

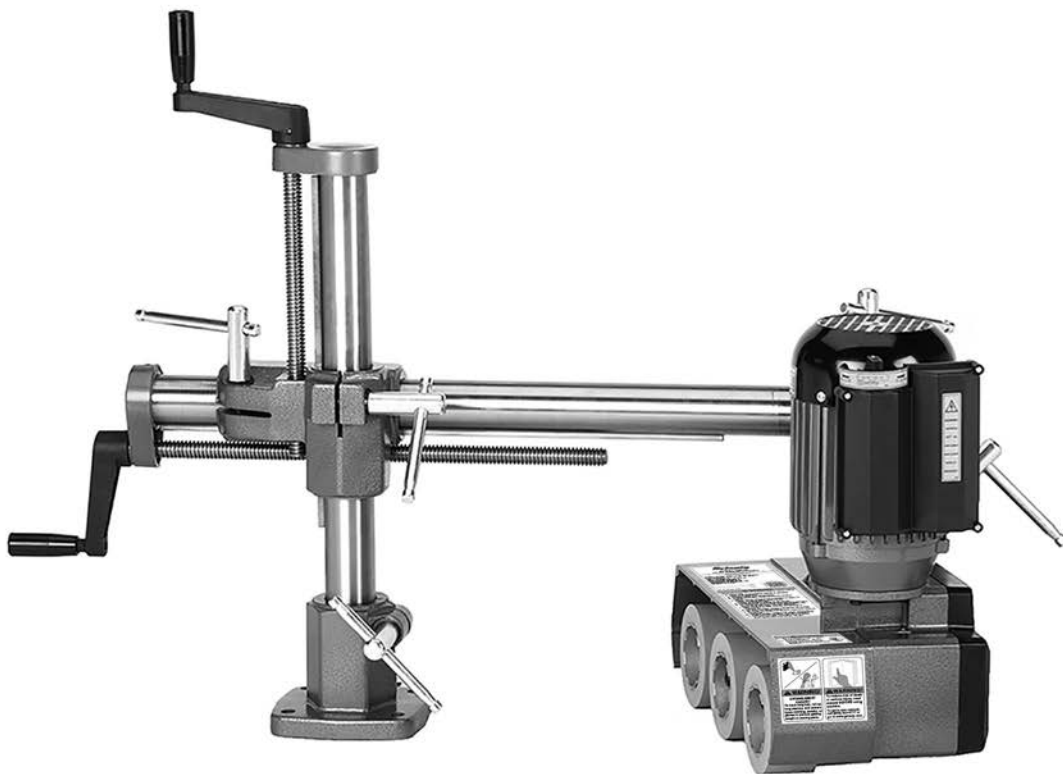


# MODEL G4179

## 1/2 HP POWER FEEDER

### OWNER'S MANUAL

*(For models manufactured since 01/22)*



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#CR10816 PRINTED IN TAIWAN

V3.05.22

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



## **WARNING!**

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

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

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

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



## **WARNING!**

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

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

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

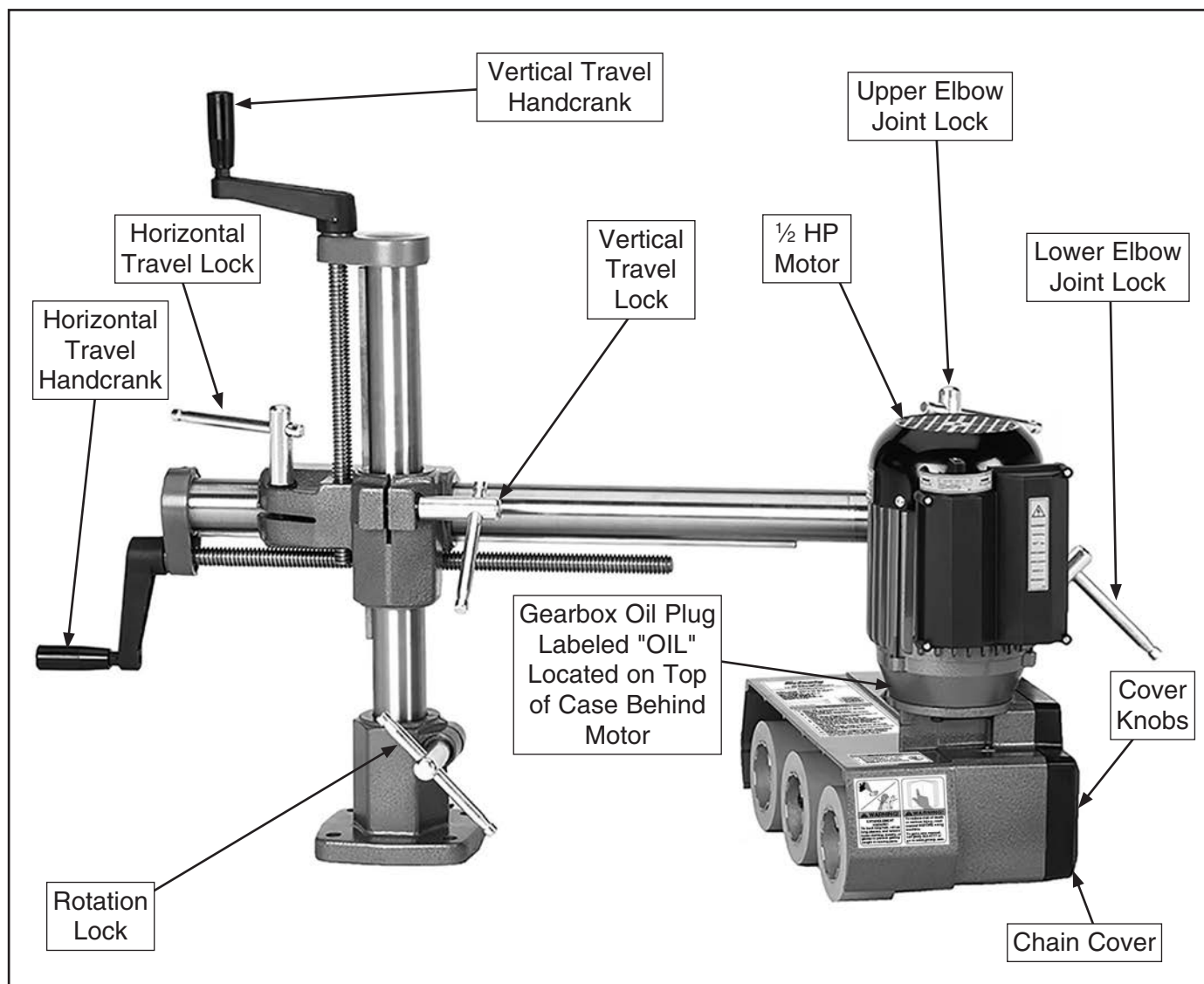
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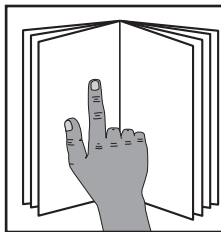


# Identification

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



# 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.

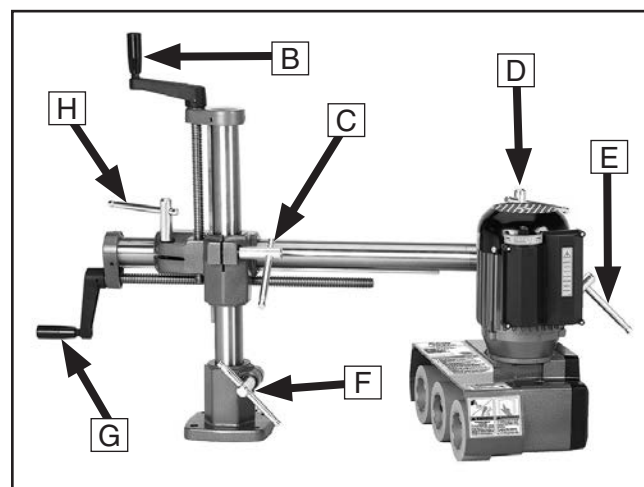
### Feed Direction Switch



**Figure 1.** Feed direction switch.

- A. Feed Direction Switch:** Starts and stops motor, and controls forward/reverse roller rotation.

### Column Controls



**Figure 2.** Column features.

- B. Vertical Travel Handcrank:** Adjusts vertical position of power feeder.
- C. Vertical Travel Lock:** Locks vertical position of power feeder.
- D. Upper Elbow Joint Lock:** Loosen to allow lower elbow and power feeder to rotate around upper elbow. Tighten to secure lower elbow.
- E. Lower Elbow Joint Lock:** Loosen to allow power feeder to rotate around lower elbow. Tighten to secure power feeder.
- F. Rotation Lock:** Loosen to allow vertical column to rotate when loosened. Tighten to prevent vertical column from rotating.
- G. Horizontal Travel Handcrank:** Adjusts horizontal position of power feeder.
- H. Horizontal Travel Lock:** Locks horizontal position of power feeder.





# MACHINE DATA SHEET

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

## MODEL G4179 1/2 HP POWER FEEDER

### Product Dimensions:

Weight..... 104 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 45 x 18 x 28-1/2 in.  
Footprint (Length x Width)..... N/A x N/A

### Shipping Dimensions:

#### Carton #1

Type..... Cardboard Box  
Content..... Machine  
Weight..... 58 lbs.  
Length x Width x Height..... 20 x 11 x 19 in.  
Must Ship Upright..... No

#### Carton #2

Type..... Cardboard Box  
Content..... Stand  
Weight..... 49 lbs.  
Length x Width x Height..... 19 x 30 x 11 in.  
Must Ship Upright..... No

### Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 4A  
Minimum Circuit Size..... 15A  
Connection Type..... Cord & Plug  
Power Cord Included..... Yes  
Power Cord Length..... 9 ft.  
Power Cord Gauge..... 18 AWG  
Plug Included..... No  
Recommended Plug Type..... 6-15  
Switch Type..... Forward/Reverse Switch

### Motors:

#### Main

Horsepower..... 1/2 HP  
Phase..... Single-Phase  
Amps..... 2.9A  
Speed..... 1700 RPM  
Type..... TEFC Capacitor-Start Induction  
Power Transfer ..... Gear Drive  
Bearings..... Sealed & Permanently Lubricated  
Centrifugal Switch/Contacts Type..... External

### Main Specifications:

#### Workpiece Capacities

Minimum Workpiece Length..... 6 in.



### Operation Info

Number of Feed Speeds.....	4
Feed Speeds.....	9.5, 15, 25, 38 FPM
Swing.....	360 deg.
Vertical Movement.....	9 in.
Horizontal Movement.....	16 in.
Rotation.....	Forward, Reverse

### Roller Info

Number of Rollers.....	3
Roller Width.....	2 in.
Roller Diameter.....	4 in.
Roller Suspension.....	1 in.
Maximum Height Rollers Parallel Table Surface.....	7 in.
Centers Between Rollers.....	4-3/4 in.

### Construction Info

Roller.....	Synthetic Rubber
Housing.....	Cast Aluminum
Supports.....	Cast Iron
Column.....	Steel
Paint Type/Finish.....	Enamel

### Other

Column Diameter.....	2 in.
----------------------	-------

### Other Specifications:

Country of Origin .....	Taiwan
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	45 Minutes
Serial Number Location .....	Machine ID Label
ISO 9001 Factory .....	Yes

### Features:

Rollers are Spring Tensioned  
Heavy-Duty Gear Reduction with Hardened Gears  
Universal Positioning with Handle Locks





# SECTION 1: SAFETY

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

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



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



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



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

### **NOTICE**

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

## Safety Instructions for Machinery



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

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

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

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

### **ELECTRICAL EQUIPMENT INJURY RISKS.**

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

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

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



## **WARNING**

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Power Feeders

## WARNING

Serious injury or death can occur from getting hands, clothing, or jewelry entangled in moving parts of power feeder or being pulled into cutting tool on attached machinery. Workpieces ejected by attached machine can strike operator or bystanders with significant force, causing impact injuries. To minimize risk of injury, anyone operating this machine **MUST** completely heed hazards and warnings below.

**HAND SAFETY.** To reduce risk of accidental entanglement/pinch injuries between power feeder rollers and workpiece, or contact with blade/cutter of associated machine, keep hands away from rotating parts of power feeder. Turn power feeder and associated machine **OFF** before removing chips, sawdust, or cutoffs—DO NOT use your hands.

**INSTALLING GUARDS.** To reduce risk of kickback and accidental contact with blade/cutter of associated machine, always install guards, fences, and hold-downs before starting attached machine and power feeder. Repair or replace guards promptly if they become damaged.

**KICKBACK.** Occurs when workpiece is ejected from machine at a high rate of speed. To reduce risk of kickback-related injuries (blindness, broken bones, bruises, amputation, severe lacerations, and death), use quality workpieces and proper setup or maintenance of power feeder or associated machine. Never stand in path of workpiece.

**VERIFY EACH SETUP.** An improperly adjusted power feeder can increase risk of kickback, because it will continue feeding even if stock is not properly positioned for cut. Ensure that power feeder is set up correctly and firmly secured before feeding workpiece.

**FEATHERBOARD.** When cutting long or large stock that is difficult to feed properly, use a featherboard with power feeder (on the infeed side) to maintain even pressure and control of workpiece against fence, and to help reduce risk of kickback.

**FEED WORKPIECE PROPERLY.** To reduce risk of kickback, verify blade or cutter of associated machine is at full speed before feeding stock with power feeder. Avoid feeding workpiece too quickly. Always verify power feeder wheels are slightly lower than workpiece to ensure it will not slip during cutting operation. Stop power feeder **BEFORE** stopping cutting tool.

**WORKPIECE SUPPORT.** Loss of workpiece control while feeding can increase risk of kickback. Support workpiece continuously during operation as required. Use auxiliary stands or support tables for long or wide stock.

**ADJUSTMENTS/MAINTENANCE.** Make sure power feeder and associated machine are turned **OFF**, disconnected from power, and all moving parts are completely stopped before doing adjustments or maintenance.

**ATTACHED MACHINERY.** Follow all warnings and safety information for attached machine doing cutting work.

## 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

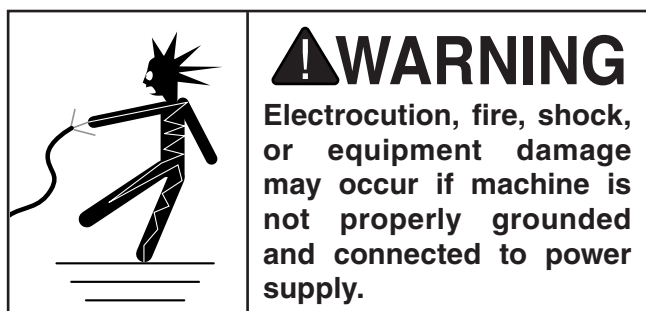
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



# SECTION 2: POWER SUPPLY

## Availability

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



## Full-Load Current Rating

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

### Full-Load Current Rating at 220V ..... 4 Amps

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

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

## Circuit Requirements for 220V

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

**Nominal Voltage ..... 208V, 220V, 230V, 240V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 15 Amps**  
**Plug/Receptacle ..... NEMA 6-15**  
**Cord ..... “S”-Type, 3-Wire, 14 AWG, 300 VAC**

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

## ! CAUTION

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

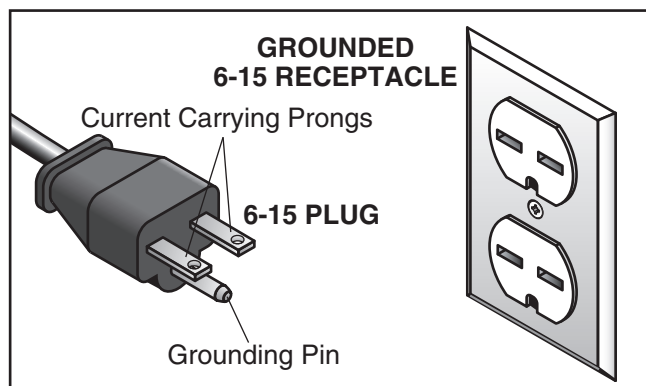
**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel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



## Grounding Instructions

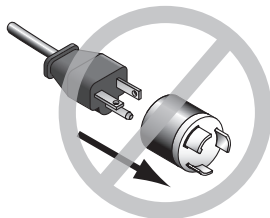
This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

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



**Figure 3.** Typical 6-15 plug and receptacle.

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

## Extension Cords

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

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

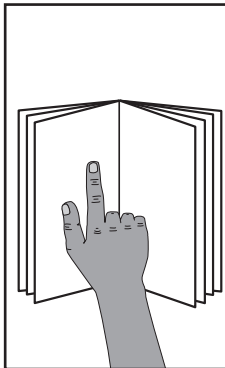
Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

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



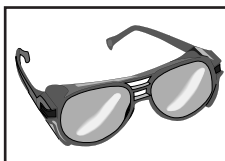


# SECTION 3: SETUP



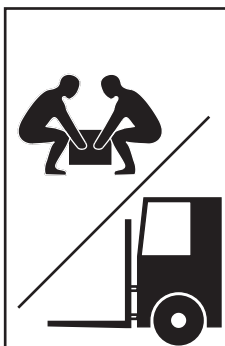
## **!WARNING**

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



## **!WARNING**

Wear safety glasses during the entire setup process!



## **!WARNING**

### **HEAVY LIFT!**

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

## Needed for Setup

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

Description	Qty
• Safety Glasses .....	1
• Cleaner/Degreaser .....	As Required
• Medium-Grade Thread Locking Liquid.....	1
• Clean Rags.....	As Required
• Disposable Gloves .....	1
• Hex Wrench 6mm.....	1
• Table Mounting Hardware .....	1
• Gear Oil 80-90W .....	1
• 6-15 Plug .....	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.

### Inventory (Figures 4–5)

	Qty
A. Power Feeder Assembly .....	1
B. Extra 26T/34T Gears (Behind Cover)....	1 Ea
C. Elbow Joint Assembly .....	1
D. Base and Column Assembly .....	1
E. Crank and Leadscrew Assembly.....	1
F. T-Handle .....	1
G. Horizontal Column Assembly .....	1
H. Base Bolt Pattern Template.....	1
I. Cap Screws M8-1.25 x 20 .....	2
J. Handcrank Handles.....	2
K. Flat Washer 13mm .....	1
L. Hex Wrench 4mm.....	1

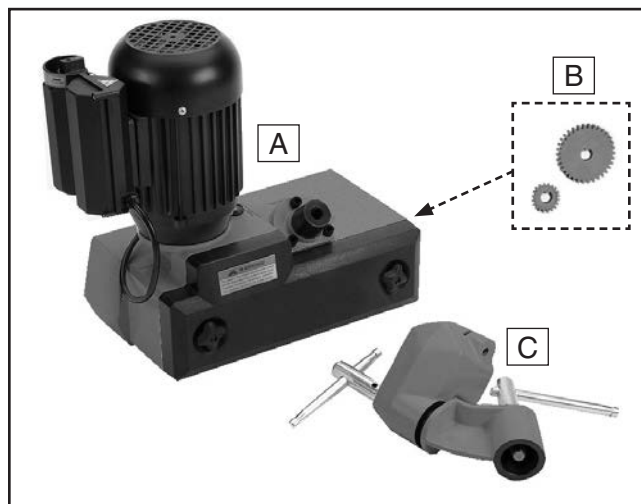


Figure 4. Power feeder inventory.

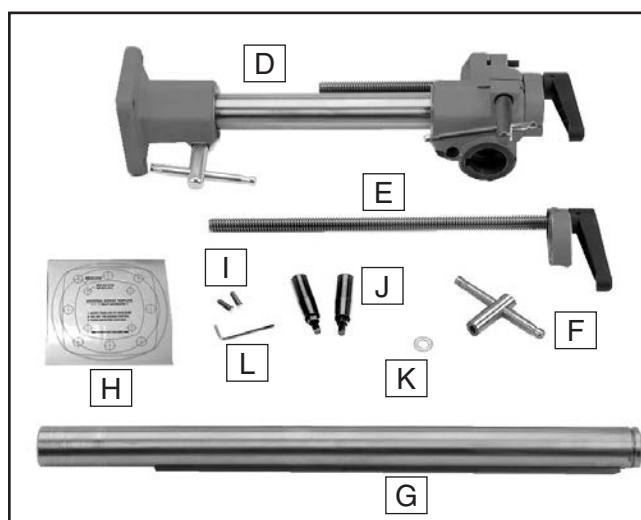


Figure 5. Base inventory.



# Cleanup

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

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

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

## Before cleaning, gather the following:

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

## Basic steps for removing rust preventative:

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

## NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

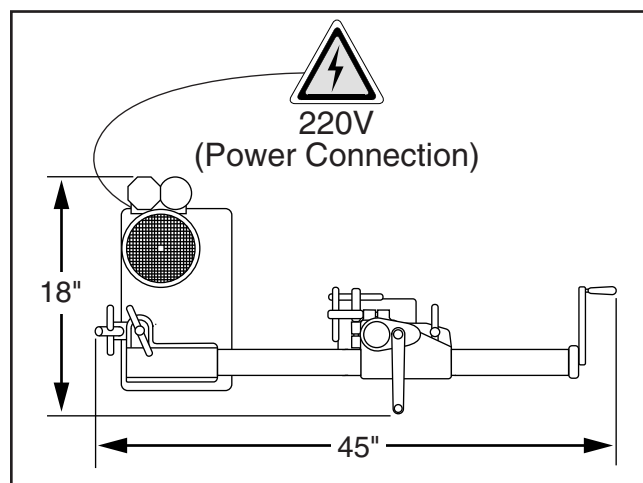
# Site Considerations

## Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

## Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.



**Figure 6.** Minimum working clearances.

**Note:** Power feeder can rotate 360° around the vertical column, so be sure to situate machine so it can freely rotate. The machine is shown here with the overarm shaft fully extended.

	<p><b>CAUTION</b></p> <p>Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
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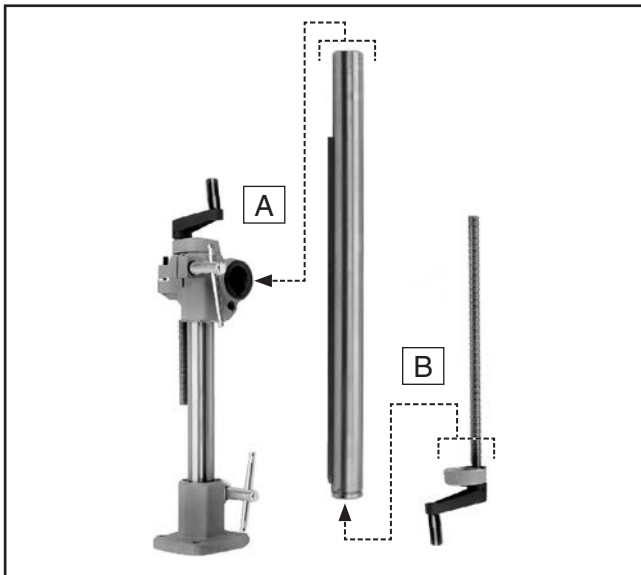
# Assembly

## WARNING

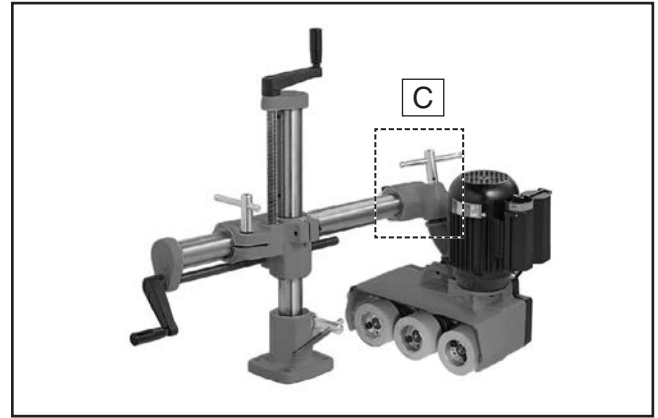
You **MUST** assemble all guards, fences, and hold-downs before starting your machine or power feeder. Failure to heed this warning could result in serious personal injury.

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 correctly position this power feeder on your table top, completely assemble the power feeder first in the order of **A**, **B** and **C** as shown in **Figures 7–8**. Next, refer to **Base Mounting** on **Page 17**. With the power feeder unit completely assembled, it will be easier to locate where on the table top you will need to drill your base mounting holes, so you can take advantage of the full range of power feeder swing and adjustments.



**Figure 7.** Stand assembly.



**Figure 8.** Assembled unit.

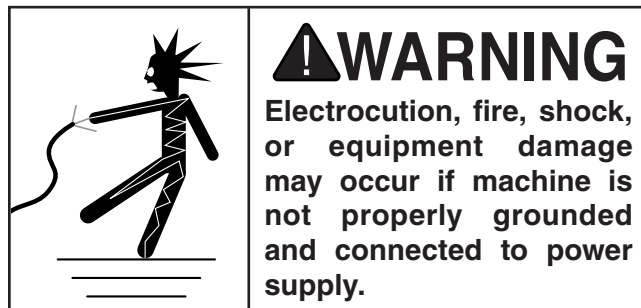
**Tip:** We recommend using a set of C-clamps to temporarily secure the base while assembling the power feeder to prevent it from tipping. You will mount the power feeder to the machine table after completing the assembly process. Refer to **Base Mounting** on **Page 17** for specific details.

# Power Connection

---

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual, and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly.

Always make sure the power switch on the machine is turned OFF (or the OFF button is pushed in) before connecting power.



## Connecting Plug to Power Cord

To connect plug to power cord, install 6-15 plug on end of power cord per plug manufacturer's instructions. If no instructions were included, use wiring diagram on **Page 33**.

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



# Base Mounting

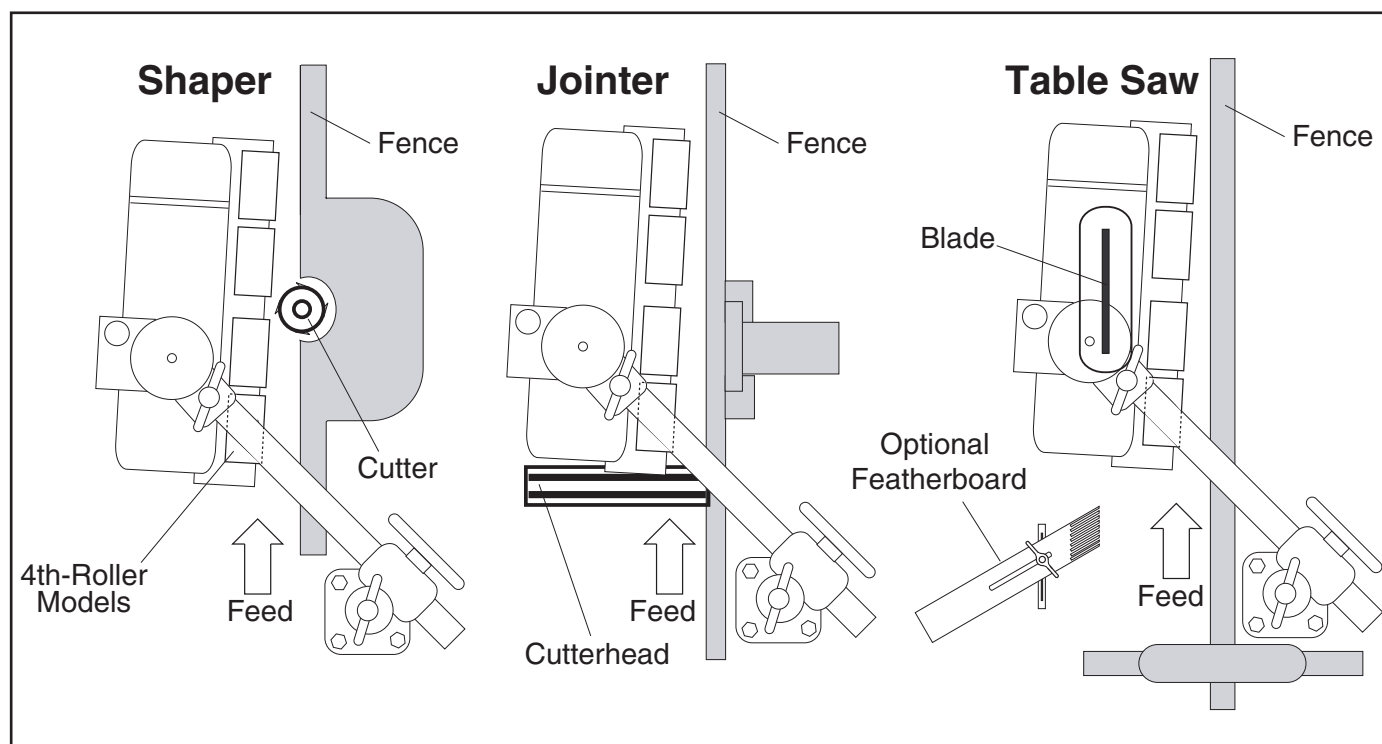
Position the power feeder on the table top to determine where to drill the base mounting holes in order to maximize power feeder swing and adjustment options.

Use the included base-bolt pattern template to align the mounting holes. Consider the available mounting choices for your needs: **Through-Bolt Mounting** and **Direct Mounting** (discussed on Page 18).

With either mounting choice, leave room to operate the hand cranks and lock levers to position the rubber rollers parallel with the table surface and approximately  $\frac{1}{8}$ " lower than the thickness of the workpiece.

Also, aim the front of the power feeder slightly towards the machine fence (see **Figure 9**) with approximately  $1^\circ$  to  $1.5^\circ$  toe-in toward the machine fence, so the rubber rollers lightly push the workpiece against the fence during cutting operations.

If cutting long or large stock that is difficult to feed properly, use a featherboard *before* the power feeder (on the infeed side) to maintain even pressure and control of the workpiece against the fence.



**Figure 9.** Typical power feed mounting on a shaper, jointer, and table saw.



# Mounting Options

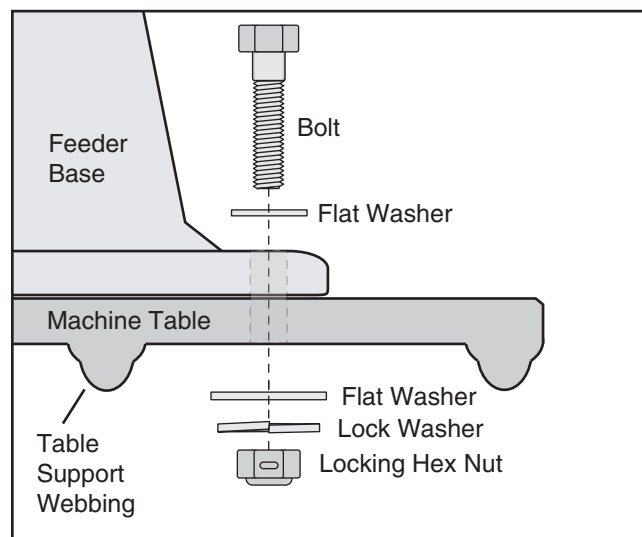
To correctly position this power feeder on your table top, completely assemble the power feeder first, then refer to this section and mount your base to the table using one of the two methods below. The reason for this order is that with the power feeder unit completely assembled, it will be easier to locate where on the table top you will need to drill your base mounting holes, so you can take advantage of the full range of power feeder swing and adjustments.

## Through-Bolt Mounting

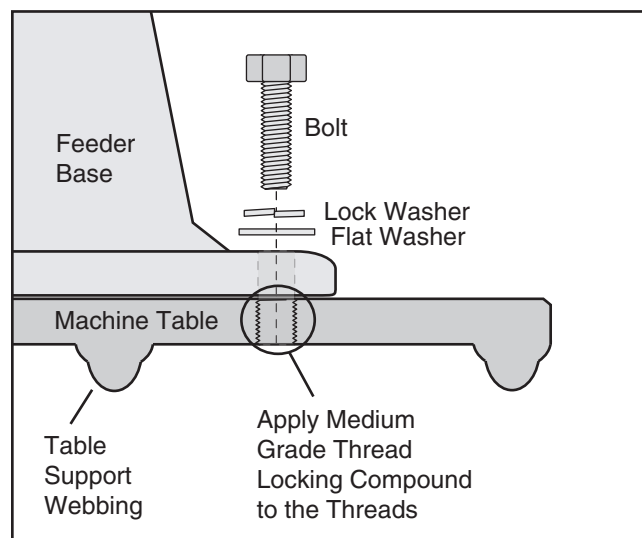
We recommend that you mount your new power feeder to the machine table with through bolts, nuts, and washers (see **Figure 10**). This option will give the most rigidity and clamping strength to prevent the feeder base from twisting out of alignment during use. However, if under-table support webs interfere with washer or nut locations under the table, you must use an optional clamping kit, or drill and thread holes directly into the table as described in **Direct Mounting**.

## Direct Mounting

Use the included mounting template to drill and tap your table, so the power feeder base can be directly mounted to the table surface (see **Figure 11**). If the table is thinner than  $\frac{3}{8}$ " thick where the threaded holes would be drilled and tapped, or if support webbing is in the way, the threads may strip or loosen as the power feeder is used. Thread locking compound will not cure this situation. Revert to the **Through-Bolt Mounting** option. In any case, make sure to use a medium-grade liquid thread locking compound on all threads.



**Figure 10.** Through-bolt mounting.



**Figure 11.** Direct mounting.



# Test Run

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

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

The Test Run consists of verifying the following:  
1) The motor powers up and runs correctly, and 2) the feed direction switch 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 the machine:

1. Clear all setup tools away from machine.

2. Make sure gearbox oil level is full. See **Lubrication** on **Page 26** for details.
3. Adjust and lock power feeder so wheels are held approximately one inch above table and nothing will interfere with wheel rotation.
4. Connect power feeder to power supply and use feed direction switch (see **Figure 12**) to test operation in both directions. The motor should run smoothly and without unusual problems or noises.

Congratulations! The Test Run is complete.

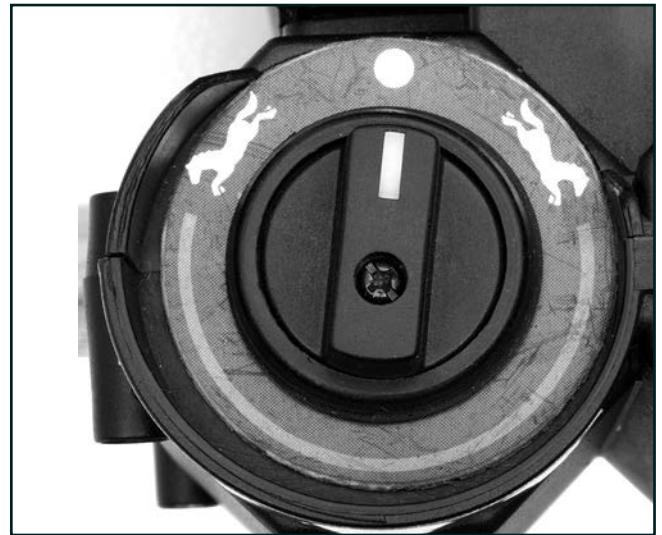


Figure 12. Feed direction switch.

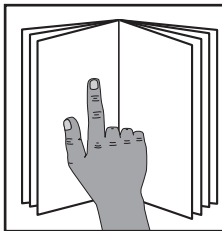


# SECTION 4: OPERATIONS

## Operation Overview

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

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

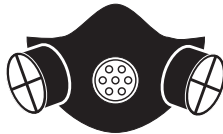


### **WARNING**

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

### **WARNING**

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



### **NOTICE**

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

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

1. Examines workpiece to make sure it is suitable for cutting operation.
2. Adjusts machine cutter/blade and fence for desired operation.
3. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through cutter/blade without interference.
4. Loosens upper elbow joint lock and points power feeder 1° to 1.5° toward machine fence, so rubber rollers will lightly push workpiece against fence during cutting operations, then tightens elbow lock.
5. Loosens vertical travel lock and lower elbow joint lock, then adjusts position of power feeder so rubber rollers are parallel with table surface and 1/8" lower than thickness of workpiece, then tightens all locks.
6. Checks to make sure rollers are clear of cutter or blade.
7. (Optional) positions featherboard on infeed side for cutting long or large stock that is difficult to feed properly.
8. Uses feed direction switch to select correct feed direction for operation.
9. Ensures feed speed is correct for operation.
10. Puts on safety glasses and a respirator.
11. Starts machine, then starts power feeder. Feeds stock into power feeder, maintaining firm pressure on workpiece against table and fence.
12. When operation is complete, stops power feeder, then stops machine.



# Basic Use & Care

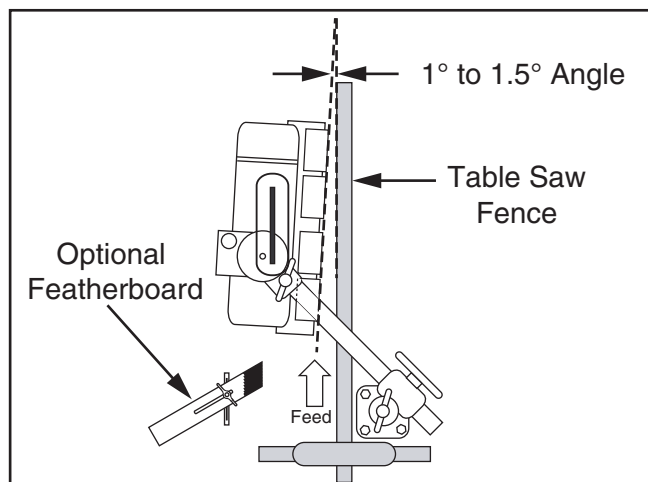
## WARNING

**You MUST assemble all guards, fences, and hold-downs before starting your machine or power feeder. Failure to heed this warning could result in amputation or death!**

Power feeders reduce kickback hazards and improve cutting results by feeding in a consistent and stable manner. Remember, **DO NOT** stand in the path of potential kickback. When not in use, support the power feeder with a wooden block so the rubber rollers are raised above the table and do not compress from the weight of the power feeder.

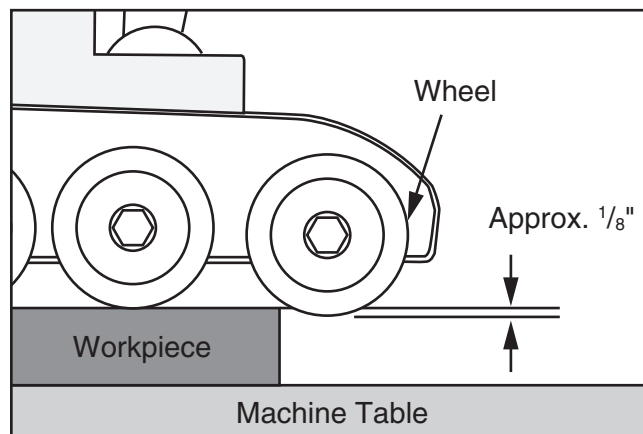
The lock levers and hand cranks allow you to adjust the power feeder tracking and height to accommodate many workpiece sizes. Before loosening any lock lever, always support the power feeder with a block of wood so the power feeder does not drop and cause damage.

Adjust the power feeder so it is toed-in approximately  $1^{\circ}$  to  $1.5^{\circ}$  towards the machine fence, as shown in **Figure 13**. This adjustment will ensure that the power feeder rollers slightly push the workpiece against the fence during cutting operations. Use a featherboard on the infeed side to assist with feeding long or large stock.



**Figure 13.** Example of power feeder toe-in on a table saw (4-roller model shown).

Next, adjust the power feeder so the rubber rollers are parallel with the table surface and approximately  $\frac{1}{8}$ " lower than the thickness of the workpiece, as shown in **Figure 14**. This ensures that the workpiece will not slip or hang during a cut. Always double check that the power feeder rollers are slightly lower than the workpiece before you begin feeding operations. Otherwise, the workpiece may slip and kick back.



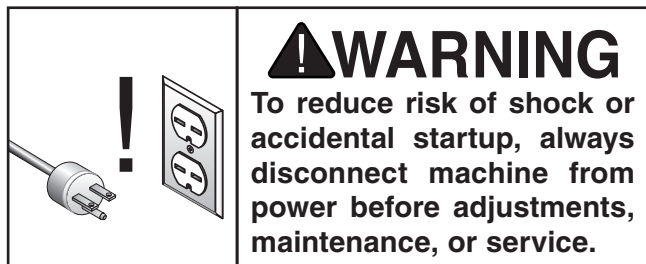
**Figure 14.** Rollers adjusted approximately  $\frac{1}{8}$ " below workpiece.





# Changing Feed Speed

The Model G4179 power feeder has the ability to feed a workpiece at four different feed rates: 9.5, 15, 25, and 38 feet per minute. These rates are achieved by changing the combination of change gears in the power feeder gearbox (see **Figure 15**).

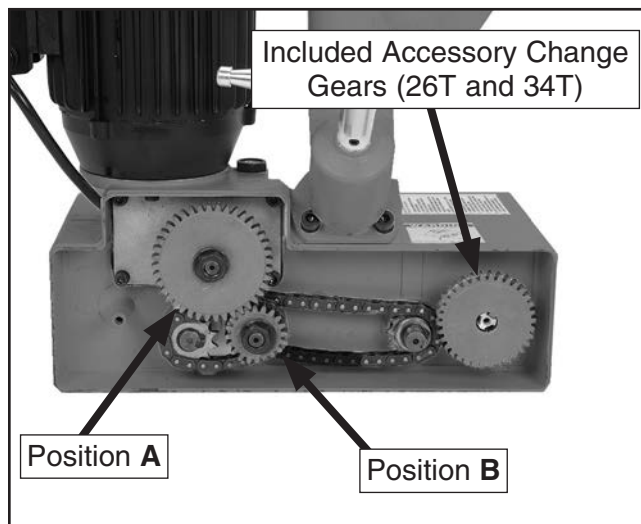


## To change feed speed:

1. Turn feed direction switch to OFF position.
2. DISCONNECT MACHINE FROM POWER!
3. Refer to change gear chart below to find gear combination for desired feed rate.


4. Remove gearbox cover and (2) 14mm hex nuts securing position **A** & **B** change gears to shafts.
5. Swap required gears in positions **A** & **B** shown in **Figure 15**.

**Note:** Accessory gear set is located underneath gearbox cover as shown in **Figure 15**.



**Figure 15.** Change gear locations.

6. Reinstall hex nuts and gearbox cover.



**Installed Change Gears:**  
**A, 20-Tooth + B, 40-Tooth = 9.5 Feet Per Minute**  
**A, 40-Tooth + B, 20-Tooth = 38 Feet Per Minute**

**Included Accessory Change Gears:**  
**A, 26-Tooth + B, 34-Tooth = 15 Feet Per Minute**  
**A, 34-Tooth + B, 26-Tooth = 25 Feet Per Minute**

● = Motor OFF

**Figure 16.** Change gear chart.

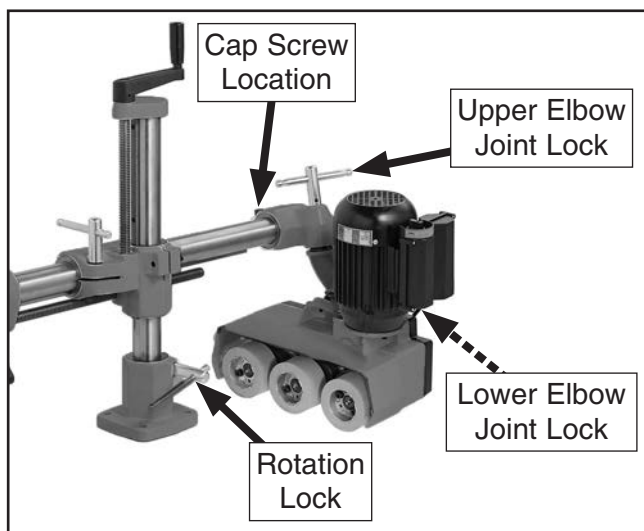




# Vertical/Incline Feeding

The Model G4179 can be positioned to feed workpieces so the rollers are angled relative to the machine fence at 45°, 90°, or another angle in between. For example, it can be positioned at 90° to feed stock against a fence, or it can be positioned at 45° or another angle such as when making bevel cuts on a jointer.

Use the controls shown in **Figure 17** to position the power feeder for incline feeding.



**Figure 17.** Location of controls for re-positioning power feeder for incline feeding.

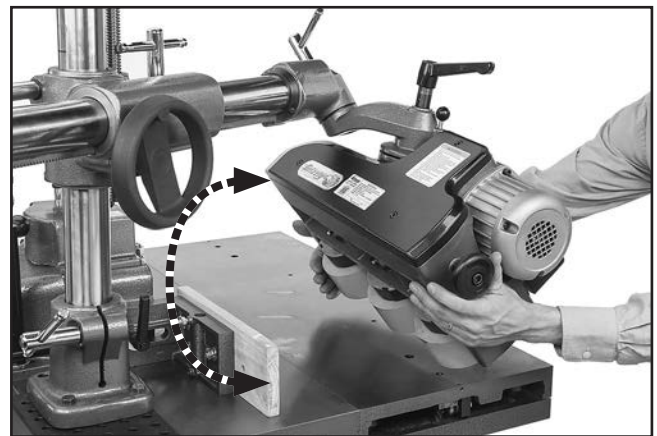
## Tools Needed

## Qty

Hex Wrench 10mm..... 1

To position power feeder for vertical/incline feeding:

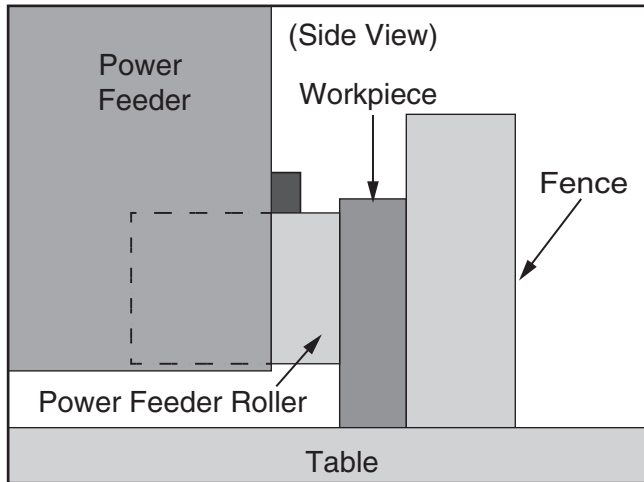
1. Loosen rotation lock and swing power feeder off of machine table (see **Figure 17**).
2. Loosen cap screw on upper elbow-joint, rotate upper elbow to desired angle, then tighten cap screw (see **Figure 17**) to secure setting.
3. Loosen upper and lower elbow joint locks (see **Figure 17**).
4. Rotate power feeder (flip it sideways) so it is oriented as shown in **Figure 18**, then move it back over table and up against fence.



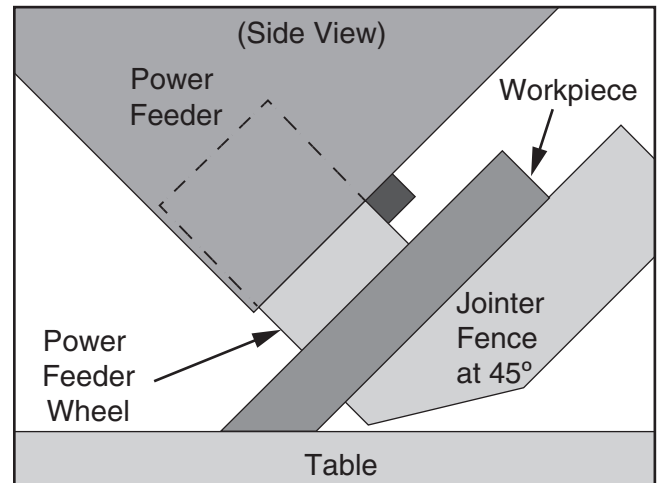
**Figure 18.** Example of rotating power feeder for vertical or incline feeding.



5. Lower power feeder and adjust it as needed so rollers are parallel to workpiece, and workpiece is firmly against fence, as shown in **Figures 19–20**.



**Figure 19.** Example of power feeder set up for 90° feeding operation on a shaper.



**Figure 20.** Example of power feeder set up for 45° feeding operation on a jointer.

6. Tighten all locks on power feeder and vertical column.
7. Repeat **Steps 1–6** in reverse order to reposition power feeder for non-angle feeding operations.



# SECTION 5: ACCESSORIES

## **! WARNING**

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

## **NOTICE**

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

### **D3122—Shop Fox® Push Stick**

Measuring 13½" overall, this push stick allows the operator to keep his hands a safe distance away from the blade or cutter.



Figure 21. D3122 Shop Fox® Push Stick.

### **D3096—Shop Fox® Featherboard**

Designed to lock into a standard ⅜" x ⅜" miter slot, this featherboard is fully adjustable to accommodate a wide range of workpieces. Reduce the likelihood of kickback with this convenient accessory.



Figure 22. D3096 Shop Fox® Featherboard.

### **T26419—Syn-O-Gen Synthetic Grease**

Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.



Figure 23. Recommended product for machine lubrication.

### **G5562—SLIPIT® 1 Qt. Gel**

### **G5563—SLIPIT® 12 Oz. Spray**

### **G2871—Boeshield® T-9 12 Oz. Spray**

### **G2870—Boeshield® T-9 4 Oz. Spray**

### **H3788—G96® Gun Treatment 12 Oz. Spray**

### **H3789—G96® Gun Treatment 4.5 Oz. Spray**



Figure 24. Recommended products for protecting unpainted cast iron/steel part on machinery.

### **G4180—Synthetic Rubber Roller for G4179**

These 2" wide x 4" diameter Rubber Rollers are made from synthetic rubber and are for use with the G4179 ½ HP Power Feeder.

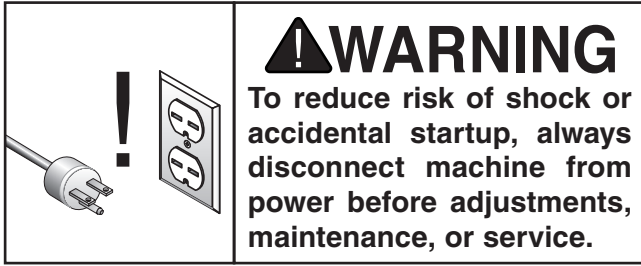


Figure 25. G4180 Replacement Roller.

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



# SECTION 6: MAINTENANCE



## Schedule

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

### Ongoing

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

- Loose mounting bolts.
- Damaged rollers.
- Worn or damaged switch, cord, and plug.
- Any other unsafe condition.

### Daily Maintenance

- Lubricate chains and sprockets (**Page 28**).
- Lubricate vertical travel leadscrew (**Page 28**).
- Lubricate lock levers (**Page 28**).
- Lubricate overarm rack (**Page 28**).

### Monthly Maintenance

- Lubricate roller and chain grease fittings (**Page 27**).
- Lubricate gearbox—initial month (**Page 27**).

### Every 6 Months

- Lubricate gearbox (**Page 27**).

## Cleaning & Protecting

Cleaning the Model G4179 is relatively easy. Frequently blow off sawdust with compressed air. This is especially important for internal working parts and the motor. Dust build-up around the motor will decrease its lifespan. If rollers become loaded up with pitch, oil, or other residues, wipe with a clean rag and soap and water. Keep mineral spirits away from plastic parts or painted surfaces to avoid damage.

## Lubrication

Other than the lubrication points covered in this section, all other bearings are internally lubricated and sealed at the factory. Simply leave them alone unless they need to be replaced.

Before performing any lubrication task, **DISCONNECT MACHINE FROM POWER!**

**IMPORTANT:** Before adding lubricant, clean any debris and grime from fill hole/grease fitting and immediate area to prevent contamination of new lubricant.

Use the schedule below and the following instructions to properly lubricate the other components that require lubrication.

Lubrication Task	Frequency (Hours of Operation)	Page Ref.
Roller Grease Fittings	200 Hrs.	<b>27</b>
Gearbox	1000 Hrs.	<b>27</b>
Chain & Sprockets	8 Hrs.	<b>28</b>
Vertical Travel Leadscrew	8 Hrs.	<b>28</b>
Lock Levers	8 Hrs.	<b>28</b>
Overarm Rack	8 Hrs.	<b>28</b>

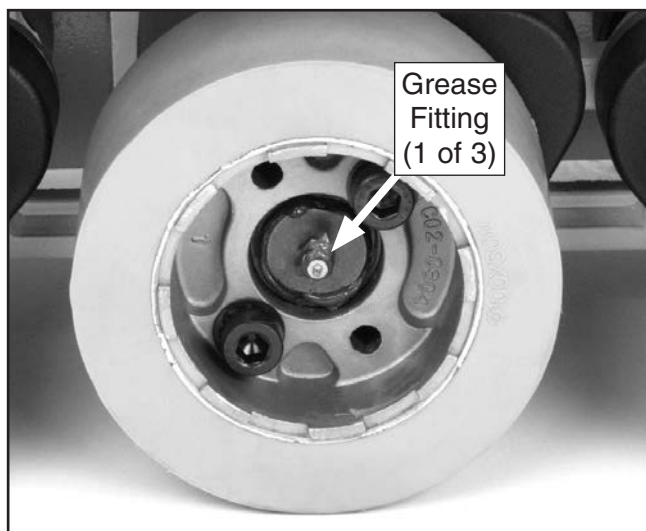


Items Needed	Qty
NLGI#2 Grease or Equivalent .....	As Needed
ISO 32 Oil or Equivalent.....	As Needed
80-90W Gear Oil .....	As Needed
Clean Shop Rags .....	As Needed
Mineral Spirits.....	As Needed
Brushes .....	As Needed
1-Gallon Catch Pan .....	1
Grease Gun.....	1
Open-End Wrench 19mm.....	1
Hex Wrench 5mm.....	1

## Roller Grease Fittings

Lube Type..... T26419 or NLGI#2 Equivalent  
Amount ..... 1–2 Pumps.  
Lubrication Frequency .....200 Hrs. of Operation  
Grease Gun..... 1

Wipe the roller grease fittings clean and lubricate with one pump from a grease gun filled with NLGI#2 grease (see **Figures 26**).



**Figure 26.** Location of roller grease fittings.

## Gearbox

Lube Type.....80-90W Gear Oil  
Amount .....4.05 Oz.

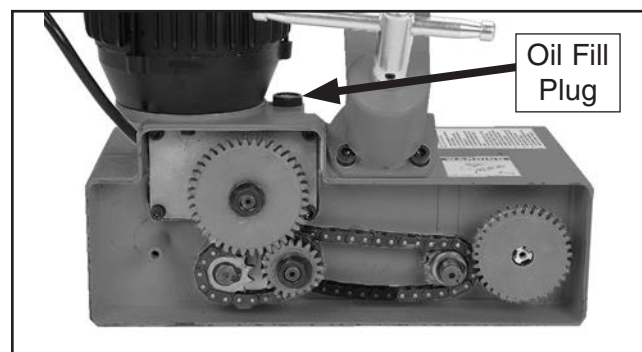
Lubrication Frequency:

- 200 Hrs./First Month of Operation
- 1000 Hrs./6 Months of Operation

The gearbox should be drained and refilled after the first month or 200 hours of use. For the remaining life of the power feeder, change oil every six months or 1000 hours of use.

### To change gearbox oil:

1. DISCONNECT MACHINE FROM POWER!
2. Rotate power feeder off of machine table, remove gearbox cover, and tighten rotation lock.
3. Rotate power feeder upside down so chains face down.
4. Place drain pan under fill plug labeled "OIL" (see **Figure 27**), then remove fill plug and drain oil.



**Figure 27.** Location of gearbox fill plug/oil drain and sight glass.

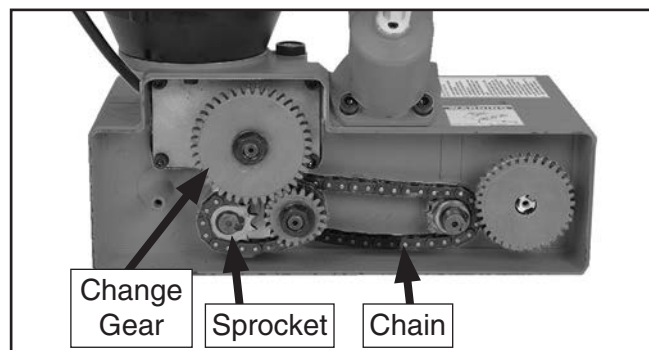
5. Rotate power feeder 180 degrees so chains are face up, then fill gearbox with oil until oil level is 1" below oil fill port.
6. Re-install gearbox cover and rotate power feeder back into place for operation.



## Chain & Sprockets

Lube Type..... T26419 or NLGI#2 Equivalent  
 Amount .....Thin Coat  
 Lubrication Frequency .....8 Hrs. of Operation

To prevent rust and binding, brush the sprockets and chains (see **Figure 28**) with a light film of NLGI#2 grease. It will be necessary to remove the gearbox cover to access the chain and sprockets.

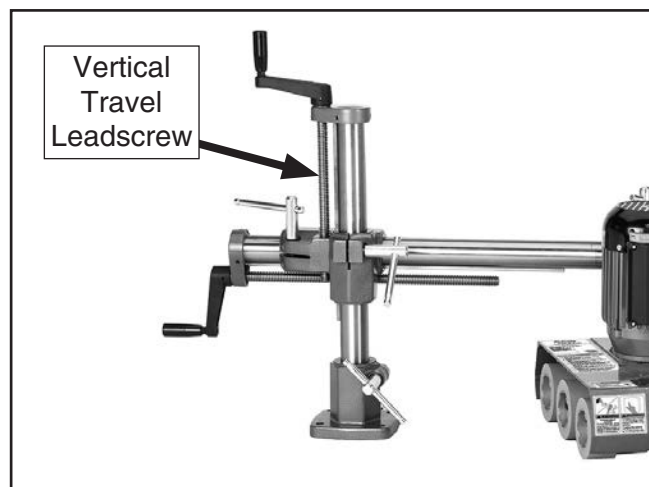


**Figure 28.** Location of chain and sprockets (gearbox cover removed).

## Vertical Travel Leadscrew

Lube Type..... T26419 or NLGI#2 Equivalent  
 Amount .....Thin Coat  
 Lubrication Frequency .....8 Hrs. of Operation

Use mineral spirits to clean any debris and built-up grime from the vertical travel leadscrew shown in **Figure 29**, then wipe it dry. Brush a thin coat of lubricant on the threads of the leadscrew, then rotate leadscrew through its full path to distribute the grease.

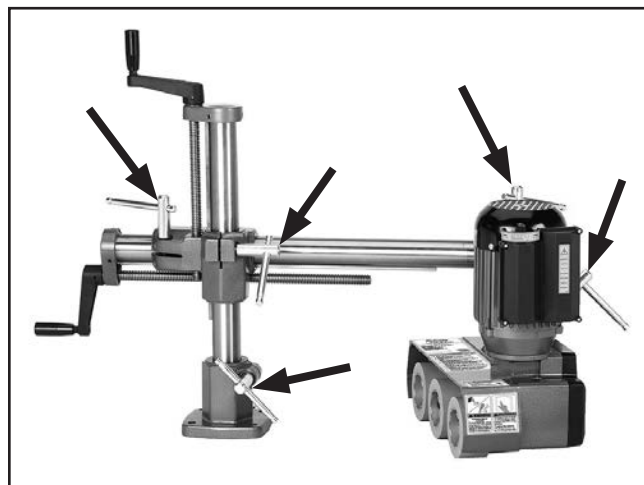


**Figure 29.** Vertical travel leadscrew.

## Lock Levers

Lube Type..... ISO 32 or Equivalent  
 Amount .....Thin Coat  
 Lubrication Frequency .....8 Hrs. of Operation

To prevent rust and binding, periodically clean and oil all lock-lever and leadscrew threads (see **Figure 30**) with light machine oil.

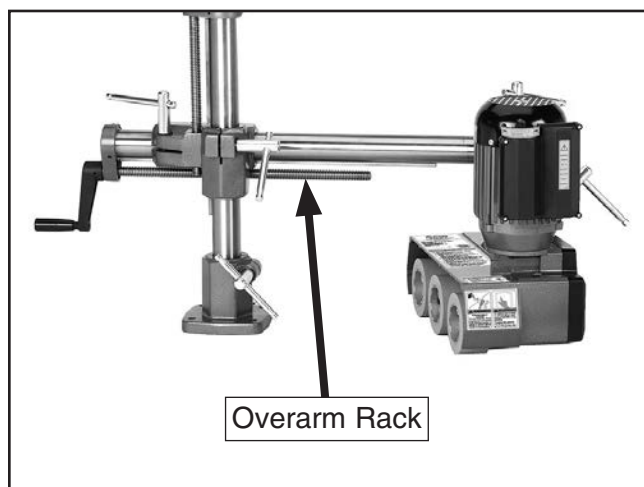


**Figure 30.** Location of levers to lubricate.

## Overarm Rack

Lube Type..... T26419 or NLGI#2 Equivalent  
 Amount .....Thin Coat  
 Lubrication Frequency .....8 Hrs. of Operation

Clean the overarm rack teeth (see **Figure 31**) with mineral spirits, shop rags, and a brush. When dry, use a brush to apply a thin coat of grease to the teeth, then move overarm back and forth several times to distribute the grease.



**Figure 31.** Overarm rack.

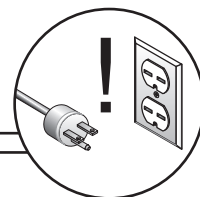




# SECTION 7: SERVICE

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

## Troubleshooting



### Motor & Electrical

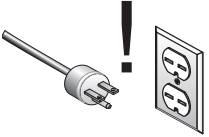
Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> <li>1. Incorrect power supply voltage or circuit size.</li> <li>2. Plug/receptacle at fault/wired incorrectly.</li> <li>3. Power supply circuit breaker tripped or fuse blown.</li> <li>4. Start capacitor at fault</li> <li>5. Wiring broken, disconnected, or corroded.</li> <li>6. Motor start/direction switch at fault.</li> <li>7. Motor or motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Ensure correct power supply voltage and circuit size.</li> <li>2. Test for good contacts; correct the wiring.</li> <li>3. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.</li> <li>4. Test/replace if at fault.</li> <li>5. Fix broken wires or disconnected/corroded connections.</li> <li>6. Inspect/replace if at fault.</li> <li>7. Test/repair/replace.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Motor wired incorrectly.</li> <li>2. Plug/receptacle at fault.</li> <li>3. Motor start/direction switch at fault.</li> <li>4. Pulley/sprocket slipping on shaft.</li> <li>5. Motor overheated, tripping machine circuit breaker.</li> <li>6. Run capacitor at fault</li> <li>7. Extension cord too long.</li> <li>8. Motor or motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Wire motor correctly (<b>Page 33</b>).</li> <li>2. Test for good contacts/correct wiring.</li> <li>3. Inspect/replace if at fault.</li> <li>4. Tighten/replace loose pulley/key/shaft.</li> <li>5. Clean motor, let cool, and reduce workload. Reset breaker.</li> <li>6. Test/repair/replace.</li> <li>7. Move machine closer to power supply; use shorter extension cord.</li> <li>8. Replace motor.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor or component loose.</li> <li>2. Incorrectly mounted to workbench.</li> <li>3. Motor fan rubbing on fan cover.</li> <li>4. Motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace damaged or missing bolts/nuts or tighten if loose.</li> <li>2. Adjust or tighten mounting hardware.</li> <li>3. Fix/replace fan cover; replace loose/damaged fan.</li> <li>4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> </ol>



## Feeding Operations

Symptom	Possible Cause	Possible Solution
Workpiece jams when feeding under rollers.	<ol style="list-style-type: none"> <li>1. Rollers positioned too low.</li> <li>2. Feeder at wrong angle.</li> </ol>	<ol style="list-style-type: none"> <li>1. Raise feeder.</li> <li>2. Adjust angle (<b>Page 23</b>).</li> </ol>
Workpiece slips while passing beneath rollers.	<ol style="list-style-type: none"> <li>1. Rollers positioned too high.</li> <li>2. Workpiece too dusty.</li> <li>3. Rollers dirty or oily.</li> <li>4. Feed speed too fast.</li> <li>5. Worn roller(s).</li> <li>6. Rollers loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Lower power feeder roller <math>\frac{1}{8}</math>" lower than height of workpiece (<b>Page 21</b>).</li> <li>2. Wipe dust off workpiece.</li> <li>3. Clean roller surface with soap and warm water.</li> <li>4. Reduce feed speed.</li> <li>5. Replace roller(s) (<b>Page 31</b>).</li> <li>6. Tighten rollers.</li> </ol>
Workpiece cut is burnt.	<ol style="list-style-type: none"> <li>1. Feed speed too slow.</li> <li>2. Dull cutter or blade.</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase feed speed.</li> <li>2. Replace with sharp cutter or blade.</li> </ol>
Rough finish or chipped grain on workpiece.	<ol style="list-style-type: none"> <li>1. Feed speed too fast.</li> <li>2. Dull cutter or blade.</li> <li>3. Power feeder angle not toed-in to keep workpiece against fence.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed speed.</li> <li>2. Replace with sharp cutter or blade.</li> <li>3. Adjust power feeder so it is toed in <math>1^{\circ}</math> to <math>1.5^{\circ}</math> toward fence (<b>Page 21</b>).</li> </ol>
Workpiece hangs up/does not enter machine.	<ol style="list-style-type: none"> <li>1. Rollers positioned too high.</li> </ol>	<ol style="list-style-type: none"> <li>1. Lower power feeder roller <math>\frac{1}{8}</math>" lower than height of workpiece (<b>Page 21</b>).</li> </ol>

## Replacing Rollers



**! WARNING**

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Worn or damaged rollers are easily replaceable.

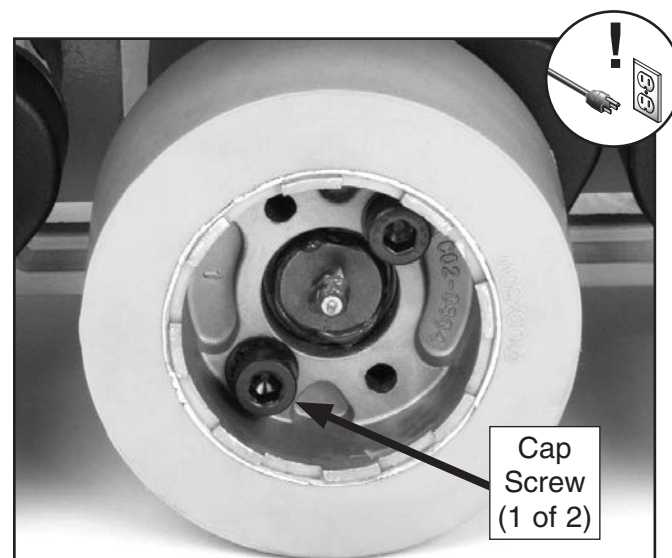
Contact Grizzly Customer Service at **(570) 546-9663** or visit **[www.grizzly.com/parts](http://www.grizzly.com/parts)** to order a replacement roller (Part #P4179526).

Tools Needed	Qty
Hex Wrench 5mm.....	1
Replacement Wheel (Part #P4179526) .....	1

### To replace a roller:

1. DISCONNECT MACHINE FROM POWER!

2. Remove (2) roller retaining cap screws (see **Figure 32**).



**Figure 32.** Wheel replacement.

3. Remove and replace roller.
4. Reinstall cap screws, and tighten in an alternating pattern until wheel is secure.





# SECTION 8: WIRING

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

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

## ⚠ WARNING

### Wiring Safety Instructions

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

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

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

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

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

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
















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

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

#### NOTICE

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

#### COLOR KEY

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



# Wiring Diagram

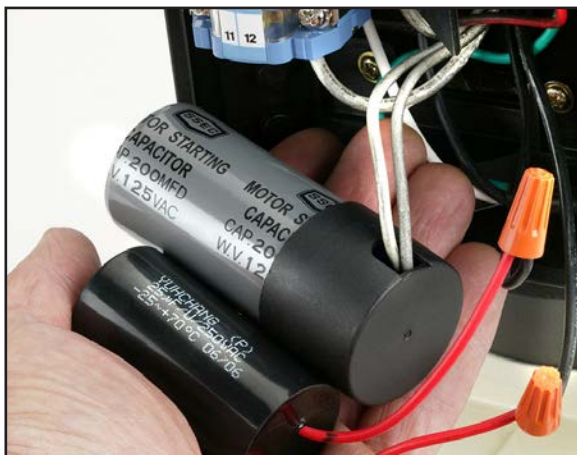
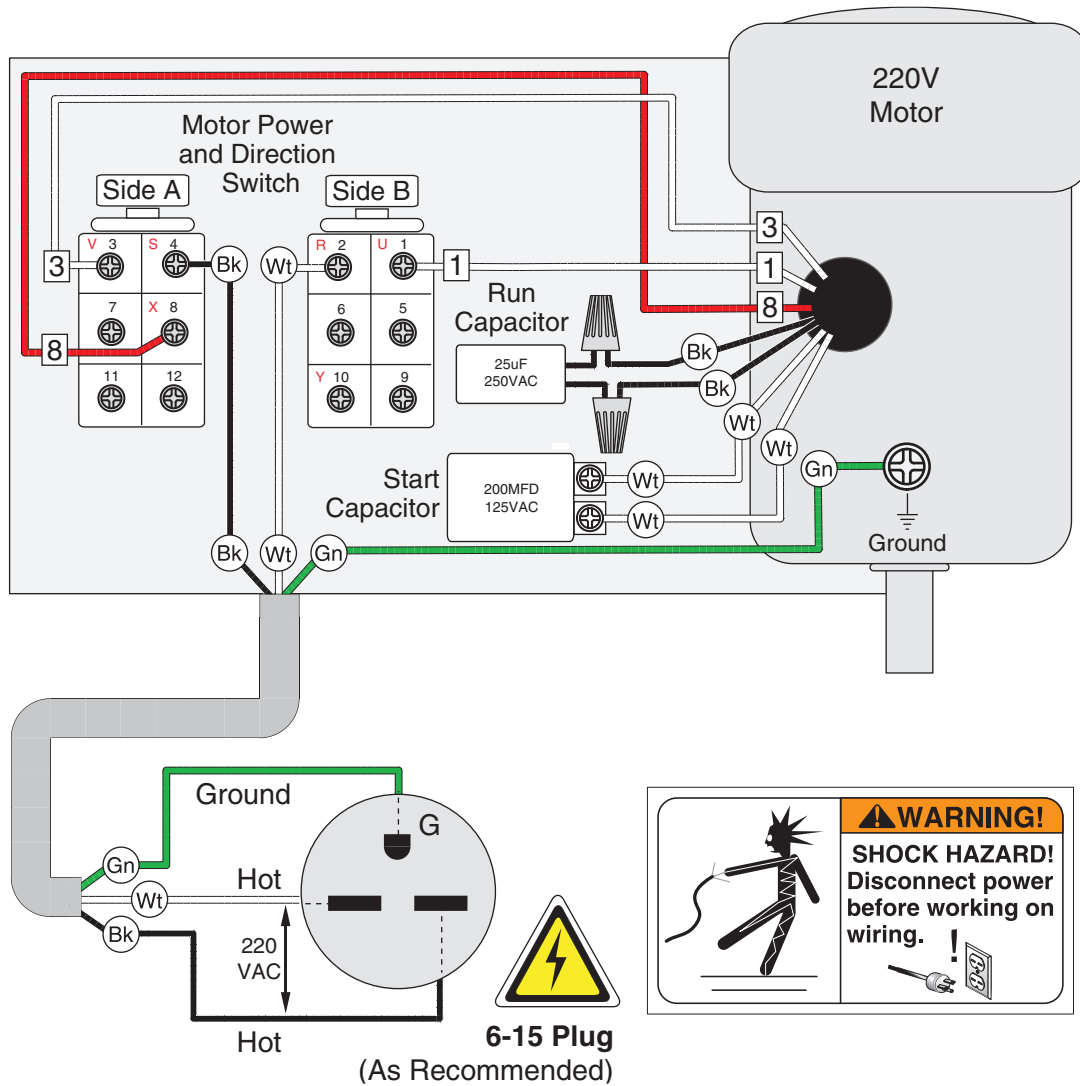


Figure 33. Motor capacitors.



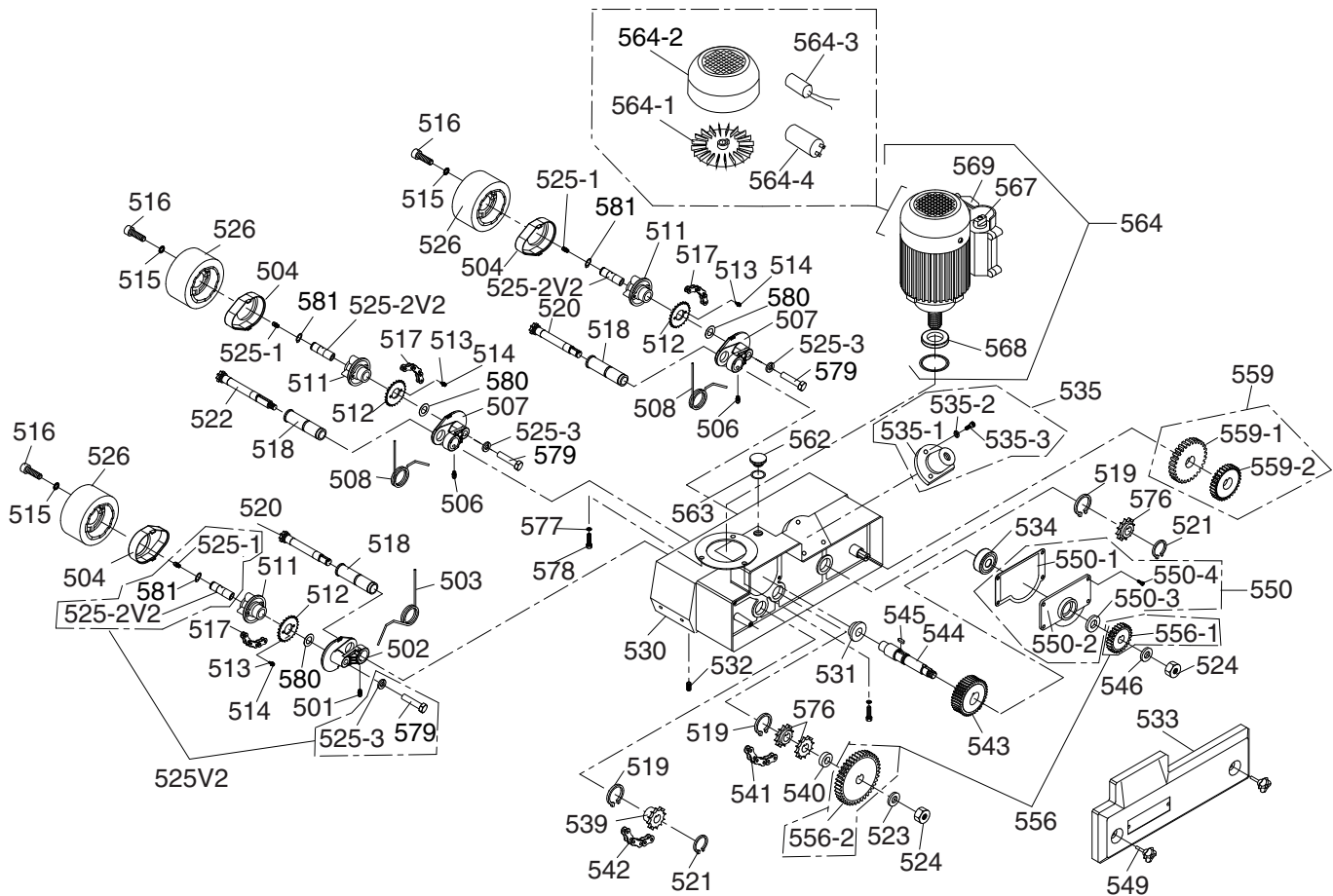
Figure 34. Motor power and direction switch.



## SECTION 9: G4179 PARTS

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

# Power Feeder



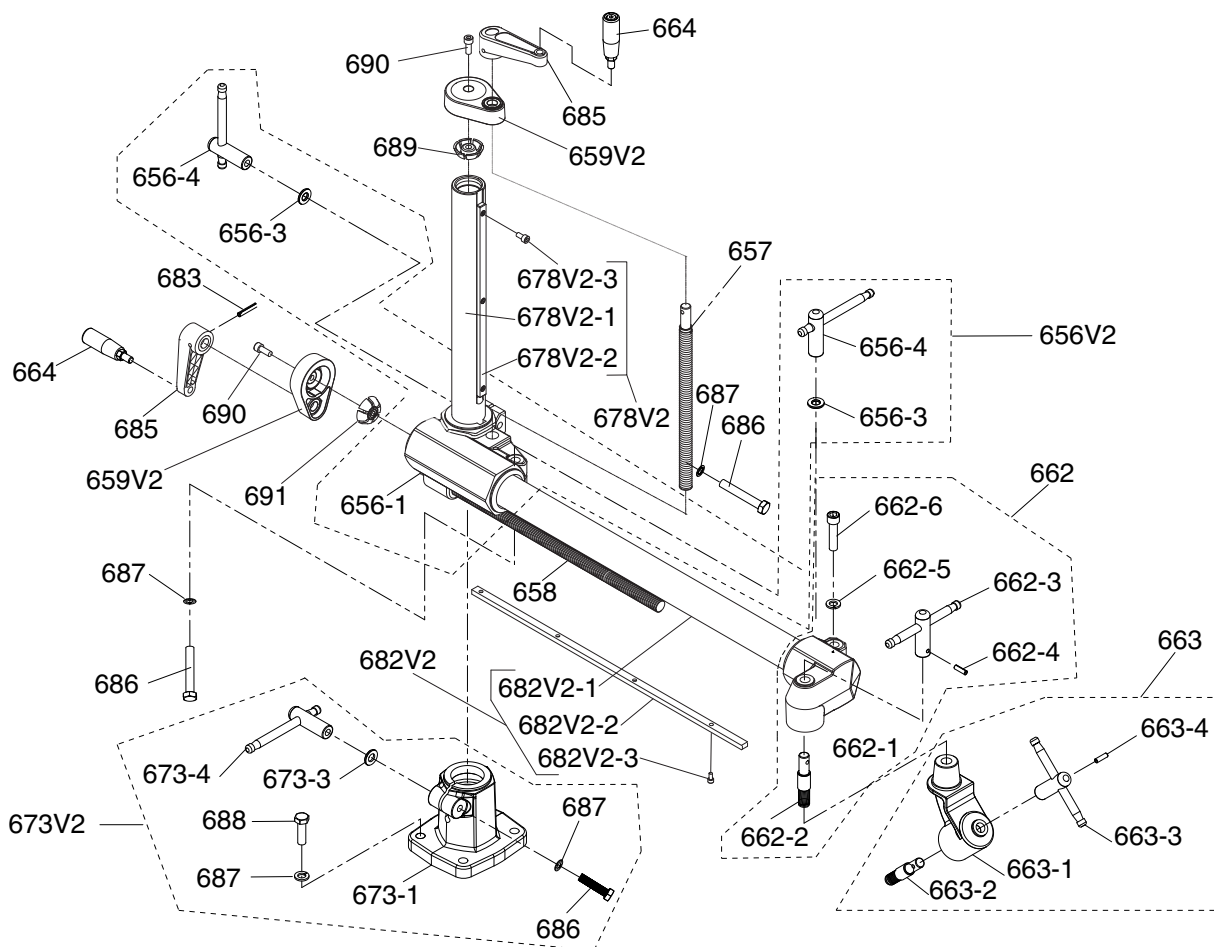
# Power Feed Parts List

REF	PART #	DESCRIPTION
501	P4179501	GREASE FITTING M6-1 STRAIGHT
502	P4179502	SPROCKET CASE
503	P4179503	TORSION SPRING (A) 3.5 x 100
504	P4179504	CASE COVER
506	P4179506	GREASE FITTING M6-1 STRAIGHT
507	P4179507	CASE SPROCKET
508	P4179508	TORSION SPRING (B) 3.5 X 100
511	P4179511	ROLLER BASE
512	P4179512	SPROCKET
513	P4179513	LOCK WASHER 5MM
514	P4179514	CAP SCREW M5-.8 X 16
515	P4179515	LOCK WASHER 8MM
516	P4179516	CAP SCREW M8-1.25 X 25
517	P4179517	CHAIN-(22S)
518	P4179518	TUBE
519	P4179519	EXT RETAINING RING 24MM
520	P4179520	SPROCKET SHAFT
521	P4179521	EXT RETAINING RING 13MM
522	P4179522	SPROCKET SHAFT
523	P4179523	FLAT WASHER 12MM
524	P4179524	HEX NUT M12-1.75
525V2	P4179525V2	SPINDLE ASSY-INT. THREADS V2.07.14
525-1	P4179525-1	GREASE FITTING M6-1 STRAIGHT
525-2V2	P4179525-2V2	ROLLER SPINDLE V2.06.14
525-3	P4179525-3	FLAT WASHER 12MM
526	P4179526	ROLLER
530	P4179530	HOUSING
531	P4179531	BUSHING
532	P4179532	SET SCREW M6-1 X 10
533	P4179533	GEAR COVER
534	P4179534	BALL BEARING 6203ZZ
535	P4179535	SWIVEL CONE ASSEMBLY
535-1	P4179535-1	CONE
535-2	P4179535-2	LOCK WASHER 8MM
535-3	P4179535-3	CAP SCREW M8-1.25 X 25
539	P4179539	SPROCKET

REF	PART #	DESCRIPTION
540	P4179540	SPACING COLLAR
541	P4179541	CHAIN (36S)
542	P4179542	CHAIN (22S)
543	P4179543	WORM GEAR
544	P4179544	WORM GEAR SHAFT
545	P4179545	KEY 6 X 6 X 12
546	P4179546	FLAT WASHER 12MM
549	P4179549	KNOB
550	P4179550	GEARBOX ASSEMBLY
550-1	P4179550-1	GASKET
550-2	P4179550-2	COVER
550-3	P4179550-3	OIL SEAL
550-4	P4179550-4	CAP SCREW M6-1 X 16
556	P4179556	GEAR SET 20T, 40T
556-1	P4179556-1	GEAR 20T
556-2	P4179556-2	GEAR 40T
559	P4179559	GEAR SET 26T, 34T
559-1	P4179559-1	GEAR 34T
559-2	P4179559-2	GEAR 26T
562	P4179562	OIL CAP
563	P4179563	O-RING 15.8 X 2.4 P16
564	P4179564	MOTOR 1/2HP 110V
564-1	P4179564-1	FAN
564-2	P4179564-2	FAN COVER
564-3	P4179564-3	R. CAPACITOR 25MFD 250VAC
564-4	P4179564-4	S. CAPACITOR 200MFD 125VAC
567	P4179567	COMPLETE SWITCH ASSEMBLY
568	P4179568	SPACER W/SEAL
569	P4179569	COMPLETE SWITCH BOX ASSEMBLY
576	P4179576	SPROCKET
577	P4179577	LOCK WASHER 6MM
578	P4179578	HEX BOLT M6-1 X 30
579	P4179579	HEX BOLT M12-1.75 X 50
580	P4179580	SPACER
581	P4179581	EXT RETAINING RING 17MM



# Stand



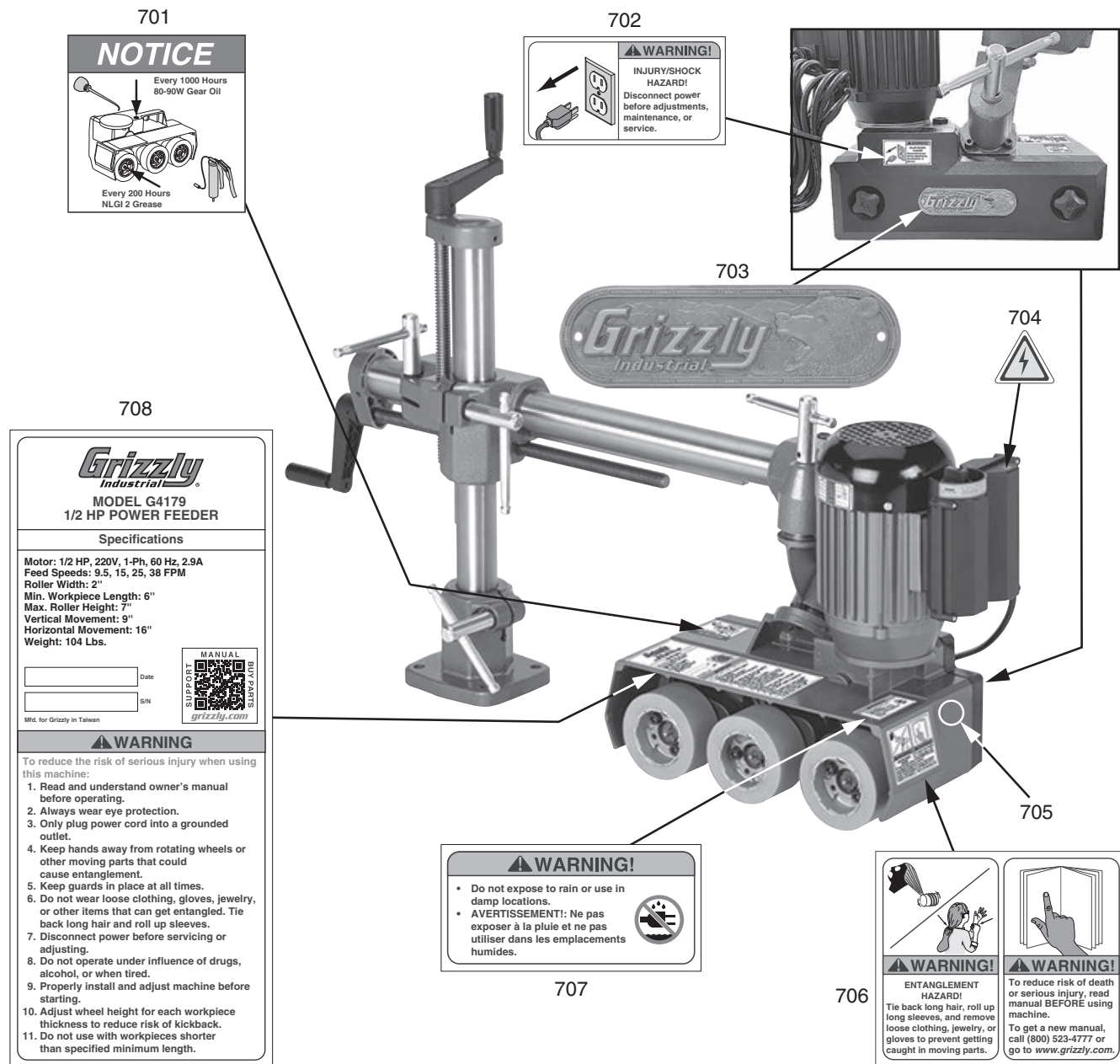
REF	PART #	DESCRIPTION
656V2	P4179656V2	ELEVATING BRACKET ASSEMBLY
656-1	P4179656-1	ELEVATING BRACKET
656-2	P4179656-2	STUD M12-1.75 X 70
656-3	P4179656-3	FLAT WASHER 1/2
656-4	P4179656-4	HANDLE
657	P4179657	ELEVATION LEAD SCREW
658	P4179658	HORIZONTAL LEAD SCREW
659V2	P4179659V2	COLUMN CAP V2.01.22
660	P4179660	SET SCREW M8-1.25 X 12
662	P4179661	OVER ARM CONE ASSEMBLY
662-1	P4179662-1	OVER ARM CONE
662-2	P4179662-2	LOCK STUD
662-3	P4179662-3	T-HANDLE
662-4	P4179662-4	ROLL PIN 6 X 22
662-5	P4179662-5	FLAT WASHER 1/2
662-6	P4179662-6	CAP SCREW M12-1.75 X 50
663	P4179663	SWIVEL CONE ASSEMBLY
663-1	P4179663-1	SWIVEL CONE
663-2	P4179663-2	LOCK STUD
663-3	P4179663-3	T-HANDLE
663-4	P4179663-4	ROLL PIN 6 X 22
664	P4179664	HANDLE

REF	PART #	DESCRIPTION
673V2	P4179673V2	BASE ASSEMBLY
673-1	P4179673-1	COLUMN BASE
673-2	P4179673-2	STUD M12-1.75 X 70
673-3	P4179673-3	FLAT WASHER 1/2
673-4	P4179673-4	LEVER
678V2	P4179678V2	VERTICAL COLUMN ASSEMBLY V2.01.22
678V2-1	P4179678V2-1	COLUMN
678V2-2	P4179678V2-2	KEY 350MML X 8T
678V2-3	P4179678V2-3	CAP SCREW M5-.8 X 10
682V2	P4179682V2	OVER ARM ASSEMBLY V2.01.22
682V2-1	P4179682V2-1	OVER ARM
682V2-2	P4179682V2-2	KEY 564MML X 8T
682V2-3	P4179682V2-3	CAP SCREW M5-.8 X 10
683	P4179683	ROLL PIN 6 x 36
685	P4179685	CRANK ARM
686	P4179686	HEX BOLT M12-1.75 X 70
687	P4179687	LOCK WASHER 12MM
688	P4179688	HEX BOLT M12-1.75 X 50
689	P4179689	ANCHOR FINNED M8-1.25
690	P4179690	CAP SCREW M8-1.25 X 20
691	P4179691	ANCHOR FINNED M8-1.25





# Labels & Cosmetics



REF	PART #	DESCRIPTION
701	P4179701	LUBRICATION NOTICE
702	P4179702	DISCONNECT 110V LABEL
703	P4179703	GRIZZLY NAMEPLATE
704	P4179704	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
705	P4179705	TOUCH-UP PAINT, GRIZZLY GREEN
706	P4179706	COMBO WARNING LABEL
707	P4179707	DAMPNESS WARNING LABEL
708	P4179708	MACHINE ID 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](http://www.grizzly.com).



# WARRANTY & RETURNS

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

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

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.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/forms/warranty>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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