READ THIS FIRST

Model G0864

IMPORTANT UPDATE

For Machines Mfd. Since 12/22
and Owner's Manual Printed 05/19

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

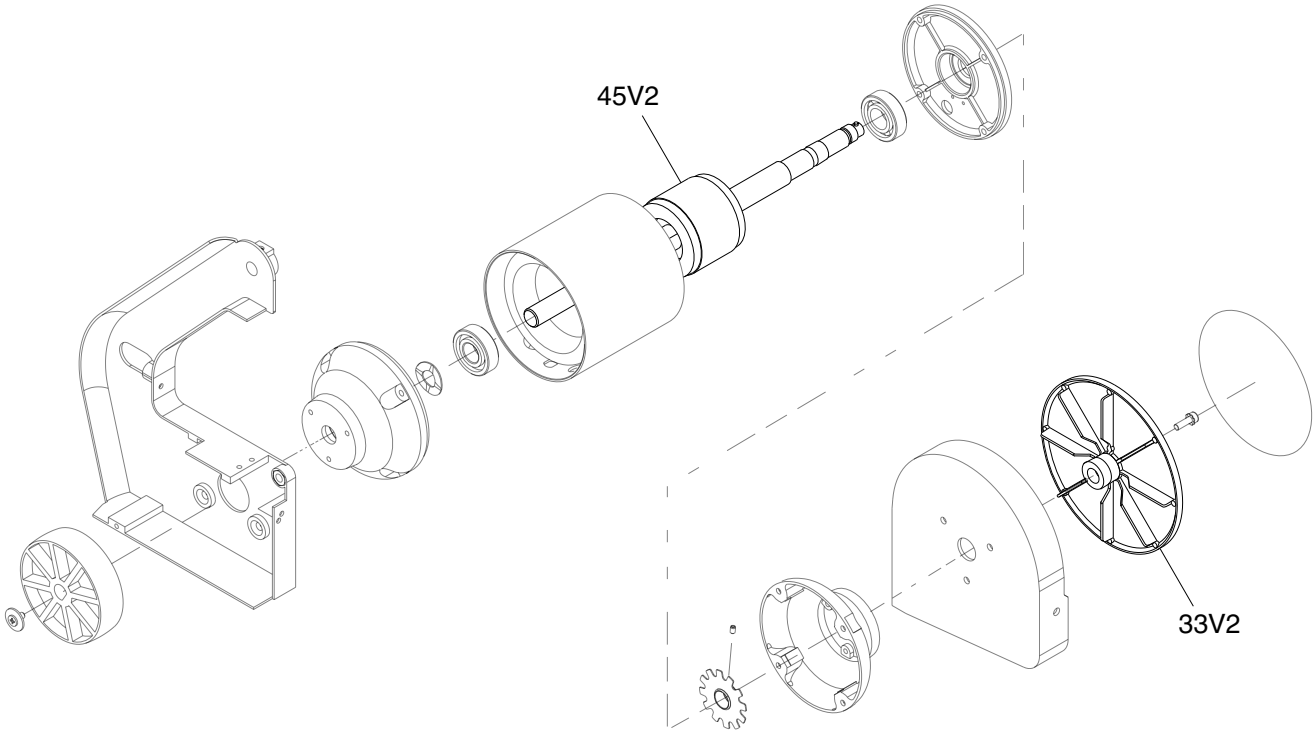
The following changes were recently made since the owner's manual was printed:

- Sanding disc and rotor changed.

Aside from this information, all other content in the owner's manual applies and MUST be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Parts



REF	PART #	DESCRIPTION
33V2	P0864033V2	SANDING DISC 6" V2.12.22

REF	PART #	DESCRIPTION
45V2	P0864045V2	ROTOR V2.12.22

#CS22476 PRINTED IN CHINA

MODEL G0864
VARIABLE-SPEED 1" X 30" BELT/ 6" DISC SANDER

OWNER'S MANUAL

(For models manufactured since 05/19)

#AL20098 PRINTED IN CHINA V1.05.19

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

INTRODUCTION

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

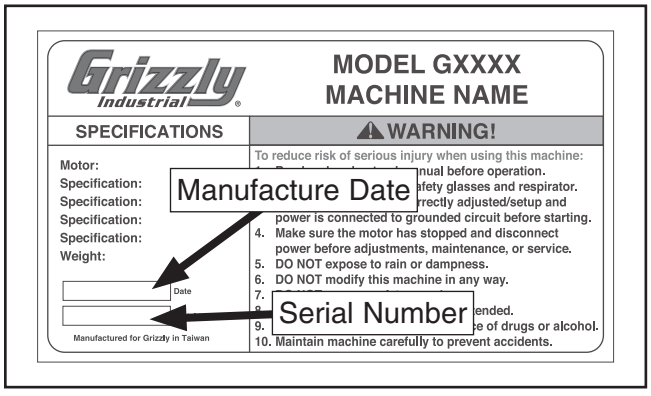
Manual Accuracy

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

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

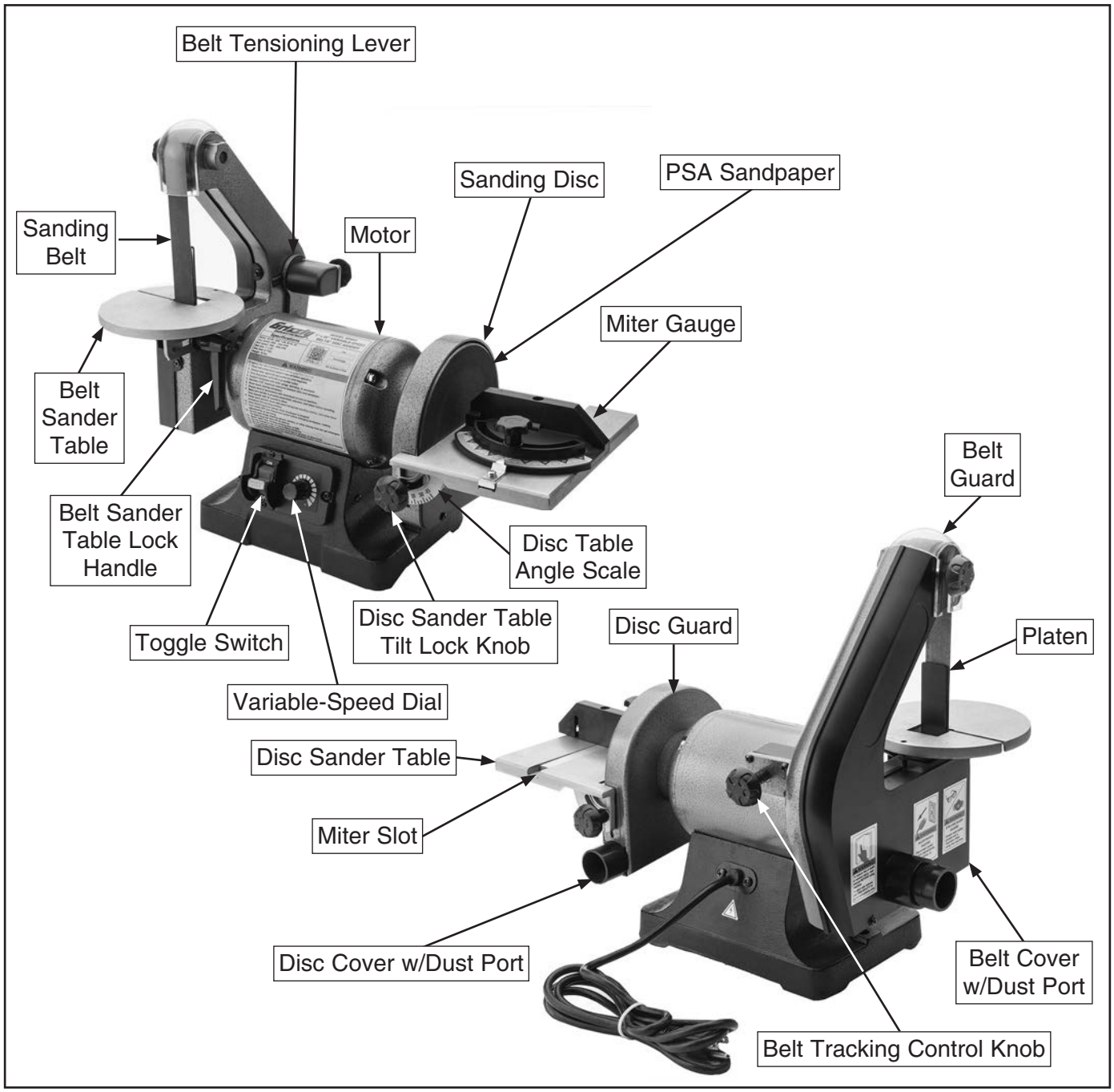
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

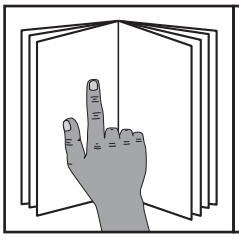
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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



Identification

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





⚠WARNING

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

MODEL G0864 VARIABLE-SPEED 1" X 30" BELT/ 6" DISC SANDER

Product Dimensions:

Weight..... 30 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 21 x 12 x 17 in.
Footprint (Length x Width)..... 10 x 7 in.

Shipping Dimensions:

Type..... Cardboard
Content..... Machine
Weight..... 33 lbs.
Length x Width x Height..... 19 x 17 x 13 in.

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 4A
Minimum Circuit Size..... 15A
Connection Type..... Cord and Plug
Power Cord Included..... Yes
Power Cord Length..... 7 ft.
Power Cord Gauge..... 18 AWG
Included Plug Type..... 5-15
Switch Type..... Toggle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 1/2 HP
Phase..... Single-Phase
Amps..... 4A
Speed..... 3400 RPM
Type..... Permanent Split Capacitor
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Belt Sander Info

Sanding Belt Width..... 1 in.
Sanding Belt Length..... 30 in.
Sanding Belt Speed..... 1900 - 3200 FPM
Table Length..... 5-3/4 in.
Table Width..... 5-3/4 in.
Table Thickness..... 7/16 in
Table Tilt..... 0 - 45 deg.
Max Height of Belt in Vertical Position..... 4-1/2 in.
Belt Tension Release Type..... Spring
Platen Type..... POM Plastic
Platen Length..... 2-1/4 in.
Platen Width..... 1 in.

Disc Sander Info

Disc Diameter	6 in.
Disc Speed	2000 - 3450 RPM
Disc Sandpaper Backing Type	PSA
Table Length	8 in.
Table Width	6-1/8 in.
Table Thickness	5/8 in.
Table Tilt	0 - 45 deg.

Construction Materials

Base	Cast Iron
Table	Cast Aluminum
Disc	Cast Aluminum
Miter Gauge	ABS Plastic
Paint Type/Finish	Epoxy

Other Related Info

Miter Gauge Slot Width	5/8 in.
Miter Gauge Slot Height	5/16 in.
Number of Dust Ports	2
Dust Port Size	1-1/2, 1-3/4 in.

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

Features:

Variable-Speed Sanding Disc from 2000 - 3400 RPM
Variable-Speed Sanding Belt from 1900 - 3200 FPM
Dedicated Dust Collection Port for Each Side
Uses Standard 1" x 30" Sanding Belts and 6" PSA Sanding Discs
Switch with Removable Safety Key
Tilting Cast-Aluminum Tables

Accessories Included:

Miter Gauge
Dust Port Adapter 1-1/2 in.

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Disc & Belt Sanders

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 120V ..... 4 Amps

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

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

⚠WARNING

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

120V Circuit Requirements

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

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 15 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!

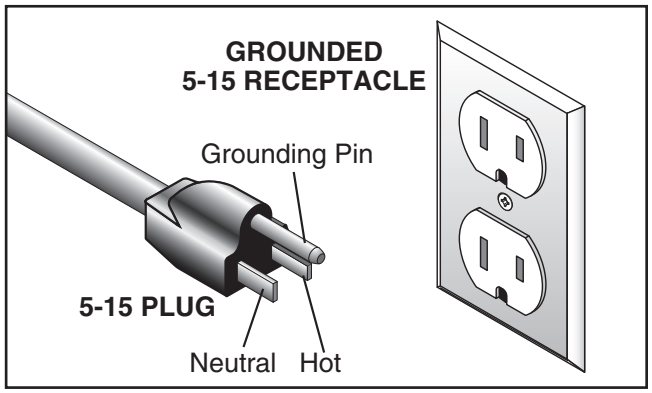
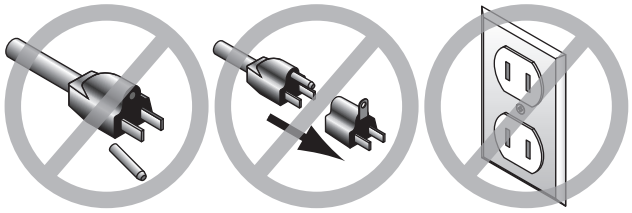


Figure 1. Typical 5-15 plug and receptacle.

⚠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 .....16 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

Unpacking

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

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

Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Phillips Screwdriver #2	1
• Dust Collection System	1
• Dust Hose 1½"	2
• Hose Clamps 1½"	4

NOTICE

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

Inventory

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

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

Box 1 (Figure 2)	Qty
A. G0864 Machine (Not Shown)	1
B. Disc Sander Table	1
C. Miter Gauge	1
D. Dust Port Adapter 1½"	1
E. Fender Washer 8mm	1
F. Lock Handle	1
G. Belt Sander Table	1
H. Disc Sander Table Tilt Knobs	2
I. Flat Washers 6mm	2
J. Hex Wrench 3mm	1

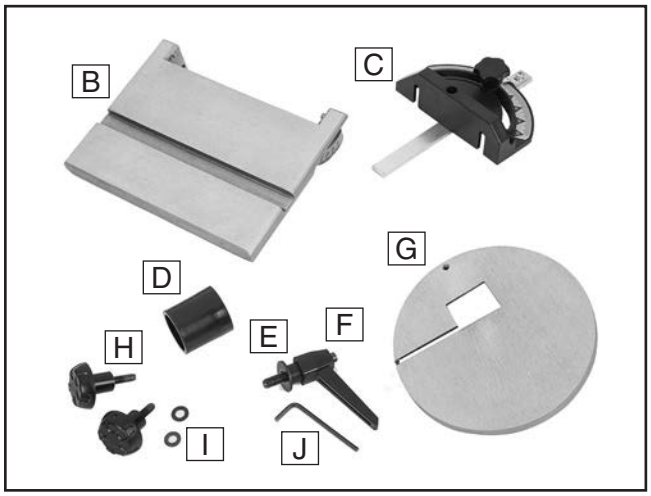


Figure 2. Loose inventory

Site Considerations

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

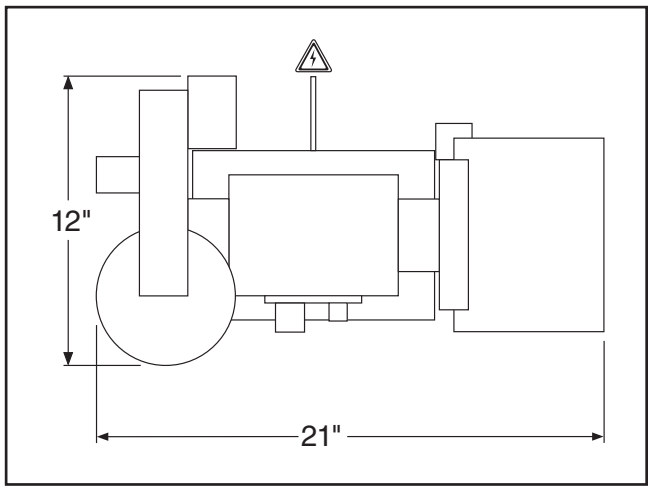
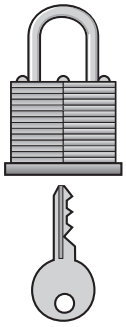


Figure 3. Minimum working clearances.



⚠CAUTION

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

Bench Mounting

Number of Mounting Holes 2
Dia. of Mounting Hardware Needed ..... 5/16"

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

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

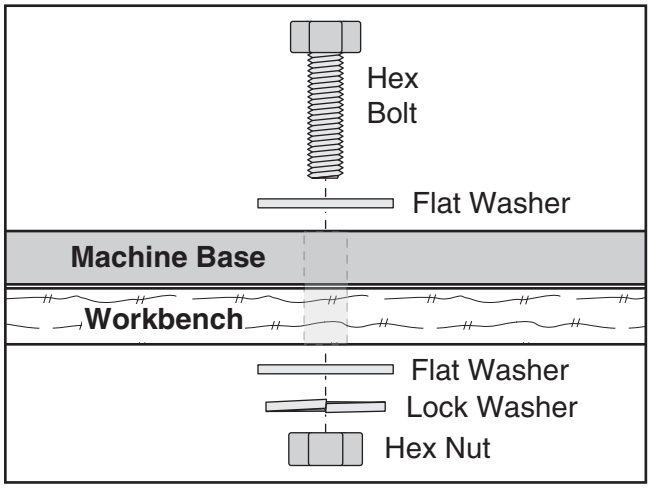


Figure 4. "Through Mount" setup.

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

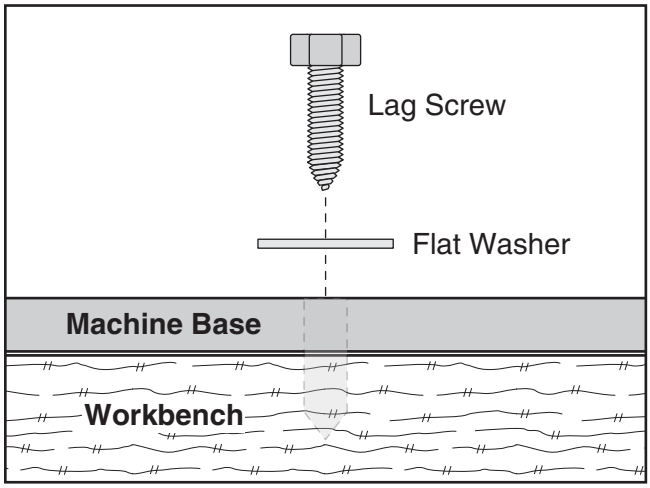


Figure 5. "Direct Mount" setup.

Assembly

⚠WARNING

To avoid risk of serious injury, DO NOT connect the sander to power until told to do so in the Test Run subsection.

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

To assemble sander:

1. Install disc sander table with (2) knob bolts and (2) 6mm flat washers, as shown in **Figures 6–7**.

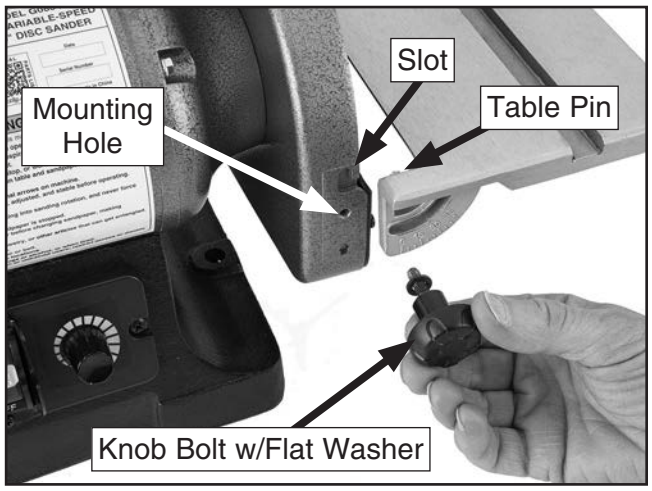


Figure 6. Disc sander table pins.

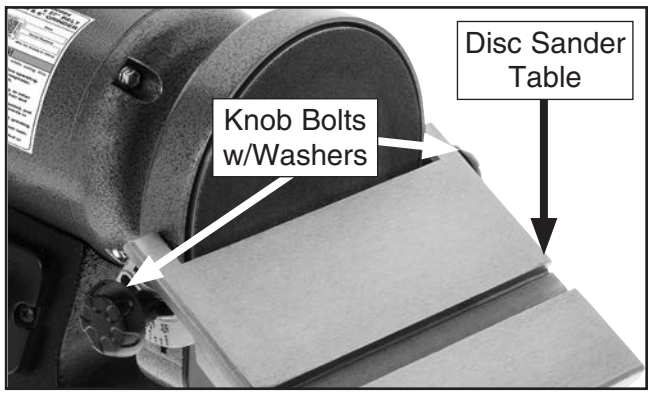


Figure 7. Disc sander table attached.

2. Install belt sander table with (1) lock handle and (1) 8mm fender washer, as shown in **Figure 8**.

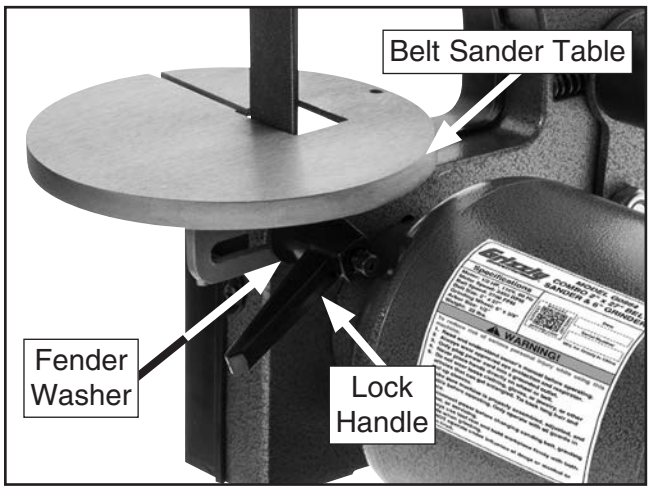


Figure 8. Belt sander table installed.

3. Slide 1½" dust port adapter into existing dust port on sanding belt dust cover.

   Note: *Only the smaller end of the 1½" dust port adapter will fit, as there is a slight taper. (see **Figure 9**).*

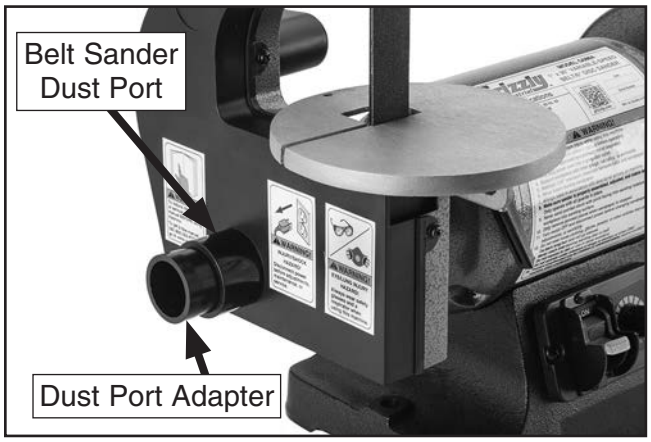


Figure 9. Dust port adapter installed.

Dust Collection

⚠CAUTION

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

Minimum CFM at Dust Port: 100 CFM

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

To connect dust collection system to machine:

1. Fit 1½" dust hose over each dust port, as shown in **Figure 10**, and secure in place with 1½" hose clamps.

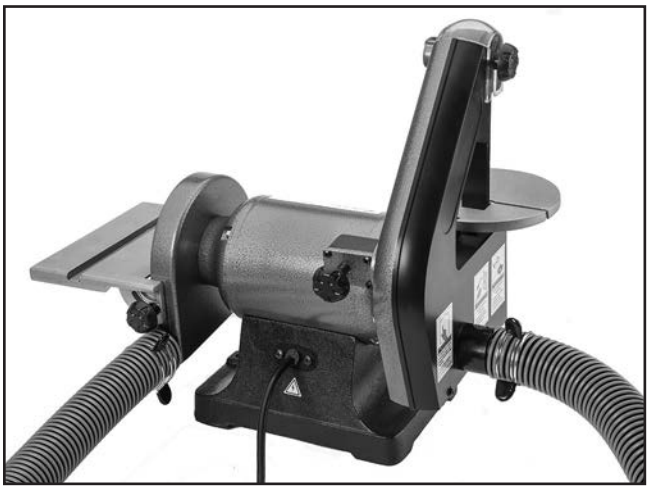


Figure 10. Dust hoses attached to dust ports.

2. Gently pull hoses to make sure they do not easily come off.

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

Test Run

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

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

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the belt is tracking properly and will not come off rollers during initial startup, and 3) the safety disabling mechanism on the switch works correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Connect machine to power.

2. Rotate variable-speed dial all the way counterclockwise so machine will start at slowest speed upon startup.

3. Use toggle switch to start and immediately stop sander, while watching how belt tracks on top wheel. Belt "tracking" refers to belt positioning on wheels when belt rotates. When properly tracking, belt remains centered on wheels as it rotates.

   — If belt tracks too far left or right, belt edge will be destroyed if it makes contact with the side cover. To prevent that from happening, you must adjust belt tracking before proceeding to next step. Refer to **Adjusting Belt Tracking** on **Page 17** for further details.

4. Start sander and allow it to run while ensuring belt tracks properly. Fine-tune tracking as necessary before proceeding to next step.

5. Slowly rotate variable-speed dial clockwise and counterclockwise to verify sander runs smoothly and without problems or unusual noies at all speeds, then turn sander ***OFF***.

6. Remove yellow key from toggle switch, as shown below.

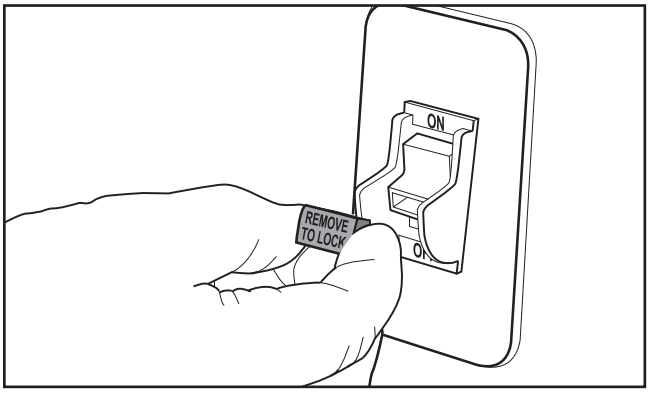


Figure 11. Removing key from toggle switch.

7. Try to start machine with key removed from switch.

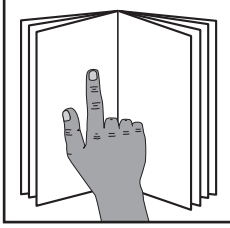
   Machine should NOT start. If it *does* start, the switch disabling feature is not functioning properly and the switch must be replaced.

SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

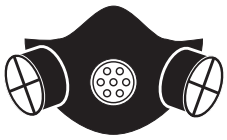


⚠WARNING

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

⚠WARNING

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



NOTICE

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

Belt & Disc Sanding

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

1. Examines workpiece to make sure it is suitable for disc sanding.
2. DISCONNECTS MACHINE FROM POWER!
3. Adjusts table tilt as necessary and locks table in place.
4. Puts on safety glasses and respirator.
5. Starts machine and dust collector. Allows machine to reach full speed.
6. For disc sanding, holds workpiece firmly and flatly against both table and miter gauge (if used), pushes workpiece into downward spinning side of disc.
7. For belt sanding, places workpiece on belt sander table, then slowly, and with light pressure, moves workpiece into sanding belt.
8. When finished, stops machine and dust collector.

Adjusting Belt Tracking

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

To check and adjust belt sander tracking:

1. DISCONNECT MACHINE FROM POWER!

2. Remove belt cover.

3. Standing in front of sander, push downward on sanding belt multiple times along bottom pulley and watch how belt tracks on top pulley.

   — If sanding belt moves right, rotate belt tracking control knob clockwise ¼ turn.

   — If sanding belt moves left, rotate belt tracking control knob counterclockwise ¼ turn (see **Figure 12**).

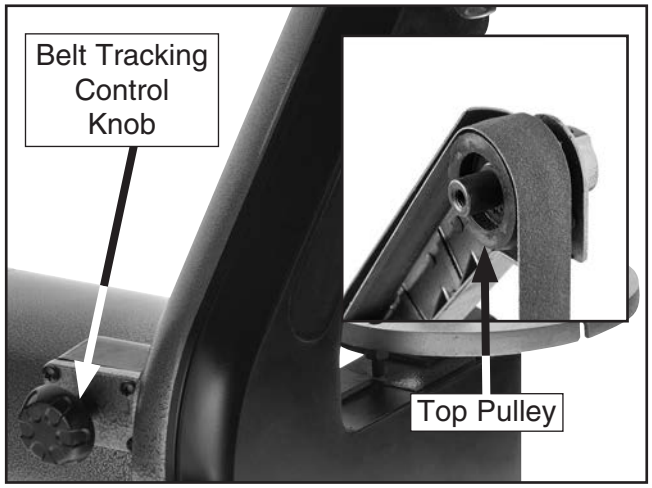


Figure 12. Sanding belt tracking adjustment.

4. When belt is tracking in center of pulley, replace belt cover. Turn variable-speed dial counterclockwise to its lowest setting.

5. Connect machine to power source and turn it ***ON***, verify belt is tracking correctly on center of pulley and fine-tune tracking as necessary while sander is running.

Replacing Sanding Disc

The Model G0864 accepts 6" diameter PSA (pressure-sensitive adhesive) sanding discs, which are available in a variety of grits. The sanding discs can be replaced *without* removing the table by following the procedure below.

To replace sanding disc:

1. DISCONNECT MACHINE FROM POWER!

2. Peel off old sandpaper, clean disc surface with mineral spirits, and wipe it dry.

3. Loosen disc sander table tilt knobs and fully tilt table down.

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

5. Slip half with protective layer between disc and table edge, as shown in **Figure 13**.

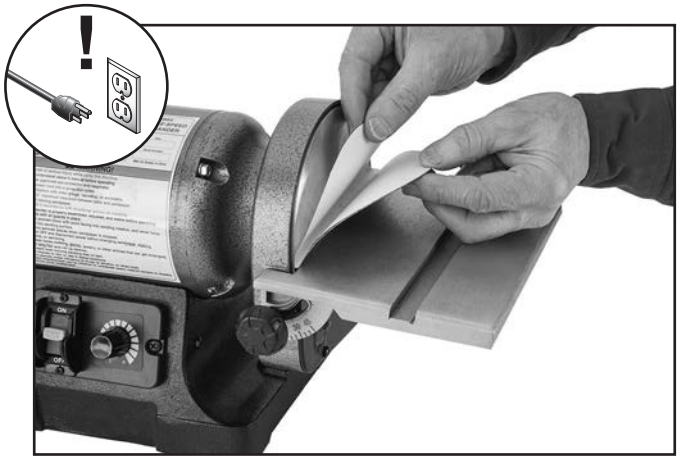


Figure 13. Example of attaching sanding disc.

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

7. Rotate disc 180° to expose other half of sanding disc. Peel off other half of protective paper, and press sandpaper against disc to complete adhesion.

8. Re-position table and tighten table tilt knobs.

Using Disc Sander

The purpose of a disc sander is to smooth wood and to remove small amounts of waste material.

Move the workpiece slowly back and forth along the *downward* moving side of the sanding disc, as shown in **Figure 14**, and avoid using excessive pressure to prevent burning the workpiece and overloading the sanding discs.

To perform angle sanding, tilt the table and rotate the miter gauge to the appropriate angles as shown in **Figures 15–16**.

⚠CAUTION

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

⚠CAUTION

To reduce risk of your fingers getting pinched between work table and sanding disc, always make sure gap between table and sanding disc does NOT exceed 1/16".

To perform disc sanding operations:

1. DISCONNECT MACHINE FROM POWER!
2. If needed, set angle of table and miter gauge for operation.
3. Make sure table is about 1/16" away from sanding disc (refer to **Adjusting Disc Sander Table** on **Page 21** for further details).
4. Connect sander to power, turn it ***ON***, and allow sanding disc to reach full speed.
5. Position workpiece on table against miter gauge.
6. With moderate pressure, push workpiece into downward moving side of rotating disc (see **Figures 14–16** for examples of disc sanding).

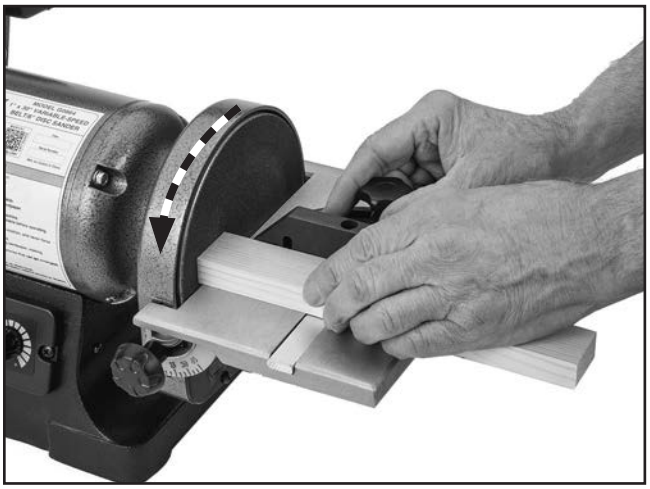


Figure 14. Example of end-grain sanding.

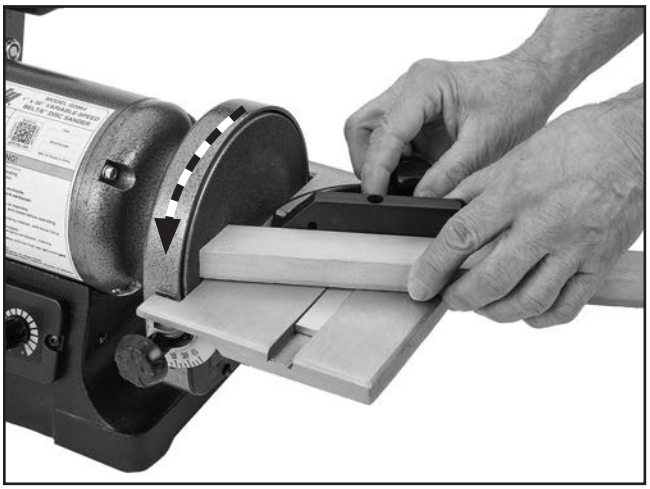


Figure 15. Example of angle sanding.

Figure 16. Example of bevel sanding.

Replacing Sanding Belt

Some sanding belts are designed to sand in only one direction and will have a direction indicated on the back of the belt. The Model G0864 is designed so that the sanding belt travels down toward to the sanding table.

To replace sanding belt:

1. DISCONNECT MACHINE FROM POWER!

2. Remove knob bolt and belt guard (see **Figure 17**).

3. Remove three Phillips head screws from sanding belt cover and remove cover from sander (see **Figure 17**).

4. Fully loosen tracking control knob to remove tension from sanding belt (see **Figure 17**).

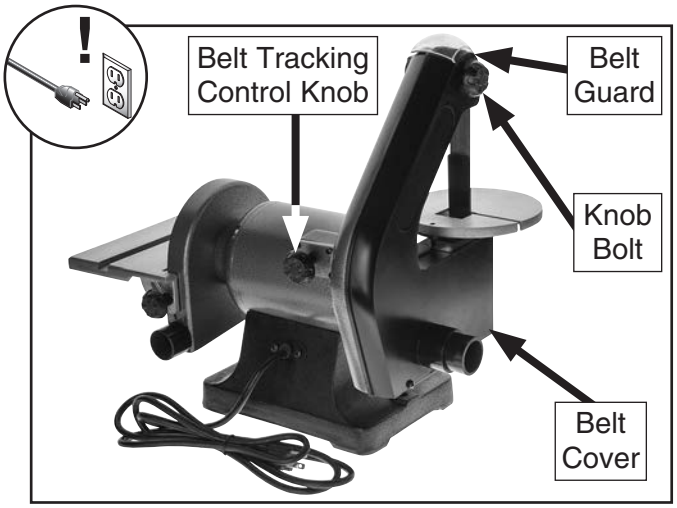


Figure 17. Location of sanding belt components.

5. Roll old belt off pulleys (see **Figure 18**), then install new sanding belt.

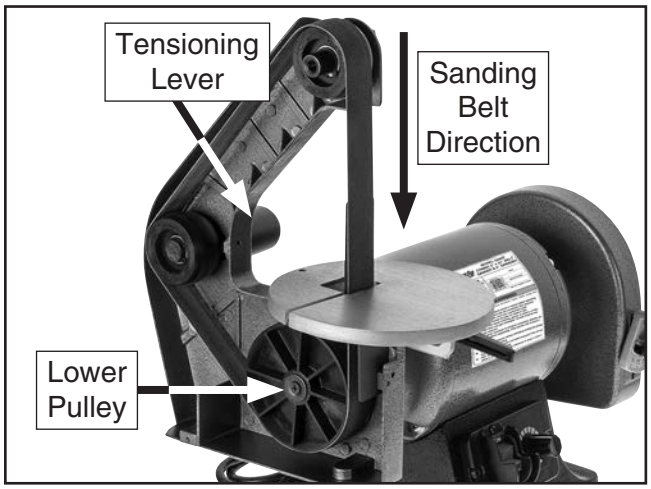


Figure 18. Location of sanding belt tensioning lever.

6. Tighten belt tension knob, then move belt on lower pulley by hand to make sure it is centered on all three pulleys.

7. Replace and secure sanding belt cover with Phillips head screws.

8. Check and adjust belt sander tracking as instructed on **Page 17**.

Using Belt Sander

With the Model G0864, you can belt-sand the end of a workpiece at a chosen angle. The angle is achieved by tilting the belt table.

End-Grain Sanding

1. DISCONNECT MACHINE FROM POWER!

2. Make sure platen is in place (see **Figure 19**) and table-to-platen angle is set for operation (refer to **Adjusting Platen & Belt Sander Table** on **Page 21**).

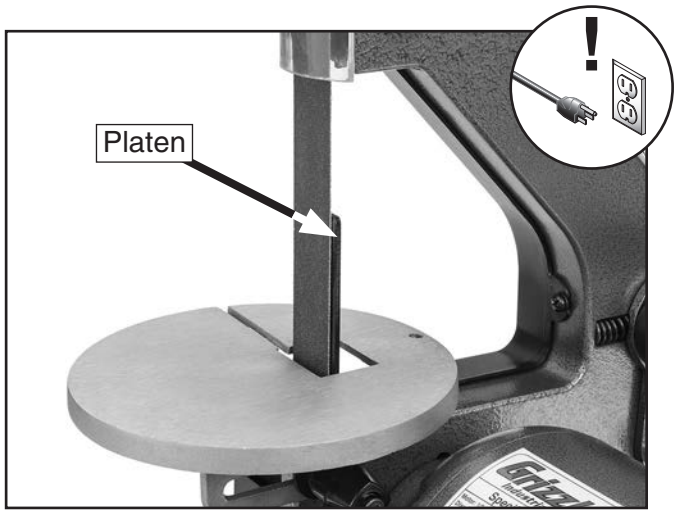


Figure 19. Location of platen.

3. Turn sander ***ON***, and slowly feed workpiece into sanding belt, as shown in **Figure 20**. Hold workpiece firmly so it does not chatter or vibrate.

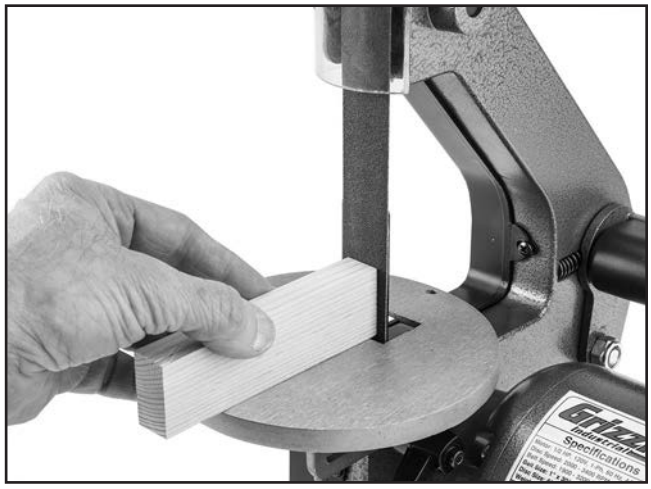


Figure 20. Example of feeding workpiece.

Edge Sanding

Use the belt sander to smooth long, flat surfaces on the workpiece.

⚠CAUTION

To avoid the risk of kickback and personal injury, always keep workpiece firmly on table, and never sand short side of workpiece with sanding belt.

To use belt sander:

1. DISCONNECT MACHINE FROM POWER!

2. Set belt sander table angle with protractor, or other angle measuring tool, for your operation (refer to **Adjusting Platen & Belt Sander Table** on **Page 21**).

3. Turn sander ***ON***, and allow it to reach full speed.

4. Place workpiece on sanding belt table, then slowly, and with light pressure, move workpiece into sanding belt.

   Note: *Hold workpiece firmly against table, but keep your fingers away from sanding surface, as shown in* ***Figure 21.***

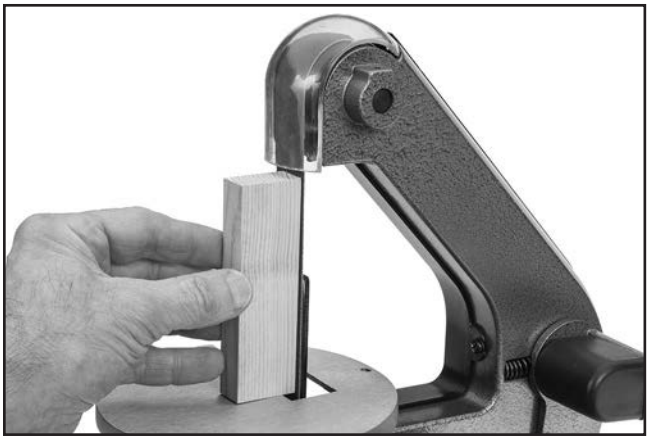


Figure 21. Example of belt sanding.

Adjusting Disc Sander Table

The miter slot must be parallel with the face of the sanding disc to ensure accurate results. To reduce the risk of pinch injuries and to prevent the sandpaper from rubbing against the disc sander table, the gap between the edge of the table and the sanding disc cannot exceed 1/16".

⚠CAUTION

To reduce risk of your fingers getting pinched between work table and sanding disc, always make sure gap between table and sanding disc does NOT exceed 1/16".

Items Needed: **Qty**
Ruler 18" 1

To set table gap and parallelism:

1. DISCONNECT MACHINE FROM POWER!

2. On disc sander table, loosen (2) knobs that secure table to disc sander guard.

3. With sandpaper installed on disc, adjust table so there is a 1/16" maximum gap (see **Figure 22**) between sanding disc and edge of table along its full length, then tighten knobs.

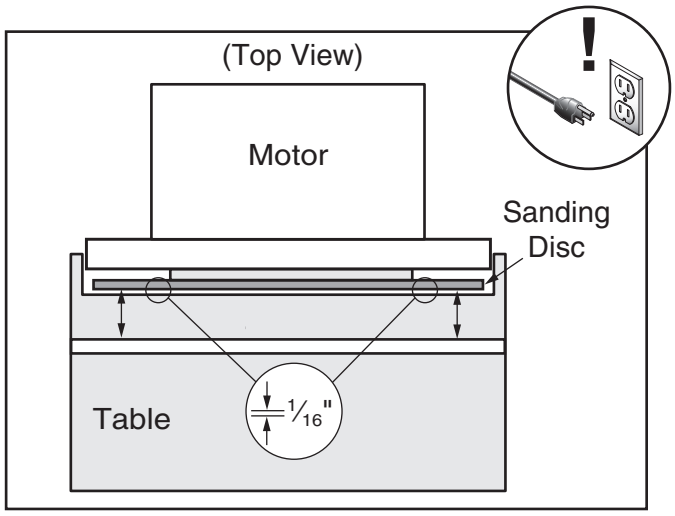


Figure 22. Example of table gap parallel with sanding disc.

4. Rotate disc by hand to ensure sandpaper does not touch table.

   IMPORTANT: DO NOT turn the disc sander ***ON*** until you have verified that it does not touch the table at any point in its rotation! If sandpaper touches tables at any point, re-adjust table parallelism.

Adjusting Platen & Belt Sander Table

The platen acts as a flat surface to sand against. The platen is adjustable and should have a gap of 1/16" between the sandpaper and the platen. At times you may find it useful to remove the platen for polishing or contour sanding. To polish or contour sand, remove the cap screws, washers, and platen. To set the platen-to-belt clearance, loosen the cap screws, and move the platen to get 1/16" between the platen and the belt, then retighten the cap screws.

Items Needed: **Qty**
Hex Wrench 3mm 1
90° Square 1

To adjust or remove platen:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen cap screws located behind platen as shown in **Figure 23**.

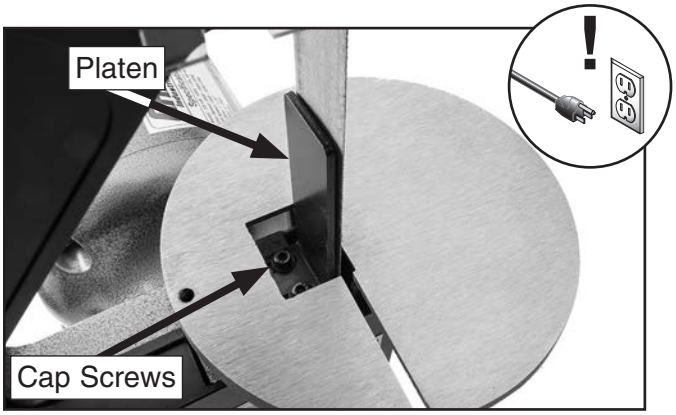


Figure 23. Location of platen and cap screws.

3. Loosen adjustable position handle on sanding belt table, and use a 90° square to square table to platen.

Setting Disc Sander Table Angle

Set the disc sander table angle relative to the sanding disc. The angle can be set using the angle scale on the disc sander housing. For greater accuracy, use a protractor or machinist's square.

Items Needed: **Qty**
90° Square or Protractor 1

To calibrate table tilt:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen disc table tilt knobs and position disc sander table so knob shaft aligns with desired angle on disc table angle scale, as shown in **Figure 24.**

Note: *Although this procedure can be done with sandpaper installed, it is more precise without it.*

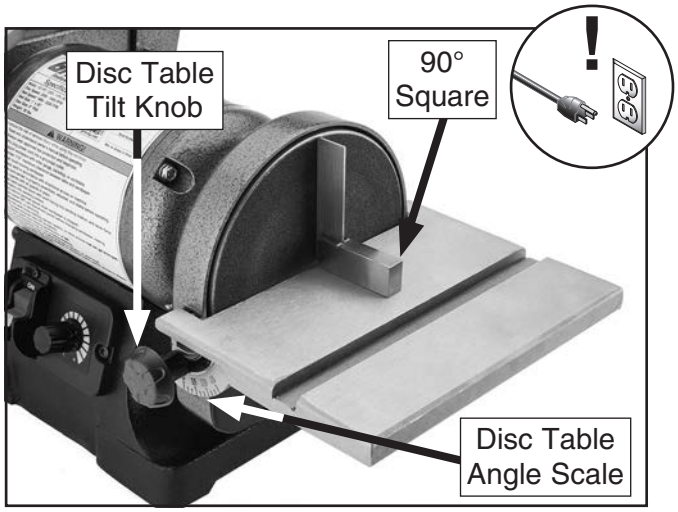


Figure 24. Setting disc sander table angle.

3. Re-tighten disc table tilt knobs.

Calibrating Miter Gauge

A properly calibrated miter gauge is needed to ensure accurate sanding results. When the miter gauge is inserted into the table slot and set 90˚, it should be perpendicular to the face of the disc. If it is not, perform the following procedure to calibrate the miter gauge.

Items Needed: **Qty**
90° Square 1
Phillips Screwdriver #1 1

To calibrate miter gauge:

1. DISCONNECT MACHINE FROM POWER!

2. Check that miter slot is parallel to sanding disc (refer to **Adjusting Disc Sander Table** on **Page 21** for instructions).

3. Set one edge of 90° square against face of miter gauge and other edge against disc face, as shown in **Figure 25**.

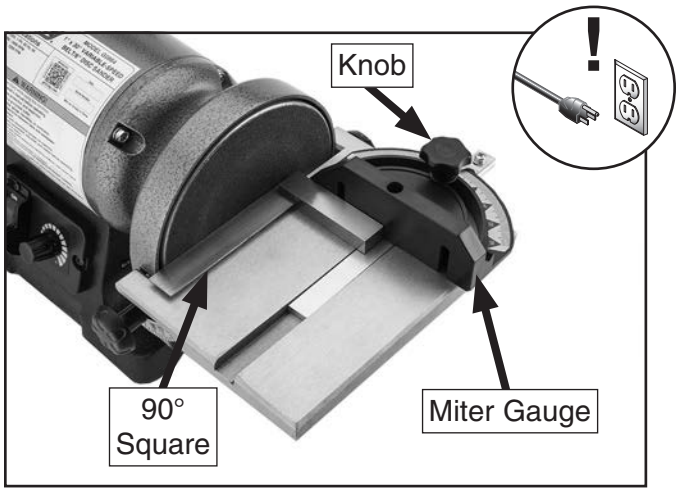


Figure 25. Squaring miter gauge to disc.

4. Loosen knob on miter gauge and adjust face of miter gauge so it is flush with edge of square, tighten gauge knob, and verify setting.

5. If necessary, loosen screw securing degree scale pointer on miter gauge, position pointer on 90˚, and retighten screw.

6. Re-check accuracy with square.

SECTION 5: ACCESSORIES

⚠WARNING

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

NOTICE

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

1" x 30" A/O Sanding Belt (10 Pack)

Model	Grit
H4857	60
H4858	80
H4859	100
T26629	120
T26630	150
T26631	180
T26632	220

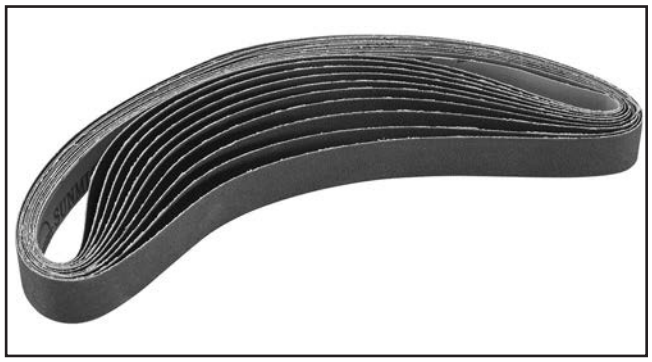


Figure 26. Grizzly 1" x 30" A/O sanding belts.

6" PSA Sanding Discs

Model & Type	Grit
D1307 6" PSA	60
D1308 6" PSA	80
D1309 6" PSA	100
D1310 6" PSA	120
D1311 6" PSA	150
D1312 6" PSA	180
D1313 6" PSA	220

Figure 27. Grizzly 6" PSA sanding discs.

PRO-STIK Abrasive Surface Cleaners

Choose the Pro-Stik with a handle for greater control or without a handle for more usable area.

Size	Model
1½" x 1½" x 8½"	W1306
2" x 2" x 12"	W1307

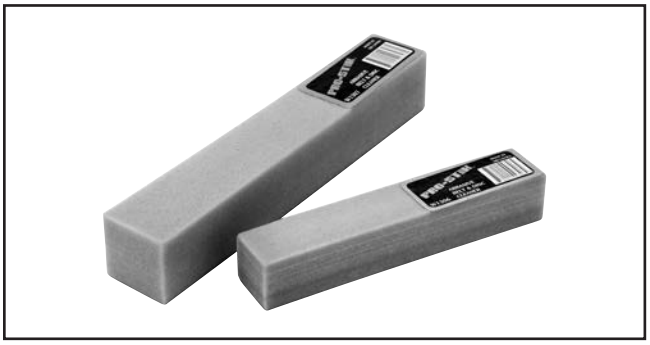
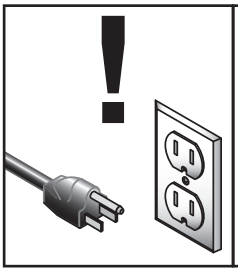


Figure 28. PRO-STIK abrasive cleaners.

SECTION 6: MAINTENANCE



⚠WARNING

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

Schedule

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

Ongoing

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

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

Weekly/Monthly Check

- Vacuum dust out of belt/disc covers.

Lubrication

Since all bearings are sealed and permanently lubricated, simply leave them alone until they need to be replaced. Do not lubricate them.

Cleaning

Cleaning Model G0864 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove.

Using an abrasive belt/disc cleaner can prolong the life of a clogged sanding belt/disc, provided it is in otherwise good condition.

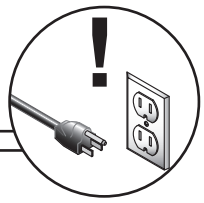
To clean sanding belt/disc:

1. Turn machine ***ON***.
2. Using work table as support, rub abrasive cleaner on sanding belt/disc in continuous motion, covering entire surface of belt/disc until belt/disc is no longer clogged.
3. Turn machine ***OFF***.

SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power-supply fuse/breaker trips immediately after startup.	1. Switch disabling key removed. 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped or fuse blown. 4. Speed control potentiometer at fault. 5. Wiring broken, disconnected, or corroded. 6. ON/OFF switch at fault. 7. Circuit board at fault. 8. Motor at fault.	1. Install switch disabling key (**Page 15**). 2. Ensure correct power supply voltage and circuit size (**Page 9**). 3. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 4. Test/replace if at fault. 5. Check/fix broken, disconnected, or corroded wires. 6. Replace switch. 7. Inspect/replace if at fault. 8. Test/repair/replace.
Machine stalls or is underpowered.	1. Sanding with too much pressure. 2. Workpiece material not suitable for machine. 3. Machine undersized for task. 4. Dust collector undersized or improper ducting, causing dust buildup/clogging. 5. Run capacitor at fault. 6. Motor overheated. 7. Motor bearings at fault.	1. Reduce pressure of workpiece against sanding belt/disc. 2. Only sand wood—ensure moisture is below 20%. 3. Clean/replace sandpaper (**Pages 17 & 19**); reduce feed rate/sanding depth. 4. Move dust collector closer to machine/upgrade dust collector. 5. Test/repair/replace. 6. Clean motor, let cool, and reduce workload. 7. Test/repair/replace.
Machine has vibration or noisy operation.	1. Sanding belt slapping cover. 2. Machine incorrectly mounted to workbench. 3. Motor or component loose. 4. Sanding disc out of balance, damaged, or loose. 5. Motor bearings at fault.	1. Replace/tension sanding belt. 2. Adjust feet, shim, or tighten mounting hardware. 3. Inspect/replace damaged bolts/nuts, and retighten with thread locking fluid. 4. Adjust or replace disc (**Page 17**). 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Sander Operation

Symptom	Possible Cause	Possible Solution
Sanding grains easily rub off belt or disc.	1. Sanding belt/disc has been stored in an incorrect environment. 2. Sanding belt/disc has been smashed or folded.	1. Store sanding belt/disc in a cool, dry area. 2. Store sanding belt/disc flat. Do *not* bend or fold.
Deep sanding grooves or scars in workpiece.	1. Sanding belt/disc too coarse for desired finish. 2. Too much pressure on sanding belt/disc. 3. Workpiece sanded across the grain. 4. Workpiece held still for too long against belt/disc.	1. Use finer grit sanding belt/disc (**Pages 17 & 19**). 2. Reduce pressure on workpiece while sanding. 3. Sand with grain. 4. Keep workpiece moving while sanding.
Sanding belt/disc clogs quickly or burns workpiece.	1. Too much pressure on sanding belt/disc. 2. Sanding softwood. 3. Sanding belt/disc clogged. 4. Sanding belt/disc worn or damaged.	1. Reduce pressure of workpiece against sanding belt/disc. 2. Use different stock, or accept characteristics of stock and plan to clean/replace sanding belt/disc frequently. 3. Clean sanding belt/disc (**Page 24**). 4. Replace sanding belt/disc (**Pages 17 & 19**).
Glazed sanding surface.	1. Sanding wet stock. 2. Sanding stock with high amount of residue.	1. Only sand dry stock. 2. Use different stock, or accept characteristics of stock and plan to clean/replace sanding belt/disc frequently.
Burn marks on workpiece.	1. Too much pressure on sanding belt/disc. 2. Sanding grit too fine. 3. Workpiece held still for too long.	1. Reduce pressure of workpiece against sanding belt/disc. 2. Use coarser grit sanding belt/disc (**Pages 17 & 19**). 3. Keep workpiece moving while sanding.
Workpiece gets pulled out of your hand while belt sanding.	1. Not supporting workpiece against table.	1. Use table to support workpiece.
Workpiece lifts up from sanding disc table.	1. Sanding on the upward spinning half of sanding disc.	1. Sand on downward spinning half of sanding disc.
Miter bar binds in miter slot.	1. Miter slot/bar dirty or gummed up.	1. Carefully clean miter slot/bar with mineral spirits or resin-dissolving cleaner.
Workpiece angle incorrect or out of square when disc sanding.	1. Miter slot not parallel with face of sanding disc. 2. Miter gauge not perpendicular to face of sanding disc. 3. Belt sander table stop is out of adjustment.	1. Set table gap and parallelism (**Page 21**). 2. Calibrate miter gauge (**Page 22**). 3. Set table stop to 90˚ (**Page 22**).
Sanding belt comes off during operation.	1. Belt tracking out of adjustment.	1. Adjust belt tracking (**Page 17**).

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

COLOR KEY

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

Electrical Components

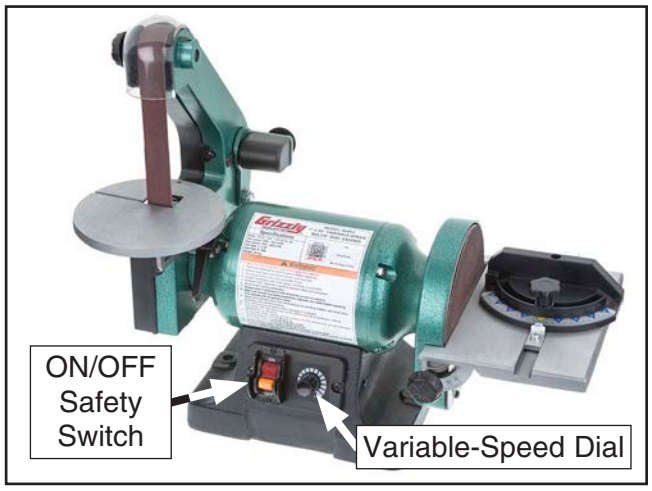


Figure 29. ON/OFF switch and variable-speed dial.

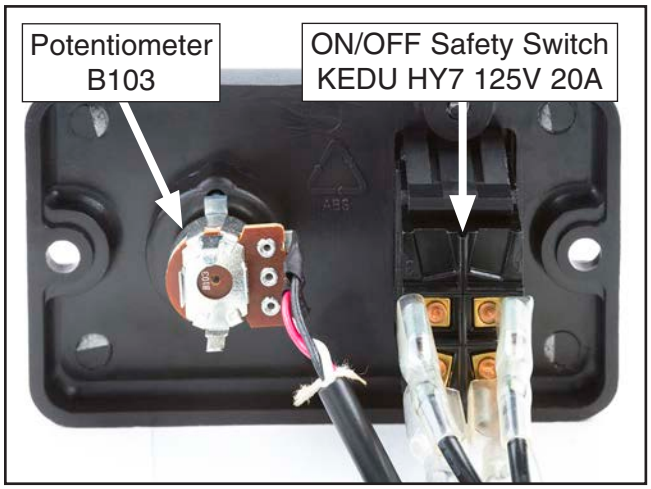


Figure 31. Back of switch and variable-speed dial (potentiometer).

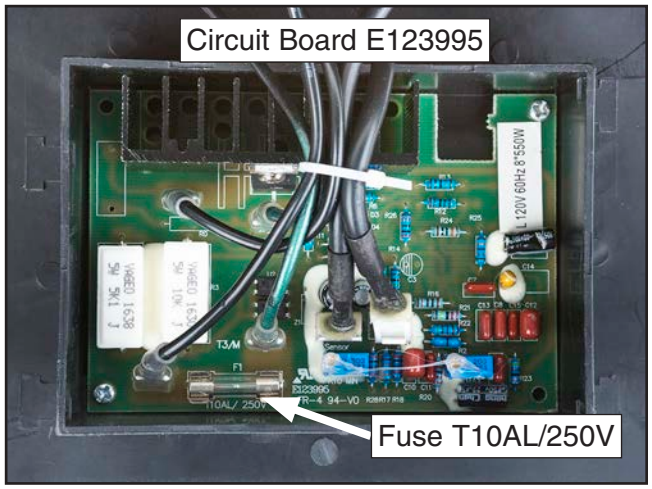
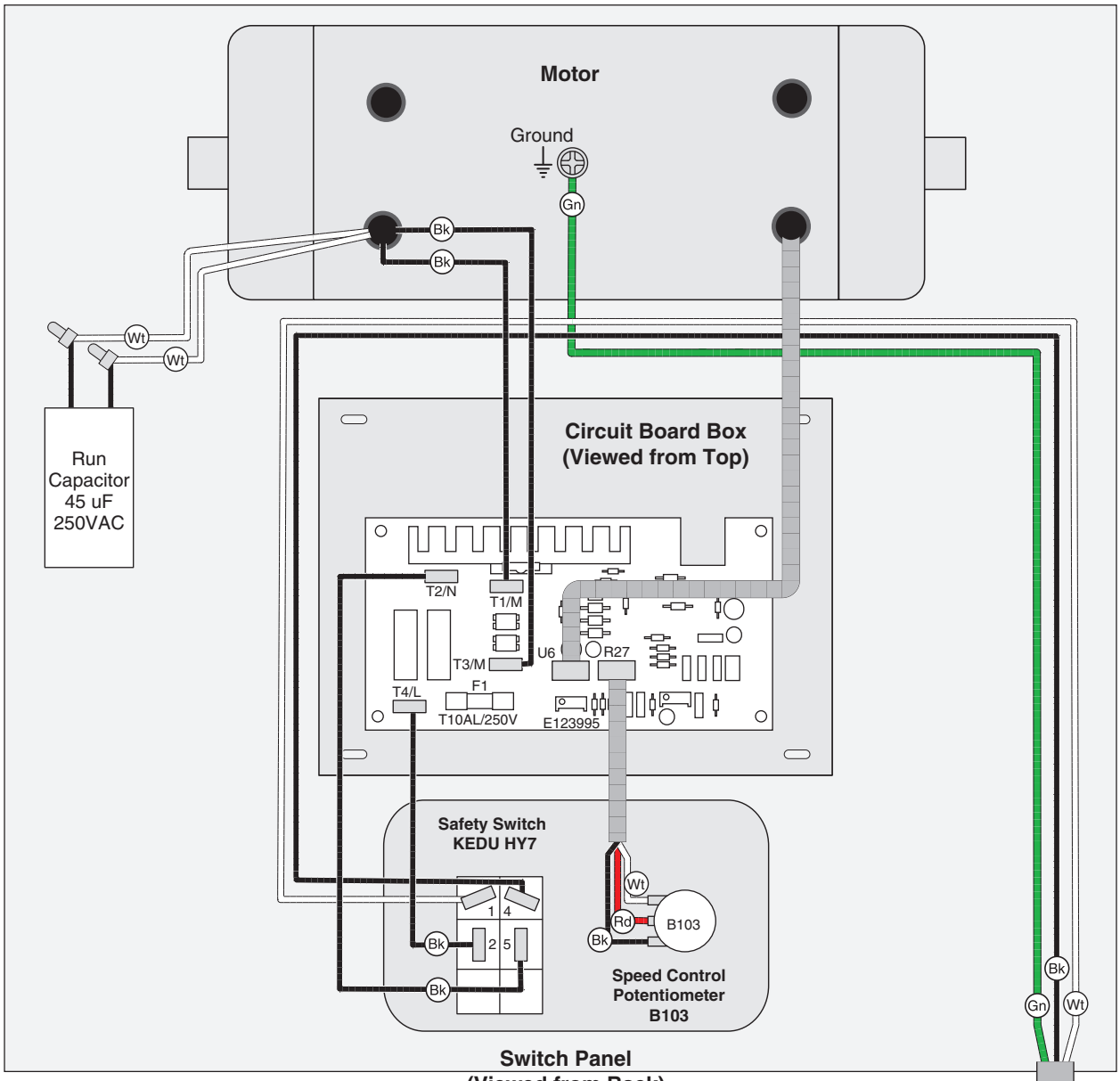


Figure 30. Circuit board and fuse.

Wiring Diagram



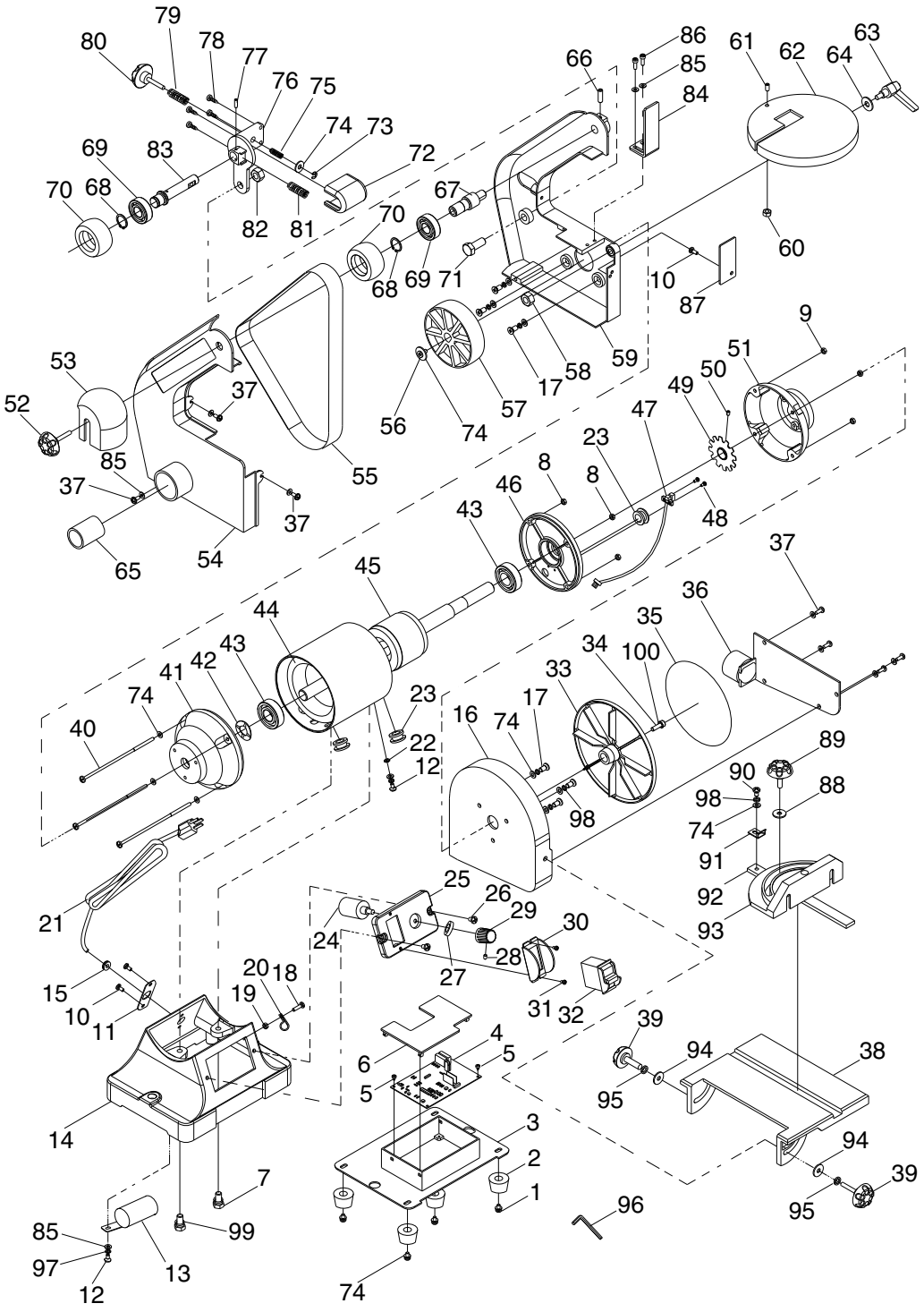
NOTICE

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

SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call **(800) 523-4777** or visit **www.grizzly.com/parts** to check for availability.

Main

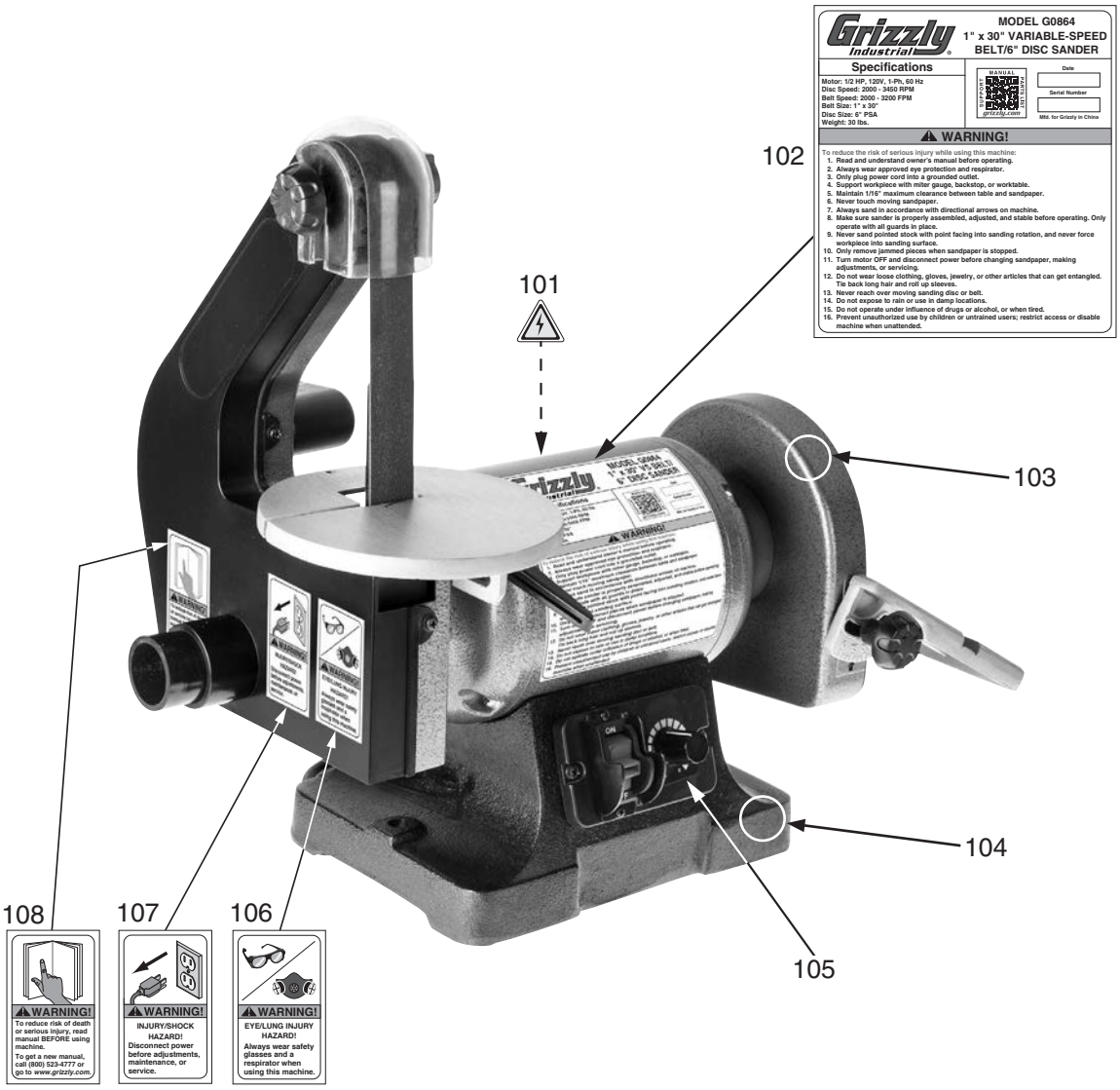


Main Parts List

REF	PART #	DESCRIPTION
1	P0864001	PHLP HD SCR M5-.8 X 16
2	P0864002	RUBBER FOOT
3	P0864003	BASE COVER
4	P0864004	CIRCUIT BOARD
5	P0864005	TAP SCREW M2.9 X 5
6	P0864006	CIRCUIT BOARD COVER
7	P0864007	HEX BOLT M8-1.25 X 22
8	P0864008	HEX NUT M5-.8
9	P0864009	HEX NUT M5-.8
10	P0864010	PHLP HD SCR M4-.7 X 8
11	P0864011	STRAIN RELIEF MOUNTING PLATE
12	P0864012	PHLP HD SCR M4-.7 X 8
13	P0864013	R CAPACITOR 45M 125V 1-3/8 X 2-15/16
14	P0864014	BASE
15	P0864015	STRAIN RELIEF TYPE-1 M16-2
16	P0864016	DISC GUARD
17	P0864017	PHLP HD SCR M5-.8 X 18
18	P0864018	PHLP HD SCR M4-.7 X 16
19	P0864019	HEX NUT M4-.7
20	P0864020	LOOP CLAMP 3/16" PLASTIC
21	P0864021	POWER CORD 18G 3W 72" 5-15P
22	P0864022	EXT TOOTH WASHER 4MM
23	P0864023	GROMMET
24	P0864024	POTENTIOMETER KEDU B103
25	P0864025	SWITCH PLATE
26	P0864026	PHLP HD SCR M5-.8 X 8
27	P0864027	RUBBER WASHER 6 X 14 X 4MM
28	P0864028	SET SCREW M4-.7 X 5
29	P0864029	VARIABLE SPEED DIAL
30	P0864030	SWITCH COVER
31	P0864031	PHLP HD SCR M3-.5 X 10
32	P0864032	TOGGLE SWITCH KEDU HY7
33	P0864033	SANDING DISC 6"
34	P0864034	CAP SCREW M6-1 X 16
35	P0864035	SANDING DISC 6" 100-GRIT PSA
36	P0864036	DISC SANDER DUST COVER W/DUST PORT
37	P0864037	PHLP HD SCR M4-.7 X 8
38	P0864038	DISC SANDING TABLE
39	P0864039	KNOB BOLT M6-1 X 20, D35, ROUND
40	P0864040	PHLP HD SCR M5-.8 X 160
41	P0864041	MOTOR END CAP (LEFT)
42	P0864042	WAVY WASHER 17MM
43	P0864043	BALL BEARING 6203-2RS
44	P0864044	STATOR
45	P0864045	ROTOR
46	P0864046	MOTOR CLAMPING PLATE
47	P0864047	ROTATION SENSOR
48	P0864048	PHLP HD SCR M2.5-.45 X 6
49	P0864049	ROTATION SENSOR FEEDBACK WHEEL
50	P0864050	SET SCREW M5-.8 X 6

REF	PART #	DESCRIPTION
51	P0864051	MOTOR END CAP (RIGHT)
52	P0864052	KNOB BOLT M8-1.25 X 10, D35, ROUND
53	P0864053	SANDING BELT GUARD
54	P0864054	SANDING BELT DUST COVER W/2" DUST PORT
55	P0864055	SANDING BELT 1" X 30" 100-GRIT
56	P0864056	PHLP HD SCR M5-.8 X 16 LH
57	P0864057	DRIVE PULLEY
58	P0864058	HEX NUT M8-1.25
59	P0864059	BELT HOUSING
60	P0864060	HEX NUT M6-1
61	P0864061	SET SCREW M6-1 X 20
62	P0864062	BELT SANDING TABLE
63	P0864063	ADJUSTABLE HANDLE M8-1.25 X 19, 65L
64	P0864064	FENDER WASHER 8MM
65	P0864065	DUST HOSE ADAPTER 1-1/2"-2"
66	P0864066	SET SCREW M6-1 X 8
67	P0864067	IDLER SHAFT
68	P0864068	EXT RETAINING RING 15MM
69	P0864069	BALL BEARING 6202-2RS
70	P0864070	IDLER PULLEY
71	P0864071	HEX BOLT M10-1.5 X 25
72	P0864072	TRACKING CONTROL COVER
73	P0864073	E-CLIP 5MM
74	P0864074	FLAT WASHER 5MM
75	P0864075	COMPRESSION SPRING 0.8 X 7.5 X 8MM
76	P0864076	TRACKING CONTROL MOUNTING BRACKET
77	P0864077	ROLL PIN 3 X 20
78	P0864078	TAP SCREW M4 X 13
79	P0864079	COMPRESSION SPRING 1 X 11.7 X 14.2MM
80	P0864080	KNOB BOLT M8-1.25 X 22, D35, ROUND
81	P0864081	COMPRESSION SPRING 1.5 X 11 X 36.5MM
82	P0864082	LOCK NUT M10-1.5
83	P0864083	TRACKING CONTROL IDLER SHAFT 15 X 83MM
84	P0864084	PLATEN
85	P0864085	FLAT WASHER 4MM
86	P0864086	CAP SCREW M4-.7 X 10
87	P0864087	BELT GUARD PLATE
88	P0864088	FENDER WASHER 6MM
89	P0864089	KNOB BOLT M6-1 X 21, D34, 6-LOBE
90	P0864090	PHLP HD SCR M5-.8 X 8
91	P0864091	MITER GAUGE POINTER
92	P0864092	MITER BAR
93	P0864093	MITER GAUGE BASE
94	P0864094	FLAT WASHER 6MM
95	P0864095	LOCK WASHER 6MM
96	P0864096	HEX WRENCH 3MM
97	P0864097	LOCK WASHER 4MM
98	P0864098	LOCK WASHER 5MM
99	P0864099	LOCK WASHER 8MM
100	P0864100	EXT TOOTH WASHER 6MM

Labels & Cosmetics



REF	PART #	DESCRIPTION
101	P0864101	ELECTRICITY LABEL
102	P0864102	MACHINE ID LABEL
103	P0864103	TOUCH-UP PAINT, GRIZZLY GREEN
104	P0864104	TOUCH-UP PAINT, GLOSSY BLACK

REF	PART #	DESCRIPTION
105	P0864105	VARIABLE SPEED DIAL LABEL
106	P0864106	GLASSES/RESPIRATOR LABEL
107	P0864107	DISCONNECT 110V LABEL
108	P0864108	READ MANUAL LABEL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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