MODEL G0898
2" X 48" 2-WHEEL BELT GRINDER/SANDER
OWNER'S MANUAL
(For models manufactured since 12/19)
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.

**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](http://www.grizzly.com).

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

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

![Diagram of the sander with labeled controls and features]

**WARNING**

For Your Own Safety Read Instruction Manual Before Operating Sander

a) Wear eye protection.
b) Support workpiece backstop or worktable.
c) Maintain $\frac{1}{16}$ in. maximum clearance between table and sanding belt.
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.

Component Descriptions

A. Belt Access Door Knob: Opens and closes belt access door.
B. Belt Access Door: Opens and closes to allow for belt replacement and maintenance.
C. Belt Tracking Adjustment Handle: Fine tunes tracking along platen and wheels.
D. Belt Tension Lever: Releases and engages belt tension for removal or adjustment.
E. ON/OFF Switch with Removable Key: Turns motor ON/OFF and prevents accidental startup.
F. Circuit Breaker Reset Button: Restores power to motor when pressed after overload.
G. Tilt Lock: Releases to allow for 0°–90° grinder position adjustment and secures to lock grinder in place.
H. Platen: Provides flat surface belt support when surface grinding.
I. Work Table/Support: Supports workpiece during operations and adjusts 0°–90°.
J. Contact Wheel: Drives belt and provides belt support for an additional grinding surface.

Figure 1. Sanding belt controls.

Figure 2. Power controls.

Figure 3. Work area components.
MODEL G0898 2" X 48" 2-WHEEL BELT GRINDER/SANDER

Product Dimensions:

- Weight: 95 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height: 22-1/2 x 28-1/2 x 28-1/2 in.
- Footprint (Length x Width): 10-1/2 x 13 in.

Shipping Dimensions:

- Type: Wood Crate
- Content: Machine
- Weight: 137 lbs.
- Length x Width x Height: 25 x 28 x 17 in.
- Must Ship Upright: Yes

Electrical:

- Power Requirement: 110V or 220V, Single-Phase, 60 Hz
- Prewired Voltage: 110V
- Full-Load Current Rating: 11A at 110V, 5.5A at 220V
- Minimum Circuit Size: 15A
- 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
- Recommended Plug Type: 6-15 for 220V
- Switch Type: Paddle Safety Switch w/Removable Key

Motor:

- Main
  - Horsepower: 1 HP
  - Phase: Single-Phase
  - Amps: 11A/5.5A
  - Speed: 1720 RPM
  - Type: TEFC Capacitor-Start Induction
  - Power Transfer: Belt
  - Bearings: Shielded & Permanently Sealed
  - Centrifugal Switch/Contacts Type: External
Main Specifications:

Belt Sander Info

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sanding Belt Width</td>
<td>2 in.</td>
</tr>
<tr>
<td>Sanding Belt Length</td>
<td>48 in.</td>
</tr>
<tr>
<td>Sanding Belt Speed</td>
<td>4000 FPM</td>
</tr>
<tr>
<td>Sanding Belt Tilt</td>
<td>0 - 90 deg.</td>
</tr>
<tr>
<td>Table Length</td>
<td>3-5/8 in.</td>
</tr>
<tr>
<td>Table Width</td>
<td>2-1/2 in.</td>
</tr>
<tr>
<td>Table Thickness</td>
<td>3/8 in.</td>
</tr>
<tr>
<td>Table Tilt</td>
<td>0 - 90 deg.</td>
</tr>
<tr>
<td>Table-to-Floor Height</td>
<td>8-1/2 in.</td>
</tr>
<tr>
<td>Max Height of Belt in Vertical Position</td>
<td>24 in.</td>
</tr>
<tr>
<td>Contact Wheel Diameter</td>
<td>7 in.</td>
</tr>
<tr>
<td>Contact Wheel Width</td>
<td>2 in.</td>
</tr>
<tr>
<td>Idler Wheel Diameter</td>
<td>6 in.</td>
</tr>
<tr>
<td>Idler Wheel Width</td>
<td>2 in.</td>
</tr>
<tr>
<td>Belt Tension Release Type</td>
<td>Quick-Release</td>
</tr>
</tbody>
</table>

Construction Info

<table>
<thead>
<tr>
<th>Feature</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Base</td>
<td>Formed Steel</td>
</tr>
<tr>
<td>Frame</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>Paint Type/Finish</td>
<td>Powder Coated</td>
</tr>
</tbody>
</table>

Other Specifications:

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Country of Origin</td>
<td>Taiwan</td>
</tr>
<tr>
<td>Warranty</td>
<td>1 Year</td>
</tr>
<tr>
<td>Approximate Assembly &amp; Setup Time</td>
<td>30 Minutes</td>
</tr>
<tr>
<td>Serial Number Location</td>
<td>ID Label</td>
</tr>
</tbody>
</table>

Features:

- 4000 FPM
- 2" X 48" 150-Grit Belt Included
- Work Table with Adjustable Angle
- Removable Vertical Platen
- Built-In Circuit Breaker
- Frame Pivots 90 Deg. for Vertical and Horizontal Grinding
- Single-Knob Tracking Adjustment
- Rubber-Coated Contact Wheel
- Quick-Release Belt Tension Lever
SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

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

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

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

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

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

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

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.
WEARING PROPER APPAREL.  Do not wear clothing, apparel or jewelry that can become entangled in moving parts.  Always tie back or cover long hair.  Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Serious injury or death can occur from fingers, clothing, jewelry, or hair getting pinched/entangled in rotating belt or other moving components. Abrasion injuries can occur from touching moving grinding belt with bare skin. Workpieces or ground-off particles thrown by grinding belt can strike operator or bystanders, causing impact injuries, or blindness. Long-term respiratory damage can occur from using grinder without wearing a respirator. To reduce the risk of these hazards, operator or bystanders MUST completely heed the hazards and warnings below.

IN-RUNNING NIP POINTS. The gap between moving grinding belt and table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater the risk of fingers or workpieces getting caught in it. Minimize the risk of pinch and crush injuries by adjusting table/support to no more than 1/16" away from belt.

GRINDING DUST. Grinding creates large amounts of airborne dust particles that can cause eye injury or respiratory illness. Reduce your risk by always wearing approved eye and respiratory protection when using grinder.

ABRASIVE CONDITION. Worn or damaged sandpaper can fly apart and throw debris, or aggressively grab workpiece, causing injury from operator loss of workpiece control. Always inspect belt before operation and replace if worn or damaged.

HOT WORKPIECES. Grinding friction will cause workpiece to quickly get hot, causing burns to the skin. Wear protective gloves and apron if grinding for an extended time. Do not touch freshly ground surfaces or nearby areas without first cooling them or allowing them to cool.

MINIMUM STOCK DIMENSION. Small workpieces can be aggressively pulled from your hands, causing contact with belt surface. Always use a jig or other holding device when grinding small workpieces, and keep hands and fingers at least 2" away from abrasive surface.

FLAMMABLE MATERIALS. Grinding metal will cause sparks. Make sure there are no flammable or combustible materials near machine.

ABRASIVE DIRECTION. Feeding workpiece incorrectly can cause it to be thrown from machine, striking operator or bystanders, or causing hands to slip into moving sandpaper. To reduce these risks, only grind against direction of sandpaper travel, ensure workpiece is properly supported, and avoid introducing sharp edges into moving belt on the leading side of the workpiece.

HAND PLACEMENT. Rotating belt can remove skin quickly. Always keep hands away from moving belt during operation. Stop machine before cleaning dust from table.

FEEDING WORKPIECE. Forcefully jamming workpiece into abrasive surface could cause it to be grabbed aggressively, pulling hands into abrasive surface. Firmly grasp workpiece in both hands and ease it into belt using light pressure.

AVOIDING ENTANGLEMENT. Becoming entangled in moving parts can cause severe injury or death. Keep all guards in place and closed; DO NOT wear loose clothing, gloves, or jewelry; and tie back long hair.

WORKPIECE INTEGRITY & SUPPORT. Grinding fragile workpieces can result in loss of control, resulting in abrasion injuries, pinch/impact injuries, or damage to abrasive belt. Only grind solid workpieces that can withstand power grinding forces. Properly support workpiece; avoid grinding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when grinding force is applied. Always grind with workpiece firmly against table or another support device.
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.

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.

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

Full-Load Current Rating at 110V..... 11 Amps
Full-Load Current Rating at 220V .... 5.5 Amps

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

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

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

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

Circuit Requirements for 110V
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

Circuit Requirements for 220V
This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to Voltage Conversion instructions for details.)

Nominal Voltage ....... 208V, 220V, 230V, 240V
Cycle..............................60 Hz
Phase........................... Single-Phase
Power Supply Circuit .............. 15 Amps
Plug/Receptacle ................. NEMA 6-15
Grounding Requirements
This machine MUST be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

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 ......................... 14 AWG
Maximum Length (Shorter is Better)........ 50 ft.
**Converting Voltage to 220V**

The voltage conversion MUST be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the motor and installing the correct plug. A wiring diagram is provided on Page 33 for your reference.

**Items Needed**

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Phillips Head Screwdriver #2 ............... 1</td>
</tr>
<tr>
<td>• Electrical Tape.......................... As Needed</td>
</tr>
<tr>
<td>• Wire Cutters/Stripper..................... 1</td>
</tr>
<tr>
<td>• NEMA 6-15 Plug........................... 1</td>
</tr>
<tr>
<td>• Circuit Breaker 8A (P0898061-2X)......... 1</td>
</tr>
</tbody>
</table>

**To convert Model G0898 to 220V:**

1. DISCONNECT MACHINE FROM POWER!

2. Cut off existing 5-15 plug.

3. Open motor junction box, then loosen two wire nuts indicated in Figure 6.

4. Use wire nuts to connect wires as indicated in Figure 7. Twist wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose during operation.

5. Replace pre-installed 110V 15A circuit breaker (see Figure 8) with 220V 8A circuit breaker.

6. Close and secure motor junction box.

7. Install a 6-15 plug on power cord, according to plug manufacturer's instructions.

— If plug manufacturer's instructions are not available, NEMA standard 6-15 plug wiring is provided on Page 33.
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
This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

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 9)  
<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A.</td>
</tr>
<tr>
<td>B.</td>
</tr>
<tr>
<td>C.</td>
</tr>
<tr>
<td>D.</td>
</tr>
</tbody>
</table>

Figure 9. Inventory.

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

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.

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Additional Person</td>
<td>1</td>
</tr>
<tr>
<td>Safety Glasses (Per Person)</td>
<td>1</td>
</tr>
<tr>
<td>Bench Mounting Hardware</td>
<td>1</td>
</tr>
</tbody>
</table>

Needed for Setup

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

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Additional Person</td>
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</tr>
<tr>
<td>Safety Glasses (Per Person)</td>
<td>1</td>
</tr>
<tr>
<td>Bench Mounting Hardware</td>
<td>1</td>
</tr>
</tbody>
</table>

Bench Mounting

Number of Mounting Holes............................ 4
Diameter of Mounting Hardware Needed .. ½"

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.

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

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.
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).

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.

To assemble machine:

1. Mount machine to bench as described in Bench Mounting on Page 14.

2. Loosen both cap screws shown in Figure 13, but do not remove.

3. Loosen grinder tilt lock screw (see Figure 14). Adjust grinder to upright position, then tighten screw to secure.

4. Unscrew belt access door knob to open door (see Figure 15).

5. Pull belt tension lever backward (see Figure 16), then slide included sanding belt over wheels and platen.

Figure 13. Wheel guard and work table position cap screws.

Figure 14. Grinder tilt lock screw.

Figure 15. Belt access door knob.

Figure 16. Lever positioned without tension.
6. Center belt on wheels, then pull belt tension lever forward.

7. Position platen so it barely touches back of sanding belt (see Figure 17), then tighten contact wheel guard cap screw from Step 2.

— If you need to adjust platen angle, loosen platen adjustment cap screws (see Figure 18), adjust platen, then tighten to secure.

8. Close belt access door and secure with door knob.

9. Loosen table tilt screw and adjust table so there is less than \( \frac{1}{16} \)" between table and belt (see Figure 19), then tighten screw to secure.

---

**CAUTION**

Table and belt form an in-running nip point where one part moves past a stationary object. Body parts may be caught in this gap and be crushed or otherwise injured. Minimize this risk by allowing no more than \( \frac{1}{16} \)" between table and belt.

10. Tighten work table position screw (see Figure 20) to secure table position.

11. Proceed to Test Run.
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 belt tracks properly and will not come off the wheels during initial startup, 2) the motor powers up and runs correctly, and 3) 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 the machine:

1. Clear all setup tools away from machine.

2. Tie back loose clothing and long hair to protect yourself from getting caught in the moving belt when you start the machine.

3. Connect machine to power supply.

4. Use power switch to start and immediately stop grinder, while watching how belt tracks on platen and contact wheel. Belt “tracking” refers to belt positioning on wheels when belt rotates. When tracking properly, belt remains centered on wheels as it rotates.

5. Start grinder and allow it to run while ensuring belt tracks properly. Fine-tune tracking with handle shown in Figure 21 as necessary before proceeding to next step.

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

---

6. Turn machine OFF.

7. Remove switch disabling key, as shown in Figure 22.

---

8. Try to start machine with paddle switch. The machine should not start.

   — If the machine does not start, the switch disabling feature is working correctly.

   — If 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.
SECTION 4: OPERATIONS

Disabling Switch

The switch can be disabled by removing the key, as shown below. Disabling the switch in this manner can prevent unauthorized operation of the machine, which is important if it is not kept inside an access-restricted building or in a location where children may be present.

IMPORTANT: Disabling the switch only restricts its function. It is not a substitute for disconnecting the machine from power when adjusting or servicing.

Figure 23. Disabling switch by removing key.

WARNING

Loose hair, clothing, or jewelry could get caught in machinery and cause serious personal injury. Keep these items away from moving parts at all times to reduce this risk.

WARNING

Eye and face injuries and respiratory problems can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.

WARNING

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

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.

WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, always disable switch before leaving machine unattended. Make sure to place key in a well-hidden or secure location!

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

1. Examines workpiece to make sure it is suitable for grinding (i.e. without imbedded foreign objects, without an edge sharp enough to cut belt, etc.).

2. Puts on safety glasses and a respirator.

3. Starts grinder.

4. Holds workpiece firmly and flatly, pushes workpiece into belt, and moves it to different locations to wear sandpaper evenly and to prevent it from overheating.

5. Stops machine.

---

Grinding Tips

- Extend the life of the abrasive belt by regularly using a PRO-STIK® abrasive surface cleaner (see Accessories on Page 25).

- When grinding against contact wheel (Page 23), tilt grinder horizontal for better control.

- Hold workpiece securely with both hands. Use table/rest whenever possible to support workpiece. Do not force workpiece against belt.

- Never grind magnesium. Once shaved or powdered, it is highly flammable and magnesium fire is difficult to put out.

- Remember that grinding metal often produces sparks. DO NOT allow anyone to stand in the path of the sparks. DO NOT grind metal near flammable materials.

- Make sure belt access door is closed and latched during operation.

- Belts clog and wear. Change belts whenever you notice a difference in grinding quality/performance.

- The workpiece will get hot as you continue to grind. Cool the workpiece frequently by quenching in water or another approved solution. Allow workpiece to dry before allowing it to contact abrasive belt.

- Wear the proper protective clothing. Prepare for particles to be expelled from the grinder at high speeds. Wear safety glasses, face shield, dust mask, earplugs, leather apron, and heavy leather boots.

---

CAUTION

Moving belt can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Always support workpiece against platen or work stop when grinding. Use extreme care to provide a safe distance between belt and any body part.
Choosing Abrasive Belts

This machine uses a 2" x 48" belt. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

<table>
<thead>
<tr>
<th>Grit</th>
<th>Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>36</td>
<td>Extra Coarse</td>
</tr>
<tr>
<td>60</td>
<td>Coarse</td>
</tr>
<tr>
<td>80–100</td>
<td>Medium</td>
</tr>
<tr>
<td>120–180</td>
<td>Fine</td>
</tr>
</tbody>
</table>

To achieve a fine finish, the general rule is to grind 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 metal you use and your stage of finish will determine the best grit types to install on your grinder.

Replacing Abrasive Belt

The grinding belt on the G0898 should be changed whenever there is a noticeable change in grinding quality/performance. You may also need to change grit sizes of grinding belt for quick material removal or finer finishes.

To replace belt:

1. DISCONNECT MACHINE FROM POWER!
2. Open belt access door.
3. Refer to Adjusting Grinder Tilt on Page 22 to adjust grinder to vertical position.
4. Pull belt-tension release lever backward (see Figure 24) to release belt tension. The lever will snap into position.
5. Remove old sanding belt from wheels.
6. Place new sanding belt on wheels, then pull belt tension lever forward to tension belt.

**Note:** The included belt uses a butt joint, so it does not have an intended rotation direction. If you choose to replace it with one that uses a lap joint, you must match rotational arrows of belt with belt rotation direction of grinder (see Figure 24).

7. Rotate belt by hand to verify belt moves freely without rubbing against any parts of machine.
8. Check and adjust belt tracking (see Adjusting Belt Tracking on Page 21).
Adjusting Belt Tracking

The purpose of belt tracking is to make sure the belt stays centered on the wheels and platen during grinding operations. Although belt tracking is set at the factory, it needs to be checked any time you change or replace the belt.

To check and adjust belt tracking:

1. DISCONNECT MACHINE FROM POWER!
2. Open belt access door.
3. Standing at front of sander, rotate either wheel with one hand and watch how belt tracks.
   — If sanding belt moves left (toward motor) rotate tracking handle clockwise ¼ turn (see Figure 25).
   — If sanding belt moves right (away from motor), rotate tracking handle counterclockwise ¼ turn (see Figure 25).
4. When belt is tracking in center of platen and wheels, close belt access panel.
5. Connect machine to power source and turn it ON, verify belt is tracking correctly in center of platen and wheels, and fine-tune tracking as necessary while sander is running.

Adjusting Table

The table on the G0898 may be used as a table, a backstop, or a rest, depending on how the grinder and the table are positioned. As a table, it supports a workpiece from below; as a backstop, it acts as a barrier to stop the workpiece from following the path of the belt.

To adjust table/rest tilt:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen position cap screw shown in Figure 26, adjust position of table, then tighten to secure.
3. Loosen tilt cap screw shown in Figure 27, adjust tilt of table, then tighten to secure.

Figure 25. Belt tracking.

Figure 26. Table position lock screw.

Figure 27. Table tilt lock screw.
Adjusting Grinder Tilt

The G0898 can be positioned vertically or horizontally, or anywhere in between, depending on your operation (see Figure 28).

To adjust grinder tilt:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen both cap screws shown in Figure 29, but do not remove.

3. While supporting grinder body, loosen cap screw shown in Figure 30. If grinder is upright it will fall back to a horizontal position. Adjust and tighten cap screw at desired angle.

4. Adjust platen until it lightly contacts belt, then tighten cap screws loosened in Step 2.

5. Close belt access door and lock with knob.

Figure 28. Grinder positioned for various applications.

Figure 29. Wheel guard and work table position lock cap screws.

Figure 30. Grinder tilt lock cap screw.
Flat Grinding

Flat grinding operations can be performed directly on the belt against the platen. Always use two hands to control the workpiece and use the work stop to support it.

To perform flat grinding:

1. Connect machine to power, turn it ON, and allow it to reach full speed.

2. While supporting workpiece against work table, slowly feed it into moving belt with light, even pressure. Maintain control of workpiece, as shown in Figure 31. DO NOT force workpiece against belt.

End Grinding

End grinding operations are performed with the workpiece pressing against the contact wheel. For additional control over the workpiece, adjust grinder tilt to be horizontal, then use the work table/rest to support workpieces during operations. Always use two hands to maintain best control.

To perform end grinding:

1. Connect machine to power, turn it ON, and allow it to reach full speed.

2. Position workpiece on work rest if feasible.

3. Use both hands to maintain control of workpiece, as shown in Figures 32, and slowly feed it into contact wheel at end of moving belt with light, even pressure. DO NOT force workpiece against belt.

Figure 31. Proper flat grinding.

Figure 32. Proper end grinding.
Slack Grinding

Slack grinding is positioned similarly to flat grinding, but with the platen removed. This is most useful for contour sanding where the belt conforms to the shape of the workpiece.

To perform slack grinding:

1. DISCONNECT MACHINE FROM POWER.

2. Remove (2) cap screws and flat washers shown in Figure 33 to remove platen.

3. Loosen cap screw shown in Figure 34, adjust wheel guard until it lightly contacts belt (see Figure 35), then tighten to secure.

4. Connect machine to power, turn it ON, and allow it to reach full speed.

5. Position workpiece against work table/rest if feasible, then slowly feed it into moving belt with light, even pressure (see Figure 36). Move workpiece to different locations to wear sandpaper evenly and to prevent it from overheating.
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.

Basic Respiratory Protection
H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
Breathing metal dust could cause severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Grizzly Sanding Belts
These tough sanding belts come in a variety of grits.
T31797—Sanding Belt 2" x 48" 40-Grit, 5-Pk.
T31798—Sanding Belt 2" x 48" 60-Grit, 5-Pk.
T31799—Sanding Belt 2" x 48" 80-Grit, 5-Pk.
T31800—Sanding Belt 2" x 48" 100-Grit, 5-Pk.
T31801—Sanding Belt 2" x 48" 120-Grit, 5-Pk.

Figure 38. Grizzly sanding belts.

PRO-STIK® Abrasive Surface Cleaners
Extend the life of your abrasive discs and sleeves! Choose the Pro-Stik® with a handle for greater control or without a handle for more usable area.

<table>
<thead>
<tr>
<th>Size</th>
<th>Model</th>
</tr>
</thead>
<tbody>
<tr>
<td>1½&quot; x 1½&quot; x 8½&quot;</td>
<td>W1306</td>
</tr>
<tr>
<td>2&quot; x 2&quot; x 12&quot;</td>
<td>W1307</td>
</tr>
<tr>
<td>1½&quot; x 1½&quot; x 9&quot; with Handle</td>
<td>W1308</td>
</tr>
<tr>
<td>2&quot; x 2&quot; x 11&quot; with Handle</td>
<td>W1309</td>
</tr>
</tbody>
</table>

Figure 39. PRO-STIK® abrasive cleaners.

order online at www.grizzly.com or call 1-800-523-4777
T10456—Heavy-Duty Anti-Fatigue Mat 3' x 5'
This Heavy-Duty Anti-Fatigue Mat features beveled edges and no-slip tread for safety and comfort. Open-hole design allows liquid to drain through, so it's perfect for wet or oily conditions. Measures 3' wide x 5' long x 3/8" thick.

Figure 40. Model T10456 Anti-Fatigue Mat.

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

Figure 41. Assortment of basic eye protection.

D3304—Heavy-Duty Workbench System
Square column legs make this Heavy-Duty Workbench System one of the sturdiest around. The 28" x 28" footprint is ideal for smaller carving benches or to use to support heavy machines. Legs are 32" high. Maple Top and shelf not included.

Figure 42. Model D3304 Workbench System.

H9744—Economy Lined Gripping Glove
T20692—Deluxe Soft Goatskin Gloves
Grizzly offers a wide selection of synthetic and leather gloves for all-day comfort in a variety of working conditions.

Figure 43. Variety of work gloves.

T28503—3-In-One Multi-Purpose Oil

Figure 44. T28503 Multi-Purpose Oil.
SECTION 6: MAINTENANCE

Cleaning & Protecting

Cleaning the Model G0898 is relatively easy. Vacuum excess shavings, and wipe off any remaining dust with a dry cloth. Never use compressed air to blow away dust as airborne particles may be combustible.

Lubrication

The bearings are sealed and pre-lubricated; they require no lubrication. The only parts that require lubrication on the Model G0898 are on the tracking assembly.

To lubricate tracking assembly:

Lubrication Type ..... T28503 or Light Machine Oil
Amount .............................................. 1-2 Drops
Lubrication Frequency ...................... Monthly

To lubricate the tracking assembly, apply 2 drops of light machine oil to tracking handle (see Figure 45). Adjust tracking with machine ON to distribute grease.

Figure 45. Tracking assembly lubrication location.

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.
• Worn or damaged wires.
• Any other unsafe condition.

After Each Use
• Check for worn or damaged belt.
• Clean any shavings and dust from between platen and belt.
• Sweep surrounding dust and shavings.
• Sweep or vacuum dust and shavings from inside belt compartment and around motor.

Weekly/Monthly Maintenance
• Clean/vacuum dust off motor.
• Check drive belt condition and tension (Page 30).

Cleaning & Protecting

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or 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.

**SECTION 7: SERVICE**

**Troubleshooting**

**Motor & Electrical**

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
</table>
| Machine does not start, or power supply fuse/breaker trips immediately after startup. | 1. Switch disabling key removed.  
3. Incorrect power supply voltage or circuit size.  
4. Power supply circuit breaker tripped or fuse blown.  
5. Motor wires connected incorrectly.  
6. Start capacitor at fault.  
7. Wiring broken, disconnected or corroded.  
8. ON/OFF switch or circuit breaker at fault.  
9. Motor centrifugal switch adjustment/contact points at fault.  
10. Motor at fault. | 1. Install switch disabling key.  
2. Reset machine circuit breaker.  
3. Ensure correct power supply voltage and circuit size (Page 10).  
4. Ensure circuit is sized correctly and free of shorts. Reset breaker or replace fuse.  
5. Correct motor wiring connections (Page 32).  
6. Test/replace if at fault.  
7. Fix broken, disconnected, or corroded connections (Page 32).  
8. Replace switch/circuit breaker.  
9. Adjust centrifugal switch/clean contact points. Replace either if at fault.  
10. Test/repair/replace. |
| Machine stalls or is underpowered. | 1. Excessive feed pressure applied.  
2. Belt slipping/pulleys misaligned.  
6. Run capacitor at fault.  
7. Motor bearings at fault.  
8. Centrifugal switch/contact points at fault.  
2. Tension/replace belt; align pulleys (Page 30).  
3. Clean/replace sandpaper; reduce feet rate/sanding depth.  
5. Clean motor, let cool, and reduce workload. Reset breaker.  
6. Test/repair/replace.  
7. Test/repair/replace.  
8. Adjust centrifugal switch/clean contact points.  
| Machine has vibration or noisy operation. | 1. Grinding belt not tracking correctly.  
2. Motor or component loose.  
3. V-belt worn, loose, or pulleys misaligned/loose.  
4. Belt slapping cover.  
5. Incorrectly mounted to workbench.  
6. Motor fan rubbing on fan cover.  
7. Motor bearings at fault. | 1. Ensure belt is tracking correctly (Page 21).  
2. Replace damaged or missing bolts/nuts or tighten.  
3. Inspect/replace belt with a new one (Page 30). Realign/secure pulleys if necessary.  
4. Replace/realign belt.  
5. Tighten mounting hardware (Page 14); shim machine to ensure no wobbles.  
6. Fix/replace fan cover; replace loose/damaged fan.  
7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. |
<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>2. Incorrect grinding belt tension.</td>
<td>2. Make sure tension lever is in tensioning position (Page 20).</td>
</tr>
<tr>
<td>Grains easily rub off belt.</td>
<td>1. Grinding belt has been stored in damp environment.</td>
<td>1. Replace damaged grinding belt (Page 20). Store grinding belt in a cool, dry area.</td>
</tr>
<tr>
<td></td>
<td>2. Grinding belt has been smashed or folded.</td>
<td>2. Replace damaged grinding belt (Page 20). Do not bend or fold grinding belt.</td>
</tr>
<tr>
<td></td>
<td>3. Grinding belt is too old.</td>
<td>3. Use new grinding belt.</td>
</tr>
<tr>
<td>Belt tracks to one side under load.</td>
<td>1. Belt tracking not set correctly.</td>
<td>1. Ensure belt tracking is set correctly (Page 21).</td>
</tr>
<tr>
<td>Deep sanding grooves or scratches in workpiece.</td>
<td>1. Excessive feed pressure while grinding.</td>
<td>1. Reduce workpiece feed pressure.</td>
</tr>
<tr>
<td></td>
<td>2. Workpiece held still for too long against grinding belt.</td>
<td>2. Keep workpiece moving while grinding.</td>
</tr>
<tr>
<td></td>
<td>3. Grinding belt too coarse.</td>
<td>3. Use finer grit grinding belt (Page 20).</td>
</tr>
<tr>
<td></td>
<td>4. Platen worn.</td>
<td>4. Replace platen.</td>
</tr>
<tr>
<td></td>
<td>2. Grinding belt damaged.</td>
<td>2. Replace grinding belt (Page 20).</td>
</tr>
<tr>
<td></td>
<td>3. Platen noticeably worn.</td>
<td>3. Replace platen.</td>
</tr>
<tr>
<td>Belt clogs quickly.</td>
<td>1. Excessive feed pressure while grinding.</td>
<td>1. Clean grinding belt (Page 25), and then reduce workpiece pressure.</td>
</tr>
<tr>
<td></td>
<td>2. Grinding belt worn or damaged.</td>
<td>2. Replace grinding belt (Page 20).</td>
</tr>
<tr>
<td></td>
<td>3. Workpiece material is prone to belt-clogging, such as soft aluminum.</td>
<td>3. Reduce feed pressure. Use coarser-grit belt (Page 20).</td>
</tr>
<tr>
<td>Sanded surface not square.</td>
<td>1. Table not perpendicular to platen.</td>
<td>1. Adjust table tilt to be perpendicular with platen.</td>
</tr>
<tr>
<td>Workpiece frequently gets pulled out of hand when sanding.</td>
<td>1. Workpiece not supported sufficiently against table/rest.</td>
<td>1. Use work table/rest, or push block to support workpiece.</td>
</tr>
<tr>
<td></td>
<td>2. Leading edge or sharp edges grabbing into grinding belt.</td>
<td>2. Change angle or orientation of workpiece so workpiece is not digging into oncoming direction of grinding belt.</td>
</tr>
</tbody>
</table>
Tensioning & Replacing Drive Belt

The drive belt stretches slightly as the grinder is used. Most of the belt stretching will happen during the first 16 hours of use, but it may continue through continued use. If you notice the belt is slipping, it will need to be tensioned. If the belt is cracked, frayed, or shows other signs of excessive wear, it will need to be replaced.

Tools Needed

- Wrench 13mm ................................................... 1
- Straightedge 12" ............................................... 1

To replace and tension belt:

1. DISCONNECT MACHINE FROM POWER.

2. Remove belt safety cover by removing (2) hex nuts, lock washers, and flat washers shown in Figure 46.

3. Press belt in center to check belt tension. The belt is correctly tensioned when there is approximately ¼" deflection when it is pushed with moderate pressure, as shown in Figure 47.

4. Replace belt safety cover and secure with hardware from Step 2.

---

Figure 46. Safety cover hardware.

---

Figure 47. Checking V-belt tension.

---

Figure 48. Motor mounting bolts.

---
Aligning Pulleys

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

Each pulley can be adjusted by loosening the set screws that secure them to their respective shafts.

Tools Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wrench 13mm</td>
<td>1</td>
</tr>
<tr>
<td>Straightedge 12&quot;</td>
<td>1</td>
</tr>
</tbody>
</table>

To align pulleys:

1. DISCONNECT MACHINE FROM POWER.

2. Remove belt safety cover by removing (2) hex nuts, lock washers, and flat washers shown in Figure 49.

3. Place a straightedge against both pulleys (see Figure 50) and check that they are aligned. There should be no space anywhere between straightedge or pulleys.

![Figure 50. Checking pulley alignment.](image)

— If pulleys are aligned, proceed to Step 6.

— If pulleys are not aligned, proceed to Step 4.

4. Loosen set screw on motor pulley shown in Figure 51.

![Figure 51. Motor pulley set screw.](image)

5. Use straightedge to adjust pulley on shaft until it aligns with contact wheel pulley, then tighten set screw from Step 4.

6. Replace belt safety cover and secure with hardware from Step 2.
SECTION 8: WIRING

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

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

![WARNING]

Wiring Safety Instructions

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

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

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

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

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

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

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

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

<table>
<thead>
<tr>
<th>NOTICE</th>
<th>COLOR KEY</th>
</tr>
</thead>
<tbody>
<tr>
<td>The photos and diagrams included in this section are best viewed in color. You can view these pages in color at <a href="http://www.grizzly.com">www.grizzly.com</a>.</td>
<td></td>
</tr>
<tr>
<td>BLACK</td>
<td>BLUE</td>
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<td>WHITE</td>
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Model G0898 (Mfd. Since 12/19)
Motor Prewired for 110V

GND

Motor Rewired for 220V

GND

Start Capacitor
150 MFD 125VAC

Running Capacitor
40uF 250VAC

110V/220V MOTOR

Circuit Breaker
KOUYOH 15A 120VAC

ON/OFF Switch

Motor Rewired for 220V

Circuit Breaker
KOUYOH 8A 120VAC

ON/OFF Switch

WARNING!
SHOCK HAZARD!
Disconnect power before working on wiring.

110 VAC 5-15 Plug

Ground

220 VAC 6-15 Plug (as recommended)

Ground

Hot

Neutral

Hot

Figure 52. Run capacitor.

Figure 53. Start capacitor.

Figure 54. Motor junction box.

Figure 55. Wiring diagram.
SECTION 9: PARTS

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

Main
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<th>REF</th>
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### Labels & Cosmetics

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**WARNING**

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.
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/secureforms/warranty-card, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.