MODEL G1014Z/G1014ZX
COMBINATION SANDER
OWNER'S MANUAL
(For models manufactured since 07/17)
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.

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

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

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

## INTRODUCTION ............................................... 2
- Manual Accuracy ........................................... 2
- Contact Info ............................................. 2
- Machine Description ...................................... 2
- Identification ............................................. 3
- G1014Z Machine Data Sheet .................................. 4
- G1014ZX Machine Data Sheet .................................. 6

## SECTION 1: SAFETY ....................................... 9
- Safety Instructions for Machinery .......................... 9
- Safety for Belt and DiscSanders ........................... 11

## SECTION 2: POWER SUPPLY ...................... 12

## SECTION 3: SETUP ....................................... 14
- Needed for Setup .......................................... 14
- Unpacking .................................................... 14
- Hardware Recognition Chart .................................. 15
- G1014Z Inventory ........................................ 16
- G1014ZX Inventory ........................................ 17
- Clean Up ...................................................... 18
- Site Considerations ........................................ 18
- Mounting to Shop Floor .................................... 19
- Mounting to Workbench ..................................... 20
- G1014Z Stand Assembly .................................... 20
- G1014ZX Cabinet Assembly ................................. 22
- Sanding Unit Assembly ..................................... 22
- Calibrating Miter Gauge .................................... 28
- Dust Collection .............................................. 29
- Power Connection .......................................... 30
- Test Run ...................................................... 31

## SECTION 4: OPERATIONS ........................... 32
- Basic Controls .............................................. 32
- Operation Overview ....................................... 33
- Sanding Tips ............................................... 34
- Choosing Sandpaper ....................................... 34
- Stock Inspection and Requirements ....................... 34
- Horizontal & Edge Sanding ................................ 35
- Contour Sanding ............................................ 36
- Disc Sanding ................................................ 37
- Vertical Sanding ............................................ 38
- Changing Sanding Belt ..................................... 41
- Tracking Belt ................................................ 42
- Changing Sanding Disc ...................................... 42

## SECTION 5: ACCESSORIES ......................... 43

## SECTION 6: MAINTENANCE ......................... 45
- Schedule ..................................................... 45
- Cleaning ..................................................... 45
- Unpainted Cast Iron ........................................ 45
- Lubrication ................................................... 45

## SECTION 7: SERVICE ................................... 47
- Troubleshooting ............................................ 47
- V-Belt Tension & Replacement ............................ 49
- Sanding Belt Tension ....................................... 50
- Pulley Alignment ........................................... 51
- Squaring Work Table to Sanding Disc ................... 51
- Miter Slot-Disc Parallelism ................................ 52

## SECTION 8: WIRING ...................................... 53
- Wiring Safety Instructions .................................. 53
- G1014Z Wiring Diagram .................................... 54
- G1014ZX Wiring Diagram ................................... 55

## SECTION 9: PARTS ....................................... 56
- G1014Z Main ............................................... 56
- G1014Z Main Parts List ................................... 57
- G1014Z Stand ............................................... 58
- G1014Z Labels ............................................... 58
- G1014ZX Main .............................................. 59
- G1014ZX Main Parts List .................................. 60
- G1014ZX Cabinet ............................................ 61
- G1014ZX Labels ............................................ 62

## WARRANTY AND RETURNS ........................ 65
INTRODUCTION

Manual Accuracy

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

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

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

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

Contact Info

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

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

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

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

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.
Identification

Figure 1. G1014ZX identification.

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.
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

**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:**

<table>
<thead>
<tr>
<th>Carton #1</th>
<th>Carton #2</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Type</strong>: Cardboard Box</td>
<td>Cardboard Box</td>
</tr>
<tr>
<td><strong>Content</strong>: Machine</td>
<td>Stand</td>
</tr>
<tr>
<td><strong>Weight</strong>: 106 lbs.</td>
<td>52 lbs.</td>
</tr>
<tr>
<td><strong>Length x Width x Height</strong>: 29 x 19 x 15 in.</td>
<td>17 x 20 x 28 in.</td>
</tr>
<tr>
<td><strong>Must Ship Upright</strong>: No</td>
<td>No</td>
</tr>
</tbody>
</table>

**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, 6-15 for 220V
- **Recommended Plug Type**: 5-15 for 110V, 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

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*Information contained herein is deemed accurate as of 10/19/2017 and represents our most recent product specification.*
Main Specifications:

### Belt Sander Info

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sanding Belt Width</td>
<td>6 in.</td>
</tr>
<tr>
<td>Sanding Belt Length</td>
<td>48 in.</td>
</tr>
<tr>
<td>Sanding Belt Speed</td>
<td>2300 FPM</td>
</tr>
<tr>
<td>Sanding Belt Tilt</td>
<td>90 deg.</td>
</tr>
<tr>
<td>Max Height of Belt in Vertical Position</td>
<td>58 in.</td>
</tr>
<tr>
<td>Belt Tension Release Type</td>
<td>Quick Release</td>
</tr>
<tr>
<td>Platen Type</td>
<td>Graphite Coated</td>
</tr>
<tr>
<td>Platen Length</td>
<td>17 in.</td>
</tr>
<tr>
<td>Platen Width</td>
<td>6-1/4 in.</td>
</tr>
</tbody>
</table>

### Disc Sander Info

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Disc Diameter</td>
<td>9 in.</td>
</tr>
<tr>
<td>Disc Speed</td>
<td>3450 RPM</td>
</tr>
<tr>
<td>Disc Sandpaper Backing Type</td>
<td>PSA</td>
</tr>
<tr>
<td>Table Length</td>
<td>12-1/4 in.</td>
</tr>
<tr>
<td>Table Width</td>
<td>6 in.</td>
</tr>
<tr>
<td>Table Thickness</td>
<td>1 in.</td>
</tr>
<tr>
<td>Table Tilt</td>
<td>Left 0, Right 45 deg.</td>
</tr>
<tr>
<td>Table-to-Floor Height</td>
<td>37-1/2 in.</td>
</tr>
</tbody>
</table>

### Construction Materials

<table>
<thead>
<tr>
<th>Material</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Base</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>Stand</td>
<td>Die Cast Aluminum/Aluminum Bar</td>
</tr>
<tr>
<td>Table</td>
<td>Sheet Metal</td>
</tr>
<tr>
<td>Frame</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>Disc</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>Miter Gauge</td>
<td>Die Cast Aluminum/Aluminum Bar</td>
</tr>
<tr>
<td>Paint Type/Finish</td>
<td>Powder Coated</td>
</tr>
</tbody>
</table>

### Other Related Info

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Miter Gauge Slot Width</td>
<td>3/4 in.</td>
</tr>
<tr>
<td>Miter Gauge Slot Height</td>
<td>13/32 in.</td>
</tr>
<tr>
<td>Number of Dust Ports</td>
<td>2</td>
</tr>
<tr>
<td>Dust Port Size</td>
<td>2, 2-1/2 in.</td>
</tr>
<tr>
<td>Compatible Mobile Base</td>
<td>D2260A</td>
</tr>
</tbody>
</table>

### Other Specifications:

<table>
<thead>
<tr>
<th>Feature</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Country of Origin</td>
<td>Taiwan</td>
</tr>
<tr>
<td>Warranty</td>
<td>1 Year</td>
</tr>
<tr>
<td>Approximate Assembly &amp; Setup Time</td>
<td>30 Minutes</td>
</tr>
<tr>
<td>Serial Number Location</td>
<td>ID Label on Stand</td>
</tr>
<tr>
<td>ISO 9001 Factory</td>
<td>No</td>
</tr>
<tr>
<td>Certified by a Nationally Recognized Testing Laboratory (NRTL)</td>
<td>No</td>
</tr>
</tbody>
</table>

### Features:

- Solid Cabinet Stand
- Built-in Storage Shelf
- Quick Belt Release Mechanism
- Cast-Iron Table, Disc and Body
The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

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

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

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

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

### Safety Instructions for Machinery

**WARNING**

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

CLOTHING. DO NOT wear loose clothing while operating this machine. Roll up or button sleeves at the cuff to avoid entanglement.

HAND PROTECTION. DO NOT place hands near, or in contact with, sanding belt during operation. DO NOT allow fingers to get pinched between the workpiece and the table. This may pull your hand into the machine and cause serious injury!

MINIMUM STOCK DIMENSIONS. Do not sand any stock thinner than \( \frac{1}{16} \)", narrower than \( \frac{1}{8} \)" or shorter than 9", to reduce the risk of abrasion injury.

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

FEEDING STOCK. Firmly grasp the workpiece in both hands and ease it into the machine using light pressure. DO NOT jam the workpiece into the machine during operation. Feed the workpiece against the direction of rotation. DO NOT sand tapered or pointed stock with the point facing the feed direction. Never sand more than one piece of stock at a time.

UNATTENDED OPERATION. Never leave the machine running unattended.

REPLACING SANDPAPER. Replace sanding paper when it becomes worn. DO NOT operate the sander with a damaged or badly worn sandpaper.

MAINTENANCE AND ADJUSTMENTS. Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.

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

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.
SECTION 2: POWER SUPPLY

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

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

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

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

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).

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.

Needs for Setup

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

Description | Qty
--- | ---
Safety Glasses | 1
Cleaner/Degreaser (Page 17) | 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

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

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

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

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

- Hex Wrench
- Phillips Head Screw
- Flat Head Screw
- Tap Screw
- Wing Nut
- Lock Nut
- Carriage Bolt
- Flange Bolt
- Button Head Screw
- Set Screw
- Hex Bolt
- E-Clip
- External Retaining Ring
- Internal Retaining Ring
- Lock Washer
- Flat Washer
- Key

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

WASHER DIAMETER

5mm
- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm

LINES ARE 1MM APART

- 5mm
- 10mm
- 15mm
- 20mm
- 25mm
- 30mm
- 35mm
- 40mm
- 45mm
- 50mm
- 55mm
- 60mm
- 65mm
- 70mm
- 75mm

LINES ARE 1/16 INCH APART

- 1/8"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 1/4"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 3/8"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 7/16"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 1/2"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 9/16"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 5/8"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 3/4"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 1"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 1 1/4"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 1 1/2"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 1 3/4"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 2  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 2 1/4"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 2 1/2"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 2 3/4"  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- 3  5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
- #10 5/32"  3/32"  1/16"  5/64"  3/32"  1/16"  5/64"
G1014Z Inventory

The following is a description of the main components shipped with the Model G1014Z. Lay the components out to inventory them.

Note: If you can’t find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.

Box 1: (Figures 2–4) 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 ⅜"-18 x 1" (Feet) ..............................4
• Hex Nuts ⅜"-18 (Feet, Stand) .........................36
• Flat Washers ⅜" (Feet, Stand) .........................40
• Hex Bolts ⅜"-18 x ½" (Stand & Sander) .........4
• Carriage Bolts ⅜"-18 x ½" (Stand) .................32
• Phillips Head Screws #10-24 x ⅜" (2½" Dust Port).................................4
• Hex Nuts #10-24 (2½" Dust Port) ....................4
• Flat Washers #10 (2½" Dust Port) ...................4
• Hex Nuts ⅝"-16 (Quick Release Lever) ..........2

If any nonproprietary 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.

WARNING
SUFFOCATION HAZARD!
Immediately discard all plastic bags and packing materials to eliminate choking/suffocation hazards for children and animals.
G1014ZX Inventory

The following is a description of the main components shipped with the Model G1014ZX. Lay the components out to inventory them.

**Note:** If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.

**Box 1:** (Figure 5)  
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)**  
- Hex Wrench 4mm............................................. 1  
- Hex Bolts 5/16"-18 x ½" (Sander & Cabinet) . 4  
- Flat Washers 5/16" (Sander & Cabinet) ............ 4  
- Phillip Head Screws #10-24 x ½"  
  (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 7)  
A. Cabinet ........................................................ 1  
B. Shelf ............................................................ 1

**Hardware (not shown)**  
- Hex Nuts 5/16"-18 (Cabinet) ......................... 4  
- Hex Bolts 5/16"-18 x 1" (Cabinet) ................. 4  
- Flat Washers 5/16" (Cabinet) ....................... 4

![Figure 5. G1014ZX sander unit.](image1)

![Figure 6. G1014ZX loose inventory items.](image2)

![Figure 7. Cabinet inventory.](image3)
Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser, such as shown in Figure ?? for thorough cleaning, some parts must be removed. **For optimum performance, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer’s instructions when using any type of cleaning product.

![WARNING]

**WARNING**

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. **DO NOT** use these products to clean the machinery.

![CAUTION]

**CAUTION**

Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.

T23692—Orange Power Cleaner & Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.

![Call]

**Call**

1-800-523-4777

**To Order**

![Figure ??. T23692 Orange Power Degreaser.]

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 ?? for the minimum working clearances.

![Figure ??. Minimum working clearances.]

![CAUTION]

**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 8) 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.

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 43).

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 9. 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 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 5/16"-18 hex nut and flat washer, as shown in Figure 10.

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) 5/16"-18 x 1/2" carriage bolts, 5/16"-18 hex nuts, and 5/16" flat washers, as shown in Figure 11. Finger tighten the fasteners for now.

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

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

---

**Figure 10.** Foot fastened to bottom of a leg.

**Figure 11.** Stand legs fastened to long braces.
5. Fasten the two short upper braces and the two short lower braces to one of the leg assemblies with the (8) 5/16"-18 x 1/2" carriage bolts, 5/16"-18 hex nuts, and 5/16" flat washers, as shown in Figure 12.

![Figure 12. Short upper and lower braces fastened to leg assembly.](image1)

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 13.

![Figure 13. Short brace overlapping long upper brace.](image2)

6. Fasten the second leg assembly to the braces on the first leg assembly with the remaining (8) 5/16"-18 x 1/2" carriage bolts, 5/16"-18 hex nuts, and 5/16" flat washers, then place the stand upright on its feet, as shown in Figure 14.

![Figure 14. Stand assembled.](image3)

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 (Figure 15) and adjust the stand if needed by shimming the feet so it is level from front-to-back and side-to-side.

![Figure 15. Leveling stand.](image4)
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 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 5/16"-18 hex nut and 5/16" flat washer (see Figure 16).

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 17) and adjust it level from front-to-back and side-to-side by shimming it.

Figure 16. Feet installed onto bottom of 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) 5/16"-18 hex bolts and 5/16" flat washers, as shown in Figures 18 & 19.

Figure 17. Leveling cabinet.

Figure 18. G1014Z sander fastened to stand (view from underneath stand).
3. Slide the flat ends of the idler roller into the slots on the roller adjustment bars (see Figure 20).

4. Use the 4mm hex wrench to back the shaft set screws on the cast iron plate out of the shaft hole and keyway (Figure 21).

5. Align the keyway on the plate with the drive shaft key, then slide the plate onto the shaft, as shown in Figure 22.

6. Adjust the cast iron plate so it protrudes slightly (1/16"-1/8") beyond the curved lip of the metal cover on both sides, as illustrated in Figure 23, to avoid the possibility of workpieces hitting the cover during sanding operations.

Figure 19. G1014ZX sander fastened to cabinet (two of four hex bolts shown).

Figure 20. Idler roller installed.

Figure 21. Set screw locations on sanding disc plate.

Figure 22. Installing plate onto drive shaft.

Figure 23. Gap between plate and cover.
7. 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 24).

8. 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 25. Make sure the sanding disc adheres completely flat against the plate.

9. 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 26.

10. Secure the pulley cover with the thumb knob.

11. 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 27. The rod should protrude about 6¼" from the side of the base.
12. 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 28.

13. Loosen the angle adjustment knob on the work table (Figure 28), tilt the table to the 0° mark, then tighten the knob.

14. 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 29.

15. Using a ruler (see Figure 29) adjust the edge of the work table approximately 1⁄16" away from the sanding disc on both sides (see Figure 30), then tighten the set screws on the work table arm.

16. Square the table to the sanding disc (refer to instructions on Page 50 for more details).

17. Adjust the miter gauge slot parallel with the sanding disc (refer to instructions on Page 51 for more details), then insert the miter gauge.
18. Install the 2" dust port onto the back of the sanding belt frame with the pre-installed ¼"-20 x ½" hex bolts and flat washers, as shown in Figure 31.

![Figure 31. 2" dust port installed.](image1)

19. Assemble the quick release lever, as shown in Figure 32, using the handle, 6" quick release lever stud, short lever arm, and ⅜"-16 hex nuts, thread the assembly into the rocker arm, then tighten the hex nuts.

![Figure 32. Quick release lever installed.](image2)

20. 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 33).

![Figure 33. Belt installed onto idler and drive rollers.](image3)

21. Push the lever toward the motor to tension the sanding belt.

22. Loosen the thumb knobs behind the idler roller, and install the idler roller assembly (Figure 34).

![Figure 34. Idler roller guard installed.](image4)
23. Adjust the inside edge of the idler roller guard \(\frac{1}{4}-\frac{1}{2}\)" away from the sanding belt (see Figure 35).

![Figure 35. Correct distance between belt and idler guard. Measuring distance (inset).](image)

24. 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.

25. Tighten the thumb knobs located behind the idler roller to secure the guard.

26. **G1014ZX Only**: Connect the motor cord to the power cord on the cabinet (see Figure 36). DO NOT connect the sander to the power until indicated in the Test Run section on Page 30.

![Figure 36. Motor cord connected to power cord.](image)

27. At this point, decide if you want to set up the sanding belt horizontally as in Step 28, or follow the instructions on Page 37 to set up the sanding belt vertically.

28. 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.

29. Place a square flat against the sanding belt and back stop (see Figure 37) adjust the backstop flush with the square on both sides of the belt and \(\frac{1}{8}\)" above the belt (see Figure 38), then tighten the hex bolt.

![Figure 37. Adjusting backstop square with belt.](image)

![Figure 38. Correct clearance between backstop and belt.](image)
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 39) or sanding belt.

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 47 on Page 32), 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 40.

5. Tighten the tracking control knob lock nut.
Dust Collection

⚠️ CAUTION
DO NOT operate the Model G1014Z/G1014ZX without an adequate dust collection system. This sander creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

**Recommended CFM at 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 41**.

**Figure 41.** Sander hooked up to 4” hose.

**Figure 42.** Hose attached to 2” dust port.

**Figure 43.** Hose attached to 2½” dust port.

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

---

**Figure 43 shows a 2” dust hose connected to the dust collection port with a hose clamp.**
Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the POWER SUPPLY section in this manual, and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly.

Always make sure the power switch on the machine is turned OFF (or the OFF button is pushed in) before connecting power.

**NOTICE**
The Model G1014Z/G1014ZX is prewired for 110V. If you plan to operate the machine at 220V, the motor must be rewired (see Page 5???).

---

Connecting Power

1. Turn the machine power switch **OFF**.

2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

![Connecting Power](image1)

**Figure ???.** Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.

2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.

![Disconnecting Power](image2)

**Figure ???.** Disconnecting power.
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 46. 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.

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 40, 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 ??.

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.

Model G1014Z/G1014ZX (Mfd. Since 07/17)
SECTION 4: OPERATIONS

Basic Controls

Refer to Figures 44–48 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 (Figure 45).

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

NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.
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 (Figure 46), 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 38.

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 (Figure 46), 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 47) 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 instructions on Page 41 for more details.)

Vertical Tilt and Work Table Position:
The sanding belt frame can be tilted to the vertical position (see Figure 48) and the work table can be moved behind the motor to support workpieces during vertical sanding. (See Vertical Sanding on Page 37 for more detail.)

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-STICK® abrasive belt cleaners (see Accessories on Page 42).
- 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.

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 30).

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.

<table>
<thead>
<tr>
<th>Grit</th>
<th>Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>36</td>
<td>Extra Coarse</td>
</tr>
<tr>
<td>60</td>
<td>Coarse</td>
</tr>
<tr>
<td>80–100</td>
<td>Medium</td>
</tr>
<tr>
<td>120–180</td>
<td>Fine</td>
</tr>
</tbody>
</table>

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.

![Figure 30. Minimum dimensions for sanding.](image-url)
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 49).

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 41).

3. Turn the sander ON.
4. 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 51 & 52.

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

---

**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:

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 41).

3. Loosen the knobs that secure the idler roller guard and sleeve guard assembly, then remove the guard.

4. Turn the sander ON.

5. 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 53.

---

**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.

6. 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 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 kickback.

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. Slowly, and with light pressure, move the workpiece into the left side of the sanding disc. See Figures 54–57 for examples of disc sanding.

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 39.

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 41).
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 58 & 59.
6. Raise the sanding belt frame until it reaches the 90° mark (or the desired angle) on the tilt scale, as shown in Figure 60, then tighten the rotation lock nuts.
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 61.

Figure 58. Location of top rotation lock nut.

Figure 59. Location of bottom rotation lock nut.

Figure 60. Sanding belt tilted to 90° position.

Figure 61. Work table installed for vertical sanding.
9. Adjust the front of the work table \( \frac{1}{16} \)" away from the sanding belt (see Figure 62) across its entire length.

—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 63), where the arm is attached to the table, and adjust the table until the distance is correct, then tighten the 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 64, and check for gaps between the square, belt, and table.

—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.

—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 \( \frac{1}{8} \)" 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 66–69 for examples of horizontal belt sanding.

Figure 66. Example of end grain sanding.

Figure 67. Example of vertical miter sanding.

Figure 68. Example of vertical face and edge sanding.

Figure 69. 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 70.

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 71).

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.
Changing Sanding Disc

The model G1014Z/G1014ZX accepts 9" diameter paper-backed pressure sensitive adhesive (PSA) discs (refer to Accessories on Page 42).

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.

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 (Figure 72), carefully adjust the tracking in or out until the sanding belt is centered on the main roller (see Figure 40, Page 27).

Figure 72. 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.
SECTION 5: ACCESSORIES

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

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

PRO-STICK® Abrasive Surface Cleaners
Extend the life of your sanding discs and sleeves! Choose the Pro-Stick® with a handle for greater control or without a handle for more usable area.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td>G1511</td>
<td>1½&quot; X 1½&quot; X 8½&quot;</td>
</tr>
<tr>
<td>G1512</td>
<td>2&quot; X 2&quot; X 12&quot;</td>
</tr>
<tr>
<td>G2519</td>
<td>1½&quot; X 1½&quot; X 9&quot; with Handle</td>
</tr>
<tr>
<td>G2520</td>
<td>2&quot; X 2&quot; X 11&quot; with Handle</td>
</tr>
</tbody>
</table>

Figure 73. PRO-STICK® Abrasive Cleaners.

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

Figure 74. Eye protection assortment.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter 2PK P100
H3633—Cartridge Filter 2PK P100 & O Vapor

Wood and other types of dust can cause severe respiratory damage. If you work around dust everyday, a half-mask respirator can greatly reduce your risk. Compatible with safety glasses!

Figure 75. Half-mask respirator with disposable cartridge filters.

order online at www.grizzly.com or call 1-800-523-4777
6" x 48" Aluminum Oxide Sanding Belts
Our aluminum oxide sanding belts are available in grits from 60–220 and packs of 2.

<table>
<thead>
<tr>
<th>Grit</th>
<th>Model</th>
</tr>
</thead>
<tbody>
<tr>
<td>60 Grit, 2 pack</td>
<td>G1214</td>
</tr>
<tr>
<td>80 Grit, 2 pack</td>
<td>G4283</td>
</tr>
<tr>
<td>100 Grit, 2 pack</td>
<td>G1215</td>
</tr>
<tr>
<td>120 Grit, 2 pack</td>
<td>G4284</td>
</tr>
<tr>
<td>150 Grit, 2 pack</td>
<td>G1216</td>
</tr>
<tr>
<td>180 Grit, 2 pack</td>
<td>G4285</td>
</tr>
<tr>
<td>220 Grit, 2 pack</td>
<td>G4286</td>
</tr>
</tbody>
</table>

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.

<table>
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<td>G4244</td>
</tr>
<tr>
<td>100 Grit</td>
<td>G1218</td>
</tr>
<tr>
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<td>G4245</td>
</tr>
<tr>
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<td>G1219</td>
</tr>
<tr>
<td>180 Grit</td>
<td>G4246</td>
</tr>
<tr>
<td>220 Grit</td>
<td>G4247</td>
</tr>
</tbody>
</table>

D2260A—Mini SHOP FOX® Mobile Base
Shop Fox mobile bases are the strongest bases on the market. Adjusts from 10½" x 14½" to 17" x 21½". Has outrigger supports and a stable 4 wheel system. 600 lb. capacity. Weighs 32 lbs.

W1400—Safety Push Blocks
Made of high-impact molded plastic, these safety push blocks have a layer of friction rubber on the bottom that grabs your workpiece as you press down. We strongly recommend these for use with jointers, router tables, shapers and table saws. Measures 3" x 6".

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</tr>
<tr>
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<td>G4285</td>
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<td>220 Grit, 2 pack</td>
<td>G4286</td>
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<td>G1219</td>
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<tr>
<td>180 Grit</td>
<td>G4246</td>
</tr>
<tr>
<td>220 Grit</td>
<td>G4247</td>
</tr>
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</table>

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Figure 77. D2260A SHOP FOX® Mobile Base.

Figure 76. Sandpaper discs.

Figure 78. G2405 Safety Push Blocks.

Figure 79. G1029Z2P 2HP Dust Collector.

G1029Z2P—2HP Dust Collector
The great combination of price and performance make this one of the most popular dust collectors we sell. Perfect for use as a central dust collector in a small shop or as a "dedicated" dust collector next to an industrial machine. Features 220V single-phase power, 1550 CFM, 2.5 micron filtration, and a 6" main inlet w/included 4" x 2" "Y" fitting.

order online at www.grizzly.com or call 1-800-523-4777
SECTION 6: MAINTENANCE

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

Schedule

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

Daily Check:
• Loose mounting bolts.
• Damaged or worn sanding belt or disc.
• Check cords, plugs, and switch for damage.
• 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.

After Each Use:
• Clean/vacuum dust buildup on tables and motor.

Monthly Check:
• Check and lubricate table support rod (see Page 45).

After 50 Hours of Use:
• Check and correct V-belt tension, damage, or wear (see Page 48).
• Check and correct sanding belt tension (see Page 49).

Yearly
• Check and lubricate the rocker plate (see Page 45).

Cleaning

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. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Section 5: Accessories on Page 42 for more details).

Lubrication

An essential step for lubrication is cleaning the components before lubricating them.

This idea is critical because dust will build up on lubricated components and make them hard to move. Simply adding more grease to the components with built-up grime on them will not yield smooth moving components.

Clean the components in this section with an oil/grease solvent cleaner, such as shown on Page 17 so they move smoothly.

The following components need to be lubricated:
• Rocker Plate
• Table Support Rod
Table Support Rod

<table>
<thead>
<tr>
<th>Lubricant</th>
<th>Frequency</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Light Machine Oil</td>
<td>Monthly</td>
<td>Thin Coat</td>
</tr>
</tbody>
</table>

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 80). Move the work table back and forth to distribute the oil.

Rocker Plate

<table>
<thead>
<tr>
<th>Lubricant</th>
<th>Frequency</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>NLGI #2 Grease</td>
<td>Yearly</td>
<td>Dollop</td>
</tr>
</tbody>
</table>

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 81).
### SECTION 7: SERVICE

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

### Troubleshooting

#### Motor & Electrical

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
</table>
| **Machine does not start or a breaker trips.** | 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.  
10. Motor at fault. | 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.** | 1. Feed rate too aggressive.  
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.  
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.** | 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.  
10. Work table support rod rubbing on motor. | 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. |
<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine vibrates excessively.</td>
<td>1. Sander not secured properly to stand (G1014Z) or cabinet (G1014ZX).</td>
<td>1. Tighten fasteners that mount sander to stand (G1014Z) or cabinet (G1014ZX).</td>
</tr>
<tr>
<td></td>
<td>2. Stand not stable on floor.</td>
<td>2. Secure stand to floor, reposition to level surface, or shim stand.</td>
</tr>
<tr>
<td></td>
<td>3. Incorrect motor mounting.</td>
<td>3. Check/adjust motor mounting.</td>
</tr>
<tr>
<td></td>
<td>4. Idler roller is too loose.</td>
<td>4. Adjust idler roller.</td>
</tr>
<tr>
<td></td>
<td>5. Broken/defective sanding belt.</td>
<td>5. Replace sanding belt (see Page 40).</td>
</tr>
<tr>
<td></td>
<td>6. End of table support rod touches side of motor.</td>
<td>6. Position the table support rod further away from motor.</td>
</tr>
<tr>
<td>Sanded surface not square.</td>
<td>1. Work table not perpendicular to disc.</td>
<td>1. Adjust work table square to sanding disc (see Page 50).</td>
</tr>
<tr>
<td></td>
<td>2. Miter gauge not square to disc.</td>
<td>2. Adjust miter gauge square to disc or belt (Page 27).</td>
</tr>
<tr>
<td></td>
<td>3. Work table not perpendicular to belt in vertical position.</td>
<td>3. Adjust work table square to belt in vertical position (see Page 38).</td>
</tr>
<tr>
<td>Deep sanding grooves or scars in workpiece.</td>
<td>1. Sandpaper too coarse for the desired finish.</td>
<td>1. Use a finer grit sanding belt/disc.</td>
</tr>
<tr>
<td></td>
<td>2. Workpiece sanded across the grain.</td>
<td>2. Sand with the grain.</td>
</tr>
<tr>
<td></td>
<td>3. Too much sanding force on workpiece.</td>
<td>3. Reduce pressure on workpiece while sanding.</td>
</tr>
<tr>
<td></td>
<td>4. Workpiece held still against the belt/disc.</td>
<td>4. Keep workpiece moving while sanding on the belt/disc.</td>
</tr>
<tr>
<td>Grains rub off the belt or disc easily.</td>
<td>1. Sanding belt/disc has been stored in an incorrect environment.</td>
<td>1. Store sanding belt/disc away from extremely dry or hot temperatures.</td>
</tr>
<tr>
<td></td>
<td>2. Sanding belt/disc has been folded or smashed.</td>
<td>2. Store sanding belt/disc flat, not folded or bent.</td>
</tr>
<tr>
<td>Sanding surfaces clog quickly or burn.</td>
<td>1. Too much pressure against belt/disc.</td>
<td>1. Reduce pressure on workpiece while sanding.</td>
</tr>
<tr>
<td></td>
<td>2. Sanding softwood, or stock has surface residue.</td>
<td>2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning or replacing belts or discs frequently.</td>
</tr>
<tr>
<td>Burn marks on workpiece.</td>
<td>1. Using too fine of sanding grit.</td>
<td>1. Use a coarser grit sanding belt/disc.</td>
</tr>
<tr>
<td></td>
<td>2. Using too much pressure.</td>
<td>2. Reduce pressure on workpiece while sanding.</td>
</tr>
<tr>
<td></td>
<td>3. Work held still for too long.</td>
<td>3. Do not keep workpiece in one place for too long.</td>
</tr>
<tr>
<td></td>
<td>2. Sanding stock with high residue.</td>
<td>2. Use different stock. Or, accept the characteristics of the stock and plan on cleaning/replacing belts/discs frequently.</td>
</tr>
<tr>
<td>Workpiece frequently gets pulled out of your hand.</td>
<td>1. Not supporting the workpiece against the stop.</td>
<td>1. Use back stop or miter gauge to support workpiece.</td>
</tr>
<tr>
<td></td>
<td>2. Starting the workpiece on a leading corner.</td>
<td>2. Start workpiece on a trailing corner.</td>
</tr>
<tr>
<td>Belt slips on rollers.</td>
<td>1. Quick release tension lever not engaged.</td>
<td>1. Engage quick release tension lever.</td>
</tr>
<tr>
<td></td>
<td>2. Belt tension not sufficient.</td>
<td>2. Adjust belt tension (see Page 49).</td>
</tr>
</tbody>
</table>
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

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hex Wrench 4mm</td>
<td>1</td>
</tr>
<tr>
<td>Wrench 12mm</td>
<td>1</td>
</tr>
</tbody>
</table>

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 24 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 ¼" deflection when it is pushed with moderate pressure, as shown in Figure 82.

6. Loosen the four hex bolts that secure the motor to the base, as shown in Figures 83–84, 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.

—If there is approximately ¼" deflection, no adjustments are necessary. Go to Step 9.

—If there is more or less than that ¼" deflection when you push the V-belt with moderate pressure, follow Steps 6-7.

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.

---

Figure 82. Checking belt tension.

Figure 83. Rear motor mounting bolts.

Figure 84. Front motor mounting bolts.
Replacing V-Belt

1. DISCONNECT SANDER FROM POWER!


3. Loosen the four hex bolts that secure the motor to the base, as shown in Figures 83–84, 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 48 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

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wrench 14mm</td>
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</tr>
<tr>
<td>Adjustable Wrench w/ 1 1/2” Throat</td>
<td>1</td>
</tr>
</tbody>
</table>

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 85).

4. Turn the eccentric to the left to tighten the belt or right to loosen the belt tension, 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 1/2”, as shown in Figure 86.

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 41 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

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
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</thead>
<tbody>
<tr>
<td>Hex Wrench 4mm</td>
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</tr>
<tr>
<td>Straightedge 12&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Standard Screwdriver</td>
<td>1</td>
</tr>
</tbody>
</table>

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 87.

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 87.

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.

Figure 87. 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.

Squaring Work Table to Sanding Disc

Tools Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machinist's Square</td>
<td>1</td>
</tr>
</tbody>
</table>

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 88).

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.

Figure 88. Using a machinist's square to adjust the work table to 90°.
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**

<table>
<thead>
<tr>
<th>Combination Square</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1</td>
</tr>
</tbody>
</table>

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 89.

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 63 on Page 38) that secure the work table arm to the work table and adjust the table so it is approximately ¼" 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.

Figure 89. Checking miter slot parallelism with sanding disc.
SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

⚠️ WARNING

Wiring Safety Instructions

1. **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!

2. **QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.

3. **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.

4. **WIRE/MODEL 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 before completing the task.

5. **MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.

6. **MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

7. **CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.

8. **CIRCUIT REQUIREMENTS.** You MUST follow the requirements on Page ??? when connecting your machine to a power source.

9. **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: **WH**
- BROWN: **BN**
- GREEN: **GN**
- GRAY: **GR**
- PURPLE: **PU**
- TURQUOISE: **Tu**
- PINK: **PN**

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-52-
G1014Z Wiring Diagram

MOTOR (Prewired 110V)

MOTOR (Wired 220V)

NOTICE
The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

Figure 90. G1014Z 110V motor wiring.

Figure 91. G1014Z switch wiring.

DANGER
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!
**G1014ZX Wiring Diagram**

**NOTICE**
The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

**DANGER**
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

The motor wiring shown here is current at the time of printing; however, always use the diagram on the inside of junction box cover when rewiring your motor.

**Figure 92** G1014ZX motor wiring.

**Figure 93**. G1014ZX switch wiring.

---

READ ELECTRICAL SAFETY ON PAGE 52!  
Model G1014Z/G1014ZX (Mfd. Since 07/17)
<table>
<thead>
<tr>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
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<td>P1014Z001</td>
<td>DUST COVER</td>
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<tr>
<td>2</td>
<td>P1014Z002</td>
<td>EXT RETAINING RING 12MM</td>
</tr>
<tr>
<td>3</td>
<td>P1014Z003</td>
<td>BALL BEARING 6201-2RS</td>
</tr>
<tr>
<td>4</td>
<td>P1014Z004</td>
<td>DRIVER ROLLER SHAFT</td>
</tr>
<tr>
<td>5</td>
<td>P1014Z005</td>
<td>SANDING BELT 6&quot; X 48&quot;</td>
</tr>
<tr>
<td>6</td>
<td>P1014Z006</td>
<td>KEY 5 X 5 X 55</td>
</tr>
<tr>
<td>7</td>
<td>P1014Z007</td>
<td>EXT RETAINING RING 15MM</td>
</tr>
<tr>
<td>8</td>
<td>P1014Z008</td>
<td>SANDING BELT FRAME</td>
</tr>
<tr>
<td>9</td>
<td>P1014Z009</td>
<td>BACK STOP</td>
</tr>
<tr>
<td>10</td>
<td>P1014Z010</td>
<td>SET SCREW 5/16-18 X 3/8</td>
</tr>
<tr>
<td>11</td>
<td>P1014Z011</td>
<td>DRIVE ROLLER</td>
</tr>
<tr>
<td>12</td>
<td>P1014Z012</td>
<td>HEX NUT 5/16-18</td>
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<td>13</td>
<td>P1014Z013</td>
<td>FLAT WASHER 5/16</td>
</tr>
<tr>
<td>14</td>
<td>P1014Z014</td>
<td>KNOB 5/16-18</td>
</tr>
<tr>
<td>15</td>
<td>P1014Z015</td>
<td>BALL BEARING 6202-2RS W/SNAP RING</td>
</tr>
</tbody>
</table>

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<td>COMPLETE METER GAUGE ASSY</td>
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<td>P1014Z017</td>
<td>BUSHING 15 X 19.4 X 12MM</td>
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<td>P1014Z018</td>
<td>CARRIAGE BOLT 5/16-18 X 1-1/2</td>
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<td>P1014Z019</td>
<td>PULLEY COVER V2.07.00</td>
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<td>20</td>
<td>P1014Z020</td>
<td>METER BAR</td>
</tr>
<tr>
<td>21</td>
<td>P1014Z021</td>
<td>CAST IRON DISC V2.02.97</td>
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<td>P1014Z022</td>
<td>SANDING DISC PAPER 9&quot;</td>
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<td>P1014Z023</td>
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<td>P1014Z026</td>
<td>PHLP HD SCR 1/4-20 X 1/2</td>
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<td>P1014Z027</td>
<td>PHLP HD SCR 10-24 X 3/8</td>
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<td>P1014Z027A</td>
<td>FLANGE SCREW 10-24 X 3/8</td>
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<td>P1014Z028</td>
<td>POINTER</td>
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<td>P1014Z030</td>
<td>SUPPORT BAR</td>
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<td>MOTOR 3/4 HP 110V/220V 1-PH</td>
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<td>P1014Z043-1</td>
<td>CENTRIFUGAL SWITCH</td>
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<td>P1014Z043-2</td>
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<td>P1014Z043-3</td>
<td>MOTOR FAN COVER</td>
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**G1014Z Stand**

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**G1014Z Labels**

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G1014ZX Main
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Model G1014Z/G1014ZX (Mfd. Since 07/17)
## G1014ZX Cabinet

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<td>79</td>
<td>P1014ZX079</td>
<td>ELECTRICITY LABEL</td>
</tr>
<tr>
<td>104</td>
<td>P1014ZX104</td>
<td>GRIZZLY NAMEPLATE- SMALL</td>
</tr>
<tr>
<td>118</td>
<td>P1014ZX118</td>
<td>TAP SCREW #5 X 3/8</td>
</tr>
</tbody>
</table>
### G1014ZX Labels

**REF** | **PART #** | **DESCRIPTION** |
--- | --- | --- |
60 | P1014ZX060 | MACHINE ID LABEL |
61 | P1014ZX061 | MODEL NUMBER LABEL |
66 | P1014ZX066 | DISCONNECT 110V 2W X 3.3H |
67 | P1014ZX067 | READ MANUAL V2.07.05 |
79 | P1014ZX079 | ELECTRICITY LABEL |
104 | P1014ZX104 | GRIZZLY NAMEPLATE - SMALL |

**REF** | **PART #** | **DESCRIPTION** |
--- | --- | --- |
129 | P1014ZX129 | GRIZZLY GREEN TOUCH-UP PAINT |
130 | P1014ZX130 | GRAY PUTTY TOUCH-UP PAINT |
131 | P1014ZX131 | BLACK TOUCH UP PAINT |
133 | P1014ZX133 | ABRASION INJURY HAZARD |
134 | P1014ZX134 | GLASSES/RESPIRATOR 2W X 3.3H |

**WARNING**

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.
WARRANTY CARD

Name _____________________________________________________________________________
Street _____________________________________________________________________________
City _______________________ State _________________________ Zip _____________________
Phone # ____________________ Email _________________________________________________
Model # ____________________ Order # _______________________ Serial # __________________

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

1. How did you learn about us?
   ____ Advertisement    ____ Friend    ____ Catalog
   ____ Card Deck    ____ Website    ____ Other:

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

3. What is your annual household income?
   ____ $20,000-$29,000    ____ $30,000-$39,000    ____ $40,000-$49,000
   ____ $50,000-$59,000    ____ $60,000-$69,000    ____ $70,000+

4. What is your age group?
   ____ 20-29    ____ 30-39    ____ 40-49
   ____ 50-59    ____ 60-69    ____ 70+

5. How long have you been a woodworker/metalworker?
   ____ 0-2 Years    ____ 2-8 Years    ____ 8-20 Years    ____ 20+ Years

6. How many of your machines or tools are Grizzly?
   ____ 0-2    ____ 3-5    ____ 6-9    ____ 10+

7. Do you think your machine represents a good value?  ____Yes  ____No

8. Would you recommend Grizzly Industrial to a friend?  ____Yes  ____No

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

10. Comments:_________________________________________________________________________
    ___________________________________________________________________________________
    ___________________________________________________________________________________
    ___________________________________________________________________________________
WARRANTY AND RETURNS

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

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

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

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

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

Thank you again for your business and continued support. We hope to serve you again soon.
Visit Our Website Today For Current Specials!

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