

Grizzly *Industrial, Inc.*®

MODEL H7761 2" x 27" BELT & 6" DISC COMBO SANDER OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#JK7658 PRINTED IN CHINA



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 chemical 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.

WARNING

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

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INTRODUCTION

Foreword

We are proud to offer the Model H7761 2" x 27" Belt & 6" Disc Combo Sander. This machine is part of a growing Grizzly family of fine wood-working machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model H7761. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model H7761 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>





MACHINE DATA SHEET

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

MODEL H7761 COMBO BELT/DISC SANDER

Design Type Bench Model

Overall Dimensions:

Height (w/Work Light Extended)..... 19³/₄"
 Width 18³/₄"
 Depth 11³/₄"
 Shipping Weight 30 lbs.
 Net Weight..... 27 lbs.
 Box Size 16¹/₂" L x 15³/₄" W x 12¹/₂" H
 Footprint 6" x 8¹/₂"
 Arbor..... 1/2"
 Sanding Disc Size 6"
 Sanding Belt Size 2" x 27"

Motor:

Type..... TEFC Capacitor-Start Induction
 Horsepower 1/3 HP
 Voltage/Phase 110V / Single-Phase
 Amps 2.6A
 Cycle / RPM 60 Hertz / 3450 RPM

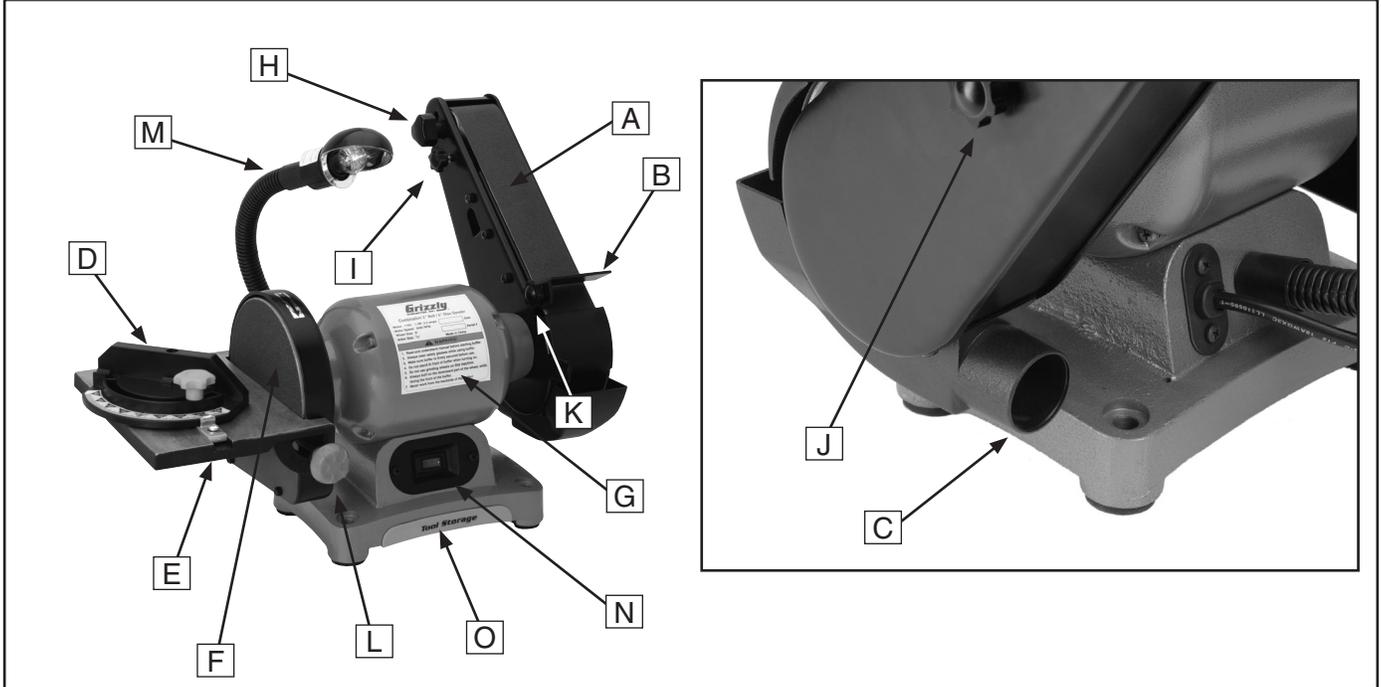
Features:

..... Tool Rests
 Rocker-Type Switch
 Flexible Work Light
 Convenient Tool Tray
 Included 80 Grit Sanding Belt
 Included 80 Grit Sanding disc

Specifications, while deemed accurate, are not guaranteed.



Identification



- A. Sanding Belt
- B. Back Stop
- C. 1 $\frac{1}{2}$ " Dust Ports (disc port not shown)
- D. Miter Gauge
- E. Disc Sanding Table
- F. Sanding Disc
- G. Motor
- H. Tracking Knob
- I. Belt Tensioning Knob
- J. Side Guard Knob
- K. Back Stop Angle Knob
- L. Table Angle Knobs (rear knob not shown)
- M. Adjustable Work Light
- N. *ON/OFF* Switch
- O. Tool Storage



SECTION 1: SAFETY

WARNING

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 which are 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.



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

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

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses. They are NOT safety glasses.
- 3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power off and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN MATERIALS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of dust you will be exposed to and always wear an approved respirator.



WARNING

Additional Safety Instructions for Sanders

- 1. RESPIRATOR AND SAFETY GLASSES.** Always wear a respirator and safety glasses while operating the machine. Dust and chips are created when sanding. Some debris will be ejected, becoming hazards to the eyes and lungs.
- 2. DUST COLLECTION SYSTEM.** It is safer to operate the sander with an adequate dust collection system in place and running.
- 3. CLOTHING.** DO NOT wear loose clothing while operating this machine. Roll up or button sleeves at the cuff.
- 4. HAND PROTECTION.** DO NOT place hands near, or in contact with, sanding belt during operation. DO NOT allow fingers to get pinched between the workpiece and the table. This may pull the operator's hand into the machine and cause serious injury!
- 5. MINIMUM STOCK DIMENSIONS.** Do not flat sand any stock thinner than $\frac{1}{16}$ " or narrower than $\frac{1}{8}$ "
- 6. INSPECTING WORKPIECES.** Always inspect workpiece for nails, staples, knots, and other imperfections that could be dislodged and thrown from the machine during sanding operations.
- 7. SANDING METAL.** DO NOT sand any kind of metal, as this is an imminent fire hazard and could lead to serious injury or death.
- 8. FEEDING WORKPIECE.** Firmly grasp the workpiece in both hands and ease it into the machine using light pressure. DO NOT jam the workpiece into the machine during operation. Feed the workpiece against the direction of rotation. DO NOT sand tapered or pointed stock with the point facing the feed direction. Never sand more than one piece of stock at a time.
- 9. UNATTENDED OPERATION.** Never leave the machine running unattended.
- 10. REPLACING SANDPAPER.** Replace sanding paper when it becomes worn. DO NOT operate the sander with damaged or badly worn sandpaper.
- 11. MAINTENANCE AND ADJUSTMENTS.** Perform machine inspections and maintenance service promptly when called for. Disconnect power before performing maintenance or adjustments on the sander.
- 12. EXPERIENCING DIFFICULTIES.** Any problem, with the exception of conveyor or belt tracking that is concerned with any moving parts or accessories, must be investigated and corrected with the power disconnected, and after all moving parts have come to a complete stop.

WARNING

Like all machines there is danger associated with the Model H7761. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

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



SECTION 2: CIRCUIT REQUIREMENTS

110V Operation

⚠️ WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The Model H7761 motor draws the following amps under maximum load:

Motor Draw2.6 Amps

Circuit Recommendations

We recommend connecting this machine to a dedicated circuit with a verified ground (**Figure 1**), using the circuit breaker size given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire hazard—consult a qualified electrician to reduce this risk.**

Circuit Breaker..... 15 Amps

Plug/Receptacle Type

Included Plug Type..... NEMA 5-15

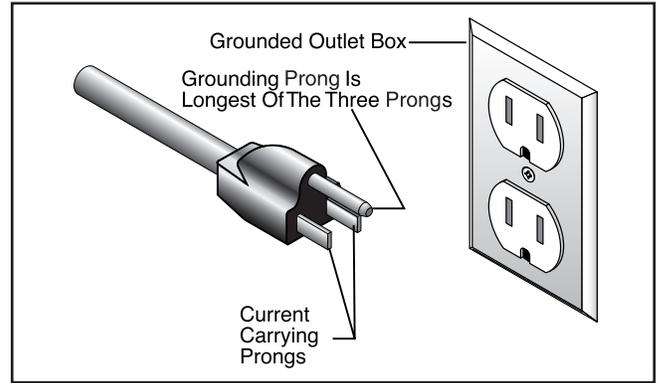
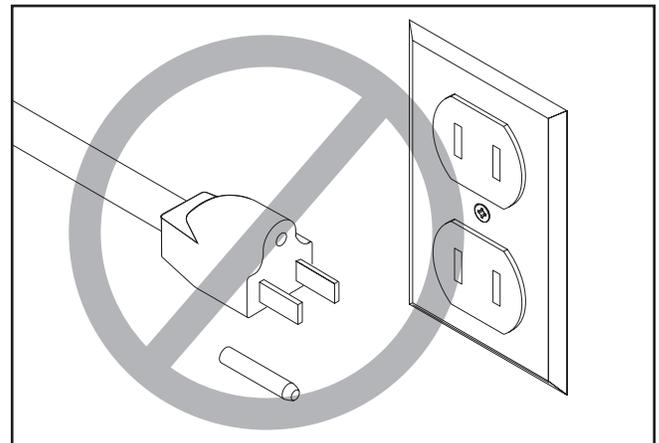


Figure 1. Typical type 5-15 plug & receptacle.



⚠️ CAUTION

This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.



⚠️ WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. **Ensure compliance by checking with a qualified electrician!**

Extension Cords

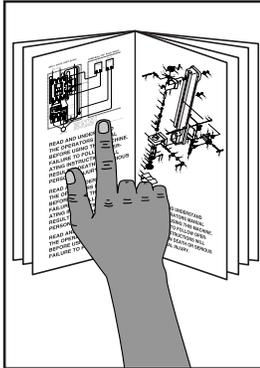
We do not recommend the use of extension cords. If you find it absolutely necessary:

- Use at least a 16 gauge cord that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.



SECTION 3: SET UP

Set Up Safety



⚠ 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 set up process!

Unpacking

The Model H7761 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, please immediately call Customer Service at (570) 546-9663 for advice.

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

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Inventory

After all the parts have been removed from the box, you should have the following items:

| Inventory (Figure 2) | Qty |
|--|-----|
| A. Sander Unit | 1 |
| B. Disc Sanding Table | 1 |
| C. Miter Gauge..... | 1 |
| D. Back Stop | 1 |
| E. Sanding Table Angle Knobs M6-1.0 x 18 ... | 2 |
| F. Flat Washers 6mm | 2 |
| G. Back Stop Adjustment Knob M5-0.8 x 9.... | 1 |
| H. Flat Washer 5mm | 1 |
| I. Hex Nut M5-0.8 | 1 |

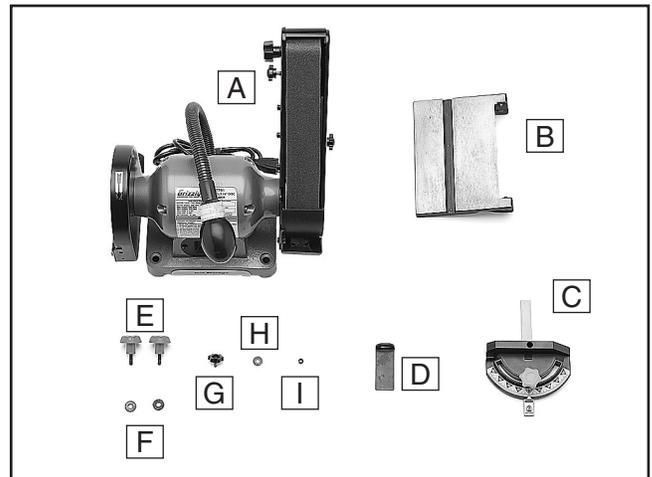


Figure 2. Inventory.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



Items Needed for Set Up

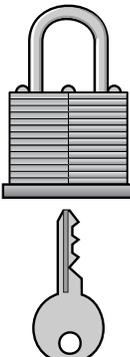
The following items are needed to complete the set up process, but are not included with your machine:

| Description | Qty |
|---------------------------------------|-----|
| Wrench 8mm | 1 |
| Wrench 13mm | 1 |
| Hex Bolt M8-1.25 (length varies)..... | 2 |
| Flat Washer 8mm | 4 |
| Lock Washer 8mm | 2 |
| Hex Nut M8-1.25 | 2 |

Mounting

The Model H7761 weighs 22 lbs. Make sure the workbench on which you plan to mount the sander is sturdy enough to hold the weight of the machine and any downward pressure that may be applied during operation. The workbench should have a level surface and be heavy, or attached to the floor so that it will not move during operation.

| Components and Hardware Required | Qty |
|---------------------------------------|-----|
| Sander Unit | 1 |
| Hex Bolt M8-1.25 (length varies)..... | 2 |
| Flat Washer 8mm | 4 |
| Lock Washer 8mm | 2 |
| Hex Nut M8-1.25 | 2 |



CAUTION

The Model H7761 can cause personal injury if operated by untrained users. Ensure that your machine is inaccessible to children and visitors by closing and locking all entrances to your shop/garage when you are away.

NOTICE

When mounted, the storage tray can be easily damaged if the grinder is tipped forward.

To mount the grinder:

1. Find the best place in your shop to mount the sander.

—Pick a spot on the workbench that will allow enough room to move the size of an anticipated workpiece around the sander. The operator (and possibly bystanders) should have enough room to stand out of the way.

—Mount the sander in an area with proper lighting and near electrical outlets. Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements.

Note: Keep power or extension cords clear of high-traffic areas. If you install new lighting, outlets, or circuits, observe all electrical codes.

2. Mount the sander to the workbench with bolts that are long enough to exceed the thickness of your workbench and the sander base. Secure each bolt with flat washers, a lock washer, and a hex nut as in **Figure 3**.

Note: Because sizes vary for each individual situation, the hardware in this step is not included with the Model H7761.

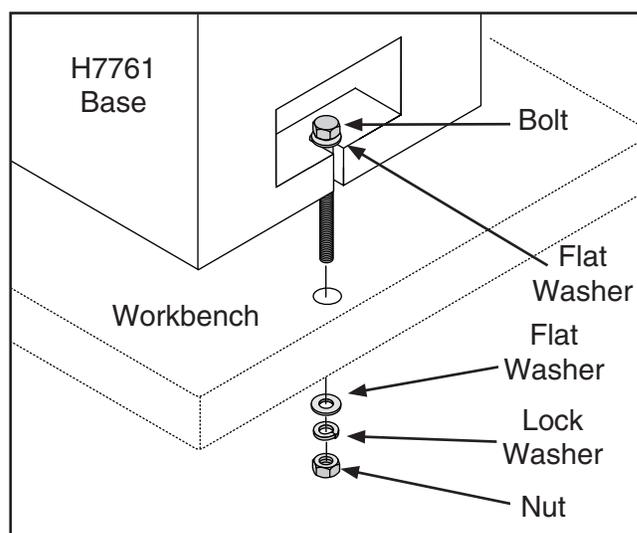


Figure 3. Mounting machine to the workbench.

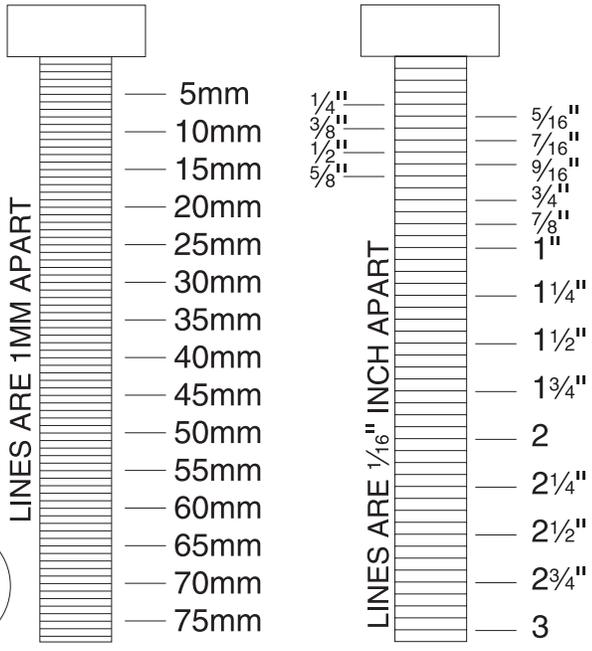
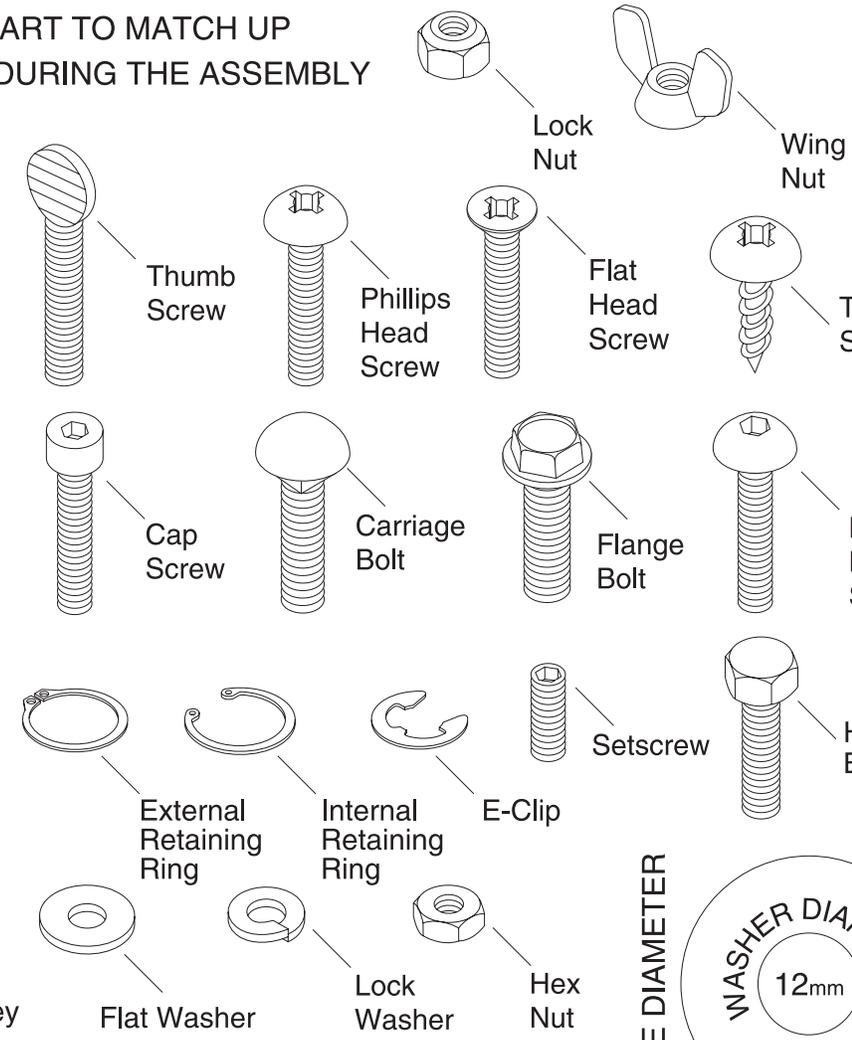


Hardware Recognition Chart

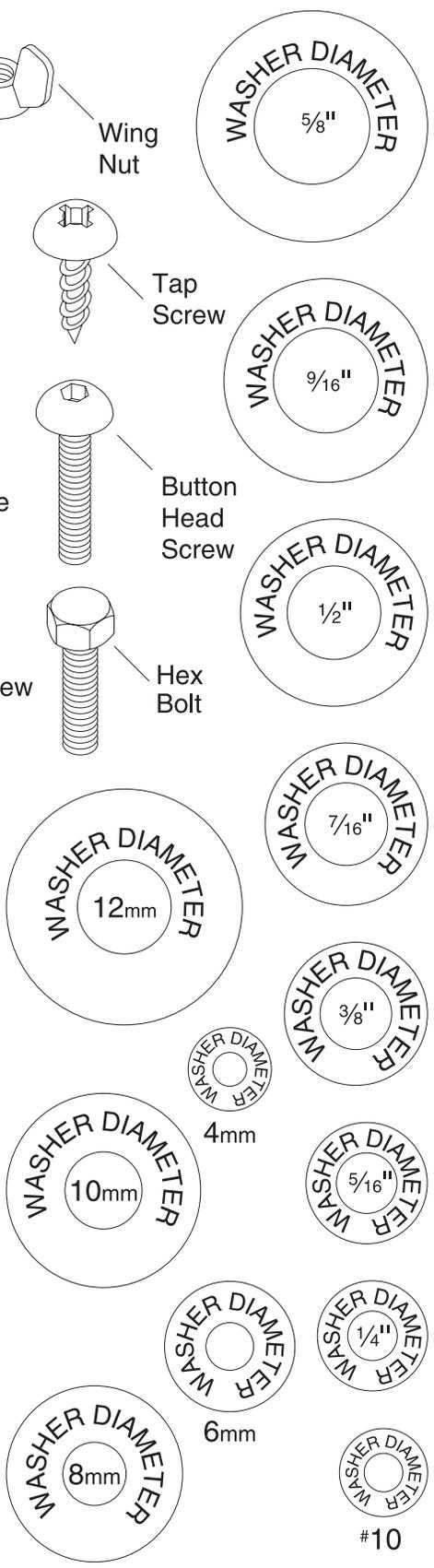
USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"
- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



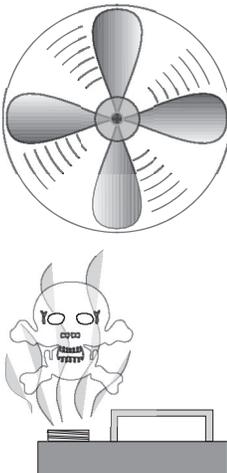
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

| | |
|--|--|
|  | <p>⚠️ WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p> |
|--|--|

| | |
|---|--|
|  | <p>⚠️ CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p> |
|---|--|

Site Considerations

Weight Load

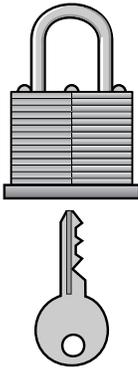
The Model H7761 Combo Sander is a moderate weight load with a small footprint. Most tables and workbenches should be sufficient to carry the weight of the machine. Reinforce the table or workbench if you question its ability to support the added weight.

Working Clearance

Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine, and space for auxiliary stands or work tables. Also consider the relative position of each machine to one another for efficient material handling.

Lighting and Outlets

Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle the amperage draw. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.

| | |
|--|--|
|  | <p>⚠️ WARNING Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.</p> |
|--|--|



Attaching Sanding Disc

The Model H7761 Combo Sander accepts 6" diameter cloth or paper-backed pressure sensitive adhesive (PSA) sanding discs. These are available in the current Grizzly catalog in a variety of grits.

The PSA sanding disc sticks directly to the surface of the aluminum disc and can be replaced with little effort. Often if the disc is still warm from sanding, the adhesive will be soft enough that the disc will come off very easily.

Components and Hardware Needed: Qty
6" PSA disc sandpaper 1

To attach sandpaper:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Remove the disc table.
3. Remove the worn out sandpaper by slowly peeling it from the aluminum disc.
4. If necessary, clean the aluminum disc with a light application of a non-oil, non-flammable solvent to remove any adhesive residue. Make sure the aluminum disc is thoroughly clean of all substances, including the solvent, before applying a new sanding disc.
5. Peel back the protective layer on one-half of the sandpaper disc and fold it against the remaining half.
6. Center the sticky half of the sandpaper on the upper half of the disc and press the sandpaper onto the surface.
7. Remove the remainder of the protective layer and then press the paper against the disc.
8. Rotate the disc by hand and make sure the sandpaper is firmly attached to the disc.
9. Reattach the disc table as outlined **on this page**.



Installing Disc Table

Components and Hardware Needed: Qty
Sanding Disc Table 1
Table Knobs 2
Flat Washer 6mm 2

To install the disc table:

1. Attach the table as shown in **Figure 4** with the included knobs and washers.

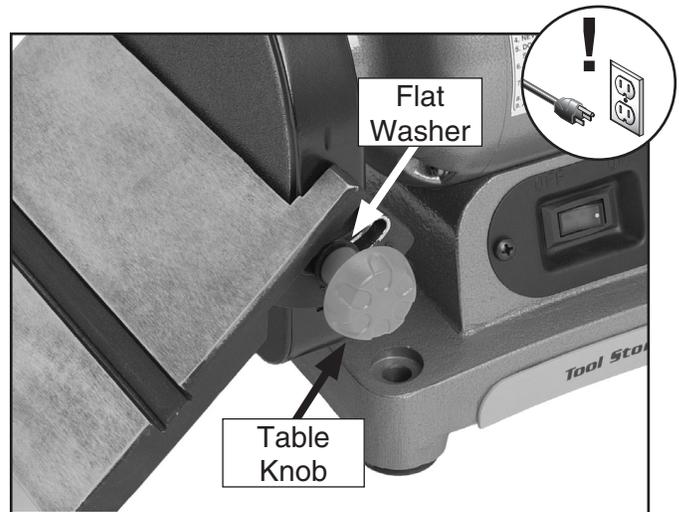


Figure 4. Installing disc table.

2. Using a machinist's square, set one edge on the table surface and the other against the face of the disc as shown in **Figure 5**.

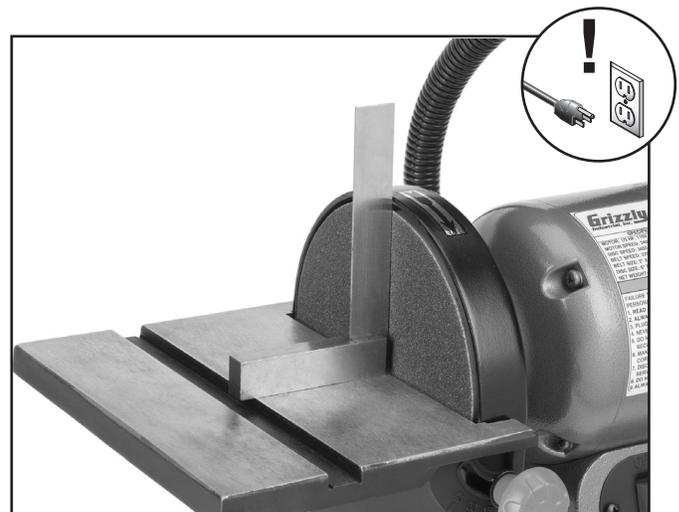


Figure 5. Squaring disc table.

- Loosen the angle knobs and adjust the table angle until there is no gap between the disc face and the square.
- Tighten the angle knobs while holding the table perpendicular.

Aligning Table

The table must be aligned to the face of the sanding disc so that the sandpaper does not rub against the table.

To align the table:

- DISCONNECT THE MACHINE FROM THE POWER SOURCE!
- Loosen the knobs that secure the table to the sanding unit.
- Adjust the table so that there is $\frac{3}{64}$ " or 1 mm between the table and the sanding disc as shown in **Figure 6**.

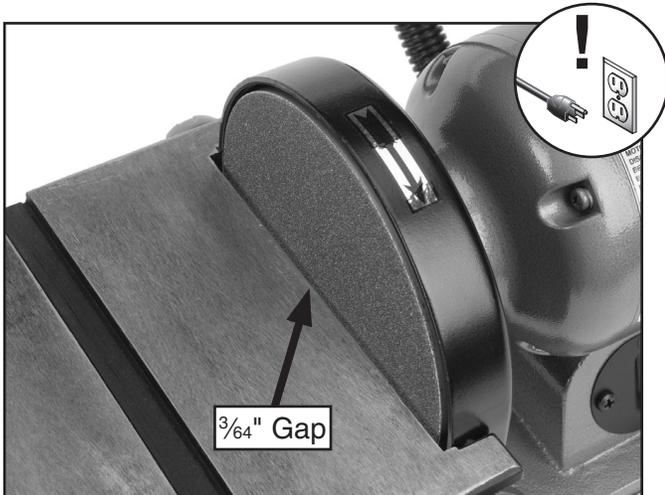


Figure 6. The gap between the table and the disc.

- Tighten the knobs loosened in **Step 2**.
- Spin the disc by hand to check if the sandpaper is touching the table.
- Repeat **Steps 2-4** if the sandpaper touches the table at any point in the rotation.

Adjusting Miter Gauge

The miter gauge needs to be adjusted perpendicular to the face of the wheel when it is mounted in the table slot.

To adjust miter gauge:

- DISCONNECT THE MACHINE FROM THE POWER SOURCE!
- Use a machinist square with one edge against the face of the miter gauge and the other against the disc face as shown in **Figure 7**.

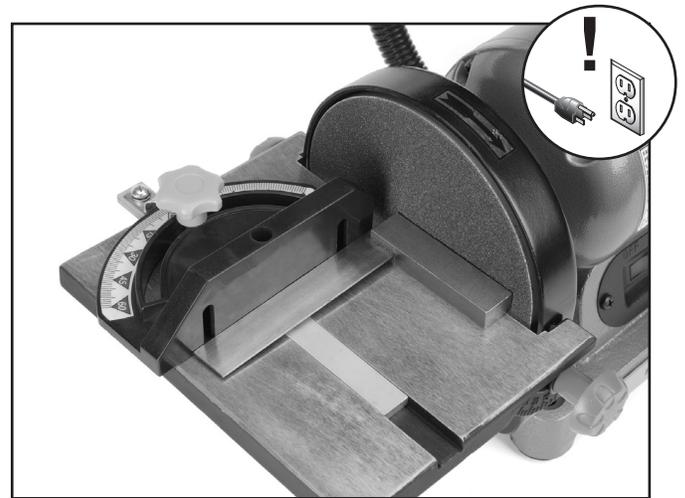


Figure 7. Squaring the miter gauge.

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

Note: Sometimes the tightening procedure can affect the adjustment.

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



Installing Sanding Belt

To install the sanding belt:

1. Initially loosen the belt tension by loosening the tensioning knob, and if necessary, by loosening the tracking knob.
2. Remove the side guard by unscrewing the side guard knob completely.

Note: To provide further access to the lower drive wheel, it is also possible to remove the front belt guard.

3. Slide the belt onto the drive drums as shown in **Figure 9** and tighten both the tensioning knob and the tracking knob. The tensioning knob should be completely tightened.
4. Test the belt tension by lightly pressing on it. The belt should give some resistance before it touches the belt support.

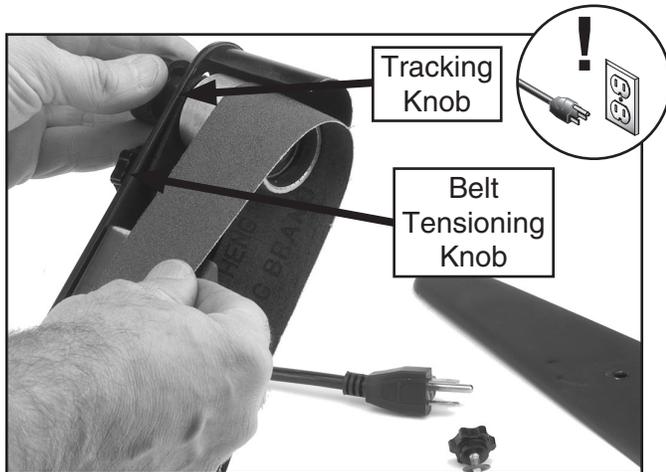


Figure 9. Installing belt.

Note: Make sure that the arrow on the inside of the sanding belt points the same direction as the belt rotation arrow on the machine.

Adjusting Sanding Belt Tracking

!WARNING

Before starting the sander, perform the preceding assembly and adjustment instructions, and read through the rest of the manual and to become familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury.

Once the sanding belt is installed, test the belt tracking to see if the belt slides off the drum.

To test the tracking:

1. Remove all tools from the sander.
2. Plug the sander into the power source. Turn the sander **ON** and then immediately **OFF**.
3. If the sanding belt moves toward the disc, turn the tracking knob shown in **Figure 10** towards the rear of the sander ½ turn.



Figure 10. Sanding belt tracking knob.

4. If the sanding belt moves away from the disc, turn the tracking knob towards the front of the sander ½ turn.



- Turn the sander **ON** and then immediately **OFF**. The belt is tracking properly if it stays centered on the drive drums. If the belt moves to the side, return to **Step 3**.

Note: Listen for any unusual noises, vibrations or rubbing while adjusting the tracking. If anything sounds unusual, stop the sander immediately. Disconnect the machine from the power source and find the source of the problem before operating further. If you cannot locate the source of an unusual noise or vibration, feel free to contact our Technical Support department for help.

Installing Back Stop

To install the back stop:

- Ensure that the belt is tracking evenly and properly, as outlined on **Page 13**.
- Attach the back stop with the knob, washer and hex nut as shown in **Figure 8**.

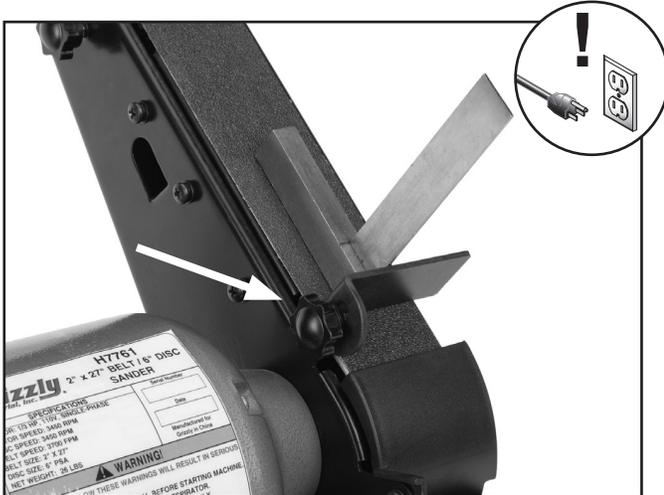


Figure 8. Squaring the back stop

- Square the back stop as shown in **Figure 8** and tighten the back stop knob.

Installing Dust Collection Hose

The dust ports are located behind both the sanding belt and the sanding disc. Each opening is 1½" in diameter and can be connected to a utility vacuum or a dust collector.

To connect a dust port to a dust collection system:

- Place a hose clamp over the dust hose.
- Slide the hose over the dust port.
- Secure the hose airtight with the hose clamp.
- Check the hose with a light tug to ensure it is secure.

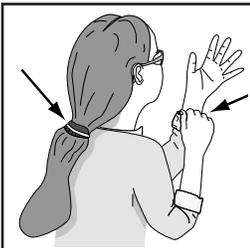


SECTION 4: OPERATIONS

General

This section covers basic sanding operations. Please read the remaining portion of the manual before attempting any type of operation.

Your safety is important! Please follow the warnings below during this entire section:



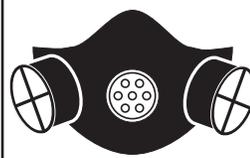
!WARNING

Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



!WARNING

Using this machine produces dust which may cause allergic reactions and respiratory problems. Protect yourself by wearing safety glasses and a respirator during the entire operation process. **DO NOT** wear gloves while operating this machine as they can be caught in the rotating surfaces and become entangled. Failure to comply with this warning may result in serious personal injury.



!WARNING

Operating this equipment has the potential to propel debris into the air which can cause eye injury. Always wear safety glasses or goggles when operating equipment. **Everyday glasses only have impact resistant lenses — they are not safety glasses.** Be sure the safety glasses you wear meet the standards of the American National Standards Institute (ANSI).

Disc Sanding

!CAUTION

Always keep the workpiece on the side of the wheel that is rotating down toward the table. This will keep the workpiece from flying out of your hands due to the rotational forces.

To perform disc sanding operations:

1. Set the angle of the table relative to the sanding disc. The angle can be set with the angle scale on the sides of the sanding table or with a protractor for greater accuracy.
2. When a 90° horizontal angle is required, place one surface of the workpiece firmly against the face of the miter gauge (set at 0°), with the other surface against the face of the disc (**Figure 11**).



Figure 11. Disc sanding.

3. Using light pressure, move the workpiece slowly back and forth to the center of the disc to prevent the workpiece from burning and to prevent excessive loading of the sanding disc.



Miter Sanding

The most efficient way to get a perfect miter is to cut the workpiece slightly long and sand it to the desired dimension. Miter sanding can be done easily with the miter gauge.

To perform miter sanding operations:

1. Loosen the knob on the miter gauge, adjust the angle to the desired point, and tighten the knob.
2. Slide the miter gauge into its slot and use it to hold your workpiece in position.

Note: *The miter gauge can be used in either direction in the slot to achieve the proper relation of the workpiece to the disc.*

3. Using light pressure, move the workpiece slowly back and forth across the disc as shown in **Figure 12**.



Figure 12. Disc sanding with a miter gauge.

!WARNING

Never use the Model H7761 for applications other than those for which it was made. **DO NOT** overload the machine or use excess force when sanding. Severe personal injury, damage to the machine, or damage to your workpiece could occur.

Angle Sanding

!CAUTION

Always keep the workpiece on the side of the wheel that is rotating down toward the table. This will keep the workpiece from flying out of your hands from the rotational forces.

Miters can also be sanded by changing the angle of the table.

To perform angle sanding operations:

1. Loosen the angle knobs securing the table.
2. Use the angle gauge to achieve the desired table angle and tighten the angle knobs.

Note: *The disc table can be positioned from 0° to 45°, relative to the plane of the sanding surface.*

3. Slide the miter gauge into the miter slot and use the miter gauge to hold your workpiece in position.
4. Using light pressure, push the workpiece slowly into the downspin side of the rotating disc (**Figure 13**).



Figure 13. Mitering with the table angled.

5. Move the workpiece slowly back and forth across the downspin side of the disc.



Belt Sanding

Belt sanding allows you to sand the flat surface of a workpiece.

To perform belt sanding operations:

1. Turn the power **ON** and allow the sander to reach full speed.
2. Place the workpiece against the surface of the sanding belt. Hold the workpiece firmly with both hands but keep fingers away from the sanding surface as shown in **Figure 14**.
3. Move the workpiece across the surface of the belt for even belt wear.
4. Use the back stop to prevent the workpiece from being thrown off by the rotation of the sanding belt.



Figure 14. Belt sanding.

WARNING

Never sand the short side of any workpiece with the belt sander. This carries a high risk of kickback and serious personal injury!



SECTION 5: ACCESSORIES

G7984—Face Shield

H1298—Dust Sealed Safety Glasses

H1300—UV Blocking, Clear Safety Glasses

H2347—Uvex® Spitfire Safety Glasses

H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!

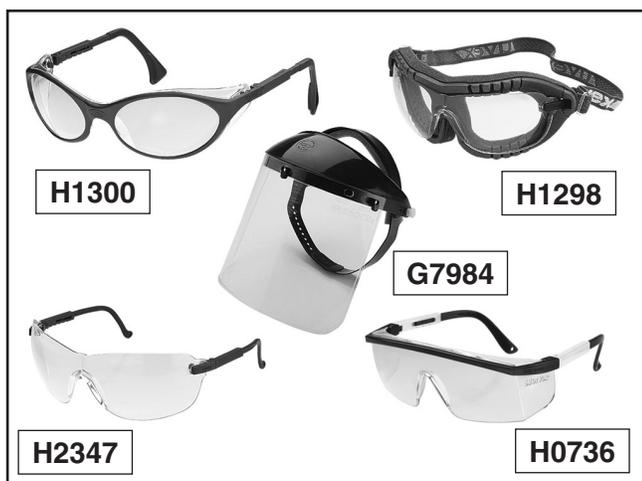


Figure 1. Our most popular safety glasses.

2" x 27" Silicon Carbide Sanding Belts

Our silicon carbide sanding belts are available in packs of ten.

| MODEL | SIZE | GRIT |
|-------|----------|------|
| H5016 | 2" x 27" | 60 |
| H5017 | 2" x 27" | 80 |
| H5018 | 2" x 27" | 100 |
| H5019 | 2" x 27" | 120 |
| H5020 | 2" x 27" | 150 |
| H5021 | 2" x 27" | 180 |
| H5022 | 2" x 27" | 220 |

PRO-STIK® Belt Cleaners

G1511—Large (1½" x 1½" x 8½")

G1512—Small (2" x 2" x 12")

H1446—1¾" x 4¼"

H1447—1¾" x 8½"

These crepe-rubber Belt Cleaners quickly remove gum and grit from belts and discs without damage. Extend the life of your belts or discs with this innovative natural cleaner.



Figure 2. PRO-STIK® Belt Cleaners.

Aluminum Oxide Sanding Discs

Our aluminum oxide sanding discs are manufactured in ISO 9002 factories to ensure the highest quality. Available in packs of three.

| MODEL | TYPE | GRIT |
|-------|--------|------|
| G1445 | 6" PSA | 60 |
| G4236 | 6" PSA | 80 |
| G1446 | 6" PSA | 100 |
| G4237 | 6" PSA | 120 |
| G1447 | 6" PSA | 150 |
| G4238 | 6" PSA | 180 |
| G4239 | 6" PSA | 220 |

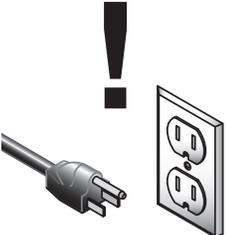
Call 1-800-523-4777 To Order

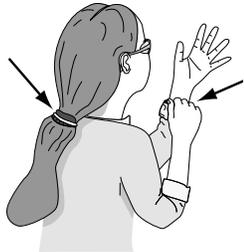


SECTION 6: MAINTENANCE

Maintenance Safety

Your safety is important! Please follow the warnings below during this entire section:

| | |
|---|---|
|  | <p>! WARNING Serious personal injury could occur if you connect your machine to the power source during the maintenance process. DO NOT connect the machine to the power source while performing any maintenance on this machine.</p> |
|---|---|

| | |
|---|---|
|  | <p>! WARNING Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from machinery.</p> |
|---|---|

| | |
|---|--|
|  | <p>! WARNING Projectiles from the machine could cause serious eye injury. Wear safety glasses at all times.</p> |
|---|--|

Schedule

Before Each Use:

- Tighten back stop, table or guard knobs.
- Replace any worn or damaged sanding discs or belts.
- Check for worn or damaged wires.
- Check for any other condition that could hamper the safe operation of this machine.

After Each Use:

- Turn **OFF** machine.
- Wipe off the sawdust build-up from the table surface.

Weekly Maintenance:

- Wipe a lubricant such as SLIPIT® onto the table.

Long-Term Storage:

- Keep unpainted surfaces rust free with products such as Boeshield® T-9.



Lubricating Sleeve Bearings

Lubricate the sleeve bearing with 30 WT oil every 10 hours of operation. No other lubrication is necessary for this machine.

To lubricate the sleeve bearings:

1. DISCONNECT THE MACHINE FROM THE POWER SOURCE!
2. Remove the sanding belt.
3. Apply two or three drops of oil in the hole at the end of the idler pulley (**Figure 15**).
4. Wipe of any residual oil.

Note: *DO NOT apply extra oil. Too much oil can cause the belt to slip.*



Figure 15. Lubricating the sleeve bearings.



SECTION 7: SERVICE

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



Troubleshooting

| SYMPTOM | POSSIBLE CAUSE | CORRECTIVE ACTION |
|---|--|--|
| Motor will not start. | <ol style="list-style-type: none"> 1. Low voltage. 2. Open circuit in motor or loose connections. | <ol style="list-style-type: none"> 1. Check power line voltage and correct if necessary. 2. Inspect all connections on motor for loose or open connections. |
| Motor will not start; fuses/circuit breakers blow. | <ol style="list-style-type: none"> 1. Loose connections or short circuit in line cord, plug, or motor. 2. Incorrect fuses or circuit breakers in power line. | <ol style="list-style-type: none"> 1. Inspect cord, plug and motor for damaged insulation, shorted wires or loose terminals. 2. Install correct fuses or circuit breakers. |
| Motor stalls (resulting in blown fuses or tripped circuit). | <ol style="list-style-type: none"> 1. Motor overloaded. 2. Short circuit in motor or loose connections. 3. Low voltage. 4. Incorrect fuses or circuit breakers in power line. | <ol style="list-style-type: none"> 1. Reduce load on motor. 2. Inspect connections on motor for loose or shorted terminals or worn insulation. 3. Check power line voltage and correct if necessary. 4. Install correct fuses or circuit breakers. |
| Machine slows when operating. | <ol style="list-style-type: none"> 1. Workpiece pressure is too great. | <ol style="list-style-type: none"> 1. Reduce workpiece pressure on wheel. |
| Machine vibrates excessively. | <ol style="list-style-type: none"> 1. Machine not mounted securely. 2. Incorrect sanding belt tracking. 3. Weak or broken tension spring. 4. Broken/defective sanding belt. 5. Sanding disc rubbing or not centered properly. | <ol style="list-style-type: none"> 1. Secure machine to benchtop or stand. 2. Follow belt tracking instructions on Page 15. 3. Replace spring. 4. Replace sanding belt. 5. Adjust sanding table to prevent disc contact. |
| Sanded surface not square. | <ol style="list-style-type: none"> 1. Table not perpendicular to disc. 2. Miter gauge not square to disc. | <ol style="list-style-type: none"> 1. Adjust table tilt. 2. Adjust miter gauge. |
| Deep sanding grooves or scars in workpiece. | <ol style="list-style-type: none"> 1. Sandpaper damaged or clogged. 1. Sandpaper too coarse for the desired finish. 2. Workpiece sanded across the grain. 3. Too much sanding force on workpiece. 4. Workpiece held still against the belt or disc. | <ol style="list-style-type: none"> 1. Clean and/or replace sanding surface. 1. Use a finer grit sanding belt or disc. 2. Sand with the grain. 3. Reduce pressure on workpiece while sanding. 4. Keep workpiece moving while sanding. |
| Grains rub off the belt or disc easily. | <ol style="list-style-type: none"> 1. Sanding belt or disc has been stored in an incorrect environment. 2. Sanding belt or disc has been damaged. | <ol style="list-style-type: none"> 1. Store sanding belt or disc away from damp conditions. 2. Store sanding belt or disc flat, not folded or bent. |
| Sanding surfaces clog quickly or burn. | <ol style="list-style-type: none"> 1. Too much pressure against belt or disc. 2. Sanding softwood. | <ol style="list-style-type: none"> 1. Reduce pressure on workpiece while sanding. 2. Use different stock or plan on cleaning/replacing belts frequently. |
| Burn marks on workpiece. | <ol style="list-style-type: none"> 1. Using too fine of sanding grit. 2. Using too much pressure. 3. Work held still for too long. | <ol style="list-style-type: none"> 1. Use a coarser grit sanding belt or disc. 2. Reduce pressure on workpiece while sanding. 3. Do not keep workpiece in one place for too long. |
| Glazed sanding surfaces. | <ol style="list-style-type: none"> 1. Sanding wet stock. 2. Sanding stock with high residue. | <ol style="list-style-type: none"> 1. Dry stock properly before sanding. 2. Use different stock or plan on cleaning/replacing belts/discs frequently. |
| Workpiece kick-back or vibration. | <ol style="list-style-type: none"> 1. Not supporting the workpiece against the stop. 2. Starting the workpiece on a leading corner. | <ol style="list-style-type: none"> 1. Use back stop to support workpiece. 2. Start workpiece on a trailing corner. |



Parts List

| REF | PART # | DESCRIPTION |
|-----|-----------|---------------------------------|
| 1 | PH7761001 | WORK TABLE |
| 2 | PH7761002 | DISC PAPER 80 GRIT |
| 3 | PSB01M | CAP SCREW M6-1 X 16 |
| 4 | PTLW13M | INTERNAL TOOTH WASHER 6MM |
| 5 | PH7761005 | SANDING DISC |
| 6 | PS08M | PHLP HD SCR M5-.8 X 12 |
| 7 | PLW01M | LOCK WASHER 5MM |
| 8 | PH7761008 | DISC GUARD |
| 9 | PS79M | PHLP HD SCR M4-.7 X 8 |
| 10 | PH7761010 | DISC COVER/DUST PORT |
| 11 | PH7761011 | GAUGE BODY |
| 12 | PH7761012 | GAUGE SLIDE |
| 13 | PH7761013 | GAUGE INDICATOR |
| 14 | PTLW02M | EXT TOOTH WASHER 5MM |
| 15 | PS05M | PHLP HD SCR M5-.8 X 8 |
| 16 | PW03M | FLAT WASHER 6MM |
| 17 | PH7761017 | MITER GAUGE KNOB M6-1 X 22 |
| 18 | PH7761018 | LOCK KNOB M6-1 X 18 |
| 19 | PH7761019 | BULB 10W |
| 20 | PH7761020 | LAMP COVER |
| 21 | PH7761021 | LAMP ARM |
| 22 | PH7761022 | MOTOR END CAP |
| 23 | PH7761023 | SPECIAL WAVE WASHER 35MM |
| 24 | P6202 | BEARING 6202 |
| 25 | PH7761025 | STATOR |
| 26 | PH7761026 | ROTOR |
| 27 | PH7761027 | BASE |
| 28 | PH7761028 | CORD CLIP FIXED PLATE |
| 29 | PH7761029 | CORD BUSHING |
| 30 | PH7761030 | CORD CLIP |
| 31 | PH7761031 | CORD |
| 32 | PH7761032 | RUBBER FOOT |
| 33 | PLW02M | LOCK WASHER 4MM |
| 34 | PW05M | FLAT WASHER 4MM |
| 35 | PTLW11M | INT TOOTH WASHER 4MM |
| 36 | PH7761036 | CAPACITOR 9M 300VAC 1.3" X 1.8" |
| 37 | PH7761037 | CAPACITOR BRACKET |
| 38 | PN03M | HEX NUT M8-1.25 |

| REF | PART # | DESCRIPTION |
|-----|-----------|---------------------------|
| 39 | PH7761039 | SWITCH PLATE |
| 40 | PH7761040 | SWITCH |
| 41 | PH7761041 | TOOL STORAGE BOTTOM COVER |
| 42 | PH7761042 | TOOL STORAGE |
| 43 | PS06M | PHLP HD SCR M5-.8 X 20 |
| 44 | PS26M | PHLP HD SCR M6-1 X 20 |
| 45 | PH7761045 | TRACKING KNOB M8-1.25 |
| 46 | PW01M | FLAT WASHER 8MM |
| 47 | PH7761047 | TENSIONING KNOB M6-1 X 10 |
| 48 | PS09M | PHLP HD SCR M5-.8 X 10 |
| 49 | PH7761049 | RIGHT SAFE GUARD |
| 50 | PW02M | FLAT WASHER 5MM |
| 51 | PH7761051 | SAFE GUARD |
| 52 | PW02M | FLAT WASHER 5MM |
| 53 | PN06M | HEX NUT M5-.8 |
| 54 | PH7761054 | TENSION PLATE |
| 55 | PH7761055 | IDLER SHAFT CUSHION |
| 56 | P6201 | BALL BEARING 6201RS |
| 57 | PR29M | INT RETAINING RING 32MM |
| 58 | PH7761058 | IDLER DRUM |
| 59 | PH7761059 | IDLER SHAFT |
| 60 | PH7761060 | RIGHT GUARD COVER |
| 61 | PH7761061 | COVER KNOB M5-.8 X 10 |
| 62 | PH7761062 | SANDING BELT 80 GRIT |
| 63 | PN09M | HEX NUT M12-1.75 |
| 64 | PH7761064 | BELT DRIVE WHEEL |
| 65 | PH7761065 | BELT SUPPORT |
| 66 | PH7761066 | TENSIONING ROD |
| 67 | PN03M | HEX NUT M8-1.25 |
| 68 | PH7761068 | COMPRESSION SPRING |
| 69 | PH7761069 | DUST PORT |
| 70 | PH7761070 | RIGHT TOOL REST |
| 71 | PN04M | HEX NUT M4-.7 |
| 72 | PN01M | HEX NUT M6-1 |
| 73 | PH7761073 | LOCK WASHER 10MM |
| 74 | PN14M | HEX NUT M10-1 |
| 75 | PLW03M | LOCK WASHER 6MM |
| 76 | PH7761076 | MACHINE ID LABEL |

WARNING

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



WARRANTY AND RETURNS

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

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

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

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

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

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





WARRANTY CARD

Name _____
 Street _____
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 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

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 Card Deck Website Other:

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|---|--|---|
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| <input type="checkbox"/> Journal of Light Cont. | <input type="checkbox"/> Projects in Metal | <input type="checkbox"/> Woodwork |
| <input type="checkbox"/> Live Steam | <input type="checkbox"/> RC Modeler | <input type="checkbox"/> Woodworker West |
| <input type="checkbox"/> Model Airplane News | <input type="checkbox"/> Rifle | <input type="checkbox"/> Woodworker's Journal |
| <input type="checkbox"/> Modeltec | <input type="checkbox"/> Shop Notes | <input type="checkbox"/> Other: |
| <input type="checkbox"/> Old House Journal | <input type="checkbox"/> Shotgun News | |

3. What is your annual household income?

\$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

20-29 30-39 40-49
 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: We never use names more than 3 times. Yes No

10. Comments: _____

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