

Grizzly ***Industrial, Inc.***®

MODEL G0826 **"EASY FEEDER"** **POWER FEEDER** **OWNER'S MANUAL** *(For models manufactured since 06/20)*



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#BL18915 PRINTED IN TAIWAN

V2.05.20



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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 safety glasses and respirator are properly adjusted/setup and	
Specification:		4. power is connected to grounded circuit before starting.	
Weight:		5. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.	
		6. DO NOT expose to rain or dampness.	
		7. DO NOT modify this machine in any way.	
		8. Make sure power is disconnected.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
		Manufactured for Grizzly in Taiwan	

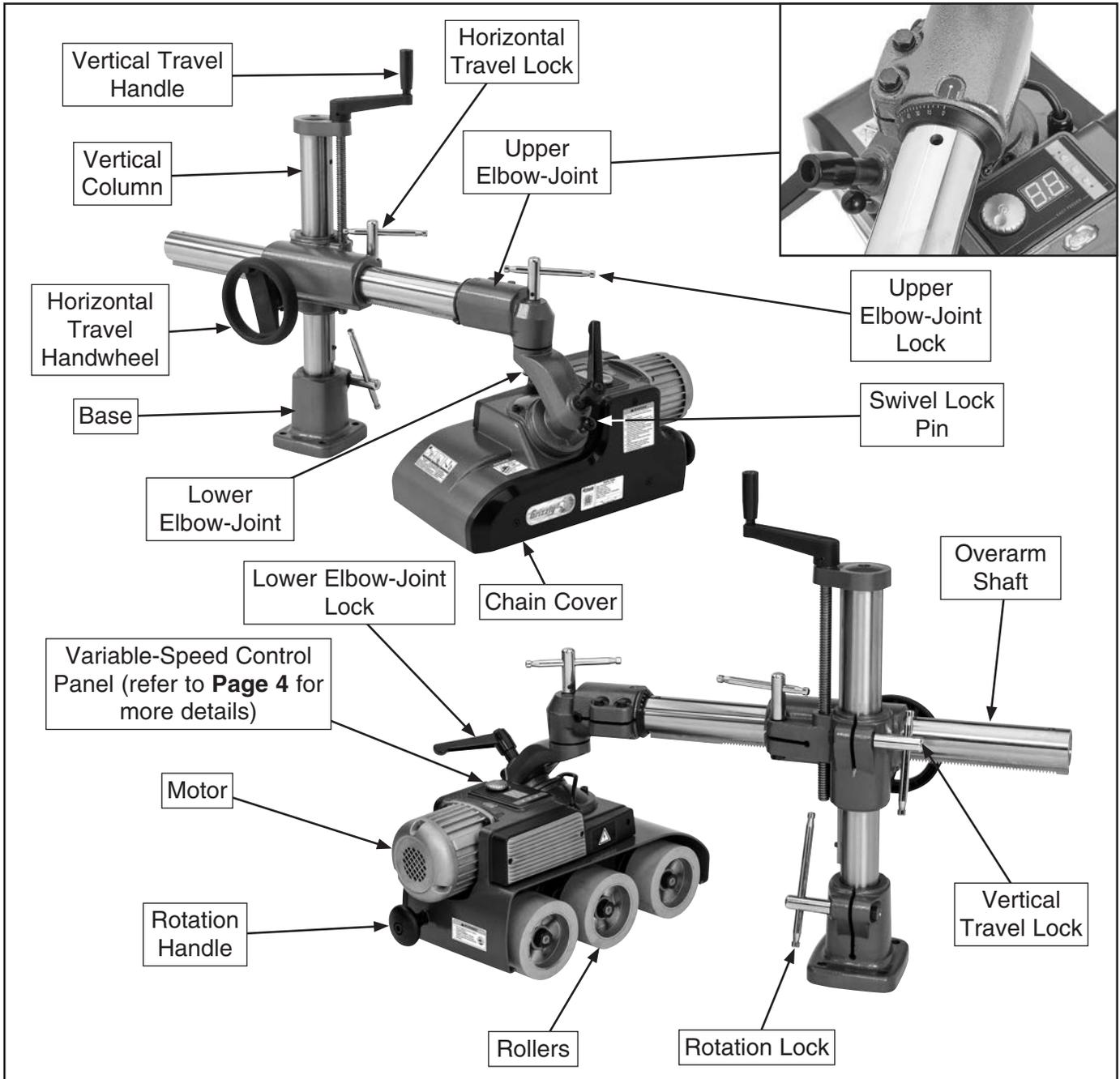
Manufacture Date

Serial Number



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



	<p>⚠ WARNING</p> <p>To reduce your risk of serious injury, read this entire manual BEFORE using machine.</p>
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Controls & Components



Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

Variable-Speed Control Panel

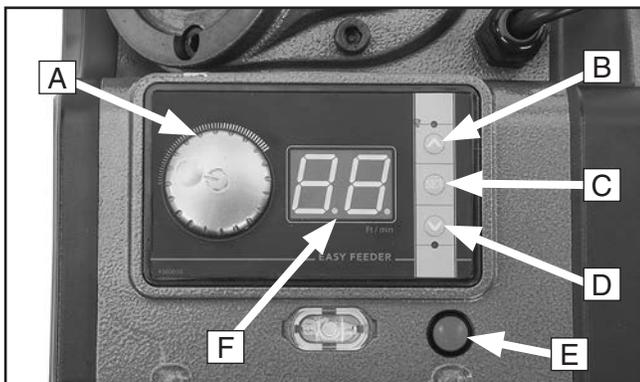


Figure 1. Variable-speed control panel features.

- A. **Motor Start/Speed Dial:** Starts and stops motor and controls feed rate from 7–72 FPM. To start motor, press dial until it beeps and control panel glows red. To stop motor, press dial again. To adjust feed rate, press SET button, then rotate dial clockwise to increase feed rate or counterclockwise to decrease feed rate.
- B. **Forward Feed Direction Button (⤴):** Selects forward feed direction. When pressed, green light above button illuminates, indicating button is selected. To change feed direction, press feed direction button opposite of currently selected feed direction twice (2X). New feed direction will be set at lowest speed (7 FPM). Press motor start/speed dial twice to restore original feed rate.
- C. **SET Button:** Enables changes to feed rate. When pressed, selected feed rate flashes on control panel for 10 seconds, during which time feed rate can be selected with motor start/speed dial. When panel stops flashing, feed rate is locked—until SET button is pressed again.
- D. **Reverse Feed Direction Button (⤵):** Selects reverse feed direction. Green light below button illuminates, indicating button is selected.
- E. **ON/OFF Switch:** When pressed, enables or disables power.
- F. **Variable-Speed Readout:** Displays feed rate in FPM.



Power Feeder & Column Controls

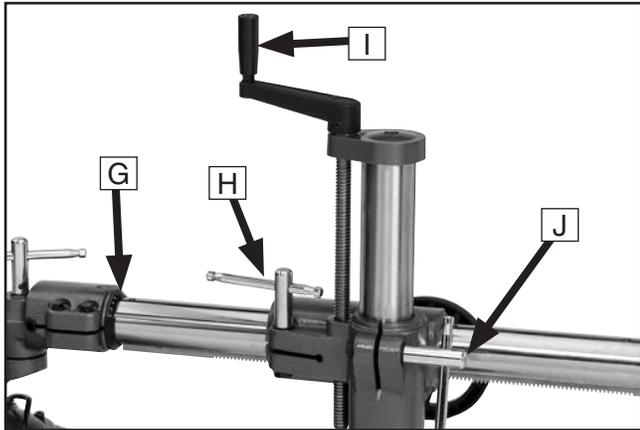


Figure 2. Location of column controls.

- G. Angle Adjustment Scale:** Indicates angle that power feeder assembly is rotated relative to overarm shaft. Loosen hex bolts on upper elbow-joint to allow rotation; tighten hex bolts to secure power feeder angle.
- H. Horizontal Travel Lock:** Locks horizontal position of power feeder.
- I. Vertical Travel Handle:** Adjusts vertical position of overarm shaft and power feeder (when vertical travel lock is loosened).
- J. Vertical Travel Lock:** Locks power feeder height setting.

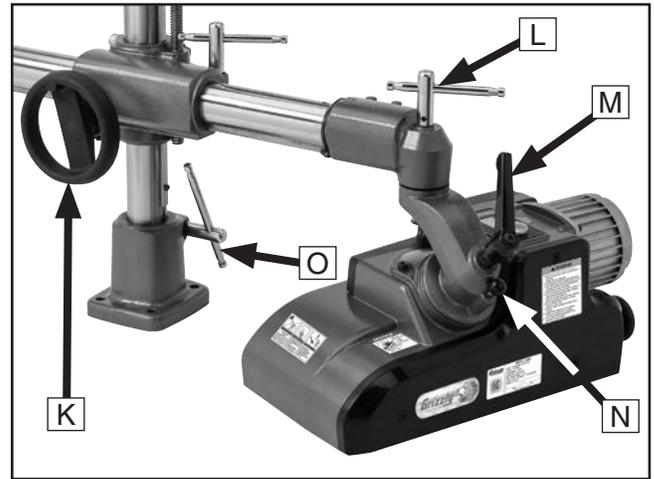


Figure 3. Location of power feeder and column controls.

- K. Horizontal Travel Handwheel:** Moves overarm shaft horizontally and adjusts lateral position of power feeder (when horizontal travel lock (G) is loosened).
- L. Upper Elbow-Joint Lock:** Allows lower elbow and power feeder to rotate around upper elbow. Tighten to secure lower elbow.
- M. Lower Elbow-Joint Lock:** Allows power feeder to rotate on its axis when swivel lock pin is disengaged. Tighten to secure power feeder swivel position.
- N. Swivel Lock Pin:** Allows power feeder to rotate when disengaged. Locks power feeder in horizontal position when engaged in either of two detents.
- O. Rotation Lock:** Allows vertical column to rotate when loosened. Prevents vertical column from rotating when tightened.





MACHINE DATA SHEET

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

MODEL G0826 EASY FEEDER POWER FEEDER

Product Dimensions:

Weight..... 117 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 37-1/2 x 20-1/2 x 29-1/2 in.
 Footprint (Length x Width)..... 5-1/2 x 6 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard Box
 Content..... Machine
 Weight..... 54 lbs.
 Length x Width x Height..... 23 x 13 x 12 in.
 Must Ship Upright..... No

Carton #2

Type..... Cardboard Box
 Content..... Stand
 Weight..... 71 lbs.
 Length x Width x Height..... 31 x 13 x 13 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 2.3A
 Minimum Circuit Size..... 15A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 9 ft.
 Power Cord Gauge..... 18 AWG
 Plug Included..... Yes
 Included Plug Type..... 6-15
 Switch Type..... Push-Button ON/OFF

Motors:

Main

Horsepower..... 500 Watt (2/3 HP)
 Phase..... Single-Phase
 Amps..... 2.3A
 Speed..... 350 – 4800 RPM
 Type..... BLDC
 Power Transfer Gear Drive
 Bearings..... Sealed & Permanently Lubricated

Main Specifications:



Operation Info

Number of Feed Speeds..... Variable
Feed Speeds..... 7 – 72 FPM
Swing..... 360 deg.
Vertical Movement..... 6-11/16 in.
Horizontal Movement..... 17 in.
Rotation..... Forward/Reverse

Roller Info

Number of Rollers..... 3
Roller Width..... 2-5/16 in.
Roller Diameter..... 4-3/4 in.
Roller Suspension..... 3/4 in.
Maximum Height Rollers Parallel Table Surface..... 7-1/2 in.

Construction Info

Roller..... Rubber
Housing..... Cast Aluminum
Supports..... Cast Iron
Column..... Cast Iron
Paint Type/Finish..... Enamel

Other

Column Diameter..... 2-1/4 in.

Other Specifications:

Country of Origin Taiwan
Warranty 1 Year
Approximate Assembly & Setup Time 45 Minutes
Serial Number Location ID Label
ISO 9001 Factory Yes

Features:

- Variable-Speed Feed Adjustment Dial
- Large Feed Speed Digital Readout
- Push-Button ON/OFF Switch and Feed Direction
- Crank Handle Vertical Adjustment
- 7" Max. Workpiece Clearance
- Rack-and-Pinion Horizontal Movement



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

Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery

WARNING

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

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

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

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

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

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

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



WARNING

WEARING PROPER APPAREL. Do not wear 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 Power Feeders

WARNING

Serious injury or death can occur from getting hands, clothing, or jewelry entangled in moving parts of power feeder or being pulled into cutting tool on attached machinery. Workpieces ejected by attached machine can strike operator or bystanders with significant force, causing impact injuries. To minimize risk of injury, anyone operating this machine **MUST** completely heed hazards and warnings below.

HAND SAFETY. To reduce risk of accidental entanglement/pinch injuries between power feeder rollers and workpiece, or contact with blade/cutter of associated machine, keep hands away from rotating parts of power feeder. Turn power feeder and associated machine **OFF** before removing chips, sawdust, or cutoffs—**DO NOT** use your hands.

INSTALLING GUARDS. To reduce risk of kickback and accidental contact with blade/cutter of associated machine, always install guards, fences, and hold-downs before starting attached machine and power feeder. Repair or replace guards promptly if they become damaged.

KICKBACK. Occurs when workpiece is ejected from machine at a high rate of speed. To reduce risk of kickback-related injuries (blindness, broken bones, bruises, amputation, severe lacerations, and death), use quality workpieces and proper setup or maintenance of power feeder or associated machine. Never stand in path of workpiece.

VERIFY EACH SETUP. An improperly adjusted power feeder can increase risk of kickback, because it will continue feeding even if stock is not properly positioned for cut. Ensure that power feeder is set up correctly and firmly secured before feeding workpiece.

FEATHERBOARD. When cutting long or large stock that is difficult to feed properly, use a featherboard with power feeder (on the infeed side) to maintain even pressure and control of workpiece against fence, and to help reduce risk of kickback.

FEED WORKPIECE PROPERLY. To reduce risk of kickback, verify blade or cutter of associated machine is at full speed before feeding stock with power feeder. Avoid feeding workpiece too quickly. Always verify power feeder wheels are slightly lower than workpiece to ensure it will not slip during cutting operation. Stop power feeder **BEFORE** stopping cutting tool.

WORKPIECE SUPPORT. Loss of workpiece control while feeding can increase risk of kickback. Support workpiece continuously during operation as required. Use auxiliary stands or support tables for long or wide stock.

ADJUSTMENTS/MAINTENANCE. Make sure power feeder and associated machine are turned **OFF**, disconnected from power, and all moving parts are completely stopped before doing adjustments or maintenance.

ATTACHED MACHINERY. Follow all warnings and safety information for attached machine doing cutting work.

WARNING

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

CAUTION

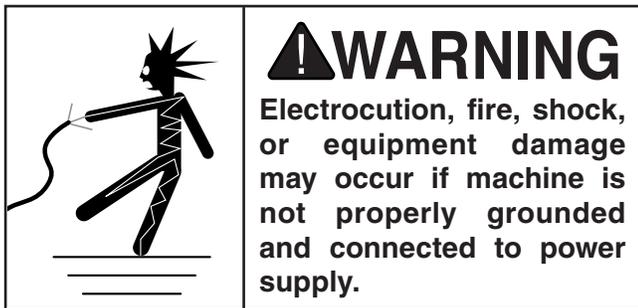
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: POWER SUPPLY

Availability

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

Full-Load Current Rating at 220V 2.3 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.*

Circuit Requirements

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 6-15



Grounding Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!

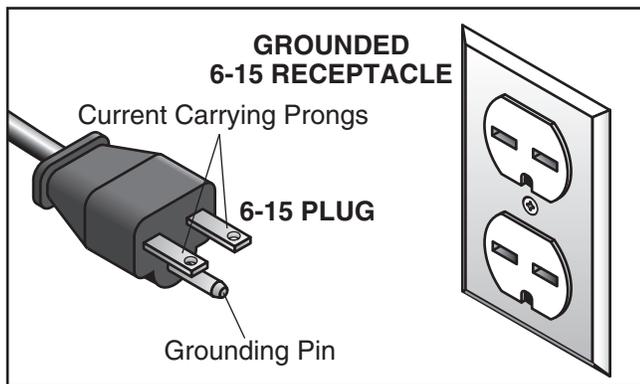
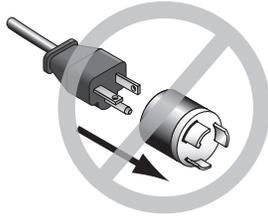


Figure 4. Typical 6-15 plug and receptacle.

CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

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.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size 16 AWG
Maximum Length (Shorter is Better).....50 ft.



SECTION 3: SETUP

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.***

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

Description	Qty
• Precision Level	1
• Safety Glasses (for each person).....	1
• Cleaner/Degreaser	As Needed
• Shop Rags.....	As Needed
• Disposable Gloves	As Needed
• Hex Wrench 4, 5, 8mm	1 Ea.
• Phillips Head Screwdriver #2	1
• C-Clamps	2
• 12" 2x4 Wood Block.....	1
• Open-End Wrench 13, 17, 19mm	1 Ea.
• Power Drill.....	1
• Drill Bit & Tap	1
• Optional Mounting Hardware.....	As Needed
• Med.-Grade Thread Locking Liquid.....	1
• Gear Oil (80-90W).....	As Needed

Inventory

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

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

NOTICE

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

Box 1 (Figure 5)	Qty
A. Power Feeder Assembly	1
B. Lower Elbow-Joint	1
C. Angle Adjustment Ring/Indicator Sticker....	1
D. Rotation Handle M10-1.5.....	1
E. Base Bolt Pattern Template.....	1

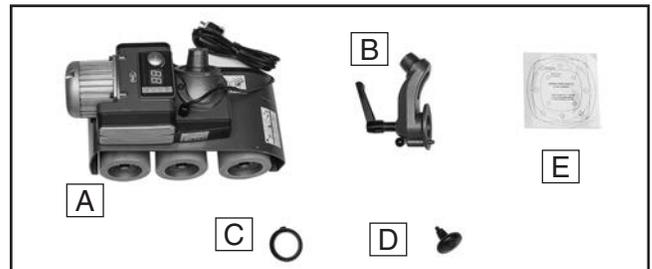


Figure 5. Box 1 inventory.

Box 2 (Figure 6)	Qty
F. Base and Vertical Column Assembly.....	1
G. Upper Elbow-Joint.....	1
H. Overarm Shaft.....	1
I. Hex Bolts M12-1.75 x 50 (Mounting).....	4
J. Lock Washers 12mm (Mounting).....	4
K. Vertical Travel Handle M10-1.5 x 25.....	1

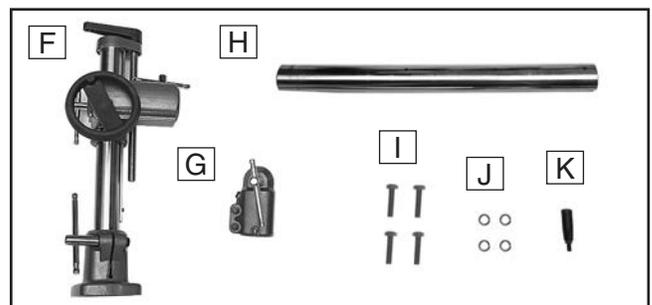


Figure 6. Box 2 inventory.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD-40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

NOTICE

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

Site Considerations

Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

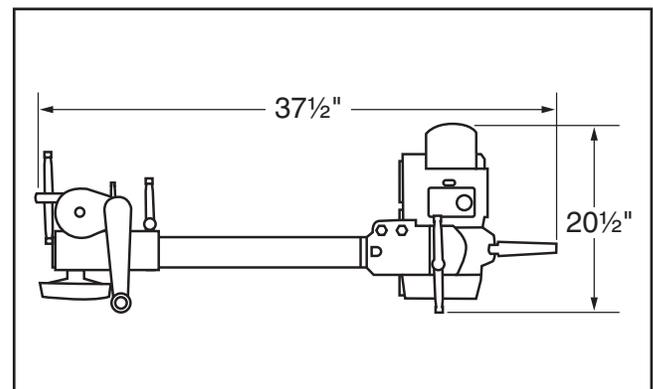
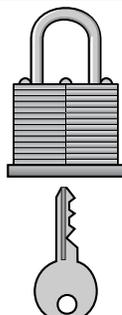


Figure 7. Minimum working clearances.

Note: Power feeder can rotate 360° around the vertical column, so be sure to situate machine so it can freely rotate. The machine is shown here with the overarm shaft fully extended.

	<p>CAUTION</p> <p>Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
--	--



Assembly

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

Tip: We recommend using a set of C-clamps to temporarily secure the base while assembling the power feeder to prevent it from tipping. You will mount the power feeder to the machine table after completing the assembly process. Refer to **Base Mounting** on **Page 17** for specific details.

To assemble machine:

1. Place vertical column assembly onto machine table top, then attach vertical travel handle to vertical crank shown in **Figure 8**.

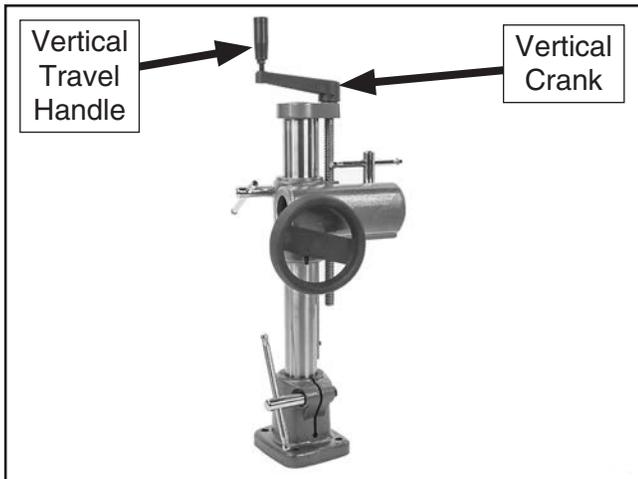


Figure 8. Vertical travel handle installed.

2. Loosen hex nut and set screw under horizontal handwheel shown in **Figure 9**, then remove horizontal handwheel.
3. Feed overarm shaft into sleeve of vertical column (see **Figure 9**). Re-install handwheel and engage gears with overarm shaft teeth. Re-tighten set screw and hex nut just enough to secure handwheel.

Note: Do not overtighten set screw or hand wheel will not rotate.

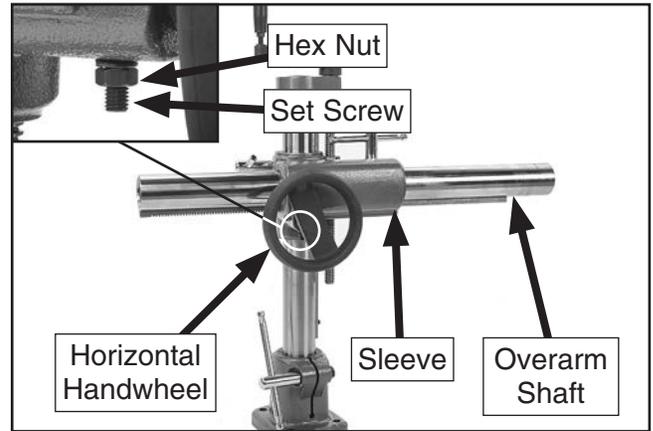


Figure 9. Overarm shaft installed onto vertical column.

4. Slide angle adjustment ring onto overarm shaft, slide upper elbow-joint onto overarm shaft, then tighten for now with one of the hex bolts shown in **Figure 10**.

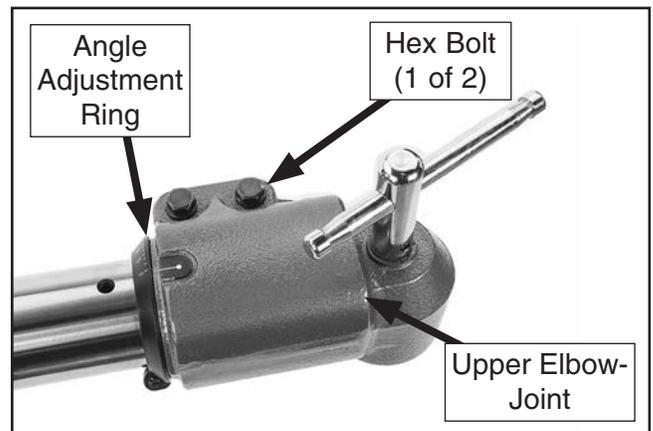


Figure 10. Angle adjustment ring installed onto upper elbow-joint.

5. Attach rotation handle to power feeder (see **Figure 11**) using pre-installed cap screw, flange nut, and (2) flat washers.

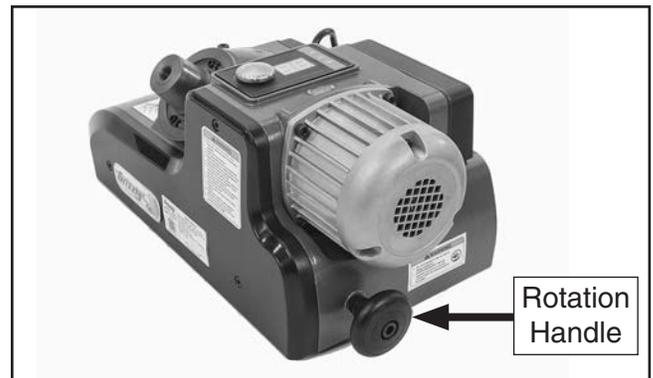


Figure 11. Rotation handle installed.



- Attach lower elbow-joint to power feeder assembly by threading lower elbow-joint lever all the way into threads of axial hub of power feeder (see **Figure 12**).

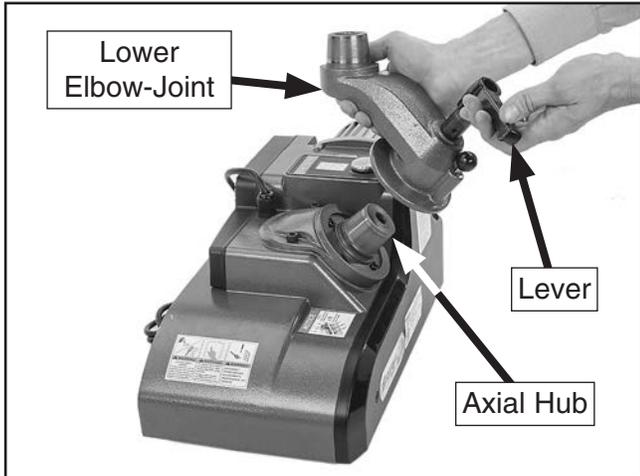


Figure 12. Attaching lower elbow-joint.

- Loosen vertical and horizontal travel locks and rotation lock, and use horizontal handwheel and vertical travel handle to position upper elbow-joint directly over hub of lower elbow-joint (see **Figure 13**).

Tip: Place a short (approx. 12" long) 2x4 under power feeder to make it level with table top and make it easier to connect upper and lower elbow-joints during next step.

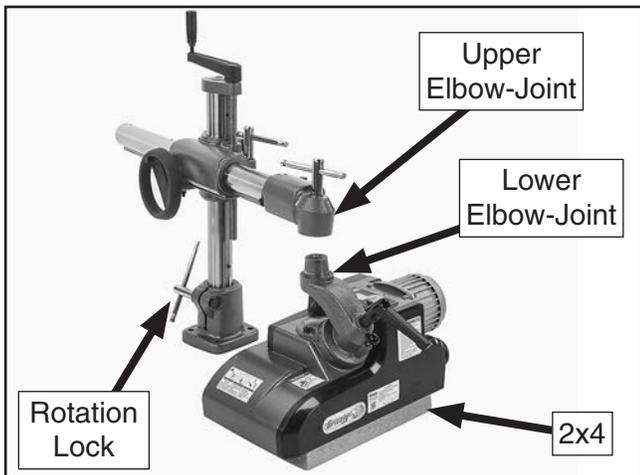


Figure 13. Upper and lower elbow-joints aligned.

- Position upper elbow-joint so internal threads contact those inside lower elbow-joint, then fully tighten upper elbow-joint lock (see **Figure 14**).

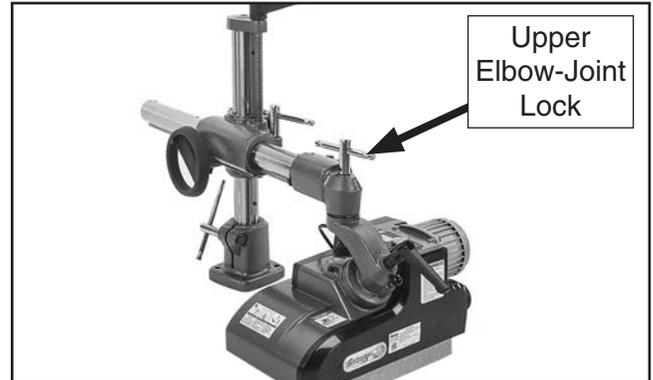


Figure 14. Upper elbow-joint lock fully tightened.

- Adjust rollers parallel to table top, then tighten hex bolts shown in **Figure 15**.
- Place indicator line sticker included with angle adjustment ring to upper elbow-joint, as shown in **Figure 15**.
- Position angle adjustment ring so it just contacts upper elbow-joint, align "0" on ring with indicator, then tighten screw (see **Figure 15**).

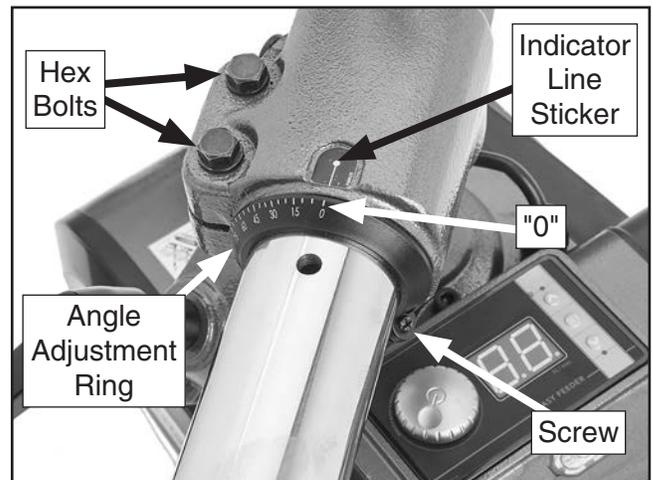


Figure 15. Location of "0" on adjustment ring.



Base Mounting

Position the power feeder on the table top to determine where to drill the base mounting holes in order to maximize power feeder swing and adjustment options.

Use the included base-bolt pattern template to align the mounting holes. Consider the available mounting choices for your needs: **Through-Bolt Mounting** and **Direct Mounting** (discussed on **Page 18**).

With either mounting choice, leave room to operate the hand cranks and lock levers to position the rubber rollers parallel with the table surface and approximately $\frac{1}{8}$ " lower than the thickness of the workpiece.

Also, aim the front of the power feeder slightly towards the machine fence (see **Figure 16**) with approximately 1° to 1.5° toe-in toward the machine fence, so the rubber rollers lightly push the workpiece against the fence during cutting operations.

If cutting long or large stock that is difficult to feed properly, use a featherboard *before* the power feeder (on the infeed side) to maintain even pressure and control of the workpiece against the fence.

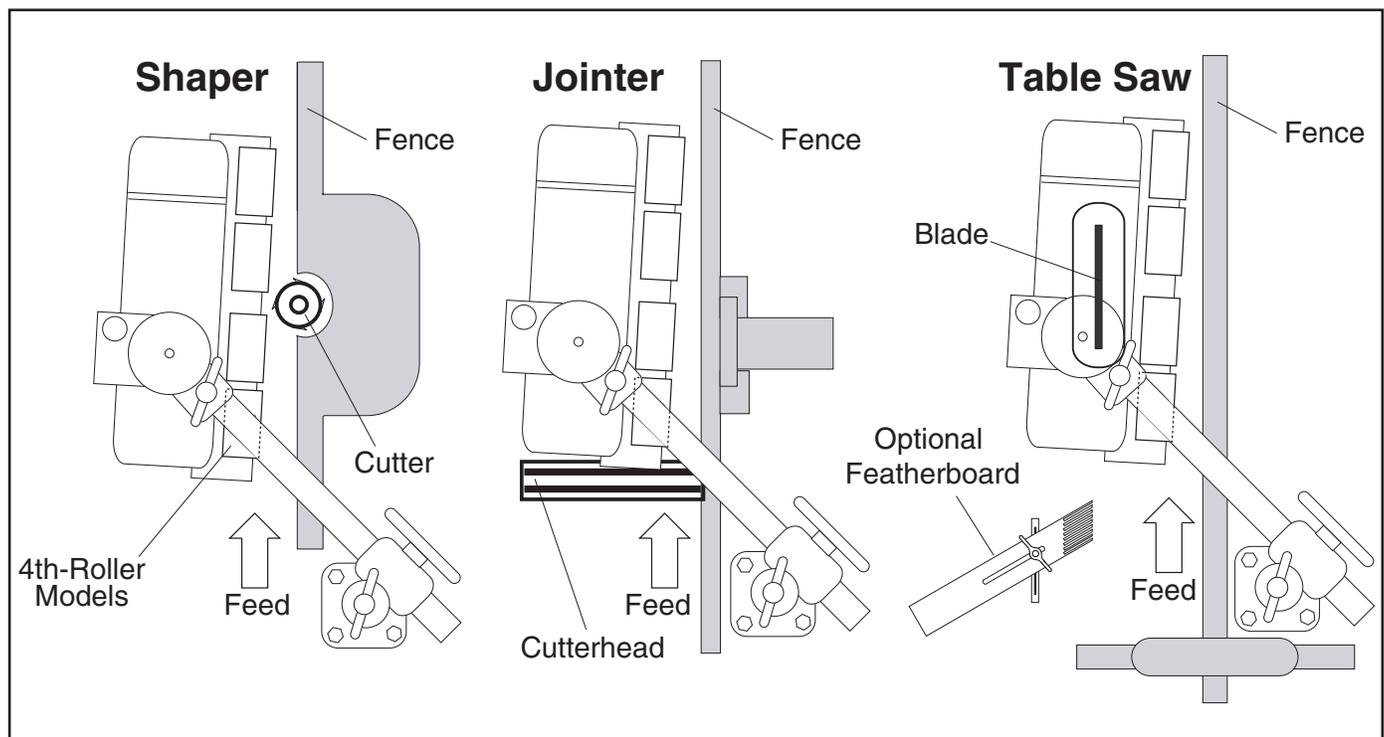


Figure 16. Typical power feed mounting on a shaper, jointer, and table saw.



Through-Bolt Mounting

We recommend mounting the power feeder to the machine table with through bolts, nuts, and washers (see **Figure 17**). This provides the most rigidity and clamping strength to prevent the feeder base from twisting out of alignment during use. However, if under-table support webs interfere with washer or nut locations, drill and thread holes directly into the table (**Direct Mounting**).

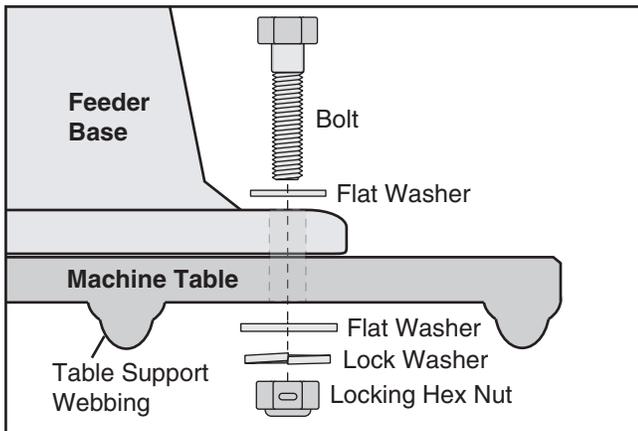


Figure 17. Through-bolt mounting.

Direct Mounting

Use the included mounting template to drill and tap the table so the power feeder base can be directly mounted to the table surface (see **Figure 18**). Use medium-grade liquid thread-locking compound on all threads. If the table is less than $\frac{3}{8}$ " thick where the holes will be drilled and tapped, or if support webbing interferes, the threads may strip or loosen during power feeder use. Thread-locking compound is *not* a permanent solution. Revert to the **Through-Bolt Mounting** or clamping kit options.

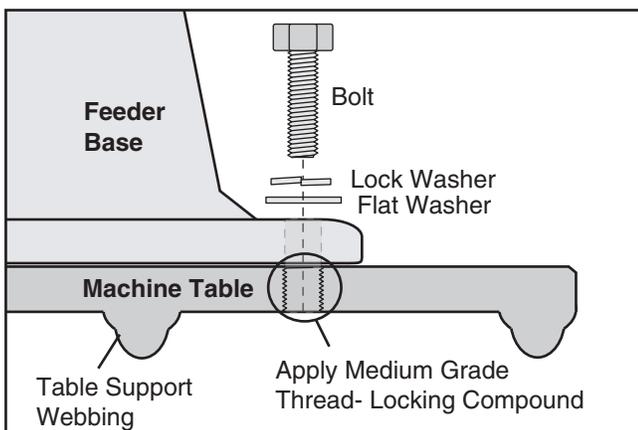


Figure 18. Direct mounting.

Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem **BEFORE** operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the control panel works correctly.

!WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

!WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run machine:

1. Clear all setup tools away from machine.
2. Make sure gearbox oil level is full. Refer to **Lubrication** on **Page 26** for details.
3. Adjust and lock power feeder so rollers are held approximately 1" above machine table and nothing will interfere with roller rotation.



4. Connect power feeder to power supply. Variable-speed readout (see **Figure 19**) will illuminate.



Figure 19. Variable-speed readout illuminated, indicating power is connected.

5. Press ON/OFF button, press SET button (see **Figure 20**), and use motor start/speed dial to select 10 FPM on readout. Number will flash for 10 seconds, then glow steadily.
6. Press forward feed direction button  (see **Figure 20**), and press and hold motor start/speed dial until you hear a beeping sound and outside edge of panel glows red.

Motor should run smoothly and without unusual problems or noises. The rollers should rotate in a counterclockwise direction (when viewed from the top).

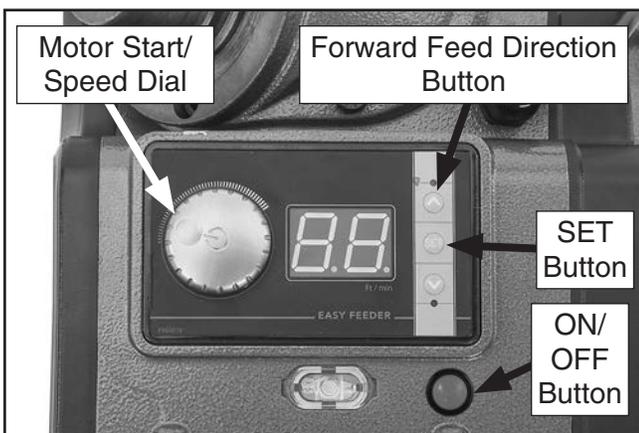


Figure 20. Location of buttons on control panel.

— If motor or rollers do not function correctly, disconnect from power and refer to **Troubleshooting** on **Page 28** before completing Test Run.

7. Press motor start/speed dial (see **Figure 21**). Rollers should stop rotating.
8. Press reverse feed direction button  shown in **Figure 21**, then press and hold motor start/speed dial until you hear a beep and control panel glows red. Rollers should rotate in clockwise direction (when viewed from the top).

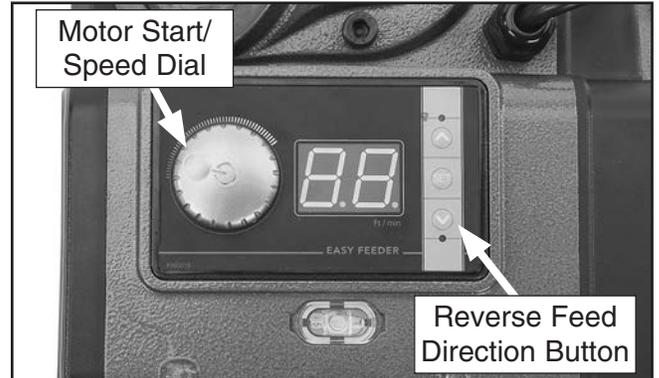


Figure 21. Location of reverse feed direction button.

9. Press motor start/speed dial. Rollers should stop rotating.
10. Test run is complete.

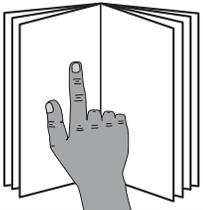


SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

	<p>! WARNING To reduce your risk of serious injury, read this entire manual BEFORE using machine.</p>
--	---

<p>! WARNING To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.</p>	
	

<p>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.</p>
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To complete a typical operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for cutting operation.
2. Adjusts machine cutter/blade and fence for desired operation.
3. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through cutter/blade without interference.
4. Loosens upper elbow-joint lock and points power feeder 1° to 1.5° toward machine fence, so rubber rollers will lightly push workpiece against fence during cutting operations, then tightens elbow lock.
5. Loosens vertical travel lock and lower elbow-joint lock, then adjusts position of power feeder so rubber rollers are parallel with table surface and 1/8" lower than thickness of workpiece, then tightens all locks.
6. Checks to make sure rollers are clear of cutter or blade.
7. (Optional) positions featherboard on infeed side for cutting long or large stock that is difficult to feed properly.
8. Sets feed speed and direction using control panel.
9. Puts on safety glasses and a respirator.
10. Starts machine and power feeder. Feeds stock into power feeder, maintaining firm pressure on workpiece against table and fence.
11. Stops power feeder, then stops machine.



Basic Use & Care

⚠️ WARNING

You MUST assemble all guards, fences, and hold-downs before starting your machine or power feeder. Failure to heed this warning could result in amputation or death!

Power feeders reduce kickback hazards and improve cutting results by feeding in a consistent and stable manner. Remember, **DO NOT** stand in the path of potential kickback. When not in use, support the power feeder with a wooden block so the rubber rollers are raised above the table and do not compress from the weight of the power feeder.

The lock levers and hand cranks allow you to adjust the power feeder tracking and height to accommodate many workpiece sizes. Before loosening any lock lever, always support the power feeder with a block of wood so the power feeder does not drop and cause damage.

Adjust the power feeder so it is toed-in approximately 1° to 1.5° towards the machine fence, as shown in **Figure 22**. This adjustment will ensure that the power feeder rollers slightly push the workpiece against the fence during cutting operations. Use a featherboard on the infeed side to assist with feeding long or large stock.

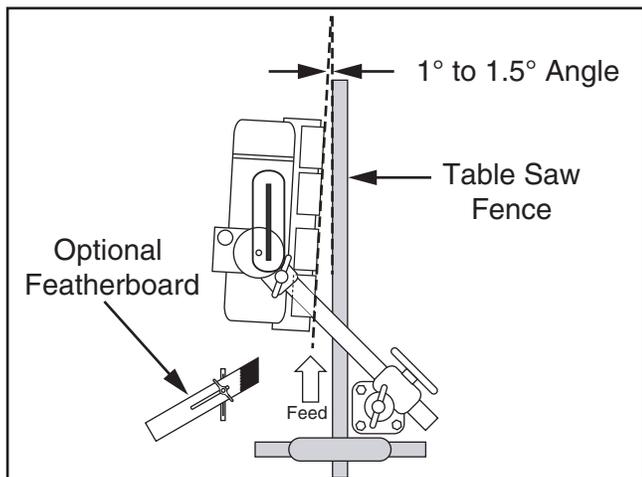


Figure 22. Example of power feeder toe-in on a table saw (4-roller model shown).

Next, adjust power feeder so the rubber rollers are parallel with the table surface and approximately $\frac{1}{8}$ " lower than the thickness of the workpiece, as shown in **Figure 23**. This ensures that the workpiece will not slip or hang during a cut. Always double check that the power feeder rollers are always slightly lower than the workpiece before you begin feeding operations. Otherwise, the workpiece may slip and kick back.

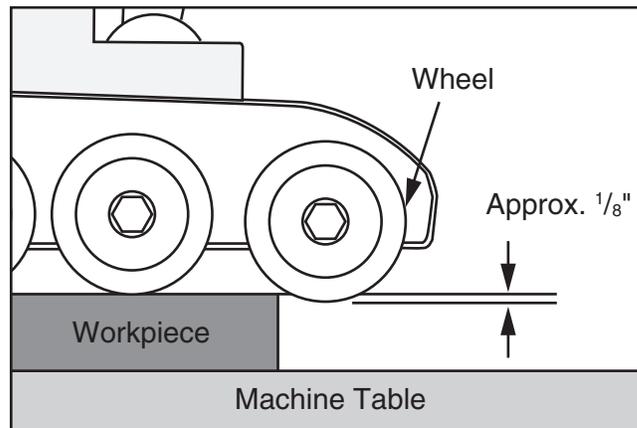
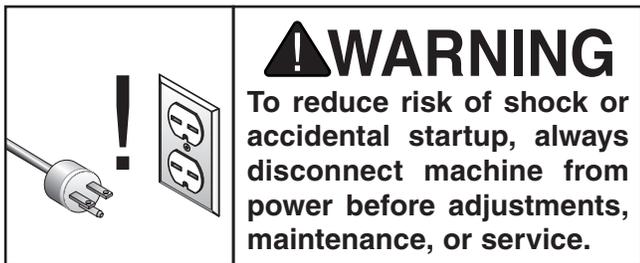


Figure 23. Rollers adjusted approximately $\frac{1}{8}$ " below workpiece.



Changing Speeds



Variable Feed Speeds7-72 FPM

Users can change the feed rate by adjusting the motor start/speed dial on the variable-speed control panel.

To change power feeder feed rate:

1. Press SET button on control panel, as shown in **Figure 24**.

Note: The current feed rate will flash for up to 10 seconds, after which SET button must be pressed again to adjust feed rate.



Figure 24. Location of SET button and motor start/speed dial on control panel.

2. Rotate motor start/speed dial to desired feed rate.

Vertical/Incline Feeding

The Model G0826 can be positioned to feed workpieces so the rollers are angled relative to the machine fence at 45°, 90°, or another angle in between. For example, it can be positioned at 90° to feed stock against a fence, or it can be positioned at 45° or another angle such as when making bevel cuts on a jointer.

Use the controls shown in **Figure 25** to position the power feeder for incline feeding.

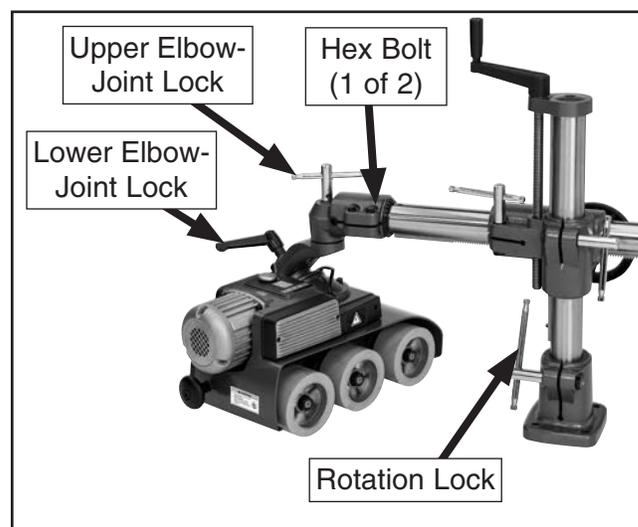


Figure 25. Location of controls for re-positioning power feeder for incline feeding.

Tools Needed	Qty
Open-End Wrench or Socket 17mm.....	1

To position power feeder for vertical/incline feeding:

1. Loosen rotation lock and swing power feeder off of machine table (see **Figure 25**).
2. Loosen (2) hex bolts on upper elbow-joint, rotate upper elbow to desired angle, then tighten hex bolts (see **Figure 25**) to secure setting.
3. Loosen upper elbow-joint lock and lower elbow-joint lock (see **Figure 25**).



4. While holding onto rotation handle with one hand, disengage swivel lock pin, rotate power feeder clockwise (flip it upside down) so it is oriented as shown in **Figure 26**, then move it back over table and up against fence.

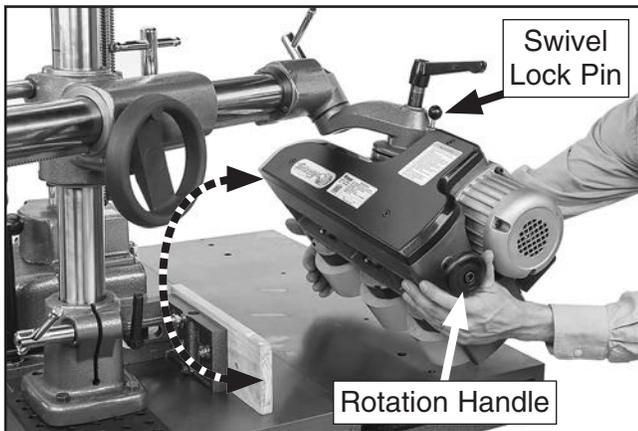


Figure 26. Rotating power feeder for vertical or incline feeding.

5. Lower power feeder and adjust it as needed so rollers are parallel to workpiece and workpiece is firmly against fence, as shown in **Figures 27–28**.

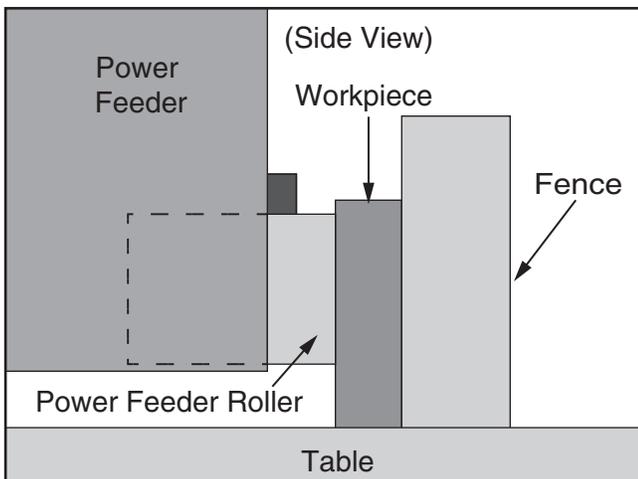


Figure 27. Example of power feeder set up for 90° feeding operation on shaper against a fence.

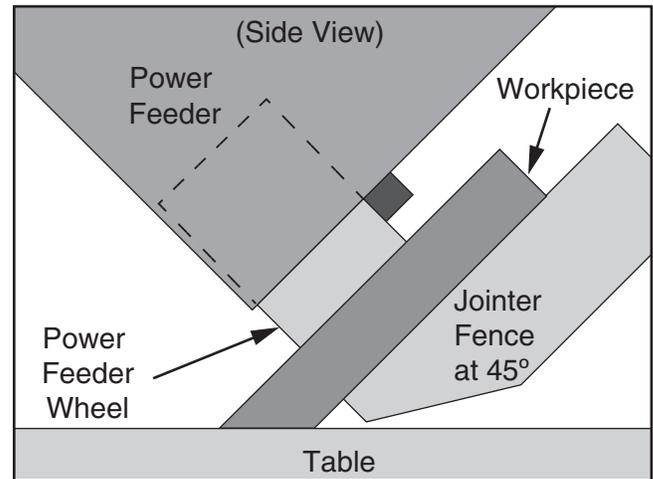


Figure 28. Example of power feeder set up for 45° feeding operation on jointer.

6. Tighten all locks on power feeder and vertical column.
7. Repeat **Steps 1–6** in reverse order to reposition power feeder for non-angle feeding operations.



SECTION 5: 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.

D3122—Shop Fox® Push Stick

Measuring 13½" overall, this push stick allows the operator to keep his hands a safe distance away from the blade or cutter.



Figure 29. D3122 Shop Fox® Push Stick.

D3096—Shop Fox® Featherboard

Designed to lock into a standard ¾" x ¾" miter slot, this featherboard is fully adjustable to accommodate a wide range of workpieces. Reduce the likelihood of kickback with this convenient accessory.



Figure 30. D3096 Shop Fox® Featherboard.

T26419—Syn-O-Gen Synthetic Grease

Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.



Figure 31. Recommended product for machine lubrication.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray

H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 32. Recommended products for protecting unpainted cast iron/steel part on machinery.

T28095—120mm X 60mm Replacement Roller

T28096—120mm X 25mm Half Roller

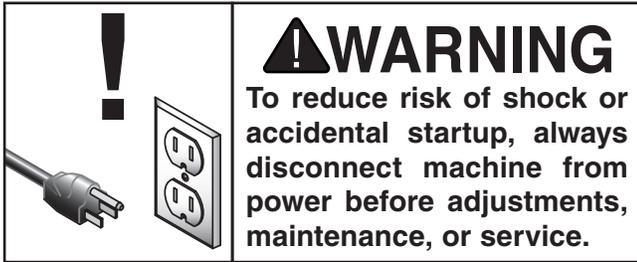


Figure 33. T28095 Replacement Roller.

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



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Damaged rollers.
- Worn or damaged switch, cord, and plug.
- Any other unsafe condition.

Daily Maintenance

- Lubricate chains and sprockets (**Page 27**).
- Lubricate vertical travel leadscrew (**Page 27**).
- Lubricate lock levers (**Page 27**).
- Lubricate overarm rack (**Page 27**).

Monthly Maintenance

- Lubricate roller and chain grease fittings (**Page 26**).
- Lubricate gearbox—initial month (**Page 26**).

Every 6 Months

- Lubricate gearbox (**Page 26**).

Cleaning & Protecting

Cleaning the Model G0826 is relatively easy. Frequently blow off sawdust with compressed air. This is especially important for internal working parts and the motor. Dust build-up around the motor will decrease its lifespan. If rollers become loaded up with pitch, oil, or other residues, wipe with a clean rag and soap and water. Keep mineral spirits away from plastic parts or painted surfaces to avoid damage.

Lubrication

Other than the lubrication points covered in this section, all other bearings are internally lubricated and sealed at the factory. Simply leave them alone unless they need to be replaced.

Before performing any lubrication task, **DISCONNECT MACHINE FROM POWER!**

IMPORTANT: Before adding lubricant, clean any debris and grime from fill hole/grease fitting and immediate area to prevent contamination of new lubricant.

Use the schedule below and the following instructions to properly lubricate the other components that require lubrication.

Lubrication Task	Frequency (Hours of Operation)	Page Ref.
Roller & Chain Grease Fittings	200 Hrs.	26
Gearbox	1000 Hrs.	26
Chain & Sprockets	8 Hrs.	27
Vertical Travel Leadscrew	8 Hrs.	27
Lock Levers	8 Hrs.	27
Overarm Rack	8 Hrs.	27



Items Needed	Qty
NLGI#2 Grease or Equivalent	As Needed
ISO 32 Oil or Equivalent.....	As Needed
80-90W Gear Oil	As Needed
Clean Shop Rags	As Needed
Mineral Spirits.....	As Needed
Brushes	As Needed
1-Gallon Catch Pan	1
Grease Gun.....	1
Open-End Wrench 14, 22mm.....	1 Ea.
Hex Wrench 5mm.....	1

Roller & Chain Grease Fittings

Lube Type..... T26419 or NLGI#2 Equivalent
 Amount..... 1–2 Pumps.
 Lubrication Frequency.....200 Hrs. of Operation
 Grease Gun..... 1

Wipe the roller and chain grease fittings clean and lubricate with one pump from a grease gun filled with NLGI#2 grease (see **Figures 34–35**). It will be necessary to remove the chain cover to access the chain grease fittings.

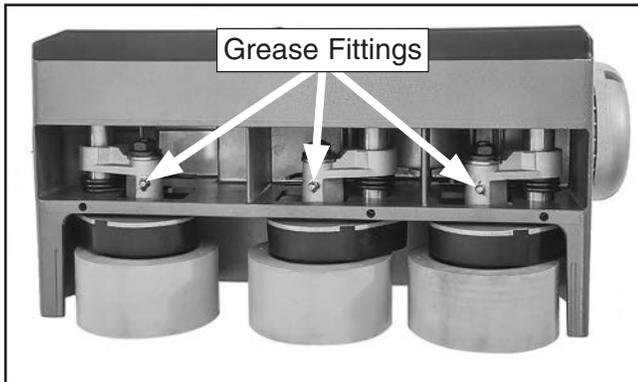


Figure 34. Location of roller grease fittings.

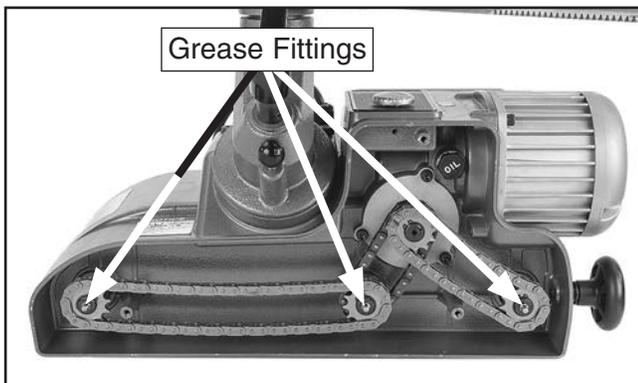


Figure 35. Location of chain grease fittings (chain cover removed).

Gearbox

Lube Type.....80-90W Gear Oil
 Amount.....4.05 Oz.

Lubrication Frequency:

- 200 Hrs./First Month of Operation
- 1000 Hrs./6 Months of Operation

The gearbox should be drained and refilled after the first month or 200 hours of use. For the remaining life of the power feeder, change oil every six months or 1000 hours of use.

To change gearbox oil:

1. DISCONNECT MACHINE FROM POWER!
2. Rotate power feeder off of machine table, remove chain cover, and tighten rotation lock.
3. Rotate power feeder upside down so chains face down (see **Figure 36**).
4. Place drain pan under fill plug labeled "OIL," then remove fill plug (see **Figure 36**) and drain oil.

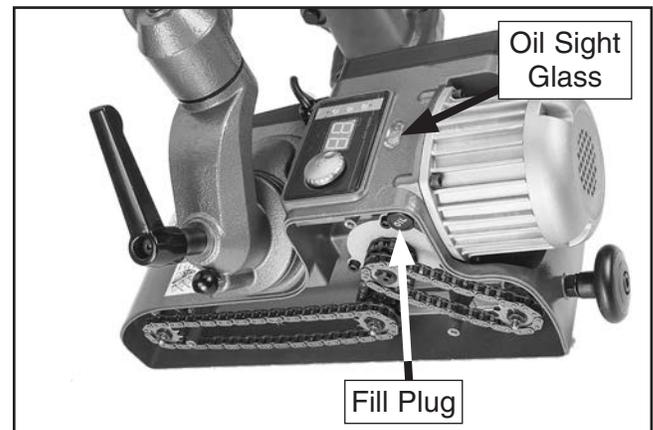


Figure 36. Location of gearbox fill plug/oil drain and sight glass.

5. Rotate power feeder 180 degrees so chains are face up, then fill gearbox with oil until oil level is at halfway point in sight glass, then replace fill plug.
6. Re-install chain cover and rotate power feeder back into place for operation.



Chain & Sprockets

Lube Type..... T26419 or NLGI#2 Equivalent
 AmountThin Coat
 Lubrication Frequency8 Hrs. of Operation

To prevent rust and binding, brush the sprockets and chains (see **Figure 37**) with a light film of NLGI#2 grease. It will be necessary to remove the chain cover to access the chain and sprockets.

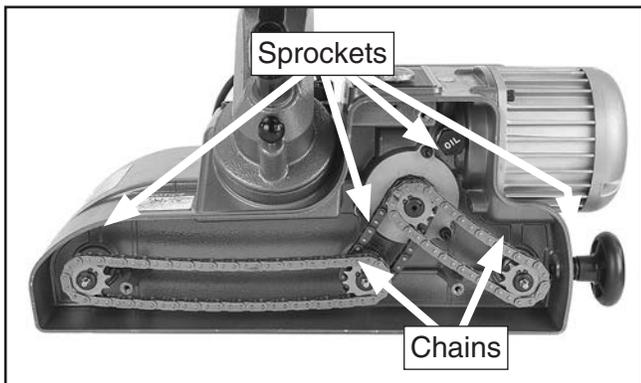


Figure 37. Location of chain and sprockets (chain cover removed).

Vertical Travel Leadscrew

Lube Type..... T26419 or NLGI#2 Equivalent
 AmountThin Coat
 Lubrication Frequency8 Hrs. of Operation

Use mineral spirits to clean any debris and built-up grime from the vertical travel leadscrew shown in **Figure 38**, then wipe it dry. Brush a thin coat of lubricant on the threads of the leadscrew, then rotate leadscrew through its full path to distribute the grease.

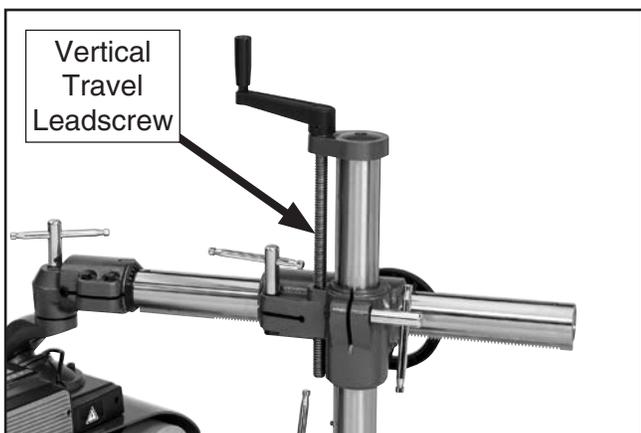


Figure 38. Vertical travel leadscrew.

Lock Levers

Lube Type..... ISO 32 or Equivalent
 AmountThin Coat
 Lubrication Frequency8 Hrs. of Operation

To prevent rust and binding, periodically clean and oil all lock-lever and leadscrew threads (see **Figure 39**) with light machine oil.

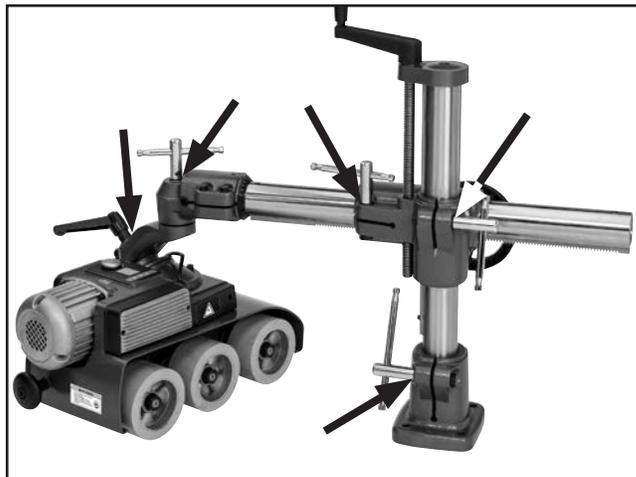


Figure 39. Location of levers to lubricate.

Overarm Rack

Lube Type..... T26419 or NLGI#2 Equivalent
 AmountThin Coat
 Lubrication Frequency8 Hrs. of Operation

Clean the overarm rack teeth (see **Figure 40**) with mineral spirits, shop rags, and a brush. When dry, use a brush to apply a thin coat of grease to the teeth, then move overarm back and forth several times to distribute the grease.

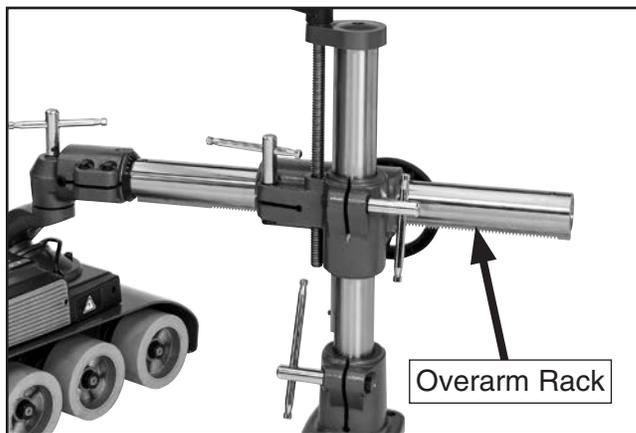


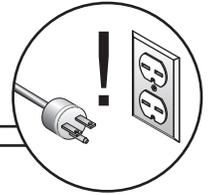
Figure 40. Overarm rack.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or power supply breaker (or fuse) trips immediately upon startup.	<ol style="list-style-type: none"> 1. Incorrect power supply voltage or circuit size. 2. Power supply circuit breaker tripped or fuse blown. 3. Wires disconnected, damaged, or connected incorrectly. 4. Circuit board at fault. 5. Motor at fault. 	<ol style="list-style-type: none"> 1. Ensure correct power supply voltage and circuit size. 2. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 3. Fix or replace damaged, disconnected, or misconnected wires. 4. Inspect/replace. 5. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Motor overheated. 2. Motor wired incorrectly. 3. Circuit board at fault. 4. Pulley/sprocket slipping on shaft. 5. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Reduce feed rate. Allow motor to cool. 2. Wire motor correctly (Page 31). 3. Inspect/replace. 4. Replace loose pulley/key/shaft. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Motor fan rubbing on fan cover. 3. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and retighten with thread-locking fluid. 2. Fix/replace fan cover; replace loose/damaged fan. 3. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Feeding Operations

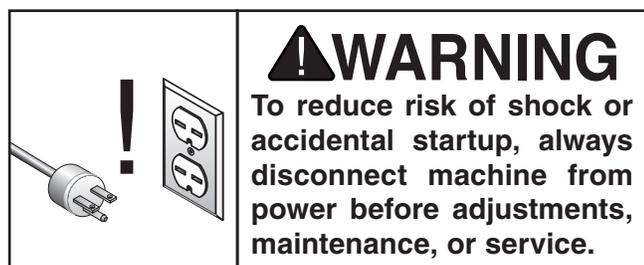
Symptom	Possible Cause	Possible Solution
Workpiece jams when feeding under rollers.	<ol style="list-style-type: none"> 1. Rollers positioned too low. 2. Feeder at wrong angle. 	<ol style="list-style-type: none"> 1. Raise feeder. 2. Adjust angle (Page 22).
Workpiece slips while passing beneath rollers.	<ol style="list-style-type: none"> 1. Rollers positioned too high. 2. Workpiece too dusty. 3. Rollers dirty or oily. 4. Feed speed too fast. 5. Worn roller(s). 6. Rollers loose. 	<ol style="list-style-type: none"> 1. Lower power feeder roller 1/8" lower than height of workpiece (Page 21). 2. Wipe dust off workpiece. 3. Clean roller surface with soap and warm water. 4. Reduce feed speed. 5. Replace roller(s) (Page 22). 6. Tighten rollers.
Workpiece cut is burnt.	<ol style="list-style-type: none"> 1. Feed speed too slow. 2. Dull cutter or blade. 	<ol style="list-style-type: none"> 1. Increase feed speed. 2. Replace with sharp cutter or blade.
Rough finish or chipped grain on workpiece.	<ol style="list-style-type: none"> 1. Feed speed too fast. 2. Dull cutter or blade. 3. Power feeder angle not toed-in to keep workpiece against fence. 	<ol style="list-style-type: none"> 1. Reduce feed speed. 2. Replace with sharp cutter or blade. 3. Adjust power feeder so it is toed in 1° to 1.5° toward fence (Page 21).



Feeding Operations Cont.

Symptom	Possible Cause	Possible Solution
Workpiece hangs up and does not enter the machine.	1. Rollers positioned too high.	1. Lower power feeder roller $\frac{1}{8}$ " lower than height of workpiece (Page 21).
Error message on control panel (E1, E2, E3).	1. (E1) Motor failed to start; workpiece jammed. 2. (E2) Circuit board temperature too high. 3. (E3) Motor temperature too high.	1. Remove jammed workpiece. 2. Allow circuit board to cool. 3. Allow motor to cool.

Roller Replacement



Worn or damaged rollers are easily replaceable.

Contact Grizzly Customer Service at (570) 546-9663 or visit www.grizzly.com/parts to order a replacement roller (Part #P0826081).

To replace worn or damaged roller:

1. DISCONNECT MACHINE FROM POWER!
2. Remove wing nut that secures roller (see **Figure 41**).

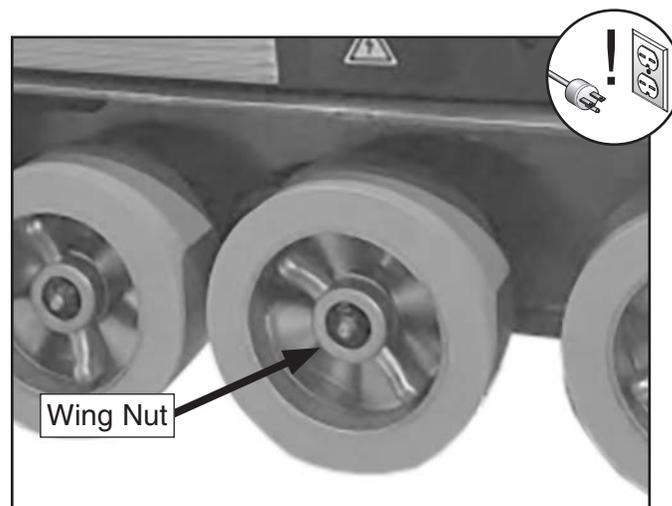


Figure 41. Roller wing nuts location.

3. Remove and replace roller.
4. Re-install wing nut and tighten.



SECTION 8: WIRING

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

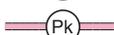
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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			



Wiring Diagram

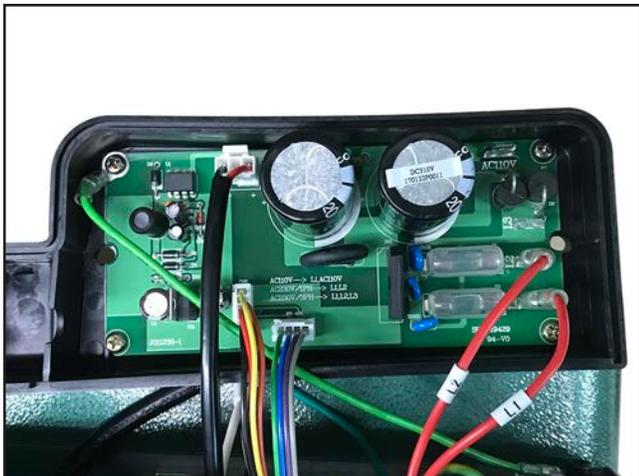
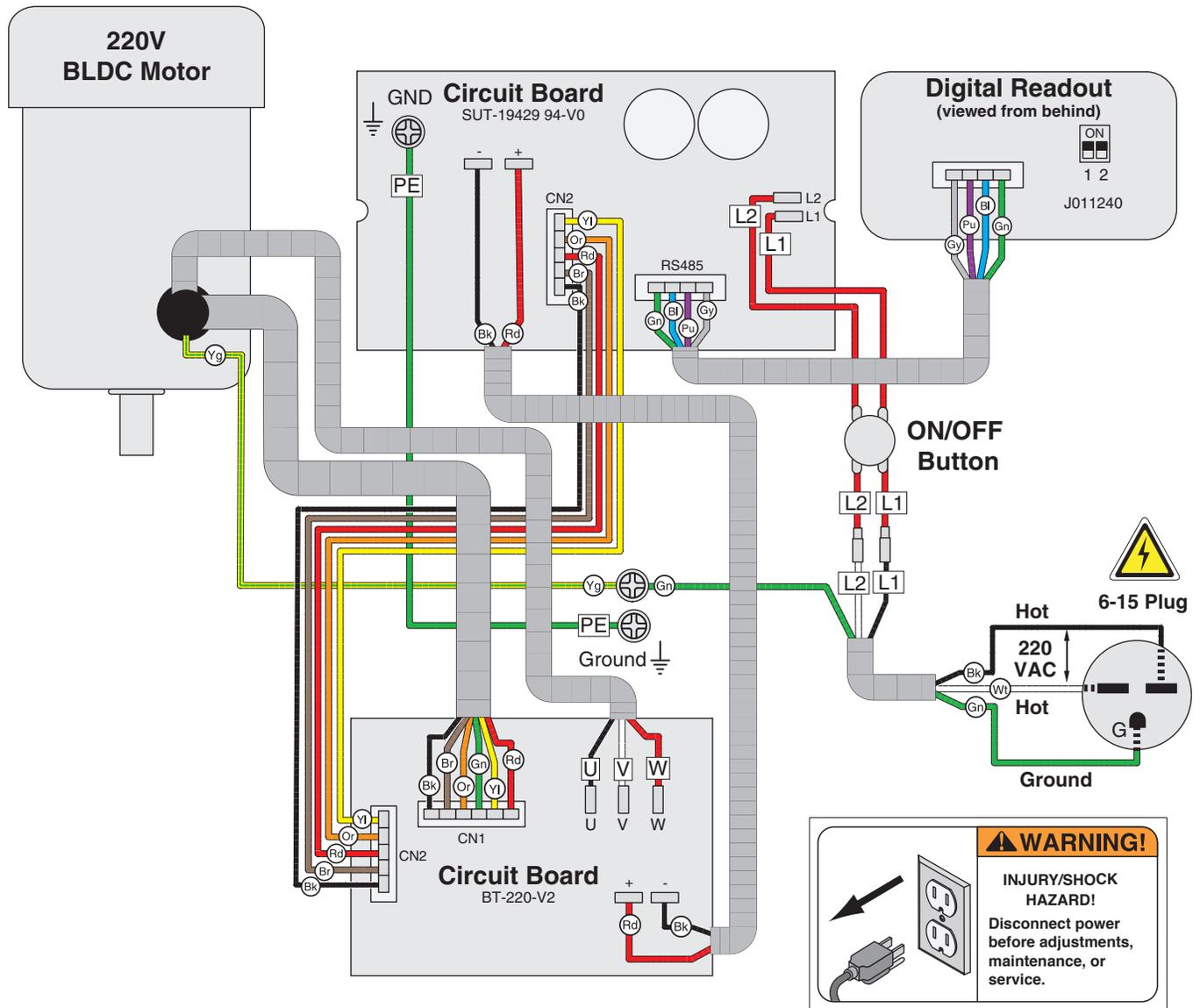


Figure 42. Motor circuit board wiring.

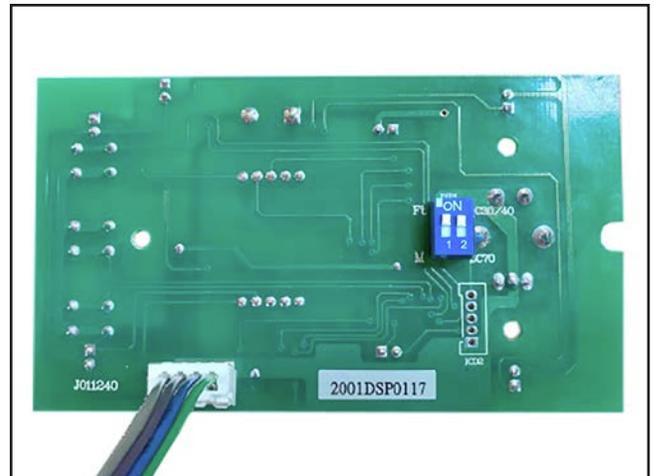


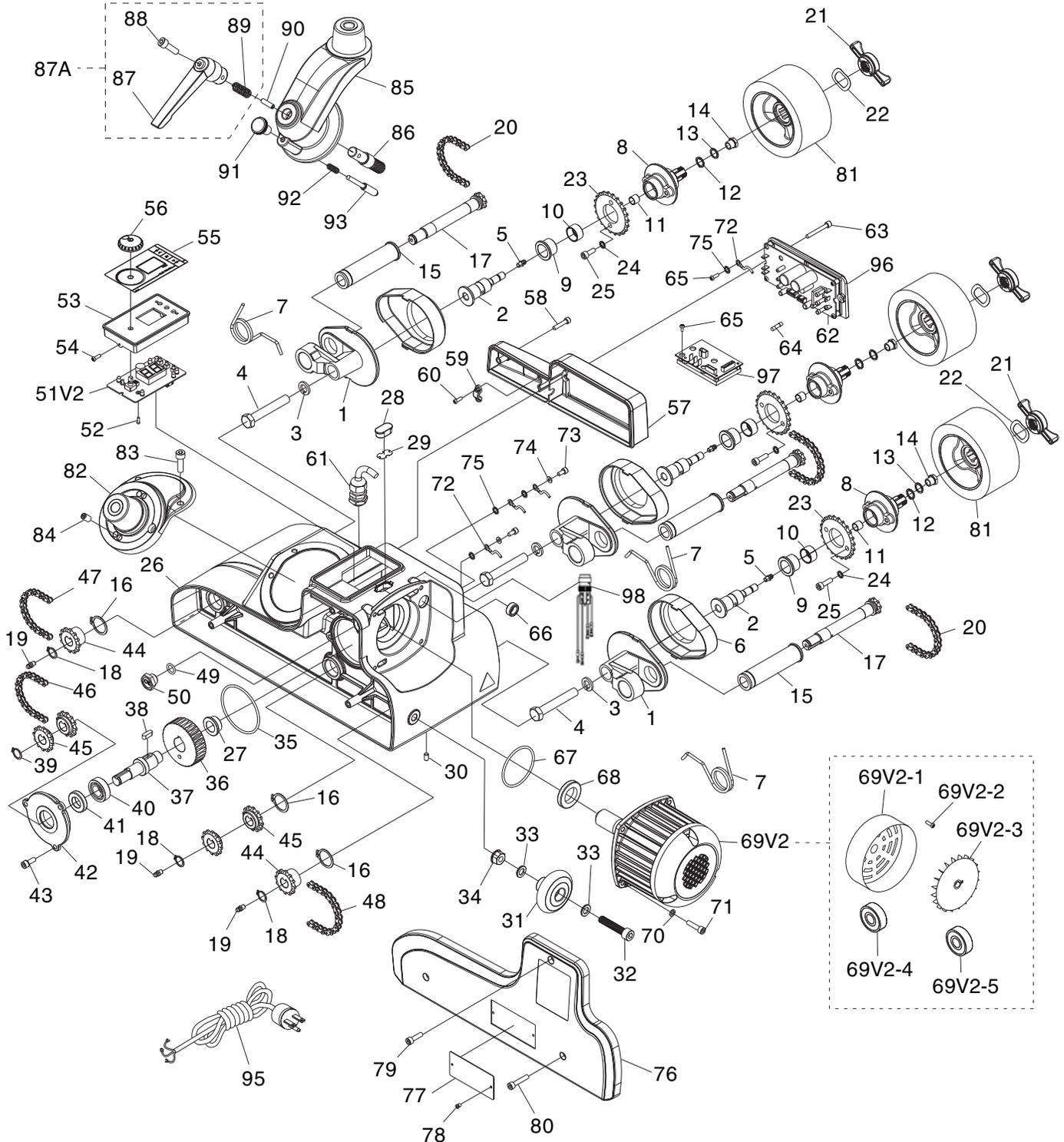
Figure 43. Digital readout circuit board.



SECTION 9: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call (800) 523-4777 or visit www.grizzly.com/parts to check for availability.

Power Feeder Assembly



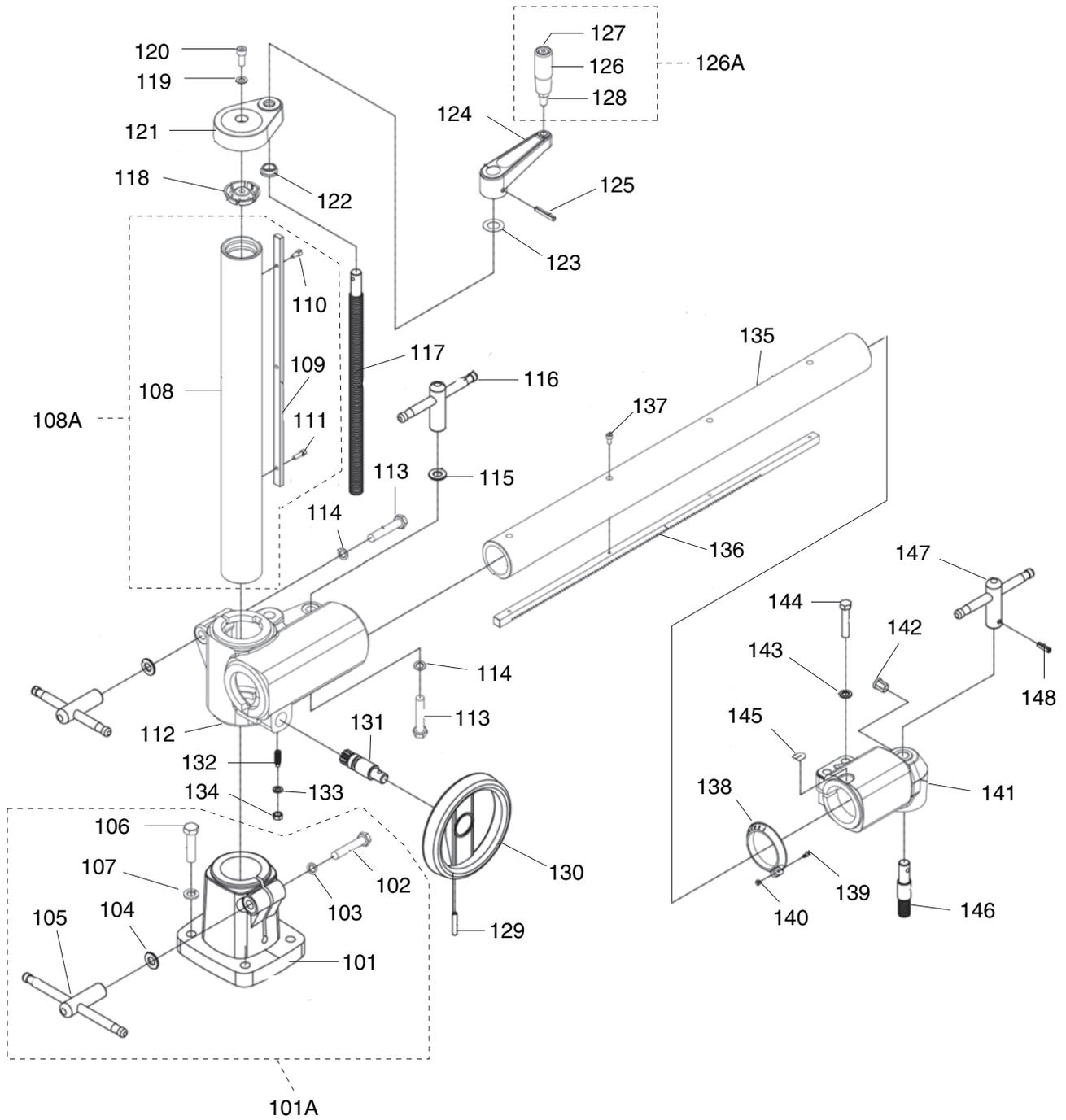
Power Feeder Assembly Parts List

REF	PART #	DESCRIPTION
1	P0826001	SPROCKET CASE
2	P0826002	SPROCKET SHAFT
3	P0826003	LOCK WASHER 12MM
4	P0826004	HEX BOLT M12-1.75 X 75
5	P0826005	GREASE FITTING M6-1 STRAIGHT
6	P0826006	CASE COVER
7	P0826007	TORSION SPRING
8	P0826008	ROLLER SUPPORTER
9	P0826009	BUSHING
10	P0826010	SPACER
11	P0826011	SPACER
12	P0826012	KEYED WASHER 12 X 16 X 1
13	P0826013	FLAT WASHER 12 X 16 X 1
14	P0826014	RECESSED HEX NUT M10-1.5
15	P0826015	SPROCKET SHAFT TUBE
16	P0826016	EXT RETAINING RING 26MM
17	P0826017	SPROCKET SHAFT
18	P0826018	EXT RETAINING RING 15MM
19	P0826019	GREASE FITTING M6-1 STRAIGHT
20	P0826020	CHAIN 26S
21	P0826021	WING NUT M16-2
22	P0826022	WAVY WASHER 16MM
23	P0826023	SPROCKET 22T X 3/8"
24	P0826024	LOCK WASHER 6MM
25	P0826025	CAP SCREW M6-1 X 20
26	P0826026	POWER FEEDER BODY
27	P0826027	BUSHING
28	P0826028	OIL SIGHT GLASS
29	P0826029	OIL SIGHT GLASS PANEL
30	P0826030	SET SCREW M6-1 X 10
31	P0826031	KNOB 65D X 38L X 10B
32	P0826032	CAP SCREW M10-1.5 X 50
33	P0826033	FLAT WASHER 10MM
34	P0826034	FLANGE NUT M10-1.5
35	P0826035	O RING 71.4 X 3.1 G72
36	P0826036	WORM GEAR 30T
37	P0826037	WORM GEAR SHAFT
38	P0826038	KEY 6 X 6 X 18
39	P0826039	EXT RETAINING RING 15MM
40	P0826040	BEARING 35MM X 17MM 6003ZZ
41	P0826041	OIL SEAL 17 X 32 X 7MM
42	P0826042	WORM GEAR COVER
43	P0826043	CAP SCREW M6-1 X 16
44	P0826044	SPROCKET 3/8" 12T
45	P0826045	DOUBLE-SPROCKET 12T X 3/8"
46	P0826046	CHAIN 28S
47	P0826047	CHAIN 62S
48	P0826048	CHAIN 36S
49	P0826049	O RING 11.8 X 2.4 P12
50	P0826050	OIL FILL PLUG
51V2	P0826051V2	DRO CIRCUIT BOARD V2.06.20
52	P0826052	TAP SCREW M3 X 8

REF	PART #	DESCRIPTION
53	P0826053	DRO COVER
54	P0826054	TAP SCREW M4 X 12
55	P0826055	DRO COVER PLATE
56	P0826056	SPEED ADJUSTMENT DIAL
57	P0826057	CIRCUIT BOARD COVER
58	P0826058	CAP SCREW M5-.8 X 25
59	P0826059	WIRE CLAMP (PLASTIC)
60	P0826060	PHLP HD SCR M4-.7 X 8
61	P0826061	STRAIN RELIEF TYPE-3 PG11
62	P0826062	CONTROLLER CIRCUIT BOARD
63	P0826063	CAP SCREW M5-.8 X 40
64	P0826064	FUSE 5A GLASS
65	P0826065	PHLP HD SCR M4-.7 X 8
66	P0826066	SPACER
67	P0826067	O-RING 59.4 X 3.1 G60
68	P0826068	MOTOR OIL SEAL
69V2	P0826069V2	MOTOR 500W 220V 1-PH V2.06.20
69V2-1	P0826069V2-1	MOTOR FAN COVER
69V2-2	P0826069V2-2	BUTTON HD CAP SCR M5-.8 X 12
69V2-3	P0826069V2-3	MOTOR FAN
69V2-4	P0826069V2-4	BALL BEARING 6005-2RS (FRONT)
69V2-5	P0826069V2-5	BALL BEARING 6201-2RS (REAR)
70	P0826070	LOCK WASHER 6MM
71	P0826071	CAP SCREW M6-1 X 20
72	P0826072	GROUND WIRE 18G
73	P0826073	CAP SCREW M5-.8 X 12
74	P0826074	FLAT WASHER 5MM
75	P0826075	EXT TOOTH WASHER 5MM
76	P0826076	CHAIN COVER
77	P0826077	SPECIFICATION LABEL PANEL
78	P0826078	RIVET 3 X 10
79	P0826079	CAP SCREW M6-1 X 20
80	P0826080	CAP SCREW M6-1 X 30
81	P0826081	120MM X 60MM ROLLER
82	P0826082	LOWER ELBOW PIVOT JOINT
83	P0826083	CAP SCREW M8-1.25 X 25
84	P0826084	LOCK PIN
85	P0826085	LOWER ELBOW JOINT
86	P0826086	STANDOFF HEX M16-1.5 X 82
87A	P0826087A	LOWER ELBOW JOINT LOCK ASSEMBLY
87	P0826087	ADJUSTABLE HANDLE 108L
88	P0826088	SHOULDER CAP SCR M6-1 X 6, 7 X 22
89	P0826089	COMPRESSION SPRING 1 X 15 X 16
90	P0826090	ROLL PIN 6 X 22
91	P0826091	PIVOT LOCK KNOB M6-1, 22D
92	P0826092	COMPRESSION SPRING 0.8 X 8 X 23
93	P0826093	LOCK PIN
95	P0826095	POWER CORD 3W 16G 72" 6-15P
96	P0826096	CIRCUIT BOARD HEAT SINK
97	P0826097	MOTOR CIRCUIT BOARD
98	P0826098	ON/OFF SWITCH



Column & Stand



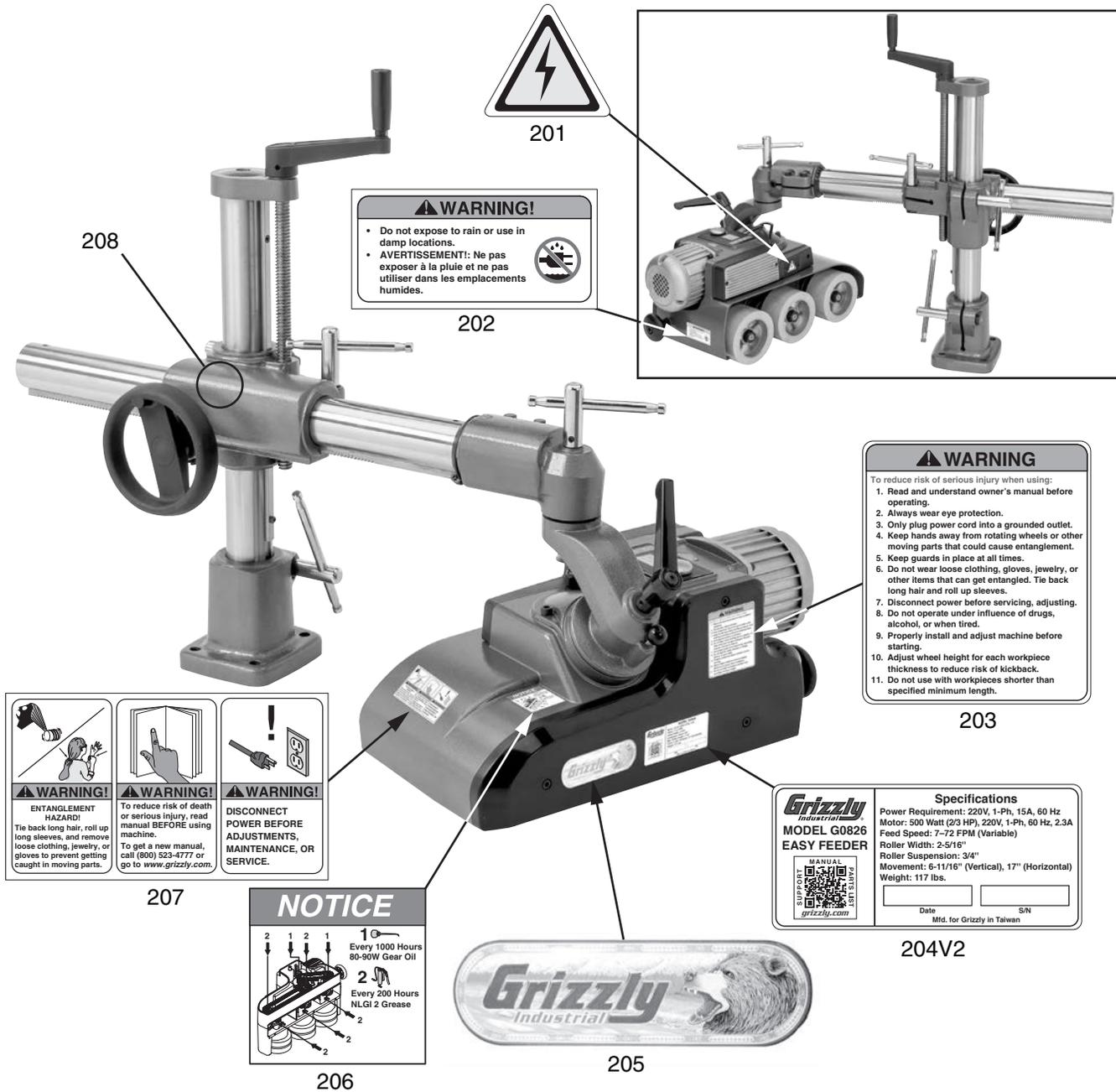
Column & Stand Parts List

REF	PART #	DESCRIPTION
101A	P0826101A	VERTICAL COLUMN BASE ASSY
101	P0826101	VERTICAL COLUMN BASE
102	P0826102	HEX BOLT M12-1.75 X 75
103	P0826103	LOCK WASHER 12MM
104	P0826104	FLAT WASHER 12MM
105	P0826105	SLIDING T-HANDLE 200MM
106	P0826106	HEX BOLT M12-1.75 X 50
107	P0826107	LOCK WASHER 12MM
108A	P0826108A	VERTICAL COLUMN ASSEMBLY
108	P0826108	VERTICAL COLUMN
109	P0826109	VERTICAL COLUMN RACK
110	P0826110	CAP SCREW M5-.8 X 10
111	P0826111	CAP SCREW M5-.8 X 16
112	P0826112	ELEVATING BRACKET
113	P0826113	HEX BOLT M12-1.75 X 75
114	P0826114	LOCK WASHER 12MM
115	P0826115	FLAT WASHER 12MM
116	P0826116	SLIDING T-HANDLE 150MM
117	P0826117	ELEVATION LEADSCREW
118	P0826118	FINNED ANCHOR M8-1.25
119	P0826119	FLAT WASHER 8MM
120	P0826120	CAP SCREW M8-1.25 X 25
121	P0826121	COLUMN CAP
122	P0826122	LEADSCREW BUSHING
123	P0826123	FLAT WASHER 17 X 30 X 0.5
124	P0826124	ELEVATION HANDLE ARM 130L

REF	PART #	DESCRIPTION
125	P0826125	ROLL PIN 6 X 36
126A	P0826126A	ELEVATION HANDLE ASSEMBLY
126	P0826126	ELEVATION HANDLE 10, 25 X 69
127	P0826127	CAP SCREW M10-1.5 X 85
128	P0826128	HEX NUT M10-1.5
129	P0826129	ROLL PIN 6 X 36
130	P0826130	HANDWHEEL TYPE-17 160D
131	P0826131	PINION
132	P0826132	SET SCREW M8-1.25 X 25 DOG-PT
133	P0826133	LOCK WASHER 8MM
134	P0826134	HEX NUT M8-1.25
135	P0826135	OVER-ARM SHAFT 720MM
136	P0826136	OVERARM SHAFT RACK 650MM
137	P0826137	CAP SCREW M5-.8 X 10
138	P0826138	ANGLE DIAL SCALE
139	P0826139	PHLP HD SCR M4-.7 X 15
140	P0826140	HEX NUT M4-.7
141	P0826141	UPPER ELBOW JOINT
142	P0826142	CORD RETAINER PLUG
143	P0826143	LOCK WASHER 10MM
144	P0826144	HEX BOLT M10-1.5 X 50
145	P0826145	POINTER PANEL
146	P0826146	STANDOFF STUD M16-2
147	P0826147	T-HANDLE, 150MM W/HOLE FOR PIN
148	P0826148	ROLL PIN 6 X 22



Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P0826201	ELECTRICITY LABEL
202	P0826202	WATER EXPOSURE WARNING LABEL
203	P0826203	OPERATION WARNING LABEL
204V2	P0826204V2	MACHINE ID LABEL V2.05.20

REF	PART #	DESCRIPTION
205	P0826205	GRIZZLY OVAL LOGO LABEL
206	P0826206	LUBRICATION NOTICE
207	P0826207	ENTANGLEMENT/READ/UNPLUG LABEL
208	P0826208	TOUCH-UP PAINT, GRIZZLY GREEN

⚠ WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.



WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

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

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

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

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

To take advantage of this warranty, you must register it at <https://www.grizzly.com/secureforms/warranty-card>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.



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