



**MODEL G1071Z
1 HP VARIABLE-SPEED
OSCILLATING SPINDLE SANDER
MANUAL INSERT**

**For Machines Mfd. Since 06/24
and Owner's Manual Revised 05/19**

The Model G1071Z is the same machine as the Model G1071 except for the power controls, spindle speed, power supply requirements, and wiring. Except for the differences noted in this insert, all other content in the Model G1071 owner's manual applies to this machine.

▲WARNING: To reduce the risk of serious injury, you **MUST** read and understand this insert—and the entire Model G1071 manual—**BEFORE** assembling, installing, or operating this machine!

If you have any further questions about this manual insert or the differences between the Model G1071Z and the Model G1071, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.



COPYRIGHT © MAY, 2024 BY GRIZZLY INDUSTRIAL, INC.
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#CS23187 PRINTED IN TAIWAN

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

Power Controls

Refer to the following figure and descriptions to become familiar with the power controls and components of this machine.

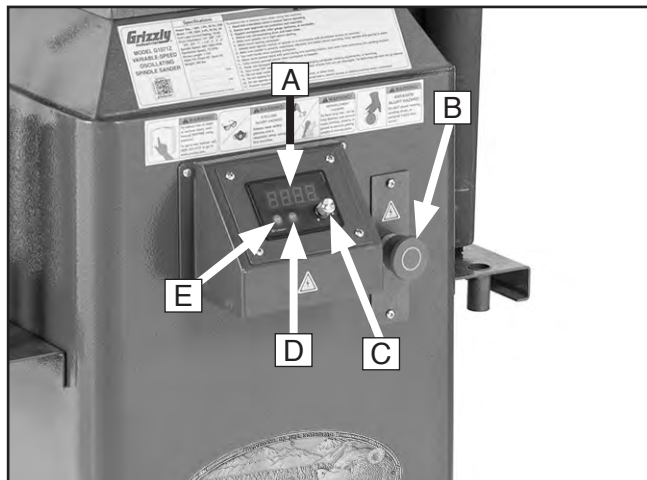


Figure 1. G1071Z power controls.

- A. **Spindle Speed Digital Readout:** Shows spindle speed in RPM.
- B. **Emergency Stop Button:** Stops spindle and disables machine. Twist clockwise to reset.
- C. **Spindle Speed Dial:** Adjusts spindle speed from 900–1800 RPM.
- D. **OFF Button:** Stops spindle rotation.
- E. **ON Button:** Starts spindle rotation.

Site Considerations

Weight Load

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

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.

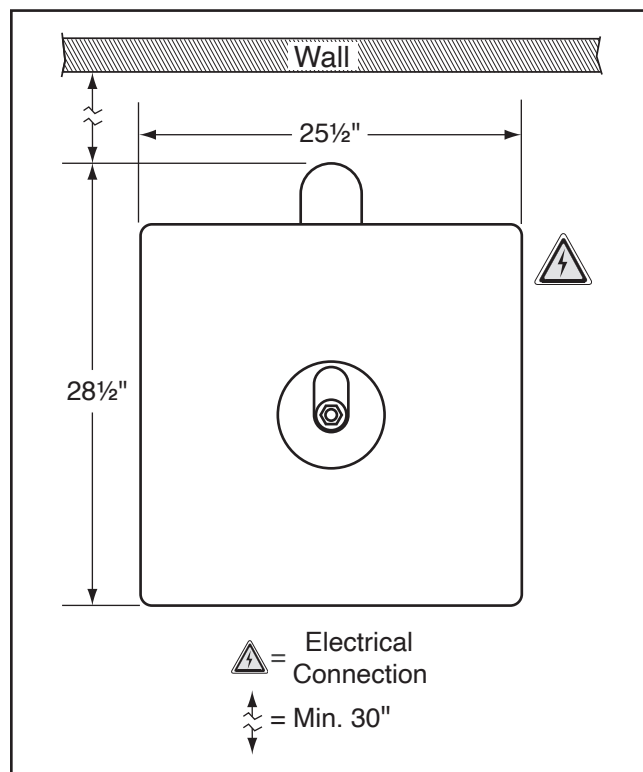


Figure 2. Minimum working clearances.

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





MACHINE DATA SHEET

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

MODEL G1071Z 1 HP VARIABLE-SPEED OSCILLATING SPINDLE SANDER

Product Dimensions:

Weight..... 290 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 25-1/2 x 28-1/2 x 45 in.
Footprint (Length x Width)..... 16 x 16 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 300 lbs.
Length x Width x Height..... 29 x 26 x 37 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 15.5A
Minimum Circuit Size..... 20A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 14 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... ON/OFF Buttons
Inverter (VFD) Type..... TAI-CHUAN TA11D5
Inverter (VFD) Size..... 1 HP

Motors:

Main

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



Spindle Sander Info

Sanding Drum Diameters.....	1/4, 3/8, 1/2, 5/8, 3/4, 1, 1-1/2, 2, 3, 4 in.
Sanding Drum Length.....	5, 6, 9 in.
Spindle Speed.....	900 - 1800 RPM
Spindle Oscillation.....	72 OPM
Stroke Length.....	1-1/2 in.
Table Length.....	25-1/8 in.
Table Width.....	25-1/8 in.
Table Thickness.....	1-1/8 in.
Table-to-Floor Height.....	35-3/4 in.
Number of Table Inserts.....	3
Included Sanding Sleeve Grit Size.....	100
Table Tilt.....	Front 45, Back 20 deg.

Construction Materials

Base.....	Formed Steel
Stand.....	Formed Steel
Table.....	Precision-Ground Cast Iron
Frame.....	Steel
Paint Type/Finish.....	Powder Coated

Other Related Info

Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	T28922

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	45 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Features:

Three Precision-Ground Steel Table Inserts
Formed & Welded Steel Stand
Precision-Ground Heavy-Duty Cast Iron Table
Table Tilts 45 Deg. Forward, 20 Deg. Back
Variable Spindle Speed Digital Readout
Ten Sanding Drums in a Variety of Diameters & Lengths

Accessories Included:

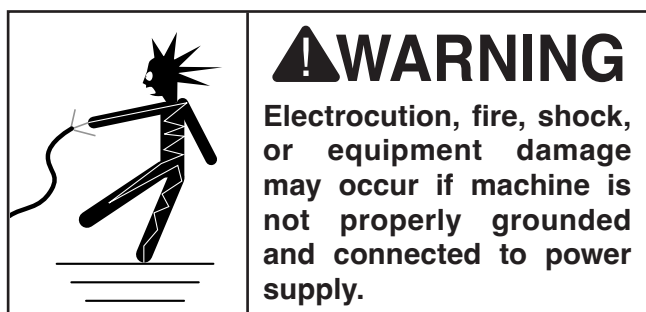
One 100-Grit Sanding Sleeve for Each Drum Size



POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 120V .. 15.5 Amps

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

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

! WARNING

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

120V Circuit Requirements

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

Nominal Voltage 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps
Plug/Receptacle NEMA 5-15

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

! CAUTION

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

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



Grounding & Plug Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

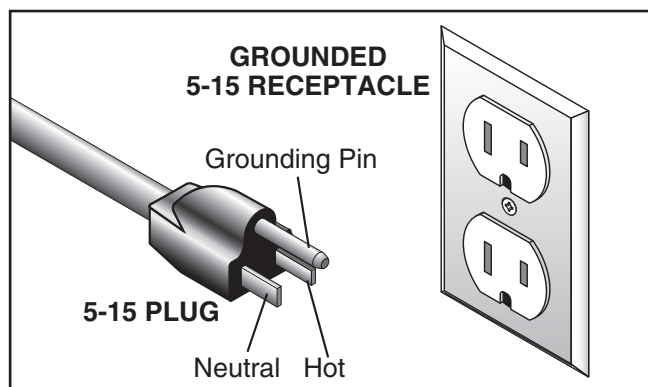
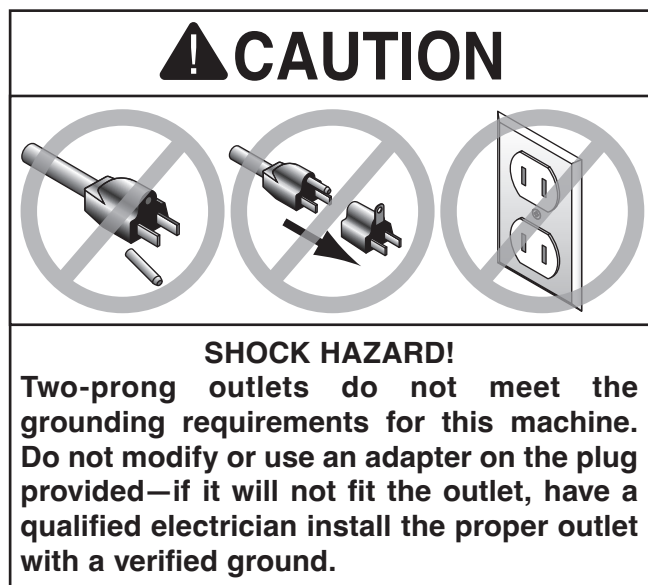


Figure 3. Typical 5-15 plug and receptacle.



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

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

Extension Cords

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

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

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

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



Dust Collection

⚠ CAUTION

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

Minimum CFM at Dust Port: 400 CFM

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

To connect dust collection system to machine:

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



Figure 4. Dust hose attached to dust port.

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

Note: Tight fit is necessary for proper performance.

Test Run

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

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

The Test Run consists of verifying the following: 1) the motor powers up and runs correctly, 2) the power controls function correctly, and 3) the Emergency Stop button disables the machine correctly.

⚠ WARNING

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

⚠ WARNING

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



To test run machine:

1. Clear all setup tools away from machine.
2. Press Emergency Stop button in (see **Figure 5**).
3. Turn spindle speed dial all the way counter-clockwise (see **Figure 5**).
4. Connect machine to power by inserting power cord plug into a matching receptacle. Spindle speed digital readout (see **Figure 5**) will illuminate.

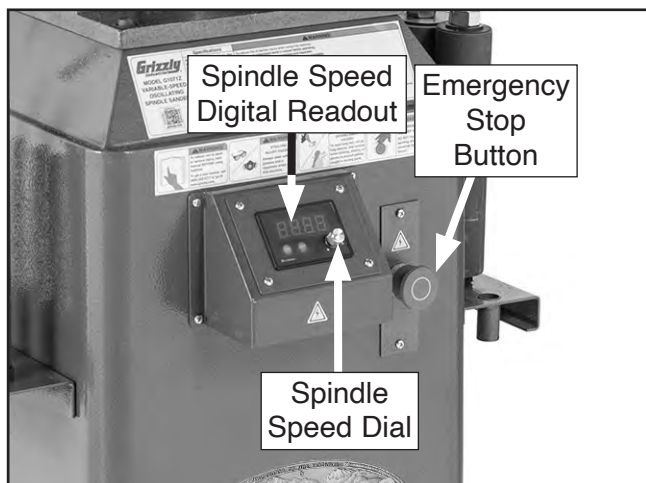


Figure 5. Location of Emergency Stop button, spindle speed dial, and spindle speed digital readout.

5. Twist Emergency Stop button clockwise until it springs out (see **Figure 6**). This resets button so machine can start.



Figure 6. Resetting Emergency Stop button.

6. Press ON button (see **Figure 7**) to turn machine **ON**. Verify motor starts up and runs smoothly without any unusual problems or noises.



Figure 7. Location of ON button.

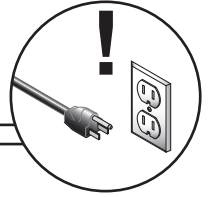
7. Verify speed controls by slowly turning spindle speed dial clockwise. Rotate dial back and forth to test variable-speed function.
8. Press Emergency Stop button to turn machine **OFF**.
9. WITHOUT resetting Emergency Stop button, try to start machine by pressing ON button. Machine should not start.
 - If machine *does not* start, safety feature of Emergency Stop button is working correctly. Congratulations! Test Run is complete.
 - If machine *does* start, immediately turn it **OFF** and disconnect power. Safety feature of Emergency Stop button is NOT working properly and must be replaced before further using machine.



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.	- Emergency Stop button depressed. - Incorrect power supply voltage or circuit size. - Power supply circuit breaker tripped or fuse blown. - Motor wires connected incorrectly. - Wiring broken, disconnected, or corroded. - Emergency Stop button at fault. - Control panel at fault. - VFD at fault. - Motor or motor bearings at fault.	- Rotate Emergency Stop button head to reset. - Ensure correct power supply voltage and circuit size (Page 5). - Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. - Correct motor wiring connections (Page 11). - Fix broken wires or disconnected/corroded connections (Page 11). - Replace. - Replace. - Inspect VFD; replace if at fault. - Replace motor.
Machine stalls or is underpowered.	- Workpiece material unsuitable for machine. - Worm or worm gear at fault. - Motor wires connected incorrectly. - Machine undersized for task. - Motor overheated. - Extension cord too long. - Motor or motor bearings at fault.	- Only sand wood/ensure moisture is below 20%. - Replace broken or slipping worm/gear. - Correct motor wiring connections (Page 11). - Clean/replace sanding sleeve (Page 22/28 of manual); reduce feed rate/sanding depth. - Clean motor, let cool, and reduce workload. - Move machine closer to power supply; use shorter extension cord (Page 6). - Replace motor.
Machine has vibration or noisy operation.	- Motor or component loose. - Spindle loose, improperly installed, or damaged. - Motor fan rubbing on fan cover. - Motor bearings at fault. - Worm or worm gear at fault.	- Replace damaged or missing bolts/nuts or tighten if loose. - Tighten loose spindle, reinstall spindle ensuring mating surfaces are clean, replace spindle if damaged. - Fix/replace fan cover; replace loose/damaged fan. - Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. - Replace broken or slipping worm/gear.
Machine operates in reverse.	Motor connections wired out of phase.	Correct phase polarity.
Spindle speed digital readout does not work/display is incorrect.	- Digital readout displays "E.ESP" because Emergency Stop button is depressed. - Wiring broken, disconnected, or corroded. - Control panel at fault.	- Rotate Emergency Stop button head to reset. - Fix broken wires or disconnected/corroded connections (Page 11). - Replace.



Operation

Symptom	Possible Cause	Possible Solution
Deep sanding grooves or scores in workpiece.	- Excessive spindle speed. - Workpiece sanded across grain. - Excessive workpiece pressure against spindle sleeve. - Sanding sleeve too coarse for desired finish.	- Reduce spindle speed. - Sand workpiece with grain. - Reduce workpiece pressure. - Replace with finer grit sleeve (Page 22 of manual).
Glazed sanding surface.	- Sanding wet stock. - Sanding stock with high pitch/residue. - Sanding sleeve worn or filled with pitch/residue.	- Only sand wood/ensure moisture is below 20%. - Use different stock or accept characteristics and plan on frequently cleaning/replacing sanding sleeves (Page 22/28 of manual). - Replace sleeve (Page 22 of manual).
Sanding sleeve clogs quickly.	- Sanding wet stock. - Excessive spindle speed. - Excessive workpiece pressure against spindle sleeve. - Sanding sleeve too fine for desired finish. - Sanding softwood. - Worn sanding sleeve. - Poor dust collection.	- Only sand wood/ensure moisture is below 20%. - Reduce spindle speed. - Reduce workpiece pressure. - Replace with coarser grit sleeve (Page 22 of manual). - Use different stock or accept characteristics and plan on frequently cleaning/replacing sanding sleeves (Page 22/28 of manual). - Replace sleeve (Page 22 of manual). - Unclog ducts; close gates to improve suction; redesign dust collection system.
Poor, non-aggressive sanding results.	- Sanding sleeve grit too fine for desired finish. - Sanding sleeve clogged/worn.	- Replace with a coarser grit sleeve (Page 22 of manual). - Clean/replace sleeve (Page 22/28 of manual).
Burn marks on workpiece.	- Excessive spindle speed. - Excessive workpiece pressure against spindle sleeve. - Sanding sleeve grit too fine for desired finish. - Sanding sleeve clogged/worn.	- Reduce spindle speed. - Reduce workpiece pressure. - Replace with a coarser grit sleeve (Page 22 of manual). - Clean/replace sleeve (Page 22/28 of manual).
Workpiece not sanded square when table tilt is set to 0°.	Table is not square to spindle.	Adjust table stop bolt until table is square to spindle.
Sanded workpiece angle does not match scale angle.	Table tilt scale needs to be calibrated.	Use 90° square to adjust table square to spindle, then adjust scale pointer to 0°.
Abrasive grit rubs off easily.	- Sanding sleeve has been stored in an incorrect environment. - Sanding sleeve has been folded or crushed.	- Replace sleeve (Page 22 of manual). Store sleeve in a cool, dry area. - Replace sleeve (Page 22 of manual). Do not bend/fold sleeve.
Workpiece frequently gets pulled out of your hands.	- Not supporting workpiece against table. - Starting workpiece on a leading corner.	- Use table to support workpiece. - Start workpiece on a trailing corner.



WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

COLOR KEY

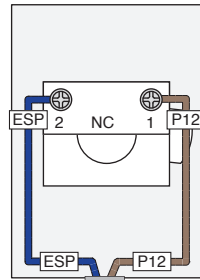
BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



Wiring Diagram

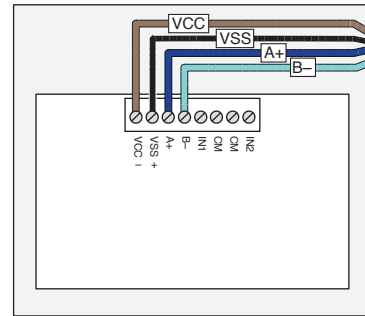
EMERGENCY STOP BUTTON

NHD NPB22-H01



CONTROL PANEL

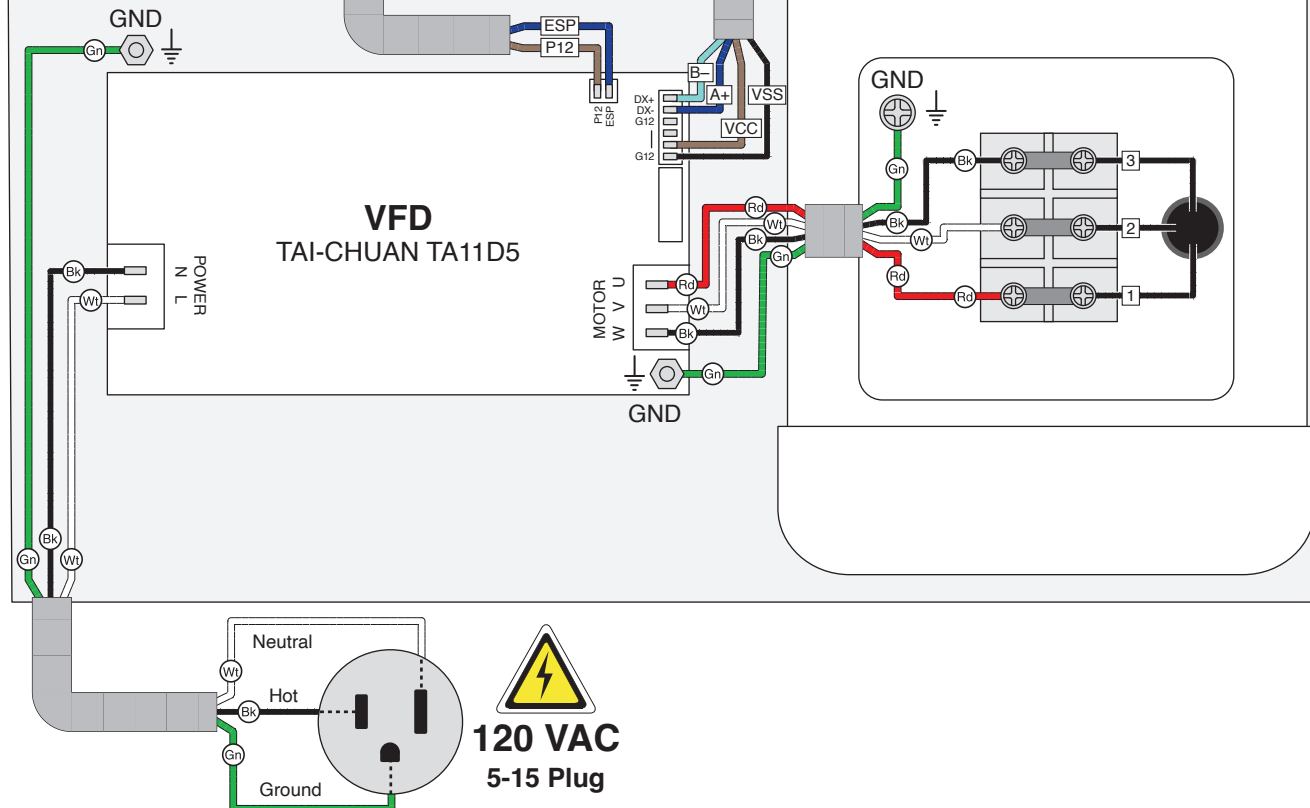
TAI-CHUAN 8-2B-4-900-1800-FL



CABINET

VFD
TAI-CHUAN TA11D5

Motor 220V



Electrical Components

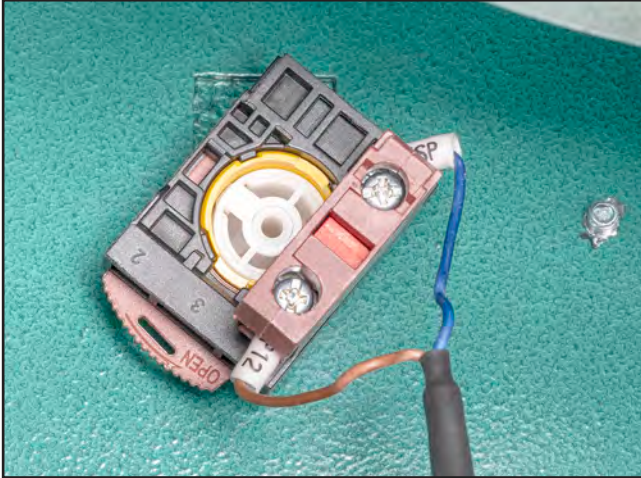


Figure 8. Emergency Stop button wiring.

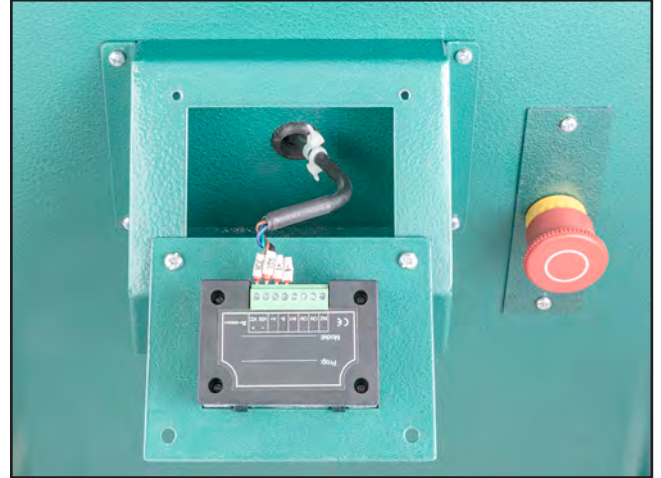


Figure 9. Control panel wiring.

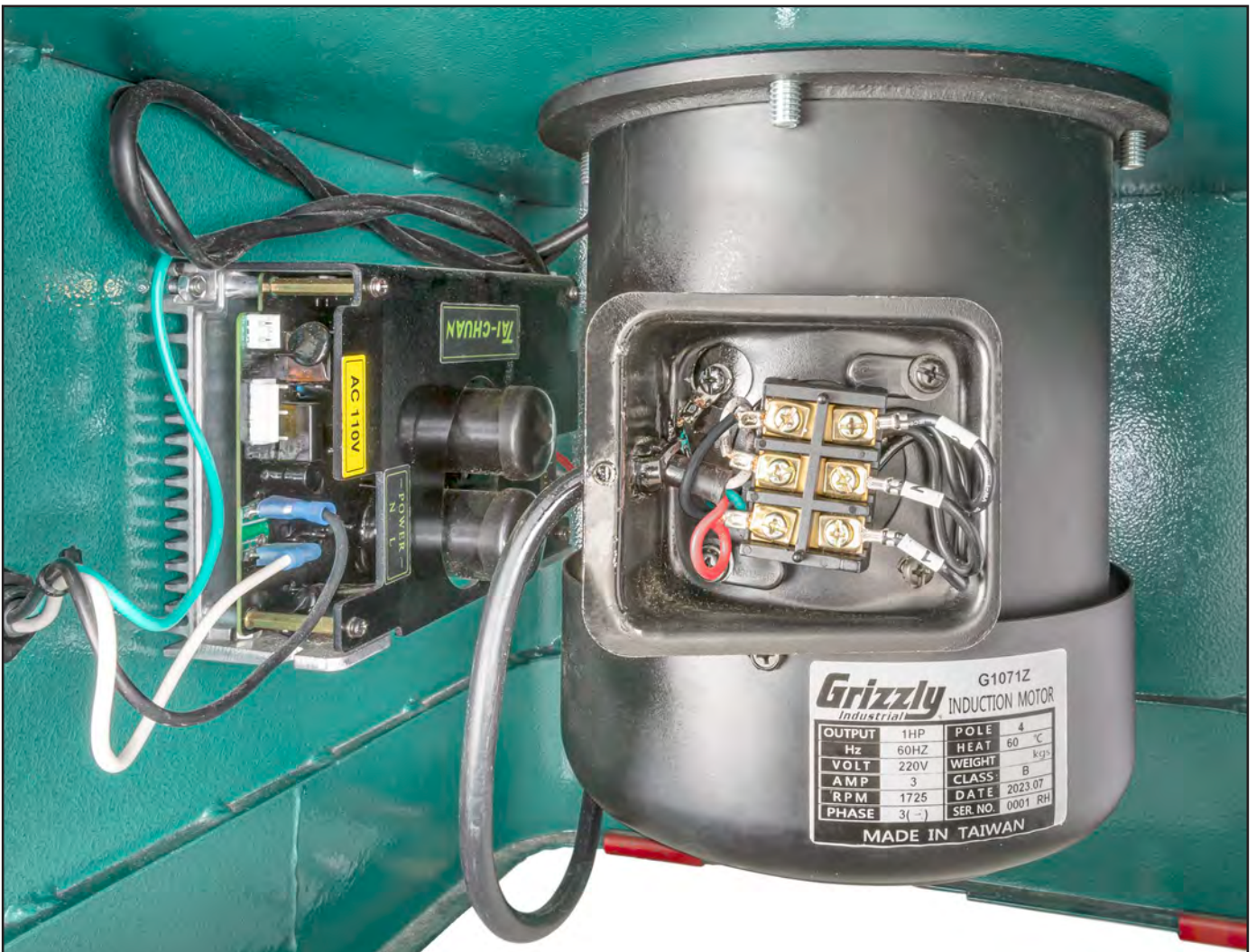
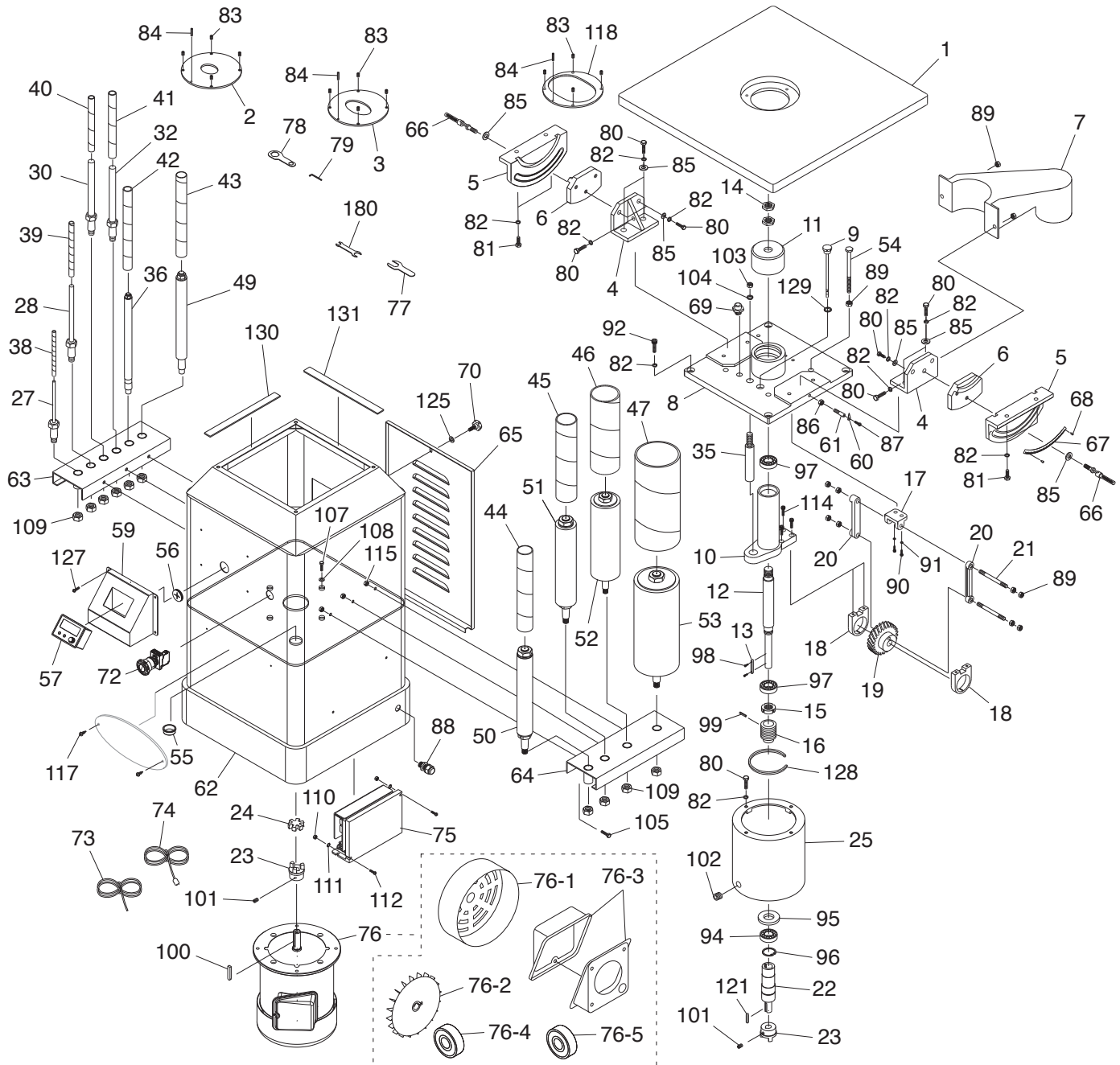


Figure 10. VFD and motor wiring.

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



REF PART # DESCRIPTION

1	P1071Z001	TABLE
2	P1071Z002	TABLE INSERT 1-3/4 X 2-3/16
3	P1071Z003	TABLE INSERT 2-3/16 X 3-1/2
4	P1071Z004	BRACKET

REF PART # DESCRIPTION

5	P1071Z005	TRUNNION OUTER
6	P1071Z006	TRUNNION INNER
7	P1071Z007	DUST CHUTE
8	P1071Z008	HOUSING



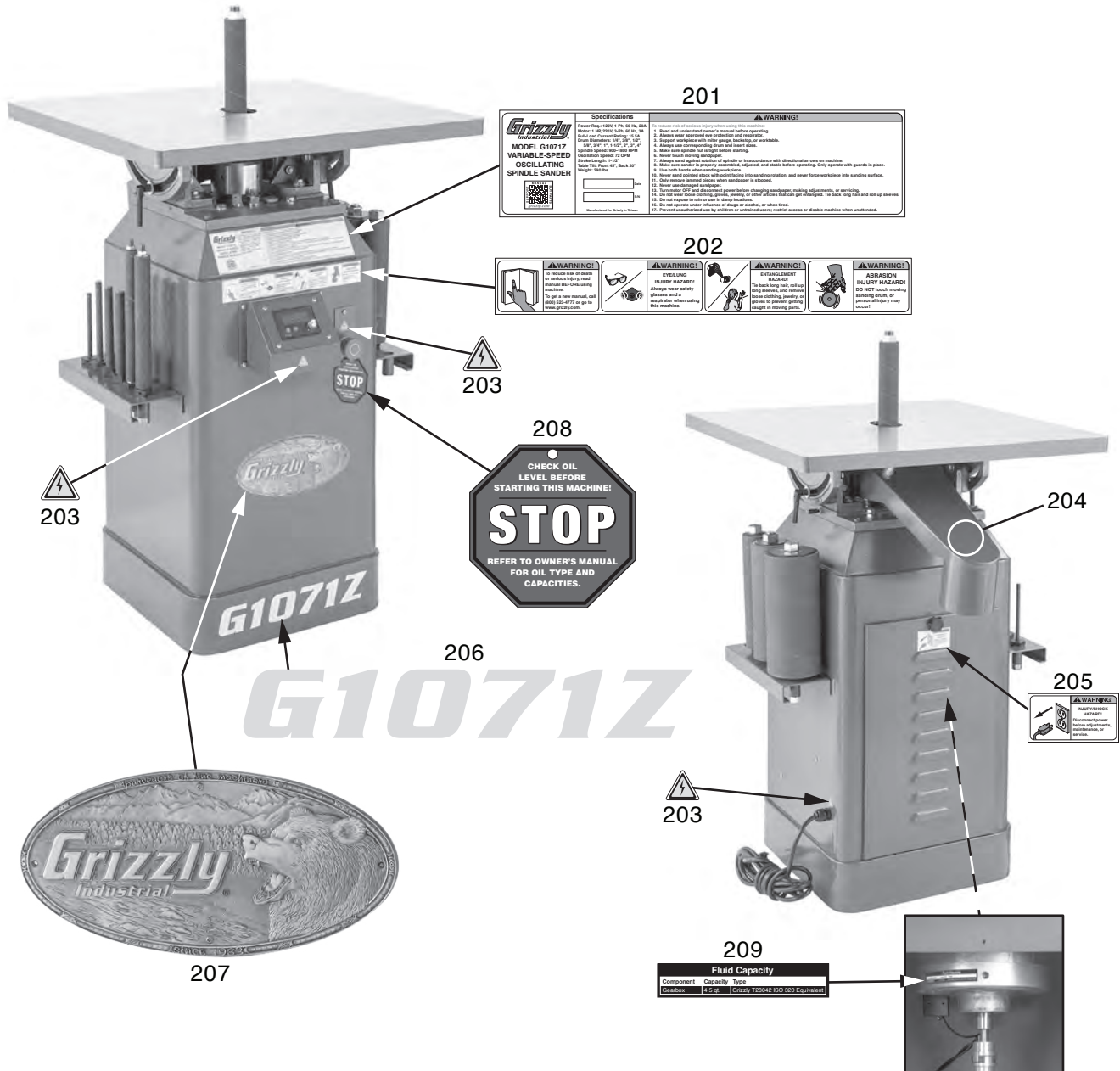
Main Parts List

REF	PART #	DESCRIPTION
9	P1071Z009	DIPSTICK
10	P1071Z010	SPINDLE CASTING
11	P1071Z011	COVER
12	P1071Z012	SPINDLE
13	P1071Z013	SPINDLE KEY 5 X 5 X 50
14	P1071Z014	HEX NUT 15/16-20 THIN
15	P1071Z015	SPANNER NUT 15/16-20
16	P1071Z016	WORM
17	P1071Z017	GEAR MOUNTING BRACKET
18	P1071Z018	BEARING BLOCK
19	P1071Z019	WORM GEAR 24T
20	P1071Z020	CONNECTING ROD
21	P1071Z021	STUD-DE 3/8-16 X 4-5/16, 5/8
22	P1071Z022	DRIVE SHAFT
23	P1071Z023	HUB
24	P1071Z024	CENTER BLOCK
25	P1071Z025	SPINDLE CASE
27	P1071Z027	SPINDLE 1/4"
28	P1071Z028	SPINDLE 3/8"
30	P1071Z030	SPINDLE 1/2"
32	P1071Z032	SPINDLE 5/8"
35	P1071Z035	GUIDE SHAFT
36	P1071Z036	SPINDLE 3/4"
38	P1071Z038	SANDING SLEEVE 1/4 X 5 100-GR (3-PK)
39	P1071Z039	SANDING SLEEVE 3/8 X 6 100-GR (3-PK)
40	P1071Z040	SANDING SLEEVE 1/2 X 6 100-GR (3-PK)
41	P1071Z041	SANDING SLEEVE 5/8 X 6 100-GR (3-PK)
42	P1071Z042	SANDING SLEEVE 3/4 X 9 100-GR (3-PK)
43	P1071Z043	SANDING SLEEVE 1 X 9 100-GR (3-PK)
44	P1071Z044	SANDING SLEEVE 1-1/2 X 9 100-GR (3-PK)
45	P1071Z045	SANDING SLEEVE 2 X 9 100-GR (3-PK)
46	P1071Z046	SANDING SLEEVE 3 X 9 100-GR (3-PK)
47	P1071Z047	SANDING SLEEVE 4 X 9 100-GR (3-PK)
49	P1071Z049	SPINDLE 1"
50	P1071Z050	SPINDLE 1-1/2"
51	P1071Z051	SPINDLE 2"
52	P1071Z052	SPINDLE 3"
53	P1071Z053	SPINDLE 4"
54	P1071Z054	HEX BOLT 3/8-16 X 6-1/2
55	P1071Z055	GROMMET 30MM
56	P1071Z056	DUST GROMMET 30MM
57	P1071Z057	CONTROL PANEL TAI-CHUAN
59	P1071Z059	CONTROL PANEL MOUNT
60	P1071Z060	POINTER
61	P1071Z061	POINTER MOUNT
62	P1071Z062	CABINET
63	P1071Z063	SPINDLE HOLDER 6-HOLE
64	P1071Z064	SPINDLE HOLDER 4-HOLE
65	P1071Z065	CABINET PANEL
66	P1071Z066	FOLDING HANDLE 3/8-16 X 1-1/4, 2-13/16L
67	P1071Z067	ANGLE SCALE
68	P1071Z068	RIVET 2 X 5MM NAMEPLATE, STEEL
69	P1071Z069	OIL BREATHER
70	P1071Z070	KNOB BOLT 1/4-20 X 3/4, 6-LOBE, D1-5/16
72	P1071Z072	E-STOP BUTTON NHD NPB22-H01

REF	PART #	DESCRIPTION
73	P1071Z073	MOTOR CORD 16G 4W 16"
74	P1071Z074	POWER CORD 14G 3W 150" 5-15P
75	P1071Z075	VFD TAI-CHUAN TC111P5
76	P1071Z076	MOTOR 1HP 220V 3-PH
76-1	P1071Z076-1	MOTOR FAN COVER
76-2	P1071Z076-2	MOTOR FAN
76-3	P1071Z076-3	MOTOR JUNCTION BOX
76-4	P1071Z076-4	BALL BEARING 6204ZZ (FRONT)
76-5	P1071Z076-5	BALL BEARING 6203ZZ (REAR)
77	P1071Z077	FLAT WRENCH 1-1/8 OPEN-END
78	P1071Z078	FLAT WRENCH 3/4 X 1 CLOSED-ENDS
79	P1071Z079	HEX WRENCH 2MM
80	P1071Z080	HEX BOLT 3/8-16 X 1-1/4
81	P1071Z081	HEX BOLT 3/8-16 X 1
82	P1071Z082	LOCK WASHER 10MM
83	P1071Z083	SET SCREW 1/4-20 X 5/8
84	P1071Z084	ROLL PIN 5 X 28
85	P1071Z085	FENDER WASHER 3/8
86	P1071Z086	HEX NUT 5/16-18
87	P1071Z087	PHLP HD SCR 8-32 X 1/4
88	P1071Z088	STRAIN RELIEF TYPE-3 M16-1.5
89	P1071Z089	HEX NUT 3/8-16
90	P1071Z090	CAP SCREW 5/16-18 X 1
91	P1071Z091	LOCK WASHER 5/16
92	P1071Z092	CAP SCREW 3/8-16 X 1
94	P1071Z094	BALL BEARING 6206-2RS
95	P1071Z095	OIL SEAL 30 X 62 X 2MM
96	P1071Z096	INT RETAINING RING 35MM
97	P1071Z097	BALL BEARING 6205-2RS
98	P1071Z098	CAP SCREW 4-40 X 1/2
99	P1071Z099	ROLL PIN 5 X 30
100	P1071Z100	KEY 5 X 5 X 25
101	P1071Z101	SET SCREW 5/16-18 X 3/8
102	P1071Z102	DRAIN PLUG 1/4-19 X 7/16
103	P1071Z103	HEX NUT 5/8-11
104	P1071Z104	LOCK WASHER 5/8
105	P1071Z105	HEX BOLT 1/4-20 X 1/2
107	P1071Z107	HEX BOLT 5/16-18 X 1
108	P1071Z108	FENDER WASHER 5/16
109	P1071Z109	HEX NUT 1/2-13
110	P1071Z110	HEX NUT 10-24
111	P1071Z111	EXT TOOTH WASHER #10
112	P1071Z112	PHLP HD SCR 10-24 X 5/8
114	P1071Z114	CAP SCREW 5/16-18 X 1
115	P1071Z115	HEX NUT 1/4-20
117	P1071Z117	TAP SCREW #5 X 3/8
118	P1071Z118	TABLE INSERT 4-1/4 X 6
121	P1071Z121	KEY 5 X 5 X 25
125	P1071Z125	FLAT WASHER 1/4
127	P1071Z127	PHLP HD SCR 10-24 X 3/8
128	P1071Z128	RUBBER STRIP 3 X 755MM
129	P1071Z129	O-RING 15.8 X 2.4 P16
130	P1071Z130	GASKET 20 X 1 X 240MM
131	P1071Z131	GASKET 20 X 1 X 240MM
180	P1071Z180	FLAT WRENCH 7/8 X 1-1/4 OPEN-ENDS



Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P1071Z201	MACHINE ID LABEL
202	P1071Z202	COMBO WARNING LABEL
203	P1071Z203	ELECTRICITY LABEL
204	P1071Z204	TOUCH-UP PAINT, GRIZZLY GREEN
205	P1071Z205	INJURY/SHOCK HAZARD LABEL

REF	PART #	DESCRIPTION
206	P1071Z206	MODEL NUMBER LABEL
207	P1071Z207	GRIZZLY NAMEPLATE SMALL
208	P1071Z208	CHECK OIL HANG TAG
209	P1071Z209	FLUID CAPACITY 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.





MODEL G1071
1 HP OSCILLATING SPINDLE
SANDER
OWNER'S MANUAL
(For models manufactured since 11/10)



COPYRIGHT © 1995 BY GRIZZLY INDUSTRIAL, INC. REVISED MAY, 2019 (BL)
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#JB11261 PRINTED IN TAIWAN

V3.05.19



WARNING!

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

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

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

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



WARNING!

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

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

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

Table of Contents

INTRODUCTION.....	2	SECTION 5: ACCESSORIES.....	25
Manual Accuracy	2	SECTION 6: MAINTENANCE.....	27
Contact Info.....	2	Schedule	27
Machine Description	2	Cleaning & Protecting	27
Identification	3	Lubrication	27
Machine Data Sheet	4	Sanding Sleeves	28
SECTION 1: SAFETY	6	Gearbox Oil.....	28
Safety Instructions for Machinery	6	SECTION 7: SERVICE	29
Additional Safety for Spindle Sanders	8	Troubleshooting	29
SECTION 2: POWER SUPPLY	9	SECTION 8: WIRING.....	31
Voltage Conversion to 240V	11	Wiring Safety Instructions	31
SECTION 3: SETUP	12	Wiring Diagram	32
Needed for Setup.....	12	SECTION 9: PARTS.....	33
Unpacking	12	Main	33
Inventory	13	Base.....	35
Cleanup.....	14	Labels & Cosmetics	36
Site Considerations.....	14	WARRANTY & RETURNS	37
Assembly	15		
Check Gearbox Oil	17		
Test Run	18		
SECTION 4: OPERATIONS	19		
Operation Overview	19		
Disabling Switch.....	20		
Stock Inspection.....	20		
Sanding Tips.....	20		
Sanding Spindles.....	21		
Sanding Sleeves.....	22		
Table Inserts	23		
Bevel Sanding.....	24		

INTRODUCTION

Manual Accuracy

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

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

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

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

		MODEL GXXXX	
		MACHINE NAME	
SPECIFICATIONS		⚠ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Make sure machine is properly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not use while under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
Manufactured for Grizzly in Taiwan			

Manufacture Date (indicated by arrow pointing to the date field)

Serial Number (indicated by arrow pointing to the serial number field)

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

Machine Description

An oscillating spindle sander is used to sand the edges of contoured or irregularly shaped workpieces.

The cast-iron sanding table provides a solid platform for supporting workpieces and can tilt for sanding beveled edges.

The integrated dust collection port can be fitted to a dust collection system to reduce the amount of dust released by the machine.

Sanding sleeves are easily replaceable and available in a variety of sizes and grits.



Identification

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

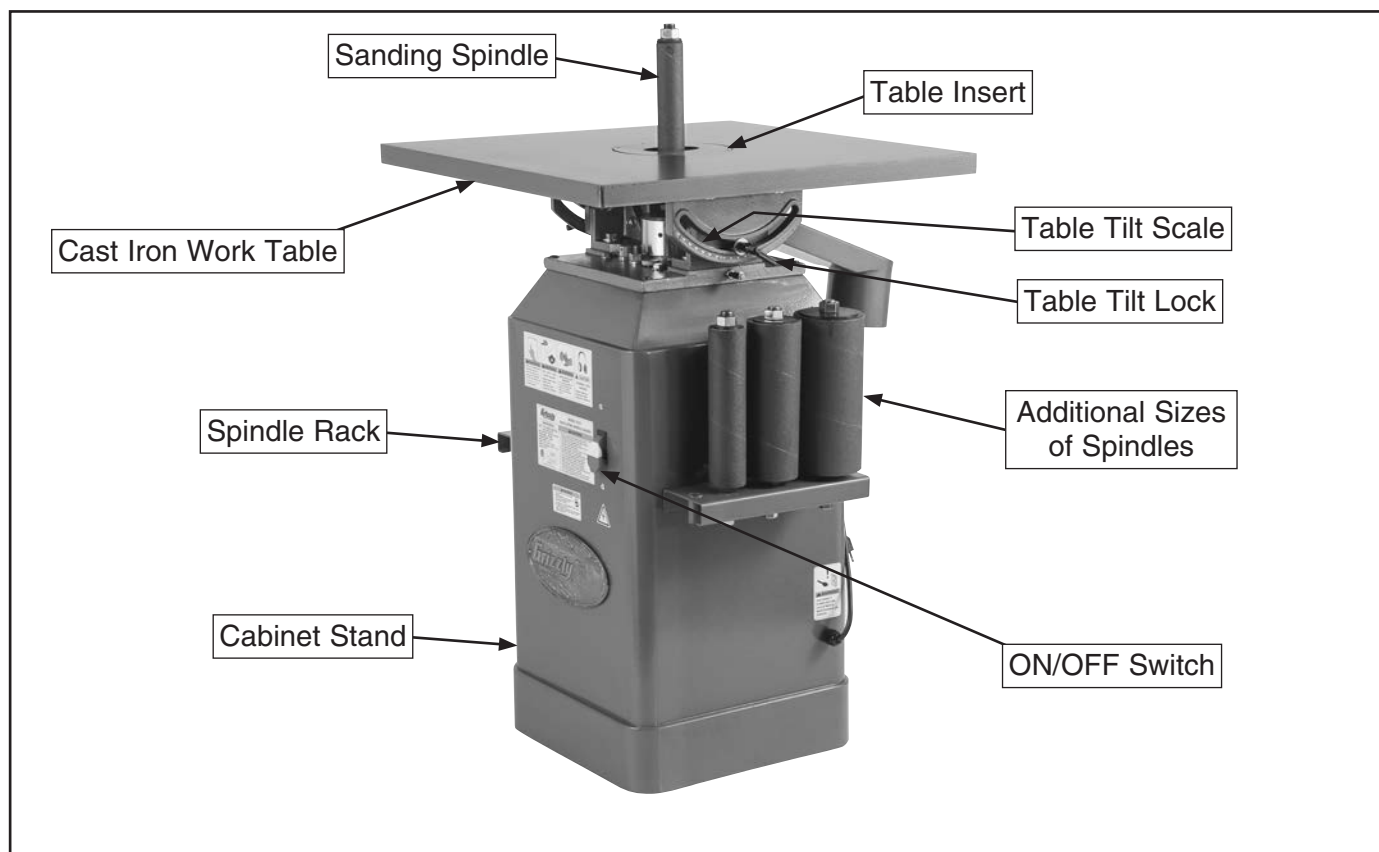


Figure 1. Identification.

⚠ CAUTION

For Your Own Safety Read Instruction Manual Before Operating Spindle Sander

- a) Wear eye protection.
- b) Feed workpiece **AGAINST** rotation of sanding drum.
- c) Keep fingers away from sanding drum.
- d) Do not use awkward hand positions.





MACHINE DATA SHEET

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

MODEL G1071 1 HP OSCILLATING SPINDLE SANDER

Product Dimensions:

Weight..... 287 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 25 x 30 x 44-1/2 in.
Footprint (Length x Width)..... 16 x 16 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 296 lbs.
Length x Width x Height..... 29 x 26 x 37 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V or 240V, Single-Phase, 60 Hz
Prewired Voltage..... 120V
Full-Load Current Rating..... 12A at 120V, 6A at 240V
Minimum Circuit Size..... 15A at 120V, 15A at 240V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 9 ft.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15 for 120V
Recommended Plug Type..... 6-15 for 240V
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 1 HP
Phase..... Single-Phase
Amps..... 12A/6A
Speed..... 1720 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer..... Direct Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:



Spindle Sander Info

Sanding Drum Diameters.....	1/4, 3/8, 1/2, 5/8, 3/4, 1, 1-1/2, 2, 3, 4 in.
Sanding Drum Length.....	5, 6, 9 in.
Spindle Speed.....	1725 RPM
Spindle Oscillation.....	72 OPM
Stroke Length.....	1-1/2 in.
Table Length.....	25 in.
Table Width.....	25 in.
Table Thickness.....	1-1/8 in.
Table-to-Floor Height.....	35-1/2 in.
Number of Table Inserts.....	3
Included Sanding Sleeve Grit Size.....	100
Table Tilt.....	Front 45, Back 15 deg.

Construction Materials

Base.....	Formed Steel
Stand.....	Formed Steel
Table.....	Ground Cast Iron
Frame.....	Sheet Metal
Paint Type/Finish.....	Powder Coated

Other Related Info

Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D2260A

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	45 Minutes
Serial Number Location	ID Label on Center of Stand
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes
Awards	Wood Magazine Top Value 1999

Features:

Features Ground Steel Table Inserts
Includes Formed and Welded Steel Stand
100 Grit Sleeve Included for Each Spindle
Cast-Iron Table
Table Tilts 45 deg.



SECTION 1: SAFETY

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

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



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



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



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

NOTICE

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

Safety Instructions for Machinery

WARNING

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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Spindle Sanders

WARNING

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

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

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

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

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

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

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

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

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

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

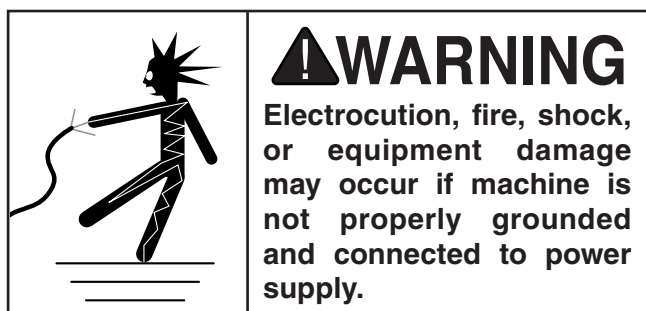
WORKPIECE INTEGRITY. Sanding fragile workpieces can result in loss of control, resulting in entanglement, impact injuries, or damage to the sanding sleeve or drum. Only sand solid workpieces that can withstand power sanding forces. Make sure shape of workpiece is properly supported; avoid sanding workpieces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



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 120V 12 Amps

Full-Load Current Rating at 240V 6 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 120V

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

Nominal Voltage 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 5-15

Circuit Requirements for 240V

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 6-15



Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

For 120V 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.

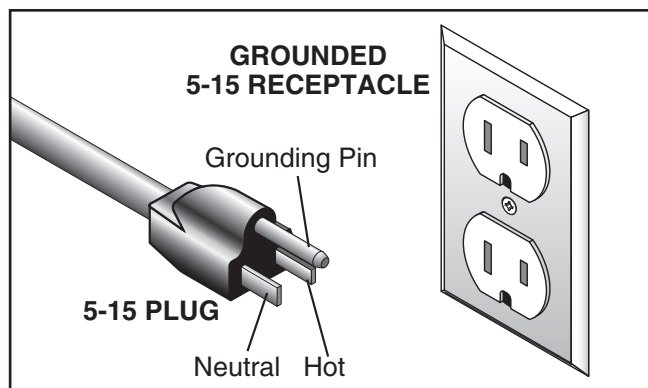
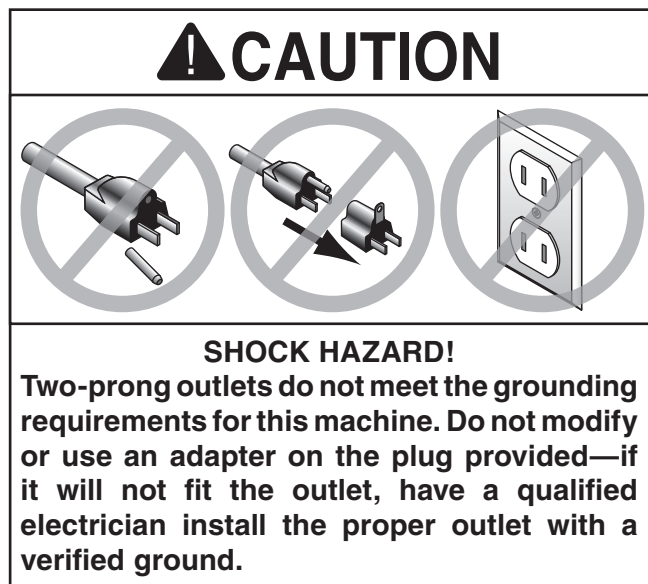


Figure 2. Typical 5-15 plug and receptacle.



For 240V operation: The plug specified under “Circuit Requirements for 240V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

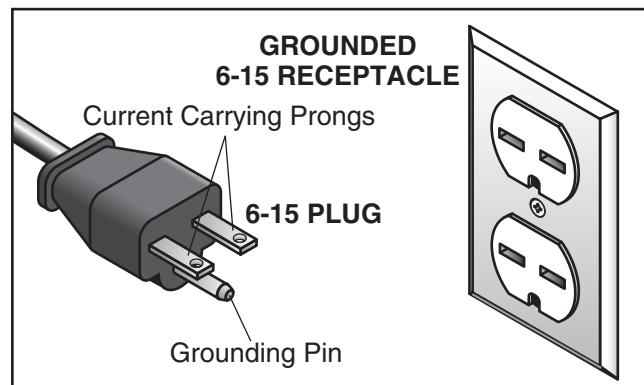


Figure 3. Typical 6-15 plug and receptacle.

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 tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

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

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

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

Minimum Gauge Size12 AWG
Maximum Length (Shorter is Better).....50 ft.



Voltage Conversion to 240V

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

The voltage conversion procedure consists of rewiring the motor and installing the correct plug. A wiring diagram is provided on **Page 32** for your reference.

IMPORTANT: If the diagram included on the motor conflicts with the one on **Page 32**, the motor may have changed since the manual was printed. Use the diagram provided on the motor junction box instead.

Items Needed	Qty
• Phillips Head Screwdriver #2	1
• Electrical Tape.....	As Needed
• Wire Nut (16 AWG x 3).....	1
• 6-15 Plug	1
• Wire Cutters/Stripper.....	1

To convert Model G1071 to 240V:

1. DISCONNECT MACHINE FROM POWER!
2. Cut off existing 5-15 plug.
3. Open motor junction box, remove two wire nuts indicated in **Figure 4**, then disconnect wires.

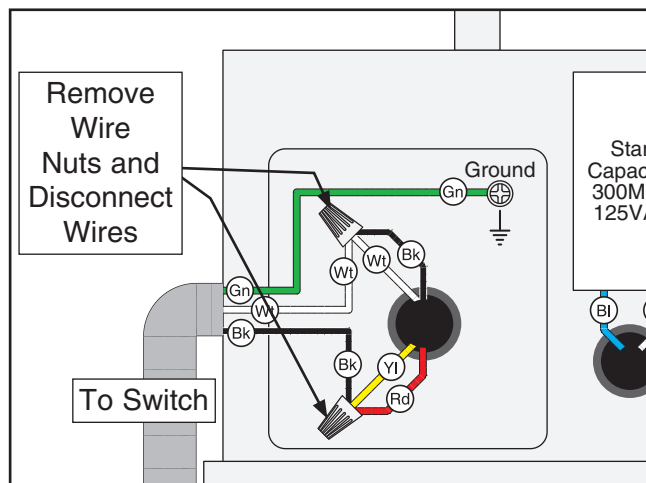


Figure 4. Inside motor junction box (motor pre-wired to 120V).

4. Use wire nuts to connect wires as indicated in **Figure 5**. Twist wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose.

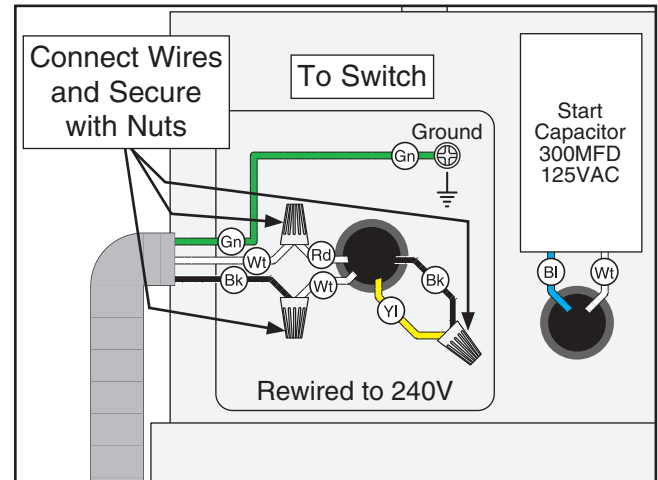
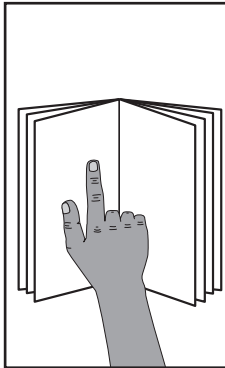


Figure 5. Motor rewired to 240V.

5. Close and secure motor junction box.
6. Install a 6-15 plug according to manufacturer's instructions. If plug manufacturer's instructions are not available, NEMA standard 6-15 plug wiring is provided on **Page 32**.

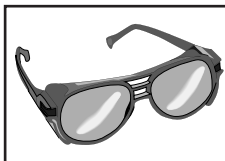


SECTION 3: SETUP



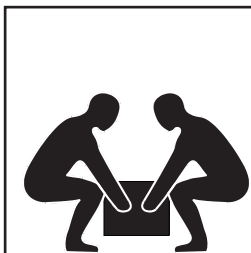
⚠️ WARNING

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



⚠️ WARNING

Wear safety glasses during the entire setup process!



⚠️ WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

⚠️ WARNING

Like all power tools, there is danger associated with this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this tool with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Dust Collection System	1
• 4" Dust Hose	1
• Machinist's Square	1
• Cleaner and Shop Rags	As Needed

Unpacking

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

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

⚠️ 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 follow guidelines could result in serious personal injury, damage to equipment or poor work results.



Inventory

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

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

Box 1 (Figure 6)

Qty

A. Table Assembly (Table, Trunnion, Dust Chute)	1
B. Sanding Spindles	
1/4" x 5"	1
3/8" x 6"	1
1/2" x 6"	1
5/8" x 6"	1
3/4" x 9"	1
1" x 9"	1
1 1/2" x 9"	1
2" x 9"	1
3" x 9"	1
4" x 9"	1
C. Flat Wrench 1 1/8"	1
D. Combo Flat Wrench Open-End 7/8" x 1 1/4" ..	1
E. Combo Flat Wrench Box-End 1" x 3/4"	1
F. Table Insert 1 3/4"	1
G. Table Insert 2 3/16"	1
H. Table Insert 4 1/4"	1
I. Hardware Bag	1
—Set Screws 1/4"-20 x 5/8"	12
—Roll Pins 5 x 28	3
—Hex Wrench 5/64"	1

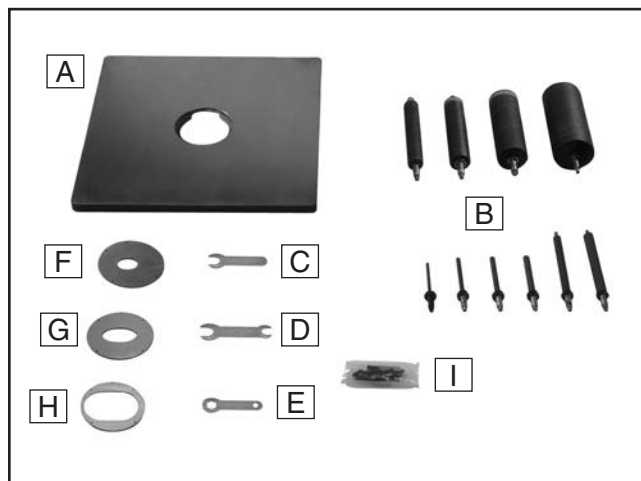


Figure 6. Inventory.

NOTICE

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



Cleanup

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

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

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

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

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.

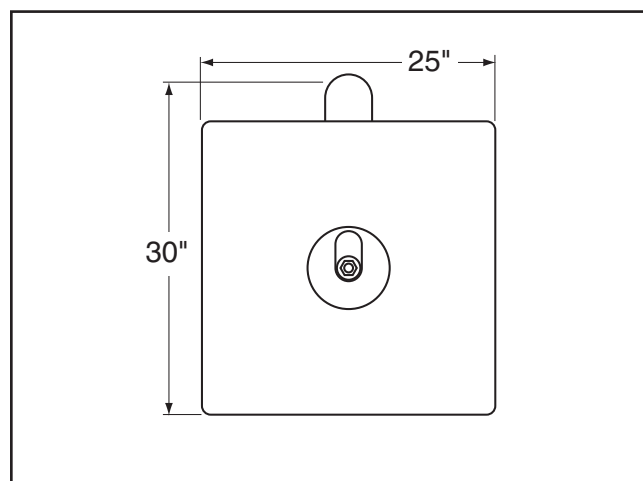


Figure 7. Minimum working clearances.

A detailed illustration of a heavy-duty padlock with a shackle, and a key with a notched bit.	⚠ 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.
---	--



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 your spindle sander:

1. With the assistance of a helper, carefully lift the table/trunnion assembly onto the top of the sander base.
2. Align the mounting holes in the trunnions with the mounting holes in the sander base.
3. Using the (4) $\frac{3}{8}$ "-16 x $1\frac{1}{4}$ " hex bolts and $\frac{3}{8}$ " lock washers, secure the table/trunnion assembly to the sander base as shown in **Figure 8**.

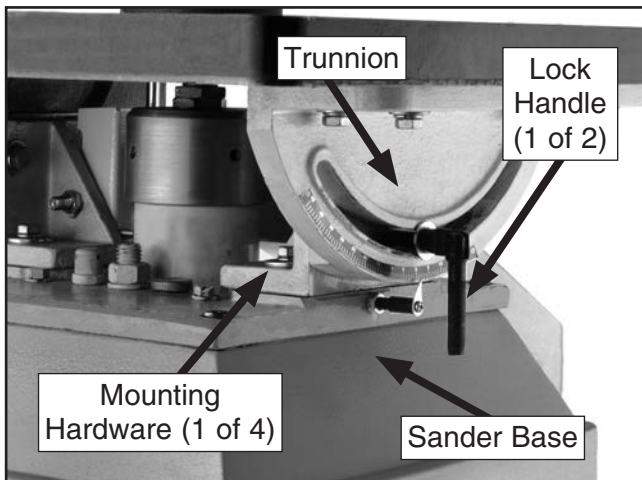


Figure 8. Table mounting.

4. Secure the dust chute to the trunnion assembly with (2) $\frac{3}{8}$ "-16 x $1\frac{1}{2}$ " hex bolts, $\frac{3}{8}$ " lock washers and $\frac{3}{8}$ "-16 hex nuts (see **Figure 9**).

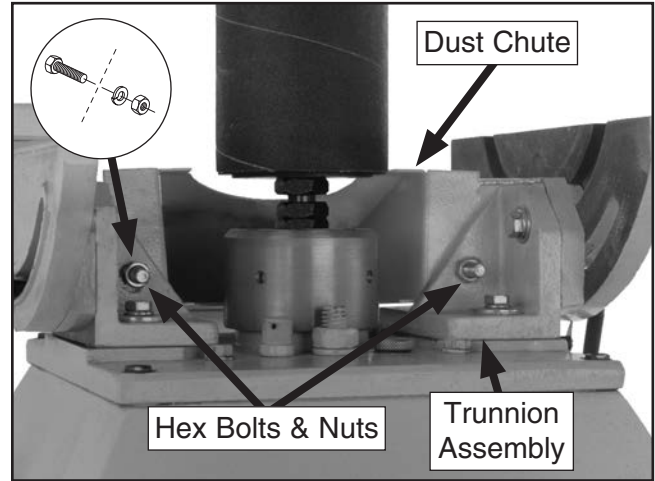


Figure 9. Dust chute.

5. Thread the table stop bolt and jam nut into the sander base, as shown in **Figure 10**.

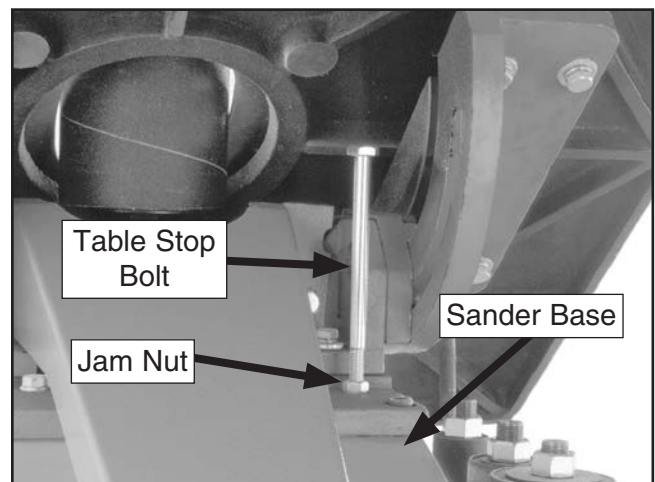


Figure 10. Table stop bolt.

6. Loosen the table lock handles located on each side of the table trunnion assembly (see **Figure 8**).

7. Using a machinist square, bring the table surface square to the spindle surface as shown in **Figure 11**.

Note: It may be necessary to thread the table stop bolt further into the base in order to make the table square to the spindle.

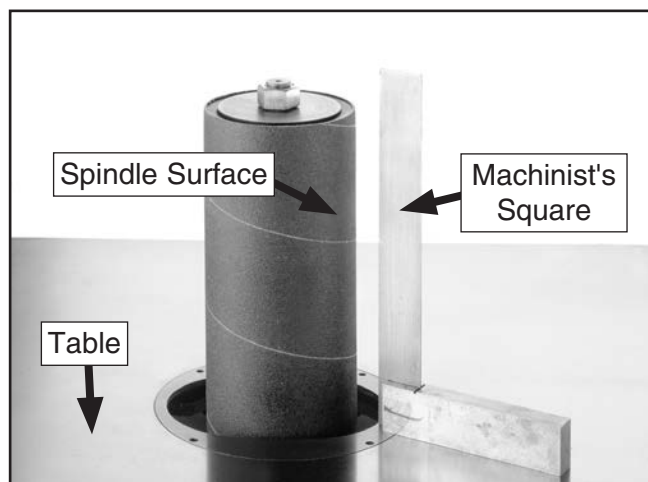


Figure 11. Checking table for square.

8. Move the square to various points around the table to ensure the table and spindle are square on all sides. Adjust the stop bolt as necessary until the table rests on the stop bolt and is square with the spindle (see **Figure 12**).

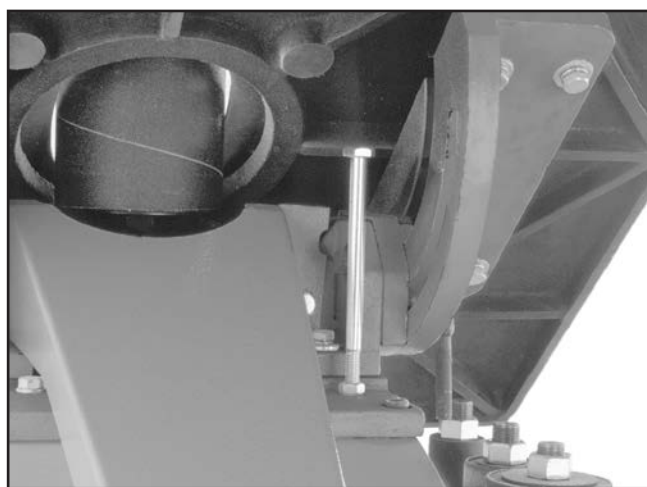


Figure 12. Table stop bolt (table tilted for clarity).

9. Tighten both table lock handles when you are satisfied with the position of the table.
10. Loosen the retainer screw (see **Figure 13**) that secures the scale pointer and adjust the scale pointer to read 0°. Re-tighten the retainer screw.

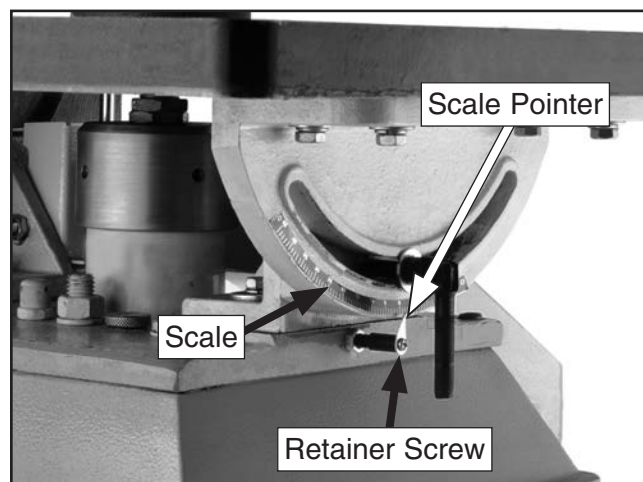


Figure 13. Pointer adjustment.

11. Re-tighten the jam nut to secure the table stop bolt (see **Figure 12**).
12. Insert one 5 x 28 roll pin into the non-threaded hole in each of the three table inserts, as shown in **Figure 14**. Make sure it does not extend through the surface of the table insert.

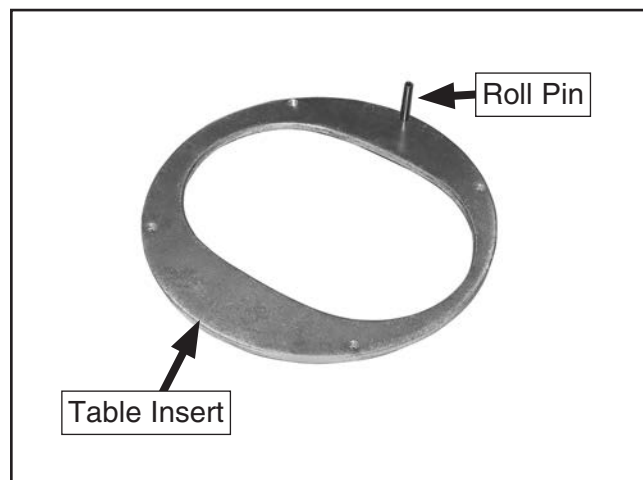


Figure 14. Inserting roll pins (bottom view).



13. Thread four of the $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " set screws into the threaded holes on each table insert, as shown in **Figure 15**.

Note: The roll pins and set screws must not protrude above the top surface of the table insert or they will interfere with sanding operations.

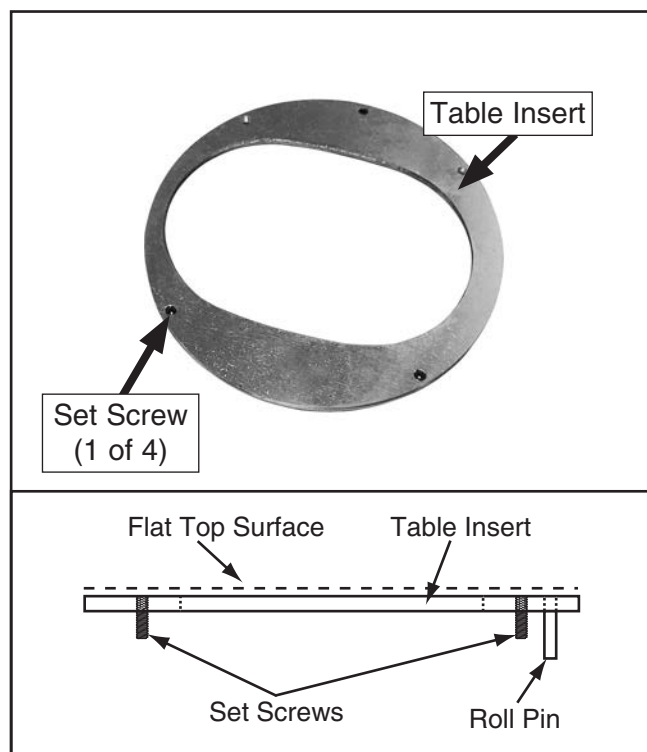


Figure 15. Inserting set screws.

Check Gearbox Oil



It is critical that you make sure there is oil in the gearbox before proceeding with the test run. Remove the spindle gearbox oil fill cap and use the dipstick to make sure the oil level is full. When full, the oil will read on the knurled portion of the dipstick.

Refer to **Gearbox Oil** on **Page 28** for more information on gearbox lubrication, which type of oil to use, how much to use, and where to put it.

After first two hours of operation, perform an oil change as described in the **Gearbox Oil** on **Page 28**.



Test Run

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

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

The Test Run consists of verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the switch disabling key disables the switch properly.

WARNING

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

WARNING

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

To test run the machine:

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

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

4. Remove switch disabling key, as shown in **Figure 16**.

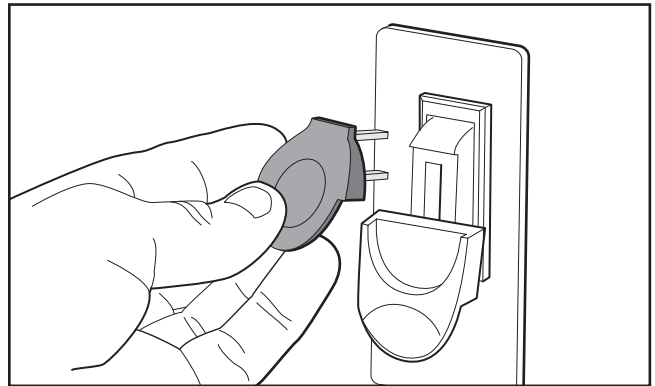


Figure 16. Removing switch key from paddle switch.

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

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

—If the machine *does start*, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

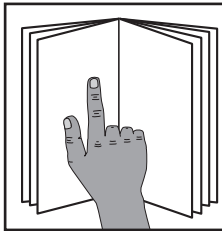


SECTION 4: OPERATIONS

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.

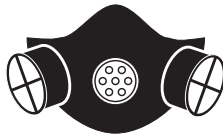


WARNING

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. If necessary, tilts table to correct angle and locks it in place.
3. Installs sanding spindle assembly. (Refer to **Installing Sanding Spindles** on **Page 21**).
4. Selects table insert best suited to accommodate size of the sanding drum and tilt of the table.
5. Puts on safety glasses and a respirator.
6. Starts oscillating sander.
7. Feeds workpiece against direction of spindle rotation, maintaining a safe working distance between hands and sanding drum.
8. Turns machine **OFF**.



Disabling Switch

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

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

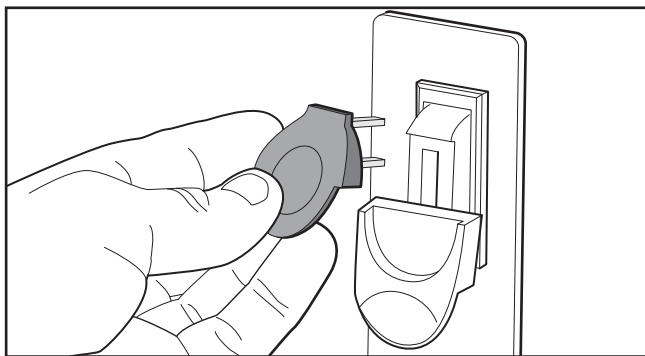


Figure 17. Disabling switch by removing key.

WARNING

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

Stock Inspection

Follow these rules when choosing stock:

- **DO NOT sand stock that contains large or loose knots.** Injury to the operator or damage to the workpiece can occur if a knot becomes dislodged during the sanding operation.
- **Remove foreign objects from the workpiece.** Make sure that any stock you process with the sander is clean and free of dirt, nails, staples, tiny rocks or any other foreign objects that could damage the sanding belt or eject from the workpiece during sanding.
- **Scrape all glue off the workpiece before sanding.** Glue deposits on the workpiece, hard or soft, can gum up the sanding belt and produce poor results.
- **Only sand the proper material type:** This machine is only intended for sanding workpieces of natural wood fiber. Attempting to sand workpieces of any other material could lead to personal injury and property damage.

Sanding Tips

- Replace the sanding sleeve with a higher grit to achieve a finer finish. Avoid skipping grits, as this will leave scratches in the wood.
- Extend the life of the sanding sleeve by regularly using a PRO-STIK® sanding pad (**Accessories on Page 25**).
- When bevel sanding, make any necessary guide lines on the longer side of the board so they will be visible during sanding.
- Always turn the sander **ON** and allow it to reach full speed before engaging the workpiece with the sanding sleeve.
- Keep your workpiece moving across the sanding sleeve to prevent burns, grooves or ruts in the workpiece surface.



Sanding Spindles

The Model G1071 is supplied with ten rubber sanding spindles. Use the larger diameter spindles for sanding large sweeping curves and the smaller spindles for sanding more intricate curves.

When not in use, the spindles are stored on racks located on each side of the machine base, as shown in **Figure 18**. Each spindle is secured to the rack with a hex nut.



Figure 18. Sanding spindles.

To mount the spindle for sanding:

1. DISCONNECT MACHINE FROM POWER!
2. Determine the spindle size needed.
3. Lubricate the threads and shaft shown in **Figure 19** with a light oil.

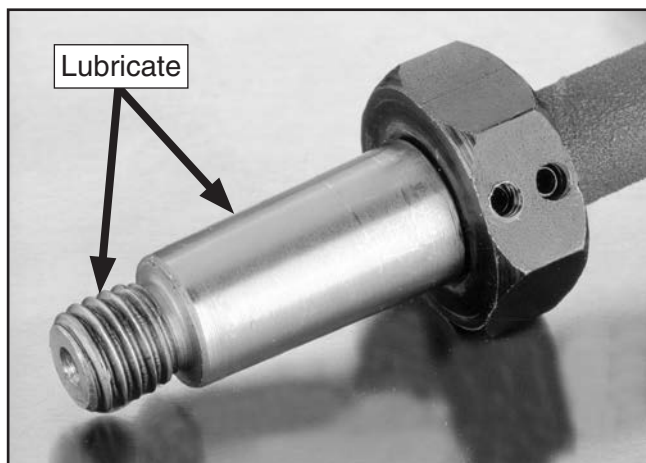


Figure 19. Spindle threads.

4. Insert the threaded end of the spindle shaft into the spindle mounting hole, and screw it down by hand as shown in **Figure 20**.



Figure 20. Mounting spindle.

NOTICE

DO NOT tighten the sanding spindle with a wrench! The sanding action will further tighten the spindle to the sander. Using a wrench could make removal difficult.

To remove the spindle:

1. DISCONNECT MACHINE FROM POWER!
2. Use one of the supplied wrenches to hold the jam nuts stationary while you loosen the spindle retainer nut, and the spindle will back out as it un-threads (see **Figure 21**).

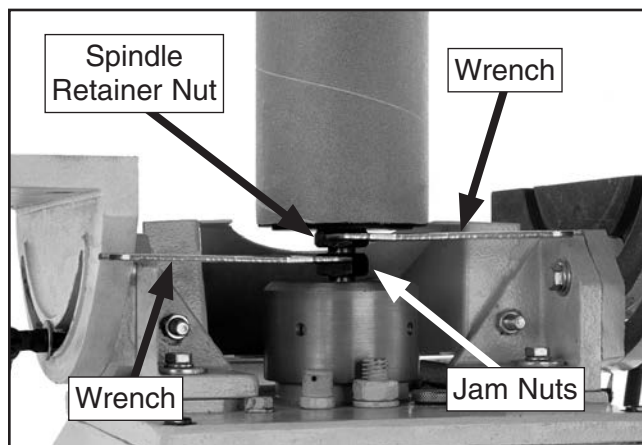


Figure 21. Spindle removal.

Tip: If the spindle has not been removed for some time and is stuck, run the machine until the spindle housing heats up, then retry.



Sanding Sleeves

The Model G1071 is supplied with 10 sanding sleeves. Use coarse grits for fast material removal and a rough finish. Use fine grits for slower material removal and a smoother finish. When changing from a coarse sleeve to a finer sleeve on a particular sanding project, avoid increasing the grit number by intervals of more than 50.

To change the sanding sleeve on spindles larger than $\frac{5}{8}$ ":

1. DISCONNECT MACHINE FROM POWER!
2. Loosen the hex nut located on the top of the spindle as shown in **Figure 22**. The hex nut and flange disk DO NOT need to be removed.

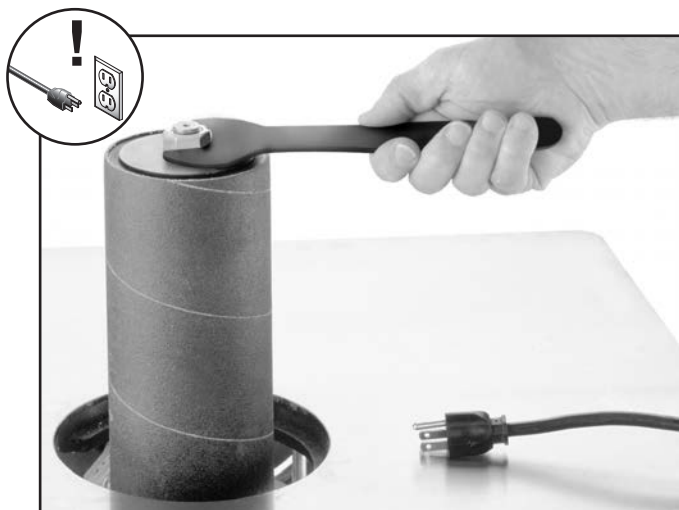


Figure 22. Removing sanding sleeve.

3. Slide the sanding sleeve from the spindle.
4. Reverse **Steps 1–2** to install a sanding sleeve.

To change the sanding sleeve on spindles $\frac{5}{8}$ " and smaller:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen the set screw located in the retainer nut (see **Figure 23**).

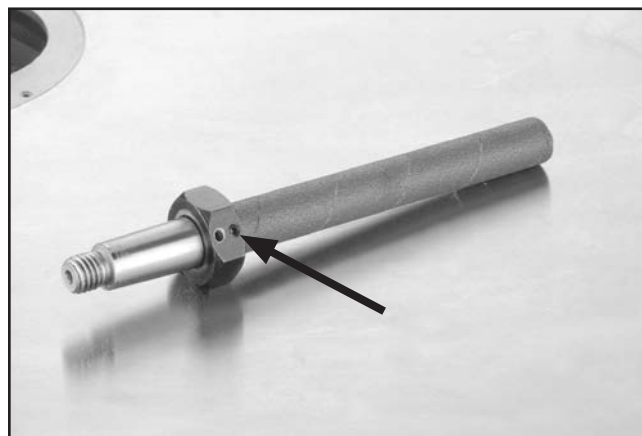


Figure 23. Retainer nut set screw.

3. Slide the sanding sleeve from the spindle.
4. Reverse **Steps 1–2** to install a sanding sleeve.

NOTICE

Monitor the wear on the sanding sleeves. The upper portion of the sanding sleeve often gets very little use. If this is the case, flip the sanding sleeve over and re-install. This allows maximum use of the sleeve. Worn sanding sleeves will not efficiently remove material and can burn the wood.



Table Inserts

The Model G1071 is supplied with three different sized table inserts. The inserts are designed to reduce the gap between the spindle and the table opening. The hole in each insert is oblong to allow clearance when the table is tilted.

NOTICE

Always use the table insert with the smallest opening that still allows at least $\frac{1}{8}$ " clearance around the spindle.

To install the table insert:

1. DISCONNECT MACHINE FROM POWER!
2. Determine which table insert is best for the particular spindle you are using.
3. Install the insert over the mounted spindle and into the recessed hole on the table, as shown in **Figure 24**.



Figure 24. Installing table insert.

Note: The insert is fitted with pins that allow it to fit into the table in only one position. This ensures the table insert will not make contact with the spindle even when the table is tilted.

4. Adjust the set screws shown in **Figure 25** so the top of the insert is flush with the table surface.

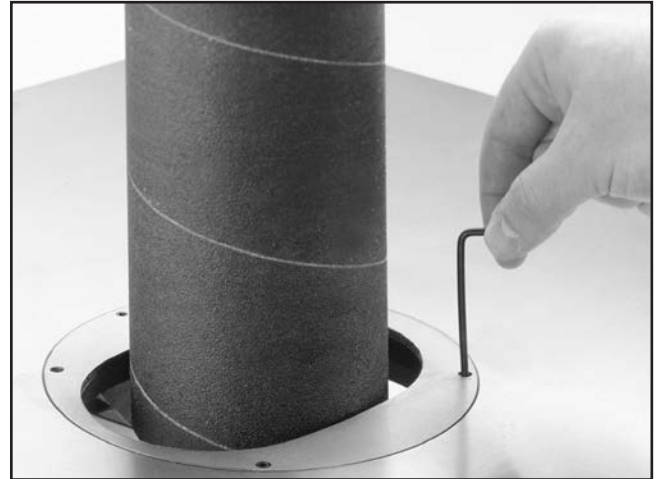


Figure 25. Adjusting table insert.



Bevel Sanding

The Model G1071 has a tilting table to allow bevel sanding at a variety of angles.

NOTICE

Bevel sanding on a spindle sander is NOT an exact science. When the table is tilted to 45°, the actual angle sanded on the edge of a workpiece will change if the workpiece is sanded at different positions around the spindle.

To bevel sand a workpiece:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust the table to the desired angle and secure it into position with the trunnion lock handles shown in **Figure 26**.

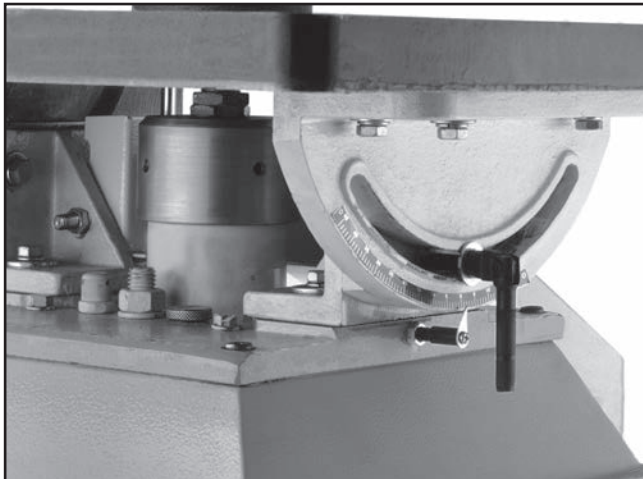


Figure 26. Trunnion lock handle.

3. Rotate the spindle by hand to ensure it does not make contact with the table insert.

When marking the finish line on your workpiece, always mark on the outside, or longest, edge of the bevel, as shown in **Figure 27**. This allows the finish line to be viewed on the top side of the workpiece.

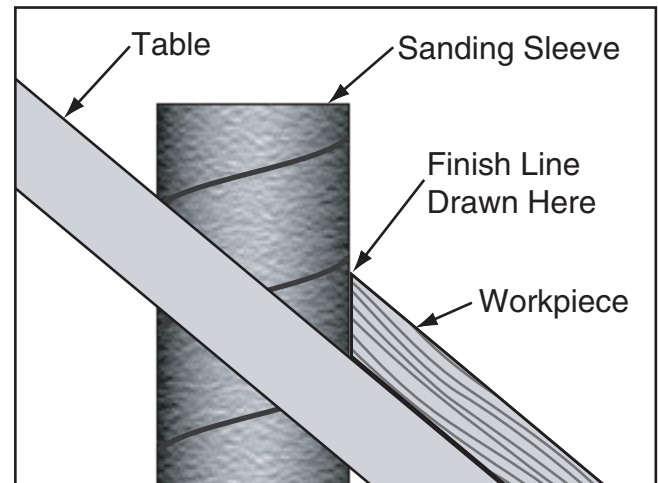


Figure 27. Bevel sanding illustration.



SECTION 5: ACCESSORIES

!WARNING

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

NOTICE

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

Basic Eye Protection

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



Figure 28. Assortment of basic eye protection.

PRO-STIK® Abrasive Surface Cleaners

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

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

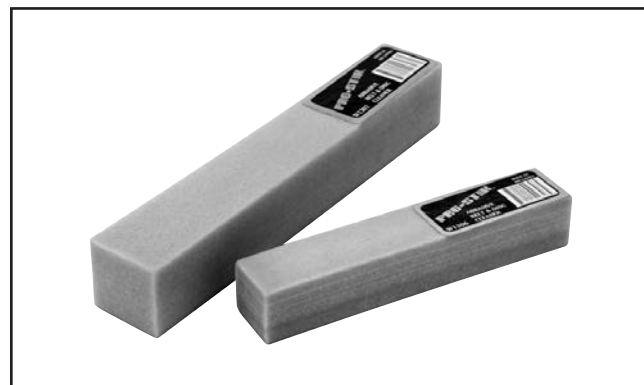


Figure 29. PRO-STIK® abrasive cleaners.

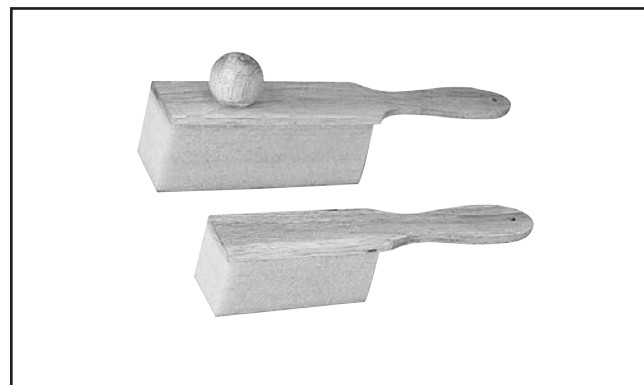


Figure 30. PRO-STIK® cleaners with handles.

order online at www.grizzly.com or call 1-800-523-4777



H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100

Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 31. Half-mask respirator with disposable cartridge filters.

Replacement Sanding Sleeves

A full range of sanding spindles are available for the Model G1071. Visit www.grizzly.com to see them all!



Figure 32. Replacement sanding sleeves.

T10117—Big Mouth Dust Hood with Stand
G2753—4" Bench Attachment
G2754—4" Floor Attachment

These attachments are indispensable for collecting dust at machines without a port. Designed for use with 4" flexible hose (not included).



Figure 33. Dust collection attachments.

order online at www.grizzly.com or call 1-800-523-4777



SECTION 6: MAINTENANCE



Schedule

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

Ongoing

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

- Loose hardware.
- Damaged sanding sleeve.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance:

- Clean/vacuum dust buildup from beneath the table.

Every 1000 hours of use:

- Drain and replace gear oil (**Page 28**).

Cleaning & Protecting

Cleaning the Model G1071 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of quality products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9.

Lubrication

Since all bearings are shielded and permanently lubricated, simply leave them alone until they need to be replaced. Do not lubricate them, as this will only attract dust and result in possible premature bearing failure.

DO NOT oil any exposed areas on the sander. Dust will be attracted to these areas, creating a gummy mixture that will hamper proper movement of components. Instead, lubricate exposed areas with dry, powdered graphite.



Sanding Sleeves

As sanding sleeves are used, they will become "loaded" with saw dust. If not removed, this saw dust will harden on the abrasive surface, greatly reducing the effectiveness of the sanding sleeve. Routinely clean the sanding sleeves with a rubber gum abrasive cleaner such as the PRO-STIK® cleaners shown in **Figure 34**.

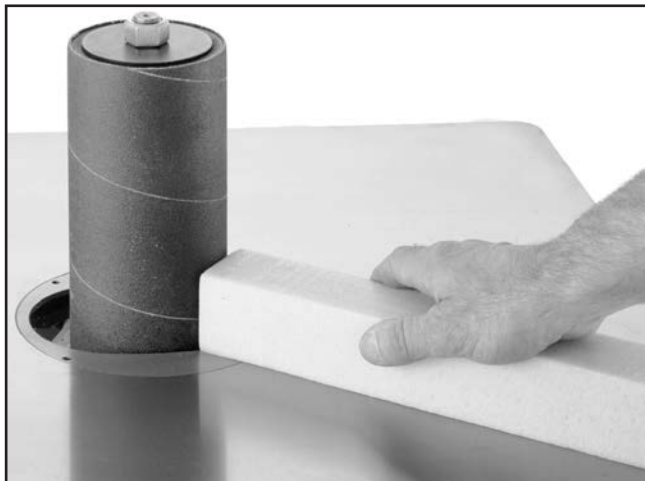


Figure 34. Sanding sleeve maintenance.

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

Gearbox Oil

The spindle gearbox contains 4.5 Qts. of 90 Wt. gear oil. Replace the gear oil after the first two hours of use, and then after approximately every 1000 hours of use. Remove the fill cap first, then drain the gear oil from the drain plug located inside the sander base at the bottom of the gear box (see **Figure 35**). The fill cap is shown in **Figure 36**.

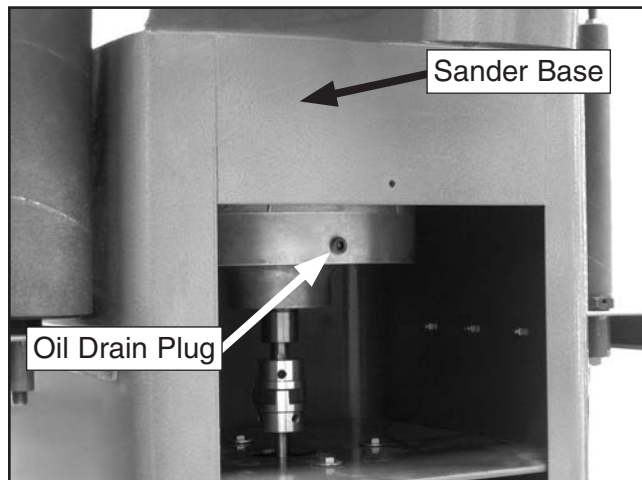


Figure 35. Drain plug location.

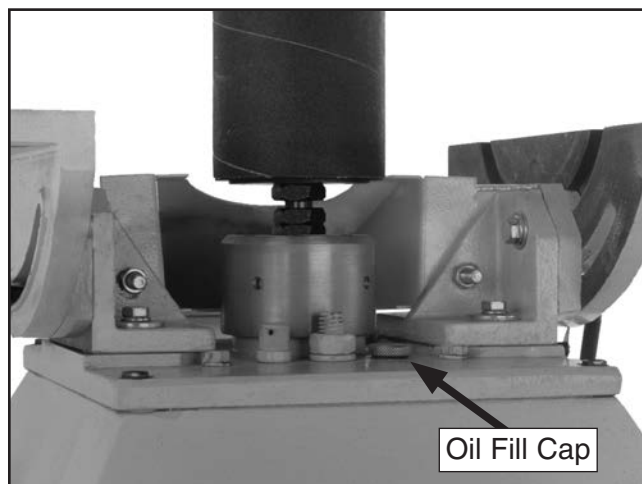


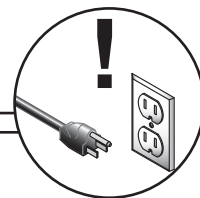
Figure 36. Oil fill cap.



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 a breaker trips.	1. Switch disabling key removed. 2. Power supply switched OFF or at fault. 3. Plug/receptacle at fault/wired wrong. 4. Start capacitor at fault. 5. Motor connection wired wrong. 6. Wall circuit breaker tripped. 7. Wiring open/has high resistance. 8. Motor ON/OFF switch at fault. 9. Motor at fault.	1. Install switch disabling key. 2. Ensure power supply is on/has correct voltage. 3. Test for good contacts; correct the wiring. 4. Test/replace if faulty. 5. Correct motor wiring connections. 6. Ensure circuit size is correct/replace weak breaker. 7. Check/fix broken, disconnected, or corroded wires. 8. Replace switch. 9. Test/repair/replace.
Machine stalls or is underpowered.	1. Feed rate too aggressive. 2. Workpiece material not suitable for machine. 3. Motor wired incorrectly. 4. Plug/receptacle at fault. 5. Motor bearings at fault. 6. Machine undersized for task. 7. Motor overheated. 8. Motor at fault.	1. Decrease feed rate. 2. Only sand wood, ensure moisture is below 20%. 3. Wire motor correctly. 4. Test for good contacts/correct wiring. 5. Test/repair/replace. 6. Clean/replace sandpaper; reduce feed rate/sanding depth. 7. Clean motor, let cool, and reduce workload. 8. Test/repair/replace.
Motor Overheats	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean off motor to provide normal air circulation.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor fan rubbing on fan cover. 3. Motor bearings at fault. 4. Gearbox is damaged.	1. Inspect/replace damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Fix/replace fan cover; replace loose/damaged fan. 3. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 4. Inspect and repair/replace.



Sanding Operations

Symptom	Possible Cause	Possible Solution
Deep sanding grooves or scars in workpiece.	1. Sanding sleeve too coarse for the desired finish. 2. Workpiece sanded across the grain. 3. Too much sanding force on workpiece.	1. Use a finer grit sanding sleeve. 2. Sand with the grain. 3. Reduce pressure on workpiece while sanding.
Grains rub off the sanding sleeve.	1. Sanding sleeve has been stored in an incorrect environment. 2. Sanding sleeve has been folded or smashed.	1. Store sanding sleeve away from extremely temperature and humidity. 2. Store sanding sleeves separately and not folded or flat.
Sanding surfaces clog quickly or burn.	1. Too much pressure against sleeve. 2. Sanding softwood.	1. Reduce pressure on workpiece while sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/replacing belts frequently.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

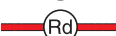
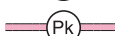
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

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

COLOR KEY

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



Wiring Diagram

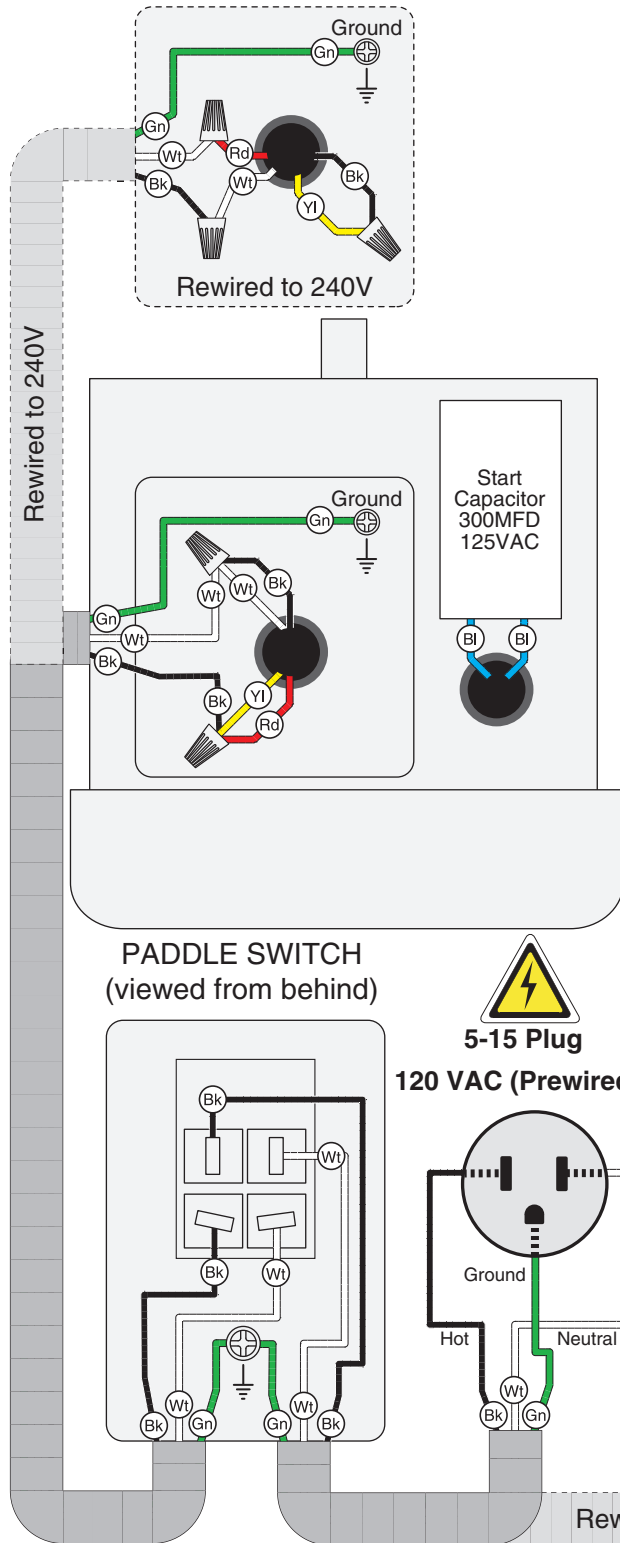


Figure 37. Motor wiring.



Figure 38. Switch wiring.

View this page in color at www.grizzly.com.

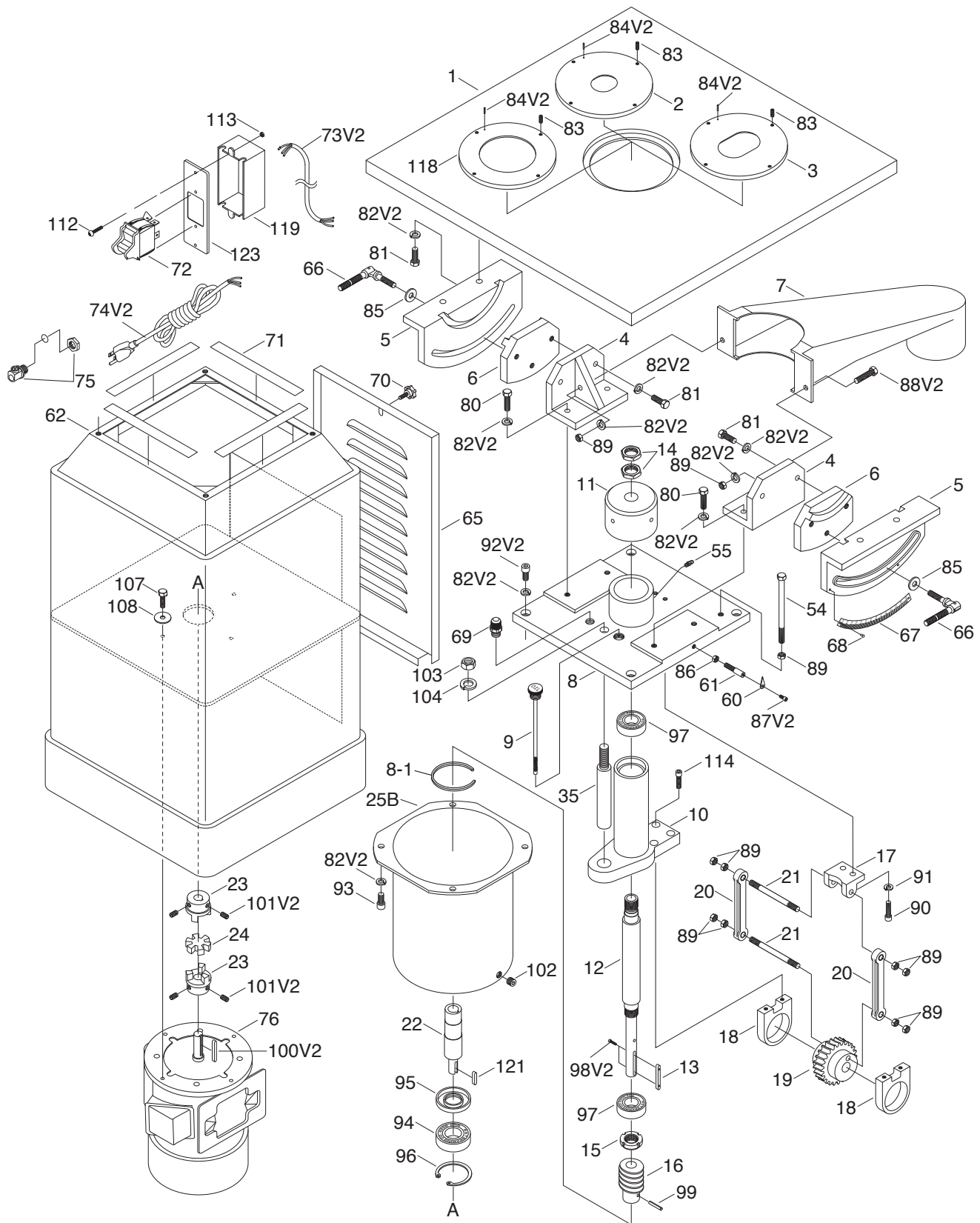
NOTICE

The motor wiring shown here is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.



SECTION 9: PARTS

Main



Main Parts List

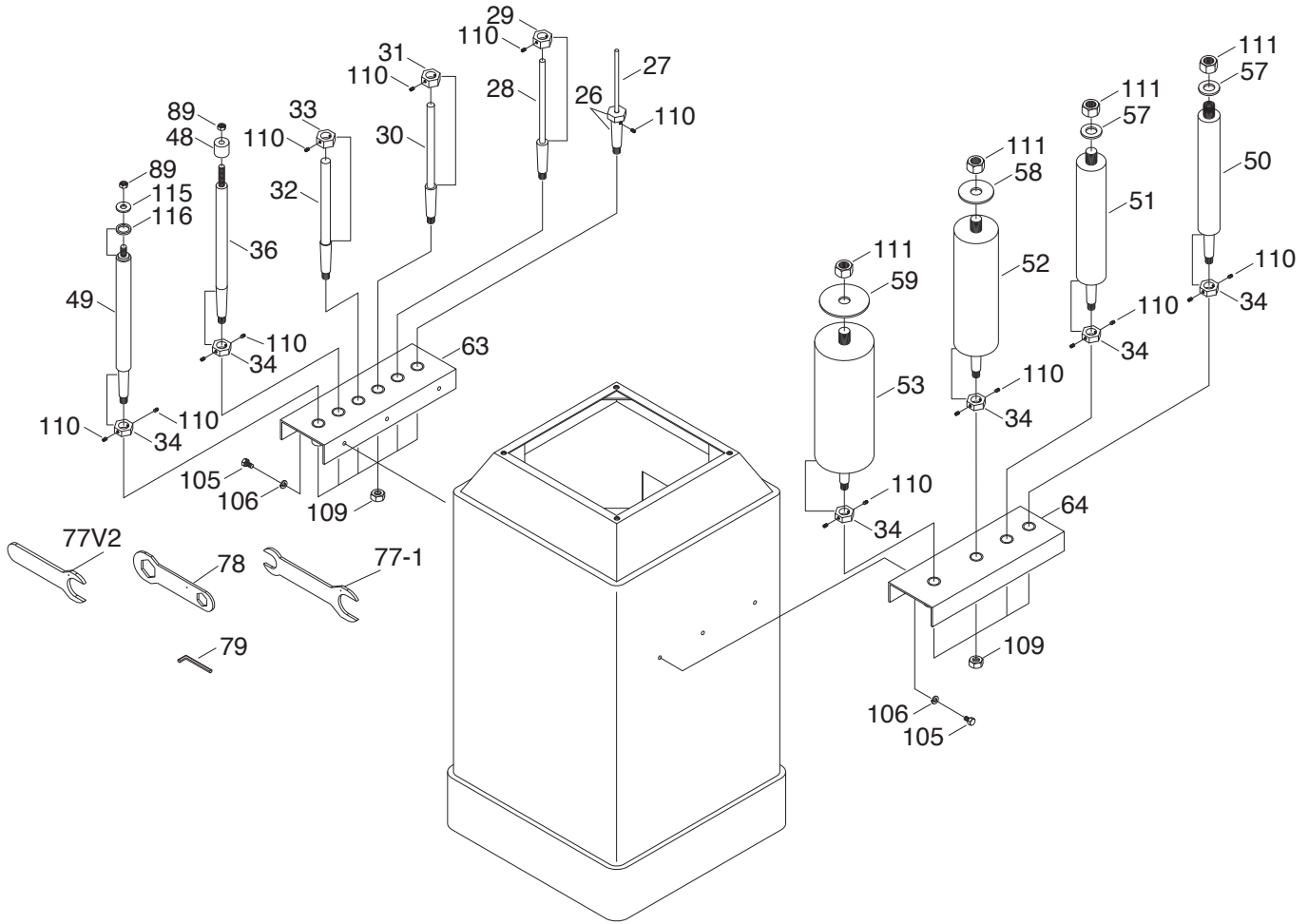
REF	PART #	DESCRIPTION
1	P1071001	TABLE
2	P1071002	INSERT 1-3/4 X 2-3/16
3	P1071003	INSERT 2-3/16 X 3-1/2
4	P1071004	BRACKET
5	P1071005	TRUNNION
6	P1071006	INNER TRUNNION
7	P1071007	DUST HOOD
8	P1071008	HOUSING CASTING
8-1	P1071008-1	RUBBER STRIP
9	P1071009	DIPSTICK
10	P1071010	SPINDLE CASTING
11	P1071011	COVER
12	P1071012	SPINDLE
13	P1071013	SPINDLE KEY 5 X 5 X 50
14	P1071014	JAM NUT 15/16-20
15	P1071015	SPANNER NUT 15/16-20
16	P1071016	WORM
17	P1071017	MOUNTING BRACKET
18	P1071018	BEARING BLOCK
19	P1071019	WORM GEAR 24T
20	P1071020	CONNECTING ROD
21	P1071021	WRIST PIN
22	P1071022	DRIVE SHAFT
23	P1071023	HUB
24	P1071024	CENTER BLOCK
25B	P1071025B	CASE V2.11.98
35	P1071035	GUIDE SHAFT
54	P1071054	HEX BOLT 3/8-16 X 6-1/2
55	P1071055	GREASE FITTING M6-1 X 5
61	P1071061	POINTER MOUNT
62	P1071062	CABINET
65	P1071065	DOOR
66	P1071066	LOCK HANDLE
67	P1071067	SCALE
68	P1071068	RIVET 2 X 5MM NAMEPLATE, STEEL
69	P1071069	OIL BREATHER
70	P1071070	KNOB
71	P1071071	GASKET
72	P1071072	TOGGLE SAFETY SWITCH

REF	PART #	DESCRIPTION
73V2	P1071073V2	MOTOR CORD 16G 3W 30" V2.11.10
74V2	P1071074V2	POWER CORD 16G 3W 12' 5-15P V2.11.10
75	P1071075	STRAIN RELIEF M15 TYPE-2
76	P1071076	MOTOR 1HP 120/240V 1-PH
80	P1071080	HEX BOLT 3/8-16 X 1-1/4
81	P1071081	HEX BOLT 3/8-16 X 1
82V2	P1071082V2	LOCK WASHER 10MM
83	P1071083	SET SCREW 1/4-20 X 1/2
84V2	P1071084V2	ROLL PIN 5 X 28
85	P1071085	FLAT WASHER 3/8
86	P1071086	HEX NUT 5/16-18
87V2	P1071087V2	PHLP HD SCR 6-32 X 1/4
88V2	P1071088V2	HEX BOLT 3/8-16 X 1-1/4
89	P1071089	HEX NUT 3/8-16
90	P1071090	CAP SCREW 5/16-18 X 1
91	P1071091	LOCK WASHER 5/16
92V2	P1071092V2	CAP SCREW 3/8-16 X 1
93	P1071093	CAP SCREW 3/8-16 X 3/4
94	P1071094	BALL BEARING 6206ZZ
95	P1071095	SEAL 30-62-8
96	P1071096	INT RETAINING RING 62MM
97	P1071097	BALL BEARING 6205ZZ
98V2	P1071098V2	CAP SCREW #4-40 X 1/2 V2.04.09
99	P1071099	ROLL PIN 5 X 30
100V2	P1071100V2	KEY 5 X 5 X 25
101V2	P1071101V2	SET SCREW 5/16-18 X 3/8
102	P1071102	OIL DRAIN PLUG
103	P1071103	HEX NUT 5/8-11
104	P1071104	LOCK WASHER 5/8
107	P1071107	HEX BOLT 5/16-18 X 1
108	P1071108	FENDER WASHER 5/16
112	P1071112	PHLP HD SCR 10-24 X 1
113	P1071113	HEX NUT 10-24
114	P1071114	CAP SCREW 5/16-18 X 1
118	P1071118	INSERT 4-1/4 X 6
119	P1071119	DUST COVER
121	P1071121	KEY 5 X 5 X 24
123	P1071123	MOUNTING PLATE

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.



Base

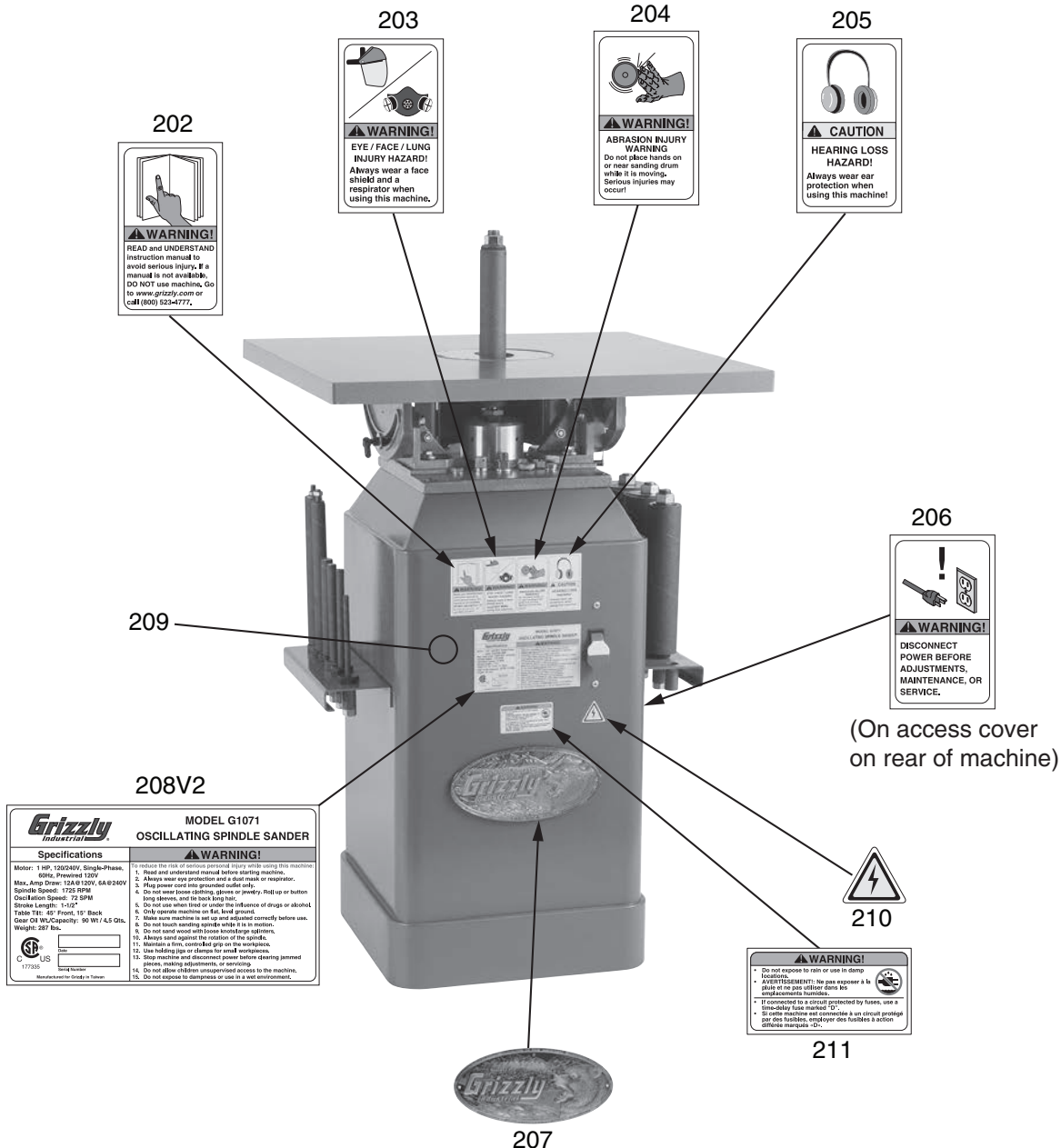


REF	PART #	DESCRIPTION
26	P1071026	ARBOR
27	P1071027	SPINDLE 1/4"
28	P1071028	SPINDLE 3/8"
29	P1071029	RETAINER
30	P1071030	SPINDLE 1/2"
31	P1071031	RETAINER
32	P1071032	SPINDLE 5/8"
33	P1071033	RETAINER
34	P1071034	RETAINER
36	P1071036	SPINDLE 3/4"
48	P1071048	GROMMET 19 X 9MM PLASTIC
49	P1071049	SPINDLE 1"
50	P1071050	SPINDLE 1-1/2"
51	P1071051	SPINDLE 2"
52	P1071052	SPINDLE 3"
53	P1071053	SPINDLE 4"

REF	PART #	DESCRIPTION
57	P1071057	WASHER 36 X 19 X 3MM
58	P1071058	FLAT WASHER 18MM
59	P1071059	FLAT WASHER 18MM
63	P1071063	SPINDLE HOLDER
64	P1071064	SPINDLE HOLDER
77V2	P1071077V2	FLAT WRENCH 1-1/8 V2.01.02
77-1	P1071077-1	FLAT COMBO WRENCH 7/8 X 1-1/4 V2.01.02
78	P1071078	FLAT COMBO SPINDLE WRENCH 1 X 3/4
79	P1071079	HEX WRENCH 2MM
89	P1071089	HEX NUT 3/8-16
105	P1071105	HEX BOLT 1/4-20 X 1/2
106	P1071106	LOCK WASHER 1/4
110	P1071110	SET SCREW 10-24 X 1/4
111	P1071111	HEX NUT 3/4-16
115	P1071115	FLAT WASHER 3/8
116	P1071116	SPACER



Labels & Cosmetics



REF	PART #	DESCRIPTION
202	P1071202	READ MANUAL LABEL
203	P1071203	FACE SHIELD RESPIRATOR LABEL
204	P1071204	SANDING DRUM INJURY LABEL
205	P1071205	HEARING PROTECTION LABEL
206	P1071206	DISCONNECT POWER LABEL

REF	PART #	DESCRIPTION
207	P1071207	GRIZZLY NAMEPLATE-LARGE
208V2	P1071208V2	MACHINE ID LABEL V2.11.10
209	P1071209	TOUCH-UP PAINT, GRIZZLY GREEN
210	P10712010	ELECTRICITY LABEL
211	P1071211	DAMPNESS HAZARD LABEL

WARNING

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



WARRANTY & RETURNS

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

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

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

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

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

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

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





Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!
~Since 1983~

*Visit Our Website Today For
Current Specials!*

**ORDER
24 HOURS A DAY!
1-800-523-4777**

