MODEL G0967
20" VARIABLE-SPEED DISC SANDER
OWNER'S MANUAL
(For models manufactured since 06/23)

#CS22710 PRINTED IN CHINA V1.05.23

******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.

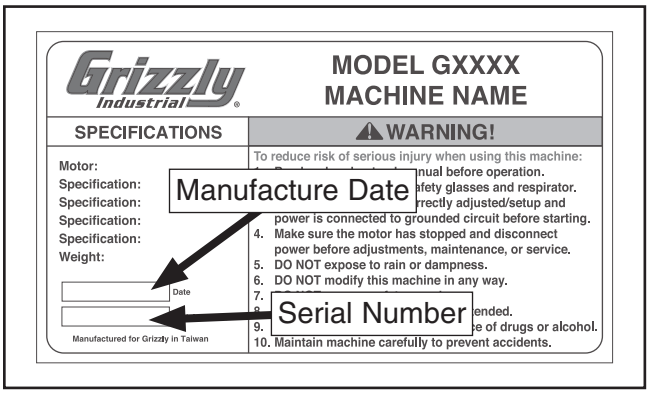
Manual Accuracy

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**.

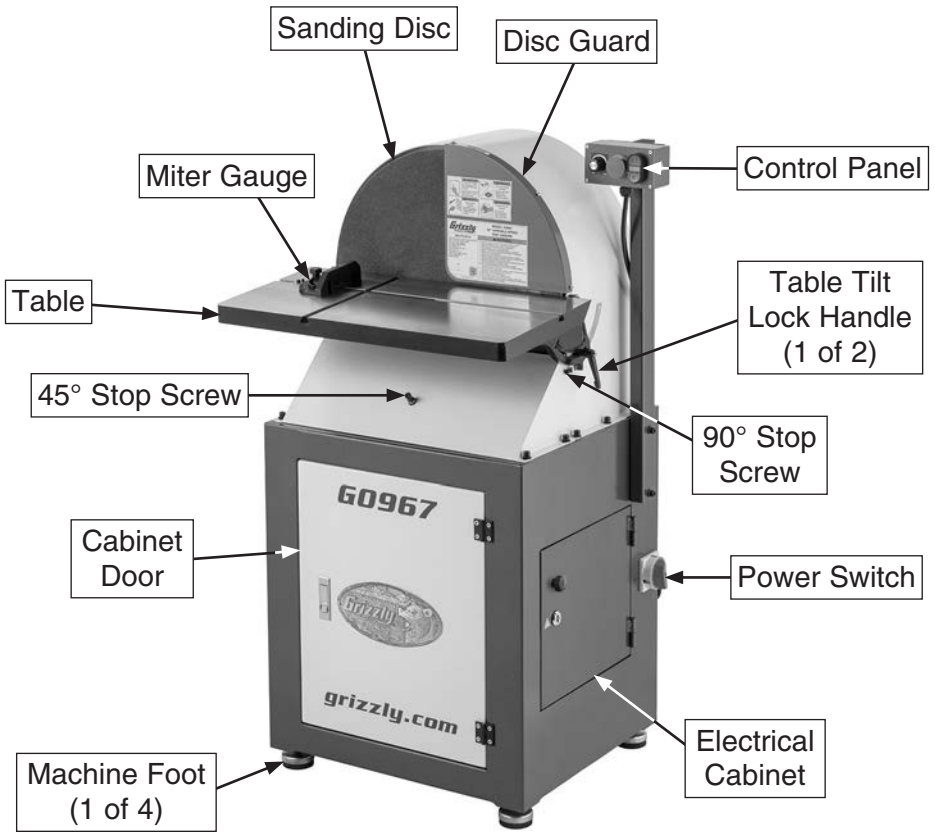
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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.



Identification

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

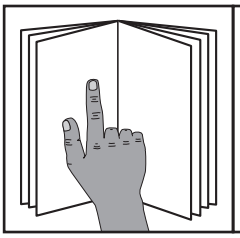


⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating the Sander

a) Wear eye protection.
b) Support workpiece with miter gauge, backstop, or work table.
c) Maintain 1/16 in. maximum clearance between table and sanding disc.
d) Avoid kickback by sanding in accordance with directional arrows.

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

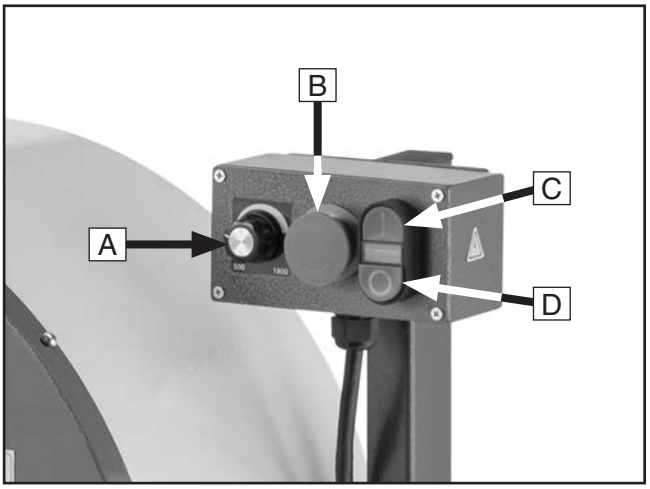


Figure 1. Control panel controls.

A. Variable-Speed Dial: Rotate dial clockwise to increase sanding speed; rotate counterclockwise to decrease sanding speed. Sanding speed ranges from 500–1800 RPM.

B. Stop Button: Stops machine and prevents it from starting. To reset, twist button clockwise until it pops out.

C. ON Button: Turns motor ***ON***.

D. OFF Button: Turns motor ***OFF***.

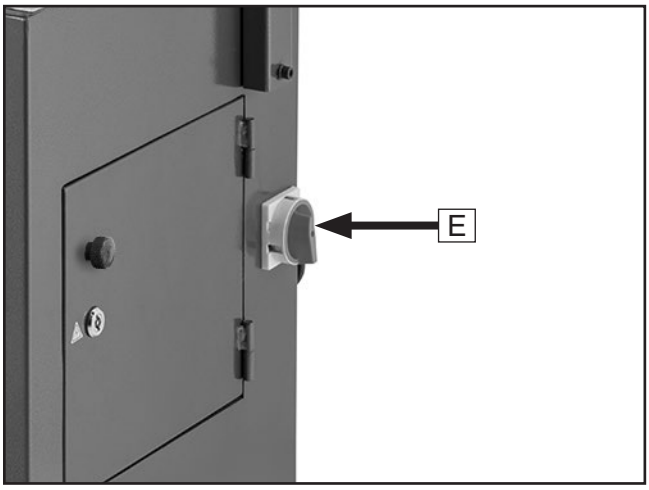


Figure 2. Power switch.

E. Power Switch: Turns incoming power to machine ***ON*** (I) and ***OFF*** (O).

Table

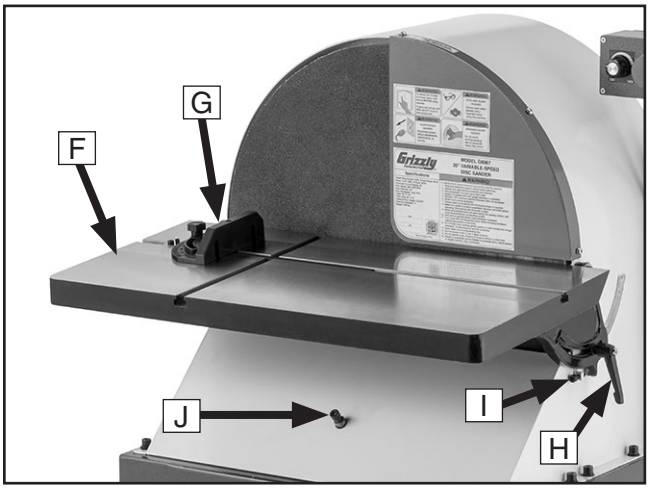


Figure 3. Table controls and components.

F. Table: Supports workpiece as it is pressed against sanding disc and tilts between 0°–45°. Has X- and Y-axis slots for miter gauge.

G. Miter Gauge: Adjusts between 60° left and 60° right to support workpiece against sanding disc and table.

H. Table Tilt Lock Handle (1 of 2): Loosens to adjust table tilt; tightens to secure.

I. 90° Stop Screw: Stops table tilt at 90°.

J. 45° Stop Screw: Stops table tilt at 45°.

MACHINE DATA SHEET

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

MODEL G0967 20" VARIABLE-SPEED DISC SANDER

Product Dimensions:

Weight..... 309 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 27-1/2 x 27 x 48-1/2 in.
Footprint (Length x Width)..... 23 x 20-1/2 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 364 lbs.
Length x Width x Height..... 30 x 29 x 53 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
Full-Load Current Rating..... 8A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 98 in.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 6-15
Switch Type..... Control Panel w/Magnetic Switch Protection
Inverter (VFD) Type..... EURA E2000-0015S2
Inverter (VFD) Size..... 2 HP

Motors:

Main

Horsepower..... 2 HP
Phase..... 3-Phase
Amps..... 6.5A
Speed..... 1700 RPM
Type..... Induction
Power Transfer ..... Direct
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Disc Sander Info

Disc Diameter..... 20 in.
Disc Speed..... 500 - 1800 RPM
Disc Sandpaper Backing Type..... PSA
Included Sanding Disc Grit Size 60-Grit
Table Length..... 12 in.
Table Width..... 25 in.
Table Thickness..... 1-3/8 in.
Table Tilt..... 0 - 45 deg.
Table-to-Floor Height..... 37-5/16 in.

Construction Materials

Base	Steel
Stand	Steel
Table	Precision-Ground Cast Iron
Frame	Steel
Disc	Steel
Miter Gauge	Plastic
Paint Type/Finish	Powder Coated

Other Related Info

Miter Gauge Slot Width	7/16 in.
Miter Gauge Slot Height	1/2 in.
Number of Dust Ports	1
Dust Port Size	4 in.
Compatible Mobile Base	T28000

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Features:

0 - 45 Degree Table Tilt
Adjustable Miter Gauge
20" 60-Grit Sanding Disc Included
Heavy-Duty Cabinet Stand
Precision-Ground Cast Iron Table w/X- and Y-Axis Miter Slots

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.

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Disc Sanders

⚠WARNING

Serious injury or death can occur from fingers or hands contacting sandpaper, or from fingers, clothes, or hair getting entangled in sanding disc. Workpieces thrown by sander can strike nearby operators with great force. Long-term respiratory damage can occur from using sander without a respirator and adequate dust collection system. To minimize risk of getting hurt or killed, anyone operating machine MUST completely heed hazards and warnings below.

DISC DIRECTION. Only sand on downward-moving left side of sanding disc. Sanding on upward-moving right side of sanding disc forces operator to rely only on hands (rather than table) for support, which increases risk of workpiece "kick-out" and impact/abrasion injuries.

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

FEEDING WORKPIECE. Forcefully jamming workpiece into sanding surface could cause workpiece to be aggressively grabbed and pull your hands into sanding surface. Firmly grasp workpiece in both hands and ease it into sandpaper using light pressure.

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

AVOIDING ENTANGLEMENT. Becoming entangled in moving parts of this machine can cause pinching and crushing injuries. To avoid these hazards, DO NOT wear loose clothing, gloves, or jewelry, and tie back long hair. Keep all guards in place and secure.

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

WORKPIECE SUPPORT. Workpiece kickback can occur with violent force if workpiece is not properly supported during operation. Always sand with workpiece firmly against table or another support device.

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

SANDPAPER CONDITION. Worn or damaged sandpaper not only produces poor sanding results, but could fly apart, aggressively grab workpiece, and throw debris at the operator. Always inspect sandpaper before operation and replace if worn or damaged.

WORKPIECE INTEGRITY. Only sand solid workpieces that can withstand power sanding forces. Make sure shape of workpiece is properly supported on table; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.

SANDING DUST. Sanding creates large amounts of dust and flying chips that can lead to eye injury or respiratory illness. Reduce risk of these hazards by wearing approved eye and respiratory protection when using sander.

DUST COLLECTION. Never operate without adequate dust collection system in place and running. Proper dust collection reduces dust in work area, which decreases risk of long-term respiratory damage, but it is not a substitute for using a respirator.

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 220V ..... 8 Amps

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

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

Circuit Information

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

⚠CAUTION

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

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

Circuit Requirements

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

Nominal Voltage 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.

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!

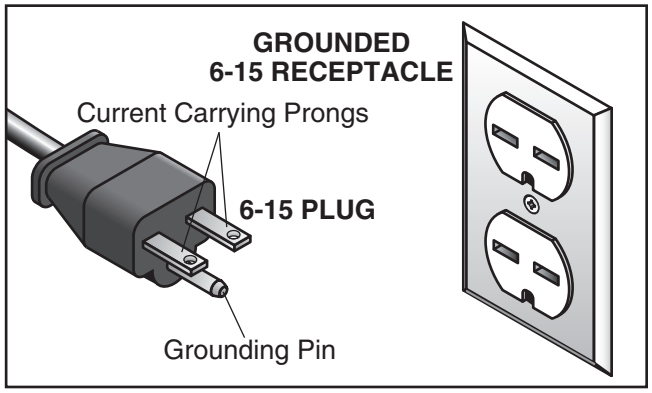
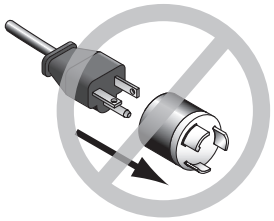


Figure 4. Typical 6-15 plug and receptacle.

⚠CAUTION



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

⚠WARNING

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

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

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

Extension Cords

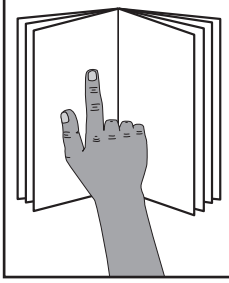
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

Minimum Gauge Size .....18 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

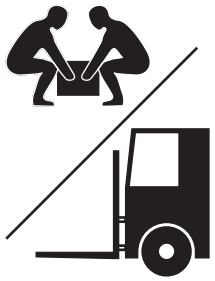


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

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.*

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 Pr.
• Cleaner/Degreaser	As Needed
• Disposable Rags	As Needed
• Disposable Gloves	As Needed
• Lifting Assistants	2
• Lifting Equipment (Rated for at least 450 lbs.)	1
• Lifting Straps (Rated for at least 450 lbs.)	2
• Level 24"	1
• Open-End Wrench 5/8"	1
• Wrench or Socket 17mm	1
• Hex Wrench 6mm	1
• Phillips Head Screwdriver #2	1
• Feeler Gauge 1/16"	1
• Dust Collection System	1
• Dust Hose 4"	1
• Hose Clamps 4"	2

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.

Main Inventory (Figure 5) **Qty**
A. Sander 1

Figure 5. Main inventory.

Loose Items (Figure 6) **Qty**
B. Miter Gauge 1
C. Sanding Disc 20" 60-Grit 1
D. Electrical Cabinet Key 1
E. Machine Feet 4
F. Hex Nuts M10-1.5 8

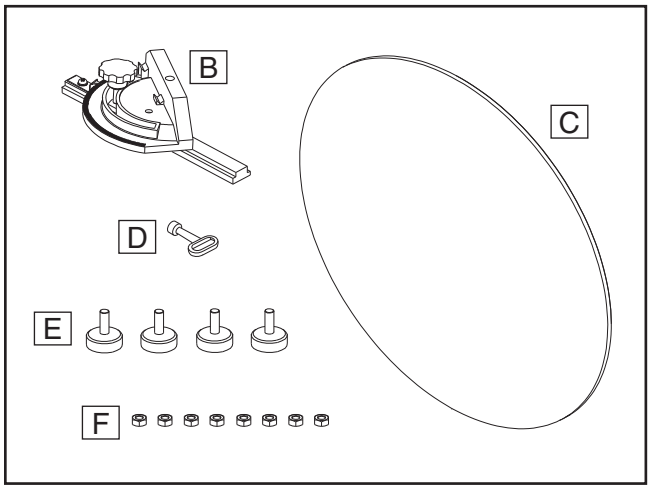


Figure 6. Loose item inventory.

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.

Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

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

Before cleaning, gather the following:
- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

⚠WARNING

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

⚠CAUTION

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

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Order online at www.grizzly.com OR Call 1-800-523-4777

Figure 7. T23692 Orange Power Degreaser.

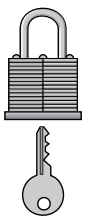
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

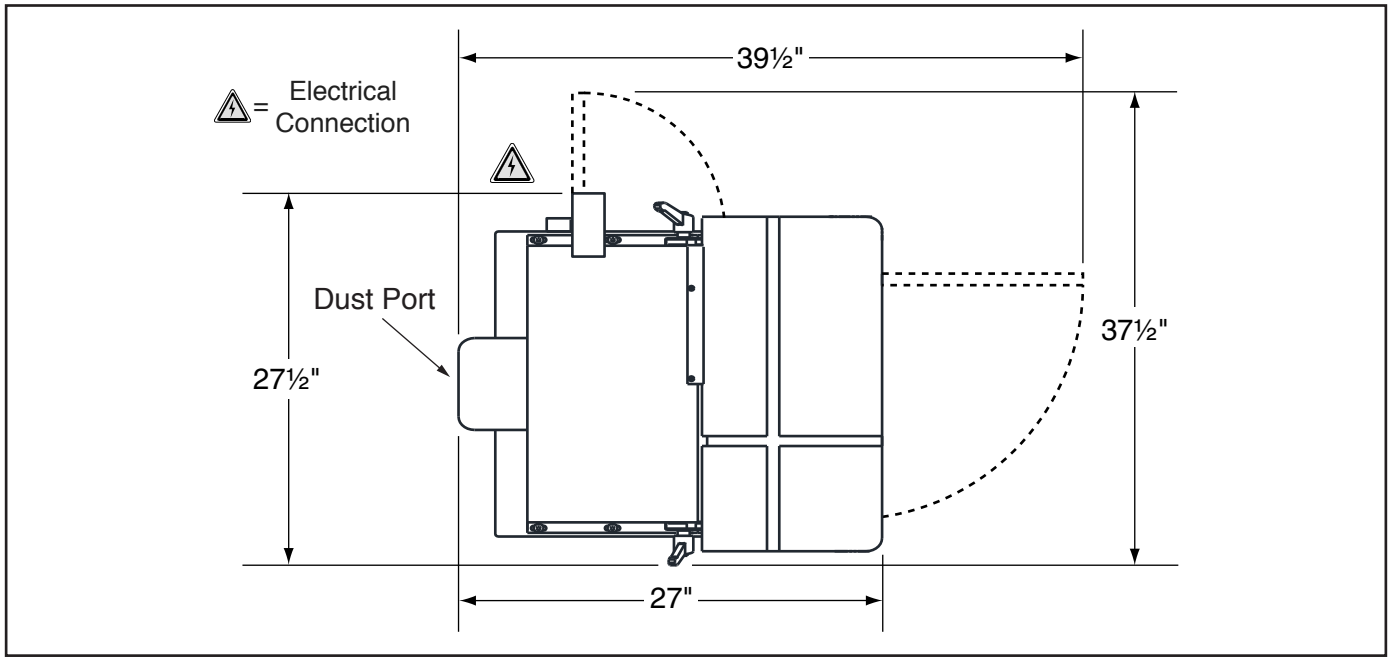


Figure 8. Minimum working clearances.

Assembly

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

⚠WARNING

HEAVY LIFT!

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

To assemble machine:

1. Remove crate top and sides, then remove any small components from machine.

2. Move machine to prepared location while it is still attached to shipping pallet.

3. Open cabinet door (see **Figure 9**), remove any small components from inside cabinet, then remove fasteners securing machine to pallet.

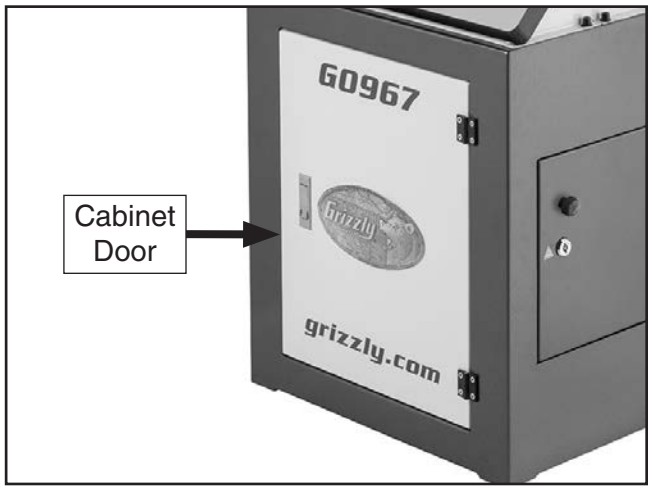


Figure 9. Location of cabinet door.

4. Thread (1) M10-1.5 hex nut about halfway onto each machine foot.

5. Have two other people help tilt one side of machine up, insert (2) machine feet into exposed holes in corners of base, then lower machine onto feet (see **Figure 10**).

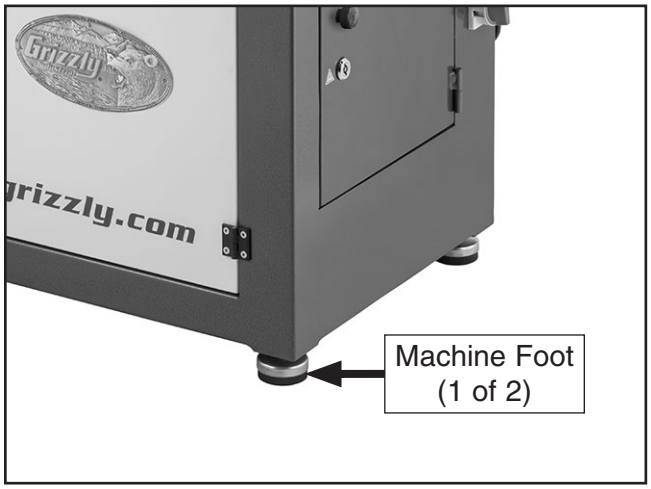


Figure 10. Machine feet inserted in corners of base.

6. Repeat **Step 5** for other side of machine.

7. Install (1) M10-1.5 hex nut on each foot inside cabinet to secure. Only hand tighten for now.

8. Place (2) lifting straps under sander (see **Figure 11**), and attach straps securely to hoist or other power lifting equipment.

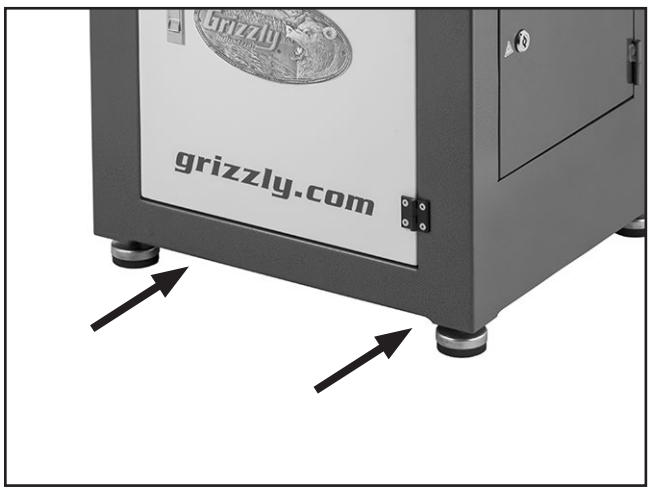


Figure 11. Lifting locations.

Tip: *Route additional ratchet strap around machine base to keep lifting straps from moving to keep machine weight evenly distributed.*

9. With another person to help steady machine, lift machine just enough to clear pallet, then remove pallet and lower machine to ground.

10. Loosen hex nuts from **Step 7**, adjust lower hex nuts on machine feet until machine is level, then tighten upper hex nuts to secure.

11. Remove (3) Phillips head screws and flat washers shown in **Figure 12** to remove disc guard.

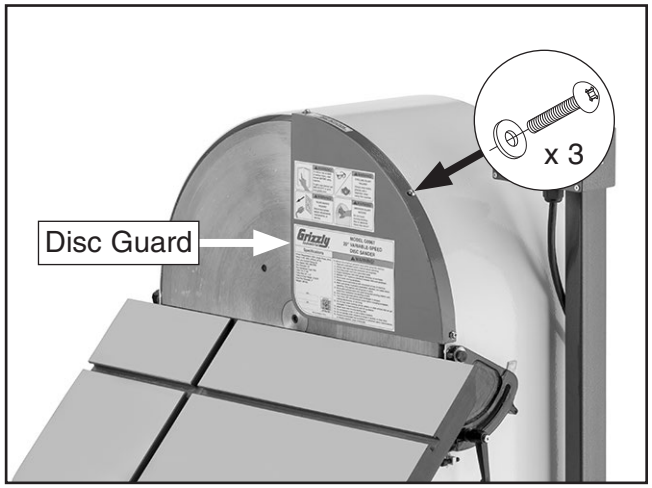


Figure 12. Location of disc guard and fasteners.

12. Loosen (2) table tilt lock handles, adjust table tilt to 0°, then tighten lock handles (see **Figure 13**).

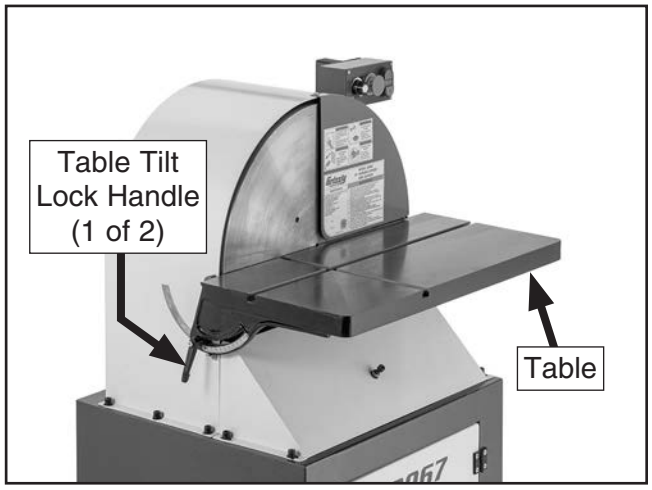


Figure 13. Table tilt adjusted to 0°.

13. Loosen (6) cap screws shown in **Figure 14**, then move table away from steel disc.

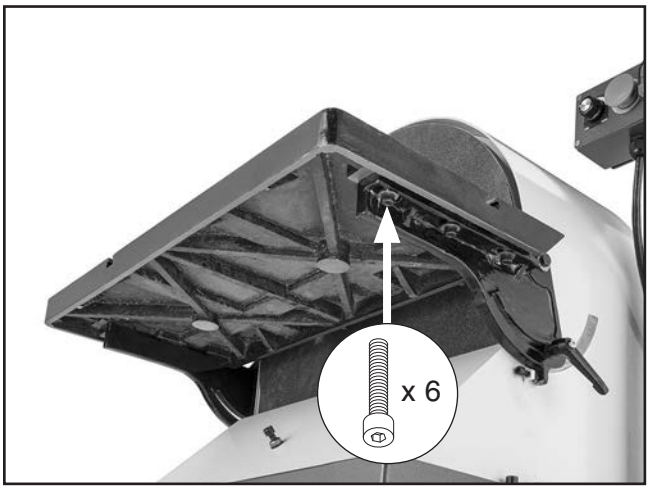


Figure 14. Location of table cap screws.

14. Clean steel disc surface with cleaner/degreaser and let dry.

15. Peel back protective layer on **one-half** of sanding disc and fold it against remaining half.

16. Slip half with protective layer between disc and table edge (see **Figure 15**).

Figure 15. Example of installing sanding disc.

17. Position exposed adhesive on upper half of steel disc that extends above table. Once it is positioned evenly across disc, press adhesive onto surface.

18. Rotate disc so lower half is above table. Peel off other half of protective paper, and press remaining sanding disc against steel disc so adhesion is complete.

19. Adjust table so there is a 1/16" gap between disc and edge of table along its full width (see **Figure 16**).

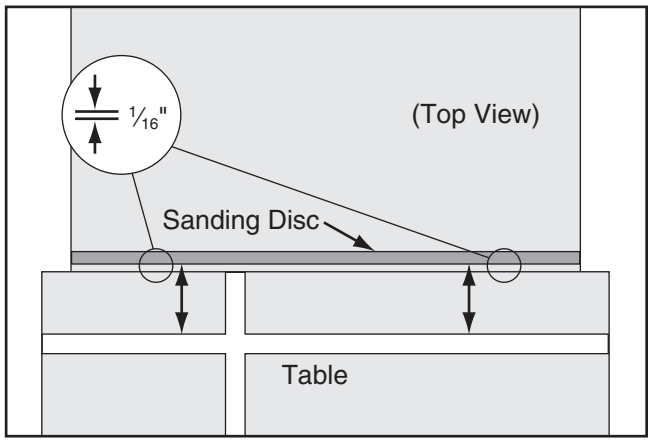


Figure 16. Example of correctly adjusted table.

20. Tighten table cap screws.

21. Spin disc by hand to check if sanding disc touches table.

— If sanding disc touches table at any point, loosen table cap screws, then repeat **Steps 19–21** until it does not.

IMPORTANT: DO NOT proceed to **Test Run** until you have verified that sanding disc does not touch table at any point in its rotation.

22. Install disc guard, ensuring guard does not contact sanding disc.

Dust Collection

⚠CAUTION

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

Minimum CFM at Dust Port: 400 CFM

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

To connect dust collection system to machine:

1. Fit 4" dust hose over dust port, as shown in **Figure 17**, and secure in place with hose clamp.

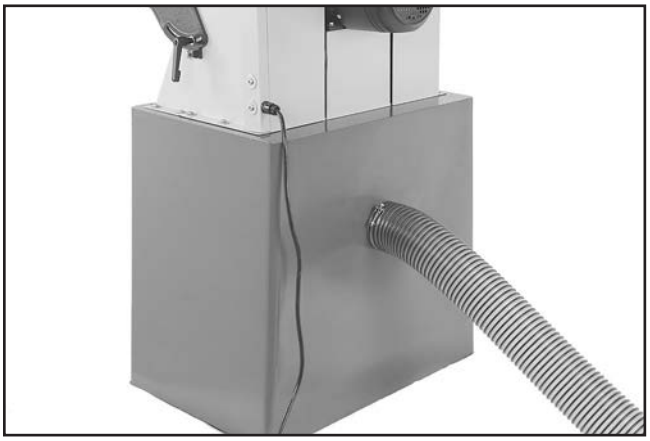


Figure 17. Example of dust hose attached to dust port.

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, 2) the sanding disc rotates in the correct direction, and 3) the Stop button disables the machine correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Press Stop button in (see **Figure 18**).
3. Turn variable-speed dial all the way counterclockwise (see **Figure 18**).

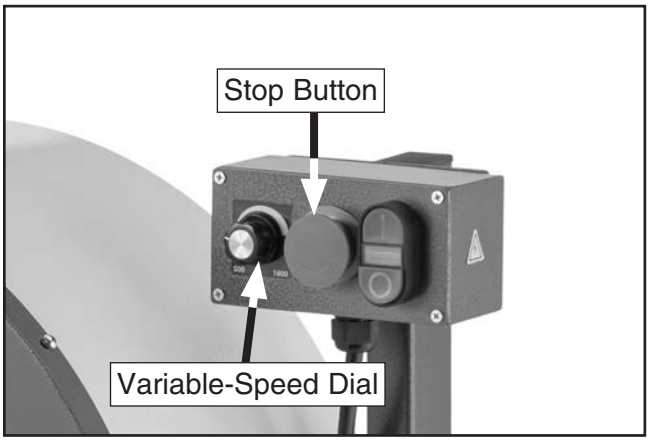


Figure 18. Location of Stop button and variable-speed dial.

4. Turn power switch to OFF (0) position (see **Figure 19**).

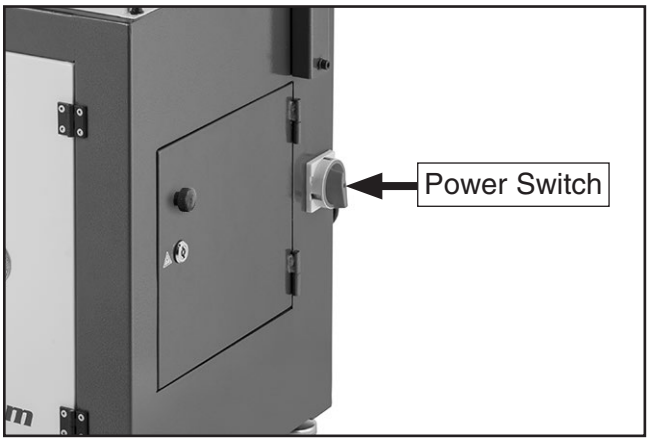


Figure 19. Location of power switch.

5. Connect machine to power by inserting power cord plug into a matching receptacle.
6. Turn power switch to ON position (I).
7. Twist Stop button clockwise until it springs out (see **Figure 20**). This resets switch so machine can start.

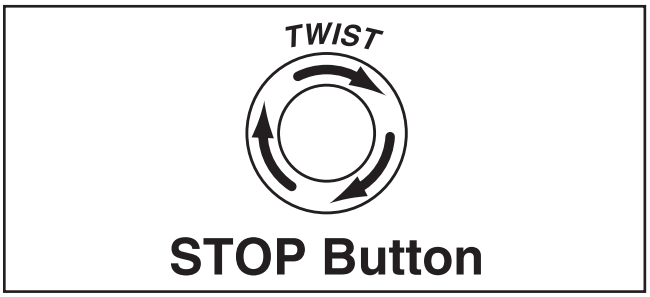


Figure 20. Resetting switch.

8. Press ON button (I) to turn machine ***ON*** (see **Figure 21**). Power light will illuminate. Verify motor starts up and runs smoothly without any unusual problems or noises.

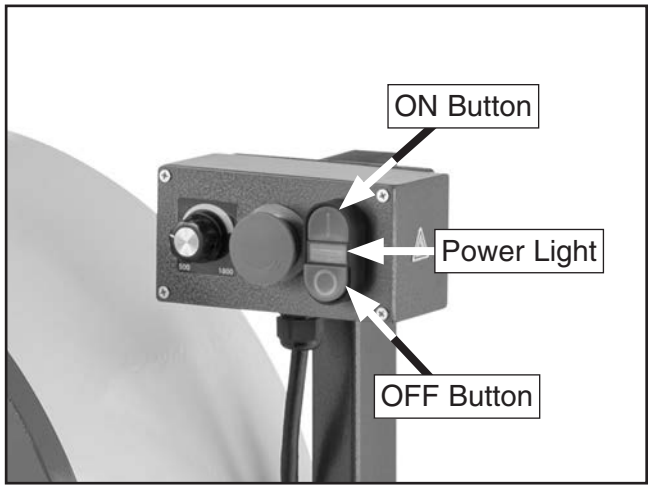


Figure 21. Location of ON/OFF buttons and power light.

9. Observe sanding disc rotation direction. Disc should rotate in same direction as disc rotation arrow (see **Figure 22**).

   — If disc rotates in same direction as disc rotation arrow, proceed to **Step 14**.

   — If disc *does not* rotate in same direction as disc rotation arrow, phase polarity of motor needs to be reversed. Proceed to **Step 10**.

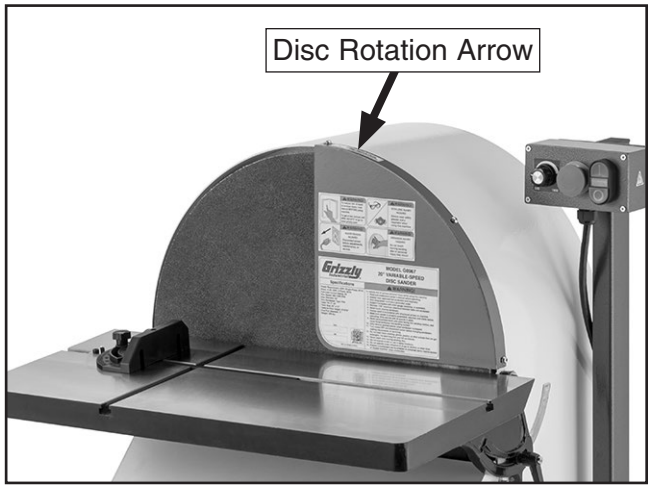


Figure 22. Location of disc rotation arrow.

10. Press OFF button (see **Figure 21**) and DISCONNECT MACHINE FROM POWER!

11. Use electrical cabinet key to open electrical cabinet door.

12. Swap any (2) motor wires connected to bottom of inverter labeled **U1**, **V1**, and **W1** (see **Figure 23**).

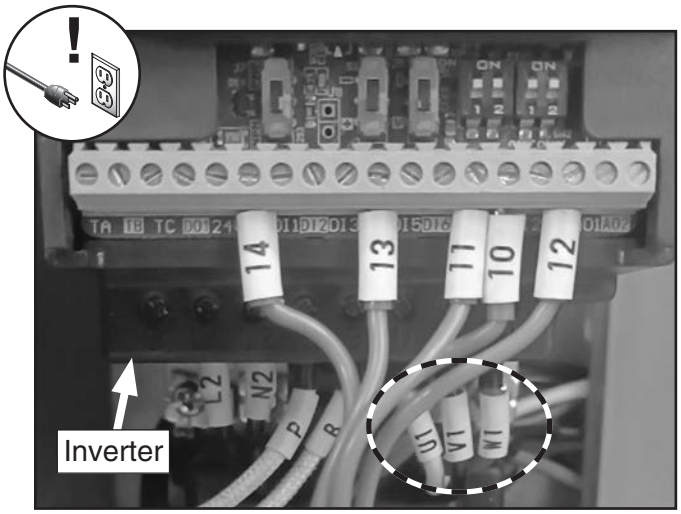


Figure 23. Location of U1, V1, and W1 wires (inverter cover removed for clarity).

13. Close electrical cabinet door and reconnect machine to power. Repeat **Steps 8**–**9**.

14. Verify speed controls by slowly turning variable-speed dial clockwise. Rotate dial back and forth to test variable-speed function.

15. Press Stop button to turn machine ***OFF***.

16. WITHOUT resetting Stop button, try to start machine by pressing ON button. Machine should not start.

   — If machine *does not* start, safety feature of Stop button is working correctly. Congratulations! Test Run is complete.

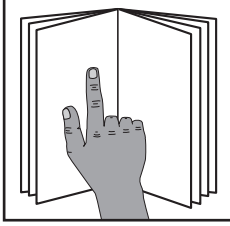
   — If machine *does* start, immediately turn it ***OFF*** and disconnect power. Safety feature of Stop button is NOT working properly and must be replaced before further using machine.

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.

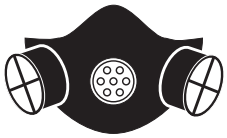


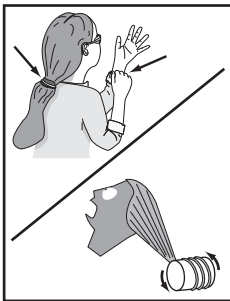
⚠WARNING

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

⚠WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.





⚠WARNING

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

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

1. Examines workpiece to make sure it is suitable for sanding.
2. Inspects and installs sanding disc with appropriate grit for operation.
3. Adjusts table tilt.
4. Inserts miter gauge in either X- or Y-axis miter slot, then adjusts miter gauge to desired angle and position.
5. Ties back loose hair and clothing, removes loose jewelry, and puts on safety glasses and a respirator.
6. Starts dust collector, then turns sander ***ON***.
7. Adjusts disc speed as desired.
8. Holds workpiece firmly and flatly against both table and miter gauge (if used), pushes workpiece into or along down-spin side of sanding disc.
9. Stops sander, then turns ***OFF*** dust collector.

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.

Sanding Tips

- Extend the life of the sandpaper by regularly using PRO-STIK® abrasive surface cleaners (see **Accessories** on **Page 27**).
- 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.
- Hold workpiece securely with both hands and do not wear gloves. Use work table and miter gauge whenever possible to support workpiece. Do not force workpiece against disc.
- Sanding discs clog and wear. Change sandpaper whenever you notice a difference in sanding quality/performance.
- To increase the life of the sanding disc and ensure even wear, move the workpiece back and forth across the sanding surface if the operation allows it.
- As a rule-of-thumb, sand with progressively higher grit numbers. A higher grit will achieve a finer finish.
- Make sure guards are installed and secured during operation.
- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease sandpaper life and cost you more money over time.

⚠CAUTION

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

Choosing Sandpaper

The Model G0967 uses a 20" sanding disc. 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 marks and initial finish sanding.
120–180	Fine	Finish sanding.

We recommend using aluminum-oxide sanding discs for best results. The grit you choose will depend on the condition and species of wood, and the level of finish you wish to achieve.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers. Avoid skipping grits; the larger the grit increase at one time, the harder it will be to remove the scratches from the previous grit.

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

Note: *Sandpaper finer than 180-grit will easily load up or burn workpieces.*

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 sand metal, glass, stone, tile, plastics, drywall, cement backer board, laminate products, etc. 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 discs will be greatly reduced (or immediately damaged) from sanding improper materials or from exposure to fine dust created when doing so.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear sanding disc. Always visually inspect your workpiece for these items. If they cannot be removed, DO NOT sand the workpiece.

- ***Wet or "Green" Stock:*** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding disc, increases the risk of kickback, and yields poor results.

- ***Excessive Glue or Finish:*** Sanding workpieces with excess glue or finish will load up the abrasive, reducing its usefulness and lifespan.

Adjusting Table Tilt

The angle of the table on the Model G0967 can be adjusted between 0°–45° to sand angled workpieces.

To adjust table tilt:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen (2) table tilt lock handles (see **Figure 24**), adjust table tilt, then tighten handles to secure.

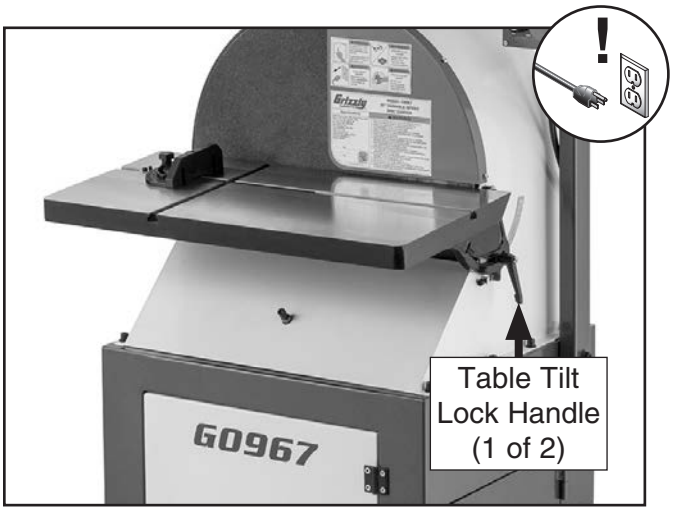


Figure 24. Location of table lock handles.

3. Refer to **Adjusting Table Gap and Parallelism** on **Page 32** to adjust table within 1/16" of sanding disc.

Adjusting Miter Gauge

The miter gauge angle can be adjusted 60° to the right or the left, keeping angled workpieces accurate. When the miter lock knob is tight, both the angle of the miter gauge and its position on the table are secure and will act as a stop to brace your workpiece against.

To adjust miter gauge:

1. Loosen miter lock knob (see **Figure 25**), adjust angle and position, then tighten knob to secure.

Figure 25. Location of miter lock knob.

Changing Sanding Disc

The G0967 accepts 20" diameter PSA (pressure-sensitive adhesive) sanding discs. Use the following steps to change the sanding disc when a sanding disc wears out or your operation requires a different grit size.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Hex Wrench 6mm	1
Cleaner/Degreaser	As Needed
Disposable Rags	As Needed
Replacement Sanding Disc	1
Feeler Gauge 1/16"	1

To change sanding disc:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (3) Phillips head screws and flat washers shown in **Figure 26** to remove disc guard.

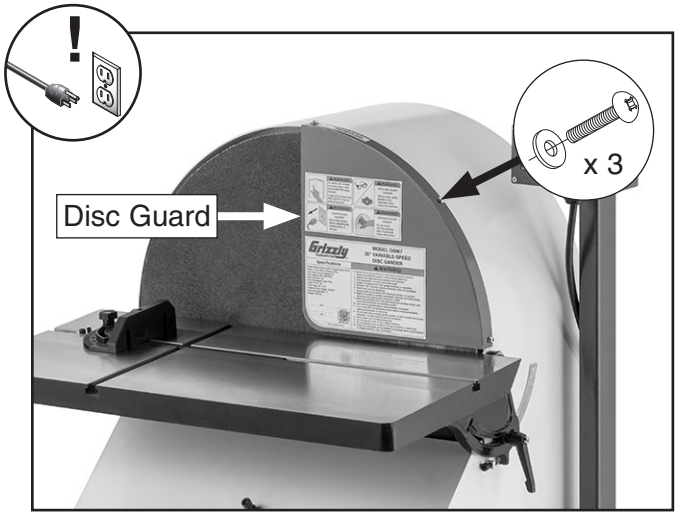


Figure 26. Location of disc guard and fasteners.

3. Loosen (6) cap screws shown in **Figure 27**, then move table away from sanding disc.

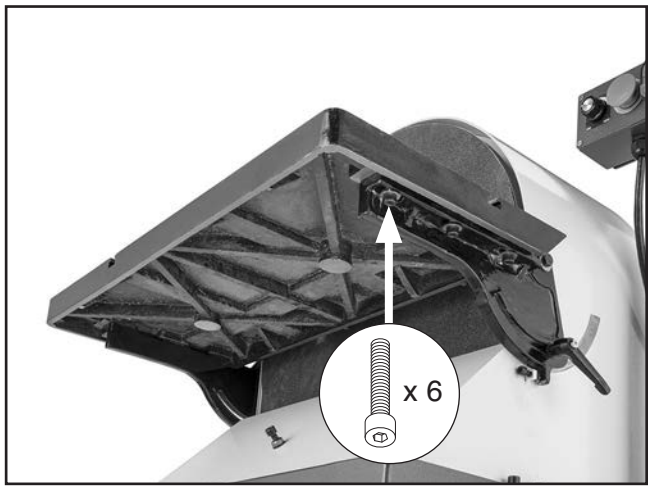


Figure 27. Location of table cap screws.

4. Peel old sanding disc off of steel disc.

5. Clean steel disc surface with cleaner/degreaser and let dry.

6. Peel back protective layer on **one-half** of sanding disc and fold it against remaining half.

7. Slip half with protective layer between disc and table edge (see **Figure 28**).

Figure 28. Example of installing sanding disc.

8. Position exposed adhesive on upper half of steel disc that extends above table. Once it is positioned evenly across disc, press adhesive onto surface.

9. Rotate disc so lower half is above table. Peel off other half of protective paper, and press remaining sanding disc against steel disc so adhesion is complete.

10. Adjust table so there is a 1/16" gap between disc and edge of table along its full width (see **Figure 29**).

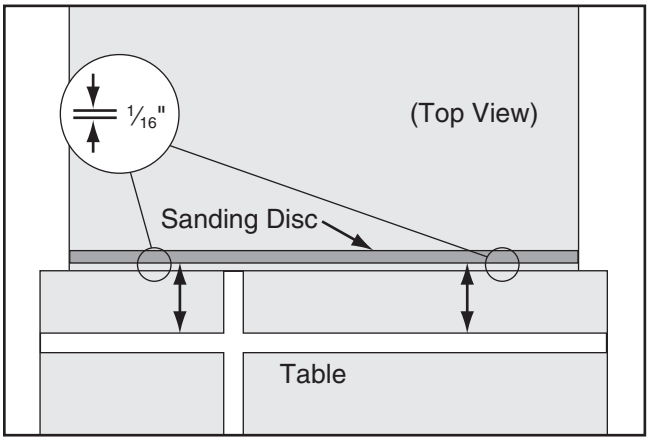


Figure 29. Example of correctly adjusted table.

11. Tighten table cap screws.

12. Spin disc by hand to check if sanding disc touches table.

    — If sanding disc touches table at any point, loosen table cap screws, then repeat **Steps 10–12** until it does not.

    IMPORTANT: DO NOT operate machine until you have verified that sanding disc does not touch table at any point in its rotation.

13. Install disc guard, ensuring guard does not contact sanding disc.

Sanding Operations

The Model G0967 uses a dual-axis miter slot design for increased workpiece control.

⚠CAUTION

Always keep disc guard in place and workpiece on side of wheel that is rotating downward. This will reduce likelihood of workpiece ejection.

⚠CAUTION

To reduce risk of fingers or workpiece getting trapped between work table and sanding disc, adjust table within 1/16" of sanding disc.

To perform sanding operation:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust table and miter gauge (if using) for operation.
3. Refer to **Adjusting Table Gap and Parallelism** on **Page 32** to adjust table within 1/16" of sanding disc.
4. Connect machine to power, turn it ***ON***, and adjust machine to desired speed.
5. Place workpiece on table and firmly against miter gauge (if using).
6. With moderate pressure, push workpiece into down-spin side of rotating disc. See **Figures 30–32** for examples of disc sanding.

Figure 30. Example of X-axis sanding.

Figure 31. Example of miter sanding.

Figure 32. Example of sanding with table tilted.

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.

Grizzly 20" Sanding Discs

These tough, aluminum oxide sanding discs come in a variety of grits to fit the Model G0967. These sanding discs are pre-applied with top-quality pressure-sensitive adhesive.

D1342—60-Grit, 2-Pk.
D1343—80-Grit, 2-Pk.
D1344—100-Grit, 2-Pk.
D1345—120-Grit, 2-Pk.
D1346—150-Grit, 2-Pk.
D1347—180-Grit, 2-Pk.
D1348—220-Grit, 2-Pk.

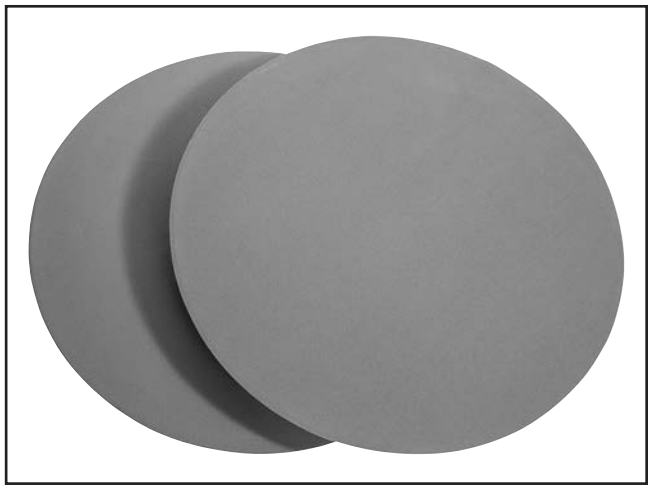


Figure 33. Replacement sanding discs.

PRO-STIK® Abrasive Surface Cleaners

Extend the life of your abrasive discs! Choose the Pro-Stik® with a handle for greater control or without a handle for more usable area.

Model	Size
W1306	1½" x 1½" x 8½"
W1307	2" x 2" x 12"
W1308	1½" x 1½" x 9" with Handle
W1309	2" x 2" x 11" with Handle

Figure 34. PRO-STIK® abrasive cleaners.

Basic Eye Protection

T32323—Woodturners Face Shield
T32401—EDGE Brazeau Safety Glasses, Clear
T32402—EDGE Khor G2 Safety Glasses, Tint
T32404—EDGE Mazeno Safety Glasses, Clear

Figure 35. Assortment of basic eye protection.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 11 Oz. Spray
Use on cast iron table surfaces and other unpainted metal surfaces to reduce sliding friction and hang-ups. This product also reduces rust and prevents resin build-up.

Figure 36. SLIPIT® gel and spray.

D4206—Clear Flexible Hose 4" x 10'
D4256—45° Elbow 4"
W1034—Heavy-Duty Clear Flex Hose 4" x 10'
D2107—Hose Hanger 4¼"
W1015—Y-Fitting 4" x 4" x 4"
W1017—90° Elbow 4"
W1019—Hose Coupler (Splice) 4"
W1317—Wire Hose Clamp 4"
W1007—Plastic Blast Gate 4"
W1053—Anti-Static Grounding Kit
Hand-picked selection of commonly used dust collection components for 4" dust ports.

Figure 37. Dust collection accessories.

G0862—3 HP Portable Cyclone Dust Collector
The G0862 features a 3 HP motor, a whopping 1941 CFM of airflow capacity, and a 45-gallon collection capacity. It's packed with features like a quick-release collection drum, latching system, high-efficiency, two-stage separation driven by a 16" aluminum impeller, durable powder coated finish, and a heavy-duty steel frame and housing.

Figure 38. G0862 3 HP Portable Cyclone Dust Collector.

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 ⅜" thick.

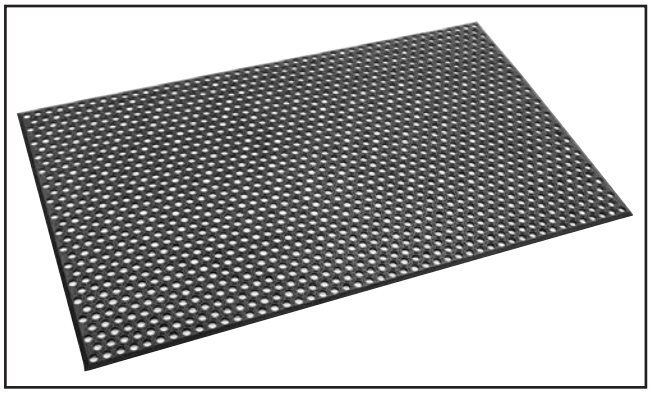
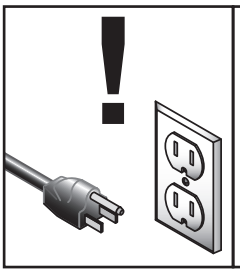


Figure 39. T10456 Anti-Fatigue Mat 3' x 5'.

SECTION 6: MAINTENANCE



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

Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

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

- Loose mounting bolts.
- Damaged sanding disc.
- Worn or damaged wires.
- Any other unsafe condition.

After Each Use
- Sweep surrounding dust and shavings.
- Clean/protect table.

Weekly Maintenance
- Clean/vacuum dust buildup off of motor fan and inside machine cabinet.

Cleaning & Protecting

Cleaning the Model G0967 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.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of a metal protectant like those shown in **Figure 36** on **Page 28**.

Cleaning Sanding Disc

Using an abrasive surface cleaner can prolong the life of a clogged sanding disc, provided it is in otherwise good condition. See **Accessories** on **Page 27** for more details.

To clean sanding disc:

1. Turn machine ***ON***.

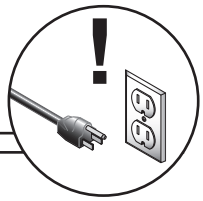
2. Using table as support, rub abrasive cleaner on sanding disc in continuous motion, covering entire surface of disc until disc is no longer clogged.

3. Turn machine ***OFF***.

SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Power switch in OFF position. 2. Stop button depressed/at fault. 3. Machine circuit breaker(s) tripped. 4. Incorrect power supply voltage or circuit size. 5. Power supply circuit breaker tripped or fuse blown. 6. Motor wires connected incorrectly. 7. Wiring broken, disconnected, or corroded. 8. ON/OFF switch or machine circuit breaker at fault. 9. Inverter (VFD) at fault. 10. Braking resistor at fault. 11. Transformer at fault. 12. Relay at fault. 13. Motor or motor bearings at fault.	1. Turn power switch to ON position. 2. Rotate Stop button head to reset. Replace if at fault. 3. Reset circuit breaker(s). 4. Ensure correct power supply voltage and circuit size (**Page 10**). 5. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 6. Correct motor wiring connections (**Page 35**). 7. Fix broken wires or disconnected/corroded connections (**Page 35**). 8. Replace switch/machine circuit breaker. 9. Inspect inverter (VFD); replace if at fault. 10. Inspect braking resistor; replace if at fault. 11. Inspect transformer; replace if at fault. 12. Inspect relay; replace if at fault. 13. Replace motor.
Machine stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Motor wires connected incorrectly. 3. Machine undersized for task. 4. Motor overheated. 5. Machine circuit breaker tripped. 6. Extension cord too long. 7. Motor or motor bearings at fault.	1. Only sand wood/ensure moisture is below 20% (**Page 23**). 2. Correct motor wiring connections (**Page 35**). 3. Clean (**Page 29**)/replace (**Page 24**) sandpaper; reduce feed rate/sanding depth. 4. Clean motor, let cool, and reduce workload. 5. Reset breaker. 6. Move machine closer to power supply; use shorter extension cord (**Page 11**). 7. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Machine feet not adjusted properly or loose. 3. Sanding disc out of balance or loose. 4. Motor fan rubbing on fan cover. 5. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Tighten/adjust machine feet to stabilize machine. 3. Tighten disc hub or replace disc. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Machine operates in reverse.	1. Motor power connections wired out of phase.	1. Correct phase polarity (**Page 20**).

Operation

Symptom	Possible Cause	Possible Solution
Sanding discs clog quickly or excessive sanding disc replacement.	1. Excessive sanding speed. 2. Excessive workpiece pressure. 3. Using too fine of sanding grit. 4. Sanding softwood. 5. Sanding wet stock; workpiece has high sap content. 6. Not using full width of sanding surface. 7. Worn sanding disc.	1. Decrease sanding speed. 2. Reduce workpiece pressure. 3. Use a coarser grit sandpaper (**Page 22**). 4. Use different stock or accept characteristics of workpiece and plan on cleaning (**Page 29**)/replacing (**Page 24**) disc frequently. 5. Dry workpiece properly before sanding (**Page 23**); use different stock or accept characteristics of workpiece and plan on cleaning (**Page 29**)/replacing (**Page 24**) disc frequently. 6. Position workpieces to use different locations to use full width of sanding surface; move workpiece back and forth across sanding surface if operation allows it. 7. Replace sanding disc (**Page 24**).
Deep sanding grooves or scores in workpiece.	1. Excessive sanding speed. 2. Workpiece sanded across grain. 3. Excessive workpiece pressure. 4. Sandpaper too coarse for desired finish. 5. Workpiece held still against disc.	1. Decrease sanding speed. 2. Sand workpiece with grain. 3. Reduce workpiece pressure. 4. Use a finer grit sandpaper (**Page 22**). 5. Move workpiece back and forth across sanding surface if operation allows it.
Burn marks on workpiece.	1. Excessive sanding speed. 2. Excessive workpiece pressure. 3. Using too fine of sanding grit. 4. Workpiece held still against disc. 5. Sanding disc loaded with sawdust, resin, and/or pitch.	1. Decrease sanding speed. 2. Reduce workpiece pressure. 3. Use a coarser grit sandpaper (**Page 22**). 4. Move workpiece back and forth across sanding surface if operation allows it. 5. Clean (**Page 29**)/replace (**Page 24**) sanding disc.
Glazed sanding surfaces.	1. Sanding wet stock; workpiece has high sap content. 2. Sanding disc loaded with sawdust, resin, and/or pitch.	1. Dry workpiece properly before sanding (**Page 23**); use different stock or accept characteristics of workpiece and plan on cleaning (**Page 29**)/replacing (**Page 24**) disc frequently. 2. Clean (**Page 29**)/replace (**Page 24**) sanding disc.
Workpiece not sanded square when table tilt is set to 0˚.	1. Table is not perpendicular to sanding disc. 2. Table is not parallel to sanding disc.	1. Calibrate table tilt (**Page 33**). 2. Adjust table parallelism (**Page 32**).
Sanded workpiece angle does not match miter gauge setting.	1. Miter gauge needs to be calibrated.	1. Calibrate miter gauge scale (**Page 33**).
Abrasive grit rubs off sanding disc easily.	1. Sanding disc has been stored in an incorrect environment. 2. Sanding disc has been folded or crushed.	1. Replace sanding disc (**Page 24**). Store sanding disc in a cool, dry area. 2. Replace sanding disc (**Page 24**). Store sanding disc flat, not folded or bent.
Workpiece frequently gets pulled out of your hands.	1. Not supporting workpiece properly.	1. Use miter gauge to support workpiece.

Adjusting Table Gap & Parallelism

The X-axis miter slot must be parallel with the face of the sanding disc to ensure accurate results. There should also be no more than 1/16" between the edge of the table and the sanding disc in order to minimize the risk of the workpiece and the operator's fingers being caught in the gap. On the other hand, if this gap is too small, the sandpaper will rub against the table, damaging both.

Perform this adjustment any time the sanding disc is changed or the table tilt is adjusted.

Tools Needed	Qty
Phillips Head Screwdriver #2	1
Hex Wrench 6mm	1
Feeler Gauge 1/16"	1

To adjust table gap and parallelism:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (3) Phillips head screws and flat washers shown in **Figure 40** to remove disc guard.

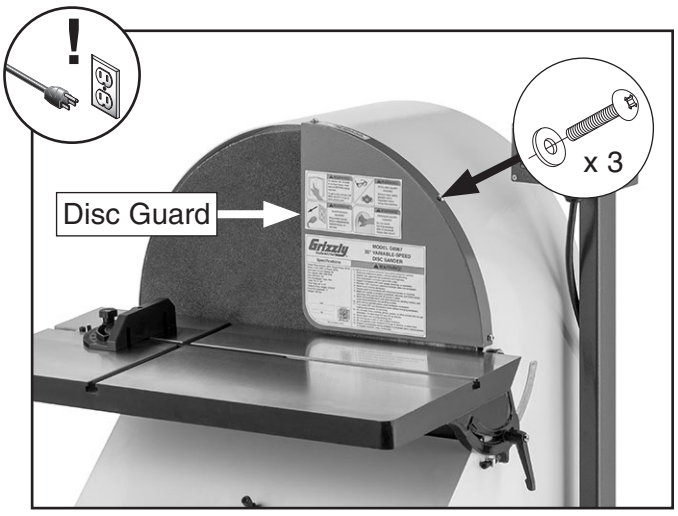


Figure 40. Location of disc guard and fasteners.

3. Loosen (6) cap screws shown in **Figure 41**.

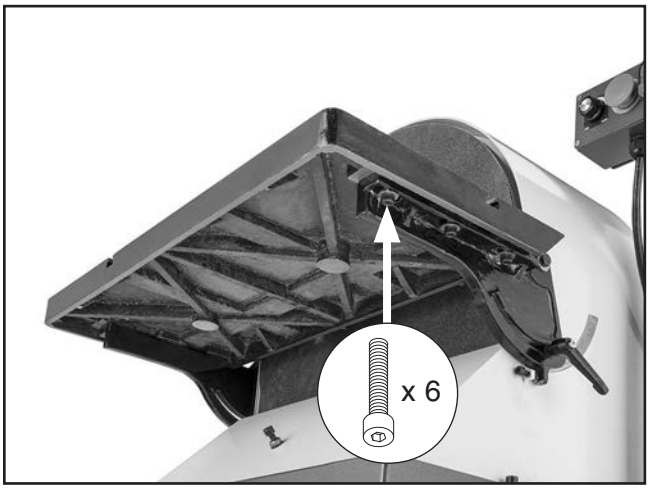


Figure 41. Location of table cap screws.

4. With sanding disc installed, adjust table so there is a 1/16" gap between disc and edge of table along its full width (see **Figure 42**).

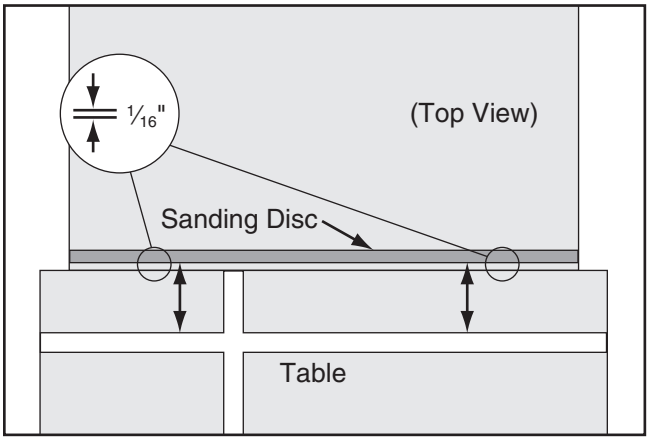


Figure 42. Example of correctly adjusted table.

5. Tighten table cap screws.

6. Spin disc by hand to check if sanding disc touches table.

   — If sanding disc touches table at any point, repeat **Steps 3–5** until it does not.

   IMPORTANT: DO NOT operate machine until you have verified that sanding disc does not touch table at any point in its rotation.

7. Install disc guard, ensuring guard does not contact sanding disc.

Calibrating Miter Gauge Scale

Calibrate the miter gauge scale if the angle of a workpiece sanded with the miter gauge does not match the angle shown on the miter gauge scale.

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

To calibrate miter gauge scale:

1. DISCONNECT MACHINE FROM POWER!

2. Refer to **Adjusting Table Gap and Parallelism** on **Page 32** to adjust x-axis miter slot parallel to sanding disc.

3. Place miter gauge in x-axis slot of table and loosen miter gauge lock knob (see **Figure 43**).

4. Use 90° square to adjust miter gauge square to sanding disc (see **Figure 43**).

   — If angle indicator points to 90°, no adjustment is required.

   — If angle indicator *does not* point to 90°, proceed to **Step 5**.

5. Loosen screw shown in **Figure 43**, adjust indicator to point to 90°, then tighten screw.

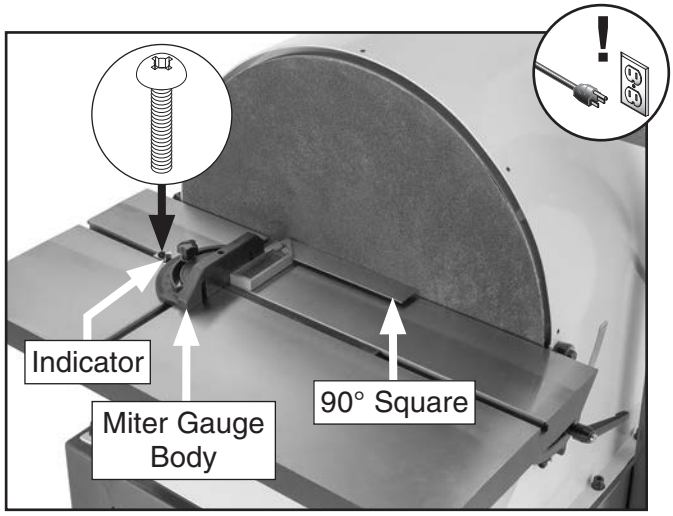


Figure 43. Example of miter gauge square to sanding disc.

Calibrating Table Tilt Scale & Stops

Use the following steps to check the accuracy of the table tilt components.

Note: *Although these steps can be done with the sandpaper installed, these adjustment will be more precise without it.*

Calibrating Table Tilt

Use the following steps to check the accuracy of the 90° stop screw and the table tilt scale if workpieces are not square when being sanded at 90°.

Tools Needed	Qty
90° Square	1
Hex Wrench 5mm	1
Phillips Head Screwdriver #2	1

To calibrate table tilt:

1. DISCONNECT MACHINE FROM POWER!

2. Set 90° square on table surface and other edge against face of disc (see **Figure 44**).

3. While supporting table, loosen (2) table tilt lock handles, then adjust 90° stop screw until table is perpendicular to disc (see **Figure 44**).

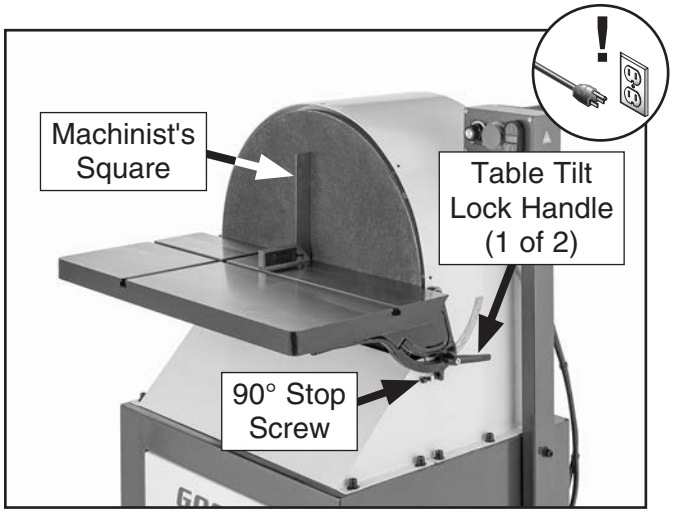


Figure 44. Squaring table to sanding disc.

4. Tighten table lock handles.

5. Check to see if angle indicator points to zero (see **Figure 45**).

   — If angle indicator *does not* point to zero, proceed to **Step 6**.

   — If angle indicator *does* point to zero, table tilt is calibrated correctly and no further adjustment is necessary.

6. Loosen angle indicator Phillips head screw (see **Figure 45**), adjust indicator to zero, then tighten screw.

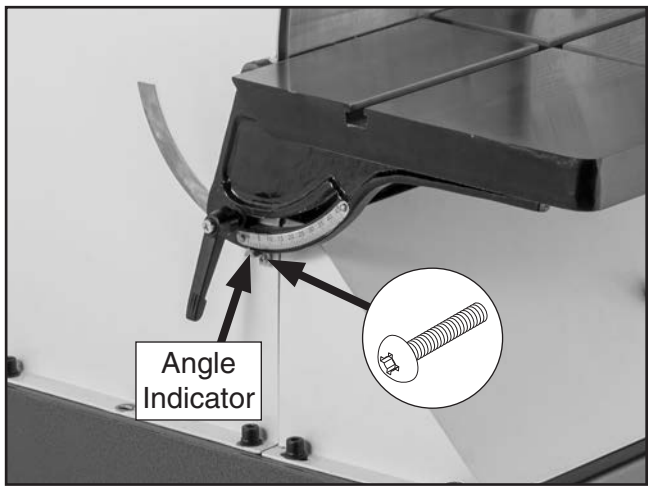


Figure 45. Location of angle indicator and Phillips head screw.

Calibrating 45° Stop Screw

When the 45° stop screw is calibrated correctly, it allows you to quickly adjust the table tilt to 45° without referring to the angle scale.

Tools Needed	Qty
45° Square	1
Open-End Wrench 13mm	1
Hex Wrench 6mm	1

To calibrate 45° stop screw:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen jam nut on 45° stop screw (see **Figure 46**).

3. Loosen (2) table tilt lock handles and allow table to rest on 45° stop screw (see **Figure 46**).

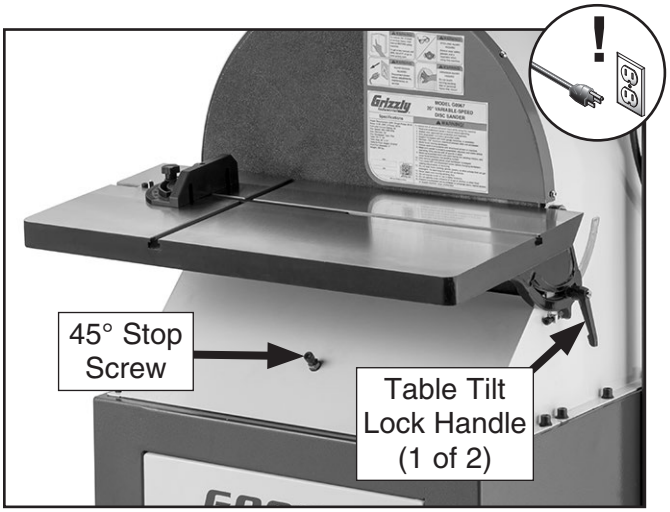


Figure 46. Location of table tilt lock handles and 45° stop screw.

4. Set 45° square on table surface and other edge against face of disc (see **Figure 47**).

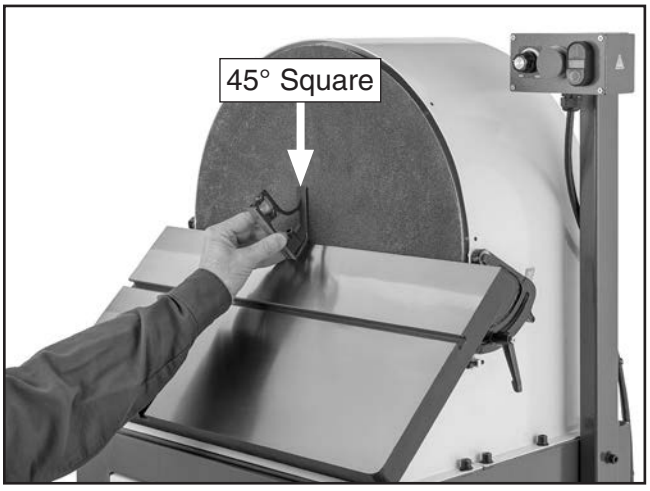


Figure 47. Checking 45° stop screw with square.

5. Adjust 45° stop screw until table is exactly 45° to disc, then tighten jam nut on 45° stop screw without turning stop screw to secure setting.

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.

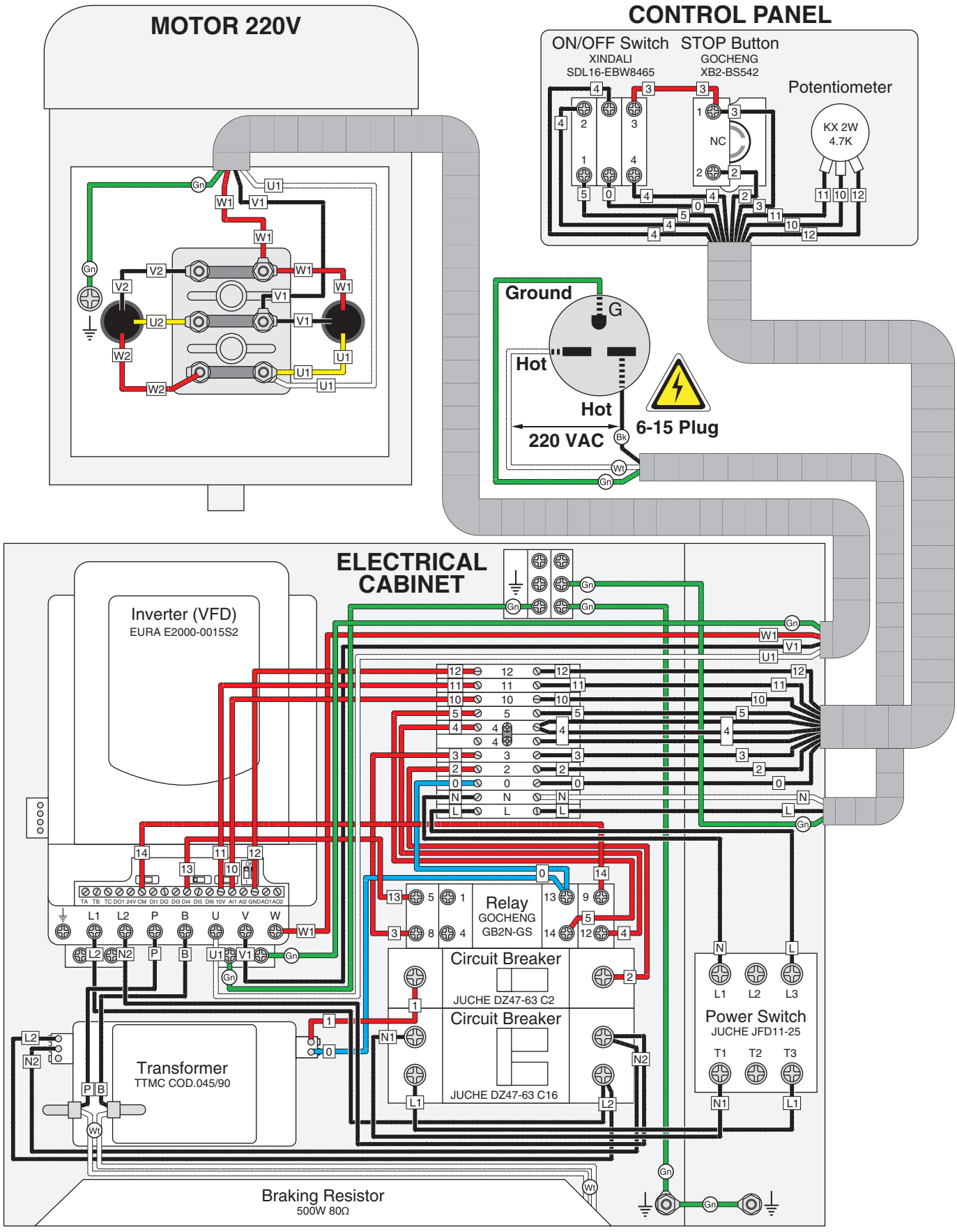
NOTICE

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	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram



STOP ***READ ELECTRICAL SAFETY ON PAGE 35!***

Electrical Component Photos

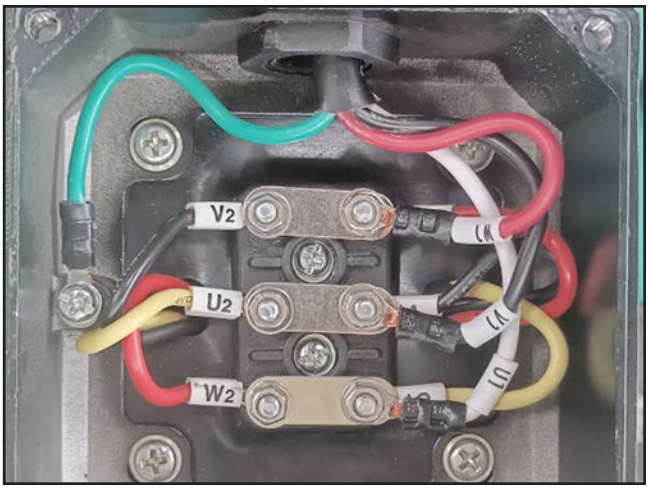


Figure 48. Motor wiring.

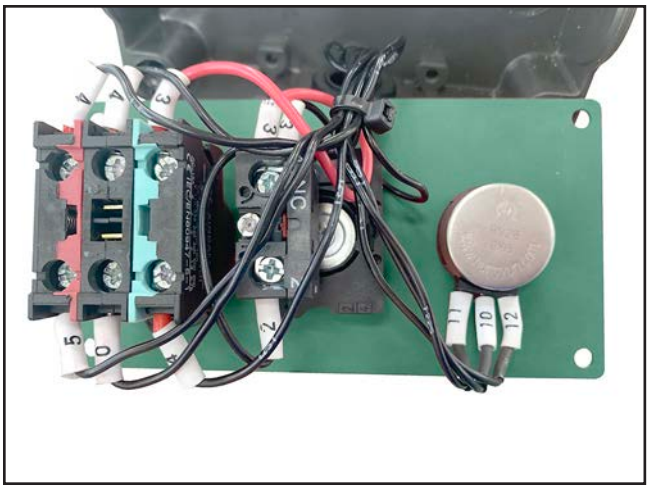


Figure 49. Control panel wiring.

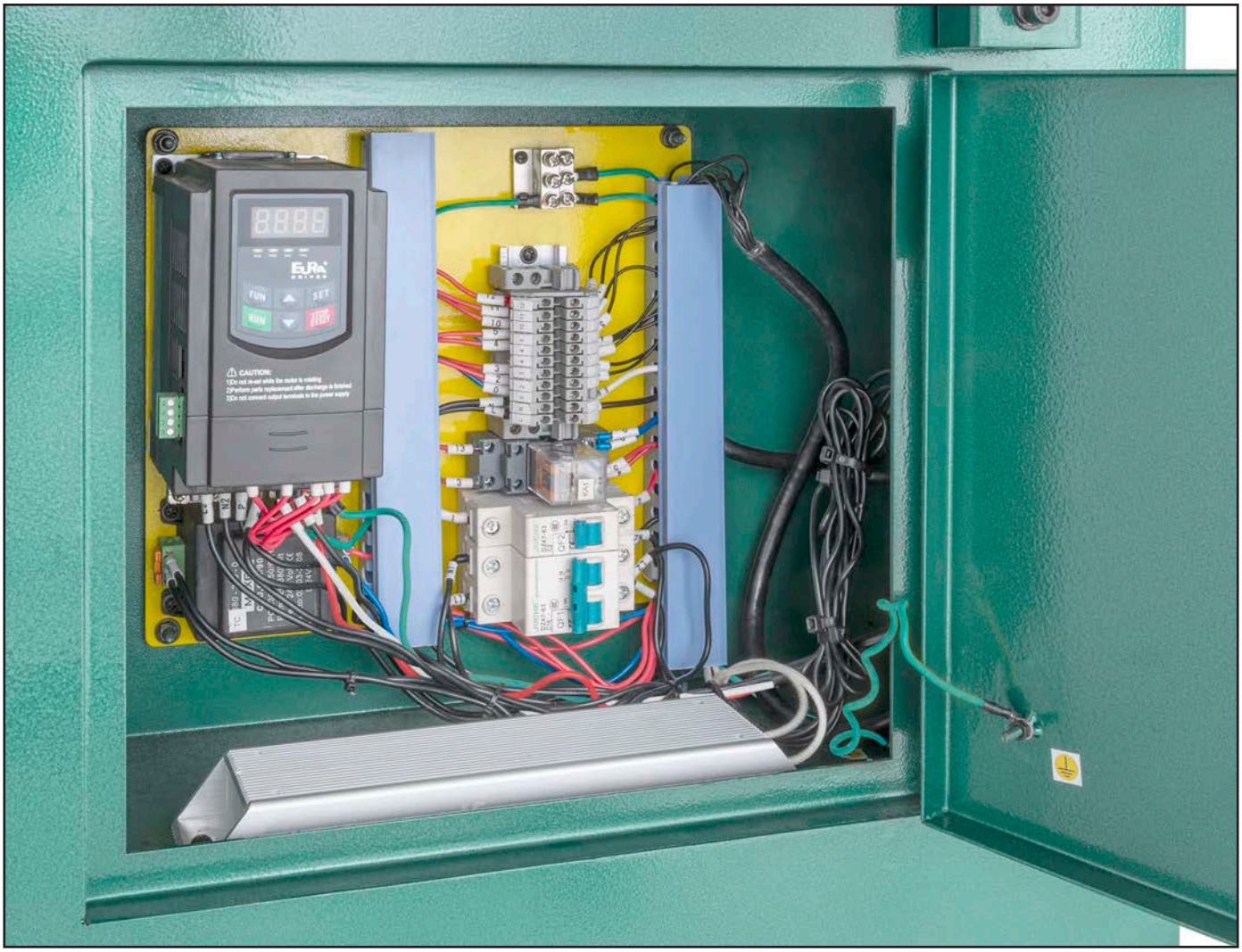
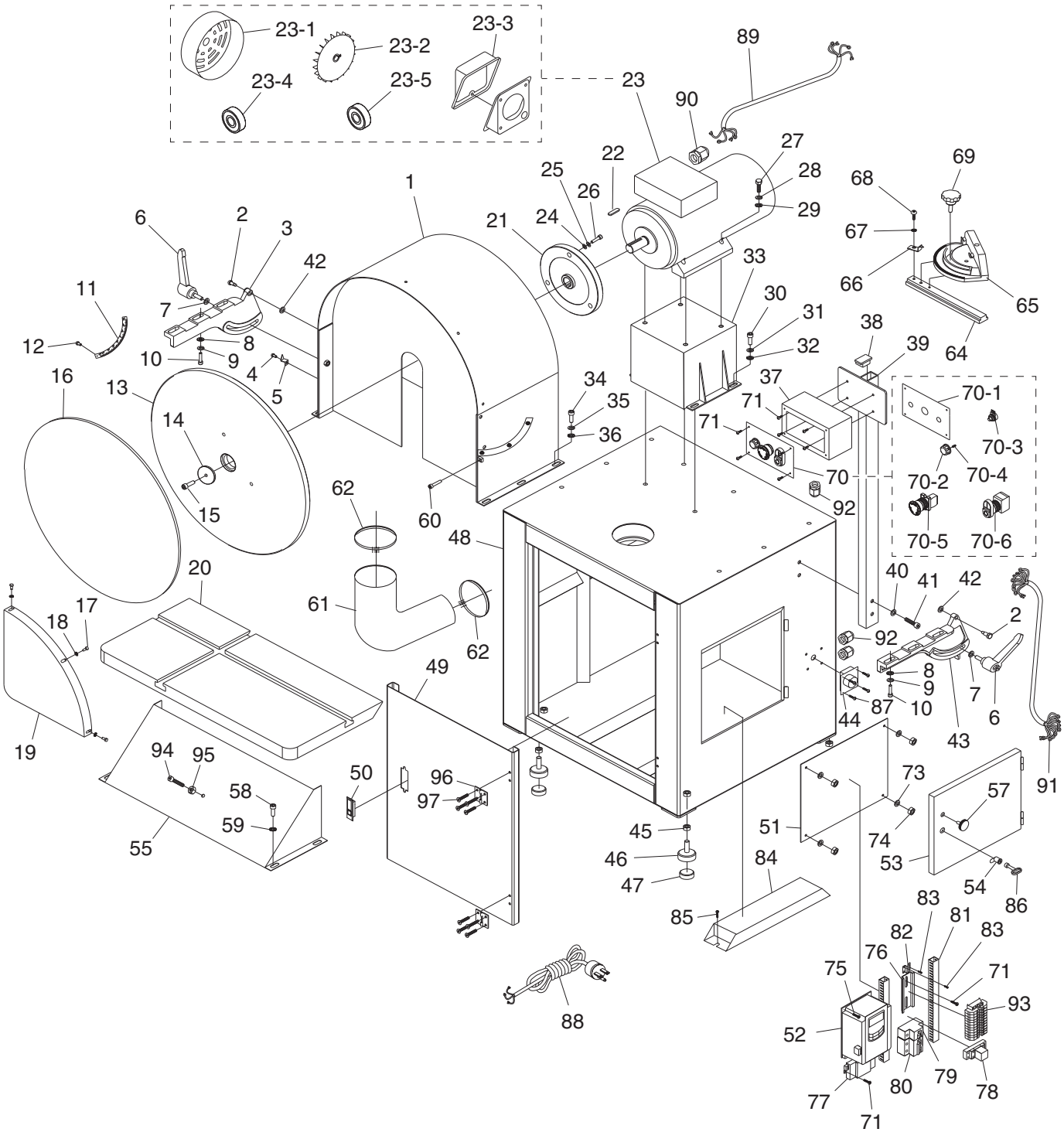


Figure 50. Electrical cabinet.

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

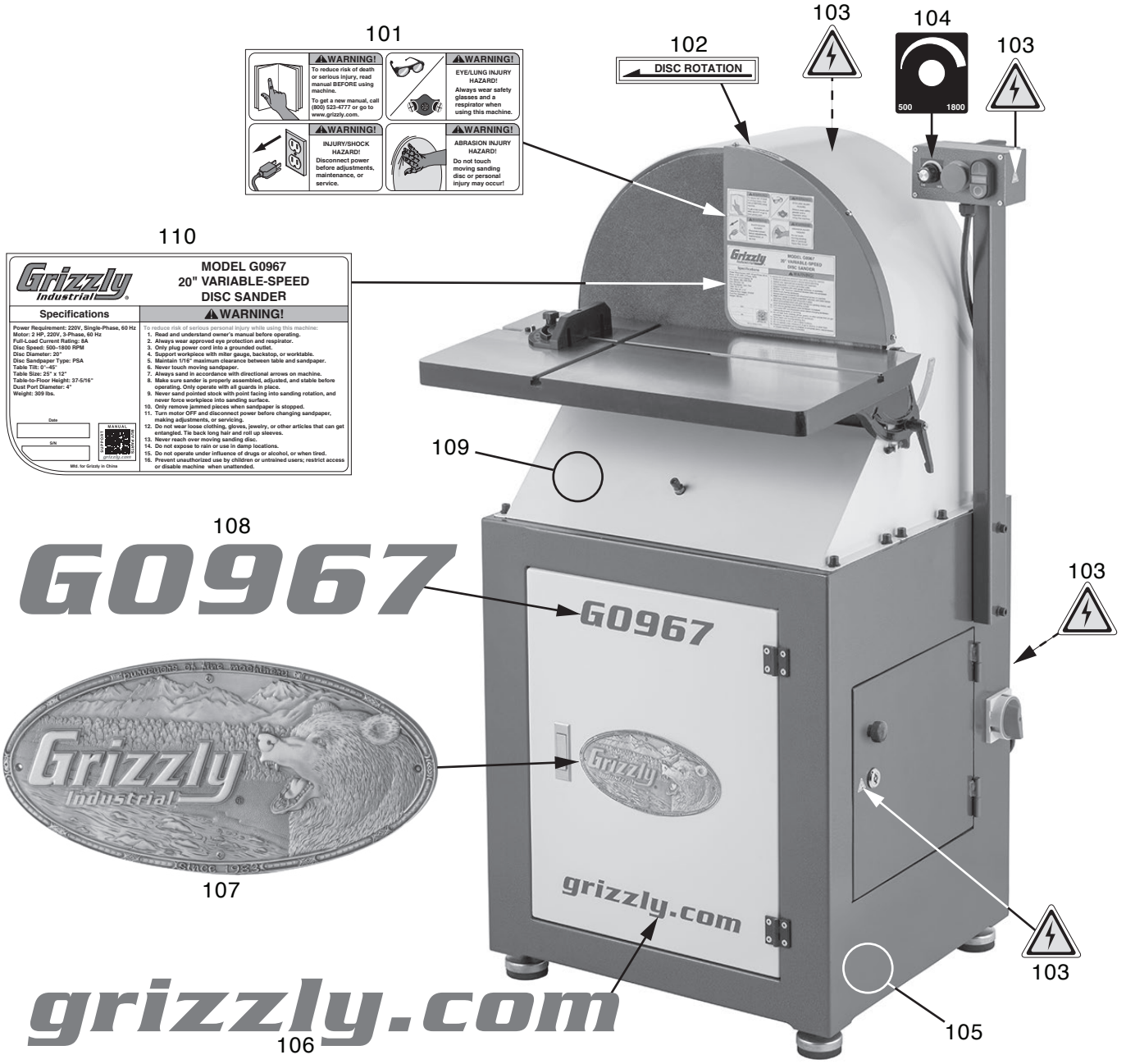


Main Parts List

REF	PART #	DESCRIPTION
1	P0967001	MOTOR GUARD
2	P0967002	SHOULDER BOLT M8-1.25 X 6, 9 X 16.5
3	P0967003	TABLE MOUNT LEFT
4	P0967004	PHLP HD SCR M5-.8 X 6
5	P0967005	TABLE TILT POINTER
6	P0967006	ADJUSTABLE HANDLE M8-1.25 X 32, 63L
7	P0967007	FLAT WASHER 8MM
8	P0967008	FLAT WASHER 8MM
9	P0967009	LOCK WASHER 8MM
10	P0967010	CAP SCREW M8-1.25 X 30
11	P0967011	TILT SCALE
12	P0967012	RIVET 2 X 6MM NAMEPLATE, STEEL
13	P0967013	SANDING DISC STEEL
14	P0967014	BUSHING 10 X 48 X 8MM
15	P0967015	CAP SCREW M6-1 X 25
16	P0967016	SANDING DISC 20" PSA 60-GRIT (2 PK)
17	P0967017	PHLP HD SCR M5-.8 X 6
18	P0967018	FLAT WASHER 5MM
19	P0967019	DISC GUARD UPPER
20	P0967020	TABLE
21	P0967021	MOTOR FLANGE
22	P0967022	KEY 8 X 7 X 32
23	P0967023	MOTOR 2HP 220V 3-PH
23-1	P0967023-1	MOTOR FAN COVER
23-2	P0967023-2	MOTOR FAN
23-3	P0967023-3	MOTOR JUNCTION BOX
23-4	P0967023-4	BALL BEARING 6203-2RS (FRONT)
23-5	P0967023-5	BALL BEARING 6205-2RS (REAR)
24	P0967024	FLAT WASHER 10MM
25	P0967025	LOCK WASHER 10MM
26	P0967026	CAP SCREW M10-1.5 X 35
27	P0967027	HEX BOLT M8-1.25 X 30
28	P0967028	LOCK WASHER 8MM
29	P0967029	FLAT WASHER 8MM
30	P0967030	CAP SCREW M8-1.25 X 16
31	P0967031	LOCK WASHER 8MM
32	P0967032	FLAT WASHER 8MM
33	P0967033	MOTOR BASE
34	P0967034	CAP SCREW M8-1.25 X 16
35	P0967035	LOCK WASHER 8MM
36	P0967036	FLAT WASHER 8MM
37	P0967037	CONTROL PANEL BOX
38	P0967038	PLASTIC CAP
39	P0967039	PEDESTAL
40	P0967040	FLAT WASHER 8MM
41	P0967041	CAP SCREW M8-1.25 X 40
42	P0967042	FLAT WASHER 10 X 22 X 2MM
43	P0967043	TABLE MOUNT RIGHT
44	P0967044	POWER SWITCH JUCHE JFD11-25
45	P0967045	HEX NUT M10-1.5
46	P0967046	FOOT M10-1.5 X 50
47	P0967047	FOOT PAD
48	P0967048	CABINET

REF	PART #	DESCRIPTION
49	P0967049	CABINET DOOR
50	P0967050	CAM LATCH
51	P0967051	ELECTRICAL MOUNTING BOARD
52	P0967052	INVERTER EURA E2000-0015S2
53	P0967053	ELECTRICAL BOX DOOR
54	P0967054	CAM LOCK CIRCULAR-KEYWAY
55	P0967055	DISC GUARD LOWER
57	P0967057	KNOB BOLT M8-1.25 X 15, D32, ROUND KD
58	P0967058	CAP SCREW M8-1.25 X 16
59	P0967059	FLAT WASHER 8MM
60	P0967060	CAP SCREW M6-1 X 30
61	P0967061	DUST HOSE 4" X 20"
62	P0967062	HOSE CLAMP 4"
64	P0967064	MITER BAR
65	P0967065	MITER GAUGE
66	P0967066	MITER GAUGE POINTER
67	P0967067	FLAT WASHER 5MM
68	P0967068	PHLP HD SCR M5-.8 X 10
69	P0967069	KNOB BOLT M6-1 X 25, 5-LOBE, D32
70	P0967070	CONTROL PANEL ASSEMBLY
70-1	P0967070-1	CONTROL PANEL
70-2	P0967070-2	SPEED DIAL
70-3	P0967070-3	POTENTIOMETER KX 2W 4.7K
70-4	P0967070-4	SET SCREW M4-.7 X 6 SLOTTED
70-5	P0967070-5	STOP BUTTON GOCHENG XB2-BS542
70-6	P0967070-6	ON/OFF SWITCH XINDALI SDL16-EBW8465
71	P0967071	PHLP HD SCR M4-.7 X 8
73	P0967073	FLAT WASHER 6MM
74	P0967074	HEX NUT M6-1
75	P0967075	PHLP HD SCR M4-.7 X 16
76	P0967076	DIN RAIL 25 X 30 X 240MM
77	P0967077	TRANSFORMER TTMC COD.045/90 30VA 240V
78	P0967078	RELAY GOCHENG GB2N-GS 24VAC
79	P0967079	CIRCUIT BREAKER JUCHE DZ47-63 C2
80	P0967080	CIRCUIT BREAKER JUCHE DZ47-63 C16
81	P0967081	WIRE LOOM 25 X 30 X 240MM
82	P0967082	TERMINAL BAR 3P M4 X 20 TM4
83	P0967083	PHLP HD SCR M4-.7 X 12
84	P0967084	BRAKING RESISTOR 500W 80OHM
85	P0967085	PHLP HD SCR M5-.8 X 12
86	P0967086	DOOR KEY
87	P0967087	PHLP HD SCR M4-.7 X 20
88	P0967088	POWER CORD 16G 3W 98" 6-15P
89	P0967089	MOTOR CORD 16G 4W 69"
90	P0967090	STRAIN RELIEF TYPE-3 M20-1.5
91	P0967091	CONTROL PANEL CORD 22G 10W 59"
92	P0967092	STRAIN RELIEF TYPE-3 M18-1.5
93	P0967093	TERMINAL BAR 11P DIN30 12-14G
94	P0967094	CAP SCREW M8-1.25 X 35
95	P0967095	LOCK NUT M8-1.25
96	P0967096	HINGE
97	P0967097	FLAT HD CAP SCR M5-.8 X 10

Labels & Cosmetics



REF	PART #	DESCRIPTION
101	P0967101	COMBO WARNING LABEL
102	P0967102	DISC ROTATION LABEL
103	P0967103	ELECTRICITY LABEL
104	P0967104	VARIABLE-SPEED LABEL
105	P0967105	TOUCH-UP PAINT, GRIZZLY GREEN

REF	PART #	DESCRIPTION
106	P0967106	GRIZZLY.COM LABEL
107	P0967107	GRIZZLY NAMEPLATE SMALL
108	P0967108	MODEL NUMBER LABEL
109	P0967109	TOUCH-UP PAINT, GRIZZLY BEIGE
110	P0967110	MACHINE ID LABEL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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

WARRANTY

grizzly.com