



MODEL G0671/G0672/G0673 DUST COLLECTOR

OWNER'S MANUAL

(For models manufactured since 6/17)



G0671
4 HP 220V Single-Phase



G0672
5 HP 220V Single-Phase



G0673
10 HP 220/440V 3-Phase

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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.**

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V4.11.17



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

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

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Machine Description

This machine is designed to capture dust and wood chips from multiple woodworking machines at the same time, such as table saws, jointers, and planers.

A wide variety of accessories for setting up a stationary or mobile dust collection system are available through Grizzly.

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		⚠ WARNING!	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure machine is properly adjusted/setup and	
Specification:		4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.	
Weight:		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	

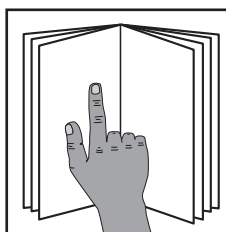
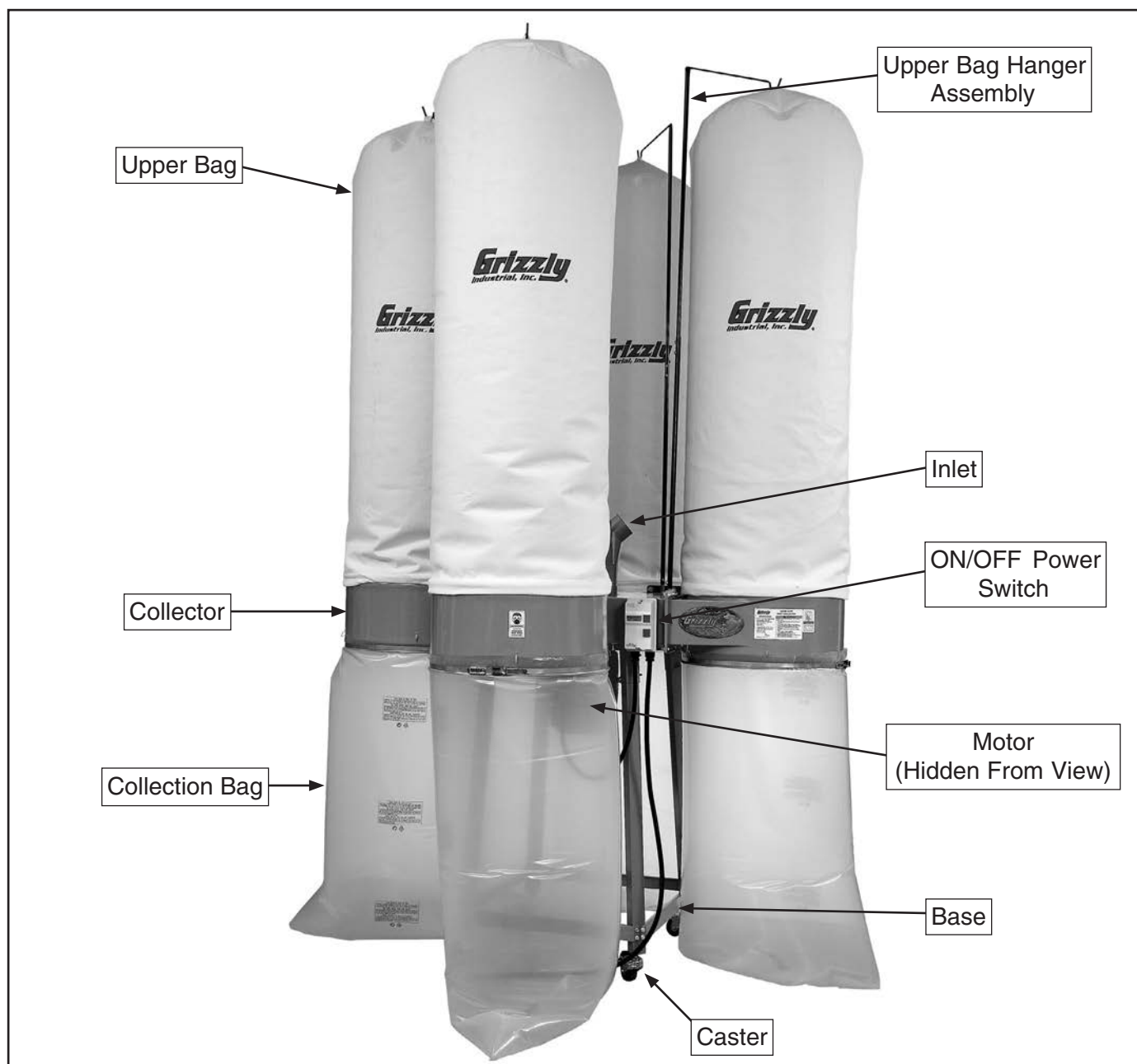
Manufactured for Grizzly in Taiwan

Manufacture Date []

Serial Number []



Identification



⚠ WARNING

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





MACHINE DATA SHEET

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

MODEL G0671 4 HP DUST COLLECTOR

Product Dimensions:

Weight..... 270 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 73-7/8 x 31-3/8 x 101-1/8 in.
Footprint (Length x Width)..... 73-7/8 x 31-3/8 in.

Shipping Dimensions:

Type..... Cardboard Box & Wood Frame
Content..... Machine
Weight..... 306 lbs.
Length x Width x Height..... 42 x 29 x 30 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
Prewired Voltage..... 220V
Full-Load Current Rating..... 26A
Minimum Circuit Size..... 40A
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Power Cord Included..... Yes
Plug Included..... No
Switch Type..... Magnetic Switch w/Overload Protection

Motors:

Main

Horsepower..... 4 HP
Phase..... Single-Phase
Amps..... 26A
Speed..... 3450 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Direct Drive
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation

Dust Collector Type..... Single-Stage
Approved Dust Types..... Wood
Filter Type..... Bag
Airflow Performance..... 3552 CFM
Max Static Pressure (at 0 CFM)..... 13.5 in.
Main Inlet Size..... 10 in.
Inlet Adapter Included..... Yes
Number of Adapter Inlets..... 4
Adapter Inlet Size..... 4 in.
Machine Collection Capacity At One Time..... 3
Maximum Material Collection Capacity..... 24 cu. ft.
Filtration Rating..... 2.5 Micron



Bag Information

Number of Upper Bags..... 2
Number of Lower Bags..... 2
Upper Bag Diameter..... 23-5/8 in.
Upper Bag Length..... 47-1/4 in.
Lower Bag Diameter..... 23-5/8 in.
Lower Bag Length..... 54 in.

Impeller Information

Impeller Type..... Radial Fin
Impeller Size..... 14-1/2 in.
Impeller Blade Thickness..... 1/4 in.

Construction

Upper Bag..... Fabric
Lower Bag..... Plastic
Frame..... Steel Sheet Metal w/Casters
Impeller..... Steel
Paint Type/Finish..... Powder Coated
Body..... Steel Sheet Metal

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 1 Hour
Serial Number Location ID Label on Front of Machine
Sound Rating 90 dB
ISO 9001 Factory Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) No

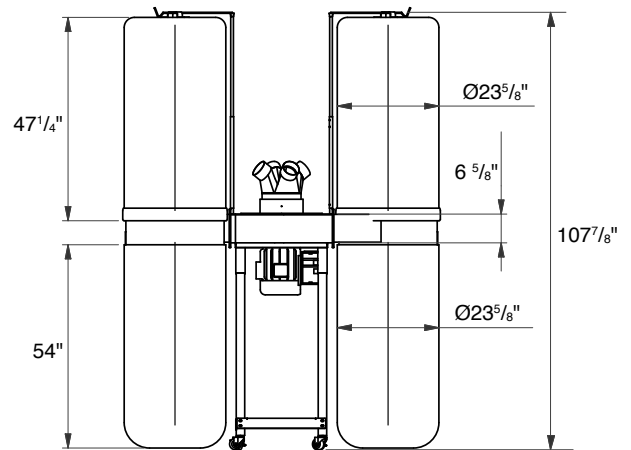
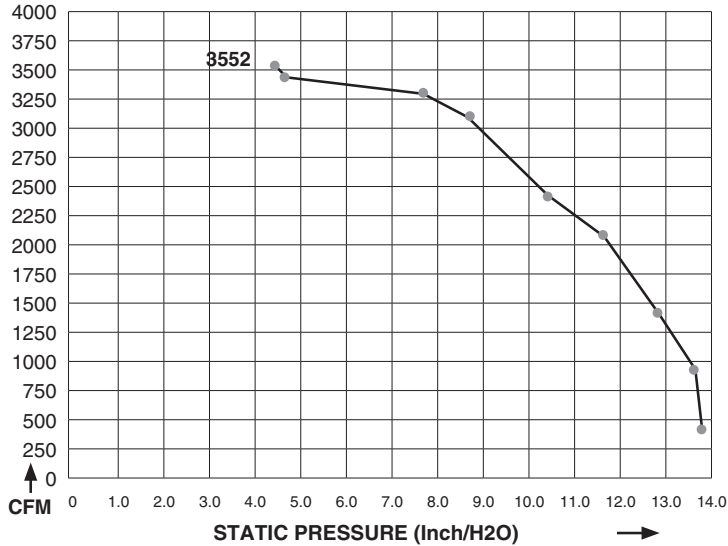
Features:

2.5 Micron Upper Bag Filtration
14-1/2" Balanced Steel, Radial Fin Impeller
Heavy-Duty Steel Stand with 3" Casters and Brakes
Green Powder Coated Paint
Sturdy Collection Bags with 24 cu. ft. Total Capacity
Four-Port Intake Manifold for Even Distribution to Collection Bags



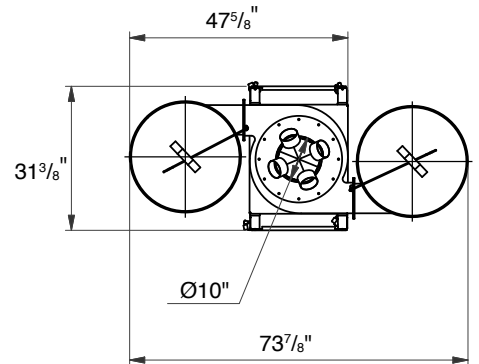
MODEL G0671 4 HP DUST COLLECTOR

Performance Curve



4 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	Max SP	HP	Volts	Inlet	Impeller
3551.6	13.5	4 HP	220V	10"	14 1/2"

Inlet Dia. (inch)	10"	9"	8"	7"	6"	5"	4"	3"	2"
CFM	3551.6	3454.8	3282.6	2916.6	2475.4	2098.7	1452.9	979.4	484.3
Static Pressure (Inch/H2O)	4.72	4.82	6.98	8.5	10.3	11.1	12.53	13.2	13.5
Amps	30	29.5	27.5	24	21	16.8	12.5	11	8.6
Air Speed (m/s)	33	32.1	30.5	27.1	23	19.5	13.5	9.1	4.5



Test run using 30 micron upper and lower bag.



MACHINE DATA SHEET

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

MODEL G0672 5 HP INDUSTRIAL DUST COLLECTOR

Product Dimensions:

Weight..... 286 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 74 x 29 x 134 in.
Footprint (Length x Width)..... 74 x 29 in.

Shipping Dimensions:

Type..... Cardboard Box & Wood Frame
Content..... Machine
Weight..... 326 lbs.
Length x Width x Height..... 42 x 29 x 30 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
Prewired Voltage..... 220V
Full-Load Current Rating..... 34A
Minimum Circuit Size..... 50A
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Power Cord Included..... Yes
Plug Included..... No
Switch Type..... Magnetic Switch w/Overload Protection

Motors:

Main

Horsepower..... 5 HP
Phase..... Single-Phase
Amps..... 34A
Speed..... 3450 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Direct Drive
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation

Dust Collector Type..... Single-Stage
Approved Dust Types..... Wood
Filter Type..... Bag
Airflow Performance..... 3961 CFM
Max Static Pressure (at 0 CFM)..... 14.6 in.
Main Inlet Size..... 10 in.
Inlet Adapter Included..... Yes
Number of Adapter Inlets..... 4
Adapter Inlet Size..... 4 in.
Machine Collection Capacity At One Time..... 4
Maximum Material Collection Capacity..... 24 cu. ft.
Filtration Rating..... 2.5 Micron



Bag Information

Number of Upper Bags..... 2
Number of Lower Bags..... 2
Upper Bag Diameter..... 23-5/8 in.
Upper Bag Length..... 70 in.
Lower Bag Diameter..... 23-5/8 in.
Lower Bag Length..... 54 in.

Impeller Information

Impeller Type..... Radial Fin
Impeller Size..... 15 in.
Impeller Blade Thickness..... 1/4 in.

Construction

Upper Bag..... Fabric
Lower Bag..... Plastic
Frame..... Steel Sheet Metal w/Casters
Caster..... Rubber
Impeller..... Steel
Paint Type/Finish..... Powder Coated
Blower Housing..... Formed Steel

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 1 Hour
Serial Number Location ID Label on Front of Machine
Sound Rating 92 dB
ISO 9001 Factory Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) No

Features:

2.5 Micron Upper Bag Filtration
15" Balanced Steel, Radial Fin Impeller
Heavy-Duty Steel Stand with 3" Casters and Brakes
Green Powder Coated Paint
Sturdy Collection Bags with 24 cu. ft. Total Capacity
Four-Port Intake Manifold for Even Distribution to Collection Bags



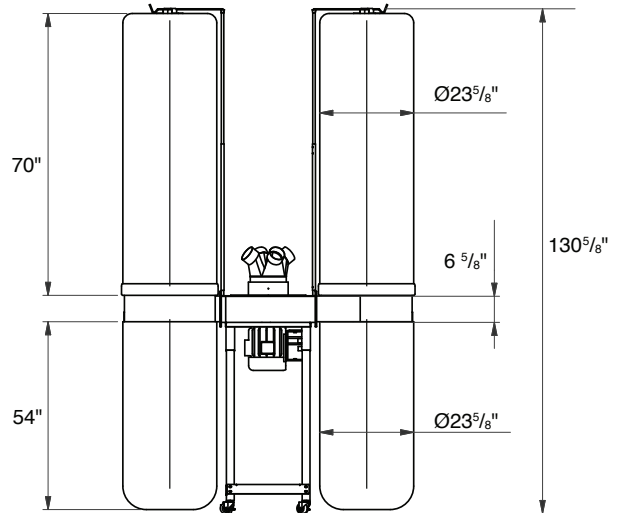
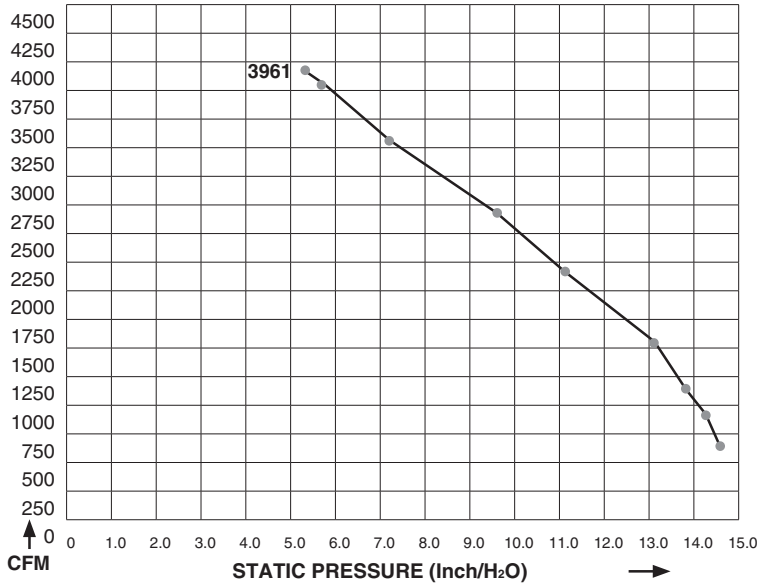


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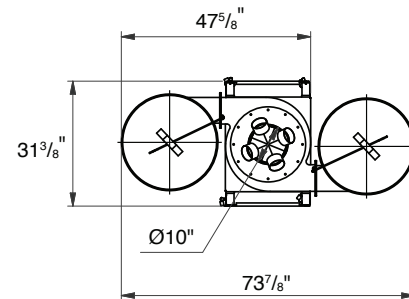
MODEL G0672 5 HP DUST COLLECTOR

Performance Curve



5 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	Max SP	HP	Volts	Inlet	Impeller
3960.6	14.6	5HP	220V	10"	15"

Inlet Dia. (inch)	10"	9"	8"	7"	6"	5"	4"	3"	2"
CFM	3960.6	3809.9	3336.4	2744.4	2206.3	1560.6	1140.8	861.0	656.5
Static Pressure (Inch/H ₂ O)	5.36	5.6	7.2	9.64	11.4	13.04	13.84	14.08	14.6
Amps	33.2	32.5	30	25.5	21.7	17.4	13.5	10.7	9.5
Air Speed (m/s)	36.8	35.4	31	25.5	20.5	14.5	10.6	8	6.1



Test run using 2.5 micron upper bag and plastic lower collection bag.
Max amp draw after adding 10" x 4" x 4" inlet: 30.3A.





MACHINE DATA SHEET

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

MODEL G0673 10 HP INDUSTRIAL DUST COLLECTOR

Product Dimensions:

Weight..... 410 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 61 x 61 x 134 in.
Footprint (Length x Width)..... 61 x 61 in.

Shipping Dimensions:

Type..... Cardboard Box & Wood Frame
Content..... Machine
Weight..... 472 lbs.
Length x Width x Height..... 53 x 46 x 31 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
Prewired Voltage..... 220V
Full-Load Current Rating..... 30A at 220V, 15A at 440V
Minimum Circuit Size..... 40A at 220V, 20A at 440V
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Switch Type..... Magnetic Switch w/Overload Protection
Voltage Conversion Kit..... P0508037 for 440V
Recommended Phase Converter..... G7979

Motors:

Main

Horsepower..... 10 HP
Phase..... 3-Phase
Amps..... 30A/15A
Speed..... 3450 RPM
Type..... TEFC Induction
Power Transfer Direct Drive
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation

Dust Collector Type..... Single-Stage
Approved Dust Types..... Wood
Filter Type..... Bag
Airflow Performance..... 5360 CFM
Max Static Pressure (at 0 CFM)..... 17.9 in.
Main Inlet Size..... 10 in.
Inlet Adapter Included..... Yes
Number of Adapter Inlets..... 5
Adapter Inlet Size..... 4 in.
Machine Collection Capacity At One Time..... 4
Maximum Material Collection Capacity..... 48 cu. ft.
Filtration Rating..... 2.5 Micron



Bag Information

Number of Upper Bags..... 4
Number of Lower Bags..... 4
Upper Bag Diameter..... 23-5/8 in.
Upper Bag Length..... 70 in.
Lower Bag Diameter..... 23-5/8 in.
Lower Bag Length..... 54 in.

Impeller Information

Impeller Type..... Radial Fin
Impeller Size..... 17 in.
Impeller Blade Thickness..... 1/4 in.

Construction

Upper Bag..... Fabric
Lower Bag..... Plastic
Frame..... Steel Sheet Metal w/Casters
Caster..... Rubber
Impeller..... Steel
Paint Type/Finish..... Powder Coated
Blower Housing..... Formed Steel

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 1-1/2 Hours
Serial Number Location ID Label on Front of Machine
ISO 9001 Factory Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) No

Features:

2.5 Micron Upper Bag Filtration
17" Balanced Steel, Radial Fin Impeller
Heavy-Duty Steel Stand with 3" Casters and Brakes
Green Powder Coated Paint
Sturdy Collection Bags with 48 cu. ft. Total Capacity
Five-Port Intake Manifold for Even Distribution to Collection Bags



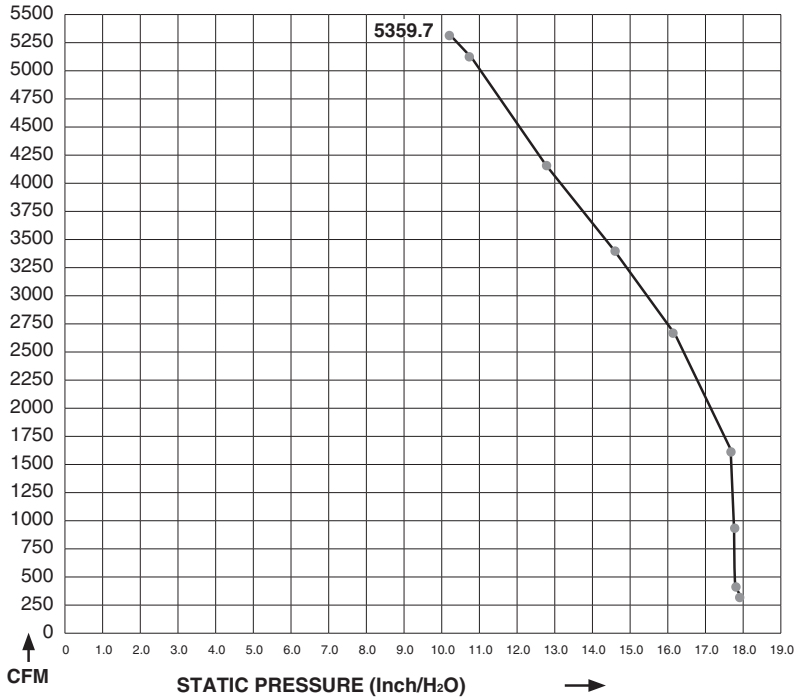


MACHINE DATA SHEET

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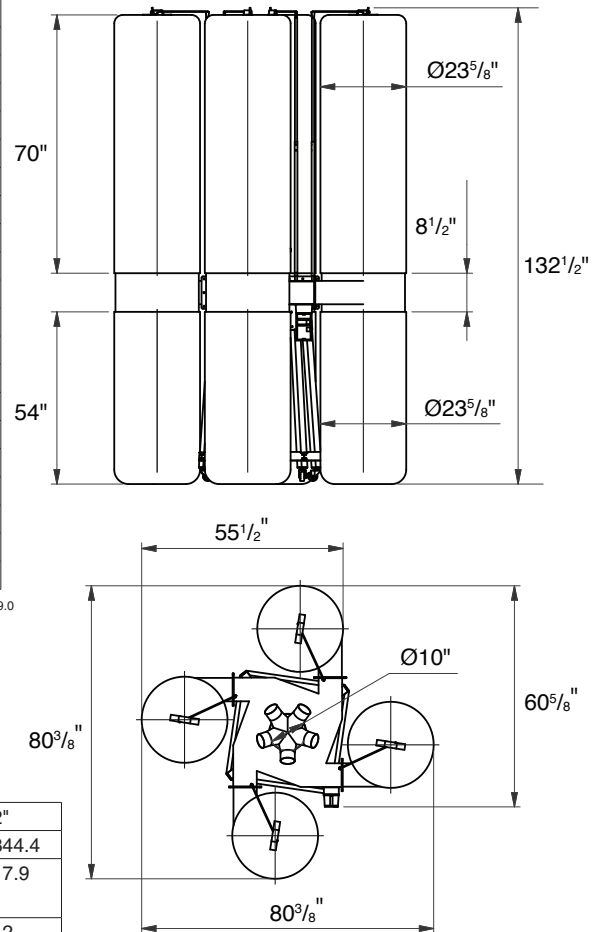
MODEL G0673 10 HP DUST COLLECTOR

Performance Curve



10 HP DUST COLLECTOR PERFORMANCE RESULTS					
Max CFM	Max SP	HP	Volts	Inlet	Impeller
5359.7	17.9	10HP	220V	10"	17"

Inlet Dia. (inch)	10"	9"	8"	7"	6"	5"	4"	3"	2"
CFM	5359.7	5176.8	4229.7	3390.2	2604.5	1678.9	968.6	430.5	344.4
Static Pressure (Inch/H ₂ O)	10.08	10.64	12.96	14.72	16.08	17.68	17.72	17.8	17.9
Amps	32.6	32.1	30	26.6	23.1	18.7	15.4	13.1	12
Air Speed (m/s)	49.8	48.1	39.3	31.5	24.2	15.6	9	4	3.2



Test run using 2.5 micron upper bag and plastic lower collection bag.
Max amp draw after adding 10" x 4" x 5 inlet: 30.5A.



SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating This Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.



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.

Safety Instructions for Machinery



OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

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

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly **BEFORE** operating machine.

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

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

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

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace **BEFORE** operating machine. For your own safety, **DO NOT** operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—**NOT** the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

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



Additional Safety for Dust Collectors

WARNING

Long-term respiratory damage can occur from using dust collectors without proper use of a respirator. Fire or explosions can result in smoke inhalation, serious burns, or death—if machine is used to collect incorrect materials, is operated near potential explosion sources, or ducting is improperly grounded. Entanglement, amputation, or death can occur if hair, clothing, or fingers are pulled into the inlet. To reduce the risk of these hazards, operator and bystanders **MUST** completely heed the hazards and warnings below.

INTENDED USE. Collecting the wrong materials can result in serious inhalation hazards, fire, explosions, or machine damage. This machine is **ONLY** designed to collect wood dust and chips from woodworking machines. **DO NOT** use it to collect silica, polyurethane, toxic fumes, metal dust or shavings, lead paint, drywall, asbestos, biohazards, explosive dusts, flammable or combustible liquids or fumes, nor burning or smoking material.

WEAR A RESPIRATOR. Fine dust that is too small to be caught in filter will be blown into ambient air. Always wear a NIOSH-approved respirator during operation and for a short time after to reduce your risk of permanent respiratory damage. Never collect dust from any hazardous material.

IMPELLER HAZARDS. To reduce risk of entanglement or contact with impeller, **DO NOT** place hands, hair, clothing, or tools in or near open dust collection inlet during operation, and keep small animals and children away. The powerful suction could easily pull them into impeller.

HAZARDOUS DUST. Dust exposure 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.

EMPTYING DUST. When emptying bag or drum, wear respirator and safety glasses. Empty dust away from ignition sources and into approved container.

OPERATING LOCATION. To reduce respiratory exposure to fine dust, locate permanently installed dust collectors away from working area or in another room. **DO NOT** place dust collector where it can be exposed to rain or moisture, which creates a shock hazard and will reduce life of machine.

POWER DISCONNECT. Turn machine **OFF**, disconnect from power supply, and allow impeller to completely stop before leaving machine unattended, or doing any maintenance or service.

REGULAR CLEANING. To reduce risk of starting a fire, regularly check/empty collection bags or drum to avoid buildup of fine dust, which can increase risk of fire. Regularly clean surrounding area where machine is operated—excessive dust buildup on overhead lights, heaters, electrical panels, or other heat sources will increase risk of fire.

SUSPENDED DUST PARTICLES. To reduce risk of death or injury caused by explosions or fires, **DO NOT** operate in areas where these risks are high, including spaces near pilot lights, open flames, or other ignition sources.

AVOIDING SPARKS. To reduce risk of fire, avoid collecting any metal objects or stones. These can possibly produce sparks when they strike impeller, which can smolder in wood dust for a long time before a fire is detected. If you accidentally cut into wood containing metal, immediately turn **OFF** dust collector, disconnect from power, and wait for impeller to stop. Then empty bag or drum into approved airtight metal container.

FIRE SUPPRESSION. Only operate dust collector in locations that contain fire suppression system or have fire extinguisher nearby.

STATIC ELECTRICITY. To reduce risk of fire or explosions caused by sparks from static electricity, ground all ducting using grounding wire.

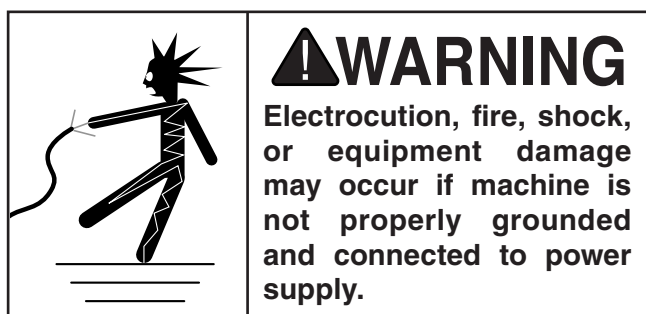
DUST ALLERGIES. Dust from certain woods will cause an allergic reaction. Make sure you know what type of wood dust you will be exposed to in case of an allergic reaction.



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 an electrician or qualified service personnel 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.

G0671

Full-Load Current Rating at 220V 26 Amps

G0672

Full-Load Current Rating at 220V 34 Amps

G0673

Full-Load Current Rating at 220V 30 Amps

Full-Load Current Rating at 440V 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 specified circuit requirements.

Circuit Information

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

! CAUTION

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

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



G0671 Circuit Requirements for 220V

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

Nominal Voltage208V, 220V, 230V, 240V
Cycle60 Hz
Phase Single-Phase
Power Supply Circuit 40 Amps

G0672 Circuit Requirements for 220V

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

Nominal Voltage208V, 220V, 230V, 240V
Cycle60 Hz
Phase Single-Phase
Power Supply Circuit 50 Amps

G0672 Circuit Requirements for 220V

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

Nominal Voltage208V, 220V, 230V, 240V
Cycle60 Hz
Phase 3-Phase
Power Supply Circuit 40 Amps

G0673 Circuit Requirements for 440V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage208V, 220V, 230V, 240V
Cycle60 Hz
Phase 3-Phase
Power Supply Circuit 20 Amps

Connection Type

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

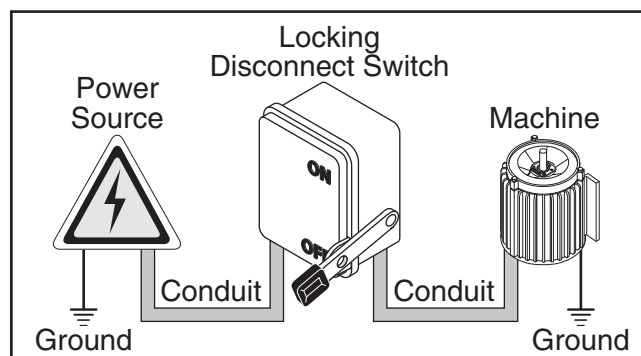


Figure 1. Typical setup of a permanently connected machine.

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 machine to power before completing 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.



G0673 440V Conversion

The Model G0673 can be converted for 440V operation. This conversion job consists of disconnecting the machine from the power source, changing the connections on the magnetic switch and rewiring the motor for 440V operation.

The Model G0673 440V Conversion Kit (Part #P0673036) for this procedure can be purchased by calling Grizzly Customer Service at (800) 523-4777.

All wiring changes must be performed by an electrician or qualified service personnel before the machine is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

To rewire the Model G0673 for 440V operation:

1. DISCONNECT MACHINE FROM POWER!
2. Remove the magnetic switch cover, then disconnect and remove the 220V magnetic switch (see Figure 2).

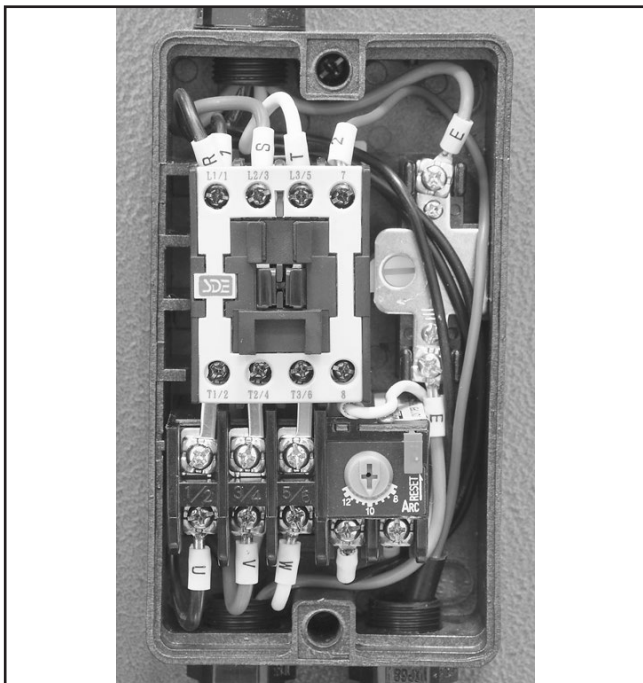


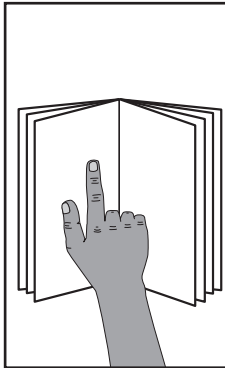
Figure 2. 220V magnetic switch.

3. Install the 440V magnetic switch and wire it according to the **G0673 Wiring Diagram** on **Page 45**.
4. Remove the motor junction box cover, rewire the motor as shown on the diagram located inside the junction box, then re-install the cover.

Note: *The reference motor wiring diagram on Page 45 was current at the time of printing, but always use the wiring diagram provided inside the motor junction box, as it will reflect any changes to the motor shipped with your machine.*

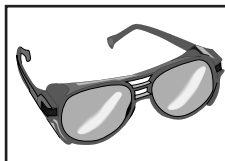


SECTION 3: SETUP



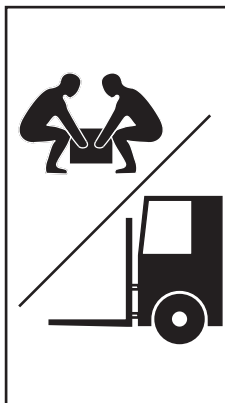
!WARNING

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

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

Needed for Setup

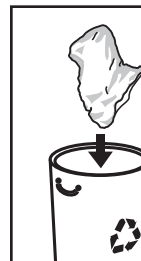
The following are needed to complete the setup process:

Description	Qty
• Assistant.....	1 or more
• Safety Glasses (for each person).....	1
• Gloves (for each person).....	1
• Phillips Head Screwdriver.....	1
• Wrench 10mm	1
• Wrenches 12mm	2
• Ladder (for hanging upper bag).....	1

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. ***You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.***



!WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.



G0671/G0672 Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

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

Contents (Figures 3 & 4)

	Qty
A. Collectors	2
B. Impeller Housing with Motor.....	1
C. Casters	4
D. Leg Braces	4
E. Combo Wrench 10 x 12mm.....	1
F. Legs.....	4
G. Gaskets	2
H. 4-in-1 Inlet Adapter	1
I. Hangers.....	2
J. Hanger Supports.....	2
K. Lower Collection Bags (Plastic).....	2
L. Upper Filter Bags (Fabric)	2

Fasteners (where used) (not shown)

	Qty
• Hex Bolts $\frac{5}{16}$ "-18 x $2\frac{1}{2}$ " (legs)	8
• Hex Nuts $\frac{5}{16}$ "-18 (legs/collectors)	24
• Hex Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " (leg braces)	16
• Hex Bolts $\frac{5}{16}$ "-18 x 1" (collectors)	16
• Hex Bolts $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " (hangers).....	6
• Flat Washers $\frac{5}{16}$ " (collectors)	32
• Phillips Head Screw 10-24 X $\frac{3}{8}$ " (inlet)	1
• Bag Clamps (bags).....	4

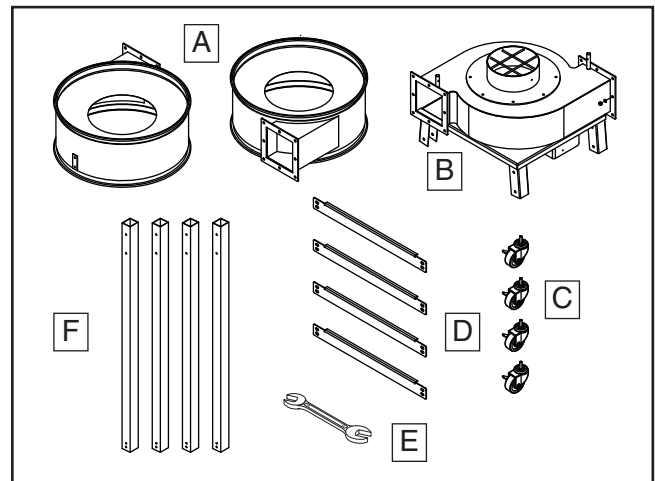


Figure 3. G0671/G0672 Inventory 1.

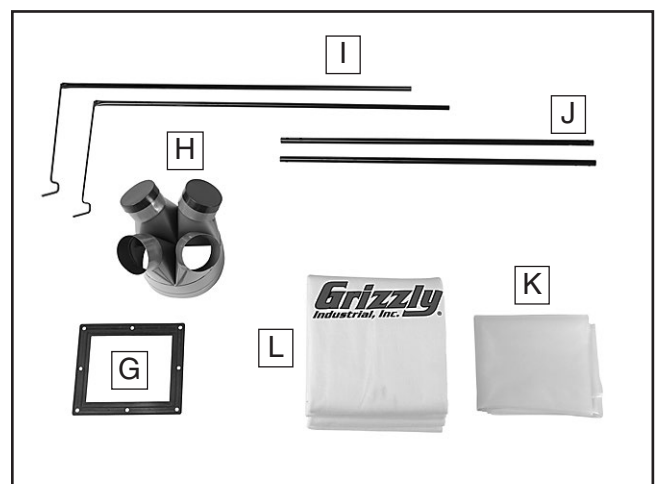


Figure 4. G0671/G0672 Inventory 2.



G0673 Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

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

Contents (Figures 5–7)

	Qty
A. Collectors	4
B. 5-in-1 Inlet Adapter	1
C. G0673 Impeller Housing with Motor	1
D. Legs	4
E. Leg Braces	4
F. Combo Wrench 10 x 12mm	1
G. Casters	4
H. Upper Filter Bags (Fabric)	4
I. Lower Collection Bags (Plastic)	4
J. Hangers	4
K. Hanger Supports	4
L. Rubber Gaskets	4
M. Bag Clamps	8

Fasteners (where used) (not shown)

	Qty
• Hex Bolts $\frac{5}{16}$ "-18 x $2\frac{1}{2}$ " (legs)	8
• Hex Nuts $\frac{5}{16}$ "-18" (legs/collectors)	40
• Hex Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " (leg braces)	16
• Hex Bolts $\frac{5}{16}$ "-18 x 1" (collectors)	32
• Hex Bolts $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " (hangers)	12
• Flat Washers $\frac{5}{16}$ " (collectors)	64
• Phillips Head Screw 10-24 X $\frac{3}{8}$ " (inlet)	1

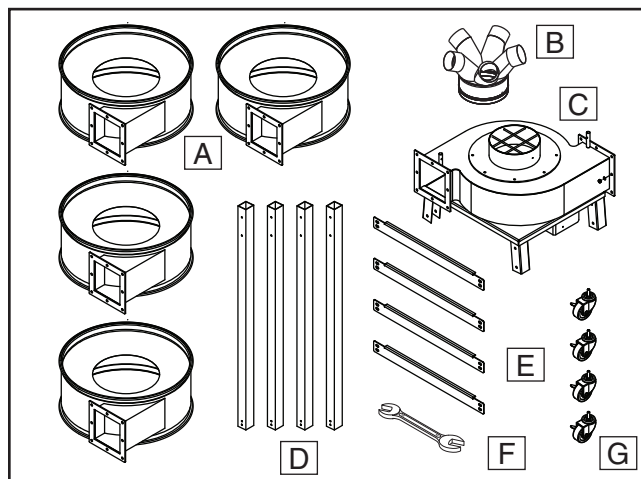


Figure 5. G0673 Inventory 1.

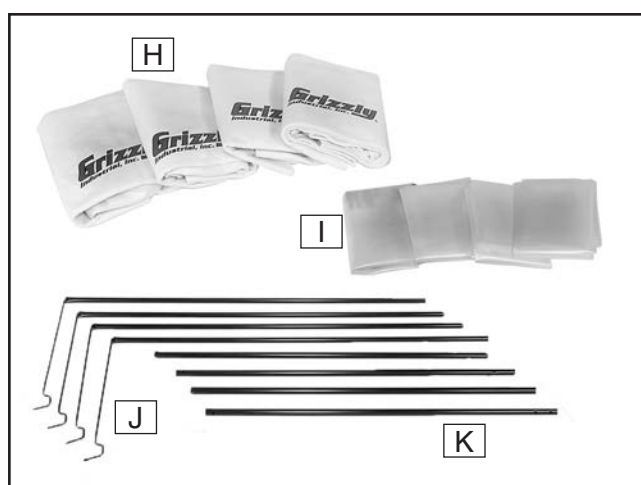


Figure 6. G0673 Inventory 2.

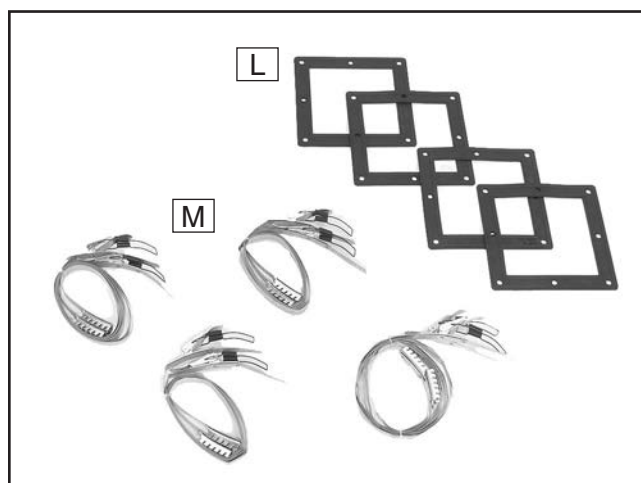


Figure 7. G0673 Inventory 3.



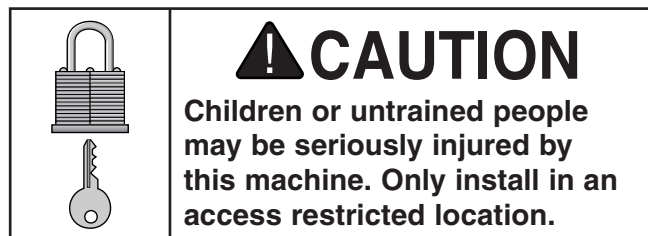
Site Considerations

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.**



Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

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

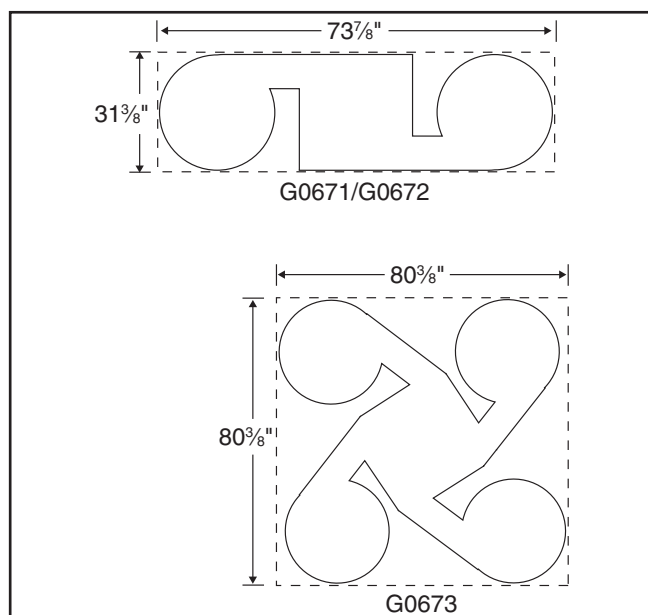


Figure 1. Model G0671-3 illustrated top view and suggested clearances.



Assembly

To assemble the dust collector:

1. With assistance, place the impeller housing on the floor so that the motor is pointing up.
2. Insert the legs into the leg mounting brackets and secure them with the eight $\frac{5}{16}$ "-18 x $2\frac{1}{2}$ " hex bolts and $\frac{5}{16}$ "-18 hex nuts, as shown in **Figure 8**. Do not yet fully tighten the nuts.

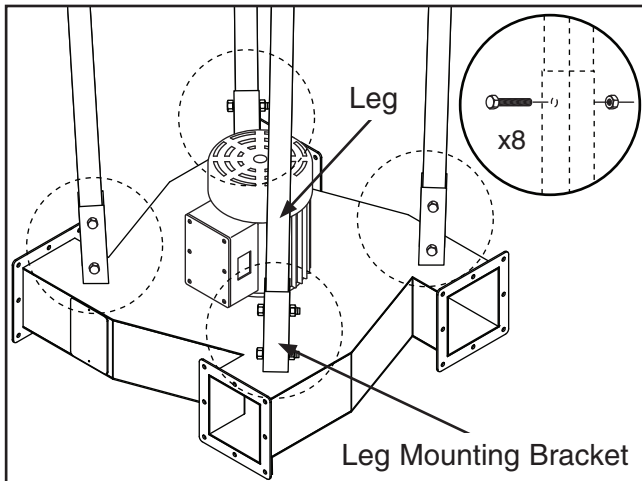


Figure 8. Attaching legs to impeller housing (Model G0673 shown).

3. Attach the four leg braces to the legs with the (16) $\frac{5}{16}$ "-18 x $\frac{1}{2}$ " hex bolts, as shown in **Figure 9**. Fully tighten the bolts and the hardware from **Step 2**.

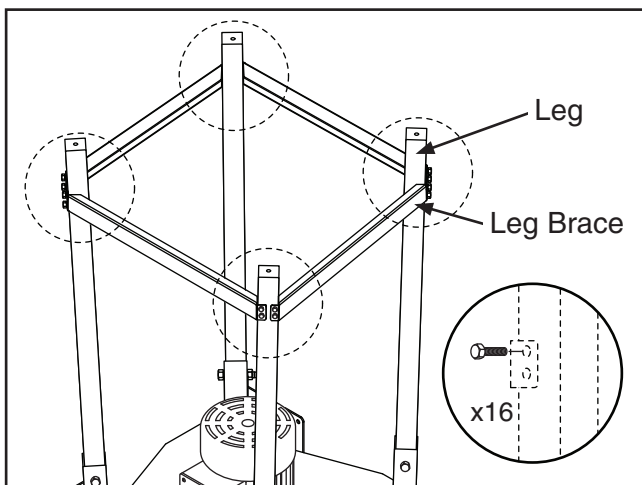


Figure 9. Attaching leg braces.

4. Attach the four casters to the legs by threading them into the bottom of the legs, as shown in **Figure 11**.

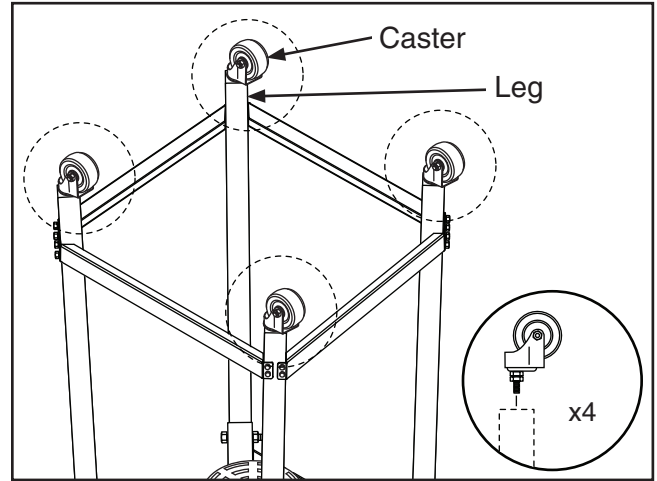


Figure 10. Attaching casters.

5. With assistance, turn the entire assembly over so that the casters rest on the floor.
6. Use (8) $\frac{5}{16}$ "-18 x 1" hex bolts, (16) $\frac{5}{16}$ " flat washers, and (8) $\frac{5}{16}$ "-18 hex nuts to attach each collector to the impeller housing with a rubber gasket between the components, as shown in **Figure 11**.

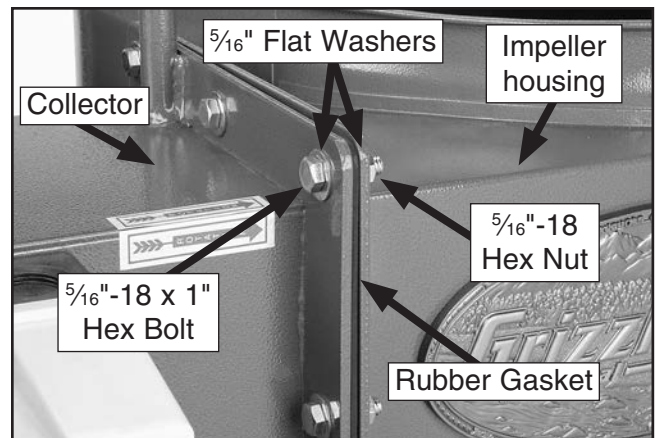


Figure 11. Collector mounted to impeller housing.



Note: The Model G0673 is a three-phase machine. If it is wired out of phase, the machine may not function properly. Proceed to **Test Run** on **Page 26** to determine if your machine is wired in phase, then proceed to **Step 7**.

The Models G0671 and G0672 are single phase and cannot be wired out of phase. For these models, continue below.

7. Attach the inlet to the top of the impeller housing with the #10-24 x 3/8" Phillips head screw, as shown in **Figure 12**.

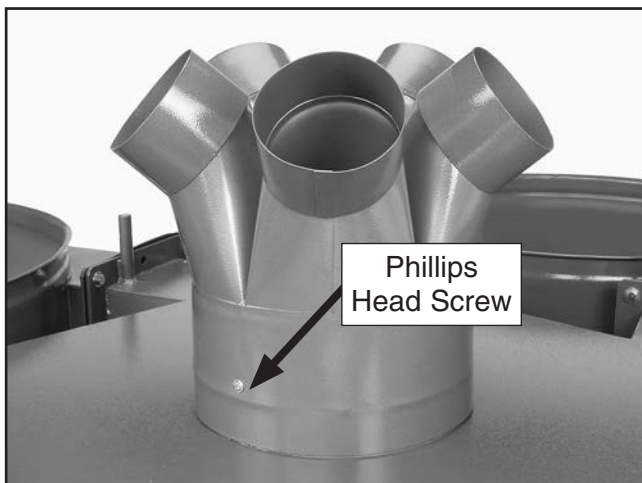


Figure 12. Inlet mounted on impeller housing.

8. Secure the hanger into the hanger support with one (Model G0673) or two (Model G0671/G0672) 1/4"-20 x 1/2" hex bolts (see **Figure 13**).

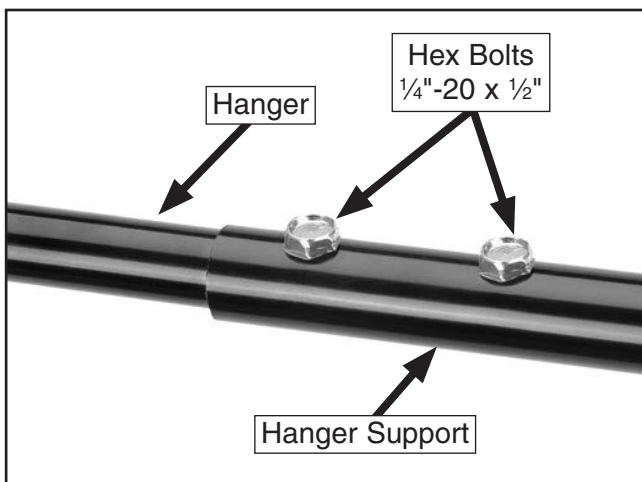


Figure 13. Hanger attached to hanger support (G0671/G0672 shown).

9. Mount the hanger assembly on the protruding rod on the collector with one (Model G0671/G0672) or two (Model G0673) 1/4"-20 x 1/2" hex bolts, as shown in **Figure 14**.

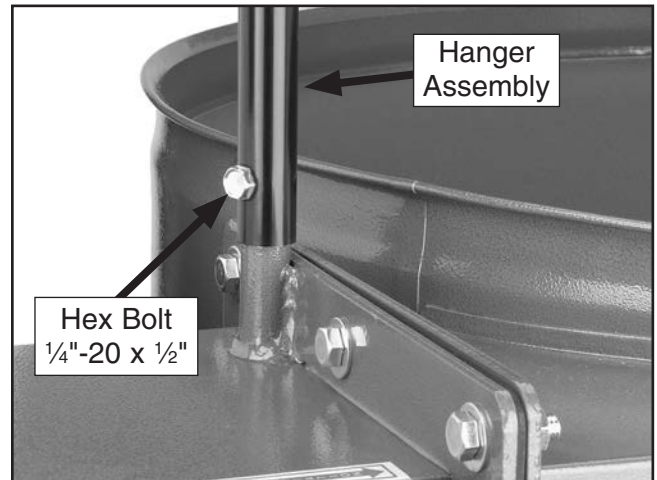


Figure 14. Hanger assembly mounted onto collector (G0671/G0672).

10. Align the hanger assembly so that the hook is directly over the center of the collector.
11. Repeat **Steps 8–10** for the remaining hanger assemblies.
12. Place the loop at the top of each upper collection bag over each hook on the hanger assemblies (see **Figure 15**).

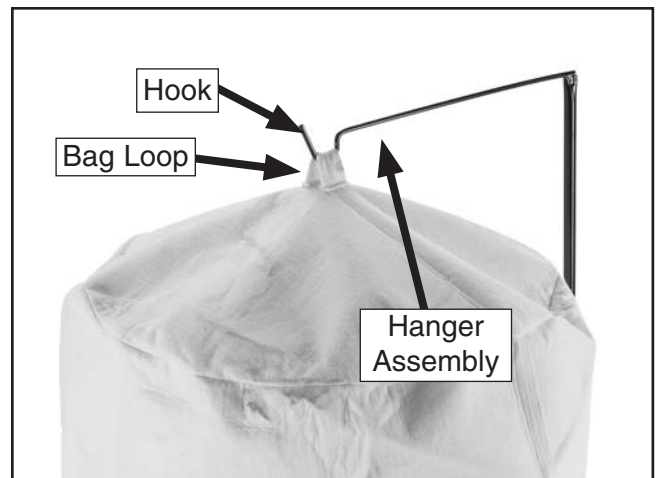


Figure 15. Upper filter bag mounted on hanger assembly.



13. Thread the bag clamp into and around the bottom seam of the upper collection bag (see **Figure 16**).



Figure 16. Upper filter bag secured to collector.

14. Slip the bottom of the bag with the clamp over the top lip of the collector.
15. Fasten the locking mechanism of the bag clamp to secure the bag to the collector (see **Figure 16**).
16. Repeat **Steps 12–15** for the remaining upper bags.
17. Install the lower bags.

—**Model G0671:** Repeat **Steps 12-15** in a similar manner to install the remaining lower collection bags on the lower rims of each collector. Then, proceed to **Test Run** on **Page 26**.

—**Model G0672-73:** Slip the lower plastic collection bag over the bottom lip of the collector and position the bag evenly around the collector. Snag the bag on the hooks to hold it in place until the bag clamp can be secured (see **Figure 17**).

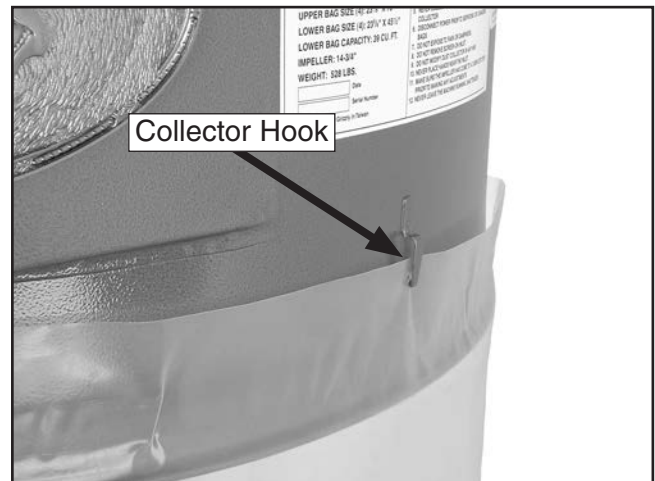


Figure 17. Bottom collection bag snagged on collector hooks.

18. Wrap the bag clamp around the collector, position it between the bottom lip of the collector and the hooks, and fasten the bag clamp to secure the bag to the collector (see **Figure 18**).

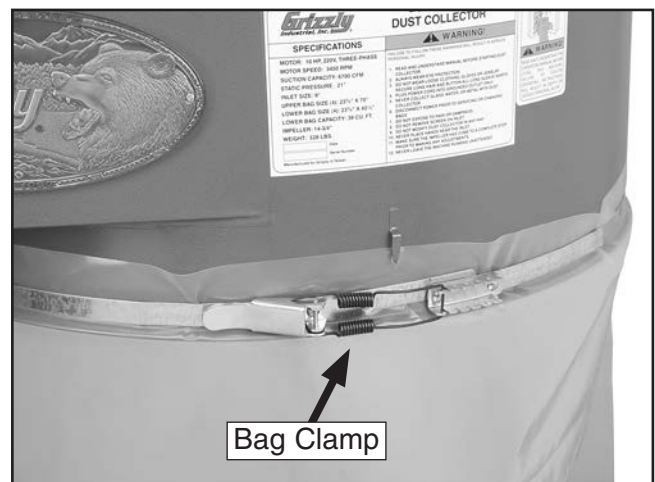


Figure 18. Lower collection bag secured to collector.

19. Repeat **Steps 16 & 17** for the remaining Model G0672-73 lower bag assemblies.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) (Model G0673 only), the motor turns the correct direction (machine is not wired out of phase).

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 40**.

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

WARNING

Before starting the dust collector, make sure you have performed the preceding assembly instructions, and you have read through the rest of the manual and are familiar with the various functions and safety features on this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the machine:

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. Connect the machine to the power source.
4. Turn the machine **ON** by pushing in the GREEN button on the power switch.

5. Listen to and watch for abnormal noises or actions. The machine should run smoothly with little or no vibration or rubbing noises.

—Strange or unusual noises should be investigated and corrected before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

6. Turn the machine **OFF** by pushing in the RED button on the power switch.

7. **Model G0673 Only:** Verify that the power is not connected out of phase by starting/stopping the machine and determining if the motor turns in the correct direction, using the criteria below:

—If the impeller turns counterclockwise (when looking down on the inlet port on the impeller housing), it is turning in the correct direction.

—If the impeller turns clockwise, it is turning in the wrong direction. Stop the machine, shut off the power source, then swap any two of the three power wires that connect to the machine.



SECTION 4: DESIGNING THE SYSTEM

General

The Model G0671/G0672/G0673 can be operated as either a stationary or mobile unit. There are advantages and disadvantages to both set-ups. The advantage of the mobile system is eliminating the cost of many ducts and fittings. On the other hand, the stationary system is more versatile and convenient.

The Model G0671/G0672/G0673 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. These machines can accommodate the following number of machines each drawing 400 CFM on a 4" dust port:

G0671:	8
G0672:	9
G0673:	12

The large suction capacity of the Model G0671/G0672/G0673 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*.

A 4-port inlet is included with the Model G0671/G0672 and a 5-port inlet is included with the Model G0673 for quick and economical dust collection setup. However, depending upon your system design using this feature, bags may fill at different rates requiring you to empty some bags more often than others.

Whatever system 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 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 (see **Figure 19**) 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.

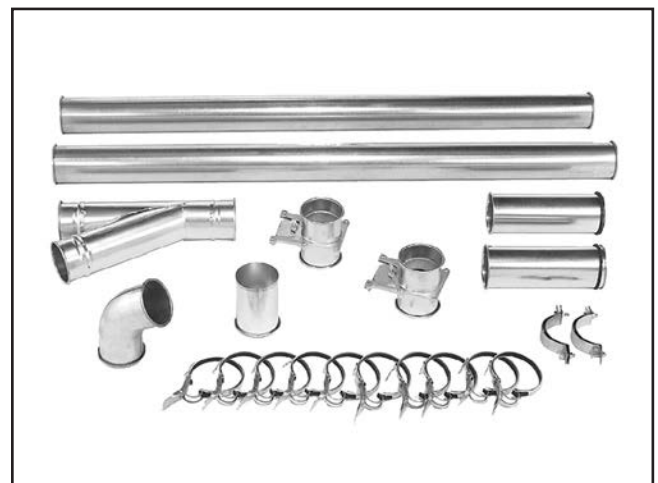


Figure 19. Examples of metal pipe and components.



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 machines. See the **Accessories** section on **Page 36** 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.

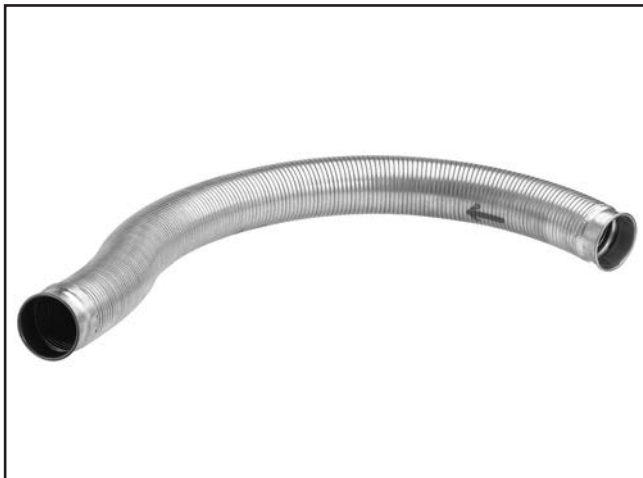


Figure 20. Example of flexible metal duct.

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 21. 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 that you perform 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 22**, including all your current/planned machines and your planned placement of the dust collector.

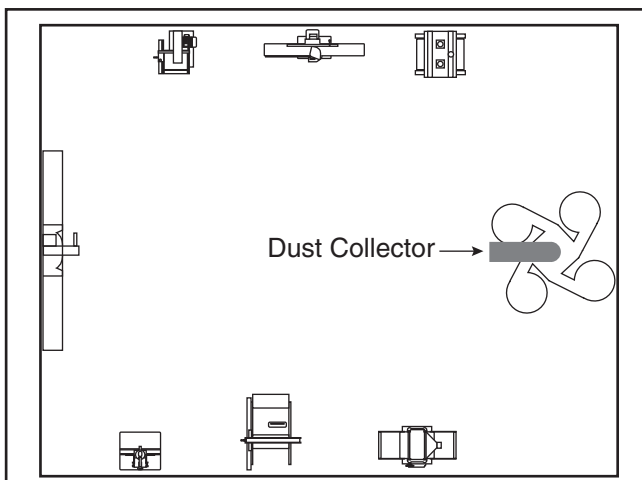


Figure 22. Initial sketch of shop layout.

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. Ideally, you should design the duct system to have the shortest possible main line and secondary branch ducts. See **Figures 23 & 24** for ideas of good duct layouts vs bad duct layouts.

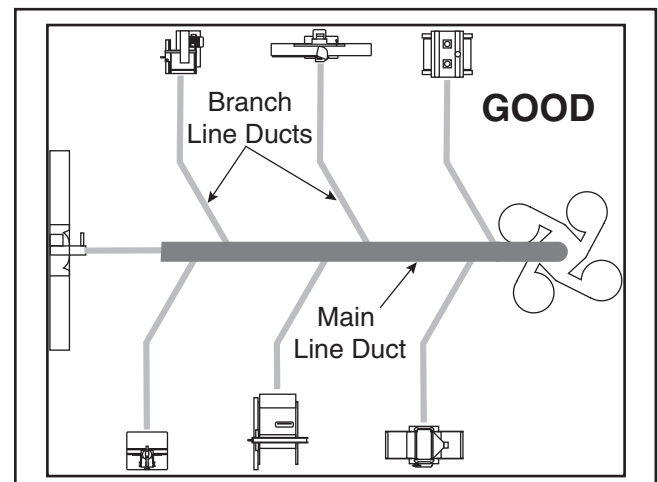


Figure 23. Good duct layout.

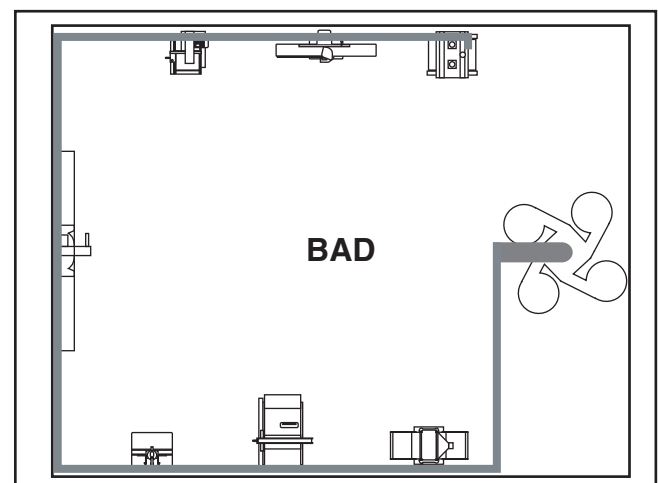


Figure 24. Bad duct layout.



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

If your machine does not have a built in dust port, use **Figure 26** 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 26. Dust port size and quantity per average machine.

Write the required CFM for each machine on your sketch, as shown in **Figure 27**.

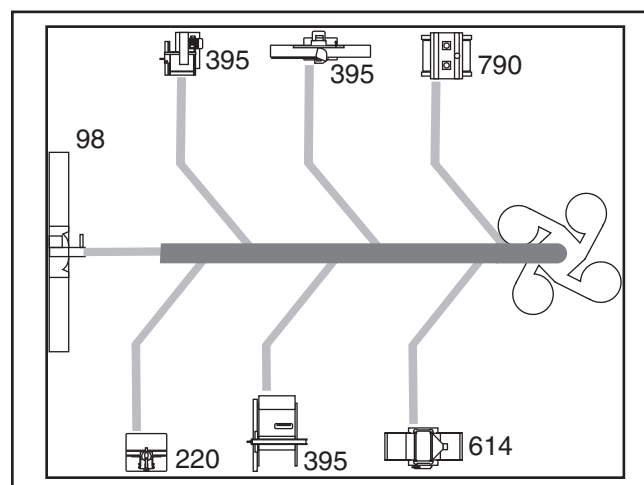


Figure 27. CFM requirements labeled for each machine.



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.

Use the inlet size of the dust collector as a starting point for the main line. Neck the main line down 1" for every 10' of length. This 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 G0671/G0672/G0673 this is 10". Mark your drawing, as in **Figure 28**.

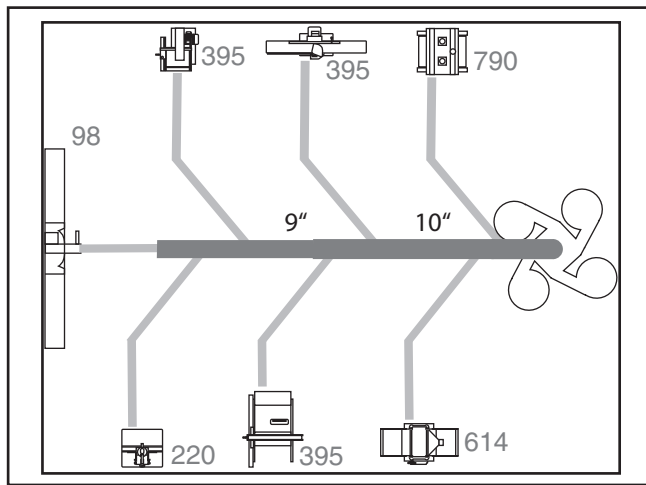


Figure 28. Main line size labeled on sketch.

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 reduce the line 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 29**.

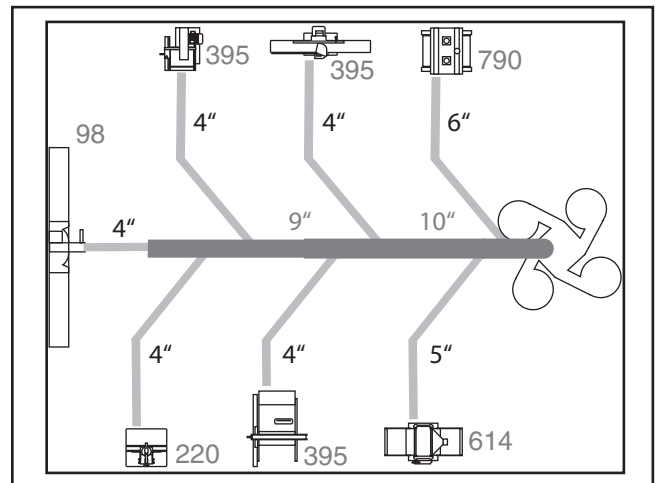


Figure 29. Branch line sizes labeled on sketch.

Multiple Dust Ports

If your machine has multiple dust ports, add the total CFM given for each dust port size from **Figure 25**. Refer to **Figure 30** and find the CFM that is closest to your total to determine the correct branch size. Split the branch line just before the dust ports with matching duct sizes.

Two Machines on Same Branch Line

If both machines will be running at the same time, add the total CFM given for each dust port size from **Figure 25**.

If both the machines will never be run at the same time, reference the machine with biggest dust port to **Figure 30** and add blast gates after the Y-branch to open/close the line to each machine.

Total CFM	Branch Line Size
<500	4"
600	5"
700	5"
800	6"
1000	6"
1200	7"
1400	8"
1600	8"

Figure 30. 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 is 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 32** 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 31. Static pressure loss charts.

In most small/medium shops it is only necessary to calculate FPM for the line (from the dust collector to the machine) 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).

The line with the longest duct length and most fittings in our system sketch (see **Figure 27**) is the one connected to the router table, which draws 220 CFM.

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 31**.
2. List each type of elbow or branch and multiply the quantity (if more than one) by the static pressure loss given in **Figure 31**.
3. Add the additional factors from **Figure 32** to your list.

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

Figure 32. Additional factors affecting static pressure loss.

Continued on next page →



4. Total your list, as shown in the example in **Figure 33**, 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 33. 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 closest CFM given in the **Performance Curve** section on the **Machine Data Sheet** (located toward the front of this manual).

Example: go to the Model G0671 Data Sheet *Performance Curve* section (see **Page 4**) or **see Figure 34** and find 4.4 on the Pressure axis, then go up the CFM axis to the closest value—approximately 3550 CFM, as shown in **Figure 34**.

The 3550 CFM (**Figure 34**) for the static pressure loss of the line connected to the router is well above the 220 CFM requirement of that machine.

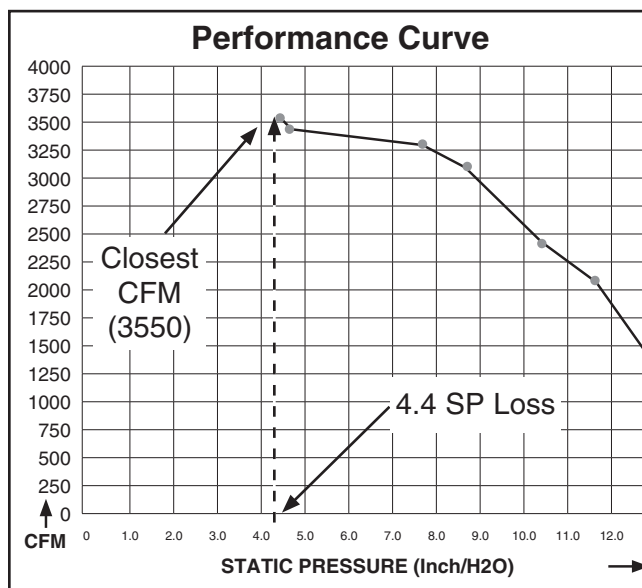


Figure 34. CFM for static pressure loss of line connected to G0671 dust collector & router.

—If the CFM for your static pressure loss is above the requirement of the machine connected to the end of that branch line, then dust collection will most likely be successful. Congratulations! You've just designed your own dust system. Refer to the **Accessories** section on **Page 36** to start buying the components necessary to make your system a reality.

—If the CFM for your static pressure loss is below the requirement of the machine, 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



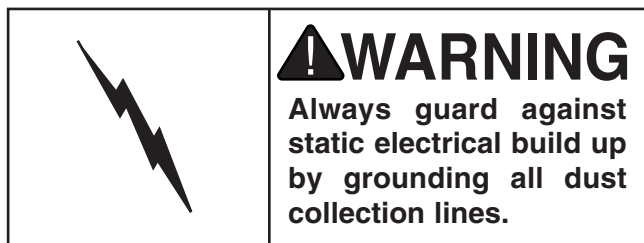
System Grounding

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

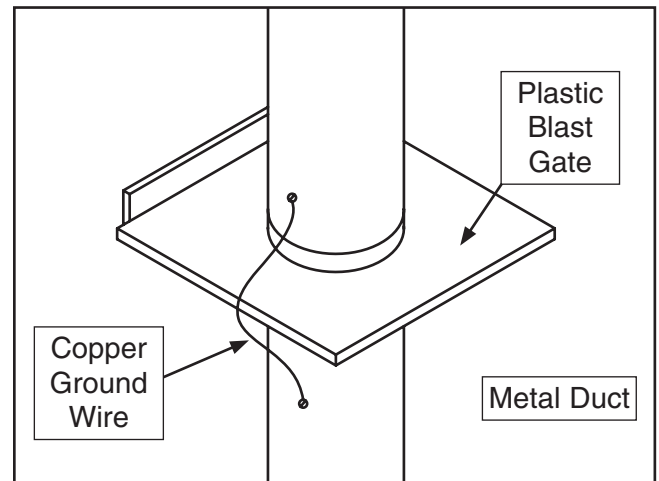


Figure 35. Ground jumper wire when using plastic blast gates and metal duct.

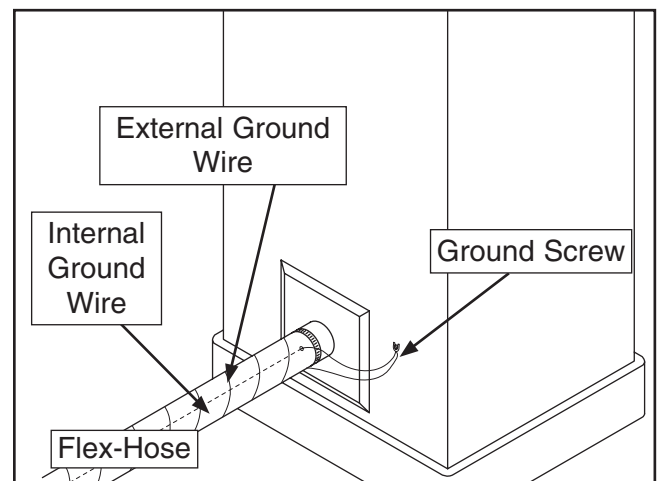


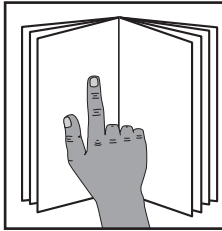
Figure 36. Flex-hose grounded to machine.

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 36**. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.



SECTION 5: OPERATIONS

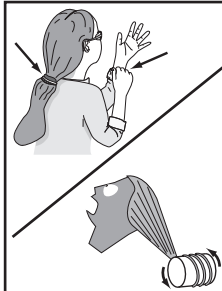
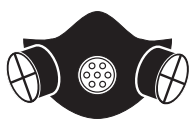


!WARNING

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

!WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



!WARNING

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

NOTICE

If you are not experienced with this type of machine, **WE STRONGLY RECOMMEND** that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Controls

This section covers the basic controls used during routine operations:

ON Button: Starts the motor.

OFF Button: Stops the motor.

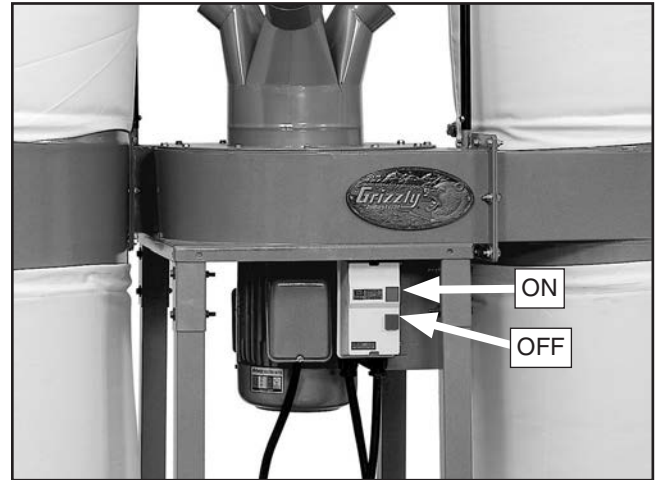


Figure 37. ON/OFF button locations.

General

Operating your Model G0671/G0672/G0673 is simple and straightforward. Blast gates located at each of the woodworking machines control the airflow 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.

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



SECTION 6: ACCESSORIES

!WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

G0673036—Mag Switch 3-Phase 440V for Model G0673 Conversion

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.

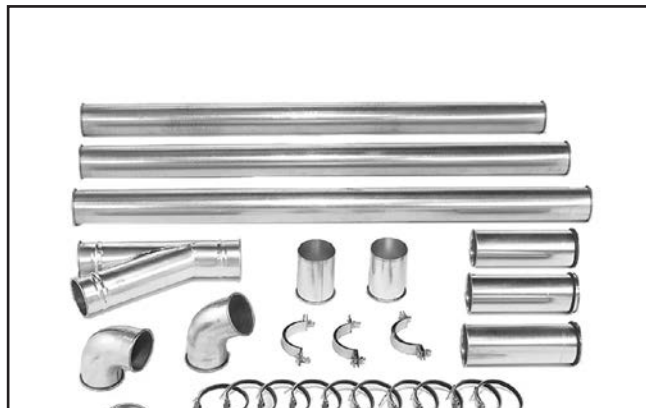


Figure 38. Metal Duct Starter Kit.

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.

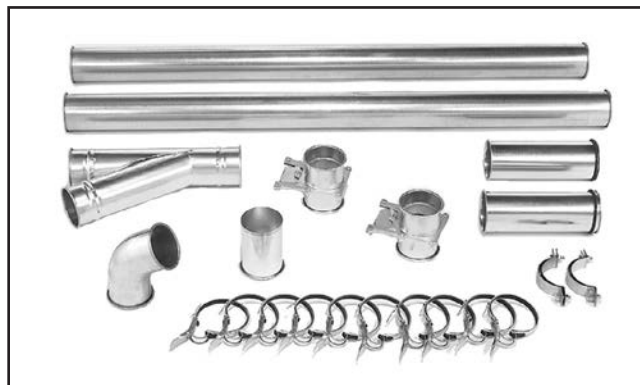


Figure 39. Metal Duct Machine Addition Kit.

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 40. Metal Blast Gate.

order online at www.grizzly.com or call 1-800-523-4777



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.

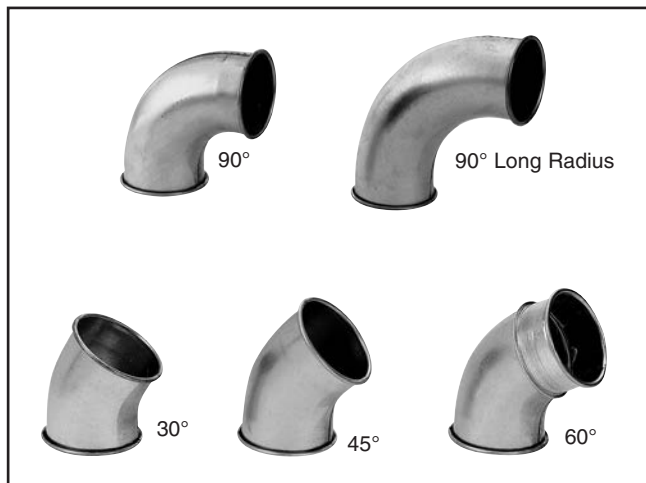


Figure 41. Metal elbow examples.

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 42. Straight Metal Pipe.

Metal Branches

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



Figure 43. Metal Branches.

Reducers & Adapters

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



Figure 44. Metal Reducers & Adapters.

G7979—Phase Converter for Model G0673

Add 3-phase multi-motor capability to your single-phase electrical supply! Operate single or multiple motors, transformers, and resistance loads at 100% power and 95% efficiency while saving big dollars at cheaply-metered single-phase electrical rates.

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.

order online at www.grizzly.com or call 1-800-523-4777



H4978—Deluxe Earmuffs - 27dB**H4979—Twin Cup Hearing Protector - 29dB****T20446—Ear Plugs 200 Pair - 31dB**

Protect your hearing before its too late. Especially important if you or employees operate for hours at a time.



Figure 45. Hearing protection assortment.

T10115—Benchtop Downdraft Table**G3119—4" x 2½" Adapter**

Want to stop making such a mess when sanding? This benchtop downdraft table is the perfect solution. Just connect the 2½" dust port in the back to a dust collector or Shop•Vac, and the suction will pull all dust and chips down into the table, keeping your work area tidy and clean.



Figure 46. T10115 Benchtop Downdraft Table.

G0572—Hanging Air Filter With Remote

This Hanging Air Filter has a convenient remote control and features a three speed motor, automatic shutoff timer and 1 micron inner filter and 5 micron outer filter. Air flow is 556, 702, and 1044 CFM.



Figure 47. G0572 Hanging Air Filter.

T10117—Big Mouth Dust Hood with Stand

Capture dust from any machine operation with this Big Mouth Dust Hood. Simply attach a 4" dust collection hose and adjust the hood right where you need it. The free standing base eliminates complicated machine set-ups and the tilting 16⅜" x 12⅞" hood adjusts from 23" to 43" high. Every shop needs one of these!

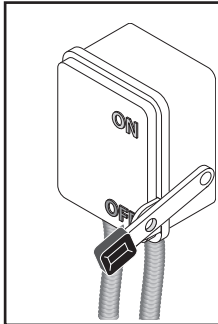


Figure 48. T10117 Big Mouth Dust Hood.

order online at www.grizzly.com or call 1-800-523-4777

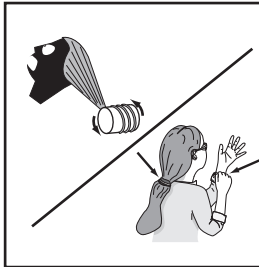


SECTION 7: MAINTENANCE



!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.

Schedule

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

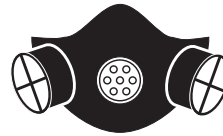
Daily Check:

- Dust collector is completely powered down at the end of use.
- Loose mounting bolts.
- Worn switch or wires.
- Any other condition that would hamper the safe operation of this machine.
- Empty the lower collection bags before they become 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



!CAUTION

All dust collectors disperse fine dust which may cause allergic reactions or respiratory problems. Always wear a respirator when operating your dust collector.

Empty the lower collection bags on a regular basis to maintain dust collection efficiency.

Always wear the appropriate respirator or dust mask and safety glasses when emptying the collection bags. 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.

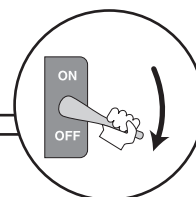
While the Model G0671/G0672/G0673 excels at collecting the majority of wood dust produced by your machines, we always recommend the supplemental aid of a shop air filter. Air filters are designed to collect the smaller airborne dust particles that a dust collector bags cannot trap.



SECTION 8: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** Please gather the serial number and manufacture date of your machine before calling.

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Plug/receptacle is at fault or wired incorrectly. 2. Motor connection wired incorrectly. 3. Thermal overload relay has tripped. 4. Contactor not getting energized/has burnt contacts. 5. Power supply is at fault/switched OFF. 6. Motor ON button or ON/OFF switch is at fault. 7. Centrifugal switch is at fault. 8. Wiring is open/has high resistance. 9. Motor is at fault.	1. Test for good contacts; correct the wiring. 2. Correct motor wiring connections. 3. Turn cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times (weak relay). 4. Test for power on all legs and contactor operation. Replace unit if faulty. 5. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 6. Replace faulty ON button or ON/OFF switch. 7. Adjust/replace the centrifugal switch if available. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Test/repair/replace.
Machine stalls or is underpowered.	1. Motor connection is wired incorrectly. 2. Plug/receptacle is at fault. 3. Motor bearings are at fault. 4. Motor has overheated. 5. Contactor not getting energized or has poor contacts. 6. Motor is at fault. 7. Centrifugal switch is at fault.	1. Correct motor wiring connections. 2. Test for good contacts; correct the wiring. 3. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 4. Clean off motor, let cool, and reduce workload. 5. Test for power on all legs and contactor operation. Replace if faulty. 6. Test/repair/replace. 7. Adjust/replace centrifugal switch if available.
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. Motor fan is rubbing on fan cover. 3. Motor mount loose/broken. 4. Motor bearings are at fault. 5. Centrifugal switch.	1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Replace dented fan cover; replace loose/damaged fan. 3. Tighten/replace. 4. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 5. Replace.



Dust Collection Operation

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Loud, repetitious noise, or excessive vibration coming from dust collector.	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.	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 is damaged. 5. Replace motor fan cover.
Dust collector does not adequately collect dust or chips; poor performance.	1. Dust collection bag is full/filter bag is dirty. 2. There is a restriction in the duct line. 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 are not enough open branch lines at one time, thereby causing a velocity drop in the main line. 7. The ducting and ports are incorrectly sized. 8. The machine dust collection design is inadequate. 9. The dust collector is too small for the dust collection system.	1. Empty collection bag/clean or replace filter bag. 2. Remove dust line from dust collector inlet and unblock the restriction in the duct line. A plumbing snake may be necessary. 3. Relocate the dust collector closer to the point of suction, and rework ducting without sharp bends. Refer to Designing the System, beginning on Page 27. 4. Process lumber with less than 20% moisture content. 5. Rework the ducting to eliminate all leaks. Close dust ports for lines not being used. Refer to Designing the System on Page 27 for more solutions. 6. Open 1 or 2 more blast gates to different branch lines to allow the velocity in the main line to increase. 7. Reinstall correctly sized ducts and fittings. Refer to Designing the System on Page 27 for more solutions. 8. Use a dust collection nozzle on a stand. 9. Install a larger dust collector to power your dust collection system.
Sawdust being blown into the air from the dust collector.	1. Bag clamps, dust collection bag, or filter bag is not properly secured.	1. Reclamp the dust collection bag and air filter bag, making sure bag clamps are tight and completely over the bags.



SECTION 9: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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

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

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

NOTICE

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

COLOR KEY

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



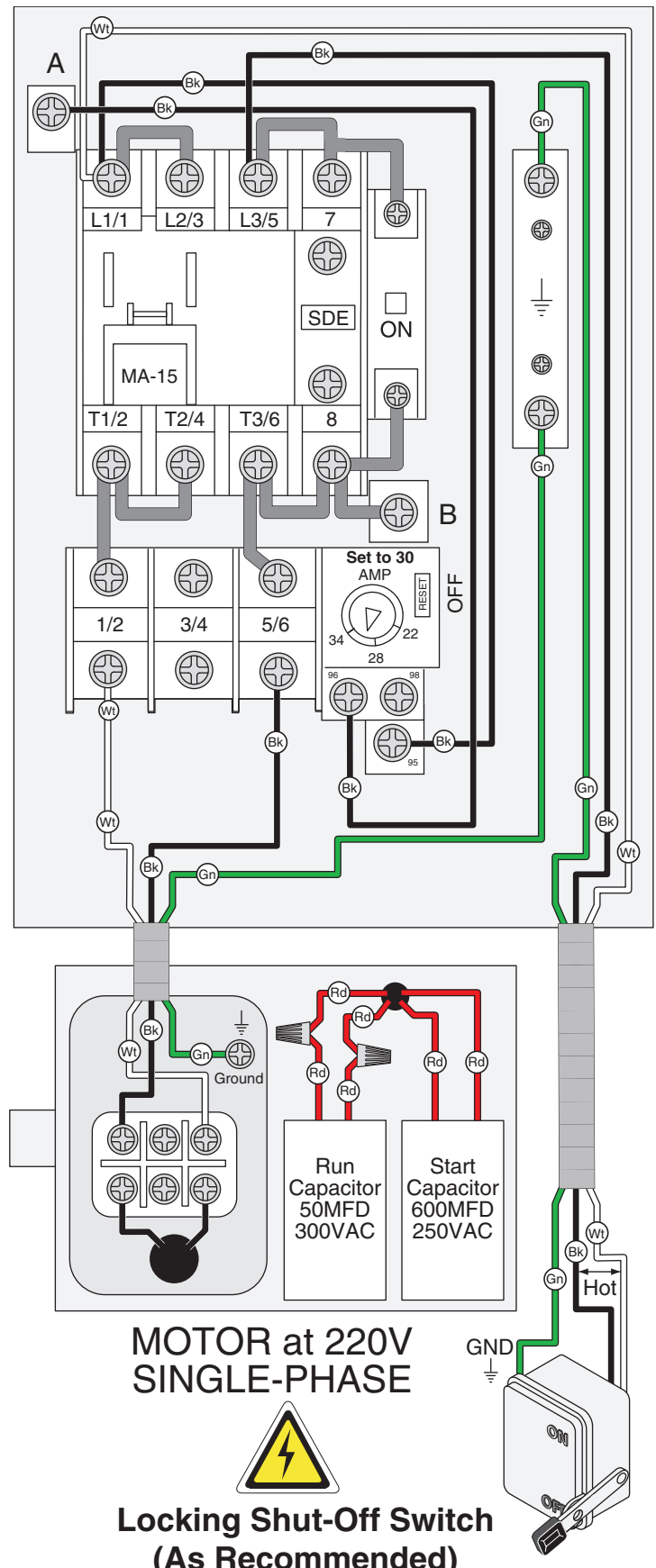
G0671 Wiring Diagram



Figure 49. G0671 MA-15 contactor.



Figure 50. G0671 motor junction box.



G0672 Wiring Diagram



Figure 51. G0672 MA-30 contactor.

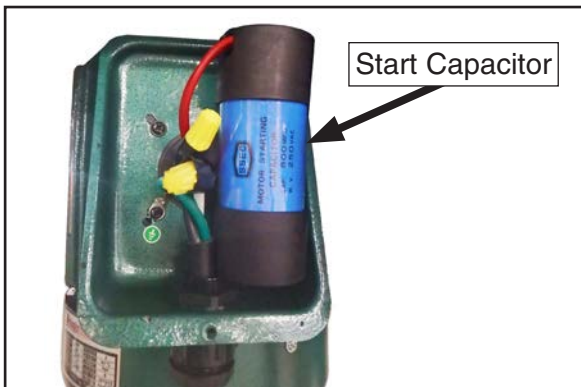


Figure 52. G0672 start capacitor.

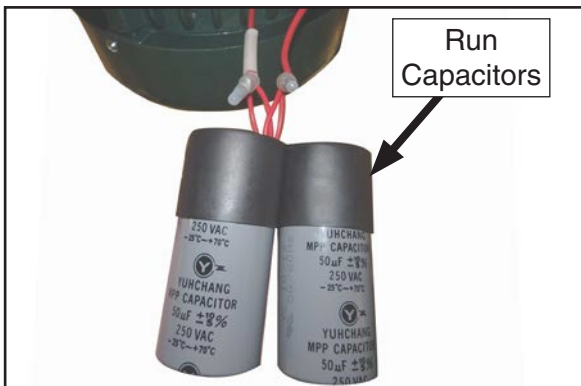
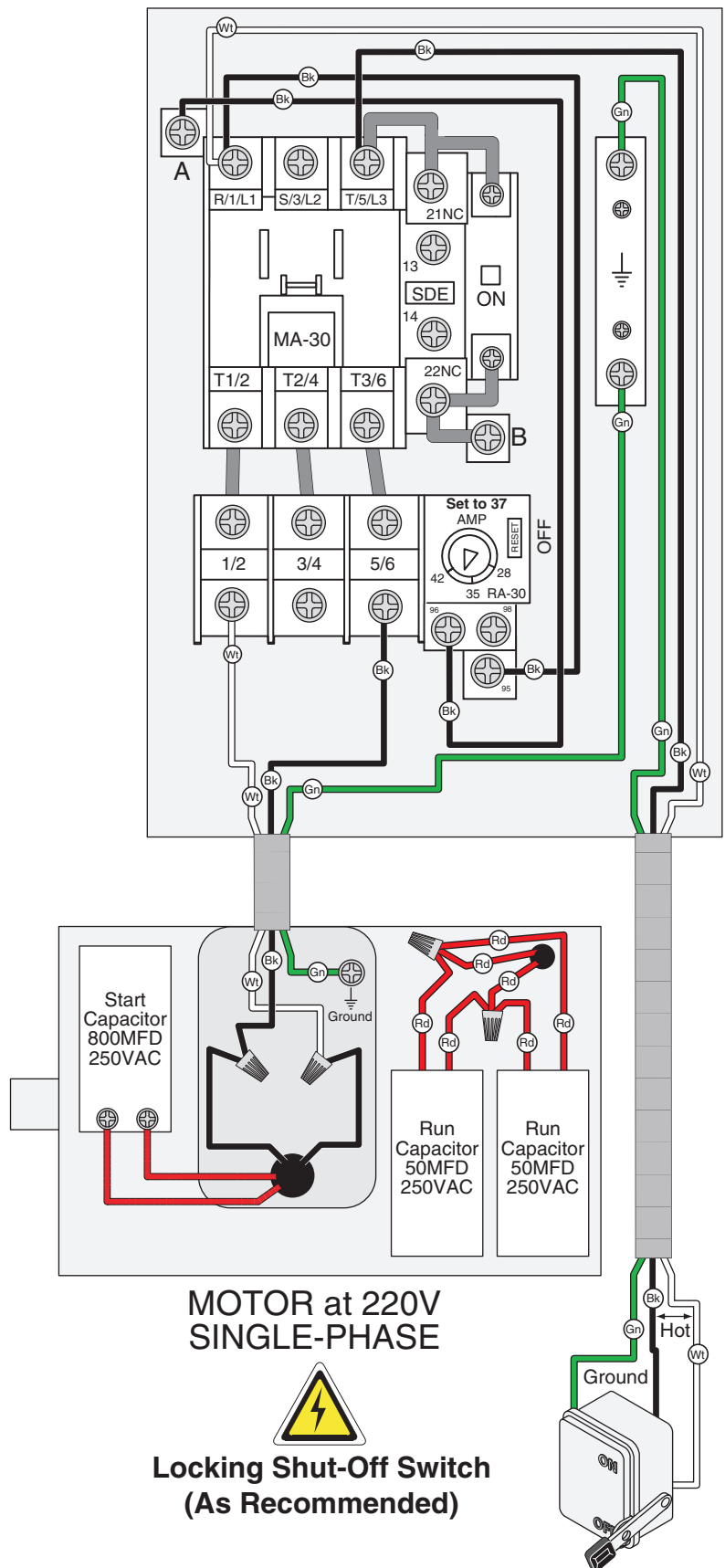


Figure 53. G0672 run capacitors.



G0673 Wiring Diagram

MOTOR DIRECTION

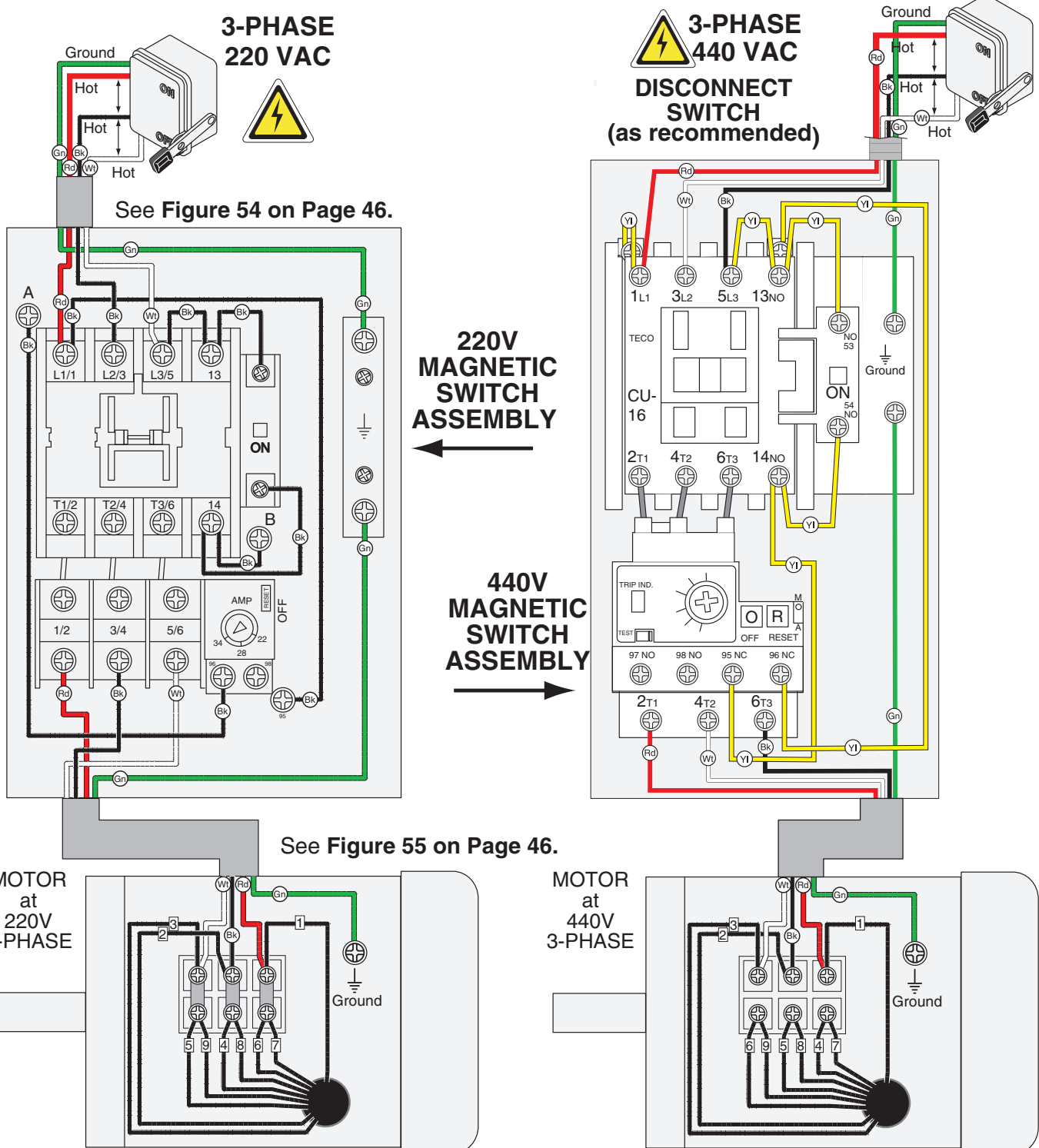
NOTICE

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



WARNING!

SHOCK HAZARD!
Disconnect power
before working on
wiring.



G0673 Electrical Components



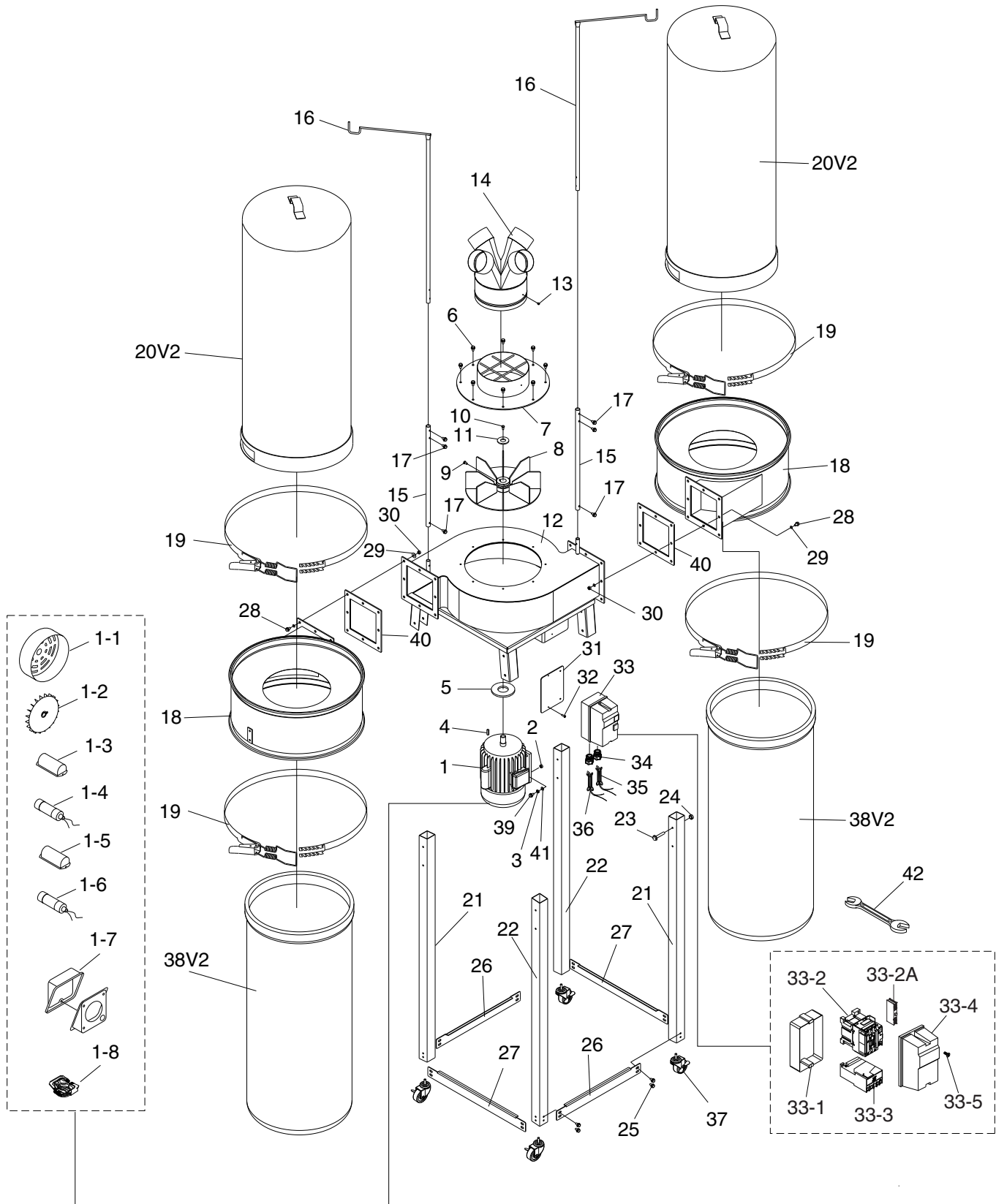
Figure 54. G0673 220V switch.



Figure 55. G0673 220V motor.

SECTION 10: PARTS

G0671 Parts Breakdown



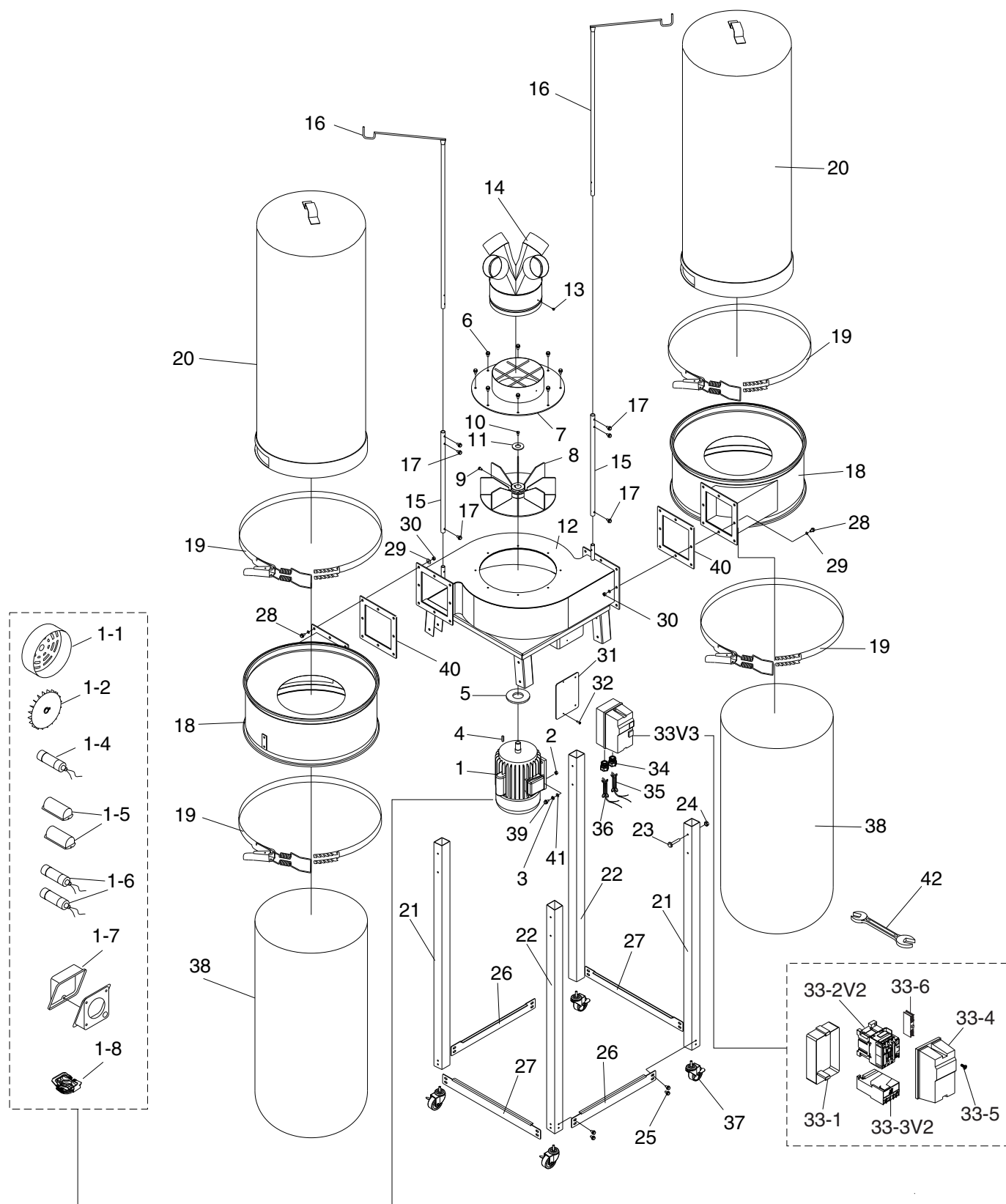
G0671 Parts List

REF	PART #	DESCRIPTION
1	P0671001	MOTOR 4HP, 220V, 1 PH
1-1	P0671001-1	FAN COVER
1-2	P0671001-2	FAN
1-3	P0671001-3	S CAPACITOR COVER
1-4	P0671001-4	S CAPACITOR 600M 250V X 1-3/4 X 3-7/8
1-5	P0671001-5	R CAPACITOR COVER
1-6	P0671001-6	R CAPACITOR 50M 300V X 1-3/4 X 2-3/4
1-7	P0671001-7	JUNCTION BOX
1-8	P0671001-8	CENTRIFUGAL SWITCH
2	P0671002	HEX NUT 3/8-16
3	P0671003	LOCK WASHER 3/8
4	P0671004	KEY 6 X 6 X 25
5	P0671005	MOTOR GASKET
6	P0671006	HEX BOLT 5/16-18 X 3/4
7	P0671007	INLET COVER
8	P0671008	IMPELLER 14-1/2"
9	P0671009	HEX BOLT 3/8-16 X 1/2
10	P0671010	CAP SCREW M6-1 X 20
11	P0671011	FLAT WASHER 6MM
12	P0671012	COLLECTOR HOUSING
13	P0671013	PHLP HD SCR 10-24 X 3/8
14	P0671014	INLET ADAPTER
15	P0671015	BAG HANGER LOWER SUPPORT
16	P0671016	BAG HANGER
17	P0671017	HEX BOLT 1/4-20 X 1/2
18	P0671018	COLLECTOR DRUM
19	P0671019	BAG CLAMP
20V2	P0671020V2	FILTER BAG 2.5 MICRON 23-5/8" X 47-1/4" V2.07.15

REF	PART #	DESCRIPTION
21	P0671021	RIGHT LEG
22	P0671022	LEFT LEG
23	P0671023	HEX BOLT 5/16-18 X 2-1/2
24	P0671024	HEX NUT 5/16-18
25	P0671025	HEX BOLT 5/16-18 X 1/2
26	P0671026	F/R LEG BRACE
27	P0671027	L/R LEG BRACE
28	P0671028	HEX BOLT 5/16-18 X 1
29	P0671029	FLAT WASHER 5/16
30	P0671030	HEX NUT 5/16-18
31	P0671031	MAGNETIC SWITCH PLATE
32	P0671032	PHLP HD SCR 10-24 X 1/2
33	P0671033	MAGNETIC SWITCH
33-1	P0671033-1	MAG SWITCH BACK COVER
33-2	P0671033-2	CONTACTOR SDE MP-15 220V
33-2A	P0671033-2A	AUXILIARY CONTACTOR SWITCH
33-3	P0671033-3	OL RELAY SDE RA-30 21-35
33-4	P0671033-4	MAG SWITCH FRONT COVER
33-5	P0671033-5	PLASTIC COVER SCREW 11/32-16 X 3/4
34	P0671034	STRAIN RELIEF
35	P0671035	MOTOR CORD 12AWG X 3C
36	P0671036	POWER CORD 12AWG X 3C
37	P0671037	CASTER WITH BRAKE
38V2	P0671038V2	LOWER DUST BAG 23-5/8" X 54" V2.07.15
39	P0671039	HEX BOLT 3/8-16 X 1-1/4
40	P0671040	RUBBER GASKET
41	P0671041	FLAT WASHER 3/8
42	P0671042	COMBO WRENCH 10 X 12MM



G0672 Parts Breakdown



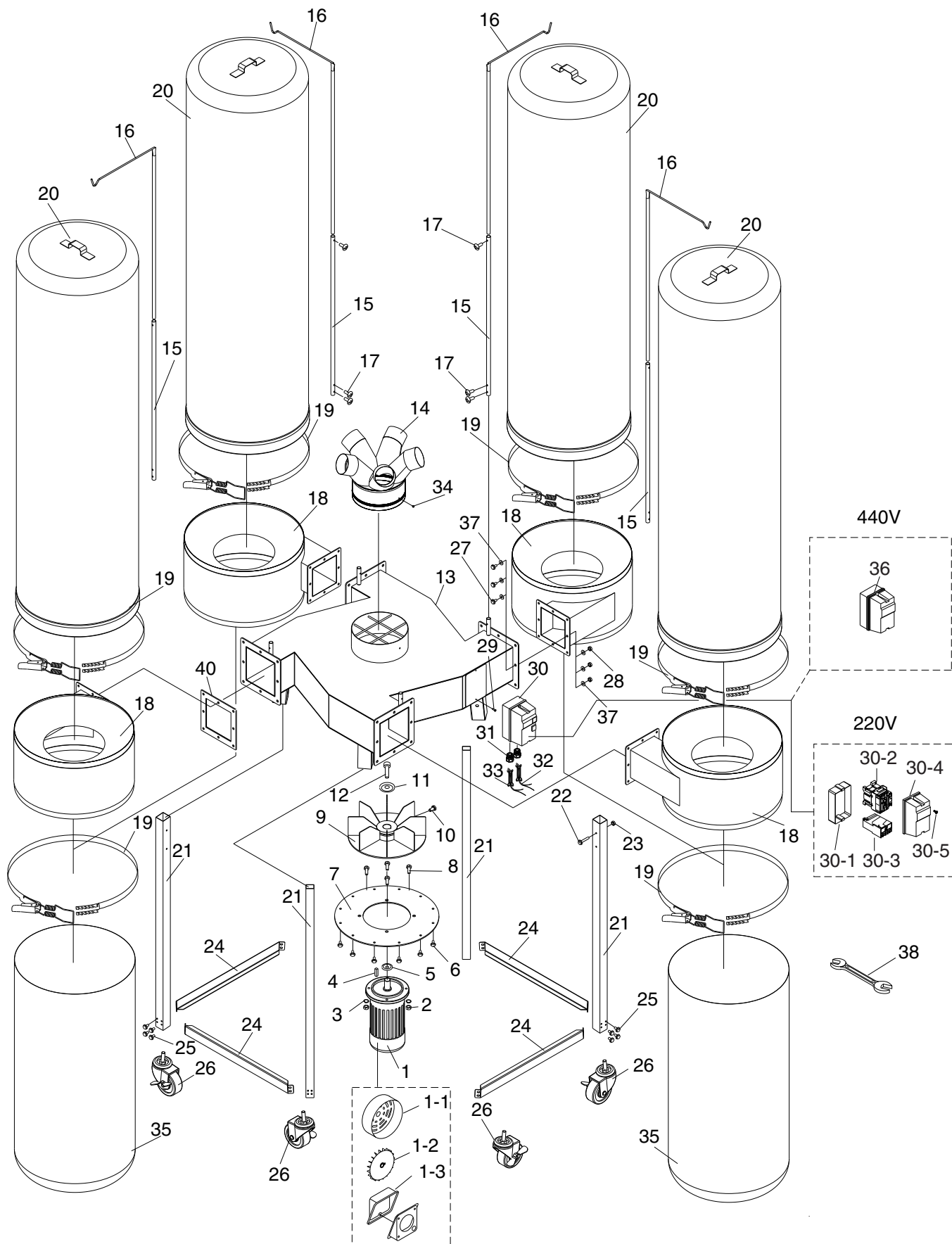
G0672 Parts List

REF	PART #	DESCRIPTION
1	P0672001	MOTOR 5HP, 220V, 1 PH
1-1	P0672001-1	FAN COVER
1-2	P0672001-2	FAN
1-4	P0672001-4	S CAPACITOR 800M 250V 1-3/4 X 3-3/4
1-5	P0672001-5	R CAPACITOR COVER
1-6	P0672001-6	R CAPACITOR 50M 250V 2 X 4-3/8
1-7	P0672001-7	JUNCTION BOX
1-8	P0672001-8	CENTRIFUGAL SWITCH
2	P0672002	HEX NUT 3/8-16
3	P0672003	LOCK WASHER 3/8
4	P0672004	KEY 6 X 6 X 25
5	P0672005	MOTOR GASKET
6	P0672006	HEX BOLT 5/16-18 X 3/4
7	P0672007	INLET COVER
8	P0672008	IMPELLER 15"
9	P0672009	HEX BOLT 3/8-16 X 1/2
10	P0672010	CAP SCREW M6-1 X 20
11	P0672011	FLAT WASHER 6MM
12	P0672012	COLLECTOR HOUSING
13	P0672013	PHLP HD SCR 10-24 X 3/8
14	P0672014	INLET ADAPTER
15	P0672015	BAG HANGER LOWER SUPPORT
16	P0672016	BAG HANGER
17	P0672017	HEX BOLT 1/4-20 X 1/2
18	P0672018	COLLECTOR DRUM
19	P0672019	BAG CLAMP
20	P0672020	FILTER BAG 2.5 MICRON 23-5/8" X 70"
21	P0672021	RIGHT LEG

REF	PART #	DESCRIPTION
22	P0672022	LEFT LEG
23	P0672023	HEX BOLT 5/16-18 X 2-1/2
24	P0672024	HEX NUT 5/16-18
25	P0672025	HEX BOLT 5/16-18 X 1/2
26	P0672026	F/R LEG BRACE
27	P0672027	L/R LEG BRACE
28	P0672028	HEX BOLT 5/16-18 X 1
29	P0672029	FLAT WASHER 5/16
30	P0672030	HEX NUT 5/16-18
31	P0672031	MAGNETIC SWITCH PLATE
32	P0672032	PHLP HD SCR 10-24 X 1/2
33V3	P0672033V3	MAGNETIC SWITCH ASSY V3.06.17
33-1	P0672033-1	MAG SWITCH BACK COVER
33-2V2	P0672033-2V2	CONTACTOR SDE MA-30 220V V2.06.17
33-3V2	P0672033-3V2	OL RELAY SDE RA-30 28-42A V2.01.13
33-4	P0672033-4	MAG SWITCH FRONT COVER
33-5	P0672033-5	PLASTIC COVER SCREW 11/32-16 X 3/4
33-6	P0672033-6	AUXILIARY CONTACTOR SWITCH
34	P0672034	STRAIN RELIEF
35	P0672035	MOTOR CORD 10AWG X 3C
36	P0672036	POWER CORD 10AWG X 3C
37	P0672037	CASTER WITH BRAKE
38	P0672038	LOWER DUST BAG 23-5/8" X 54"
39	P0672039	HEX BOLT 3/8-16 X 1-1/4
40	P0672040	RUBBER GASKET
41	P0672041	FLAT WASHER 3/8
42	P0672042	COMBO WRENCH 10 X 12MM



G0673 Parts Breakdown



G0673 Parts List

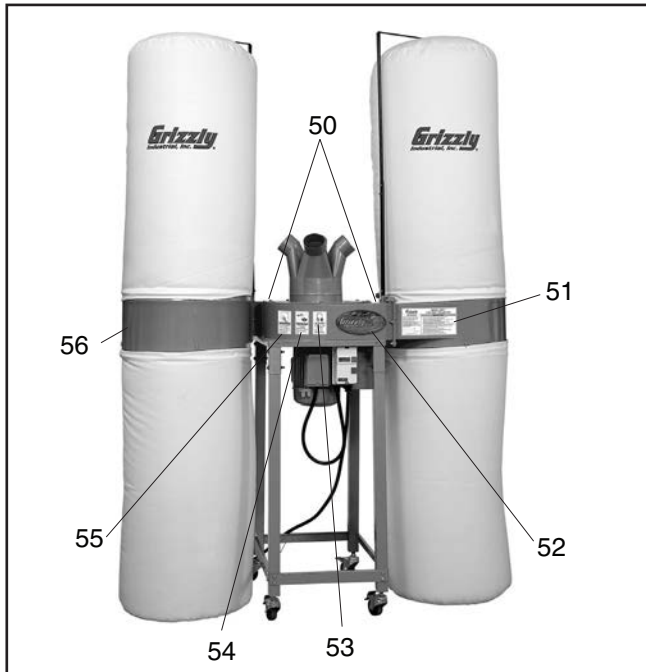
REF	PART #	DESCRIPTION
1	P0673001	MOTOR 10HP, 220V, 3 PH
1-1	P0673001-1	FAN COVER
1-2	P0673001-2	FAN
1-3	P0673001-3	JUNCTION BOX
2	P0673002	HEX NUT 1/2"-12
3	P0673003	LOCK WASHER 1/2
4	P0673004	KEY 8 X 8 X 25
5	P0673005	MOTOR GASKET
6	P0673006	HEX BOLT 5/16-18 X 3/4
7	P0673007	INLET COVER
8	P0673008	HEX BOLT 1/2 X 1-1/2
9	P0673009	IMPELLER 17"
10	P0673010	HEX BOLT 3/8-16 X 1-1/2
11	P0673011	FLAT WASHER 6MM
12	P0673012	CAP SCREW M6-1 X 20
13	P0673013	COLLECTOR HOUSING
14	P0673014	INLET ADAPTER
15	P0673015	BAG HANGER LOWER SUPPORT
16	P0673016	BAG HANGER
17	P0673017	HEX BOLT 1/4-20 X 1/2
18	P0673018	COLLECTOR DRUM
19	P0673019	BAG CLAMP
20	P0673020	FILTER BAG 2.5 MICRON 23-5/8" X 70"
21	P0673021	LEG
22	P0673022	HEX BOLT 5/16-18 X 2-1/2
23	P0673023	HEX NUT 5/16-18
24	P0673024	LEG BRACE

REF	PART #	DESCRIPTION
25	P0673025	HEX BOLT 5/16-18 X 1/2
26	P0673026	CASTER WITH BRAKE
27	P0673027	HEX BOLT 5/16-18 X 1
28	P0673028	HEX NUT 5/16-18
29	P0673029	PHLP HD SCR 10-24 X 1/2
30	P0673030	MAGNETIC SWITCH ASSY 220V
30-1	P0673030-1	MAG SWITCH BACK COVER
30-2	P0673030-2	CONTACTOR SDE MP-30 220V 3PH
30-3	P0673030-3	OL RELAY SDE RA-30 21-35
30-4	P0673030-4	MAG SWITCH FRONT COVER
30-5	P0673030-5	PLASTIC COVER SCREW 11/32-16 X 3/4
31	P0673031	STRAIN RELIEF
32	P0673032	MOTOR CORD 10AWG X 4C
33	P0673033	POWER CORD 10AWG X 4C
34	P0673034	PHLP HD SCR 10-24 X 3/8
35	P0673035	LOWER DUST BAG 23-5/8" X 54"
36	P0673036	MAGNETIC SWITCH ASSY 440V
37	P0673037	FLAT WASHER 5/16"
38	P0673038	COMBO WRENCH 10 X 12MM
40	P0673040	RUBBER GASKET
51	P0673051	MACHINE ID LABEL
52	P0673052	GRIZZLY NAMEPLATE
53	P0673053	EAR PROTECTION 2" X 3-5/16"H
54	P0673054	GLASSES/RESPIRATOR
55	P0673055	READ MANUAL-VERTICAL NS 7/05
56	P0673056	GRIZZLY GREEN TOUCH-UP PAINT
56	P0673056	GRIZZLY GREEN TOUCH-UP PAINT

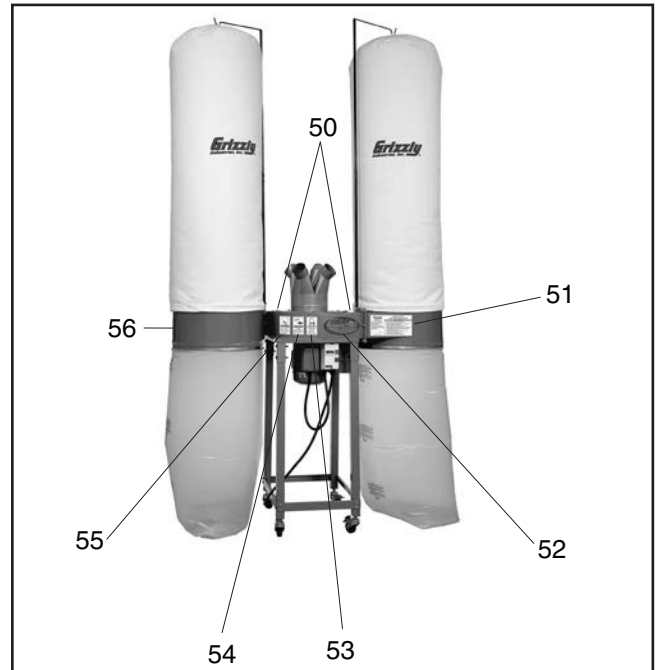


Label Placement

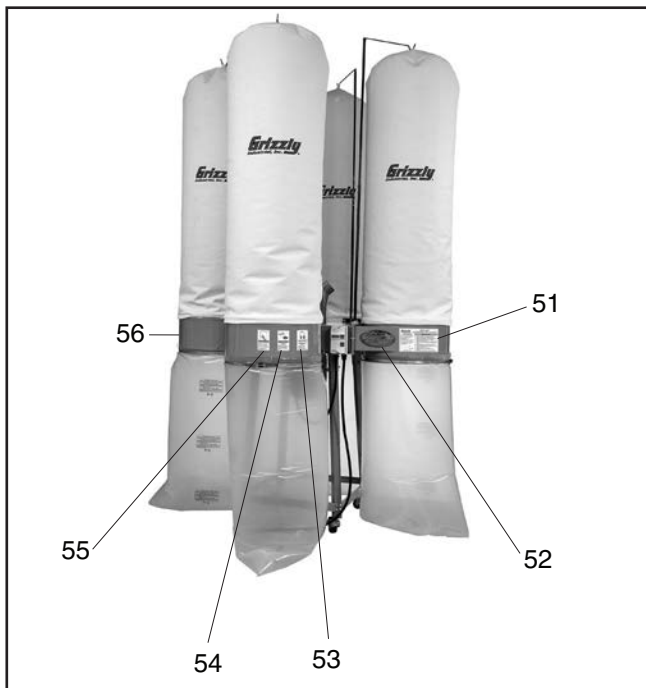
G0671



G0672



G0673



REF	PART #	DESCRIPTION
50	P0671050	HANDS INLET WARNING (G0671, G0672)
51	P0671051	MACHINE ID LABEL (G0671)
51	P0672051	MACHINE ID LABEL (G0672)
51	P0673051	MACHINE ID LABEL (G0673)
52	P0671052	GRIZZLY NAMEPLATE (G0671, G0672)
52	P0673052	GRIZZLY NAMEPLATE (G0673)
53	P0671053	EAR PROTECTION 2" X 3-5/16"H
54	P0671054	GLASSES/RESPIRATOR
55	P0671055	READ MANUAL-VERTICAL NS 7/05
56	P0671056	GRIZZLY GREEN 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 _____

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?

_____ Cabinetmaker & FDM

_____ Popular Science

_____ Wooden Boat

_____ Family Handyman

_____ Popular Woodworking

_____ Woodshop News

_____ Hand Loader

_____ Precision Shooter

_____ Woodsmith

_____ Handy

_____ Projects in Metal

_____ Woodwork

_____ Home Shop Machinist

_____ RC Modeler

_____ Woodworker West

_____ Journal of Light Cont.

_____ Rifle

_____ Woodworker's Journal

_____ Live Steam

_____ Shop Notes

_____ Other:

_____ Model Airplane News

_____ Shotgun News

_____ Old House Journal

_____ Today's Homeowner

_____ Popular Mechanics

_____ 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.



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Current Specials!*

**ORDER
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