



MODEL T34579 110V CONVERSION KIT FOR G0621X MFD 01/21+ INSTRUCTIONS

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

Introduction

The Model T34579 110V Conversion Kit transforms the power supply requirements of the Model G0621X from 220V to 110V, and includes a NEMA 5-20 plug.

G0621X Revised Specifications

Electrical:

Power Requirement..... 110V, 1-Ph, 60 Hz
Full-Load Current Rating 18A
Power Cord Length 72 in.
Power Cord Gauge..... 12 AWG
Plug Included..... Yes
Included Plug Type..... 5-20
Inverter (VFD) Type RM6S2-1002E1

Inventory

Description	Qty
A. VFD Rhymebus RM6S2 100V-120V	1
B. VFD Cover Plate.....	1
C. Phillips Head Screws #10-24 x 1/2" (PT34579005).....	2
D. Button Head Cap Screw M5-.8 x 10 (PT34579010)	1
E. Ext. Tooth Washers 5mm (PT34579009)...	2
F. Hex Nuts #10-24 (PT34579006).....	2
G. Wing Nut M5-.8 (PT34579008)	1
H. VFD Cord 12G 3W 30"	1
I. Power Cord 12G 3W 83" 5-20P	1
J. Replacement Power Supply Label	1
K. Strain Relief PG13.5	1
L. Parameter Manual RM6S2/S3 Series	1

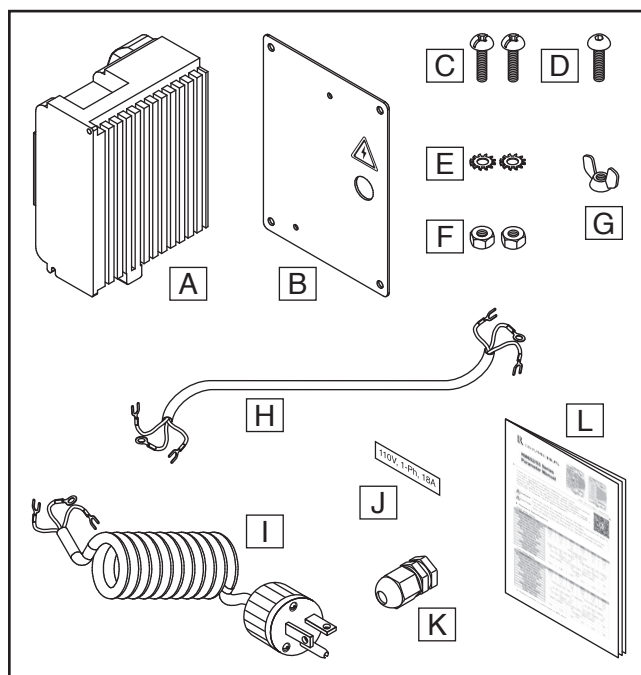


Figure 1. Box inventory.

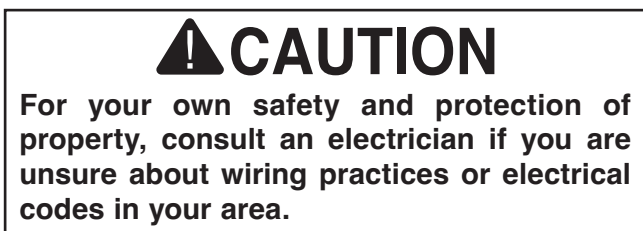
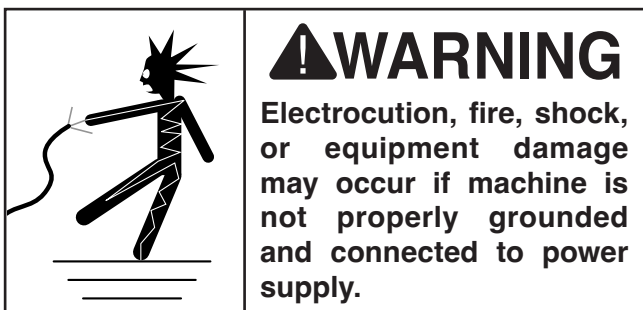
NOTICE

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

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V1.07.25

Keep for Future Reference



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 Pr.
• Phillips Head Screwdrivers #1, #2.....	1 Ea.
• Flat Head Screwdriver $\frac{3}{32}$ ".....	1
• Hex Wrench 3mm.....	1
• Wrench $\frac{5}{16}$ ".....	1
• Flashlight.....	1
• Tape Measure (6' Minimum).....	1
• Tie Straps (3" Minimum).....	As Needed
• Cleaner/Degreaser.....	As Needed
• Clean Shop Rags.....	As Needed
• Disposable Gloves.....	As Needed

Assembly

The Model T34579 must be fully assembled and installed before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. During assembly, refer to the **G0621X Revised Wiring Diagram** on **Page 7** to verify that electrical connections are made correctly. To ensure the assembly process goes smoothly, clean your Model G0621X bandsaw and remove any debris that may interfere with installation (if applicable).

Removing G0621X Components

1. DISCONNECT MACHINE FROM POWER!
2. Remove power switch (see **Figure 2**) and save fasteners for later use, then disconnect power cord and motor cord wires from power switch terminals and set power switch aside for now.
3. Loosen and remove Phillips head screw, external tooth washer, and hex nut securing chassis ground wires, as shown in **Figure 2**.

Note: Replacement chassis ground fasteners are included in kit inventory.

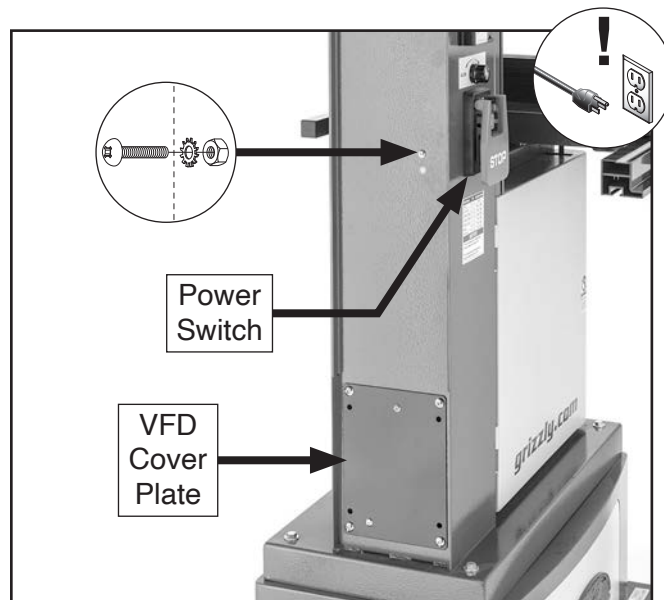


Figure 2. Location of G0621X components.



4. Remove power cord and strain relief (see **Figure 3**).

Note: Access to strain relief is available through opening for power switch.

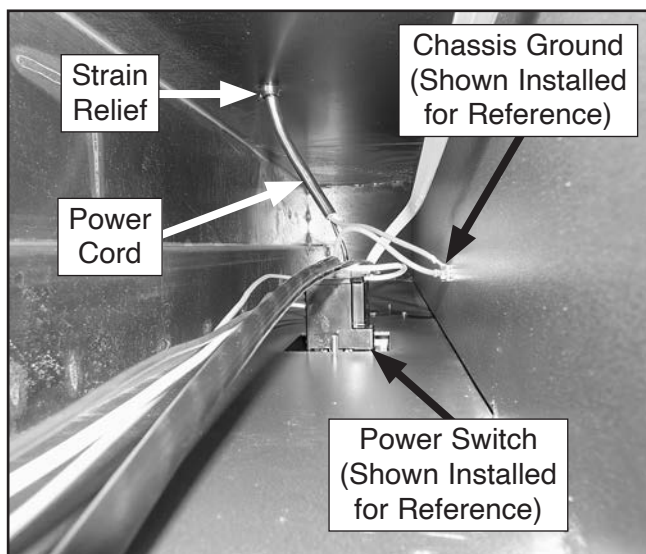


Figure 3. Location of power cord components (viewed from below in machine interior).

5. Remove VFD cover plate (see **Figure 2**) and save fasteners for later use, then disconnect ethernet cable, motor cord wires, VFD cord wires, and speed dial wires from VFD (see **Figure 4**).

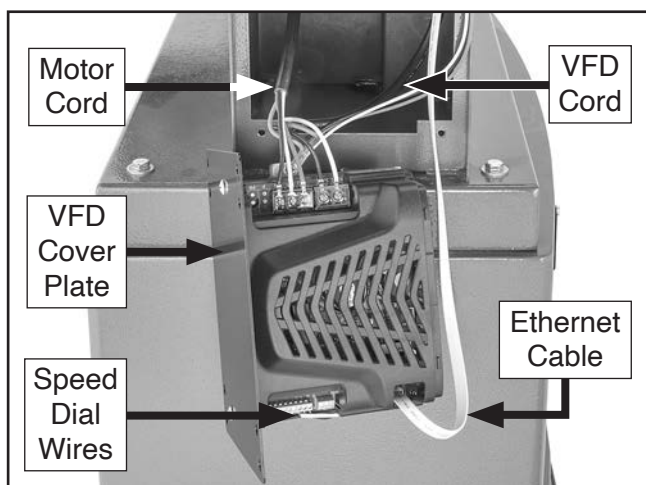


Figure 4. Location of VFD wiring connections.

6. Remove VFD, VFD cover plate, and VFD cord from machine. Place all removed components in a storage bag that will keep out dust and resist moisture.

Installing T34579 Components

1. Connect black and white wires on one end of included 30" VFD cord to LINE power switch terminals shown in **Figure 5**.

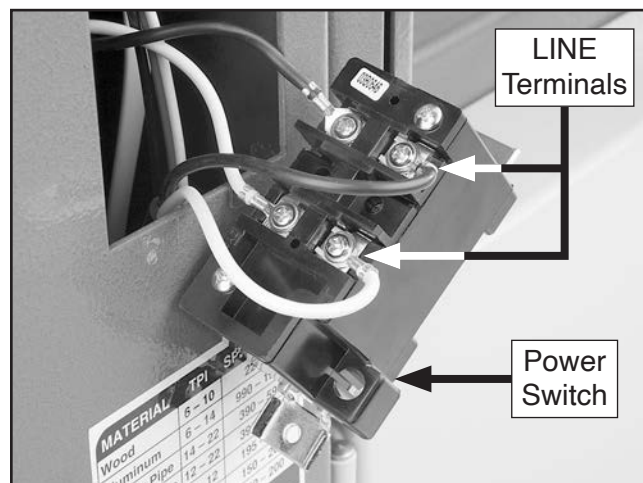


Figure 5. Location of power switch LINE terminals.

2. Route opposite end of 30" VFD cord down through machine interior to VFD cover plate opening and connect black and white wires to R/L1 and S/L2 VFD terminals (see **Figure 6**).
3. Connect red, white, and black wires on motor cord to U, V, and W terminals on VFD shown in **Figure 6**.
4. Connect green ground wires from motor cord and VFD cord to grounding terminal on VFD (see **Figure 6**).

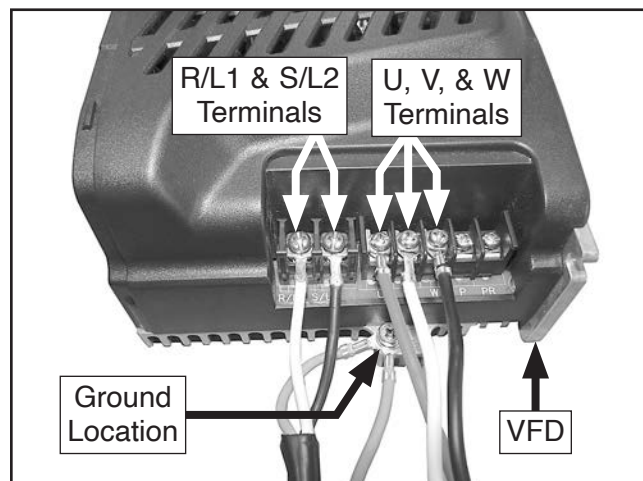


Figure 6. Location of upper VFD terminals.



5. Connect white, red, and black speed dial wires to V+, AI, and GND terminals on VFD (see **Figure 7**).
6. Connect ethernet cable to CN1 terminal on VFD (see **Figure 7**).

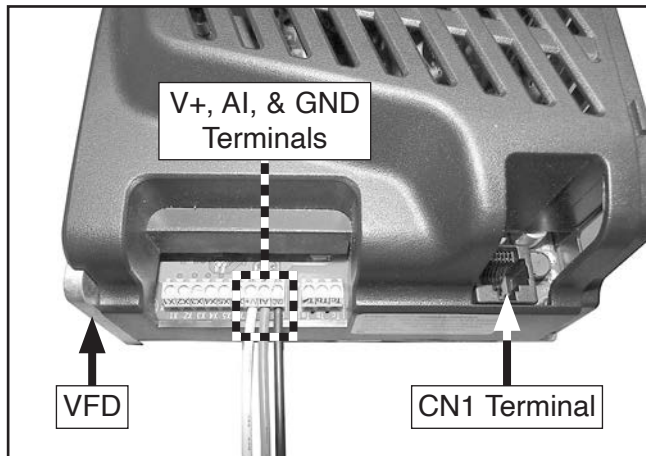


Figure 7. Location of lower VFD terminals.

7. Separate strain relief nut from strain relief base, then insert end of power cord through strain relief and VFD cover plate included with kit, as shown in **Figure 8**.
8. Verify there is a *minimum* of 18" of exposed power cord length from strain relief base, then hand-tighten strain relief on base (see **Figure 8**).

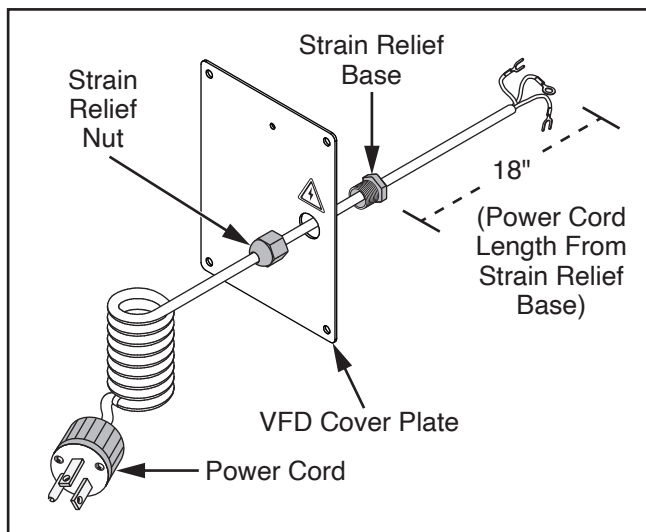


Figure 8. Location of included VFD cover plate components.

9. Install VFD on VFD cover plate with (2) #10-24 x 1/2" Phillips head screws and #10-24 hex nuts (see **Figure 9**).

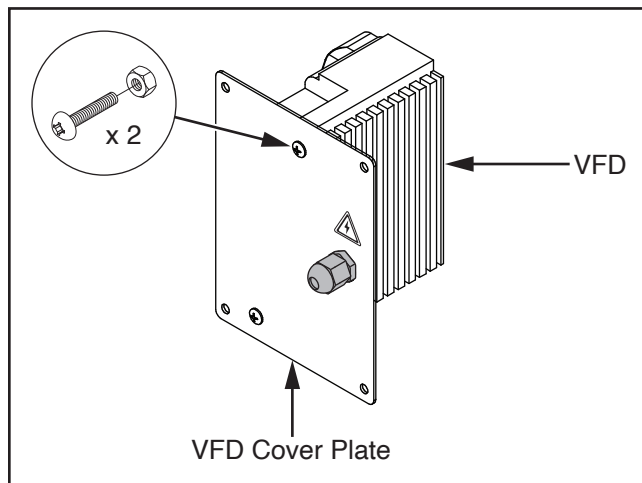


Figure 9. VFD installed on VFD cover plate (power cord removed for clarity).

10. Route wire end of power cord up through machine interior to power switch and connect black and white wires to LOAD power switch terminals shown in **Figure 10**.

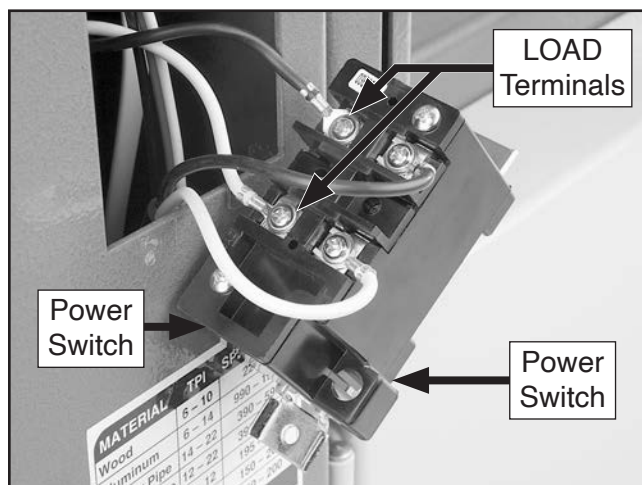


Figure 10. Location of power switch LOAD terminals.



11. Clean and dry interior and exterior surface of chassis ground hole, then attach green motor cord and power cord ground wires to chassis ground hole with (1) M5-.8 X 10 button head cap screw, (2) 5mm external tooth washers, and (1) M5-.8 wing nut included with kit (see **Figure 11**).

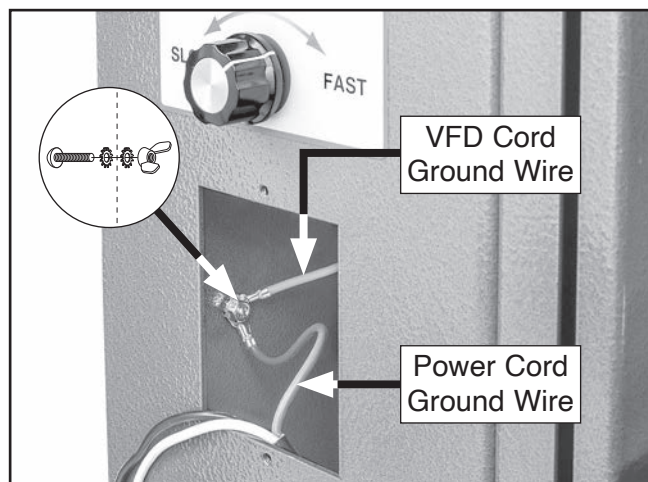


Figure 11. Example of VFD cord and power cord ground wires attached to chassis ground.

NOTICE

Prior to installing power switch and VFD cover plate, secure wire groups connected to VFD with tie straps to help prevent clutter and keep machine interior tidy.

12. Install power switch and secure with fasteners removed in **Step 2** of **Removing G0621X Components** on **Page 2**.
13. Install VFD cover plate with fasteners removed in **Step 5** of **Removing G0621X Components** on **Page 2**.

14. Place replacement power supply label included with kit over **Power Supply** specification on machine ID label (see **Figure 12**).

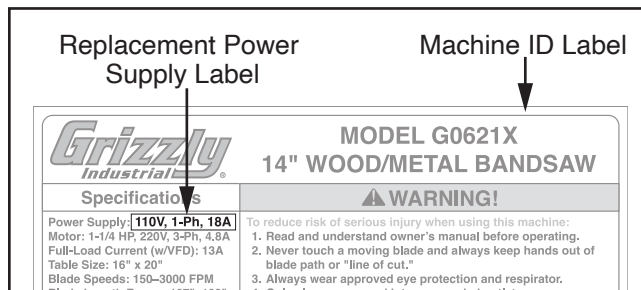


Figure 12. Replacement power supply label installed.

15. Perform **Test Run** procedure on **Page 20** of the Model G0621X owner's manual.

IMPORTANT: For issues concerning the VFD, contact Rhymebus to obtain an RM6S2 series manual (or visit <https://www.rhyme-bus.com.tw/en>). All VFD servicing should be done by an authorized and trained technician. The VFD parameters have been set at the factory to optimize the performance of the machine and should not be adjusted unless instructed by Grizzly Tech Support. Improper adjustments can cause machine damage, disable important safety features, and may void the warranty.



WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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















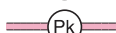
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

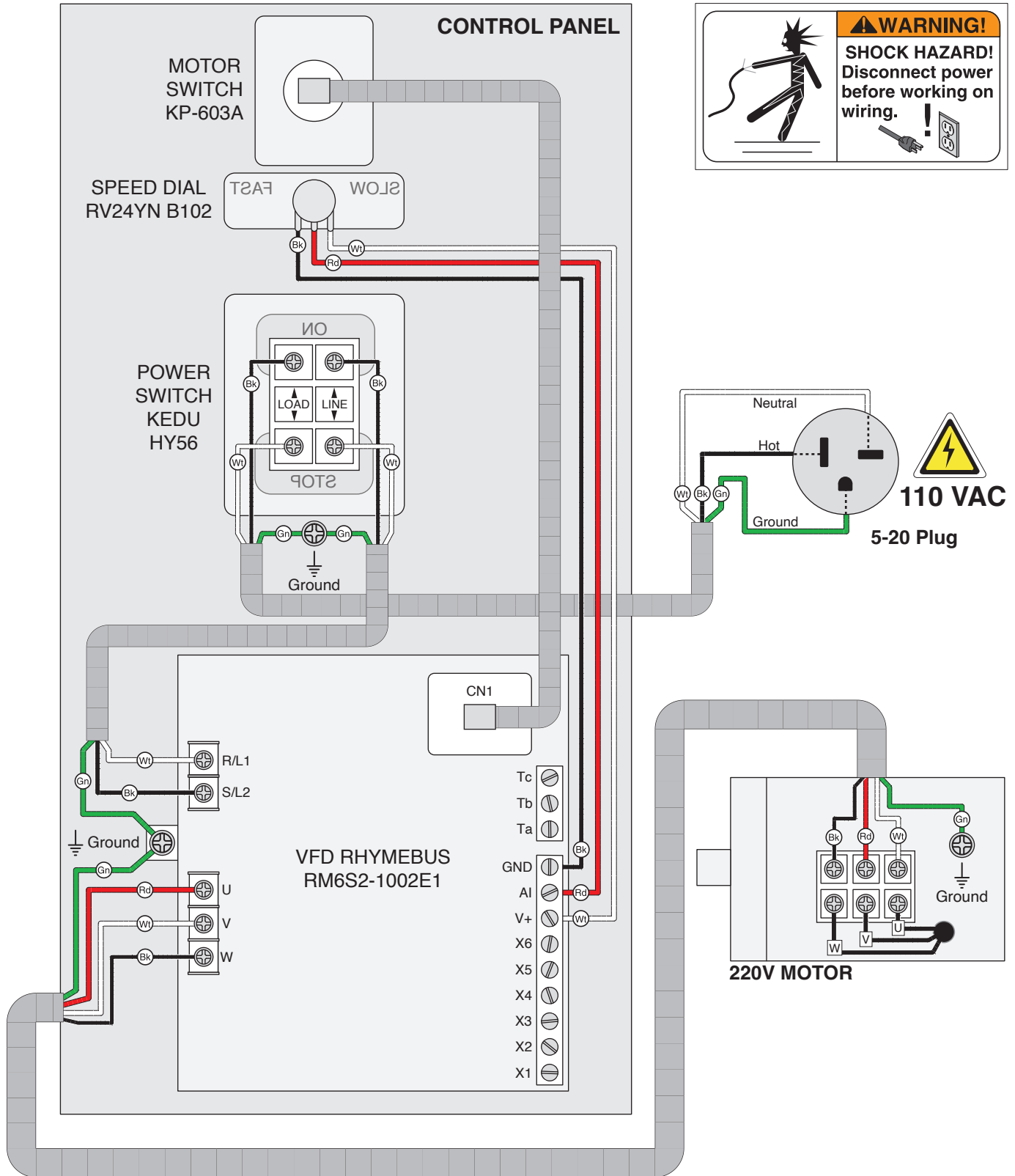
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

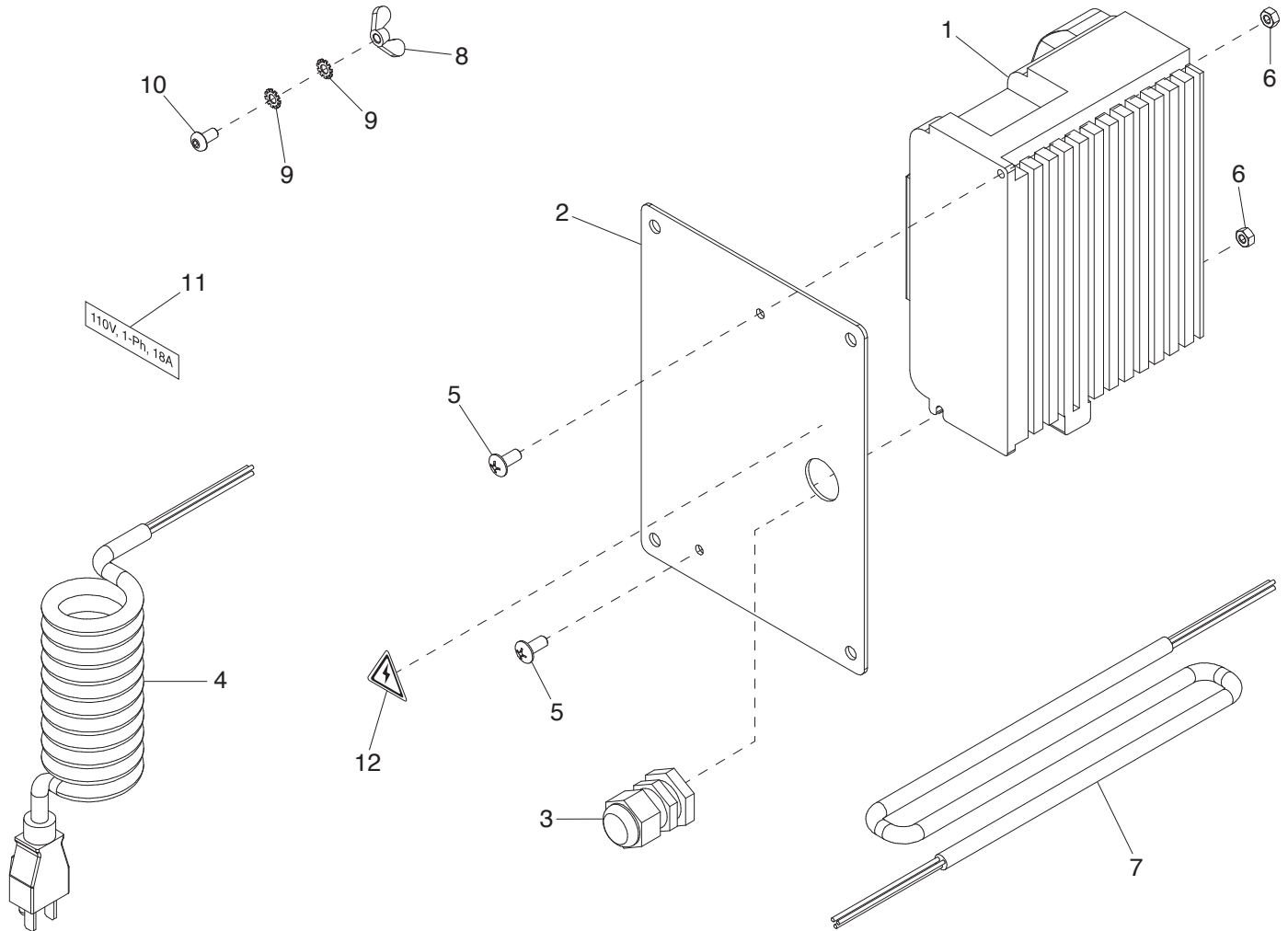
BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



G0621X Revised Wiring Diagram



T34579 Parts Breakdown & List



REF	PART #	DESCRIPTION
1	PT34579001	VFD RHYMEBUS RM6S2-1002E1
2	PT34579002	VFD COVER PLATE
3	PT34579003	STRAIN RELIEF PG13.5
4	PT34579004	POWER CORD 12G 3W 83" 5-20P
5	PT34579005	PHLP HD SCR 10-24 X 1/2
6	PT34579006	HEX NUT 10-24

REF	PART #	DESCRIPTION
7	PT34579007	VFD CORD 12G 3W 30"
8	PT34579008	WING NUT M5-.8, SELF-LOCKING
9	PT34579009	EXT TOOTH WASHER 5MM
10	PT34579010	BUTTON HD CAP SCR M5-.8 X 10
11	PT34579011	REPLACEMENT POWER LABEL
12	PT34579012	ELECTRICITY LABEL

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.

