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

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

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

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

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

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

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

Machine Description

This machine is designed to capture dust and wood chips from multiple woodworking machines at the same time, such as table saws, jointers, and planers.

A wide variety of accessories for setting up a stationary or mobile dust collection system are available through Grizzly.

Manual Accuracy

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

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

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

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

Contact Info

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

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

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

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

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

WARNING
MODEL G0671 4 HP DUST COLLECTOR

Product Dimensions:
- Weight: 270 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height: 73-7/8 x 31-3/8 x 101-1/8 in.
- Footprint (Length x Width): 73-7/8 x 31-3/8 in.

Shipping Dimensions:
- Type: Cardboard Box & Wood Frame
- Content: Machine
- Weight: 306 lbs.
- Length x Width x Height: 42 x 29 x 30 in.
- Must Ship Upright: Yes

Electrical:
- Power Requirement: 220V, Single-Phase, 60 Hz
- Prewired Voltage: 220V
- Full-Load Current Rating: 26A
- Minimum Circuit Size: 40A
- Connection Type: Permanent (Hardwire to Shutoff Switch)
- Power Cord Included: Yes
- Plug Included: No
- Switch Type: Magnetic Switch w/Overload Protection

Motors:
- Main
  - Horsepower: 4 HP
  - Phase: Single-Phase
  - Amps: 26A
  - Speed: 3450 RPM
  - Type: TEFC Capacitor-Start Induction
  - Power Transfer: Direct Drive
  - Bearings: Shielded & Permanently Lubricated

Main Specifications:
- Operation
  - Dust Collector Type: Single-Stage
  - Approved Dust Types: Wood
  - Filter Type: Bag
  - Airflow Performance: 352 CFM
  - Max Static Pressure (at 0 CFM): 13.5 in.
  - Main Inlet Size: 10 in.
  - Inlet Adapter Included: Yes
  - Number of Adapter Inlets: 4
  - Adapter Inlet Size: 4 in.
  - Machine Collection Capacity At One Time: 3
  - Filtration Rating: 2.5 Micron
Bag Information

- Number of Upper Bags: 2
- Number of Lower Bags: 2
- Upper Bag Length: 47-1/4 in.
- Lower Bag Length: 54 in.

Impeller Information

- Impeller Type: Radial Fin
- Impeller Size: 14-1/2 in.
- Impeller Blade Thickness: 1/4 in.

Construction

- Upper Bag: Fabric
- Lower Bag: Plastic
- Frame: Steel Sheet Metal w/Casters
- Impeller: Steel
- Paint Type/Finish: Powder Coated
- Body: Steel Sheet Metal

Other Specifications:

- Country of Origin: Taiwan
- Warranty: 1 Year
- Approximate Assembly & Setup Time: 1 Hour
- Serial Number Location: ID Label on Front of Machine
- Sound Rating: 90 dB
- ISO 9001 Factory: Yes
- Certified by a Nationally Recognized Testing Laboratory (NRTL): No

Features:

- 2.5 Micron Upper Bag Filtration
- 14-1/2" Balanced Steel, Radial Fin Impeller
- Heavy-Duty Steel Stand with 3" Casters and Brakes
- Green Powder Coated Paint
- Sturdy Collection Bags with 24 cu. ft. Total Capacity
- Four-Port Intake Manifold for Even Distribution to Collection Bags
MODEL G0671
4 HP DUST COLLECTOR

Performance Curve

4 HP DUST COLLECTOR PERFORMANCE RESULTS

<table>
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<th>Inlet Dia. (inch)</th>
<th>CFM</th>
<th>Static Pressure (Inch/H2O)</th>
<th>Amps</th>
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</table>

Test run using 30 micron upper and lower bag.
**MODEL G0672 5 HP INDUSTRIAL DUST COLLECTOR**

**Product Dimensions:**
- Weight: 286 lbs.
- Dimensions: 74 x 29 x 134 in.

**Shipping Dimensions:**
- Type: Cardboard Box & Wood Frame
- Height: 42 x 29 x 30 in.
- Weight: Yes

**Electrical:**
- Power Requirement: 220V, Single-Phase, 60 Hz
- Prewired Voltage: 220V
- Full-Load Current Rating: 34A
- Minimum Circuit Size: 50A
- Connection Type: Permanent (Hardwire to Shutoff Switch)
- Power Cord Included: Yes
- Plug Included: No
- Switch Type: Magnetic Switch w/Overload Protection

**Motors:**
- Horsepower: 5 HP
- Phase: Single-Phase
- Amps: 34A
- Speed: 3450 RPM
- Type: TEFC Capacitor-Start Induction
- Power Transfer: Direct Drive
- Bearings: Shielded & Permanently Lubricated

**Main Specifications:**

**Operation**
- Dust Collector Type: Single-Stage
- Approved Dust Types: Wood
- Filter Type: Bag
- Airflow Performance: 3961 CFM
- Max Static Pressure (at 0 CFM): 14.6 in.
- Main Inlet Size: 10 in.
- Inlet Adapter Included: Yes
- Number of Adapter Inlets: 4
- Adapter Inlet Size: 4 in.
- Machine Collection Capacity At One Time: 4
- Filtration Rating: 2.5 Micron

Due to our ongoing improvement efforts, this information may not accurately describe items previously purchased.
Bag Information

Number of Upper Bags: 2
Number of Lower Bags: 2
Upper Bag Length: 70 in.
Lower Bag Length: 54 in.

Impeller Information

Impeller Type: Radial Fin
Impeller Size: 15 in.
Impeller Blade Thickness: 1/4 in.

Construction

Upper Bag: Fabric
Lower Bag: Plastic
Frame: Steel Sheet Metal w/Casters
Caster: Rubber
Impeller: Steel
Paint Type/Finish: Powder Coated
Blower Housing: Formed Steel

Other Specifications:

Country of Origin: Taiwan
Warranty: 1 Year
Approximate Assembly & Setup Time: 1 Hour
Serial Number Location: ID Label on Front of Machine
Sound Rating: 92 dB
ISO 9001 Factory: Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL): No

Features:

2.5 Micron Upper Bag Filtration
15" Balanced Steel, Radial Fin Impeller
Heavy-Duty Steel Stand with 3" Casters and Brakes
Green Powder Coated Paint
Sturdy Collection Bags with 24 cu. ft. Total Capacity
Four-Port Intake Manifold for Even Distribution to Collection Bags
MODEL G0672
5 HP DUST COLLECTOR

Performance Curve

Test run using 2.5 micron upper bag and plastic lower collection bag. Max amp draw after adding 10" x 4" x 4 inlet: 30.3A.
MODEL G0673 10 HP INDUSTRIAL DUST COLLECTOR

Product Dimensions:

- Weight........................................................................................................................................... 410 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height.............................................................. 61 x 61 x 134 in.
- Footprint (Length x Width)........................................................................................................ 61 x 61 in.

Shipping Dimensions:

- Type........................................................................................................................................ Cardboard Box & Wood Frame
- Content...................................................................................................................................... Machine
- Weight...................................................................................................................................... 472 lbs.
- Length x Width x Height......................................................................................................... 53 x 46 x 31 in.
- Must Ship Upright.................................................................................................................. Yes

Electrical:

- Power Requirement.......................................................................................................... 220V or 440V, 3-Phase, 60 Hz
- Prewired Voltage............................................................................................................... 220V
- Full-Load Current Rating.................................................................................................. 30A at 220V, 15A at 440V
- Minimum Circuit Size........................................................................................................ 40A at 220V, 20A at 440V
- Connection Type............................................................................................................... Permanent (Hardwire to Shutoff Switch)
- Switch Type........................................................................................................................ Magnetic Switch w/Overload Protection
- Voltage Conversion Kit....................................................................................................... P0508037 for 440V
- Recommended Phase Converter......................................................................................... G7979

Motors:

- Horsepower......................................................................................................................... 10 HP
- Phase.................................................................................................................................... 3-Phase
- Amps...................................................................................................................................... 30A/15A
- Speed.................................................................................................................................... 3450 RPM
- Type....................................................................................................................................... TEFC Induction
- Power Transfer .................................................................................................................. Direct Drive
- Bearings............................................................................................................................... Shielded & Permanently Lubricated

Main Specifications:

Operation

- Dust Collector Type............................................................................................................. Single-Stage
- Approved Dust Types........................................................................................................ Wood
- Filter Type............................................................................................................................. Bag
- Airflow Performance.......................................................................................................... 5360 CFM
- Max Static Pressure (at 0 CFM)......................................................................................... 17.9 in.
- Main Inlet Size.................................................................................................................... 10 in.
- Inlet Adapter Included......................................................................................................... Yes
- Number of Adapter Inlets.................................................................................................... 5
- Adapter Inlet Size............................................................................................................... 4 in.
- Machine Collection Capacity At One Time...................................................................... 4
- Maximum Material Collection Capacity........................................................................... 48 cu. ft.
- Filtration Rating................................................................................................................... 2.5 Micron
Bag Information

Number of Upper Bags: 4
Number of Lower Bags: 4
Upper Bag Length: 70 in.
Lower Bag Length: 54 in.

Impeller Information

Impeller Type: Radial Fin
Impeller Size: 17 in.
Impeller Blade Thickness: 1/4 in.

Construction

Upper Bag: Fabric
Lower Bag: Plastic
Frame: Steel Sheet Metal w/Casters
Caster: Rubber
Impeller: Steel
Paint Type/Finish: Powder Coated
Blower Housing: Formed Steel

Other Specifications:

Country of Origin: Taiwan
Warranty: 1 Year
Approximate Assembly & Setup Time: 1-1/2 Hours
Serial Number Location: ID Label on Front of Machine
ISO 9001 Factory: Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL): No

Features:

2.5 Micron Upper Bag Filtration
17" Balanced Steel, Radial Fin Impeller
Heavy-Duty Steel Stand with 3" Casters and Brakes
Green Powder Coated Paint
Sturdy Collection Bags with 48 cu. ft. Total Capacity
Five-Port Intake Manifold for Even Distribution to Collection Bags
Test run using 2.5 micron upper bag and plastic lower collection bag.
Max amp draw after adding 10” x 4” x 5 inlet: 30.5A.
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.

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

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

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

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

Safety Instructions for Machinery

⚠️ WARNING

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

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

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

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

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

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

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

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 Dust Collectors

**WARNING**

Long-term respiratory damage can occur from using dust collectors without proper use of a respirator. Fire or explosions can result in smoke inhalation, serious burns, or death—if machine is used to collect incorrect materials, is operated near potential explosion sources, or ducting is improperly grounded. Entanglement, amputation, or death can occur if hair, clothing, or fingers are pulled into the inlet. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

**INTENDED USE.** Collecting the wrong materials can result in serious inhalation hazards, fire, explosions, or machine damage. This machine is ONLY designed to collect wood dust and chips from woodworking machines. DO NOT use it to collect silica, polyurethane, toxic fumes, metal dust or shavings, lead paint, drywall, asbestos, biohazards, explosive dusts, flammable or combustible liquids or fumes, nor burning or smoking material.

**POWER DISCONNECT.** Turn machine **OFF**, disconnect from power supply, and allow impeller to completely stop before leaving machine unattended, or doing any maintenance or service.

**REGULAR CLEANING.** To reduce risk of starting a fire, regularly check/empty collection bags to avoid buildup of fine dust, which can increase risk of fire. Regularly clean surrounding area where machine is operated—excessive dust buildup on overhead lights, heaters, electrical panels, or other heat sources will increase risk of fire.

**SUSPENDED DUST PARTICLES.** To reduce risk of death or injury caused by explosions or fires, DO NOT operate in areas where these risks are high, including spaces near pilot lights, open flames, or other ignition sources.

**AVOIDING SPARKS.** To reduce risk of fire, avoid collecting any metal objects or stones. These can possibly produce sparks when they strike impeller, which can smolder in wood dust for a long time before a fire is detected. If you accidentally cut into wood containing metal, immediately turn **OFF** dust collector, disconnect from power, and wait for impeller to stop. Then empty bag or drum into approved airtight metal container.

**FIRE SUPPRESSION.** Only operate dust collector in locations that contain fire suppression system or have fire extinguisher nearby.

**STATIC ELECTRICITY.** To reduce risk of fire or explosions caused by sparks from static electricity, ground all ducting using grounding wire.

**DUST ALLERGIES.** Dust from certain woods will cause an allergic reaction. Make sure you know what type of wood dust you will be exposed to in case of an allergic reaction.
SECTION 2: POWER SUPPLY

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

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

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

G0671
Full-Load Current Rating at 220V ..... 26 Amps

G0672
Full-Load Current Rating at 220V ..... 34 Amps

G0673
Full-Load Current Rating at 220V ..... 30 Amps
Full-Load Current Rating at 440V ..... 15 Amps

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

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

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

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

Note: Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.
**G0671 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:

**Nominal Voltage** ............... 208V, 220V, 230V, 240V  
**Cycle** ........................................ 60 Hz  
**Phase** ........................................ Single-Phase  
**Power Supply Circuit** .................. 40 Amps

**G0672 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:

**Nominal Voltage** ............... 208V, 220V, 230V, 240V  
**Cycle** ........................................ 60 Hz  
**Phase** ........................................ Single-Phase  
**Power Supply Circuit** .................. 50 Amps

**G0672 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:

**Nominal Voltage** ............... 208V, 220V, 230V, 240V  
**Cycle** ........................................ 60 Hz  
**Phase** ........................................ 3-Phase  
**Power Supply Circuit** .................. 40 Amps

**G0673 Circuit Requirements for 440V**
This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to Voltage Conversion instructions for details.)

**Nominal Voltage** ............... 208V, 220V, 230V, 240V  
**Cycle** ........................................ 60 Hz  
**Phase** ........................................ 3-Phase  
**Power Supply Circuit** .................. 20 Amps

**Connection Type**
A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

**Grounding Instructions**
In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

**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.

**Extension Cords**
Since this machine must be permanently connected to the power supply, an extension cord cannot be used.
G0673 440V Conversion

The Model G0673 can be converted for 440V operation. This conversion job consists of disconnecting the machine from the power source, changing the connections on the magnetic switch and rewiring the motor for 440V operation.

The Model G0673 440V Conversion Kit (Part #P0673036) for this procedure can be purchased by calling Grizzly Customer Service at (800) 523-4777.

All wiring changes must be performed by an electrician or qualified service personnel before the machine is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

To rewire the Model G0673 for 440V operation:

1. DISCONNECT MACHINE FROM POWER!

2. Remove the magnetic switch cover, then disconnect and remove the 220V magnetic switch (see Figure 2).

3. Install the 440V magnetic switch and wire it according to the G0673 Wiring Diagram on Page 45.

4. Remove the motor junction box cover, rewire the motor as shown on the diagram located inside the junction box, then re-install the cover.

Note: The reference motor wiring diagram on Page 45 was current at the time of printing, but always use the wiring diagram provided inside the motor junction box, as it will reflect any changes to the motor shipped with your machine.
### SECTION 3: SETUP

#### Needed for Setup

The following are needed to complete the setup process:

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Assistant</td>
<td>1 or more</td>
</tr>
<tr>
<td>Safety Glasses (for each person)</td>
<td>1</td>
</tr>
<tr>
<td>Gloves (for each person)</td>
<td>1</td>
</tr>
<tr>
<td>Phillips Head Screwdriver</td>
<td>1</td>
</tr>
<tr>
<td>Wrench 10mm</td>
<td>1</td>
</tr>
<tr>
<td>Wrenches 12mm</td>
<td>2</td>
</tr>
<tr>
<td>Ladder (for hanging upper bag)</td>
<td>1</td>
</tr>
</tbody>
</table>

#### Unpacking

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

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

---

**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.

**WARNING**

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.
### G0671/G0672 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.

<table>
<thead>
<tr>
<th>Contents (Figures 3 &amp; 4)</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Collectors</td>
<td>2</td>
</tr>
<tr>
<td>B. Impeller Housing with Motor</td>
<td>1</td>
</tr>
<tr>
<td>C. Casters</td>
<td>4</td>
</tr>
<tr>
<td>D. Leg Braces</td>
<td>4</td>
</tr>
<tr>
<td>E. Combo Wrench 10 x 12mm</td>
<td>1</td>
</tr>
<tr>
<td>F. Legs</td>
<td>4</td>
</tr>
<tr>
<td>G. Gaskets</td>
<td>2</td>
</tr>
<tr>
<td>H. 4-in-1 Inlet Adapter</td>
<td>1</td>
</tr>
<tr>
<td>I. Hangers</td>
<td>2</td>
</tr>
<tr>
<td>J. Hanger Supports</td>
<td>2</td>
</tr>
<tr>
<td>K. Lower Collection Bags (Plastic)</td>
<td>2</td>
</tr>
<tr>
<td>L. Upper Filter Bags (Fabric)</td>
<td>2</td>
</tr>
</tbody>
</table>

**Fasteners (where used) (not shown)**

- Hex Bolts ⅜"-18 x 2½" (legs) ............... 8
- Hex Nuts ⅜"-18 (legs/collectors) .......... 24
- Hex Bolts ⅜"-18 x ½" (leg braces) ....... 16
- Hex Bolts ⅜"-18 x 1" (collectors) ........ 16
- Hex Bolts ⅜"-20 x ½" (hangers) ............ 6
- Flat Washers ⅜" (collectors) .............. 32
- Phillips Head Screw 10-24 X ½" (inlet) ... 1
- Bag Clamps (bags) ......................... 4

Figure 3. G0671/G0672 Inventory 1.

Figure 4. G0671/G0672 Inventory 2.
G0673 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.

Contents (Figures 5–7)  

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Collectors ................................................... 4</td>
</tr>
<tr>
<td>B. 5-in-1 Inlet Adapter ..................................... 1</td>
</tr>
<tr>
<td>C. G0673 Impeller Housing with Motor .................. 1</td>
</tr>
<tr>
<td>D. Legs.................................................................... 4</td>
</tr>
<tr>
<td>E. Leg Braces ...................................................... 4</td>
</tr>
<tr>
<td>F. Combo Wrench 10 x 12mm................................. 1</td>
</tr>
<tr>
<td>G. Casters ............................................................. 4</td>
</tr>
<tr>
<td>H. Upper Filter Bags (Fabric) ................................. 4</td>
</tr>
<tr>
<td>I. Lower Collection Bags (Plastic) .................................. 4</td>
</tr>
<tr>
<td>J. Hangers .............................................................. 4</td>
</tr>
<tr>
<td>K. Hanger Supports .................................................. 4</td>
</tr>
<tr>
<td>L. Rubber Gaskets .................................................. 4</td>
</tr>
<tr>
<td>M. Bag Clamps........................................................ 8</td>
</tr>
</tbody>
</table>

Fasteners (where used) (not shown)  

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hex Bolts ½&quot;-18 x 2½&quot; (legs) ......................... 8</td>
</tr>
<tr>
<td>Hex Nuts ½&quot;-18&quot; (legs/collectors) .................. 40</td>
</tr>
<tr>
<td>Hex Bolts ½&quot;-18 x ½&quot; (leg braces) ................. 16</td>
</tr>
<tr>
<td>Hex Bolts ½&quot;-18 x 1&quot; (collectors) ................. 32</td>
</tr>
<tr>
<td>Hex Bolts ¼&quot;-20 x ½&quot; (hangers) ..................... 12</td>
</tr>
<tr>
<td>Flat Washers ¼&quot; (collectors) ......................... 64</td>
</tr>
<tr>
<td>Phillips Head Screw 10-24 X ½&quot; (inlet) ......... 1</td>
</tr>
</tbody>
</table>

Figure 5. G0673 Inventory 1.

Figure 6. G0673 Inventory 2.

Figure 7. G0673 Inventory 3.
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.

Figure 1. Model G0671-3 illustrated top view and suggested clearances.
Assembly

To assemble the dust collector:

1. With assistance, place the impeller housing on the floor so that the motor is pointing up.

2. Insert the legs into the leg mounting brackets and secure them with the eight 5/16"-18 x 2 1/2" hex bolts and 5/16"-18 hex nuts, as shown in Figure 8. Do not yet fully tighten the nuts.

3. Attach the four leg braces to the legs with the (16) 5/16"-18 x 1/2" hex bolts, as shown in Figure 9. Fully tighten the bolts and the hardware from Step 2.

4. Attach the four casters to the legs by threading them into the bottom of the legs, as shown in Figure 11.

5. With assistance, turn the entire assembly over so that the casters rest on the floor.

6. Use (8) 5/16"-18 x 1" hex bolts, (16) 5/16" flat washers, and (8) 5/16"-18 hex nuts to attach each collector to the impeller housing with a rubber gasket between the components, as shown in Figure 10.
**Note:** The Model G0673 is a three-phase machine. If it is wired out of phase, the machine may not function properly. Proceed to Test Run on Page 26 to determine if your machine is wired in phase, then proceed to Step 7.

The Models G0671 and G0672 are single phase and cannot be wired out of phase. For these models, continue below.

7. Attach the inlet to the top of the impeller housing with the #10-24 x 3/8" Phillips head screw, as shown in Figure 12.

8. Secure the hanger into the hanger support with one (Model G0673) or two (Model G0671/G0672) ¼"-20 x ½" hex bolts (see Figure 13).

9. Mount the hanger assembly on the protruding rod on the collector with one (Model G0671/G0672) or two (Model G0673) ¼"-20 x ½" hex bolts, as shown in Figure 14.

10. Align the hanger assembly so that the hook is directly over the center of the collector.

11. Repeat Steps 8–10 for the remaining hanger assemblies.

12. Place the loop at the top of each upper collection bag over each hook on the hanger assemblies (see Figure 15).

---

**Figure 12.** Inlet mounted on impeller housing.

**Figure 13.** Hanger attached to hanger support (G0671/G0672 shown).

**Figure 14.** Hanger assembly mounted onto collector (G0671/G0672).

**Figure 15.** Upper filter bag mounted on hanger assembly.
13. Thread the bag clamp into and around the bottom seam of the upper collection bag (see Figure 16).

![Figure 16. Upper filter bag secured to collector.](image)

14. Slip the bottom of the bag with the clamp over the top lip of the collector.

15. Fasten the locking mechanism of the bag clamp to secure the bag to the collector (see Figure 16).

16. Repeat Steps 12–15 for the remaining upper bags.

17. Install the lower bags.

—**Model G0671**: Repeat Steps 12-15 in a similar manner to install the remaining lower collection bags on the lower rims of each collector. Then, proceed to **Test Run on Page 26**.

—**Model G0672-73**: Slip the lower plastic collection bag over the bottom lip of the collector and position the bag evenly around the collector. Snag the bag on the hooks to hold it in place until the bag clamp can be secured (see Figure 17).

![Figure 17. Bottom collection bag snagged on collector hooks.](image)

18. Wrap the bag clamp around the collector, position it between the bottom lip of the collector and the hooks, and fasten the bag clamp to secure the bag to the collector (see Figure 18).

![Figure 18. Lower collection bag secured to collector.](image)

19. Repeat Steps 16 & 17 for the remaining Model G0672-73 lower bag assemblies.
Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) (Model G0673 only), the motor turns the correct direction (machine is not wired out of phase).

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the Troubleshooting on Page 40.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

[WARNING]

Before starting the dust collector, make sure you have performed the preceding assembly instructions, and you have read through the rest of the manual and are familiar with the various functions and safety features on this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Connect the machine to the power source.

4. Turn the machine **OFF** by pushing in the RED button on the power switch.

5. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

6. Turn the machine **OFF** by pushing in the RED button on the power switch.

7. **Model G0673 Only:** Verify that the power is not connected out of phase by starting/ stopping the machine and determining if the motor turns in the correct direction, using the criteria below:

—If the impeller turns counterclockwise (when looking down on the inlet port on the impeller housing), it is turning in the correct direction.

—If the impeller turns clockwise, it is turning in the wrong direction. Stop the machine, shut off the power source, then swap any two of the three power wires that connect to the machine.
SECTION 4: DESIGNING THE SYSTEM

General

The Model G0671/G0672/G0673 can be operated as either a stationary or mobile unit. There are advantages and disadvantages to both set-ups. The advantage of the mobile system is eliminating the cost of many ducts and fittings. On the other hand, the stationary system is more versatile and convenient.

The Model G0671/G0672/G0673 is designed to be a central dust collector system. Locate the dust collector in an out of the way location such as a corner or separate room. These machines can accommodate the following number of machines each drawing 400 CFM on a 4" dust port:

G0671: ............................................................... 8
G0672: ............................................................... 9
G0673: .............................................................12

The large suction capacity of the Model G0671/G0672/G0673 allows great flexibility in planning and designing of your dust collection duct layout. Grizzly offers a complete line of dust collection accessories for setting up a stationary system. Additionally, Grizzly offers a complete guide book titled *Dust Collection Basics*.

A 4-port inlet is included with the Model G0671/G0672 and a 5-port inlet is included with the Model G0673 for quick and economical dust collection setup. However, depending upon your system design using this feature, bags may fill at different rates requiring you to empty some bags more often than others.

Whatever system you choose, always make sure there are no open flames (including pilot lights) in the same room as the dust collector; otherwise you risk an explosion if dust is dispersed into the air.

Duct Material

You have many choices regarding main line and branch line duct material. For best results, use metal duct for the main line and branch lines, then use short lengths of flexible hose to connect each machine to the branch lines.

Plastic duct is also a popular material for home shops. However, be aware that there is a fire or explosion hazard if plastic duct material is used for dust collection without being grounded against static electrical charge build-up. This topic will be discussed later in this section. Another problem with using plastic is that it is less efficient per foot than metal.

Metal Duct

Advantages of metal duct (see Figure 19) is its conductivity and that it does not contribute to static electrical charge build-up. However, static charges are still produced when dust particles strike other dust particles as they move through the duct. Since metal duct is a conductor, it can be grounded quite easily to dissipate any static electrical charges.

![Figure 19. Examples of metal pipe and components.](image-url)
There are quite a number of options when it comes to metal duct, but metal duct that is specially manufactured for dust collection is the best choice. When selecting your metal duct, choose high quality metal duct with smooth welded internal seams that will minimize airflow resistance. This type of duct usually connects to other ducts or elbows with a simple, self-sealing clamp, is very quick and easy to assemble, and can be readily dismantled and re-installed. This is especially important if you ever need to change things around in your shop or add more machines. See the Accessories section on Page 36 for examples.

Avoid inferior metal duct that requires you to cut it to length and snap it together. This type of duct is time consuming to install because it requires you to seal all the seams with silicone and screw the components on the ends with sheet metal screws. Another disadvantage is the rough internal seams and crimped ends that unavoidably increase static pressure loss.

Flexible Duct
Flexible hose is generally used for short runs, small shops and at rigid duct-to-tool connections. There are many different types of flex hose on the market today. These are manufactured from materials such as polyethylene, PVC, cloth hose dipped in rubber and even metal, including steel and aluminum.

The superior choice for flexible ducting is metal flex hose that is designed to be flexible and as smooth as possible to reduce static pressure loss.

Figure 20. Example of flexible metal duct.

There are also many kinds of pure plastic flexible hose, such as non-perforated drainage type hose and dryer vent hose. Drainage type hose, while being economical, does not quite have the flexibility required for dust collection. The inside of the duct is also deeply corrugated and can increase the static pressure loss by as much as 50% over smooth wall duct. Dryer vent hose offers greater flexibility, but is non-resistant to abrasion and tends to collapse in a negative pressure system. We DO NOT recommend using dryer vent hose in your dust collection system.

If using flex-hose, choose one of the many types designed specifically for the movement of solid particles, i.e. dust, grains and plastics. However, the cost of specifically designed flexible duct can vary greatly. Grizzly offers polyethylene hose, which is well suited for the removal of particulate matter, especially sawdust, since it is durable and completely flexible. Polyethylene is also very economical and available in a wide variety of diameters and lengths for most applications.

Plastic Duct
The popularity of plastic duct is due to the fact that it is economical and readily available. It is also simple to assemble and easily sealed against air loss. The primary disadvantage of plastic duct for dust collection is the inherent danger of static electrical build-up.

Figure 21. Example of plastic duct and components.
System Design

Step 1. Decide Who Will Design
For most small-to-medium sized shops, you can design and build the dust collection system yourself without hiring engineers or consultants. We have included some basic information here to get you started on a dust collection system design.

If you have a large shop or must design a complicated system, then we recommend that you perform additional research beyond this manual, or seek help from an expert.

Step 2. Sketch Your Shop Layout
Planning is the most important step when designing a successful dust collection system.

Before you begin to draw your necessary layout sketch, we recommend that you visit our FREE Workshop Planner available on our website at www.grizzly.com.

Our Workshop Planner will allow you to quickly and easily draw and print a basic shop layout. Don't worry, non-Grizzly brand machines can be substituted with Grizzly machines for layout purposes. **Note:** After you're finished, make sure to save your layout for later modification.

Your sketch only needs the basic details of the shop layout, similar to Figure 22, including all your current/planned machines and your planned placement of the dust collector.

Step 3. Sketch a Basic Duct Layout
For the next step, sketch how your machines will connect to the dust collector. Consider these general guidelines for planning an efficient system:

1. Machines that produce the most sawdust should be placed nearest to the dust collector (i.e. planers and sanders).

2. Ideally, you should design the duct system to have the shortest possible main line and secondary branch ducts. See Figures 23 & 24 for ideas of good duct layouts vs bad duct layouts.

Figure 22. Initial sketch of shop layout.

Figure 23. Good duct layout.

Figure 24. Bad duct layout.
3. Directional changes should be kept to a minimum. The more directional change fittings you use directly increases the overall resistance to airflow.

4. Gradual directional changes are more efficient than sudden directional changes (i.e. use the largest corner radius possible when changing hose or pipe direction).

5. Each branch line should have a blast gate immediately after the branch to control suction from one machine to another.

6. The simpler the system, the more efficient and less costly it will be.

**Step 4. Determine Required CFM of Each Machine**

Since each machine produces a different amount of sawdust, the requirements for the minimum amount of CFM needed to move that sawdust is unique to the machine (for example, a planer produces more sawdust than a table saw). Knowing this required CFM is important in gauging which size of duct to use.

Figure 25 will give you a close estimation of the airflow your machine requires. Machines that generate the most sawdust should be placed near the dust collector. If the machine has multiple dust ports, the total CFM required is the sum of all ports.

<table>
<thead>
<tr>
<th>Machine</th>
<th>Average Dust Port Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table Saw</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Miter/Radial-Arm Saw</td>
<td>2&quot;</td>
</tr>
<tr>
<td>Jointer (6&quot; and smaller)</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Jointer (8&quot;-12&quot;)</td>
<td>5&quot;</td>
</tr>
<tr>
<td>Thickness Planer (13&quot; and smaller)</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Thickness Planer (14&quot;-20&quot;)</td>
<td>6&quot;</td>
</tr>
<tr>
<td>Shaper</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Router (mounted to table)</td>
<td>2&quot;</td>
</tr>
<tr>
<td>Bandsaw</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Lathe</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Disc Sander (12&quot; and smaller)</td>
<td>2&quot;</td>
</tr>
<tr>
<td>Disc Sander (13-18&quot;)</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Belt Sander (6&quot; and smaller)</td>
<td>2&quot;</td>
</tr>
<tr>
<td>Belt Sander (7&quot;-9&quot;)</td>
<td>3&quot;</td>
</tr>
<tr>
<td>Edge Sander (6&quot; x 80&quot; and smaller)</td>
<td>4&quot;</td>
</tr>
<tr>
<td>Edge Sander (6&quot; x 80&quot; and larger)</td>
<td>5&quot;</td>
</tr>
<tr>
<td>Drum Sander (24&quot; and smaller)</td>
<td>2 x 4&quot;</td>
</tr>
<tr>
<td>Drum Sander (24&quot; and larger)</td>
<td>4 x 4&quot;</td>
</tr>
<tr>
<td>Widebelt Sander (18&quot; and smaller)</td>
<td>5&quot;</td>
</tr>
<tr>
<td>Widebelt Sander (24&quot;-37&quot; single head)</td>
<td>2 x 6&quot;</td>
</tr>
<tr>
<td>Widebelt Sander (24&quot;_51&quot; double head)</td>
<td>5 x 4&quot;</td>
</tr>
</tbody>
</table>

**Figure 26.** Dust port size and quantity per average machine.

Write the required CFM for each machine on your sketch, as shown in **Figure 27**.

<table>
<thead>
<tr>
<th>Machine</th>
<th>Approximate Required CFM</th>
</tr>
</thead>
<tbody>
<tr>
<td>2&quot;</td>
<td>98</td>
</tr>
<tr>
<td>2.5&quot;</td>
<td>150</td>
</tr>
<tr>
<td>3&quot;</td>
<td>220</td>
</tr>
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<td>884</td>
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<td>1203</td>
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<tr>
<td>8&quot;</td>
<td>1570</td>
</tr>
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<td>9&quot;</td>
<td>1990</td>
</tr>
<tr>
<td>10&quot;</td>
<td>2456</td>
</tr>
</tbody>
</table>

**Figure 25.** Approximate required airflow for machines, based on dust port size.
Determining Main Line Duct Size

The general rule of thumb for a main line duct is that the velocity of the airflow must not fall below 3500 FPM.

Use the inlet size of the dust collector as a starting point for the main line. Neck the main line down 1" for every 10' of length. This will usually keep the air velocity above 3500 FPM and, depending on your system, will allow you to keep multiple branches open at one time.

For the Model G0671/G0672/G0673 this is 10". Mark your drawing, as in Figure 28.

Multiple Dust Ports

If your machine has multiple dust ports, add the total CFM given for each dust port size from Figure 25. Refer to Figure 30 and find the CFM that is closest to your total to determine the correct branch size. Split the branch line just before the dust ports with matching duct sizes.

Two Machines on Same Branch Line

If both machines will be running at the same time, add the total CFM given for each dust port size from Figure 25.

If both the machines will never be run at the same time, reference the machine with biggest dust port to Figure 30 and add blast gates after the Y-branch to open/close the line to each machine.

<table>
<thead>
<tr>
<th>Total CFM</th>
<th>Branch Line Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>&lt;500</td>
<td>4&quot;</td>
</tr>
<tr>
<td>600</td>
<td>5&quot;</td>
</tr>
<tr>
<td>700</td>
<td>5&quot;</td>
</tr>
<tr>
<td>800</td>
<td>6&quot;</td>
</tr>
<tr>
<td>1000</td>
<td>6&quot;</td>
</tr>
<tr>
<td>1200</td>
<td>7&quot;</td>
</tr>
<tr>
<td>1400</td>
<td>8&quot;</td>
</tr>
<tr>
<td>1600</td>
<td>8&quot;</td>
</tr>
</tbody>
</table>

Figure 30. Branch line sizing chart by total CFM (for use when multiple machines share line).

Determining Branch Line Duct Size

The general rule of thumb for a branch line duct is that the velocity of the airflow must not fall below 4000 FPM.

For small/medium sized shops, using the dust port size from the machine as the branch line duct size will achieve the correct velocity in most applications. However, if the dust port on the machine is smaller than 4", make the branch line 4" and reduce the line right before the dust port.

Note: Systems with powerful dust collectors work better if multiple blast gates are left open. This also allows you to run two machines at once. Experiment with different combinations of blast gates open/closed to find the best results for your system.

Write your determined branch line sizes on your drawing, as shown in Figure 29.
Calculating Duct Resistance

Adding duct work, elbows, branches and any other components to a duct line increases airflow resistance (static pressure loss). This resistance can be minimized by using rigid (smooth) pipe and gradual curves, as opposed to flexible pipe and 90° elbows.

To help you think about this resistance, imagine riding a bicycle in a tunnel that is an exact replica of your duct work. If the inside of the tunnel is very bumpy (flexible pipe) and has many sharp turns (90° elbows), it will take a lot more effort for you to travel from one end to the other than if your path is smooth and straight.

The purpose of calculating this resistance is to determine if it is low enough from the machine to the dust collector to meet the given requirement for the machine. Use the charts in Figure 32 to calculate the resistance of duct work.

<table>
<thead>
<tr>
<th>Duct Dia.</th>
<th>Approximate Static Pressure Loss Per Foot of Rigid Pipe</th>
<th>Approximate Static Pressure Loss Per Foot of Flex Pipe</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Main Lines at 3500 FPM</td>
<td>Branch Lines at 4000 FPM</td>
</tr>
<tr>
<td></td>
<td>Branch Lines at 4000 FPM</td>
<td>Main Lines at 3500 FPM</td>
</tr>
<tr>
<td>2&quot;</td>
<td>0.091</td>
<td>0.122</td>
</tr>
<tr>
<td>2.5&quot;</td>
<td>0.08</td>
<td>0.107</td>
</tr>
<tr>
<td>3&quot;</td>
<td>0.071</td>
<td>0.094</td>
</tr>
<tr>
<td>4&quot;</td>
<td>0.057</td>
<td>0.075</td>
</tr>
<tr>
<td>5&quot;</td>
<td>0.046</td>
<td>0.059</td>
</tr>
<tr>
<td>6&quot;</td>
<td>0.037</td>
<td>0.047</td>
</tr>
<tr>
<td>7&quot;</td>
<td>0.029</td>
<td>0.036</td>
</tr>
<tr>
<td>8&quot;</td>
<td>0.023</td>
<td>0.027</td>
</tr>
<tr>
<td>9&quot;</td>
<td>0.017</td>
<td>0.019</td>
</tr>
</tbody>
</table>

In most small/medium shops it is only necessary to calculate FPM for the line (from the dust collector to the machine) with the longest duct length or the most fittings (operating under the assumption that if the line with the highest resistance works, the others will be fine).

The line with the longest duct length and most fittings in our system sketch (see Figure 27) is the one connected to the router table, which draws 220 CFM.

To calculate the static pressure loss of any given line in the system, follow these steps:

1. Make a list of each size duct in the line, including the length, and multiply those numbers by the static pressure loss value given in Figure 31.

2. List each type of elbow or branch and multiply the quantity (if more than one) by the static pressure loss given in Figure 31.

3. Add the additional factors from Figure 32 to your list.

<table>
<thead>
<tr>
<th>Additional Factors</th>
<th>Static Pressure Loss</th>
</tr>
</thead>
<tbody>
<tr>
<td>Seasoned (well used)</td>
<td>1</td>
</tr>
<tr>
<td>Dust Collection Filter</td>
<td>1</td>
</tr>
<tr>
<td>Entry Loss at Large Machine Hood</td>
<td>2</td>
</tr>
</tbody>
</table>

Figure 32. Additional factors affecting static pressure loss.

Continued on next page
4. Total your list, as shown in the example in Figure 33, to come up with your overall static pressure loss number for that line.

**Note:** Always account for a seasoned filter, so you don't end up with a system that only works right when the filter is clean.

<table>
<thead>
<tr>
<th>Main Line</th>
<th>Branch Line</th>
<th>Elbows/Branches</th>
<th>Additional Factors</th>
</tr>
</thead>
<tbody>
<tr>
<td>6'' Rigid Pipe (0.037) at 20'</td>
<td>4'' Rigid Pipe (0.075) at 10'</td>
<td>6'' 45˚ Y-Branch</td>
<td>Seasoned Filter</td>
</tr>
<tr>
<td>.............................. 0.740</td>
<td>.............................. 0.750</td>
<td>.............................. 0.329</td>
<td>.............................. 1.000</td>
</tr>
<tr>
<td>4'' Flex Pipe (0.28) at 5'</td>
<td>4'' 45˚ Elbow</td>
<td>4'' 45˚ Elbow</td>
<td></td>
</tr>
<tr>
<td>.............................. 1.400</td>
<td>.............................. 0.225</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Total Static Pressure Loss** .............................. 4.444

![Figure 33](image)

**Figure 33.** Example list for totaling SP loss.

**Note:** When calculating static pressure loss to determine if multiple lines can be left open at the same time, only include the main line numbers once.

5. Compare the total static pressure loss for that line to the closest CFM given in the Performance Curve section on the Machine Data Sheet (located toward the front of this manual).

**Example:** go to the Model G0671 Data Sheet Performance Curve section (see Page 4) or see Figure 34 and find 4.4 on the Pressure axis, then go up the CFM axis to the closest value—approximately 3550 CFM, as shown in Figure 34.

The 3550 CFM (Figure 34) for the static pressure loss of the line connected to the router is well above the 220 CFM requirement of that machine.

![Performance Curve](image)

—If the CFM for your static pressure loss is above the requirement of the machine connected to the end of that branch line, then dust collection will most likely be successful. Congratulations! You've just designed your own dust system. Refer to the Accessories section on Page 36 to start buying the components necessary to make your system a reality.

—If the CFM for your static pressure loss is below the requirement of the machine, then that line will not effectively collect the dust. You must then modify some of the factors in that line to reduce the static pressure loss. Some of the ways to do this include: 1) Installing larger duct, 2) reducing amount of flexible duct used, 3) increasing machine dust port size, 4) moving machine closer to dust collector to eliminate duct length, and 5) reducing 90˚ elbows or replacing them with 45˚ elbows.
System Grounding

Since plastic hose is abundant, relatively inexpensive, easily assembled and air tight, it is a very popular material for conveying dust from woodworking machines to the dust collector. We recommend using flexible hose (flex-hose) to connect the woodworking machine to the dust collection system. However, plastic flex-hose and plastic duct are insulators, and dust particles moving against the walls of the plastic duct create static electrical build up. This charge will build until it discharges to a ground. If a grounding medium is not available to prevent static electrical build up, the electrical charge will arc to the nearest grounded source. This electrical discharge may cause an explosion and subsequent fire inside the system.

To protect against static electrical build up inside a non-conducting duct, a bare copper wire should be placed inside the duct along its length and grounded to the dust collector. You must also confirm that the dust collector is continuously grounded through the electrical circuit to the electric service panel.

If you connect the dust collector to more than one machine by way of a non-conducting branching duct system and blast gates, the system must still be grounded as mentioned above. We recommend inserting a continuous bare copper ground wire inside the entire duct system and attaching the wire to each grounded woodworking machine and dust collector.

Be sure that you extend the bare copper wire down all branches of the system. Do not forget to connect the wires to each other with wire nuts when two branches meet at a “Y” or “T” connection.

![Figure 35. Ground jumper wire when using plastic blast gates and metal duct.](image1)

![Figure 36. Flex-hose grounded to machine.](image2)

Ensure that the entire system is grounded. If using plastic blast gates to direct air flow, the grounding wire must be jumped (Figure 35) around the blast gate without interruption to the grounding system.

We also recommend wrapping the outside of all plastic ducts with bare copper wire to ground the outside of the system against static electrical build up. Wire connections at Y’s and T’s should be made with wire nuts.

Attach the bare ground wire to each stationary woodworking machine and attach to the dust collector frame with a ground screw, as shown in Figure 36. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.

![WARNING]

Always guard against static electrical build up by grounding all dust collection lines.
SECTION 5: OPERATIONS

Basic Controls

This section covers the basic controls used during routine operations:

ON Button: Starts the motor.

OFF Button: Stops the motor.

General

Operating your Model G0671/G0672/G0673 is simple and straightforward. Blast gates located at each of the woodworking machines control the airflow from the woodworking machine to the dust collector. If a machine is not being used, keep the blast gate closed to maintain higher levels of efficiency throughout the system.

CAUTION

DO NOT use the dust collector for any other purpose besides collecting dust from connected woodworking machines. A dust collector should NEVER be used as a shop vacuum. For safest use, wear a respirator and use an air cleaner in addition to the dust collector.
SECTION 6: 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.

H5293—4” Metal Duct Starter Kit
H5295—5” Metal Duct Starter Kit
H5297—6” Metal Duct Starter Kit
Save over 20% with this great starter kit. Includes: (2) machine adapters, (10) pipe clamps, (3) 5’ straight pipes, (1) branch, (3) pipe hangers, (1) end cap, (3) adjustable nipples, (1) 90˚ elbow, and (1) 60˚ elbow.

Figure 38. Metal Duct Starter Kit.

H5294—4” Metal Duct Machine Addition Kit
H5296—5” Metal Duct Machine Addition Kit
H5298—6” Metal Duct Machine Addition Kit
Save over 20% with this great machine addition kit. Includes: (2) blast gates, (1) machine adapter, (10) pipe clamps, (2) pipe hangers, (2) 5’ straight pipes, (2) adjustable nipples, (1) branch, and (1) 60˚ elbow.

Figure 39. Metal Duct Machine Addition Kit.

G0673036—Mag Switch 3-Phase 440V for Model G0673 Conversion

G6177—4” Metal Blast Gate
G7340—5” Metal Blast Gate
G7358—6” Metal Blast Gate
H5234—7” Metal Blast Gate
H5249—8” Metal Blast Gate
H5259—9” Metal Blast Gate

Figure 40. Metal Blast Gate.

order online at www.grizzly.com or call 1-800-523-4777
Metal Elbows
These industrial metal elbows are available from 4"–8" with 90°, 60°, 45°, or 30° curves. Also, available with a 90° long radius curve. Call (800) 523-4777 or visit www.grizzly.com for more information and pricing.

![Metal Elbows Diagram]

Figure 41. Metal elbow examples.

G6162—4" x 5' Straight Metal Pipe
G7346—5" x 5' Straight Metal Pipe
G7364—6" x 5' Straight Metal Pipe
H5227—7" x 5' Straight Metal Pipe
H5237—8" x 5' Straight Metal Pipe
H5252—9" x 5' Straight Metal Pipe
These laser welded straight pipes ensure a super smooth internal seam. Ends easily clamp together for a sealed fit without screws or silicone.

![Straight Metal Pipe Diagram]

Figure 42. Straight Metal Pipe.

Metal Branches
We carry many different branches, all designed to minimize airflow resistance.

![Metal Branches Diagram]

Figure 43. Metal Branches.

Reducers & Adapters
We carry a multitude of reducers and elbows to cover most applications from 4" through 9".

![Reducers & Adapters Diagram]

Figure 44. Metal Reducers & Adapters.

G7979—Phase Converter for Model G0673
Add 3-phase multi-motor capability to your single-phase electrical supply! Operate single or multiple motors, transformers, and resistance loads at 100% power and 95% efficiency while saving big dollars at cheaply-metered single-phase electrical rates.

H7216—5" x 5' Rigid Metal Flex Hose
H7217—6" x 5' Rigid Metal Flex Hose
H7218—7" x 5' Rigid Metal Flex Hose
H7219—8" x 5' Rigid Metal Flex Hose
H7220—9" x 5' Rigid Metal Flex Hose
This flex hose provides just enough flexibility to make difficult connections while still keeping the inside wall as smooth as possible to minimize static pressure loss.

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

Model G0671/G0672/G0673 (Mfd. Since 6/17)
Protect your hearing before it's too late. Especially important if you or employees operate for hours at a time.

**H4978—Deluxe Earmuffs - 27dB**

**H4979—Twin Cup Hearing Protector - 29dB**

**T20446—Ear Plugs 200 Pair - 31dB**

Protect your hearing before it's too late. Especially important if you or employees operate for hours at a time.

**Figure 45. Hearing protection assortment.**

---

**T10115—Benchtop Downdraft Table**

**G3119—4” x 2½” Adapter**

Want to stop making such a mess when sanding? This benchtop downdraft table is the perfect solution. Just connect the 2½” dust port in the back to a dust collector or Shop•Vac, and the suction will pull all dust and chips down into the table, keeping your work area tidy and clean.

**Figure 46. T10115 Benchtop Downdraft Table.**

---

**G0572—Hanging Air Filter With Remote**

This Hanging Air Filter has a convenient remote control and features a three speed motor, automatic shutoff timer and 1 micron inner filter and 5 micron outer filter. Air flow is 556, 702, and 1044 CFM.

**Figure 47. G0572 Hanging Air Filter.**

---

**T10117—Big Mouth Dust Hood with Stand**

Capture dust from any machine operation with this Big Mouth Dust Hood. Simply attach a 4” dust collection hose and adjust the hood right where you need it. The free standing base eliminates complicated machine set-ups and the tilting 16½” x 12½” hood adjusts from 23” to 43” high. Every shop needs one of these!

**Figure 48. T10117 Big Mouth Dust Hood.**

---

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

Model G0671/G0672/G0673 (Mfd. Since 6/17)
SECTION 7: MAINTENANCE

**WARNING**
Disconnect power to the machine when performing any maintenance, assembly or adjustments. Failure to do this may result in serious personal injury.

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

### Schedule

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

**Daily Check:**
- Dust collector is completely powered down at the end of use.
- Loose mounting bolts.
- Worn switch or wires.
- Any other condition that would hamper the safe operation of this machine.
- Empty the lower collection bags before they become completely full.

### Lubrication

Since all bearings are shielded and permanently lubricated, simply leave them alone until they need to be replaced. Do not lubricate them.

### Bag Cleaning

**CAUTION**
All dust collectors disperse fine dust which may cause allergic reactions or respiratory problems. Always wear a respirator when operating your dust collector.

Empty the lower collection bags on a regular basis to maintain dust collection efficiency.

Always wear the appropriate respirator or dust mask and safety glasses when emptying the collection bags. Small dust particles can escape the bags during emptying, causing them to become airborne and easily inhaled. This microscopic airborne dust is extremely unhealthy to breathe and can cause serious health problems.

While the Model G0671/G0672/G0673 excels at collecting the majority of wood dust produced by your machines, we always recommend the supplemental aid of a shop air filter. Air filters are designed to collect the smaller airborne dust particles that a dust collector bags cannot trap.
Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** Please gather the serial number and manufacture date of your machine before calling.

## Troubleshooting

### Motor & Electrical

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine does not start or a breaker trips.</td>
<td>1. Plug/receptacle is at fault or wired incorrectly. 2. Motor connection wired incorrectly. 3. Thermal overload relay has tripped. 4. Contactor not getting energized/has burnt contacts. 5. Power supply is at fault/switched OFF. 6. Motor ON button or ON/OFF switch is at fault. 7. Centrifugal switch is at fault. 8. Wiring is open/has high resistance. 9. Motor is at fault.</td>
<td>1. Test for good contacts; correct the wiring. 2. Correct motor wiring connections. 3. Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times (weak relay). 4. Test for power on all legs and contactor operation. Replace unit if faulty. 5. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 6. Replace faulty ON button or ON/OFF switch. 7. Adjust/replace the centrifugal switch if available. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Test/repair/replace.</td>
</tr>
<tr>
<td>Machine stalls or is underpowered.</td>
<td>1. Motor connection is wired incorrectly. 2. Plug/receptacle is at fault. 3. Motor bearings are at fault. 4. Motor has overheated. 5. Contactor not getting energized or has poor contacts. 6. Motor is at fault. 7. Centrifugal switch is at fault.</td>
<td>1. Correct motor wiring connections. 2. Test for good contacts; correct the wiring. 3. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 4. Clean off motor, let cool, and reduce workload. 5. Test for power on all legs and contactor operation. Replace if faulty. 6. Test/repair/replace. 7. Adjust/replace centrifugal switch if available.</td>
</tr>
<tr>
<td>Machine has vibration or noisy operation.</td>
<td>1. Motor or component is loose. 2. Motor fan is rubbing on fan cover. 3. Motor mount loose/broken. 4. Motor bearings are at fault. 5. Centrifugal switch.</td>
<td>1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Replace dented fan cover; replace loose/damaged fan. 3. Tighten/replace. 4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 5. Replace.</td>
</tr>
</tbody>
</table>
### Dust Collection Operation

<table>
<thead>
<tr>
<th>SYMPTOM</th>
<th>POSSIBLE CAUSE</th>
<th>CORRECTIVE ACTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>Loud, repetitious noise, or excessive vibration coming from dust collector.</td>
<td>1. Dust collector is not on a flat surface and wobbles.</td>
<td>1. Stabilize the dust collector.</td>
</tr>
<tr>
<td></td>
<td>2. Impeller fan is damaged and unbalanced.</td>
<td>2. Unplug dust collector, and inspect the impeller for dents, bends, loose fins. Replace impeller if any damage is found.</td>
</tr>
<tr>
<td></td>
<td>3. The motor mounting is loose.</td>
<td>3. Make sure all fasteners on the dust collector are tight.</td>
</tr>
<tr>
<td></td>
<td>4. Impeller is loose on the motor shaft.</td>
<td>4. Replace the motor and impeller as a set if the motor shaft and the impeller hub is damaged.</td>
</tr>
<tr>
<td></td>
<td>5. Motor fan cover is dented, causing the motor fan to hit the cover while spinning.</td>
<td>5. Replace motor fan cover.</td>
</tr>
<tr>
<td>Dust collector does not adequately collect dust or chips; poor performance.</td>
<td>1. Dust collection bag is full/filter bag is dirty.</td>
<td>1. Empty collection bag/clean or replace filter bag.</td>
</tr>
<tr>
<td></td>
<td>2. There is a restriction in the duct line.</td>
<td>2. Remove dust line from dust collector inlet and unblock the restriction in the duct line. A plumbing snake may be necessary.</td>
</tr>
<tr>
<td></td>
<td>3. The dust collector is too far away from the point of suction, or there are too many sharp bends in the ducting.</td>
<td>3. Relocate the dust collector closer to the point of suction, and rework ducting without sharp bends. Refer to Designing the System, beginning on Page 27.</td>
</tr>
<tr>
<td></td>
<td>4. The lumber is wet and not flowing through the dust lines smoothly.</td>
<td>4. Process lumber with less than 20% moisture content.</td>
</tr>
<tr>
<td></td>
<td>5. There is a leak in the ducting, or a series of small leaks, or too many open ports.</td>
<td>5. Rework the ducting to eliminate all leaks. Close dust ports for lines not being used. Refer to Designing the System on Page 27 for more solutions.</td>
</tr>
<tr>
<td></td>
<td>6. There are not enough open branch lines at one time, thereby causing a velocity drop in the main line.</td>
<td>6. Open 1 or 2 more blast gates to different branch lines to allow the velocity in the main line to increase.</td>
</tr>
<tr>
<td></td>
<td>7. The ducting and ports are incorrectly sized.</td>
<td>7. Reinstall correctly sized ducts and fittings. Refer to Designing the System on Page 27 for more solutions.</td>
</tr>
<tr>
<td></td>
<td>8. The machine dust collection design is inadequate.</td>
<td>8. Use a dust collection nozzle on a stand.</td>
</tr>
<tr>
<td></td>
<td>9. The dust collector is too small for the dust collection system.</td>
<td>9. Install a larger dust collector to power your dust collection system.</td>
</tr>
<tr>
<td>Sawdust being blown into the air from the dust collector.</td>
<td>1. Bag clamps, dust collection bag, or filter bag is not properly secured.</td>
<td>1. Reclamp the dust collection bag and air filter bag, making sure bag clamps are tight and completely over the bags.</td>
</tr>
</tbody>
</table>
SECTION 9: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

COLOR KEY

<table>
<thead>
<tr>
<th>BLACK</th>
<th>BLUE</th>
<th>GREEN</th>
<th>RED</th>
</tr>
</thead>
<tbody>
<tr>
<td>BK</td>
<td>B</td>
<td>GR</td>
<td>RO</td>
</tr>
<tr>
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<td>BROWN</td>
<td>GRAY</td>
<td>ORANGE</td>
</tr>
<tr>
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<td>R</td>
<td>GY</td>
<td>ORANGE</td>
</tr>
<tr>
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<td>Y1</td>
<td>PURPLE</td>
<td>PK</td>
</tr>
<tr>
<td>YELLOW</td>
<td>Y9</td>
<td>TURQUOISE</td>
<td>TQ</td>
</tr>
<tr>
<td>LIGHT BLUE</td>
<td>LB</td>
<td>WHITE</td>
<td>BW</td>
</tr>
</tbody>
</table>

Model G0671/G0672/G0673 (Mfd. Since 6/17)
Figure 49. G0671 MA-15 contactor.

Figure 50. G0671 motor junction box.

G0671 Wiring Diagram

MOTOR at 220V
SINGLE-PHASE

Locking Shut-Off Switch
(As Recommended)

READ ELECTRICAL SAFETY
ON PAGE 42!
Figure 51. G0672 MA-30 contactor.

Figure 52. G0672 start capacitor.

Figure 53. G0672 run capacitors.

MOTOR at 220V SINGLE-PHASE

Locking Shut-Off Switch (As Recommended)
G0673 Wiring Diagram

**MOTOR DIRECTION NOTICE**
If motor rotates in opposite direction, swap any two power source wires at the incoming terminals.

**WARNING!**
SHOCK HAZARD!
Disconnect power before working on wiring.

**3-PHASE 220 VAC**

3-PHASE 440 VAC
DISCONNECT SWITCH (as recommended)

**220V MAGNETIC SWITCH ASSEMBLY**

**440V MAGNETIC SWITCH ASSEMBLY**

See Figure 54 on Page 46.

See Figure 55 on Page 46.

Model G0671/G0672/G0673 (Mfd. Since 6/17)

STOP
READ ELECTRICAL SAFETY ON PAGE 42!
G0673 Electrical Components

**Figure 54.** G0673 220V switch.

**Figure 55.** G0673 220V motor.
SECTION 10: PARTS

G0671 Parts Breakdown

Model G0671/G0672/G0673 (Mfd. Since 6/17)
<table>
<thead>
<tr>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>P0671001</td>
<td>MOTOR 4HP, 220V, 1 PH</td>
<td>21</td>
<td>P0671021</td>
<td>RIGHT LEG</td>
</tr>
<tr>
<td>1-1</td>
<td>P0671001-1</td>
<td>FAN COVER</td>
<td>22</td>
<td>P0671022</td>
<td>LEFT LEG</td>
</tr>
<tr>
<td>1-2</td>
<td>P0671001-2</td>
<td>FAN</td>
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Label Placement

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.

**WARNING**

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WARRANTY CARD

Name ________________________________________________________________
Street ____________________________________________________________________________
City __________________________ State __________________________ Zip __________________
Phone # ____________________ Email _________________________________________________
Model # ____________________ Order # _______________________ Serial # __________________

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

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

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

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:________________________________________________________________________
   __________________________________________________________________________________
   __________________________________________________________________________________
   __________________________________________________________________________________
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.
Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!
~Since 1983~

Visit Our Website Today For Current Specials!

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