



MODEL G1014Z/G1014ZX

6" X 48" BELT/9" DISC COMBINATION SANDER

OWNER'S MANUAL

(For models manufactured since 07/17)

G1014Z



G1014ZX



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WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

This combination sander can be used to smooth the faces, edges, or ends of workpieces using the sanding belt or the sanding disc.

The sanding belt can be used in either the horizontal position or vertical position.

The back stop supports workpieces in the horizontal position, and the work table supports workpieces on the sanding disc or the belt when it is in the vertical position.

The work table and miter gauge can be adjusted for the desired angle.

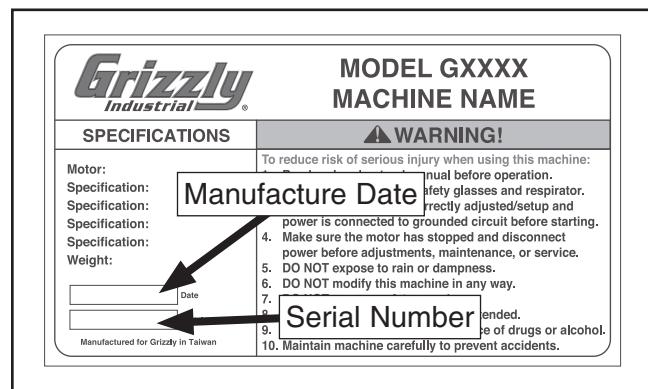
Manual Accuracy

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

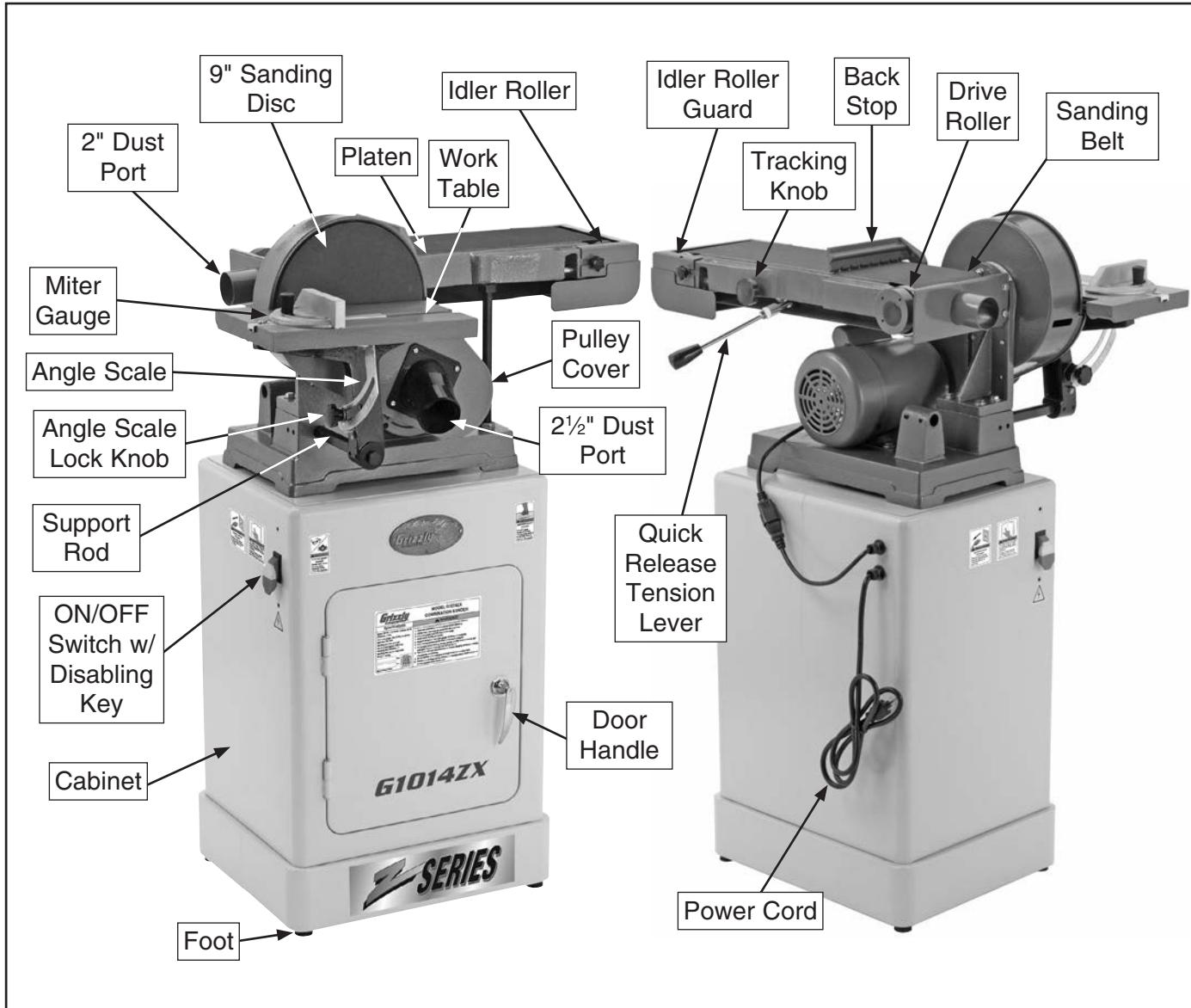


Figure 1. G1014ZX identification.





MACHINE DATA SHEET

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

MODEL G1014Z COMBINATION SANDER 6" X 48" BELT 9" DISC Z SERIES

Product Dimensions:

Weight.....	117 lbs.
Width (side-to-side) x Depth (front-to-back) x Height.....	30 x 24 x 56 in.
Footprint (Length x Width).....	23 x 19 in.

Shipping Dimensions:

Type.....	Cardboard Box
Content.....	Machine
Weight.....	122 lbs.
Length x Width x Height.....	19 x 29 x 15 in.
Must Ship Upright.....	No

Electrical:

Power Requirement.....	110V or 220V, Single-Phase, 60 Hz
Prewired Voltage.....	110V
Full-Load Current Rating.....	12A at 110V, 6A at 220V
Minimum Circuit Size.....	15A at 110V, 15A at 220V
Connection Type.....	Cord & Plug
Power Cord Included.....	Yes
Power Cord Length.....	6 ft.
Power Cord Gauge.....	16 AWG
Plug Included.....	Yes
Included Plug Type.....	5-15 for 110V
Recommended Plug Type.....	6-15 for 220V
Switch Type.....	Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower.....	3/4 HP
Phase.....	Single-Phase
Amps.....	12A/6A
Speed.....	3450 RPM
Type.....	TEFC Capacitor-Start Induction
Power Transfer.....	Belt Drive
Bearings.....	Sealed & Permanently Lubricated

Main Specifications:

Belt Sander Info

Sanding Belt Width.....	6 in.
Sanding Belt Length.....	48 in.
Sanding Belt Speed.....	2300 FPM
Sanding Belt Tilt.....	90 deg.
Max Height of Belt in Vertical Position.....	56 in.
Belt Tension Release Type.....	Quick Release
Platen Type.....	Graphite Coated
Platen Length.....	17 in.
Platen Width.....	6-1/4 in.



Disc Sander Info

Disc Diameter.....	9 in.
Disc Speed.....	3450 RPM
Disc Sandpaper Backing Type.....	PSA
Table Length.....	12-1/4 in.
Table Width.....	6 in.
Table Thickness.....	1 in.
Table Tilt.....	Left 0, Right 45 deg.
Table-to-Floor Height.....	35 in.

Construction Materials

Base.....	Cast Iron
Stand.....	Preformed Steel
Table.....	Cast Iron
Frame.....	Cast Iron
Disc.....	Cast Iron
Miter Gauge.....	Die Cast Aluminum/Aluminum Bar
Paint Type/Finish.....	Epoxy

Other Related Info

Miter Gauge Slot Width.....	3/4 in.
Miter Gauge Slot Height.....	13/32 in.
Number of Dust Ports.....	2
Dust Port Size.....	2, 2-1/2 in.
Compatible Mobile Base.....	D2057A

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1-1/2 Hours
Serial Number Location	ID Label on Front of Stand, Above Grizzly Nameplate
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No
Awards	Wood Magazine Best Value 1998

Features:

- 2" Dust Port for Belt and 2-1/2" Dust Port for Disc
- Quick Belt Release
- Work Table Mounts for Use on Disc or Belt
- Single Knob Tracking
- Cast-Iron Table
- Graphite Coated Platen
- Sturdy Steel Stand





MACHINE DATA SHEET

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

MODEL G1014ZX COMBINATION SANDER WITH CABINET STAND

Product Dimensions:

Weight.....	148 lbs.
Width (side-to-side) x Depth (front-to-back) x Height.....	30 x 24 x 56 in.
Footprint (Length x Width).....	15 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type.....	Cardboard Box
Content.....	Machine
Weight.....	106 lbs.
Length x Width x Height.....	29 x 19 x 15 in.
Must Ship Upright.....	No

Carton #2

Type.....	Cardboard Box
Content.....	Stand
Weight.....	52 lbs.
Length x Width x Height.....	17 x 20 x 28 in.
Must Ship Upright.....	No

Electrical:

Power Requirement.....	110V or 220V, Single-Phase, 60 Hz
Prewired Voltage.....	110V
Full-Load Current Rating.....	12A at 110V, 6A at 220V
Minimum Circuit Size.....	15A at 110V, 15A at 220V
Connection Type.....	Cord & Plug
Power Cord Included.....	Yes
Power Cord Length.....	8-1/2 ft.
Power Cord Gauge.....	16 AWG
Plug Included.....	Yes
Included Plug Type.....	5-15 for 110V
Recommended Plug Type.....	6-15 for 220V
Switch Type.....	Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower.....	3/4 HP
Phase.....	Single-Phase
Amps.....	12A/6A
Speed.....	3450 RPM
Type.....	TEFC Capacitor-Start Induction
Power Transfer.....	Belt Drive
Bearings.....	Sealed & Permanently Lubricated



Main Specifications:**Belt Sander Info**

Sanding Belt Width.....	6 in.
Sanding Belt Length.....	48 in.
Sanding Belt Speed.....	2300 FPM
Sanding Belt Tilt.....	90 deg.
Max Height of Belt in Vertical Position.....	58 in.
Belt Tension Release Type.....	Quick Release
Platen Type.....	Graphite Coated
Platen Length.....	17 in.
Platen Width.....	6-1/4 in.

Disc Sander Info

Disc Diameter.....	9 in.
Disc Speed.....	3450 RPM
Disc Sandpaper Backing Type.....	PSA
Table Length.....	12-1/4 in.
Table Width.....	6 in.
Table Thickness.....	1 in.
Table Tilt.....	Left 0, Right 45 deg.
Table-to-Floor Height.....	37-1/2 in.

Construction Materials

Base.....	Cast Iron
Stand.....	Sheet Metal
Table.....	Cast Iron
Frame.....	Cast Iron
Disc.....	Cast Iron
Miter Gauge.....	Die Cast Aluminum/Aluminum Bar
Paint Type/Finish.....	Powder Coated

Other Related Info

Miter Gauge Slot Width.....	3/4 in.
Miter Gauge Slot Height.....	13/32 in.
Number of Dust Ports.....	2
Dust Port Size.....	2, 2-1/2 in.
Compatible Mobile Base.....	D2260A

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	ID Label on Stand
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

Features:

- Solid Cabinet Stand
- Built-in Storage Shelf
- Quick Belt Release Mechanism
- Cast-Iron Table, Disc and Body



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



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 Belt & Disc Sanders

WARNING

Serious injury or death can occur from fingers, clothing, jewelry, or hair getting 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.

HAND PLACEMENT. Rotating sandpaper can remove a large amount of flesh quickly. Always keep hands away from sandpaper during operation. Never touch moving sandpaper on purpose. Use a brush to clean table of sawdust and chips.

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.

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 $\frac{1}{16}$ " away from sandpaper. For spindle sanders, always use the table insert that fits closest diameter of installed drum.

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.

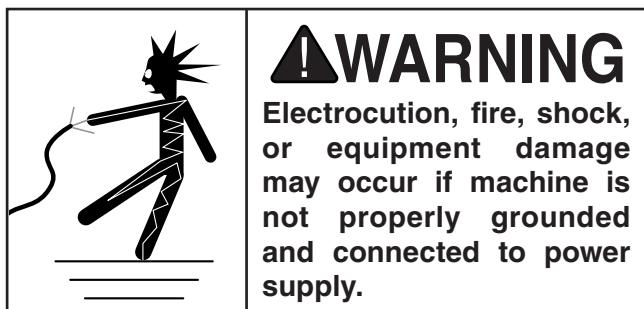
WORKPIECE INTEGRITY. Sanding fragile workpieces can result in loss of control, resulting in abrasion injuries, impact injuries, or damage to sandpaper. Only sand solid workpieces that can withstand power sanding forces. Make sure workpiece shape is properly supported; avoid sanding workpieces without 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.



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 specified circuit requirements.

Circuit Information

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

CAUTION

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

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

Circuit Requirements for 110V

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

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

Circuit Requirements for 220V

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

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



Grounding Requirements

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

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

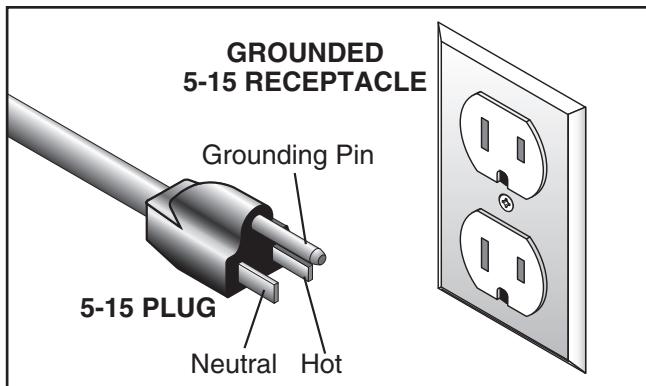
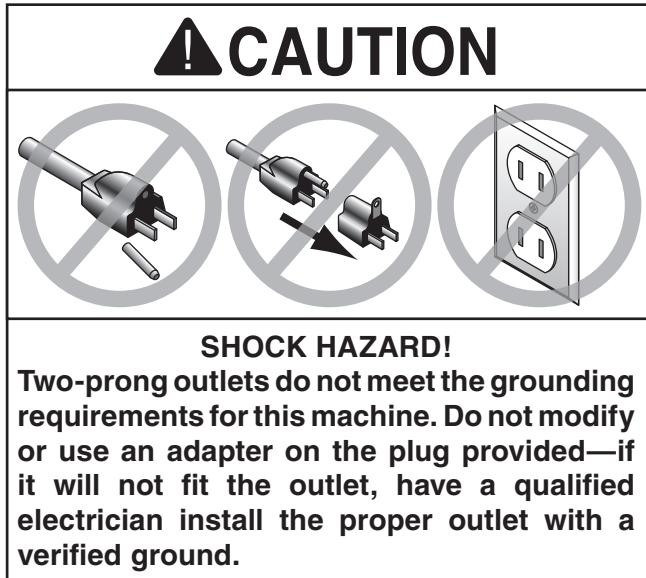


Figure 2. Typical 5-15 plug and receptacle.



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.

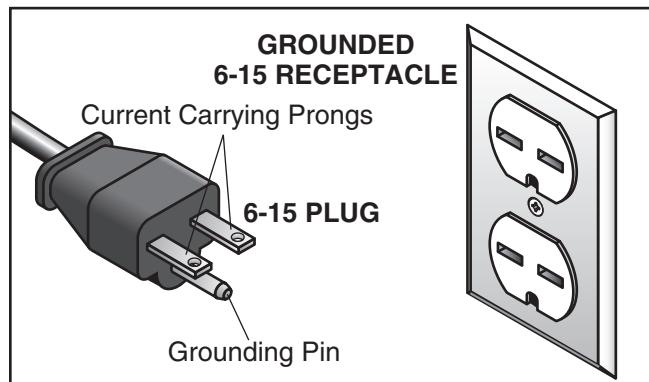


Figure 3. Typical 6-15 plug and receptacle.

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

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

Extension Cords

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

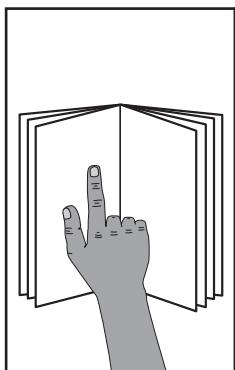
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

Minimum Gauge Size 14 AWG
Maximum Length (Shorter is Better)..... 50 ft.



SECTION 3: SETUP



⚠️ WARNING

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



⚠️ WARNING

Wear safety glasses during the entire setup process!



⚠️ WARNING

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

⚠️ WARNING

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

⚠️ CAUTION

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

Needed for Setup

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

Description	Qty
Safety Glasses	1
Cleaner/Degreaser	As Needed
Disposable Shop Rags.....	As Needed
Forklift.....	1
Additional People	1
Wrench 10mm	1
Wrench 12mm	1
Dust Hose 2"	1
Dust Hose Clamp 2"	1
Dust Hose 2½"	1
Dust Hose Clamp 2½".....	1
Flashlight	1
Machinist's Square	1

Unpacking

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

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

Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

○ #10

○ 1/4"

○ 5/16"

○ 3/8"

○ 7/16"

○ 1/2"

○ 4mm

○ 5mm

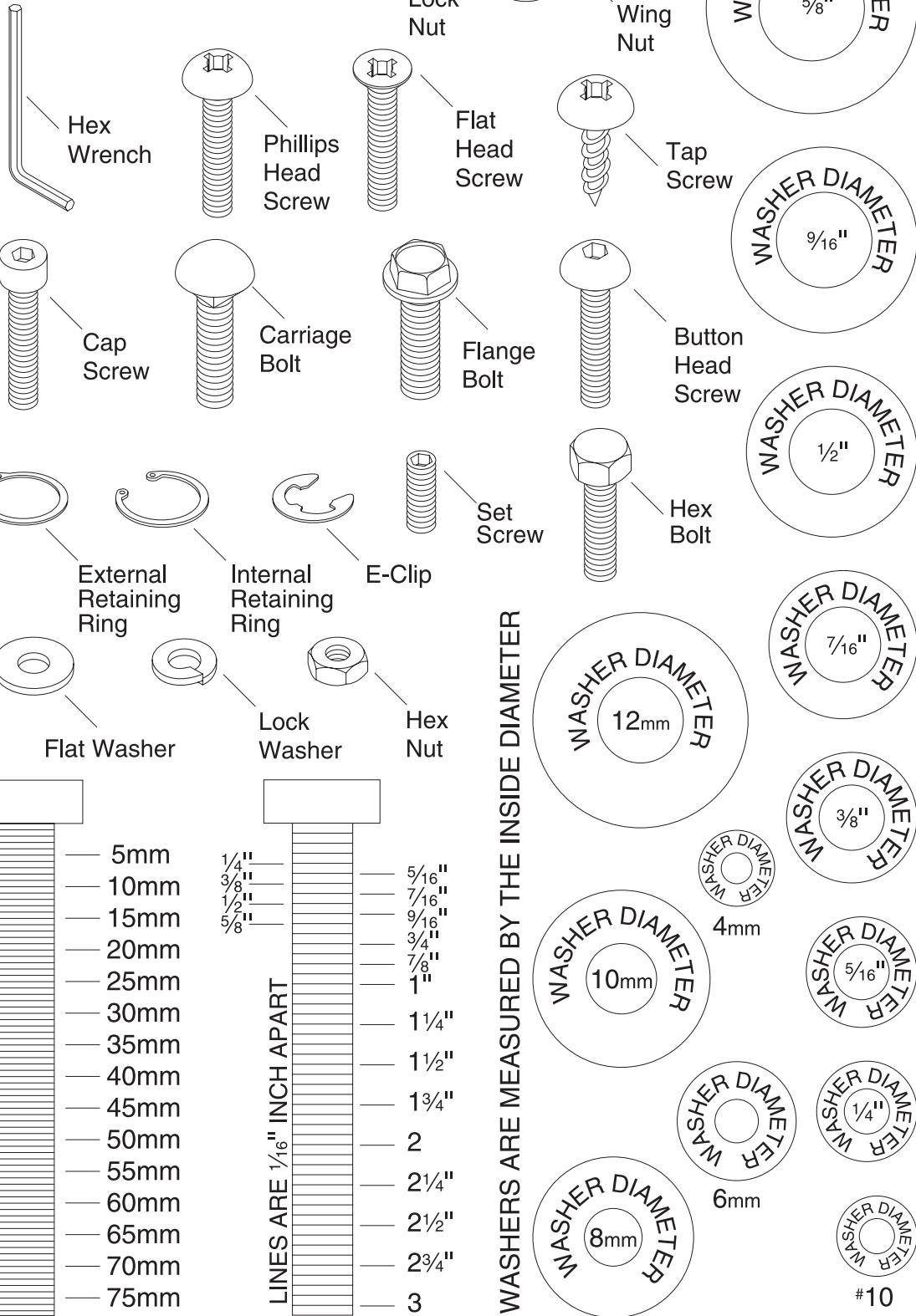
○ 6mm

○ 8mm

○ 10mm

○ 12mm

○ 16mm



G1014Z Inventory

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

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

Box 1 (Figures 4–6)

	Qty
A. Sander Unit	1
B. Stand Legs	4
C. Long Lower Braces	2
D. Long Upper Braces	2
E. Short Lower Braces	2
F. Short Upper Braces	2
G. Sanding Belt 6" x 48"	1
H. Dust Port 2½" (Black)	1
I. Work Table	1
J. Miter Gauge	1
K. Back Stop	1
L. Rubber Feet	4
M. Table Support Rod	1
N. Quick Release Lever Stud	1
O. Short Lever, 4½" Long	1
P. Quick Release Lever Handle	1
Q. Idler Roller	1
R. Idler Roller Guard	1
S. Dust Port 2" (Green)	1
T. Cast Iron Plate	1
U. Sanding Disc 9"	1

Hardware & Tools (not shown)

	Qty
• Hex Wrench 4mm	1
• Hex Bolts 5/16"-18 x 1" (Feet)	4
• Hex Nuts 5/16"-18 (Feet, Stand)	36
• Flat Washers 5/16" (Feet, Stand)	40
• Hex Bolts 5/16"-18 x 1/2" (Stand & Sander)	4
• Carriage Bolts 5/16"-18 x 1/2" (Stand)	32
• Phillip Head Screws #10-24 x 3/8" (2½" Dust Port)	4
• Hex Nuts #10-24 (2½" Dust Port)	4
• Flat Washers #10 (2½" Dust Port)	4
• Hex Nuts 3/8"-16 (Quick Release Lever)	2
• Thumb Knobs 1/4"-20 x 1/2" (Sander Unit)	2
• Flat Washers 1/4" (Sander Unit)	2
• Thumb Knobs M5-.8 x 10 (Roller Guard)	2
• Flat Washers #10 (Roller Guard)	2
• Lock Washers #10 (Roller Guard)	2

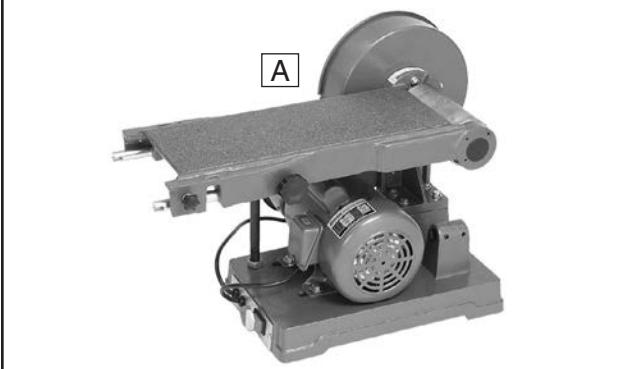


Figure 4. G1014Z sander unit.

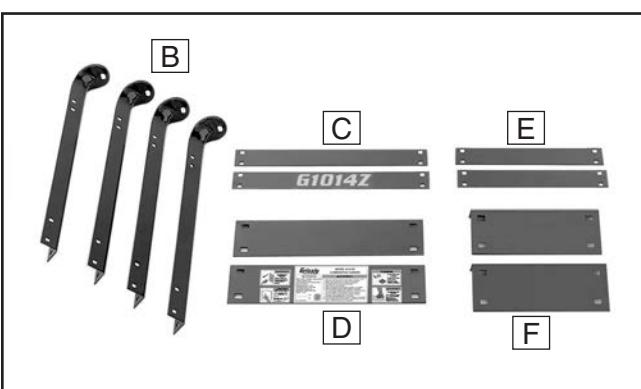


Figure 5. G1014Z stand components.

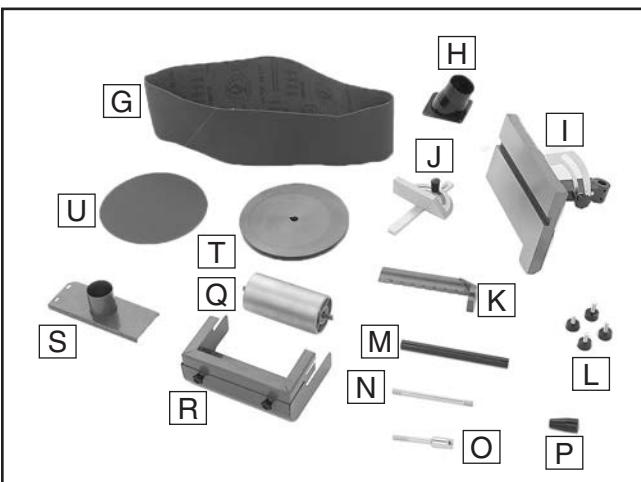


Figure 6. Loose inventory items.

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.

G1014ZX Inventory

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

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

Box 1 (Figures 7–8)

Qty

A. Sander Unit	1
B. Sanding Belt 6" x 48"	1
C. Dust Port 2½" (Black).....	1
D. Work Table	1
E. Miter Gauge.....	1
F. Back Stop	1
G. Rubber Feet (Cabinet)	4
H. Quick Release Lever Handle	1
I. Table Support Rod	1
J. Quick Release Lever Stud.....	1
K. Short Lever, 4½" Long.....	1
L. Idler Roller Guard.....	1
M. Idler Roller	1
N. Cast Iron Plate.....	1
O. Sanding Disc 9".....	1
P. Dust Port 2" (Green).....	1

Hardware & Tools (not shown)

Qty

• Hex Wrench 4mm.....	1
• Hex Bolts 5/16"-18 x 1/2" (Sander & Cabinet) .	4
• Flat Washers 5/16" (Sander & Cabinet).....	4
• Phillip Head Screws #10-24 x 1/2"	
(2½" Dust Port).....	4
• Hex Nuts #10-24 (2½" Dust Port).....	4
• Flat Washers #10 (2½" Dust Port).....	4
• Hex Nuts 3/8"-16 (Quick Release Lever)	2

Box 2 (Figure 9)

Qty

Q. Cabinet	1
R. Shelf	1

Hardware (not shown)

Qty

• Hex Nuts 5/16"-18 (Cabinet)	4
• Hex Bolts 5/16"-18 x 1" (Cabinet)	4
• Flat Washers 5/16" (Cabinet)	4
• Thumb Knobs 1/4"-20 x 1/2" (Sander Unit)....	2
• Flat Washers 1/4" (Sander Unit).....	2
• Thumb Knobs M5-.8 x 10 (Roller Guard)	2
• Flat Washers #10 (Roller Guard).....	2
• Lock Washers #10 (Roller Guard).....	2

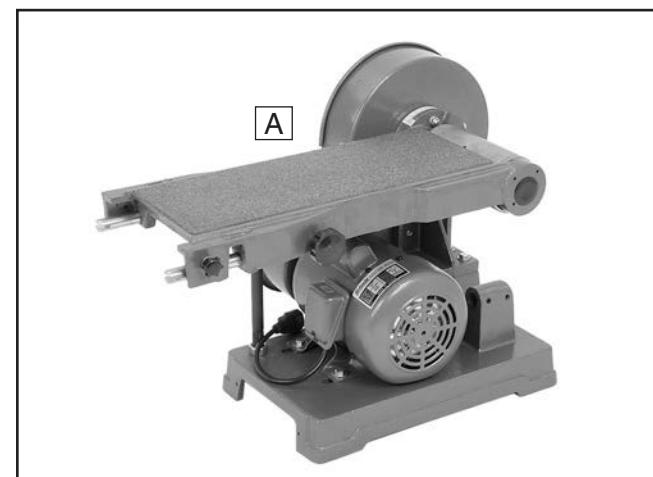


Figure 7. G1014ZX sander unit.

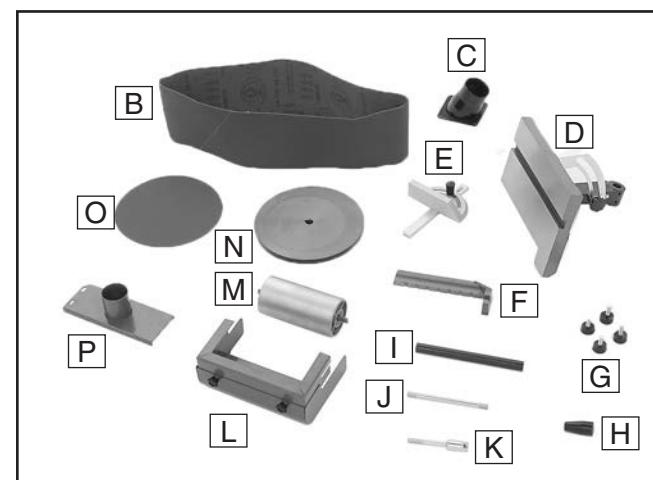


Figure 8. G1014ZX loose inventory items.

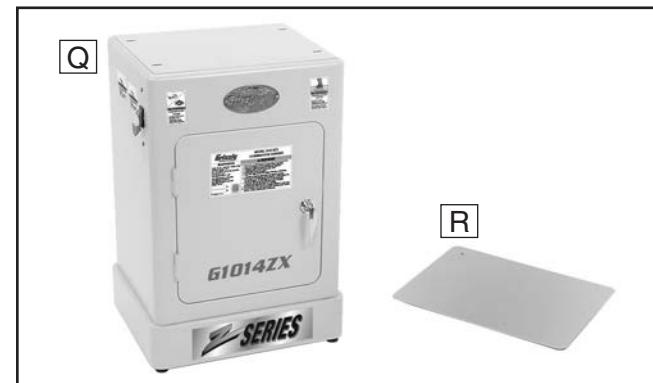


Figure 9. Cabinet inventory.

NOTICE

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



Cleanup

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

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

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

Before cleaning, gather the following:

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

Basic steps for removing rust preventative:

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

NOTICE

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

Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some residential floors or workbenches may require additional reinforcement to support the machine and operator or machine and workpiece.

Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 10** for the minimum working clearances.

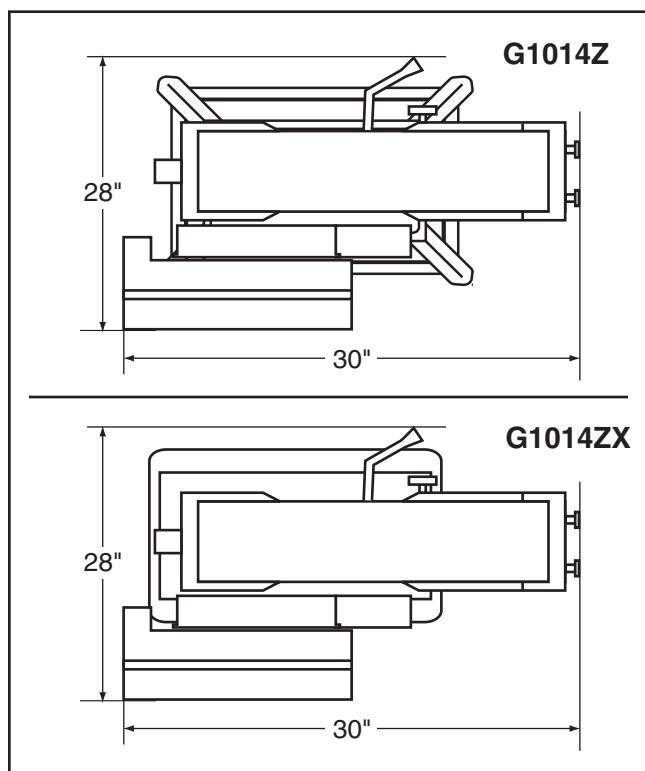
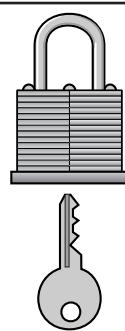


Figure 10. Minimum working clearances.



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.



Mounting to Shop Floor

Although not required, we recommend that you mount your new Model G1014Z sander to the floor. The Model G1014ZX sander cabinet cannot be mounted to the floor because the mounting holes cannot be accessed through the cabinet. However, you can use machine mounts on the G1014ZX cabinet.

Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor or mount it on machine mounts. Whichever option you choose, it is necessary to level your machine with a precision level.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 11**) and anchor studs are two popular methods for anchoring an object to a concrete floor.

We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

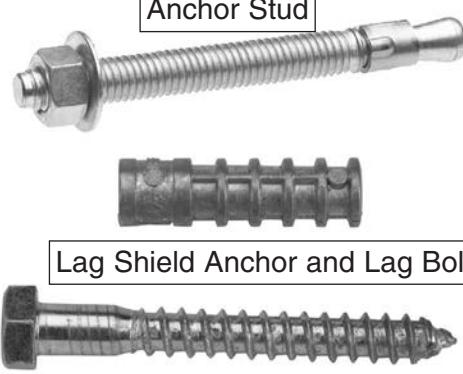


Figure 11. Typical fasteners for mounting to concrete floors.

To mount the Model G1014Z stand to the floor:

1. Follow the instructions for assembling the stand (refer to **G1014Z Stand Assembly** on **Page 19**).
2. Place the stand on the floor where you plan to mount it.
3. Use a pencil or pen to transfer the stand mounting hole locations onto the floor.
4. Drill holes in the floor and install the stand with the appropriate mounting hardware.
5. Using a precision level, level the stand front-to-back and side-to-side. If necessary, place shims between the floor and the stand to level it.

Mobile Base

You can mount the Model G1014Z to the Model G7314 (shown below) or the G1014ZX to the Model G8683 mobile base (see **Accessories, Page 41**).

G7314—Heavy-Duty SHOP FOX® Mobile Base

Make your machine mobile with this popular patented mobile base. The unique outrigger type supports increase stability and lower machine height. This heavy duty mobile base is rated for up to a 700 lb. capacity.



Figure 12. G7314 SHOP FOX® Mobile Base.



G1014Z Stand Assembly

The Model G1014Z stand can be assembled with the included feet or mounted directly to a concrete floor (refer to **Mounting to Shop Floor on Page 18** for further details).

To assemble the G1014Z Stand:

1. Insert a $\frac{5}{16}$ "-18 x 1" hex bolt through bottom of rubber foot, then insert foot into bottom of leg and fasten it finger tight with $\frac{5}{16}$ "-18 hex nut and flat washer, as shown in **Figure 13**.

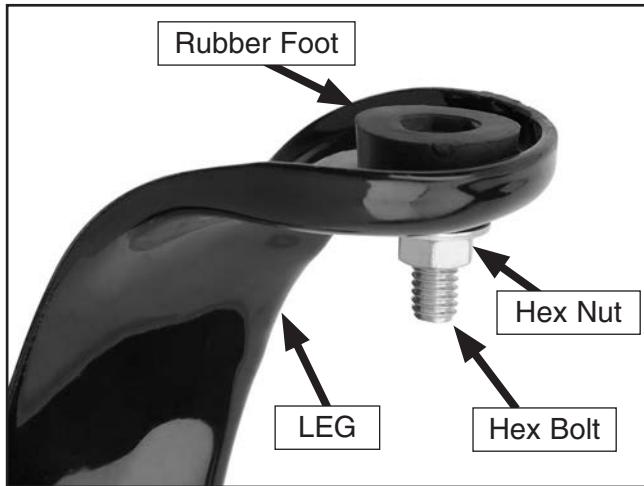


Figure 13. Foot fastened to bottom of a leg.

2. Repeat **Step 1** to install remaining feet on the other three legs.

3. Fasten a long upper and long lower brace to the two stand legs with (8) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " carriage bolts, $\frac{5}{16}$ "-18 hex nuts, and $\frac{5}{16}$ " flat washers, as shown in **Figure 14**. Finger tighten the fasteners for now.

Note: Make sure the *lip* on the long braces faces up.

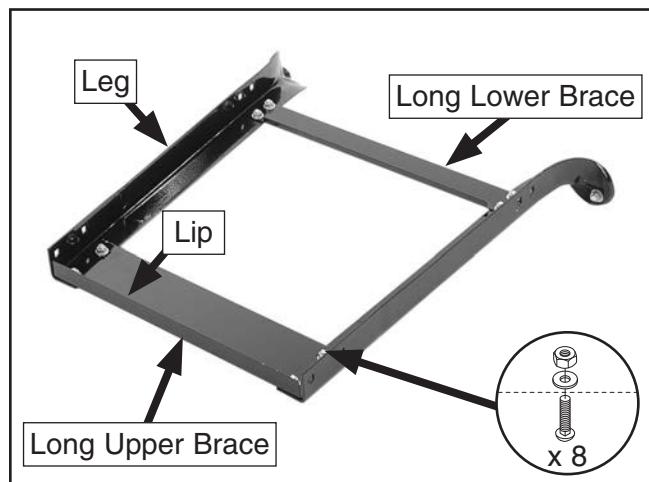


Figure 14. Stand legs fastened to long braces.

4. Repeat **Step 3** to fasten the two remaining long upper and long lower braces to the remaining stand legs.

5. Fasten the two short upper braces and the two short lower braces to one of the leg assemblies with the (8) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " carriage bolts, $\frac{5}{16}$ "-18 hex nuts, and $\frac{5}{16}$ " flat washers, as shown in **Figure 15**.

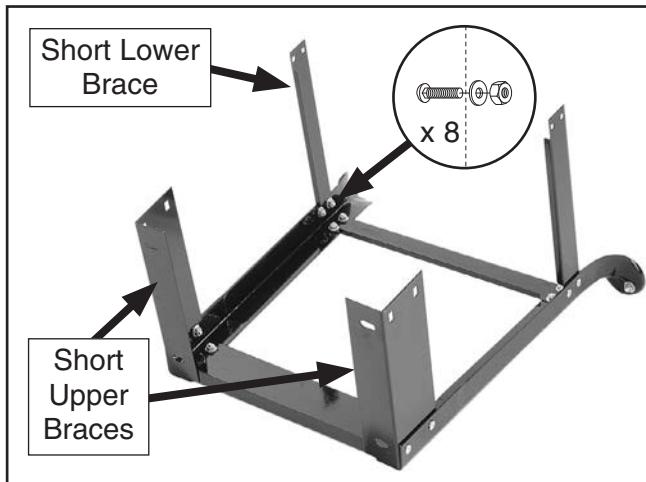


Figure 15. Short upper and lower braces fastened to leg assembly.

Make sure the two short upper braces overlap the long upper braces and that the braces are placed inside the leg assemblies, as shown in **Figure 16**.

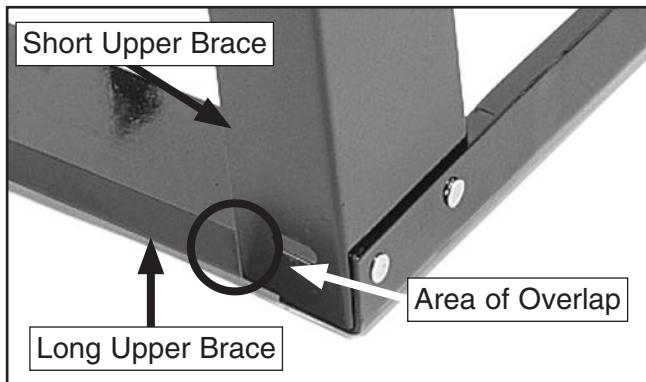


Figure 16. Short brace overlapping long upper brace.

6. Fasten the second leg assembly to the braces on the first leg assembly with the remaining (8) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " carriage bolts, $\frac{5}{16}$ "-18 hex nuts, and $\frac{5}{16}$ " flat washers, then place the stand upright on its feet, as shown in **Figure 17**.



Figure 17. Stand assembled.

7. Final tighten all the fasteners on the stand.
8. Tighten the lock nuts on the feet.
9. (*Optional*) Place a level on top of the stand (see **Figure 18**) and adjust the stand if needed by shimming the feet so it is level from front-to-back and side-to-side.



Figure 18. Leveling stand.

G1014ZX Cabinet Assembly

To assemble the G1014ZX cabinet:

1. Place the stand flat on its side, but do not lay it down on the switch or door handle.
2. Insert a $\frac{5}{16}$ "-18 x 1" hex bolt through the bottom of each of the four rubber feet, then insert the hex bolt on each foot into the mounting holes on the bottom of the cabinet.
3. Fasten each foot with a $\frac{5}{16}$ "-18 hex nut and $\frac{5}{16}$ " flat washer (see **Figure 19**).



Figure 19. Feet installed onto bottom of cabinet.

4. Place the stand upright on its feet, then place the shelf in the cabinet.
5. (*Optional*) Place a level on top of the cabinet (see **Figure 20**) and adjust it level from front-to-back and side-to-side by shimming it.



Figure 20. Leveling cabinet.

Sanding Unit Assembly

To assemble the sanding unit:

1. With the help of an assistant, lift the headstock onto the stand (G1014Z) or the cabinet (G1014ZX), and align the mounting holes in the sander unit and the stand or cabinet.

Note: To access the top mounting holes inside the G1014ZX cabinet stand, open the front door.

Tip: Insert the end of the included 4mm hex wrench through the mounting holes in the sanding unit and the stand or cabinet, then jiggle the wrench back and forth to align the mounting holes.

2. Secure the sanding unit to the stand or cabinet with the (4) $\frac{5}{16}$ "-18 hex bolts and $\frac{5}{16}$ " flat washers, as shown in **Figures 21 & 22**.

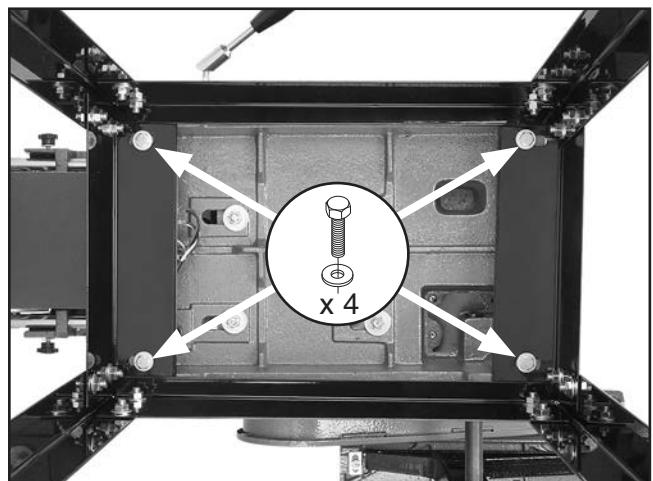


Figure 21. G1014Z sander fastened to stand (view from underneath stand).



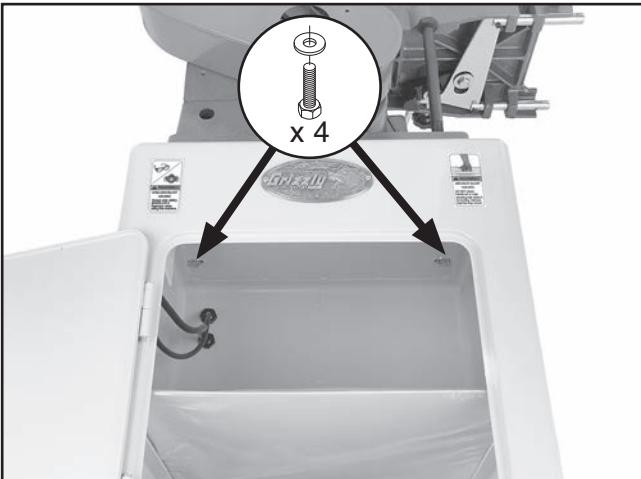


Figure 22. G1014ZX sander fastened to cabinet (two of four hex bolts shown).

3. Slide the flat ends of the idler roller into the slots on the roller adjustment bars (see **Figure 23**).
4. Install (1) $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " thumb knob and (1) $\frac{1}{4}$ " flat washer onto each side of sander behind idler roller (see **Figure 23**).

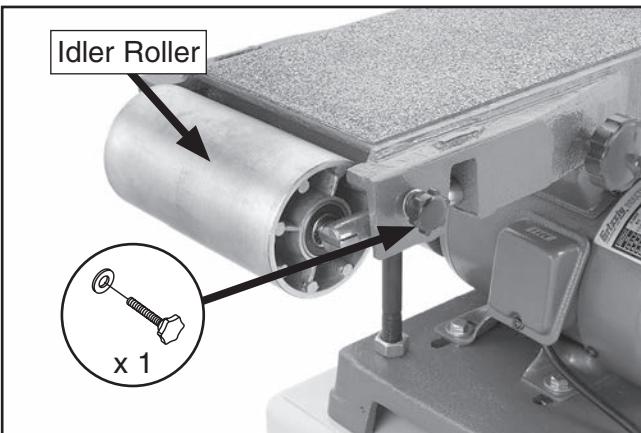


Figure 23. Idler roller installed.

5. Use the 4mm hex wrench to back the shaft set screws on the cast iron plate out of the shaft hole and keyway (see **Figure 24**).

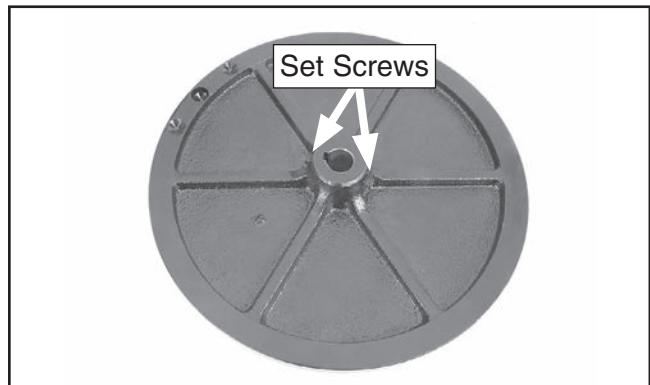


Figure 24. Set screw locations on sanding disc plate.

6. Align the keyway on the plate with the drive shaft key, then slide the plate onto the shaft, as shown in **Figure 25**.

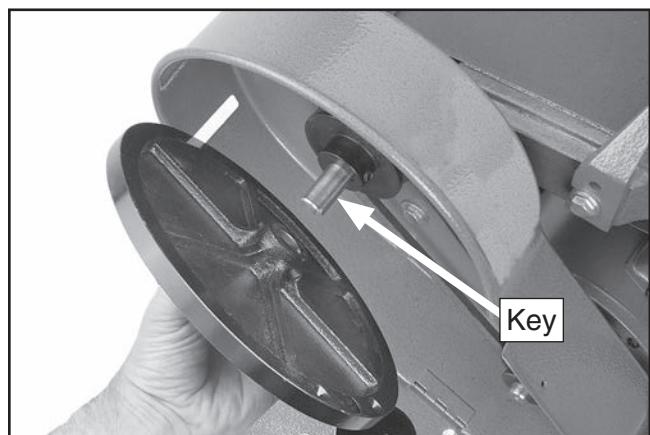


Figure 25. Installing plate onto drive shaft.

7. Adjust the cast iron plate so it protrudes slightly ($\frac{1}{16}$ "- $\frac{1}{8}$ ") beyond the curved lip of the metal cover on both sides, as illustrated in **Figure 26**, to avoid the possibility of workpieces hitting the cover during sanding operations.

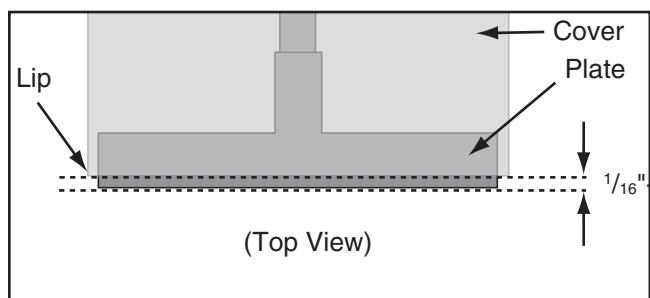


Figure 26. Gap between plate and cover.



8. While looking through the access hole on the side of the cover, rotate the plate and tighten each of the set screws to secure the plate to the drive shaft (see **Figure 27**).

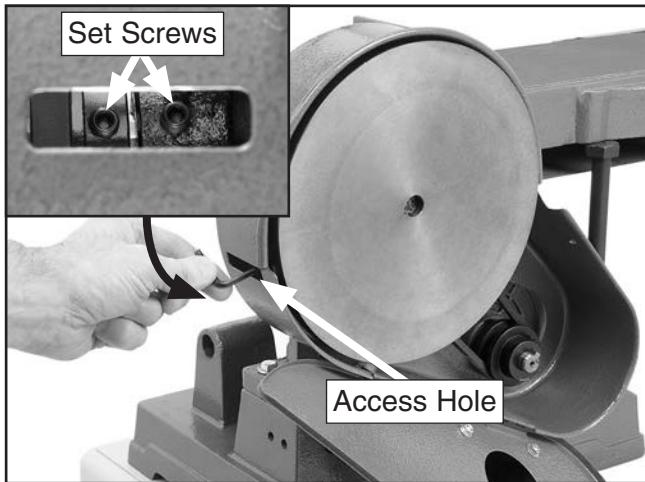


Figure 27. Securing plate to drive shaft.

9. Peel off the backing on the 9" PSA (pressure sensitive adhesive) sanding disc, make sure the cast iron plate is clean, and install the sanding disc onto the plate, as shown in **Figure 28**. Make sure the sanding disc adheres completely flat against the plate.



Figure 28. Installing sanding disc onto cast iron plate.

10. Install the 2½" black plastic dust port onto the pulley cover with the (4) #10-24 Phillips head screws, #10-24 hex nuts and #10 flat washers, as shown in **Figure 29**.

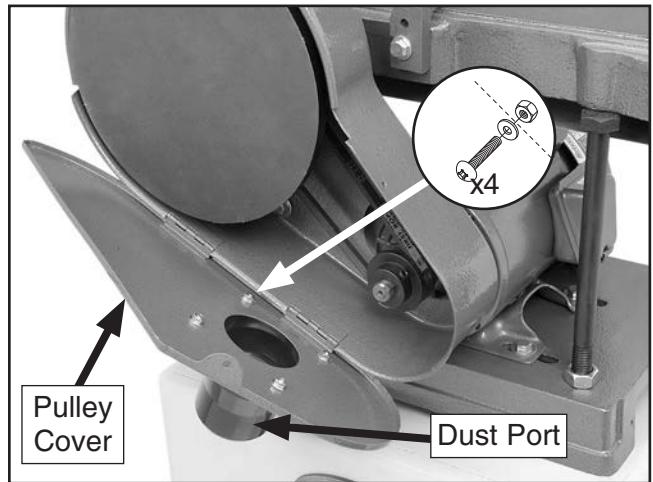


Figure 29. 2½" dust port installed.

11. Secure the pulley cover with the thumb knob.
12. Loosen the two set screws on the back of the base, slide the table support rod into the shaft, making sure the flat of the shaft faces the set screws, then tighten the set screws, as shown in **Figure 30**. The rod should protrude about 6¼" from the side of the base.

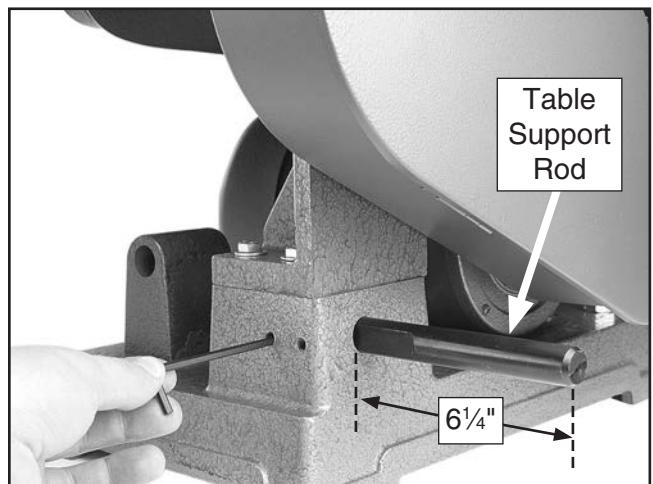


Figure 30. Installing table support rod.

- 13.** Loosen the two set screws on the work table arm so their ends are flush with the inside of the opening, as shown in **Figure 31**.

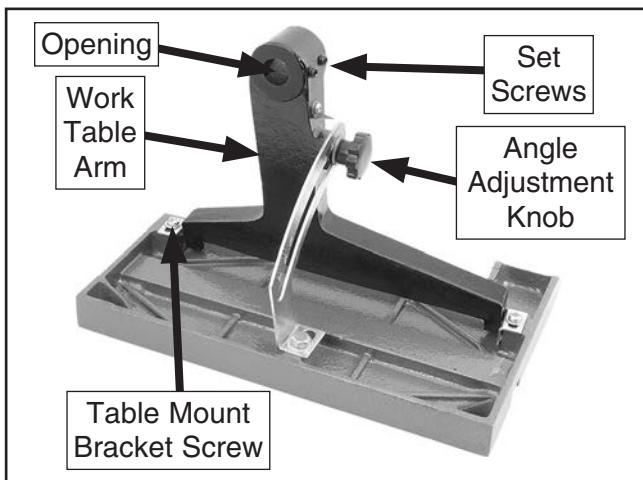


Figure 31. Location of set screws on work table arm.

- 14.** Loosen the angle adjustment knob on the work table (see **Figure 31**), tilt the table to the 0° mark, then tighten the knob.
- 15.** Slide the work table arm onto the table support rod, making sure that the set screws on the table arm face the flat part of the rod, as shown in **Figure 32**.



Figure 32. Installing work table onto table support rod.

- 16.** Using a ruler adjust the edge of the work table approximately $\frac{1}{16}$ " away from the sanding disc on both sides (see **Figure 33**), then tighten the set screws on the work table arm.

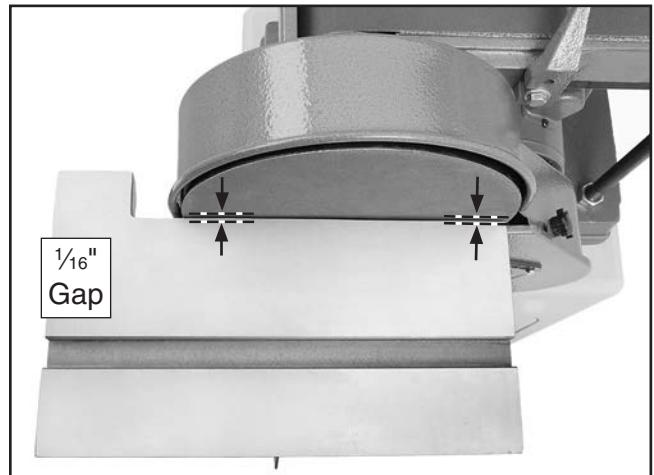


Figure 33. Correct distance between disc and work table.

—If the gap between the work table and the sanding disc is not the same on both sides, loosen one of the table mount bracket screws (see **Figure 31**), adjust the table as needed to even the gap, then tighten the screw.

! CAUTION

To reduce the risk of your fingers getting stuck between the work table and sanding disc, set the table approximately $\frac{1}{16}$ " away from the sanding disc.

- 17.** Square the table to the sanding disc (refer to instructions on **Page 48** for more details).
- 18.** Adjust the miter gauge slot parallel with the sanding disc (refer to instructions on **Page 49** for more details), then insert the miter gauge.

- 19.** Install the 2" dust port onto the back of the sanding belt frame with the pre-installed 1/4"-20 x 1/2" hex bolts and flat washers, as shown in **Figure 34**.

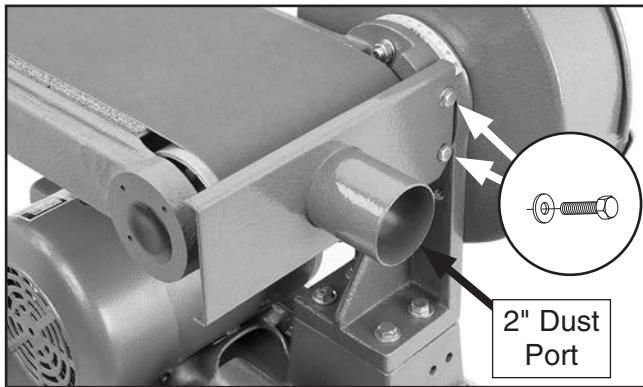


Figure 34. 2" dust port installed.

- 20.** Assemble the quick release lever, as shown in **Figure 35**, using the handle, 6" quick release lever stud, short lever arm, and 3/8"-16 hex nuts, thread the assembly into the rocker arm, then tighten the hex nuts.

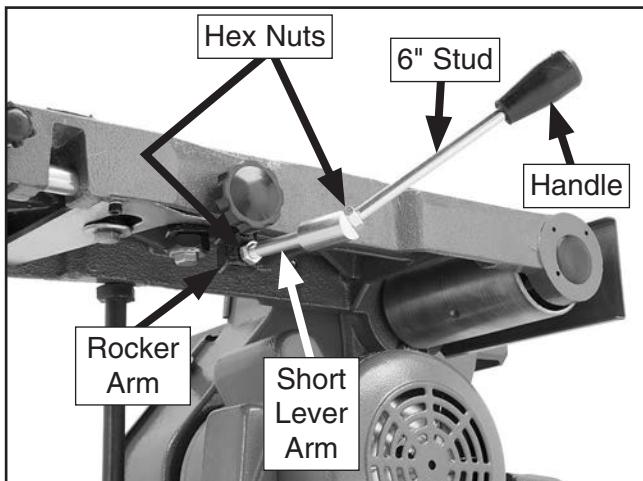


Figure 35. Quick release lever installed.

- 21.** Move the quick release lever toward the motor, slide the sanding belt over the lever and onto the idler roller and drive rollers, then center the belt on the rollers (see **Figure 36**).

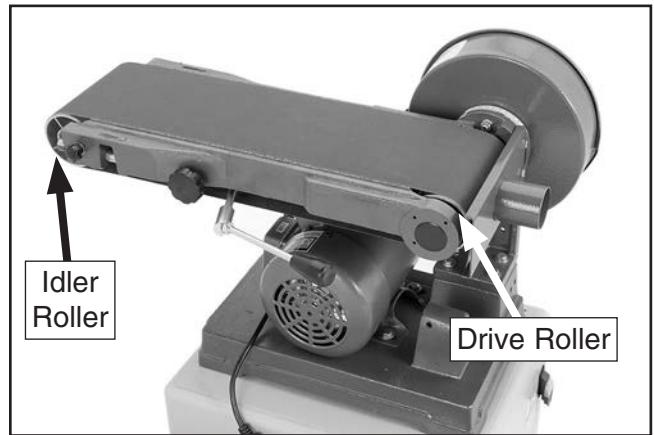


Figure 36. Belt installed onto idler and drive rollers.

- 22.** Push the lever toward the motor to tension the sanding belt.
- 23.** Assemble idler roller guard with (2) M5-8 x 10 thumb knobs, (2) #10 lock washers, and (2) #10 flat washers. Then loosen thumb knobs behind idler roller, and install idler roller assembly (see **Figure 37**).

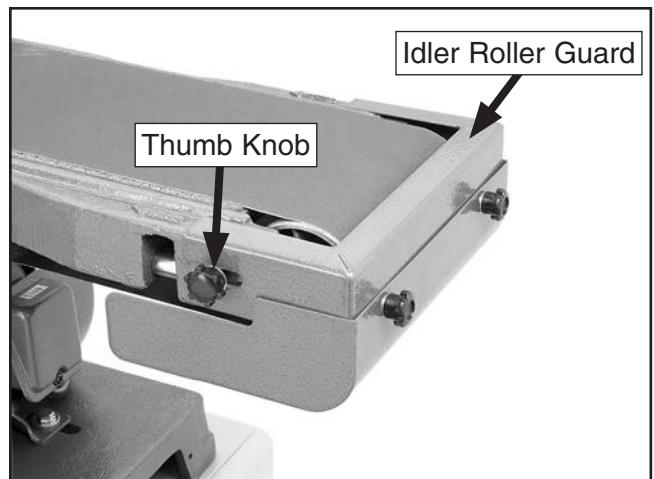


Figure 37. Idler roller guard installed.

- 24.** Adjust the inside edge of the idler roller guard $\frac{1}{4}$ - $\frac{1}{2}$ " away from the sanding belt (see **Figure 38**).

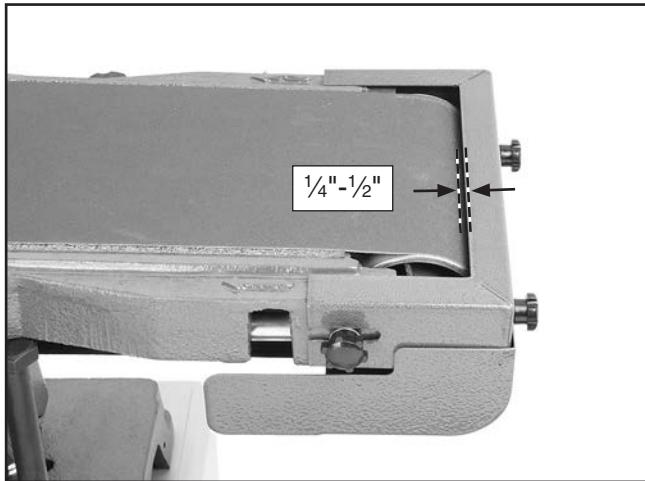


Figure 38. Correct distance between belt and idler guard. Measuring distance (inset).

- 25.** Rotate the sanding belt just enough to verify that the belt does not catch on or rub against the ends of the thumb screws on the sleeve guard.
- 26.** Tighten the thumb knobs located behind the idler roller to secure the guard.
- 27. G1014ZX Only:** Connect the motor cord to the power cord on the cabinet (see **Figure 39**). DO NOT connect the sander to the power until indicated in the **Test Run** section on **Page 29**.

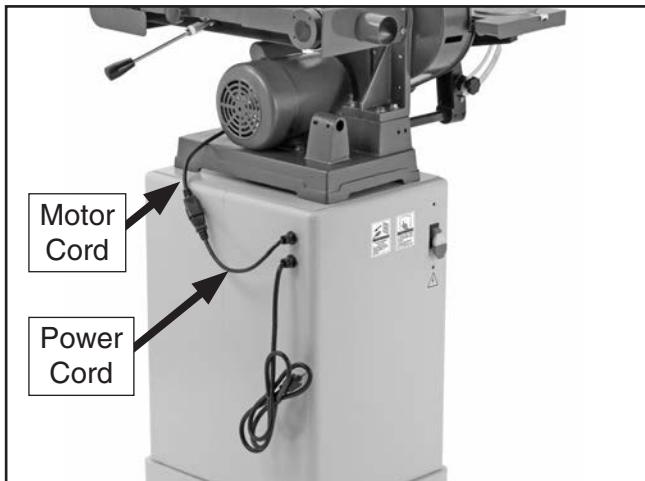


Figure 39. Motor cord connected to power cord.

- 28.** At this point, decide if you want to set up the sanding belt horizontally as in **Step 28**, or follow the instructions on **Page 36** to set up the sanding belt vertically.

- 29.** Loosen the pre-installed $\frac{5}{16}$ "-18 x 1" hex bolt and flat washer on the side of the sanding belt frame, slide the backstop groove onto the bolt, then finger tighten the bolt.

- 30.** Place a square flat against the sanding belt and back stop (see **Figure 40**) adjust the backstop flush with the square on both sides of the belt and $\frac{1}{8}$ " above the belt (see **Figure 41**), then tighten the hex bolt.

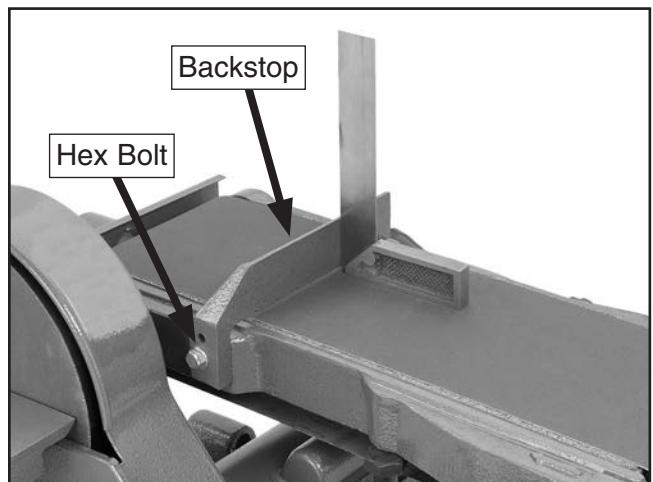


Figure 40. Adjusting backstop square with belt.

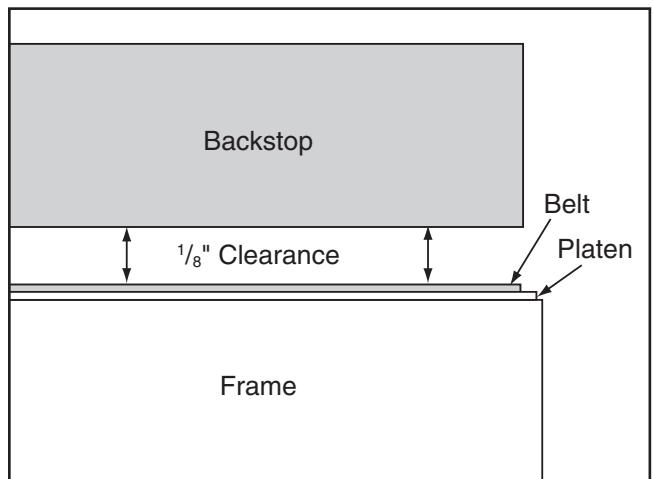


Figure 41. Correct clearance between backstop and belt.

Calibrating Miter Gauge

The miter gauge needs to be calibrated to the sanding disc when it is first mounted in the miter slot.

To calibrate the miter gauge:

1. Place one edge of a machinist's square against the face of the miter gauge and the other against the sanding disc (see **Figure 42**) or sanding belt.

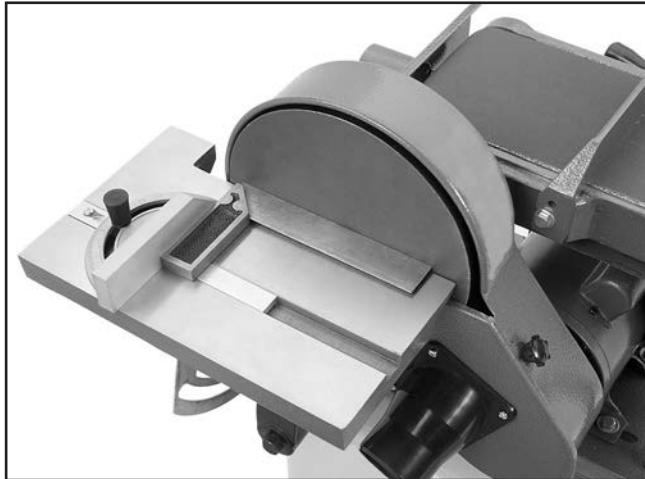


Figure 42. Calibrating miter gauge with square.

2. Loosen the lock knob on the miter gauge and adjust it flush with the edge of the square.
3. Tighten the lock knob and verify the setting.

Note: Sometimes the tightening procedure can affect the adjustment.

4. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.
5. Retighten the screw that secures the angle pointer.
6. Repeat **Steps 1–5** in a similar manner to calibrate the miter gauge to the belt if you set up the sander for vertical sanding.

Pre-Tracking Belt

You must perform the following procedure before the test run to ensure that the belt does not come off or get jammed against the sanding belt frame.

To pre-track the belt:

1. DISCONNECT SANDER FROM POWER!
2. Loosen the lock nut on the tracking control knob (see **Figure 51** on **Page 31**), then move the quick release tension lever to the tensioned position.

CAUTION

Fingers or other body parts can be quickly injured if they touch moving sanding surfaces. To reduce the risk of injury, wear gloves during the next step.

3. Standing in front of the sander, push the sanding belt multiple times along the platen, so that it moves in the direction of operation (clockwise on the rollers), then watch how the belt tracks on the rollers.
4. Adjust the tracking with the tracking control knob and continue to rotate the belt by hand until the sanding belt is centered on the main roller, as shown in **Figure 43**.

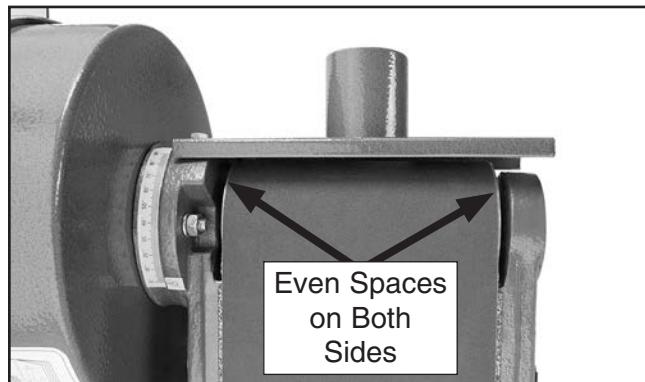


Figure 43. Example of sanding belt centered on main roller.

5. Tighten the tracking control knob lock nut.

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.

Recommended CFM at 2" Dust Port: 100

Recommended CFM at 2½" Dust Port: 150

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.

The Model G1014Z/G1014ZX features a 2" dust port and a 2½" dust port that can be connected to a dust collector or a dust collection system, using the components shown in **Figure 44**.

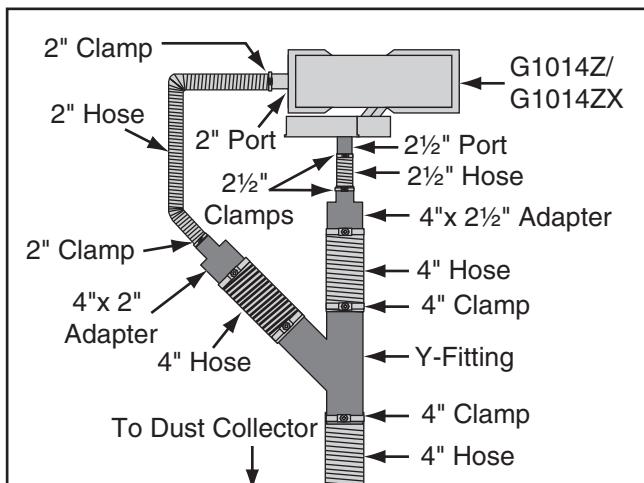


Figure 44. Sander hooked up to 4" hose.

Figure 45 shows a 2" dust hose connected to the dust collection port with a hose clamp.

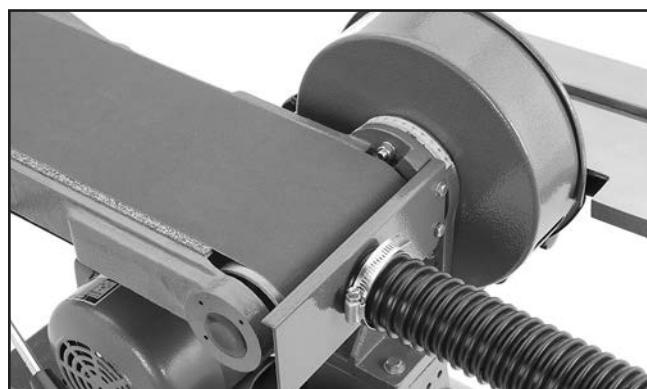


Figure 45. Hose attached to 2" dust port.

Note: A tight fit is necessary for proper performance.

Figure 46 shows a 2½" dust hose attached to the dust port with a hose clamp. After installing the dust hoses on the two ports, tug the hoses to make sure they do not come off.

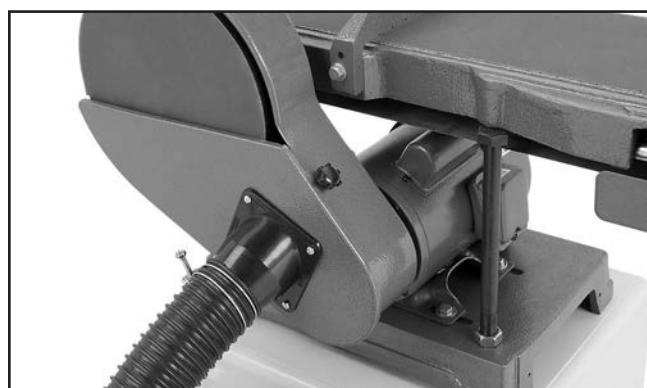


Figure 46. Hose attached to 2½" dust port.

You can also attach a wet/dry vacuum with a 2¼" outside diameter hose to the sander. The hose will slide into the 2½" dust port or fit over the 2" dust port.



Test Run

Test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following:
1) The motor powers up and runs correctly, and
2) the safety disabling mechanism on the switch works correctly.

You must perform the pre-tracking procedure on **Page 27** before starting the sander to ensure that the belt does not come off of the rollers or jam against the sander during startup.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 44**. 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 set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Make sure the belt is properly pre-tracked (refer to **Pre-Tracking Belt** on **Page 27**).
4. Tie back loose clothing and long hair to protect yourself from getting caught in the moving sanding belt when you start the sander.
5. Connect the machine to the power source.
6. Verify that the machine is operating correctly by turning it **ON**. Be ready to turn it **OFF** if it tracks over the sanding belt frame edge.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

CAUTION

Moving sanding belts are dangerously abrasive. Use extreme caution when working near sanding surfaces.

7. Loosen the lock nut on the tracking control knob, and carefully adjust the tracking in small increments toward the front or back of the sander frame until the sanding belt remains centered on the main roller (see **Figure 43, Page 27**).
8. When the tracking is correct, allow the sander to run for approximately one minute to verify that the tracking stays in the correct position.
9. Repeat **Steps 7–8** if the tracking does not stay correct, otherwise proceed to **Step 10**.
10. When the sanding belt is tracking correctly, tighten the lock nut on the tracking control knob.
11. Turn the machine **OFF**, and remove the switch disabling key, as shown in **Figure 47**.

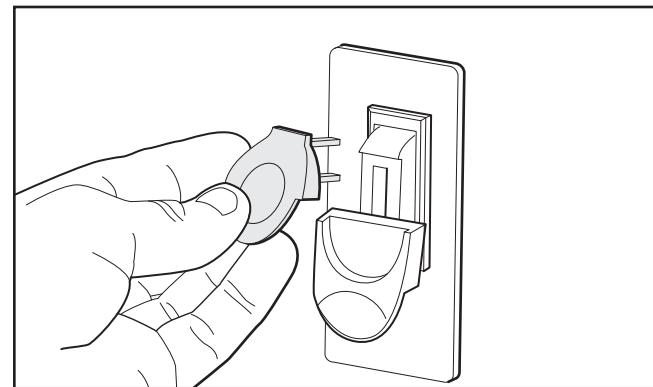
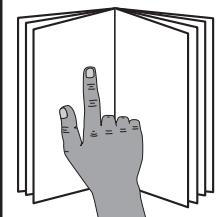


Figure 47. Removing switch key from paddle switch.

12. Try to turn the start the sander with the paddle switch.
 - If the sander does not start, the switch disabling feature is working as designed.
 - If the sander starts, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.



SECTION 4: OPERATIONS

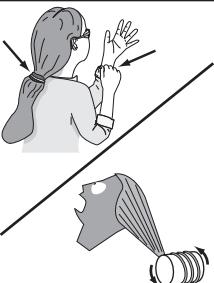


WARNING

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

WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



WARNING

Keep hair, clothing, and jewelry away from moving parts at all times. Entanglement can result in death, amputation, or severe crushing injuries!

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.

Basic Controls

Refer to Figures 48–52 and the following descriptions to become familiar with the basic controls of this machine.

Paddle Switch: Turns the motor **ON** when flipped up; turns motor **OFF** when pressed down (see Figure 49).

Switch Disabling Key: Disables switch when the yellow key is removed.

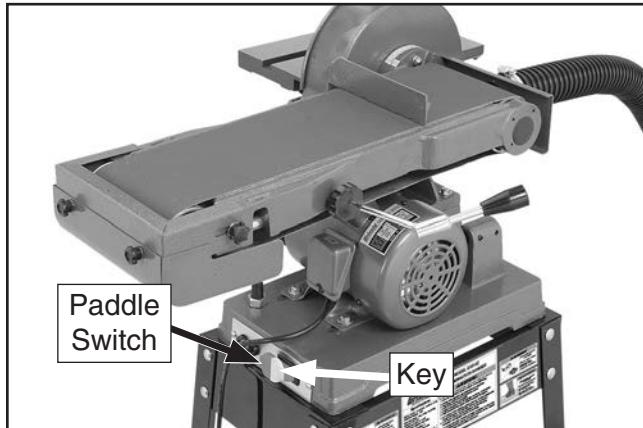


Figure 48. Paddle switch location on G1014Z.

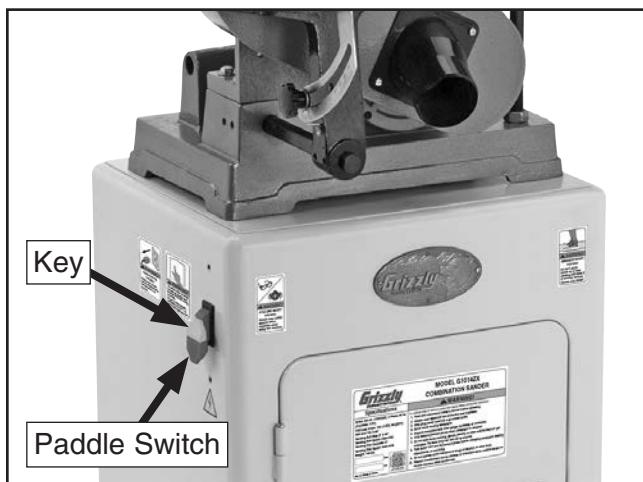


Figure 49. Paddle switch location on G1014ZX.



Table Tilt: Use to tilt the table relative to the sanding disc or the sanding belt. To tilt the table, loosen the table tilt lock knob (see **Figure 50**), tilt the work table to the desired angle, then retighten the lock knob.

The work table should be set approximately $\frac{1}{16}$ " away from the sanding disc or sanding belt to prevent fingers or workpieces from getting caught. To adjust the work table relative to the sanding disc, refer to **Step 16 in Sanding Unit Assembly on Page 24**. To adjust the work table relative to the belt, refer to **Step 9 in Setting up Sander for Vertical Sanding on Page 37**.

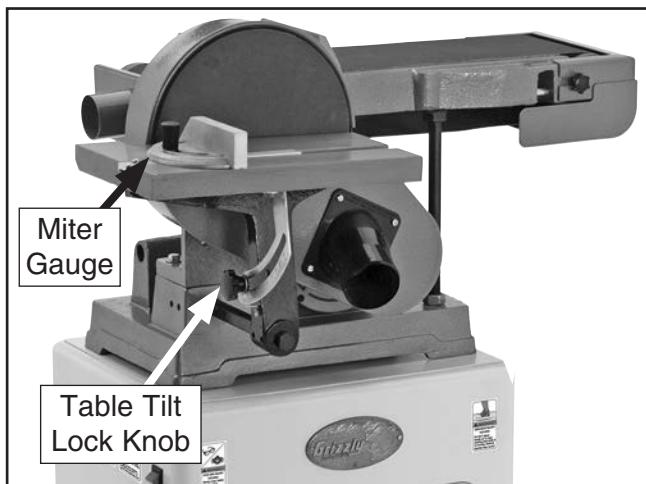


Figure 50. Table tilt controls.

Miter Gauge: Use to move workpieces into the sanding disc (horizontal sanding) or belt (vertical sanding) at a specific angle. To use the miter gauge (see **Figure 50**), slide it into the miter slot, loosen the lock knob, set the angle, then tighten the knob.

Belt Tracking and Tension: The quick release tension lever (see **Figure 51**) tensions the belt. To tension the sanding belt, move the quick release tension lever toward the motor.

The tracking control knob keeps the belt in the center of the idler and drive rollers. To adjust the belt tracking, loosen the lock nut on the tracking control knob. Turn the motor **ON**, adjust the tracking in small increments with the knob, then tighten the lock nut to secure the knob. (Refer to **Tracking Belt** on **Page 40** for more details.)

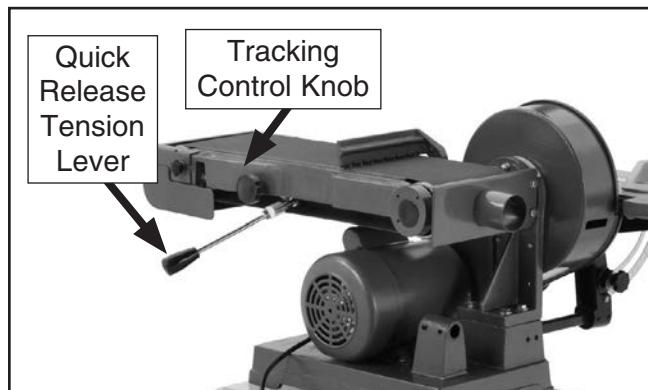


Figure 51. Belt tracking and tension controls.

Vertical Tilt and Work Table Position:

The sanding belt frame can be tilted to the vertical position (see **Figure 52**) and the work table can be moved behind the motor to support workpieces during vertical sanding. (See **Vertical Sanding** on **Page 36** for more detail.)



Figure 52. Model G1014ZX set up for vertical sanding.

Operation Overview

This combination sander removes surface material from the edges, ends, and faces of wood stock using an abrasive belt and disc. A graphite coated platen on the sanding belt frame provides a flat support surface for the sanding belt and workpiece.

The abrasive belt revolves around a pair of metal rollers, one of which is driven by the motor. The adhesive-backed abrasive disc is attached to a cast iron disc, which revolves in a counterclockwise direction.

During a typical operation, the sander is turned **ON**, and while holding the workpiece with both hands, the operator gradually eases the workpiece into the belt or the left side of the sanding disc.



Sanding Tips

- Replace the sandpaper with a higher grit to achieve a finer finish.
- Extend the life of the sandpaper by regularly using PRO-STIK® abrasive belt cleaners (see **Accessories** on Page 41).
- When sanding workpieces with a bow or crown, place the high point up on the table (prevents the workpiece from rocking) and take very light passes.

Choosing Sandpaper

The Model G1014Z/G1014ZX uses a 6" x 48" sanding belt and a 9" sanding disc.

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
36	Extra Coarse
60	Coarse
80–100	Medium
120–180	Fine

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

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

Stock Inspection and Requirements

Some workpieces are not safe or may require modification before they are safe to sand. **Before sanding, inspect all workpieces for the following:**

- **Material Type:** This machine is intended for ONLY sanding natural and man-made wood products. This machine is NOT designed to sand metal, glass, stone, tile, drywall or cementitious backerboard.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear the sanding belt. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT sand the workpiece.
- **Excessive glue or finish:** Sanding workpieces with excess glue or finish will load up the abrasive, reducing its usefulness and lifespan.
- **Workpiece Dimensions:** DO NOT sand boards less than 9" long, $\frac{1}{8}$ " wide and $\frac{1}{16}$ " thick to prevent damage to the workpiece to reduce the risk of your hands contacting the abrasive belt (see **Figure 53**).

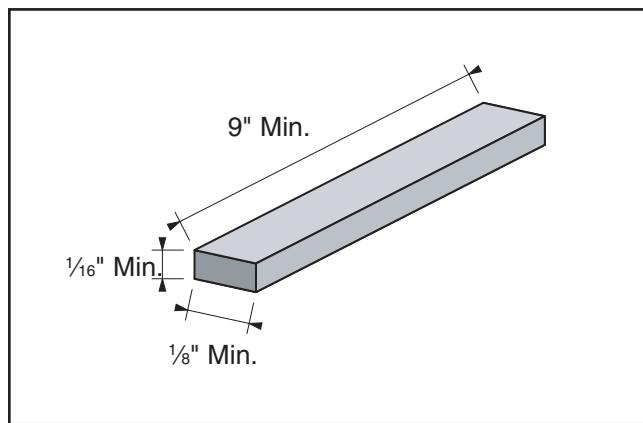


Figure 53. Minimum dimensions for sanding.



Horizontal & Edge Sanding

If the sanding belt frame is in the vertical position, proceed to "Setting Up Sander for Horizontal and Edge Sanding" below to setup the sander for horizontal sanding. If the sander is already in the horizontal position, skip ahead to "Performing Horizontal Sanding and Edge Sanding."

Setting Up Sander for Horizontal Sanding

1. Loosen the set screws that secure the work table support rod to the mounting bracket behind the motor, then remove the work table assembly (see **Figure 54**).



Figure 54. Location for removing work table assembly.

2. Loosen the sanding frame rotation lock nuts (behind the sanding disc cover), rotate the frame to the horizontal position, as shown in **Figure 55**, then tighten the rotation lock nuts.

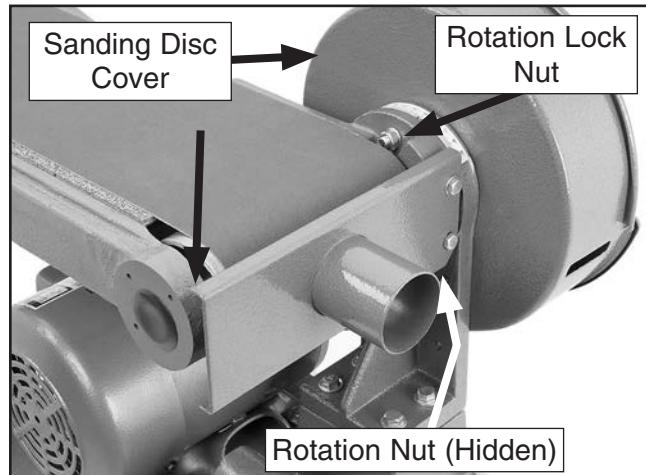


Figure 55. Table tilted to horizontal position.

3. Insert the table support rod into the hole in the base under the sanding disc, and position the work table $\frac{1}{16}$ " away from the sanding disc, as shown in **Figures 32–33 on Page 24**.
4. Check that the miter gauge slot-sanding disc distance is correct (see instructions on **Page 49** for further detail).
5. Re-install the backstop so it is square with and $\frac{1}{8}$ " above the sanding belt (see **Figure 40 on Page 26**).

Performing Horizontal or Edge Sanding

1. Make sure the sanding belt is tensioned—if it is not already tight.
2. Make sure the belt tracking is correctly set (see **Tracking Belt on Page 40**).
3. Turn the sander **ON**.

- While holding the back end of the workpiece against the backstop with both hands, and while keeping your fingers away from the belt, slowly feed the workpiece into the belt, as shown in **Figures 56 & 57**.

Note: *Apply even pressure and move the workpiece back and forth across the sanding belt.*



Figure 56. Sanding workpiece in horizontal position.



Figure 57. Sanding edge of workpiece in horizontal position.

⚠️WARNING

Sanding surfaces can cause serious personal injury if they come in contact with fingers, hands or other body parts. Use extreme care to provide a safe distance between the belt and any part of your body.

Contour Sanding

To perform contour sanding:

- Make sure the sanding belt is tensioned—if it is not already tight.
- Make sure the belt tracking is correctly set (see **Tracking Belt on Page 40**).
- Loosen the knobs that secure the idler roller guard and sleeve guard assembly, then remove the guard.
- Turn the sander **ON**.

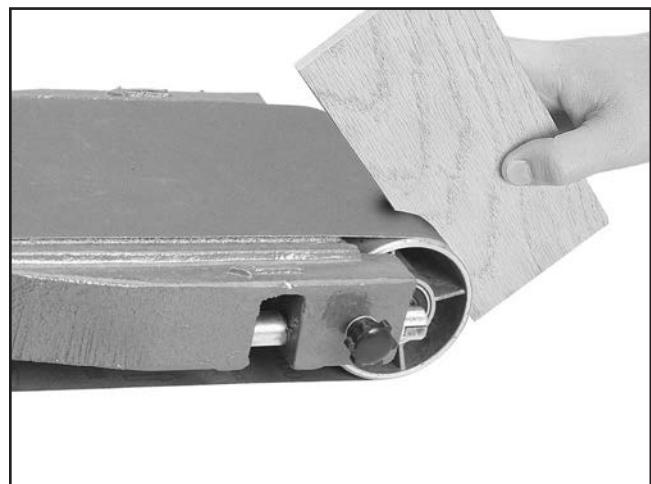


Figure 58. Example of contour sanding.

- Slowly feed the workpiece into the curved end of the belt and continue moving the workpiece profile along the contour until you achieve your desired shape, as shown in **Figure 58**.

⚠️WARNING

Do not operate this equipment when wearing loose clothing, gloves, neckties, rings, bracelets or other jewelry that might get caught in the moving belt. Serious personal injury may result. You must re-install the idler roller and sleeve guard before performing edge or horizontal sanding operations.

- Re-install the idler roller and sleeve guard.

Disc Sanding

The sanding disc can be used to smooth the ends of workpieces.

! CAUTION

To reduce the risk of your fingers getting trapped between the work table and sanding disc, make sure the table is approximately $\frac{1}{16}$ " away from the sanding disc.

! CAUTION

Always keep the workpiece on the left side of the wheel that rotates down toward the work table. This will keep the workpiece from flying out of your hands due to kick-back.

To use the sanding disc:

1. DISCONNECT SANDER FROM POWER!
2. Adjust the angles of the work table and the miter gauge for your operation.
3. Connect the sander to power, turn it **ON**, and allow it to reach full speed.
4. Place the workpiece on the work table and firmly against the miter gauge.
5. With light pressure, slowly move the workpiece into the left side of the sanding disc. See **Figures 59–62** for examples of disc sanding.



Figure 59. Example of 90° disc sanding.



Figure 60. Example of miter sanding.

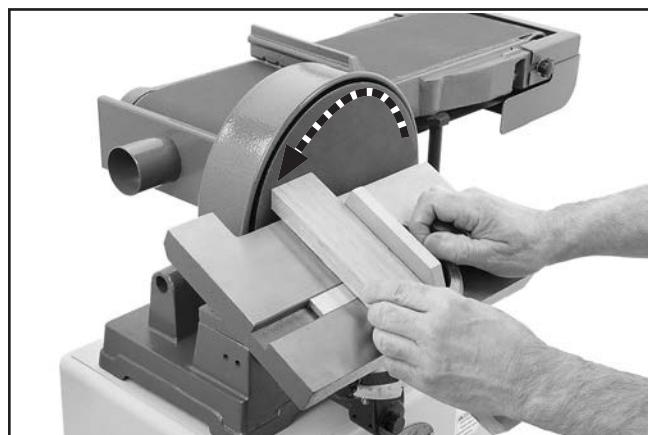


Figure 61. Example of angle sanding.



Figure 62. Example of sanding round workpiece.

Note: To prevent burning the workpiece and overloading the sanding disc, move the workpiece slowly back and forth from the left side of the sanding disc to the center.

Vertical Sanding

If the sanding belt frame is in the horizontal position, proceed to **Setting up Sander for Vertical Sanding**. If the sander is already in the vertical position, skip to **Performing Vertical Sanding on Page 38**.

Setting up Sander for Vertical Sanding

1. Make sure the sanding belt is tensioned—if it is not already tight.
2. Make sure the belt tracking is correctly set (see **Tracking Belt on Page 40**).
3. DISCONNECT SANDER FROM POWER!
4. Remove the backstop and miter gauge from the work table.
5. Loosen the sanding frame rotation lock nuts (behind the sanding disc cover) as shown in **Figures 63 & 64**.

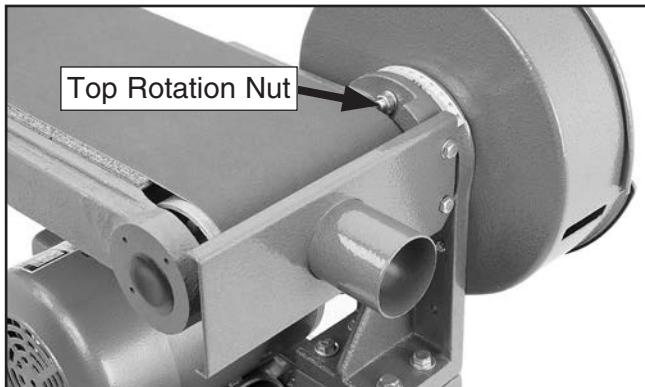


Figure 63. Location of top rotation lock nut.

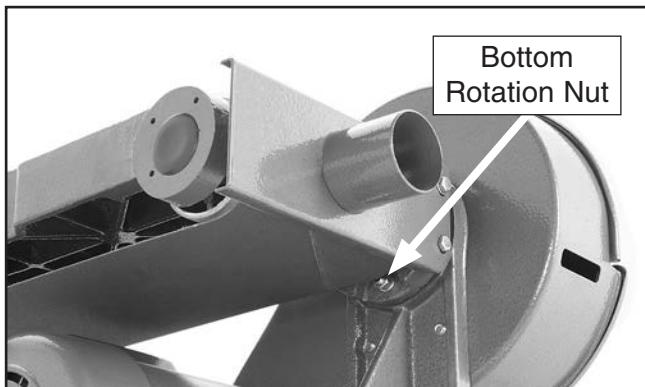


Figure 64. Location of bottom rotation lock nut.

6. Raise the sanding belt frame until it reaches the 90° mark (or the desired angle) on the tilt scale, as shown in **Figure 65**, then tighten the rotation lock nuts.

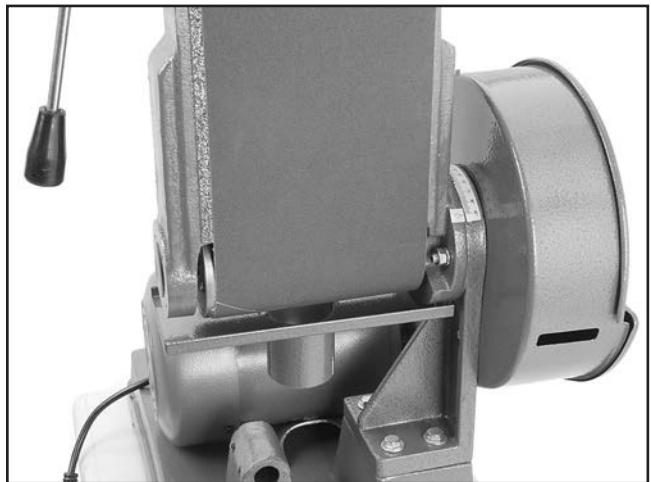


Figure 65. Sanding belt tilted to 90° position.

7. Loosen the set screws that secure the table support rod under the sanding disc, then remove the support rod and work table assembly.
8. Loosen the set screws on the mounting bracket behind the motor, then slide the support rod and work table assembly into the bracket hole, as shown in **Figure 66**.

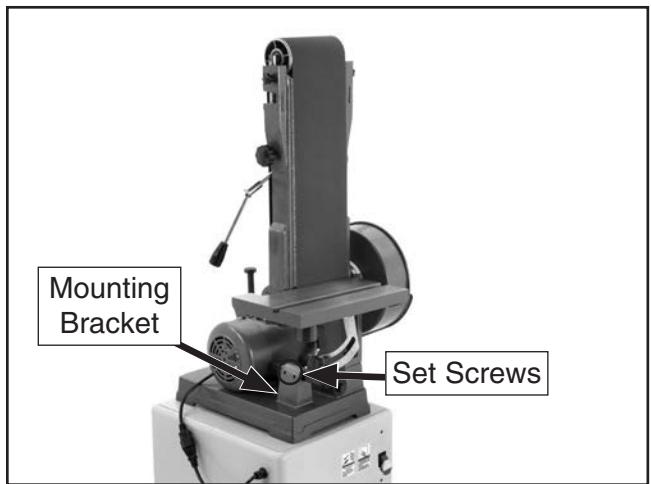


Figure 66. Work table installed for vertical sanding.



9. Adjust the front of the work table $\frac{1}{16}$ " away from the sanding belt (see **Figure 67**) across its entire length.

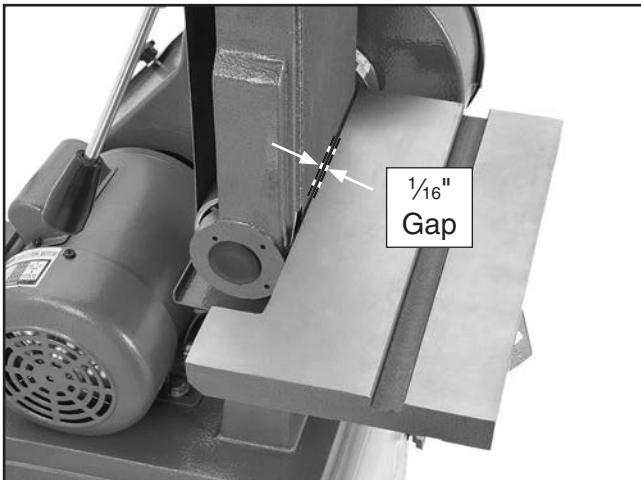


Figure 67. Correct distance between work table and sanding belt.

—If the gap is not $\frac{1}{16}$ " across the entire length of the work table, loosen one or both of the screws under the table (see **Figure 68**), where the arm is attached to the table, and adjust the table until the distance is correct, then tighten the screws.

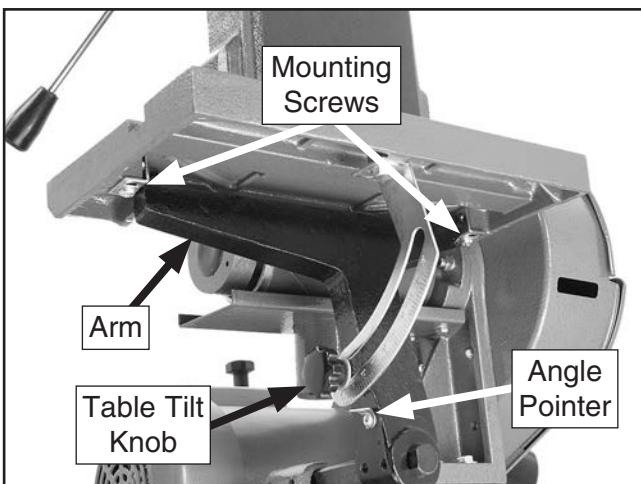


Figure 68. Location of work table arm mounting screws.

Note: To reduce the chance of vibration or rattling sounds, make sure the table support rod does not touch the motor.

10. Tighten the mounting bracket set screws to secure the support rod.

11. Place a machinist's square on the work table and against the sanding belt, as shown in **Figure 69**, and check for gaps between the square, belt, and table.



Figure 69. Squaring table and sanding belt.

—If there are any gaps, loosen the table tilt knob, adjust the table as needed to remove the gaps, then tighten the knob. Loosen the angle pointer screw, position the pointer over the zero mark on the scale, then tighten the screw.

12. Use a fine ruler or combination square to check if the distance from the slot to the belt is the same at both edges of the belt.

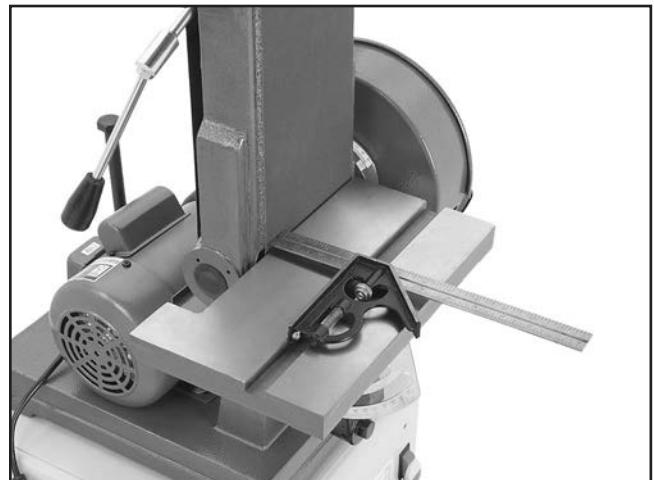


Figure 70. Checking miter slot-belt distance.

—If the distance is the same, no adjustments need to be made.

—If the distance is not the same from side-to-side, loosen the screws that secure the work table arm to the work table. Then adjust the table until the miter slot-belt distance is even side-to-side and the table is approximately $\frac{1}{16}$ " away from the belt across its entire length.

13. Insert the miter gauge into the left side of the miter slot.

Performing Vertical Sanding

1. Adjust the angles of the work table and miter gauge for your operation.
2. Place the workpiece on the table and firmly against the miter gauge.
3. Slowly and with light pressure, move the workpiece into the left side of the sanding belt. See **Figures 71–74** for examples of horizontal belt sanding.



Figure 71. Example of end grain sanding.

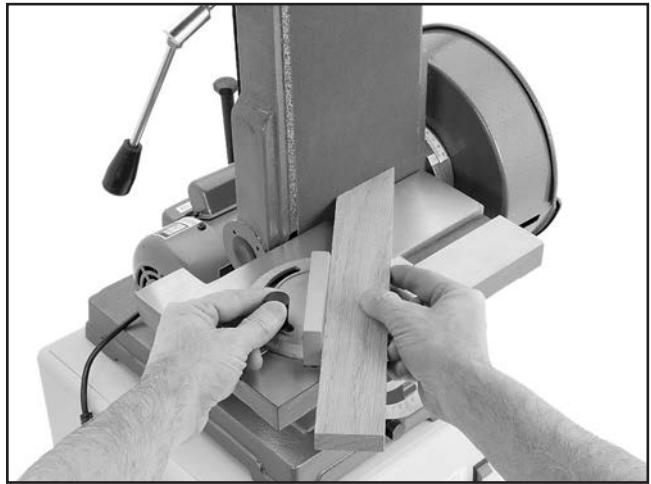


Figure 72. Example of vertical miter sanding.



Figure 73. Example of vertical face and edge sanding.

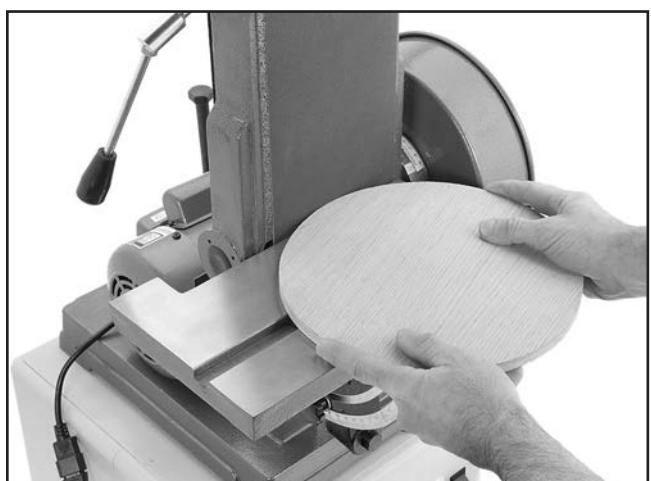


Figure 74. Example of sanding round workpiece in vertical position.

Changing 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 G1014Z/G1014ZX is designed so that the sanding belt travels clockwise as viewed from the side with the quick release tension lever.

To change the sanding belt:

1. DISCONNECT SANDER FROM POWER!
2. Move the quick release lever away from the motor to release the belt tension.
3. Remove the idler roller guard and back stop.
4. Remove the belt from the rollers and sanding belt frame.
5. Install a new sanding belt onto the idler and drive rollers, making sure the arrows on the bottom of the belt face the front of the sander, as shown in **Figure 75**.

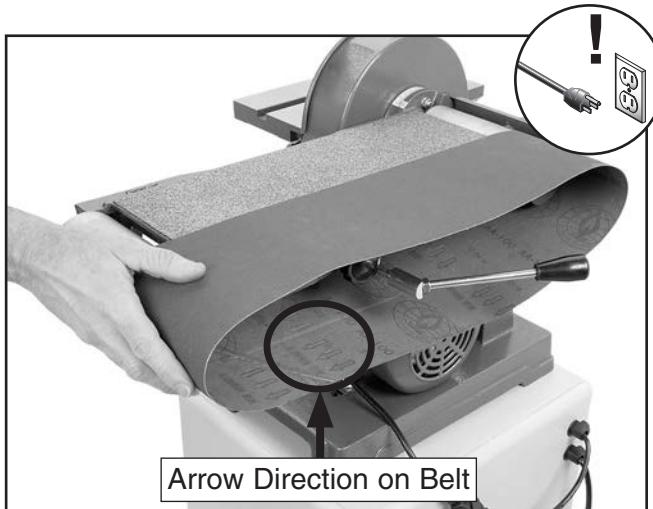


Figure 75. Installing new sanding belt.

6. Position the belt in the center of the roller, then move the quick release tension lever toward the motor to tension the belt (see **Figure 76**).

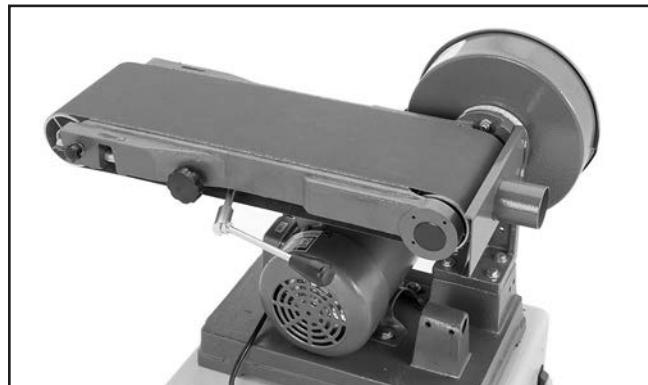


Figure 76. New belt installed.

7. Re-install the back stop.
8. Perform the belt pre-tracking procedure (refer to **Pre-Tracking Belt on Page 27**).
9. Perform the belt tracking procedure outlined below.

Tracking Belt

The aim of tracking the belt is to keep it centered on the rollers.

To track the belt:

1. Make sure the belt is properly pre-tracked (refer to **Pre-Tracking Belt on Page 27**).
2. Tie back loose clothing and long hair to protect yourself from getting caught in the moving sanding belt when you start the machine.
3. Move the quick release tension lever toward the back of the sander to tension the belt.
4. Loosen the lock nut on the belt tracking knob.
5. Turn the sander **ON**, and using the tracking control knob (see **Figure 77**), carefully adjust the tracking in or out until the sanding belt is centered on the main roller (see **Figure 43, Page 27**).

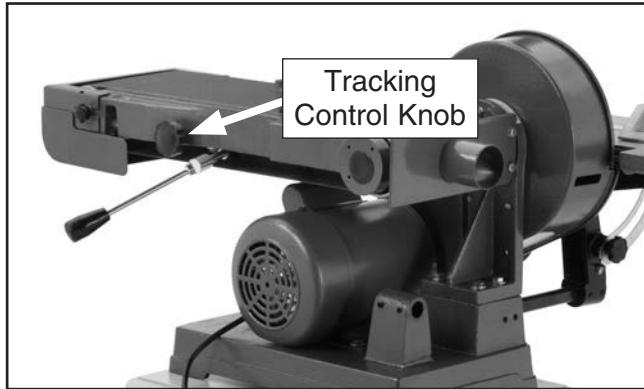


Figure 77. Tracking control knob.

Note: *The tracking control knob is very sensitive; adjust it carefully in small increments. Turning the knob clockwise moves the belt toward the front of the sander.*

6. Tighten the belt tracking knob lock nut.

Changing Sanding Disc

The model G1014Z/G1014ZX accepts 9" diameter paper-backed pressure sensitive adhesive (PSA) discs (refer to **Accessories on Page 41**).

To change the sanding disc:

1. DISCONNECT SANDER FROM POWER!
2. Remove the work table and miter gauge.
3. Unscrew the pulley cover thumb knob, open the cover, then remove the existing PSA disc.
4. Remove dried-on adhesive from the cast iron disc with acetone or lacquer thinner and a brush, then let it dry. **CAUTION:** *Follow the manufacturer's safety recommendations when using acetone or lacquer thinner.*
5. Peel off the backing from the new PSA disc, then press it onto the cast iron plate, making sure it contacts the surface evenly.
6. Close the pulley cover, re-install the lock knob, then re-install the work table and miter gauge.



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.

PRO-STIK® Abrasive Surface Cleaners

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

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



Figure 78. PRO-STIK® Abrasive Cleaners.

9" 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.....	D1321
80 Grit.....	D1322
100 Grit.....	D1323
120 Grit.....	D1324
150 Grit.....	D1325
180 Grit.....	D1326
220 Grit.....	D1327



Figure 79. 9" Sandpaper discs.

6" x 48" Aluminum Oxide Sanding Belts

Our aluminum oxide sanding belts are sized right for all of your belt sanding needs and are sold in packs of 10.

Grit	Model
60 Grit.....	H3515
80 Grit.....	H3516
100 Grit.....	H3517
120 Grit.....	H3518
150 Grit.....	H3519
180 Grit.....	H3520
220 Grit.....	H3521

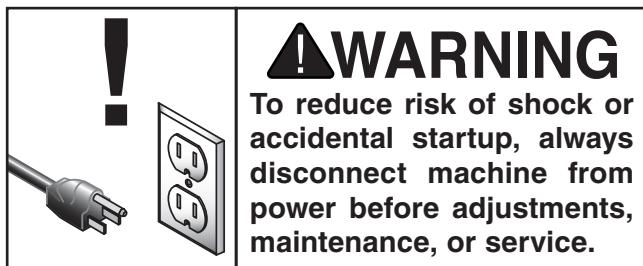


Figure 80. Assortment of sanding belts.

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



SECTION 6: MAINTENANCE



Schedule

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

Ongoing

- Loose mounting bolts.
- Worn or damaged sanding belt or disc.
- Worn or damaged wires.
- Wipe the work table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check

- Check and lubricate table support rod.
- V-belt tension, damage, or wear.
- Sanding belt tension.

Annually

- Check and lubricate rocker plate.

Lubrication

It is essential to clean the components before lubricating them, because dust and chips build up on lubricated components and make the components hard to move. Simply adding more grease to the components with built-up grime on them will not yield smooth moving components.

Cleaning & Protecting

Cleaning the Model G1014Z G1014ZX is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

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

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray

H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 81. Recommended products for protecting unpainted cast iron/steel parts on machinery.



Table Support Rod

Oil Type T23962 or ISO 68 Equivalent
Oil Amount..... Thin Coat
Lubrication Frequency Annually

Use a shop rag and mineral spirits to wipe away any built up grime and debris off of the table support rod, then brush on a thin coat of light machine oil onto the shaft (see **Figure 82**). Move the work table back and forth to distribute the oil.



Figure 82. Table support rod lubrication.

Rocker Plate

Oil Type NLGI#2 Grease
Oil Amount..... Dollop
Lubrication Frequency Annually

Clean the rocker plate with mineral spirits and a rag, and brush a dollop of grease onto the rocker plate. Move the quick release tension lever forward and backward to spread the grease (see **Figure 83**).

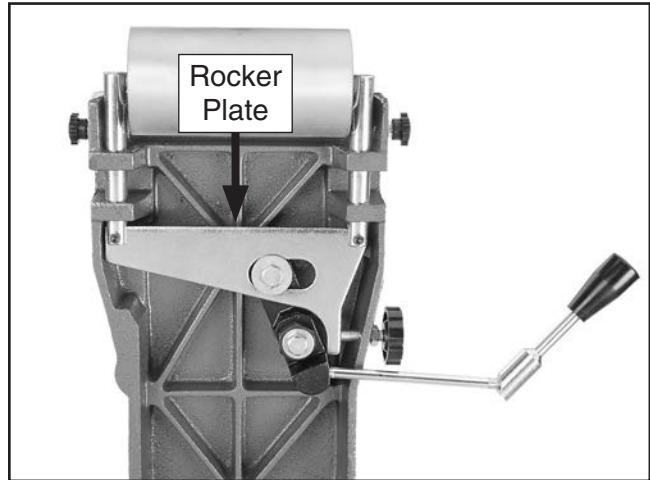
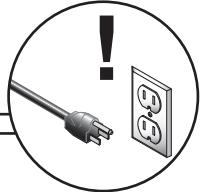


Figure 83. Rocker plate lubrication.

SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none">1. Switch disabling key removed.2. Motor cord not connected to power cord (G1014ZX only).3. Power supply switched OFF or at fault.4. Plug/receptacle at fault/wired wrong.5. Motor connection wired wrong.6. Wall circuit breaker tripped.7. Wiring open/has high resistance.8. Start capacitor at fault.9. Motor ON/OFF switch at fault.10. Motor at fault.	<ol style="list-style-type: none">1. Install switch disabling key.2. Connect motor cord to power cord (G1014ZX).3. Ensure power supply is on/has correct voltage.4. Test for good contacts; correct the wiring.5. Correct motor wiring connections.6. Ensure circuit size is correct/replace weak breaker.7. Check/fix broken, disconnected, or corroded wires.8. Test/replace if faulty.9. Replace switch.10. 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. Belt slipping.5. Motor wired incorrectly.6. Pulley slipping on shaft.7. Plug/receptacle at fault.8. Motor bearings at fault.9. Motor overheated.10. 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. Tension/replace belt; ensure pulleys are aligned.5. Wire motor correctly.6. Replace loose pulley/shaft.7. Test for good contacts/correct wiring.8. Test/repair/replace.9. Clean motor, let cool, and reduce workload.10. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none">1. Motor or component loose.2. V-belt worn or loose.3. Workpiece loose.4. Pulley loose.5. Incorrectly mounted to workbench.6. Motor fan rubbing on fan cover.7. Motor mount loose/broken.8. Sanding disc out of balance or loose.9. Motor bearings at fault.10. Work table support rod rubbing on motor.	<ol style="list-style-type: none">1. Inspect/replace damaged bolts/nuts, and re-tighten with thread locking fluid.2. Inspect/replace belt.3. Use the correct holding fixture and reclamp workpiece.4. Realign/replace shaft, pulley, setscrew, and key.5. Adjust feet, shim, or tighten mounting hardware.6. Fix/replace fan cover; replace loose/damaged fan.7. Tighten/replace.8. Tighten disc hub or replace disc.9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.10. Adjust table support rod.

Machine Operation

Symptom	Possible Cause	Possible Solution
Machine vibrates excessively.	<ul style="list-style-type: none"> 1. Sander not secured properly to stand (G1014Z) or cabinet (G1014ZX). 2. Stand not stable on floor. 3. Incorrect motor mounting. 4. Idler roller is too loose. 5. Broken/defective sanding belt. 6. End of table support rod touches side of motor. 	<ul style="list-style-type: none"> 1. Tighten fasteners that mount sander to stand (G1014Z) or cabinet (G1014ZX). 2. Secure stand to floor, reposition to level surface, or shim stand. 3. Check/adjust motor mounting. 4. Adjust idler roller. 5. Replace sanding belt (see Page 39). 6. Position the table support rod further away from motor.
Sanded surface not square.	<ul style="list-style-type: none"> 1. Work table not perpendicular to disc. 2. Miter gauge not square to disc. 3. Work table not perpendicular to belt in vertical position. 	<ul style="list-style-type: none"> 1. Adjust work table square to sanding disc (see Page 48). 2. Adjust miter gauge square to disc or belt (Page 27). 3. Adjust work table square to belt in vertical position (Page 37).
Deep sanding grooves or scars in workpiece.	<ul 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. 	<ul 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.
Grains rub off the belt or disc easily.	<ul 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. 	<ul 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.	<ul style="list-style-type: none"> 1. Too much pressure against belt/disc. 2. Sanding softwood, or stock has surface residue. 	<ul 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.	<ul style="list-style-type: none"> 1. Using too fine of sanding grit. 2. Using too much pressure. 3. Work held still for too long. 	<ul 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.	<ul style="list-style-type: none"> 1. Sanding wet stock. 2. Sanding stock with high residue. 	<ul 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/dics frequently.
Workpiece frequently gets pulled out of your hand.	<ul style="list-style-type: none"> 1. Not supporting the workpiece against the stop. 2. Starting the workpiece on a leading corner. 	<ul style="list-style-type: none"> 1. Use back stop or miter gauge to support workpiece. 2. Start workpiece on a trailing corner.
Belt slips on rollers.	<ul style="list-style-type: none"> 1. Quick release tension lever not engaged. 2. Belt tension not sufficient. 	<ul style="list-style-type: none"> 1. Engage quick release tension lever. 2. Adjust belt tension (Page 47)



V-Belt Tension & Replacement

The V-belt is pre-installed and tensioned at the factory. However, we recommend you verify this setting and also check the V-belt tension after the first 16 hours of operation, during which the belt will stretch and seat.

Tools Needed	Qty
Hex Wrench 4mm.....	1
Wrench 12mm	1

Tensioning V-Belt

1. DISCONNECT SANDER FROM POWER!
2. Remove the work table assembly from the sanding disc, then open the pulley cover.
3. While looking through the access hole on the side of the pulley cover (see **Figure 27** on **Page 23**), rotate the cast iron plate and loosen each of the set screws that secure the plate to the drive shaft.
4. Remove the cast iron plate to expose the V-belt.
5. Push the center of the V-belt with your finger to check belt tension. The belt is correctly tensioned when there is approximately $\frac{1}{4}$ " deflection when it is pushed with moderate pressure, as shown in **Figure 84**.

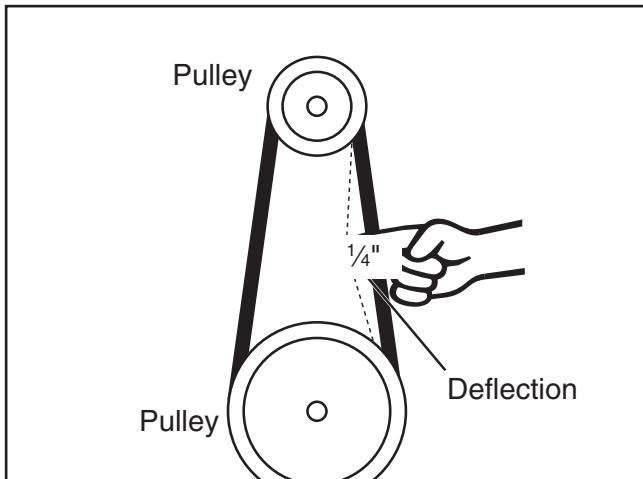


Figure 84. Checking belt tension.

—If there is approximately $\frac{1}{4}$ " deflection, no adjustments are necessary. Go to **Step 9**.

—If there is more or less than that $\frac{1}{4}$ " deflection when you push the V-belt with moderate pressure, follow **Steps 6-7**.

6. Loosen the four hex bolts that secure the motor to the base, as shown in **Figures 85-86**, then slide the motor toward the back of the sander to reduce belt tension or slide it toward the front of the sander to increase tension.

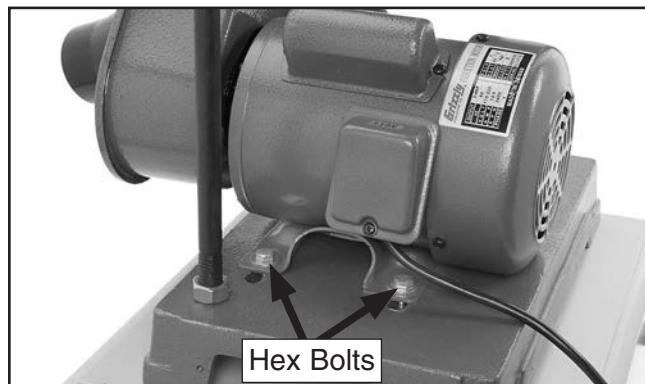


Figure 85. Rear motor mounting bolts.

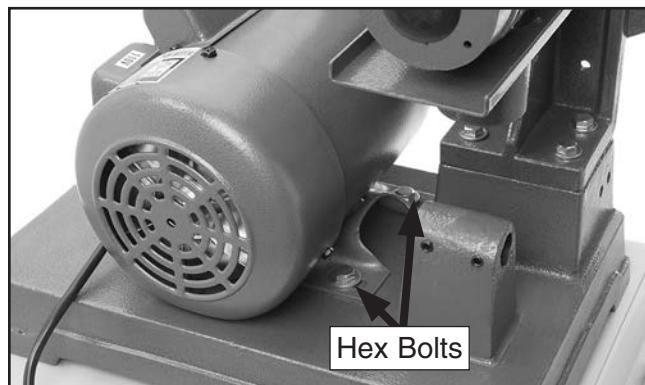


Figure 86. Front motor mounting bolts.

7. Tighten the four hex bolts to secure the motor.
8. Repeat **Step 5** and re-adjust the V-belt tension if necessary.
9. Re-install the cast iron plate onto the drive shaft and secure with the set screws, close and secure the pulley cover, then re-install the work table.



Replacing V-Belt

1. DISCONNECT SANDER FROM POWER!
2. Follow Steps 2-4 in Tensioning V-Belt on Page 46.
3. Loosen the four hex bolts that secure the motor to the base, as shown in Figures 85-86, then slide the motor toward the back of the sander to reduce belt tension.
4. Remove the V-belt and replace it with a new one.
5. Slide the motor toward the front of the sander, then tighten the four hex bolts on the motor base.
6. Repeat Step 5 on Page 46 and adjust the V-belt tension as needed.
7. Re-install the cast iron plate onto the drive shaft and secure it with the two set screws, close and secure the pulley cover, then re-install the work table.

Sanding Belt Tension

Correct belt tension will ensure that your sander functions properly. If the sanding belt slaps against the platen or slips on the idler and drive rollers, the belt may be too loose. If you have a difficult time installing a new sanding belt, tension may be too tight.

Tools Needed	Qty
Wrench 14mm	1
Adjustable Wrench w/1½" Throat	1

To adjust sanding belt tension:

1. DISCONNECT SANDER FROM POWER!
2. Move the quick release tension lever toward the motor to tighten the sanding belt.

3. Loosen the hex bolt on the eccentric (see Figure 87).

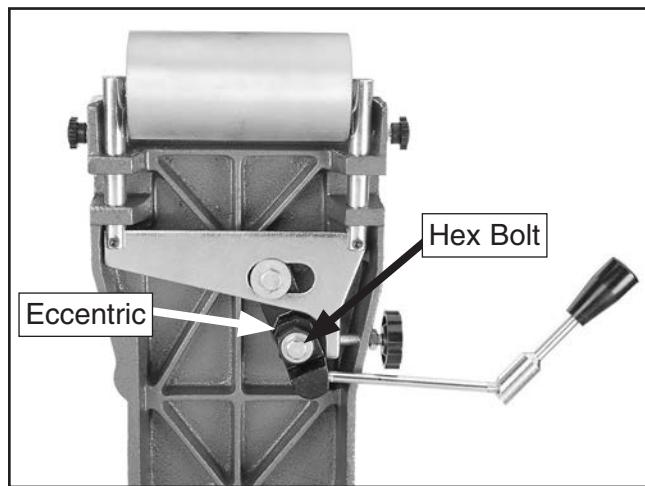


Figure 87. Location of belt tension adjustments (belt removed for clarity).

4. Turn the eccentric to the right to tighten the belt or left to loosen the belt, then tighten the hex bolt on the eccentric.
5. Push the belt in the center with your finger using moderate pressure. The deflection is correct when the belt deflects ½", as shown in Figure 88.

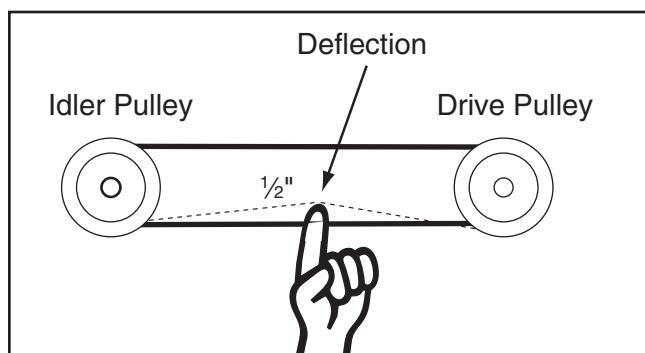


Figure 88. Checking sanding belt tension.

6. Follow the Pre-Tracking Belt instructions on Page 27.
7. Turn the sander **ON** and check the belt tracking. If the belt does not stay in the center of the idler and drive rollers, adjust the tracking with the tracking control knob (refer to Tracking Belt on Page 40 for further detail).



Pulley Alignment

Proper pulley alignment prevents premature belt wear. The pulleys are properly aligned when they are parallel and in the same plane as each other.

Tools Needed	Qty
Hex Wrench 4mm.....	1
Straightedge 12"	1
Standard Screwdriver.....	1

To check and adjust pulley alignment:

1. DISCONNECT SANDER FROM POWER!
2. Remove the work table assembly and miter gauge.
3. Open the pulley cover.
4. Loosen the set screws that secure the cast iron plate to the drive shaft, then remove the plate.
5. Place a 12" straightedge across both pulleys, as shown in **Figure 89**.

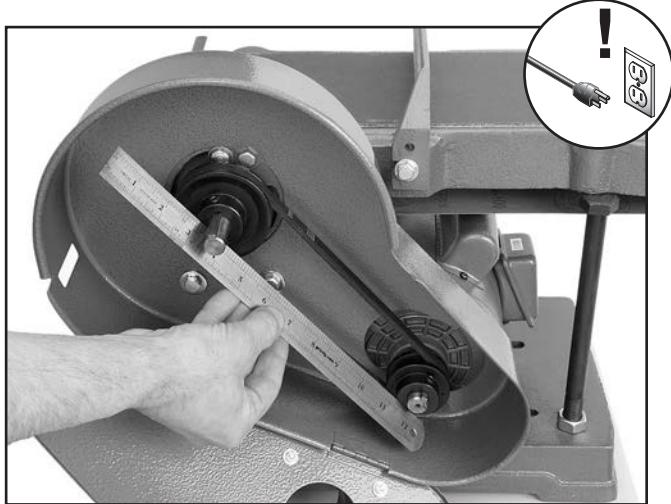


Figure 89. Checking pulley alignment.

—If the straightedge touches the pulleys evenly, no adjustments need to be made. Go to **Step 7**.

—If there is a gap between the straightedge and one of the pulleys, that pulley needs to be adjusted. Proceed to **Step 6**.

6. Loosen the set screw on the pulley where you noticed the gap, then adjust the pulley so it touches the bottom of the straightedge when it is extended across both pulleys, as shown in **Figure 89**.
7. Tighten the pulley set screw, re-install the cast iron plate, close the pulley cover, then re-install the thumb knob and work table.

Squaring Work Table to Sanding Disc

Tools Needed	Qty
Machinist's Square	1

To square the sanding disc table:

1. DISCONNECT SANDER FROM POWER!
2. Place a machinist's square or other 90° measuring tool against the work table and sanding disc (see **Figure 90**).

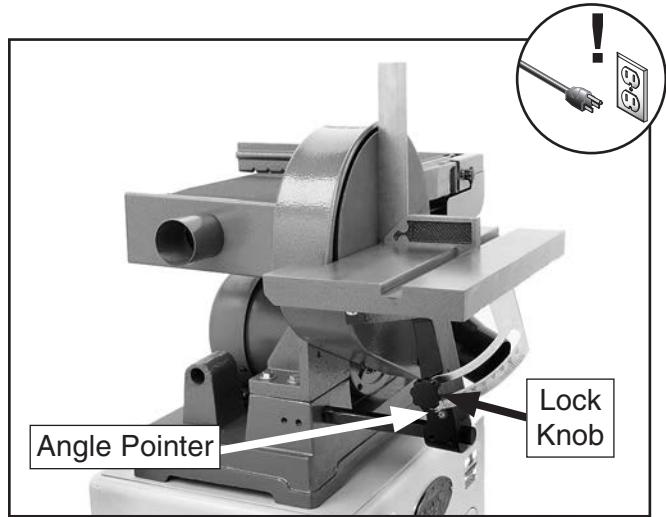


Figure 90. Using a machinist's square to adjust the work table to 90°.

3. Loosen the table lock knob, adjust the table square with the sanding disc, then re-tighten the table lock knob.
4. Loosen the Phillips head screw on the angle pointer, position the red scale pointer over the "0" mark on the angle scale, then re-tighten the screw.



Miter Slot-Disc Parallelism

If the miter slot is not parallel with the disc, workpieces may not be sanded correctly when using the miter gauge.

Tools Needed	Qty
Combination Square.....	1

To check and adjust the miter slot parallel with the sanding disc:

1. DISCONNECT SANDER FROM POWER!
2. Remove the miter gauge, then place a combination square with the 90° square in the miter slot, as shown in **Figure 91**.

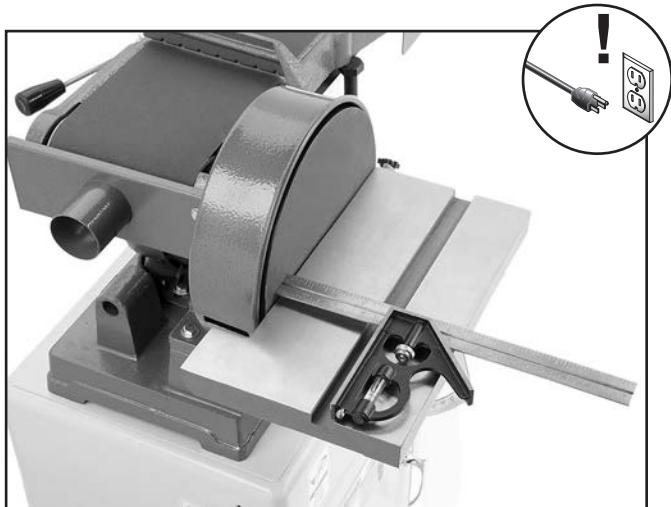


Figure 91. Checking miter slot parallelism with sanding disc.

3. Slide the square to the other side and check to see if the distance from the slot to the sanding disc is the same.

—If the distance is the same, no adjustments need to be made.

—If the distance is not the same from side to side, loosen the screws (see **Figure 68** on **Page 37**) that secure the work table arm to the work table and adjust the table so it is approximately $\frac{1}{16}$ " away from the sanding belt across its entire length.

4. Repeat **Step 3** and adjust the table as needed until the miter slot is parallel with the sanding disc on both sides.

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	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	GREEN		PURPLE	Pu
RED	Rd	ORANGE	Or	PINK		TUR- QUOISE	Tu



G1014Z Wiring Diagram

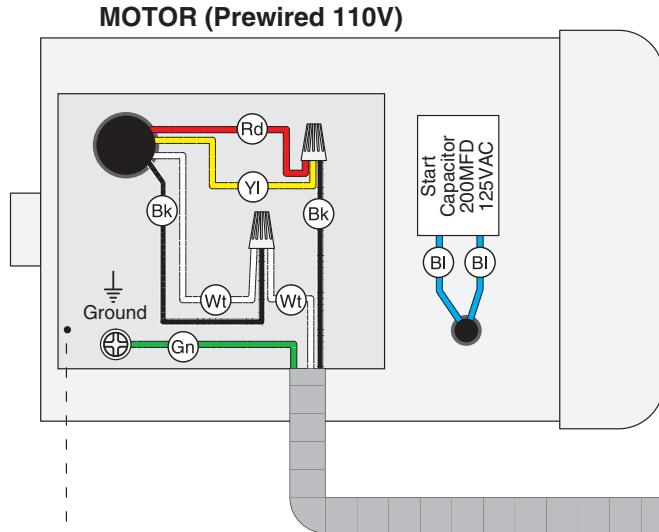


Figure 92. G1014Z 110V motor wiring.

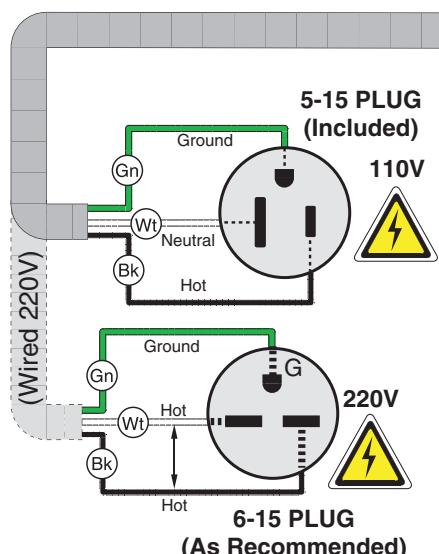
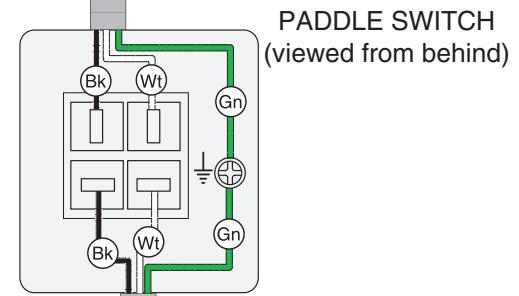
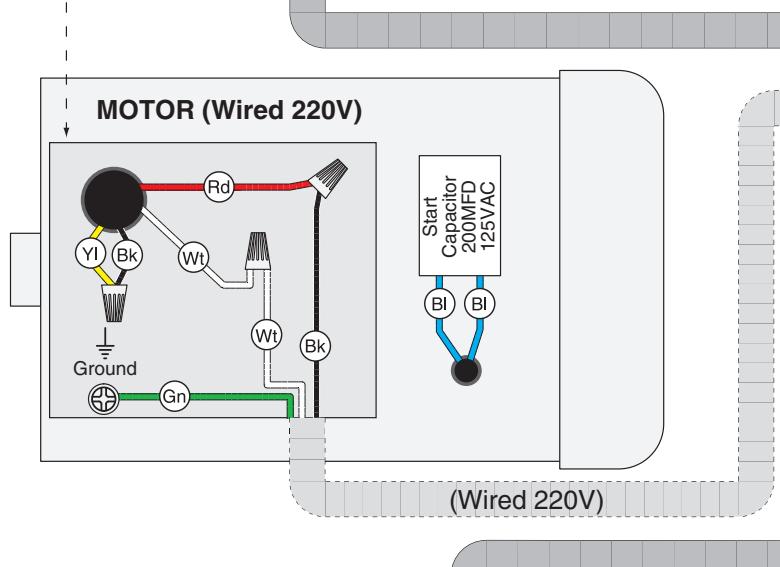


Figure 93. G1014Z switch wiring.



G1014ZX Wiring Diagram

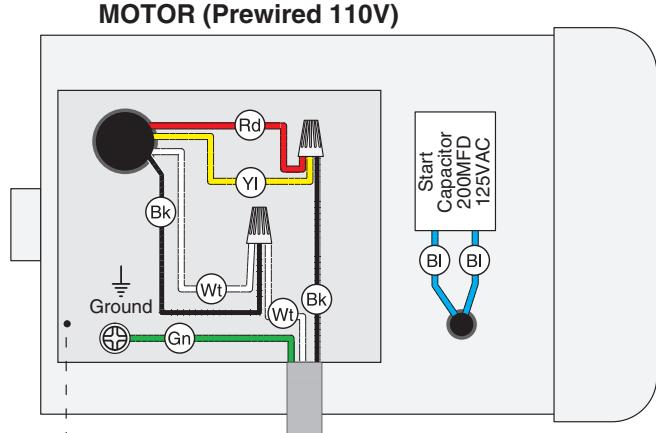


Figure 94 G1014ZX motor wiring.

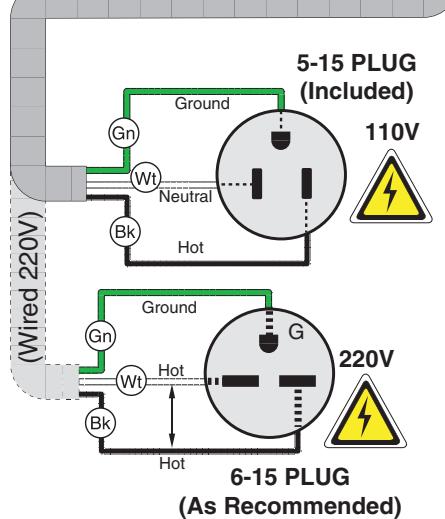
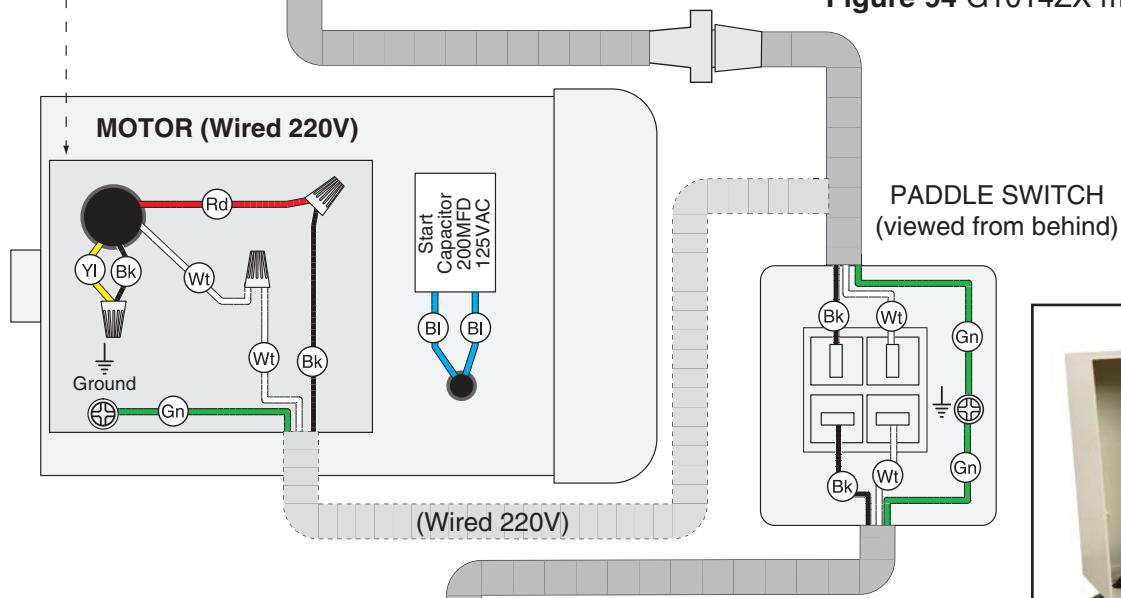


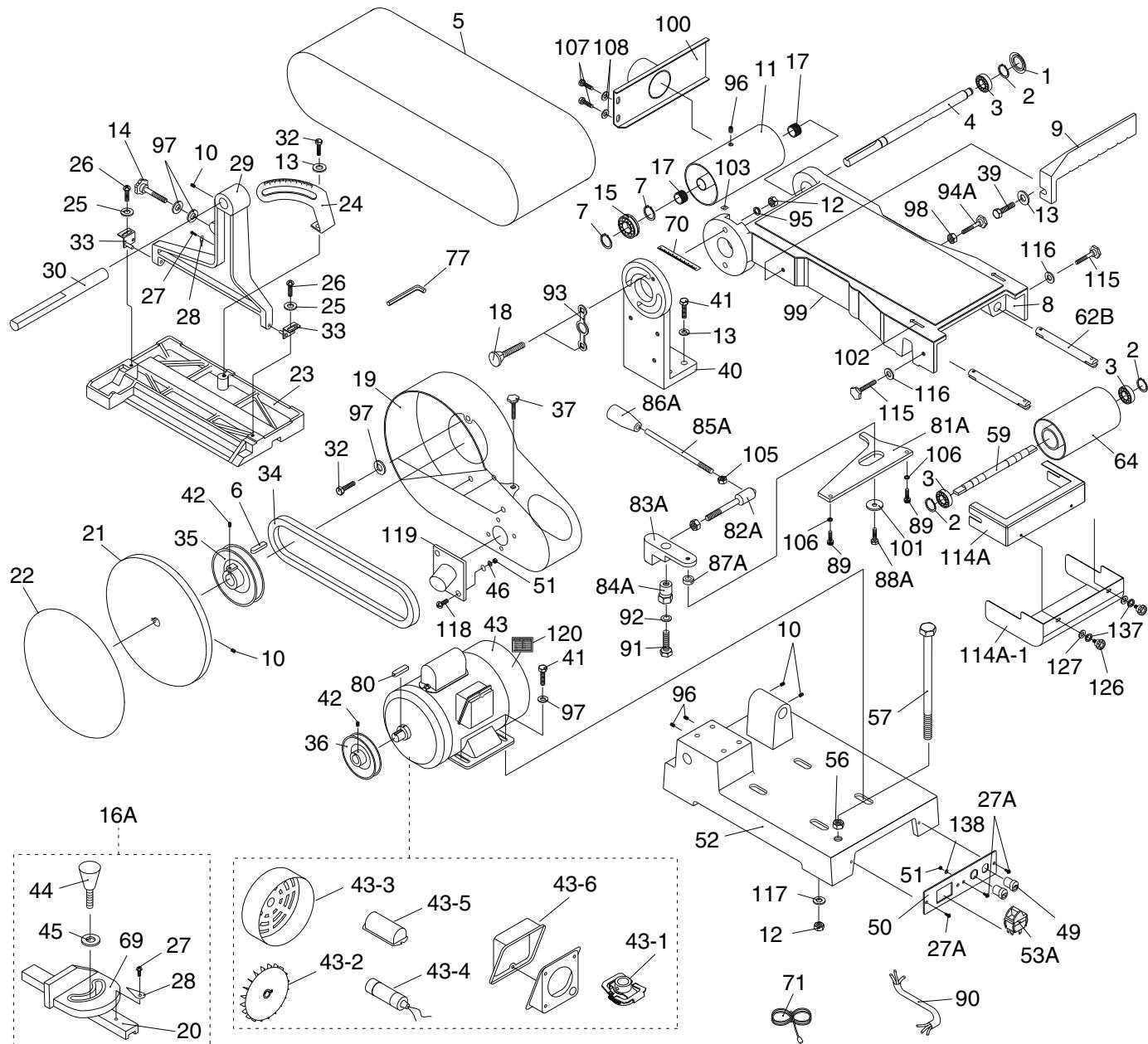
Figure 95. G1014ZX switch wiring.



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.

G1014Z Main



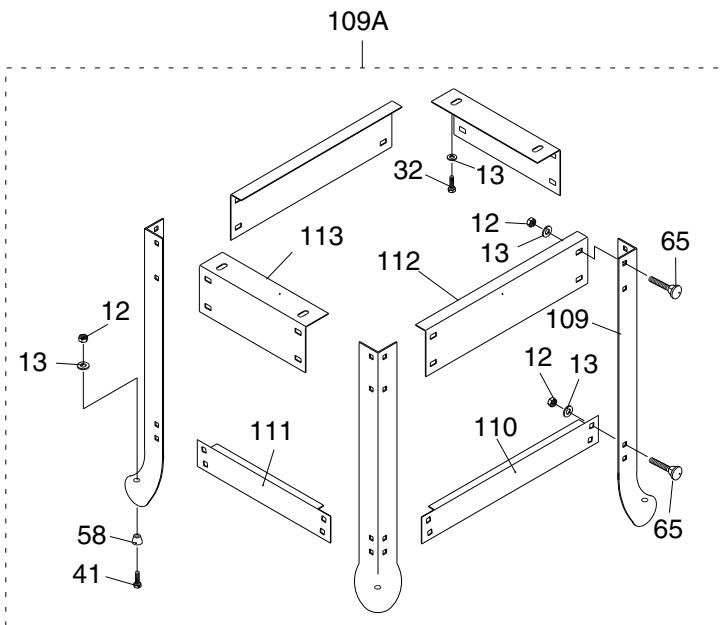
G1014Z Main Parts List

REF	PART #	DESCRIPTION
1	P1014Z001	DUST COVER
2	P1014Z002	EXT RETAINING RING 12MM
3	P1014Z003	BALL BEARING 6201-2RS
4	P1014Z004	DRIVER ROLLER SHAFT
5	P1014Z005	SANDING BELT 6" X 48" A60 (2-PC)
6	P1014Z006	KEY 5 X 5 X 55
7	P1014Z007	EXT RETAINING RING 15MM
8	P1014Z008	SANDING BELT FRAME
9	P1014Z009	BACK STOP
10	P1014Z010	SET SCREW 5/16-18 X 3/8
11	P1014Z011	DRIVE ROLLER
12	P1014Z012	HEX NUT 5/16-18
13	P1014Z013	FLAT WASHER 5/16
14	P1014Z014	KNOB 5/16-18
15	P1014Z015	BALL BEARING 6202-2RS W/SNAP RING
16A	P1014Z016A	COMPLETE MITER GAUGE ASSY
17	P1014Z017	BUSHING 15 X 19.4 X 12MM
18	P1014Z018	CARRIAGE BOLT 5/16-18 X 1-1/2
19	P1014Z019	PULLEY COVER W/DUST PORT V2.07.00
20	P1014Z020	MITER BAR
21	P1014Z021	CAST IRON DISC V2.02.97
22	P1014Z022	SANDING DISC 9" A60 PSA (2-PC)
23	P1014Z023	TABLE
24	P1014Z024	TRUNNION
25	P1014Z025	FLAT WASHER 1/4
26	P1014Z026	PHLP HD SCR 1/4-20 X 1/2
27	P1014Z027	PHLP HD SCR 10-24 X 3/8
27A	P1014Z027A	FLANGE SCREW 10-24 X 3/8
28	P1014Z028	MITER GAUGE POINTER
29	P1014Z029	TABLE SUPPORT BRACKET V2.01.98
30	P1014Z030	SUPPORT BAR
32	P1014Z032	HEX BOLT 5/16-18 X 1/2
33	P1014Z033	TABLE MOUNT L & R (2 PC SET)
34	P1014Z034	V-BELT M24 3L240
35	P1014Z035	PULLEY
36	P1014Z036	MOTOR PULLEY
37	P1014Z037	KNOB 10-24
39	P1014Z039	HEX BOLT 5/16-18 X 1
40	P1014Z040	BRACKET
41	P1014Z041	HEX BOLT 5/16-18 X 1
42	P1014Z042	SET SCREW 5/16-18 X 3/8
43	P1014Z043	MOTOR 3/4HP 110V/220V 1-PH
43-1	P1014Z043-1	CENTRIFUGAL SWITCH
43-2	P1014Z043-2	MOTOR FAN
43-3	P1014Z043-3	MOTOR FAN COVER
43-4	P1014Z043-4	S CAPACITOR 200M 125V 1-3/8 X 2-1/4
43-5	P1014Z043-5	S CAPACITOR COVER
43-6	P1014Z043-6	JUNCTION BOX COVER
44	P1014Z044	LOCK KNOB 1/4-20 X 5/8
45	P1014Z045	PLASTIC WASHER 1/4-16
46	P1014Z046	FLAT WASHER #10
49	P1014Z049	STRAIN RELIEF M14 TYPE-1 SNAP-IN
50	P1014Z050	SWITCH PLATE

REF	PART #	DESCRIPTION
51	P1014Z051	HEX NUT 10-24
52	P1014Z052	BASE
53A	P1014Z053A	SAFETY PADDLE SWITCH
56	P1014Z056	HEX NUT 5/8-11
57	P1014Z057	HEX BOLT 5/8-11 X 9
59	P1014Z059	IDLER SHAFT V3.08.97
62B	P1014Z062B	ROLLER ADJUST BAR
64	P1014Z064	IDLER ROLLER V3.08.97
69	P1014Z069	MITER BODY
70	P1014Z070	TILT SCALE
71	P1014Z071	POWER CORD 16G X 3W 73"L
77	P1014Z077	HEX WRENCH 4MM
80	P1014Z080	KEY 5 X 5 X 40
81A	P1014Z081A	ROCKER PLATE
82A	P1014Z082A	SHORT LEVER
83A	P1014Z083A	ROCKER ARM
84A	P1014Z084A	ECCENTRIC
85A	P1014Z085A	LONG LEVER
86A	P1014Z086A	KNOB 3/8-16
87A	P1014Z087A	SPACER
88A	P1014Z088A	HEX BOLT 3/8-16 X 3/4
89	P1014Z089	CAP SCREW 10-24 X 5/8
90	P1014Z090	MOTOR CORD 16AWG x 3C
91	P1014Z091	HEX BOLT 3/8-16 X 1-1/2
92	P1014Z092	FLAT WASHER 3/8
93	P1014Z093	WASHER PLATE 19 X 88
94A	P1014Z094A	KNOB 3/8-24
95	P1014Z095	LOCK WASHER 5/16
96	P1014Z096	SET SCREW 5/16-18 X 3/4
97	P1014Z097	FENDER WASHER 5/16 X 21 X 2
98	P1014Z098	HEX NUT 3/8-16
99	P1014Z099	GRAPHITE PAD 6"W X 17)L
100	P1014Z100	DUST PORT
101	P1014Z101	FENDER WASHER 3/8
102	P1014Z102	BELT DIRECTION ARROW
103	P1014Z103	TABLE TILT POINTER
105	P1014Z105	HEX NUT 3/8-16
106	P1014Z106	LOCK WASHER 5MM
107	P1014Z107	HEX BOLT 1/4-20 X 1/2
108	P1014Z108	FLAT WASHER 1/4
114A	P1014Z114A	IDLER ROLLER GUARD V2.03.08
114A-1	P1014Z114A-1	SLEEVE GUARD
115	P1014Z115	LOCK KNOB 1/4-20
116	P1014Z116	FLAT WASHER 1/4
117	P1014Z117	FLAT WASHER 5/16
118	P1014Z118	PHLP HD SCR 10-24 X 3/8
119	P1014Z119	DUST PORT (ABS) 2-1/2"
120	P1014Z120	MOTOR LABEL
126	P1014Z126	LOCK KNOB 10-32
127	P1014Z127	FLAT WASHER #10
137	P1014Z137	LOCK WASHER #10
138	P1014Z138	EXT TOOTH WASHER #10

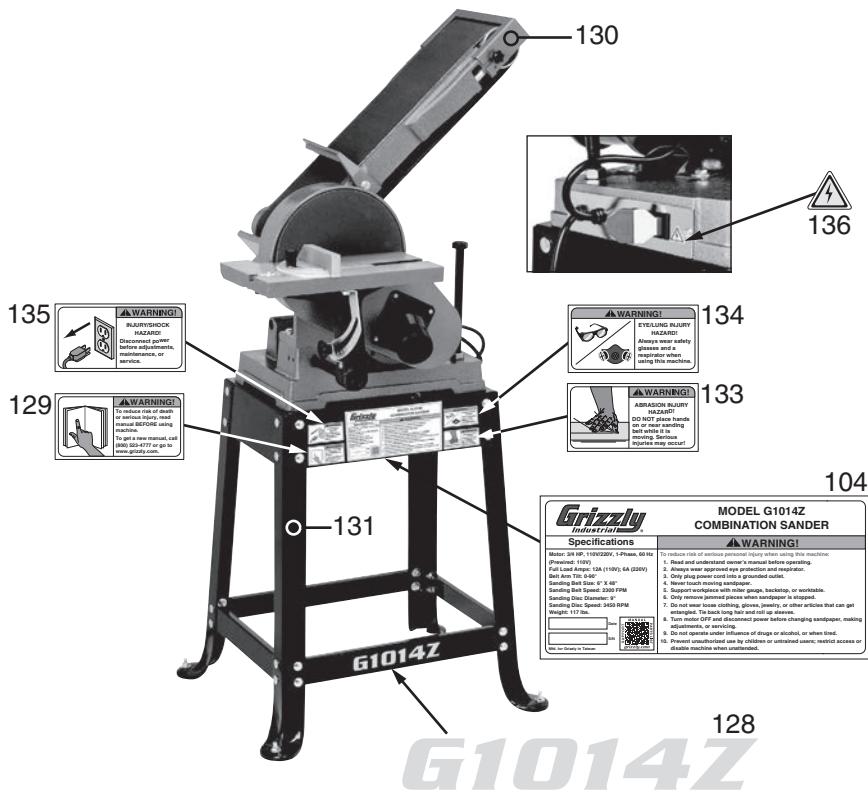


G1014Z Stand



REF	PART #	DESCRIPTION
12	P1014Z012	HEX NUT 5/16-18
13	P1014Z013	FLAT WASHER 5/16
32	P1014Z032	HEX BOLT 5/16-18 X 1/2
41	P1014Z041	HEX BOLT 5/16-18 X 1
58	P1014Z058	RUBBER FOOT
65	P1014Z065	CARRIAGE BOLT 5/16-18 X 5/8
109	P1014Z109	LEG
109A	P1014Z109A	STAND ASSEMBLY
110	P1014Z110	LOWER BRACE (LONG)
111	P1014Z111	LOWER BRACE (SHORT)
112	P1014Z112	UPPER BRACE (LONG)
113	P1014Z113	UPPER BRACE (SHORT)

G1014Z Labels & Cosmetics

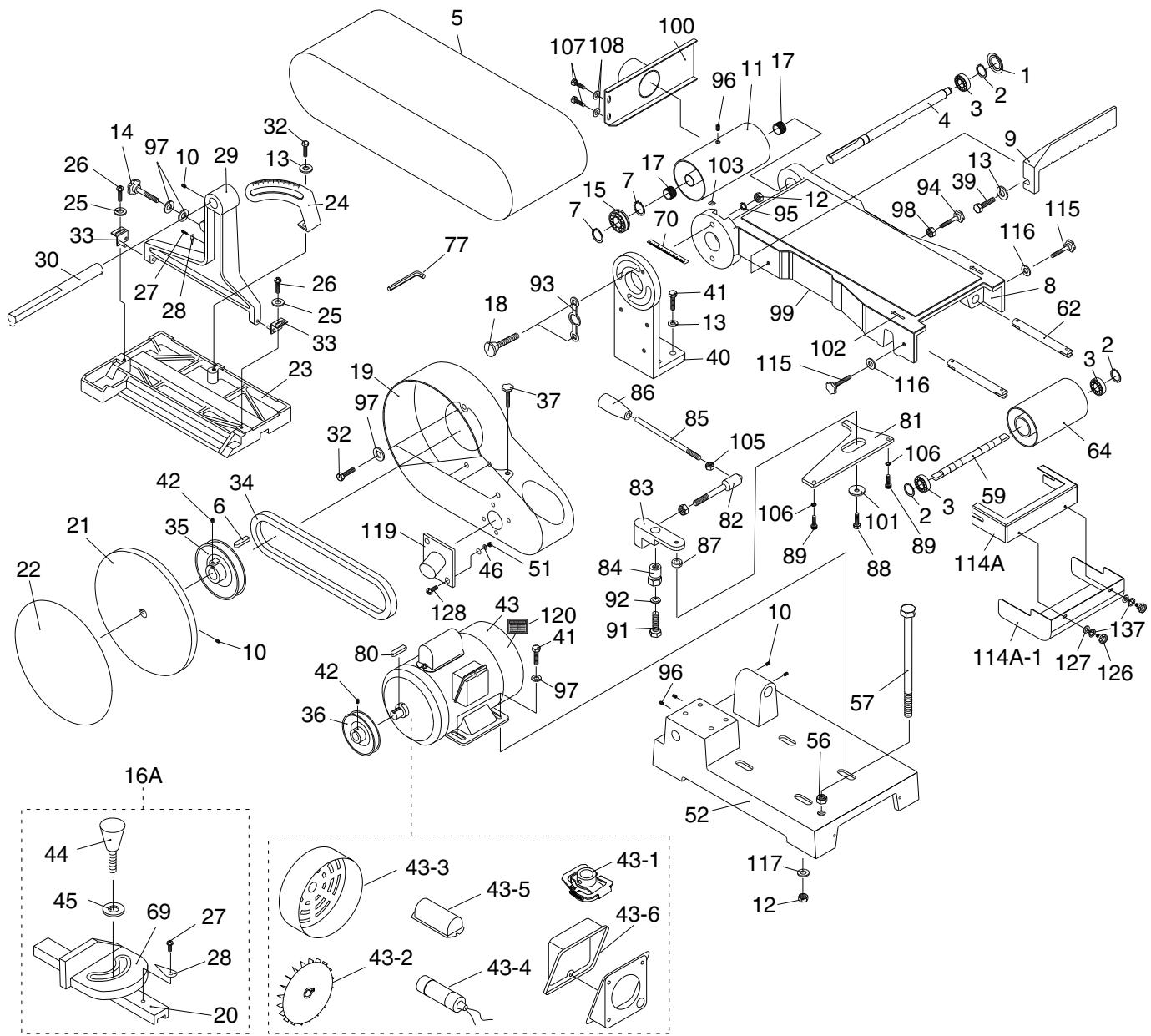


REF	PART #	DESCRIPTION
104	P1014Z104	MACHINE ID LABEL
128	P1014Z128	MODEL NUMBER LABEL
129	P1014Z129	READ MANUAL LABEL
130	P1014Z130	TOUCH-UP PAINT, GRIZZLY GREEN
131	P1014Z131	TOUCH-UP PAINT, GRIZZLY BLACK

REF	PART #	DESCRIPTION
133	P1014Z133	ABRASION INJURY HAZARD
134	P1014Z134	GLASSES/RESPIRATOR LABEL
135	P1014Z135	DISCONNECT POWER LABEL
136	P1014Z136	ELECTRICITY LABEL



G1014ZX Main



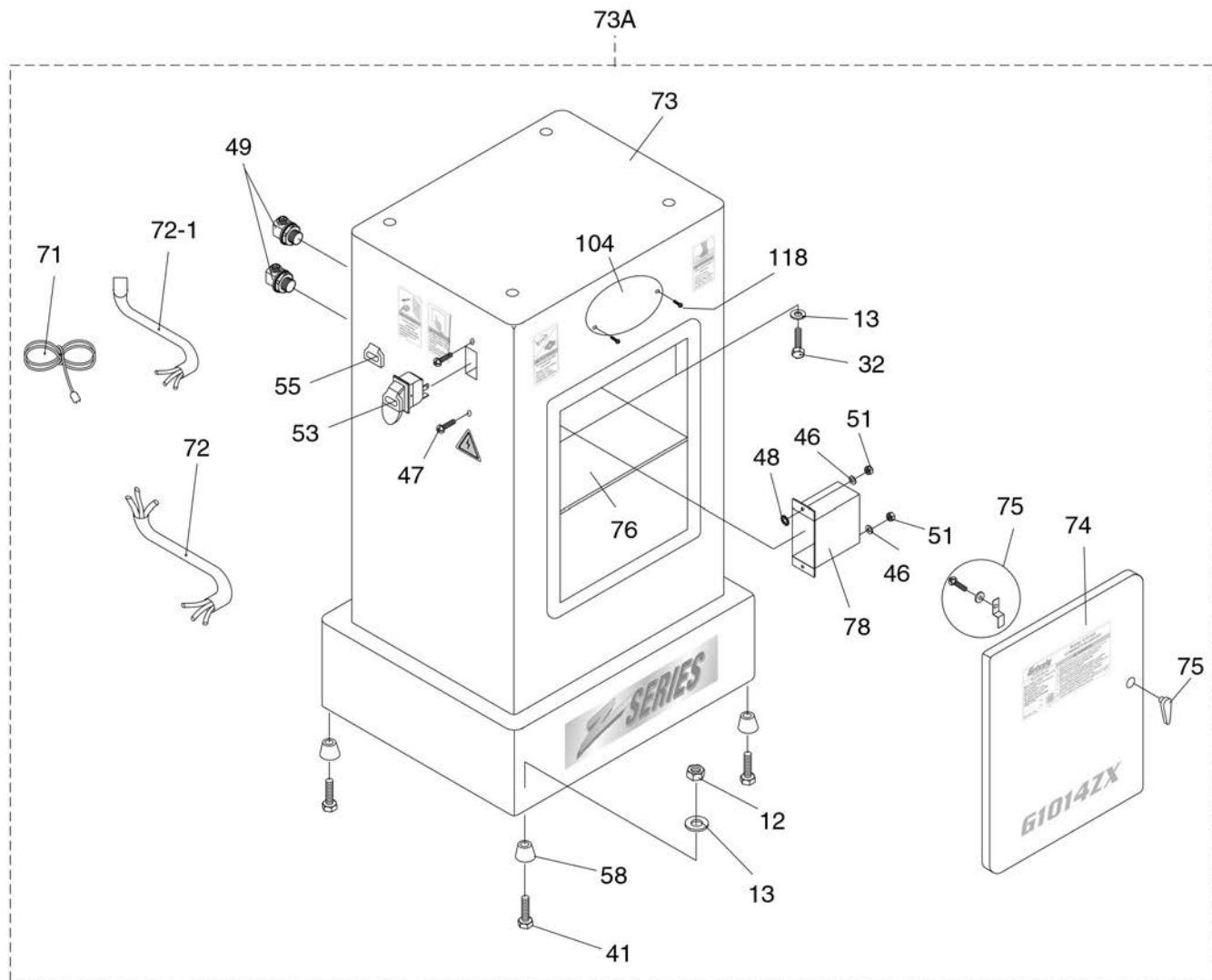
G1014ZX Main Parts List

REF	PART #	DESCRIPTION
1	P1014ZX001	DUST COVER
2	P1014ZX002	EXT RETAINING RING 12MM
3	P1014ZX003	BALL BEARING 6201-2RS
4	P1014ZX004	DRIVER ROLLER SHAFT
5	P1014ZX005	SANDING BELT 6" X 48"
6	P1014ZX006	KEY 5 X 5 X 40
7	P1014ZX007	EXT RETAINING RING 15MM
8	P1014ZX008	SANDING BELT FRAME
9	P1014ZX009	BACK STOP
10	P1014ZX010	SET SCREW 5/16-18 X 3/8
11	P1014ZX011	DRIVE ROLLER
12	P1014ZX012	HEX NUT 5/16-18
13	P1014ZX013	FLAT WASHER 5/16
14	P1014ZX014	KNOB
15	P1014ZX015	BALL BEARING 6202-2RS W/SNAP RING
16A	P1014ZX016A	COMPLETE MITER GAUGE ASSY
17	P1014ZX017	BUSHING 15 X 19.4 X 12MM
18	P1014ZX018	CARRIAGE BOLT 5/16-18 X 1-1/2
19	P1014ZX019	PULLEY COVER V2.07.00
20	P1014ZX020	MITER BAR
21	P1014ZX021	CAST IRON DISC V2.02.97
22	P1014ZX022	SANDING DISC PAPER 9"
23	P1014ZX023	TABLE
24	P1014ZX024	TRUNNION
25	P1014ZX025	FLAT WASHER 1/4
26	P1014ZX026	PHLP HD SCR 1/4-20 X 1/2
27	P1014ZX027	PHLP HD SCR 10-24 X 3/8
28	P1014ZX028	MITER GAUGE POINTER
29	P1014ZX029	TABLE SUPPT BRACKET V2.01.98
30	P1014ZX030	SUPPORT BAR
32	P1014ZX032	HEX BOLT 5/16-18 X 1/2
33	P1014ZX033	TABLE MOUNT
34	P1014ZX034	V-BELT M-24 3L240 (QTY 1)
35	P1014ZX035	PULLEY
36	P1014ZX036	MOTOR PULLEY
37	P1014ZX037	KNOB
39	P1014ZX039	HEX BOLT 5/16-18 X 1
40	P1014ZX040	BRACKET
41	P1014ZX041	HEX BOLT 5/16-18 X 1
42	P1014ZX042	SET SCREW 5/16-18 X 3/8
43	P1014ZX043	MOTOR 3/4 HP 110V/220V 1-PH
43-1	P1014ZX043-1	CENTRIFUGAL SWITCH
43-2	P1014ZX043-2	MOTOR FAN
43-3	P1014ZX043-3	MOTOR FAN COVER
43-4	P1014ZX043-4	S CAP 200M 125V 1-3/8 x 2-1/4
43-5	P1014ZX043-5	S CAPACITOR COVER
43-6	P1014ZX043-6	JUNCTION BOX COVER
44	P1014ZX044	LOCK KNOB 1/4-20 X 5/8
45	P1014ZX045	PLASTIC WASHER 1/4-16

REF	PART #	DESCRIPTION
46	P1014ZX046	FLAT WASHER #10
51	P1014ZX051	HEX NUT 10-24
52	P1014ZX052	BASE
56	P1014ZX056	HEX NUT 5/8-11
57	P1014ZX057	HEX BOLT 5/8-11 X 9
59	P1014ZX059	IDLER SHAFT V3.08.97
62	P1014ZX062	ROLLER ADJ UST BAR
64	P1014ZX064	IDLER ROLLER V3.08.97
69	P1014ZX069	MITER BODY
70	P1014ZX070	SCALE
77	P1014ZX077	HEX WRENCH 4MM
80	P1014ZX080	KEY 5 X 5 X 40
81	P1014ZX081	ROCKER PLATE
82	P1014ZX082	LEVER, SHORT
83	P1014ZX083	ROCKER ARM
84	P1014ZX084	ECCENTRIC
85	P1014ZX085	LONG LEVER
86	P1014ZX086	KNOB 3/8-16
87	P1014ZX087	SPACER
88	P1014ZX088	HEX BOLT 3/8-16 X 3/4
89	P1014ZX089	CAP SCREW 10-24 X 5/8
91	P1014ZX091	HEX BOLT 3/8-16 X 1-1/2
92	P1014ZX092	FLAT WASHER 3/8
93	P1014ZX093	WASHER PLATE 19 X 88
94	P1014ZX094	KNOB 3/8-24
95	P1014ZX095	LOCK WASHER 5/16
96	P1014ZX096	SET SCREW 5/16-18 X 3/4
97	P1014ZX097	FENDER WASHER 5/16 X 21 X 2
98	P1014ZX098	HEX NUT 3/8-24
99	P1014ZX099	GRAPHITE PAD 6"W X 17"L
100	P1014ZX100	DUST PORT
101	P1014ZX101	FENDER WASHER 3/8"
102	P1014ZX102	DIRECTION SCALE
103	P1014ZX103	POINTER
105	P1014ZX105	HEX NUT 3/8-16
106	P1014ZX106	LOCK WASHER 5MM
107	P1014ZX107	HEX BOLT 1/4-20 X 1/2
108	P1014ZX108	FLAT WASHER 1/4
114A	P1014ZX114A	IDLER ROLLER GUARD V2.03.08
114A-1	P1014ZX114A-1	SLEEVE GUARD
115	P1014ZX115	LOCK KNOB 1/4-20
116	P1014ZX116	FLAT WASHER 1/4
117	P1014ZX117	FLAT WASHER 5/16
119	P1014ZX119	DUST PORT (ABS) 2-1/2"
120	P1014ZX120	MOTOR LABEL
126	P1014ZX126	LOCK KNOB 10-32
127	P1014ZX127	FLAT WASHER #10
128	P1014ZX128	PHLP HD SCR 10-24 X 3/8
137	P1014ZX137	LOCK WASHER #10



G1014ZX Cabinet



REF	PART #	DESCRIPTION
12	P1014ZX012	HEX NUT 5/16-18
13	P1014ZX013	FLAT WASHER 5/16
32	P1014ZX032	HEX BOLT 5/16-18 X 1/2
41	P1014ZX041	HEX BOLT 5/16-18 X 1
46	P1014ZX046	FLAT WASHER #10
47	P1014ZX047	FLANGE SCREW 10-24 X 3/8
48	P1014ZX048	EXT TOOTH WASHER #10
49	P1014ZX049	STRAIN RELIEF
51	P1014ZX051	HEX NUT 10-24
53	P1014ZX053	GRIZZLY SAFETY PADDLE SWITCH
55	P1014ZX055	PADDLE SWITCH KEY

REF	PART #	DESCRIPTION
58	P1014ZX058	RUBBER FOOT
71	P1014ZX071	POWER CORD
72	P1014ZX072	MOTOR CORD 1 FEMALE
72-1	P1014ZX072-1	MOTOR CORD 2 MALE
73	P1014ZX073	CABINET
73A	P1014ZX073A	COMPLETE STAND ASSY BOX 2
74	P1014ZX074	CABINET DOOR
75	P1014ZX075	DOOR LATCH SYSTEM
76	P1014ZX076	SHELF
78	P1014ZX078	SWITCH HOUSING
118	P1014ZX118	TAP SCREW #5 X 3/8



G1014ZX Labels & Cosmetics



REF	PART #	DESCRIPTION
60	P1014ZX060	MACHINE ID LABEL
61	P1014ZX061	MODEL NUMBER LABEL
63	P1014ZX063	Z-SERIES LABEL
66	P1014ZX066	DISCONNECT POWER LABEL
67	P1014ZX067	READ MANUAL LABEL
79	P1014ZX079	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
104	P1014ZX104	GRIZZLY NAMEPLATE- SMALL
129	P1014ZX129	TOUCH-UP PAINT, GRIZZLY GREEN
130	P1014ZX130	TOUCH-UP PAINT, GREY PUTTY
131	P1014ZX131	TOUCH-UP PAINT, GLOSSY BLACK
133	P1014ZX133	ABRASION INJURY HAZARD
134	P1014ZX134	GLASSES/RESPIRATOR 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.



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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.





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