



# MODEL G0818

## METAL DUST COLLECTOR

### OWNER'S MANUAL

*(For models manufactured since 10/16)*



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OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**  
#KB18550 PRINTED IN CHINA

V1.03.17



## **WARNING!**

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

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

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

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



## **WARNING!**

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

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

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

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# INTRODUCTION

## Contact Info

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

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

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

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


## Manual Accuracy

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

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

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

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

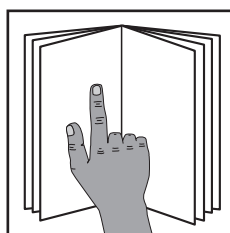
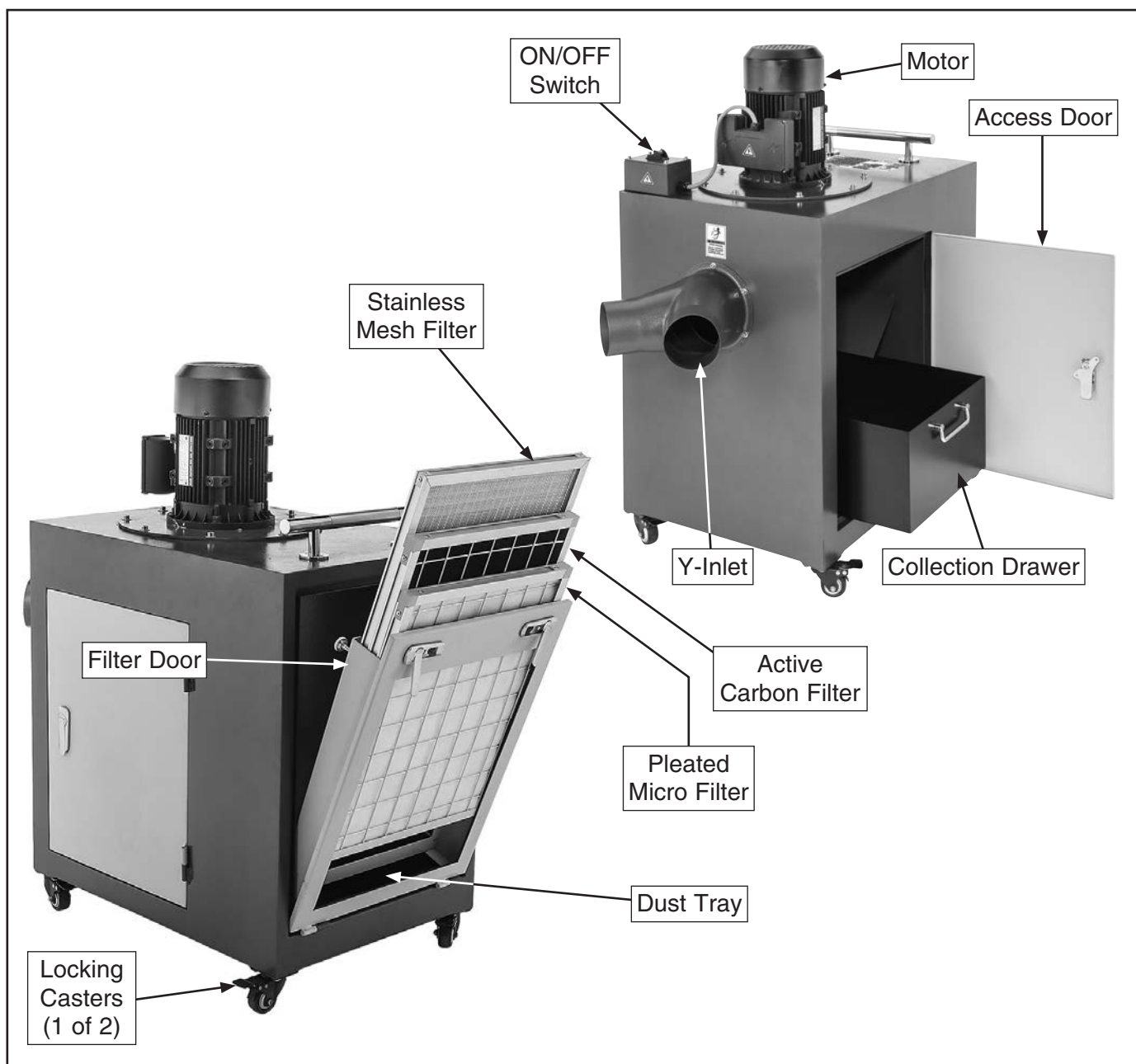
		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Adjust safety devices correctly adjusted/setup and		
Specification:	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 operate if impaired by fatigue, drowsiness, or use of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		

Manufactured for Grizzly in Taiwan



# Identification

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



## **! WARNING**

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





# MACHINE DATA SHEET

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

## MODEL G0818 METAL DUST COLLECTOR

### Product Dimensions:

Weight ..... 256 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height ..... 39 x 20 x 41-1/2 in.  
Footprint (Width x Depth)..... 27-1/2 x 20 in.

### Shipping Dimensions:

Type ..... Wooden Crate  
Content..... Machine  
Weight ..... 309 lbs.  
Length x Width x Height..... 30 x 22 x 46 in.  
Must Ship Upright ..... Yes

### Electrical:

Power Requirement ..... 220V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 8.2A  
Minimum Circuit Size ..... 15A  
Connection Type ..... Cord & Plug  
Power Cord Included ..... Yes  
Power Cord Length ..... 6 ft.  
Power Cord Gauge ..... 16 AWG  
Plug Included ..... 6-15  
Switch Type ..... Toggle Switch w/Removable Locking Key

### Motor:

#### Main

Type..... TEFC Capacitor-Start Induction  
Horsepower ..... 1.5 HP  
Voltage ..... 220V  
Phase ..... 1-Phase  
Amps ..... 8.2A  
Speed ..... 3450 RPM  
Cycle..... 60 Hz  
Power Transfer..... Direct Drive  
Bearings ..... Shielded and Permanently Lubricated



## Main Specifications:

### Operation Information

Dust Collector Type .....	Metal
Airflow Performance .....	755 CFM
Max. Static Pressure (at 0 CFM) .....	8-5/8 in.
Main Inlet Size .....	6 in.
Inlet Adapter Included .....	Yes
Inlet Adapter Type .....	Y-Inlet
Number of Adapter Inlets .....	2
Adapter Inlet Size .....	4 in.
Max. Material Collection Capacity .....	1 cu. ft. (Main Compartment), 0.23 cu. ft. (Filter Compartment)

### Filter Information

Number of Filters .....	3, Aluminum-Framed
Total Filter Surface Area .....	6.48 sq. ft.
First-Stage Filter Type .....	Stainless Filter
First-Stage Filter Rating .....	30 Microns
First-Stage Filter Size (Length x Width x Thickness) .....	15-3/4 x 19-3/4 x 13/16 in.
Second-Stage Filter Type .....	Active Carbon Filter
Second-Stage Filter Rating .....	5 Microns
Second-Stage Filter Size (Length x Width x Thickness) .....	15-3/4 x 19-3/4 x 13/16 in.
Third-Stage Filter Type .....	Pleated Outer Micro-Filter
Third-Stage Filter Rating .....	1 Micron
Third-Stage Filter Size (Length x Width x Thickness) .....	15-3/4 x 19-3/4 x 13/16 in.

### Impeller Information

Impeller Type .....	Precision, Spin-Balanced Aluminum
Impeller Size .....	12-3/4 in.
Impeller Blade Thickness .....	5/16 in.

### Construction

Base .....	Steel
Frame .....	Steel
Side Walls .....	Steel
Collection Drawers .....	Steel
Caster .....	Rubber
Impeller .....	Aluminum Alloy
Blower Housing .....	Cast Aluminum

## Other Specifications:

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	30 Minutes
Sound Rating .....	85 dB
Serial Number Location .....	Machine ID Label
ISO 9001 Factory .....	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) .....	No



# SECTION 1: SAFETY

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

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



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



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



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

### **NOTICE**

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

## Safety Instructions for Machinery

### **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 Metal Dust Collectors

## WARNING

Long-term respiratory damage, metal toxicity, cancer, or birth defects can occur from improperly using, setting up, or servicing machine, and using this machine without wearing a respirator. Explosions or fire can result if machine is used to capture incorrect materials or if dust/waste material is exposed to an ignition source. To reduce these risks, operator and bystanders **MUST** completely heed the warnings below.

**USE FOR INTENDED PURPOSE.** This metal dust collector is only designed to capture non-combustible or non-explosible metal particles. Collect only one type of metal/material at one time. **DO NOT** use to capture materials made from wood or wood products. **DO NOT** use it to collect lead, magnesium, niobium, tantalum, titanium, zirconium, hafnium, asbestos, crystalline silica, gypsum, or any other non-metal products. **DO NOT** use to capture welding fumes, gasses, vapors, liquids, smoke, or ordinary combustible materials. **DO NOT** connect this dust collector to any machine using a coolant system.

**WEAR PROPER PPE.** Dust created from cutting, grinding, sanding, etc. may cause cancer, birth defects, or long-term respiratory damage. Be aware of the dust hazards, exposure limits, and toxicity associated with each type of workpiece material being collected. Very fine dust/particles may not be captured by filters and may become airborne in the work area. Anyone working in this same work area **MUST** wear a NIOSH-approved respirator and eye protection rated for the workpiece material.

**RISK OF FIRE/EXPLOSIONS.** To minimize static electrical charge, only connect with smooth-walled, sheet-metal ducting—do not use PVC. Entire collection system (collector + ductwork) must be bonded and grounded. 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 near chemical fumes or within an enclosed spray booth.

**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 toxicity of metal types you work with and always seek to minimize/eliminate exposure to yourself and others.

**CLEANING DRAWERS.** Wear safety goggles and a NIOSH-approved respirator (rated for the metal type) when emptying and cleaning collection drawer and dust tray. Empty only into an approved, closed-top metal container, taking care to minimize amount of dust allowed to become airborne. Prevent spread of dust onto hands or clothing. Dispose of waste properly and according to local regulations for material type.

**HIGH-HAZARD MATERIAL.** This machine does **NOT** protect against highly hazardous materials, such as lead dust, asbestos fibers, or radioactive particles. These materials **MUST** be collected with special filtration equipment because of their high health/contamination hazard and difficulty of filtration. **DO NOT** attempt to collect such materials with this machine.

**SAFE OPERATING LOCATION.** **DO NOT** place metal dust collector where it can be exposed to rain or moisture. Exposure to water creates a shock hazard and will reduce life of machine.

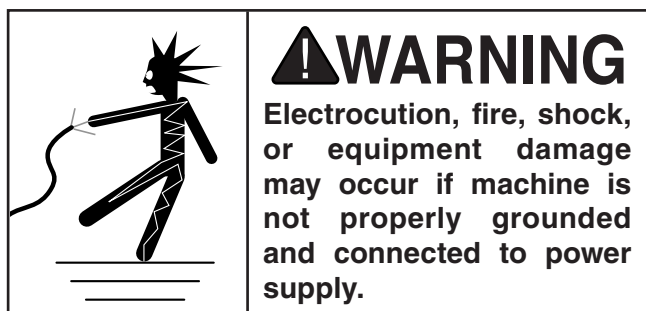
**PROPERLY MAINTAIN MACHINE.** Keep machine in proper working condition to help ensure all guards and components function as intended. Perform routine inspections and all necessary maintenance indicated in owner's manual. Never operate machine with damaged or worn parts. Duct must be disconnected before service. Never operate machine with filters or covers removed.



# 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 .... 8.2 Amps

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

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

## ! WARNING

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

## Circuit Information

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

## ! CAUTION

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

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

## Circuit Requirements for 220V

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

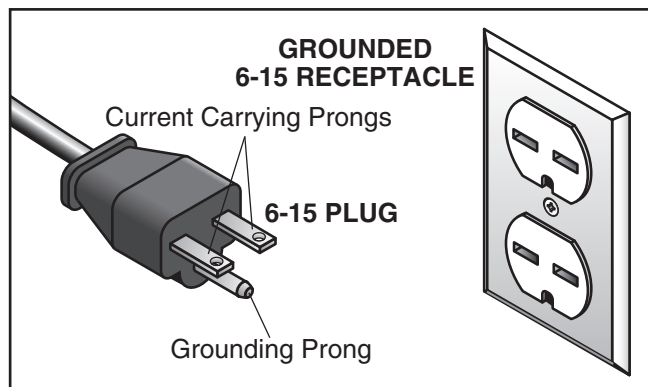
**Nominal Voltage ..... 208V, 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 15 Amps**  
**Plug/Receptacle ..... NEMA 6-15**



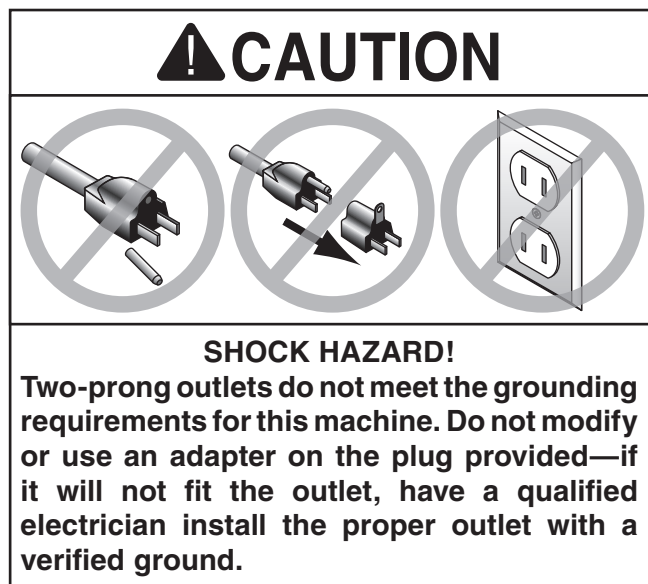
## Grounding Requirements

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

**For 220V operation:** This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). 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.



**Figure 1.** Typical 6-15 plug and receptacle.



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.

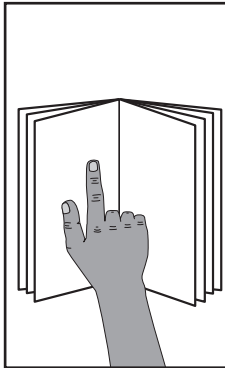
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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.**

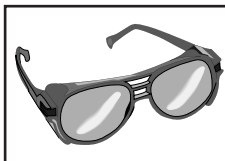


# SECTION 3: SETUP



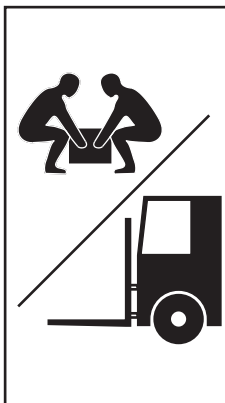
## **!WARNING**

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

### Description

### Qty

- Assistant..... 1
- Safety Glasses (for each person)..... 1 Pair
- Hex Wrench 6mm..... 1
- Metal Ducting ..... As Needed

## Unpacking

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

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



## **!WARNING**

### **SUFFOCATION HAZARD!**

Keep children and pets away from plastic bags or packing materials shipped with this machine.

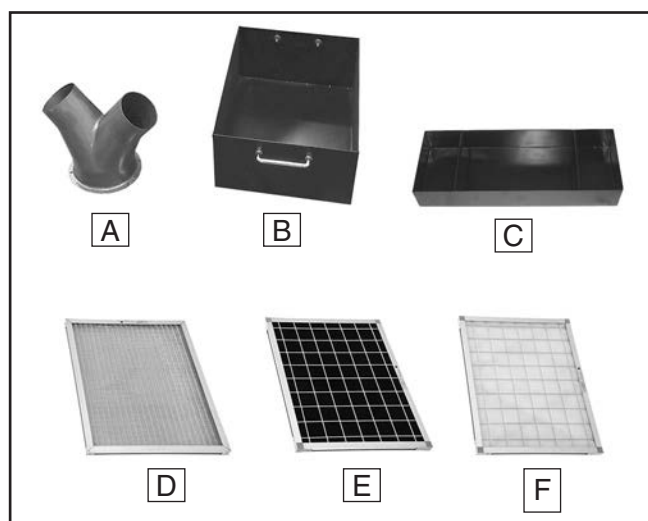


# Inventory

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

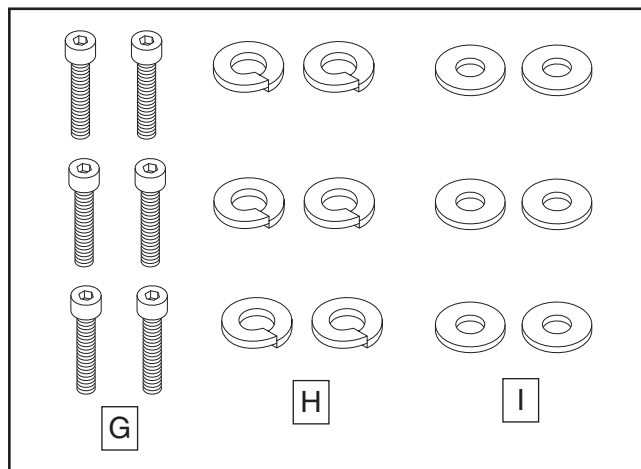
If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Loose Components (Figure 2)		Qty
A.	Y-Inlet 4 X 4 X 6".....	1
B.	Collection Drawer.....	1
C.	Air Filter Dust Tray.....	1
D.	Stainless-Steel Mesh Filter.....	1
E.	Active Carbon Filter.....	1
F.	Pleated Micro Filter .....	1



**Figure 2.** Loose components inventory.

Hardware (Figure 3)		Qty
G.	Cap Screws M8-1.25 x 16 .....	6
H.	Lock Washers 8mm.....	6
I.	Flat Washers 8mm .....	6



**Figure 3.** Hardware inventory.

## NOTICE

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





# Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

○ #10

○ 1/4"

○ 5/16"

○ 3/8"

○ 7/16"

○ 1/2"



Key

4mm ○

5mm ○

6mm ○

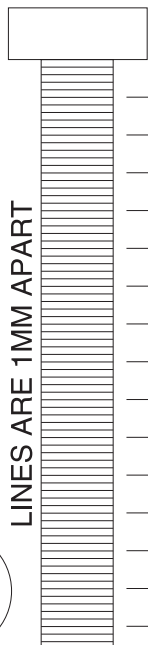
8mm ○

10mm ○

12mm ○

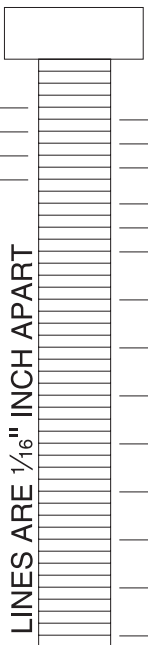
16mm ○

LINES ARE 1MM APART

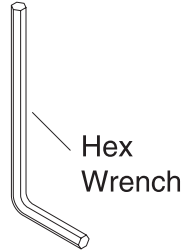


5mm  
10mm  
15mm  
20mm  
25mm  
30mm  
35mm  
40mm  
45mm  
50mm  
55mm  
60mm  
65mm  
70mm  
75mm

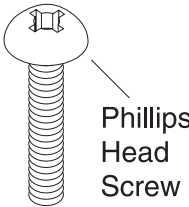
LINES ARE 1/16" INCH APART



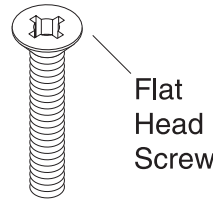
1/4"  
3/8"  
1/2"  
5/8"  
5/16"  
7/16"  
9/16"  
3/4"  
7/8"  
1"  
1 1/4"  
1 1/2"  
1 3/4"  
2  
2 1/4"  
2 1/2"  
2 3/4"  
3



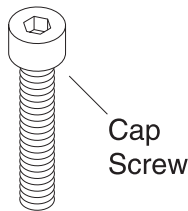
Hex Wrench



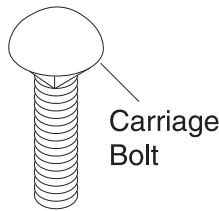
Phillips Head Screw



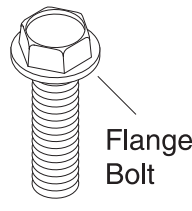
Flat Head Screw



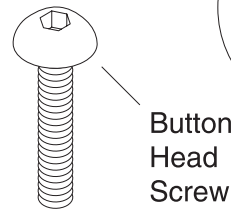
Cap Screw



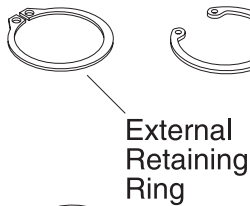
Carriage Bolt



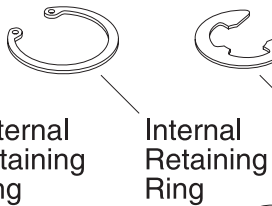
Flange Bolt



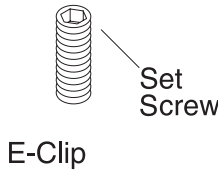
Button Head Screw



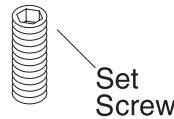
External Retaining Ring



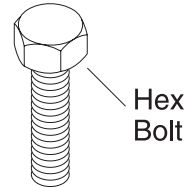
Internal Retaining Ring



E-Clip



Set Screw



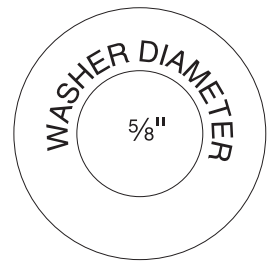
Hex Bolt



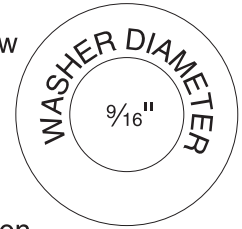
Lock Nut



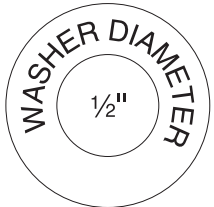
Wing Nut



WASHER DIAMETER  
5/8"



WASHER DIAMETER  
9/16"



WASHER DIAMETER  
1/2"



WASHER DIAMETER  
7/16"



WASHER DIAMETER  
3/8"



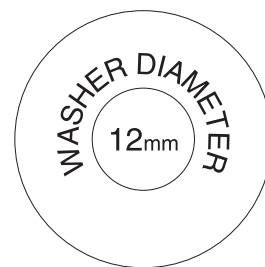
WASHER DIAMETER  
5/16"



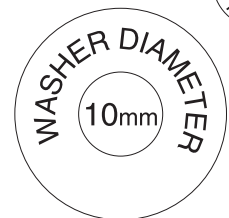
WASHER DIAMETER  
1/4"



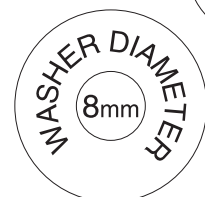
#10



WASHER DIAMETER  
12mm



WASHER DIAMETER  
10mm



WASHER DIAMETER  
8mm



WASHER DIAMETER  
4mm



WASHER DIAMETER  
6mm

WASHERS ARE MEASURED BY THE INSIDE DIAMETER



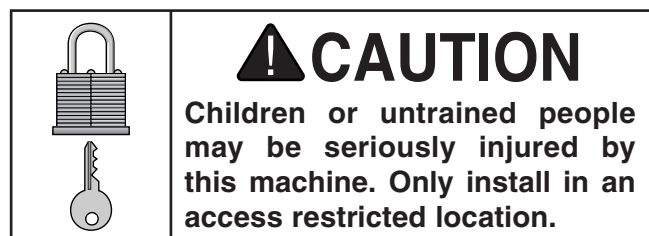
# Site Considerations

## 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

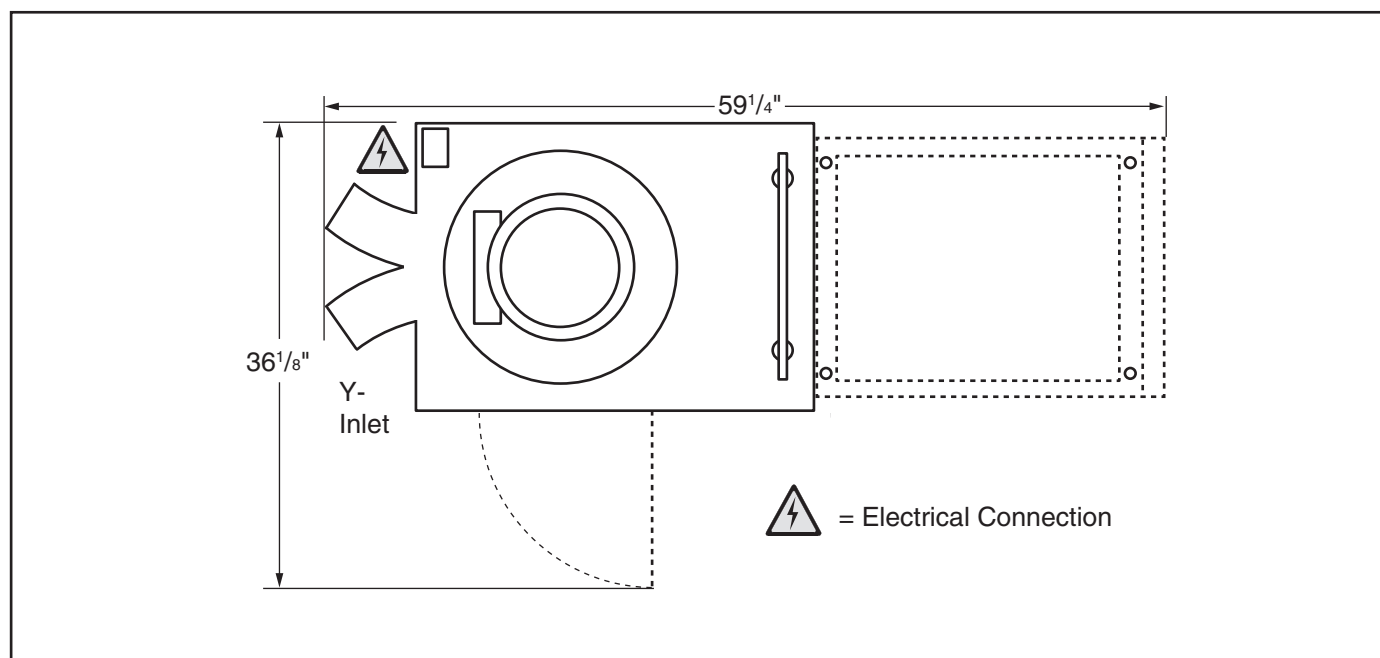
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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

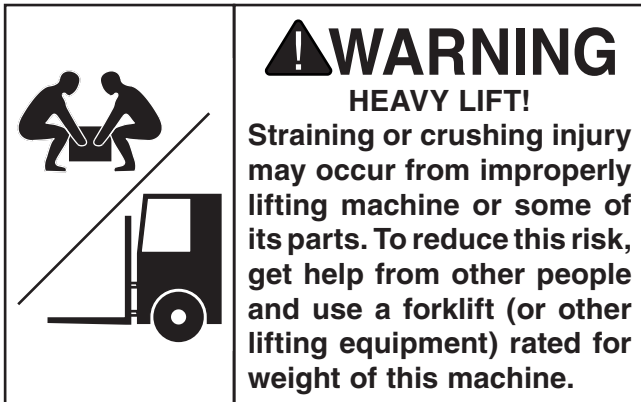


**Figure 4.** Minimum working clearances.

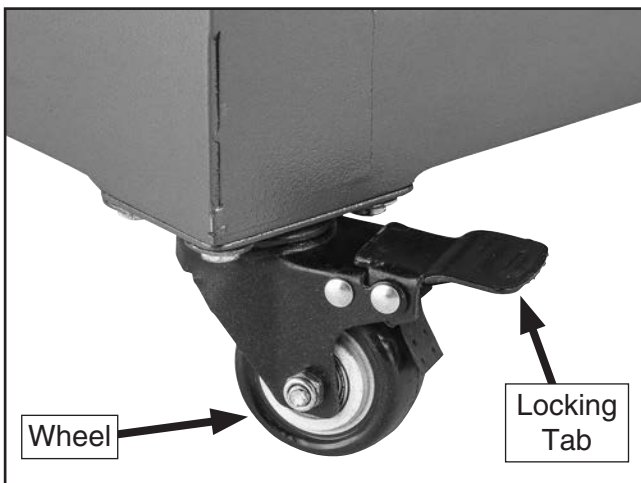




# Lifting & Placing



Have an assistant help you remove the machine from the crate, then roll it into position and press down on the wheel locking tab (see **Figure 5**) to lock it in place.



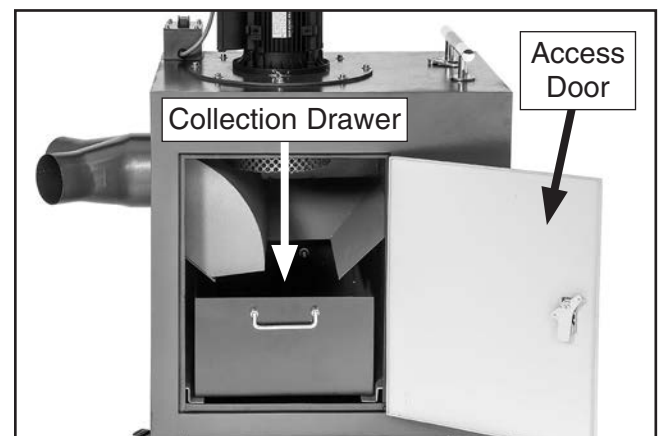
**Figure 5.** Locking caster assembly (one of four).

# 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 dust collector:

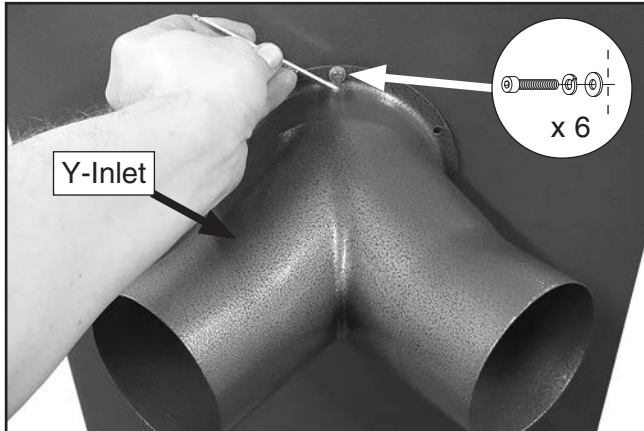
1. Open access door. Remove protective wrap from collection drawer, and insert collection drawer as shown in **Figure 6**. Close and latch access door.



**Figure 6.** Installing collection drawer.

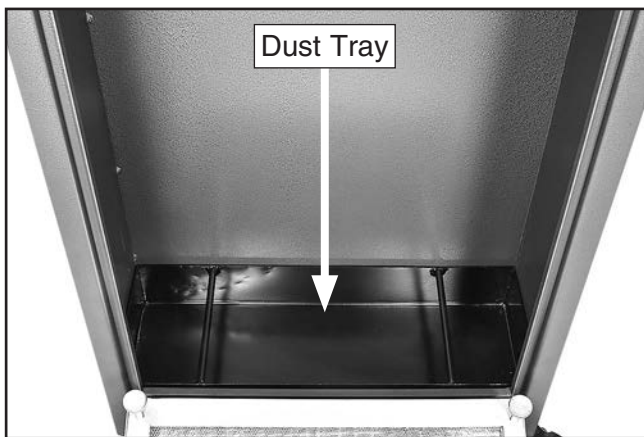


2. Attach Y-inlet with (6) M8-1.25 x 16 cap screws, (6) 8mm lock washers, and (6) 8mm flat washers (see **Figure 7**).



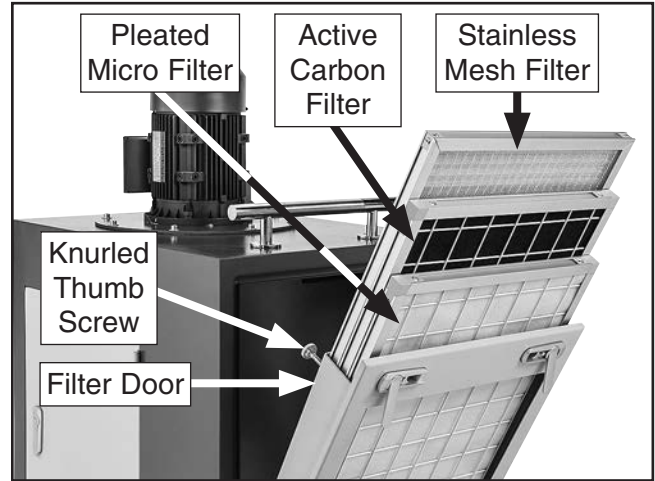
**Figure 7.** Attaching the Y-inlet.

3. Open filter door and verify dust tray is installed, as shown in **Figure 8**.



**Figure 8.** Dust tray installed below air filter door.

4. Install air filters in same sequence shown in **Figure 9**, then tighten all four knurled thumb screws to secure filters together.



**Figure 9.** Install air filters in this sequence.

5. Close and latch filter door.
6. Attach ducting to Y-inlet dust ports. Refer to **Page 17** for suggestions about collection ducting and metal dust collection components .



# Collection Ducting

## General

The Model G0818 is designed *exclusively* as a dry metal dust collector. **DO NOT** use the G0818 to collect sawdust. **DO NOT** connect the G0818 to a machine that uses cutting fluid or coolant. Due to fire or explosion risk, **DO NOT** use the G0818 to collect combustible or explosive metals, magnesium, niobium, tantalum, titanium, zirconium, hafnium, combustible liquids or fuels, gasoline, or oil- or solvent-based paints.

For best filtration performance, place the G0818 as close to dust-generating machines as possible and install blast gates at the beginning of ducting lines. Only open one line at a time to focus maximum suction at the machine where dust is being collected. Grizzly offers a complete line of dust collection accessories for setting up the G0818 (see **Page 21**) and a complete guide book titled *Dust Collection Basics*.

Whatever system design you choose, always make sure to position ducting and collector away from any open flames (including pilot lights); otherwise you risk an explosion if material is dispersed into the air.

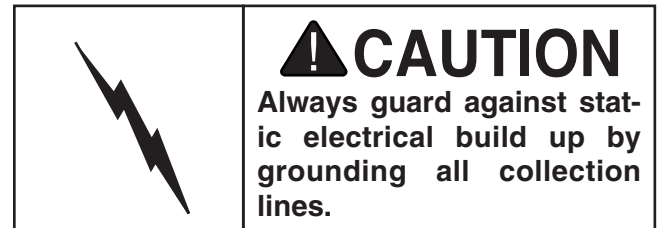
## Duct Material

For best results, use only smooth-wall, sheet-metal ducting or flexible metal ducting to connect each machine.

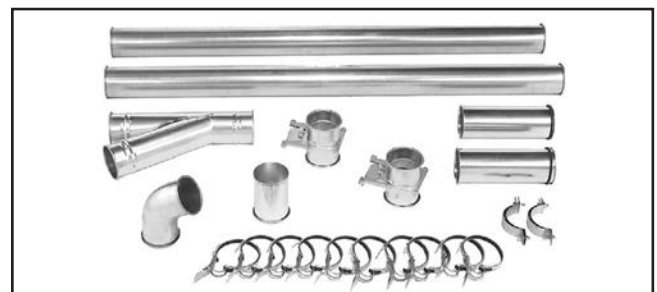
The National Fire Protection Agency (NFPA) warns of explosion or fire hazard because of static electrical buildup if plastic or non-conductive duct material is used for metal dust collection and is not completely grounded and bonded. We **DO NOT** recommend using any plastic duct material with the Model G0818.

## Metal Ducting

Advantages of metal ducting is its conductivity and that it does not contribute to static electrical charge build-up. However, static charges are still produced when particles strike other dust particles as they move through the duct. Since metal duct is a conductor, it can be grounded quite easily to dissipate any static electrical charges. Replace any plastic dust ports with sheet-metal equivalents, or bond sheet metal ducting to metal frame of machine with grounding wire.



There are a number of options when it comes to metal duct, but duct that is specially manufactured for metal dust collection is the best choice. When selecting your metal duct, choose high-quality metal duct with smooth-welded internal seams that will minimize airflow resistance. This type of duct usually connects to other ducts or elbows with a simple, self-sealing clamp, is very quick and easy to assemble, and can be readily dismantled and re-installed. This is especially important if you ever need to change things around in your shop or add more tools.



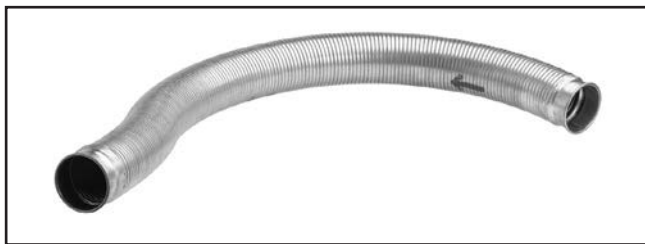
**Figure 10.** Examples of metal duct and components.

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



## Flexible Duct

Flexible hose is generally used for short runs and at rigid duct-to-machine connections. The superior choice here is metal flex hose that is designed to be flexible, yet be as smooth as possible inside to reduce static pressure loss. DO NOT use dryer vent hose because it tends to collapse.



**Figure 11.** Example of flexible metal duct.

## Ensure Required CFM at Machine

Since each machine produces a different amount of dust, the requirements for the minimum amount of CFM to move that dust is unique to the machine. Knowing this required CFM is important to gauging what size duct to use.

For best results, we recommend installing blast gates to control airflow and resistance for each line near the Y-inlet, or connect one machine by capping one 4" inlet, or use 6" duct with reducers and adapters.

Refer to **Figure 12** for a close estimation of the airflow each dust-producing machine requires. Machines that generate the most dust should be placed as close as possible to the dust collector.

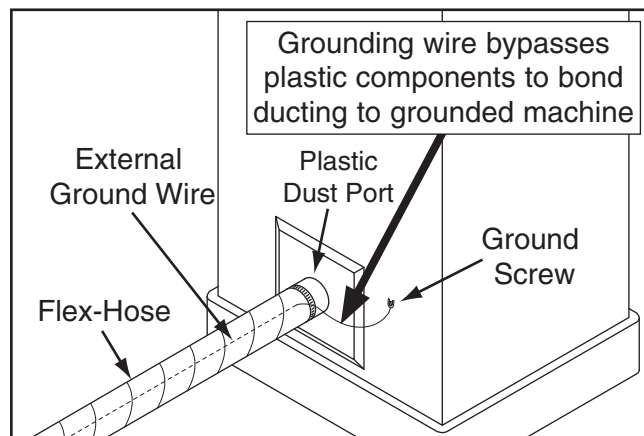
Machine Dust Port Size	Approximate Required CFM
2"	100
2.5"	150
3"	250
4"	400
5"	600
6"	850

**Figure 12.** Approximate required airflow for machines based on dust port size.

# System Grounding

To guard against static electrical buildup, we strongly recommend replacing any plastic dust ports on dust-producing machines with metal equivalents.

If you absolutely must use any plastic duct or components, they must be completely grounded and bonded to the metal frame of a grounded machine by wrapping the flex hose with an external ground wire connected to both machines as shown in **Figure 13**. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.



**Figure 13.** Example showing how to ground and bond ducting with a grounding wire.

**⚠ CAUTION**

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



# 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.

## WARNING

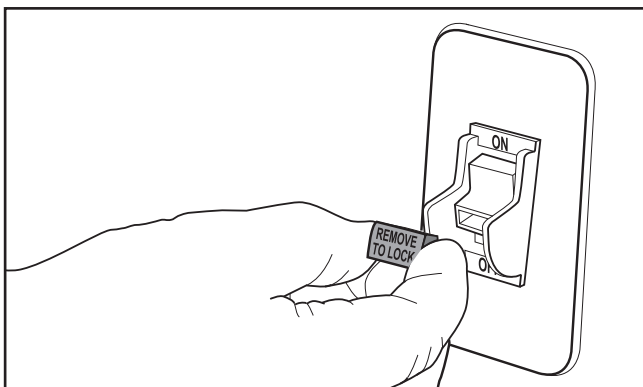
**DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.**

### To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine **ON**, verify motor operation, and then turn machine **OFF**.

Machine should run smoothly and without unusual problems or noises.

4. Remove switch-disabling key, as shown in **Figure 14**.



**Figure 14.** Removing switch key from toggle switch.

## WARNING

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

5. Try to start machine with toggle switch. The machine should not start.
  - If the machine *does not* start, the switch disabling feature is working as designed.
  - If the machine *does start*, immediately stop the machine. The switch-disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.



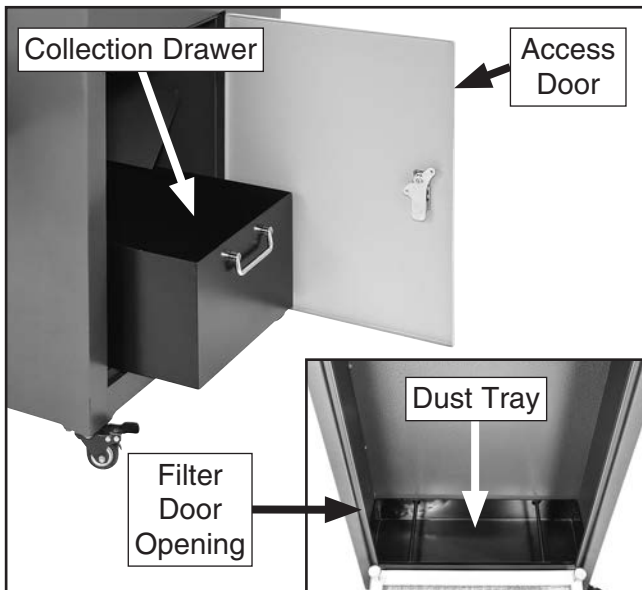


# SECTION 4: OPERATIONS

## Operation

This metal dust collector draws metal dust into a collection drawer and discharges air through a 3-stage air-filter system.

Metal dust is collected in a primary 1.0-cubic-foot drawer that slides into the main compartment behind an access door, as shown in **Figure 15**. A secondary dust tray in the air filter compartment holds 0.23 cubic feet of material (see **Figure 15, inset**).

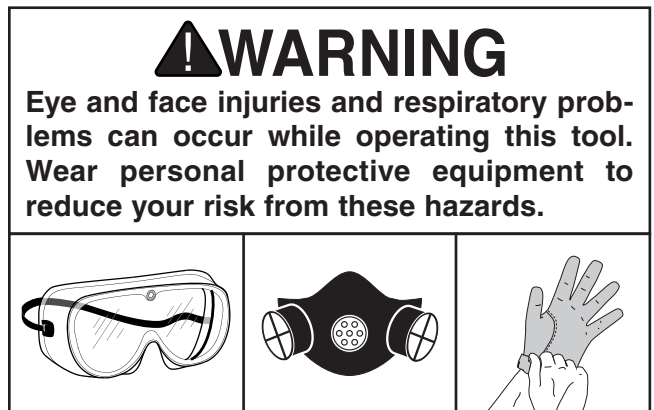


**Figure 15.** Collection drawer and dust tray locations.

When machine is not in use, remove safety key from **ON/OFF** switch to avoid accidental startup.

## 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.



**To use metal dust collector:**

1. Turn metal dust collector **ON**.
2. Turn dust-producing machine **ON** and perform operation.
3. Turn dust-producing machine **OFF** when operation is complete.
4. Turn metal dust collector **OFF** when finished with operation or to check/clean collection drawer. Empty drawer and tray when approximately  $\frac{1}{3}$ – $\frac{1}{2}$  full.

**IMPORTANT:** Wear NIOSH-approved respirator, ANSI-approved safety goggles and leather gloves whenever checking or emptying collection drawer and air filter dust tray. Keep metal dust off clothing and skin.



# 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.

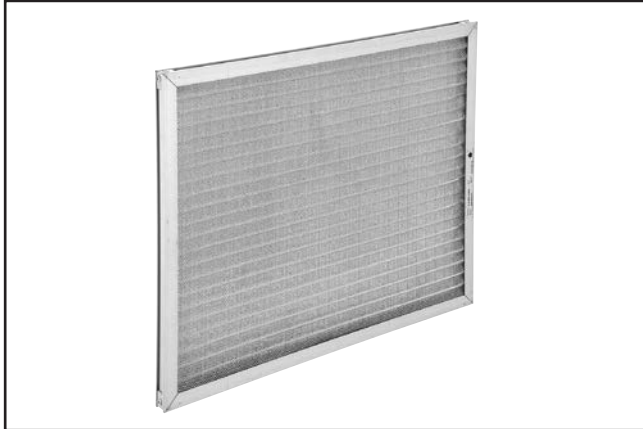
## **NOTICE**

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

### **Air Filters**

#### **T27909—Stainless-Steel Mesh Filter**

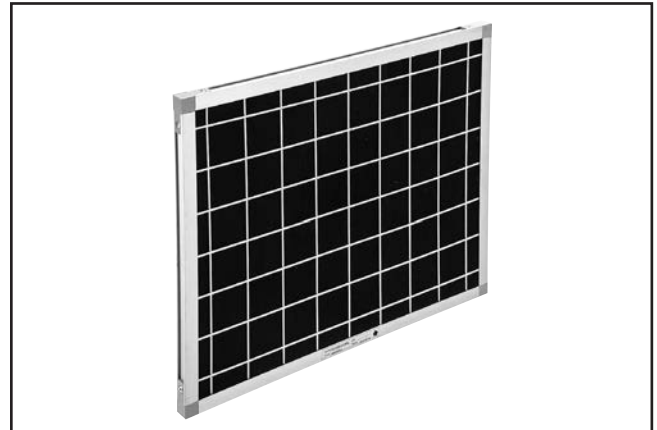
The first-stage replacement stainless steel mesh filter for the G0818 Metal Dust Collector traps particles as small as 30 microns. The filter can be cleaned and reused as long as it is not damaged. It measures 15<sup>3</sup>/<sub>4</sub>" x 19<sup>3</sup>/<sub>4</sub>" x 1<sup>13</sup>/<sub>16</sub>".



**Figure 16.** Model T27909 Mesh Filter.

#### **T27910—Active Carbon Filter**

The second-stage replacement active carbon filter for the G0818 Metal Dust Collector traps particles as small as 5 microns. The filter measures 15<sup>3</sup>/<sub>4</sub>" x 19<sup>3</sup>/<sub>4</sub>" x 1<sup>13</sup>/<sub>16</sub>". It is cleanable and reusable for up to 300 hours of use.



**Figure 17.** Model T27910 Active Carbon Filter.

#### **T27911—Pleated Micro Filter**

The third-stage replacement pleated micro filter for the G0818 Metal Dust Collector traps particles as small as 1 micron. The filter measures 15<sup>3</sup>/<sub>4</sub>" x 19<sup>3</sup>/<sub>4</sub>" x 1<sup>13</sup>/<sub>16</sub>". It is cleanable and reusable for up to 300 hours of use.



**Figure 18.** Model T27911 Pleated Micro Filter.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



## Metal Ducting

**G6162—4" x 5' Straight Metal Pipe**

**G7346—5" x 5' Straight Metal Pipe**

**G7364—6" x 5' Straight Metal Pipe**

These laser welded straight pipes ensure a super smooth internal seam. Ends easily clamp together for a sealed fit without screws or silicone.



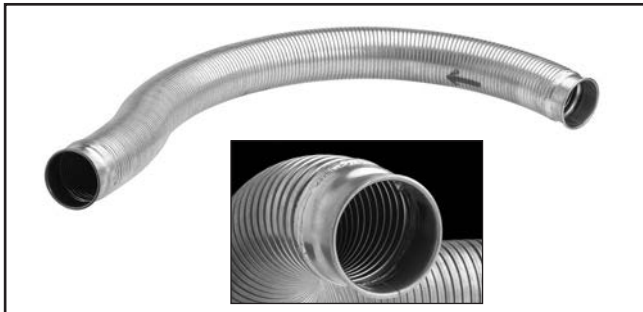
**Figure 19.** Straight metal pipe.

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

**H7216—5" x 5' Rigid Metal Flex Hose**

**H7217—6" 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 20.** Rigid metal flex hose.

## Reducers & Adapters

We carry a multitude of smooth-wall metal reducers, adapters, and fittings.



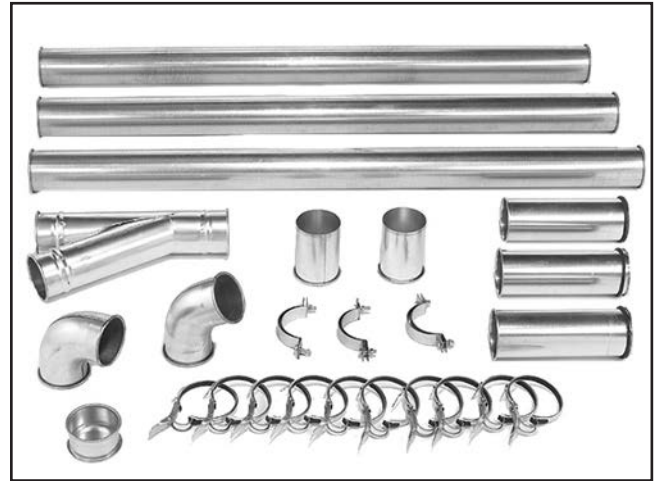
**Figure 21.** Metal reducers & adapters.

**H5293—4" Metal Duct Starter Kit**

**H5295—5" Metal Duct Starter Kit**

**H5297—6" Metal Duct Starter Kit**

Save over 20% with this great starter kit. Includes: (2) machine adapters, (10) pipe clamps, (3) 5' straight pipes, (1) branch, (3) pipe hangers, (1) end cap, (3) adjustable nipples, (1) 90° elbow, and (1) 60° elbow.



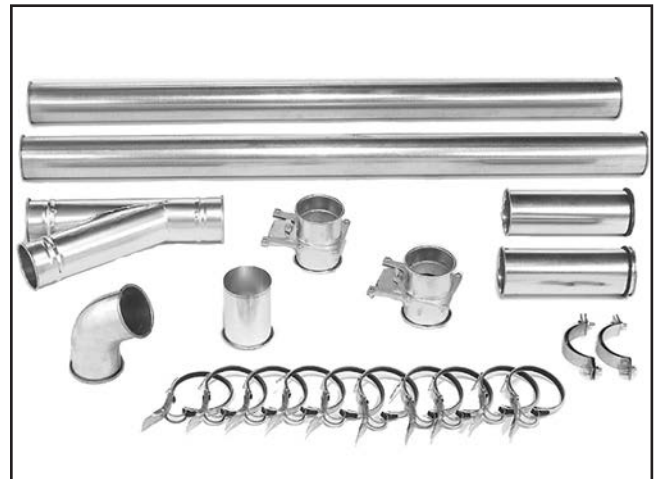
**Figure 22.** 4" Metal duct starter kit.

**H5294—4" Metal Duct Machine Addition Kit**

**H5296—5" Metal Duct Machine Addition Kit**

**H5298—6" Metal Duct Machine Addition Kit**

Save over 20% with this great machine addition kit. Includes: (2) blast gates, (1) machine adapter, (10) pipe clamps, (2) pipe hangers, (2) 5' straight pipes, (2) adjustable nipples, (1) branch, and (1) 60° elbow.



**Figure 23.** Metal duct machine addition kits.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**





### Metal Elbows

These industrial metal elbows are available from 4"–6" with 90°, 60°, 45°, or 30° curves. Also, available with a 90° long radius curve.

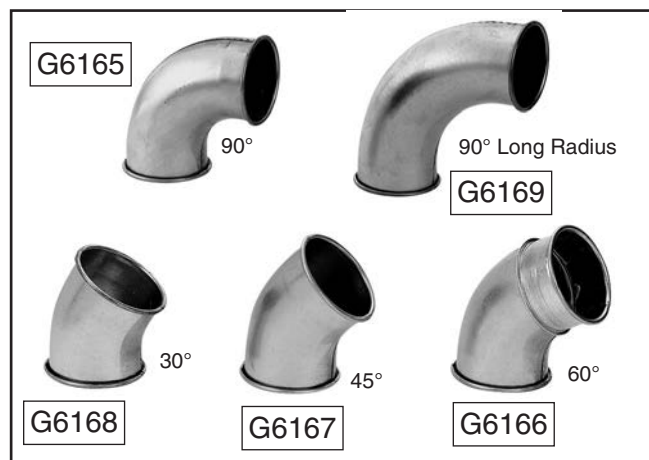


Figure 24. 4" Metal elbows.

### G6177—4" Metal Blast Gate

### G7340—5" Metal Blast Gate

### G7358—6" Metal Blast Gate

Control airflow and resistance between machines.



Figure 25. Metal blast gates.

### T27418—Viewing Spool 4"

### T27419—Viewing Spool 5"

### T27420—Viewing Spool 6"

This viewing spool is a section of acrylic glass with QF ends so you can inspect material flow. Ends are 22-gauge. Total length 12½".

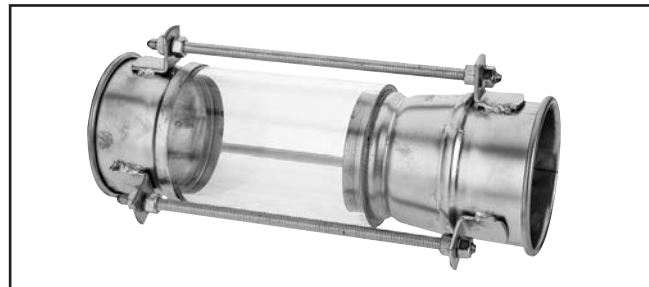


Figure 26. Viewing spools.

### G6163—4" Dust Collection Pipe Clamp

### G7343—5" Dust Collection Pipe Clamp

### G7361—6" Dust Collection Pipe Clamp

These clamps feature lever latches and foam seals that secure around the rolled ends of fittings and pipe.



Figure 27. Dust collection pipe clamps.

### G6252—4" Floor Sweep

### G7341—5" Floor Sweep

### G7359—6" Floor Sweep

Great for cleaning up around the shop, these metal floor sweeps close tight when not in use.



Figure 28. Industrial floor sweeps.

### T26512—4" Dust Collection Ball Joint

### T26513—6" Dust Collection Ball Joint

This ball joint for your dust collection system allows for 22° of movement off center. In 4" and 6" diameter sizes, both are 8" long and 20-gauge.

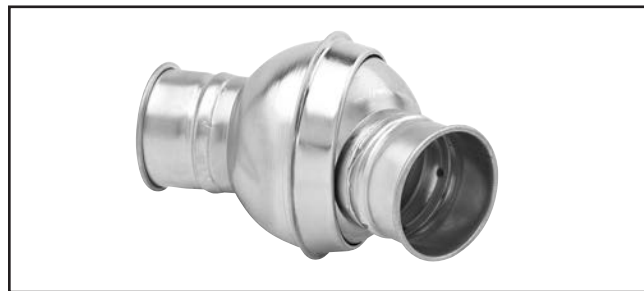


Figure 29. Dust collection ball joints.

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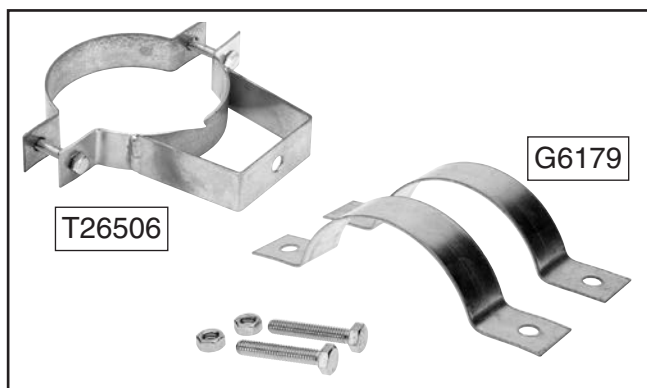
**G6164—4" Dust Collection Adjustable Nipple**  
Use this slip fitting to make up any length less than 5'. Also available in 5" and 6" sizes.



**Figure 30.** G6164 Dust collection adjustable nipple.

### Metal Hangers

We carry many types of hangers for installing ductwork.



**Figure 31.** 4" Metal hangers.

### Basic Eye Protection

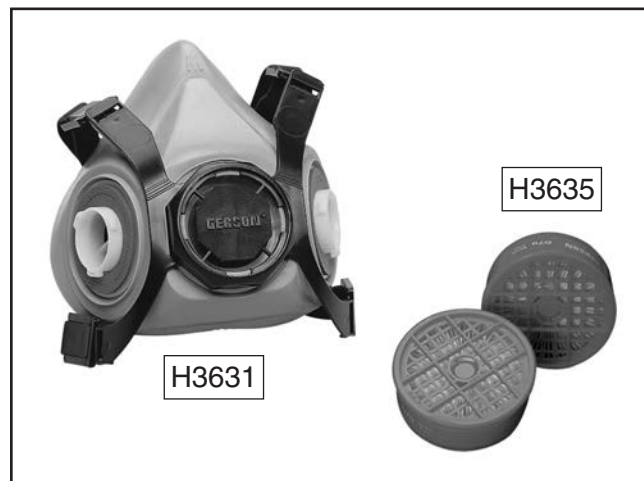
**T20502—Face Shield Crown Protector 7"**  
**T20503—Face Shield Window**  
**T20451—"Kirova" Clear Safety Glasses**  
**T20452—"Kirova" Anti-Reflective S. Glasses**  
**T20456—DAKURA Safety Glasses, Black/Clear**



**Figure 32.** Assortment of basic eye protection.

**H2499—Small Half-Mask Respirator**  
**H3631—Medium Half-Mask Respirator**  
**H3632—Large Half-Mask Respirator**  
**H3635—Cartridge Filter Pair P100**

Metal dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust every day, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



**Figure 33.** Half-mask respirator and disposable cartridge filters.

**H4978—Deluxe Earmuffs - 27dB**  
**H4979—Twin Cup Hearing Protection - 29dB**  
**T20446—Ear Plugs 200 Pair - 31dB**

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



**Figure 34.** Hearing Protection Assortment.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



# SECTION 6: MAINTENANCE

## Schedule

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

### Daily Check

- Loose mounting bolts.
- Check/empty dust collection drawer and dust tray.
- Check/replace filters.
- Worn or damaged wires.
- Any other unsafe condition.

### Monthly Check

- Clean dust buildup from inside cabinet and off motor. Inspect and clean inside ducts.

### Every 10–15 Hours

- Clean stainless steel mesh filter. Inspect for damage and replace if necessary.

### Every 25–30 Hours

- Clean active carbon filter.

### Every 35–40 Hours

- Clean pleated micro filter.

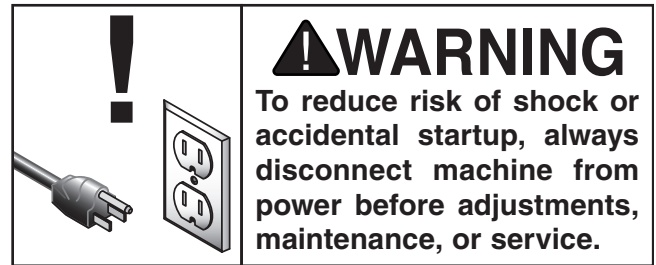
### Every 300 Hours

- Replace active carbon filter and pleated micro filter every 300 hours of use, or sooner if cleaning filters no longer improves airflow.

See **Page** for air filter cleaning instructions.

## **!WARNING**

Wear ANSI-approved safety goggles, a NIOSH-approved respirator, and leather gloves when removing, cleaning, and replacing filters. Carefully minimize amount of dust allowed to become airborne, and prevent spread of dust onto hands or clothing. Dispose of all waste properly according to local regulations for material type.



## Cleaning Exterior

To clean the exterior of the Model G0818, wipe off dust with a dry cloth.

## Cleaning Collection Drawer & Dust Tray

Frequently monitor and empty collection drawer and air filter dust tray during operations (see **Figure 35**). Wear NIOSH-approved respirator, ANSI-approved safety goggles, and leather gloves when inspecting or emptying drawer or tray.



**Figure 35.** Collection drawer and air filter dust tray.



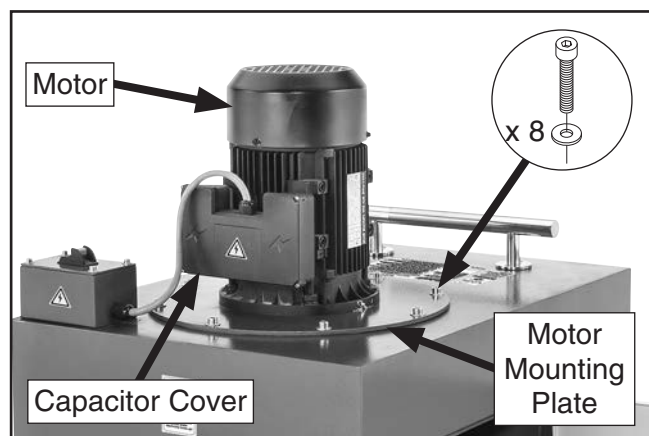
# Cleaning Impeller

The impeller normally requires no maintenance, but the blades can accumulate metal dust debris that will adversely affect motor performance. Removing the motor/impeller assembly allows cleaning and inspection of the impeller blades.

Tools Needed	Qty
Hex Wrench 6mm.....	1
Soft Bristle Brush .....	1
Shop Vacuum with HEPA Filter and Non-Conductive Hose .....	1
NIOSH-Approved Respirator .....	1
ANSI-Approved Safety Goggles.....	1
Leather Gloves .....	1 Pair

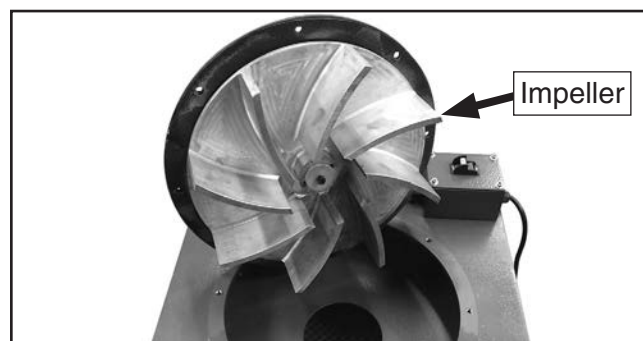
## To clean impeller and inspect motor shaft:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (8) cap screws and flat washers from motor mounting plate (see **Figure 36**).
3. Put on NIOSH-approved respirator, ANSI-approved safety goggles, and leather gloves.



**Figure 36.** Cap screws secure the motor/impeller assembly to the cabinet.

4. Remove motor/impeller assembly and carefully set it on capacitor cover (see **Figure 37**).



**Figure 37.** Motor/impeller assembly removed for cleaning and inspection.

5. Use a soft bristle brush and dry rag to remove dust from impeller blades and impeller housing. **DO NOT** use compressed air or your bare hands. Inspect impeller for damage and replace if necessary.
  - Use only NFPA 484-compliant shop vacuum with HEPA filter and non-conductive hose to vacuum debris inside housing. **DO NOT** use compressed air.
6. When complete, replace motor/impeller and re-install cap screws and flat washers.

# Cleaning Ducts

Inspect all ducts and fittings monthly and clean as necessary.

## To clean inside ducts:

1. DISCONNECT MACHINE FROM POWER!
2. Wear NIOSH-approved respirator, ANSI-approved goggles, and leather gloves.
3. Undo clamps to disconnect ducts and fittings. Use soft bristle brush and dry/damp rag to remove accumulated metal dust.
4. Reconnect ducts and secure clamps.



# Cleaning/Replacing Filters

The active carbon and pleated micro filters need regular cleaning and must be replaced every 300 hours or when airflow performance becomes noticeably reduced despite cleaning.

## **!WARNING**

**Wear ANSI-approved safety goggles, a NIOSH-approved respirator, and protective gloves when removing, cleaning, and replacing filters. Carefully minimize amount of dust allowed to become airborne, and prevent spread of dust onto hands or clothing. Dispose of all waste properly according to local regulations for material type.**

### Cleaning Filters

Always clean filters outdoors when possible! However, take special care to avoid contaminating the environment. When cleaning filters, always inspect for damage and replace if ANY damage or tears are found.

Initially clean all filters by carefully tapping caked-on dust into an enclosed container to minimize release of dust into the air, then follow the applicable instructions provided below for each filter type.

**IMPORTANT:** DO NOT use compressed air to clean filters—especially if indoors—as it will likely cause a large amount of fine dust to become airborne and could damage the Stage-2 and -3 filters.

#### Stage-1 Stainless Steel Mesh Filter

Flush with water or other liquid into an enclosed container and air dry. Carefully collect flushed waste and dispose of properly.

#### Stage-2 Active Carbon Filter

Clean with a soft bristle brush, or take outdoors and vacuum with a shop vacuum equipped with a HEPA filter.

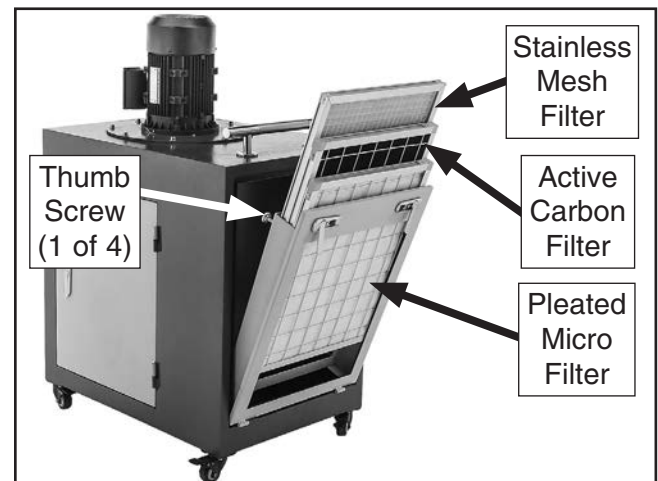
#### Stage-3 Pleated Micro Filter

Clean with a soft bristle brush, or take outdoors and vacuum with a shop vacuum equipped with a HEPA filter.

Model G0818 (Mfd. Since 10/16)

### Replacing Filters

1. DISCONNECT MACHINE FROM POWER!
2. Wear NIOSH-approved respirator, ANSI-approved goggles, and protective gloves while handling filters.
3. Unlatch filter door and lower to floor.
4. Loosen (4) knurled thumb screws and remove filters (see **Figure 38**). If re-using, note airflow direction across filter for replacement in **Step 5**.



**Figure 38.** Air filters and components.

5. Replace filters in same sequence as shown in **Figure 38**, while also maintaining original airflow direction. Tighten knurled thumb screws to secure filters.
6. Close and latch filter door.

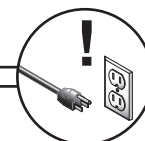




# SECTION 7: SERVICE

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

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> <li>1. Switch disabling key removed.</li> <li>2. Power supply circuit breaker tripped or fuse blown.</li> <li>3. Motor wires connected incorrectly.</li> <li>4. Wiring open/has high resistance.</li> <li>5. ON/OFF switch at fault.</li> <li>6. Start capacitor at fault.</li> <li>7. Motor at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Install switch disabling key (<b>Page 19</b>).</li> <li>2. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse.</li> <li>3. Correct motor wiring connections.</li> <li>4. Check/fix broken, disconnected, or corroded wires.</li> <li>5. Replace switch.</li> <li>6. Test/replace.</li> <li>7. Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Motor overheated.</li> <li>2. Motor wired incorrectly.</li> <li>3. Run capacitor at fault.</li> <li>4. Motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Turn off machine, allow motor to cool.</li> <li>2. Inspect/correct motor wiring (<b>Page 30</b>).</li> <li>3. Test/replace.</li> <li>4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Debris caught in impeller.</li> <li>2. Motor or component loose.</li> <li>3. Motor fan rubbing on cover.</li> <li>4. Motor mount loose/broken.</li> <li>5. Motor bearings at fault.</li> <li>6. Motor shaft bent.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect impeller for debris or damage (<b>Page 26</b>).</li> <li>2. Inspect/replace damaged bolts/nuts, and retighten with thread-locking fluid.</li> <li>3. Fix/replace fan cover; replace loose/damaged fan.</li> <li>4. Tighten/replace.</li> <li>5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>6. Test with dial indicator. Replace motor if damaged.</li> </ol>



## Operations

Symptom	Possible Cause	Possible Solution
Loud, repetitious noise, or excessive vibration coming from dust collector (non-motor related).	<ol style="list-style-type: none"> <li>1. Dust collector not on a flat surface and wobbles.</li> <li>2. Impeller is damaged and unbalanced.</li> <li>3. Impeller is loose on the motor shaft.</li> </ol>	<ol style="list-style-type: none"> <li>1. Stabilize dust collector; lock casters.</li> <li>2. Disconnect dust collector from power. Inspect impeller for dents, bends, or loose fins. Replace impeller if damaged.</li> <li>3. Secure impeller; replace motor and impeller as a set if motor shaft and impeller hub are damaged.</li> </ol>
Dust collector does not adequately collect dust or chips; poor performance.	<ol style="list-style-type: none"> <li>1. Collection drawer or air filter dust tray are full.</li> <li>2. Filters are dirty/clogged.</li> <li>3. Clog in ducting.</li> <li>4. Leak in ducting/connections.</li> <li>5. Ducting blocked/restricted.</li> <li>6. The dust collector is too far away from the point of suction, or there are too many sharp bends in the ducting.</li> <li>7. Dust collector is undersized.</li> </ol>	<ol style="list-style-type: none"> <li>1. Empty collection drawer and dust tray (<b>Page 25</b>).</li> <li>2. Clean filters; replace with new filters if performance does not improve (<b>Page 27</b>).</li> <li>3. Remove clog.</li> <li>4. Seal leak.</li> <li>5. Remove ducting from dust collector inlet and unblock the restriction.</li> <li>6. Relocate the dust collector closer to the point of suction; remove sharp bends in ducting.</li> <li>7. Install a larger dust collector.</li> </ol>



# 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			





# Wiring Diagram

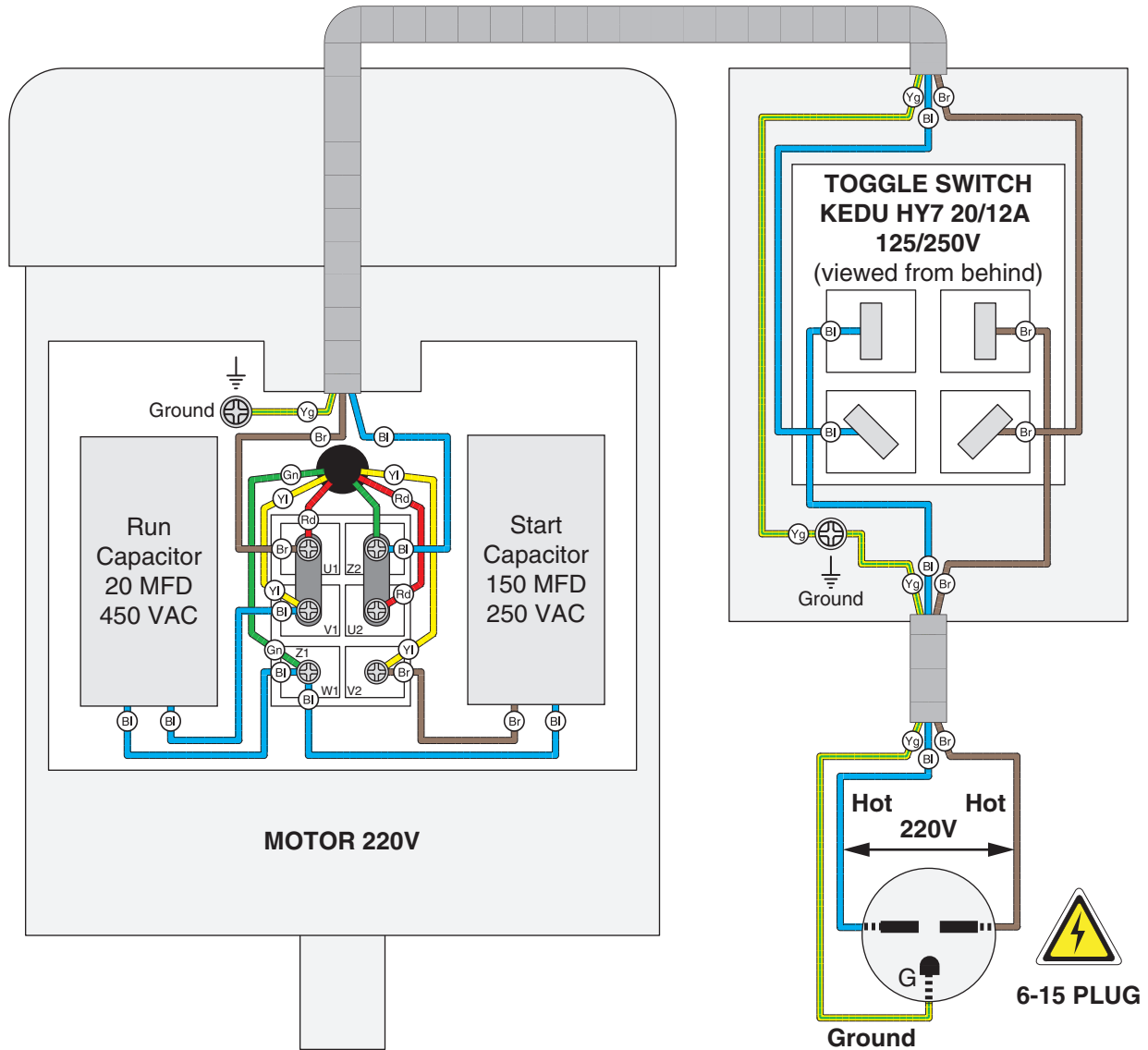


Figure 39. Motor and capacitor wiring.

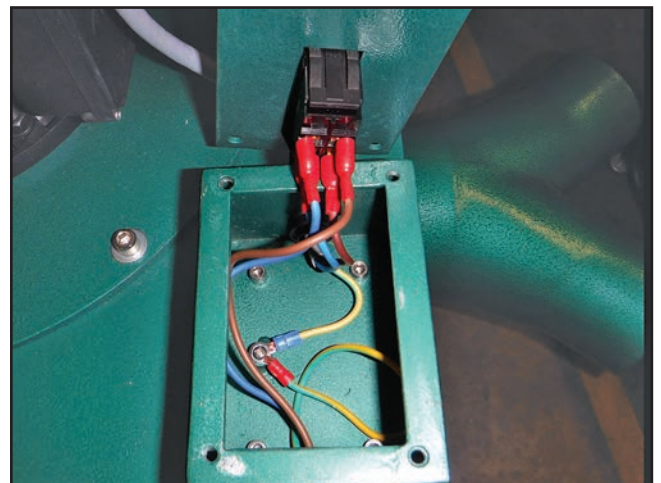
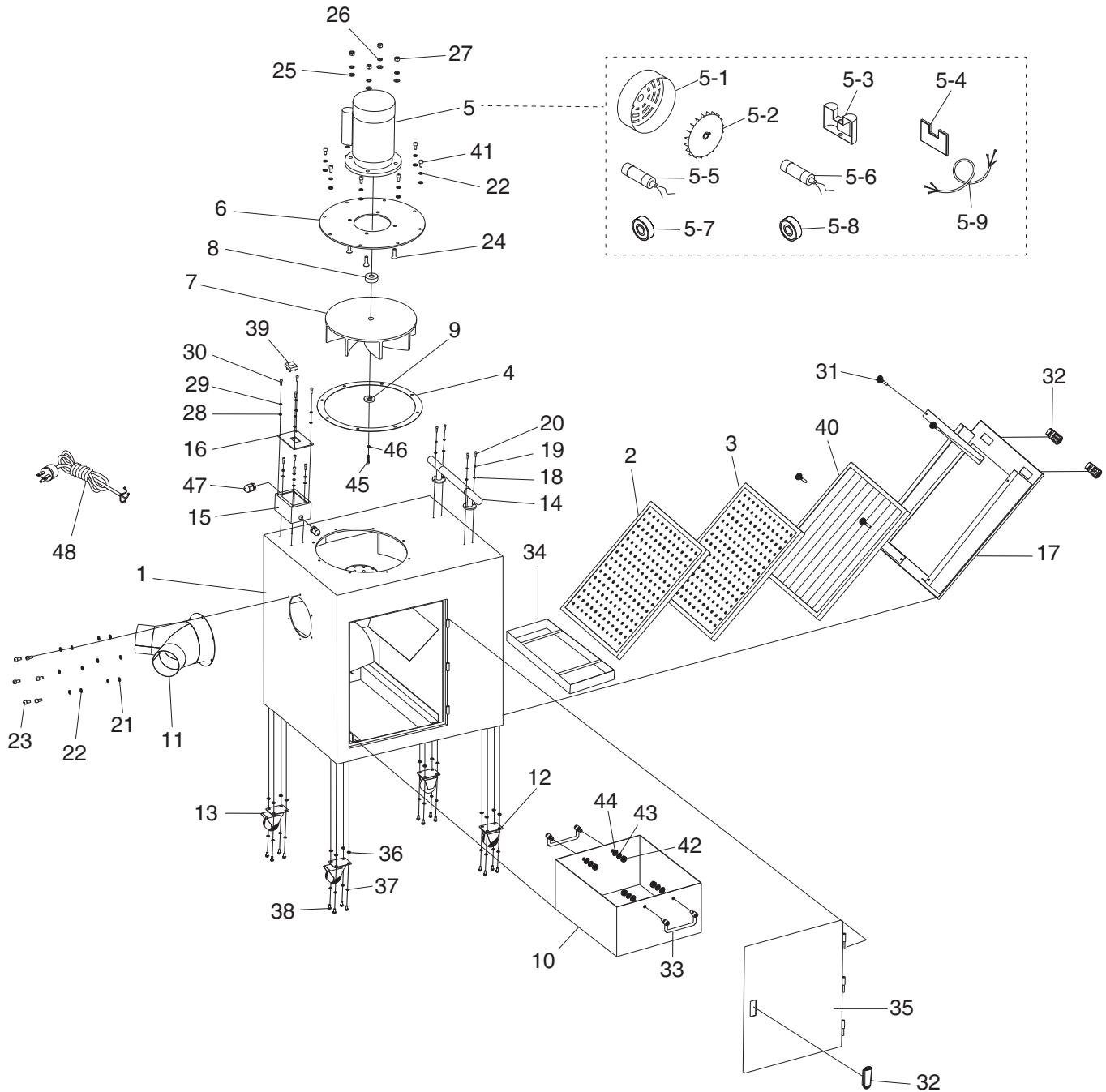


Figure 40. Switch wiring.

# 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.

## Breakdown



# Parts List

## REF PART # DESCRIPTION

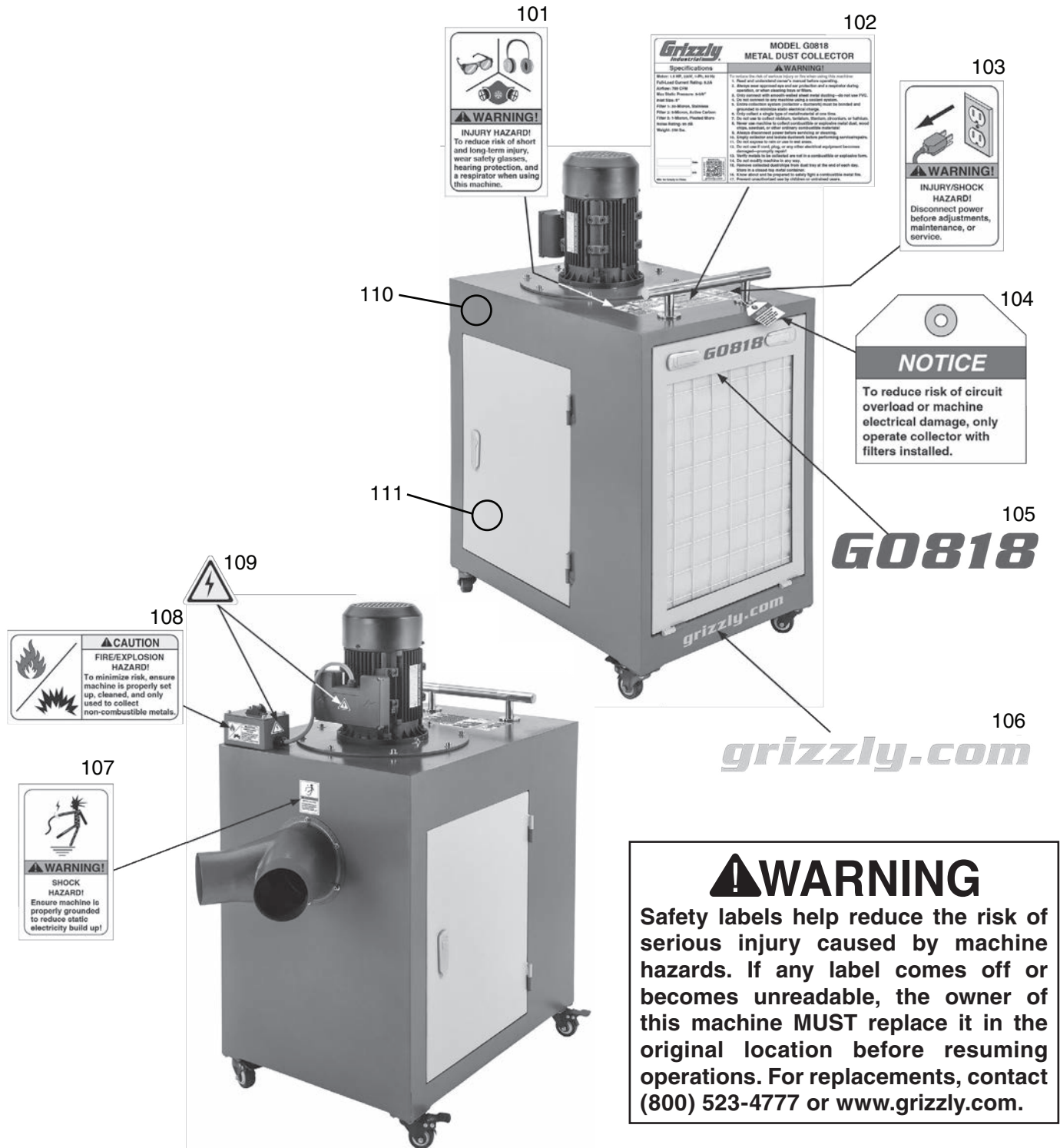
1	P0818001	CABINET
2	P0818002	STAGE-1 STAINLESS FILTER
3	P0818003	STAGE-2 ACTIVE CARBON FILTER
4	P0818004	CONNECTION PLATE GASKET
5	P0818005	MOTOR 1.5 HP 220V 1-PH
5-1	P0818005-1	MOTOR FAN COVER
5-2	P0818005-2	MOTOR FAN
5-3	P0818005-3	CAPACITOR CASE
5-4	P0818005-4	CAPACITOR COVER
5-5	P0818005-5	S CAPACITOR 150M 1-5/8 X 3-5/16
5-6	P0818005-6	R CAPACITOR 20M 450V 1-5/8 X 3-5/16
5-7	P0818005-7	BALL BEARING
5-8	P0818005-8	BALL BEARING
5-9	P0818005-9	MOTOR CORD 16G 3W 12"
6	P0818006	MOTOR CONNECTION PLATE
7	P0818007	IMPELLER
8	P0818008	SPACER, MOTOR
9	P0818009	SPACER, IMPELLER, 38 X 10 X 6MM
10	P0818010	COLLECTION DRAWER
11	P0818011	Y-INTAKE 4" X 4" X 6"
12	P0818012	LOCKING SWIVEL CASTER
13	P0818013	LOCKING SWIVEL CASTER
14	P0818014	STAINLESS STEEL HANDLE
15	P0818015	SWITCH BOX
16	P0818016	SWITCH BOX COVER PLATE
17	P0818017	FILTER DOOR
18	P0818018	FLAT WASHER 4MM
19	P0818019	LOCK WASHER 4MM
20	P0818020	FLAT HD CAP SCR M4-.7 X 16

## REF PART # DESCRIPTION

21	P0818021	FLAT WASHER 8MM
22	P0818022	LOCK WASHER 8MM
23	P0818023	CAP SCREW M8-1.25 X 16 SS
24	P0818024	FLAT HD SCR M10-1.5 X 35 SS
25	P0818025	FLAT WASHER 10MM
26	P0818026	LOCK WASHER 10MM
27	P0818027	HEX NUT M10-1.5
28	P0818028	FLAT WASHER 5MM
29	P0818029	LOCK WASHER 5MM
30	P0818030	CAP SCREW M5-.8 X 16 SS
31	P0818031	KNURLED THUMB SCREW M8-1.25 X 30
32	P0818032	LATCH
33	P0818033	DRAWER HANDLE
34	P0818034	DUST TRAY
35	P0818035	ACCESS DOOR
36	P0818036	FLAT WASHER 6MM
37	P0818037	LOCK WASHER 6MM
38	P0818038	HEX BOLT M6-1 X 12
39	P0818039	TOGGLE SWITCH KEDU HY7
40	P0818040	STAGE-3 PLEATED MICRO FILTER
41	P0818041	CAP SCREW M8-1.25 X 25
42	P0818042	HEX NUT M10-1.5
43	P0818043	LOCK WASHER 10MM
44	P0818044	FLAT WASHER 10MM
45	P0818045	CAP SCREW M6-1 X 25
46	P0818046	LOCK WASHER 6MM
47	P0818047	STRAIN RELIEF TYPE-3 M16-1.5
48	P0818048	POWER CORD 16G 3W 72"



# Labels & Cosmetics



REF	PART #	DESCRIPTION
101	P0818101	GLASSES/RESPIRATOR/HEARING LABEL
102	P0818102	MACHINE ID LABEL
103	P0818103	DISCONNECT POWER LABEL
104	P0818104	NOTICE FILTERS TAG
105	P0818105	MODEL NUMBER LABEL
106	P0818106	GRIZZLY.COM LABEL

REF	PART #	DESCRIPTION
107	P0818107	SHOCK HAZARD LABEL
108	P0818108	EXPLOSION HAZARD LABEL
109	P0818109	ELECTRICITY LABEL
110	P0818110	TOUCH-UP PAINT, GRIZZLY GREEN
111	P0818111	TOUCH-UP PAINT, PUTTY





# WARRANTY CARD

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

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

1. How did you learn about us?

\_\_\_\_\_ Advertisement \_\_\_\_\_ Friend \_\_\_\_\_ Catalog  
\_\_\_\_\_ Card Deck \_\_\_\_\_ Website \_\_\_\_\_ Other:

2. Which of the following magazines do you subscribe to?

_____ Cabinetmaker & FDM	_____ Popular Science	_____ Wooden Boat
_____ Family Handyman	_____ Popular Woodworking	_____ Woodshop News
_____ Hand Loader	_____ Precision Shooter	_____ Woodsmith
_____ Handy	_____ Projects in Metal	_____ Woodwork
_____ Home Shop Machinist	_____ RC Modeler	_____ Woodworker West
_____ Journal of Light Cont.	_____ Rifle	_____ Woodworker's Journal
_____ Live Steam	_____ Shop Notes	_____ Other:
_____ Model Airplane News	_____ Shotgun News	
_____ Old House Journal	_____ Today's Homeowner	
_____ Popular Mechanics	_____ Wood	

3. What is your annual household income?

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

4. What is your age group?

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

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

\_\_\_\_\_ 0-2 Years \_\_\_\_\_ 2-8 Years \_\_\_\_\_ 8-20 Years \_\_\_\_\_ 20+ Years

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

\_\_\_\_\_ 0-2 \_\_\_\_\_ 3-5 \_\_\_\_\_ 6-9 \_\_\_\_\_ 10+

7. Do you think your machine represents a good value?

\_\_\_\_\_ Yes \_\_\_\_\_ No

8. Would you recommend Grizzly Industrial to a friend?

\_\_\_\_\_ Yes \_\_\_\_\_ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

**Note:** We never use names more than 3 times.

\_\_\_\_\_ Yes \_\_\_\_\_ No

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

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

FOLD ALONG DOTTED LINE

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_



Place  
Stamp  
Here



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P.O. BOX 2069  
BELLINGHAM, WA 98227-2069



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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.



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