IMPORTS, INC.

DRILL PRESS

MODEL G1199/G1200

INSTRUCTION MANUAL

REVISED JUNE, 1996 PRINTED IN USA

DISCONTINUED MACHINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE LAST CONFIGURATION OF THE MACHINE BEFORE IT WAS DISCONTINUED. MACHINE CONFIGURATIONS MAY HAVE CHANGED AS PRODUCT IMPROVEMENTS WERE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE . CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

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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SECTION 1: INTRODUCTION

Grizzly Imports, Inc. is proud to offer the Model G1199/G1200 Drill Press. This drill press is a part of Grizzly's growing family of fine woodworking and metalworking machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation.

The Model G1199/G1200 is intended for home and medium-duty professional use. This drill press features a 1,725 R.P.M., ½ H.P. capacitor-start motor, mechanical ON/OFF switch and a cast iron working table.

All running parts utilize shielded ball bearings, which require no lubrication for the life of the bearings.

We are also pleased to provide this manual with the Model G1199/G1200. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible. If you have any criticisms that you feel we should pay attention to in our next printing, please write to us at the Bellingham, WA address at the end of this section.

Most importantly, we stand behind our machines. We have two excellent regional service departments at your disposal should the need arise. If you have any service questions or parts requests, please call or write to us at the appropriate location listed below.

If you live East of the Mississippi, contact:

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone:(570) 546-9663
Fax:(800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: http://www.grizzly.com

If you live West of the Mississippi, contact:

Grizzly Industrial, Inc.
P.O. Box 2069
Bellingham, WA 98227
Phone: (360) 647-0801
Fax: (800) 225-0021
E-Mail: Grizzlytec@aol.com

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your Model G1199/G1200 will be time well spent. **DO NOT** operate this machine until you are completely familiar with the contents of this manual.

Safety Rules For All Tools

1. **KNOW YOUR POWER TOOL.** Read the owner's manual carefully. Learn the tool's applications and limitations, as well as its particular hazards.

2. **KEEP ALL GUARDS IN PLACE** and in working order.

3. **GROUND ALL TOOLS.** If an adapter is used to accommodate a two-prong receptacle, the adapter plug must be attached to a known ground. Never remove the grounding prong.

4. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make it a habit to check that keys and wrenches are removed from the machine before turning it on.

5. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.

6. **AVOID DANGEROUS ENVIRONMENTS.** Do not use power tools in damp or wet locations or expose them to rain. Keep your work area well lighted.

7. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept a safe distance away from your work area.

8. **MAKE WORKSHOP CHILD-PROOF** with padlocks, master switches, or by removable starter keys.

9. **DO NOT FORCE TOOL.** Tools work better and safer when they are allowed to perform at their own speed.

10. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, or jewelry that can get caught in moving parts. Non-slip footwear must be worn. Long hair should be tied back or wear a hat.

11. **NEVER STAND ON, OR LEAN ON THE TOOL.** Doing so could cause injury.

12. **USE SAFETY GLASSES AND EAR PROTECTION.** Also use a **DUST MASK** if the operation is dusty.

13. **DO NOT OVERREACH.** Keep proper footing and balance at all times.

14. **MAINTAIN TOOLS IN TOP CONDITION.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

15. **DISCONNECT TOOLS FROM POWER** before servicing and when changing accessories.

16. **AVOID ACCIDENTAL STARTING.** Make sure the switch is in the "OFF" position before plugging in the cord.

17. **CHECK DAMAGED PARTS.** Do not operate the machine until you are certain it is in perfect running condition.

18. **NEVER LEAVE THE TOOL RUNNING UNATTENDED - TURN POWER OFF.** Do not leave the tool until it comes to a full stop.

19. **DO NOT OPERATE THE TOOL IF USING DRUGS, ALCOHOL, OR MEDICATION.**

20. **DO NOT WORK IN HASTE** or operate machine if you are fatigued.

21. **IF THERE IS SOMETHING YOU DO NOT KNOW OR UNDERSTAND ABOUT THIS TOOL, DO NOT OPERATE IT!** Ask for help first. Confusion can lead to disaster.

22. **BAD HABITS ARE DANGEROUS.** Review all safety procedures often.

These safety rules cannot cover every situation in a woodshop. Consider your conditions when setting up or operating your drill press.

Unpacking

The Model G1199/G1200 Drill press is shipped from the manufacturer in a carefully packed carton. If you discover the machine is damaged after you've signed for delivery, *please call Customer Service immediately 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.*

Caution: The G1199/G1200 is a heavy machine (G1199-140 lbs. shipping weight; G1200-150 lbs. shipping weight). **DO NOT** over-exert yourself while unpacking or moving your machine – get assistance. In the event that your drill press must be moved up or down a flight of stairs, be sure that the stairs are capable of supporting the combined weight of people and the machine.

When you are completely satisfied with the condition of your shipment, you should inventory its parts.

Piece Inventory

After all the parts have been removed from the carton, you should have:

- Working Table
- Column
- Base
- Head Stock Assembly
- Drill Chuck and Arbor
- Crank Handle
- Column Lock Handle
- Handle Bar (3)
- Hex Bolt M10 - 1.5 x 40mm (4)
- Wedge Shifter
- Chuck Key
- 3 & 4mm Allen Wrenches

In the event that any non proprietary parts are missing (e.g. a nut or a washer...), we would be glad to replace them, or, for the sake of expediency, replacements can be obtained at your local hardware store.

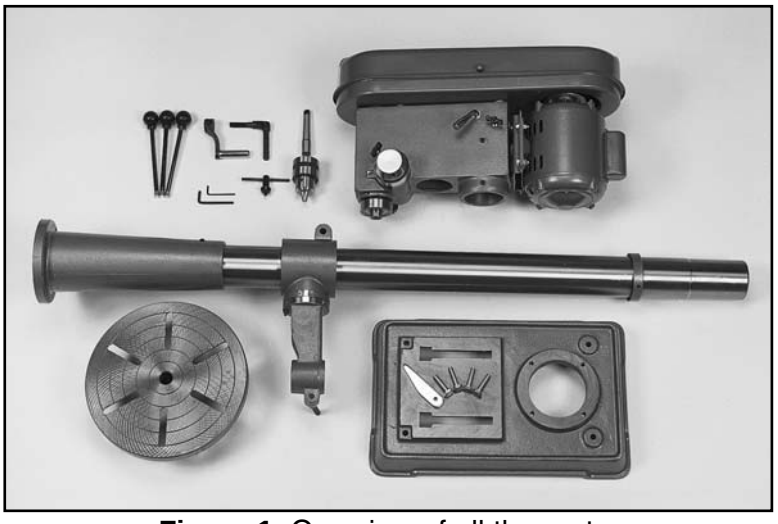


Figure 1. Overview of all the parts.

Clean up

The column and other unpainted parts of the Model G1199/G1200 are coated with a waxy oil that protects them from corrosion during shipment. Remove the protective coating with mineral spirits and paper towels. Do not use gasoline or other petroleum based solvents because of their extremely low flash points. Do not use chlorine-based solvents – if you happen to splash some onto a painted surface, you'll ruin the finish.

WARNING!

Follow the safety rules listed below when working with solvents:

1. Read and follow all directions and warnings on the solvent label.
2. Work only in a well ventilated area.
3. Do not work near any type of open flame (e.g., pilot lights, kerosene heaters, and so on).
4. **DO NOT** smoke while working with flammable material.
5. Paper towels from the cleaning process are extremely combustible. Dispose of waste towels so they do not create a fire hazard.

Site Considerations

1. **Floor Load:** Your G1199/G1200 Drill press represents a large weight load in a small footprint. Most commercial floors are suitable for the Model G1199/G1200. Some residential floors may require additional build up to support both machine and operator.
2. **Working Clearances:** Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a home for your drill press. Allow sufficient room to safely run your machines in any foreseeable operation.
3. **Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.

Circuit Requirements

The motor supplied with the G1199/G1200 is a 110V single-voltage motor, prewired for 110V. Under normal use, the motor draws approximately 9 amps @ 110V. We recommend using a 15 amp circuit breaker or a 15 amp slow blow fuse for 110V operation. This should be satisfactory for normal use, while preventing motor damage from high heat caused by overload. If frequent circuit failures occur when using the drill press, contact our service department or your local electrical contractor. The Drill press cannot be wired for 220V operation.

This equipment must be grounded. Please ensure that the drill press is continuously grounded from the motor to the machine frame and then to a known ground. Verify that any existing electrical outlet and circuit you intend to plug into is actually grounded. If it is not, it will be necessary to run a separate 12 A.W.G. copper grounding wire from the outlet to a known ground. Under no circumstances should the grounding pin from any three-pronged plug be removed.

Extension Cords: If used, extension cords must be rated Hard Service (grade S) or better. Conductor size must be 14 A.W.G. for cords up to 50 feet in length. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Light: Your Drill Press is equipped with a built-in 110/120V lamp socket located between the spindle and the column. Maximum bulb wattage is 60 watts. Always unplug machine before changing bulb.

CAUTION: Be sure that your particular electrical configuration complies with local and state codes. The best way to ensure compliance is to check with your local municipality or licensed electrician.

SECTION 2: ASSEMBLY

Beginning Assembly

Most of the Drill Press has been pre-assembled at the factory. The few remaining pieces should go together quickly and easily. Assembly is straight forward and with just a few tools you can do the entire job quickly and easily. This manual is written for the G1199/G1200 model. The only difference between the two regarding assembly is the length of the column.

CAUTION: All die-cut metal parts have a sharp edge (called "flashing") on them after they are formed. This is removed at the factory. Sometimes though, a bit of flashing might escape inspection. Please examine the edges of all die-cut metal parts before handling them.

Tools Required: Only a few common tools are needed to assemble this machine. Specifically, a 14mm open end wrench, Phillips screwdriver and 3mm and 4mm Allen wrench.

Base/Column

1. Place the base on the floor (if G1200) or on a suitable bench (if G1199). In either case, be sure the surface is flat and stable.

2. Place the column onto the base, line up the four holes and secure tightly with the four M10-1.5 x 40mm Hex Head Bolts provided. **Figure 2.**

Figure 2. Base to column.

3. Insert the worm pinion inside the table bracket and attach the crank handle by tightening the setscrew. **Figure 3.**

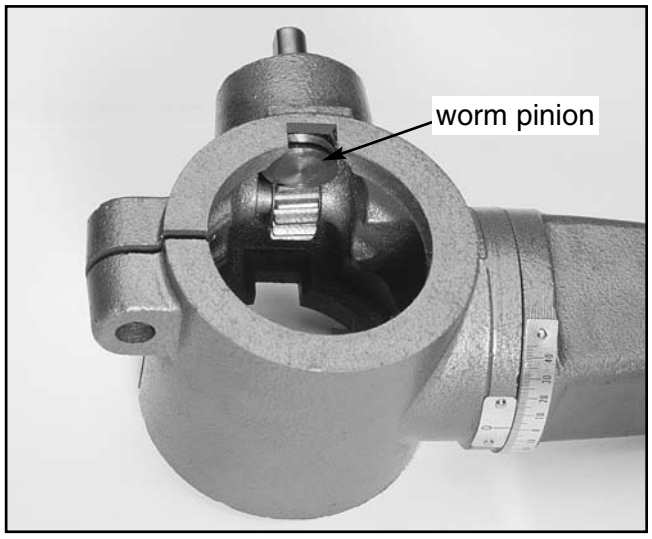


Figure 3. Worm pinion installed.

4. The rack has a section on each end with no teeth. The end with the larger blank section is the top. Place the rack in the slot in the table bracket with the top facing up. Position it so the teeth mesh with the worm pinion. While holding it in that position, slide the table bracket and rack down the column until the bottom of the rack meets the base of the column. **Figure 4.** The bevel in the rack should fit into the bevel in the top of the base.

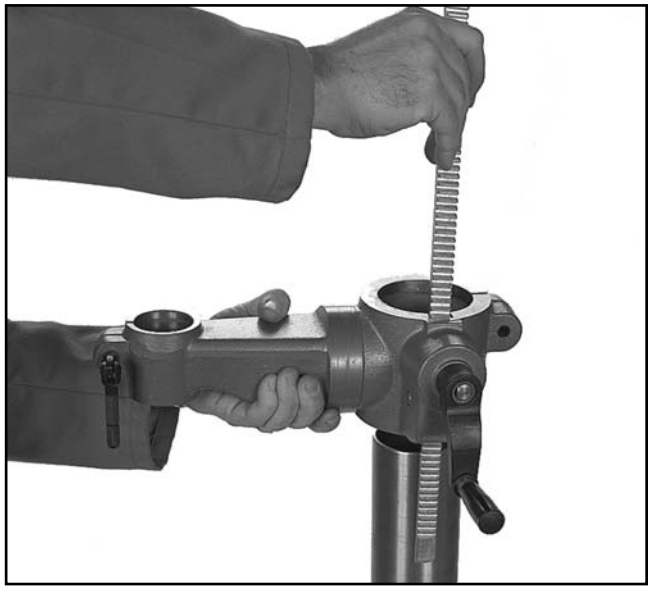


Figure 4.

5. Slide the rack ring down the column until it fits over the beveled section at the top of the rack. Tighten the setscrew in the rack ring leaving enough slack between the rack and the rack ring to allow the rack to move freely around the column. **Figure 5. Do not over-tighten or you may crack the rack ring casting.**

6. Place the head assembly onto the top of the column and lower it until it sits on the shoulder machined into the top of the column. **CAUTION:** The head assembly is quite heavy; get assistance when lifting.

7. Secure the head to the column by tightening the 5mm setscrews **Figure 5.**

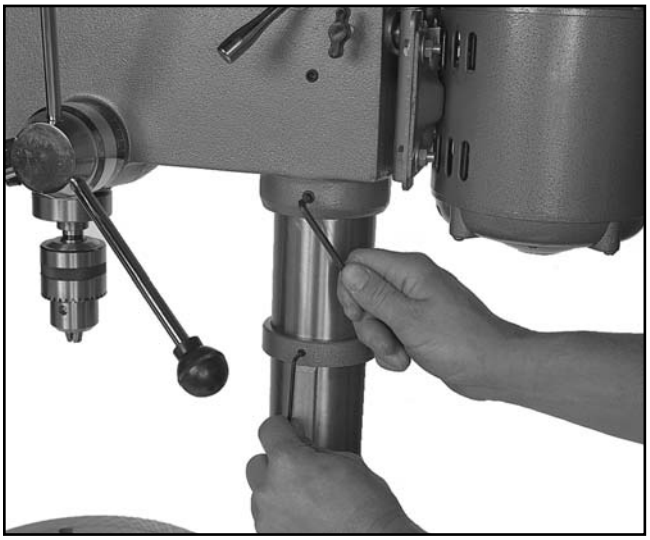


Figure 5.

Table

1. Place the table into the hole in the table bracket and secure with the handle. **Figure 6.**

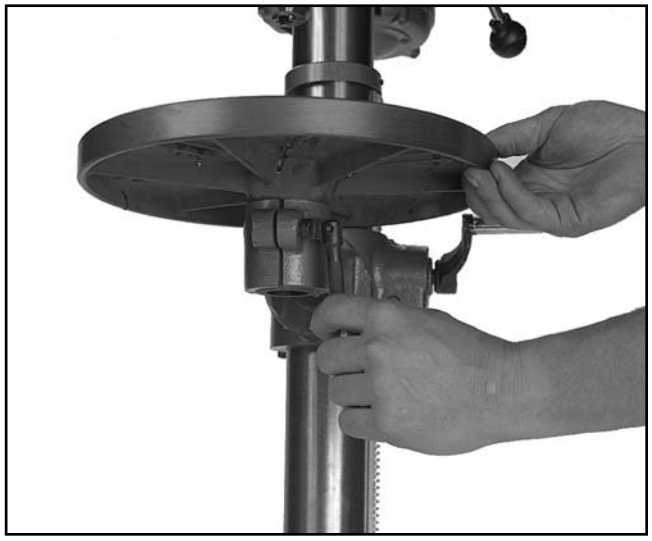


Figure 6. Installing the table.

2. Turn the crank handle to be sure the worm pinion engages the teeth on the rack and moves the bracket up and down. **Figure 7. CAUTION:** Never use the drill press with either table lock loose.

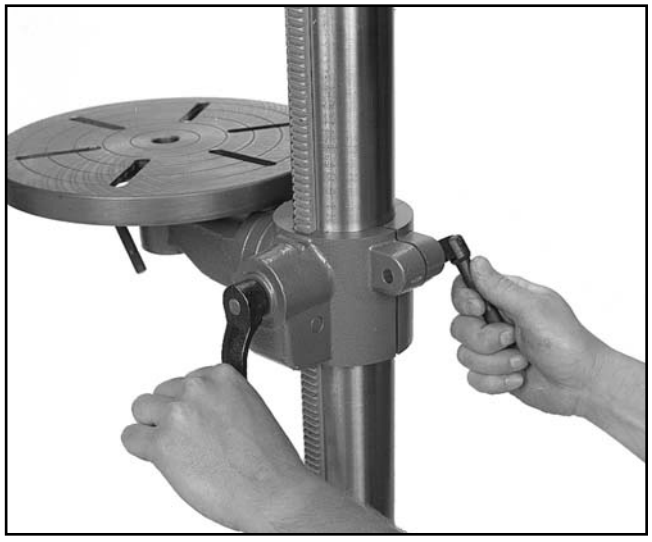


Figure 7.

HANDLES

Screw the three handle bars into the tapped holes in the handle body. **Figure 8.**

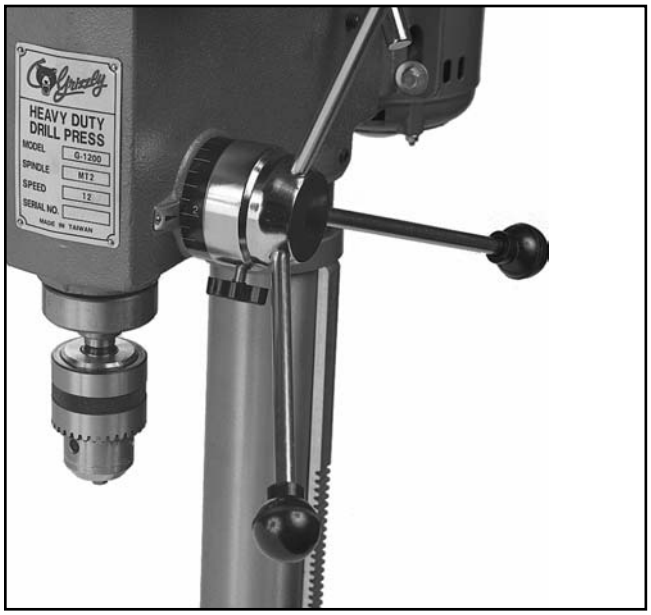


Figure 8. Handles installed.

Drill Chuck

The Drill Press chuck and arbor must be mounted in the drill press spindle. The arbor has a #6 Jacobs Taper on one end and a #2 Morse Taper on the other. The #6 Jacobs Taper fits into the drill chuck and the #2 Morse Taper fits in the drill press spindle. The arbor, drill chuck and drill press spindle fit together by friction fit. To mount the drill chuck on the drill press:

Figure 9. Drill chuck assembly.

1. Thoroughly clean all of the shipping oil or cosmolene from both ends of the arbor, inside the drill chuck and the drill press spindle. Use mineral spirits and a rag.

2. Slide the arbor into the drill chuck and tap lightly with a soft hammer or block of wood.

3. Slide the arbor and chuck into the drill press spindle and turn it until the tang slips into the slot in the spindle.

4. While holding onto the drill chuck, tap lightly on the bottom of the chuck with a soft hammer or a block of wood. The drill chuck should now be quite snug in the drill press. If not, repeat steps 1-3, making sure all oil or cosmolene is removed.

SECTION 3: ADJUSTMENTS

Speed Change

Remember to disconnect the drill press from the power source before attempting any adjustments.

1. To change speed, loosen the two lock knobs, one on either side of the head. **Figure 10.**

2. Turn the cam lever so the motor pulley moves toward the center pulley. **Figure 10.**

3. Select the proper speed by referring to the chart inside the pulley cover. Move the belts into the corresponding position for the selected speed. **Figure 11.**

4. Rotate the cam lever so the motor pulley moves away from the center pulley and tightens the belt.

5. While holding tension on the cam lever, tighten the locking screws on both sides of the head.

6. Close the cover. **CAUTION:** Never run the drill press with the cover open.

NOTE: The speed chart under the pulley cover reflects two different power cycles for the motor. Use the 60 cycles per second spindle R.P.M. reference in the U.S.A.

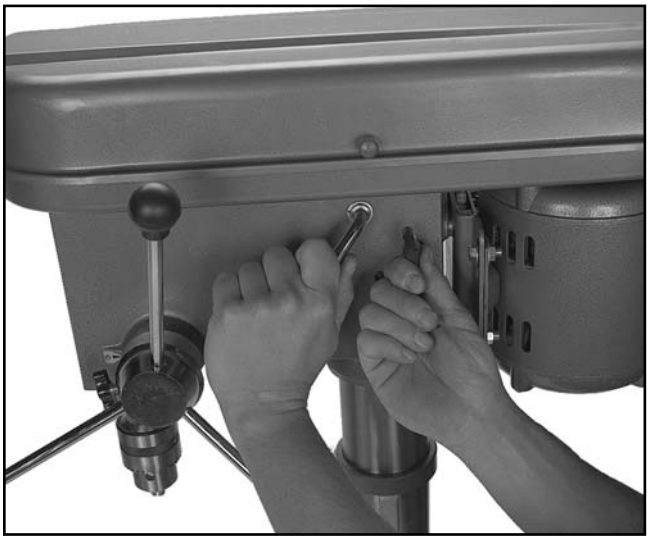


Figure 10.

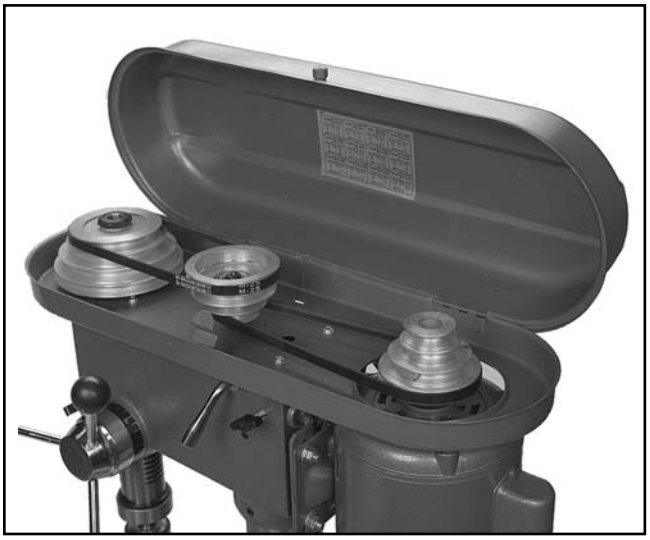


Figure 11.

Spindle Adjustments

To stop the vertical travel of the drill bit at a desired depth, loosen the scale set knob located on the feed shaft assembly, rotate the handles to the desired depth and tighten the scale set knob. **Figure 12.**

To hold a stationary depth, loosen the scale set knob and rotate the feed shaft to its lowest point. Then, rotate spindle depth to the desired depth and tighten the scale set knob. This will lock the spindle at the desired depth.

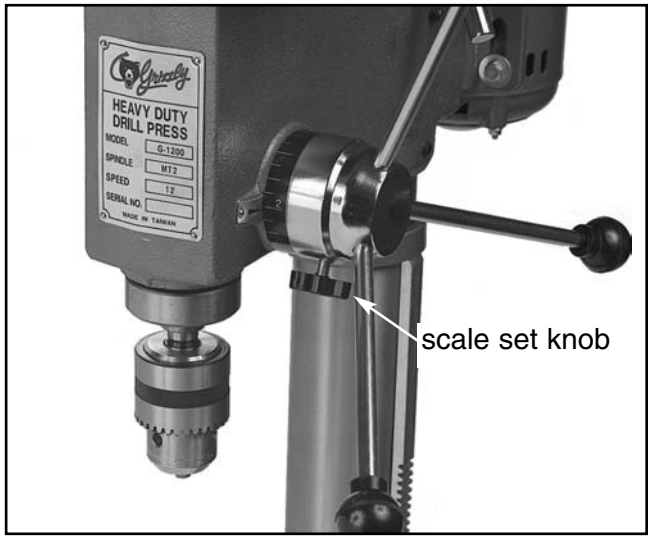


Figure 12.

Table Adjustments

1. To adjust the table up or down, loosen the column lock handle and turn the crank handle to the desired height. Re-tighten the column lock handle. **Figure 13.**

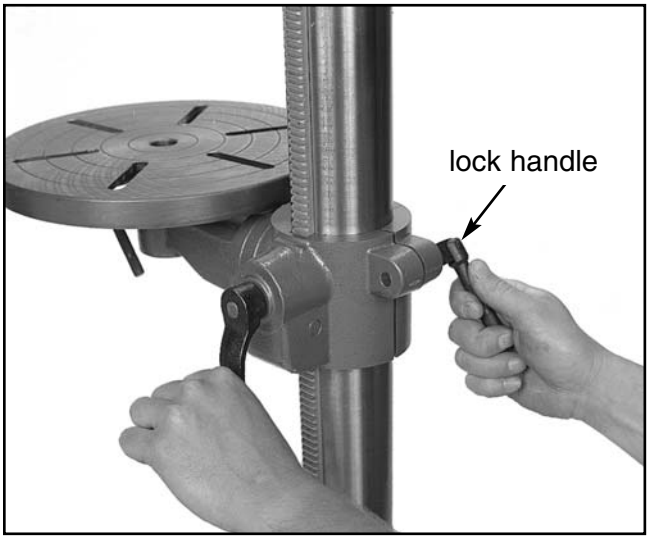


Figure 13.

2. To swing the table, loosen the column lock handle and swing the table to the desired position. Re-tighten the column lock handle. For long workpieces, swing the work table away 180° and use the base as your table. **Figure 13.**

3. To rotate the table, loosen the table lock handle, rotate the table to the desired position and re-tighten the table lock handle. **Figure 14.**

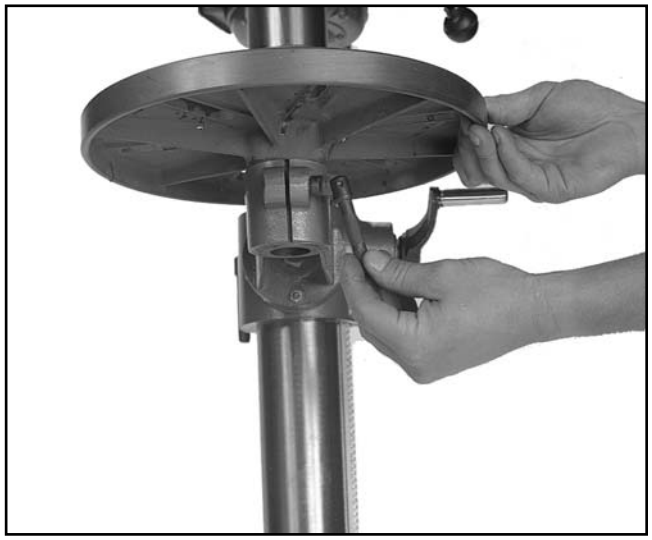


Figure 14.

4. To tilt the table, loosen the pivot bolt and remove the locator pin (**Figure 15**). This is done by tightening the nut until the pin is extracted from its hole. Tilt the table to the desired angle (up to 45°) and re-tighten the pivot bolt. Re-insert the locator pin when returning the table to zero degrees.

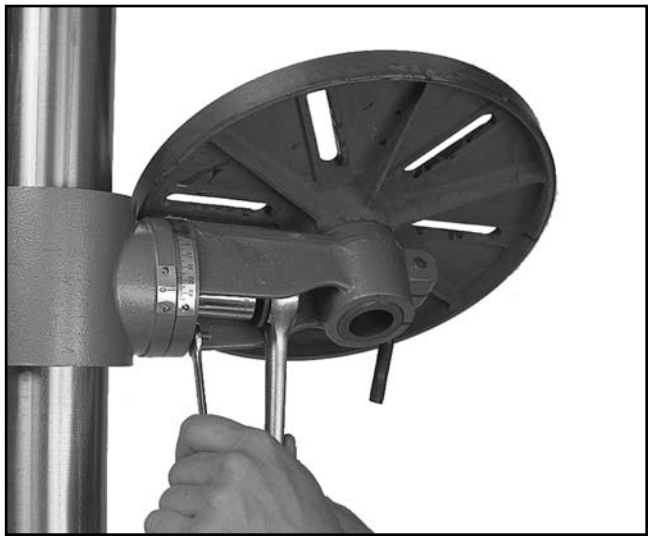


Figure 15.

Chuck Removal

1. Adjust the stationary depth to three inches (see depth setting instructions).

2. Rotate the spindle manually and line up the internal spindle slot with the slot on the side of the quill. The end of the drill chuck (the tang) should be visible through the slot at this point.

3. Insert the wedge shifter through the slot in the spindle with the tapered edge facing down. **Figure 16.**

4. When the tapered edge of the wedge shifter contacts the top of the taper, tap the wedge shifter lightly with a hammer until the taper and chuck are loose. Do not allow the taper and chuck to fall onto the table.

Figure 16. Removing the chuck.

SECTION 4: OPERATIONS

Safety Rules

Now that your drill press is assembled and in place, you are ready to begin using it. Your new drill press is a simple piece of equipment to set up and operate. It is a versatile tool that can be used to perform many different operations such as: Drilling, Boring, Sanding, Mortising and Shaping.

For your own protection, please read and follow these safety precautions.

- While operating this machine, do not wear jewelry, loose clothing, necklaces or neckties. Long sleeves on shirts should be rolled up or securely buttoned at the cuff.
- Persons with beards and/or long hair should consider the use of a hat, hair net or similar protective equipment.
- Always use face/eye protection when operating the drill press. A full face shield will afford the best protection followed by safety glasses with side shields.
- All adjustments or maintenance should be done with the power off and the drill press unplugged.
- Never use tools that are in poor condition. Cutting tools that are dull or damaged are difficult to control and may cause serious injury.
- Thoroughly clean the machine and surrounding area after use.
- Feed the drill bit evenly into the workpiece. Back the bit out of deep cuts to cool and clean the bit.
- If you have questions about your drill press, ask a professional or an experienced user.
- Never attempt to clean wood or metal cuttings from drill bits while the drill press is running.
- The workpiece must be held securely in place using a drill press vise or clamp.
- Never use a bit with a tapered shank or square bit in a drill chuck.
- Use the correct speed for the size of bit and material being drilled.
- Always remove the key from the chuck before starting drill press.
- Remove metal cuttings with a brush, never by hand.
- Perform machine inspection and maintenance service routinely.
- Never drill sheet metal unless it is securely clamped to the table.
- Work should be secured in such a way so as to avoid drilling into the table.
- When changing speeds, always disconnect the machine from the power source.

This sums up our review of safety guidelines. Remember that every shop has its own specific hazards. Be sure, above all else, to use good common sense and reasonable caution each time you start this drill press, or any woodworking machinery. Proper safety standards rarely take any more time or energy when followed religiously. Develop a habit of safety.

Caution

Always wear ANSI-approved safety glasses or goggles when operating equipment — particularly when testing new tools or machinery. Do not allow visitors into your workshop when testing or operating equipment.

Test Run

Once the assembly is complete and the adjustments are done to your satisfaction, you are ready to test the machine.

Turn on the power supply at the main panel. Press the START button. Make sure that your finger is poised on the STOP button, just in case there's a problem. The drill press should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further.

WARNING: *DO NOT attempt to investigate or adjust the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a rest before you do anything!*

If noises occur that can not be found by visual inspection, feel free to contact our service department for help.

Drill Changes

To insert or change a bit, care must be taken to secure the bit firmly in place. When changing bits, proceed as follows:

1. Disconnect the machine from the power source.
2. Open the chuck wide enough to accept a new bit.
3. Install the bit so the chuck jaws will grab the major portion of the bit shank. Do not allow the chuck to grab the fluted body of the drill bit.
4. Tighten the chuck with the chuck key using all three key locations.
5. Remove the chuck key and reconnect to the power source.
6. Reverse steps to remove drill bit.

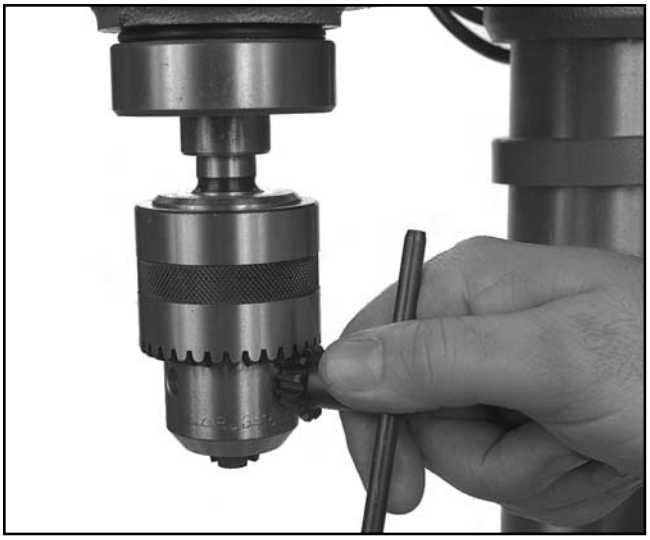


Figure 17.

Drill Speed

The best speed to use in any drill press operation is determined by; material, size of drill bit, type of drill bit or cutter and quality of cut desired. The smaller the drill bit, the greater the speed. In soft materials, the speed should be higher than for hard materials. Refer to the chart on **Page 25.**

Drilling Metal

When drilling metal, use clamps to hold the workpiece securely in place. The workpiece should never be held in place by bare hands. The cutting edge can catch in the material at any time, resulting in serious injury. Any movement of the workpiece during the drilling operation may result in a rough or misplaced hole and increase the chance of drill bit breakage.

For flat work, lay the workpiece on a wooden base and clamp it firmly to the table. Use a V-block and clamp for round stock. A drill press vise with prismatic jaws can also be used to hold flat or round material.

Drilling Wood

Twist bits, which are intended for metal, may also be used for boring holes in wood. Machine spur bits are generally preferred, they cut a square bottomed hole and are designed for removal of wood chips. Do not use hand bits which have a screw tip; at drill press speeds they turn into the wood too fast and tend to lift the workpiece off the table and spin it.

For through boring, line up the hole in the work table with the bit to avoid damaging its tip. Scribe a vertical line on the column and a matching line on the table bracket so the table can be clamped in the center position at any height. Use a piece of scrap wood under your workpiece and feed the bit into the wood slowly to prevent splintering the bottom side of the workpiece.

When using your drill press for operations such as shaping, sanding or mortising, use jigs, fixtures or hold-downs that are appropriate. For more information, review reference materials pertaining to your specific application.

The chuck will accept any tool with up to a ⅝" shank. Do not attempt to open the chuck wider by forcing it.

Mortise Attachment

The optional Grizzly G1083 Mortise Attachment was specifically designed to fit the G1199/G1200 Drill Presses. Refer to our current catalog for ordering information.

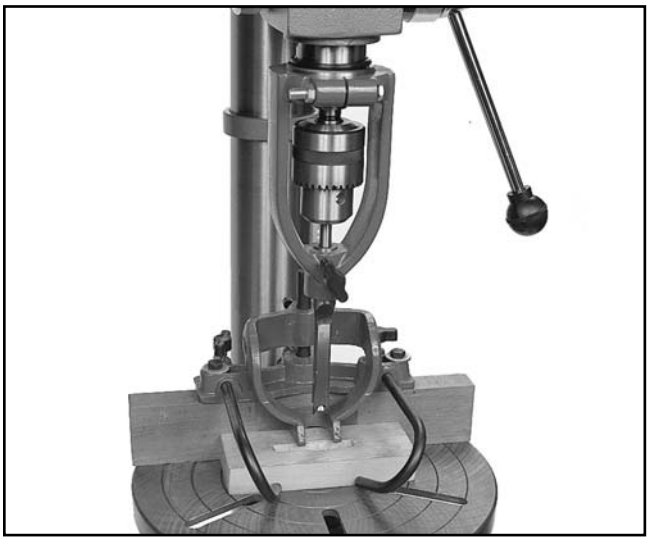


Figure 18. Mortise Attachment installed.

SECTION 5: MAINTENANCE

General

Make a habit of inspecting your drill press each time you use it. Check for the following conditions and repair or replace when necessary.

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Damaged V-belt.
5. Any other condition that could hamper the safe operation of this machine.

Belt Tension

Proper belt tension is achieved by tightening the belt adjusting cam so the belt has a slight tension on it. Excessive tension will create heat and shorten belt life. Too little tension will cause the belt to slip and squeal.

Lubrication

Shielded and pre-lubricated ball bearings require no lubrication for the life of the bearings. In a continuous-use environment, expect the bearings to last for several years. With intermittent use, bearings can be expected to last much longer. All bearings are standard sizes and can be easily replaced.

For other items on this machine, such as the quill, table and column, an occasional shot of light machine oil is all that is necessary. Before applying lubricant, clean off sawdust and metal chips. Use a light grease on the rack, both on the teeth and between the rack and column.

Your goal is to achieve adequate lubrication. Too much lubricant will attract dirt and sawdust and clog the drill press mechanism.

SECTION 6: CLOSURE

The following pages contain parts diagram, parts list, general machine data, trouble shooting guide and Warranty/Return information for your Model G1199/G1200 Drill Press.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call the appropriate regional Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the Introduction. The specifications, drawings, and photographs illustrated in this manual represent the Model G1199/G1200 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation.*

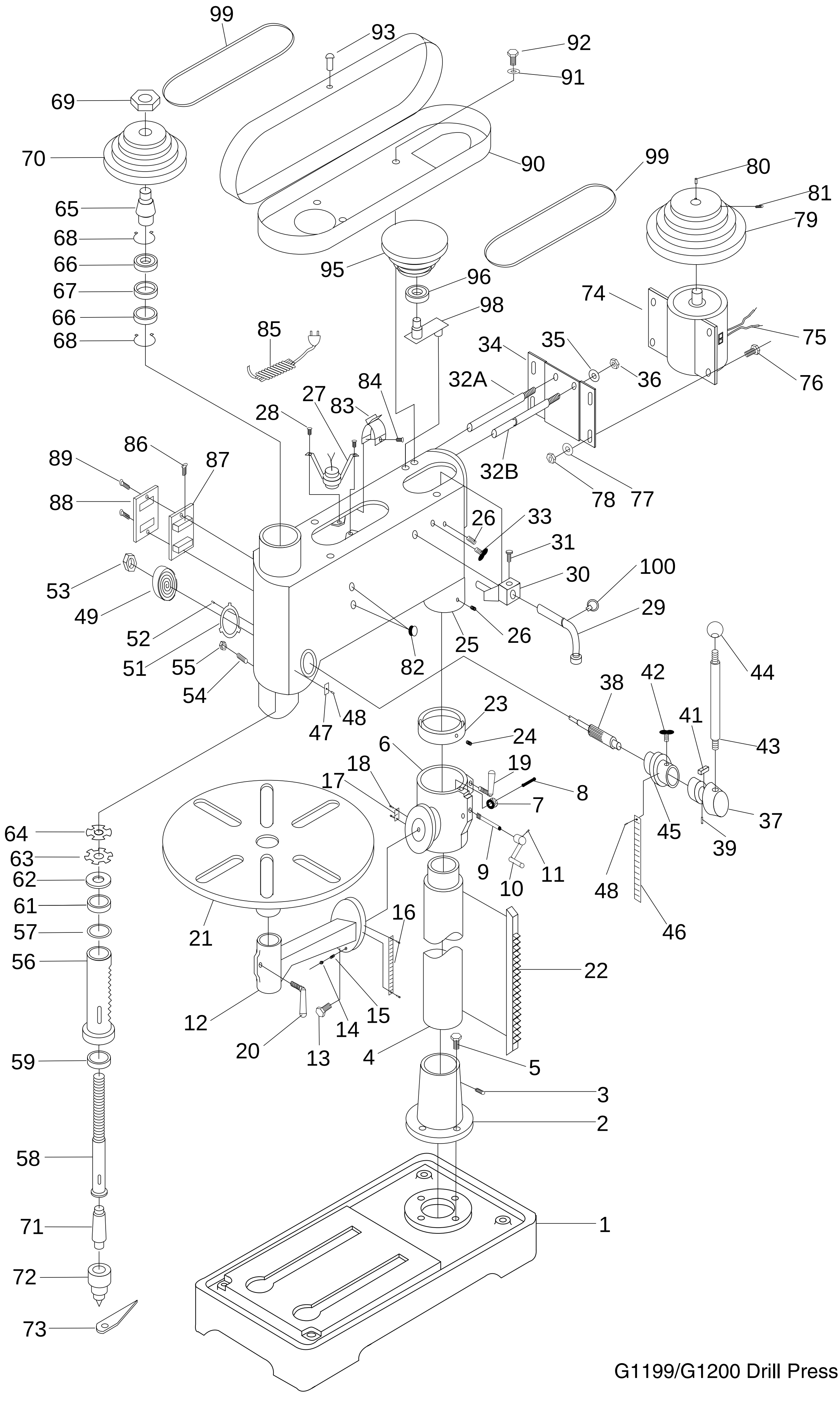
We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the appropriate regional Service Department listed in the introduction.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.

WARNING!

Like all power tools, there is danger associated with the Model G1199/G1200 Drill press. Use the tool with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored, injury to the operator or others in the area is likely.

The Model G1199/G1200 was specifically designed for drilling operations. **DO NOT MODIFY AND/OR USE THIS DRILL PRESS FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty.** If you are confused about any aspect of this machine, **DO NOT** use it until you have answered all your questions.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REF	PART #	DESCRIPTION	REF	PART #	DESCRIPTION
1	P1199001	BASE	55	PN02M	HEX NUT M10-1.5
2	P1199002	COLUMN HOLDER	56	P1199056	QUILL
4	P1199004	COLUMN	57	P1199057	RUBBER WASHER
5	PB31M	HEX BOLT M10-1.5 X 40	58	P1199058	SPINDLE SHAFT
6	P1199006	BRACKET	59	P6205	BEARING 6205-2RS
7	P1199007	PINION GEAR	60	P1199060	NAME PLATE
8	P1199008	GEAR SHAFT	61	P6203	BEARING 6203-2RS
9	P1199009	WORM PINION	62	P1199062	SPECIAL WASHER
10	P1199010	CRANK HANDLE	63	P1199063	SPECIAL LOCK NUT
11	PSS01M	SETSCREW M6-1.0 X 10	64	P1199064	SPECIAL NUT
12	P1199012	TABLE BRACKET	65	P1199065	DRIVE SLEEVE
13	P1199013	SPECIAL HEX BOLT	66	P6205	BEARING 6205-2RS
14	P1199014	LOCATOR PIN	67	P1199067	COLLAR
15	PN05	HEX NUT ¼"-20	68	P1199068	SPECIAL SNAP RING
16	P1199016	ANGLE SCALE	69	PN10M	HEX NUT M25-1.5 L.H.
17	P1199017	CENTERING SCALE	70	P1199070	SPINDLE PULLEY
18	P1183108	RIVET	71	G1676	ARBOR
19	P1199019	COLUMN LOCK HANDLE	72	G1650	CHUCK, ⅝"
20	P1199020	TABLE LOCK HANDLE	72A	P1199072A	⅝" CHUCK KEY
21	P1199021	TABLE	73	P1199073	WEDGE SHIFTER
22	P4008022	RACK	74	P1199074	MOTOR
23	P4008023	RACK RING	75	P1199075	MOTOR CORD
24	PSS03M	SET SCREW M6-1.0 X 8	76	PB09M	HEX BOLT M8-1.25 X 20
25	P1199025	HEAD CASTING	77	PW01M	FLAT WASHER 8MM
26	PSS13M	SET SCREW M10-1.5 X 12	78	PN03M	HEX NUT M8-1.25
27	P1199027	LAMP SOCKET	79	P1199079	MOTOR PULLEY
28	PB02M	HEX BOLT M6-1.0 X 12	80	PK24M	KEY 5 X 5 X 37
29	P1199029	CAM HANDLE	81	PSS01M	SET SCREW M6-1.0 X 10
30	P1199030	CAM	82	P1199082	WIRE INSULATOR
31	PB03M	HEX BOLT M8-1.25 X 16	83	P1199083	WIRE CLIP
32A	P1199032A	SLIDE BAR	84	P1199084	CLIP SCREW
32B	P1199032B	CAM SLIDE BAR	85	P1199085	CORD
33	P1199033	LOCK KNOB	86	P1199086	CLIP TERMINAL
34	P1199034	MOTOR BASE	87	P1199087	SWITCH
35	PLW05M	LOCK WASHER 12MM	88	P1199088	SWITCH COVER
36	PN09M	HEX NUT M12-1.75	89	PS08M	SCREW M5-0.8 X 12
37	P1199037	HANDLE BODY	90	P1199090	PULLEY COVER
38	P1199038	FEED SHAFT	91	PW03M	FLAT WASHER
39	PRP24M	ROLL PIN 5 X 16	92	PS11M	SCREW M6-1.0 X 16
41	P1199041	SCALE GUIDE	93	P1199093	COVER KNOB
42	P1199042	SCALE SET HANDLE	95	P1199095	CENTER PULLEY
43	P1199043	HANDLE BAR	96	P6202	BEARING 6205-2RS
44	P1199044	KNOB	98	P1199098	CENTER PULLEY SHAFT
45	P1199045	SPINDLE DEPTH	99	PVM25	V-BELT M-25
46	P1199046	SCALE	100	P1199100	SNAP RING
47	P1199047	CENTERING SCALE		--G1200 UNIQUE PARTS--	
48	P1183108	RIVET	01	P1200001	BASE
49	P1199049	SPRING & HOUSING	03	PSS13M	SET SCREW M10-1.5 X 12
51	P1199051	SPRING SEAT	02	P1200002	COLUMN HOLDER
51A	P1199051A	SPRING SEAT BUSHING	04	P1200004	COLUMN
52	P1199052	SPECIAL SET SCREW	22	P1200022	RACK
53	PN01	HEX NUT ½"-20			
54	P1199054	SPECIAL SET SCREW			

MACHINE DATA

GRIZZLY MODEL G1199 & G1200 DRILL PRESS

Design Type . . . . . .Bench Model/Floor Model

Overall Dimensions

Table Size . . . . . .12" Round
Height . . . . . .40"/60"
Overall Width . . . . . .12"
Overall Depth . . . . . .25"
Shipping Weight . . . . . .160/210 lbs.
Weight in Place . . . . . .150/200 lbs.

Construction

Table . . . . . .Precision Ground Cast Iron
Column . . . . . .Precision Ground Cast Iron
Base & Head . . . . . .Cast Iron

Motor

Type . . . . . .TEFC Capacitor Start Induction
Horsepower . . . . . .½" HP
Phase/Cycle . . . . . .Single Phase/60 Hz
Voltage 110V
Amps 9
RPM . . . . . .1725 RPM
Switch . . . . . .Power/Light
Power Transfer . . . . . .Belt Drive
Bearings . . . . . .Shielded & Permanently Lubricated Ball

Capacities

Spindle Travel . . . . . .3"
Maximum (Spindle to Base) . . . . . .24"/49"
Maximum (Spindle to Table) . . . . . .16"/29"
Spindle Taper . . . . . .MT #2
Chuck Size . . . . . .⅝"
Speeds 12
Range of Speeds . . . . . .250 - 3100 RPM

Features

- Built in light, 110V, 60 watt maximum
- Table tilts 90° left or right, swings 360°
- 4-step pulley, 2-step drive pulley
- Positive table lock
- Worm geared table adjustment

Specifications, while deemed accurate, are subject to change without notice.

TROUBLESHOOTING

WARNING: For your own safety, turn the switch off and disconnect power source before troubleshooting.

Trouble	Probable Cause	Remedy
Noisy operation	1. Incorrect belt tension	1. Adjust tension
	2. Dry spindle	2. Lubricate spindle See lubrication section
	3. Loose spindle pulley or motor pulley	3. Tighten setscrews in pulley
Bit burns or smokes	1. Incorrect speed	1. Select correct speed See speed chart
	2. Chips clogging hole	2. Retract bit frequently to clear chips
	3. Dull bit	3. Sharpen or replace bit
	4. Feeding too slow	4. Increase feed rate
	5. Bit not lubricated	5. Lubricate bit
	6. Bit running backwards	6. Check motor rotation
Excessive drill runout or wobble	1. Bent bit	1. Replace bit
	2. Worn spindle bearings	2. Replace bearings
	3. Bit improperly installed in chuck	3. Install bit properly
	4. Chuck improperly installed	4. Install chuck properly
Drill binds in workpiece	1. Workpiece pinching bit or excessive feed pressure	1. Support or clamp workpiece,reduce feed pressure
	2. Improper belt tension	2. Adjust belt tension
Workpiece torn loose from hand	Workpiece not supported or clamped properly	Support or clamp workpiece

WARRANTY AND RETURNS

Grizzly Imports, 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.

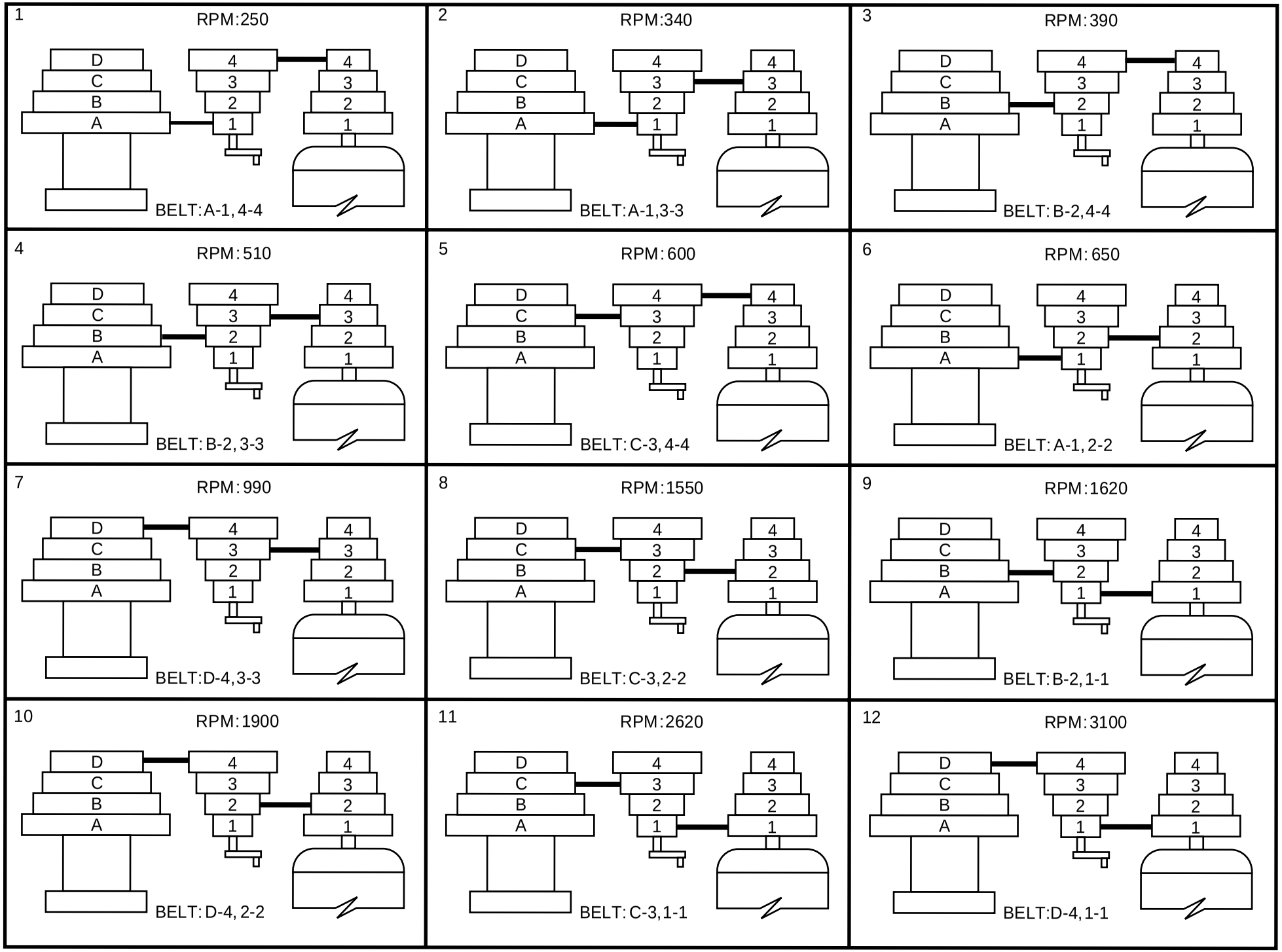
The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

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.

Recommended RPM

Drill Diameter	Cast Iron	Steel	Aluminum	Wood
1/8"	1900	2620	2620	2620
3/16"	1550	1620	2620	2620
1/4"	990	1350	1550	2620
5/16"	650	990	1550	1550
3/8"	600	990	990	1550
7/16"	510	650	990	990
1/2"	510	650	650	990
9/16"	390	600	650	990
5/8"	390	510	510	650
3/4"	340	390	510	350
7/8"	250	340	390	510
1"	—	340	390	510
1 1/8"	—	250	340	390
1 1/4"	—	—	340	390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RPM:2620
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RPM:3100
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