



# MODEL G1066R/G1066Z/G1079R DRUM SANDER OWNER'S MANUAL

*(For models manufactured since 02/24)*



Model G1066R



Model G1079R



Model G1066Z



Model G1079R Only

**Removed pages for  
models other than  
G1066Z 2/20/25**

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#0443 PRINTED IN TAIWAN

V3.02.24

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

# READ THIS FIRST



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

## Model G1066Z

### \*\*\*IMPORTANT UPDATE\*\*\*

For Machines Mfd. Since 12/24  
and Owner's Manual Revised 02/24

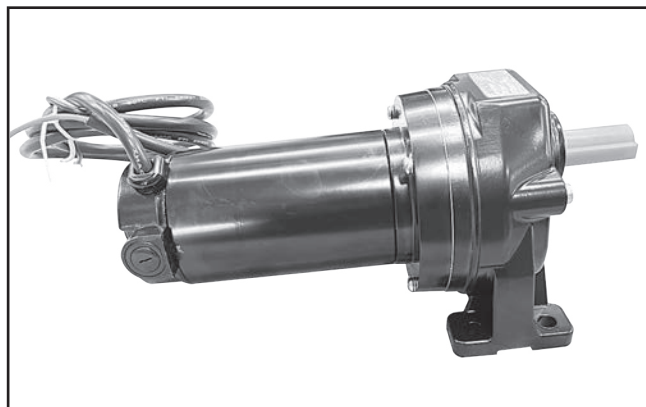
The following changes were recently made since the owner's manual was printed:

- Conveyor motor has changed.
- Added **Replacing Motor Brushes** section.

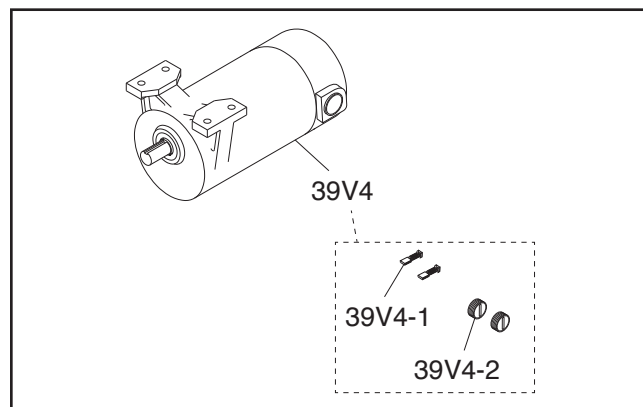
Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

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

## New Conveyor Motor



## Revised Parts



REF	PART #	DESCRIPTION
39V4	P1066Z039V4	CONVEYOR MOTOR 1/3HP 220V 1-PH V4.12.24
39V4-1	P1066Z039V4-1	MOTOR BRUSH 2-PC SET
39V4-2	P1066Z039V4-2	MOTOR BRUSH CAP

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# Replacing Motor Brushes

The Model G1066Z is equipped with a universal motor that uses two carbon motor brushes to transmit electrical current inside the motor. These brushes are considered to be regular "wear items" or "consumables" that will need to be replaced during the life of the motor. The frequency of required replacement is often related to how much the motor is used and how hard it is pushed.

Replace both motor brushes at the same time when the motor no longer reaches full power, or when the brushes measure less than  $\frac{1}{4}$ " in length (new brushes are  $\frac{5}{8}$ " long).

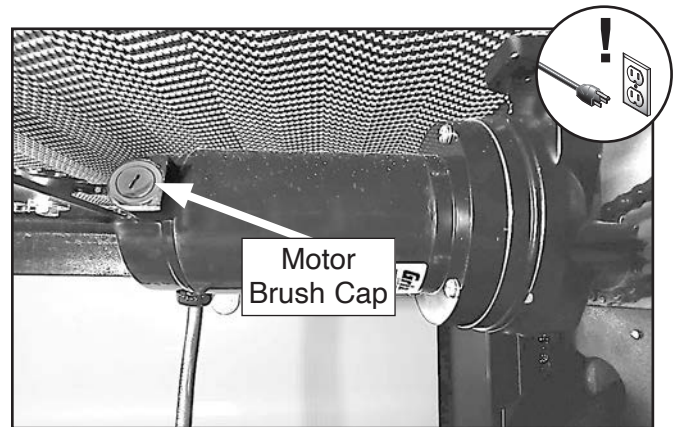
If your machine is used frequently, we recommend keeping an extra set of these replacement brushes on-hand to avoid any downtime.

Items Needed	Qty
Phillips Head Screwdriver #2 .....	1
Flat Head Screwdriver $\frac{1}{4}$ ".....	1
Motor Brushes (P1066Z039V4-1) .....	1 Set

## To replace motor brushes:

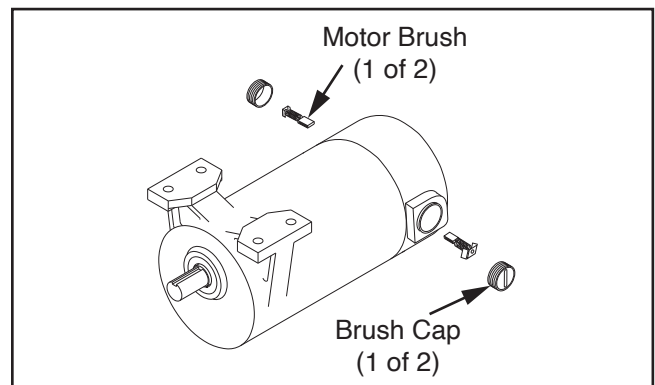
1. DISCONNECT MACHINE FROM POWER!
2. Remove front access panel.

3. Remove motor brush cap (see **Figure 1**) and motor brush from conveyor motor.



**Figure 1.** Location of motor brush cap.

4. Insert new motor brush, then install brush cap (see **Figure 2**).



**Figure 2.** Motor brush and cap installation sequence.

5. Repeat **Steps 3–4** to replace second motor brush.
6. Install front access panel.





## **WARNING!**

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

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

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

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



## **WARNING!**

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

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

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

# Table of Contents

<b>INTRODUCTION .....</b>	<b>2</b>	<b>SECTION 6: MAINTENANCE.....</b>	<b>35</b>
Contact Info .....	2	Schedule .....	35
Machine Differences .....	2	Cleaning Machine .....	35
Manual Accuracy .....	2	Cleaning Sandpaper .....	35
Identification (G1066R).....	3	Lubrication .....	36
Identification (G1066Z).....	4	<b>SECTION 7: SERVICE .....</b>	<b>37</b>
Identification (G1079R).....	5	Troubleshooting .....	37
Controls & Components.....	6	Tracking & Tensioning Conveyor Belt.....	39
Machine Data Sheet (G1066R) .....	9	Making Blocks.....	40
Machine Data Sheet (G1066Z).....	11	Aligning Drums .....	41
Machine Data Sheet (G1079R) .....	13	Adjusting Pressure Rollers .....	43
<b>SECTION 1: SAFETY .....</b>	<b>15</b>	Adjusting Dust Scoop .....	45
Safety Instructions for Machinery .....	15	Tensioning/Replacing V-Belts .....	45
Additional Safety for Drum Sanders .....	17	Replacing Bearings.....	47
<b>SECTION 2: POWER SUPPLY .....</b>	<b>18</b>	<b>SECTION 8: WIRING.....</b>	<b>48</b>
<b>SECTION 3: SETUP .....</b>	<b>20</b>	Wiring Safety Instructions .....	48
Needed for Setup.....	20	G1066R Electrical Components .....	49
Unpacking.....	20	G1066R Wiring Diagram.....	50
Inventory .....	21	G1066Z Electrical Components.....	51
Site Considerations.....	21	G1066Z Wiring Diagram .....	52
Lifting & Placing .....	22	G1079R Electrical Components .....	53
Anchoring to Floor (G1079R) .....	22	G1079R Wiring Diagram.....	54
Assembly .....	23	<b>SECTION 9: PARTS .....</b>	<b>55</b>
Dust Collection.....	24	G1066R Stand & Motor .....	55
Test Run.....	25	G1066R Conveyor Belt & Table.....	56
Recommended Adjustments.....	26	G1066R Drums & Rollers .....	57
Disabling & Locking Switch (G1079R).....	27	G1066Z Stand & Motor.....	60
<b>SECTION 4: OPERATIONS.....</b>	<b>28</b>	G1066Z Conveyor Belt & Table .....	61
Operation Overview .....	28	G1066Z Drums & Rollers .....	62
Stock Inspection & Requirements .....	29	G1079R Stand & Motor .....	65
Setting Depth of Cut .....	30	G1079R Conveyor Belt & Table.....	66
Setting Conveyor Speed (G1066Z) .....	30	G1079R Drums & Rollers .....	67
Monitoring Sanding Load (G1066Z) .....	31	G1066R Labels & Cosmetics .....	70
Sanding.....	31	G1066Z Labels & Cosmetics .....	71
Sanding Tips .....	32	G1079R Labels & Cosmetics .....	72
Choosing Sandpaper .....	32	<b>WARRANTY &amp; RETURNS.....</b>	<b>73</b>
Installing/Replacing Sandpaper .....	33		
<b>SECTION 5: ACCESSORIES .....</b>	<b>34</b>		

# INTRODUCTION

## Contact Info

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

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

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

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

## Machine Differences

Models G1066R, G1066Z, and G1079R are heavy-duty drum sanders with the following differences:

- **Model G1066R** is a 5 HP, 24" drum sander.
- **Model G1066Z** is a 5 HP, 24" drum sander with a variable-speed conveyor and rear drum height micro-adjustment knobs.
- **Model G1079R** is a 2 HP, 16" drum sander.


## 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.

		<b>MODEL GXXXX MACHINE NAME</b>	
<b>SPECIFICATIONS</b>		<b>WARNING!</b>	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure the motor is properly adjusted/setup and	
Specification:		4. power is connected to grounded circuit before starting.	
Weight:		5. Make sure the motor has stopped and disconnect	
		6. power before adjustments, maintenance, or service.	
		7. DO NOT expose to rain or dampness.	
		8. DO NOT modify this machine in any way.	
		9. Keep machine clean and free of debris.	
		10. Maintain machine carefully to prevent accidents.	
Manufactured for Grizzly in Taiwan			

**Manufacture Date** [ ]

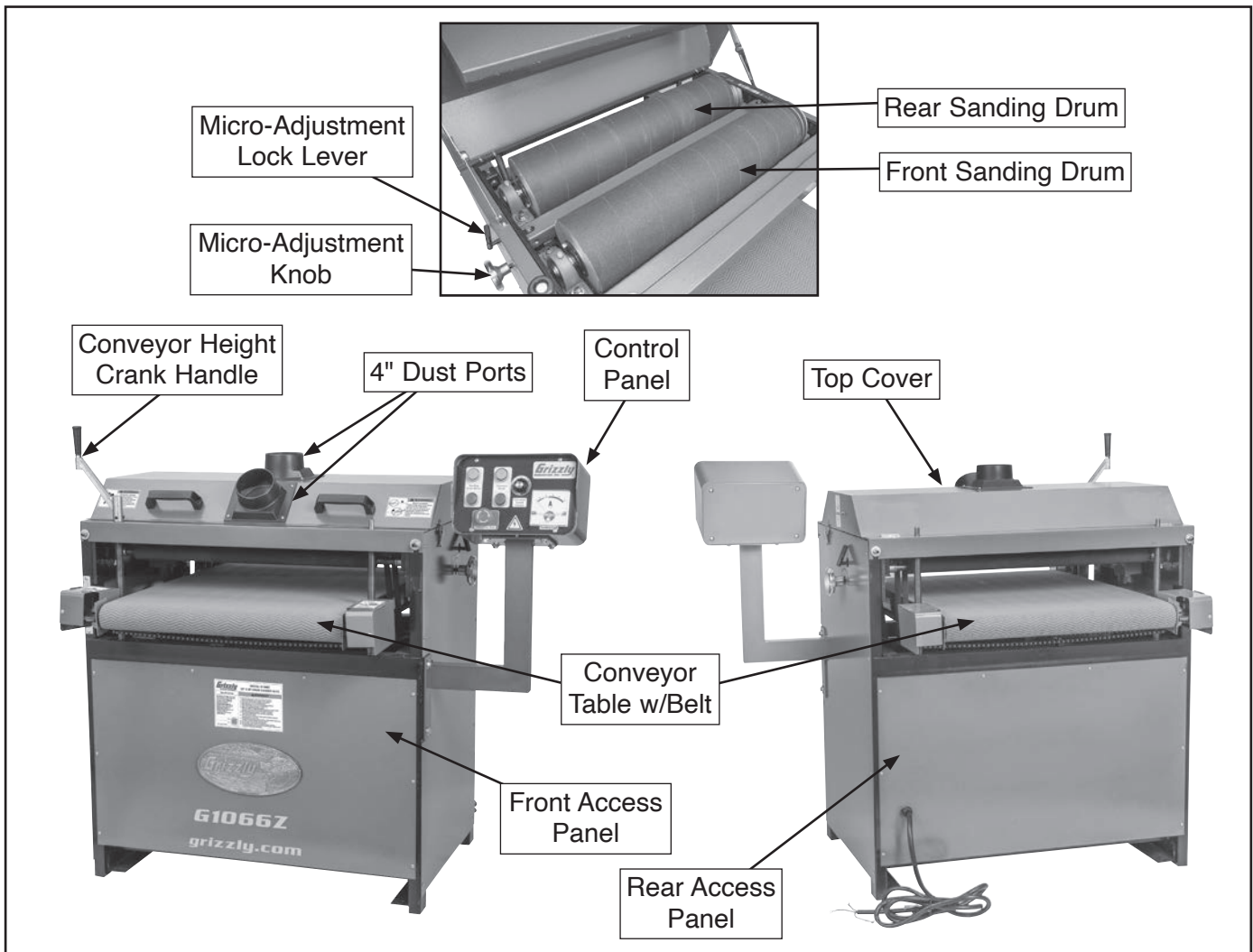
**Serial Number** [ ]





# Identification (G1066Z)

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



## G1066Z

Refer to **Figures 4–6** and the following descriptions to become familiar with the basic controls and components of the Model G1066Z. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

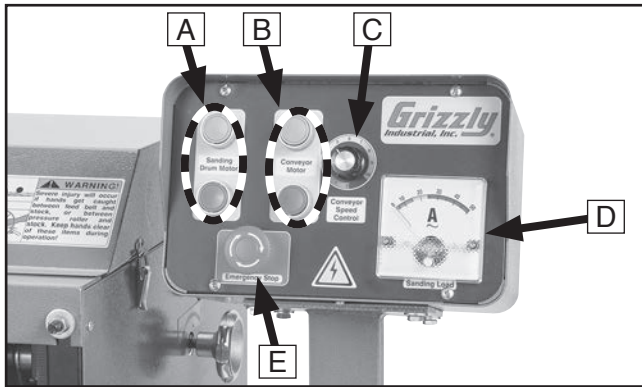


Figure 4. G1066Z control panel.

- A. Sanding Motor ON/OFF Buttons:** Push to start/stop sanding motor.
- B. Conveyor Motor ON/OFF Buttons:** Push to start/stop conveyor motor.
- C. Conveyor Speed Control:** Turn to set conveyor belt speed between 0–10 (0–60 RPM).
- D. Load Meter:** Displays total amp draw of sanding motor.
- E. Emergency Stop Button:** Stops motors when pressed and disables ON buttons. Remains in depressed position until manually reset. Reset by twisting button clockwise until it springs outward.

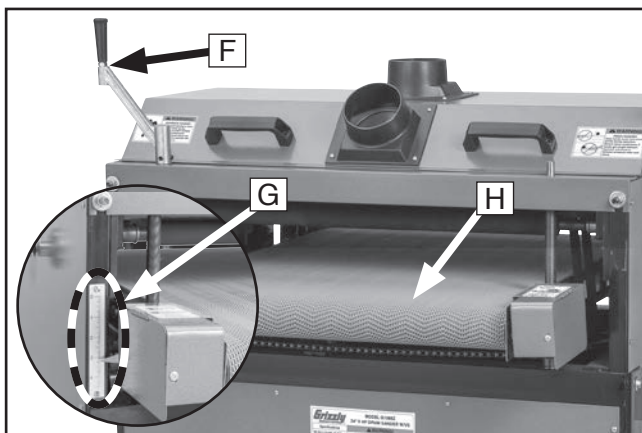


Figure 5. G1066Z front controls.

- F. Conveyor Height Crank Handle:** Rotate to raise or lower conveyor table according to workpiece thickness.
- G. Depth-of-Cut Scale:** Indicates distance between conveyor table and sanding drums.
- H. Conveyor Table w/Belt (Infeed End):** Height-adjustable table with conveyor belt that feeds workpieces toward sanding drums.

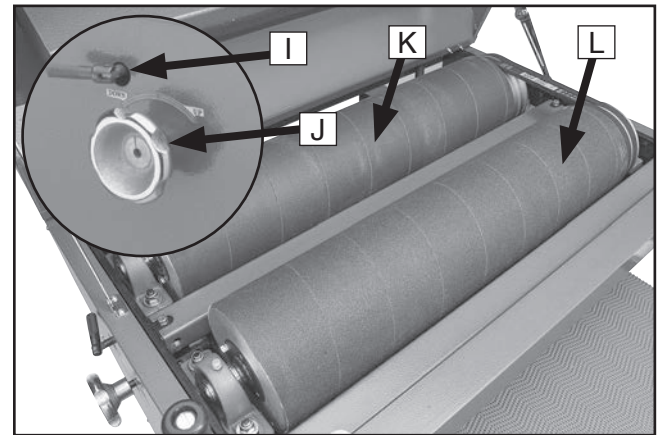


Figure 6. G1066Z sanding drums.

- I. Micro-Adjustment Lock Lever (1 of 2):** Tighten to lock micro-adjustment knob in place.
- J. Micro-Adjustment Knob (1 of 2):** Rotate to make fine height adjustments of outfeed (rear) sanding drum.
- K. Rear Sanding Drum:** Cylindrical drum with machined surface that is covered in hook-and-loop material. Typically wrapped with fine grit sandpaper to perform finish sanding portion of operation.
- L. Front Sanding Drum:** Cylindrical drum with machined surface that is covered in hook-and-loop material. Typically wrapped with coarse grit sandpaper to perform thickness sanding portion of operation.







# MACHINE DATA SHEET

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

## MODEL G1066Z 24" 5 HP DRUM SANDER WITH VS

### Product Dimensions:

Weight..... 435 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 50 x 37 x 44-1/2 in.  
Footprint (Length x Width)..... 34-1/2 x 24 in.

### Shipping Dimensions:

Type..... Cardboard Box on Metal Skids  
Content..... Machine  
Weight..... 484 lbs.  
Length x Width x Height..... 41 x 38 x 43 in.  
Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 27A  
Minimum Circuit Size..... 30A  
Connection Type..... Cord & Plug  
Power Cord Included..... Yes  
Power Cord Length..... 6 ft.  
Power Cord Gauge..... 12 AWG  
Plug Included..... No  
Recommended Plug Type..... L6-30  
Switch Type..... Control Panel w/Magnetic Switch Protection

### Motors:

#### Main

Horsepower..... 5 HP  
Phase..... Single-Phase  
Amps..... 25A  
Speed..... 3450 RPM  
Type..... TEFC Capacitor-Start Induction  
Power Transfer ..... Belt Drive  
Bearings..... Sealed & Permanently Lubricated  
Centrifugal Switch/Contacts Type..... External

#### Conveyor

Horsepower..... 1/3 HP  
Phase..... Single-Phase  
Amps..... 2A  
Speed..... 60 RPM  
Type..... Universal  
Power Transfer ..... Chain Drive  
Bearings..... Sealed & Permanently Lubricated



## Main Specifications:

### Operation Information

Number of Sanding Heads.....	2
Maximum Board Width.....	23-1/2 in.
Minimum Board Width.....	2 in.
Maximum Board Thickness.....	4 in.
Minimum Board Thickness.....	1/8 in.
Minimum Board Length.....	9 in.
Sandpaper Speed.....	2300 FPM
Conveyor Feed Rate.....	0 – 20 FPM
Sandpaper Length.....	181-1/2 in.
Sandpaper Width.....	3 in.

### Drum Information

Infeed Sanding Drum Type.....	Aluminum
Infeed Sanding Drum Size.....	6 in.
Outfeed Sanding Drum Type.....	Aluminum
Outfeed Sanding Drum Size.....	6 in.

### Construction

Conveyor Belt.....	Rubber
Body.....	Steel
Paint Type/Finish.....	Powder Coated

### Other Related Information

Floor To Table Height.....	33 in.
Sanding Belt Tension.....	Hook & Loop
Number of Pressure Rollers.....	3
Pressure Roller Type.....	Rubber
Pressure Roller Size.....	1-5/8 in.
Conveyor Belt Length.....	74 in.
Conveyor Belt Width.....	24 in.
Belt Roller Size.....	1-7/8 in.
Number of Dust Ports.....	2
Dust Port Size.....	4 in.
Mobile Base.....	D2058A, D2246A

## 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:

Hook & Loop Sanding Belt Tension/Sandpaper  
Industrial-Duty Rubber Conveyor Belt  
Two 4" Dust Ports  
Variable Speed Conveyor  
V-Belt Main Motor; Chain Drive Conveyor Motor  
Dual 6" Aluminum Sanding Drums  
Green Powder Coat Finish  
Computer-Balanced Drums  
Four-Leadscrew Table Lifting and Lowering System  
Easy Access Control Panel with Amp Load Meter  
External Micro-Adjustment on Outfeed Drum



# 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

### **WARNING**

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

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

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

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

#### **ELECTRICAL EQUIPMENT INJURY RISKS.**

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

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

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



## WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Drum Sanders

## WARNING

Serious injury or death can occur from getting hands trapped between workpiece and conveyor table and being pulled into machine, or becoming entangled in rotating parts inside machine. Workpieces thrown by sander can strike nearby operator or bystanders with significant force. Long-term respiratory damage can occur from using sander without proper use of a respirator. To reduce the risk of these hazards, operator and bystanders **MUST** completely heed the hazards and warnings below.

**FEEDING WORKPIECE.** Placing fingers between workpiece and conveyor can result in pinching injuries, or possibly getting trapped and pulled into sanding area of machine. **DO NOT** place fingers under bottom of workpiece while feeding it into sander.

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

**POWER DISCONNECT.** An accidental startup while changing sanding belts or performing adjustments or maintenance can result in serious entanglement or abrasion injuries. Make sure machine is turned **OFF**, disconnected from power and air, and all moving parts are completely stopped before changing belts, doing adjustments, or performing maintenance.

**SANDPAPER CONTACT.** Rotating sandpaper can remove a large amount of flesh quickly. Keep hands away from rotating sanding drum(s) during operation. Never touch moving sandpaper.

**AVOIDING ENTANGLEMENT.** Tie back long hair, remove jewelry, and do not wear loose clothing or gloves. These can easily get caught in moving parts. Never reach inside machine or try to clear jammed workpiece while machine is operating. Keep all guards in place and secure.

**WORKPIECE MATERIAL.** This sander is designed to sand only natural wood products or man-made products made from natural wood fiber. **DO NOT** sand any metal products.

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

**KICKBACK.** Occurs when a workpiece is ejected out the front of sander at a high rate of speed toward operator or bystanders. To reduce risk of kickback-related injuries, always stay out of workpiece path, only feed one board at a time, and always make sure pressure rollers are properly adjusted below sanding roller. Never sand workpieces below minimum specifications listed in **Machine Data Sheet**.

## 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.

## WARNING

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

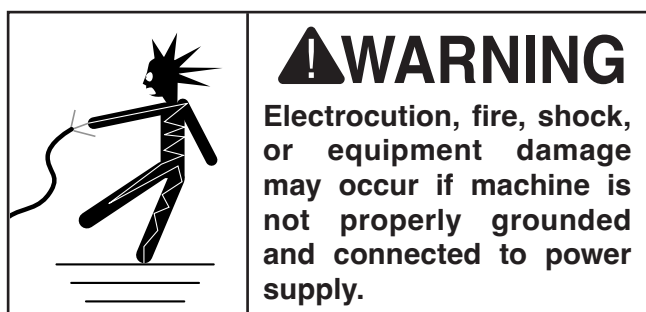




# SECTION 2: POWER SUPPLY

## Availability

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



## 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.

**G1066R Amp Draw at 220V ..... 26 Amps**  
**G1066Z Amp Draw at 220V ..... 27 Amps**  
**G1079R Amp Draw at 220V ..... 9.5 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 Requirements for 220V

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

### G1066R/G1066Z

**Nominal Voltage ..... 208V, 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 30 Amps**  
**Plug/Receptacle ..... NEMA L6-30**  
**Cord ..... "S"-Type, 3-Wire, 12 AWG, 300 VAC**

### G1079R

**Nominal Voltage ..... 208V, 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 15 Amps**  
**Plug/Receptacle ..... NEMA 6-15**  
**Cord ..... "S"-Type, 3-Wire, 14 AWG, 300 VAC**

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.**

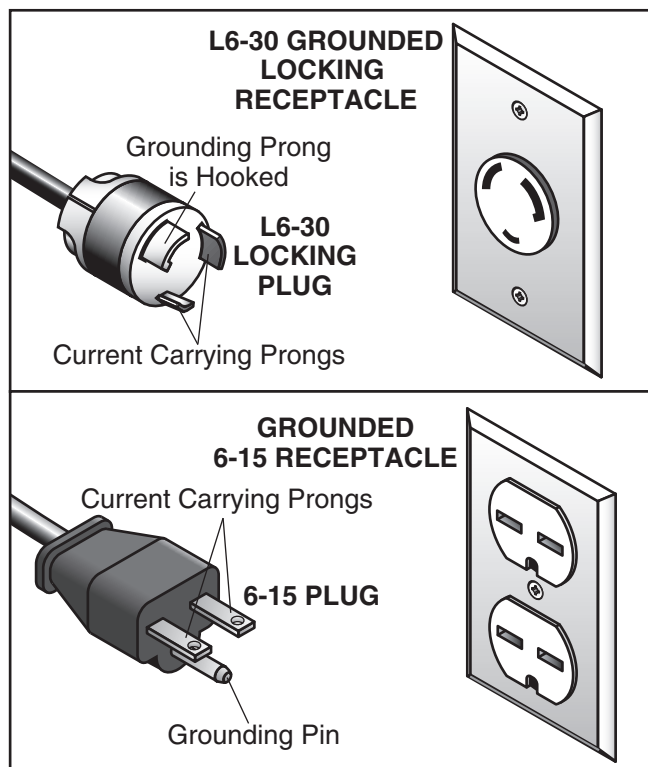
**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel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



## Grounding Instructions

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.

The power cord and plug specified under “Circuit Requirements for 220V” on the previous page has an equipment-grounding wire and a grounding prong. 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 (see figure below).

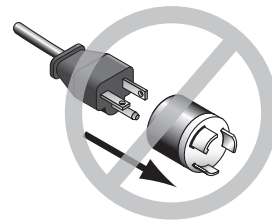


**Figure 10.** Typical L6-30 (G1066R, G1066Z) and 6-15 (G1079R) plugs and receptacles.

## ⚠ 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.**

## ⚠ CAUTION



**No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply 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.

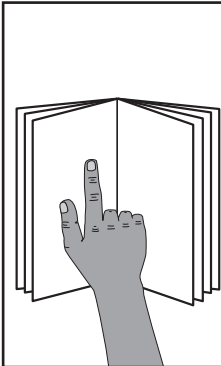
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 (G1066R/Z).....12 AWG**  
**Minimum Gauge Size (G1079R) .....18 AWG**  
**Maximum Length (Shorter is Better).....25 ft.**

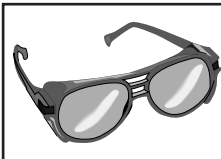


# SECTION 3: SETUP



## ⚠️WARNING

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



## ⚠️WARNING

Wear safety glasses during the entire setup process!



## ⚠️WARNING

### HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

## Needed for Setup

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

Description	Qty
• Additional Person .....	1
• Safety Glasses (for each person).....	1
• Leather Gloves (for each person).....	1 Pair
• Cleaner/Degreaser .....	As Needed
• Disposable Shop Rags.....	As Needed
• Lifting Equipment (Min. 600 lb. rating):	
—Forklift or Hoist .....	1
—Lifting Slings .....	2
• Precision Straightedge 4'.....	1
• Phillips Head Screwdriver #2 .....	1
• Flat Head Screwdriver 1/4".....	1
• Wrench Open-End 14mm.....	1
• Hex Wrench 4mm.....	1
• Wrench or Socket 1/2" (G1066Z) .....	1
• Double-Sided Tape.....	As Needed
• Dust-Collection System .....	1
• 4" Dust Hose (length as needed) .....	2
• 4" Hose Clamps .....	4

## 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.**

Box 1 (Figure 11)	Qty
A. Drum Sander (Not Shown) .....	1
B. Crank Handle .....	1
C. 4" Dust Ports .....	2
D. Tap Screws #8 x 1/2" .....	8
E. Flat Washers 10mm .....	8
F. Control Panel (G1066Z).....	1
G. Front Panel (G1066Z).....	1
H. Micro-Adjustment Knobs (G1066Z) .....	2
I. Tap Screws #8 x 3/8" (G1066Z) .....	8
J. Hex Bolts 5/16"-18 x 1" (G1066Z) .....	2
K. Flat Washers 5/16" (G1066Z) .....	2
L. Hex Wrench 3mm.....	1

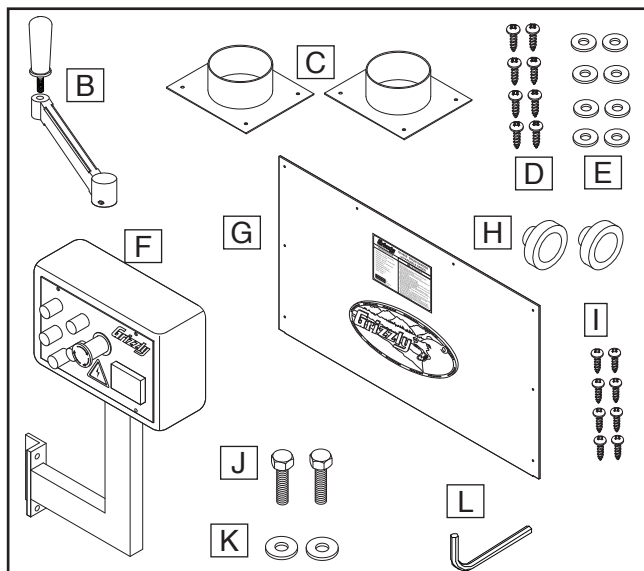


Figure 11. Inventory.

# Site Considerations

## Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

## Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual.

## Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

## Electrical Installation

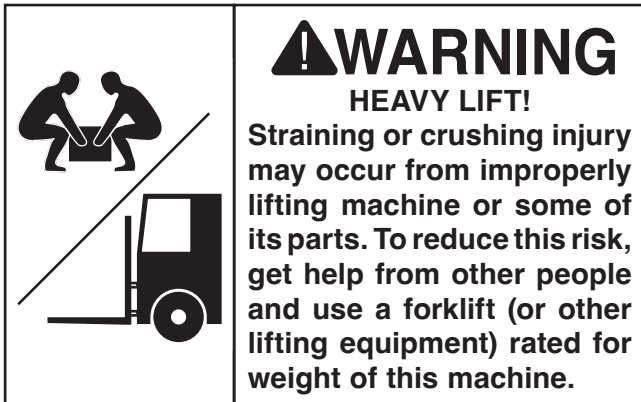
Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

## Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.



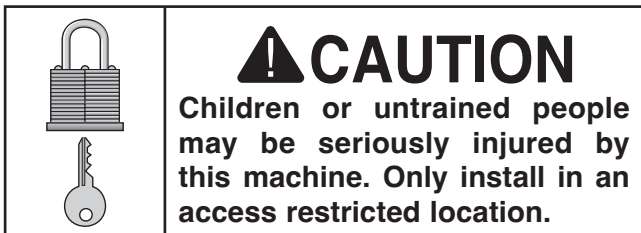
# Lifting & Placing



DO NOT attempt to lift or move machine without using a forklift or necessary assistance from other people.

Review the **Power Supply** section (**Page 18**) and **Site Considerations** section (**Page 21**), then prepare a permanent location for the machine.

**IMPORTANT:** Make sure prepared location is clean and level.



## To lift and place machine:

1. Move machine near its prepared location while still inside shipping box.
2. Remove top and sides of shipping box, then place small items aside in safe location.
3. Unbolt machine from metal skids.
4. Carefully lift machine off metal skids and move it to prepared location, then lower machine into position.

# Anchoring to Floor (G1079R)

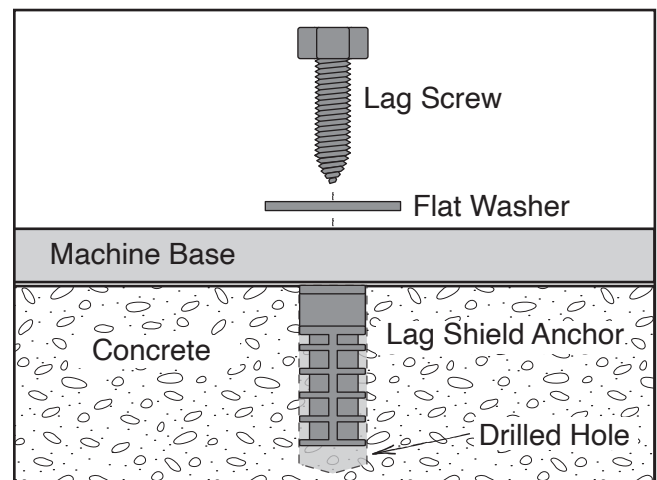
Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

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.



**Figure 12.** Popular method for anchoring machinery to a concrete floor.



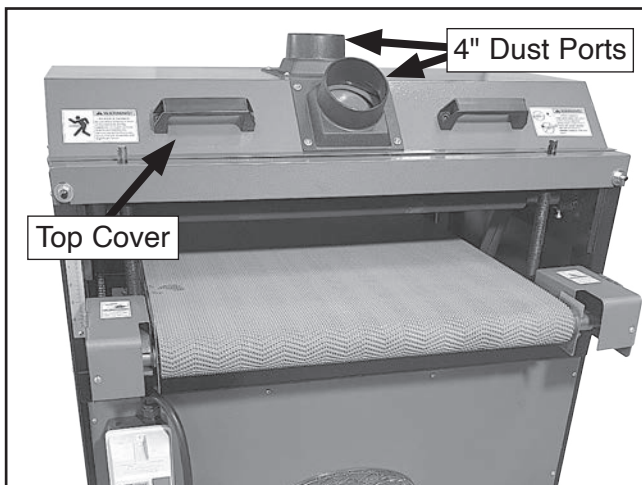


# Assembly

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. Install  $\frac{1}{16}$ " foam tape around bottom side perimeter of each dust port.
2. Attach (2) 4" dust ports to top cover with (8) #8 x  $\frac{1}{2}$ " tap screws and #10 flat washers, as shown in **Figure 13**.



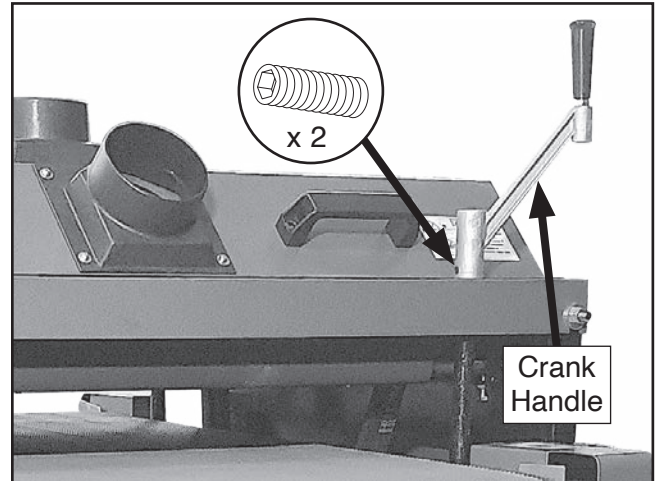
**Figure 13.** Dust ports attached to top cover (G1066R shown).

## ⚠ CAUTION

DO NOT operate machine without an adequate dust-collection system. This machine creates substantial amounts of wood dust while in operation. Failure to use a dust-collection system can result in short- and long-term respiratory illness.

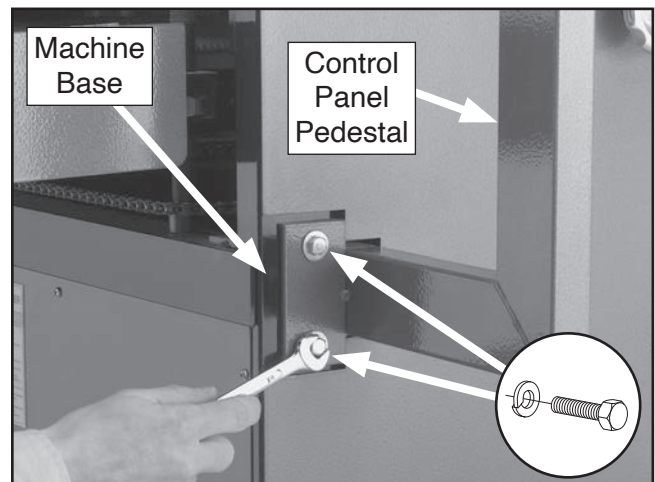
3. Attach crank handle (see **Figure 14**) to leadscrew shaft and secure with (2) pre-installed set screws. Crank handle may be attached to leadscrew on left, right, front or rear of machine, depending on operator preference.

**Note:** Make sure one of the set screws is positioned over flat part of leadscrew shaft.



**Figure 14.** Crank handle attached to right front leadscrew shaft (G1066R shown).

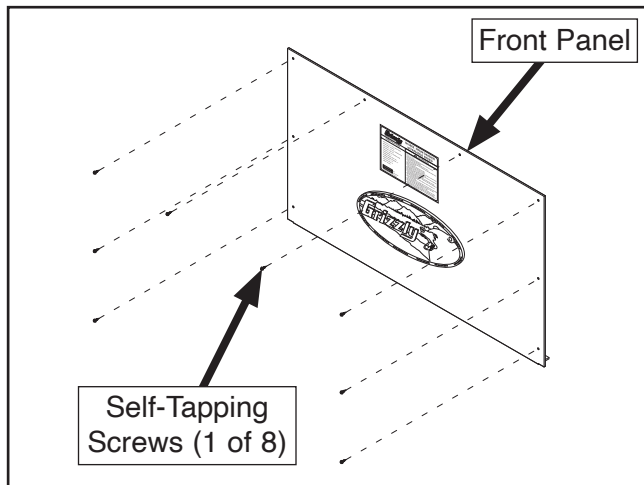
4. **G1066Z Only:** Attach control panel pedestal to right side of machine with (2)  $\frac{5}{16}$ "-18 x 1" hex bolts and (2)  $\frac{5}{16}$ " flat washers, as shown in **Figure 15**.



**Figure 15.** Attaching control panel to machine base.

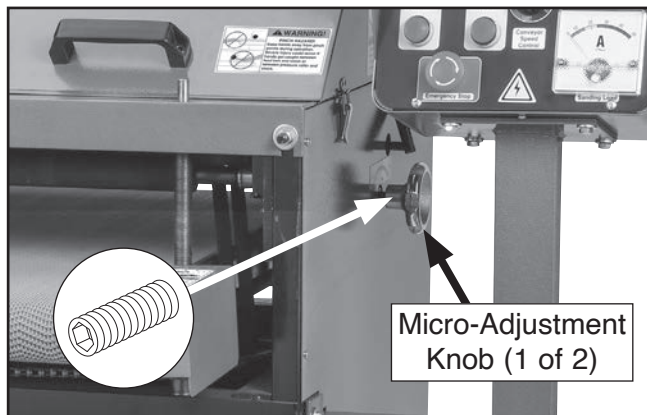


5. **G1066Z Only:** Attach front panel to machine base with (8) #8 x  $\frac{3}{8}$ " self-tapping screws, as shown in **Figure 16**.



**Figure 16.** Diagram of front panel and screw locations.

6. **G1066Z Only:** Slide micro-adjustment knob over shaft and tighten pre-installed set screw, (see **Figure 17**).



**Figure 17.** Location of micro-adjustment knob (1 of 2).

7. Repeat **Step 6** to install micro-adjustment knob on opposite side of machine.

## Dust Collection

### **! CAUTION**

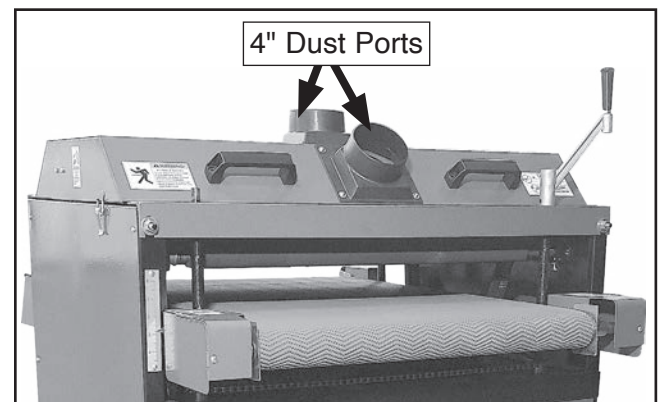
This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

#### **Minimum CFM at Dust Port: 400 CFM**

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

#### **To connect dust collection system to machine:**

1. Fit (2) 4" dust hoses over dust ports (see **Figure 18**), and secure in place with hose clamps.



**Figure 18.** Location of dust ports (G1066R shown).

2. Tug hoses to make sure they do not come off. A tight fit is necessary for proper performance.

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



# Test Run

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

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

## ⚠ 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.

### G1066R/G1079R

For Model G1066R/G1079R, the Test Run verifies that the motors power up and run correctly.

#### To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. **G1079 Only:** Remove padlock from ON button.
4. Turn machine **ON** to verify motor operation, and then turn machine **OFF**. A correctly operating machine will run smoothly with little or no vibration or rubbing noises.

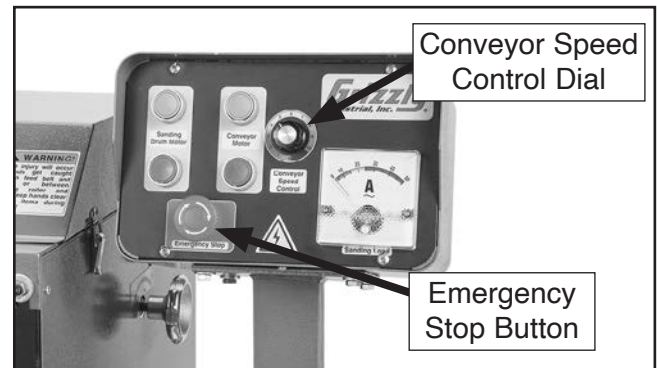
- If machine *runs* smoothly, congratulations, the Test Run is complete!
- If machine *does not run* smoothly, immediately turn machine **OFF** and call Tech Support for help.

### G1066Z

For Model G1066Z, the Test Run verifies the following: 1) the motors power up and run correctly and 2) the Emergency Stop button works correctly.

#### To test run machine:

1. Clear all setup tools away from machine.
2. Push Emergency Stop button (see **Figure 19**).
3. Rotate conveyor speed control dial counter-clockwise to "0".



**Figure 19.** Location of Emergency Stop button.

4. Connect machine to power supply.
5. Twist Emergency Stop button clockwise until it pops out (see **Figure 20**). This resets button so machine will start.



**Figure 20.** Resetting Emergency Stop button.



6. Push Sanding Drum Motor ON button to turn motor **ON**. A correctly operating machine will run smoothly with little or no vibration or rubbing noises.
  - If sanding drums *run* smoothly, proceed to **Step 6**.
  - If sanding drums *do not run* smoothly, immediately turn machine **OFF** and call Tech Support for help.
7. Push Conveyor Motor ON button to turn motor **ON**. Gradually rotate conveyor speed control dial clockwise to increase conveyor speed. A correctly operating machine will run smoothly with little or no vibration or rubbing noises.
  - If conveyor belt *runs* smoothly, proceed to **Step 7**.
  - If conveyor belt *does not run* smoothly, immediately turn machine **OFF** and call Tech Support for help.
8. Push Emergency Stop button to turn machine **OFF**.
9. WITHOUT resetting Emergency Stop button, press Sanding Drum Motor ON button and Conveyor Motor ON button. Motors should not start.
  - If both motors *do not start*, the Emergency Stop safety feature is working correctly. Congratulations! The Test Run is complete.
  - If either motor *starts* (with Emergency Stop button pushed in), immediately disconnect power from machine. The Emergency Stop safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

## Recommended Adjustments

---

For your convenience, the adjustments listed below have been performed at the factory and no further setup is required to operate your machine. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

### Factory adjustments that should be verified:

Tracking & Tensioning Conveyor Belt.....**Page 39**  
 Aligning Drums .....**Page 41**  
 Adjusting Pressure Rollers ..... **Page 43**

### Tensioning V-Belts

The final step in the setup process must be done after approximately 16 hours of operation. During this first 16 hours, the belt(s) will stretch and seat into the pulley grooves. After this time, you must re-tension the belt(s) to avoid slippage and burn out. Refer to **Page 45** when you are ready to perform this important adjustment.

**Note:** *Pulleys and belt(s) can get hot. This is a normal condition. Allow them to cool before making adjustments.*

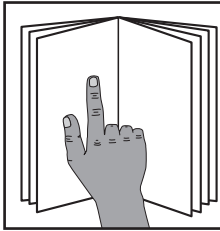
*A small amount of black belt dust at the bottom of the belt housing is normal during the life of the machine and does not indicate a problem with the machine or belt.*





# SECTION 4: OPERATIONS

## Operation Overview

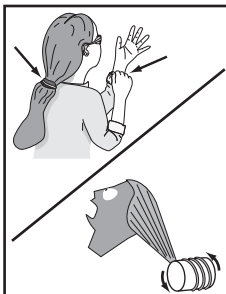
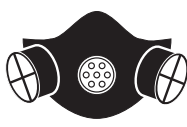


### !WARNING

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

### !WARNING

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



### !WARNING

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

## NOTICE

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

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

1. Examines workpiece to verify it is suitable for sanding and determines which sandpaper grit size to use.
2. Verifies workpiece has necessary outfeed clearance and support. If workpiece is overly long and difficult to handle, operator uses a roller support stand or an assistant to assist with feeding.
3. Adjusts conveyor height to approximate workpiece thickness.

**Note:** During initial pass with a new workpiece, operator adjusts conveyor height as necessary so workpiece only makes light contact with sanding belt and does not overload sander.

4. Puts on safety glasses, respirator, and any other required protective equipment.
5. Starts dust-collection system, and then drum sander. Waits for sanding drums and conveyor belt to reach full speed. If equipped, sets conveyor speed for the specific type and finish of workpiece.
6. Feeds workpiece into sander by placing front end on infeed side of conveyor table and supporting back end until workpiece engages with pressure rollers.
7. Receives workpiece from outfeed side of conveyor table.
8. Raises height of conveyor table a small amount (typically  $\frac{1}{4}$  of a full rotation of crank handle), then repeats the feeding process of workpiece through sander.
9. Changes sandpaper to a finer grit, as needed.
10. Repeats **Steps 6–9** as needed, turns sander **OFF**, and disconnects it from power.





# Stock Inspection & Requirements

Some workpieces are not safe to sand, or they may require further preparation before they can be safely sanded without increasing risk of injury to the operator or damaging the sanding belt or the sander.

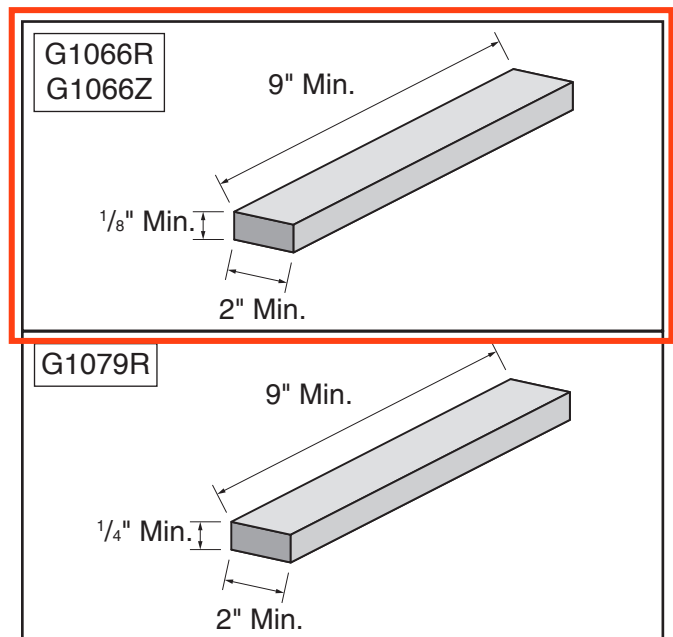
**Before sanding, inspect all workpieces for the following:**

- **Material Type:** This machine is intended for sanding natural and man-made wood products, and laminate-covered wood products. This machine is NOT designed to sand glass, stone, tile, plastics, drywall, cementitious backer board, metal, etc.

Sanding metal objects can increase the risk of fire. Sanding improper materials increases the risk of respiratory harm to the operator and bystanders due to the especially fine dust inherently created by all types of sanding operations—even if a dust collector is used. Additionally, the life of the machine and sanding belts may be greatly reduced (or immediately damaged) from sanding improper materials.

- **Foreign Objects:** Tramp metal, nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While sanding, these objects can become dislodged and tear the sanding belt. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT sand the workpiece.
- **Wet or "Green" Stock:** Sanding wood with a moisture content over 20% causes unnecessary clogging and wear on the sanding belt, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to sand because they are unstable and often unpredictable when being sanded. DO NOT use workpieces with these characteristics!

- **Excessive glue or finish:** Sanding workpieces with excess glue or finish will load up the abrasive, reducing its usefulness and lifespan.
- **Minimum Stock Dimensions:** DO NOT sand boards less than 9" long, 2" wide, and 1/8" thick (G1066R/G1066Z) or 1/4" thick (G1079R) to prevent damage to the workpiece and to reduce the risk of your hands contacting the abrasive belt (see **Figure 23**).



**Figure 23.** Minimum dimensions for sanding.



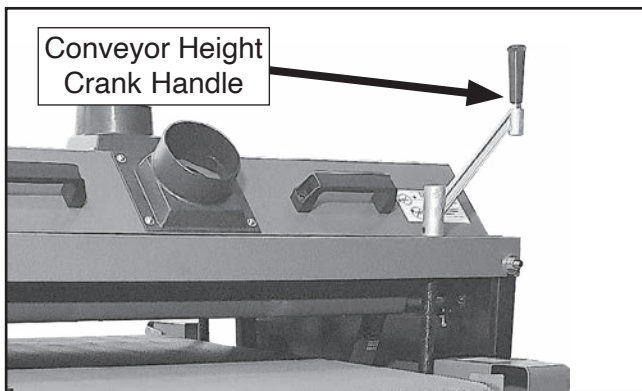
# Setting Depth of Cut

The optimum depth of cut will vary based on the type of wood, feed rate, and sandpaper grit. Under most sanding conditions, the depth should not exceed  $\frac{1}{64}$ " (approx.  $\frac{3}{4}$  turn of the handwheel). Each full turn of the conveyor height handwheel raises the conveyor table approximately 0.020". Attempts to remove too much material can cause jamming, wood burning, rapid paper wear or tearing, poor finish, and belt slippage.

## To set depth of cut:

1. Rotate conveyor height crank handle, shown in **Figure 24**, until conveyor is well below sanding drum, then raise conveyor, allowing a gap between workpiece and sanding drum.

**Note:** When adjusting the conveyor to sand a thicker workpiece, lower and then raise the conveyor to remove backlash from the adjustment mechanism.



**Figure 24.** Location of conveyor height crank handle (G1066R shown).

2. Turn sanding drums and conveyor **ON** and feed workpiece into sander. SLOWLY raise conveyor table until workpiece makes light contact with sanding drums. This is the correct height to begin sanding the workpiece.
3. After initial pass, rotate handwheel  $\frac{1}{4}$  turn ( $\frac{1}{64}$ " or 0.4mm) or less; the maximum depth for most sanding conditions.

**Note:** Each full rotation of conveyor elevation handwheel raises conveyor table approximately 0.06" ( $\frac{1}{16}$ ") or 1.5mm.

# Setting Conveyor Speed (G1066Z)

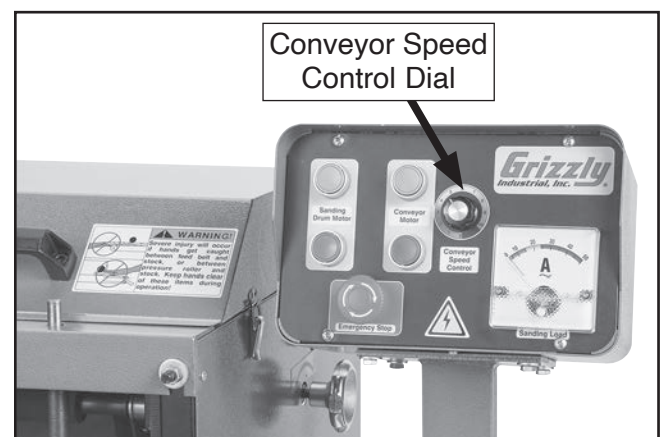
The Conveyor Speed Control dial allows you to set the conveyor speed from 0–10 (0–20 FPM). The correct speed to use depends on the type of stock you are using (hardwood vs. softwood) and the stage of finish you are at with that workpiece.

As a general rule, a slower speed will sand the surface smoother, but runs the risk of burning the wood; a faster speed will remove material faster, but runs the risk of overloading the motor. Use trial-and-error to determine the best settings for your specific applications.

## To set conveyor speed:

1. Set conveyor speed control to "0," and then turn conveyor motor **ON**.
2. Slowly rotate Conveyor Speed Control dial clockwise to increase conveyor speed (see **Figure 25**).

— If conveyor speed is too high, turn control counterclockwise to decrease conveyor speed.



**Figure 25.** Location of Conveyor Speed Control dial (G1066Z).

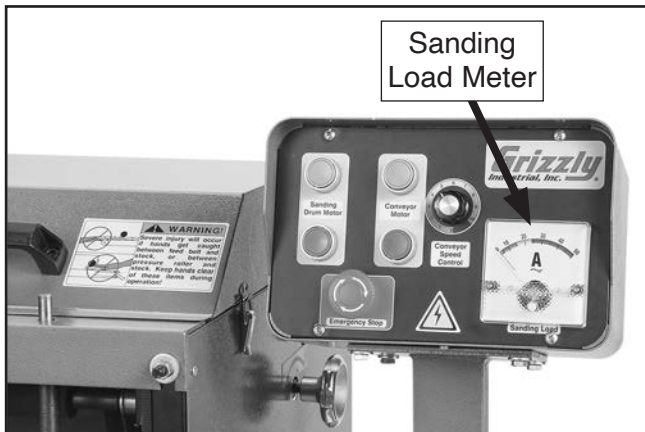


# Monitoring Sanding Load (G1066Z)

The Sanding Load meter (see **Figure 26**) displays the amperage draw of the sanding drum motor. The needle moves to the right when you increase the load on the sanding drums and moves to the left when you decrease the load. Use this meter to avoid overloading your machine with too heavy of a cut.

**IMPORTANT:** NEVER exceed 27 amps—this is the maximum that your machine can safely handle!

Since various types of stock will react differently with various loads, use trial-and-error to determine the best settings for your applications. As a general rule, always start with a small load and work your way up. We recommend that you do not push your machine to its maximum load; instead, make multiple passes or install a coarser grit paper.



**Figure 26.** Location of Sanding Load meter (G1066Z).

## NOTICE

Overloading the motor or pushing the sander to failure weakens the electrical system. Repeatedly doing so is abuse to the machine that will cause motor, capacitor, or circuit breaker damage, which is not covered under warranty.

# Sanding

## ⚠ WARNING

**DO NOT** sand more than one board at a time. Minor variations in thickness can cause one board to be propelled by the rapidly spinning sanding drum and ejected from the machine. **NEVER** stand directly in front of the infeed area of the machine. Doing so could result in severe personal injury.

### To sand a workpiece:

1. Adjust conveyor height (refer to **Setting Depth of Cut** on **Page 30**).
2. Make sure dust-collection hoses and collection system are secured and turned on before starting sander.
3. Turn machine **ON** and feed workpiece through sander. To reduce likelihood of injury, retrieve workpiece by standing to side of machine—not at outfeed end.
4. Run wide stock through two or three times without adjusting conveyor height. Turn stock 180° between passes to ensure an evenly sanded surface.
5. Turn machine **OFF**.

**Tip:** For best sanding results, always sand with the grain during finish passes.



# Sanding Tips

- DO NOT edge sand boards. This can cause boards to kickback, causing serious personal injury. Edge sanding boards also can cause damage to the conveyor belt and sandpaper.
- DO NOT sand more than one board at a time side by side. Minor variations in thickness can cause one board to be propelled by the rapidly spinning sanding drum and ejected from the machine.
- NEVER stand directly in front of the infeed area of the machine. Failure to do so could result in severe personal injury.
- DO NOT sand boards less than 9" long, 2" wide, and 1/8" thick (G1066R/G1066Z) or 1/4" thick (G1079R) to prevent damage to the workpiece and to reduce the risk of your hands contacting the abrasive belt.
- Sanding workpieces with high-resin content or with applied finishes can quickly contaminate sandpaper beyond the point where it can be properly cleaned. This will produce poor sanding results. In this case, use a different workpiece, remove the applied finishes, or frequently clean/replace the sandpaper strip.
- Replace coarse grit sandpaper with a finer grit to achieve a smoother finish.
- Lower the conveyor table a maximum of 1/4 turn of the handwheel until the workpiece is the desired thickness.
- Reduce snipe when sanding more than one board of the same thickness by feeding them into the sander with the front end of the second board touching the back end of the first board.
- Feed boards into the sander at different places on the conveyor to maximize sandpaper life and prevent uneven conveyor belt wear.
- Extend the life of the sandpaper by regularly using a PRO-STIK® sanding pad (see **Page 34**).

- Run wide stock through two or three times without adjusting table height. Turn stock 180° between passes to ensure an evenly sanded surface.
- When sanding workpieces with irregular surfaces, such as cabinet doors, take very light sanding passes to prevent gouges. When the drum moves from sanding a wide surface to sanding a narrow surface, the load on the motor will be reduced, and the drum will speed up, causing a gouge.
- When sanding workpieces with a bow or crown, place the high point up or cupped side down to prevent the workpiece from rocking and take very light passes.
- Feed the workpiece at an angle to maximize stock removal and sandpaper effectiveness, but feed the workpiece straight to reduce sandpaper grit scratches for the finish passes.

## Choosing Sandpaper

There are many types of sandpaper rolls to choose from. We recommend Aluminum Oxide for general workshop environments. Below is a chart that groups abrasives into different classes, and shows which grits fall into each class.

Grit	Class	Usage
36	Extra Coarse	Rough sawn boards, thickness sanding, and glue removal.
60	Coarse	Thickness sanding and glue removal.
80–100	Medium	Removing planer marks and initial finish sanding.
120–180	Fine	Finish sanding.

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





The Model G1066R/G1066Z/G1079R allows you to place a different grit sandpaper on each drum. The front drum should have a coarser grit than the rear. Usually this translates into combinations of successive group types. A common selection for stock that is planed before being sanded is a 100/150 grit combination.

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

# Installing/Replacing Sandpaper

The Model G1066R/G1066Z/G1079R is designed to use 3" wide hook-and-loop sandpaper rolls.

Items Needed	Qty
Straightedge 24" .....	1
Razor Knife.....	1
Strapping Tape 3/4".....	As Needed
Sandpaper (for each drum):	
—G1066R.....	3" x 181 1/2"
—G1066Z.....	3" x 181 1/2"
—G1079R.....	3" x 129 1/2"

## To install/replace sandpaper:

1. DISCONNECT MACHINE FROM POWER!
2. Open dust hood to expose drums.
3. Remove tape from both ends of drum.
4. Carefully unwrap sandpaper from drum.
5. Use old sandpaper as pattern or use example in **Figure 27** to cut new one.

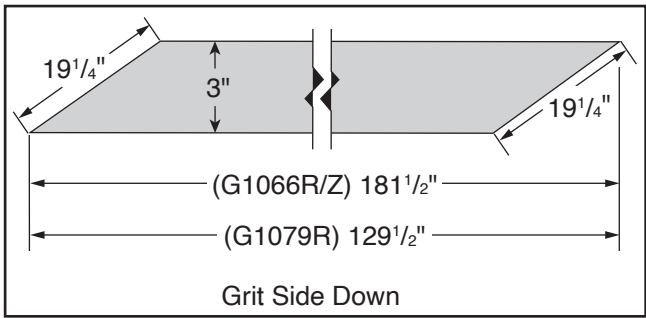


Figure 27. Sandpaper pattern.

6. Starting with right side of drum, position end of sandpaper flush with end of drum (see **Figure 28**), then rotate drum clockwise (push top of drum toward back of machine), keeping edge of sandpaper even with end of drum.



Figure 28. Example of wrapping sandpaper around drum.

**IMPORTANT:** If your sandpaper has directional arrows printed on backing, point arrows toward rear of machine when you begin to wrap sandpaper around drum.

7. Continue to rotate drum clockwise while wrapping sandpaper around drum.

**Note:** Keep tension on sandpaper as you wrap. Leave approximately 1/32" gap between edges of sandpaper and ensure sandpaper does not overlap or have bubbles.

8. Wrap 2–3 layers of strapping tape around each end of drum.

**Note:** Wrap tape in same direction as sandpaper.

9. Repeat **Steps 3–8** for second drum.





# 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.

**Aluminum Oxide, H&L Sanding Rolls 3" x 50'**  
**H4422—60-Grit:** Use for thickness sanding and glue removal.

**H4779—80-Grit:** Use for removing planer marks and initial finish sanding.

**H4423—100-Grit:** Use for removing planer marks and initial finish sanding.

**H4780—120-Grit:** Use for finish sanding.

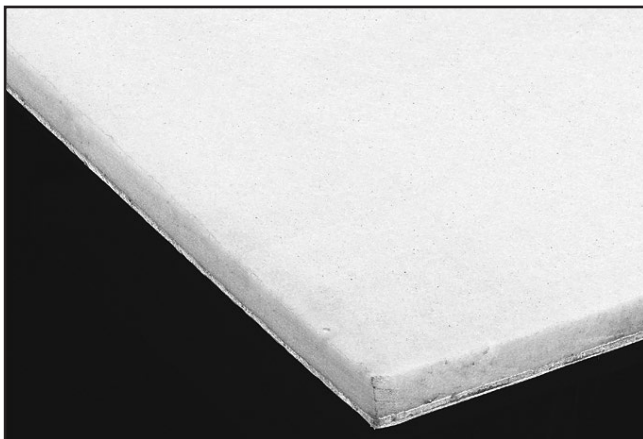
**H4424—150-Grit:** Use for finish sanding.

**T21255—180-Grit:** Use for finish sanding.

**T21256—220-Grit:** Use for finish sanding.

### **Model D3003—PRO-STIK® Cleaning Pad**

Extend the life of your sandpaper! Just feed this crepe-rubber cleaning pad through your drum sander to remove dust build-up from the sandpaper without damage. Measures 15" x 20" x 3/4".



**Figure 29.** D3003 PRO-STIK® Cleaning Pad.

### **T28172—14" x 39" Heavy-Duty Roller Table**

### **T28369—14" x 78" Heavy-Duty Roller Table**

### **T28370—14" x 118" Heavy-Duty Roller Table**

Increase material handling and processing efficiency with one or more of these Heavy-Duty Roller Tables. Ideal for easily positioning of material into sander. Simply place a roller table on one or both sides of your sander and production time is automatically improved!



**Figure 30.** Heavy-duty roller tables.

### **G0862—3 HP Portable Cyclone Dust Collector**

The G0862 features a 3 HP motor, a whopping 1941 CFM of airflow capacity, and a 45-gallon collection capacity. It's packed with features like a quick-release collection drum, latching system, high-efficiency, two-stage separation driven by a 15" welded steel impeller, durable powder coated finish, and a heavy-duty steel frame and housing.

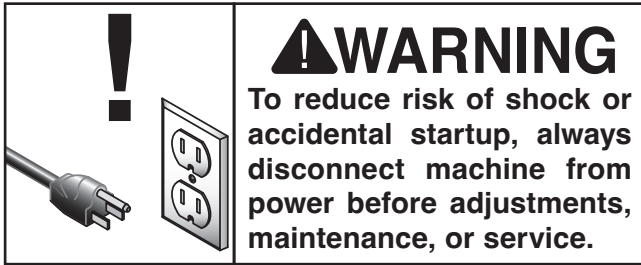


**Figure 31.** Model G0862 3 HP Portable Cyclone Dust Collector.

**order online at [www.grizzly.com](http://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 maintain a low risk of injury and proper machine operation, if you ever observe any of the items below, shut down the machine immediately and fix the problem before continuing operations:

- Loose mounting bolts.
- Worn or damaged sandpaper.
- Worn switch or buttons.
- Any other unsafe condition.

### Daily Maintenance

- Lubricate conveyor roller bushings.

### Weekly Maintenance

- Clean/vacuum dust buildup from underneath top cover.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Lubricate pillow bearings.

### Monthly Check

- Clean/vacuum dust buildup from inside cabinet and off of the motor.
- V-belt tension, damage, and wear.

### Biannual Maintenance

- Lubricate conveyor table leadscrews and sprockets.

## Cleaning Machine

Cleaning the Model G1066R/G1066Z/G1079R 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.

## Cleaning Sandpaper

To increase the working life of your sandpaper, clean it whenever you notice a decrease in performance due to heavy loading of material. Use a Model D3003 PRO-STIK® Cleaning Pad, as shown in **Figure 32**.

### To clean sandpaper:

1. Set conveyor to thickness of cleaning pad.
2. Run pad through sander two or three times, as shown in **Figure 32**. DO NOT take too deep of a cut—the sandpaper should barely touch cleaning pad!



**Figure 32.** Example of using D3003 PRO-STIK® Cleaning Pad to clean sandpaper.



# Lubrication

The conveyor roller bushings should be lubricated daily, while the pillow bearings, elevation leadscrews, and sprockets should be lubricated periodically, depending on usage. See below for some lubrication products that Grizzly offers.

**T26685—ISO 32 Moly-D Machine Oil, 1 Gal.**  
**T26419—Syn-O-Gen Synthetic Grease**



**Figure 33.** Lubrication products.

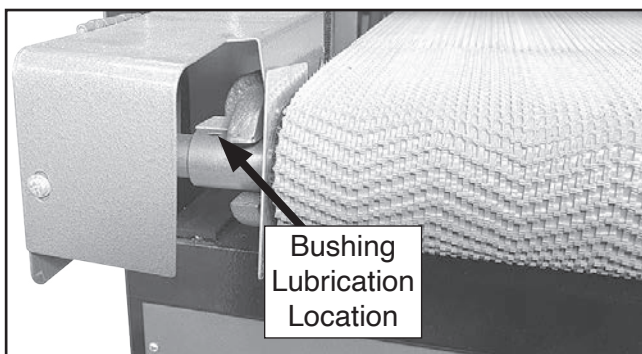
**IMPORTANT:** Avoid using excess lubrication. Too much lubricant attracts sawdust and will clog the components.

## Conveyor Roller Bushings

Lubricant Type.....T26685 or ISO 32 Equivalent  
 Lubricant Amount ..... As Needed  
 Check/Add Frequency ..... Daily

Items Needed	Qty
Oil Can .....	1
Shop Rags.....	As Needed

To lubricate the conveyor roller bushings, place a couple drops of lubricant into hole in each bushing (see **Figure 34**).



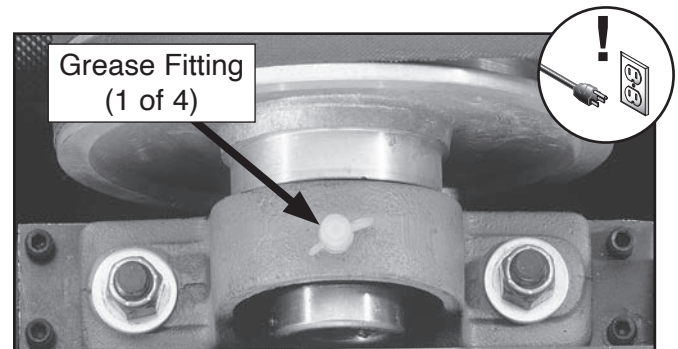
**Figure 34.** Bushing lubrication locations.

## Pillow Bearings

Lube Type..... T26419 or NLGI#2 Equivalent  
 Lube Amount ..... 1–2 Pumps  
 Lube Frequency .....20 Hours

Items Needed	Qty
Grease Gun.....	1
Shop Rags.....	As Needed

To lubricate the pillow bearings, remove the grease fitting cap (see **Figure 35**), use a grease gun to pump a small amount of grease into the fittings, then attach the cap.



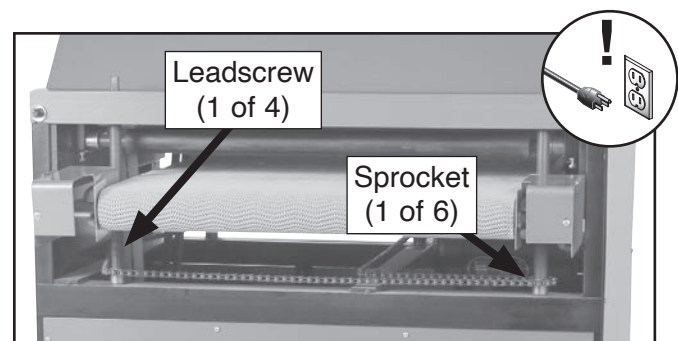
**Figure 35.** Location of grease fittings.

## Table Leadscrews and Sprockets

Lubricant Type..... T26419 or NLGI#2 Equivalent  
 Lubricant Amount ..... As Needed  
 Check/Add Frequency ..... 6 Months

Items Needed	Qty
Soft Wire Brush .....	1
Grease Gun .....	1
Shop Rags.....	As Needed

To lubricate the table leadscrews and sprockets, clean the leadscrews, chain, and sprockets with a soft wire brush (see **Figure 36**), then apply grease onto the sprockets and leadscrew threads. Adjust the conveyor up or down to spread the grease thoroughly throughout the mechanisms.



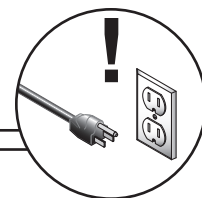
**Figure 36.** Location of leadscrews and sprockets.



# SECTION 7: SERVICE

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

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>Emergency Stop button depressed/at fault (G1066Z).</li> <li>Incorrect power supply voltage or circuit size.</li> <li>Power supply circuit breaker tripped/fuse blown.</li> <li>Machine circuit breaker tripped (G1079R).</li> <li>Wiring open/has high resistance.</li> <li>ON/OFF switch at fault</li> <li>Start capacitor at fault.</li> <li>Thermal overload relay has tripped.</li> <li>Contactor not energized/has poor contacts.</li> <li>Centrifugal switch at fault.</li> <li>Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Rotate Emergency Stop button to reset. Replace if at fault (G1066Z).</li> <li>Ensure correct power supply voltage and circuit size.</li> <li>Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.</li> <li>Reset circuit breaker on machine (G1079R).</li> <li>Check/fix broken, disconnected, or corroded wires.</li> <li>Test/replace.</li> <li>Test/replace.</li> <li>Allow to cool, then reset; replace.</li> <li>Test all legs for power/replace if at fault.</li> <li>Adjust centrifugal switch/contact points; replace if necessary.</li> <li>Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>Workpiece material not suitable.</li> <li>Feed rate too fast (G1066Z).</li> <li>Excessive depth of cut.</li> <li>Sandpaper roll loaded up.</li> <li>Sandpaper roll worn or damaged.</li> <li>Machine undersized for task.</li> <li>Belt(s) slipping or pulleys misaligned.</li> <li>Motor overheated.</li> <li>Motor bearings at fault.</li> <li>Run capacitor at fault.</li> <li>Centrifugal switch at fault.</li> <li>Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Ensure workpiece is suitable for sanding (<b>Page 29</b>).</li> <li>Reduce feed rate (G1066Z) (<b>Page 30</b>).</li> <li>Reduce depth of cut (<b>Page 30</b>).</li> <li>Clean sandpaper roll (<b>Page 35</b>).</li> <li>Replace sandpaper roll (<b>Page 33</b>).</li> <li>Reduce feed rate/workpiece pressure.</li> <li>Tension/replace belt(s) (<b>Page 45</b>); ensure pulleys are aligned (<b>Page 46</b>).</li> <li>Clean motor, let cool, and reduce workload.</li> <li>Test/repair/replace.</li> <li>Test/replace.</li> <li>Test/replace.</li> <li>Test for good contacts/correct wiring.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>Sandpaper roll loose.</li> <li>Machine not stable on floor.</li> <li>Belt(s) loose or worn.</li> <li>Motor or component loose.</li> <li>Pulley(s) loose or misaligned.</li> <li>Motor fan rubbing on fan cover.</li> <li>Worn drum bearings.</li> <li>Centrifugal switch at fault.</li> <li>Motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Re-install sandpaper roll (<b>Page 33</b>).</li> <li>Relocate/shim machine; tighten mounting bolts.</li> <li>Tension/replace belt(s) (<b>Page 45</b>).</li> <li>Tighten mounting bolts; relocate/shim machine.</li> <li>Secure pulley on shaft or realign (<b>Page 46</b>).</li> <li>Fix/replace fan cover; replace loose/damaged fan.</li> <li>Test/repair/replace.</li> <li>Adjust centrifugal switch/contact points; replace if necessary.</li> <li>Test/repair/replace.</li> </ol>





## Operation

Symptom	Possible Cause	Possible Solution
Machine slows when sanding; makes squealing noise on start-up.	1. Belt(s) loose or worn.	1. Tension/replace belt(s) ( <b>Page 45</b> ).
Grinding, screeching, or rubbing noise from sanding drums.	1. Drum scraping on dust scoop. 2. Drum bearings need lubrication. 3. Drum bearings worn.	1. Adjust dust scoop so it does not contact drum ( <b>Page 45</b> ). 2. Lubricate drum bearings ( <b>Page 36</b> ). 3. Replace drum bearings ( <b>Page 47</b> ).
Machine lacks power; drums stop turning under load.	1. Too much pressure on sanding drum. 2. Belt(s) loose or worn.	1. Lower conveyor table ( <b>Page 30</b> ). 2. Tension/replace belts ( <b>Page 45</b> ).
Conveyor belt slips or does not track correctly.	1. Belt tension not properly adjusted. 2. Belt tracking not properly adjusted. 3. Conveyor belt loose or worn. 4. Workpiece too heavy.	1. Properly adjust belt tension ( <b>Page 39</b> ). 2. Properly adjust belt tracking ( <b>Page 39</b> ). 3. Properly tension ( <b>Page 39</b> )/replace conveyor belt. 4. Use lighter workpiece.
Workpiece pulls to one side during sanding operations.	1. Sanding drum(s) not perpendicular to feed direction. 2. Sanding drum(s) not parallel with conveyor.	1. Adjust sanding drum(s) perpendicular to feed direction ( <b>Page 41</b> ). 2. Adjust sanding drum(s) parallel to conveyor ( <b>Page 42</b> ).
Workpiece kicks out of sander.	1. Not enough pressure from pressure rollers. 2. Sanding drum(s) not properly aligned.	1. Lower pressure rollers ( <b>Page 43</b> ). 2. Adjust sanding drum(s) alignment ( <b>Page 41</b> ).
Excessive snipe.	1. Lack of outfeed support. 2. Too much pressure from pressure rollers. 3. Too much pressure from rear pressure roller.	1. Set up outfeed table or have someone catch workpiece as it comes out. 2. Raise pressure rollers ( <b>Page 43</b> ). 3. Raise rear pressure roller ( <b>Page 43</b> ).
Sanding grains easily rub off roll.	1. Sandpaper roll has been stored in an incorrect environment. 2. Sandpaper roll has been smashed or folded.	1. Replace damaged sandpaper roll ( <b>Page 33</b> ). Store sanding belt in a cool, dry area. 2. Replace damaged sandpaper roll ( <b>Page 33</b> ). Do not bend or fold sanding belt.
Sandpaper comes off drum or is loose.	1. Sandpaper roll not properly wrapped around drum. 2. Sandpaper roll not correct size. 3. Torn or damaged sandpaper. 4. Sandpaper not tightened or fastened correctly. 5. Sanding drum not parallel with conveyor.	1. Re-install sandpaper roll ( <b>Page 33</b> ). 2. Cut sandpaper roll to correct dimensions ( <b>Page 33</b> ). 3. Replace sandpaper roll ( <b>Page 33</b> ). 4. Re-install sandpaper roll ( <b>Page 33</b> ). 5. Adjust sanding drum parallel to conveyor ( <b>Page 40</b> ).
Sandpaper clogs quickly.	1. Sanding depth of cut too much or feed rate too slow. 2. Workpiece has high moisture content or sap. 3. Incorrect sandpaper grit. 4. Poor dust collection. 5. Sandpaper loaded with sawdust and gum. 6. Worn sandpaper.	1. Reduce depth of cut ( <b>Page 30</b> ) or increase feed rate ( <b>Page 30</b> ). 2. Use different stock, or accept characteristics of stock and plan on cleaning/replacing sandpaper frequently; remove applied finish before sanding. 3. Use correct sandpaper grit for operation ( <b>Page 32</b> ). 4. Unclog ducts; close gates to improve suction; re-design collection system. 5. Clean/replace sandpaper ( <b>Page 35</b> ). 6. Replace sandpaper ( <b>Page 33</b> ).





# Tracking & Tensioning Conveyor Belt

## CAUTION

Working around moving conveyor and parts presents pinch/entanglement hazards that can cause personal injury. Use extreme care to keep hands clear of in-running pinch points while adjusting tracking bolts when machine is running. Roll up sleeves and do not wear gloves or other apparel that could become entangled in moving parts.

The conveyor belt must track straight. If the belt tracks to either side, then the tracking must be corrected or the conveyor belt will become damaged and have to be replaced. The tracking was properly set at the factory, but eventually, wear may cause it to track unevenly.

Tracking the conveyor belt is a balancing process that takes patience and some trial and error. Usually, you must over-tighten the loose side to make the belt move to center of the rollers, then loosen that same side to make the conveyor belt stay in position. If the tracking bolt is over-adjusted, the process will need to be repeated until the conveyor belt stays centered on the rollers.

The conveyor belt will stretch when new and will eventually need to be tensioned. This is most obvious if the conveyor belt starts slipping on the rollers.

When adjusting conveyor belt tension, focus on adjusting the tension bolts in even increments. Adjusting one side more than the other will cause tracking problems, which will require additional adjustments to get the conveyor belt tracking correctly again.

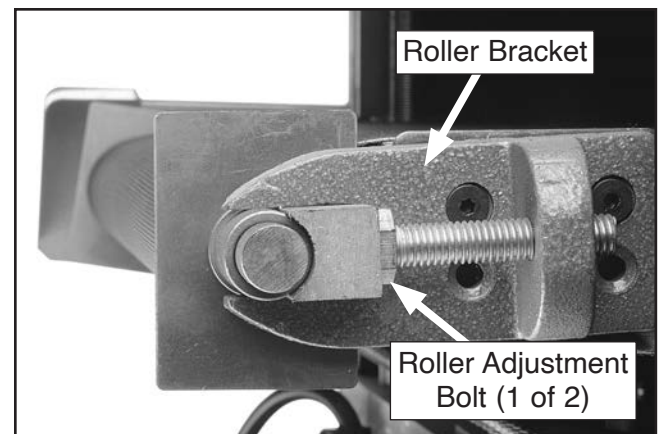
**Note:** *Whenever possible, make tracking adjustments to infeed end of conveyor to avoid needing to make adjustments to table elevation chain.*

### Items Needed

	Qty
Phillips Head Screwdriver #2 .....	1
Open-End Wrench 19mm.....	1

## Tracking Conveyor Belt

1. Turn machine **ON** and watch conveyor belt track.
  - If conveyor belt quickly moves to one side, immediately stop machine and adjust belt tracking before running conveyor again. Proceed to **Step 2**.
  - If conveyor belt tracks evenly, no adjustment is required.
2. Open conveyor roller bracket guards.
3. Make conveyor belt tension and tracking adjustments:
  - If belt tracks toward right, rotate right-side roller adjustment bolt (see **Figure 37**) counterclockwise to move belt left.
  - If belt tracks toward left, rotate right-side roller adjustment bolt (see **Figure 37**) clockwise to move belt right.



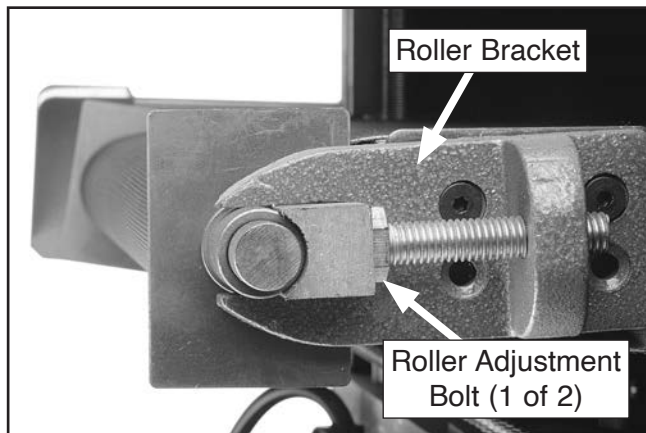
**Figure 37.** Location of conveyor roller adjustment bolts.

4. After adjustments are made, run machine for approximately 15 minutes to watch the tension or tracking adjustments you made. Be patient, belt tracks slowly.
5. Proceed to **Tensioning Conveyor Belt** on next page.



## Tensioning Conveyor Belt

1. Turn machine **ON** and confirm conveyor belt tracking does not need to be adjusted. Refer to **Tracking Conveyor Belt** on previous page.
2. Open conveyor roller bracket guards.
  - If belt slips during operation, rotate both adjustment bolts equally (see **Figure 38**) clockwise to increase belt tension.



**Figure 38.** Location of conveyor roller adjustment bolts.

**Note:** When tensioned properly, conveyor belt should not lift off table, slide back and forth, or slip.

### NOTICE

**DO NOT** over-tension conveyor belt. Doing so may cause premature wearing of conveyor belt and roller bushings, and cause strain on conveyor motor.

3. Close conveyor roller bracket guards.

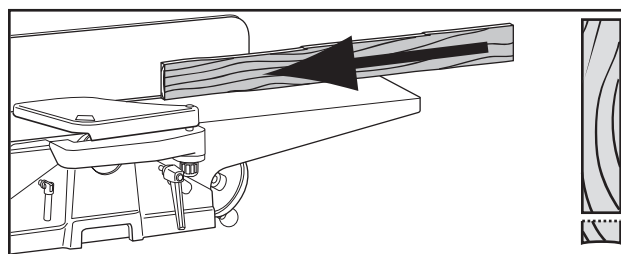
## Making Blocks

The blocks described below will be required to complete the alignment procedures in the following sub-sections.

Items Needed	Qty
2x4 (6' Length).....	1
Miter Saw (or Circular Saw).....	1
Jointer.....	1
Table Saw.....	1

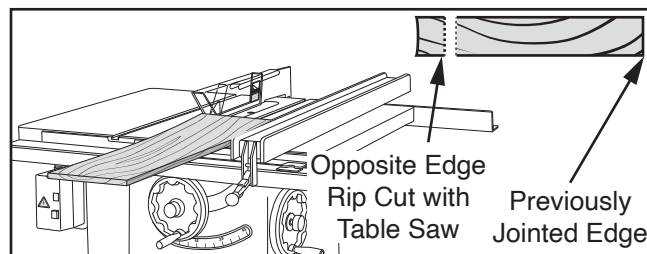
### To make blocks:

1. Edge joint concave edge of 2x4 flat on jointer, as shown in **Figure 39**.



**Figure 39.** Edge jointing on jointer.

2. Place jointed edge of 2x4 against table saw fence and rip cut just enough off opposite side to square up two edges of 2x4, as shown in **Figure 40**.



**Figure 40.** Rip cutting on table saw.

3. Cut 2x4 into two even pieces to make two 36" long wood gauge blocks.

**Note:** **Steps 1–2** can be skipped, but having gauge blocks of equal height is critical to accuracy of adjustments.

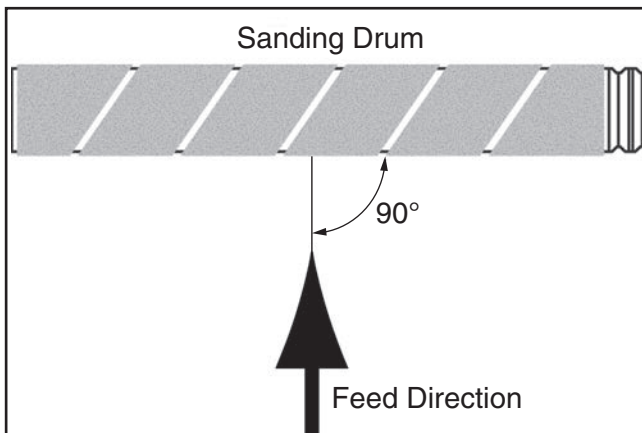


# Aligning Drums

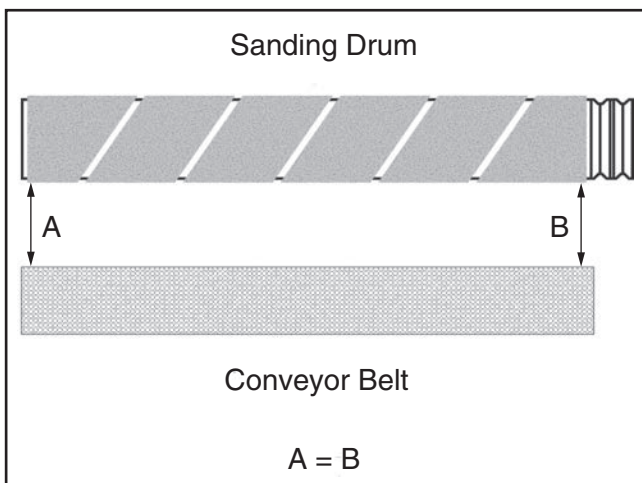
## ⚠ CAUTION

Improper drum alignment could cause an uncontrolled exit of material from the machine—which could result in damage to property, premature wear and failure of sandpaper, or personal injury.

For the Model G1066R/G1066Z/G1079R Drum Sander to function properly, the sanding drums must be aligned in two directions: (1) perpendicular to feed direction (see **Figure 41**) and (2) parallel to the conveyor belt (see **Figure 42**).



**Figure 41.** Feed direction perpendicular to sanding drum (viewed from top of machine).



**Figure 42.** Sanding drum parallel to conveyor belt (viewed from front of machine).

## Adjusting Sanding Drums Perpendicular to Feed Direction

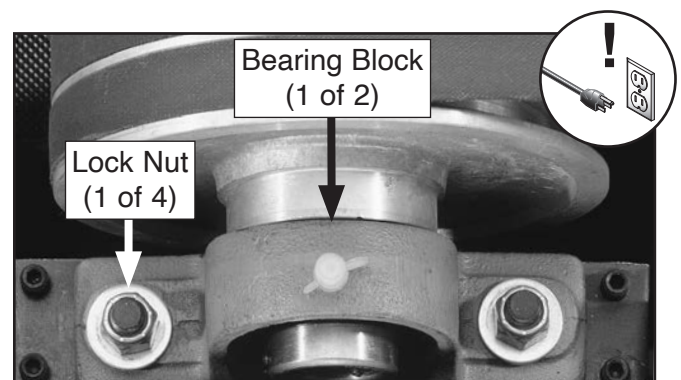
Items Needed	Qty
Tape Measure.....	1
Open-End or Socket Wrench $\frac{9}{16}$ " .....	1

To adjust sanding drum perpendicular to feed direction:

1. DISCONNECT MACHINE FROM POWER!
2. Measure distances between outside of front sanding drum and inside of front brace on both ends of drum.
  - If distances *are* within  $\frac{1}{8}$ " of one another, no adjustment is necessary.
  - If distances *are not* within  $\frac{1}{8}$ " of one another, front sanding drum needs to be aligned. Proceed to **Step 3**.
3. Repeat **Step 2** on rear sanding drum.
  - If distances *are* within  $\frac{1}{8}$ " of one another, no adjustment is necessary.
  - If distances *are not* within  $\frac{1}{8}$ " of one another, rear sanding drum needs to be aligned. Proceed to **Step 4**.

**Note:** If sanding drums are not perpendicular to feed direction, sandpaper will creep toward one end of drum during operation.

4. Loosen lock nuts on bearing blocks (see **Figure 43**) and adjust sanding drum forward or backward as necessary until distances between outside of drum and inside of front brace on both ends of drum are within  $\frac{1}{8}$ " of one another.



**Figure 43.** Location of bearing blocks.



5. Tighten lock nuts and check alignment.

**Note:** *DO NOT over tighten lock nuts. Bearing blocks will break if over tightened.*

## Adjusting Sanding Drums Parallel to Conveyor Belt

Items Needed	Qty
2x4 Gauge Block (2" x 4" x 36").....	1
Marking Tape or Felt Pen.....	1
Open-End or Socket Wrench $\frac{9}{16}$ " .....	1

### To adjust sanding drum parallel to conveyor belt:

1. DISCONNECT MACHINE FROM POWER!
2. Remove sandpaper.
3. Starting with front sanding drum, lower conveyor so gauge block slides easily under pressure bars. Slide block to right side with end of gauge lined up with front of conveyor.

**Note:** *Make note of gauge block position to make sure same part of the gauge block is used to set drum heights.*

4. Raise conveyor until gauge block just touches front pressure roller, then raise conveyor one full turn of crank handle.
5. Adjust height of right side of sanding drum so it just touches gauge block (refer to **Adjusting Sanding Drum Height** on this page) and is able to rotate back and forth with moderate resistance.
6. Mark location of crank handle with felt pen or piece of tape. In same manner, mark height of conveyor in relation to body of sander. Both marks indicate exact conveyor position (referred to as *Reference Height #1*).

**Note:** *Having Reference Height #1 marked is crucial to all subsequent steps.*

7. Lower conveyor two full turns. Remove gauge block and insert it on left side. Line it up with front of conveyor, as was done in **Step 3**.

8. Raise conveyor two full turns to bring it back to *Reference Height #1*.
9. Repeat **Step 5** to adjust left side of sanding drum.
10. Rotate front sanding drum back and forth. It should feel as it did in **Step 5**. If not, adjust drum height again. Continue this process, going back and forth, until both sides of drum feel the same.
11. Lower conveyor ( $\frac{1}{8}$ ) turn from *Reference Height #1* and mark location of crank handle and conveyor in relation to the body of sander. Both these marks indicate exact conveyor position (referred to as *Reference Height #2*).

**Note:** *Model G1066Z has micro-adjustment controls on sides of machine for rear sanding drum adjustments. Other than this difference, the procedure for setting rear drum height is the same.*

12. Lower conveyor two full turns.
13. Using *Reference Height #2*, repeat **Steps 5–10** on rear sanding drum until both sides of drum feel the same.

**Note:** *Rear drum should always be slightly lower than front drum. Actual difference will vary depending on wood type, feed rate, sandpaper grits, etc. Once familiar with adjustment process, experiment to determine best settings for your specific application.*

## Adjusting Sanding Drum Height

Items Needed	Qty
2x4 Gauge Block (2" x 4" x 36").....	1
Open-End or Socket Wrench $\frac{9}{16}$ " .....	1
Hex Wrench 3mm.....	1

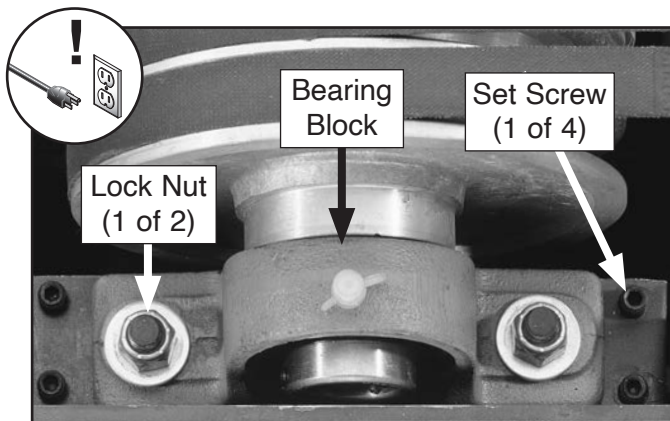
### To adjust sanding drum height:

1. DISCONNECT MACHINE FROM POWER!





2. Loosen lock nuts (see **Figure 44**) on bearing block on side of drum requiring adjustment.



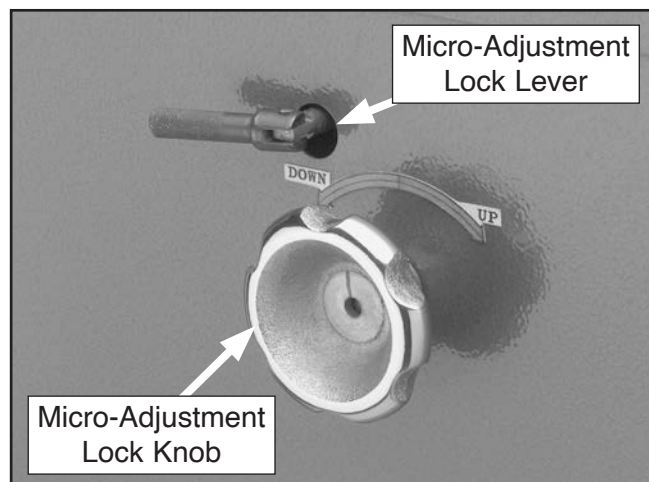
**Figure 44.** Bearing block components.

3. Raise or lower bearing block by rotating set screws (see **Figure 44** on **Page 43**). Turn very gradually— $\frac{1}{8}$  turn or less.
4. Tighten lock nuts and re-check alignment using gauge block.

**Note:** Tightening lock nuts pulls sanding drum slightly downward. Re-adjust set screws as necessary to compensate for this movement. **DO NOT** over tighten lock nuts. Bearing blocks will break if over tightened. Also, **DO NOT** change conveyor height until the lock nuts are tight.

5. Repeat **Steps 2–4** on opposite side of drum.

**Note:** Model G1066Z has micro-adjustment controls on sides of machine for rear sanding drum adjustments (see **Figure 45**).



**Figure 45.** Model G1066Z rear drum micro-adjustment controls.

## Adjusting Pressure Rollers

Proper pressure on the workpiece helps avoid kickback and keeps the workpiece from slipping. However, as pressure increases on the workpiece, snipe also increases (snipe is normal with all brands of drum sanders).

If snipe becomes a problem, you can minimize it by reducing pressure. However, you can only minimize it so much before the workpiece will slip or kick out, causing a hazard to the operator. If this happens, either the pressure rollers tension is too little, or the pressure roller height is too high for them to function as intended—the pressure rollers must be properly adjusted to prevent injury.

**IMPORTANT:** Before making adjustments to pressure rollers, ensure sanding drums are properly aligned. Refer to **Aligning Drums** on **Page 41**.

**Note:** These adjustments should be used as a starting point. Once you are familiar with the adjustment process, you should experiment to determine the best settings for your specific application.

### Adjusting Pressure Roller Height

Items Needed	Qty
Open-End Wrenches 10mm.....	2
2x4 Gauge Blocks (2" x 4" x 36").....	2

#### To adjust pressure roller height:

1. DISCONNECT MACHINE FROM POWER!
2. Open top cover, then lower conveyor enough to insert gauge blocks.
3. Position one gauge block in middle of conveyor and under front sanding drum only.
4. Raise conveyor until gauge block just touches front sanding drum.
5. Lower conveyor one full turn.

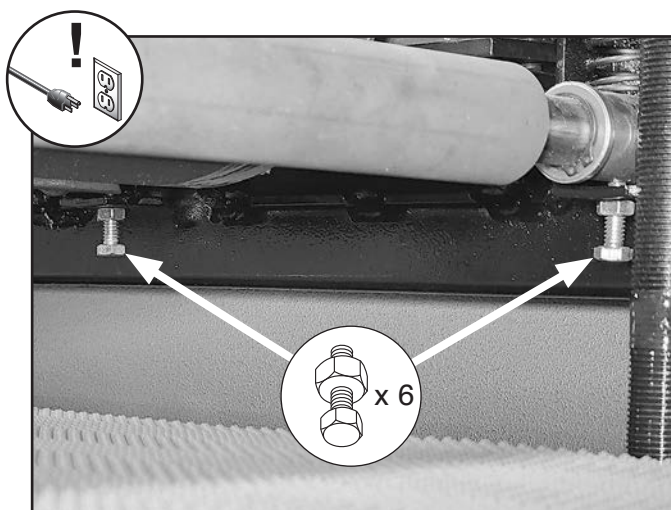




6. Position gauge blocks on both sides of conveyor and under all three pressure rollers. Check both ends of each pressure roller. Pressure rollers should be just touching gauge blocks.

- If pressure rollers are just touching gauge block, no height adjustment is necessary.
- If pressure rollers are not touching or are set too low, pressure rollers need to be adjusted. Proceed to **Step 7**.

7. Loosen jam nut, then rotate adjustment bolt (see **Figure 46**) clockwise to raise pressure roller or counterclockwise to lower.



**Figure 46.** Location of pressure roller height adjustment bolts.

8. Repeat **Steps 6–7** until pressure roller height is properly adjusted.

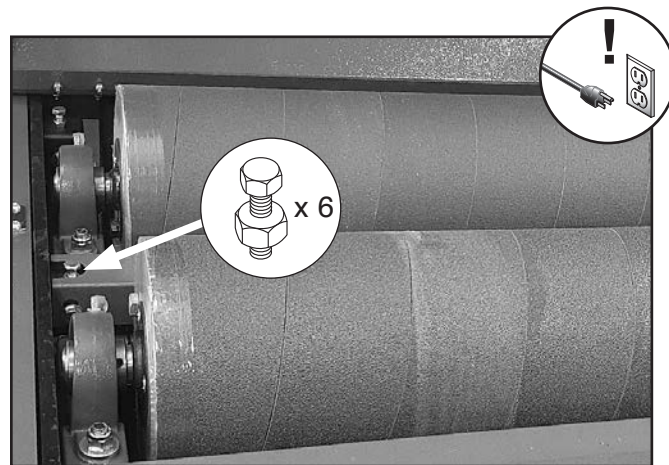
## Adjusting Pressure Roller Tension

Items Needed	Qty
Open-End Wrenches 10mm.....	2
2x4 Gauge Blocks (2" x 4" x 36").....	2

**Note:** It may be necessary to remove dust scoop to access adjustment bolt. Refer to **Adjusting Dust Scoop** on **Page 45**.

## To adjust pressure roller height:

1. DISCONNECT MACHINE FROM POWER!
2. Ensure pressure roller height is properly adjusted, refer to **Adjusting Pressure Roller Height** on **Page 43**.
3. Open top cover.
4. Loosen tension adjustment jam nut (see **Figure 47**) on both ends of pressure roller.



**Figure 47.** Location of pressure roller tension adjustment bolts.

5. Rotate adjustment bolt counterclockwise until there is no longer pressure on tension spring.
6. Rotate adjustment bolt clockwise until it touches spring, then rotate one more full turn.
7. Repeat **Steps 5–6** on opposite end of pressure roller.
8. While preventing adjustment bolts from moving, tighten jam nuts.
9. Repeat **Steps 4–8** to make adjustments to remaining pressure rollers.
10. If dust scoop was removed, refer to **Adjusting Dust Scoop** on **Page 45**.



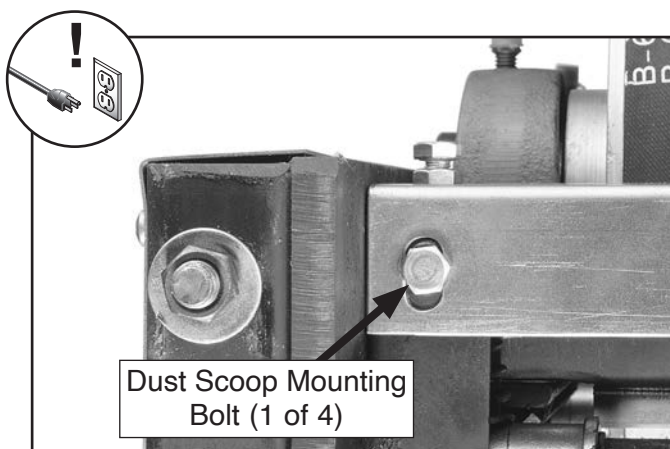
# Adjusting Dust Scoop

The Model G1066R/G1066Z/G1079R features a dust scoop for each drum. Dust scoops reduce the amount of dust that accumulates on the workpiece as it travels through the sander. Dust scoops are adjustable and should be set approximately  $\frac{1}{32}$ " above the bottom of the drum for optimum effectiveness.

Items Needed	Qty
Open-End or Socket Wrench 10mm .....	1
2x4 Gauge Block (2" x 4" x 36").....	2

## To adjust dust scoop:

1. DISCONNECT MACHINE FROM POWER!
2. Ensure sanding drums are properly aligned (see **Aligning Drums** on **Page 41**).
3. Place gauge blocks under rear sanding drum and dust scoop. Raise conveyor until gauge blocks just touch sanding drum.
4. Loosen dust scoop mounting bolts located at each end of scoop (see **Figure 48**).



**Figure 48.** Location of dust scoop mounting bolts.

5. Adjust scoop up or down until it is approximately  $\frac{1}{32}$ " above gauge blocks. Some flexing of sheet metal assembly may be needed to get proper clearance.
6. Tighten mounting bolts and remove gauge blocks.

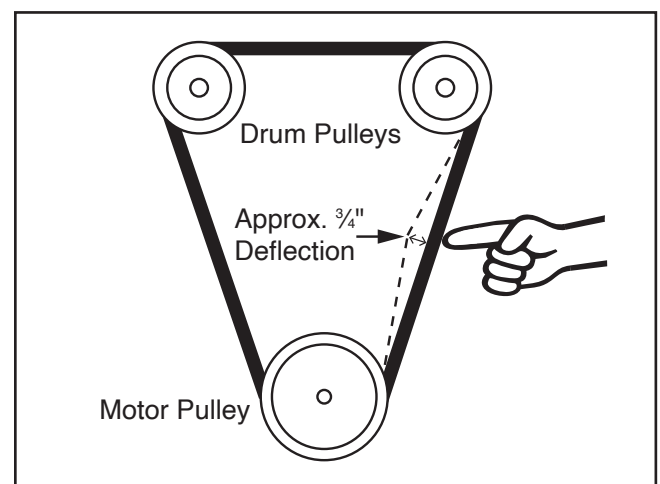
# Tensioning/Replacing V-Belts

Items Needed	Qty
Open-End or Socket Wrench 17mm.....	1
Straightedge (at least 24") .....	1
Tape Measure.....	1
Phillips Head Screwdriver #2 .....	1
Hex Wrench 5mm.....	1

## V-Belt Tension

New V-belts often stretch and loosen up during the first 16 hours of use. After this period, they should be inspected and re-tensioned if necessary. Replace V-belts if you notice fraying, cracking, glazing, or any other damage. A worn/damaged belt will not provide optimum power transfer from the motor to the drums.

The sanding drums are driven by two V-belts on the Model G1066R and G1066Z, and one V-belt on the Model G1079R. The belts must have proper tension for optimum power transfer. However, too much tension may cause premature bearing failure. Proper tension is achieved when the belts deflect about  $\frac{3}{4}$ " with moderate finger pressure at the midpoint between the drum pulley and the motor pulleys (see **Figure 49**).



**Figure 49.** Proper V-belt deflection.



## ⚠ CAUTION

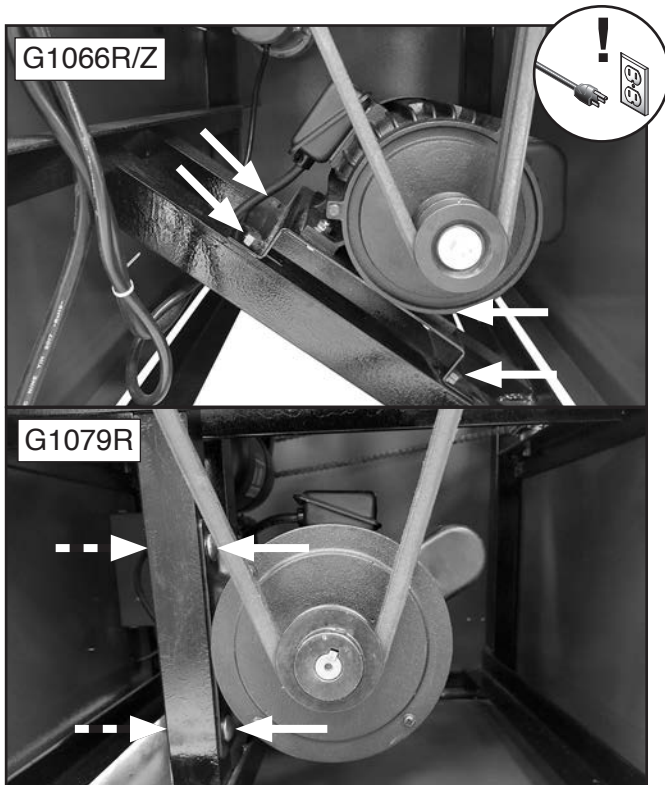
Always inspect V-belts for damage or deterioration when adjusting tension. Should you find evidence of fraying, cracking, or other damage, replace the belt immediately. Belt breakage could lead to mechanical damage or operator injury.

## ⚠ CAUTION

Belts and pulleys will be hot after operation. Allow them to cool before handling.

### To adjust V-belt tension:

1. DISCONNECT MACHINE FROM POWER!
2. Remove right access panel.
3. Loosen motor mount fasteners shown in **Figure 50**. DO NOT remove motor mount fasteners.



**Figure 50.** Locations of motor mount fasteners.

4. While pressing down on motor to keep tension on belt, tighten motor mount fasteners.

5. Check V-Belt tension. If necessary, repeat **Steps 3–4** until belt(s) is properly tensioned.
6. Install right access panel.

### V-Belt Removal/Replacement

Replace the V-belt if you notice fraying, cracking, glazing, or any other damage. A worn/damaged V-belt will not provide optimum power transmission from the motor to the drums.

V-belt removal and replacement is simply a matter of loosening the V-belts until you can roll them off the pulleys, replacing them with a **MATCHED** set, then re-tensioning them.

**Note:** A matched set means both the V-belts are the same size and also have the same serial number.

### Pulley Alignment

Pulley alignment is another important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplanar) for optimum performance.

Each pulley can be adjusted by loosening the set screw that secures the pulley to the shaft, sliding the pulley in/out, and retightening the set screw to lock the pulley in place.

### To align pulleys:

1. DISCONNECT MACHINE FROM POWER!
2. Remove right access panel, loosen motor mount fasteners, and remove V-belts.
3. Place straightedge across face of motor pulley and front drum pulley to check alignment. The straightedge should sit evenly on top and bottom part of both pulleys.
4. Repeat **Step 3** with straightedge placed against motor pulley and rear drum pulley.
5. Loosen pulleys and adjust them as necessary until they are all coplanar with each other, and then tighten set screws.
6. Reinstall and properly tension V-belts, tighten motor mount fasteners, and reinstall right access panel.



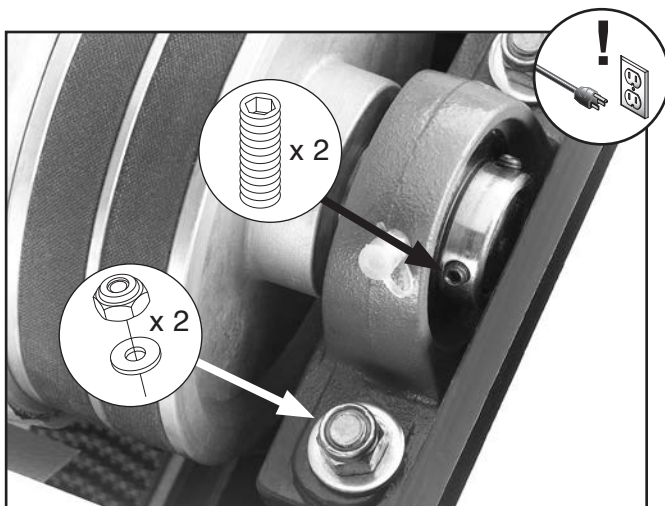
# Replacing Bearings

The Model G1066R/G1066Z/G1079R is designed for many years of reliable service. But after long periods of heavy use, it may be necessary to replace the pillow block bearings. Always replace both bearings on the same drum at the same time.

Items Needed	Qty
Wrench or Socket $\frac{9}{16}$ " .....	1
Hex Wrench 3mm.....	1
Bearing Blocks .....	2 Per Drum
—P1066R081	
—P1066Z081	
—P1079R081	
Grease Gun .....	1
T26419 or NLGI#2 Equivalent .....	As Needed
Shop Rags.....	As Needed

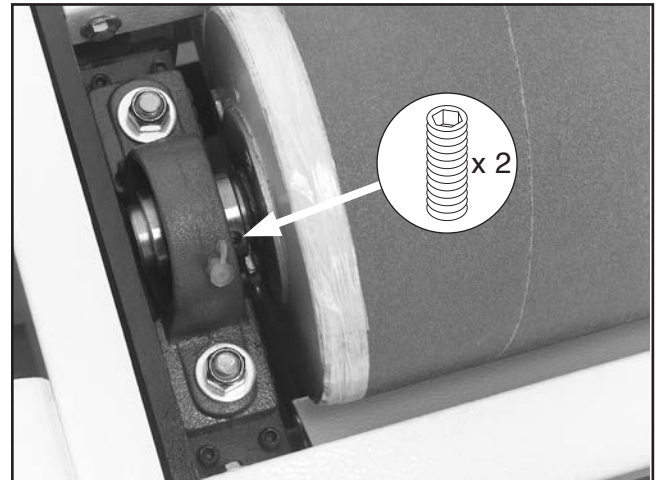
## To replace bearings:

1. DISCONNECT MACHINE FROM POWER!
2. Remove V-belts (see **V-Belt Removal/Replacement** on **Page 46**).
3. Remove lock nuts and flat washers from bearing block assembly on each side of drum, shown in **Figure 51**.



**Figure 51.** Location of bearing fasteners.

4. Carefully lift drum up and out of machine and place on flat, stable surface.
5. Loosen (2) bearing set screws (see **Figures 51–52**) on each side of drum, then remove bearing assemblies from drum shaft.



**Figure 52.** Location of bearing set screws.

6. Clean and inspect drum shaft for damage or unusual wear.
7. Slide new bearing assemblies into place on the drum shaft. Do not tighten set screws at this time.
8. Install drum into machine, then secure with lock nuts and flat washers removed in **Step 3**.
9. Follow instructions for **Pulley Alignment** on **Page 46** before tightening bearing set screws.
10. Follow instructions for **Aligning Drums** on **Page 41**.
11. Follow instructions for **Tensioning/Replacing V-Belts** on **Page 45**.
12. Install side cover.

## NOTICE

Lubricate the bearings sparingly every two months of sander operation. The bearing requires very little grease, so avoid the temptation to over-lubricate.





# 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.











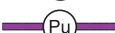




**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

**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](http://www.grizzly.com).

### COLOR KEY

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

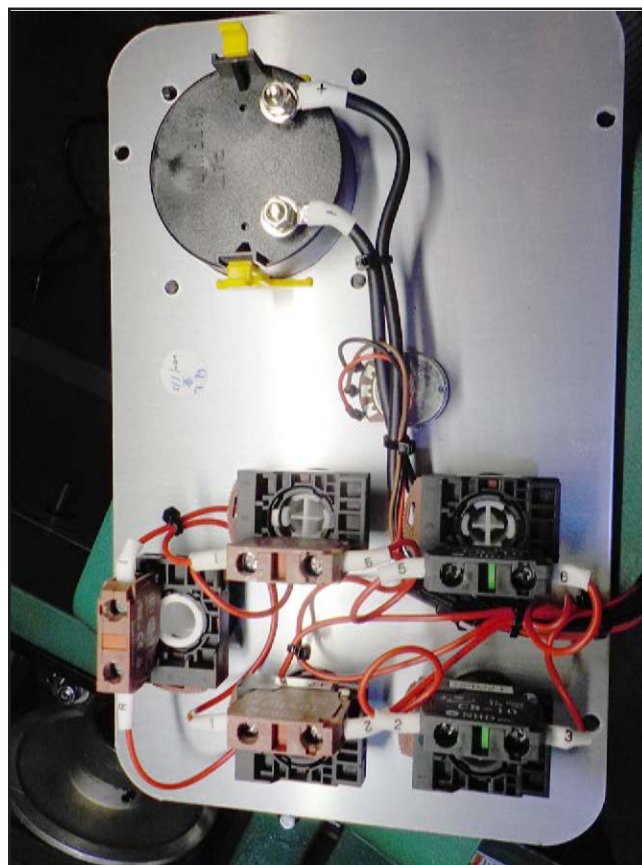




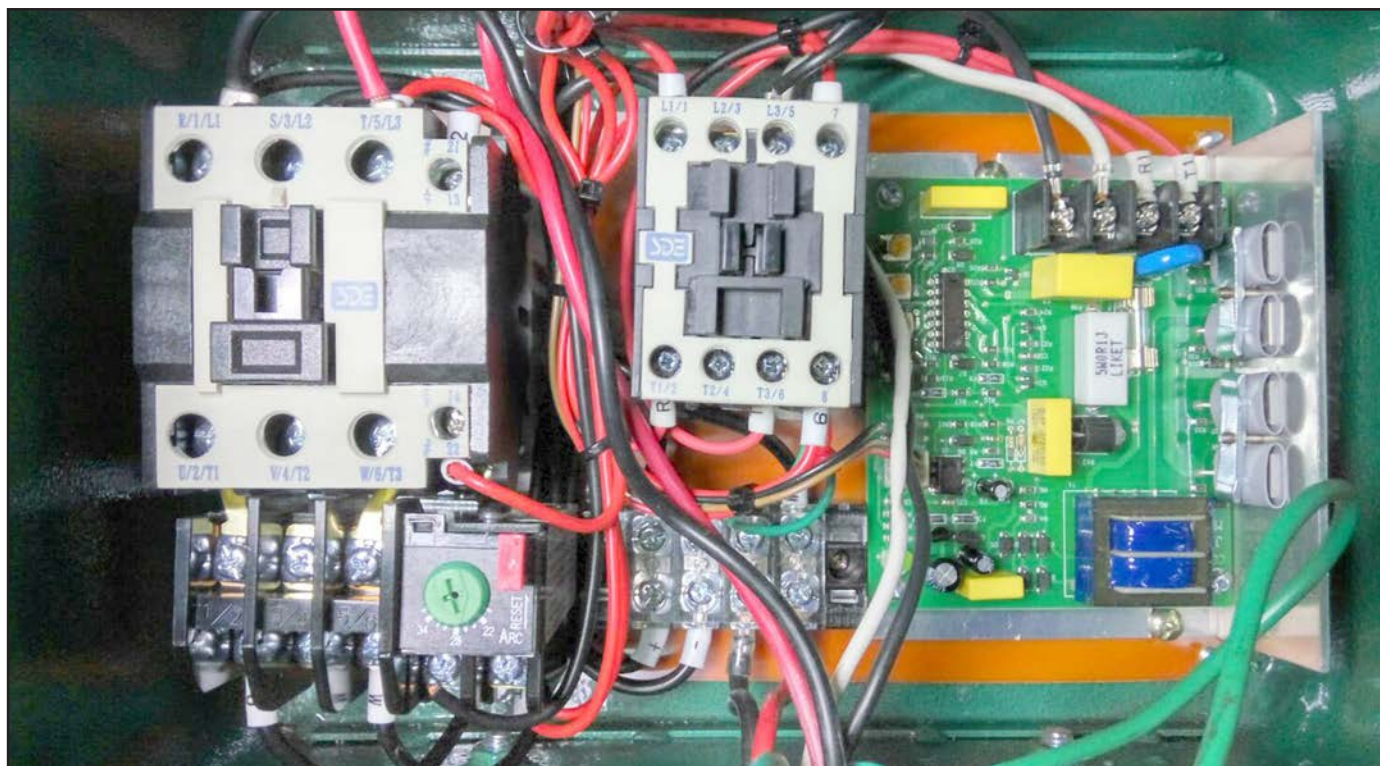
# G1066Z Electrical Components



**Figure 57.** G1066Z drum motor connections and capacitors.

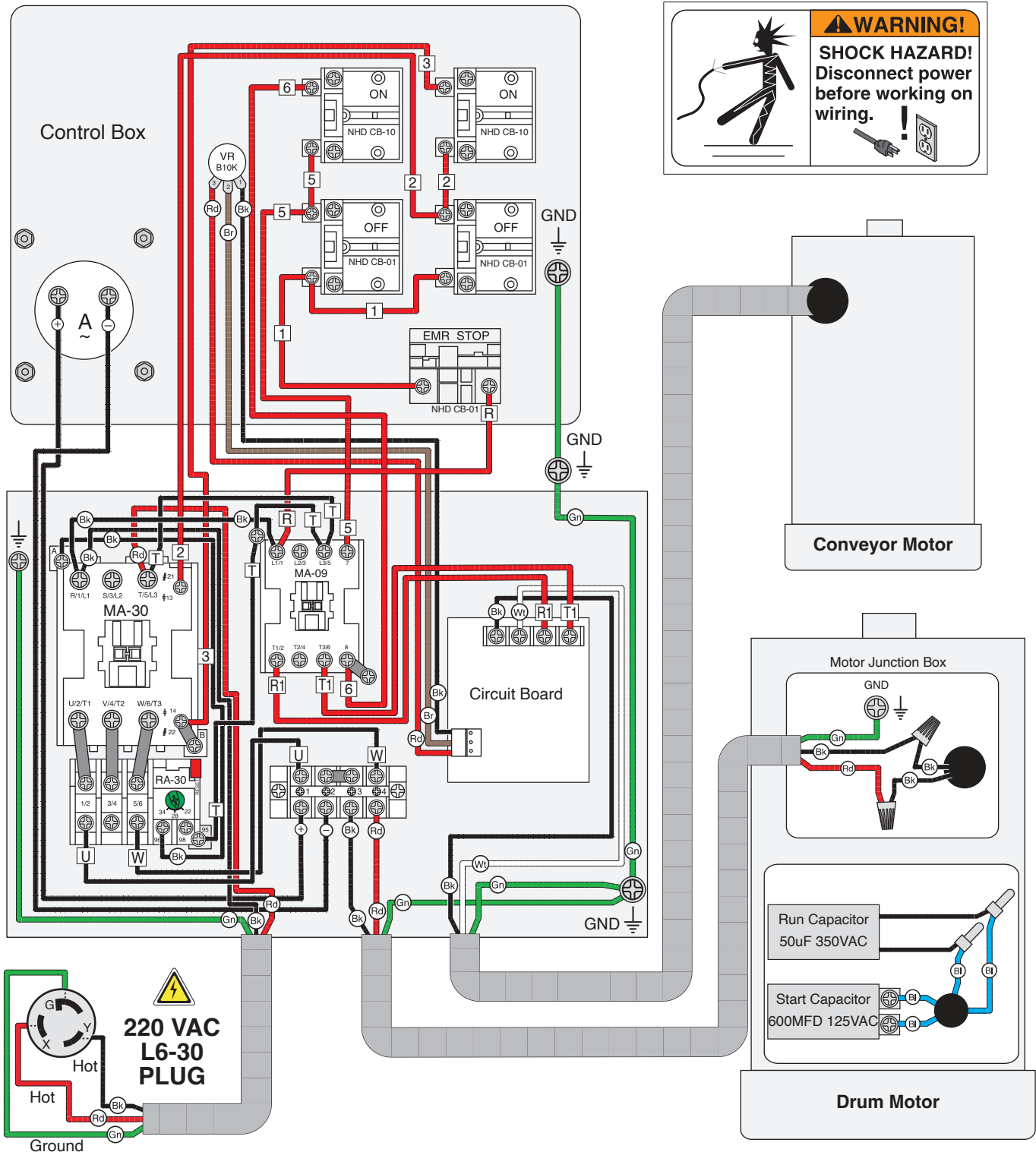


**Figure 58.** G1066Z controls connections (rotated 90°).



**Figure 59.** G1066Z control panel connections.

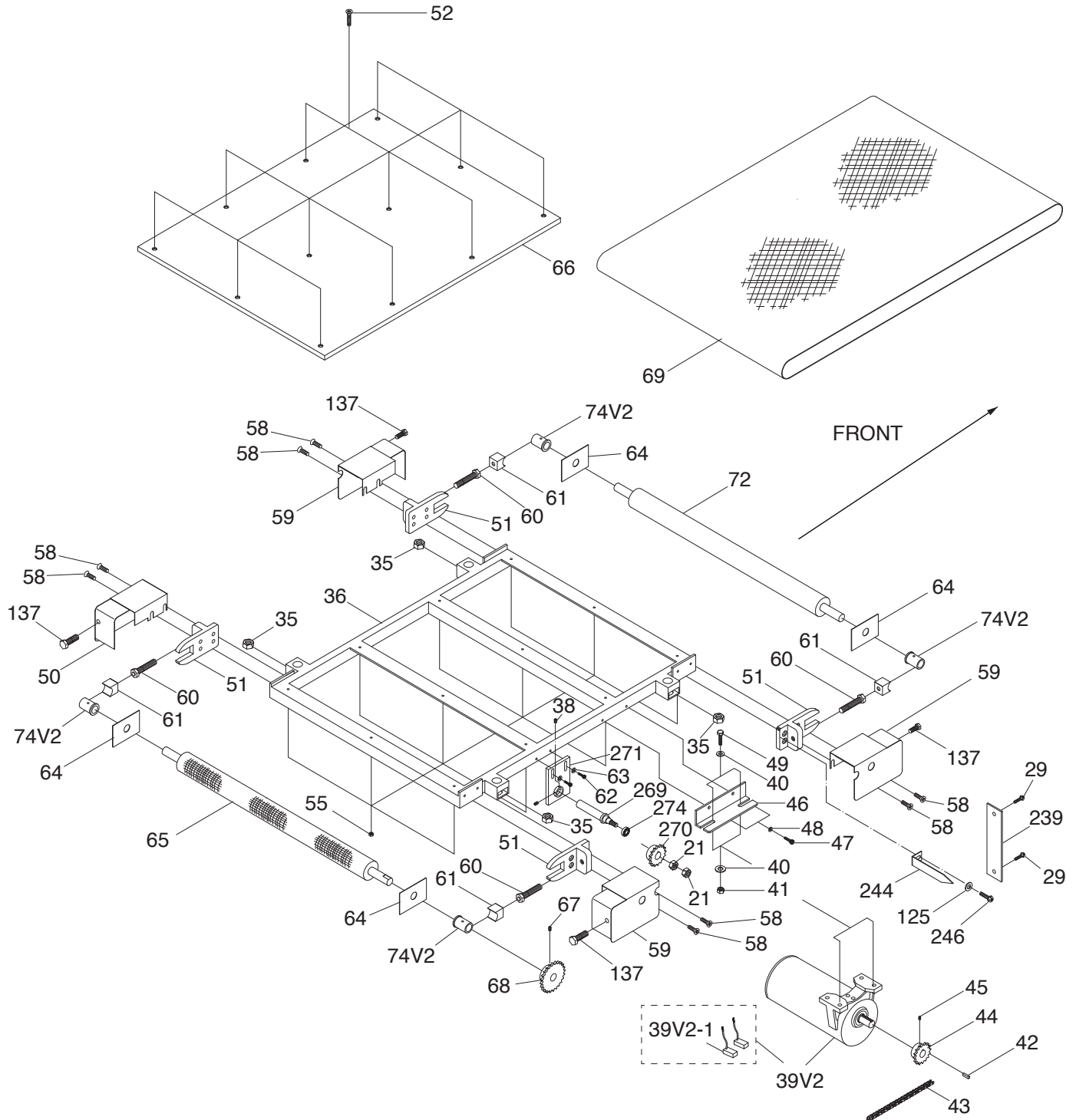
# G1066Z Wiring Diagram



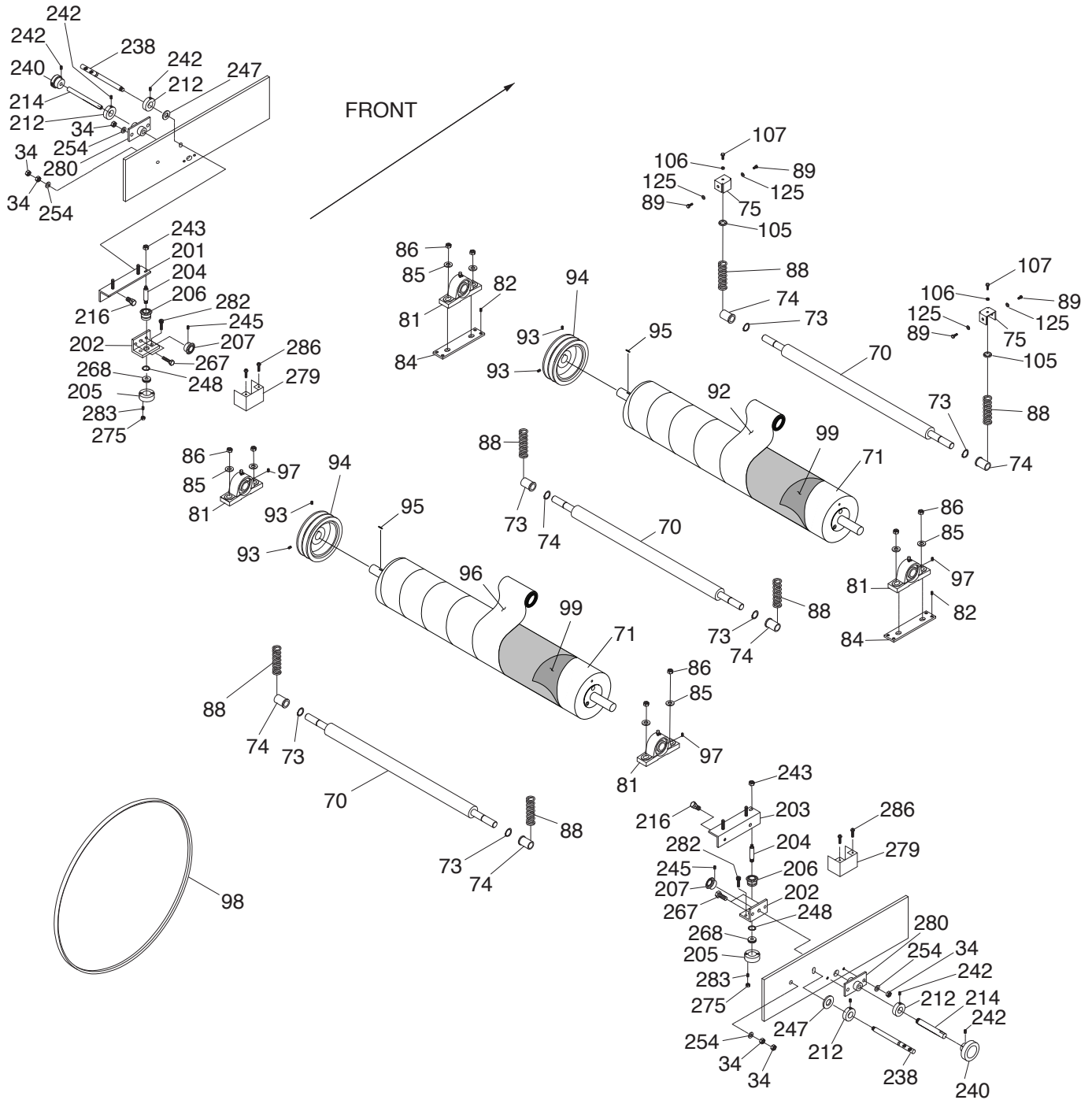
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# G1066Z Conveyor Belt & Table



# G1066Z Drums & Rollers





# G1066Z Parts List

REF	PART #	DESCRIPTION
1	P1066Z001	FRAME
2	P1066Z002	HEX NUT 3/8-16
3	P1066Z003	FLAT WASHER 3/8
4	P1066Z004	SIDE PANEL
5	P1066Z005	FLAT WASHER 1/2
6	P1066Z006	SPROCKET
7	P1066Z007	SPROCKET
7-1	P1066Z007-1	SHAFT
8	P1066Z008	TABLE SCREW FINE THREADS 3/4-16
8-1	P1066Z008-1	TABLE SCREW SHIM 1/2 X 27 X 1
9	P1066Z009	CHAIN
10	P1066Z010	FRONT BRACE
11	P1066Z011	SET SCREW 5/16-24 X 3/8
12	P1066Z012	COMPLETE CRANK HANDLE ASSY
13	P1066Z013	DUST PORT TOP
14	P1066Z014	HOOD
15	P1066Z015	REAR BRACE
16	P1066Z016	REAR PANEL
17	P1066Z017	SET SCREW 1/4-20 X 1/2
18	P1066Z018	MOTOR PULLEY
19	P1066Z019	KEY 5 X 5 X 25
20	P1066Z020	DRUM MOTOR 5HP 220V 1-PH
20-1	P1066Z020-1	MOTOR FAN
20-2	P1066Z020-2	MOTOR FAN COVER
20-3	P1066Z020-3	S CAPACITOR 600M 125V 1-3/4 X 3-3/8
20-4	P1066Z020-4	R CAPACITOR 50M 350V 1-3/4 X 3-3/8
20-5	P1066Z020-5	CAPACITOR COVER
20-6	P1066Z020-6	JUNCTION BOX
20-7	P1066Z020-7	CENTRIFUGAL SWITCH
21	P1066Z021	HEX NUT 3/8-16
22	P1066Z022	HEX BOLT 3/8-16 X 1
23	P1066Z023	BRACKET
24	P1066Z024	FLAT WASHER 3/8
25	P1066Z025	PHLP HD SCR M4-.7 X 10
26	P1066Z026	FLAT WASHER 3/8
27	P1066Z027	HEX NUT 3/8-16
28	P1066Z028	DUST DEFLECTOR
29	P1066Z029	TAP SCREW #8 X 3/8
30	P1066Z030	GROMMET 29 X 25MM
31	P1066Z031	POWER CORD 12G 3W 86"
32	P1066Z032	FRONT PANEL
33V2	P1066Z033V2	CONTACTOR SDE MA-30 240V V2.05.16
34	P1066Z034	HEX NUT 5/16-18
35	P1066Z035	HEX NUT 3/4-16 1-1/4" DIA
36	P1066Z036	TABLE FRAME
37	P1066Z037	FLAT WASHER 5/16
38	P1066Z038	SET SCREW 3/8-16 X 1/4
39V2	P1066Z039V2	CONVEYOR MOTOR 1/3HP 1-PH V2.03.24
40	P1066Z040	FLAT WASHER 5/16
41	P1066Z041	HEX NUT 5/16-18
42	P1066Z042	KEY 5 X 5 X 20
43	P1066Z043	CHAIN
44	P1066Z044	SPROCKET
46	P1066Z046	MOTOR BRACKET
47	P1066Z047	CAP SCREW 1/4-20 X 3/4
48	P1066Z048	FLAT WASHER 1/4

REF	PART #	DESCRIPTION
49	P1066Z049	HEX BOLT 5/16-18 X 1-1/4
50	P1066Z050	GUARD HINGED LEFT
51	P1066Z051	ROLLER BRACKET
52	P1066Z052	FLAT HD SCR 1/4-20 X 1
53	P1066Z053	POWER CORD 12G 3W 36"
54	P1066Z054	POWER CORD 12G 3W 36"
55	P1066Z055	LOCK NUT 1/4-20
56	P1066Z056	LOCK NUT M4-.7
58	P1066Z058	CAP SCREW 1/4-20 X 3/4
59	P1066Z059	GUARD RIGHT
60	P1066Z060	ROLLER BRACKET BOLT 1/2-13 X 70
61	P1066Z061	BUSHING SUPPORT
62	P1066Z062	HEX BOLT 1/4-20 X 1/4
63	P1066Z063	FLAT WASHER 1/4
64	P1066Z064	PLATE
65	P1066Z065	DRIVE ROLLER KNURLED 24 IN
66	P1066Z066	TABLE 12 HOLE
67	P1066Z067	SET SCREW 5/16-18 X 1/2
68	P1066Z068	SPROCKET
69	P1066Z069	RUBBER CONVEYOR BELT
70	P1066Z070	PRESSURE ROLLER
71	P1066Z071	SANDING DRUM
72	P1066Z072	IDLE ROLLER SMOOTH 24 IN
73	P1066Z073	EXT RETAINING RING 19MM
74	P1066Z074	BUSHING
74V2	P1066Z074V2	BUSHING V2.12.23
75	P1066Z075	BRACKET
77	P1066Z077	FLAT WASHER 1/4
78	P1066Z078	TAP SCREW 1/4 X 1-1/2
79	P1066Z079	SIDE PANEL
80	P1066Z080	DUST PORT FRONT
81	P1066Z081	BEARING BLOCK SET
82	P1066Z082	SET SCREW 5/16-24 X 1/2
84	P1066Z084	BEARING BLOCK PLATE, TAPPED
85	P1066Z085	FLAT WASHER 3/8
86	P1066Z086	LOCK NUT 3/8-16
88	P1066Z088	COMPRESSION SPRING
89	P1066Z089	HEX BOLT 1/4-20 X 3/8
90	P1066Z090	FLAT WASHER 3/8
91	P1066Z091	HEX BOLT M8-1.25 X 24
92	P1066Z092	SANDING ROLL 3" x 50' A60 H&L
93	P1066Z093	SET SCREW 3/8-16 X 1/2
94	P1066Z094	DRUM PULLEY
95	P1066Z095	KEY 1/4 X 1/4 X 1-1/4
96	P1066Z096	SANDING ROLL 3" x 50' A120 H&L
97	P1066Z097	SET SCREW M6-1 X 6
98	P1066Z098	V-BELT B67
99	P1066Z099	HOOK-AND-LOOP BACKING
101	P1066Z101	STRIKE
102	P1066Z102	LATCH
105	P1066Z105	SPRING PLATE
106	P1066Z106	HEX NUT 1/4-20
107	P1066Z107	HEX BOLT 1/4-20 X 5/8
118	P1066Z118	LINE CORD
119	P1066Z119	LINE CORD
120	P1066Z120	EARTH LEAD GREEN



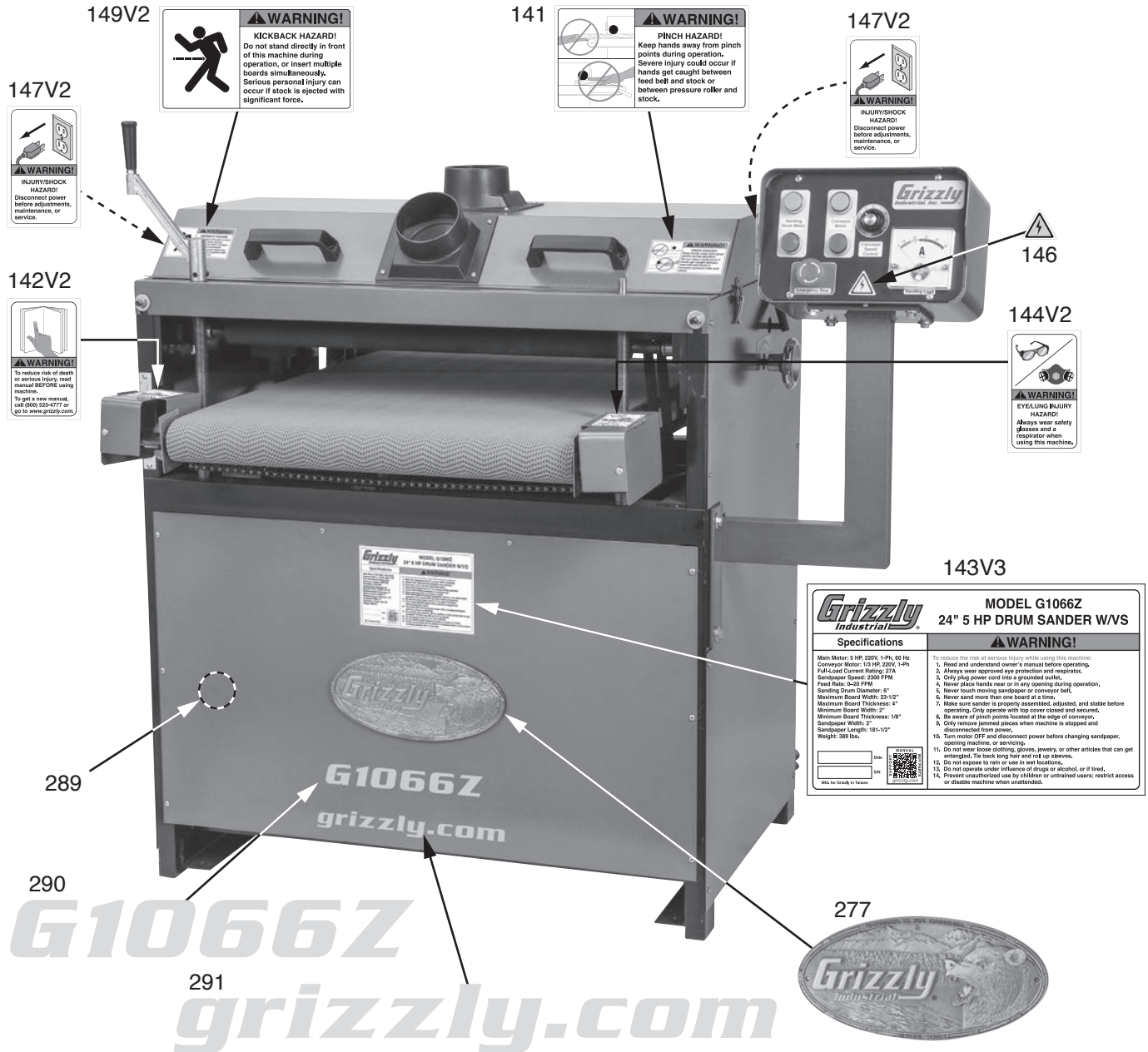
# G1066Z Parts List (Cont.)

REF	PART #	DESCRIPTION
125	P1066Z125	FLAT WASHER 1/4
126	P1066Z126	STRAIN RELIEF TYPE-3 PG20
136	P1066Z136	BASE STEEL CRATE
137	P1066Z137	PHLP HD SCR 10-24 X 3/8
138	P1066Z138	HEX NUT M4-.7
139	P1066Z139	TAP SCREW #8 X 1/2
140	P1066Z140	FLAT WASHER #10
201	P1066Z201	BEARING SEAT LEFT
202	P1066Z202	MOUNTING BRACKET
203	P1066Z203	BEARING SEAT RIGHT
204	P1066Z204	MICRO ADJUST SCREW
205	P1066Z205	THRUST BEARING SEAT
206	P1066Z206	BEVEL GEAR A
207	P1066Z207	BEVEL GEAR B
212	P1066Z212	LOCK COLLAR
214	P1066Z214	DRIVE SHAFT
216	P1066Z216	RIGHT BEARING SEAT BOLT 5/16-18 X 1/2
217	P1066Z217	WIRING PANEL
218V2	P1066Z218V2	MAG SWITCH BOX V2
218-1	P1066Z218-1	TERMINAL BLOCK
219	P1066Z219	PEDESTAL ARM
220	P1066Z220	CONTROL BOX
221	P1066Z221	CONTROL PANEL
221-1	P1066Z221-1	FEED RATE SWITCH
221-2V2	P1066Z221-2V2	COMP CONTROL WIRE HARNESS V2.10.08
222V2	P1066Z222V2	CONTACTOR SDE MA-09 240V V2.06.13
223	P1066Z223	ON SWITCH NHD CB-10
224	P1066Z224	OFF SWITCH NHD CB-01
225	P1066Z225	E-STOP BUTTON NHD CB-01
226	P1066Z226	LOAD/AMP METER
226-1	P1066Z226-1	LOAD/AMP METER COVER
227	P1066Z227	CABLE MARKER
238	P1066Z238	LOCK HANDLE
239	P1066Z239	SCALE
240	P1066Z240	CONTROL KNOB
242	P1066Z242	SET SCREW 1/4-20 X 5/16
243	P1066Z243	LOCK NUT 1/4-20
244	P1066Z244	POINTER
245	P1066Z245	SET SCREW 10-24 X 1/4
246	P1066Z246	PHLP HD SCR 1/4-20 X 3/8

REF	PART #	DESCRIPTION
247	P1066Z247	FLAT WASHER 5/16
248	P1066Z248	EXT RETAINING RING 20MM
249	P1066Z249	HEX NUT 1/4-20
250	P1066Z250	HEX BOLT 1/4-20 X 3/4
251	P1066Z251	FLAT WASHER 1/4
253	P1066Z253	HEX BOLT 5/16-18 X 1
254	P1066Z254	FLAT WASHER 5/16
256	P1066Z256	PHLP HD SCR 10-24 X 1/2
257	P1066Z257	FLAT WASHER #10
258	P1066Z258	HEX NUT 10-24
259V2	P1066Z259V2	PHLP HD SCR M5-.8 X 10
260	P1066Z260	VARIABLE SPEED CIRCUIT BOARD
261V2	P1066Z261V2	PHLP HD SCR M5-.8 X 15
261V3	P1066Z261V3	PHLP HD SCR 1/4-20 X 1/4
262	P1066Z262	HEX NUT 10-24
263	P1066Z263	HINGE
264	P1066Z264	NYLON CABLE TIES
265	P1066Z265	AIR DUST SCOOP
266	P1066Z266	HANDLE
267	P1066Z267	CAP SCREW 5/16-18 X 1-1/4
268	P1066Z268	THRUST BEARING 51101
269	P1066Z269	SPROCKET SHAFT
270	P1066Z271	SPROCKET
271	P1066Z271	ADJUSTMENT PLATE
272	P1066Z272	SUPPORT ARM LEFT
273	P1066Z273	SUPPORT ARM RIGHT
274	P1066Z274	BALL BEARING 6201-2RS
275	P1066Z275	HEX NUT 10-24
276	P1066Z276	PHLP HD SCR M4-.7 X 6
278	P1066Z278	SELF ADHESIVE FOAM 660 X 15 X 2MM
279	P1066Z279	DUST COVER
280	P1066Z280	DRIVE SHAFT BRACKET
282	P1066Z282	CAP SCREW 1/4-20 X 5/8
283	P1066Z283	SET SCREW 10-24 X 1/2
285	P1066Z285	CAP SCREW 5/16-18 X 3/4
286	P1066Z286	TAP SCREW #10 X 3/8
287	P1066Z287	CORD RETAINER CLIP
288	P1066Z288	TAP SCREW #8 X 5/8
292	P1066Z292	PHLP HD SCR M6-1 X 20



# G1066Z Labels & Cosmetics



REF	PART #	DESCRIPTION
141	P1066Z141	SANDER BELT PINCH LABEL
142V2	P1066Z142V2	READ MANUAL LABEL V2.09.22
143V3	P1066Z143V3	MACHINE ID LABEL V3.02.24
144V2	P1066Z144V2	RESPIRATOR/GLASSES LABEL V2.09.22
146	P1066Z146	ELECTRICITY LABEL
147V2	P1066Z147V2	DISCONNECT POWER LABEL V2.09.22

REF	PART #	DESCRIPTION
149V2	P1066Z149V2	KICKBACK HAZARD LABEL V2.09.22
277	P1066Z277	GRIZZLY NAMEPLATE-LARGE
289	P1066Z289	TOUCH-UP PAINT, GRIZZLY GREEN
290	P1066Z290	MODEL NUMBER LABEL
291	P1066Z291	GRIZZLY.COM LABEL

## ⚠ WARNING

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



# WARRANTY & RETURNS

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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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