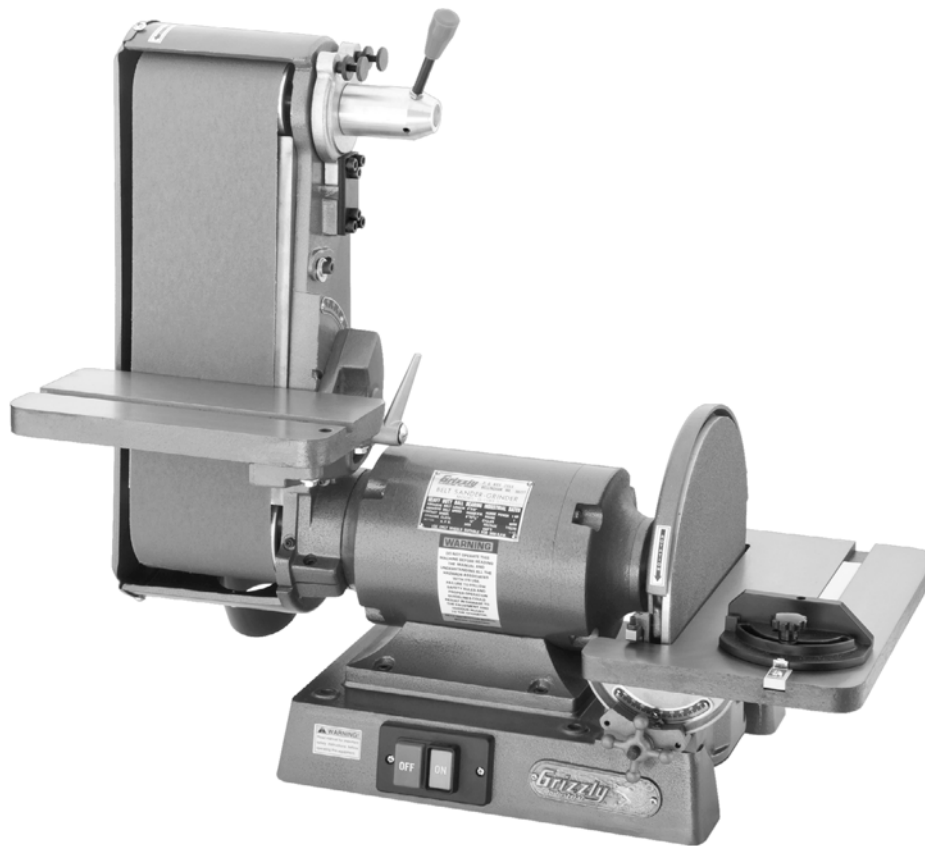


Grizzly **Industrial, Inc.**®

MODEL G1183/G1276 HEAVY-DUTY COMBINATION SANDER OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
(FOR MODELS MANUFACTURED SINCE 3/10) #0335 PRINTED IN TAIWAN



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 offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

Grizzly Industrial		MODEL GXXXX MACHINE NAME
SPECIFICATIONS	WARNING!	
Motor: Specification: Specification: Specification: Weight: Date Serial Number <small>Manufactured for Grizzly in Taiwan</small>	Manufacture Date of Your Machine 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. DO NOT remove safety guards. 8. Never leave machine running unattended. 9. DO NOT operate under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.	

For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
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



Basic Controls

Having a good understanding of the basic controls of the sander is important to properly set up the machine and successfully complete the test run. Refer to **Figure 5** and the following descriptions to gain this understanding.

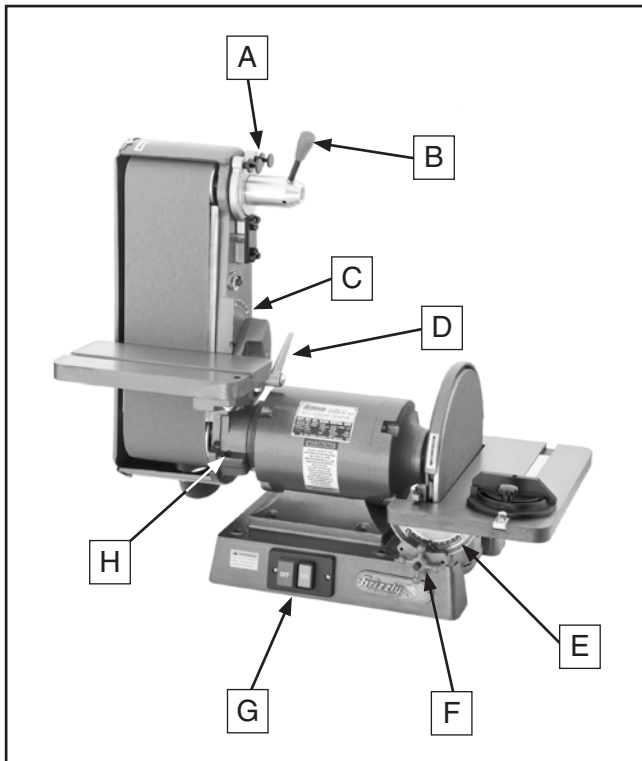
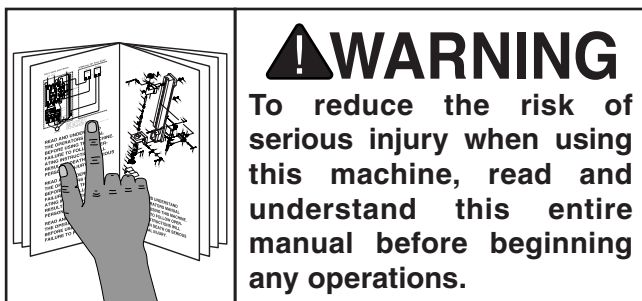


Figure 5. Locations of the basic controls.

- A. Upper Roller Adjustment Screws:** Control the tilt of the upper roller and are used to make it parallel with the lower roller for tracking purposes.
- B. Sanding Belt Quick-Release Tension Lever:** When pulled down, releases the tension on the sanding belt for removal/installation.
- C. Sanding Belt Table Angle Scale:** Displays the tilt angle of the belt table.
- D. Sanding Belt Table Lock Lever:** Locks the belt table in place after changing the tilt angle.
- E. Sanding Disc Table Angle Scale:** Displays the tilt angle of the disc table.
- F. Sanding Disc Table Lock Knob (1 of 2):** Locks the disc table in place after changing the tilt angle.
- G. ON/OFF Switch:** Turns the sander **ON** and **OFF**.
- H. Belt Assembly Locking Cap Screw:** Secures the sanding belt assembly in place after changing its tilt position.





MACHINE DATA SHEET

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

MODEL G1183 COMBINATION SANDER 6" X 48" BELT 12" DISC 3450 RPM

Product Dimensions:

Weight..... 144 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 32-1/2 x 16-1/2 x 29-1/2 in.
Footprint (Length x Width)..... 16-1/2 x 14 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 148 lbs.
Length x Width x Height..... 30 x 28 x 18 in.

Electrical:

Power Requirement..... 110V/220V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 12A at 110V, 6A at 220V
Minimum Circuit Size..... 15A
Switch..... Push Button
Switch Voltage..... 110V
Cord Length..... 5 ft.
Cord Gauge..... 14 gauge
Plug Included..... Yes
Included Plug Type..... NEMA 5-15 for 110V
Recommended Plug/Outlet Type..... NEMA 6-15 for 220V

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower..... 1 HP
Voltage..... 110/220V
Prewired..... 110V
Phase..... Single
Amps..... 12/6A
Speed..... 3450 RPM
Cycle..... 60 Hz
Number of Speeds..... 1
Power Transfer..... Direct Drive
Bearings..... Shielded and Permanently Lubricated



Main Specifications:

Table Info

Table Tilt.....	Belt -20 to +45 deg, Disc -45 to +45 deg.
Miter Gauge Slot Width.....	3/4 in.
Miter Gauge Slot Height.....	3/8 in.
Belt Table Length.....	12-1/2 in.
Belt Table Width.....	7 in.
Belt Table Thickness.....	1-1/4 in.
Disc Table Length.....	16-1/2 in.
Disc Table Width.....	7 in.
Disc Table Thickness.....	1 in.

Belt Info

Sanding Belt Width.....	6 in.
Sanding Belt Length.....	48 in.
Sanding Belt Speed.....	5000 FPM
Belt Arm Tilt.....	0 - 90 deg.
Height Belt Arm Horizontal.....	14-1/2 in.
Height Belt Arm Vertical.....	29-1/2 in.
Belt Release.....	Quick Release
Drive Roller Type.....	Aluminum
Drive Roller Length.....	6-1/4 in.
Drive Wheel Diameter.....	5 in.
Idler Roller Type.....	Aluminum
Idler Roller Length.....	6-1/4 in.
Idler Roller Diameter.....	3-1/2 in.

Spindle Info

Arbor Size.....	3/4 in.
Total Arbor Length.....	6 in.

Disc Info

Sanding Disc Diameter.....	12 in.
Sanding Disc Speed.....	3450 RPM

Platen Info

Platen Type.....	Cast Iron
Platen Length.....	14-1/2 in.
Platen Width.....	6 in.
Platen Travel.....	1/4 in.

Construction

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

Other

No. Of Dust Ports.....	2
Dust Port Size.....	2-1/2, 3 in.

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine Label on Motor
Assembly Time	45 minutes





MACHINE DATA SHEET

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

MODEL G1276 COMBINATION SANDER 6" X 48" BELT 12" DISC 1725 RPM

Product Dimensions:

Weight..... 145 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 32-1/2 x 16-1/2 x 29-1/2 in.
Footprint (Length x Width)..... 17 x 14 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 150 lbs.
Length x Width x Height..... 30 x 28 x 18 in.

Electrical:

Power Requirement..... 110V/220V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 12A at 110V, 6A at 220V
Minimum Circuit Size..... 15A
Switch..... Push Button
Switch Voltage..... 110V
Cord Length..... 5 ft.
Cord Gauge..... 14 gauge
Plug Included..... Yes
Included Plug Type..... NEMA 5-15 for 110V
Recommended Plug/Outlet Type..... NEMA 6-15 for 220V

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower..... 1 HP
Voltage..... 110/220V
Prewired..... 110V
Phase..... Single
Amps..... 12/6A
Speed..... 1725 RPM
Cycle..... 60 Hz
Number of Speeds..... 1
Power Transfer..... Direct Drive
Bearings..... Shielded and Permanently Lubricated



Main Specifications:

Table Info

Table Tilt.....	Belt -20 to +45 deg; Disc -45 to +45 deg.
Miter Gauge Slot Width.....	3/4 in.
Miter Gauge Slot Height.....	3/8 in.
Belt Table Length.....	12-1/2 in.
Belt Table Width.....	7 in.
Belt Table Thickness.....	1-1/4 in.
Disc Table Length.....	16-1/2 in.
Disc Table Width.....	7 in.
Disc Table Thickness.....	1 in.

Belt Info

Sanding Belt Width.....	6 in.
Sanding Belt Length.....	48 in.
Sanding Belt Speed.....	2500 FPM
Belt Arm Tilt.....	0 - 90 deg.
Height Belt Arm Horizontal.....	14-1/2 in.
Height Belt Arm Vertical.....	29-1/2 in.
Belt Release.....	Quick Release
Drive Roller Type.....	Aluminum
Drive Roller Length.....	6-1/4 in.
Drive Wheel Diameter.....	5 in.
Idler Roller Type.....	Aluminum
Idler Roller Length.....	6-1/4 in.
Idler Roller Diameter.....	3-1/2 in.

Spindle Info

Arbor Size.....	3/4 in.
Total Arbor Length.....	6 in.

Disc Info

Sanding Disc Diameter.....	12 in.
Sanding Disc Speed.....	1725 RPM

Platen Info

Platen Type.....	Cast Iron
Platen Length.....	14-1/2 in.
Platen Width.....	6 in.
Platen Travel.....	1/4 in.

Construction

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

Other

No. Of Dust Ports.....	2
Dust Port Size.....	2-1/2, 3 in.

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine Label on Motor
Assembly Time	45 minutes



SECTION 1: SAFETY


WARNING

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.

 **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.

WARNING

Safety Instructions for Machinery

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

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.

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

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 avoid accidental slips which could cause a loss of workpiece control.

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.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



WARNING

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well-lighted to minimize risk of injury.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify or alter machine for a purpose not intended by the manufacturer or serious injury may result!

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

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

REMOVE ADJUSTING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

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

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

NEVER STAND ON MACHINE. Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

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.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine may increase the risk of serious injury.

CHECK DAMAGED PARTS. Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

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



WARNING

Additional Safety for Combination Sanders

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

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

HAND PLACEMENT. Rotating sandpaper can remove a large amount of flesh in a few seconds. Always keep hands away from the sandpaper during operation. Never touch moving sandpaper on purpose.

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

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

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

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

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

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

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

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

WARNING

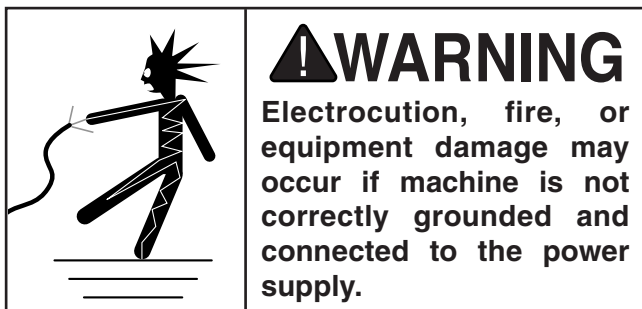
Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious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



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 a qualified electrician 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 110V..... 12 Amps
Full-Load Current Rating at 220V 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 requirements in the following section.

Circuit Information

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



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

Circuit Requirements for 110V

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V/120V
Cycle 60 Hz
Phase Single-Phase
Circuit Rating 15 Amps
Plug/Receptacle NEMA 5-15

Circuit Requirements for 220V

This machine can be converted to operate on a 220V power supply (refer to **Voltage Conversion** instructions). This power supply must have a verified ground and meet the following requirements:

Nominal Voltage 220V/240V
Cycle 60 Hz
Phase Single-Phase
Circuit Rating 15 Amps
Plug/Receptacle NEMA 6-15



Grounding Requirements

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

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

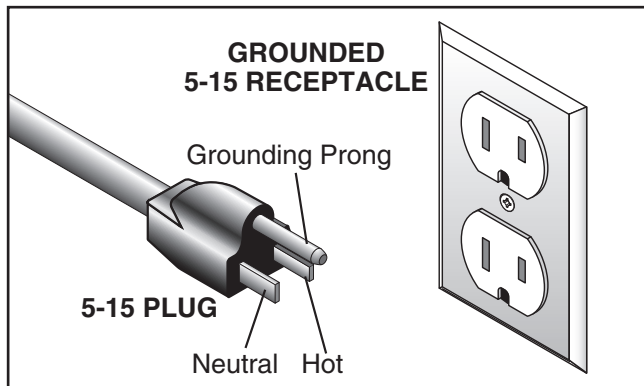


Figure 6. Typical 5-15 plug and receptacle.

⚠ CAUTION

SHOCK HAZARD!

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

For 220V operation: The plug specified under “Circuit Requirements for 220V” 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.

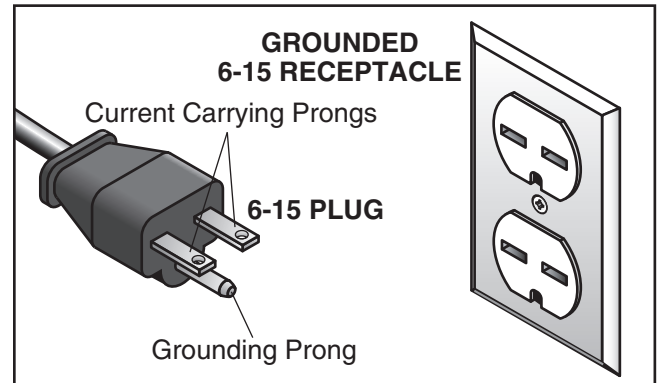


Figure 7. Typical 6-15 plug and receptacle.

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

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the 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.

⚠ WARNING

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



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 may 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 contain a ground wire, match the required plug and receptacle, and meet the following requirements:

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

Voltage Conversion

The voltage conversion **MUST** be performed by an electrician or qualified service personnel. Make sure the power supply circuit for the new voltage meets the specified circuit requirement on **Page 11**.

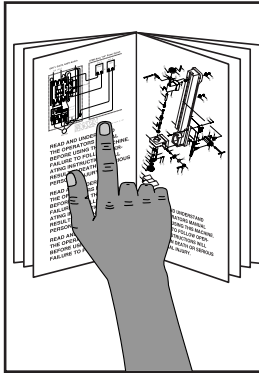
To convert the machine to 220V:

1. DISCONNECT MACHINE FROM POWER!
2. Replace the 5-15 plug on the power cord with a 6-15 plug.
3. Re-wire the motor as illustrated in the wiring diagram on **Page 39**.

Note: *If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor.*

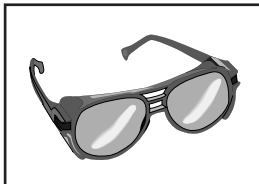


SECTION 3: SETUP



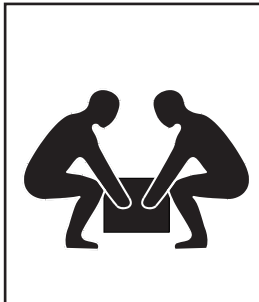
!WARNING

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!



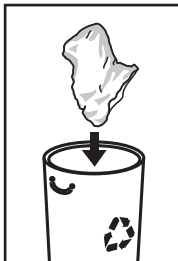
!WARNING

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

SUFFOCATION HAZARD!

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

Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Additional Person for Lifting	1
• Standard Screwdriver #2.....	1
• Phillips Screwdriver #2	1
• Hex Wrench 6mm.....	1
• Wrench 1 ¹ / ₁₆ "	1
• Wrench 1/2"	1
• Wrench 3/8"	1
• 90° Square	1
• Fine Ruler.....	1
• Straight Edge 12"	1
• Dust Collection System	1
• Dust Hose 3"	1
• Hose Clamp 3"	1
• Dust Hose 2 ¹ / ₂ "	1
• Hose Clamp 2 ¹ / ₂ "	1

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Inventory

The following is a description of the main components shipped with your machine. Lay the components out to 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.

Shipping Inventory: (Figure 8)	Qty
A. Sander Assembly	1
B. Sanding Belt Table	1
C. Belt Table Trunnion	1
D. Dust Port 3"	1
E. Disc Table w/Trunnions	1
F. Miter Gauge Assembly	1
G. Dust Hose Assembly 2 1/2"	1
H. Hardware (Not Shown):	
—Quick-Release Tension Lever	1
—Hex Bolts 5/16"-18 x 1"	3
—Flat Washers 5/16"	3
—Flange Screws 1/4"-20 x 1/2"	2
—Phillips Head Screws #10-24 x 3/8"	2
—Hex Wrench 6mm	1

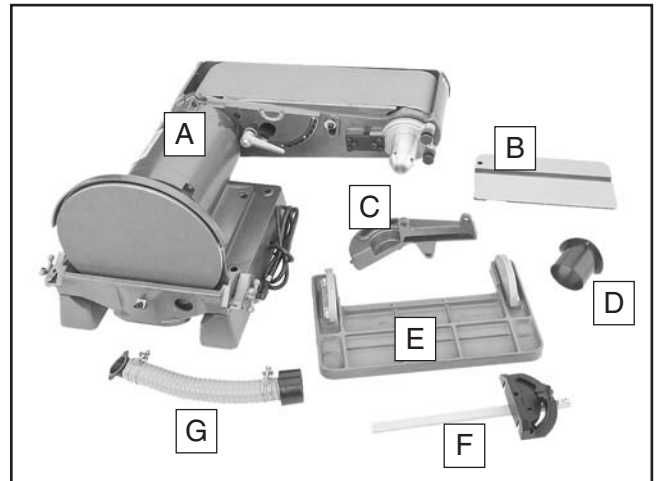


Figure 8. Shipping inventory.

NOTICE

If you cannot find an item on this list, check the mounting location on the machine or the packaging materials. Sometimes parts are pre-installed for shipping, or they become hidden by packaging materials.



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.

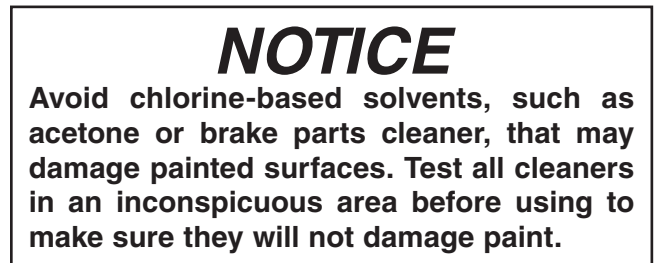
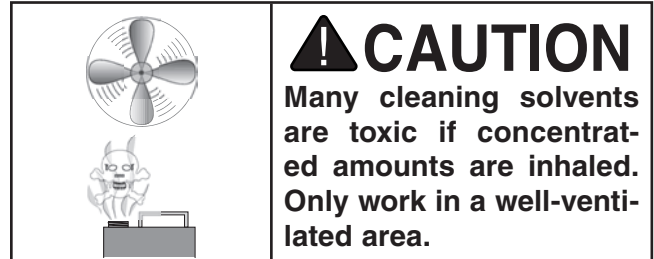
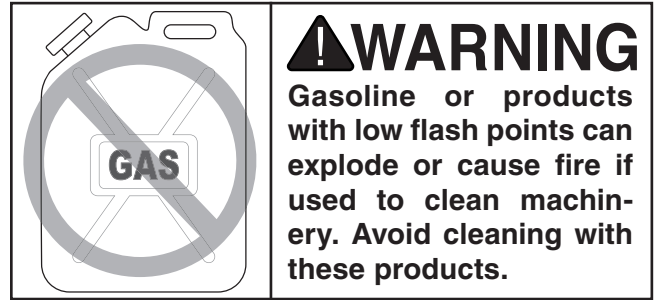
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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.



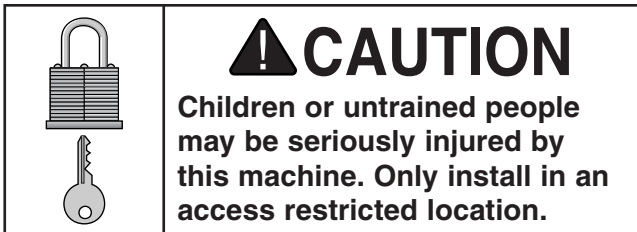
Site Considerations

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.**



Physical Environment

The physical environment where your machine is operated is important for safe operation and the longevity of its 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 access to a means of disconnecting the power source or engaging a lockout/tagout device.

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.

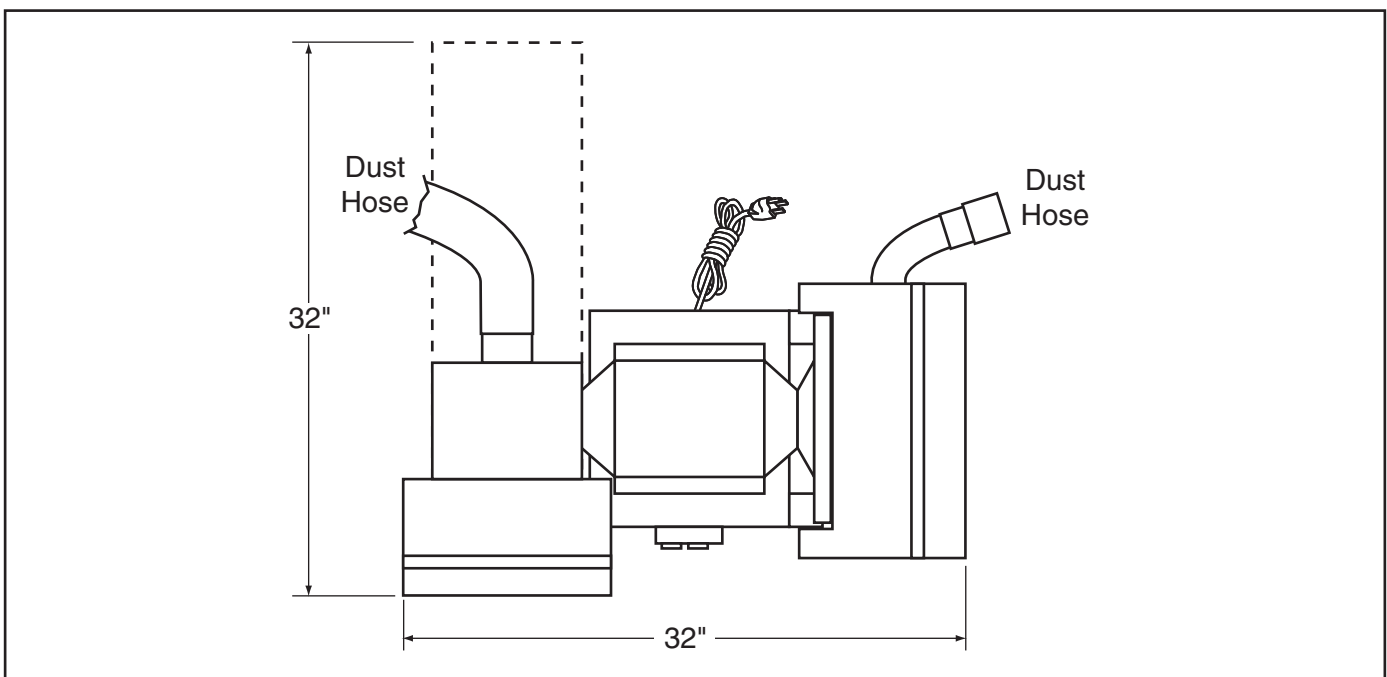


Figure 9. Minimum working clearances.



Mounting

The base of this machine has holes that accept $\frac{5}{8}$ " bolts for mounting the machine to a workbench. We strongly recommend that you mount your machine to a workbench to prevent it from moving during operation. An unexpected movement could result in an injury or property damage.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the drill press to the workbench.

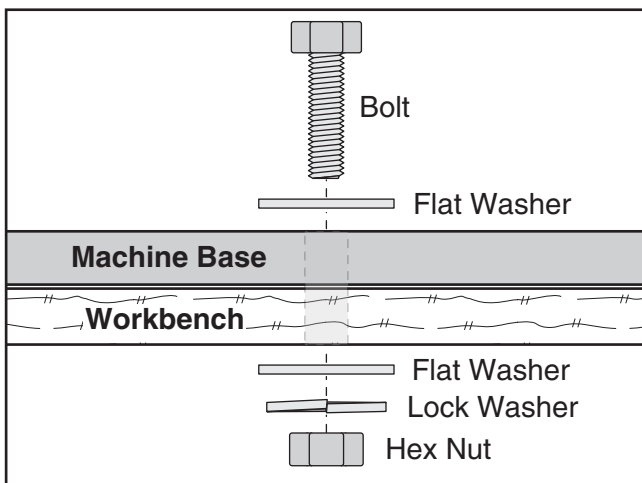


Figure 10. Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw and flat washer.

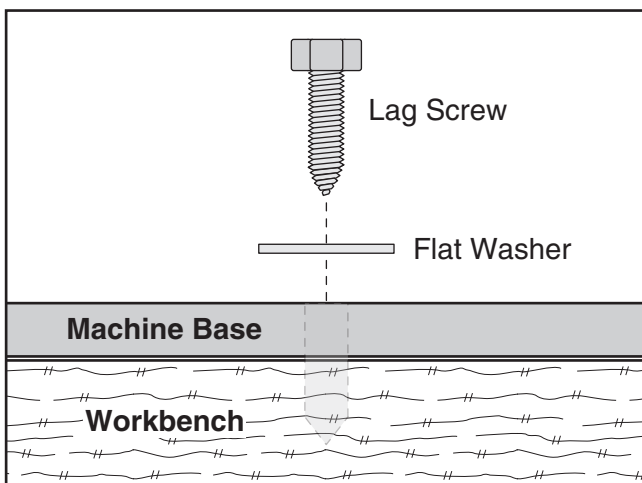


Figure 11. Example of a direct mount setup.

Assembly

To assemble the sander:

1. Unthread the screw cap on the sanding belt table lock lever, remove the lever, then unthread the lock bolt and flat washer from the sander (see **Figure 12**).

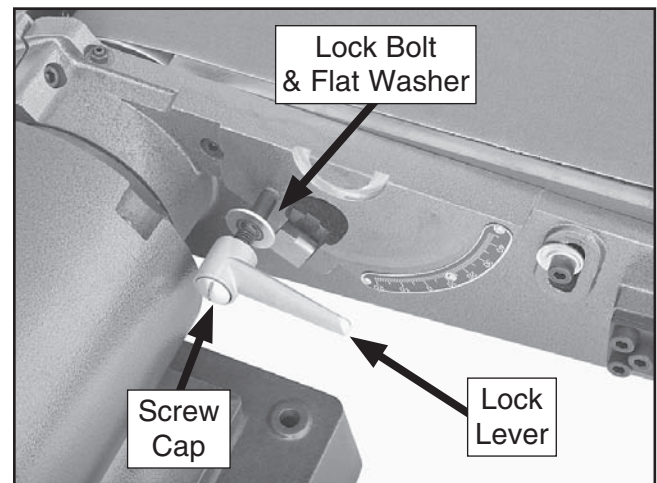


Figure 12. Sanding belt lock lever.

2. Position the belt table trunnion against the side of the belt housing so that the semicircular flange fits into the keyway, then secure the trunnion in place with the lock bolt that was removed in **Step 1** (see **Figure 13**).

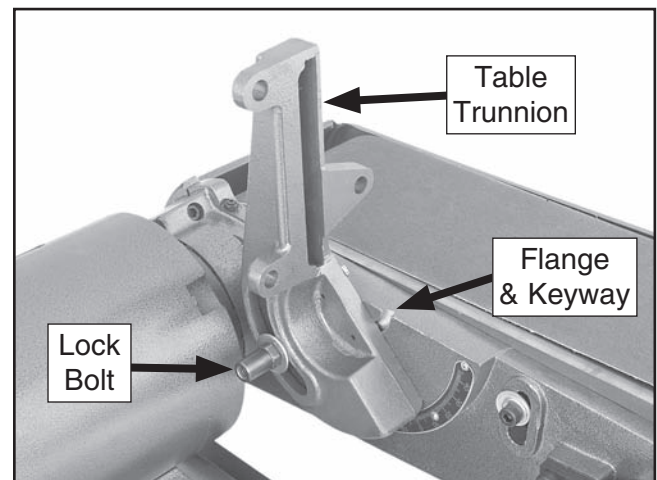


Figure 13. Sanding belt table trunnion installed.

3. Re-install the lock lever onto the lock bolt.

- Attach the sanding belt table to the trunnion by finger tightening the (3) $\frac{5}{16}$ "-11 x 1" hex bolts and $\frac{5}{16}$ " flat washers from underneath the table, as shown in **Figure 14**. The hex bolts will be fully tightened when aligning the tables in later steps.

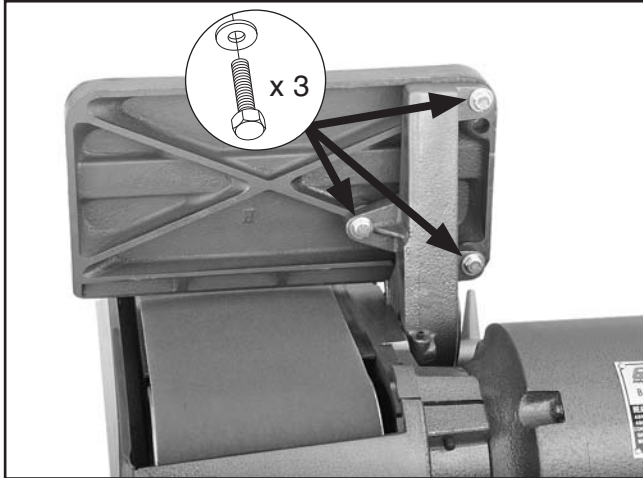


Figure 14. Sanding belt table installed.

- Attach the 3" dust port to the bottom of the sanding belt housing with the (2) $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " Phillips head screws, as shown in **Figure 15**.

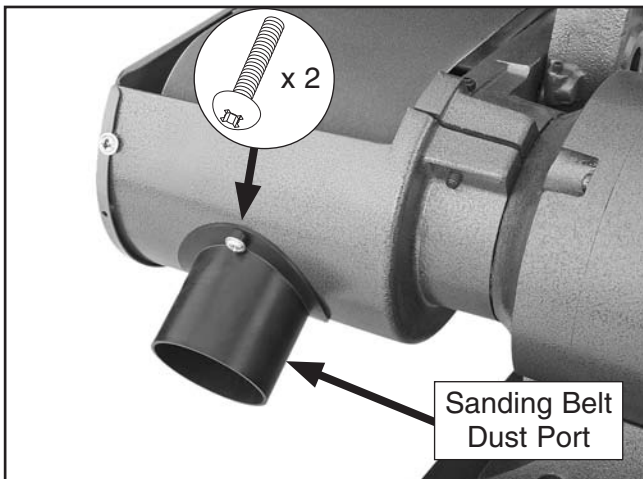


Figure 15. Sanding belt dust port attached.

- Loosen the sanding belt pivot cap screw shown in **Figure 16**, rotate the sanding belt assembly to the vertical position, then re-tighten the cap screw to hold it place.

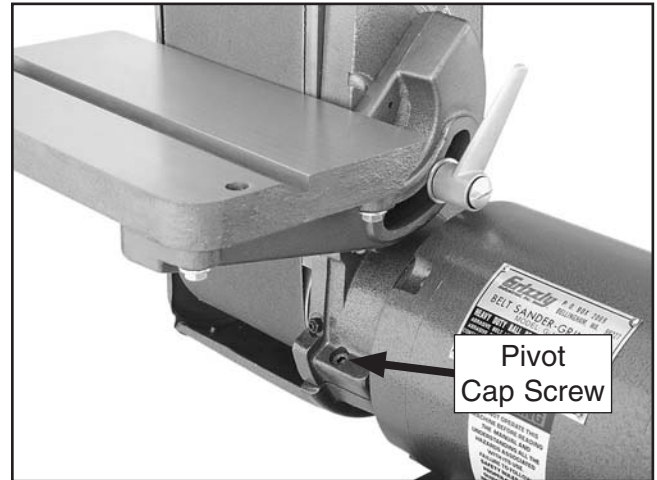


Figure 16. Location of the sanding belt pivot cap screw.

- Attach the dust hose assembly to the lower disc bracket with the (2) #10-24 x $\frac{3}{8}$ " flange screws, as shown in **Figure 17**.

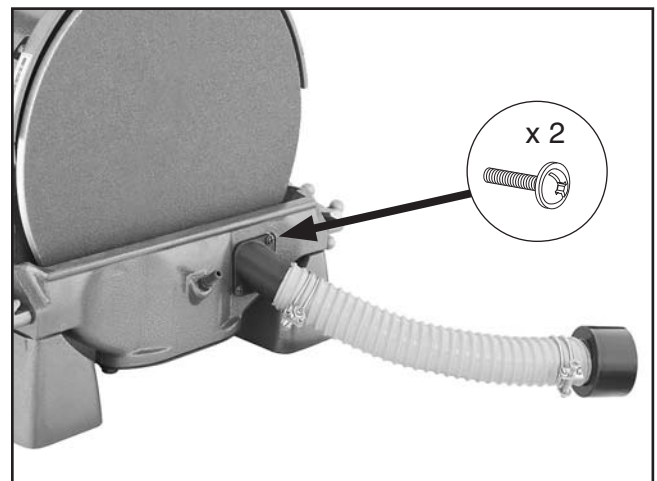


Figure 17. Sanding disc dust hose assembly attached.

- Loosen the sanding disc table lock knobs, then move the trunnion brackets away from the lower disc guard, as shown in **Figure 18**.

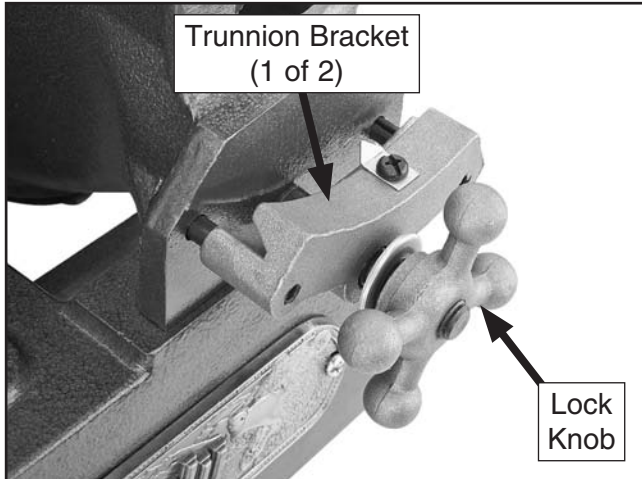


Figure 18. Lock knob and trunnion bracket positioned to receive the table trunnion.

- Place the sanding disc table trunnions between the bracket and lower disc guard, then tighten the lock knobs to hold the table in place (see **Figure 19**).

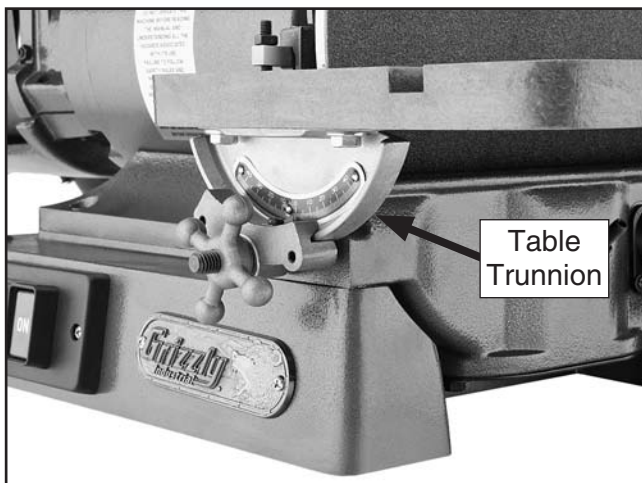


Figure 19. Sanding disc table trunnion secured by the lock knob.

Table Gap Adjustment

To reduce the risk of in-running nip (pinch) points, yet avoid the risk of the sandpaper contacting the tables, the tables should be adjusted away from the sandpaper no more than $\frac{1}{16}$ ".

Note: *The procedure for the table gap adjustment is similar for both tables.*

To adjust the table-to-sandpaper gap:

- DISCONNECT SANDER FROM POWER!**
- First, check the existing adjustment by sliding the miter gauge into the table T-slot, then positioning a 90° square flat against the miter face and up against the sanding surface, as shown in **Figure 20**.

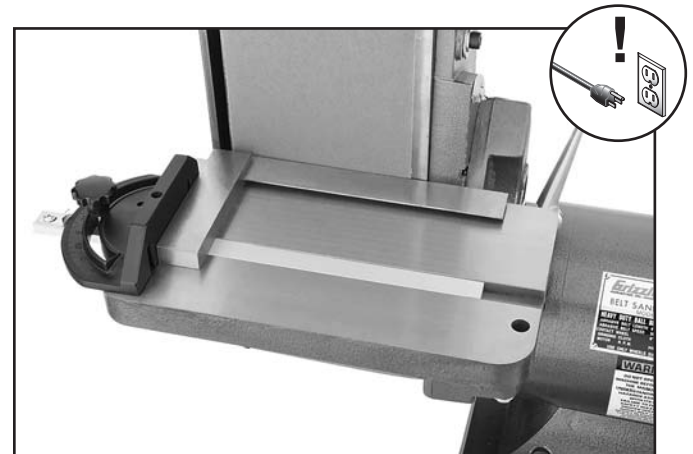


Figure 20. Positioning the miter gauge and square for aligning the table.

—If the square is flat against the miter face and the sanding surface, and the table is no more than $\frac{1}{16}$ " away from the sandpaper for both tables, no adjustments are needed. Fully tighten the hex bolts underneath the table. Continue to the **Checking Belt Tracking** procedure.

—If the square is not flat against the sanding surface as it remains flat against the miter face, or the table is not at least $\frac{1}{16}$ " away from the sanding surface, continue with the next step.

- Loosen the hex bolts underneath the table that secure it to the trunnion(s).

Note: The sanding belt table has three hex bolts (see **Figure 21**), and the sanding disc table has two hex bolts on both sides of the table (see **Figure 22**).

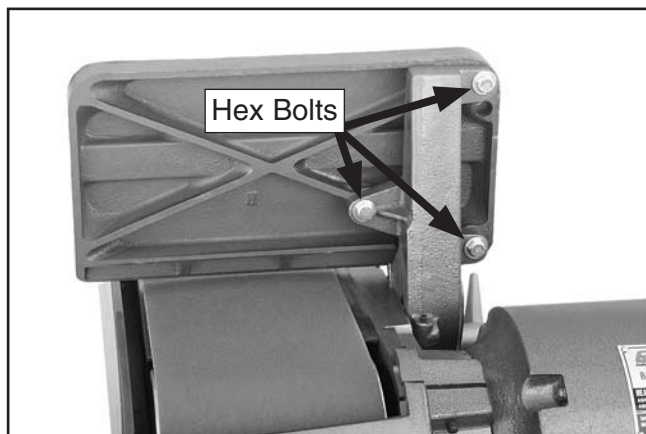


Figure 21. Sanding belt trunnion hex bolts.

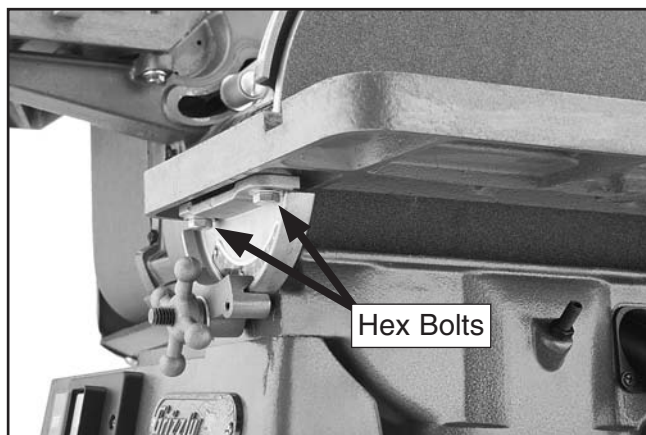


Figure 22. Sanding disc trunnion hex bolts (2 of 4 shown).

- Adjust the table so that when the square is flat against the miter face and the sanding surface at the same time, and that the table is no more than $\frac{1}{16}$ " away from the sandpaper, then re-tighten the hex bolts.
- Repeat **Step 2** to make sure the table is properly positioned. If necessary, repeat **Steps 3–4** until it is.

Checking Belt Tracking

Proper belt tracking depends on two conditions: 1) The platen height, and 2) the upper roller parallelism.

The upper belt roller is designed with a slight crown in the middle, and the belt platen should be even with the highest point of this crown to ensure proper belt tracking.

Additionally, the upper roller should be parallel to the lower roller so that the sanding belt rides evenly in the middle of the rollers.

To check the belt tracking:

- DISCONNECT SANDER FROM POWER!
- Put on heavy leather gloves to protect your hands from the abrasive sandpaper
- Rotate the sandpaper belt down toward the table several times by hand—NOT by power—as fast as possible (see **Figure 23**).

—If the belt stays centered on the rollers, continue to the **Dust Collection** procedure on **Page 22**.

—If the belt begins moving to one side or the other, perform the **Tracking Roller & Platen Adjustment** on **Page 35** to make sure the belt tracks properly.



Figure 23. Rotating the sanding belt to check belt tracking.

Dust Collection

⚠ CAUTION

DO NOT operate the Model G1183/G1276 without an adequate dust collection system. This sander creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at:

3" Dust Port..... 220 CFM

2½" Dust Hose..... 150 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 the sander to the dust collection system:

1. Fit the dust hoses over both dust ports, as shown in **Figure 24**, and secure them in place with hose clamps.
2. Tug the hoses to make sure they do not come off. **Note:** A tight fit is necessary for proper performance.

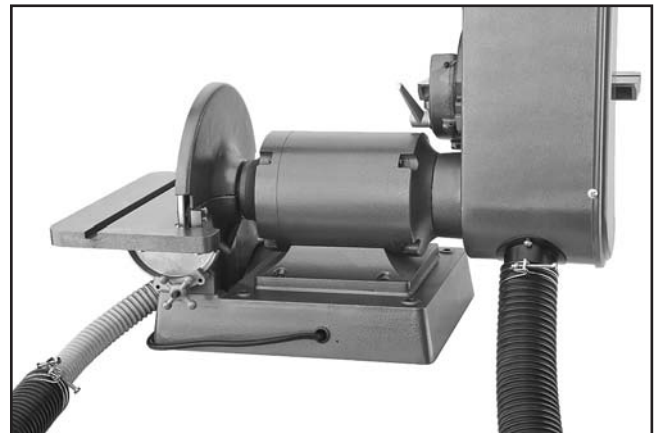


Figure 24. Dust hoses attached.

Power Connection

After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine.

Connecting Power

1. Turn the machine power switch **OFF**.
2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

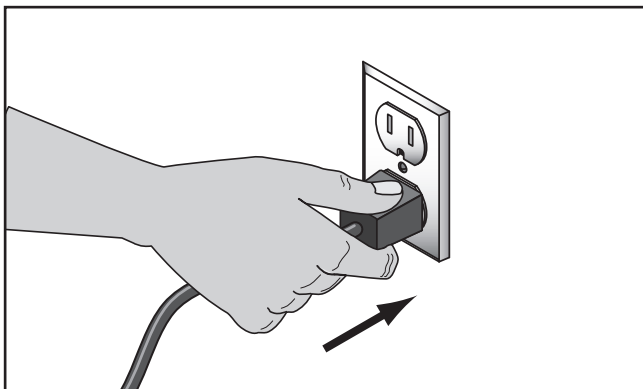


Figure 25. Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.
2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.

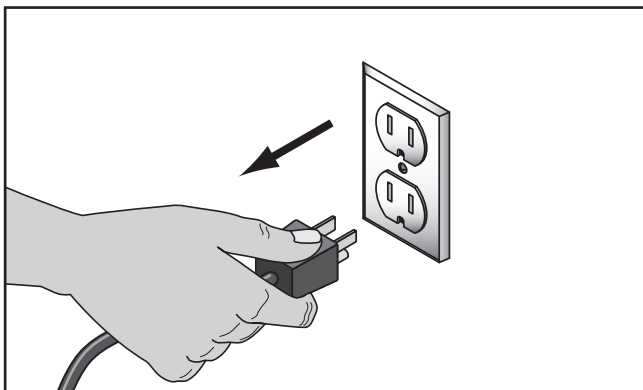


Figure 26. Disconnecting power.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 33**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.

Important: When turning the sander **ON**, if the sanding belt begins to track to one side or the other, immediately turn the machine **OFF** and disconnect it from power. Then, perform the **Tracking Roller & Platen Adjustment** procedure on **Page 35**.

3. Turn the machine **ON**.
4. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

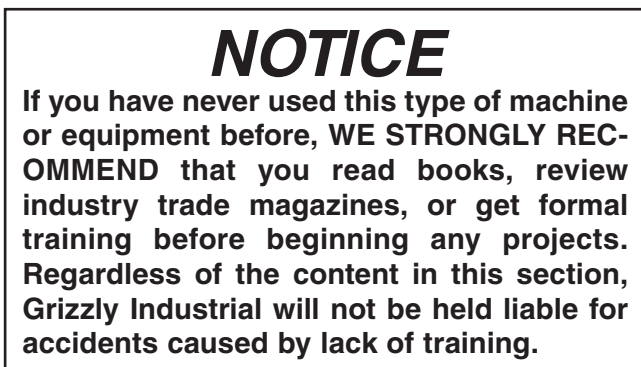
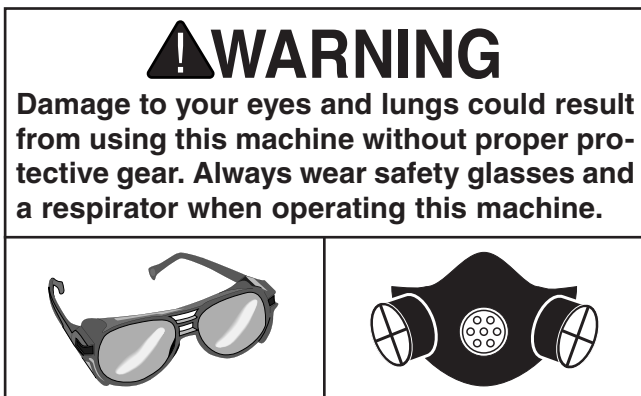
5. Turn the machine **OFF**.

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 and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



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

1. Examines the workpiece to make sure it is suitable for sanding.
2. Adjusts the table tilt, if necessary, to the correct angle for the operation.
3. Makes sure the sandpaper is in good condition and properly mounted.
4. Puts on safety glasses and a respirator, and turns the dust collection system **ON**.
5. Starts the sander.
6. Makes sure the sanding belt is tracking properly.
7. Feeds the workpiece slowly into the sandpaper while maintaining firm pressure on the workpiece against the table or miter gauge. Keeps hands and fingers away from the moving sandpaper.
8. Stops the machine.



Table Tilt

Angle sanding is performed with the table tilted away from 0° (perpendicular to the sanding surface). Compound angles are sanded using a combination of table tilt and miter gauge angle.

Table Tilt Ranges

Sanding Belt Table -45° to +45°
Sanding Disc Table -40° to +30°

Both tables have an adjustable positive stop that is used to quickly return the table to 0°. The belt table has an additional stop at -45° and uses a flip stop to engage the stops. The disc table has an additional stop at -40° underneath the table (see **Figures 27–29**).

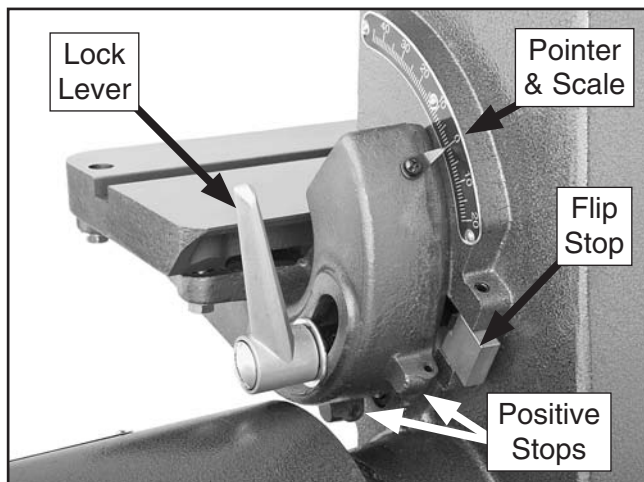


Figure 27. Sanding belt table tilting controls.

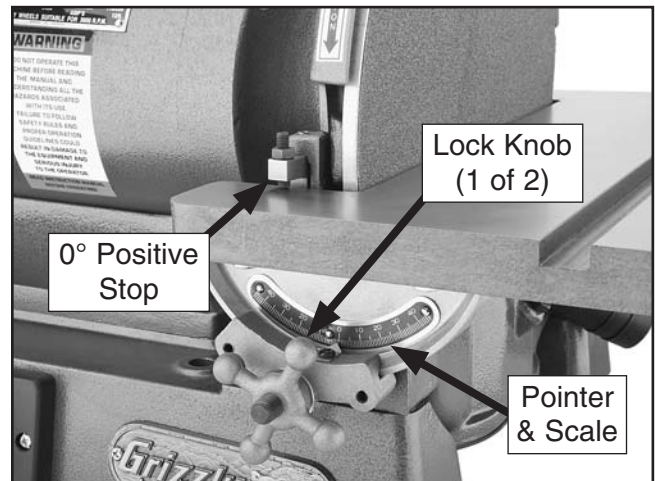


Figure 28. Sanding disc table tilting controls.

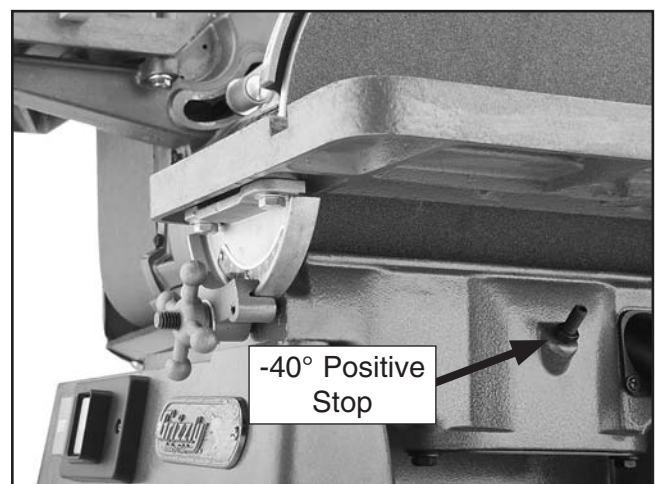


Figure 29. Sanding disc table -40° positive stop.

⚠ 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.

Sandpaper Selection

Sanding a workpiece smooth requires using progressively smaller grit sandpaper until the desired finish is attained.

The abrasiveness of sandpaper is designated in grit size—the larger the number, the finer the abrasive and the smaller the scratches. Thus, 100 grit is finer than 60 grit.

Typically, sanding operations start with a coarse grit and progressively work through the finer (larger number) grits until the desired finish is achieved. Avoid skipping a grit to achieve the best results.

Choosing the correct grits involve many factors, such as the workpiece condition, type/hardness, and the desired finish.

There are many types of sanding belts and discs 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.

NOTICE

To ensure good sanding results, never skip more than 50 grit with each sandpaper change.

Sanding Belt Replacement

The Model G1183/G1276 ships with a pre-installed 80-grit, 6" x 48" sanding belt.

Tools Needed	Qty
Phillips Head Screwdriver #2	1

To change the sanding belt:

1. DISCONNECT SANDER FROM POWER!
2. Loosen the four Phillips head screws that secure the left cover of the sanding belt housing, then remove the cover.
3. Pull the spring-loaded quick-release tension lever forward to lower the top roller, then remove the sanding belt.

Note: Typically, sanding belts have a direction arrow printed on the inside. Match this arrow with the direction arrow label on top of the sanding belt housing (see **Figure 30**). This will ensure that belt seams are correctly oriented for longer belt life.

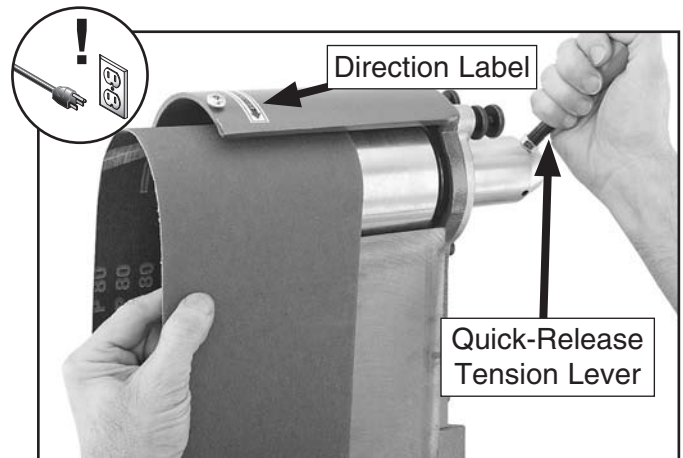


Figure 30. Replacing sanding belt.

4. While still holding the tension lever down, center the new belt on the top roller, then release the tension lever.
5. Perform the **Checking Belt Tracking** on **Page 21** to ensure the new belt will track properly during operation.



Disc Sandpaper Replacement

The Model G1183/G1276 sander ships with a pre-installed 80-grit, 12" diameter adhesive-backed sanding disc.

The sanding disc sticks to the surface of the cast iron disc platen, using the pressure-sensitive adhesive (PSA) backing. The sandpaper can be replaced without removing the table or dust port.

To replace the disc sandpaper:

1. DISCONNECT SANDER FROM POWER!
2. Peel off the old sandpaper, clean the disc surface with mineral spirits, then wipe it dry.
3. Peel back the protective layer on **one-half** of the sandpaper disc and fold it against the remaining half.
4. Slip the half with the protective layer between the disc and the table edge (see **Figure 31** for an example).



Figure 31. Example photo of installing the sandpaper disc.

5. Position the exposed adhesive on the upper half of the aluminum disc that extends above the table. Once it is positioned evenly across the disc, press the adhesive onto the surface.
6. Rotate the disc so the lower half is above the table. Peel off the other half of the protective paper, then press the remaining sandpaper against the disc so adhesion is complete.

Disc Sanding

⚠ CAUTION

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

Refer to **Figures 32–35** for examples of sanding operations that are possible with the sanding disc.



Figure 32. Example photo of 90° disc sanding.

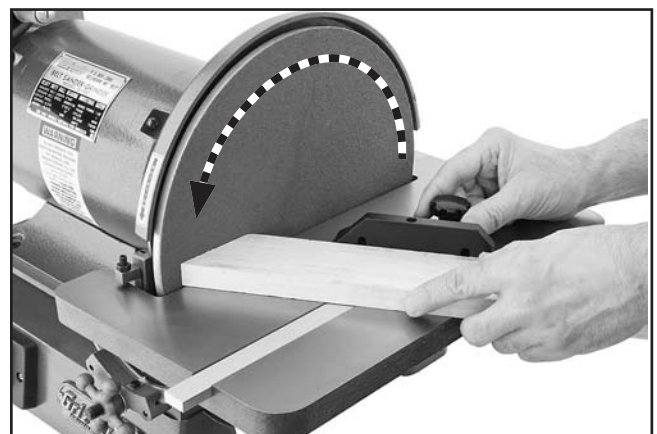


Figure 33. Example of miter sanding.



Figure 34. Example of compound angle sanding.

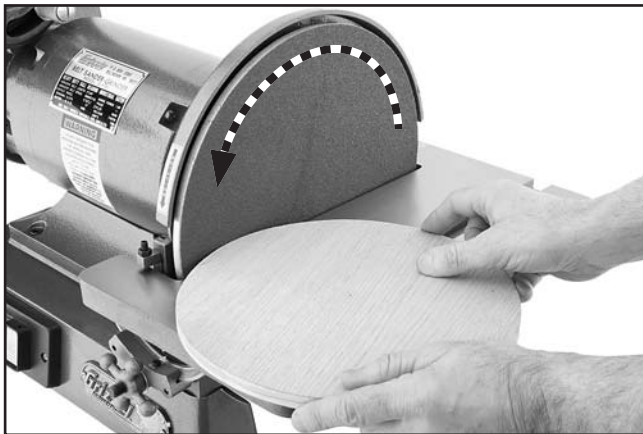


Figure 35. Example of round workpiece sanding.

Belt Sanding

The sanding belt removes material faster than the sanding disc, and can be secured at any angle from horizontal to completely vertical with the use of the pivot cap screw shown in **Figure 36**.

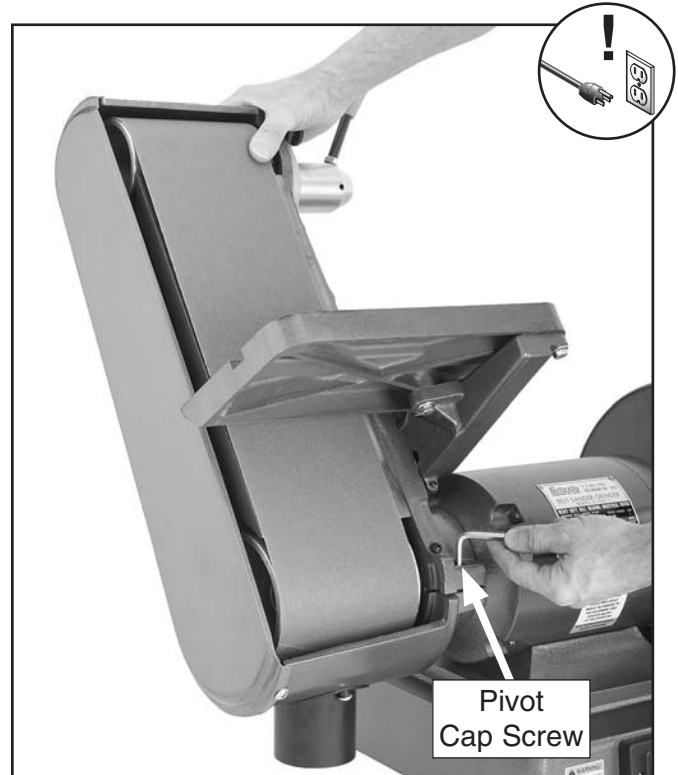


Figure 36. Positioning the sanding belt assembly.

⚠ CAUTION

If the sanding belt or table unexpectedly moves when sanding, your hands could slip and contact the moving sandpaper, resulting in abrasion injuries. Always make sure the table lock lever and the sanding belt pivot cap screw are tight before operation.

⚠ CAUTION

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

Refer to **Figures 37–40** for examples of sanding operations that are possible with the belt sanding assembly.



Figure 37. Sanding workpiece in horizontal position.

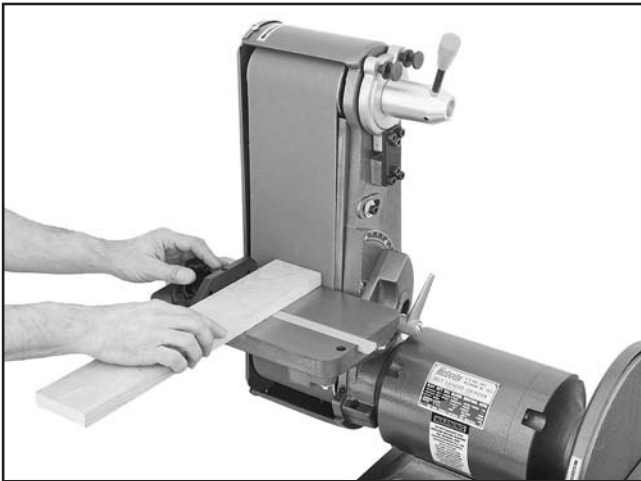


Figure 38. Example of end grain sanding.



Figure 39. Example of vertical miter sanding.



Figure 40. Examples of vertical face and edge sanding.

NOTICE

Sanding workpieces with high-resin content or with applied finishes can quickly contaminate the sandpaper beyond the point where it can be properly cleaned. This will produce poor sanding results. In this case, use a different workpiece, remove the applied finishes, or frequently clean/replace the sandpaper strip.

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

6" x 48" Aluminum Oxide Sanding Belts

Our aluminum oxide sanding belts are available in grits from 60–220 and packs of two.

Grit	Model
60 Grit, 2 pack	G1214
80 Grit, 2 pack.....	G4283
100 Grit, 2 pack.....	G1215
120 Grit, 2 pack.....	G4284
150 Grit, 2 pack.....	G1216
180 Grit, 2 pack.....	G4285
220 Grit, 2 pack.....	G4286

12" PSA Aluminum Oxide Sanding Discs

Our aluminum oxide sanding discs are manufactured in ISO 9002 factories to ensure the highest quality and are available in packs of two.

Grit	Model
60 Grit.....	G1220
80 Grit.....	G4255
100 Grit.....	G1221
120 Grit.....	G4256
150 Grit.....	G1222
180 Grit.....	G4257
220 Grit.....	G4258

G2405—Safety Push Blocks

Made of high-impact molded plastic, these safety push blocks have a layer of friction rubber on the bottom that grabs your workpiece as you press down. We strongly recommend these for use with sanders, jointers, router tables, shapers and table saws. Measures 3" x 6".



Figure 41. G2405 Safety Push Blocks.

T20501—Face Shield Crown Protector 4"

T20502—Face Shield Crown Protector 7"

T20503—Face Shield Window

T20452—"Kirova" Anti-Reflective S. Glasses

T20451—"Kirova" Clear Safety Glasses

H0736—Shop Fox® Safety Glasses

H7194—Bifocal Safety Glasses 1.5

H7195—Bifocal Safety Glasses 2.0

H7196—Bifocal Safety Glasses 2.5



Figure 42. Eye protection assortment.



Pro-Stik® Abrasive Belt Cleaners

G1511—Small: (1½" x 1½" x 8½")

G1512—Large: (2" x 2" x 12")



Figure 43. Pro-Stik® Belt Cleaners.

G0710—Wall Hanging Dust Collector

Mount this 1 HP Dust Collector to your wall and keep precious floor space free of clutter. With 450 CFM, this dust collector will handle just about any dust producing machine in your shop. Add a couple of blast gates and a Y fitting and you've got a small dust collection system. A simple mounting bracket allows you to hang this dust collector on the wall, or lift it off to use in a horizontal position on the floor. Very versatile!



Figure 44. G0710 Dust Collector.

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 45. Half-mask respirator with disposable cartridge filters.

Heavy-Duty Birch Workbench

H8361—60" x 30"

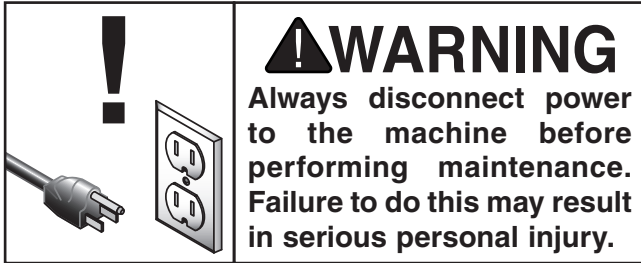
H8362—72" x 36"

Sized to fit the needs of any shop, these Super Heavy-Duty Birch Workbenches have solid 3" thick tops. The solid wood end vise measures 14¾" wide (H8361) or 17¾" (H8362) and has a 7" maximum capacity. Stable laminated birch provides strength and durability.



Figure 46. H8362 Super Heavy-Duty Birch Workbench.

SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Before & During Operation:

- Loose mounting bolts.
- Damaged, excessively worn, or clogged sandpaper.
- Worn or damaged switch or wires.
- Excessive dust build-up.
- Efficiency of the dust collection system.
- Any other unsafe condition.

Lubrication

All bearings on the sander are permanently lubricated and sealed, and they need no further attention unless they require replacement.

Cleaning & Protecting Machine

Cleaning the Model G1183/G1276 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 surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Then apply a non-staining rust preventative that does not contain silicone or oil.

Cleaning Sandpaper

When the sandpaper surface becomes clogged with resin or gummy sawdust, the efficiency of the sanding operation is significantly reduced and can leave glazed or gouge marks in the workpiece.

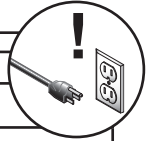
Regularly clean the belt and disc sandpaper by using crepe-rubber cleaners (see **Accessories** on **Page 31** for options from Grizzly).



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Power supply switched OFF or at fault. 2. Plug/receptacle at fault/wired wrong. 3. Motor connection wired wrong. 4. Wall circuit breaker tripped. 5. Wiring open/has high resistance. 6. Start capacitor at fault. 7. Motor ON/OFF switch at fault. 8. Motor at fault. 	<ol style="list-style-type: none"> 1. Ensure power supply is on/has correct voltage. 2. Test for good contacts; correct the wiring. 3. Correct motor wiring connections. 4. Ensure circuit size is correct/replace weak breaker. 5. Check/fix broken, disconnected, or corroded wires. 6. Test/replace if faulty. 7. Replace switch. 8. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Feed rate too aggressive. 2. Machine undersized for task. 3. Workpiece material not suitable for machine. 4. Motor wired incorrectly. 5. Plug/receptacle at fault. 6. Motor bearings at fault. 7. Motor overheated. 8. Motor at fault. 	<ol style="list-style-type: none"> 1. Decrease feed rate. 2. Clean/replace sandpaper; reduce feed rate/sanding depth. 3. Only sand wood, ensure moisture is below 20%. 4. Wire motor correctly. 5. Test for good contacts/correct wiring. 6. Test/repair/replace. 7. Clean motor, let cool, and reduce workload. 8. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Incorrectly mounted to workbench. 3. Motor fan rubbing on fan cover. 4. Motor mount loose/broken. 5. Sanding disc out of balance or loose. 6. Broken/defective sanding belt. 7. Tables are loose. 8. Motor bearings at fault. 9. Sanding belt roller bearings at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Secure stand to workbench, reposition to level surface, or shim. 3. Fix/replace fan cover; replace loose/damaged fan. 4. Tighten/replace. 5. Tighten disc hub or replace disc. 6. Replace sanding belt (see Page 26). 7. Tighten table locks. 8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 9. Replace bearings.





Symptom	Possible Cause	Possible Solution
Sanded surface not square.	<ol style="list-style-type: none"> 1. Work table not perpendicular to belt or disc. 2. Miter gauge not square to disc. 	<ol style="list-style-type: none"> 1. Adjust work table square to sanding belt and disc (see Page 20). 2. Adjust face of the miter gauge square to disc or belt.
Deep sanding grooves or scars in workpiece.	<ol style="list-style-type: none"> 1. Sandpaper too coarse for the desired finish. 2. Workpiece sanded across the grain. 3. Too much sanding force on workpiece. 4. Workpiece held still against the belt/disc. 5. Sandpaper clogged. 	<ol style="list-style-type: none"> 1. Use a finer grit sanding belt/disc. 2. Sand with the grain. 3. Reduce pressure on workpiece while sanding. 4. Keep workpiece moving while sanding on the belt/disc. 5. Clean/replace sandpaper.
Grains rub off the belt or disc easily.	<ol style="list-style-type: none"> 1. Sanding belt/disc has been stored in an incorrect environment. 2. Sanding belt/disc has been folded or smashed. 	<ol style="list-style-type: none"> 1. Store sanding belt/disc away from extremely dry or hot temperatures. 2. Store sanding belt/disc flat, not folded or bent.
Sanding surfaces clog quickly or burn.	<ol style="list-style-type: none"> 1. Too much pressure against belt/disc. 2. Sanding softwood, or stock has surface residue. 	<ol style="list-style-type: none"> 1. Reduce pressure on workpiece while sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning or replacing belts or discs frequently.
Burn marks on workpiece.	<ol style="list-style-type: none"> 1. Using too fine of sanding grit. 2. Using too much pressure. 3. Work held still for too long. 	<ol style="list-style-type: none"> 1. Use a coarser grit sanding belt/disc. 2. Reduce pressure on workpiece while sanding. 3. Do not keep workpiece in one place for too long.
Glazed sanding surfaces.	<ol style="list-style-type: none"> 1. Sanding wet stock. 2. Sanding stock with high residue. 	<ol style="list-style-type: none"> 1. Dry stock properly before sanding. 2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/replacing belts/discs frequently.
Workpiece frequently gets pulled out of your hand.	<ol style="list-style-type: none"> 1. Not properly supporting the workpiece. 2. Starting the workpiece on a leading corner. 	<ol style="list-style-type: none"> 1. Hold the workpiece firmly against the miter gauge and table. 2. Start workpiece on a trailing corner.
Belt slips on rollers.	<ol style="list-style-type: none"> 1. Back of belt or belt rollers are glazed or have oily substance. 2. Quick-release tension spring at fault. 	<ol style="list-style-type: none"> 1. Replace sanding belt; clean belt rollers with mineral spirits and let dry. 2. Replace tension spring assembly.



Tracking Roller & Platen Adjustment

To ensure proper belt tracking, the belt platen must be even with the upper roller crown and the upper and lower rollers must be parallel.

To adjust the roller and platen:

1. DISCONNECT SANDER FROM POWER!
1. Remove the side cover and table from the belt assembly.
2. Pull the quick-release tension lever down, then remove the sanding belt, as shown in **Figure 47**.

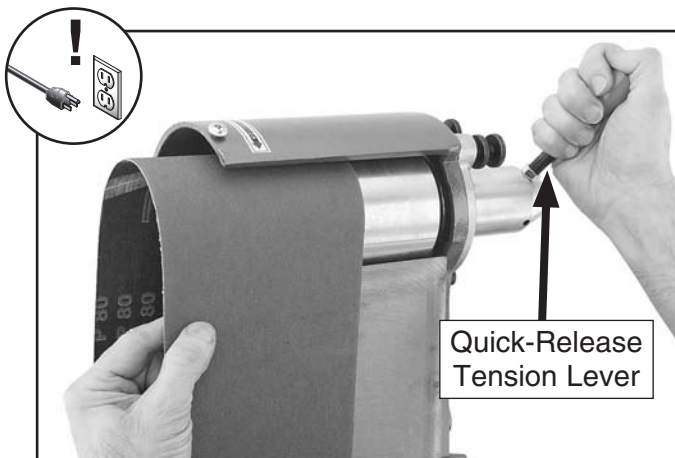


Figure 47. Removing the sanding belt.

3. If the sanding belt assembly is not already horizontal, loosen the cap screw shown in **Figure 48** and lower the assembly to the horizontal position.

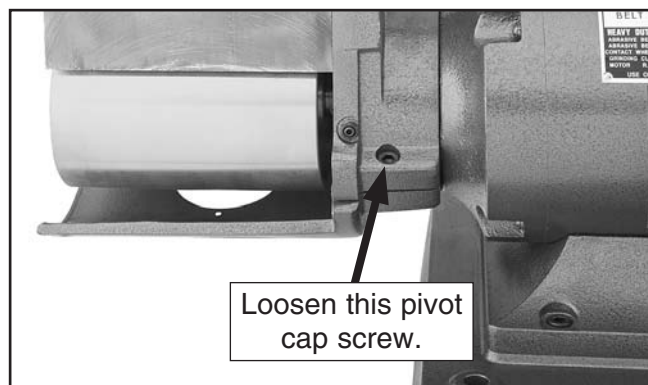


Figure 48. Location of the cap screw that secures the rotation of the belt assembly.

4. Place the straightedge over the platen and upper roller aligned with the middle of the roller (the crown at the highest point), as shown in **Figure 49**.

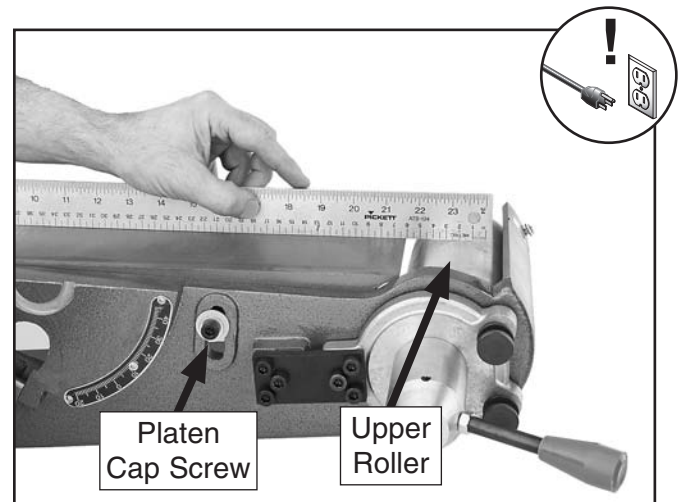


Figure 49. Comparing the platen height with the upper roller crown.

—If the platen is not even with or is higher than the upper roller crown, loosen the platen cap screw shown in **Figure 49**, adjust the platen even with the middle of the top roller, then re-tighten the cap screw to secure the platen in place.

5. Replace the sanding belt, put on gloves to protect your hands, then rotate it several times by hand—NOT by power.

—If the sanding belt tracks steadily in the middle of the rollers without moving to one side or the other, no other adjustments are necessary. Continue to **Step 11**.

—If the sanding belt does track to one side or the other, continue with next step.

6. Fully loosen the locking thumb wheels on both of the roller adjustment screws shown in **Figure 50**.

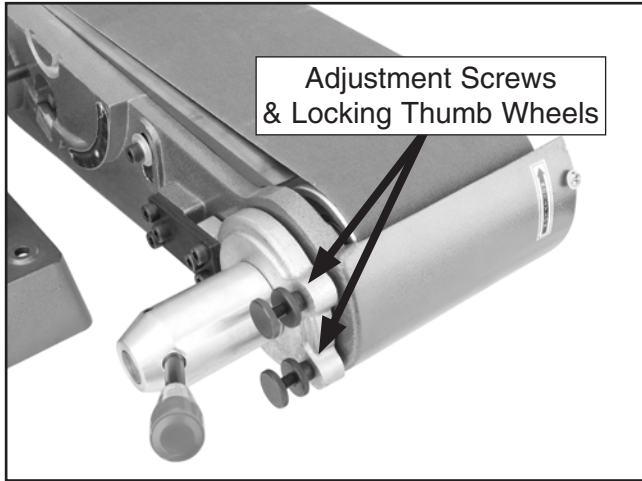


Figure 50. Upper roller adjustment screws and locking thumb wheels.

7. Back out the adjustment screws so that they are not against the belt housing.

Note: *The next step is matter of trial-and-error until you attain proper belt tracking. The adjustment screws control the tilt of the upper roller to make it parallel with the lower roller, which affects the belt tracking.*

8. Make small changes to the adjustment knobs as you continue to rotate the sanding belt by hand.
9. When the sanding belt continues to track in one position on the rollers, make sure both adjustment screws are making contact with the belt housing, then re-tighten the locking thumb screws.
10. Repeat **Step 4** to make sure the platen is still even with the crown of the upper roller.
11. Replace the side cover and table to the belt assembly before connecting the sander to power.
12. When first connecting the sander to power after this, turn it **ON** and watch the belt tracking closely.

—If the sanding belt begins to track to one side or the other, immediately turn the machine **OFF** and disconnect it from power. Then, repeat this procedure until the belt tracks properly.

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. 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.

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 	



110V Wiring Diagram

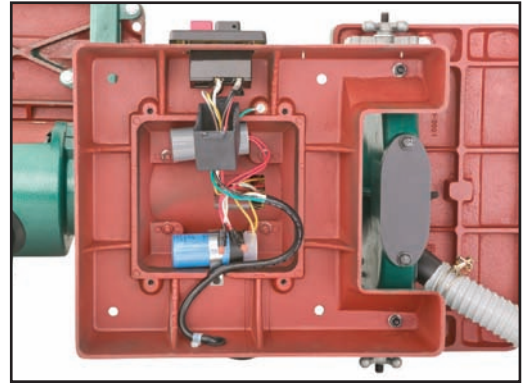
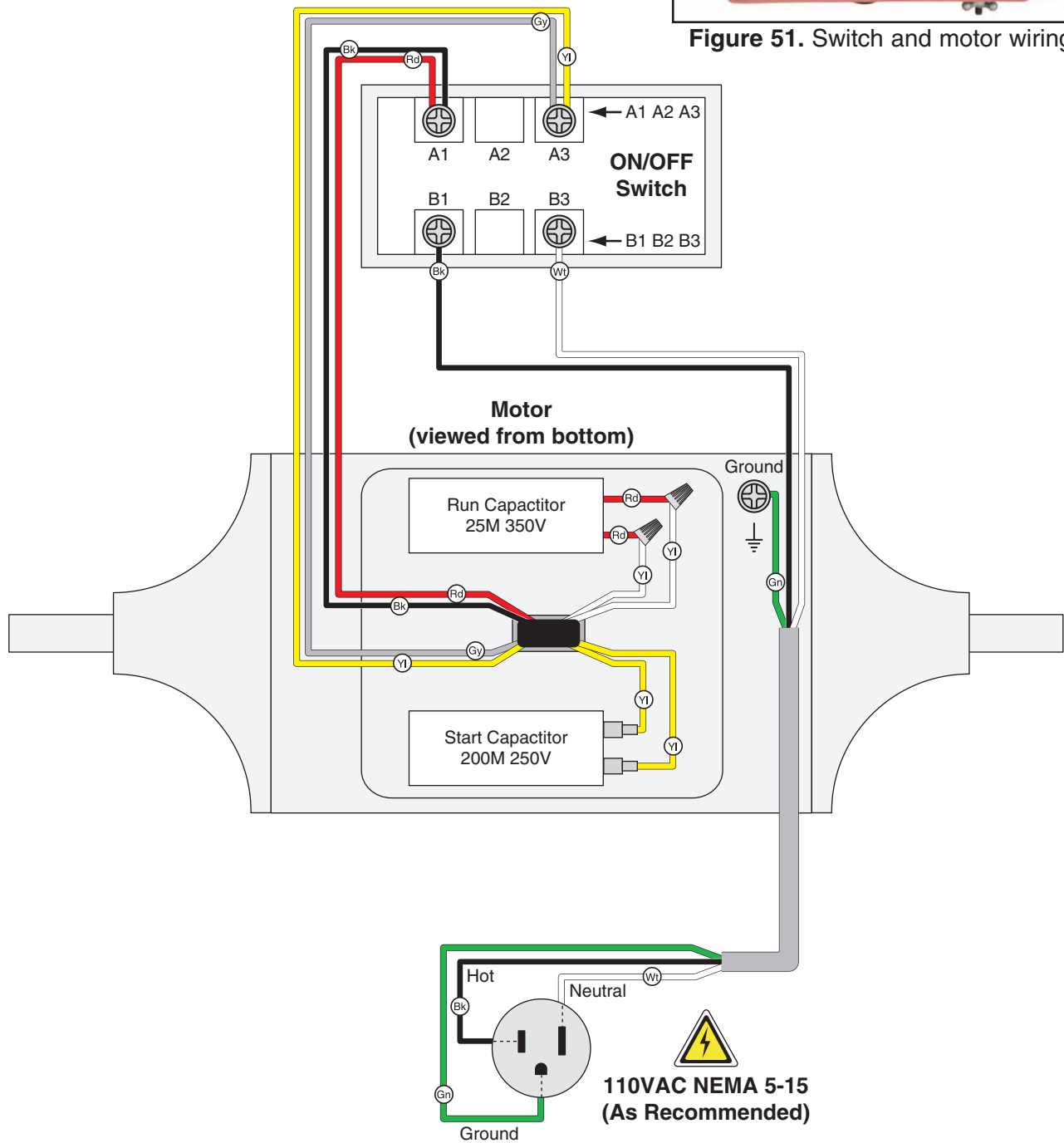
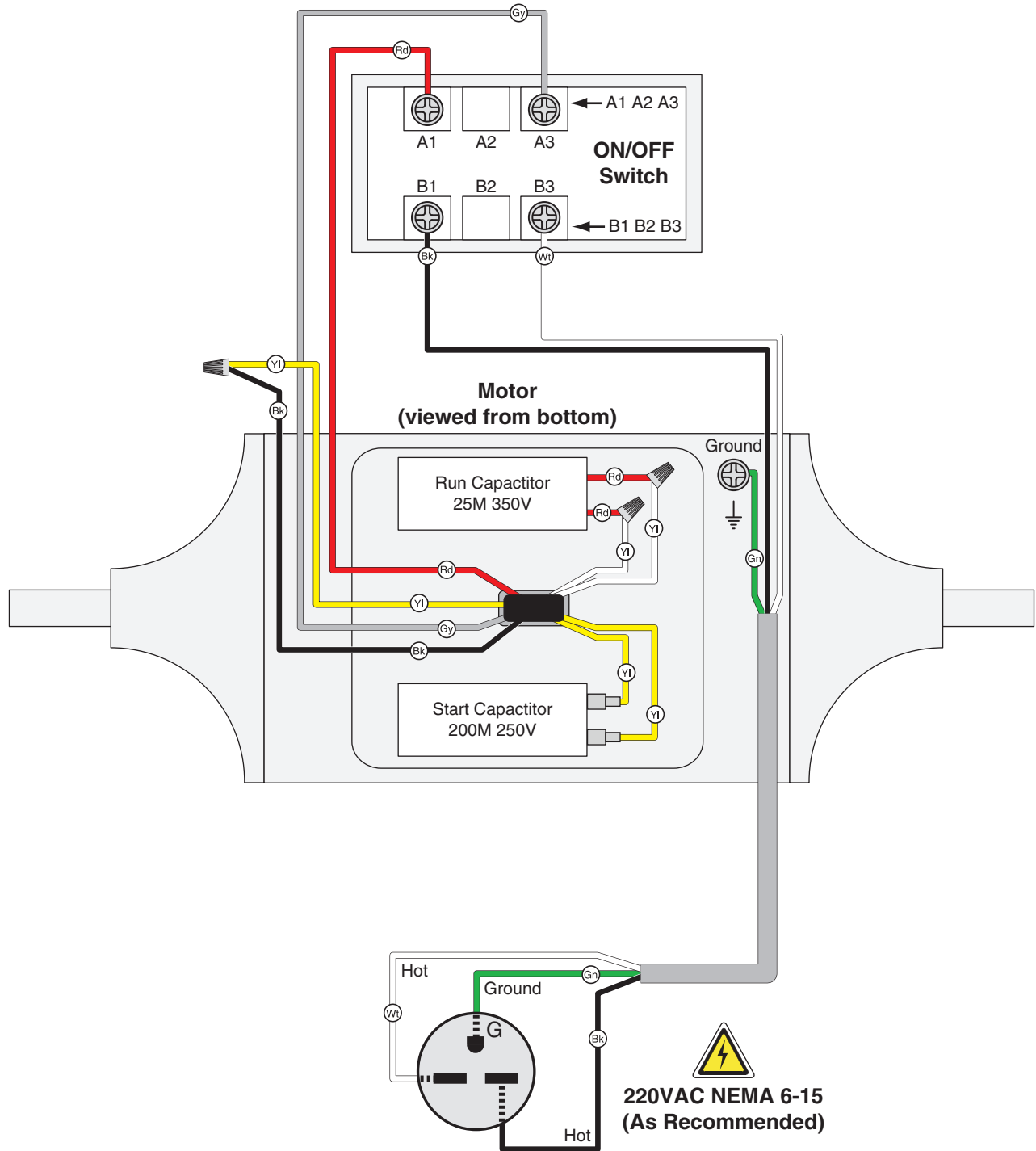


Figure 51. Switch and motor wiring.

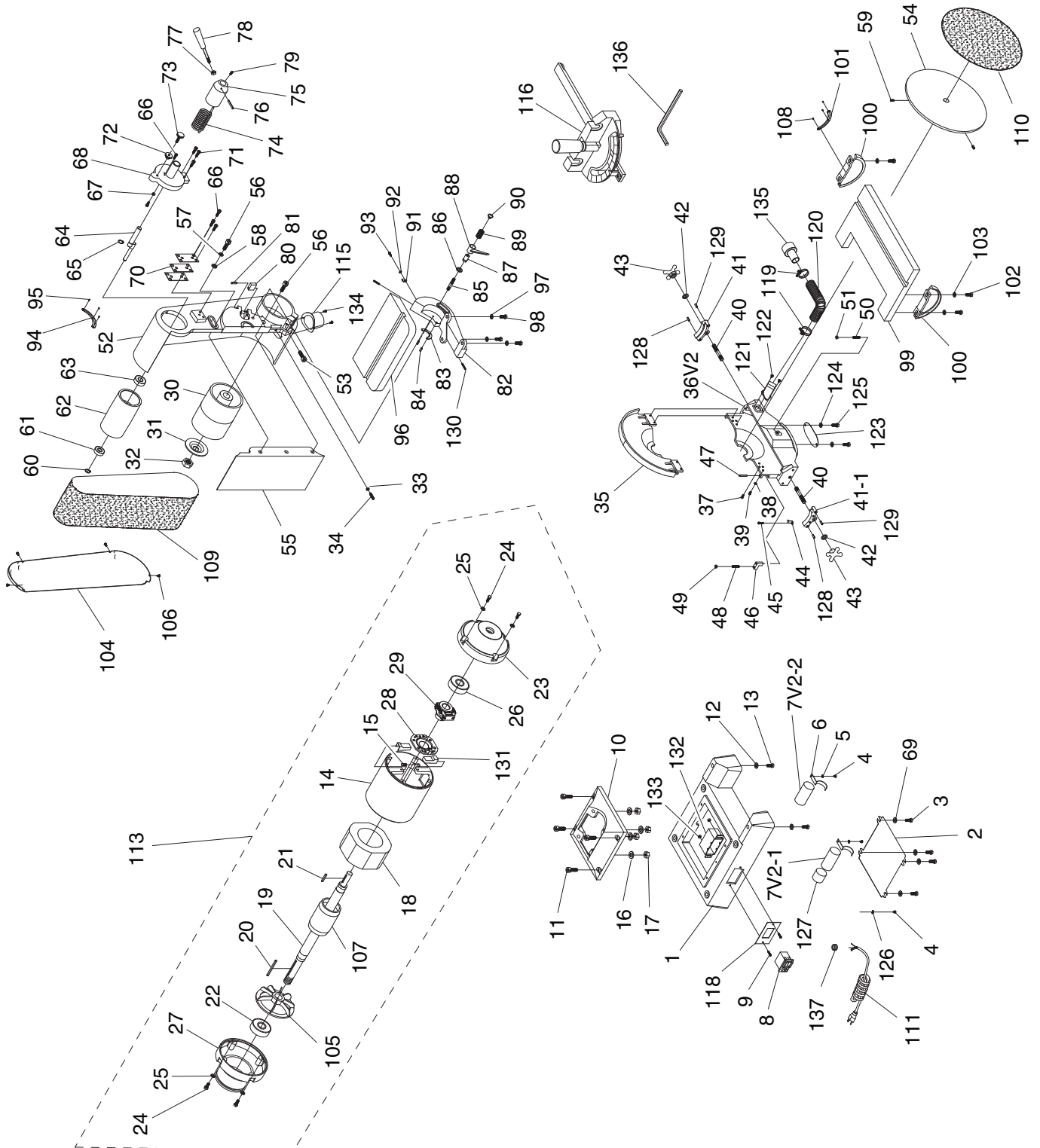


220V Wiring Diagram



SECTION 9: PARTS

Main Breakdown



Main Parts List

REF	PART #	DESCRIPTION
1	P1183001	BASE ALUMINUM
2	P1183002	BASE PLATE PLASTIC
3	PB06M	HEX BOLT M8-1.25 X 12
4	PFS03	FLANGE SCREW 10-24 X 3/8
5	PTLW01	EXT TOOTH WASHER #10
6	P1183006	CAPACITOR CLIP
7V2-1	PC200H	S CAPACITOR 200M 250V 1-1/2 X 3-1/8
7V2-2	PC025A	R CAPACITOR 25M 350V 1-1/2 X 3-5/8
8	P1183008	PUSH BUTTON SWITCH 110/220V
9	PS13	PHLP HD SCR 10-24 X 1-1/4
10	P1183010	MOTOR BASE
11	PCAP31M	CAP SCREW M8-1.25 X 25
12	PW02	FLAT WASHER 3/8
13	PB24	HEX BOLT 3/8-16 X 1-1/4
14	P1183014	MOTOR HOUSING
15	PB11	HEX BOLT 5/16-18 X 1-1/2
16	PW07	FLAT WASHER 5/16
17	PN02	HEX NUT 5/16-18
18	P1183018	STATOR 2-P 160 X 80 X 55MM (G1183)
18	P1276018	STATOR 4-P 160 X 80 X 55MM (G1276)
19	P1183019	STATOR SHAFT (G1183)
19	P1276019	STATOR SHAFT (G1276)
20	PK16M	KEY 5 X 5 X 65
21	PK126M	KEY 5 X 5 X 32
22	P6206ZZ	BALL BEARING 6206ZZ
23	P1183023	RIGHT MOTOR COVER
24	PB32	HEX BOLT 5/16-18 X 5/8
25	PW07	FLAT WASHER 5/16
26	P6206ZZ	BALL BEARING 6206ZZ
27	P1183027	LEFT MOTOR COVER
28	P1183028	CONTACT PLATE (G1183)
28	P1276028	CONTACT PLATE (G1276)
29	P1183029	CENTRIFUGAL SWITCH (G1183)
29	P1276029	CENTRIFUGAL SWITCH (G1276)
30	P1183030	LOWER BELT ROLLER 5"
31	P1183031	ROLLER FLANGE 25MM
32	PN18	HEX NUT 1-8 LH
33	PN01M	HEX NUT M6-1
34	PSS12M	SET SCREW M6-1 X 25
35	P1183035	UPPER DISC GUARD
36V2	P1183036V2	LOWER DISC HOUSING V2.03.10
37	PS06	PHLP HD SCR 10-24 X 3/8
38	PW03	FLAT WASHER #10
39	PS01	PHLP HD SCR 10-24 X 1/2
40	P1183040	SHOULDER STUD 7/16-14
41	P1183041	REAR TRUNNION
41-1	P1183041-1	FRONT TRUNNION

REF	PART #	DESCRIPTION
42	PW04	FLAT WASHER 7/16
43	P1183043	STAR KNOB
44	P1183044	POINTER
45	PS18	PHLP HD SCR 10-24 X 1/4
46	P1183046	STOP BLOCK
47	PRP32M	ROLL PIN 6 X 40
48	PSS12M	SET SCREW M6-1 X 25
49	PN01M	HEX NUT M6-1
50	PSS01	SET SCREW 5/16-18 X 1
51	PN02	HEX NUT 5/16-18
52	P1183052	BELT HOUSING
53	PCAP12M	CAP SCREW M8-1.25 X 40
54	P1183054	SANDING DISC ALUMINUM
55	P1183055	BELT PLATEN
56	PCAP13M	CAP SCREW M8-1.25 X 30
57	PW07	FLAT WASHER 5/16
58	PW02	FLAT WASHER 3/8
59	PSS01M	SET SCREW M6-1 X 10
60	PR05M	EXT RETAINING RING 15MM
61	P6203ZZ	BALL BEARING 6203ZZ
62	P1183062	UPPER BELT ROLLER 3-1/2"
63	P6204ZZ	BALL BEARING 6204ZZ
64	P1183064	ECCENTRIC SHAFT
65	PR10M	EXT RETAINING RING 22MM
66	PCAP01M	CAP SCREW M6-1 X 16
67	PN01M	HEX NUT M6-1
68	P1183068	SHAFT BRACKET
69	PW01M	FLAT WASHER 8MM
70	P1183070	RETAINING PLATE
71	PCAP14M	CAP SCREW M8-1.25 X 20
72	P1183072	KNURLED CHECK NUT M8-1.25
73	P1183073	KNURLED BOLT M8-1.25 X 40
74	P1183074	TORSION SPRING 9-1/2 X 4MM
75	P1183075	LEVER HOLDER
76	PRP33M	ROLL PIN 6 X 50
77	PN08	HEX NUT 3/8-16
78	P1183078	BELT TENSION LEVER
79	PSS01M	SET SCREW M6-1 X 10
80	P1183080	STOP BLOCK
81	PRP33M	ROLL PIN 6 X 50
82	P1183082	TRUNNION
83	P1183083	PIVOT PLATE
84	PRP19M	ROLL PIN 4 X 14
85	P1183085	STUD-UDE 7/16-14 X 2-7/8 1-3/16, 11/16
86	PW04	FLAT WASHER 7/16
87	P1183087	LOCK LEVER NUT 7/16-14
88	P1183088	LOCK HANDLE



Main Parts List

REF	PART #	DESCRIPTION
89	P1183089	COMPRESSION SPRING
90	P1183090	LOCK HANDLE SCREW ALUMINUM
91	P1183091	POINTER
92	PW03	FLAT WASHER #10
93	PS18	PHLP HD SCR 10-24 X 1/4
94	P1183094	DEGREE SCALE
95	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
96	P1183096	BELT SANDER TABLE
97	PW07	FLAT WASHER 5/16
98	PB03	HEX BOLT 5/16-18 X 1
99	P1183099	DISC SANDER TABLE
100	P1183100	PIVOT PLATE
101	P1183101	DEGREE SCALE
102	PB07	HEX BOLT 5/16-18 X 3/4
103	PW07	FLAT WASHER 5/16
104	P1183104	BELT GUARD
105	P1183105	MOTOR FAN PLASTIC
106	PFS20	FLANGE SCREW 1/4-20 X 1/2
107	P1183107	ROTOR 2-POLE 80 X 50MM (G1183)
107	P1276107	ROTOR 4-POLE 80 X 50MM (G1276)
108	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
109	P1183109	SANDING BELT 6" X 48" 80-GRIT
110	P1183110	SANDING DISC 12" 80-GRIT
111	P1183111	POWER CORD 14G 3C 6FT 5-15

REF	PART #	DESCRIPTION
113	P1183113	MOTOR 1HP 110/220V 3450RPM (G1183)
113	P1276113	MOTOR 1HP 110/220V 1725RPM (G1276)
115	P1183115	SANDING BELT DUST PORT 3"
116	P1183116	MITER GAUGE ASSEMBLY
118	P1183118	SWITCH PLATE
119	P1183119	HOSE CLAMP 1-1/2"
120	P1183120	DUST HOSE 1-1/2" X 10"
121	P1183121	DUST CHUTE
122	PFS03	FLANGE SCREW 10-24 X 3/8
123	P1183123	LOWER DISC BRACKET COVER
124	PW07	FLAT WASHER 5/16
125	PB09	HEX BOLT 5/16-18 X 1/2
126	P1183126	FLAT WASHER #10 COPPER
127	P1183127	CAPACITOR END CAP
128	PRP32M	ROLL PIN 6 X 40
129	PRP33M	ROLL PIN 6 X 50
130	PSS12M	SET SCREW M6-1 X 25
131	P1183131	CENTRIFUGAL SWITCH BRACKET
132	P1183132	SWITCH BOX
133	PN07	HEX NUT 10-24
134	PFS16	FLANGE SCREW 1/4-20 X 1/2
135	P1183135	DUST HOSE ADAPTER 2-1/2" X 1-1/2"
136	PAW06M	HEX WRENCH 6MM
137	P1183137	STRAIN RELIEF

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 CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 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.**

- How did you learn about us?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
- Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	
- What is your annual household income?

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
- What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- How long have you been a woodworker/metalworker?

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------
- How many of your machines or tools are Grizzly?

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
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- Do you think your machine represents a good value? Yes No
- Would you recommend Grizzly Industrial to a friend? Yes No
- 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



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Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND 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.

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