Grizzly Industrial, Inc.®

MODEL G0405
BEAR TRAP 1 HP UNDERMOUNT DUST COLLECTOR
OWNER'S MANUAL
(For models manufactured since 06/25)

#JACS23593 PRINTED IN TAIWAN V1.07.25

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

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

⚠WARNING

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

⚠CAUTION

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

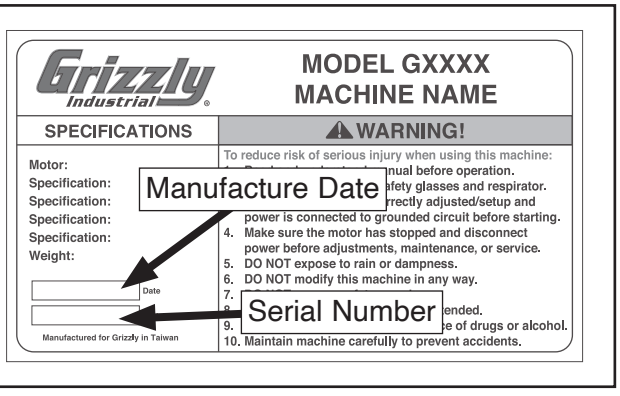
Manual Accuracy

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

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

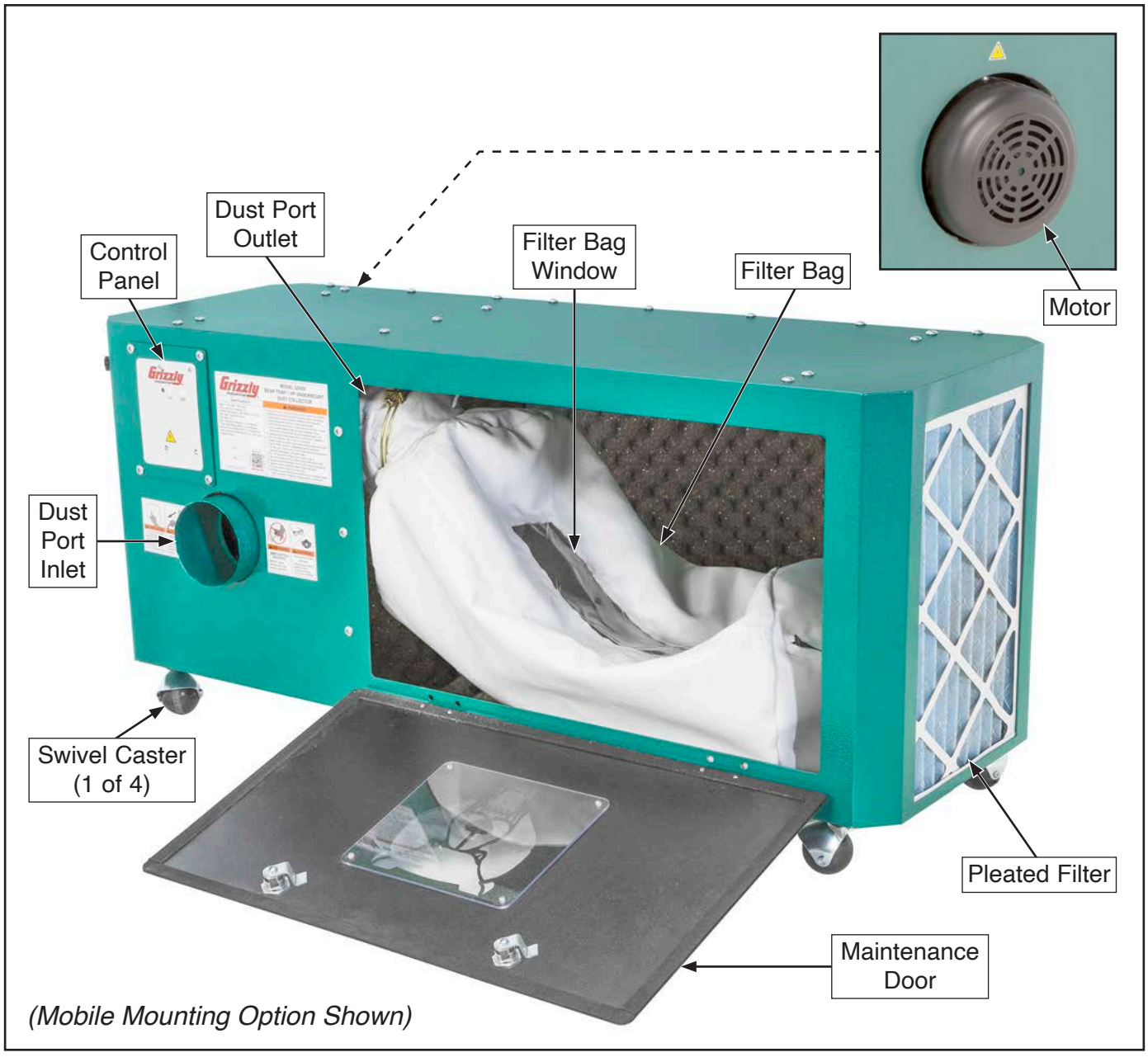
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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

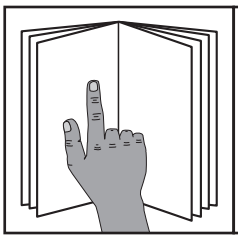


Identification

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



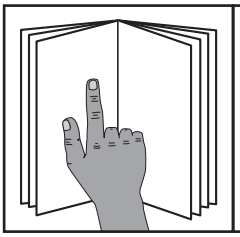
(Mobile Mounting Option Shown)



⚠WARNING

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

Controls & Components



⚠WARNING

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

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

Filter Components

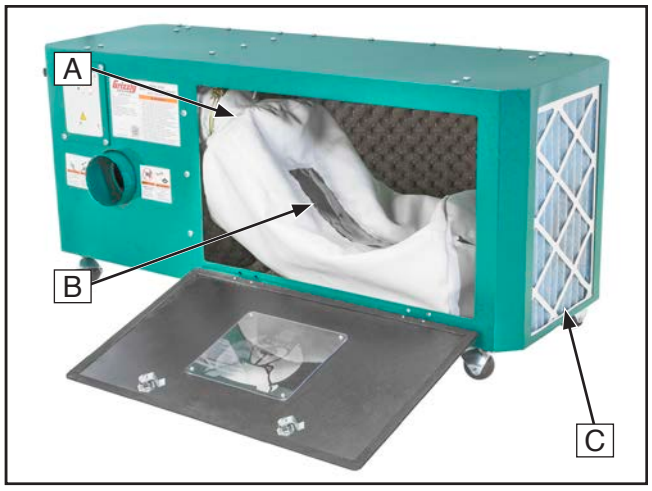


Figure 1. Filter components.

A. Filter Bag: Collects 11¼ gallons of wood dust and filters 96.67% of 30 micron particles.

B. Filter Bag Window: Allows operator to see when filter bag needs to be emptied.

C. Pleated Filter: Filters 65.8% of 5 micron particles.

Control Panel

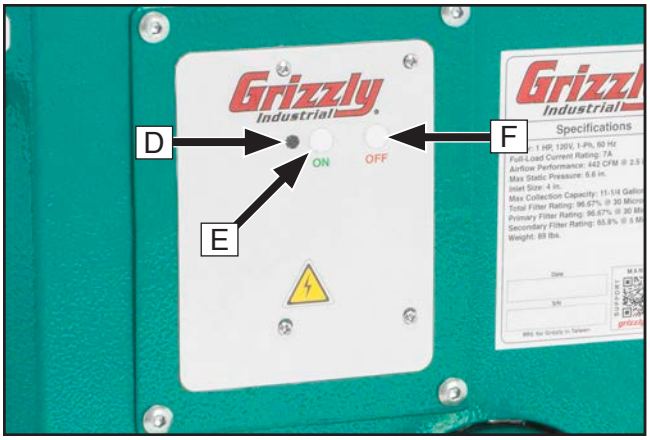


Figure 2. Control panel controls.

D. Power Indicator: Illuminates when machine is connected to power.

E. ON Button: Turns motor ***ON***.

F. OFF Button: Turns motor ***OFF***

Remote Control

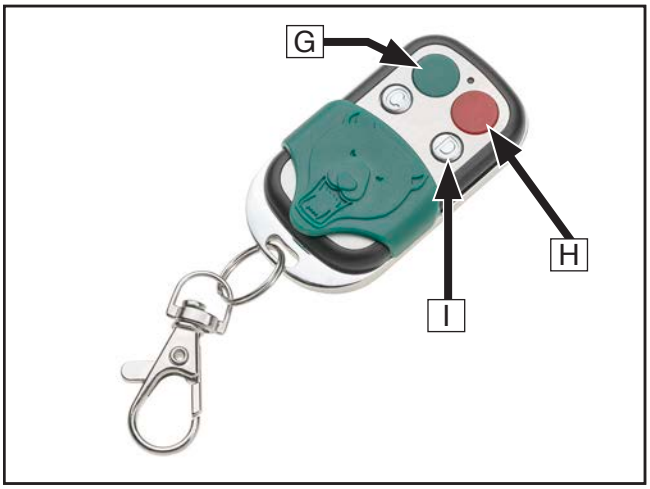


Figure 3. Remote control components.

G. ON Button: Turns motor ***ON.***

H. OFF Button: Turns motor ***OFF***.

I. D Button: Pairs remote with control panel when control panel is in pairing mode.

Note: *Remote control requires 12V, A27 battery.*

Note: *Remote control operates on radio frequency and has 75-ft. range. It does not need to be aimed at control panel to operate.*

MACHINE DATA SHEET

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

MODEL G0405
BEAR TRAP 1 HP UNDERMOUNT DUST COLLECTOR

Product Dimensions:

Weight..... 89 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 40-1/2 x 18-1/2 x 19 in.
Footprint (Length x Width)..... 40-1/2 x 13-1/2 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 93 lbs.
Length x Width x Height..... 43 x 19 x 19 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 7A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Control Panel w/Remote Control

Motors:

Main

Horsepower..... 1 HP
Phase..... Single-Phase
Amps..... 7A
Speed..... 3450 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer ..... Direct
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Operation

Dust Collector Type..... Single-Stage
Approved Dust Types..... Wood
Filter Type..... Bag/Pleated Panel
Airflow Performance..... 442 CFM @ 2.5 in. SP
Max Static Pressure (at 0 CFM)..... 6.6 in.
Main Inlet Size..... 4 in.
Machine Collection Capacity At One Time..... 1
Maximum Material Collection Capacity..... 11-1/4 Gallons

Filter Information

Number of Filters	2
Filtration Rating	96.67% @ 30 Micron
Number of Primary Filters	1
Primary Filter Type	Bag
Primary Filter Rating	96.67% @ 30 Microns
Primary Filter Length	24 in.
Primary Filter Width	13-1/2 in.
Number of Secondary Filters	1
Secondary Filter Type	Pleated Panel
Secondary Filter Rating	65.8% @ 5 Microns
Secondary Filter Length	382mm
Secondary Filter Width	225mm
Secondary Filter Thickness	22mm

Impeller Information

Impeller Type	Radial Fin
Impeller Size	10 in.
Impeller Blade Thickness	3/32 in.

Construction

Filter Bag	Fabric
Caster	Nylon
Impeller	Aluminum
Paint Type/Finish	Powder Coated
Blower Housing	Steel
Body	Steel

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Features:

Wireless Remote Control
Material Collection Capacity of 11-1/4 Gallons
Steel Brackets for Under Mounting or Wall Mounting
Nylon Casters for Portability

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for 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.

WEAR A RESPIRATOR. Fine dust that is too small to be caught in filter will be blown into ambient air. Always wear a NIOSH-approved respirator during operation and for a short time after to reduce your risk of permanent respiratory damage. Never collect dust from any hazardous material.

IMPELLER HAZARDS. To reduce risk of entanglement or contact with impeller, DO NOT place hands, hair, clothing, or tools in or near open dust collection inlet during operation, and keep small animals and children away. The powerful suction could easily pull them into impeller.

HAZARDOUS DUST. Dust exposure created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator.

EMPTYING DUST. When emptying bag or drum, wear respirator and safety glasses. Empty dust away from ignition sources and into approved container.

OPERATING LOCATION. To reduce respiratory exposure to fine dust, locate permanently installed dust collectors away from working area or in another room. DO NOT place dust collector where it can be exposed to rain or moisture, which creates a shock hazard and will reduce life of machine.

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 or drum 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.

Full-Load Current Rating at 120V ..... 7 Amps

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

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

⚠WARNING

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

120V Circuit Requirements

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

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

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

⚠CAUTION

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

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

Grounding & Plug Requirements

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

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

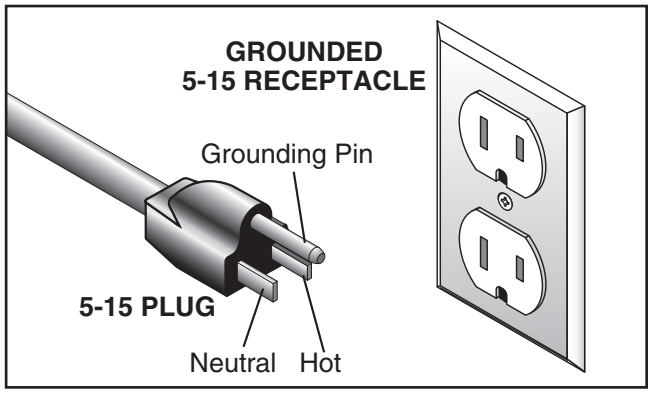
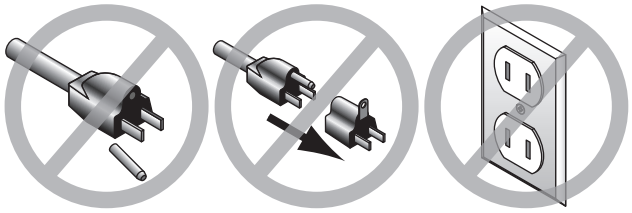


Figure 4. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

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

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

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

Extension Cords

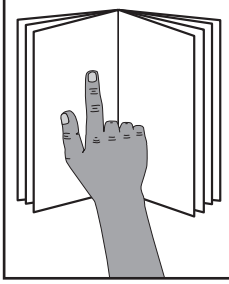
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

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

SECTION 3: SETUP

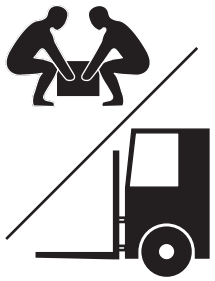


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠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.

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.*

Needed for Setup

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

For General Assembly

Description	Qty
• Safety Glasses (for each person)	1 Ea.
• Punch Tool 3mm	1
• Wrench 5.5, 7mm	1 Ea.
• Phillips Head Screwdriver #1	1
• Phillips Head Screwdriver #2	1
• Open-End Wrench 1"	1
• Box Cutter or Precision knife	1

For Mobile Mounting

Description	Qty
• Additional Person	1
• Hex Wrench 3/16"	1
• Open End Wrenches 1/2"	2

For Wall Mounting (Wood Framed Walls)

Description	Qty
• Additional Person	1
• Hex Wrench 3/16"	1
• Mounting Boards 2" x 8" x 48"	2
• Level	1
• Pencil	1
• Measuring Tape	1
• Lag Bolts 3/8" x 5" (Board/Wall)	16
• Flat Washers 3/8" (Board/Wall)	16
• Lag Bolts 5/16" x 2" (Machine/Board)	6
• Flat Washers 5/16" (Machine/Board)	6
• Drill	1
• Drill Bit 1/4" (For 3/8" Pre-Drill)	1
• Drill Bit 3/16" (For 5/16" Pre-Drill)	1
• Stud Finder	1
• Socket Wrench or Square/Socket Adapter	1
• Sockets 1/2", 9/16"	1 Ea.

For Wall Mounting (Concrete/Masonry Walls)

Description	Qty
• Additional Person	1
• Hex Wrench 3/16"	1
• Concrete Anchor Studs 5/16" x 2 3/4"	6
• Hex Nuts 5/16"	6
• Flat Washers 5/16"	6
• Hammer Drill	1
• Masonry Drill Bit 5/16"	1
• Masonry Drill Bit 3/16" (For 5/16" Pre-Drill)	1
• Level	1
• Pencil	1
• Measuring Tape	1
• Hammer	1
• Wrench or Socket 1/2"	1

For Undermounting (Workbench)

Items Needed	Qty
• Additional Person	1
• Hex Wrench 5/32"	1
• Level	1
• Pencil	1
• Measuring Tape	1
• Lag Bolts 5/16" x 2"	8*
• Flat Washers 5/16"	8
• Drill	1
• Drill Bit 3/16" (For 5/16" Pre-Drill)	1
• Socket Wrench or Square/Socket Adapter	1
• Socket 1/2"	1

**Lag bolt length is based on a standard 3–4" thick workbench. If your workbench is less than 3" thick, use shorter lag bolts.*

For Undermounting (Wood Joists)

Items Needed	Qty
• Additional Person	1
• Hex Wrench 5/32"	1
• Mounting Boards 2" x 4" x 48"	2
• Level	1
• Pencil	1
• Measuring Tape	1
• Lag Bolts 3/8" x 5" (Board/Ceiling)	12
• Flat Washers 3/8" (Board/Ceiling)	12
• Lag Bolts 5/16" x 2" (Machine/Board)	8
• Flat Washers 5/16" (Machine/Board)	8
• Drill	1
• Drill Bit 1/4" (For 3/8" Pre-Drill)	1
• Drill Bit 3/16" (For 5/16" Pre-Drill)	1
• Stud Finder	1
• Socket Wrench or Square/Socket Adapter	1
• Sockets 1/2", 9/16"	1 Ea.

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.

Fasteners (Figure 5) **Qty**

A. Flat Head Cap Screws ¼"-20 x ⅝" (P0405043) 8
B. Phillips Head Screws M3-.5 x 8 (P0405049) 8
C. Phillips Head Screws M4-.7 x 8 (P0405052) 4
D. Lock Nuts M3-.5 (P0405050) 8
E. Lock Nuts M4-.7 (P0405051) 4
F. Hex Nuts 5/16"-18 (P0405039) 4

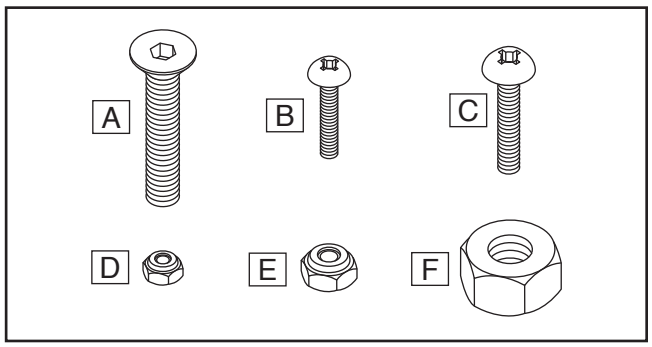


Figure 5. Fasteners (one of each shown).

Main (Figure 6) **Qty**

G. Machine Body (Not Shown) 1
H. Remote Control 1
I. 5" Bag Clamp 1
J. Filter Bag 1
K. Body Mounting Brackets 4
L. Wall Mounting Brackets 2
M. Undermounting Brackets 2
N. Maintenance Door 1
O. Acrylic Window 1
P. Lock Handle Assemblies 2
Q. Hinges 2
R. Left Foam Piece (335 x 337 x 25mm) 1
S. Top Foam Piece (335 x 615 x 25mm) 1
T. Rear Foam Piece (350 x 590 x 25mm) 1
U. Bottom Foam Piece (335 x 565 x 25mm) 1
V. Foam Tape 1
W. Casters 2" 4

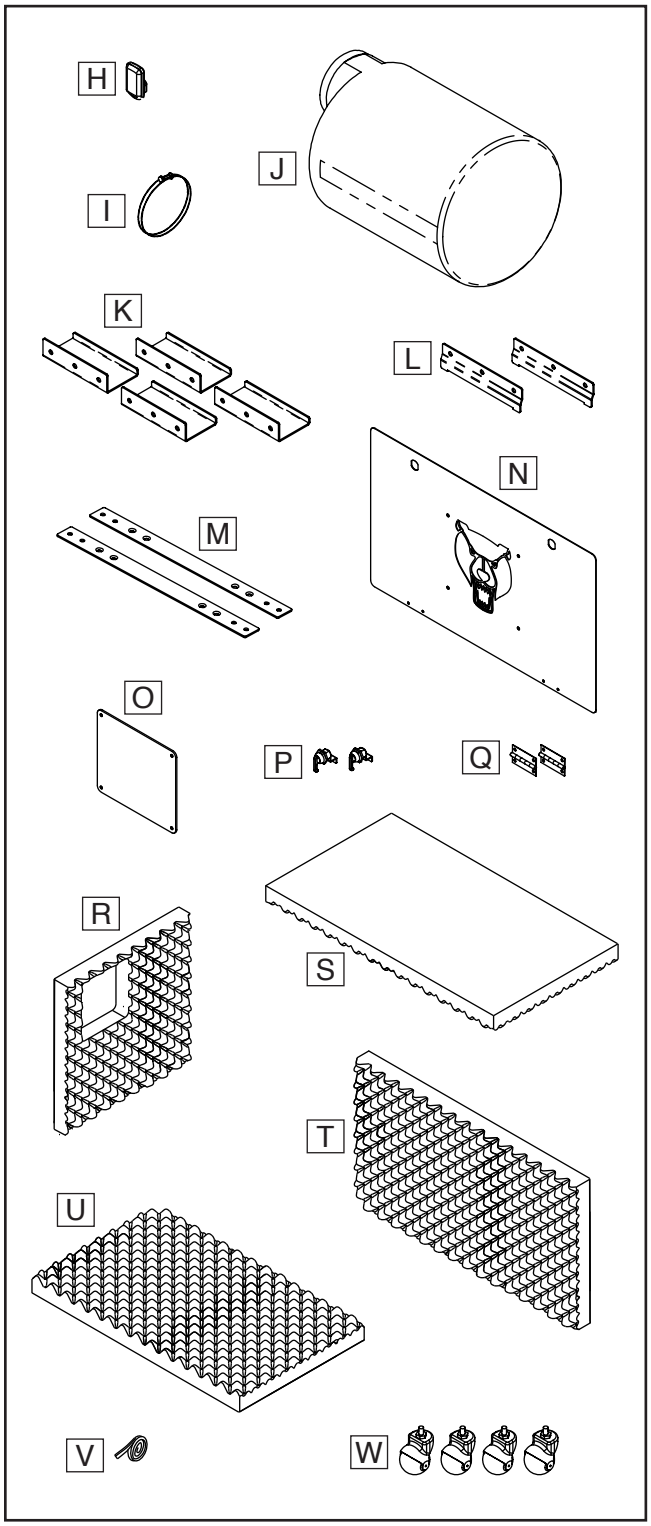


Figure 6. Main inventory.

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.

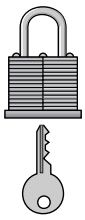
Site Considerations

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. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

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.

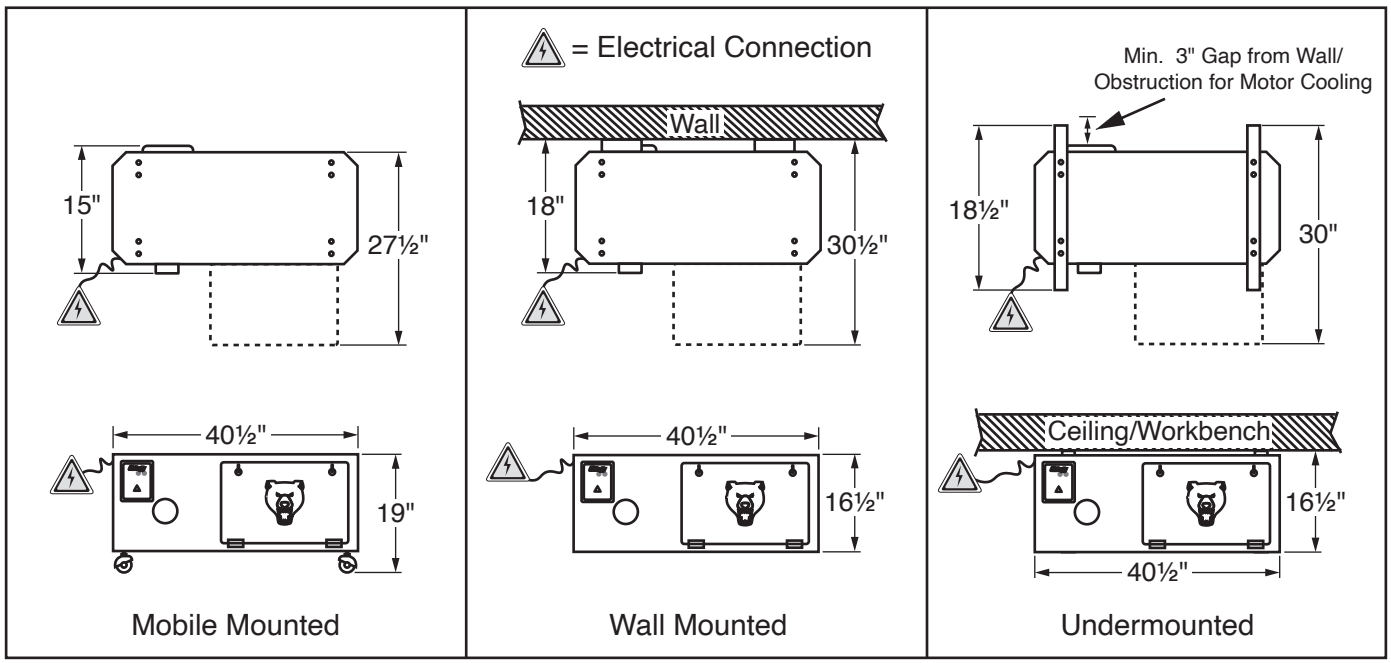


Figure 7. Minimum working clearances.

Assembly

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

The Model G0405 can be mounted three ways. Complete **General Assembly** before proceeding to the appropriate mounting section.

General Assembly

1. Attach acrylic window to maintenance door using (4) M4-.7 x 8 Phillips head screws and M4-.7 lock nuts, as shown in **Figure 8**.

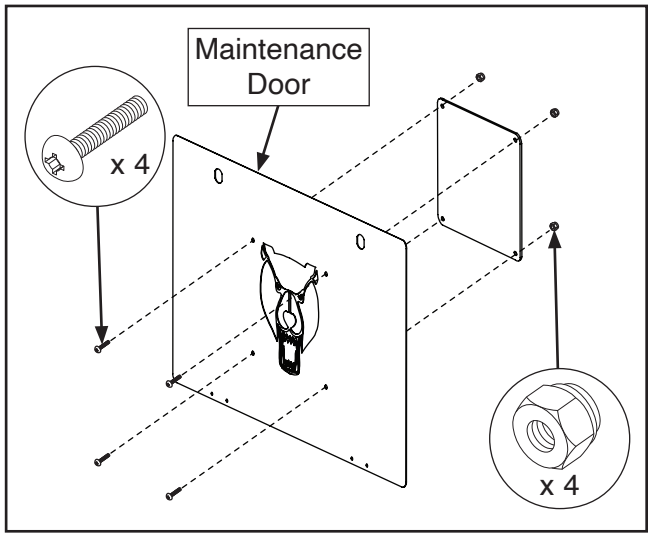


Figure 8. Attaching acrylic window to maintenance door.

2. Lay maintenance door face down on a flat protected surface, with acrylic window facing up.

3. Apply foam tape, aligning tape with edges of maintenance door (see **Figure 9**).

4. Use holes at bottom edge of maintenance door as a template to punch (4) 3mm holes in foam tape with 3mm punch tool (see **Figure 9**).

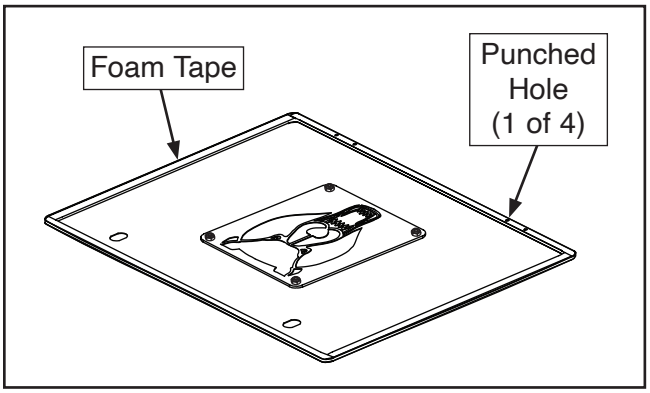


Figure 9. 3mm holes punched in foam tape.

5. Attach maintenance door to machine body with (2) hinges, (8) M3-.5 x 8 Phillips head screws, and (8) M3-.5 x 8 lock nuts (see **Figure 10**).

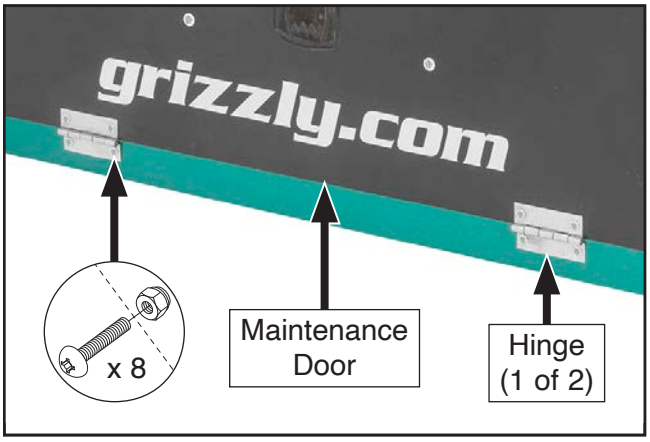


Figure 10. Maintenance door and hinges installed on machine body.

6. Disassemble (2) lock handle assemblies. Each contains (4) components: (1) lock handle, lock handle nut, latch plate, and M5-.8 x 5 truss head Phillips screw (see **Figure 11**).

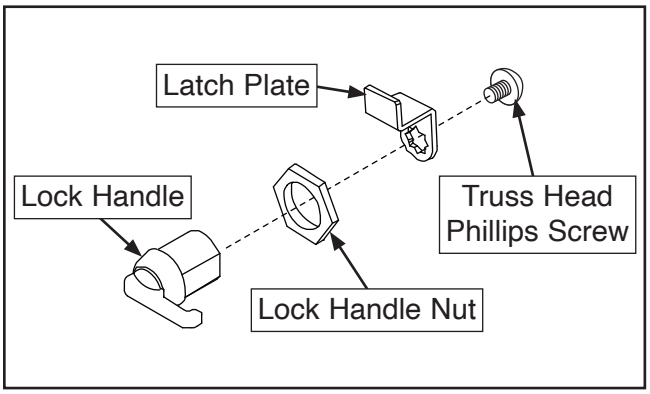


Figure 11. Lock handle assembly components.

7. Attach (2) lock handles to maintenance door with (2) lock handle nuts. Ensure lock handle is facing up toward the top of the machine when the maintenance door is closed (see **Figure 12**).

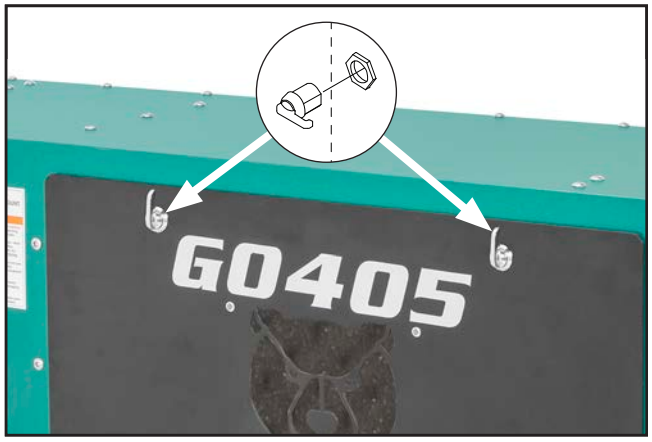


Figure 12. Lock handles facing up on maintenance door.

8. Fully tighten lock handle nuts, then attach latch plates to lock handles with M5-.8 x 5 truss head Phillips screws (see **Figure 13**).

   Note: *Latch plates should be installed facing same direction as lock handle.*

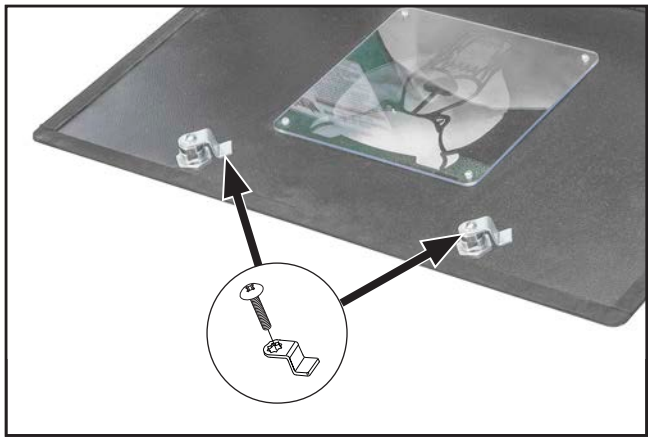


Figure 13. Latch plates attached to lock handles.

9. Once installed, rotate lock to latch maintenance door closed to verify correct lock knob installation.

10. Open maintenance door.

11. Apply left foam piece to left panel, aligning cutout in foam with dust port outlet in maintenance compartment, as shown in **Figure 14**.

    IMPORTANT: Test foam alignment for all foam pieces before removing backing for final placement.

12. Apply bottom foam piece to bottom panel inside maintenance compartment, as shown in **Figure 14**.

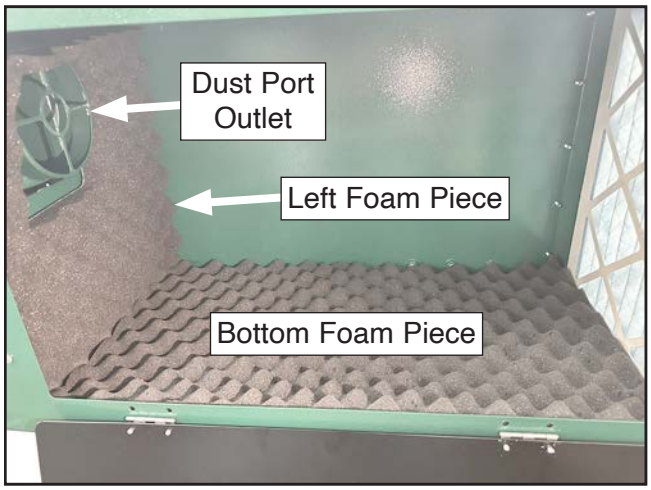


Figure 14. Left and bottom foam pieces applied to maintenance compartment panels.

13. Apply rear foam piece to rear panel inside maintenance compartment, as shown in **Figure 15**.

14. Apply top foam piece to top panel inside maintenance compartment, as shown in **Figure 15**.

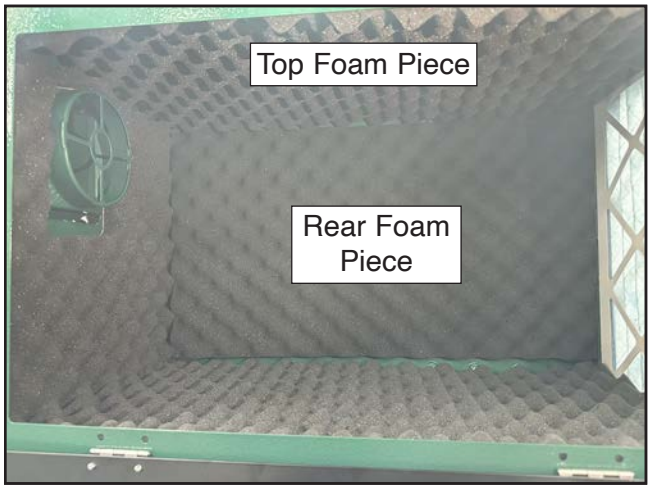


Figure 15. Rear and top foam pieces applied to maintenance compartment panels.

15. Secure filter bag to dust port outlet using 5" bag clamp (see **Figure 17**).

    Note: *When installing filter bag, rotate it so filter bag window is facing maintenance door.*

Figure 17. Filter bag secured to dust port outlet.

16. Close maintenance door.

17. General assembly is now complete.

    — If you are mounting on casters, proceed to **Mobile Mounting**.

    — If you are mounting to a wall, proceed to **Wall Mounting** on **Page 19**.

    — If you are mounting to a workbench or ceiling, proceed to **Undermounting** on **Page 21**.

Mobile Mounting

Use the following steps to attach the included casters to your machine for mobile use.

To mobile mount machine:

1. Tilt machine forward so you can access bottom of machine. Use spare pieces of wood to prevent damage to door latches and dust port inlet.

2. Remove (4) button head cap screws from bottom corners of machine. Set fasteners aside.

   IMPORTANT: If you choose to wall mount or undermount your machine in the future, these fasteners will be needed to create seal in maintenance and motor compartments.

3. Thread (4) 5/16"-18 hex nuts onto (4) 2" casters, then thread casters into machine base, as shown in **Figure 16**.

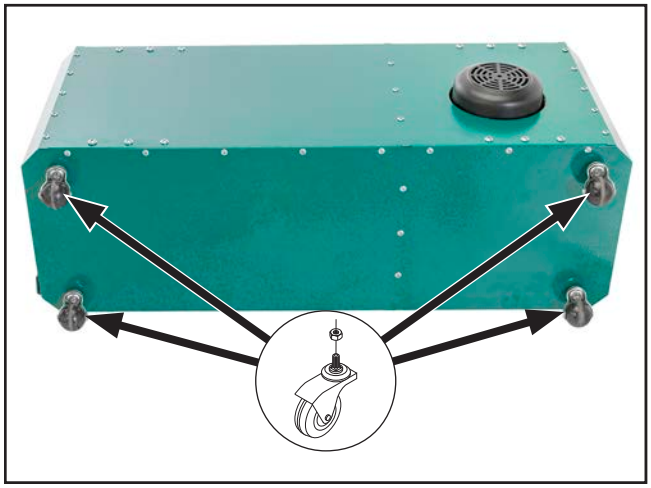


Figure 16. Example of casters installed on machine base.

4. Tilt machine onto casters, ensuring all casters contact ground evenly, then tighten hex nuts snug against base of machine.

5. Proceed to **Collection System** on **Page 24**.

Wall Mounting

⚠CAUTION

Make sure there are no open flames or pilot lights in same room as dust collector. There is a risk of explosion if too much fine dust is dispersed into air with open flame present.

Before mounting, consider the following:

- Do not place the machine where doors may pass closely or where the machine may impede the movement of any other object.
- Try to place the unit where it is easy to access for cleaning and maintenance.
- Make sure an electrical outlet with a properly grounded receptacle is available at the mounting location.

If you are mounting your dust collector to a wood framed wall, proceed to **Mounting to Wood-Framed Wall**.

If you are mounting your dust collector to a concrete or masonry wall, proceed to **Mounting to Concrete/Masonry** on **Page 20**.

Mounting to Wood-Framed Wall

1. Attach (4) body mounting brackets to machine body with (12) pre-installed button head cap screws, as shown in **Figure 18**.

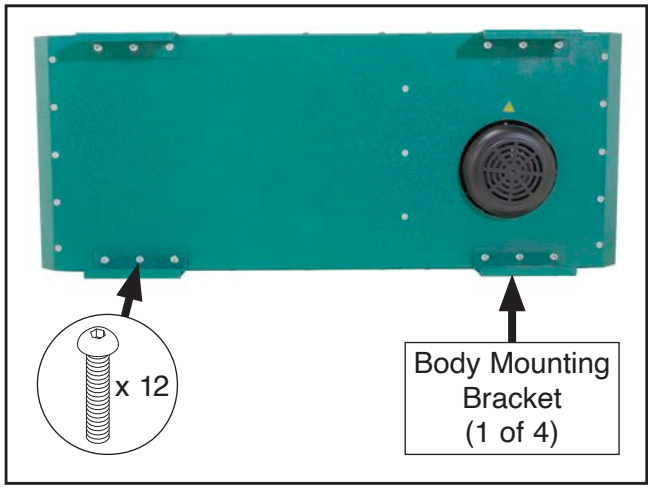


Figure 18. Body mounting brackets attached to machine body.

2. Attach (2) 2" x 8" mounting boards to wall studs using (16) ⅜" x 5" lag bolts and (16) ⅜" flat washers (see **Figure 19**).

   Note: *Mount machine high enough to ensure base does not touch ground.*

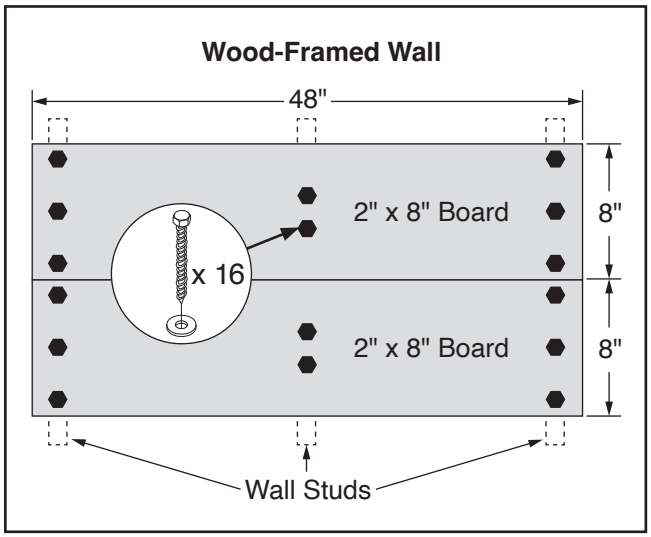


Figure 19. Wall mounting board layout.

3. Secure (2) wall mounting brackets to top mounting board 18" apart using (6) 5⁄16" x 2" lag bolts and (6) 5⁄16" flat washers. Ensure wall mounting brackets are aligned with top of mounting board (see **Figure 20**).

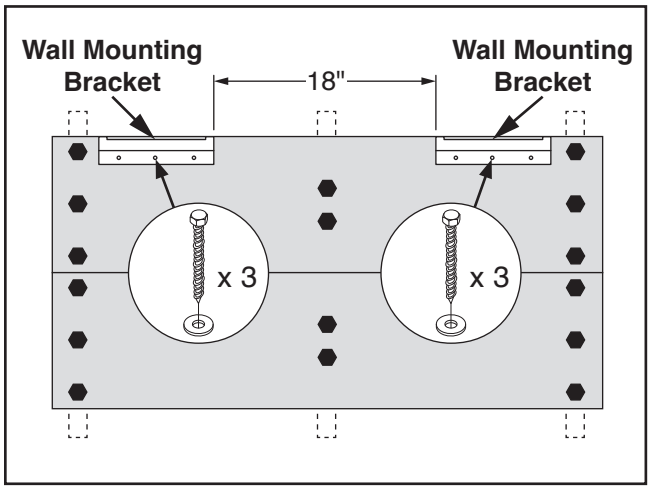


Figure 20. Wall mounting brackets secured to top of mounting board.

4. With help from an assistant, lift machine up, and insert lip of top body mounting brackets into wall mounting brackets.

   Note: *Bottom body mounting brackets are not fastened to mounting boards, they will rest against mounting board face.*

5. Proceed to **Collection System** on **Page 24**.

Mounting to Concrete/Masonry

1. Attach (4) body mounting brackets to machine body with (12) pre-installed button head cap screws, as shown in **Figure 21**.

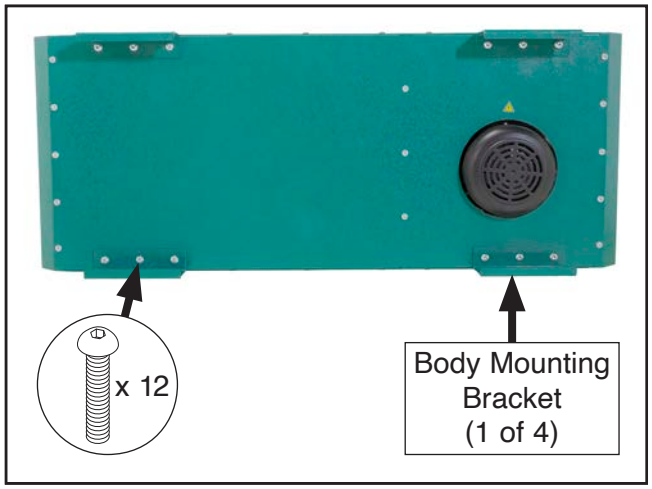


Figure 21. Body mounting brackets attached to machine body.

2. Place (2) wall mounting brackets against wall at intended mounting location, then use holes to mark (6) mounting locations. Brackets should be level, with 18" between them (see **Figure 22**).

   Note: *When marking locations, ensure machine will be mounted high enough to ensure base does not touch ground.*

3. Mount (6) 5/16" x 2 3/4" concrete anchor studs to wall at mounting locations (see **Figure 22**).

4. Secure wall mounting brackets to anchor studs with (6) 5/16" hex nuts, and (6) 5/16" flat washers (see **Figure 22**).

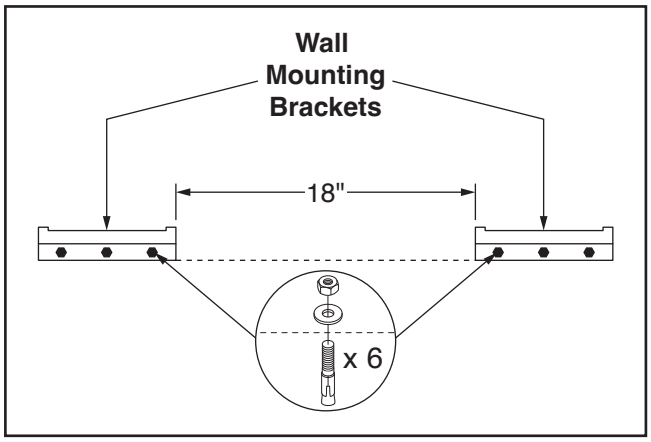


Figure 22. Wall mounting brackets mounted to concrete wall.

5. With help from an assistant, lift machine up, then insert lip of top body mounting brackets into wall mounting brackets.

   Note: *Bottom body mounting brackets are not fastened to wall, they will rest against wall face.*

6. Proceed to **Collection System** on **Page 24**.

Undermounting

⚠CAUTION

Only mount dust collector to joists or workbench that can hold at least 100 lbs. DO NOT mount machine only to sheet rock, press board, paneling, or honeycomb wall panels with expansion type fasteners. The fasteners can tear out and the machine can fall. Ignoring this caution can result in serious personal injury and property damage.

⚠CAUTION

Make sure there are no open flames or pilot lights in same room as dust collector. There is a risk of explosion if too much fine dust is dispersed into air with open flame present.

Before mounting, consider the following:

- In high traffic areas, mount machine with enough clearance so passers-by will not hit their heads.
- Do not place the machine where doors may pass closely or where the machine may impede the movement of any other object.
- Try to place the unit where it is easy to access for cleaning and maintenance.
- Make sure an electrical outlet with a properly grounded receptacle is available at the mounting location.

If you are mounting your dust collector to a workbench, proceed to **Mounting to Workbench**.

If you are mounting your dust collector to wood joists, proceed to **Mounting to Wood Joists on Page 22**.

To learn more about alternative undermounting options, such as mounting to concrete/masonry ceilings and steel joists, do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

Mounting to Workbench

1. Place (2) undermounting brackets against underside of workbench at intended mounting location, then use outer holes to mark (8) mounting locations. Brackets should have 28⅛" between their entire length, as shown in **Figure 23**.

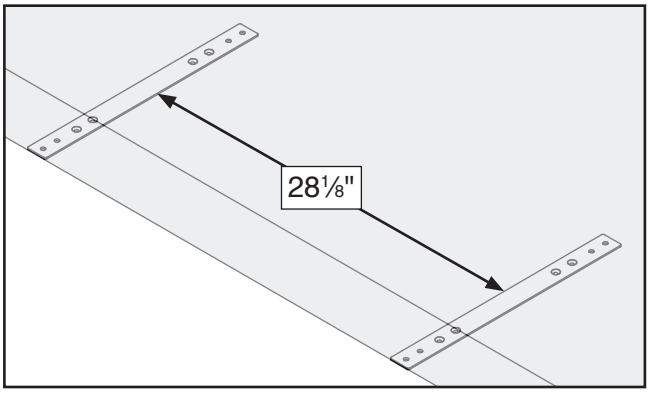


Figure 23. Undermounting brackets against underside of workbench (workbench greyed out for clarity).

2. Remove (8) pre-installed button head cap screws shown in **Figure 24** from machine body. Set fasteners aside.

   IMPORTANT: If you choose to mobile mount or wall mount your machine in the future, these fasteners will be needed to create seal in maintenance and motor compartments.

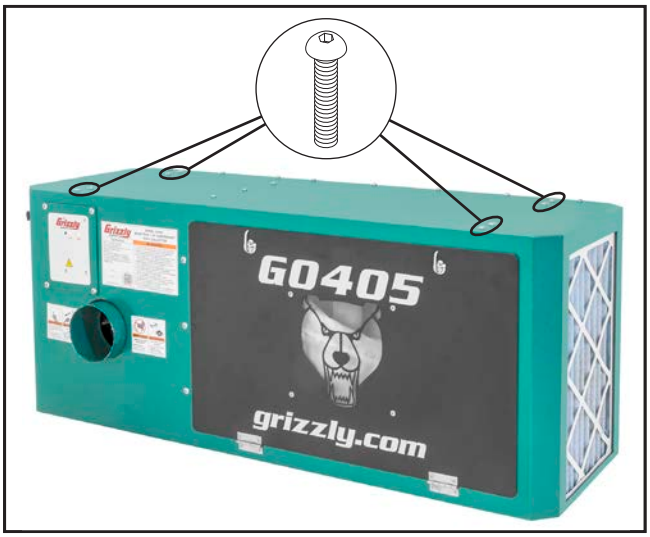


Figure 24. Location of screws to remove.

3. Attach (2) undermounting brackets to machine body with (8) 5/16"-18 x 5/8" flat head cap screws (see **Figure 27**).

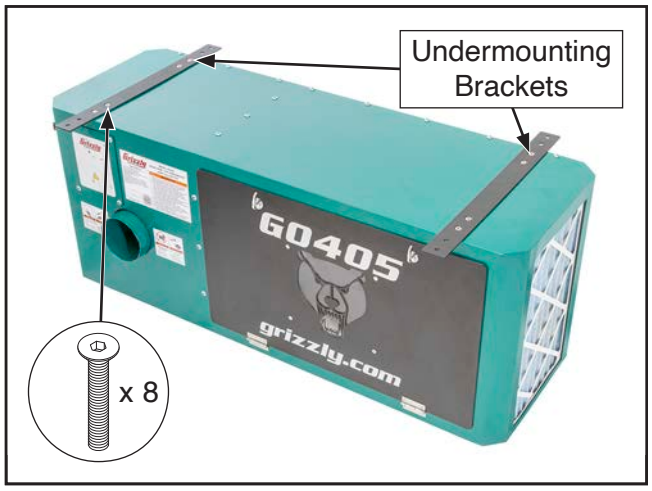


Figure 27. Undermounting brackets attached to machine body.

4. With help from an assistant, lift machine and secure to workbench with (8) 5/16" x 2" lag bolts and 5/16" flat washers, as shown in **Figure 25**.

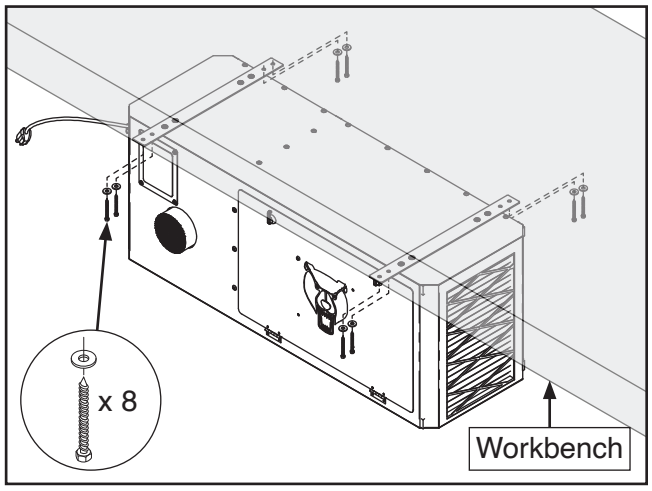


Figure 25. Securing machine to underside of workbench (workbench greyed out for clarity).

5. Proceed to **Collection System** on **Page 24**.

Mounting to Wood Joists

1. Attach (2) 2" x 4" mounting boards to ceiling joists 11 1/4" apart using (12) 3/8" x 5" lag bolts and (12) 3/8" flat washers (see **Figure 26**).

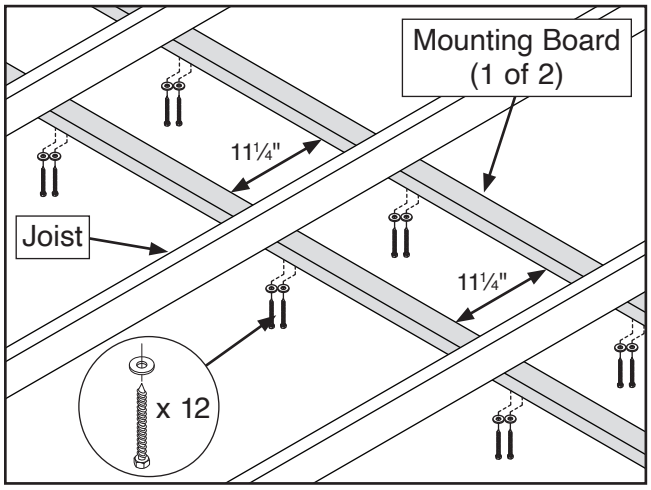


Figure 26. Attaching mounting boards to ceiling joists.

2. Place (2) undermounting brackets against underside of mounting boards at intended mounting location, then use outer holes to mark (8) mounting locations. Brackets should have 28 1/8" between their entire length, as shown in **Figure 28**.

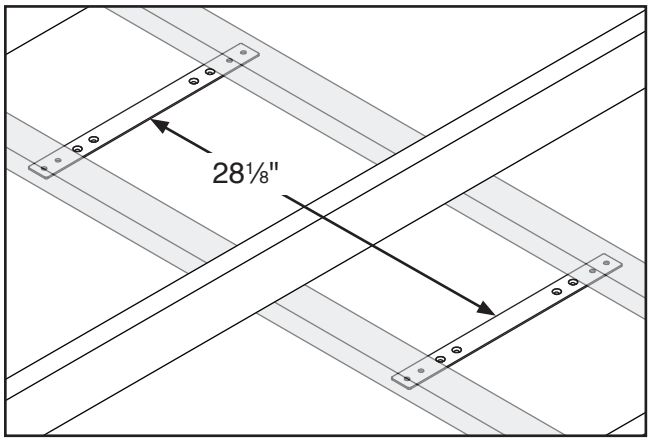


Figure 28. Undermounting brackets against mounting boards (mounting boards greyed out for clarity).

3. Remove (8) pre-installed button head cap screws shown in **Figure 29** from machine body. Set fasteners aside.

   IMPORTANT: If you choose to mobile mount or wall mount your machine in the future, these fasteners will be needed to create seal in maintenance and motor compartments.

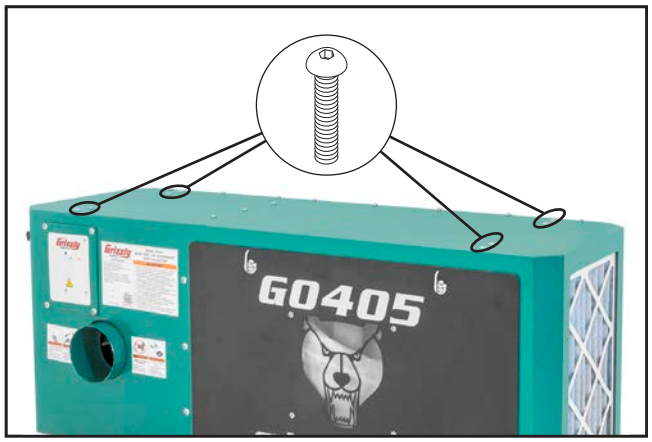


Figure 29. Location of screws to remove.

4. Attach (2) undermounting brackets to machine body with (8) 5/16"-18 x 5/8" flat head cap screws (see **Figure 30**).

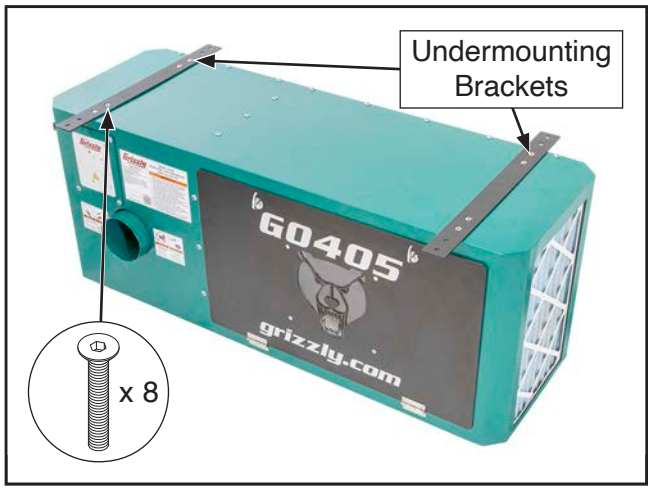


Figure 30. Undermounting brackets attached to machine body.

5. With help from an assistant, lift machine and secure to mounting boards with (8) 5/16" x 2" lag bolts and 5/16" flat washers, as shown in **Figure 31**.

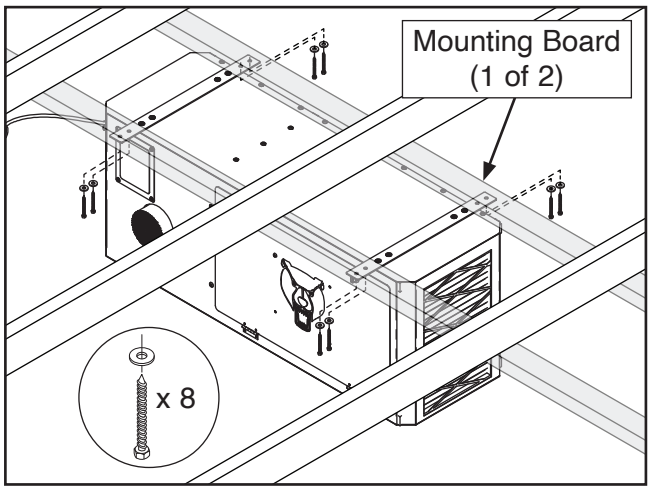


Figure 31. Securing machine to mounting boards (mounting boards greyed out for clarity).

6. Proceed to **Collection System** on **Page 24**.

Collection System

Material Selection

You have many choices regarding dust collection ducting, but flexible hose is the most common for this size of machine. 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.

Flexible rubber hose, polyethylene, plastic flex-hose and other flexible ribbed hose is generally used for short runs. 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.

If using flex-hose, you should choose one of the many types that are 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 and steel flex hose.

⚠WARNING

Always guard against static electrical build up by grounding all dust collection lines.

Duct Grounding

Plastic flex-hose is an insulator, and dust particles moving against the walls of the hose creates a 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.

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.

Ensure that the entire system is grounded. If using plastic blast gates to direct air flow, the grounding wire must be jumped (**Figure 32**) around the blast gate without interruption to the grounding system.

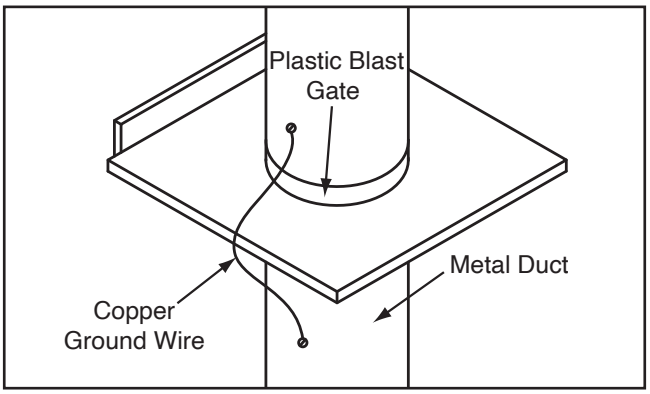


Figure 32. Ground jumper wire when using plastic blast gates or elbows and metal duct.

We also recommend wrapping the outside of all plastic ducts with bare copper wire to ground the outside of the system against static electrical buildup. 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 the figure below. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.

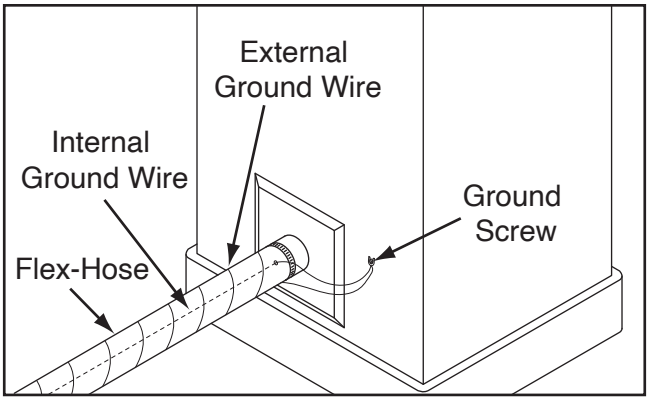


Figure 33. Flex-hose grounded to machine.

Dust Collection

Since each machine produces a different amount of sawdust, the requirements for the minimum amount of CFM 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 to gauging which size of duct to use.

Refer to the figure below for a close estimation of the airflow each machine requires. Keep in mind that machines that generate the most sawdust should be placed closest to the dust collector. If the machine has multiple dust ports, the total CFM required is the sum of all ports.

Machine Dust Port Size	Approximate Required CFM
2"	98
2.5"	150
3"	220
4"	395

Figure 34. Approximate required airflow for machines, based on dust port size.

If the machine does not have a built-in dust port, use the following table to determine which size of dust port to install.

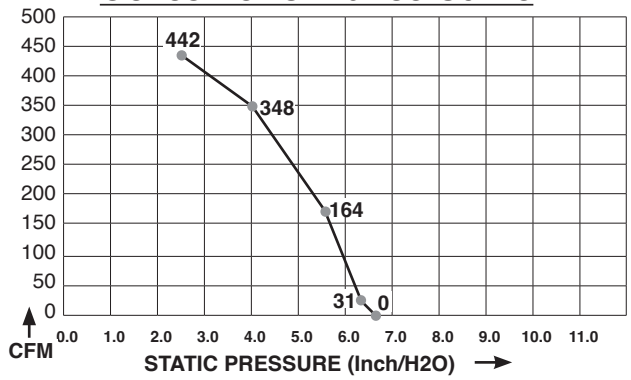
Machine	Average Dust Port Size
Table Saw, Shaper, Bandsaw, or Lathe	4"
Router (mounted to table)	2"
Miter/Radial-Arm Saw	2"
Jointer (6" and smaller)	4"
Jointer (8"-12")	5"
Thickness Planer (13" and smaller)	4"
Thickness Planer (14"-20")	6"
Disc Sander (12" and smaller)	2"
Disc Sander (13-18")	4"
Belt Sander (6" and smaller)	2"
Belt Sander (7"-9")	3"
Edge Sander (6" x 80" and smaller)	4"
Edge Sander (6" x 80" and larger)	5"
Drum Sander (24" and smaller)	2 x 4"
Drum Sander (24" and larger)	4 x 4"
Widebelt Sander (18" and smaller)	5"
Widebelt Sander (24"–37" single head)	2 x 6"
Widebelt Sander (24"–51" double head)	5 x 4"

Figure 1. Typical ducting sizes and port sizes for various machines.

Tips for Optimum Performance

- Avoid using more than 10' of flexible hose on any ducting line. The ridges inside flexible hose greatly increase static pressure loss, which reduces suction performance.
- Keep ducts between the dust collector and machines as short as possible.
- Keep ducting directional changes to a minimum. The more curved fittings you use, the greater the loss of suction at the dust-producing machine.
- Gradual directional changes are more efficient than sudden directional changes (i.e. use 45° elbows in place of 90° elbows whenever possible).
- The simpler the system, the more efficient and less costly it will be.

Dust Collector Performance



1 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	Max SP	HP	Volts	Inlet	Impeller
442	6.6	1 HP	120V	4"	10"

Restrictor Plate (Inch)	4"	3"	2"	1"	0"
Static Pressure (Inch/H2O)	2.5	4.1	5.6	6.3	6.6
CFM	442	348	164	31	0

The airflow test probe is located 1.5x duct diameter upstream from the air inlet. Test pipe length is a minimum of 10x duct diameter.

Figure 35. G0405 performance curve table and data.

Test Run

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

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

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the remote control works correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Clear all setup tools away from machine.

2. Connect machine to dust-collection system or place covers over inlet adapter ports.

   IMPORTANT: DO NOT operate dust collector without first connecting it to a dust-collection system or covering an inlet adapter port. Otherwise, lack of airflow resistance will cause motor to operate at full amperage load, which could trip your circuit breaker or blow a fuse.

3. Connect machine to power.

4. Press ON button (see **Figure 36**) to turn machine ***ON***. Verify motor starts up and runs smoothly without any problems or unusual noises.

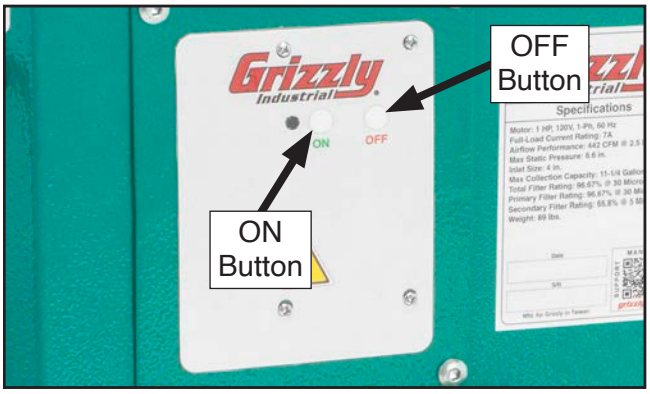


Figure 36. Location of ON and OFF buttons.

5. Press OFF button to turn machine ***OFF***.

6. Press green remote button (see **Figure 37**) to turn machine ***ON***. Verify motor starts up and runs smoothly without any problems or unusual noises.

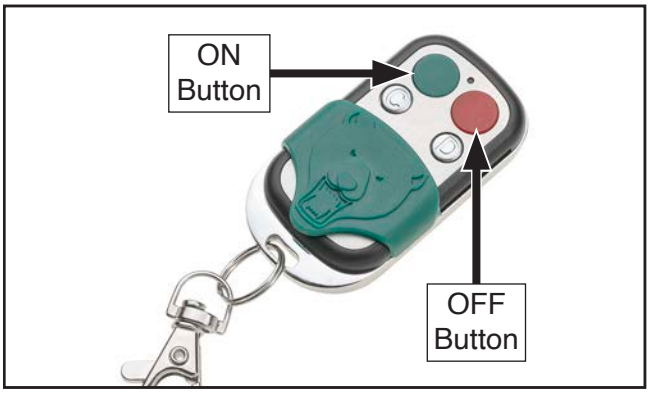


Figure 37. Location of remote control buttons.

7. Press red remote button to turn machine ***OFF***.

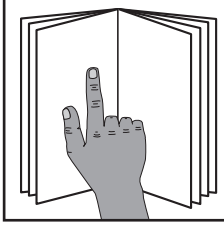
   — If machine *does not* turn ***OFF*** with remote control, press OFF button on control box to turn machine ***OFF***. Refer to **Troubleshooting** on **Page 32** of manual to correct any problems with remote control unit before further using it with machine.

SECTION 4: OPERATIONS

Operation Overview

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

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

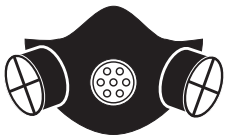


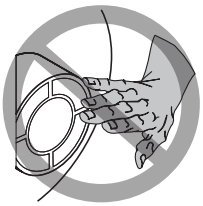
⚠WARNING

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

⚠WARNING

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





⚠WARNING

DO NOT put hands or small objects near inlet opening during operation. Objects sucked into inlet will meet with impeller blade. Failure to heed this warning could result in personal injury or property damage.

⚠WARNING

Never place dust collector in room with open flames or pilot lights. There is a risk of explosion if too much fine dust is dispersed into air with open flame present.

General Operation

This dust collector pulls wood dust past the impeller and into the filter bag.

The fabric bag filters 96.67% of all particles 30-microns in size, and the pleated secondary filter filters 65.8% of all particles 5 microns in size.

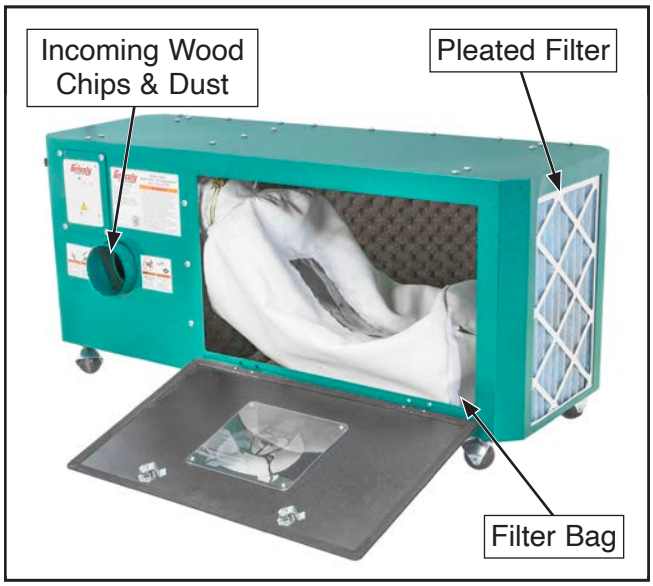


Figure 38. Dust collector operation (shown mounted on casters).

To maintain CFM during heavy dust collection operations, regularly check fill level of filter bag and empty as necessary.

Pairing Remote Control

The Model G0405 is equipped with a remote control receiver unit that can be programmed to operate from (5) separate controllers.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Small Wooden Dowel	1

⚠WARNING

Avoid touching electrified parts inside control panel enclosure while performing the following procedure! Touching electrified parts will result in serious personal injury such as severe burns, electrocution, or death. Use a wood dowel or other non-conducting item to push button on receiver.

To pair remote control:

1. Remove control panel.

2. Press and hold CODE SAVE button (see **Figure 39**) on circuit board with wooden dowel until it beeps once.

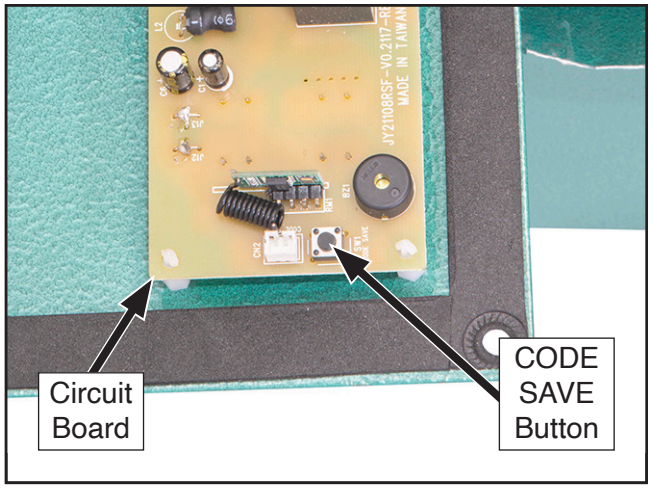


Figure 39. Location of circuit board and CODE SAVE button.

3. Press and hold D button (see **Figure 40**) on remote control until it beeps twice. Pairing is now complete.

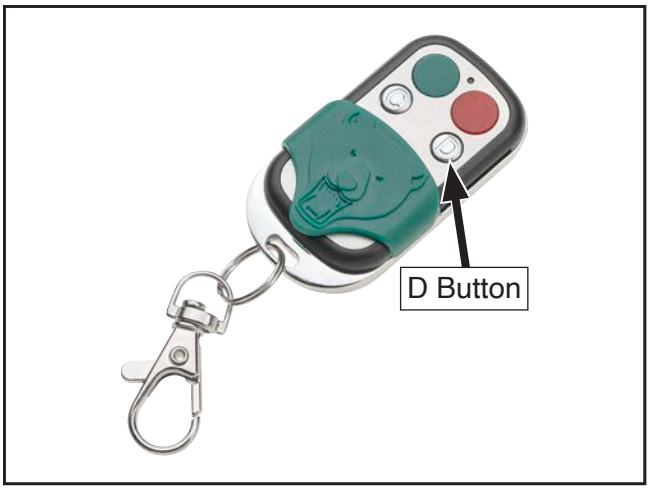


Figure 40. Location of D button on remote control.

4. Install control panel.

Replacing Remote Control Battery

The remote control is powered by a 12V type A27 battery. If the receiver stops responding to the remote control, replace the battery as the first course of action.

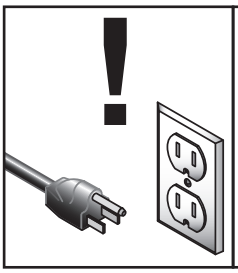
Items Needed	Qty
Phillips Head Screwdriver #00	1
A27 12V Battery	1

To replace remote control battery:

1. Turn remote control face down, remove (3) Phillips head screws, then remove battery cover.

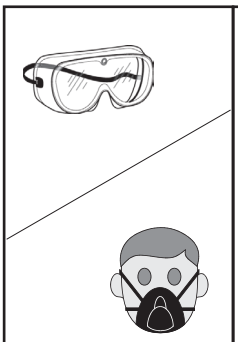
2. Replace battery, then re-assemble remote control.

SECTION 5: MAINTENANCE



⚠WARNING

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



⚠CAUTION

Dust exposure created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Always wear goggles and NIOSH-approved respirator when working with filters.

Schedule

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

Ongoing

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

- Loose mounting bolts.
- Damaged filter bag or pleated filter.
- Worn or damaged wires.
- Suction leaks.
- Any other unsafe condition.

Daily

- Check filter bag fill level and empty as needed.
- Check/clean pleated filter.

Monthly

- Clean/vacuum dust buildup off machine body and motor.

Emptying/Replacing Filter Bag

Empty the filter bag when it is about ½ full. Emptying the filter bag allows the machine to operate at a much higher level of efficiency. Always wear goggles and a respirator when handling the filter bag.

With normal wear and use, the filter bag will eventually need to be replaced. There is no specific determination for replacement intervals, but bags generally last between 1 and 3 years, depending on use.

Replace filter bag when:

- There is a lack of airflow and reduced collection performance and cleaning does not improve performance.
- Holes form in filter bag.
- Filter bag is accidentally washed.
- Filter bag is contaminated with bacteria or mold.

Items Needed **Qty**
Phillips Head Screwdriver #2 1
Filter Bag (P0405008) ..... As Needed

To empty/replace filter bag:

1. DISCONNECT MACHINE FROM POWER!

2. Open maintenance door, loosen 5" bag clamp, then remove filter bag and bag clamp from dust port outlet (see **Figure 41**).

Figure 41. Filter bag removal components.

3. Inspect filter bag.

— If filter bag is worn or damaged, replace it, then proceed to **Step 5**.

4. Unzip filter bag over suitable disposal container located away from open flames or pilot lights, gently shake filter bag to empty contents, then zip filter bag shut.

5. Secure filter bag to dust port outlet using 5" bag clamp removed in **Step 2**.

Note: *When installing filter bag, rotate it so filter bag window is facing maintenance door.*

6. Close maintenance door.

Cleaning/Replacing Pleated Filter

The volume of air filtered has a direct correlation to when you must clean or replace the filters. To maintain efficient operation, check the filters approximately every 40 hours of use in light or moderately dusty environments. In very dusty environments, check the filters every eight hours of use. Always wear goggles and a respirator when checking the filters.

Items Needed	**Qty**
Vacuum w/HEPA Filter	1
Pleated Filter (P0405009)	1

NOTICE

DO NOT use compressed air to blow out pleated filter. This can cause damage to filter.

To clean/replace pleated filter:

1. DISCONNECT MACHINE FROM POWER!
2. Open maintenance door.
3. Carefully lift and push on bottom of pleated filter to dislodge it from machine.
4. Gently vacuum pleated filter to remove dust buildup.
5. Visually inspect pleated filter for damage to see if it need to be replaced

   Note: *During regular use, filters can be cleaned several times before replacement becomes necessary.*
6. Install or replace filter by aligning top edge of filter with inside edge of right side of machine, then lift up and gently push on backside of pleated filter to seat it in filter groove (see **Figure 42**).

   IMPORTANT: Ensure airflow direction on filter is facing the correct direction (see **Figure 42**).

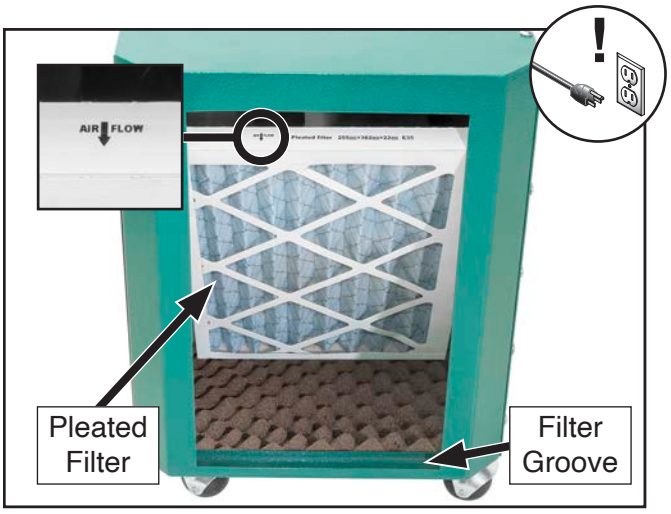
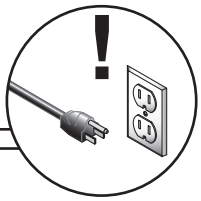


Figure 42. Location of pleated filter components.

SECTION 6: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Incorrect power supply voltage or circuit size. 2. Hand-held controller not working. 3. Power supply circuit breaker tripped or fuse blown. 4. Motor wires connected incorrectly. 5. Centrifugal switch needs adjustment/contact points dirty. 6. Wiring broken, disconnected, or corroded. 7. Motor or motor bearings at fault.	1. Ensure correct power supply voltage and circuit size. 2. Replace batteries (**Page 28**); stay in signal range. 3. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 4. Correct motor wiring connections. 5. Adjust centrifugal switch/clean contact points. 6. Fix broken wires or disconnected/corroded connections (**Page 34**). 7. Replace motor.
Machine stalls or is underpowered.	1. Motor wires connected incorrectly. 2. Motor overheated. 3. Extension cord too long. 4. Centrifugal switch needs adjustment/contact points dirty. 5. Motor or motor bearings at fault.	1. Correct motor wiring connections (**Page 34**). 2. Clean motor, let cool, and reduce workload. 3. Move machine closer to power supply; use shorter extension cord. 4. Adjust centrifugal switch/clean contact points. 5. Replace motor.
Machine has vibration or noisy operation.	1. Motor or component loose. 2. Motor fan rubbing on fan cover. 3. Centrifugal switch needs adjustment. 4. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Fix/replace fan cover; replace loose/damaged fan. 3. Adjust switch. 4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operations

Symptom	Possible Cause	Possible Solution
Loud, repetitious noise, or excessive vibration coming from dust collector (non-motor related).	1. Machine incorrectly mounted/sits unevenly. 2. Impeller damaged and unbalanced. 3. Impeller loose on motor shaft.	1. Chock casters if mobile, or tighten/replace mounting hardware. 2. Disconnect dust collector from power; inspect impeller for cracks or damage; replace impeller if damaged. 3. Secure impeller; replace motor and impeller as a set if motor shaft and impeller hub are damaged.

Operations

Symptom	Possible Cause	Possible Solution
Dust collector does not adequately collect dust or chips; poor performance.	1. Dust filter bag full or worn. 2. Pleated filter clogged/at fault. 3. Ducting blocked/restricted. 4. Dust collector too far away from point of suction; duct clamps not properly secured; too many sharp bends in ducting. 5. Wood wet/green and dust not flowing smoothly through ducting. 6. Ducting has one or more leaks, or too many open ports. 7. Ducting and ports are incorrectly sized. 8. Machine dust collection design inadequate. 9. Dust collector undersized. 10. Unused inlet adapter port(s) uncovered.	1. Empty or replace filter bag (**Page 30**). 2. Clean/replace filter (**Page 31**). 3. Remove ducting from dust collector inlet and unblock restriction. A plumbing snake may be necessary. 4. Relocate dust collector closer to point of suction; secure ducts; remove sharp bends. Refer to **Collection System** (**Page 24**). 5. Only collect dust from wood with less than 20% moisture content. 6. Seal/eliminate all ducting leaks; close dust ports for lines not being used. 7. Install correctly sized ducts and fittings. Refer to **Collection System** (**Page 24**). 8. Use dust collection hood on stand. 9. Upgrade to larger dust collector. 10. Cover unused inlet adapter port(s).
Emptying filter bag does not improve dust collection performance.	1. Filter bag clogged and at end of life.	1. Replace filter bag (**Page 30**).
Cleaning pleated filter does not improve dust collection performance.	1. Pleated filter at end of life.	1. Replace filter (**Page 31**).
Dust collector blows sawdust into the air.	1. Duct clamp(s) or dust filter bag(s) not properly clamped and secured; ducting loose/damaged. 2. Filter bag has hole(s).	1. Secure ducts and dust filter bag, making sure duct/bag clamp(s) are tight; tighten/replace ducting. 2. Replace filter bag (**Page 30**).

SECTION 7: 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.

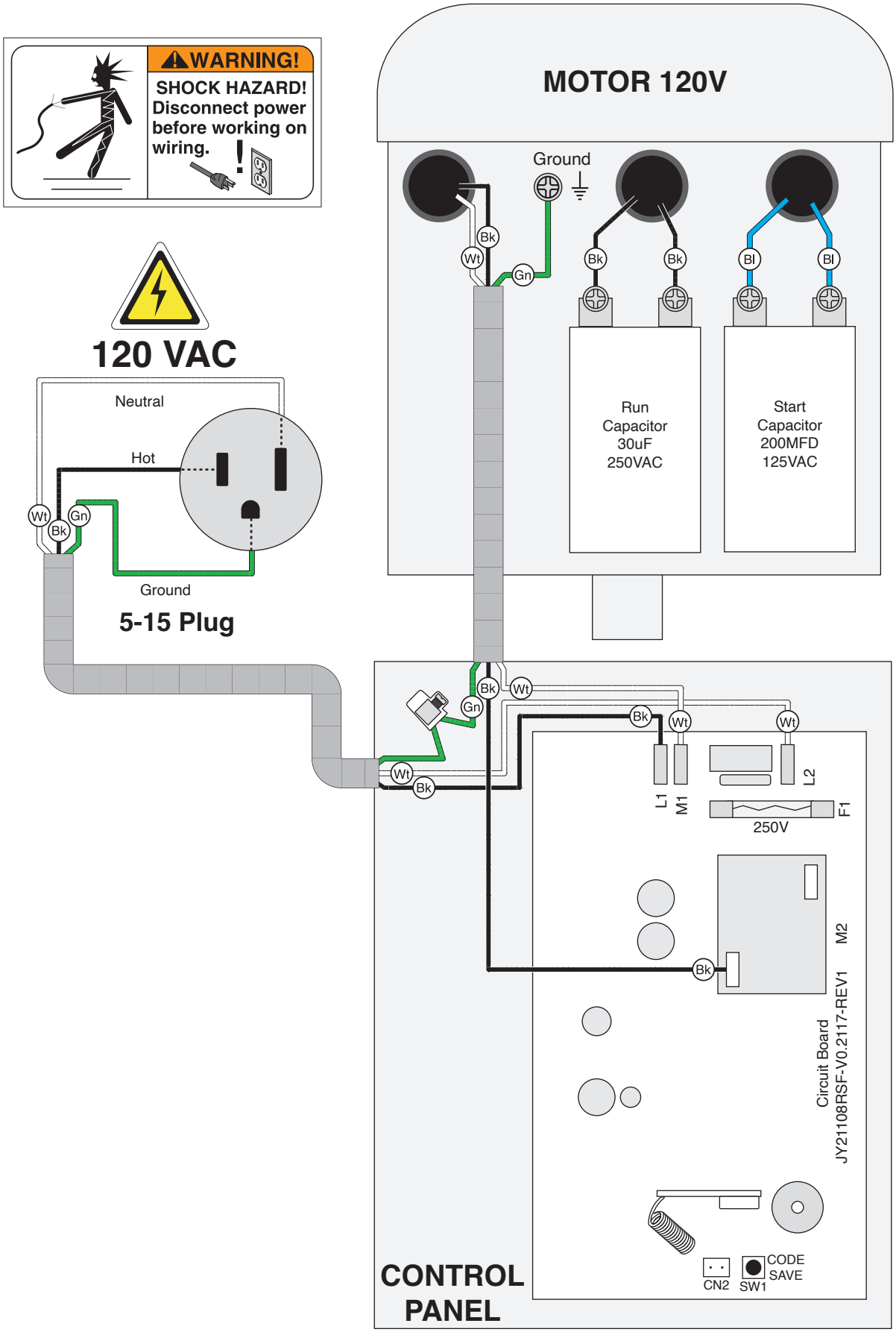
NOTICE

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

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram



Electrical Components

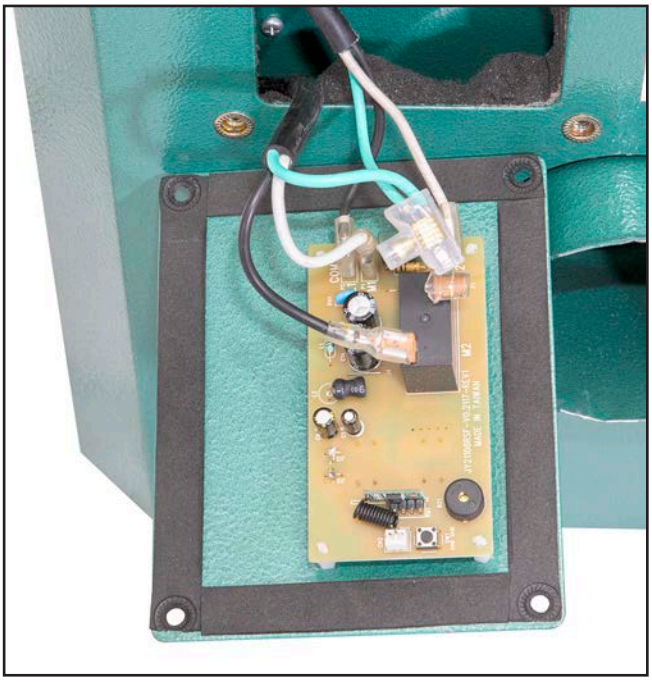


Figure 43. Control panel wiring.

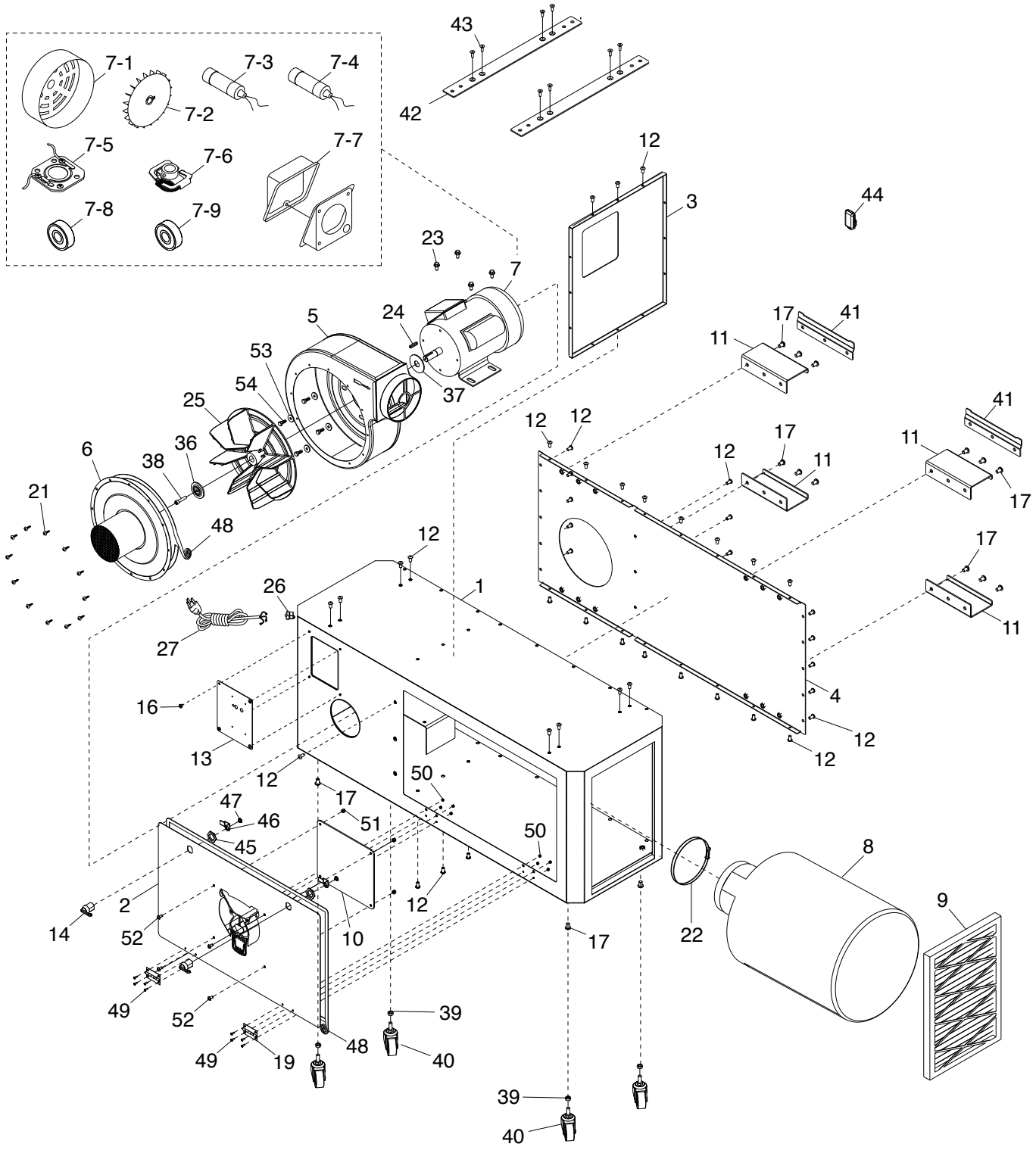
Figure 45. Run capacitor.

Figure 44. Start capacitor.

SECTION 8: PARTS

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

Main

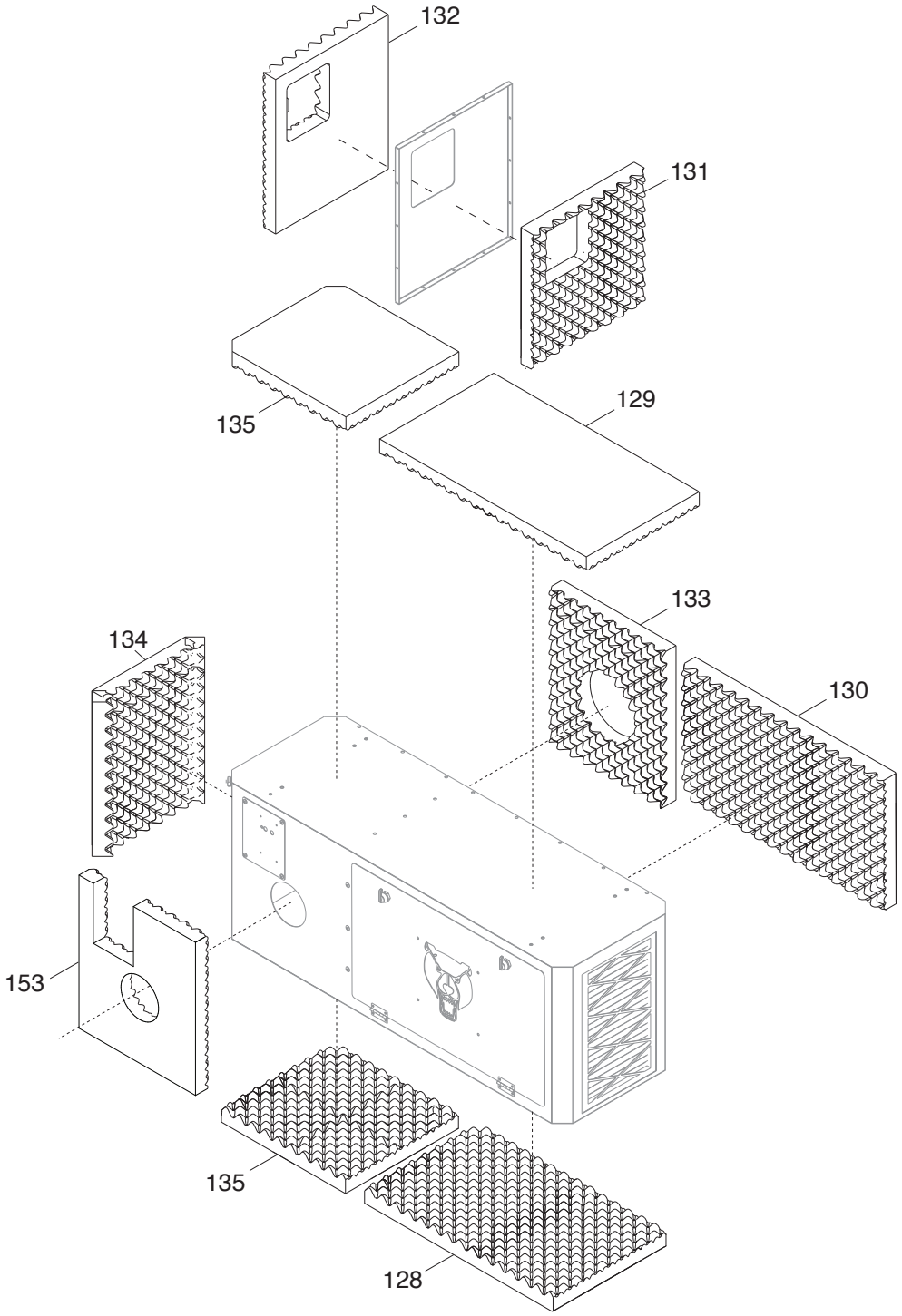


Main Parts List

REF	PART #	DESCRIPTION
1	P0405001	MACHINE BODY
2	P0405002	MAINTENANCE DOOR
3	P0405003	PANEL, MIDDLE
4	P0405004	PANEL, REAR
5	P0405005	IMPELLER HOUSING
6	P0405006	INLET COVER
7	P0405007	MOTOR 1HP 120V 1-PH
7-1	P0405007-1	MOTOR FAN COVER
7-2	P0405007-2	MOTOR FAN
7-3	P0405007-3	S CAPACITOR 200M 125V 2-3/4 X 1-3/8
7-4	P0405007-4	R CAPACITOR 30M 250V 2-3/8 X 1-3/8
7-5	P0405007-5	CONTACT PLATE 1 X 2-3/4 EXT
7-6	P0405007-6	CENTRIFUGAL SWITCH 5/8 1800
7-7	P0405007-7	MOTOR JUNCTION BOX
7-8	P0405007-8	BALL BEARING 6203-2RS
7-9	P0405007-9	BALL BEARING 6202-2RS
8	P0405008	FILTER BAG 24 X 13-1/2" FABRIC
9	P0405009	PLEATED FILTER 382 X 225 X 22MM
10	P0405010	WINDOW 200 X 180MM, ACRYLIC
11	P0405011	MOUNTING BRACKET, BODY
12	P0405012	BUTTON HD CAP SCR 1/4-20 X 1/2
13	P0405013	CONTROL PANEL
14	P0405014	CAM LATCH
16	P0405016	PHLP HD SCR 10-24 X 1/4
17	P0405017	BUTTON HD CAP SCR 5/16-18 X 1/2
19	P0405019	HINGE

REF	PART #	DESCRIPTION
21	P0405021	TAP SCREW #10 X 1/2
22	P0405022	BAG CLAMP 5"
23	P0405023	FLANGE BOLT 1/4-20 x 1/2
24	P0405024	KEY 5 X 5 X 25 RE
25	P0405025	IMPELLER 10", ALUMINUM
26	P0405026	STRAIN RELIEF 5/8
27	P0405027	POWER CORD 16G 3W 72" 5-15P
36	P0405036	IMPELLER WASHER 7 X 44 X 3MM
37	P0405037	GASKET 18 X 63 X 2MM, PVC
38	P0405038	CAP SCREW M6-1 X 30 LH
39	P0405039	HEX NUT 5/16-18
40	P0405040	CASTER 2", SWIVEL
41	P0405041	MOUNTING BRACKET, WALL
42	P0405042	MOUNTING BRACKET, UNDERMOUNTING
43	P0405043	FLAT HD CAP SCR 1/4-20 X 5/8
44	P0405044	REMOTE CONTROL
45	P0405045	HEX NUT M19-1
46	P0405046	LATCH PLATE
47	P0405047	TRUSS HD PHLP SCR M5-.8 X 5
48	P0405048	FOAM TAPE 16 X 2 X 1900MM
49	P0405049	PHLP HD SCR M3-.5 X 8
50	P0405050	LOCK NUT M3-.5
51	P0405051	LOCK NUT M4-.7
52	P0405052	PHLP HD SCR M4-.7 X 8
53	P0405053	FENDER WASHER 1/4
54	P0405054	HEX BOLT 1/4-20 X 1/2

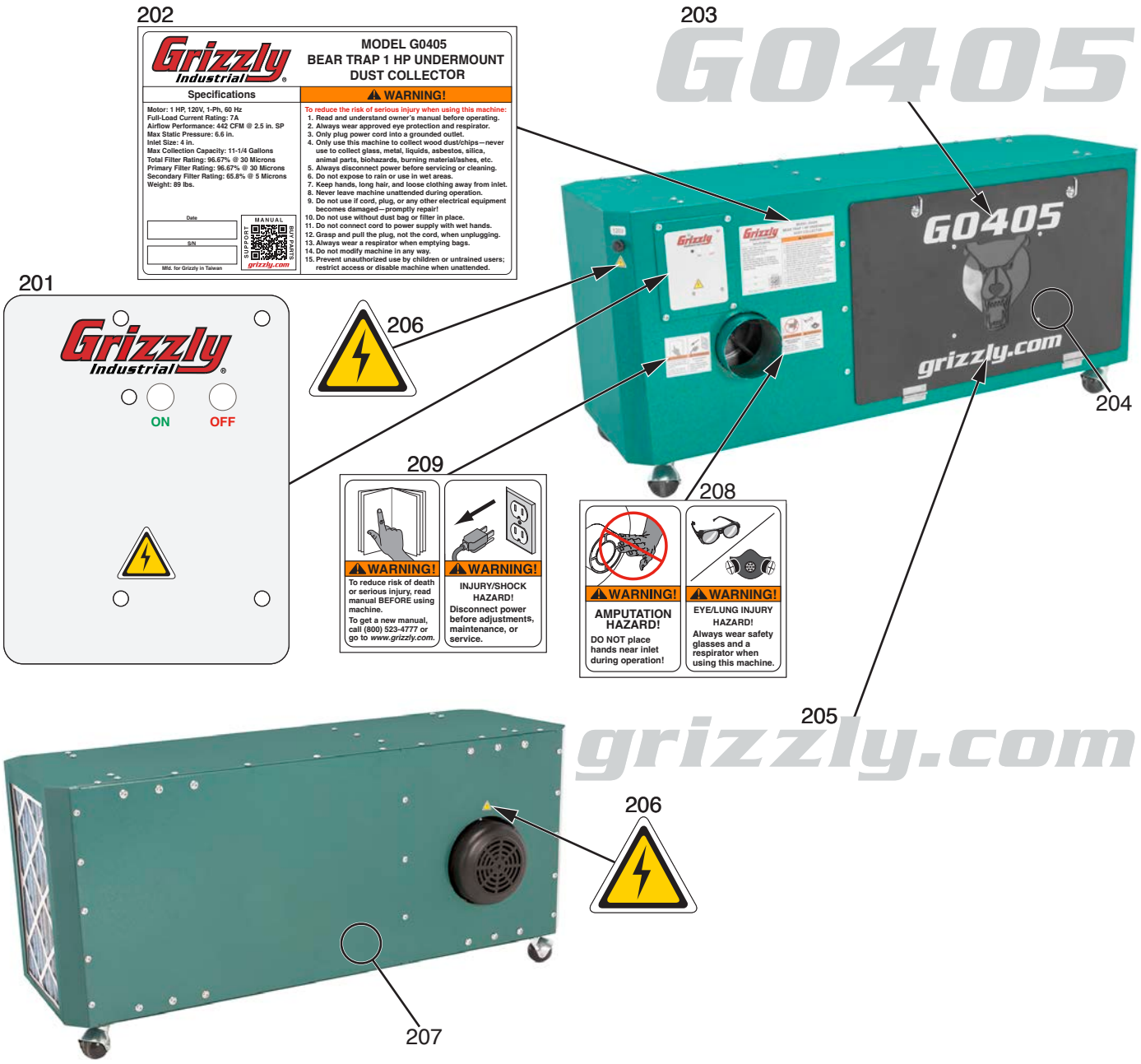
Insulating Foam



REF	PART #	DESCRIPTION
128	P0405128	FOAM 335 X 565 X 25MM BOTTOM R
129	P0405129	FOAM 335 X 615 X 25MM TOP R
130	P0405130	FOAM 350 X 590 X 25MM REAR R
131	P0405131	FOAM 335 X 337 X 25MM MIDDLE R
132	P0405132	FOAM 355 X 337 X 25MM MIDDLE L

REF	PART #	DESCRIPTION
133	P0405133	FOAM 325 X 370 X 25MM REAR L
134	P0405134	FOAM 400 X 361 X 25MM SIDE
135	P0405135	FOAM 368 X 337 X 25MM TOP/BOTTOM L
153	P0405153	FOAM 368 X 337 X 25MM FRONT L

Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P0405201	CONTROL PANEL LABEL
202	P0405202	MACHINE ID LABEL
203	P0405203	MODEL NUMBER LABEL
204	P0405204	TOUCH-UP PAINT, GLOSSY BLACK
205	P0405205	GRIZZLY.COM LABEL

REF	PART #	DESCRIPTION
206	P0405206	ELECTRICITY LABEL
207	P0405207	TOUCH-UP PAINT, GRIZZLY GREEN
208	P0405208	IMPELLER/EYE/LUNG LABEL
209	P0405209	READ MANUAL/DISCONNECT POWER LABEL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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

WARRANTY

grizzly.com