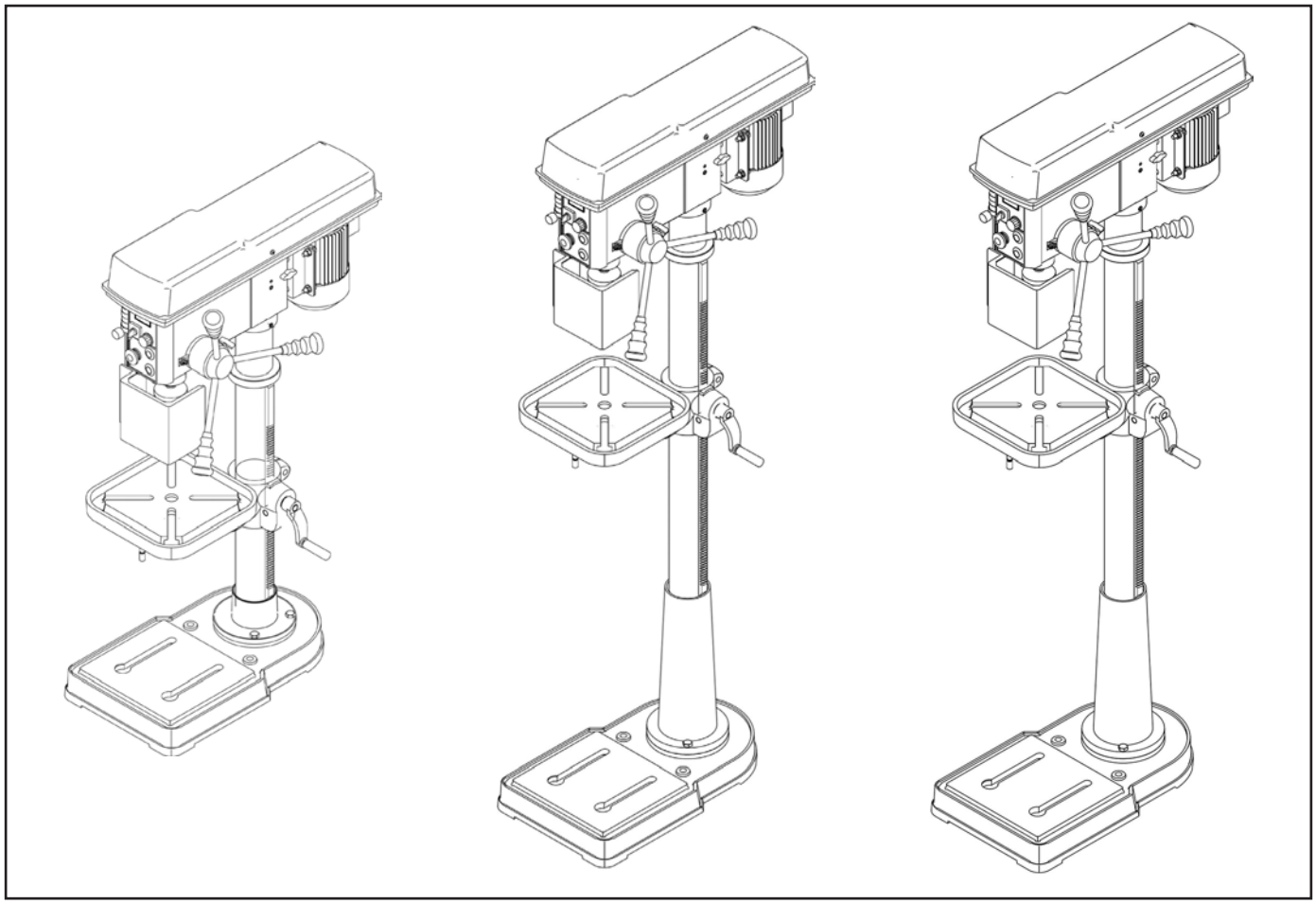
Grizzly Industrial, Inc.®

MODEL T34612/T34613/T34614
15" & 17" VARIABLE-SPEED DRILL PRESSES

OWNER'S MANUAL

(For models manufactured since 06/25)



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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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

⚠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

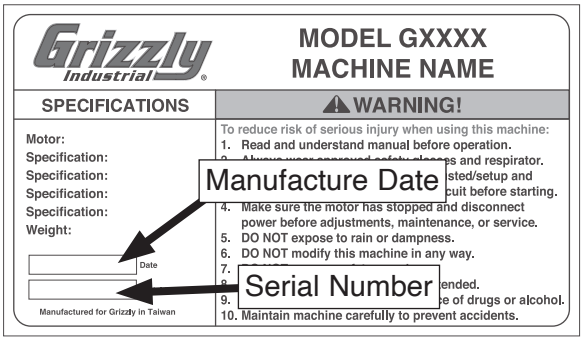
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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

Manual Accuracy

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.



MACHINE DATA SHEET

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

MODEL T34612 15" BENCHTOP VARIABLE-SPEED DRILL PRESS

Product Dimensions:

Weight	135 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	15 x 26 x 42 in.
Footprint (Length x Width)	20-1/2 x 12-1/2 in.

Shipping Dimensions:

Type	Cardboard Box
Content	Machine
Weight	142 lbs.
Length x Width x Height	35 x 20 x 14 in.

Electrical:

Power Requirement	110V, Single-Phase, 60 Hz
Full-Load Current Rating	6.41A
Minimum Circuit Size	15A
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	72 in.
Power Cord Gauge	16 AWG
Plug Included	Yes
Included Plug Type	5-15
Switch Type	ON/OFF Push Buttons
Inverter (VFD) Type	LSD-J7100
Inverter (VFD) Size	2 HP

Motors:

Main

Horsepower	1 HP
Phase	3-Phase
Amps	1.85A
Speed	1400 RPM
Type	TEFC Induction
Power Transfer	Belt
Bearings	Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Type	Benchtop
Swing	15-1/4 in.
Spindle Taper	MT#2
Spindle Travel	3-1/4 in.
Max. Distance From Spindle to Column	7-5/8 in.
Max. Distance From Spindle to Table	18-1/16 in.
Number of Spindle Speeds	Variable
Range of Spindle Speeds	30 - 650, 130 - 3000 RPM
Drilling Capacity (Mild Steel)	5/8 in.
Drilling Capacity (Cast Iron)	3/4 in.
Drill Chuck Type	JT3 Keyed
Drill Chuck Size	5/8 in.

Spindle Information

Distance From Spindle to Base	26-7/8 in.
Quill Diameter	1.850 in.

Table Information

Max. Table Tilt (Left/Right)	45 deg.
Table Swivel Around Center	360 deg.
Table Swivel Around Column	360 deg.
Max. Movement of Work Table	14-1/2 in.
Table Length	10-9/16 in.
Table Width	10-9/16 in.
Table Thickness	1-3/16 in.
Number of T-Slots	4
T-Slot Size	9/16 in.
Floor-To-Table Height	11-1/4 - 25-3/4 in.

Construction

Table	Cast Iron
Column	Steel
Spindle Housing	Cast Iron
Head	Cast Iron
Base	Cast Iron
Paint Type/Finish	Powder Coated

Other Related Information

Base Length	20-1/2 in.
Base Width	12-3/8 in.
Column Diameter	2-7/8 in.
Quill Flange/Collar Diameter	2-5/16 in.
Depth Stop Type	Hub
Has Work Light	Yes
Light Socket Type	LED
Maximum Bulb Wattage	1W
Has Laser Guide	Yes
Laser Classification	Class II
Laser Wavelength	650nm
Laser Maximum Output	1mW

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

MACHINE DATA SHEET

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

MODEL T34613 15" FLOOR VARIABLE-SPEED DRILL PRESS

Product Dimensions:

Weight..... 146 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 15 x 27-1/2 x 63 in.
Footprint (Length x Width)..... 20-1/2 x 12-3/8 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 153 lbs.
Length x Width x Height..... 55 x 20 x 12 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Full-Load Current Rating..... 6.41A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... ON/OFF Push Buttons
Inverter (VFD) Type..... LSD-J7100
Inverter (VFD) Size..... 2 HP

Motors:

Main

Horsepower..... 1 HP
Phase..... 3-Phase
Amps..... 1.85A
Speed..... 1400 RPM
Type..... TEFC Induction
Power Transfer ..... Belt
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Type..... Floor
Swing..... 15-1/4 in.
Spindle Taper..... MT#2
Spindle Travel..... 3-1/4 in.
Max. Distance From Spindle to Column..... 7-5/8 in.
Max. Distance From Spindle to Table..... 28-3/8 in.
Number of Spindle Speeds..... Variable
Range of Spindle Speeds..... 30 - 650, 130 - 3000 RPM
Drilling Capacity (Mild Steel)..... 5/8 in.
Drilling Capacity (Cast Iron)..... 3/4 in.
Drill Chuck Type..... JT3 Keyed
Drill Chuck Size..... 5/8 in.

Spindle Information

Distance From Spindle to Base	48-1/16 in.
Quill Diameter	1.850 in.

Table Information

Max. Table Tilt (Left/Right)	45 deg.
Table Swivel Around Center	360 deg.
Table Swivel Around Column	360 deg.
Max. Movement of Work Table	25-7/8 in.
Table Length	10-9/16 in.
Table Width	10-9/16 in.
Table Thickness	1-3/16 in.
Number of T-Slots	4
T-Slot Size	9/16 in.
Floor-To-Table Height	22-1/8 - 48 in.

Construction

Table	Cast Iron
Column	Steel
Spindle Housing	Cast Iron
Head	Cast Iron
Base	Cast Iron
Paint Type/Finish	Powder Coated

Other Related Information

Base Length	20-1/2 in.
Base Width	12-3/8 in.
Column Diameter	2-7/8 in.
Quill Flange/Collar Diameter	2-5/16 in.
Depth Stop Type	Hub
Has Work Light	Yes
Light Socket Type	LED
Maximum Bulb Wattage	1W
Has Laser Guide	Yes
Laser Classification	Class II
Laser Wavelength	650nm
Laser Maximum Output	1mW

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Features:

360 Deg. Table Positioning Around Column
Spindle Speed Digital Readout
Two Variable-Speed Spindle Speed Ranges
Adjustable Class II Laser Guide
Built-In LED Worklight
Adjustable Chip Guard w/Safety Switch
Reversible Spindle Rotation
Belt Door Safety Switch

MACHINE DATA SHEET

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

MODEL T34614 17" FLOOR VARIABLE-SPEED DRILL PRESS

Product Dimensions:

Weight..... 170 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 16 x 28 x 64-1/2 in.
Footprint (Length x Width)..... 21-1/2 x 13 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 179 in.
Length x Width x Height..... 55 x 21 x 13 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Full-Load Current Rating..... 11.78A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... ON/OFF Push Buttons
Inverter (VFD) Type..... LSD-C7100
Inverter (VFD) Size..... 2 HP

Motors:

Main

Horsepower..... 1-1/2 HP
Phase..... 3-Phase
Amps..... 3.4A
Speed..... 1400 RPM
Type..... TEFC Induction
Power Transfer ..... Belt
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Type..... Floor
Swing..... 17 in.
Spindle Taper..... MT#2
Spindle Travel..... 3-1/4 in.
Max. Distance From Spindle to Column..... 8-1/2 in.
Max. Distance From Spindle to Table..... 28-9/16 in.
Number of Spindle Speeds..... Variable
Range of Spindle Speeds..... 30 - 650, 130 - 3000 RPM
Drilling Capacity (Mild Steel)..... 3/4 in.
Drilling Capacity (Cast Iron)..... 1 in.
Drill Chuck Type..... JT3 Keyed
Drill Chuck Size..... 5/8 in.

Spindle Information

Distance From Spindle to Base	48-1/2 in.
Quill Diameter	2.047 in.

Table Information

Max. Table Tilt (Left/Right)	45 deg.
Table Swivel Around Center	360 deg.
Table Swivel Around Column	360 deg.
Max. Movement of Work Table	25-1/4 in.
Table Length	12-3/8 in.
Table Width	12-3/8 in.
Table Thickness	1-3/16 in.
Number of T-Slots	4
T-Slot Size	9/16 in.
Floor-To-Table Height	22-1/2 - 47-3/4 in.

Construction

Table	Cast Iron
Column	Steel
Spindle Housing	Cast Iron
Head	Cast Iron
Base	Cast Iron
Paint Type/Finish	Powder Coated

Other Related Information

Base Length	21-3/8 in.
Base Width	12-3/4 in.
Column Diameter	3-1/8 in.
Quill Flange/Collar Diameter	2-5/8 in.
Depth Stop Type	Hub
Has Work Light	Yes
Light Socket Type	5V LED
Maximum Bulb Wattage	1W
Has Laser Guide	Yes
Laser Classification	Class II
Laser Wavelength	650nm
Laser Maximum Output	1mW

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes

Features:

360 Deg. Table Positioning Around Column
Spindle Speed Digital Readout
Two Variable-Speed Spindle Speed Ranges
Adjustable Class II Laser Guide
Built-In LED Worklight
Adjustable Chip Guard w/Safety Switch
Reversible Spindle Rotation
Belt Door Safety Switch

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 Drill Presses

⚠WARNING

Serious injury or death can occur from getting clothing, jewelry, or long hair entangled in rotating spindle or bit/cutting tool. Contact with rotating bit/cutting tool can result in severe cuts or amputation of fingers. Flying metal chips can cause blindness or eye injuries. Broken bits/cutting tools, unsecured workpieces, chuck keys, or other adjustment tools thrown from rotating spindle can strike nearby operator or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders MUST completely heed hazards and warnings below.

EYE/FACE/HAND PROTECTION. Flying chips created by drilling can cause eye injuries or blindness. Always wear a face shield in addition to safety glasses. Always keep hands and fingers away from drill bit/cutting tool. Avoid awkward hand positions, where a sudden slip could cause hand to move into bit/cutting tool.

AVOIDING ENTANGLEMENT. DO NOT wear loose clothing, gloves, or jewelry. Tie back long hair. Keep all guards in place and secure. Always allow spindle to stop on its own. DO NOT stop spindle using your hand or any other object.

REMOVING ADJUSTMENT TOOLS. Chuck key, wrenches, and other tools left on machine can become deadly projectiles when spindle is started. Remove all loose items or tools used on spindle immediately after use.

CORRECT SPINDLE SPEED. Using wrong spindle speed can cause bits/cutting tools to break and strike operator or bystanders. Follow recommended speeds and feeds for each size/type of bit/cutting tool and workpiece material.

SECURING BIT/CUTTING TOOL. Firmly secure bit/cutting tool in chuck so it cannot fly out of spindle during operation or startup.

DRILLING PREPARATION. To avoid loss of drilling control or bit breakage, only drill into a flat surface that is approximately perpendicular to bit. Clear table of all objects before starting spindle. Never start spindle with bit pressed against workpiece.

SECURING TABLE AND HEADSTOCK. To avoid loss of control leading to accidental contact with tool/bit, tighten all table and headstock locks before operating drill press.

WORKPIECE CONTROL. An unsecured workpiece may unexpectedly shift, spin out of control, or be thrown if bit/cutting tool "grabs" during operation. Clamp workpiece to table or in table-mounted vise, or brace against column to prevent rotation. NEVER hold workpiece by hand during operation. NEVER start machine with bit/cutting tool touching workpiece; allow spindle to gain full speed before drilling.

INSPECTING BIT/CUTTING TOOL. Damaged bits/cutting tools may break apart during operation and hit operator or bystanders. Dull bits/cutting tools increase cutting resistance and are more likely to grab and spin/throw workpiece. Always inspect bits/cutting tools for sharpness, chips, or cracks before each use. Replace dull, chipped, or cracked bits/cutting tools immediately.

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.

T34612/T34613 ..... 6.41 Amps
T34614 ..... 11.78 Amps

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

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

⚠WARNING

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

110V 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 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 15 Amps
Plug/Receptacle ..... NEMA 5-15

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

⚠CAUTION

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

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

Grounding & Plug 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!

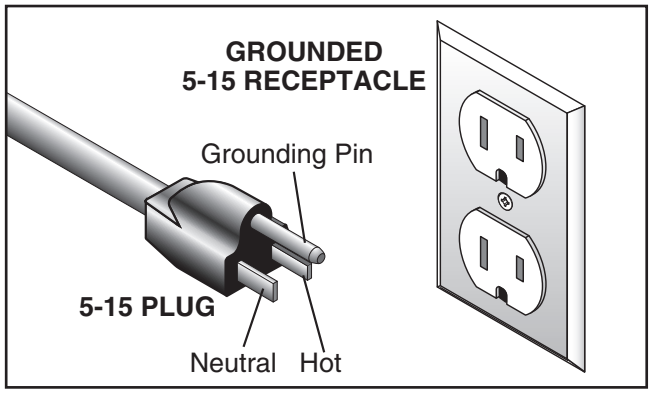
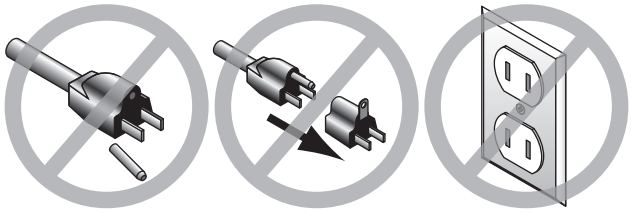


Figure 1. Typical 5-15 plug and receptacle.

⚠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.

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.

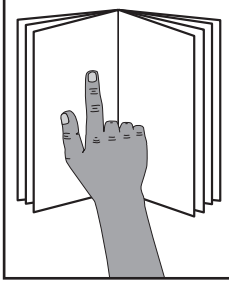
Extension Cords

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.....14 AWG
Maximum Length (Shorter is Better).....50 ft.

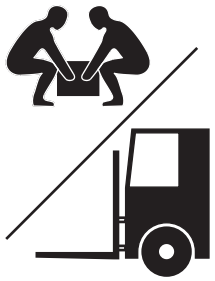


⚠WARNING

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.

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.

Box 1 (Figure 2)	Qty
A. Headstock	1
B. Downfeed Handles	3
C. Table Height Lock Handle	1
D. Table Height Crank	1
E. Base	1
F. Table	1
G. Arbor MT#2 x JT3	1
H. Drill Chuck JT3 5/8"	1
I. Drill Chuck Key	1
J. Drift Key	1
K. Hex Bolts M10-1.5 x 35	4
L. Hex Wrenches 3, 4, 5mm	1 Ea.
M. Table Swivel Lock Handle	1
N. Chip Guard	1
O. Chip Guard Rail	1
P. Column Assembly (T34612)	1
Q. Column Assembly (T34613/T34614)	1

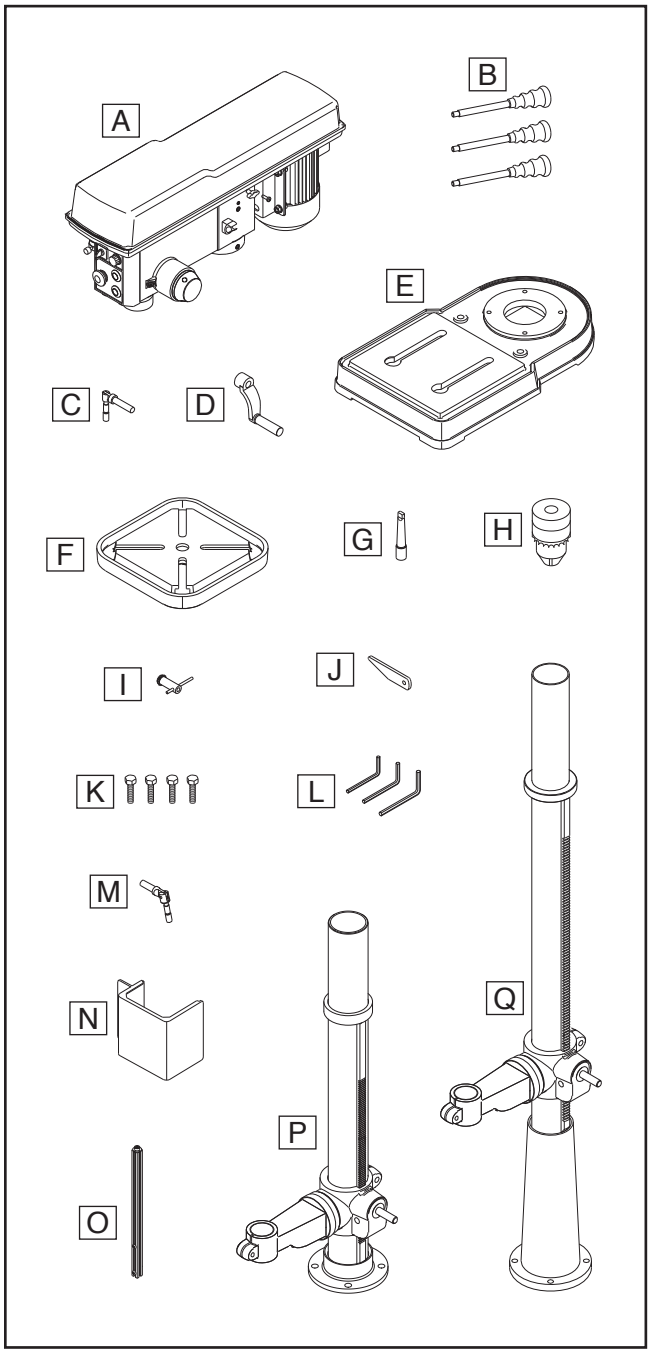


Figure 2. Inventory.

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.

⚠WARNING

Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

⚠CAUTION

Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

NOTICE

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

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Figure 3. T23692 Orange Power Degreaser.

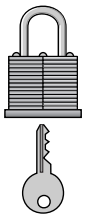
Site Considerations

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

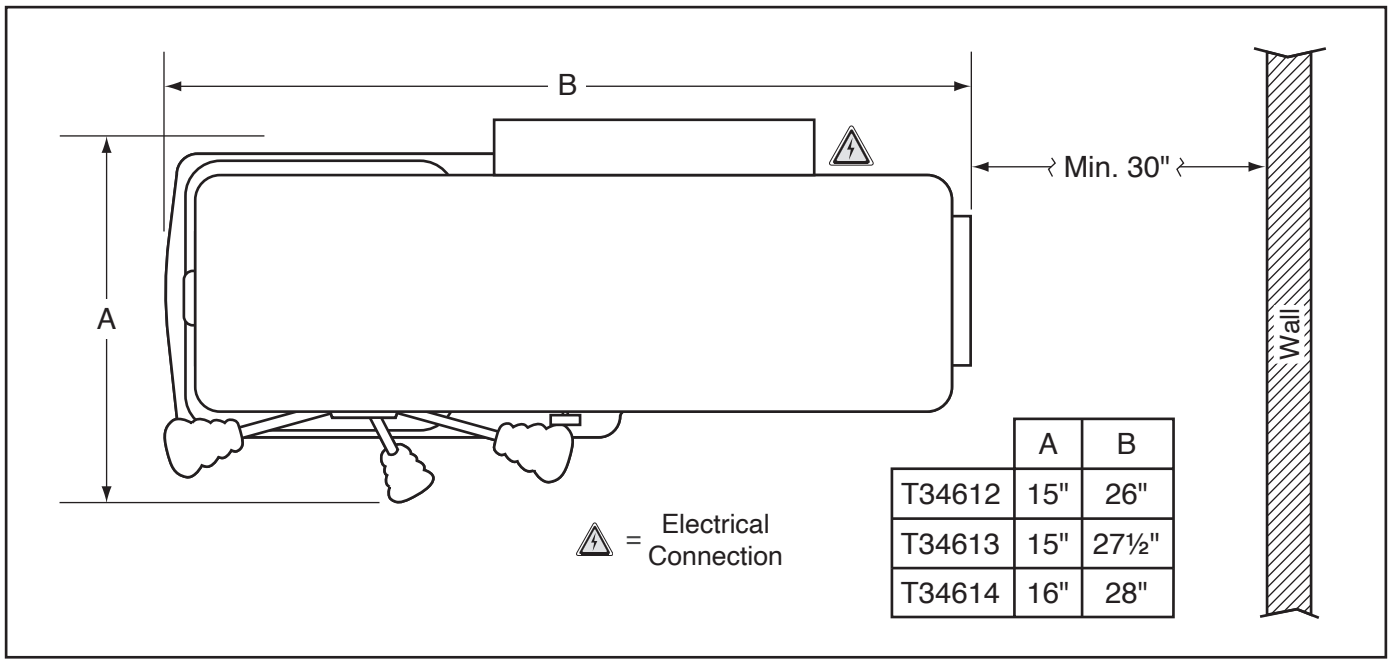
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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



	A	B
T34612	15"	26"
T34613	15"	27½"
T34614	16"	28"

Figure 4. Minimum working clearances.

Bench Mounting (T34612)

The Model T34612 base has holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

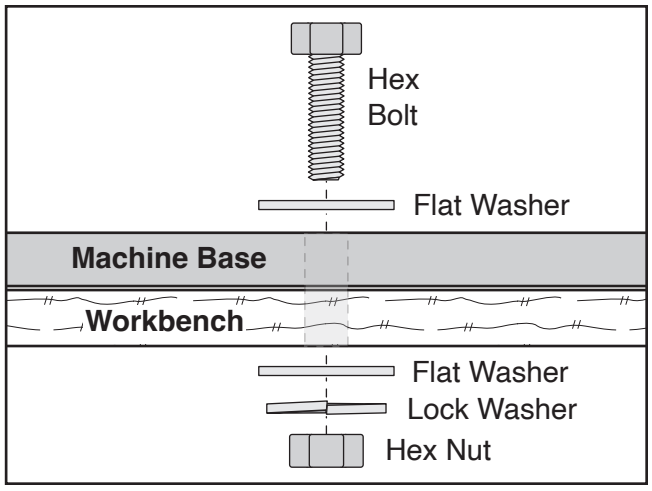


Figure 5. "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

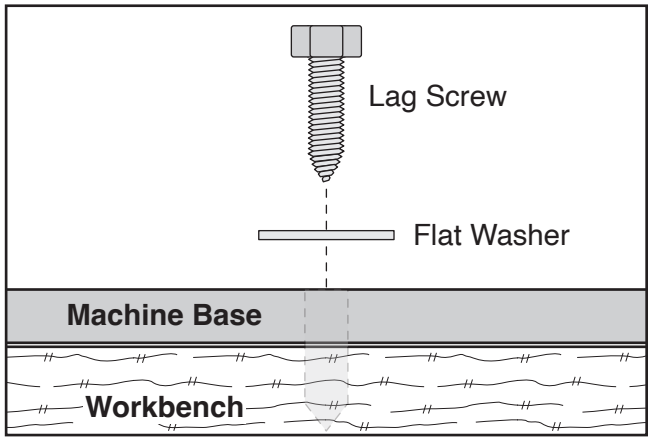


Figure 6. "Direct Mount" setup.

Anchoring to Floor (T34613/T34614)

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

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you MUST follow the anchoring methodology specified by the code.

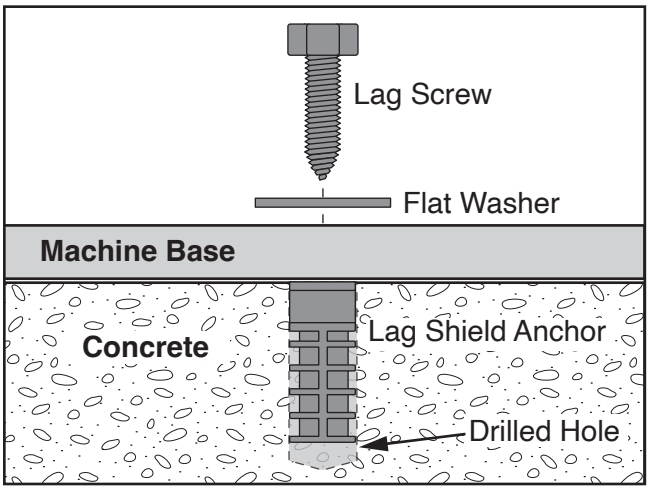
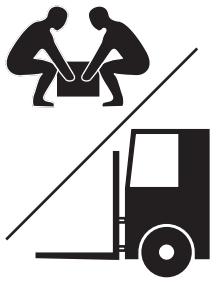


Figure 7. Popular method for anchoring machinery to a concrete floor.

Assembly

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



⚠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.

To assemble the machine:

1. Attach the column assembly (see **A** in **Figure 8**) to the base (see **B** in **Figure 8**) with four hex bolts (see **C** in **Figure 8**). Tighten firmly.

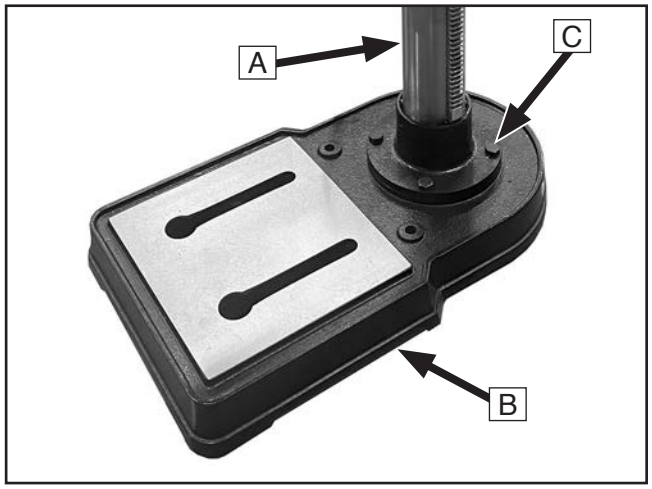


Figure 8. Column assembly attached to base (Model T34612 shown).

2. Thread the table height lock handle (see **A** in **Figure 9**) into the table bracket (see **B** in **Figure 9**).

3. Slide the table height crank (see **C** in **Figure 9**) onto the table bracket shaft.

4. Turn the crank until the set screw (see **D** in **Figure 9**) is aligned with the flat section on the shaft, then tighten the set screw.

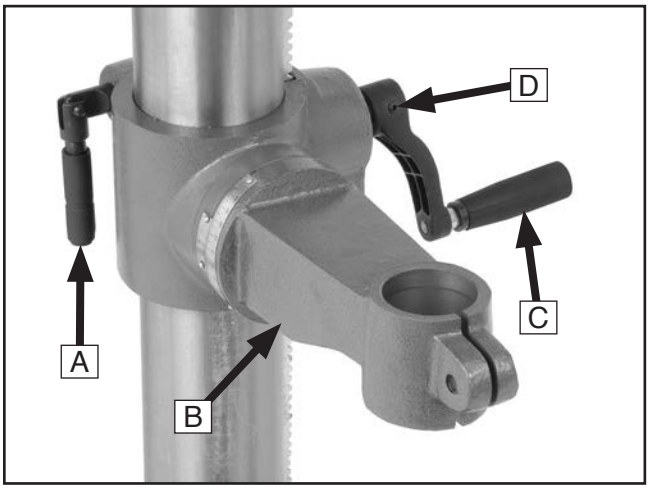


Figure 9. Example of table height controls installed.

5. Insert the table (see **A** in **Figure 10**) into the table bracket. Thread the table swivel lock handle (see **B** in **Figure 10**) into the table bracket.

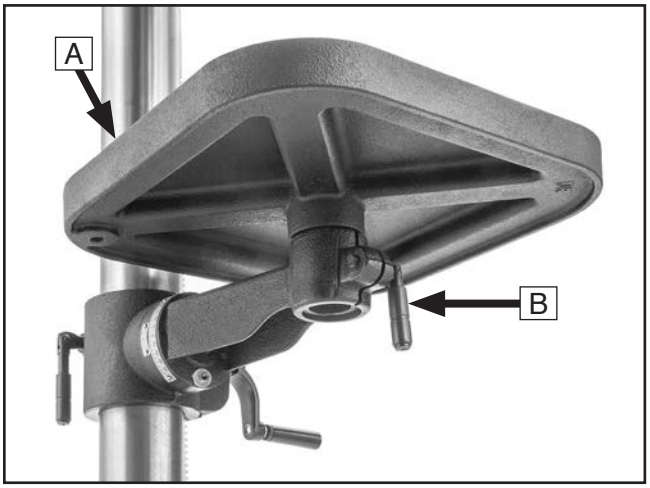


Figure 10. Example of table installed.

6. With the aid of a second person, carefully lift the headstock onto the column top.

7. Rotate the headstock until the sides of the belt door are parallel with the sides of the base, then tighten two set screws (see **A** in **Figure 11**).

8. Install three downfeed handles (see **B** in **Figure 11**) into the downfeed hub (see **C** in **Figure 11**).

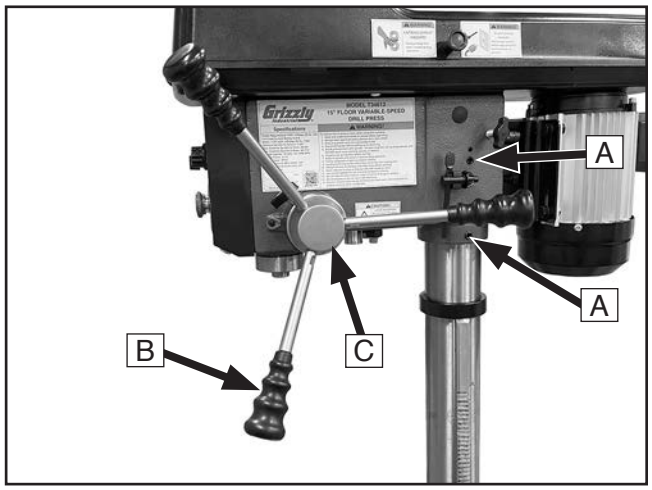


Figure 11. Headstock and downfeed handles installed (T34613 shown).

9. Remove (2) Phillips head screws from T-slot nuts (see **A** in **Figure 12**) inside chip guard rail (see **B** in **Figure 12**), then use screws and nuts to attach chip guard (see **C** in **Figure 12**) to chip guard rail.

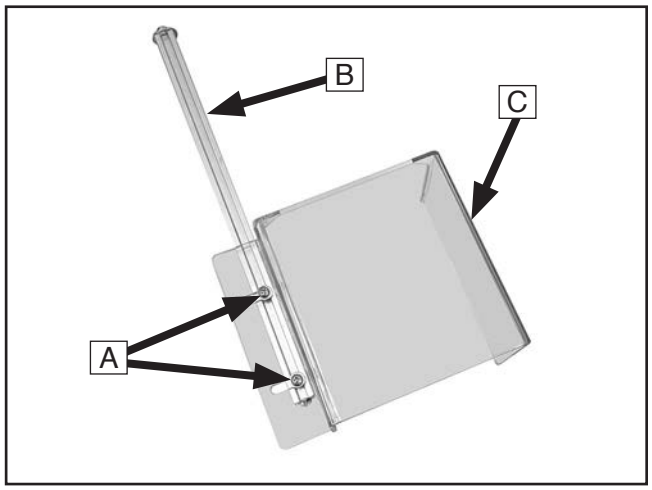


Figure 12. Chip guard attached to chip guard rail.

10. Remove cap screw and flat washer (see **A** in **Figure 13**) from chip guard rail.

11. Loosen chip guard lock knob (see **B** in **Figure 13**), insert chip guard rail through bottom of mount on side of headstock, then tighten lock knob to secure.

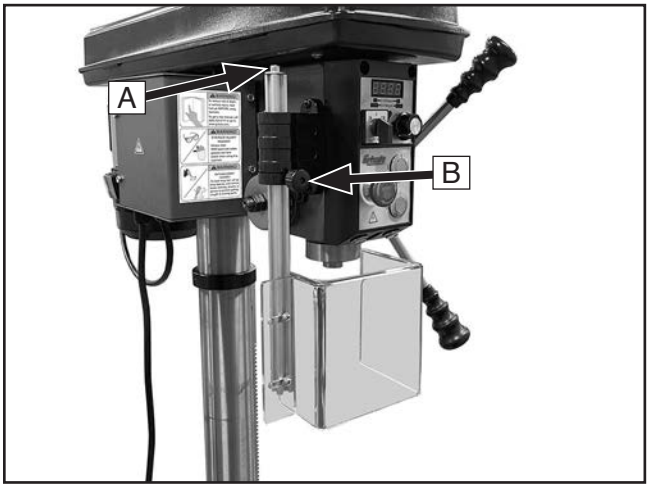


Figure 13. Chip guard attached to chip guard rail (T34613 shown).

12. Install fasteners removed in **Step 10**.

Joining Drill Chuck & Arbor

An arbor is included for the drill chuck that comes with this machine. The following procedure describes how to install the arbor in the chuck.

After the arbor is installed in the drill chuck, it is very difficult to separate the assembly. If you would like to use a different chuck in the future, we recommend obtaining a new arbor.

IMPORTANT: DO NOT install the drill chuck and arbor assembly into the spindle until **AFTER** the test run.

To join drill chuck and arbor:

1. Use acetone or lacquer thinner to clean drill chuck and arbor mating surfaces, especially the bore.

2. Retract chuck jaws completely into chuck.

3. Insert small end of arbor into chuck.

4. Hold assembly by the arbor and tap chuck onto a block of wood with medium force, as illustrated below.

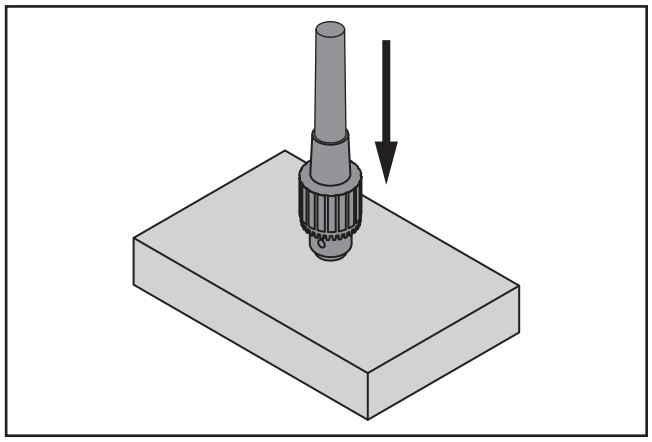


Figure 14. Tapping drill chuck/arbor on block of wood.

5. Attempt to separate drill chuck and arbor by hand—if they separate, repeat **Steps 3–4**.

Spindle Break-In

The spindle break-in procedure distributes lubrication throughout the bearings to reduce the risk of early bearing failure if there are any "dry" spots or areas where lubrication has settled in the bearings. You ***must*** complete this procedure ***before*** placing operational loads on the spindle for the first time when the machine is new or if it has been sitting idle for longer than 6 months.

Always start the spindle break-in at the lowest speed to minimize wear if there *are* dry spots. Allow the spindle to run long enough to warm up and distribute the bearing grease, then incrementally increase spindle speeds and repeat this process at each speed until reaching the maximum spindle speed. Following the break-in procedure in this progressive manner helps minimize any potential wear that could occur before lubrication is fully distributed.

NOTICE

Complete spindle bearing break-in procedure to prevent rapid wear and tear of spindle components once drill press is placed into operation.

To perform spindle break-in:

1. Make sure spindle area is free of obstructions.

2. Configure V-belts for a spindle speed of 30 RPM. Refer to **Changing Spindle Speed Range** on **Page 26**.

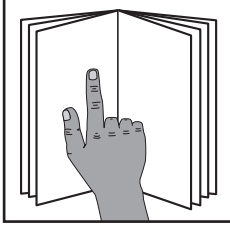
3. Connect machine to power and run spindle clockwise for 10 minutes, then counterclockwise for 10 minutes.

4. Turn machine ***OFF***, and allow spindle to come to a complete stop.

5. Repeat **Steps 2–4** for each speed listed below in progressive order.

   a. 650 RPM
   b. 1500 RPM
   c. 3000 RPM

OPERATIONS

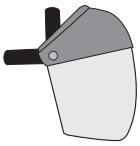


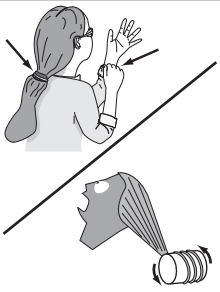
⚠WARNING

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

⚠WARNING

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





⚠WARNING

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

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.

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.

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

1. Examines workpiece to make sure it is suitable for drilling.
2. Puts on required safety glasses and face shield.
3. Firmly secures workpiece to table using vise or T-slot clamps.
4. Installs correct drill bit for operation.
5. Adjusts table to correct height and tilt, then locks it in place.
6. Selects appropriate spindle speed according to drill bit speed chart located on **Page 25**.
7. Configures machine for appropriate spindle speed range.
8. Connects machine to power, starts spindle rotation, and sets spindle speed.
9. Performs drilling operation.
10. When finished, turns machine ***OFF*** and disconnects it from power.

Power Controls

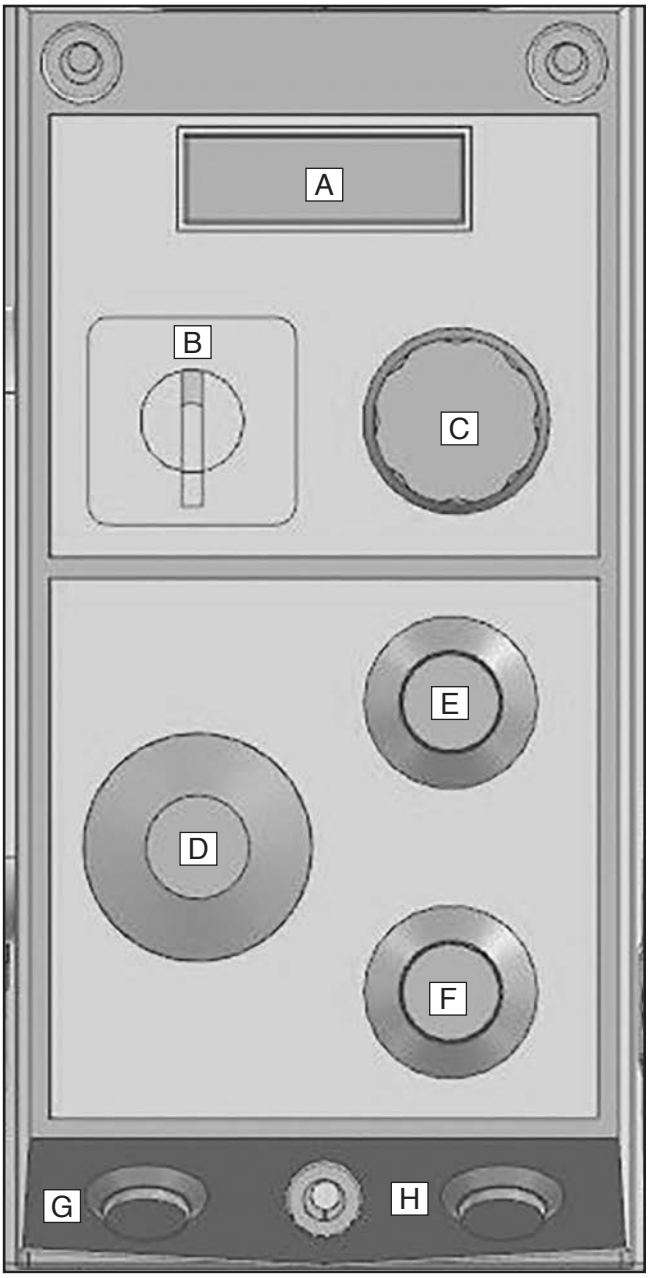


Figure 15. Control panel controls.

A. Spindle Speed Digital Readout: Displays spindle speed (RPM).

B. Rotation Direction Switch: Controls spindle rotation direction.

C. Spindle Speed Dial: Adjusts spindle speed.

D. EMERGENCY STOP Button: Turns ***OFF*** machine and prevents it from turning ***ON***. To reset, twist button clockwise until it pops out.

E. Start Button: Starts spindle.

F. Stop Button: Stops spindle.

G. Laser Switch: Turns laser guide ***ON*** or ***OFF***.

H. LED Switch: Turns LED ***ON*** or ***OFF***.

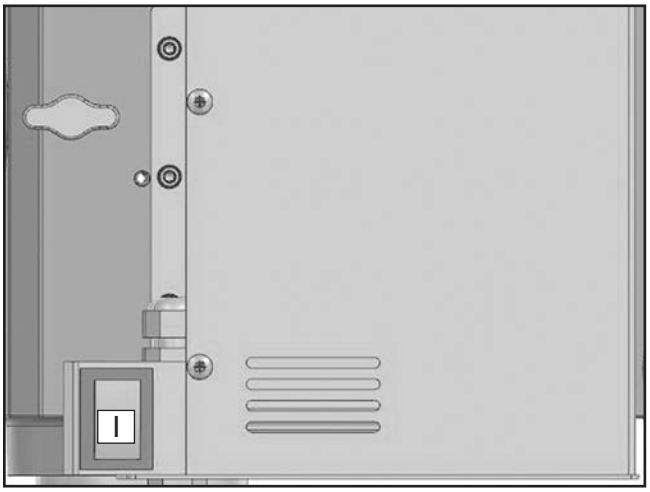


Figure 16. Master power switch.

I. Master Power Switch: Turns incoming machine power ***ON*** or ***OFF***.

Installing/Removing Arbor

Usually, once the chuck and arbor have been properly mounted together, they are considered semi-permanent connections. If you would like to install a different chuck, we recommend getting a new arbor for that chuck.

Installing Arbor in Spindle

1. Disconnect the machine from the power source.
2. Pivot chip guard out of the way.
3. Join chuck and arbor (refer to **Joining Drill Chuck & Arbor** on **Page 21**).
4. Rotate chuck on arbor until chuck jaws retract into drill chuck body.
5. Use acetone or lacquer thinner to clean mating surfaces of arbor and spindle socket.
6. Slide arbor (see **A** in **Figure 17**) into spindle socket (see **B** in **Figure 17**) while slowly rotating chuck to line up tang on arbor with slot in socket.

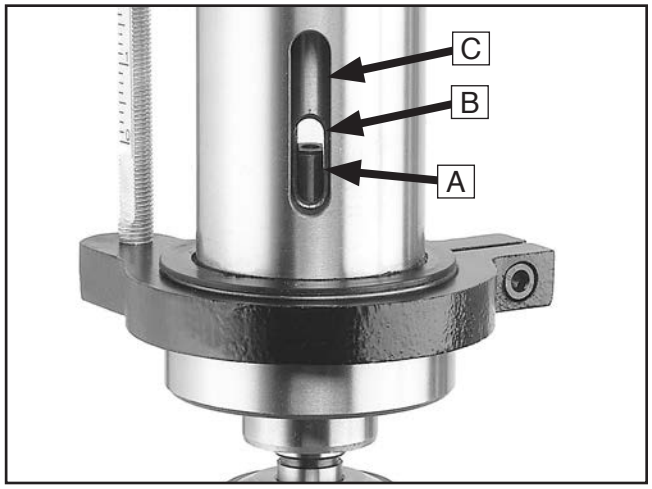


Figure 17. Example of arbor tang lined up with spindle socket.

7. Strike face of chuck from below with rubber-faced mallet to seat arbor in spindle.
8. Check seat by gently pulling down on chuck.
9. Pivot chip guard back into place.

Removing Arbor from Spindle

The arbor can be removed to install other Morse Taper #2 tooling in the spindle. A drift key is included to help remove the arbor or other tooling from the spindle.

To remove the arbor from the spindle:

1. Disconnect the machine from the power source.
2. Pivot chip guard out of the way.
3. Rotate downfeed handles until drift key slot is exposed in side of quill.
4. Rotate spindle until inner drift key slot (see **B** in **Figure 17**) is aligned with outer slot (see **C** in **Figure 17**). You will see through spindle when slot is properly aligned.
5. Insert drift key (see **A** in **Figure 18**) into drift key slot, then tap drift key with metal hammer (see **B** in **Figure 18**) until chuck released.

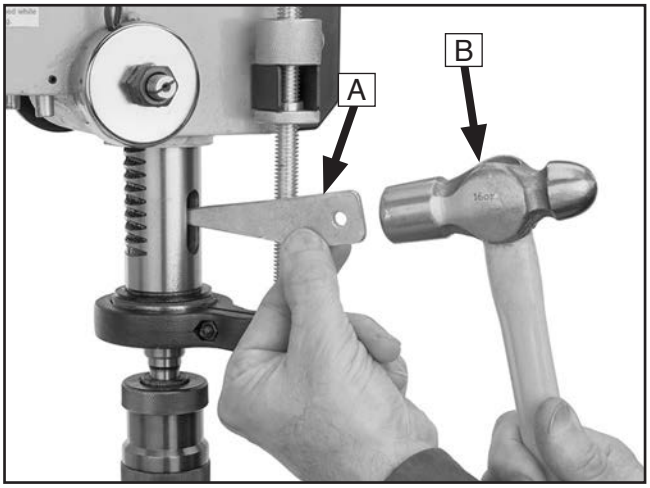


Figure 18. Example of using drift key to remove arbor from spindle.

Choosing Spindle Speeds

Using Drill Bit Speed Chart

The chart shown in **Figure 28** is intended as a generic guide only. Always follow the manufacturer's speed recommendations if provided with your drill bits, cutters, or hole saws. Exceeding the recommended speeds may be dangerous to the operator.

The speeds shown here are intended to get you started. The optimum speed will always depend on various factors, including tool diameter, drilling pressure, material hardness, material quality, and desired finish.

Often, when drilling materials other than wood, some type of lubrication is necessary.

Lubrication Suggestions

Wood .....None
Plastics .....Soapy Water
Brass .....Water-Based Lubricant
Aluminum..... Paraffin-Based Lubricant
Mild Steel..... Oil-Based Lubricant

⚠CAUTION

Larger bits turning at slower speeds tend to grab workpiece aggressively. This can result in operator's hand being pulled into bit or workpiece being thrown with great force. Always clamp workpiece to table to prevent reduce risk of injury.

Twist/Brad Point Drill Bits	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/16" – 3/16"	3000	2500	2500	2500	3000	2500
13/64" – 3/8"	2000	1500	2000	1250	2500	1250
25/64" – 5/8"	1500	750	1500	750	1500	600
11/16" – 1"	750	500	1000	400	1000	350

Spade/Forstner Bits	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/4" – 1/2"	2000	1500				
9/16" – 1"	1500	1250				
1-1/8" – 1-7/8"	1000	750				
2–3"	500	350				

Hole Saws	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/2" – 7/8"	500	500	600	600	600	500
1" – 1-7/8"	400	400	500	500	500	400
2" – 2-7/8"	300	300	400	400	400	300
3" – 3-7/8"	200	200	300	300	300	200
4" – 5"	100	100	200	200	200	100

Rosette Cutters	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
Carbide Insert Type	350	250				
One-Piece Type	1800	500				

Tenon/Plug Cutters	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
3/8" – 1/2"	1200	1000				
5/8" – 1"	800	600				

Figure 19. Drill bit speed chart (RPMs).

Changing Spindle Speed Range

A spindle speed and belt arrangement chart is found on the inside of the belt door. Refer to this chart whenever changing speeds.

To change spindle speed range:

1. Disconnect the machine from the power source.

2. Loosen the lock knob on the belt door, then open the door.

3. Release V-belt tension by loosening two knobs (see **A** in **Figure 20**) and tightening two hex bolts (see **B** in **Figure 20**).

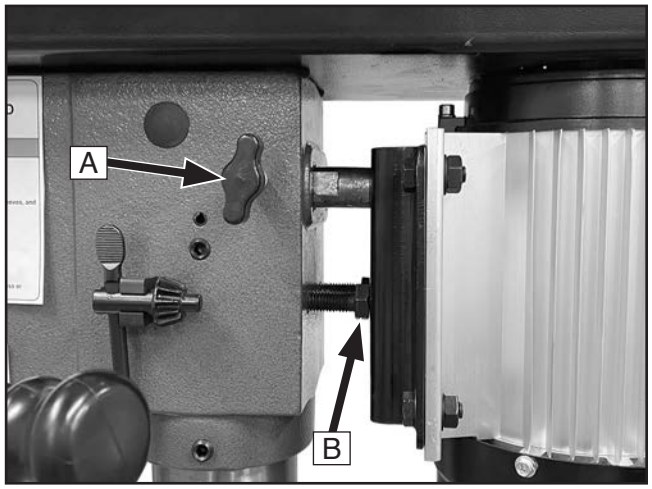


Figure 20. V-belt tension components.

4. Move V-belt onto desired pulley sheaves according to chart on belt door.

5. Adjust motor position by loosening hex bolts (see **B** in **Figure 20**) so belt deflects approximately 10mm when pressed with thumb midway between two pulleys.

6. Tighten knobs (see **A** in **Figure 20**).

7. Close and lock the belt door.

Adjusting Depth Stop

To drill multiple holes at the same preset depth, use the depth stop:

1. With the drill bit in the chuck, lower the downfeed handle to advance the chuck to the desired point.

2. Turn the depth scale collar (see **C** in **Figure 21**) counterclockwise until it stops moving.

3. Tighten the depth scale lock knob (see **D** in **Figure 21**).

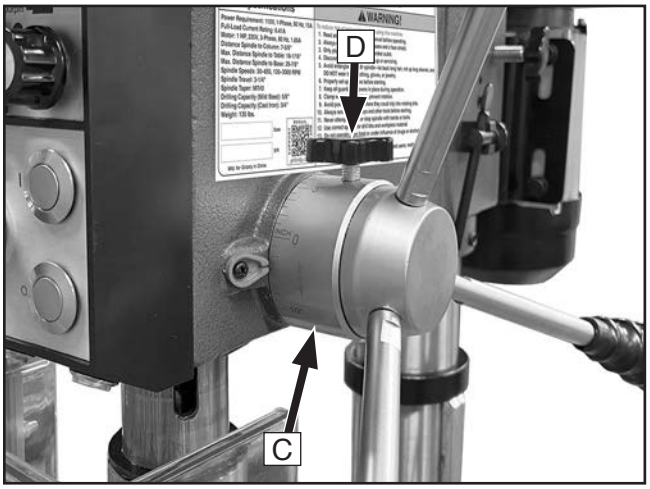


Figure 21. Depth stop components (T34612 shown).

Tilting Table

To tilt the table:

1. Disconnect the machine from the power source.

2. Tighten the cap screw (see **B** in **Figure 22**) to pull locking taper pin out of table bracket.

3. Loosen the hex bolt (see **C** in **Figure 22**) to tilt the table. Only loosen the hex bolt slightly, otherwise the table assembly will separate from the column and fall.

4. Tighten the hex bolt (see **C** in **Figure 22**).

   — If returning table tilt to 0°, install taper pin assembly (see **B** in **Figure 22**) and loosen cap screw to secure.

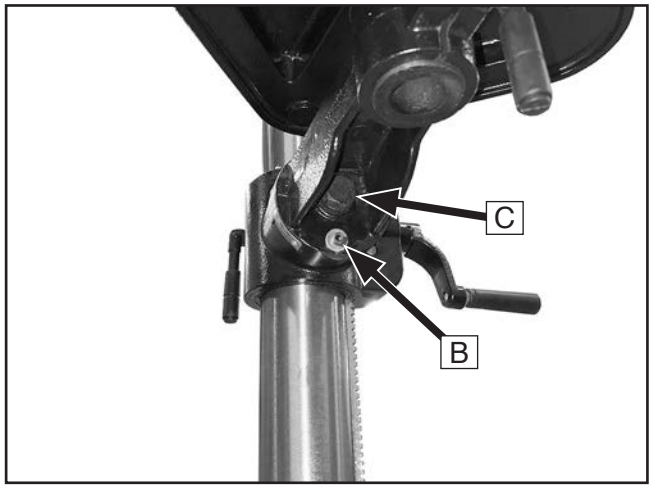


Figure 22. Table tilt components.

Adjusting Laser Guide

The lasers are designed for use with twist drill bits. There will be shadowing with wider tools, such as Forstner bits, therefore use will be limited. The two laser beams need to meet at the drill center (see **Figure 23**).

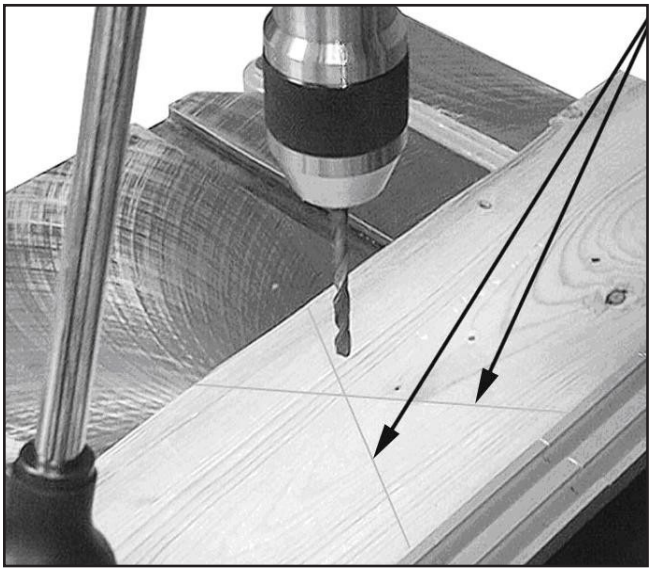


Figure 23. Location of laser beams.

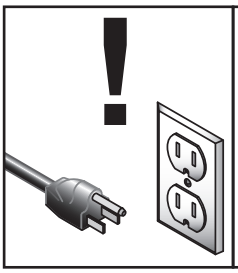
The laser assembly has been installed and preset at the factory. To adjust, install a small drill bit and rotate lasers gently with a set of pliers.

Loosen screws holding lasers to adjust.

⚠CAUTION

- **Do not stare into beam of laser.**
- **Do not view directly with optical instruments.**
- **Do not point the laser beam at people or animals.**
- **Do not use the laser beam on highly reflective materials. Reflected laser light is dangerous.**
- **A defective laser beam may be replaced only, not repaired.**

MAINTENANCE



⚠WARNING

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

⚠WARNING

Defective safety devices must be replaced immediately in order to reduce risk of personal injury.

⚠WARNING

Repair and maintenance of the electrical system may only be carried out by a qualified electrician. Failure to heed this warning could result in electrocution, fire, shock, or equipment damage.

Cleaning & Protecting

Clean the machine regularly. Apply metal protectant to unpainted metal parts.

Lubrication

Periodically lubricate the pinion gear and the rack, the table elevation mechanism, the drive splines (grooves) in the spindle, and the teeth of the quill gently with grease.

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.*

Use the table below for general troubleshooting of the Model T34612/T34613/T34614. For issues concerning the VFD, contact LINGSHIDA to obtain a LSD-J7100 (T34612/T34613) or LSD-C7100 (T34614) manual (or visit **https://www.lsdvfd.com**). 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.

Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor does not start.	1. No electricity. 2. Defective switch, motor, or cord.	1. Check main power and fuses. 2. Consult an electrician.
Chuck will not stay on spindle.	1. Oil or grease on contact surfaces.	1. Clean the tapered surfaces of chuck and spindle.
Machine vibration.	1. Incorrect belt tension. 2. Dry spindle quill. 3. Spindle pulley loose. 4. Motor pulley loose. 5. Dull drill bit.	1. Adjust belt tension. 2. Lubricate spindle quill. 3. Tighten retaining nut. 4. Tighten set screw. 5. Resharpen drill bit.
Drill bit burns.	1. Incorrect speed. 2. Chips clogged. 3. Dull drill bit. 4. Feeding too slow.	1. Reduce speed. 2. Retract drill bit frequently. 3. Resharpen drill bit. 4. Feed faster.
Drill leads off.	1. Cutting lips or angle not equal. 2. Drilled hole off-center. 3. Bent drill bit. 4. Drill bit not properly installed.	1. Resharpen drill bit correctly. 2. Drill a pilot hole first. 3. Use a proper drill bit. 4. Install drill bit correctly.

Adjusting Return Spring Tension

The return spring is adjusted at the factory and should not need further adjustment.

If adjustment is necessary:

1. Disconnect the machine from the power source.

2. Loosen two lock nuts (see **A** in **Figure 24**) approximately 6mm.

3. Firmly hold the coil spring cover (see **B** in **Figure 24**).

4. Pull out the cover and rotate until the pin (see **C** in **Figure 24**) on the return spring plate engages the next notch in the coil spring cover. Turn the cover clockwise to decrease tension and counterclockwise to increase tension.

5. Tighten two lock nuts (see **A** in **Figure 24**). Do not over-tighten. Nuts should not contact the housing when tight.

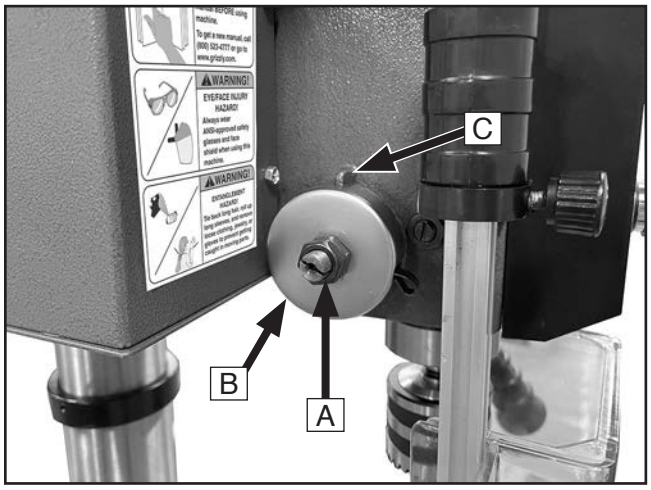


Figure 24. Return spring adjustment components.

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.

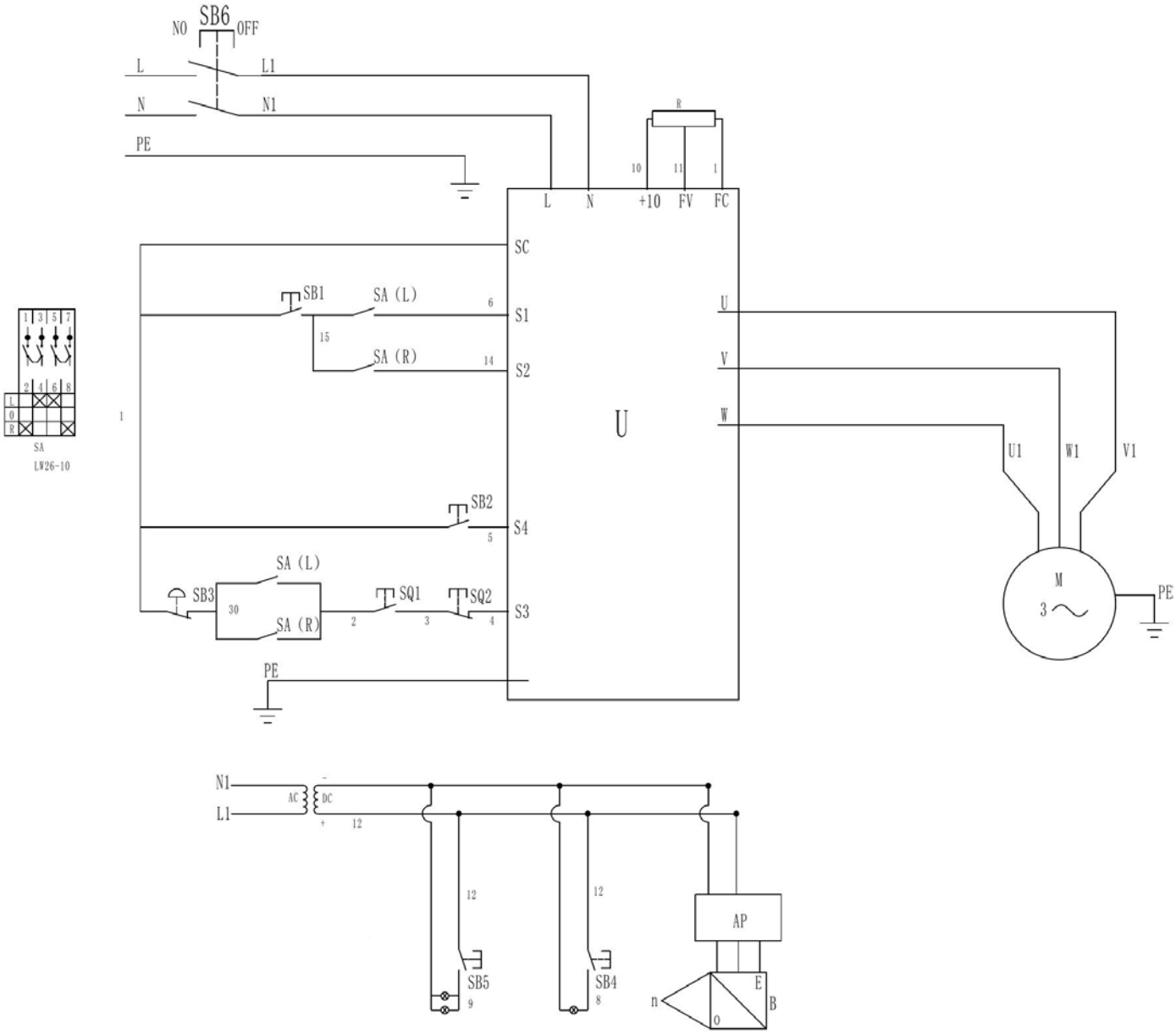
WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

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.

Wiring Schematic



SB1: Start Button
SB2: Stop Button
SB3: EMERGENCY STOP Button
SB4: LED Button
SB5: Laser Button
R: Potentiometer
T: Transformer

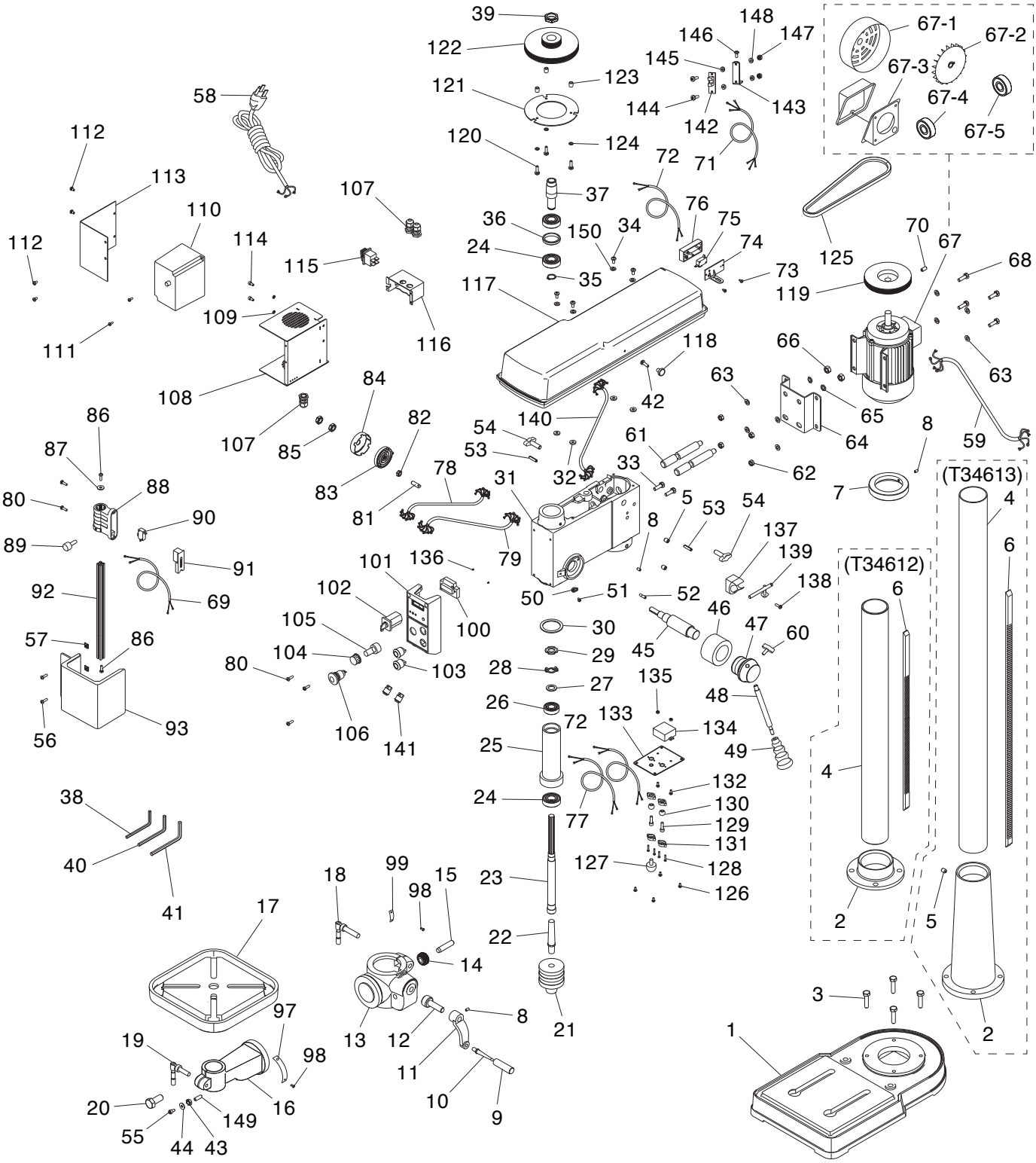
SB6: Master Power Switch
SQ1: Belt Door Safety Switch
SQ2: Chip Guard Safety Switch
M: Motor
AP: Spindle Speed Digital Readout
U: VFD

READ ELECTRICAL SAFETY ON PAGE 31!

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.

T34612/T34613 Main



T34612/T34613 Main Parts List

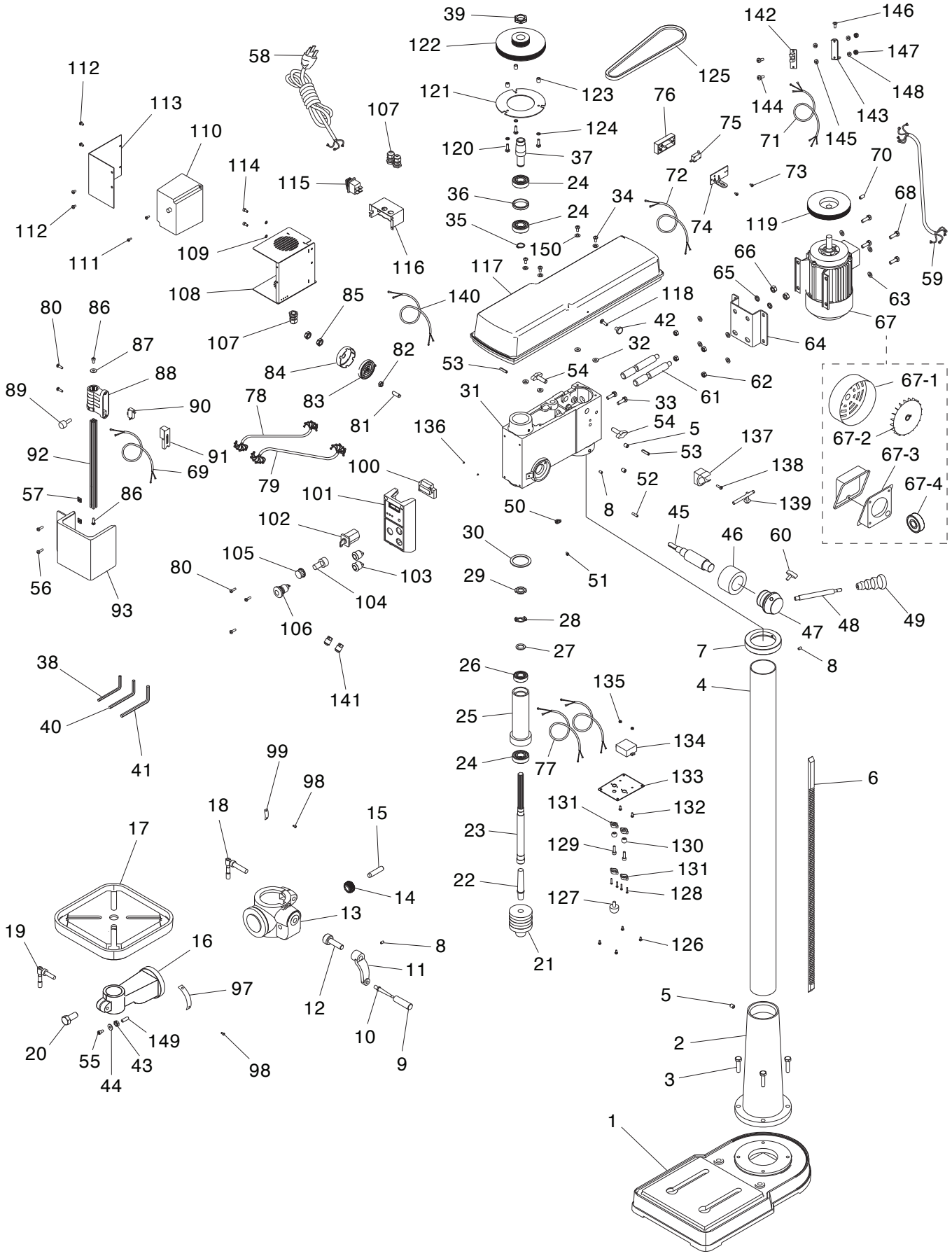
REF	PART #	DESCRIPTION
1	PT34612001	BASE
2	PT34612002	COLUMN SUPPORT (T34612)
2	PT34613002	COLUMN SUPPORT (T34613)
3	PT34612003	HEX BOLT M10-1.5 X 35
4	PT34612004	COLUMN (T34612)
4	PT34613004	COLUMN (T34613)
5	PT34612005	SET SCREW M10-1.5 X 12
6	PT34612006	RACK (T34612)
6	PT34613004	RACK (T34613)
7	PT34612007	RACK COLLAR
8	PT34612008	SET SCREW M6-1 X 10
9	PT34612009	CRANK ARM HANDLE GRIP
10	PT34612010	CRANK ARM HANDLE SHAFT
11	PT34612011	CRANK ARM
12	PT34612012	WORM SHAFT
13	PT34612013	TABLE SUPPORT
14	PT34612014	HELICAL GEAR 14T
15	PT34612015	GEAR PIN
16	PT34612016	TABLE BRACKET
17	PT34612017	TABLE
18	PT34612018	FOLDING HANDLE M12-1.75 X 35
19	PT34612019	FOLDING HANDLE M10-1.5 X 28
20	PT34612020	HEX BOLT M16-2 X 35
21	PT34612021	CHUCK JT3 5/8"
22	PT34612022	ARBOR JT3 X MT#2
23	PT34612023	SPINDLE MT#2
24	PT34612024	BALL BEARING 6204-2RS
25	PT34612025	QUILL
26	PT34612026	BALL BEARING 6203-2RS
27	PT34612027	FLAT WASHER 17.5 X 27 X 2MM
28	PT34612028	EXT TOOTH WASHER 17.5MM
29	PT34612029	SPANNER NUT M17-1
30	PT34612030	FLAT WASHER 46.3 X 60 X 4MM
31	PT34612031	HEADSTOCK
32	PT34612032	FOAM PAD
33	PT34612033	HEX BOLT M10-1.5 X 30
34	PT34612034	PHLP HD SCR M6-1 X 12
35	PT34612035	EXT RETAINING RING 20MM
36	PT34612036	SPACER 38 X 46 X 7.5MM
37	PT34612037	SPLINE SHAFT
38	PT34612038	HEX WRENCH 3MM
39	PT34612039	HEX NUT M24-1.5 LH
40	PT34612040	HEX WRENCH 4MM
41	PT34612041	HEX WRENCH 5MM
42	PT34612042	PHLP HD SCR M5-.8 X 20
43	PT34612043	HEX NUT M10-1.5 THIN
44	PT34612044	FENDER WASHER 6MM
45	PT34612045	GEAR SHAFT 13T
46	PT34612046	DEPTH COLLAR STOP W/SCALE
47	PT34612047	HUB
48	PT34612048	STUD-UDE M10-1.5 X 13, M8-1.25 X 15, 146
49	PT34612049	KNOB M8-1.25
50	PT34612050	POINTER
51	PT34612051	PHLP HD SCR M4-.7 X 8
52	PT34612052	STOP SCREW M6-1 X 8
53	PT34612053	ROLL PIN 6 X 26
54	PT34612054	KNOB BOLT M10-1.5 X 33
55	PT34612055	CAP SCREW M5-.8 X 12
56	PT34612056	PHLP HD SCR M5-.8 X 8
57	PT34612057	T-SLOT NUT M5-.8
58	PT34612058	POWER CORD 16G 3W 72" 5-15
59	PT34612059	MOTOR CORD 18G 4W 31"
60	PT34612060	KNOB BOLT M8-1.25 X 17
61	PT34612061	SLIDE BAR
62	PT34612062	HEX NUT M8-1.25
63	PT34612063	FLAT WASHER 8MM
64	PT34612064	MOTOR BASE
65	PT34612065	LOCK WASHER 12MM
66	PT34612066	HEX NUT M12-1.75
67	PT34612067	MOTOR 1HP 220V 3-PH
67-1	PT34612067-1	MOTOR FAN COVER
67-2	PT34612067-2	MOTOR FAN
67-3	PT34612067-3	JUNCTION BOX
67-4	PT34612067-4	BALL BEARING 6204-2RS (FRONT)
67-5	PT34612067-5	BALL BEARING 6204-2RS (REAR)
68	PT34612068	HEX BOLT M8-1.25 X 25
69	PT34612069	GUARD SWITCH CORD 20G 2W 8"
70	PT34612070	SET SCREW M8-1.25 X 16
71	PT34612071	SENSOR CORD 24G 3W 19"
72	PT34612072	DOOR SWITCH CORD 18G 2W 23"
73	PT34612073	TAP SCREW M4.2 X 9.5
74	PT34612074	MICRO SWITCH COVER
75	PT34612075	MICRO SWITCH LEMA KW-7-3C
76	PT34612076	MICRO SWITCH BOX
77	PT34612077	LASER CORD 24G 2W 8"
78	PT34612078	CONTROL PANEL CORD I 20G 7W 37"
79	PT34612079	CONTROL PANEL CORD II 20G 4W 20"
80	PT34612080	PHLP HD SCR M5-.8 X 16
81	PT34612081	ROTATION STOP SCREW M10-1.5 X 28
82	PT34612082	HEX NUT M10-1.5
83	PT34612083	FLAT COIL SPRING
84	PT34612084	RETURN SPRING COVER
85	PT34612085	HEX NUT M12-1.5 THIN
86	PT34612086	PHLP HD SCR M6-1 X 8
87	PT34612087	FENDER WASHER 6MM
88	PT34612088	MICRO SWITCH BASE
89	PT34612089	KNOB BOLT M6-1 X 20
90	PT34612090	MICRO SWITCH LEMA KW7-03B
91	PT34612091	MICRO SWITCH COVER
92	PT34612092	CHIP GUARD RAIL
93	PT34612093	CHIP GUARD
97	PT34612097	TABLE ANGLE SCALE
98	PT34612098	RIVET 4 X 6MM BLIND
99	PT34612099	ANGLE SCALE POINTER
100	PT34612100	RPM DRO
101	PT34612101	CONTROL PANEL
102	PT34612102	ROTATION SWITCH WHUROW LW26-10
103	PT34612103	PUSH BUTTON YONGLI YL22S-A10P

T34612/T34613 Main Parts List (Cont.)

REF	PART #	DESCRIPTION
104	PT34612104	SPEED DIAL
105	PT34612105	POTENTIOMETER COSMOS RV24YN 20S
106	PT34612106	E-STOP BUTTON YONGLI YL19S-J11
107	PT34612107	STRAIN RELIEF PG9
108	PT34612108	VFD BASE
109	PT34612109	LOCK WASHER 5MM
110	PT34612110	VFD LINGSHIDA J7100-1.5KW
111	PT34612111	PHLP HD SCR M4-.7 X 10
112	PT34612112	PHLP HD SCR M5-.8 X 12
113	PT34612113	VFD SIDE COVER
114	PT34612114	CAP SCREW M5-.8 X 12
115	PT34612115	POWER SWITCH JIN DING JD03-K1
116	PT34612116	SWITCH BOX
117	PT34612117	PULLEY COVER
118	PT34612118	KNOB M5-.8
119	PT34612119	MOTOR PULLEY
120	PT34612120	PHLP HD SCR M6-1 X 20
121	PT34612121	LOCKING RING
122	PT34612122	SPINDLE PULLEY
123	PT34612123	SPACER 5 X 10 X 11MM
124	PT34612124	LOCK WASHER 6MM
125	PT34612125	POLY V-BELT 440J
126	PT34612126	PHLP HD SCR M4-.7 X 12
127	PT34612127	LED 5V 1W

REF	PART #	DESCRIPTION
128	PT34612128	PHLP HD SCR M3-.5 X 16
129	PT34612129	LASER DKLD LDBX003B
130	PT34612130	LASER COLLAR
131	PT34612131	LASER SEAT
132	PT34612132	PHLP HD SCR M4-.7 X 12
133	PT34612133	LASER MOUNTING BASE
134	PT34612134	TRANSFORMER DKLD B26-7B
135	PT34612135	HEX NUT M4-.7
136	PT34612136	TAP SCREW M2.5 X 6
137	PT34612137	CHUCK KEY HOLDER
138	PT34612138	PHLP HD SCR M4-.7 X 12
139	PT34612139	CHUCK KEY
140	PT34612140	HEADSTOCK CORD 2G 16W 8"
141	PT34612141	PUSH BUTTON YONGLI YL16S-H11GZ
142	PT34612142	SPEED SENSOR DONGKE CB07-5L
143	PT34612143	SENSOR MOUNT
144	PT34612144	PHLP HD SCR M3-.5 X 14
145	PT34612145	SPACER 4 X 6 X 3MM
146	PT34612146	PHLP HD SCR M4-.7 X 12
147	PT34612147	HEX NUT M3-.5
148	PT34612148	FLAT WASHER 3MM
149	PT34612149	TAPER PIN 8 X 25MM, M5-.8
150	PT34612150	FLAT WASHER 6MM

T34614 Main



T34614 Main Parts List

REF	PART #	DESCRIPTION
1	PT34614001	BASE
2	PT34614002	COLUMN SUPPORT
3	PT34614003	HEX BOLT M10-1.5 X 35
4	PT34614004	COLUMN
5	PT34614005	SET SCREW M10-1.5 X 12
6	PT34614006	RACK
7	PT34614007	RACK COLLAR
8	PT34614008	SET SCREW M6-1 X 10
9	PT34614009	CRANK ARM HANDLE GRIP
10	PT34614010	CRANK ARM HANDLE SHAFT
11	PT34614011	CRANK ARM
12	PT34614012	WORM SHAFT
13	PT34614013	TABLE SUPPORT
14	PT34614014	HELICAL GEAR 14T
15	PT34614015	GEAR PIN
16	PT34614016	TABLE BRACKET
17	PT34614017	TABLE
18	PT34614018	FOLDING HANDLE M12-1.75 X 35
19	PT34614019	FOLDING HANDLE M10-1.5 X 28
20	PT34614020	HEX BOLT M16-2 X 35
21	PT34614021	CHUCK JT3 5/8"
22	PT34614022	ARBOR JT3 X MT#2
23	PT34614023	SPINDLE MT#2
24	PT34614024	BALL BEARING 6205-2RS
25	PT34614025	QUILL
26	PT34614026	BALL BEARING 6203-2RS
27	PT34614027	FLAT WASHER 17.5 X 27 X 2MM
28	PT34614028	EXT TOOTH WASHER 17.5MM
29	PT34614029	SPANNER NUT M17-1
30	PT34614030	FLAT WASHER 46.3 X 60 X 4MM
31	PT34614031	HEADSTOCK
32	PT34614032	FOAM PAD
33	PT34614033	HEX BOLT M10-1.5 X 30
34	PT34614034	PHLP HD SCR M6-1 X 12
35	PT34614035	EXT RETAINING RING 25MM
36	PT34614036	SPACER 42 X 51.5 X 5MM
37	PT34614037	SPLINE
38	PT34614038	HEX WRENCH 3MM
39	PT34614039	HEX NUT M24-1.5 LH
40	PT34614040	HEX WRENCH 4MM
41	PT34614041	HEX WRENCH 5MM
42	PT34614042	KNOB M5-.8
43	PT34614043	HEX NUT M10-1.5 THIN
44	PT34614044	FENDER WASHER 6MM
45	PT34614045	GEAR SHAFT 13T
46	PT34614046	DEPTH COLLAR STOP W/SCALE
47	PT34614047	HUB
48	PT34614048	STUD-UDE M10-1.5 X 13, M8-1.25 X 15, 146
49	PT34614049	KNOB M8-1.25
50	PT34614050	POINTER
51	PT34614051	PHLP HD SCR M4-.7 X 8
52	PT34614052	STOP SCREW M6-1 X 8
53	PT34614053	ROLL PIN 6 X 26
54	PT34614054	KNOB BOLT M10-1.5 X 33
55	PT34614055	CAP SCREW M5-.8 X 12

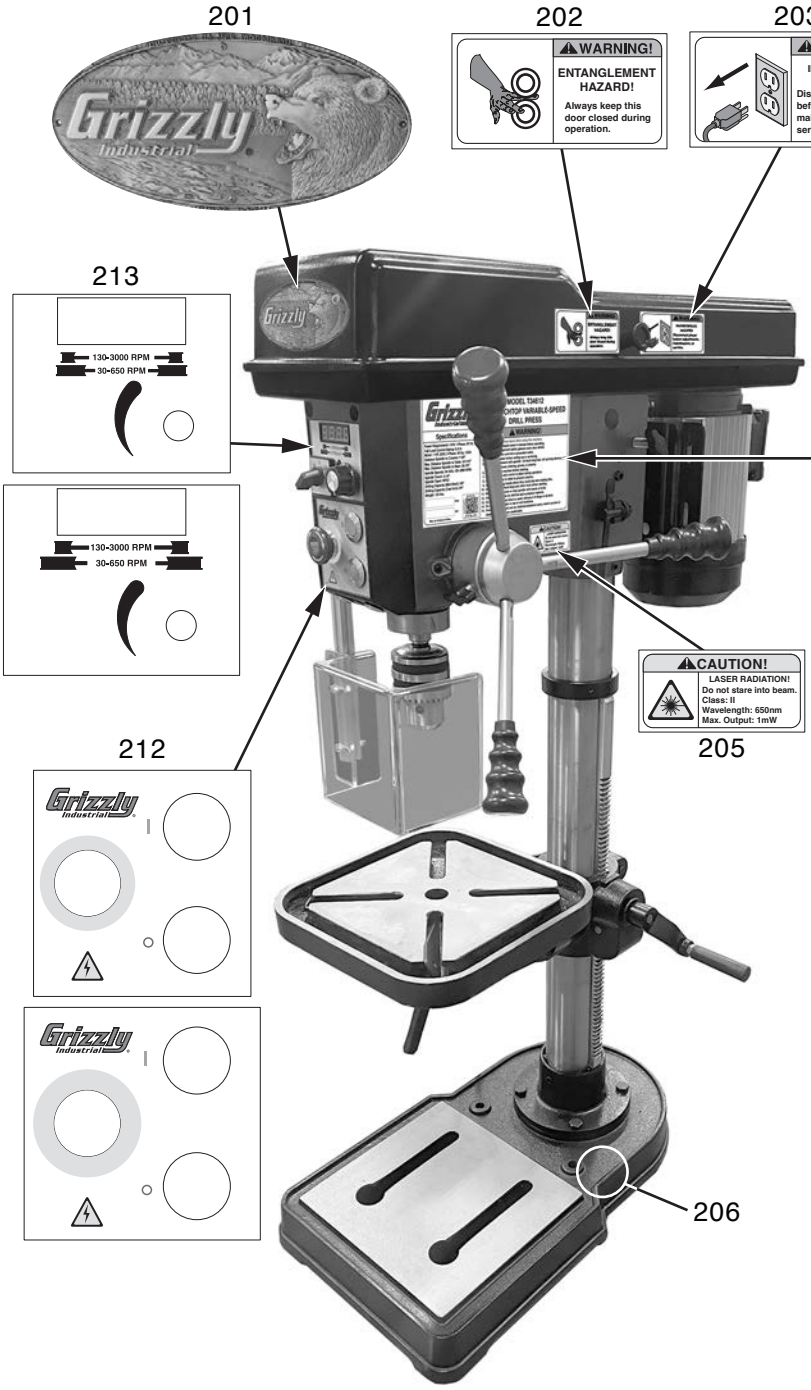
REF	PART #	DESCRIPTION
56	PT34614056	PHLP HD SCR M5-.8 X 8
57	PT34614057	T-SLOT NUT M5-.8
58	PT34614058	POWER CORD 16G 3W 72" 5-15
59	PT34614059	MOTOR CORD 18G 4W 31"
60	PT34614060	KNOB BOLT M8-1.25 X 17
61	PT34614061	SLIDE BAR
62	PT34614062	HEX NUT M8-1.25
63	PT34614063	FLAT WASHER 8MM
64	PT34614064	MOTOR BASE
65	PT34614065	LOCK WASHER 12MM
66	PT34614066	HEX NUT M12-1.75
67	PT34614067	MOTOR 1.5HP 220V 3-PH
67-1	PT34614067-1	MOTOR FAN COVER
67-2	PT34614067-2	MOTOR FAN
67-3	PT34614067-3	JUNCTION BOX
67-4	PT34614067-4	BALL BEARING 6204-2RS
68	PT34614068	HEX BOLT M8-1.25 X 25
69	PT34614069	GUARD SWITCH CORD 20G 2W 8"
70	PT34614070	SET SCREW M8-1.25 X 16
71	PT34614071	SENSOR CORD 24G 3W 19"
72	PT34614072	DOOR SWITCH CORD 18G 2W 23"
73	PT34614073	TAP SCREW M4.2 X 9.5
74	PT34614074	MICRO SWITCH COVER
75	PT34614075	MICRO SWITCH LEMA KW-7-3C
76	PT34614076	MICRO SWITCH BOX
77	PT34614077	LASER CORD 24G 2W 8"
78	PT34614078	CONTROL PANEL CORD I 20G 7W 41"
79	PT34614079	CONTROL PANEL CORD II 20G 4W 24"
80	PT34614080	PHLP HD SCR M5-.8 X 16
81	PT34614081	ROTATION STOP SCREW M10-1.5 X 28
82	PT34614082	HEX NUT M10-1.5
83	PT34614083	FLAT COIL SPRING
84	PT34614084	RETURN SPRING COVER
85	PT34614085	HEX NUT M12-1.5 THIN
86	PT34614086	PHLP HD SCR M6-1 X 8
87	PT34614087	FENDER WASHER 6MM
88	PT34614088	MICRO SWITCH BASE
89	PT34614089	KNOB BOLT M6-1 X 20
90	PT34614090	MICRO SWITCH LEMA KW7-03B
91	PT34614091	MICRO SWITCH COVER
92	PT34614092	CHIP GUARD RAIL
93	PT34614093	CHIP GUARD
97	PT34614097	TABLE ANGLE SCALE
98	PT34614098	RIVET 4 X 6MM BLIND
99	PT34614099	ANGLE SCALE POINTER
100	PT34614100	RPM DRO
101	PT34614101	CONTROL PANEL
102	PT34614102	ROTATION SWITCH WHUROW LW26-10
103	PT34614103	PUSH BUTTON YONGLI YL22S-A10P
104	PT34614104	SPEED DIAL
105	PT34614105	POTENTIOMETER COSMOS RV24YN 20S
106	PT34614106	E-STOP BUTTON YONGLI YL19S-J11
107	PT34614107	STRAIN RELIEF PG9
108	PT34614108	VFD BASE
109	PT34614109	LOCK WASHER 5MM

T34614 Main Parts List (Cont.)

REF	PART #	DESCRIPTION
110	PT34614110	VFD LINGSHIDA C7100-1.5KW
111	PT34614111	PHLP HD SCR M4-.7 X 10
112	PT34614112	PHLP HD SCR M5-.8 X 12
113	PT34614113	VFD SIDE COVER
114	PT34614114	CAP SCREW M5-.8 X 12
115	PT34614115	POWER SWITCH JIN DING JD03-K1
116	PT34614116	SWITCH BOX
117	PT34614117	PULLEY COVER
118	PT34614118	PHLP HD SCR M5-.8 X 16
119	PT34614119	MOTOR PULLEY
120	PT34614120	PHLP HD SCR M6-1 X 20
121	PT34614121	LOCKING RING
122	PT34614122	SPINDLE PULLEY
123	PT34614123	SPACER 5 X 10 X 11MM
124	PT34614124	LOCK WASHER 6MM
125	PT34614125	POLY V-BELT 460J
126	PT34614126	PHLP HD SCR M4-.7 X 12
127	PT34614127	LED 5V 1W
128	PT34614128	PHLP HD SCR M3-.5 X 16
129	PT34614129	LASER DKLD LDBX003B
130	PT34614130	LASER COLLAR

REF	PART #	DESCRIPTION
131	PT34614131	LASER SEAT
132	PT34614132	PHLP HD SCR M4-.7 X 12
133	PT34614133	LASER MOUNTING BASE
134	PT34614134	TRANSFORMER DKLD B26-7B
135	PT34614135	HEX NUT M4-.7
136	PT34614136	TAP SCREW M2.5 X 6
137	PT34614137	CHUCK KEY HOLDER
138	PT34614138	PHLP HD SCR M4-.7 X 12
139	PT34614139	CHUCK KEY
140	PT34614140	HEADSTOCK CORD 2G 16W 9"
141	PT34614141	PUSH BUTTON YONGLI YL16S-H11GZ
142	PT34614142	SPEED SENSOR DONGKE CB07-5L
143	PT34614143	SENSOR MOUNT
144	PT34614144	PHLP HD SCR M3-.5 X 14
145	PT34614145	SPACER 4 X 6 X 3MM
146	PT34614146	PHLP HD SCR M4-.7 X 12
147	PT34614147	HEX NUT M3-.5
148	PT34614148	FLAT WASHER 3MM
149	PT34614149	TAPER PIN 8 X 25MM
150	PT34614150	FLAT WASHER 6MM

Labels & Cosmetics



204

MODEL T34612
15" BENCHTOP VARIABLE-SPEED DRILL PRESS

Specifications

Power Requirement: 110V, 1-Phase, 60 Hz, 15A
Full-Load Current Rating: 6.41A
Motor: 1 HP, 220V, 3-Phase, 60 Hz, 1.85A
Distance Spindle to Column: 7-5/8"
Max. Distance Spindle to Table: 18-1/16"
Max. Distance Spindle to Base: 26-7/8"
Spindle Speeds: 30–650, 130–3000 RPM
Spindle Travel: 3-1/4"
Spindle Taper: MT#2
Drilling Capacity (Mild Steel): 5/8"
Drilling Capacity (Cast Iron): 3/4"
Weight: 135 lbs.

Date
S/N
Mfd. for Grizzly in China

MANUAL SUPPORT grizzly.com

WARNING!

To reduce the risk of serious injury when using this machine:
1. Read and understand owner's manual before operating.
2. Always wear approved safety glasses and a face shield.
3. Only plug power cord into a grounded outlet.
4. Disconnect power before setting up or servicing.
5. Avoid entanglement with spindle—tie back long hair, roll up long sleeves, and DO NOT wear loose clothing, gloves, or jewelry.
6. Properly set up machine before starting.
7. Keep all guards and covers in place during operation.
8. Clamp workpiece to table to prevent rotation.
9. Avoid positioning hands where they could slip into rotating bits.
10. Always remove chuck keys and other tools before starting.
11. Never attempt to slow or stop spindle with hands or tools.
12. Use correct speeds for drill bits and workpiece material.
13. Do not operate when tired or under influence of drugs or alcohol.
14. Do not expose to rain or use in wet locations.
15. Prevent unauthorized use by children/untrained users; restrict access or disable machine when unattended.

MODEL T34613
15" FLOOR VARIABLE-SPEED DRILL PRESS

Specifications

Power Requirement: 110V, 1-Phase, 60 Hz, 15A
Full-Load Current Rating: 6.41A
Motor: 1 HP, 220V, 3-Phase, 60 Hz, 1.85A
Distance Spindle to Column: 7-5/8"
Max. Distance Spindle to Table: 28-3/8"
Max. Distance Spindle to Base: 48-1/16"
Spindle Speeds: 30–650, 130–3000 RPM
Spindle Travel: 3-1/4"
Spindle Taper: MT#2
Drilling Capacity (Mild Steel): 5/8"
Drilling Capacity (Cast Iron): 3/4"
Weight: 146 lbs.

Date
S/N
Mfd. for Grizzly in China

MANUAL SUPPORT grizzly.com

WARNING!

To reduce the risk of serious injury when using this machine:
1. Read and understand owner's manual before operating.
2. Always wear approved safety glasses and a face shield.
3. Only plug power cord into a grounded outlet.
4. Disconnect power before setting up or servicing.
5. Avoid entanglement with spindle—tie back long hair, roll up long sleeves, and DO NOT wear loose clothing, gloves, or jewelry.
6. Properly set up machine before starting.
7. Keep all guards and covers in place during operation.
8. Clamp workpiece to table to prevent rotation.
9. Avoid positioning hands where they could slip into rotating bits.
10. Always remove chuck keys and other tools before starting.
11. Never attempt to slow or stop spindle with hands or tools.
12. Use correct speeds for drill bits and workpiece material.
13. Do not operate when tired or under influence of drugs or alcohol.
14. Do not expose to rain or use in wet locations.
15. Prevent unauthorized use by children/untrained users; restrict access or disable machine when unattended.

MODEL T34614
17" FLOOR VARIABLE-SPEED DRILL PRESS

Specifications

Power Requirement: 110V, 1-Phase, 60 Hz, 15A
Full-Load Current Rating: 11.78A
Motor: 1-1/2 HP, 220V, 3-Phase, 60 Hz, 3.4A
Distance Spindle to Column: 8-1/2"
Max. Distance Spindle to Table: 28-9/16"
Max. Distance Spindle to Base: 48-1/2"
Spindle Speeds: 30–650, 130–3000 RPM
Spindle Travel: 3-1/4"
Spindle Taper: MT#2
Drilling Capacity (Mild Steel): 3/4"
Drilling Capacity (Cast Iron): 1"
Weight: 170 lbs.

Date
S/N
Mfd. for Grizzly in China

MANUAL SUPPORT grizzly.com

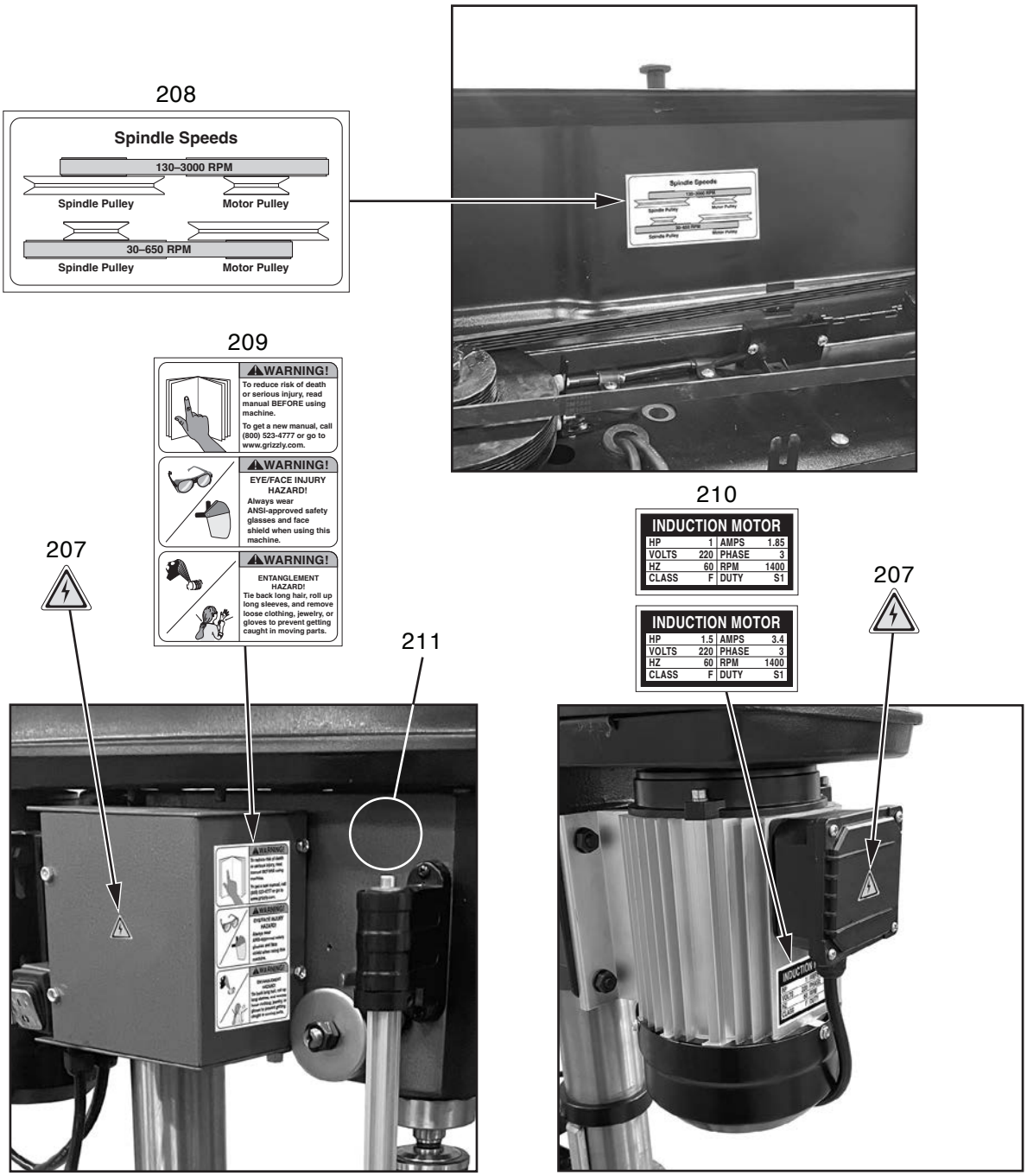
WARNING!

To reduce the risk of serious injury when using this machine:
1. Read and understand owner's manual before operating.
2. Always wear approved safety glasses and a face shield.
3. Only plug power cord into a grounded outlet.
4. Disconnect power before setting up or servicing.
5. Avoid entanglement with spindle—tie back long hair, roll up long sleeves, and DO NOT wear loose clothing, gloves, or jewelry.
6. Properly set up machine before starting.
7. Keep all guards and covers in place during operation.
8. Clamp workpiece to table to prevent rotation.
9. Avoid positioning hands where they could slip into rotating bits.
10. Always remove chuck keys and other tools before starting.
11. Never attempt to slow or stop spindle with hands or tools.
12. Use correct speeds for drill bits and workpiece material.
13. Do not operate when tired or under influence of drugs or alcohol.
14. Do not expose to rain or use in wet locations.
15. Prevent unauthorized use by children/untrained users; restrict access or disable machine when unattended.

⚠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.

Labels & Cosmetics (Cont.)



REF	PART #	DESCRIPTION
201	PT34612201	NAMEPLATE MINI
202	PT34612202	DOOR CLOSED LABEL
203	PT34612203	INJURY/SHOCK LABEL
204	PT34612204	MACHINE ID LABEL (T34612)
204	PT34613204	MACHINE ID LABEL (T34613)
204	PT34614204	MACHINE ID LABEL (T34614)
205	PT34612205	LASER RADIATION LABEL
206	PT34612206	TOUCH-UP PAINT, GLOSSY BLACK
207	PT34612207	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
208	PT34612208	SPINDLE SPEED LABEL
209	PT34612209	COMBO WARNING LABEL
210	PT34612210	MOTOR LABEL (T34612/T34613)
210	PT34614210	MOTOR LABEL (T34614)
211	PT34612211	TOUCH-UP PAINT, GRIZZLY GREEN
212	PT34612212	CONTROL PANEL LABEL LOWER (T34612/T34613)
212	PT34614212	CONTROL PANEL LABEL LOWER (T34614)
213	PT34612213	CONTROL PANEL LABEL UPPER (T34612/T34613)
213	PT34614213	CONTROL PANEL LABEL UPPER (T34614)

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