



MODEL G0458Z

18" OPEN-END DRUM SANDER

OWNER'S MANUAL

(For models manufactured since 01/23)



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#JM22748 PRINTED IN TAIWAN

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



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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


Manual Accuracy

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

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

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

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 machine is properly adjusted/setup and	
Specification:		4. Make sure the motor has stopped and disconnect	
Weight:		power before adjustments, maintenance, or service.	
		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9. Do not use machine if you are tired, drowsy, or under the	
		influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	

Manufactured for Grizzly in Taiwan

Manufacture Date

Serial Number



Identification

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



- A. Circuit Breaker:** Trips during excessive sanding operation when workload overloads circuit. Press button to reset breaker.
- B. ON/OFF Paddle Switch w/Disabling Key:** Turns motor **ON** and **OFF**. Remove yellow key to disable switch.
- C. Conveyor Feed Rate Dial:** Rotate dial counterclockwise to decrease conveyor belt feed rate or clockwise to increase feed rate. Conveyor feed rate ranges from 0–12 FPM.
- D. Table Height Indicator:** Displays approximate distance between sanding drum and conveyor belt.
- E. Dust Port:** Connects sander to 4" dust collection system.
- F. Table Elevation Handwheel:** Raises and lowers conveyor table (G). Rotate counterclockwise to lower table; rotate clockwise to raise table. One full rotation moves the table approximately 0.060" ($\frac{1}{16}$ ").
- G. Conveyor Table w/Belt:** Feeds workpiece across conveyor table during sanding operations.
- H. Belt Access Panel:** Remove panel to change sanding belt pulley positions or make belt adjustments.
- I. Conveyor Belt Motor:** Controls feed rate of conveyor belt. Use Conveyor Feed Rate Dial (C) to adjust feed rate.





MACHINE DATA SHEET

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

MODEL G0458Z 18" OPEN-END DRUM SANDER

Product Dimensions:

Weight..... 198 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 35-1/2 x 22-1/2 x 50 in.
Footprint (Length x Width)..... 36-7/8 x 20-1/2 in.

Shipping Dimensions:

Type..... Cardboard Box w/Wood Skids
Content..... Machine
Weight..... 235 lbs.
Length x Width x Height..... 25 x 33 x 33 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 13.92A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6 ft.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Conveyor Belt

Horsepower..... 90W
Amps..... 0.92A
Speed..... 1800 RPM
Type..... Universal DC
Power Transfer Direct Drive
Centrifugal Switch/Contacts Type..... External

Main

Horsepower..... 1.5 HP
Phase..... Single-Phase
Amps..... 13A
Speed..... 3450 RPM
Type..... ODP Capacitor-Start Induction
Power Transfer V-Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External



Main Specifications:**Operation Information**

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.....	2600, 3400 FPM
Conveyor Feed Rate.....	0 – 12 FPM
Sandpaper Length.....	86 in.
Sandpaper Width.....	3 in.

Drum Information

Infeed Sanding Drum Type.....	Aluminum
Infeed Sanding Drum Size.....	4 in.

Construction

Conveyor Belt.....	Sandpaper
Body.....	Steel
Base.....	Steel
Paint Type/Finish.....	Powder Coated

Other Related Information

Floor To Table Height.....	35 – 40 in.
Sanding Belt Tension.....	Spring Loaded
Conveyor Belt Length.....	45 in.
Conveyor Belt Width.....	18 in.
Belt Roller Size.....	1-3/8 in.
Number of Dust Ports.....	1
Dust Port Size.....	4 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1-1/2 Hours
Serial Number Location	ID Label
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features:

Open-Ended Design Accommodates Workpieces up to 36" Wide
Spring-Loaded Sanding Belt Tension
Sandpaper Conveyor Belt
4" Dust Port
Electronic Variable-Speed Conveyor Motor
4" Aluminum Sanding Drum
Durable Powder-Coated Finish
Stationary Drum Headstock
Paddle Switch with Removable Key
Easy Access for Sandpaper Changes



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



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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Drum Sanders

WARNING

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

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

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

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

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

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

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

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

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

WARNING

Like all 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

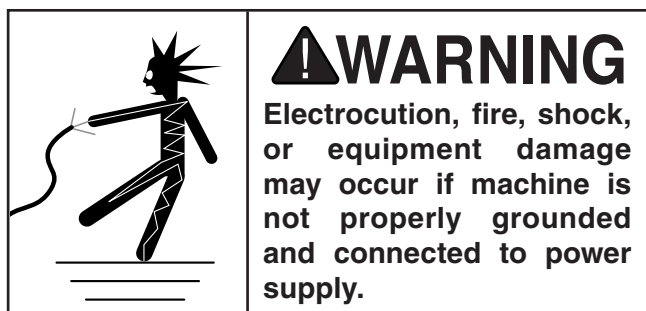
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



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 120V 13.92 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.

!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.

120V 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, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps
Plug/Receptacle NEMA 5-15

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.*



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!

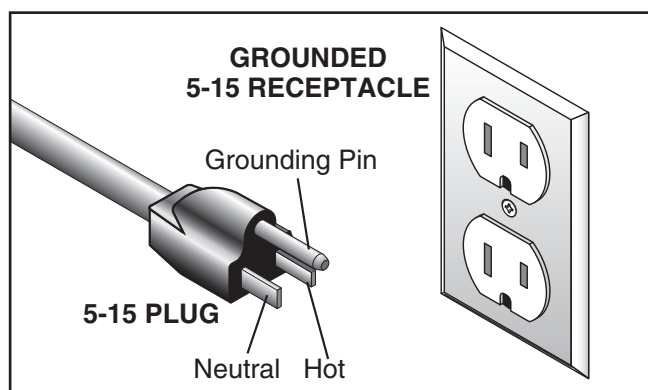
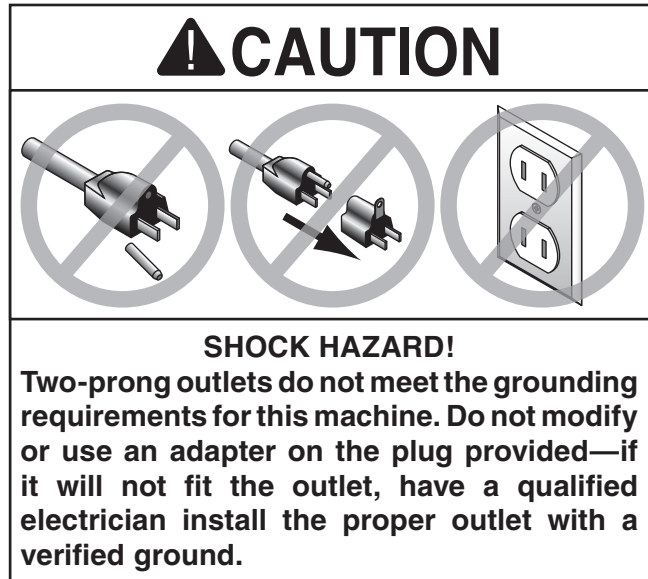


Figure 1. Typical 5-15 plug and receptacle.



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.

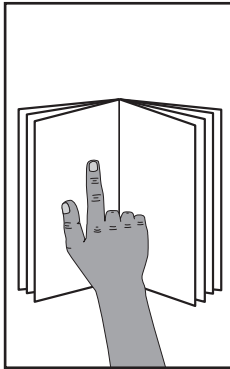
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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.

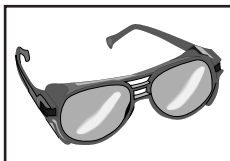


SECTION 3: SETUP



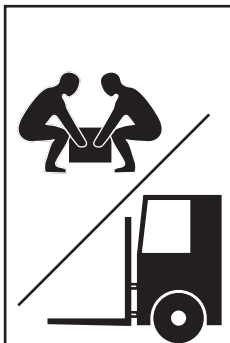
!WARNING

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

Description	Qty
• Additional People	2
• Safety Glasses	1 Ea.
• Open-End Wrench or Socket 13mm	1
• Open-End Wrench or Socket 14mm	2
• Hex Wrench 4mm.....	2
• Phillips Head Screwdriver #2	1
• Wood Blocks 2x4.....	3
• Wood Shims	As Needed
• Dust Hose 4"	As Needed
• Hose Clamp 4"	As Needed

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.

Box 1 (Figure 2)		Qty
A.	Drum Sander (Not Shown)	1
B.	Top Long Brackets	2
C.	Top Short Brackets	2
D.	Bottom Short Brackets	2
E.	Bottom Long Brackets	2
F.	Stand Legs	4
G.	Handwheel	1
H.	Hardware and Tools (Not Shown)	
	—Handwheel w/Handle	1
	—Hex Bolts M8-1.25 x 20	4
	—Hex Nuts M8-1.25	4
	—Flat Washers 8mm	8
	—Carriage Bolts M8-1.25 x 15	24
	—Flange Nuts M8-1.25	24
	—Combination Wrench 8/12mm	1
	—Hex Wrenches 4, 5, 6mm	1 Ea.
	—Flat Washer 5mm	1
	—Cap Screw M5-.8 x 35	1

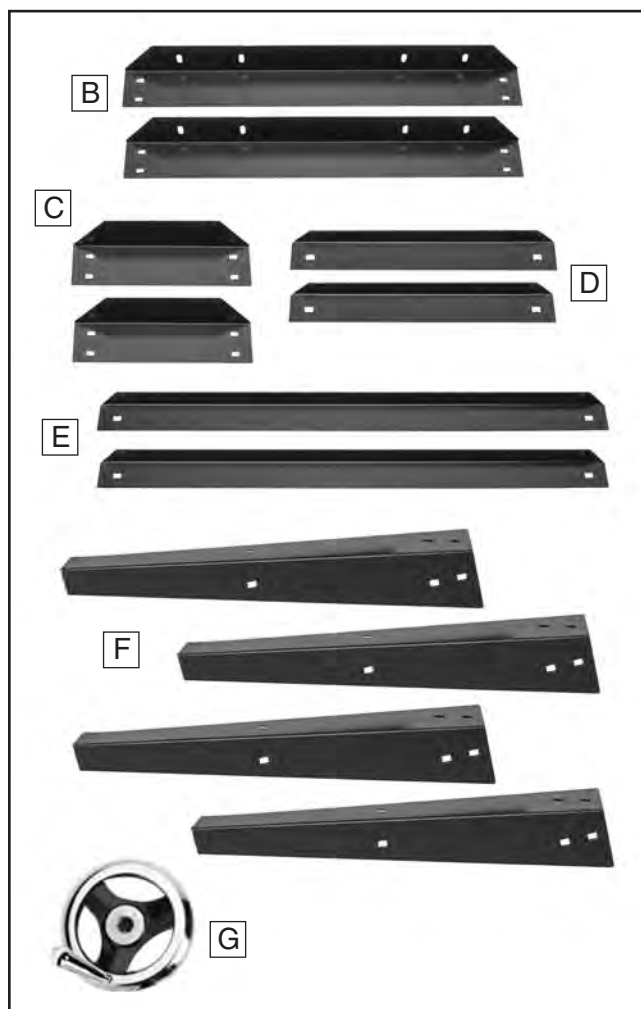


Figure 2. Box contents.

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.



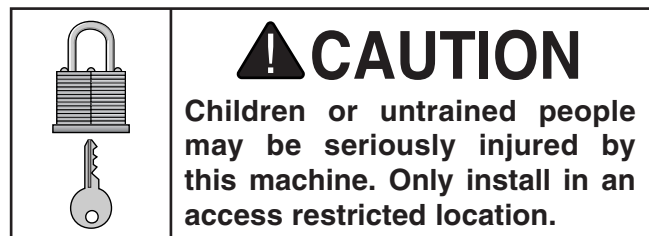
Site Considerations

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.

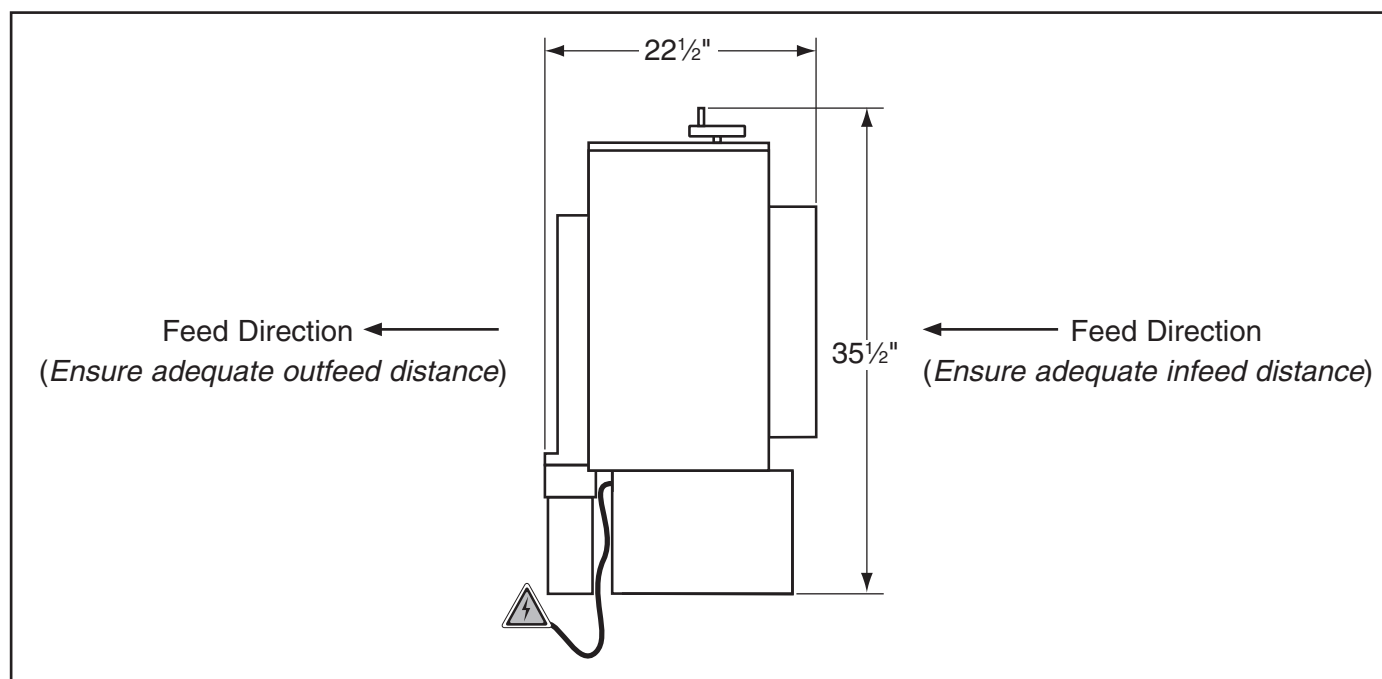


Figure 3. Minimum working clearances.



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).

Note: 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 stand components have been assembled.

To assemble sander:

1. Move sander crate to an appropriate location, as described in **Site Considerations** on previous page.
2. Mount a top long bracket to a stand leg and secure by hand with (2) M8-1.25 x 15 carriage bolts and (2) M8-1.25 flange nuts, as shown in **Figure 4**.
3. Mount a bottom long bracket to stand leg and secure by hand with (1) M8-1.25 x 15 carriage bolt and (1) M8-1.25 flange nut, as shown in **Figure 4**.

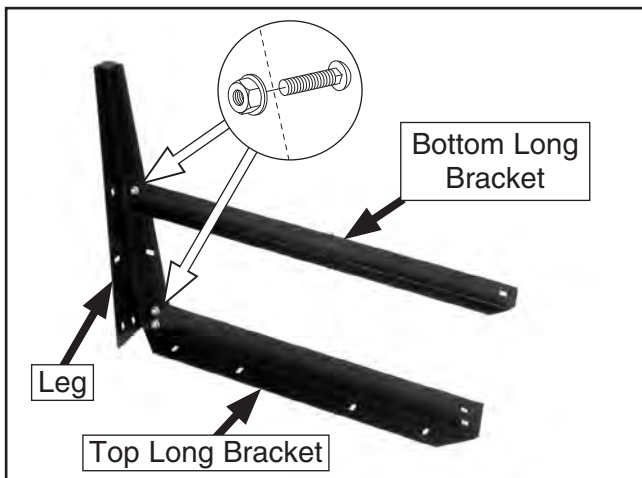


Figure 4. Top and bottom long brackets secured to a stand leg.

4. Secure a second leg to top and bottom long brackets, as shown in **Figure 5**.
5. Repeat **Steps 2–4** with remaining components to build remaining stand leg assembly.

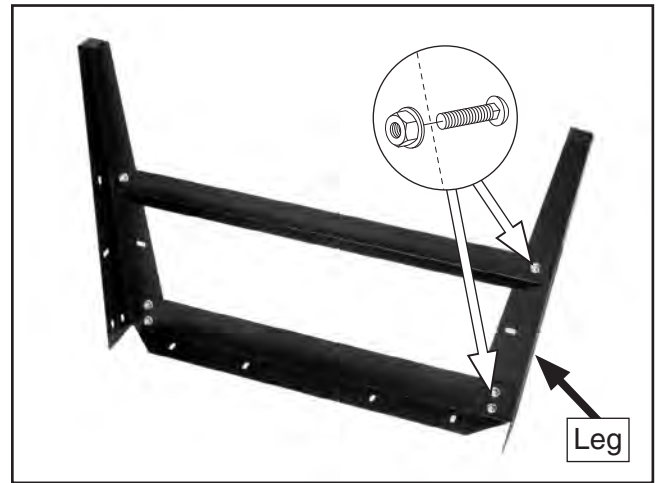


Figure 5. A completed stand leg assembly.

6. Mount top short bracket to stand leg assembly with (2) M8-1.25 x 15 carriage bolts and (2) M8-1.25 flange nuts, as shown in **Figure 6**.
7. Mount bottom short bracket to stand leg assembly with (1) M8-1.25 x 15 carriage bolt and (1) M8-1.25 flange nut, as shown in **Figure 6**.

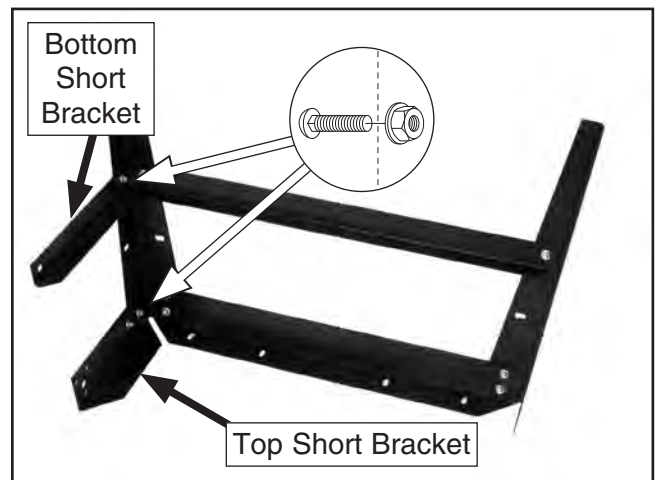


Figure 6. Top and bottom short brackets secured to stand leg assembly.



8. Assemble remaining stand components, as shown in **Figure 7**, with remaining hardware.



Figure 7. Completed stand assembly.

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



10. Make sure sander is still resting on shipping pallet.
11. Place pallet and stand near appropriate location (once sander is mounted to stand it will be difficult to move).

12. With help of an assistant, tilt sander back so side with belt access panel faces pallet, move left bottom edge of sander forward, and rest left side of sander on pallet, as shown in **Figure 8**.

Note: The base should be even with or stick out from the edge of the pallet to properly install stand assembly.



Figure 8. Sander tipped back on pallet against belt access panel.

Tip: Place two stacks of blocks the same height as the pallet and about 15 inches apart on the floor near the sander base, and lay the stand assembly on the blocks, as shown in **Figure 9**.

13. Lay stand assembly on blocks, as shown in **Figure 9**.

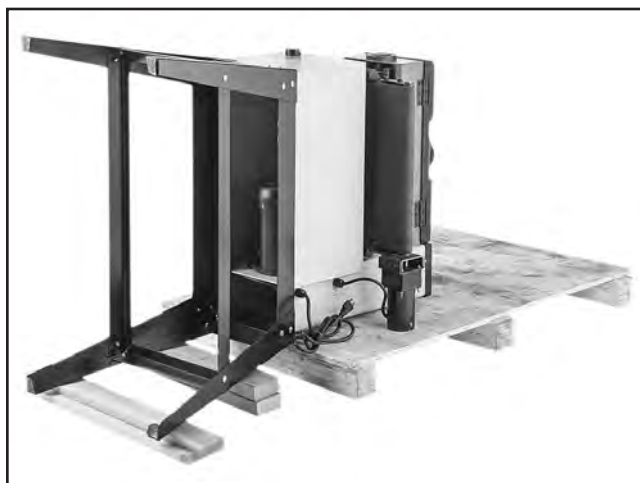


Figure 9. Stand resting on blocks.



14. Secure stand to sander with (4) M8-1.25 x 20 hex bolts, (8) 8mm flat washers, and (4) M8-1.25 hex nuts (see **Figure 10**).

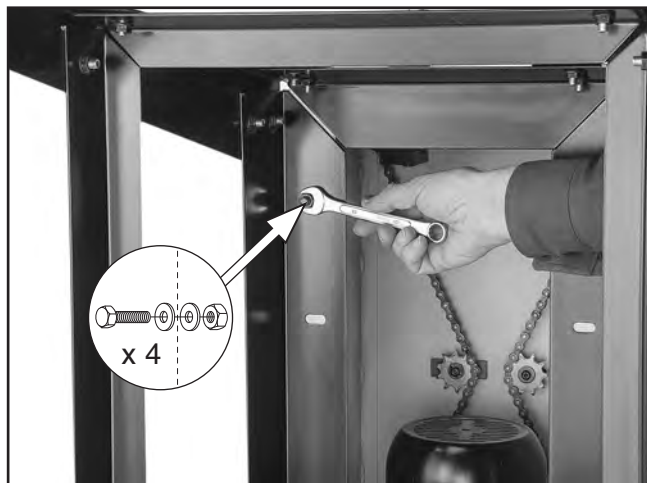


Figure 10. Mounting sander to stand.

15. Lift up on stand and remove blocks.
16. With help from an assistant, carefully tilt sander upright, as shown in **Figure 11**, so rear legs touch the floor.



Figure 11. Tilting sander upright.

! 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!

17. Slide table elevation handwheel over shaft pin (see **Figure 12**) and secure with (1) 5mm flat washer and (1) M6-1 x 35 cap screw.

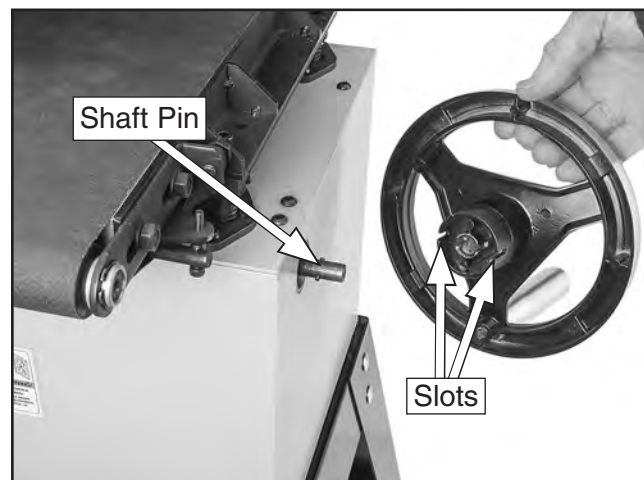


Figure 12. Installing table elevation handwheel.



Dust Collection

⚠ CAUTION

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

Minimum CFM at Dust Port: 400 CFM

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

To connect dust collection system to machine:

1. Fit 4" dust hose over dust port, as shown in **Figure 13**, and secure in place with a hose clamp.

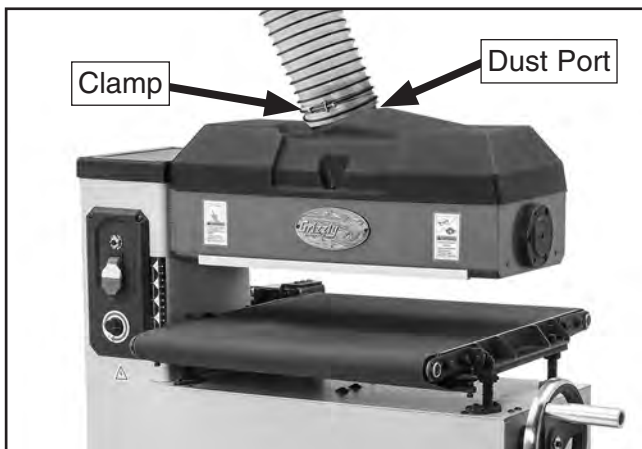


Figure 13. Dust hose and clamp installed.

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

Note: A tight fit is necessary for proper performance.

Test Run

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

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

The Test Run consists of verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the safety disabling mechanism on the switch works correctly.

⚠ WARNING

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

⚠ WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine **ON**, verify motor operation, and then turn machine **OFF**.

The motor should run smoothly and without unusual problems or noises.



4. Remove switch disabling key, as shown in **Figure 14**.

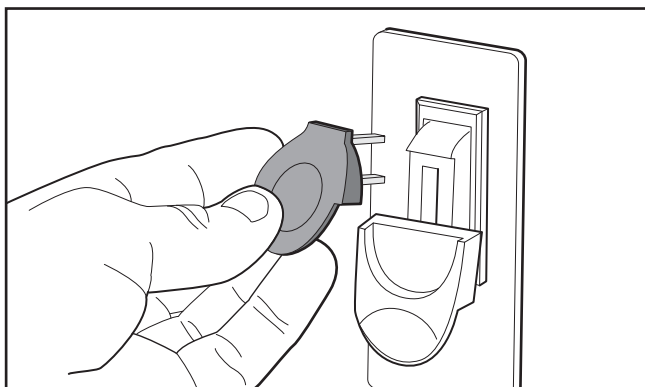


Figure 14. Removing switch key from paddle switch.

5. Try to start machine with paddle switch. The machine should not start.
 - If the machine *does not* start, the switch disabling feature is working as designed.
 - If the machine *does start*, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Recommended Adjustments

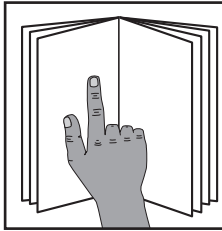
For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping, some of these adjustments may need to be repeated to ensure optimum results.

- **Tensioning V-Belt** (see **Page 31**). Perform after the first 16 hours.
- **Tracking & Tensioning Conveyor Belt** (see **Pages 33 & 35**).
- **Table Adjustments** (see **Page 37**).



SECTION 4: OPERATIONS

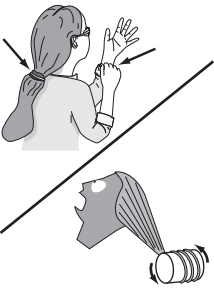
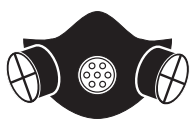


!WARNING

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

!WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



!WARNING

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

NOTICE

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

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

1. Examines workpiece to verify it is suitable for sanding and to determine which sanding belt grit size to use.
2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is wider than conveyor table, operator supports workpiece full width. If workpiece is overly long and difficult to handle, operator uses a roller support stand to assist with feeding.
3. Adjusts table height to approximate workpiece thickness.
4. Puts on required safety glasses and respirator, and ensures dust collection is connected to dust port.
5. Turns motor **ON**.
6. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.

Note: During initial pass with a new workpiece, operator adjusts table height as necessary so workpiece only makes light contact with sanding belt and does not overload sander.
7. Receives workpiece from outfeed side of conveyor table. If workpiece is wider than conveyor table, operator rotates workpiece 180° and feeds workpiece back through sander.
8. Raises height of conveyor table a small amount (typically ¼ of a full rotation of handwheel), then repeats the feeding process of workpiece through sander.
9. Changes sandpaper to a finer grit, as needed.
10. Repeats **Steps 8–11** as needed, turns sander **OFF**, and disconnects it from power.



Stock Inspection & Requirements

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

Before sanding, inspect all workpieces for the following:

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

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

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

Setting 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 depth of cut:

1. Rotate table elevation handwheel (see **Figure 15**) until conveyor table is well below sanding drum, then raise table, allowing a gap between workpiece and sanding drum.

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



Figure 15. Table elevation handwheel.

2. Turn machine **ON** and feed workpiece into sander. SLOWLY raise conveyor belt until workpiece makes light contact with sanding drum. This is the correct height to begin sanding the workpiece.
3. After initial pass, turn handwheel up to $\frac{1}{4}$ turn ($\frac{1}{64}$ " or 0.4mm)—maximum depth for most sanding conditions.

Note: Each full turn of the table elevation handwheel raises the conveyor table approximately 0.060" ($\frac{1}{16}$ " or 1.5mm).



Adjusting Conveyor Feed Rate

The potentiometer (see **Figure 16**) allows you to increase the feed rate from 0–12 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.



Figure 16. Location of conveyor feed rate dial.

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 feed rate:

1. Turn **ON** the conveyor belt (DO NOT adjust conveyor speed when the conveyor motor is **OFF**).
2. Rotate potentiometer (see **Figure 16**) clockwise to increase the feed rate or counterclockwise to decrease the conveyor feed rate.

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 table height according to instructions in **Setting Depth of Cut** on **Page 20**.
2. Make sure dust collection hose and collection system is secured and turned on before turning sander **ON**.
3. Feed workpiece through sander. Retrieve workpiece by standing at the side—not at the outfeed end.
4. Run wide stock through two or three times without adjusting table height. Turn stock 180° between passes to ensure an evenly sanded surface.

NOTICE

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 circuit breaker damage, which is not covered under warranty.



Sanding Tips

- Replace coarse grit sandpaper with a finer grit to achieve a smoother finish.
- Raise the table a maximum of ¼ turn of the handwheel until the workpiece is the desired thickness.
- Reduce snipe when sanding more than one board of the same thickness by feeding them into the sander with the front end of the second board touching the back end of the first board.
- Feed boards into the sander at different places on the conveyor to maximize sandpaper life and prevent uneven conveyor belt wear.
- DO NOT sand boards less than 6" long or less than ⅛" thick to prevent damage to the workpiece and the drum sander.
- Extend the life of the sandpaper by regularly using a PRO-STIK® sanding pad (see **Page 28**).
- When sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When the drum moves from sanding a wide surface to sanding a narrow surface, the load on the motor will be reduced, and the drum will speed up, causing a gouge.
- DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury. Edge sanding boards also can cause damage to the conveyor belt and sandpaper.
- When sanding workpieces with a bow or crown, place the high point up (prevents the workpiece from rocking) and take very light passes.
- Feed the workpiece at an angle to maximize stock removal and sandpaper effectiveness, but feed the workpiece straight to reduce sandpaper grit scratches for the finish passes.

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.

Grit	Class	Usage
60	Coarse	Fast sanding, dimensioning, and glue removal.
80–100	Medium	Removing planer marks and initial finish sanding.
120–180	Fine	Finish sanding.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers, with no 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.



Replacing Sandpaper

The Model G0458Z is designed for 3" wide sandpaper rolls. Turn to **SECTION 5: ACCESSORIES** on **Page 26** for grit selection and model numbers.

Items Needed	Qty
Flat Head Screwdriver	1
Hex Wrench 4mm.....	1
Hex Wrench 5mm.....	1
Carton Cutter or Utility Knife	1

To change sandpaper:

1. DISCONNECT MACHINE FROM POWER!
2. Open top cover and loosen cap screw on right spring-loaded clamp, as shown in **Figure 17**.

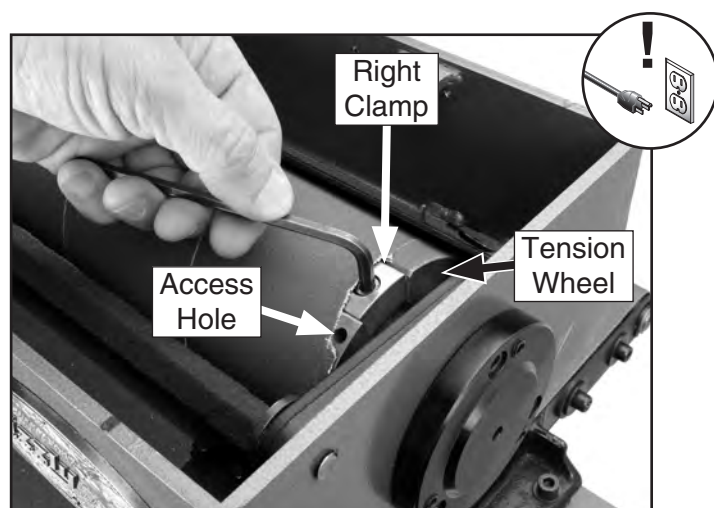


Figure 17. Example of loosening cap screw on right spring-loaded clamp (dust hood removed for clarity).

3. Remove sandpaper from clamp. Use a flat head screwdriver, if necessary, to loosen clamp to free sandpaper.
4. 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 18**.

5. Loosen cap screw on left clamp and fully remove sandpaper strip.
6. Use old sandpaper strip as a pattern, if at all possible. Otherwise, use pattern in **Figure 18**, to cut a new piece of sandpaper to the necessary shape. After cutting the 12" angled sides, measure 2" along same sides and cut off ends with a knife.

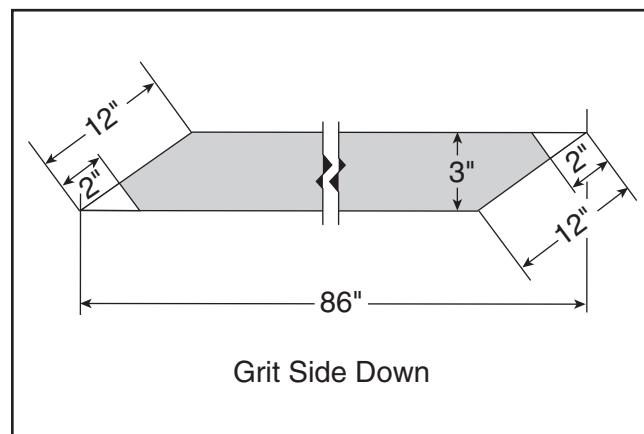


Figure 18. Sandpaper pattern for drum.

7. Insert corner of new sandpaper into left clamp and tighten cap screw, as shown in **Figure 19**.

Note: 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.

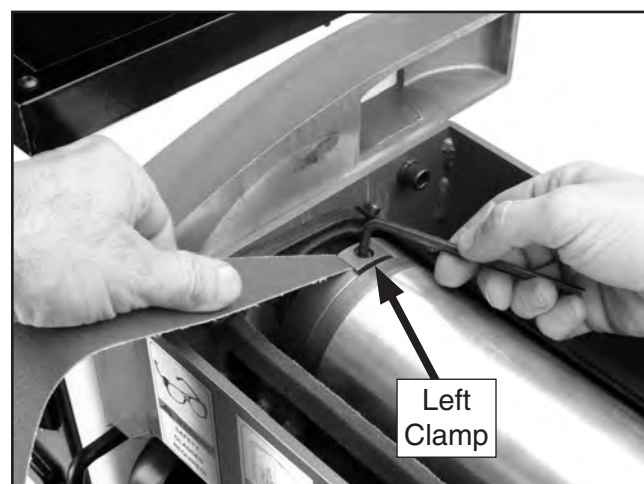


Figure 19. Securing sandpaper in left clamp.



8. Wrap sandpaper around drum (see **Figure 20**), ensuring there are no bubbles or overlapping edges.



Figure 20. Wrapping sandpaper around drum.

9. When sandpaper reaches right side of drum, move sandpaper out of the way with a 4mm hex wrench and place it into access hole.
10. Rotate drum toward you so hex wrench rests against frame, as shown in **Figure 21**.

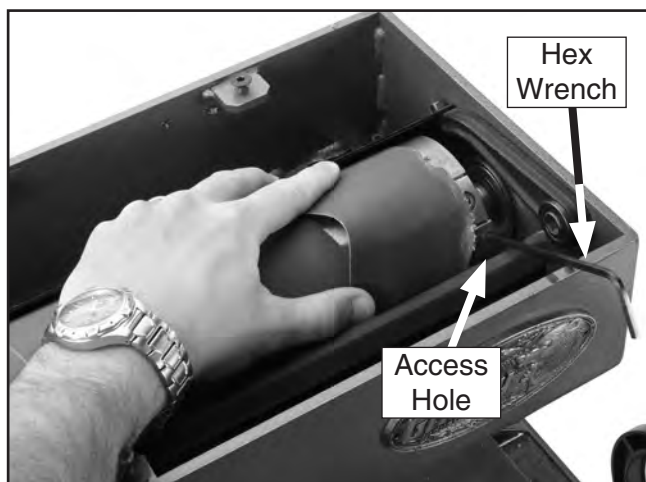


Figure 21. Hex wrench inserted into access hole on right tension wheel.

11. Firmly hold down sandpaper with both hands, rotate drum toward you, then wrap end of sandpaper over top of the drum (see **Figure 22**).

Note: Only put enough tension on sandpaper so it fits into clamp in next step. Do not over-tighten it. Doing so can damage drum spring.



Figure 22. Wrapping sandpaper over tension wheel.

12. Place end of sandpaper into clamp, secure it, and remove hex wrench from access hole. Sandpaper should seat flat against roller and not overlap at any point.
- If the sandpaper *does not* fit into the right clamp, you may have inserted sandpaper too deeply into left clamp. Also, check to make sure the length, width, and angled cuts match the pattern in **Figure 18**. Make adjustments to sandpaper if necessary.
 - If sandpaper completely covers access hole, you may have placed too little sandpaper into left clamp. Unwrap sandpaper and repeat **Steps 7–12**.
13. In either case, re-install sandpaper, repeat **Steps 7–12**, and continue adjusting paper until it fits into clamp.
14. When finished, reconnect dust collection system.



Changing Sanding Drum Speeds

This machine features two different sanding speeds, which are controlled by belt position on the pulleys (see **Figure 23**).

IMPORTANT: Proper belt tension is important for optimum power transmission. Any time pulley adjustments are made, be sure to re-tension the belt.

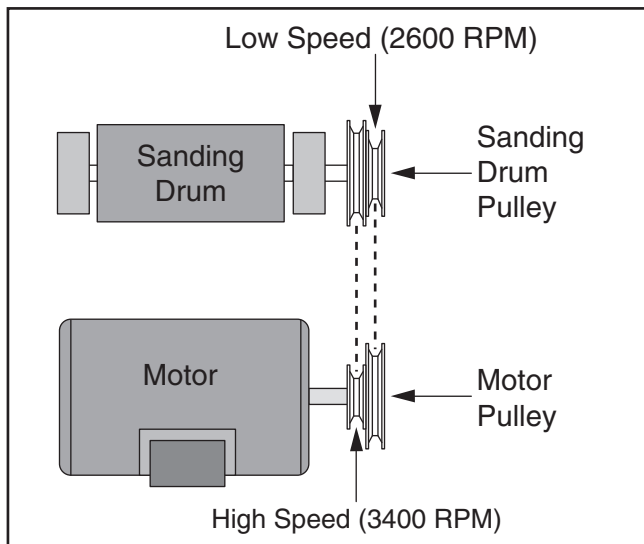


Figure 23. Pulley speed settings.

Tools Needed: Qty
Hex Wrenches 4, 8mm..... 1 Ea.

To adjust V-belt location:

1. DISCONNECT MACHINE FROM POWER!
2. Remove the pulley cover.

3. Loosen the motor mount cap screws shown in **Figure 24**, and lift motor pulley to de-tension belt.
4. Tighten motor mount cap screws to keep motor de-tensioned during belt change.

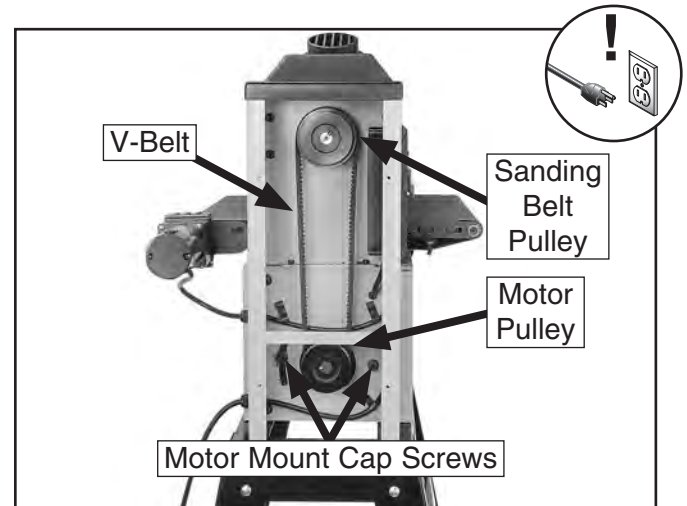


Figure 24. Belt drive system.

5. Roll V-belt onto correct pulley for sanding operation, and follow steps outlined in **Tensioning V-Belt** on **Page 31** to properly tension belt before operation.



SECTION 5: ACCESSORIES

WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

Aluminum Oxide Sanding Rolls 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—1 HP Floor Model Dust Collector

G0710—1 HP 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.

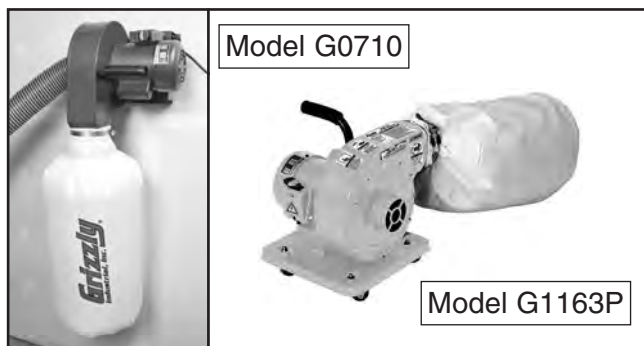


Figure 25. Point-of-use dust collectors.

Basic Eye Protection

T32323—Woodturners Face Shield

T32401—EDGE Brazeau Safety Glasses, Clear

T32402—EDGE Khor G2 Safety Glasses, Tint

T32404—EDGE Mazeno Safety Glasses, Clear



Figure 26. Assortment of basic eye protection.

T28172—14" x 39" Heavy-Duty Roller Table

T28369—14" x 78" Heavy-Duty Roller Table

T28370—14" x 118" Heavy-Duty Roller Table

Increase material handling and processing efficiency with one or more of these Heavy-Duty Roller Tables. Ideal for easily positioning material for cross cutting or cutting to length using a chop saw or metal cutting bandsaw. Simply place a roller table on one or both sides of your saw and production time is automatically improved!

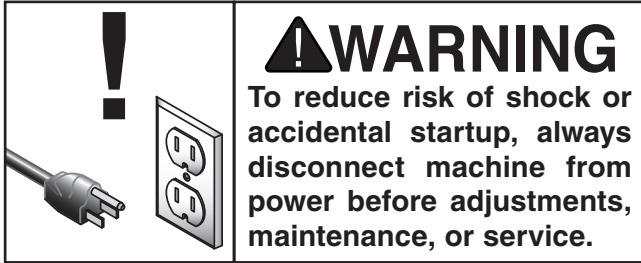


Figure 27. Heavy-duty roller tables.

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

- Loose 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.

Cleaning

Cleaning the Model G0458Z 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 ISO 32 (Model T26685) Multi-Function Machine Oil. The bearings do not need lubrication.

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

Bushings

Oil Type T26685 ISO 32 Machine Oil
Oil Amount..... As Needed
Check/Add Frequency Daily

Oil the drive bushings on each end of the feed belt rollers and remove the belt access cover to access the drive bushings (see **Figure 28**).

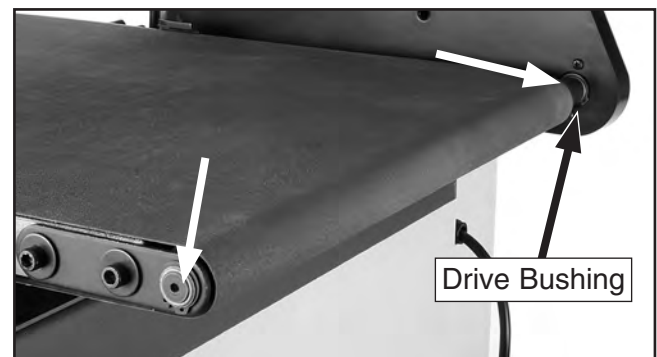


Figure 28. Bushing lubrication locations.



Bushings

Oil TypeModel T26419 NLGI#2
Oil Amount..... As Needed
Check/Add Frequency 6 Months

Lubricate the table lift screws, chain, and helical gear with lithium grease every six months. Clean the chain and table lift screws (see **Figure 29**), then apply grease onto the chain links and screw threads. Clean the helical gear (see **Figure 30**) and place a dab of grease on the teeth. Move the table up or down to spread the grease thoroughly throughout the mechanism.

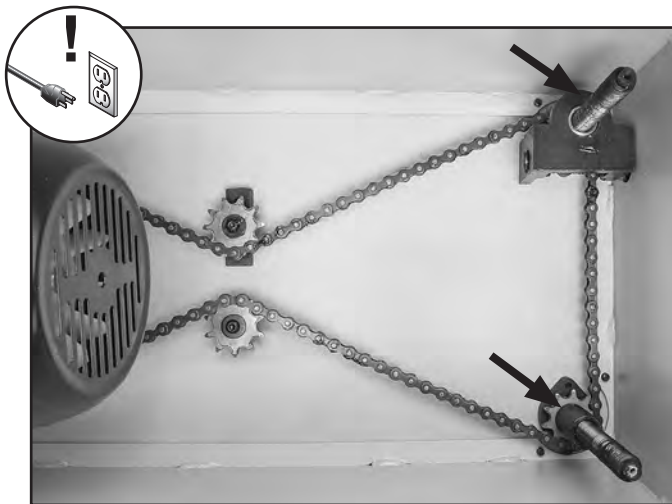


Figure 29. Table lift screws (2 of 4 shown).



Figure 30. Helical gear.

Cleaning Sanding Belts

To increase the working life of your sanding belts, clean them whenever they decrease in performance due to heavy loading of material. Use a Model D3003 PRO-STIK® Cleaning Pad as shown in **Figure 31**.

To clean sanding belt:

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

Model D3003 PRO-STIK® Cleaning Pad

Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your drum sander to remove dust build-up from the sandpaper without damage. Measures 15" x 20" x $\frac{3}{4}$ ".



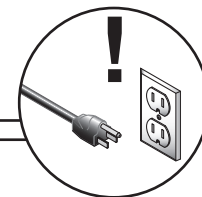
Figure 31. D3003 PRO-STIK® Cleaning Pad.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. Switch disabling key removed. 2. Incorrect power supply voltage or circuit size. 3. Machine circuit breaker tripped. 4. Circuit board fuse blown. 5. Variable speed dial at fault. 6. Start capacitor at fault. 7. Motor wires connected incorrectly. 8. Power supply circuit breaker tripped or fuse blown. 9. Centrifugal switch/contact points is at fault. 10. Wiring open/has high resistance. 11. Motor at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key. 2. Ensure correct power supply voltage and circuit size. 3. Reset circuit breaker on switch. 4. Replace fuse/ensure no shorts. 5. Test/repair if at fault. 6. Test/repair if at fault. 7. Correct motor wiring connections (Page 42). 8. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 9. Test/repair/replace. 10. Check/fix broken, disconnected, or corroded wires. 11. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Workpiece material is not suitable for machine. 2. Feed rate/cutting speed too fast. 3. Machine undersized for task. 4. V-belt is slipping. 5. Plug or receptacle at fault. 6. Run capacitor at fault. 7. Motor bearings at fault. 8. Motor overheated, tripping machine circuit breaker. 9. Centrifugal switch at fault. 10. Motor is at fault. 	<ol style="list-style-type: none"> 1. Only sand wood; ensure moisture is below 20% and there are no foreign materials in the workpiece. 2. Decrease feed rate/cutting speed. 3. Clean/replace sandpaper; reduce feed rate/sanding depth. 4. Replace bad belt, align pulleys, and re-tension V-belt (Pages 31 & 32). 5. Test for good contacts/correct wiring. 6. Test/repair/replace. 7. Test/repair/replace. 8. Clean motor/let cool, and reduce workload. Reset breaker. Test/repair/replace. 9. Test/replace. 10. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Machine undersized for task. 2. Motor or component loose. 3. V-belt is worn, loose, or misaligned. 4. Pulley loose. 5. Motor fan rubbing on fan cover. 6. Motor mount loose/broken. 7. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Reduce feed rate/sanding depth. 2. Inspect/replace damaged bolts/nuts, and re-tighten with thread-locking fluid. 3. Inspect/replace belt; realign pulleys (Pages 31 & 32). 4. Realign/replace shaft, pulley, set screw, and key. 5. Replace dented fan cover/damaged fan. 6. Tighten/replace. 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Operation

Symptom	Possible Cause	Possible Solution
Grinding, screeching, or rubbing noise when sanding drum is powered up.	1. Drum bearings are worn and need replacement.	1. Replace drum bearings.
Short V-belt lifespan.	1. Pulleys not aligned correctly. 2. Improperly tensioned.	1. Align pulleys (Page 32). 2. Properly tension V-belt (Page 31).
Machine lacks power; drum stops turning under load.	1. V-belt loose. 2. Too much pressure on sanding drum.	1. Tighten V-belt (Page 31). 2. Lower conveyor table (Page 38).
Conveyor belt slips under load.	1. Belt tension not properly adjusted. 2. Belt tracking not properly adjusted. 3. Conveyor belt worn. 4. Workpiece too heavy.	1. Properly adjust belt tension (Page 35). 2. Properly adjust belt tracking (Page 33). 3. Replace conveyor belt (Page 36). 4. Use lighter workpiece.
Conveyor belt tracks to one side or hits the conveyor table mounts.	1. Conveyor belt tracking is incorrect.	1. Track the conveyor belt so it runs straight (Page 33).
Excessive snipe.	1. Lack of outfeed support. 2. Too much pressure from pressure rollers. 3. Too much pressure from the rear pressure roller.	1. Set up an outfeed table or have someone catch the workpiece as it comes out. 2. Raise pressure rollers (Page 38). 3. Raise rear pressure roller (Page 38).
Workpiece kicks out of sander.	1. Not enough pressure from pressure rollers.	1. Lower pressure roller (Page 38).
Sandpaper comes off drum or is loose.	1. Sandpaper not properly wrapped onto drum. 2. Sandpaper not cut to correct dimensions. 3. Torn or damaged sandpaper. 4. Sandpaper not tightened or fastened correctly. 5. Sanding drum not parallel with table.	1. Re-install sandpaper (Page 23). 2. Use sandpaper cut to correct dimensions (Page 23). 3. Replace sandpaper (Page 23). 4. Re-install sandpaper (Page 23). 5. Adjust sanding drum parallel to table (Page 37).
Table elevation controls are stiff and hard to adjust.	1. Table lift screws are dirty or loaded with sawdust. 2. Chain idler sprocket cap screws have been over tightened. 3. Elevation handwheel helical gear is dirty or loaded with sawdust.	1. Clean and re-grease table lift screws (Page 28). 2. Adjust the cap screws on the idler sprocket so it can spin freely. 3. Clean and re-grease the helical gear (Page 28).
Burn marks on workpiece.	1. Using too fine of sanding grit for depth of cut. 2. Sandpaper loaded with sawdust and gum 3. Feed rate too slow. 4. Sandpaper not properly wrapped onto drum. 5. Worn sandpaper.	1. Using too fine of sanding grit for depth of cut. 2. Sandpaper loaded with sawdust and gum 3. Feed rate too slow. 4. Sandpaper not properly wrapped onto drum. 5. Worn sandpaper.
Workpiece sanded on only one side.	1. Sanding drum not parallel with table.	1. Adjust sanding drum parallel to table (Page 37).



Tensioning V-Belt

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 $\frac{1}{2}$ "– $\frac{3}{4}$ " when pushed in the middle with moderate pressure. See **Figure 32** for an example of how to perform a V-belt deflection test with a straightedge and ruler.

Items Needed	Qty
Hex Wrenches 4 & 8mm	1 Ea.
Phillips Head Screwdriver #2	1
Straightedge	1
Ruler	1

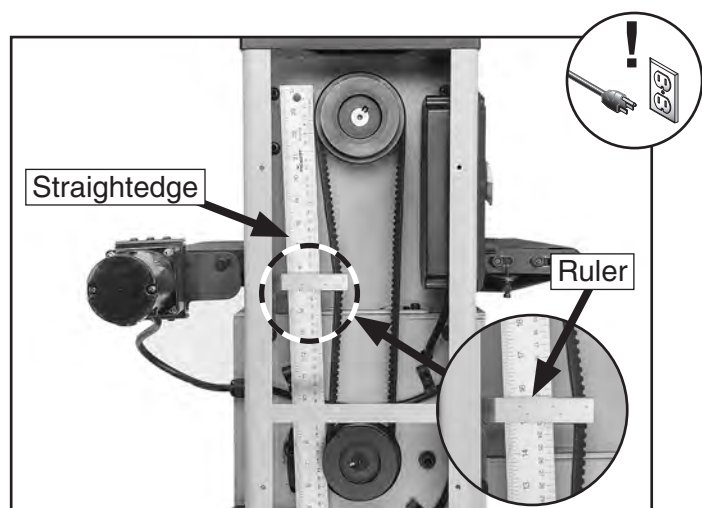


Figure 32. Checking V-belt tension with a straightedge and a ruler (belt access panel removed).

⚠ CAUTION

Always inspect V-belt 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 MACHINE FROM POWER!
2. Open belt access panel.
3. Check tension of V-belt, then adjust tension by loosening motor mount cap screws shown in **Figure 33**.

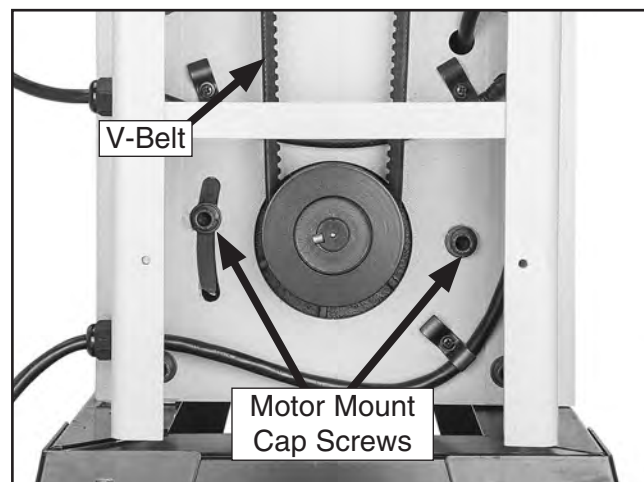


Figure 33. Feed belt V-belt tension.

4. Tension V-belt by pushing down on bottom motor pulley with one hand, then tighten motor mount cap screws and check belt tension.
5. Repeat **Steps 3-4** as needed until V-belt is correctly tensioned, then replace belt access panel.

NOTICE

New V-belts will often stretch and loosen after approximately 16 hours of use. Check frequently after installation and re-tension if necessary.



Changing V-Belt

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

V-belt removal and replacement is simply a matter of loosening the V-belt, rolling it off of the pulleys, replacing it with a new belt, then re-tensioning pulleys.

Items Needed	Qty
Hex Wrenches 4, 8mm.....	1 Ea.
Phillips Head Screwdriver #2	1
V-Belt (Part P0458Z069)	1
Straightedge	1

To replace V-belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove pulley belt access cover.
3. Loosen motor mount cap screws shown in **Figure 34**.
4. Lift motor pulley to de-tension belt, and tighten motor mount cap screws (see **Figure 34**) to keep motor de-tensioned during belt change.

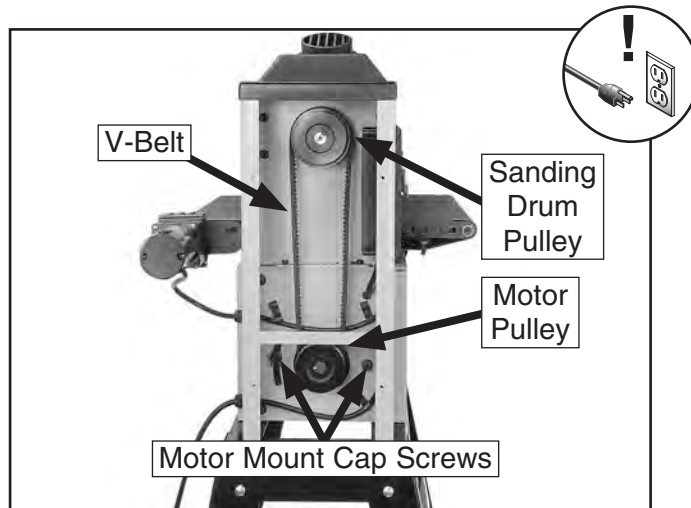


Figure 34. Belt drive system.

5. Roll V-belt off both pulleys and install new V-belt on pulley grooves for desired speed setting (see **Adjusting Sanding Drum Speeds** on **Page 25**).
6. Properly tension V-belt (see **Tensioning V-Belt** on **Page 31** for more information).

NOTICE

New V-belts will often stretch and loosen after approximately 16 hours of use. Check frequently after installation and re-tension if necessary.

7. Re-install V-belt cover from **Step 2**.

Aligning Pulleys

Pulley alignment is an 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.

Items Needed	Qty
Hex Wrenches 4, 8mm.....	1 Ea.
Phillips Head Screwdriver #2	1
Pry Bar	1

To align pulleys:

1. DISCONNECT MACHINE FROM POWER!
2. Open pulley cover.
3. Looking from top, sight down outside face of pulleys to see if pulleys are parallel and aligned with each other (see **Figure 35**).

— If pulleys *are* aligned, go to **Step 9**.

— If pulleys are *not* aligned, perform **Steps 4–8**.



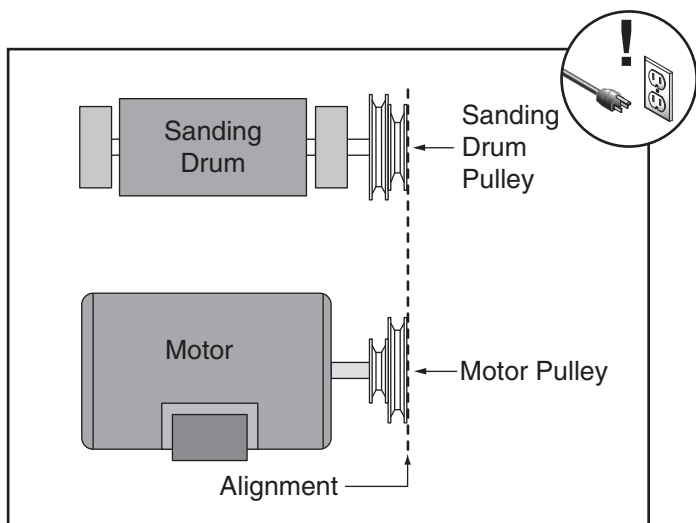


Figure 35. Proper pulley alignment for optimum power transmission.

4. Remove the V-belt (refer to **Changing V-Belt** on **Page 32**).
5. Loosen motor pulley set screws and sanding drum pulley set screws and align both pulleys (see **Figure 36**).

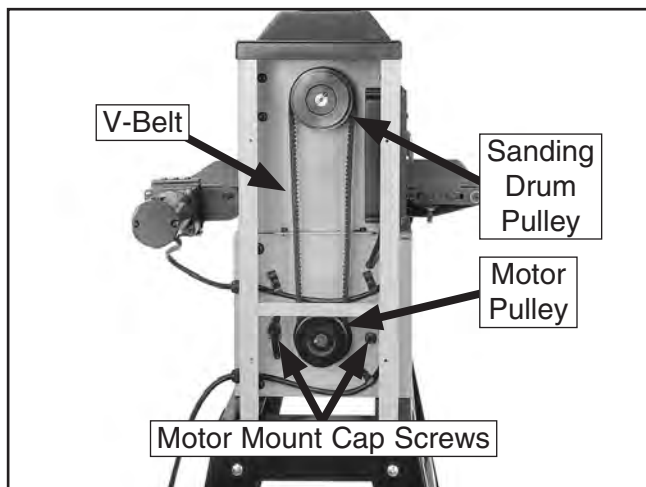


Figure 36. Belt drive system.

6. Tighten the set screws, replace the V-belt, and repeat **Step 3** to verify proper pulley alignment. Pulleys should be parallel and aligned, as shown in **Figure 35**, when belt is properly tensioned.
7. Replace the pulley cover.

Tracking Conveyor Belt

The conveyor belt must track straight. If the feed belt tracks to either side, then the tracking must be corrected or the conveyor belt will become damaged and have to be replaced. The tracking was properly set at the factory, but it is the responsibility of the end user to keep it tracking properly during the life of the machine.

Tracking the conveyor belt is a balancing process that takes patience and a small degree of trial-and-error.

You begin coarse tracking adjustment by rotating the right conveyor belt adjustment bolt clockwise or counterclockwise. If the belt continues to track to one side then you must over-tighten the loose side (the side the belt is tracking towards) to make the conveyor 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 tracking screw too much either way, then you have to repeat the process until the conveyor belt rides in the middle and stays there during continuous operation.

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

Items Needed	Qty
Wrench 8mm	1
Hex Wrench 4mm.....	1

CAUTION

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



To track conveyor belt:

1. Turn conveyor belt **ON** and watch it track.
 - If the belt tracks evenly, leave it alone.
 - If the belt tracks toward the right, loosen lock nut shown in **Figure 37** and rotate the right-side conveyor belt adjustment bolt *counterclockwise* to move belt left.
 - If the belt tracks toward the left, loosen lock nut shown in **Figure 37** and rotate the right-side conveyor belt adjustment bolt *clockwise* to move belt right.

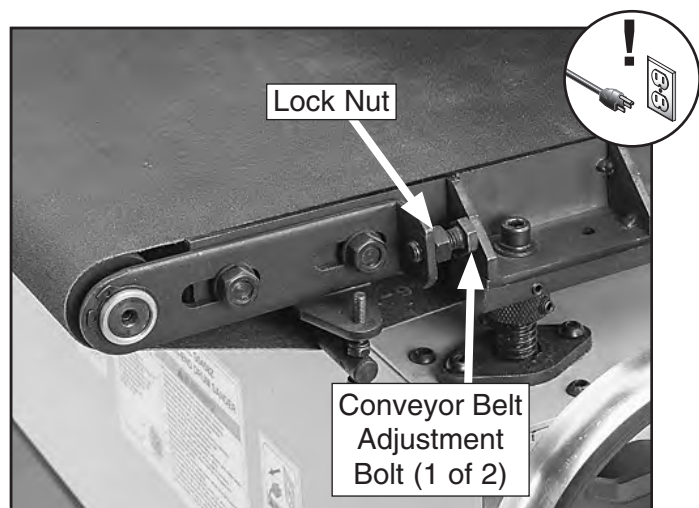


Figure 37. Conveyor coarse tracking controls.

2. After adjustments are made, run machine for approximately 15 minutes to watch the tracking adjustments you made. Be patient, belt tracks slowly.
 - If the belt tracks evenly, leave it alone.
 - If the belt moves to one side, immediately stop the machine and adjust the belt tracking before running the conveyor again. Proceed to **Step 3**.

3. Loosen lock nut (see **Figure 38**) on side that conveyor belt tracks towards and tension tracking adjustment screw until conveyor belt tracks in opposite direction.

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

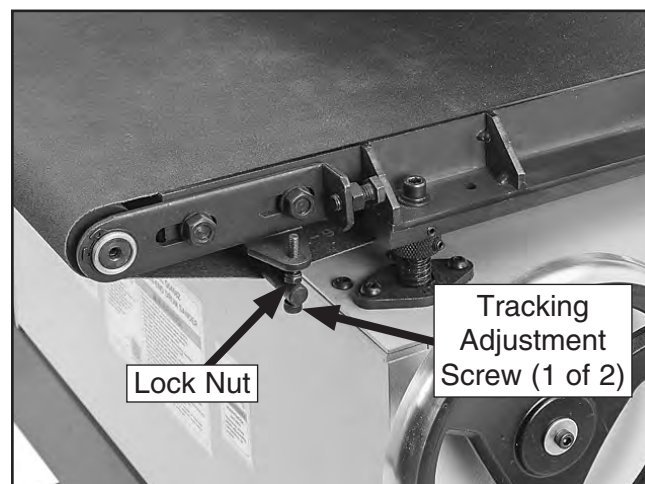


Figure 38. Conveyor fine tracking controls.

4. When conveyor belt is near the middle of the rollers or table, loosen tracking adjustment screw until feed belt stops moving and tracks straight.
 - If conveyor belt tracks too far to the other side, loosen tracking adjustment screw as necessary to bring it back.
5. Repeat **Steps 3–4** until tracking is correct.



Tensioning Conveyor Belt

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

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

Items Needed	Qty
Wrench 12mm	2
Hex Wrench 6mm.....	1

⚠ CAUTION

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

To tension conveyor belt:

1. Loosen feed roller lock nuts, shown in **Figure 39**, on both sides of conveyor belt.

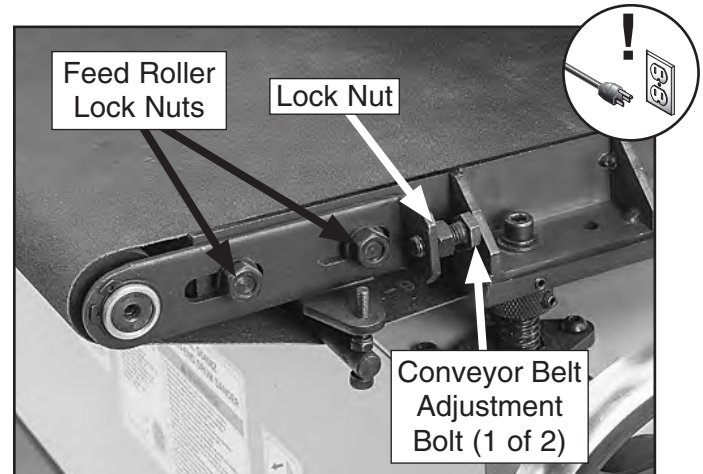


Figure 39. Conveyor belt tensioning controls.

2. Use a permanent marker, paper correction fluid, or fingernail polish to mark conveyor belt adjustment 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 lock nuts and turn both conveyor belt adjustment bolts clockwise one full turn at a time until feed belt no longer slips during operation.
 - If conveyor belt starts tracking to one side, back off the conveyor belt adjustment bolt that is being adjusted.
 - If conveyor belt continues tracking to one side, immediately turn drum sander **OFF** and perform tracking instructions.
4. Tighten lock nuts to lock conveyor belt adjustment bolts in place.

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

NOTICE

DO NOT over-tension the conveyor belt. This may cause premature wearing of belt, bushings, and cause strain on the motor.



Replacing Conveyor Belt

Replacing the conveyor belt is a relatively simple process, but it will require re-tensioning and tracking once the new conveyor belt is installed.

Items Needed	Qty
Wrench 12mm	2
Hex Wrench 6mm.....	1
An Assistant	1

To replace conveyor belt:

1. DISCONNECT MACHINE FROM POWER!
2. Use a permanent marker to mark the front of the conveyor belt adjustment bolt (see **Figure 40**) on both sides. This step will aid you in returning the bolts to their original position, reducing the amount of tracking necessary.
3. Loosen lock nuts shown in **Figure 40**. Turn both of the conveyor belt adjustment bolts counterclockwise one full turn at a time to release tension from feed belt.

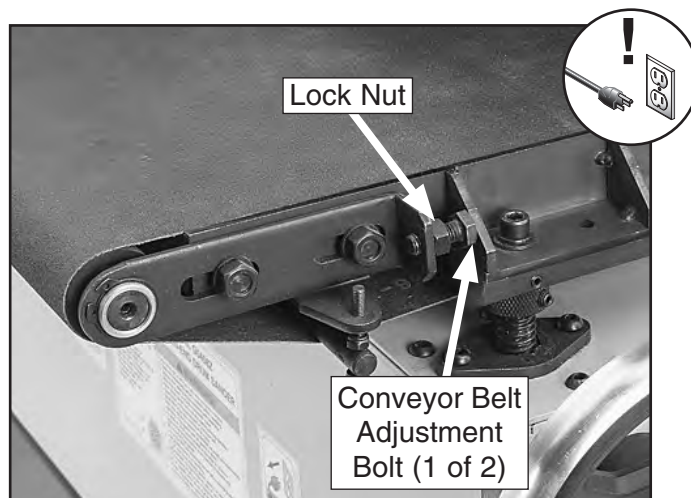


Figure 40. Conveyor belt tensioning controls.

4. Remove outside table cap screws shown in **Figure 41** and loosen corresponding cap screws on inside edge.



Figure 41. Feed belt table outside cap screws.

5. Have an assistant lift outside edge of the table, then slide conveyor belt off.
6. Clean any dirt or dust off of table and rollers, have an assistant lift the table, then slide the new conveyor belt on.
7. Re-install and tighten all of the table cap screws.
8. Tighten conveyor belt adjustment bolts equally, then follow tensioning instructions on **Page 35**.
9. Track new conveyor belt according to instructions on **Page 34**.

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

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



Making Blocks

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

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

To make blocks:

1. Edge joint concave edge of 2x4 flat on a jointer, as shown in **Figure 42**.

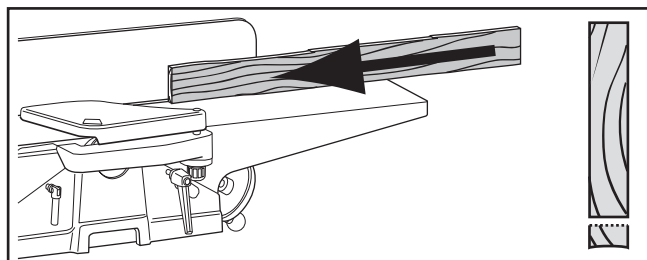


Figure 42. Edge jointing on a jointer.

2. Place 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 43**.

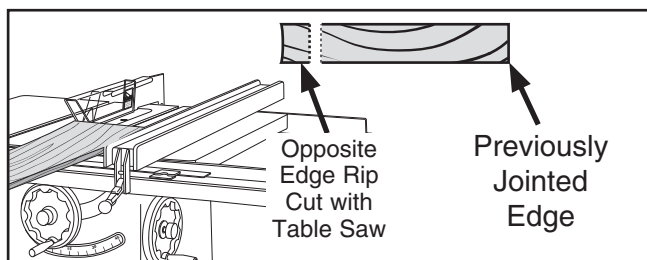


Figure 43. Rip cutting on a table saw.

3. Cut 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.*

Aligning Drum

Aligning the drum parallel to the conveyor belt (see **Figure 44**) 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.

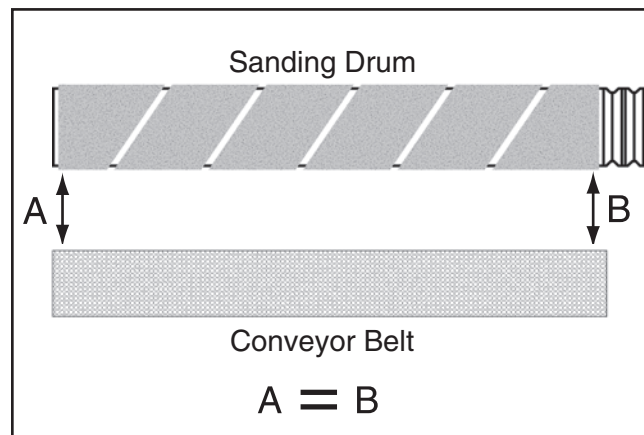


Figure 44. Drum parallel to conveyor belt.

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

To align sanding drum:

1. DISCONNECT MACHINE FROM POWER!
2. Remove sandpaper from drum and place gauge blocks as shown in **Figure 45**.



Figure 45. Example of gauge blocks placed under drum.



3. Raise table until 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 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 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" of the other. Continue to the next step.
7. Loosen table cap screws and adjust height of table by rotating adjustment knob shown in **Figure 46**.

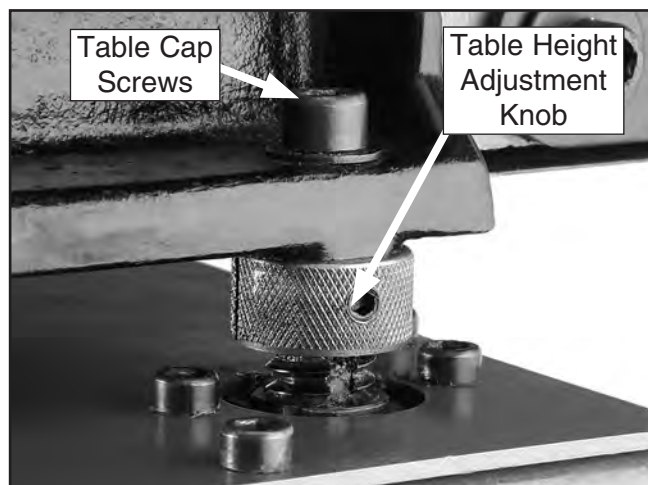


Figure 46. Table height adjustment knob.

8. Tighten table cap screws and repeat **Steps 5–6**.

Aligning Pressure Rollers

Two spring-loaded pressure rollers help maintain consistent pressure on the workpiece as it passes the sanding drum. The pressure rollers have been set correctly at the factory. **DO NOT** adjust the pressure rollers unless absolutely necessary.

When properly positioned, the pressure rollers should be approximately 0.004" lower than the drum.

Adjusting the pressure rollers 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.

Items Needed	Qty
Wrench 8mm	1
Hex Wrench 4mm.....	1
Gauge Blocks (see Page 37)	2
Feeler Gauge Set	1

To check pressure rollers:

1. DISCONNECT MACHINE FROM POWER!
2. Place gauge blocks on feed belt as shown in **Figure 47**.



Figure 47. Example of gauge blocks placed under drums.



3. Raise table until blocks just touch the rear pressure roller.
4. Find the largest size feeler gauge that can pass between sanding drum and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing drum to roll.)
 - If gap is 0.004" (0.1mm) or less, then no adjustment of rear pressure roller is necessary.
 - If gap is more than 0.004" (0.1mm), then rear pressure roller must be adjusted.
5. Raise table until gauge blocks just touch the drum.
6. Find the largest size feeler gauge that can pass between the front pressure roller 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 front pressure plate is necessary.
 - If the gap is more than 0.004" (0.1mm), then front pressure plate must be adjusted.

To adjust rear pressure roller:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen hex nut securing tensioner cap screws on both ends of rear pressure roller shown in **Figure 48**.

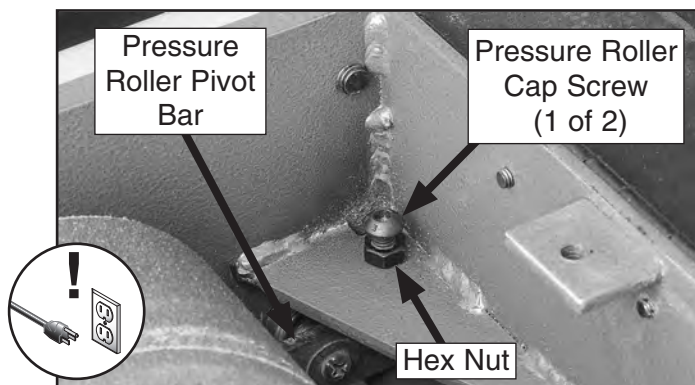


Figure 48. Rear pressure roller adjustments.

3. Rotate cap screw clockwise to raise the pressure roller, or counterclockwise to lower pressure roller.
4. Adjust rear pressure roller until it is equal to or up to 0.004" (0.1mm) lower than height of the drum.

To adjust front pressure roller:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen hex nut securing adjustment cap screws on both ends of rear pressure roller shown in **Figure 49**.
3. Rotate cap screw clockwise to raise pressure roller, or counterclockwise loosen cap screw to lower pressure roller.

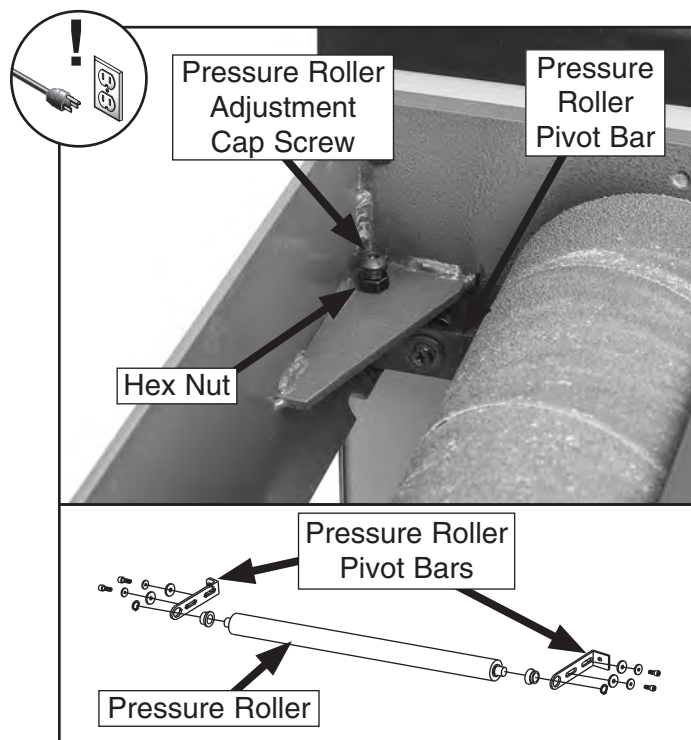


Figure 49. Front pressure roller adjustments and pressure roller overview.

4. Adjust rear pressure roller until it is equal to, or up to 0.004" (0.1mm) lower than height of the drum.

Replacing Brushes

This sander is equipped with a universal motor that uses two carbon brushes to transmit electrical current inside the motor. These brushes are considered to be regular "wear items" or "consumables" that will need to be replaced during the life of the motor. The frequency of required replacement is often related to how much the motor is used and how hard it is pushed.

Replace the carbon brushes (part number: P0458Z042-1) at the same time when the motor no longer reaches full power, or when the brushes measure less than $\frac{1}{4}$ " long (new brushes are $\frac{5}{8}$ " long).

Tools Needed:	Qty
Standard Screwdriver #2.....	1

To inspect and replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!

2. Remove brush caps and worn brushes (see **Figure 50**) from conveyor belt motor.

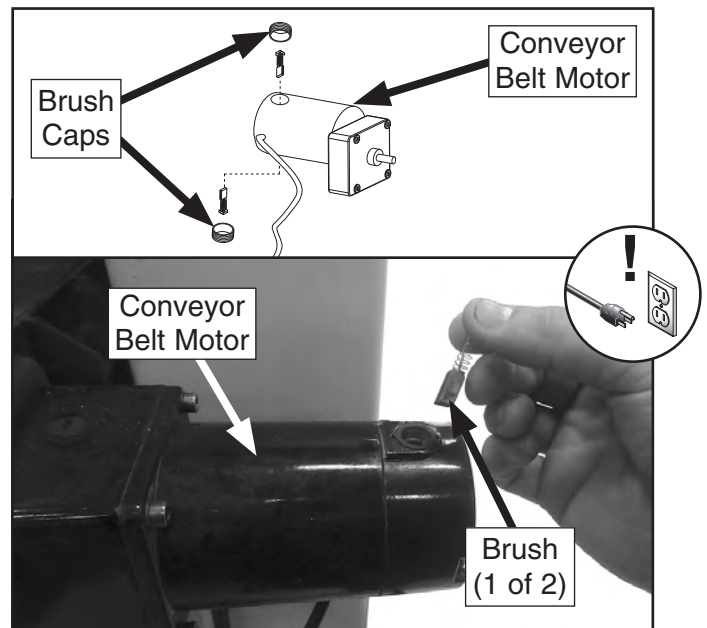


Figure 50. Location of motor cover cap screws.

3. Replace both motor brushes and install brush caps.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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
















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

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

NOTICE

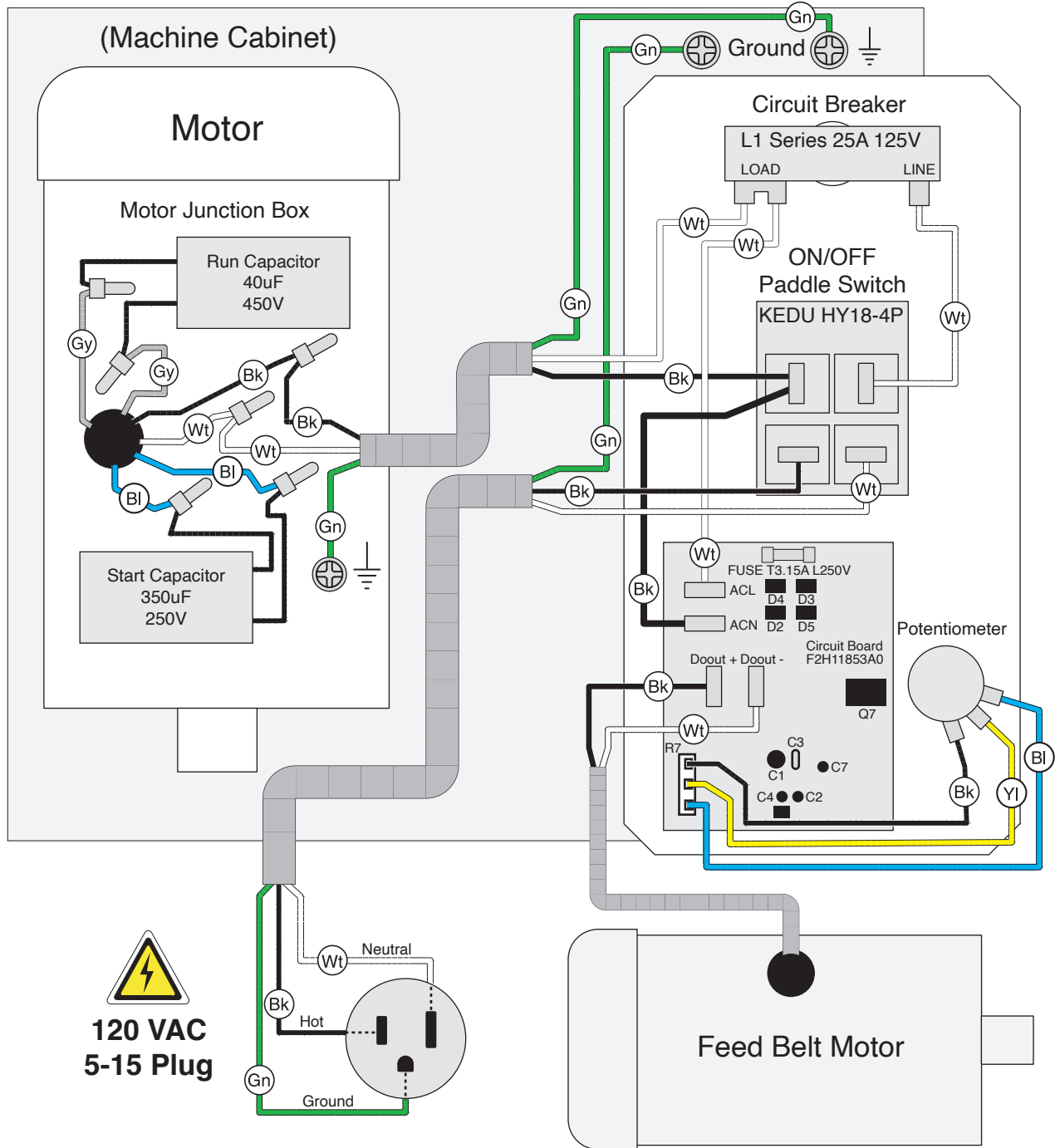
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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



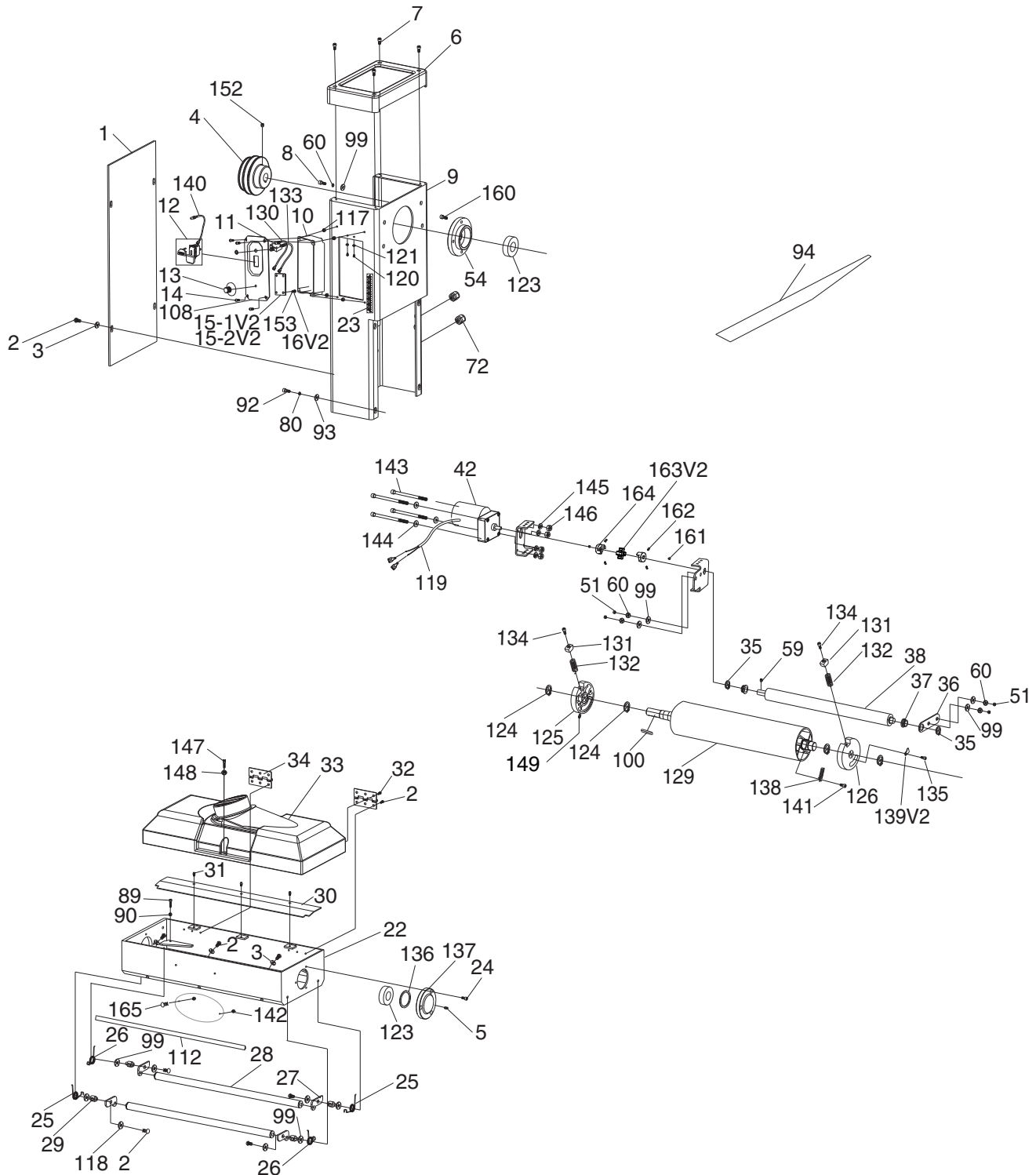
Wiring Diagram



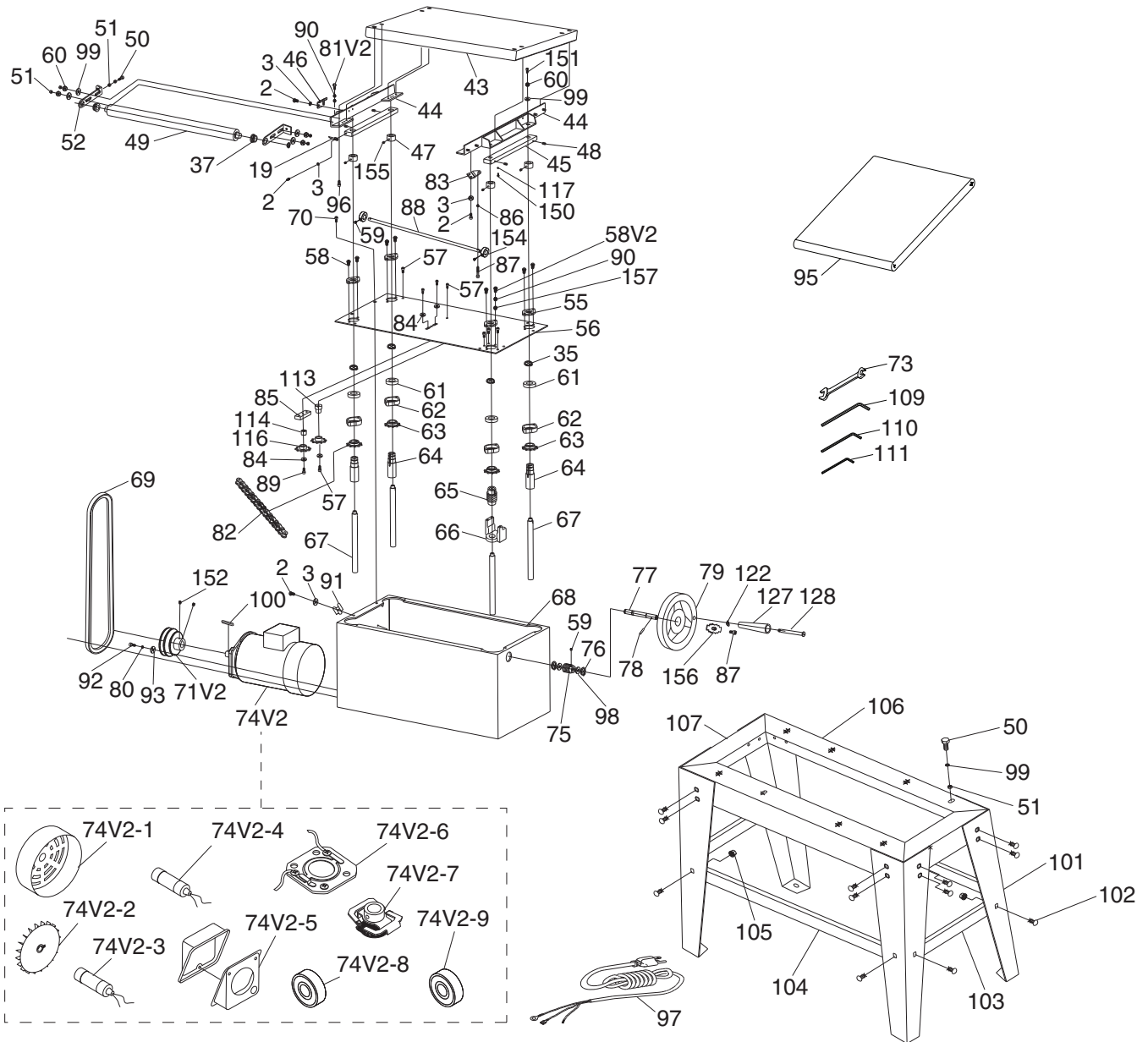
SECTION 9: PARTS

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.

Main



Main (Cont.)



Main Parts List

REF	PART #	DESCRIPTION	REF	PART #	DESCRIPTION
1	P0458Z001	SIDE COVER	57	P0458Z057	CAP SCREW M6-1 X 12
2	P0458Z002	PHLP HD SCR M5-.8 X 8	58	P0458Z058	CAP SCREW M6-1 X 15
3	P0458Z003	FLAT WASHER 5MM	58V2	P0458Z058V2	HEX BOLT M6-1 X 30 V2.01.23
4	P0458Z004	DRIVE PULLEY	59	P0458Z059	SET SCREW M5-.8 X 5
5	P0458Z005	SET SCREW M6-1 X 10	60	P0458Z060	LOCK WASHER 8MM
6	P0458Z006	FIXED COVER	61	P0458Z061	BALL BEARING 6904ZZ
7	P0458Z007	CAP SCREW M5-.8 X 16	62	P0458Z062	BEARING SEAT
8	P0458Z008	CAP SCREW M8-1.25 X 16	63	P0458Z063	SPROCKET
9	P0458Z009	SIDE CABINET	64	P0458Z064	ELEVATION SCREW CAP
10	P0458Z010	ELECTRICAL BOX COVER	65	P0458Z065	GEAR 65T
11	P0458Z011	CIRCUIT BREAKER L1 SERIES 25A	66	P0458Z066	BRACKET
12	P0458Z012	PADDLE SAFETY SWITCH KEDU HY18-4P	67	P0458Z067	ELEVATION SCREW ROD
13	P0458Z013	POTENTIOMETER KNOB	68	P0458Z068	LOWER CASTING
14	P0458Z014	PHLP HD SCR M5-.8 X 15	69	P0458Z069	V-BELT B40
15-1V2	P0458Z015-1V2	CIRCUIT BOARD F2H11853A0 V2.01.23	70	P0458Z070	CAP SCREW M8-1.25 X 12
15-2V2	P0458Z015-2V2	POTENTIOMETER W/WIRES, PLUG V2.06.20	71V2	P0458Z071V2	DRIVE PULLEY V2.07.19
16V2	P0458Z016V2	TAP SCREW M3 X 15 V2.09.22	72	P0458Z072	STRAIN RELIEF TYPE-3 M20-2.5
17	P0458Z017	SPACER (PLASTIC)	73	P0458Z073	WRENCH 8 X 12 OPEN-ENDS
18	P0458Z018	FUSE 15A 250V 5MM TIME-DELAY, GLASS	74V2	P0458Z074V2	MOTOR 1.5HP 120V 1-PH V2.03.20
19	P0458Z019	POINTER	74V2-1	P0458Z074V2-1	MOTOR FAN COVER
22	P0458Z022	HEAD CASTING	74V2-2	P0458Z074V2-2	MOTOR FAN
23	P0458Z023	TABLE HEIGHT SCALE	74V2-3	P0458Z074V2-3	S CAPACITOR 350M 250V
24	P0458Z024	CAP SCREW M6-1 X 12	74V2-4	P0458Z074V2-4	R CAPACITOR 40M 450V
25	P0458Z025	TORSION SPRING (LEFT)	74V2-5	P0458Z074V2-5	JUNCTION BOX
26	P0458Z026	TORSION SPRING (RIGHT)	74V2-6	P0458Z074V2-6	CONTACT PLATE
27	P0458Z027	ROLLER MOUTING PLATE	74V2-7	P0458Z074V2-7	CENTRIFUGAL SWITCH
28	P0458Z028	ROLLER	74V2-8	P0458Z074V2-8	BALL BEARING 6203-2RS (FRONT)
29	P0458Z029	PIVOT SHOULDER PIN	74V2-9	P0458Z074V2-9	BALL BEARING 6202-2RS (REAR)
30	P0458Z030	CHIP DEFLECTOR PLATE	75	P0458Z075	WORM GEAR
31	P0458Z031	CAP SCREW M6-1 X 10	76	P0458Z076	EXT RETAINING RING 12MM
32	P0458Z032	TAP SCREW M5 X 10	77	P0458Z077	SHAFT
33	P0458Z033	TOP COVER	78	P0458Z078	ROLL PIN 3 X 16
34	P0458Z034	HINGE 3"	79	P0458Z079	HANDWHEEL W/HANDLE TYPE-3 177D X M6-1
35	P0458Z035	EXT RETAINING RING 20MM	80	P0458Z080	LOCK WASHER 10MM
36	P0458Z036	FEED ROLLER BRACKET	81V2	P0458Z081V2	HEX BOLT M6-1 X 40 V2.01.23
37	P0458Z037	BUSHING	82	P0458Z082	CHAIN 410-132
38V2	P0458Z038V2	FEED BELT ROLLER V2.06.19	83	P0458Z083	FIXED PLATE
39	P0458Z039	MOTOR SUPPORT BRACKET	84	P0458Z084	FLAT WASHER 10MM
40	P0458Z040	MOTOR MOUNTING BRACKET	85	P0458Z085	ADJUSTMENT BLOCK
42-1	P0458Z042-1	MOTOR BRUSHES (2-PC SET)	86	P0458Z086	HEX NUT M5-.8
43	P0458Z043	CONVEYOR TABLE	87	P0458Z087	CAP SCREW M5-.8 X 35
44	P0458Z044	TABLE GUIDE	88	P0458Z088	ADJUSTMENT ROD
45	P0458Z045	STEEL BAR	89	P0458Z089	CAP SCREW M6-1 X 20
46	P0458Z046	PLATE	90	P0458Z090	HEX NUT M6-1
47	P0458Z047	LOCK COLLAR 16MM	91	P0458Z091	CORD CLAMP
48	P0458Z048	SET SCREW M5-.8 X 8	92	P0458Z092	CAP SCREW M10-1.5 X 25
49	P0458Z049	FEED BELT ROLLER	93	P0458Z093	FLAT WASHER 10MM
50	P0458Z050	HEX BOLT M8-1.25 X 20	94	P0458Z094	SANDING BELT 100-GRIT 3" X 84"
51	P0458Z051	HEX NUT M8-1.25	95	P0458Z095	CONVEYOR BELT
52	P0458Z052	FEED ROLLER BRACKET (REAR)	96	P0458Z096	CAP SCREW M6-1 X 30
54	P0458Z054	BEARING COVER (LEFT)	97	P0458Z097	POWER CORD 14G 3W 72" 5-15P
55	P0458Z055	LEADSCREW FIXED PLATE	98	P0458Z098	FLAT WASHER 12MM
56	P0458Z056	BASE COVER PLATE	99	P0458Z099	FLAT WASHER 8MM



Main Parts List (Cont.)

REF	PART #	DESCRIPTION
100	P0458Z100	KEY 6 X 6 X 40
101	P0458Z101	STAND LEG
102	P0458Z102	CARRIAGE BOLT M8-1.25 X 16
103	P0458Z103	SHORT BRACKET (BOTTOM)
104	P0458Z104	LONG BRACKET (BOTTOM)
105	P0458Z105	FLANGE NUT M8-1.25
106	P0458Z106	LONG BRACKET (TOP)
107	P0458Z107	SHORT BRACKET (TOP)
108	P0458Z108	CONTROL PANEL PLATE
109	P0458Z109	HEX WRENCH 6MM
110	P0458Z110	HEX WRENCH 5MM
111	P0458Z111	HEX WRENCH 4MM
112	P0458Z112	INFEED COVER
113	P0458Z113	SPACER BLOCK
114	P0458Z114	BUSHING
116	P0458Z116	SPROCKET
117	P0458Z117	HEX NUT M5-.8
118	P0458Z118	FLAT WASHER 5 X 14 OD X 0.8 T
119	P0458Z119	SPADE TERMINAL (F)
120	P0458Z120	CAP SCREW M5-.8 X 8
121	P0458Z121	FLAT WASHER 5MM
122	P0458Z122	FLAT WASHER 8MM
123	P0458Z123	BALL BEARING 6205ZZ
124	P0458Z124	EXT RETAINING RING 25MM
125	P0458Z125	SANDING BELT CLAMP BRACKET (RIGHT)
126	P0458Z126	SANDING BELT CLAMP BRACKET (LEFT)
127	P0458Z127	HOLLOW HANDLE 26 X 106, 9
128	P0458Z128	SHOULDER SCREW M8-1.25 X 16, 10 X 116
129	P0458Z129	BELT DRUM
130	P0458Z130	CONNECTION WIRE 2, 14AWG, 100L
131	P0458Z131	BELT LOCKING BLOCK
132	P0458Z132	COMPRESSION SPRING

REF	PART #	DESCRIPTION
133	P0458Z133	CONNECTION WIRE 1, 14AWG, 100L
134	P0458Z134	CAP SCREW M6-1 X 25
135	P0458Z135	CAP SCREW M5-.8 X 10
136	P0458Z136	WAVY WASHER 40MM
137	P0458Z137	BEARING COVER (RIGHT)
138	P0458Z138	EXTENSION SPRING
139V2	P0458Z139V2	SPRING RETAINER V2.11.20
140	P0458Z140	CONNECTION WIRE 3, 14AWG, 50L
141	P0458Z141	CAP SCREW M5-.8 X 12
142	P0458Z142	HEX NUT M3-.5
143	P0458Z143	SHOULDER SCREW M5-.8 X 30, 6 X 30
144	P0458Z144	FLAT WASHER 5MM
145	P0458Z145	LOCK WASHER 5MM
146	P0458Z146	HEX NUT M5-.8
147	P0458Z147	CAP SCREW M6-1 X 20
148	P0458Z148	FLAT WASHER 6MM
149	P0458Z149	SET SCREW M8-1.25 X 20
150	P0458Z150	HEX BOLT M5-.8 X 25
151	P0458Z151	CAP SCREW M8-1.25 X 16
152	P0458Z152	SET SCREW M8-1.25 X 10
153	P0458Z153	FLAT WASHER 3MM
154	P0458Z154	COLLAR
155	P0458Z155	SET SCREW M6-1 X 6
156	P0458Z156	FLAT WASHER 5MM
157	P0458Z157	LOCK WASHER 6MM
160	P0458Z160	CAP SCREW M6-1 X 16
161	P0458Z161	KEY 4 X 4 X 8
162	P0458Z162	SET SCREW M4-.7 X 8
163V2	P0458Z163V2	RUBBER CUSHION V2.01.23
164	P0458Z164	BUSHING
165	P0458Z165	PHLP HD SCR M3-.5 X 16



Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P0458Z201	ENTANGLEMENT WARNING LABEL
202	P0458Z202	ELECTRICITY LABEL
203	P0458Z203	READ MANUAL WARNING LABEL
204	P0458Z204	EYE/LUNG HAZARD WARNING LABEL
205	P0458Z205	GRIZZLY NAME PLATE-MINI
206	P0458Z206	MODEL NUMBER LABEL

REF	PART #	DESCRIPTION
207	P0458Z207	INJURY/SHOCK HAZARD WARNING
208	P0458Z208	TOUCH-UP PAINT, GREY PUTTY
209	P0458Z209	GRIZZLY.COM LABEL
210	P0458Z210	TOUCH-UP PAINT, GLOSSY BLACK
211V2	P0458Z211V2	MACHINE ID LABEL V2.09.22

! 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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