MODEL G0458
18" OPEN-END DRUM SANDER
OWNER'S MANUAL

(FOR MODELS MANUFACTURED SINCE 11/16) #TRCREWPCBL7423 PRINTED IN CHINA V5.01.18

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

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INTRODUCTION

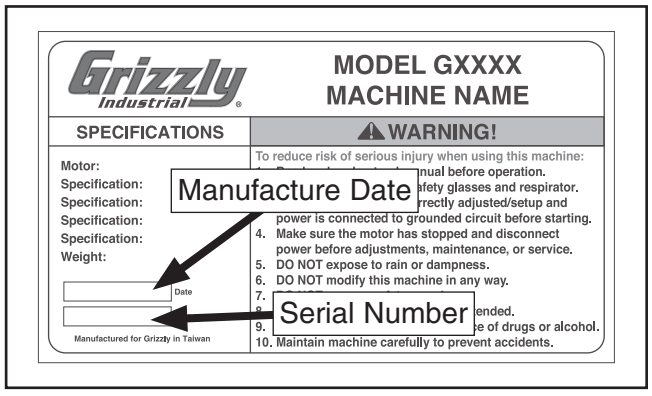
Manual Accuracy

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.



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

Identification

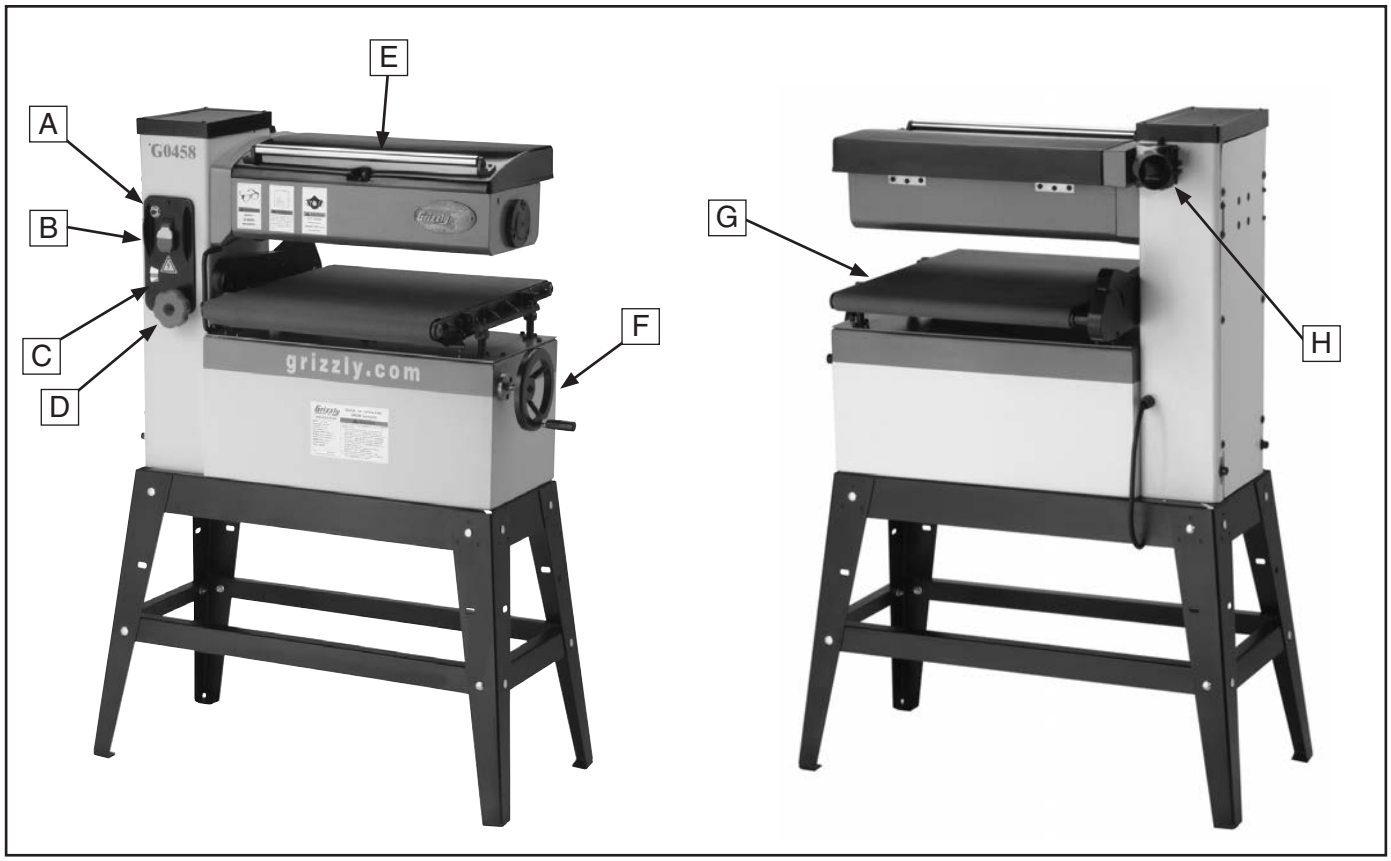


Figure 1. Main controls/components of the sander.

- **A.** Circuit Breaker
- **B.** ON/OFF Switch w/Lockout Key
- **C.** Feed Speed Scale
- **D.** Variable Speed Feed Rate Knob
- **E.** Return Roller
- **F.** Table Height Adjustment Handwheel
- **G.** Feed Belt
- **H.** Dust Port

MACHINE DATA SHEET

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

MODEL G0458 18" 1-1/2 HP SINGLE-PHASE OPEN END DRUM SANDER

Product Dimensions:

Weight	252 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	35 x 24 x 50 in.
Footprint (Length x Width)	35 x 17 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	300 lbs.
Length x Width x Height	25 x 33 x 33 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	110V, Single-Phase, 60 Hz
Prewired Voltage	110V
Full-Load Current Rating	11.5A
Minimum Circuit Size	20A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	6-1/2 ft.
Power Cord Gauge	14 AWG
Plug Included	Yes
Included Plug Type	5-15
Switch Type	Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower	1.5 HP
Phase	Single-Phase
Amps	11.5A
Speed	3460 RPM
Type	ODP Capacitor-Start Induction
Power Transfer	V-Belt Drive
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Number of Sanding Heads	1
Maximum Board Width	36 in.
Minimum Board Width	1 in.
Maximum Board Thickness	4-1/2 in.
Minimum Board Thickness	1/8 in.
Minimum Board Length	6 in.
Sandpaper Speed	4000 FPM
Conveyor Feed Rate	2 – 12 FPM
Sandpaper Length	84 in.
Sandpaper Width	3 in.

Drum Information

Infeed Sanding Drum Type..... Aluminum
Infeed Sanding Drum Size..... 4 in.

Construction

Conveyor Belt..... Sandpaper
Body..... Steel
Base..... Steel
Paint Type/Finish..... Powder Coated

Other Related Information

Floor To Table Height..... 35–40 in.
Sanding Belt Tension..... Spring Loaded
Conveyor Belt Length..... 44-1/2 in.
Conveyor Belt Width..... 18 in.
Belt Roller Size..... 1-1/2 in.
Number of Dust Ports..... 1
Dust Port Size..... 2-1/2 in.

Other Specifications:

Country of Origin ..... China
Warranty ..... 1 Year
Approximate Assembly & Setup Time ..... 1-1/2 Hours
Serial Number Location ..... ID Label
ISO 9001 Factory ..... No
Certified by a Nationally Recognized Testing Laboratory (NRTL) ..... No

Features:

Spring-Loaded Sanding Belt Tension
Sandpaper Conveyor Belt
2-1/2" Dust Port
Variable Speed Conveyor
V-Belt Motor Drive
4" Aluminum Sanding Drum
Green and Putty Powder Coated Paint
Stand Alone Dust Collection with Dust Bag
Stationary Drum Headstock
Board Return Roller
Safety Switch
Easy Access for Sandpaper Changes

SECTION 1: SAFETY

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

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

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

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

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

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

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.

⚠WARNING
Additional Safety for Drum Sanders

FEEDING STOCK. Do not allow anyone to stand in the path of the workpiece at the outfeed end when feeding your stock. Never sand more than one piece of stock at a time. Do not jam the workpiece into the machine during operation. Firmly grasp the workpiece in both hands and ease it into the machine using light pressure.

MINIMUM STOCK DIMENSIONS. Do not sand any stock thinner than ⅛", narrower than ⅛", or shorter than 6". Do not sand thin stock by using a "dummy" board under your workpiece.

CLOTHING. Do not wear loose clothing while operating this machine. Roll up or button sleeves at the cuff.

HAND PROTECTION. Do not place hands near, or in contact with, sanding drums during operation. Do not allow fingers to get pinched between board and conveyor belt during operation. This may pull the operator's hand into the machine and cause serious injury!

INSPECTING WORKPIECES. Always inspect workpiece for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.

DUST COLLECTION SYSTEM. Never operate the sander without an adequate dust collection system in place and running.

UNATTENDED OPERATION. Never leave the machine running unattended.

REPLACING SANDING PAPER. Replace sanding paper when it becomes worn.

EXPERIENCING DIFFICULTIES. Any problem, with the exception of conveyor belt tracking that is concerned with any moving parts or accessories, must be investigated and corrected with the power disconnected, and after all moving parts have come to a complete stop.

MAINTENANCE AND ADJUSTMENTS. Never attempt to adjust conveyor belt tracking when the sanding drums are engaged. Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.

RESPIRATOR AND SAFETY GLASSES. Always wear a respirator and safety glasses while operating the machine. Dust and chips are created when sanding. Some debris will be ejected, becoming hazards to the eyes and lungs.

⚠WARNING

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

⚠CAUTION

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 110V... 11.5 Amps

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

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

Circuit 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/120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps

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!

⚠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.

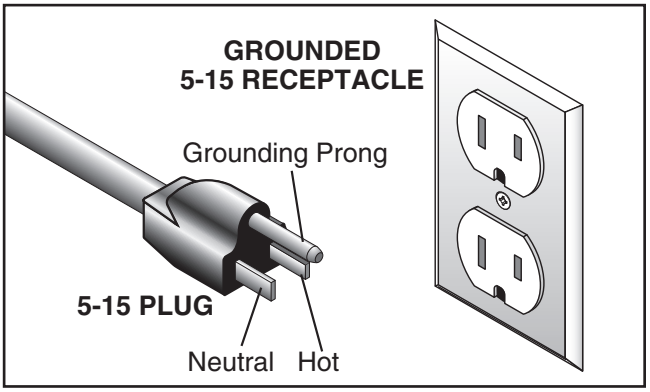
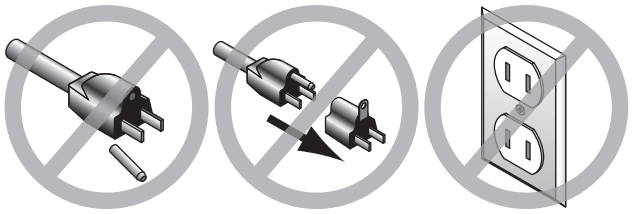


Figure 2. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

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

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

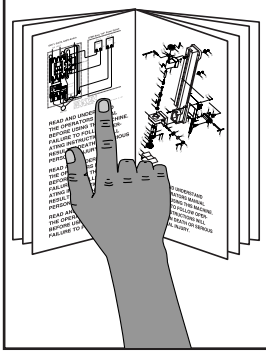
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

SECTION 3: SETUP



⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire set up process!

⚠WARNING

The Model G0458 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Needed for Setup

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

Description	Qty
• Safety Glasses (for each person)	1
• Assistants	2
• Wrench or Socket 13mm	1
• Wrench or Socket 14mm	2
• Hex Wrench 4mm	2
• Phillips Head Screwdriver	1
• Wood Blocks	(three 2x4s)
• Wood Shims	(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.*

⚠WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

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: (Figures 3 & 4) Qty

A. Drum Sander 1

Figure 3. Box Contents.

B. Dust Bag 1
C. Dust Hose Clamp 1
D. Dust Port 1
E. Stand Legs 4
F. Bottom Long Brackets 2
G. Top Long Brackets 2
H. Bottom Short Brackets 2
I. Top Short Brackets 2

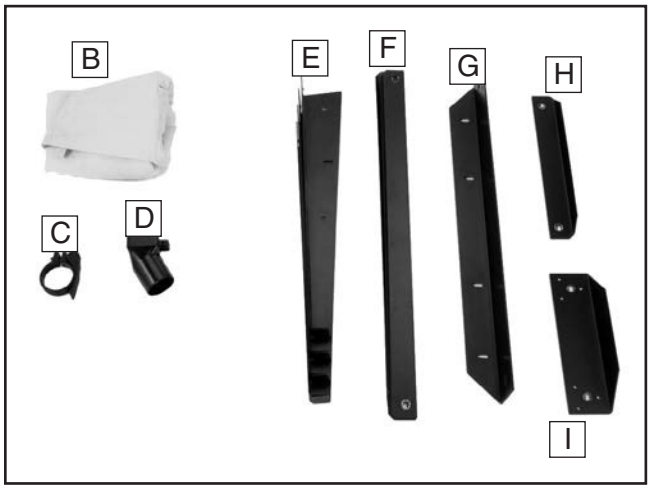


Figure 4. Additional box contents.

J. Hardware and Tools (Not Shown)
— Handwheel 1
— Handwheel Handle M10-1.5 1
— Phillips Head Screw M6-1 x 25 1
— Flat Washer 5mm 1
— Hex Bolt M8-1.25 x 20 4
— Hex Nut M8-1.25 4
— Flat Washer 8mm 8
— Carriage Bolt M8-1.25 x 15 24
— Serrated Flange Nut M8-1.25 24
— Combination Wrench 8/12mm 1
— Hex Wrenches 4, 5, 6mm ..... 1 ea

NOTICE

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

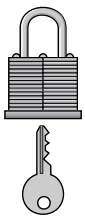
Site Considerations

Weight Load

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

Space Allocation

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



⚠CAUTION

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

Physical Environment

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

Electrical Installation

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

Lighting

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

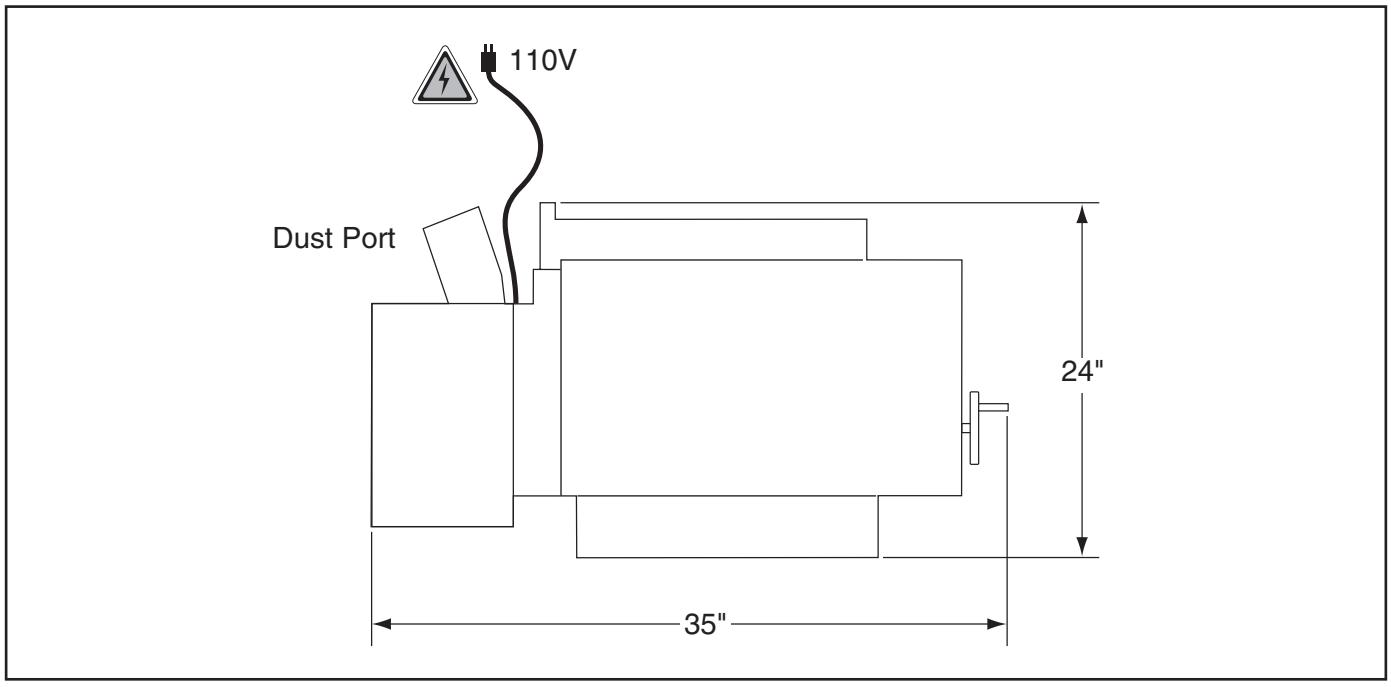


Figure 5. Minimum working clearances.

Assembly

We recommend assembling the stand upside down. To make it easier, have an assistant hold the pieces while you assemble the stand.

NOTICE

Do not final tighten stand bolts until the stand components have been assembled.

To assemble the machine:

1. Mount a top and bottom long bracket to a stand leg and loosely secure with two M8-1.25 x 15 carriage bolts and serrated flange nuts as shown in **Figure 6**.

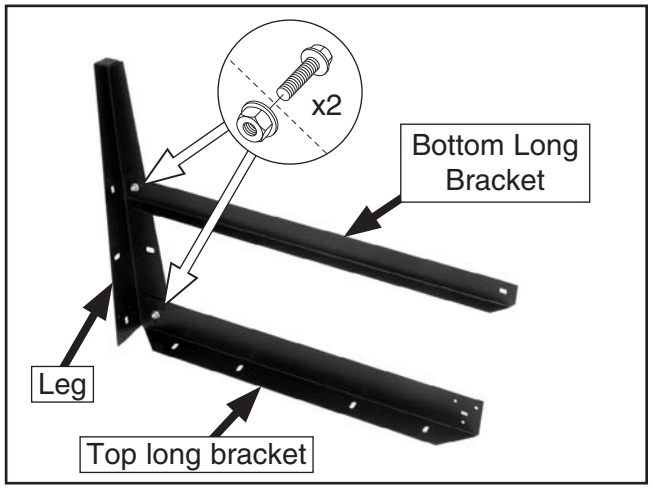


Figure 6. Top and bottom long brackets secured to a stand leg.

2. Secure a second leg to the top and bottom long brackets with two M8-1.25 x 15 carriage bolts and serrated flange nuts as shown in **Figure 7**.

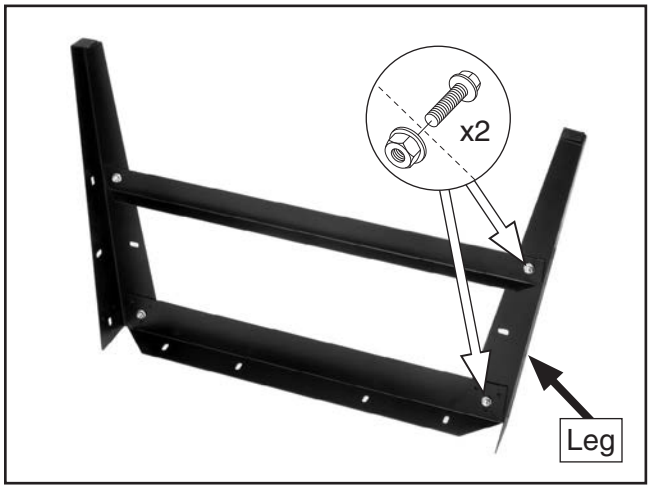


Figure 7. A completed stand leg assembly.

3. Mount a top and bottom short bracket to the left and right sides of the stand leg assembly completed in **Step 2** as shown in **Figure 8**. Secure with two M8-1.25 x 15 carriage bolts and serrated flange nuts.

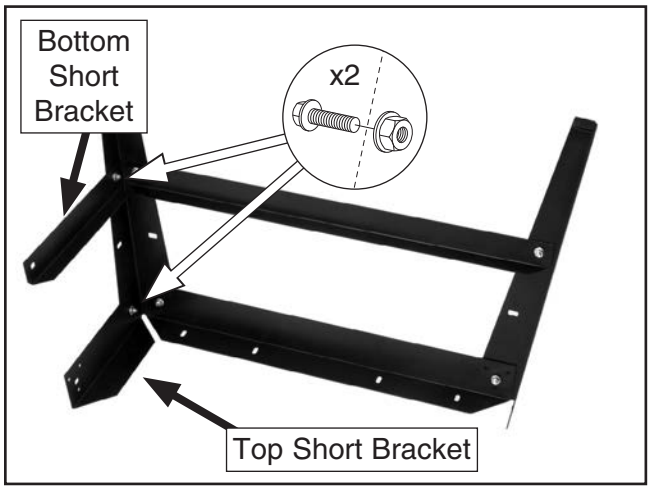


Figure 8. Top and bottom short brackets secured to a stand leg assembly.

4. Build the rest of the stand assembly, as shown in **Figure 9**, with the remaining hardware.

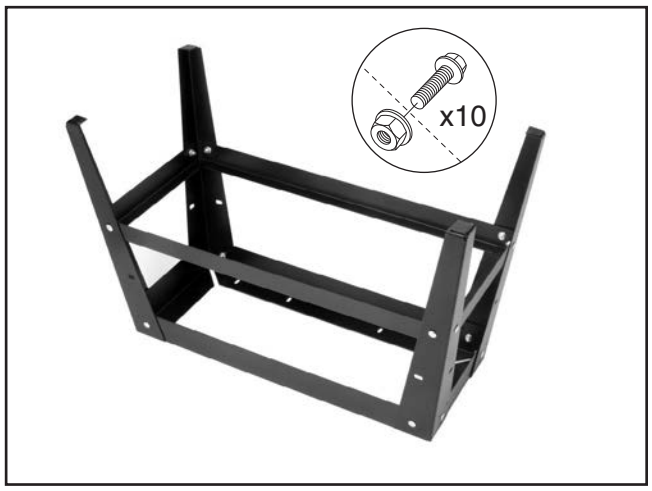


Figure 9. Completed stand assembly.

5. Turn the stand upright and adjust it so the legs are evenly positioned, then tighten all the stand fasteners.

⚠WARNING

The sander is very heavy. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

6. Make sure the sander is still resting on the shipping pallet.

7. Place the pallet and stand near the permanent mounting location (once the sander is mounted to the stand it will be difficult to move).

8. With help of an assistant, tilt the sander back so the side with pulley cover faces the pallet, move the left bottom edge of the sander forward, and rest the left side of the sander on the pallet as shown in **Figure 10.**

   Note: *The base should stick out a few inches beyond the edge of the pallet.*

Figure 10. Sander tipped back on pallet against pulley cover.

9. Place two stacks of blocks the same height as the pallet and about 15 inches apart on the floor near the sander base as shown in **Figure 11**.

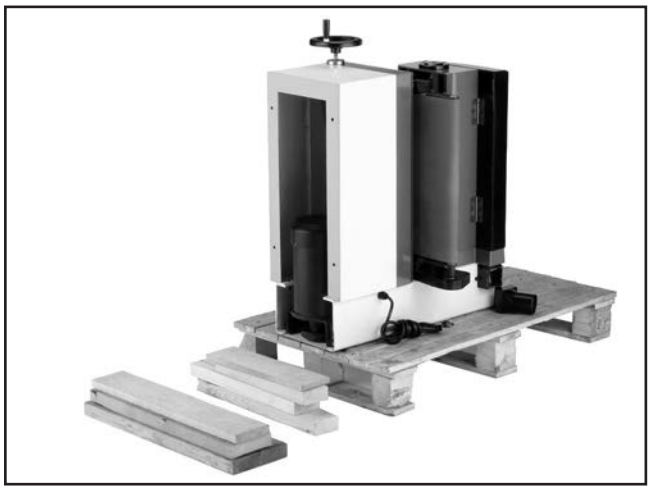


Figure 11. Blocks set near sander base.

10. Lay the stand on the blocks as shown in **Figure 12**.

Figure 12. Stand resting on blocks.

11. Align the holes, and secure the stand to the sander with the remaining hex bolts, washers, and hex nuts (**Figure 13**).

Note: *If the holes do not align, add wood shims to adjust the block heights.*

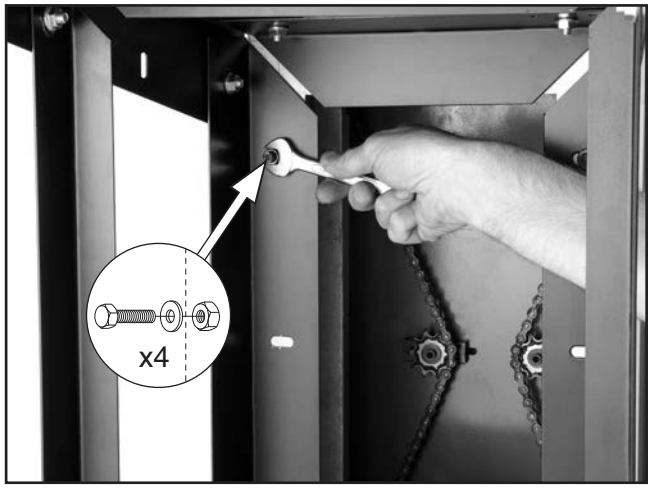


Figure 13. Mounting sander to stand.

12. Lift up on the stand and remove the blocks.

13. Tighten the mounting bolts.

14. Tilt the sander upright, as shown in **Figure 14,** so the rear legs touch the floor.

⚠CAUTION

If the legs start to slide when tilting, you MUST have a third person hold the stand from sliding to avoid personal injury or machine damage!

Figure 14. Tilting sander upright.

15. Thread the handwheel handle into the handwheel and tighten it.

16. Slide the handwheel over the shaft, making sure the shaft pin (**Figure 15**) inserts into the slots in the handwheel.

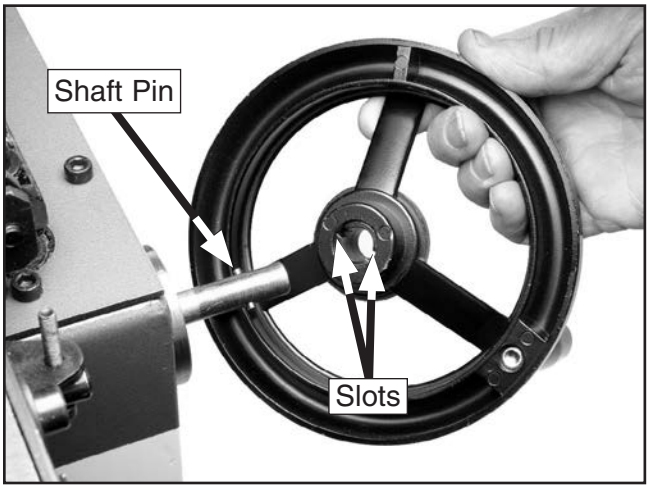


Figure 15. Installing handwheel.

17. Secure the handwheel with an M5-.8 x 10 cap screw and 5mm flat washer.

18. Slide the dust port over the fan housing and tighten the included Phillips head screw (**Figure 16**).

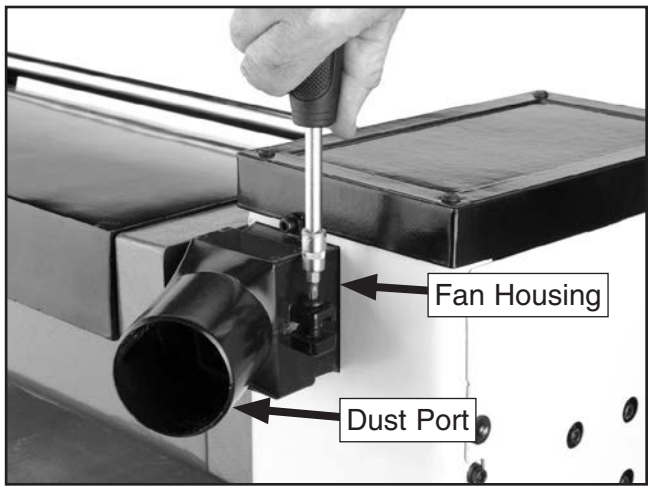


Figure 16. Installing dust port.

19. Slide the dust hose clamp over the dust bag, insert the bag and clamp over the dust port (**Figure 17**), and secure with the clamp handle. **DO NOT overtighten the clamping adjustment or it may break!**

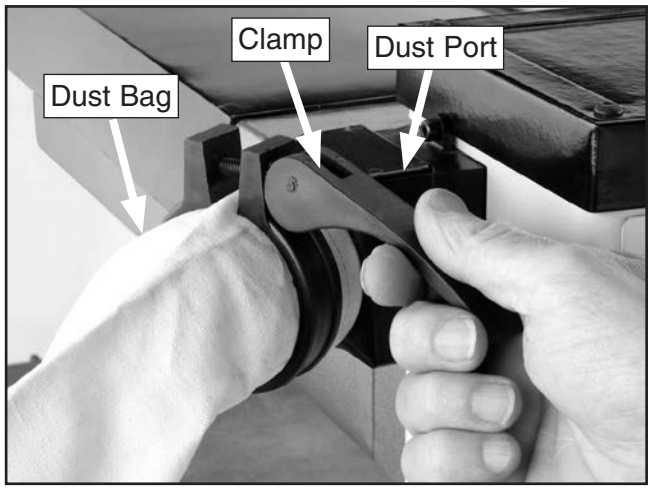


Figure 17. Installing dust bag and clamp.

Dust Collection

⚠CAUTION

DO NOT operate the Model G0458 without adequate dust collection. This sander creates substantial amounts of wood dust while operating. Failure to use dust collection can result in short and long-term respiratory illness.

You may attach the Model G0458 drum sander to a dust collection system if you do not use the included dust bag. If you are using your own dust collection system, we recommend using a system that can collect a minimum of 400 CFM **AT THE DUST PORT**.

Note: *Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must take into account many variables, including the rating of the dust collector, the length of hose between the dust collector and the machine, the amount of branches or wyes, and the amount of other open lines throughout the system.*

When the dust collection is working properly, a fine layer of dust may be present on your stock as it comes out of the sander. This is a normal characteristic of all drum sanders.

To connect the dust ports to a dust collector:

1. Attach a 2½" dust collection hose to the dust port and secure with a hose clamp.

Test Run

Now that the machine is assembled, perform a test run to make sure all the controls are working properly.

⚠WARNING

Before starting the sander, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury!

To test run the sander:

1. Put on safety glasses and make sure any bystanders are out of the way and also wearing safety glasses.

2. Connect the sander to power.

3. Flip the ON/OFF switch ***ON***. Make sure that your finger is poised over the ON/OFF switch, just in case there is a problem.

   The drum sander should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises MUST be investigated and corrected before operating the machine further. To avoid injury or damage to the machine, **DO NOT** attempt to make adjustments to the machine without turning it ***OFF*** and unplugging it from its power source.

Investigate and correct any problems before operating the machine further. If you need help, refer to the **Troubleshooting** section in the back of this manual or contact Tech Support at (570) 546-9663.

Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine.

However, because of the many variables involved with shipping, some of these adjustments may need to be repeated to ensure optimum results. Keep this in mind as you start to use your new drum sander.

Step-by-step instructions for these adjustments can be found in SECTION 7: SERVICE ADJUSTMENTS.

1. V-Belt Tensioning (**Page 27**). Perform after the first 16 hours.

2. Feed Belt Tensioning & Tracking (**Pages 31 & 32**).

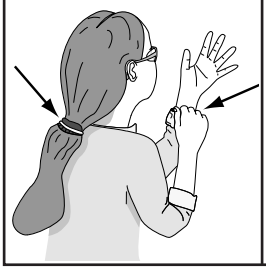
3. Table Adjustments (**Page 34**).

SECTION 4: OPERATIONS

⚠WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.





⚠WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade 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.

Depth of Cut

The optimum depth of cut will vary based on the type of wood, feed rate, and sandpaper grit. Attempts to remove too much material can cause jamming, wood burning, rapid paper wear or tearing, poor finish, and belt slippage.

To set the depth of cut:

1. Rotate the table height handwheel (**Figure 18**) until the table is too low, then raise the table, allowing a gap between the workpiece and the sanding drum.

   Note: *When adjusting the table to sand a thicker workpiece, lower and then raise the table to remove backlash from the adjustment mechanism.*

Figure 18. Table height handwheel.

2. Turn ***ON*** the feed belt and sanding drum and feed the workpiece into the sander. SLOWLY raise the feed belt until the workpiece makes light contact with the sanding drum. This is the correct height to begin sanding the workpiece.

3. After the initial pass, turn the handwheel up to ¼ turn (1/64" or 0.4mm)—the maximum depth for most sanding conditions. **Note:** *Each full turn of the table height handwheel raises the feed table approximately 0.060" (1/16") or 1.5mm.*

Variable Speed

The variable speed knob allows you to increase the feed rate from 2–12 FPM. The correct speed to use depends on the type of stock you are using (hardwood vs. softwood) and the stage of finish with that workpiece.

As a general rule, a slower feed rate will sand the surface smoother, but runs the risk of burning the wood; a faster feed rate will remove material faster, but runs the risk of overloading the motor or damaging the sandpaper.

Use trial-and-error to determine the best settings for your specific applications.

To adjust the feed belt speed:

1. Turn ***ON*** the feed belt (DO NOT adjust conveyor speed when the conveyor motor is ***OFF***).

NOTICE

Adjusting the variable speed when the conveyor motor is *OFF* can damage the V-belt and the adjusting mechanism.

2. Rotate the variable speed knob (**Figure 19**) counterclockwise to increase the feed speed, or clockwise to decrease the feed speed.

Figure 19. Variable speed knob.

Sanding

⚠WARNING

DO NOT sand more than one board at a time. Minor variations in thickness can cause one board to be propelled by the rapidly spinning sanding drum and ejected from the machine. NEVER stand directly in front of the outfeed area of the machine. Failure to do so could result in severe personal injury.

To sand a workpiece:

1. Adjust the table height according to the instructions in **Depth of Cut** on **Page 19.**

2. Make sure the filter bag is secure (or start the dust collector, if connected) and turn the sander ***ON***.

3. Feed the workpiece through the sander. Retrieve the workpiece by standing at the side—not at the outfeed end.

4. Run wide stock through two or three times without adjusting the table height. Turn the stock 180° between passes to ensure an evenly sanded surface.

NOTICE

Overloading the motor or pushing the sander to failure weakens the electrical system. Repeatedly doing so is abuse to the machine that will cause motor, capacitor, or thermal breaker damage, which is not covered by the warranty.

Sanding Tips

- Replace the sandpaper with a higher grit to achieve a finer finish.
- Raise the table a maximum of ¼ turn of the handwheel until the workpiece is the desired thickness.
- Reduce snipe when sanding more than one board of the same thickness by feeding them into the sander with the front end of the second board touching the back end of the first board.
- Feed boards into the sander at different points on the conveyor to maximize sandpaper life and prevent uneven conveyor belt wear.
- DO NOT sand boards less than 6" long or less than ⅛" thick to prevent damage to the workpiece and the drum sander.
- Extend the life of the sandpaper by regularly using a PRO-STICK® sanding pad (**Page 24**).
- When sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When the drum moves from sanding a wide surface to sanding a narrow surface, the load on the motor will be reduced, and the drum will speed up, causing a gouge.
- DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury. Edge sanding boards also can cause damage to the conveyor belt and sandpaper.
- When sanding workpieces with a bow or crown, place the high point up (prevents the workpiece from rocking) and take very light passes.
- Feed the workpiece at an angle to maximize stock removal and sandpaper effectiveness, but feed the workpiece straight to reduce sandpaper grit scratches for the finish passes.

Choosing Sandpaper

There are many types of sanding belts to choose from. We recommend Aluminum Oxide for general workshop environments. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

Grit	Class	Usage
36	Extra Coarse	Rough sawn boards, thickness sanding, and glue removal.
60	Coarse	Thickness sanding and glue removal.
80–100	Medium	Removing planer marks and initial finish sanding.
120–180	Fine	Finish sanding.

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

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

Paper Replacement

The Model G0458 is designed for 3" wide sandpaper rolls. Turn to **SECTION 5: ACCESSORIES** on **Page 24** for grit selection and model numbers.

Tools Needed:	**Qty**
Flat Head Screwdriver	1
Hex Wrench 4mm	1
Hex Wrench 5mm	1
Carton Cutter or Utility Knife	1

To change the paper:

1. **Disconnect power to the sander!**

2. Open the top cover, remove the three cap screws that secure the chip deflector to the sander frame, and set the deflector aside.

3. Loosen the cap screw on the right spring-loaded clamp as shown in **Figure 20**.

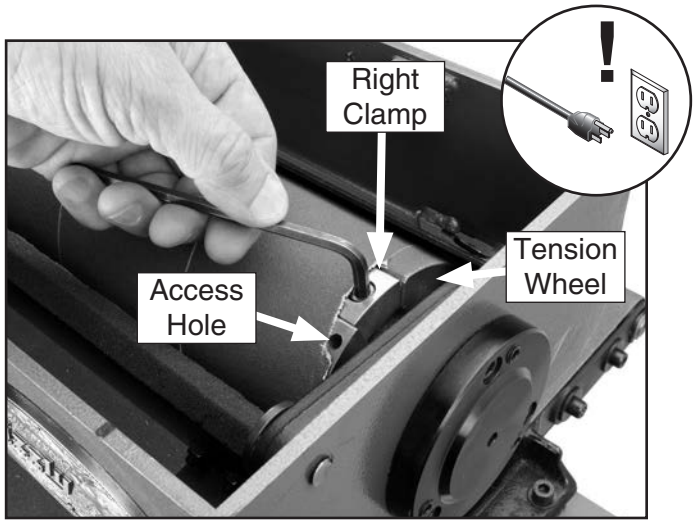


Figure 20. Loosening cap screw on right spring-loaded clamp.

4. Remove the sandpaper from the clamp. Use a flat head screwdriver, if necessary, to loosen the clamp to free the sandpaper.

5. Rotate drum to carefully remove sandpaper strip from most of the drum but the end.

   Note: *Take care not to rip or tear the old sandpaper, so you can use it as a template when cutting out the replacement sandpaper strip. This is easier than using the drawing shown in* ***Figure 21****.*

6. Loosen the cap screw on the left clamp and fully remove the sandpaper strip.

7. Use the old sandpaper strip as a pattern, if at all possible. Otherwise, use the pattern in **Figure 21**, to cut a new piece of sandpaper to the necessary shape. After cutting the 12½" angled sides, measure 2" along the same sides and cut off the ends with a knife.

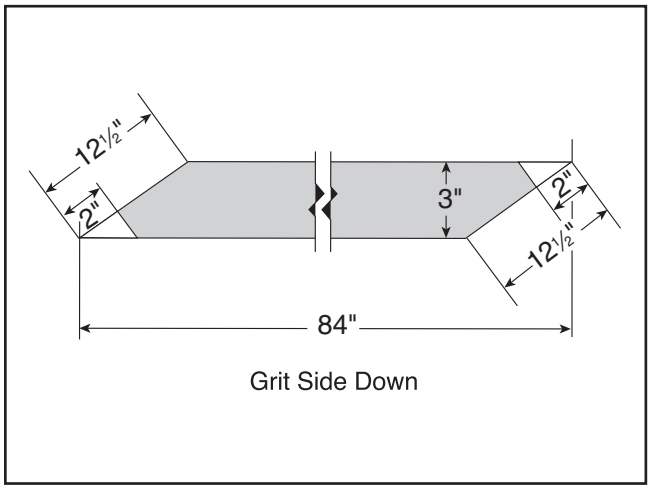


Figure 21. Sandpaper pattern for drum.

8. Insert the left corner of the new sandpaper into the left clamp and tighten the cap screw as shown in **Figure 22**. The angled side of the sandpaper must be flush with the left drum edge. If the sandpaper overlaps the edge, you may have difficulty closing the cover.

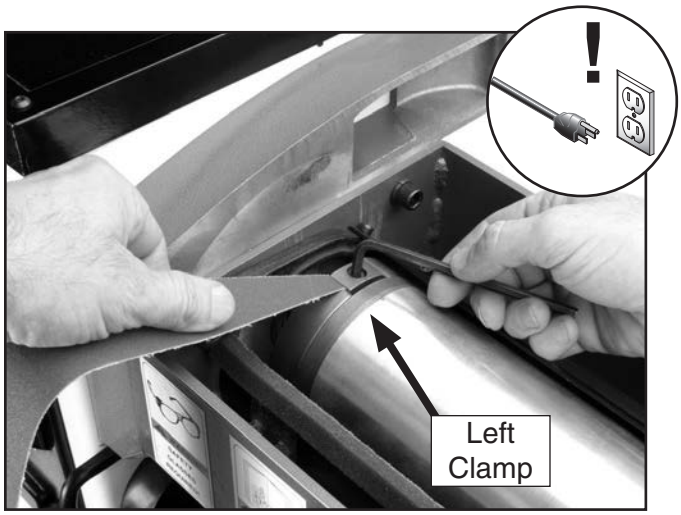


Figure 22. Securing sandpaper in left clamp.

9. Wrap the sandpaper around the drum (**Figure 23**), ensuring there are no bubbles or overlapping edges.

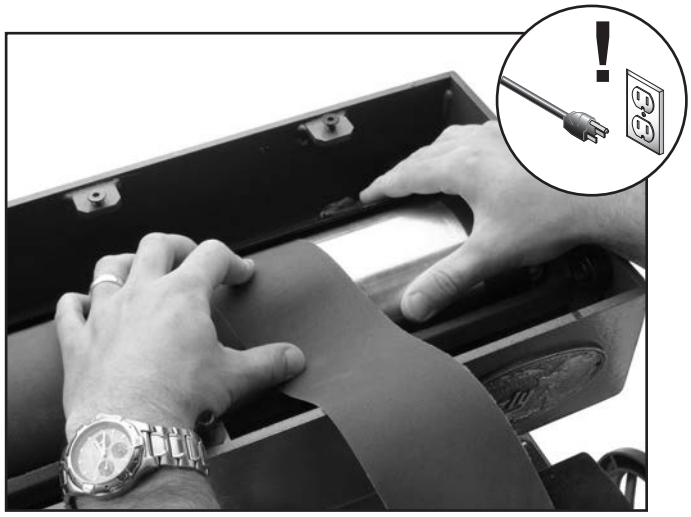


Figure 23. Wrapping sandpaper around drum.

10. When the sandpaper reaches the right side of the drum, move the sandpaper out of the way with a 4mm wrench and place it into the access hole.

11. Rotate the drum toward you so the wrench rests against the frame as shown in **Figure 24**.

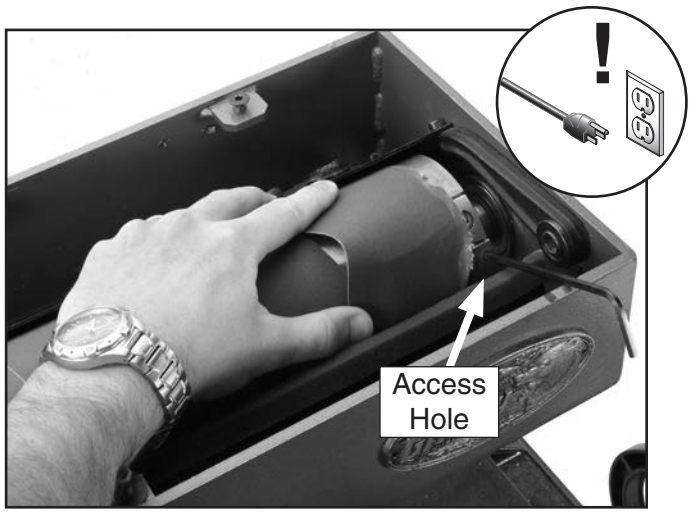


Figure 24. Hex wrench inserted into access hole on right tension wheel.

12. Firmly hold down the sandpaper with both hands, rotate the drum toward you, then wrap the end of the sandpaper over the top of the drum (**Figure 25**).

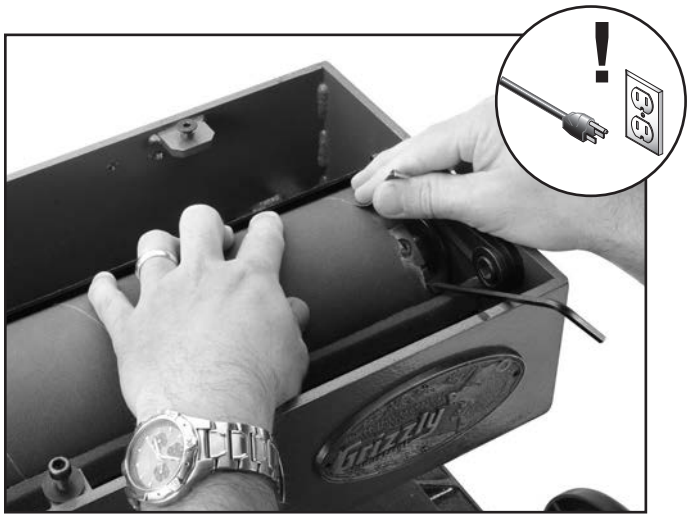


Figure 25. Wrapping sandpaper over tension wheel.

13. Place the end of the sandpaper into the clamp, secure it, and remove the hex wrench from the access hole.

14. If the sandpaper does not fit into the right clamp, you may have inserted the sandpaper too deeply into the left clamp. Also, check to make sure the length, width, and angled cuts match the pattern in **Figure 21**. Make adjustments to the sandpaper if necessary.

    If sandpaper completely covers the access hole, you may have placed too little sandpaper into the left clamp. Unwrap the sandpaper and redo **Steps 8–13**.

15. In either case, reinstall the sandpaper, repeat **Steps 9–13**, and continue adjusting the paper until it fits into the clamp.

16. When finished, reinstall the chip deflector, secure it with the three cap screws, and close the cover.

SECTION 5: ACCESSORIES

⚠WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

Aluminum Oxide Sanding Rolls 3" x 22'

T23880—60 Grit: Use for thickness sanding and glue removal.

T23881—80 Grit: Use for removing planer marks and initial finish sanding.

T23882—100 Grit: Use for removing planer marks and initial finish sanding.

T23883—120 Grit: Use for finish sanding.

T23884—150 Grit: Use for finish sanding.

T23885—180 Grit: Use for finish sanding.

T23886—220 Grit: Use for finish sanding.

G1163P—1HP Floor Model Dust Collector
G0710—1HP Wall-Mount Dust Collector

Excellent point-of-use dust collectors that can be used next to the machine with only a small amount of ducting. Specifications: 450 CFM, 7.2" static pressure, 2 cubic foot bag, and 30 micron filter. Motor is 1HP, 110V/220V, 14A/7A.

Figure 26. Point-of-use dust collectors.

PRO-STICK® Sanding Pad

Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your drum sander to remove dust build-up from the sandpaper without damage.

Size	Model
15" X 20" X 1⅛"	H2845

Figure 27. PRO-STICK® sanding pad.

T21992—Power Twist® V-Belt ½" x 4'

Smooth running with less vibration and noise than solid belts. The Power Twist® V-belts can be customized in minutes to any size—just add or remove sections to fit your needs. Size: ½" x 4'; replaces all "A" sized V-belts. Requires one Power Twist® V-belt to replace the stock V-belt on your Model G0458.

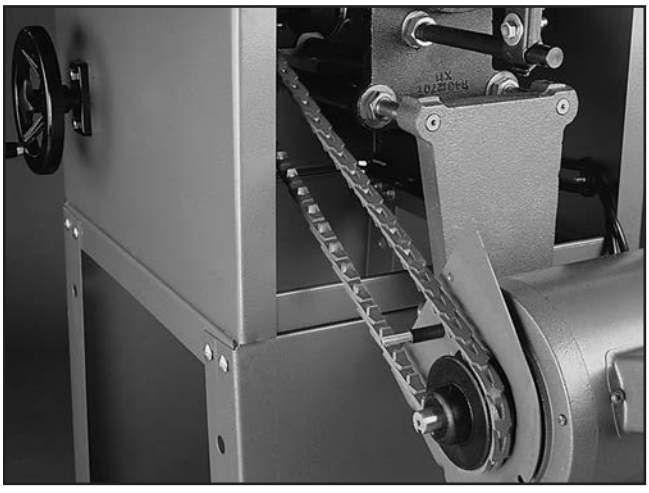
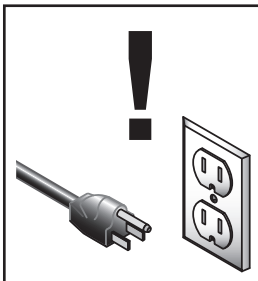


Figure 28. Power twist V-belt.

SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For safe and optimum performance from a machine that is used on a daily basis, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Checks and Maintenance:

- Loose mounting bolts.
- Damaged sanding belt.
- Worn switch.
- Worn or damaged cords or plugs.
- Damaged V-belts.
- Any other unsafe condition.
- Oil the feed belt roller and drive bushings.
- Clean/vacuum dust buildup from inside cabinet and off of the motor.

Cleaning

Cleaning the Model G0458 is relatively easy. Vacuum excess sawdust, and wipe off the remaining dust with a dry cloth.

Lubrication

The feed belt bushings should be lubricated daily with a light machine oil. Lubricate the chains and gears with a high-quality, lithium-based grease. The bearings do not need lubrication.

Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the chain.

Bushings: Must be oiled daily or each time the sander is used. Oil the bushings on each end of the feed belt rollers and remove the pulley cover and oil the drive bushings (see **Figure 29**).

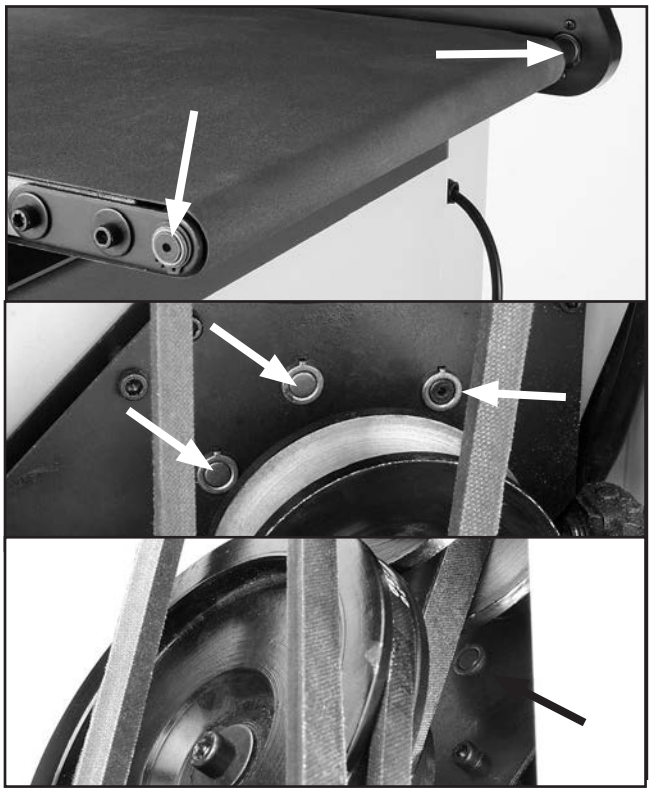


Figure 29. Bushing locations.

Feed Belt Drive: Lubricate with lithium grease monthly. Wipe sawdust and dirt impregnated grease off of the chain and gears shown in **Figures 30 & 31**. Apply fresh lithium grease to the gears and chain.

Figure 30. Feed belt drive chain.

Figure 31. Feed belt gears.

Table Lift Mechanism: Lubricate the table lift screws, chain, and helical gear with lithium grease every six months. Clean the chain and table lift screws (**Figure 32**), then rub lithium grease onto the chain links and screw threads. Clean the helical gear (**Figure 33**) and place a dab of grease on the teeth. Move the table up or down to spread the grease thoroughly throughout the mechanism.

Figure 32. Table lift screws (only two shown).

Figure 33. Helical gear.

Sanding Belts

You can greatly increase the lifespan of your sanding belts if you clean them often. Cleaning pads (**Accessories** on **Page 24**) are the fastest way to remove sawdust build-up.

V-Belt Tensioning

Tools Needed: **Qty**
Hex Wrenches 4 & 8mm ..... 1 Ea
Phillips Head Screwdriver.....1
Pry Bar 1

Proper tension is important for optimum power transmission. However, too much tension may cause premature bearing failure.

Correct V-belt tension is achieved when the V-belts can be deflected ½"–¾" when pushed in the middle with moderate pressure. See **Figure 34** for an example of how to perform a V-belt deflection test with a straightedge and ruler.

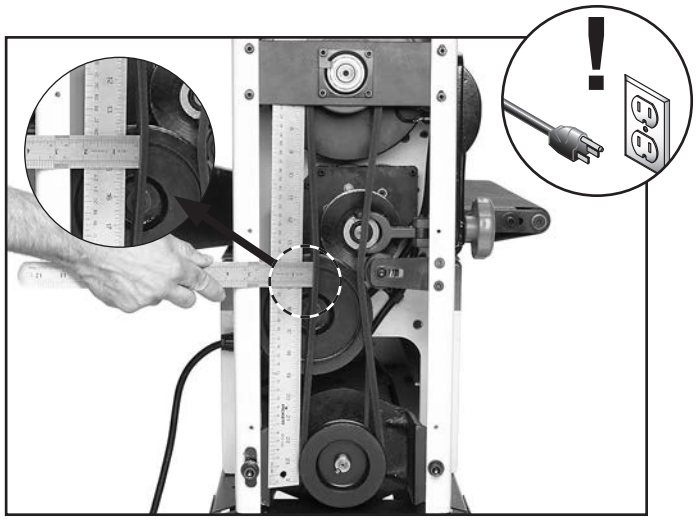


Figure 34. Checking V-belt tension with a straightedge and a ruler.

⚠CAUTION

Always inspect V-belts for damage or deterioration when adjusting for tension. Should you find evidence of cracking, abrasion or damage from wood chips or other foreign materials, replace the belt immediately. Belt breakage may lead to mechanical damage or operator injury.

To adjust V-belt tension:

1. **Disconnect power to the sander!**

2. Open the pulley cover.

3. Check the tension of the feed belt V-belt, then adjust the tension by loosening the motor mount cap screws shown in **Figure 35** and pushing down on the motor mount to tighten the V-belts.

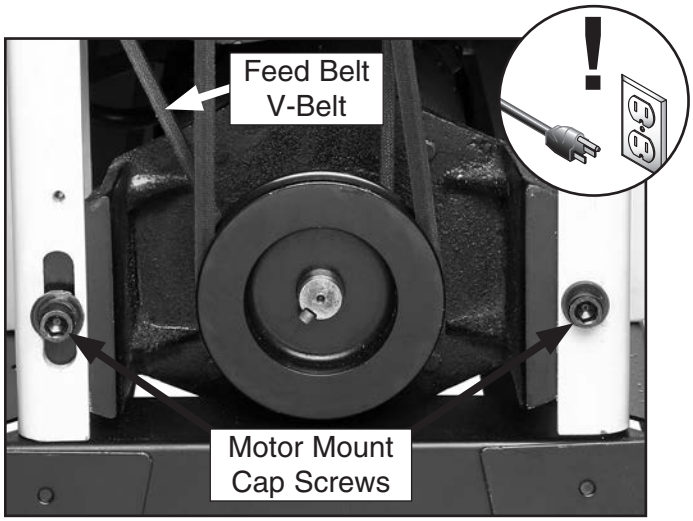


Figure 35. Feed belt V-belt tension.

4. Tension the sanding drum V-belt by sliding the idler roller (**Figure 36**) into the V-belt until the belt is correctly tensioned, then replace the pulley cover.

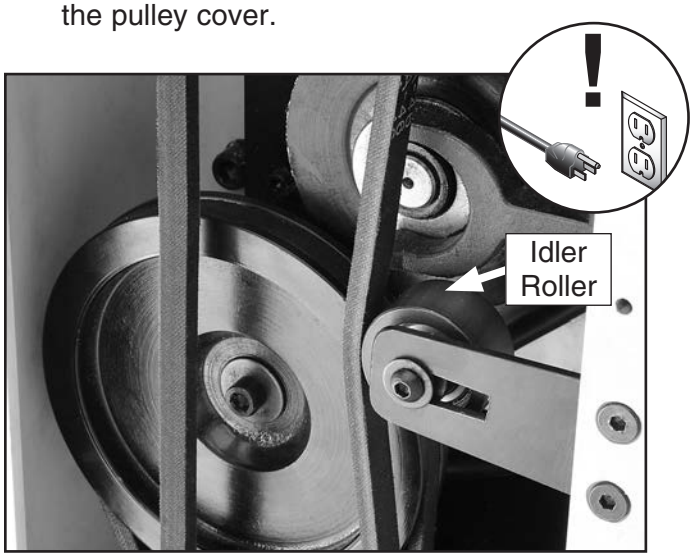


Figure 36. Sanding drum V-belt tension.

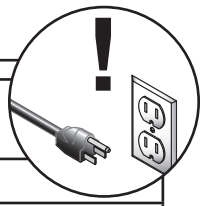
NOTICE

New V-belts will often stretch and loosen after moderate use. Check frequently after installation and re-tension if necessary.

SECTION 7: SERVICE

Review the troubleshooting and 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

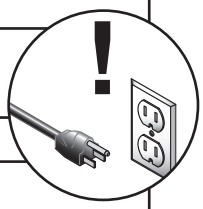


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Plug/receptacle is faulty or wired incorrectly. 2. Start capacitor is faulty. 3. Motor connection is wired incorrectly. 4. Power supply is faulty, or is switched OFF. 5. Safety switch key is at fault. 6. Motor ON/OFF switch is faulty. 7. Centrifugal switch is at fault. 8. Cable or wiring is open or has high resistance. 9. Motor is at fault.	1. Test power plug and receptacle for good contact and correct wiring. 2. Test capacitor and replace if necessary. 3. Correct motor wiring (see **Page 38**). 4. Make sure hot lines and grounds are operational and have correct voltage on all legs. 5. Install or replace safety key, or replace switch assembly. 6. Replace faulty ON/OFF switch. 7. Adjust or replace the centrifugal switch. 8. Check for disconnected or corroded connections, troubleshoot wires for internal or external breaks, then repair or replace wiring. 9. Test, then repair or replace motor.
Machine stalls or is underpowered.	1. Wrong workpiece material. 2. Low power supply voltage. 3. Run capacitor is faulty. 4. Filter bags are at fault. 5. V-belts are slipping. 6. Plug or receptacle is at fault. 7. Motor connection is wired incorrectly. 8. Motor bearings are at fault. 9. Machine is overloaded. 10. Motor has overheated. 11. Centrifugal switch is at fault. 12. Motor is at fault.	1. Only process wood with correct moisture content, and no glues, or resins. 2. Make sure hot lines and grounds are operational and have correct voltage on all legs. 3. Test capacitor and replace if necessary. 4. Empty and clean filter bag. 5. Replace bad belts, align pulleys, and re-tension the V-belts (see **Pages 27 & 30**). 6. Test power plug and receptacle for good contact and correct wiring. 7. Correct motor wiring (see **Page 38**). 8. Rotate motor shaft for noisy or burnt bearings, repair/replace as required. 9. Use new sandpaper with appropriate grit, and reduce the feed rate/depth of sanding. 10. Check motor cooling air flow, let motor cool, and reduce workload on machine. 11. Adjust/replace the centrifugal switch. 12. Test motor, and repair/replace if necessary.

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. V-belts are worn or loose. 3. Motor fan is rubbing on fan cover. 4. Pulley is loose. 5. Machine is incorrectly mounted to the floor. 6. Cast iron motor mount is at fault. 7. Motor bearings are at fault.	1. Inspect for stripped/damaged bolts/nuts, replace/re-tighten with thread locking fluid. 2. Inspect belts, replace and re-tension (see **Pages 27 & 30**). 3. Replace dented fan cover/damaged fan. 4. Remove pulley, replace shaft, pulley, setscrew, and key as required, and realign. 5. Machine has loose anchor studs in floor, or is sitting on uneven floor. Replace/tighten relocate as required. 6. Using leverage and a small pry bar to inspect, carefully replace loose/broken mounts. 7. Check bearings, replace motor or bearings as required.

Sanding Operations



Symptom	Possible Cause	Possible Solution
Vibration when sanding.	1. Loose drum bearings. 2. Worn drum bearings.	1. Tighten drum bearings. 2. Replace drum bearings.
Grinding, screeching, or rubbing noise when sanding drums are powered up.	1. Drum bushings lack sufficient oil. 2. Drum bushings are worn and need replacement.	1. Oil the drum bushings (see **Page 25**). 2. Replace the drum bushings.
Short V-belt lifespan.	1. Pulleys not aligned correctly. 2. Improperly tensioned.	1. Align pulleys (see **Page 31**). 2. Properly tension V-belts (see **Page 27**).
Machine lacks power; drums stop turning under load.	1. V-belts loose. 2. Too much pressure on pressure plates.	1. Tighten V-belts (see **Page 27**). 2. Raise the pressure plates (**Page 35**).
Feed belt slips under load.	1. Feed belt is too loose. 2. Too much load.	1. Tension feed belt (see **Page 32**). 2. Decrease load.
Feed belt tracks to one side or hits the feed table mounts.	1. Feed belt tracking is incorrect.	1. Track the feed belt so it runs straight (see **Page 31**).
Excessive snipe.	1. Lack of outfeed support. 2. Too much pressure from pressure plates. 3. Too much pressure from the rear pressure plate.	1. Set up an outfeed table or have someone catch the workpiece as it comes out. 2. Raise the pressure plates (**Page 35**). 3. Raise the rear pressure plate (**Page 35**).
Workpiece kicks out of sander.	1. Not enough pressure from the pressure plates.	1. Lower the pressure plates (**Page 35**).
Sandpaper tears off drums during operation.	1. Nail/staple in workpiece. 2. Sandpaper not tightened or fastened correctly.	1. Sand only clean workpieces. 2. Install the sandpaper correctly (see **Page 22**).
Table elevation controls are stiff and hard to adjust.	1. Table lift screws are dirty or loaded with sawdust. 2. Chain idler sprocket cap screws have been over tightened. 3. Elevation handle helical gear is dirty or loaded with sawdust.	1. Clean and re-grease table lift screws (see **Page 26**). 2. Adjust the cap screws on the idler sprocket so it can spin freely. 3. Clean and re-grease the helical gear (see **Page 26**).

Replacing V-Belts

Tools Needed:	Qty
Hex Wrenches 4, 6 & 8mm	1 Ea
Phillips Head Screwdriver	1
Pry Bar	1

Inspect the V-belts closely; if you notice fraying, cracking, glazing, or any other damage, replace the belts. A worn/damaged V-belt will not provide optimum power transmission from the motor to the drum and feed belt.

V-belt removal and replacement is simply a matter of loosening the V-belts, rolling them off of the pulleys, replacing them with new belts, then retensioning them.

To replace the V-belts:

1. **Disconnect power to the sander!**

2. Open the pulley cover.

   Note: *If you plan on replacing the variable speed belt, loosen the cap screw securing the variable speed pulley (**Figure 38**) before loosening the motor mount cap screws.*

3. Loosen the motor mount cap screws shown in **Figure 37** and loosen the cap screw securing the idler roller.

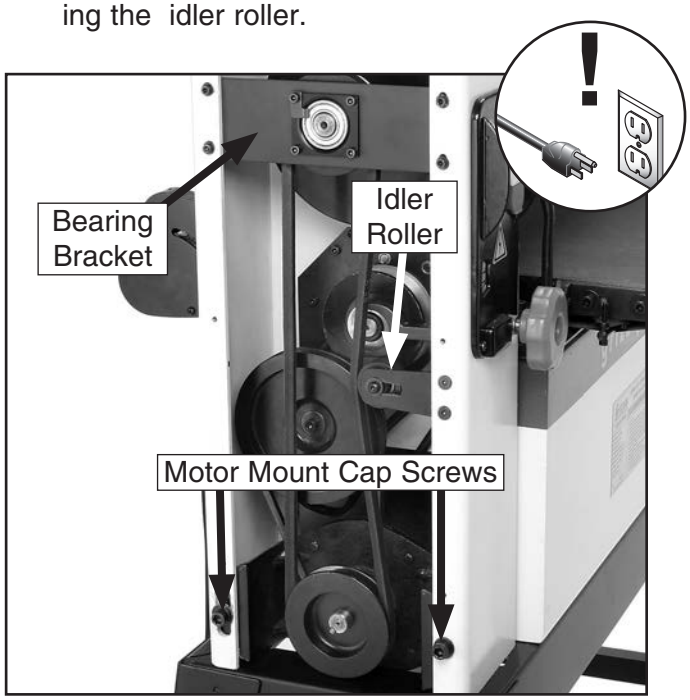


Figure 37. Belt drive system.

4. Remove the cap screws securing the bearing bracket and rotate the bearing bracket 90˚.

5. Slide the sanding drum V-belt off of the motor pulley, then lift the motor mount to remove the feed V-belt.

   Note: *You may need to use a pry bar to lift the motor mount.*

6. To replace the variable speed belt, remove the cap screw securing the pulley shown in **Figure 38**, then remove the outer half of the pulley.

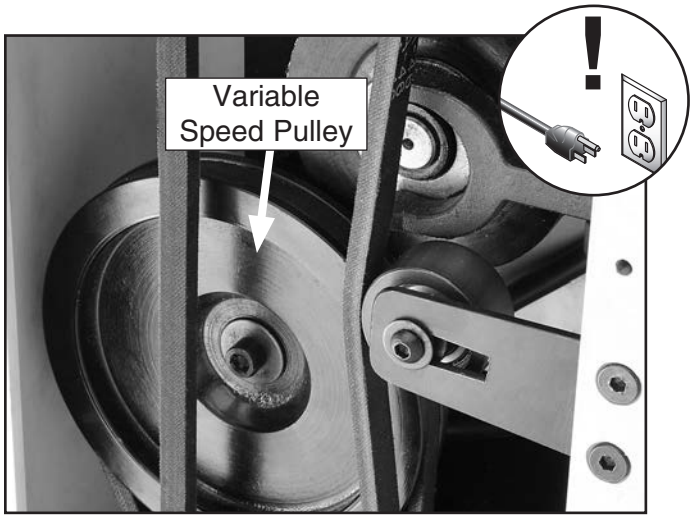


Figure 38. Variable speed pulley.

7. Compress the spring behind the inner half of the variable speed pulley, slide the outer half of the pulley over the shaft and key, then thread in the cap screw.

8. Install the new feed and drum V-belts, reattach the bearing bracket, and tension according to the instructions on **Page 27**.

9. Tighten the variable speed pulley cap screw and replace the pulley cover.

Pulley Alignment

Tools Needed:	Qty
Hex Wrenches 4 & 8mm	1 Ea
Phillips Head Screwdriver	1
Pry Bar	1

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

Each pulley can be adjusted by loosening the set screw that secures the pulley to the shaft, sliding the pulley in/out, and retightening the set screw to lock the pulley in place.

To align the pulleys:

1. **Disconnect power to the sander!**

2. Open the pulley cover.

3. Looking from the top, sight down the V-belts and pulleys and check to see that the pulleys are parallel and aligned with each other (see **Figure 39**).

   —If the pulleys are aligned, go to **Step 9**.

   —If the pulleys are NOT aligned, perform **Steps 4–8**.

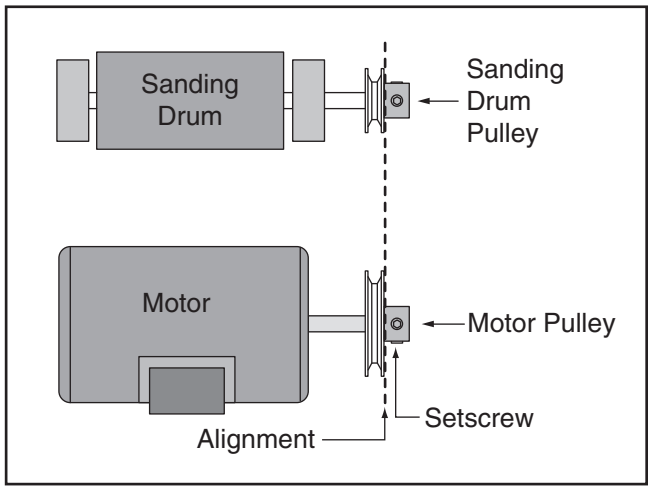


Figure 39. The pulleys should be parallel and aligned.

4. Remove the V-belts.

5. Loosen the set screws on the motor pulley and align the motor pulley with the feed belt pulley.

6. Loosen the set screws on the sanding belt pulley and align the sanding belt pulley with the motor pulley.

7. Tighten the set screws, replace the V-belts, and repeat **Step 3**. Belts should be parallel and aligned as shown in **Figure 39.**

8. Adjust the pulleys again, if necessary, until they are all coplanar with each other.

9. Replace the pulley cover.

Feed Belt Tracking

Tools Needed:	Qty
Wrench 8mm	1
Hex Wrench 4mm	1

The feed belt must track straight. If the feed belt tracks to either side, then the tracking must be corrected or the feed belt will become damaged and have to be replaced.

Tracking the feed belt is a balancing process that takes patience and a small degree of trial-and-error. Usually you must over-tighten the loose side (the side the belt is tracking towards) to make the feed belt move to the middle of the rollers, then loosen that same side to make the feed belt stay in position. If you adjust the bolt too much either way, then you have to repeat the process until the feed belt rides in the middle and stays there during continuous operation.

Note: *Tracking affects tension, so tension must always be adjusted after tracking.*

To track the feed belt:

1. Turn the feed belt ***ON*** and watch it track. If the belt moves to one side, immediately stop the machine and adjust the belt tracking. If the belt tracks evenly, leave it alone.

2. Loosen the lock nut (**Figure 40**) on the side that the feed belt tracks towards and tension the tracking adjustment screw until the feed belt tracks in the opposite direction.

   Note: *Small tracking changes may take up to three minutes before they are noticeable.*

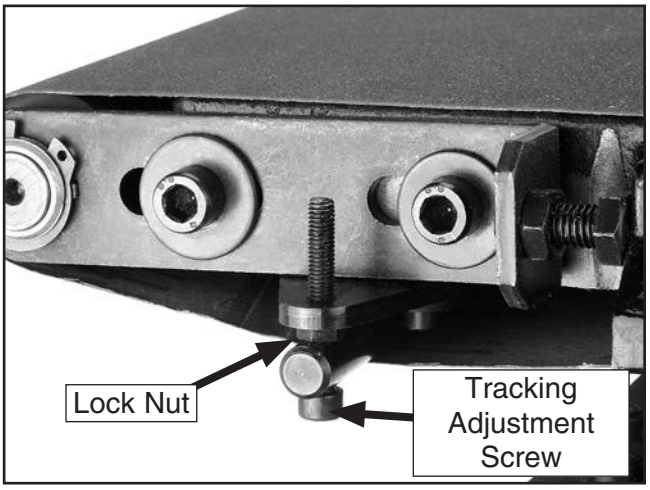


Figure 40. Feed belt tracking adjustment bolt.

3. When the feed belt is near the middle of the rollers or table, loosen the tracking adjustment screw until the feed belt stops moving and tracks straight.

   —If the feed belt tracks too far to the other side, loosen the tracking adjustment screw as necessary to bring it back. Repeat **Steps 2 & 3** until the tracking is correct.

Feed Belt Tension

Tools Needed:	**Qty**
Wrench 12mm	2
Hex Wrench 6mm	1

The feed belt will stretch when new and will eventually need to be tensioned. This is most obvious if the feed belt starts slipping on the rollers.

When you tension the feed belt, focus on adjusting the tensioning bolts in even increments. Adjusting one side more than the other will cause tracking problems, which will require you to take additional steps to get the sander operating correctly.

To tension the feed belt:

1. Loosen the feed roller lock screws, shown in **Figure 41**, on both sides of the feed belt.

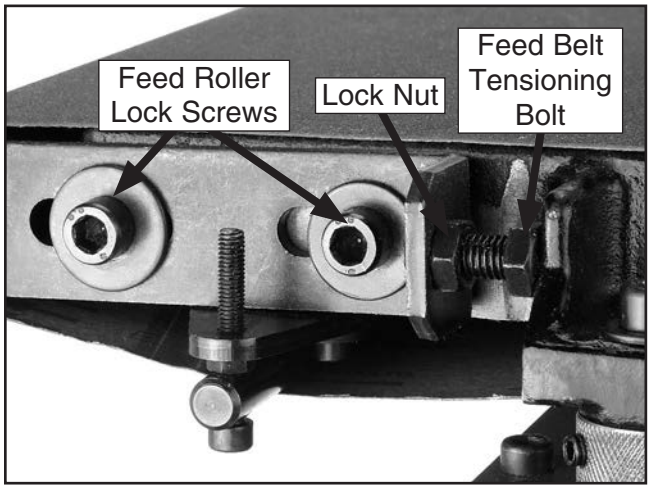


Figure 41. Feed belt tensioning controls.

2. Use a permanent marker, paper correction fluid, or fingernail polish to mark the feed belt tensioning bolt on both sides. This step will aid you in keeping track of the rotations as you turn the bolts, so they remain as even as possible.

3. Loosen the lock nuts and turn both of the feed belt tensioning bolts clockwise one full turn at a time until the feed belt no longer slips during operation.

   —If the feed belt starts tracking to one side, back off the feed belt tensioning bolt that is being adjusted.

   —If the feed belt continues tracking to one side, immediately turn the drum sander ***OFF*** and perform the tracking instructions.

4. Tighten the lock nuts to lock the feed belt tensioning bolts in place.

   Note: *When tensioned properly the belt should not lift off the table, slide back and forth, or slip.*

NOTICE

DO NOT over-tension the feed belt, this may cause premature wearing of the belt, bushings, and cause strain on the motor.

Feed Belt Replacement

Tools Needed:	Qty
Wrench 12mm	2
Hex Wrench 6mm	1
An Assistant	1

Replacing the feed belt is a simple process, but will require tensioning and tracking when completed.

To replace the feed belt:

1. **Disconnect power to the sander!**

2. Use a permanent marker, paper correction fluid, or fingernail polish to mark the front of the feed belt tensioning bolt (**Figure 41**) on both sides. This step will aid you in returning the bolts to their original position, reducing the amount of tracking necessary.

3. Loosen the lock nuts shown in **Figure 41** and turn both of the feed belt adjustment bolts counterclockwise one full turn at a time to release the tension from the feed belt.

4. Remove the outside table cap screws shown in **Figure 42** and loosen the corresponding cap screws on the inside edge.

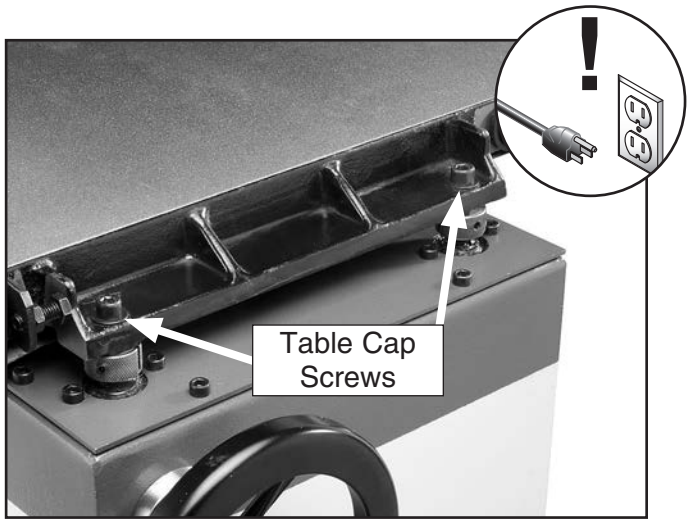


Figure 42. Feed belt table outside cap screws.

5. Have an assistant lift the outside edge of the table, then slide the feed belt off.

6. Clean any dirt or dust off of the table and rollers, have an assistant lift the table, then slide the new feed belt on.

7. Re-install and tighten all of the table cap screws.

8. Tighten the feed belt adjustment bolts equally, then follow the tensioning instructions on **Page 32**.

   Note: *The feed belt will stretch slightly when new and will need to be re-tensioned after a short amount of use.*

9. Track the new feed belt according to the instructions on **Page 31**.

   Note: *One side of the belt may need to be tighter than the other for the belt to track straight.*

Gauge Blocks

Tools Needed:	Qty
6' Long 2x4	1
Miter Saw (or Circular Saw)	1
Jointer	1
Table Saw	1

The gauge blocks described here will be required to complete the remaining service procedures in this section.

To make the gauge blocks:

1. Edge joint the concave edge of the 2x4 flat on a jointer, as shown in **Figure 43**.

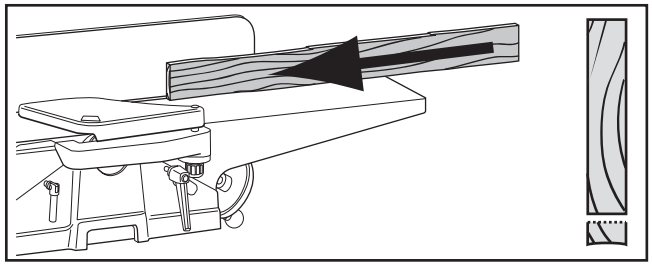


Figure 43. Edge jointing on a jointer.

2. Place the jointed edge of the 2x4 against the table saw fence and rip cut just enough off the opposite side to square up the two edges of the 2x4, as shown in **Figure 44**.

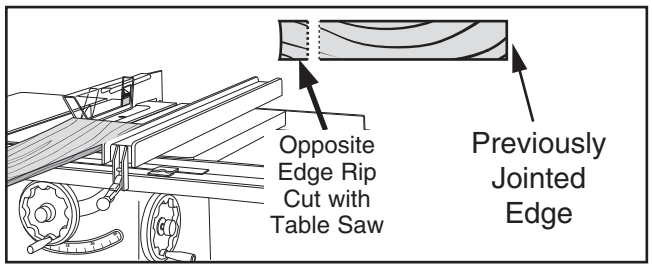


Figure 44. Rip cutting on a table saw.

3. Cut the 2x4 into two even pieces to make two 36" long wood gauge blocks.

   Note: ***Steps 1 & 2*** *can be skipped, but having the gauge blocks at an equal height is critical to the accuracy of your adjustments.*

Table Adjustments

Aligning the drums parallel to the conveyor belt (**Figure 45**) is critical for sanding accuracy. Care should be taken to make the tolerances as close as possible (within 0.002" from one side to the other) when adjusting the drum height.

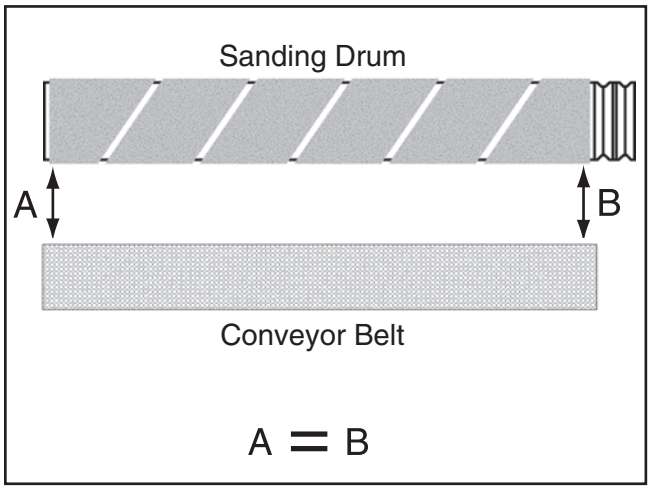


Figure 45. Drum parallel to conveyor belt.

Tools Needed:	Qty
Hex Wrenches 3 & 6mm	1 Ea
Gauge Blocks	2
Feeler Gauge Set	1

To align the drums:

1. **Disconnect power to the sander!**

2. Remove the sandpaper from the drum and place the gauge blocks as shown in **Figure 46**.

Figure 46. Gauge blocks placed under drums.

3. Raise the table until the gauge blocks just touch the drum.

   N**ote:** *A good way to know when they are touching is to rock the drum back and forth while raising the table until you hear or feel contact with the gauge blocks.*

4. Lower the table one full crank of the handwheel (taking handwheel free-play into consideration; or in other words, wait until the chain starts moving before starting to count the handwheel rotation).

5. Starting at one end, find the largest size feeler gauge that can pass between the drum and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing the drum to roll.)

6. Repeat **Step 5** at the other end of the drum.

   —If the difference between the two sizes is 0.002" or less, then no adjustment is necessary.

   —If the difference between the two sizes is more than 0.002", then one end must be adjusted to within 0.002" from the other. Continue to the next step.

7. Loosen the table cap screws and adjust the height of the table by rotating the adjustment knob shown in **Figure 47**.

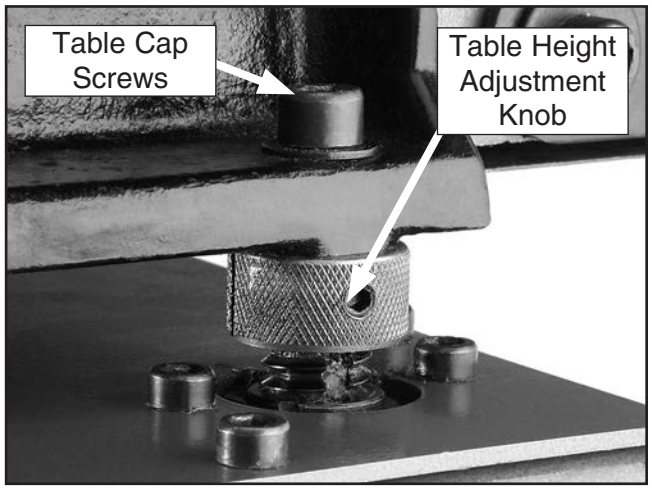


Figure 47. Table height adjustment knob.

8. Tighten the table cap screws and repeat **Steps 5 & 6**.

Pressure Plate Adjustments

Tools Needed:	**Qty**
Wrench 8mm	1
Hex Wrench 4mm	1
Gauge Blocks (see **Page 34**)	2
Feeler Gauge Set	1

When properly positioned, the pressure plates should be approximately 0.004" lower than the drum.

Adjusting the pressure plates is a fine balance between too much pressure and not enough. Too much pressure can cause problems like snipe or overloading the motor, not enough pressure may allow the workpiece to kick out of the sander towards the operator.

The pressure plates have been set correctly at the factory. Do not adjust the pressure plates unless absolutely necessary.

To check pressure plate adjustment:

1. **Disconnect power to the sander!**

2. Place the gauge blocks on the feed belt as shown in **Figure 46**.

3. Raise the table until the gauge blocks just touch the rear pressure plate.

4. Find the largest size feeler gauge that can pass between the drum and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing the drum to roll.)

   —If the gap is 0.004" (0.1mm) or less, then no adjustment of the rear pressure plate is necessary.

   —If the gap is more than 0.004" (0.1mm), then the rear pressure plate must be adjusted.

5. Raise the table until the gauge blocks just touch the drum.

6. Find the largest size feeler gauge that can pass between the front pressure plate and your gauge block. (The feeler gauge should slide with moderate resistance, without forcing the drum to roll.)

   —If the gap is 0.004" (0.1mm) or less, then no adjustment of the front pressure plate is necessary.

   —If the gap is more than 0.004" (0.1mm), then the front pressure plate must be adjusted.

To adjust the rear pressure plate:

1. **Disconnect power to the sander!**

2. Loosen the lock nuts and tighten the cap screws on both ends of the rear pressure plate shown in **Figure 48** to raise the pressure plate, or loosen the cap screw to lower the pressure plate.

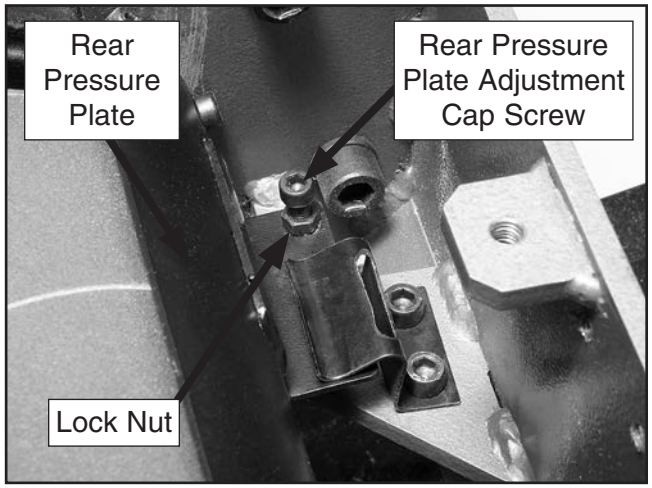


Figure 48. Rear pressure plate adjustments.

3. Adjust the rear pressure plate until it is equal to, or up to 0.004" (0.1mm) lower than the height of the drum.

To adjust the front pressure plate:

1. **Disconnect power to the sander!**

2. Loosen the lock nuts and tighten the cap screws on both ends of the front pressure plate shown in **Figure 49** to raise the pressure plate, or loosen the cap screw to lower the pressure plate.

3. Adjust the front pressure plate until it is equal to, or up to 0.004" (0.1mm) lower than the height of the drum.

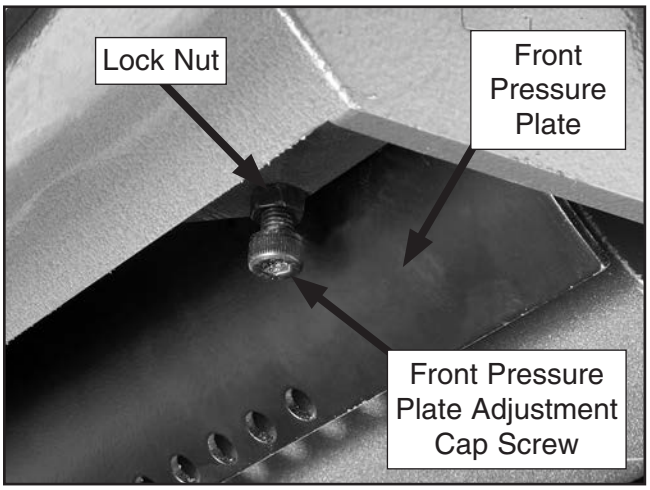


Figure 49. Front pressure plate adjustments.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

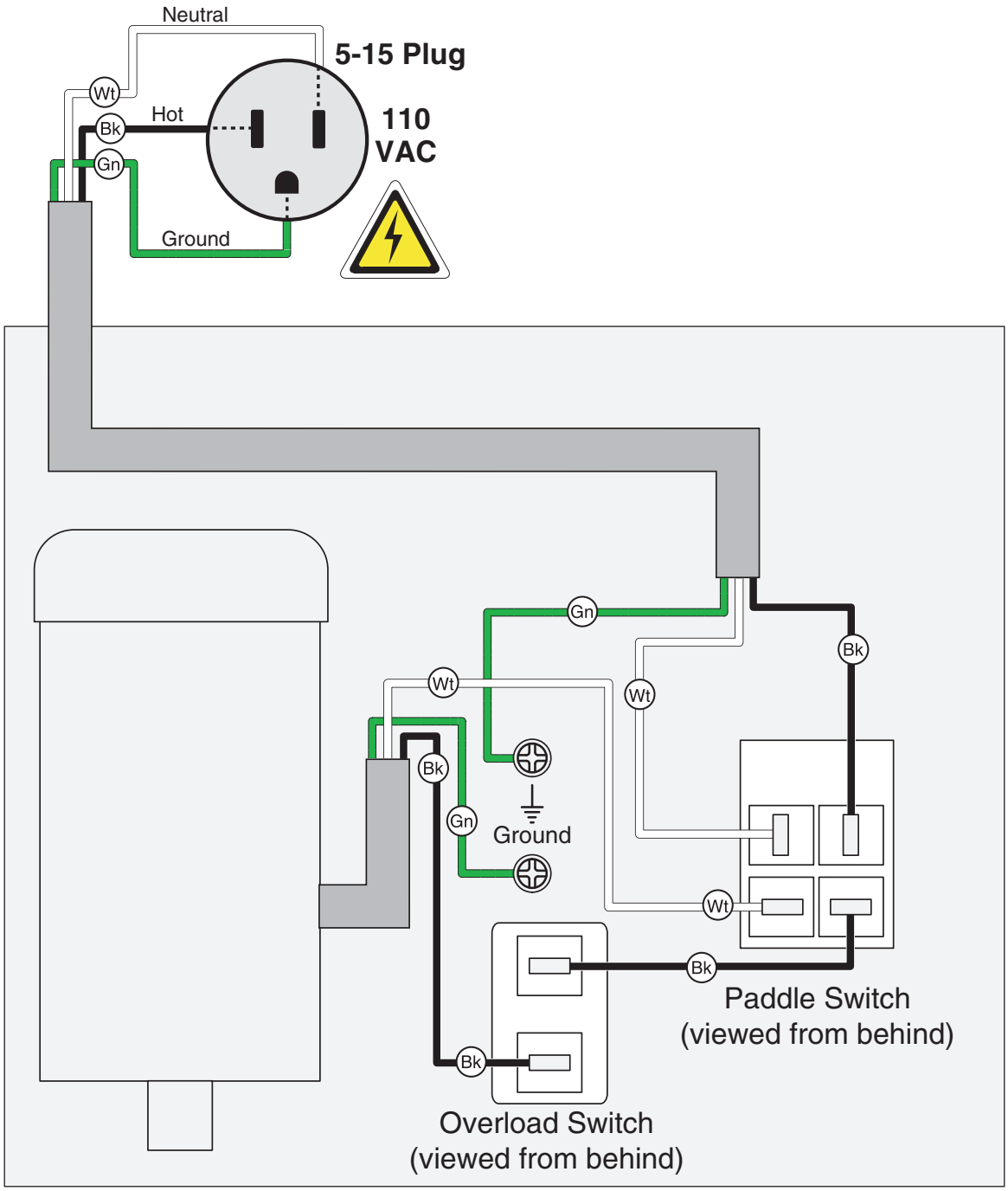
NOTICE

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

COLOR KEY

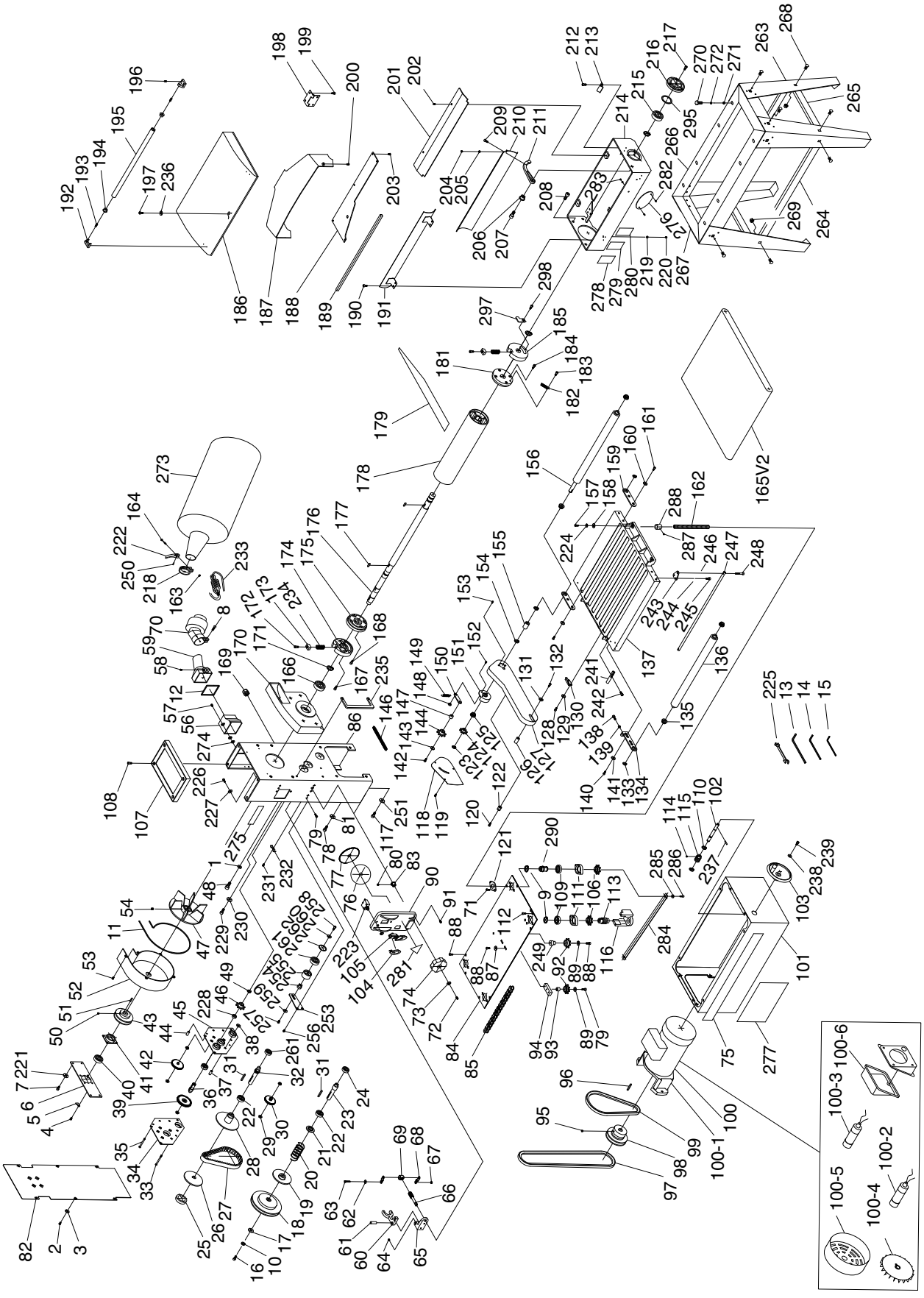
BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram



READ ELECTRICAL SAFETY ON PAGE 37!

G0458 Parts Breakdown



G0458 Parts List

REF	PART #	DESCRIPTION
1	P0458001	LOCK WASHER 10MM
2	P0458002	PHLP HD SCR M5-.8 X 8
3	P0458003	FLAT WASHER 5MM
4	P0458004	CAP SCREW M5-.8 X 8
5	P0458005	BEARING RETAINER
6	P0458006	BEARING CAP
7	P0458007	CAP SCREW M5-.8 X 12
8	P0458008	PHLP HD SCR M6-1 X 25
9	P0458009	EXT RETAINING RING 20MM
10	P0458010	LOCK WASHER 8MM
11	P0458011	SPONGE STRIP
12	P0458012	SPONGE STRIP
13	P0458013	HEX WRENCH 6MM
14	P0458014	HEX WRENCH 5MM
15	P0458015	HEX WRENCH 4MM
16	P0458016	CAP SCREW M8-1.25 X 15
17	P0458017	FLAT WASHER 8MM
18	P0458018	PULLEY
19	P0458019	PULLEY
20	P0458020	COMPRESSION SPRING
21	P0458021	SPACER
22	P0458022	BEARING 6003ZZ
23	P0458023	SHAFT
24	P0458024	BEARING 6003ZZ
25	P0458025	THRUST BALL BEARING
26	P0458026	PULLEY
27	P0458027	COGGED V-BELT 400VK15-22
28	P0458028	PULLEY
29	P0458029	BUSHING
30	P0458030	GEAR 52/12T
31	P0458031	KEY 5 X 5 X 40
32	P0458032	SHAFT
33	P0458033	CAP SCREW M5-.8 X 30
34	P0458034	INSIDE COVER
35	P0458035	CAP SCREW M5-.8 X 25
36	P0458036	SHAFT
37	P0458037	SPACER
38	P0458038	FLAT WASHER 5MM
39	P0458039	GEAR 70T
40	P0458040	BEARING 6004ZZ
41	P0458041	BEARING COVER
42	P0458042	GEAR 58/12T
43	P0458043	PULLEY
44	P0458044	SPACER
45	P0458045	INSIDE COVER
46	P0458046	SPROCKET
47	P0458047	FAN
48	P0458048	CAP SCREW M10-1.5 X 25
49	P0458049	EXT RETAINING RING 15MM
50	P0458050	SET SCREW M6-1 X 10

REF	PART #	DESCRIPTION
51	P0458051	KEY 6 X 6 X 20
52	P0458052	FAN COVER
53	P0458053	CAP SCREW M4-.7 X 8
54	P0458054	SET SCREW M8-1.25 X 8
56	P0458056	COLLECTOR TUBE
57	P0458057	PHLP HD SCR M5-.8 X 8
58	P0458058	PHLP HD SCR M6-1 X 25
59	P0458059	DUST PORT 2-1/2"
60	P0458060	LINK
61	P0458061	PIN
62	P0458062	LOCK WASHER 5MM
63	P0458063	CAP SCREW M5-.8 X 25
64	P0458064	SET SCREW M6-1 X 6
65	P0458065	BRACKET
66	P0458066	ADJUSTING ROD
67	P0458067	HEX NUT M5-.8
68	P0458068	RETAINER
69	P0458069	SPECIAL NUT
70	P0458070	DUST PORT
71	P0458071	CAP SCREW M6-1 X 16
72	P0458072	PHLP HD SCR M5-.8 X 10
73	P0458073	FLAT WASHER 5MM
74	P0458074	KNOB 8MM
75	P0458075	GRIZZLY.COM LABEL
76	P0458076	SPEED SCALE
77	P0458077	GEAR
78	P0458078	CAP SCREW M10-1.5 X 25
79	P0458079	CAP SCREW M6-1 X 20
80	P0458080	SET SCREW M5-.8 X 5
81	P0458081	FLAT WASHER 10MM
82	P0458082	SIDE COVER
83	P0458083	GEAR
84	P0458084	SIDE COVER
85	P0458085	CHAIN 132-410
86	P0458086	SIDE CASTING
87	P0458087	FLAT WASHER 6MM
88	P0458088	CAP SCREW M6-1 X 10
89	P0458089	FLAT WASHER 6MM
90	P0458090	TURNMETER COVER
91	P0458091	PHLP HD SCR M5-.8 X 12
92	P0458092	SPROCKET
93	P0458093	SPACER
94	P0458094	IDLER BRACKET
95	P0458095	SET SCREW M8-1.25 X 12
96	P0458096	KEY 6 X 6 X 40
97	P0458097	V-BELT A46
98	P0458098	PULLEY
99	P0458099	V-BELT M-26 3L260
100	P0458100	MOTOR 1-1/2HP 110V 1-PH

G0458 Parts List

REF	PART #	DESCRIPTION
100	P0458100	MOTOR 1-1/2HP 110V 1-PH
100-1	P0458100-1	MOTOR BRACKET
100-2	P0458100-2	R CAPACITOR 40M 250V 1-1/2 X 2-3/4
100-3	P0458100-3	START CAPACITOR 300MFD 125VAC
100-4	P0458100-4	MOTOR FAN
100-5	P0458100-5	FAN COVER
100-6	P0458100-6	CAP COVER /JUNCTION BOX
101	P0458101	LOWER CASTING
102	P0458102	SHAFT
103	P0458103	HANDWHEEL
104	P0458104	SWITCH KEY
105	P0458105	SWITCH
106	P0458106	SPROCKET
107	P0458107	COVER
108	P0458108	CAP SCREW M5-.8 X 16
109	P0458109	BEARING 6904ZZ
110	P0458110	EXT RETAINING RING 12MM
111	P0458111	BEARING COVER
112	P0458112	PHLP HD SCR M6-1 X 10
113	P0458113	GEAR
114	P0458114	SET SCREW M5-.8 X 5
115	P0458115	WORM
116	P0458116	BRACKET
117	P0458117	CAP SCREW M10-1.5 X 16
118	P0458118	SIDE COVER
119	P0458119	TAP SCREW M5- X 10
120	P0458120	PHLP HD SCR M4-.7 X 10
121	P0458121	DUST COVER
122	P0458122	FIXED COLLAR
123	P0458123	EXT RETAINING RING 15MM
124	P0458124	SPROCKET
125	P0458125	BUSHING
126	P0458126	SPACER
127	P0458127	CHAIN COVER
128	P0458128	CAP SCREW M5-.8 X 8
129	P0458129	FLAT WASHER 5MM
130	P0458130	GUIDE PLATE
131	P0458131	FLAT WASHER 5MM
132	P0458132	CAP SCREW M5-.8 X 35
133	P0458133	EXT RETAINING RING 20MM
134	P0458134	EXTENSION BRACKET
135	P0458135	BUSHING
136	P0458136	ROLLER
137	P0458137	TABLE
138	P0458138	HEX BOLT M8-1.25 X 20
139	P0458139	HEX NUT M8-1.25
140	P0458140	CAP SCREW M8-1.25 X 16
141	P0458141	FLAT WASHER 8MM
142	P0458142	CAP SCREW M6-1 X 20
143	P0458143	FLAT WASHER 6MM
144	P0458144	SPROCKET
146	P0458146	CHAIN

REF	PART #	DESCRIPTION
147	P0458147	SPACER
148	P0458148	SPECIAL NUT
149	P0458149	EXTENSION SPRING
150	P0458150	TENSION WHEEL ASSY
151	P0458151	CHAIN PROTECTOR
152	P0458152	PHLP HD SCR M5-.8 x 8
153	P0458153	PHLP HD SCR M5-.8 x 6
154	P0458154	EXT RETAINING RING 20MM
155	P0458155	SPACER
156	P0458156	ROLLER
157	P0458157	CAP SCREW M8-1.25 X 25
158	P0458158	FLAT WASHER 8MM
159	P0458159	EXTENSION BRACKET
160	P0458160	FLAT WASHER 8MM
161	P0458161	CAP SCREW M8-1.25 X 16
162	P0458162	ELEVATING SCREW
163	P0458163	HEX NUT M6-1
164	P0458164	EYE BOLT M6-1 X 50
165V2	P0458165V2	CONVEYOR BELT V2.11.16
166	P0458166	BEARING 6205ZZ
167	P0458167	CAP SCREW M6-1 X 25
168	P0458168	CAP SCREW M6-1 X 25
169	P0458169	STRAIN RELIEF
170	P0458170	BEARING SEAT
171	P0458171	EXT RETAINING RING 25MM
172	P0458172	CAP SCREW M6-1 X 25
173	P0458173	LOCKING BLOCK
174	P0458174	FIXED PAN
175	P0458175	FIXED PAN
176	P0458176	HEAD SHAFT
177	P0458177	KEY 6 X 6 X 15
178	P0458178	DRUM
179	P0458179	SANDPAPER
181	P0458181	FIXED PAN
182	P0458182	EXTENSION SPRING
183	P0458183	CAP SCREW M5-.8 X 12
184	P0458184	CAP SCREW M6-1 X 25
185	P0458185	FIXED PAN
186	P0458186	HEAD COVER
187	P0458187	CHIP GUIDE BRACKET
188	P0458188	SIDE COVER
189	P0458189	SPONGE STRIP
190	P0458190	CAP SCREW M6-1 X 10
191	P0458191	PRESSURE PLATE
192	P0458192	BRACKET
193	P0458193	ROLLER PIN
194	P0458194	BUSHING
195	P0458195	ROLLER
196	P0458196	PHLP HD SCR M5-.8 X 16
197	P0458197	CAP SCREW M6-1 X 16
198	P0458198	HINGE
199	P0458199	PHLP HD SCR M5-.8 X 8

G0458 Parts List

REF	PART #	DESCRIPTION
200	P0458200	CAP SCREW M5-.8 X 12
201	P0458201	CHIP DEFLECTOR PLATE
202	P0458202	FLAT HD SCR M6-1 X 10
203	P0458203	FLAT HD SCR M5-.8 X 10
204	P0458204	SET SCREW M5-.8 X 25
205	P0458205	HEX NUT M5-.8
206	P0458206	BUSHING
207	P0458207	CAP SCREW M10-1.5 X 10
208	P0458208	CAP SCREW M10-1.5 X 25
209	P0458209	CAP SCREW M5-.8 X 12
210	P0458210	PRESSURE PLATE
211	P0458211	LINK
212	P0458212	CAP SCREW M6-1 X 10
213	P0458213	SPRING SHEET
214	P0458214	HEADCASTING
215	P0458215	BEARING 6205ZZ
216	P0458216	BEARING COVER
217	P0458217	CAP SCREW M6-1 X 12
218	P0458218	COLLAR
219	P0458219	HEX NUT M5-.8
220	P0458220	SET SCREW M5-.8 X 16
221	P0458221	FLAT WASHER 5MM
222	P0458222	DUST HOSE CLAMP
223	P0458223	SWITCH RESET
224	P0458224	LOCK WASHER 8MM
225	P0458225	OPEN END WRENCH 8/12MM
226	P0458226	PHLP HD SCR M5-.8 X 6
227	P0458227	EXT TOOTH WASHER 5MM
228	P0458228	SPACER
229	P0458229	CAP SCREW M5-.8 X 12
230	P0458230	FLAT WASHER 5MM
231	P0458231	PHLP HD SCR M5-.8 X 8
232	P0458232	STRAIN RELIEF
233	P0458233	POWER CORD
234	P0458234	COMPRESSION SPRING
235	P0458235	PLATE
236	P0458236	FLAT WASHER 6MM
237	P0458237	ROLL PIN 3 X 16
238	P0458238	FLAT WASHER 5MM
239	P0458239	CAP SCREW M5-.8 X 12
241	P0458241	ROD
242	P0458242	CAP SCREW M5-.8 X 12
243	P0458243	PLATE
244	P0458244	FLAT WASHER 5MM
246	P0458246	HEX NUT M5-.8

REF	PART #	DESCRIPTION
247	P0458247	ROD
248	P0458248	ADJUSTMENT BOLT M5-.8 X 35
249	P0458249	SPACER
250	P0458250	PIN
251	P0458251	LOCK WASHER 10MM
253	P0458253	PULLEY COVER
254	P0458254	PULLEY SHAFT
255	P0458255	PULLEY
256	P0458256	HEX BOLT M6-1 X 10
257	P0458257	HEX BOLT M6-1 X 10
258	P0458258	HEX BOLT M6-1 X 10
259	P0458259	FLAT WASHER 6MM
260	P0458260	FLAT WASHER 6MM
261	P0458261	BALL BEARING 6002ZZ
262	P0458262	FLAT WASHER 32MM
263	P0458263	LEG
264	P0458264	FRONT SUPPORTING PLATE
265	P0458265	SIDE SUPPORTING PLATE
266	P0458266	FRONT PLATE
267	P0458267	SIDE PLATE
268	P0458268	CARRIAGE BOLT M8-1.25 X 16
269	P0458269	FLANGE NUT M8-1.25
270	P0458270	HEX BOLT M8-1.25 X 20
271	P0458271	HEX NUT M8-1.25
272	P0458272	FLAT WASHER 8MM
273	P0458273	DUST BAG
274	P0458274	FLAT WASHER 5MM
275	P0458275	G0458 LABEL
276	P0458276	GRIZZLY LOGO
277	P0458277	MACHINE ID LABEL
278	P0458278	SAFETY GLASSES LABEL
279	P0458279	READ MANUAL LABEL
280	P0458280	DUST MASK LABEL
281	P0458281	ELECTRICITY LABEL
282	P0458282	PHLP HD SCR M3-.5 X 16
283	P0458283	HEX NUT M3-.5
284	P0458284	CONNECTING CORD
285	P0458285	FLAT WASHER 5MM
286	P0458286	HEX BOLT M5-.8 X 12
287	P0458287	SET SCREW M6-1 X 6
288	P0458288	LOCK NUT 5/8-8
290	P0458290	BUSHING
295	P0458295	WAVE WASHER 40MM
297	P0458297	SPRING RETAINER
298	P0458298	CAP SCREW M5-.8 X 10

⚠WARNING

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

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinetmaker & FDM
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____Yes _____No

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

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.

To take advantage of 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.

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.

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.