

Grizzly *Industrial, Inc.*®

MODEL G0767 ABRASIVE TUBE NOTCHER

OWNER'S MANUAL

(For models manufactured since 1/14)



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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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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

The Model G0767 Abrasive Tube Notcher is designed to quickly notch or cope the ends of metal tubing, so two pieces of tubing can be welded together with clean, strong joints. It is an ideal machine for production work with fencing, gates, roll cages, bicycle frames, stainless steel piping, or any other type of tubing work that requires joining multiple pieces together.

The vise allows the tube to be set at any angle from 30° to 90° to the grinding belt. Using the variety of included profile rollers, notches can be formed in diameters from 3/4" to 3". After notching is complete, tubing edges can be deburred using an exposed flat section of the grinding belt.

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.

Grizzly Industrial **MODEL GXXXX**
MACHINE NAME

SPECIFICATIONS **▲ WARNING!**

Motor: To reduce risk of serious injury when using this machine:
Specification: **Manufacture Date** **Manual before operation.**
Specification: **Safety glasses and respirator.**
Specification: **Correctly adjusted/setup and**
Weight: **power is connected to grounded circuit before starting.**

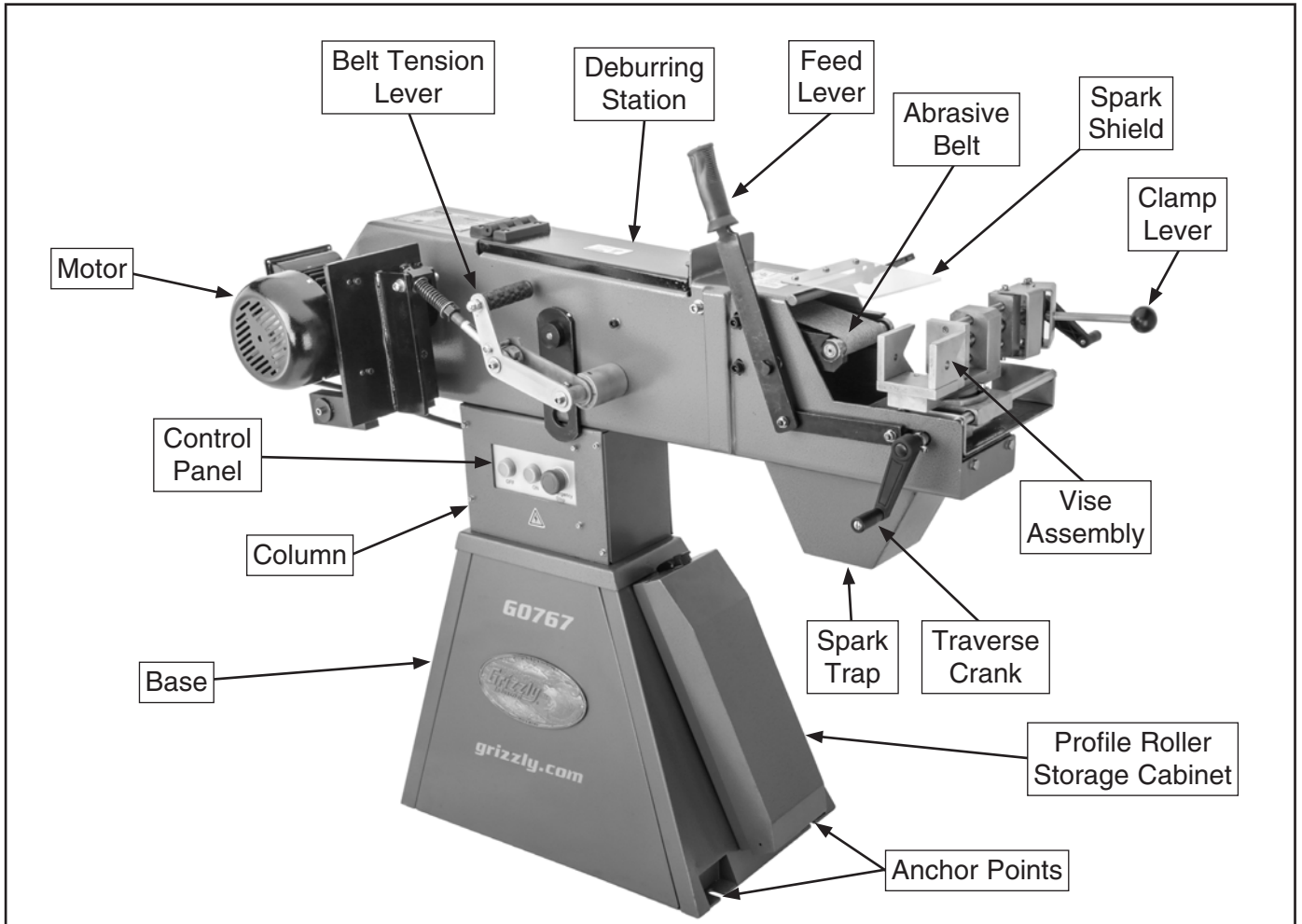
4. **Make sure the motor has stopped and disconnect**
5. **DO NOT expose to rain or dampness.**
6. **DO NOT modify this machine in any way.**
7.
8. **Serial Number** **ended.**
9. **Use of drugs or alcohol.**
10. **Maintain machine carefully to prevent accidents.**

Manufactured for Grizzly in Taiwan

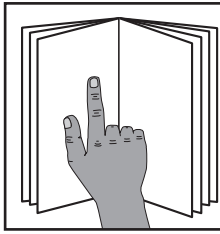


Identification

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



Controls & Components



!WARNING

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

Refer to **Figures 1–2** and the following descriptions to become familiar with the basic controls of this machine.

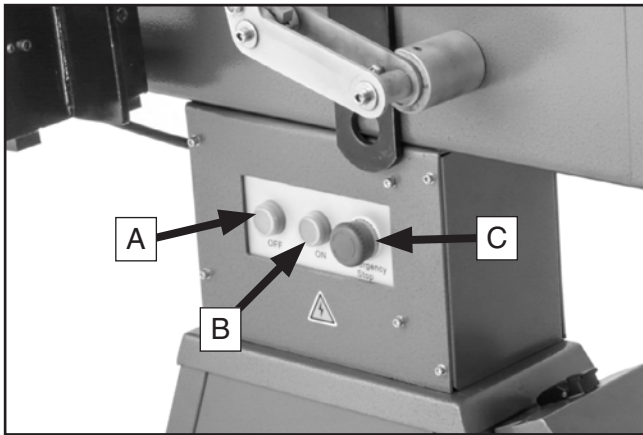


Figure 1. Control panel.

- A. Abrasive Belt OFF Button**
- B. Abrasive Belt ON Button**
- C. Emergency Stop Button:** Cuts power to the motor and remains depressed until reset. Twist clockwise until it pops out to reset.

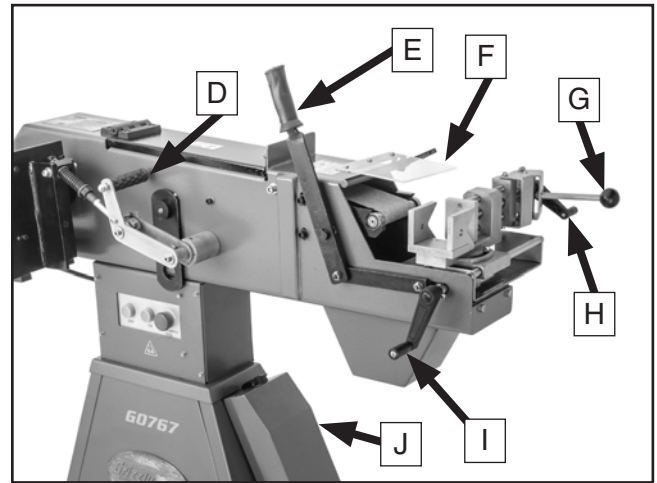


Figure 2. Other controls.

- D. Belt Tension Lever:** Controls abrasive belt tension.
- E. Feed Lever:** Moves tube toward or away from abrasive belt.
- F. Spark Shield Lock Handle:** Secures spark shield in place.
- G. Clamp Lever:** Locks tube between vise jaws so it will not move during grinding.
- H. Clamp Crank:** Adjusts distance between jaws and clamp plate to accommodate diameter of tube.
- I. Traverse Crank:** Moves tube from side-to-side across abrasive belt. This will increase the life of the belt.
- J. Profile Roller Storage Cabinet:** Safely stores profile rollers away from debris and grime.





MACHINE DATA SHEET

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

MODEL G0767 ABRASIVE TUBE NOTCHER

Product Dimensions:

Weight 290 lbs.
Width (side-to-side) x Depth (front-to-back) x Height 31-1/2" x 49-1/4" x 47-1/4"
Foot Print (Length/Width)..... 25-1/2" x 15-3/4"

Shipping Dimensions:

Type Wood Crate
Weight..... 381 lbs.
Length/Width/Height..... 48" x 28" x 45"
Must Ship Upright Yes

Electrical:

Required Requirement..... 220V, Single-Phase, 60 Hz
Full-Load Current Rating..... 14.8A
Minimum Circuit Size 20A
Connection Type..... Cord & Plug
Power Cord Included Yes
Power Cord Length..... 6-1/2 ft.
Power Cord Gauge 12 AWG
Plug Included No
Recommended Plug Type 6-20
Switch Type ON/OFF Push Button

Motor:

Main

Type..... TEFC Capacitor-Start Induction
Horsepower 3 HP
Voltage 220V
Phase Single-Phase
Amps 14.8A
Speed 3360 RPM
Cycle..... 60 Hz
Power Transfer..... Direct
Bearings Shielded and Permanently Sealed



Main Specifications:

Operation Information

Sanding Belt Speed.....	5900 FPM
Sanding Belt Length.....	78-3/4"
Sanding Belt Width.....	4"
Number of Profile Rollers.....	7
Profile Roller Sizes.....	3/4", 1", 1-1/4", 1-1/2", 2", 2-1/2", 3"
Grinding Capacity.....	3/4" – 3" O.D.
Grinding Angle Range.....	90° – 30°

Construction

Stand.....	Formed Steel
Body.....	Formed Steel
Rollers.....	Polished Steel
Paint.....	Powder Coated

Other Specifications:

Country of Origin.....	China
Warranty.....	1 Year
Approximate Assembly & Setup Time.....	1 Hour
Serial Number Location.....	ID Label
ISO 9001 Factory.....	Yes
CSA Certified.....	No

Features:

- Convenient ratcheting system for sanding belt tensioning
- Front debris-catching tray
- Rear 3" dust port
- Easy sanding belt alignment
- Top sanding belt access for deburring
- Compound self-aligning vise with side-to-side adjustment to prevent uneven belt wear
- Transparent safety guard
- Removable spark tray

Accessories:

- 7 rollers (3/4", 1", 1-1/4", 1-1/2", 2", 2-1/2", 3")
- Toolbox with service tools



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 Abrasive Tube Notchers

WARNING

The primary risks of operating a Tube Sander are as follows: You can get seriously injured or killed if clothing, jewelry, or long hair become entangled in rotating machine parts. You can get burned or blinded by hot metal particles that fly out during operation. Flying sparks can ignite explosive or flammable materials, if nearby. Sanding belt will quickly remove skin upon contact. To reduce your risk of serious injury when operating this machine, completely heed and understand the following:

PROTECT YOURSELF FROM HOT SPARKS.

ALWAYS wear approved safety glasses or goggles, a face shield, a respirator, hearing protection, long leather gloves, and a leather apron to reduce the risk of injury from hot, flying sparks when operating. Never allow anyone to stand in path of sparks.

PROTECT YOURSELF FROM ENTANGLEMENT.

Do not wear loose clothing, jewelry or other items that can get caught in moving parts. Tie back hair and roll up long sleeves. Never operate machine with belt cover open.

REDUCE EXPOSURE TO SANDING BELT.

Keep hands away from rotating sanding belt during operation. Keep deburring station cover closed when not in use.

REDUCE RISK OF FIRE AND EXPLOSIONS.

This machine creates a shower of hot sparks that can ignite explosive or flammable materials nearby. Move these types of materials a safe distance away.

WEAR RESPIRATOR.

Sanding creates large amounts of fine particles that may cause long-term respiratory damage. Reduce risk of this hazard by wearing a respirator when using this machine.

USE SPARK SHIELD. Properly adjust and lock spark shield prior to sanding operations.

REDUCE RISK OF BURNS. Workpieces and parts of this machine can get very hot during operation. Always wear long leather gloves when operating machine.

REDUCE RISK OF CUTS. This machine creates burrs, which can cut hands or fingers. Always wear long leather gloves.

PROPERLY MAINTAIN MACHINE. Keep machine in proper working condition to help ensure all guards and other components work as intended and function safely. Perform routine inspections and all necessary maintenance, as indicated in owner's manual. Never operate machine with damaged or worn parts that can break during operation.

DISCONNECT POWER FIRST. To reduce the risk of electrocution or injury from unexpected startup, make sure machine is turned **OFF**, disconnected from power, and all moving parts have come to a complete stop before changing sanding belt or doing any inspection, adjustment, or maintenance procedure.

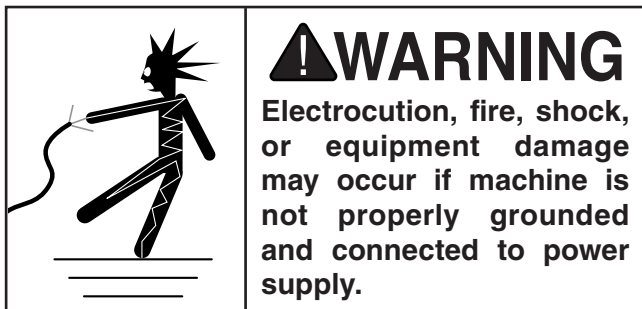
AVOID SUDDEN STARTUP. In the event of a local power outage during operation, immediately press Emergency Stop button to avoid a sudden startup once power is restored.



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 .. 14.8 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 Requirements for 220V

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 20 Amps
Plug/Receptacle NEMA 6-20

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.)



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.*



Grounding Instructions

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.

The power cord and plug specified under “Circuit Requirements for 220V” on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

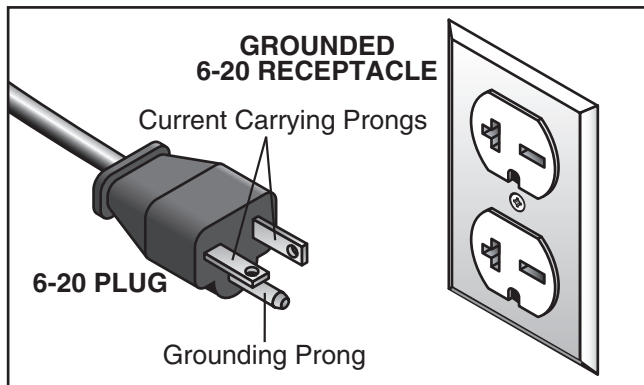


Figure 3. Typical 6-20 plug and receptacle.

!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.

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.

!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.

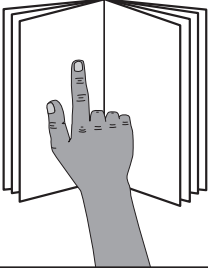
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 Size12 AWG
Maximum Length (Shorter is Better).....50 ft.



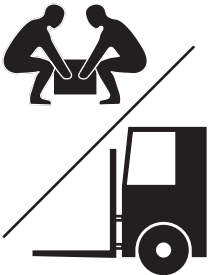
SECTION 3: SETUP



!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
• Additional People	2
• Safety Glasses	1 Per Person
• Forklift or Crane (Rated For at Least 500 lbs.).....	1
• Web Slings (Rated For at Least 500 lbs. Each)	2
• Lifting Chain & Safety Hook (Optional) (Rated For at Least 500 lbs. Each)	1
• Wrench or Socket 13mm.....	1
• Wrench or Socket 16mm.....	1
• Wrench or Socket 17mm	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.



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.

Main Inventory (Figure 4)	Qty
A. Machine Body	1
B. Spark Trap	1
C. Machine Base with Profile Rollers.....	1
—Profile Roller ¾" Dia.	1
—Profile Roller 1" Dia. (Installed).....	1
—Profile Roller 1¼" Dia.	1
—Profile Roller 1½" Dia.	1
—Profile Roller 2" Dia.	1
—Profile Roller 2½" Dia.	1
—Profile Roller 3" Dia.	1
D. Toolbox	1
E. Vise Assembly	1
F. Feed Lever Assembly.....	1
G. Hex Wrenches 2.5, 3, 4, 5, 6, 8mm	1 Ea
H. Phillips Screwdriver #2	1
I. Spanner Wrenches 22–26mm	2
J. Open-End Wrench 13/16mm.....	1

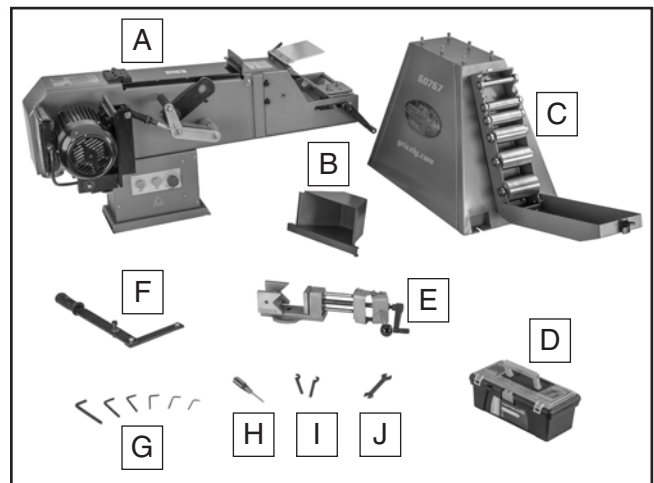


Figure 4. Model G0767 inventory.



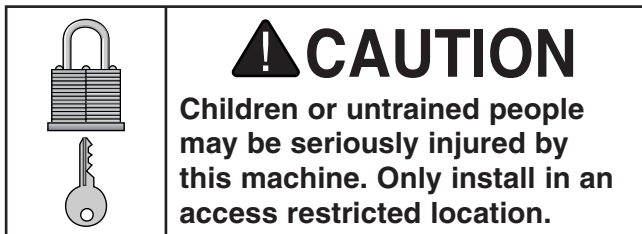
Site Considerations

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.

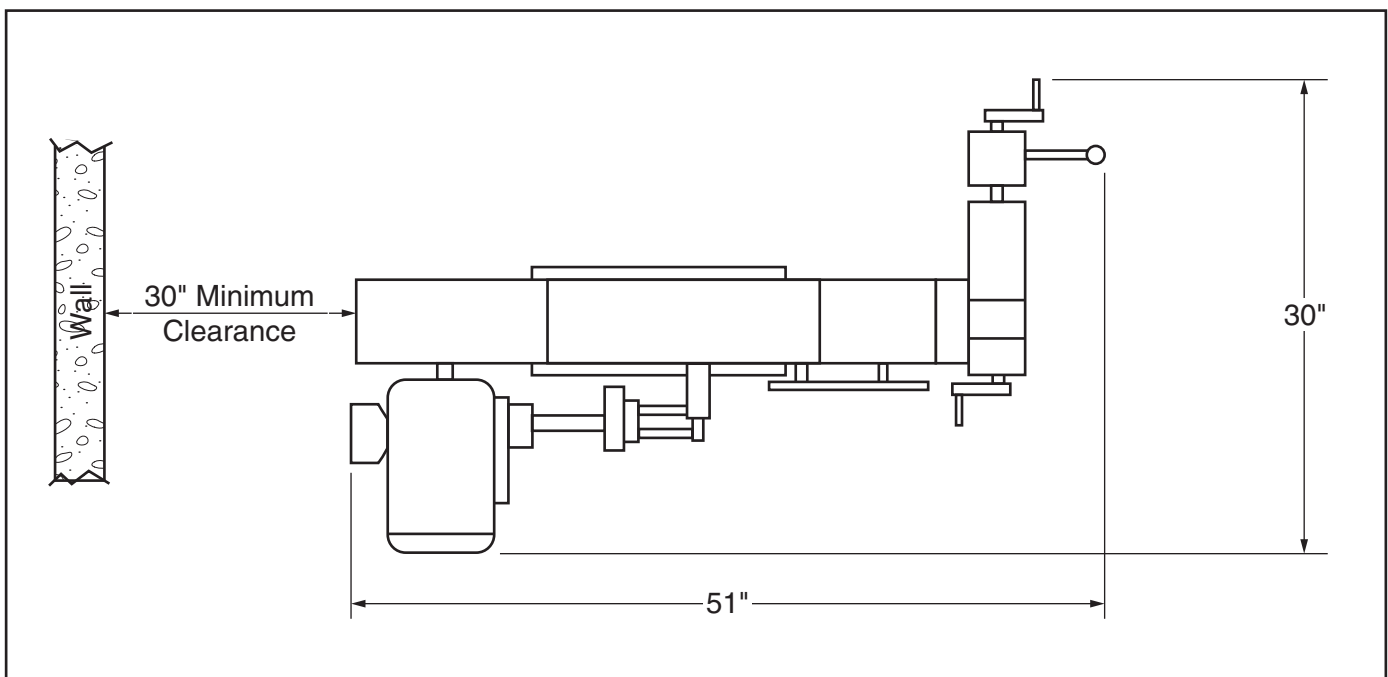


Figure 5. Minimum working clearances.



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 chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 7/16"

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs more quietly and feels more solid.

WARNING

Because of the top heavy nature of the Model G0767 and the dynamic forces exerted during operation, this machine **MUST** be solidly anchored to floor.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you **MUST** follow the anchoring methodology specified by the code.

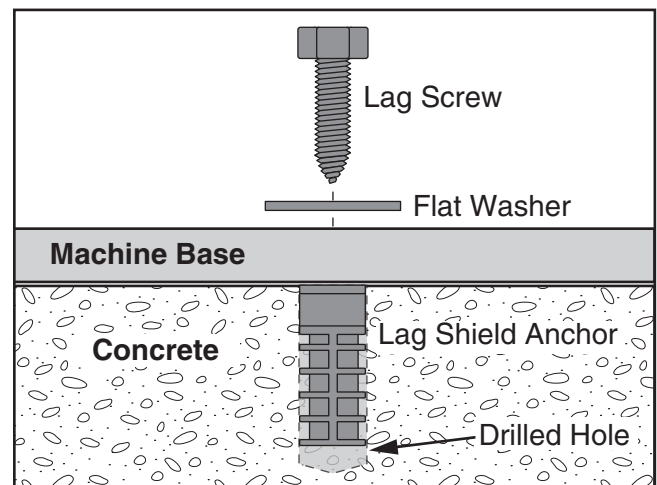


Figure 6. Popular method for anchoring machinery to a concrete floor.



Assembly

To assemble machine:

1. Place shipping crate near operational location, then remove crate from shipping pallet and set small items aside.
2. Unbolt base from shipping pallet.
3. Move base to selected location and properly anchor it to floor (refer to **Anchoring to Floor** on previous page).
4. Remove the four cap screws that secure electrical box inside column (see **Figure 7**).

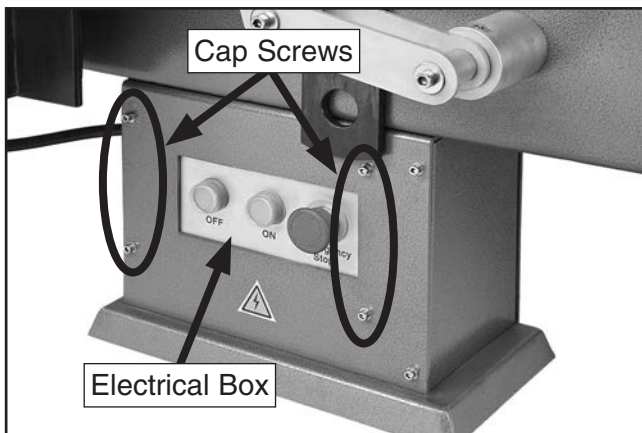


Figure 7. Location of cap screws that secure electrical box.

5. Slide electrical box out of column and place on top of motor.
6. Remove column front cover by removing the four cap screws that secure it (see **Figure 8**).

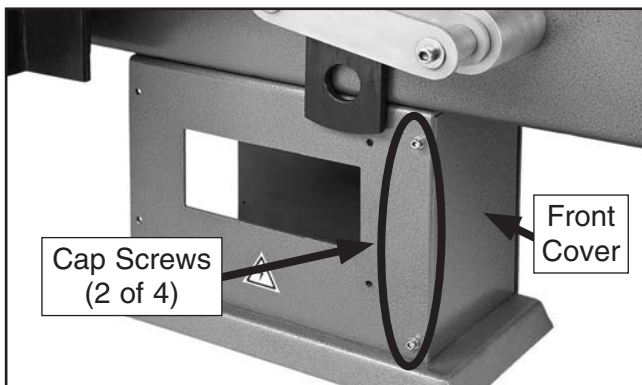


Figure 8. Location of column front cover and securing cap screws.

7. Remove the six pre-installed cap screws from top of base (see **Figure 9**).



Figure 9. Cap screws on top of base.

8. Have another person hold machine steady so that it does not tip, then remove hex nuts that secure machine column to pallet.
9. Listed below are two methods for lifting machine onto base. Use method that is best for your operation.

—Wrap web slings around machine and attach them to a lifting device (see **Figure 10** for an example).

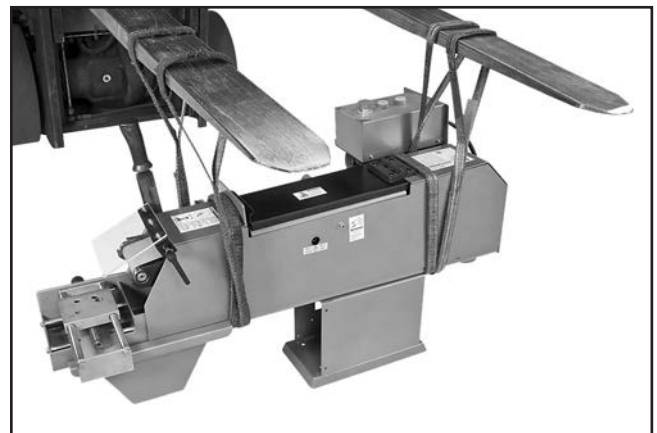


Figure 10. Example photo of web slings positioned on machine and lifting device.



—Rotate lifting bar up (see **Figure 11**), and attach lifting chain and safety hook between lifting bar and lifting device.

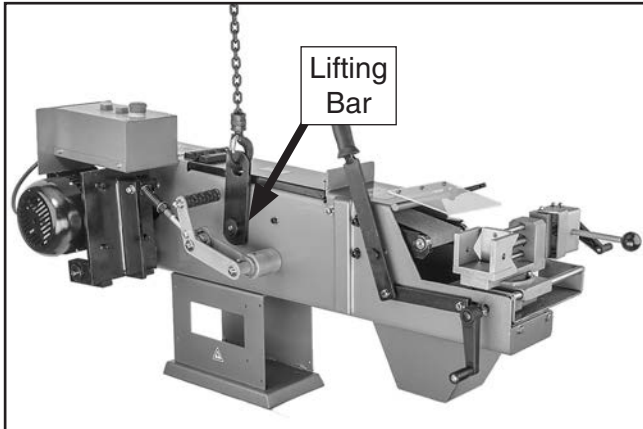


Figure 11. Example photo of lifting machine with chain and hook.

10. With two other people holding onto machine to steady and balance the load, lift machine onto base and position it so vise and roller storage cabinet both face the front of machine.

11. Secure machine to base with six cap screws removed in **Step 7** (see **Figure 12**).

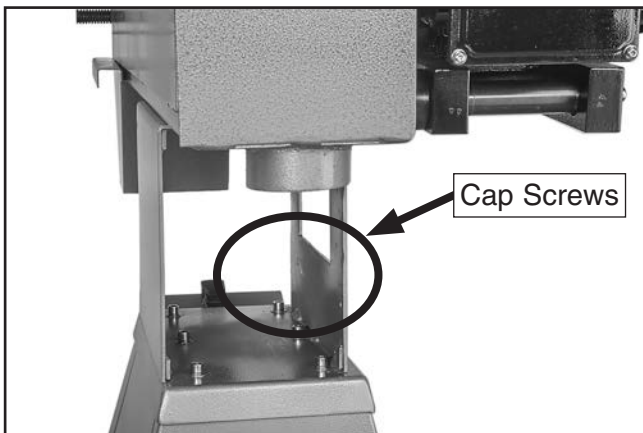


Figure 12. Machine attached to base.

12. Re-install column front cover removed in **Step 6**.

13. Re-install electrical box in column.

14. Remove pre-installed fasteners shown in **Figure 13**. These fasteners will secure feed lever assembly in next step.

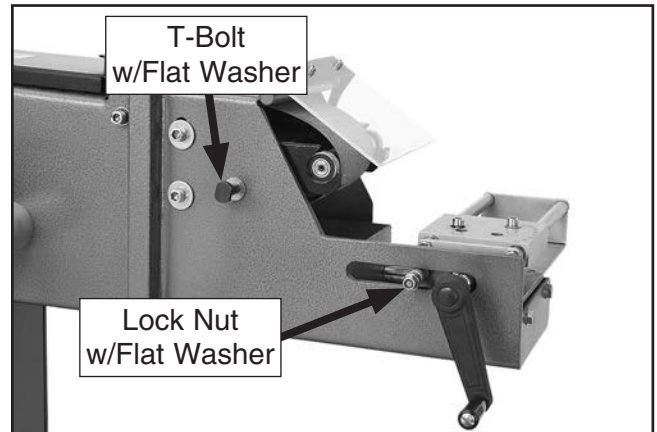


Figure 13. Locations of feed lever fasteners.

15. Attach feed lever assembly to machine with fasteners removed in **Step 14** (see **Figure 14**).

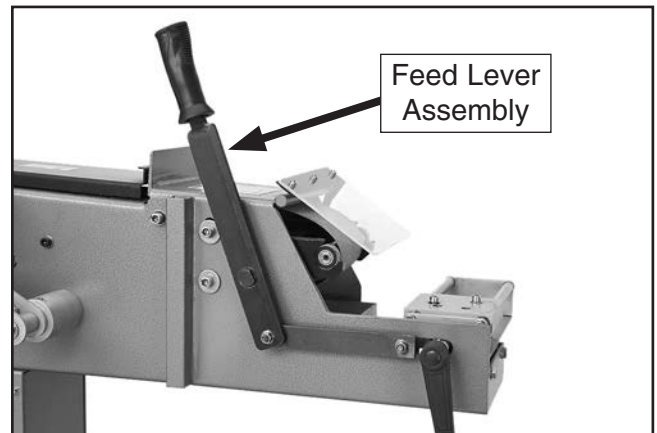


Figure 14. Feed lever assembly attached.



16. Remove the two pre-installed vise mounting cap screws shown in **Figure 15**.

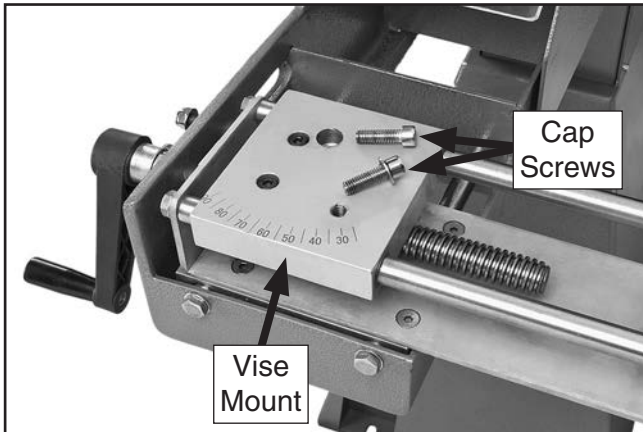


Figure 15. Vise mounting cap screws.

17. Position vise assembly on vise mount and secure it with cap screws removed in **Step 16** (see **Figure 16**).

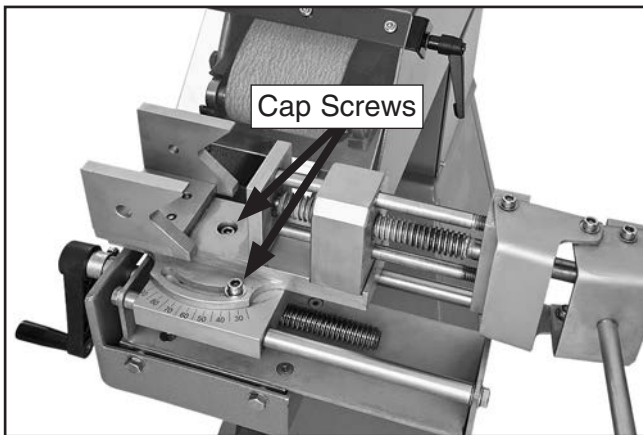


Figure 16. Vise assembly attached.

18. Slide spark trap into grooves on right side of machine, as shown in **Figure 17**.

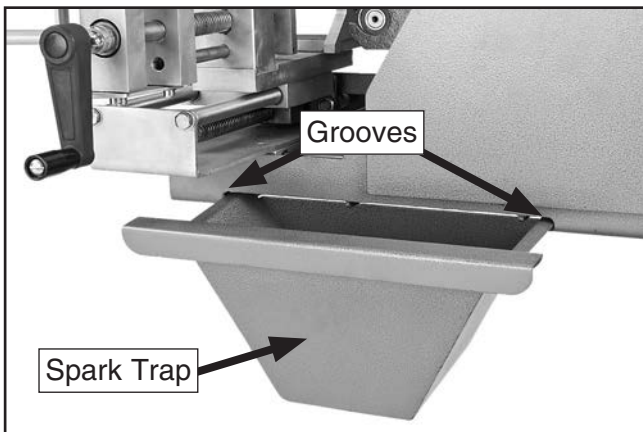


Figure 17. Spark trap positioned in grooves.

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.

!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 make the test run quicker and easier to perform, you will be instructed to remove the abrasive belt from the machine. If you choose to leave the belt on the machine for the test run, you **MUST** perform the **Replacing Abrasive Belt** procedure on **Page 21** and **Abrasive Belt Tracking** procedure on **Page 23** to make sure the belt is properly tensioned and tracked, and will not fall off the rollers during the test run.

To test run machine:

1. Using a 6mm hex wrench, loosen cap screw that secures belt cover and open cover to expose abrasive belt (see **Figure 18**).

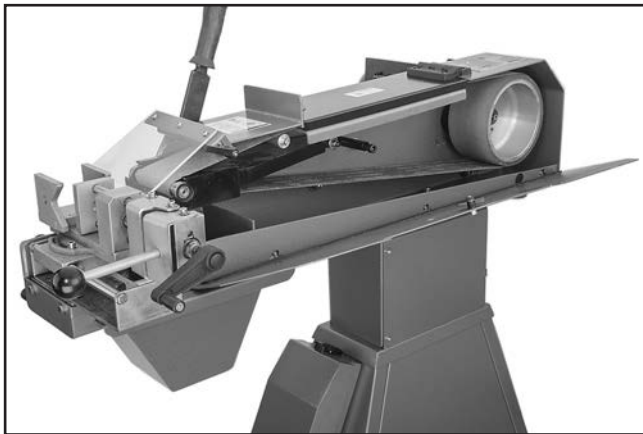


Figure 18. Belt cover opened.

2. Pull belt tension lever up and toward front of machine with one hand as you guide motor forward with other hand (see **Figure 19**). This releases abrasive belt tension.

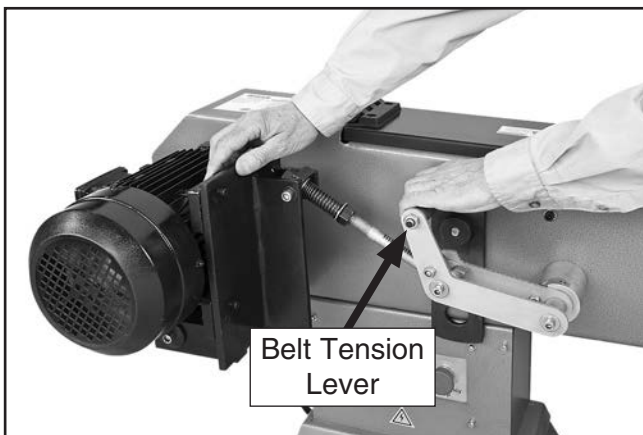


Figure 19. Releasing abrasive belt tension.

3. Remove abrasive belt.
4. Close and secure belt cover.
5. Clear all setup tools away from machine.
6. Connect machine to power supply.
7. Twist Emergency Stop button clockwise until it pops out—this resets switch so machine will start (see **Figure 20**).



Figure 20. Location of Emergency Stop button.

8. Push ON button to start machine. A correctly operating machine runs smoothly with little or no vibration or rubbing noises.
9. Press Emergency Stop button to turn machine **OFF**.
10. **WITHOUT** resetting the Emergency Stop button, press ON button. Machine should not start.

—If machine *does* start (with Emergency Stop button pressed in), immediately disconnect power to machine. The Emergency Stop button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Note: To re-install abrasive belt, perform **Installing Abrasive Belt** procedure on **Page 21**.



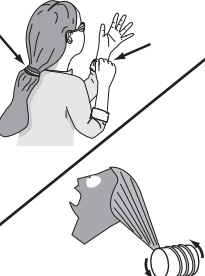
SECTION 4: OPERATIONS

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

<p>! WARNING To reduce risk of eye or face injury from flying sparks, always wear approved safety glasses and a face shield when operating this machine.</p>	
	

To complete a typical operation, the operator does the following:

1. Examines tube to make sure the diameter is appropriate for operation and the end does not have any burrs that could damage abrasive belt or machine.
2. Adjusts vise angle, if necessary, to the correct angle of the desired cut.
3. Makes sure abrasive belt is properly tensioned and tracked.
4. Puts on personal protective equipment.
5. Secures tube in vise.
6. Properly adjusts spark shield.
7. Starts machine.
8. Uses feed lever and traverse crank to make light side-to-side passes of tube against abrasive belt.
9. Stops machine and removes tube.

<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>
--



Replacing Abrasive Belt

Whenever the abrasive belt becomes worn or damaged, replace it. The Model G0767 uses a 4" x 79" silicon-carbide abrasive belt (refer to **Page 28** for abrasive belts available from Grizzly).

Use coarser grit belts for fast cutting and hard metals. Use finer grit belts for softer metals and a smoother finish.

Tool Needed	Qty
Hex Wrench 6mm.....	1

To replace abrasive belt:

1. DISCONNECT MACHINE FROM POWER!
2. Pull belt tension lever up and toward front of machine with one hand as you guide motor forward with other hand (see **Figure 21**). This releases abrasive belt tension.

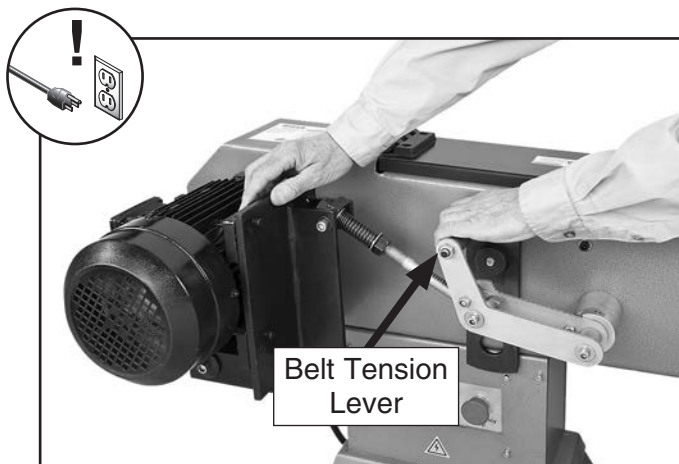


Figure 21. Releasing abrasive belt tension.

3. Loosen cap screw that secures belt cover (see **Figure 22**), then open cover and remove abrasive belt from machine.

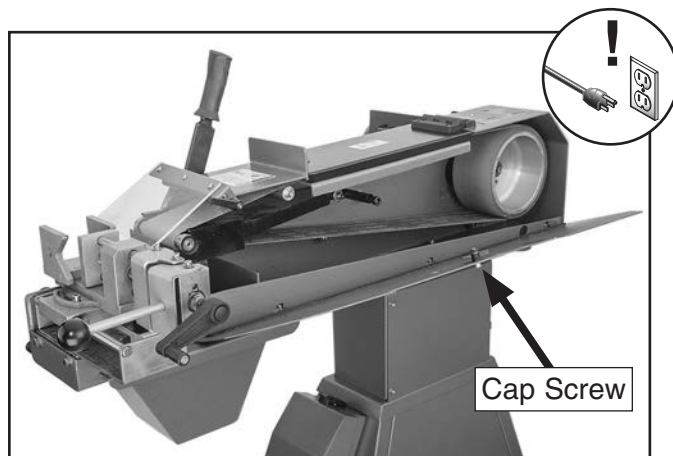


Figure 22. Belt cover opened.

4. Place desired profile roller in support bracket (refer to **Replacing Profile Roller** on next page for detailed instructions).
5. Slide abrasive belt onto profile roller, drive pulley, and over deburring platen so that direction arrows stamped on inside of belt are pointing in same direction as arrows shown in **Figure 23**.

Note: Arrows on bottom inside of belt should point to the right.

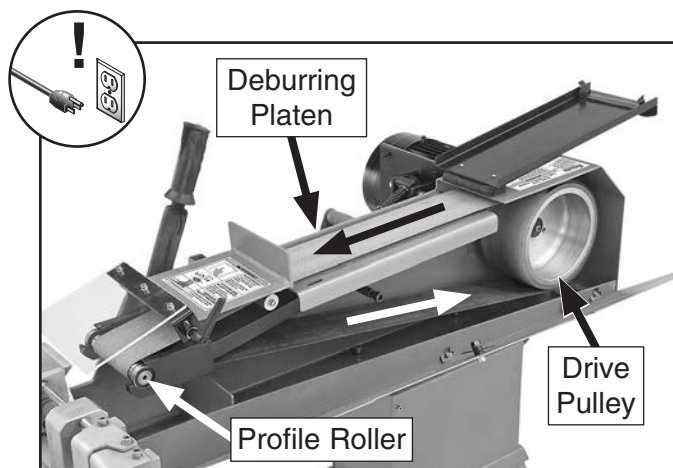


Figure 23. Correct installation and orientation of abrasive belt direction arrows.



6. Center belt on drive pulley.
7. Without holding abrasive belt lever, push motor back with moderate force until it stops. This applies correct abrasive belt tension.
8. Perform **Abrasive Belt Tracking** procedure on next page.

Replacing Profile Roller

The Model G0767 includes seven profile rollers ranging from $\frac{3}{4}$ " to 3". The size of profile roller you use will depend on the size of tubing your workpiece will be welded to.

To install profile roller:

1. DISCONNECT MACHINE FROM POWER!
2. With abrasive belt removed, remove profile roller from support bracket (see **Figure 24**).

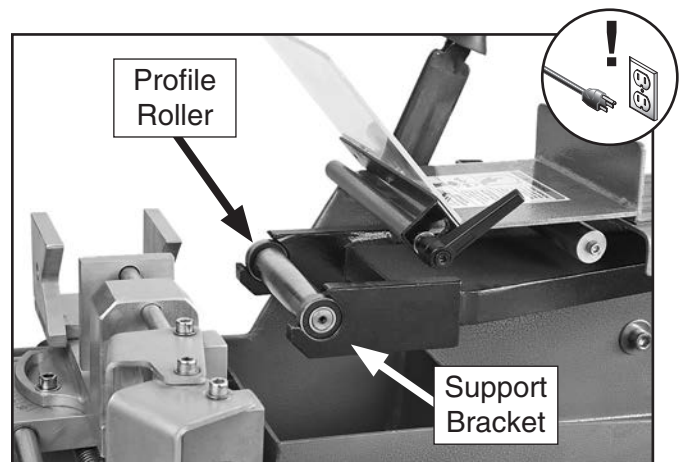


Figure 24. 1" profile roller installed.

3. Thoroughly clean all surfaces of profile roller with sop rag and mineral spirits, then apply a light coat of rust preventative before placing roller in storage cabinet.
4. Repeat **Step 3** with desired profile roller to be installed.
5. Place desired profile roller in support bracket and install abrasive belt.



Abrasive Belt Tracking

The abrasive belt must track in the center of the drive pulley and profile roller to avoid presenting an injury hazard or damaging the belt or machine.

Tools Needed	Qty
Hex Wrench 6mm.....	1
Hex Wrench 8mm.....	1

Checking Abrasive Belt Tracking

1. DISCONNECT MACHINE FROM POWER!
2. Open belt and deburring station covers.
3. Rotate drive pulley (see **Figure 25**) counterclockwise several times by hand.

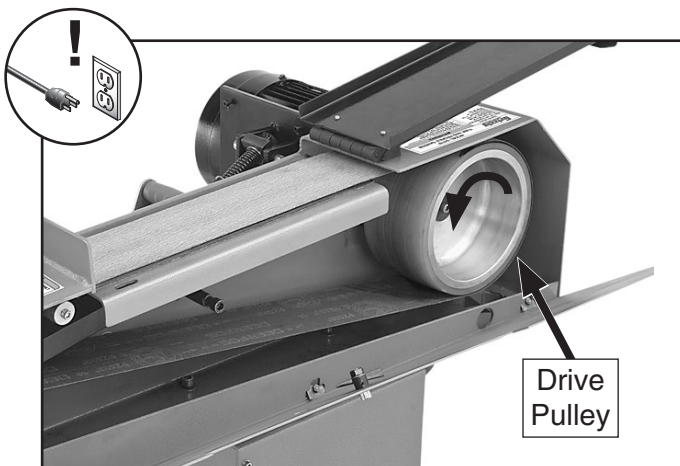


Figure 25. Location of drive pulley.

—If abrasive belt tracks in center of drive pulley, close and secure belt and deburring station covers.

—If abrasive belt moves to one side or the other while it is rotating, the belt tracking needs to be adjusted. Perform **Adjusting Abrasive Belt Tracking** procedure on this page.

Adjusting Abrasive Belt Tracking

Adjustments to the abrasive belt tracking are made with the machine running. These adjustments are made in small amounts to make sure the belt does not track too far from the center, which could damage the belt and machine.

To adjust abrasive belt tracking:

1. Make sure belt and deburring station covers are closed and secured.
2. Have another person position their hand over Emergency Stop button to quickly turn machine **OFF** and prevent damage if abrasive belt moves too close to side of machine.
3. Connect machine to power, turn it **ON**, and observe to which side abrasive belt tracks.

—If abrasive belt tracks to the *left* (as viewed from front of machine), rotate tracking adjustment cap screw (see **Figure 26**) *counterclockwise* in small amounts until abrasive belt tracks in center.



Figure 26. Location of tracking adjustment cap screw.

—If abrasive belt tracks to the *right* (as viewed from front of machine), rotate tracking adjustment cap screw *clockwise* in small amounts until abrasive belt tracks in center.



Operational Tips

- When grinding against the profile roller, make sure all covers are closed securely and spark shield is properly positioned.
- Use multiple light passes instead of a few heavy passes to increase the life of abrasive belt and decrease the need to deburr along notch edges.
- Make sure tube is firmly secured in vise and any tube longer than 3' is supported at the opposite end by another person.
- Tube gets hot as you continue operation. Cool it frequently by quenching in water or quenching salt solution.
- Change belts frequently and use correct grit for best performance.
- DO NOT force or jam tube into abrasive belt.
- When not in use, release abrasive belt tension to increase life of belt.
- Hot particles flying off of abrasive belt travel very fast—prepare for this! Wear proper personal protective equipment (refer to Warning box on **Page 26** for additional details).
- Grinding metal produces flying sparks. DO NOT allow anyone to stand in path of sparks. DO NOT grind near flammable materials or fumes.
- Concentrate on task at hand. STOP grinding if you become distracted.

Making Notch

Making a notch in the tube consists of preparing the tube, properly setting up the machine, mounting the tube in the vise, and grinding the notch.

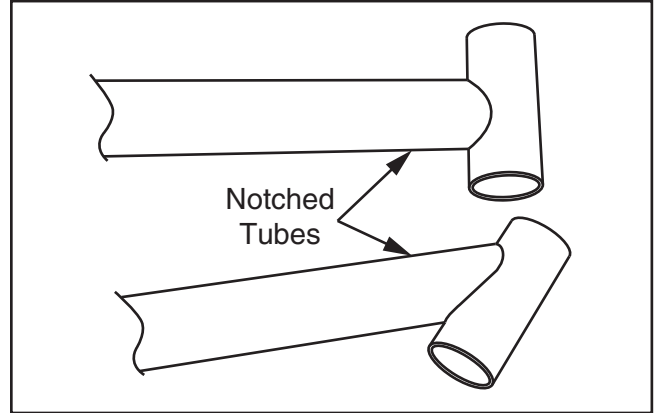


Figure 27. Example illustrations of fitting notched tubes.

Tool Needed	Qty
Hex Wrench 6mm.....	1

To make a notch:

1. Make sure tube end to be notched is smoothly cut without any burrs.
2. Install profile roller that will produce the correct diameter notch for size of tubing your workpiece will be welded to.
3. Make sure abrasive belt is properly tensioned and tracked.
4. DISCONNECT MACHINE FROM POWER!
5. Push feed lever (see **Figure 28**) toward motor to move vise away from abrasive belt.

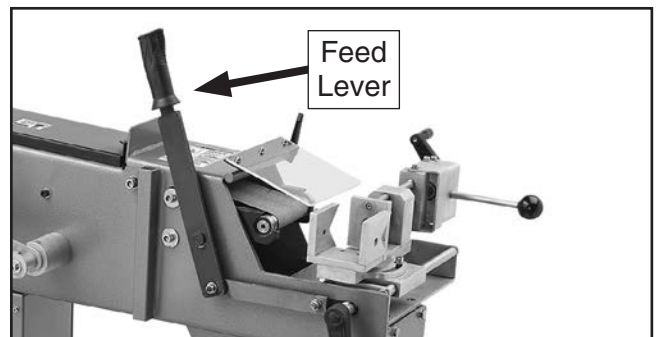


Figure 28. Feed lever pushed toward motor.



- Loosen vise cap screws shown in **Figure 29**.

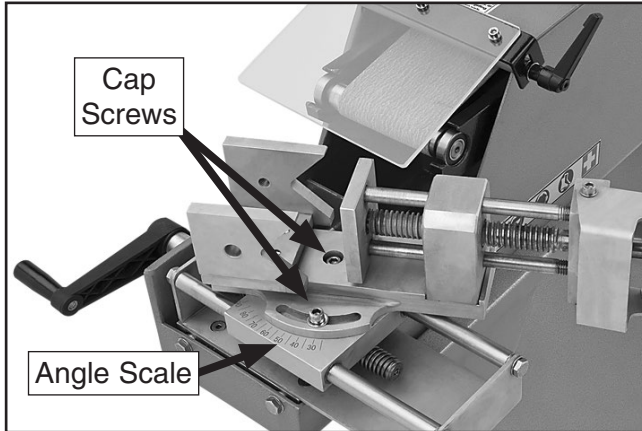


Figure 29. Vise angle controls.

- Using angle scale, rotate vise to desired angle of notch (from 90° to 30° in relation to front profile roller), then retighten both cap screws.
- Use crank handle (see **Figure 30**) to adjust space between clamp plate and jaws to accept tube.

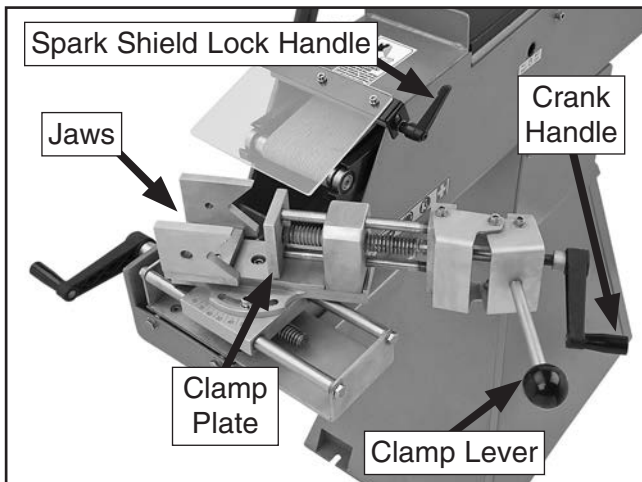


Figure 30. Vise clamping controls.

⚠ WARNING

When mounting tubes longer than 3', have another person support end of tube. This will reduce risk of tube unexpectedly coming loose in vise during operation and causing impact injuries or property damage.

NOTICE

In next step, make sure tube end you plan to notch is protruding far enough out of vise that vise will not contact belt during operation. Otherwise, property damage may occur.

- Insert tube between jaws and clamp plate (see **Figure 31**), making sure tube extends far enough that notching operation can be performed without vise contacting belt.

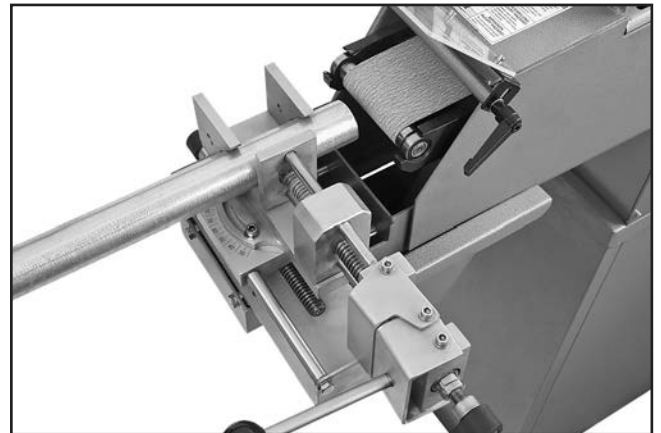

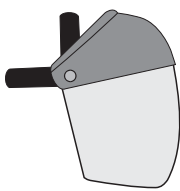
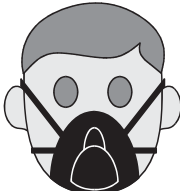





Figure 31. Tube inserted in vise.

- Loosen clamp lever (**Figure 30**), then use crank handle to position clamp plate within 1/16" of tube.
- Tighten clamp lever to lock tube in place.
Note: If it is too difficult to secure tube with clamp lever, use crank handle to slightly increase distance between clamp plate and tube, then try again.
- Position spark shield over profile roller and lock it in place (see **Figure 30**).



13. Put on PPE (Personal Protective Equipment).

<p>⚠ WARNING PERSONAL PROTECTIVE EQUIPMENT (PPE) The Model G0767 produces a large amount of sparks that can cause burns and injuries to skin, eyes, and face. ALWAYS wear safety goggles, face shield, dust mask, heavy leather, long sleeve gloves, and leather apron to reduce the risk of injury from flying sparks when operating. Also, wear leather boots with toe protection to reduce risk of injury from a falling tube.</p>		
		
		

14. Turn machine **ON** and wait until abrasive belt reaches full speed.

15. Stand to side of machine to avoid path of sparks during next step.

16. Use feed lever (see **Figure 32**) to bring tube in light contact with abrasive belt as you use rotate traverse crank to move tube across abrasive belt.

Note: Moving tube back and forth across abrasive belt reduces wear in any one spot and increases life of belt.

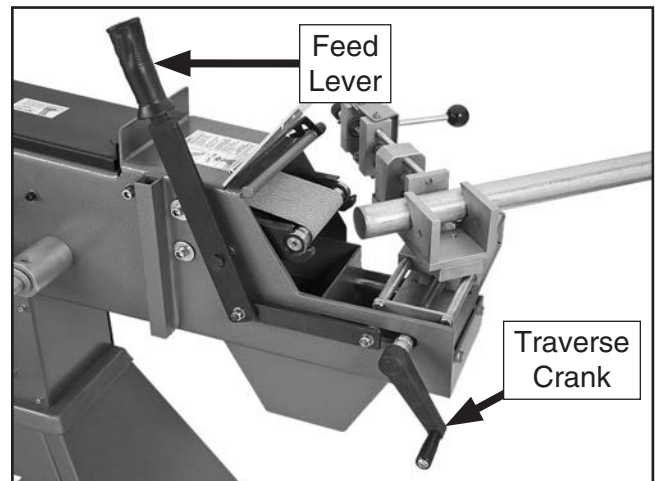


Figure 32. Feed and traverse controls.

17. When notch is complete, use feed lever to move tube away from abrasive belt (see **Figure 33** for an example).

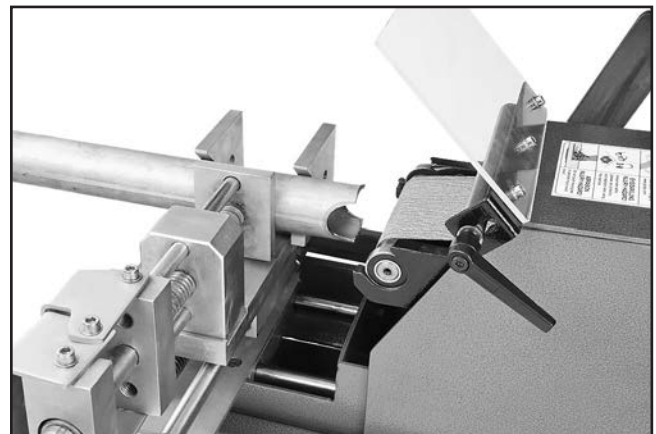


Figure 33. Example of notch in end of tubing.

18. Turn machine **OFF** and wait for abrasive belt to completely stop.

19. Loosen clamp lever and remove tube.



Deburring

Sharp burrs in the tube are typically created during notching. These should be ground off for safe handling and clean welds during tubing.

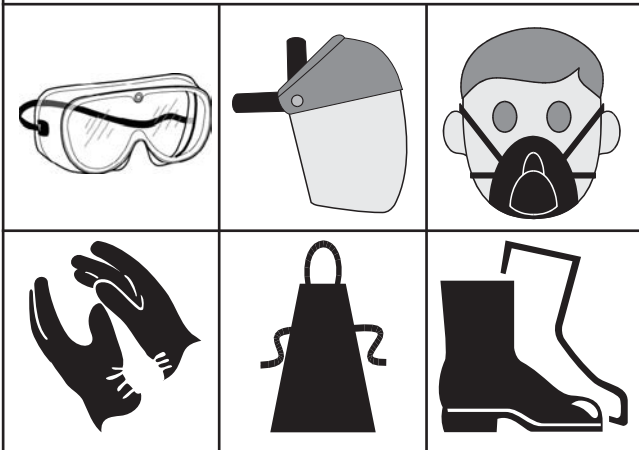
To deburr notched tubing:

1. Put on PPE.

⚠️ WARNING

PERSONAL PROTECTIVE EQUIPMENT (PPE)

The Model G0767 produces a large amount of sparks that can cause burns and injuries to skin, eyes, and face. **ALWAYS** wear safety goggles, face shield, dust mask, heavy leather, long sleeve gloves, and leather apron to reduce the risk of injury from flying sparks when operating. Also, wear leather boots with toe protection to reduce risk of injury from a falling tube.



2. Open deburring station cover to expose abrasive belt.
3. Stand to side of machine and turn machine **ON**, then wait until abrasive belt reaches full speed.

Note: Abrasive belt travels towards front of machine at the deburring station.

4. Position tube at a slight angle to abrasive belt (see **Figure 34**) and make light contact with belt. Rotate tube to deburr entire circumference of notched end.



Figure 34. Tube positioned for deburring.

5. When finished, turn machine **OFF**, wait for abrasive belt to completely stop, and close deburring station cover.



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.

4" x 79" Silicon-Carbide Abrasive Belts
T26604—60 Grit, 10-Pk.
T26605—80 Grit, 10-Pk.
T26606—100 Grit, 10-Pk.
T26607—120 Grit, 10-Pk.
T26608—150 Grit, 10-Pk.

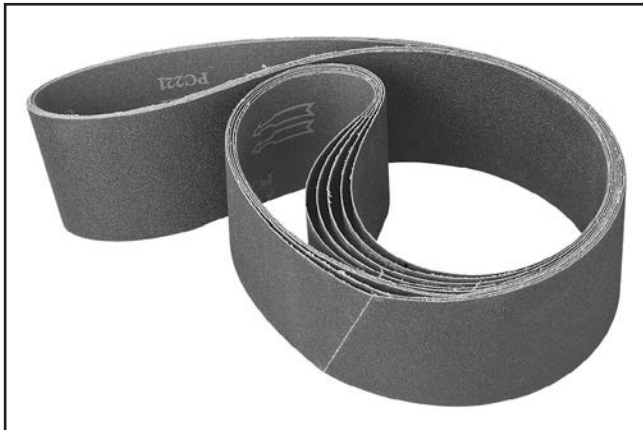


Figure 35. 4" x 79" silicon-carbide abrasive belts.

Hydraulic Tube Benders

Any serious do-it-yourselfer or job shop must have one of these! The included bending dies are sized in pipe diameters.

G9017—12 Ton

Capacities:

- 1/2", 3/4", 1", 1 1/4", 1 1/2", and 2" pipe
- 2" maximum pipe size while bending to 90°
- Schedule 40 wall thickness

G9018—16 Ton

Capacities:

- 1/2", 3/4", 1", 1 1/4", 2 1/2", 1 1/2", and 3" pipe
- 3" maximum pipe size while bending to 90°
- Schedule 40 wall thickness

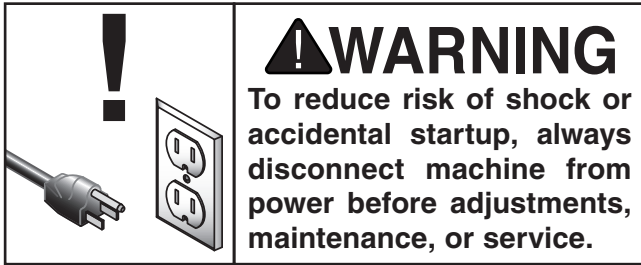


Figure 36. Hydraulic tube bender.

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



SECTION 6: MAINTENANCE



Schedule

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

Daily Maintenance

- Check/tighten mounting bolts.
- Check/replace worn/damaged abrasive belt.
- Empty spark trap.
- Vacuum debris from floor around machine.
- Check/repair worn or damaged wires.
- Check/resolve any other unsafe issues.

Weekly Maintenance

- Clean machine.
- Clean and protect front profile rollers.
- Clean and lubricate vise guide rods and leadscrews.

Cleaning

Use a shop vacuum to remove debris from the outside of the machine, especially from the moving parts of the belt tension lever and vise. Open the belt and deburring station covers, remove the abrasive belt, and vacuum all debris from inside machine, rollers, and deburring platen.

Metal debris from flying sparks left on the floor presents a slipping hazard. Vacuum the area around the machine on a daily basis.

Wipe the profile rollers clean with shop rags and mineral spirits. When dry, apply a light coat of rust preventative.

Lubrication

Vise Guide Rods

The tube vise moves side-to-side and from front-to-back on four guide rods (see **Figure 37**).

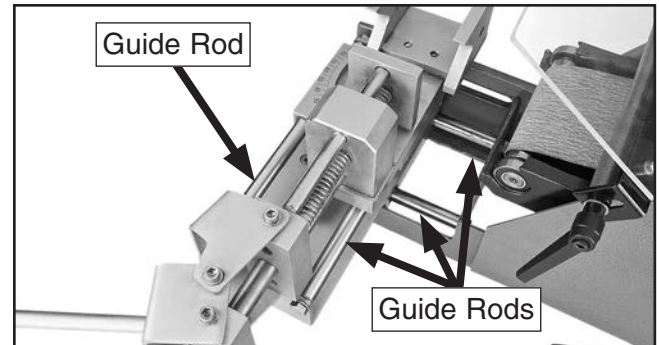


Figure 37. Locations of vise guide rods.

Move the vise as necessary to access the full length of the guide rods and clean any debris from their surfaces with shop rags and mineral spirits. When dry, wipe with a clean shop rag damp with light machine oil.

Leadscrews

The vise has two leadscrews (see **Figure 38**). Move the vise as necessary through the full length of the leadscrews and clean any debris from the threads with a stiff brush and mineral spirits. When dry, apply a thin coat of light machine oil and work the lubricant into the threads with a clean, stiff brush. Wipe away any excess oil. Move the vise through the full length of each leadscrew to distribute the oil.

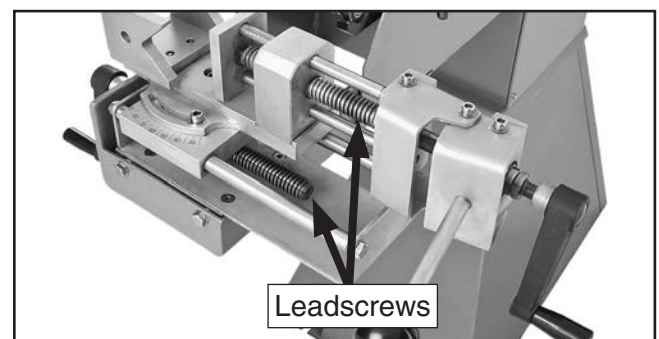


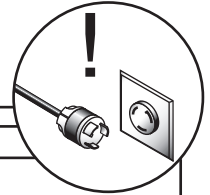
Figure 38. Locations of vise leadscrews.



SECTION 7: 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



Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> Emergency Stop button engaged/at fault. Power supply switched OFF or at fault. Motor connection wired incorrectly. Thermal overload relay has tripped. Power supply fuse/circuit breaker is blown/tripped. Contactors not getting energized or has burnt contacts. Wiring is open/has high resistance. Motor at fault. 	<ol style="list-style-type: none"> Rotate clockwise until it pops out/replace. Ensure power supply is switched ON; ensure power supply has correct voltage. Correct motor wiring connections (Page 34). Disconnect machine from power, turn amperage dial on thermal overload relay to a higher setting. Ensure power supply circuit size is adequate for this machine (Page 10); replace weak breaker. Test for power on all legs and contactor operation. Replace if faulty. Check for broken wires or disconnected/corroded connection, and repair/replace as necessary. Test/repair/replace.
Machine stalls or is overloaded.	<ol style="list-style-type: none"> Feed rate too fast. Motor connection wired incorrectly. Motor bearings at fault. Machine undersized for task. Contactors not getting energized/has burnt contacts. Motor has overheated. Motor at fault. 	<ol style="list-style-type: none"> Reduce feed rate. Correct motor wiring connections (Page 34). Test by rotating motor shaft; rotational grinding/loose shaft requires bearing replacement. Use new abrasive belt with appropriate grit; reduce feed rate. Test for power on all legs and contactor operation. Replace if faulty. Clean off motor, let cool, and reduce workload. Test/repair/replace.
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> Motor mounting loose. Motor fan hitting cover. Abrasive belt torn. 	<ol style="list-style-type: none"> Retighten motor mount fasteners. Repair/replace motor fan; remove any dents in cover. Replace abrasive belt (Page 21).
Abrasive belt stops rotating under load.	<ol style="list-style-type: none"> Abrasive belt not properly tensioned. Feed rate too fast. 	<ol style="list-style-type: none"> Properly tension abrasive belt (Page 21). Reduce feed rate.
Abrasive belt tracks to one side under load.	<ol style="list-style-type: none"> Abrasive belt tracking not properly set. Abrasive belt not properly tensioned. 	<ol style="list-style-type: none"> Properly set abrasive belt tracking (Page 23). Properly tension abrasive belt (Page 21).
Abrasive belt excessively worn in one spot.	<ol style="list-style-type: none"> Tube not moved across face of abrasive belt during operation. 	<ol style="list-style-type: none"> Use traverse crank to evenly move tube across face of abrasive belt during operation.
Tube has burn marks at notch.	<ol style="list-style-type: none"> Abrasive belt worn/not correct grit for task. Feed rate too fast. 	<ol style="list-style-type: none"> Use new abrasive belt with appropriate grit. Reduce feed rate.
Notch not centered on tube.	<ol style="list-style-type: none"> Profile roller not even with center of tube. 	<ol style="list-style-type: none"> Adjust profile roller height (Page 31).



Adjusting Profile Roller Height

To produce an accurate notch, the center of the profile roller must be even with the center of the tube when mounted in the vise (see **Figure 39**).

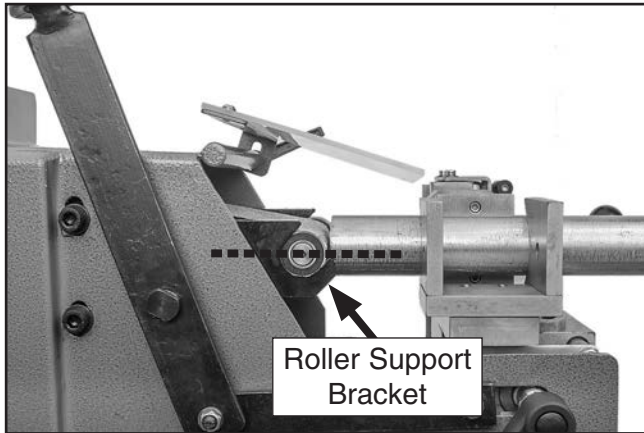


Figure 39. Profile roller and tube even with each other.

The correct height of the profile roller depends on the height of the roller support bracket. This was set properly at the factory. However, if you determine that the center of the profile roller is not even with the center of the tube when mounted in the vise, perform the following procedure to adjust it.

Tool Needed	Qty
Hex Wrench 8mm.....	1

To adjust roller support bracket height:

1. DISCONNECT MACHINE FROM POWER!
2. Properly mount a tube in vise.
3. Loosen the two roller support bracket cap screws shown in **Figure 40**.

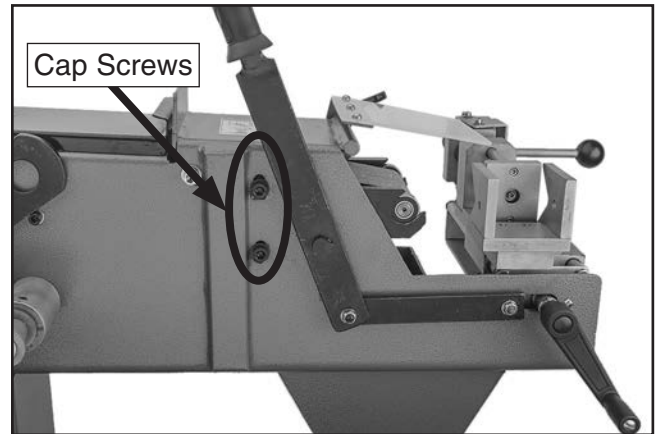


Figure 40. Location of roller support bracket cap screws.

4. Move profile roller up or down to center profile roller with center of tube.
5. Retighten the two cap screws loosened in **Step 3**.



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.













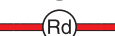

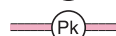
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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			



G0767 Wiring

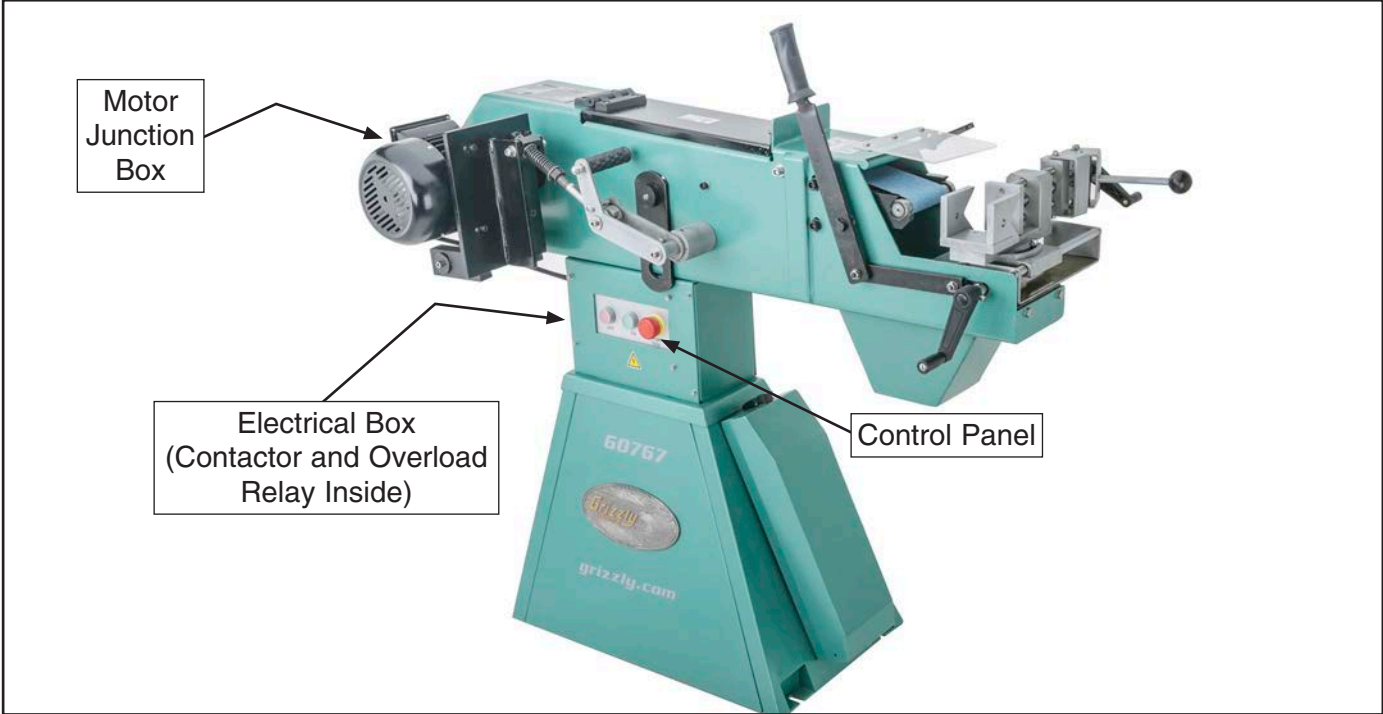


Figure 41. Wiring overview showing component locations.

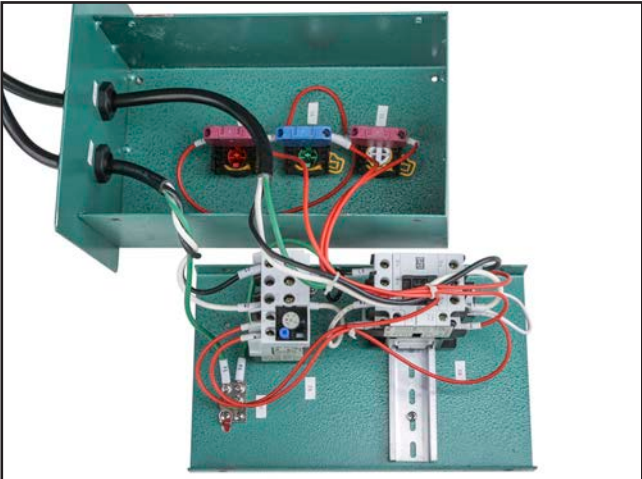


Figure 42. Control panel (viewed from behind) and electrical box pulled out and opened.

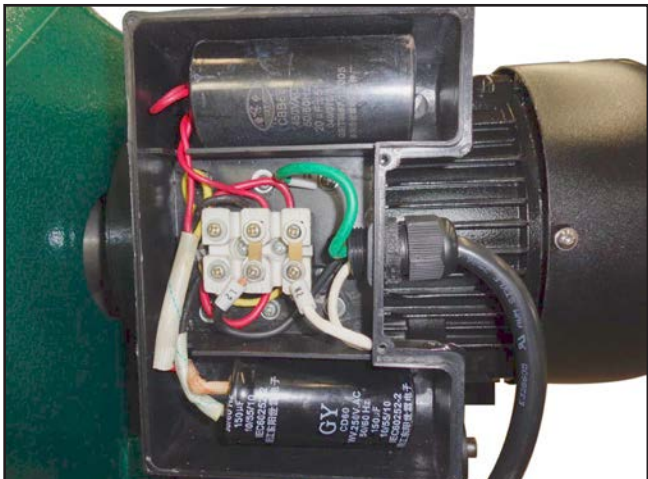
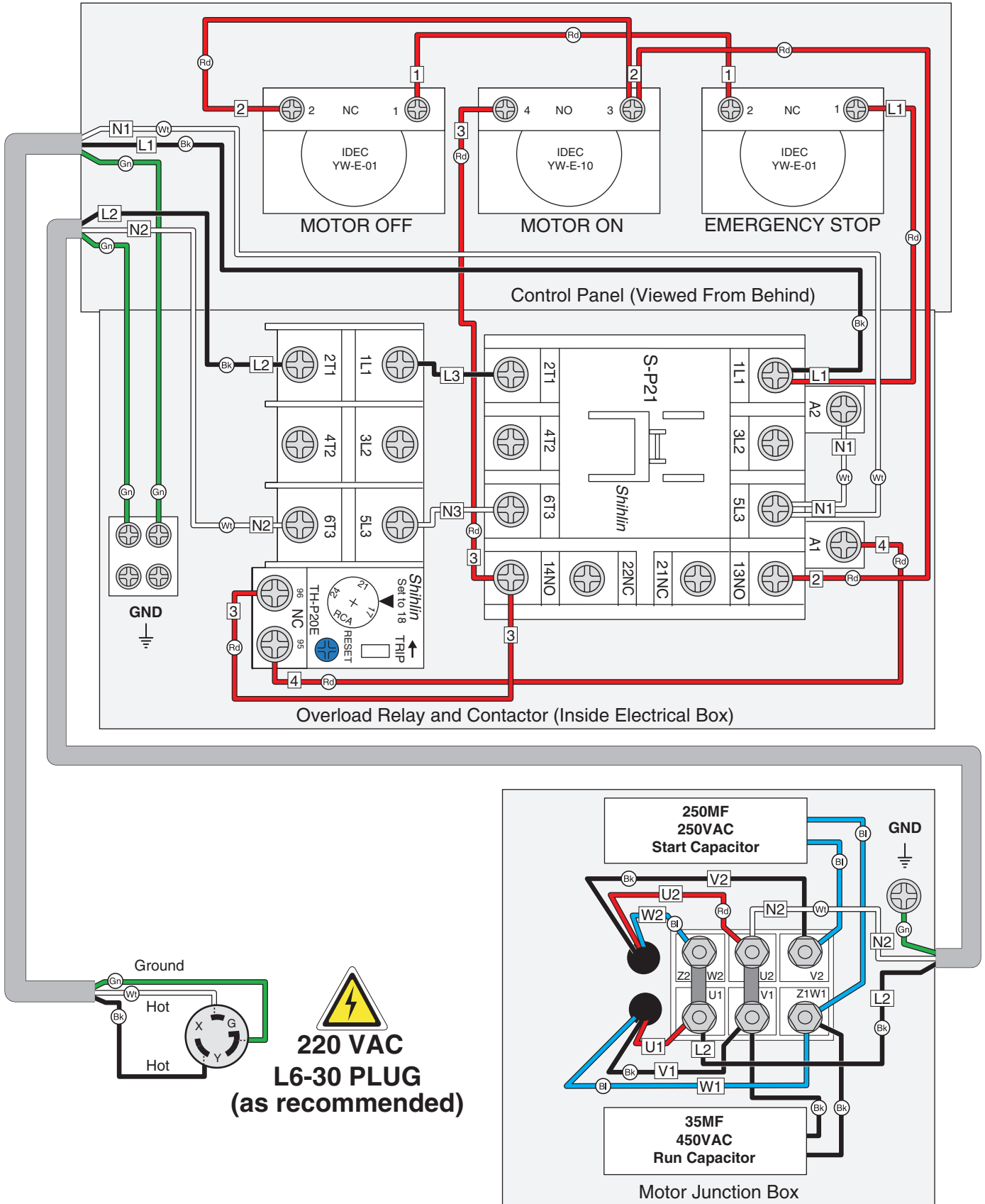


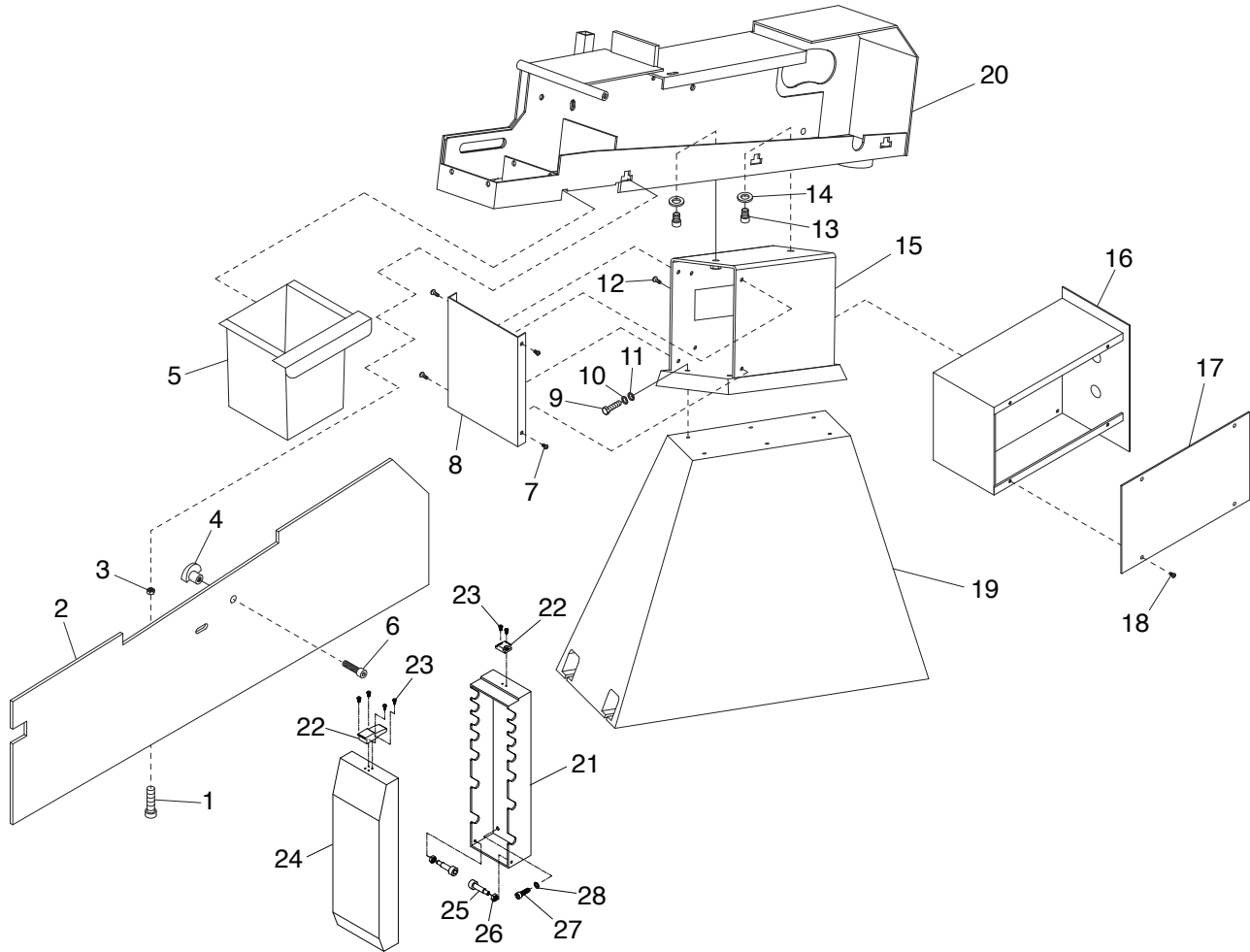
Figure 43. Motor junction box.

Wiring Diagram



SECTION 9: PARTS

Body



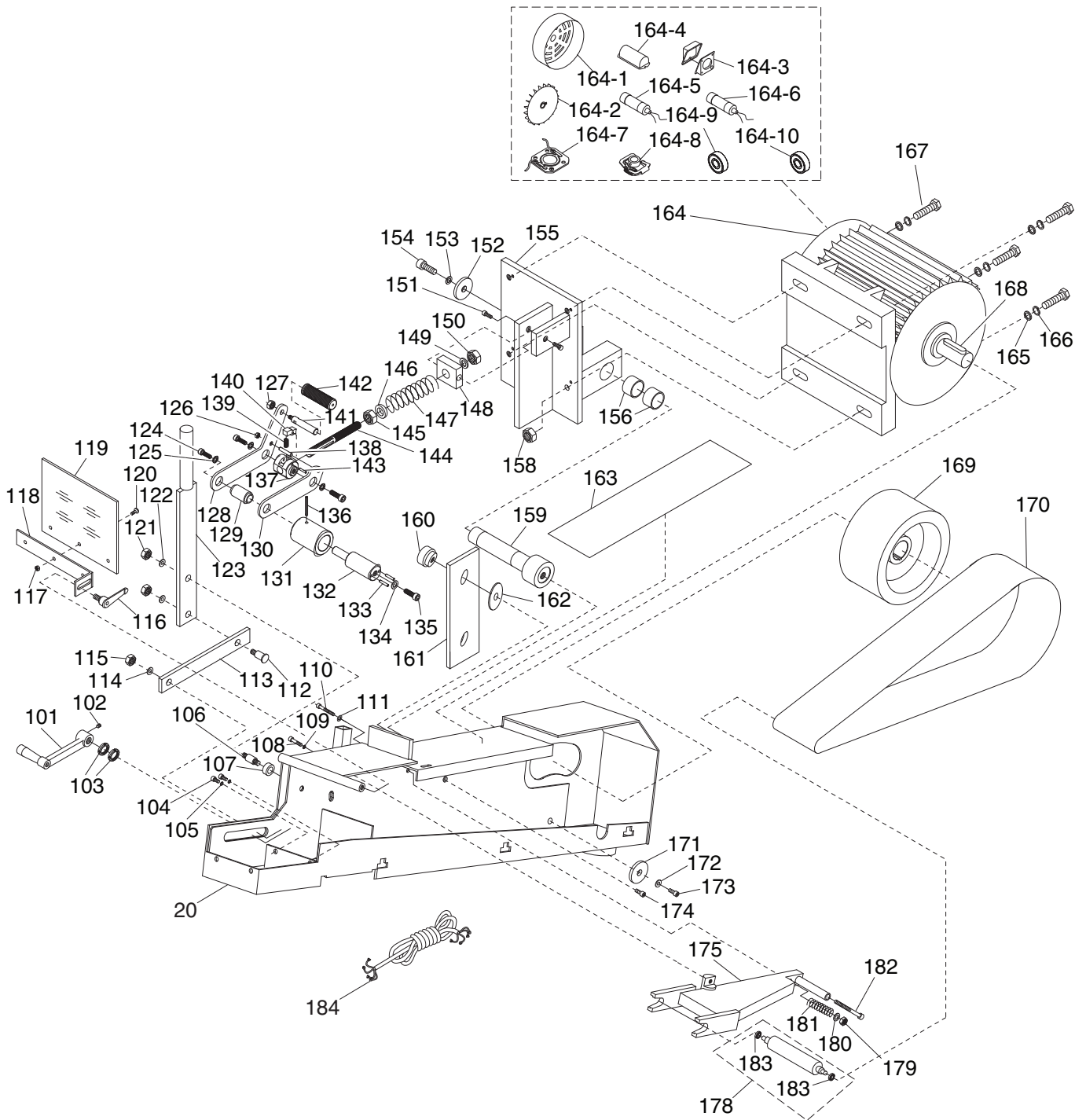
REF	PART #	DESCRIPTION
1	P0767001	CAP SCREW M5-.8 X 12
2	P0767002	BELT COVER, SIDE
3	P0767003	HEX NUT M5-.8
4	P0767004	BELT COVER LATCH
5	P0767005	SPARK TRAP
6	P0767006	CAP SCREW M8-1.25 X 12
7	P0767007	PHLP HD SCR M5-.8 X 8
8	P0767008	RISER FRONT PLATE
9	P0767009	HEX BOLT M8-1.25 X 20
10	P0767010	LOCK WASHER 8MM
11	P0767011	FLAT WASHER 8MM
12	P0767012	PHLP HD SCR M6-1 X 10
13	P0767013	CAP SCREW M12-1.75 X 35
14	P0767014	FLAT WASHER 12MM

REF	PART #	DESCRIPTION
15	P0767015	RISER
16	P0767016	ELECTRICAL CABINET
17	P0767017	ELECTRICAL MOUNTING BOARD
18	P0767018	PHLP HD SCR M4-.7 X 6
19	P0767019	BASE
20	P0767020	BODY
21	P0767021	PROFILE ROLLER STORAGE RACK
22	P0767022	COVER LATCH
23	P0767023	PHLP HD SCR M3-.5 X 5
24	P0767024	STORAGE RACK COVER
25	P0767025	SHOULDER M5-.8 X 8, 6 X 16MM
26	P0767026	HEX NUT M6-1
27	P0767027	CAP SCREW M8-1.25 X 20
28	P0767028	FLAT WASHER 8MM

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.



Main



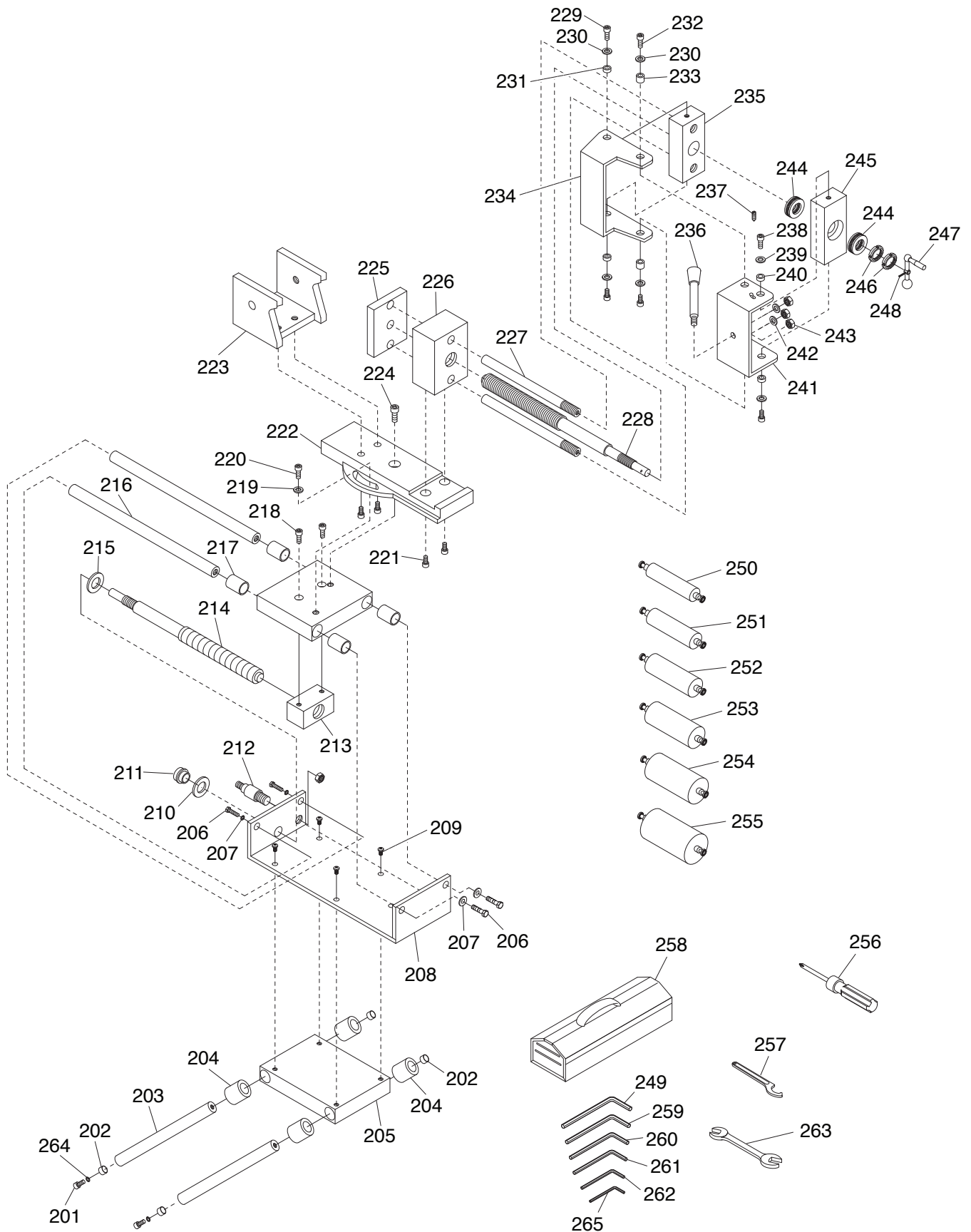
Main

REF	PART #	DESCRIPTION
20	P0767020	BODY
101	P0767101	CRANK 5"L W/HANDLE
102	P0767102	SET SCREW M6-1 X 8 CONE-PT
103	P0767103	SPANNER NUT M12-1.25
104	P0767104	CAP SCREW M8-1.25 X 25
105	P0767105	FLAT WASHER 8MM
106	P0767106	STUD-DE M8-1.25 X 37, 9
107	P0767107	SPACER
108	P0767108	CAP SCREW M12-1.75 X 35
109	P0767109	FLAT WASHER 12MM
110	P0767110	CAP SCREW M8-1.25 X 100
111	P0767111	FLAT WASHER 8MM
112	P0767112	STEP BOLT M8-1.25 X 12
113	P0767113	CONNECTING BAR
114	P0767114	FLAT WASHER 8MM
115	P0767115	HEX NUT M8-1.25
116	P0767116	ADJUSTABLE HANDLE M8-1.25 X 20
117	P0767117	HEX NUT M5-.8
118	P0767118	EYE SHIELD BRACKET
119	P0767119	EYE SHIELD PLASTIC
120	P0767120	PHLP HD SCR M5-.8 X 8
121	P0767121	HEX NUT M10-1.5
122	P0767122	FLAT WASHER 10MM
123	P0767123	LEVER W/GRIP
124	P0767124	CAP SCREW M8-1.25 X 14
125	P0767125	FENDER WASHER 8MM
126	P0767126	ACORN NUT M8-1.25
127	P0767127	ACORN NUT M10-1.5
128	P0767128	CONNECTING PLATE (LS)
129	P0767129	SUPPORT SLEEVE
130	P0767130	CONNECTING PLATE (RS)
131	P0767131	SPACER
132	P0767132	PIVOT SHAFT
133	P0767133	DOWEL PIN 6 X 16
134	P0767134	FENDER WASHER 12MM
135	P0767135	CAP SCREW M12-1.75 X 30
136	P0767136	ROLL PIN 6 X 50
137	P0767137	RATCHET SLEEVE
138	P0767138	BACKING PIN
139	P0767139	COMPRESSION SPRING 0.9 X 7 X 15
140	P0767140	PAWL
141	P0767141	HANDLE
142	P0767142	HANDLE GRIP
143	P0767143	DOWEL PIN 5 X 20
144	P0767144	RATCHET SHAFT
145	P0767145	HEX NUT M16-2

REF	PART #	DESCRIPTION
146	P0767146	SPRING RETAINER
147	P0767147	COMPRESSION SPRING 1.4 X 20 X 35
148	P0767148	SPRING BASE
149	P0767149	FLAT WASHER 16MM
150	P0767150	HEX NUT M16-2
151	P0767151	CAP SCREW M10-1.5 X 20
152	P0767152	FENDER WASHER 10MM
153	P0767153	FLAT WASHER 10MM
154	P0767154	CAP SCREW M10-1.5 X 20
155	P0767155	MOTOR MOUNT
156	P0767156	BUSHING, COPPER
158	P0767158	HEX NUT M10-1.5
159	P0767159	PIVOT SHAFT W/FLANGE
160	P0767160	LIFTING BAR RETAINER
161	P0767161	LIFTING BAR
162	P0767162	SPACER
163	P0767163	BELT COVER, TOP
164	P0767164	MOTOR 3HP 220V 1-PH
164-1	P0767164-1	MOTOR FAN COVER
164-2	P0767164-2	MOTOR FAN
164-3	P0767164-3	MOTOR JUNCTION BOX
164-4	P0767164-4	CAPACITOR COVER
164-5	P0767164-5	S CAPACITOR 250M 250V
164-6	P0767164-6	R CAPACITOR 30M 450V
164-7	P0767164-7	CONTACT PLATE
164-8	P0767164-8	CENTRIFUGAL SWITCH
164-9	P0767164-9	BALL BEARING 6205ZZ
164-10	P0767164-10	BALL BEARING 6205ZZ
165	P0767165	FLAT WASHER 10MM
166	P0767166	LOCK WASHER 10MM
167	P0767167	HEX BOLT M10-1.5 X 40
168	P0767168	KEY 8 X 8 X 40
169	P0767169	DRIVE PULLEY
170	P0767170	SANDING BELT 4" X 79" 80-GRIT
171	P0767171	FENDER WASHER 12MM
172	P0767172	LOCK WASHER 12MM
173	P0767173	CAP SCREW M12-1.75 X 50
174	P0767174	CAP SCREW M12-1.75 X 30
175	P0767175	CONTACT ROLLER BRACKET
178	P0767178	CONTACT ROLLER 1" DIA W/BEARINGS
179	P0767179	HEX NUT M8-1.25
180	P0767180	FLAT WASHER 8MM
181	P0767181	COMPRESSION SPRING 1 X 12 X 19
182	P0767182	CAP SCREW M8-1.25 X 100
183	P0767183	BALL BEARING 6002-RZ
184	P0767184	POWER CORD 12G 3W 72"



Pipe Vise Assembly & Accessories



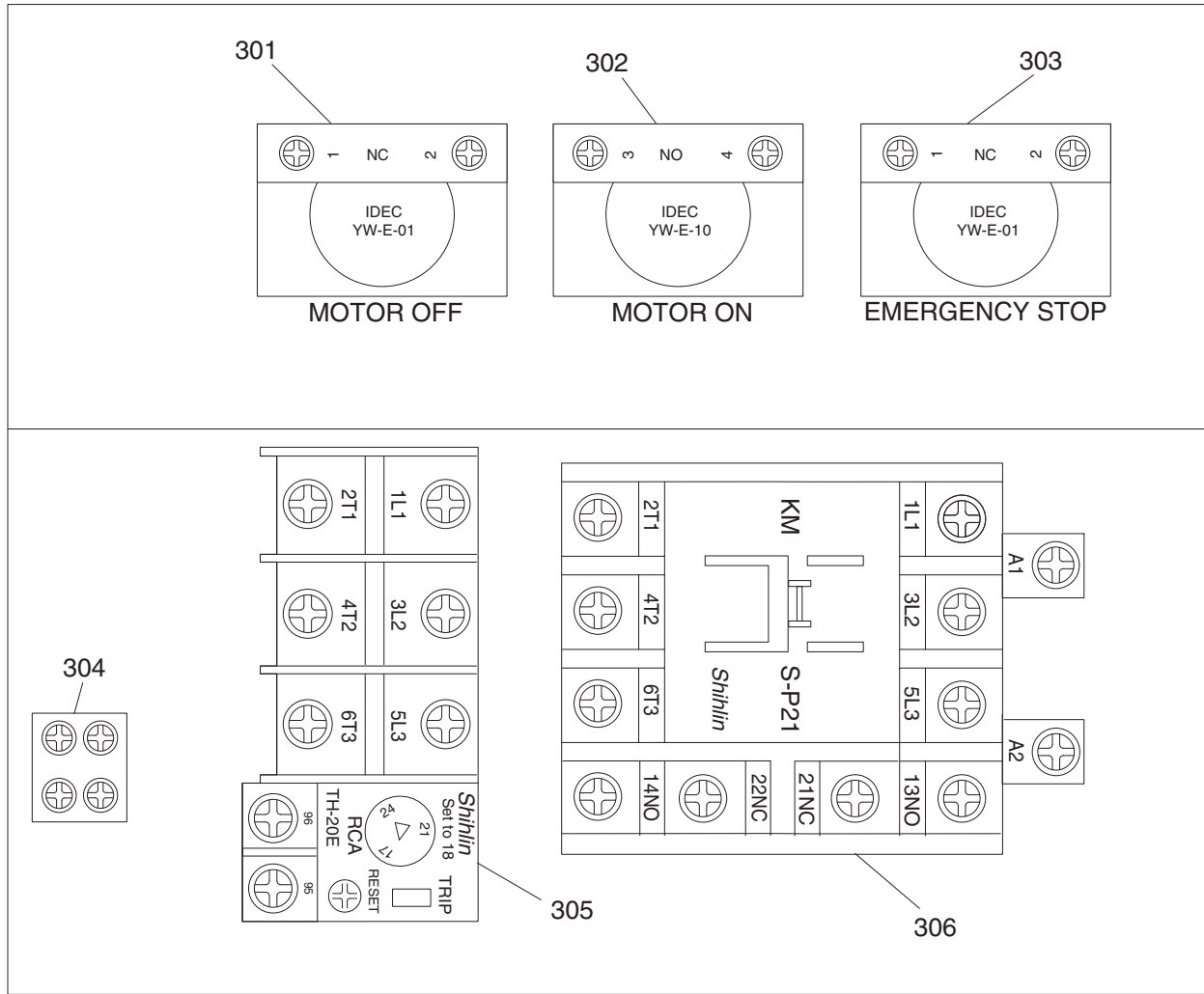
Pipe Vise Assembly & Accessories

REF PART #	DESCRIPTION
201	P0767201 CAP SCREW M8-1.25 X 20
202	P0767202 BUSHING
203	P0767203 Y-AXIS SLIDE ROD
204	P0767204 BUSHING, COPPER
205	P0767205 SLIDE BAR BRACKET
206	P0767206 HEX BOLT M8-1.25 X 20
207	P0767207 FLAT WASHER 8MM
208	P0767208 PIPE CLAMP BASE
209	P0767209 PHLP HD SCR M6-1 X 12
210	P0767210 FLAT WASHER 14MM
211	P0767211 LEADSCREW END CAP
212	P0767212 SLIDER SHAFT
213	P0767213 LONGITUDINAL LEADSCREW NUT
214	P0767214 LONGITUDINAL LEADSCREW
215	P0767215 FLAT WASHER 14MM
216	P0767216 X-AXIS SLIDE ROD
217	P0767217 GUIDE BAR BUSHING, COPPER
218	P0767218 CAP SCREW M8-1.25 X 40
219	P0767219 FLAT WASHER 8MM
220	P0767220 CAP SCREW M8-1.25 X 20
221	P0767221 CAP SCREW M8-1.25 X 30
222	P0767222 ROTARY TABLE
223	P0767223 PIPE JAW
224	P0767224 CAP SCREW M10-1.5 X 30
225	P0767225 PIPE CLAMP PLATE
226	P0767226 PIPE CLAMP LEADSCREW NUT
227	P0767227 INT/EXT THREADED ROD
228	P0767228 PIPE CLAMP LEADSCREW
229	P0767229 CAP SCREW M6-1 X 16
230	P0767230 FLAT WASHER 6MM
231	P0767231 BUSHING
232	P0767232 CAP SCREW M6-1 X 20
233	P0767233 BUSHING

REF PART #	DESCRIPTION
234	P0767234 PRESSURE BRACKET (LS)
235	P0767235 MOVABLE BLOCK
236	P0767236 LEVER M8-1.25 X 20 W/KNOB
237	P0767237 SET SCREW M3-.5 X 10 CONE-PT
238	P0767238 CAP SCREW M6-1 X 16
239	P0767239 FLAT WASHER 6MM
240	P0767240 BUSHING
241	P0767241 PRESSURE BRACKET (RS)
242	P0767242 FLAT WASHER 6MM
243	P0767243 HEX NUT M8-1.25
244	P0767244 THRUST BEARING 51101
245	P0767245 STATIONARY BLOCK
246	P0767246 SPANNER NUT M12-1.25
247	P0767247 CRANK 4"L W/HANDLE
248	P0767248 ROLL PIN 3 X 22
249	P0767249 HEX WRENCH 8MM
250	P0767250 CONTACT ROLLER 3/4" DIA W/BEARINGS
251	P0767251 CONTACT ROLLER 1-1/4" DIA W/BEARINGS
252	P0767252 CONTACT ROLLER 1-1/2" DIA W/BEARINGS
253	P0767253 CONTACT ROLLER 2" DIA W/BEARINGS
254	P0767254 CONTACT ROLLER 2-1/5" DIA W/BEARINGS
255	P0767255 CONTACT ROLLER 3" DIA W/BEARINGS
256	P0767256 SCREWDRIVER PHILLIPS #2
257	P0767257 SPANNER WRENCH 22-26MM
258	P0767258 TOOLBOX
259	P0767259 HEX WRENCH 6MM
260	P0767260 HEX WRENCH 5MM
261	P0767261 HEX WRENCH 4MM
262	P0767262 HEX WRENCH 3MM
263	P0767263 WRENCH 13 X 16MM OPEN-ENDS
264	P0767264 FLAT WASHER 8MM
265	P0767265 HEX WRENCH 2.5MM



Electrical Box

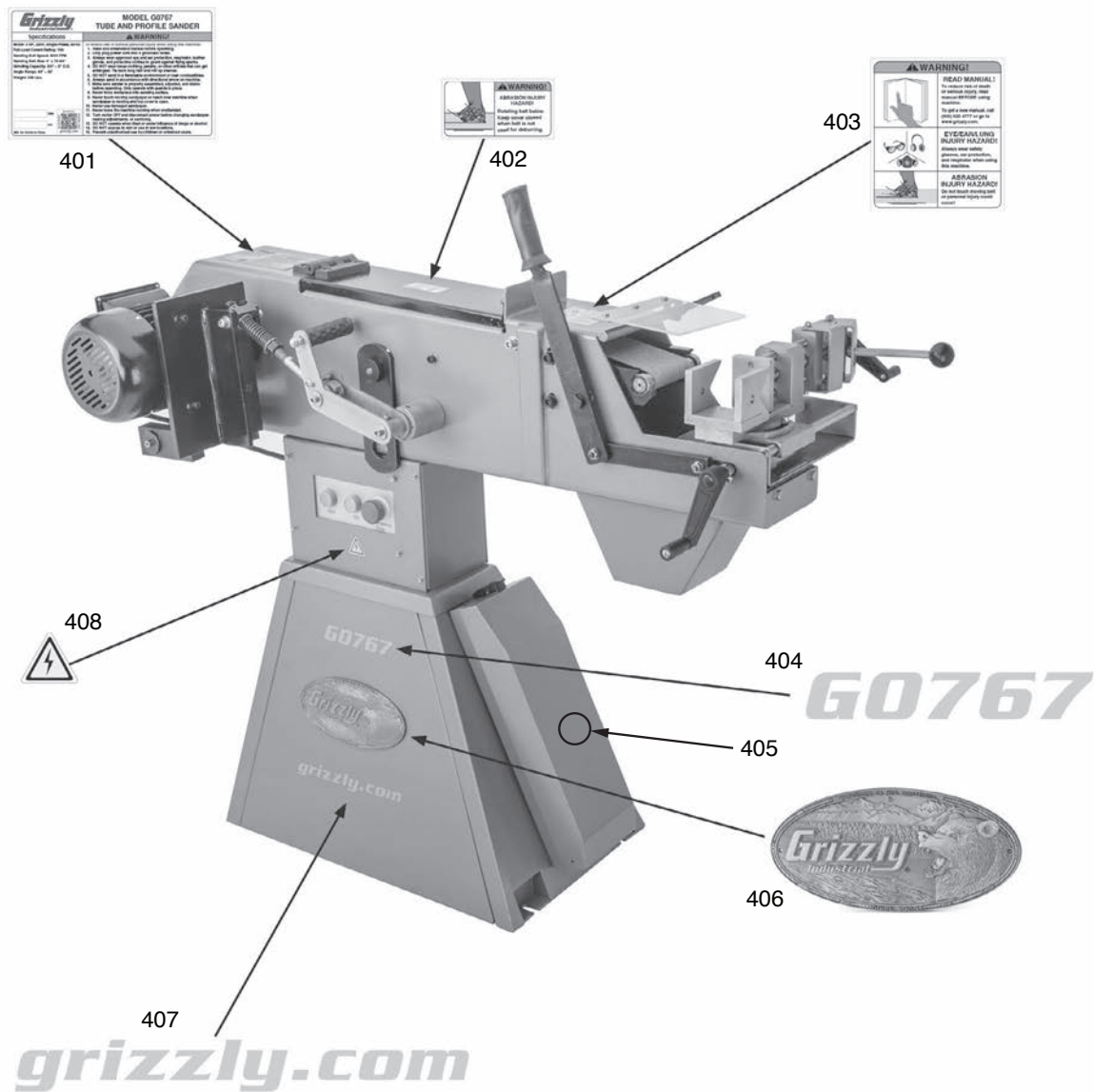


REF	PART #	DESCRIPTION
301	P0767301	OFF BUTTON IDEC YW-E-01 22MM RED
302	P0767302	ON BUTTON IDEC YW-E-10 22MM GRN
303	P0767303	E-STOP BUTTON IDEC YW-E-01 22MM

REF	PART #	DESCRIPTION
304	P0767304	TERMINAL BAR 2P
305	P0767305	OL RELAY SHIHLIN TH-20E 17-21A
306	P0767306	CONTACTOR SHIHLIN S-P21 220V



Labels (Front)



REF	PART #	DESCRIPTION
401	P0767401	MACHINE ID LABEL
402	P0767402	ABRASION HAZARD LABEL
403	P0767403	COMBO WARNING LABEL
404	P0767404	MODEL NUMBER LABEL P-7527C

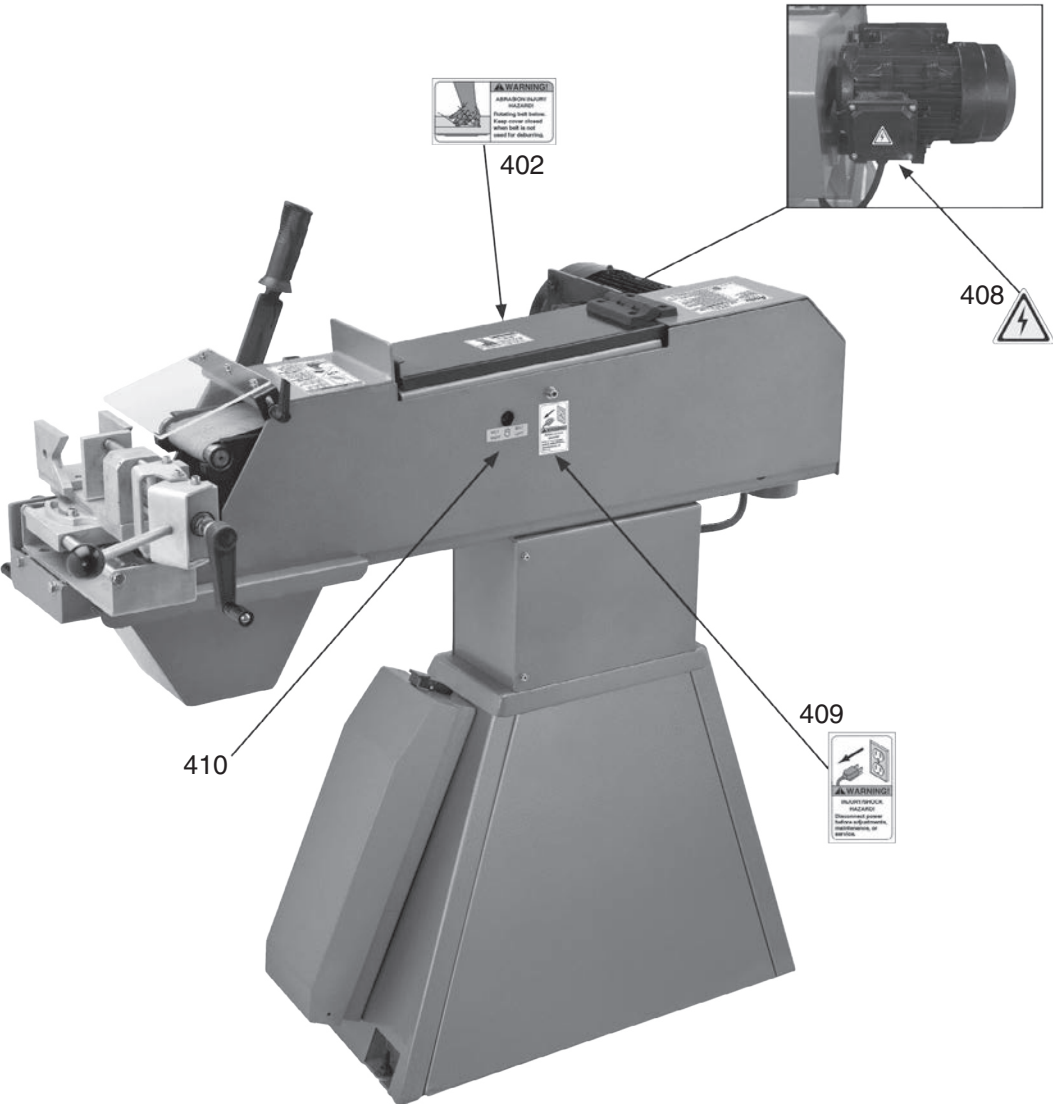
REF	PART #	DESCRIPTION
405	P0767405	GRIZZLY GREEN TOUCH-UP PAINT
406	P0767406	GRIZZLY NAMEPLATE-SMALL
407	P0767407	GRIZZLY.COM LABEL P-7527C
408	P0767408	ELECTRICITY LABEL

⚠️ 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.



Labels (Rear)



REF	PART #	DESCRIPTION
402	P0767402	ABRASION HAZARD LABEL
408	P0767408	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
409	P0767409	DISCONNECT POWER WARNING LABEL
410	P0767410	BELT TENSION DIRECTION LABEL





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.**

- How did you learn about us?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
- Which of the following magazines do you subscribe to?

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

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
- What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- How long have you been a woodworker/metalworker?

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------
- How many of your machines or tools are Grizzly?

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
------------------------------	------------------------------	------------------------------	------------------------------
- Do you think your machine represents a good value? Yes No
- Would you recommend Grizzly Industrial to a friend? Yes No
- 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 & 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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