

Grizzly *Industrial, Inc.*®

MODEL G0406 **7-1/2 HP BAGHOUSE** **DUST COLLECTOR** **OWNER'S MANUAL** *(For models manufactured since 07/25)*



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#JAKS23599 PRINTED IN TAIWAN

V1.01.26

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



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

WARNING

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

CAUTION

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

Manual Accuracy

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

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

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

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

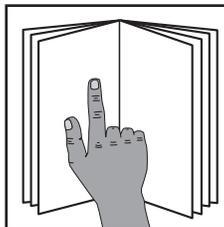
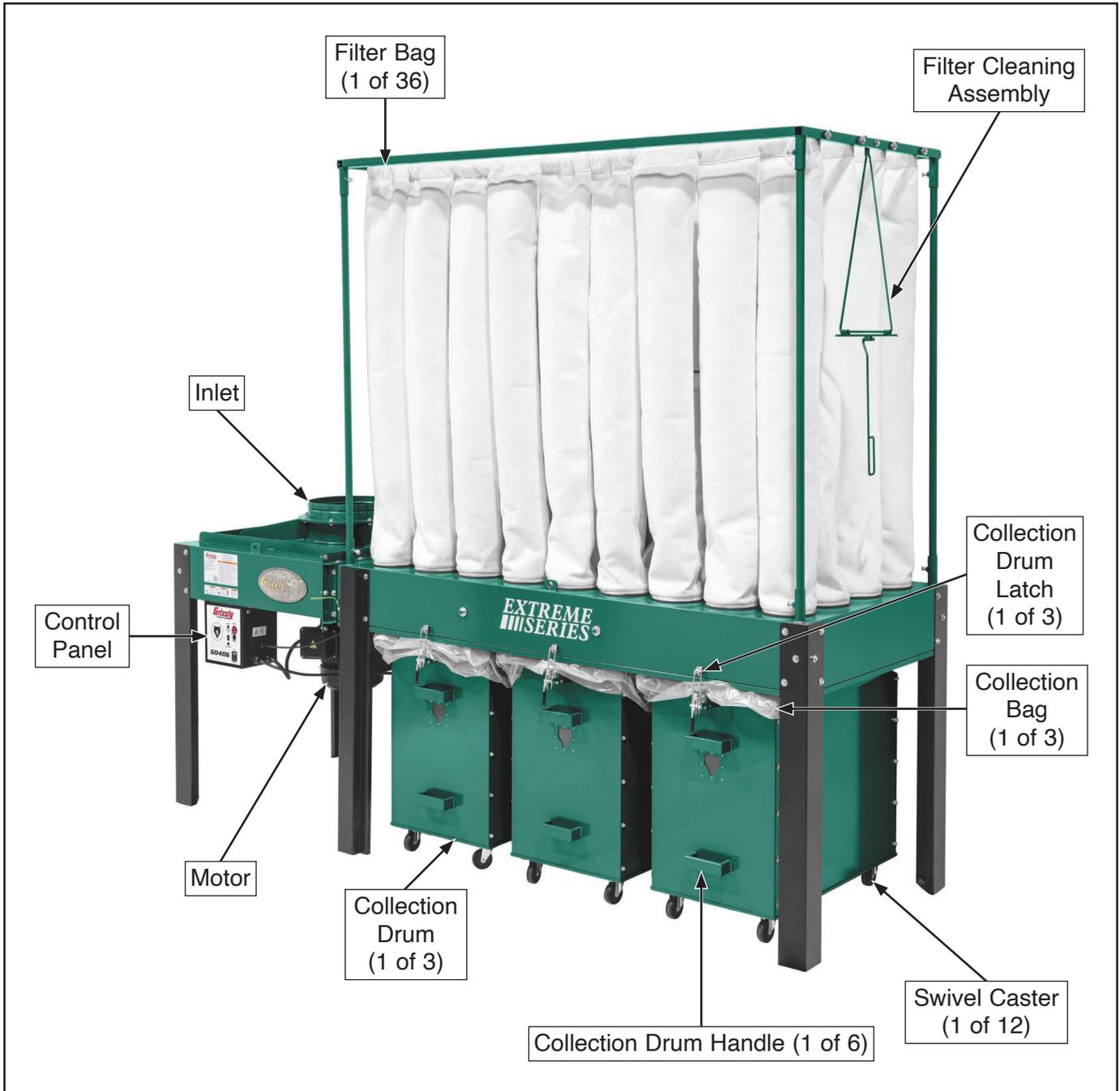
		MODEL GXXXX MACHINE NAME
SPECIFICATIONS		 WARNING!
Motor:	To reduce risk of serious injury when using this machine:	
Specification:	Manual before operation.	
Specification:	Safety glasses and respirator.	
Specification:	Correctly adjusted/setup and	
Specification:	power is connected to grounded circuit before starting.	
Weight:	4. Make sure the motor has stopped and disconnect	
	power before adjustments, maintenance, or service.	
	5. DO NOT expose to rain or dampness.	
	6. DO NOT modify this machine in any way.	
	7.	
	8.	
	9. ended.	
	10. Use of drugs or alcohol.	
	10. Maintain machine carefully to prevent accidents.	

Manufactured for Grizzly in Taiwan



Identification

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



! WARNING

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



Controls & Components



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.

Main



Figure 1. Main controls and components.

- A. **Filter Cleaning Assembly:** Swings back and forth to knock caked-on wood dust from filter bags to maintain consistent air flow.
- B. **Filter Bag (1 of 36):** Filters wood particles as small as 0.2 microns from collected air, and allows wood particles to fall and collect in drums below.
- C. **Collection Drum Latch (1 of 3):** Secures collection drum to machine body when pressed down. Releases collection drum when lifted.
- D. **Collection Drum (1 of 3):** Collects wood particles in collection bag during operation.
- E. **Collection Drum Handle (1 of 6):** Allows for easy collection drum movement.

Photoelectric Sensors

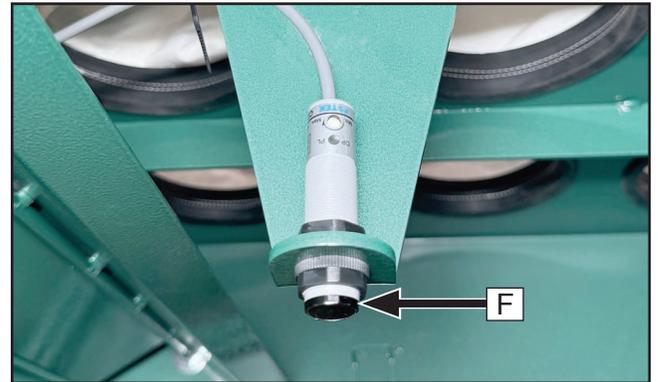


Figure 2. Photoelectric sensor (1 of 3).

- F. **Photoelectric Sensor (1 of 3):** Activates bag full indicator and audio alarm when desired fill volume of collection bag has been reached.



Control Panel

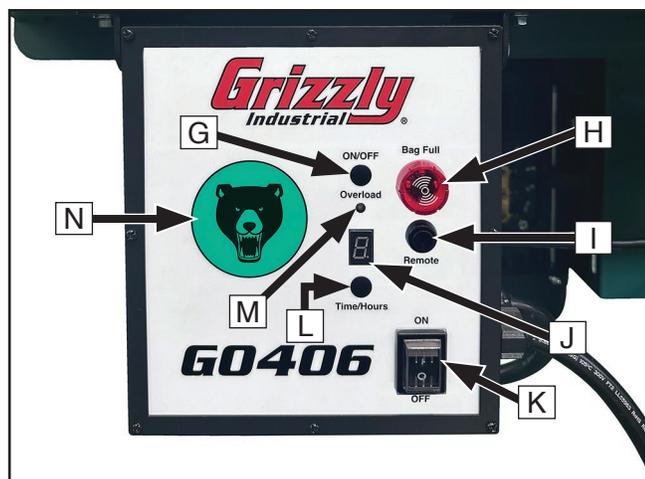


Figure 3. Control panel components.

- G. ON/OFF Button:** Turns motor **ON** and **OFF**.
- H. Bag Full Indicator:** Illuminates when one or more collection drum bags are full.
- I. Remote Button:** Activates pairing mode for remote control when pressed and held.
- J. Digital Readout:** Displays machine run time setting.

Note: When time setting duration has passed, machine will automatically turn off.
- K. ON/OFF Switch:** Turns incoming power to machine **ON** and **OFF**.

Note: ON/OFF switch must be moved to ON position for remote control to work.
- L. Time/Hours Button:** Cycles through nine available timer settings in one hour increments. Each button press adds one hour to time cycle.
- M. Overload Indicator:** Illuminates when motor is overloaded/overheated. Disconnect power and allow motor to cool before resuming operations.
- N. Dust Collection Indicator:** Illuminates when machine is operating.

Remote Control

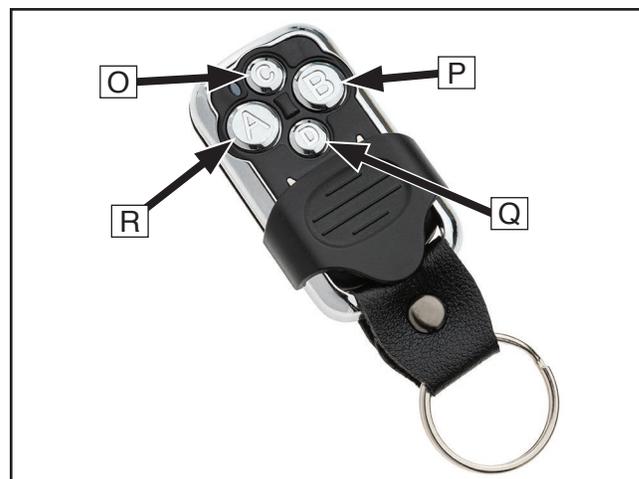


Figure 4. Remote control components.

- O. C Button:** Cycles through nine available timer settings in one hour increments. Each button press adds one hour to time cycle.
- P. B Button:** Turns motor **OFF**.
- Q. D Button:** Pairs remote with control panel when control panel is in pairing mode. Refer to **Pairing Remote Control** on Page 48.
- R. A Button:** Turns motor **ON**.

Note: Remote control operates on radio frequency and has a 50-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 G0406 7-1/2 HP BAGHOUSE DUST COLLECTOR

Product Dimensions:

Weight..... 1112 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 121 x 42 x 104 in.
 Footprint (Length x Width)..... 120-1/2 x 42 in.
 Space Required for Full Range of Movement (Width x Depth)..... 121 x 77 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
 Content..... Machine
 Weight..... 825 lbs.
 Length x Width x Height..... 88 x 45 x 35 in.
 Must Ship Upright..... Yes

Carton #2

Type..... Wood Crate
 Content..... Blower
 Weight..... 566 lbs.
 Length x Width x Height..... 45 x 41 x 40 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
 Prewired Voltage..... 220V
 Full-Load Current Rating..... 22A at 220V, 11A at 440V
 Minimum Circuit Size..... 50A at 220V, 30A at 440V
 Connection Type..... Permanent (Hardwire to Shutoff)
 Switch Type..... Control Panel

Motors:

Main

Horsepower..... 7-1/2 HP
 Phase..... 3-Phase
 Amps..... 22A/11A
 Speed..... 1720 RPM
 Type..... TEFC Induction
 Power Transfer Direct
 Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation

Dust Collector Type..... Single-Stage
 Approved Dust Types..... Wood
 Filter Type..... Bag
 Airflow Performance..... 5503 CFM @ 2.92 in. SP
 Max Static Pressure (at 0 CFM)..... 10.6 in.
 Main Inlet Size..... 14 in.
 Maximum Material Collection Capacity..... 231 Gallons



Filter Information

Filtration Rating..... 99.9% @ 0.2 - 2 microns
Filter Surface Area..... 311 sq. ft.

Bag Information

Number Of Filter Bags..... 36
Number Of Collection Drum Bags..... 3
Filter Bag Diameter..... 6-5/8 in.
Filter Bag Length..... 59-13/16 in.
Collection Drum Bag Diameter..... 37-13/16 in.
Collection Drum Bag Length..... 53-1/8 in.

Impeller Information

Impeller Type..... Radial Fin
Impeller Size..... 25 in.
Impeller Blade Thickness..... 1/8 in.

Construction

Filter Bag..... Spun Bond Polyester
Frame..... Steel
Impeller..... Steel
Paint Type/Finish..... Powder Coated
Blower Housing..... Steel
Body..... Steel
Collection Drum Bag..... Clear Plastic

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 5 Hours
Serial Number Location Machine ID Label
Sound Rating 80 dB
ISO 9001 Factory Yes

Features:

- Wireless Remote Control
- Three 77-Gallon Rolling Collection Drums with Quick-Release Latches
- Spun Bond Polyester Filter Bags with Collection Capacity of 99.9% @ 0.2 - 2 Microns
- Integrated Filter Bag Shaker for Maintaining Filter Efficiency
- Full Drum Indicator with Buzzer



SECTION 1: SAFETY

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

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



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



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



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

NOTICE

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

Safety Instructions for Machinery



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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for 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.

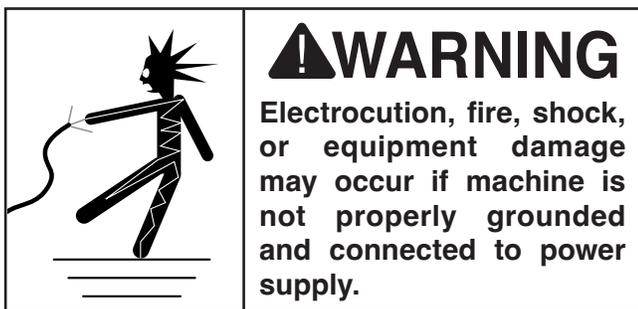
DUST ALLERGIES. Dust from certain woods will cause an allergic reaction. Make sure you know what type of wood dust you will be exposed to in case of an allergic reaction.



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.



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 220V 22 Amps

Full-Load Current Rating at 440V 11 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.)



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.*

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 50 Amps

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 440V, 480V
Cycle 60 Hz
Phase 3-Phase
Power Supply Circuit 30 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.

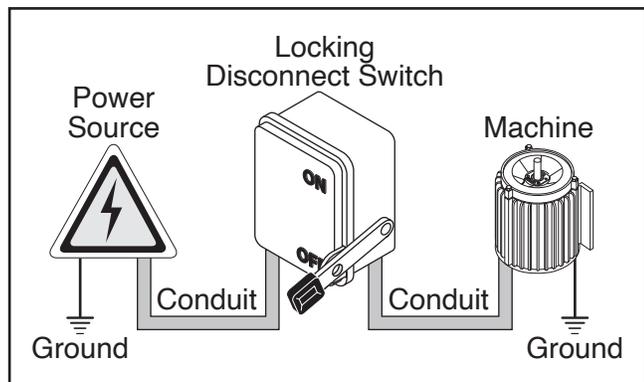


Figure 5. Typical setup of a permanently connected machine.

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.

3-Phase Power

This machine requires 3-phase power. **DO NOT** use a static phase converter to create 3-phase power—it can quickly decrease the life of electrical components on this machine. If you must use a phase converter, only use a rotary phase converter.

G7979—20 HP Rotary Phase Converter

This rotary phase converter allows you to operate 3-phase machinery from a single-phase power source at 100% power and 95% efficiency.



Figure 6. Model G7979 20 HP Rotary Phase Converter.



Converting Voltage to 440V



! WARNING
 Electrocution, shock, fire, or damage may occur if machine is ungrounded, incorrectly connected to power, or NOT connected to a proper power supply. Only an electrician or qualified service personnel should connect this machine to power. Damage from an improper connection or power supply will NOT be covered under warranty!

The voltage conversion MUST be performed by an electrician or qualified personnel.

The voltage conversion procedure consists of replacing the electrical mounting board, overload relay, and motor cord, and rewiring the control box, control panel, and motor. Wiring diagrams are provided on **Pages 58–59**.

IMPORTANT: If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. Use the diagram provided on the motor.

Items Needed	Qty
Conversion Kit 440V (G440VG0406)	1
Phillips Head Screwdriver #2	1
Open-End Wrenches 33, 36mm.....	1 Ea.
Socket Wrench	1
Socket 10mm.....	1
Socket Extension (12" Min.).....	1

To convert machine to 440V operation:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (8) fasteners securing control panel (see **Figure 7**).



Figure 7. Location of control panel fasteners.

3. Lower and tilt control panel so wiring is facing you, then secure panel to control box with (3) fasteners removed in **Step 2** (see **Figure 8**).

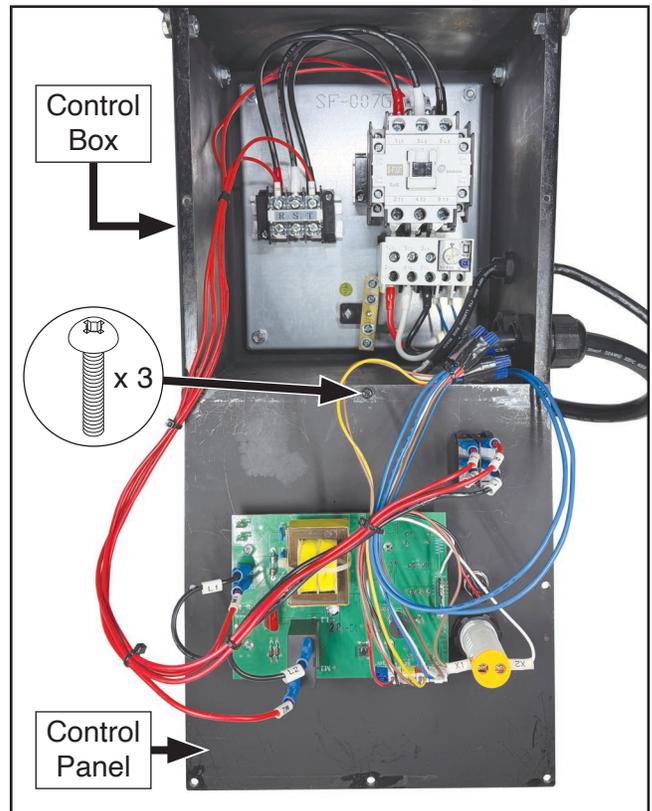


Figure 8. Control panel secured for 440V conversion.



- Disconnect and remove all wires at both ends connected to terminals on the terminal bar, contactor, overload relay, and ground terminals inside control box (see **Figure 9**).

Note: Remove 220V motor cord from control box but leave cord connected to motor at this time.

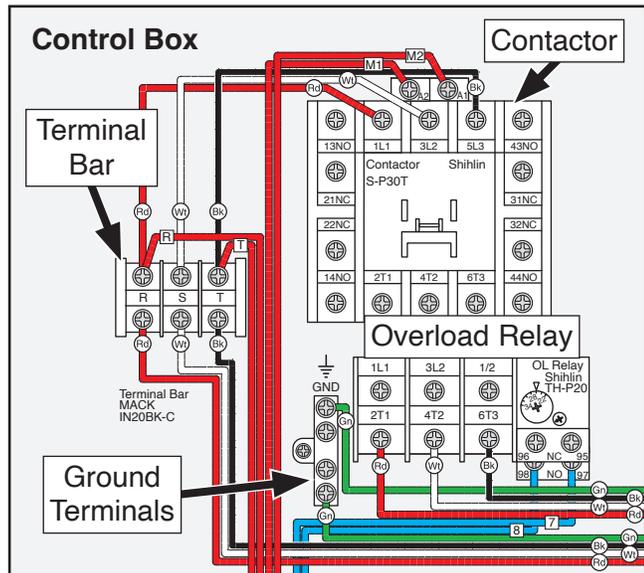


Figure 9. Wires to disconnect and remove at both ends in control box.

- Gently pull cover off of overload relay, then disconnect (3) spade connectors connected to relay terminals (see **Figure 10**) and remove relay.

IMPORTANT: Tilt overload relay towards you to release it from contactor.

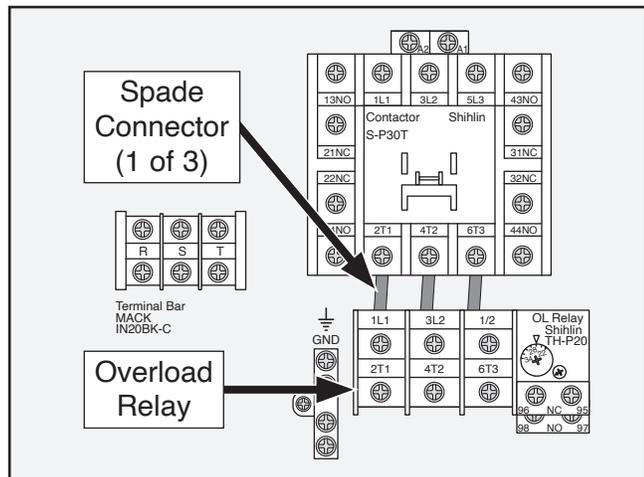


Figure 10. Spade connectors to remove on overload relay.

- Remove (4) nuts and washers securing electrical mounting board (see **Figure 11**) and set aside, then remove board from control box.

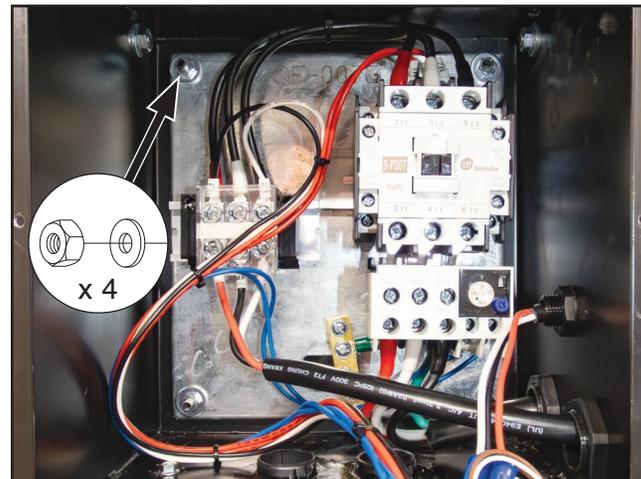


Figure 11. Location of fasteners securing electrical mounting board.

- Remove contactor, terminal bar, and ground terminal bar from electrical mounting board and set aside (see **Figure 12**).

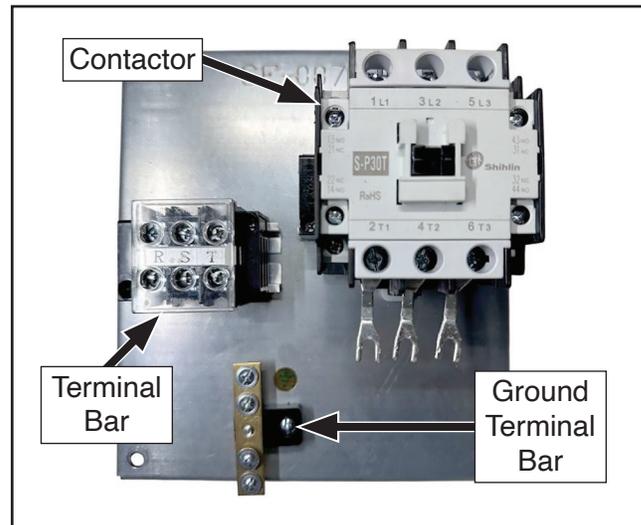


Figure 12. Components to remove from electrical mounting board.



8. Install contactor and terminal bar removed in previous step on DIN rails of 440V mounting board at locations shown in **Figure 13**.
9. Install ground terminal bar on 440V mounting board at location shown in **Figure 13**.

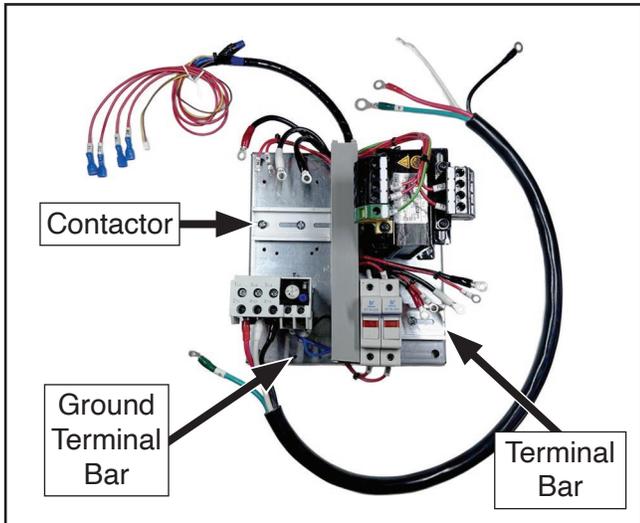


Figure 13. Installation locations on 440V mounting board.

10. Gently pull cover off overload relay on 440V mounting board and connect spade connectors from contactor to overload relay terminals 1L1, 3L2, 5L3 (see **Figure 14**), then install overload relay cover.

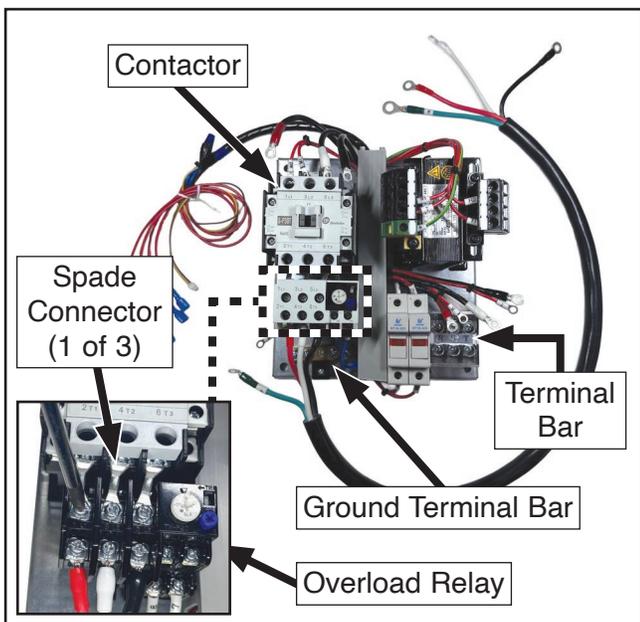


Figure 14. Connecting spade connectors to 440V overload relay.

11. Connect M1, M2, red, white, and black wires to A1, A2, 1L1, 3L2, and 5L3 contactor terminals (see **Figure 15**).

Note: Terminal guards covering contactor terminals can be removed to provide adequate clearance for terminal fasteners.

12. Connect R, red, white, T, and black wires to terminal bar R, S, and T terminals (see **Figure 15**).

13. Connect ground wires from 440V motor cord and transformer to any open terminals on ground terminal bar (see **Figure 15**).

Note: Ground wire from transformer may be hidden in wire loom.

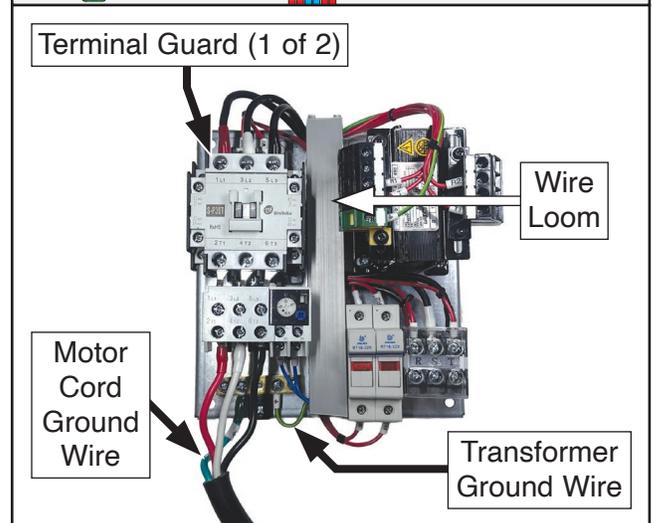
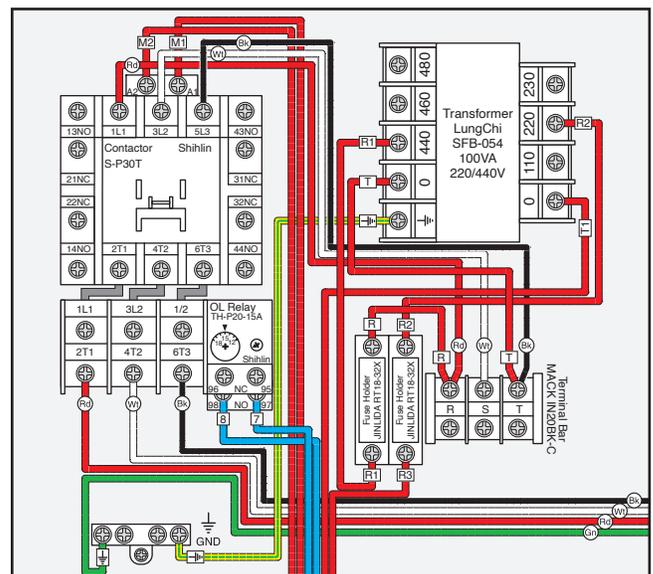


Figure 15. Location of wiring connections on 440V mounting board.



- Install 440V mounting board in control box and secure using nuts and washers removed in **Step 6** (see **Figure 16**).
- Loosen strain reliefs on side panel of control box and insert 440V motor cord through closest strain relief, then tighten to secure cord (see **Figure 16**).

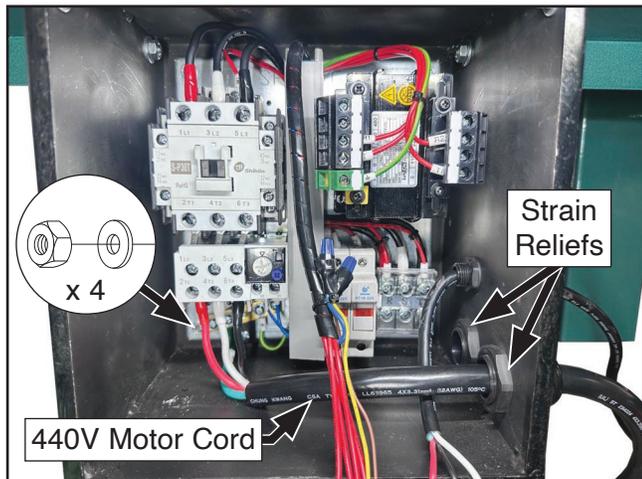


Figure 16. Mounting board and motor cord components installed for 440V operation.

- Connect T1 and R3 wires to upper ON/OFF switch terminals on control panel, M1 wire to 220V M1 terminal, M2 wire to M2 relay terminal, and brown/yellow wires to OLP terminal (see **Figure 17**).

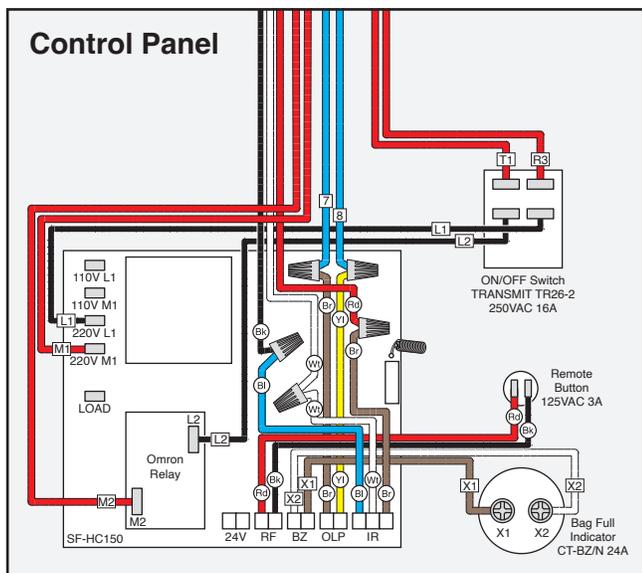


Figure 17. Wiring connections on control panel for 440V operation.

- Remove (4) fasteners securing motor junction box cover, and loosen strain relief securing 220V motor cord (see **Figure 18**).

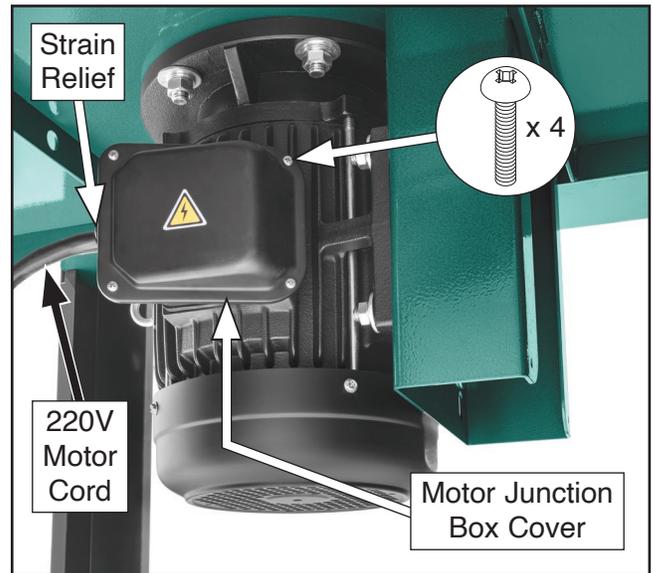


Figure 18. Location of motor components.

- Remove (6) hex nuts and (2) bus bars securing wires in motor junction box, as shown in **Figure 19**.

- Remove 220V motor cord (see **Figure 19**).

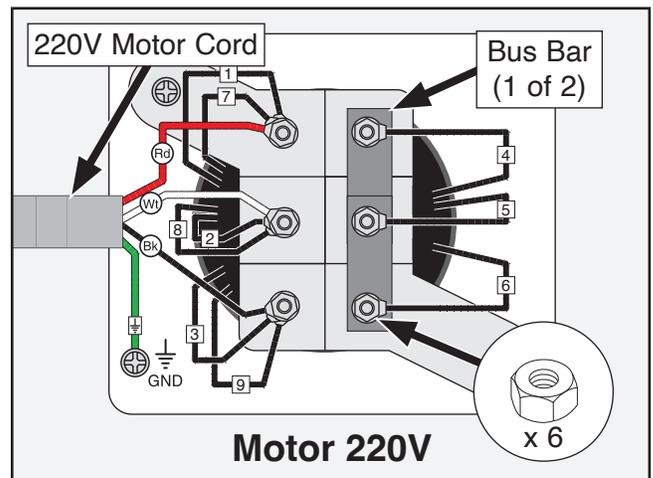


Figure 19. Components to remove in motor junction box.



20. Connect numbered motor wires to terminals shown in **Figure 20**.

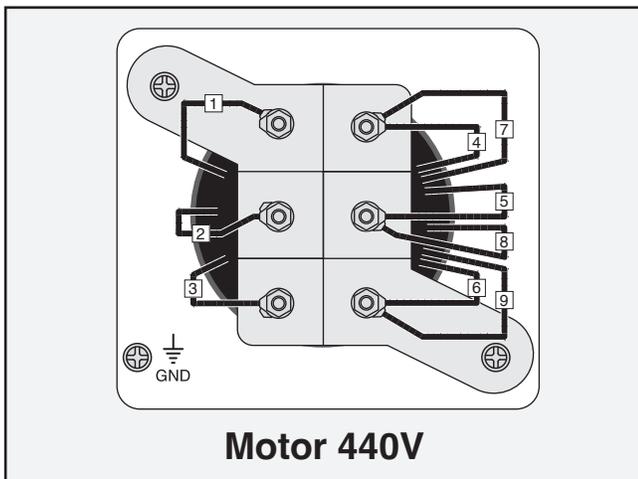


Figure 20. Motor wired for 440V operation.

21. Route 440V motor cord through strain relief and connect to terminals shown in **Figure 21**.
22. Install (6) hex nuts removed in **Step 18** on terminals and tighten to secure, as shown in **Figure 21**.

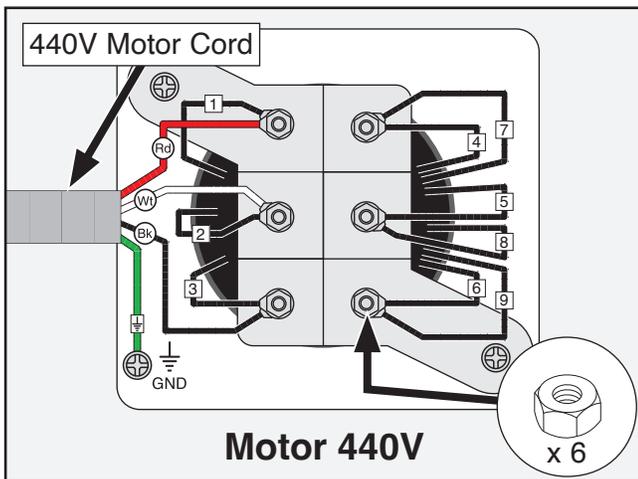


Figure 21. Location of 440V motor cord connections.

23. Tighten strain relief on motor junction box to secure 440V motor cord, then install motor junction box cover and secure with (4) fasteners removed in **Step 17**.
24. Route incoming power supply wires through available strain relief on side panel of control box and connect line wires to terminal bar (see **Figure 22**).

25. Connect power supply ground wire to any open terminal on ground terminal bar (see **Figure 22**).

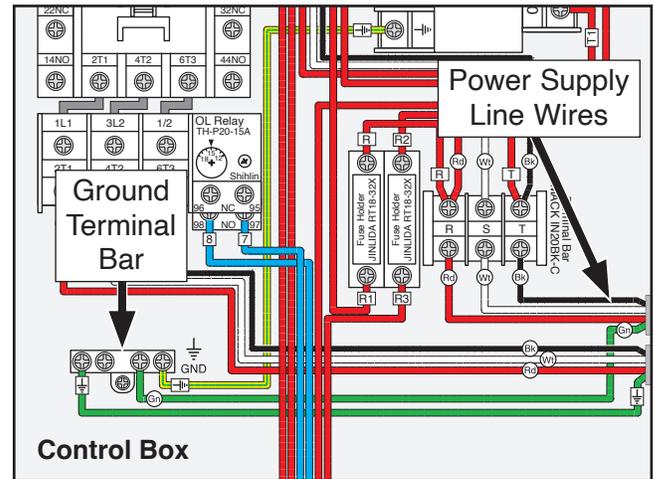


Figure 22. Connected 440V power supply wires.

26. Remove (3) fasteners securing control panel to control box and verify all wire connections are secure and match control panel shown in **Figure 23**.

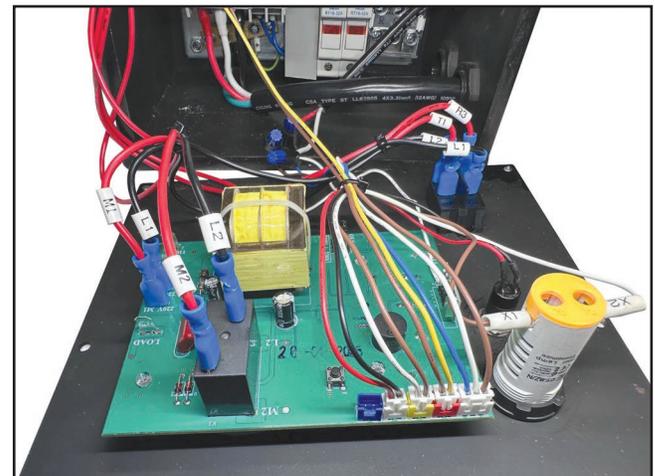
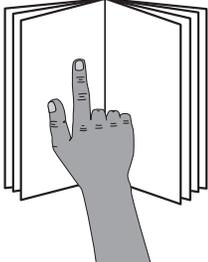


Figure 23. Wiring connected and secured on control panel.

27. Lift control panel and secure to control box with (8) fasteners removed in **Step 2**.
28. Proceed to **Test Run** on **Page 36** to verify machine operation.



SECTION 3: SETUP



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



!WARNING
 Wear safety glasses during the entire setup process!



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

Needed for Setup

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

Description	Qty
• Additional People	2
• Safety Glasses (for each person).....	1 Pr.
• Lifting Straps w/Hooks (rated for at least 1400 lbs.).....	2
• Forklift (rated for at least 1400 lbs.).....	1
• Wire Strippers.....	1
• Utility Knife	1
• Open-End Wrenches or Sockets 12, 14, 19mm	2 Ea.
• Open-End Wrenches or Sockets 8, 10, 11, 13, 15, 21mm.....	1
• Open-End Wrenches 33, 36mm.....	1
• Phillips Head Screwdriver #2	1
• Dust Collection System (Page 38).....	1
• Electrical Tape.....	As Needed

Unpacking

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

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



Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Main (Figure 24)	Qty
A. Impeller Housing (Not Shown)	1
B. Machine Body (Not Shown).....	1
C. Front Drum Panels	3
D. Base Drum Panels	3
E. Rear Drum Panels.....	3
F. Drum Rims	3
G. Side Drum Panels	6
H. Collection Drum Bags (T34368).....	3
I. Swivel Casters.....	12
J. Chip Deflectors.....	2
K. Vibration Pads	6
L. Inlet Flange Adapter 14".....	1
M. Corner Legs.....	4
N. Middle Legs.....	2
O. Frame Support Rods.....	4
P. Filter Cleaning Assembly (Installed).....	1

Loose Parts (Figure 25)	Qty
Q. Photoelectric Sensor Junction Box	1
R. Wire Nuts.....	3
S. Strain Reliefs M10-1.5	3
T. Photoelectric Sensor Adjustment Keys	3
U. Latches.....	3
V. Cable Ties	8
W. Strain Relief M16-1.5	1
X. Remote Control	1
Y. Foam Tape 3 x 6 x 1000mm	1
Z. Photoelectric Sensors CDR-30X.....	3
AA. Drum Latch Hooks	3
AB. Body Latch Hooks.....	3

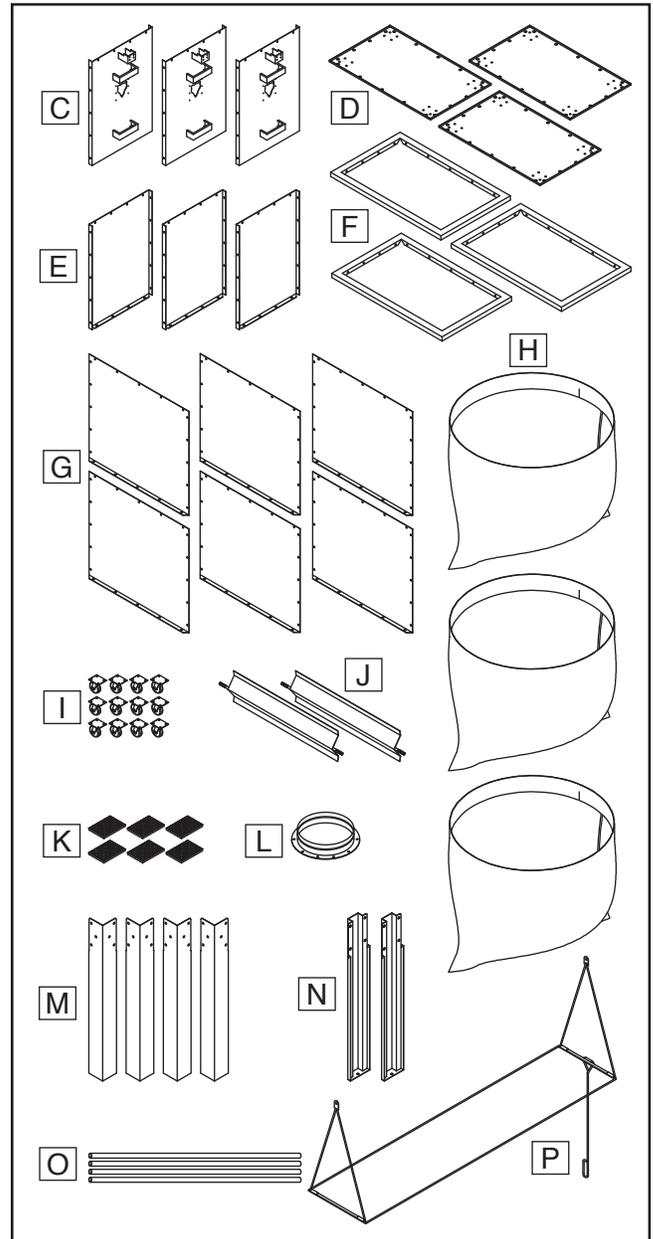


Figure 24. Main inventory.

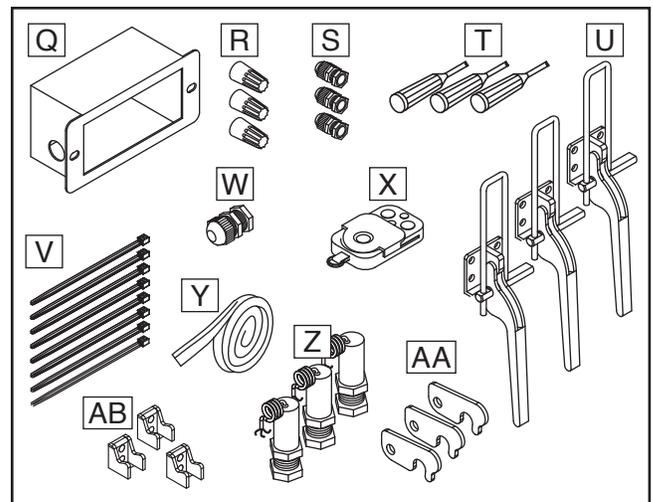


Figure 25. Loose parts inventory.



Fasteners (Figure 26)	Qty
AC. Hex Bolts $\frac{3}{8}$ "-16 x 1" (P0406062)	26
AD. Flat Washers $\frac{3}{8}$ " (P0406063).....	40
AE. Lock Nuts $\frac{3}{8}$ "-16 (P0406114).....	2
AF. Hex Nuts $\frac{3}{8}$ "-16 (P0406064)	18
AG. Hex Bolts $\frac{3}{8}$ "-16 x 2" (P0406112)	2
AH. Flat Washers $\frac{5}{16}$ " (P0406091).....	378
AI. Hex Nuts $\frac{5}{16}$ "-18 (P0406092)	162
AJ. Hex Bolts $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " (P0406090).....	216
AK. Hex Bolts $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " (P0406099).....	3
AL. Lock Nuts $\frac{1}{4}$ "-20 (P0406100)	3
AM. Flat Washers #10 (P0406125).....	4
AN. Hex Nuts #10-24 (P0406126).....	2
AO. Phillips Head Screws #10-24 x $\frac{1}{2}$ " (P0406124)	2
AP. Phillips Head Screws #10-24 x $\frac{3}{8}$ " (P0406078).....	18

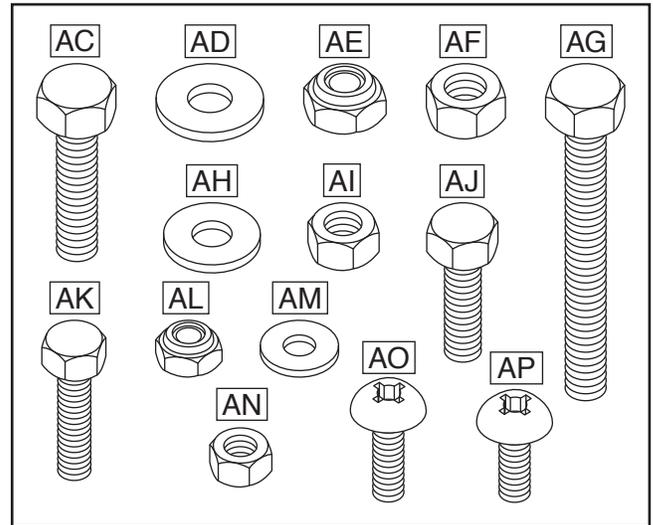


Figure 26. Fasteners (one of each shown).

Spare Fasteners (Figure 27)	Qty
AQ. Hex Bolts $\frac{3}{8}$ "-16 x 1" (P0406062)	2
AR. Flat Washers $\frac{3}{8}$ " (P0406063).....	2
AS. Hex Nuts $\frac{3}{8}$ "-16 (P0406064)	2
AT. Hex Bolts $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " (P0406090)	2
AU. Flat Washers $\frac{5}{16}$ " (P0406091)	2
AV. Hex Nuts $\frac{5}{16}$ "-18 (P0406092)	2

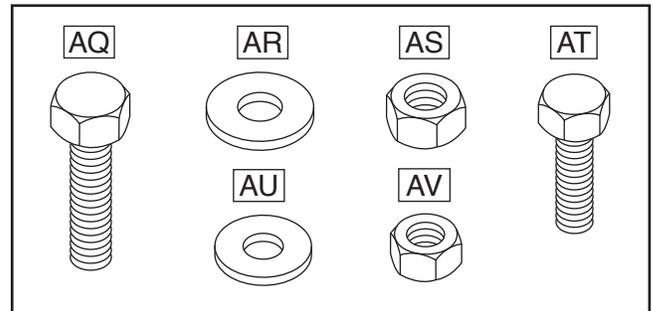


Figure 27. Spare fasteners (one of each shown).

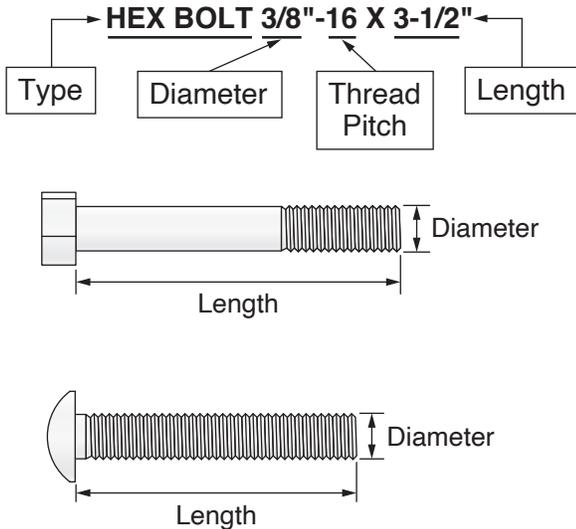


Measuring Hardware

Use this page to understand how hardware is measured in this manual.

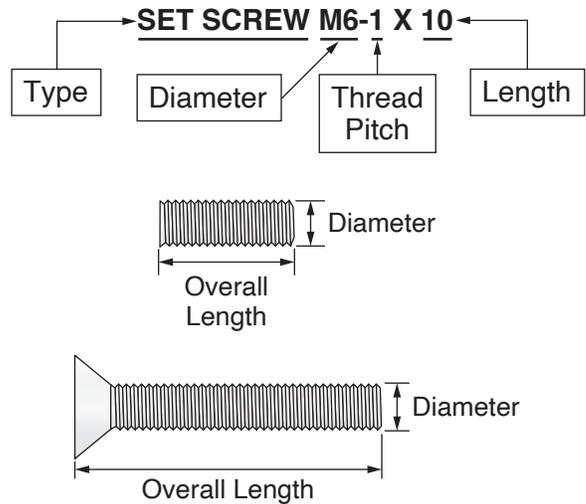
Bolts & Screws

Most bolts and screws are measured by the outside diameter of the threads, thread pitch, and the length from under the head to the opposite end:

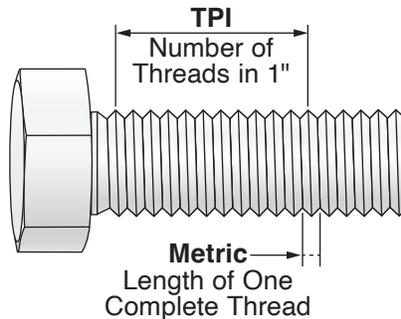


Flat Head & Set Screws

Flat head and set screws are measured by the outside diameter of the threads, thread pitch, and overall length of the fastener. These fasteners are often meant to sit flush with the adjoining surface:



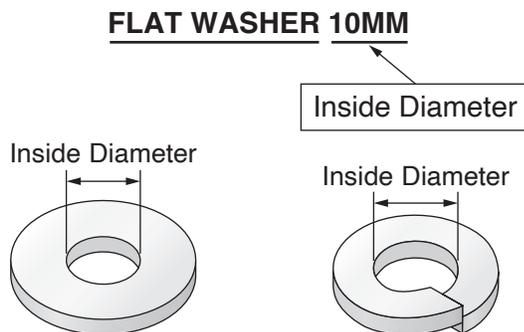
Thread pitch is the distance from the tip of one thread to the tip of the next thread. For US Standard threads, pitch is measured in threads per inch (TPI). Metric thread pitch is the length of one complete thread.



Note: Grizzly Industrial does not typically list a thread pitch for thread-forming screws and bolts, such as tap screws, wood screws, and lag bolts.

Washers

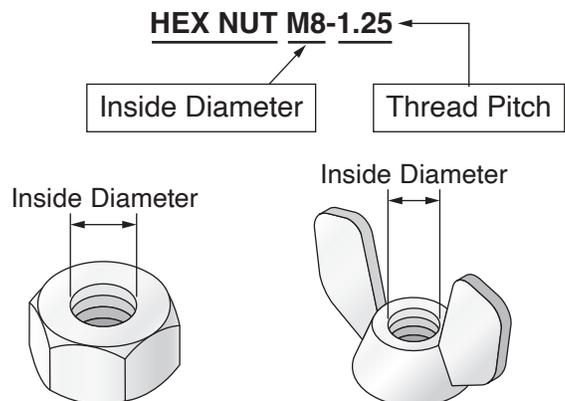
Common washers are measured by their inside diameter.



Note: Specialized washers may list the inside diameter, outside diameter, and the thickness.

Nuts

Nuts are measured by the inside diameter of the threads and the thread pitch.



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.**

Physical Environment

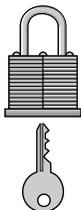
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions 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.

	<p>⚠ CAUTION</p> <p>Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
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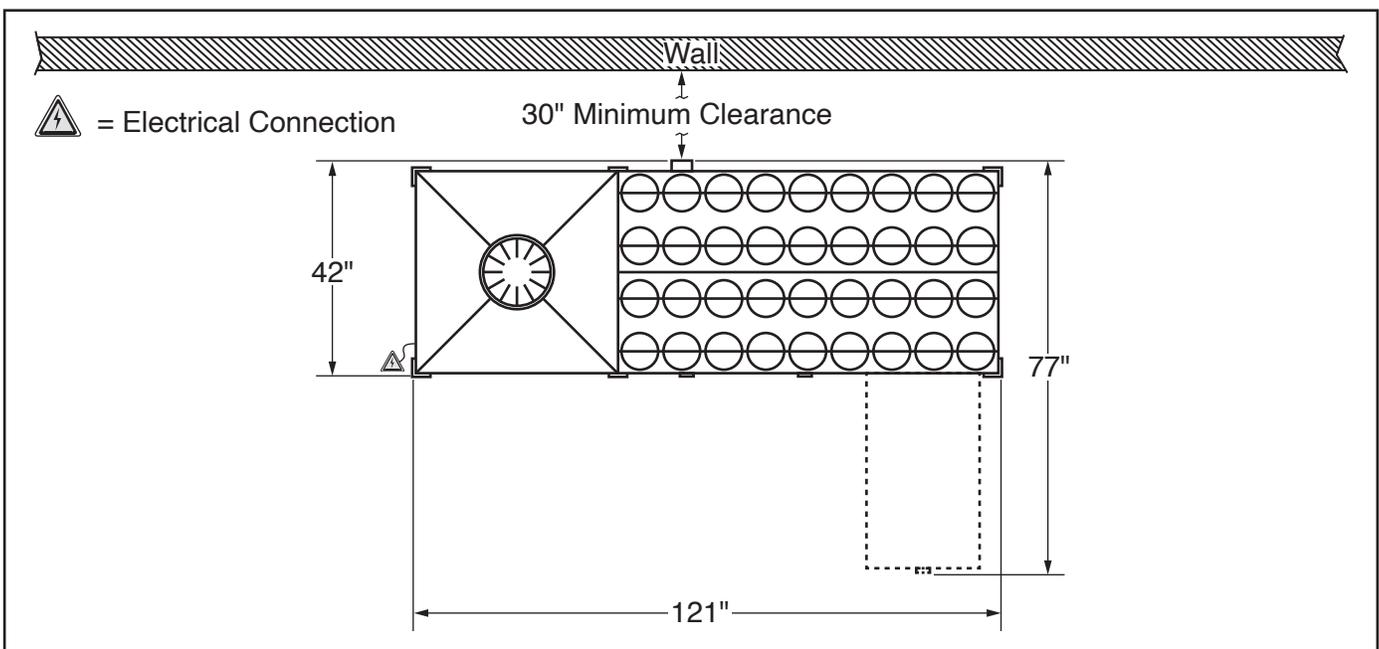
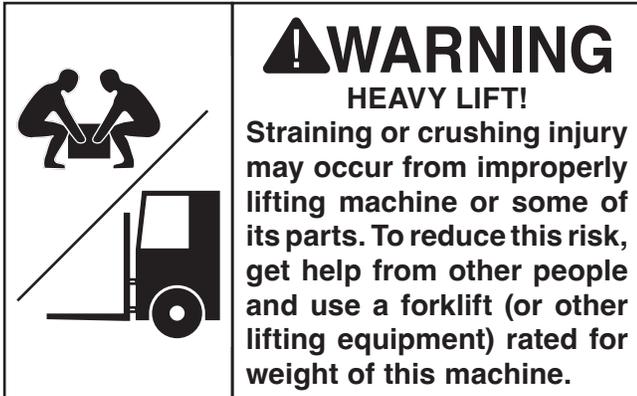


Figure 28. Minimum working clearances.



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).



DO NOT attempt to lift this machine without using a forklift and the necessary assistance from other people. Each piece of lifting equipment must be rated for at least **1400 lbs.** to support dynamic loads that may be applied.

The G0406 is packaged in two crates for transportation: one holds the machine body, and the other holds the impeller housing. It is important that both boxes are present to complete the assembly process.

To assemble machine:

1. If anchoring machine to floor, use the template shown in **Figure 29** and refer to **Anchoring to Floor** on **Page 32** to prepare mounting location prior to machine assembly.

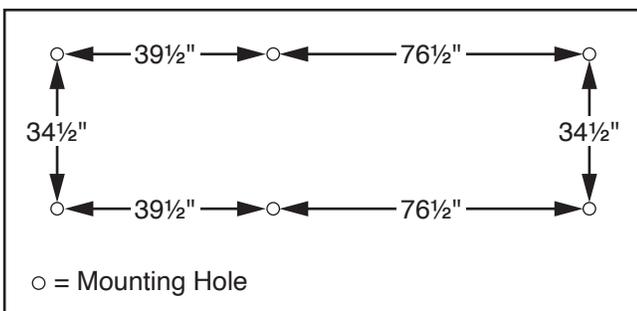


Figure 29. Mounting hole locations.

2. Move pallets to desired shipping location, then remove top crate from each shipping pallet.
3. Remove loosely packed items.
4. Unbolt machine body and impeller housing from pallets.
5. Secure lifting straps with hooks to lifting brackets on front and rear of machine body (see **Figure 30**).

IMPORTANT: To prevent damage to machine components, route lifting straps inside filter support frame.



6. Lift machine body 45" from ground, then remove pallet and (4) pre-installed steel legs (see **Figure 30**). Save fasteners for later use.

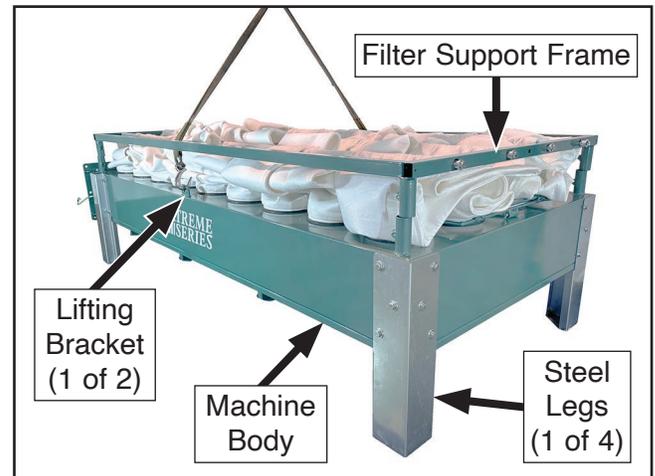


Figure 30. Location of filter support frame, lifting brackets, and pre-installed steel legs.



- Install (2) corner legs on right side of machine body with (12) hex bolts, (24) flat washers, and (12) hex nuts removed in **Step 6** (see **Figure 31**). Hand-tighten fasteners for now.

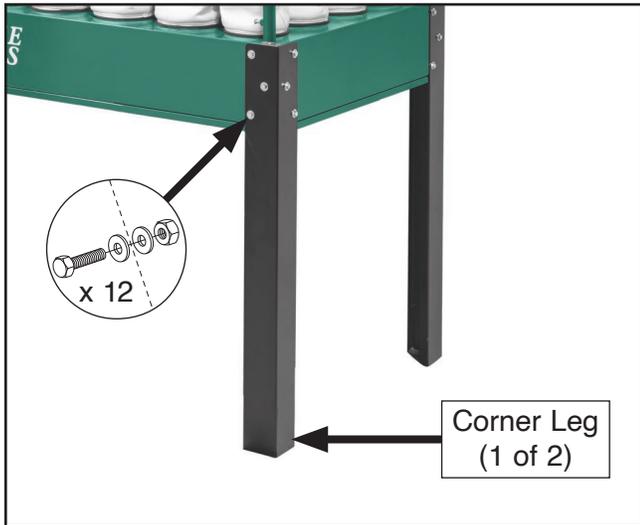


Figure 31. Corner legs installed on right side of machine body.

- Install (1) middle leg to front left edge of machine body with (4) hex bolts, (8) flat washers, and (4) hex nuts removed in **Step 6** (see **Figure 32**). Hand-tighten fasteners for now.

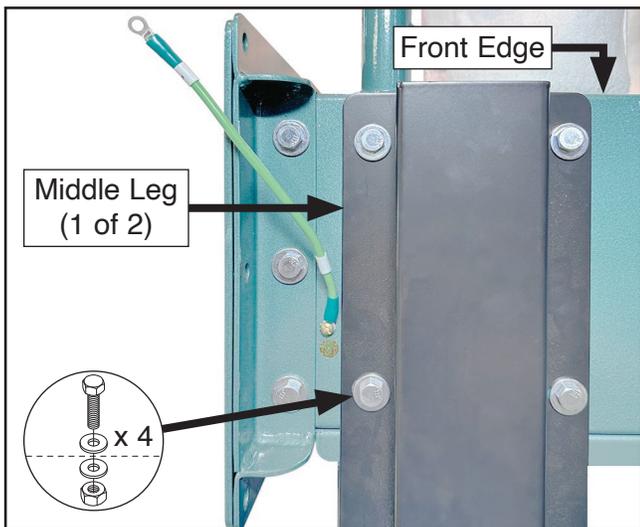


Figure 32. Middle leg installed on front edge of machine body.

- Repeat **Step 8** on rear left edge.
- Place (1) vibration pad under each leg.
- Lower machine body onto vibration pads while keeping tension on lifting straps, then fully tighten fasteners from **Steps 7–9**.
- Release tension on lifting straps and remove from machine body.
- Install inlet flange adapter to impeller housing with (8) $\frac{3}{8}$ "-16 x 1" hex bolts, (16) $\frac{3}{8}$ " flat washers, and (8) $\frac{3}{8}$ "-16 hex nuts, as shown in **Figure 33**.
- Attach lifting straps to brackets on front and rear of impeller housing (see **Figure 33**).

IMPORTANT: For **Steps 15–19** have at least two additional people steady impeller housing as it is lifted.

- Lift impeller housing 45" from ground, then remove pallet, and remove (4) pre-installed steel legs (see **Figure 33**). Save fasteners for later use.

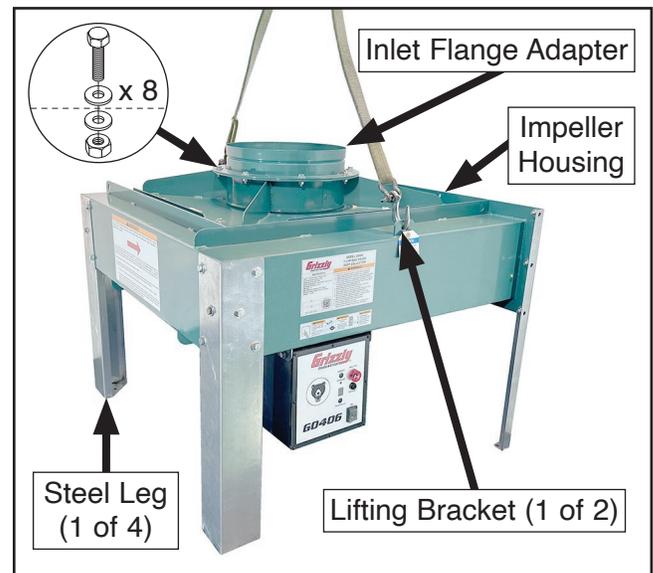


Figure 33. Location of inlet flange adapter, lifting brackets, and pre-installed steel legs.



16. Install (2) corner legs to left side of impeller housing with (12) hex bolts and (12) flat washers removed in **Step 15** (see **Figure 34**). Hand-tighten fasteners for now.

Note: Remaining (6) hex bolts, (12) flat washers, and (6) hex nuts removed in **Step 15** will be used in a later step.

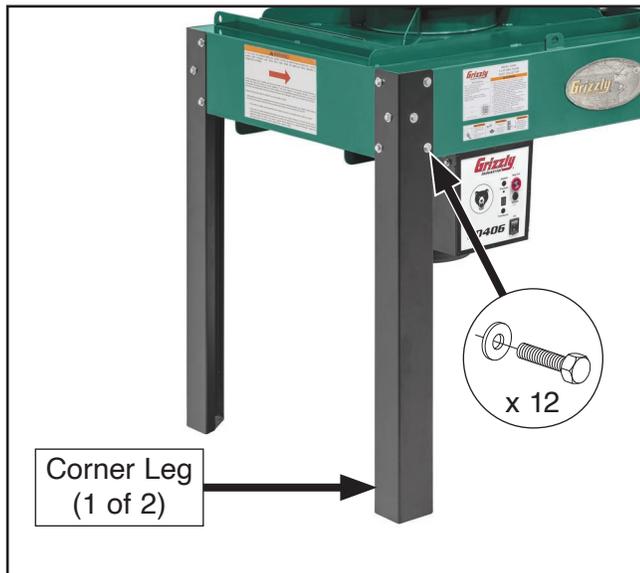


Figure 34. Corner legs installed on left side of impeller housing.

17. Remove backing from foam tape and apply along edge of impeller housing flange (see **Figure 35**), then cut foam tape to size and cut out holes for fasteners.

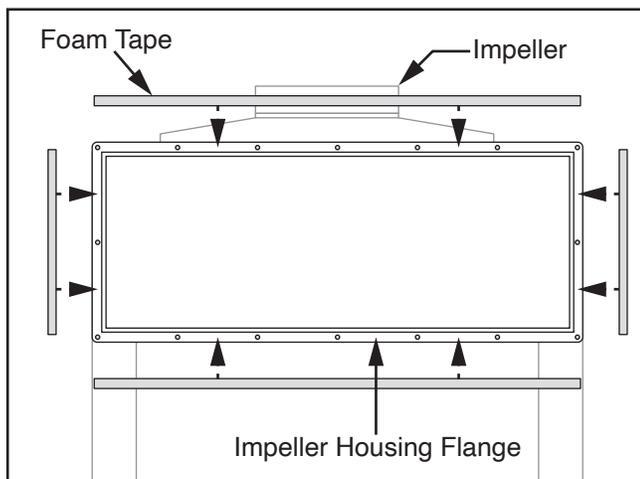
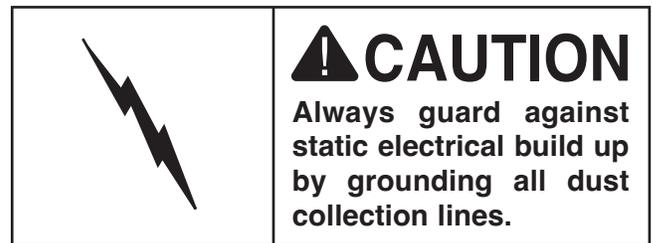


Figure 35. Foam tape application on impeller housing flange.

18. Position impeller housing flange flush with machine body flange, then place (1) vibration pad under each leg.
19. Lower impeller housing onto vibration pads, but maintain tension in lifting straps in case adjustments need to be made.
20. Secure impeller housing to machine body with (16) $\frac{3}{8}$ "-16 x 1 hex bolts, (32) $\frac{3}{8}$ " flat washers, and (16) $\frac{3}{8}$ "-16 hex nuts (see **Figure 36**). Hand-tighten fasteners for now.



21. Attach ground wire to impeller housing with pre-installed Phillips head screw shown in **Figure 36**.

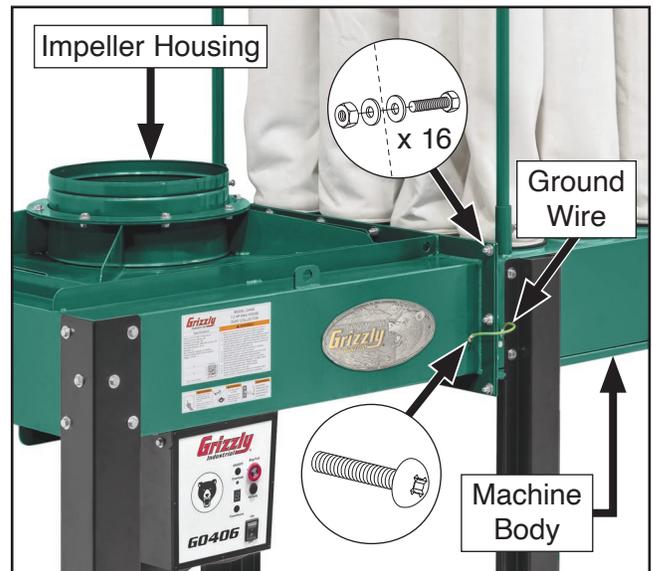


Figure 36. Impeller housing attached to machine body.



22. Fully tighten fasteners from **Steps 16 & 20**, then release tension on lifting straps and remove from impeller housing.
23. Attach lifting straps to filter support frame and raise frame, then install (4) frame support rods into corners of machine body and secure with (4) $\frac{3}{8}$ "-16 x 1" hex bolts (see **Figure 37**).
24. Keep filter support frame raised and align rods with holes in frame, then lower frame so rods seat into holes, and secure with (4) $\frac{3}{8}$ "-16 x 1" hex bolts (see **Figure 37**).

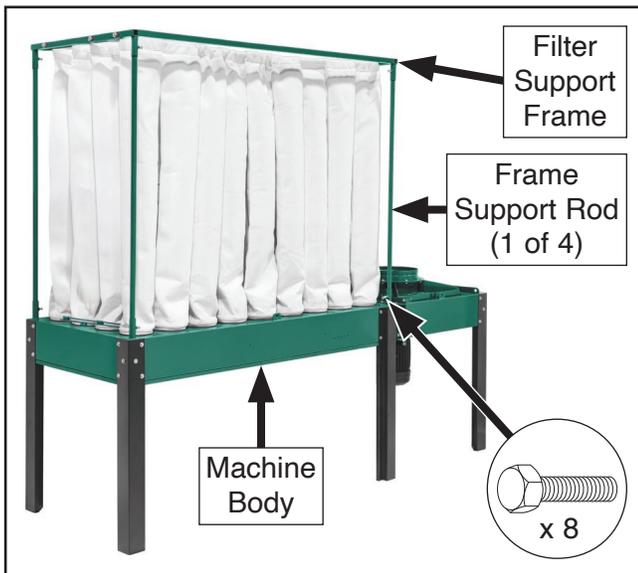


Figure 37. Filter support frame and rods installed on machine body.

25. Attach filter cleaning assembly to filter support frame with (2) $\frac{3}{8}$ "-16 x 2" hex bolts, (4) $\frac{3}{8}$ " flat washers, and (2) $\frac{3}{8}$ "-16 lock nuts, (see **Figure 38**).



Figure 38. Filter cleaning assembly installed on filter support frame.



26. Ensure each filter bag seal is seated properly in hole in machine body (see **Figure 39**).

TIP: If any seal is not seated, fold seal in half and stick all the way into hole in machine body, then slowly pull upper lip of seal over edge of machine body.

NOTICE

An improper seal may result in decreased filter efficiency, expulsion of sawdust, and strain on motor. Ensure all filter bags are properly sealed before operating.

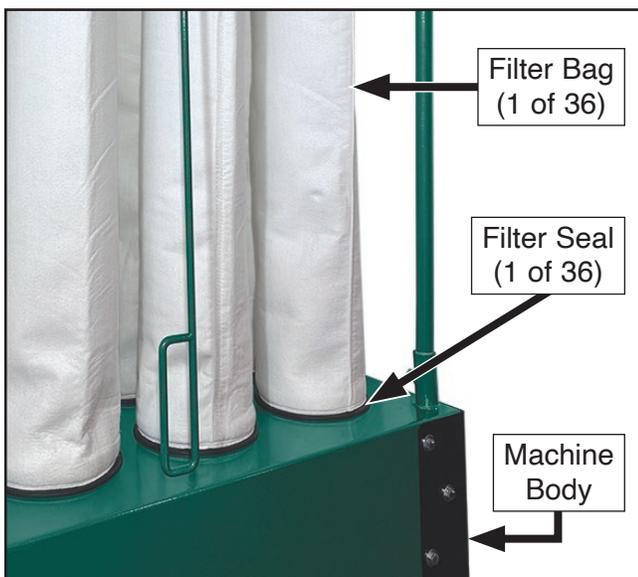


Figure 39. Filter seal properly seated in hole in machine body.

27. Remove pre-installed exterior hex nuts, flat washers, and rubber gaskets from both ends of (1) chip deflector rod (see **Figure 40**).

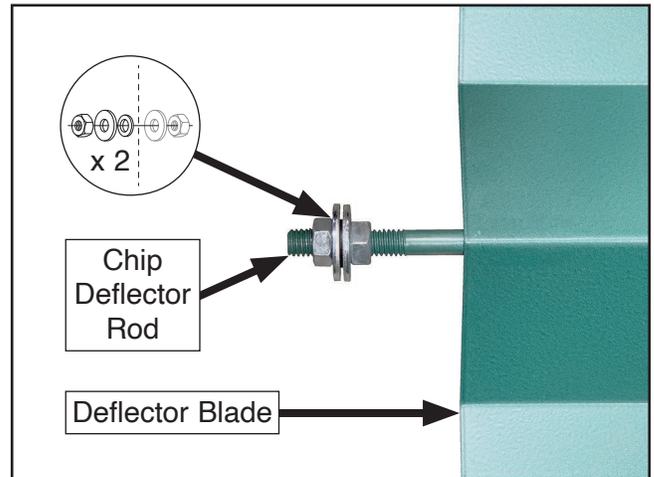


Figure 40. Location of chip deflector components (front end shown).

28. Fully thread inside hex nuts on chip deflector rod and push remaining flat washers flush against hex nuts (see **Figure 41**).

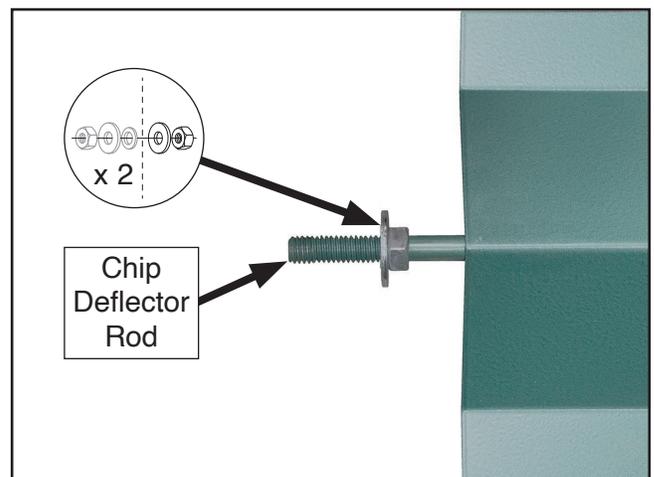


Figure 41. Inside hex nut threaded all the way back on chip deflector rod (front end shown).



29. Slide chip deflector rod into holes in front and rear panels of machine body, then adjust hex nuts against machine body until snug, as shown in **Figure 42**.

Note: Ensure equal amounts of chip deflector rod are sticking out the front and rear of machine (approximately $\frac{5}{8}$ " on each side), and chip deflector is positioned with concave side facing down.

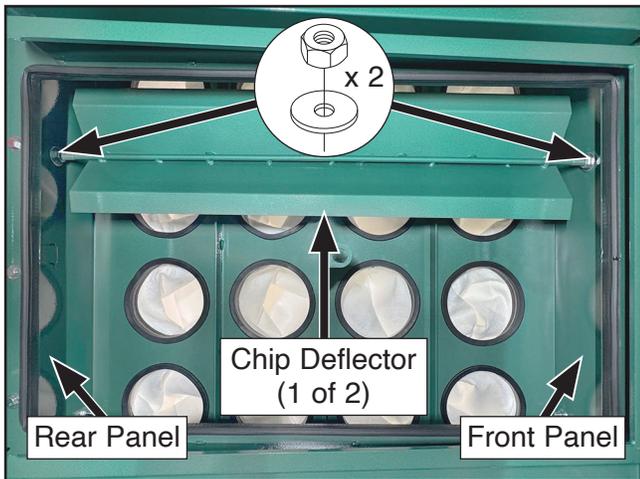


Figure 42. Left chip deflector installed (shown from underneath machine body facing upward).

30. Secure chip deflector to machine body with fasteners removed in **Step 27** (see **Figure 43**). Tighten until snug, but do not overtighten, as this may damage rubber gasket.

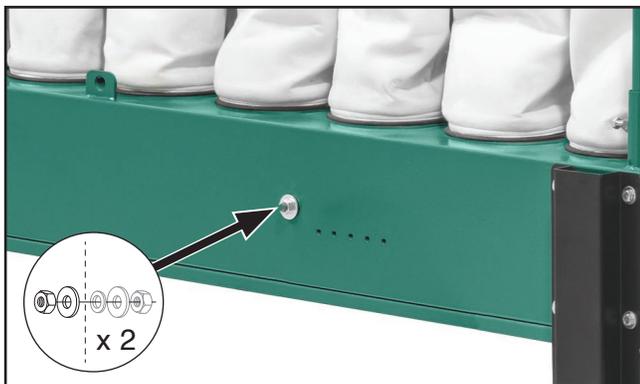


Figure 43. Location of outside chip deflector fasteners (rear machine body shown).

31. Repeat **Steps 27–30** for remaining chip deflector.

32. Attach (1) side drum panel to (1) front drum panel with (5) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " hex bolts, (10) $\frac{5}{16}$ " flat washers, and (5) $\frac{5}{16}$ "-18 hex nuts (see **Figure 44**).

Note: Ensure corner of front panel is positioned over outside of side panel, and hex bolt is on the inside of side drum panel.

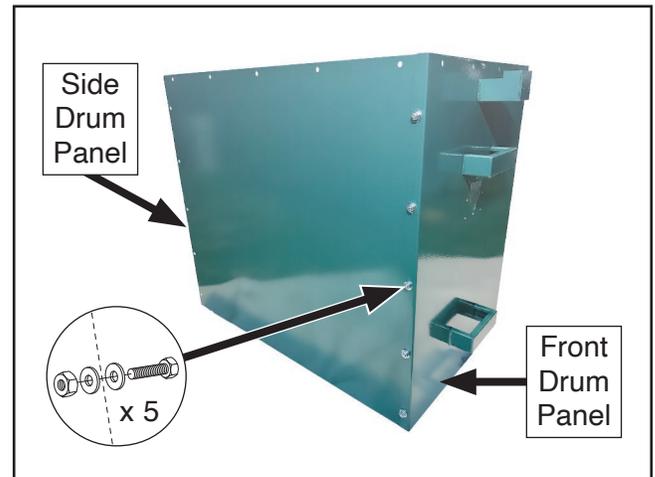


Figure 44. Side drum panel attached to front drum panel.

33. Attach (1) side drum panel to other side of front drum panel with (5) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " hex bolts, (10) $\frac{5}{16}$ " flat washers, and (5) $\frac{5}{16}$ "-18 hex nuts.

34. Attach (1) rear drum panel to side panels with (10) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " hex bolts, (20) $\frac{5}{16}$ " flat washers, and (10) $\frac{5}{16}$ "-18 hex nuts, as shown in **Figure 45**.

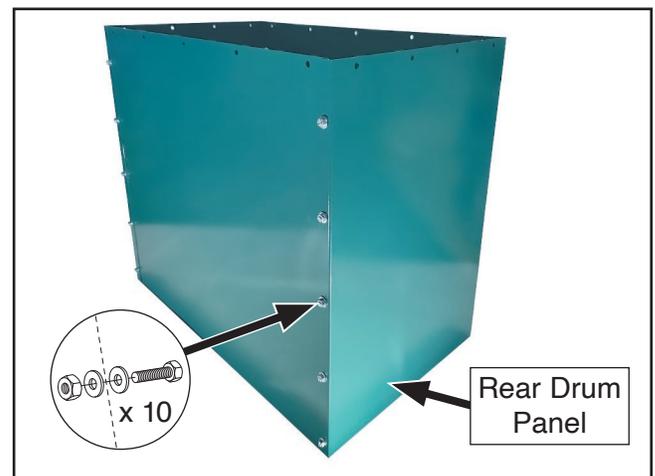


Figure 45. Rear drum panel attached to side drum panels.



35. Attach (1) drum rim to top of drum assembly with (18) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " hex bolts, (36) $\frac{5}{16}$ " flat washers, and (18) $\frac{5}{16}$ "-18 hex nuts (see **Figure 46**).

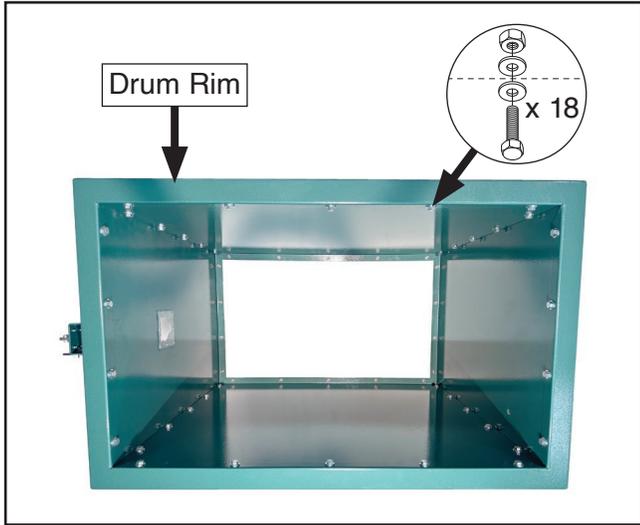


Figure 46. Drum rim attached to drum assembly.

36. Attach (4) swivel casters to (1) base drum panel with (16) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " hex bolts, (32) $\frac{5}{16}$ " flat washers, and (16) $\frac{5}{16}$ "-18 hex nuts (see **Figure 47**).

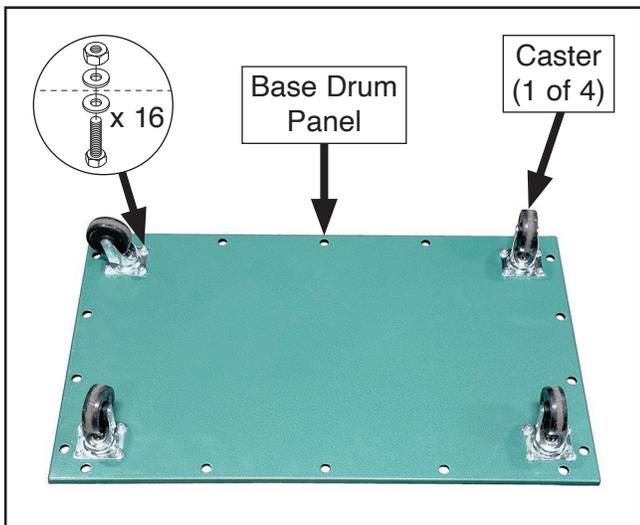


Figure 47. Casters attached to base drum panel.

37. Place drum assembly upside down on flat protected surface, then attach base drum panel to bottom drum assembly with (18) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " hex bolts, and (18) $\frac{5}{16}$ " flat washers (see **Figure 48**).

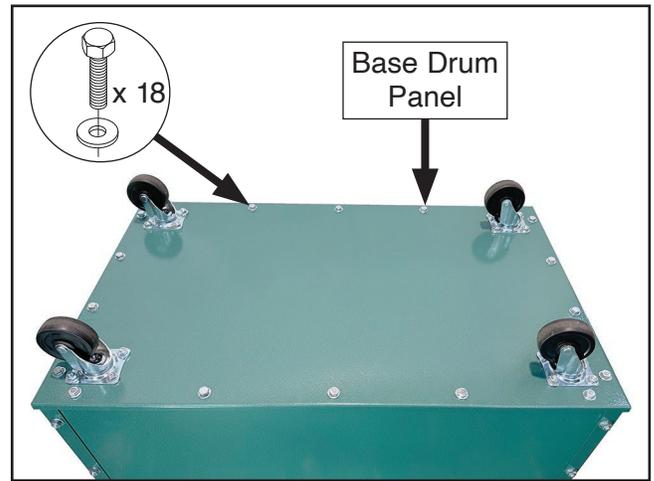


Figure 48. Base drum panel with casters attached to drum assembly.

38. Attach (1) latch to front of collection drum with (4) #10-24 x $\frac{3}{8}$ " Phillips head screws (see **Figure 49**).

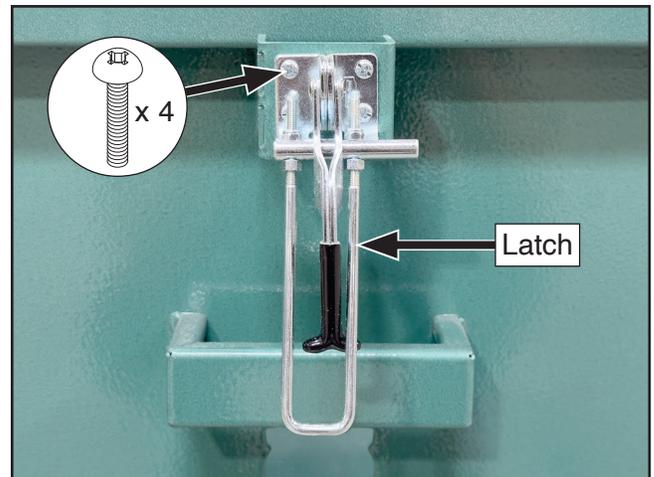


Figure 49. Latch attached to drum assembly



39. Attach (1) drum latch hook to front of collection drum with (1) 1/4"-20 x 5/8" hex bolt and (1) 1/4"-20 lock nut (see **Figure 50**). Do not over-tighten so drum latch hook can move freely.

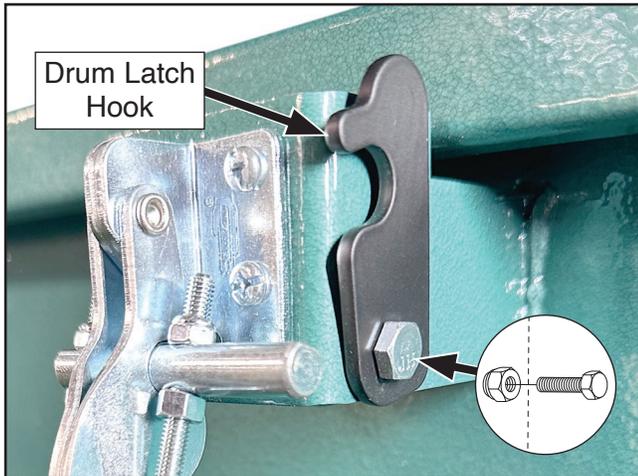


Figure 50. Drum latch hook attached to drum assembly.

40. Repeat **Steps 32–39** to assemble each of the remaining collection drums.
41. Install collection drum bags into each collection drum.
42. Attach (3) body latch hooks to front of machine body with (6) #10-24 x 3/8" Phillips head screws (see **Figure 51**).

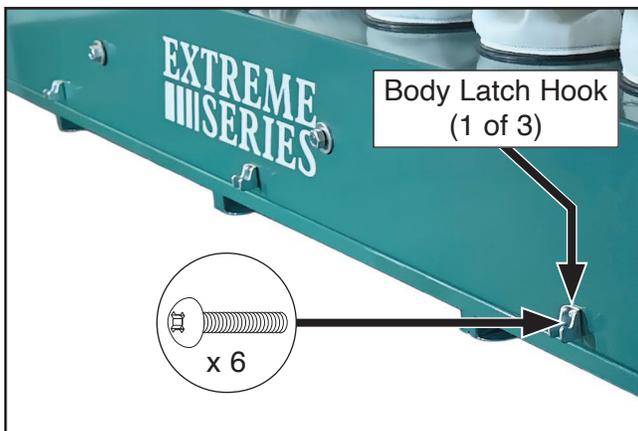


Figure 51. Body latch hooks attached to machine body.

43. Remove bottom plastic nut from (1) photoelectric sensor, then insert base of sensor through sensor holder under machine (see **Figure 52**).

Note: Sensor should only stick out roughly 5/8" below sensor holder hole, any more than that and it may make contact with collection drum and damage sensor.

44. Install bottom plastic nut (see **Figure 52**) removed in **Step 43**, and tighten until sensor is secure.

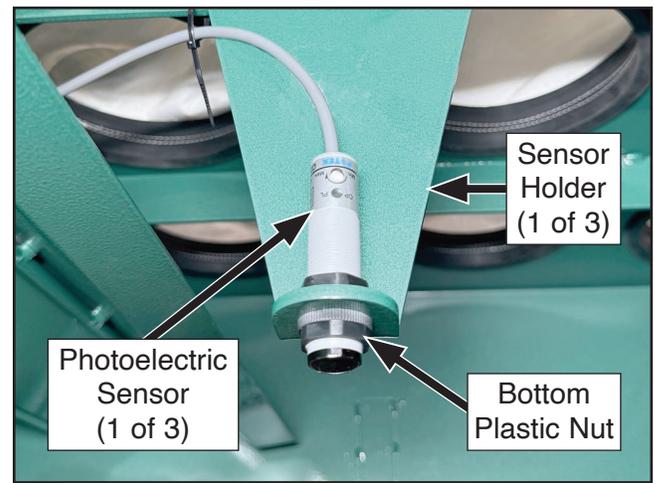


Figure 52. Photoelectric sensor installed in sensor holder.

45. Repeat **Steps 43–44** for each of the remaining photoelectric sensors.
46. Route photoelectric sensor cords through (3) holes in machine body (see **Figure 53**).

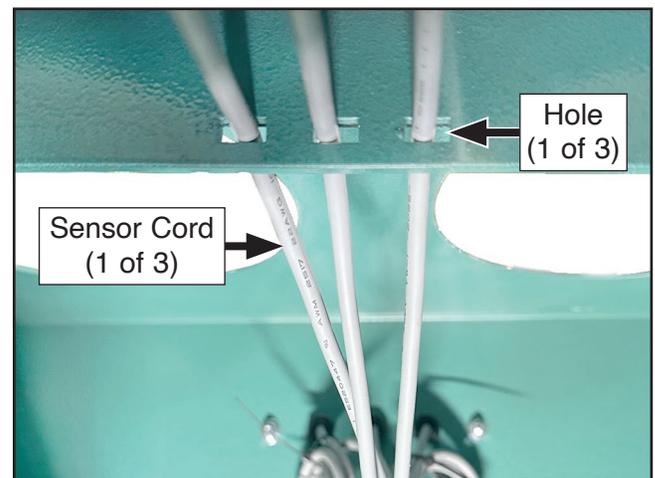


Figure 53. Photoelectric sensor cords routed through holes in machine body.



47. Use included cable ties to secure photoelectric sensor cords to machine body so cords will not interfere with collection drums.
48. Route photoelectric sensor cords through (3) holes in rear face of machine body, then secure with (3) M10-1.5 strain reliefs, as shown in **Figure 54**.

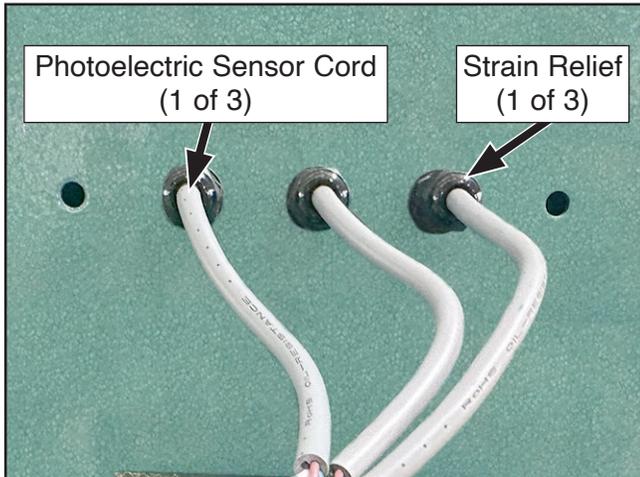


Figure 54. Photoelectric sensor cords secured to rear face of machine body with strain reliefs.

49. Route control box cord through hole in photoelectric sensor junction box, then secure with (1) M16-1.5 strain relief (see **Figure 55**).

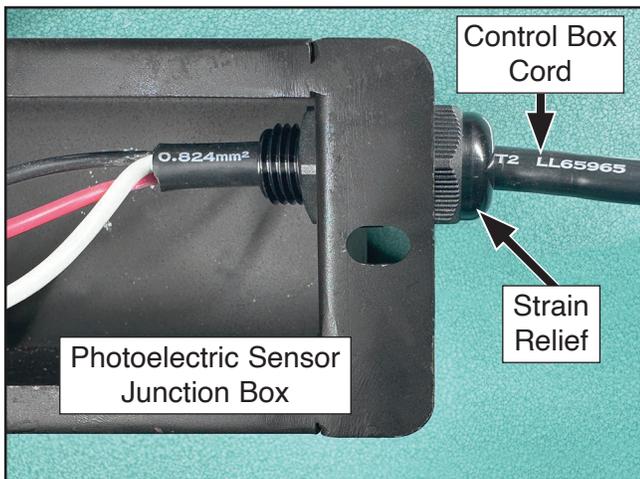


Figure 55. Control box cord secured to photoelectric sensor junction box with strain relief.

50. Connect wires from photoelectric sensor cords to control box cord wires, as illustrated in **Figure 57**.

- Connect (3) brown wires from sensors to (1) red wire with (1) wire nut.
- Connect (3) white wires from sensors to (1) white wire with (1) wire nut.
- Connect (3) blue wires from sensors to (1) black wire with (1) wire nut.

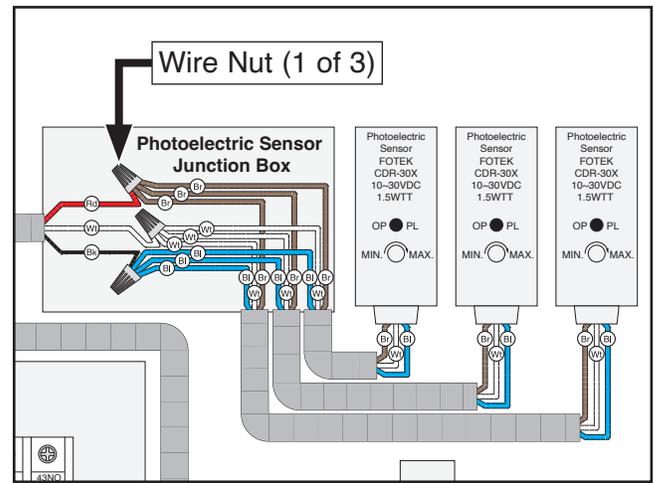


Figure 57. Photoelectric sensor wiring.

50. Wrap each wire nut with electrical tape (see **Figure 56**).

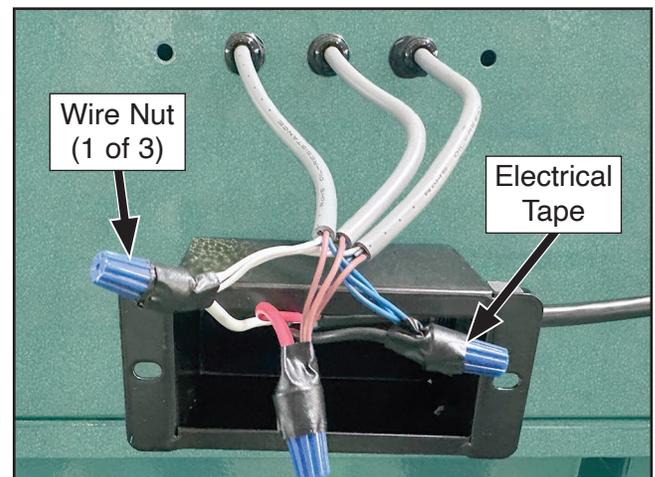


Figure 56. Wires and wire nuts wrapped in electrical tape.



51. Secure photoelectric sensor junction box to machine body with (2) #10-24 x 1/2" Phillips head screws, (4) #10 flat washers, and (2) #10-24 hex nuts (see **Figure 58**).

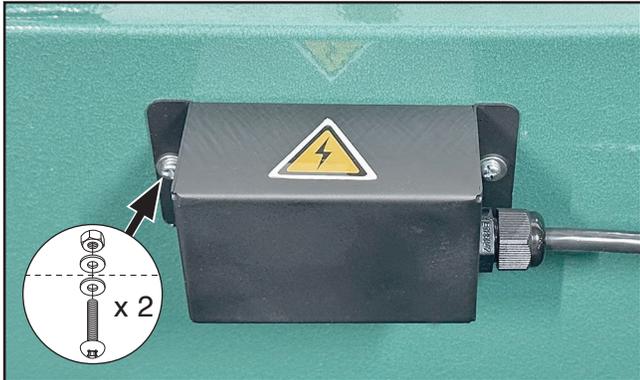


Figure 58. Photoelectric sensor junction box attached to machine body.

52. Install and latch collection drums.

Anchoring to Floor

Number of Mounting Holes 6
Diameter of Mounting Hardware..... 1/2"

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

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you **MUST** follow the anchoring methodology specified by the code.

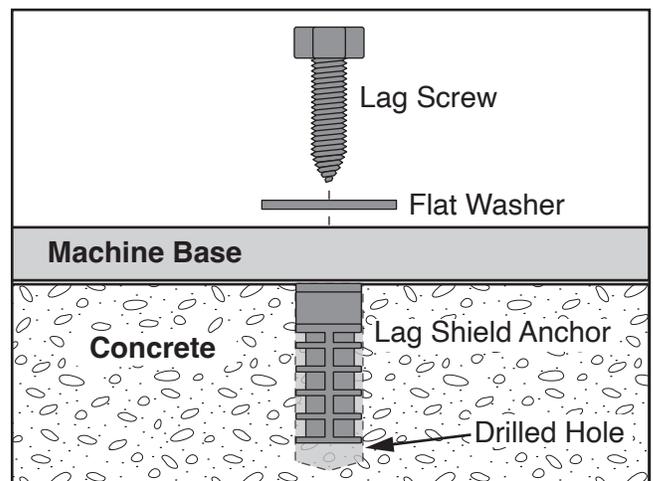
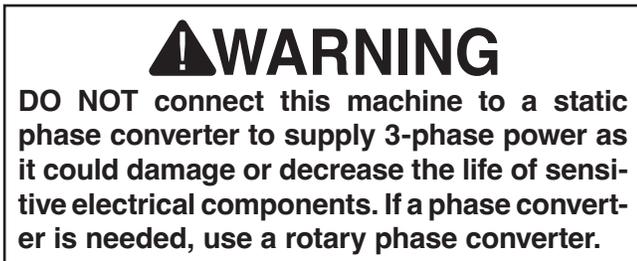
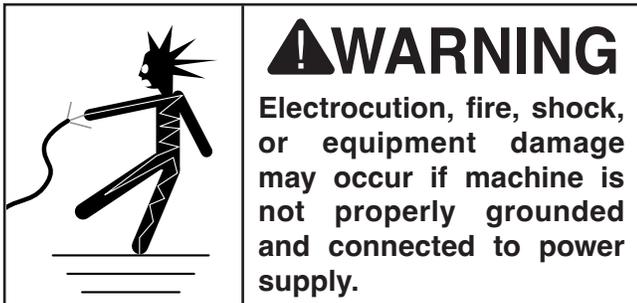


Figure 59. Popular method for anchoring machinery to a concrete floor.



Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.



IMPORTANT: Due to the complexity required for planning, bending, and installing the conduit necessary for a code-compliant hardwire setup, an electrician or other qualified person **MUST** perform this type of installation. Hardwire setups typically require power supply wires to be enclosed inside of a solid or flexible conduit, which is securely mounted at both ends with the appropriate conduit fittings.

Connecting Power Supply Wires



To connect power supply wires:

1. DISCONNECT HARDWIRED POWER SOURCE OR LOCK DISCONNECT SWITCH BOX IN OFF POSITION!
2. Remove (8) fasteners securing control panel (see **Figure 60**).



Figure 60. Location of control panel fasteners.

3. Lower and tilt control panel so wiring is facing you, then secure panel to control box with (3) fasteners removed in **Step 2** (see **Figure 61**).



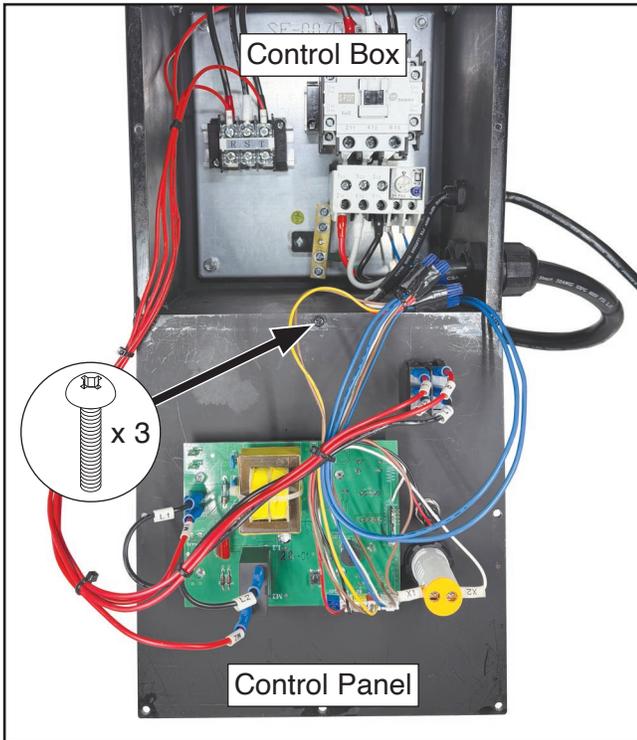


Figure 61. Control panel secured to control box.

4. Insert incoming power wires through open strain relief in control box (see **Figure 62**).

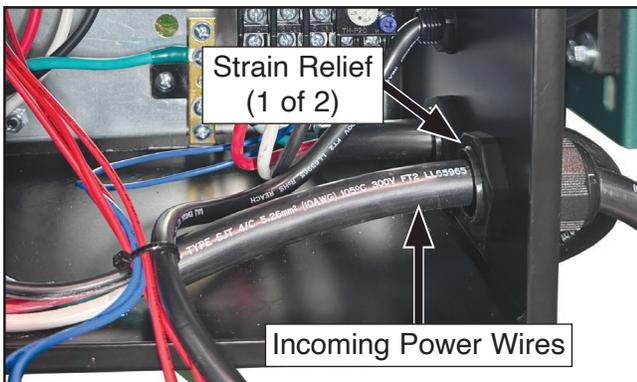


Figure 62. Location of strain relief and power wires in control box.

!WARNING

During next step, make sure incoming ground wire is connected to ground terminal to ensure machine will be properly grounded (see "Ground Terminal" in **Figure 63**). An ungrounded or improperly grounded machine can cause electrocution if live electrical wires make contact with frame or other parts touched by operator.

5. Connect incoming power wires to R, S, and T terminals on terminal bar, then connect ground wire to any available terminal on ground terminal bar (see **Figure 63**).

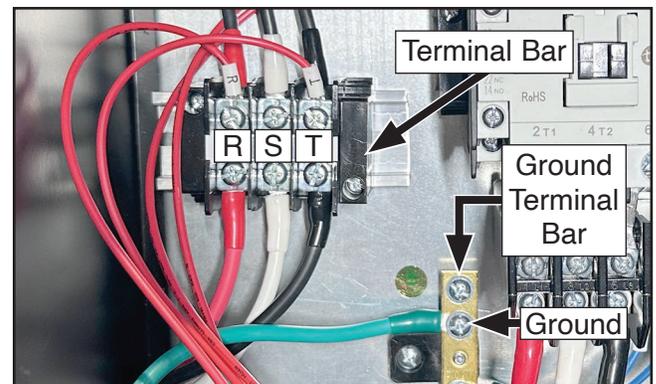


Figure 63. Location of R, S, T, and ground terminals.

6. Tighten strain relief to secure incoming power wires.
7. Remove (3) fasteners securing control panel to control box.
8. Lift control panel and secure to control box with (8) fasteners removed in **Step 2**.



Connecting to Power Source

Move the disconnect switch handle to the ON position, as illustrated below. The machine is now connected to the power source.

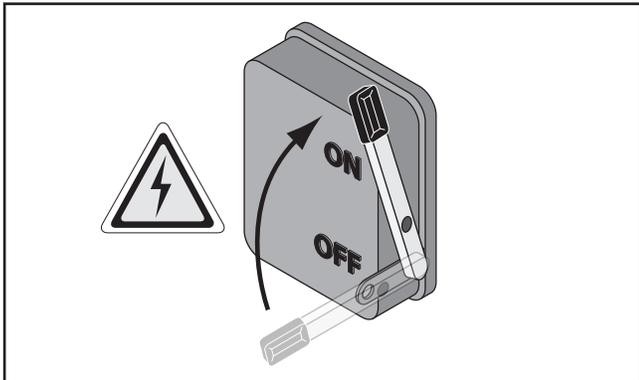


Figure 64. Connecting power to machine.

Disconnecting from Power Source

Move the disconnect switch handle to the OFF position, as illustrated below. The machine is now disconnected from the power source.

Note: Lock the switch in the OFF position to restrict others from starting the machine.

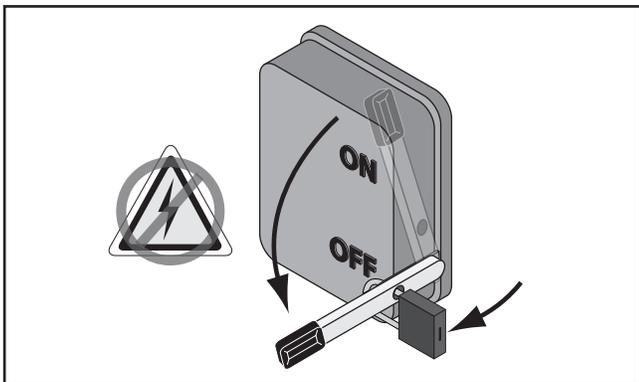


Figure 65. Disconnecting power from machine.

Correcting Phase Polarity

This section is provided for troubleshooting Model G0406 3-phase power connections. If you discover during the **Test Run** that the machine will not operate, or that the motor runs backwards, the power supply connection may be wired "out of phase," meaning the polarity of the incoming power wires is incorrectly wired. This is a common situation with 3-phase power and it is easy to correct.

To correct phase polarity:

1. DISCONNECT MACHINE FROM POWER!
2. Remove control panel.
3. Swap wires connected to **R** and **T** terminals (see **Figure 66**).

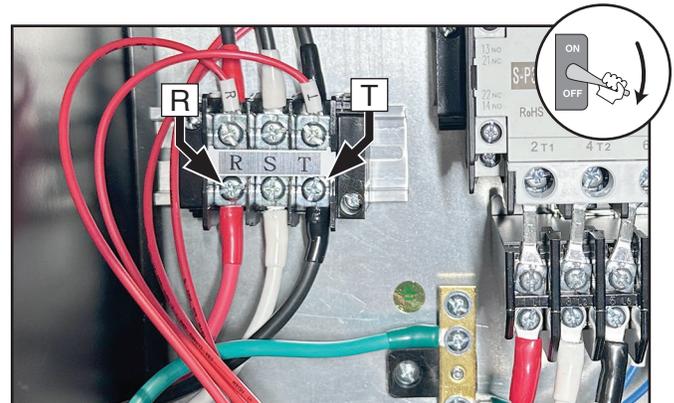


Figure 66. Location of R and T terminals.

4. Install control panel and reconnect machine to power.
5. Follow **Test Run** to ensure that machine functions properly.



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, 2) the power supply polarity is correct, and 3) 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 (see **Page 38** for information on designing a dust collection system).

NOTICE

DO NOT operate dust collector without first connecting it to a dust collection system. Otherwise, lack of airflow resistance will cause motor to operate at full amperage load, which could cause motor to overheat or trip the power supply circuit breaker.

3. Connect machine to power (see **Power Connection on Page 33**).
4. Move ON/OFF switch to ON position, then press ON/OFF button (see **Figure 67**) to turn motor **ON**.

— Dust collection indicator light should illuminate, and motor should run smoothly and without unusual problems or noises.

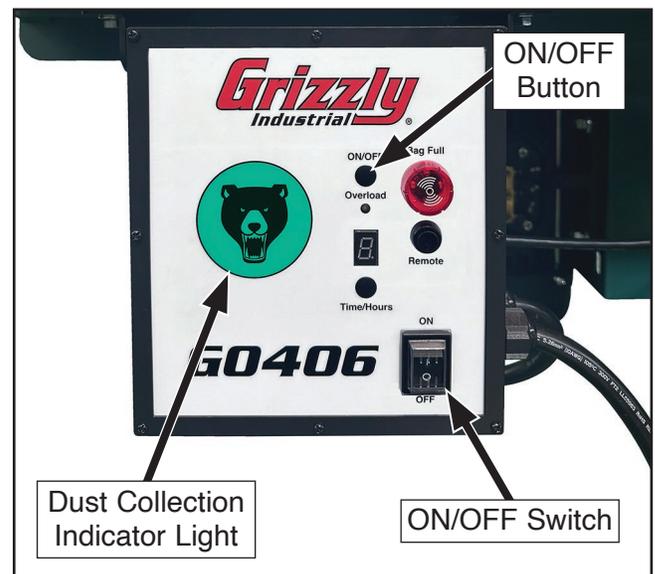


Figure 67. Location of control panel power components.



5. Observe motor fan through motor cover (see **Figure 68**).
 - If motor fan rotates *clockwise* when viewed from below, power supply polarity is correct. Proceed to **Step 6**.
 - If motor fan rotates *counterclockwise* when viewed from below, stop machine. Phase polarity of incoming power is reversed and needs to be corrected. See **Correcting Phase Polarity** on **Page 35** to correct polarity before proceeding with test run.

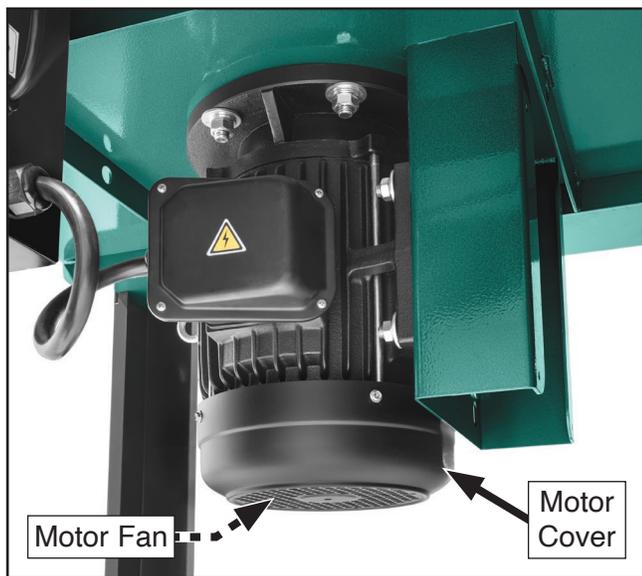


Figure 68. Location of motor components.

6. Press ON/OFF button to turn motor **OFF**.

7. Pair remote as instructed in **Pairing Remote Control** on **Page 48**.
8. Press A button on remote control to turn motor **ON** (see **Figure 69**).
9. Press B button to turn motor **OFF** (see **Figure 69**).
 - If motor does not turn **OFF** with remote control, press OFF button on control panel to turn motor **OFF**. Refer to **Troubleshooting** on **Page 55** to correct any problems with remote control before further using it with machine.



Figure 69. Remote control components.

Congratulations! Test Run is complete.



SECTION 4: DESIGNING A SYSTEM

General

⚠ CAUTION

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



⚠ CAUTION

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

The Model G0406 is designed for industrial applications. It will accommodate several machines simultaneously, but the exact number of machines that can be connected at one time depends upon the machine type, dust port size, and layout.

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.

Duct Material

You have many choices regarding main line and branch line duct material. For best results, use smooth 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 not properly grounded to prevent static electrical buildup (refer to **System Grounding** at the end of this section). Another problem with using plastic duct is that it is less efficient per foot than metal.



⚠ CAUTION

Plastic duct generates static electrical buildup that can cause fire or shock. Properly ground it to reduce this risk.

Plastic Duct

The popularity of plastic duct is due to the fact that it is an economical and readily available product. 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 buildup.



Figure 70. Examples of plastic ducting components.



Metal Duct

Advantages of metal ducting are its conductivity, efficiency, 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 ducting is a conductor, it can be grounded quite easily to dissipate any static electrical charges.

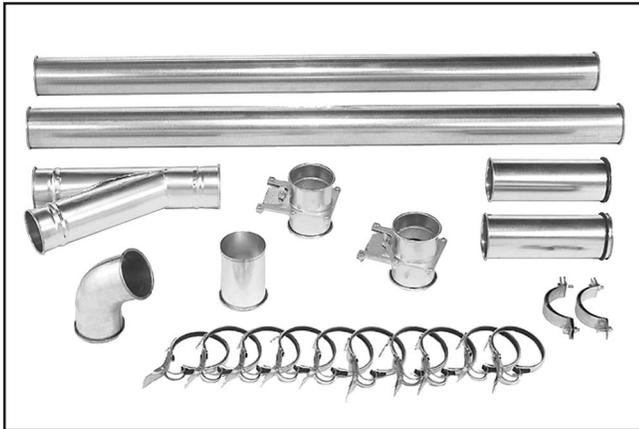


Figure 71. Examples of metal pipe and components.

There are 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 in a different configuration. This is especially important if you ever need to change things around in your shop or add more tools.

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 ducting is generally used for short runs, small shops and at rigid duct-to-tool connections. There are many different types of flexible ducts 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 here is flexible metal ducting that is designed to be flexible, yet be as smooth as possible inside to reduce static pressure loss.

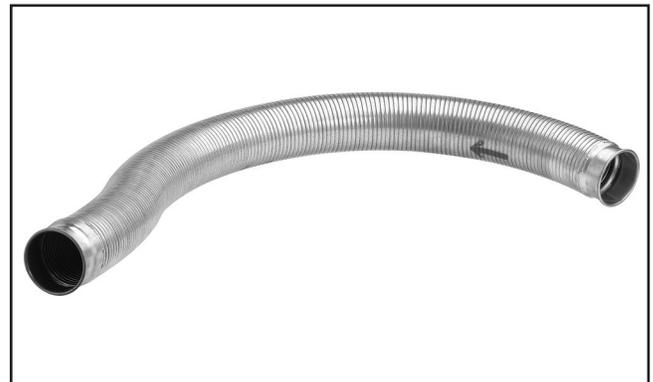


Figure 72. Example of flexible metal duct.

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, while being completely flexible, is non-resistant to abrasion and has a tendency to collapse in a negative pressure system. We DO NOT recommend using dryer vent hose in your dust collection system.

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 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.



System Design

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 basic design.

If you have a large shop or plan to design a complicated system, we recommend doing additional research beyond this manual or seeking the help of an expert.

Sketch Your Shop Layout

When designing a successful dust collection system, planning is the most important step. In this step, sketch a basic layout of your shop, including space requirements of different machines.

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

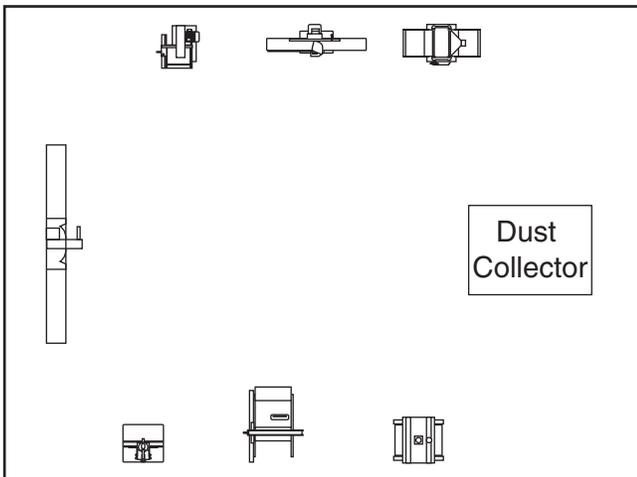


Figure 73. Basic sketch of shop layout.

Sketch a Basic Duct Layout

For the next step, sketch how you will connect your machines to the dust collector. Consider these general guidelines for an efficient system:

- Machines that produce the most saw dust should be placed nearest to the dust collector (i.e. planers and sanders).
- Ideally, you should design the duct system to have the shortest possible main line and secondary branch ducts. See the figures below for a comparison of efficient versus inefficient duct layouts.

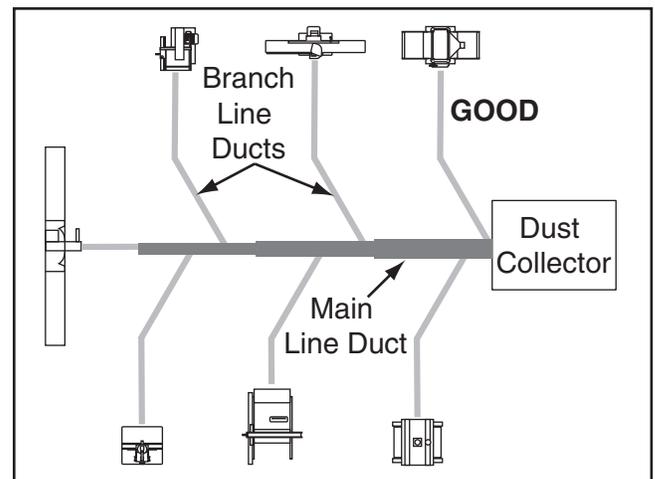


Figure 74. Efficient duct layout.

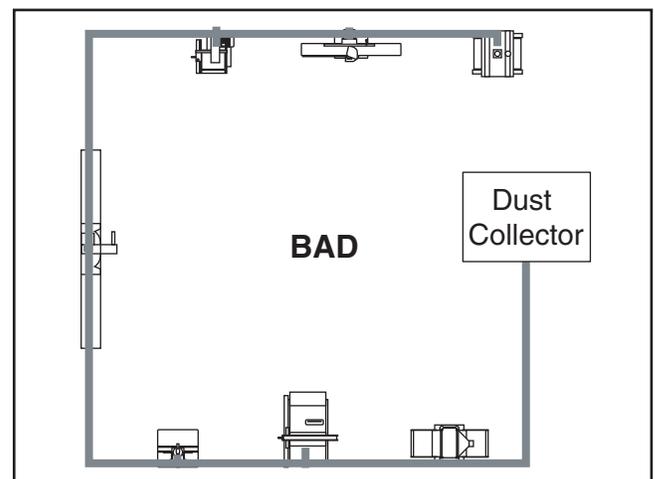


Figure 75. Inefficient duct layout.



- Directional changes should be kept to a minimum. The more directional change fittings you use directly increases the overall resistance to airflow.
- Gradual directional changes are more efficient than sudden directional changes (i.e. use the largest corner radius possible when changing hose or pipe direction).
- Each individual branch line should have a blast gate immediately after the branch to control suction from one machine to another.
- The simpler the system, the more efficient and less costly it will be.

Determine Required CFMs

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"	100
2.5"	150
3"	250
4"	400
5"	600
6"	850
7"	1200
8"	1600
9"	2000
10"	2500

Figure 76. 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.....	4"
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"
Shaper.....	4"
Router (mounted to table).....	2"
Bandsaw.....	4"
Lathe.....	4"
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 77. Dust port size and quantity per average machine.

Write the required CFM for each machine on your sketch, as shown in the figure below.

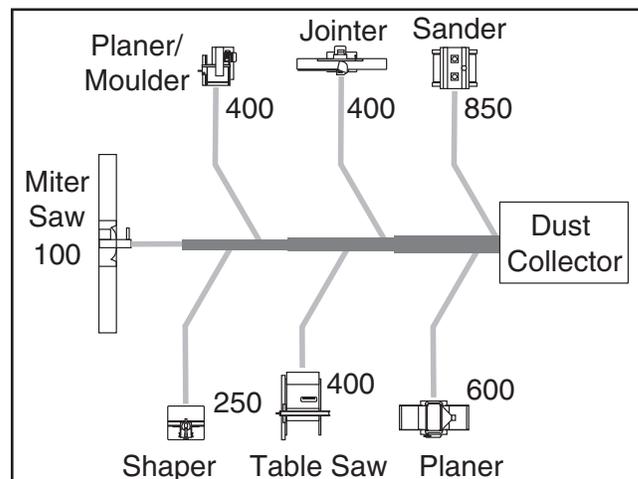


Figure 78. CFM requirements labeled for each machine.



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.

For small/medium sized shops, using the inlet size of the dust collector as the main line duct size 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.

Mark your drawing, as shown in the figure below, but using the inlet size for your dust collector as the main line.

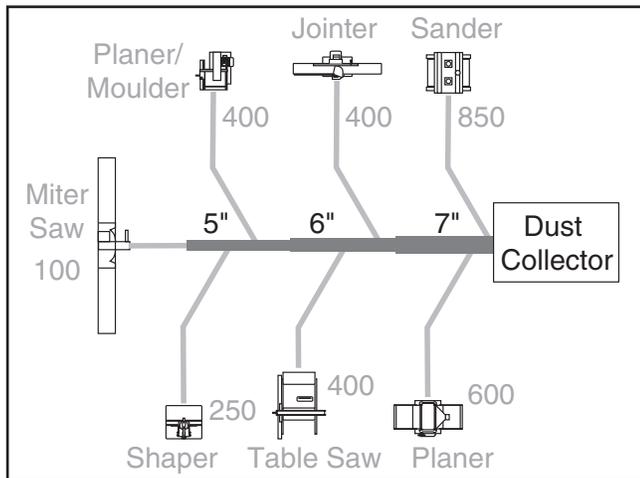


Figure 79. Main line size labeled on sketch.

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 neck the line down 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 the following figure.

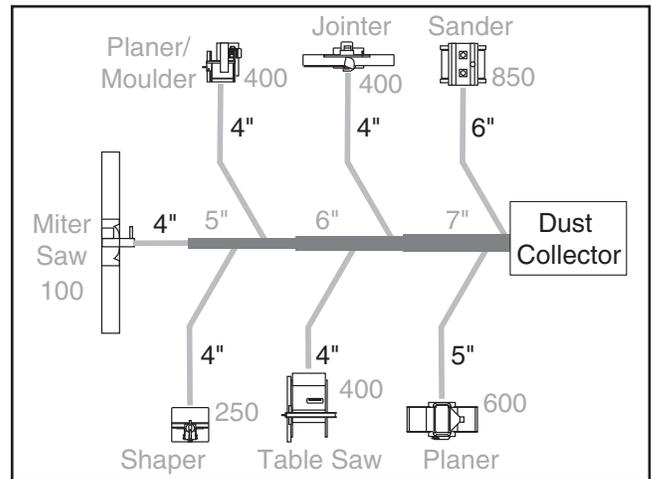


Figure 80. Branch line duct sizes labeled.

If two machines will connect to the same branch line and both will operate at the same time, then add the required CFM for each machine together and find the closest total CFM in the table below to determine the correct branch size.

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

Total CFM	Branch Line Size
400	4"
500	4"
600	5"
700	5"
800	6"
900	6"
1000	6"

Figure 81. Sizing chart for multiple machines on the same branch line.



Planning Drop Downs

Plan the drop downs for each machine, using blast gates wherever possible to control airflow.

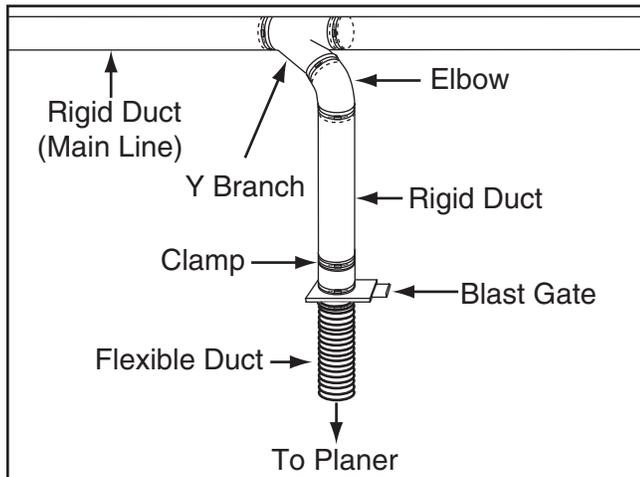


Figure 82. Drop down setup.

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) duct and gradual curves, as opposed to flexible duct 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 duct) and has a lot of sharp turns (90° elbows), it will take a lot more effort to travel from one end to the other.

The purpose of calculating the resistance is to determine if the resistance is low enough so the airflow at the machine will meet the given CFM requirement of the machine. Use the following tables to calculate the resistance of duct work.

Duct Dia.	Approximate Static Pressure Loss Per Foot of Rigid Duct		Approximate Static Pressure Loss Per Foot of Flexible Duct	
	Main Lines at 3500 FPM	Branch Lines at 4000 FPM	Main Lines at 3500 FPM	Branch Lines at 4000 FPM
2"	0.091	0.122	0.35	0.453
2.5"	0.08	0.107	0.306	0.397
3"	0.071	0.094	0.271	0.352
4"	0.057	0.075	0.215	0.28
5"	0.046	0.059	0.172	0.225
6"	0.037	0.047	0.136	0.18
7"	0.029	0.036	0.106	0.141
8"	0.023	0.027	0.08	0.108
9"	0.017	0.019	0.057	0.079

Fitting Dia.	90° Elbow	45° Elbow	45° Wye(Y)	90° Wye(Y)
3"	0.47	0.235	0.282	0.188
4"	0.45	0.225	0.375	0.225
5"	0.531	0.266	0.354	0.236
6"	0.564	0.282	0.329	0.235
7"	0.468	0.234	0.324	0.216
8"	0.405	0.203	0.297	0.189

Figure 83. Static pressure loss charts.

In most small/medium shops it is only necessary to calculate the line 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).

To calculate the static pressure 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 value given in the previous table.
2. List each type of elbow or branch and multiply the quantity (if more than one) by the static pressure loss given in the previous table.



3. Add the additional factors from the following table to your list.

Additional Factors	Static Pressure
Seasoned (well used) Dust Collection Filter	1"
Entry Loss at Large Machine Hood	2"

Figure 84. Additional factors affecting static pressure.

4. Total your list, as shown in the example below, to come up with your overall static pressure loss number for that line.

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

Main Line		
6" Rigid Duct (0.037) at 20'	0.740
Branch Line		
4" Rigid Duct (0.075) at 10'	0.750
4" Flexible Duct (0.28) at 5'	1.400
Elbows/Branches		
6" 45° Y-Branch	0.329
4" 45° Elbow	0.225
Additional Factors		
Seasoned Filter	<u>1.000</u>
Total Static Pressure Loss	4.444

Figure 85. Totaling static pressure numbers.

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 **Figure 86** for your dust collector.

Example: A typical **Performance Curve** is illustrated in **Figure 86**. Find 4.4 on the Static Pressure axis (the amount of total static pressure loss calculated in **Figure 85**), then refer to the closest value on the CFM axis—approximately 1120 CFM.

The 1120 CFM for the static pressure loss of the line connected to the router is well above the 220 CFM requirement of that machine.

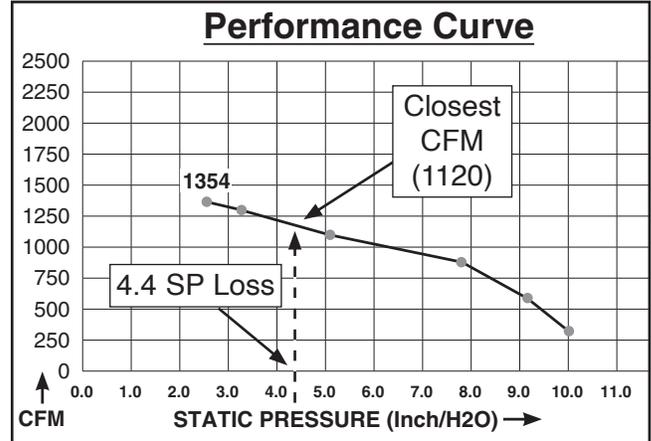


Figure 86. Example CFM for static pressure loss of line connected to a dust collector & router.

- 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 49** 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.

NOTICE

Refer to G0406 Performance Curve on Page 45 for data related to designing a dust collection system for the Model G0406.



G0406 Performance Curve

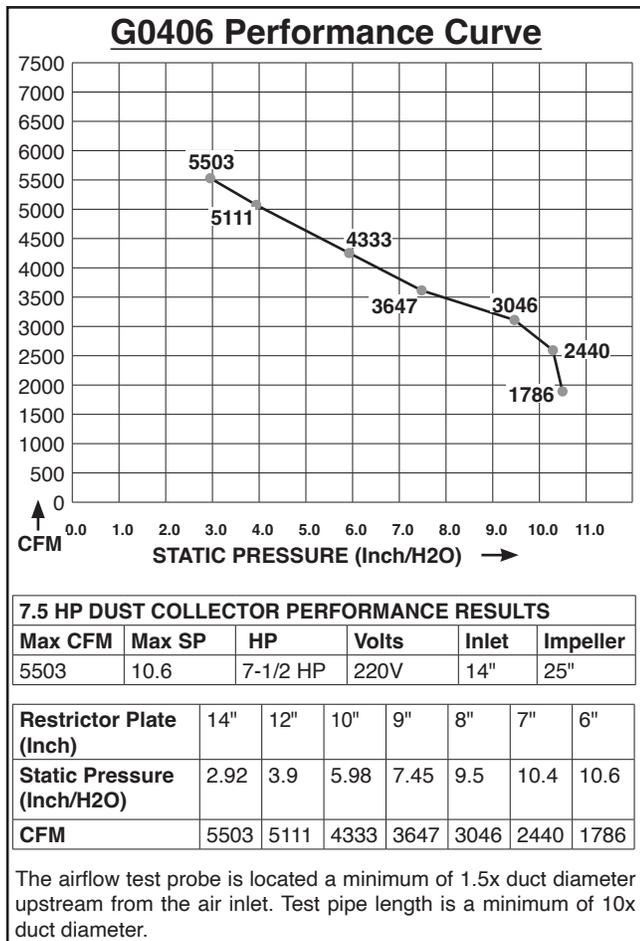


Figure 87. G0406 performance curve table.

Example Materials List

After the system is designed, create a materials list of all the items you will need to build your dust collection system. This will make it easy when it comes time to purchase the materials.

Below is an example of some items that might be needed. Refer to **Accessories** for dust collection components available through grizzly.com.

Description	Model	Quantity
6" Rigid Duct at 5'	G7364	4
4" Rigid Duct at 5'	G6162	2
4" Flex Hose at 5'	H7215	6
6" 45° Y-Branch	G7353	6
4" 45° Elbow	G6167	6

Figure 88. Example materials list.

System Grounding

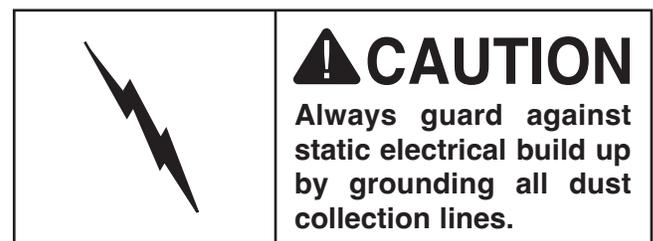
Since plastic hose is abundant, relatively inexpensive, easily assembled and air tight, it is a very popular material for conveying dust from woodworking machines to the dust collector.

We recommend only using short lengths of flexible hose (flex-hose) to connect the woodworking machine to the dust collector. However, plastic flex-hose and plastic duct are an insulator, and dust particles moving against the walls of the plastic duct create a static electrical buildup. This charge will build until it discharges to a ground.

If a grounding medium is not available to prevent static electrical buildup, 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 buildup 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.

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

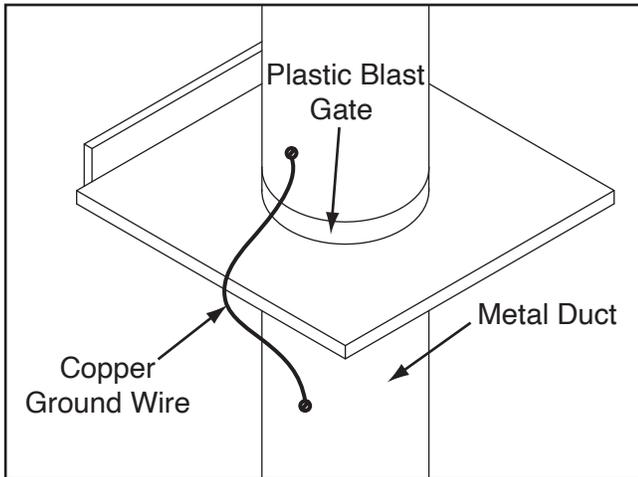


Figure 89. Ground jumper wire when using plastic blast gates and metal duct.

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.

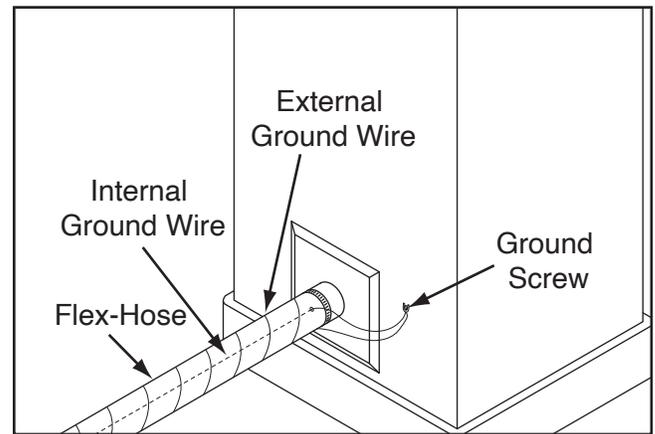


Figure 90. Flex-hose grounded to machine.

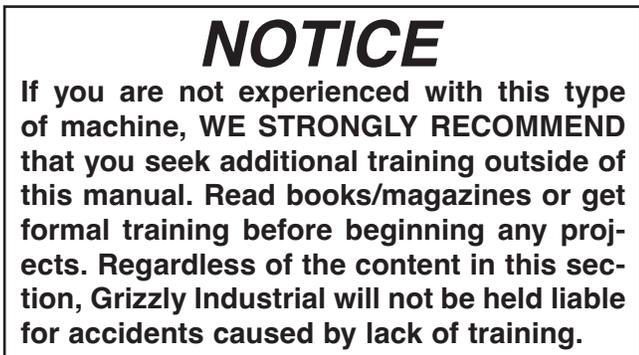
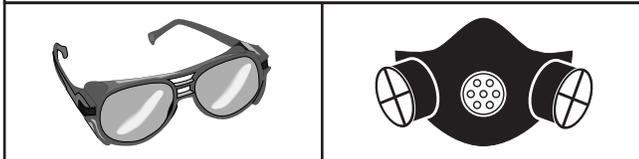


SECTION 5: OPERATIONS

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.



General Operation

This baghouse dust collector extracts heavy wood chips and dust particles during woodworking operations. Large wood chips and heavy dust are dropped into the three steel drums lined with plastic collection bags.



Figure 91. Dust collector operation.

The remaining fine dust travels past the impeller and is caught by the (36) dust collection bags hanging above the machine body. The (36) filter bags catch 99.9% of particles 0.2–2 microns in size.

To maintain CFM during heavy dust collection, occasionally swing the filter cleaning handle back and forth to knock excess dust buildup from filter bags.



Pairing Remote Control

The included remote control requires one 12V A27 battery and has a range of approximately 50 feet. The receiver and remote control must be paired when the batteries are changed, or if the remote control begins to function erratically.

Up to five remote controls can be paired with the machine at any one time. The pairing process is the same for each additional remote.

To pair remote control:

1. Move ON/OFF switch to ON position.
2. Press and hold Remote button on control panel (see **Figure 92**) until it beeps twice to signal control panel is in pairing mode. Continue to hold Remote button through the next step.

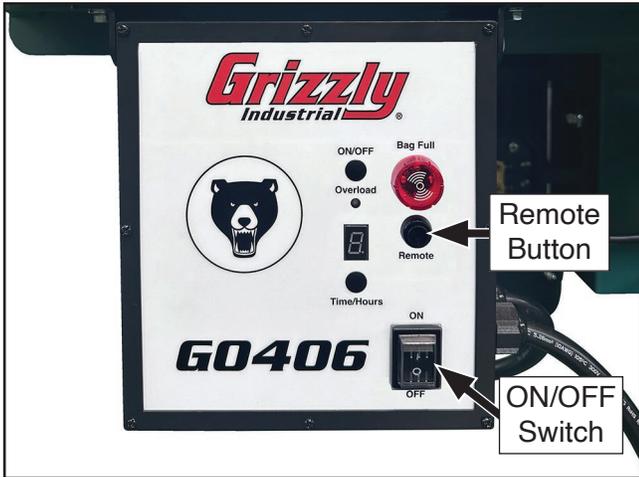


Figure 92. Location of Remote button on control panel.

3. Simultaneously press and hold D button on remote control and Remote button on control panel (see **Figure 93**) until remote beeps (3) times. Remote should now be paired.
4. Test connection by pressing A button to turn motor **ON**, then press B Button to turn motor **OFF** (see **Figure 93**).

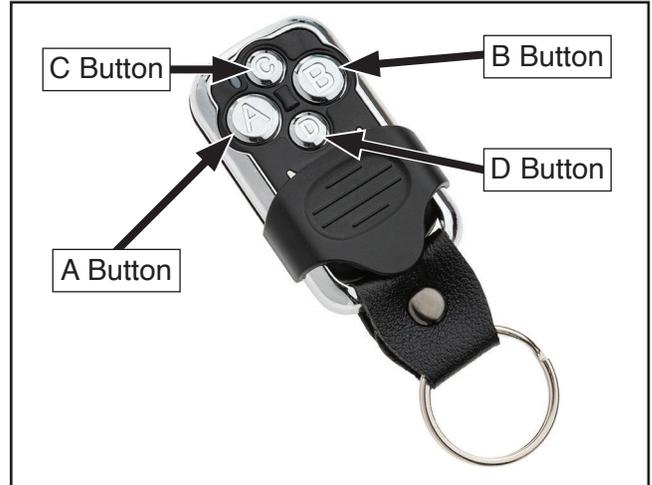


Figure 93. Location of remote control buttons.



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.

W1050—Dust Collection Basics Book

This incisive book skillfully guides the woodworker through all the steps necessary in the design and construction of an efficient central dust-collection system and tells you what you need to know for easy installation. 64 pages.

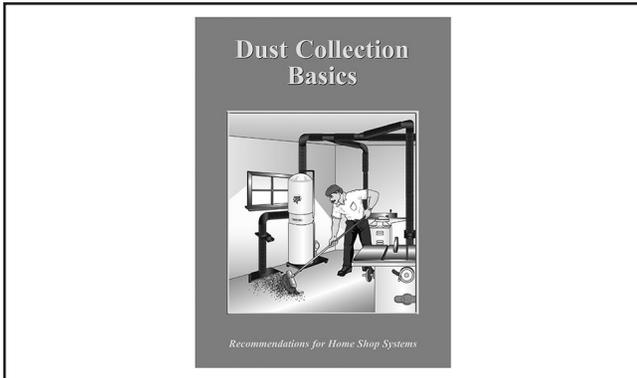


Figure 94. W1050 Dust Collection Basics Book.

H7217—6" x 5' Rigid Flex Hose

H7218—7" x 5' Rigid Flex Hose

H7219—8" x 5' Rigid Flex Hose

These rigid flex hoses with rolled collars provide just enough flexibility to make difficult connections while still keeping the inside wall smooth.

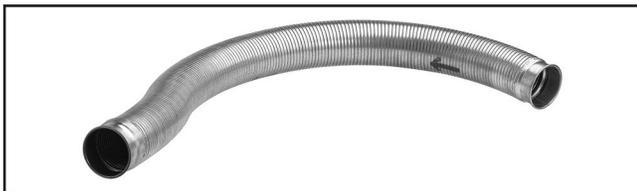


Figure 95. Rigid flex hose.

T34637—Replacement Filter Bag

This replacement filter bag captures 99.9% of 1-micron particles.

T34638—Collection Bag



Figure 96. Replacement collection bags.

D4206—Clear Flexible Hose 4" x 10'

D4256—45° Elbow 4"

W1317—Wire Hose Clamp 4"

W1007—Plastic Blast Gate 4"

W1017—90° Elbow 4"

W1053—Anti-Static Grounding Kit



Figure 97. 4" dust-collection accessories.

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



- 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**

Control air flow and resistance between machines. These industrial blast gates can take the abuse of thousands of open and close cycles. Made specifically for production shops. These metal industrial dust collection fittings are simply the best you can find.



Figure 98. Metal blast gate assortment.

W1039—Universal Adapter

This adapter provides a multitude of reducing options. Simply cut off unneeded steps. Outside diameter sizes include 1", 2", 2.5", 3", 4", 5", and 6". Wall thickness is 1/8".



Figure 99. W1039 Universal Adapter.

- H5293—4" 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.

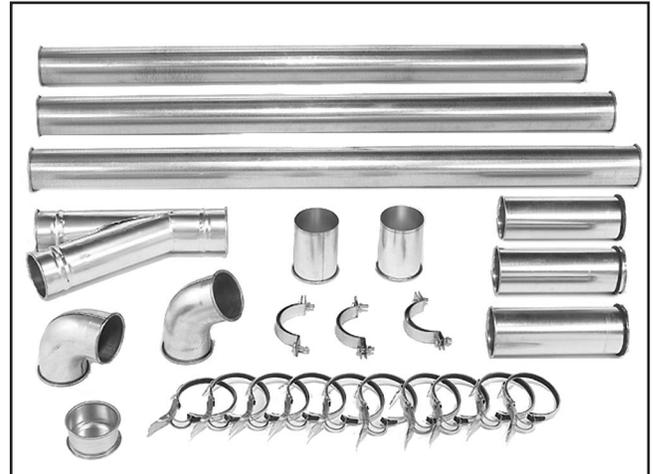


Figure 100. Metal duct starter kit.

- H5294—4" 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.

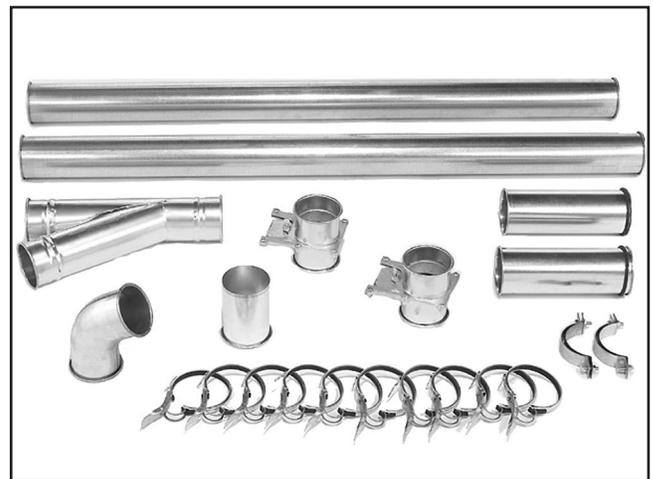
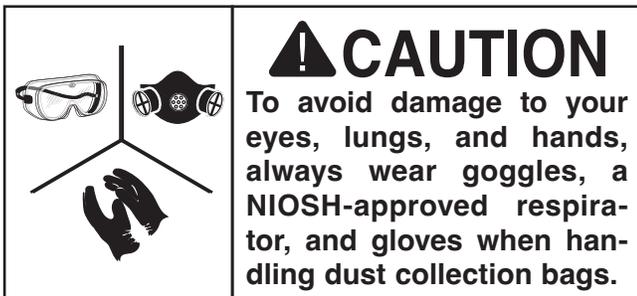
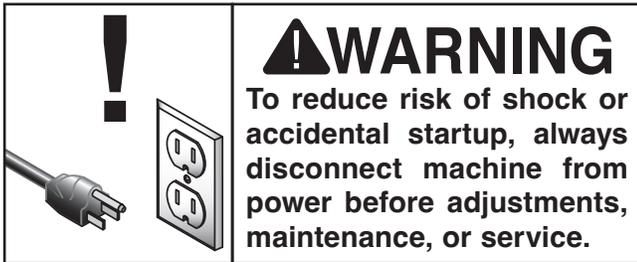


Figure 101. Metal duct machine addition kit.

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



SECTION 7: MAINTENANCE



Schedule

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

Ongoing

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

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

Monthly Check

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

Cleaning Filter Bags

This dust collector uses a manual filter cleaning assembly to remove dust buildup and debris from the filter bags. This filter cleaning assembly is controlled by the filter cleaning handle shown in Figure 102.



Figure 102. Location of filter cleaning handle.

Swing the filter cleaning assembly back and forth 3–4 times to knock built up dust from the filter bags. The particles will fall into the three collection drums below the machine body.

Note: If cleaning the filter bags does not improve CFM performance to the machine, filter bags may need to be replaced.



Replacing Filter Bags

Remove and replace filter bags when cleaning no longer improves CFM or if a filter bag becomes damaged.

Items Needed	Qty
Additional Person	1
Goggles (per person)	1 Pr.
Respirator (per person)	1
Wrench or Socket 15mm	1
Ladder	1
Vacuum w/HEPA Filter	1
Filter Bags (T34637).....	As Needed
Disposable Gloves	As Needed



CAUTION
To avoid damage to your eyes, lungs, and hands, always wear goggles, a NIOSH-approved respirator, and gloves when handling dust collection bags.

To replace filter bags:

1. DISCONNECT MACHINE FROM POWER!

2. Disconnect filter seals (see **Figure 103**) from machine body.

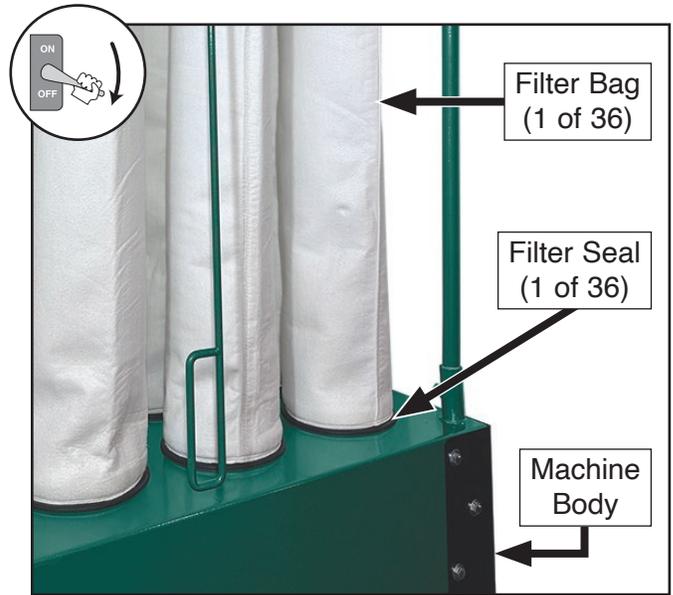


Figure 103. Location of filter seals.

3. Remove hex bolts securing filter support rod to filter support frame (see **Figure 104**), then slide filter bags off support rod.

Note: We recommend replacing filters on one support rod at a time.

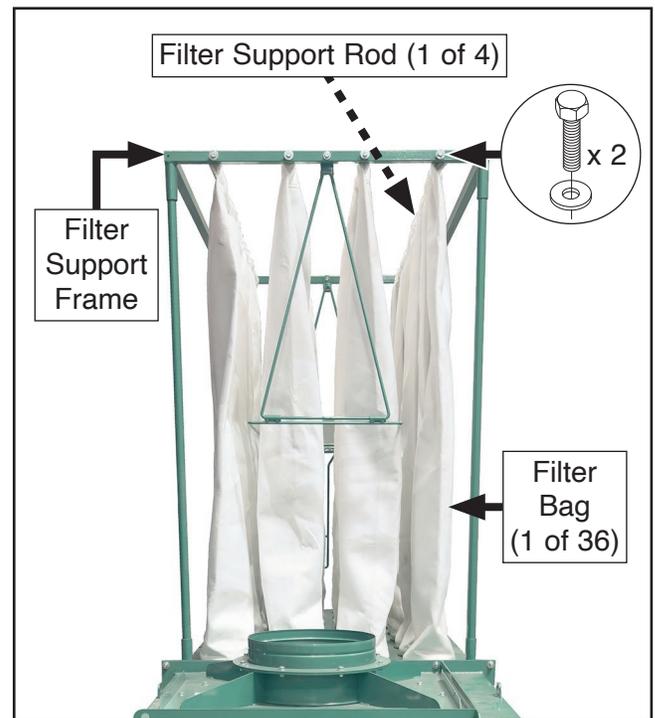


Figure 104. Location of filter support rod components.



4. Slide replacement filter bag(s) on support rod (nine per rod), then secure support rod to filter support frame with fasteners removed in **Step 3**.
5. Repeat **Steps 3–4** for remaining support rods.
6. Secure rubber seal of each filter bag to machine body. Ensure seal is seated properly in hole (see **Figure 103**).

TIP: *Fold seal in half and stick all the way into hole in machine body, then slowly pull upper lip of seal over edge of machine body.*

NOTICE

An improper seal may result in decreased filter efficiency, expulsion of sawdust, and strain on motor. Ensure all filter bags are properly sealed before operating.

Replacing Collection Drum Bag

Dispose of the collection drum bag when the bag full indicator has activated. Replace the bag if it develops a leak or becomes damaged.

IMPORTANT: To contain wood dust and minimize risk of exposure, tie bag closed before disposal.

Items Needed	Qty
Goggles	1 Pr.
Respirator	1
Collection Drum Bag (T34638).....	As Needed
Disposable Gloves	As Needed

	<p style="text-align: center;">⚠ CAUTION</p> <p>To avoid damage to your eyes, lungs, and hands, always wear goggles, a NIOSH-approved respirator, and gloves when handling dust collection bags.</p>
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To replace collection drum bag:

1. DISCONNECT MACHINE FROM POWER!
2. Lift drum latch hook to unlock collection drum latch (see **Figure 105**).

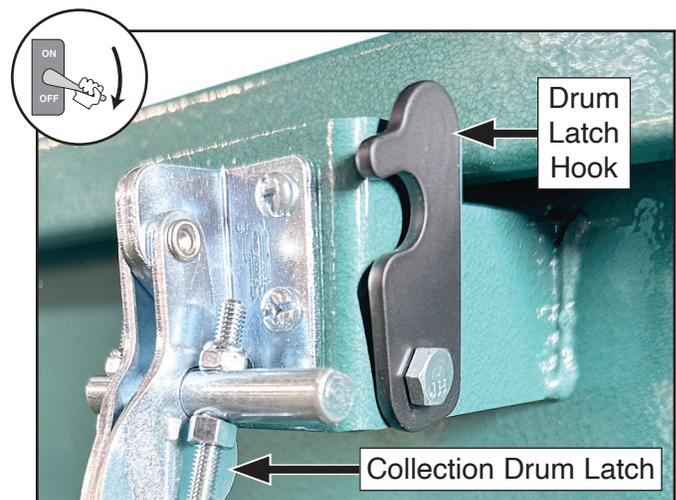


Figure 105. Location of drum latch hook.



- Lift collection drum latch (see **Figure 106**) to release latch from body latch hook, then remove collection drum from under machine.

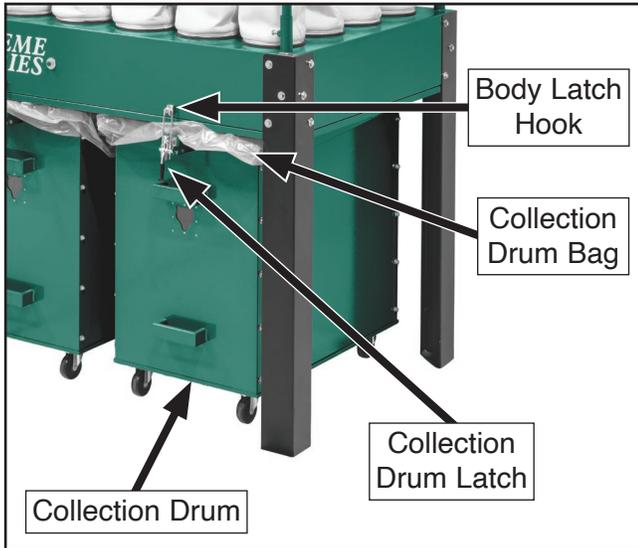


Figure 106. Collection drum components.

- Lift collection bag out of drum, firmly tie closed, then dispose of bag.
- Place new collection drum bag inside collection drum, and fold excess bag length over top edge of drum.
- Position collection drum under machine body, then fasten collection drum latch to body latch hook and push down to lock in place.
- Lower drum latch hook over collection drum latch to secure.

Adjusting Photoelectric Sensor

The photoelectric sensors on the Model G0406 can be set depending on the operators preferences. Adjusting the sensor sensitivity correlates to how full the collection drums will get before activating the bag full indicator.

Use a sensor key or 1/8" flat head screwdriver to rotate the adjustment dial (see **Figure 107**) on the front of the photoelectric sensor.

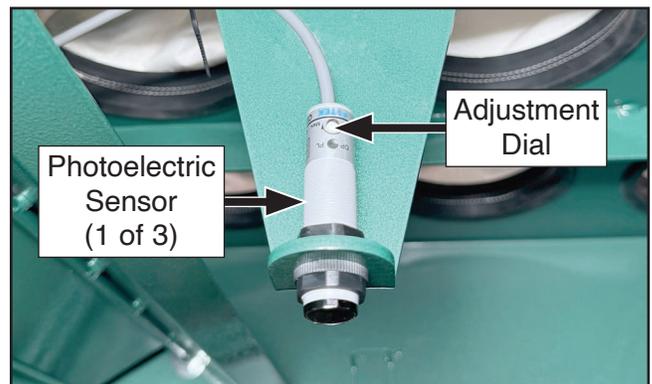


Figure 107. Location of photoelectric sensor adjustment dial.

- Rotate *clockwise* to increase photoelectric sensitivity so sensor activates when drum is *less* full.
- Rotate *counterclockwise* to decrease photoelectric sensitivity so sensor activates when drum is *more* full.

NOTICE

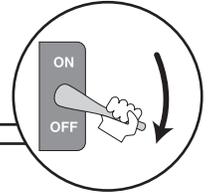
To prevent collection drum bag from overflowing and clogging filters, we recommend replacing bags when collected dust reaches 75% of total bag capacity.



SECTION 8: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. Photoelectric sensor tripped. 2. Incorrect power supply voltage or circuit size. 3. Remote control improperly paired/not working. 4. Power supply circuit breaker tripped or fuse blown. 5. Motor wires connected incorrectly. 6. Thermal overload relay has tripped. 7. Wiring broken, disconnected, or corroded. 8. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Empty dust collection drum (Page 53). 2. Ensure correct power supply voltage and circuit size (Page 33). 3. Replace batteries; stay in signal range; pair remote to machine (Page 48). 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Correct motor wiring connections (Page 57). 6. Reset relay. 7. Fix broken wires or disconnected/corroded connections (Page 57). 8. Replace motor.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Motor wires connected incorrectly. 2. Motor overheated. 3. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Correct motor wiring connections (Page 57). 2. Clean motor, let cool, and reduce workload. 3. Replace motor.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Motor fan rubbing on fan cover. 3. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Fix/replace fan cover; replace loose/damaged fan. 3. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Machine operates in reverse.	<ol style="list-style-type: none"> 1. Power connections wired out of phase. 	<ol style="list-style-type: none"> 1. Correct phase polarity (Page 35).
Digital readout does not work/ display is incorrect.	<ol style="list-style-type: none"> 1. Wiring broken, disconnected, or corroded. 	<ol style="list-style-type: none"> 1. Fix broken wires or disconnected/corroded connections (Page 57).

Operations

Symptom	Possible Cause	Possible Solution
Loud, repetitious noise, or excessive vibration coming from dust collector (non-motor related).	<ol style="list-style-type: none"> 1. Dust collector not on flat surface and wobbles. 2. Impeller damaged and unbalanced. 3. Impeller loose on motor shaft. 	<ol style="list-style-type: none"> 1. Stabilize dust collector. 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 (Cont.)

Symptom	Possible Cause	Possible Solution
Dust collector does not adequately collect dust or chips; poor performance.	<ol style="list-style-type: none"> 1. Collection drum full; seal damaged; leak in drum. 2. Filter bags clogged. 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. Not enough open branch lines at one time, causing velocity drop in main line. 8. Ducting and ports are incorrectly sized. 9. Machine dust collection design is inadequate. 10. Dust collector undersized. 	<ol style="list-style-type: none"> 1. Empty collection drum (Page 53); replace seal; seal/eliminate leak. 2. Oscillate filter cleaning handle to clean filter bags. Replace (Page 52) when cleaning no longer restores adequate airflow. 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; re-secure ducts; remove sharp bends; and use smooth wall duct. Refer to Designing a System (Page 38). 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. Refer to Designing a System (Page 38). 7. Open 1 or 2 more blast gates to different branch lines to increase main line velocity. 8. Install correctly sized ducts and fittings. Refer to Designing a System (Page 38). 9. Use dust collection hood on machine. 10. Upgrade dust collector.
Cleaning filter bags does not improve dust collection performance.	<ol style="list-style-type: none"> 1. Filter bag(s) clogged and at end of life. 	<ol style="list-style-type: none"> 1. Replace filter bag(s) (Page 52).
Dust collector blows sawdust into the air.	<ol style="list-style-type: none"> 1. Duct clamp(s) or dust collection bag(s) not properly clamped and secured; ducting loose/damaged. 2. Seals loose/damaged. 3. Filter bag has hole(s). 	<ol style="list-style-type: none"> 1. Secure ducts and dust collection bag(s), making sure duct/bag clamp(s) are tight; tighten/replace ducting. 2. Tighten all sealing points; replace damaged seals/gaskets or use silicon to seal. 3. Replace filter bag(s) (Page 52).



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 after-market parts.

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

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

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

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

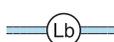
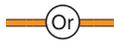
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

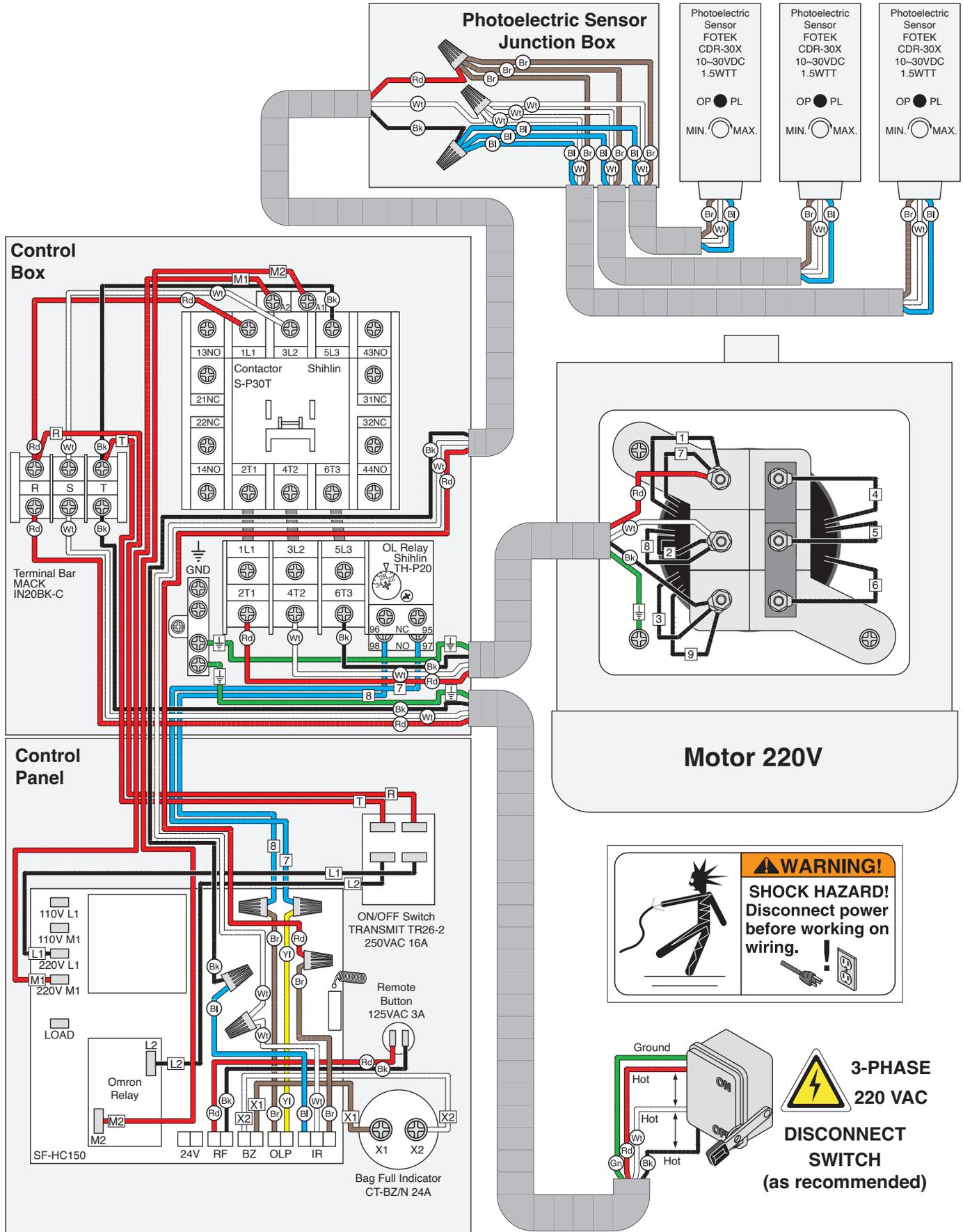
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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



Wiring Diagram 220V



Electrical Components

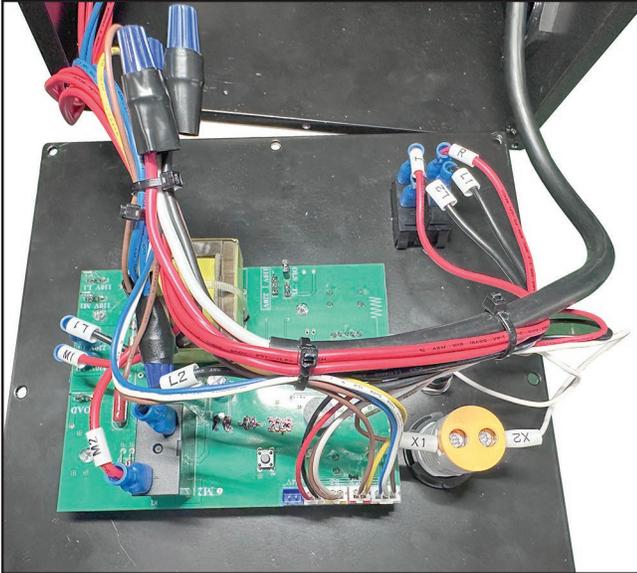


Figure 108. Control panel wiring (220V).

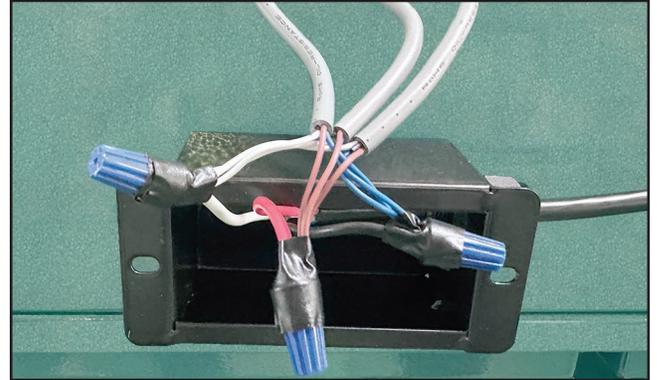


Figure 110. Photoelectric sensor junction box wiring.

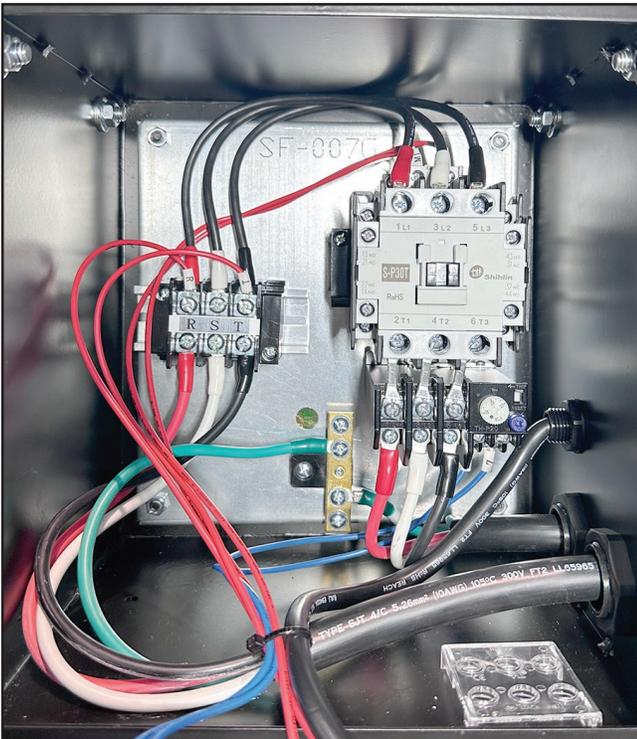


Figure 109. Control box wiring (220V).



Figure 111. Photoelectric sensors (left, middle, and right).

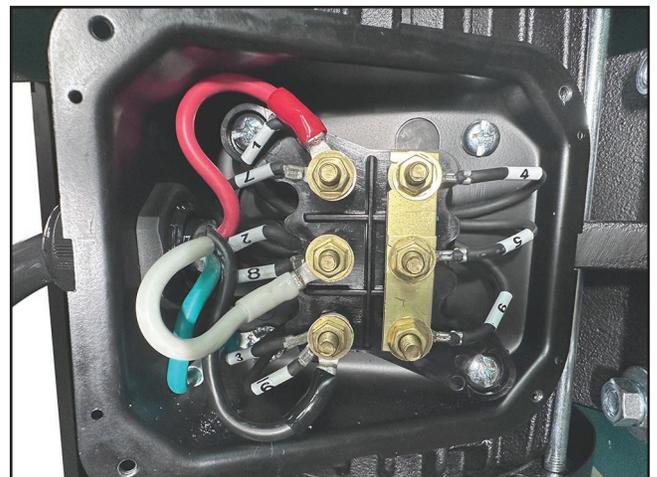


Figure 112. Motor wiring (220V).



Electrical Components (440V)

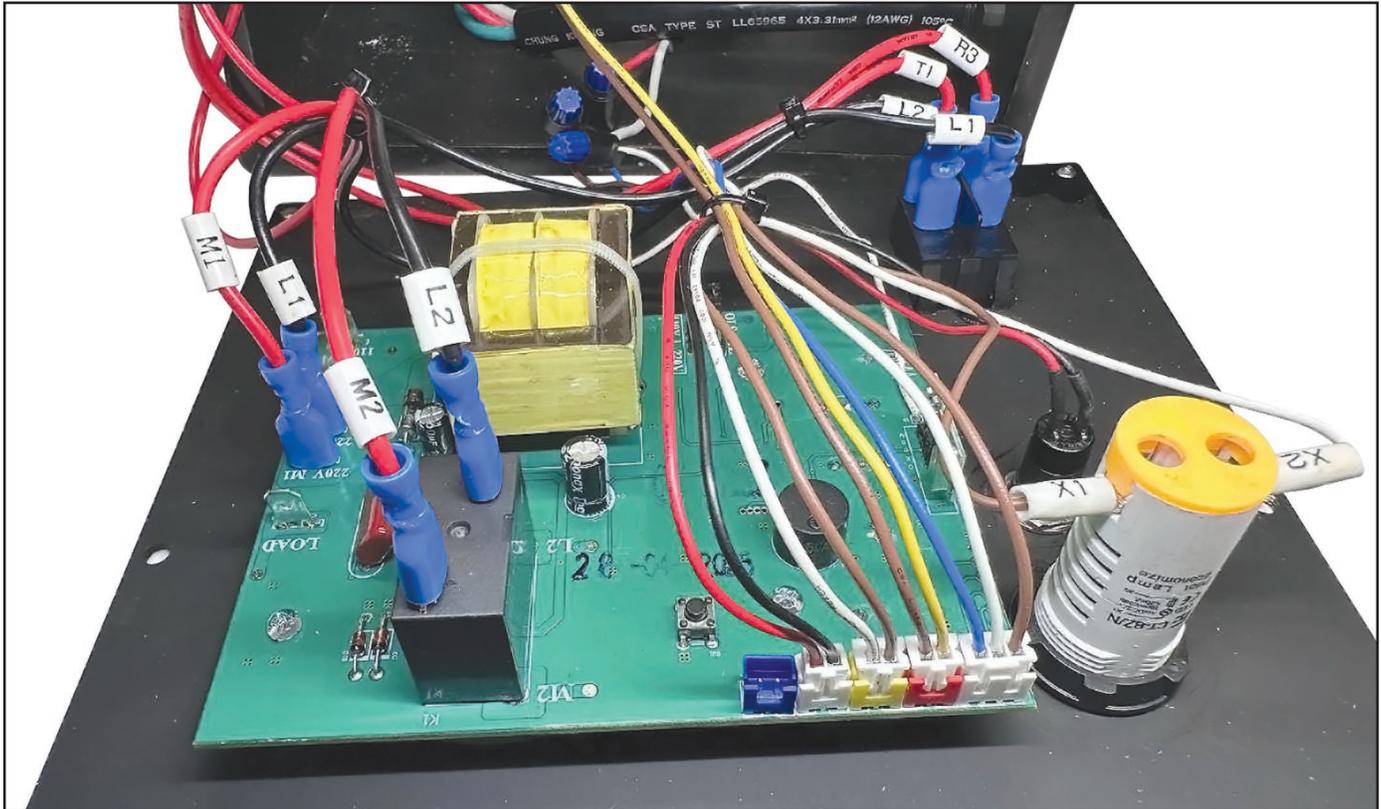


Figure 113. Control panel wiring (440V).

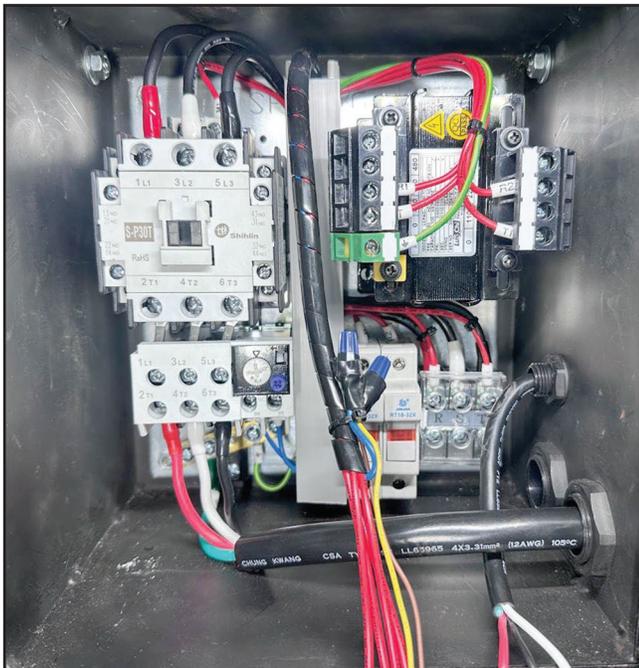


Figure 114. Control box wiring (440V).

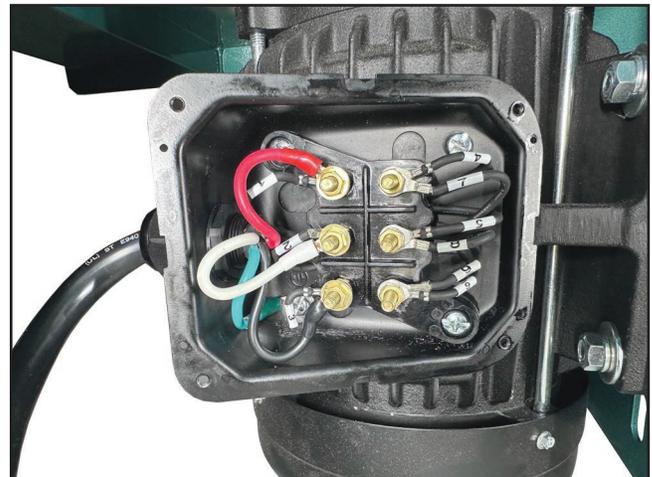


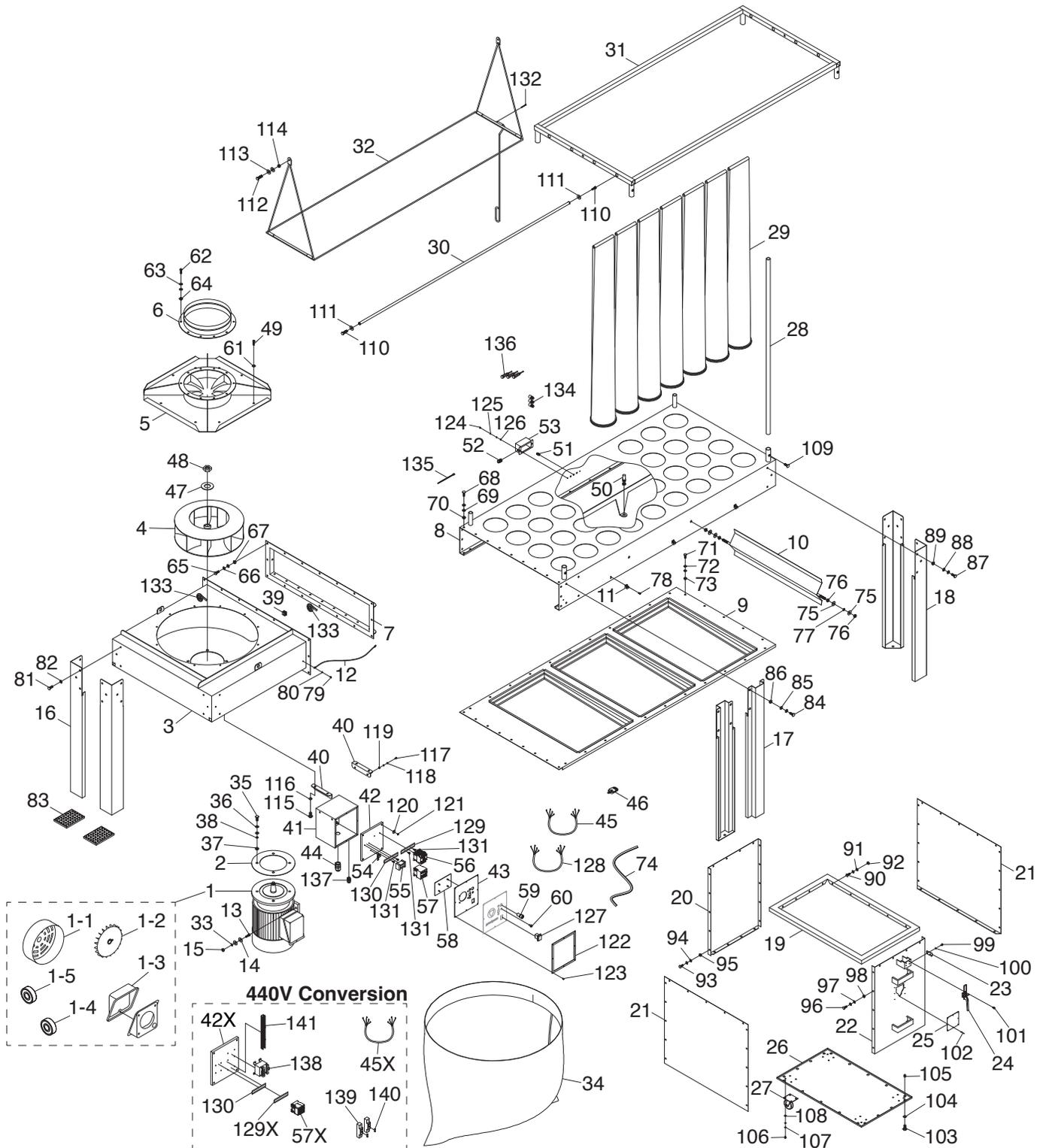
Figure 115. Motor wiring (440V).



SECTION 10: 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	P0406001	MOTOR 7.5HP 220V/440V 3-PH
1-1	P0406001-1	MOTOR FAN COVER
1-2	P0406001-2	MOTOR FAN
1-3	P0406001-3	MOTOR JUNCTION BOX
1-4	P0406001-4	BALL BEARING 6308ZZ (FRONT)
1-5	P0406001-5	BALL BEARING 6306ZZ (REAR)
2	P0406002	MOTOR GASKET 233 X 300 X 3MM, RUBBER
3	P0406003	IMPELLER HOUSING
4	P0406004	IMPELLER 25"
5	P0406005	INLET COVER PLATE
6	P0406006	INLET FLANGE 14"
7	P0406007	BODY FLANGE 800 X 200 X 3MM
8	P0406008	BODY, UPPER
9	P0406009	BODY, LOWER
10	P0406010	CHIP DEFLECTOR
11	P0406011	LATCH HOOK, MACHINE BODY
12	P0406012	GROUND WIRE 10G 8"
13	P0406013	HEX BOLT 1/2-12 X 1-1/2
14	P0406014	FLAT WASHER 1/2
15	P0406015	HEX NUT 1/2-12
16	P0406016	LEG, LEFT
17	P0406017	LEG, MIDDLE
18	P0406018	LEG, RIGHT
19	P0406019	DRUM RIM
20	P0406020	DRUM PANEL, REAR
21	P0406021	DRUM PANEL, SIDE
22	P0406022	DRUM PANEL, FRONT
23	P0406023	LATCH HOOK, DRUM
24	P0406024	LATCH
25	P0406025	DRUM WINDOW 90 X 90 X 1MM, PLASTIC
26	P0406026	DRUM PANEL, BASE
27	P0406027	SWIVEL CASTER 3"
28	P0406028	FRAME SUPPORT ROD
29	P0406029	FILTER BAG
30	P0406030	FILTER SUPPORT ROD
31	P0406031	FILTER SUPPORT FRAME
32	P0406032	FILTER CLEANING ASSEMBLY
33	P0406033	LOCK WASHER 1/2
34	P0406034	COLLECTION BAG 37-13/16" X 53-1/8"
35	P0406035	HEX BOLT 5/8-11 X 2
36	P0406036	FLAT WASHER 5/8
37	P0406037	HEX NUT 5/8-11
38	P0406038	LOCK WASHER 5/8
39	P0406039	PLUG 25 X 25MM, PLASTIC
40	P0406040	CONTROL BOX SUPPORT BRACKET
41	P0406041	CONTROL BOX
42	P0406042	ELECTRICAL MOUNTING BOARD (220V)
42X	P0406042X	ELECTRICAL MOUNTING BOARD (440V)
43	P0406043	CONTROL PANEL
44	P0406044	STRAIN RELIEF PG21
45	P0406045	MOTOR CORD 10G 4W 31"
45X	P0406045X	MOTOR CORD 12G 4W 31"
46	P0406046	REMOTE CONTROL
47	P0406047	FLAT WASHER 25.4 X 58 X 3MM
48	P0406048	IMPELLER NUT 1"
49	P0406049	HEX BOLT 3/8-16 X 1
50	P0406050	PHOTOELECTRIC SENSOR FOTEK CDR-30X
51	P0406051	STRAIN RELIEF M10-1.5
52	P0406052	STRAIN RELIEF M16-1.5

REF	PART #	DESCRIPTION
53	P0406053	PHOTOELECTRIC SENSOR JUNCTION BOX
54	P0406054	GROUND TERMINAL BAR 62 X 13 X 15MM
55	P0406055	TERMINAL BAR 3P DIN35 14-22G
56	P0406056	CONTACTOR SHIHLIN S-P30T 220V
57	P0406057	OL RELAY SHIHLIN TH-P20 22-34A
57X	P0406057X	OL RELAY SHIHLIN TH-P20-15A 12-18A
58	P0406058	CIRCUIT BOARD SF-HC150
59	P0406059	INDICATOR LAMP CT-BZ/N 24V
60	P0406060	REMOTE CONTROL BUTTON 12MM 125V 3A
61	P0406061	FLAT WASHER 3/8
62	P0406062	HEX BOLT 3/8-16 X 1
63	P0406063	FLAT WASHER 3/8
64	P0406064	HEX NUT 3/8-16
65	P0406065	HEX BOLT 3/8-16 X 1
66	P0406066	FLAT WASHER 3/8
67	P0406067	HEX NUT 3/8-16
68	P0406068	HEX BOLT 3/8-16 X 1
69	P0406069	FLAT WASHER 3/8
70	P0406070	HEX NUT 3/8-16
71	P0406071	HEX BOLT 3/8-16 X 1
72	P0406072	FLAT WASHER 3/8
73	P0406073	HEX NUT 3/8-16
74	P0406074	RUBBER SEAL 10 X 22 X 2900MM
75	P0406075	FENDER WASHER 1/2
76	P0406076	HEX NUT 1/2-12
77	P0406077	DEFLECTOR RUBBER GASKET 12 X 30 X 3MM
78	P0406078	PHLP HD SCR 10-24 X 3/8
79	P0406079	PHLP HD SCR M5-.8 X 12, COPPER
80	P0406080	EXT TOOTH WASHER 3/16
81	P0406081	HEX BOLT 3/8-16 X 1
82	P0406082	FLAT WASHER 3/8
83	P0406083	VIBRATION PAD 170 X 120 X 12MM, RUBBER
84	P0406084	HEX BOLT 3/8-16 X 1
85	P0406085	FLAT WASHER 3/8
86	P0406086	HEX NUT 3/8-16
87	P0406087	HEX BOLT 3/8-16 X 1
88	P0406088	FLAT WASHER 3/8
89	P0406089	HEX NUT 3/8-16
90	P0406090	HEX BOLT 5/16-18 X 5/8
91	P0406091	FLAT WASHER 5/16
92	P0406092	HEX NUT 5/16-18
93	P0406093	HEX BOLT 5/16-18 X 5/8
94	P0406094	FLAT WASHER 5/16
95	P0406095	HEX NUT 5/16-18
96	P0406096	HEX BOLT 5/16-18 X 5/8
97	P0406097	FLAT WASHER 5/16
98	P0406098	HEX NUT 5/16-18
99	P0406099	HEX BOLT 1/4-20 X 5/8
100	P0406100	LOCK NUT 1/4-20
101	P0406101	PHLP HD SCR 10-24 X 3/8
102	P0406102	RIVET 2.4 X 8MM BLIND AL
103	P0406103	HEX BOLT 5/16-18 X 5/8
104	P0406104	FLAT WASHER 5/16
105	P0406105	RIVET NUT 5/16-18
106	P0406106	HEX BOLT 5/16-18 X 5/8
107	P0406107	FLAT WASHER 5/16
108	P0406108	HEX NUT 5/16-18
109	P0406109	HEX BOLT 3/8-16 X 1
110	P0406110	HEX BOLT 3/8-16 X 1



Main Parts List (Cont.)

REF	PART #	DESCRIPTION
111	P0406111	FLAT WASHER 3/8
112	P0406112	HEX BOLT 3/8-16 X 2
113	P0406113	FLAT WASHER 3/8
114	P0406114	LOCK NUT 3/8-16
115	P0406115	HEX BOLT 5/16-18 X 3/4
116	P0406116	FLAT WASHER 5/16
117	P0406117	HEX BOLT 5/16-18 X 3/4
118	P0406118	FLAT WASHER 5/16
119	P0406119	HEX NUT 5/16-18
120	P0406120	FLAT WASHER 1/4
121	P0406121	HEX NUT 1/4-20
122	P0406122	CONTROL PANEL FRAME
123	P0406123	PHLP HD SCR M4-.7 X 10
124	P0406124	PHLP HD SCR 10-24 X 1/2
125	P0406125	FLAT WASHER 3/16
126	P0406126	HEX NUT 10-24

REF	PART #	DESCRIPTION
127	P0406127	ON/OFF SWITCH TRANSMIT TR26-2
128	P0406128	PHOTOELECTRIC SENSOR CORD 18G 4W 98"
129	P0406129	DIN RAIL TH35-7.5 X 111MM
129X	P0406129X	DIN RAIL TH35-7.5 X 82MM
130	P0406130	DIN RAIL TH35-7.5 X 86MM
131	P0406131	TRUSS HD PHLP SCR M4-.7 X 6MM
132	P0406132	COTTER PIN M6 X 38 STANDARD
133	P0406133	FOAM TAPE 3 X 6 X 1000MM
134	P0406134	WIRE NUT 22-14G
135	P0406135	CABLE TIE 2.2 X 100MM, NYLON
136	P0406136	PHOTOELECTRIC SENSOR ADJUSTMENT PIN
137	P0406137	STRAIN RELIEF M16-1.5
138	P0406138	TRANSFORMER LC SFB-054 100VA 220/440V
139	P0406139	FUSE HOLDER JINLIDA RT18-32X
140	P0406140	FUSE 1A 500V 0.25" FAST-ACTING, CERAMIC
141	P0406141	WIRE LOOM 45 X 210MM

BUY PARTS ONLINE AT GRIZZLY.COM!
Scan QR code to visit our Parts Store.




Labels & Cosmetics

EXTREME III SERIES

Grizzly Industrial

MODEL G0406
7.5 HP BAGHOUSE
DUST COLLECTOR

Specifications

Motor: 7.5HP 220V/440V, 3-Phase, 60 Hz
 Pre-wired Voltage: 220V
 Full-Load Amps: 22A at 220V, 11A at 440V
 Minimum Circuit Size: 50A at 220V, 30A at 440V
 Airflow Performance: 5500 CFM @ 2.92 in. SP
 Max. Static Pressure: 15.2 in. H₂O
 Inlet Size: 14"
 Bag Collection Capacity: 231 Gallons
 Filtration Rating: 99.9% @ 0.2-2-microns
 Weight: 1112 lbs.

WARNING!

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

1. Read and understand owner's manual before operating.
2. Always wear approved eye protection and a respirator.
3. Properly ground machine—connect to permanently grounded metal wiring system or an equipment-grounding conductor.
4. Only use this machine to collect wood dust/shavings—never use to collect glass, metal, liquids, asbestos, silica, animal parts, biohazardous, burning materials/shavings, etc.
5. Always disconnect power before servicing or cleaning.
6. Do not expose to rain or use in wet areas.
7. Keep hands, long hair, and loose clothing away from inlet.
8. Never leave machine unattended during operation.
9. Do not use if power supply wires, conduit, or any other electrical equipment becomes damaged—promptly repair!
10. Do not use without dust bags or filters in place.
11. Always wear a respirator when emptying bags.
12. Do not modify machine in any way.
13. Prevent unauthorized use by children or untrained users; restrict access or disable machine when unattended.

212

⚠ DANGER

AMPUTATION HAZARD!

DO NOT place hands near inlet during operation!

213

ROTATION

211

⚠ WARNING!

IF YOU TOUCH THE SPINNING IMPELLER, SEVERE CUTTING OR AMPUTATION INJURIES WILL OCCUR. ALWAYS KEEP YOURSELF AND TOOLS WELL AWAY FROM THE IMPELLER WHILE MACHINE IS CONNECTED TO POWER.

This dust collector uses a 3-phase motor that must rotate in the direction of the arrow above (counterclockwise as viewed from above the motor) for correct operation. If the motor rotates in the opposite direction, it is wired out-of-phase. The machine will still work in this condition but with significantly reduced performance. If operated for more than a few minutes when wired out-of-phase, the motor will be damaged—which is not covered under warranty!

Follow the instructions below to verify the correct impeller rotation:

After assembly is correctly completed and the machine is properly connected to power, use a ladder to safely observe the motor fan through the dust port inlet as another person quickly turns the machine ON and OFF.

- If the motor fan rotates counterclockwise when viewed from above, the impeller/motor rotation is correct.
- If the motor fan rotates clockwise when viewed from above, the rotation direction is incorrect and the motor is wired out-of-phase. Disconnect the machine from power, then swap any two incoming power leads terminated inside the control box (refer to the owner's manual Wiring Diagram for a detailed illustration). Repeat the instructions above to confirm that the impeller/motor rotates correctly.

210

⚠ WARNING! To reduce risk of strain or serious injury, read manual BEFORE using machine.

⚠ WARNING! EYE/LING INJURY HAZARD! Always wear safety glasses/eye wear when operating and emptying bags.

⚠ WARNING! DISCONNECT POWER BEFORE ADJUSTMENTS, MAINTENANCE, OR SERVICE.

209

Grizzly Industrial

ON/OFF Bag Full
 Overload
 Remote
 Time/Hours
 ON
 OFF

G0406

208

220 VOLT

This machine is prewired for 220V operation. To operate at 440V, follow critical voltage conversion instructions in the user manual included with this machine. Failure to follow these instructions will damage the machine and void the warranty!

207

⚠ WARNING!

220 VOLT

This machine is prewired for 220V operation. To operate at 440V, follow critical voltage conversion instructions in the user manual included with this machine. Failure to follow these instructions will damage the machine and void the warranty!

206

NOTICE

To reduce risk of circuit overload or machine electrical damage, only operate dust collector with bags/filters installed.

201

202

203

204

205

⚠ 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.



Labels & Cosmetics Parts List

REF	PART #	DESCRIPTION
201	P0406201	MACHINE ID LABEL
202	P0406202	EXTREME SERIES LABEL
203	P0406203	TOUCH-UP PAINT, GRIZZLY GREEN
204	P0406204	TOUCH-UP PAINT, GLOSSY BLACK
205	P0406205	GRIZZLY NAMEPLATE, LARGE
206	P0406206	DUST COLLECTOR NOTICE HANG TAG
207	P0406207	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
208	P0406208	PREWIRED 220V LABEL
209	P0406209	CONTROL PANEL LABEL
210	P0406210	COMBO WARNING LABEL
211	P0406211	IMPELLER WARNING LABEL
212	P0406212	AMPUTATION HAZARD LABEL
213	P0406213	ROTATION DIRECTION LABEL



WARRANTY & RETURNS

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

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

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

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

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

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

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



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