MODEL G1014Z/G1014ZX
6" X 48" BELT/9" DISC COMBO SANDER
OWNER'S MANUAL
(For models manufactured since 08/22)
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.
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INTRODUCTION

Contact Info

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

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

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

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

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](http://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.

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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

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

![Diagram of sander with labeled parts]

**WARNING**

For Your Own Safety Read Instruction Manual Before Operating the Sander

- a) Wear eye and ear protection.
- b) Support workpiece with miter gauge, backstop, or work table.
- c) Maintain \( \frac{1}{16} \) in. maximum clearance between table and sanding belt or disc.
- d) Avoid kickback by sanding in accordance with directional arrows.
Controls & Components

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

Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

Power Controls

Figure 1. Paddle switch location on G1014Z.

A. Paddle Switch: Turns the motor ON when flipped up; turns motor OFF when pressed down.

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

Figure 2. Paddle switch location on G1014ZX.

Table Controls

C. Miter Gauge: Moves workpieces into the sanding disc (horizontal sanding) or belt (vertical sanding) at a specific angle. Slide miter gauge into the miter slot, loosen the lock knob, set the angle, then tighten the knob.

D. Table Tilt Lock Knob: Loosens to tilt the table relative to the sanding disc or the sanding belt, then tightens to secure.

Sanding Belt Controls

E. Sanding Belt Frame: Tilts between horizontal and vertical positions.

F. Tracking Control Knob: Adjusts belt tracking on the rollers. Loosen the lock nut on the tracking knob, turn the motor ON, adjust the tracking in small increments with the knob, then tighten the lock nut to secure.

G. Quick Release Tension Lever: Tensions the sanding belt when moved toward the motor.
MODEL G1014Z 6" X 48" BELT/9" DISC Z SERIES COMBO SANDER

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
  - Bearings: Sealed & Permanently Lubricated
  - Centrifugal Switch/Contacts Type: External

Main Specifications:
- Belt Sander Info
  - Sanding Belt Width: 6 in.
  - Sanding Belt Length: 48 in.
  - Sanding Belt Speed: 1900 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......................................................................................................................................................... 2420 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
ISO 9001 Factory .......................................................................................................................................... Yes

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
MODEL G1014ZX 6" X 48" BELT/9" DISC COMBO SANDER WITH CABINET STAND

Product Dimensions:

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

Shipping Dimensions:

- Carton #1:
  - Type: Cardboard Box
  - Content: Machine
  - Weight: 106 lbs.
  - Length x Width x Height: 29 x 19 x 15 in.
  - Must Ship Upright: No

- Carton #2:
  - Type: Cardboard Box
  - Content: Stand
  - Weight: 52 lbs.
  - Length x Width x Height: 17 x 20 x 28 in.
  - Must Ship Upright: No

Electrical:

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

Motors:

- Main
  - Horsepower: 3/4 HP
  - Phase: Single-Phase
  - Amps: 12A/6A
  - Speed: 3450 RPM
  - Type: TEFC Capacitor-Start Induction
  - Power Transfer: Belt
  - Bearings: Sealed & Permanently Lubricated
  - Centrifugal Switch/Contacts Type: External
### Main Specifications:

#### Belt Sander Info

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</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>1900 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>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Disc Diameter</td>
<td>9 in.</td>
</tr>
<tr>
<td>Disc Speed</td>
<td>2420 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>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Base</td>
<td>Cast Iron</td>
</tr>
<tr>
<td>Stand</td>
<td>Sheet Metal</td>
</tr>
<tr>
<td>Table</td>
<td>Cast Iron</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>Specification</th>
<th>Value</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:

- **Country of Origin**: Taiwan
- **Warranty**: 1 Year
- **Approximate Assembly & Setup Time**: 30 Minutes
- **Serial Number Location**: ID Label
- **ISO 9001 Factory**: Yes

### Features:

- Solid Cabinet Stand
- Built-in Storage Shelf
- Quick Belt Release Mechanism
- Cast-Iron Table, Disc and Body
For Your Own Safety, Read Instruction Manual Before Operating This Machine

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

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

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

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

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

### Safety Instructions for Machinery

**WARNING**

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

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

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

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

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

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

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.
WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

⚠️ WARNING

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

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

IN-RUNNING NIP POINTS. The gap between moving sandpaper and fixed table/support creates a pinch point for fingers or workpieces; the larger this gap is, the greater the risk of fingers or workpieces getting caught in it. Minimize this risk by adjusting table/support to no more than $\frac{3}{16}$" away from sandpaper.

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

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

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

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

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

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

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

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

WORKPIECE INTEGRITY. Sanding fragile workpieces can result in loss of control, resulting in abrasion injuries, impact injuries, or damage to sandpaper. Only sand solid workpieces that can withstand power sanding forces. Make sure workpiece shape is properly supported; avoid sanding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when sanding force is applied.
SECTION 2: POWER SUPPLY

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

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

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

**Full-Load Current Rating at 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, 115V, 120V
- **Cycle** .............................................. 60 Hz
- **Phase** .............................................. Single-Phase
- **Circuit Rating** ..................... 15 Amps
- **Plug/Receptacle** ................. NEMA 5-15

Circuit Requirements for 220V
This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to Voltage Conversion instructions for details.)

- **Nominal Voltage** ............. 208V, 220V, 230V, 240V
- **Cycle** .............................................. 60 Hz
- **Phase** .............................................. Single-Phase
- **Circuit Rating** ..................... 15 Amps
- **Plug/Receptacle** ................. NEMA 6-15
Grounding Requirements

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

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

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal. Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

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

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

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

Minimum Gauge Size: 14 AWG
Maximum Length: 50 ft.

For 220V operation: The plug specified under “Circuit Requirements for 220V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

Figure 5. Typical 5-15 plug and receptacle.

Figure 6. Typical 6-15 plug and receptacle.
Converting Voltage to 220V

The voltage conversion MUST be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the motor and installing the correct plug. A wiring diagram for each machine is provided for your reference in the back of this manual, beginning on Page 52.

Items Needed

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phillips Head Screwdriver #2</td>
</tr>
<tr>
<td>Electrical Tape</td>
</tr>
<tr>
<td>Wire Cutters/Stripper</td>
</tr>
<tr>
<td>NEMA 6-15 Plug</td>
</tr>
</tbody>
</table>

To convert the machine to 220V operation:

1. DISCONNECT MACHINE FROM POWER!
2. Cut off the existing 5-15 plug.
3. Open the motor junction box, then loosen two wire nuts indicated in Figure 7.
4. Use wire nuts to connect wires as indicated in Figure 8. Twist wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose during operation.
5. Close and secure motor junction box.
6. Install 6-15 plug on power cord, according to plug manufacturer’s instructions.
   — If plug manufacturer’s instructions are not available, NEMA standard 6-15 plug wiring is provided beginning on Page 52.

Figure 7. Motor prewired for 110V.

Figure 8. Motor rewired for 220V.
SECTION 3: SETUP

Needed for Setup

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

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety Glasses</td>
<td>1</td>
</tr>
<tr>
<td>Cleaner/Degreaser</td>
<td>As Needed</td>
</tr>
<tr>
<td>Disposable Shop Rags</td>
<td>As Needed</td>
</tr>
<tr>
<td>Disposable Gloves</td>
<td>As Needed</td>
</tr>
<tr>
<td>Additional People</td>
<td>1</td>
</tr>
<tr>
<td>Open-End Wrench ½&quot;, ⅜&quot;</td>
<td>1 Ea.</td>
</tr>
<tr>
<td>Level</td>
<td>1</td>
</tr>
<tr>
<td>Shims</td>
<td>As Needed</td>
</tr>
<tr>
<td>Phillips Head Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Ruler</td>
<td>1</td>
</tr>
<tr>
<td>Machinist’s Square</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket ⅛&quot;, ⅜&quot;</td>
<td>1 Ea.</td>
</tr>
<tr>
<td>Dust Hose 2&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Hose Clamps 2&quot;</td>
<td>2</td>
</tr>
<tr>
<td>Dust Hose 2½&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Hose Clamps 2⅜&quot;</td>
<td>2</td>
</tr>
<tr>
<td>Hose Adapters 4&quot; x 2&quot;, 4&quot; x 2½&quot;</td>
<td>1 Ea.</td>
</tr>
<tr>
<td>Dust Hoses 4&quot;</td>
<td>3</td>
</tr>
<tr>
<td>Hose Clamps 4&quot;</td>
<td>5</td>
</tr>
<tr>
<td>Hose Y-Fitting 4&quot; x 4&quot; x 4&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Dust Collector</td>
<td>1</td>
</tr>
</tbody>
</table>

Unpacking

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

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

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- ¼"
- 5/16"
- 3/8"
- 7/16"
- ¼"

LINES ARE 1 MM APART

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

LINES ARE 1/8 INCH APART

- 5mm
- 5/16"
- 3/8"
- 1/2"
- 5/8"
- 7/16"
- 9/16"
- 5/16"
- 1/2"
- 3/4"
- 7/8"
- 1"

WASHER DIAMETER

- 5/8"
- 9/16"
- 1/2"
- 7/16"
- 1/4"

WASHERS MEASURED BY THE INSIDE DIAMETER

- 12mm
- 10mm
- 8mm
- 6mm
- 4mm
- #10

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

Model G1014Z/G1014ZX (Mfd. Since 08/22)
G1014Z Inventory

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

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

Box 1 (Figures 9–11)  

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

Hardware & Tools (not shown)  

<table>
<thead>
<tr>
<th>Item Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Hex Wrench 4mm</td>
<td>1</td>
</tr>
<tr>
<td>• Hex Bolts ½-16 x 1” (Feet)</td>
<td>4</td>
</tr>
<tr>
<td>• Hex Nuts ½-18 (Feet, Stand)</td>
<td>36</td>
</tr>
<tr>
<td>• Flat Washers ½-16 (Feet, Stand)</td>
<td>40</td>
</tr>
<tr>
<td>• Hex Bolts ½-18 x ½” (Stand &amp; Sander)</td>
<td>4</td>
</tr>
<tr>
<td>• Carriage Bolts ½-18 x ½” (Stand)</td>
<td>32</td>
</tr>
<tr>
<td>• Phillip head Screws 10-24 x ½” (2½” Dust Port)</td>
<td>4</td>
</tr>
<tr>
<td>• Hex Nuts 10-24 (2½” Dust Port)</td>
<td>4</td>
</tr>
<tr>
<td>• Flat Washers #10 (2½” Dust Port)</td>
<td>4</td>
</tr>
<tr>
<td>• Hex Nuts ¾-16 (Quick Release Lever)</td>
<td>2</td>
</tr>
<tr>
<td>• Thumb Knobs ¼”-20 x ½” (Sander Unit)</td>
<td>2</td>
</tr>
<tr>
<td>• Flat Washers ¼” (Sander Unit)</td>
<td>2</td>
</tr>
<tr>
<td>• Thumb Knobs M5-.8 x 10 (Roller Guard)</td>
<td>2</td>
</tr>
<tr>
<td>• Flat Washers #10 (Roller Guard)</td>
<td>2</td>
</tr>
<tr>
<td>• Lock Washers #10 (Roller Guard)</td>
<td>2</td>
</tr>
</tbody>
</table>

NOTICE
If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.
# G1014ZX Inventory

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

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

## Box 1 (Figures 12–13)

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Sander Unit</td>
<td>1</td>
</tr>
<tr>
<td>B. Sanding Belt 6&quot; x 48&quot;</td>
<td>1</td>
</tr>
<tr>
<td>C. Dust Port 2½&quot; (Black)</td>
<td>1</td>
</tr>
<tr>
<td>D. Work Table</td>
<td>1</td>
</tr>
<tr>
<td>E. Miter Gauge</td>
<td>1</td>
</tr>
<tr>
<td>F. Back Stop</td>
<td>1</td>
</tr>
<tr>
<td>G. Rubber Feet (Cabinet)</td>
<td>4</td>
</tr>
<tr>
<td>H. Quick Release Lever Handle</td>
<td>1</td>
</tr>
<tr>
<td>I. Table Support Rod</td>
<td>1</td>
</tr>
<tr>
<td>J. Quick Release Lever Stud 6&quot;</td>
<td>1</td>
</tr>
<tr>
<td>K. Short Lever Arm</td>
<td>1</td>
</tr>
<tr>
<td>L. Idler Roller Guard</td>
<td>1</td>
</tr>
<tr>
<td>M. Idler Roller</td>
<td>1</td>
</tr>
<tr>
<td>N. Cast Iron Plate</td>
<td>1</td>
</tr>
<tr>
<td>O. Sanding Disc 9&quot;</td>
<td>1</td>
</tr>
<tr>
<td>P. Dust Port 2&quot; (Green)</td>
<td>1</td>
</tr>
</tbody>
</table>

## Hardware & Tools (not shown)

- Hex Wrench 4mm .................. 1
- Hex Bolts ¾"-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 ¾"-16 (Quick Release Lever) .... 2

## Box 2 (Figure 14)

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Q. Cabinet</td>
<td>1</td>
</tr>
<tr>
<td>R. Shelf</td>
<td>1</td>
</tr>
</tbody>
</table>

## Hardware (not shown)

- Hex Nuts 5/16"-18 (Cabinet) ........ 4
- Hex Bolts ¾"-18 x 1" (Cabinet).... 4
- Flat Washers 5/16" (Cabinet)........ 4
- Thumb Knobs ¾"-20 x ½" (Sander Unit).... 2
- Flat Washers ¾" (Sander Unit)........ 2
- Thumb Knobs M5-8 x 10 (Roller Guard).... 2
- Flat Washers #10 (Roller Guard)........ 2
- Lock Washers #10 (Roller Guard) .... 2

---

**NOTICE**

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

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

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

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

Before cleaning, gather the following:
- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

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

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

Site Considerations

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

Placement Location
Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See Figure 15 for the minimum working clearances.

Figure 15. Minimum working clearances.

NOTICE
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.
Anchoring to Floor

Number of Mounting Holes .......................... 4
Diameter of Mounting Hardware ................... 5/16”

We recommend mounting the Model G1014Z to the floor. Use machine mounts on the Model G1014ZX because the mounting holes cannot be accessed through the cabinet.

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you MUST follow the anchoring methodology specified by the code.

Assembly

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

For the Model G1014Z, begin assembly with Step 1. For the Model G1014ZX, begin assembly with Step 11.

To assemble machine:

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 5/16” flat washer, as shown in Figure 17.

2. Repeat Step 1 to install remaining feet on the other (3) legs.

3. Fasten (1) long upper and long lower brace to (2) 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 18. Finger tighten the fasteners for now.

Figure 16. Popular method for anchoring machinery to a concrete floor.

Figure 17. Foot fastened to bottom of a leg.
Note: Make sure the (2) short upper braces overlap the long upper braces and that the braces are placed inside the leg assemblies, as shown in Figure 20.

4. Repeat Step 3 to fasten the (2) remaining long upper and long lower braces to the remaining stand legs.

5. Fasten the (2) short upper braces and the (2) short lower braces to (1) of the leg assemblies with (8) 5/16"-18 x 1/2" carriage bolts, 5/16"-18 hex nuts, and 5/16" flat washers, as shown in Figure 19.

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

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 21.

7. Final tighten all the fasteners on the stand.

8. Tighten the hex nuts on the feet.
9. Place a level on top of the stand (see Figure 22) and adjust the stand if needed by shimming the feet so it is level from front-to-back and side-to-side.

**Figure 22.** Leveling stand.

10. Proceed to Step 16.

11. Place the cabinet flat on its side on a flat, protected surface, but do not lay it down on the switch or door handle.

12. 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.

13. Fasten each foot with a 5/16"-18 hex nut and 5/16" flat washer (see Figure 23).

**Figure 23.** Feet installed onto bottom of cabinet.

14. Place the stand upright on its feet, then place the shelf in the cabinet.

15. Place a level on top of the cabinet (see Figure 24) and adjust it level from front-to-back and side-to-side by shimming it.

**Figure 24.** Leveling cabinet.

16. With the help of an assistant, lift the sanding unit 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.

17. Secure the sanding unit to the stand or cabinet with (4) 5/16"-18 x 1/2" hex bolts and 5/16" flat washers, as shown in Figures 25–26.

**Figure 25.** G1014Z sander fastened to stand (view from underneath stand).
18. Slide the flat ends of the idler roller into the slots on the roller adjustment bars (see Figure 27).

19. Install (1) ¼”-20 x ½” thumb knob and (1) ¼” flat washer onto each side of sander behind idler roller (see Figure 27).

20. Loosen, but do not remove, the shaft set screws on the cast iron plate so they are backed out of the shaft hole and keyway (see Figure 28).

21. Align the keyway on the plate with the drive shaft key, then slide the plate onto the shaft, as shown in Figure 29.

22. Adjust the cast iron plate so it protrudes slightly (¼"-½") beyond the curved lip of the metal cover on both sides, as illustrated in Figure 30, to avoid the possibility of workpieces hitting the cover during sanding operations.

---

**Figure 26.** G1014ZX sander fastened to cabinet (2 of 4 hex bolts shown).

**Figure 27.** Idler roller installed.

**Figure 28.** Set screw locations on sanding disc plate.

**Figure 29.** Installing plate onto drive shaft.

**Figure 30.** Gap between plate and cover.
23. 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 31).

24. 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 32. Make sure the sanding disc adheres completely flat against the plate.

25. Install the 2½" black plastic dust port onto the pulley cover with (4) 10-24 x ¾" Phillips head screws, 10-24 hex nuts, and #10 flat washers, as shown in Figure 33.

26. Secure the pulley cover with the thumb knob.

27. Loosen the (2) set screws on the back of the base, slide the table support rod into the base, making sure the flat of the rod faces the set screws, then tighten the set screws, as shown in Figure 34. The rod should protrude about 6¼" from the side of the base.
28. Loosen the (2) set screws on the work table arm so their ends are flush with the inside of the opening, as shown in Figure 35.

29. Loosen the angle adjustment knob on the work table (see Figure 35), tilt the table to the 0° mark, then tighten the knob.

30. 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 36.

31. Using a ruler, adjust the edge of the work table approximately 1/16" away from the sanding disc on both sides (see Figure 37), then tighten the set screws on the work table arm.

Figure 35. Location of work table installation components.

Figure 36. Installing work table onto table support rod.

Figure 37. Correct distance between disc and work table.

— If the gap between the work table and the sanding disc is not the same on both sides, loosen one of the table mount bracket screws (see Figure 35), adjust the table as needed to even the gap, then tighten the screw.

⚠️ CAUTION
To reduce the risk of your fingers getting stuck between the work table and sanding disc, set the table no more than 1/16" away from the sanding disc.

32. Square the table to the sanding disc (refer to instructions on Page 47 for more details).
33. Install the 2" dust port onto the back of the sanding belt frame with the pre-installed \( \frac{1}{4}" \)-\( \frac{1}{2}" \) hex bolts and \( \frac{1}{4}" \) flat washers, as shown in Figure 38.

34. Assemble the quick release lever, as shown in Figure 39, using the handle, 6" quick release lever stud, short lever arm, and (2) \( \frac{3}{16}" \)-16 hex nuts.

35. Thread the assembly from Step 34 into the rocker arm, then tighten the hex nuts (see Figure 39).

36. 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 40).

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

38. Assemble idler roller guard with (2) M5-\( \frac{5}{8} \) x 10 thumb knobs, #10 lock washers, and #10 flat washers, then loosen thumb knobs behind idler roller, and install idler roller assembly (see Figure 41).
39. Adjust the inside edge of the idler roller guard ¼-½" away from the sanding belt (see Figure 42).

**Figure 42.** Correct distance between belt and idler roller guard.

40. 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.

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

42. **G1014ZX Only:** Connect the motor cord to the power cord on the cabinet (see Figure 43). DO NOT connect the sander to the power until indicated in the Test Run section on Page 30.

43. To set up the sanding belt in the vertical position, follow the instructions on Page 36.

44. Loosen the pre-installed 5/16"-18 x 1" hex bolt and flat washer on the side of the sanding belt frame, slide the back stop groove onto the bolt, then finger tighten the bolt.

45. Place a machinist's square flat against the sanding belt and back stop (see Figure 44) adjust the back stop flush with the square on both sides of the belt and ¼" above the belt (see Figure 45), then tighten the hex bolt.

**Figure 43.** Motor cord connected to power cord.

**Figure 44.** Adjusting back stop square to belt.

**Figure 45.** Correct clearance between back stop and belt.
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 MACHINE FROM POWER!

2. Loosen the lock nut on the tracking control knob (see Figure 4 on Page 4), then move the quick release tension lever to the tensioned position.

3. Standing in front of the sander, carefully 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 47.

5. Tighten the tracking control knob lock nut.

46. Place one edge of a machinist's square against the face of the miter gauge and the other against the sanding disc (see Figure 46) or sanding belt.

47. Loosen the lock knob on the miter gauge and adjust it flush with the edge of the square.

48. Tighten the lock knob and verify the setting.

   Note: Sometimes the tightening procedure can affect the adjustment.

49. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.

50. Retighten the screw that secures the angle pointer.

51. Repeat Steps 46–50 in a similar manner to calibrate the miter gauge to the belt if you set up the sander for vertical sanding.

Figure 46. Calibrating miter gauge with square.

Figure 47. Example of sanding belt centered on main roller.
Dust Collection

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

Recommended CFM at 2” Dust Port: 100
Recommended CFM at 2½” Dust Port: 150
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

The Model G1014Z/G1014ZX features a 2” dust port and a 2½” dust port that can be connected to a dust collector or a dust collection system, using the components shown in Figure 48.

Figure 48 shows a 2” dust hose connected to the dust collection port with a hose clamp.

Figure 49. Hose attached to 2” dust port.

Note: A tight fit is necessary for proper performance.

Figure 50 shows a 2½” dust hose attached to the dust port with a hose clamp. After installing the dust hoses on the two ports, tug the hoses to make sure they do not come off.

Figure 50. 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.
Test Run

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

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

The Test Run consists of verifying the following: 1) The belt tracks properly and will not come off the rollers during initial startup, 2) the motor powers up and runs correctly, and 3) the switch disabling key disables the switch properly.

4. 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. The motor should run smoothly and without unusual problems or noises.

   — If the motor *does not* run smoothly, turn the machine **OFF** and disconnect power. Contact technical support.

5. Loosen the lock nut on the tracking control knob, and carefully adjust the tracking in small increments until the sanding belt remains centered on the main roller (see Figure 47, Page 28).

6. When the tracking is correct, allow the sander to run for approximately one minute to verify that the tracking stays in the correct position.

7. When the sanding belt is tracking correctly, tighten the lock nut on the tracking control knob.

8. Turn the machine **OFF**, and remove the switch disabling key, as shown in Figure 51.

9. Try to turn 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.

moving sanding belts are dangerously abrasive. Use extreme caution when working near sanding surfaces.
SECTION 4: OPERATIONS

Operation Overview

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

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

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

1. Examines the workpiece to make sure it is suitable for sanding.

2. Inspects and installs a sanding belt/disc with appropriate the grit for the operation.

3. For sanding on the belt: Adjusts the platen tilt as desired (and the table/miter gauge, if used).

4. For sanding on the disc: Adjusts the table tilt and/or the miter gauge position to the desired location.

5. Secures any loose clothing, removes loose jewelry, and ties back long hair.

6. Puts on some safety glasses and a respirator. Takes all other required safety precautions.

7. Starts the dust collector, then turns the sander ON.

8. Holds the workpiece firmly against the back stop or the table and miter gauge (if used), pushes the workpiece into the sanding belt or along the down-spin of sanding disc, and moves the workpiece back and forth to wear the sandpaper evenly and prevent overheating.

9. Turns the sander OFF, then stops the dust collector.

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

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

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

- Extend the life of the sandpaper by regularly using PRO-STIK® abrasive belt cleaners (see Accessories on Page 42).
- When sanding workpieces with a bow or crown, place the high point up on the able to prevent the workpiece from rocking, then take very light passes.
- Hold workpiece securely with both hands and do not wear gloves. Use work table, miter gauge, and back stop whenever possible to support workpiece. Do not force workpiece against belt or disc.
- Sanding discs/belts clog and wear. Change sandpaper whenever you notice a difference in sanding quality/performance.
- To increase the life of the sanding disc/belt and ensure even wear, move the workpiece back and forth across the sanding surface.
- As a rule-of-thumb, sand with progressively higher grit numbers. A higher grit will achieve a finer finish.
- Make sure sanding belt and V-belt covers are closed and secured during operation.
- Avoid sanding a workpiece more than is necessary, since doing so will unnecessarily decrease belt life and cost you more money over time.

CAUTION

A moving belt or disc can cause serious personal injury if it comes in contact with your fingers, hands, or other body parts. Always support the workpiece against the table, back stop, or miter gauge when sanding. Use extreme care to provide a safe distance between sanding paper and any body part.

Choosing Sandpaper

The Model G1014Z/G1014ZX uses a 6" x 48" sanding belt and a 9" sanding disc. 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>
<th>Usage</th>
</tr>
</thead>
<tbody>
<tr>
<td>36</td>
<td>Extra Coarse</td>
<td>Rough sawn boards, thickness sanding, and glue removal.</td>
</tr>
<tr>
<td>60</td>
<td>Coarse</td>
<td>Thickness sanding and glue removal.</td>
</tr>
<tr>
<td>80–100</td>
<td>Medium</td>
<td>Removing marks and initial finish sanding.</td>
</tr>
<tr>
<td>120–180</td>
<td>Fine</td>
<td>Finish sanding.</td>
</tr>
</tbody>
</table>

We recommend using aluminum-oxide sanding belts and discs for best results. The grit you choose will depend on the condition and species of wood, and the level of finish you wish to achieve.

The general rule of thumb is to sand a workpiece with progressively higher grit numbers. Avoid skipping grits; the larger the grit increase at one time, 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.

Note: Sandpaper finer than 180-grit will easily load up or burn workpieces.
Workpiece Inspection

Some workpieces are not safe to sand 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 sanding natural and man-made wood products. This machine is NOT designed to sand metal, glass, stone, tile, plastics, drywall, cement backer board, laminate products, etc. Sanding improper materials increases risk of respiratory harm to operator and bystanders due to especially fine dust inherently created by all types of sanding operations—even if a dust collector is used. Additionally, life of machine and sanding belts/discs will be greatly reduced (or immediately damaged) from sanding improper materials or from exposure to fine dust created when doing so.

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear sanding belt or disc. Always visually inspect your workpiece for these items. If they cannot be removed, DO NOT sand the workpiece.

- **Wet or "Green" Stock:** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding belt or disc, increases the risk of kickback, and yields poor results.

- **Excessive Glue or Finish:** Sanding workpieces with excess glue or finish will load up the abrasive, reducing its usefulness and lifespan.

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 and Edge 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 52**).
2. Loosen the sanding frame rotation lock nuts (behind the sanding disc cover), rotate the frame to the horizontal position, as shown in Figure 53, then tighten the rotation lock nuts.

3. Insert the table support rod into the hole in the base under the sanding disc, and position the work table 1/16” away from the sanding disc, as shown in Figures 36–37 on Page 25.

4. Check that the miter gauge slot-sanding disc distance is correct (see instructions on Page 48 for further detail).

5. Install the back stop so it is square with and 1/16” above the sanding belt (see Figure 44 on Page 27).

Performing Horizontal and Edge Sanding
1. Use quick release tension lever to tension sanding belt.

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 back stop with both hands, and while keeping your fingers away from the belt, slowly feed the workpiece into the belt, as shown in Figures 54–55.

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

Figure 53. Table tilted to horizontal position.

Figure 54. Sanding workpiece in horizontal position.

Figure 55. Sanding edge of workpiece in horizontal position.

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

Contour sanding operations can be performed directly on the idler roller. Since the back stop cannot be used for these operations, support the workpiece against your workbench, if the workpiece is large enough. Always use two hands to control the workpiece.

To perform contour sanding:

1. Use quick release tension lever to tension sanding belt and refer to Tracking Belt on Page 41 to make sure belt is tracking correctly.

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

3. Turn the sander ON.

4. 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 56.

5. Install the idler roller guard.

---

Disc Sanding

The sanding disc can be used to create flat, smooth ends and edges of workpieces.

⚠️ CAUTION

To reduce the risk of your fingers getting trapped between the work table and sanding disc, make sure the table is no more than 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 MACHINE FROM POWER!

2. Adjust the angles of the work table and the miter gauge for your operation.

3. Connect the sander to power, turn it ON, and allow it to reach full speed.

4. Place the workpiece on the work table and firmly against the miter gauge.

5. With light pressure, slowly move the workpiece into the left side of the sanding disc. See Figures 57–60 for examples of disc sanding.

---

⚠️ WARNING

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

---

Figure 56. Example of contour sanding.

Figure 57. Example of 90° disc sanding.

Model G1014Z/G1014ZX (Mfd. Since 08/22)
Vertical Sanding

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

Setting Up Sander for Vertical Sanding
1. Make sure the sanding belt is tensioned—if it is not already tight.
2. Make sure the belt tracking is correctly set (see Tracking Belt on Page 41).
3. DISCONNECT MACHINE FROM POWER!
4. Remove the back stop and miter gauge from the work table.
5. Loosen the sanding frame rotation lock nuts (behind the sanding disc cover) as shown in Figures 61–62.

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.
6. Raise the sanding belt frame until it reaches the 90° mark (or the desired angle) on the tilt scale, as shown in Figure 63, then tighten the rotation lock nuts.

![Figure 63. Sanding belt tilted to 90° position.](image)

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 64.

![Figure 64. Work table installed for vertical sanding.](image)

9. Adjust the front of the work table 1/16” away from the sanding belt (see Figure 65) across its entire length.

![Figure 65. Correct distance between work table and sanding belt.](image)

— If the gap is not 1/16” across the entire length of the work table, loosen one or both of the screws under the table (see Figure 66), where the arm is attached to the table, and adjust the table until the distance is correct, then tighten the screws.

![Figure 66. Location of work table arm mounting screws.](image)

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 67, and check for gaps between the square, belt, and table.

Figure 67. Squaring table and sanding belt.

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

12. 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 68–71 for examples of horizontal belt sanding.

Figure 68. Example of end grain sanding.

Figure 69. Example of vertical miter sanding.

Figure 70. Example of vertical face and edge sanding.

Figure 71. 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 MACHINE 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 72.

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 73).

7. Adjust the sanding belt tension for new belt (refer to Adjusting Sanding Belt Tension on Page 40).

8. Install the back stop and adjust it so it is no more than $\frac{1}{16}$" above the belt (see Figure 74).

9. Perform the belt pre-tracking procedure (refer to Pre-Tracking Belt on Page 28).

Adjusting 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 are replacing a worn sanding belt with a new one, the belt tension will likely need to be loosened.

**Tools Needed**

- Wrench 14mm .................................................... 1
- Adjustable Wrench w/1½" Throat ......................... 1

**To adjust sanding belt tension:**

1. DISCONNECT MACHINE FROM POWER!

2. Move the quick release tension lever toward the motor to tighten the sanding belt.

3. Turn the eccentric shown in Figure 75 to tighten or loosen the belt.

4. Push the belt in the center with your finger using moderate pressure. The deflection is correct when the belt deflects ½", as shown in Figure 76.

5. Follow the Pre-Tracking Belt instructions on Page 28.

6. 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).

*Figure 75. Location of belt tension eccentric (belt removed for clarity).*

*Figure 76. Checking sanding belt tension.*
Tracking Belt

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

To track the belt:

1. Pre-track the belt according to Pre-Tracking Belt on Page 28.

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. Loosen the lock nut on the belt tracking knob.

4. Turn the sander ON, and using the tracking control knob (see Figure 77), carefully adjust the tracking in or out until the sanding belt is centered on the main roller (see Figure 47, Page 28).

![Tracking Control Knob](Image)

**Figure 77.** Tracking control knob.

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

5. Tighten the belt tracking knob lock nut.

Changing Sanding Disc

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

To change the sanding disc:

1. DISCONNECT MACHINE 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, install the lock knob, then install the work table and miter gauge.
SECTION 5: ACCESSORIES

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

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

**PRO-STIK® Abrasive Surface Cleaners**
Extend the life of your abrasive belts! Choose the PRO-STIK® 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>W1306</td>
<td>1½&quot; x 1½&quot; x 8½&quot;</td>
</tr>
<tr>
<td>W1307</td>
<td>2&quot; x 2&quot; x 12&quot;</td>
</tr>
<tr>
<td>W1308</td>
<td>1½&quot; x 1½&quot; x 9&quot; with Handle</td>
</tr>
<tr>
<td>W1309</td>
<td>2&quot; x 2&quot; x 11&quot; with Handle</td>
</tr>
</tbody>
</table>

Figure 78. PRO-STIK® abrasive cleaners.

**9" PSA Aluminum Oxide Sanding Discs**
Our aluminum oxide sanding discs are manufactured in ISO 9002 factories to ensure the highest quality and are available in packs of two.

<table>
<thead>
<tr>
<th>Grit</th>
<th>Model</th>
</tr>
</thead>
<tbody>
<tr>
<td>60 Grit</td>
<td>D1321</td>
</tr>
<tr>
<td>80 Grit</td>
<td>D1322</td>
</tr>
<tr>
<td>100 Grit</td>
<td>D1323</td>
</tr>
<tr>
<td>120 Grit</td>
<td>D1324</td>
</tr>
<tr>
<td>150 Grit</td>
<td>D1325</td>
</tr>
<tr>
<td>180 Grit</td>
<td>D1326</td>
</tr>
<tr>
<td>220 Grit</td>
<td>D1327</td>
</tr>
</tbody>
</table>

Figure 79. 9" Sandpaper discs.

**6" x 48" Aluminum Oxide Sanding Belts**
Our aluminum oxide sanding belts are sized right for all of your belt sanding needs and are sold in packs of 10.

<table>
<thead>
<tr>
<th>Grit</th>
<th>Model</th>
</tr>
</thead>
<tbody>
<tr>
<td>60 Grit</td>
<td>H3515</td>
</tr>
<tr>
<td>80 Grit</td>
<td>H3516</td>
</tr>
<tr>
<td>100 Grit</td>
<td>H3517</td>
</tr>
<tr>
<td>120 Grit</td>
<td>H3518</td>
</tr>
<tr>
<td>150 Grit</td>
<td>H3519</td>
</tr>
<tr>
<td>180 Grit</td>
<td>H3520</td>
</tr>
<tr>
<td>220 Grit</td>
<td>H3521</td>
</tr>
</tbody>
</table>

Figure 80. Assortment of sanding belts.

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

Model G1014Z/G1014ZX (Mfd. Since 08/22)
Cleaning the Model G1014Z/G1014ZX is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

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

G5562—SLIPIT® 1 Qt. Gel  
G5563—SLIPIT® 12 Oz. Spray  
G2870—Boeshield® T-9 4 Oz. Spray  
G2871—Boeshield® T-9 12 Oz. Spray  
H3788—G96® Gun Treatment 12 Oz. Spray

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

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**SECTION 6: MAINTENANCE**

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**WARNING**

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

---

**Schedule**

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

**Ongoing**

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

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

**After Each Use**

- Clean any shavings and dust from between platen and belt.
- Sweep surrounding dust and shavings.
- Clean/protect table.

**Weekly Maintenance**

- Sweep or vacuum dust and shavings from inside belt compartment and inside machine base.

**Monthly Check**

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

**Annually**

- Check and lubricate rocker plate.
Cleaning Sanding Belt/Disc

Using an abrasive belt/disc cleaner can prolong the life of a clogged sanding belt/disc, provided it is in otherwise good condition. See Accessories on Page 42 for more details.

To clean the sanding belt/disc:

1. Turn the machine **ON**.

2. Using the back stop or work table as support, rub the abrasive cleaner on the sanding belt/disc in a continuous motion, covering the entire surface of the belt/disc until the belt/disc is no longer clogged.

3. Turn the machine **OFF**.

Lubrication

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

Table Support Rod

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

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

Figure 82. Table support rod lubrication.

Rocker Plate

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

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

Figure 83. Rocker plate lubrication.
## SECTION 7: SERVICE

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

### Troubleshooting

#### Motor & Electrical

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
</table>
| Machine does not start, or power supply breaker immediately trips after startup. | 1. Switch disabling key removed.  
2. Motor cord not connected to power cord (G1014ZX only).  
3. Incorrect power supply voltage or circuit size.  
4. Plug/receptacle at fault/wired wrong.  
5. Power supply circuit breaker tripped or fuse blown.  
6. Motor wires connected incorrectly.  
7. Start capacitor at fault.  
8. Centrifugal switch adjustment/contact points at fault.  
9. Wiring broken, disconnected, or corroded.  
10. ON/OFF switch at fault.  
11. Motor or motor bearings at fault. | 1. Install switch disabling key.  
2. Connect motor cord to power cord (G1014ZX).  
3. Ensure correct power supply voltage and circuit size (Page 12).  
4. Test for good contacts; correct the wiring (Page 51).  
5. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.  
6. Correct motor wire connections (Page 51).  
7. Test/replace if at fault.  
8. Adjust centrifugal switch/clean contact points. Replace either if at fault.  
9. Fix broken wires or disconnected/corroded connections (Page 51).  
10. Replace switch.  
11. Replace motor. |
| Machine stalls or is underpowered.                            | 1. Workpiece material unsuitable for machine.  
2. V-belt slipping/pulleys misaligned.  
3. Motor wires connected incorrectly.  
4. Plug/receptacle at fault/wired wrong.  
5. Pulley slipping on shaft.  
7. Motor overheated.  
8. Extension cord too long.  
9. Centrifugal switch/contact points at fault.  
10. Motor or motor bearings at fault. | 1. Only sand wood/ensure moisture is below 20% (Page 33).  
2. Clean/replace V-belt (Page 50); ensure pulleys are aligned (Page 50).  
3. Correct motor wire connections (Page 51).  
4. Test for good contacts; correct the wiring (Page 51).  
5. Tighten/replace loose pulley/shaft.  
6. Clean (Page 44)/replace sanding belt (Page 39)/disc (Page 41); reduce feed rate/sanding depth.  
7. Clean motor, let cool, and reduce workload.  
8. Move machine closer to power supply; use shorter extension cord.  
9. Adjust centrifugal switch/clean contact points. Replace either if at fault.  
10. Replace motor. |
| Machine has vibration or noisy operation.                     | 1. Motor or component loose.  
2. Stand feet not adjusted/attached properly.  
3. V-belt worn, loose, pulleys misaligned, or belt slapping cover.  
4. Pulley loose.  
5. Motor mount loose/broken. | 1. Replace damaged or missing bolts/nuts or tighten if loose.  
2. Adjust/re-install stand feet to stabilize machine.  
4. Secure pulley on shaft.  
5. Tighten/replace. |
### Motor & Electrical (Cont.)

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine has vibration or noisy operation.</td>
<td>6. Sanding disc out of balance or loose.</td>
<td>6. Tighten disc hub or replace disc.</td>
</tr>
<tr>
<td></td>
<td>7. Motor fan rubbing on fan cover.</td>
<td>7. Fix/replace fan cover; replace loose/damaged fan.</td>
</tr>
<tr>
<td></td>
<td>10. Work table support rod rubbing on motor.</td>
<td>10. Adjust table support rod.</td>
</tr>
</tbody>
</table>

### Operation

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sanding belt slaps or vibrates excessively.</td>
<td>1. Sanding belt not tensioned properly.</td>
<td>1. Tension sanding belt (<a href="#">Page 40</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Sanding belt tracking needs adjustment.</td>
<td>2. Adjust sanding belt tracking (<a href="#">Page 41</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Sanding belt is stretched unevenly, worn, or damaged.</td>
<td>3. Replace sanding belt (<a href="#">Page 39</a>).</td>
</tr>
<tr>
<td></td>
<td>4. Sanding belt roller is loose.</td>
<td>4. Tighten sanding belt roller.</td>
</tr>
<tr>
<td>Sanding belt will not track properly.</td>
<td>1. Sanding belt is not tensioned properly.</td>
<td>1. Tension sanding belt (<a href="#">Page 40</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Sanding belt is stretched unevenly, worn, or damaged.</td>
<td>2. Replace sanding belt (<a href="#">Page 39</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Sanding belt roller is worn.</td>
<td>3. Replace sanding belt roller.</td>
</tr>
<tr>
<td>Sanding belt slips during use.</td>
<td>1. Sanding belt is not tensioned properly.</td>
<td>1. Tension sanding belt (<a href="#">Page 40</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Excessive workpiece pressure.</td>
<td>2. Reduce workpiece pressure.</td>
</tr>
<tr>
<td></td>
<td>3. V-belt is worn or not tensioned properly.</td>
<td>3. Inspect/tension V-belt (<a href="#">Page 49</a>).</td>
</tr>
<tr>
<td>Belts/discs clog quickly or excessive sanding belt/disc replacement.</td>
<td>1. Sanding wet stock.</td>
<td>1. Only sand wood/ensure moisture is below 20% (<a href="#">Page 33</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Excessive workpiece pressure.</td>
<td>3. Reduce workpiece pressure.</td>
</tr>
<tr>
<td></td>
<td>4. Using too fine of sanding grit.</td>
<td>4. Use coarser grit sandpaper (<a href="#">Page 32</a>).</td>
</tr>
<tr>
<td></td>
<td>5. Sanding softwood.</td>
<td>5. Use different stock or accept characteristics and plan on frequently cleaning (<a href="#">Page 44</a>)/replacing sanding belt (<a href="#">Page 39</a>)/disc (<a href="#">Page 41</a>).</td>
</tr>
<tr>
<td>Deep sanding grooves or scars in workpiece.</td>
<td>1. Not using full width of sanding surface.</td>
<td>1. Move workpiece back and forth across sanding surface.</td>
</tr>
<tr>
<td></td>
<td>2. Workpiece sanded across grain.</td>
<td>2. Sand workpiece with grain.</td>
</tr>
<tr>
<td></td>
<td>3. Excessive workpiece pressure.</td>
<td>3. Reduce workpiece pressure.</td>
</tr>
<tr>
<td></td>
<td>4. Sandpaper too coarse for desired finish.</td>
<td>4. Use finer grit sandpaper (<a href="#">Page 32</a>).</td>
</tr>
<tr>
<td>Burn marks on workpiece.</td>
<td>1. Not using full width of sanding surface.</td>
<td>1. Move workpiece back and forth across sanding surface.</td>
</tr>
<tr>
<td></td>
<td>2. Excessive workpiece pressure.</td>
<td>2. Reduce workpiece pressure.</td>
</tr>
<tr>
<td></td>
<td>3. Using too fine of sanding grit.</td>
<td>3. Use coarser grit sandpaper (<a href="#">Page 32</a>).</td>
</tr>
<tr>
<td></td>
<td>4. Sanding belt/disc clogged/worn.</td>
<td>4. Clean (<a href="#">Page 44</a>)/replace sanding belt (<a href="#">Page 39</a>)/disc (<a href="#">Page 41</a>).</td>
</tr>
<tr>
<td>Snake-shaped marks on workpiece.</td>
<td>1. Sanding belt/disc dirty/damaged.</td>
<td>1. Clean (<a href="#">Page 44</a>)/replace sanding belt (<a href="#">Page 39</a>)/disc (<a href="#">Page 41</a>).</td>
</tr>
<tr>
<td>Glazed sanding surfaces.</td>
<td>1. Sanding wet stock.</td>
<td>1. Only sand wood/ensure moisture is below 20% (<a href="#">Page 33</a>).</td>
</tr>
</tbody>
</table>
### Symptom, Possible Cause, Possible Solution

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Glazed sanding surfaces.</td>
<td>2. Sanding stock with high pitch/residue.</td>
<td>2. Use different stock or accept characteristics and plan on frequently cleaning (Page 44)/replacing sanding belt (Page 39)/disc (Page 41).</td>
</tr>
<tr>
<td></td>
<td>3. Sanding belt/disc worn or filled with pitch/residue.</td>
<td>3. Replace sanding belt (Page 39)/disc (Page 41).</td>
</tr>
<tr>
<td>Poor, non-aggressive sanding results.</td>
<td>1. Using too fine of sanding grit.</td>
<td>1. Use coarser grit sandpaper (Page 32).</td>
</tr>
<tr>
<td></td>
<td>2. Sanding belt/disc clogged/worn.</td>
<td>2. Clean (Page 44)/replace sanding belt (Page 39)/disc (Page 41).</td>
</tr>
<tr>
<td>Abrasive grit rubs off easily.</td>
<td>1. Sanding belt/disc has been stored in an incorrect environment.</td>
<td>1. Replace sanding belt (Page 39)/disc (Page 41).</td>
</tr>
<tr>
<td></td>
<td>2. Sanding belt/disc has been folded or crushed.</td>
<td>2. Replace sanding belt (Page 39)/disc (Page 41). Do not bend or fold belt/disc.</td>
</tr>
<tr>
<td>Workpiece not sanded square when table is set to 90°.</td>
<td>1. Table is not square to sanding belt/disc.</td>
<td>1. Calibrate table tilt (this page).</td>
</tr>
<tr>
<td>Workpiece not sanded square when miter gauge is set to 90°.</td>
<td>1. Miter gauge body is not square to miter bar.</td>
<td>1. Calibrate miter gauge scale (Page 48).</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>
</tbody>
</table>

### Squaring Work Table to Sanding Belt/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 work table to the sanding belt/disc:

1. **DISCONNECT MACHINE FROM POWER!**

2. Place a machinist's square or other 90° measuring tool against the work table and sanding belt/disc (see Figure 84).

3. Loosen the table lock knob, adjust the table square with the sanding belt/disc, then retighten 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 retighten the screw.
Adjusting Miter Slot-Belt/Disc Parallelism

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

Tools Needed

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

To adjust the miter slot parallel with the sanding belt/disc:

1. DISCONNECT MACHINE FROM POWER!

2. Remove the miter gauge, then place a combination square with the 90º square in the miter slot, as shown in Figure 85.

3. Slide the square to the other side and check to see if the distance from the slot to the sanding belt/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 66 on Page 37) that secure the work table arm to the work table and adjust the table so it is approximately 1/8" away from the sanding belt/disc across its entire length.

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

Calibrating Miter Gauge

Calibrate the miter gauge if the angle of sanded workpieces does not match what the miter gauge scale indicates.

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 86) 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 0º mark on the scale.

5. Retighten the screw that secures the angle pointer.

Figure 85. Checking miter slot parallelism (sanding disc shown).

Figure 86. Calibrating miter gauge with square.
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>

Tools Needed

Tensioning V-Belt

1. DISCONNECT MACHINE 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 31 on Page 24), 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 87.

   — 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.

6. Loosen the (4) hex bolts that secure the motor to the base, as shown in Figures 88–89, then slide the motor toward the back of the sander to reduce belt tension or slide it toward the front of the sander to increase tension.

   Figure 88. Rear motor mounting bolts.

   Figure 89. Front motor mounting bolts.

7. Tighten the (4) 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 87. Checking belt tension.
Replacing V-Belt

1. **DISCONNECT** MACHINE FROM POWER!


3. Loosen the (4) hex bolts that secure the motor to the base, as shown in Figures 88–89 on Page 49, 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 (4) hex bolts on the motor base.

6. Repeat Step 5 on Page 49 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.

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**

- Hex Wrench 4mm................................. 1
- Straightedge 12"................................. 1
- Standard Screwdriver.......................... 1

To check and adjust pulley alignment:

1. **DISCONNECT** MACHINE 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 90.

---

![Figure 90. Checking pulley alignment.](image)

---

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

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

6. Loosen the set screw on the pulley where you noticed the gap, then adjust the pulley so it touches the bottom of the straightedge when it is extended across both pulleys, as shown in Figure 90.

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.
SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

COLOR KEY

BLACK  [B]  BLUE  [B]  YELLOW  [Y]
RED  [R]  ORANGE  [O]  PINK  [P]

G1014Z Wiring Diagram

**MOTOR (Prewired 110V)**

- Hot
- Neutral
- Ground

**MOTOR (Wired 220V)**

- Hot
- Neutral
- Ground

5-15 PLUG (Included)

- 110V
- Ground
- Neutral
- Hot

6-15 PLUG (As Recommended)

- 220V
- Ground
- Hot
- Hot

PADDLE SWITCH

KEDU HY18
t (viewed from behind)

**Figure 91.** G1014Z 110V motor wiring.

**Figure 92.** G1014Z switch wiring.

- **5-15 PLUG**
- **6-15 PLUG**
- **Ground**
- **Neutral**
- **Hot**
G1014ZX Wiring Diagram

MOTOR (Prewired 110V)

MOTOR (Wired 220V)

PADDLE SWITCH
KEDU HY18
(viewed from behind)

5-15 PLUG
(Included)

6-15 PLUG
(As Recommended)

Figure 93 G1014ZX motor wiring.

Figure 94. G1014ZX switch wiring.
SECTION 9: PARTS

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

G1014Z Main

BUY PARTS ONLINE AT GRIZZLY.COM!
Scan QR code to visit our Parts Store.
<table>
<thead>
<tr>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>P1014Z001</td>
<td>DUST COVER</td>
<td>51</td>
<td>P1014Z051</td>
<td>HEX NUT 10-24</td>
</tr>
<tr>
<td>2</td>
<td>P1014Z002</td>
<td>EXT Retaining Ring 12MM</td>
<td>52</td>
<td>P1014Z052</td>
<td>BASE</td>
</tr>
<tr>
<td>3</td>
<td>P1014Z003</td>
<td>BALL BEARING 6201-2RS</td>
<td>53A</td>
<td>P1014Z053A</td>
<td>SAFETY PADDLE SWITCH</td>
</tr>
<tr>
<td>4</td>
<td>P1014Z004</td>
<td>DRIVER ROLLER SHAFT</td>
<td>56</td>
<td>P1014Z056</td>
<td>HEX NUT 5/8-11</td>
</tr>
<tr>
<td>5</td>
<td>P1014Z005</td>
<td>SANDING BELT 6&quot; X 48&quot; A60 (2-PC)</td>
<td>57</td>
<td>P1014Z057</td>
<td>HEX BOLT 5/8-11 X 9</td>
</tr>
<tr>
<td>6</td>
<td>P1014Z006</td>
<td>KEY 5 X 5 X 55</td>
<td>59</td>
<td>P1014Z059</td>
<td>IDLER SHAFT V3.08.97</td>
</tr>
<tr>
<td>7</td>
<td>P1014Z007</td>
<td>EXT Retaining Ring 15MM</td>
<td>62B</td>
<td>P1014Z062B</td>
<td>ROLLER ADJUST BAR</td>
</tr>
<tr>
<td>8</td>
<td>P1014Z008</td>
<td>SANDING BELT FRAME</td>
<td>64</td>
<td>P1014Z064</td>
<td>IDLER ROLLER V3.08.97</td>
</tr>
<tr>
<td>9</td>
<td>P1014Z009</td>
<td>BACK STOP</td>
<td>69</td>
<td>P1014Z069</td>
<td>MITER BODY</td>
</tr>
<tr>
<td>10</td>
<td>P1014Z010</td>
<td>SET SCREW 5/16-18 X 3/8</td>
<td>70</td>
<td>P1014Z070</td>
<td>TILT SCALE</td>
</tr>
<tr>
<td>11</td>
<td>P1014Z011</td>
<td>DRIVE ROLLER</td>
<td>71</td>
<td>P1014Z071</td>
<td>POWER CORD 16G 3W 73&quot; 5-15P</td>
</tr>
<tr>
<td>12</td>
<td>P1014Z012</td>
<td>HEX NUT 5/16-18</td>
<td>77</td>
<td>P1014Z077</td>
<td>HEX WRENCH 4MM</td>
</tr>
<tr>
<td>13</td>
<td>P1014Z013</td>
<td>FLAT WASHER 5/16</td>
<td>80</td>
<td>P1014Z080</td>
<td>KEY 5 X 5 X 40</td>
</tr>
<tr>
<td>14</td>
<td>P1014Z014</td>
<td>KNOB 5/16-18</td>
<td>81A</td>
<td>P1014Z081A</td>
<td>ROCKER PLATE</td>
</tr>
<tr>
<td>15</td>
<td>P1014Z015</td>
<td>BALL BEARING 6202-2RS W/SNAP RING</td>
<td>82A</td>
<td>P1014Z082A</td>
<td>SHORT LEVER</td>
</tr>
<tr>
<td>16</td>
<td>P1014Z016A</td>
<td>COMPLETE MITER GAUGE ASSY</td>
<td>83A</td>
<td>P1014Z083A</td>
<td>ROCKER ARM</td>
</tr>
<tr>
<td>17</td>
<td>P1014Z017</td>
<td>BUSHING 15 X 19.4 X 12MM</td>
<td>84A</td>
<td>P1014Z084A</td>
<td>ECCENTRIC</td>
</tr>
<tr>
<td>18</td>
<td>P1014Z018</td>
<td>CARRIAGE BOLT 5/16-18 X 1-1/2</td>
<td>85A</td>
<td>P1014Z085A</td>
<td>LONG LEVER</td>
</tr>
<tr>
<td>19</td>
<td>P1014Z019</td>
<td>PULLEY COVER W/DUST PORT V2.07.00</td>
<td>86A</td>
<td>P1014Z086A</td>
<td>KNOB 3/8-16</td>
</tr>
<tr>
<td>20</td>
<td>P1014Z020</td>
<td>MITER BAR</td>
<td>87A</td>
<td>P1014Z087A</td>
<td>SPACER</td>
</tr>
<tr>
<td>21</td>
<td>P1014Z021</td>
<td>CAST IRON DISC V2.02.97</td>
<td>88A</td>
<td>P1014Z088A</td>
<td>HEX BOLT 3/8-16 X 3/4</td>
</tr>
<tr>
<td>22</td>
<td>P1014Z022</td>
<td>SANDING DISC 9&quot; A60 PSA (2-PC)</td>
<td>89</td>
<td>P1014Z089</td>
<td>CAP SCREW 10-24 X 5/8</td>
</tr>
<tr>
<td>23</td>
<td>P1014Z023</td>
<td>TABLE</td>
<td>90</td>
<td>P1014Z090</td>
<td>MOTOR CORD 16G 3W 12&quot;</td>
</tr>
<tr>
<td>24</td>
<td>P1014Z024</td>
<td>TRUNNION</td>
<td>91</td>
<td>P1014Z091</td>
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### G1014Z Labels & Cosmetics

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<tr>
<td>48 P1014ZX048</td>
<td>EXT TOOTH WASHER #10</td>
<td>74 P1014ZX074</td>
<td>CABINET DOOR</td>
</tr>
<tr>
<td>49 P1014ZX049</td>
<td>STRAIN RELIEF M14 TYPE-1 SNAP-IN</td>
<td>75V2 P1014ZX075V2</td>
<td>DOOR LATCH SYSTEM V2.11.13</td>
</tr>
<tr>
<td>51 P1014ZX051</td>
<td>HEX NUT 10-24</td>
<td>76 P1014ZX076</td>
<td>SHELF</td>
</tr>
<tr>
<td>53 P1014ZX053</td>
<td>SAFETY PADDLE SWITCH</td>
<td>78 P1014ZX078</td>
<td>SWITCH HOUSING</td>
</tr>
<tr>
<td>55 P1014ZX055</td>
<td>PADDLE SWITCH KEY</td>
<td>118 P1014ZX118</td>
<td>TAP SCREW #5 X 3/8</td>
</tr>
</tbody>
</table>
G1014ZX Labels & Cosmetics

![Image of G1014ZX Labels & Cosmetics]

### Specifications

- **Motor**: 3/4 HP, 110V/220V, 1-Phase, 60 Hz
- **Prewired Voltage**: 110V
- **Full Load Amps**: 12A (110V); 6A (220V)
- **Belt Arm Tilt**: 0–90°
- **Sanding Belt Size**: 6" x 48"
- **Sanding Belt Speed**: 1900 FPM
- **Table Tilt**: 0–45°
- **Sanding Disc Diameter**: 9"
- **Sanding Disc Speed**: 2420 RPM
- **Weight**: 117 lbs.

**Mfd. for Grizzly in Taiwan**

### Safety Labels

- **MACHINE ID LABEL** V2.08.22
- **MODEL NUMBER LABEL**
- **Z-SERIES LABEL**
- **COMBO WARNING LABEL** V2.08.22
- **ELECTRICITY LABEL** V2.08.22

### WARNING

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

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

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

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

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

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

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

To take advantage of this warranty, you must register it at https://www.grizzly.com/forms/warranty, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.
Visit Our Website Today For Current Specials!

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