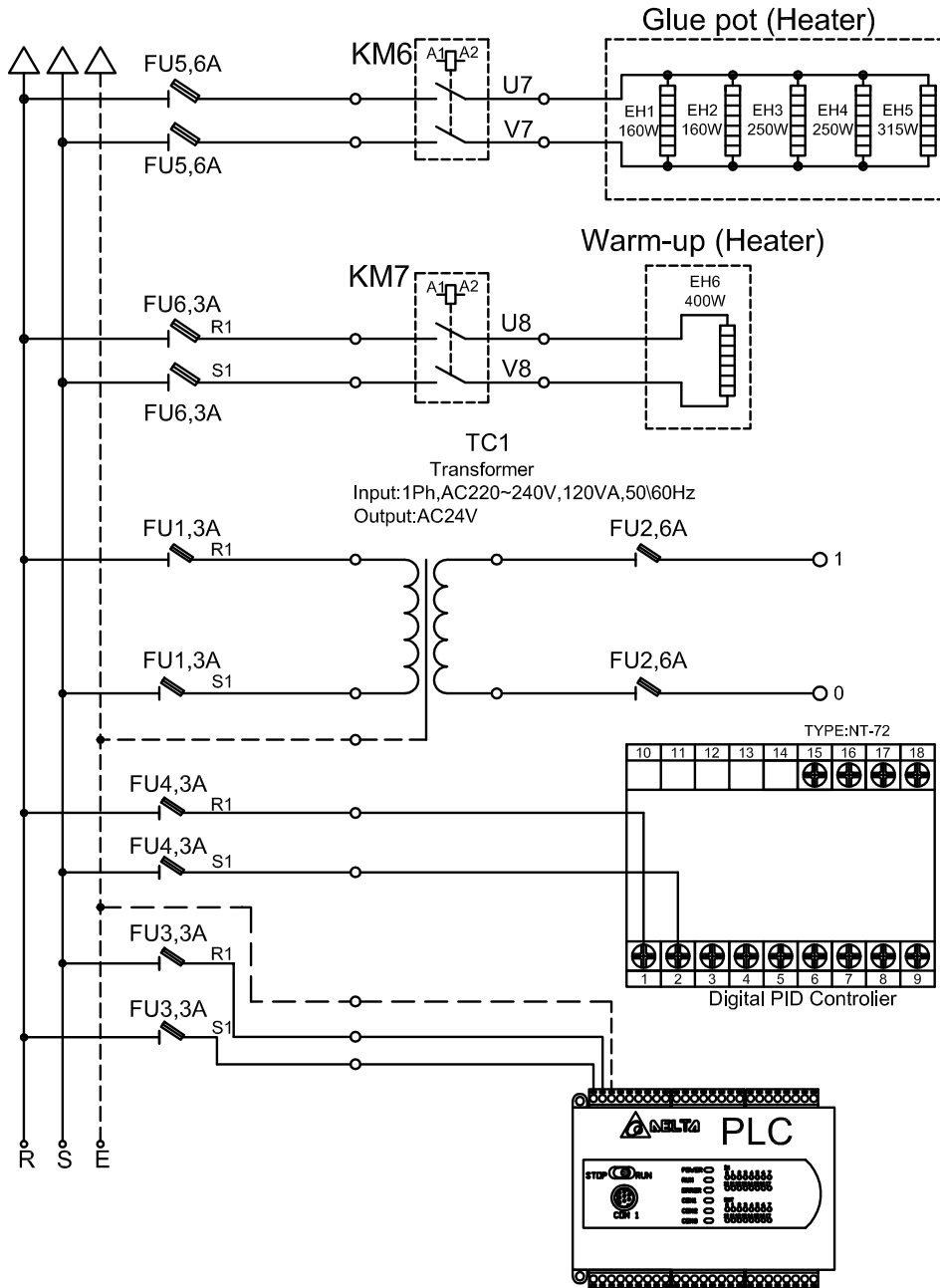
Power Supply—Motor Circuit Breaker



Motor Circuit Breaker



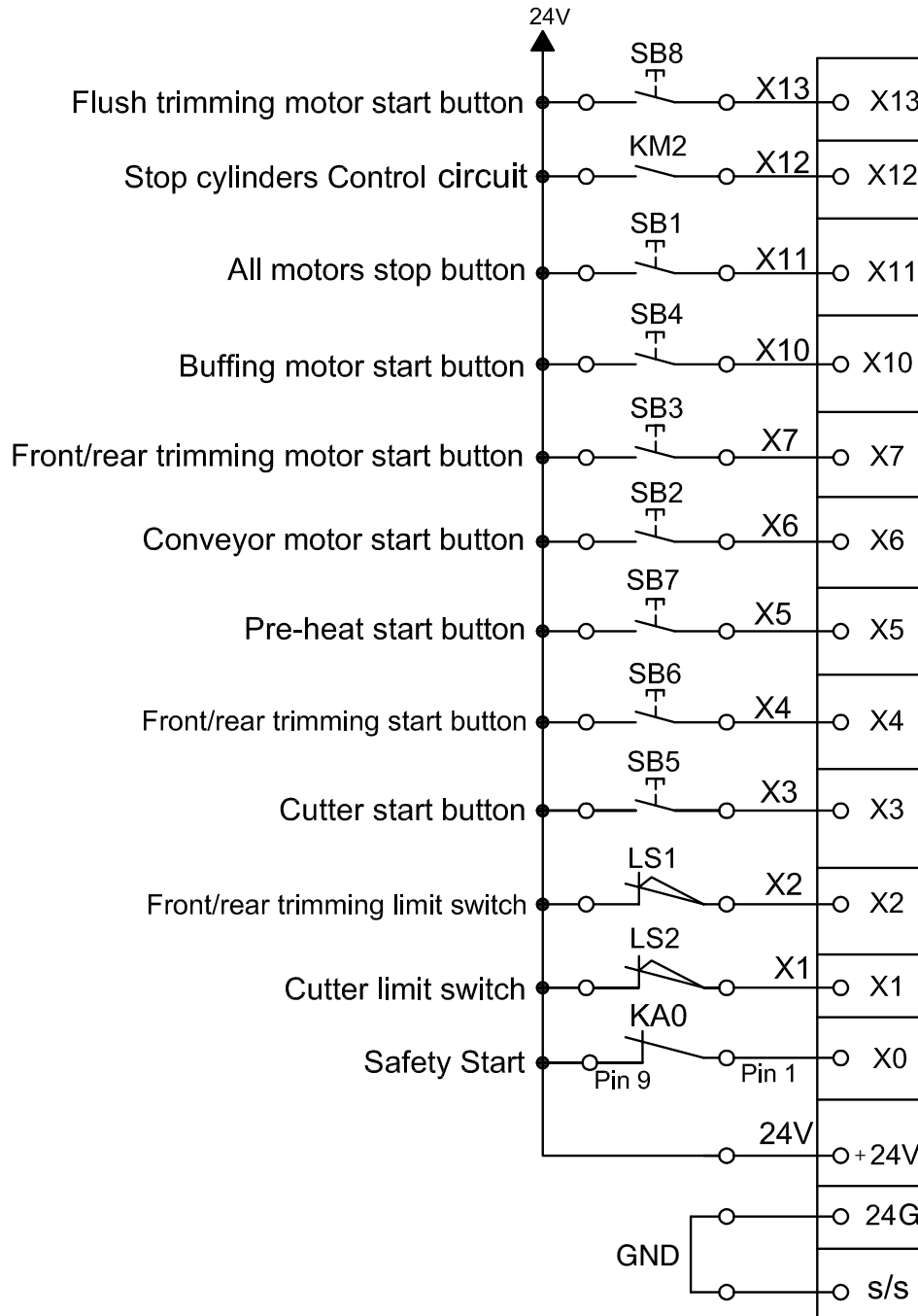
Power Supply – Transformer & Heater



Transformer & Heater



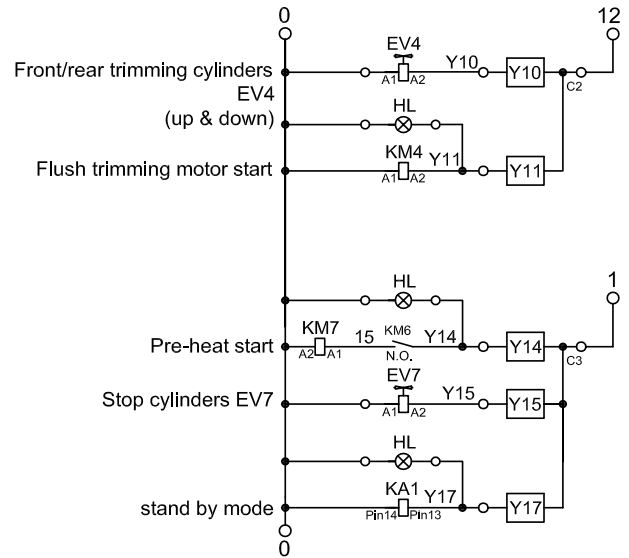
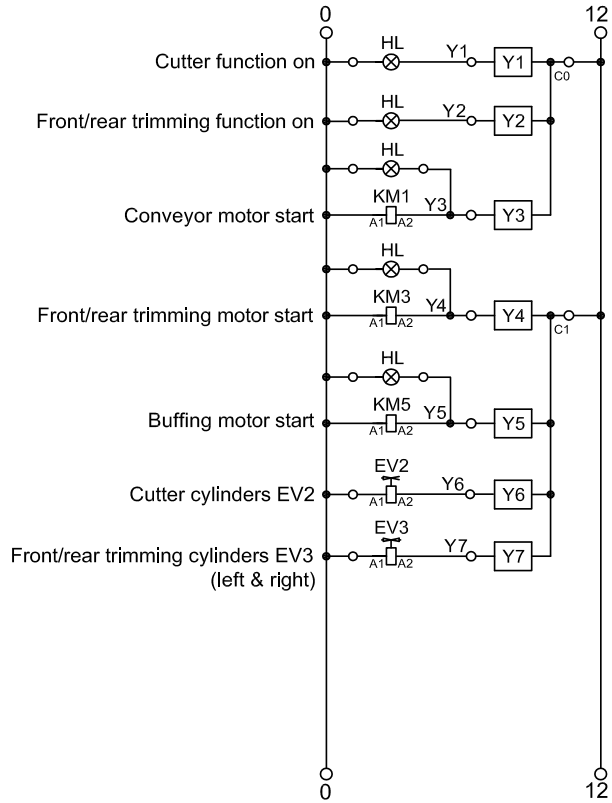
Power Supply—PLC Input



PLC Input



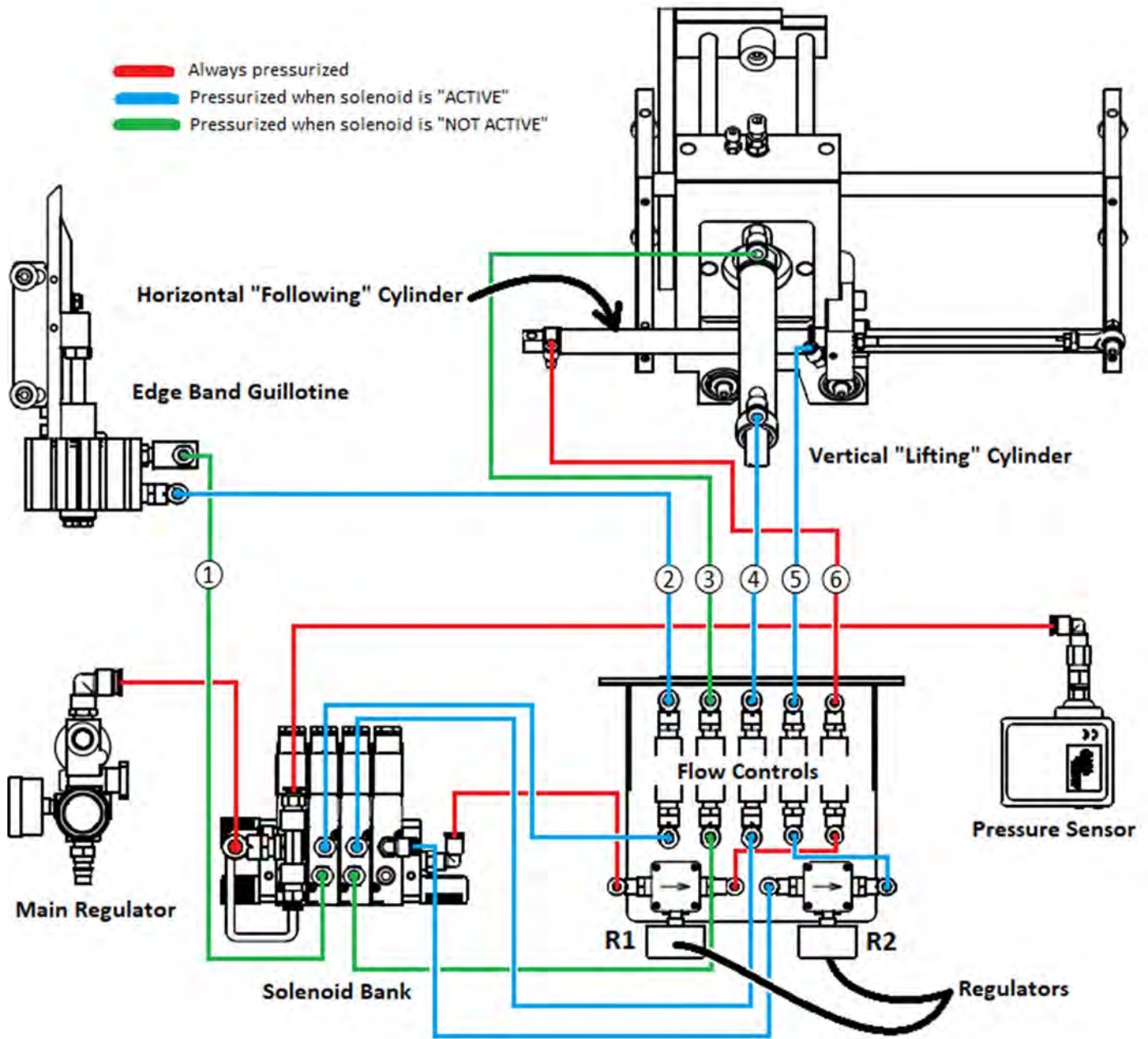
Power Supply—PLC Output



PLC Output



SECTION 9: PNEUMATIC SYSTEM



NOTICE

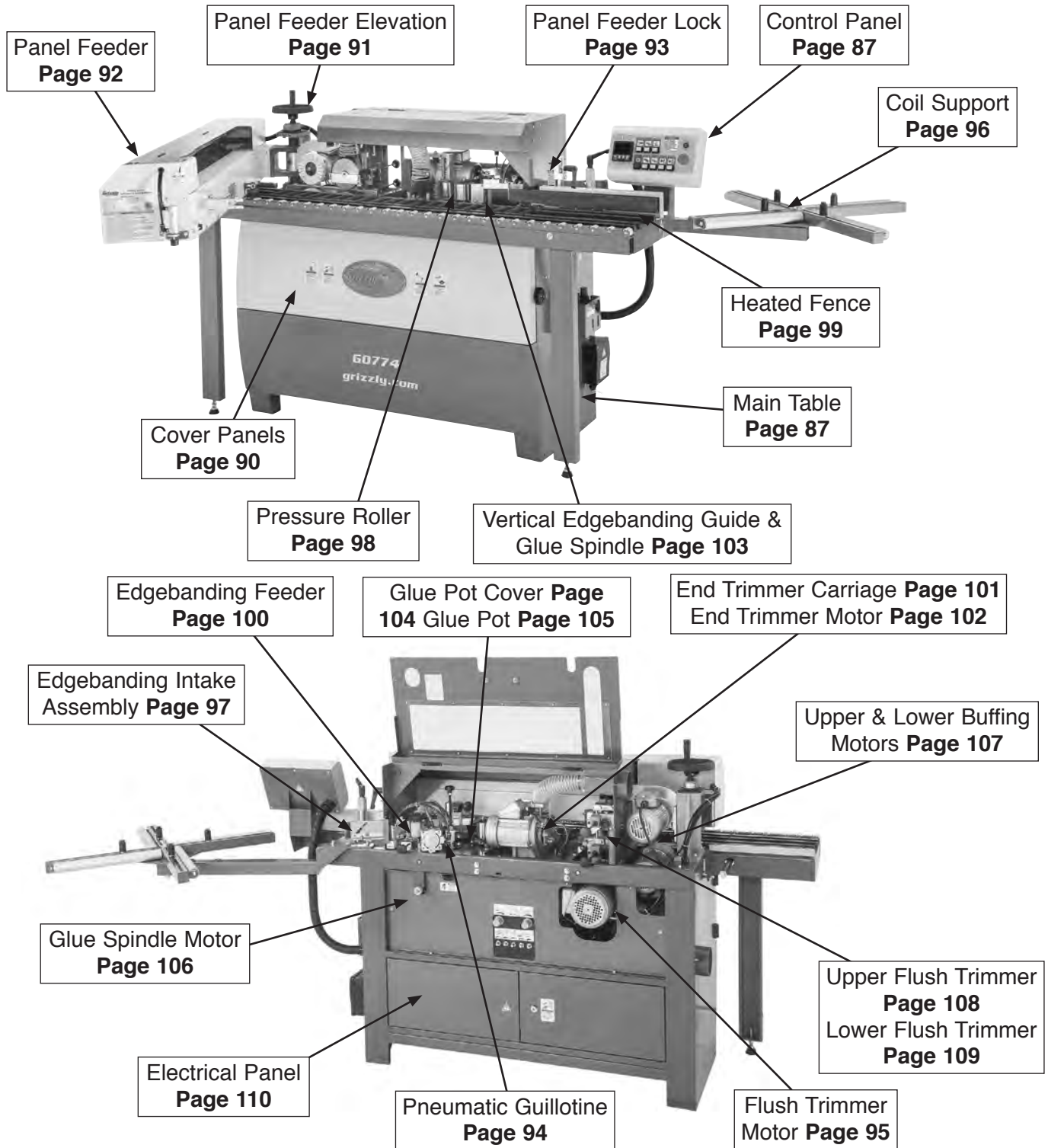
This diagram is only provided as a reference to help you identify pneumatic system components. Seek assistance from a professional pneumatic technician whenever servicing or repairing the pneumatic system.



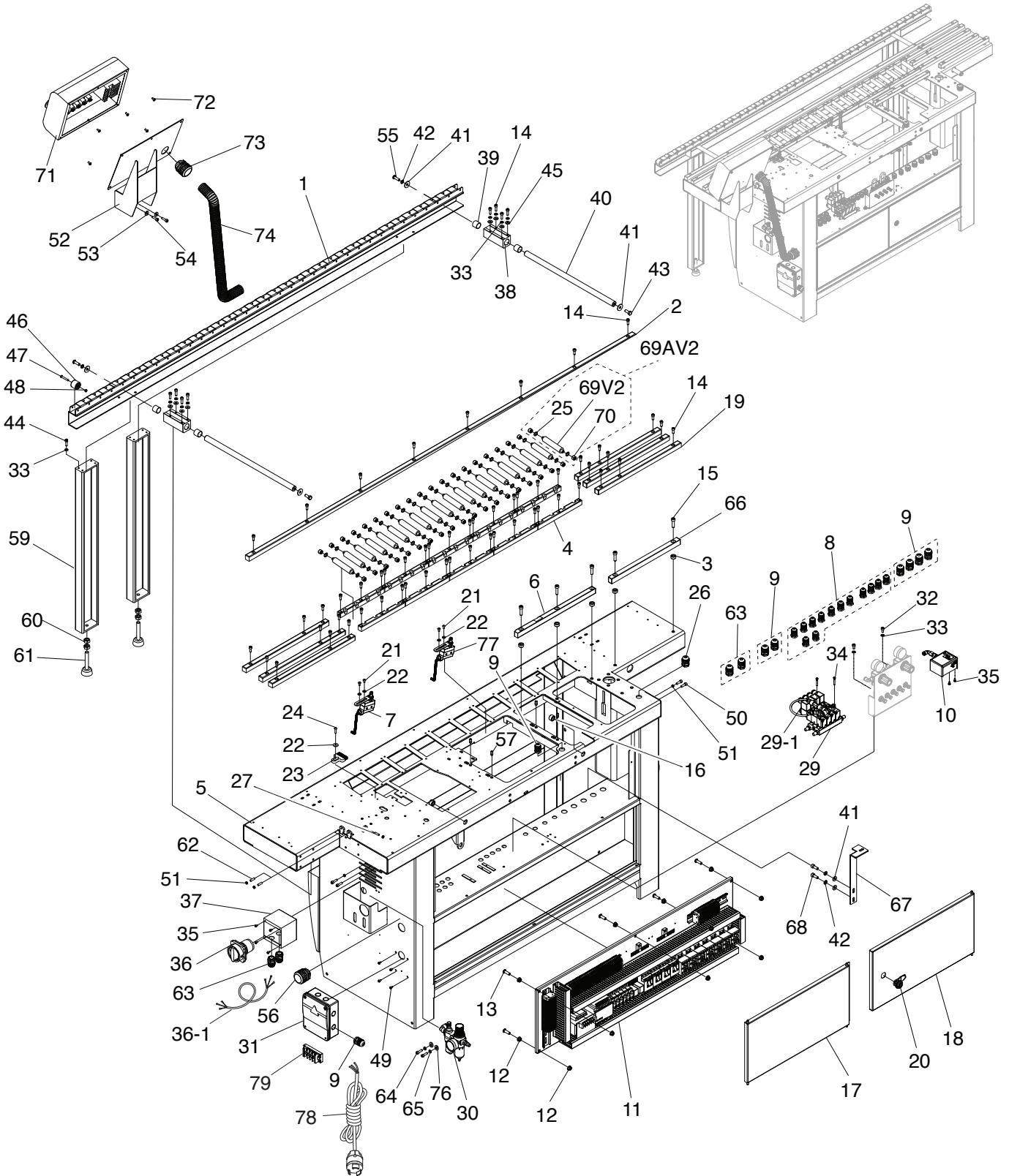
SECTION 10: PARTS

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.

Parts Reference Page



Main Table

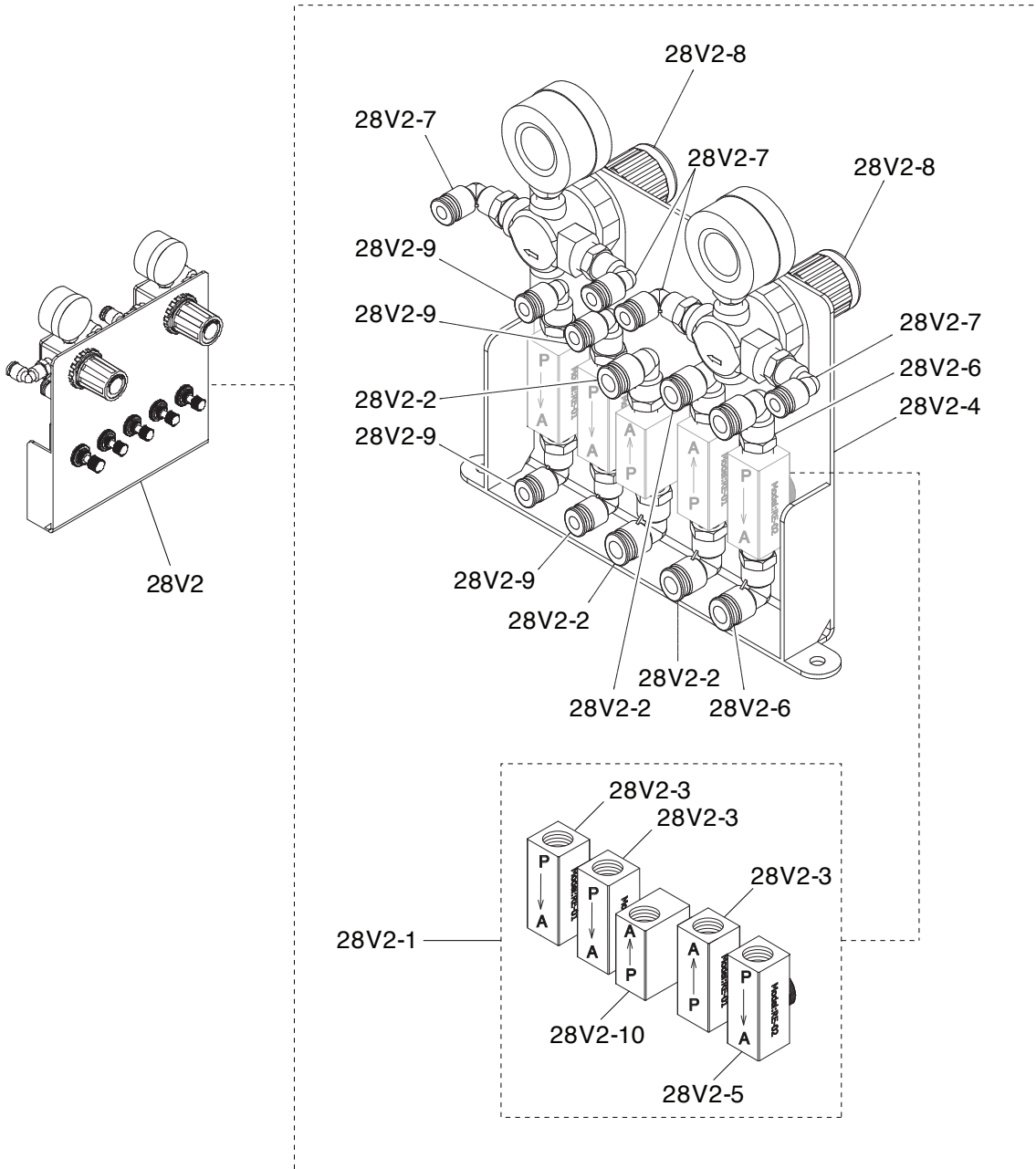


Main Table Parts List

REF	PART #	DESCRIPTION	REF	PART #	DESCRIPTION
1	P07740001	EXTENSION BRACKET	40	P07740040	EXTENSION ROD 21 X 3/4"
2	P07740002	ROLLER SKID 78-1/2 X 3/4 X 3/4"	41	P07740041	FENDER WASHER 8MM
3	P07740003	FLAT WASHER 8MM	42	P07740042	LOCK WASHER 8MM
4	P07740004	WHEEL SEAT 9"	43	P07740043	HEX BOLT M8-1.25 X 12
5	P07740005	CABINET BODY	44	P07740044	CAP SCREW M6-1 X 20
6	P07740006	FENCE PLATE (NOTCHED)	45	P07740045	FLAT WASHER 6MM
7	P07740007	LIMIT SWITCH SNZ AZD-S11 2A 400V	46	P07740046	EXTENSION SUPPORT ROLLER
8	P07740008	STRAIN RELIEF TYPE-1 PG9 (1PC)	47	P07740047	BUTTON HD CAP SCR M5-.8 X 40
9	P07740009	STRAIN RELIEF TYPE-1 PG13.5 (1PC)	48	P07740048	LOCK NUT M5-.8
10	P07740010	PRESSURE SWITCH DANFOSS KP36	49	P07740049	PHLP HD SCR M6-1 X 12
11	P07740011	ELECTRICAL PANEL ASSEMBLY	50	P07740050	CAP SCREW M6-1 X 25
12	P07740012	FLANGE NUT M8-1.25	51	P07740051	HEX NUT M6-1
13	P07740013	BUTTON HD CAP SCR M8-1.25 X 25	52	P07740052	CONTROL PANEL BACKPLATE
14	P07740014	CAP SCREW M6-1 X 16	53	P07740053	FLAT WASHER 8MM
15	P07740015	CAP SCREW M8-1.25 X 30	54	P07740054	CAP SCREW M8-1.25 X 12
16	P07740016	MAGNETIC CATCH	55	P07740055	BUTTON HD CAP SCR M8-1.25 X 16
17	P07740017	ELECTRICAL PANEL DOOR (L)	56	P07740056	WAVE TUBE N-MGN32-34B
18	P07740018	ELECTRICAL PANEL DOOR (R)	57	P07740057	SET SCREW M8-1.25 X 8
19	P07740019	WORKPIECE SUPPORT BAR	59	P07740059	EXTENSION TABLE LEG
20	P07740020	ELECTRICAL PANEL DOOR LOCK	60	P07740060	HEX NUT M12-1.75
21	P07740021	BUTTON HD CAP SCR M5-.8 X 10	61	P07740061	ADJUSTABLE FOOT M12-1.75 X 75
22	P07740022	FLAT WASHER 5MM	62	P07740062	SET SCREW M6-1 X 16
23	P07740023	BRUSH	63	P07740063	STRAIN RELIEF TYPE-3 PG20
24	P07740024	BUTTON HD CAP SCR M5-.8 X 20	64	P07740064	CAP SCREW M6-1 X 12
25	P07740025	FLAT WASHER 10MM	65	P07740065	LOCK WASHER 6MM
26	P07740026	NYLON BOX CONNECT N-MGN16-15B-ST	66	P07740066	OUTFEED SKID BAR 14 X 3/4 X 1" METAL
27	P07740027	HEX BOLT M6-1 X 25	67	P07740067	MOTOR CONTACT BAR
29	P07740029	SOLENOID FONRAY 4V210-08H 0.15-.8MP	68	P07740068	CAP SCREW M8-1.25 X 20
29-1	P07740029-1	SOLENOID AMISCO E343908 24V 4.5A	69AV2	P07740069AV2	ROLLER ASSEMBLY V2.01.21
30	P07740030	FILTER/LUBRICATOR/REG FONRAY 1508	69V2	P07740069V2	ROLLER 96 X 20MM V2.01.21
31	P07740031	WIRING JUNCTION BOX	70	P07740070	NEEDLE BEARING HK1010
32	P07740032	CAP SCREW M6-1 X 12	71	P07740071	CONTROL PANEL COVER
33	P07740033	LOCK WASHER 6MM	72	P07740072	BUTTON HD CAP SCR M5-.8 X 10
34	P07740034	PHLP HD SCR M4-.7 X 30	73	P07740073	WAVE TUBE N-MGN32-34B
35	P07740035	PHLP HD SCR M4-.7 X 15	74	P07740074	CONDUIT 1-3/8" X 32"
36	P07740036	ROTARY SWITCH ZH-HD-2	76	P07740076	FLAT WASHER 6MM
36-1	P07740036-1	CORD 3W 12G 16"	77	P07740077	LIMIT SWITCH SNZ AZD-S11 2A 400V
37	P07740037	SWITCH BOX	78	P07740078	POWER CORD 12G 3W 10' L6-30P
38	P07740038	EXTENSION BRACKET BLOCK	79	P07740079	TERMINAL BLOCK 4P
39	P07740039	BUSHING			



Pressure Regulator Assembly

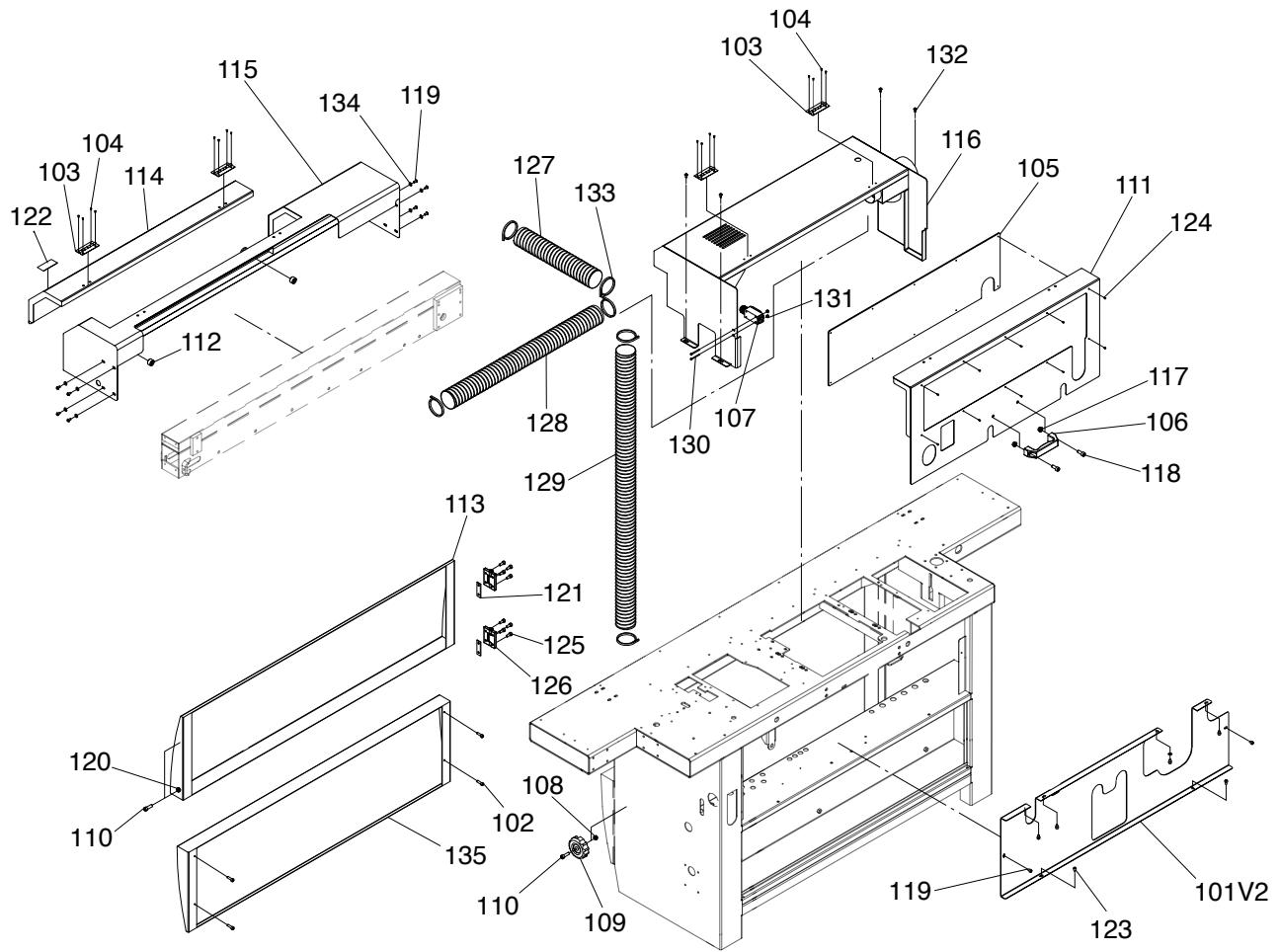


REF	PART #	DESCRIPTION
28V2	P07740028V2	PRESSURE REGULATOR ASSY V2.07.19
28V2-1	P07740028V2-1	FLOW CONTROL VALVE ASSY
28V2-2	P07740028V2-2	ELBOW 1/8 X 8 90DEG
28V2-3	P07740028V2-3	REGULATOR 1/8" AL
28V2-4	P07740028V2-4	REGULATOR PLATE
28V2-5	P07740028V2-5	REGULATOR 1/4" AL

REF	PART #	DESCRIPTION
28V2-6	P07740028V2-6	ELBOW 1/4 X 8 90DEG
28V2-7	P07740028V2-7	ELBOW 1/4 X 6 90DEG
28V2-8	P07740028V2-8	PRESSURE REGULATOR 5KG-PT1/4"
28V2-9	P07740028V2-9	ELBOW FITTING 1/8 X 6 90DEG
28V2-10	P07740028V2-10	REGULATOR 1/8" AL



Cover Panels

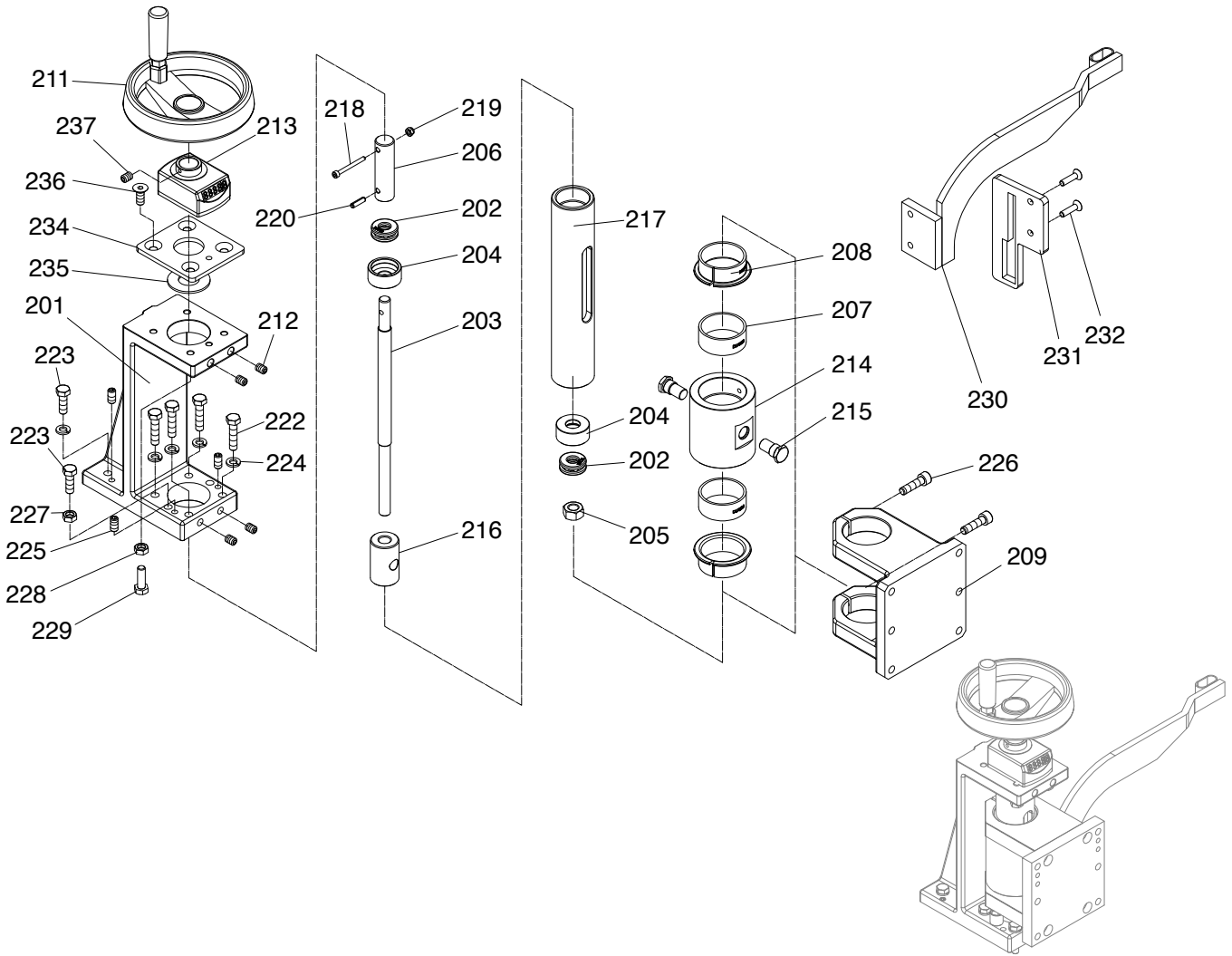


REF	PART #	DESCRIPTION
101V2	P07740101V2	REAR ACCESS PANEL V2.07.19
102	P07740102	CAP SCREW M6-1 X 12
103	P07740103	HINGE
104	P07740104	RIVET 3.2 X 8.9 BLIND
105	P07740105	CLEAR COVER
106	P07740106	REAR COVER HANDLE
107	P07740107	LIMIT SWITCH ASSY AZD-S11
108	P07740108	LOCK NUT M6-1
109	P07740109	KNOB 10-LOBE 60MM
110	P07740110	CAP SCREW M6-1 X 25
111	P07740111	REAR COVER (UPPER)
112	P07740112	MAGNETIC CATCH
113	P07740113	FRONT COVER (UPPER)
114	P07740114	PANEL FEEDER COVER
115	P07740115	PANEL FEEDER HOUSING
116	P07740116	TOP COVER
117	P07740117	FLANGE NUT M8-1.25
118	P07740118	CAP SCREW M8-1.25 X 16

REF	PART #	DESCRIPTION
119	P07740119	BUTTON HD CAP SCR M5-.8 X 8
120	P07740120	HEX NUT M6-1
121	P07740121	HINGE PLATE
122	P07740122	DO NOT LEAN LABEL
123	P07740123	FLANGE BOLT M6-1 X 8
124	P07740124	RIVET 3.2 X 8.9 BLIND
125	P07740125	CAP SCREW M5-.8 X 12
126	P07740126	HINGE
127	P07740127	CONDUIT 2.5" X 25"
128	P07740128	CONDUIT 2.5" X 36"
129	P07740129	CONDUIT 2.5" X 46"
130	P07740130	BUTTON HD CAP SCR M4-.7 X 35
131	P07740131	FLANGE NUT M4-.7
132	P07740132	FLANGE BOLT M5-.8 X 8
133	P07740133	CABLE TIE (WHITE)
134	P07740134	FLAT WASHER 5MM
135	P07740135	FRONT COVER (LOWER)



Panel Feeder Elevation

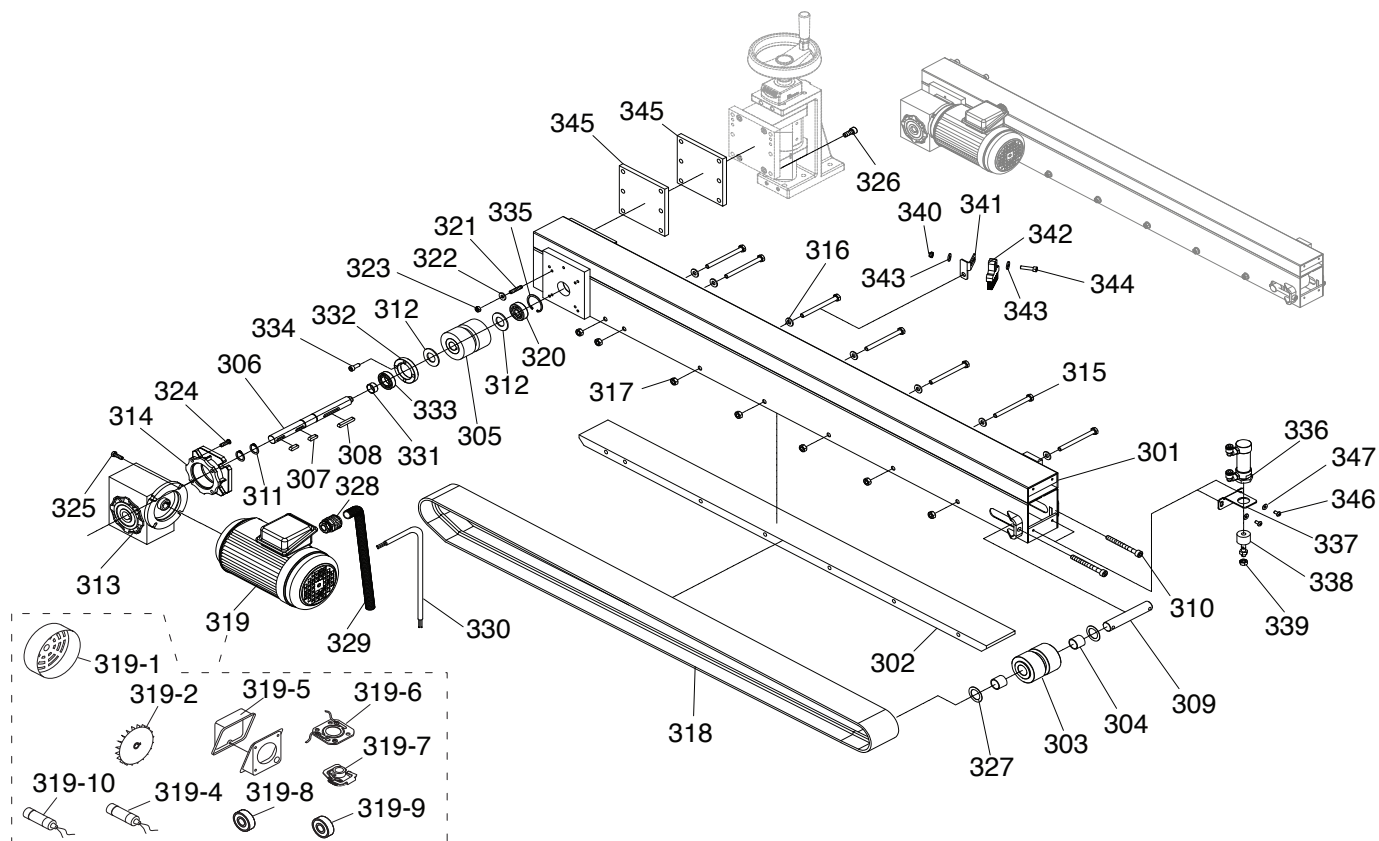


REF	PART #	DESCRIPTION
201	P07740201	PRESSURE BEAM BRACKET
202	P07740202	THRUST BEARING 51201
203	P07740203	STUD-SE M14-1.5 X 115
204	P07740204	BEARING SLEEVE BUSHING
205	P07740205	HEX NUT M12-1.75
206	P07740206	ADAPTER SHAFT
207	P07740207	BEARING SLEEVE
208	P07740208	BEARING CAP
209	P07740209	SLIDER BRACKET
211	P07740211	HANDWHEEL 2-SPOKE 165MM W/HANDLE
212	P07740212	SET SCREW M8-1.25 X 10
213	P07740213	POSITION INDICATOR
214	P07740214	SLIDER RING
215	P07740215	SHOULDER BOLT M14-1.25 X 15, 25L
216	P07740216	SHAFT SEAT M14-1.5
217	P07740217	COLUMN
218	P07740218	CAP SCREW M5-.8 X 45

REF	PART #	DESCRIPTION
219	P07740219	LOCK NUT M5-.8
220	P07740220	ROLL PIN 5 X 20
222	P07740222	HEX BOLT M8-1.25 X 40
223	P07740223	HEX BOLT M8-1.25 X 30
224	P07740224	LOCK WASHER 8MM
225	P07740225	SET SCREW M8-1.25 X 16
226	P07740226	CAP SCREW M8-1.25 X 30
227	P07740227	HEX NUT M8-1.25
228	P07740228	HEX NUT M8-1.25 THIN
229	P07740229	HEX BOLT M8-1.25 X 12
230	P07740230	COUNTER ARM SUPPORT
231	P07740231	SUPPORT ARM PLATE
232	P07740232	FLAT HD CAP SCR M6-1 X 25
234	P07740234	PRESSURE BEAM FIXED PLATE
235	P07740235	FLAT WASHER 20MM
236	P07740236	FLAT HD CAP SCR M8-1.25 X 12
237	P07740237	SET SCREW M5-.8 X 6



Panel Feeder

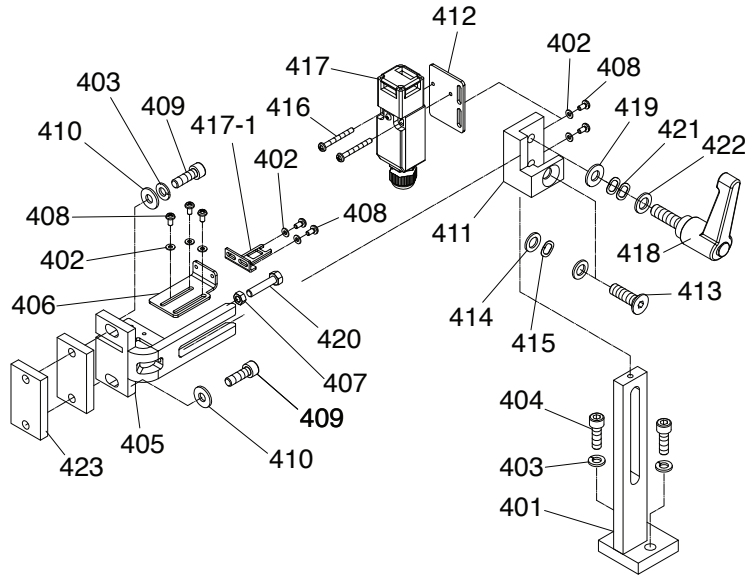


REF	PART #	DESCRIPTION
301	P07740301	CONVEYOR BODY
302	P07740302	CONVEYOR BASE PLATE
303	P07740303	BELT IDLER ROLLER 70 X 60MM, PLASTIC
304	P07740304	ROLLER BUSHING
305	P07740305	BELT DRIVE ROLLER 70 X 60MM, PLASTIC
306	P07740306	KEYED SHAFT
307	P07740307	KEY 6 X 6 X 20
308	P07740308	KEY 6 X 6 X 40
309	P07740309	ROLLER SHAFT
310	P07740310	CAP SCREW M8-1.25 X 80
311	P07740311	EXT RETAINING RING 18MM
312	P07740312	DRIVE ROLLER GASKET
313	P07740313	GEARBOX NMRV040
314	P07740314	REDUCER FLANGE
315	P07740315	HEX BOLT M8-1.25 X 90
316	P07740316	FLAT WASHER 8MM
317	P07740317	FLANGE NUT M8-1.25
318	P07740318	CONVEYER BELT (RUBBER)
319	P07740319	MOTOR 3/4HP 220V 1-PH (PANEL FEEDER)
319-1	P07740319-1	MOTOR FAN COVER
319-2	P07740319-2	MOTOR FAN
319-4	P07740319-4	R CAPACITOR 30MFD 250V
319-5	P07740319-5	MOTOR JUNCTION BOX
319-6	P07740319-6	CONTACT PLATE
319-7	P07740319-7	CENTRIFUGAL SWITCH
319-8	P07740319-8	BALL BEARING 6203ZZ (FRONT)
319-9	P07740319-9	BALL BEARING 6202ZZ (REAR)
319-10	P07740319-10	S CAPACITOR 150MFD 250V

REF	PART #	DESCRIPTION
320	P07740320	BALL BEARING 6301-2RS
321	P07740321	SET SCREW M6-1 X 30
322	P07740322	FENDER WASHER 6 X 23 X 3MM
323	P07740323	HEX NUT M6-1
324	P07740324	BUTTON HD CAP SCR M6-1 X 20
325	P07740325	HEX BOLT M6-1 X 20
326	P07740326	CAP SCREW M8-1.25 X 40
327	P07740327	FLAT WASHER 20 X 30 X .5MM
328	P07740328	WAVE TUBE N-MGN16-15B-ST
329	P07740329	CONDUIT 30" NGN-12B-50 RIBBED
330	P07740330	MOTOR CORD 16G 4W 40"
331	P07740331	BUSHING
332	P07740332	BEARING PLATE
333	P07740333	BALL BEARING 6904-2RS
334	P07740334	CAP SCREW M6-1 X 20
335	P07740335	INT RETAINING RING 37MM
336	P07740336	PNEUMATIC STOP PISTON
337	P07740337	STOP PISTON BRACKET
338	P07740338	STOP (RUBBER)
339	P07740339	HEX NUT M8-1.25
340	P07740340	HEX NUT M6-1
341	P07740341	BRUSH MOUNTING BRACKET
342	P07740342	BRUSH
343	P07740343	FLAT WASHER 6MM
344	P07740344	CAP SCREW M6-1 X 25
345	P07740345	CONVEYOR MOUNTING BLOCK
346	P07740346	BUTTON HD CAP SCR M5-.8 X 10
347	P07740347	FLAT WASHER 4MM



Panel Feeder Lock

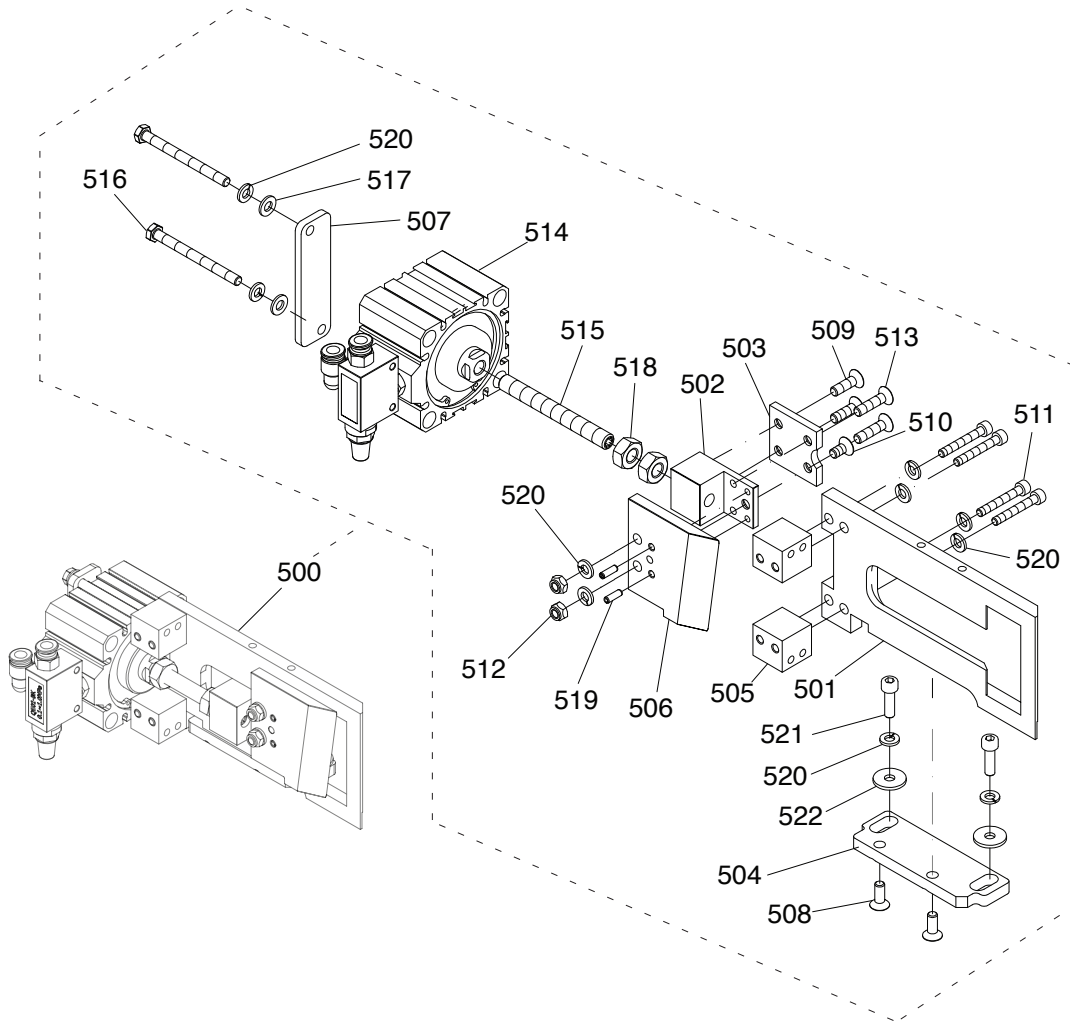


REF	PART #	DESCRIPTION
401	P07740401	ADJUSTMENT COLUMN
402	P07740402	FLAT WASHER 4MM
403	P07740403	LOCK WASHER 8MM
404	P07740404	CAP SCREW M8-1.25 X 20
405	P07740405	CONVEYOR LOCK BRACKET
406	P07740406	SWITCH CONTACT PLATE
407	P07740407	HEX NUT M6-1
408	P07740408	PHLP HD SCR M4-.7 X 8
409	P07740409	PHLP HD SCR M8-1.25 X 40
410	P07740410	FLAT WASHER 8MM
411	P07740411	ADJUSTMENT BRACKET
412	P07740412	DOOR SWITCH MOUNTING PLATE

REF	PART #	DESCRIPTION
413	P07740413	FLAT HD CAP SCR M10-1.5 X 35
414	P07740414	FLAT WASHER 10 X 20 X 2MM
415	P07740415	WAVY WASHER 10MM
416	P07740416	PHLP HD SCR M4-.7 X 30
417	P07740417	LIMIT SWITCH AZDS11
417-1	P07740417-1	LIMIT SWITCH KEY
418	P07740418	ADJUSTABLE HANDLE M10-1.5 X 35, 92L
419	P07740419	FENDER WASHER 10 X 27 X 4MM
420	P07740420	HEX BOLT M6-1 X 30
421	P07740421	WAVY WASHER 10MM
422	P07740422	FLAT WASHER 10MM
423	P07740423	LOCK BRACKET BLOCK



Pneumatic Guillotine

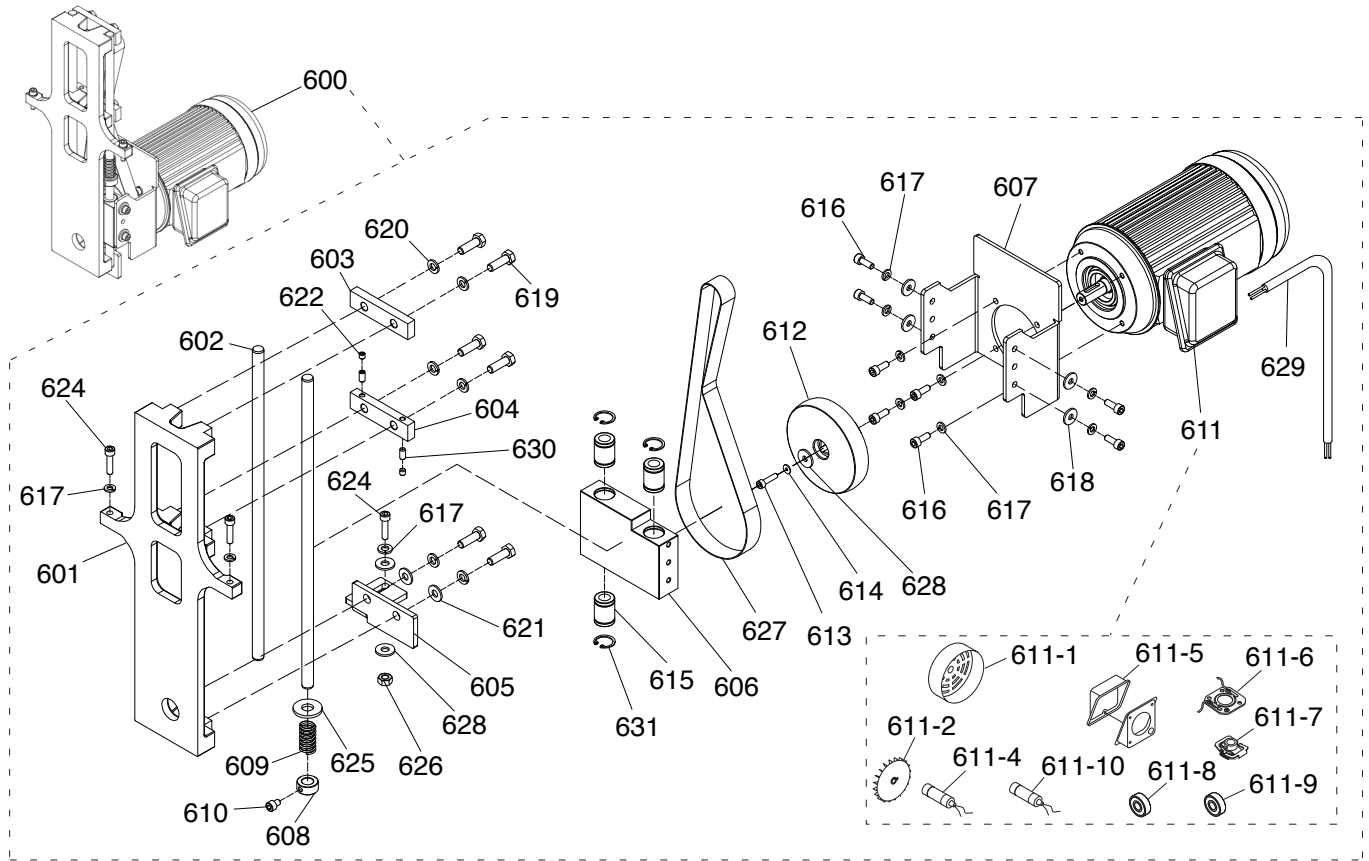


REF	PART #	DESCRIPTION
500	P07740500	GUILLOTINE ASSEMBLY
501	P07740501	CUTTER GUIDE PLATE
502	P07740502	CUTTER MOUNTING BLOCK
503	P07740503	CUTTER SUPPORT PLATE
504	P07740504	CUTTER ALIGNMENT PLATE
505	P07740505	LOCATE BLOCK
506	P07740506	CUTTER
507	P07740507	CYLINDER MOUNTING PLATE
508	P07740508	FLAT HD CAP SCR M6-1 X 16
509	P07740509	FLAT HD CAP SCR M6-1 X 20
510	P07740510	FLAT HD CAP SCR M6-1 X 12
511	P07740511	CAP SCREW M6-1 X 35

REF	PART #	DESCRIPTION
512	P07740512	LOCK NUT M6-1
513	P07740513	FLAT HD CAP SCR M6-1 X 25
514	P07740514	PNEUMATIC CYLINDER ASSEMBLY
515	P07740515	SET SCREW M10-1.5 X 90
516	P07740516	HEX BOLT M6-1 X 70
517	P07740517	FLAT WASHER 6MM
518	P07740518	HEX NUT M10-1.5
519	P07740519	ROLL PIN 4 X 12
520	P07740520	LOCK WASHER 6MM
521	P07740521	CAP SCREW M6-1 X 20
522	P07740522	FENDER WASHER 6MM



Flush Trimmer Motor

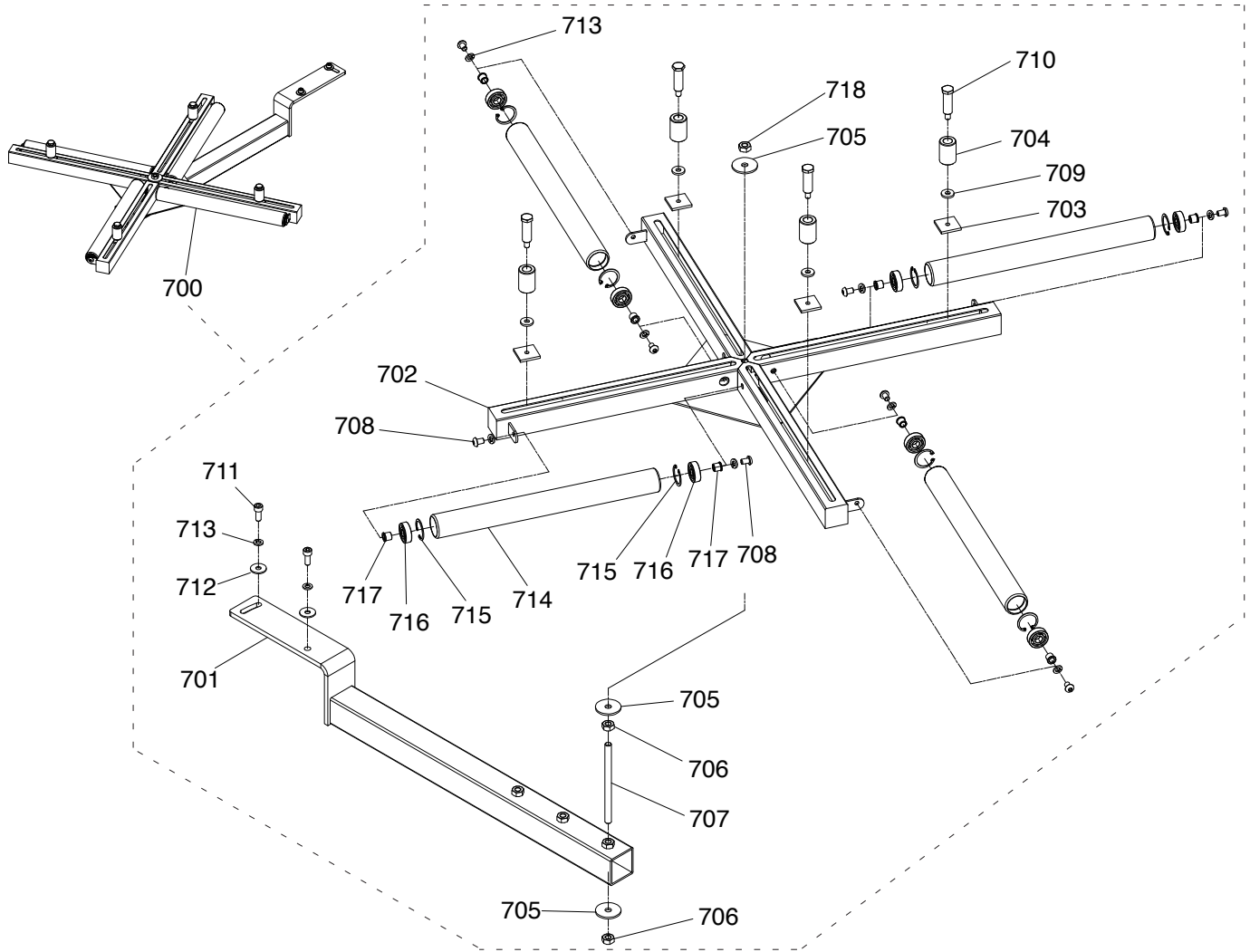


REF	PART #	DESCRIPTION
600	P07740600	FLUSH TRIMMER MOTOR ASSEMBLY
601	P07740601	COLUMN SEAT
602	P07740602	HEIGHT ROD
603	P07740603	HEIGHT ROD LOCK PLATE (UPPER)
604	P07740604	HEIGHT ROD LOCK PLATE (LOWER)
605	P07740605	MOTOR MOVEMENT PLATE
606	P07740606	MOTOR BLOCK
607	P07740607	MOTOR MOUNTING BRACKET
608	P07740608	LOCK COLLAR
609	P07740609	COMPRESSION SPRING 7 X 22 X 1.5
610	P07740610	CAP SCREW M6-1 X 10
611	P07740611	MOTOR 3/4HP 220V 1-PH (TRIM ROUTER)
611-1	P07740611-1	MOTOR FAN COVER
611-2	P07740611-2	MOTOR FAN
611-4	P07740611-4	R CAPACITOR 30MFD 250V
611-5	P07740611-5	MOTOR JUNCTION BOX
611-6	P07740611-6	CONTACT PLATE
611-7	P07740611-7	CENTRIFUGAL SWITCH
611-8	P07740611-8	BALL BEARING 6203ZZ (FRONT)
611-9	P07740611-9	BALL BEARING 6202ZZ (REAR)

REF	PART #	DESCRIPTION
611-10	P07740611-10	S CAPACITOR 150MFD 250V
612	P07740612	FLAT BELT PULLEY
613	P07740613	CAP SCREW M5-.8 X 16
614	P07740614	FLAT WASHER 5MM
615	P07740615	LINEAR BEARING LM12UU
616	P07740616	CAP SCREW M6-1 X 16
617	P07740617	LOCK WASHER 6MM
618	P07740618	FLAT WASHER 6MM
619	P07740619	HEX BOLT M8-1.25 X 25
620	P07740620	LOCK WASHER 8MM
621	P07740621	FLAT WASHER 8MM
622	P07740622	SET SCREW M6-1 X 6
624	P07740624	CAP SCREW M6-1 X 25
625	P07740625	FLAT WASHER 13MM
626	P07740626	HEX NUT M6-1
627	P07740627	BELT 20 X 730MM
628	P07740628	FLAT WASHER 6 X 19 X 2MM
629	P07740629	MOTOR CORD 16G 3W 12"
630	P07740630	SET SCREW M6-1 X 20
631	P07740631	INT RETAINING RING R21



Coil Support

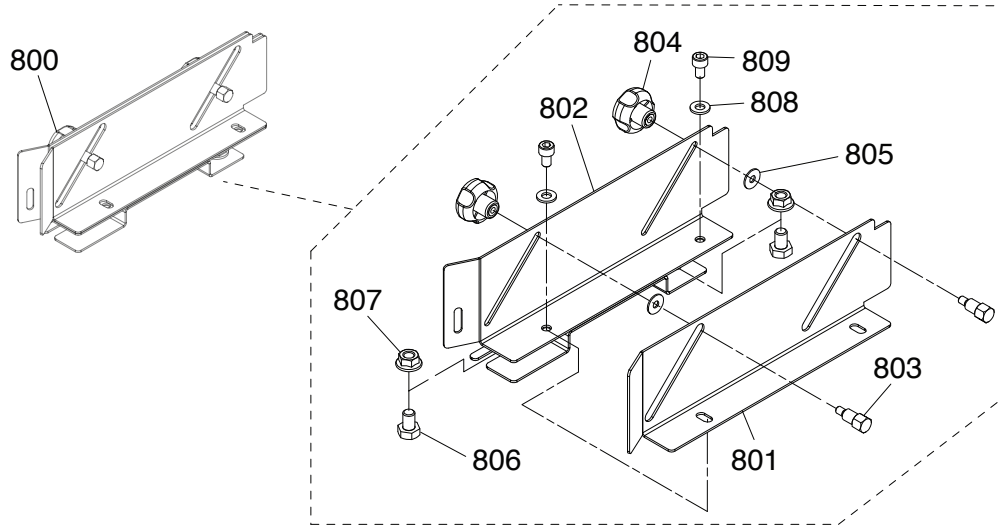


REF	PART #	DESCRIPTION
700	P07740700	COIL SUPPORT ASSEMBLY
701	P07740701	SUPPORT ARM
702	P07740702	COIL SUPPORT
703	P07740703	ROLLER LOCK PLATE M8-1.25
704	P07740704	BANDING TENSION ROLLER 40 X 25MM
705	P07740705	FENDER WASHER 10MM
706	P07740706	HEX NUT M10-1.5
707	P07740707	STUD-FT M10-1.5 X 150
708	P07740708	BUTTON HD CAP SCR M8-1.25 X 16
709	P07740709	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
710	P07740710	SHOULDER BOLT M8-1.25 X 12, 14 X 52L
711	P07740711	CAP SCREW M8-1.25 X 20
712	P07740712	FLAT WASHER 8MM
713	P07740713	LOCK WASHER 8MM
714	P07740714	BANDING ROLLER 375 X 40MM
715	P07740715	INT RETAINING RING 32MM
716	P07740716	BALL BEARING 6201ZZ
717	P07740717	BEARING SPACER
718	P07740718	LOCK NUT M10-1.5



Edgebanding Intake Assembly

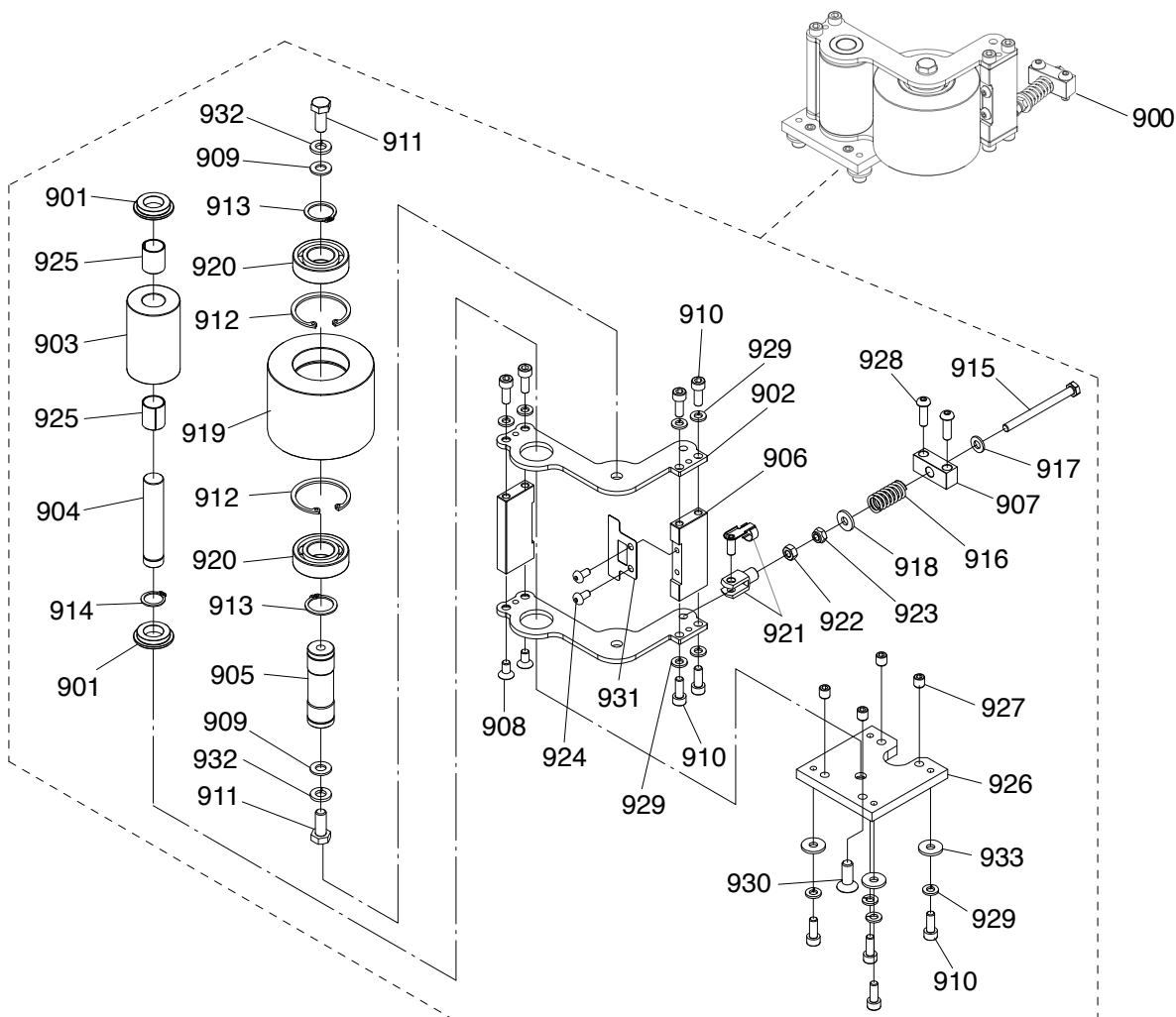


REF	PART #	DESCRIPTION
800	P07740800	EDGEBOARDING INTAKE ASSEMBLY
801	P07740801	GUIDE (INNER)
802	P07740802	GUIDE (OUTER)
803	P07740803	SHOULDER BOLT M5-.8 X 8, 8 X 18
804	P07740804	KNOB 4-LOBE M5-.8

REF	PART #	DESCRIPTION
805	P07740805	FLAT WASHER 5MM
806	P07740806	HEX BOLT M8-1.25 X 12
807	P07740807	FLANGE NUT M8-1.25
808	P07740808	FLAT WASHER 6MM
809	P07740809	CAP SCREW M6-1 X 10



Pressure Roller

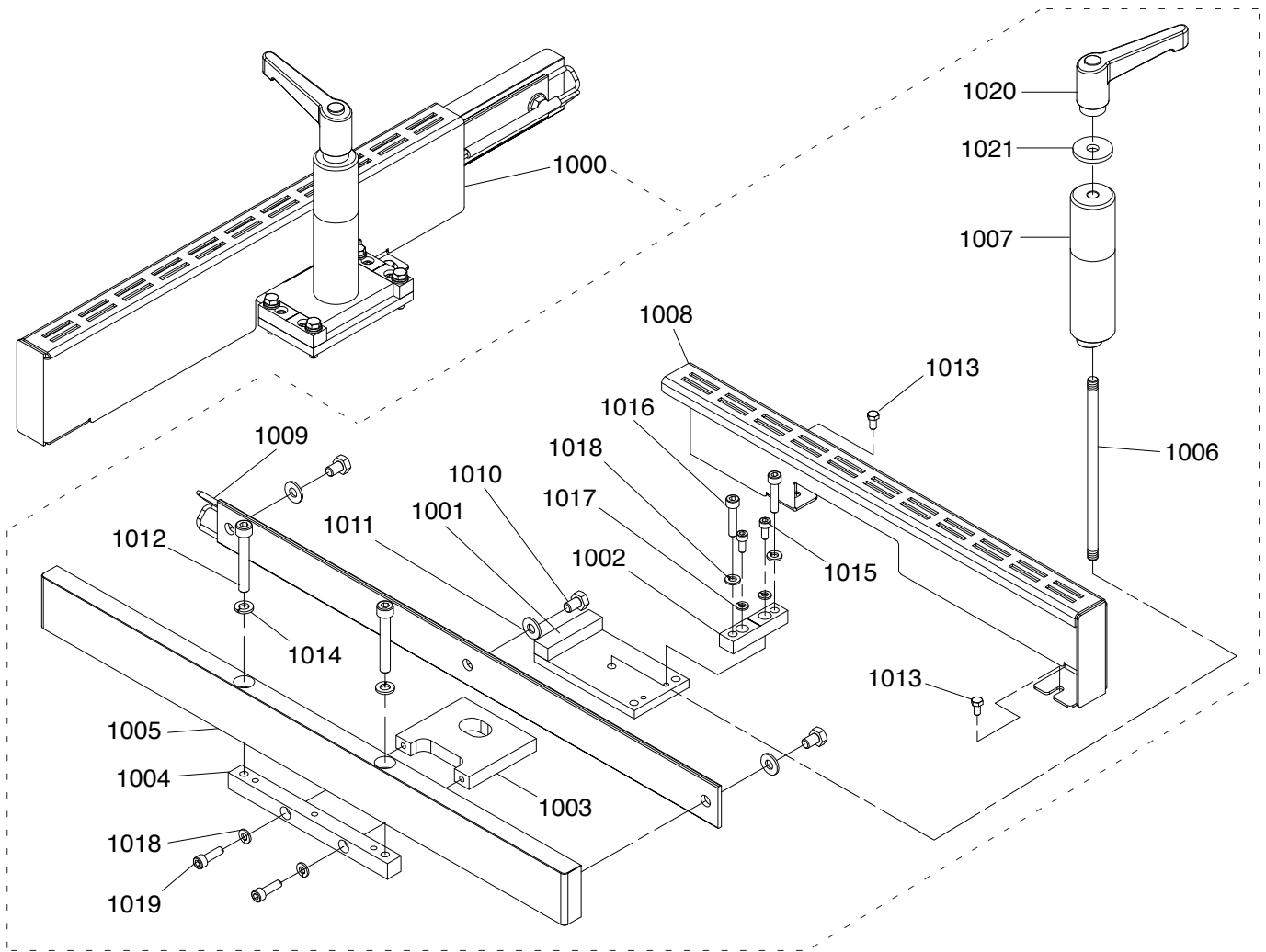


REF	PART #	DESCRIPTION
900	P07740900	PRESSURE ROLLER ASSEMBLY
901	P07740901	BEARING PLATE
902	P07740902	WHEEL SUPPORT PLATE
903	P07740903	ROLLER WHEEL 40 X 65MM METAL (OUTER)
904	P07740904	WHEEL SPINDLE 15 X 80MM (OUTER)
905	P07740905	WHEEL SPINDLE 15 X 80MM (INNER)
906	P07740906	T-PLATE SUPPORT BLOCK
907	P07740907	BASE PLATE TOP BLOCK
908	P07740908	FLAT HD CAP SCR M6-1 X 12
909	P07740909	FLAT WASHER 8MM
910	P07740910	CAP SCREW M6-1 X 16
911	P07740911	HEX BOLT M8-1.25 X 20
912	P07740912	INT RETAINING RING 42MM
913	P07740913	EXT RETAINING RING 20MM
914	P07740914	EXT RETAINING RING 15MM
915	P07740915	HEX BOLT M6-1 X 65
916	P07740916	COMPRESSION SPRING 2.5 X 14 X 30

REF	PART #	DESCRIPTION
917	P07740917	FLAT WASHER 6MM
918	P07740918	FENDER WASHER 6 X 16 X 2
919	P07740919	ROLLER WHEEL 79 X 58MM METAL (INNER)
920	P07740920	BALL BEARING 6004LLU
921	P07740921	CLEVIS ROD END
922	P07740922	HEX NUT M6-1
923	P07740923	LOCK NUT M6-1
924	P07740924	BUTTON HD CAP SCR M5-.8 X 8
925	P07740925	SELF-LUBE BEARING DU1520
926	P07740926	BASE PLATE
927	P07740927	SET SCREW M8-1.25 X 8
928	P07740928	BUTTON HD CAP SCR M6-1 X 20
929	P07740929	LOCK WASHER 6MM
930	P07740930	FLAT HD CAP SCR M8-1.25 X 20
931	P07740931	ROLLER SCRAPER
932	P07740932	LOCK WASHER 8MM
933	P07740933	FLAT WASHER 6 X 18 X 2MM



Heated Fence

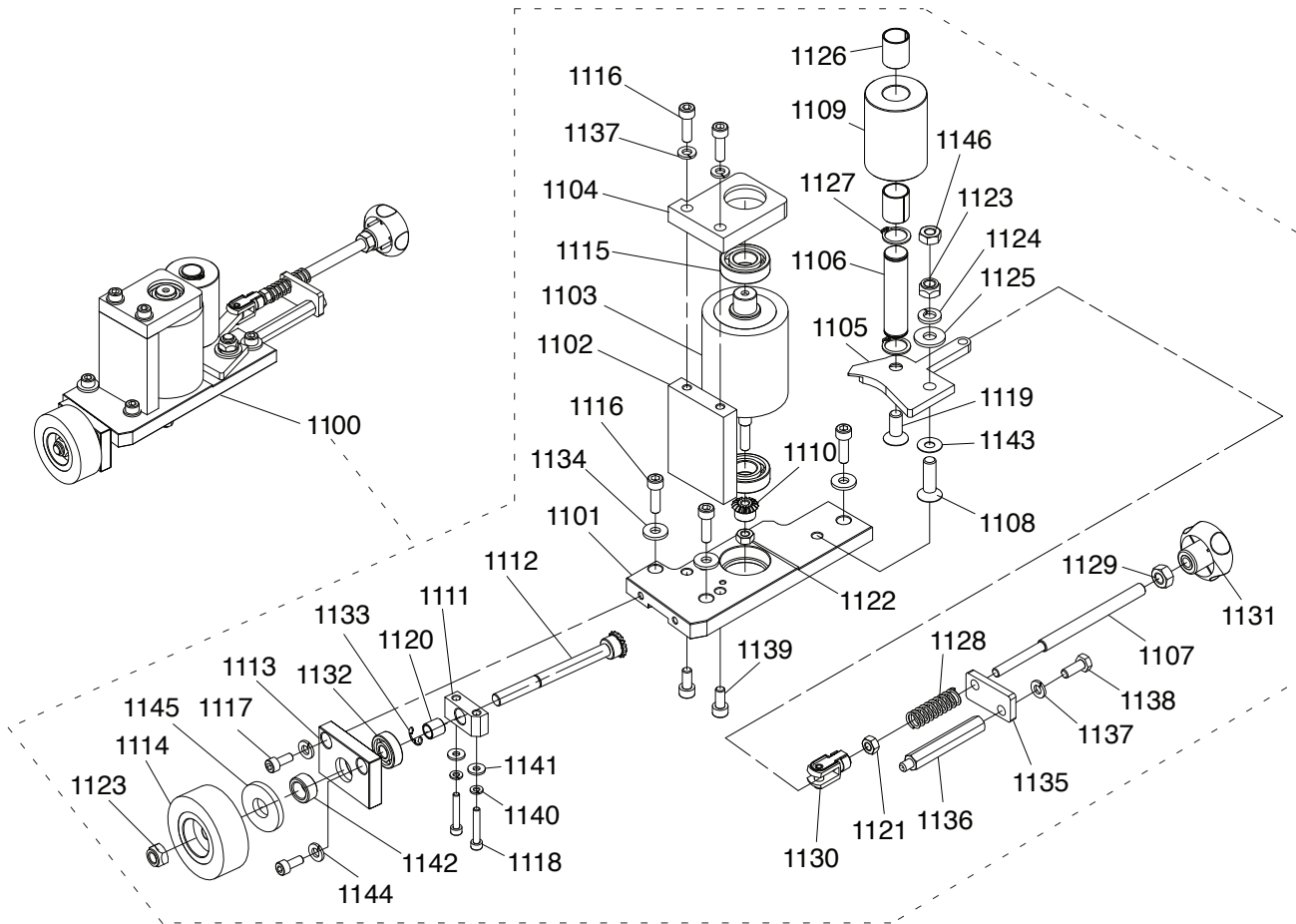


REF	PART #	DESCRIPTION
1000	P07741000	HEATED FENCE ASSEMBLY
1001	P07741001	FENCE MOUNTING PLATE
1002	P07741002	LIMIT BLOCK
1003	P07741003	FENCE SLIDER
1004	P07741004	SLIDER BLOCK
1005	P07741005	HEATED FENCE
1006	P07741006	STUD-DE M8-1.25 X 160, 10
1007	P07741007	ECCENTRIC KNURLED CYCLINDER
1008	P07741008	HEATED FENCE COVER
1009	P07741009	HEATING ELEMENT
1010	P07741010	HEX BOLT M8-1.25 X 12

REF	PART #	DESCRIPTION
1011	P07741011	FLAT WASHER 8MM
1012	P07741012	CAP SCREW M8-1.25 X 55
1013	P07741013	FLANGE BOLT M5-.8 X 10
1014	P07741014	LOCK WASHER 8MM
1015	P07741015	CAP SCREW M5-.8 X 12
1016	P07741016	CAP SCREW M6-1 X 35
1017	P07741017	LOCK WASHER 5MM
1018	P07741018	LOCK WASHER 6MM
1019	P07741019	CAP SCREW M6-1 X 20
1020	P07741020	ADJUSTABLE HANDLE M8-1.25, 82L
1021	P07741021	FENDER WASHER 8 X 30 X 3MM



Edgebanding Feeder

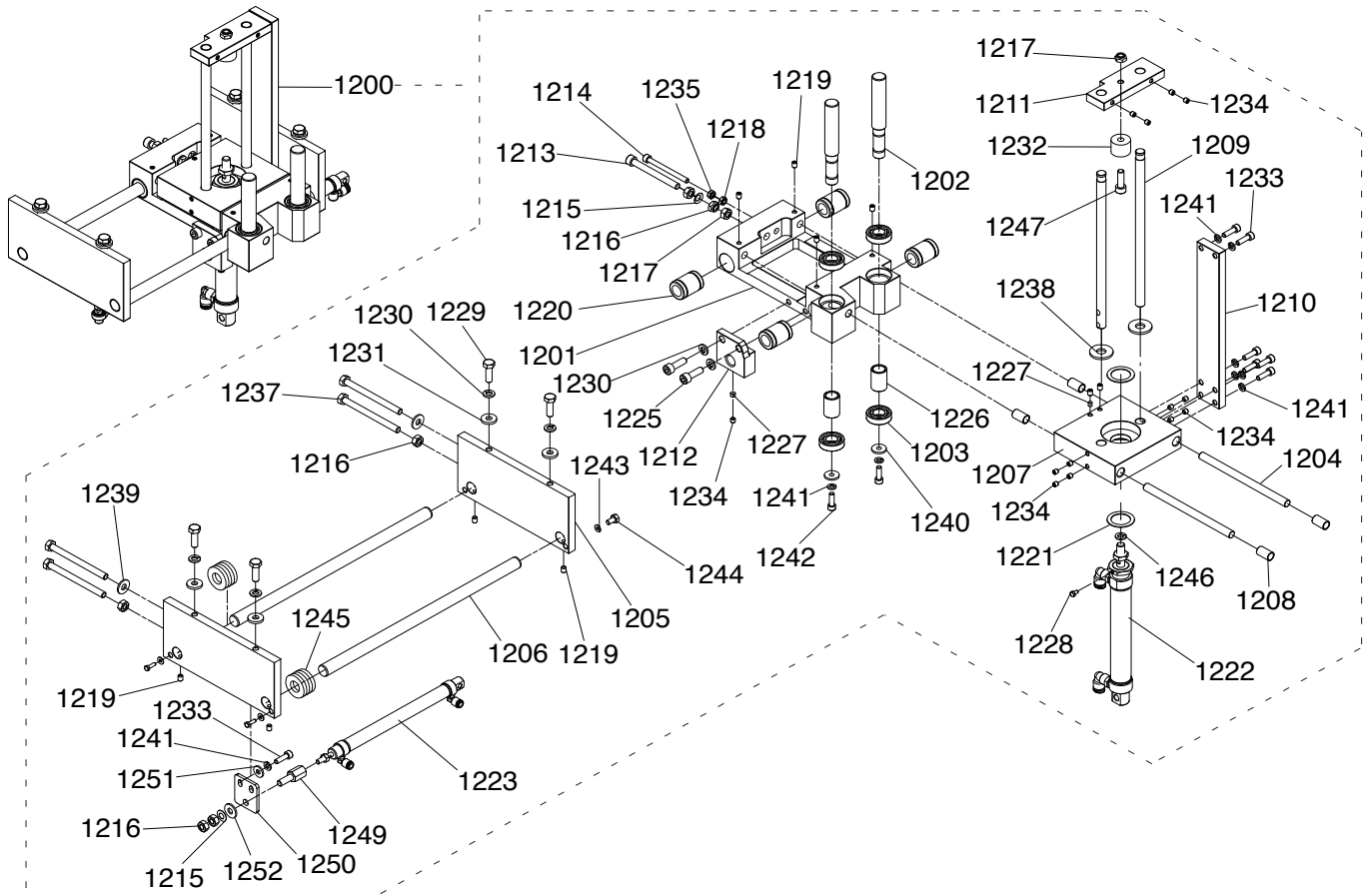


REF	PART #	DESCRIPTION
1100	P07741100	EDGEBOARDING FEEDER ASSEMBLY
1101	P07741101	ROLLER BASE PLATE
1102	P07741102	VERTICAL PLATE
1103	P07741103	PRESSURE WHEEL
1104	P07741104	BEARING PLATE (UPPER)
1105	P07741105	TENSION WHEEL BASE PLATE
1106	P07741106	WHEEL SHAFT
1107	P07741107	STUD-DE M8-1.25 X 30, 82L
1108	P07741108	FLAT HD CAP SCR M8-1.25 X 40
1109	P07741109	TENSION WHEEL 40 X 60MM PLASTIC
1110	P07741110	GEAR
1111	P07741111	FIXED BRACKET
1112	P07741112	WHEEL SHAFT W/GEAR
1113	P07741113	BEARING PLATE (LOWER)
1114	P07741114	WHEEL 55MM, RUBBER
1115	P07741115	BALL BEARING 6002-2RS
1116	P07741116	CAP SCREW M6-1 X 20
1117	P07741117	CAP SCREW M5-.8 X 12
1118	P07741118	CAP SCREW M4-.7 X 25
1119	P07741119	FLAT HD CAP SCR M8-1.25 X 20
1120	P07741120	SELF-LUBE BEARING DU0810
1121	P07741121	HEX NUT M6-1
1122	P07741122	HEX NUT M6-1 LH
1123	P07741123	HEX NUT M8-1.25

REF	PART #	DESCRIPTION
1124	P07741124	LOCK WASHER 8MM
1125	P07741125	FLAT WASHER 8MM
1126	P07741126	SELF-LUBE BEARING DU1520
1127	P07741127	EXT RETAINING RING 15MM
1128	P07741128	COMPRESSION SPRING 1.6 X 12 X 22
1129	P07741129	HEX NUT M8-1.25
1130	P07741130	CLEVIS ROD END
1131	P07741131	KNOB 4-LOBE M8-1.25
1132	P07741132	BALL BEARING 608ZZ
1133	P07741133	E-CLIP 7MM
1134	P07741134	FLAT WASHER 6MM
1135	P07741135	CONNECTOR PLATE
1136	P07741136	STAND-OFF HEX M6-1 X 52, 60L
1137	P07741137	LOCK WASHER 6MM
1138	P07741138	HEX BOLT M6-1 X 16
1139	P07741139	CAP SCREW M6-1 X 12
1140	P07741140	LOCK WASHER 4MM
1141	P07741141	FLAT WASHER 4MM
1142	P07741142	WHEEL BUSHING
1143	P07741143	FLAT WASHER 10MM
1144	P07741144	LOCK WASHER 5MM
1145	P07741145	FENDER WASHER 8 X 23 X 2MM
1146	P07741146	HEX NUT M8-1.25



End Trimmer Carriage

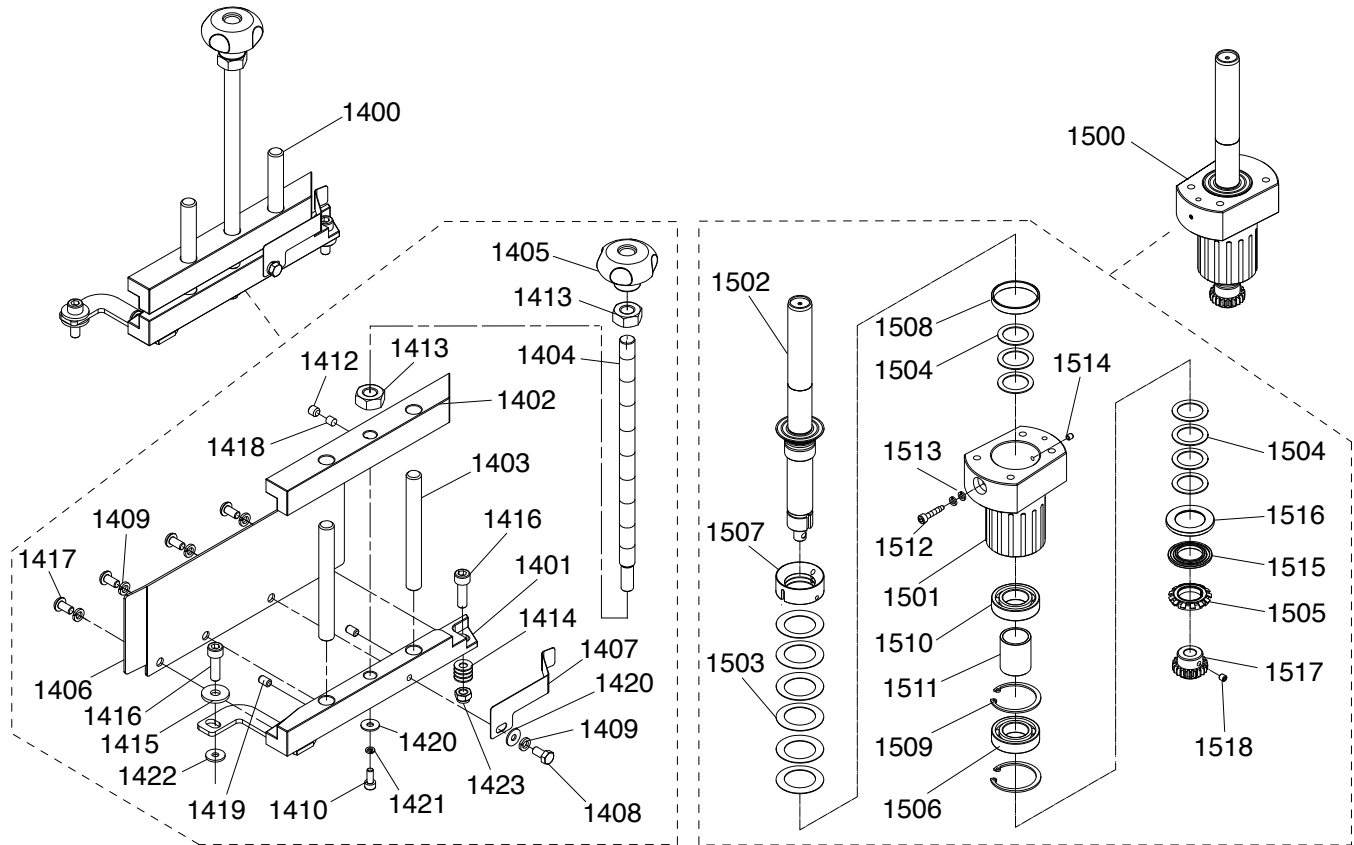


REF	PART #	DESCRIPTION
1200	P07741200	END TRIMMER CARRIAGE ASSEMBLY
1201	P07741201	BASE
1202	P07741202	VERTICAL ROD 18 X 128L
1203	P07741203	BALL BEARING 6002LLU
1204	P07741204	HORIZONTAL ROD 10 X 155L
1205	P07741205	GUIDE PLATE
1206	P07741206	HORIZONTAL ROD 16 X 350L
1207	P07741207	LIFTING BLOCK
1208	P07741208	SELF-LUBE BEARING DU1020
1209	P07741209	VERTICAL ROD 12 X 246.5L
1210	P07741210	VERTICAL PLATE
1211	P07741211	TOP PLATE
1212	P07741212	CYLINDER FIXED BLOCK
1213	P07741213	CAP SCREW M8-1.25 X 80
1214	P07741214	CAP SCREW M6-1 X 70
1215	P07741215	BELLEVILLE WASHER 8 X 15MM
1216	P07741216	HEX NUT M8-1.25
1217	P07741217	LOCK NUT M8-1.25
1218	P07741218	LOCK NUT M6-1
1219	P07741219	SET SCREW M6-1 X 8
1220	P07741220	LINEAR BEARING LME16
1221	P07741221	FLAT WASHER 25 X 35 X 1
1222	P07741222	VERTICAL AIR CYLINDER SMC-25M100
1223	P07741223	HORIZONTAL AIR CYLINDER SMC-16N150
1225	P07741225	CAP SCREW M8-1.25 X 20

REF	PART #	DESCRIPTION
1226	P07741226	SPACER 20 X 30L
1227	P07741227	ABS STRIP 4 X 5L
1228	P07741228	HEX BOLT M4-.7 X 6
1229	P07741229	HEX BOLT M8-1.25 X 25
1230	P07741230	LOCK WASHER 8MM
1231	P07741231	FLAT WASHER 8MM
1232	P07741232	CYLINDER BLOCK 25 X 19L
1233	P07741233	CAP SCREW M6-1 X 20
1234	P07741234	SET SCREW M6-1 X 6
1235	P07741235	HEX NUT M6-1
1237	P07741237	HEX BOLT M8-1.25 X 80
1238	P07741238	SPACER
1239	P07741239	FLAT WASHER 8MM
1240	P07741240	FLAT WASHER 6MM
1241	P07741241	LOCK WASHER 6MM
1242	P07741242	CAP SCREW M6-1 X 16
1243	P07741243	FLAT WASHER 5MM
1244	P07741244	HEX BOLT M5-.8 X 10
1245	P07741245	BUFFER BLOCK
1246	P07741246	LOCK WASHER 10MM
1247	P07741247	BUTTON HD CAP SCR M8-1.25 X 30
1249	P07741249	CONNECTING ROD
1250	P07741250	CYLINDER PLATE
1251	P07741251	FLAT WASHER 6MM
1252	P07741252	FLAT WASHER 8MM



Vertical Edgebanding Guide & Glue Spindle

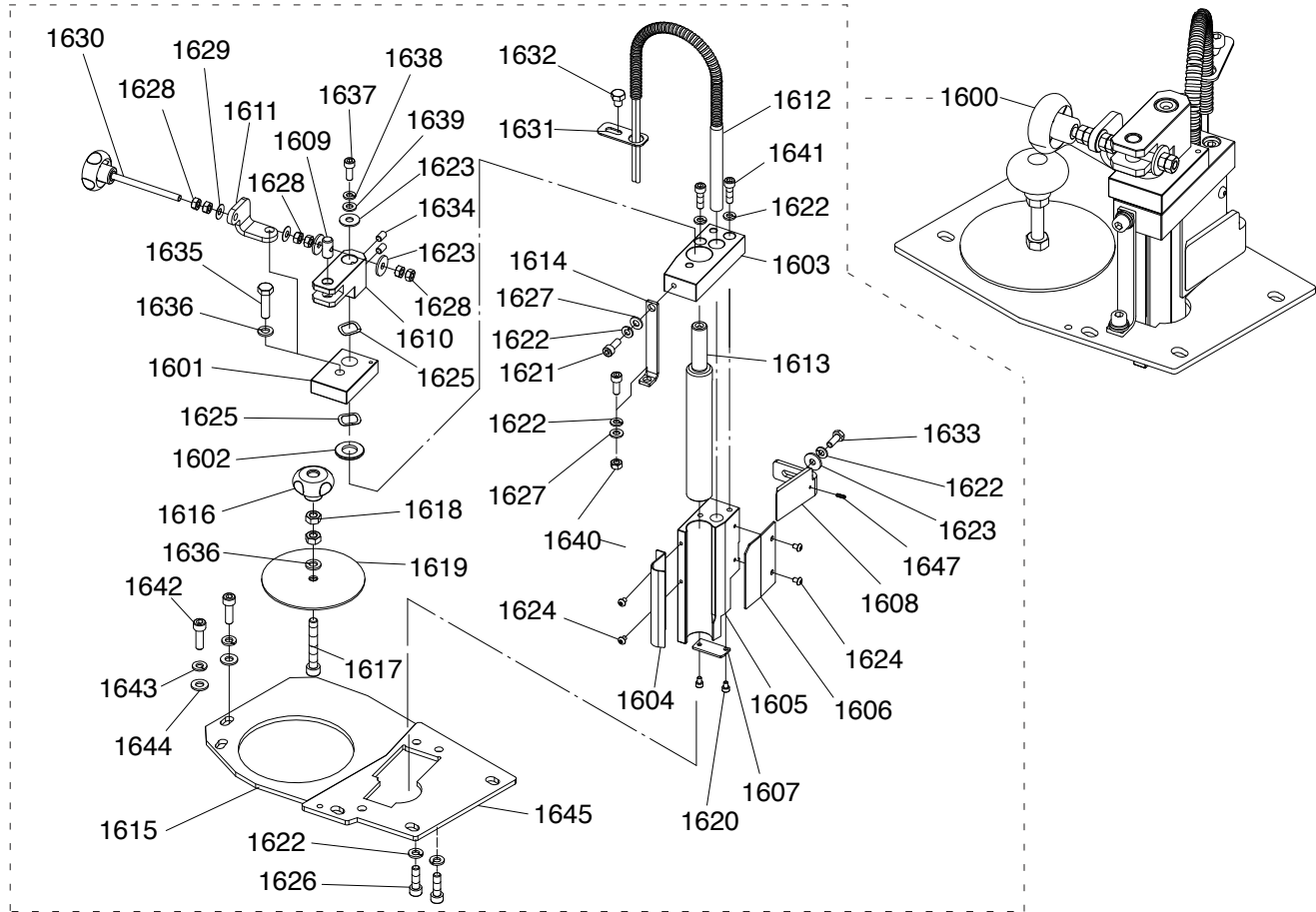


REF	PART #	DESCRIPTION
1400	P07741400	VERTICAL EDGEBANDING GUIDE ASSY
1401	P07741401	EDGE BAND SEAT (LOWER)
1402	P07741402	EDGE BAND SEAT (UPPER)
1403	P07741403	VERTICAL ROD 10 X 90L
1404	P07741404	SET SCREW M10-1.5 X 190
1405	P07741405	KNOB 4-LOBE M10-1.5
1406	P07741406	PROTECTION PLATE
1407	P07741407	SPRING PLATE
1408	P07741408	HEX BOLT M5-.8 X 10
1409	P07741409	LOCK WASHER 5MM
1410	P07741410	BUTTON HD CAP SCR M4-.7 X 10
1412	P07741412	SET SCREW M6-1 X 6
1413	P07741413	HEX NUT M10-1.5
1414	P07741414	FLAT WASHER 6 X 15 X .5MM
1415	P07741415	FENDER WASHER 6MM
1416	P07741416	CAP SCREW M6-1 X 20
1417	P07741417	BUTTON HD CAP SCR M5-.8 X 10
1418	P07741418	ABS STRIP 4 X 5L
1419	P07741419	SET SCREW M5-.8 X 8
1420	P07741420	FLAT WASHER 4MM
1421	P07741421	LOCK WASHER 4MM

REF	PART #	DESCRIPTION
1422	P07741422	FLAT WASHER 6MM
1423	P07741423	LOCK WASHER 6MM
1500	P07741500	GLUE SPINDLE ASSEMBLY
1501	P07741501	GLUE SPINDLE BASE
1502	P07741502	GLUE SPINDLE
1503	P07741503	SPACER
1504	P07741504	FLAT WASHER 25 X 35 X 1MM
1505	P07741505	SPANNER NUT W/ BEARING LOCK WASHER
1506	P07741506	BALL BEARING 6005ZZ
1507	P07741507	BUSHING
1508	P07741508	COLLAR
1509	P07741509	INT RETAINING RING 47MM
1510	P07741510	BALL BEARING 6005ZZ
1511	P07741511	BUSHING
1512	P07741512	CAP SCREW M6-1 X 25
1513	P07741513	LOCK WASHER 5MM
1514	P07741514	SET SCREW M5-.8 X 6
1515	P07741515	INTERNAL GASKET
1516	P07741516	EXTERNAL GASKET
1517	P07741517	GEAR 21T
1518	P07741518	SET SCREW M6-1 X 8



Glue Pot Cover

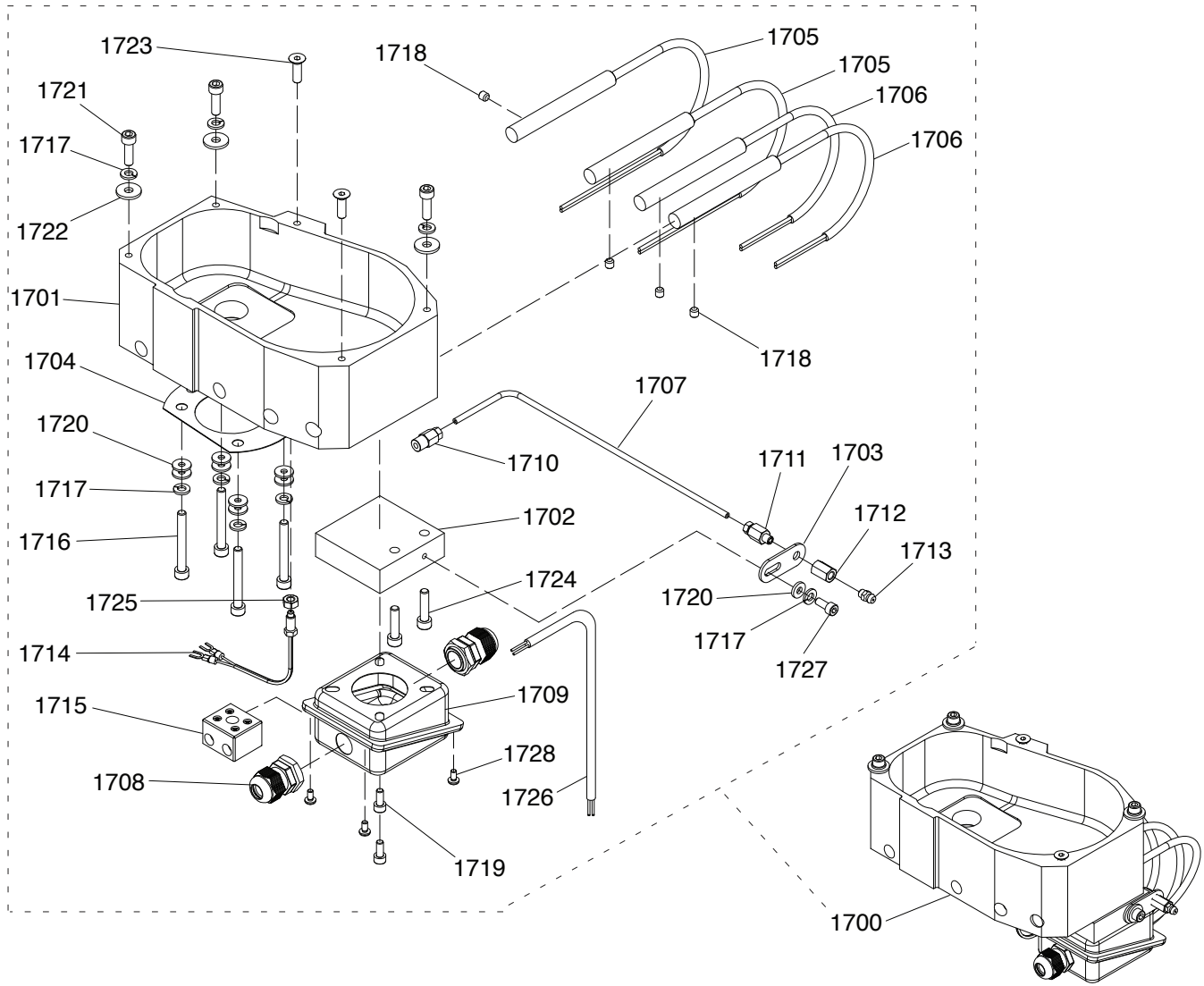


REF	PART #	DESCRIPTION
1600	P07741600	GLUE POT COVER ASSEMBLY
1601	P07741601	ADJUSTMENT BLOCK SPACER
1602	P07741602	SPACER
1603	P07741603	LOCATE BLOCK
1604	P07741604	FRONT COVER PLATE
1605	P07741605	BASE
1606	P07741606	SIDE COVER PLATE
1607	P07741607	BOTTOM COVER PLATE
1608	P07741608	GUIDE PLATE
1609	P07741609	BLOCK PIN
1610	P07741610	ADJUSTMENT BLOCK
1611	P07741611	SUPPORT PLATE
1612	P07741612	GLUE POT HEATING ELEMENT
1613	P07741613	ROTATION SHAFT
1614	P07741614	BRACKET
1615	P07741615	GLUE POT COVER (UPPER)
1616	P07741616	KNOB 4-LOBE M8-1.25
1617	P07741617	CAP SCREW M8-1.25 X 55
1618	P07741618	HEX NUT M8-1.25
1619	P07741619	GLUE POT LID
1620	P07741620	CAP SCREW M4-.7 X 6
1621	P07741621	CAP SCREW M6-1 X 16
1622	P07741622	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
1623	P07741623	FENDER WASHER 6 X 19 X 2
1624	P07741624	BUTTON HD CAP SCR M4-.7 X 6
1625	P07741625	WAVY WASHER 15 X 22MM
1626	P07741626	CAP SCREW M6-1 X 12
1627	P07741627	FLAT WASHER 6MM
1628	P07741628	HEX NUT M6-1
1629	P07741629	BELLEVILLE LOCK WASHER 6MM
1630	P07741630	KNOB BOLT 4-LOBE M6-1 X 75
1631	P07741631	HEAT ROD MOUNTING PLATE
1632	P07741632	FLANGE BOLT M6-1 X 8
1633	P07741633	HEX BOLT M6-1 X 16
1634	P07741634	SET SCREW M6-1 X 8
1635	P07741635	HEX BOLT M8-1.25 X 30
1636	P07741636	LOCK WASHER 8MM
1637	P07741637	CAP SCREW M5-.8 X 16
1638	P07741638	LOCK WASHER 5MM
1639	P07741639	FLAT WASHER 5MM
1640	P07741640	FLANGE NUT M6-1
1641	P07741641	CAP SCREW M6-1 X 20
1642	P07741642	CAP SCREW M6-1 X 20
1643	P07741643	LOCK WASHER 6MM
1644	P07741644	FLAT WASHER 6MM
1645	P07741645	HEAT ELEMENT BRACKET



Glue Pot

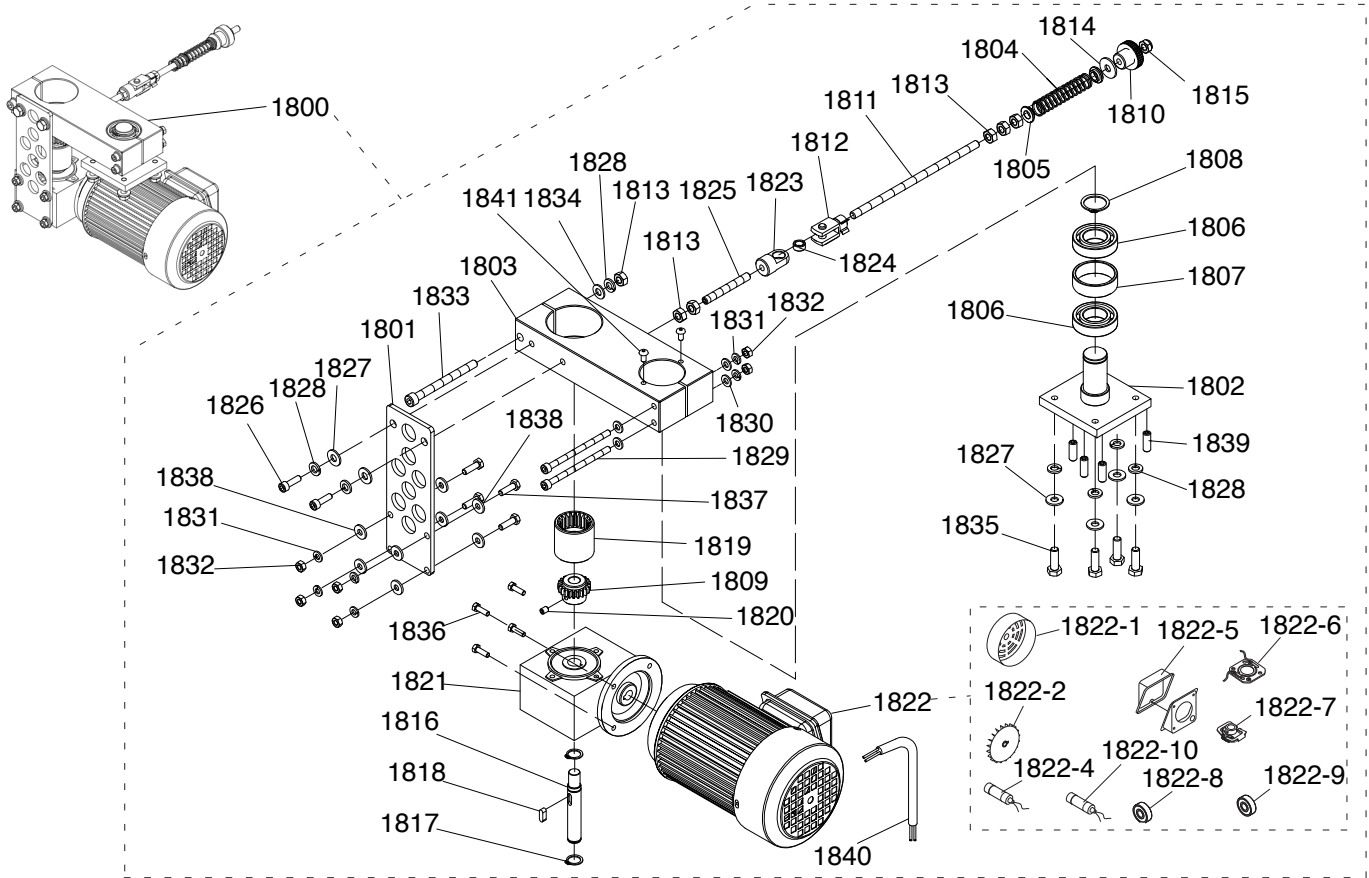


REF	PART #	DESCRIPTION
1700	P07741700	GLUE POT ASSEMBLY
1701	P07741701	GLUE POT
1702	P07741702	ELECTRIC ELEMENT
1703	P07741703	TUBING BRACKET
1704	P07741704	GLUE POT GASKET
1705	P07741705	HEATING ELEMENT 220V 160W
1706	P07741706	HEATING ELEMENT 220V 250W
1707	P07741707	BRASS TUBING 300 X 4MM
1708	P07741708	STRAIN RELIEF TYPE-1 PG11
1709	P07741709	JUNCTION BOX
1710	P07741710	CONNECTOR 1/4" ID BRASS FEMALE
1711	P07741711	CONNECTOR 1/4" ID BRASS MALE
1712	P07741712	GREASE ADAPTER
1713	P07741713	GREASE FITTING M6-1.0 STRAIGHT
1714	P07741714	THERMOCOUPLE W/ WIRES

REF	PART #	DESCRIPTION
1715	P07741715	CERAMIC TERMINAL BLOCK
1716	P07741716	CAP SCREW M6-1 X 50
1717	P07741717	LOCK WASHER 6MM
1718	P07741718	SET SCREW M6-1 X 6
1719	P07741719	CAP SCREW M5-.8 X 12
1720	P07741720	BELLEVILLE LOCK WASHER 6MM
1721	P07741721	CAP SCREW M6-1 X 20
1722	P07741722	FLAT WASHER 6MM
1723	P07741723	FLAT HD CAP SCR M6-1 X 20
1724	P07741724	CAP SCREW M6-1 X 25
1725	P07741725	HEX NUT 1/4-20
1726	P07741726	CORD 14G 2W 16"
1727	P07741727	CAP SCREW M6-1 X 12
1728	P07741728	BUTTON HD CAP SCR M4-.7 X 8



Glue Spindle Motor

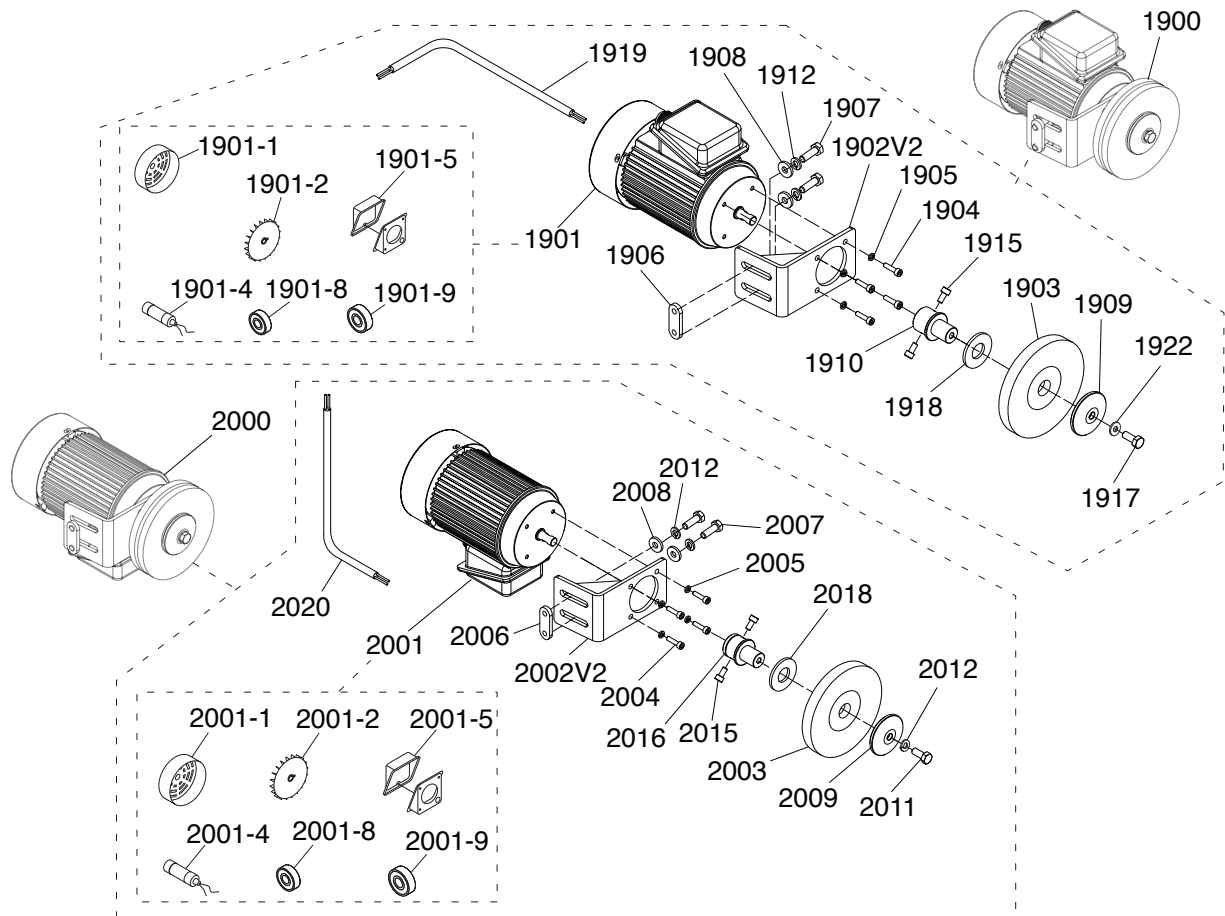


REF	PART #	DESCRIPTION
1800	P07741800	GLUE SPINDLE MOTOR ASSEMBLY
1801	P07741801	REDUCER CONNECTION PLATE
1802	P07741802	SPINDLE BRACKET
1803	P07741803	REDUCER BRACKET
1804	P07741804	COMPRESSION SPRING 1.7 X 18 X 45
1805	P07741805	GASKET
1806	P07741806	BALL BEARING 6005ZZ
1807	P07741807	BEARING RING
1808	P07741808	EXT RETAINING RING 25MM
1809	P07741809	GEAR 21T
1810	P07741810	KNOB M8-1.25, 30MM OD
1811	P07741811	STUD-FT M8-1.25 X 180
1812	P07741812	CLEVIS ROD-END
1813	P07741813	HEX NUT M8-1.25
1814	P07741814	FENDER WASHER 8 X 23 X 2MM
1815	P07741815	LOCK NUT M8-1.25
1816	P07741816	KEYED SHAFT
1817	P07741817	EXT RETAINING RING 14MM
1818	P07741818	KEY 5 X 5 X 15
1819	P07741819	GEAR CONNECTION SHAFT
1820	P07741820	SET SCREW M6-1 X 8
1821	P07741821	GEAR REDUCER
1822	P07741822	MOTOR 1/3HP 220V 1-PH (GLUE SPINDLE)
1822-1	P07741822-1	MOTOR FAN COVER
1822-2	P07741822-2	MOTOR FAN
1822-4	P07741822-4	R CAPACITOR 20MFD 250V

REF	PART #	DESCRIPTION
1822-5	P07741822-5	MOTOR JUNCTION BOX
1822-6	P07741822-6	CONTACT PLATE
1822-7	P07741822-7	CENTRIFUGAL SWITCH
1822-8	P07741822-8	BALL BEARING 6203ZZ (FRONT)
1822-9	P07741822-9	BALL BEARING 6202ZZ (REAR)
1822-10	P07741822-10	S CAPACITOR 100MFD 250V
1823	P07741823	CLEVIS ROD-END
1824	P07741824	BUSHING
1825	P07741825	SET SCREW M8-1.25 X 65
1826	P07741826	CAP SCREW M8-1.25 X 20
1827	P07741827	FLAT WASHER 8MM
1828	P07741828	LOCK WASHER 8MM
1829	P07741829	CAP SCREW M6-1 X 90
1830	P07741830	FLAT WASHER 6MM
1831	P07741831	LOCK WASHER 6MM
1832	P07741832	HEX NUT M6-1
1833	P07741833	CAP SCREW M8-1.25 X 90
1834	P07741834	FLAT WASHER 8MM
1835	P07741835	HEX BOLT M8-1.25 X 30
1836	P07741836	HEX BOLT M5-.8 X 12
1837	P07741837	HEX BOLT M6-1 X 20
1838	P07741838	FLAT WASHER 6MM
1839	P07741839	SET SCREW M8-1.25 X 16
1840	P07741840	MOTOR CORD 16G 3W 18"
1841	P07741841	BUTTON HD CAP SCR M6-1 X 8



Upper & Lower Buffing Motors

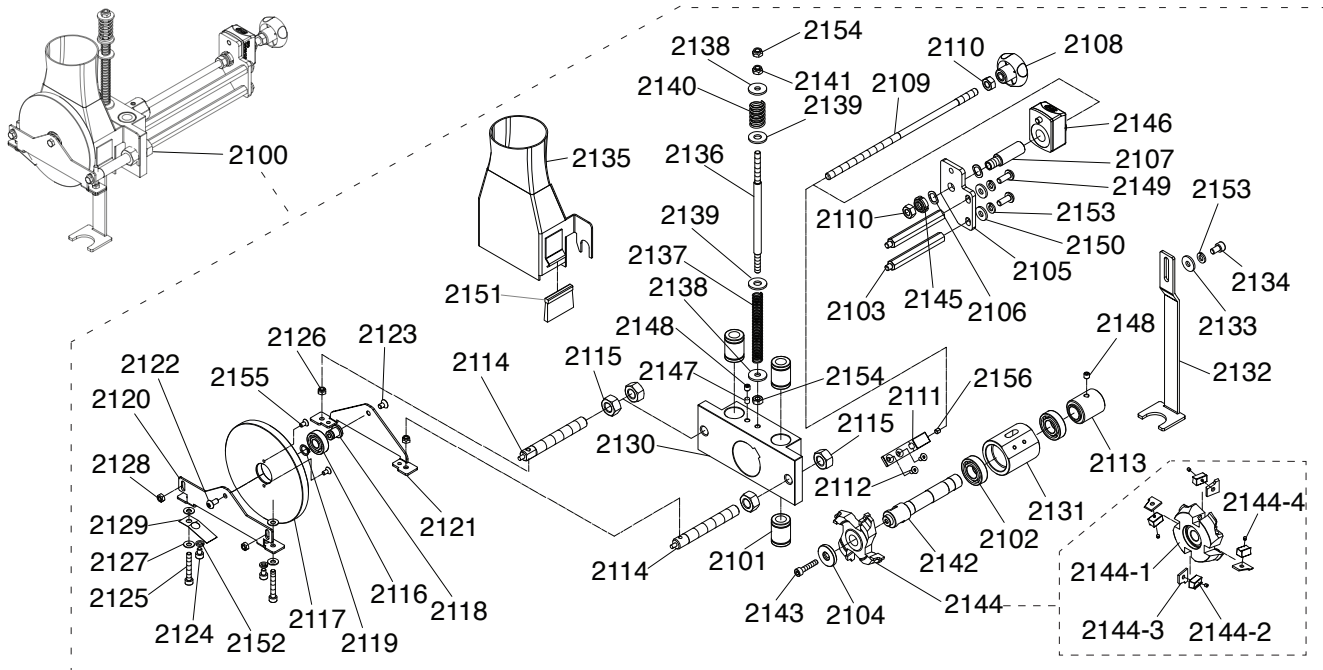


REF	PART #	DESCRIPTION
1900	P07741900	UPPER BUFFING MOTOR ASSEMBLY
1901	P07741901	MOTOR 1/4HP 220V 1-PH (UPPER BUFF)
1901-1	P07741901-1	MOTOR FAN COVER
1901-2	P07741901-2	MOTOR FAN
1901-4	P07741901-4	R CAPACITOR 5M 500V 1-1/2" X 2"
1901-5	P07741901-5	MOTOR JUNCTION BOX
1901-8	P07741901-8	BALL BEARING 6202ZZ (FRONT)
1901-9	P07741901-9	BALL BEARING 6200ZZ (REAR)
1902V2	P07741902V2	MOTOR MOUNTING PLATE V2.01.21
1903	P07741903	BUFFING WHEEL 5 X 1/2 X 3/4
1904	P07741904	CAP SCREW M5-.8 X 16
1905	P07741905	LOCK WASHER 5MM
1906	P07741906	BOLT PLATE
1907	P07741907	HEX BOLT M8-1.25 X 25
1908	P07741908	FLAT WASHER 8MM
1909	P07741909	WHEEL FLANGE
1910	P07741910	SPINDLE (UPPER)
1912	P07741912	LOCK WASHER 8MM
1915	P07741915	CAP SCREW M6-1 X 12
1917	P07741917	HEX BOLT M8-1.25 X 20 LH
1918	P07741918	FLAT WASHER 22 X 55 X 3MM
1919	P07741919	MOTOR CORD 16G 3W 36"
1922	P07741922	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
2000	P07742000	LOWER BUFFING MOTOR ASSEMBLY
2001	P07742001	MOTOR 1/4HP 220V 1-PH (LOWER BUFF)
2001-1	P07742001-1	MOTOR FAN COVER
2001-2	P07742001-2	MOTOR FAN
2001-4	P07742001-4	R CAPACITOR 5M 500V 1-1/2" X 2"
2001-5	P07742001-5	MOTOR JUNCTION BOX
2001-8	P07742001-8	BALL BEARING 6202ZZ (FRONT)
2001-9	P07742001-9	BALL BEARING 6200ZZ (REAR)
2002V2	P07742002V2	MOTOR MOUNTING PLATE V2.01.21
2003	P07742003	BUFFING WHEEL 5 X 1/2 X 3/4
2004	P07742004	CAP SCREW M5-.8 X 16
2005	P07742005	LOCK WASHER 5MM
2006	P07742006	BOLT PLATE
2007	P07742007	HEX BOLT M8-1.25 X 25
2008	P07742008	FLAT WASHER 8MM
2009	P07742009	WHEEL FLANGE
2011	P07742011	HEX BOLT M8-1.25 X 20
2012	P07742012	LOCK WASHER 8MM
2015	P07742015	CAP SCREW M6-1 X 12
2016	P07742016	SPINDLE (LOWER)
2018	P07742018	FLAT WASHER 22 X 55 X 3MM
2020	P07742020	MOTOR CORD 16G 3W 24"



Upper Flush Trimmer

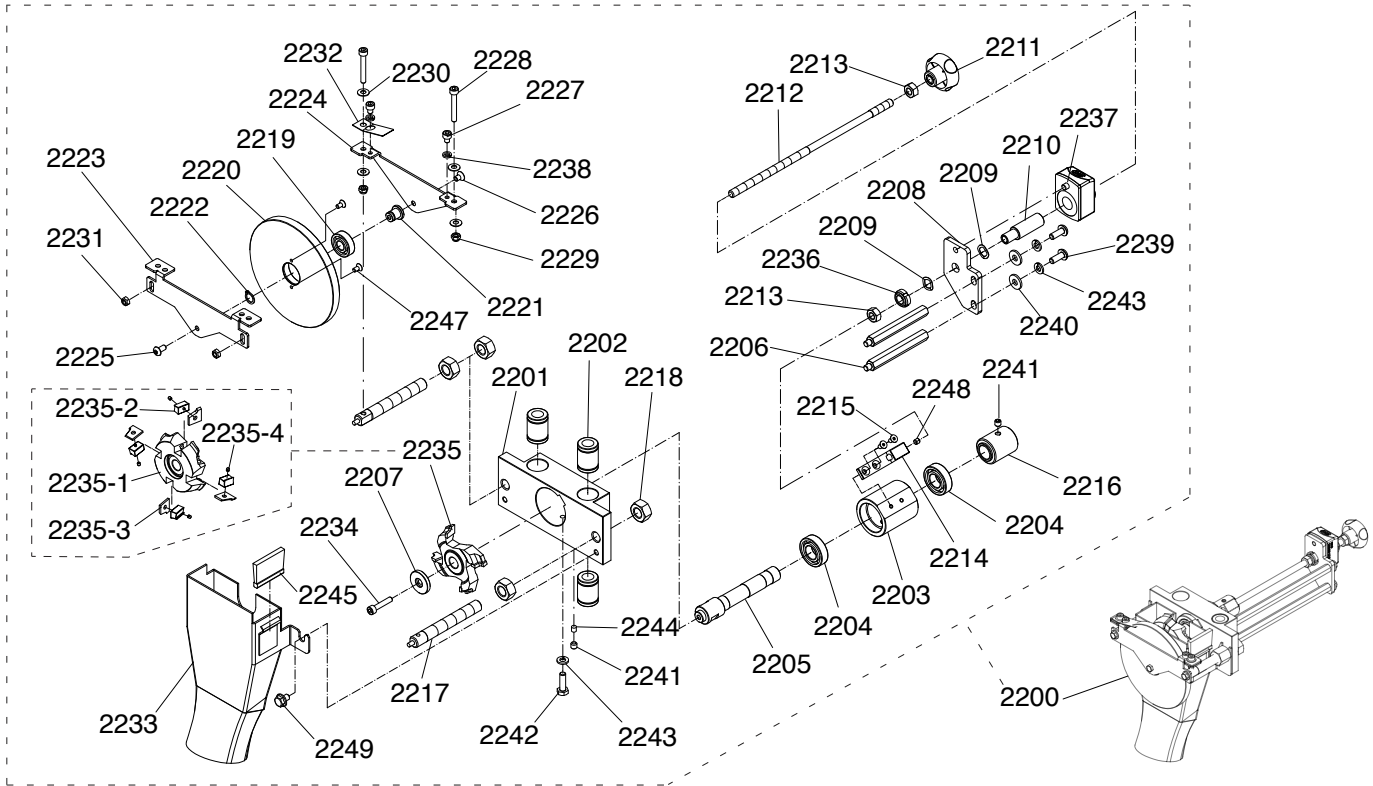


REF	PART #	DESCRIPTION
2100	P07742100	UPPER FLUSH TRIMMER ASSEMBLY
2101	P07742101	LINEAR BEARING LM12
2102	P07742102	BALL BEARING 6002LLB
2103	P07742103	STAND-OFF HEX 61.5MM
2104	P07742104	SPINDLE SPACER
2105	P07742105	MOUNTING PLATE
2106	P07742106	WAVY WASHER 8MM
2107	P07742107	ADAPTER SHAFT M8-1.25
2108	P07742108	KNOB 4-LOBE M8-1.25
2109	P07742109	STUD-FT M8-1.25 X 125
2110	P07742110	HEX NUT M8-1.25
2111	P07742111	CONNECTION PLATE
2112	P07742112	FLAT HD CAP SCR M4-.7 X 8
2113	P07742113	FLAT PULLEY
2114	P07742114	THREADED ROD M12-1.75 X 104
2115	P07742115	HEX NUT M12-1.75
2116	P07742116	BALL BEARING 6000LLB
2117	P07742117	PROFILING WHEEL
2118	P07742118	WHEEL SPINDLE
2119	P07742119	EXT RETAINING RING 10MM
2120	P07742120	WHEEL MOUNTING PLATE (OUTER)
2121	P07742121	WHEEL MOUNTING PLATE (INNER)
2122	P07742122	BUTTON HD CAP SCR M5-.8 X 8
2123	P07742123	FLAT HD CAP SCR M5-.8 X 8
2124	P07742124	CAP SCREW M5-.8 X 10
2125	P07742125	CAP SCREW M5-.8 X 30
2126	P07742126	LOCK NUT M5-.8
2127	P07742127	BELLEVILLE LOCK WASHER 5MM
2128	P07742128	HEX NUT M5-.8
2129	P07742129	SPRING PLATE
2130	P07742130	MOUNTING BLOCK

REF	PART #	DESCRIPTION
2131	P07742131	BEARING COLLAR (UPPER)
2132	P07742132	ADJUSTMENT BRACKET
2133	P07742133	FENDER WASHER 6MM
2134	P07742134	CAP SCREW M6-1 X 12
2135	P07742135	DUST COVER
2136	P07742136	STUD-DE M6-1
2137	P07742137	COMPRESSION SPRING 1 X 12 X 46
2138	P07742138	FENDER WASHER 6MM
2139	P07742139	FENDER WASHER 6MM
2140	P07742140	COMPRESSION SPRING 1.5 X 17 X 22
2141	P07742141	LOCK NUT M6-1
2142	P07742142	FLUSH TRIMMER SPINDLE (UPPER)
2143	P07742143	CAP SCREW M5-.8 X 20
2144	P07742144	FLUSH TRIMMER ASSEMBLY (UPPER)
2144-1	P07742144-1	FLUSH TRIMMER CUTTERHEAD (UPPER)
2144-2	P07742144-2	CUTTERHEAD BLOCK (UPPER)
2144-3	P07742144-3	CUTTERHEAD KNIFE (UPPER)
2144-4	P07742144-4	SET SCREW M6-1 X 16 DOG-PT
2145	P07742145	SPANNER NUT M10-.75
2146	P07742146	POSITION COUNTER
2147	P07742147	ABS STRIPS 4 X 5L
2148	P07742148	SET SCREW M6-1 X 6
2149	P07742149	CAP SCREW M6-1 X 16
2150	P07742150	FENDER WASHER 6MM
2151	P07742151	DUST COVER BRUSH
2152	P07742152	LOCK WASHER 5MM
2153	P07742153	LOCK WASHER 6MM
2154	P07742154	HEX NUT M6-1
2155	P07742155	FLAT HD CAP SCR M4-.7 X 8
2156	P07742156	SET SCREW M5-.8 X 8



Lower Flush Trimmer

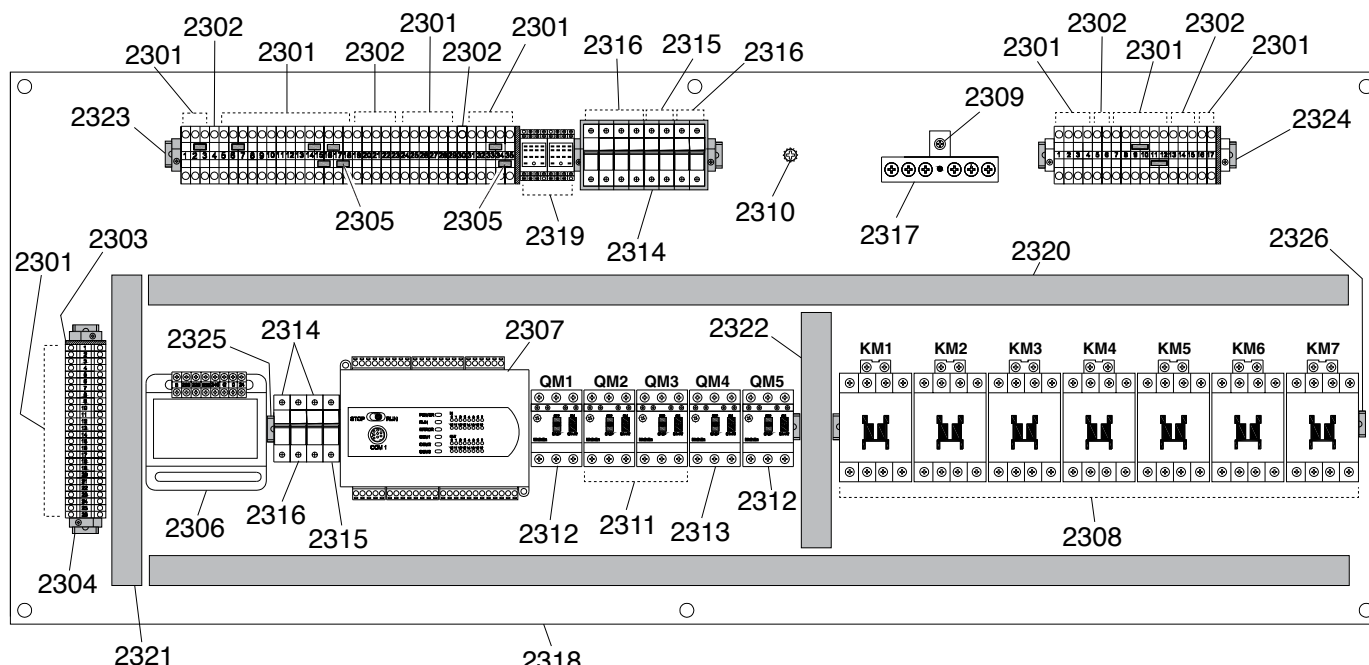


REF	PART #	DESCRIPTION
2200	P07742200	LOWER FLUSH TRIMMER ASSEMBLY
2201	P07742201	LOWER MOUNTING BLOCK
2202	P07742202	LINEAR BEARING LM12
2203	P07742203	BEARING COLLAR (LOWER)
2204	P07742204	BALL BEARING 6002LLB
2205	P07742205	FLUSH TRIMMER SPINDLE (LOWER)
2206	P07742206	STAND-OFF HEX 61.5MM
2207	P07742207	SPINDLE SPACER
2208	P07742208	MOUNTING PLATE
2209	P07742209	WAVY WASHER 8MM
2210	P07742210	ADAPTER SHAFT
2211	P07742211	KNOB 4-LOBE M8-1.25
2212	P07742212	STUD-FT M8-1.25 X 125
2213	P07742213	HEX NUT M8-1.25
2214	P07742214	CONNECTION PLATE
2215	P07742215	FLAT HD CAP SCR M4-.7 X 8
2216	P07742216	FLAT PULLEY
2217	P07742217	THREADED ROD M12-1.75 X 104
2218	P07742218	HEX NUT M12-1.75
2219	P07742219	BALL BEARING 6000LLB
2220	P07742220	PROFILING WHEEL
2221	P07742221	WHEEL SPINDLE
2222	P07742222	EXT RETAINING RING 10MM
2223	P07742223	WHEEL MOUNTING PLATE (OUTER)
2224	P07742224	WHEEL MOUNTING PLATE (INNER)
2225	P07742225	BUTTON HD CAP SCR M5-.8 X 8
2226	P07742226	FLAT HD CAP SCR M5-.8 X 8

REF	PART #	DESCRIPTION
2227	P07742227	CAP SCREW M5-.8 X 10
2228	P07742228	CAP SCREW M5-.8 X 30
2229	P07742229	LOCK NUT M5-.8
2230	P07742230	BELLEVILLE LOCK WASHER 5.2 X 12 X .6MM
2231	P07742231	HEX NUT M5-.8
2232	P07742232	SPRING PLATE
2233	P07742233	DUST COVER
2234	P07742234	CAP SCREW M5-.8 X 16 LH
2235	P07742235	FLUSH TRIMMER ASSEMBLY (LOWER)
2235-1	P07742235-1	FLUSH TRIMMER CUTTERHEAD (LOWER)
2235-2	P07742235-2	CUTTERHEAD BLOCK (LOWER)
2235-3	P07742235-3	CUTTERHEAD KNIFE (LOWER)
2235-4	P07742235-4	SET SCREW M6-1 X 16 DOG-PT
2236	P07742236	SPANNER NUT M10-.75
2237	P07742237	POSITION COUNTER
2238	P07742238	LOCK WASHER 5MM
2239	P07742239	CAP SCREW M6-1 X 16
2240	P07742240	FENDER WASHER 6MM
2241	P07742241	SET SCREW M6-1 X 6
2242	P07742242	CAP SCREW M6-1 X 20
2243	P07742243	LOCK WASHER 6MM
2244	P07742244	ABS STRIP
2245	P07742245	DUST COVER BRUSH
2247	P07742247	FLAT HD CAP SCR M4-.7 X 8
2248	P07742248	SET SCREW M5-.8 X 8
2249	P07742249	FLANGE BOLT M6-1 X 12



Electrical Panel

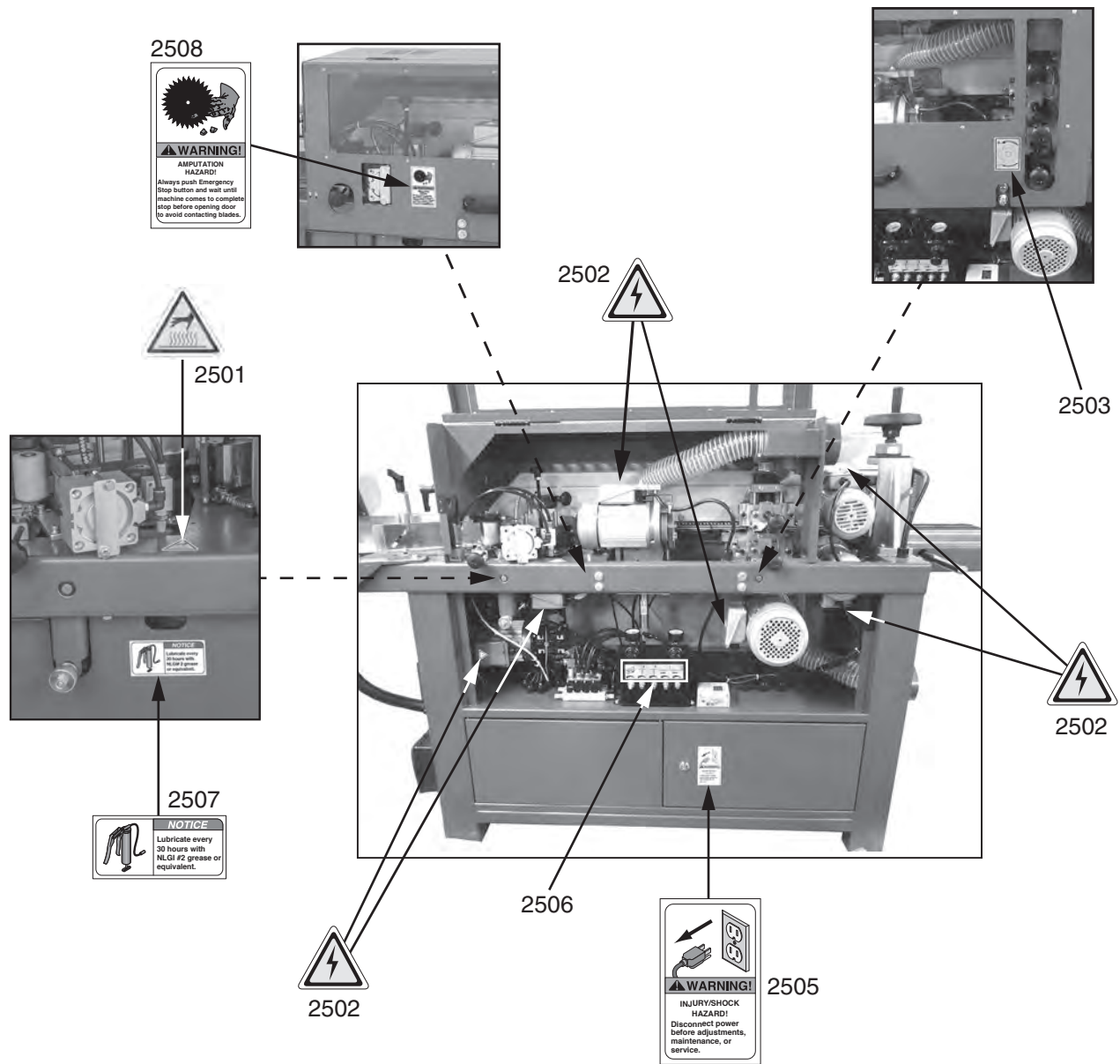


REF	PART #	DESCRIPTION
2301	P07742301	TERMINAL BAR PYK2 1-PC
2302	P07742302	TERMINAL BAR PYK2, GROUND 1-PC
2303	P07742303	TERMINAL END PLATE
2304	P07742304	MOUNTING RAIL END PLATE
2305	P07742305	TERMINAL JUMPER
2306	P07742306	TRANSFORMER 220V LCE LCP-TBSM-100120
2307	P07742307	INVERTER DELTA DVP32ES200R
2308	P07742308	CONTACTOR SHIHLIN S-P11S 24V
2309	P07742309	FLANGE SCR M5-.8 X 10
2310	P07742310	FLANGE SCR M5-.8 X 10
2311	P07742311	OL RELAY SHIHLIN MR-32S-2.5 1.6-2.5A
2312	P07742312	OL RELAY SHIHLIN MR-32S-4 2.5-4A
2313	P07742313	OL RELAY SHIHLIN MR-32S-6.3 4-6.3A

REF	PART #	DESCRIPTION
2314	P07742314	FUSE HOLDER PMX-10 X 38 RM32 32A 680V
2315	P07742315	FUSE 10 X 38MM 6A 600V F-A, CERAMIC
2316	P07742316	FUSE 10 X 38MM 3A 600V F-A, CERAMIC
2317	P07742317	GROUND TERMINAL 6-POLE 20A
2318	P07742318	CONTROL PANEL MOUNT
2319	P07742319	RELAY OMRON MY4N-J 24V
2320	P07742320	WIRING LOOM 1 X 2-1/2 X 34"
2321	P07742321	WIRING LOOM 1 X 2-1/2 X 7"
2322	P07742322	WIRING LOOM 1 X 2-1/2 X 5"
2323	P07742323	MOUNTING RAIL 1-3/8 X 1-3/8 X 17"
2324	P07742324	MOUNTING RAIL 1-3/8 X 1-3/8 X 6-1/4"
2325	P07742325	MOUNTING RAIL 1-3/8 X 1-3/8 X 17-1/4"
2326	P07742326	MOUNTING RAIL 1-3/8 X 1-3/8 X 12-1/4"



Labels & Cosmetics (Rear)



REF	PART #	DESCRIPTION
2501	P07742501	WARNING HOT SURFACE LABEL
2502	P07742502	ELECTRICITY LABEL
2503	P07742503	COUNTER ROTATION LABEL
2505	P07742505	DISCONNECT POWER LABEL

REF	PART #	DESCRIPTION
2506	P07742506	VALVE ADJUSTMENT LABEL
2507	P07742507	LUBRICATION NOTICE LABEL
2508	P07742508	WARNING FEEDER AMPUTATION LABEL

WARNING

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



WARRANTY & RETURNS

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

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

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

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

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

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

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



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