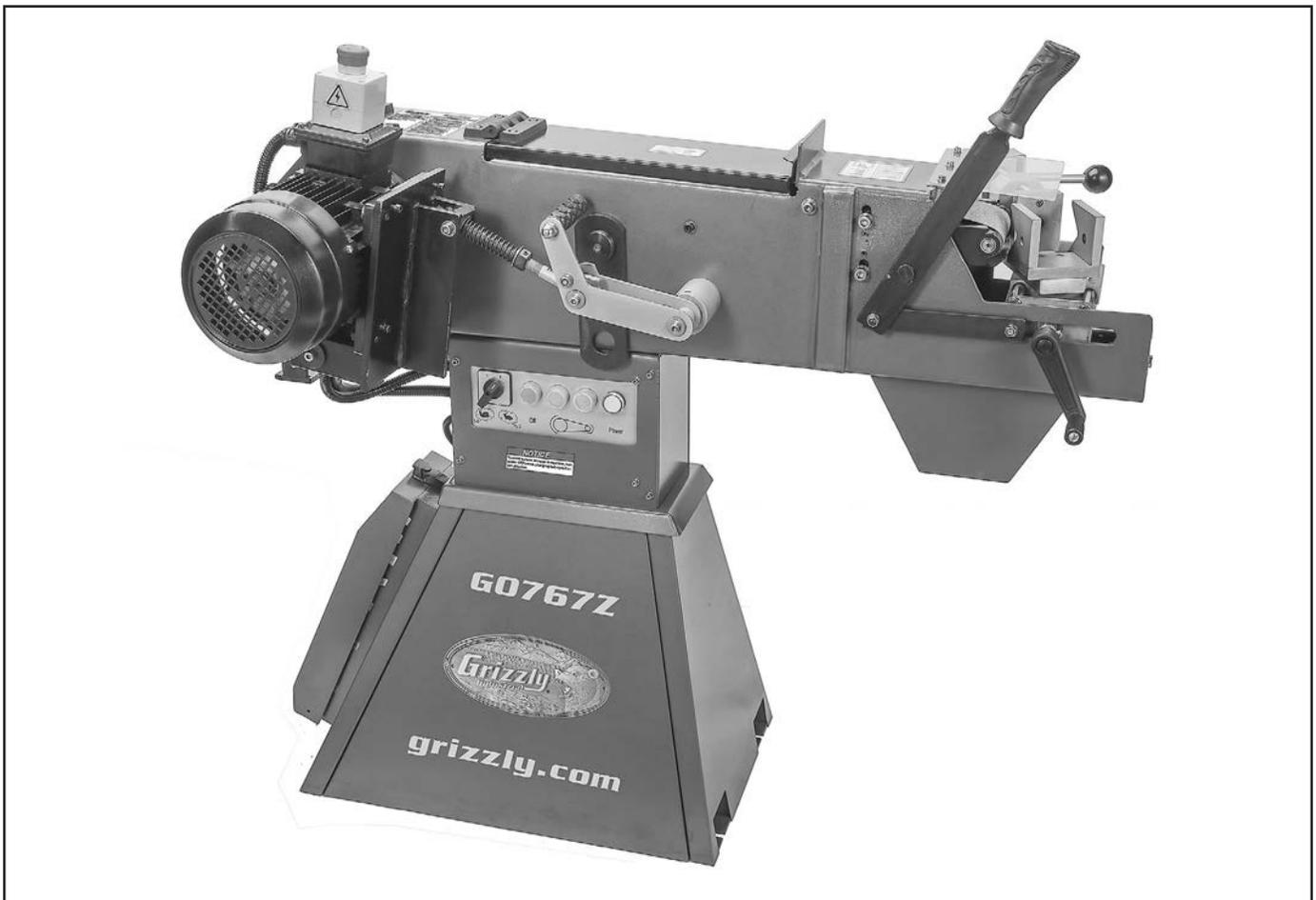


# **Grizzly** **Industrial, Inc.**®

## **MODEL G0767Z** **ABRASIVE TUBE NOTCHER**

### **OWNER'S MANUAL**

*(For models manufactured since 11/17)*



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OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#ESABJH19158 PRINTED IN CHINA

V1.02.18

 **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

## Machine Description

The Model G0767Z Abrasive Tube Notcher is designed to quickly notch or cope the ends of metal tubing, so two pieces of tubing can be welded together with clean, strong joints. It is an ideal machine for production work with fencing, gates, roll cages, bicycle frames, stainless steel piping, or any other type of tubing work that requires joining multiple pieces together.

The vise allows the tube to be set at any angle from 30° to 90° to the grinding belt. Using the variety of included profile rollers, notches can be formed in diameters from 3/4" to 3". After notching is complete, tubing edges can be deburred using the deburring stations located on the top and rear of the machine.

## Contact Info

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

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

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

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

## 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](http://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:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety is 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. Do not use while tired, drowsy, or under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		

Manufacture Date: [ ]

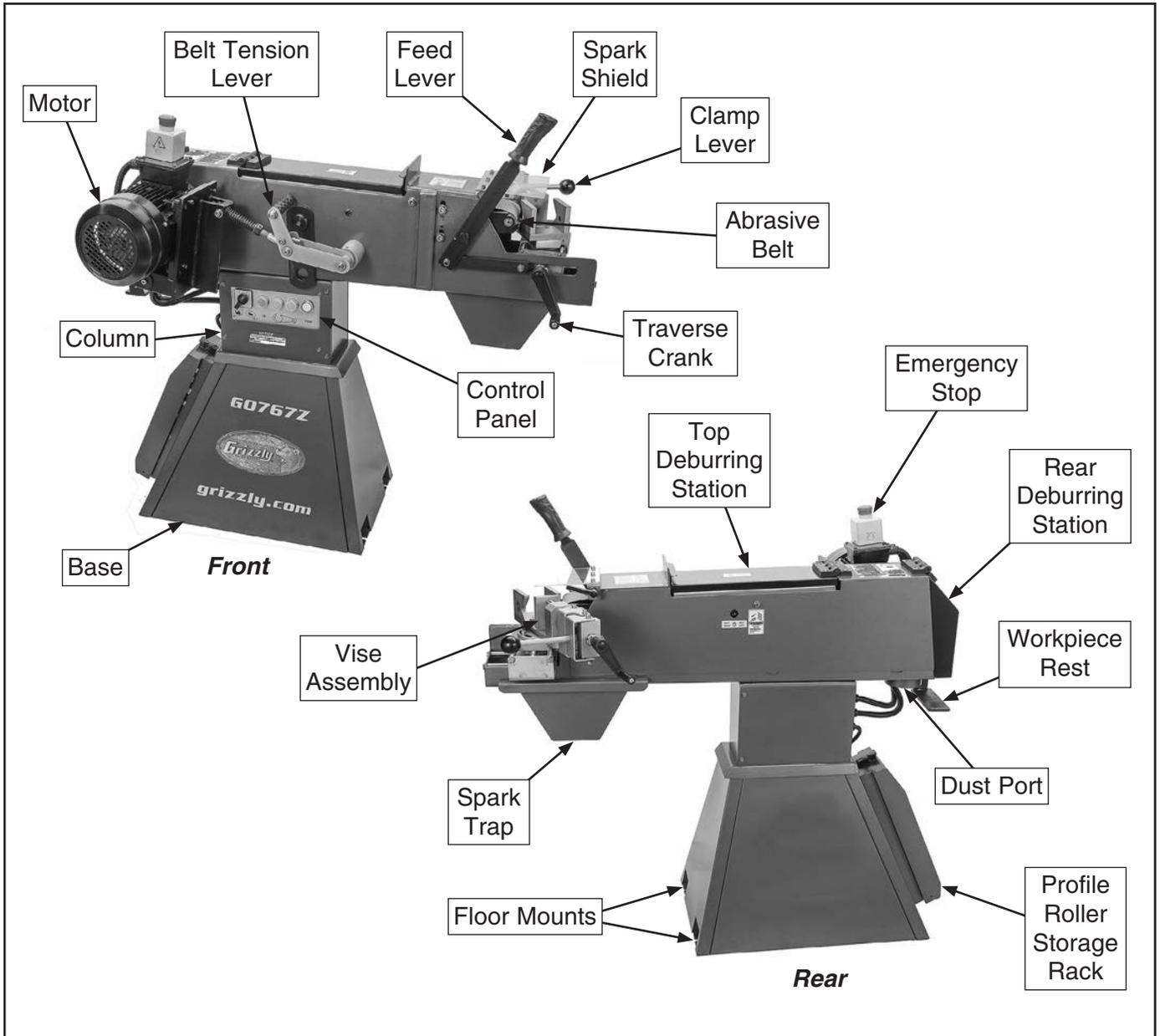
Serial Number: [ ]

Manufactured for Grizzly in Taiwan



# Identification

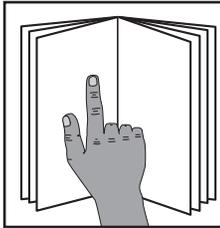
Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



	<p><b>⚠ WARNING</b> To reduce your risk of serious injury, read this entire manual <b>BEFORE</b> using machine.</p>
--	---



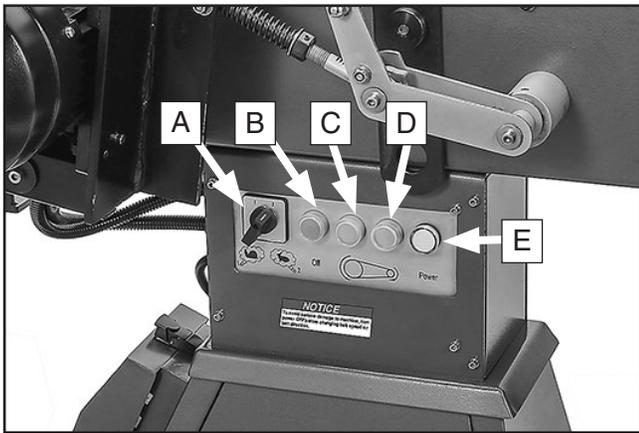
# Controls & Components



## **!WARNING**

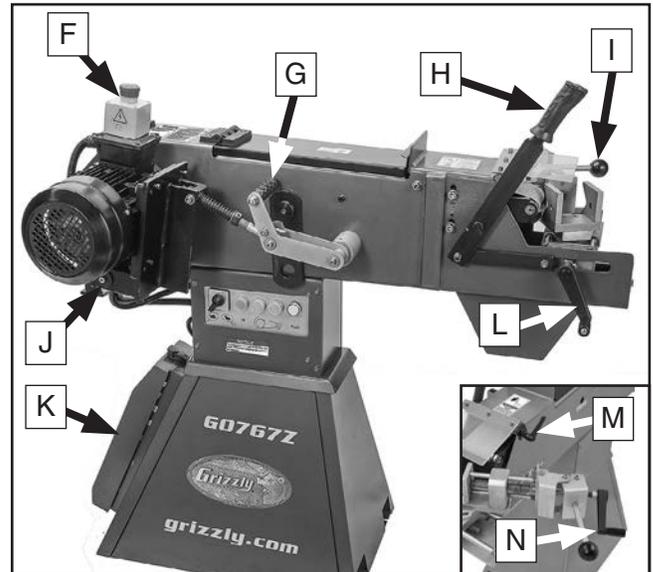
To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

Refer to **Figures 1–2** and the following descriptions to become familiar with the basic controls of this machine.



**Figure 1.** Control panel.

- A. Motor Speed Switch:** Changes motor speed between high & low.
- B. OFF Button:** Press to turn motor **OFF**.
- C. ON/Clockwise Button:** Press to start abrasive belt movement clockwise.
- D. ON/Counterclockwise Button:** Press to start abrasive belt movement counterclockwise.
- E. Power Lamp:** Indicates power to machine is turned **ON**.



**Figure 2.** Other controls.

- F. Emergency Stop Button:** Cuts power to motor and prevents restarting until reset. Twist clockwise to reset.
- G. Belt Tension Lever:** Controls abrasive belt tension.
- H. Feed Lever:** Moves tube toward or away from abrasive belt.
- I. Clamp Lever:** Locks tube between vise jaws so it will not move during grinding.
- J. Rest Lock:** Locks rest at rear deburring station in position.
- K. Profile Roller Storage Rack:** Stores profile rollers away from debris and grime.
- L. Traverse Crank:** Moves tube from side-to-side across abrasive belt. This will increase the life of the belt.
- M. Spark Shield Lock Handle:** Secures spark shield in place.
- N. Clamp Crank:** Adjusts distance between jaws and clamp plate to accommodate diameter of tube.





# MACHINE DATA SHEET

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

## MODEL G0767Z ABRASIVE TUBE NOTCHER

### Product Dimensions:

Weight ..... 290 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height ..... 31-1/2 x 49-1/2 x 47-1/2 in.  
 Footprint (Length/Width) ..... 25-1/2 x 16 in.

### Shipping Dimensions:

Type ..... Wood Crate  
 Content ..... Machine  
 Weight ..... 381 lbs.  
 Length x Width x Height ..... 48 x 28 x 45 in.  
 Must Ship Upright ..... Yes

### Electrical:

Power Requirement ..... 220V, 3-Phase, 60 Hz  
 Full-Load Current Rating ..... 11.6A  
 Minimum Circuit Size ..... 15A  
 Connection Type ..... Cord & Plug  
 Power Cord Included ..... Yes  
 Power Cord Length ..... 6 ft.  
 Power Cord Gauge ..... 14 AWG  
 Plug Included ..... No  
 Recommended Plug Type ..... NEMA L15-15  
 Switch Type ..... Control Panel

### Motor:

#### Main

Type ..... TEFC Induction  
 Horsepower ..... 3 HP/4 HP  
 Phase ..... 3-Phase  
 Amps ..... 9.7A/11.6A  
 Speeds ..... 1720 RPM/3440 RPM  
 Power Transfer ..... Direct  
 Bearings ..... Sealed & Permanently Lubricated

### Main Specifications:

#### Belt Sander Info

Sanding Belt Speed ..... 3580, 6180 FPM  
 Sanding Belt Length ..... 78-3/4 in.  
 Sanding Belt Width ..... 4 in.  
 Number of Profile Rollers ..... 7  
 Profile Roller Sizes ..... 3/4, 1, 1-1/4, 1-1/2, 2, 2-1/2, 3 in.  
 Grinding Capacity ..... 3/4 - 3 in. O.D.  
 Grinding Angle Range ..... 0 - 60 deg.



**Platen Info:**

Platen Type..... Graphite Coated  
Platen Length..... 15-3/8 in.  
Platen Width.....4-1/2 in.

**Construction:**

Stand..... Formed Steel  
Body..... Formed Steel  
Rollers.....Polished Steel  
Paint..... Powder Coated

**Other Specifications:**

Country of Origin..... China  
Warranty..... 1 Year  
Approximate Assembly & Setup Time ..... 1 Hour  
Serial Number Location ..... ID Label  
ISO 9001 Factory.....Yes  
Certified by a Nationally Recognized Testing Laboratory (NRTL)..... No

**Features:**

- Two Belts Speeds (3580 & 6180 FPM)
- Ratcheting System for Easy Tensioning of Sanding Belt
- Front Debris-Catching Tray
- 3" Dust Port
- Easy Belt Alignment/Tracking System
- Top and Rear Sanding-Belt Access for Deburring
- Self-Aligning Vise with Side-to-Side Adjustment to Prevent Uneven Belt Wear
- Vise Rotates 0 - 60 degrees
- Transparent Safety Guard
- Removable Spark Tray

**Accessories:**

- Seven Rollers: 3/4", 1", 1-1/4", 1-1/2", 2", 2-1/2", 3"
- Toolbox with Service Tools



# SECTION 1: SAFETY

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

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

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

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

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

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

## Safety Instructions for Machinery

### **WARNING**

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

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

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

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

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

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

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



# WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Abrasive Tube Notchers

## **WARNING**

Long-term respiratory damage, cancer, or birth defects can occur from inhalation of dust. You can get seriously injured or killed if clothing, jewelry, or long hair become entangled in rotating machine parts. You can be blinded or burned by hot metal particles that fly out during operation. Flying sparks can ignite nearby explosive or flammable materials. Sanding belt quickly removes skin upon contact. To reduce your risk of these hazards when operating this machine, completely heed and understand the following:

**USE FOR INTENDED PURPOSE.** This machine is designed for grinding certain metals. DO NOT use it to grind materials made from wood or wood products, lead, magnesium, asbestos, crystalline silica, gypsum, or any other non-metal products.

**PROTECTION FROM HOT SPARKS.** Properly adjust and lock spark shield prior to grinding operations. ALWAYS wear approved safety glasses or goggles, a face shield, a respirator, hearing protection, long leather gloves, and a leather apron to reduce the risk of injury from hot, flying sparks when operating. Never allow anyone to stand in path of sparks.

**PROTECTION FROM ENTANGLEMENT.** DO NOT wear loose clothing, jewelry or other items that can get caught in moving parts. Tie back hair and roll up long sleeves. Make sure machine is turned **OFF**, disconnected from power, and that all moving parts come to a complete stop before opening belt cover.

**MINIMIZE EXPOSURE TO SANDING BELT.** Keep hands away from rotating sanding belt during operation. Keep deburring station covers closed when not in use.

**WEAR PROPER RESPIRATOR.** Dust created from grinding metals may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards, exposure limits, and toxicity associated with each type of workpiece material. Very fine dust/particles are unlikely to be captured and may become airborne in work area. Anyone working with or around this machine MUST wear a NIOSH-approved respirator rated for the workpiece material.

**RISK OF FIRE AND EXPLOSIONS.** This machine creates a shower of hot sparks that can ignite nearby explosive or flammable materials. ALWAYS keep these materials away from machine. Fine metal dust particles can ignite, depending on material type and circumstances. Know about and be prepared to safely fight a combustible metal fire by conducting a combustible screening test under Chapter 4 of NFPA 484. Keep machine away from pilot lights, open flames, or other ignition sources. Never use machine to grind magnesium—as these particles can ignite from exposure to water/moisture.

**TOXIC METALS.** Exposure (or over-exposure) to certain types of metal dusts or fumes can result in serious, potentially deadly health effects. To reduce this risk, research toxic effects of metal types you work with and always seek to minimize/eliminate exposure to yourself and others.

**REDUCE RISK OF BURNS.** Workpieces get very hot while grinding. Always wear long leather gloves when operating machine.

**PROPERLY MAINTAIN MACHINE.** Keep machine in proper working condition to help ensure all guards and other components work as intended and function safely. Perform routine inspections and all necessary maintenance, as indicated in owner's manual. Never operate machine with damaged or worn parts that can break during operation.

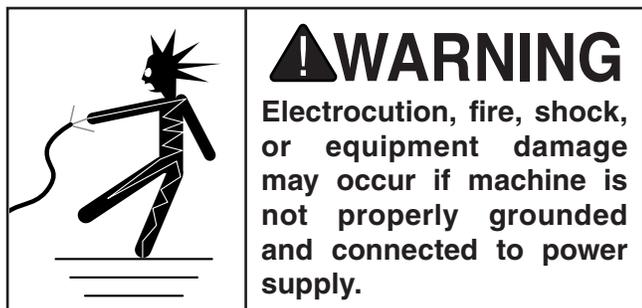
**AVOID SUDDEN STARTUP.** In event of power loss during operation, immediately press Emergency Stop button to avoid a sudden startup once power is restored.



# 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 ...11.6 Amps

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

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

## Circuit Requirements for 220V

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

**Nominal Voltage** ..... 208V, 220V, 230V, 240V  
**Cycle** ..... 60 Hz  
**Phase** ..... 3-Phase  
**Power Supply Circuit** ..... 15 Amps  
**Plug/Receptacle** ..... NEMA L15-15

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

## ! CAUTION

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

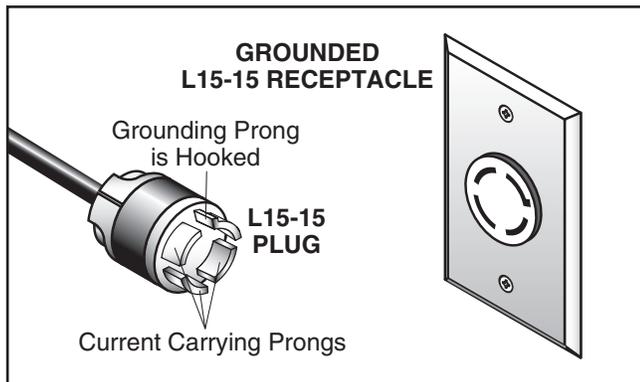
**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel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



## Grounding Instructions

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

The power cord and plug specified under “Circuit Requirements for 220V” on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).



**Figure 3.** Typical L15-15 plug and receptacle.

## **!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.**

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

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

## **!WARNING**

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

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

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

## Extension Cords

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

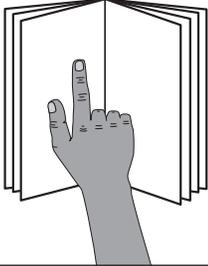
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

**Minimum Gauge Size ..... 14 AWG**  
**Maximum Length (Shorter is Better).....50 ft.**



# SECTION 3: SETUP



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



**!WARNING**  
Wear safety glasses during the entire setup process!



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

## Needed for Setup

The following are needed to complete the setup process:

Description	Qty
• Additional People .....	2
• Safety Glasses .....	1 Ea.
• Forklift or Crane (Rated For at Least 500 lbs.).....	1
• Web Slings (Rated For at Least 500 lbs. Each) .....	2
• Lifting Chain & Safety Hook (Optional) (Rated For at Least 500 lbs. Each) .....	1
• Wrench or Socket 13mm.....	1
• Wrench or Socket 16mm.....	1
• Wrench or Socket 17mm .....	1
• Metal Dust Collection System .....	1
• Metal Flex Hose 4" .....	1
• Hose Clamps 4" .....	1

## Unpacking

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

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



**!WARNING**  
**SUFFOCATION HAZARD!**  
Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.



# 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.

Inventory (Figure 4)	Qty
A. Machine Body .....	1
B. Machine Base with Profile Rollers.....	1
—Profile Roller ¾" Dia. ....	1
—Profile Roller 1" Dia. (Installed).....	1
—Profile Roller 1¼" Dia. ....	1
—Profile Roller 1½" Dia. ....	1
—Profile Roller 2" Dia. ....	1
—Profile Roller 2½" Dia. ....	1
—Profile Roller 3" Dia. ....	1
C. Feed Lever Assembly.....	1
D. Spark Trap.....	1
E. Vise Assembly.....	1
F. Hex Wrenches 2.5, 3, 4, 5, 6, 8mm .....	1 Ea
G. Phillips Screwdriver #2 .....	1
H. Spanner Wrenches 22, 26mm .....	2
I. Open-End Wrench 13/16mm.....	1
J. Toolbox.....	1

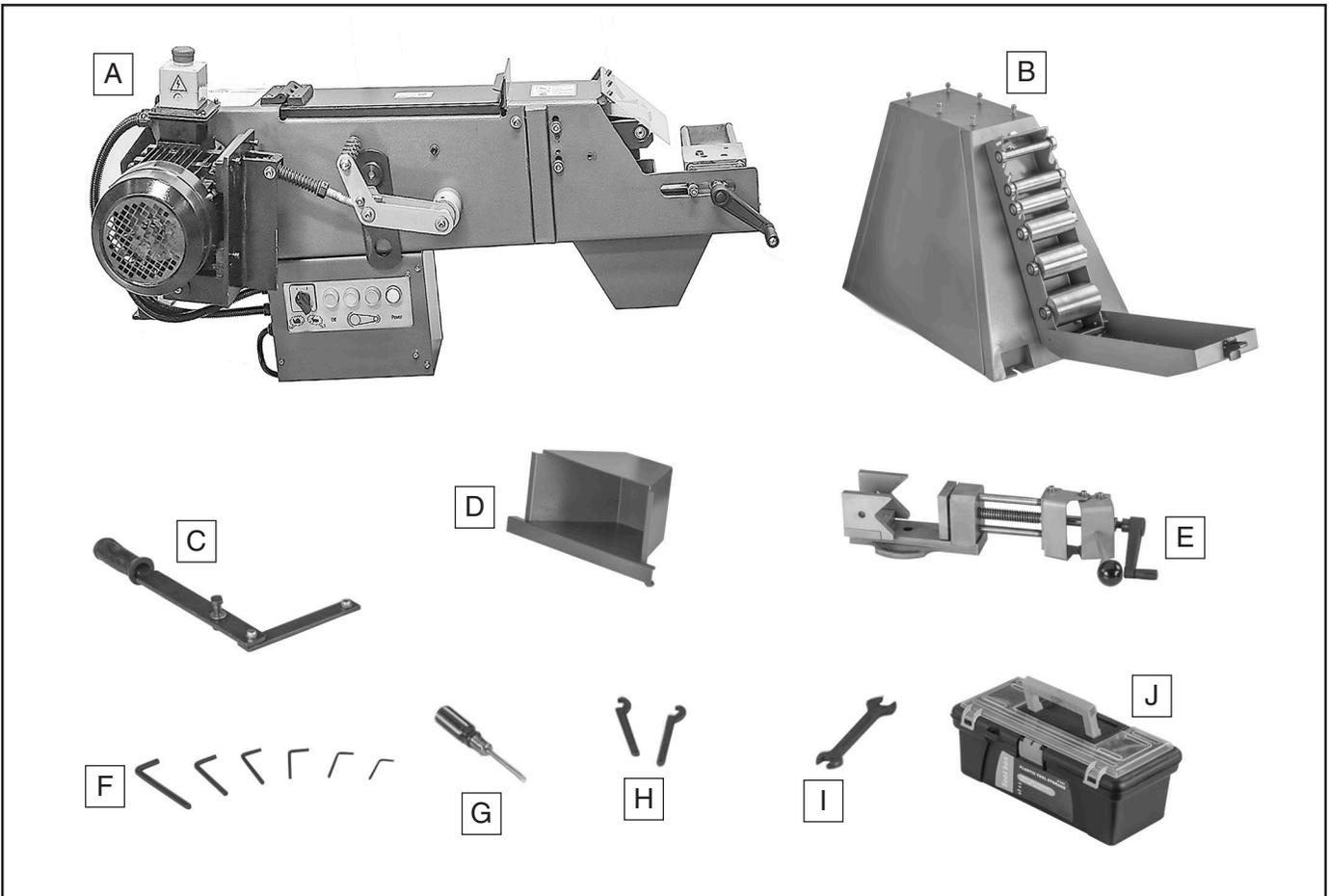


Figure 4. Model G0767Z inventory.

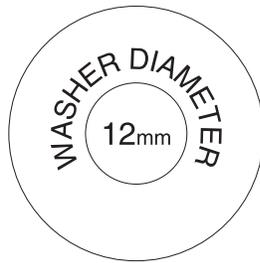
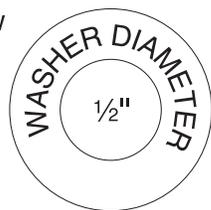
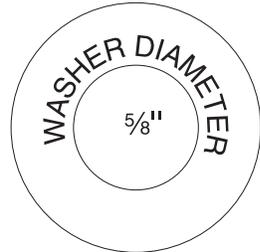
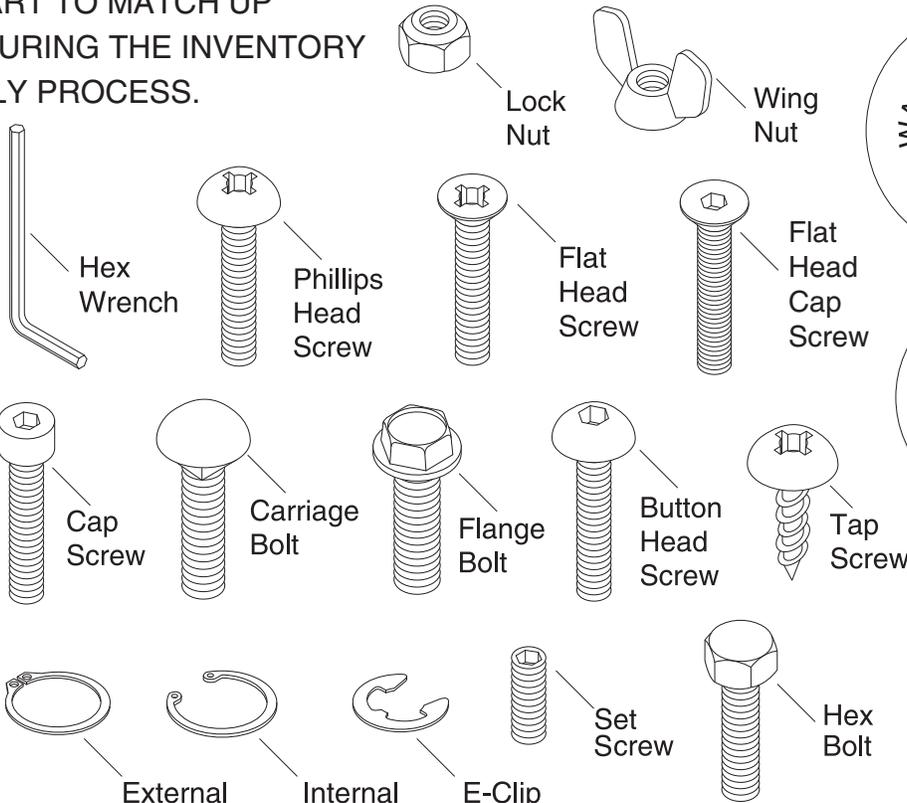


# Hardware Recognition Chart

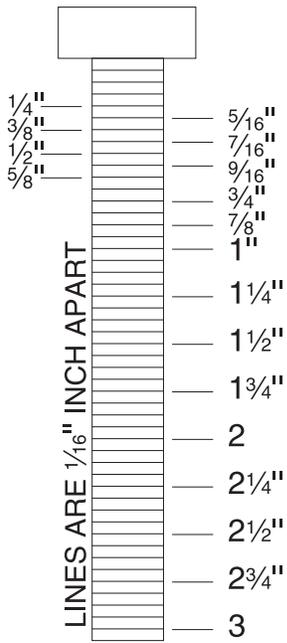
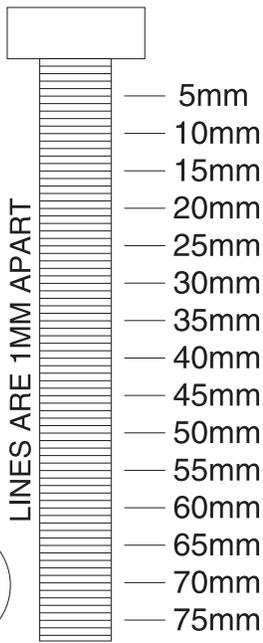
USE THIS CHART TO MATCH UP  
HARDWARE DURING THE INVENTORY  
AND ASSEMBLY PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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



- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



# Site Considerations

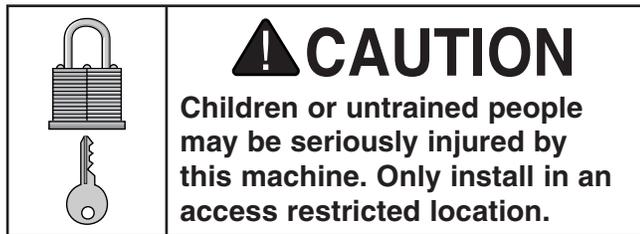
## Weight Load

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

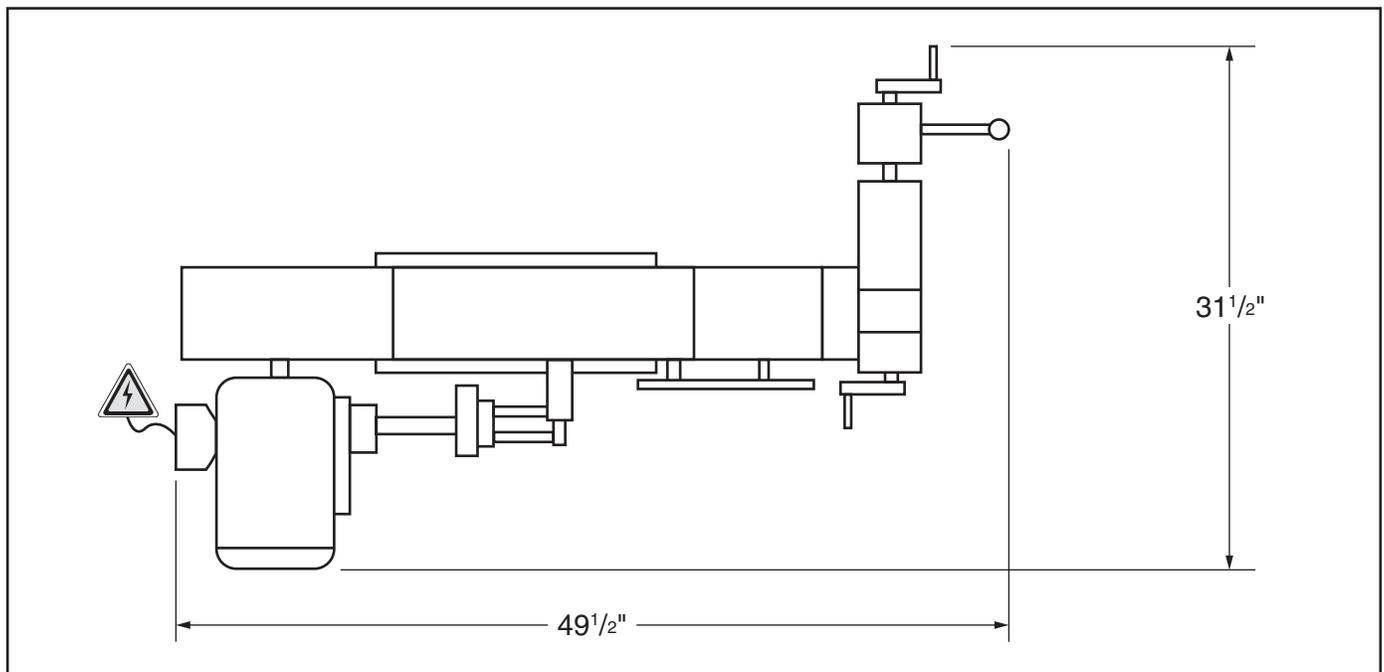
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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

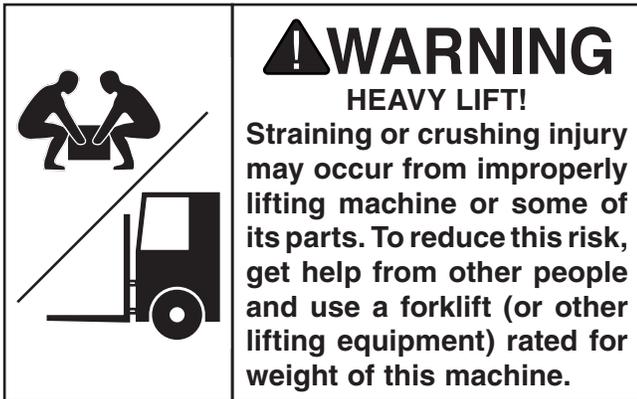
Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.



**Figure 5.** Minimum working clearances.



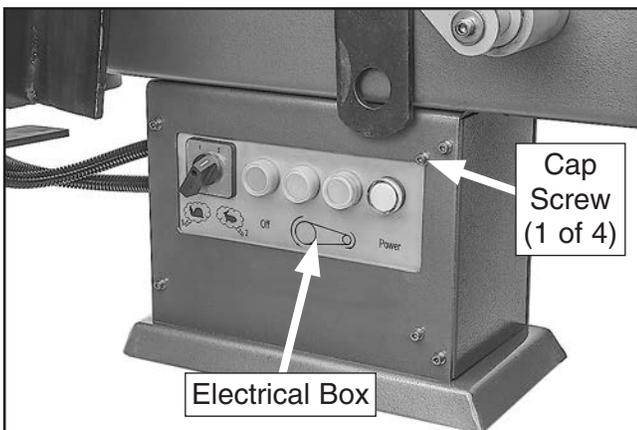
# Lifting & Placing



The following procedure details how to place the machine's base, and then how to lift and secure the machine to the base.

## To lift and place machine:

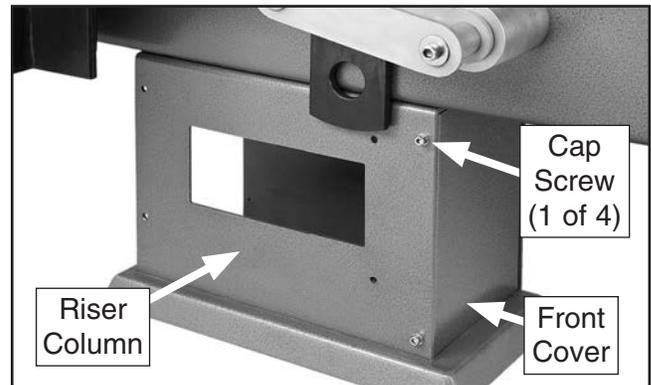
1. Place shipping crate near installation location, then remove crate from shipping pallet and set small items aside.
2. Unbolt base from shipping pallet.
3. Move base to selected location and properly anchor it to floor (refer to **Anchoring to Floor** on **Page 18**).
4. Remove (4) cap screws that secure electrical box inside riser column (see **Figure 6**).



**Figure 6.** Location of cap screws that secure electrical box.

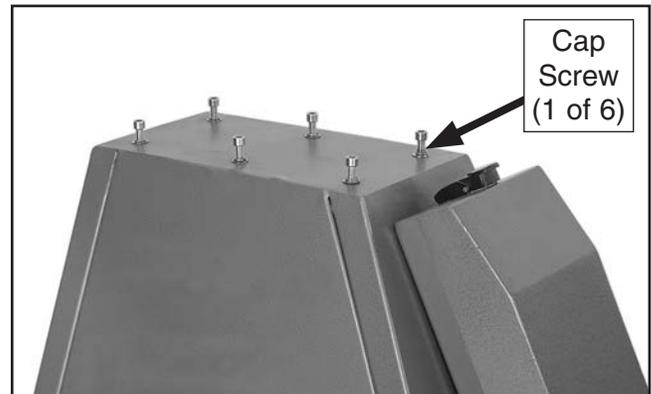
5. Slide electrical box out of riser column and place on top of machine.

6. Remove (4) cap screws that secure riser column front cover (see **Figure 7**).



**Figure 7.** Location of cap screws that secure front cover.

7. Remove (6) pre-installed cap screws, lock washers, and flat washers from top of base (see **Figure 8**).



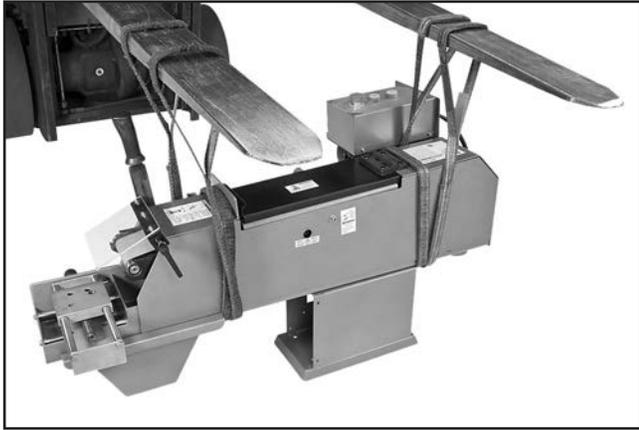
**Figure 8.** Cap screws on top of base.

8. Have another person hold machine steady so that it does not tip, then remove hex nuts that secure machine body to pallet.



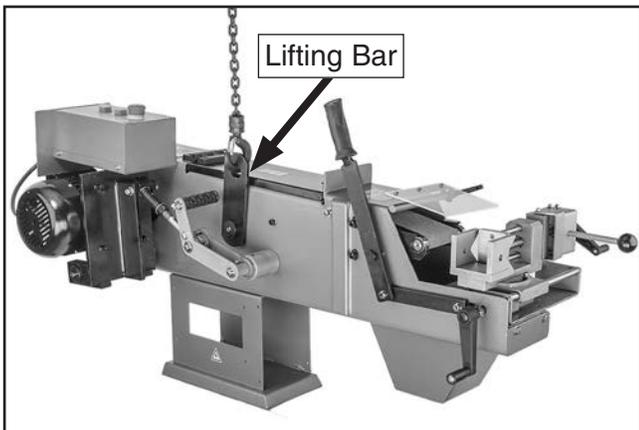
9. Below are two methods for lifting machine onto base. Use the best one for your operation.

— Wrap web slings around machine and attach them to a forklift or other lifting device (see **Figure 9**).



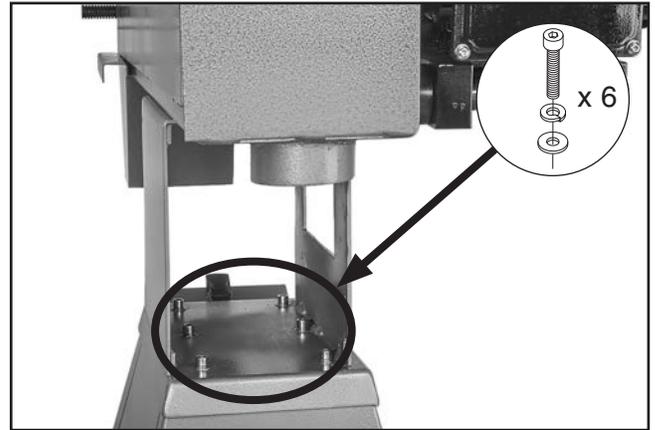
**Figure 9.** Example of lifting machine with web slings.

— Rotate lifting bar up (see **Figure 10**), and attach lifting chain and safety hook between lifting bar and lifting device.



**Figure 10.** Example of lifting machine with chain and hook.

10. Lift machine onto base with roller storage rack underneath motor, and secure machine to base with (6) cap screws removed in **Step 7** (see **Figure 11**).



**Figure 11.** Machine attached to base.

11. Re-install riser column front cover with (4) cap screws removed in **Step 6**.

12. Re-install electrical box in riser column with (4) cap screws removed in **Step 4** (see **Figure 12**).



**Figure 12.** Electrical box re-installed.



# Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

## Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

## NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

# Anchoring to Floor

Number of Mounting Holes ..... 4  
Diameter of Mounting Hardware..... 7/16"

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

## WARNING

Because of the top heavy nature of the Model G0767Z and the dynamic forces exerted during operation, this machine **MUST** be solidly anchored to floor.

## 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.

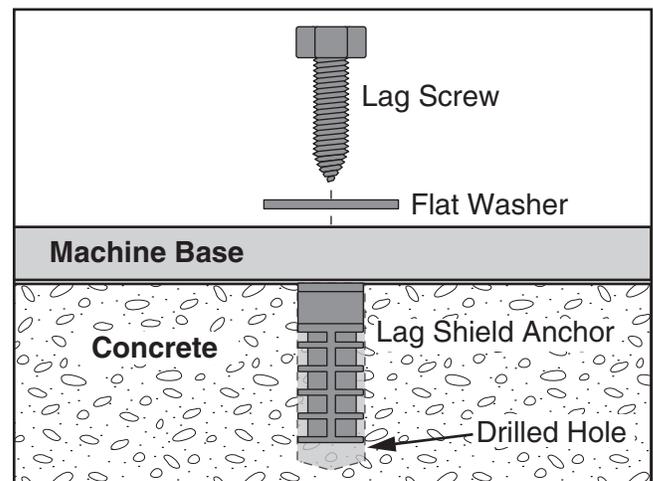


Figure 13. Popular method for anchoring machinery to a concrete floor.

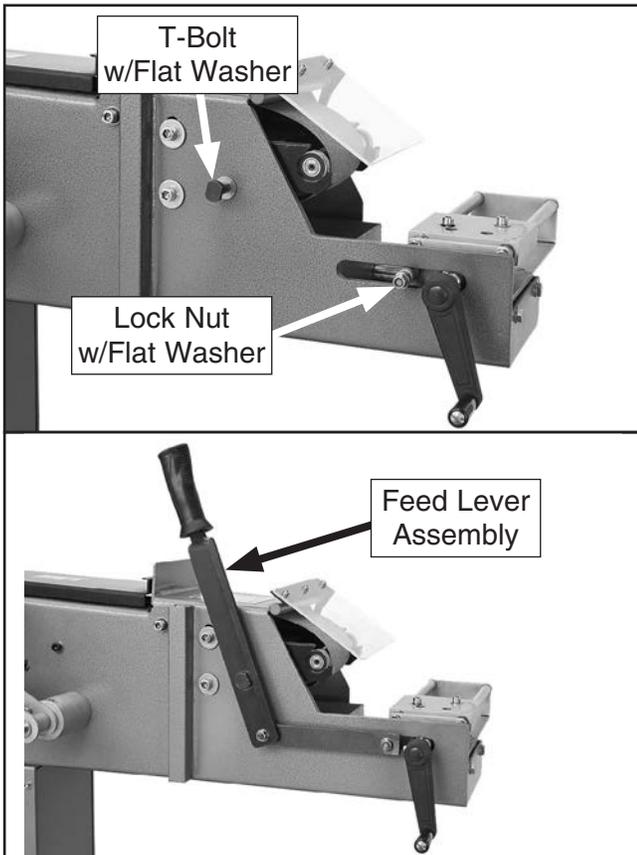


# Assembly

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

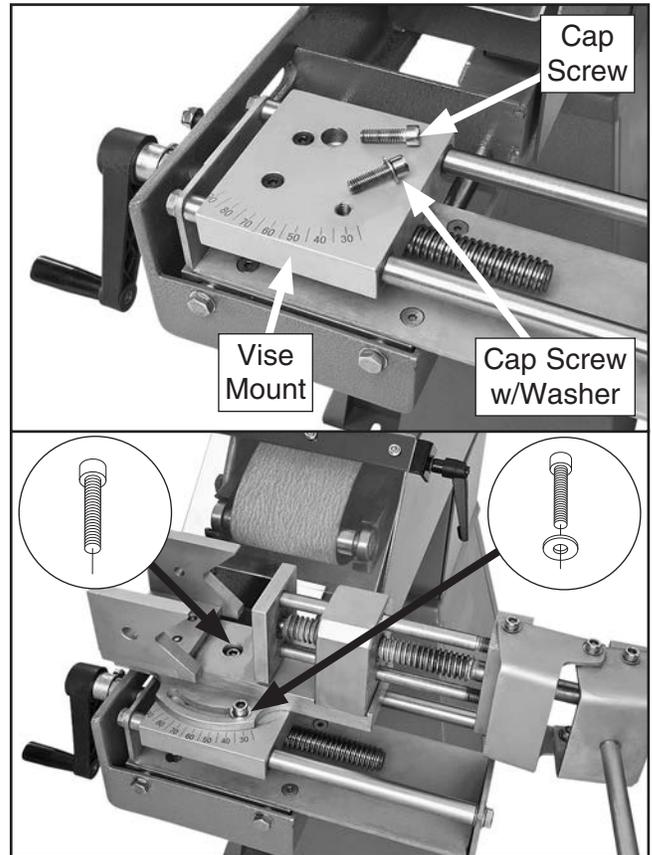
## To assemble machine:

1. Remove pre-installed T-bolt, lock nut, and flat washers (shown in **Figure 14**), then attach feed lever assembly to machine with same fasteners (see **Figure 14**).



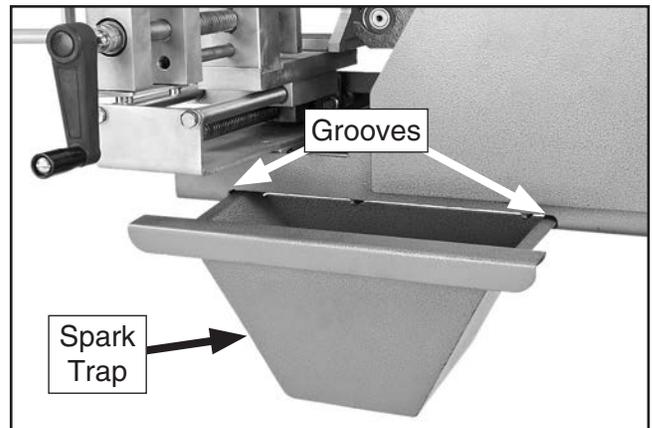
**Figure 14.** Feed lever assembly attached.

2. Remove pre-installed vise mounting cap screws and washer (shown in **Figure 15**), and then position vise assembly on vise mount and secure it to machine with same fasteners (see **Figure 15**).



**Figure 15.** Vise assembly attached.

3. Slide spark trap into grooves on right side of machine, as shown in **Figure 16**.



**Figure 16.** Spark trap positioned in grooves.



# Dust Collection

## **!WARNING**

### **EXPLOSION OR FIRE HAZARD**

**DO NOT** use any plastic duct material with this machine. The National Fire Protection Agency (NFPA) warns of explosion or fire hazard because of static electrical buildup if plastic or non-conductive duct material is used for metal dust collection and is not completely grounded and bonded.

## **!CAUTION**

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

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

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

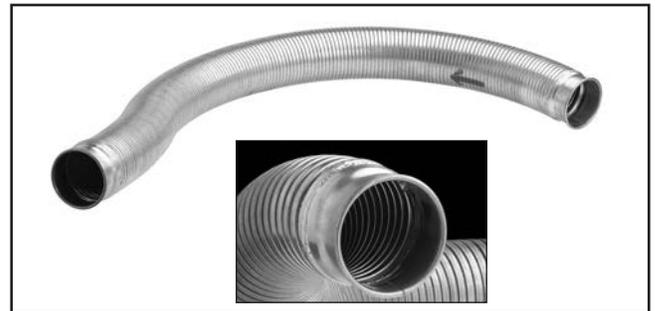
### **To connect dust collection system to machine:**

1. Fit a 4" metal flex hose over the dust port located at the rear deburring station. Secure it in place with a 4" hose clamp.
2. Tug hose to make sure it does not come off.

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

### **H7215—4" x 5' Rigid Metal Flex Hose**

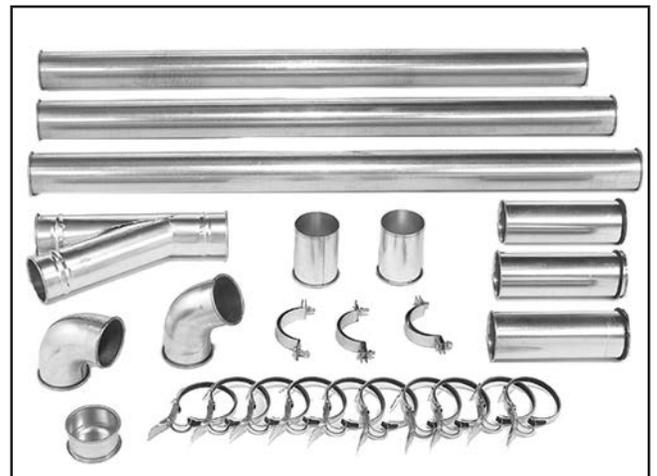
This flex hose provides just enough flexibility to make difficult connections while still keeping the inside wall as smooth as possible to minimize static pressure loss.



**Figure 17.** Rigid metal flex hose.

### **H5293—4" 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.

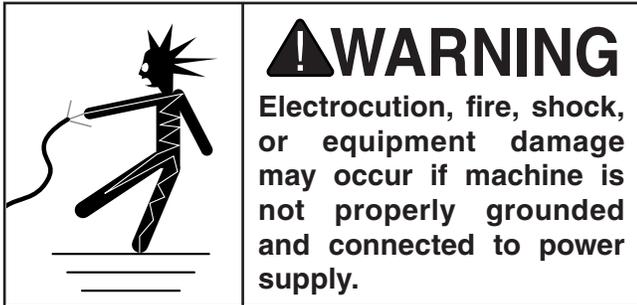


**Figure 18.** Metal duct starter kit.



# Power Connection

Before the machine can be connected to the power source a 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.



**Note About Extension Cords:** *Using an incorrectly-sized extension cord may decrease the life of electrical components on your machine. If you must use an extension cord, refer to **Extension Cords** on **Page 11** for more information.*

To connect plug to power cord, install L15-15 plug on end of power cord per plug manufacturer's instructions. If no instructions were included, use **Wiring Diagram** on **Page 39**.

# Test Run

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

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

The test run consists of verifying the following:  
1) The motor powers up and runs correctly and  
2) the emergency stop button works correctly.



To make the test run quicker and easier to perform, you will be instructed to remove the abrasive belt from the machine. If you choose to leave the belt on the machine for the test run, you **MUST** perform the **Replacing/Tensioning Abrasive Belt** procedure on **Page 24** and **Abrasive Belt Tracking** procedure on **Page 25** to make sure the belt is properly tensioned and tracked, and will not fall off the rollers during the test run.



### To test run machine:

1. Loosen cap screw securing belt cover and open cover to expose abrasive belt (see Figure 19).

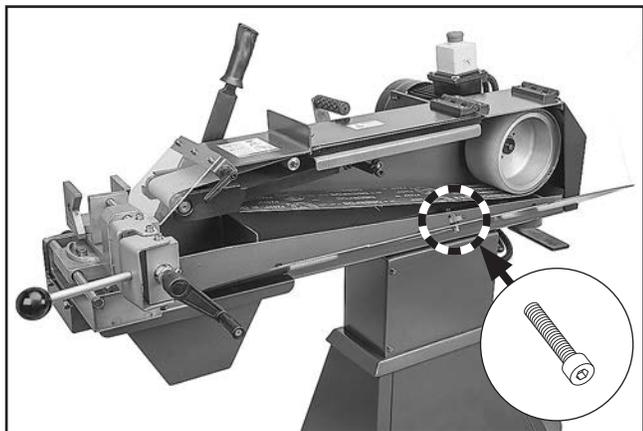


Figure 19. Belt cover opened.

2. Pull belt tension lever up and toward front of machine with one hand as you guide motor forward with other hand (see Figure 20). This releases abrasive belt tension.

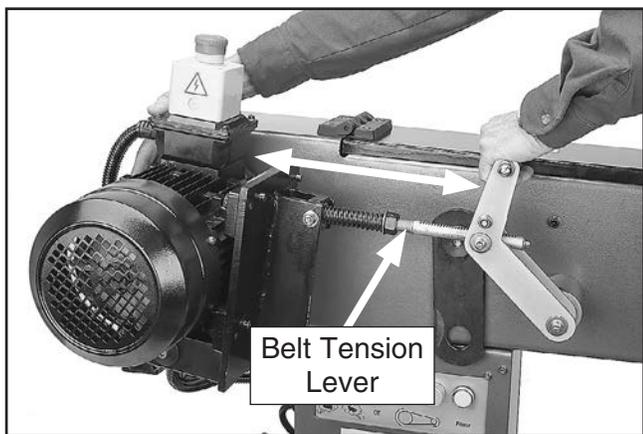


Figure 20. Releasing abrasive belt tension.

3. Remove abrasive belt.
4. Close and secure belt cover.
5. Clear all setup tools away from machine.
6. Connect machine to power supply.
7. Twist emergency stop button clockwise until it pops out—this resets switch so machine will start (see Figure 21).

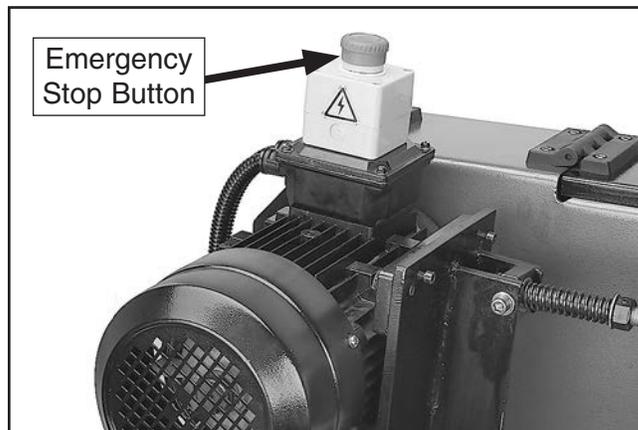


Figure 21. Location of emergency stop button.

8. Push ON button to start machine. A correctly operating machine runs smoothly with little or no vibration or rubbing noises.
9. Press emergency stop button to turn machine **OFF**.
10. **WITHOUT** resetting the emergency stop button, press ON button. Machine should *not* start.

— If machine *does* start (with emergency stop button in depressed position), immediately disconnect power to machine. The emergency stop button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

**Note:** To re-install abrasive belt, perform **Replacing/Tensioning Abrasive Belt** procedure on Page 24.

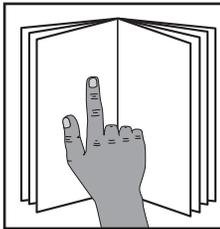


# SECTION 4: OPERATIONS

## Operation Overview

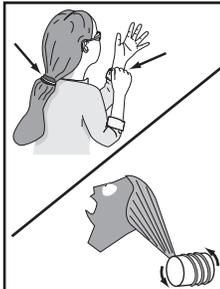
The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

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



### **!WARNING**

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



### **!WARNING**

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

### **!WARNING**

To reduce risk of eye or face injury from flying sparks, always wear approved safety glasses and a face shield when operating this machine.



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

1. Examines tube to make sure the diameter is appropriate for operation and the end does not have any burrs that could damage abrasive belt or machine.
2. Adjusts vise angle, if necessary, to correct angle of desired cut.
3. Makes sure abrasive belt is properly tensioned and tracking correctly.
4. Puts on personal protective equipment.
5. Secures tube in vise.
6. Properly adjusts spark shield.
7. Starts machine.
8. Uses feed lever and traverse crank to make light side-to-side passes of tube against abrasive belt.
9. Stops machine and removes tube.

### **NOTICE**

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



# Replacing/ Tensioning Abrasive Belt

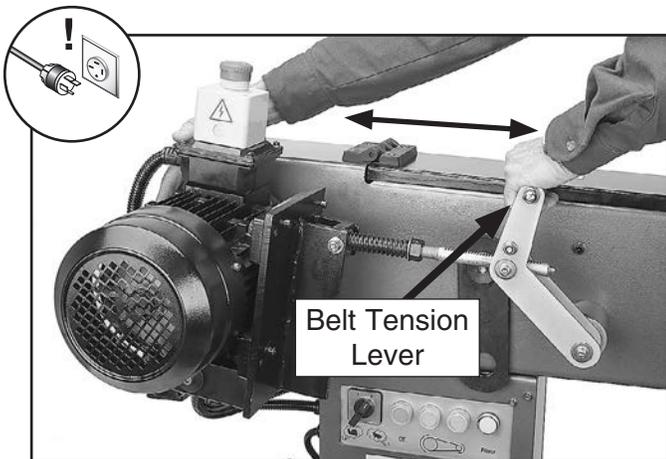
Whenever the abrasive belt becomes worn or damaged, replace it. The Model G0767Z uses a 4" x 79" silicon-carbide abrasive belt (refer to **Page 31** for abrasive belts available from Grizzly).

Use coarser grit belts for fast cutting and hard metals. Use finer grit belts for softer metals and a smoother finish.

Tool Needed	Qty
Hex Wrench 6mm.....	1

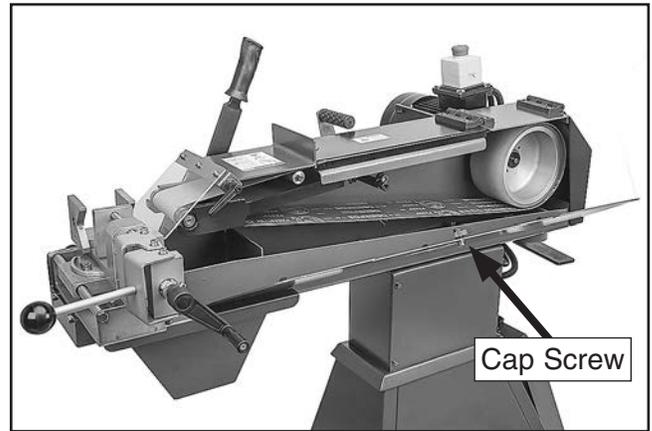
## To replace abrasive belt:

1. DISCONNECT MACHINE FROM POWER!
2. Pull belt tension lever up and toward front of machine with one hand as you guide motor forward with other hand (see **Figure 22**). This releases abrasive belt tension.



**Figure 22.** Releasing abrasive belt tension.

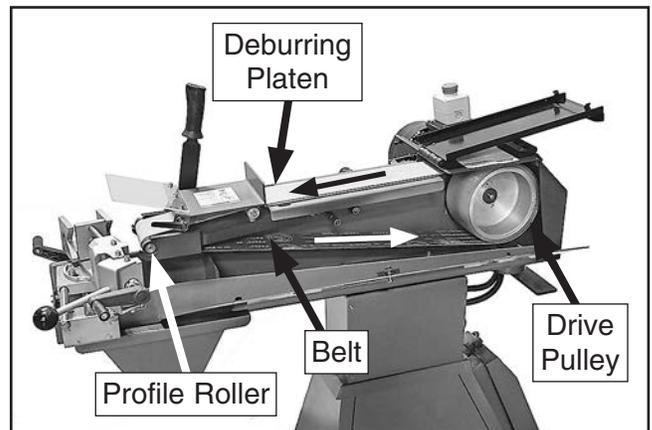
3. Loosen cap screw that secures belt cover (see **Figure 23**), then open cover and remove abrasive belt from machine.



**Figure 23.** Belt cover opened.

4. Place desired profile roller in support bracket (refer to **Changing Profile Rollers** on **Page 25** for instructions).
5. Slide abrasive belt onto profile roller, drive pulley, and over deburring platen so that direction arrows printed on inside of belt are pointing in same direction as arrows on machine (see **Figure 24**).

**Note:** Arrows on bottom inside of belt must point to the right.



**Figure 24.** Correct installation and orientation of abrasive belt.

6. Center belt on drive pulley.
7. Without holding abrasive belt lever, push motor back with moderate force until it stops. This applies correct abrasive belt tension.
8. Adjust abrasive belt tracking (refer to **Abrasive Belt Tracking** on **Page 25** for instructions).

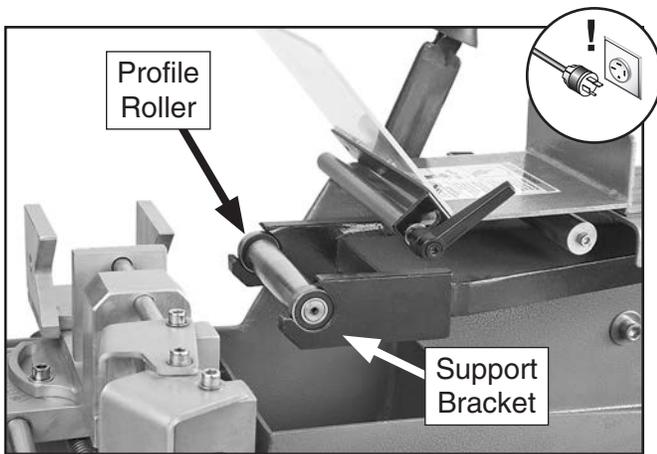


# Changing Profile Rollers

The Model G0767Z includes seven profile rollers ranging from  $\frac{3}{4}$ " to 3". The size of profile roller you use will depend on the size of tubing your workpiece will be mated to.

## To install profile roller:

1. DISCONNECT MACHINE FROM POWER!
2. Remove abrasive belt, then remove profile roller from support bracket (see **Figure 25**).



**Figure 25.** 1" profile roller installed.

3. Thoroughly clean all surfaces of profile roller with shop rag and mineral spirits, then apply a light coat of rust preventative before placing roller in storage cabinet.
4. Repeat **Step 3** with desired profile roller to be installed.
5. Place desired profile roller in support bracket and replace abrasive belt.

# Abrasive Belt Tracking

The abrasive belt must track in the center of the drive pulley and profile roller to avoid presenting an injury hazard or damaging the belt or machine.

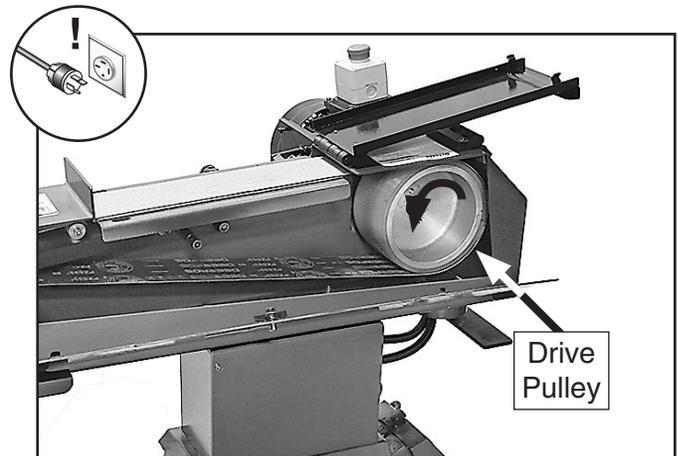
## Tools Needed

Qty

Hex Wrench 6mm.....	1
Hex Wrench 8mm.....	1

## Checking Abrasive Belt Tracking

1. DISCONNECT MACHINE FROM POWER!
2. Open belt and deburring station covers.
3. Rotate drive pulley (see **Figure 26**) counter-clockwise several times and watch how belt tracks on drive pulley.



**Figure 26.** Location of drive pulley.

- If abrasive belt tracks in center of drive pulley, close and secure belt and deburring station covers.
- If abrasive belt moves to one side or the other while it is rotating, the belt tracking needs to be adjusted. Perform **Adjusting Abrasive Belt Tracking** procedure on **Page 26**.



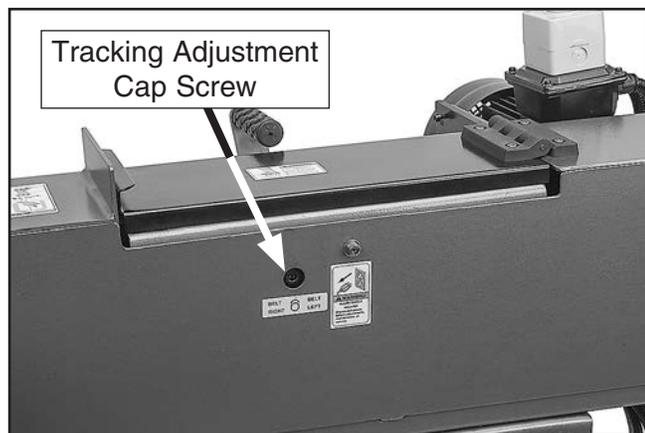
## Adjusting Abrasive Belt Tracking

Adjustments to the abrasive belt tracking are made with the machine running. These adjustments are made in small amounts to make sure the belt does not track too far from the center, which could damage the belt and machine.

### To adjust abrasive belt tracking:

1. Make sure belt and deburring station covers are closed and secured.
2. Have another person position his hand over emergency stop button to quickly turn machine **OFF** and prevent damage if abrasive belt moves too close to side of machine.
3. Connect machine to power, turn it **ON**, and observe to which side abrasive belt tracks.

— If abrasive belt tracks to the *left* (as viewed from front of machine), rotate tracking adjustment cap screw (see **Figure 27**) *counterclockwise* in small amounts until abrasive belt tracks in center.



**Figure 27.** Location of tracking adjustment cap screw.

— If abrasive belt tracks to the *right* (as viewed from front of machine), rotate tracking adjustment cap screw *clockwise* in small amounts until abrasive belt tracks in center.

## Operational Tips

- Hot particles flying off of abrasive belt travel very fast—prepare for this! Wear proper personal protective equipment.
- Grinding metal produces flying sparks. DO NOT allow anyone to stand in path of sparks. DO NOT grind near flammable materials or combustible fumes.
- When grinding against the profile roller, make sure all covers are closed securely and spark shield is properly positioned.
- Use multiple light passes instead of a few heavy passes to increase the life of abrasive belt and decrease the need to deburr along notch edges.
- Make sure the tube is firmly secured in the vise and any tube longer than 3' is supported at the opposite end by another person.
- Tube will get hot as you continue grinding operations. Cool it frequently by quenching in water or quenching salt solution.
- Change belts frequently and use the correct grit for best performance.
- DO NOT force or jam tube into abrasive belt.
- When deburring, hold tube securely with both hands. Use rest when possible to support the tube.
- Concentrate on task at hand. STOP grinding if you become distracted.
- When not in use, release abrasive belt tension to increase life of belt.



# Making Notches

Making a notch in the tube consists of preparing the tube, properly setting up the machine, mounting the tube in the vise, and grinding the notch.

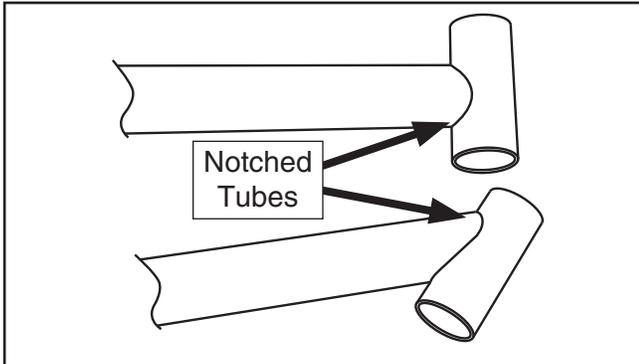
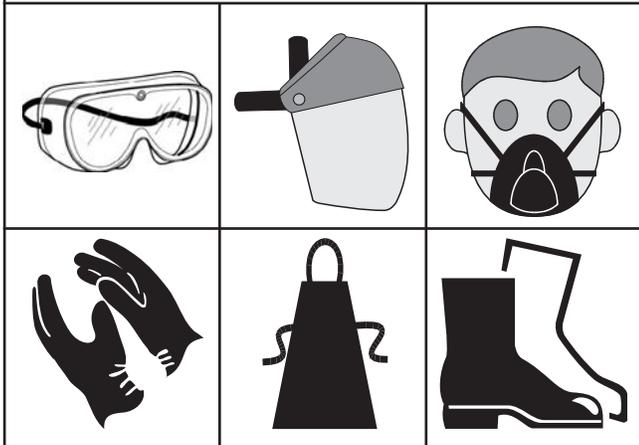


Figure 28. Examples of fitting notched tubes.

## ! WARNING

### PERSONAL PROTECTIVE EQUIPMENT (PPE)

This machine produces a large amount of sparks that can cause burns and injuries to skin, eyes, and face. ALWAYS wear protective equipment to reduce the risk of injury from flying sparks when operating.



## ! WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.



## ! WARNING

### EXPLOSION OR FIRE HAZARD

ALWAYS empty spark trap and clean machine thoroughly before switching workpiece metal types. DO NOT allow dust from different metal types to mix in spark trap and on machine.

#### Items Needed

Qty

Hex Wrench 6mm..... 1

#### To make a notch:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure tube end to be notched is smoothly cut without any burrs.
3. Install profile roller that will produce correct diameter notch for size of tubing your workpiece will be welded to. (Refer to **Replacing Profile Rollers** on Page 25 for instructions.)
4. Make sure abrasive belt is properly tensioned and tracking correctly. (Refer to **Abrasive Belt Tracking** on Page 25 for instructions.)
5. Push feed lever (see Figure 29) toward motor to move vise away from abrasive belt.

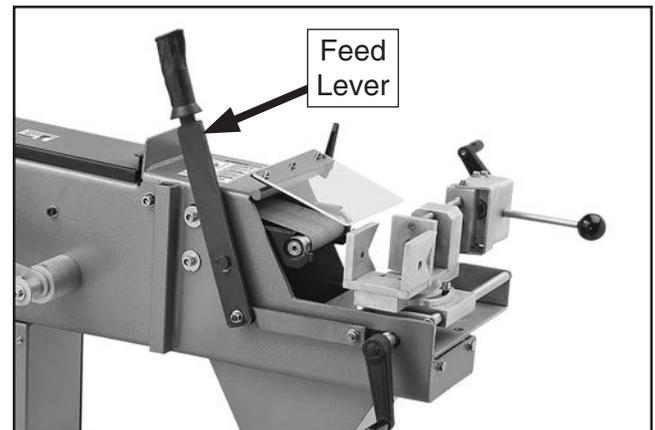
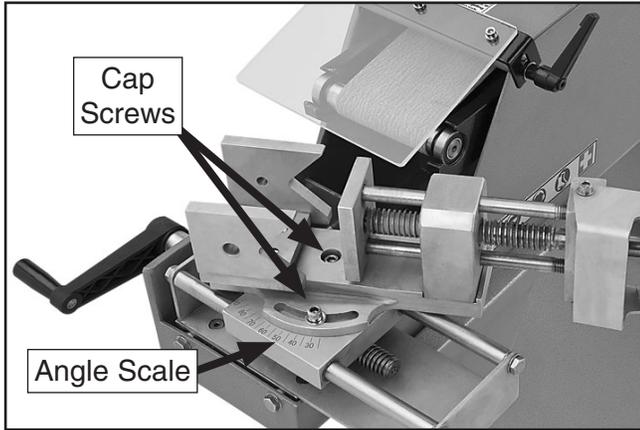


Figure 29. Feed lever pushed toward motor.

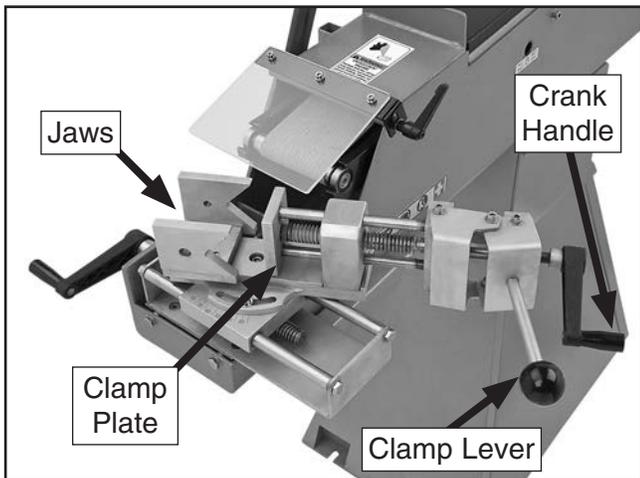


- Loosen vise cap screws (see **Figure 30**).



**Figure 30.** Vise angle controls.

- Using angle scale, rotate vise to desired angle of notch (from 90° to 30° in relation to front profile roller), then retighten both cap screws.
- Use crank handle (see **Figure 31**) to adjust space between clamp plate and jaws to accept tube.



**Figure 31.** Vise clamping controls.

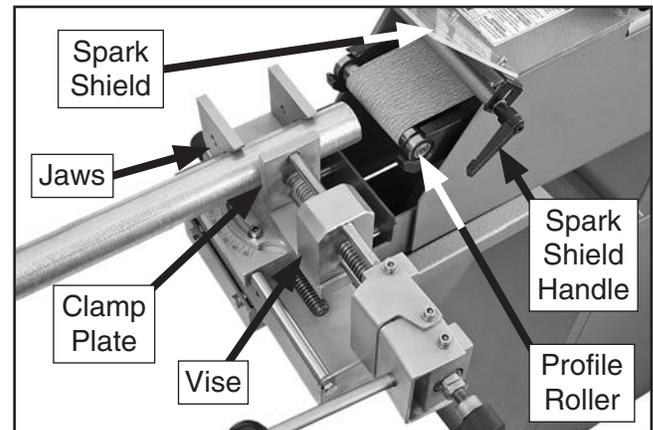
## **!WARNING**

When mounting tubes longer than 3', have another person support end of tube. This will reduce risk of tube unexpectedly coming loose in vise during operation and causing impact injuries or equipment damage.

## **NOTICE**

In next step, make sure tube end you plan to notch is protruding far enough out of vise that vise will not contact belt during operation. Otherwise, material and equipment damage may occur.

- Insert tube between jaws and clamp plate (see **Figure 32**), making sure tube extends far enough that notching operation can be performed without vise contacting belt.



**Figure 32.** Tube inserted in vise.

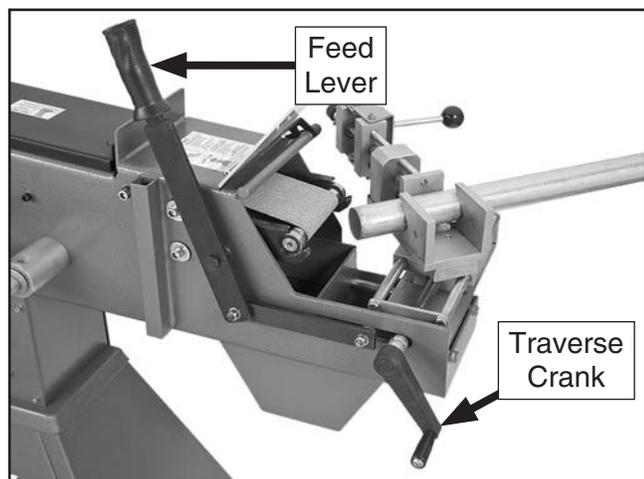
- Loosen clamp lever (see **Figure 31**), then use crank handle to position clamp plate within 1/16" of tube.
- Tighten clamp lever to lock tube in place.

**Note:** If it is difficult to secure tube with clamp lever, use crank handle to slightly increase distance between clamp plate and tube, then try again.



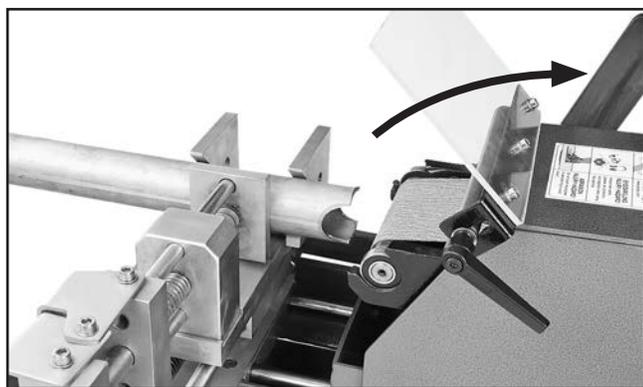
12. Position spark shield over profile roller and lock it in place (see **Figure 32** on **Page 28**).
13. Turn machine **ON/Clockwise** and wait until abrasive belt reaches full speed. Stand to side of machine to avoid path of sparks during next step.
14. Use feed lever (see **Figure 33**) to slowly move tube into contact with abrasive belt. Use traverse crank to move tube back and forth across abrasive belt as contact is made.

**Note:** Moving tube back and forth across abrasive belt reduces wear in any one spot and increases life of belt.



**Figure 33.** Feed and traverse controls.

15. When notch is complete, use feed lever to move tube away from abrasive belt (see **Figure 34** for an example).



**Figure 34.** Example of notch in end of tubing.

16. Turn machine **OFF**, wait for abrasive belt to completely stop, then loosen clamp lever and remove tube.

## Deburring

Sharp burrs in the tube are typically created during notching. These should be ground off for safe handling and clean welds. Use the top deburring station to grind off burrs from large workpieces; use the rear deburring station to grind off burrs from small workpieces that require more support.

### **!WARNING**

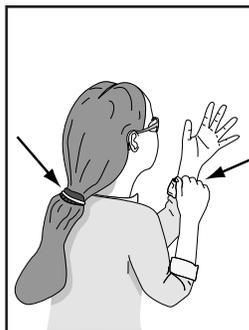
#### **PERSONAL PROTECTIVE EQUIPMENT (PPE)**

This machine produces a large amount of sparks that can cause burns and injuries to skin, eyes, and face. **ALWAYS** wear protective equipment to reduce the risk of injury from flying sparks when operating.



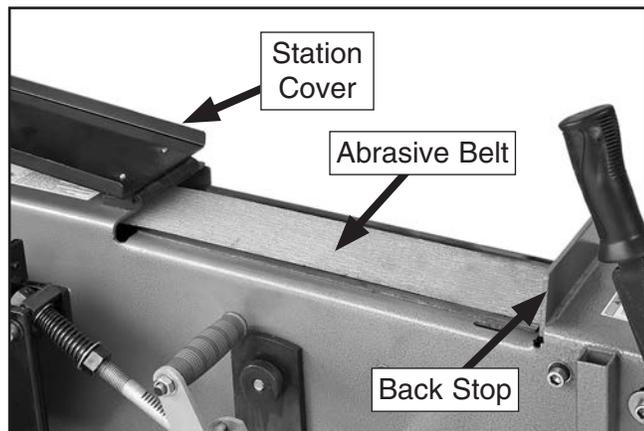
### **!WARNING**

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.



## Using Top Deburring Station

1. Open top station cover to expose abrasive belt (see **Figure 35**).



**Figure 35.** Top deburring station.

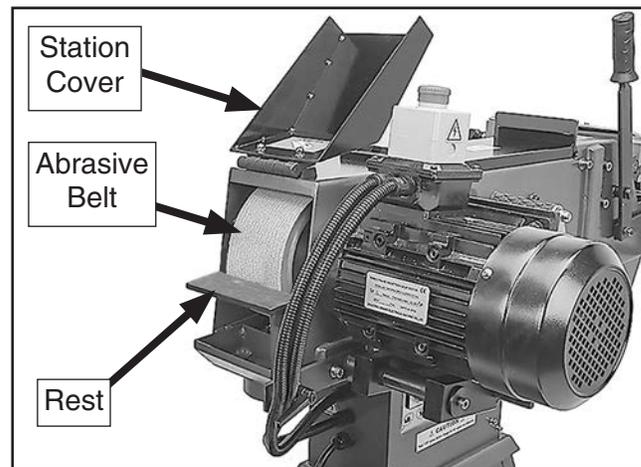
2. Push **ON/Clockwise** button, then wait until abrasive belt reaches full speed.

**IMPORTANT:** *Make sure abrasive belt travels towards front of machine.*

3. Stand to side of machine and position workpiece at a slight angle to abrasive belt, against back stop (see **Figure 35**), and then slowly make light contact with belt. Move and rotate tube as needed to remove burrs.
4. When finished, turn machine **OFF**, wait for abrasive belt to completely stop, and close deburring station cover.

## Using Rear Deburring Station

1. Open rear station cover to expose abrasive belt (see **Figure 36**).



**Figure 36.** Rear deburring station.

2. Adjust and secure workpiece rest in position (see **Figure 36**).

3. Push the **ON/Counterclockwise** button, then wait until abrasive belt reaches full speed.

**IMPORTANT:** *Make sure abrasive belt travels towards rear of machine.*

4. Stand behind machine and position workpiece at a slight angle to abrasive belt, against rest (see **Figure 36**), and then slowly make light contact with belt. Move and rotate tube as needed to remove burrs.
5. When finished, turn machine **OFF**, wait for abrasive belt to completely stop, and close deburring station cover.



# SECTION 5: ACCESSORIES

## **! WARNING**

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

## **NOTICE**

Refer to our website or latest catalog for additional recommended accessories.

### **4" x 79" Silicon-Carbide Abrasive Belts**

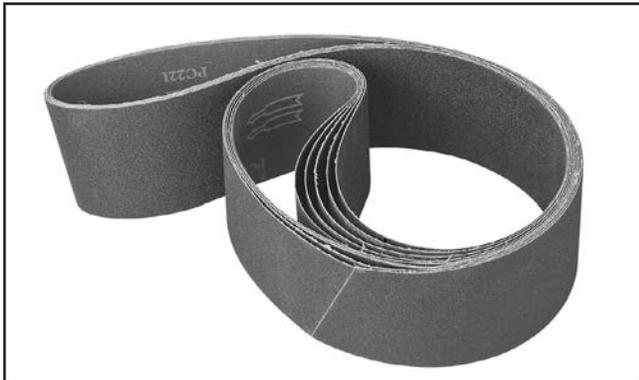
T26604—60-Grit, 10-Pk.

T26605—80-Grit, 10-Pk.

T26606—100-Grit, 10-Pk.

T26607—120-Grit, 10-Pk.

T26608—150-Grit, 10-Pk.



**Figure 37.** 4" x 79" Silicon-Carbide Abrasive Belts.

### **Hydraulic Tube Benders**

Any serious do-it-yourselfer or job shop must have one of these! The included bending dies are sized in pipe diameters.

#### **G9017—12-Ton**

Capacities:

- 1/2", 3/4", 1", 1 1/4", 1 1/2", and 2" pipe
- 2" maximum pipe size while bending to 90°
- Schedule 40 wall thickness

#### **G9018—16-Ton**

Capacities:

- 1/2", 3/4", 1", 1 1/4", 1 1/2", 2 1/2", and 3" pipe
- 3" maximum pipe size while bending to 90°
- Schedule 40 wall thickness



**Figure 38.** G9017 Hydraulic Tube Bender.

#### **G0818—Metal Dust Collector**

The G0818 helps keep your shop safe and clean. This sturdy steel-constructed dust collector features a removable chip clean-out drawer for easy disposal of metal chips and collected particulate. Incoming air from the dual 4" inlets passes through a three-stage filtering system that includes a 30-micron stainless steel filter, 5-micron active carbon filter, and a pleated 1-micron filter. An industrial-duty 220V, 1.5 HP direct-drive motor powers the 12-3/4" aluminum impeller for an impressive 755 CFM! Also features locking caster wheels and a push handle for easy placement and positioning.



**Figure 39.** G0818 Metal Dust Collector.



### G0622—4" x 6" Metal-Cutting Bandsaw

This metal-cutting bandsaw is perfect for the small shop. It features a maximum cutting capacity of 4½" round and 4½" x 6" rectangular, three cutting speeds, automatic shut-off, and a vertical cutting attachment.



Figure 40. G0622 4" x 6" Metal-Cutting Bandsaw.

### G0783—11" Slow-Speed Cold Cut Saw

This machine's 2.7 HP, 220V, 3-phase motor and gear drive produce a blade speed of either 114 RPM or 57 RPM. It features a dual-vise system that clamps on each side of the blade and a coolant system prevents the blade from overheating. A perfect choice for clean, precise, spark-free metal cutting!



Figure 41. G0783 11" Slow-Speed Cold Cut Saw.

### Phase Converters

#### G5843— Static Phase Converter

Capacities:

- Operates 3-phase motors at 70% continuous horsepower or 90% intermittent-duty
- For 3–7 HP motors

#### G5844—Rotary Phase Converter

Features:

- Operates 3-phase motors at at 100% power and 95% efficiency
- For 5 HP motors
- "Stackable" for higher HP requirements

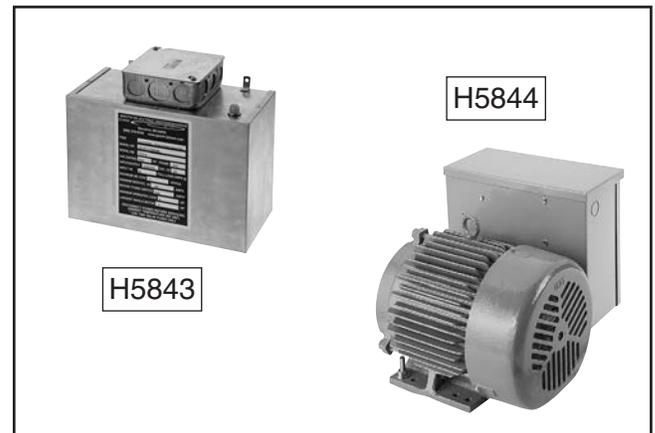
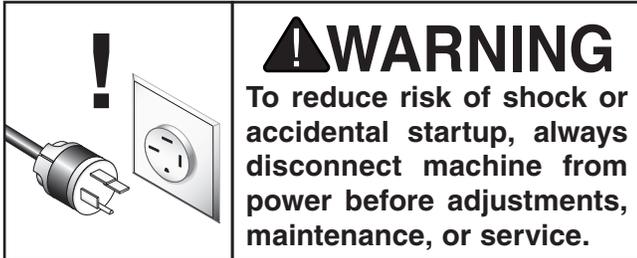


Figure 42. H5843 and H5844 Phase Converters.



# SECTION 6: MAINTENANCE

## Schedule



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

### Ongoing:

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

- Loose mounting bolts.
- Worn or damaged abrasive belt.
- Debris in spark trap.
- Debris on or around machine.
- Worn or damaged wires.
- Any other unsafe condition.

### Weekly Maintenance

- Clean machine.
- Clean and protect profile rollers.
- Clean and lubricate vise guide rods and leadscrews.

## Cleaning

Use a shop vacuum to remove debris from the outside of the machine, especially from the moving parts of the belt tension lever and vise. Open the belt and deburring station covers, remove the abrasive belt, and vacuum all debris from inside machine, rollers, and deburring platen. Vacuum debris on floor around the machine on a daily basis.

Wipe the profile rollers clean with shop rags and mineral spirits. When dry, apply a light coat of rust preventative.

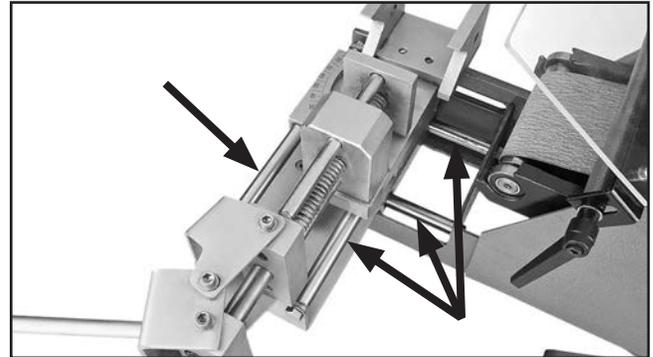
Model G0767Z (Mfd. Since 11/17)



## Lubrication

### Vise Guide Rods

The tube vise moves side-to-side and front-to-back on four guide rods (see **Figure 43**).

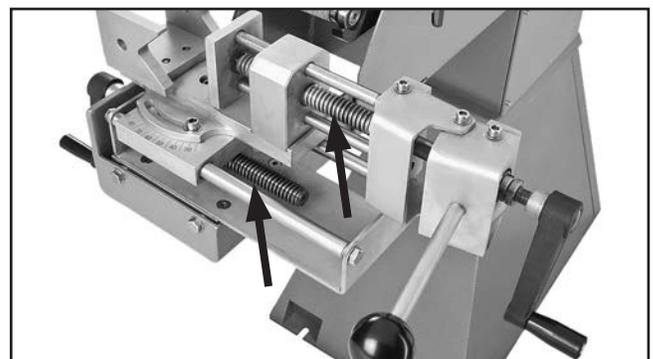


**Figure 43.** Locations of vise guide rods.

Move the vise as necessary to access the full length of the guide rods and clean any debris from their surfaces with shop rags and mineral spirits. When dry, wipe guide rods with light machine oil using a clean shop rag.

### Leadscrews

The vise has two leadscrews (see **Figure 44**). Move the vise as necessary through the full length of the leadscrews and clean any debris from the threads with a stiff brush and mineral spirits. When dry, apply a thin coat of light machine oil and work the lubricant into the threads with a clean, stiff brush. Wipe away any excess oil. Move the vise through the full length of each leadscrew to distribute the oil.

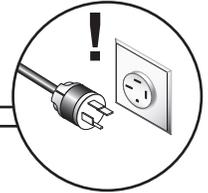


**Figure 44.** Locations of vise leadscrews.

# SECTION 7: SERVICE

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

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>Emergency Stop button engaged/at fault.</li> <li>Power supply switched <b>OFF</b> or at fault.</li> <li>Motor connection wired incorrectly.</li> <li>Thermal overload relay has tripped.</li> <li>Power supply fuse/circuit breaker is blown/tripped.</li> <li>Contactors not getting energized or has burnt contacts.</li> <li>Wiring is open/has high resistance.</li> <li>Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Rotate clockwise until it pops out/replace.</li> <li>Ensure power supply is switched <b>ON</b>; ensure power supply has correct voltage.</li> <li>Correct motor wiring connections (<b>Page 39</b>).</li> <li>Disconnect machine from power, turn amperage dial on thermal overload relay to a higher setting (<b>Page 39</b>).</li> <li>Ensure power supply circuit size is adequate for this machine (<b>Page 10</b>); replace weak breaker.</li> <li>Test for power on all legs and contactor operation. Replace if faulty.</li> <li>Check for broken wires or disconnected/corroded connection; repair/replace as necessary.</li> <li>Test/repair/replace.</li> </ol>
Machine stalls or is overloaded.	<ol style="list-style-type: none"> <li>Feed rate too fast.</li> <li>Motor connection wired incorrectly.</li> <li>Machine undersized for task.</li> <li>Motor has overheated.</li> <li>Contactors not getting energized/has burnt contacts.</li> <li>Motor bearings at fault.</li> <li>Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Reduce feed rate.</li> <li>Correct motor wiring connections (<b>Page 39</b>).</li> <li>Use new abrasive belt with appropriate grit; reduce feed rate.</li> <li>Clean off motor, let cool, and reduce workload.</li> <li>Test for power on all legs and contactor operation. Replace if faulty.</li> <li>Test by rotating motor shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>Test/repair/replace.</li> </ol>
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> <li>Motor mounting loose.</li> <li>Motor fan hitting cover.</li> <li>Abrasive belt worn/damaged/torn.</li> </ol>	<ol style="list-style-type: none"> <li>Retighten motor mount fasteners.</li> <li>Repair/replace motor fan; remove any dents in cover.</li> <li>Replace abrasive belt (<b>Page 24</b>).</li> </ol>



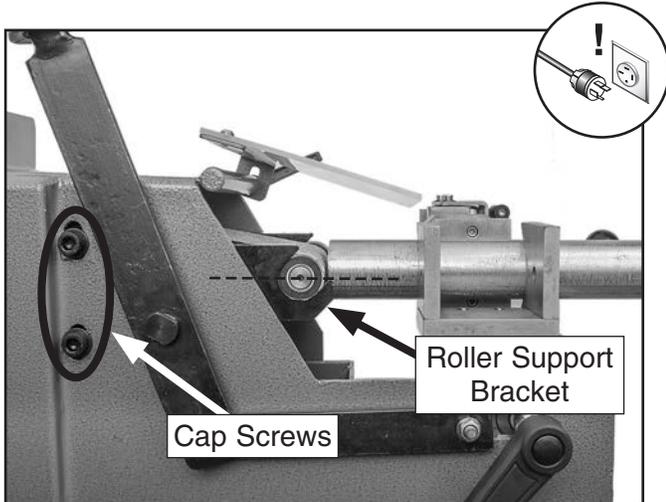
## Operation

Symptom	Possible Cause	Possible Solution
Abrasive belt stops rotating under load.	<ol style="list-style-type: none"> <li>1. Abrasive belt not properly tensioned.</li> <li>2. Feed rate too fast.</li> </ol>	<ol style="list-style-type: none"> <li>1. Properly tension abrasive belt (<b>Page 24</b>).</li> <li>2. Reduce feed rate.</li> </ol>
Abrasive belt tracks to one side under load.	<ol style="list-style-type: none"> <li>1. Abrasive belt tracking not properly set.</li> <li>2. Abrasive belt not properly tensioned.</li> </ol>	<ol style="list-style-type: none"> <li>1. Properly set abrasive belt tracking (<b>Page 25</b>).</li> <li>2. Properly tension abrasive belt (<b>Page 24</b>).</li> </ol>
Abrasive belt excessively worn in one spot.	<ol style="list-style-type: none"> <li>1. Tube not moved across face of abrasive belt during operation.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use traverse crank to evenly move tube across face of abrasive belt during operation (<b>Page 29</b>).</li> </ol>
Tube has burn marks at notch.	<ol style="list-style-type: none"> <li>1. Abrasive belt worn/not correct grit for task.</li> <li>2. Feed rate too fast.</li> </ol>	<ol style="list-style-type: none"> <li>1. Use new abrasive belt with appropriate grit.</li> <li>2. Reduce feed rate.</li> </ol>
Notch not centered on tube.	<ol style="list-style-type: none"> <li>1. Profile roller not even with center of tube.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust profile roller height (<b>Page 36</b>).</li> </ol>



# Adjusting Profile Roller Height

To produce an accurate notch, the center of the profile roller must be even with the center of the tube when mounted in the vise (see **Figure 45**).



**Figure 45.** Profile roller and tube even with each other.

The correct height of the profile roller depends on the height of the roller support bracket. This was set properly at the factory. However, if you determine that the center of the profile roller is not even with the center of the tube when mounted in the vise, perform the following procedure to adjust it.

Items Needed	Qty
Hex Wrench 8mm.....	1

## To adjust roller support bracket height:

1. DISCONNECT MACHINE FROM POWER!
2. Properly mount tube in vise.
3. Loosen roller support bracket cap screws (see **Figure 45**).
4. Move profile roller up or down to center profile roller with center of tube.
5. Retighten cap screws loosened in **Step 3**.

# Emptying Spark Trap

## ⚠ WARNING

### EXPLOSION OR FIRE HAZARD

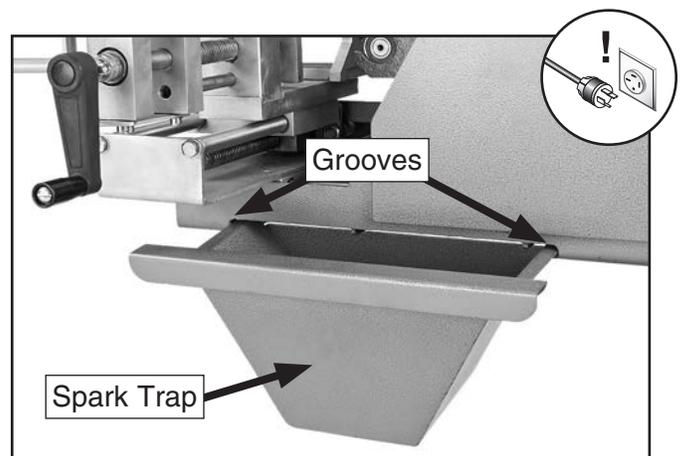
**ALWAYS** empty spark trap and clean machine thoroughly before switching workpiece metal types. **DO NOT** allow dust from different metal types to mix in spark trap and on machine.

## ⚠ WARNING

Wear ANSI-approved safety goggles, a NIOSH-approved respirator, and leather gloves when emptying spark trap. Minimize amount of dust allowed to become airborne, and prevent spread of dust onto clothing. Dispose of all waste properly according to local regulations for material type.

Empty spark trap contents daily or before switching to a new material type. *Do not* allow dust from different material types to mix. Dust particles can, depending on material type and circumstances react and ignite. Dispose of waste according to local regulations for material type.

The spark trap slides into grooves on the right side of the machine (see **Figure 46**).



**Figure 46.** Spark trap positioned in grooves.



# SECTION 8: WIRING

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

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

## WARNING

### Wiring Safety Instructions

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

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

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

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

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

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

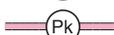
**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

#### NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

#### COLOR KEY

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



# Electrical Components

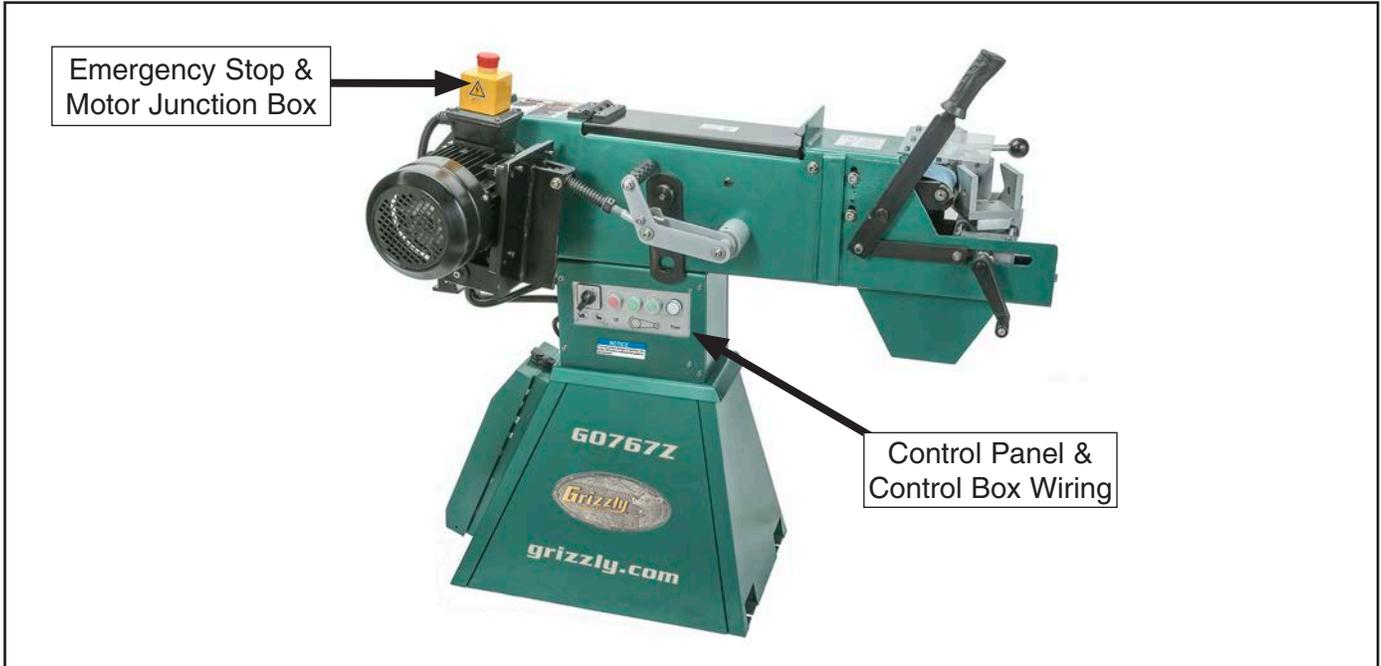


Figure 47. Wiring component overview.

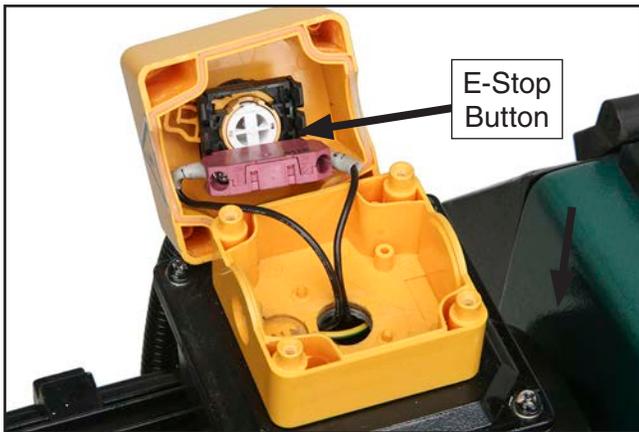


Figure 48. Emergency stop button wiring.

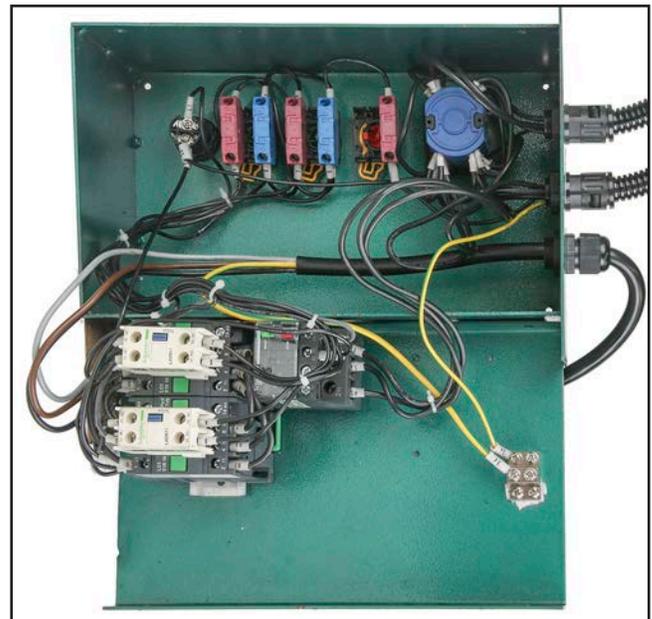


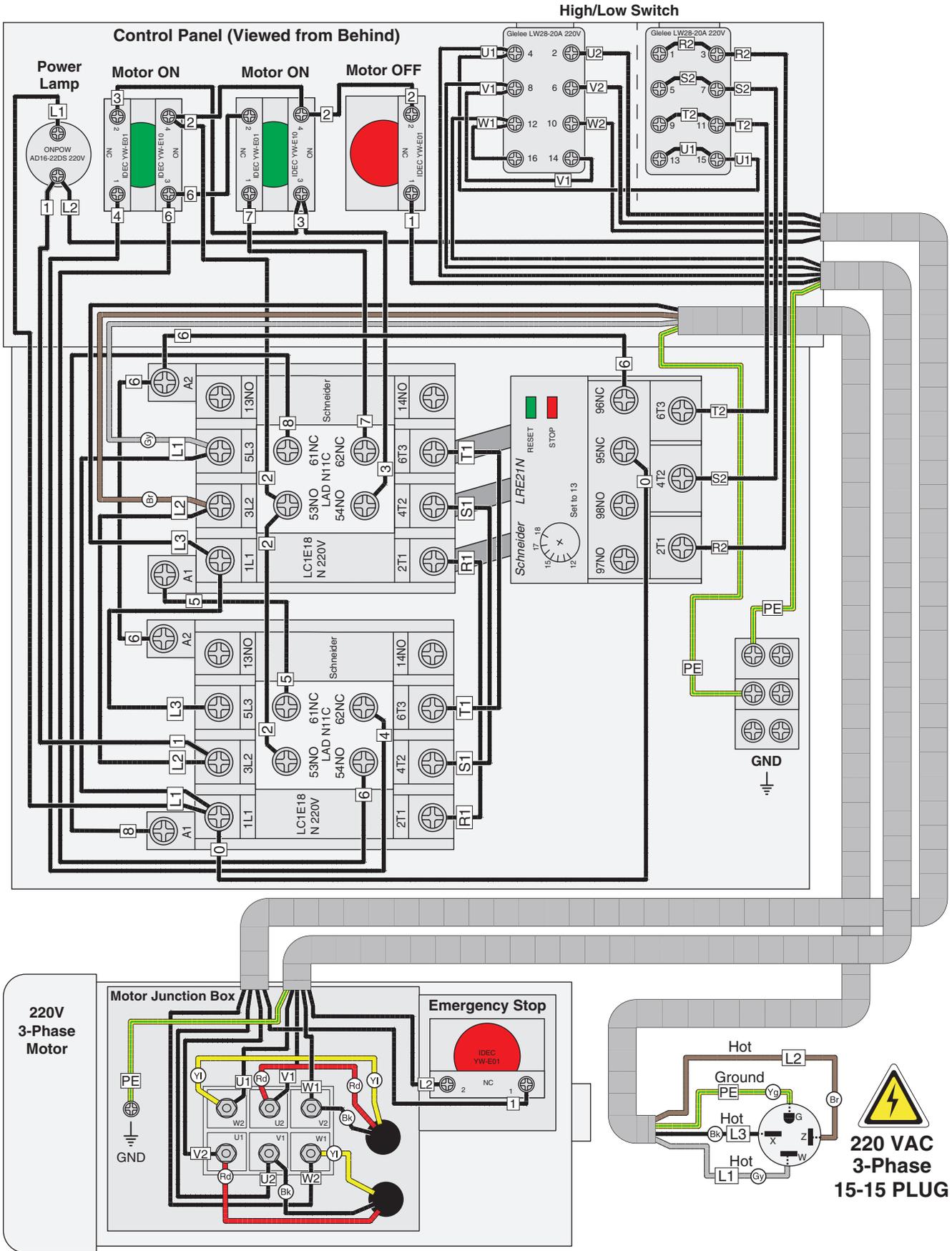
Figure 50. Control panel and control box wiring.



Figure 49. Motor junction box wiring.



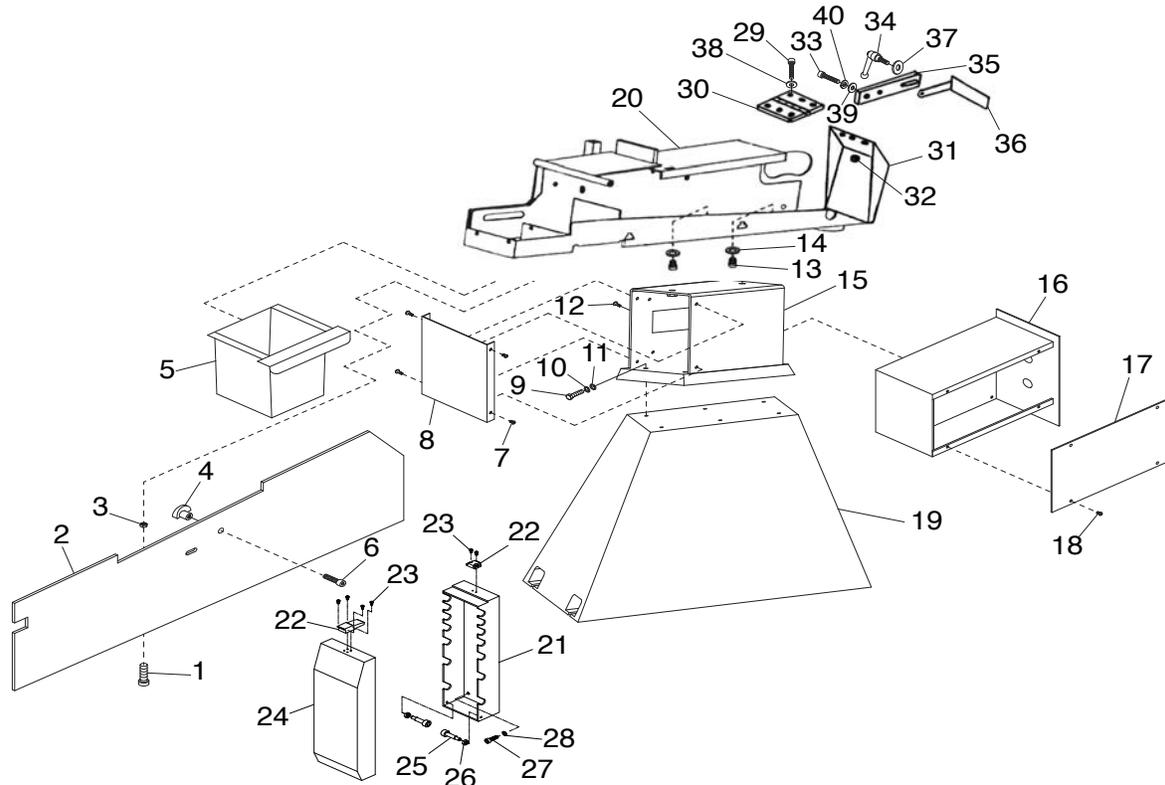
# Wiring Diagram



# SECTION 9: 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](http://www.grizzly.com/parts) to check for availability.

## Body

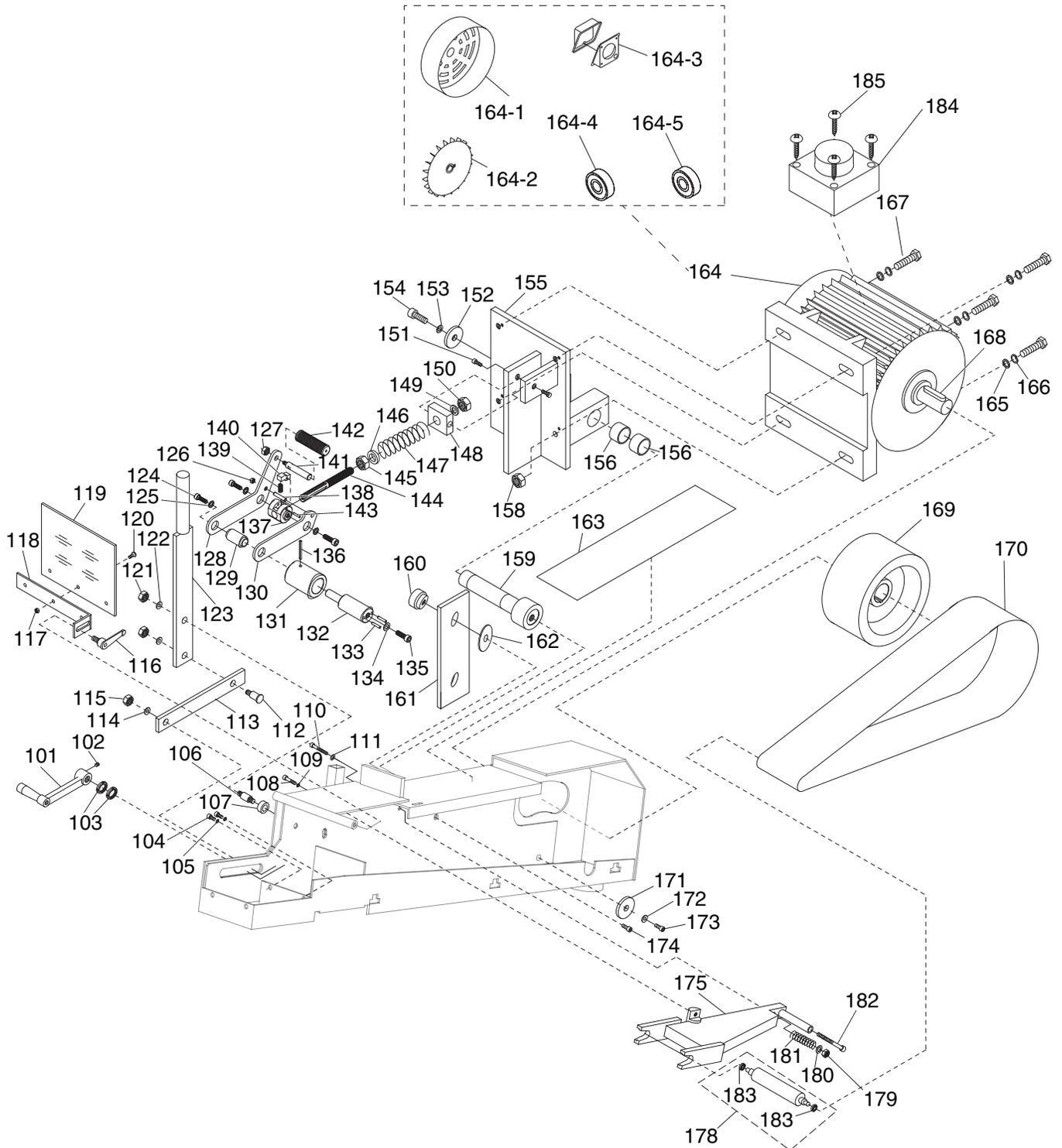


REF	PART #	DESCRIPTION
1	P0767Z001	CAP SCREW M5-.8 X 12
2	P0767Z002	BELT COVER (SIDE)
3	P0767Z003	HEX NUT M5-.8
4	P0767Z004	BELT COVER LATCH
5	P0767Z005	SPARK TRAP
6	P0767Z006	CAP SCREW M8-1.25 X 12
7	P0767Z007	PHLP HD SCR M5-.8 X 8
8	P0767Z008	RISER FRONT PLATE
9	P0767Z009	HEX BOLT M8-1.25 X 20
10	P0767Z010	LOCK WASHER 8MM
11	P0767Z011	FLAT WASHER 8MM
12	P0767Z012	PHLP HD SCR M6-1 X 10
13	P0767Z013	CAP SCREW M12-1.75 X 35
14	P0767Z014	FLAT WASHER 12MM
15	P0767Z015	RISER
16	P0767Z016	ELECTRICAL CABINET
17	P0767Z017	ELECTRICAL MOUNTING BOARD
18	P0767Z018	PHLP HD SCR M4-.7 X 6
19	P0767Z019	BASE
20	P0767Z020	BODY

REF	PART #	DESCRIPTION
21	P0767Z021	PROFILE ROLLER STORAGE RACK
22	P0767Z022	COVER LATCH
23	P0767Z023	PHLP HD SCR M3-.5 X 5
24	P0767Z024	STORAGE RACK COVER
25	P0767Z025	SHOULDER SCR M5-.8 X 8, 6 X 16
26	P0767Z026	HEX NUT M6-1
27	P0767Z027	CAP SCREW M8-1.25 X 20
28	P0767Z028	FLAT WASHER 8MM
29	P0767Z029	CAP SCREW M6-1 X 16
30	P0767Z030	HINGE
31	P0767Z031	REAR COVER
32	P0767Z032	HEX NUT M6-1
33	P0767Z033	CAP SCREW M8-1.25 X 16
34	P0767Z034	ADJUSTABLE HANDLE 90L, M10-1.5 X 17
35	P0767Z035	WORK REST MOUNTING PLATE
36	P0767Z036	WORK REST
37	P0767Z037	FENDER WASHER 10MM
38	P0767Z038	FLAT WASHER 6MM
39	P0767Z039	FLAT WASHER 8MM
40	P0767Z040	LOCK WASHER 8MM



# Motor & Belt Rollers



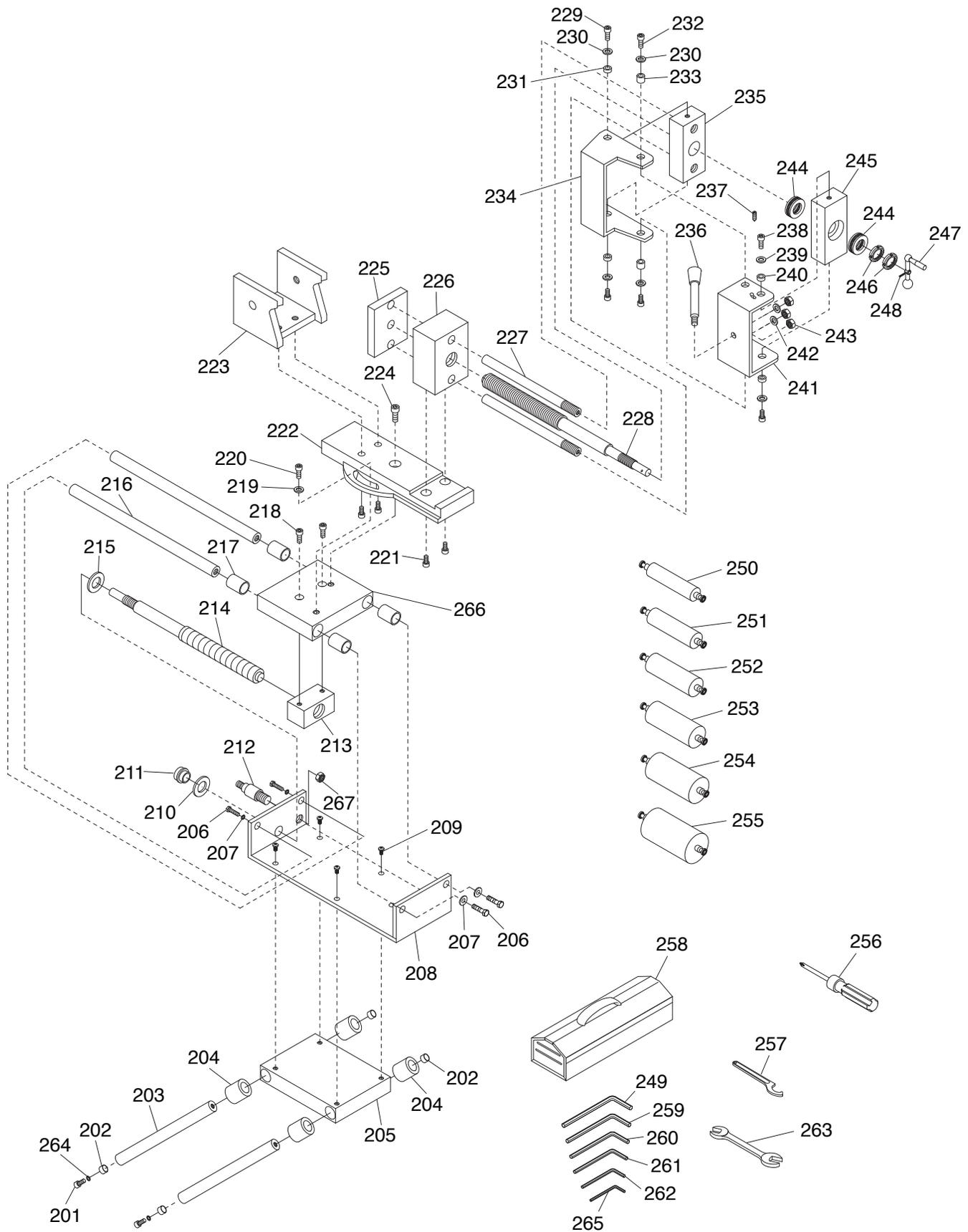
# Motor & Belt Rollers Parts List

REF	PART #	DESCRIPTION
101	P0767Z101	CRANK 5"L W/HANDLE
102	P0767Z102	SET SCREW M6-1 X 8 CONE-PT
103	P0767Z103	SPANNER NUT M12-1.25
104	P0767Z104	CAP SCREW M8-1.25 X 25
105	P0767Z105	FLAT WASHER 8MM
106	P0767Z106	STUD-DE M8-1.25 X 37, 9
107	P0767Z107	SPACER
108	P0767Z108	CAP SCREW M12-1.75 X 35
109	P0767Z109	FLAT WASHER 12MM
110	P0767Z110	CAP SCREW M8-1.25 X 100
111	P0767Z111	FLAT WASHER 8MM
112	P0767Z112	STEP BOLT M8-1.25 X 12
113	P0767Z113	CONNECTING BAR
114	P0767Z114	FLAT WASHER 8MM
115	P0767Z115	HEX NUT M8-1.25
116	P0767Z116	HANDLE 55L, M8-1.25 X 20
117	P0767Z117	HEX NUT M5-.8
118	P0767Z118	EYE SHIELD BRACKET
119	P0767Z119	EYE SHIELD (PLASTIC)
120	P0767Z120	PHLP HD SCR M5-.8 X 8
121	P0767Z121	HEX NUT M10-1.5
122	P0767Z122	FLAT WASHER 10MM
123	P0767Z123	LEVER W/GRIP
124	P0767Z124	CAP SCREW M8-1.25 X 14
125	P0767Z125	FENDER WASHER 8MM
126	P0767Z126	ACORN NUT M8-1.25
127	P0767Z127	ACORN NUT M10-1.5
128	P0767Z128	CONNECTING PLATE (LS)
129	P0767Z129	SUPPORT SLEEVE
130	P0767Z130	CONNECTING PLATE (RS)
131	P0767Z131	SPACER
132	P0767Z132	PIVOT SHAFT
133	P0767Z133	DOWEL PIN 6 X 16
134	P0767Z134	FENDER WASHER 12MM
135	P0767Z135	CAP SCREW M12-1.75 X 30
136	P0767Z136	ROLL PIN 6 X 50
137	P0767Z137	RATCHET SLEEVE
138	P0767Z138	BACKING PIN
139	P0767Z139	COMPRESSION SPRING 0.9 X 7 X 15
140	P0767Z140	PAWL
141	P0767Z141	HANDLE
142	P0767Z142	PUSH-ON HANDLE GRIP
143	P0767Z143	DOWEL PIN 5 X 20
144	P0767Z144	RATCHET SHAFT

REF	PART #	DESCRIPTION
145	P0767Z145	HEX NUT M16-2
146	P0767Z146	SPRING RETAINER
147	P0767Z147	COMPRESSION SPRING 1.4 X 20 X 35
148	P0767Z148	SPRING BASE
149	P0767Z149	FLAT WASHER 16MM
150	P0767Z150	HEX NUT M16-2
151	P0767Z151	CAP SCREW M10-1.5 X 20
152	P0767Z152	FENDER WASHER 10MM
153	P0767Z153	FLAT WASHER 10MM
154	P0767Z154	CAP SCREW M10-1.5 X 20
155	P0767Z155	MOTOR MOUNT
156	P0767Z156	BUSHING (COPPER)
158	P0767Z158	HEX NUT M10-1.5
159	P0767Z159	PIVOT SHAFT W/FLANGE
160	P0767Z160	LIFTING BAR RETAINER
161	P0767Z161	LIFTING BAR
162	P0767Z162	SPACER
163	P0767Z163	BELT COVER (TOP)
164	P0767Z164	MOTOR 3HP 220V 3-PH
164-1	P0767Z164-1	MOTOR FAN COVER
164-2	P0767Z164-2	MOTOR FAN
164-3	P0767Z164-3	MOTOR JUNCTION BOX
164-4	P0767Z164-4	BALL BEARING 6205ZZ (FRONT)
164-5	P0767Z164-5	BALL BEARING 6205ZZ (REAR)
165	P0767Z165	FLAT WASHER 10MM
166	P0767Z166	LOCK WASHER 10MM
167	P0767Z167	HEX BOLT M10-1.5 X 40
168	P0767Z168	KEY 8 X 8 X 40
169	P0767Z169	DRIVE PULLEY
170	P0767Z170	SANDING BELT 4" X 79" 80-GRIT
171	P0767Z171	FENDER WASHER 12MM
172	P0767Z172	LOCK WASHER 12MM
173	P0767Z173	CAP SCREW M12-1.75 X 50
174	P0767Z174	CAP SCREW M12-1.75 X 30
175	P0767Z175	CONTACT ROLLER BRACKET
178	P0767Z178	CONTACT ROLLER 1" DIA W/BEARINGS
179	P0767Z179	HEX NUT M8-1.25
180	P0767Z180	FLAT WASHER 8MM
181	P0767Z181	COMPRESSION SPRING 1 X 12 X 19
182	P0767Z182	CAP SCREW M8-1.25 X 100
183	P0767Z183	BALL BEARING 6002-ZZ
184	P0767Z184	E-STOP BUTTON IDEC YW-E01
185	P0767Z185	WOOD SCREW M4 X 3



# Pipe Vise Assembly & Accessories



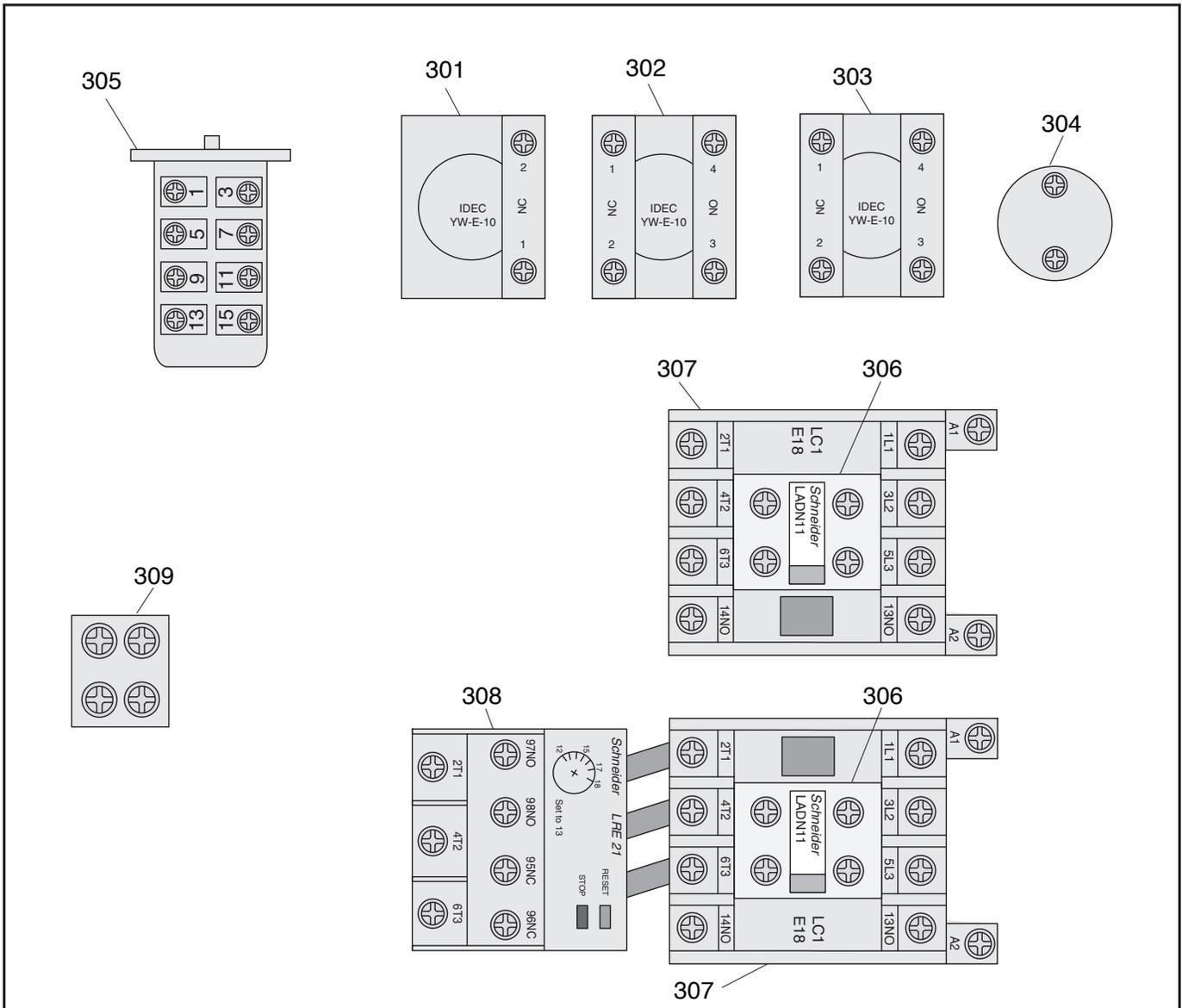
# Pipe Vise Assembly & Accessories Parts List

REF PART #	DESCRIPTION
201	P0767Z201 CAP SCREW M8-1.25 X 20
202	P0767Z202 BUSHING
203	P0767Z203 Y-AXIS SLIDE ROD
204	P0767Z204 BUSHING (COPPER)
205	P0767Z205 SLIDE BAR BRACKET (BOTTOM)
206	P0767Z206 HEX BOLT M8-1.25 X 20
207	P0767Z207 FLAT WASHER 8MM
208	P0767Z208 PIPE CLAMP BASE
209	P0767Z209 PHLP HD SCR M6-1 X 12
210	P0767Z210 FLAT WASHER 14MM
211	P0767Z211 LEADSCREW END CAP
212	P0767Z212 SLIDER SHAFT
213	P0767Z213 LONGITUDINAL LEADSCREW NUT
214	P0767Z214 LONGITUDINAL LEADSCREW
215	P0767Z215 FLAT WASHER 14MM
216	P0767Z216 X-AXIS SLIDE ROD
217	P0767Z217 GUIDE BAR BUSHING (COPPER)
218	P0767Z218 CAP SCREW M8-1.25 X 40
219	P0767Z219 FLAT WASHER 8MM
220	P0767Z220 CAP SCREW M8-1.25 X 20
221	P0767Z221 CAP SCREW M8-1.25 X 30
222	P0767Z222 ROTARY TABLE
223	P0767Z223 PIPE JAW
224	P0767Z224 CAP SCREW M10-1.5 X 30
225	P0767Z225 PIPE CLAMP PLATE
226	P0767Z226 PIPE CLAMP LEADSCREW NUT
227	P0767Z227 INT/EXT THREADED ROD
228	P0767Z228 PIPE CLAMP LEADSCREW
229	P0767Z229 CAP SCREW M6-1 X 16
230	P0767Z230 FLAT WASHER 6MM
231	P0767Z231 BUSHING
232	P0767Z232 CAP SCREW M6-1 X 20
233	P0767Z233 BUSHING
234	P0767Z234 PRESSURE BRACKET (LEFT)

REF PART #	DESCRIPTION
235	P0767Z235 MOVABLE BLOCK
236	P0767Z236 LEVER M8-1.25 X 20 W/KNOB
237	P0767Z237 SET SCREW M3-.5 X 10 CONE-PT
238	P0767Z238 CAP SCREW M6-1 X 16
239	P0767Z239 FLAT WASHER 6MM
240	P0767Z240 BUSHING
241	P0767Z241 PRESSURE BRACKET (RIGHT)
242	P0767Z242 FLAT WASHER 6MM
243	P0767Z243 HEX NUT M8-1.25
244	P0767Z244 THRUST BEARING 51101
245	P0767Z245 STATIONARY BLOCK
246	P0767Z246 SPANNER NUT M12-1.25
247	P0767Z247 CRANK 4"L W/HANDLE
248	P0767Z248 ROLL PIN 3 X 22
249	P0767Z249 HEX WRENCH 8MM
250	P0767Z250 PROFILE ROLLER 3/4" DIA W/BEARINGS
251	P0767Z251 PROFILE ROLLER 1-1/4" DIA W/BEARINGS
252	P0767Z252 PROFILE ROLLER 1-1/2" DIA W/BEARINGS
253	P0767Z253 PROFILE ROLLER 2" DIA W/BEARINGS
254	P0767Z254 PROFILE ROLLER 2-1/2" DIA W/BEARINGS
255	P0767Z255 PROFILE ROLLER 3" DIA W/BEARINGS
256	P0767Z256 SCREWDRIVER PHILLIPS #2
257	P0767Z257 SPANNER WRENCH 22-26MM
258	P0767Z258 TOOLBOX
259	P0767Z259 HEX WRENCH 6MM
260	P0767Z260 HEX WRENCH 5MM
261	P0767Z261 HEX WRENCH 4MM
262	P0767Z262 HEX WRENCH 3MM
263	P0767Z263 WRENCH 13 X 16MM OPEN-ENDS
264	P0767Z264 FLAT WASHER 8MM
265	P0767Z265 HEX WRENCH 2.5MM
266	P0767Z266 SLIDE BAR BRACKET (TOP)
267	P0767Z267 HEX NUT M12-1.75



# Electrical Box

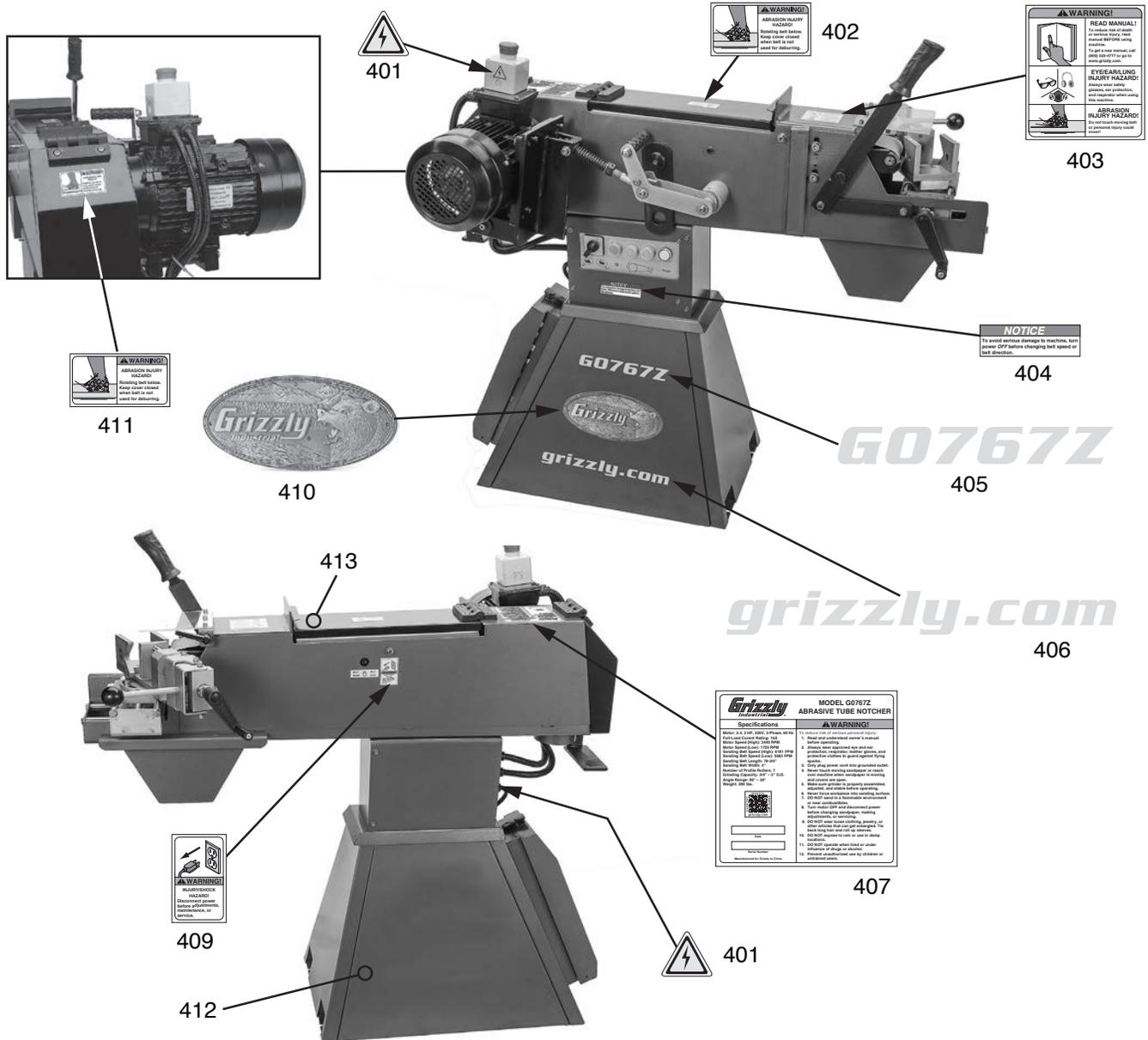


REF	PART #	DESCRIPTION
301	P0767Z301	OFF BUTTON IDEC YW-E-10 22MM RED
302	P0767Z302	ON BUTTON IDEC YW-E-10 22MM GRN
303	P0767Z303	ON BUTTON IDEC YW-E-10 22MM GRN
304	P0767Z304	POWER LAMP ONPOW AD16-22DS AC220V
305	P0767Z305	ROTARY SWITCH GLELE LW28-20A 1/2 22MM

REF	PART #	DESCRIPTION
306	P0767Z306	CONTACTOR SCHNEIDER LADN11 220V
307	P0767Z307	CONTACTOR SCHN LC1E1810
308	P0767Z308	OL RELAY SCHNEIDER LRE21N 12-18A
309	P0767Z309	TERMINAL BAR 2P



# Labels & Cosmetics



REF	PART #	DESCRIPTION
401	P0767Z401	ELECTRICITY LABEL
402	P0767Z402	ABRASION INJURY HAZARD LABEL
403	P0767Z403	WARNING LABEL
404	P0767Z404	BELT SPEED NOTICE LABEL
405	P0767Z405	MODEL NUMBER LABEL
406	P0767Z406	GRIZZLY.COM LABEL

REF	PART #	DESCRIPTION
407	P0767Z407	MACHINE ID LABEL
409	P0767Z409	DISCONNECT POWER LABEL
410	P0767Z410	GRIZZLY NAMEPLATE
411	P0767Z411	ABRASION INJURY HAZARD LABEL
412	P0767Z412	TOUCH-UP PAINT, GRIZZLY GREEN
413	P0767Z413	TOUCH-UP PAINT, GLOSSY BLACK

## WARNING

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





# WARRANTY CARD

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Phone # \_\_\_\_\_ Email \_\_\_\_\_  
 Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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

1. How did you learn about us?
 

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
  
2. Which of the following magazines do you subscribe to?
 

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	
  
3. What is your annual household income?
 

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
  
4. What is your age group?
 

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
  
5. How long have you been a woodworker/metalworker?
 

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
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6. How many of your machines or tools are Grizzly?
 

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
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7. Do you think your machine represents a good value?  Yes  No
  
8. Would you recommend Grizzly Industrial to a friend?  Yes  No
  
9. Would you allow us to use your name as a reference for Grizzly customers in your area?  
**Note:** We never use names more than 3 times.  Yes  No

10. Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_



Place  
Stamp  
Here



**GRIZZLY INDUSTRIAL, INC.**  
P.O. BOX 2069  
BELLINGHAM, WA 98227-2069



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Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

# WARRANTY & RETURNS

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

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

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

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

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

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

# *grizzly.com*<sup>®</sup>

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