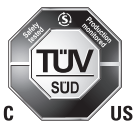




MODEL G0426
OSCILLATING EDGE BELT &
SPINDLE SANDER
OWNER'S MANUAL
(For models manufactured since 04/26)



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#CS23945 PRINTED IN CHINA

V1.04.26

*****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

WARNING

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

CAUTION

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

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.

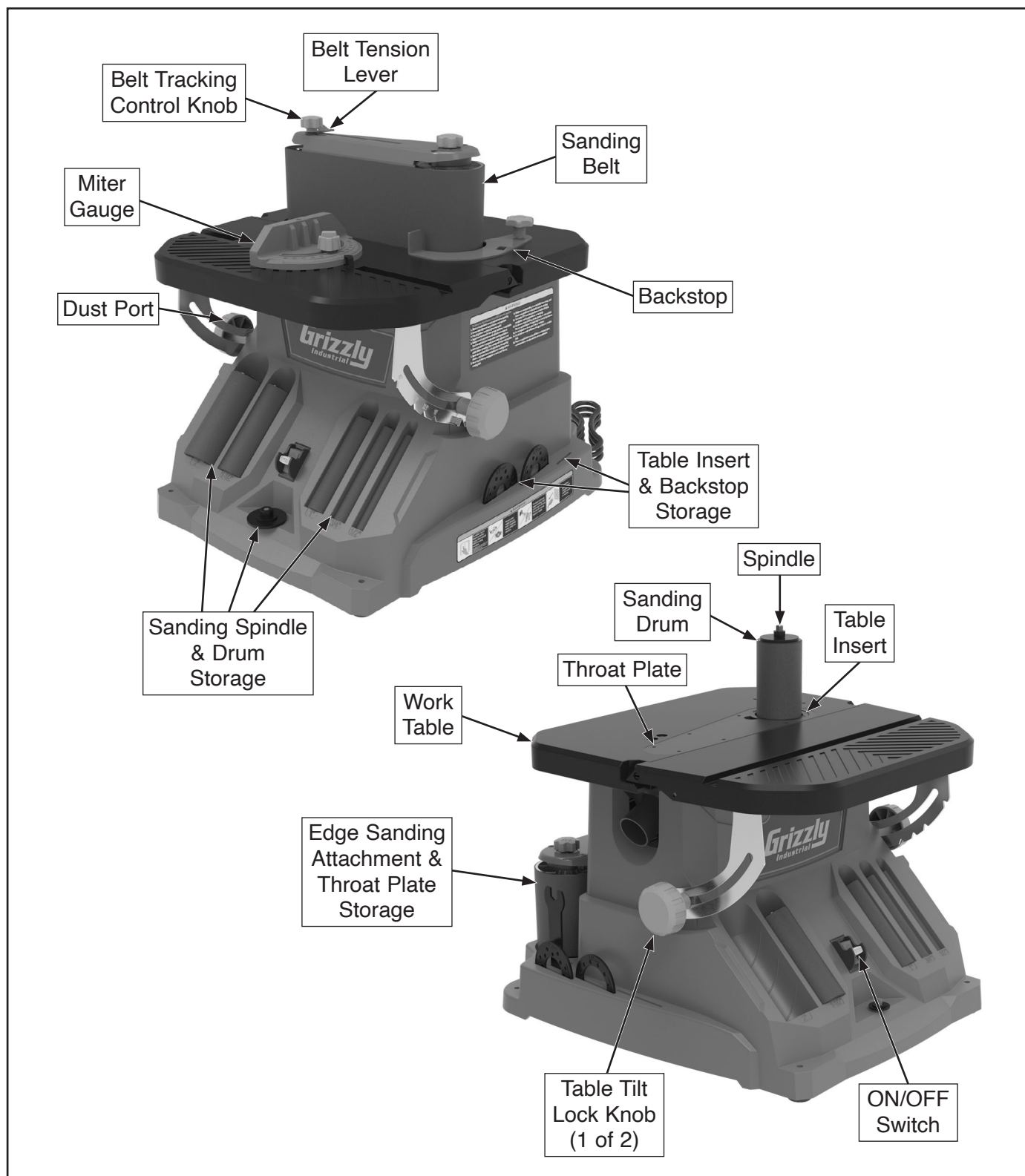
Grizzly Industrial		MODEL GXXXX MACHINE NAME
SPECIFICATIONS		 WARNING!
Motor:	To reduce risk of serious injury when using this machine:	
Specification:	1. Read manual before operation.	
Specification:	2. Wear safety glasses and respirator.	
Specification:	3. Make sure the motor is properly adjusted/setup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

Manufactured for Grizzly in Taiwan

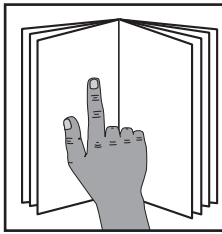


Identification

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



Controls & Components



!WARNING

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

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

Power Controls

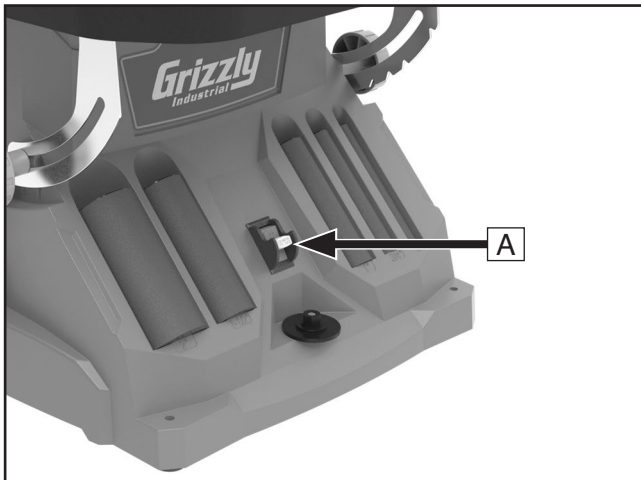


Figure 1. ON/OFF switch.

- A. ON/OFF Switch:** Turns motor **ON** and **OFF**. Remove yellow tab to lock in OFF position.

Spindle Sanding

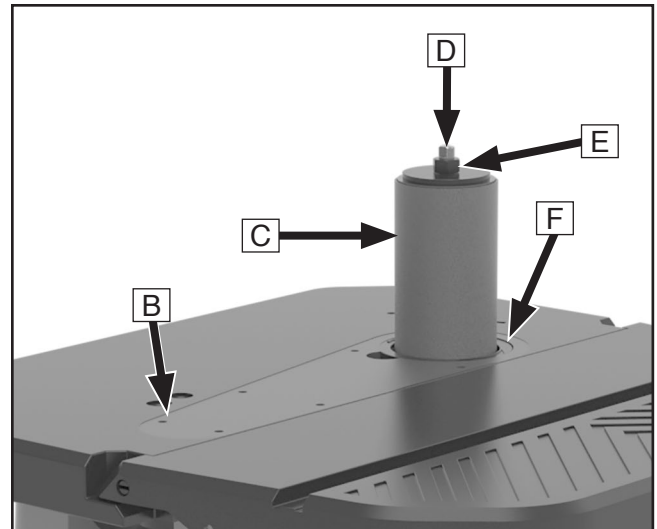


Figure 2. Spindle sanding components.

- B. Throat Plate:** Covers table opening when spindle sanding. Use in conjunction with provided table inserts.
- C. Sanding Drum w/Sleeve:** Installs on spindle for spindle sanding operations.
- D. Spindle:** Rotates sanding drum or drives edge-sanding attachment.
- E. Spindle Nut:** Secures sanding drum to spindle.
- F. Table Insert (1 of 5):** Installs onto throat plate around sanding drum. Designed to reduce risk of pinching injuries.



Edge Sanding

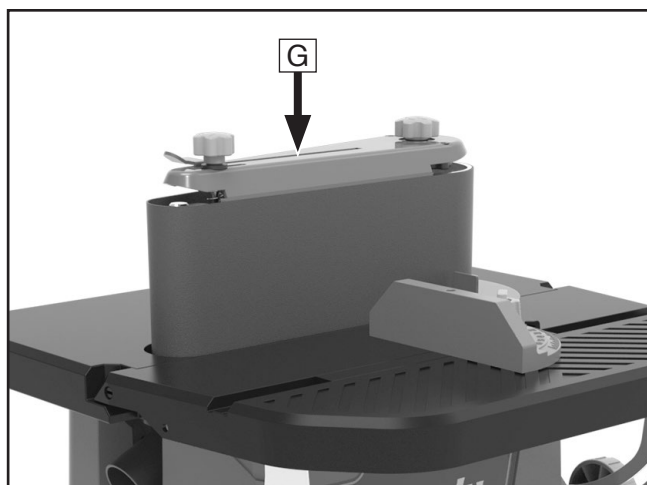


Figure 3. Edge sanding attachment.

- G. Edge Sanding Attachment w/Sanding Belt:** Slides onto spindle and into table opening for edge sanding operations.

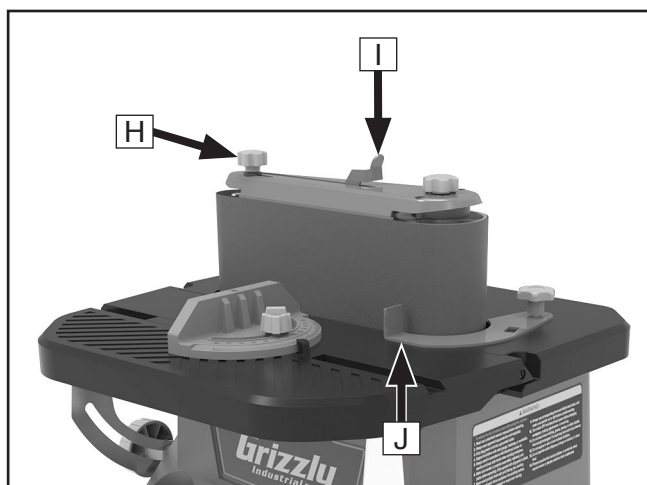


Figure 4. Edge sanding components.

- H. Belt Tracking Control Knob:** Adjusts alignment of sanding belt.
- I. Belt Tension Lever:** Tensions sanding belt when moved all the way left; releases sanding belt tension for removing/replacing belt when moved all the way right.
- J. Backstop:** Supports workpiece during edge or end sanding operations.

Table

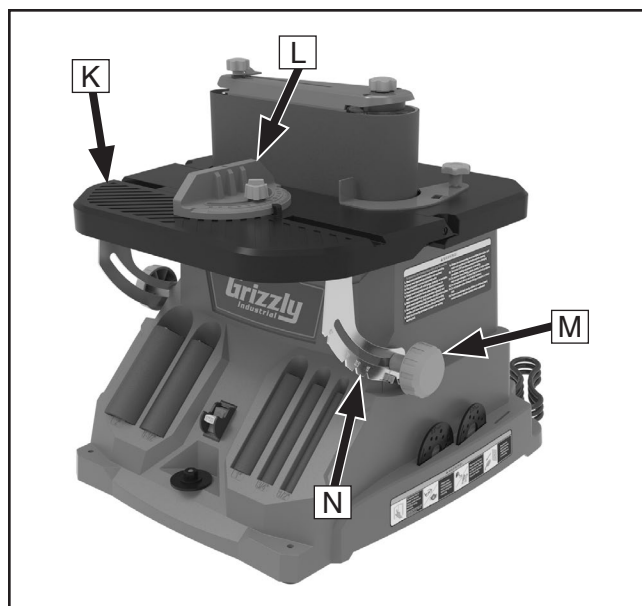


Figure 5. Table components.

- K. Work Table:** Supports workpiece during sanding operation and tilts for bevel sanding.
- L. Miter Gauge:** Adjusts from 0°–60° to support or feed workpiece against sanding belt or drum.
- M. Table Tilt Lock Knob (1 of 2):** Tightens to secure table tilt setting.
- N. Table Tilt Stop Bracket:** Detents provide positive stops for convenient positioning of table at 0°, 15°, 22.5°, 30°, and 45°.





MACHINE DATA SHEET

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

MODEL G0426 OSCILLATING EDGE BELT & SPINDLE SANDER

Product Dimensions:

Weight..... 29 in.
Width (side-to-side) x Depth (front-to-back) x Height..... 17 x 18 x 18-1/2 in.
Footprint (Length x Width)..... 18 x 16 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 34 lbs.
Length x Width x Height..... 21 x 19 x 19 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 4A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 18 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Toggle ON/OFF w/Disabling Key

Motors:

Main

Horsepower..... 1/2 HP
Phase..... Single-Phase
Amps..... 4A
Speed..... 10,000 RPM
Type..... Universal
Power Transfer Belt
Bearings..... Shielded & Permanently Lubricated



Main Specifications:

Belt Sander Info

Sanding Belt Width.....	4 in.
Sanding Belt Length.....	24 in.
Sanding Belt Speed.....	1575 FPM
Table Length.....	15-3/4 in.
Table Width.....	16 in.
Table Thickness.....	1/8 in.
Table Tilt.....	0 - 45 deg.
Table-to-Floor Height.....	13-1/4 in.
Drive Wheel Diameter.....	3 in.
Drive Wheel Width.....	4 in.
Belt Tension Release Type.....	Quick-Release Lever
Platen Type.....	Steel
Platen Length.....	6-7/8 in.
Platen Width.....	4 in.
Idler Wheel Diameter.....	1-1/2 in.
Idler Wheel Width.....	4 in.

Spindle Sander Info

Sanding Drum Diameters.....	3/4, 1, 1-1/2, 2 in.
Sanding Drum Length.....	4-1/2 in.
Spindle Speed.....	2000 RPM
Spindle Oscillation.....	58 OPM
Stroke Length.....	5/8 in.
Spindle Shaft Diameter.....	1/2 in.
Number of Table Inserts.....	5
Included Sanding Sleeve Grit Size.....	80
Table Tilt.....	0 - 45 deg.

Construction Materials

Base.....	Plastic
Table.....	Cast Aluminum
Miter Gauge.....	Plastic

Other Related Info

Miter Gauge Slot Width.....	5/8 in.
Miter Gauge Slot Height.....	1/4 in.
Number of Dust Ports.....	1
Dust Port Size.....	1-1/2 in.

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features:

Combines Advantages of Edge Sander and Spindler Sander in One Machine
Quickly Converts Between Setups w/Included Wrench
Tilting Table w/Detents at 0, 15, 22.5, 30, and 45 Degrees
Four Sanding Drums: 3/4", 1", 1-1/2", and 2"
Five 80-Grit Sanding Sleeves Included w/Matching Table Inserts: 1/2", 3/4", 1", 1-1/2", and 2"
80-Grit Sanding Belt Included
Included Miter Gauge and Backstop
On-Board Storage Included for All Accessories



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 loose clothing, gloves, neckties, 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 Spindle/Edge Sanders

WARNING

Serious injury or death can occur from fingers, clothing, jewelry or hair getting entangled in rotating spindle or other moving components. Abrasion injuries can occur from touching rotating sanding drum/belt with bare skin. Workpieces thrown by drum/belt can strike operator or bystanders with moderate force, causing impact injuries. 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.

HAND PLACEMENT. Rotating sanding sleeves/belts can remove a large amount of flesh in a few seconds. Always keep hands away from drum/belt during operation. Never touch moving drum on purpose. Use a brush to clean table of sawdust and chips.

FEEDING WORKPIECE. Forcefully jamming workpiece into sanding surface could cause workpiece to eject back at operator or damage machine. Always allow spindle to reach full speed. Firmly hold workpiece with both hands and ease it against spindle using light pressure.

FEED DIRECTION. Feeding workpiece incorrectly can cause it to be thrown from machine, allowing your hands to slip into the rotating drum/belt or striking yourself or bystanders. To reduce these risks, feed workpiece against direction of rotation, and never sand tapered or pointed stock with point facing feed direction.

SANDING SLEEVE/BELT CONDITION. Worn or damaged sanding sleeves/belts can tear apart and become entangled in spindle or other moving parts, resulting in subsequent injuries from operator loss of workpiece control. Replace worn or damaged sanding sleeves/belts promptly.

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

AVOIDING ENTANGLEMENT. DO NOT wear loose clothing, gloves, or jewelry, and tie back long hair. Keep all guards in place and secure.

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 sanding sleeves, drum, or belts. Never sand stock that has embedded foreign objects or questionable imperfections.

SMALL WORKPIECES. Small workpieces are difficult to control and require close support near sanding surface. Always use a jig or other holding device when sanding small workpieces, and keep hands and fingers at least 2" away from sanding surface.

TABLE INSERTS. A pinch point for fingers and workpieces exists in the gap between table and oscillating drum or belt. Always use table insert that fits closest to diameter of installed drum to keep this gap as small as possible and reduce risk of injury.

POWER DISCONNECT. An accidental startup while changing sanding sleeve or sanding belt can result in entanglement or abrasion injuries. Always disconnect machine from power source before changing sanding sleeve or sanding belt to avoid this risk.

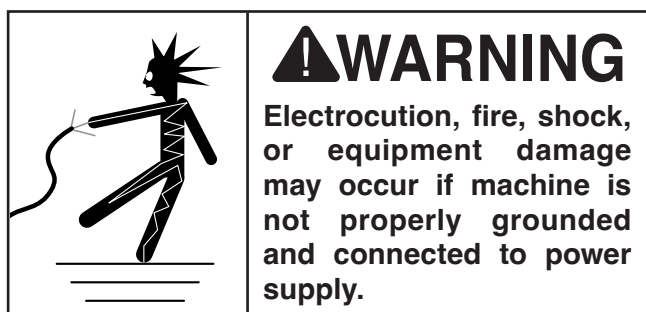
WORKPIECE INTEGRITY. Sanding fragile workpieces can result in loss of control, resulting in entanglement, impact injuries, or damage to the sanding sleeve, drum, or belt. Only sand solid workpieces that can withstand power sanding forces. Make sure shape of workpiece is properly supported; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.



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 4 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 15 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!

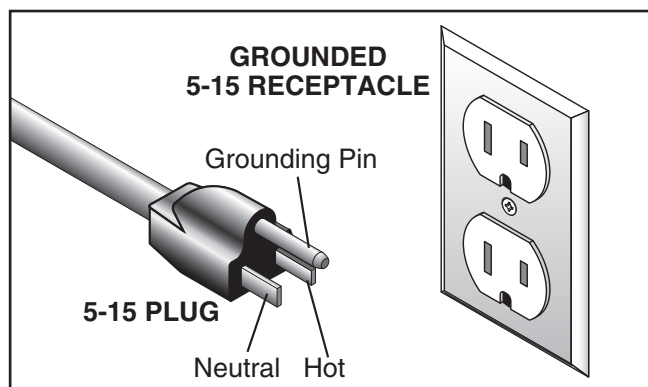
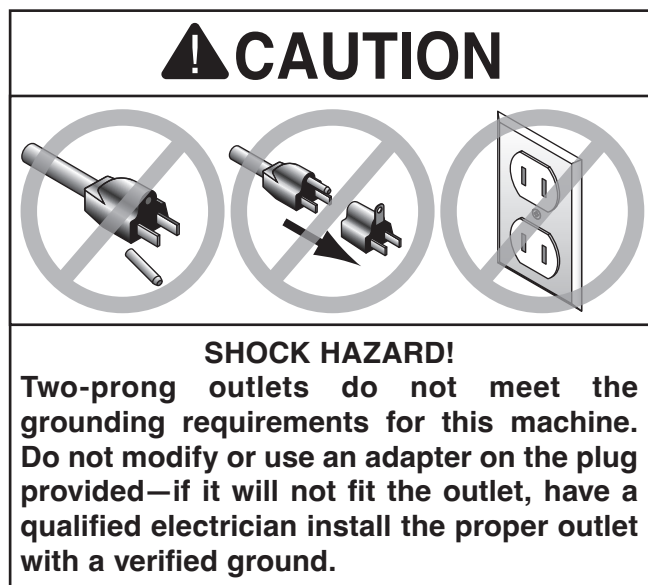


Figure 6. Typical 5-15 plug and receptacle.



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 machine 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.

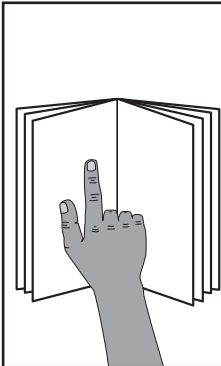
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 16 AWG
Maximum Length (Shorter is Better).....50 ft.

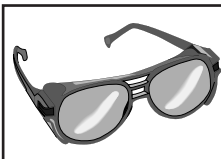


SECTION 3: SETUP



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!

Needed for Setup

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

Description	Qty
• Safety Glasses (For each person).....	1
• Dust Hose 1½"	1
• Hose Clamp 1½"	1
• Dust Collection System	1

Unpacking

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

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



Inventory

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

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

NOTICE

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

Main Components (Figure 7)	Qty
A. Machine.....	1
B. Table Inserts 0.5", 0.75", 1", 1.5", 2"	1 Ea.
C. Sanding Drums 3/4", 1", 1 1/2", 2"	1 Ea.
D. Throat Plate	1
E. Keyed Hub Plate.....	1
F. Edge Sanding Attachment	1
G. Spindle Wrench 10 x 13mm	1
H. Backstop.....	1
I. Miter Gauge.....	1

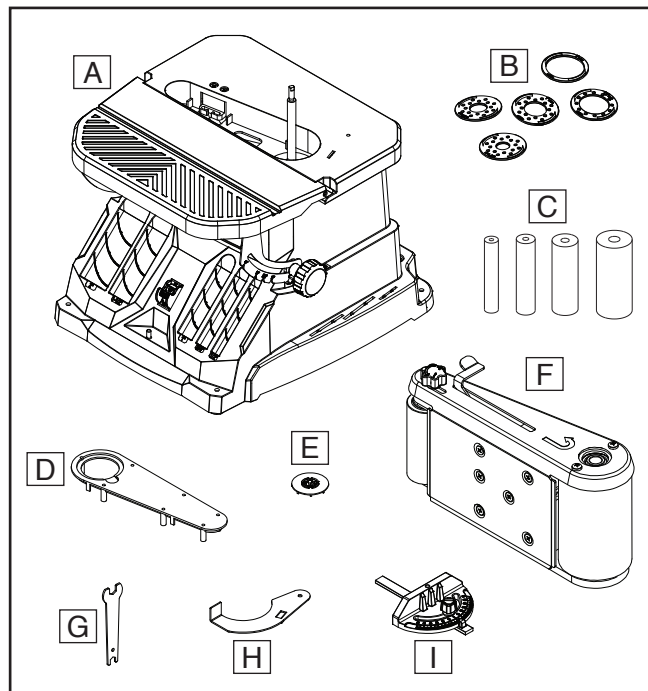


Figure 7. Main component inventory.

Abrasives (Figure 8)	Qty
J. Sanding Belt 4" x 24", 80-Grit	1
K. Sanding Sleeves, 80-Grit 1/2", 3/4", 1", 1 1/2", 2"	1 Ea.

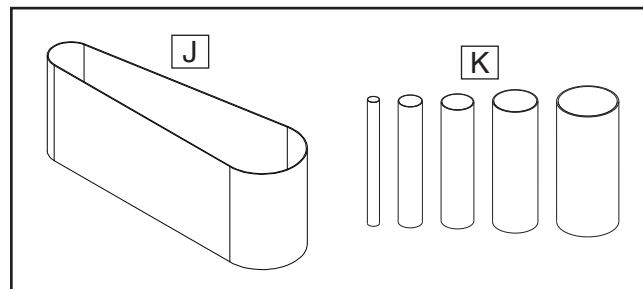


Figure 8. Abrasive inventory.

Fasteners (Figure 9)	Qty
L. Spindle Nut M8-1.25 (P0426054)	1
M. Flat Washer 8mm (P0426053)	1
N. Fender Washer 8mm (P0426098)	1
O. Flat Washer 13 x 24 x 1.5mm (P0426079)...	1
P. Flat Washer 8.4 x 45 x 3mm (P0426032)....	1
Q. Knob Bolt M6-1 x 10.....	1
R. Knob M8-1.25	1

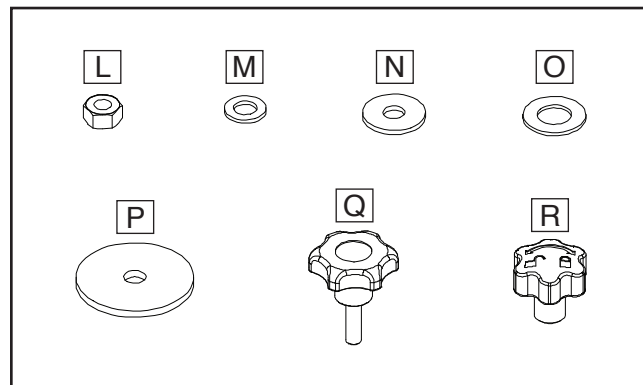


Figure 9. Fastener inventory.

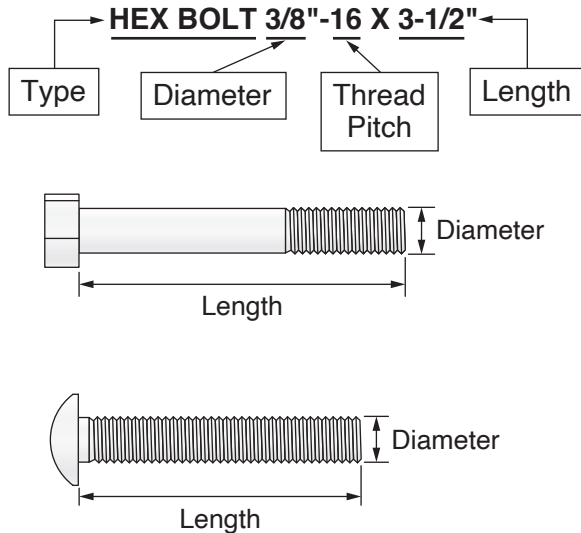


Measuring Hardware

Use this page to understand how hardware is measured in this manual.

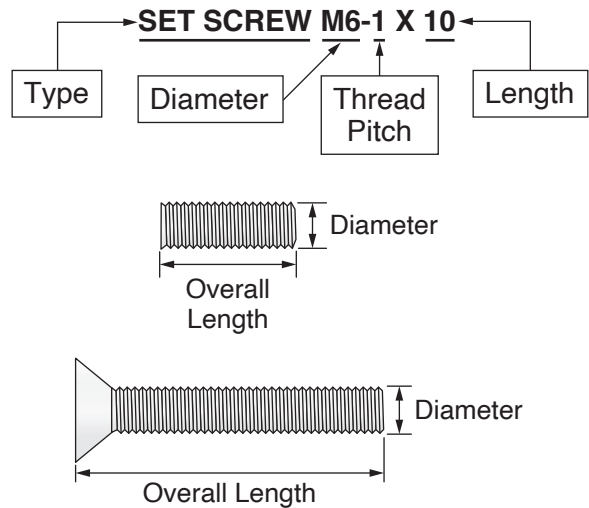
Bolts & Screws

Most bolts and screws are measured by the outside diameter of the threads, thread pitch, and the length from under the head to the opposite end:

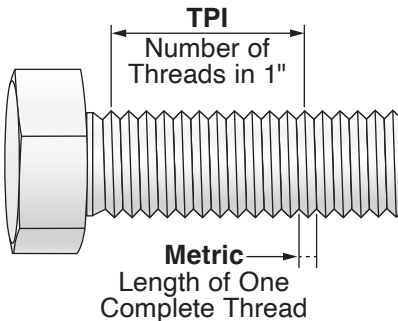


Flat Head & Set Screws

Flat head and set screws are measured by the outside diameter of the threads, thread pitch, and overall length of the fastener. These fasteners are often meant to sit flush with the adjoining surface:



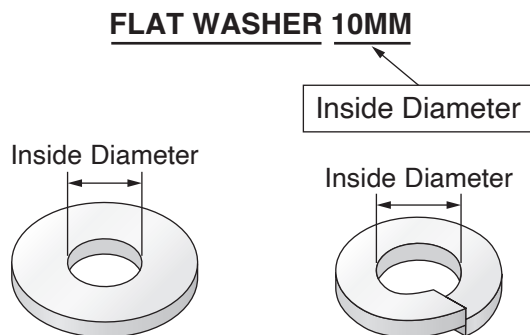
Thread pitch is the distance from the tip of one thread to the tip of the next thread. For US Standard threads, pitch is measured in threads per inch (TPI). Metric thread pitch is the length of one complete thread.



Note: Grizzly Industrial does not typically list a thread pitch for thread-forming screws and bolts, such as tap screws, wood screws, and lag bolts.

Washers

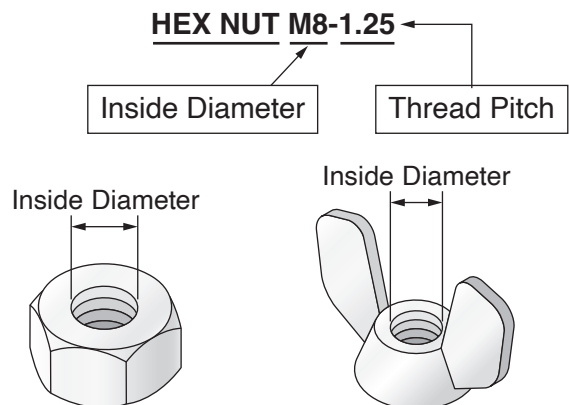
Common washers are measured by their inside diameter.



Note: Specialized washers may list the inside diameter, outside diameter, and the thickness.

Nuts

Nuts are measured by the inside diameter of the threads and the thread pitch.



Site Considerations

Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

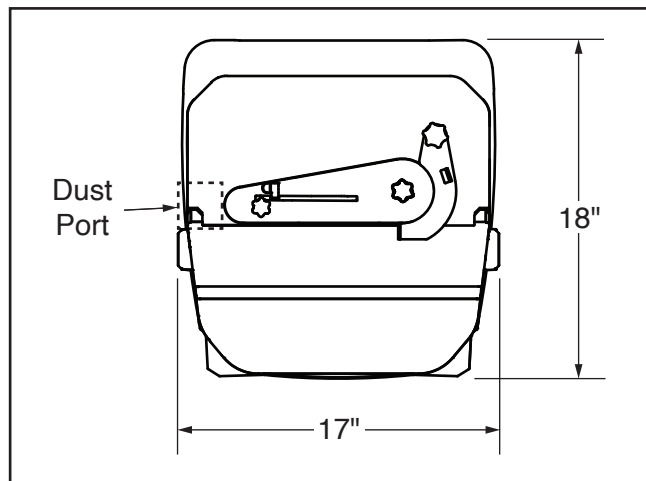
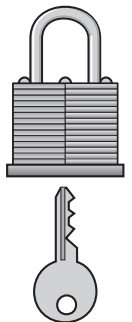


Figure 10. Minimum working clearances.

	⚠ CAUTION Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.
---	--

Bench Mounting

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

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

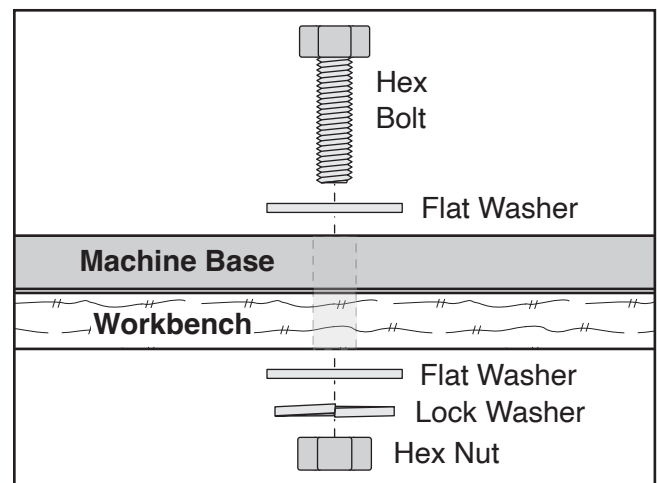


Figure 11. "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

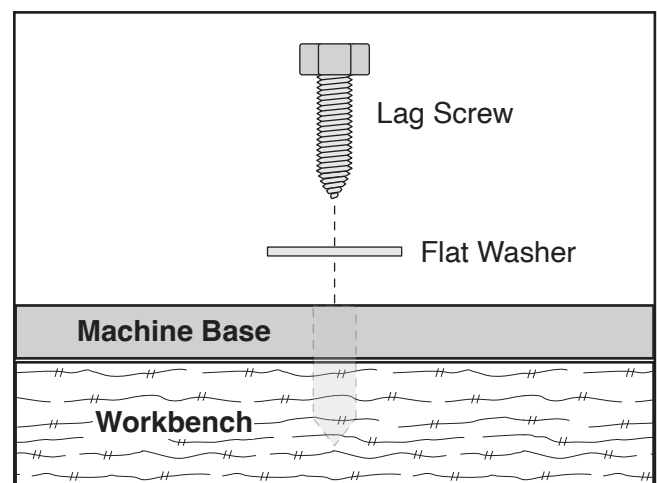


Figure 12. "Direct Mount" setup.



Assembly

Place the sanding drums and sleeves, table inserts, throat plate, backstop, spindle wrench, knobs, flat washers, and spindle nut in the accessory slots shown in **Figure 13**.

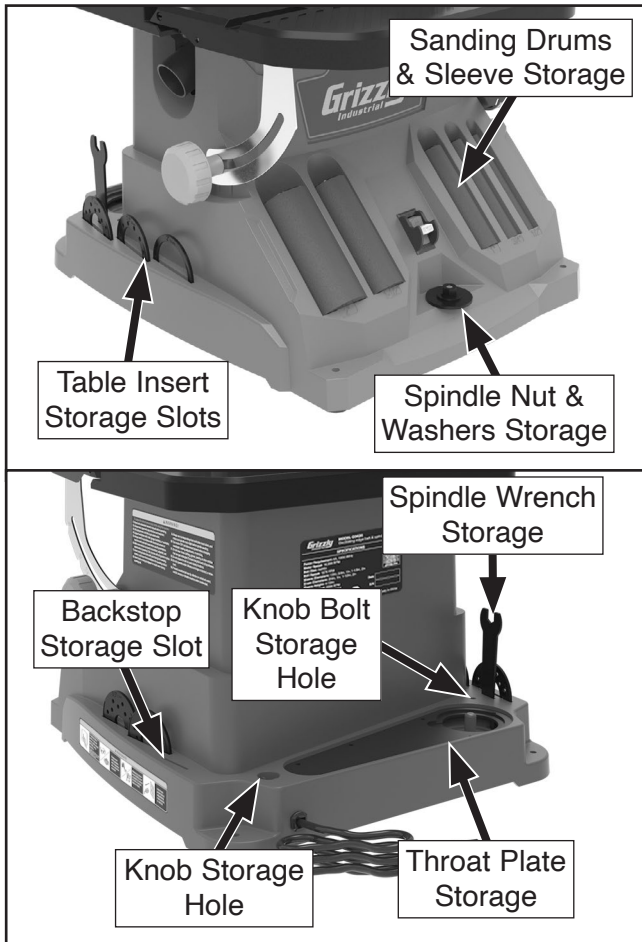


Figure 13. Accessory storage slots and holes.

Remove the edge sanding attachment, keyed hub plate, miter gauge, and sanding belt from machine for now. No sanding drum or belt needs to be installed until after the test run.

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: 100 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 1½" dust hose over dust port, as shown in **Figure 14**, and secure in place with hose clamp.



Figure 14. Example of dust hose attached to dust port.

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

Note: A tight fit is necessary for proper performance.



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 switch disabling key disables the switch properly.

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**.

Motor should run smoothly and without unusual problems or noises.

4. Remove key from toggle switch, as shown below.

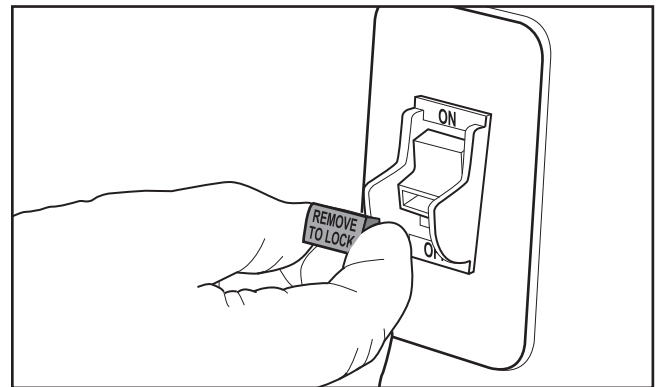


Figure 15. Removing key from toggle switch.

5. Try to start machine with switch.
 - If machine *does not* start, toggle switch is working correctly. Congratulations! Test Run is complete.
 - If machine *does* start (with key removed), immediately disconnect power to machine. Toggle switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

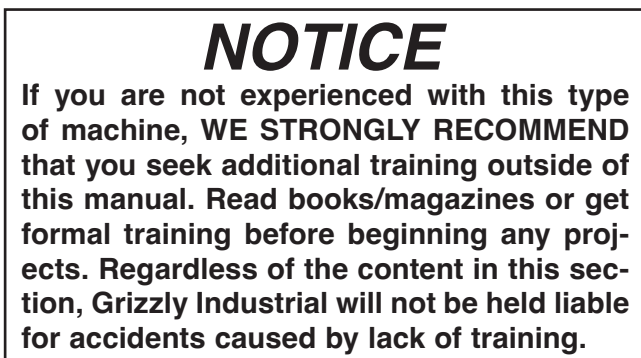
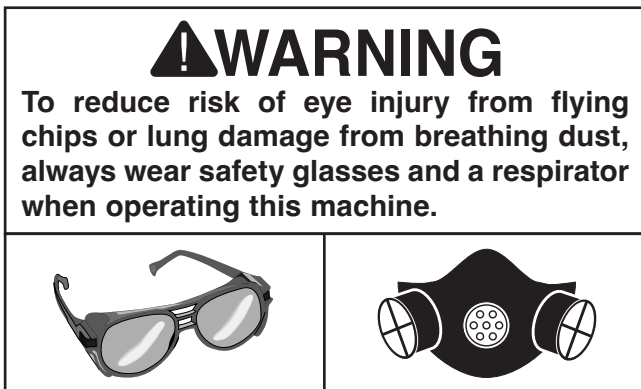


SECTION 4: OPERATIONS

Operation Overview

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

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



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

1. Examines the workpiece to make sure it is suitable for sanding.
2. If necessary for operation, tilts table and secures it in place.
3. Installs abrasive best suited for operation.
 - For spindle sanding, operator installs sanding drum and sleeve of desired size and grit, and selects and installs table insert that will minimize gap between table and drum.
 - For edge sanding, operator installs edge sanding attachment and sanding belt of desired grit.
4. Ties back loose hair and clothing, and puts on safety glasses and respirator.
5. Starts dust collection, then turns sander **ON**.
6. Feeds workpiece against abrasive.
 - For spindle sanding, operator feeds workpiece against direction of spindle rotation, using table to support workpiece while maintaining a safe working distance between hands and sanding sleeve.
 - For edge sanding, operator uses both hands to feed workpiece flatly against table (and backstop or miter gauge, if using), and gradually feeds workpiece against direction of belt rotation.
7. Turns machine and dust collection **OFF**.



Workpiece Inspection

Some workpieces are not safe to sand or may require modification before they are safe to sand.

Before sanding, inspect all workpieces for the following:

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

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

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these can become dislodged and tear sanding belt or sleeve. Always visually inspect your workpiece for these items. If they cannot be removed, DO NOT sand the workpiece.
- **Knots:** DO NOT sand stock that contains large or loose knots. Personal injury or machine damage can occur if a knot becomes dislodged during sanding.
- **Wet or "Green" Stock:** Sanding wood with moisture content over 20% causes unnecessary clogging and wear on the sanding belt, increases the risk of kickback, and yields poor results.

Sanding Tips

- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease sleeve/belt life and cost you more money over time.
- Replace the sanding sleeve or belt with a higher grit to achieve a finer finish. Avoid skipping grits, as this will leave scratches in the wood.
- Extend the life of sanding sleeves/belts by regularly using a crepe sanding pad to clean them.
- Hold workpiece steady with both hands. Use the table (and backstop or miter gauge, if installed) whenever possible to support workpieces. Do not force the workpiece against the drum or belt.
- When bevel sanding, make any necessary guide lines on the longer side of the board so they are visible during sanding.
- Keep your workpiece moving across the sanding sleeve or belt to prevent burns, grooves, or ruts in the workpiece.
- When sanding workpieces with a bow or crown, place the high point up on the table to prevent the workpiece from rocking, then take very light passes.
- Sanding sleeves and belts clog and wear. Change these whenever you notice a difference in sanding quality/performance and cleaning does not improve them.

WARNING

Moving belt or sleeve can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Always support workpiece against table and other support fixtures when sanding. Use extreme care to provide a safe distance between abrasive and any body parts.



Choosing Sanding Sleeves/Belts

The Model G0426 comes with an 80-grit sanding belt and sleeves, but the type and condition of wood you are sanding and your desired stage of finish will determine the best grit type for you to install.

There are many types of sanding sleeves and 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
36	Extra Coarse	Rough sawn boards, thickness sanding, and glue removal.
60	Coarse	Thickness sanding and glue removal.
80–100	Medium	Removing planer marks and initial finish sanding.
120–180	Fine	Finish sanding.

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

Spindle Sanding

The Model G0426 comes with 1/2", 3/4", 1", 1 1/2", and 2" sanding sleeves for sanding a variety of different curves.

Spindle sanding is performed to sand inside curves and irregular shapes. The oscillating spindle moves up and down as it rotates to help create a smooth surface that accurately follows your layout line.

To use the spindle sander, you must first configure the machine for spindle sanding by installing the appropriate sanding drum/sleeve for your operation.

Note: The 1/2" sanding sleeve does not use a sanding drum, but mounts directly to the spindle shaft.



Installing Sanding Drum/Sleeve

To ensure the workpiece is supported during spindle sanding operations, use the throat plate and table insert that matches the corresponding drum and sleeve. It is important to keep the gap between the table insert and sanding sleeve as small as possible to reduce the risk of a pinch injury.

To install sanding drum/sleeve:

1. DISCONNECT MACHINE FROM POWER!
2. Remove any sanding components installed on table or spindle (backstop, miter gauge, spindle nut, spindle washer, sanding drum/sleeve, edge sanding attachment, throat plate, table insert, etc.).



3. Clean openings for table insert, throat plates, and any other spindle areas as necessary. There should be no sawdust on edge of table openings where table insert and throat plates are placed or these components will not sit flush with table.
4. Use table in **Figure 16** to select required size of components for desired sanding drum/sleeve.

Note: Table inserts are marked with size of drum they should be used with.

Sanding Sleeve Diameter	Sanding Drum Outer Diameter	Table Insert (Marked)	Spindle Washer Outer Diameter
1/2"	N/A	0.5" (13mm)	14mm
3/4"	3/4"	0.75" (19mm)	24mm
1"	1"	1" (26mm)	24mm
1 1/2"	1 1/2"	1.5" (38mm)	24mm
2"	2"	2" (51mm)	45mm

Figure 16. Sanding drum/sleeve sizing table.

5. Install keyed hub plate on spindle shaft, and rotate plate until flats shown in **Figure 17** align with spindle shaft base flats and plate fully seats (see **Figure 18**).

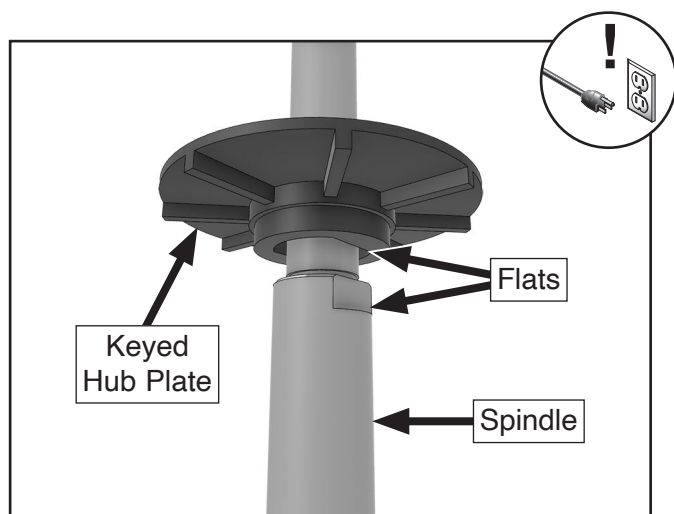


Figure 17. Keyed hub plate flats aligned with spindle shaft base flats (table removed for clarity).

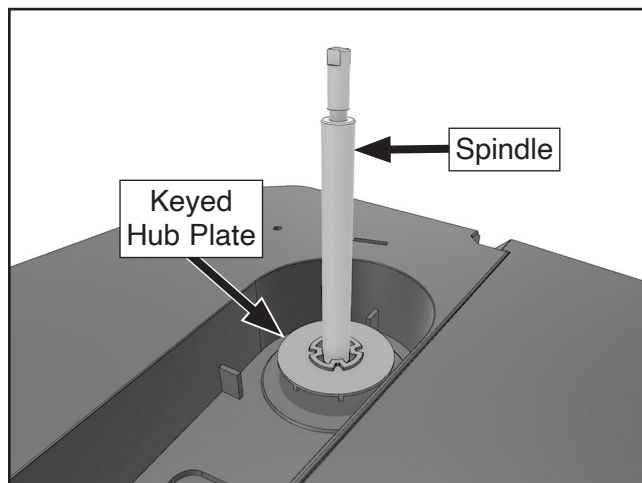


Figure 18. Keyed hub plate fully seated on spindle.

6. Place throat plate in table opening, then install desired sanding drum on spindle shaft, followed by corresponding sanding sleeve and table insert (see **Figure 19**).
7. Secure sanding drum with appropriate spindle washer and spindle nut (see **Figure 19**). Tighten nut until sanding drum places slight pressure on sanding sleeve.

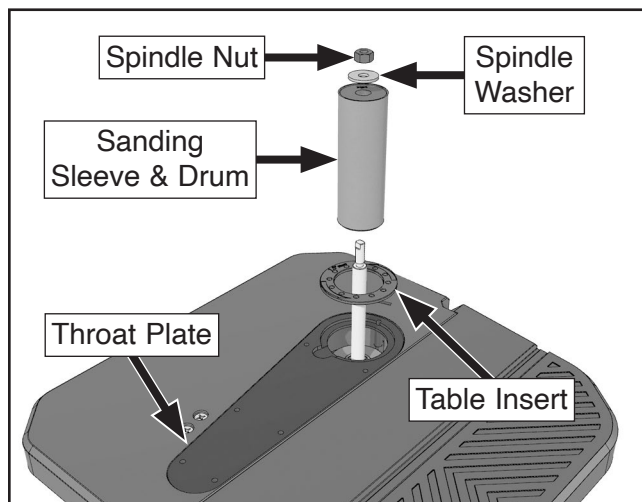


Figure 19. Installation order of spindle sanding components.



Using Spindle Sander

1. Turn sander **ON** and allow it to reach full speed.
2. Using both hands to maintain control of workpiece, guide it against rotation of spindle, as shown in **Figure 20**. DO NOT force workpiece against sanding sleeve. Allow machine to do the work.

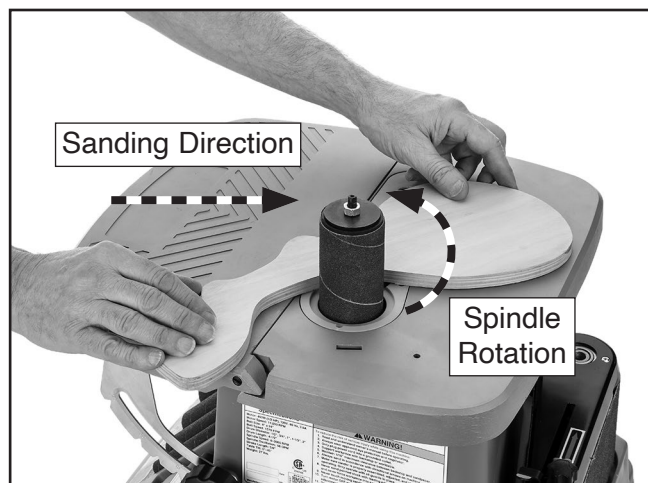


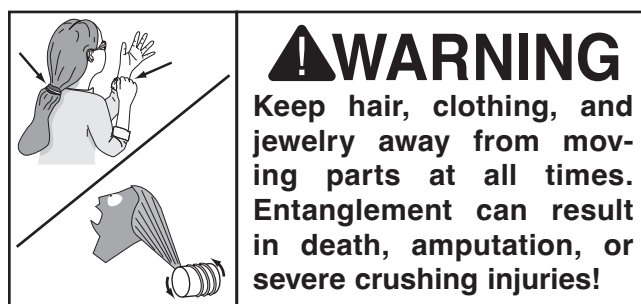
Figure 20. Example of feeding workpiece against sanding sleeve.

3. When finished, turn sander **OFF**.

Edge Sanding

Edge sanding is performed to sand straight lines or curves along the outside edge of a workpiece. The edge sanding attachment moves up and down as the sanding belt moves across the workpiece. The backstop or miter gauge is used to support the workpiece during sanding, helping to prevent the workpiece from being ejected by the moving sanding belt.

To use the edge sander, you must first configure the machine for edge sanding by installing the edge sanding attachment.



Installing Edge Sanding Attachment

Always use the backstop or the miter gauge to support the workpiece during edge sanding whenever possible.

To install edge sanding attachment:

1. DISCONNECT MACHINE FROM POWER!
2. Remove any sanding components installed on spindle (spindle nut, spindle washer, sanding drum/sleeve, throat plate, table insert, etc.).



3. Install keyed hub plate on spindle shaft, and rotate plate until flats shown in **Figure 21** align with spindle shaft base flats and plate fully seats (see **Figure 22**).

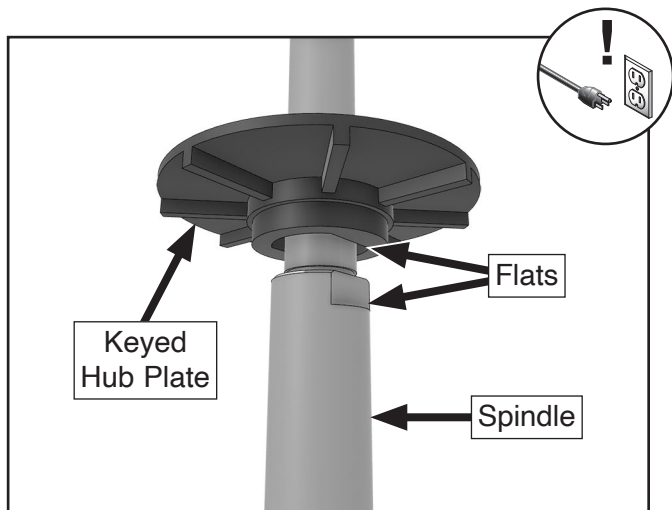


Figure 21. Keyed hub plate flats aligned with spindle shaft base flats (table removed for clarity).

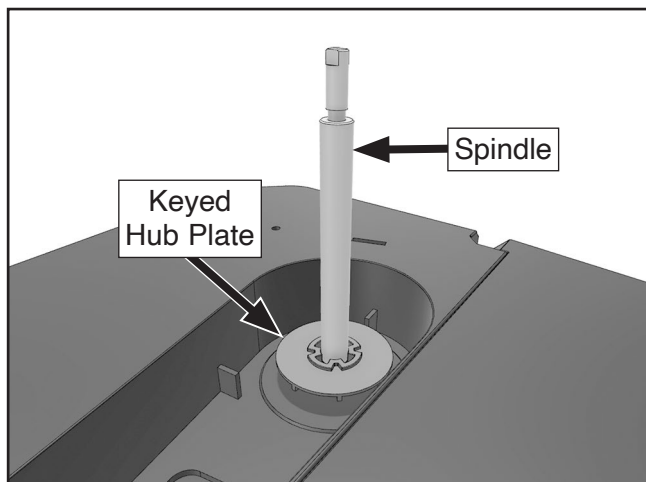


Figure 22. Keyed hub plate fully seated on spindle.

4. Install edge-sanding attachment in sander body, as shown in **Figure 23**, and rotate large sanding roller until teeth align with spline holes in keyed hub plate (see **Figure 24**).

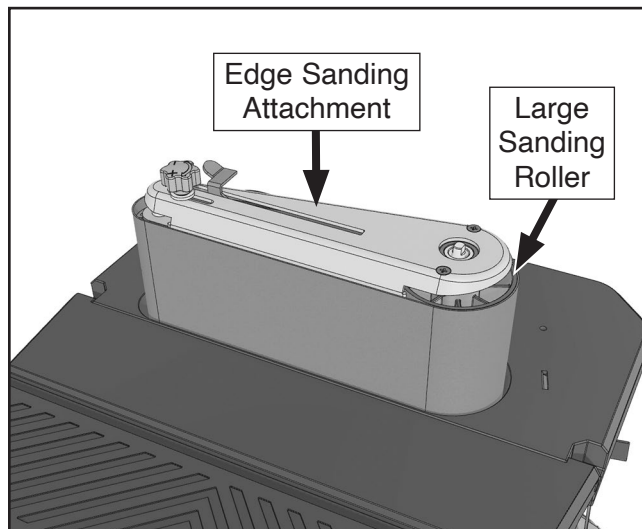


Figure 23. Edge sanding attachment installed in sander body.

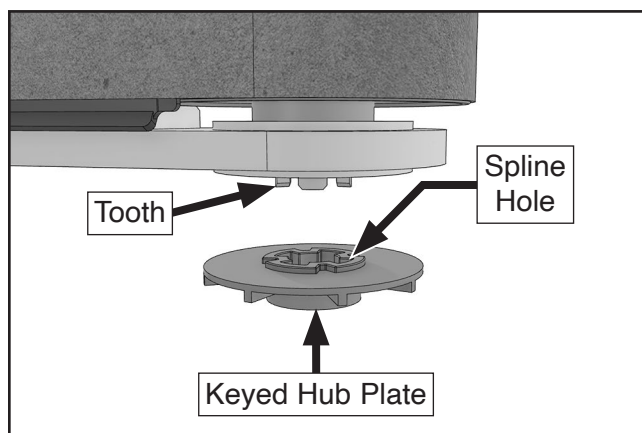


Figure 24. Edge sanding attachment teeth aligned with spline holes in keyed hub plate (table removed for clarity).



5. Secure edge sanding attachment to spindle with 13 x 24 x 1.5mm flat washer and M8-1.25 knob (see **Figure 25**).
6. Install backstop and secure with M6-1 x 10 knob bolt (see **Figure 25**).

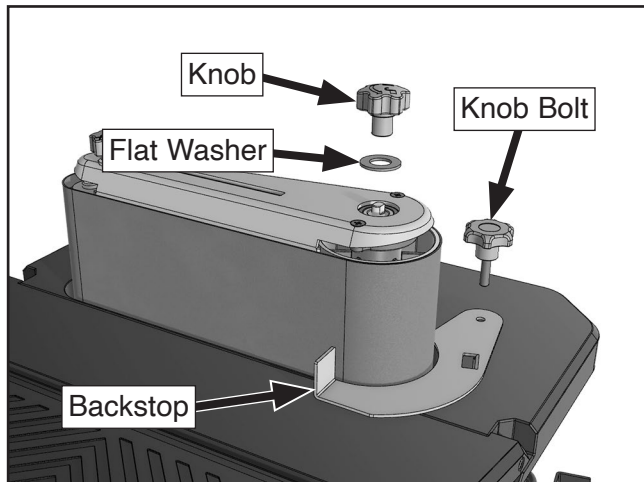


Figure 25. Securing edge sanding attachment and backstop to machine.

- If workpiece shape or size cannot be safely supported with backstop, instead insert miter gauge into miter slot (see **Figure 26**) or use some other holding fixture, if possible.

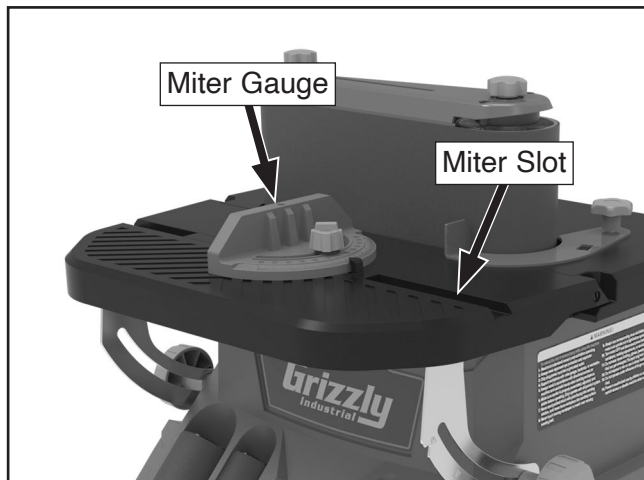


Figure 26. Miter gauge inserted into miter slot.

Edge Sanding Straight Lines

To edge sand a straight line, press your workpiece against the flat surface of the platen (shown in **Figure 27**).

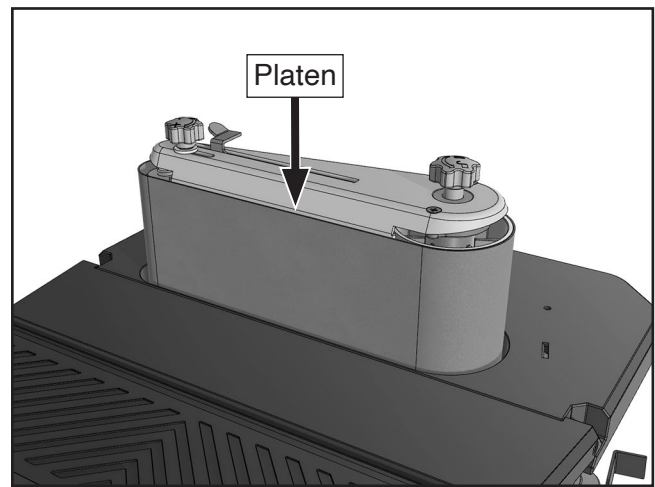


Figure 27. Location of platen.

To edge sand straight lines:

1. Turn sander **ON** and allow it to reach full speed.
2. Support workpiece against backstop or miter gauge (see **Figure 28**). Using both hands to maintain control of workpiece, guide it against rotation of sanding belt. **DO NOT** force workpiece against sanding belt. Allow machine to do the work.



Figure 28. Example of using backstop to edge sand workpiece against platen.

3. When finished, turn sander **OFF**.

Edge Sanding Inside Curves

To edge sand inside curves, use the rounded surface of the small or large sanding roller (see **Figure 29**). To edge sand on the large roller, you must first remove the backstop.

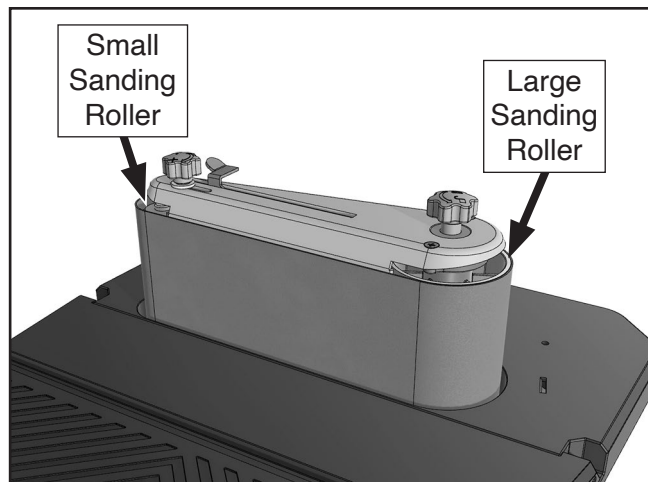


Figure 29. Location of sanding rollers.

To edge sand inside curves:

1. Set table tilt to 0° (refer to **Page 28**) and, if necessary, remove backstop.
2. Turn sander **ON** and allow it to reach full speed.
3. Using both hands to maintain control of workpiece, slowly guide it against roller portion of sanding belt (see **Figure 30**). While maintaining downward pressure on workpiece against table, gently move it along sanding belt until desired inside curve is achieved.



Figure 30. Example of edge sanding inside curve.

4. When finished, turn sander **OFF**.

Edge Sanding Outside Curves

To edge sand outside curves, use either the rounded surfaces of the sanding rollers or the flat surface of the platen (see **Figure 31**). Sand against the platen and use the miter gauge or backstop to support your workpiece if the operation allows.

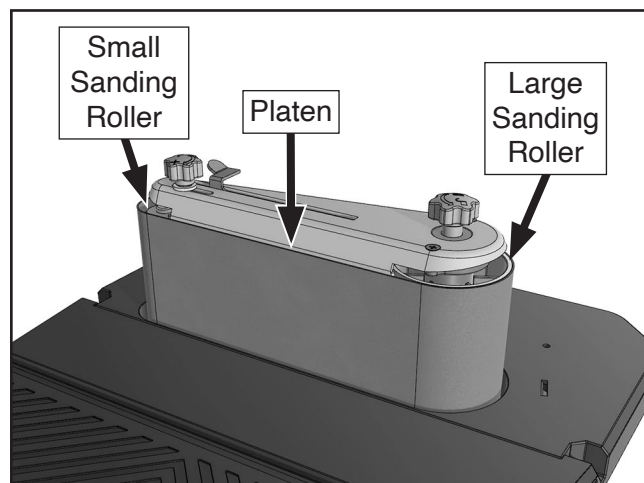


Figure 31. Location of sanding surfaces.

To edge sand outside curves:

1. Turn sander **ON** and allow it to reach full speed.
2. Using both hands to maintain control of workpiece, slowly guide it against rotation of sanding belt. While maintaining downward pressure on workpiece against table, gently move it along sanding belt (see **Figure 32**) until desired outside curve is achieved.



Figure 32. Example of sanding outside curve with edge sanding attachment.

3. When finished, turn sander **OFF**.



Changing Sanding Belt

The Model G0426 edge sander attachment accepts 4" x 24" sanding belts.

To change sanding belt:

1. DISCONNECT MACHINE FROM POWER!
2. Slide belt tension lever all the way right to release belt tension (see **Figure 33**).

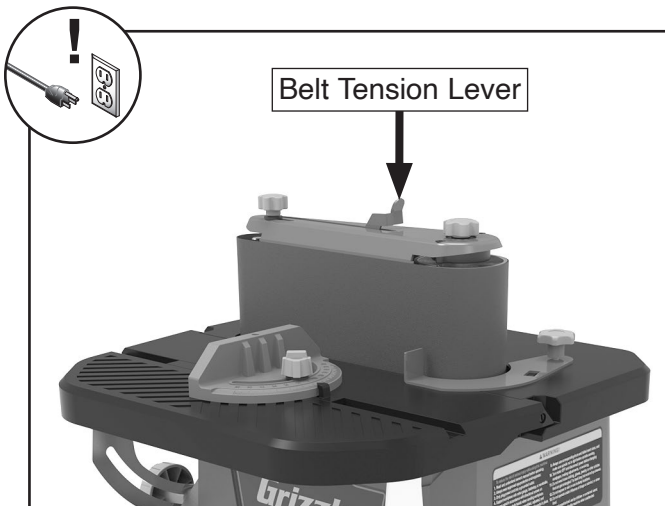


Figure 33. Belt tension lever all the way right.

3. Remove sanding belt.
4. Install a new belt, being sure arrows on belt match belt rotation arrows on top of edge sanding attachment, then slide belt tensioning lever all the way left to tension belt.

Adjusting Sanding Belt Tracking

The sanding belt tracking needs to be adjusted any time you change or replace the sanding belt, or if the belt moves toward or away from the table during operations.

To adjust sanding belt tracking:

1. Install edge sanding attachment (refer to **Installing Edge Sanding Attachment** on **Page 23**), then remove all tools from sander.
2. Connect machine to power.
3. Turn machine **ON**, then immediately turn it **OFF**. Sanding belt should be centered on rollers and *not* move toward top or bottom of edge sanding attachment.
 - If sanding belt moves toward top of edge sanding attachment, rotate belt tracking control knob (see **Figure 34**) counter-clockwise $\frac{1}{4}$ -turn.
 - If sanding belt moves toward bottom of edge sanding attachment, rotate belt tracking knob (see **Figure 34**) clockwise $\frac{1}{4}$ -turn.

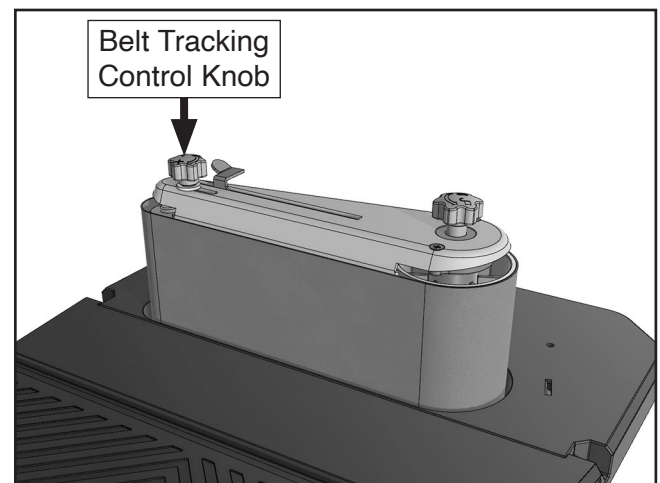


Figure 34. Location of belt tracking control knob.

4. Repeat **Step 3** until proper belt tracking is achieved.



Bevel Sanding

The work table on Model G0426 tilts from 0°–45° (see **Figure 35**) for sanding bevels on your workpiece. The table tilt stop bracket has detents for quickly setting the most common angles: 0°, 15°, 22.5°, 30°, and 45°.

Note: You can bevel sand using either the spindle sander or the edge sanding attachment.

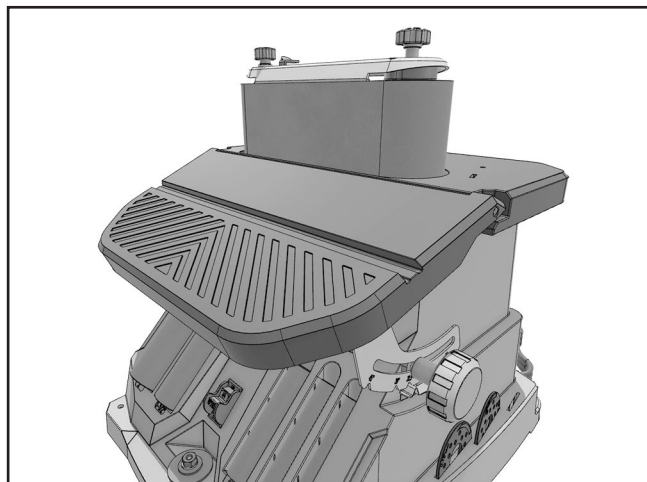


Figure 35. Work table tilted for bevel sanding.

The miter gauge tilts 0°–60° left or right (see **Figure 36**) and can also be used to sand bevels.

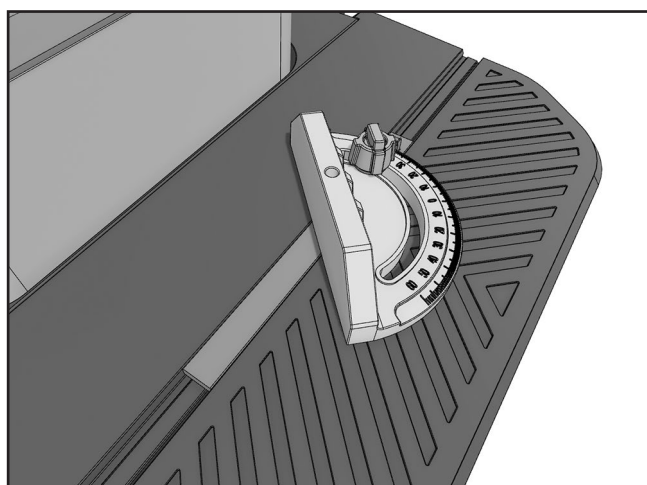


Figure 36. Miter gauge adjusted for bevel sanding.

Adjusting Work Table Angle

1. DISCONNECT MACHINE FROM POWER!
2. Loosen both table tilt lock knobs (see **Figure 37**).
3. Press down spring plate to disengage it from detents in table tilt stop bracket (see **Figure 37**).

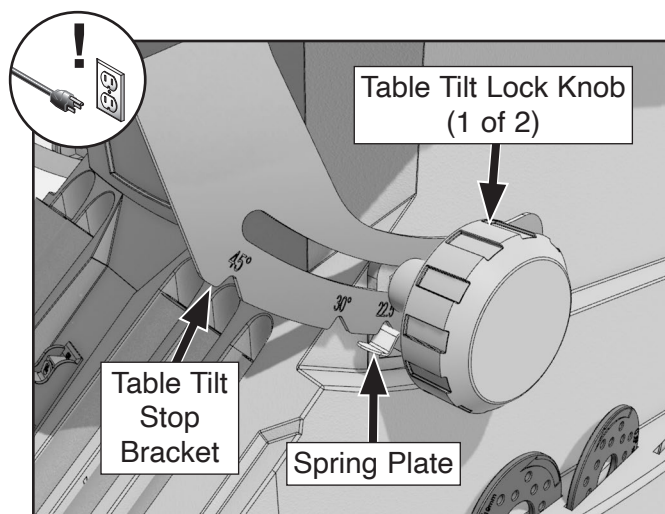


Figure 37. Location of table tilt components.

4. Tilt table to desired angle.

Note: Release spring plate to snap table into place at 0°, 15°, 22.5°, 30°, or 45°.

5. Tighten both lock knobs to secure setting.



Adjusting Miter Gauge Angle

1. DISCONNECT MACHINE FROM POWER!
2. Place miter gauge in table miter slot.
3. Loosen miter gauge lock knob shown in **Figure 38**.

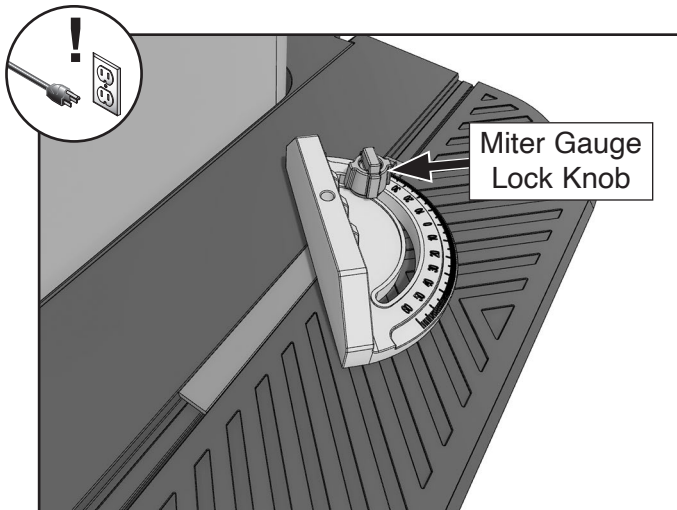


Figure 38. Location of miter gauge lock knob.

4. Adjust angle of miter gauge, then tighten lock knob to secure.

Bevel Sanding

1. Turn sander **ON** and allow it to reach full speed.
2. Using both hands to maintain control of workpiece, slowly guide it against rotation of sanding surface (see **Figure 39**) until desired results are achieved.

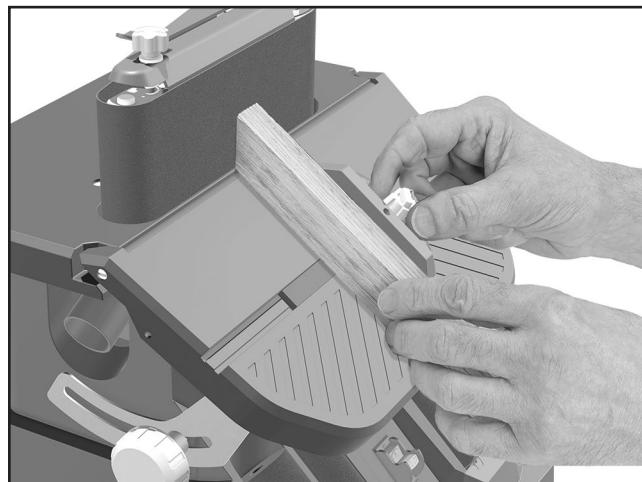
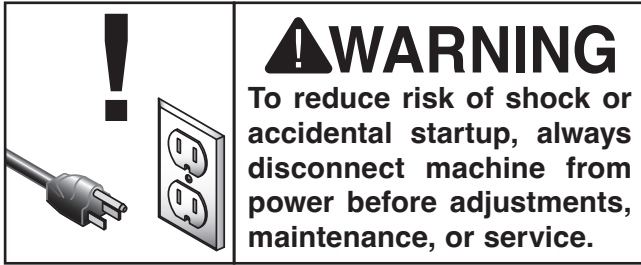


Figure 39. Example of bevel edge sanding.

3. Turn sander **OFF**.



SECTION 5: 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.
- Clogged, worn, or damaged sanding sleeve/belt.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance

- Clean any shavings and dust from between platen and sanding belt on edge sanding attachment.

Monthly Maintenance

- Check drive belt for correct tension, damage, or wear.
- Clean/vacuum dust buildup from inside base and off motor.

Cleaning

Cleaning the Model G0426 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Cleaning Sanding Sleeve/Belt

When a sandpaper surface becomes clogged with resin or gummy sawdust, the efficiency of the sanding operation is significantly reduced and can leave glazed or gouge marks in the workpiece. Using a rubber gum abrasive cleaner can prolong the life of a clogged sanding sleeve or belt, provided it is otherwise in good condition.

Always discard worn sanding sleeves/belts. As abrasives begin to wear, grit will begin to fall off, causing deep gouges in the workpiece. Glue used to hold the grit to the paper will rub off onto the workpiece, causing burns and interfering with final finishing.

To clean sanding sleeve/belt:

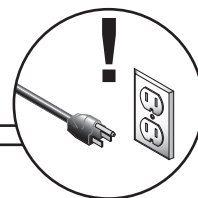
1. Turn machine **ON**.
2. Using table as support, rub abrasive cleaner on sanding sleeve/belt in continuous motion, covering entire surface of sleeve/belt until sleeve/belt is no longer clogged.
3. Turn machine **OFF**.



SECTION 6: 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.	1. Switch disabling key removed. 2. Blown machine fuse. 3. Incorrect power supply voltage or circuit size. 4. Power supply circuit breaker tripped or fuse blown. 5. Motor wires connected incorrectly. 6. Wiring broken, disconnected, or corroded. 7. Motor brushes worn out. 8. Motor or motor bearings at fault.	1. Install switch disabling key. 2. Replace fuse (Page 36)/ensure no shorts. 3. Ensure correct power supply voltage and circuit size (Page 11). 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Correct motor wiring connections (Page 38). 6. Fix broken wires or disconnected/corroded connections (Page 38). 7. Replace brushes (Page 33). 8. Replace motor.
Machine stalls or is underpowered.	1. Motor wires connected incorrectly. 2. Motor brushes worn out. 3. Motor overheated. 4. Extension cord too long. 5. Motor or motor bearings at fault.	1. Correct motor wiring connections (Page 38). 2. Replace brushes (Page 33). 3. Clean motor, let cool, and reduce workload. 4. Move machine closer to power supply; use shorter extension cord (Page 12). 5. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operation

Symptom	Possible Cause	Possible Solution
Machine stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Drive belts slipping/pulleys misaligned. 3. Pulley slipping on shaft. 4. Machine undersized for task.	1. Only sand wood/ensure moisture is below 20% (Page 20). 2. Clean/replace belts (Page 34); ensure pulleys are aligned. 3. Tighten/replace loose pulley/shaft. 4. Clean (Page 30)/replace sanding sleeve (Page 21)/belt (Page 27); reduce feed rate/sanding depth.
Machine has vibration or noisy operation.	1. Drive belts worn, loose, pulleys misaligned or belt slapping frame. 2. Pulley loose. 3. Incorrectly mounted to workbench. 4. Spindle loose, improperly installed, or damaged.	1. Inspect/replace drive belts with a new matched set (Page 34). Realign pulleys if necessary. 2. Secure pulley on shaft. 3. Adjust/shim feet, or tighten mounting hardware. 4. Tighten loose spindle, re-install spindle ensuring mating surfaces are clean, replace spindle if damaged.



Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	5. Sanding belt not tensioned. 6. Broken/defective sanding belt.	5. Tension sanding belt. 6. Replace sanding belt (Page 27).
Deep sanding grooves or scores in workpiece.	1. Workpiece sanded across grain. 2. Excessive workpiece pressure. 3. Sanding sleeve/belt too coarse for desired finish.	1. Sand workpiece with grain. 2. Reduce workpiece pressure. 3. Replace with finer (Page 21) grit sleeve/belt.
Snake-shaped marks on workpiece.	1. Sanding sleeve/belt dirty/damaged.	1. Clean (Page 30)/replace sanding sleeve (Page 21)/belt (Page 27).
Glazed sanding surfaces.	1. Sanding wet stock. 2. Sanding stock with high pitch/residue. 3. Sanding sleeve/belt worn or filled with pitch/residue.	1. Only sand wood with moisture below 20% (Page 20). 2. Use different stock or accept characteristics and plan on frequently cleaning (Page 30)/replacing sanding sleeves (Page 21)/belts (Page 27). 3. Replace sleeve (Page 21)/belt (Page 27).
Poor/non-aggressive sanding results.	1. Sanding sleeve/belt too fine for desired finish. 2. Sanding sleeve/belt clogged/worn.	1. Replace with coarser (Page 21) grit sleeve/belt. 2. Clean (Page 30)/replace sleeve (Page 21)/belt (Page 27).
Sanding sleeve/belt clogs quickly.	1. Sanding wet stock. 2. Excessive workpiece pressure. 3. Sanding sleeve/belt too fine for desired finish. 4. Sanding softwood. 5. Worn sanding sleeve/belt. 6. Poor dust collection.	1. Only sand wood/ensure moisture is below 20% (Page 20). 2. Reduce workpiece pressure. 3. Replace with coarser (Page 21) grit sleeve/belt. 4. Use different stock or accept characteristics and plan on frequently cleaning (Page 30)/replacing sanding sleeves (Page 21)/belts (Page 27). 5. Replace sleeve (Page 21)/belt (Page 27). 6. Unclog ducts; close gates to improve suction; redesign dust collection system.
Sanding belt slips during use.	1. Sanding belt not tensioned. 2. Excessive workpiece pressure. 3. Drive belts are worn.	1. Tension sanding belt. 2. Reduce workpiece pressure. 3. Replace drive belts (Page 34).
Burn marks on workpiece.	1. Excessive workpiece pressure. 2. Sanding sleeve/belt too fine for desired finish. 3. Sanding sleeve/belt clogged/worn.	1. Reduce workpiece pressure. 2. Replace with coarser (Page 21) grit sleeve/belt. 3. Clean (Page 30)/replace sleeve (Page 21)/belt (Page 27).
Workpiece not sanded square when table tilt is set to 0°.	1. Table is not square to spindle.	1. Calibrate table tilt (Page 37).
Abrasive grit rubs off easily.	1. Sanding sleeve/belt has been stored in an incorrect environment. 2. Sanding sleeve/belt has been folded or crushed.	1. Replace sleeve (Page 21)/belt (Page 27). Store sleeve (Page 21)/belt in a cool, dry area. 2. Replace sleeve (Page 21)/belt (Page 27). Do not bend/fold sleeve/belt.
Workpiece frequently gets pulled out of your hands.	1. Not supporting workpiece against table, backstop, or miter gauge. 2. Starting workpiece on a leading corner.	1. Use support fixtures to support workpiece. 2. Start workpiece on a trailing corner.
Sanding belt runs off top or bottom of rollers.	1. Sanding belt not tensioned. 2. Sanding belt is worn, damaged, or misshapen.	1. Tension sanding belt. 2. Replace sanding belt (Page 27).



Replacing Motor Brushes

The permanent magnet motor uses two carbon brushes to transmit electrical current inside of it. These brushes are considered to be regular wear items or "consumable," and 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.

Symptoms that the brushes have worn beyond their usable life may include a loss of power, inconsistent operation of the motor (motor cuts in and out inexplicably), or an inability of the motor to start. Replace both carbon brushes as a set when you experience these symptoms, or when the brushes measure less than 1/2" long. We recommend replacing them one at a time so you can keep track of which wire connects to each brush.

If your machine is used frequently, we recommend you keep an extra set of these replacement brushes on-hand to avoid any downtime. The replacement procedure can usually be done in about 15 minutes.

Items Needed	Qty
Scrap Wood Blocks.....	As Needed
Phillips Head Screwdriver #2	1
Flat Head Screwdriver 1/4".....	1
Replacement Brush Pair (P0426010-1)	1 Set

To replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Remove all sanding attachments, then place sander upside down on blocks (see **Figure 40**), ensuring proper clearance of spindle.
3. Remove (6) screws that secure base plate to remove base plate (see **Figure 40**).

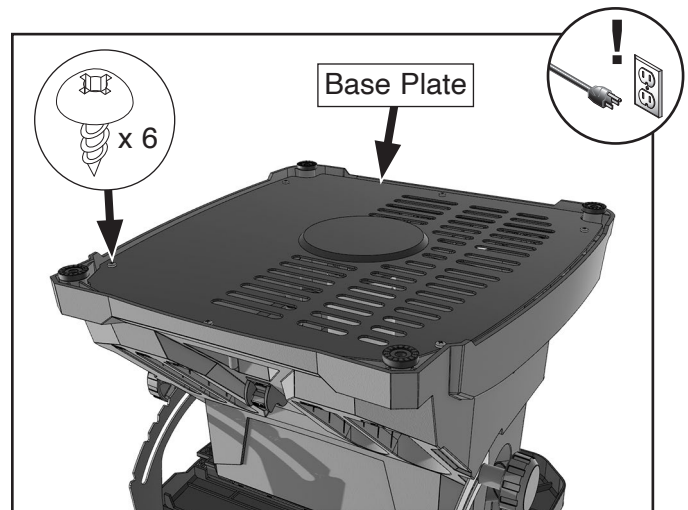


Figure 40. Location of base plate and screws.

4. Gently press tab on wire terminal shown in **Figure 41** so you can remove wire and release brush assembly from motor.

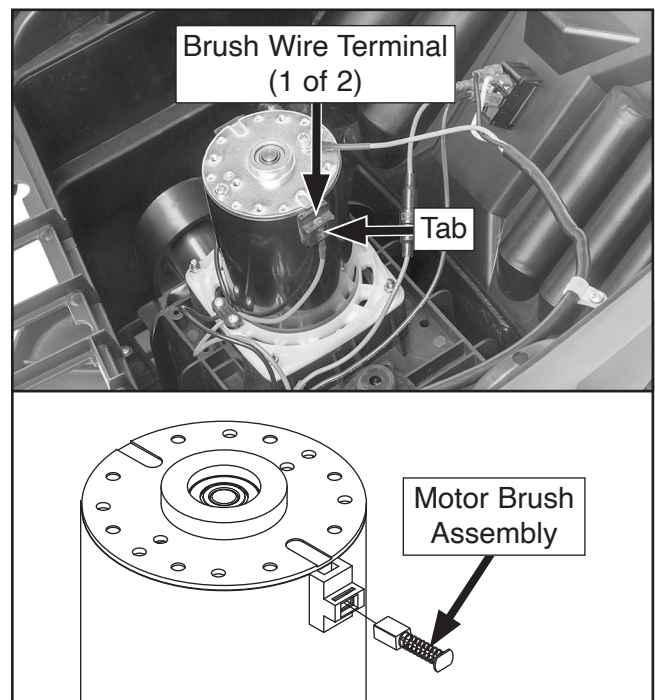


Figure 41. Brush assembly under wire terminal.

5. Replace motor brush assembly, and connect wire to secure.
6. Repeat **Steps 4–5** with second brush assembly.
7. Install base plate and place machine upright.



Replacing Drive Belts

The following procedure details removal and replacement of the drive belts. Refer to the parts breakdown and list to aid in proper identification of parts referenced in the procedure.

Items Needed	Qty
Scrap Wood Blocks.....	As Needed
Phillips Head Screwdriver #2	1
Replacement Drive Belts (P0426026)	2

To replace drive belts:

1. DISCONNECT MACHINE FROM POWER!
2. Remove all sanding attachments, then place sander upside down on blocks (see **Figure 42**), ensuring proper clearance of spindle.
3. Remove (6) screws that secure base plate to remove base plate (see **Figure 42**).

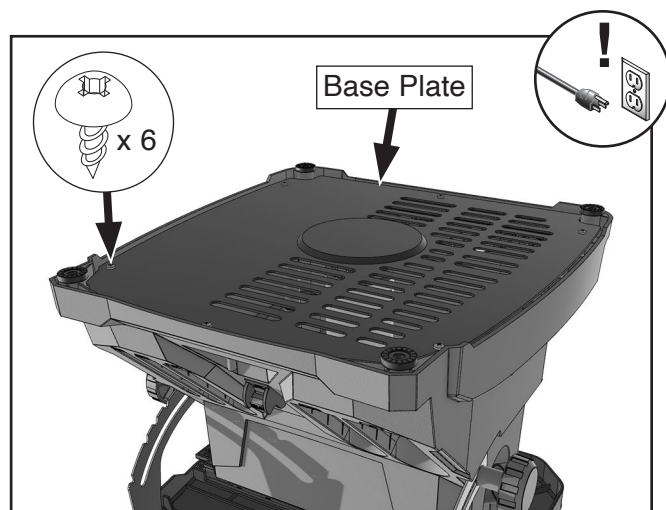


Figure 42. Location of base plate and screws.

4. Disconnect (2) wires at bridge rectifier that also attach to ON/OFF switch (see **Figure 43**).
5. Remove screw shown in **Figure 43** to disconnect green ground wire from motor.

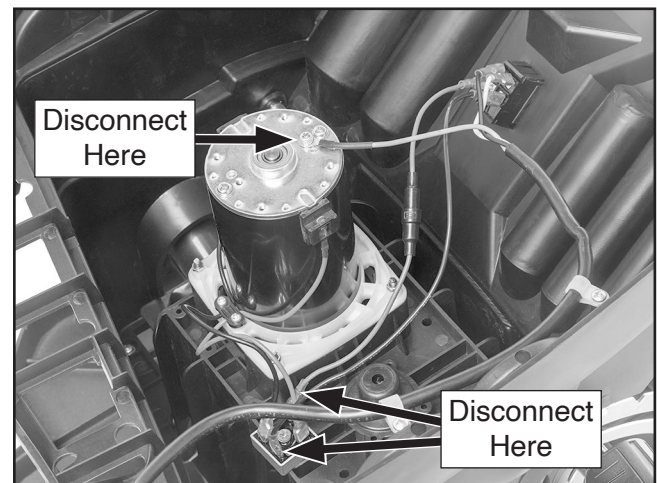


Figure 43. Wire connections to disconnect.

6. Remove (8) screws shown in **Figure 44** in order to remove motor assembly from machine.

Note: Screws have captive lock and flat washers on them.

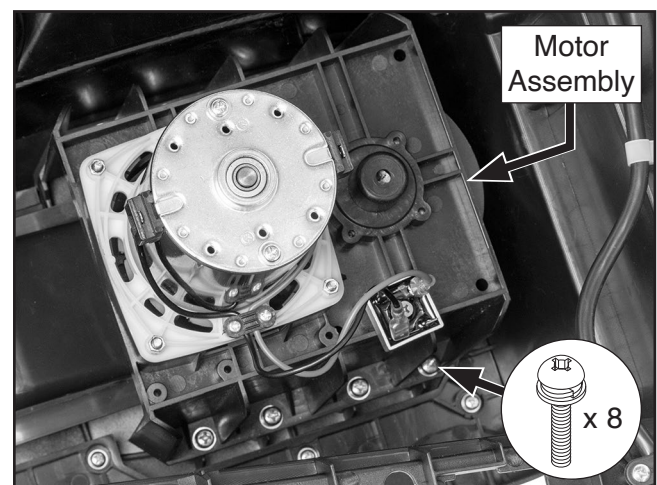


Figure 44. Location of motor assembly and motor assembly screws.



7. Remove (4) screws shown in **Figure 45**, then carefully pull spindle away from motor. Spindle pulleys and drive belts will disengage from motor pulley.

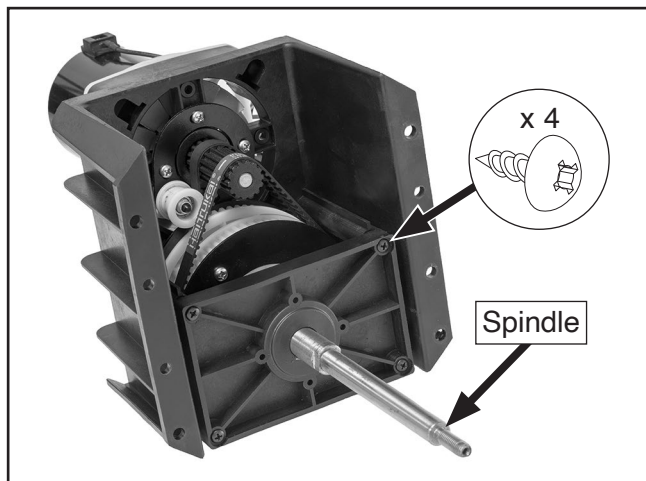


Figure 45. Location of spindle and spindle assembly screws.

8. Remove and replace drive belts on spindle pulleys (see **Figure 46**).

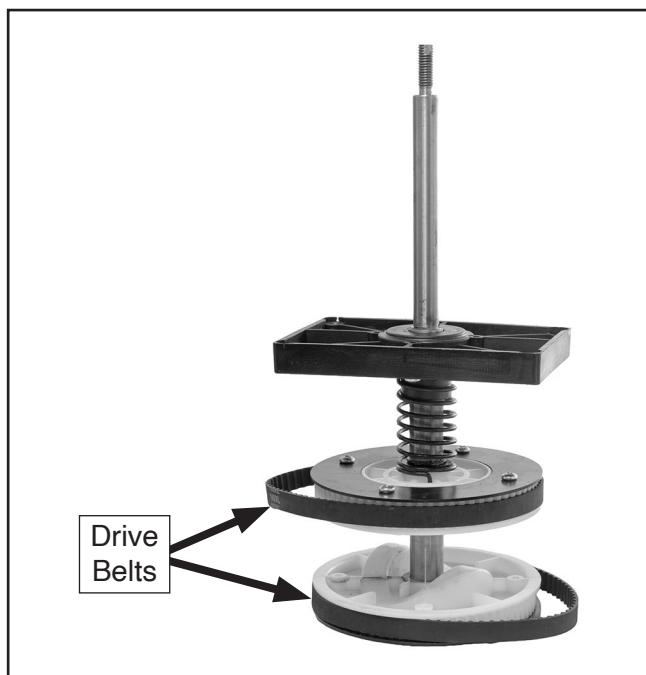


Figure 46. Location of drive belts on spindle pulleys.

9. Ensure spindle bushing shown in **Figure 47** is in place, then insert base of spindle shaft back into hole, but do not attach assembly.

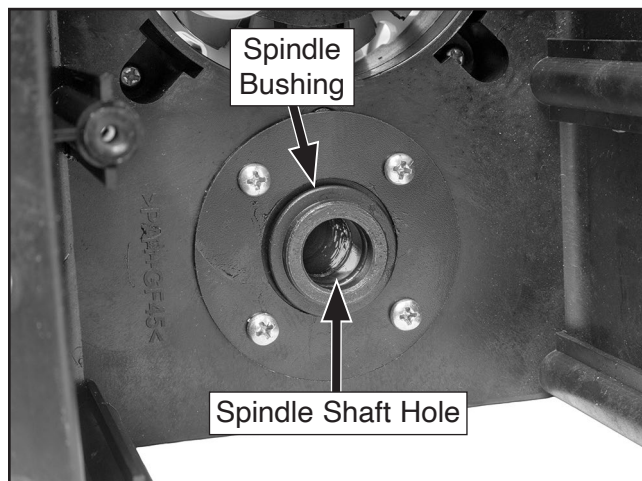


Figure 47. Spindle bushing installed around spindle shaft hole.

10. Position new drive belts around pulleys as shown in **Figure 48**.

Note: Lower drive belt must route around inside of tension roller, as shown in **Figure 48**.

11. Install screws removed in **Step 7** to secure spindle assembly. Ensure pulleys and drive belts turn freely before proceeding (see **Figure 48**).

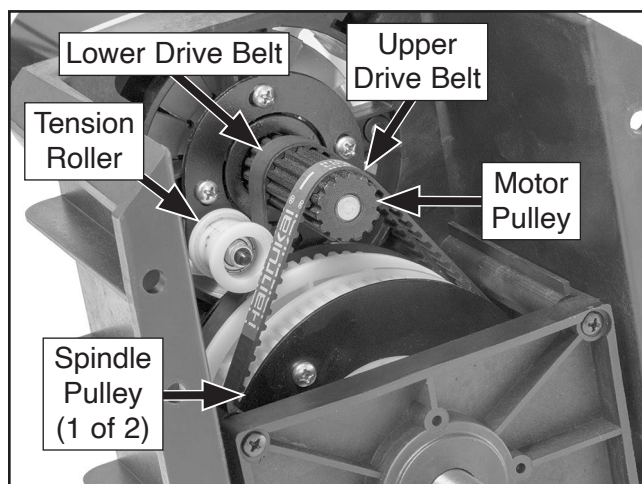


Figure 48. Drive belts positioned correctly around pulleys and tension roller.

12. Install motor assembly and connect wires removed in **Steps 4–5** (refer to **Wiring Diagram** on **Page 39**).
13. Install base plate and place machine upright.

Replacing Fuse

This machine features a fuse designed to protect the bridge rectifier and motor in the event of an electrical overload. If the fuse burns out, replace it.

Items Needed	Qty
Scrap Wood Blocks.....	As Needed
Phillips Head Screwdriver #2	1
Replacement Fuse 10A 250V (P0426108)	1

To replace fuse:

1. DISCONNECT MACHINE FROM POWER!
2. Remove all sanding attachments, then place sander upside down on blocks (see **Figure 49**), ensuring proper clearance of spindle.
3. Remove (6) screws that secure base plate to remove base plate (see **Figure 49**).

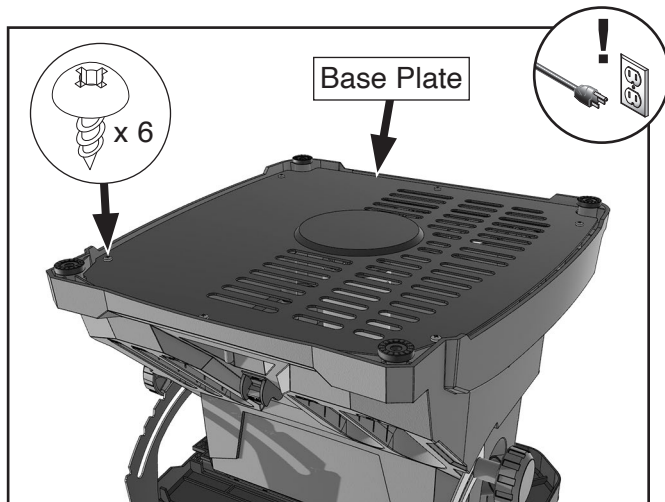


Figure 49. Location of base plate and screws.

4. Twist either side of fuse holder counterclockwise to open (see **Figure 50**).

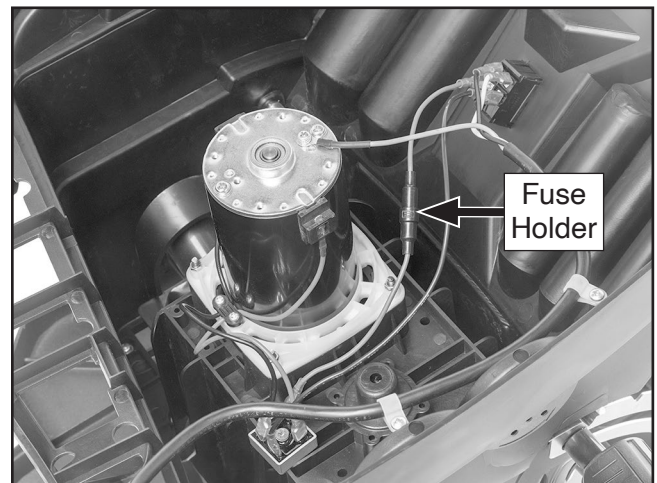


Figure 50. Location of fuse holder.

5. Remove old fuse and replace with new one.
6. Push sides of fuse holder together, then twist clockwise to secure.
7. Install base plate and place machine upright.



Calibrating Table Tilt

For best sanding results, ensure the spring plate engages the table tilt stop bracket at the correct angles. If calibrated correctly, the sanding surface should be 90° to the tilting table when the 0° detent is engaged.

Items Needed	Qty
90° Square	1
Phillips Head Screwdriver #2	1

To calibrate table tilt:

1. DISCONNECT MACHINE FROM POWER!
2. Install edge sanding attachment, and remove sanding belt.
3. Adjust table to 0°, then place 90° square on table against platen (see **Figure 51**).

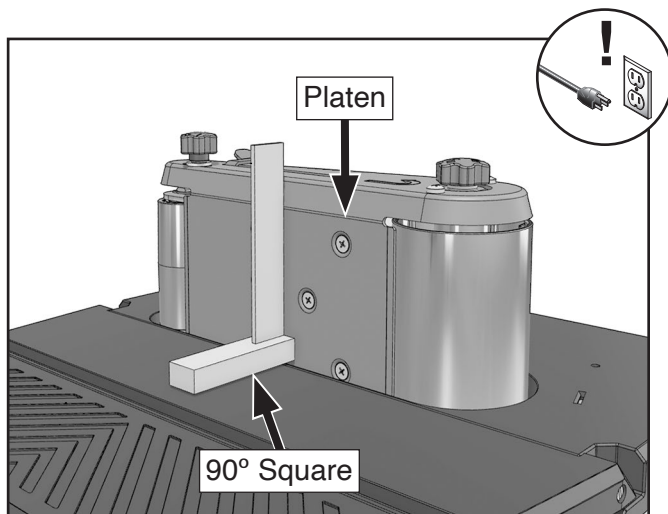


Figure 51. Checking table squareness at 0°.

- If table *is* square to platen when spring plate is engaged with 0° detent in table tilt stop bracket, no adjustment is required.
- If table *is not* square to platen when spring plate is engaged with 0° detent in table tilt stop bracket, proceed to **Step 4**.

4. Loosen (2) spring plate screws (see **Figure 52**).

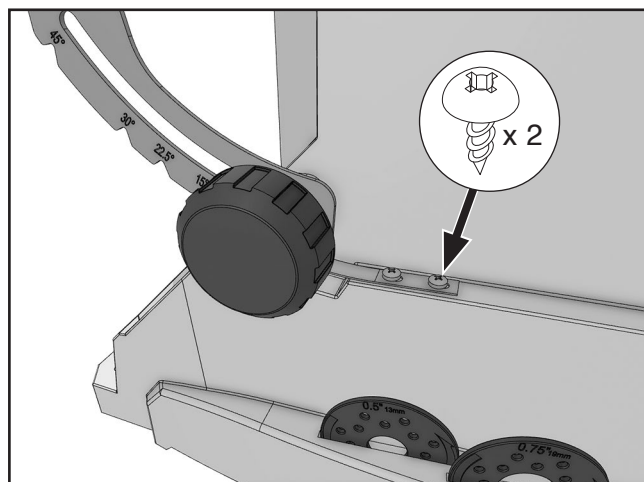


Figure 52. Location of spring plate screws.

5. Use square to adjust table angle until table is square to platen, then tighten table tilt lock knobs to secure.
6. Move spring plate so it fully engages 0° detent in table tilt stop bracket (see **Figure 53**), then tighten screws from **Step 4**.

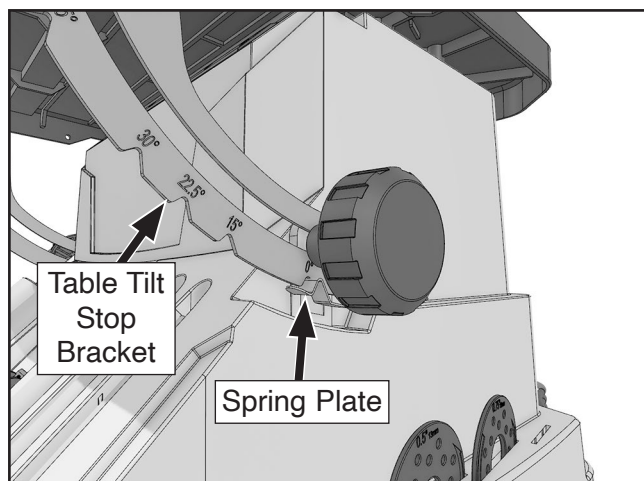


Figure 53. Spring plate engaging table tilt stop bracket at 0°.



SECTION 7: 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

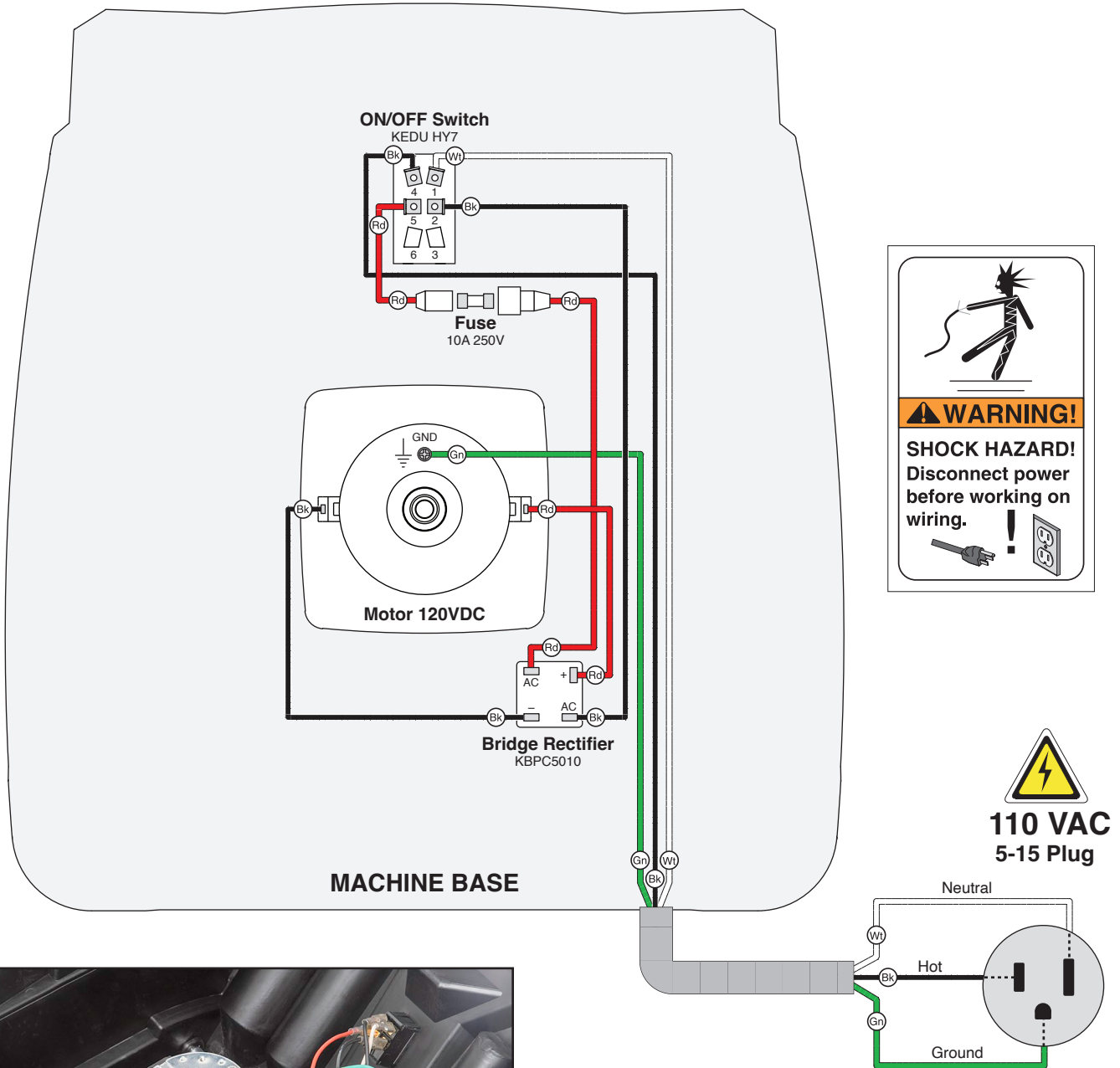
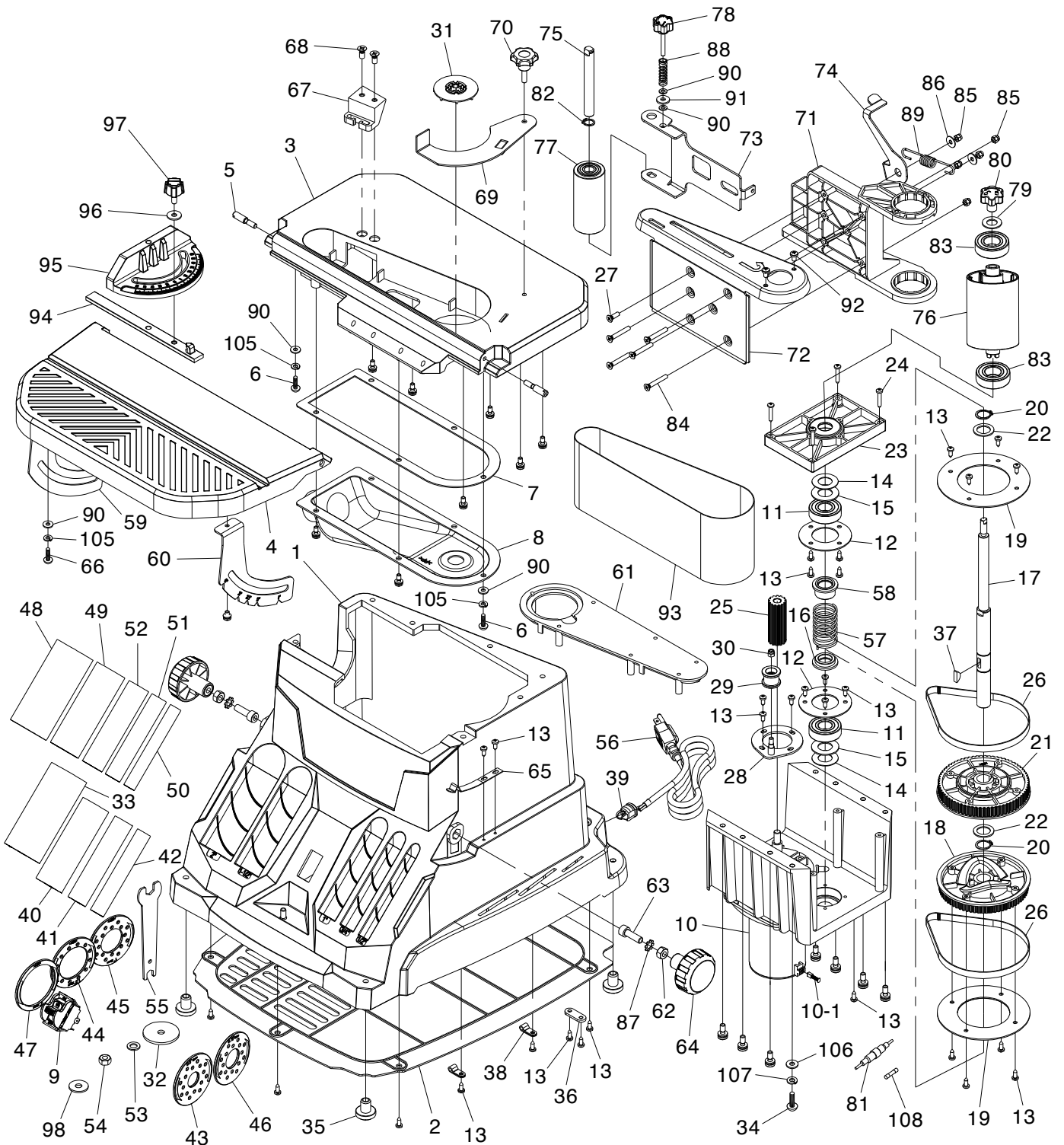


Figure 54. Machine wiring.

SECTION 8: PARTS

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

Main



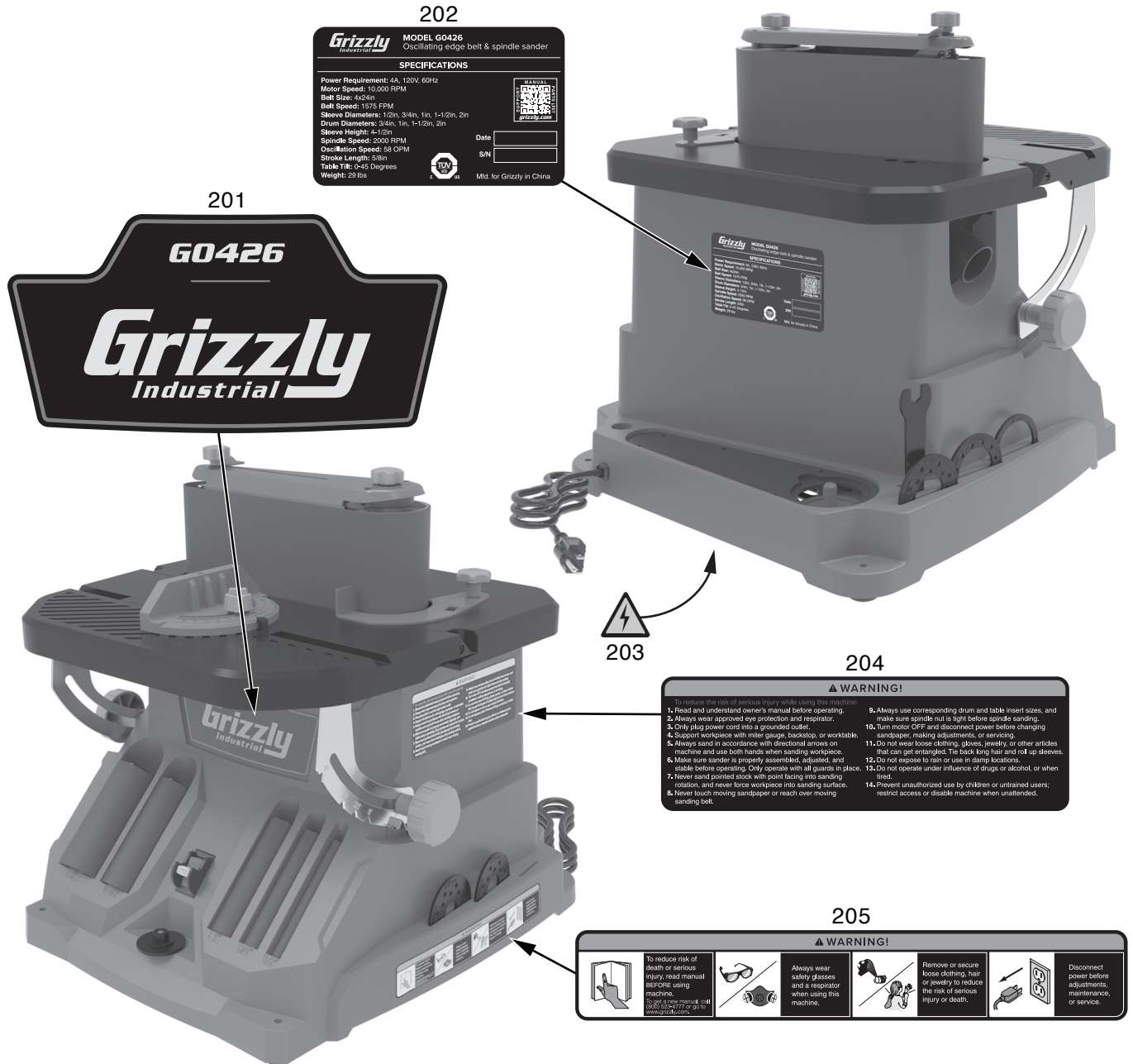
Main Parts List

REF	PART #	DESCRIPTION
1	P0426001	BASE
2	P0426002	BASE PLATE
3	P0426003	FIXED TABLE
4	P0426004	TILT TABLE
5	P0426005	PIVOT PIN 8 X 37
6	P0426006	PHLP HD SCR M5-.8 X 12
7	P0426007	DUST PORT GASKET
8	P0426008	DUST PORT 1-1/2"
9	P0426009	ON/OFF SWITCH KEDU HY7
10	P0426010	MOTOR ASSEMBLY 480W 120VDC
10-1	P0426010-1	CARBON BRUSH (2-PC SET)
11	P0426011	BALL BEARING 6203LLB
12	P0426012	BEARING COVER
13	P0426013	TAP SCREW M4.2 X 12
14	P0426014	GASKET 17.5 X 32.5 X 0.8MM RUBBER
15	P0426015	GASKET 18 X 34 X 1.5MM FELT
16	P0426016	FLANGED BUSHING 17 X 31.5 X 8MM
17	P0426017	SPINDLE
18	P0426018	SPINDLE TIMING PULLEY 69T
19	P0426019	PULLEY COVER
20	P0426020	EXT RETAINING RING 17MM
21	P0426021	SPINDLE TIMING PULLEY 70T
22	P0426022	FLAT WASHER 17 X 25.5 X 1.5MM
23	P0426023	SPRING BLOCK
24	P0426024	TAP SCREW M4.2 X 25
25	P0426025	MOTOR PULLEY
26	P0426026	TIMING BELT 160XL
27	P0426027	FLAT HD SCR M5-.8 X 16
28	P0426028	BELT TENSION FRAME
29	P0426029	BELT TENSION ROLLER
30	P0426030	ROLLER NUT M5-.8
31	P0426031	KEYED HUB PLATE
32	P0426032	FLAT WASHER 8.4 X 45 X 3MM
33	P0426033	SANDING DRUM 2"
34	P0426034	PHLP HD SCR M6-1 X 16
35	P0426035	RUBBER FOOT
36	P0426036	CORD CLAMP
37	P0426037	WOODRUFF KEY 5 X 15.7MM
38	P0426038	LOOP CLAMP 3/16"
39	P0426039	STRAIN RELIEF 5/8"
40	P0426040	SANDING DRUM 1-1/2"
41	P0426041	SANDING DRUM 1"
42	P0426042	SANDING DRUM 3/4"
43	P0426043	TABLE INSERT 1/2"
44	P0426044	TABLE INSERT 1-1/2"
45	P0426045	TABLE INSERT 1"
46	P0426046	TABLE INSERT 3/4"
47	P0426047	TABLE INSERT 2"
48	P0426048	SANDING SLEEVE 2" X 4-1/2" 80-GRIT
49	P0426049	SANDING SLEEVE 1-1/2" X 4-1/2" 80-GRIT
50	P0426050	SANDING SLEEVE 1/2" X 4-1/2" 80-GRIT
51	P0426051	SANDING SLEEVE 3/4" X 4-1/2" 80-GRIT

REF	PART #	DESCRIPTION
52	P0426052	SANDING SLEEVE 1" X 4-1/2" 80-GRIT
53	P0426053	FLAT WASHER 8MM
54	P0426054	HEX NUT M8-1.25
55	P0426055	SPINDLE WRENCH 10 X 13MM OPEN-END
56	P0426056	POWER CORD 18G 3W 72" 5-15P
57	P0426057	COMPRESSION SPRING 2 X 30 X 50
58	P0426058	FLANGED BUSHING 17 X 31.5 X 16MM
59	P0426059	TILT BRACKET L
60	P0426060	TILT BRACKET R
61	P0426061	THROAT PLATE
62	P0426062	HEX NUT M8-1.25
63	P0426063	CAP SCREW M8-1.25 X 25
64	P0426064	KNOB M8-1.25
65	P0426065	DETENT SPRING PLATE
66	P0426066	PHLP HD SCR M5-.8 X 8
67	P0426067	DRUM HOUSING SUPPORT
68	P0426068	FLAT HD SCR M6-1 X 14
69	P0426069	BACKSTOP
70	P0426070	KNOB BOLT M6-1 X 10
71	P0426071	SANDING BELT FRAME
72	P0426072	PLATEN
73	P0426073	IDLER ROLLER FRAME
74	P0426074	BELT TENSION LEVER
75	P0426075	IDLER ROLLER SHAFT
76	P0426076	DRIVE ROLLER
77	P0426077	IDLER ROLLER
78	P0426078	KNOB BOLT M5-.8 X 36
79	P0426079	FLAT WASHER 13 X 24 X 1.5MM
80	P0426080	KNOB M8-1.25
81	P0426081	INLINE FUSE HOLDER
82	P0426082	EXT RETAINING RING 12MM
83	P0426083	BALL BEARING 6004-2RS
84	P0426084	FLAT HD SCR M5-.8 X 35
85	P0426085	LOCK NUT M5-.8
86	P0426086	FENDER WASHER 5MM
87	P0426087	EXT TOOTH WASHER 8MM
88	P0426088	COMPRESSION SPRING 1 X 10 X 36
89	P0426089	EXTENSION SPRING 2 X 13 X 86.5
90	P0426090	FLAT WASHER 5MM
91	P0426091	FLAT WASHER 6.2 X 16 X 2MM RUBBER
92	P0426092	PHLP HD SCR M5-.8 X 8
93	P0426093	SANDING BELT 4" X 24 80-GRIT
94	P0426094	MITER BAR
95	P0426095	MITER GAUGE BODY
96	P0426096	FENDER WASHER 6MM
97	P0426097	KNOB BOLT M6-1 X 16
98	P0426098	FENDER WASHER 8MM
105	P0426105	LOCK WASHER 5MM
106	P0426106	FLAT WASHER 6MM
107	P0426107	LOCK WASHER 6MM
108	P0426108	FUSE 10A 250V



Labels & Cosmetics



REF PART # DESCRIPTION

201	P0426201	MODEL NUMBER/GRIZZLY LABEL
202	P0426202	ID LABEL
203	P0426203	ELECTRICITY LABEL

REF PART # DESCRIPTION

204	P0426204	WARNING LIST LABEL
205	P0426205	WARNING COMBO LABEL

! WARNING

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



WARRANTY & RETURNS

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

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

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

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

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

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

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





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