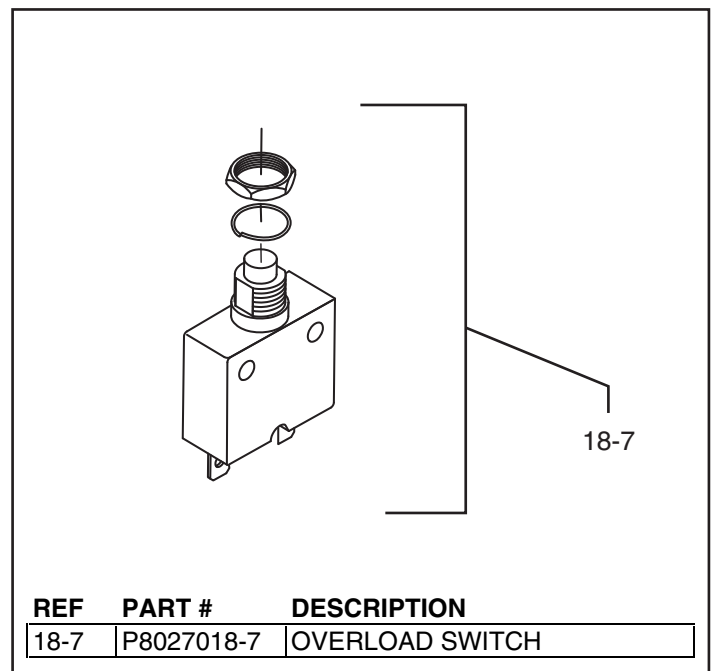
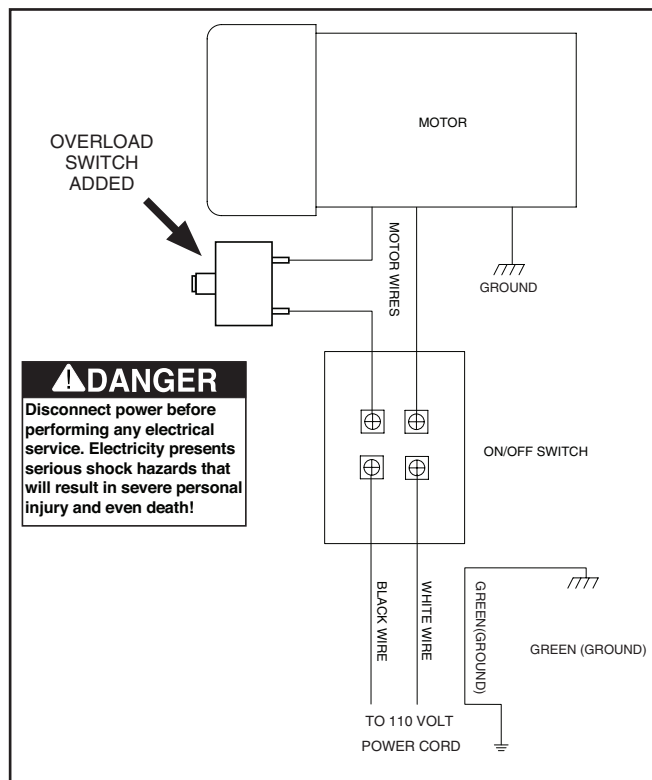




MODEL G8027 1HP DUST COLLECTOR MANUAL INSERT

A push-button overload switch has been mounted on the machine ON/OFF switch box. Except for the difference noted in this insert, all other content in the Model G8027 owner's manual applies to this machine. Before operating your new machine, you **MUST** read and understand this insert and the entire Model G8027 manual to reduce the risk of injury when using this machine.

If you have any further questions about the differences between the owner's manual and this insert, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.



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 (FOR MODELS MANUFACTURED 3/09+) #CR11673 PRINTED IN CHINA

Grizzly **Industrial, Inc.**®

1 HP DUST COLLECTOR MODEL G8027 INSTRUCTION MANUAL



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#BL7091 PRINTED IN CHINA

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.

Table of Contents

INTRODUCTION	2
Foreword	2
Contact Info	2
Machine Data Sheet.....	3
Identification	4
SECTION 1: SAFETY	5
Safety Instructions for Machinery	5
Additional Safety for Dust Collectors	7
SECTION 2: CIRCUIT REQUIREMENTS	8
110V Operation	8
SECTION 3: SET UP	9
Unpacking	9
Items Needed For Set Up	9
Inventory.....	10
Site Considerations	10
Hardware Recognition Chart.....	11
Base and Supports.....	12
Collector Support Bolts	13
Collection and Filtration Bags	14
Collection System.....	15
SECTION 4: OPERATION	17
Operation Safety	17
Test Run.....	17
General.....	17
SECTION 5: ACCESSORIES	18
SECTION 6: MAINTENANCE	20
Schedule	20
Lubrication.....	20
Bag Cleaning.....	21
Troubleshooting.....	22
Electrical Components and Wiring	23
G8027 Parts Breakdown	24
G8027 Parts List	25
WARRANTY AND RETURNS	26

INTRODUCTION

Foreword

We are proud to offer the Model G8027 1 HP Dust Collector. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G8027. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G8027 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

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

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>





MACHINE DATA SHEET

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

MODEL G8027 1 HP DUST COLLECTOR

Design Type Single Stage Floor Model

Overall Dimensions:

Base 15" x 25½"
Height (With Bags Inflated) 63"
Shipping Weight 67 lbs.
Box Size 26¼" L x 16¾" W x 17¾" H

Specifications:

Intake Hole Size 4"
Bag Size (2) 14½" x 23"
Bag Capacity (Replacement Bag G1027) 2 Cubic Feet
Bag Material Fabric/30 Micron
Impeller Size 9"
Suction Capacity 500 CFM
Static Pressure (Inches of Water) 2.76"

Construction:

Base Pre-formed Steel on Casters
Radial Impeller ¾" Steel, Riveted

Motor:

Type TEFC Capacitor-Start Induction
Horsepower 1 HP
Phase / Voltage Single Phase 110V
Prewired 110V
Amps 8A
Cycle / RPM 60 Hertz/3450 RPM
Switch Toggle ON / OFF w/ Safety Lock Tab
Bearings Sealed & Lubricated Ball Bearings

Specifications, while deemed accurate, are not guaranteed.



Identification



Figure 1. Model G8027 Identification.

- | | |
|-------------------------------|-----------------------------|
| 1. Upper Bag Support Rod | 6. Base Plate |
| 2. Filtration Bag | 7. Swivel Casters |
| 3. Collector | 8. Impeller Housing Support |
| 4. Collection Bag | 9. ON/OFF Switch |
| 5. Collection Bag Support Rod | 10. Motor |



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 which are 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

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**



WARNING

Additional Safety for Dust Collectors

- 1. MACHINE USE.** DO NOT use this dust collector to pick up liquids and metal scrap including, but not limited to, nails and filings. Also, DO NOT pick up material which cannot safely pass through the impeller, such as solid wood scraps.
- 2. KEEPING FINGERS SAFE.** DO NOT place your hands or tools near the open inlet during operation for any reason including, but not limited to, unclogging material and testing suction. The impeller could cause serious damage to body parts if touched while spinning.
- 3. SAFE SERVICING.** Disconnect power and allow impeller to come to a complete stop before servicing or working on the dust collector ducting system.
- 4. SUSPENDED DUST PARTICLES AND IGNITION SOURCES.** DO NOT operate the dust collector in areas where explosion risks would be high if dust were dispersed into the area. Areas of high risk include, but are not limited to, areas near pilot lights and/or open flames.
- 5. EMPTYING BAGS.** When emptying dust from the collection bags, wear a respirator and safety glasses. Empty dust into an approved container and dispose of properly.
- 6. AVOIDING FIRES.** DO NOT allow steel to strike against impeller, which may produce a spark. Sparks can smolder in wood dust for a long time before fire or flame is detected. If metal contacts metal during operation, immediately turn off the dust collector, unplug the power cord from the outlet, or flip the disconnect switch and wait for all moving parts to stop. Remove collection bags and empty the dust into an approved air tight metal container in case of spark. Remedy the metal to metal contact problem before resuming operation.
- 7. OPERATIONAL QUESTIONS.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Then contact our Service Department or ask a qualified expert how the operation should be performed.
- 8. 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. Always wear an approved respirator!

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 follow guidelines could result in serious personal injury, damage to equipment or poor work results.

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 an air cleaner. For safest use, wear a respirator and use an air cleaner in addition to the dust collector.



SECTION 2: CIRCUIT REQUIREMENTS

110V Operation

!WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The 1 HP motor on the Model G8027 will draw the following amps:

Motor Draw 8 Amps

Circuit Requirements

Only connect your machine to a circuit that meets the requirements below. Always check to see if the wires and circuit breaker in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

Minimum Circuit Requirement 15 Amp

Plug/Receptacle Type

Included Plug Type NEMA 5-15

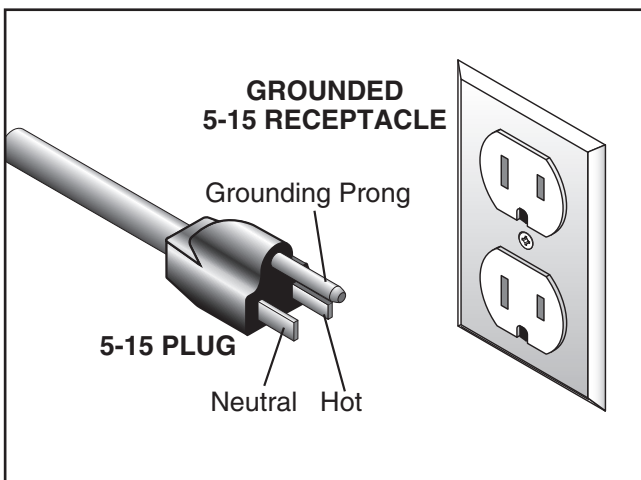

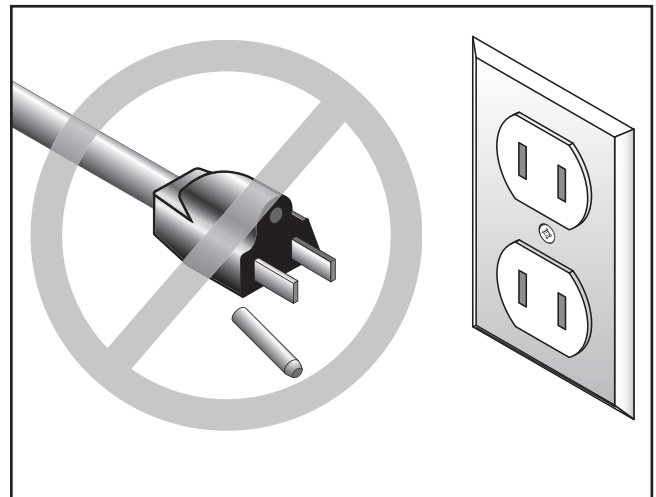


Figure 2. Typical type 5-15 plug and receptacle.



!WARNING
Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!



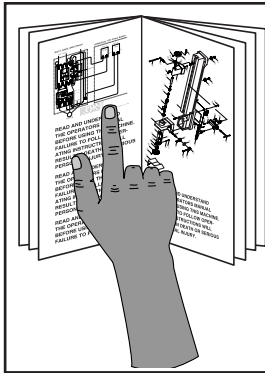
!CAUTION
This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

- Make sure the cord is rated Standard Service (grade S) or better.
- The extension cord must contain a ground wire and plug pin.
- Use at least a 16 gauge cord. Use a 14 gauge cord if the cord is between 51-100 feet.

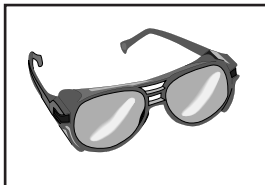


SECTION 3: SET UP



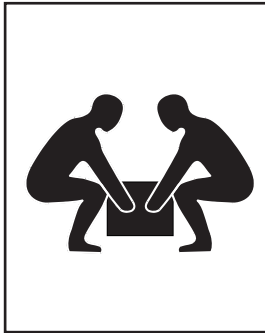
!WARNING

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 set up process!



!WARNING

The Model G8027 weighs approximately 67 lbs. (shipping weight). **DO NOT** over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed For Set Up

Items Needed for Setup	Qty
Wrench or Socket 8mm.....	1
Wrench or Socket 10mm.....	1
Wrench or Socket 13mm.....	2
Phillips Screwdriver #2	1

Unpacking

Your machine left our warehouse in two carefully packed boxes. If you discover the machine is damaged after you have signed for delivery, *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 the shipment, you should inventory the equipment.



Inventory

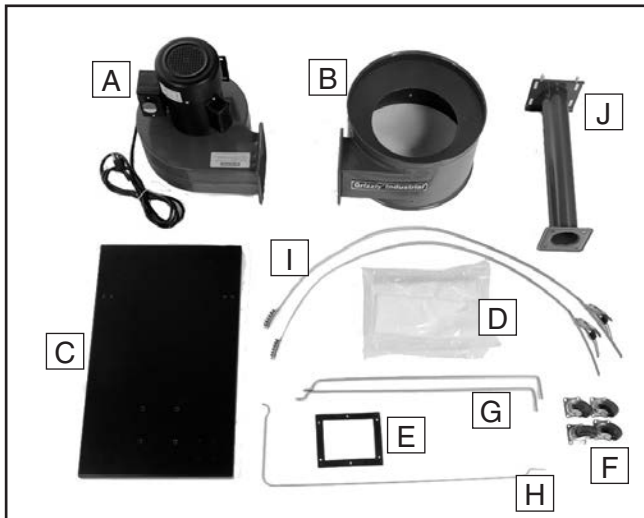


Figure 3. Main box items.

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

Box Components (Figure 3)	Qty
A. Motor/Impeller Housing	1
B. Collector.....	1
C. Base Plate	1
D. Bags.....	2
E. Rubber Gasket	1
F. Swivel Casters.....	4
G. Collection Bag Support Rods	2
H. Upper Bag Support Rod.....	1
I. Bag Clamps.....	2
J. Impeller Housing Support.....	1
K. Hardware and Tools (Not Shown)	
— Hex Bolts M6-1 x 15	6
— Hex Bolts M8-1.25 x 15	8
— Hex Nuts M8-1.25.....	4
— Hex Nut M5-.8	18
— Flat Washers 8mm	12
— Flat Washers 5mm	22
— Phillips Head Screws M5-.8 x 15	6
— Phillips Head Screws M5-.8 x 10	16
— Phillips Head Screws M4-.7 x 8	2
— Hex Wrench 5mm	1
— Hex Wrench 4mm	1

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.

Site Considerations

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 location for the machine. See **Figure 4** for the footprint dimensions of the Model G8027.

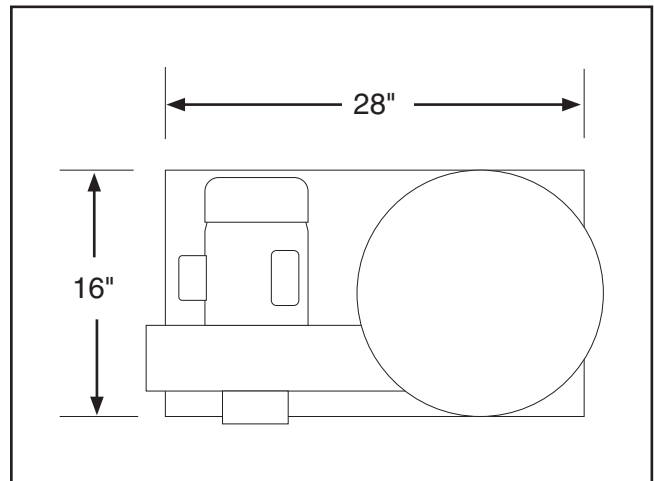


Figure 4. Dust collector footprint.







	<p>⚠ WARNING</p> <p>Unsupervised children and visitors inside your shop could receive serious personal injury. Ensure child and visitor safety by keeping all entrances to the shop locked at all times. DO NOT allow unsupervised children or visitors in the shop at any time.</p>
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







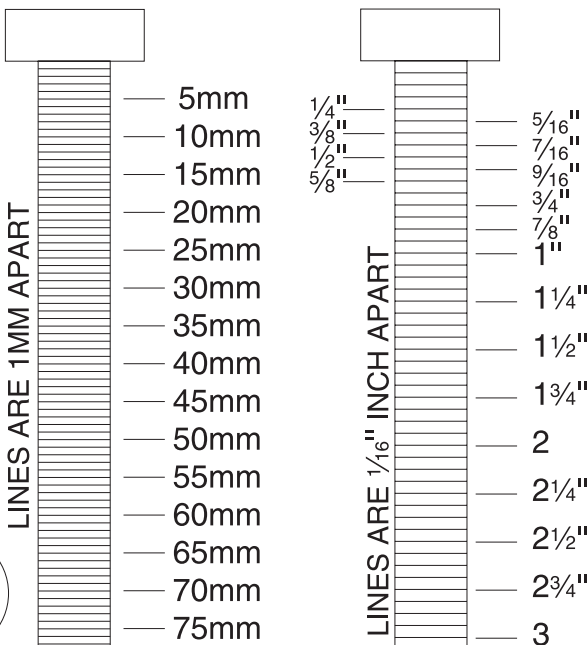
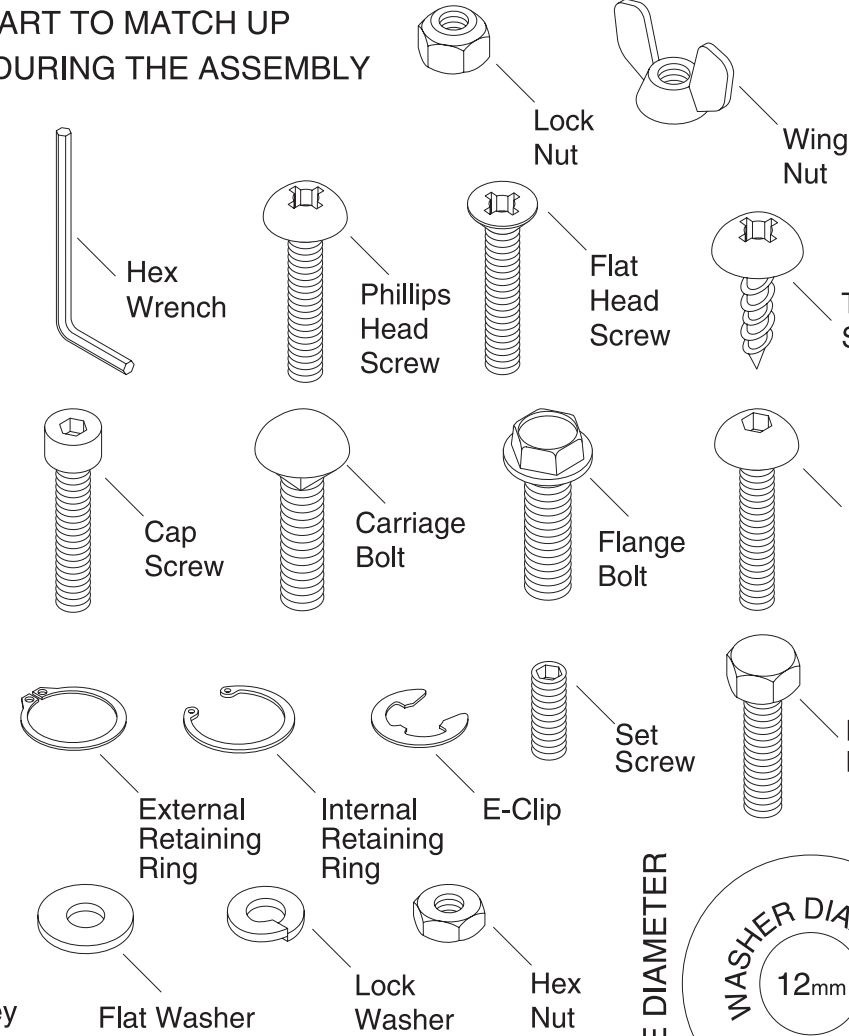
Hardware Recognition Chart

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

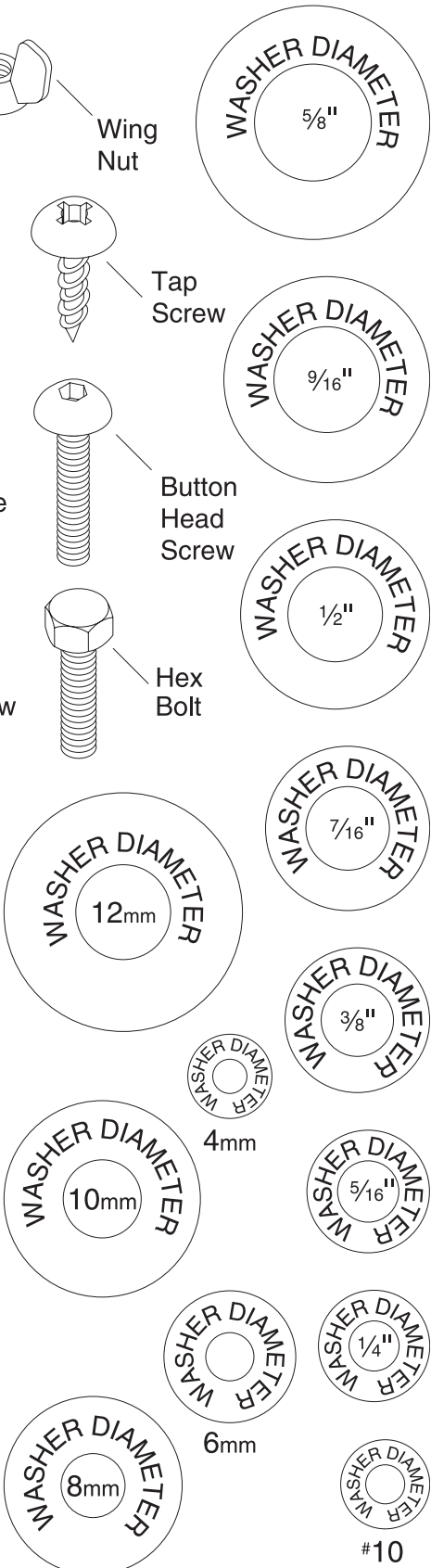
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

-  #10
-  1/4"
-  5/16"
-  3/8"
-  7/16"
-  1/2"

-  4mm
-  5mm
-  6mm
-  8mm
-  10mm
-  12mm
-  16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Base and Supports

Components and Hardware Needed:	Qty
Motor/Impeller Housing	1
Collector	1
Base	1
Rubber Gasket	1
Swivel Casters.....	4
Collection Bag Support Rods.....	2
Upper Bag Support Rod.....	1
Impeller Housing Support.....	1
Hex Bolts M6-1 x 15	6
Hex Bolts M8-1.25 x 15.....	8
Hex Nuts M5-.8	18
Hex Nuts M8-1.25	4
Flat Washers 5mm	22
Flat Washers 8mm	12
Phillips Head Screws M5-.8 x 15	6
Phillips Head Screws M5-.8 x 10	16
Phillips Head Screws M4-.7 x 8	2

To assemble the dust collector base:

1. **Make sure the dust collector motor is unplugged!**
2. Install the swivel casters onto the base with sixteen M5-.8 x 10 Phillips head screws, nuts, and flat washers (see **Figure 5**).



Figure 5. Installing casters.

3. Place the base right side up and install the collector support (**Figure 6**) using four M8-1.25 x 15 hex bolts and four flat washers.



Figure 6. Installing collector support.

4. Place the motor/impeller housing onto the collector support plate and fasten with four M8-1.25 x 15 hex bolts, four hex nuts, and eight flat washers as shown in **Figure 7**.



Figure 7. Installing motor/impeller housing on collector support.



5. Install the rubber gasket onto the motor/impeller housing opening.
6. Install the collector onto the motor/impeller housing with six M6-1 x 15 hex bolts, as shown in **Figure 8**.



Figure 8. Installing collector onto motor/impeller housing.

7. Secure the two collection bag support rods to the base plate with four M5-.8 x 15 Phillip head screws and four flat washers, and to the collector using two M5-.8 x 15 Phillip head screws, two flat washers, and two hex nuts as shown in **Figure 9**.

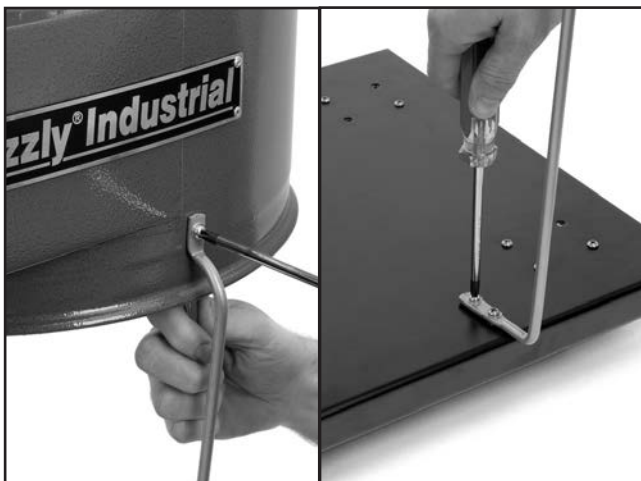


Figure 9. Securing collection bag support rods.

8. Install the upper bag support onto the collector, as shown in **Figure 10**, using two M4-.7 x 8 Phillips head screws.



Figure 10. Installing upper bag support.

Collector Support Bolts

1. Adjust the two hex bolts located on the collector support plate (**Figure 11**) so the bolt heads press against the motor/impeller housing.
2. Tighten the hex nuts against the support

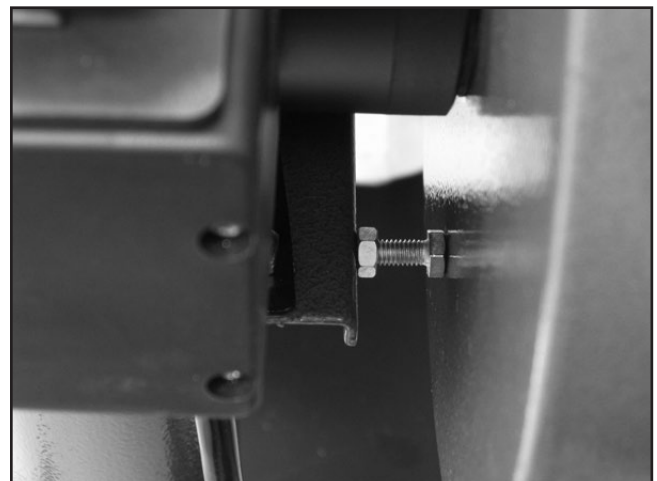


Figure 11. Adjusting collector support plate bolts.



Collection and Filtration Bags

Components and Hardware Needed:	Qty
Collection Bag	1
Filtration Bag	1
Bag Clamps.....	2

To install the collection bag:

1. Place the collection bag over the bottom edge of the collector and secure the bag clamp as shown in **Figure 12**.

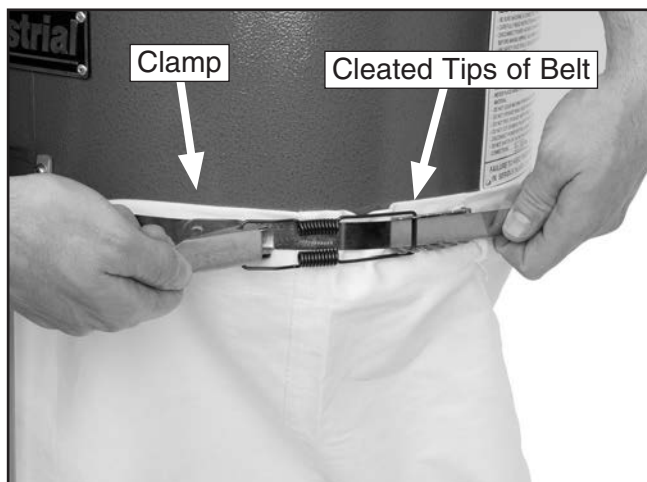


Figure 12. Securing collection bag onto collector.

2. If belts are not already installed on the collection and filtration bags, thread the cleated end of each belt through the left hole and out the right hole of each bag. Make sure cleated tips face out.

3. Bag clamp springs should be located between the belt and latch (**Figure 13**); if not, the bag clamp will not work. Adjust the springs if needed.

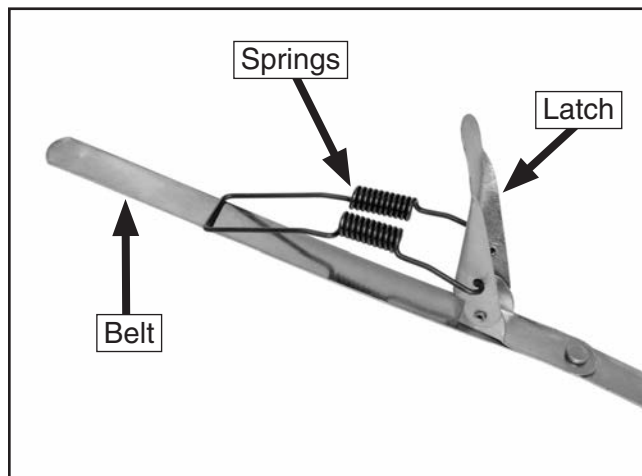


Figure 13. Correct bag clamp spring position.

To install the filtration bag:

1. Hook the top of the filtration bag onto the upper bag support rod, slip the filtration bag over the top of the collector, and secure the bag clamp. The dust collector should look similar to **Figure 14** when fully assembled.



Figure 14. Filtration and collection bags installed.



Collection System

General

The Model G8027 is designed to be a single-machine dust collector. Locate the dust collector where it will not interfere with the workpiece being processed, and no more than 10' of ducting is used, otherwise the CFM will be reduced. To solve dust collection questions, Grizzly offers a guide book entitled *Dust Collection Basics* that will help you design your system.

Whatever system you choose, always make sure there are no open flames or pilot lights in the same room as the dust collector. There is a risk of explosion if dust is dispersed into the air.

Material Selection

You have many choices regarding dust collection ducting, but flexible hose is the most common. 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.

Plastic Flexible Duct

Flexible rubber hose, polyethylene, plastic flex-hose and other flexible ribbed 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.

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, while being completely flexible, is non-resistant to abrasion and has a tendency to collapse in a negative pressure system.

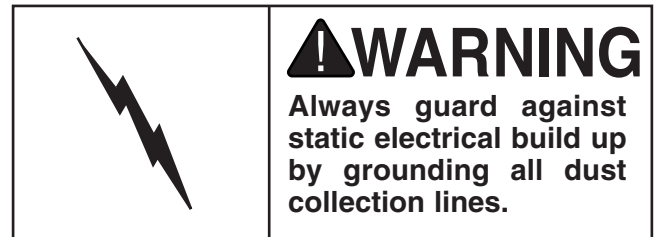
If using flex-hose, you should choose one of the many types that are designed specifically for the movement of solid particles, i.e. dust, grains

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 saw-dust, 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.

Duct Grounding

Plastic flex-hose is an insulator, and dust particles moving against the walls of the hose creates a 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.



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 15**) around the blast gate without interruption to the grounding system.

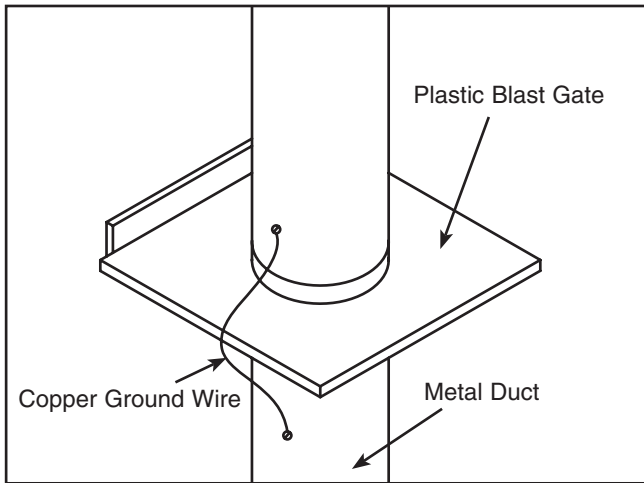


Figure 15. Ground jumper wire when using plastic blast gates or elbows and metal duct.

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 the dust collector frame with a ground screw as shown in **Figure 16**. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.

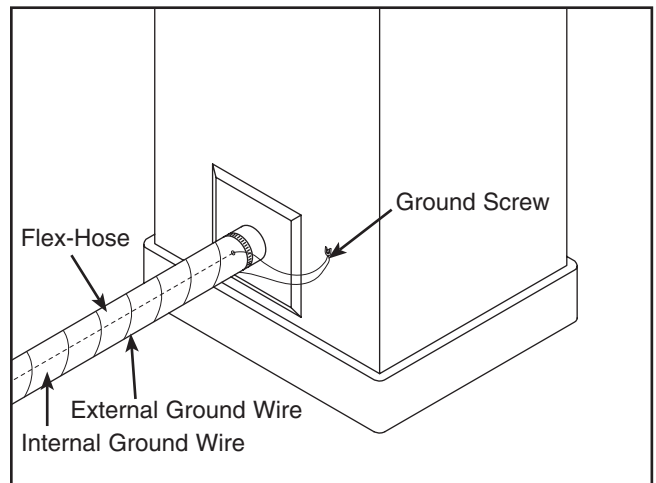


Figure 16. Flex-hose grounded to machine.



SECTION 4: OPERATION


Operation Safety



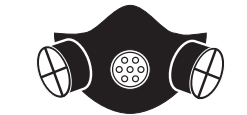
⚠️ WARNING
Disconnect power to the machine when performing any maintenance, assembly or adjustments. Failure to do this may result in serious personal injury.



⚠️ WARNING
Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.



⚠️ WARNING
Wear safety glasses during the entire operations process. Failure to comply may result in serious personal injury.



⚠️ CAUTION
Always wear a respirator when operating your dust collector. This machine circulates sawdust which may cause allergic reactions or respiratory problems.

Test Run

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

Turn on the power supply at the main panel. Turn the dust collector **ON**. Make sure that your finger is poised on the toggle switch just in case there is a problem. The dust collector 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.

If you cannot easily locate the source of an unusual noise or vibration, contact our service department for help.

General

Operating your Model G8027 is simple and straightforward. Move the dust collector to the machine location, connect the duct, connect the ducting ground, and you are ready to begin.

⚠️ 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 an air cleaner. For safest use, wear a respirator and use an air cleaner in addition to the dust collector.



SECTION 5: ACCESSORIES

- H2499—Small Half-Mask Respirator
- H3631—Medium Half-Mask Respirator
- H3632—Large Half-Mask Respirator
- H3635—Disposable Cartridge Filter Pair P100

Wood dust is now considered a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 17. Half-mask respirator and disposable cartridge filters.

- G1034—Upper Bag
- G5051—Lower Bag
- G5557—2.5 Micron Dust Bag-Medium Bag
- G5559—14.5" x 23" , 3.0 Micron Bag

To ensure consistent results, buy Grizzly replacement dust collector bags. Keep several spares on hand.



Figure 18. Model G1034 Upper Bag.

- G7984—Face Shield
- H1298—Dust Sealed Safety Glasses
- H1300—UV Blocking, Clear Safety Glasses
- H2347—Uvex® Spitfire Safety Glasses
- H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



Figure 19. Our most popular safety glasses.

- G1842—3" Plastic Blast Gate
- G1843—4" Plastic Blast Gate
- G1844—5" Plastic Blast Gate
- H1845—6" Plastic Blast Gate



Figure 20. Model G1842 Plastic Blast Gate.

Call 1-800-523-4777 To Order

G8027 1 HP Dust Collector



H2443—Universal Adapter

Seven-step adapter provides a multitude of dust collection reducing options. Simply cut away unneeded steps with a hacksaw. Outside diameter step sizes include 1", 2", 2-1/2", 3", 4", 5" and 6". Wall thickness is 1/8".

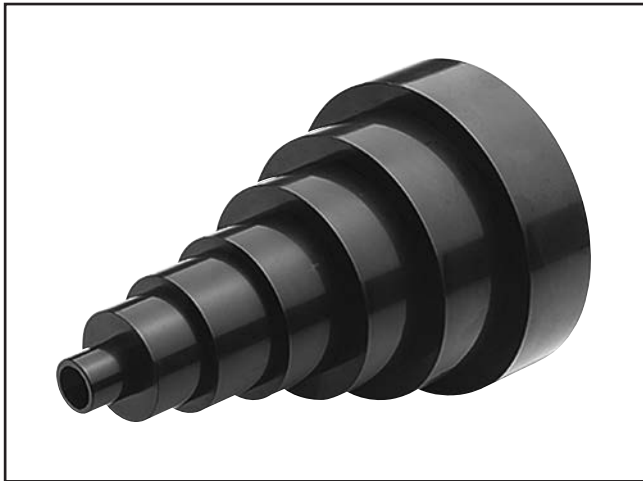


Figure 21. Model H2443 universal adapter.

G3181—Dust Collection Kit #1

Designed for a one machine hook-up, kit #1 comes complete with installation instructions and an accessories list for expanding your dust collection system in the future. Accessories included:

- (1) G1536 4" x 10' Hose
- (1) G1838 Universal Dust Hood
- (2) G2974 Wire Hose Clamps



Figure 22. Model G3181 Dust Collection Kit.

G2525—Dust Collection Basics

This incisive book skillfully guides the woodworker through all the steps necessary in the design and construction of an efficient central dust collection system and tells you what you need to know for easy installation. The text offers practical hints and techniques and takes the mystery, misery and hype away from a subject that should be as clear as the air you breathe. Fifty pages of concise, carefully illustrated text. A MUST!

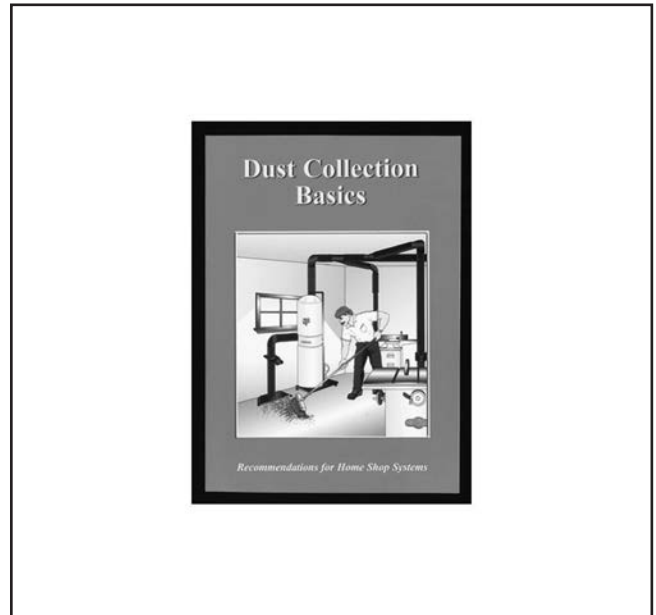


Figure 23. Model G2525 Dust Collection Basics.

G4679—Grounding Kit

Eliminate potential hazards by dissipating static charges. Kit includes 50' of 14-gauge bare copper wire, electrical connectors, grounding screws, terminal ends and instructions.

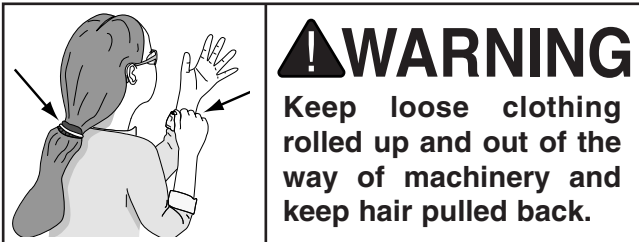
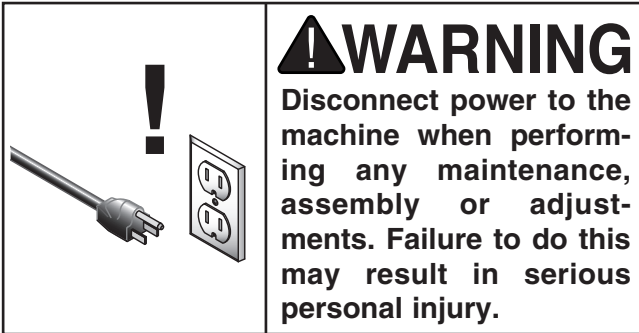


Figure 24. Model G4679 Grounding Kit.

Call 1-800-523-4777 To Order
G8027 1 HP Dust Collector



SECTION 6: MAINTENANCE



Schedule

Regular periodic maintenance on your Model G8027 Dust Collector will ensure its optimum performance. Make a habit of inspecting your machine 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. Any other condition that could hamper the safe operation of this machine.
5. DO NOT let collection bags get completely full.

Lubrication

Since all bearings are shielded and permanently lubricated, simply leave them alone until they need to be replaced. DO NOT lubricate them.



Bag Cleaning

Always wear a respirator or dust mask and safety glasses when emptying the storage bag (**Figure 25**). Small dust particles can escape the bags during emptying, causing them to become airborne and easily inhaled. This microscopic airborne dust is extremely unhealthy to breathe and can cause serious health problems.

Grizzly offers replacement collection bags (G5051 and G5559) for your Model G8027 Dust Collector.



Figure 25. Safely disposing of wood dust.

To empty the collection bag:

1. Make sure you are wearing a respirator and the dust collector is unplugged.
2. Un-clamp the collection bag and empty it.
3. Reinstall the collection bag.

While the Model G8027 excels at collecting the majority of wood dust produced by your machines, it is not an air filter; therefore, **we strongly recommend** the supplemental aid of a shop air filter such as the Grizzly G5955 or G9956. Air filters are designed to collect the smaller dust particles that a dust collector cannot trap.

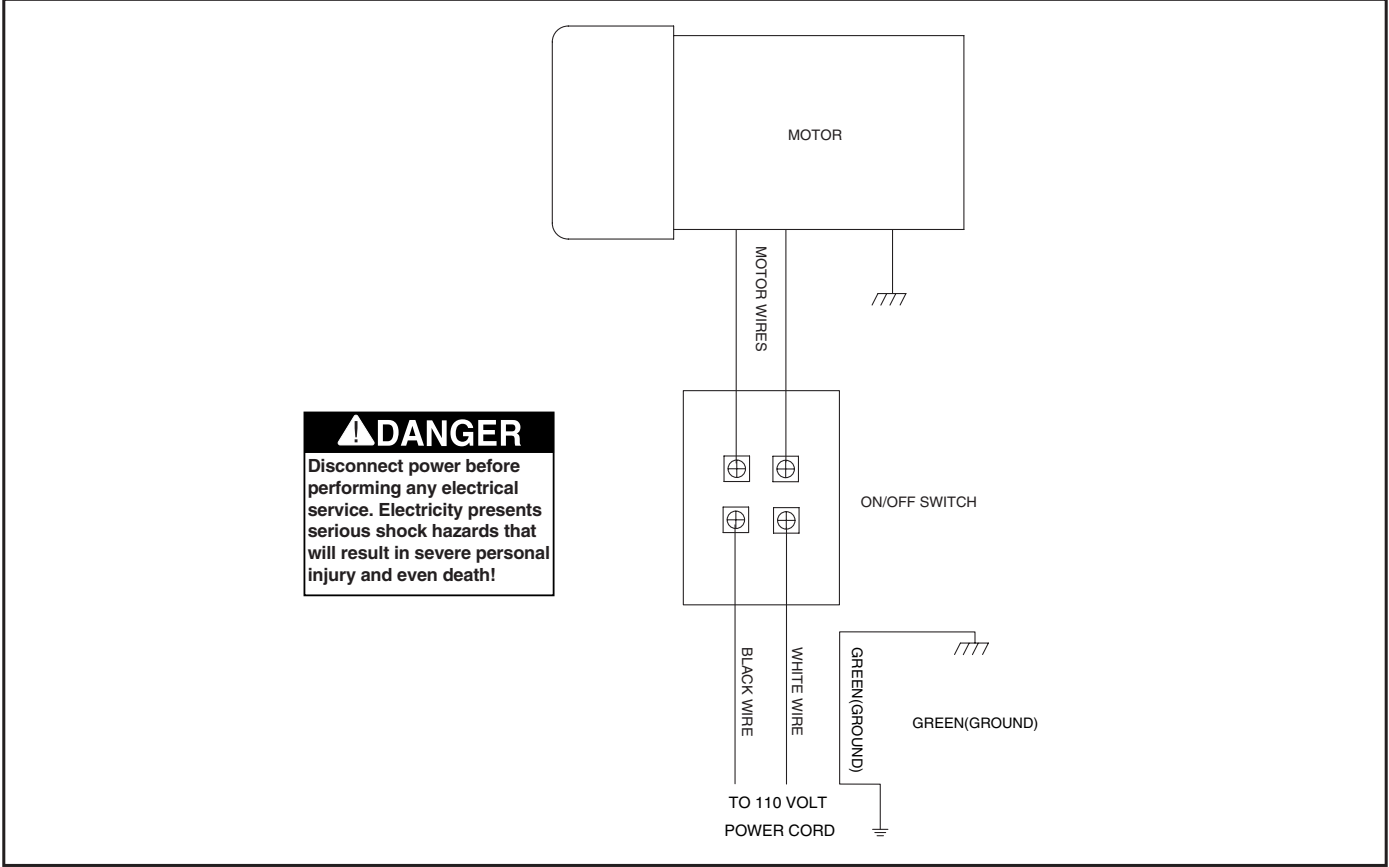
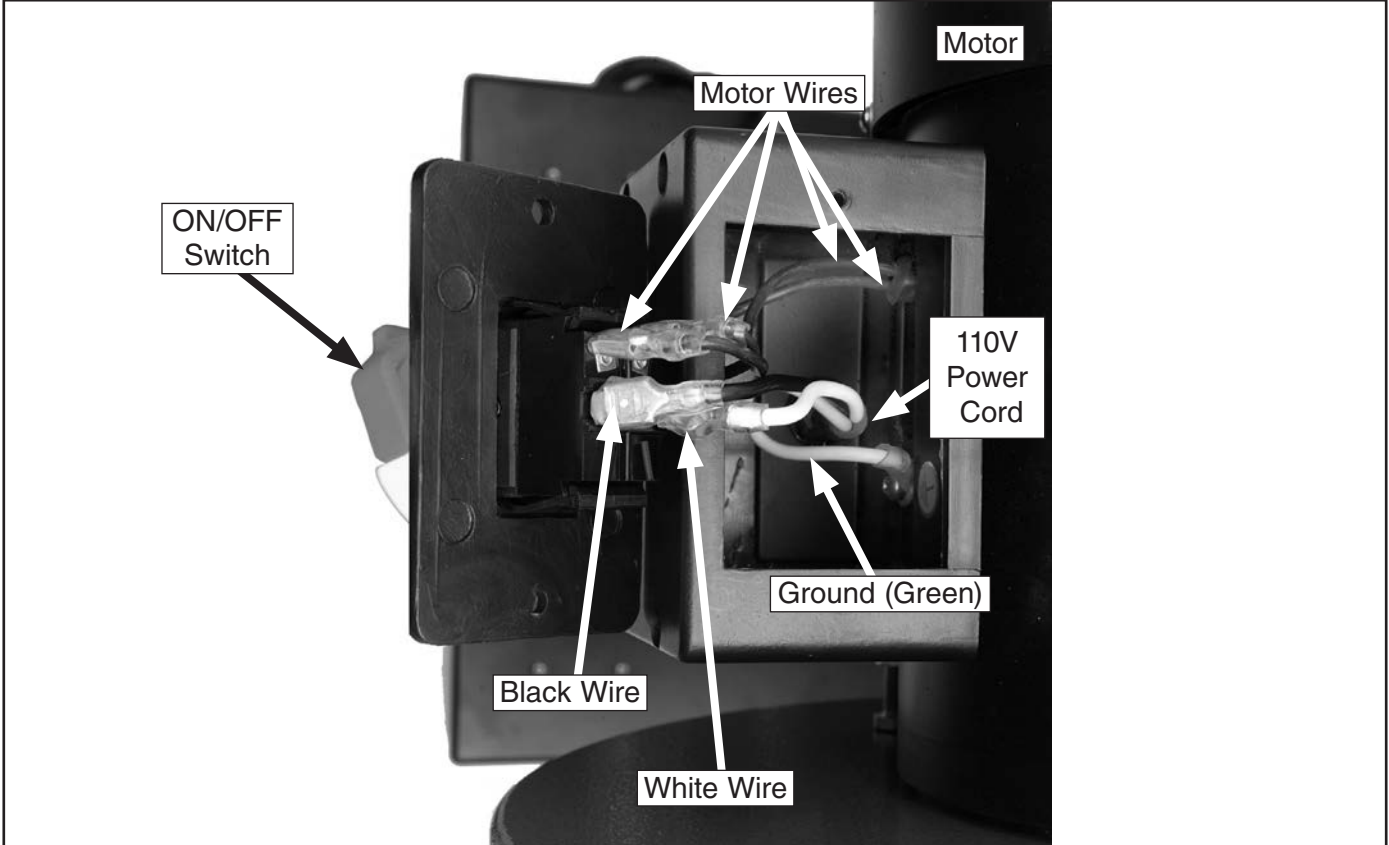


Troubleshooting

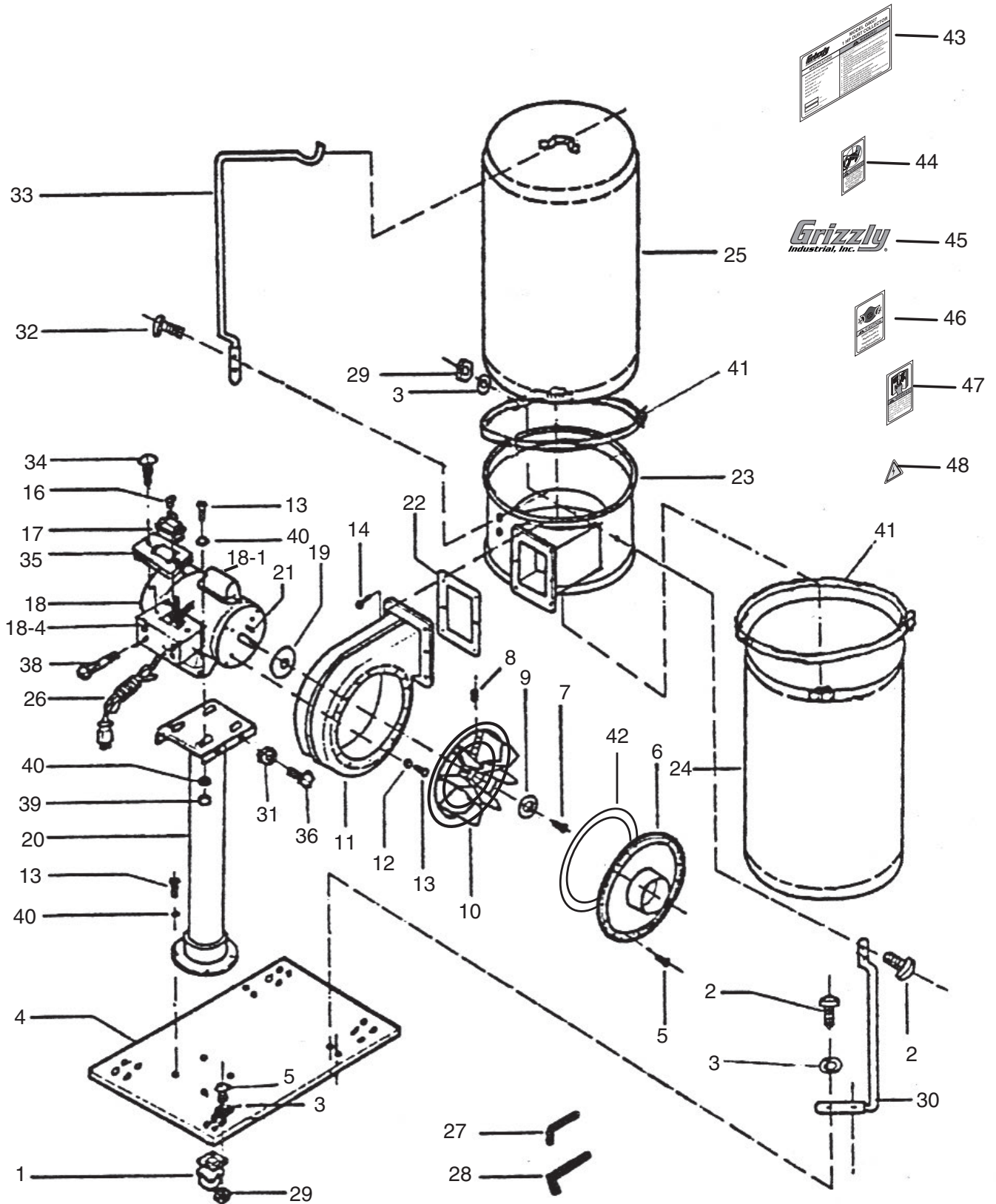
SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start, or it growls on start up.	<ol style="list-style-type: none"> 1. Power supply fuse or circuit breaker has tripped. 2. Toggle switch is broken inside. 3. Start capacitor is at fault. 4. Motor fan cover is dented, stopping the fan from being able to spin. 5. Motor is at fault. 	<ol style="list-style-type: none"> 1. Disconnect power, and inspect circuit for electrical shorts and repair. Replace circuit breaker if it is old or has tripped many times. 2. Disconnect power, and use an ohmmeter to check switch terminals for continuity, and replace switch if required. 3. Replace start capacitor. 4. Replace motor fan cover (and fan, if damaged). 5. Replace motor.
Motor runs slower than normal.	<ol style="list-style-type: none"> 1. Poor electrical connection. 2. Low power source voltage. 3. Motor is at fault. 	<ol style="list-style-type: none"> 1. Inspect the power supply for loose, corroded, or overheated electrical connections and repair. 2. Have the power source voltage checked; reduce the length of extension cord. 3. Replace the motor.
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 fan is damaged and unbalanced. 3. The motor mounting is 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. Unplug dust collector, 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 bag is full. 2. There is a restriction at the inlet grate. 3. The dust collector is too far away from the point of suction, or there are too many sharp bends in the ducting. 4. The lumber is wet and not flowing through the dust lines smoothly. 5. There is a leak in the ducting, or a series of small leaks, or too many open ports. 6. There is a restriction in the ducting, or the ducting and ports are incorrectly sized. 7. The machine dust collection design is inadequate. 8. The dust collector is too small for the dust collection system. 	<ol style="list-style-type: none"> 1. Empty bags. 2. Remove dust line from dust collector inlet and clean debris from the inlet grate (and wire-connector, if installed). 3. Relocate the dust collector closer to the point of suction, and rework ducting without sharp bends. Refer to the Dust Collection Basics handbook (ISBN 0-9635821-2-7) to help configure your dust system. 4. Process lumber with less than 20% moisture content. 5. Rework the ducting as to eliminate all leaks, and refer to the Dust Collection Basics handbook (ISBN 0-9635821-2-7) for more solutions. 6. Rework the ducting as to eliminate all restrictions, and refer to the Dust Collection Basics handbook (ISBN 0-9635821-2-7) for more solutions. 7. Use proper dust collection accessories. 8. Install a larger dust collector to power your dust collection system.



Electrical Components and Wiring



G8027 Parts Breakdown



G8027 Parts List

REF	PART #	DESCRIPTION
1	P8027001	SWIVEL CASTER
2	P8027002	PHLP HD SCR M5-.8 X 15
3	P8027003	FLAT WASHER 5MM
4	P8027004	BASE PLATE
5	P8027005	PHLP HD SCR M5-.8 X 10
6	P8027006	INLET COVER
7	P8027007	CAP SCREW M6-1 X 20 LH
8	P8027008	SET SCREW M8-1.25 X 12
9	P8027009	SPECIAL WASHER
10	P8027010	IMPELLER
11	P8027011	IMPELLER HOUSING
12	P8027012	LOCK WASHER 8MM
13	P8027013	HEX BOLT M8-1.25 X 15
14	P8027014	HEX BOLT M6-1 X 15
16	P8027016	SWITCH SAFETY KEY
17	P8027017	SWITCH 110/220V
18	P8027018	MOTOR
18-1	P8027018-1	CAPACITOR COVER
18-2*	P8027018-2	MOTOR FAN COVER
18-3*	P8027018-3	MOTOR FAN
18-4	P8027018-4	COMPLETE SWITCH BOX
19	P8027019	RUBBER GASKET
20	P8027020	IMPELLER HOUSING SUPPORT
21	P8027021	FLAT PIN 5 x 30
22	P8027022	RUBBER GASKET

REF	PART #	DESCRIPTION
23	P8027023	COLLECTOR
24	P8027024	COLLECTION BAG
25	P8027025	14.5" X 23" 2.5 MICRON BAG
26	P8027026	POWER CORD
27	P8027027	HEX WRENCH 4MM
28	P8027028	HEX WRENCH 5MM
29	P8027029	HEX NUT M5-.8
30	P8027030	COLLECTOR BAG SUPPORT ROD
31	P8027031	HEX NUT M6-1
32	P8027032	PHLP HD SCR M4-.7 X 8
33	P8027033	UPPER BAG SUPPORT ROD
34	P8027034	TAP SCREW M4 X 12
35	P8027035	SWITCH PLATE
36	P8027036	HEX BOLT M6-1 X 25
38	P8027038	PHLP HD SCR M4-.7 X 60
39	P8027039	HEX NUT M8-1.25
40	P8027040	FLAT WASHER 8MM
41	P8027041	BAG CLAMP
42	P8027042	RUBBER GASKET
43	P8027043	MACHINE ID LABEL
44	P8027044	NO HAND IN INLET LABEL
45	P8027045	GRIZZLY INDUSTRIAL, INC. LABEL
46	P8027046	RESPIRATOR LABEL
47	P8027047	READ MANUAL LABEL
48	P8027048	ELECTRICITY LABEL

* Item not shown in Parts Breakdown



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 WARRANTY CARD
Industrial, Inc.

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

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

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