MODEL G0975/G0976/G0977
CYCLONE DUST COLLECTOR
OWNER'S MANUAL
(For models manufactured since 08/24)

G0975

G0976

G0977

#JA23113 PRINTED IN TAIWAN V1.12.24

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

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

⚠WARNING

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

⚠CAUTION

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

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

Machine Differences

G0975
- 1½ HP 120V/240V Motor
- 6" Dust Port Inlet
- 1062 CFM @ 2.65" SP
- 22-Gallon Collection Capacity

G0976
- 2 HP 220V Motor
- 6" Dust Port Inlet
- 1136 CFM @ 2.85" SP
- 28-Gallon Collection Capacity

G0977
- 3 HP 220V Motor
- 8" Dust Port Inlet
- 1751 CFM @ 2.50" SP
- 36-Gallon Collection Capacity

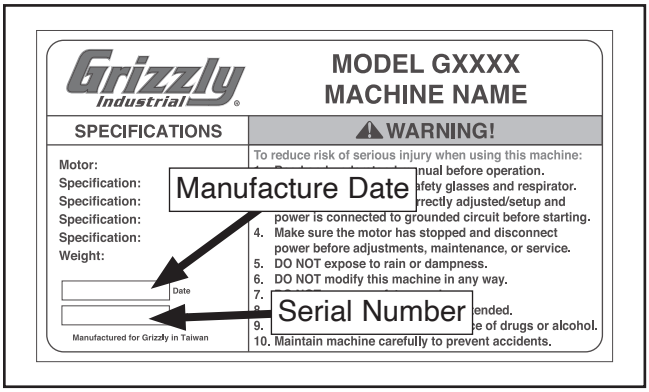
Manual Accuracy

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

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

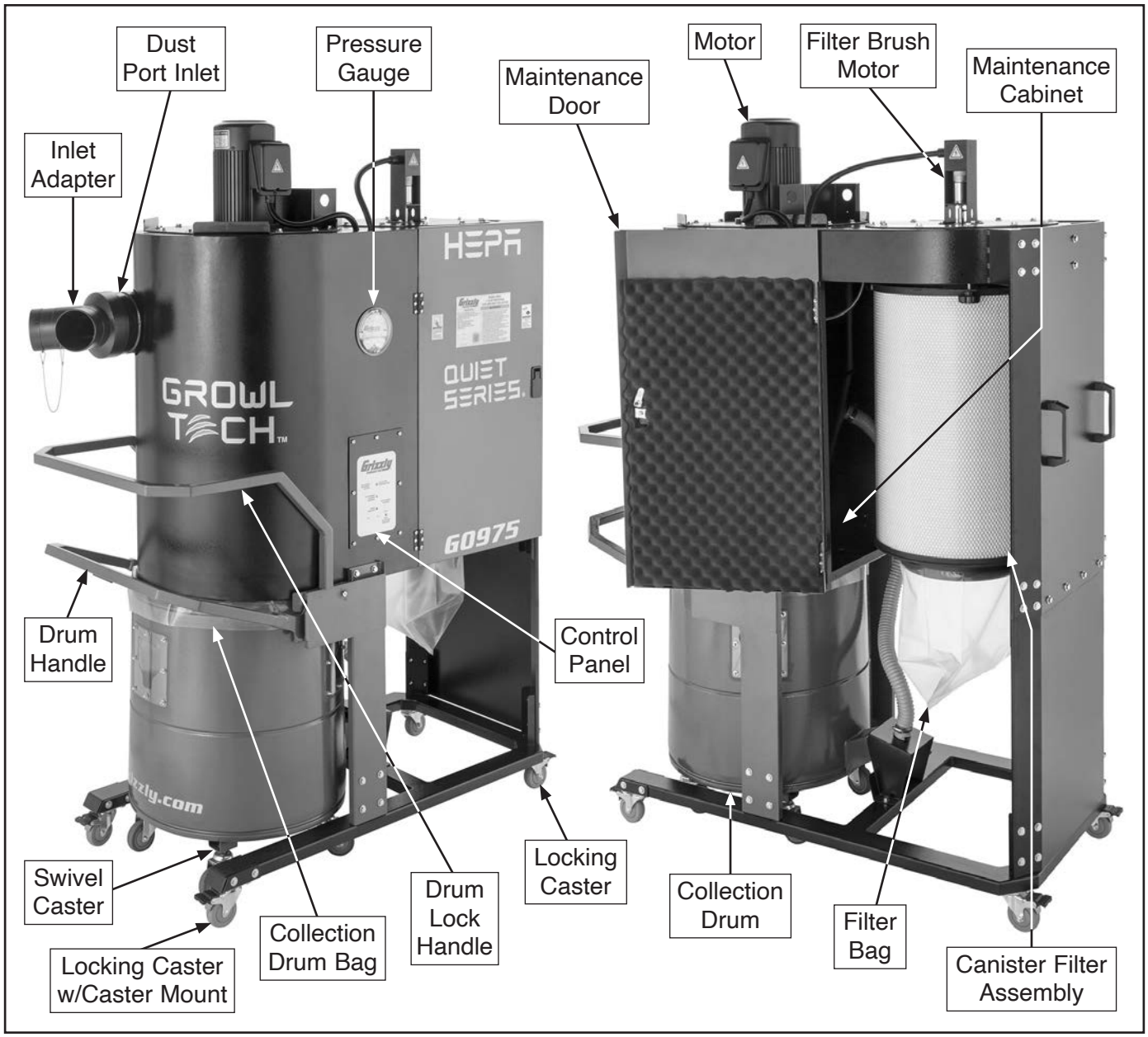
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

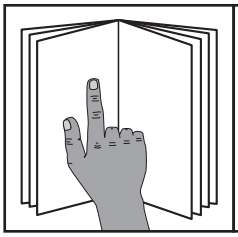
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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



Identification

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

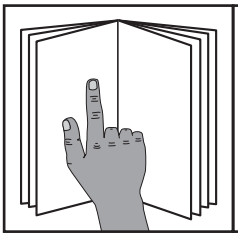




⚠WARNING

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

Controls & Components



⚠WARNING

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

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

Main Controls & Components

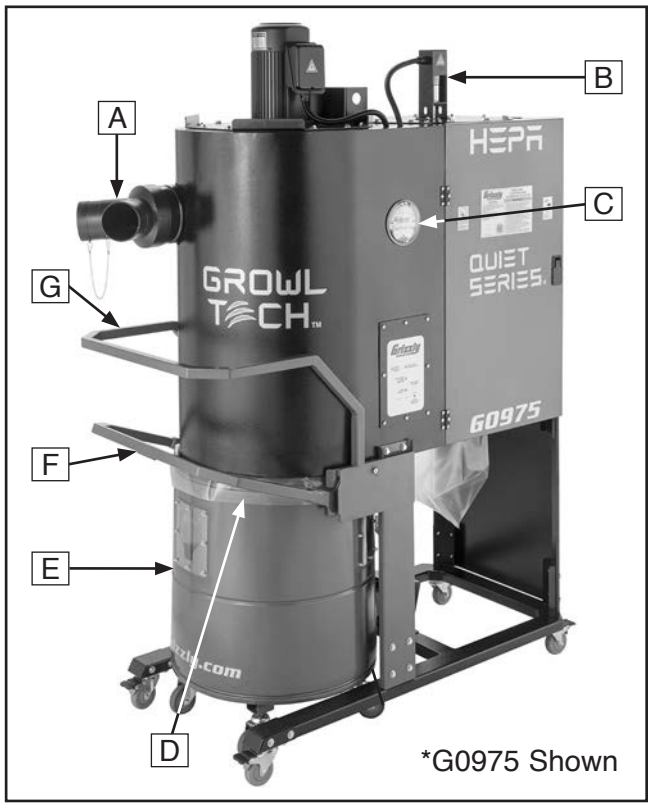


Figure 1. Main controls and components.

A. Inlet Adapter: Allows connection of multiple 4" ducts to main dust port inlet. G0975/G0976 adapter has two inlets and G0977 adapter has three inlets.

B. Filter Brush Motor: Rotates filter brush inside canister filter to remove caked on dust.

C. Pressure Gauge: Displays vacuum pressure, indicating when filter and collection bags need to be cleaned or replaced.

— Clean canister filter when operating pressure exceeds 6 inches of water (G0975/G0976) or 9 inches of water (G0977).

— If operating pressure exceeds 8 inches of water (G0975/G0976) or 11 inches of water (G0977) and cleaning does not improve performance, replace filter.

D. Collection Drum Bag: Collects wood chips and dust during operation.

E. Collection Drum: Collects large dust particles. Equipped with vacuum equalizer for using plastic collection bags, and an inspection window to see when drum is full.

F. Collection Drum Handle: Allows for easy collection drum movement. Handle lifts collection drum when pushed down.

G. Collection Drum Lock Handle: Secures collection drum to machine when pressed down. Releases collection drum when lifted.

Maintenance Cabinet Components

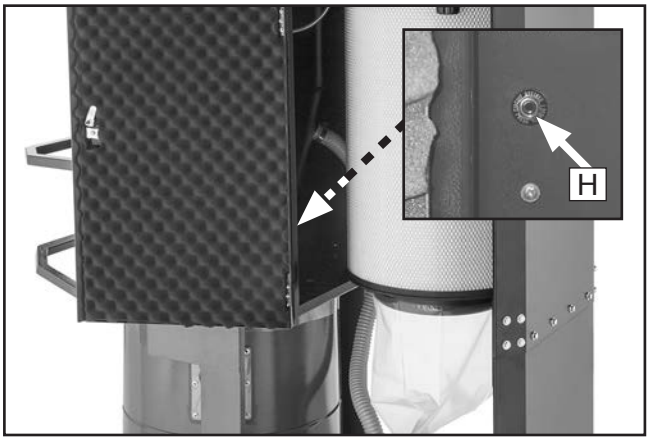


Figure 2. Circuit breaker reset button.

H. Circuit Breaker Reset Button: Allows machine to be restarted after thermal overload protection has tripped. To reset, place ON/OFF switch in OFF position, wait a few minutes for motor to cool, then press reset button. If button does not stay depressed, allow motor to cool longer, then try again.

Control Panel

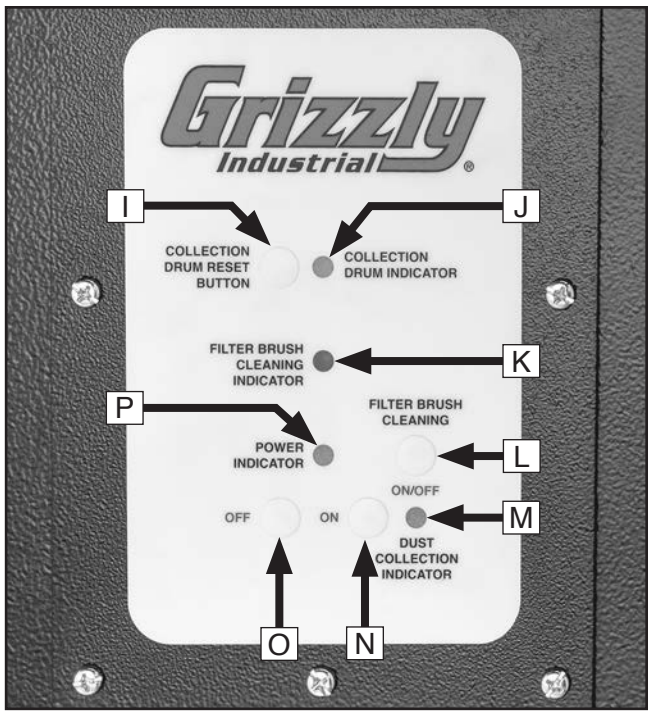


Figure 3. Control panel.

I. COLLECTION DRUM RESET BUTTON: Turns ***OFF*** indicator light to signify that drum has been emptied.

Note: *Empty collection drum before pressing collection drum reset button.*

J. COLLECTION DRUM INDICATOR: Illuminates when collection drum is full. Machine will shut ***OFF*** after 30 seconds once indicator illuminates.

K. FILTER BRUSH CLEANING INDICATOR: Illuminates when filter brush motor is operating.

L. FILTER BRUSH ON/OFF BUTTON: Turns filter brush motor ***ON*** when pressed. Motor automatically turns ***OFF*** after 8 seconds.

M. DUST COLLECTION INDICATOR: Illuminates when machine is operating.

N. ON Button: Turns main motor ***ON***.

O. OFF Button: Turns main motor ***OFF***.

P. POWER INDICATOR: Illuminates when machine is connected to power.

Remote Control

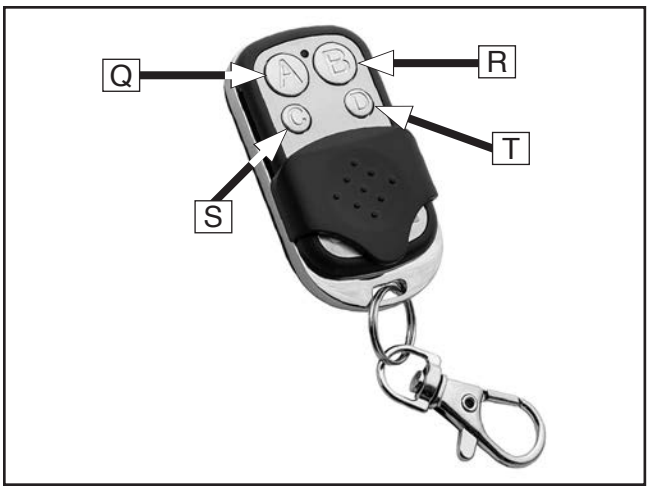


Figure 4. Remote control components.

Q. A Button: Turns main motor ***ON.***

R. B Button: Turns main motor ***OFF***.

S. C Button: Turns filter brush motor ***ON*** and ***OFF***.

T. D Button: Pairs remote with control panel.

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

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

MACHINE DATA SHEET

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

MODEL G0975/G0976/G0977 DUST COLLECTOR

Model Number	G0975	G0976	G0977
Product Dimensions			
Weight	386 lbs.	420 lbs.	484 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	53½" x 25" x 72½"	53½" x 25" x 77"	60½" x 28½" x 78½"
Footprint (Length x Width)	48" x 23½"	48" x 23½"	54½" x 27½"
Shipping Dimensions			
Carton #1 Type	Cardboard Box w/Wood Skids		
Content	Machine		
Weight	446 lbs.	469 lbs.	553 lbs.
Length x Width x Height	53" x 30" x 52"	53" x 30" x 53"	58" x 35" x 53"
Carton #2 Type	N/A		Cardboard
Content	N/A		Filter
Weight	N/A		69 lbs.
Length x Width x Height	N/A		23" x 23" x 43"
Electrical			
Power Requirement	120V/240V, Single-Phase, 60 Hz	220V, Single-Phase, 60 Hz	
Pre-Wired Voltage	120V	N/A	
Full-Load Current Rating	20A at 120V, 10A at 240V	14A	26A
Minimum Circuit Size	20A at 120V, 15A at 240V	20A	30A
Connection Type	Cord & Plug		
Power Cord Included	Yes		
Power Cord Length	118"		
Power Cord Gauge	12 AWG	14 AWG	12 AWG
Plug Included	Yes		
Included Plug Type	5-20 for 120V	6-15	L6-30
Recommended Plug Type	6-15 for 240V	N/A	N/A
Switch Type	Control Panel w/Remote Control		Magnetic Switch w/Overload Protection & Remote Control

Model Number	G0975	G0976	G0977
Main Motor			
Horsepower	1½ HP	2 HP	3 HP
Phase	Single-Phase		
Amps	20A/10A	14A	26A
Speed	3450 RPM		
Type	TEFC Capacitor-Start Induction		
Power Transfer	Direct		
Bearings	Shielded & Permanently Lubricated		
Centrifugal Switch/Contacts Type	Internal		
Filter Brush Motor			
Horsepower	3 Watt		
Phase	Single-Phase		
Amps	0.8A		
Speed	12 RPM		
Type	Universal 24 VDC		
Power Transfer	Direct		
Operation			
Dust Collector Type	Two-Stage (Cyclone)		
Approved Dust Types	Wood		
Filter Type	Pleated Cartridge & HEPA		
Air Flow Performance	1062 CFM @ 2.65 in. SP	1136 CFM @ 2.85 in. SP	1751 CFM @ 2.50 in. SP
Max Static Pressure (at 0 CFM)	9.8"	10.7"	13.3"
Main inlet Size	6"		8"
Inlet Adapter Included	Yes		
Number of Adapter Inlets	2		3
Adapter Inlet Size	4"		
Machine Collection Capacity	2		3
Max Material Collection Capacity	22 Gallons	28 Gallons	36 Gallons
Filter Information			
Number of Filters	2		
Filtration Rating	99.97% @ 0.3 Microns		
Filter Surface Area	294.9 sq. ft.	348.8 sq. ft.	387.5 sq. ft.
Number of Primary Filters	1		
Primary Filter Type	Pleated Cartridge		
Primary Filter Rating	95% @ 0.2 - 2 microns		
Primary Filter Length	25⅛"		35½"
Primary Filter Width	12⅞"		
Number of Secondary Filters	1		
Secondary Filter Type	HEPA		
Secondary Filter Rating	99.97% @ 0.3 microns		
Secondary Filter Length	25⅛"		35½"
Secondary Filter Width	16¾"		

Model Number	G0975	G0976	G0977
Bag Information			
Number of Filter Bags	1		
Number of Collection Bags	1		
Filter Bag Diameter	12¼"		
Filter Bag Length	16"		
Collection Drum Bag Diameter	21¾"		24⅞"
Collection Drum Bag Length	37½"		
Canister Information			
Number of Canister Filters	2		
Collection Drum Size	27 Gallons	35 Gallons	45 Gallons
Impeller Information			
Impeller Type	Aluminum Radial Fin		
Impeller Size	13½"	14½"	15½"
Impeller Blade Thickness	0.16"		
Construction			
Upper Bag	Clear Plastic (Filter)		
Lower Bag	Clear Plastic (Drum)		
Canister	Spun Bond Polyester		
Base	Steel		
Frame	Steel		
Caster	Polypropylene (PP)		
Impeller	Aluminum		
Paint Type/Finish	Powder Coated		
Blower Housing	Steel		
Body	Steel		
Collection Drum	Steel		
Other Specifications			
Country of Origin	Taiwan		
Warranty	1 Year		
Approx. Assembly & Setup Time	1½ Hours		2½ Hours
Serial Number Location	Machine ID Label		
Sound Rating	74 dB	77 dB	79 dB
ISO 9001 Factory	Yes		

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Dust Collectors

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

SECTION 2: POWER SUPPLY

G0975 Power Supply

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 120V ..... 20 Amps
Full-Load Current Rating at 240V ..... 10 Amps

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

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

Circuit Information

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

⚠CAUTION

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

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

Circuit Requirements for 120V

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

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 5-20

Circuit Requirements for 240V

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle ..... 60 Hz
Phase ..... 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 120V 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.

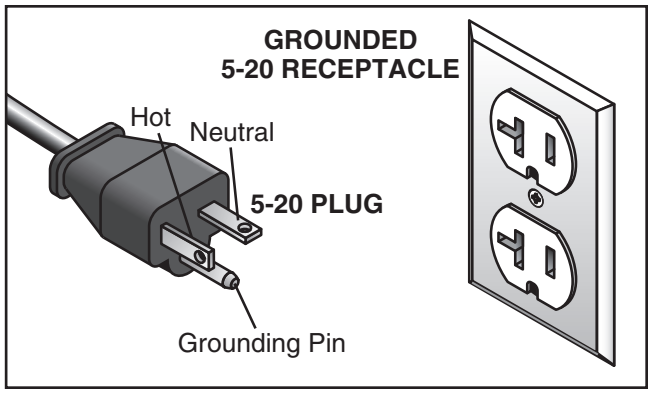
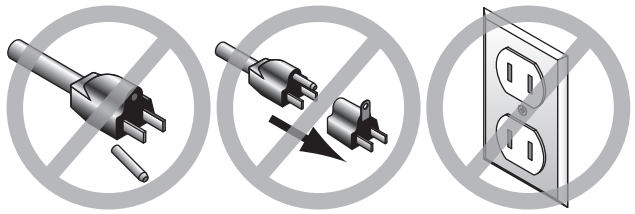


Figure 5. Typical 5-20 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

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

For 240V operation: The plug specified under "Circuit Requirements for 240V" on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

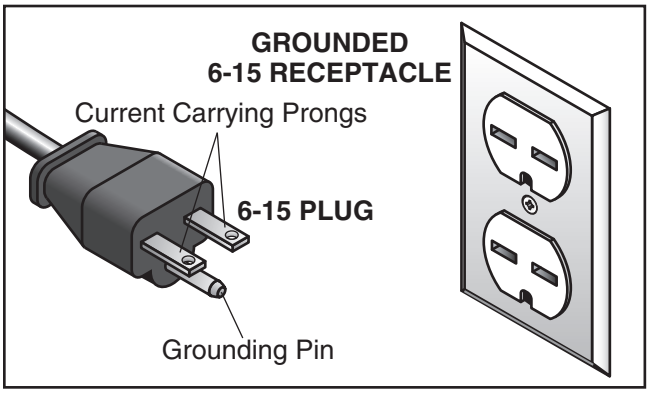


Figure 6. Typical 6-15 plug and receptacle.

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 machine is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

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

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

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

Minimum Gauge Size.....12 AWG
Maximum Length (Shorter is Better).....50 ft.

Converting Voltage to 240V (G0975)

Voltage conversions MUST be performed by an electrician or qualified service personnel.

To perform voltage conversion, rewire main motor, replace circuit breaker, then install the correct plug.

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

Items Needed	**Qty**
Phillips Head Screwdriver #1	1
Masking Tape	As Needed
Wire Nut (12AWG)	1
Electrical Tape	As Needed
KUOYUH 88 Series Circuit Breaker 15A	1
NEMA 6-15 Plug	1

To convert voltage to 240V:

1. DISCONNECT MACHINE FROM POWER!

2. Cut 5-20 plug off end of power cord.

3. Open motor junction box (see **Figure 7**).

Figure 7. G0975 motor junction box.

4. Remove electrical tape and wire nuts from wires in motor junction box (see **Figure 8**).

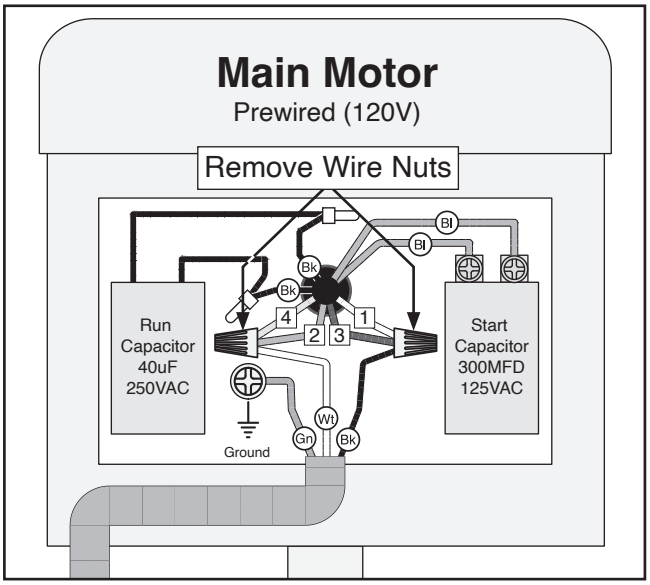


Figure 8. G0975 main motor (120V).

5. Connect wires 2 and 3 with a wire nut and secure with electrical tape (see **Figure 9**).

6. Connect black incoming power wire with wire 1, then secure with wire nut and electrical tape (see **Figure 9**).

7. Connect white incoming power wire with wire 4, then secure with wire nut and electrical tape (see **Figure 9**).

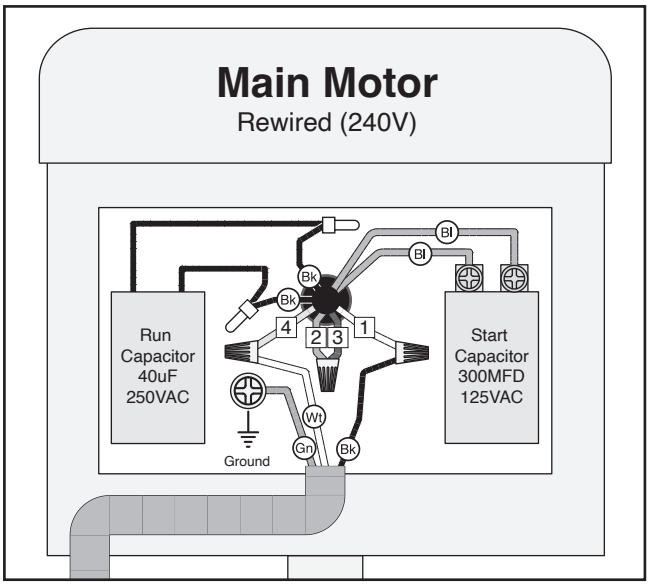


Figure 9. G0975 main motor (240V).

8. Remove control panel, then disconnect wires from 20A circuit breaker (see **Figure 10**).

Note: *We recommend using masking tape to label each wire to ensure correct wiring in next steps.*

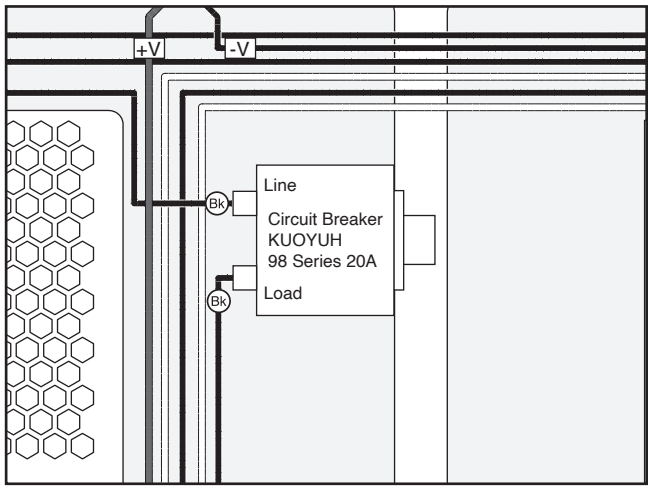


Figure 10. 25A circuit breaker.

9. Open front maintenance door, remove 20A circuit breaker (see **Figure 11**) and replace with 15A circuit breaker.

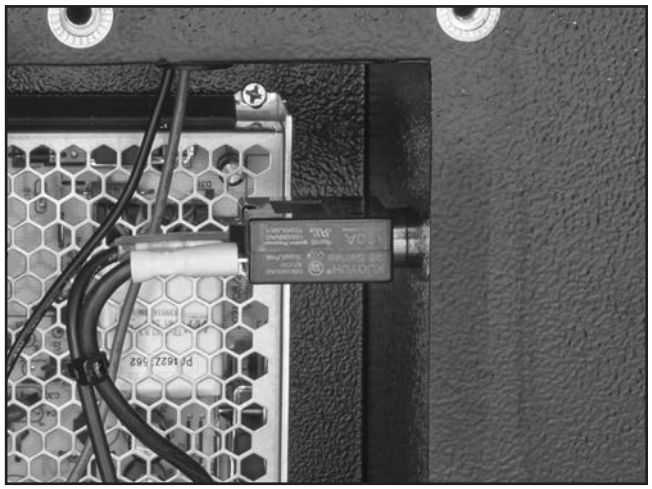


Figure 11. Location of circuit breaker.

10. Connect wires disconnected in **Step 8** to 15A circuit breaker (see **Figure 12**).

Note: *Ensure wires are connected to the correct corresponding terminals.*

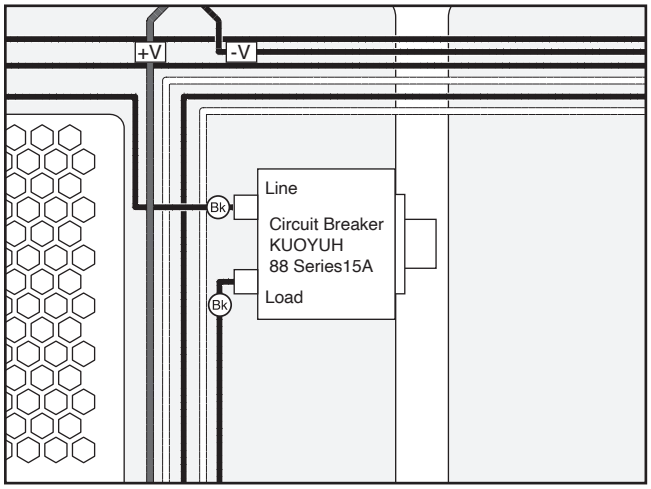


Figure 12. 15A circuit breaker.

11. Install 6-15 plug on end of power cord, according to plug manufacturer's instructions.

— If plug manufacturer did not include instructions, wiring of generic NEMA 6-15 plug is illustrated on **Page 54**.

Note: *Ensure wires are connected to the correct corresponding terminals.*

G0976/G0977 Power Supply

Availability

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

⚠WARNING

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

Full-Load Current Rating at 220V

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 (G0976) .... 14 Amps
Full-Load Current Rating (G0977) .... 26 Amps

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

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

Circuit Information

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

⚠CAUTION

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

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

Circuit Requirements

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle.....60 Hz
Phase..... Single-Phase
Power Supply Circuit (G0976)..... 20 Amps
Power Supply Circuit (G0977)..... 30 Amps
Plug/Receptacle (G0976)..... NEMA 6-15
Plug/Receptacle (G0977).....NEMA L6-30

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.

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

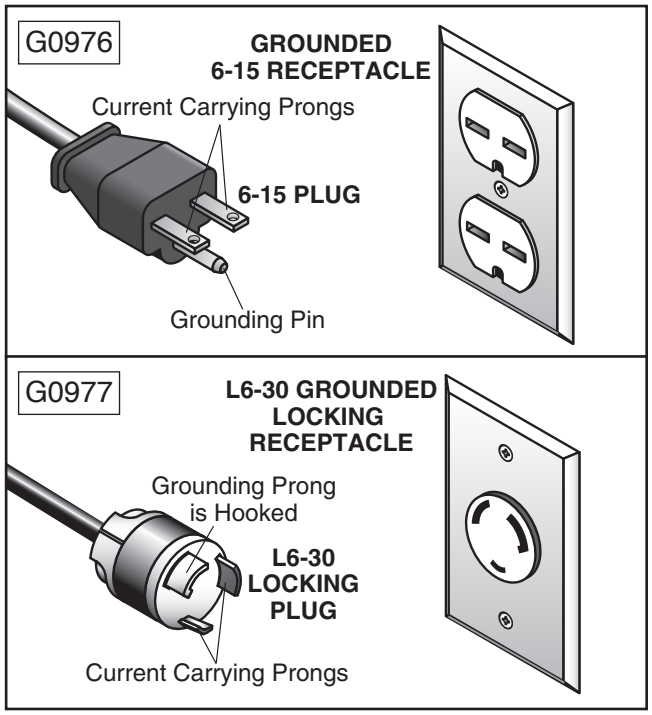
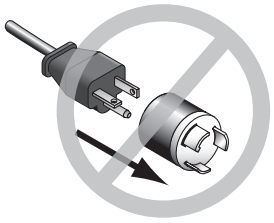


Figure 13. Typical 220V plugs and receptacles.

⚠CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

⚠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 machine is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

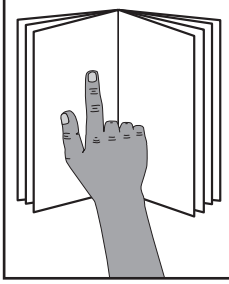
We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

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

Minimum Gauge Size.....12 AWG
Maximum Length (Shorter is Better).....50 ft.

SECTION 3: SETUP

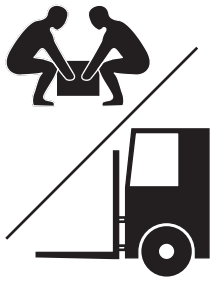


⚠WARNING

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
• Safety Glasses (for each person)	1
• Another Person	1
• Lifting Straps (Rated for at least 700 lbs.)	2
• Lifting Equipment (Rated for at least 700 lbs.)	1
• Flat Head Screwdriver ¼"	1
• Phillips Screwdriver #2	1
• Wrench or Socket 7/16"	1
• Wrench or Socket ½"	2
• Wrench or Socket 9/16"	2
• Wrench or Socket 10mm	1
• Hex Wrench 4mm	1
• Hex Wrench 6mm	1
• Retaining Ring Pliers	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.*

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.

Boxed Parts Inventory		Qty
A.	Machine Body	1
B.	Stand Base	1
C.	Leg (Left)	1
D.	Leg (Right)	1
E.	Rear Cover (Lower)	1
F.	Rear Cover (Upper)	1
G.	Collection Drum Lock Handle	1
H.	Collection Drum Handle	1
I.	Collection Drum	1
J.	Collection Drum Vacuum Ring	1
K.	Canister Filter Assembly	1
L.	Filter Brush Assembly	1
M.	Maintenance Door (Left)	1
N.	Maintenance Door (Right)	1
O.	Vacuum Hose w/Clamps	1
P.	Collection Bag (G0975/G0976)	1
Q.	Collection Bag (G0977)	1
R.	Filter Bag	1
S.	Inlet Adapter 6" x 4" x 2 (G0975/G0976)	1
T.	Inlet Adapter 8" x 4" x 3 (G0977)	1
U.	Locking Casters 3" w/Caster Mounts	2
V.	Locking Swivel Casters 3"	2
W.	Swivel Casters 3"	4
X.	Vacuum Hose Bracket	1
Y.	Filter Brush Base	1
Z.	Remote Control	1
AA.	Bag Clamp	1
AB.	Handles	2

Figure 14. Boxed parts inventory.

Fasteners (Figure 15)	Qty
AC. Hex Bolts ¼"-20 x ¾"	16
AD. Hex Bolts 5/16"-18 x ¾"	44
AE. Tap Screw #10 x ½"	1
AF. Knob Bolts ¼"-20 x ¾"	2
AG. Knob Bolts 3/8"-16 x 2"	3
AH. Cap Screws 5/16"-18 x ¾"	4
AI. Shoulder Screws M6-1 x 25	2
AJ. Phillips Head Screws 3/16"-24 x ½"	12
AK. Fender Washers ¼"	16
AL. Flat Washers 5/16"	48
AM. External Retaining Rings 13mm	2
AN. Hex Nuts 3/16"-24	12
AO. Hex Nuts 5/16"-18	4
AP. Hex Nuts 3/8"-16	4
AQ. Lock Nuts M6-1	2

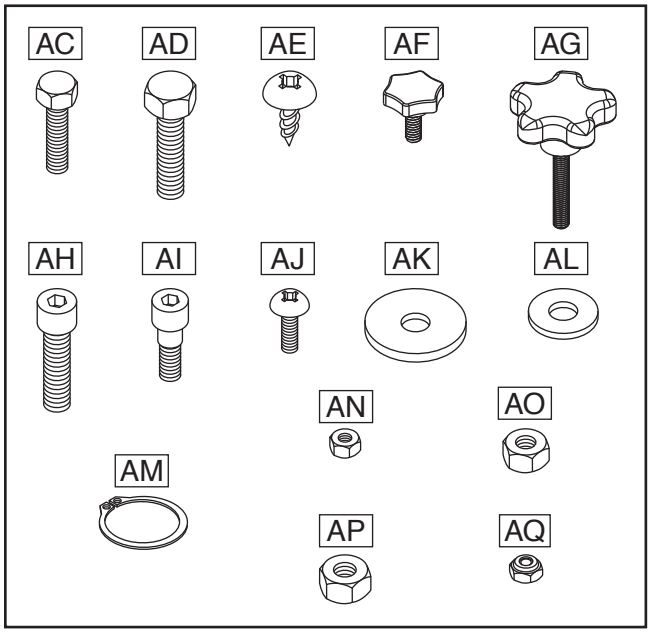
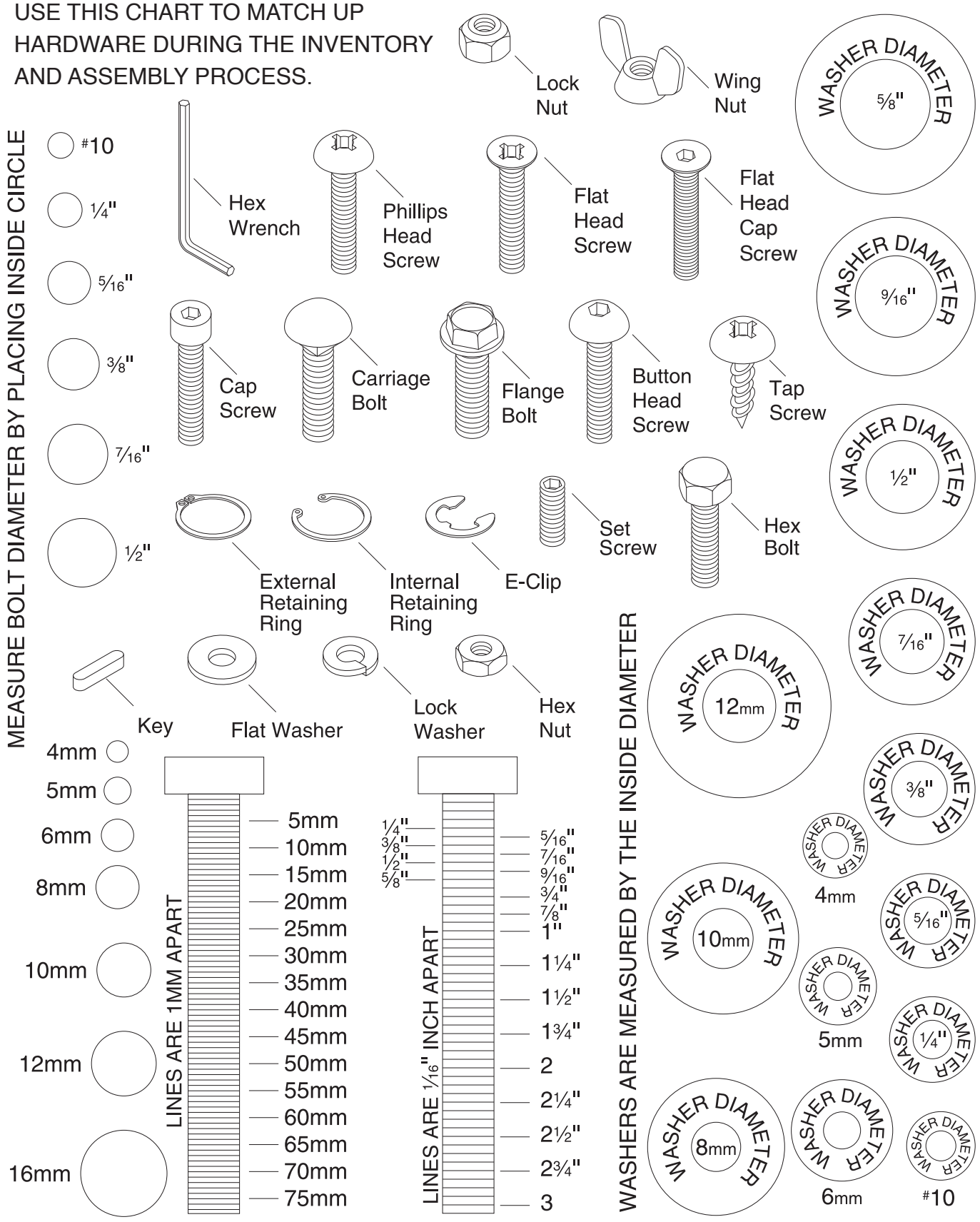


Figure 15. Hardware/fasteners.

Hardware Recognition Chart

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



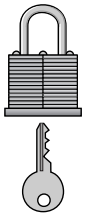
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

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

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

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

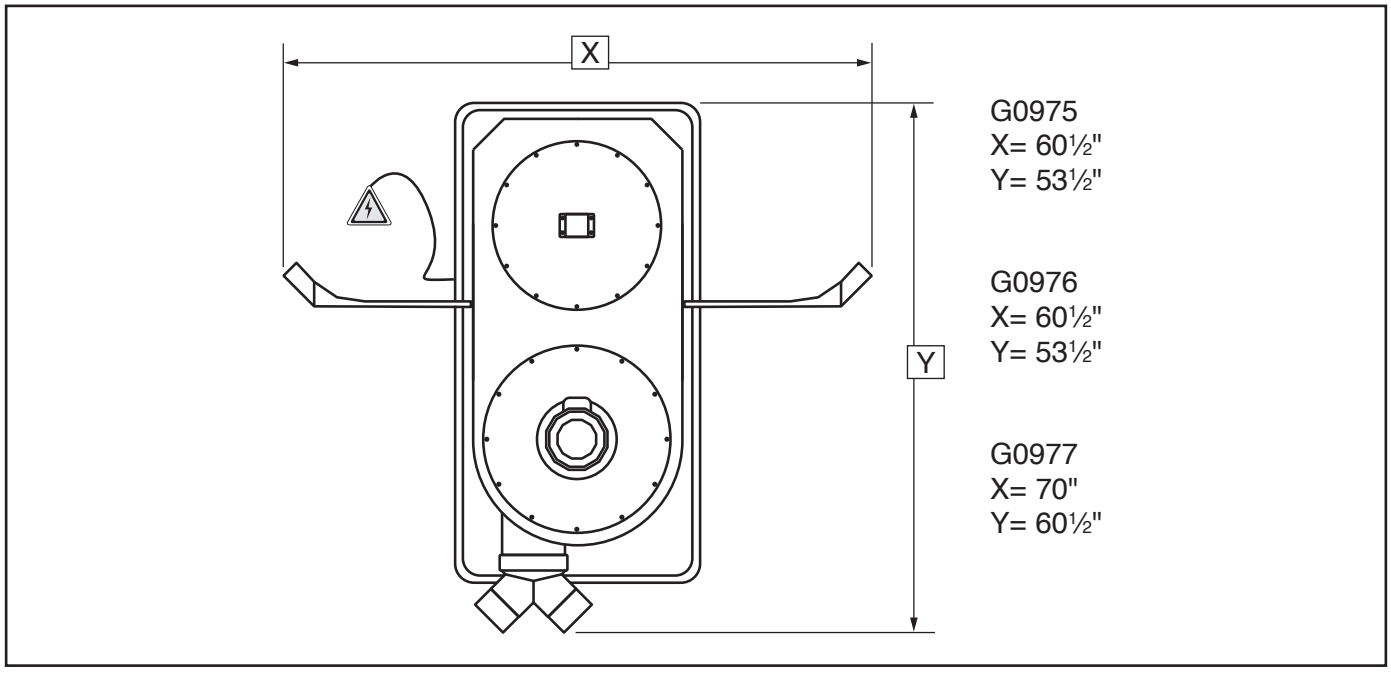


Figure 16. Minimum working clearances.

Assembly

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

To assemble machine:

1. Attach (2) locking swivel casters and (2) locking casters w/caster mounts to stand base with (16) ¼"-20 x ¾" hex bolts and (16) ¼" fender washers, as shown in **Figure 17**.

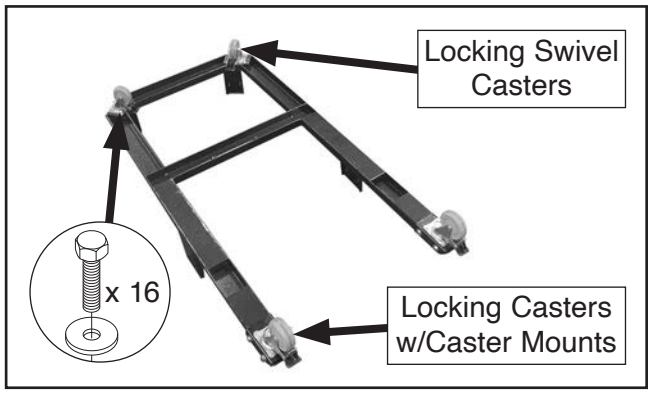


Figure 17. Locking casters attached to stand base.

2. Turn base over, then lock casters to secure base for next steps.

3. Fasten vacuum hose bracket to stand base using (2) 5/16"-18 x ¾" hex bolts and (2) 5/16" flat washers (see **Figure 18**).

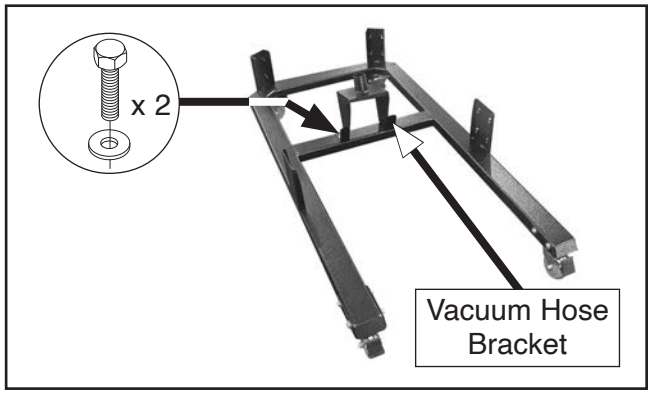


Figure 18. Vacuum hose bracket fastened to stand base.

4. Attach right and left legs to stand base using (8) 5/16"-18 x ¾" hex bolts and (8) 5/16" flat washers (see **Figure 19**).

Note: *Ensure legs are facing front of stand base, as shown in* ***Figure 19****.*

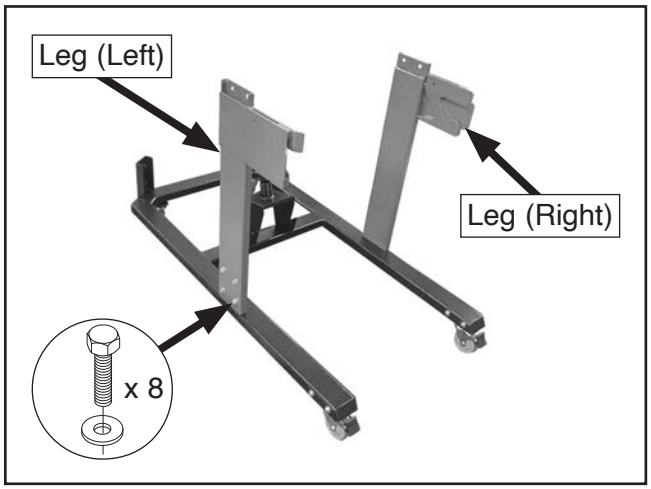


Figure 19. Right and left legs attached to stand base.

5. Attach lower rear cover to back of stand base with (8) 5/16"-18 x ¾" hex bolts and (8) 5/16" flat washers (see **Figure 20**).

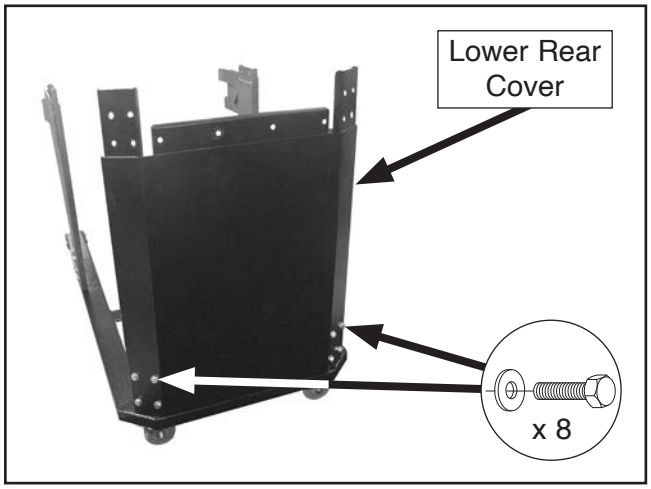


Figure 20. Lower rear cover attached to stand base.

6. Attach upper rear cover to brackets on lower rear cover with (12) 5/16"-18 x 3/4" hex bolts and (12) 5/16" flat washers (see **Figure 21**).

Note: *Ensure upper rear cover is attached to exterior surface of lower rear cover.*

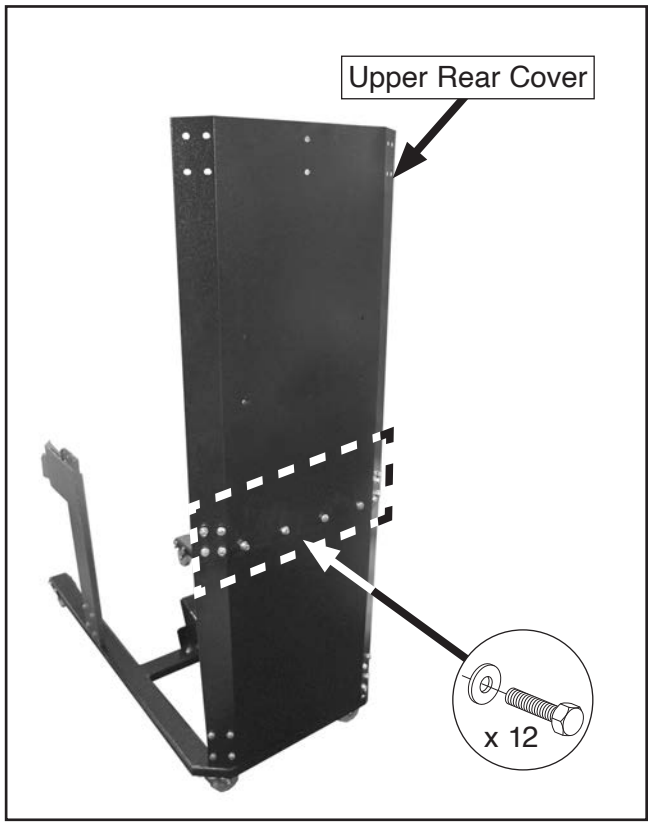


Figure 21. Upper rear cover attached to lower rear cover.

7. Attach (2) handles to upper rear cover using (4) 5/16"-18 x 3/4" cap screws, (4) 5/16" flat washers, and (4) 5/16"-18 hex nuts (see **Figure 22**).

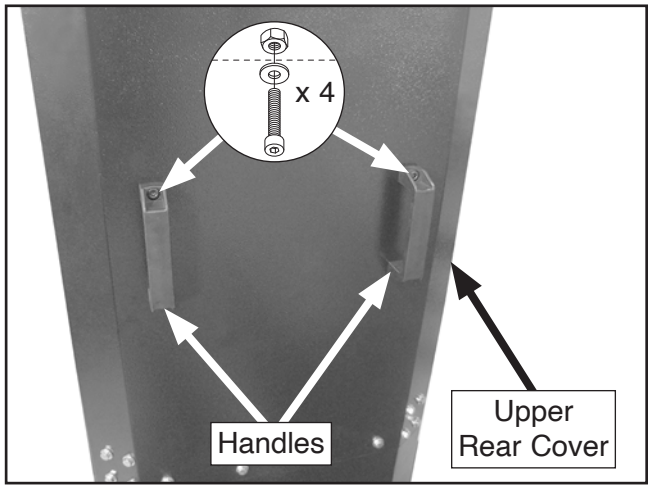


Figure 22. Handles attached to upper rear cover.

⚠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.

8. Pass lifting straps (rated for at least 700 lbs.) through holes in impeller cover base, then with a forklift or hoist, lift machine body, as shown in **Figure 23**.

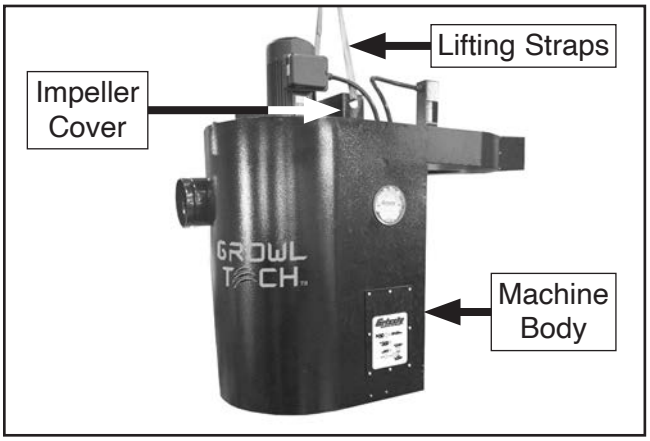


Figure 23. Location of machine lifting point.

9. Attach machine body to upper rear cover and legs with (14) 5/16"-18 x 3/4" hex bolts and (14) 5/16" flat washers, as shown in **Figure 24**.

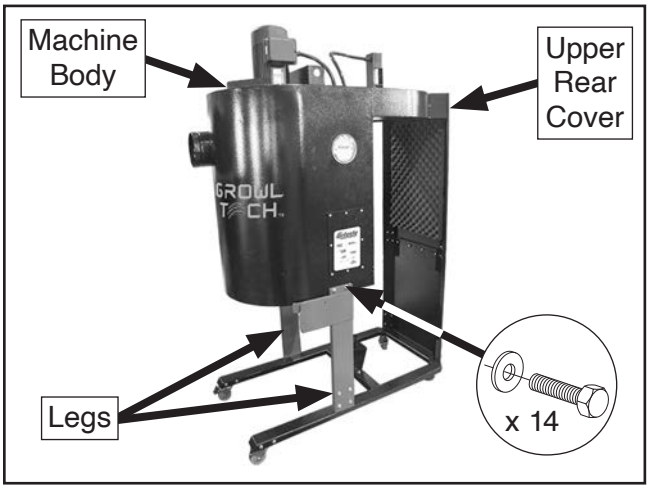


Figure 24. Machine body attached to stand.

10. Attach collection drum lock handle to legs using (2) M6-1 x 25 shoulder screws and (2) M6-1 lock nuts (see **Figure 25**).

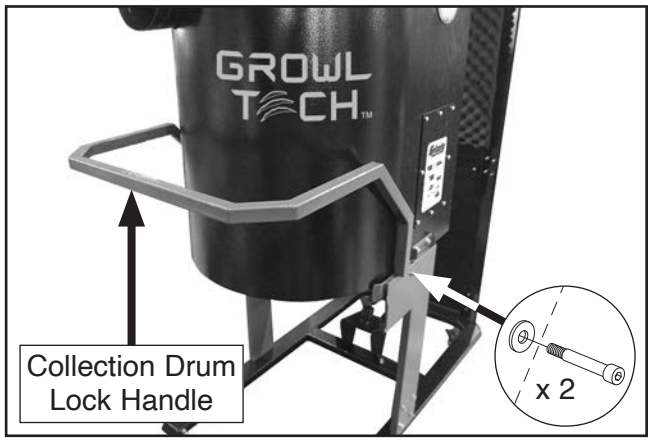


Figure 25. Collection drum lock handle attached to legs.

11. Install (4) swivel casters on bottom of collection drum with (4) 3/8"-16 hex nuts, as shown in **Figure 26**.

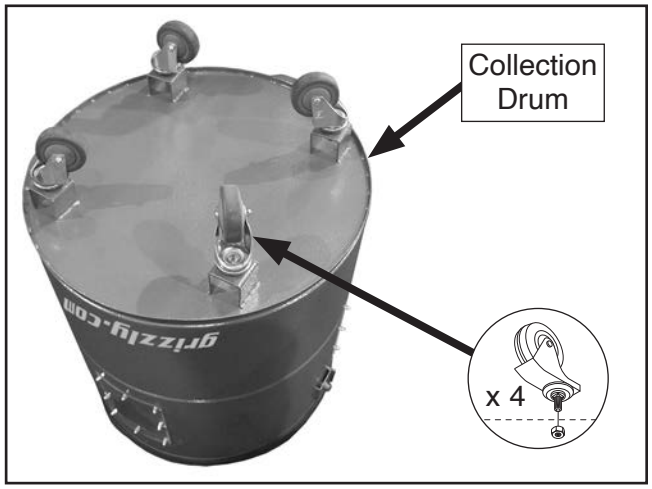


Figure 26. Swivel casters installed on collection drum.

12. Attach collection drum handle to collection drum and secure with (2) 13mm external retaining rings, as shown in **Figure 27**.

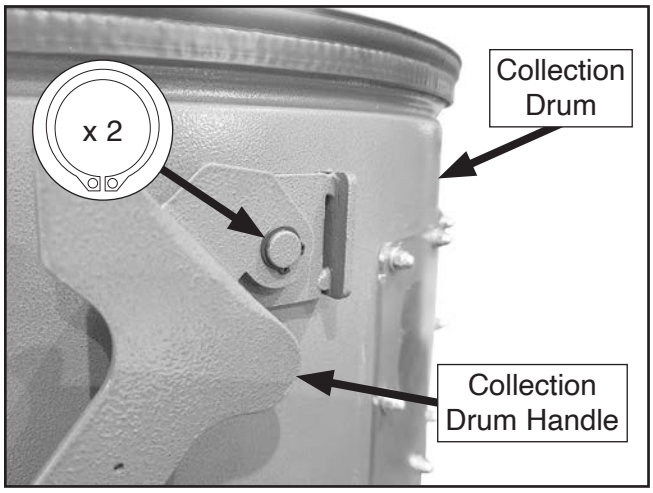


Figure 27. Collection drum handle attached to collection drum.

13. Place vacuum ring inside collection drum with inside ring facing down toward base of collection drum (see **Figure 28**).

Figure 28. Vacuum ring placed inside collection drum.

14. Place collection drum bag inside collection drum, then roll top of bag over top edge of collection drum, as shown in **Figure 29**.

Figure 29. Collection bag placed in collection drum.

15. Roll collection drum to front of machine, lift collection drum handle, then push drum into slots in legs (see **Figure 30**). Lower drum handle to engage lock handle.

Note: *When collection drum is properly seated, drum casters will lift off floor.*

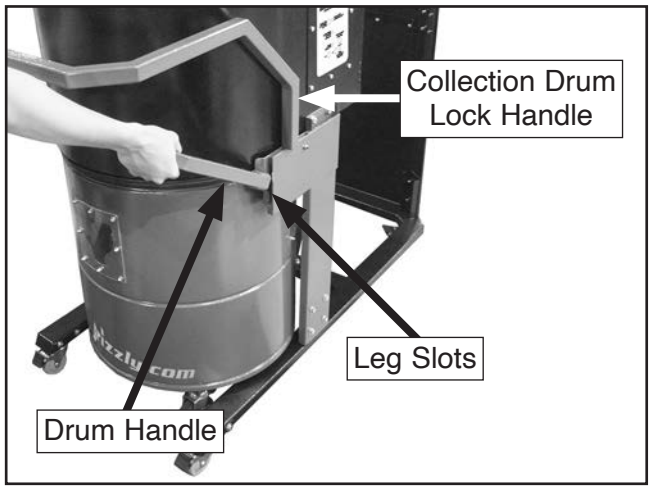


Figure 30. Aligning collection drum with front of machine.

16. Install vacuum hose on cyclone funnel port and vacuum hose bracket, then tighten pre-installed hose clamps on each end of vacuum hose to secure (see **Figure 31**).

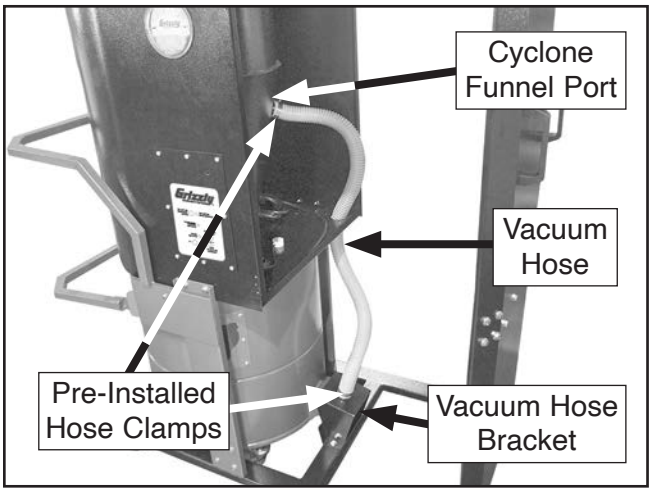


Figure 31. Vacuum hose installed.

17. Attach filter brush assembly to motor spindle using (1) ¼"-20 x 1¼" hex bolt, (2) ¼" flat washers, and (1) ¼"-20 wing nut, as shown in **Figure 32**.

Note: *These fasteners are pre-installed on filter brush assembly. Remove fasteners before starting assembly.*

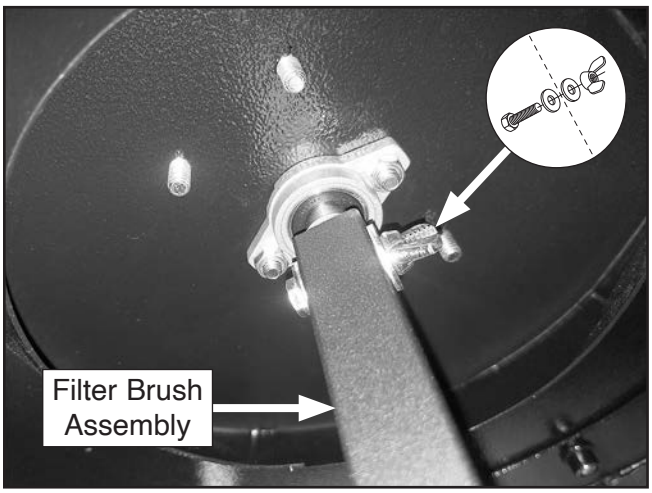


Figure 32. Filter brush assembly attached to motor spindle.

18. Thread (3) ⅜"-16 x 2" knob bolts halfway into impeller housing (see **Figure 33**).

19. With help from an assistant, lift canister filter assembly around filter brush assembly and twist filter counterclockwise until hooks on filter assembly nest with knob bolts (see **Figure 33**).

20. Fully tighten knob bolts from **Step 18** (see **Figure 33**).

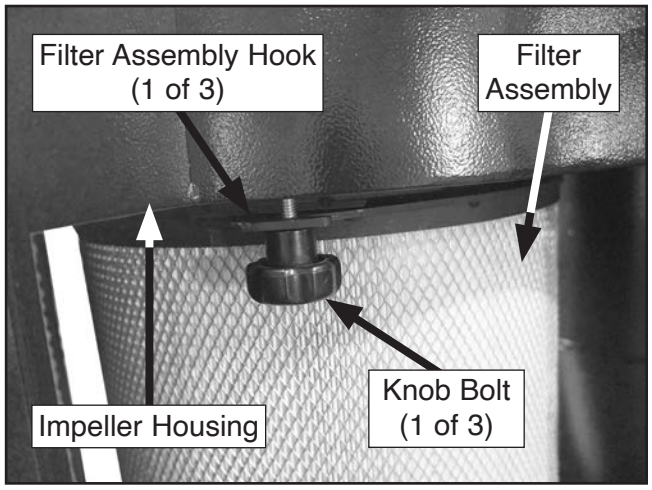


Figure 33. Canister filter assembly attached to machine body.

21. Attach filter brush base to filter brush assembly with (1) ¼"-20 x 1¼" hex bolt, (2) ¼" flat washers, and (1) ¼"-20 wing nut (see **Figure 34**).

22. Secure filter brush base to canister filter assembly with (2) ¼"-20 x ¾" knob bolts (see **Figure 34**).

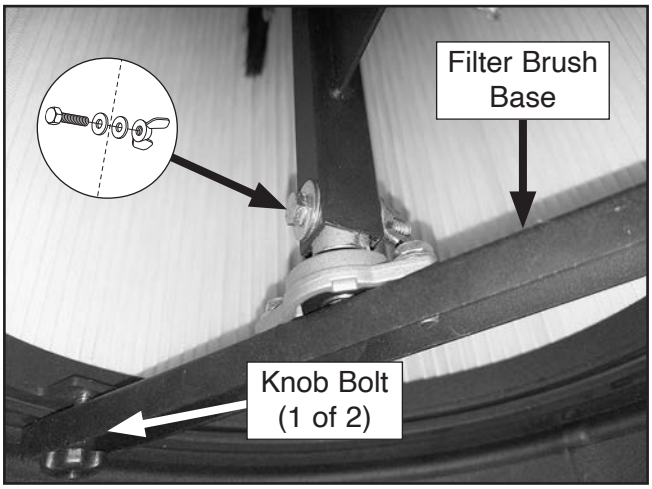


Figure 34. Filter brush base attached to filter brush assembly and canister filter assembly.

23. Place filter bag around bottom of canister filter assembly and secure with bag clamp (see **Figure 35**).

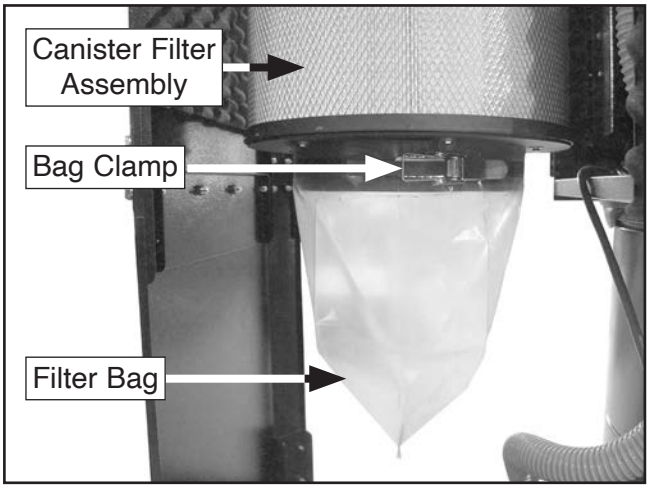


Figure 35. Filter bag attached to canister filter.

24. Attach right maintenance door to right side of machine using (6) 3/16"-24 x 1/2" Phillips head screws and (6) 3/16"-24 hex nuts, as shown in **Figure 36**.

Note: *Hinges are pre-installed on maintenance doors.*

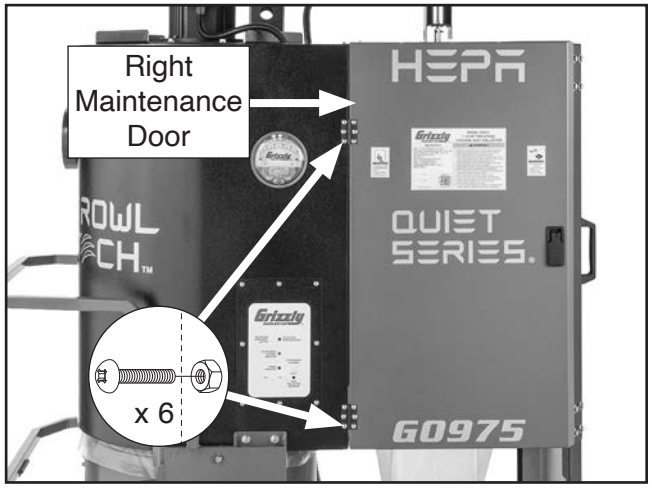


Figure 36. Right maintenance door attached to machine body.

25. Close maintenance door with compression latch to verify correct installation.

26. Repeat **Steps 24–25** for left maintenance door.

27. Attach inlet adapter to machine body using (1) #10 x 1/2" tap screw, as shown in **Figure 37**.

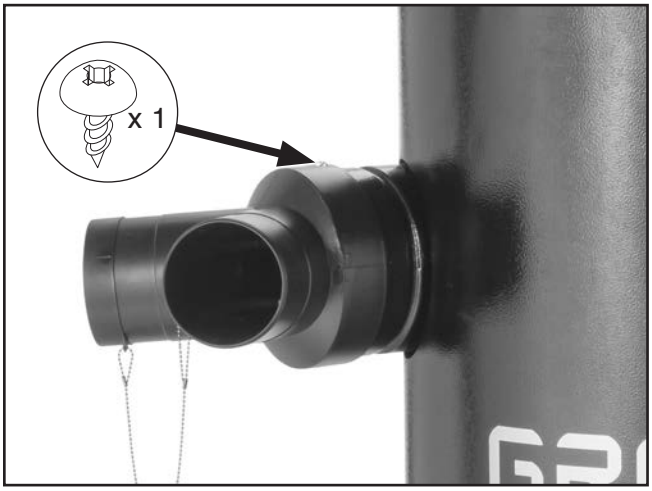


Figure 37. Inlet adapter attached to dust port (G0975 shown).

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 main motor powers up and runs correctly, 2) the filter brush motor powers up and runs correctly, and 3) the remote control works correctly.

⚠WARNING

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

⚠WARNING

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

To test run machine:

1. Clear all setup tools away from machine.

2. Lock casters so machine will not move during test.

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

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

4. Connect machine to power supply.

5. Standing away from intake port, press ON button (see **Figure 38**) to turn main motor ***ON***.

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

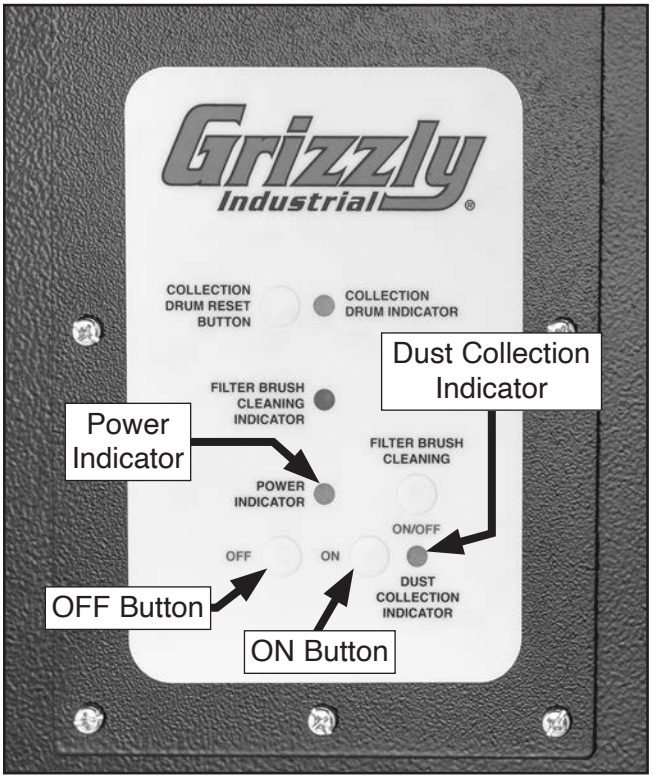


Figure 38. Location of ON and OFF Buttons and dust collection and power indicators.

6. Press OFF button to turn main motor ***OFF***.

   Note: *After main motor is turned **OFF**, filter brush cleaning motor will automatically run for 8 seconds. Allow cleaning cycle to finish before proceeding to next step.*

7. Press filter brush cleaning ON/OFF button to turn filter brush motor ***ON*** (see **Figure 39**).

   Filter brush cleaning indicator should illuminate, and filter brush should run smoothly as brushes turn inside filter. Filter brush motor automatically shuts off after 8 seconds.

8. Press filter brush cleaning ON/OFF button again to turn filter brush motor ***ON,*** then within 8 seconds, press ON/OFF button again. Filter motor should turn ***OFF***.

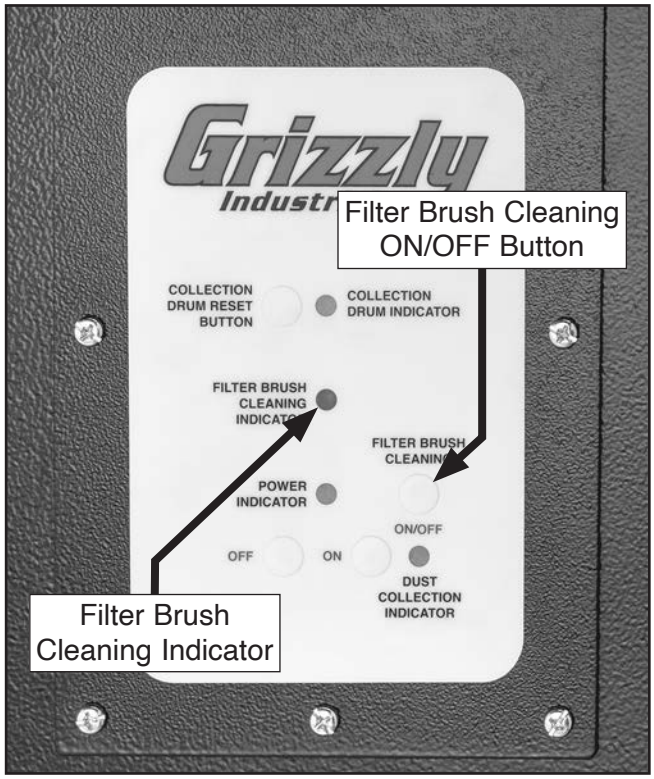


Figure 39. Location of filter brush ON/OFF button and filter brush cleaning indicators.

9. Press A button to turn main motor ***ON*** (see **Figure 40**). Motor should run smoothly with little or no vibration or rubbing noises.

10. Press B button to turn main motor ***OFF*** (see **Figure 40**).

    Note: *After main motor is turned **OFF**, filter brush cleaning motor will automatically run for 8 seconds. Allow cleaning cycle to finish before proceeding to next step.*

    — If machine *does not* start or stop, press OFF button to turn machine ***OFF***. Refer to **Pairing Remote Control** on **Page 41** and ensure remote control is paired.

11. Press C button to turn filter brush motor ***ON*** (see **Figure 40**).

    Filter brush cleaning indicator should illuminate, and filter brush should run smoothly as brushes turn inside filter. Filter brush motor automatically shuts off after 8 seconds.

12. Press C button again to turn filter brush motor ***ON,*** then within 8 seconds, press ON/OFF button again. Filter brush motor should turn ***OFF***.

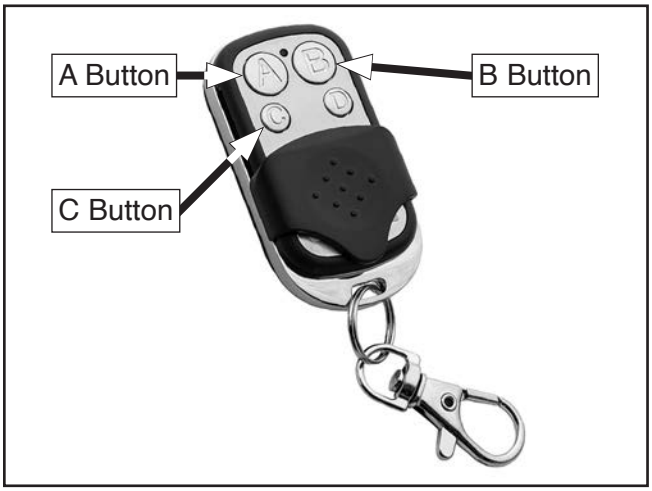


Figure 40. Location of remote control buttons.

Congratulations! Test Run is complete.

SECTION 4: DESIGNING THE SYSTEM

General

⚠CAUTION

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

⚠CAUTION

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

The Model G0975/G0976/G0977 works quite well as a point-of-use dust collector, or for collecting dust from up to two machines (Model G0975 and G0976) or up to three machines (Model G0977) simultaneously. The locking swivel casters make it easy to move around the shop near the machine being used.

Tips for Optimum Performance

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

Duct Material

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

Plastic duct is also a popular material for home shops. However, be aware that there is a fire or explosion hazard if plastic duct material is not properly grounded to prevent static electrical buildup (refer to **System Grounding** at the end of this section). Another problem with using plastic duct is that it is less efficient per foot than metal.

⚠CAUTION

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

Plastic Duct

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

Figure 41. Examples of plastic ducting components.

Metal Duct

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

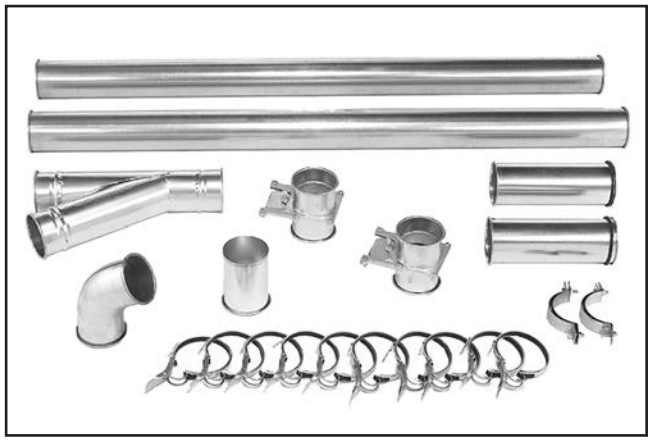


Figure 42. Examples of metal pipe and components.

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

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

Flexible Duct

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

The superior choice here is metal flex hose that is designed to be flexible, yet be as smooth as possible inside to reduce static pressure loss.

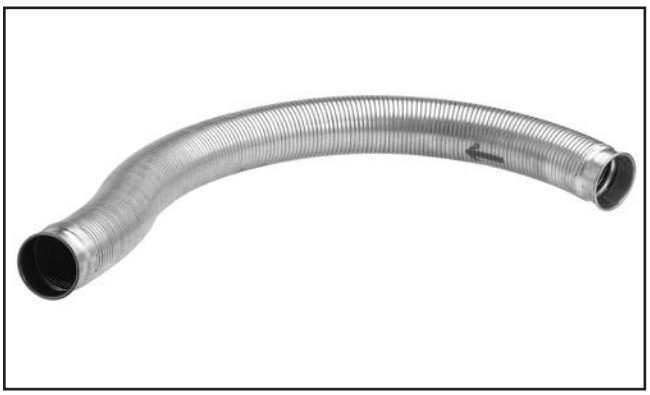


Figure 43. Example of flexible metal duct.

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

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

System Design

Decide Who Will Design

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

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

Sketch Your Shop Layout

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

Before you get out your pencil and paper, we recommend you visit our FREE *Workshop Planner,* at **http://www.grizzly.com/workshopplanner**.

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

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

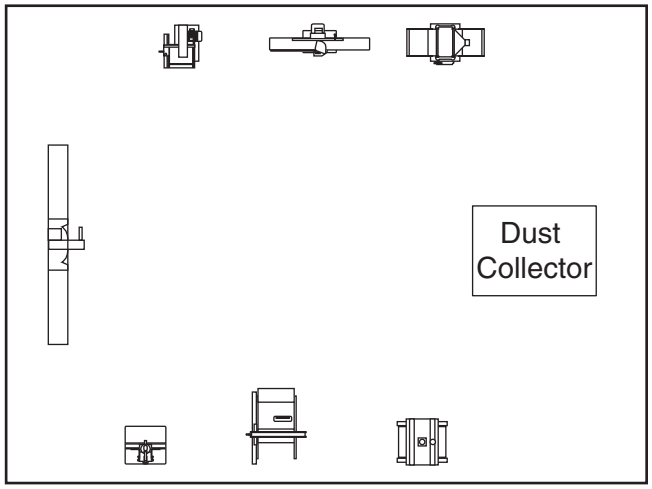


Figure 44. Basic sketch of shop layout.

Sketch a Basic Duct Layout

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

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

2. Ideally, you should design the duct system to have the shortest possible main line and secondary branch ducts. See the figures below for ideas of efficient versus inefficient duct layouts.

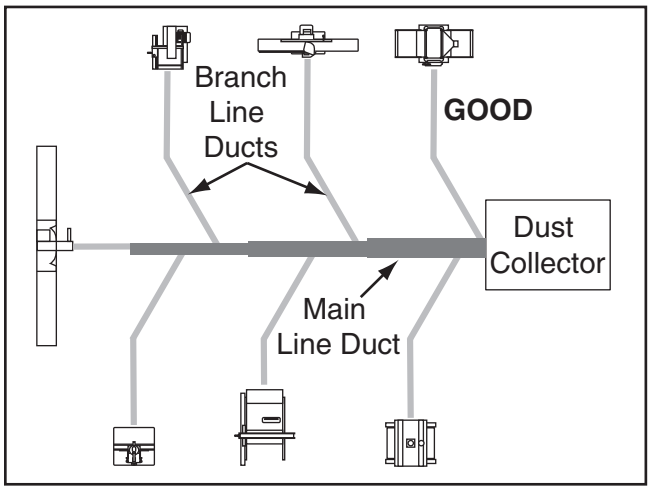


Figure 45. Efficient duct layout.

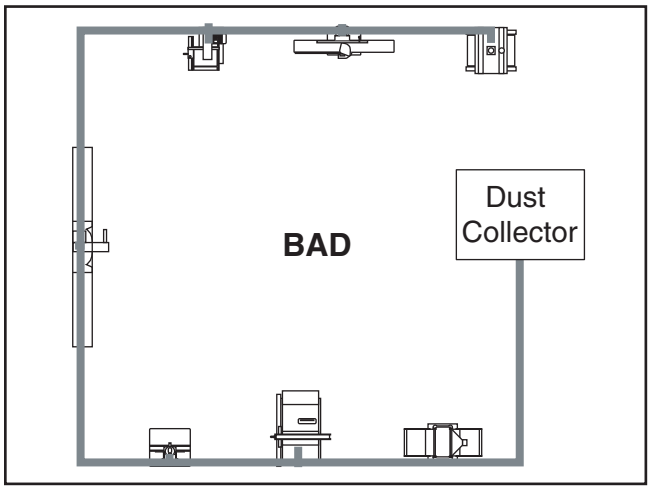


Figure 46. Inefficient duct layout.

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

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

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

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

Determine Required CFMs

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

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

Machine Dust Port Size	Approximate Required CFM
2"	100
2.5"	150
3"	250
4"	400
5"	600
6"	850
7"	1200
8"	1600
9"	2000
10"	2500

Figure 47. Approximate required airflow for machines, based on dust port size.

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

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

Figure 48. Dust port size and quantity per average machine.

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

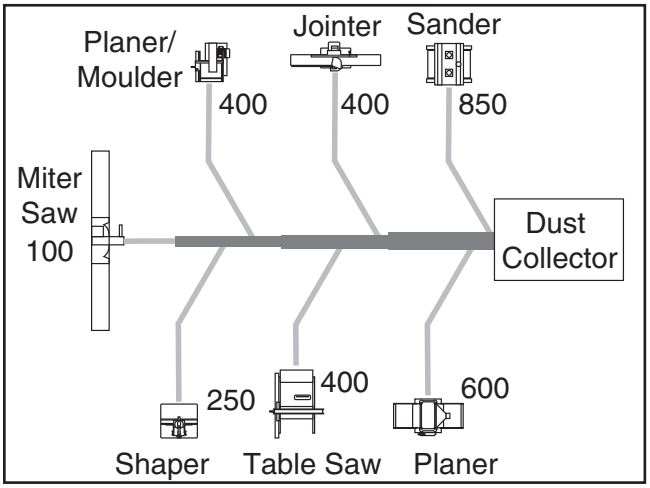


Figure 49. CFM requirements labeled for each machine.

Determining Main Line Duct Size

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

For small/medium sized shops, using the inlet size of the dust collector as the main line duct size will usually keep the air velocity above 3500 FPM and, depending on your system, will allow you to keep multiple branches open at one time.

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

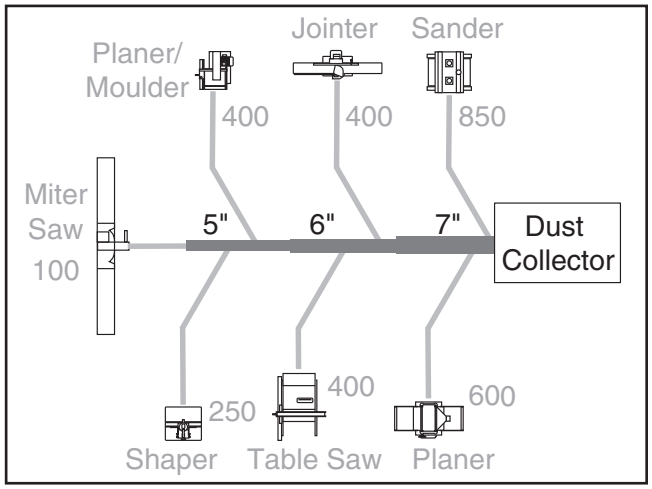


Figure 50. Main line size labeled on sketch.

Determining Branch Line Duct Size

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

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

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

Write your determined branch line sizes on your drawing, as shown in the following figure.

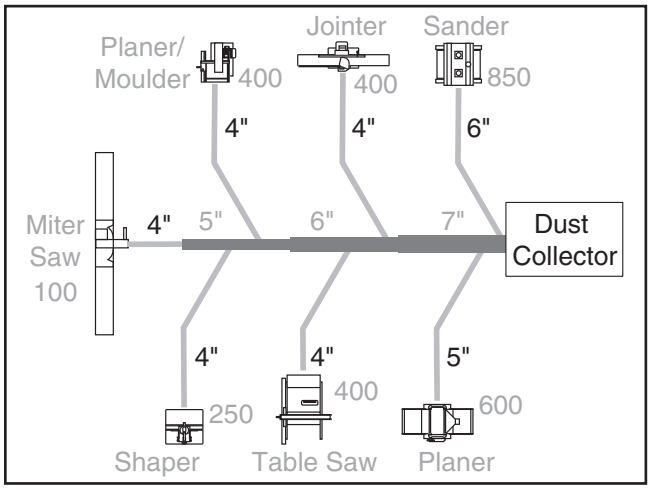


Figure 51. Branch line duct sizes labeled.

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

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

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

Figure 52. Sizing chart for multiple machines on the same branch line.

Planning Drop Downs

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

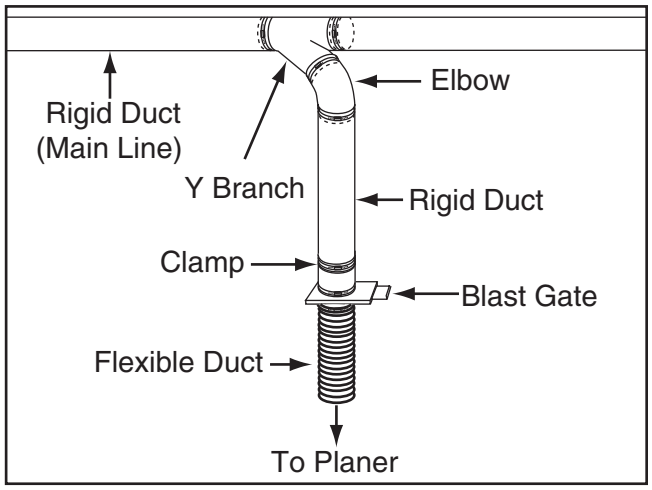


Figure 53. Drop down setup.

Calculating Duct Resistance

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

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

The purpose of calculating the resistance is to determine if it is low enough from the machine to the dust collector to meet the given CFM requirement for the machine. Use the following tables to calculate the resistance of duct work.

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

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

Figure 54. Static pressure loss charts.

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

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

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

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

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

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

Figure 55. Additional factors affecting static pressure.

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

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

Main Line
6" Rigid Duct (0.037) at 20' 0.740

Branch Line
4" Rigid Duct (0.075) at 10' 0.750
4" Flexible Duct (0.28) at 5' 1.400

Elbows/Branches
6" 45˚ Y-Branch 0.329
4" 45˚ Elbow 0.225

Additional Factors
Seasoned Filter 1.000

Total Static Pressure Loss 4.444

Figure 56. Totaling static pressure numbers.

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

5. Compare the total static pressure loss for that line to the closest CFM given in **Figure 57** for your dust collector.

Example: A typical **Data Sheet Performance Curve** is illustrated in **Figure 57**. Find 4.4 on the Static Pressure axis (the amount of total static pressure loss calculated in **Figure 57**), then refer to the closest value on the CFM axis—approximately 1120 CFM.

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

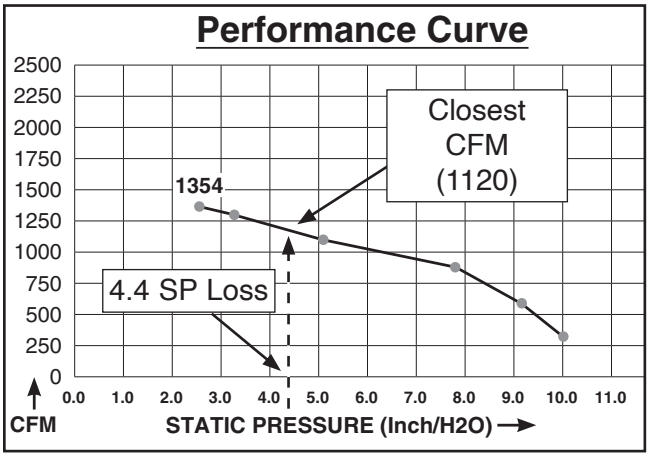
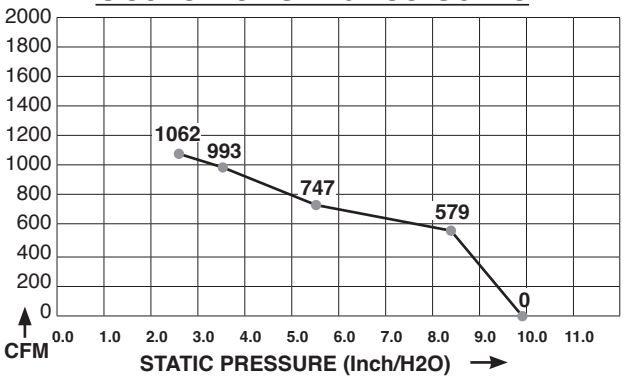


Figure 57. Example CFM for static pressure loss of line connected to a dust collector & router.

— If the CFM for your static pressure loss is above the requirement of the machine connected to the end of that branch line, then dust collection will most likely be successful. Congratulations! You've just designed your own dust system. Refer to the **Accessories** section on **Page 42** to start buying the components necessary to make your system a reality.

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

G0975 Performance Curve



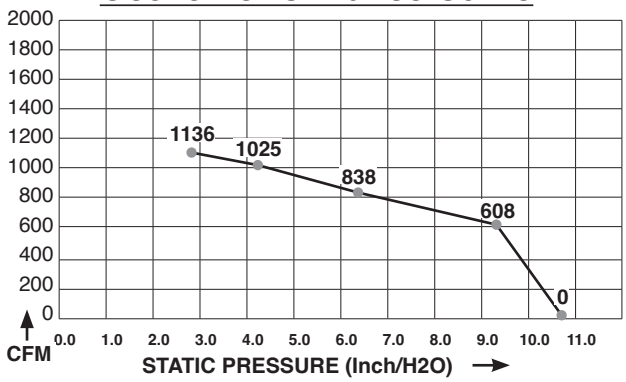
1.5 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	**Max SP**	**HP**	**Volts**	**Inlet**	**Impeller**
1062	9.8	1½ HP	120V	6"	13½"

Restrictor Plate (Inch)	6"	5"	4"	3"	0"
Static Pressure (Inch/H2O)	2.65	3.50	5.52	8.21	9.8
CFM	1062	993	747	579	0

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

Figure 58. G0975 performance curve table and data.

G0976 Performance Curve



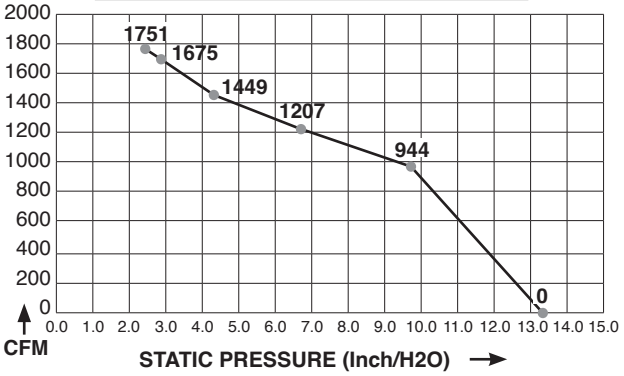
1.5 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	**Max SP**	**HP**	**Volts**	**Inlet**	**Impeller**
1136	10.7	2 HP	220V	6"	12½"

Restrictor Plate (Inch)	6"	5"	4"	3"	0"
Static Pressure (Inch/H2O)	2.85	4.23	6.36	9.21	10.7
CFM	1136	1025	838	608	0

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

Figure 59. G0976 performance curve table and data.

G0977 Performance Curve



3 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	**Max SP**	**HP**	**Volts**	**Inlet**	**Impeller**
1751	13.3	3 HP	220V	8"	15½"

Restrictor Plate (Inch)	8"	7"	6"	5"	4"	0"
Static Pressure (Inch/H2O)	2.50	2.90	4.30	6.85	9.80	13.30
CFM	1751	1675	1449	1207	944	0

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

Figure 60. G0977 performance curve table and data.

Example Materials List

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

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

Description	Model	Quantity
6" Rigid Duct at 20'	G7364	4
4" Rigid Duct at 10'	G6162	2
4" Flex Hose at 5'	H7215	6
6" 45° Y-Branch	G7353	6
4" 45° Elbow	G6167	6

Figure 61. Example materials list.

System Grounding

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

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

If a grounding medium is not available to prevent static electrical buildup, the electrical charge will arc to the nearest grounded source. This electrical discharge may cause an explosion and subsequent fire inside the system.

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

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

⚠CAUTION

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

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

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

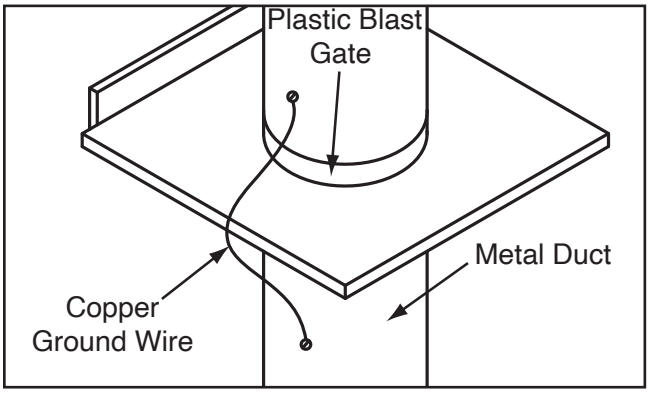


Figure 62. Ground jumper wire when using plastic blast gates and metal duct.

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

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

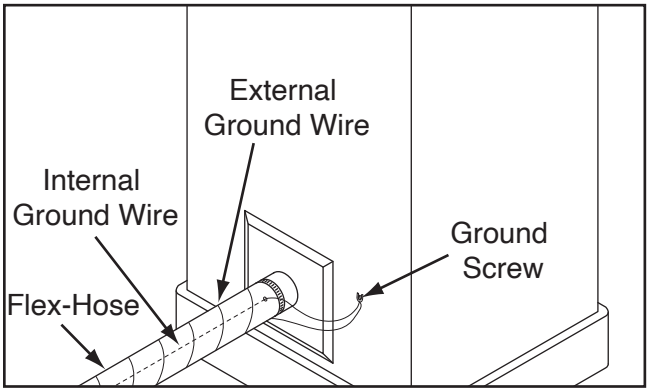


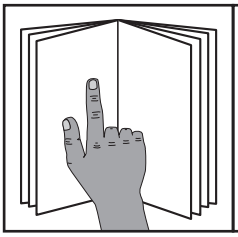
Figure 63. Flex-hose grounded to machine.

SECTION 5: OPERATIONS

Operation Overview

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

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

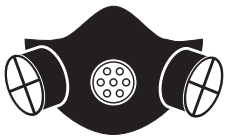


⚠WARNING

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

⚠WARNING

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



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.

General Operation

This cyclone dust collector creates a vortex of incoming air that extracts heavy wood chips and large dust particles, and then drops them into the steel drum below lined with a plastic bag.

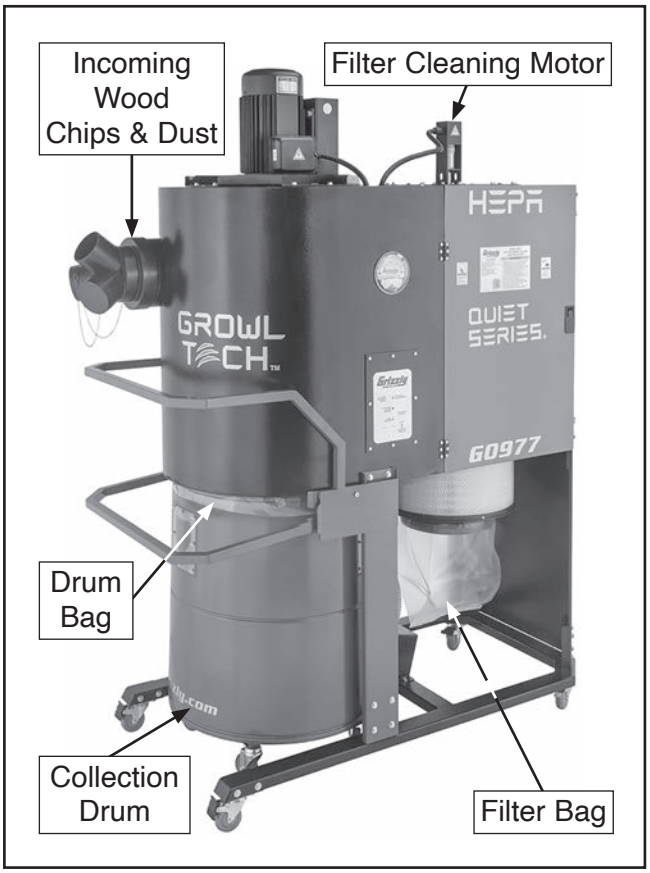


Figure 64. Dust Collector Operation

The remaining fine dust travels past the impeller and is then caught by a canister filter and deposited in the plastic collection bag below. The HEPA certified filter catches 99.97% of particles to 0.3 micron in size, and is pleated to provide maximum surface area for efficient airflow.

To maintain CFM during heavy dust collection operations, turn the filter cleaning motor on periodically to brush caked on dust into the plastic collection bag.

Always lock the swivel casters before operation.

Pairing Remote Control

The included remote control runs on (1) 12V A27 battery and has a range of approximately 50 feet. The receiver and remote control must be paired when the batteries are changed, or if the remote control begins to function erratically.

⚠WARNING

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

To pair remote control:

1. Remove control panel cover and turn over to expose circuit board.

2. Press and hold SAVE CODE button on circuit board (see **Figure 65**) until it beeps.

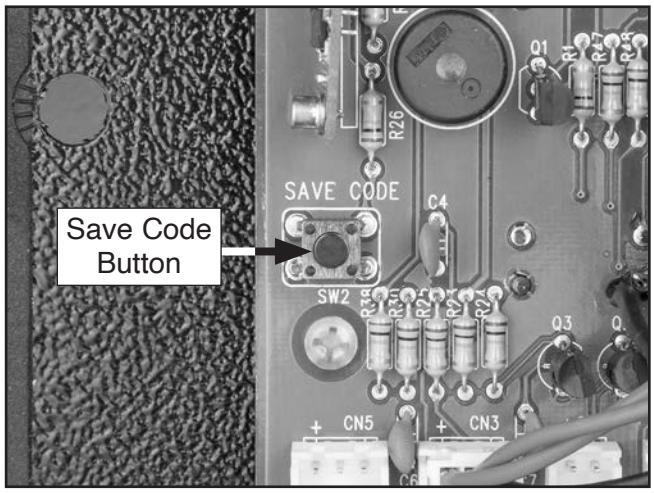


Figure 65. Location of SAVE CODE button on control panel circuit board.

3. Press and hold D button on remote control (see **Figure 66**). Pairing is complete after the second audible beep.

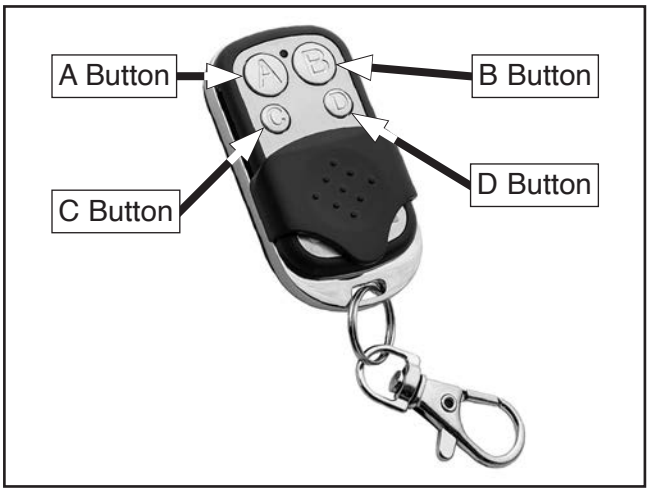


Figure 66. Location of remote control buttons.

4. Test connection by pressing A button to turn main motor ***ON***, then press B button to turn motor ***OFF***.

   Note: *After main motor is turned **OFF**, filter brush cleaning motor will automatically run for 8 seconds. Allow cleaning cycle to finish before proceeding to next step.*

5. Press C button to turn filter brush motor ***ON*** (see **Figure 66**)

   Filter brush cleaning indicator should illuminate, and filter brush should run smoothly as brushes turn inside filter. Filter brush motor automatically shuts off after 8 seconds.

6. Press C button again to turn filter brush motor ***ON,*** then within 8 seconds, press ON/OFF button again. Filter motor should turn ***OFF***.

7. After verifying remote control connection, install control panel.

SECTION 6: ACCESSORIES

⚠WARNING

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

NOTICE

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

T34157—Pleated Cartridge (G0975)
T34158—Pleated Cartridge (G0976)
T34159—Pleated Cartridge (G0977)
These pleated cartridge filters are the internal component in the cartridge filter assembly and must be used in tandem with a HEPA filter. The filters capture 95% of 0.2-2 micron particles.

T34160—HEPA Cartridge (G0975)
T34161—HEPA Cartridge (G0976)
T34162—HEPA Cartridge (G0977)
These MERV-17 HEPA cartridge filters are the external component in the cartridge filter assembly and must be used in tandem with a pleated cartridge filter. The filters capture 99.99% of 0.3 micron particles.

H7217—6" x 5' Rigid Flex Hose
H7218—7" x 5' Rigid Flex Hose
H7219—8" x 5' Rigid Flex Hose
These rigid flex hoses with rolled collars provide just enough flexibility to make difficult connections while still keeping the inside wall smooth.

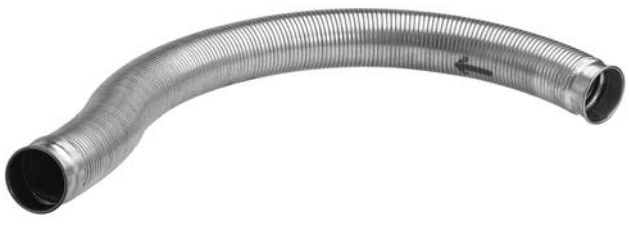


Figure 67. Rigid flex hose.

W1050—Dust Collection Basics Book
This incisive book skillfully guides the woodworker through all the steps necessary in the design and construction of an efficient central dust-collection system and tells you what you need to know for easy installation. 64 pages.

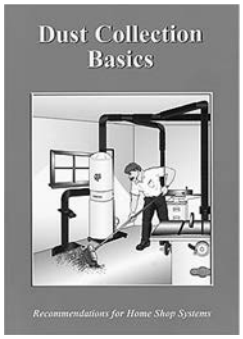


Figure 68. W1050 Dust Collection Basics Book.

G6177—4" Metal Blast Gate
G7340—5" Metal Blast Gate
G7358—6" Metal Blast Gate
H5234—7" Metal Blast Gate
H5249—8" Metal Blast Gate
Control air flow and resistance between machines. These industrial blast gates can take the abuse of thousands of open and close cycles. Made specifically for production shops. These metal industrial dust collection fittings are simply the best you can find.

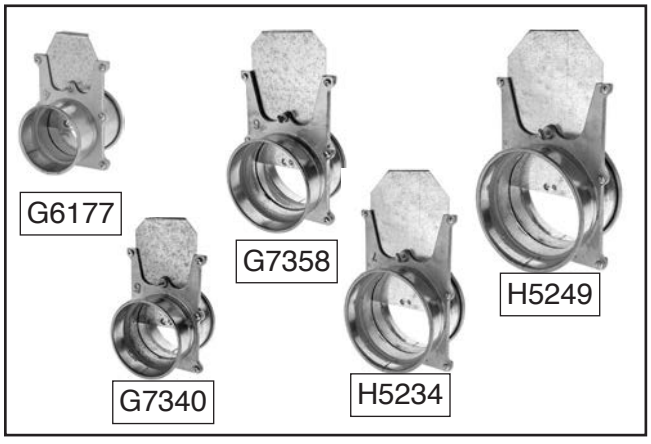


Figure 69. Metal blast gate assortment.

W1039—Universal Adapter
This adapter provides a multitude of reducing options. Simply cut off unneeded steps. Outside diameter sizes include 1", 2", 2.5", 3", 4", 5", and 6". Wall thickness is ⅛".

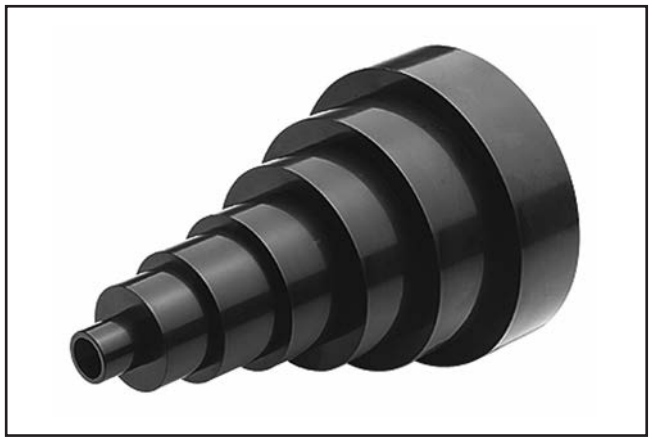


Figure 70. W1039 Universal Adapter.

D4206—Clear Flexible Hose 4" x 10'
D4256—45° Elbow 4"
W1317—Wire Hose Clamp 4"
W1007—Plastic Blast Gate 4"
W1017—90° Elbow 4"
W1053—Anti-Static Grounding Kit

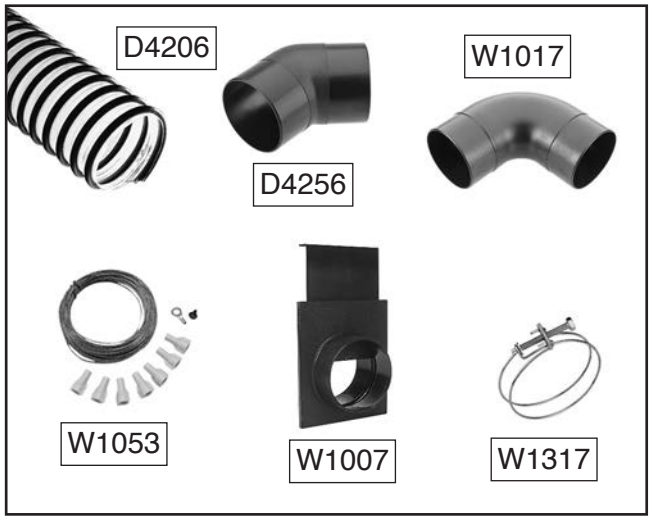


Figure 71. 4" Dust-collection accessories.

H7429—8" Industrial Dust Collection Machine Adapter
H5238—8" Industrial Dust Collection Pipe Clamp
H5239—8" Industrial Dust Collection Adjustable Sleeve
H5250—8" Industrial Dust Collection Pipe Hanger
T26510—8" Industrial Dust Collection Joist Hanger

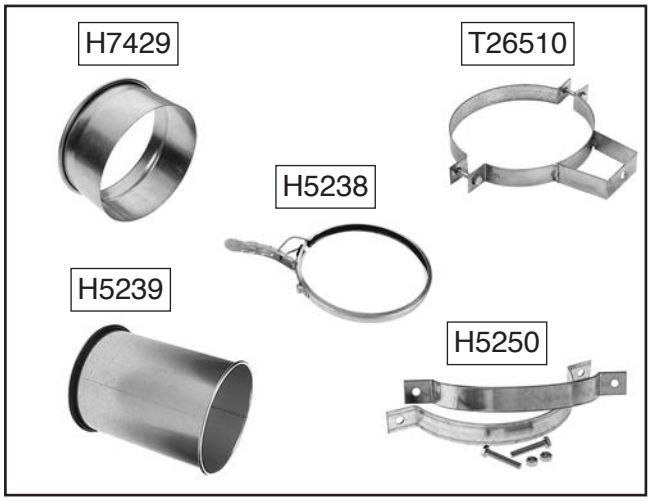
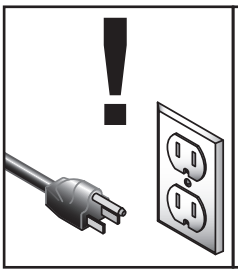


Figure 72. 8" Dust-collection accessories.

T24268—Filter Bag (G0975, G0976, & G0977)
H8469—Collection Bag (G0975 & G0976)
T30326—Collection Bag (G0977)

Figure 73. Replacement collection bags.

SECTION 7: MAINTENANCE



⚠WARNING

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

Schedule

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

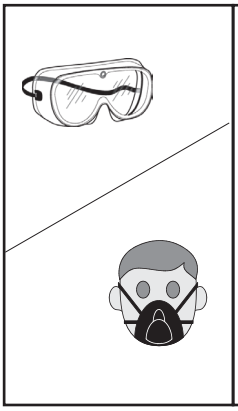
Ongoing

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

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

Monthly Check

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



⚠CAUTION

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

Cleaning Canister Filter

This dust collector uses an automatic filter brush to remove dust buildup and debris from the filter pleats. The system will turn ***ON*** for approximately 8 seconds after the machine is turned ***OFF*** to clean the canister filter and knock dust cake into the filter bag.

If the operating pressure on the pressure gauge exceeds 6 inches of water (G0975/G0976) or 9 inches of water (G0977), then remove the canister filter and gently knock dust from the pleats (refer to **Removing/Replacing Canister Filter** on **Page 46**). If the operating pressure exceeds 8 inches of water (G0975/G0976) or 11 inches of water (G0977) and cleaning does not improve performance, then replace the filter.

IMPORTANT: DO NOT use water or high pressure to clean canister filter. Doing so will damage the filter and reduce filtration.

Dispose of the filter collection bag when dust fills it about ½ full (see **Removing/Replacing Filter Bag** on **Page 45**).

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

Removing/Replacing Collection Drum Bag

Dispose of the collection drum bag when dust fills it ¾ full. Replace the bag if it develops a leak or becomes damaged.

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

Items Needed	Qty
Drum Bag H8469 (Models G0975, G0976)	1
Drum Bag T30326 (Model G0977)	1

To remove/replace collection drum bag:

1. DISCONNECT MACHINE FROM POWER!

2. Raise lock handle, then lift collection drum handle to lower collection drum onto casters (see **Figure 74**).

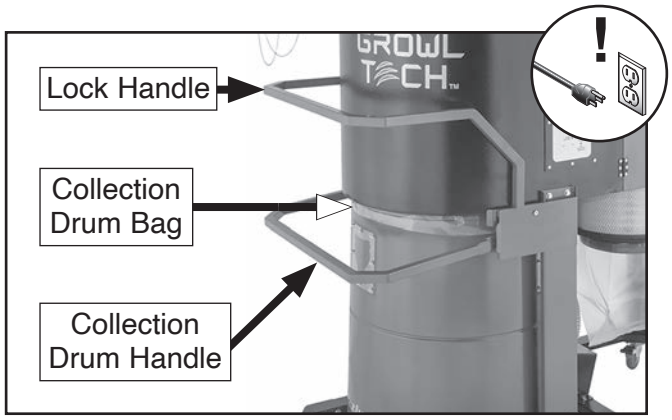


Figure 74. Collection drum bag components.

3. Roll drum clear of machine, then lift collection bag out of drum, firmly tie closed, and dispose of contents.

4. Place new drum bag inside collection drum, and fold excess bag length over top edge of drum.

5. Roll collection drum to front of machine and lift collection drum handle, then push drum into slots in legs.

6. Lower drum handle to engage lock handle.

7. Connect machine to power and press collection drum reset button.

Removing/Replacing Filter Bag

Remove and replace the filter bag when it is about ½ full.

Item Needed	Qty
Filter Bag T24268	1

To remove/replace filter bag:

1. DISCONNECT MACHINE FROM POWER!

2. Open maintenance door.

3. Release bag clamp from around bottom of canister filter assembly (see **Figure 75**), and remove filter bag.

   IMPORTANT: To contain wood dust and minimize exposure risk, firmly tie filter bag closed.

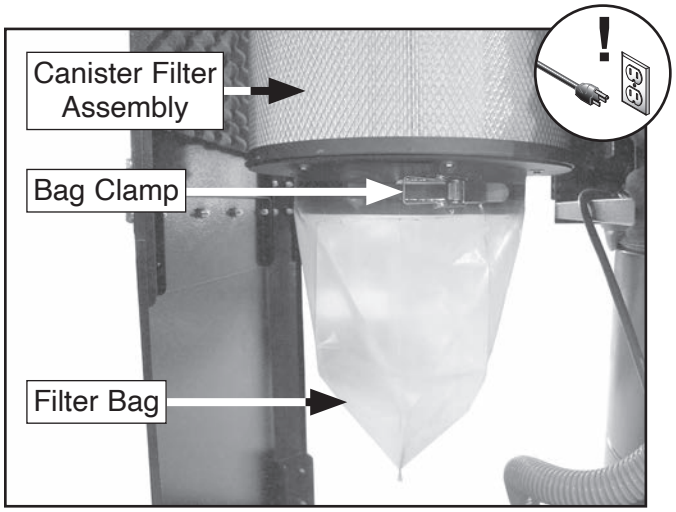


Figure 75. Filter bag attached to canister filter.

4. Place new filter bag around bottom of canister filter and secure with bag clamp.

Removing/Replacing Canister Filter Assembly

The canister filter assembly is comprised of the pleated cartridge filter (internal) and the HEPA filter (external). If the canister filter assembly is clogged or dirty and cleaning it does not improve dust-collection performance, one or both filters must be replaced.

Items Needed	Qty
An Assistant	1
Combination Wrench 7/16"	1
Pleated Cartridge Filter	1
HEPA Filter	1

Removing/Replacing Pleated Cartridge Filter

1. Press filter brush cleaning ON/OFF button to turn filter brush motor ***ON*** (see **Figure 76**).

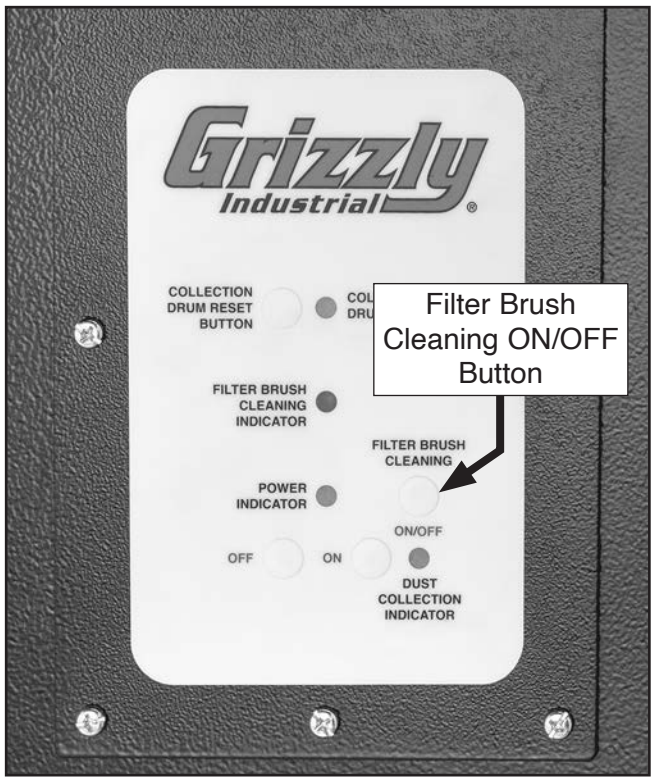


Figure 76. Location of filter brush cleaning ON/OFF button.

2. Allow filter brush cleaning motor to complete full 8 second cleaning cycle.

3. Repeat **Steps 1–2** one more time to remove as much dust as possible from filters.

4. DISCONNECT MACHINE FROM POWER!

5. Open both maintenance doors, then release bag clamp from around bottom of canister filter assembly (see **Figure 77**), and remove filter bag.

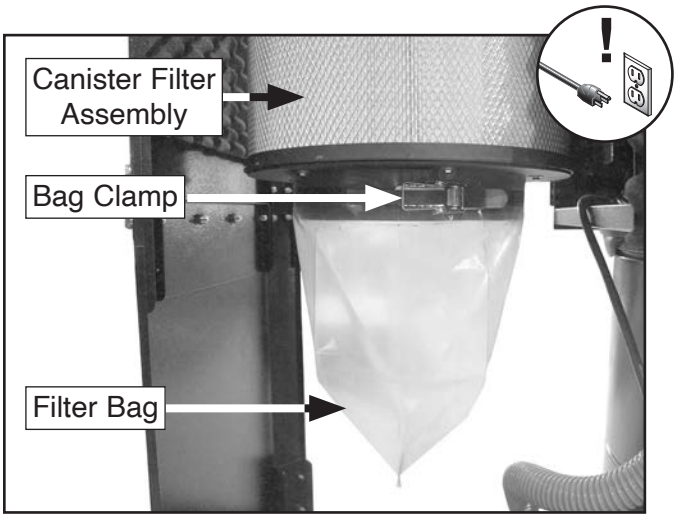


Figure 77. Location of filter bag and bag clamp.

6. Remove hex bolt, (2) flat washers, wing nut and (2) knob bolts, then remove filter brush base (see **Figure 78**).

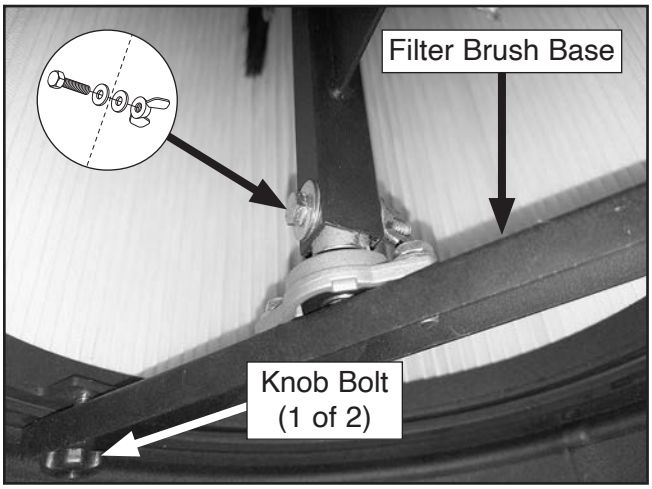


Figure 78. Location of filter brush base and fasteners.

7. Loosen (3) ⅜"-16 x 2" knob bolts that secure canister filter assembly to machine body, as shown in **Figure 79**.

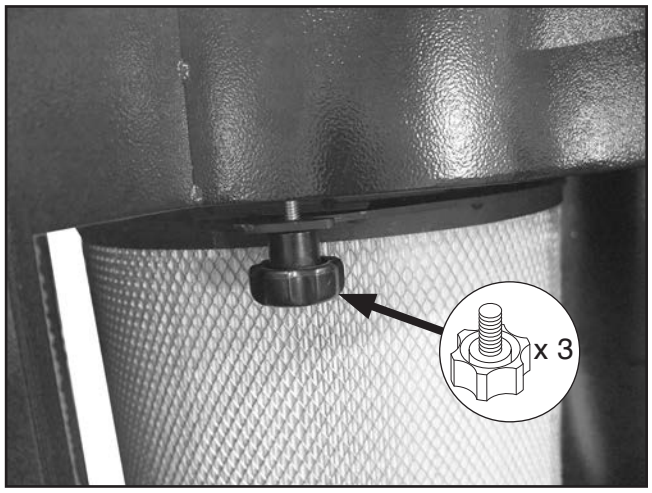


Figure 79. Location of canister filter knob bolts.

8. With help of assistant, twist filter clockwise, then carefully lower past filter brush assembly to remove.

9. Flip canister filter assembly so filter bag flange is facing up (see **Figure 80**), then remove (6) hex bolts, (6) flat washers, and filter bag flange.

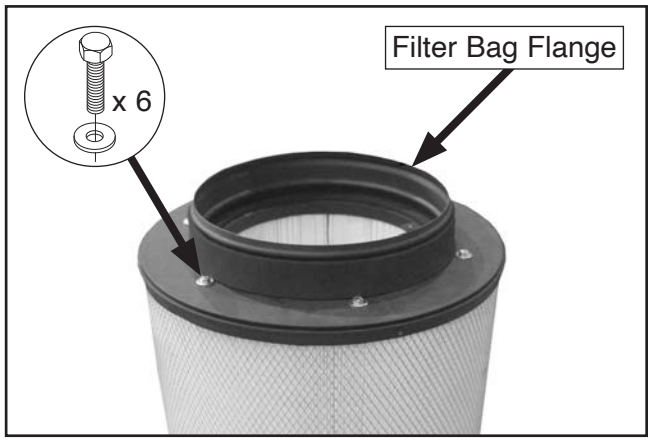


Figure 80. Location of filter bag flange.

10. Gently lift pleated cartridge filter from HEPA filter and clean or replace as needed.

11. Slide clean filter or replacement pleated cartridge filter into HEPA filter (see **Figure 81**), and install filter bag flange using fasteners removed in **Step 9**.

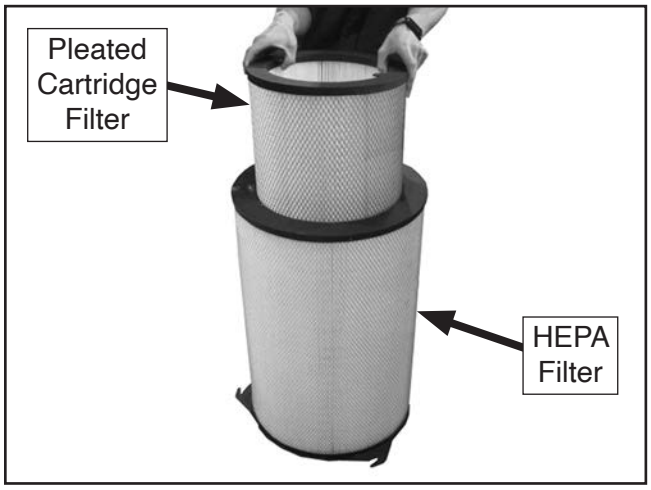


Figure 81. Replacing pleated cartridge filter.

IMPORTANT: When assembling any components with a gasket, tighten fasteners in an alternating star pattern (see **Figure 82**) to ensure an even seal and reduce risk of air leaks.

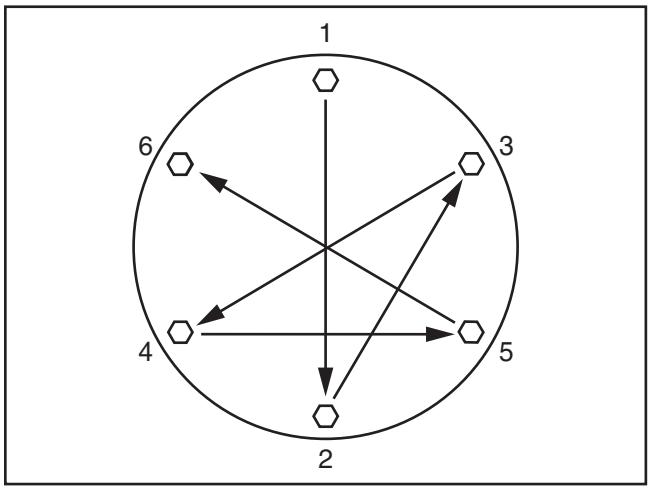


Figure 82. Alternating star pattern for tightening components assembled with a gasket.

12. Align top of canister filter assembly with bottom of filter brush assembly, then gently lift canister filter assembly into place.

13. Secure canister filter assembly to machine body using (3) knob bolts loosened in **Step 7**.

14. Attach filter brush base to filter brush assembly and canister filter assembly using fasteners removed in **Step 6** (see **Figure 83**).

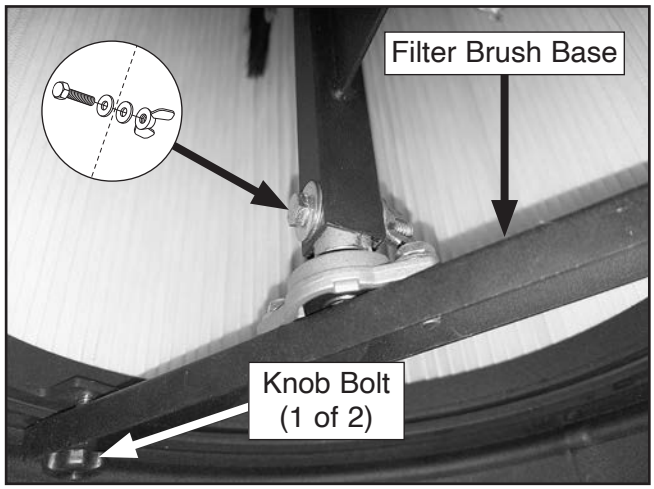


Figure 83. Filter brush base attached to filter brush assembly and canister filter assembly.

15. Place filter bag around bottom of canister filter assembly and secure with bag clamp (see **Figure 84**).

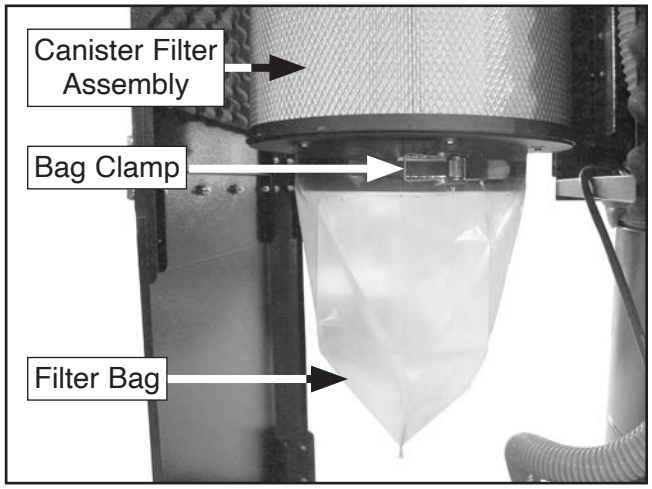


Figure 84. Filter bag attached to canister filter assembly.

16. Connect machine to power supply.

17. Turn machine ***ON*** and check pressure gauge to verify vacuum pressure is below 4 inches of water (G0975/G0976) or 7 inches of water (G0977).

    If pressure gauge still reads over 4 inches of water (G0975/G0976) or 7 inches of water (G0977), then HEPA filter may need replacement.

Removing/Replacing HEPA Filter

1. Perform **Steps 1–10** in **Removing/Replacing Pleated Cartridge Filter** beginning on **Page 46**.

2. Slide clean filter or replacement pleated cartridge filter into new HEPA filter, as shown in **Figure 85**.

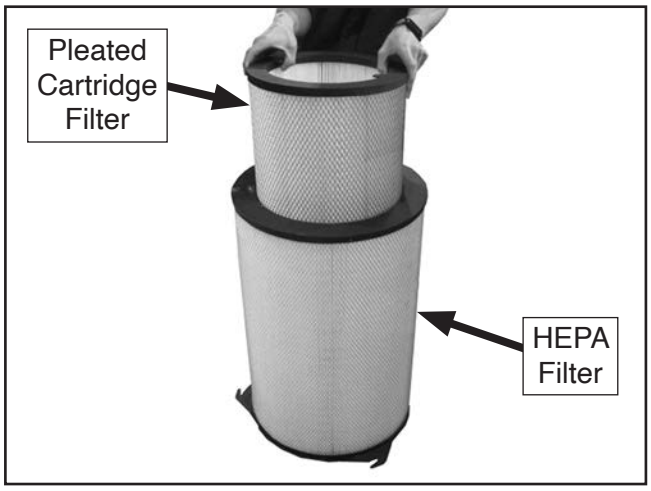


Figure 85. Replacing pleated cartridge filter.

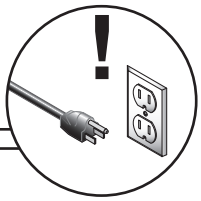
3. Attach filter bag flange to canister filter assembly using fasteners removed in **Step 9** of **Removing/Replacing Pleated Cartridge Filter** on **Page 47**.

4. Continue with **Steps 12–17** in **Removing/Replacing Pleated Cartridge Filter** beginning on **Page 47**.

SECTION 8: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	1. Collection drum sensor tripped. 2. Machine circuit breaker tripped or at fault. 3. Incorrect power supply voltage or circuit size. 4. Plug/receptacle at fault/wired incorrectly. 5. Remote control not working. 6. Remote receiver/circuit board at fault. 7. Power supply circuit breaker tripped or fuse blown. 8. Motor wires connected incorrectly. 9. Thermal overload relay has tripped/at fault (G0977 only). 10. Start capacitor at fault. 11. Centrifugal switch adjustment/contact points at fault. 12. Contactor not energized/at fault (G0977 only). 13. Wiring broken, disconnected, or corroded. 14. Circuit breaker switch at fault. 15. Circuit board at fault. 16. Inverter/control box at fault. 17. Motor or motor bearings at fault.	1. Empty collection drum, then press collection drum reset button. 2. Reset circuit breaker on switch. 3. Ensure correct power supply voltage and circuit size. 4. Test for good contacts; correct the wiring. 5. Replace battery; stay in signal range. 6. Replace circuit board. 7. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 8. Correct motor wiring connections (**Page 52**). 9. Reset. Adjust or replace if at fault. 10. Test/replace if at fault. 11. Adjust centrifugal switch/clean contact points. Replace either if at fault. 12. Test all legs for power; replace if necessary. 13. Fix broken wires or disconnected/corroded connections. 14. Replace circuit breaker switch. 15. Inspect/replace if at fault. 16. Inspect inverter/controller box; replace if at fault. 17. Replace motor.
Machine stalls or is underpowered.	1. Dust-collection ducting problem. 2. Filter bags at fault. 3. Canister filter clogged/at fault. 4. Motor wires connected incorrectly. 5. Dust collector too far from machine or undersized for dust-collection system. 6. Plug/receptacle at fault/wired incorrectly. 7. Motor overheated, tripping machine circuit breaker. 8. Run capacitor at fault. 9. Extension cord too long. 10. Contactor not energized/at fault (G0977 only). 11. Centrifugal switch adjustment/contact points at fault. 12. Motor or motor bearings at fault.	1. Clear blockages, seal leaks, use smooth-wall duct, eliminate bends, close other branches (**Page 33**). 2. Replace bag(s) (**Page 45**). 3. Replace filter (**Page 46**). 4. Correct motor wiring connections. 5. Move closer to machine/redesign ducting layout/ upgrade dust collector. 6. Test for good contacts/correct wiring. 7. Clean motor, let cool, and reduce workload. Reset breaker. 8. Test/repair/replace. 9. Move machine closer to power supply; use shorter extension cord. 10. Test all legs for power; repair/replace if at fault. 11. Adjust centrifugal switch/clean contact points. Replace either if at fault. 12. Replace motor.

Motor & Electrical (Cont.)

Machine has vibration or noisy operation.	1. Motor or component loose. 2. Mobile stand fasteners loose or feet not adjusted properly. 3. Motor mount loose/broken. 4. Motor fan rubbing on fan cover. 5. Centrifugal switch needs adjustment/at fault. 6. Motor bearings at fault.	1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Tighten machine to mobile stand or adjust feet to stabilize machine. 3. Tighten/replace. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Adjust/replace if at fault. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operation

Symptom	Possible Cause	Possible Solution
Loud, repetitious noise, or excessive vibration coming from dust collector (non-motor related).	1. Dust collector not on flat surface and wobbles/casters not locked. 2. Machine incorrectly mounted/sits unevenly. 3. Impeller damaged and unbalanced. 4. Impeller loose on the motor shaft.	1. Stabilize dust collector; lock casters. 2. Chock casters if mobile. 3. Inspect/replace. 4. Secure impeller; replace motor and impeller as a set if motor shaft and impeller hub are damaged.
Dust collector does not adequately collect dust or chips; poor performance.	1. Collection bag(s) full. 2. Dust collection drum full; seal installed incorrectly/damaged; lid loose; leak in drum. 3. Filter clogged/at fault. 4. Ducting blocked/restricted. 5. Dust collector too far away from point of suction; duct clamps not properly secured; too many sharp bends in ducting. 6. Wood wet/green and dust not flowing smoothly through ducting. 7. Ducting has one or more leaks, or too many open ports. 8. Not enough open branch lines at one time, causing velocity drop in main line. 9. Ducting and ports are incorrectly sized. 10. The machine dust-collection design inadequate. 11. Dust collector undersized. 12. Unused inlet adapter port(s) uncovered.	1. Empty collection bag(s). 2. Empty collection drum; check/re-install/replace seal; secure lid; seal/eliminate leak. 3. Turn on filter brush motor to clean filter; replace when cleaning no longer restores adequate airflow. 4. Remove ducting from dust collector inlet and unblock restriction. A plumbing snake may be necessary. 5. Relocate dust collector closer to point of suction; re-secure ducts; remove sharp bends (**Page 33**). 6. Only collect dust from wood with less than 20% moisture content. 7. Seal/eliminate all ducting leaks; close dust ports for lines not being used (**Page 33**). 8. Open 1 or 2 more blast gates to different branch lines to increase main line velocity. 9. Install correctly sized ducts and fittings (**Page 33**). 10. Use dust-collection hood on stand. 11. Upgrade to larger dust collector. 12. Cover unused inlet adapter port(s).
Musty odor detected during operation.	1. Filter caked with dust containing excessive moisture, causing mold growth on filter.	1. Replace HEPA filter (**Page 48**).
Cleaning filter does not improve dust collection performance.	1. Pleated cartridge filter clogged and at end of life. 2. HEPA filter clogged and at end of life.	1. Replace pleated cartridge filter (**Page 46**). 2. Replace HEPA filter (**Page 48**).
Dust collector blows sawdust into the air.	1. Duct clamp(s) or dust collection bag(s) are not properly clamped and secured; ducting loose/damaged. 2. Cylinder or funnel seals are loose or damaged. 3. Filter bag has hole(s).	1. Secure ducts and dust collection bag, making sure duct and bag clamp are tight; tighten/replace ducting. 2. Retighten all mounting and sealing points; replace damaged seals/gaskets. 3. Replace filter bag (**Page 45**).

Operation (Cont.)

Remote control does not operate dust collector.	1. Machine is disconnected from power. 2. Remote control battery is weak or dead. 3. A wall or barrier disrupts the radio frequency, or controller is too far away. 4. Remote control not paired with receiver.	1. Verify machine is connected to power source. 2. Replace battery. 3. Move machine away from barrier; use remote within 75' of machine. 4. Program receiver to accept remote control (**Page 41**).

SECTION 9: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

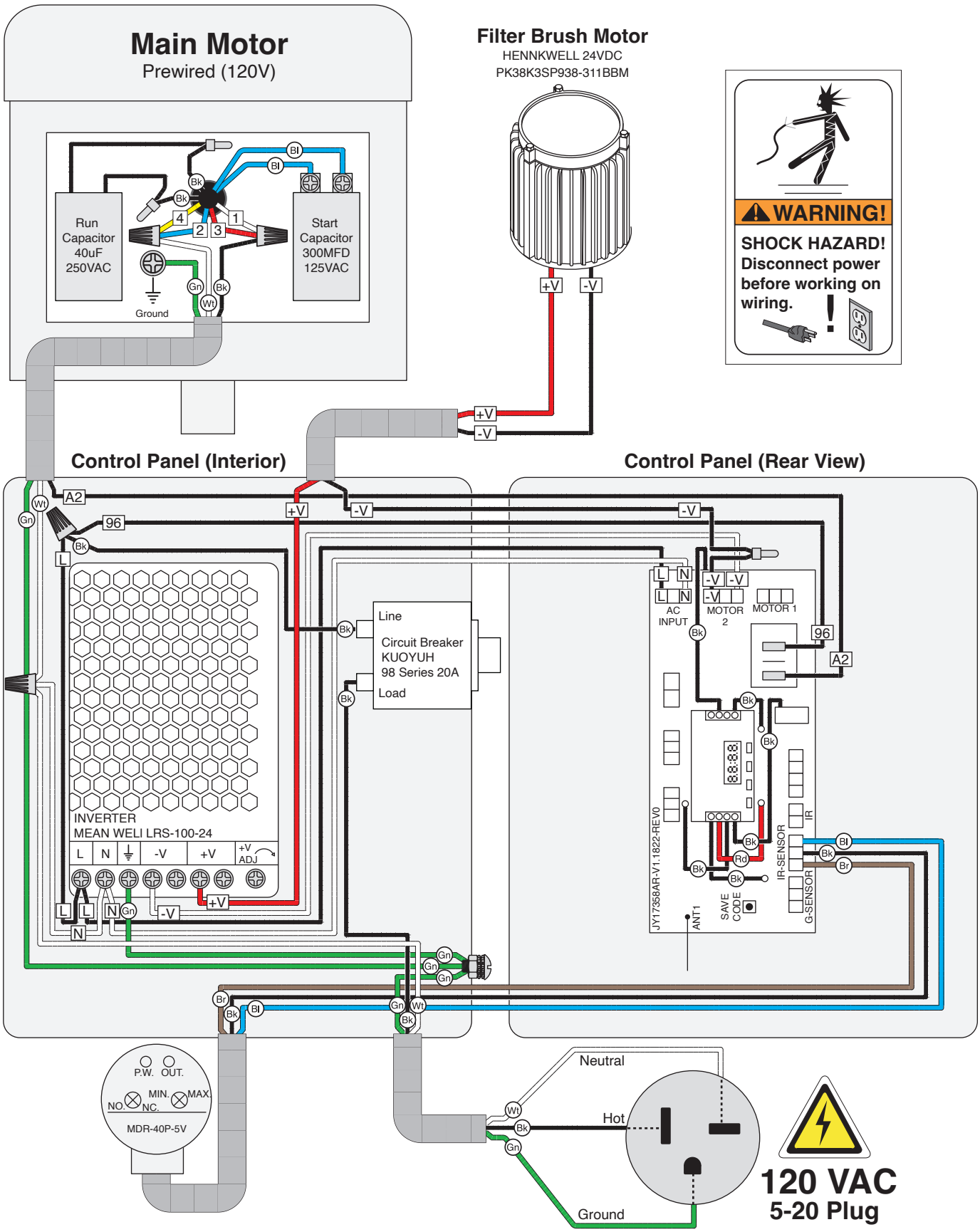
NOTICE

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

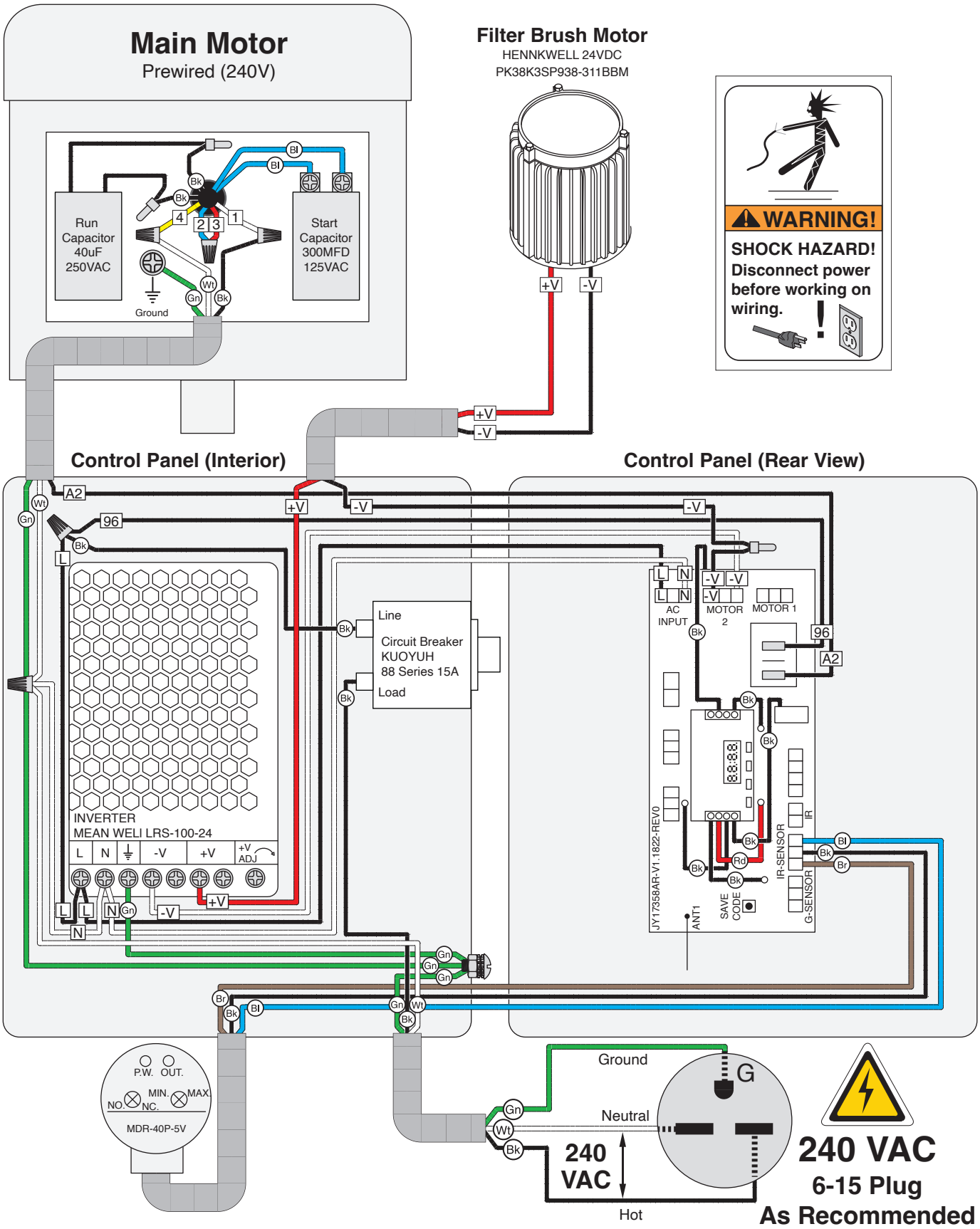
COLOR KEY

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

G0975 Wiring Diagram 120V

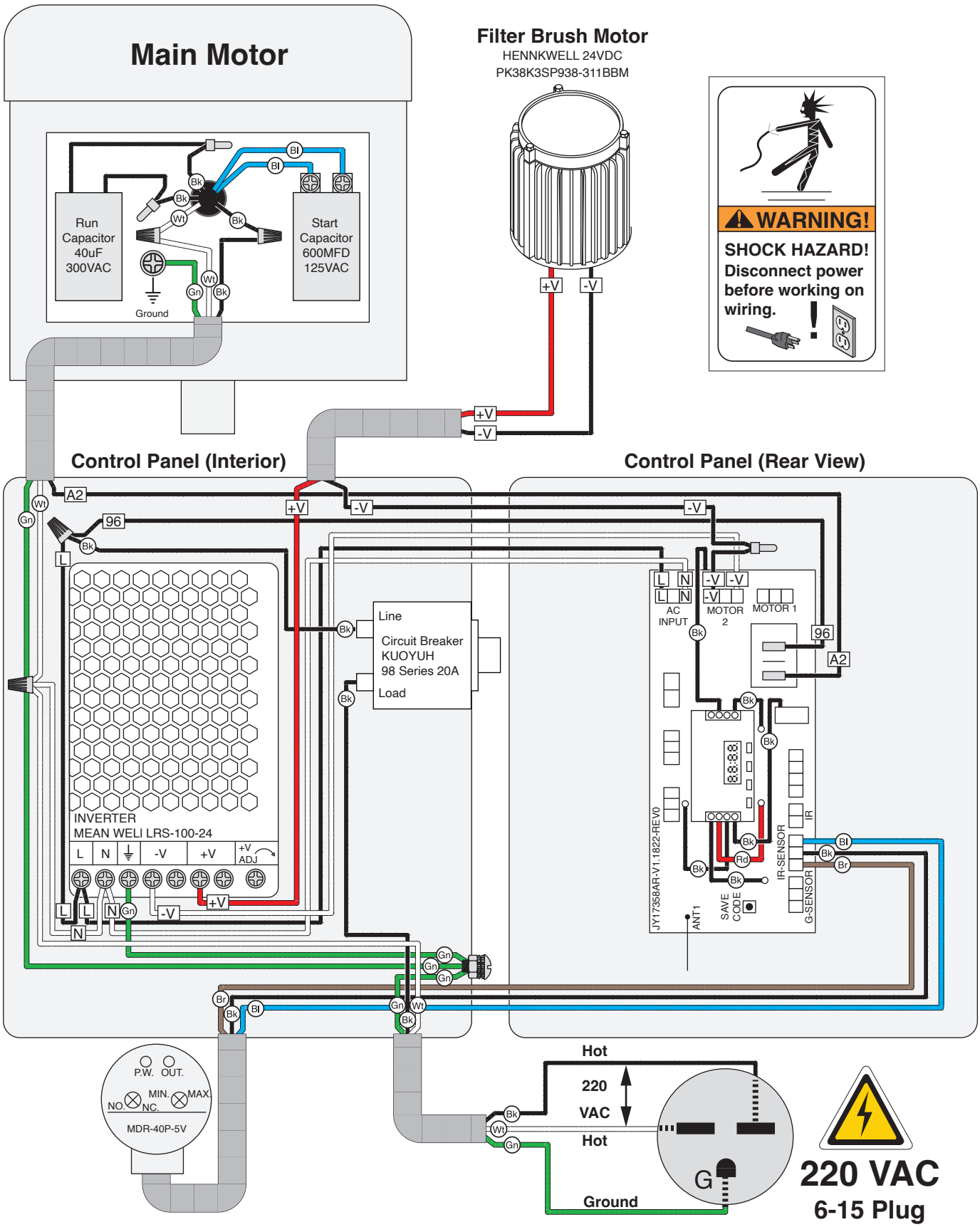


G0975 Wiring Diagram 240V

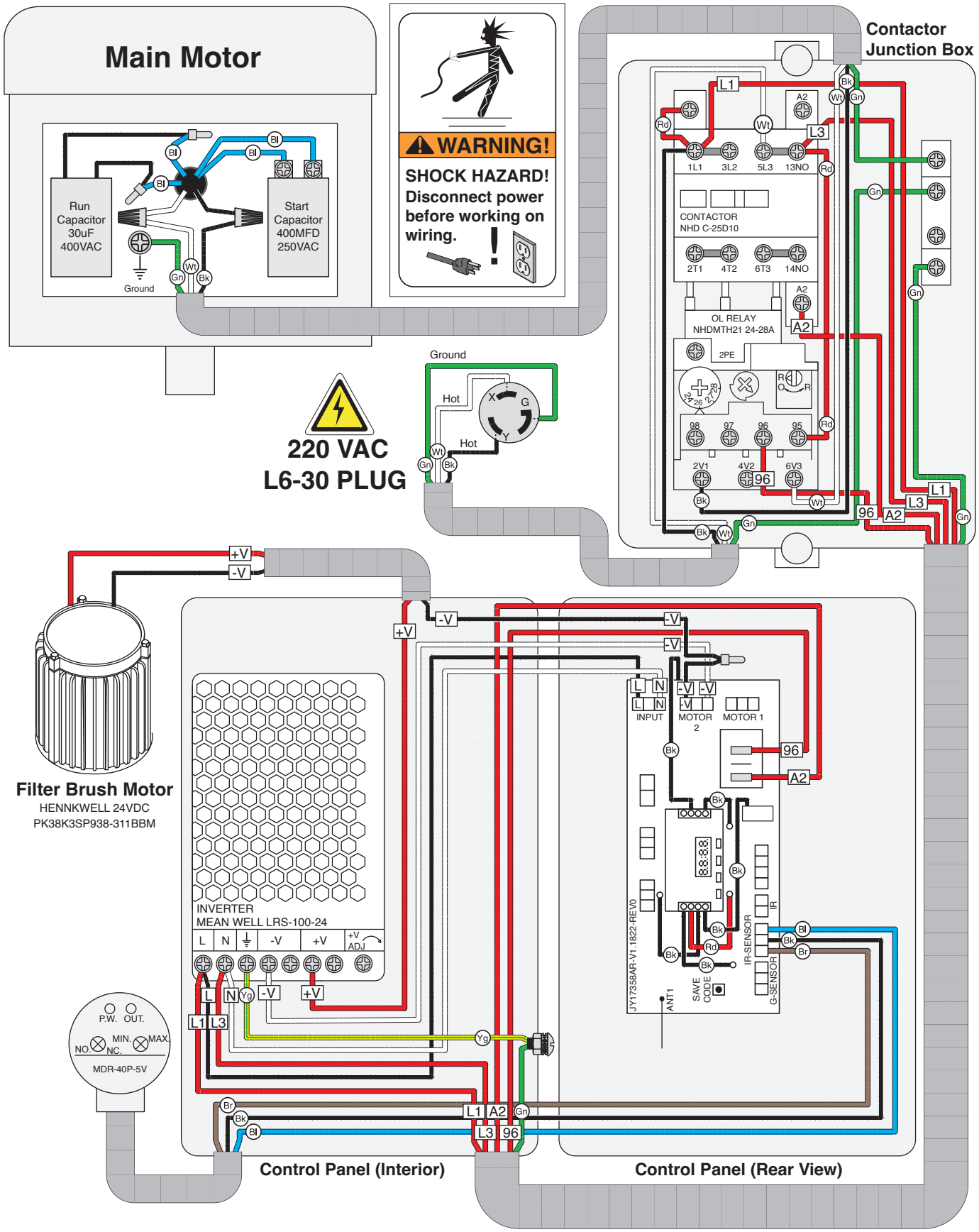


STOP READ ELECTRICAL SAFETY ON PAGE 52!

G0976 Wiring Diagram



G0977 Wiring Diagram



STOP *READ ELECTRICAL SAFETY ON PAGE 52!*

G0975 Electrical Components

Figure 86. G0975 motor wiring.

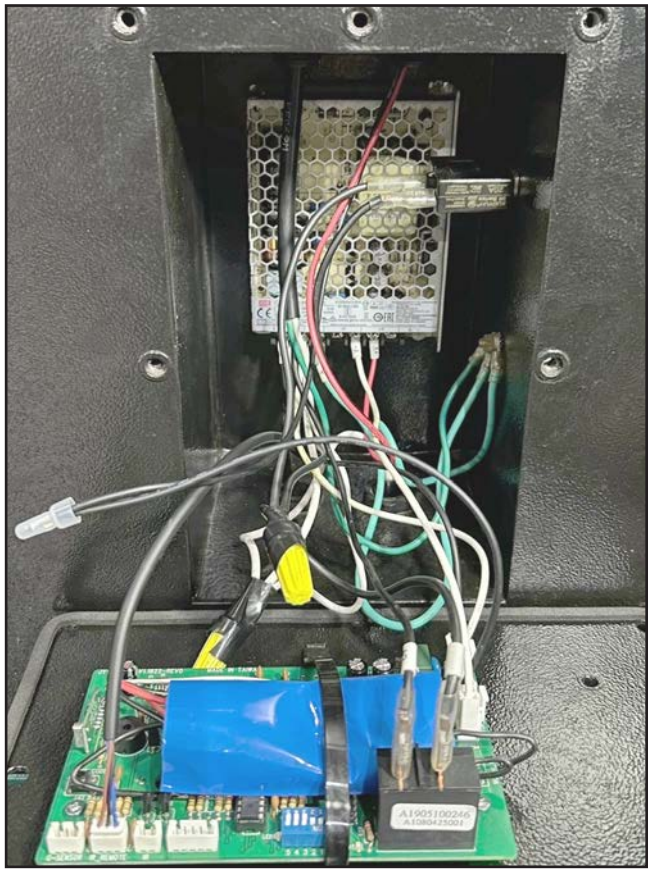


Figure 87. G0975 control panel wiring.

G0976 Electrical Components

Figure 88. G0976 motor wiring.

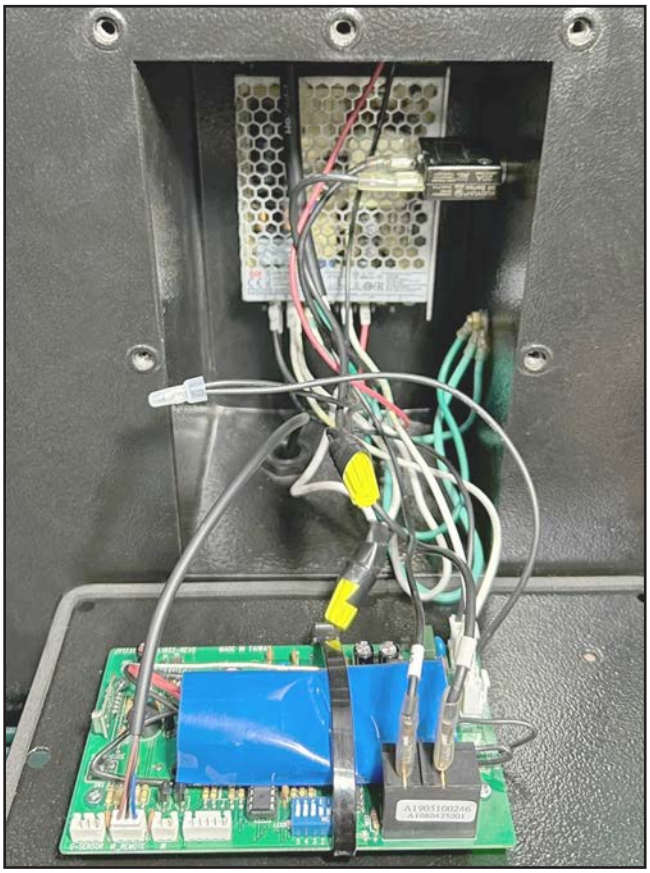


Figure 89. G0976 control panel wiring.

G0977 Electrical Components

Figure 90. G0977 motor wiring.

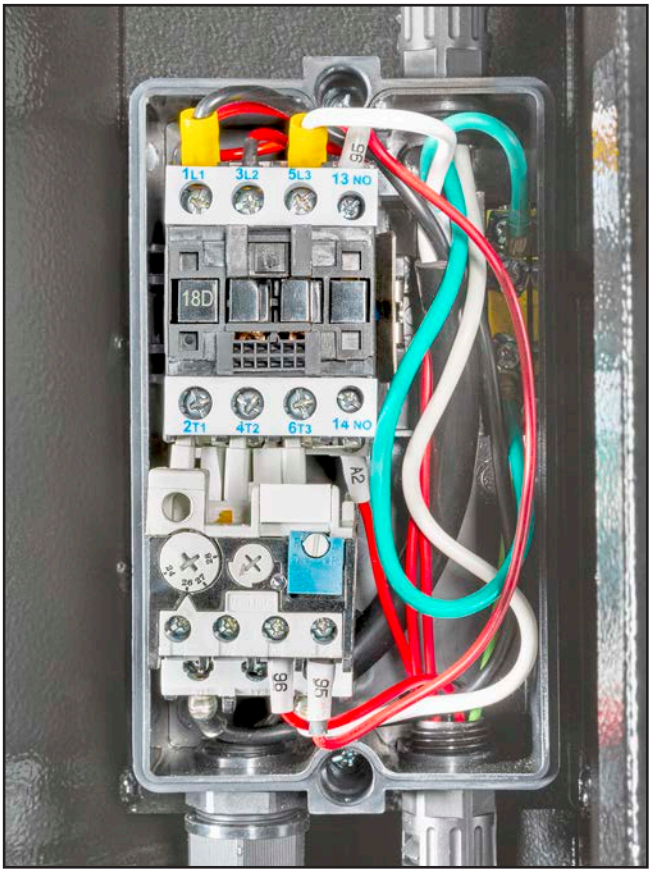


Figure 91. G0977 magnetic switch wiring.

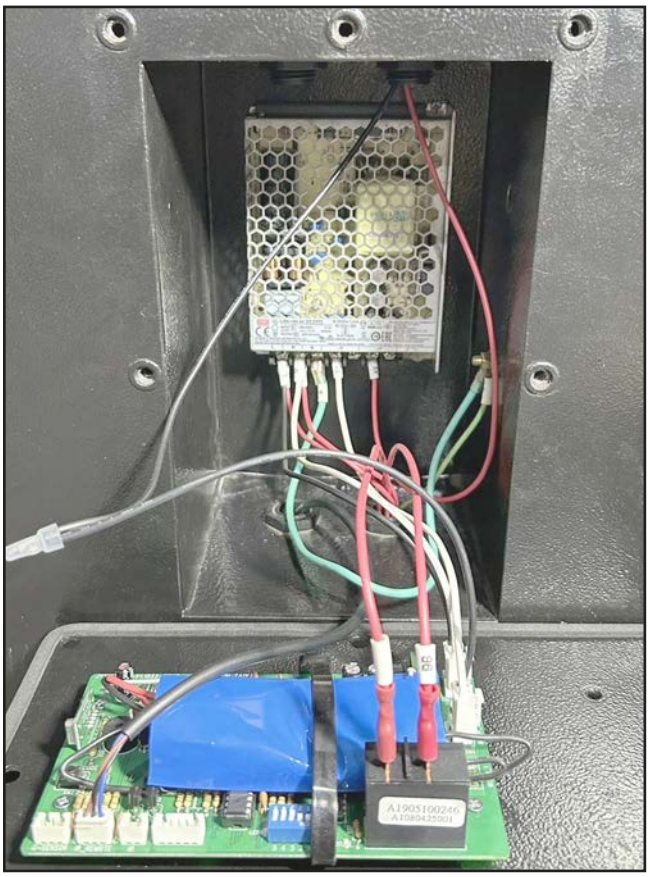


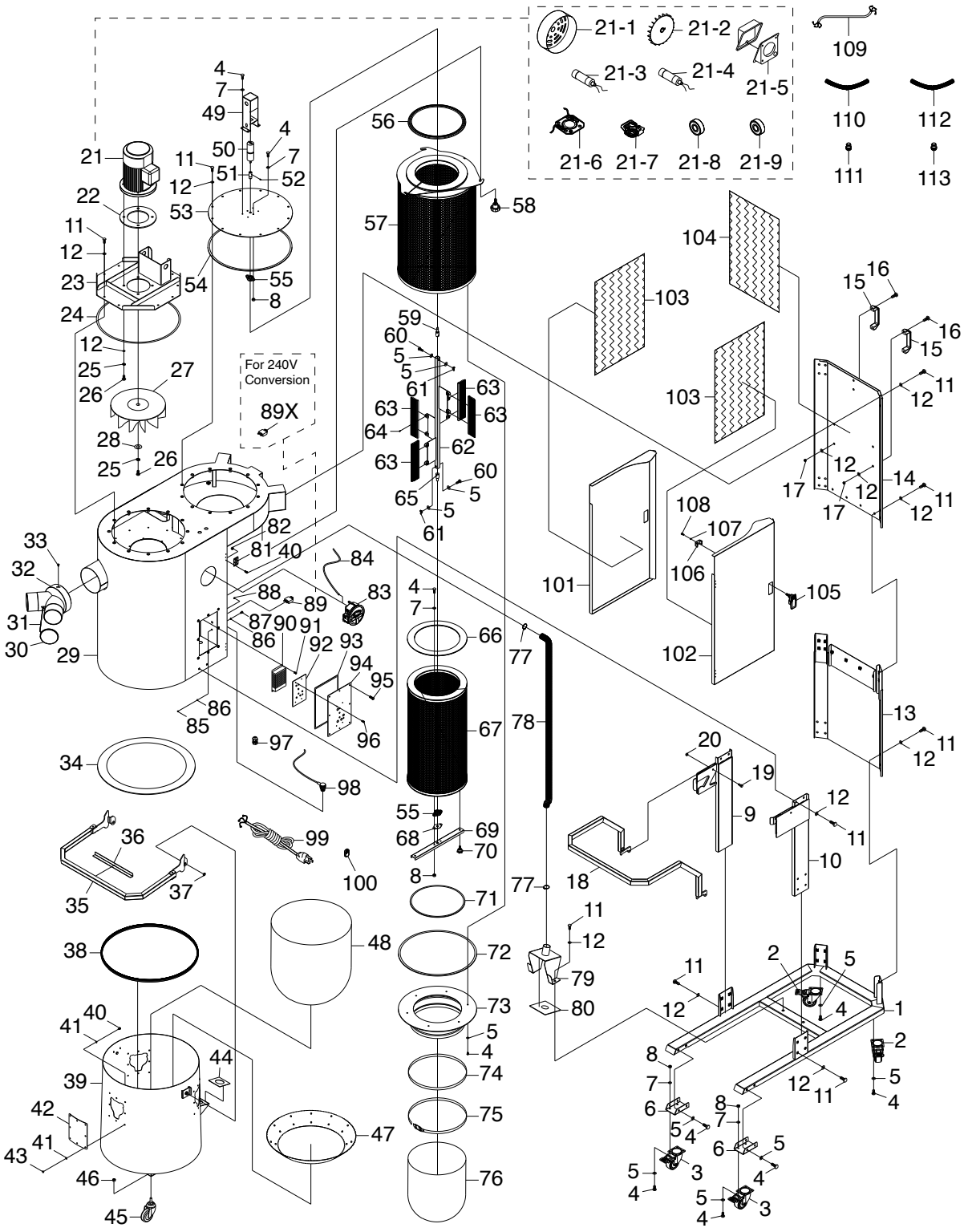
Figure 92. G0977 control panel wiring.

STOP *READ ELECTRICAL SAFETY ON PAGE 52!*

SECTION 10: PARTS

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

G0975 Parts



G0975 Parts List

REF	PART #	DESCRIPTION
1	P0975001	STAND BASE
2	P0975002	CASTER 3", SWIVEL LOCKING
3	P0975003	CASTER 3", LOCKING
4	P0975004	HEX BOLT 1/4-20 X 3/4
5	P0975005	FENDER WASHER 1/4
6	P0975006	CASTER MOUNT
7	P0975007	FLAT WASHER 1/4
8	P0975008	HEX NUT 1/4-20
9	P0975009	LEG, LEFT
10	P0975010	LEG, RIGHT
11	P0975011	HEX BOLT 5/16-18 X 3/4
12	P0975012	FLAT WASHER 5/16
13	P0975013	COVER, LOWER REAR
14	P0975014	COVER, UPPER REAR
15	P0975015	HANDLE
16	P0975016	CAP SCREW 5/16-18 X 3/4
17	P0975017	HEX NUT 5/16-18
18	P0975018	COLLECTION DRUM LOCK HANDLE
19	P0975019	SHOULDER SCREW M6-1 X 11, 8 X 12
20	P0975020	LOCK NUT M6-1
21	P0975021	MOTOR 1.5HP 120/240V 1-PH
21-1	P0975021-1	MOTOR FAN COVER
21-2	P0975021-2	MOTOR FAN
21-3	P0975021-3	S CAPACITOR 400M 125V 1-3/8" X 3-1/8"
21-4	P0975021-4	R CAPACITOR 50M 250V 1-3/8" X 2-3/8"
21-5	P0975021-5	MOTOR JUNCTION BOX
21-6	P0975021-6	CONTACT PLATE
21-7	P0975021-7	CENTRIFUGAL SWITCH
21-8	P0975021-8	BALL BEARING 6205ZZ FRONT
21-9	P0975021-9	BALL BEARING 6202ZZ REAR
22	P0975022	GASKET 135 X 195 X 3MM
23	P0975023	IMPELLER COVER
24	P0975024	GASKET 9 X 8 X 1420MM
25	P0975025	LOCK WASHER 5/16
26	P0975026	HEX BOLT 5/16-18 X 1
27	P0975027	IMPELLER 13-1/2"
28	P0975028	FENDER WASHER 5/16
29	P0975029	MACHINE BODY
30	P0975030	INLET COVER 4"
31	P0975031	BALL CHAIN 19.7"
32	P0975032	INLET ADAPTER 6" X 4" X 2
33	P0975033	TAP SCREW #10 X 1/2
34	P0975034	GASKET 10 X 50 X 1650MM
35	P0975035	COLLECTION DRUM HANDLE
36	P0975036	BUMPER 18 X 8 X 80MM
37	P0975037	EXT RETAINING RING 13MM
38	P0975038	GASKET 11 X 21 X 1650MM RUBBER
39	P0975039	COLLECTION DRUM
40	P0975040	PHLP HD SCR 10-24 X 1/2
41	P0975041	FLAT WASHER 3/16
42	P0975042	DRUM WINDOW 140 X 170 X 3MM ACRYLIC
43	P0975043	ACORN NUT 3/16-24
44	P0975044	GASKET 80 X 85 X 5MM
45	P0975045	CASTER 3", SWIVEL
46	P0975046	HEX NUT 3/8-16
47	P0975047	COLLECTION DRUM VACUUM RING

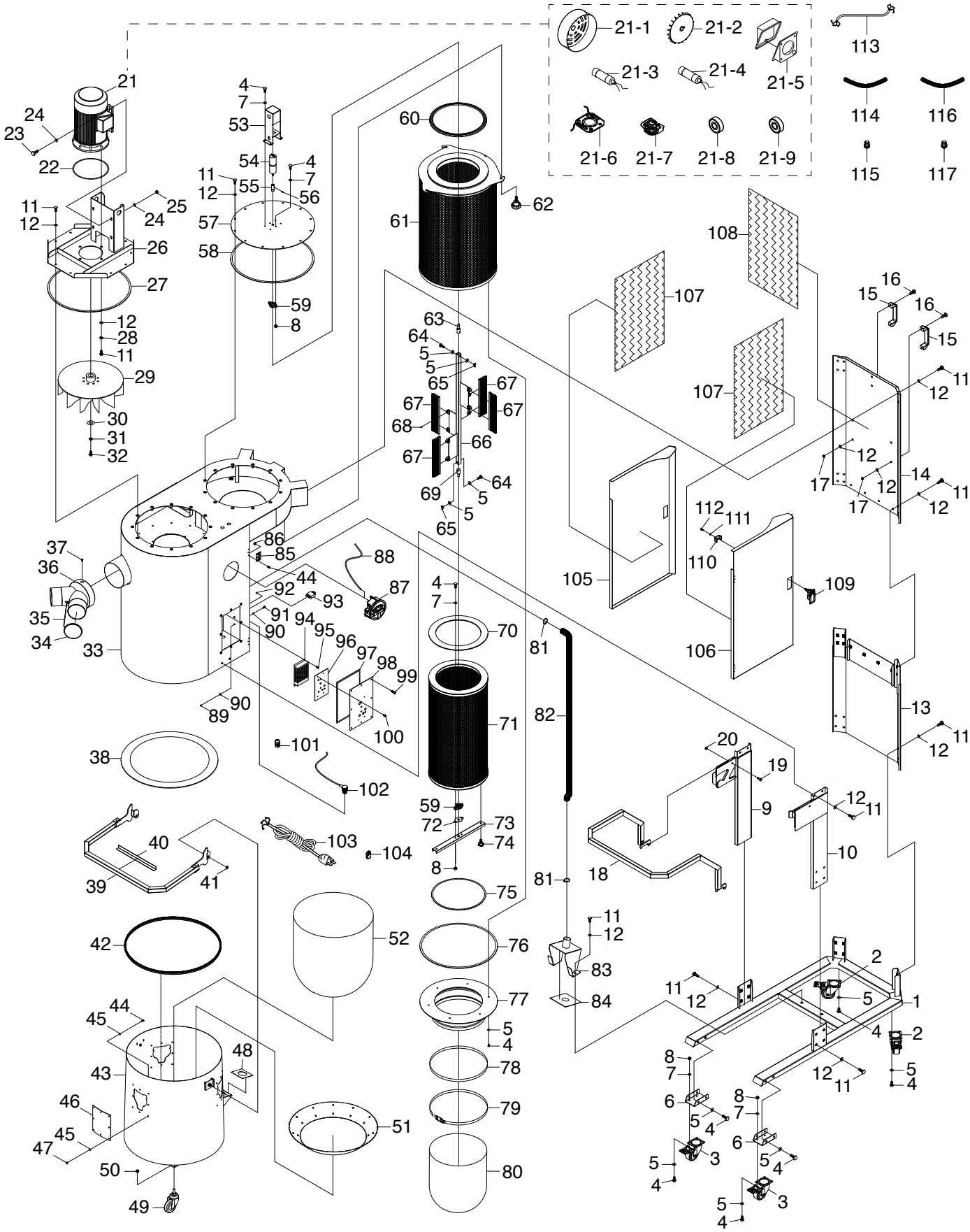
REF	PART #	DESCRIPTION
48	P0975048	COLLECTION BAG 21-3/4" X 37-1/2"
49	P0975049	FILTER BRUSH MOTOR BRACKET
50	P0975050	FILTER BRUSH MOTOR 3W 24VDC
51	P0975051	BRUSH SPINDLE CONNECTOR
52	P0975052	SET SCREW M4-.7 X 12
53	P0975053	FILTER COVER PLATE
54	P0975054	GASKET 9 X 8 X 1420MM
55	P0975055	PILLOW BEARING UFL000
56	P0975056	GASKET 18 X 8 X 950MM RUBBER
57	P0975057	CANISTER FILTER, HEPA
58	P0975058	KNOB BOLT 3/8-16 X 2
59	P0975059	UPPER SPINDLE HEAD
60	P0975060	HEX BOLT 1/4-20 X 1-1/4
61	P0975061	WING NUT 1/4-20
62	P0975062	BRUSH SPINDLE 735MM
63	P0975063	FILTER BRUSH 250 X 40 X 5MM
64	P0975064	SET SCREW M8-1.25 X 8
65	P0975065	LOWER SPINDLE HEAD
66	P0975066	GASKET 5 X 40 X 930MM
67	P0975067	CANISTER FILTER, POLYESTER
68	P0975068	PILLOW BLOCK BEARING PLATE
69	P0975069	FILTER BRUSH BASE
70	P0975070	KNOB BOLT 1/4-20 X 3/4
71	P0975071	GASKET 3 X 6 X 870MM
72	P0975072	GASKET 3 X 6 X 1310MM
73	P0975073	FILTER BAG FLANGE
74	P0975074	GASKET 5 X 40 X 985MM
75	P0975075	BAG CLAMP 38-1/2"
76	P0975076	FILTER BAG 12-1/4" X 16"
77	P0975077	HOSE CLAMP 1-3/4"
78	P0975078	VACUUM HOSE 1-1/2" X 39.5"
79	P0975079	VACUUM HOSE BRACKET
80	P0975080	GASKET 120 X 110 X 5MM
81	P0975081	HINGE
82	P0975082	HEX NUT 3/16-24
83	P0975083	PRESSURE GAUGE
84	P0975084	HOSE 5 X 8 X 600MM
85	P0975085	HEX NUT M5-.8
86	P0975086	EXT TOOTH WASHER 5MM
87	P0975087	PHLP HD SCR M5-.8 X 12
88	P0975088	HEX NUT M3-.5
89	P0975089	CIRCUIT BREAKER KUOYUH 98 SERIES 20A
89X	P0975089X	CIRCUIT BREAKER KUOYUH 88 SERIES 15A
90	P0975090	POWER SUPPLY MEAN WELL LRS-100-24
91	P0975091	FLAT HD SCR M3-.5 X 10
92	P0975092	CIRCUIT BOARD JY17358AR-V1.1822 REV0
93	P0975093	GASKET 3 X 6 X 880MM
94	P0975094	CONTROL PANEL
95	P0975095	PHLP HD SCR 1/4-20 X 1/2
96	P0975096	FLAT HD SCR M3-.5 X 6
97	P0975097	STRAIN RELIEF PG13.5
98	P0975098	PHOTOELECTRIC SENSOR
99	P0975099	POWER CORD 12G 3W 118" 5-20P
100	P0975100	REMOTE CONTROL
101	P0975101	MAINTENANCE DOOR, LEFT
102	P0975102	MAINTENANCE DOOR, RIGHT

G0975 Parts List (Cont.)

REF	PART #	DESCRIPTION
103	P0975103	INSULATION FOAM 18" X 28"
104	P0975104	INSULATION FOAM 16" X 24"
105	P0975105	COMPRESSION LATCH
106	P0975106	LATCH MOUNT
107	P0975107	INT TOOTH WASHER 5MM
108	P0975108	HEX BOLT M5-.8 X 16

REF	PART #	DESCRIPTION
109	P0975109	MOTOR CORD 12G 3W 46"
110	P0975110	CONDUIT 3/8 X 31.5"
111	P0975111	CONDUIT FITTING 3/8 X 1/2
112	P0975112	CONDUIT 3/8 X 39.4"
113	P0975113	CONDUIT FITTING 3/8 X 1/2

G0976 Parts



G0976 Parts List

REF	PART #	DESCRIPTION
1	P0976001	STAND BASE
2	P0976002	CASTER 3", SWIVEL LOCKING
3	P0976003	CASTER 3", LOCKING
4	P0976004	HEX BOLT 1/4-20 X 3/4
5	P0976005	FENDER WASHER 1/4
6	P0976006	CASTER MOUNT
7	P0976007	FLAT WASHER 1/4
8	P0976008	HEX NUT 1/4-20
9	P0976009	LEG, LEFT
10	P0976010	LEG, RIGHT
11	P0976011	HEX BOLT 5/16-18 X 3/4
12	P0976012	FLAT WASHER 5/16
13	P0976013	COVER, LOWER REAR
14	P0976014	COVER, UPPER REAR
15	P0976015	HANDLE
16	P0976016	CAP SCREW 5/16-18 X 3/4
17	P0976017	HEX NUT 5/16-18
18	P0976018	COLLECTION DRUM LOCK HANDLE
19	P0976019	SHOULDER SCREW M6-1 X 11, 8 X 12
20	P0976020	LOCK NUT M6-1
21	P0976021	MOTOR 2HP 220V 1-PH
21-1	P0976021-1	MOTOR FAN COVER
21-2	P0976021-2	MOTOR FAN
21-3	P0976021-3	S CAPACITOR 600M 125V 2" X 4"
21-4	P0976021-4	R CAPACITOR 40M 300V 1-9/16" X 2-3/4"
21-5	P0976021-5	MOTOR JUNCTION BOX
21-6	P0976021-6	CONTACT PLATE
21-7	P0976021-7	CENTRIFUGAL SWITCH
21-8	P0976021-8	BALL BEARING 6205ZZ FRONT
21-9	P0976021-9	BALL BEARING 6202ZZ REAR
22	P0976022	GASKET 3 X 6 X 560MM
23	P0976023	HEX BOLT 3/8-16 X 1-1/2
24	P0976024	FLAT WASHER 3/8
25	P0976025	LOCK NUT 3/8-16
26	P0976026	IMPELLER COVER
27	P0976027	GASKET 9 X 8 X 1410MM
28	P0976028	LOCK WASHER 5/16
29	P0976029	IMPELLER 14-1/2"
30	P0976030	FENDER WASHER 3/8
31	P0976031	LOCK WASHER 3/8
32	P0976032	HEX BOLT 3/8-16 X 1
33	P0976033	MACHINE BODY
34	P0976034	INLET COVER 4"
35	P0976035	BALL CHAIN 19.7"
36	P0976036	INLET ADAPTER 6" X 4" X 2
37	P0976037	TAP SCREW #10 X 1/2
38	P0976038	GASKET 10 X 50 X 1700MM RUBBER
39	P0976039	COLLECTION DRUM HANDLE
40	P0976040	BUMPER 18 X 8 X 80MM
41	P0976041	EXT RETAINING RING 13MM
42	P0976042	GASKET 11 X 21 X 1650MM
43	P0976043	COLLECTION DRUM
44	P0976044	PHLP HD SCR 10-24 X 1/2
45	P0976045	FLAT WASHER 3/16
46	P0976046	DRUM WINDOW 140 X 170 X 3MM ACRYLIC
47	P0976047	ACORN NUT 3/16-24

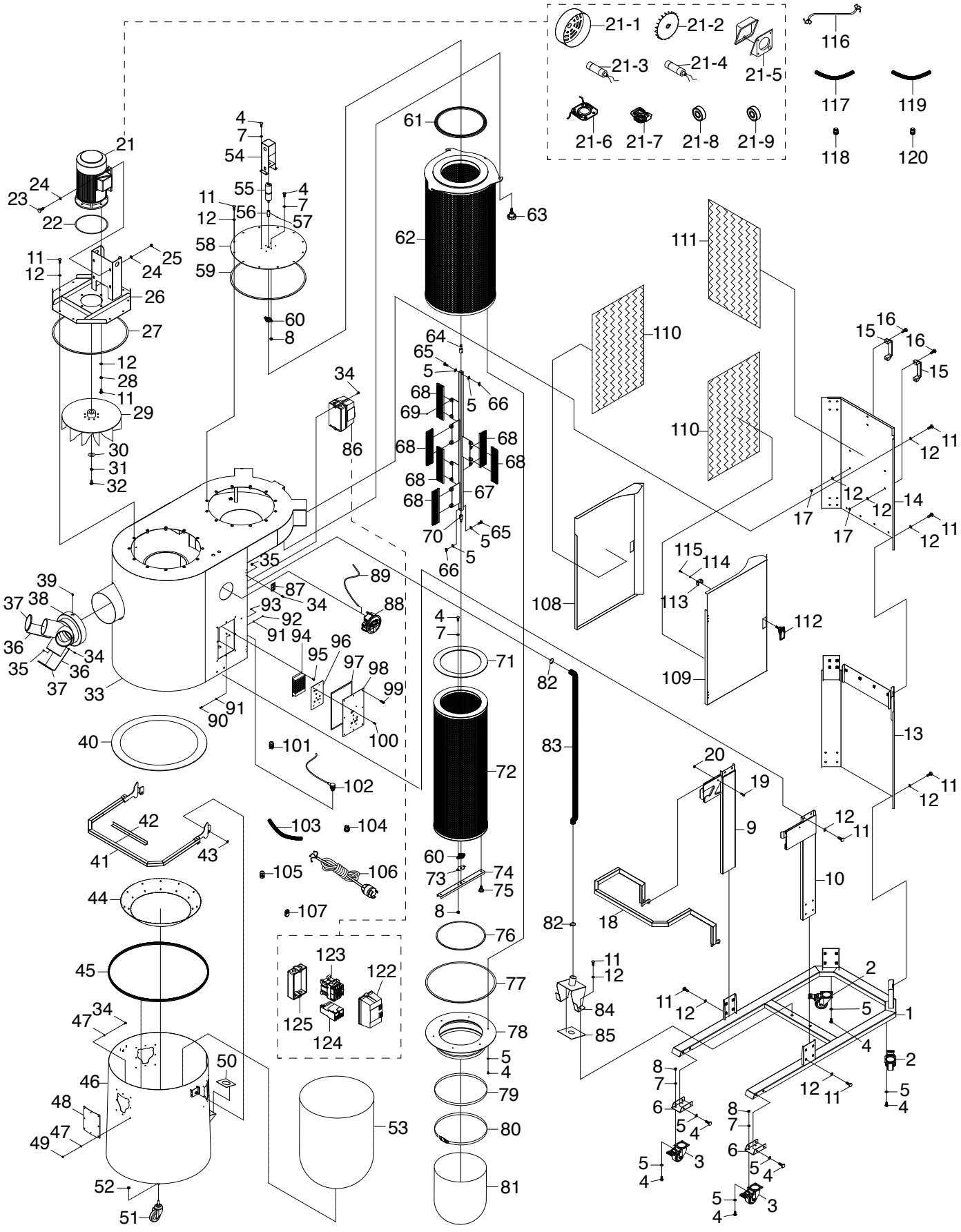
REF	PART #	DESCRIPTION
48	P0976048	GASKET 80 X 85 X 5MM
49	P0976049	CASTER 3", SWIVEL
50	P0976050	HEX NUT 3/8-16
51	P0976051	COLLECTION DRUM VACUUM RING
52	P0976052	COLLECTION BAG 21-3/4" X 37-1/2"
53	P0976053	FILTER BRUSH MOTOR BRACKET
54	P0976054	FILTER BRUSH MOTOR 3W 24VDC
55	P0976055	BRUSH SPINDLE CONNECTOR
56	P0976056	SET SCREW M4-.7 X 12
57	P0976057	FILTER COVER PLATE
58	P0976058	GASKET 9 X 8 X 1420MM
59	P0976059	PILLOW BEARING UFL000
60	P0976060	GASKET 18 X 8 X 950MM
61	P0976061	CANISTER FILTER, HEPA
62	P0976062	KNOB BOLT 3/8-16 X 2
63	P0976063	UPPER SPINDLE HEAD
64	P0976064	HEX BOLT 1/4-20 X 1-1/4
65	P0976065	WING NUT 1/4-20
66	P0976066	BRUSH SPINDLE 735MM
67	P0976067	FILTER BRUSH 250 X 40 X 5MM
68	P0976068	SET SCREW M8-1.25 X 8
69	P0976069	LOWER SPINDLE HEAD
70	P0976070	GASKET 5 X 40 X 930MM
71	P0976071	CANISTER FILTER, POLYESTER
72	P0976072	PILLOW BLOCK BEARING PLATE
73	P0976073	FILTER BRUSH BASE
74	P0976074	KNOB BOLT 1/4-20 X 3/4
75	P0976075	GASKET 3 X 6 X 870MM
76	P0976076	GASKET 3 X 6 X 1310MM
77	P0976077	FILTER BAG FLANGE
78	P0976078	GASKET 5 X 40 X 985MM
79	P0976079	BAG CLAMP 38-1/2"
80	P0976080	FILTER BAG 12-1/4" X 16"
81	P0976081	HOSE CLAMP 1-3/4"
82	P0976082	VACUUM HOSE 1-1/2" X 45"
83	P0976083	VACUUM HOSE BRACKET
84	P0976084	GASKET 120 X 110 X 5MM
85	P0976085	HINGE
86	P0976086	HEX NUT 3/16-24
87	P0976087	PRESSURE GAUGE
88	P0976088	HOSE 5 X 8 X 600MM
89	P0976089	HEX NUT M5-.8
90	P0976090	EXT TOOTH WASHER 5MM
91	P0976091	PHLP HD SCR M5-.8 X 12
92	P0976092	HEX NUT M3-.5
93	P0976093	CIRCUIT BREAKER KUOYUH 98 SERIES 20A
94	P0976094	POWER SUPPLY MEAN WELL LRS-100-24
95	P0976095	FLAT HD SCR M3-.5 X 10
96	P0976096	CIRCUIT BOARD JY17358AR-V1.1822 REV0
97	P0976097	GASKET 3 X 6 X 880MM
98	P0976098	CONTROL PANEL
99	P0976099	PHLP HD SCR 1/4-20 X 1/2
100	P0976100	FLAT HD SCR M3-.5 X 6
101	P0976101	STRAIN RELIEF PG13.5
102	P0976102	PHOTOELECTRIC SENSOR
103	P0976103	POWER CORD 14G 3W 118" 6-15P

G0976 Parts List (Cont.)

REF	PART #	DESCRIPTION
104	P0976104	REMOTE CONTROL
105	P0976105	MAINTENANCE DOOR, LEFT
106	P0976106	MAINTENANCE DOOR, RIGHT
107	P0976107	INSULATION FOAM 18" X 28"
108	P0976108	INSULATION FOAM 16" X 24"
109	P0976109	COMPRESSION LATCH
110	P0976110	LATCH MOUNT

REF	PART #	DESCRIPTION
111	P0976111	INT TOOTH WASHER 5MM
112	P0976112	HEX BOLT M5-.8 X 16
113	P0976113	MOTOR CORD 14G 3W 53"
114	P0976114	CONDUIT 3/8 X 31.5"
115	P0976115	CONDUIT FITTING 3/8 X 1/2
116	P0976116	CONDUIT 3/8 X 39.4"
117	P0976117	CONDUIT FITTING 3/8 X 1/2

G0977 Parts



G0977 Parts List

REF	PART #	DESCRIPTION
1	P0977001	STAND BASE
2	P0977002	CASTER 3", SWIVEL LOCKING
3	P0977003	CASTER 3", LOCKING
4	P0977004	HEX BOLT 1/4-20 X 3/4
5	P0977005	FENDER WASHER 1/4
6	P0977006	CASTER MOUNT
7	P0977007	FLAT WASHER 1/4
8	P0977008	HEX NUT 1/4-20
9	P0977009	LEG, LEFT
10	P0977010	LEG, RIGHT
11	P0977011	HEX BOLT 5/16-18 X 3/4
12	P0977012	FLAT WASHER 5/16
13	P0977013	COVER, LOWER REAR
14	P0977014	COVER, UPPER REAR
15	P0977015	HANDLE
16	P0977016	CAP SCREW 5/16-18 X 3/4
17	P0977017	HEX NUT 5/16-18
18	P0977018	COLLECTION DRUM LOCK HANDLE
19	P0977019	SHOULDER SCREW M6-1 X 11, 8 X 12
20	P0977020	LOCK NUT M6-1
21	P0977021	MOTOR 3HP 220V 1-PH
21-1	P0977021-1	MOTOR FAN COVER
21-2	P0977021-2	MOTOR FAN
21-3	P0977021-3	S CAPACITOR 400M 250V 2" X 4"
21-4	P0977021-4	R CAPACITOR 30M 400V 1-3/4" X 3-3/8"
21-5	P0977021-5	MOTOR JUNCTION BOX
21-6	P0977021-6	CONTACT PLATE
21-7	P0977021-7	CENTRIFUGAL SWITCH
21-8	P0977021-8	BALL BEARING 6205ZZ FRONT
21-9	P0977021-9	BALL BEARING 6202ZZ REAR
22	P0977022	GASKET 3 X 6 X 560MM
23	P0977023	HEX BOLT 3/8-16 X 1-1/2
24	P0977024	FLAT WASHER 3/8
25	P0977025	LOCK NUT 3/8-16
26	P0977026	IMPELLER COVER
27	P0977027	GASKET 9 X 8 X 1450MM
28	P0977028	LOCK WASHER 5/16
29	P0977029	IMPELLER 15-1/2"
30	P0977030	FENDER WASHER 3/8
31	P0977031	LOCK WASHER 3/8
32	P0977032	HEX BOLT 3/8-16 X 1
33	P0977033	MACHINE BODY
34	P0977034	PHLP HD SCR 10-24 X 1/2
35	P0977035	HEX NUT 3/16-24
36	P0977036	BALL CHAIN 19.7"
37	P0977037	INLET COVER 4"
38	P0977038	INLET ADAPTER 8" X 4" X 3
39	P0977039	TAP SCREW #10 X 1/2
40	P0977040	GASKET 10 X 50 X 1970MM RUBBER
41	P0977041	COLLECTION DRUM HANDLE
42	P0977042	BUMPER 18 X 8 X 80MM
43	P0977043	EXT RETAINING RING 13MM
44	P0977044	COLLECTION DRUM VACUUM RING
45	P0977045	GASKET, RUBBER 11 X 21 X 1890MM

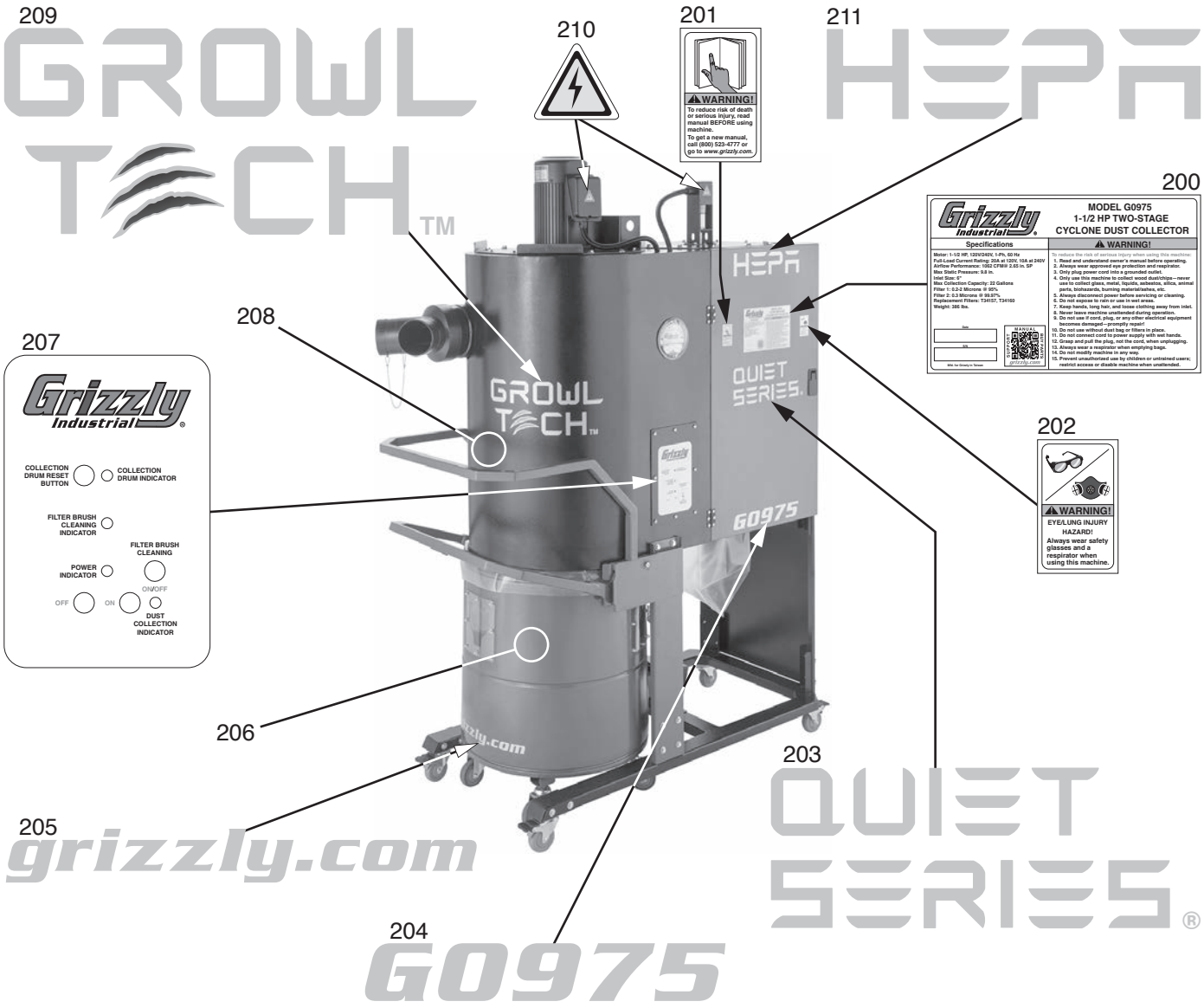
REF	PART #	DESCRIPTION
46	P0977046	COLLECTION DRUM
47	P0977047	FLAT WASHER #10
48	P0977048	DRUM WINDOW 140 X 170 X 3MM ACRYLIC
49	P0977049	ACORN NUT 3/16-24
50	P0977050	GASKET 80 X 85 X 5MM
51	P0977051	CASTER 3", SWIVEL
52	P0977052	HEX NUT 3/8-16
53	P0977053	COLLECTION BAG 24-3/4" X 37-1/2"
54	P0977054	FILTER BRUSH MOTOR BRACKET
55	P0977055	FILTER BRUSH MOTOR 3W 24VDC
56	P0977056	BRUSH SPINDLE CONNECTOR
57	P0977057	SET SCREW M4-.7 X 12
58	P0977058	FILTER COVER PLATE
59	P0977059	GASKET 9 X 8 X 1420MM
60	P0977060	PILLOW BEARING UFL000
61	P0977061	GASKET 18 X 8 X 950MM
62	P0977062	CANISTER FILTER, HEPA
63	P0977063	KNOB BOLT 3/8-16 X 2
64	P0977064	UPPER SPINDLE HEAD
65	P0977065	HEX BOLT 1/4-20 X 1-1/4
66	P0977066	WING NUT 1/4-20
67	P0977067	BRUSH SPINDLE 995MM
68	P0977068	FILTER BRUSH 250 X 40 X 5MM
69	P0977069	SET SCREW M8-1.25 X 8
70	P0977070	LOWER SPINDLE HEAD
71	P0977071	GASKET 5 X 40 X 930MM
72	P0977072	CANISTER FILTER, POLYESTER
73	P0977073	PILLOW BLOCK BEARING PLATE
74	P0977074	FILTER BRUSH BASE
75	P0977075	KNOB BOLT 1/4-20 X 3/4
76	P0977076	GASKET 3 X 6 X 870MM
77	P0977077	GASKET 3 X 6 X 1310MM
78	P0977078	FILTER BAG FLANGE
79	P0977079	GASKET 5 X 40 X 985MM
80	P0977080	BAG CLAMP 38-1/2"
81	P0977081	FILTER BAG 12-1/4" X 16"
82	P0977082	HOSE CLAMP 1-3/4"
83	P0977083	VACUUM HOSE 1-1/2" X 45"
84	P0977084	VACUUM HOSE BRACKET
85	P0977085	GASKET 120 X 110 X 5MM
86	P0977086	MAGNETIC SWITCH MS-18D
87	P0977087	HINGE
88	P0977088	PRESSURE GAUGE
89	P0977089	HOSE 5 X 8 X 600MM
90	P0977090	PHLP HD SCR M5-.8 X 12
91	P0977091	EXT TOOTH WASHER 5MM
92	P0977092	HEX NUT M5-.8
93	P0977093	HEX NUT M3-.5
94	P0977094	POWER SUPPLY MEAN WELL LRS-100-24
95	P0977095	FLAT HD SCR M3-.5 X 10
96	P0977096	CIRCUIT BOARD JY17358AR-V1.1822 REV0
97	P0977097	GASKET 3 X 6 X 880MM
98	P0977098	CONTROL PANEL
99	P0977099	PHLP HD SCR 1/4-20 X 1/2

G0977 Parts List (Cont.)

REF	PART #	DESCRIPTION
100	P0977100	FLAT HD SCR M3-.5 X 6
101	P0977101	STRAIN RELIEF PG13.5
102	P0977102	PHOTOELECTRIC SENSOR
103	P0977103	CONDUIT 3/8" X 30.3"
104	P0977104	CONDUIT FITTING 3/8 X 1/2
105	P0977105	STRAIN RELIEF PG13.5
106	P0977106	POWER CORD 12G 3W 118" L6-30P
107	P0977107	REMOTE CONTROL
108	P0977108	MAINTENANCE DOOR, LEFT
109	P0977109	MAINTENANCE DOOR, RIGHT
110	P0977110	INSULATION FOAM 20" X 27.5"
111	P0977111	INSULATION FOAM 18" X 23.5"
112	P0977112	COMPRESSION LATCH

REF	PART #	DESCRIPTION
113	P0977113	LATCH MOUNT
114	P0977114	INT TOOTH WASHER 5MM
115	P0977115	HEX BOLT M5-.8 X 16
116	P0977116	MOTOR CORD 12G 3W 65"
117	P0977117	CONDUIT 3/8" X 56"
118	P0977118	CONDUIT FITTING 3/8 X 1/2
119	P0977119	CONDUIT 3/8" X 43.3"
120	P0977120	CONDUIT FITTING 3/8 X 1/2
122	P0977122	MAGNETIC SWITCH COVER
123	P0977123	CONTACTOR MS-18D 220V
124	P0977124	OL RELAY NHD 220V 24-28A
125	P0977125	MAGNETIC SWITCH BOX

Labels & Cosmetics



REF	PART #	DESCRIPTION
200	P0975200	MACHINE ID LABEL (G0975)
200	P0976200	MACHINE ID LABEL (G0976)
200	P0977200	MACHINE ID LABEL (G0977)
201	P0975201	READ MANUAL LABEL
202	P0975202	RESPIRATOR/GLASSES LABEL
203	P0975203	QUIET SERIES LABEL
204	P0975204	MODEL NUMBER LABEL (G0975)
204	P0976204	MODEL NUMBER LABEL (G0976)

REF	PART #	DESCRIPTION
204	P0977204	MODEL NUMBER LABEL (G0977)
205	P0975205	GRIZZLY.COM LABEL
206	P0975206	TOUCH-UP PAINT, GRIZZLY GREEN
207	P0975207	CONTROL PANEL LABEL
208	P0975208	TOUCH-UP PAINT, GLOSSY BLACK
209	P0975209	GROWL TECH LABEL
210	P0975210	ELECTRICITY LABEL
211	P0975211	HEPA LABEL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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

WARRANTY

grizzly.com