

Grizzly ***Industrial, Inc.***®

MODEL T32459 **2" X 42" KNIFE-MAKING** **BELT SANDER/GRINDER** **OWNER'S MANUAL** *(For models manufactured since 12/23)*



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OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
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V2.04.24

******Keep for Future Reference******



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

WARNING

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

CAUTION

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



Manual Accuracy

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

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

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

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

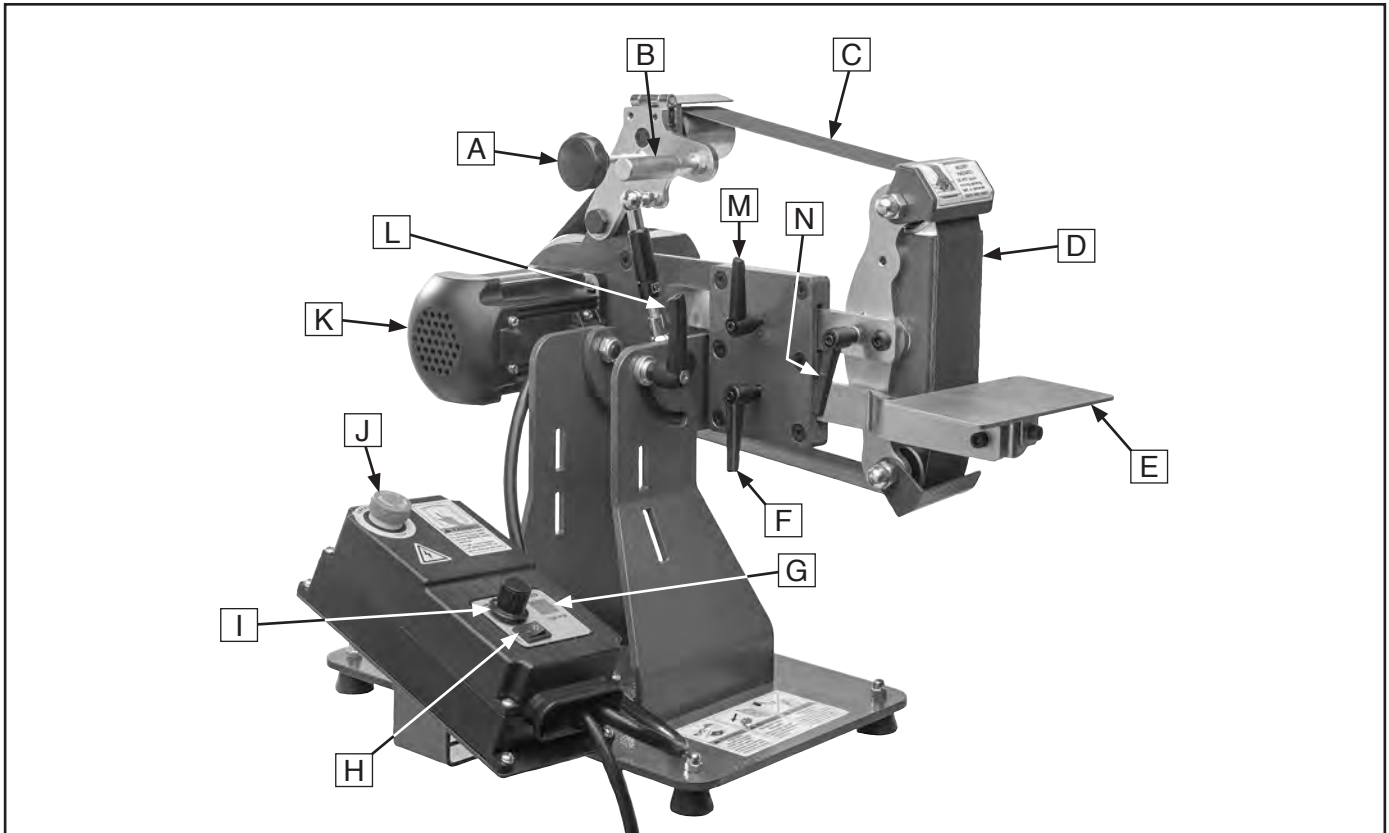
		MODEL GXXXX MACHINE NAME
SPECIFICATIONS		 WARNING!
Motor:	To reduce risk of serious injury when using this machine:	
Specification:	Manufacture Date	1. Read manual before operation.
Specification:		2. Wear safety glasses and respirator.
Specification:		3. Make sure safety glasses and respirator are properly adjusted/setup and
Weight:		4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.
		5. DO NOT expose to rain or dampness.
		6. DO NOT modify this machine in any way.
		7.
		8.
		9. Do not use while under the influence of drugs or alcohol.
		10. Maintain machine carefully to prevent accidents.

Manufactured for Grizzly in Taiwan



Identification

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



- | | |
|--------------------------------|----------------------------|
| A. Belt Tracking Knob | H. ON/OFF Switch |
| B. Belt Tension Handle | I. Variable-Speed Dial |
| C. Abrasive Belt | J. EMERGENCY STOP Button |
| D. Platen | K. Motor |
| E. Tool Rest | L. Frame Tilt Lock Handle |
| F. Tool Rest Lock Handle | M. Platen Lock Handle |
| G. Motor Speed Digital Readout | N. Platen Tilt Lock Handle |

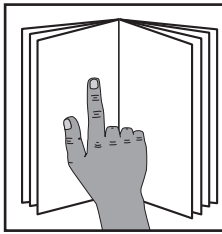
⚠️ WARNING

For Your Own Safety Read Instruction Manual Before Operating Sander

- a) **Wear eye protection.**
- b) **Support workpiece with tool rest.**
- c) **Maintain $\frac{1}{16}$ in. maximum clearance between tool rest and abrasive belt.**



Controls & Components



⚠️ WARNING

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

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

Grinding Components

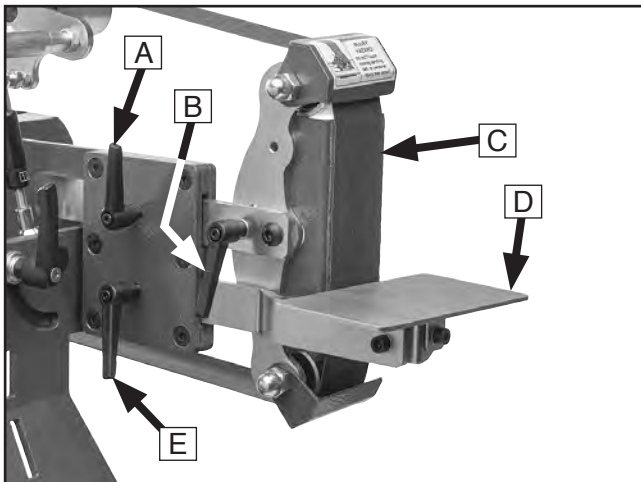


Figure 1. Platen and tool rest components.

Note: *The handles on this machine are adjustable. If movement of handle is obstructed, pull handle away from handle shaft to reposition it as needed.*

- A. **Platen Lock Handle:** Loosen to adjust platen position and tighten to secure.
- B. **Platen Tilt Lock Handle:** Loosen to adjust platen angle and tighten to secure.
- C. **Platen:** Provides flat surface belt support.
- D. **Tool Rest:** Supports workpiece.
- E. **Tool Rest Lock Handle:** Loosen to remove tool rest or adjust tool rest position relative to platen and tighten to secure.

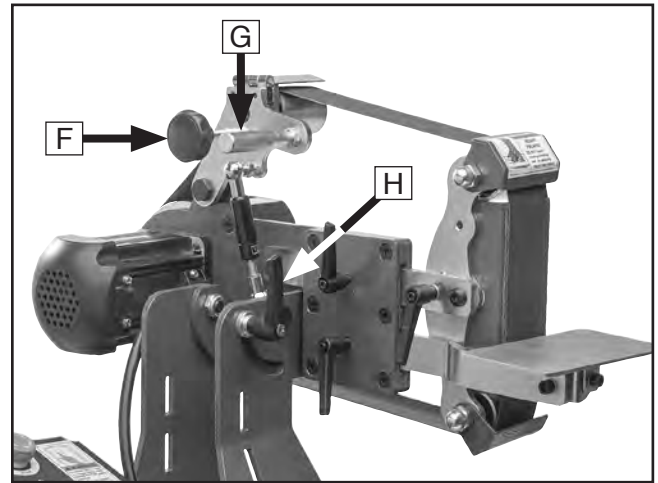


Figure 2. Additional adjustment components.

- F. **Belt Tracking Knob:** Fine-tunes belt tracking along platen and wheels.
- G. **Belt Tension Handle:** Compresses gas strut to release belt tension.
- H. **Frame Tilt Lock Handle:** Loosen to adjust frame angle and tighten to secure.

Power Controls

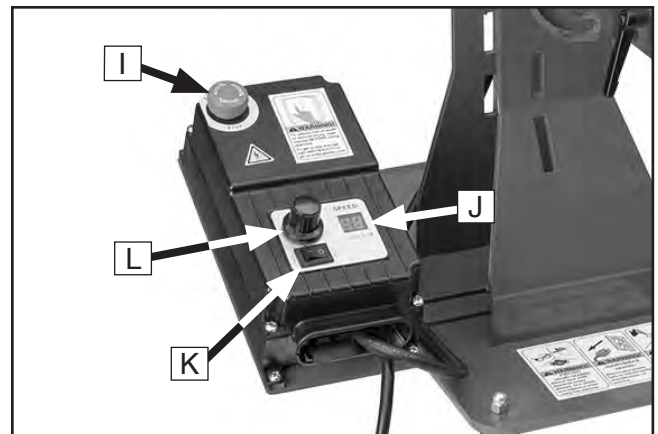


Figure 3. Power controls.

- I. **EMERGENCY STOP Button:** Turns machine **OFF** when pressed. Twist clockwise to reset.
- J. **Motor Speed Digital Readout:** Displays current motor speed at 100 RPM intervals.
- K. **ON/OFF Switch:** Turns machine **ON** and **OFF**.
- L. **Variable-Speed Dial:** Rotates to adjust motor and belt speed.





MACHINE DATA SHEET

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

MODEL T32459 2" X 42" KNIFE-MAKING BELT SANDER/GRINDER

Product Dimensions:

Weight..... 38 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 15-1/2 x 19 x 18 in.
Footprint (Length x Width)..... 14 x 9-1/2 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 42 lbs.
Length x Width x Height..... 16 x 11 x 15 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Full-Load Current Rating..... 7.8A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Rocker ON/OFF Switch

Motors:

Main

Horsepower..... 3/4 HP
Phase..... Single-Phase
Amps..... 7.8A
Speed..... 100 - 3200 RPM
Type..... Brushless DC
Power Transfer Direct
Bearings..... Shielded & Permanently Lubricated



Belt Sander Info

Sanding Belt Width.....	2 in.
Sanding Belt Length.....	42 in.
Sanding Belt Speed.....	131 - 4189 FPM
Sanding Belt Tilt.....	0 - 90 deg.
Table Length.....	4-7/8 in.
Table Width.....	2-1/2 in.
Table Thickness.....	1/8 in.
Table Tilt.....	Left 5, Right 120 deg.
Drive Wheel Diameter.....	5 in.
Drive Wheel Width.....	2 in.
Belt Tension Release Type.....	Quick-Release
Platen Type.....	Graphite-Coated
Platen Length.....	5-1/2 in.
Platen Width.....	2-1/4 in.
Idler Wheel Diameter.....	1-1/2 in.
Idler Wheel Width.....	2 in.

Construction

Base.....	Steel
Frame.....	Steel
Paint/Finish.....	Powder Coated

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	15 Minutes
Serial Number Location	Machine ID Label

Features:

- 2" x 42" 120-Grit Silicon Carbide Belt Included
- Frame Pivots 90 Deg. for Vertical or Horizontal Grinding
- Platen Tilts 30 Deg. Left/Right on Frame
- Tool Rest Adjusts for Vertical and Horizontal Grinding
- Gas Strut Quick-Release Belt Tension
- Variable-Speed Motor and Belt Speed
- Graphite-Coated Platen
- Aluminum Drive and Idler Wheels

Accessories Included:

- Combo Wrench 10mm
- Open-End Wrench 12 x 14mm
- Hex Wrenches 1/8", 3/16"



SECTION 1: SAFETY

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

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



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



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



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

NOTICE

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

Safety Instructions for Machinery



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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

WEARING PROPER APPAREL. Do not wear loose clothing, gloves, neckties, 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 Metal Belt Grinders

WARNING

Serious injury or death can occur from fingers, clothing, jewelry, or hair getting pinched/entangled in rotating belt or other moving components. Abrasion injuries can occur from touching moving abrasive belt with bare skin. Workpieces or ground-off particles thrown by abrasive belt can strike operator or bystanders, causing impact injuries or blindness. Long-term respiratory damage can occur from using grinder without wearing a respirator. To reduce the risk of these hazards, operator or bystanders **MUST** completely heed the hazards and warnings below.

IN-RUNNING NIP POINTS. The gap between moving abrasive belt and rest/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 the risk of pinch and crush injuries by adjusting rest/support to no more than $\frac{1}{16}$ " away from belt.

GRINDING DUST. Grinding creates large amounts of airborne dust particles that can cause eye injury or respiratory illness. Reduce your risk by always wearing approved eye and respiratory protection when using grinder.

ABRASIVE CONDITION. Worn or damaged abrasive belts can fly apart and throw debris, or aggressively grab workpiece, causing injury from operator loss of workpiece control. Always inspect belt before operation and replace if worn or damaged.

HOT WORKPIECES. Grinding friction will cause workpiece to quickly get hot, causing burns to the skin. Wear apron if grinding for an extended time. Do not touch freshly ground surfaces or nearby areas without first cooling them or allowing them to cool.

WORKPIECE INTEGRITY & SUPPORT. Grinding fragile workpieces can result in loss of control, resulting in abrasion injuries, pinch/impact injuries, or damage to abrasive belt. Only grind solid workpieces that can withstand power grinding forces. Properly support workpiece; avoid grinding workpieces without flat bottom surfaces unless some type of jig is used to maintain support and control when grinding force is applied. Always grind with workpiece firmly against rest or another support device, if feasible.

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

FLAMMABLE MATERIALS. Grinding metal will cause sparks. Make sure there are no flammable or combustible materials near machine.

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

PROTECTING HANDS. Rotating belt can remove skin quickly. Always keep hands away from moving belt during operation. Do not wear gloves while grinding. Stop machine before cleaning dust from work area and protect hands because pieces can be sharp.

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

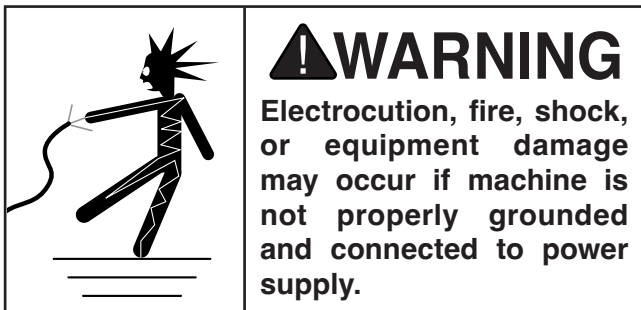
AVOIDING ENTANGLEMENT. Becoming entangled in moving parts can cause severe injury or death. Keep all guards in place and closed; **DO NOT** wear loose clothing, gloves, or jewelry; and tie back long hair.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 110V ... 7.8 Amps

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

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

! WARNING

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

110V Circuit Requirements

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

Nominal Voltage 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 5-15

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

! CAUTION

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

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



Grounding & Plug Requirements

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

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

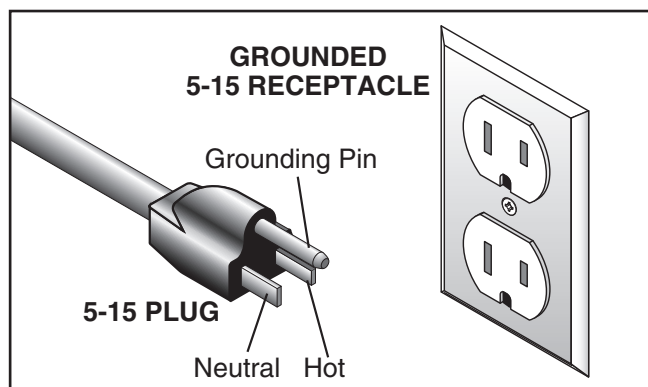


Figure 4. Typical 5-15 plug and receptacle.

⚠ CAUTION

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

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

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

Extension Cords

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

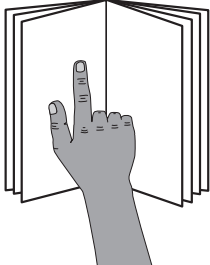
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

Minimum Gauge Size 16 AWG
Maximum Length (Shorter is Better).....50 ft.



SECTION 3: SETUP



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



!WARNING
Wear safety glasses during the entire setup process!

Needed for Setup

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

Description	Qty
• Safety Glasses (for each person).....	1 Pr.

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.***

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.

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.

Loose Items (Figure 5)	Qty
A. Combo Wrench 10mm	1
B. Abrasive Belt 2" x 42" 120-Grit	1
C. Cap Screws M5-.8 x 8	4
D. Open-End Wrench 12 x 14mm	1
E. Tool Rest	1
F. Hex Wrenches 1/8", 3/16"	1 Ea.

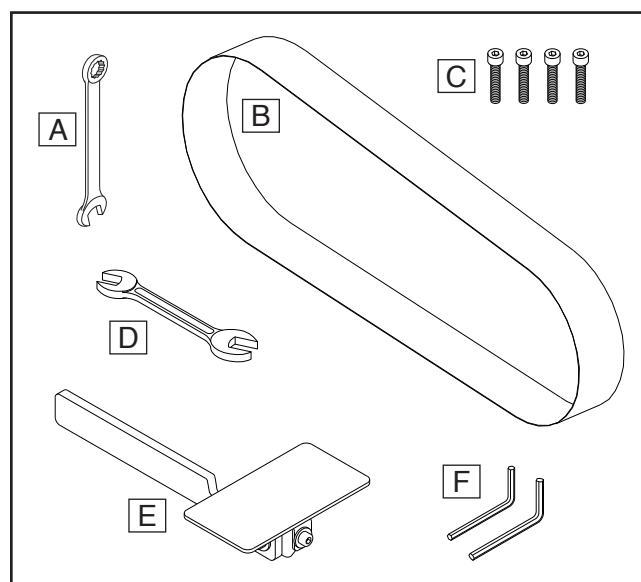


Figure 5. Loose items.



Site Considerations

Workbench Load

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

Placement Location

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

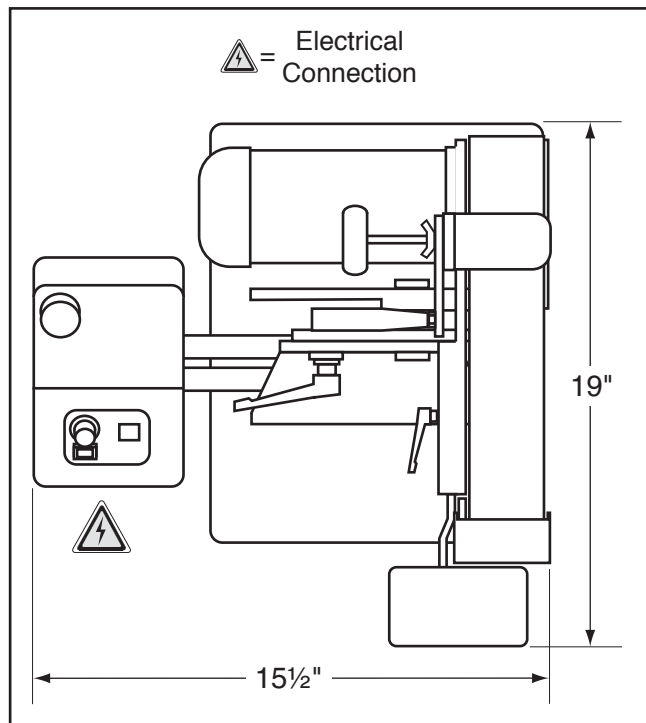


Figure 6. Minimum working clearances.

	<p>⚠ CAUTION</p> <p>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.</p>
---	--

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).

To assemble machine:

1. Loosen (2) control box mount cap screws, fully extend control box mount from machine base, then tighten screws (see **Figure 7**).

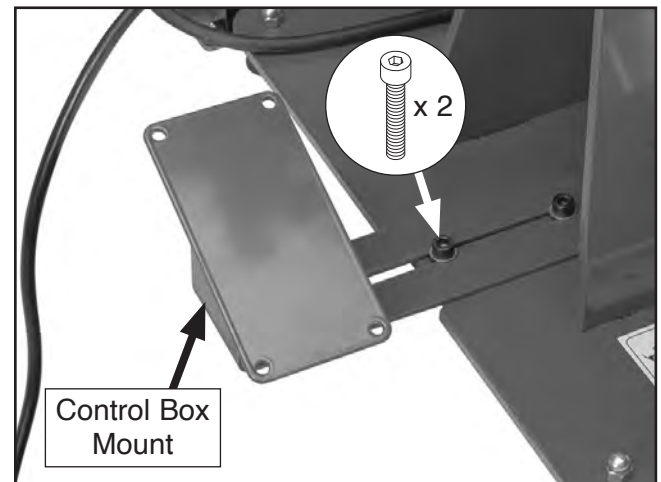


Figure 7. Control box mount fully extended.

2. Attach control box to mount with (4) M5-.8 x 8 cap screws (see **Figure 8**).

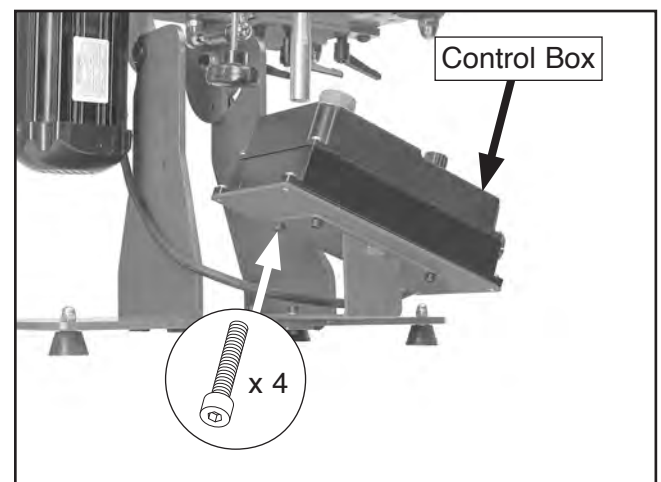


Figure 8. Control box attached to mount.



3. Loosen frame tilt lock handle and tilt machine frame to vertical position, as shown in **Figure 9**, then tighten frame tilt lock handle to secure.
4. Loosen platen lock handle (see **Figure 9**).
5. Remove platen assembly from machine frame (see **Figure 9**).

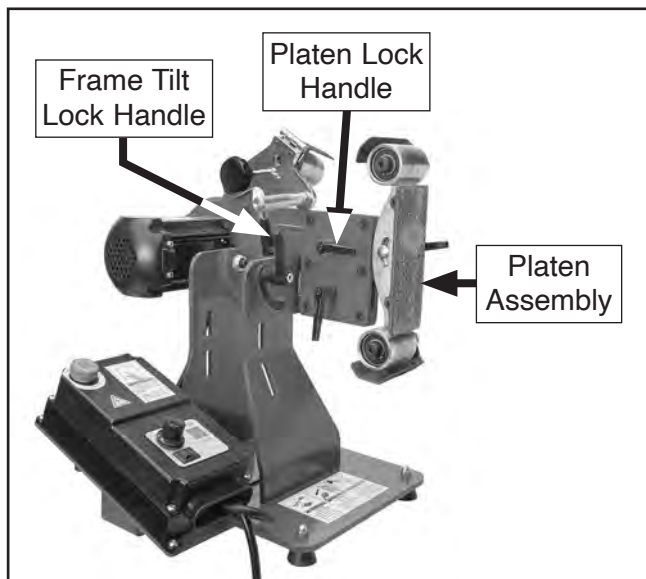


Figure 9. Frame tilted to vertical position.

6. Flip platen assembly so abrasion injury label faces up, then install assembly in machine frame (see **Figure 10**).

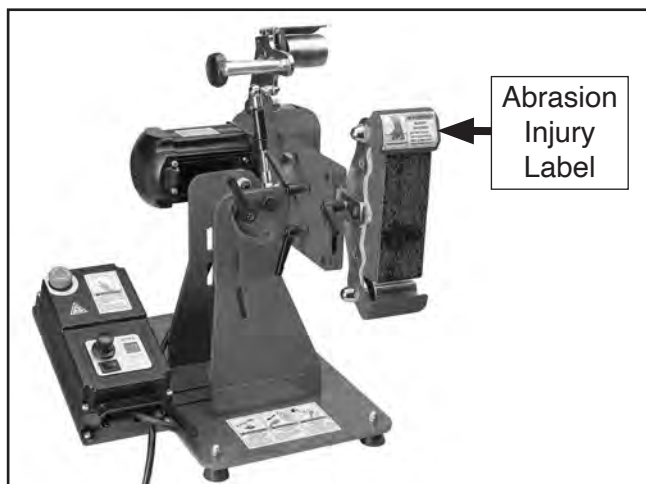


Figure 10. Platen assembly flipped and installed correctly.

7. Push belt tension handle (see **Figure 11**) toward frame tilt lock handle to compress gas strut.

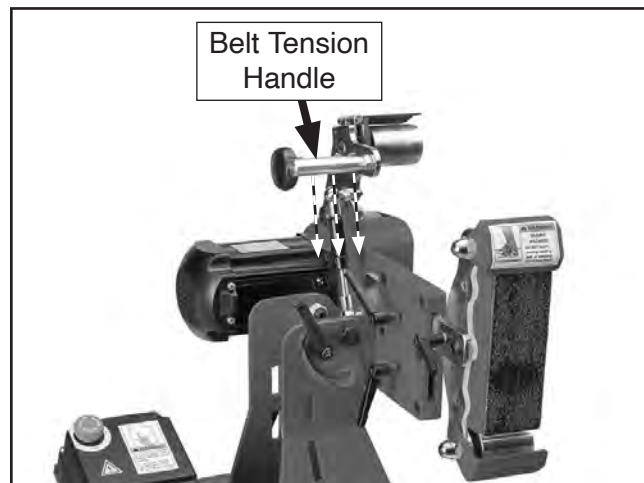


Figure 11. Direction to push belt tension handle.

8. While holding belt tension handle to keep gas strut compressed, install abrasive belt around wheels, being sure arrows on belt match belt rotation arrow on machine (see **Figure 12**).

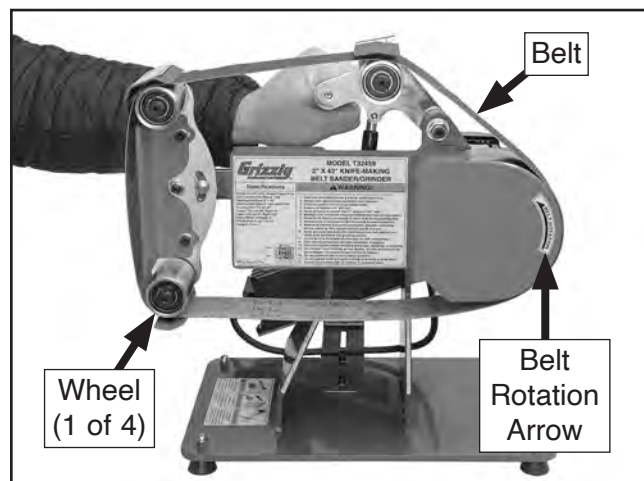


Figure 12. Abrasive belt installed around wheels.



- Without releasing belt tension handle, move platen assembly as far forward as you can without stretching belt (see **Figure 13**), and tighten platen lock handle.

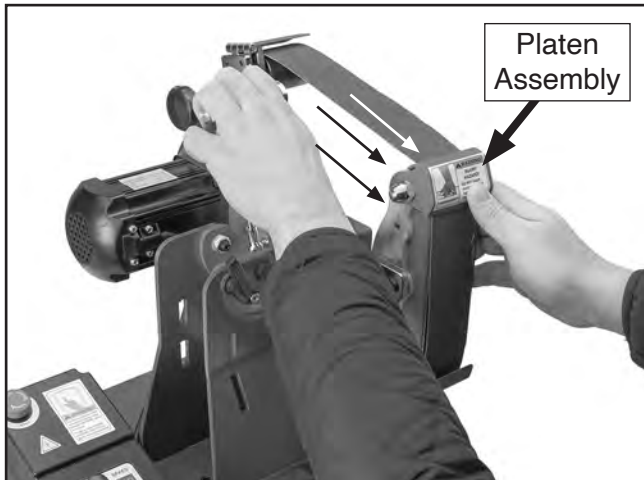


Figure 13. Pulling platen assembly forward.

- Center belt on wheels, then slowly release belt tension handle to tension belt. Confirm that gas strut on tension assembly expands to tension belt when belt tension handle is released.

- If strut is already fully extended, or if lock nut shown in **Figure 14** is too tight, gas strut will not expand to properly tension belt. Loosen lock nut, if necessary, and repeat **Steps 9–10** to correct tension before proceeding to **Test Run**.



Figure 14. Location of tension assembly lock nut.

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 wheels during initial startup, 2) the motor powers up and runs correctly, and 3) the EMERGENCY STOP button works correctly.

!WARNING

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

!WARNING

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

To test run machine:

- Clear all setup tools away from machine.
- Tie back loose clothing and long hair to protect yourself from getting caught in moving belt when you start machine.



3. Loosen wing nut shown in **Figure 15**.
4. Standing in front of machine, push belt multiple times along platen so it moves in direction of operation (see **Figure 15**), then watch how belt tracks on wheels.

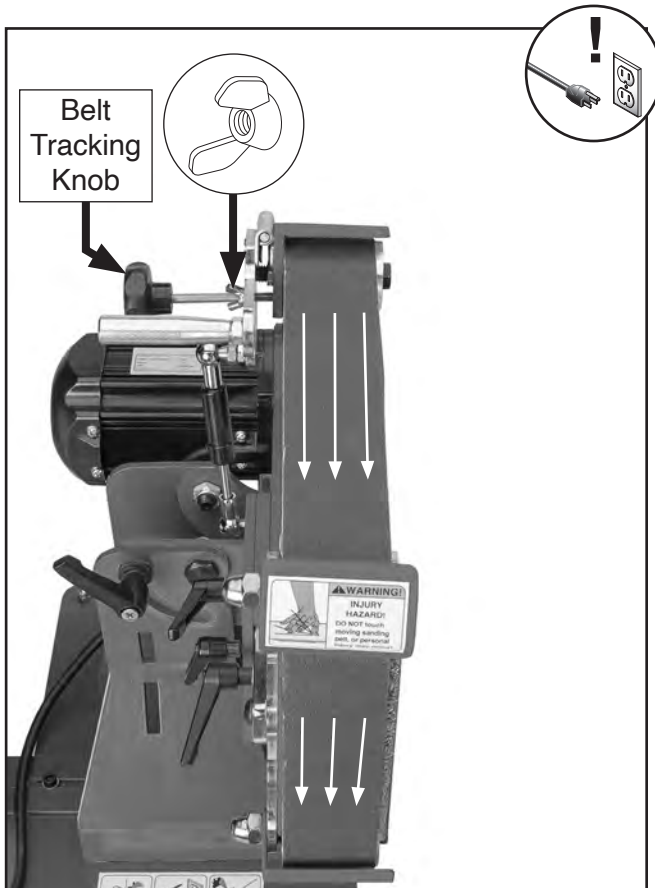


Figure 15. Belt tracking components.

- If belt tracks centered on wheels, proceed to **Step 6**.
 - If belt *does not* track centered on wheels, proceed to **Step 5**.
5. Use belt tracking knob (see **Figure 15**) to adjust belt tracking while continuing to rotate belt by hand to check adjustment.
 - Turn knob *clockwise* to move belt *left* on wheels and platen, and turn knob *counter-clockwise* to move belt *right*.

6. Press EMERGENCY STOP button in (see **Figure 16**).
7. Move ON/OFF switch to OFF position (see **Figure 16**).
8. Turn variable-speed dial all the way counter-clockwise (see **Figure 16**).

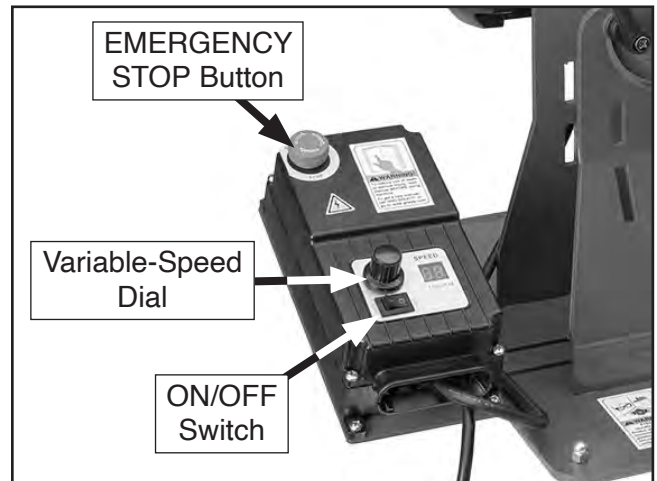


Figure 16. Location of power controls.

9. Connect machine to power. Motor speed digital readout will illuminate.
10. Twist EMERGENCY STOP button clockwise until it springs out (see **Figure 17**). This resets button so machine can start.



Figure 17. Resetting EMERGENCY STOP button.



11. Move ON/OFF switch to ON position, slowly turn variable-speed dial clockwise just enough to start machine, verify belt is tracking correctly in center of platen and wheels, and fine-tune tracking with belt tracking knob as necessary while machine is running.
12. Once belt tracks centered on wheels, slowly turn variable-speed dial back and forth to test variable-speed function.

Motor should run smoothly and without unusual problems or noises, and belt **MUST** rotate in same direction as belt rotation arrow on machine (see **Figure 18**).

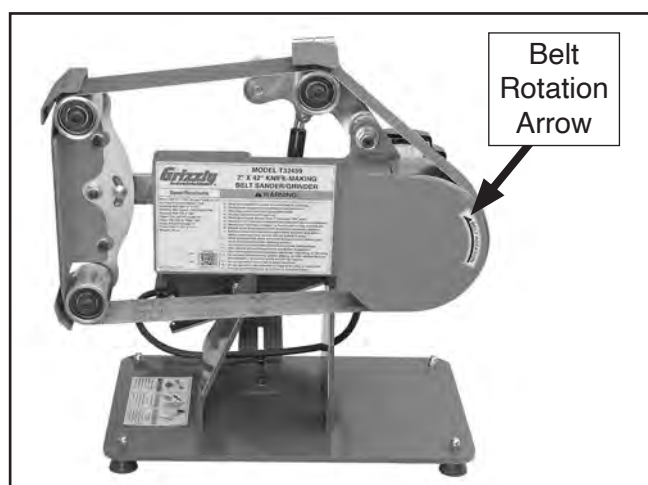


Figure 18. Location of belt rotation arrow.

- If motor runs smoothly and belt rotates in correct direction, proceed to **Step 13**.
- If motor *does not* run smoothly, or belt *does not* rotate in correct direction, turn machine **OFF** and disconnect power. Contact Technical Service before proceeding.

13. Press EMERGENCY STOP button to turn machine **OFF**.
14. **WITHOUT** resetting EMERGENCY STOP button, try to start machine with ON/OFF switch and variable-speed dial. Machine should not start.

- If machine *does not* start, safety feature of EMERGENCY STOP button is working correctly. Proceed to **Step 15**.
- If machine *does* start, immediately turn it **OFF** and disconnect power. Safety feature of EMERGENCY STOP button is **NOT** working properly and must be replaced before further using machine.

15. DISCONNECT MACHINE FROM POWER!

16. Adjust wing nut on belt tracking knob without moving knob so it contacts frame to secure tracking setting.
17. Loosen tool rest lock handle, install tool rest, adjust it so there is no more than 1/16" between rest and belt, then tighten handle to secure (see **Figure 19**).

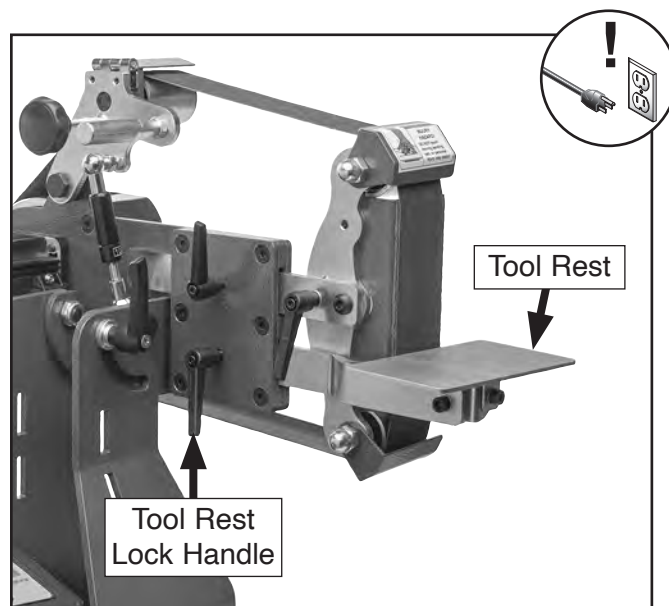


Figure 19. Tool rest installed on machine.

Congratulations! Test Run is complete.

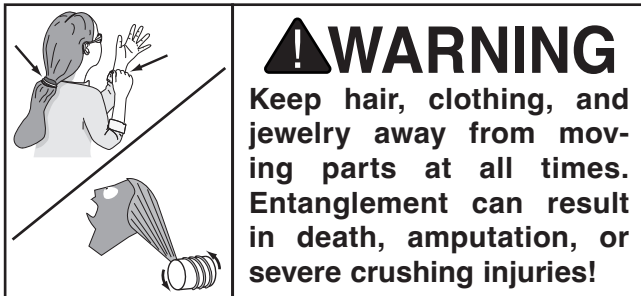
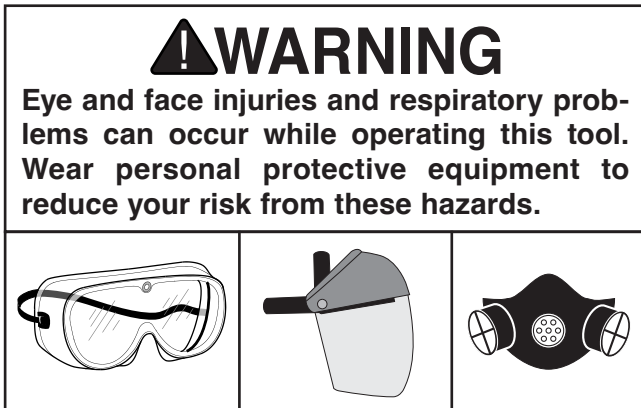


SECTION 4: OPERATIONS

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.



NOTICE

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

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

1. Examines workpiece to make sure it is suitable for grinding (i.e., strong enough to be ground, etc.).
2. Inspects and installs belt with appropriate grit for operation.
3. Determines if operation requires parallel or perpendicular grinding and adjusts frame tilt as necessary.
4. Adjusts platen tilt as desired.
5. Installs and adjusts tool rest to support workpiece, if feasible for operation, then adjusts tool rest to allow maximum $\frac{1}{16}$ " clearance between rest and belt.
6. Ties back loose hair and clothing, and puts on safety glasses, respirator, and face shield. Takes all other required safety precautions.
7. Starts machine and adjusts belt speed as desired.
8. Holds workpiece firmly with both hands, supports it with fixtures as well as the operation and setup allows, pushes workpiece into belt, and moves it to different locations to wear abrasive belt evenly and prevent it from overheating.
9. Stops machine when operation is complete.



Workpiece Inspection

Some workpieces are not suitable for grinding on a grinder. **Before grinding, inspect all workpieces for the following:**

- **Flammable Workpiece:** Workpieces with unstable chemical elements (like magnesium) may catch fire or create explosion hazards when introduced to the heat and friction of grinding. Be aware of the material composition of workpieces you intend to use and avoid grinding different metals and alloys on the same belt in case two different materials create a dangerous chemical reaction.
- **Soft Workpiece:** Workpieces that are made of aluminum, brass, lead, and other nonferrous metals will load up in the belt. Grinding plastics, rubber, fiberglass, or other soft materials can also cause the same problem. Always use the recommended belt for the material.
- **Flexible/Unstable Workpiece:** Grinding on the side or the ends of cable, chain, or round workpieces creates the hazard of workpiece twist or grab, leading to contact with the belt. This hazard must be avoided.
- **Wood Workpiece:** Never grind wood on this machine. Wood dust and shavings are extremely flammable and hot metal sparks will ignite them. A belt that has been used to sand wood creates a flame and explosion hazard when the hot sparks created by grinding metal are introduced.

Grinding Tips

- Extend the life of the abrasive belt by regularly using an abrasive surface cleaner. Change a belt when cleaning is no longer effective.
- As a rule-of-thumb, grind with progressively higher grit numbers. A higher grit will achieve a finer finish.
- Hold workpiece securely with both hands and do not wear gloves. Use tool rest and jigs whenever possible to support workpiece. Do not force workpiece against belt.
- Never grind magnesium. Once shaved or powdered, it is highly flammable, and a magnesium fire is difficult to put out.
- Remember that grinding metal often produces sparks. DO NOT grind metal near flammable materials, and be aware of the area around the machine the sparks will reach.
- Use full width of belt by moving the workpiece back-and-forth across the belt.
- Make sure belt guards/covers are secured during operation.
- The workpiece will get hot as you continue to grind. Cool the workpiece frequently by quenching in water or another approved solution.
- Wear the proper protective clothing. Prepare for particles to be expelled from the grinder at high speeds. Wear safety glasses, face shield, dust mask, earplugs, leather apron, and heavy leather boots.

CAUTION

Moving belt can cause serious personal injury if it comes in contact with fingers, hands, or other body parts. Always support workpiece against tool rest when grinding if possible. Use extreme care to provide a safe distance between belt and any body part.



Choosing Grinding Belts

This machine uses a 2" x 42" belt. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

Grit	Class
24–60	Extra Coarse
60–120	Coarse
120–180	Medium
180+	Fine

The general rule of thumb is to grind a workpiece with progressively higher grit numbers. Avoid skipping grits; the larger the grit increase, the harder it will be to remove the scratches from the previous grit.

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

Belts are also made with different materials, and your workpiece and intended operation will determine which belt material will produce the best results for you. The chart below illustrates some common belt materials and the situations that they are most effective.

Belt Material	Operation
Aluminum Oxide	Finishing. Ferrous metals.
Zirconia Alumina	Finishing; wet or dry grinding. Ferrous metals, some steels.
Ceramic	Aggressive grinding; deburring. Heat-sensitive metals.
Silicon Carbide	Cutting; stock removal; wet or dry grinding. Cast iron, steel, non-ferrous metals.

Depending on the material, some belts also come with different backing material. For grinding, cloth backing is the most common and has various weights. The "weight" of the cloth backing refers to the flexibility of the belt, and you will want to use a belt with flexibility tailored to your workpiece and application. The chart below illustrates common cloth weights and their flexibility/uses.

Belt Weight	Description
J-Weight	Flexible. Good for contour sanding/grinding.
X-Weight	Medium flexibility. Strong. For all-purpose sanding/grinding.
Y-Weight	Least flexible. Very strong. Good for heavy stock removal. Often waterproof and tear resistant.

Adjusting Frame Tilt

The Model T32459 frame can be positioned from 0°–90°, depending on your operation. With the frame at a vertical angle (see **Figure 20**), it is easier to perform grinds perpendicular to the belt (i.e., with a workpiece flat against the tool rest in **Figure 20**).

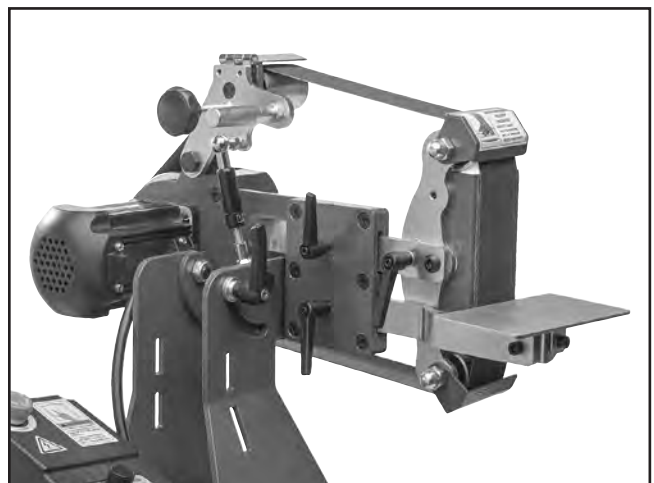


Figure 20. Frame angled to 0° for perpendicular grinding.



With the frame at a horizontal angle (see **Figure 21**), it is easier to perform grinds parallel to the belt (i.e., with a workpiece flat against the tool rest in **Figure 21**).

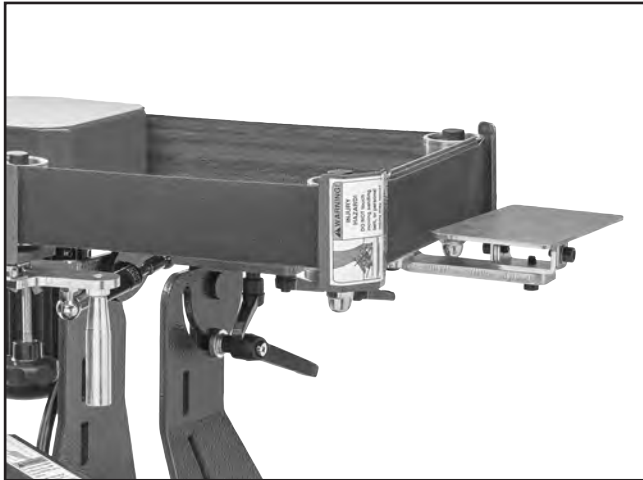


Figure 21. Frame angled to 90° for parallel grinding.

To adjust frame tilt:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen frame tilt lock handle (see **Figure 22**), adjust frame tilt as desired, then tighten handle to secure.

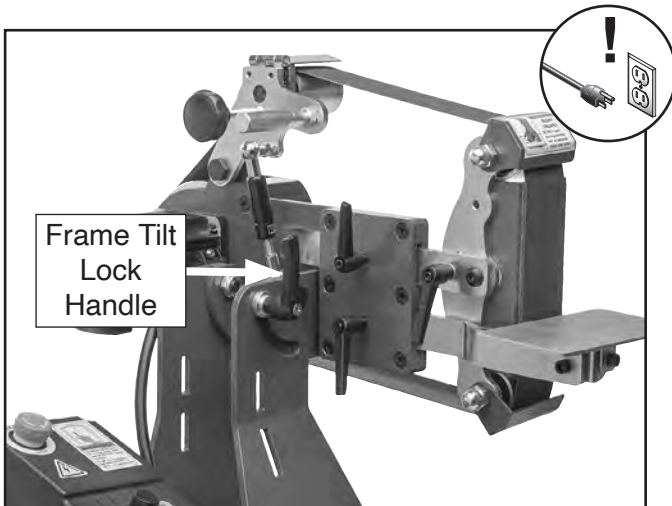


Figure 22. Location of frame tilt lock handle.

3. If tool rest can be installed for your operation, refer to **Adjusting Tool Rest** on **Page 25** to adjust tool rest tilt to match new frame position and to prepare tool rest for desired operation.

Adjusting Platen Tilt

Tilt the platen forward or backward up to 30° (or left or right when the frame is at a horizontal angle), if necessary for your operation (see **Figures 23–24**).

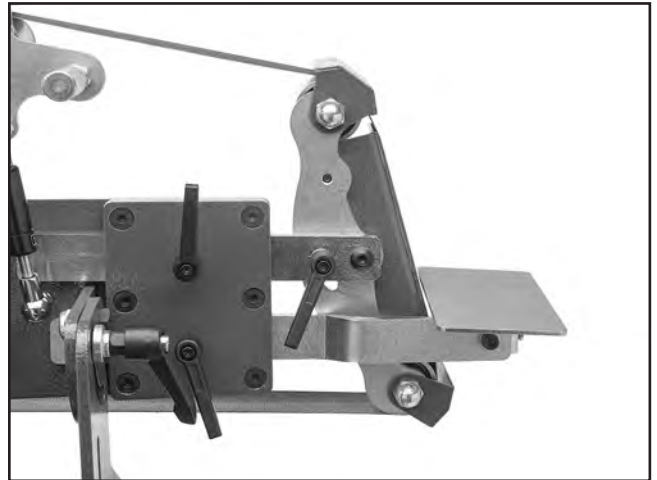


Figure 23. Platen tilted backward with frame at vertical angle.

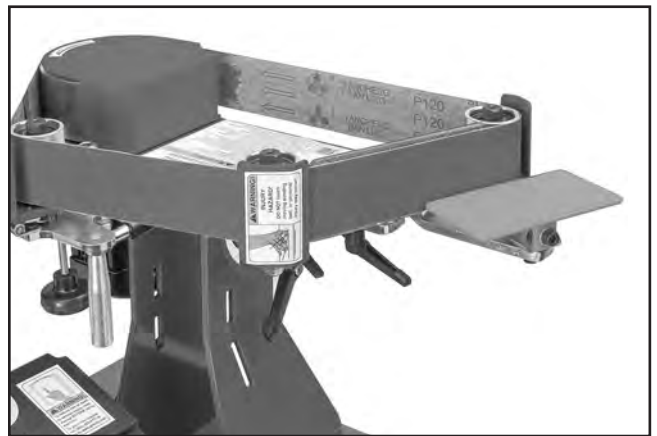


Figure 24. Platen tilted left with frame at horizontal angle.

Tool Needed	Qty
Wrench 17mm	1

To adjust platen tilt:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen tool rest lock handle (see **Figure 25**), so you can move it as needed during next step.



- Loosen platen tilt lock handle (see **Figure 25**), adjust platen tilt as desired, then tighten handle to secure.

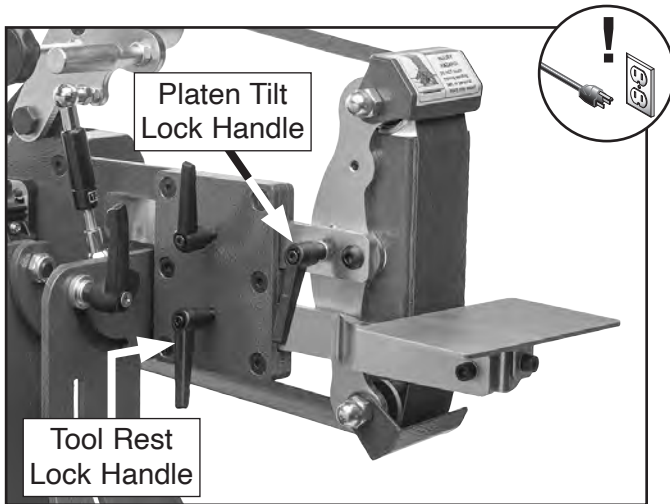


Figure 25. Location of tool rest lock handle and platen tilt lock handle.

NOTICE

When adjusting platen tilt, you MUST adjust wheel covers or machine may be damaged when it is turned ON.

- Loosen acorn nuts on wheel covers shown in **Figure 26**, adjust covers so they are not contacting belt, then tighten nuts to secure.

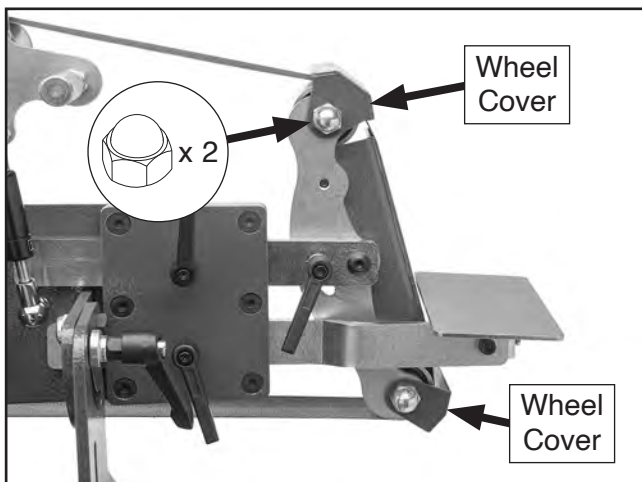


Figure 26. Location of wheel covers and acorn nuts.

- If tool rest can be installed for operation, refer to **Adjusting Tool Rest** on **Page 25** to adjust tool rest swivel and clearance to match platen position. If tool rest cannot be safely installed for operation, remove it.

Installing/Changing Belt

The belt should be changed whenever there is a noticeable change in quality/performance. You will also need to change grit sizes depending on whether you are performing quick material removal or would like a finer finish.

Required Belt Size.....2" x 42"

Item Needed	Qty
Replacement Belt	1

To install/change belt:

- DISCONNECT MACHINE FROM POWER!
- Adjust frame tilt so platen is vertical (refer to **Adjusting Frame Tilt** on **Page 20**).
- Loosen platen lock handle (see **Figure 27**).
- Push belt tension handle toward frame tilt lock handle (see **Figure 27**) to compress gas strut and release belt tension.

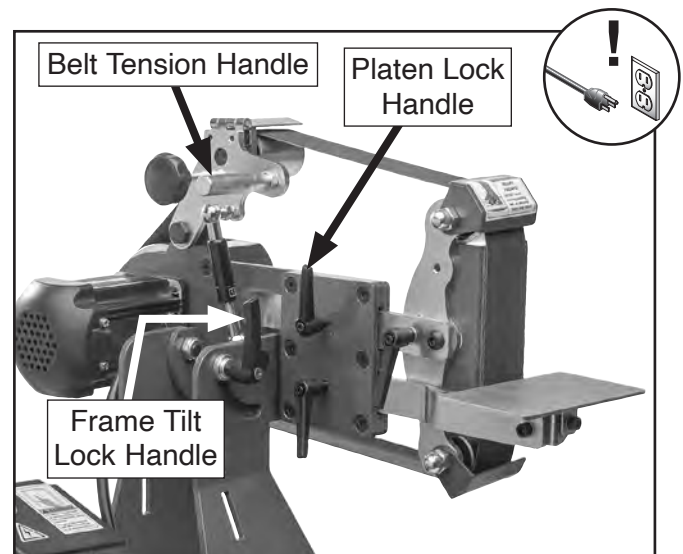


Figure 27. Location of platen lock handle, belt tension handle, and frame tilt lock handle.



5. While holding belt tension handle to keep gas strut compressed, remove old belt from wheels and replace with new one, being sure arrows on belt match belt rotation arrow on machine (see **Figure 28**).



Figure 28. Location of belt rotation arrow.

6. Without releasing belt tension handle, move platen assembly as far forward as you can without stretching belt (see **Figure 29**), then tighten platen lock handle.

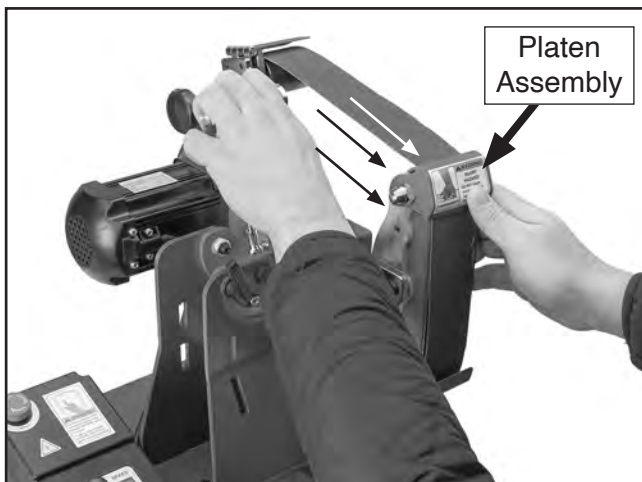


Figure 29. Pulling platen assembly forward.

7. Center belt on wheels and platen, then slowly release belt tension handle to tension belt. Confirm that gas strut on tension assembly expands to tension belt when handle is released.
8. Belt **MUST** be pre-tracked before connecting machine to power. Proceed to **Pre-Tracking Belt**.

Pre-Tracking Belt

You must perform the following procedure after installing a new belt to ensure that the belt does not come off the wheels or get jammed against the belt frame.

To pre-track belt:

1. **DISCONNECT MACHINE FROM POWER!**
2. Install desired belt as described in **Installing/Changing Belt** on **Page 22**.
3. Loosen wing nut shown in **Figure 30**.

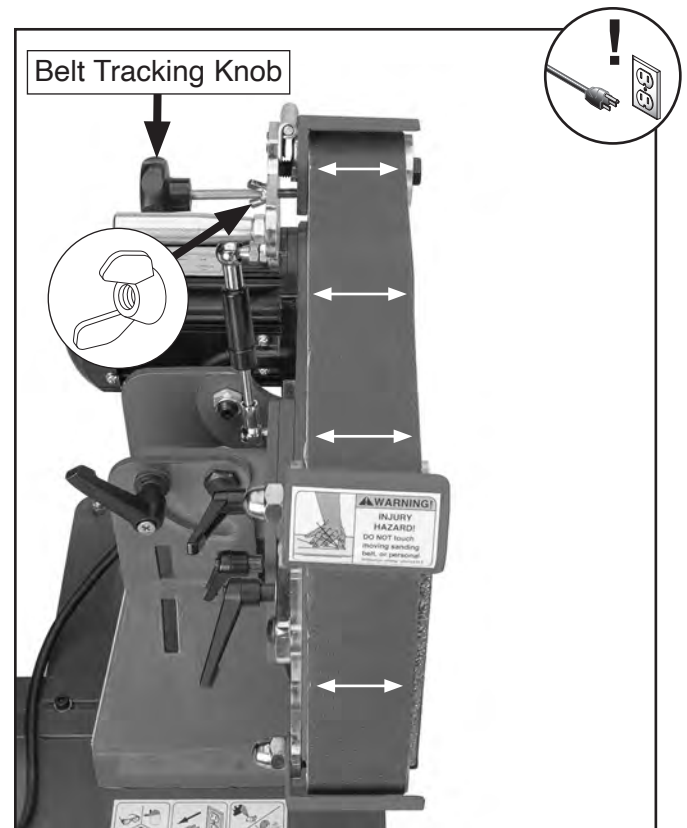


Figure 30. Belt tracking components.

Tip: Loosen tool rest lock handle to remove tool rest assembly while tracking belt for unobstructed view of platen and wheels.



4. Standing in front of machine, push grinding belt multiple times along platen, so it moves in direction of operation (see **Figure 31**), then watch how belt tracks on wheels.

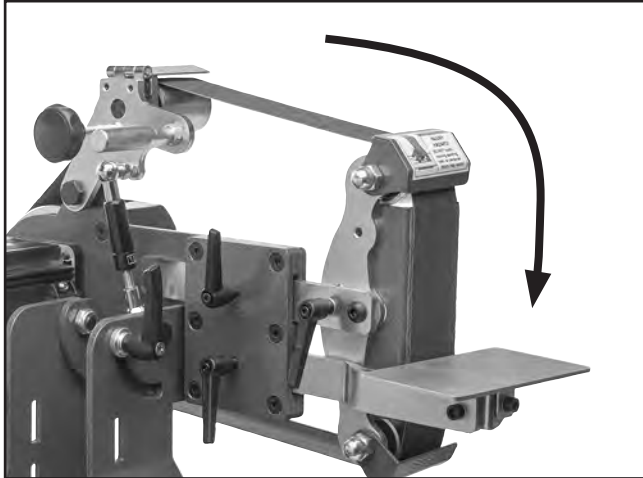


Figure 31. Direction of belt during operation.

- If belt tracks centered on wheels, proceed to **Step 6**.
 - If belt *does not* track centered on wheels, proceed to **Step 5**.
5. Use belt tracking knob to adjust belt tracking while continuing to rotate belt by hand to check adjustment.
 - Turn knob *clockwise* to move belt *left* on wheels and platen (see **Figure 30** on **Page 23**) and turn knob *counterclockwise* to move belt *right*.
 6. Proceed to **Checking/Adjusting Belt Tracking**.

Checking/Adjusting Belt Tracking

The purpose of belt tracking is to make sure the belt stays centered on the wheels during operations. The belt tracking needs to be checked any time you change or replace the belt.

You must perform the following procedure after installing a belt to ensure that the belt does not come off the wheels or get jammed against the machine frame.

To check/adjust belt tracking:

1. Install desired belt as described in **Installing/Changing Belt** on **Page 22**.
2. Pre-track belt as described in **Pre-Tracking Belt** on **Page 23**.
3. Connect machine to power, turn it **ON**, verify belt is tracking correctly in center of platen and wheels, and fine-tune tracking with belt tracking knob as necessary while machine is running.
4. **DISCONNECT MACHINE FROM POWER!**
5. Once belt tracks centered on wheels, tighten wing nut on belt tracking knob.
6. Loosen tool rest lock handle, install and adjust tool rest so there is no more than $\frac{1}{16}$ " between rest and belt, then tighten handle to secure (see **Figure 32**).

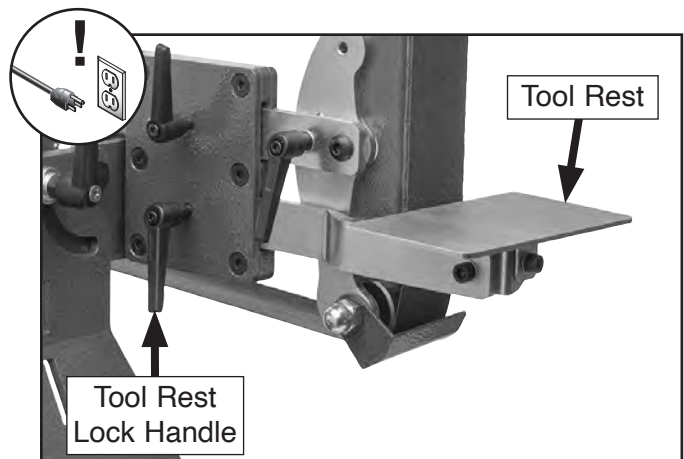


Figure 32. Location of tool rest and tool rest lock handle.



Adjusting Tool Rest

The tool rest should be used whenever it can feasibly be installed to help support the workpiece. Once installed, it can be tilted from 5° left to 120° right, can be swiveled on its base, and can adjust toward and away from the machine frame. These adjustments allow for angled workpieces and for the rest to be adjusted square to the platen regardless of how the frame and platen are adjusted.

When grinding very thin workpieces, a common practice when producing knife bevels, the workpiece can be drawn into the gap between the tool rest and the belt. If a workpiece is too thin to be safely supported by the tool rest, consider researching freehand belt grinding techniques or using a different method to grind your workpiece.

⚠ CAUTION

Tool rest must always be adjusted within 1/16" of belt to reduce risk of fingers or workpiece being drawn into gap.

Adjusting Tool Rest Angle

Tool Needed	Qty
Hex Wrench 3/16"	1

To adjust tool rest angle:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen cap screw shown in **Figure 33**, adjust tool rest to desired angle, then tighten cap screw to secure (see **Figure 33**).

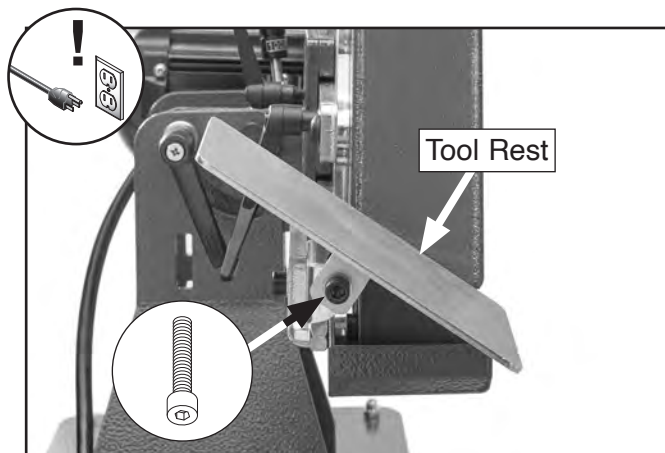


Figure 33. Location of tool rest angle cap screw.

Adjusting Tool Rest Swivel While Frame is Vertical

When the machine frame is vertical, the tool rest swivel can be adjusted for an angled workpiece (see **Figure 34**).

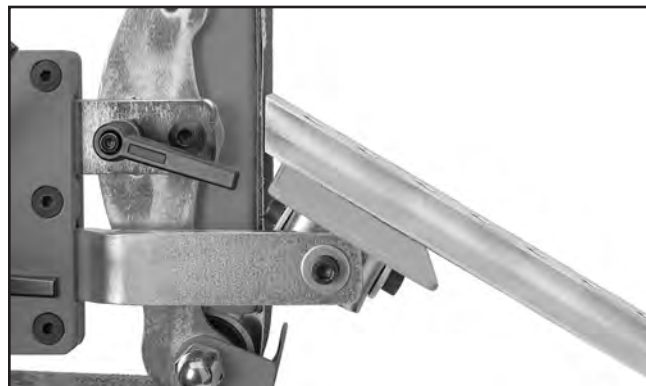


Figure 34. Example of tool rest swivel adjusted for workpiece angle.

Tool Needed	Qty
Hex Wrench 3/16"	1

To adjust swivel while frame is vertical:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen tool rest lock handle (see **Figure 35**), so you can move it as needed during next step.
3. Loosen cap screw shown in **Figure 35**, swivel tool rest to match workpiece angle, then tighten cap screw to secure.

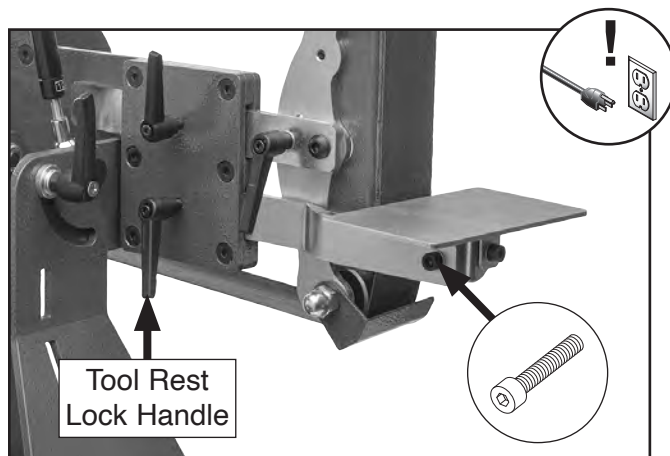


Figure 35. Location of tool rest lock handle and swivel cap screw.

4. Refer to **Adjusting Tool Rest Clearance** on **Page 26**.



Adjusting Tool Rest Swivel While Frame is Horizontal

When the machine frame is horizontal, to use the tool rest as a table, you **MUST** adjust the tool rest swivel in order to align the rest's full edge within $\frac{1}{16}$ " of the belt (see **Figure 36**).

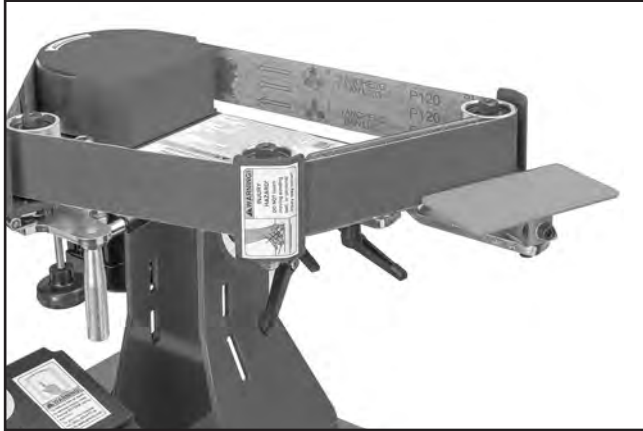


Figure 36. Example of tool rest swivel adjusted to match platen tilt.

Tool Needed	Qty
Hex Wrench $\frac{3}{16}$ "	1

To adjust swivel while frame is horizontal:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen cap screw shown in **Figure 37**, swivel tool rest to match platen angle, then tighten cap screw to secure.

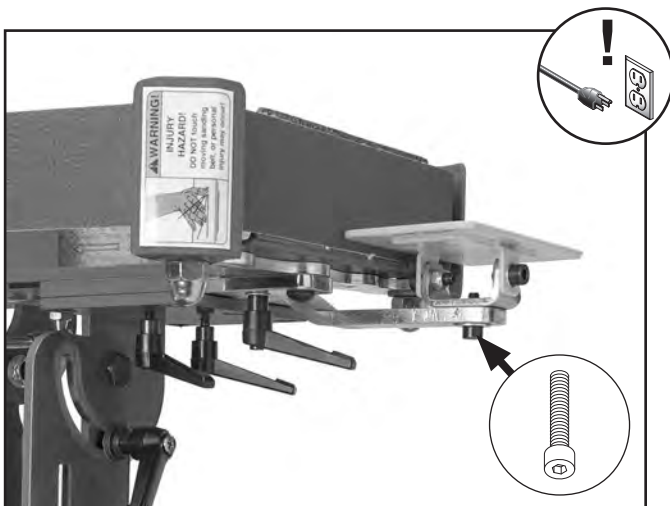


Figure 37. Location of swivel cap screw.

3. Refer to **Adjusting Tool Rest Clearance**.

Note: If front wheel cover prevents you from adjusting tool rest within $\frac{1}{16}$ " of belt, loosen acorn nut on wheel cover (see **Figure 38**), adjust cover out of the way, then tighten acorn nut.

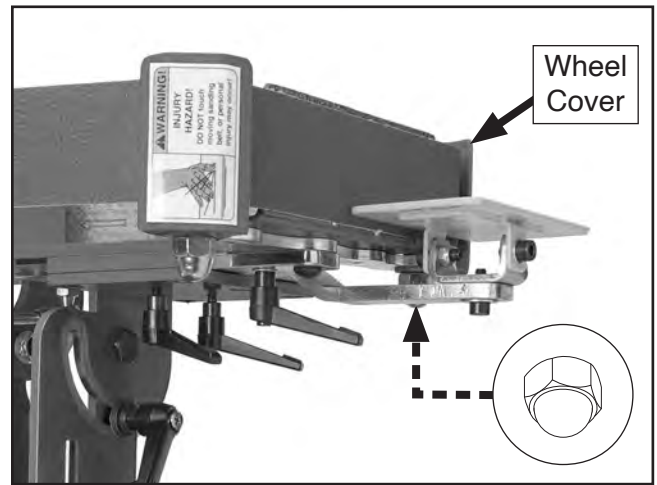


Figure 38. Location wheel cover acorn nut.

Adjusting Tool Rest Clearance

Adjust the tool rest clearance whenever the belt has been replaced, the tool rest has been removed, or the platen tilt has been adjusted.

To adjust tool rest clearance:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen tool rest lock handle, adjust tool rest so there is no more than $\frac{1}{16}$ " between rest and belt (see **Figure 39**), then tighten handle to secure.

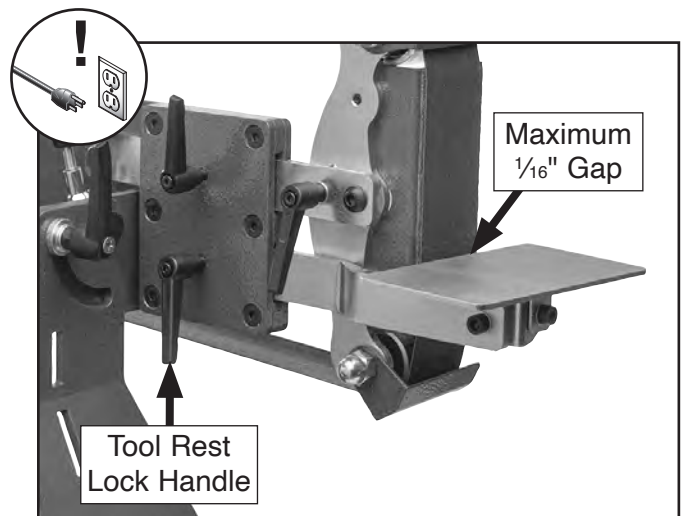


Figure 39. Tool rest clearance adjustment controls.



Flat Grinding

Flat grinding operations are performed directly on the belt against the platen. Refer to **Figure 40** for an example of flat grinding.



Figure 40. Properly grinding workpiece face.

This setup is good for material removal and creating profiles. Regardless of your workpiece, always use two hands to control the workpiece and use the tool rest to support it, if feasible.

To flat grind:

1. Connect machine to power, turn it **ON**, and allow motor to reach desired speed.
2. Position workpiece on tool rest, if installed.
3. Use both hands to maintain control of workpiece, as shown in **Figure 40**, and slowly feed it into moving belt with light, even pressure. **DO NOT** force workpiece against belt.

Note: *There are many different techniques for using belt to grind and sharpen knives. Whichever one you use, make sure that you hold knife firmly and ease it into belt without excessive pressure to ensure safe operation.*



Slack Belt Grinding

Slack belt grinding operations are performed directly on the belt with the platen removed (see **Figure 41**).



Figure 41. Example of slack belt grinding.

When a workpiece is fed into the belt without a flat platen behind it, the belt can better conform to curved contours.

Tool Needed	Qty
Hex Wrench $\frac{3}{16}$ "	1

To slack belt grind:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (2) cap screws, lock washers, and flat washers shown in **Figure 42** to remove platen.

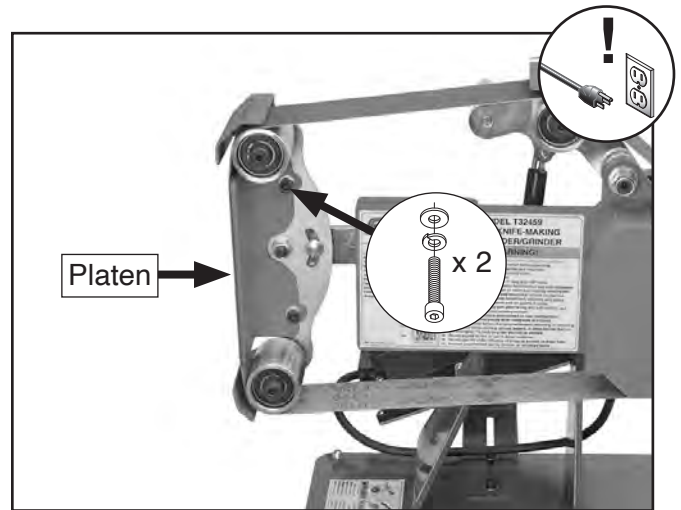


Figure 42. Location of platen and fasteners.

3. Connect machine to power, turn it **ON**, and allow motor to reach desired speed.
4. Position workpiece on tool rest, if installed.
5. Use both hands to maintain control of workpiece, as shown in **Figure 41**, and slowly feed it into moving belt with light, even pressure. **DO NOT** force workpiece against belt. Move workpiece to different locations to wear abrasive belt evenly and to prevent it from overheating.
6. When slack grinding is complete, install platen and refer to **Adjusting Platen to Wheels** on **Page 34** to adjust platen correctly to resume flat grinding operations.



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.

Grizzly Belts

These tough, silicon carbide belts come in a variety of grits.

T33771—2" x 42" 60-Grit, 10-Pk.

T33772—2" x 42" 80-Grit, 10-Pk.

T33773—2" x 42" 120-Grit, 10-Pk.

T33774—2" x 42" 180-Grit, 10-Pk.

T33775—2" x 42" 220-Grit, 10-Pk.

T33776—2" x 42" 400-Grit, 10-Pk.

T33777—2" x 42" 600-Grit, 10-Pk.

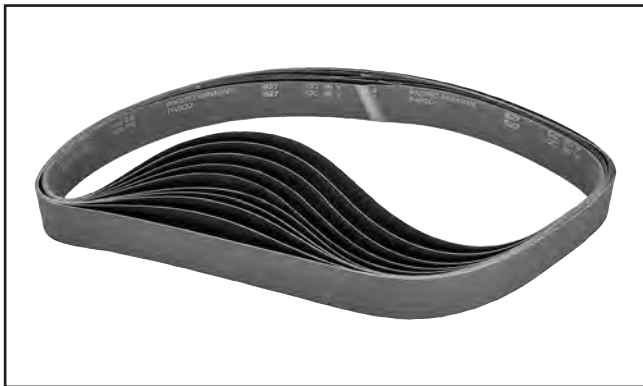


Figure 43. Grizzly belts.

T30024—Powered Respirator Kit

Breathing metal dust could cause severe respiratory illnesses. This kit is a lightweight, comfortable, and easy-to-carry device for protecting the airway from small particulates.



Figure 44. T30024 Powered Respirator Kit.

T26685—ISO 32 Moly-D Machine Oil, 1 Gal.

Moly-D oils are some of the best we've found for maintaining the critical components of machinery because they tend to resist run-off and maintain their lubricity under a variety of conditions.



Figure 45. T26685 ISO 32 Moly-D Machine Oil.

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



T32720—10" Variable-Speed Wet Sharpener

The 220-grit aluminum oxide grinding wheel is specially made for wet sharpening and runs through a water bath to prevent residue buildup on the grinding wheel and keep tools cool while sharpening. The leather stropping wheel helps remove burrs and hones to a final razor edge.



Figure 46. T32720 10" Variable-Speed Wet Sharpener.

T21578—12" Bevel Edge Straight Edge

This 12" Bevel Edge Straight Edge is made from hardened steel and ground and lapped for straightness and parallelism. Features satin chrome finish, true right angles for all edges, and bevel edge with scale. Accuracy: 0.001". Resolution: 1/64".



Figure 47. T21578 12" Bevel Edge Straight Edge.

T10456—Heavy-Duty Anti-Fatigue Mat 3' x 5'

This Heavy-Duty Anti-Fatigue Mat features beveled edges and no-slip tread for safety and comfort. Open-hole design allows liquid to drain through, so it's perfect for wet or oily conditions. Measures 3' wide x 5' long x 3/8" thick.

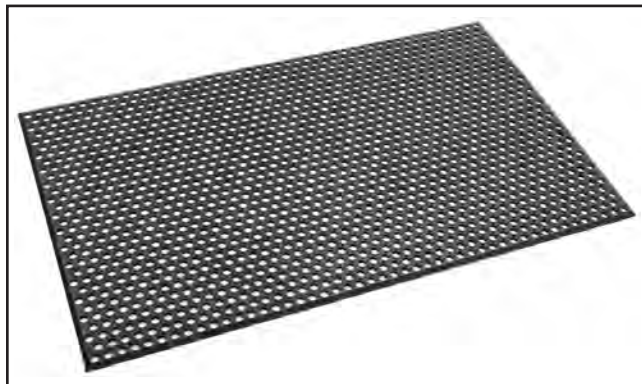


Figure 48. Model T10456 Anti-Fatigue Mat.

D2056—Tool Table

Flared legs and adjustable rubber feet ensure stability and reduce machine vibration. Butcher block finish table top measures 13" x 23" x 1". 30 1/2" height, 21" x 32" footprint, and 700 lb. capacity!

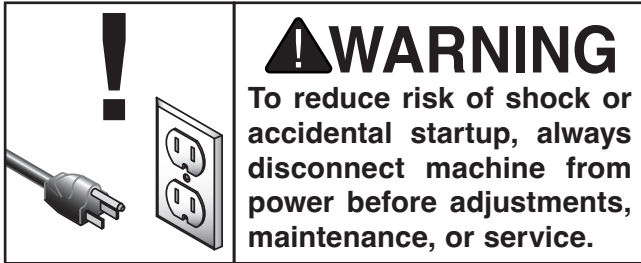


Figure 49. D2056 Tool Table.

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



SECTION 6: MAINTENANCE



Schedule

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

Ongoing

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.
- Worn or damaged belt.
- Worn or damaged wires.
- Any other unsafe condition.

Daily Maintenance

- Clean any shavings and dust from between platen and belt.

Weekly Maintenance

- Sweep surrounding dust and shavings.
- Clean/vacuum dust off motor.

Monthly Check

- Lubricate frame and tension assembly pivot bolts.

Cleaning

Cleaning the Model T32459 is relatively easy. Vacuum excess shavings, and wipe off any remaining dust with a dry cloth. Never use compressed air to blow away dust as airborne particles may be combustible.

Lubrication

The bearings are sealed and permanently lubricated; they require no lubrication. The only parts that require lubrication are the frame pivot bolts and belt tension pivot bolt (see **Figure 50**).

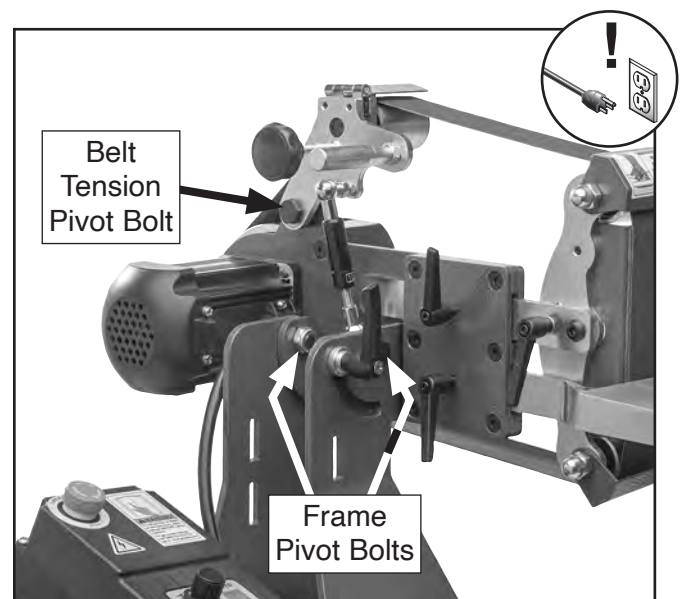


Figure 50. Locations of pivot bolts.

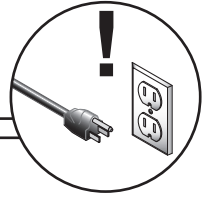
Apply two drops of an ISO 32 oil like the one shown in **Figure 45** on **Page 29** monthly to each pivot bolt. Adjust the frame through its full tilting range and release and apply belt tension to distribute the oil.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> EMERGENCY STOP button depressed/at fault. Incorrect power supply voltage or circuit size. Motor speed potentiometer at fault. Power supply circuit breaker tripped or fuse blown. Wiring broken, disconnected, or corroded. ON/OFF switch at fault. Control box circuit board at fault. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> Rotate EMERGENCY STOP button head to reset. Replace if at fault. Ensure correct power supply voltage and circuit size (Page 10). Test/replace if at fault. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. Fix broken wires or disconnected/corroded connections (Page 36). Replace switch. Inspect/replace if at fault. Replace motor.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> Excessive workpiece pressure. Wrong workpiece material (metal). Control box circuit board at fault. Motor speed potentiometer at fault. Machine undersized for task. Motor overheated. Extension cord too long. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> Reduce workpiece pressure against belt. Use correct type/size of metal. Inspect/replace if at fault. Test/replace if at fault. Clean/replace belt (Page 22); reduce feed rate/sanding depth. Clean motor, let cool, and reduce workload. Move machine closer to power supply; use shorter extension cord. Replace motor.
Motor speed will not display, adjust, or is inconsistent.	<ol style="list-style-type: none"> Variable-speed dial stripped. Wiring broken, disconnected, or corroded. Motor speed potentiometer at fault. Motor speed digital readout circuit board at fault. 	<ol style="list-style-type: none"> Replace dial. Fix broken wires or disconnected/corroded connections (Page 36). Test/replace if at fault. Inspect/replace if at fault.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> Motor or component loose. Stand feet not adjusted properly or loose. Drive wheel hex bolt missing or loose. Motor fan rubbing on fan cover. Motor bearings at fault. 	<ol style="list-style-type: none"> Replace damaged or missing bolts/nuts or tighten if loose. Adjust stand feet to stabilize machine or tighten if loose. Inspect drive wheel. Replace or tighten if necessary. Fix/replace fan cover; replace loose/damaged fan. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Operation

Symptom	Possible Cause	Possible Solution
Belt slaps or vibrates excessively.	<ol style="list-style-type: none"> 1. Belt not tensioned properly during installation. 2. Belt tracking needs adjustment. 3. Broken/defective belt. 4. Idler or drive wheel is loose. 5. Gas strut is worn/at fault. 	<ol style="list-style-type: none"> 1. Adjust platen forward while belt tension handle and gas strut are fully compressed, lock platen, then release handle. 2. Adjust belt tracking (Page 24). 3. Replace belt (Page 22). 4. Tighten idler or drive wheel. 5. Replace gas strut.
Belt does not track correctly.	<ol style="list-style-type: none"> 1. Belt not tensioned properly during installation. 2. Belt tracking needs adjustment. 3. Belt tension assembly lock nut is too tight or too loose. 4. Belt damaged, worn, or misshapen. 5. Idler or drive wheel is worn. 6. Gas strut is worn/at fault. 	<ol style="list-style-type: none"> 1. Adjust platen forward while belt tension handle and gas strut are fully compressed, lock platen, then release handle. 2. Adjust belt tracking (Page 24). 3. Adjust belt tension assembly lock nut (see Figure 14 on Page 15) so gas strut can tension belt correctly. 4. Replace belt (Page 22). 5. Replace wheel. 6. Replace gas strut.
Belt slips during use.	<ol style="list-style-type: none"> 1. Belt not tensioned properly during installation. 2. Excessive workpiece pressure. 3. Gas strut is worn/at fault. 	<ol style="list-style-type: none"> 1. Adjust platen forward while belt tension handle and gas strut are fully compressed, lock platen, then release handle. 2. Reduce workpiece pressure against belt. 3. Replace gas strut.
Poor, non-aggressive grinding results.	<ol style="list-style-type: none"> 1. Belt clogged/worn. 2. Using too fine of belt grit. 	<ol style="list-style-type: none"> 1. Clean/replace belt (Page 22). 2. Use coarser grit belt (Page 20).
Excessive belt replacement.	<ol style="list-style-type: none"> 1. Not using full width of abrasive surface. 2. Excessive workpiece pressure. 	<ol style="list-style-type: none"> 1. Move workpiece back and forth across abrasive surface. 2. Reduce workpiece pressure against belt.
Deep grooves or scores in workpiece.	<ol style="list-style-type: none"> 1. Excessive belt speed. 2. Using too coarse of belt grit. 3. Excessive workpiece pressure. 4. Workpiece held still for too long. 5. Graphite pad on platen damaged. 	<ol style="list-style-type: none"> 1. Decrease belt speed. 2. Use finer grit belt (Page 20). 3. Reduce workpiece pressure against belt. 4. Move workpiece back and forth across abrasive surface. 5. Replace graphite pad.
Belt clogs quickly.	<ol style="list-style-type: none"> 1. Excessive belt speed. 2. Worn belt. 3. Excessive workpiece pressure. 4. Using too fine of belt grit. 5. Workpiece material is prone to belt-clogging, such as soft aluminum. 	<ol style="list-style-type: none"> 1. Decrease belt speed. 2. Replace belt (Page 22). 3. Reduce workpiece pressure against belt. 4. Use coarser grit belt (Page 20). 5. Reduce feed pressure. Use coarser grit belt (Page 20).
Abrasive grit rubs off belt easily.	<ol style="list-style-type: none"> 1. Belt stored in incorrect environment. 2. Belt has been folded or crushed. 3. Belt is too old. 	<ol style="list-style-type: none"> 1. Replace belt (Page 22); store belt in cool, dry area. 2. Replace belt (Page 22). Store belt flat; do not bend or fold belt. 3. Use new belt (Page 22).
Workpiece surface not square when platen/tool rest tilt is set to 0°.	<ol style="list-style-type: none"> 1. Tool rest not perpendicular to platen. 	<ol style="list-style-type: none"> 1. Use machinist square to adjust tool rest tilt/swivel so it is perpendicular to platen.
Workpiece frequently gets pulled out of your hand.	<ol style="list-style-type: none"> 1. Not supporting workpiece properly. 2. Starting workpiece on a leading corner. 	<ol style="list-style-type: none"> 1. Use tool rest to support workpiece (Page 25). 2. Start workpiece on a trailing corner.



Adjusting Platen to Wheels

The platen should extend about $\frac{1}{8}$ " forward from the two front idler wheels in order to produce flat and square grinds. Due to the force and abrasives of grinding, the platen wears as it is used, so you will occasionally need to adjust the platen forward in order for grinds to maintain this adjustment.

Tools Needed	Qty
Hex Wrench $\frac{3}{16}$ "	1
Wrench 17mm	1
Straightedge 12"	1

To adjust platen to wheels:

1. DISCONNECT MACHINE FROM POWER!
2. Remove tool rest and belt.
3. Loosen acorn nuts on front wheel covers shown in **Figure 51**, and adjust covers back so you can place straightedge against platen and wheels in following steps.

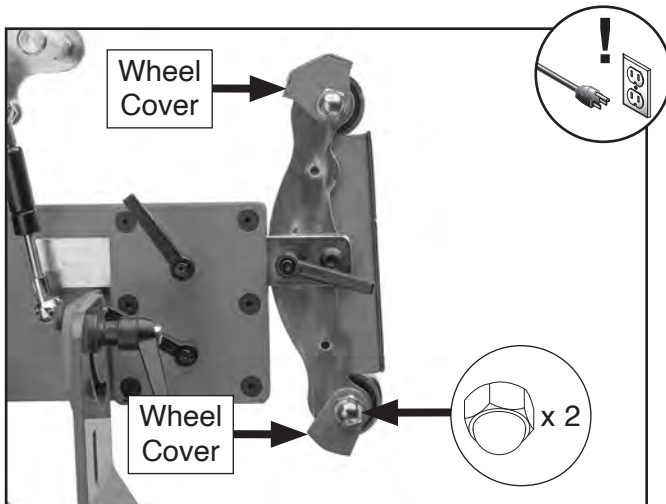


Figure 51. Wheel covers adjusted back and away from platen.

4. Tilt frame so platen is horizontal.
5. Place straightedge across platen graphite and idler wheels, as shown in **Figure 52**, and measure distance between each idler wheel and straightedge.

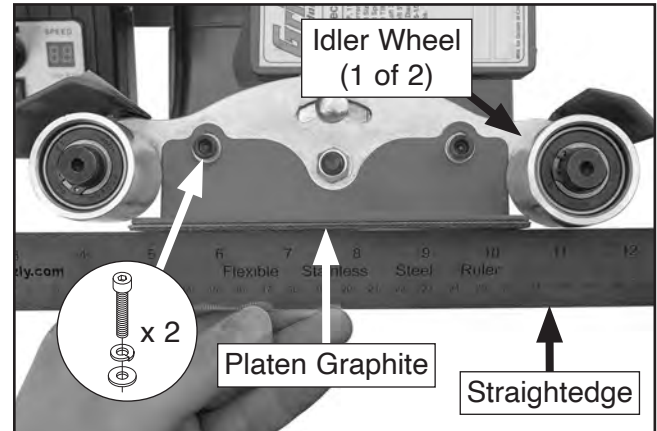


Figure 52. Checking distance between platen graphite and idler wheels.

- If each idler wheel is approximately $\frac{1}{8}$ " from straightedge, platen does not need to be adjusted. Proceed to **Step 7**.
 - If each idler wheel is *not* approximately $\frac{1}{8}$ " from straightedge, proceed to **Step 6**.
6. Loosen (2) cap screws shown in **Figure 52**, adjust platen so each idler wheel is about $\frac{1}{8}$ " from straightedge, then tighten screws.
 7. Adjust wheel covers back to their original position and tighten acorn nuts to secure.



Replacing Gas Strut

The gas strut will eventually wear and will no longer provide enough tension to keep the belt safely tracking on the wheels.

Items Needed	Qty
Open-End Wrenches 10, 12mm	1 Ea.
Replacement Gas Strut (#PT32459012).....	1

To replace gas strut:

1. On new gas strut, thread (2) hex nuts all the way onto ball studs, as shown in **Figure 53**.

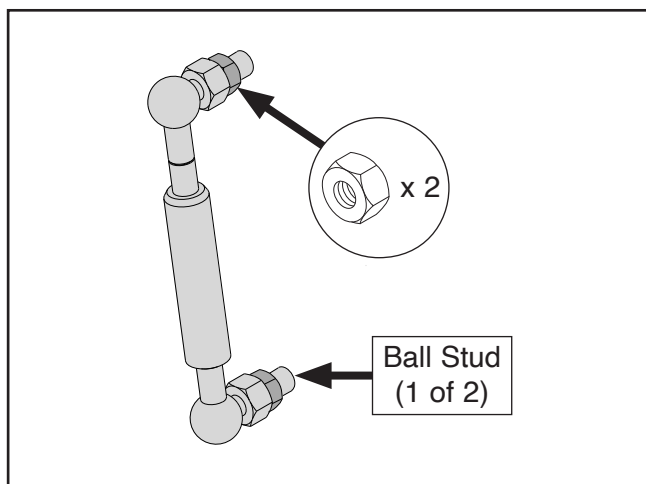


Figure 53. Hex nuts threaded all the way onto ball studs.

2. DISCONNECT MACHINE FROM POWER!
3. Remove tool rest and belt.
4. Adjust frame tilt so platen is vertical (refer to **Adjusting Frame Tilt** on **Page 20**).
5. Turn gas strut ball studs counterclockwise to remove old gas strut (see **Figure 54**).

6. Thread new gas strut ball studs into frame holes, as shown in **Figure 54**.

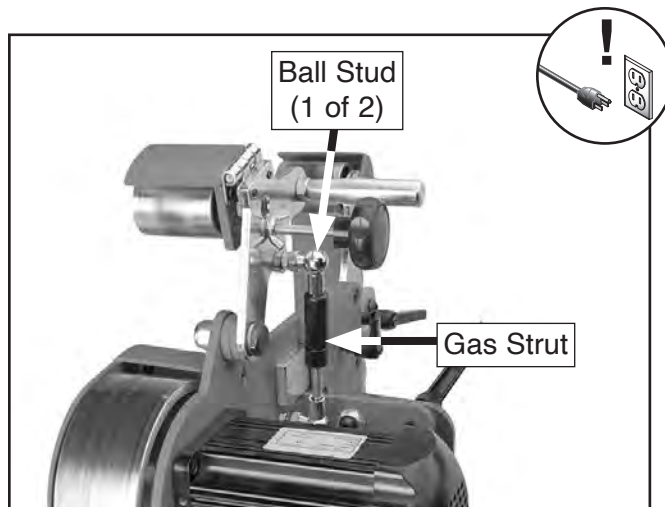


Figure 54. Location of gas strut ball studs.

7. Push belt tension handle (see **Figure 55**) toward frame tilt lock handle to test gas strut compression.

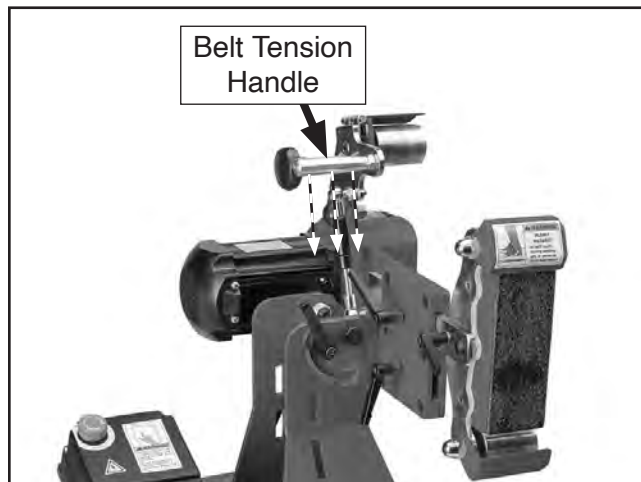


Figure 55. Direction to push belt tension handle.

8. Adjust hex nuts from **Step 1** without turning ball studs until they contact machine frame to secure.



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 after-market parts.

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

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

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

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
















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

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

NOTICE

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

COLOR KEY

BLACK		BLUE		YELLOW		LIGHT BLUE	
WHITE		BROWN		YELLOW GREEN		BLUE WHITE	
GREEN		GRAY		PURPLE		TURQUOISE	
RED		ORANGE		PINK			



Wiring Diagram

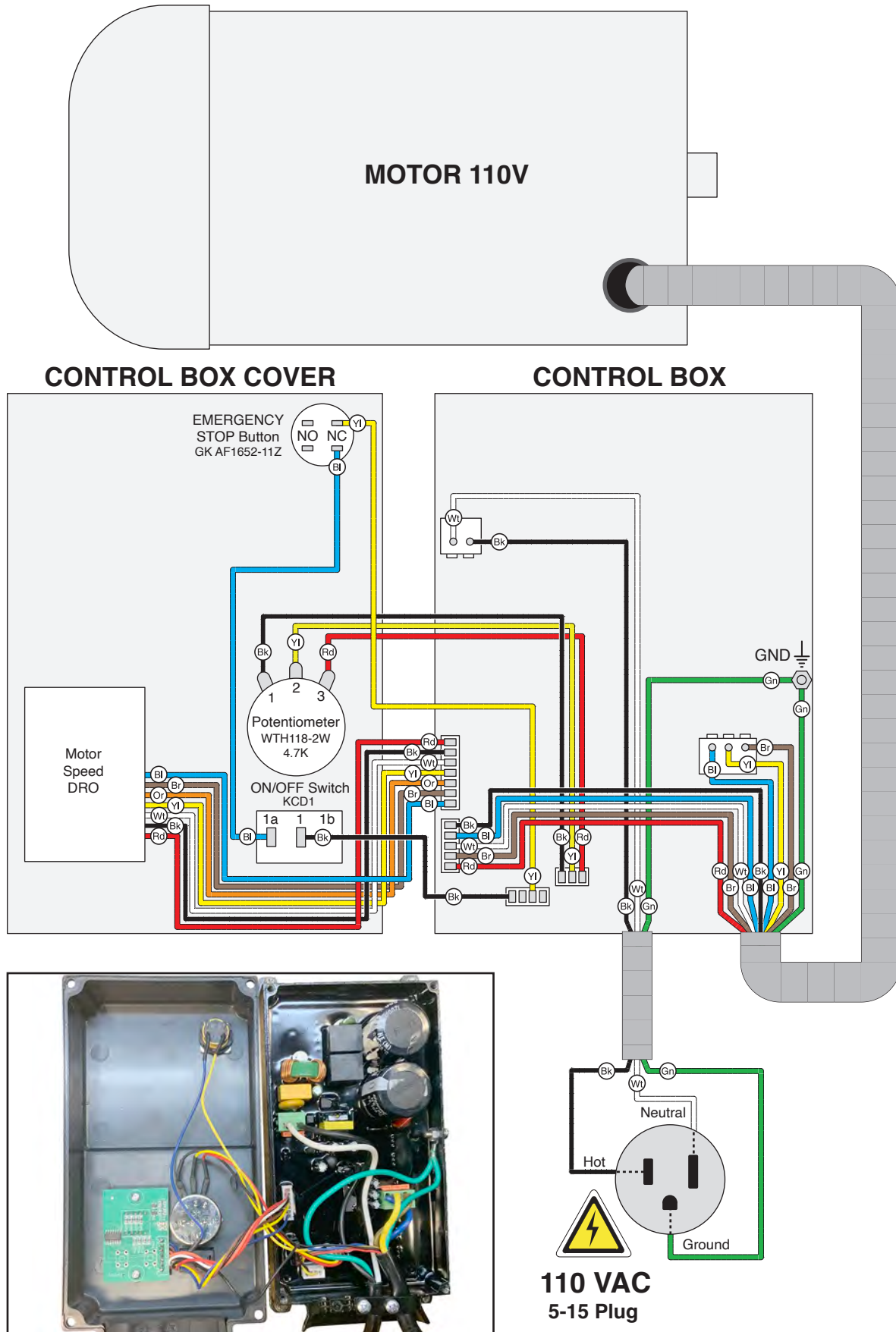


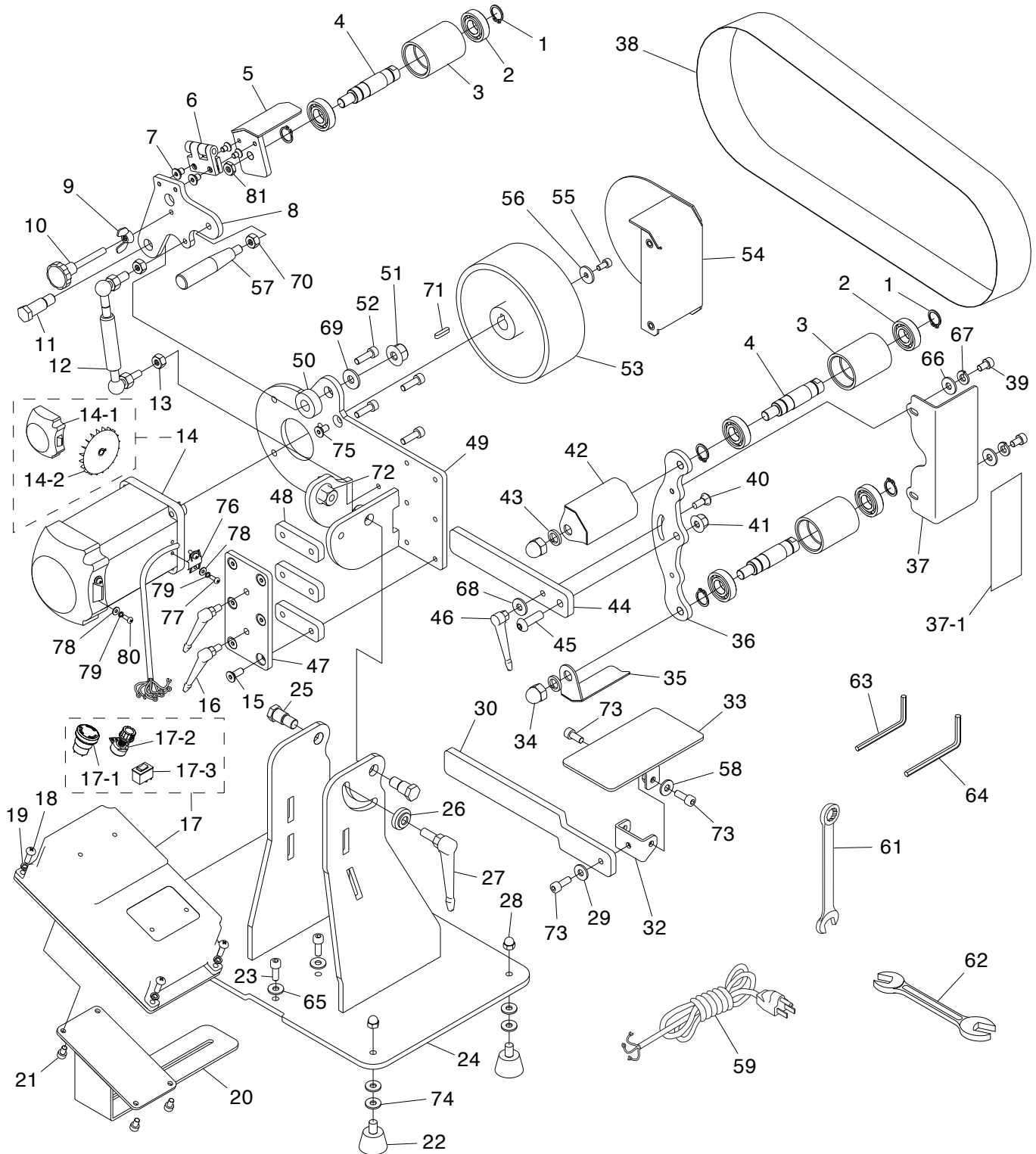
Figure 56. Control box wiring.



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.

Main



Main Parts List


REF	PART #	DESCRIPTION
1	PT32459001	EXT RETAINING RING 15MM
2	PT32459002	BALL BEARING 6002-2RS
3	PT32459003	IDLER WHEEL
4	PT32459004	IDLER WHEEL SHAFT
5	PT32459005	TENSION WHEEL COVER
6	PT32459006	HINGE
7	PT32459007	FLAT HD CAP SCR M5-.8 X 8
8	PT32459008	TENSION PLATE
9	PT32459009	WING NUT M6-1
10	PT32459010	KNOB BOLT M6-1 X 58, 7-LOBE, D40
11	PT32459011	SHOULDER BOLT M10-1.5 X 13, 12 X 22
12	PT32459012	GAS STRUT W/BALL STUD M6-1
13	PT32459013	HEX NUT M6-1
14	PT32459014	MOTOR 3/4HP 110V 1-PH
14-1	PT32459014-1	MOTOR FAN COVER
14-2	PT32459014-2	MOTOR FAN
15	PT32459015	FLAT HD CAP SCR M6-1 X 20
16	PT32459016	ADJUSTABLE HANDLE M6-1 X 10, 50L
17	PT32459017	CONTROL BOX
17-1	PT32459017-1	EMERGENCY STOP BUTTON GK AF1652-11Z
17-2	PT32459017-2	POTENTIOMETER 4.7K WTH118-2W
17-3	PT32459017-3	ON/OFF SWITCH KCD1
18	PT32459018	PHLP HD SCR M5-.8 X 16
19	PT32459019	LOCK WASHER 5MM
20	PT32459020	CONTROL BOX MOUNT
21	PT32459021	CAP SCREW M5-.8 X 8
22	PT32459022	FOOT M6-1 X 14
23	PT32459023	CAP SCREW M6-1 X 16
24	PT32459024	BASE
25	PT32459025	SHOULDER BOLT M10-1.5 X 13, 12 X 12
26	PT32459026	BUSHING 8.5 X 20.3 X 7.7
27	PT32459027	ADJUSTABLE HANDLE M8-1.25 X 20, 60L
28	PT32459028	ACORN NUT M6-1
29	PT32459029	FLAT WASHER 6MM
30	PT32459030	TOOL REST ADJUSTMENT BAR
32	PT32459032	TOOL REST MOUNTING BRACKET
33	PT32459033	TOOL REST
34	PT32459034	ACORN NUT M10-1.5
35	PT32459035	PLATEN WHEEL COVER LOWER
36	PT32459036	PLATEN FRAME
37	PT32459037	PLATEN
37-1	PT32459037-1	GRAPHITE PAD 2" X 5-1/4"
38	PT32459038	BELT 2" X 42" 120-GRIT

REF	PART #	DESCRIPTION
39	PT32459039	CAP SCREW M6-1 X 10
40	PT32459040	CARRIAGE BOLT M6-1 X 16
41	PT32459041	LOCK NUT M8-1.25
42	PT32459042	PLATEN WHEEL COVER UPPER
43	PT32459043	LOCK WASHER 10MM
44	PT32459044	PLATEN ADJUSTMENT BAR
45	PT32459045	BUTTON HD CAP SCR M8-1.25 X 25
46	PT32459046	ADJUSTABLE HANDLE M6-1, 60L
47	PT32459047	COVER PLATE
48	PT32459048	SUPPORT BAR
49	PT32459049	BODY
50	PT32459050	SPACER 12.3 X 24 X 9.5
51	PT32459051	LOCK NUT M10-1.5
52	PT32459052	CAP SCREW M6-1 X 20
53	PT32459053	DRIVE WHEEL 5"
54	PT32459054	DRIVE WHEEL COVER
55	PT32459055	CAP SCREW M5-.8 X 16
56	PT32459056	FLAT WASHER 5.3 X 25 X 2
57	PT32459057	FIXED HANDLE 16 X 70, M8-1.25 X 12
58	PT32459058	FLAT WASHER 6MM
59	PT32459059	POWER CORD 16G 3W 72" 5-15P
61	PT32459061	WRENCH 10MM COMBO
62	PT32459062	WRENCH 12 X 14MM OPEN-ENDS
63	PT32459063	HEX WRENCH 1/8"
64	PT32459064	HEX WRENCH 3/16"
65	PT32459065	FLAT WASHER 6MM
66	PT32459066	FLAT WASHER 6MM
67	PT32459067	LOCK WASHER 6MM
68	PT32459068	FLAT WASHER 6MM
69	PT32459069	FLAT WASHER 10MM
70	PT32459070	HEX NUT M8-1.25
71	PT32459071	KEY 5 X 5 X 20
72	PT32459072	LOCK NUT M8-1.25
73	PT32459073	CAP SCREW M6-1 X 10
74	PT32459074	FLAT WASHER 6MM
75	PT32459075	FLAT HD CAP SCR M6-1 X 16
76	PT32459076	CORD ROUTER
77	PT32459077	PHLP HD SCR M4-.7 X 8
78	PT32459078	FLAT WASHER 4MM
79	PT32459079	LOCK WASHER 4MM
80	PT32459080	PHLP HD SCR M4-.7 X 10
81	PT32459081	HEX NUT M10-1.5 THIN



Labels & Cosmetics

107V2



MODEL T32459
2" X 42" KNIFE-MAKING
BELT SANDER/GRINDER

⚠ WARNING!

Specifications

Motor: 3/4 HP, 110V, Single-Phase, 60 Hz
Full-Load Current Rating: 7.5A
Sanding Belt Size: 2" x 42"
Sanding Belt Speed: 131-4189 FPM
Sanding Belt Tilt: 0°-90°
Platen Tilt: Left 30°, Right 30°
Table Tilt: Left 5°, Right 120°
Drive Wheel Diameter: 5"
Platen Size: 5-1/2" x 2-1/4"
Weight: 38 lbs.

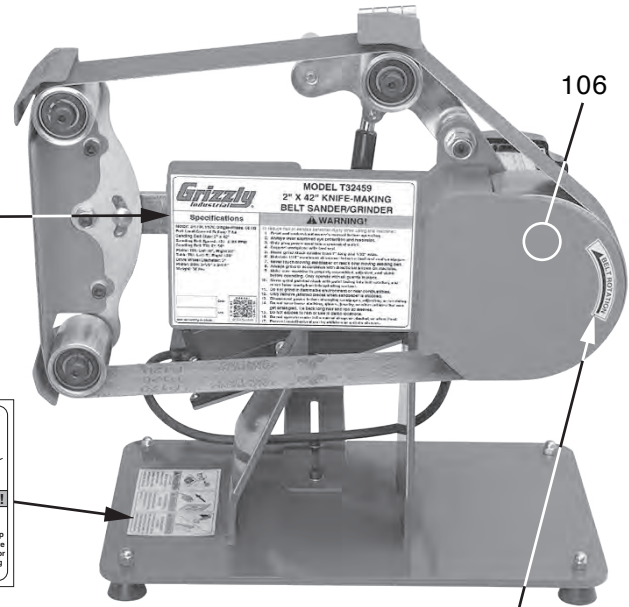
To reduce risk of serious personal injury when using this machine:

1. Read and understand owner's manual before operating.
2. Always wear approved eye protection and respirator.
3. Only plug power cord into a grounded outlet.
4. Support workpiece with tool rest.
5. Never grind stock smaller than 7" long and 1/2" wide.
6. Maintain 1/16" maximum clearance between tool rest and sandpaper.
7. Never touch moving sandpaper or reach over moving sanding belt.
8. Always grind in accordance with directional arrows on machine.
9. Make sure machine is properly assembled, adjusted, and stable before operating. Only operate with all guards in place.
10. Never grind pointed stock with point facing into belt rotation, and never force workpiece into grinding surface.
11. Do not grind in flammable environment or near combustibles.
12. Only remove jammed pieces when sandpaper is stopped.
13. Disconnect power before changing sandpaper, adjusting, or servicing.
14. Do not wear loose clothing, gloves, jewelry, or other articles that can get entangled. Tie back long hair and roll up sleeves.
15. Do not expose to rain or use in damp locations.
16. Do not operate under influence of drugs or alcohol, or when tired.
17. Prevent unauthorized use by children or untrained users.


MANUAL

Scan QR code to visit our Parts Store.

Mfg. for Grizzly in China




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⚠ WARNING!
EYE/LUNG
INJURY HAZARD!
Always wear ANSI-approved safety glasses, face shield, and respirator when using this machine.



⚠ WARNING!
INJURY/SHOCK
HAZARD!
Disconnect power before adjustments, maintenance, or service.



⚠ WARNING!
ENTANGLEMENT
HAZARD!
Tie back long hair, roll up long sleeves, and remove loose clothing, jewelry, or gloves to prevent getting caught in moving parts.

101



⚠ WARNING!
INJURY
HAZARD!
DO NOT touch moving sanding belt, or personal injury may occur!



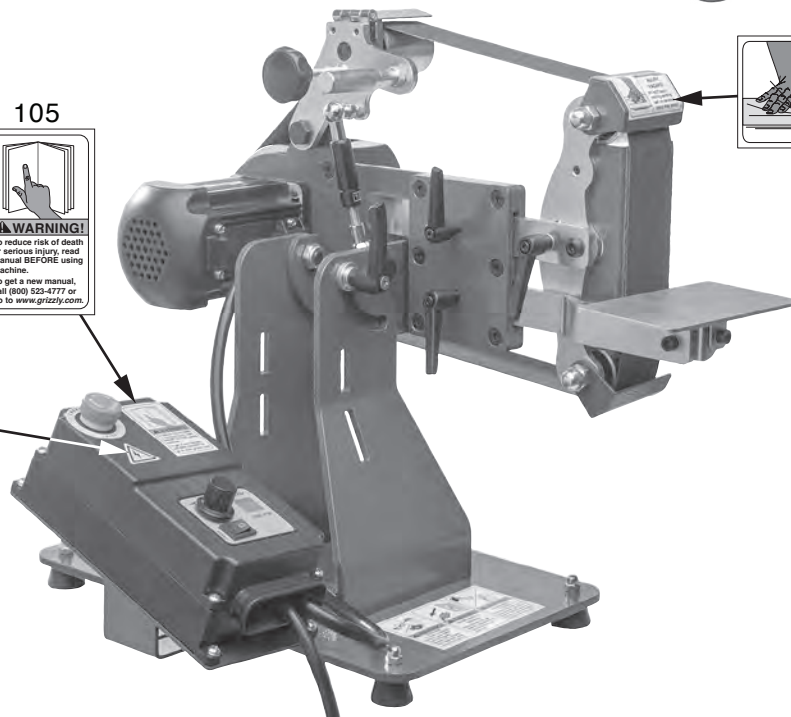
105



⚠ WARNING!
To reduce risk of death or serious injury, read manual BEFORE using machine.
To get a new manual, call (800) 523-4777 or go to www.grizzly.com.

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REF	PART #	DESCRIPTION
101	PT32459101	ABRASION INJURY LABEL
102	PT32459102	BELT ROTATION LABEL
103	PT32459103	COMBO WARNING LABEL
104	PT32459104	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
105	PT32459105	READ MANUAL LABEL
106	PT32459106	TOUCH-UP PAINT, GRIZZLY GREEN
107V2	PT32459107V2	MACHINE ID LABEL V2.12.23

⚠ 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.

For further information about the warranty, visit <https://www.grizzly.com/forms/warranty> or scan the QR code below to be automatically directed to our warranty page.



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