

Grizzly **Industrial, Inc.**®

MODEL G0637/G0638 7½ & 10 HP CYCLONE DUST COLLECTORS OWNER'S MANUAL



Model G0637



Model G0638

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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
FOR MODELS MANUFACTURED SINCE 8/10 #TS8762 PRINTED IN TAIWAN

 **WARNING!**

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

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

The owner of this machine/equipment 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, blade/cutter 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

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		WARNING!	
Motor:		<p>ing this machine: operation. s and respirator. sted/setup and suit before starting.</p> <p>4. make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. 5. DO NOT expose to rain or dampness. 6. DO NOT modify this machine in any way. 7. DO NOT remove safety guards. 8. Never leave machine running unattended. 9. DO NOT operate under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.</p>	
Specification:			
Specification:			
Specification:			
Weight:			
<input type="text"/>	Date		
<input type="text"/>	Serial Number		
Manufactured for Grizzly in Taiwan			
Manufacture Date of Your Machine			

For your convenience, we post all available manuals and manual updates for free on our website at www.grizzly.com. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
E-Mail: techsupport@grizzly.com

We want your feedback on this manual. If you can take the time, please email or write to us at the address below and tell us how we did:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

The Model G0637/G0638 is a 2-stage cyclone wood dust collector capable of collecting dust from multiple machines running simultaneously.

Cyclonic action separates the heavy dust and chips from the fine particles and drops them into the steel collection drum. Any remaining fine dust travels past the impeller and is trapped by the pleated cartridge filter made of spun-bond polyester. With the use of the cable and pulley system on the outside of the filter assembly, the caked dust is forced down into the collection bag.

The machine is controlled directly by the magnetic switch mounted to it or by the IR remote switch—each control includes timer options.



Identification

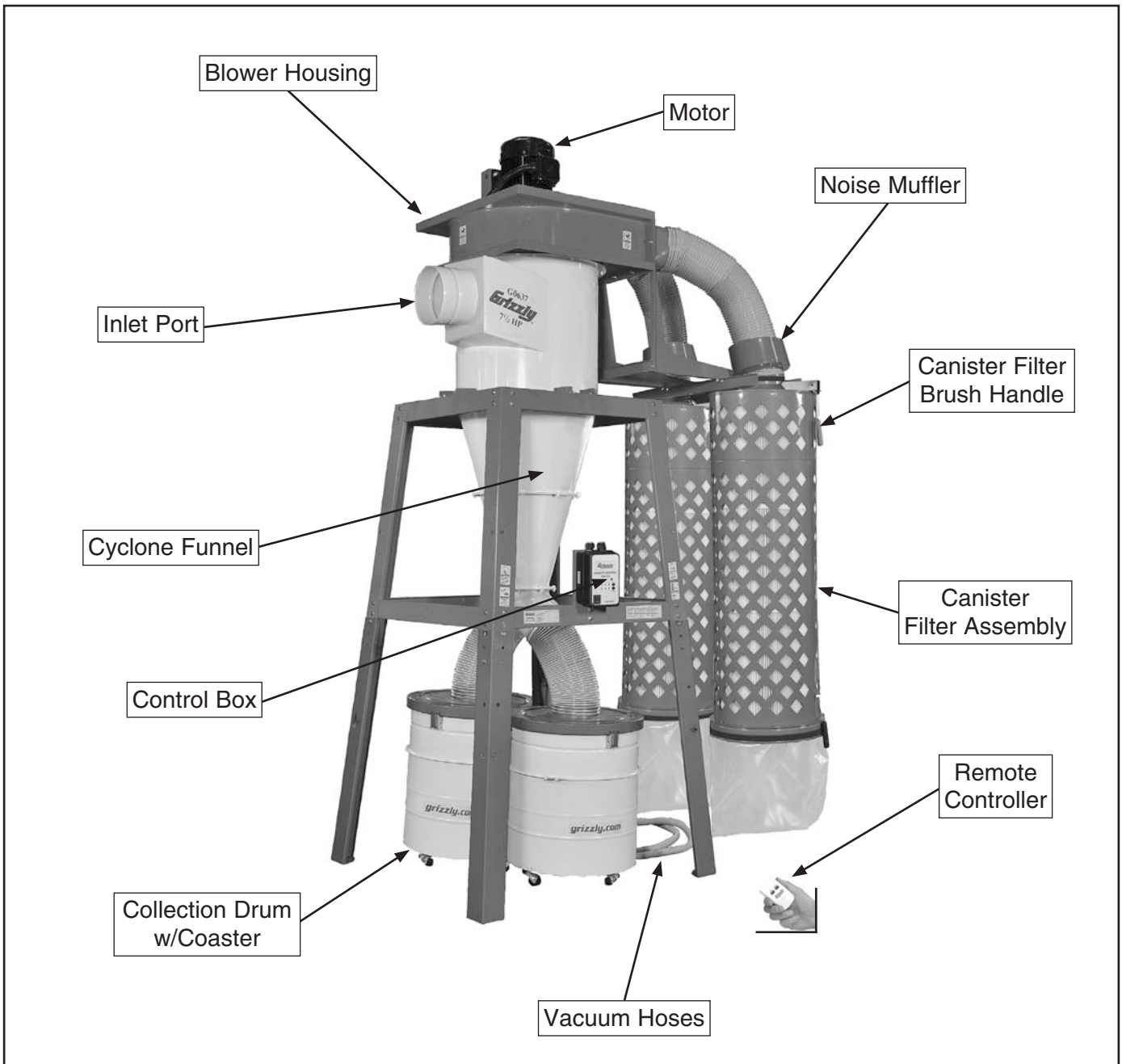
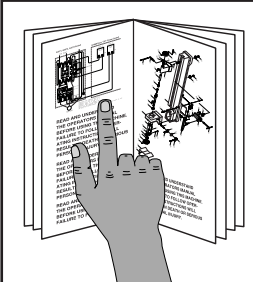


Figure 1. Identification (Model G0637 shown).

	<p>⚠ WARNING</p> <p>To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.</p>
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MACHINE DATA SHEET

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

MODEL G0637 7-1/2 HP 3-PHASE CYCLONE DUST COLLECTOR

Product Dimensions:

Weight..... 624 lbs.
 Length/Width/Height..... 76-3/4 x 59-3/8 x 137 in.
 Foot Print (Length/Width)..... 77 x 60 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
 Content..... Machine
 Weight..... 789 lbs.
 Length/Width/Height..... 91 x 39 x 43 in.

Carton #2

Type..... Cardboard
 Content..... Filter 1
 Weight..... 57 lbs.
 Length/Width/Height..... 57 x 23 x 23 in.

Carton #3

Type..... Cardboard
 Content..... Filter 2
 Weight..... 57 lbs.
 Length/Width/Height..... 57 x 23 x 23 in.

Electrical:

Minimum Circuit Size..... 40/20 amp
 Switch..... Magnetic Switch with Thermal Overload Protection
 Switch Voltage..... 220V
 Cord Length..... 10 ft.
 Cord Gauge..... 10 gauge
 Plug Included..... No
 Voltage Conversion Kit..... P0637119
 Phase Converter..... G5845

Motors:

Main

Type..... TEFC Induction (Class F)
 Horsepower..... 7.5 HP
 Voltage..... 220/440V
 Prewired..... 220V
 Phase..... Three
 Amps..... 25/12.5A
 Speed..... 3450 RPM
 Cycle..... 60 Hz
 Number Of Speeds..... 1
 Power Transfer Direct Drive
 Bearings..... Shielded and Lubricated



Main Specifications:

Operation

Air Suction Cap.....	3468 CFM @4.3 in. S.P.
Max Static Pressure.....	14.73 in.
Main Inlet Size.....	10 in.
Maximum Material Collection Cap.....	20 cu. ft.
Canister Filtration.....	0.2 - 2 micron

Bag Information

No Of Lower Bags.....	2
Lower Bag Cap.....	2.9 cu. ft.
Lower Bag Diameter.....	22-7/16 in.
Lower Bag Length.....	26-3/4 in.

Canister Information

No Of Canister Filters.....	2
Canister Filter Diameter.....	20 in.
Canister Filter Length.....	47-1/4 in.
Filter Surface Area.....	130 sq. ft.
Collection Drum Size.....	8.5 cu. ft.

Impeller Information

Impeller Type.....	Radial Fin
Impeller Size.....	18 in.
Impeller Blade Thickness.....	3/8 in.

Construction

Lower Bag Material.....	Clear Plastic
Canister Material.....	Spun Bond Polyester
Base Construction.....	16 Gauge Steel
Frame Construction.....	13 Gauge Steel
Impeller Construction.....	Steel, Riveted
Paint.....	Powder Coated
Blower Housing Construction.....	11 Gauge Steel
Body Construction.....	16 Gauge Steel
Collection Drum Construction.....	Steel

Other

Height With Bags Inflated.....	131 in.
--------------------------------	---------

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Data Label on Machine
Assembly Time	3 hours
Sound Rating	84 - 85 dB

Features:

- Ramped Inlet Maximizes Dust Flow into Collection Drums
- Steel Collection Drums with Casters for Easy Dust Disposal
- Remote Controlled Magnetic Switch
- Class "F" Motor
- Dual Pleated Filters with Cleaning Brushes to Maximize Air Flow
- Standard Equipment Mufflers Reduce Noise Level without Reducing Air Flow





MACHINE DATA SHEET

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

MODEL G0638 10 HP 3-PHASE CYCLONE DUST COLLECTOR

Product Dimensions:

Weight..... 646 lbs.
Length/Width/Height..... 76-3/4 x 59-7/8 x 139-3/8 in.
Foot Print (Length/Width)..... 77 x 60 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
Content..... Machine
Weight..... 812 lbs.
Length/Width/Height..... 91 x 39 x 43 in.

Carton #2

Type..... Cardboard
Content..... Filter 1
Weight..... 73 lbs.
Length/Width/Height..... 69 x 23 x 23 in.

Carton #3

Type..... Cardboard
Content..... Filter 2
Weight..... 73 lbs.
Length/Width/Height..... 69 x 23 x 23 in.

Electrical:

Minimum Circuit Size..... 40/20 amp
Switch..... Magnetic Switch with Thermal Overload Protection
Switch Voltage..... 220V
Cord Length..... 10 ft.
Cord Gauge..... 10 gauge
Plug Included..... No
Voltage Conversion Kit..... P0638119
Phase Converter..... G7978

Motors:

Main

Type..... TEFC Induction (Class F)
Horsepower..... 10 HP
Voltage..... 220/440V
Prewired..... 220V
Phase..... Three
Amps..... 30/15A
Speed..... 3450 RPM
Cycle..... 60 Hz
Number Of Speeds..... 1
Power Transfer Direct Drive
Bearings..... Shielded and Lubricated



Main Specifications:

Operation

Air Suction Cap.....	4029 CFM @4.3 in. S.P.
Max Static Pressure.....	16.8 in.
Main Inlet Size.....	12 in.
Maximum Material Collection Cap.....	20 cu. ft.
Canister Filtration.....	0.2 - 2 micron

Bag Information

No Of Lower Bags.....	2
Lower Bag Cap.....	2.9 cu. ft.
Lower Bag Diameter.....	22-7/16 in.
Lower Bag Length.....	26-3/4 in.

Canister Information

No Of Canister Filters.....	2
Canister Filter Diameter.....	20 in.
Canister Filter Length.....	59 in.
Filter Surface Area.....	198 sq. ft.
Collection Drum Size.....	8.5 cu. ft.

Impeller Information

Impeller Type.....	Radial Fin
Impeller Size.....	18-1/2 in.
Impeller Blade Thickness.....	3/8 in.

Construction

Lower Bag Material.....	Clear Plastic
Canister Material.....	Spun Bond Polyester
Base Construction.....	16 Gauge Steel
Frame Construction.....	13 Gauge Steel
Impeller Construction.....	Steel, Riveted
Paint.....	Powder Coated
Blower Housing Construction.....	11 Gauge Steel
Body Construction.....	16 Gauge Steel
Collection Drum Construction.....	Steel

Other

Height With Bags Inflated.....	140 in.
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Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Data Label on Machine
Assembly Time	3 hours
Sound Rating	86 - 87 dB

Features:

- Ramped Inlet Maximizes Dust Flow into Collection Drums
- Steel Collection Drums with Casters for Easy Dust Disposal
- Remote Controlled Star Delta Switch
- Class "F" Motor
- Dual Pleated Filters with Cleaning Brushes to Maximize Air Flow
- Standard Equipment Mufflers Reduce Noise Level without Reducing Air Flow



SECTION 1: SAFETY

WARNING

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.



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



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



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

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

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.

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

WEARING PROPER APPAREL. Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

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.

MENTAL ALERTNESS. Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



WARNING

DISCONNECTING POWER SUPPLY. Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

APPROVED OPERATION. Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well-lighted to minimize risk of injury.

ONLY USE AS INTENDED. Only use machine for its intended purpose. Never modify or alter machine for a purpose not intended by the manufacturer or serious injury may result!

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

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

REMOVE ADJUSTING TOOLS. Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

SECURING WORKPIECE. When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

FEED DIRECTION. Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

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

GUARDS & COVERS. Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

NEVER STAND ON MACHINE. Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

STABLE MACHINE. Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

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.

UNATTENDED OPERATION. Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine may increase the risk of serious injury.

CHECK DAMAGED PARTS. Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

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



WARNING

Additional Safety Instructions for Dust Collectors

MACHINE USE. This machine is intended to only collect wood dust and chips from wood-working machines. Do not use this dust collector as a vacuum or with machines producing dust/chips from metal, asbestos products, lead paint, silica or any products that are not natural wood or man-made wood products, such as plywood or particle boards.

WEAR RESPIRATOR. This machine may blow fine dust particles into the air during operation causing a hazard to the lungs. Always wear an approved respirator during machine operation and for a short time after.

SUSPENDED DUST PARTICLES AND IGNITION SOURCES. Do not operate the dust collector in area where explosion risks are high. Areas of high risk include, but are not limited to, areas near pilot lights or open flames.

EMPTYING DUST. When emptying dust from the collection bags or drum, wear a respirator and safety glasses. Empty dust away from ignition sources and into an approved container, then dispose of properly.

SAFE SERVICING. Disconnect the machine from power and allow the impeller to come to a complete stop before servicing, maintenance, adjustments.

AVOIDING FIRES. Do not allow steel particles to strike the impeller—this may produce a spark. Sparks can smolder in the wood dust for a long time before the fire or flame is detected. If you accidentally collect metal during operation, immediately turn off the dust collector, disconnect it from power, and wait for all moving parts to stop. Remove the collection bags and empty the dust into an approved air tight metal container. Prevent any chance of accidentally collecting metal again before resuming operations.

KEEPING FINGERS SAFE. Do not place your hands or tools near the open inlet during operation for any reason. The powerful suction could easily cause accidental contact with the impeller which will cause serious personal injury or damage to the machine.

DUST HAZARD. Be aware that certain woods may cause an allergic reaction in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to in case there is a possibility of an allergic reaction.

OPERATIONAL QUESTIONS. If, at any time, you are experiencing difficulties performing the intended operation, stop using the machine! Then contact our Tech Support or ask a qualified expert how the operation should be performed.

WARNING

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

CAUTION

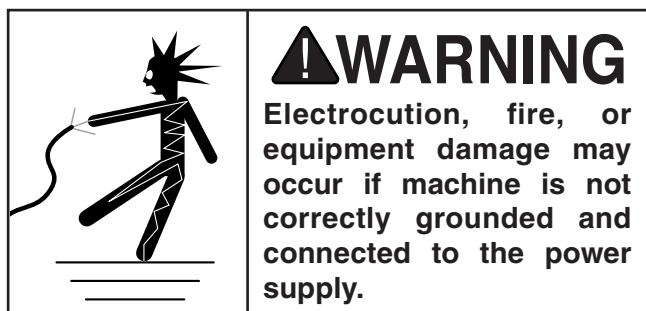
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Model G0637:

Full-Load Current Rating at 220V 25 Amps

Full-Load Current Rating at 440V .. 12.5 Amps

Model G0638:

Full-Load Current Rating at 220V 30 Amps

Full-Load Current Rating at 330V 15 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 requirements in the following section.

Circuit Information

A power supply circuit includes all electrical equipment between the main breaker box or fuse panel in your building and the incoming power connections at the machine. This circuit must be sized to safely handle the full-load current drawn from the machine for an extended period of time.

! CAUTION

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

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

Circuit Requirements for 220V

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V/240V
Cycle 60 Hz
Phase 3-Phase
Circuit Rating 40 Amps
Connection Hardwired w/Locking Switch

Circuit Requirements for 440V

This machine can be converted to operate on a 440V power supply. **Voltage Conversion** instructions are provided later in this manual. The intended 440V circuit must have a verified ground and meet the requirements that follow:

Nominal Voltage 440V/480V
Cycle 60 Hz
Phase 3-Phase
Rated Size 20 Amps
Connection Hardwired w/Locking Switch



Connection Type

A power cord is not included, because this machine must be permanently connected to the power supply. A disconnecting means, such as a locking switch (see **Figure** below), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by a qualified electrician in accordance with all applicable electrical codes and ordinances.

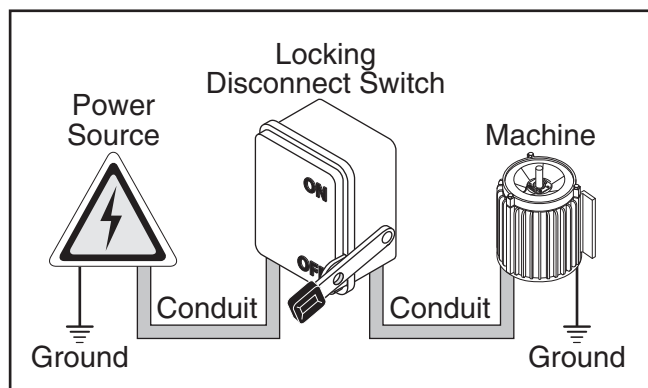


Figure 2. Typical setup of a permanently connected machine.

Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

⚠️ WARNING

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

Extension Cords

Since this machine must be permanently connected to the power supply, an extension cord cannot be used.

Phase Converter

When using a phase converter, the power from the manufactured power leg (sometimes called the wild wire) can fluctuate. Connect the manufactured power leg to the **3L/2** terminal to prevent damage to the IC board or transformer. The wire from this terminal can handle some fluctuation because it goes directly to the motor. The power going to the **1L/2** and **5L/3** terminals goes to the IC board and transformer and must be consistent to prevent damage.



Model G0637 440V Conversion

The Model G0637 can be rewired for 440V operation. This rewiring job consists of disconnecting the dust collector from the power source, changing the control box, and rewiring the motor.

The necessary control box for this procedure can be purchased by calling our customer service number at (800) 523-4777 and ordering part number P0637119.

When complete, the rewiring job must be inspected by a qualified electrician before the dust collector is connected to the power source. Refer to the **Wiring Diagrams** on **Pages 51–52** for additional information.

Model G0638 440V Conversion

To operate the Model G0638 on 440V power, you must purchase a G0638 440V Conversion Kit. Call our customer service number at (800) 523-4777 and order part number P0638119.

To convert the G0638 to 440V:

1. DISCONNECT MACHINE FROM POWER!
2. Open the control box and identify the overload relay and the transformer (see **Figure 3**).

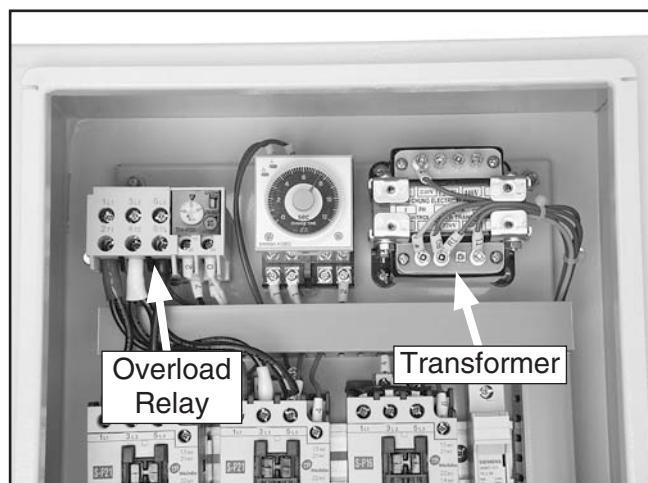


Figure 3. Model G0638 control box overload relay and transformer.

3. Replace the overload relay with the one included in the conversion kit, and turn the AMP dial to 15.
4. Move the "R0" wire on the transformer from the 220V terminal to the 440V terminal (see **Figure 4**).

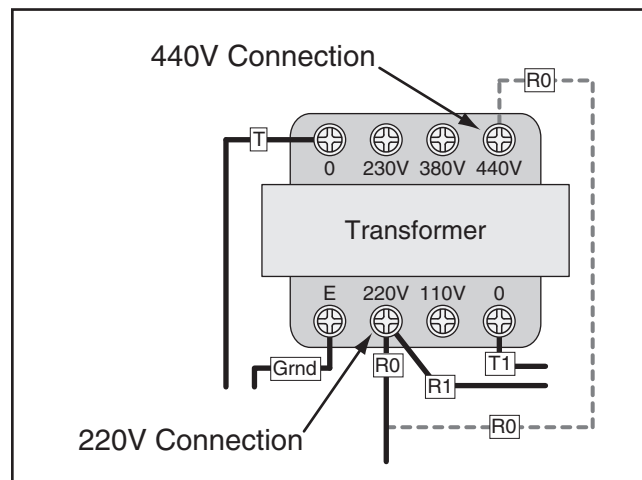


Figure 4. Model G0638 220V and 440V transformer connections.

⚠️ WARNING

You must have a qualified electrician inspect your 440V rewiring job before connecting the dust collector to the power source. Failure to heed this warning may result in property damage, serious personal injury, or death from electrocution.

5. Open the motor junction box and rewire the motor terminals for 440V power. Refer to **Wiring Diagram** on **Page 54** for additional information.



Correcting Phase Polarity

This subsection is only provided for troubleshooting. If you discover during the test run that the machine will not operate, or that the impeller spins backward, the power connections may be wired out-of-phase. Without the proper test equipment to determine the polarity of the power source legs, wiring machinery to 3-phase power may require trial-and-error. Correcting phase polarity is simply a matter of reversing the positions where two of the incoming power source wires are connected inside the control box.

3. Secure the control box cover, then re-connect the machine to power.
4. Perform **Step 10** of the test run on **Page 32** to confirm that the power connections are correct.

—If the motor and impeller are still rotating in the wrong direction, contact our Tech Support at (570) 546-9663 for assistance.

NOTICE

If this machine is wired out-of-phase, the motor and impeller will spin in the wrong direction. The efficiency of the dust collector will be greatly reduced and will not provide the rated CFM. You must make sure the motor is spinning in the correct direction before placing the machine into full operation. Perform **Step 10** of the test run on **Page 32** to make sure the machine is correctly wired.

To correct phase polarity:

1. DISCONNECT MACHINE FROM POWER!
2. Open the control box and swap the connections of any two incoming hot wires from the power source (see **Figure 5**).

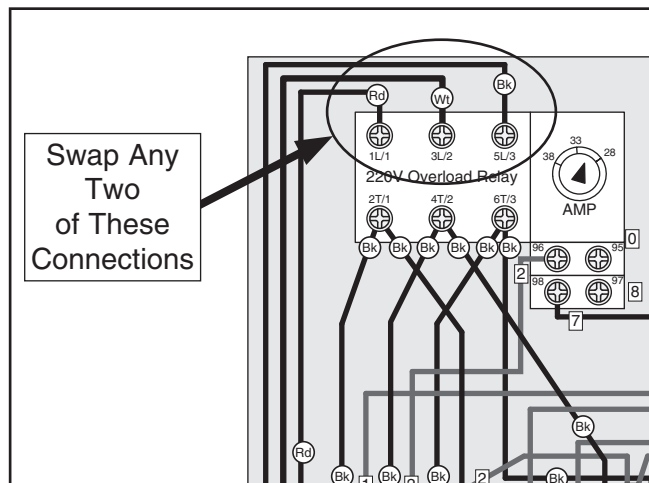
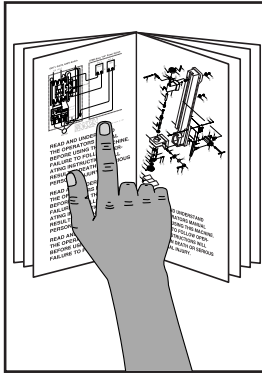


Figure 5. Connections to change when correction phase polarity.



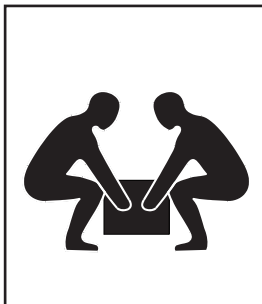
SECTION 3: SETUP



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



! WARNING
Wear safety glasses during the entire setup process!



! WARNING
This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.



! WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials unpacked with this machine. Discard immediately.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Assistance	As Needed
• Power Lifting Equipment.....	As Needed
• Safety Glasses.....	For Each Person
• Wrenches 1/2".....	2
• Wrenches 3/8".....	2
• Wrench 5/16"	1
• Wrench 10mm	1
• Phillips Screwdriver #2	1
• Level (3 ft. or more in length)	1
• Floor Mounting Hardware	See Page 20
• Medium-Strength Thread Locking Compound.....	1 Bottle

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Inventory

After all the parts have been removed from the boxes, you should have the following items:

Inventory: (Figures 6–10)	Qty
A. Upper Stand Braces	4
B. Upper Stand Legs	4
C. Filter Brace Supports (Long)	2
D. Control Box Bracket	1
E. Cyclone Mounting Brackets.....	4
F. Lower Stand Legs	4
G. Filter L-Braces	2
H. Filter Brace Support (Short)	1
I. Lower Stand Braces	4

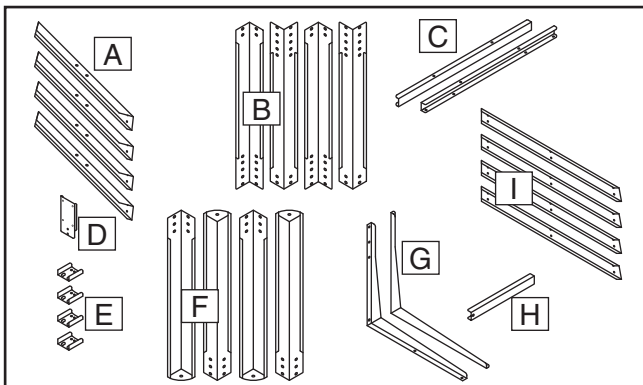


Figure 6. Model G0637/G0638 inventory A-I.

J. Intake Cylinder	1
K. Outlet Port	1
L. Cyclone Funnel (Large)	1
M. Intake Barrel	1
N. Cyclone Funnel (Small)	1
O. Funnel Port.....	1

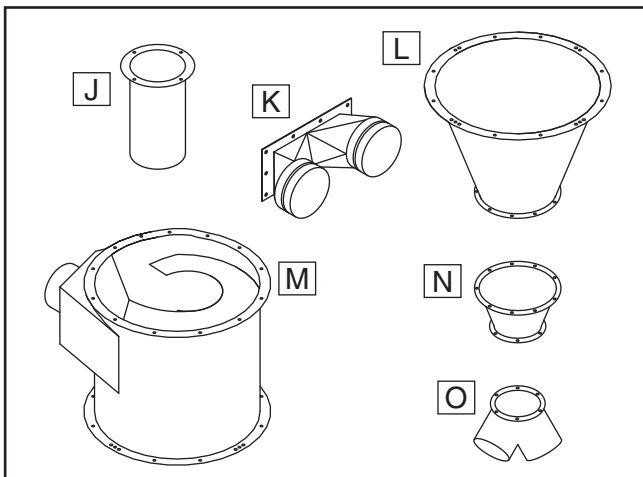


Figure 7. Model G0637/G0638 inventory J-O.

P. Blower Housing with Motor	1
Q. Control Box.....	1
R. Remote Control	1
S. Collection Drum Lid Latches	6
T. Casters 2"	8
U. Collection Drum Lids	2
V. Upper Collection Drum Cylinders.....	2
W. Collection Drum Clamps	2
X. Lower Collection Drum Cylinders.....	2

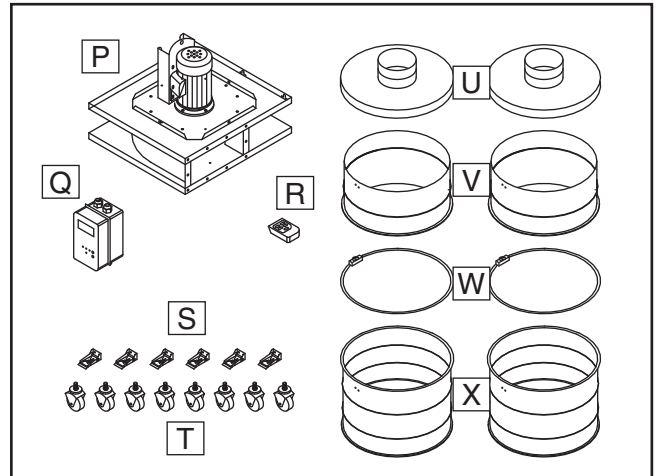


Figure 8. Model G0637/G0638 inventory P-X.

Y. Flexible Ducts 9" x 25½"	2
Z. Noise Mufflers	2
AA. Canister Filters	
—Model G0637 510 x 1200mm	2
—Model G0638 510 x 1500mm	2
AB. Flexible Ducts 8" x 31½"	2
AC. Flexible Ducts 8" x 4¾"	2
AD. Canister Filter Bag Clamps	2

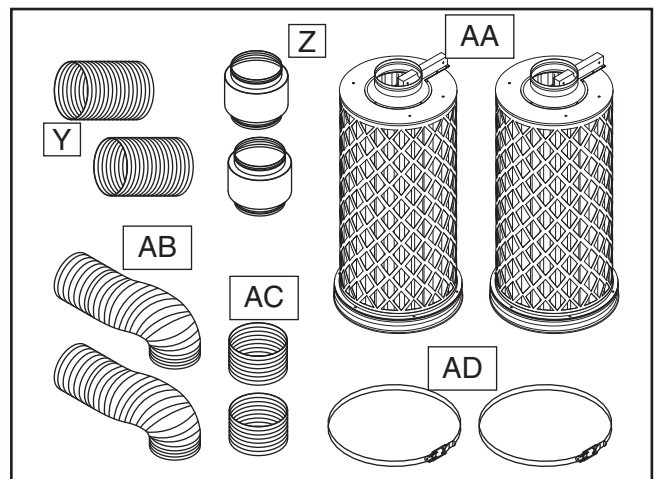
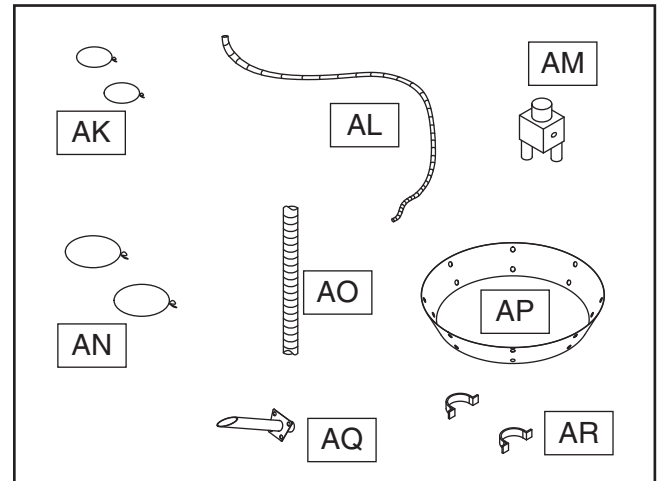


Figure 9. Model G0637/G0638 inventory Y-AD.



AE. Gaskets (not shown):	
—Intake Cylinder 3 x 6 x 1800mm.....	1
—Outlet Port 3 x 6 x 1100mm.....	1
—Cyclone Funnel (Large)	
3 x 6 x 2500mm.....	1
—Intake Barrel 3 x 6 x 2500mm	1
—Cyclone Funnel (Small)	
3 x 6 x 2200mm.....	1
—Funnel Port 3 x 6 x 735mm	1
—Collection Drum Lids	
10 x 50 x 2000mm.....	2
—Canister Hose Gaskets	
3 x 15 x 700mm.....	8
—Drum Lid PVC Rubber Seal.....	1
—Foam Tape 3 x 6 x 300mm	1
AF. Rubber Mounting Gaskets (not shown):	
—Filter Canisters.....	4
AG. Duct Clamps 8" (not shown).....	8
AH. Duct Clamps 9" (not shown).....	4
AI. Collection Bags (not shown):	
—Collection Drums 640 x 1200mm	10
—Canister Filters 510 x 600mm.....	2
AJ. Hardware (not shown):	
—Hex Bolts $\frac{3}{8}$ "-16 x $\frac{3}{4}$ ".....	74
—Hex Bolts $\frac{3}{8}$ "-16 x $1\frac{1}{4}$ "	8
—Hex Bolts $\frac{5}{16}$ "-18 x $\frac{3}{4}$ "	30
—Hex Bolts $\frac{5}{16}$ "-18 x 1".....	10
—Hex Bolts $\frac{5}{16}$ "-18 x $1\frac{1}{4}$ "	27
—Hex Bolts $\frac{5}{16}$ "-18 x 3".....	2
—Phillips Head Screws #10-24 x $\frac{3}{8}$ "	24
—Fender Washers $\frac{5}{16}$ "	8
—Flat Washers $\frac{3}{8}$ ".....	178
—Flat Washers $\frac{5}{16}$ ".....	96
—Lock Washers $\frac{3}{8}$ "	8
—Hex Nuts $\frac{3}{8}$ "-16	16
—Hex Nuts $\frac{5}{16}$ "-18	37
—Hex Nuts #10-24	24
—Lock Nuts $\frac{3}{8}$ "-16	72
—G0638 (For Control Box Bracket)	
Phillips Head Screws M6-1 x 15	4
Flat Washers 6mm.....	4
Hex Nuts M6-1	4

AK. Vacuum Hose Clamps 1$\frac{1}{4}$"	4
AL. Vacuum Hose 1$\frac{1}{4}$" x 79"	2
AM. Vacuum Manifold.....	1
AN. Vacuum Hose Clamps 2"	2
AO. Vacuum Hose 2" x 39"	1
AP. Collection Drum Vacuum Ring	2
AQ. Cyclone Vacuum Port.....	1
AR. Vacuum Hose Clips.....	2



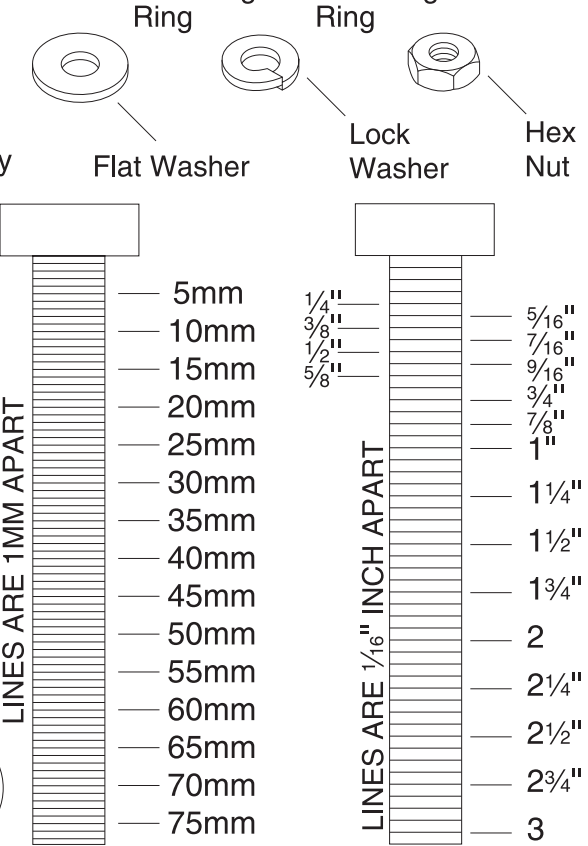
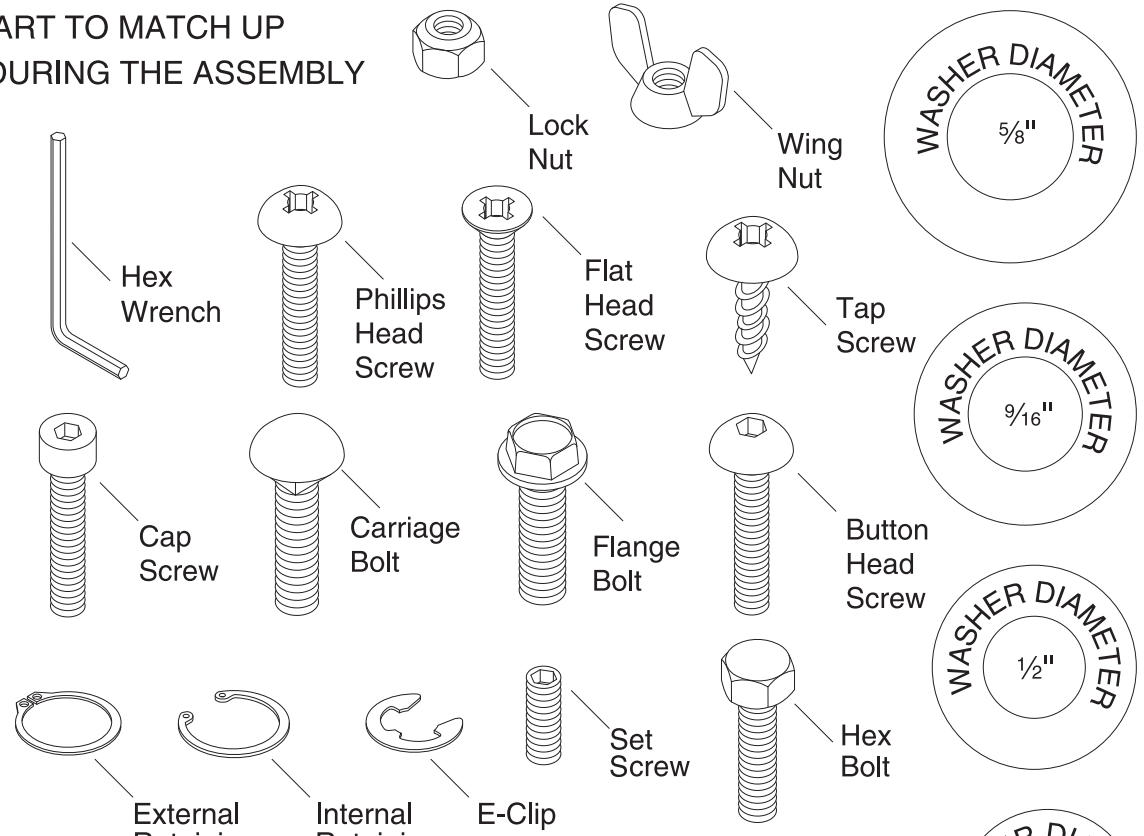
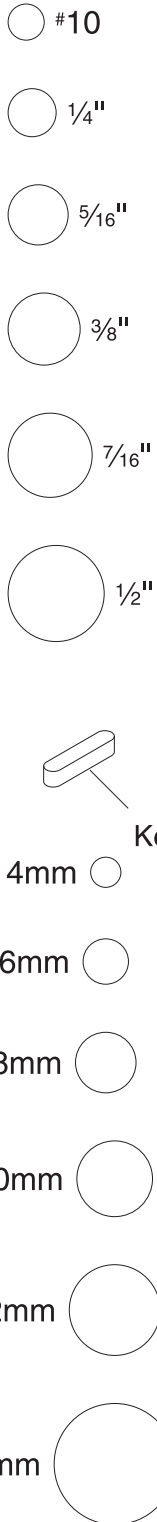
**Figure 10. Model G0637/G0638 inventory
AK-AR.**



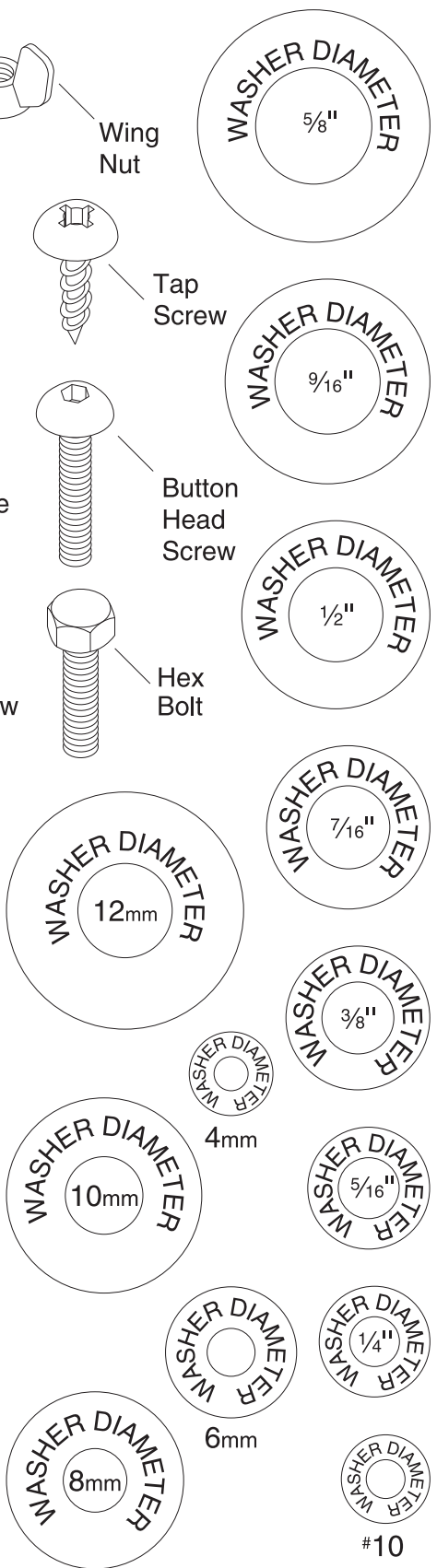
Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Site Considerations

Weight Load

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

Space Allocation

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

	<p>⚠ CAUTION Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
--	---

Physical Environment

The physical environment where your machine is operated is important for safe operation and the longevity of its 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 access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

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

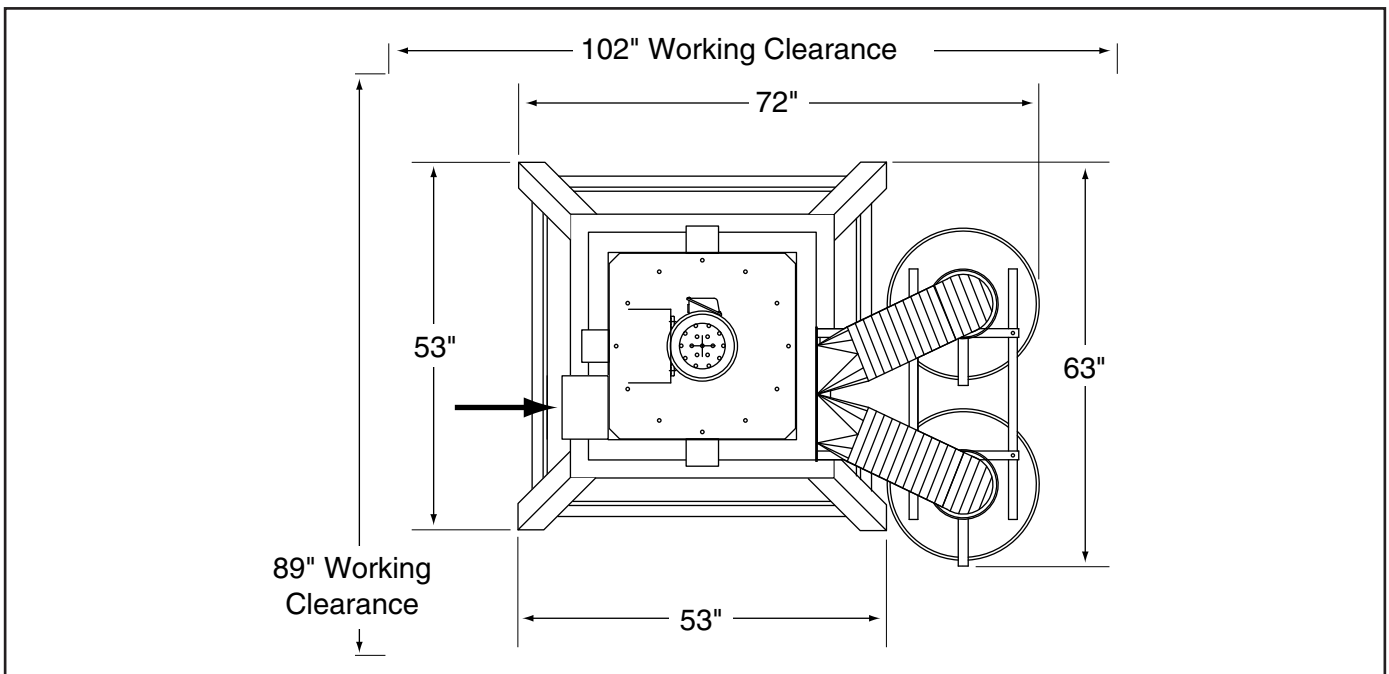


Figure 11. Minimum working clearances.



Mounting to Shop Floor

We recommend that you mount your new dust collection system to the floor. Because floor materials may vary, floor mounting hardware is not included.

Bolting to Concrete Floors

Lag shield anchors with lag bolts and anchor studs (Figure 12) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options for mounting your machine and choose the one that best fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, presenting a tripping hazard if you decide to move your machine.

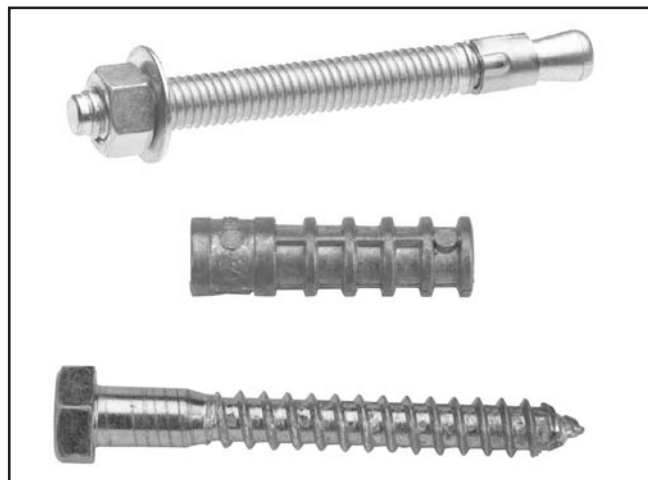


Figure 12. Typical fasteners for mounting to concrete floors.

NOTICE

Since your dust collection system will be hardwired to the power source, we strongly recommend securing your machine to the floor. Consult with your electrician to ensure compliance with applicable codes.

Assembly

To assemble the dust collector:

1. Use (8) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (16) $\frac{3}{8}$ " flat washers, and (8) $\frac{3}{8}$ "-16 lock nuts to connect 2 upper stand legs, 1 upper stand brace, and 1 lower stand brace —*only finger tighten the fasteners* (see Figure 13).

Note: To make the installation of the fasteners easier, use scrap wood to raise the metal components off the floor.

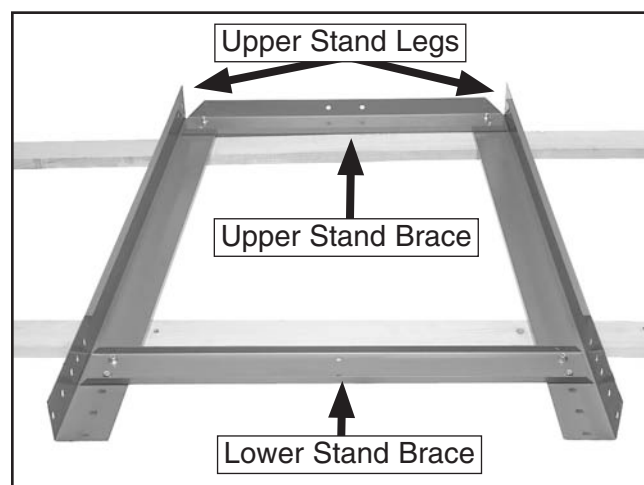


Figure 13. One side of upper stand assembled.

2. Repeat **Step 1** to make the other side of the upper stand.

Note: The $\frac{5}{16}$ " fender washers with a larger outside diameter will be used to attach the canister filters in later steps—do not use them for any other assembly.



3. Use (16) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (32) $\frac{3}{8}$ " flat washer, and (16) $\frac{3}{8}$ "-16 lock nuts to connect the two sides of the upper stand with two upper stand braces and two lower stand braces—*only finger tighten the fasteners* (see **Figure 14**).



Figure 14. Upper stand assembled.

4. Place the level across a corner of the lower stand braces and move the upper stand around until that corner is level, then fully tighten all of the fasteners for that corner (see **Figure 15**).

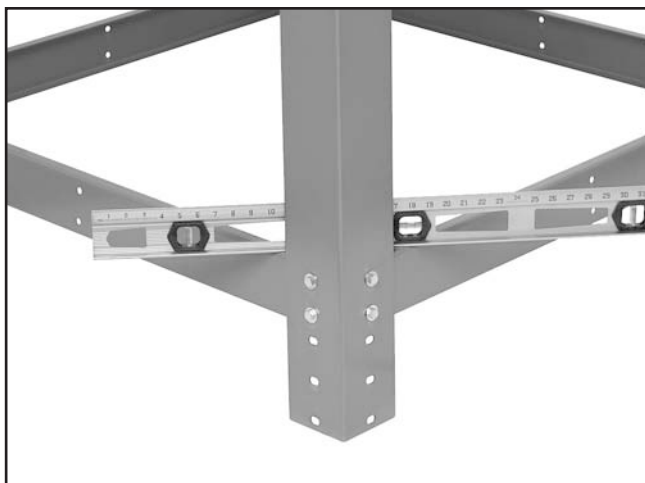


Figure 15. Level positioned on the upper stand.

5. Repeat **Step 4** for the rest of the corners, then set the upper stand assembly aside.

!WARNING

When using power lifting equipment during the assembly, make sure the equipment is safe, fully operational, and adequately rated for the weight being lifted. The operator of the equipment must be experienced and able to use safe methods during these processes. Failure to heed these warnings could result in serious personal injury or death.

5. Place the intake cylinder on the floor and apply the 3 x 6 x 1800mm gasket to the intake cylinder top rim, between the mounting holes and the inside edge (see **Figure 16**).

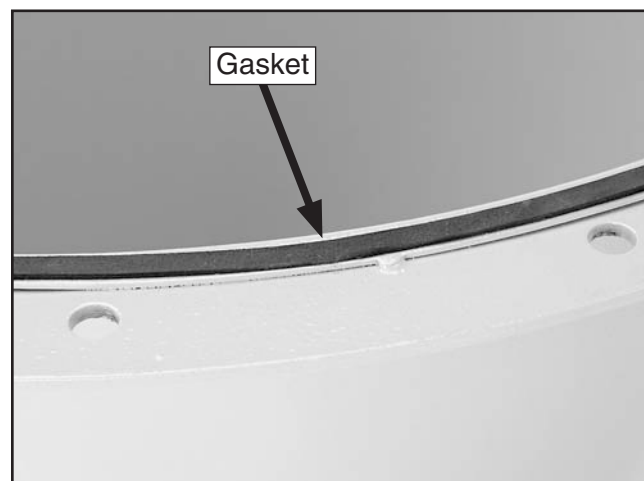


Figure 16. Gasket applied to the intake cylinder rim.

6. With assistance and the power lifting equipment, keep the intake cylinder on the floor and lower the blower housing over the top of the intake cylinder.



- Use the (6) $\frac{5}{16}$ "-18 x $\frac{3}{4}$ " hex bolts and (6) $\frac{5}{16}$ " flat washers to secure the intake cylinder to the bottom of the blower housing (see **Figure 17**).

Note: Because this part of the dust collector is not accessible after assembly, consider using Medium Strength Blue Thread Locker (Grizzly Model T21854) on the bolts that secure the intake cylinder to the motor/blower housing assembly to ensure that the fasteners won't come loose with vibration.



Figure 17. Intake cylinder mounted to blower housing.

- Position the large cyclone funnel so the small end rests on the floor.
- Apply the 3 x 6 x 2500mm gasket to the top mating surface of the large cyclone funnel.

Note: When aligning the holes in the next step, be aware that the large cyclone funnel top and the intake barrel mating surfaces have four places around the rims where there are three mounting holes close together.

- With assistance, place the intake barrel over the large cyclone funnel and align the mounting holes as illustrated in **Figure 18**.

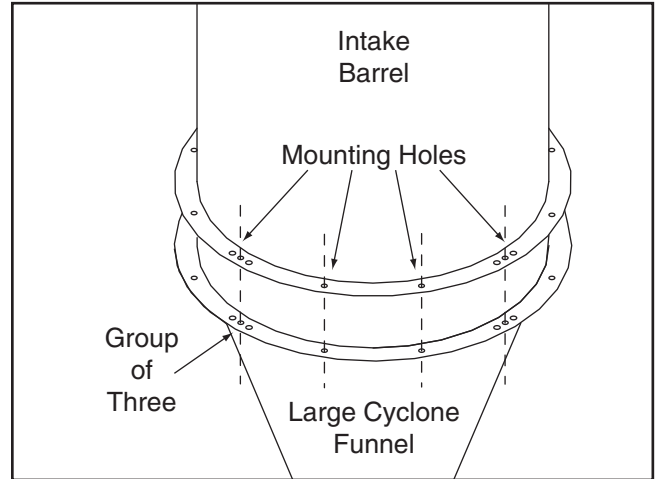


Figure 18. Intake barrel and large cyclone funnel mounting holes aligned.

NOTICE

When connecting parts that have a gasket applied to the mounting surface, always tighten the fasteners in an opposing star pattern to ensure the gasket does not become crimped and compromise the seal.

- Connect the intake barrel and large cyclone funnel with (12) $\frac{5}{16}$ "-18 x $1\frac{1}{4}$ " hex bolts, (24) $\frac{5}{16}$ " flat washers, and (12) $\frac{5}{16}$ "-18 hex nuts in the mounting holes—excluding the left and right hole of the groups of three (see **Figure 19**).

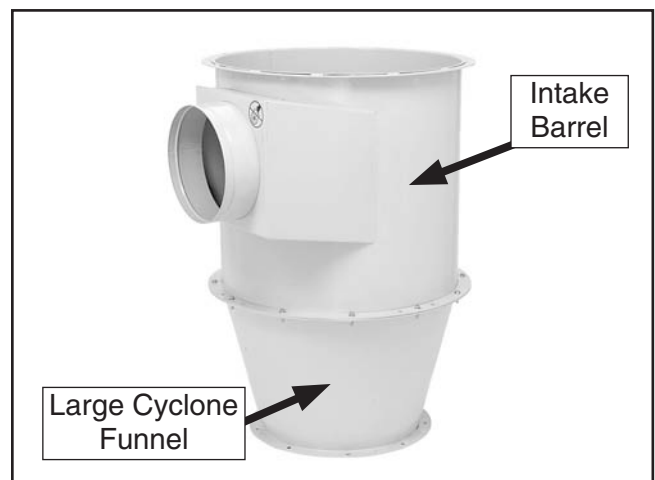


Figure 19. Intake barrel and large cyclone funnel.



12. Install the four cyclone mounting brackets with (8) $\frac{3}{8}$ "-16 x $1\frac{1}{4}$ " hex bolts, (16) $\frac{3}{8}$ " flat washers, and (8) $\frac{3}{8}$ "-16 lock nuts (see **Figures 18 & 20**).



Figure 20. Cyclone mounting bracket mounted to collector assembly.

13. Apply the 3 x 6 x 2500mm gasket to the top mating surface of the intake barrel assembly.
14. Keeping the intake barrel assembly on the floor, lower the blower housing assembly over and approximately one inch away from the intake barrel assembly.
15. Using two punches or Phillips screwdrivers as alignment guides (see **Figure 21**), lower the blower housing assembly onto the intake barrel assembly.

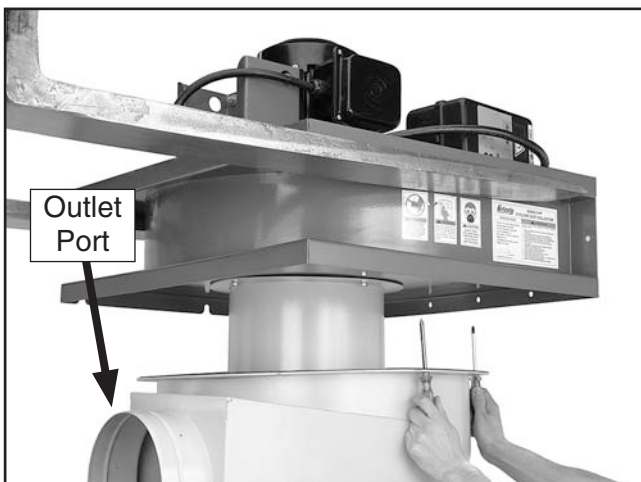


Figure 21. Aligning the mounting holes.

Note: Orient the two assemblies so that the large, round intake port of the intake barrel is NOT directly underneath the rectangular outlet port of the blower housing. The outlet port will connect to the canister filters and will not allow room for attachment of the intake ducting to the intake port.

16. Attach the two assemblies with the (12) $\frac{5}{16}$ "-18 x $\frac{3}{4}$ " hex bolts and (12) $\frac{5}{16}$ " flat washers (see **Figure 22**).



Figure 22. Securing intake barrel assembly to blower housing assembly.

Tip: When installing the two bolts above the intake port of the intake barrel, use duct tape on the bottom of your wrench. This will hold the bolts in the wrench while inserting them in place (see **Figure 23**).

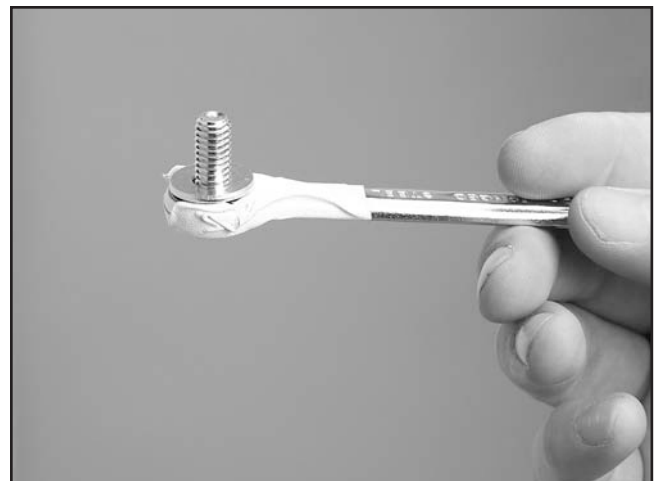


Figure 23. Using tape on a wrench in a tight spot.



- Apply the 3 x 6 x 300mm foam tape to the mating surface of the cyclone vacuum port, then attach it to the cyclone funnel with (4) $\frac{5}{16}$ "-18 x $\frac{3}{4}$ " hex bolts and (4) $\frac{5}{16}$ " flat washers (see **Figure 24**).

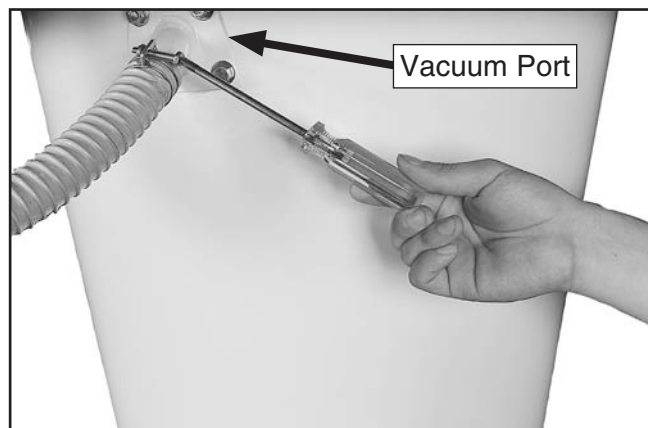


Figure 24. Cyclone vacuum tube and hose attachment.

- Lower the blower/intake assembly into the upper stand assembly so that the cyclone mounting brackets align with the mounting holes of the upper stand braces (see **Figure 25**).

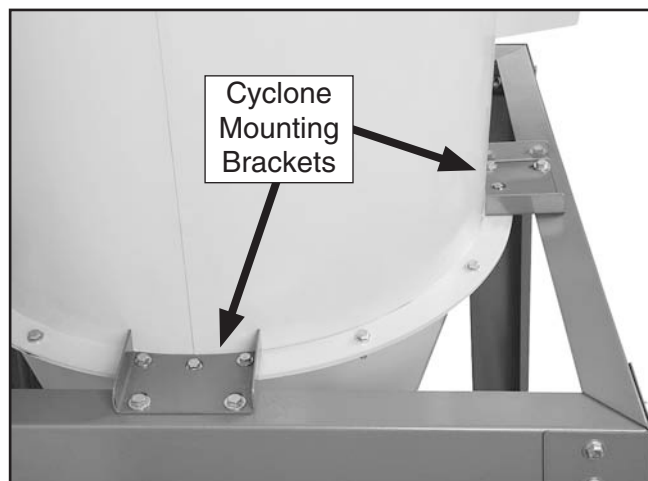


Figure 25. Mounting blower/intake assembly to upper stand.

- Secure the mounting brackets to the upper stand with (8) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (16) $\frac{3}{8}$ " flat washers, and (8) $\frac{3}{8}$ "-16 lock nuts.
- With assistance and the power lifting equipment, raise the entire assembly high enough to install the lower stand legs.

- Slide the four lower stand legs onto the bottoms of the upper stand legs—do NOT install the fasteners yet.

- Slowly lower the weight of the assembly onto the lower stand legs.

Note: To keep the assembly stable while completing the next steps, keep the power lifting equipment engaged but not lifting.

- To allow the mounting holes of the lower stand legs to align properly, slightly loosen the 16 fasteners that connect the lower stand braces to the upper stand legs (see **Figure 26**).

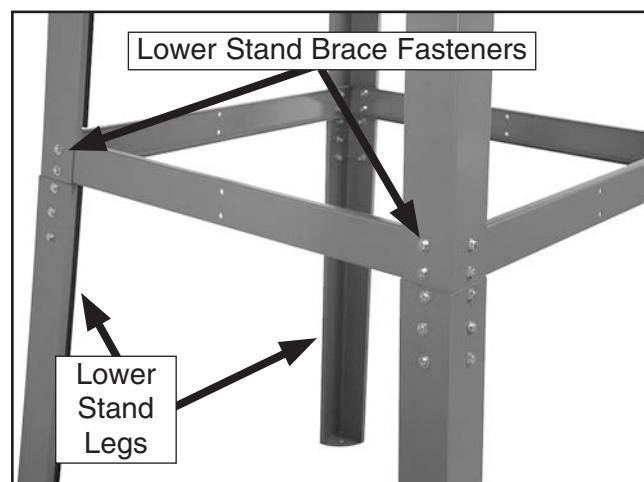


Figure 26. Lower stand legs attached to the upper stand assembly.

- Secure the lower stand legs to the upper stand assembly with (24) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (48) $\frac{3}{8}$ " flat washers, and (24) $\frac{3}{8}$ "-16 lock nuts.

- Re-tighten the 16 fasteners connecting the lower stand braces to the assembly.

- Remove the power lifting equipment from the assembly.

Note: The only other use for the power lifting equipment is moving the dust collection system into its permanent position when the assembly is complete.



27. Apply the 3 x 6 x 1100mm gasket to the square side of the outlet port.
28. Attach (1) 3 x 15 x 700mm gasket to the outer circular rims of each outlet port.
29. Mount the outlet port to the blower housing with (4) $\frac{5}{16}$ "-18 x 1" hex bolts, (8) $\frac{5}{16}$ " flat washers, and (4) $\frac{5}{16}$ "-18 hex nuts (see **Figure 27**).

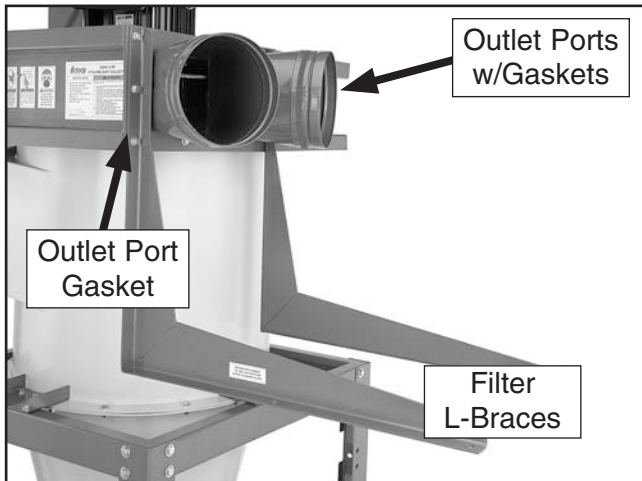


Figure 27. Filter L-braces mounted to blower housing.

30. Attach the filter L-braces to either side of the outlet port on the blower housing with (6) $\frac{5}{16}$ "-18 x 1" hex bolts, (12) $\frac{5}{16}$ " flat washers, and (6) $\frac{5}{16}$ "-18 hex nuts.
31. Secure the short filter brace support to the back of the filter L-braces with (2) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (4) $\frac{3}{8}$ " flat washers, and (2) $\frac{3}{8}$ "-16 hex nuts (see **Figure 28**).

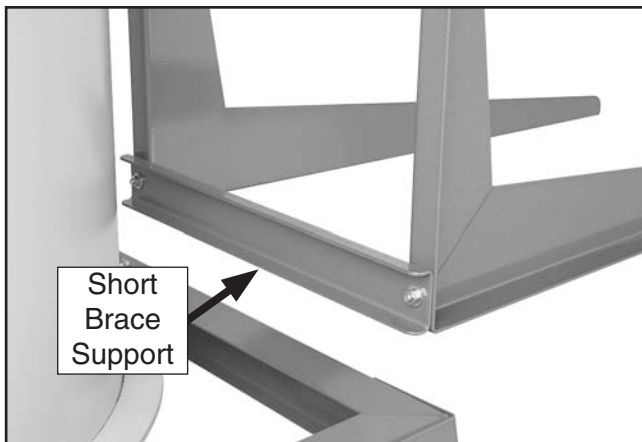


Figure 28. Short filter brace support attached.

32. Attach the two long brace supports to the filter braces with (4) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (8) $\frac{3}{8}$ " flat washers, and (4) $\frac{3}{8}$ "-16 hex nuts, as shown in **Figure 29**.



Figure 29. Long brace supports attached.

33. With assistance, position the rubber mounting gaskets between the filter canisters and the long brace supports, and secure the canisters with (8) $\frac{5}{16}$ "-18 x $\frac{3}{4}$ " hex bolts and (8) $\frac{5}{16}$ " fender washers (see **Figure 30**).

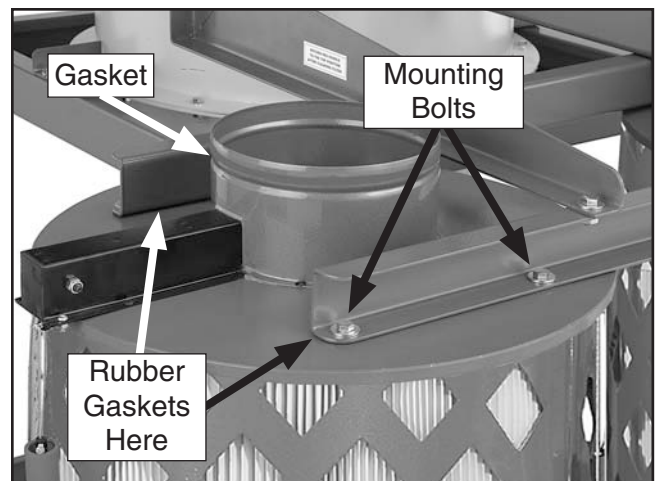


Figure 30. Canister filters mounted to the long support braces.



34. Attach the 3 x 15 x 700mm gaskets to the upper rim of the canister filter assembly and both rims of the noise muffler.
35. Assemble the 8" x 31½" flexible ducts, the noise mufflers, and the 8" x 4¾" flexible ducts with the 8" duct clamps (see **Figure 31**).

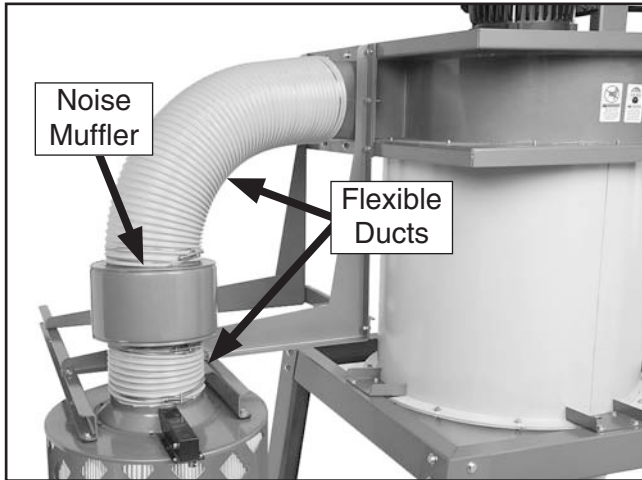


Figure 31. Ducting and noise muffler connected between blower housing and filter canister.

36. Use the 8" duct clamps to connect the duct assemblies between the outlet port of the blower housing and the canister filters.
37. Fit the smaller plastic collection bags over the bottom of the filters and clamp them in place with the metal bag clamps, as shown in **Figure 32**.



Figure 32. Canister filter collection bag installed.

38. Apply the 3 x 6 x 2200mm gasket to the larger, top end of the small cyclone funnel, then place the cyclone funnel upside down on the floor.

Note: Use a clean covering on the floor to protect the gasket.

39. Apply the 3 x 6 x 735mm gasket to the top of the funnel port and place this upside down on top of the cyclone funnel.
40. Attach the small cyclone funnel and funnel port with (6) 5/16"-18 x 1¼" hex bolts, (12) 5/16" flat washers, and (6) 5/16"-18 hex nuts.
41. With assistance, attach this assembly to the bottom of the large cyclone funnel with (9) 5/16"-18 x 1¼" hex bolts, (18) 5/16" flat washers, and (9) 5/16"-18 hex nuts (see **Figure 33**).

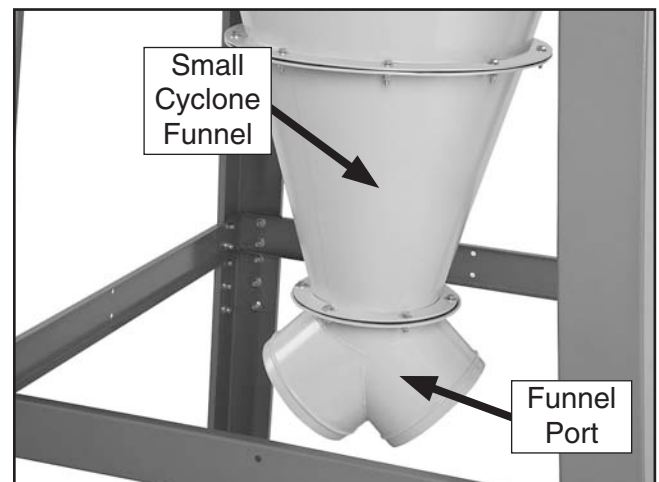


Figure 33. Small cyclone funnel and funnel port attached.



42. For each lower collection drum cylinders, attach the casters to the bottom using (4) $\frac{3}{8}$ "-16 hex nuts, (4) $\frac{3}{8}$ " flat washers, and (4) $\frac{3}{8}$ " lock washers (see **Figure 34**).



Figure 34. Dust collection drum casters installed.

43. Connect each upper and lower collection drum cylinder with a collection drum clamp and use (1) $\frac{5}{16}$ "-18 x 3" hex bolt and (1) $\frac{5}{16}$ "-18 hex nut to tighten the clamp (see **Figure 35**).

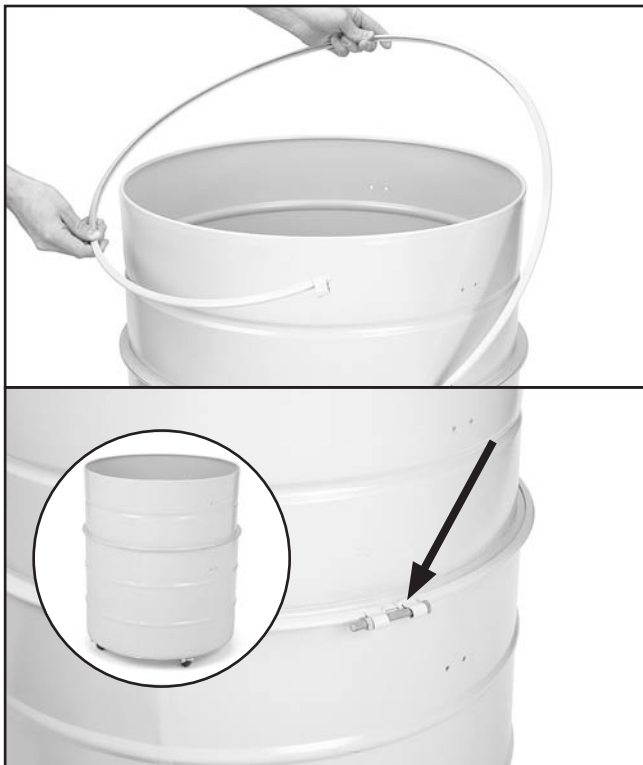


Figure 35. Installing drum clamp around dust collection cylinders.

44. Install the rubber seal over the top lip of the collection drum rim. Pay special attention to the direction of the seal, as shown in the **Figure 36**.

Tip: To keep the seal in place, you can use an adhesive applied to the rubber seal at approximately 1" intervals.

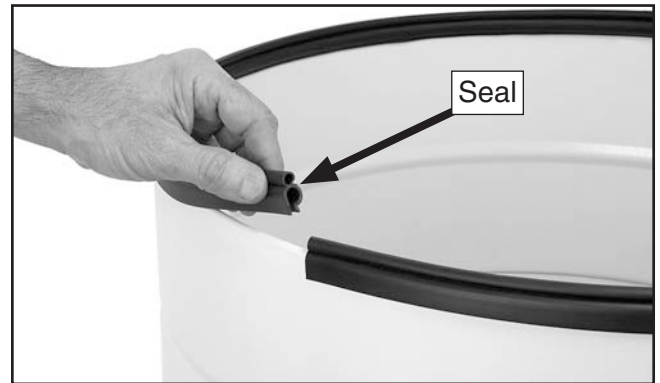


Figure 36. Installing drum seal.

45. Install the drum lid latches on the upper part of each collection drum assembly with (12) #10-24 x $\frac{3}{8}$ " Phillips head screws and (12) #10-24 hex nuts (see **Figure 37**).



Figure 37. Collection drum lid latch installed.

46. To prevent a vacuum leak in the collection drums, use (12) #10-24 x $\frac{3}{8}$ " Phillips head screws and (12) #10-24 hex nuts to plug the holes in the lower half of the collection drums.



47. Place the collection drum vacuum rings on the bottom of the collection drums (see **Figure 38**).

Note: During operation, this ring and the vacuum connection to the cyclone funnel will prevent the collection bag from collapsing.

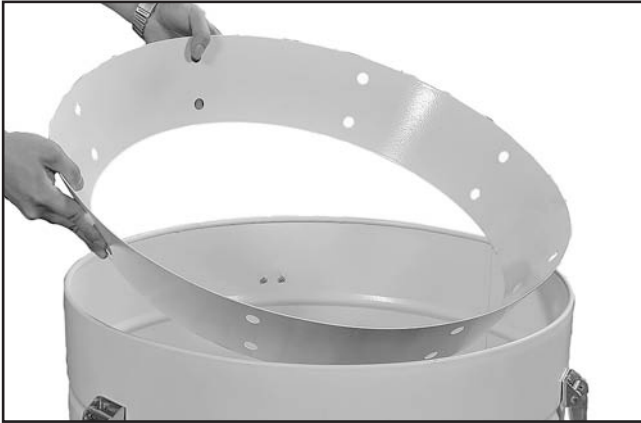


Figure 38. Inserting collection drum vacuum ring.

48. Install the larger plastic collection bag into the drum, place the lid on it and hook the latch over the lid, as shown in **Figure 1**, then clamp it in place.



Figure 1. Latch hooked over the lid for clamping.

49. Connect the dust collection drum assemblies to the funnel port with the 9" flexible ducts and 9" duct clamps (see **Figure 39**).

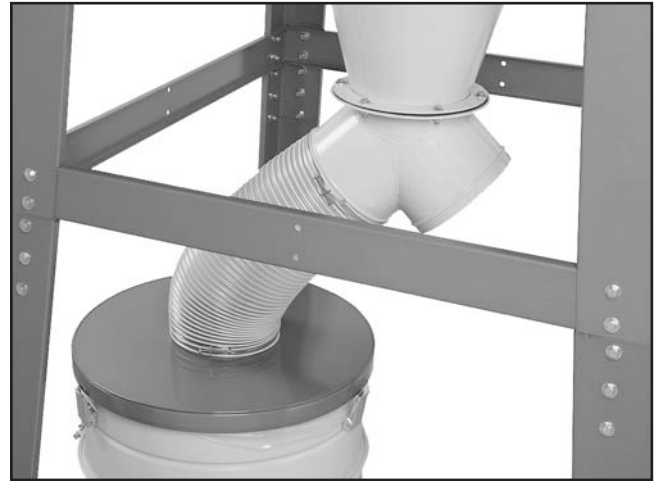


Figure 39. Dust collection drum assemblies connected to funnel port.

50. Use the 2" hose clamps to attach one end of the 2" x 39" vacuum hose to the cyclone vacuum port and the other end to the vacuum manifold (see **Figure 40**).

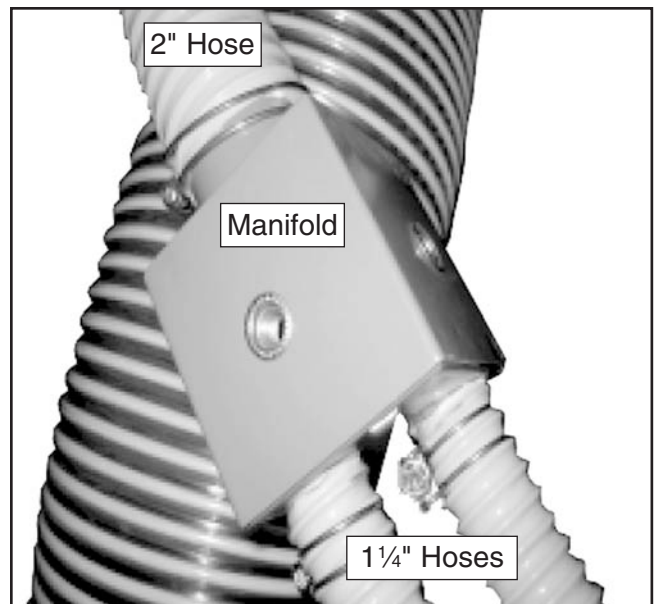


Figure 40. Vacuum hoses attached to the vacuum manifold.



51. Connect the vacuum hoses between the vacuum manifold and the collection drum vacuum ports with (4) 1 1/4" hose clamps (see **Figure 40–41**).



Figure 41. Connecting the vacuum hose.

52. Secure the vacuum hose inside the upper and lower stand legs with the (2) U-shaped clips (see **Figure 42**).



Figure 42. Securing the vacuum hose to the stand legs.

53. **Model G0637:** Mount the control box onto the lower stand brace with (2) 3/8"-16 x 3/4" hex bolts, (4) 3/8" flat washers, and (2) 3/8"-16 hex nuts (see **Figure 43**).

Note: The remote control uses IR (infrared) to communicate with the control box, and must have direct line-of-sight to the control box. Locate the control box with this in mind.



Figure 43. Model G0637 control box mounted.

Continued on next page →



54. **Model G0638:** Mount the control bracket onto the lower stand brace with (2) $\frac{3}{8}$ "-16 x $\frac{3}{4}$ " hex bolts, (4) $\frac{3}{8}$ " flat washers, and (2) $\frac{3}{8}$ "-16 hex nuts (see **Figure 44**).



Figure 44. Model G0638 control box bracket mounted.

55. Open the control box and identify the four mounting holes in the back of the cabinet.
56. Attach the control box to the bracket already mounted on the stand brace with (4) M6-1 x 15 Phillips head screws, (4) 6mm flat washers, and (4) M6-1 hex nuts (see **Figure 45**).



Figure 45. Model G0638 control box mounted.

Test Run

When the assembly is complete, test run your dust collection system to make sure it operates properly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review the **Troubleshooting** on **Page 47**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run your dust collection system:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is setup properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Review **Circuit Requirements** on **Page 11** and connect the machine to the power source.
4. Flip the main power switch at the lower left hand corner of the control box (see **Figure 46**).

Note: For the Model G0638, make sure the **EMERGENCY STOP** button is popped out by twisting the knurled knob clockwise.

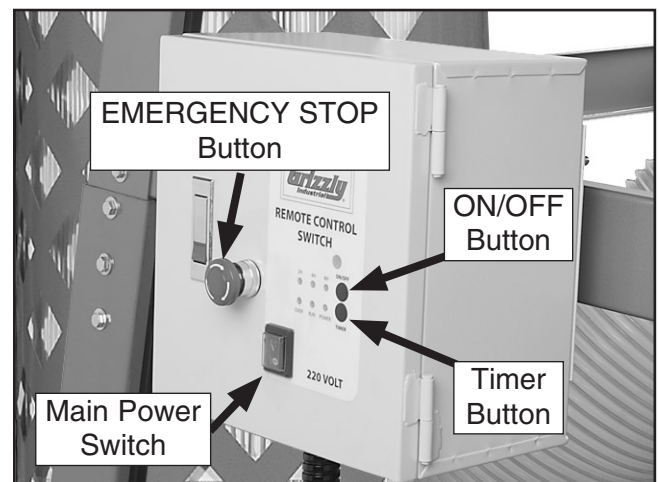


Figure 46. Control box (Model G0638 shown).



5. Press the ON/OFF button to turn the machine **ON**. Make sure your hand stays poised over the switch in case you need to quickly turn the machine **OFF**.
6. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.
 - If you suspect any problems, immediately turn the machine **OFF** and disconnect the machine from power. Refer to **Troubleshooting** on **Page 47** to identify and fix any problems.
 - If you cannot solve the problem with the use of the **Troubleshooting** guide, contact our Tech Support at (570) 546-9663 for assistance.
7. Press the TIMER button on the control box and cycle through each of the times to make sure the indicators light.
8. Press the TIMER button on the remote control and cycle through the times in the same manner as **Step 7**.
9. Toggle the ON/OFF button on both the control box and the remote control to make sure they are working properly.

WARNING

If any part of your body contacts the spinning impeller, severe cutting or amputation injuries could occur. Always keep well away from the impeller and never use any tools near the impeller when the machine is connected to power.

Note: For proper operation, the impeller inside the blower housing must be rotating counterclockwise. Since the motor and impeller are directly connected, you will verify in the next step that the motor is rotating in the correct direction.

Keep in mind that if the motor is rotating in the incorrect direction, the dust collector will still operate but with drastically reduced performance.

10. Safely use a ladder so that you can observe the motor fan through the top motor cover. Stay clear of the motor, then use the remote control to turn the motor **ON** and **OFF** while you note the fan rotation direction.
 - If the motor fan is rotating *counterclockwise* while looking down on it, the rotation direction is correct.
 - If the motor fan is rotating *clockwise*, the rotation direction is incorrect and the motor is receiving power out-of-phase. You will need perform the **Correcting Phase Polarity** procedure on **Page 14** so that the impeller will rotate in the correct direction.
11. **For the G0638 only:**
 - a. Turn the machine **OFF**.
 - b. Press the EMERGENCY STOP button in.
 - c. Turn the machine **ON**—nothing should happen.
 - d. Turn the machine **OFF**.
 - e. Pop the EMERGENCY STOP button out by twisting the knurled knob clockwise.
 - f. Pressing the ON/OFF button should now turn the dust collector **ON**.



SECTION 4: DESIGNING THE SYSTEM

General

The Model G0637/G0638 is designed to be a central dust collector system. Locate the dust collector in an out of the way location such as a corner or separate room. The large suction capacity of the Model G0637/G0638 allows great flexibility in planning and designing of your dust collection duct layout. Grizzly offers a complete line of dust collection accessories for setting up a stationary system. Additionally, Grizzly offers a complete guide book titled *Dust Collection Basics*.

Whatever system design you choose, always make sure there are no open flames (including pilot lights) in the same room as the dust collector; otherwise you risk an explosion if dust is dispersed into the air.

Duct Material

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

Plastic duct is also a popular material for home shops. However, be aware that there is a fire or explosion hazard if plastic duct material is used for dust collection without being grounded against static electrical charge build-up. This topic will be discussed later in this section. Another problem with using plastic is that it is less efficient per foot than metal.

Metal Duct

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

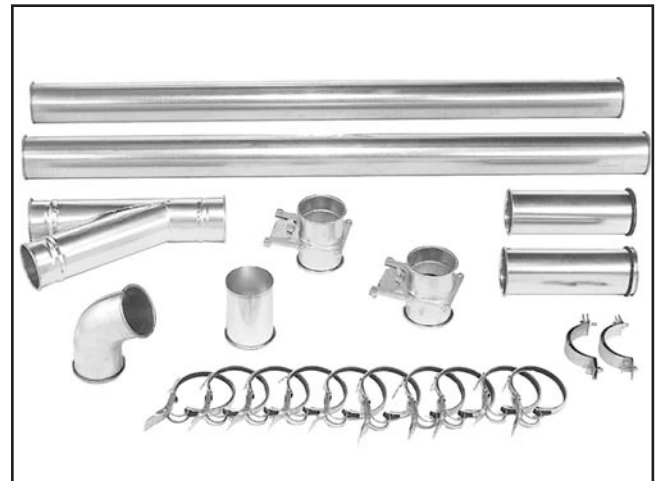


Figure 47. Examples of metal pipe and components.



There are quite a number of options when it comes to metal duct, but metal duct that is specially manufactured for dust collection is the best choice. When selecting your metal duct, choose high quality metal duct with smooth welded internal seams that will minimize airflow resistance. This type of duct usually connects to other ducts or elbows with a simple, self-sealing clamp, is very quick and easy to assemble, and can be readily dismantled and re-installed. This is especially important if you ever need to change things around in your shop or add more tools. See the **Accessories** section on **Page 41** for examples.

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

Flexible Duct

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

The superior choice for flexible ducting is metal flex hose that is designed to be flexible and as smooth as possible to reduce static pressure loss.

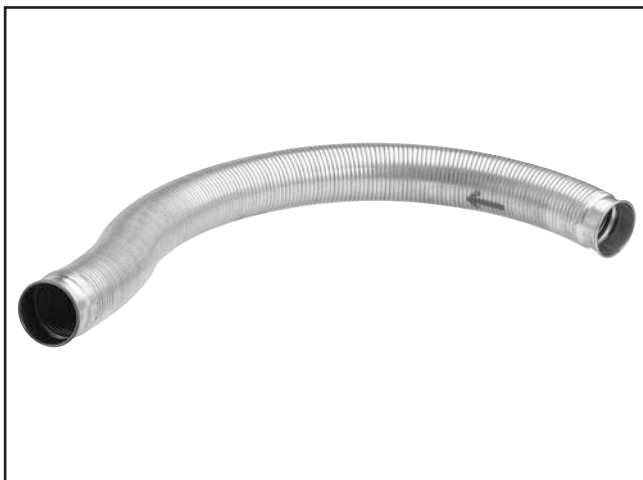


Figure 48. Example of flexible metal duct.

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

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

Plastic Duct

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



Figure 49. Example of plastic duct and components.



System Design

Step 1. Decide Who Will Design

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

If you have a large shop or must design a complicated system, then we recommend additional research beyond this manual, or seek help from an expert.

Step 2. Sketch Your Shop Layout

Planning is the most important step when designing a successful dust collection system.

Before you begin to draw your necessary layout sketch, we recommend that you visit our **FREE Workshop Planner** available on our website at www.grizzly.com.

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

Your sketch only needs the basic details of the shop layout, similar to **Figure 50**, including all your current/planned machines and your planned placement of the dust collector.

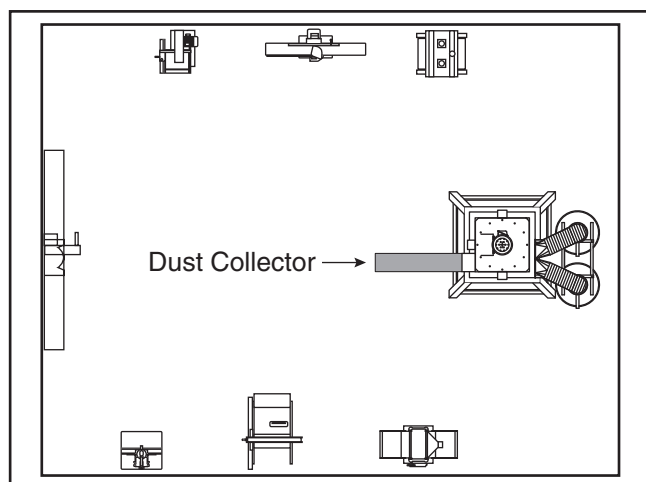


Figure 50. Initial sketch of shop layout.

Step 3. Sketch a Basic Duct Layout

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

1. Machines that produce the most sawdust should be placed nearest to the dust collector (i.e. planers and sanders).
2. An ideal design will feature the shortest possible main line and secondary branch ducts. See **Figures 51 & 52** for ideas of good duct layouts vs bad duct layouts.

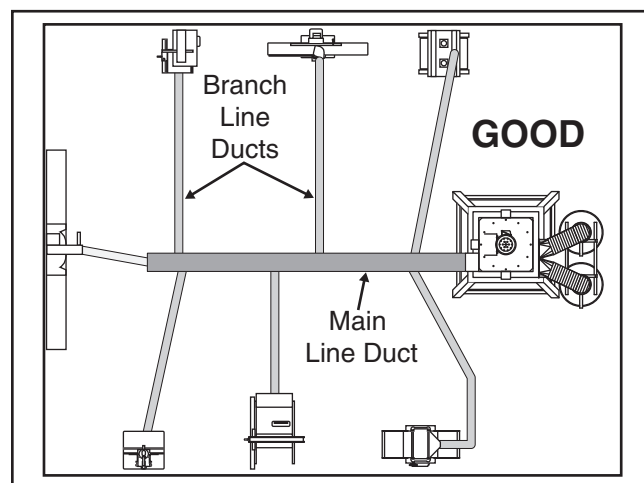


Figure 51. Good duct layout.

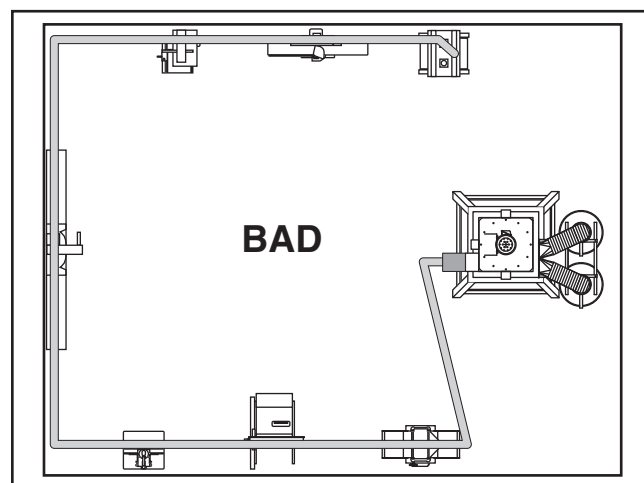


Figure 52. Bad duct layout.



3. Directional changes should be kept to a minimum. The more directional change fittings you use directly increases the overall resistance to airflow.
4. Gradual directional changes are more efficient than sudden directional changes (i.e. use the largest corner radius possible when changing hose or pipe direction).
5. Each branch line should have a blast gate immediately after the branch to control suction from one machine to another.
6. The simpler the system, the more efficient and less costly it will be.

Step 4. Determine Required CFM of Each Machine

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

Figure 53 will give you a close estimation of the airflow your machine requires. Machines that generate the most sawdust should be placed near the dust collector. If the machine has multiple dust ports, the total CFM required is the sum of all ports.

Machine Dust Port Size	Approximate Required CFM
2"	98
2.5"	150
3"	220
4"	395
5"	614
6"	884
7"	1203
8"	1570
9"	1990
10"	2456

Figure 53. Approximate required airflow for machines, based on dust port size.

If your machine does not have a built in dust port, use **Figure 54** to determine the size of dust port to install on your machine.

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

Figure 54. Dust port size and quantity per average machine.

Write the required CFM for each machine on your sketch, as shown in **Figure 55**.

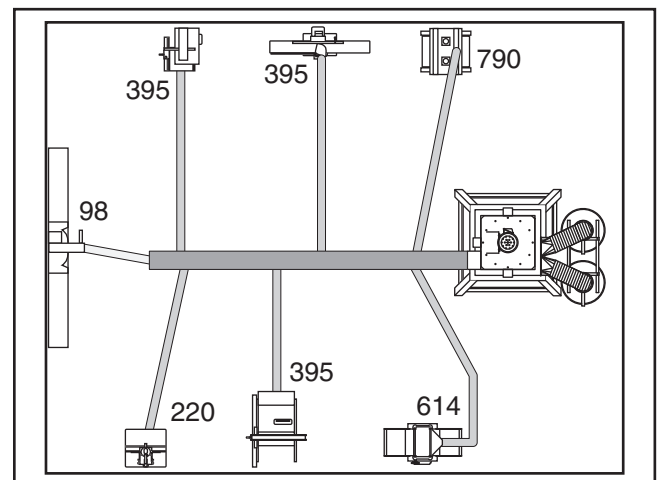


Figure 55. CFM requirements labeled for each machine.



Determining Main Line Duct Size

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

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

For the Model G0637/G0638 this is 10". Mark your drawing as in **Figure 56**.

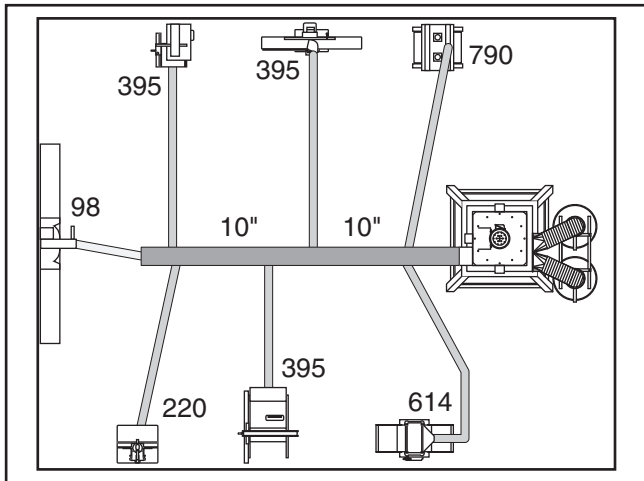


Figure 56. Main line size labeled on sketch.

Determining Branch Line Duct Size

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

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

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

Write your determined branch line sizes on your drawing, as shown in **Figure 57**.

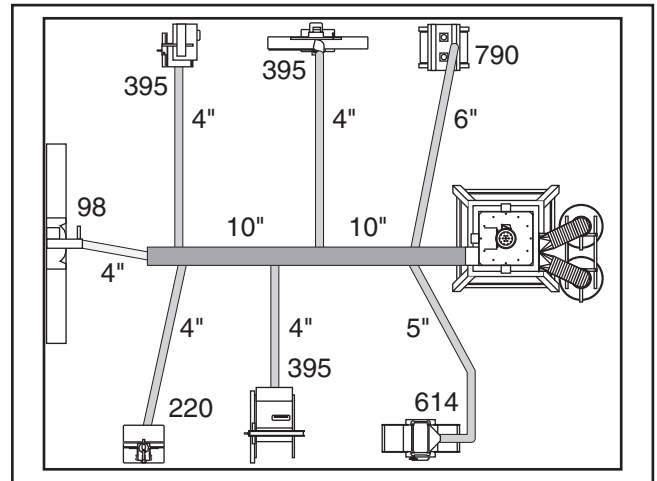


Figure 57. Branch line sizes labeled on sketch.

A few frequently asked questions when determining branch line sizes:

What size of branch line do I use if the machine has two dust ports?

Simply add the total CFM given for each size from **Figure 53** and refer to that CFM number in **Figure 58**. Then, split the branch line just before the dust ports with matching duct sizes.

How do I manage two machines on the same branch line?

You have two options:

1. If both machines will be running at the same time, add the total CFM given for each size from **Figure 53** and match the branch line given in **Figure 58**.
2. If both the machines will never be run at the same time, reference the machine with biggest dust port in **Figure 58** and add blast gates after the Y-branch to open/close the line to each machine.

Total CFM	Branch Line Size
600	5"
700	5"
800	6"
1000	6"
1200	7"
1400	8"
1600	8"

Figure 58. Branch line sizing chart by total CFM (for use when multiple machines share line).



Calculating Duct Resistance

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

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

The purpose of calculating this resistance is to determine if it is low enough from the machine to the dust collector to meet the given requirement for the machine. Use the charts in **Figure 59** to calculate the resistance of duct work.

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

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

Figure 59. Static pressure loss charts.

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

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

1. Make a list of each size duct in the line, including the length, and multiply those numbers by the static pressure loss value given in **Figure 59**.
2. List each type of elbow or branch and multiply the quantity (if more than one) by the static pressure loss given in **Figure 59**.
3. Add the additional factors from **Figure 60** to your list.

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

Figure 60. Additional factors affecting static pressure loss.

4. Total your list as shown in the example in **Figure 61** to come up with your overall static pressure loss number for that line.

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

Main Line	
6" Rigid Pipe (0.037) at 20'	0.740
Branch Line	
4" Rigid Pipe (0.075) at 10'	0.750
4" Flex Pipe (0.28) at 5'	1.400
Elbows/Branches	
6" 45° Y-Branch	0.329
4" 45° Elbow	0.225
Additional Factors	
Seasoned Filter	1.000
Total Static Pressure Loss	4.444

Figure 61. Example list for totaling SP loss.



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

5. Compare the total static pressure loss for that line to the maximum static pressure rating of your dust collector (refer to the **Machine Data Sheets** on **Pages 4 & 6**).

—If your static pressure loss is below the static pressure rating of the dust collector, then the line will most likely be successful. Congratulations! You've just designed your own dust system. Refer to the **Accessories** section on **Page 41** to start buying the components necessary to make your system a reality.

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

System Grounding

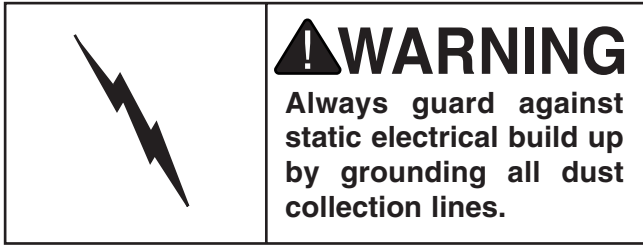
Since plastic hose is abundant, relatively inexpensive, easily assembled and air tight, it is a very popular material for conveying dust from woodworking machines to the dust collector. We recommend using flexible hose (flex-hose) to connect the woodworking machine to the dust collection system. However, plastic flex-hose and plastic duct are insulators, and dust particles moving against the walls of the plastic duct create static electrical build up. This charge will build until it discharges to a ground. If a grounding medium is not available to prevent static electrical build up, the electrical charge will arc to the nearest grounded source. This electrical discharge may cause an explosion and subsequent fire inside the system.

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

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

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





Ensure that the entire system is grounded. If using plastic blast gates to direct air flow, the grounding wire must be jumped (**Figure 62**) around the blast gate without interruption to the grounding system.

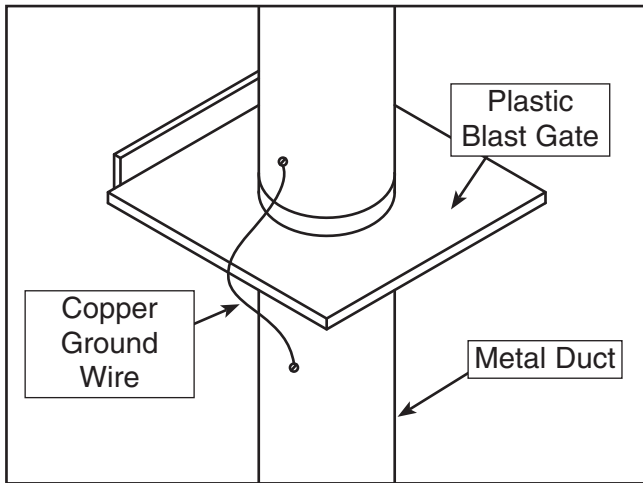


Figure 62. Ground jumper wire when using plastic blast gates and metal duct.

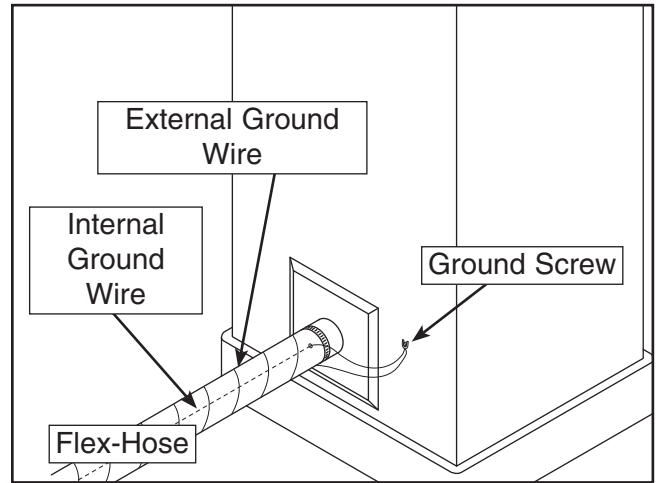


Figure 63. Flex-hose grounded to machine.

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

Attach the bare ground wire to each stationary woodworking machine and attach to the dust collector frame with a ground screw as shown in **Figure 63**. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.



SECTION 5: ACCESSORIES

H5293—4" Metal Duct Starter Kit

H5295—5" Metal Duct Starter Kit

H5297—6" Metal Duct Starter Kit

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

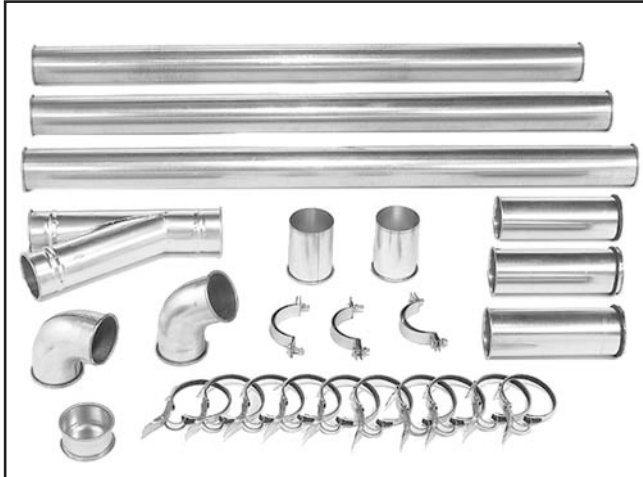


Figure 64. Metal Duct Starter Kit.

H5294—4" Metal Duct Machine Addition Kit

H5296—5" Metal Duct Machine Addition Kit

H5298—6" Metal Duct Machine Addition Kit

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

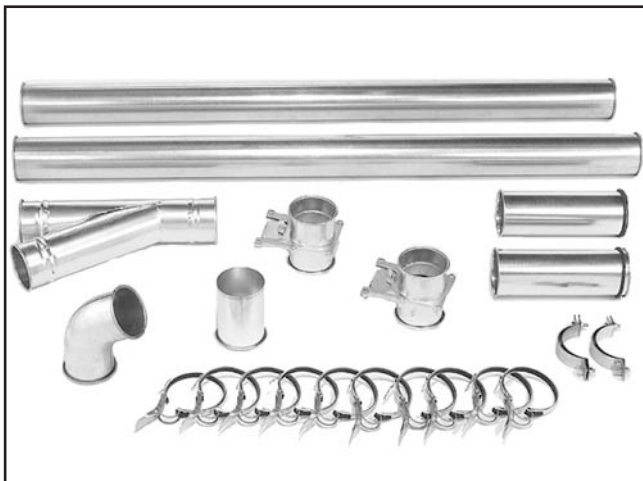


Figure 65. Metal Duct Machine Addition Kit.

G6162—4" x 5' Straight Metal Pipe

G7346—5" x 5' Straight Metal Pipe

G7364—6" x 5' Straight Metal Pipe

H5227—7" x 5' Straight Metal Pipe

H5237—8" x 5' Straight Metal Pipe

H5252—9" x 5' Straight Metal Pipe

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



Figure 66. Straight Metal Pipe.

H7216—5" x 5' Rigid Metal Flex Hose

H7217—6" x 5' Rigid Metal Flex Hose

H7218—7" x 5' Rigid Metal Flex Hose

H7219—8" x 5' Rigid Metal Flex Hose

H7220—9" x 5' Rigid Metal Flex Hose

This flex hose provides just enough flexibility to make difficult connections while still keeping the inside wall as smooth as possible to minimize static pressure loss.

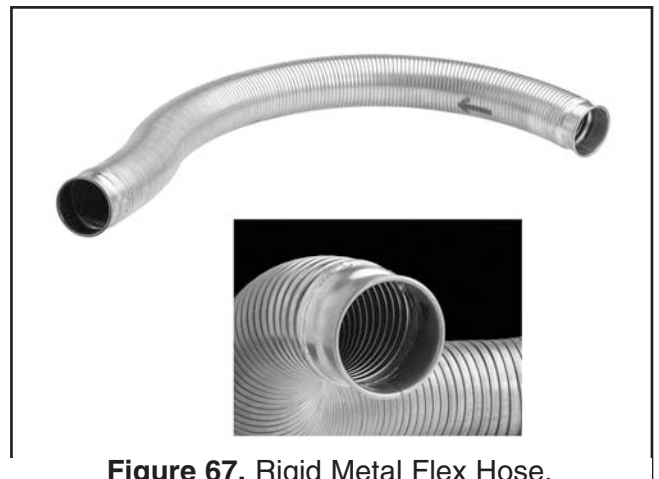


Figure 67. Rigid Metal Flex Hose.



Metal Elbows

These industrial metal elbows are available from 4"–8" with 90°, 60°, 45°, or 30° curves. Also, available with a 90° long radius curve. Call (800) 523-4777 or visit www.grizzly.com for more information and pricing.

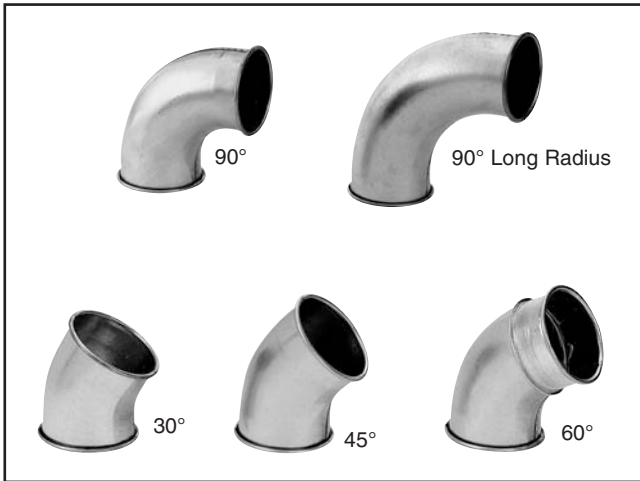


Figure 68. Metal elbow examples.

- G6177—4" Metal Blast Gate
- G7340—5" Metal Blast Gate
- G7358—6" Metal Blast Gate
- H5234—7" Metal Blast Gate
- H5249—8" Metal Blast Gate
- H5259—9" Metal Blast Gate



Figure 69. Metal Blast Gate.

Call 1-800-523-4777 To Order

Metal Branches

We carry many different branches, all designed to minimize airflow resistance.



Figure 70. Metal Branches.

Reducers & Adapters

We carry a multitude of reducers and elbows to cover most applications from 4" through 9".



Figure 71. Metal Reducers & Adapters.

- G6252—4" Floor Sweep
- G7341—5" Floor Sweep
- G7342—6" Floor Sweep

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



Figure 72. Industrial Floor Sweep.



SECTION 6: OPERATIONS

Operation Safety

!WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.

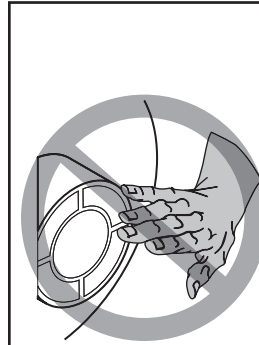


!CAUTION

DO NOT use the dust collector for any other purpose besides collecting dust from connected woodworking machines. A dust collector should **NEVER** be used as a shop vacuum and **IS NOT** a substitute for an air filter system. For safest use, wear a respirator and use an air cleaner in addition to the dust collector.

NOTICE

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, trade 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.



!WARNING

Do **NOT** put hands or small objects near inlet openings during operation. Objects sucked into the inlet will meet with the impeller blade. Failure to heed this warning could result in property damage or personal injury.

General

Operating your Model G0637/G0638 is simple and straightforward. Blast gates located at each of the machines controls the air flow from the woodworking machine to the dust collector. If a machine is not being used, keep the blast gate closed to maintain higher levels of efficiency throughout the system.

Remote Control

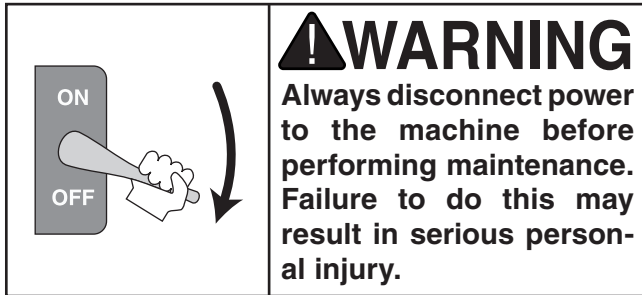
The remote control for the Model G0637/G0638 is IR (infrared) rather than RF (radio frequency) to prevent accidental startups by other common RF items like garage door openers.

Because this remote system is IR, the remote control must be pointing directly at the control box with an unobstructed line-of-sight view.

If you place your dust collector in a different room or outside of your shop, you must mount the switch in the shop and wire it through the wall to the dust collector to make use of the remote control.



SECTION 7: MAINTENANCE



Schedule

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

Daily Check:

- Dust collector is completely powered down at the end of use.
- Dust collection drums and bags.
- Loose mounting bolts.
- Pressure leaks.
- Worn or damaged wires.
- Any other condition that would hamper the safe and efficient operation of this machine.

Emptying Drums

Empty the collection drums when they are $\frac{3}{4}$ full or less. If the drums become overfilled, the dust will be sucked into the intake barrel and passed through to the canister filters.

How quickly the drum will fill up is based on the type of work being done at the time:

- Fine dust from a sander or table saw will slowly fill the drums.
- Curly shavings from a planer or jointer will quickly fill the drums.

In the beginning, check your drums regularly to get an idea of how often they need to be emptied.

Cleaning Filters

The Model G0637/G0638 dust collector has a gentle brush system inside the canisters for removing any built-up dust from the filter pleats.

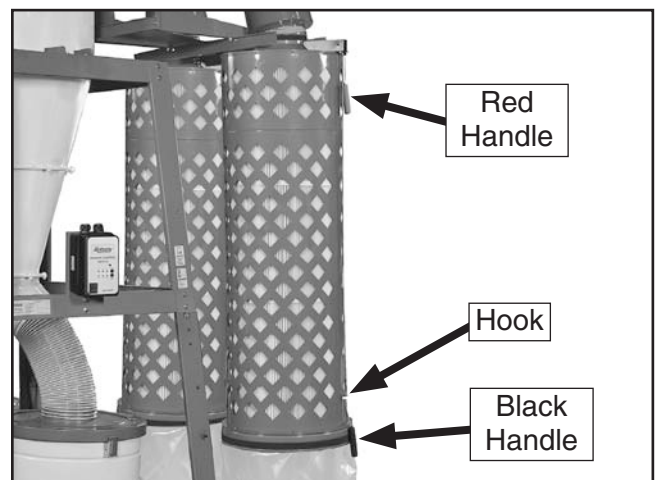
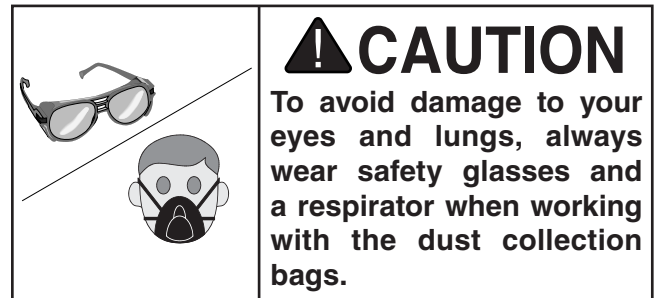


Figure 73. Brush handles for cleaning canister filters.

To clean the filters, pull the red handles down all the way, then pull the black handles down and hook them in place.

Note: Always make sure to leave the red handles in the up position to ensure that the brushes return to their proper position and do not restrict the filter.



Rinsing Filter

For a thorough cleaning, the filter can be removed and rinsed off. However, make sure to clean the filter with the brush system first. Allow the filter to air dry, but never leave the filter in the sun to dry or it could become damaged.

Removing/Replacing Filter

The filter for canister filter assemblies manufactured since November, 2009, can be removed from the assembly so that it can be replaced or rinsed off (see the instructions in the next subsection).

Removing/installing the filter requires removing the canister filter assembly from the dust collector and disassembling it. Follow the instructions below to perform this procedure.

Refer to the parts breakdown diagrams and listings beginning on **Page 56** to order the correct filter from Grizzly at 800-523-4777.

Tools Needed	Qty
Open-End Wrench 10mm.....	1
Wrench or Socket 12mm.....	2

To replace the canister filter:

1. DISCONNECT MACHINE FROM POWER!
2. Remove the bag clamp and collection bag from the canister assembly.

3. Pull the black handle all the way down and secure the cable into the handle hook at the bottom of the canister assembly, as shown in **Figure 2**, to hold it in place during the following steps.

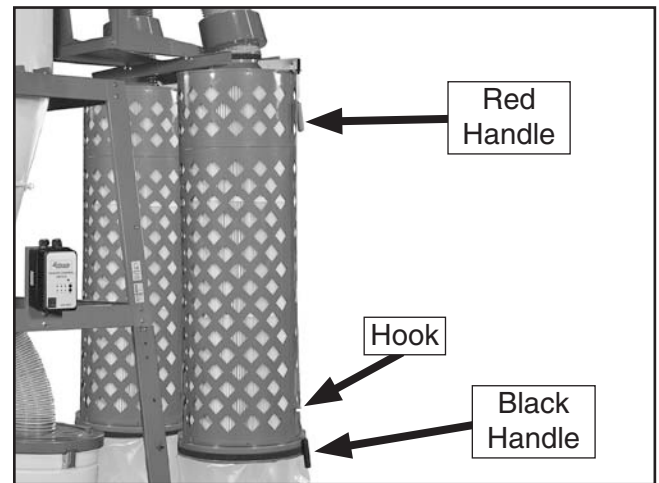


Figure 2. Black handle cable secured in the handle hook.

4. Remove the canister assembly from the dust collector and place it right-side up on a stable, flat surface.
5. Remove the six hex bolts, hex nuts, and flat washers from the rim of the canister base, as shown in **Figure 74**.

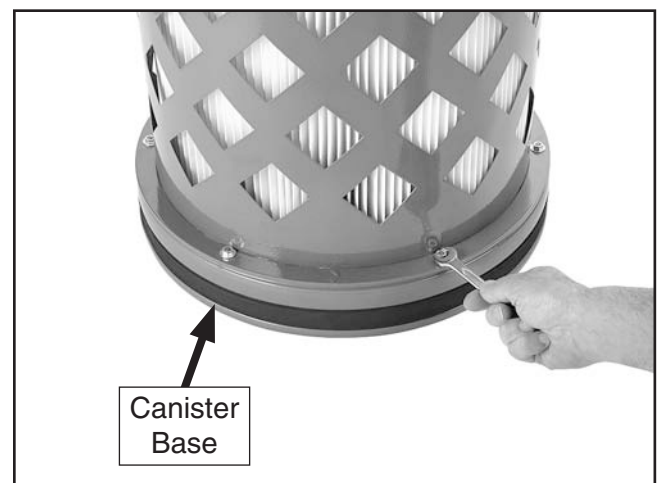


Figure 74. Removing the hex nuts and flat washers from the rim of the canister base.



6. With help from another person to steady the canister assembly, turn it upside down and remove the two M8-1.25 x 20mm hex bolts, hex nuts, and flat washers from the cross support (see **Figure 75**), then remove the canister base from the assembly.



Figure 75. Cross support fasteners.

7. Carefully lift the filter from the canister assembly, as shown in **Figure 76**.



Figure 76. Removing the filter from the canister assembly.

8. Before re-inserting a filter into the assembly, make sure that the filter brush base is aligned with two of the fastener holes around the base of the assembly (see **Figure 77**). This will allow the canister base to align with the fastener holes around the brush base.



Figure 77. Filter brush base aligned with assembly fastener holes.

9. Re-insert a filter into the canister assembly.

Note: *Make sure the bristles of the brush are straight to ensure efficient cleaning of the filter when needed.*

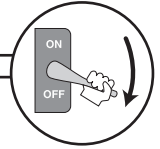
10. Re-attach the canister base in the reverse order that you removed it.
11. Re-attach the canister assembly to the dust collector, then re-install a fresh collection bag with the bag clamp.



SECTION 8: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting

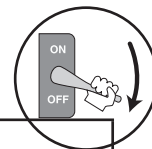


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Fuse has blown. 2. Emergency stop push-button is engaged/faulty. 3. Hand-held remote controller is at fault. 4. Receiver is at fault. 5. Motor connection wired incorrectly. 6. Wall fuse/circuit breaker is blown/tripped. 7. Thermal overload relay has tripped. 8. Contactor not getting energized/has burnt contacts. 9. Power supply switched OFF or is at fault. 10. Wiring is open/has high resistance. 11. Motor ON button or ON/OFF switch is at fault. 12. Emergency stop push-panel is stuck/switch is at fault. 13. Transformer is at fault. 14. Computer board is at fault. 15. Inverter/control box is at fault. 16. Motor is at fault. 17. Start delay module is at fault. 	<ol style="list-style-type: none"> 1. Correct short/replace fuse in control box. 2. Rotate clockwise slightly until it pops out/replace it. 3. Replace batteries in hand-held remote controller; stay in line-of-sight view and signal range. 4. Inspect receiver computer board; replace if faulty. 5. Correct motor wiring connections (Pages 52 & 55). 6. Ensure circuit size is suitable for this machine; replace weak breaker. 7. Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times (weak relay). 8. Test for power on all legs and contactor operation. Replace unit if faulty. 9. Ensure power supply is switched on; ensure power supply has the correct voltage. 10. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 11. Replace faulty ON button or ON/OFF switch. 12. Free push-panel from binding; replace faulty switch. 13. Replace transformer. Refer to Page 13 for more detail information. 14. Inspect computer board; replace if faulty. 15. Inspect inverter/control box; replace if faulty. 16. Test/repair/replace. 17. Adjust to correct delay; replace module.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. Motor mount loose/broken. 3. Machine is incorrectly mounted or sits unevenly. 4. Motor fan is rubbing on fan cover. 5. Motor bearings are at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Tighten/replace. 3. Tighten/replace anchor studs in floor; relocate/shim machine. 4. Replace dented fan cover; replace loose/damaged fan. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Dust Collector Operation



Symptom	Possible Cause	Possible Solution
Loud, repetitious noise, or excessive vibration coming from dust collector.	<ol style="list-style-type: none"> 1. Dust collector is not on a flat surface and wobbles. 2. Impeller is damaged and unbalanced. 3. The motor mounting or housing connections are loose. 4. Impeller is loose on the motor shaft. 5. Motor fan cover is dented, causing the motor fan to hit the cover while spinning. 	<ol style="list-style-type: none"> 1. Stabilize the dust collector. 2. Disconnect dust collector from power, and inspect the impeller for dents, bends, loose fins. Replace impeller if any damage is found. 3. Make sure all fasteners on the dust collector are tight. 4. Replace the motor and impeller as a set if the motor shaft and the impeller hub are damaged. 5. Replace motor fan cover.
Dust collector does not adequately collect dust or chips; poor performance.	<ol style="list-style-type: none"> 1. Dust collection bags are full. 2. Filter is dirty. 3. There is a restriction in the duct line. 4. The dust collector is too far away from the point of suction, or there are too many sharp bends in the ducting. 5. The lumber is wet and dust is not flowing through the ducting smoothly. 6. There is a leak in the ducting, or a series of small leaks, or too many open ports. 7. There are not enough open branch lines at one time, thereby causing a velocity drop in the main line. 8. The ducting and ports are incorrectly sized. 9. The machine dust collection design is inadequate. 10. The dust collector is too small for the dust collection system. 	<ol style="list-style-type: none"> 1. Empty collection bags. 2. Clean filter. 3. Remove dust line from dust collector inlet and unblock the restriction in the duct line. A plumbing snake may be necessary. 4. Relocate the dust collector closer to the point of suction, and rework ducting without sharp bends. Refer to Designing the System, beginning on Page 33. 5. Process lumber with less than 20% moisture content. 6. Rework the ducting to eliminate all leaks. Close dust ports for lines not being used. Refer to Designing the System beginning on Page 33 for more solutions. 7. Open 1 or 2 more blast gates to different branch lines to allow the velocity in the main line to increase. 8. Reinstall correctly sized ducts and fittings. Refer to Designing the System beginning on Page 33 for more solutions. 9. Use a dust collection nozzle on a stand. 10. Install a larger dust collector to power your dust collection system.
Sawdust being blown into the air from the dust collector.	<ol style="list-style-type: none"> 1. Duct clamps or dust collection bags are not properly clamped and secured. 2. Cylinder or funnel seals are loose or damaged. 	<ol style="list-style-type: none"> 1. Re-secure ducts and dust collection bag, making sure duct and bag clamps are tight and completely over the ducts and bags. 2. Retighten all mounting and sealing points, replace damaged gaskets.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. 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.

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 	



G0637 Electrical Components

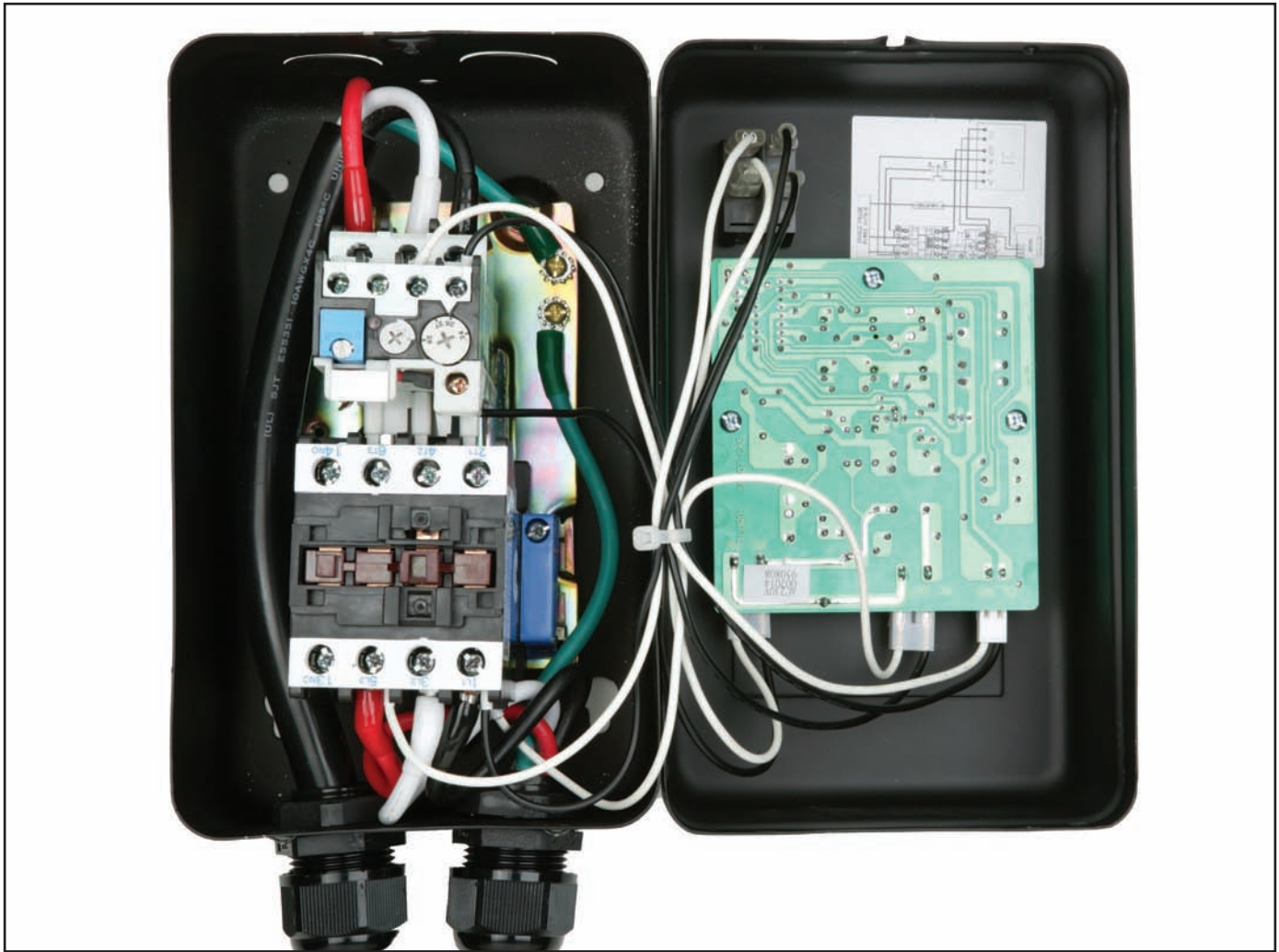


Figure 78. Model G0637 control box.

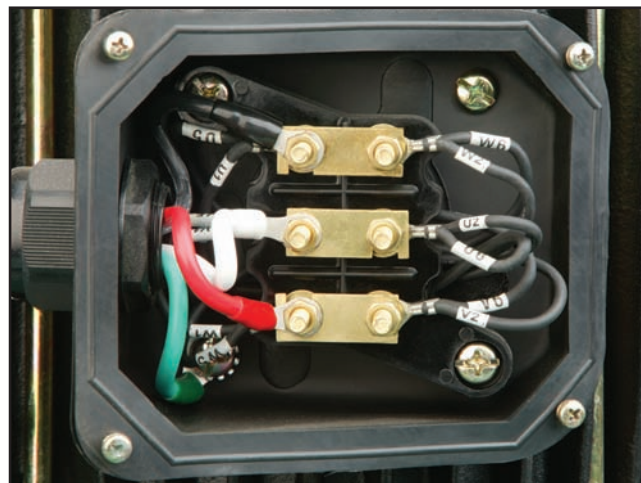


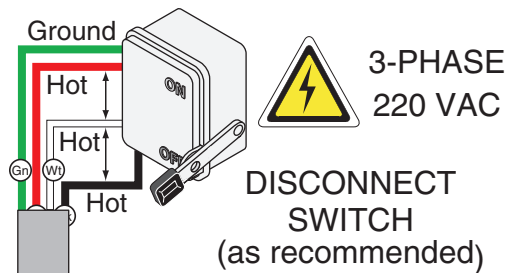
Figure 79. Model G0637 motor wiring (220V).

G0637 Control Box 220 VAC Wiring Diagram



COLOR KEY

BLACK		Bk
WHITE		Wt
GREEN		Gn
RED		Rd

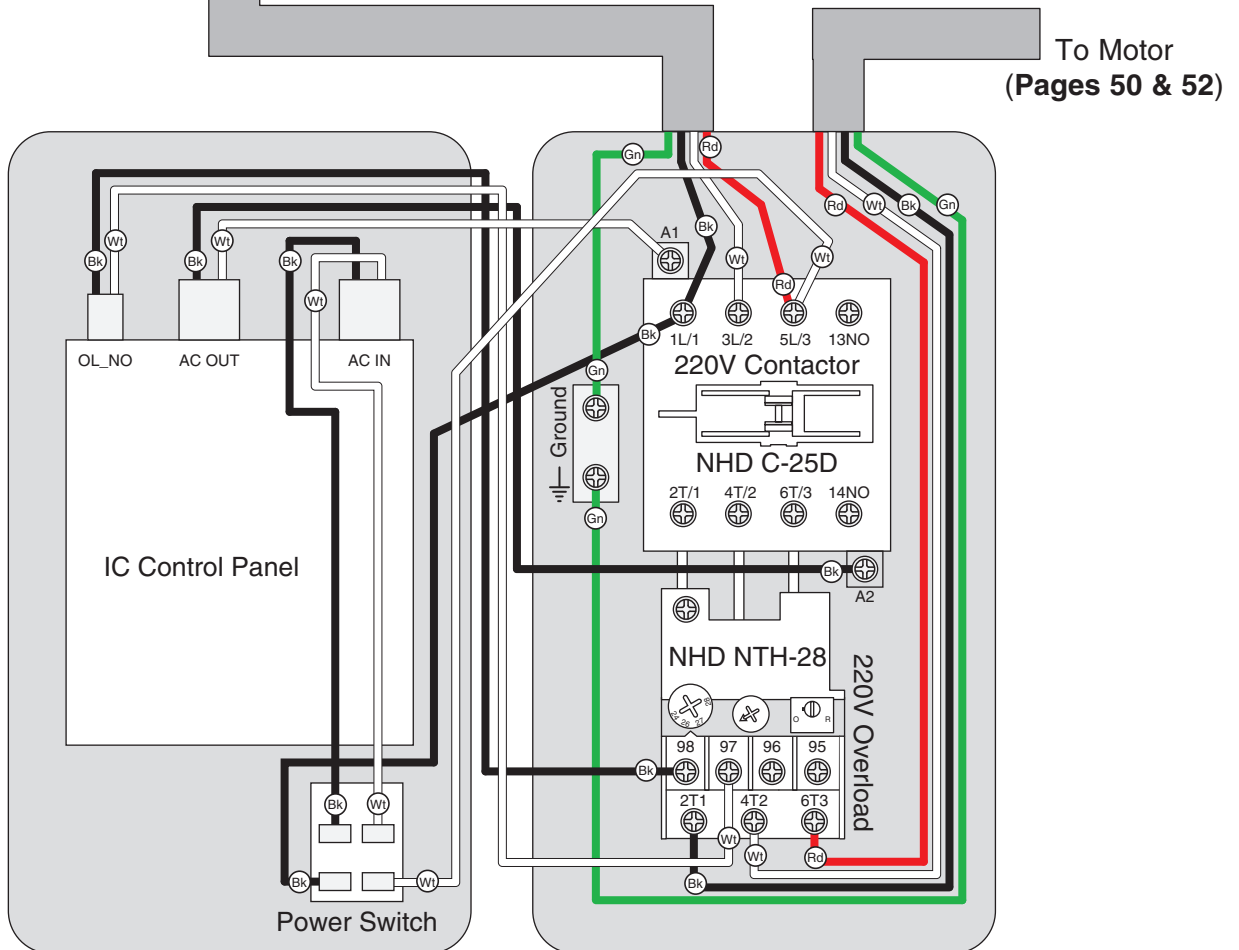


NOTICE

If connecting machine to a phase converter, the manufactured leg must be connected to terminal 3L/2.

NOTICE

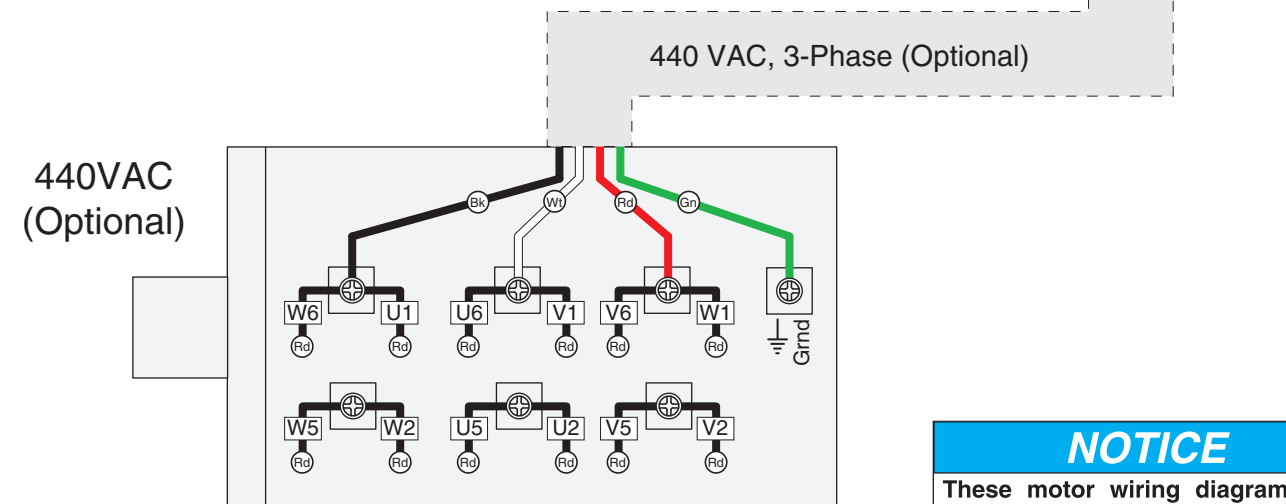
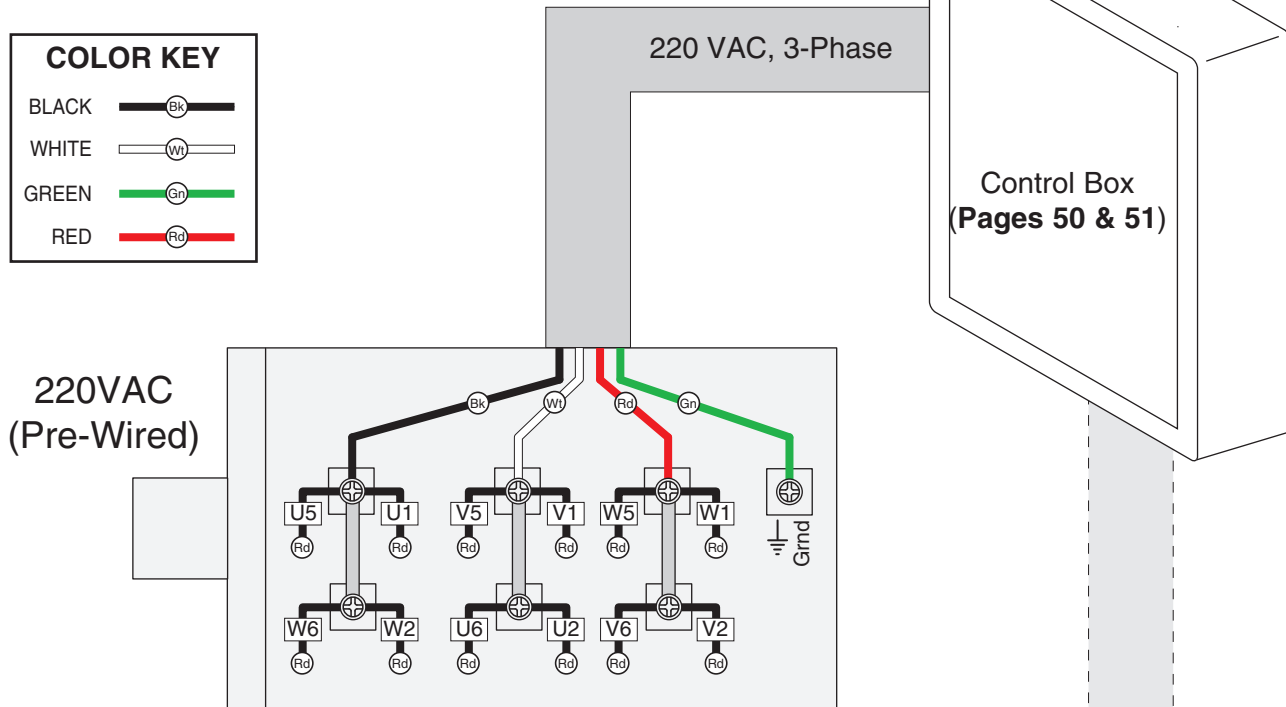
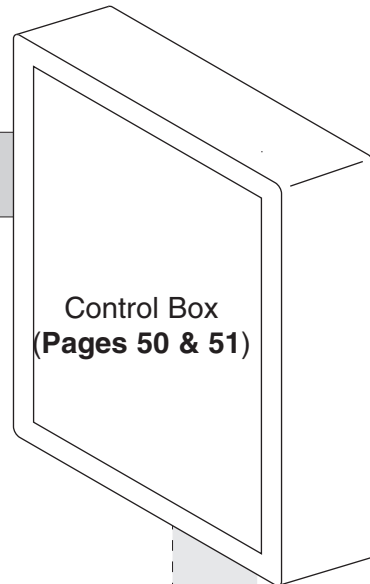
If motor rotates in opposite direction, swap any two power source wires at the incoming terminals.



G0637 Motor Wiring Diagram (220V/440V)



COLOR KEY	
BLACK	
WHITE	
GREEN	
RED	



When rewiring to 440V, you must purchase and install the 440V Conversion Kit. Refer to **Page 13** for details.

NOTICE
These motor wiring diagrams are current at the time of printing; however, always use the diagram on the inside of the junction box cover when rewiring your motor!



G0638 Electrical Components

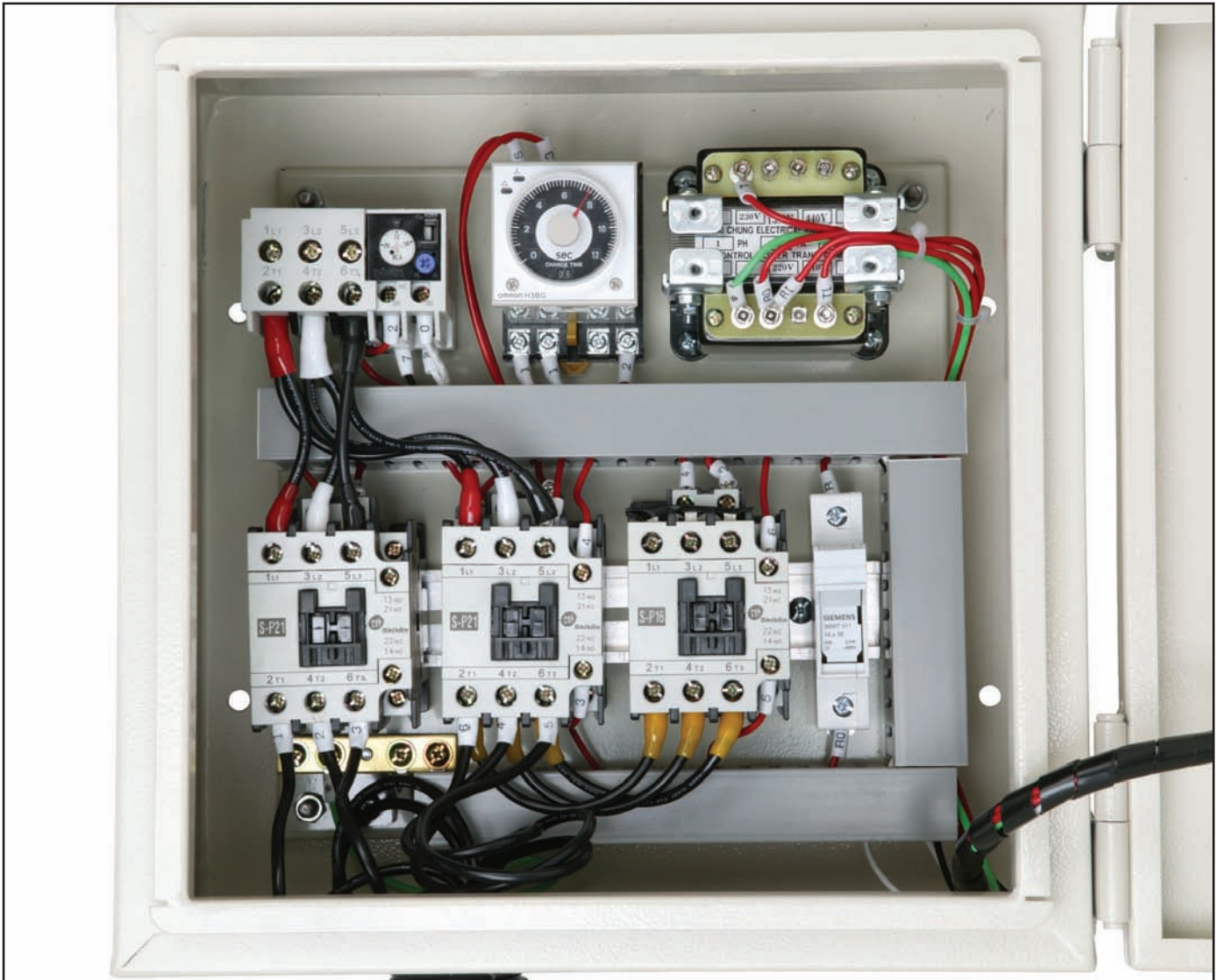


Figure 80. Model G0638 control box.

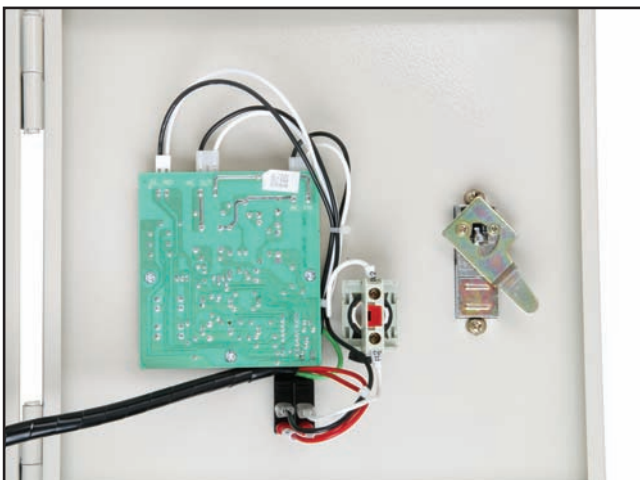


Figure 81. Model G0638 control box cover (shown from back).



Figure 82. Model G0638 motor wiring (220V).



G0638 Control Box 220 VAC Wiring Diagram



⚠ WARNING!
SHOCK HAZARD!
Disconnect power before working on wiring.

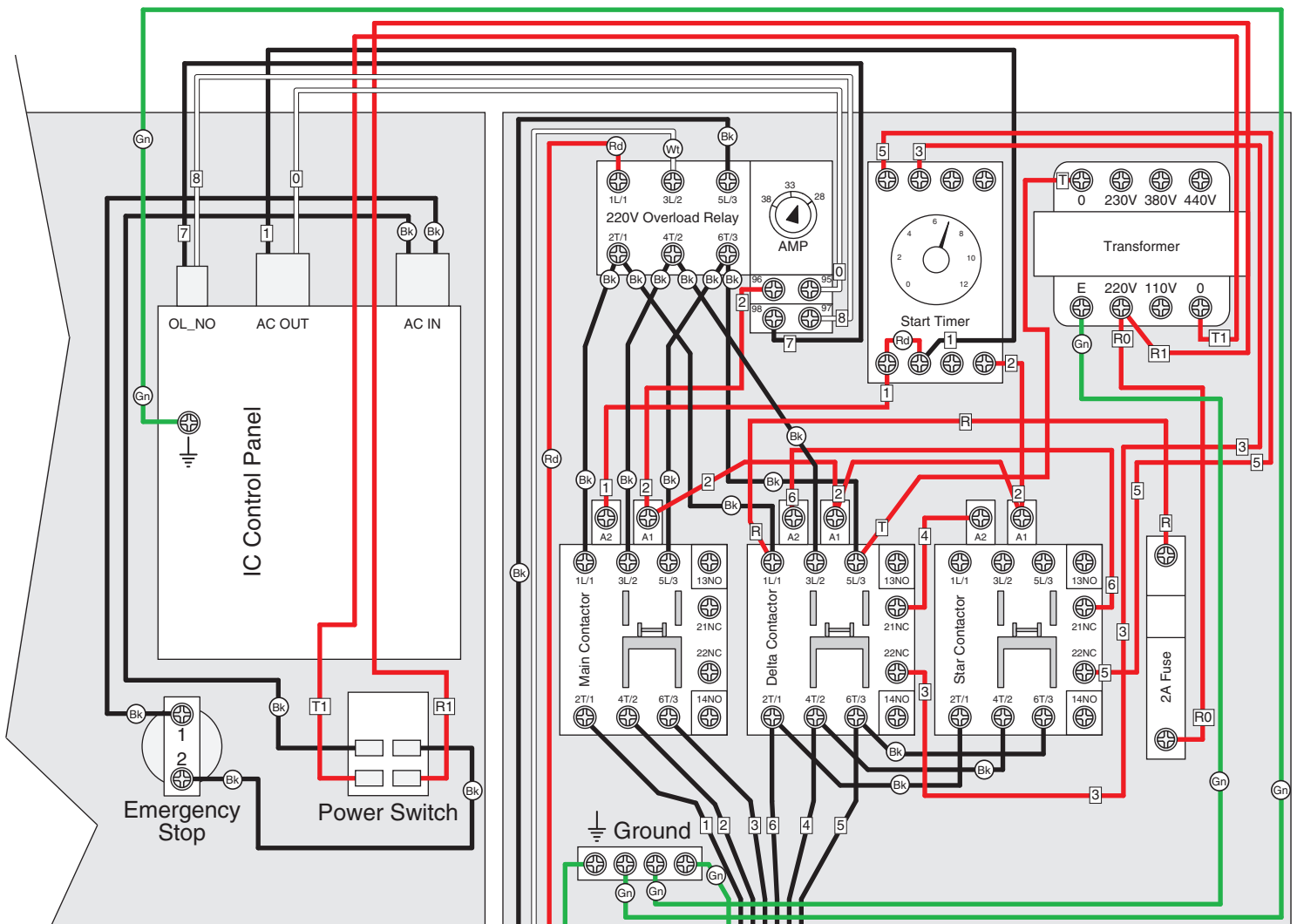
NOTICE
If connecting machine to a phase converter, the manufactured leg must be connected to terminal 3L/2.


COLOR KEY

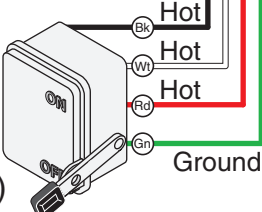
BLACK	
WHITE	
GREEN	
RED	

 View this wiring diagram in color at www.grizzly.com.

NOTICE
If motor rotates in opposite direction, swap any two power source wires at the incoming terminals.



 **3-PHASE 220 VAC**
DISCONNECT SWITCH
(as recommended)



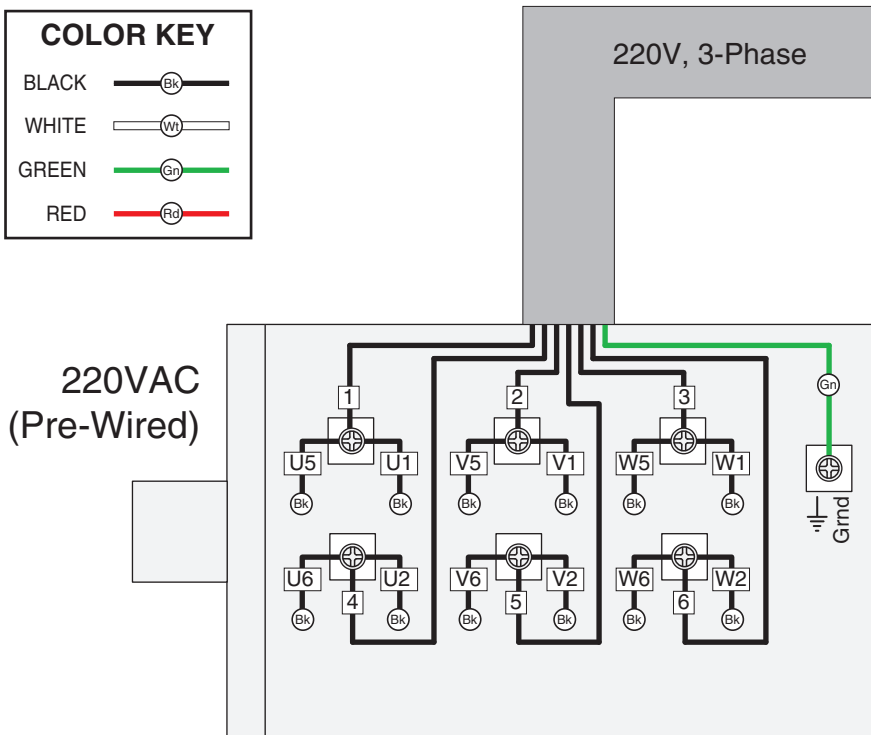
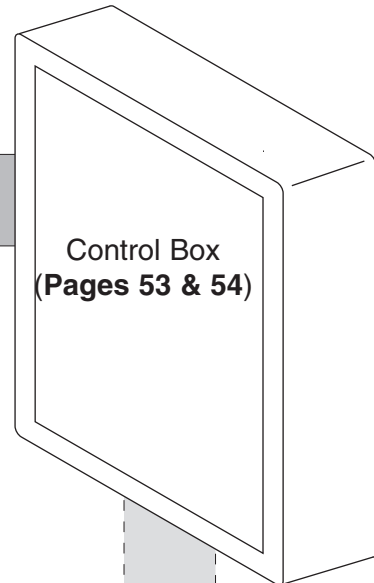
To Motor
(Pages 53 & 55)



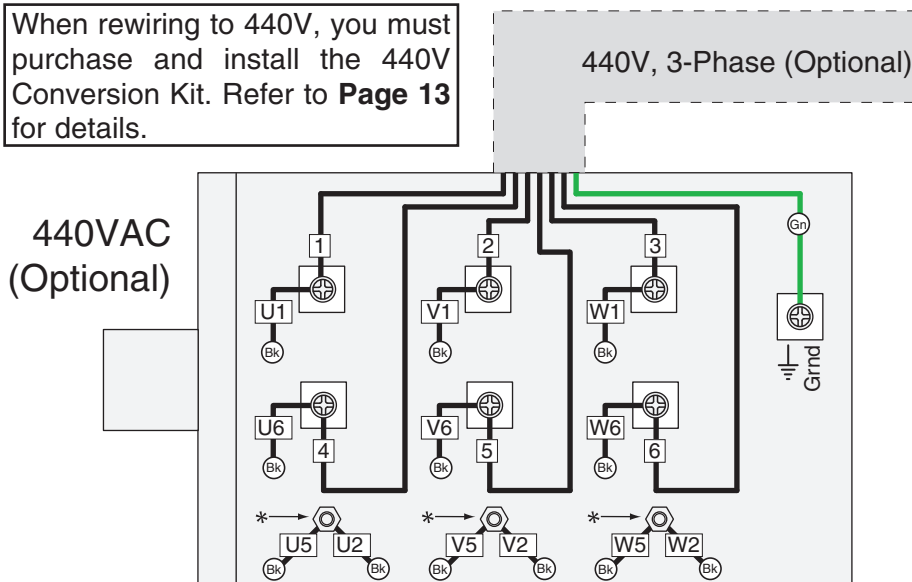
G0638 Motor Wiring Diagram (220V/440V)



COLOR KEY	
BLACK	
WHITE	
GREEN	
RED	



When rewiring to 440V, you must purchase and install the 440V Conversion Kit. Refer to **Page 13** for details.



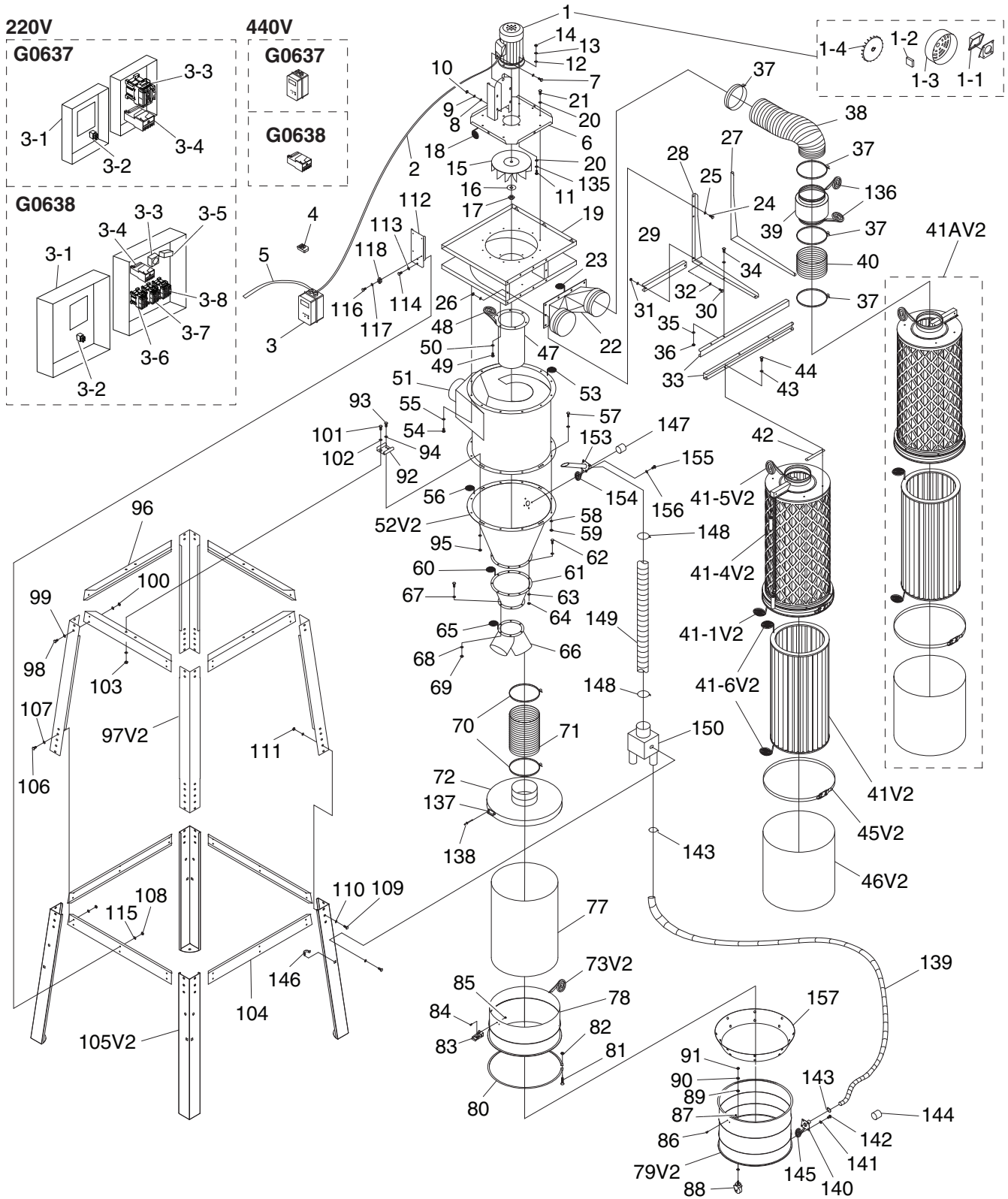
NOTICE
These motor wiring diagrams are current at the time of printing; however, always use the diagram on the inside of the junction box cover when rewiring your motor!

* Safely cover wire connections with electrical tape



SECTION 9: PARTS

Parts Breakdown



G0637 Only Parts List

REF	PART #	DESCRIPTION
1	P0638001	MOTOR 10HP 3PH 220/440V
1-1	P0638001-1	MOTOR JUNCTION BOX
1-2	P0638001-2	MOTOR JUNCTION BLOCK
1-3	P0638001-3	MOTOR FAN COVER
1-4	P0638001-4	MOTOR FAN
2	P0638002	MOTOR CORD 12AWG
3	P0638003	CONTROL BOX 220V
3-1	P0638003-1	CONTROL BOX CABINET W/IC BOARD
3-2	P0638003-2	POWER SWITCH
3-3	P0638003-3	START TIMER OMRON H3BG 0-12 SEC

REF	PART #	DESCRIPTION
3-4	P0638003-4	OL RELAY SHIHLIN TH-P20 28-38 220V
3-5	P0638003-5	TRANSFORMER
3-6	P0638003-6	CONTACTOR SHIHLIN S-P21
3-7	P0638003-6	CONTACTOR SHIHLIN S-P21
3-8	P0638003-8	CONTACTOR SHIHLIN S-P16
5	P0638005	POWER CORD 12AWG 4C
15	P0638015	IMPELLER 18-1/2"
16	PW19	FLAT WASHER 1-1/6
17	PN44	HEX NUT 1-1/16-8 LH
119	P0638119	440V CONVERSION KIT

G0638 Only Parts List

REF	PART #	DESCRIPTION
1	P0637001	MOTOR 7-1/2HP 3PH 220/440V
1-1	P0637001-1	MOTOR JUNCTION BOX
1-2	P0637001-2	MOTOR JUNCTION BLOCK
1-3	P0637001-3	MOTOR FAN COVER
1-4	P0637001-4	MOTOR FAN
2	P0637002	MOTOR CORD 10AWG
3	P0637003	CONTROL BOX
3-1	P0637003-1	CONTROL BOX CABINET W/IC BOARD

REF	PART #	DESCRIPTION
3-2	P0637003-2	POWER SWITCH
3-3	P0637003-3	CONTACTOR 220V
3-4	P0637003-4	OL RELAY 220V
5	P0637005	POWER CORD 10AWG 4C
15	P0637015	IMPELLER 18"
16	PW13	FLAT WASHER 3/4
17	PN42	HEX NUT 3/4-16 LH
119	P0637119	440V CONVERSION KIT

G0637/G0638 Common Parts List

REF	PART #	DESCRIPTION
4	P0443005	REMOTE CONTROLLER
6	P0637006	MOTOR BASE
7	PB16	HEX BOLT 3/8-16 X 1-1/2
8	PW02	FLAT WASHER 3/8
9	PLW04	LOCK WASHER 3/8
10	PN08	HEX NUT 3/8-16
11	PB55	HEX BOLT 1/2-13 X 1-1/2
12	PWF04	FENDER WASHER 1/2
13	PLW07	LOCK WASHER 1/2
14	PN06	HEX NUT 1/2-13
18	P0637018	GASKET 3 X 6 X 1700MM
19	P0637019	BLOWER
20	PW07	FLAT WASHER 5/16
21	PB07	HEX BOLT 5/16-18 X 3/4
22	P0637022	OUTLET PORT
23	P0637023	FOAM TAPE 3 X 15 X 700MM
24	PB03	HEX BOLT 5/16-18 X 1
25	PW07	FLAT WASHER 5/16
26	PN02	HEX NUT 5/16-18

REF	PART #	DESCRIPTION
27	P0637027	RIGHT FILTER L-BRACE
28	P0637028	LEFT FILTER L-BRACE
29	P0637029	SHORT FILTER BRACE SUPPORT
30	PB21	HEX BOLT 3/8-16 X 3/4
31	PN08	HEX NUT 3/8-16
32	PW02	FLAT WASHER 3/8
33	P0637033	LONG FILTER BRACE SUPPORT
34	PB21	HEX BOLT 3/8-16 X 3/4
35	PW02	FLAT WASHER 3/8
36	PN08	HEX NUT 3/8-16
37	P0637037	HOSE CLAMP 8"
38	P0637038	FLEXIBLE DUCT 8 X 31-1/2"
39	P0637039	NOISE MUFFLER 8"
40	P0637040	FLEXIBLE DUCT 8 X 4-3/4"
41AV2	P0637041AV2	CANISTER ASSEMBLY V2.11.09
41V2	P0637041V2	CANISTER FILTER 486 X 1195MM V2.11.09
41-1V2	P0637041-1V2	GASKET 3 X 25 X 1700MM V2.11.09
41-4V2	P0637041-4V2	CANISTER OUTER CAGE V2.11.09
41-5V2	P0637023	GASKET 3 X 25 X 700MM V2.11.09



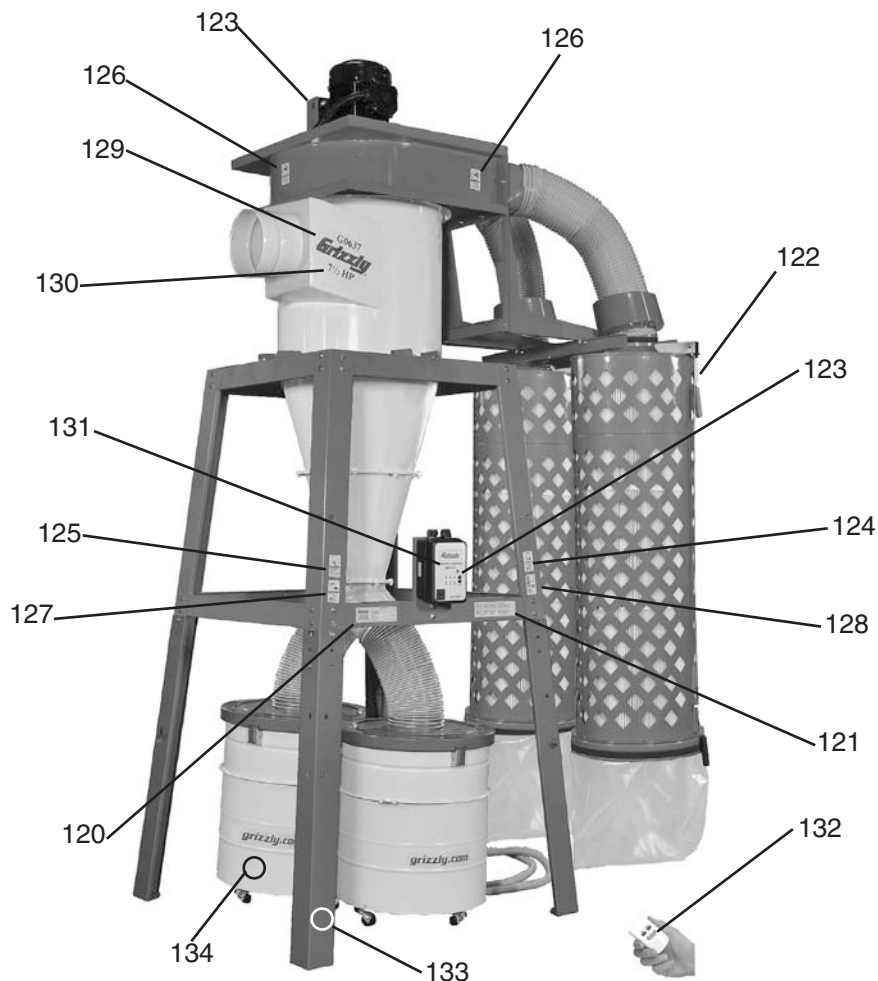
G0637/G0638 Common Parts List

REF	PART #	DESCRIPTION
41-6V2	P0637041-6V2	GASKET 35 X 38 X 1570MM V2.11.09
42	P0637042	RUBBER BRACE GASKET
43	PW07	FLAT WASHER 5/16
44	PB07	HEX BOLT 5/16-18 X 3/4
45V2	P0637045V2	FILTER BAG CLAMP 545MM V2.11.09
46V2	P0637046V2	COLLECTION BAG 570 X 600MM V2.11.09
47	P0637047	INTAKE CYLINDER
48	P0637048	GASKET 3 X 6 X 1800MM
49	PB07	HEX BOLT 5/16-18 X 3/4
50	PW07	FLAT WASHER 5/16
51	P0637051	INTAKE BARREL
52V2	P0637052V2	LARGE CYCLONE FUNNEL V2.08.10
53	P0637053	GASKET 3 X 6 X 2500MM
54	PB07	HEX BOLT 5/16-18 X 3/4
55	PW07	FLAT WASHER 5/16
56	P0637056	GASKET 3 X 6 X 2500MM
57	PB12	HEX BOLT 5/16-18 X 1-1/4
58	PW07	FLAT WASHER 5/16
59	PN02	HEX NUT 5/16-18
60	P0637060	GASKET 3 X 6 X 2200MM
61	P0637061	SMALL CYCLONE FUNNEL
62	PB12	HEX BOLT 5/16-18 X 1-1/4
63	PW07	FLAT WASHER 5/16
64	PN02	HEX NUT 5/16-18
65	P0637065	GASKET 3 X 6 X 735MM
66	P0637066	FUNNEL PORT
67	PB12	HEX BOLT 5/16-18 X 1-1/4
68	PW07	FLAT WASHER 5/16
69	PN02	HEX NUT 5/16-18
70	P0637070	HOSE CLAMP 9"
71	P0637071	FLEXIBLE DUCT 9 X 25-1/2"
72	P0637072	COLLECTION DRUM LID
73V2	P0441051V2	DRUM SEAL TYPE-R 2.0M V2.11.09
77	T20246	DRUM COLLECTION BAG
78	P0441052	UPPER DRUM 25GAL
79V2	P0440052V2	COLLECTION DRUM 35GAL V2.08.10
80	P0441054	DRUM CLAMP
81	PB04	HEX BOLT 5/16-18 X 3
82	PN02	HEX NUT 5/16-18
83	P0637083	COLLECTION DRUM LID LATCH
84	PS06	PHLP HD SCR 10-24 X 3/8
85	PN07	HEX NUT 10-24
86	PS06	PHLP HD SCR 10-24 X 3/8
87	PN07	HEX NUT 10-24
88	P0637088	CASTER 2"
89	PW02	FLAT WASHER 3/8
90	PLW04	LOCK WASHER 3/8
91	PN08	HEX NUT 3/8-16

REF	PART #	DESCRIPTION
92	P0637092	CYCLONE MOUNTING BRACKET
93	PB24	HEX BOLT 3/8-16 X 1-1/4
94	PW02	FLAT WASHER 3/8
95	PLN01	LOCK NUT 3/8-16
96	P0637096	UPPER STAND BRACE
97V2	P0637097V2	UPPER STAND LEG V2.08.10
98	PB21	HEX BOLT 3/8-16 X 3/4
99	PW02	FLAT WASHER 3/8
100	PLN01	LOCK NUT 3/8-16
101	PB21	HEX BOLT 3/8-16 X 3/4
102	PW02	FLAT WASHER 3/8
103	PLN01	LOCK NUT 3/8-16
104	P0637104	LOWER STAND BRACE
105V2	P0637105V2	LOWER STAND LEG V2.08.10
106	PB21	HEX BOLT 3/8-16 X 3/4
107	PW02	FLAT WASHER 3/8
108	PLN01	LOCK NUT 3/8-16
109	PB21	HEX BOLT 3/8-16 X 3/4
110	PW02	FLAT WASHER 3/8
111	PLN01	LOCK NUT 3/8-16
112	P0637112	CONTROL BOX BRACKET
113	PB21	HEX BOLT 3/8-16 X 3/4
114	PW02	FLAT WASHER 3/8
115	PN08	HEX NUT 3/8-16
116	PS06	PHLP HD SCR 10-24 X 3/8
117	PW03	FLAT WASHER #10
118	PN07	HEX NUT 10-24
135	PTLW04	EXT TOOTH WASHER 1/2
136	P0637023	FOAM TAPE 3 X 15 X 700MM
137	P0637137	DRUM LID HOOK
138	P0637138	HOOK RIVET
139	P0637139	VACUUM HOSE 1-1/4" X 79"
140	P0440086	COLLECTION DRUM VACUUM PORT
141	PW07	FLAT WASHER 5/16
142	PB07	HEX BOLT 5/16-18 X 3/4
143	P0440089	HOSE CLAMP 1-1/4"
144	P0440083	PORT PLUG 1-1/4"
145	P0440084	FOAM TAPE 3 X 6 X 300MM
146	P0442121	VACUUM HOSE CLIP 2-1/2"
147	P0637147	PORT PLUG 2"
148	P0637148	HOSE CLAMP 2"
149	P0637149	VACUUM HOSE 2" X 39"
150	P0637150	VACUUM MANIFOLD
153	P0637153	CYCLONE VACUUM PORT
154	P0440084	FOAM TAPE 3 X 6 X 300MM
155	PB07	HEX BOLT 5/16-18 X 3/4
156	PW07	FLAT WASHER 5/16
157	P0440092	COLLECTION DRUM VACUUM RING



Machine Labels



REF	PART #	DESCRIPTION
120	P0637120	MACHINE ID LABEL (G0637)
120	P0638120	MACHINE ID LABEL (G0638)
121	P0637121	GENERAL WARNING LABEL
122	P0637122	RED HANDLE NOTICE LABEL
123	PLABEL-14	ELECTRICITY LABEL
124	PLABEL-53	DISCONNECT POWER LABEL
125	PLABEL-12	READ MANUAL LABEL
126	PLABEL-59	HANDS/OUTLET LABEL
127	PLABEL-57	EYE/LUNG LABEL

REF	PART #	DESCRIPTION
128	PLABEL-15	EAR PROTECTION LABEL
129	P0637129	MODEL NUMBER LABEL (G0637)
129	P0638129	MODEL NUMBER LABEL (G0638)
130	P0637130	HORSEPOWER LABEL (G0637)
130	P0638130	HORSEPOWER LABEL (G0638)
131	P0637131	CONTROL PANEL LABEL
132	P0637132	REMOTE CONTROL LABEL
133	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
134	PPAINT-11	GRIZZLY PUTTY TOUCH-UP PAINT

WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

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

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

3. What is your annual household income?

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

4. What is your age group?

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

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

0-2 Years 2-8 Years 8-20 Years 20+ Years

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

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

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

Note: We never use names more than 3 times. Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place Stamp Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND 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.

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

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

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

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

grizzly.com[®]

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