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

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.

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
Figure 1. Main controls/components of the sander.

A. Circuit Breaker
B. ON/OFF Switch w/Lockout Key
C. Feed Speed Scale
D. Variable Speed Feed Rate Knob
E. Return Roller
F. Table Height Adjustment Handwheel
G. Feed Belt
H. Dust Port
MODEL G0458 18" 1-1/2 HP SINGLE-PHASE OPEN END DRUM SANDER

Product Dimensions:
- Weight: 252 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height: 35 x 24 x 50 in.
- Footprint (Length x Width): 35 x 17 in.

Shipping Dimensions:
- Type: Wood Crate
- Content: Machine
- Weight: 300 lbs.
- Length x Width x Height: 25 x 33 x 33 in.
- Must Ship Upright: Yes

Electrical:
- Power Requirement: 110V, Single-Phase, 60 Hz
- Prewired Voltage: 110V
- Full-Load Current Rating: 11.5A
- Minimum Circuit Size: 20A
- Connection Type: Cord & Plug
- Power Cord Included: Yes
- Power Cord Length: 6-1/2 ft.
- Power Cord Gauge: 14 AWG
- Plug Included: Yes
- Included Plug Gauge: 5-15
- Switch Type: Paddle Safety Switch w/Removable Key

Motors:
- Main
  - Horsepower: 1.5 HP
  - Phase: Single-Phase
  - Amps: 11.5A
  - Speed: 3460 RPM
  - Type: ODP Capacitor-Start Induction
  - Power Transfer: V-Belt Drive
  - Bearings: Shielded & Permanently Lubricated

Main Specifications:
- Number of Sanding Heads: 1
- Maximum Board Width: 36 in.
- Minimum Board Width: 1 in.
- Maximum Board Thickness: 4-1/2 in.
- Minimum Board Thickness: 1/8 in.
- Minimum Board Length: 6 in.
- Sandpaper Speed: 4000 FPM
- Conveyor Feed Rate: 2 – 12 FPM
- Sandpaper Length: 84 in.
- Sandpaper Width: 3 in.

Due to our ongoing improvement efforts, this information may not accurately describe items previously purchased.
Drum Information

<table>
<thead>
<tr>
<th>Infeed Sanding Drum Type</th>
<th>Aluminum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Infeed Sanding Drum Size</td>
<td>4 in.</td>
</tr>
</tbody>
</table>

Construction

<table>
<thead>
<tr>
<th>Conveyor Belt Type</th>
<th>Sandpaper</th>
</tr>
</thead>
<tbody>
<tr>
<td>Body</td>
<td>Steel</td>
</tr>
<tr>
<td>Base</td>
<td>Steel</td>
</tr>
<tr>
<td>Paint Type/Finish</td>
<td>Powder Coated</td>
</tr>
</tbody>
</table>

Other Related Information

<table>
<thead>
<tr>
<th>Floor To Table Height</th>
<th>35–40 in.</th>
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</thead>
<tbody>
<tr>
<td>Sanding Belt Tension</td>
<td>Spring Loaded</td>
</tr>
<tr>
<td>Conveyor Belt Length</td>
<td>44-1/2 in.</td>
</tr>
<tr>
<td>Conveyor Belt Width</td>
<td>18 in.</td>
</tr>
<tr>
<td>Belt Roller Size</td>
<td>1-1/2 in.</td>
</tr>
<tr>
<td>Number of Dust Ports</td>
<td>1</td>
</tr>
<tr>
<td>Dust Port Size</td>
<td>2-1/2 in.</td>
</tr>
</tbody>
</table>

Other Specifications:

<table>
<thead>
<tr>
<th>Country of Origin</th>
<th>China</th>
</tr>
</thead>
<tbody>
<tr>
<td>Warranty</td>
<td>1 Year</td>
</tr>
<tr>
<td>Approximate Assembly &amp; Setup Time</td>
<td>1-1/2 Hours</td>
</tr>
<tr>
<td>Serial Number Location</td>
<td>ID Label</td>
</tr>
<tr>
<td>ISO 9001 Factory</td>
<td>No</td>
</tr>
<tr>
<td>Certified by a NRTL</td>
<td>No</td>
</tr>
</tbody>
</table>

Features:

- Spring-Loaded Sanding Belt Tension
- Sandpaper Conveyor Belt
- 2-1/2” Dust Port
- Variable Speed Conveyor
- V-Belt Motor Drive
- 4” Aluminum Sanding Drum
- Green and Putty Powder Coated Paint
- Stand Alone Dust Collection with Dust Bag
- Stationary Drum Headstock
- Board Return Roller
- Safety Switch
- Easy Access for Sandpaper Changes
For Your Own Safety, Read Instruction Manual Before Operating This Machine

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

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

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

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

NOTICE This symbol is used to alert the user to useful information about proper operation of the machine.

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.
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.
**WARNING**

**Additional Safety for Drum Sanders**

**FEEDING STOCK.** Do not allow anyone to stand in the path of the workpiece at the outfeed end when feeding your stock. Never sand more than one piece of stock at a time. Do not jam the workpiece into the machine during operation. Firmly grasp the workpiece in both hands and ease it into the machine using light pressure.

**MINIMUM STOCK DIMENSIONS.** Do not sand any stock thinner than \(\frac{1}{8}\)”, narrower than \(\frac{1}{8}\)”, or shorter than 6”. Do not sand thin stock by using a “dummy” board under your workpiece.

**CLOTHING.** Do not wear loose clothing while operating this machine. Roll up or button sleeves at the cuff.

**HAND PROTECTION.** Do not place hands near, or in contact with, sanding drums during operation. Do not allow fingers to get pinched between board and conveyor belt during operation. This may pull the operator’s hand into the machine and cause serious injury!

**INSPECTING WORKPIECES.** Always inspect workpiece for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.

**DUST COLLECTION SYSTEM.** Never operate the sander without an adequate dust collection system in place and running.

**UNATTENDED OPERATION.** Never leave the machine running unattended.

**REPLACING SANDING PAPER.** Replace sanding paper when it becomes worn.

**EXPERIENCING DIFFICULTIES.** Any problem, with the exception of conveyor belt tracking that is concerned with any moving parts or accessories, must be investigated and corrected with the power disconnected, and after all moving parts have come to a complete stop.

**MAINTENANCE AND ADJUSTMENTS.** Never attempt to adjust conveyor belt tracking when the sanding drums are engaged. Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.

**RESPIRATOR AND SAFETY GLASSES.** Always wear a respirator and safety glasses while operating the machine. Dust and chips are created when sanding. Some debris will be ejected, becoming hazards to the eyes and lungs.

**WARNING**

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

**CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.
SECTION 2: POWER SUPPLY

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

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

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

Full-Load Current Rating at 110V... 11.5 Amps
The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

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

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

Nominal Voltage .................. 110V/120V
Cycle...............................60 Hz
Phase............................... Single-Phase
Power Supply Circuit.............. 20 Amps

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.
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.

**Grounding & Plug 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!

**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.

![Grounded 5-15 Receptacle](image)

**Figure 2.** Typical 5-15 plug and receptacle.

**CAUTION**

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

![Shock Hazard](image)
## SECTION 3: SETUP

### Needed for Setup

The following are needed to complete the setup process, but are not included with your machine:

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety Glasses (for each person)</td>
<td>1</td>
</tr>
<tr>
<td>Assistants</td>
<td>2</td>
</tr>
<tr>
<td>Wrench or Socket 13mm</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket 14mm</td>
<td>2</td>
</tr>
<tr>
<td>Hex Wrench 4mm</td>
<td>2</td>
</tr>
<tr>
<td>Phillips Head Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Wood Blocks (three 2x4s)</td>
<td></td>
</tr>
<tr>
<td>Wood Shims (as needed)</td>
<td></td>
</tr>
</tbody>
</table>

### 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.**

### WARNING

- Wear safety glasses during the entire setup process!
- The Model G0458 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.
- Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.
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.

Box 1: (Figures 3 & 4) Qty

A. Drum Sander .............................................. 1
B. Dust Bag ..................................................... 1
C. Dust Hose Clamp ....................................... 1
D. Dust Port ..................................................... 1
E. Stand Legs ................................................. 1
F. Bottom Long Brackets ................................ 1
G. Top Long Brackets ..................................... 1
H. Bottom Short Brackets ............................... 1
I. Top Short Brackets ..................................... 1

Figure 3. Box Contents.

J. Hardware and Tools (Not Shown)
   — Handwheel .................................................. 1
   — Handwheel Handle M10-1.5 ......................... 1
   — Phillips Head Screw M6-1 x 25 .................... 1
   — Flat Washer 5mm .................................... 1
   — Hex Bolt M8-1.25 x 20 .................................. 4
   — Hex Nut M8-1.25 ....................................... 4
   — Flat Washer 8mm .................................... 8
   — Carriage Bolt M8-1.25 x 15 ....................... 24
   — Serrated Flange Nut M8-1.25 ..................... 24
   — Combination Wrench 8/12mm ..................... 1
   — Hex Wrenches 4, 5, 6mm ......................... 1 ea

Figure 4. Additional box contents.

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.
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.

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.

![Diagram of minimum working clearances](image-url)

**Figure 5.** Minimum working clearances.
Assembly

We recommend assembling the stand upside down. To make it easier, have an assistant hold the pieces while you assemble the stand.

**NOTICE**

Do not final tighten stand bolts until the stand components have been assembled.

To assemble the machine:

1. Mount a top and bottom long bracket to a stand leg and loosely secure with two M8-1.25 x 15 carriage bolts and serrated flange nuts as shown in Figure 6.

2. Secure a second leg to the top and bottom long brackets with two M8-1.25 x 15 carriage bolts and serrated flange nuts as shown in Figure 7.

3. Mount a top and bottom short bracket to the left and right sides of the stand leg assembly completed in Step 2 as shown in Figure 8. Secure with two M8-1.25 x 15 carriage bolts and serrated flange nuts.

---

Figure 6. Top and bottom long brackets secured to a stand leg.

Figure 7. A completed stand leg assembly.

Figure 8. Top and bottom short brackets secured to a stand leg assembly.
4. Build the rest of the stand assembly, as shown in Figure 9, with the remaining hardware.

![Figure 9. Completed stand assembly.](image1)

5. Turn the stand upright and adjust it so the legs are evenly positioned, then tighten all the stand fasteners.

![WARNING](image2)

<table>
<thead>
<tr>
<th>!WARNING</th>
</tr>
</thead>
<tbody>
<tr>
<td>The sander is very heavy. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.</td>
</tr>
</tbody>
</table>

6. Make sure the sander is still resting on the shipping pallet.

7. Place the pallet and stand near the permanent mounting location (once the sander is mounted to the stand it will be difficult to move).

8. With help of an assistant, tilt the sander back so the side with pulley cover faces the pallet, move the left bottom edge of the sander forward, and rest the left side of the sander on the pallet as shown in Figure 10.

   **Note:** The base should stick out a few inches beyond the edge of the pallet.

![Figure 10. Sander tipped back on pallet against pulley cover.](image3)

9. Place two stacks of blocks the same height as the pallet and about 15 inches apart on the floor near the sander base as shown in Figure 11.

![Figure 11. Blocks set near sander base.](image4)
10. Lay the stand on the blocks as shown in Figure 12.

11. Align the holes, and secure the stand to the sander with the remaining hex bolts, washers, and hex nuts (Figure 13).

   **Note:** If the holes do not align, add wood shims to adjust the block heights.

12. Lift up on the stand and remove the blocks.

13. Tighten the mounting bolts.

14. Tilt the sander upright, as shown in Figure 14, so the rear legs touch the floor.

   **CAUTION**
   If the legs start to slide when tilting, you MUST have a third person hold the stand from sliding to avoid personal injury or machine damage!

15. Thread the handwheel handle into the handwheel and tighten it.

16. Slide the handwheel over the shaft, making sure the shaft pin (Figure 15) inserts into the slots in the handwheel.

17. Secure the handwheel with an M5-.8 x 10 cap screw and 5mm flat washer.
18. Slide the dust port over the fan housing and tighten the included Phillips head screw (Figure 16).

![Figure 16. Installing dust port.](image)

19. Slide the dust hose clamp over the dust bag, insert the bag and clamp over the dust port (Figure 17), and secure with the clamp handle. **DO NOT overtighten the clamping adjustment or it may break!**

![Figure 17. Installing dust bag and clamp.](image)

---

**Dust Collection**

---

**CAUTION**

**DO NOT** operate the Model G0458 without adequate dust collection. This sander creates substantial amounts of wood dust while operating. Failure to use dust collection can result in short and long-term respiratory illness.

You may attach the Model G0458 drum sander to a dust collection system if you do not use the included dust bag. If you are using your own dust collection system, we recommend using a system that can collect a minimum of 400 CFM AT THE DUST PORT.

**Note:** Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must take into account many variables, including the rating of the dust collector, the length of hose between the dust collector and the machine, the amount of branches or wyes, and the amount of other open lines throughout the system.

When the dust collection is working properly, a fine layer of dust may be present on your stock as it comes out of the sander. This is a normal characteristic of all drum sanders.

To connect the dust ports to a dust collector:

1. Attach a 2½" dust collection hose to the dust port and secure with a hose clamp.
Test Run

Now that the machine is assembled, perform a test run to make sure all the controls are working properly.

⚠️ WARNING

Before starting the sander, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury!

To test run the sander:

1. Put on safety glasses and make sure any bystanders are out of the way and also wearing safety glasses.

2. Connect the sander to power.

3. Flip the ON/OFF switch ON. Make sure that your finger is poised over the ON/OFF switch, just in case there is a problem.

The drum sander should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises MUST be investigated and corrected before operating the machine further. To avoid injury or damage to the machine, DO NOT attempt to make adjustments to the machine without turning it OFF and unplugging it from its power source.

Investigate and correct any problems before operating the machine further. If you need help, refer to the Troubleshooting section in the back of this manual or contact Tech Support at (570) 546-9663.

Recommended Adjustments

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

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

Step-by-step instructions for these adjustments can be found in SECTION 7: SERVICE ADJUSTMENTS.

1. V-Belt Tensioning (Page 27). Perform after the first 16 hours.

2. Feed Belt Tensioning & Tracking (Pages 31 & 32).

3. Table Adjustments (Page 34).
SECTION 4: OPERATIONS

⚠️ WARNING
Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.

⚠️ WARNING
Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

⚠️ NOTICE
If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade 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.

Depth of Cut

The optimum depth of cut will vary based on the type of wood, feed rate, and sandpaper grit. Attempts to remove too much material can cause jamming, wood burning, rapid paper wear or tearing, poor finish, and belt slippage.

To set the depth of cut:

1. Rotate the table height handwheel (Figure 18) until the table is too low, then raise the table, allowing a gap between the workpiece and the sanding drum.

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

2. Turn ON the feed belt and sanding drum and feed the workpiece into the sander. SLOWLY raise the feed belt until the workpiece makes light contact with the sanding drum. This is the correct height to begin sanding the workpiece.

3. After the initial pass, turn the handwheel up to ¼ turn (¼” or 0.4mm)—the maximum depth for most sanding conditions. Note: Each full turn of the table height handwheel raises the feed table approximately 0.060” (¼”) or 1.5mm.
Variable Speed

The variable speed knob allows you to increase the feed rate from 2–12 FPM. The correct speed to use depends on the type of stock you are using (hardwood vs. softwood) and the stage of finish with that workpiece.

As a general rule, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove material faster, but runs the risk of overloading the motor or damaging the sandpaper.

Use trial-and-error to determine the best settings for your specific applications.

To adjust the feed belt speed:

1. Turn ON the feed belt (DO NOT adjust conveyor speed when the conveyor motor is OFF).

2. Rotate the variable speed knob (Figure 19) counterclockwise to increase the feed speed, or clockwise to decrease the feed speed.

Sanding

**WARNING**

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

To sand a workpiece:

1. Adjust the table height according to the instructions in Depth of Cut on Page 19.

2. Make sure the filter bag is secure (or start the dust collector, if connected) and turn the sander ON.

3. Feed the workpiece through the sander. Retrieve the workpiece by standing at the side—not at the outfeed end.

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

**NOTICE**

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

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

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

<table>
<thead>
<tr>
<th>Grit</th>
<th>Class</th>
<th>Usage</th>
</tr>
</thead>
<tbody>
<tr>
<td>36</td>
<td>Extra Coarse</td>
<td>Rough sawn boards, thickness sanding, and glue removal.</td>
</tr>
<tr>
<td>60</td>
<td>Coarse</td>
<td>Thickness sanding and glue removal.</td>
</tr>
<tr>
<td>80–100</td>
<td>Medium</td>
<td>Removing planer marks and initial finish sanding.</td>
</tr>
<tr>
<td>120–180</td>
<td>Fine</td>
<td>Finish sanding.</td>
</tr>
</tbody>
</table>

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

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

The Model G0458 is designed for 3\" wide sandpaper rolls. Turn to SECTION 5: ACCESSORIES on Page 24 for grit selection and model numbers.

Tools Needed:

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flat Head Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 4mm</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 5mm</td>
<td>1</td>
</tr>
<tr>
<td>Carton Cutter or Utility Knife</td>
<td>1</td>
</tr>
</tbody>
</table>

To change the paper:

1. Disconnect power to the sander!

2. Open the top cover, remove the three cap screws that secure the chip deflector to the sander frame, and set the deflector aside.

3. Loosen the cap screw on the right spring-loaded clamp as shown in Figure 20.

4. Remove the sandpaper from the clamp. Use a flat head screwdriver, if necessary, to loosen the clamp to free the sandpaper.

5. Rotate drum to carefully remove sandpaper strip from most of the drum but the end.

   Note: Take care not to rip or tear the old sandpaper, so you can use it as a template when cutting out the replacement sandpaper strip. This is easier than using the drawing shown in Figure 21.

6. Loosen the cap screw on the left clamp and fully remove the sandpaper strip.

7. Use the old sandpaper strip as a pattern, if at all possible. Otherwise, use the pattern in Figure 21, to cut a new piece of sandpaper to the necessary shape. After cutting the 12\(\frac{1}{2}\)\" angled sides, measure 2\" along the same sides and cut off the ends with a knife.

8. Insert the left corner of the new sandpaper into the left clamp and tighten the cap screw as shown in Figure 22. The angled side of the sandpaper must be flush with the left drum edge. If the sandpaper overlaps the edge, you may have difficulty closing the cover.

Figure 20. Loosening cap screw on right spring-loaded clamp.

Figure 21. Sandpaper pattern for drum.

Figure 22. Securing sandpaper in left clamp.
9. Wrap the sandpaper around the drum (Figure 23), ensuring there are no bubbles or overlapping edges.

10. When the sandpaper reaches the right side of the drum, move the sandpaper out of the way with a 4mm wrench and place it into the access hole.

11. Rotate the drum toward you so the wrench rests against the frame as shown in Figure 24.

12. Firmly hold down the sandpaper with both hands, rotate the drum toward you, then wrap the end of the sandpaper over the top of the drum (Figure 25).

13. Place the end of the sandpaper into the clamp, secure it, and remove the hex wrench from the access hole.

14. If the sandpaper does not fit into the right clamp, you may have inserted the sandpaper too deeply into the left clamp. Also, check to make sure the length, width, and angled cuts match the pattern in Figure 21. Make adjustments to the sandpaper if necessary.

If sandpaper completely covers the access hole, you may have placed too little sandpaper into the left clamp. Unwrap the sandpaper and redo Steps 8–13.

15. In either case, reinstall the sandpaper, repeat Steps 9–13, and continue adjusting the paper until it fits into the clamp.

16. When finished, reinstall the chip deflector, secure it with the three cap screws, and close the cover.
SECTION 5: ACCESSORIES

⚠️ WARNING
Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE
Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

Aluminum Oxide Sanding Rolls 3" x 22'
T23880—60 Grit: Use for thickness sanding and glue removal.
T23881—80 Grit: Use for removing planer marks and initial finish sanding.
T23882—100 Grit: Use for removing planer marks and initial finish sanding.
T23883—120 Grit: Use for finish sanding.
T23884—150 Grit: Use for finish sanding.
T23885—180 Grit: Use for finish sanding.
T23886—220 Grit: Use for finish sanding.

G1163P—1HP Floor Model Dust Collector
G0710—1HP Wall-Mount Dust Collector
Excellent point-of-use dust collectors that can be used next to the machine with only a small amount of ducting. Specifications: 450 CFM, 7.2" static pressure, 2 cubic foot bag, and 30 micron filter. Motor is 1HP, 110V/220V, 14A/7A.

PRO-STICK® Sanding Pad
Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your drum sander to remove dust build-up from the sandpaper without damage.

Size               Model
15" x 20" x 1½" ...................................... H2845

Figure 27. PRO-STICK® sanding pad.

T21992—Power Twist® V-Belt ½" x 4'
Smooth running with less vibration and noise than solid belts. The Power Twist® V-belts can be customized in minutes to any size—just add or remove sections to fit your needs. Size: ½" x 4'; replaces all "A" sized V-belts. Requires one Power Twist® V-belt to replace the stock V-belt on your Model G0458.

Figure 28. Power twist V-belt.

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE
Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.
SECTION 6: MAINTENANCE

Cleaning

Cleaning the Model G0458 is relatively easy. Vacuum excess sawdust, and wipe off the remaining dust with a dry cloth.

Lubrication

The feed belt bushings should be lubricated daily with a light machine oil. Lubricate the chains and gears with a high-quality, lithium-based grease. The bearings do not need lubrication.

Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the chain.

Bushings: Must be oiled daily or each time the sander is used. Oil the bushings on each end of the feed belt rollers and remove the pulley cover and oil the drive bushings (see Figure 29).

Figure 29. Bushing locations.

Schedule

For safe and optimum performance from a machine that is used on a daily basis, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Checks and Maintenance:

- Loose mounting bolts.
- Damaged sanding belt.
- Worn switch.
- Worn or damaged cords or plugs.
- Damaged V-belts.
- Any other unsafe condition.
- Oil the feed belt roller and drive bushings.
- Clean/vacuum dust buildup from inside cabinet and off of the motor.

WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.
Feed Belt Drive: Lubricate with lithium grease monthly. Wipe sawdust and dirt impregnated grease off of the chain and gears shown in Figures 30 & 31. Apply fresh lithium grease to the gears and chain.

Table Lift Mechanism: Lubricate the table lift screws, chain, and helical gear with lithium grease every six months. Clean the chain and table lift screws (Figure 32), then rub lithium grease onto the chain links and screw threads. Clean the helical gear (Figure 33) and place a dab of grease on the teeth. Move the table up or down to spread the grease thoroughly throughout the mechanism.

Sanding Belts

You can greatly increase the lifespan of your sanding belts if you clean them often. Cleaning pads (Accessories on Page 24) are the fastest way to remove sawdust build-up.
V-Belt Tensioning

Tools Needed:  
<table>
<thead>
<tr>
<th>Qty</th>
<th>Item</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Ea</td>
<td>Hex Wrenches 4 &amp; 8mm</td>
</tr>
<tr>
<td>1</td>
<td>Phillips Head Screwdriver</td>
</tr>
<tr>
<td>1</td>
<td>Pry Bar</td>
</tr>
</tbody>
</table>

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

Correct V-belt tension is achieved when the V-belts can be deflected 1/2"–3/4" when pushed in the middle with moderate pressure. See Figure 34 for an example of how to perform a V-belt deflection test with a straightedge and ruler.

![Figure 34. Checking V-belt tension with a straightedge and a ruler.]

CAUTION

Always inspect V-belts for damage or deterioration when adjusting for tension. Should you find evidence of cracking, abrasion or damage from wood chips or other foreign materials, replace the belt immediately. Belt breakage may lead to mechanical damage or operator injury.

To adjust V-belt tension:

1. Disconnect power to the sander!
2. Open the pulley cover.
3. Check the tension of the feed belt V-belt, then adjust the tension by loosening the motor mount cap screws shown in Figure 35 and pushing down on the motor mount to tighten the V-belts.

![Figure 35. Feed belt V-belt tension.]

4. Tension the sanding drum V-belt by sliding the idler roller (Figure 36) into the V-belt until the belt is correctly tensioned, then replace the pulley cover.

![Figure 36. Sanding drum V-belt tension.]

NOTICE

New V-belts will often stretch and loosen after moderate use. Check frequently after installation and re-tension if necessary.
**SECTION 7: SERVICE**

Review the troubleshooting and 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

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine does not start or a breaker trips.</td>
<td>1. Plug/receptacle is faulty or wired incorrectly.</td>
<td>1. Test power plug and receptacle for good contact and correct wiring.</td>
</tr>
<tr>
<td></td>
<td>2. Start capacitor is faulty.</td>
<td>2. Test capacitor and replace if necessary.</td>
</tr>
<tr>
<td></td>
<td>3. Motor connection is wired incorrectly.</td>
<td>3. Correct motor wiring (see Page 38).</td>
</tr>
<tr>
<td></td>
<td>4. Power supply is faulty, or is switched OFF.</td>
<td>4. Make sure hot lines and grounds are operational and have correct voltage on all legs.</td>
</tr>
<tr>
<td></td>
<td>5. Safety switch key is at fault.</td>
<td>5. Install or replace safety key, or replace switch assembly.</td>
</tr>
<tr>
<td></td>
<td>6. Motor ON/OFF switch is faulty.</td>
<td>6. Replace faulty ON/OFF switch.</td>
</tr>
<tr>
<td></td>
<td>7. Centrifugal switch is at fault.</td>
<td>7. Adjust or replace the centrifugal switch.</td>
</tr>
<tr>
<td></td>
<td>8. Cable or wiring is open or has high resistance.</td>
<td>8. Check for disconnected or corroded connections, troubleshoot wires for internal or external breaks, then repair or replace wiring.</td>
</tr>
<tr>
<td></td>
<td>9. Motor is at fault.</td>
<td>9. Test, then repair or replace motor.</td>
</tr>
<tr>
<td>Machine stalls or is underpowered.</td>
<td>1. Wrong workpiece material.</td>
<td>1. Only process wood with correct moisture content, and no glues, or resins.</td>
</tr>
<tr>
<td></td>
<td>2. Low power supply voltage.</td>
<td>2. Make sure hot lines and grounds are operational and have correct voltage on all legs.</td>
</tr>
<tr>
<td></td>
<td>3. Run capacitor is faulty.</td>
<td>3. Test capacitor and replace if necessary.</td>
</tr>
<tr>
<td></td>
<td>4. Filter bags are at fault.</td>
<td>4. Empty and clean filter bag.</td>
</tr>
<tr>
<td></td>
<td>5. V-belts are slipping.</td>
<td>5. Replace bad belts, align pulleys, and re-tension the V-belts (see Pages 27 &amp; 30).</td>
</tr>
<tr>
<td></td>
<td>6. Plug or receptacle is at fault.</td>
<td>6. Test power plug and receptacle for good contact and correct wiring.</td>
</tr>
<tr>
<td></td>
<td>7. Motor connection is wired incorrectly.</td>
<td>7. Correct motor wiring (see Page 38).</td>
</tr>
<tr>
<td></td>
<td>8. Motor bearings are at fault.</td>
<td>8. Rotate motor shaft for noisy or burnt bearings, repair/replace as required.</td>
</tr>
<tr>
<td></td>
<td>9. Machine is overloaded.</td>
<td>9. Use new sandpaper with appropriate grit, and reduce the feed rate/depth of sanding.</td>
</tr>
<tr>
<td></td>
<td>10. Motor has overheated.</td>
<td>10. Check motor cooling air flow, let motor cool, and reduce workload on machine.</td>
</tr>
<tr>
<td></td>
<td>11. Centrifugal switch is at fault.</td>
<td>11. Adjust/replace the centrifugal switch.</td>
</tr>
<tr>
<td></td>
<td>12. Motor is at fault.</td>
<td>12. Test motor, and repair/replace if necessary.</td>
</tr>
</tbody>
</table>
### Symptom Table

<table>
<thead>
<tr>
<th>Symptom: Machine has vibration or noisy operation.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Motor or component is loose.</td>
<td>1. Motor or component is loose.</td>
<td>1. Inspect for stripped/damaged bolts/nuts, replace/re-tighten with thread locking fluid.</td>
</tr>
<tr>
<td>2. V-belts are worn or loose.</td>
<td>2. V-belts are worn or loose.</td>
<td>2. Inspect belts, replace and re-tension (see Pages 27 &amp; 30).</td>
</tr>
<tr>
<td>3. Motor fan is rubbing on fan cover.</td>
<td>3. Motor fan is rubbing on fan cover.</td>
<td>3. Replace dented fan cover/damaged fan.</td>
</tr>
<tr>
<td>4. Pulley is loose.</td>
<td>4. Pulley is loose.</td>
<td>4. Remove pulley, replace shaft, pulley, setscrew, and key as required, and realign.</td>
</tr>
<tr>
<td>5. Machine is incorrectly mounted to the floor.</td>
<td>5. Machine is incorrectly mounted to the floor.</td>
<td>5. Machine has loose anchor studs in floor, or is sitting on uneven floor. Replace/tighten relocate as required.</td>
</tr>
<tr>
<td>6. Cast iron motor mount is at fault.</td>
<td>6. Cast iron motor mount is at fault.</td>
<td>6. Using leverage and a small pry bar to inspect, carefully replace loose/broken mounts.</td>
</tr>
<tr>
<td>7. Motor bearings are at fault.</td>
<td>7. Motor bearings are at fault.</td>
<td>7. Check bearings, replace motor or bearings as required.</td>
</tr>
</tbody>
</table>

### Sanding Operations

<table>
<thead>
<tr>
<th>Symptom: Vibration when sanding.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Loose drum bearings.</td>
<td>1. Loose drum bearings.</td>
<td>1. Tighten drum bearings.</td>
</tr>
<tr>
<td>2. Worn drum bearings.</td>
<td>2. Worn drum bearings.</td>
<td>2. Replace drum bearings.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Grinding, screeching, or rubbing noise when sanding drums are powered up.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Drum bushings lack sufficient oil.</td>
<td>1. Drum bushings lack sufficient oil.</td>
<td>1. Oil the drum bushings (see Page 25).</td>
</tr>
<tr>
<td>2. Drum bushings are worn and need replacement.</td>
<td>2. Drum bushings are worn and need replacement.</td>
<td>2. Replace the drum bushings.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Short V-belt lifespan.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Pulleys not aligned correctly.</td>
<td>1. Pulleys not aligned correctly.</td>
<td>1. Align pulleys (see Page 31).</td>
</tr>
<tr>
<td>2. Improperly tensioned.</td>
<td>2. Improperly tensioned.</td>
<td>2. Properly tension V-belts (see Page 27).</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Machine lacks power; drums stop turning under load.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>2. Too much pressure on pressure plates.</td>
<td>2. Too much pressure on pressure plates.</td>
<td>2. Raise the pressure plates (Page 35).</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Feed belt slips under load.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Feed belt is too loose.</td>
<td>1. Feed belt is too loose.</td>
<td>1. Tension feed belt (see Page 32).</td>
</tr>
<tr>
<td>2. Too much load.</td>
<td>2. Too much load.</td>
<td>2. Decrease load.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Feed belt tracks to one side or hits the feed table mounts.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Feed belt tracking is incorrect.</td>
<td>1. Feed belt tracking is incorrect.</td>
<td>1. Track the feed belt so it runs straight (see Page 31).</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Excessive snipe.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Lack of outfeed support.</td>
<td>1. Lack of outfeed support.</td>
<td>1. Set up an outfeed table or have someone catch the workpiece as it comes out.</td>
</tr>
<tr>
<td>2. Too much pressure from pressure plates.</td>
<td>2. Too much pressure from pressure plates.</td>
<td>2. Raise the pressure plates (Page 35).</td>
</tr>
<tr>
<td>3. Too much pressure from the rear pressure plate.</td>
<td>3. Too much pressure from the rear pressure plate.</td>
<td>3. Raise the rear pressure plate (Page 35).</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Workpiece kicks out of sander.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Not enough pressure from the pressure plates.</td>
<td>1. Not enough pressure from the pressure plates.</td>
<td>1. Lower the pressure plates (Page 35).</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Sandpaper tears off drums during operation.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>2. Sandpaper not tightened or fastened correctly.</td>
<td>2. Sandpaper not tightened or fastened correctly.</td>
<td>2. Install the sandpaper correctly (see Page 22).</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Symptom: Table elevation controls are stiff and hard to adjust.</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
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<tbody>
<tr>
<td>1. Table lift screws are dirty or loaded with sawdust.</td>
<td>1. Table lift screws are dirty or loaded with sawdust.</td>
<td>1. Clean and re-grease table lift screws (see Page 26).</td>
</tr>
<tr>
<td>2. Chain idler sprocket cap screws have been over tightened.</td>
<td>2. Chain idler sprocket cap screws have been over tightened.</td>
<td>2. Adjust the cap screws on the idler sprocket so it can spin freely.</td>
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<tr>
<td>3. Elevation handle helical gear is dirty or loaded with sawdust.</td>
<td>3. Elevation handle helical gear is dirty or loaded with sawdust.</td>
<td>3. Clean and re-grease the helical gear (see Page 26).</td>
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Replacing V-Belts

Tools Needed:

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
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<tr>
<td>Hex Wrenches 4, 6 &amp; 8mm</td>
<td>1</td>
</tr>
<tr>
<td>Phillips Head Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Pry Bar</td>
<td>1</td>
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</table>

Inspect the V-belts closely; if you notice fraying, cracking, glazing, or any other damage, replace the belts. A worn/damaged V-belt will not provide optimum power transmission from the motor to the drum and feed belt.

V-belt removal and replacement is simply a matter of loosening the V-belts, rolling them off of the pulleys, replacing them with new belts, then retensioning them.

To replace the V-belts:

1. **Disconnect power to the sander!**

2. Open the pulley cover.

   **Note:** If you plan on replacing the variable speed belt, loosen the cap screw securing the variable speed pulley (Figure 38) before loosening the motor mount cap screws.

3. Loosen the motor mount cap screws shown in Figure 37 and loosen the cap screw securing the idler roller.

4. Remove the cap screws securing the bearing bracket and rotate the bearing bracket 90°.

5. Slide the sanding drum V-belt off of the motor pulley, then lift the motor mount to remove the feed V-belt.

   **Note:** You may need to use a pry bar to lift the motor mount.

6. To replace the variable speed belt, remove the cap screw securing the pulley shown in Figure 38, then remove the outer half of the pulley.

7. Compress the spring behind the inner half of the variable speed pulley, slide the outer half of the pulley over the shaft and key, then thread in the cap screw.

8. Install the new feed and drum V-belts, re-attach the bearing bracket, and tension according to the instructions on Page 27.

9. Tighten the variable speed pulley cap screw and replace the pulley cover.

---

Figure 37. Belt drive system.

Figure 38. Variable speed pulley.
Pulley Alignment

Tools Needed:  
Hex Wrenches 4 & 8mm .............................. 1 Ea
Phillips Head Screwdriver............................1
Pry Bar .........................................................1

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

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

To align the pulleys:

1. Disconnect power to the sander!
2. Open the pulley cover.
3. Looking from the top, sight down the V-belts and pulleys and check to see that the pulleys are parallel and aligned with each other (see Figure 39).
   —If the pulleys are aligned, go to Step 9.
   —If the pulleys are NOT aligned, perform Steps 4–8.
4. Remove the V-belts.
5. Loosen the set screws on the motor pulley and align the motor pulley with the feed belt pulley.
6. Loosen the set screws on the sanding belt pulley and align the sanding belt pulley with the motor pulley.
7. Tighten the set screws, replace the V-belts, and repeat Step 3. Belts should be parallel and aligned as shown in Figure 39.
8. Adjust the pulleys again, if necessary, until they are all coplanar with each other.
9. Replace the pulley cover.

Feed Belt Tracking

Tools Needed:  
Wrench 8mm ..................................................1
Hex Wrench 4mm.............................................1

The feed belt must track straight. If the feed belt tracks to either side, then the tracking must be corrected or the feed belt will become damaged and have to be replaced.

Tracking the feed belt is a balancing process that takes patience and a small degree of trial-and-error. Usually you must over-tighten the loose side (the side the belt is tracking towards) to make the feed belt move to the middle of the rollers, then loosen that same side to make the feed belt stay in position. If you adjust the bolt too much either way, then you have to repeat the process until the feed belt rides in the middle and stays there during continuous operation.

Note: Tracking affects tension, so tension must always be adjusted after tracking.

To track the feed belt:

1. Turn the feed belt ON and watch it track. If the belt moves to one side, immediately stop the machine and adjust the belt tracking. If the belt tracks evenly, leave it alone.
2. Loosen the lock nut (Figure 40) on the side that the feed belt tracks towards and tension the tracking adjustment screw until the feed belt tracks in the opposite direction.

**Note:** Small tracking changes may take up to three minutes before they are noticeable.

3. When the feed belt is near the middle of the rollers or table, loosen the tracking adjustment screw until the feed belt stops moving and tracks straight.

   —If the feed belt tracks too far to the other side, loosen the tracking adjustment screw as necessary to bring it back. Repeat Steps 2 & 3 until the tracking is correct.

Figure 40. Feed belt tracking adjustment bolt.

To tension the feed belt:

1. Loosen the feed roller lock screws, shown in Figure 41, on both sides of the feed belt.

Figure 41. Feed belt tensioning controls.

2. Use a permanent marker, paper correction fluid, or fingernail polish to mark the feed belt tensioning bolt on both sides. This step will aid you in keeping track of the rotations as you turn the bolts, so they remain as even as possible.

3. Loosen the lock nuts and turn both of the feed belt tensioning bolts clockwise one full turn at a time until the feed belt no longer slips during operation.

   —If the feed belt starts tracking to one side, back off the feed belt tensioning bolt that is being adjusted.

   —If the feed belt continues tracking to one side, immediately turn the drum sander **OFF** and perform the tracking instructions.

4. Tighten the lock nuts to lock the feed belt tensioning bolts in place.

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

---

**Feed Belt Tension**

**Tools Needed:**

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</thead>
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<td>Wrench 12mm</td>
<td>2</td>
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<tr>
<td>Hex Wrench 6mm</td>
<td>1</td>
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</tbody>
</table>

The feed belt will stretch when new and will eventually need to be tensioned. This is most obvious if the feed belt starts slipping on the rollers.

When you tension the feed belt, focus on adjusting the tensioning bolts in even increments. Adjusting one side more than the other will cause tracking problems, which will require you to take additional steps to get the sander operating correctly.

**NOTICE**

DO NOT over-tension the feed belt, this may cause premature wearing of the belt, bushings, and cause strain on the motor.
Feed Belt Replacement

Tools Needed:  
- Wrench 12mm ....................................................2
- Hex Wrench 6mm.................................................1
- An Assistant .......................................................1

Replacing the feed belt is a simple process, but will require tensioning and tracking when completed.

To replace the feed belt:

1. Disconnect power to the sander!

2. Use a permanent marker, paper correction fluid, or fingernail polish to mark the front of the feed belt tensioning bolt (Figure 41) on both sides. This step will aid you in returning the bolts to their original position, reducing the amount of tracking necessary.

3. Loosen the lock nuts shown in Figure 41 and turn both of the feed belt adjustment bolts counterclockwise one full turn at a time to release the tension from the feed belt.

4. Remove the outside table cap screws shown in Figure 42 and loosen the corresponding cap screws on the inside edge.

5. Have an assistant lift the outside edge of the table, then slide the feed belt off.

6. Clean any dirt or dust off of the table and rollers, have an assistant lift the table, then slide the new feed belt on.

7. Re-install and tighten all of the table cap screws.

8. Tighten the feed belt adjustment bolts equally, then follow the tensioning instructions on Page 32.

   Note: The feed belt will stretch slightly when new and will need to be re-tensioned after a short amount of use.

9. Track the new feed belt according to the instructions on Page 31.

   Note: One side of the belt may need to be tighter than the other for the belt to track straight.
Gauge Blocks

Tools Needed:  
- 6' Long 2x4 ......................................................... 1
- Miter Saw (or Circular Saw) ...................................... 1
- Jointer ................................................................. 1
- Table Saw ........................................................... 1

The gauge blocks described here will be required to complete the remaining service procedures in this section.

To make the gauge blocks:

1. Edge joint the concave edge of the 2x4 flat on a jointer, as shown in Figure 43.

   Figure 43. Edge jointing on a jointer.

2. Place the jointed edge of the 2x4 against the table saw fence and rip cut just enough off the opposite side to square up the two edges of the 2x4, as shown in Figure 44.

   Figure 44. Rip cutting on a table saw.

3. Cut the 2x4 into two even pieces to make two 36" long wood gauge blocks.

   Note: Steps 1 & 2 can be skipped, but having the gauge blocks at an equal height is critical to the accuracy of your adjustments.

Table Adjustments

Aligning the drums parallel to the conveyor belt (Figure 45) is critical for sanding accuracy. Care should be taken to make the tolerances as close as possible (within 0.002" from one side to the other) when adjusting the drum height.

Figure 45. Drum parallel to conveyor belt.

Tools Needed:  
- Hex Wrenches 3 & 6mm ...................................... 1 Ea
- Gauge Blocks ..................................................... 2
- Feeler Gauge Set ................................................. 1

To align the drums:

1. Disconnect power to the sander!

2. Remove the sandpaper from the drum and place the gauge blocks as shown in Figure 46.

   Figure 46. Gauge blocks placed under drums.
3. Raise the table until the gauge blocks just touch the drum.

   **Note:** A good way to know when they are touching is to rock the drum back and forth while raising the table until you hear or feel contact with the gauge blocks.

4. Lower the table one full crank of the handwheel (taking handwheel free-play into consideration; or in other words, wait until the chain starts moving before starting to count the handwheel rotation).

5. Starting at one end, find the largest size feeler gauge that can pass between the drum and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing the drum to roll.)

6. Repeat Step 5 at the other end of the drum.

   —If the difference between the two sizes is 0.002” or less, then no adjustment is necessary.

   —If the difference between the two sizes is more than 0.002”, then one end must be adjusted to within 0.002” from the other. Continue to the next step.

7. Loosen the table cap screws and adjust the height of the table by rotating the adjustment knob shown in Figure 47.

8. Tighten the table cap screws and repeat Steps 5 & 6.

---

**Pressure Plate Adjustments**

**Tools Needed:**

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wrench 8mm</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 4mm</td>
<td>1</td>
</tr>
<tr>
<td>Gauge Blocks (see Page 34)</td>
<td>2</td>
</tr>
<tr>
<td>Feeler Gauge Set</td>
<td>1</td>
</tr>
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</table>

When properly positioned, the pressure plates should be approximately 0.004” lower than the drum.

Adjusting the pressure plates is a fine balance between too much pressure and not enough. Too much pressure can cause problems like snipe or overloading the motor, not enough pressure may allow the workpiece to kick out of the sander towards the operator.

The pressure plates have been set correctly at the factory. Do not adjust the pressure plates unless absolutely necessary.

**To check pressure plate adjustment:**

1. **Disconnect power to the sander!**

2. Place the gauge blocks on the feed belt as shown in **Figure 46**.

3. Raise the table until the gauge blocks just touch the rear pressure plate.

4. Find the largest size feeler gauge that can pass between the drum and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing the drum to roll.)

   —If the gap is 0.004” (0.1mm) or less, then no adjustment of the rear pressure plate is necessary.

   —If the gap is more than 0.004” (0.1mm), then the rear pressure plate must be adjusted.
5. Raise the table until the gauge blocks just touch the drum.

6. Find the largest size feeler gauge that can pass between the front pressure plate and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing the drum to roll.)

—If the gap is 0.004” (0.1mm) or less, then no adjustment of the front pressure plate is necessary.

—If the gap is more than 0.004” (0.1mm), then the front pressure plate must be adjusted.

To adjust the front pressure plate:

1. Disconnect power to the sander!

2. Loosen the lock nuts and tighten the cap screws on both ends of the front pressure plate shown in Figure 49 to raise the pressure plate, or loosen the cap screw to lower the pressure plate.

3. Adjust the front pressure plate until it is equal to, or up to 0.004” (0.1mm) lower than the height of the drum.

To adjust the rear pressure plate:

1. Disconnect power to the sander!

2. Loosen the lock nuts and tighten the cap screws on both ends of the rear pressure plate shown in Figure 48 to raise the pressure plate, or loosen the cap screw to lower the pressure plate.

3. Adjust the rear pressure plate until it is equal to, or up to 0.004” (0.1mm) lower than the height of the drum.
SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

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

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

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NOTICE

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

COLOR KEY

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<td>Gr</td>
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</table>

Model G0458 (Mfg. Since 5/11)
Wiring Diagram

5-15 Plug
110 VAC

Wiring Diagram

Neutral

Ground

Hot

Ground

110 VAC

Overload Switch
(viewed from behind)

Paddle Switch
(viewed from behind)

Wiring Diagram

Stop

READ ELECTRICAL SAFETY ON PAGE 37!

Model G0458 (Mfg. Since 5/11)
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### 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 CARD

Name _____________________________________________________________________________
Street _____________________________________________________________________________
City _______________________ State _________________________ Zip _____________________
Phone # ____________________ Email _________________________________________________
Model # ____________________ Order # _______________________ Serial # __________________

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop
better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?
   ____ Advertisement  ____ Friend  ____ Catalog
   ____ Card Deck  ____ Website  ____ Other:

2. Which of the following magazines do you subscribe to?
   ____ Cabinetmaker & FDM  ____ Popular Science  ____ Wooden Boat
   ____ Family Handyman  ____ Popular Woodworking  ____ Woodshop News
   ____ Hand Loader  ____ Precision Shooter  ____ Woodsmith
   ____ Handy  ____ Projects in Metal  ____ Woodwork
   ____ Home Shop Machinist  ____ RC Modeler  ____ Woodworker West
   ____ Journal of Light Cont.  ____ Rifle  ____ Woodworker’s Journal
   ____ Live Steam  ____ Shop Notes  ____ Other:
   ____ Model Airplane News  ____ Shotgun News
   ____ Old House Journal  ____ Today’s Homeowner
   ____ Popular Mechanics  ____ Wood

3. What is your annual household income?
   ____ $20,000-$29,000  ____ $30,000-$39,000  ____ $40,000-$49,000
   ____ $50,000-$59,000  ____ $60,000-$69,000  ____ $70,000+

4. What is your age group?
   ____ 20-29  ____ 30-39  ____ 40-49
   ____ 50-59  ____ 60-69  ____ 70+

5. How long have you been a woodworker/metalworker?
   ____ 0-2 Years  ____ 2-8 Years  ____ 8-20 Years  ____ 20+ Years

6. How many of your machines or tools are Grizzly?
   ____ 0-2  ____ 3-5  ____ 6-9  ____ 10+

7. Do you think your machine represents a good value?  _____Yes  _____No

8. Would you recommend Grizzly Industrial to a friend?  _____Yes  _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
   Note: We never use names more than 3 times.  _____Yes  _____No

10. Comments:_____________________________________________________________________
    _______________________________________________________________________________
    _______________________________________________________________________________
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.

To take advantage of 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.

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.

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.
Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!
~Since 1983~

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