MODEL G0997
6" X 48" BELT/12" DISC VS COMBO SANDER
OWNER'S MANUAL
(For models manufactured since 10/24)

#CS23395 PRINTED IN TAIWAN V1.11.24

******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.

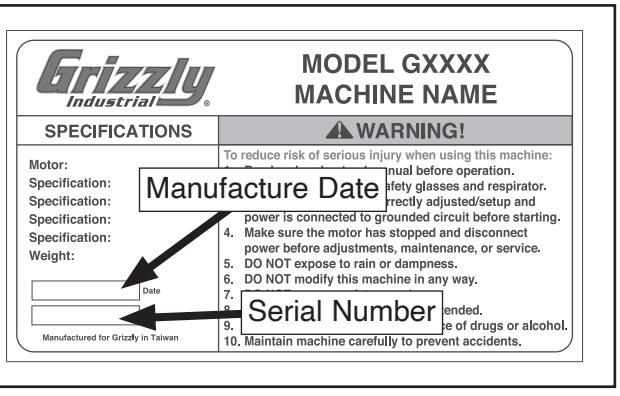
Manual Accuracy

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**.

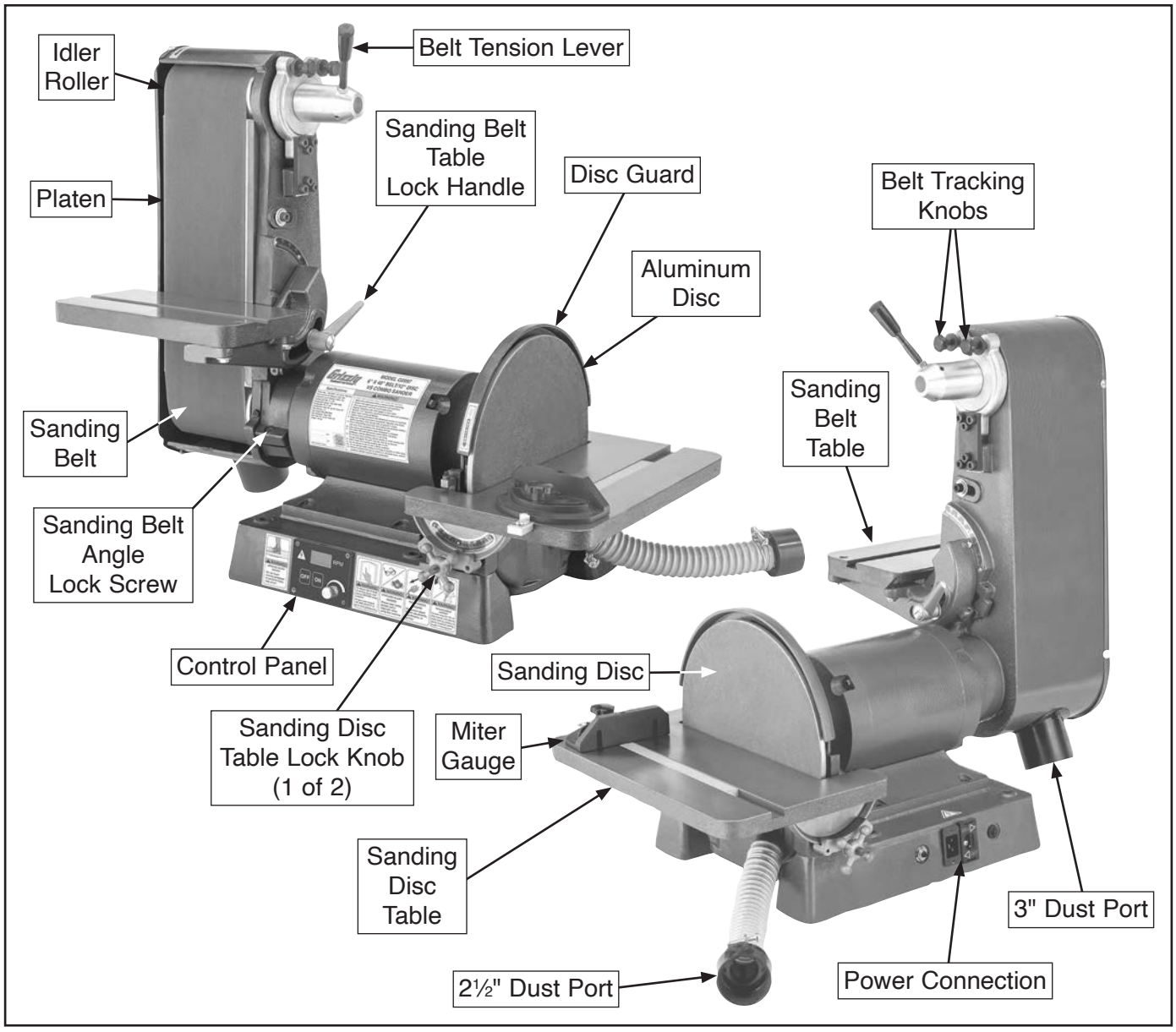
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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.

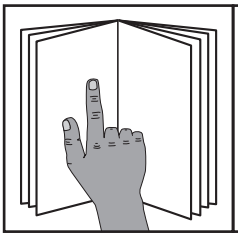


⚠WARNING

For Your Own Safety Read Instruction Manual Before Operating 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 belt or 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

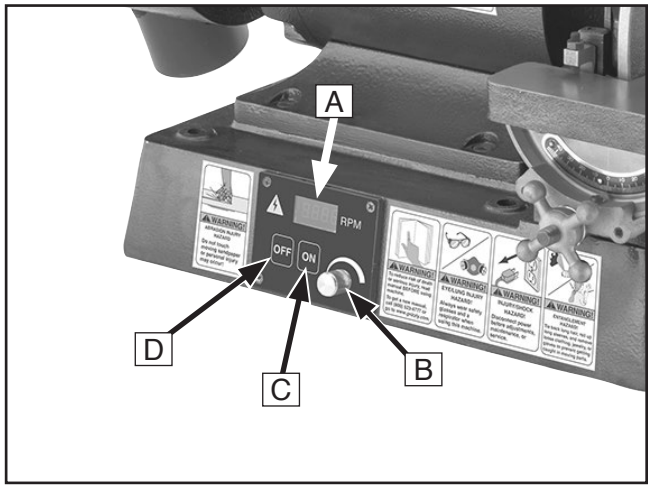


Figure 1. Control panel components.

A. Motor Speed Digital Readout: Displays current motor speed in RPM.

B. Speed Dial: Adjusts motor speed from 900–3000 RPM.

C. ON Button: Enables machine startup. Once ON button has been pressed, adjust speed dial in either direction to start motor.

D. OFF Button: Turns machine ***OFF***.

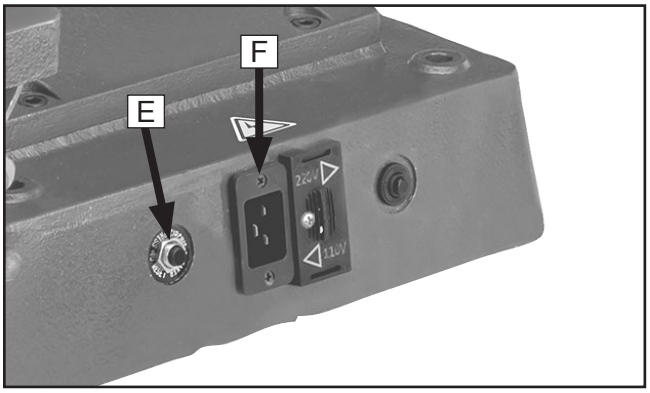


Figure 2. Rear 110V power components.

E. 110V Circuit Breaker Reset Button: Allows machine connected to 110V power to be restarted after overload protection has tripped. To reset, push OFF button, wait a few minutes for machine to cool, then press reset button. If button does not *stay* depressed, allow machine to cool longer, then try again.

F. 110V Power Receptacle: Provides 110V power connection for power cord.

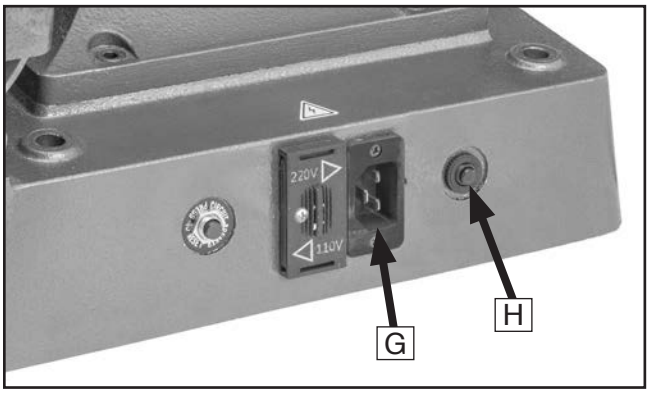


Figure 3. Rear 220V power components.

G. 220V Power Receptacle: Provides 220V power connection for power cord.

H. 220V Circuit Breaker Reset Button: Allows machine connected to 220V power to be restarted after overload protection has tripped. To reset, push OFF button, wait a few minutes for machine to cool, then press reset button. If button does not *stay* depressed, allow machine to cool longer, then try again.

Belt Sanding Components

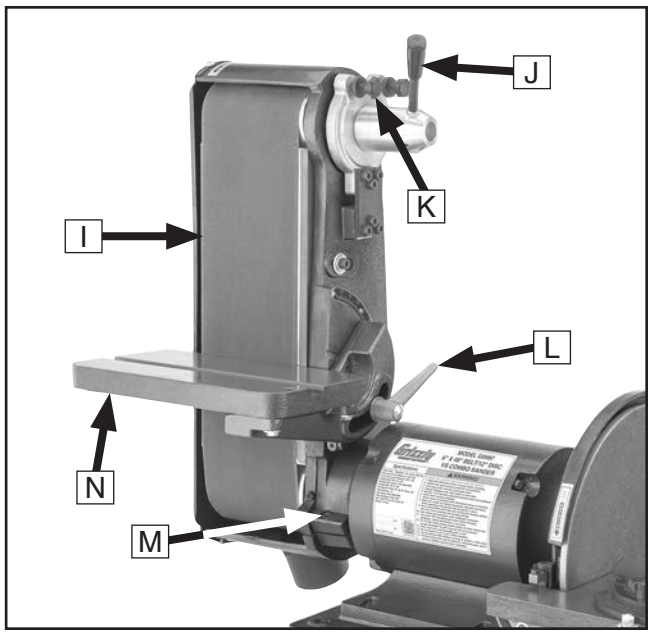


Figure 4. Belt sanding components.

I. Platen: Provides belt support for flat sanding surface and tilts between 0º–90º.

J. Belt Tension Lever: Releases belt tension for removal or installation when moved toward table.

K. Belt Tracking Knob (1 of 2): Controls side-to-side tracking of sanding belt.

L. Sanding Belt Table Lock Handle: Loosens to adjust table tilt; tightens to secure.

M. Sanding Belt Angle Lock Screw: Loosens to adjust platen tilt; tightens to secure.

N. Sanding Belt Table: Supports workpiece as it is pressed against sanding belt, and tilts between 20º up and 45º down.

Disc Sanding Components

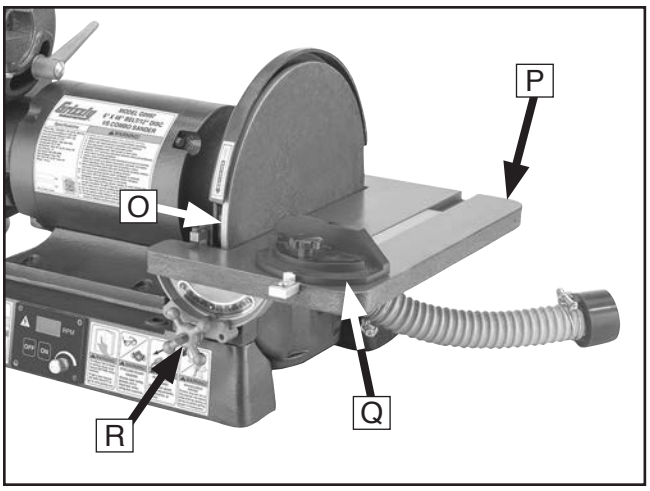


Figure 5. Disc sanding components.

O. Aluminum Disc: Provides disc support for flat sanding surface.

P. Sanding Disc Table: Supports workpiece as it is pressed against sanding disc, and tilts between 30º up and 45º down.

Q. Miter Gauge: Braces workpiece on table for miter sanding. Adjusts between 60º left and 60º right. Can also be used on sanding belt table.

R. Sanding Disc Table Lock Knob (1 of 2): Loosens to adjust table tilt; tightens to secure.

MACHINE DATA SHEET

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

MODEL G0997 6" X 48" BELT/12" DISC VARIABLE-SPEED COMBO SANDER

Product Dimensions:

Weight	146 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	32-1/2 x 30 x 29-1/2 in.
Footprint (Length x Width)	16-1/2 x 14 in.

Shipping Dimensions:

Type	Cardboard Box
Content	Machine
Weight	159 lbs.
Length x Width x Height	30 x 28 x 18 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	110V or 220V, Single-Phase, 60 Hz
Full-Load Current Rating	24A at 110V, 12A at 220V
Minimum Circuit Size	30A at 110V, 15A at 220V
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	72 in.
Power Cord Gauge	12AWG for 110V, 14AWG for 220V
Plug Included	Yes
Included Plug Type	5-15 for 110V, 6-15 for 220V
Switch Type	ON/OFF Button
Inverter (VFD) Type	OEM Control Board
Inverter (VFD) Size	4 HP

Motors:

Main

Horsepower	1-1/4 HP
Phase	3-Phase
Amps	5.1A
Speed	1725 RPM
Type	TEFC Induction
Power Transfer	Direct
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Belt Sander Info

Sanding Belt Width	6 in.
Sanding Belt Length	48 in.
Sanding Belt Speed	1180 - 3920 FPM
Sanding Belt Tilt	90 deg.
Table Length	12-5/8 in.
Table Width	6-7/8 in.
Table Thickness	1-1/8 in.
Table Tilt	Up 20, Down 45 deg.
Table-to-Floor Height	14-1/8 in.
Max Height of Belt in Vertical Position	27 in.
Drive Wheel Diameter	5 in.
Drive Wheel Width	6 in.
Belt Tension Release Type	Quick-Release Lever
Platen Type	Cast Iron
Platen Length	14-1/2 in.
Platen Width	6-1/2 in.
Idler Wheel Diameter	3-1/2 in.
Idler Wheel Width	6 in.

Disc Sander Info

Disc Diameter	12 in.
Disc Speed	900 - 3000 RPM
Disc Sandpaper Backing Type	PSA
Included Sanding Disc Grit Size	80 Grit
Table Length	16-1/2 in.
Table Width	7 in.
Table Thickness	1 in.
Table Tilt	Up 30, Down 45 deg.
Table-to-Floor Height	7 in.

Construction Materials

Base	Cast Aluminum
Table	Ground Cast Iron
Frame	Cast Aluminum
Disc	Aluminum
Miter Gauge	Die Cast Aluminum/Aluminum Bar
Paint Type/Finish	Epoxy

Other Related Info

Miter Gauge Slot Width	3/4 in.
Miter Gauge Slot Height	3/8 in.
Number of Dust Ports	2
Dust Port Size	2-1/2, 3 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	Machine ID Label

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 loose clothing, gloves, neckties, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Combo Sanders

⚠WARNING

Serious injury or death can occur from fingers, clothing, jewelry, or hair getting pinched/entangled in rotating disc, belt, spindle or other moving components. Abrasion injuries can occur from touching moving sandpaper with bare skin. Workpieces thrown by sanding surface can strike operator or bystanders with moderate force, causing impact injuries. Long-term respiratory damage can occur from using sander without proper use of a respirator. To reduce the risk of these hazards, operator or bystanders MUST completely heed the hazards and warnings below.

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

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 the risk of fingers or workpieces getting caught in it. Minimize this risk by adjusting table/support to no more than 1/16" away from sandpaper.

HAND PLACEMENT. Rotating sandpaper can remove skin quickly. Always keep hands away from moving sandpaper during operation. Stop machine to clean table of sawdust and chips.

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

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

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

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.

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

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

SANDPAPER CONDITION. Worn or damaged sandpaper can fly apart and throw debris at operator, or aggressively grab workpiece, resulting in subsequent injuries from operator loss of workpiece control. Always inspect sandpaper before operation and replace if worn or damaged.

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 110V ..... 24 Amps
Full-Load Current Rating at 220V ..... 12 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 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 ..... 30 Amps
Plug/Receptacle ..... NEMA 5-15

Circuit Requirements for 220V

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.

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.

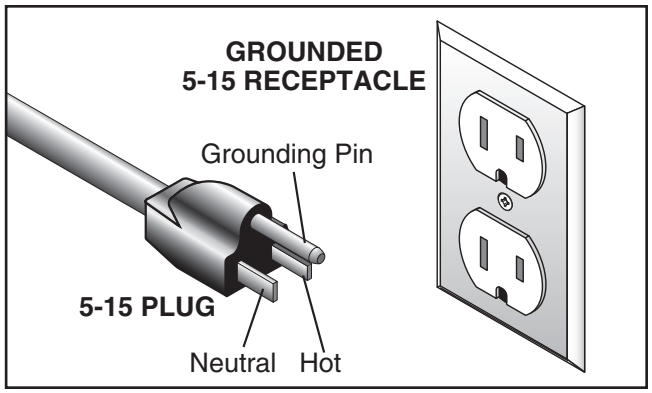
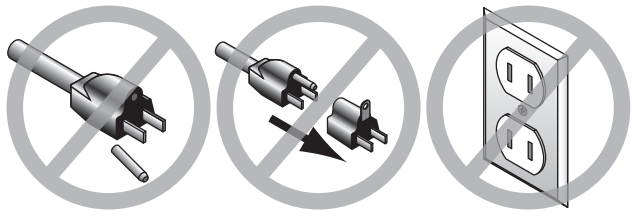


Figure 6. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

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

For 220V 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.

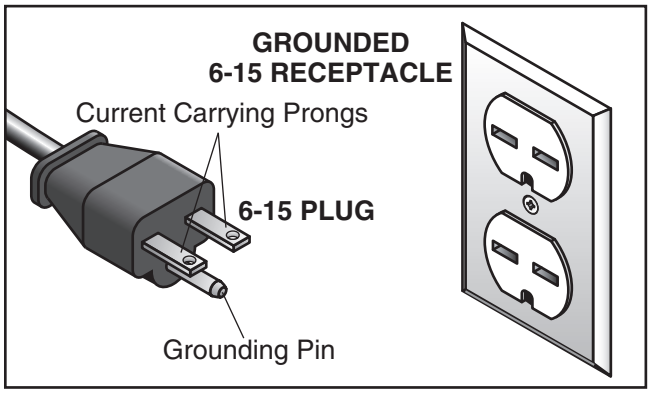


Figure 7. Typical 6-15 plug and receptacle.

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

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

Extension Cords

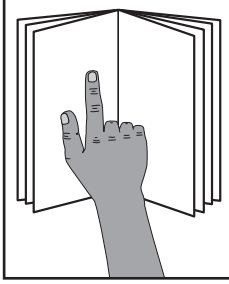
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

Minimum Gauge Size (110V).....10 AWG
Minimum Gauge Size (220V).....16 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

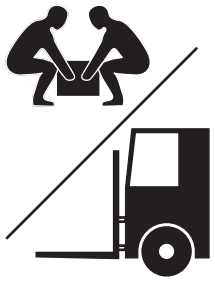


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Another Person	1
• Safety Glasses (for each person)	1 Pr.
• Disposable Rags	As Needed
• Cleaner/Degreaser	As Needed
• Disposable Gloves	As Needed
• Mounting Hardware	As Needed
• Flat Head Screwdriver ¼"	1
• Phillips Head Screwdriver #2	1
• Wrench or Socket 12, 17mm	1
• 90° Square	1
• Dust Hose 2½", 3"	1 Ea.
• Hose Clamp 2½", 3"	1 Ea.
• Dust Collection System	1

Unpacking

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

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

Inventory

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

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

NOTICE

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

Inventory (Figure 8)	Qty
A. Sander (Not Shown)	1
B. Sanding Belt Table	1
C. Dust Port 3"	1
D. Belt Tension Lever w/Hex Nut 3/8"-16	1
E. Sanding Belt Table Mount	1
F. Dust Hose Assembly w/2 1/2" Dust Port	1
G. Miter Gauge	1
H. Hex Wrench 6mm	1
I. Sanding Disc Table	1
J. Power Cord 12AWG 72" w/5-15 Plug	1
K. Power Cord 14AWG 72" w/6-15 Plug	1
L. Fasteners (Not Shown)	
—Hex Bolts 5/16"-18 x 1"	3
—Flat Washers 5/16"	3
—Phillips Head Screws 1/4"-20 x 1/2"	2
—Flange Screws 10-24 x 3/8"	2

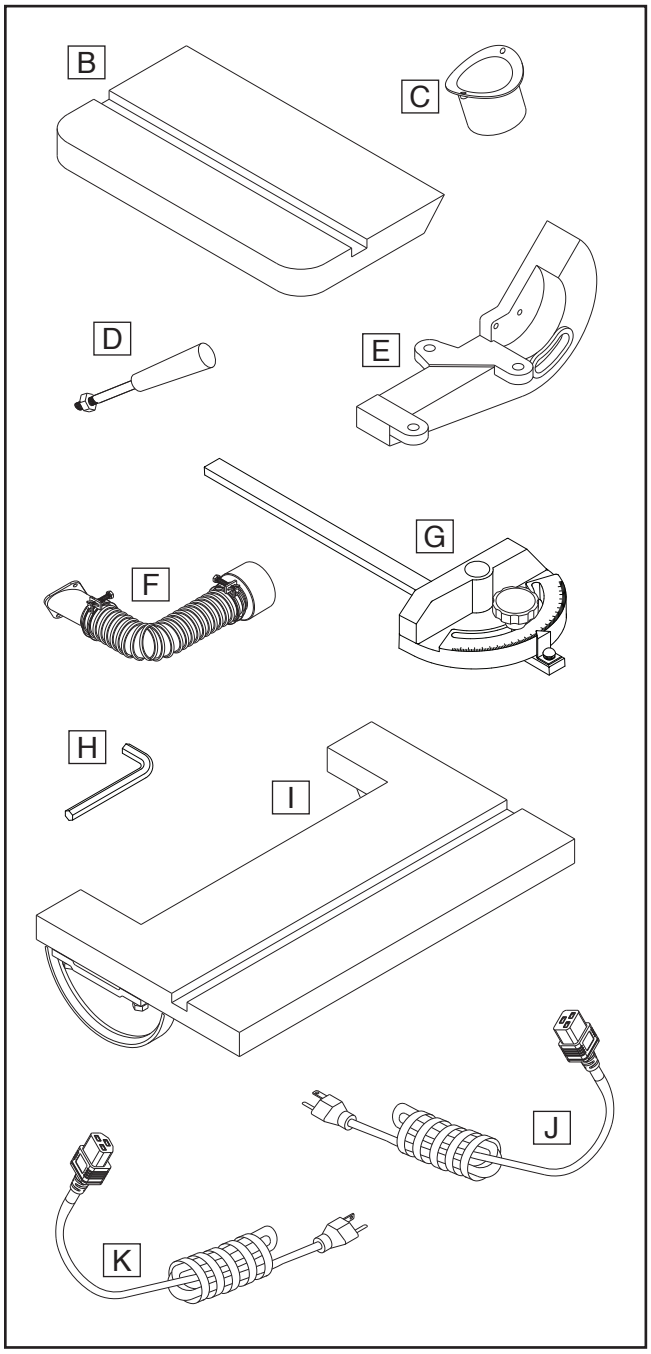
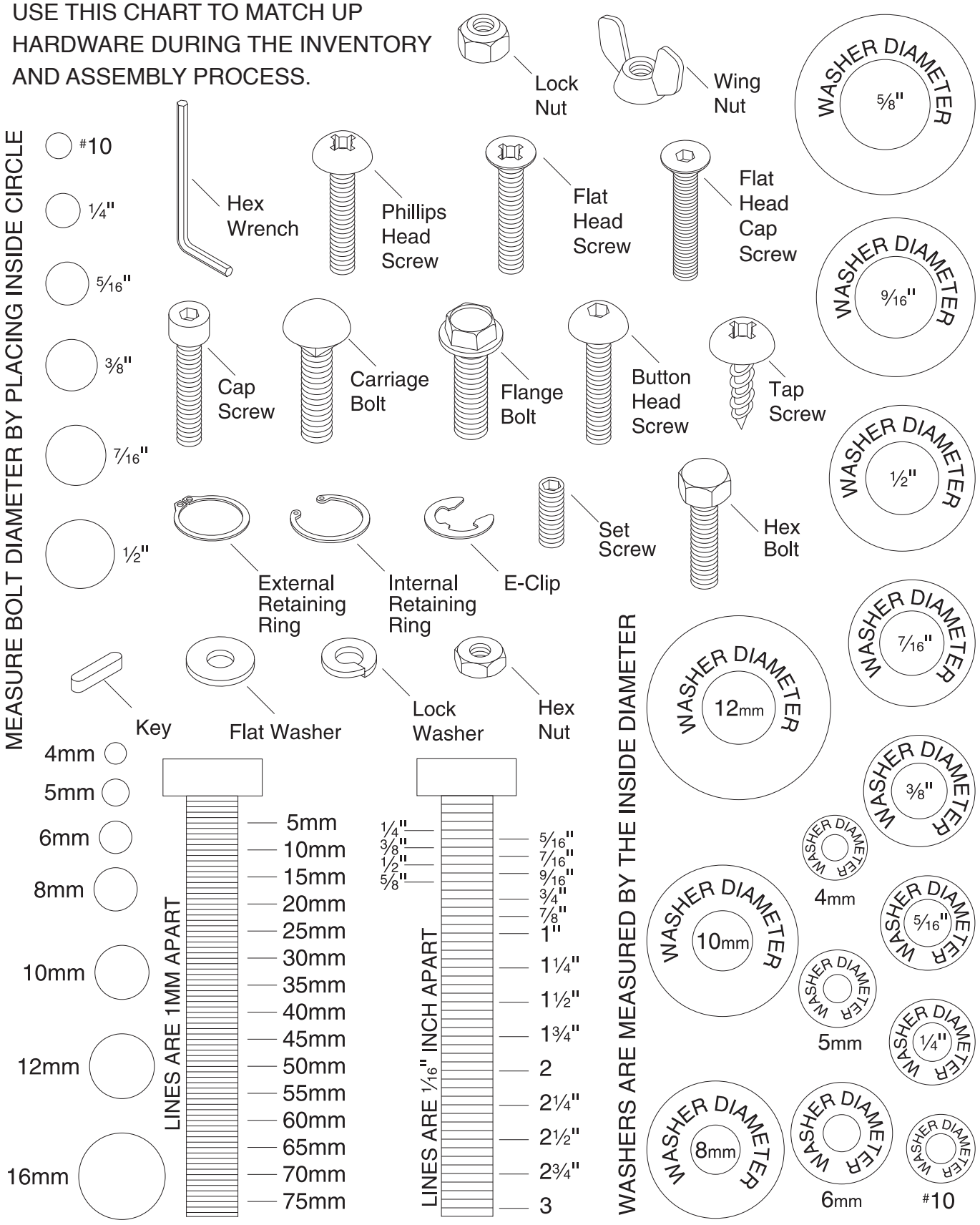


Figure 8. Inventory.

Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE INVENTORY AND ASSEMBLY PROCESS.



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.

NOTICE

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

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.

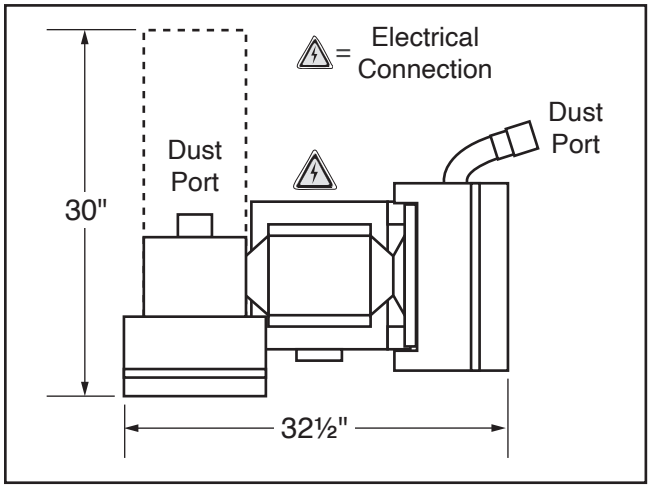
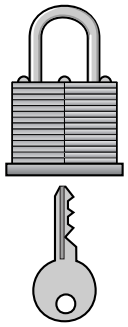


Figure 9. Minimum working clearances.



⚠CAUTION

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

Bench Mounting

Number of Mounting Holes 4
Dia. of Mounting Hardware Needed ..... 7/16"

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

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

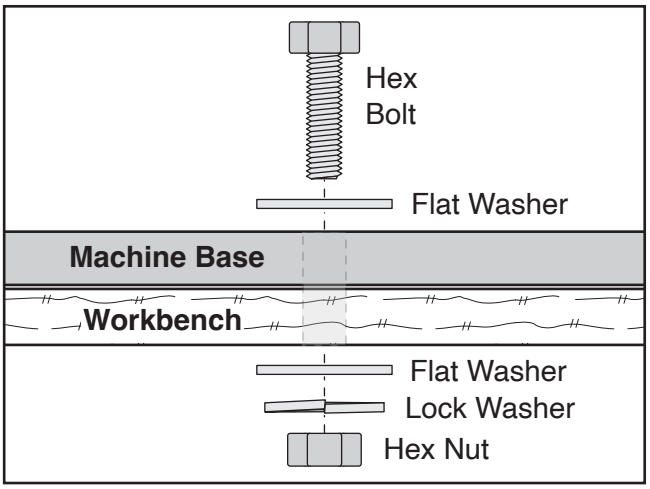


Figure 10. "Through Mount" setup.

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

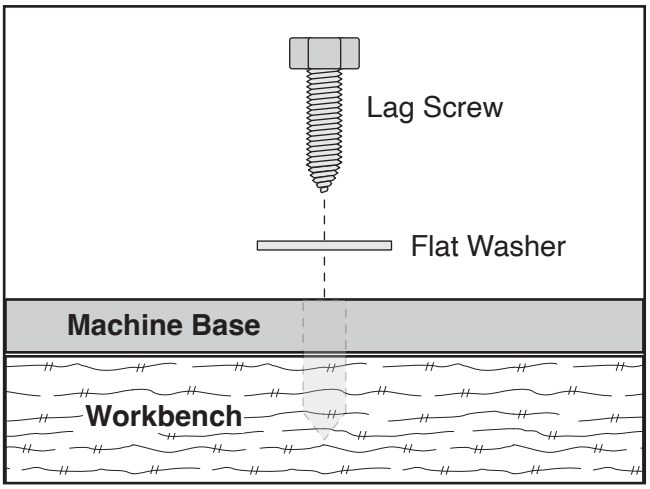


Figure 11. "Direct Mount" setup.

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).

To assemble machine:

1. Remove screw cap and spring on sanding belt table lock handle, remove handle, then remove lock bolt and flat washer from sander (see **Figure 12**).

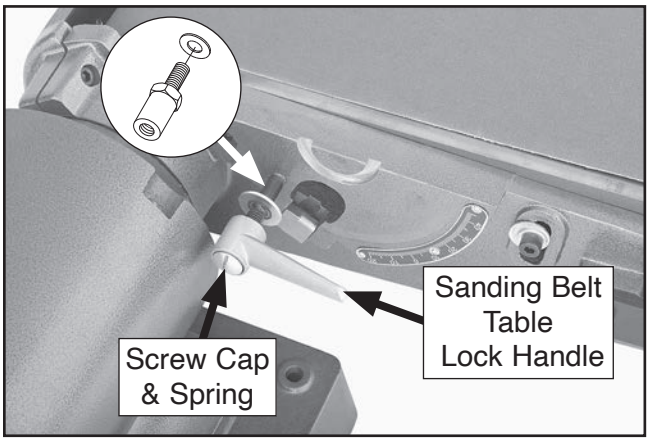


Figure 12. Location of sanding belt table lock handle fasteners.

2. Position sanding belt table mount against side of belt housing so semicircular flange fits in keyway, then secure with flat washer and lock bolt from **Step 1** (see **Figure 13**).

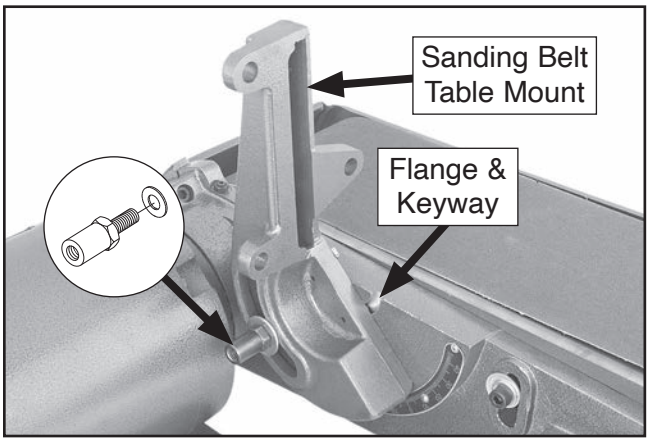


Figure 13. Sanding belt table mount installed.

3. Install sanding belt table lock handle and screw cap.

4. Attach sanding belt table to sanding belt table mount with (3) 5/16"-18 x 1" hex bolts and 5/16" flat washers (see **Figure 14**). Hand tighten bolts for now.

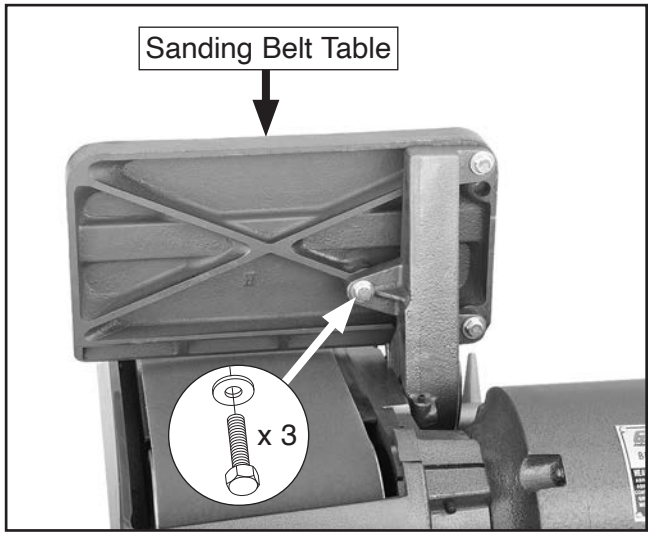


Figure 14. Example of sanding belt table attached to mount.

5. Attach 3" dust port to sanding belt housing with (2) 1/4"-20 x 1/2" Phillips head screws (see **Figure 15**).

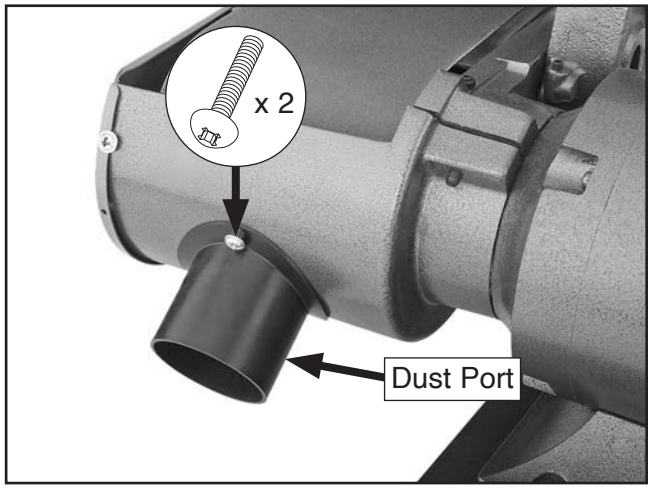


Figure 15. Dust port attached to sanding belt housing.

6. Loosen sanding belt angle lock screw (see **Figure 16**), rotate sanding belt assembly to vertical position, then tighten lock screw to secure.

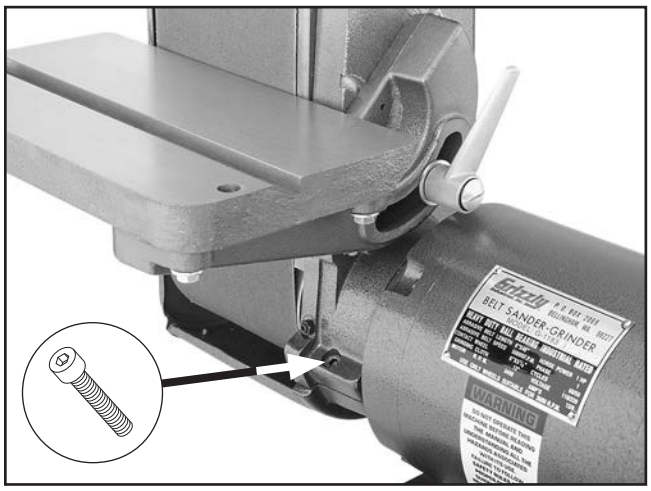


Figure 16. Example of sanding belt assembly rotated to vertical position.

7. Attach dust hose assembly to lower disc guard with (2) 10-24 x 3/8" flange screws (see **Figure 17**).

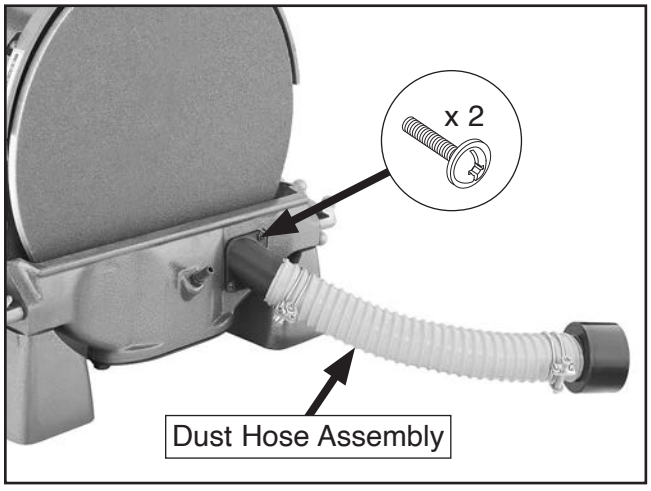


Figure 17. Dust hose assembly attached to lower disc guard.

8. Loosen (2) sanding disc table lock knobs, then move trunnion bracket away from lower disc guard (see **Figure 18**).

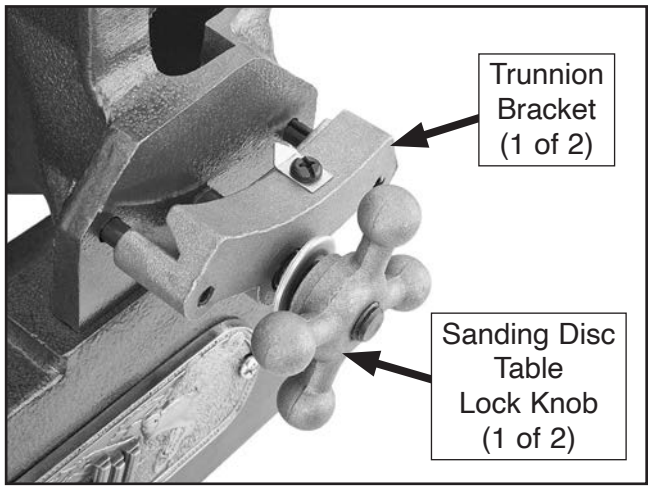


Figure 18. Example of trunnion bracket positioned to receive table trunnion.

9. Place sanding disc table trunnions between trunnion brackets and lower disc guard, as shown in **Figure 19**, then tighten sanding disc table lock knobs to secure.

Figure 19. Example of sanding disc table installed.

10. Refer to **Calibrating Miter Gauge Scale** on **Page 38** to calibrate miter gauge angle pointer.

11. Slide miter gauge into sanding belt table T-slot, and loosen miter gauge knob (see **Figure 20**).

12. Place 90° square against miter gauge and sanding belt (see **Figure 20**).

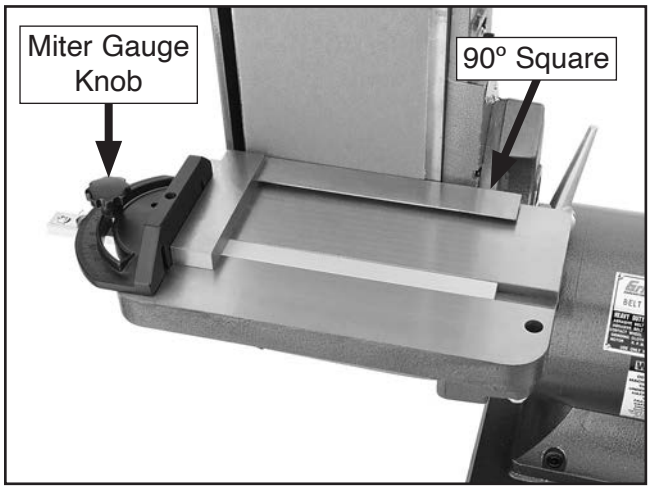


Figure 20. Example of squaring sanding belt table to sanding belt.

— If miter gauge displays 0°, and table is no more than 1/16" away from sanding belt, no adjustment is needed. Fully tighten hex bolts under table.

— If miter gauge *does not* display 0°, or table is more than 1/16" away from sanding belt, adjust table position. When table is square to and within 1/16" of sanding belt, fully tighten hex bolts under table.

13. Slide miter gauge into sanding disc table T-slot.

14. Place 90° square against miter gauge and sanding disc.

— If miter gauge displays 0°, and table is no more than 1/16" away from sanding disc, no adjustment is needed. Proceed to **Step 16**.

— If miter gauge *does not* display 0°, or table is more than 1/16" away from sanding disc, proceed to **Step 15**.

15. Loosen (4) sanding disc table trunnion hex bolts (see **Figure 21**), adjust table position until table is square to and within 1/16" of sanding disc, then tighten bolts.

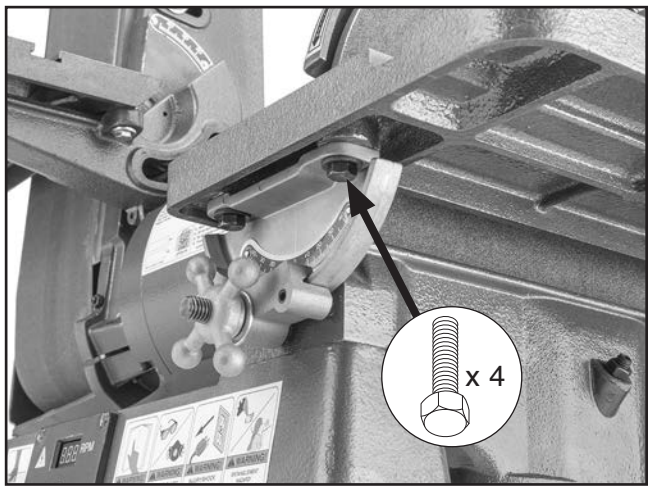


Figure 21. Location of sanding disc table trunnion hex bolts.

16. Thread belt tension lever into tension hub, as shown in **Figure 22**.

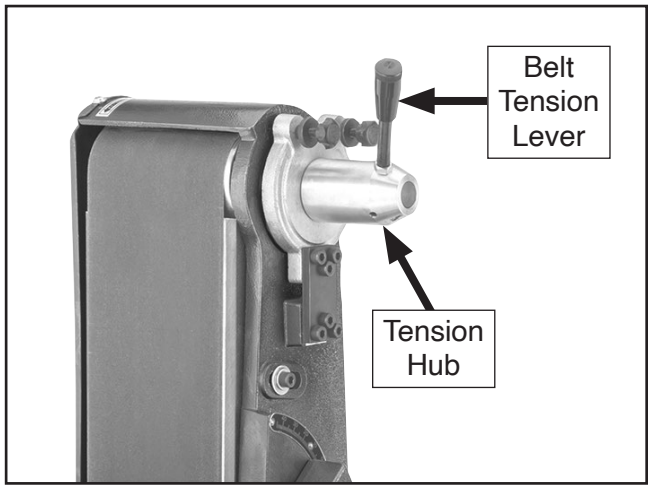


Figure 22. Belt tension lever threaded into tension hub.

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 2½" Dust Port: 150 CFM
Minimum CFM at 3" Dust Port: 250 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:

1. Fit 2½" and 3" dust hoses over dust ports, as shown in **Figure 23**, and secure hoses in place with hose clamps.

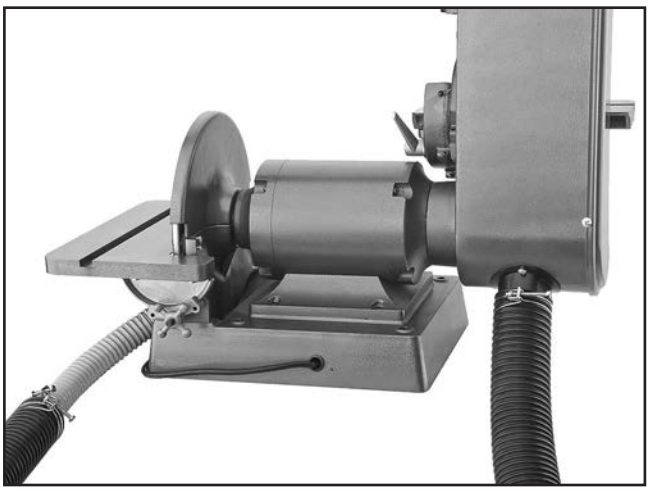


Figure 23. Example of hoses attached to ports.

2. Tug hoses to make sure they do not come off.

Note: *A tight fit is necessary for proper performance.*

Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual, and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly.

NOTICE

The Model G0997 is prewired to operate on either 110V or 220V power. Machine must be connected to power with cord and plug rated for voltage and amperage that matches prepared circuit, or property/machine damage may occur.

Connecting to 110V Power Supply

1. Connect 12AWG power cord with 5-15 plug to receptacle shown in **Figure 24**.

   Note: *Receptacle cover must be moved right to reveal 110V connection receptacle. To move cover right, remove screw shown in **Figure 24**, move cover right, then install screw to secure.*

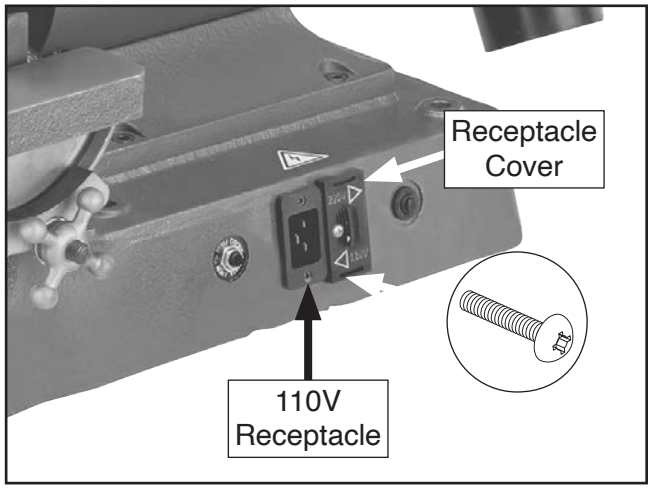


Figure 24. Location of 110V receptacle.

2. Connect power cord plug into 5-15 power supply receptacle.

Connecting to 220V Power Supply

1. Connect 14AWG power cord with 6-15 plug to receptacle shown in **Figure 25**.

   Note: *Receptacle cover must be moved left to reveal red 220V connection receptacle. To move cover left, remove screw shown in **Figure 25**, move cover left, then install screw to secure.*

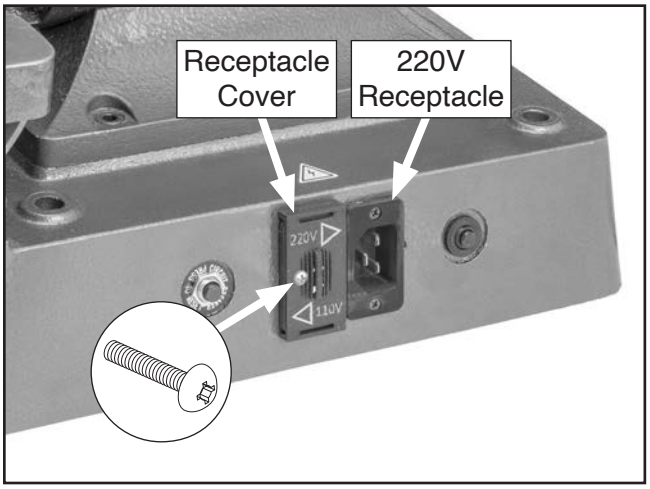


Figure 25. Location of 220V receptacle.

2. Connect power cord plug into 6-15 power supply receptacle.

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 sanding belt tracks properly and will not come off the rollers during initial startup, 2) the motor powers up and runs correctly, and 3) the power controls function 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. DISCONNECT MACHINE FROM POWER!

2. Clear all setup tools away from machine.

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

4. Standing in front of machine, push sanding belt multiple times along platen so it moves in direction of operation (see **Figure 26**), then watch how belt tracks on rollers.

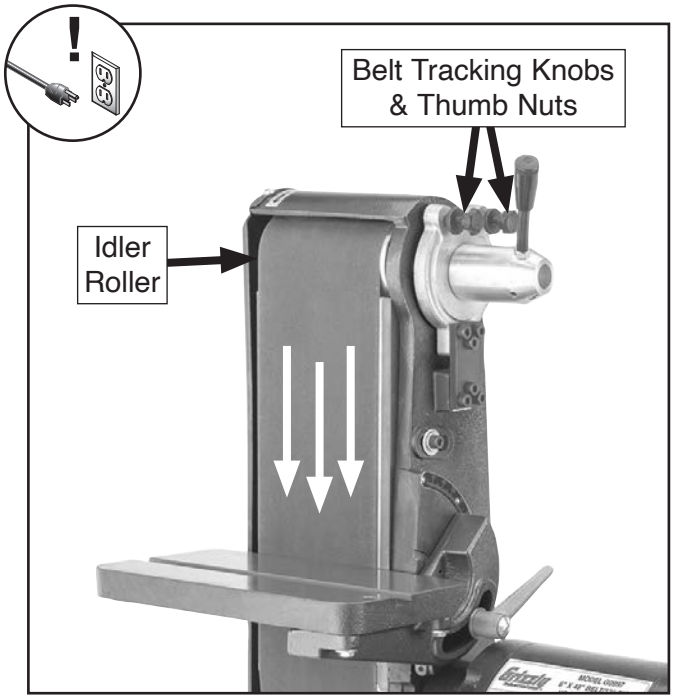


Figure 26. Belt tracking components.

— If belt tracks centered on rollers, proceed to **Step 6**.

— If belt does not track centered on rollers, proceed to **Step 5**.

5. Loosen (2) thumb nuts, then use (2) belt tracking knobs (see **Figure 26**) to adjust belt tracking while continuing to rotate belt by hand to check adjustment.

Note: *This adjustment is a matter of trial-and-error until you attain proper belt tracking, so adjust knobs in small increments. Knobs control tilt of idler (upper) roller to control how belt tracks as it moves around rollers.*

6. Turn speed dial all the way counterclockwise (see **Figure 27**).

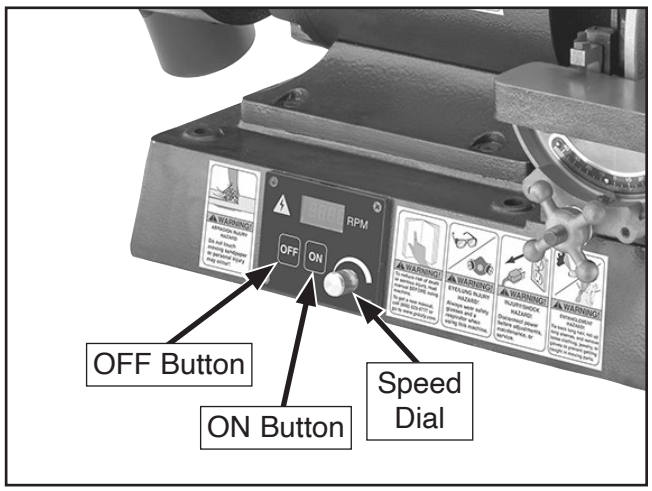


Figure 27. Control panel controls.

7. Connect machine to power.

8. Press ON button (see **Figure 27**), then turn speed dial ¼-turn clockwise to turn machine ***ON***. Verify belt is tracking correctly in center of platen and rollers, and fine-tune tracking with belt tracking knobs as necessary while machine is running.

   Motor should run smoothly and without unusual problems or noises.

9. Press OFF button (see **Figure 27**) to turn machine ***OFF***.

10. DISCONNECT MACHINE FROM POWER!

11. Adjust (2) thumb nuts on belt tracking knobs without moving knobs so they contact frame to secure tracking setting.

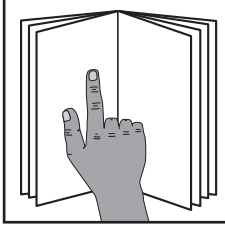
Congratulations! The Test Run is complete.

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.

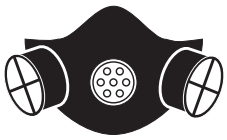


⚠WARNING

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.



NOTICE

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

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

1. Examines workpiece to make sure it is suitable for sanding.
2. Inspects and installs sanding belt/disc with appropriate grit for operation.
3. **For sanding on belt:** Adjusts platen tilt as desired (and table/miter gauge if used).

   For sanding on disc: Adjusts table tilt and/or miter gauge angle as desired.
4. Secures loose clothing, removes loose jewelry, and ties back long hair.
5. Puts on safety glasses and respirator. Takes all other required safety precautions.
6. Starts sander and dust collection system, and adjusts motor speed as desired.
7. Holds workpiece firmly against table and miter gauge (if used), pushes workpiece into sanding belt or along downspin of sanding disc, and moves workpiece back and forth to wear sandpaper evenly and prevent overheating.
8. Stops machine and dust collector.

Sanding Tips

- Extend the life of sandpaper by regularly using PRO-STIK® abrasive belt cleaners (see **Accessories** on **Page 33**).
- 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 belt or disc.
- Sanding discs/belts clog and wear. Change sandpaper whenever you notice a difference in sanding quality/performance.
- To increase the life of the sanding disc/belt and ensure even wear, move the workpiece back and forth across the sanding surface.
- As a rule-of-thumb, sand with progressively higher grit numbers. A higher grit will achieve a finer finish.
- Make sure belt and disc covers are installed and secured during operation.
- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.

⚠CAUTION

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

Choosing Sandpaper

The Model G0997 uses a 6" x 48" sanding belt and a 12" 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 belt and 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 workpiece.*

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 belts/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 belt or disc. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT sand the workpiece.

- ***Wet or "Green" Stock:*** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding belt or 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

Angle sanding is performed with the table tilted away from 0º (perpendicular to the sanding surface). Both the sanding belt table and the sanding disc table can be tilted up and down. Compound angles are sanded using a combination of table tilt and miter gauge angle.

Tilting Sanding Belt Table

The sanding belt table tilts between 20º up and 45º down, and has a flip stop that can be used to engage two adjustable positive stops that are used to quickly return the table to 0º or 45º down (see **Figure 28**).

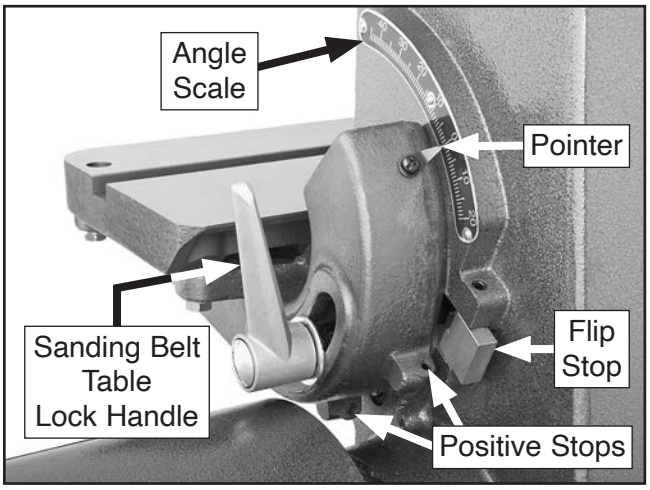


Figure 28. Sanding belt table tilt controls.

To tilt sanding belt table:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen sanding belt table lock handle (see **Figure 28**).

3. Adjust table tilt until desired angle is displayed on scale (see **Figure 28**), then tighten lock handle to secure.

Tilting Sanding Disc Table

The sanding disc table tilts between 30º up and 45º down, has a flip stop that can be used to quickly return the table to 0º, and has a positive stop that stops the table at 45º down (see **Figures 29–30**).

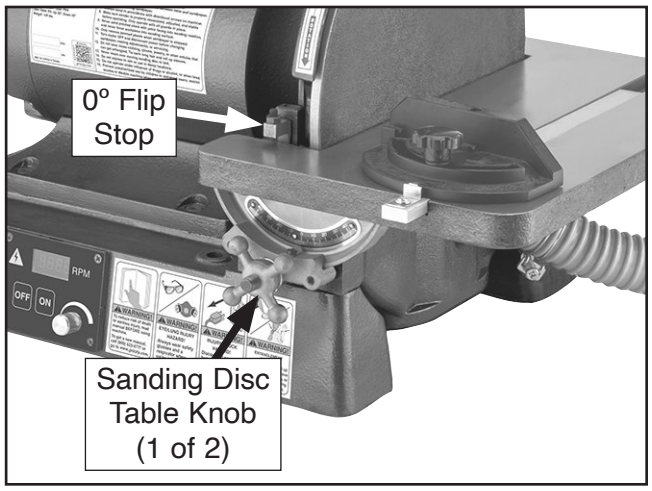


Figure 29. Sanding disc table main tilt controls.

Figure 30. Sanding disc table 45º down positive stop.

To tilt sanding disc table:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen (2) sanding disc table lock knobs (see **Figure 29**).
3. Adjust table tilt until desired angle is displayed on scale (see **Figure 29**), then tighten lock knobs to secure.

Adjusting Miter Gauge

The miter gauge angle can be adjusted 60º to the right or the left, keeping angled workpieces accurate.

To adjust miter gauge:

1. Loosen miter gauge knob (see **Figure 31**), adjust angle, then tighten knob to secure.

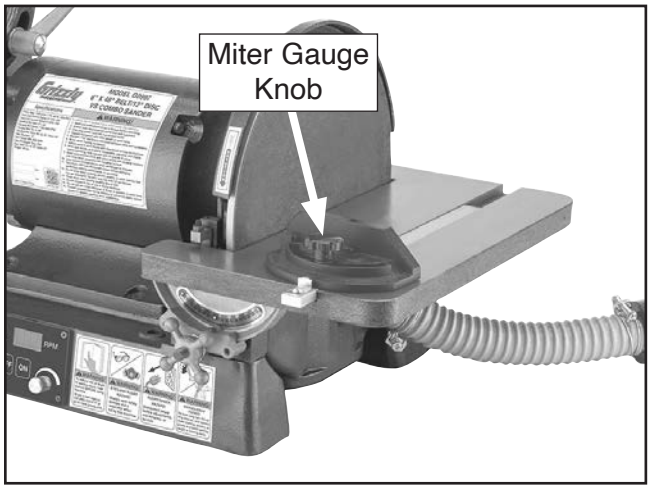


Figure 31. Location of miter gauge knob.

Adjusting Platen Tilt

The Model G0997 platen can be positioned from 0º–90º, depending on your operation (see **Figure 32**).

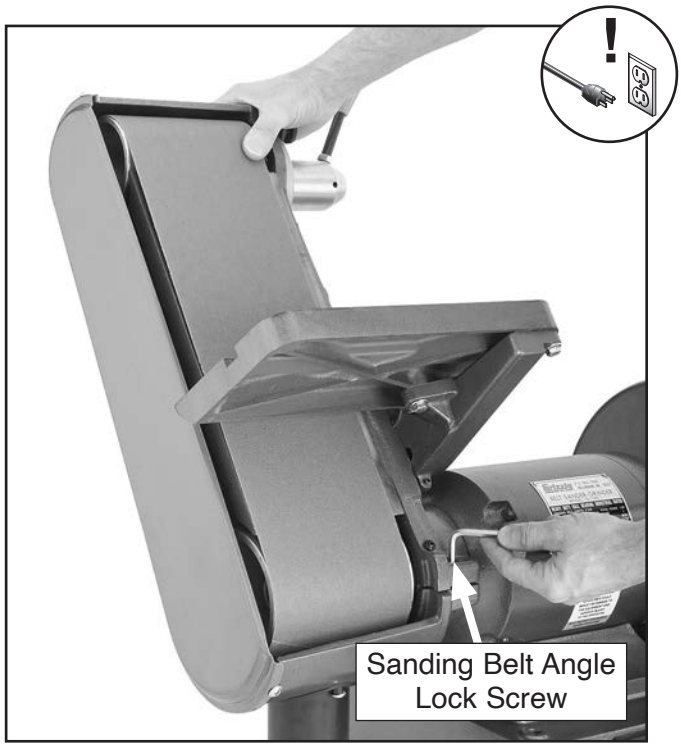


Figure 32. Example of adjusting platen tilt.

Tools Needed	Qty
Hex Wrench 6mm	1

To adjust platen tilt:

1. DISCONNECT MACHINE FROM POWER!

2. While supporting platen body, loosen sanding belt angle lock screw (see **Figure 32**). Adjust platen angle as desired, then tighten lock screw to secure.

Changing Sanding Disc

The Model G0997 accepts 12" diameter PSA (pressure-sensitive adhesive) sanding discs. Use the following steps to change the sanding disc when a disc wears out or your operation requires a different grit size.

Items Needed	Qty
Cleaner/Degreaser	As Needed
Disposable Rags	As Needed

To change sanding disc:

1. DISCONNECT MACHINE FROM POWER!

2. Peel off old sanding disc, clean aluminum disc surface with cleaner/degreaser, and allow disc to dry.

3. Peel protective backing halfway off of new disc and fold it against remaining half.

4. Slip half with protective backing between disc and table edge, as shown in **Figure 33**.

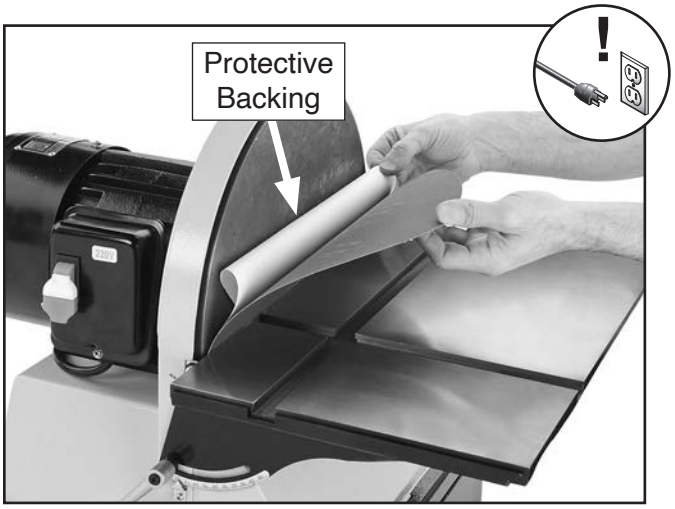


Figure 33. Example of installing sandpaper disc.

5. Position exposed adhesive evenly across upper half of aluminum disc that extends above table, then press adhesive onto disc.

6. Rotate disc so lower half is above table. Peel off other half of protective backing, then press remaining sandpaper against disc.

Disc Sanding

The sanding disc can be used to create flat, smooth ends and edges of workpieces.

⚠CAUTION

Always keep workpiece on left side of disc that rotates down toward table. This will keep workpiece from flying out of hands due to kickback.

⚠CAUTION

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

To sand on disc:

1. Adjust table and miter gauge (if using) to desired angles for operation.

2. Connect machine to power, turn it ***ON***, and set motor to desired speed.

3. Place workpiece on table and firmly against miter gauge (if using).

4. With light pressure, slowly move workpiece into left side of sanding disc. See **Figures 34–37** for examples of disc sanding.

Figure 34. Example of 90° disc sanding.

Figure 35. Example of miter sanding.

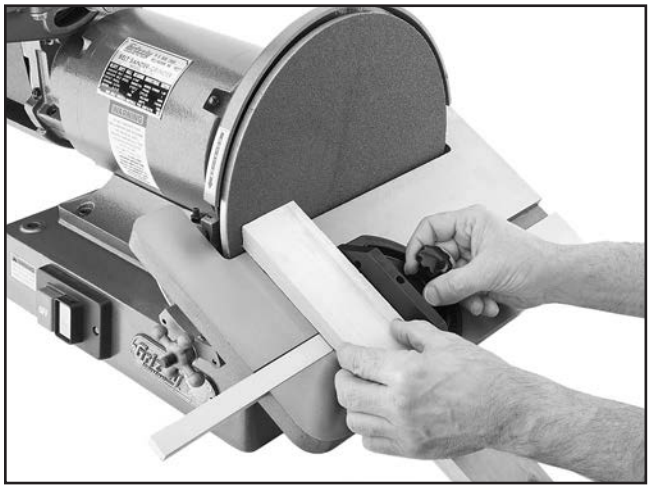


Figure 36. Example of bevel sanding.

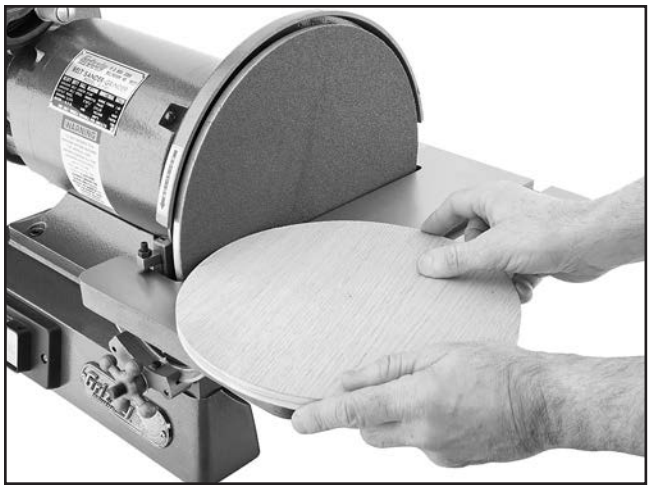


Figure 37. Example of sanding round workpiece.

Changing Sanding Belt

The Model G0997 accepts 6" x 48" sanding belts.

Some sanding belts are designed to sand in only one direction and will have a direction indicated on the back of the belt. The Model G0997 is designed so the sanding belt travels clockwise when viewed from the left side.

Tool Needed **Qty**
Phillips Head Screwdriver #2 1

To change sanding belt:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen (4) belt cover screws shown in **Figure 38**, then remove belt cover.

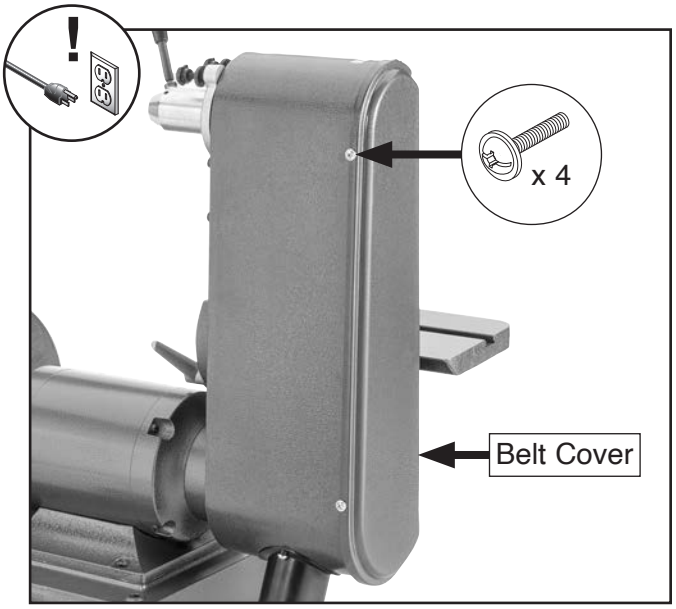


Figure 38. Location of belt cover and securing screws.

3. Move belt tension lever down, towards table (see **Figure 39**), to lower idler roller enough so you can slide sanding belt off of rollers.

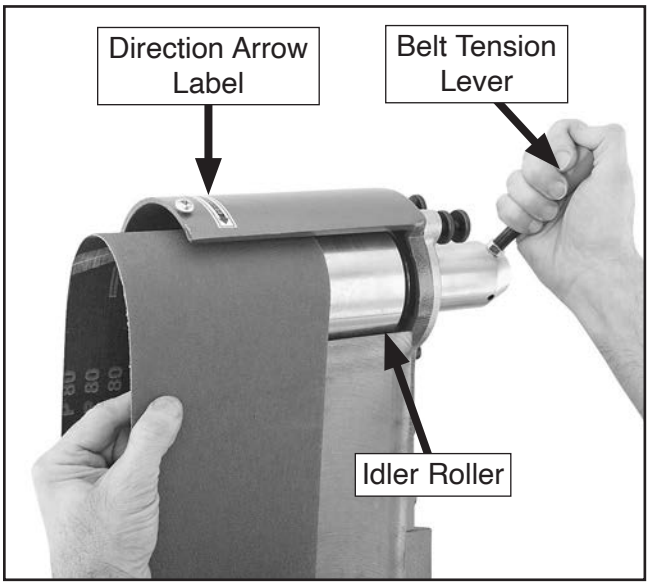


Figure 39. Moving belt tension lever down to remove sanding belt.

4. While holding belt tension lever down, center new belt on rollers, then release lever.

Note: *Typically, sanding belts have a direction arrow printed on inside. Match arrow direction with direction arrow on top of sanding belt housing (see **Figure 39**).*

5. Install belt cover, and tighten belt cover screws.

6. Adjust belt tracking (see **Checking/Adjusting Belt Tracking** on **Page 31**).

Checking/Adjusting Belt Tracking

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

You must perform the following procedure after installing a sanding belt to ensure the belt does not come off the rollers or get jammed against the machine frame.

To check/adjust belt tracking:

1. DISCONNECT MACHINE FROM POWER!

2. Standing in front of machine, push sanding belt multiple times along platen so it moves in direction of operation (see **Figure 40**), then watch how belt tracks on rollers.

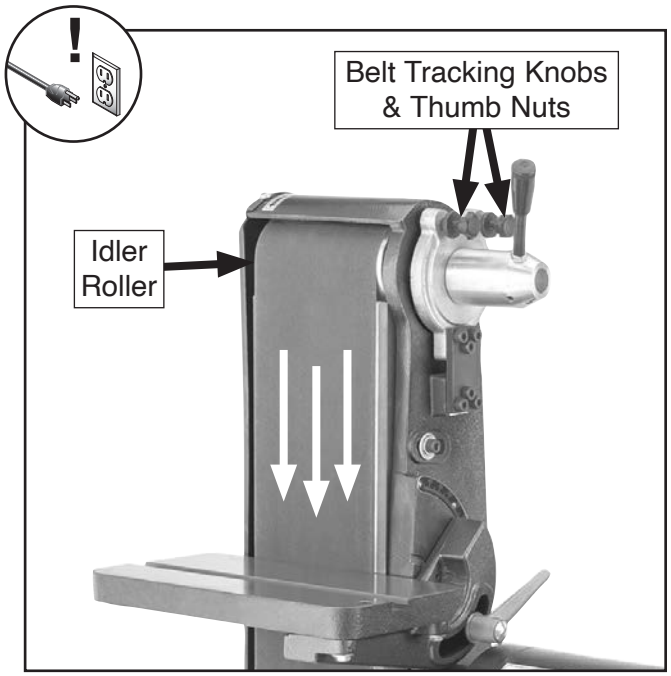


Figure 40. Belt tracking components.

   — If belt tracks centered on rollers, proceed to **Step 4**.

   — If belt *does not* track centered on rollers, proceed to **Step 3**.

3. Loosen (2) thumb nuts, then use (2) belt tracking knobs (see **Figure 40**) to adjust belt tracking while continuing to rotate belt by hand to check adjustment.

   Note: *This adjustment is a matter of trial-and-error until you attain proper belt tracking, so adjust knobs in small increments. Knobs control tilt of idler (upper) roller to control how belt tracks as it moves around rollers.*

4. Turn speed dial all the way counterclockwise.

5. Connect machine to power.

6. Turn machine ***ON*** to verify belt is tracking correctly in center of platen and rollers, and fine-tune tracking with belt tracking knobs as necessary while machine is running.

7. Turn machine ***OFF***.

8. DISCONNECT MACHINE FROM POWER!

9. Adjust (2) thumb nuts on belt tracking knobs without moving knobs so they contact frame to secure tracking setting.

Belt Sanding

The sanding belt removes material faster than the sanding disc, and it can be secured at any angle from horizontal to completely vertical.

⚠CAUTION

Always sand with workpiece supported by table. Relying on only hands to support workpiece increases risk of workpiece "kick-out" and impact/abrasion injuries.

⚠CAUTION

To reduce risk of fingers or workpiece getting trapped between table and sanding belt, table must be within 1/16" of belt.

To sand on belt:

1. Adjust platen, table, and miter gauge (if using) to desired angles for operation.

2. Connect machine to power, turn it ***ON***, and set motor to desired speed.

3. Place workpiece on table and firmly against miter gauge (if using).

4. With light pressure, slowly move workpiece into belt. Maintain control of workpiece, as shown in **Figures 41–44**. DO NOT force workpiece against belt.

Figure 41. Example of face sanding with platen in horizontal position.

Figure 42. Example of face sanding with platen in vertical position.

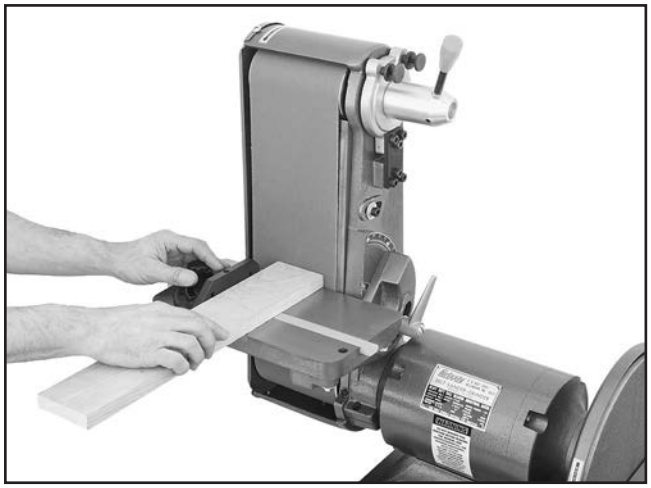


Figure 43. Example of end grain sanding.

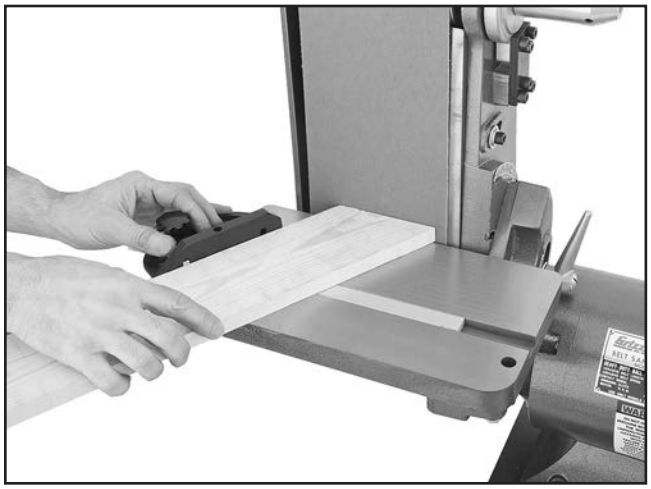


Figure 44. Example of miter sanding.

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 12" Sanding Discs

These tough, aluminum oxide sanding discs come in a variety of grits to fit the Model G0997. These sanding discs are pre-applied with top-quality pressure-sensitive adhesive.

D1335—60-Grit, 2-Pk.
D1336—80-Grit, 2-Pk.
D1337—100-Grit, 2-Pk.
D1338—120-Grit, 2-Pk.
D1339—150-Grit, 2-Pk.
D1340—180-Grit, 2-Pk.
D1341—220-Grit, 2-Pk.

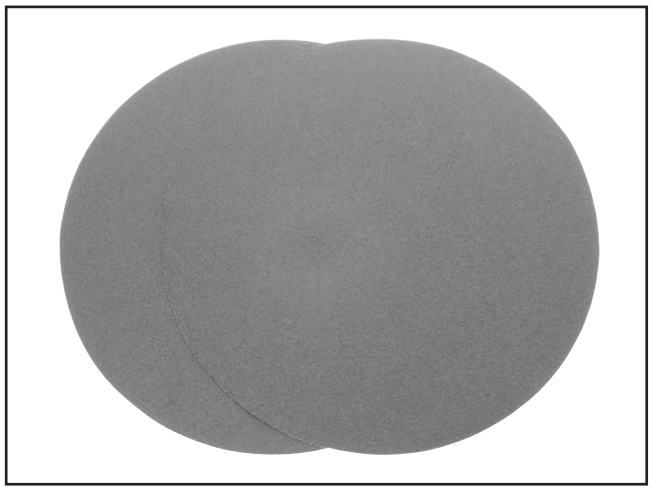


Figure 45. Replacement sanding discs.

PRO-STIK® Abrasive Surface Cleaners

Extend the life of your abrasive belts and discs!

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

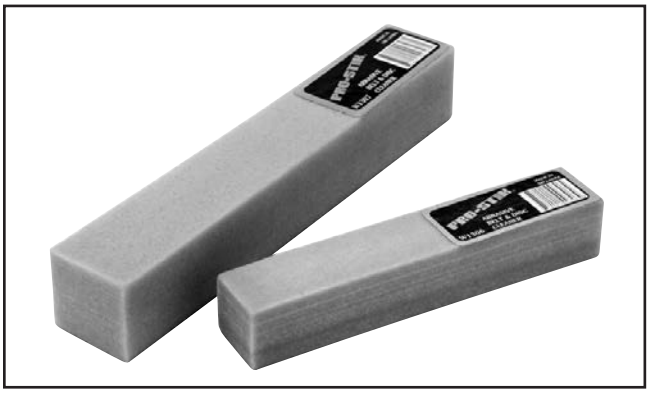


Figure 46. PRO-STIK® abrasive cleaners.

Grizzly 6" x 48" Sanding Belts

These tough, aluminum oxide sanding belts come in a variety of grits to fit the Model G0997.

D1256—60-Grit, 2-Pk.
D1257—80-Grit, 2-Pk.
D1258—100-Grit, 2-Pk.
D1259—120-Grit, 2-Pk.
D1260—150-Grit, 2-Pk.
D1261—180-Grit, 2-Pk.
D1262—220-Grit, 2-Pk.

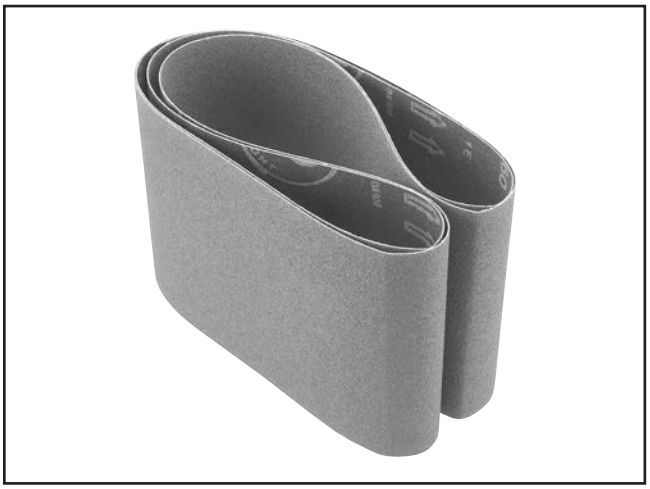
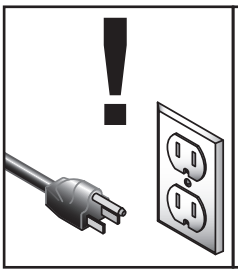


Figure 47. Replacement sanding belts.

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, excessively worn, or clogged sanding belt or disc.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance
- Clean any shavings and dust from between platen and sanding belt.
- Sweep surrounding dust and shavings.
- Clean/protect tables.

Monthly Check
- Clean/vacuum dust buildup from inside sanding belt housing and sanding disc lower guard.

Cleaning & Protecting

Cleaning the Model G0997 is relatively easy. Vacuum excess 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 tables by wiping them clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the tables rust-free with regular applications of a quality metal protectant.

Cleaning Sanding Belt/Disc

When a sandpaper surface becomes clogged with resin or gummy sawdust, the efficiency of the sanding operation is significantly reduced and can leave glazed or gouge marks in the workpiece. Using an abrasive belt/disc cleaner can prolong the life of a clogged sanding belt/disc, provided it is otherwise in good condition. See **Accessories** on **Page 33** for more details.

To clean sanding belt/disc:

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

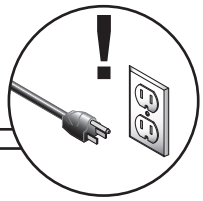
2. Using table as support, rub abrasive cleaner on sanding belt/disc in continuous motion, covering entire surface of belt/disc until belt/disc is no longer clogged.

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. Machine circuit breaker tripped. 2. Incorrect power supply voltage or circuit size. 3. Potentiometer at fault. 4. Power supply circuit breaker tripped or fuse blown. 5. Wiring broken, disconnected, or corroded. 6. Circuit breakers switch at fault. 7. Circuit board at fault. 8. Motor or motor bearings at fault.	1. Reset circuit breaker reset button (**Page 4**). 2. Ensure correct power supply voltage and circuit size (**Page 11**). 3. Test/replace if at fault. 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Fix broken wires or disconnected/corroded connections (**Page 42**). 6. Replace circuit breaker switch. 7. Inspect/replace if at fault. 8. Replace motor.
Machine stalls or is underpowered.	1. Workpiece material unsuitable for machine. 2. Machine undersized for task. 3. Motor overheated, tripping machine circuit breaker. 4. Extension cord too long. 5. Motor or motor bearings at fault.	1. Only sand wood/ensure moisture is below 20% (**Page 26**). 2. Clean (**Page 34**)/replace (**Page 28**, **Page 30**) sandpaper; reduce feed rate/sanding depth. 3. Clean motor, let cool, and reduce workload. Reset circuit breaker reset button (**Page 4**). 4. Move machine closer to power supply; use shorter extension cord (**Page 12**). 5. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Incorrectly mounted to workbench. 3. Aluminum sanding disc out of balance or loose. 4. Motor fan rubbing on motor cover. 5. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Shim or tighten mounting hardware (**Page 17**). 3. Tighten disc hub set screws or replace disc. 4. Fix/replace motor cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Digital readout does not work/ display is incorrect.	1. Wiring broken, disconnected, or corroded. 2. Circuit board at fault.	1. Fix broken wires or disconnected/corroded connections (**Page 42**). 2. Inspect/replace if at fault.

Operation

Symptom	Possible Cause	Possible Solution
Sanding belt will not track properly.	1. Sanding belt is stretched, unevenly worn, or damaged. 2. Roller shaft is worn or damaged.	1. Replace sanding belt (**Page 30**). 2. Replace roller shaft.
Sanding belt slips during use.	1. Excessive workpiece pressure.	1. Reduce workpiece pressure.
Belts/discs clog quickly or excessive belt/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 belt/disc.	1. Decrease sanding speed. 2. Reduce workpiece pressure. 3. Use coarser grit sandpaper (**Page 25**). 4. Use different stock or accept characteristics of workpiece and plan on cleaning (**Page 34**)/replacing (**Page 28**, **Page 30**) sanding belt/disc frequently. 5. Dry workpiece properly before sanding (**Page 26**); use different stock or accept characteristics of workpiece and plan on cleaning (**Page 34**)/replacing (**Page 28**, **Page 30**) belt/disc frequently. 6. Position workpiece to use different locations to use full width of sanding surface; move workpiece back and forth across sanding surface if the operation allows. 7. Replace sanding belt (**Page 30**)/disc (**Page 28**).
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 sanding surface.	1. Decrease sanding speed. 2. Sand workpiece with grain. 3. Reduce workpiece pressure. 4. Use finer grit sandpaper (**Page 25**). 5. Position workpiece to use different locations to use full width of sanding surface; move workpiece back and forth across sanding surface if the operation allows.
Burn marks on workpiece.	1. Excessive sanding speed. 2. Excessive workpiece pressure. 3. Using too fine of sanding grit. 4. Workpiece held still against sanding surface. 5. Sanding belt/disc loaded with sawdust, resin, and/or pitch.	1. Decrease sanding speed. 2. Reduce workpiece pressure. 3. Use coarser grit sandpaper (**Page 25**). 4. Position workpiece to use different locations to use full width of sanding surface; move workpiece back and forth across sanding surface if the operation allows. 5. Clean (**Page 34**)/replace (**Page 28**, **Page 30**) sanding belt/disc.
Sanding belt slaps or vibrates excessively.	1. Sanding belt tracking needs adjustment. 2. Sanding belt is stretched, unevenly worn, or damaged. 3. Sanding belt roller is loose. 4. Weak or broken tension spring.	1. Adjust sanding belt tracking (**Page 31**). 2. Replace sanding belt (**Page 30**). 3. Tighten sanding belt roller. 4. Replace spring.
Snake-shaped marks on workpiece.	1. Sanding belt/disc dirty/damaged.	1. Clean (**Page 34**)/replace (**Page 28**, **Page 30**) sanding belt/disc.
Glazed sanding surfaces.	1. Sanding wet stock; workpiece has high sap content. 2. Sanding belt/disc worn or filled with pitch residue.	1. Dry workpiece properly before sanding (**Page 26**); use different stock or accept characteristics of workpiece and plan on cleaning (**Page 34**)/replacing (**Page 28**, **Page 30**) belt/disc frequently. 2. Replace sanding belt (**Page 30**)/disc (**Page 28**).

Operation

Symptom	Possible Cause	Possible Solution
Poor, non-aggressive sanding results.	1. Using too fine of sanding grit. 2. Sanding belt/disc loaded with sawdust, resin, and/or pitch. 3. Platen is not adjusted correctly to idler roller.	1. Use coarser grit sandpaper (**Page 25**). 2. Clean (**Page 34**)/replace (**Page 28**, **Page 30**) sanding belt/disc. 3. Adjust platen correctly to idler roller (**Page 41**).
Abrasive grit rubs off sanding belt/disc easily.	1. Sanding belt/disc has been stored in an incorrect environment. 2. Sanding belt/disc has been folded or crushed.	1. Replace sanding belt (**Page 30**)/disc (**Page 28**). Store belt/disc in a cool, dry area. 2. Replace sanding belt (**Page 30**)/disc (**Page 28**). Store disc/belt flat, not folded or bent.
Workpiece not sanded square on platen when table tilt is set to 0º.	1. Table is not perpendicular to sanding belt.	1. Ensure platen is correctly adjusted to idler roller (**Page 41**), then calibrate table tilt (**Page 38**).
Workpiece not sanded square on disc when table tilt is set to 0º.	1. Table is not perpendicular to sanding disc.	1. Calibrate table tilt (**Page 38**).
Sanded workpiece angle does not match miter gauge setting.	1. Miter gauge body is not perpendicular to miter gauge bar when pointer points to 0º. 2. Table is not square to sanding surface.	1. Calibrate miter gauge scale (**Page 38**). 2. Adjust table square to sanding surface as described in Assembly (**Page 17**).
Workpiece gets frequently pulled out of your hands.	1. Not supporting workpiece properly.	1. Use table, miter gauge, or other support fixture to support workpiece.

Calibrating Miter Gauge Scale

Calibrate the miter gauge scale if workpieces are not square when being sanded at 90º while using the miter gauge.

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

To calibrate miter gauge scale:

1. Loosen miter gauge knob and adjust miter gauge until pointer points at 0º (see **Figure 48**), then tighten knob.

2. Use 90º square to check if miter bar is square to miter gauge body (see **Figure 48**).

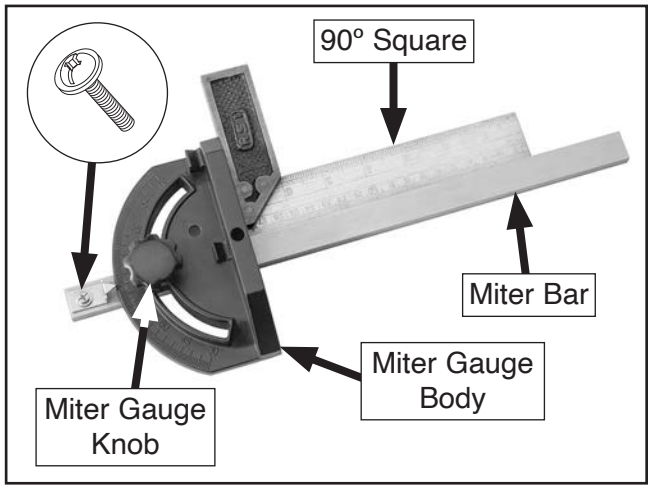


Figure 48. Using 90º square to check miter gauge pointer accuracy.

   — If bar *is* square to miter gauge body when pointer points at 0º, no adjustment is required.

   — If bar *is not* square to miter gauge body when pointer points to 0º, proceed to **Step 3**.

3. Loosen pointer screw (see **Figure 48**), adjust pointer to point to 0º when miter bar is square to miter gauge body, then tighten screw to secure.

Calibrating Table Tilt

Calibrate the table tilt and angle stops if finished workpiece angles do not match what is indicated by the angle pointer of the sanding surface you are using.

Calibrating Sanding Belt Table

Tools Needed	Qty
Square 90º	1
Phillips Head Screwdriver #2	1
Hex Wrench 3mm	1

To calibrate sanding belt table tilt:

1. DISCONNECT MACHINE FROM POWER!

2. Place 90º square on sanding belt table, loosen sanding belt table lock handle, and adjust table until it is square to sanding belt (see **Figure 49**).

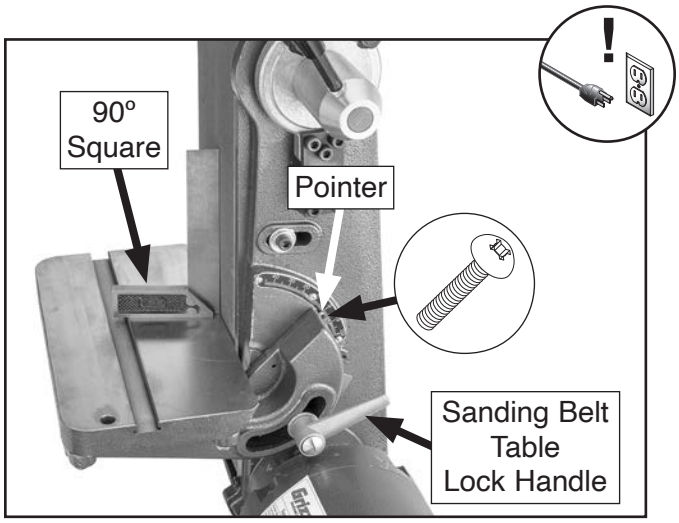


Figure 49. Squaring table to sanding belt.

   — If angle pointer points to 0º when table is square to belt, no adjustment is required. Proceed to **Step 4**.

   — If angle pointer *does not* point to 0º when table is square to belt, proceed to **Step 3**.

3. Loosen pointer screw (see **Figure 49**), adjust pointer to point to 0º when table is square to belt, then tighten screw to secure.

4. Adjust table down so pointer points between 35º–45º down, engage flip stop, then lift table until flip stop contacts 45º stop screw (see **Figure 50**).

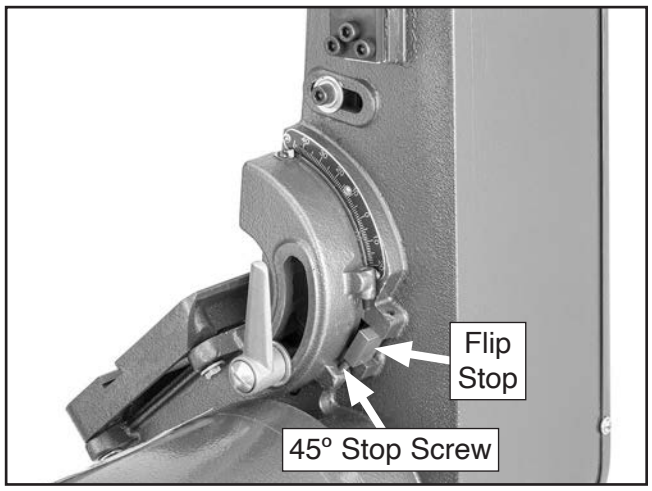


Figure 50. Flip stop engaging 45º stop screw.

— If angle pointer points to 45º when flip stop engages 45º stop screw, no adjustment is required. Proceed to **Step 6**.

— If angle pointer *does not* point to 45º when flip stop engages 45º stop screw, proceed to **Step 5**.

5. Adjust 45º stop screw until flip stop engages screw when angle pointer points to 45º.

6. Disengage flip stop, then adjust table all the way up so pointer points at 20º up.

7. Engage flip stop, then lower table until flip stop contacts 0º stop screw (see **Figure 51**).

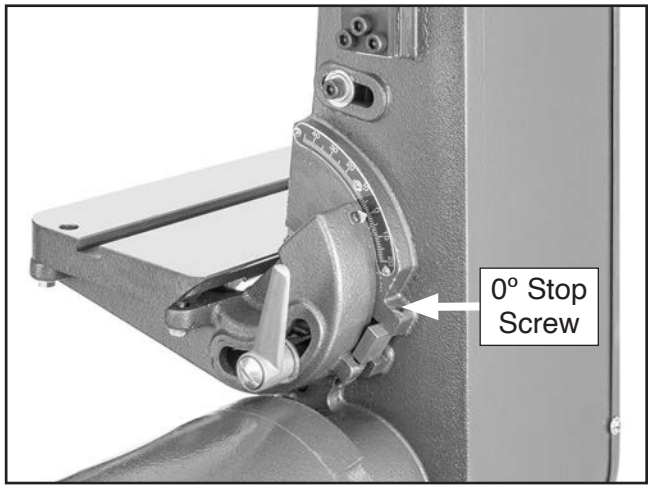


Figure 51. Flip stop engaging 0º stop screw.

— If angle pointer points to 0º when flip stop engages 0º stop screw, no adjustment is required. Proceed to **Step 9**.

— If angle pointer *does not* point to 0º when flip stop engages 0º stop screw, proceed to **Step 8**.

8. Adjust 0º stop screw until flop stop engages screw when angle pointer points to 0º.

Note: *You will need to move flip stop to adjust screw. Make small adjustment, then repeat* ***Step 7****.*

9. Tighten sanding belt table lock handle.

Calibrating Sanding Disc Table

Tools Needed	**Qty**
Square 90º	1
Phillips Head Screwdriver #2	1
Hex Wrenches 3, 4mm	1 Ea.
Wrenches 10, 12mm	1 Ea.

To calibrate sanding disc table tilt:

1. DISCONNECT MACHINE FROM POWER!

2. Place 90º square on sanding disc table, loosen (2) sanding disc table lock knobs, and adjust table until it is square to sanding disc (see **Figure 52**).

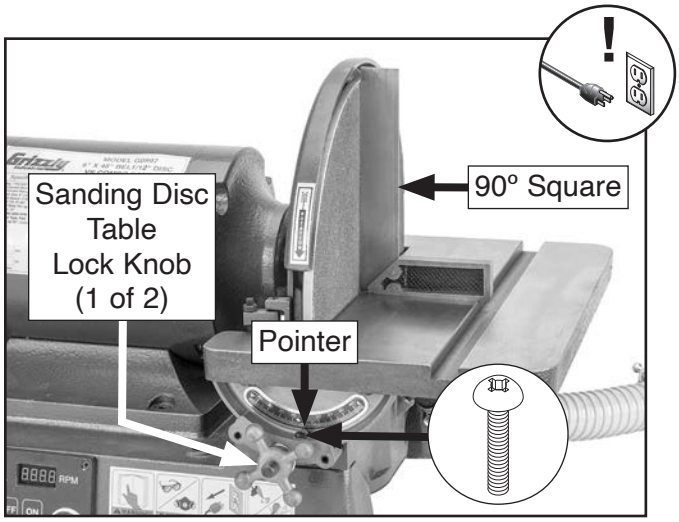


Figure 52. Squaring table to sanding disc.

— If angle pointer points to 0º when table is square to disc, no adjustment is required. Proceed to **Step 4**.

— If angle pointer *does not* point to 0º when table is square to disc, proceed to **Step 3**.

3. Loosen pointer screw (see **Figure 52** on **Page 39**), adjust pointer to point to 0º when table is square to disc, then tighten screw to secure.

4. Adjust table down until table contacts 45º stop screw (see **Figure 53**).

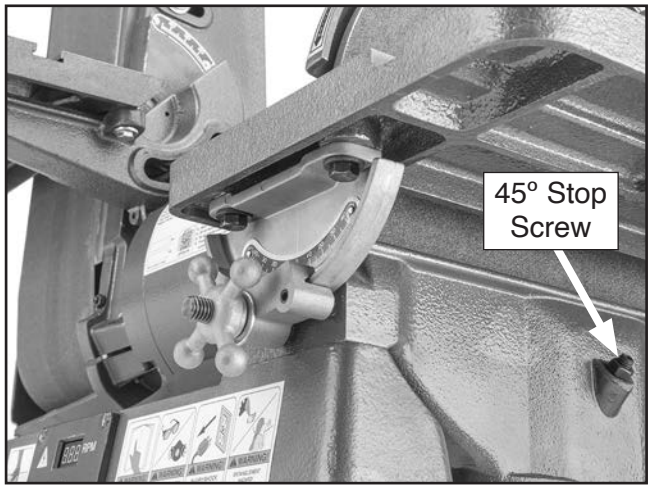


Figure 53. Location of 45º stop screw.

— If angle pointer points to 45º when table engages 45º stop screw, no adjustment is required. Proceed to **Step 6**.

— If angle pointer *does not* point to 45º when table engages 45º stop screw, proceed to **Step 5**.

5. Loosen jam nut, adjust 45º stop screw until table engages screw when angle pointer points to 45º, then tighten jam nut without moving screw to secure adjustment.

Note: *You will need to move table to adjust screw. Make small adjustment, then repeat* ***Step 4****.*

6. Adjust table all the way up so pointer points at 45º up.

7. Engage flip stop, then lower table until flip stop contacts 0º stop screw (see **Figure 54**).

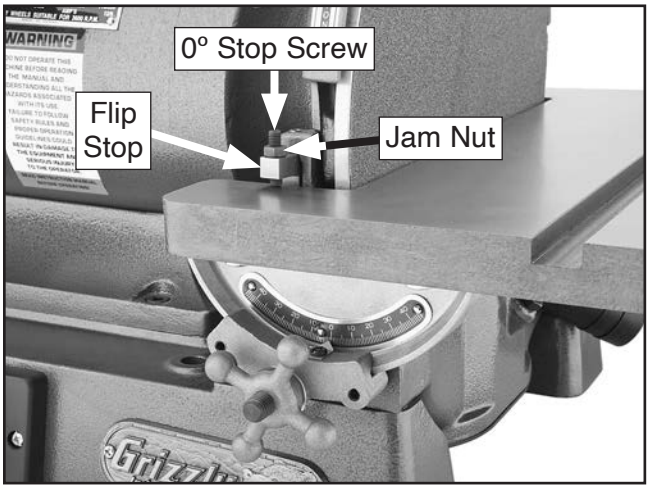


Figure 54. Example of flip stop engaging 0º stop screw.

— If angle pointer points to 0º when flip stop engages 0º stop screw, no adjustment is required. Proceed to **Step 10**.

— If angle pointer *does not* point to 0º when flip stop engages 0º stop screw, proceed to **Step 8**.

8. Loosen jam nut, then adjust 0º stop screw until flip stop engages screw when angle pointer points to 0º.

9. Tighten jam nut without moving screw to secure adjustment.

10. Tighten sanding disc table lock knobs.

Adjusting Platen to Idler Roller

The platen should be even with the idler roller crown in order to produce flat and square edges. Due to the force and abrasives of sanding, the platen wears as its used, so you will occasionally need to adjust the platen forward in order to maintain this adjustment.

Tools Needed	Qty
Phillips Head Screwdriver #2	1
Flat Head Screwdriver ¼"	1
Hex Wrench 6mm	1
Wrench or Socket 17mm	1
Straightedge 12"	1

To adjust platen to rollers:

1. DISCONNECT MACHINE FROM POWER!

2. Remove sanding belt.

3. Adjust platen tilt so platen is horizontal.

4. Remove (3) hex bolts and flat washers shown in **Figure 55** in order to remove sanding belt table from sanding belt table mount.

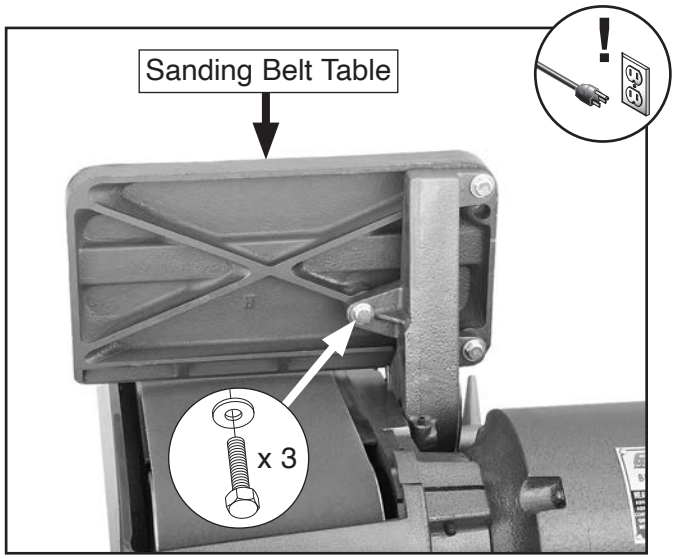


Figure 55. Location of sanding belt table hex bolts and flat washers.

5. Place straightedge over platen and idler roller, aligning straightedge with middle of roller (crown at highest point), as shown in **Figure 56**.

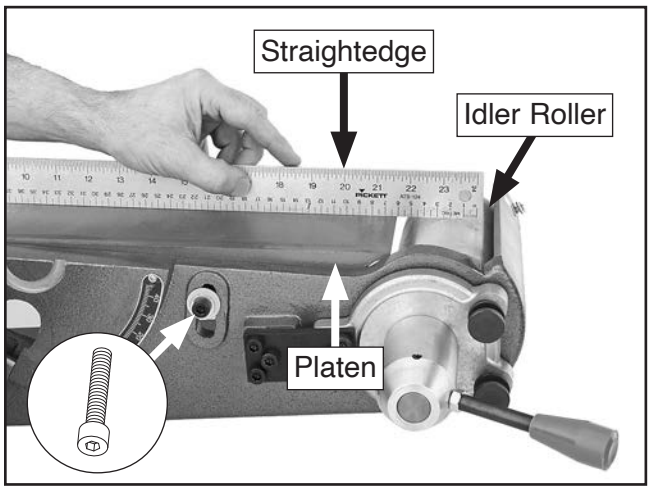


Figure 56. Example of comparing platen height with idler roller crown height.

— If platen *is* even with middle of idler roller, no adjustment is necessary. Proceed to **Step 7**.

— If platen *is not* even with middle of idler roller, proceed to **Step 6**.

6. Loosen cap screw shown in **Figure 56**, adjust platen until it is even with middle of idler roller, then tighten cap screw to secure.

7. Install sanding belt and refer to **Checking/ Adjusting Belt Tracking** on **Page 31** to track belt.

8. Install sanding belt table with fasteners removed in **Step 4**. Hand tighten bolts for now.

9. Perform **Steps 10–12** of **Assembly** section starting on **Page 17**.

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

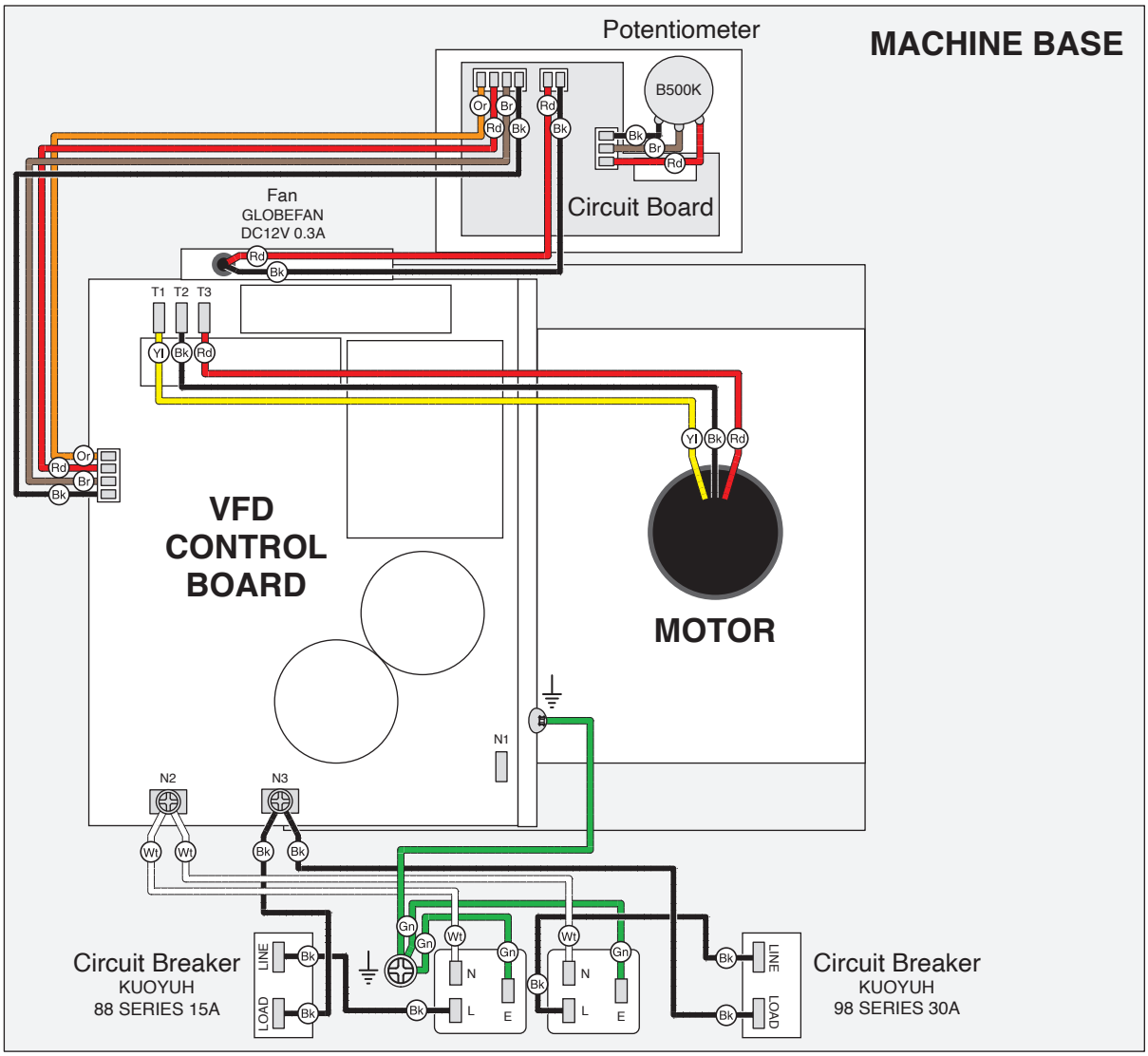
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

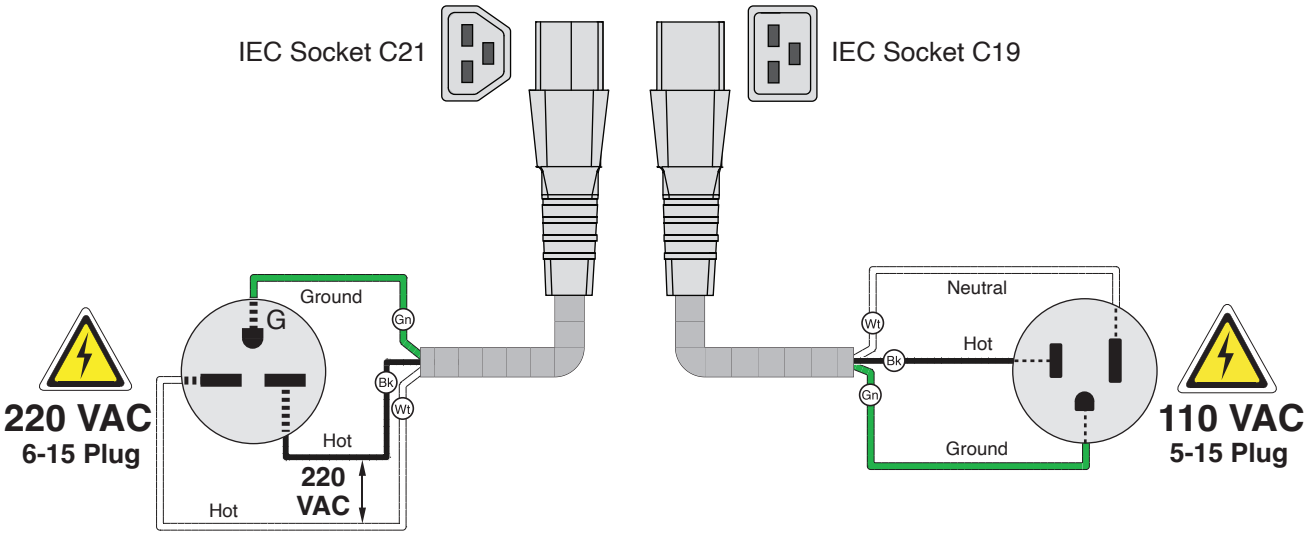
COLOR KEY

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

CONTROL PANEL





STOP READ ELECTRICAL SAFETY ON PAGE 42!

Electrical Components

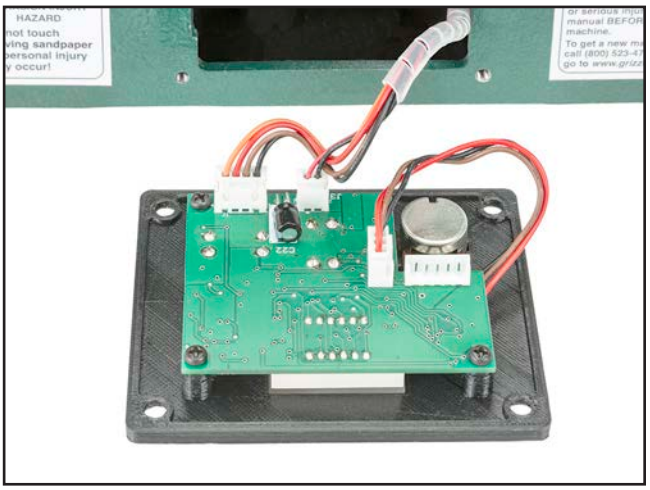


Figure 57. Control panel wiring.

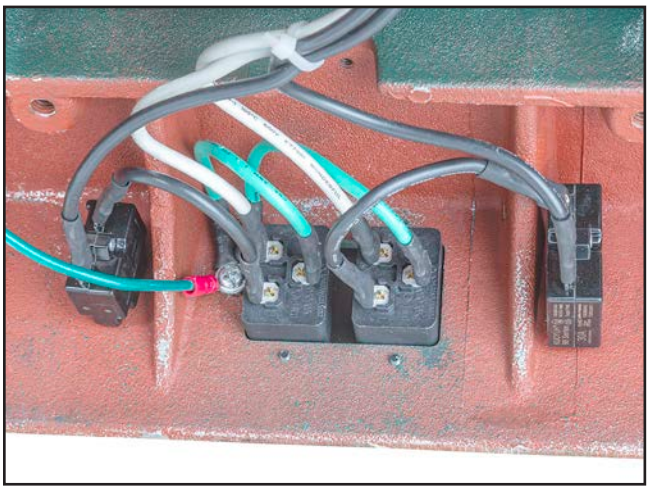


Figure 58. Receptacle and circuit breaker wiring.

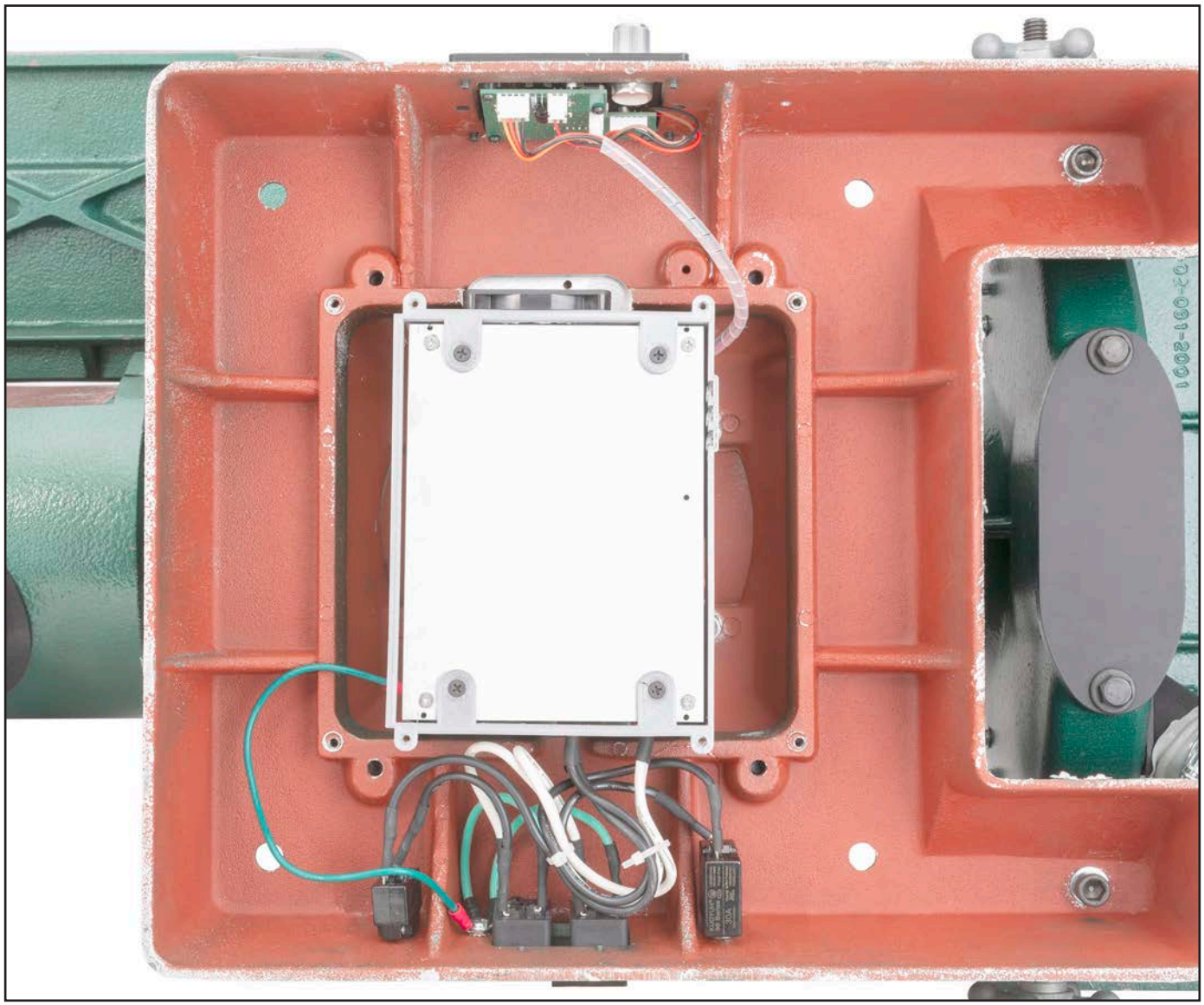


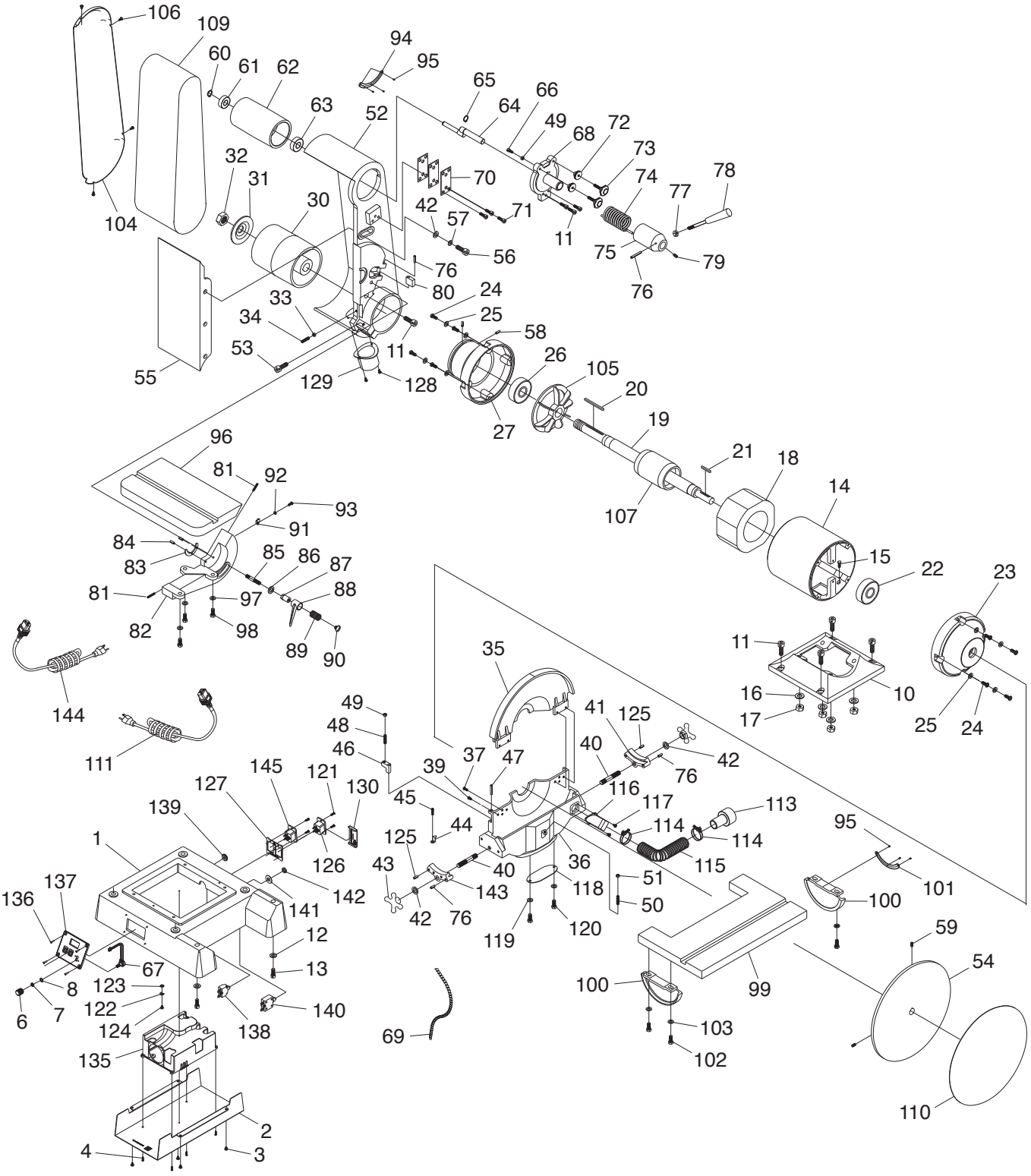
Figure 59. Electrical box wiring.

STOP *READ ELECTRICAL SAFETY ON PAGE 42!*

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	P0997001	BASE
2	P0997002	ELECTRICAL COVER
3	P0997003	FLANGE SCREW 10-24 X 3/8
4	P0997004	TAP SCREW M3 X 8
6	P0997006	SPEED DIAL
7	P0997007	HEX NUT M7-1 THIN
8	P0997008	FLAT WASHER 7 X 11 X 0.4MM
10	P0997010	MOTOR BASE
11	P0997011	CAP SCREW M8-1.25 X 25
12	P0997012	FLAT WASHER 3/8
13	P0997013	CAP SCREW 3/8-16 X 1-1/4
14	P0997014	MOTOR HOUSING
15	P0997015	HEX BOLT 5/16-18 X 1-1/2
16	P0997016	FLAT WASHER 5/16
17	P0997017	HEX NUT 5/16-18
18	P0997018	STATOR
19	P0997019	MOTOR SHAFT
20	P0997020	KEY 5 X 5 X 67
21	P0997021	KEY 5 X 5 X 32.5
22	P0997022	BALL BEARING 6206ZZ
23	P0997023	MOTOR COVER RIGHT
24	P0997024	PHLP HD SCR 1/4-20 X 7/8
25	P0997025	LOCK WASHER 1/4
26	P0997026	BALL BEARING 6206ZZ
27	P0997027	MOTOR COVER LEFT
30	P0997030	DRIVE ROLLER
31	P0997031	ROLLER FLANGE
32	P0997032	HEX NUT 1-8 LH
33	P0997033	HEX NUT M6-1
34	P0997034	SET SCREW M6-1 X 25
35	P0997035	DISC GUARD UPPER
36	P0997036	DISC HOUSING
37	P0997037	PHLP HD SCR 10-24 X 3/8
39	P0997039	FLANGE SCREW 10-24 X 3/8
40	P0997040	STUD-UDE 7/16-14 X 2-3/4, 1, 11/16
41	P0997041	TRUNNION REAR
42	P0997042	FLAT WASHER 7/16
43	P0997043	KNOB 7/16-14
44	P0997044	DISC TABLE POINTER
45	P0997045	PHLP HD SCR 10-24 X 1/4
46	P0997046	DISC TABLE FLIP STOP
47	P0997047	ROLL PIN 6 X 40
48	P0997048	SET SCREW M6-1 X 25
49	P0997049	HEX NUT M6-1
50	P0997050	SET SCREW 5/16-18 X 1
51	P0997051	HEX NUT 5/16-18
52	P0997052	BELT HOUSING
53	P0997053	CAP SCREW M8-1.25 X 40
54	P0997054	DISC ALUMINUM
55	P0997055	PLATEN
56	P0997056	CAP SCREW M8-1.25 X 30
57	P0997057	FLAT WASHER 5/16

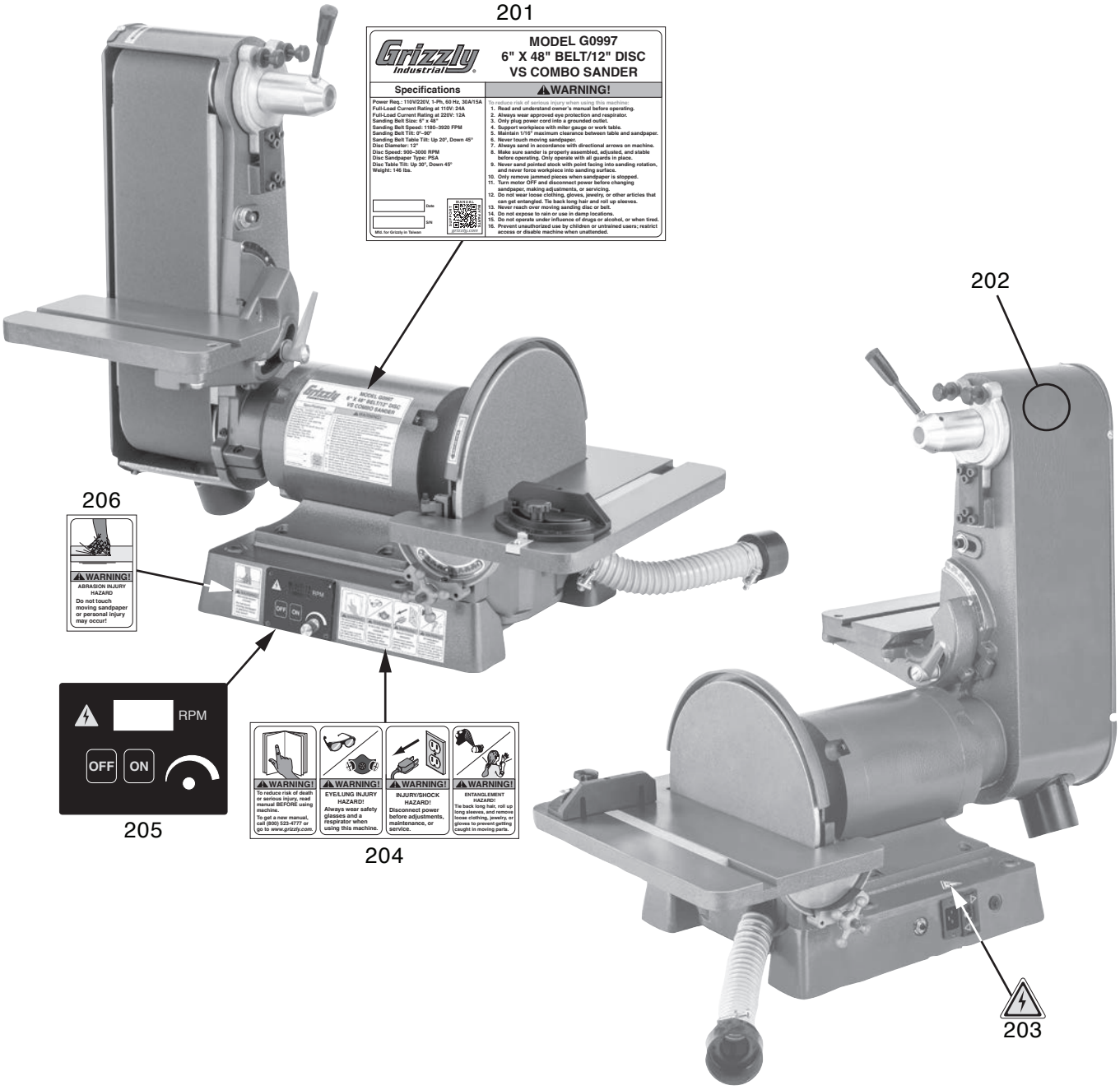
REF	PART #	DESCRIPTION
58	P0997058	ROLL PIN 4 X 14
59	P0997059	SET SCREW M6-1 X 10
60	P0997060	EXT RETAINING RING 15MM
61	P0997061	BALL BEARING 6202ZZ
62	P0997062	IDLER ROLLER
63	P0997063	BALL BEARING 6203ZZ
64	P0997064	ECCENTRIC SHAFT
65	P0997065	EXT RETAINING RING 21MM
66	P0997066	CAP SCREW M6-1 X 12
67	P0997067	POTENTIOMETER B500K
68	P0997068	TRACKING BRACKET
69	P0997069	WIRE SLEEVE SPIRAL
70	P0997070	RETAINING PLATE
71	P0997071	CAP SCREW M8-1.25 X 16
72	P0997072	THUMB NUT M8-1.25 KD
73	P0997073	KNOB BOLT M8-1.25 X 45
74	P0997074	TORSION SPRING 9.5 X 4MM
75	P0997075	TENSION HUB
76	P0997076	ROLL PIN 6 X 50
77	P0997077	HEX NUT 3/8-16
78	P0997078	FIXED HANDLE 3/8-16 X 20
79	P0997079	SET SCREW M6-1 X 10
80	P0997080	BELT TABLE FLIP STOP
81	P0997081	SET SCREW M6-1 X 25
82	P0997082	BELT TABLE TRUNNION
83	P0997083	PIVOT PLATE
84	P0997084	ROLL PIN 4 X 14
85	P0997085	STUD-UDE 7/16-14 X 2-7/8, 1-3/16, 11/16
86	P0997086	FLAT WASHER 7/16
87	P0997087	STANDOFF-HEX FF 7/16-14, 3/8-16
88	P0997088	ADJUSTABLE HANDLE
89	P0997089	COMPRESSION SPRING 1.6 X 20 X 20
90	P0997090	HANDLE SCREW 3/8-16 X 9
91	P0997091	BELT TABLE POINTER
92	P0997092	FLAT WASHER #10
93	P0997093	PHLP HD SCR 10-24 X 1/4
94	P0997094	BELT TABLE ANGLE SCALE
95	P0997095	RIVET 2 X 5MM NAMEPLATE, STEEL
96	P0997096	BELT TABLE
97	P0997097	FLAT WASHER 5/16
98	P0997098	HEX BOLT 5/16-18 X 1
99	P0997099	DISC TABLE
100	P0997100	DISC TABLE TRUNNION
101	P0997101	DISC TABLE ANGLE SCALE
102	P0997102	HEX BOLT 5/16-18 X 5/8
103	P0997103	FLAT WASHER 5/16
104	P0997104	BELT COVER
105	P0997105	MOTOR FAN PLASTIC
106	P0997106	FLANGE SCREW 1/4-20 X 1/2
107	P0997107	ROTOR 80 X 55MM
109	P0997109	SANDING BELT 6" X 48" 80-GRIT
110	P0997110	SANDING DISC 12" 80-GRIT

Main Parts List (Cont.)

REF	PART #	DESCRIPTION
111	P0997111	POWER CORD 12G 3W 72" 5-15P
113	P0997113	HOSE ADAPTER 2-1/2" X 1-1/2"
114	P0997114	HOSE CLAMP 1-1/2"
115	P0997115	HOSE 1-1/2" X 10"
116	P0997116	DUST CHUTE
117	P0997117	FLANGE SCREW 10-24 X 3/8
118	P0997118	LOWER DISC BRACKET COVER
119	P0997119	FLAT WASHER 5/16
120	P0997120	HEX BOLT 5/16-18 X 1/2
121	P0997121	FLAT HD SCR M3-.5 X 12
122	P0997122	CLIPPED WASHER 4.9, 11.5 X 10.5 COPPER
123	P0997123	EXT TOOTH WASHER 5MM
124	P0997124	FLANGE SCREW 10-24 X 1/4
125	P0997125	ROLL PIN 6 X 40
126	P0997126	RECEPTACLE MALE IEC C20

REF	PART #	DESCRIPTION
127	P0997127	RECEPTACLE PLATE
128	P0997128	PHLP HD SCR 1/4-20 X 1/2
129	P0997129	DUST PORT 3"
130	P0997130	RECEPTACLE COVER
135	P0997135	VFD CONTROL BOARD
136	P0997136	FLAT HD SCR M4-.7 X 12
137	P0997137	CONTROL PANEL
138	P0997138	CIRCUIT BREAKER KUOYUH 88 SERIES 15A
139	P0997139	THUMB NUT M11-1
140	P0997140	CIRCUIT BREAKER KUOYUH 98 SERIES 30A
141	P0997141	CIRCUIT BREAKER LABEL
142	P0997142	HEX NUT M11-1 THIN
143	P0997143	TRUNNION FRONT
144	P0997144	POWER CORD 14G 3W 72" 6-15P
145	P0997145	RECEPTACLE MALE IEC C22

Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P0997201	MACHINE ID LABEL
202	P0997202	TOUCH-UP PAINT, GRIZZLY GREEN
203	P0997203	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
204	P0997204	COMBO WARNING LABEL
205	P0997205	CONTROL PANEL LABEL
206	P0997206	ABRASION INJURY LABEL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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

WARRANTY

grizzly.com