

READ THIS FIRST



Model G0925

*****IMPORTANT UPDATE*****

**For Machines Mfd. Since 02/20
and Owner's Manual Printed 02/20**

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

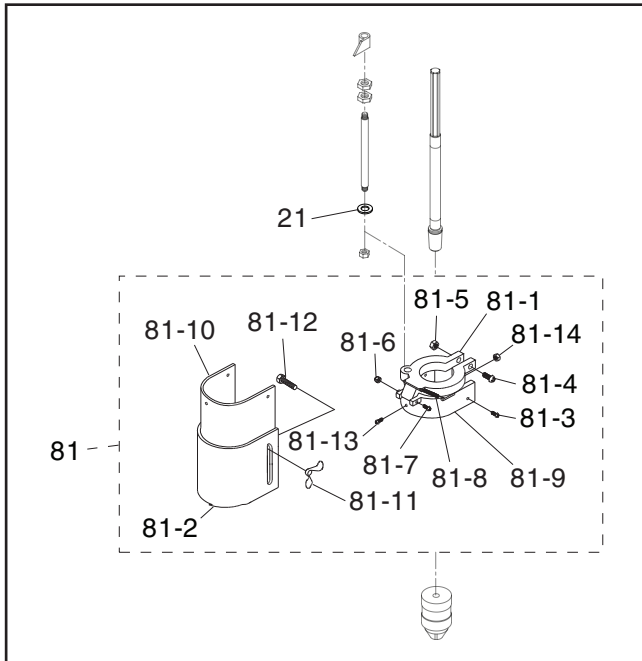
The following changes were recently made since the owner's manual was printed:

- Factory replaced depth stop bracket with a chuck guard.
- Inventory list has been revised.
- Assembly section has been revised.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Revised Parts Breakdown & List



REF	PART #	DESCRIPTION
21	P0925021	FLAT WASHER 6MM
81	P0925081	CHUCK GUARD ASSEMBLY
81-1	P0925081-1	CHUCK GUARD SEAT
81-2	P0925081-2	LOWER GUARD
81-3	P0925081-3	TAP SCREW M3.5 X 5
81-4	P0925081-4	PHLP HD SCR M4-.7 X 30
81-5	P0925081-5	HEX NUT M4-.7
81-6	P0925081-6	LOCK NUT M4-.7
81-7	P0925081-7	PHLP HD SCR M4-.7 X 20
81-8	P0925081-8	EXTENSION SPRING 1 X 6 X 20
81-9	P0925081-9	HINGE BRACKET
81-10	P0925081-10	UPPER GUARD
81-11	P0925081-11	WING NUT M5-.8
81-12	P0925081-12	HEX BOLT M5-.8 X 10
81-13	P0925081-13	PHLP HD SCR M3-.5 X 10
81-14	P0925081-14	HEX NUT M3-.5

Revised Needed for Setup

Description	Qty
Phillips Head Screwdriver #1	1
Wrench or Sockets 4, 5.5, 10mm.....	1 Ea.

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#CS21123 PRINTED IN CHINA

Revised Inventory List

Box 1 (Figure 1)	Qty
K. Pointer	1
L. Threaded Depth Rod Assembly	1
M. Chuck Guard Assembly	1
N. Chuck Guard Seat Assembly	1

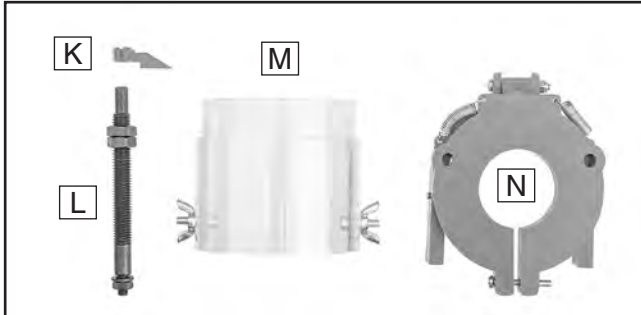


Figure 1. Box 1 additions.

Revised Assembly Steps

Perform **Steps 1–4** of **Assembly** on **Page 15** of owner's manual. Then follow the steps below to complete the assembly process.

5. Remove (2) pre-installed tap screws, Phillips head screw, and hex nut (see **Figure 2**) from chuck guard seat.

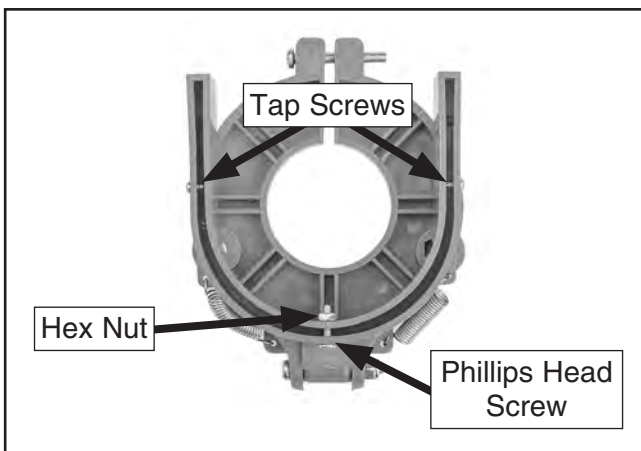


Figure 2. Location of chuck guard seat screws.

6. Attach chuck guard to chuck guard seat using fasteners removed in **Step 5** (see **Figure 4**).



Figure 3. Aligning chuck seat guard to chuck guard seat.



Figure 4. Attaching chuck guard to chuck guard seat.



7. Remove (2) M10-1.5 hex nuts, (1) M6-1 hex nut and (1) 6mm flat washer from depth rod.
8. Pull bottom of chuck guard forward to open and attach depth rod to guard with M6-1 hex nut and 6mm flat washer (see **Figure 5**).

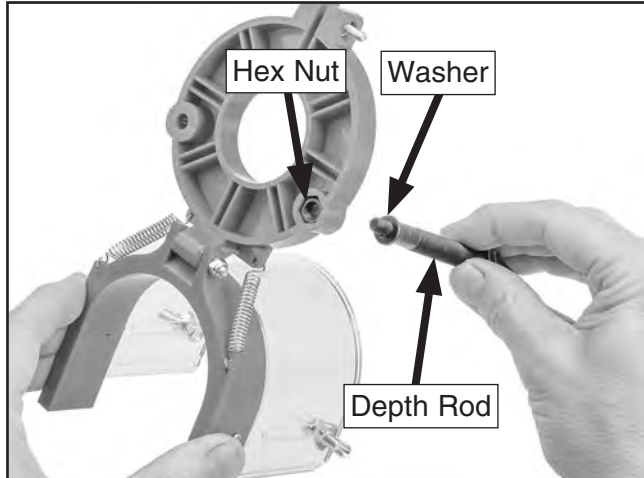


Figure 5. Attaching depth rod to chuck guard.

9. Close guard and insert depth rod through mounting hole until guard fits around drill press quill (see **Figure 6**).

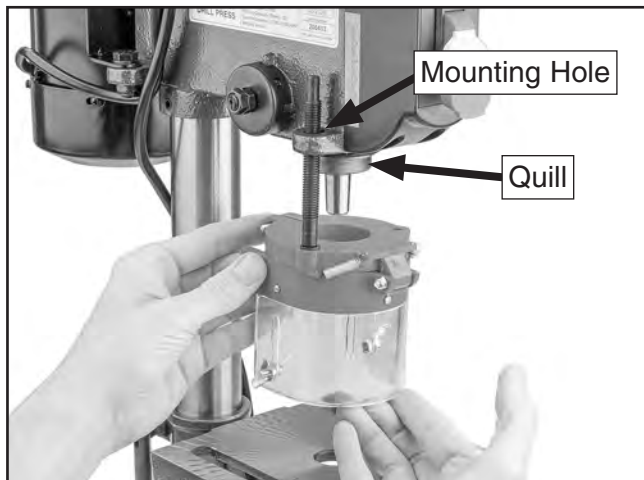


Figure 6. Inserting depth rod through mounting hole.

10. With chuck guard around quill, tighten Phillips head screw and hex nut until guard is snug (see **Figure 7**).



Figure 7. Attaching chuck guard to quill.

11. Thread (2) M10-1.5 hex nuts from **Step 7** onto depth rod, and snap on pointer so it points at zero (see **Figure 8**).

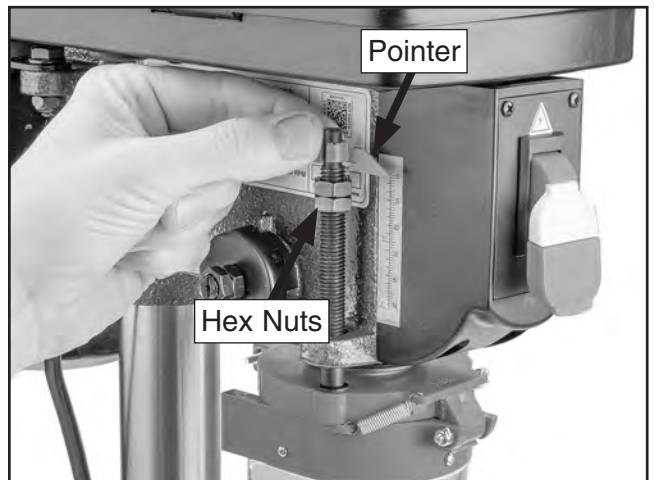


Figure 8. Attaching pointer to depth rod.

12. Open chuck guard.
13. Use acetone or lacquer thinner to clean spindle and chuck mating surfaces.
14. Retract chuck jaws completely.



15. Push chuck onto spindle taper, then use a wood block and hammer or mallet to hit chuck once with moderate force as shown in **Figure 9**.

Note: *Hitting chuck directly with a steel hammer may damage chuck, making it unsafe to use.*



Figure 9. Using block of wood and hammer to tap chuck onto spindle taper.

16. Attempt to separate spindle and chuck by hand—if they separate, repeat **Steps 13–15**.
17. Thread (3) downfeed handles into downfeed hub, as shown in **Figure 10**.

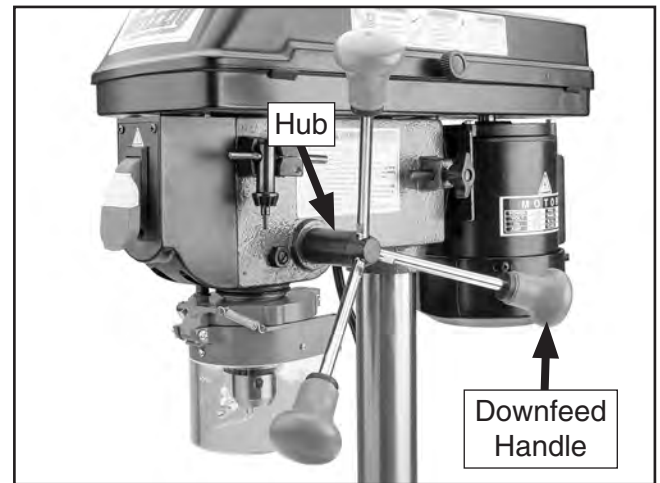


Figure 10. Downfeed handles installed in hub.



Grizzly *Industrial, Inc.*®

MODEL G0925 8" BENCHTOP DRILL PRESS OWNER'S MANUAL *(For models manufactured since 02/20)*



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V1.02.20



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

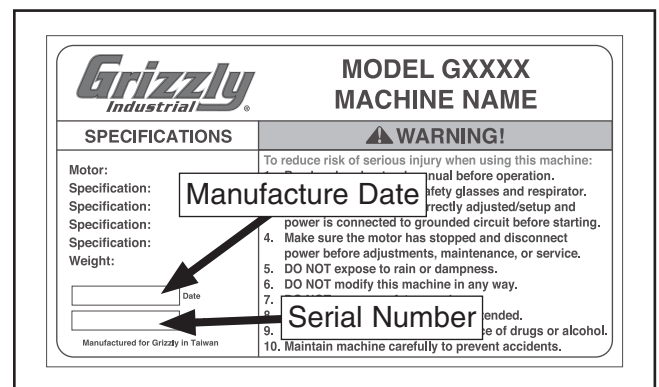
Manual Accuracy

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.**

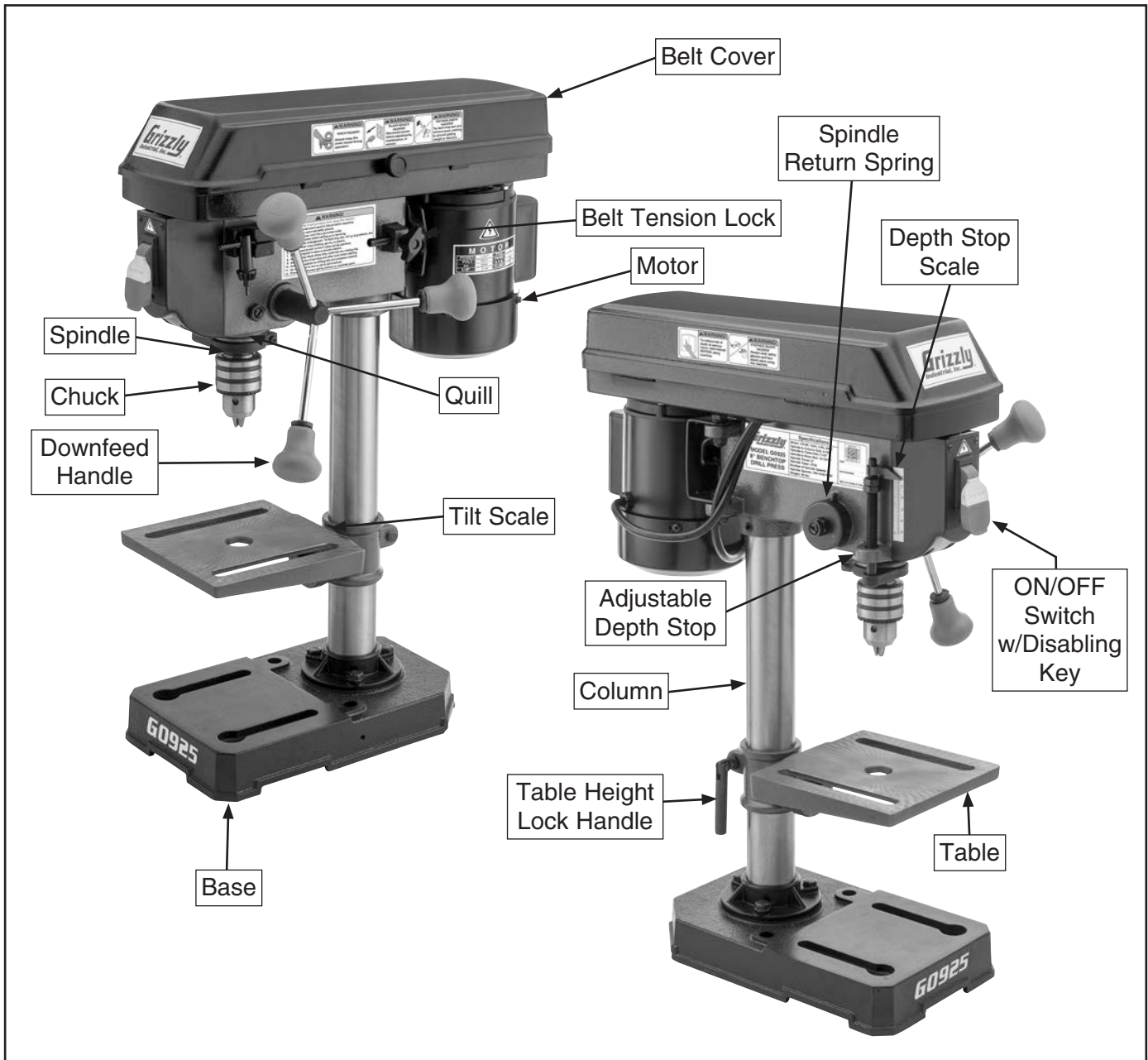
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at www.grizzly.com.

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.



Identification

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



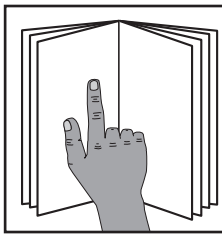
!WARNING

For Your Own Safety Read Instruction Manual Before Operating Drill Press

- a) Wear eye protection.
- b) Do not wear gloves, necktie, or loose clothing.
- c) Clamp workpiece or brace against column to prevent rotation.
- d) Use recommended speed for drill accessory and workpiece material.



Controls & Components



!WARNING

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

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.

Headstock

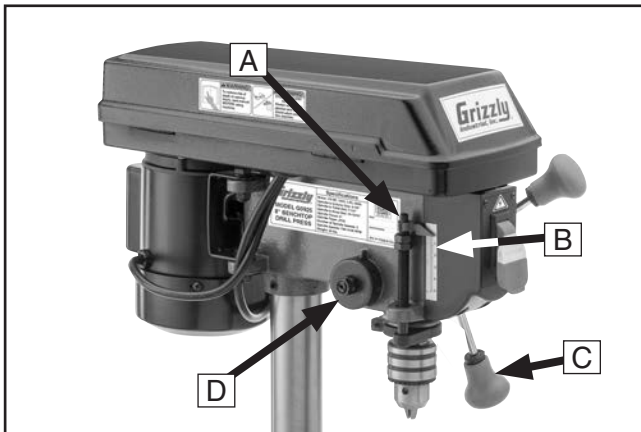


Figure 1. Headstock controls.

A. Adjustable Depth Stop: Stops spindle travel at predetermined depth.

B. Depth Scale: Indicates drilling depth and position of depth stop.

C. Downfeed Handles: Move spindle down when pulled down. Spindle automatically returns to top position when released.

D. Spindle Return Spring: Automatically returns quill into headstock.

Table

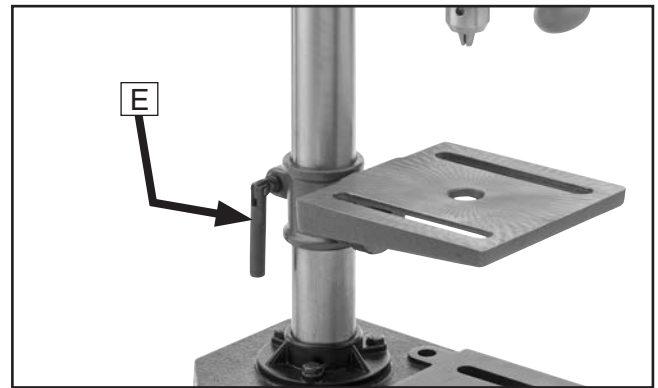


Figure 2. Table controls.

E. Table Lock Handle: Locks table height and rotation in position in relation to column.

Power and Speed Components

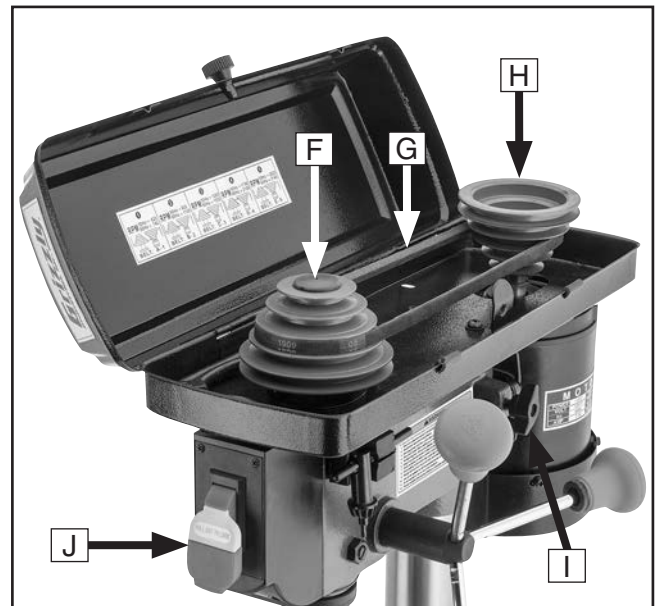


Figure 3. Control panel.

F. Spindle Pulley: Holds drive belt and transfers motor power to spindle.

G. Drive Belt: Controls spindle speed.

H. Motor Pulley: Transfers motor power to drive belt at different speeds.

I. Belt Tension Lock: Secures motor in position to set belt tension.

J. ON/OFF Switch w/Disabling Key: Turns motor **ON** when flipped up; turns motor **OFF** when pressed down. Removal of yellow key disables switch so motor cannot start.





MACHINE DATA SHEET

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

MODEL G0925 8" BENCHTOP DRILL PRESS

Product Dimensions:

Weight..... 34 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 9 x 17-1/2 x 23-1/2 in.
Footprint (Length x Width)..... 11-1/2 x 7-1/2 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 36 lbs.
Length x Width x Height..... 20 x 14 x 11 in.

Electrical:

Power Requirement..... 120V, 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..... 6 ft.
Power Cord Gauge..... 18 AWG
Plug Included..... Yes
Included Plug Type..... 5-15
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 1/3 HP
Phase..... Single-Phase
Amps..... 2.3A
Speed..... 1700 RPM
Type..... TEFC Induction
Power Transfer..... Belt
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Information

Type..... Bench
Swing..... 8 in.
Spindle Taper..... JT#33
Spindle Travel..... 2 in.
Max. Distance From Spindle to Column..... 4-1/8 in.
Max. Distance From Spindle to Table..... 7-1/2 in.
Number of Spindle Speeds..... 5
Range of Spindle Speeds..... 740 - 3140 RPM
Drilling Capacity (Mild Steel)..... 1/2 in.
Drilling Capacity (Cast Iron)..... 1/2 in.
Drill Chuck Type..... JT33 Key Chuck
Drill Chuck Size..... 1/16 - 1/2 in.



Spindle Information

Distance From Spindle to Base..... 10-13/16 in.
Quill Diameter..... 1.575 in.

Table Information

Max. Table Tilt (Left/Right)..... 45 deg.
Table Swivel Around Column..... 360 deg.
Max. Movement of Work Table..... 7-1/2 in.
Table Length..... 6-1/2 in.
Table Width..... 6-1/2 in.
Table Thickness..... 1/4 in.
Number of T-Slots..... 2
T-Slot Size..... 5/8 in.
T-Slot Centers..... 4-3/8 in.
Floor-To-Table Height..... 5 in.

Construction

Table..... Cast Iron
Column..... Steel
Spindle Housing..... Cast Iron
Head..... Cast Iron
Base..... Cast Iron
Paint Type/Finish..... Epoxy

Other Related Information

Base Length..... 11-3/8 in.
Base Width..... 7-1/8 in.
Column Diameter..... 1.81 in.
Depth Stop Type..... Threaded Rod w/Positive Stop

Other Specifications:

Country of Origin China
Warranty 1 Year
Serial Number Location ID Label
ISO 9001 Factory Yes

Features:

5 Speed Ranges: 740 - 3140 RPM
1/16" - 1/2" Drill Chuck
8" Swing
Threaded Depth Stop 0" - 2"

Accessories Included:

Hex Wrench 4mm



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.

⚠ DANGER Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

⚠ WARNING Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

⚠ CAUTION 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 Drill Presses

WARNING

Serious injury or death can occur from getting clothing, jewelry, or long hair entangled in rotating spindle or bit/cutting tool. Contact with rotating bit/cutting tool can result in severe cuts or amputation of fingers. Flying metal chips can cause blindness or eye injuries. Broken bits/cutting tools, unsecured workpieces, chuck keys, or other adjustment tools thrown from rotating spindle can strike nearby operator or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders **MUST** completely heed hazards and warnings below.

EYE/FACE/HAND PROTECTION. Flying chips created by drilling can cause eye injuries or blindness. Always wear a face shield in addition to safety glasses. Always keep hands and fingers away from drill bit/cutting tool. Avoid awkward hand positions, where a sudden slip could cause hand to move into bit/cutting tool.

AVOIDING ENTANGLEMENT. DO NOT wear loose clothing, gloves, or jewelry. Tie back long hair. Keep all guards in place and secure. Always allow spindle to stop on its own. DO NOT stop spindle using your hand or any other object.

REMOVING ADJUSTMENT TOOLS. Chuck key, wrenches, and other tools left on machine can become deadly projectiles when spindle is started. Remove all loose items or tools used on spindle immediately after use.

CORRECT SPINDLE SPEED. Using wrong spindle speed can cause bits/cutting tools to break and strike operator or bystanders. Follow recommended speeds and feeds for each size/type of bit/cutting tool and workpiece material.

SECURING BIT/CUTTING TOOL. Firmly secure bit/cutting tool in chuck so it cannot fly out of spindle during operation or startup.

DRILLING PREPARATION. To avoid loss of drilling control or bit breakage, only drill into a flat surface that is approximately perpendicular to bit. Clear table of all objects before starting spindle. Never start spindle with bit pressed against workpiece.

SECURING TABLE AND HEADSTOCK. To avoid loss of control leading to bit breakage or accidental contact with tool/bit, tighten all table and headstock locks before operating drill press.

WORKPIECE CONTROL. An unsecured workpiece may unexpectedly shift, spin out of control, or be thrown if bit/cutting tool “grabs” during operation. Clamp workpiece to table or in table-mounted vise, or brace against column to prevent rotation. NEVER hold workpiece by hand during operation. NEVER start machine with bit/cutting tool touching workpiece; allow spindle to gain full speed before drilling into workpiece.

INSPECTING BIT/CUTTING TOOL. Damaged bits/cutting tools may break apart during operation and hit operator or bystanders. Dull bits/cutting tools increase cutting resistance and are more likely to grab and spin/throw workpiece. Always inspect bits/cutting tools for sharpness, chips, or cracks before each use. Replace dull, chipped, or cracked bits/cutting tools immediately.

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

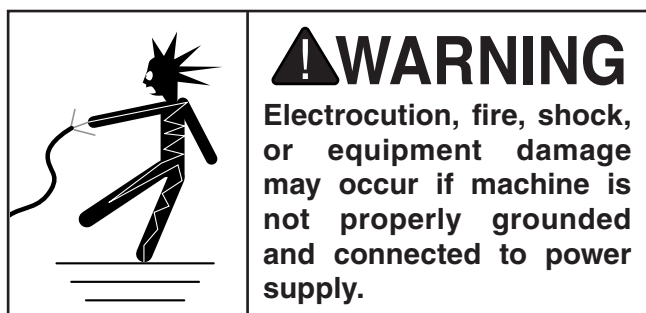
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or 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 120V ... 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.

! 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.

120V 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 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps

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.*



Grounding & Plug 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!

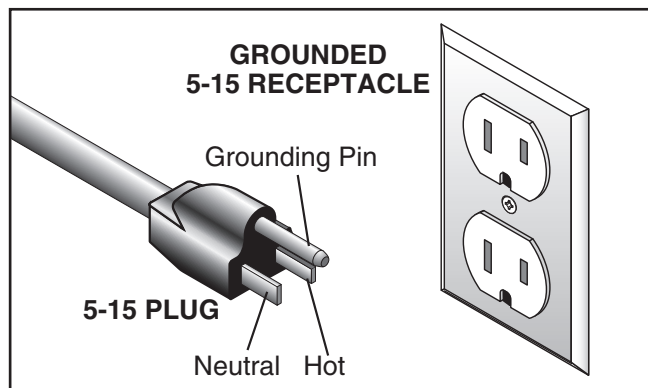


Figure 4. Typical 5-15 plug and receptacle.

⚠ CAUTION

SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

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.

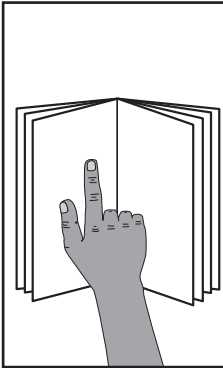
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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.

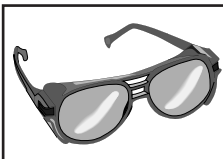


SECTION 3: SETUP



!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!

Needed for Setup

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

Description	Qty
• Safety Glasses (for each person).....	1
• Open-End Wrench 14mm.....	1
• Solvent/Cleaner.....	1
• Shop Rags.....	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.*



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. Headstock	1
B. Column Assembly	1
C. Table Assembly	1
D. Table Lock Handle.....	1
E. Downfeed Handles	3
F. Hex Bolts M8-1.25 x 20 (Column)	3
G. Chuck 1/16" -1/2"	1
H. Chuck Key	1
I. Hex Wrench 4mm.....	1
J. Base	1

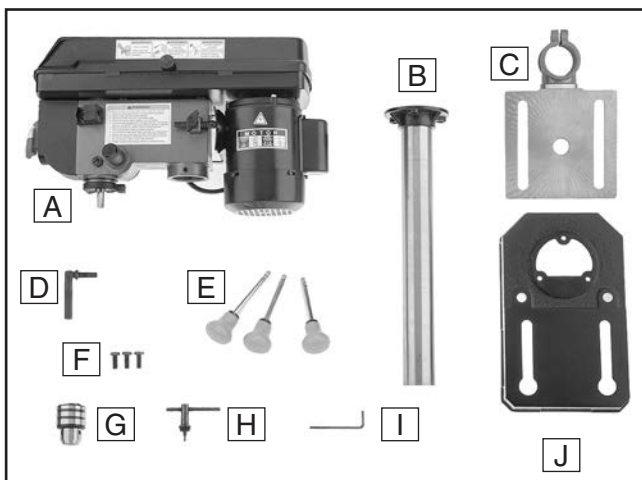


Figure 5. G0925 loose parts inventory.

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.

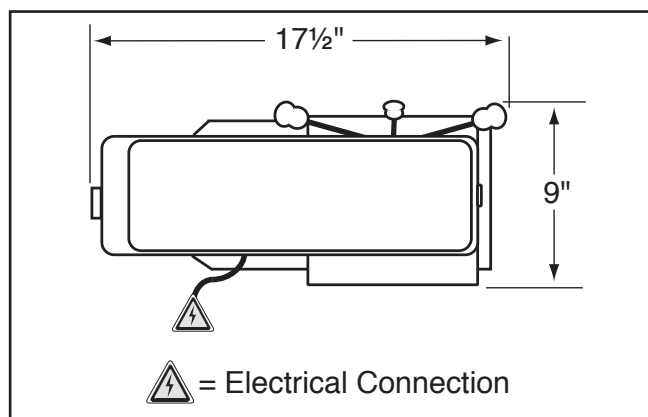
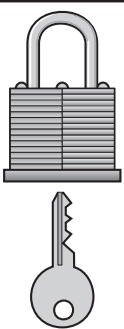


Figure 6. Minimum working clearances.

	<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>
---	--

Bench Mounting

Number of Mounting Holes 2
Diameter of Mounting Hardware Needed .. 1/2"

The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.

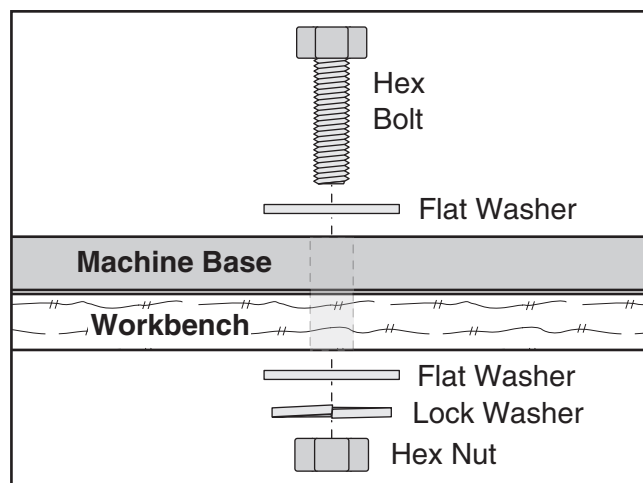


Figure 7. "Through Mount" setup.

Another option is a "direct mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.

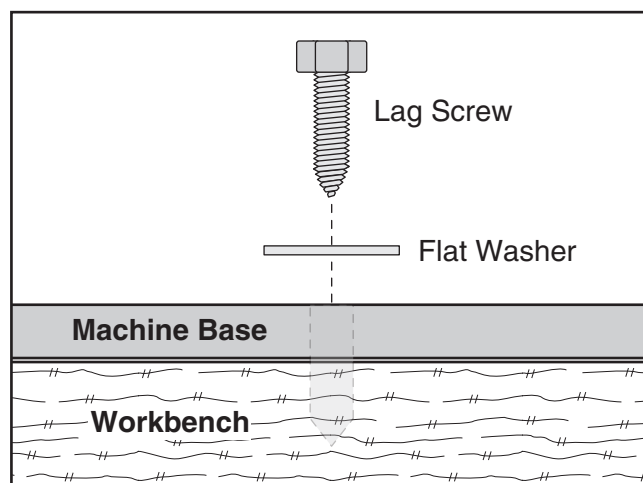


Figure 8. "Direct Mount" setup.



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).

To assemble machine:

1. Attach column to base using (3) M8-1.25 x 20 hex bolts (see **Figure 9**).

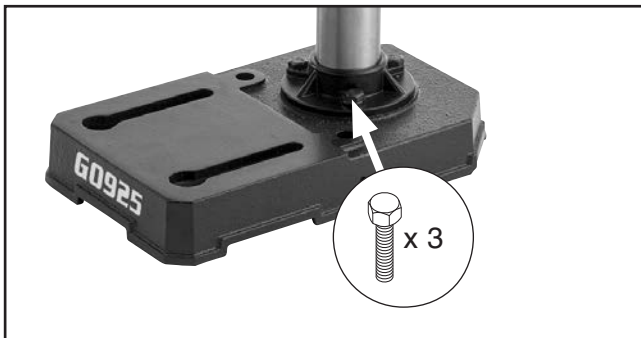


Figure 9. Column attached to base.

2. Slide table assembly onto column, centering table over base (see **Figure 10**), and secure with table lock handle.

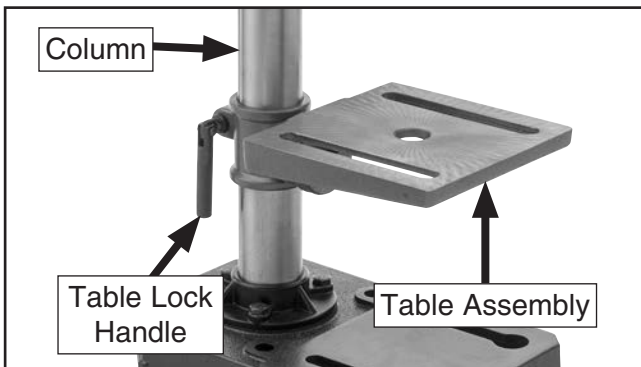


Figure 10. Table secured on column.

3. Lift headstock and fit it onto top of column (see **Figure 11**). Rotate headstock so spindle is over table.



Figure 11. Headstock placed on column.

4. Tighten (2) pre-installed set screws to secure headstock to column (see **Figure 12**).



Figure 12. Location of set screws that secure headstock to column.



5. Thread (3) downfeed handles into downfeed hub, as shown in **Figure 13**.

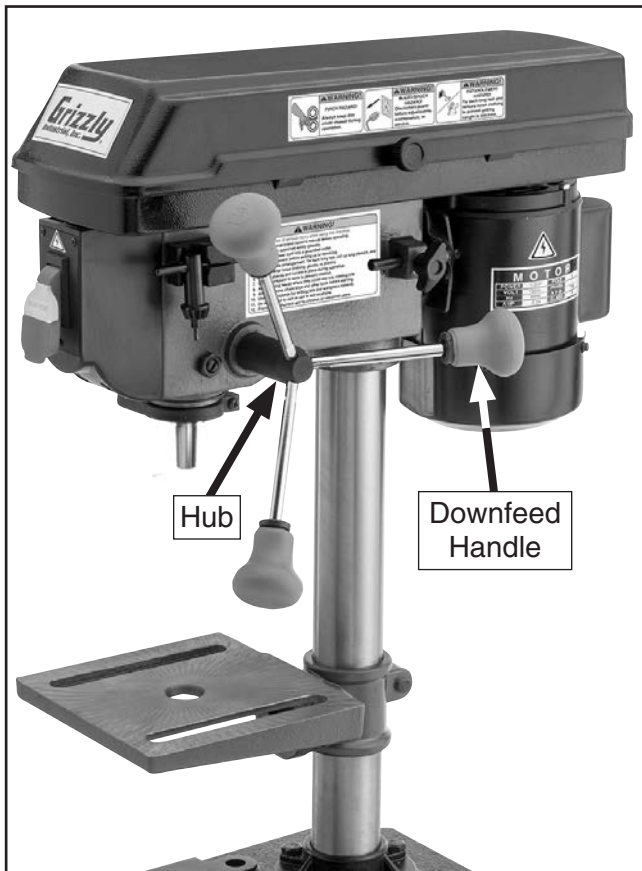


Figure 13. Downfeed handles installed in hub.

6. Use acetone or lacquer thinner to clean spindle and chuck mating surfaces.
7. Retract chuck jaws completely into chuck.

8. Push chuck onto spindle taper, then use a wood block and hammer or mallet to hit chuck once with moderate force as shown in **Figure 14**.

Note: *Hitting chuck directly with a steel hammer may damage chuck, making it unsafe to use.*



Figure 14. Example of using block of wood and hammer to tap chuck onto spindle taper.

9. Attempt to separate spindle and chuck by hand—if they separate, repeat **Steps 6–8**.



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 switch disabling key disables the switch properly.

!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 the machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine **ON**, verify motor operation, and then turn machine **OFF**.

The motor should run smoothly and without unusual problems or noises.

4. Remove switch disabling key, as shown in **Figure 15**.

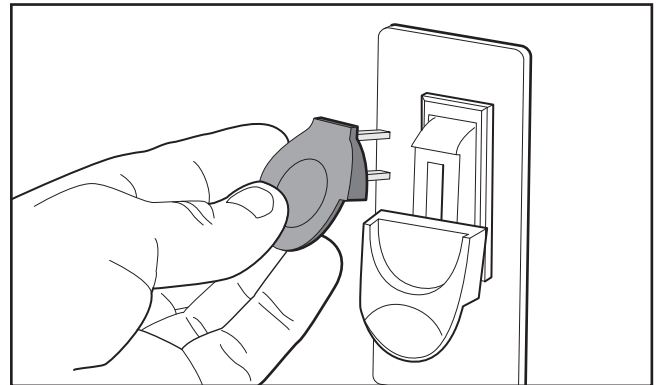


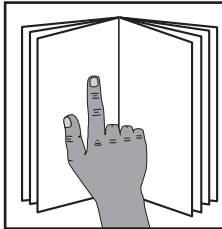
Figure 15. Removing switch key from paddle switch.

5. Try to start machine with paddle switch. The machine should not start.
 - If the machine *does not* start, the switch disabling feature is working correctly.
 - If the machine *does start*, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Congratulations! Test Run is complete.



SECTION 4: OPERATIONS

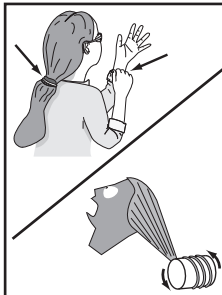
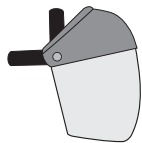


!WARNING

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

!WARNING

To reduce risk of eye or face injury from flying chips, always wear approved safety glasses and a face shield when operating this machine.



!WARNING

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

NOTICE

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

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.

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

1. Examines workpiece to make sure it is suitable for drilling.
2. Puts on required safety glasses and face shield.
3. Firmly secures workpiece to table using a vise or T-slot clamps.
4. Installs correct drill bit for operation.
5. Adjusts table to correct height, then locks it in place.
6. Selects appropriate spindle speed according to drill bit speed chart located on **Page 19** and adjusts drive belt to required pulley sheaves.
7. Connects machine to power, and turns machine **ON**.
8. Performs drilling operation.
9. When finished, turns machine **OFF** and disconnects it from power.



Choosing Spindle Speeds

Using Drill Bit Speed Chart

The chart shown in **Figure 16** is intended as a generic guide only. Always follow the manufacturer's speed recommendations if provided with your drill bits, cutters, or hole saws. Exceeding the recommended speeds may be dangerous to the operator.

The speeds shown here are intended to get you started. The optimum speed will always depend on various factors, including tool diameter, drilling pressure, material hardness, material quality, and desired finish.

Often, when drilling materials other than wood, some type of lubrication is necessary.

Lubrication Suggestions

WoodNone
 PlasticsSoapy Water
 BrassWater-Based Lubricant
 Aluminum..... Paraffin-Based Lubricant
 Mild Steel..... Oil-Based Lubricant

⚠ CAUTION

Larger bits turning at slower speeds tend to grab workpiece aggressively. This can result in operator's hand being pulled into bit or workpiece being thrown with great force. Always clamp workpiece to table to prevent reduce risk of injury.

Twist/Brad Point Drill Bits	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/16" – 3/16"	3000	2500	2500	2500	3000	2500
13/64" – 3/8"	2000	1500	2000	1250	2500	1250
25/64" – 5/8"	1500	750	1500	750	1500	600
11/16" – 1"	750	500	1000	400	1000	350

Spade/Forstner Bits	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/4" – 1/2"	2000	1500	/	/	/	/
9/16" – 1"	1500	1250	/	/	/	/
1-1/8" – 1-7/8"	1000	750	/	/	/	/
2–3"	500	350	/	/	/	/

Hole Saws	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
1/2" – 7/8"	500	500	600	600	600	500
1" – 1-7/8"	400	400	500	500	500	400
2" – 2-7/8"	300	300	400	400	400	300
3" – 3-7/8"	200	200	300	300	300	200
4" – 5"	100	100	200	200	200	100

Rosette Cutters	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
Carbide Insert Type	350	250	/	/	/	/
One-Piece Type	1800	500	/	/	/	/

Tenon/Plug Cutters	Soft Wood	Hard Wood	Plastic	Brass	Aluminum	Mild Steel
3/8" – 1/2"	1200	1000	/	/	/	/
5/8" – 1"	800	600	/	/	/	/

Figure 16. Drill bit speed chart (RPMs).



Changing Spindle Speed

The Model G0925 has five spindle speeds that operate between 740-3140 RPM. Refer to the speed chart located under the belt cover.

The highest speed is obtained when the belt is positioned on the smallest spindle pulley sheave (E) and the largest motor pulley sheave (5), as shown in **Figure 17**.

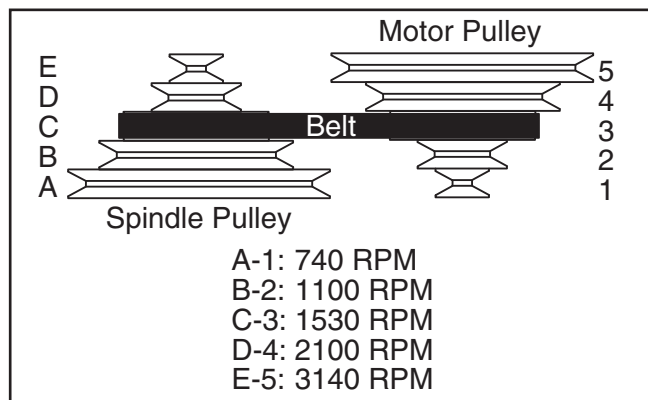


Figure 17. Spindle speed chart.

To change spindle speed:

1. DISCONNECT MACHINE FROM POWER!
2. Open belt cover.
3. Determine correct spindle speed for operation (see **Choosing Spindle Speeds** on **Page 19**).
4. Turn belt tension knob counterclockwise to loosen motor tension spring (see **Figure 18**).

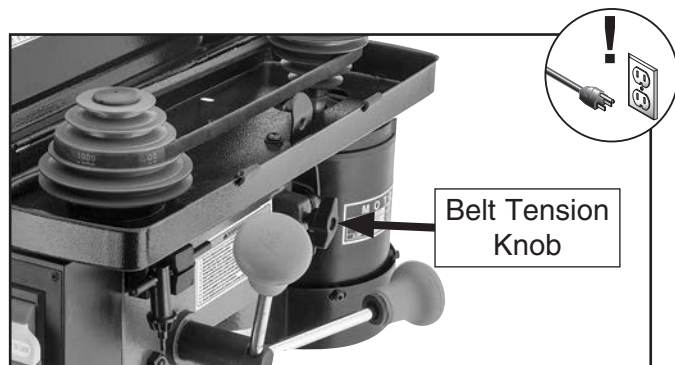


Figure 18. Belt tension knob location.

5. Pull motor toward front of drill press. This will take tension off V-belt.

Note: If V-belt is tight, have an assistant pull motor while you change drill speeds.

CAUTION

Use care when changing V-belts as they could pinch your fingers. They may also get hot after extended use so wait to change speeds if drill has been in use.

— If drive belt is cracked, torn, excessively worn, or damaged, replace it.

6. Move V-belt onto desired sheave on motor and spindle pulleys (see **Figure 19**).

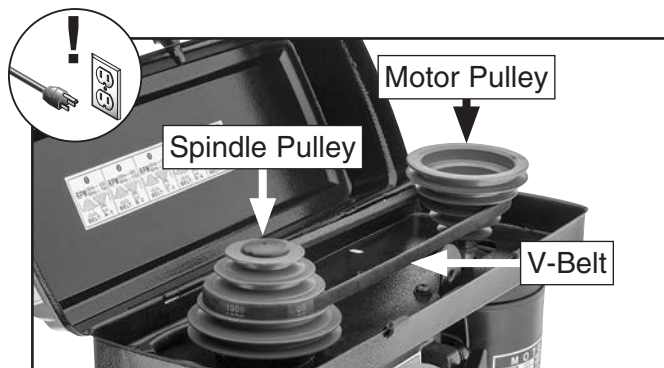


Figure 19. V-belt components.

7. Push motor away from drill press to increase belt tension and tighten belt tension knob to secure.

Note: Belt should be tight enough to prevent slippage. Correct tension is set if belt flexes 1/4" when thumb pressure is applied at mid-point of belt between pulleys (see **Figure 20**).

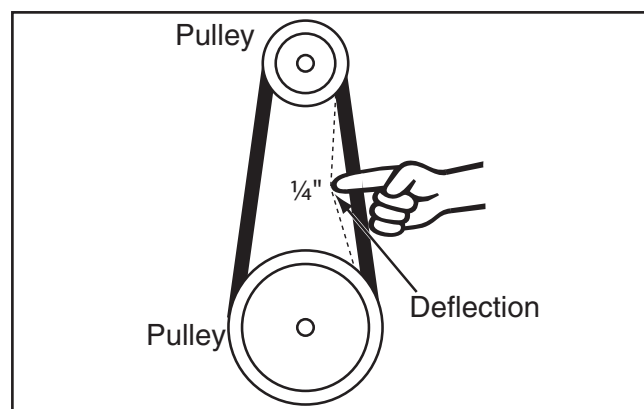


Figure 20. Checking belt tension.



Installing/Removing Drill Bits

Any drill bit you install in the chuck must be tight enough that it will not come loose during operation.

Installing a Drill Bit

1. DISCONNECT MACHINE FROM POWER!
2. Open drill chuck wide enough to accept shank of drill bit.
3. Insert drill bit as far as possible into chuck WITHOUT allowing chuck jaws to touch fluted portion of bit, then hand-tighten chuck.

Note: Make sure small bits are not trapped between edges of two jaws; if they are, re-install drill bit or it will not be secure enough to use for drilling.

4. Tighten chuck firmly with chuck key (see **Figure 21**).



Figure 21. Example of tightening chuck with chuck key.

Removing a Drill Bit

1. DISCONNECT MACHINE FROM POWER!
2. Use chuck key to open drill chuck, and catch drill bit with a rag to protect your hands.

Adjusting Depth Stop

The Model G0925 has a depth stop that allows you to drill repeat non-through holes to the same depth every time. The scale and indicator show the depth in inches. If the indicator ever gets nudged out of place, you can easily adjust it on the depth stop stud to wherever you like.

The depth stop consists of a stud attached to the quill with a depth nut that can be lowered or raised against a stop bracket to control drilling depth. **Figure 22** shows the various components of the depth stop.

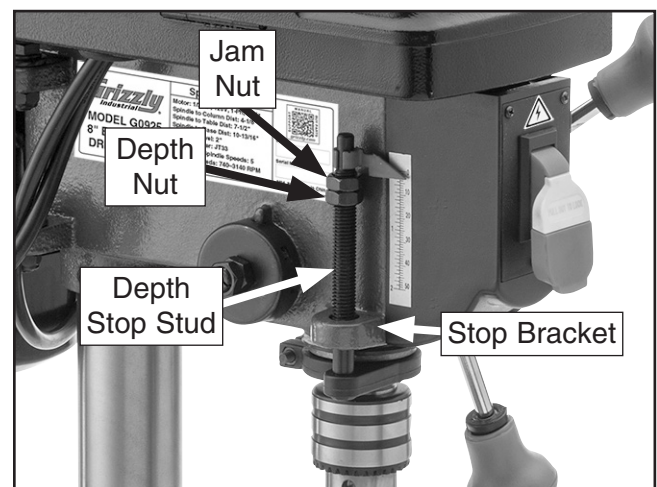


Figure 22. Depth stop components.

To adjust depth stop:

1. Lower drill bit to required height.
2. Thread depth nut down against stop bracket.
3. Adjust jam nut down against depth nut to secure position.



Positioning Table

The table moves vertically, pivots around the column, and tilts 45° left or right (see **Figure 23**).



Figure 23. Table tilted 45° right.

Adjusting Table Position

1. Loosen table lock handle shown in **Figure 24**.
2. Adjust table height and position it around column as desired, then tighten table height lock handle.

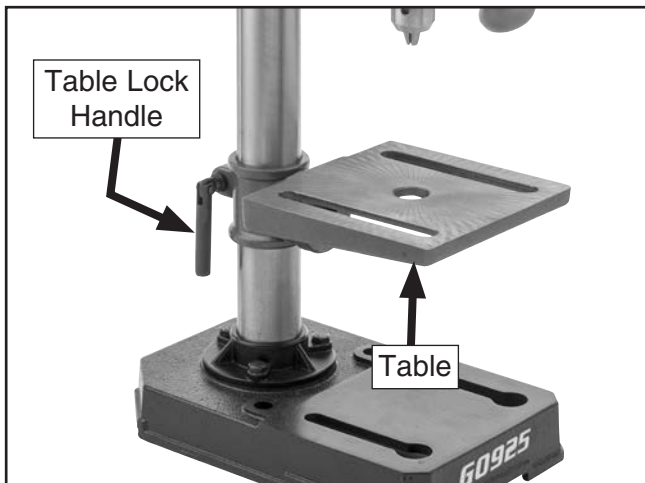


Figure 24. Table position adjustment controls.

Tilting Table

Items Needed	Qty
Open-End Wrench 19mm.....	1

To tilt table:

1. Loosen the lock bolt shown in **Figure 25**.
2. Tilt table until pointer aligns with desired angle on scale (see **Figure 25**).

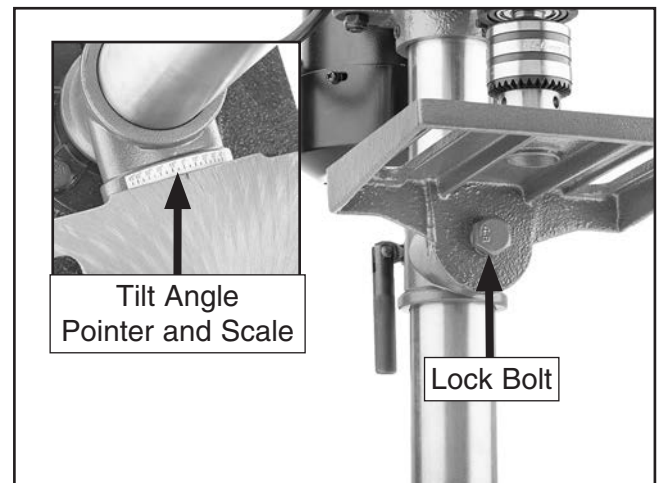


Figure 25. Table tilt controls.

3. Tighten lock bolt to secure table position.



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.

D2139—Steelex® Cobalt Alloy Drill Bits 21-Pc. Set

Because of its resistance to heat and stress, Cobalt Alloy bits turn faster without overheating. The 135° split point enables the drill to use less thrust and eliminates the tendency of the drill point to walk, which makes these great for use in portable drills or drill presses. Cobalt Alloy bits will retain their edge sharpness longer than normal HSS bits, resulting in a significant saving of time and money in the workshop. Includes 1/16"- 3/8" bits and a heavy-gauge steel index case for storage.



Figure 26. Model D2139 21-Pc. Alloy Drill Bits.

G5978—Drill Press Vise 4"

This Drill Press Vise features a quick turning knurled handle for efficient production work. Fine fit and finish and wide bolt slots make this the ideal drill press vise for any application. Includes a sturdy lip along both sides of the base, allowing vise to be mounted to nearly any machine table, using common T-slot clamps.

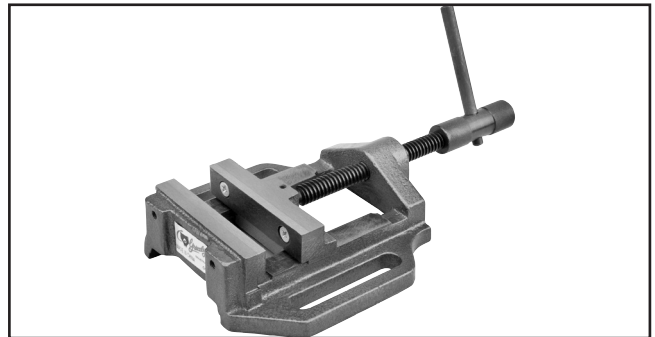


Figure 27. Model G5978 Drill Press Vise 4".

H8203—Professional Drill Bit Sharpening Machine (For Bits 1/8"-1/2" in Diameter)

This precision made Drill Bit Sharpening Machine is so simple to use, anyone can sharpen dull, smaller bits in three easy steps. Just set the drill bit in the collet, grind the taper relief angle, then grind the web thinning angle to reduce the center point width. It features a depth adjustment gauge, tapered diamond wheel, 90°-140° angle setting adjustment, and built-in collet tray. Collet sizes include 1/8", 5/32", 3/16", 1/4", 9/32", 5/16", 3/8", 25/64", 7/16", 15/32", and 1/2". Patented in the US!



Figure 28. Model H8203 Professional Drill Bit Sharpening Machine.

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



H7789—Mortising Attachment

A mortising attachment and chisel lets you drill square holes in wood. The attachment holds the sharp cornered chisel in place while the inner drill cuts out the center. Drills have 1/2" shank.



Figure 29. Model H7789 Mortising Attachment.

H8196—3-Pc. Step Drill Set

These step drills are designed to incrementally drill through sheet metal and thin stock until reaching the desired hole size. Three step drills cover hole sizes from 1/8" to 1/2" in 1/32" increments, 3/16" to 1/2" in 1/16" increments, and 1/4" to 3/4" in 1/16" increments. No-slip shanks fit 3/8" chucks. Titanium nitride coated for long life.



Figure 30. Model H8196 3-Pc. Step Drill Set.

G2500—20-Pc. Regular Sanding Drum Set

Use on your drill press, lathe, or hand drill. This kit consists of 5 drums in popular 1/2" x 1/2", 3/4" x 1", 1" x 1", 1 1/2" x 1 1/2", and 2" x 1 1/2" sizes. Comes with 3 grits for each drum.

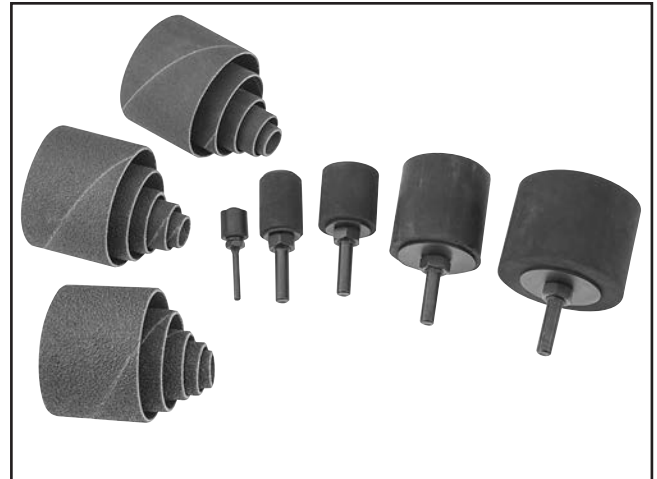


Figure 31. Model G2500 20-Pc. Sanding Drum Set.

G8581—1/2" Keyless Drill Chuck, JT33

Industrial-grade keyless chucks are excellent for quick bit changes. Knurled grips and exceptional accuracy make these chucks an indispensable part of any shop. Use on drill presses, lathe tailstocks and milling machines. 0-1/2" capacity with a Jacobs Taper #33 in back.



Figure 32. Model G8581 1/2" Keyless Drill Chuck, JT33.



Basic Hearing Protection

H4978—Deluxe Earmuffs - 27dB

H4979—Twin Cup Hearing Protector - 29dB

T20446—Ear Plugs 200 Pair - 31dB

A must have if you or employees operate for hours at a time.



Figure 33. Hearing protection assortment.

Basic Eye Protection

T20501—Face Shield Crown Protector 4"

T20502—Face Shield Crown Protector 7"

T20503—Face Shield Window

T20451—"Kirova" Clear Safety Glasses

T20452—"Kirova" Anti-Reflective S. Glasses

T20456—DAKURA Safety Glasses, Black/Clear



Figure 34. Assortment of basic eye protection.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray



Figure 35. Recommended products for protecting unpainted cast-iron and steel.

T23962—ISO 68 Moly-D Way Oil, 5 Gal.

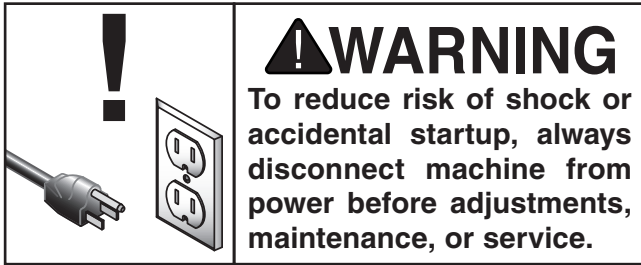
T26419—Syn-O-Gen Synthetic Grease



Figure 36. Recommended lubrication products.



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.
- Worn switch.
- Worn or damaged wires.
- Damaged V-belt.
- Any other unsafe condition.

Monthly Check

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup off motor.

Cleaning & Protecting

Cleaning the Model G0925 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast-iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like those in Accessories on **Page 25** in **Figure 35**.

Lubrication

An essential part of lubrication is cleaning the components before lubricating them.

This step is critical because grime and chips build up on lubricated components, which makes them hard to move. Simply adding more lubricant will not result in smooth moving parts.

Clean components before lubricating with recommended products like those shown in Accessories on **Page 25** in **Figure 36**.

DISCONNECT MACHINE FROM POWER BEFORE PERFORMING LUBRICATION!



Quill & Column Surfaces

Oil TypeGrizzly T23962 or ISO 68 Equivalent
 Oil Amount.....Thin Coat
 Lubrication Frequency8 Hrs. of Operation

Move the spindle all the way down to access the smooth surfaces of the quill. Adjust table height as necessary to access entire length of column (see **Figures 37–38**). Clean both with mineral spirits and shop rags.

Note: Avoid removing the grease from the column and quill racks during cleaning.

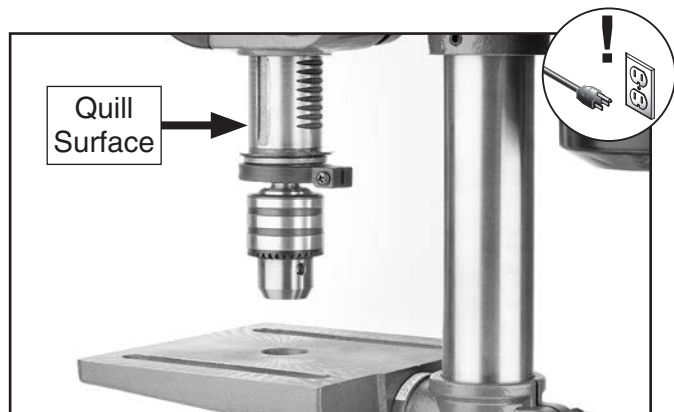


Figure 37. Quill surface.

Quill Rack & Pinion

Grease TypeGrizzly T26419 or NLGI#2 Equiv
 Grease AmountThin Coat
 Lubrication Frequency 90 hrs. of Operation

Move spindle all the way down to gain full access to quill rack (see **Figure 39**), then clean teeth with mineral spirits, shop rags, and a brush.

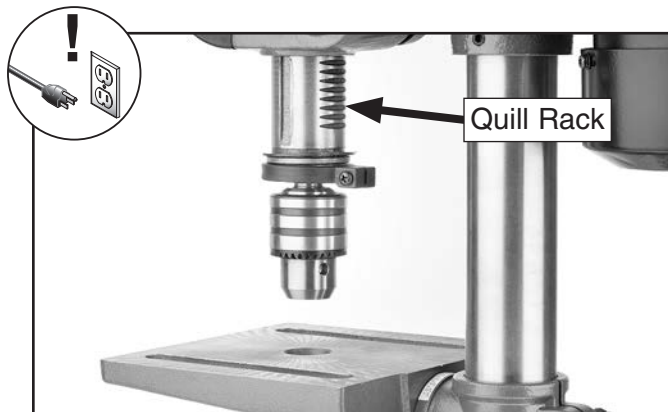


Figure 39. Quill rack location.

After cleaning, allow mineral spirits to dry, then use a brush to apply a thin coat of grease to the rack teeth, then fully raise/lower quill to distribute grease.

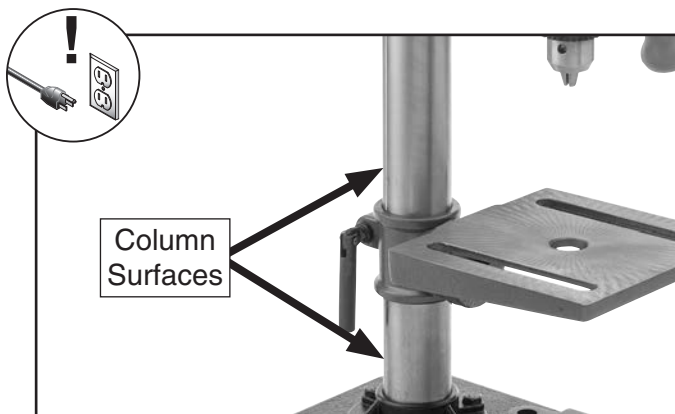


Figure 38. Column surface locations.

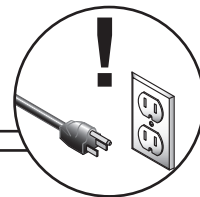
After cleaning, allow mineral spirits to dry, then apply a thin coat of oil to the surfaces.



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 fuse/breaker trips immediately after startup.	<ol style="list-style-type: none"> 1. Switch disabling key removed. 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped or fuse blown. 4. Wiring broken, disconnected, or corroded. 5. ON/OFF switch at fault. 6. Motor at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key. 2. Ensure correct power supply voltage and circuit size (Page 10). 3. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 4. Fix broken wires or disconnected/corroded connections (Page 32). 5. Replace. 6. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Incorrect bit/cutter for task. 2. Feed rate/cutting speed too fast. 3. Dull bit/cutter. 4. Belt slipping. 5. Machine undersized for task. 6. Motor overheated. 7. Pulley slipping on shaft/pulleys misaligned. 8. Run capacitor at fault. 9. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Use correct bit/cutter for task. 2. Decrease feed rate/cutting speed (Page 20). 3. Sharpen bit/cutter or replace. 4. Ensure belt is oil free, tension/replace belt (Page 20). 5. Use correct cutter/bit; reduce feed rate; reduce spindle RPM; use cutting fluid if possible. 6. Clean motor/let cool, and reduce workload. 7. Tighten loose pulley; replace broken/missing parts. Ensure pulleys are aligned. 8. Test/replace if at fault. 9. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. V-belt worn/belt slapping cover. 3. Incorrectly mounted to workbench. 4. Pulley loose or misaligned. 5. Motor mount loose/broken. 6. Spindle loose, improperly installed or damaged. 7. Workpiece loose. 8. Motor fan rubbing on fan cover. 9. Spindle bearings at fault. 10. Chuck or cutter at fault. 11. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Inspect/replace belt (Page 20). 3. Shim or tighten mounting hardware (Page 14). 4. Secure pulley on shaft and align (Page 31). 5. Tighten/replace. 6. Tighten loose spindle, install spindle with clean mating surfaces, replace spindle if damaged. 7. Use the correct holding fixture for workpiece. 8. Fix/replace fan cover; replace loose/damaged fan. 9. Test by rotating spindle; rotational grinding/loose shaft requires bearing replacement. 10. Replace out-of-round chuck, dull, or bent cutter. 11. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



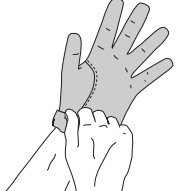

Drill Press Operations

Symptom	Possible Cause	Possible Solution
Tool falls out/loose in spindle/chuck.	<ol style="list-style-type: none"> 1. Tool loose or incorrectly installed. 2. Debris on tool or in spindle taper. 3. Excessive feed pressure. 	<ol style="list-style-type: none"> 1. Remove and re-install (Page 21). 2. Clean tool and spindle taper, then re-install. 3. Decrease feed pressure and allow chips to clear.
Breaking tools or cutters.	<ol style="list-style-type: none"> 1. Spindle speed/feed rate too fast. 2. Taking too big of cut at one time. 3. Improper cutting technique or type of cut. 4. Cutting tool getting too hot. 5. Spindle extended too far down while drilling. 	<ol style="list-style-type: none"> 1. Reduce spindle speed; reduce feed rate. 2. Decrease feed pressure and allow chips to clear by raising but up then moving back down. 3. Use right technique, tool, or machine for job. 4. Use coolant or oil for appropriate application (Page 19); reduce cutting speed (Page 20). 5. Retract spindle and raise table to increase rigidity.
Workpiece or tool vibrates or chatters during operation.	<ol style="list-style-type: none"> 1. Spindle extended too far down while drilling. 2. Table lock or lock bolt not tight. 3. Workpiece not secure. 4. Spindle speed/feed rate too fast. 	<ol style="list-style-type: none"> 1. Retract spindle and raise table to increase rigidity. 2. Tighten table lock or lock bolt (Page 22). 3. Properly clamp workpiece on table or in vise. 4. Reduce spindle speed (Page 20); reduce feed rate.
Table hard to move.	<ol style="list-style-type: none"> 1. Table locked. 2. Dirty column. 	<ol style="list-style-type: none"> 1. Disengage table lock (Page 22). 2. Clean away chips/debris. Lubricate column.
Spindle overheats.	<ol style="list-style-type: none"> 1. Drill press operated too long at high speeds. 	<ol style="list-style-type: none"> 1. Allow drill press to cool. Avoid operating at high speeds for extended time.
Spindle does not fully retract.	<ol style="list-style-type: none"> 1. Poorly adjusted/worn return spring. 2. Debris on spindle/quill rack. 	<ol style="list-style-type: none"> 1. Replace spring/increase return spring tension (Page 30). 2. Clean and lubricate spindle/quill rack.
Drill bit drifts.	<ol style="list-style-type: none"> 1. Dull/incorrectly sharpened drill bit. 2. Tool/bit incorrectly installed. 	<ol style="list-style-type: none"> 1. Correctly sharpen drill bit. 2. Correctly install tool/bit.
Drill bit stuck in workpiece.	<ol style="list-style-type: none"> 1. Workpiece loose. 2. Lack of proper lubrication for workpiece material. 3. Bit/cutting tool loose in chuck. 4. Spindle speed/feed rate too slow/fast. 	<ol style="list-style-type: none"> 1. Properly clamp workpiece. 2. Use appropriate lubrication for application (Page 19). 3. Remove and re-install (Page 21). 4. Adjust spindle speed (Page 20); feed rate.
Workpiece thrown from table.	<ol style="list-style-type: none"> 1. Workpiece not secure; bit too large for feed speed. 	<ol style="list-style-type: none"> 1. Properly clamp workpiece on table or in vise; decrease feed speed.
Excessive runout or wobbling in chuck/ drill bit.	<ol style="list-style-type: none"> 1. Debris between chuck-to-spindle mating surface. 2. Tool/bit bent or installed incorrectly. 3. Spindle bearings worn. 	<ol style="list-style-type: none"> 1. Remove chuck, clean, deburr tapered chuck and spindle mating surfaces, reassemble. 2. Install tool/bit correctly or replace (Page 21). 3. Replace spindle bearings.
Depth stop inaccurate.	<ol style="list-style-type: none"> 1. Depth stop pointer placed incorrectly. 	<ol style="list-style-type: none"> 1. Adjust pointer on depth stop stud.
Backside of workpiece splinters.	<ol style="list-style-type: none"> 1. Scrap board not installed between table and workpiece. 	<ol style="list-style-type: none"> 1. Install scrap board between table and workpiece.



Adjusting Spring Tension

The spring tension for automatic quill recoil has been pre-set at the factory. In most cases, it will never need to be re-adjusted during life of the machine. However, if quill stops automatically recoiling, the spring may need to be adjusted for additional tension. If it does need adjustment, the spring housing is located on the left side of the headstock.

	<p>⚠ WARNING If the return spring should come loose from the spring cap and rapidly unwind, laceration or impact injuries could occur. Always wear heavy leather gloves and safety glasses when adjusting the return spring tension.</p>
	

Items Needed	Qty
Heavy Leather Gloves.....	1 Pair
Safety Glasses	1 Pair
Shop Rags.....	As Needed
Open-End Wrench 14mm.....	1

To adjust spring tension:

1. DISCONNECT MACHINE FROM POWER!
2. PUT ON SAFETY GLASSES!
3. Wipe any oil off spring lock cover so it does not slip in your fingers when you hold the cover from spinning (see **Figure 41**).
4. Hold spring lock cover against side of headstock so the cover stays splined with locking lug, as shown in **Figure 41**, then loosen jam nut and loosen cover nut approximately 1/4" each.

IMPORTANT: Hold spring cover tightly during **Step 5**, or force of spring will cause cover to spin out of your hands.

5. Wearing gloves, pull spring cover (see **Figure 41**) outward just enough to disengage spring-cover lock slot from locking lug.
6. Rotate cover counterclockwise to increase tension, or let cover slowly unwind in clockwise direction to reduce spring tension (see **Figure 40**).

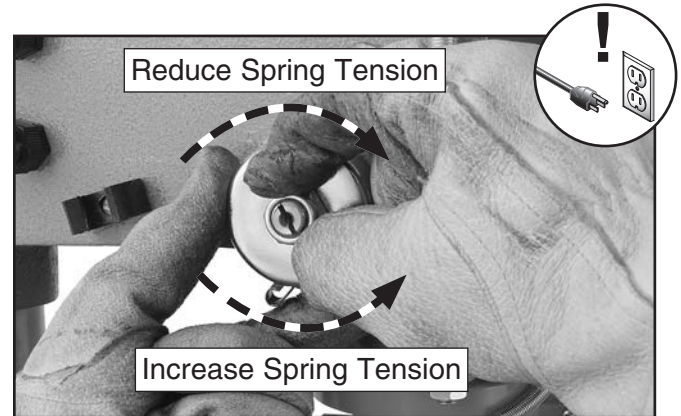


Figure 40. Example of adjusting cover.

7. Engage next available spring-cover lock slot with locking lug (see **Figure 41**) and hold spring lock cover tightly to side of headstock.

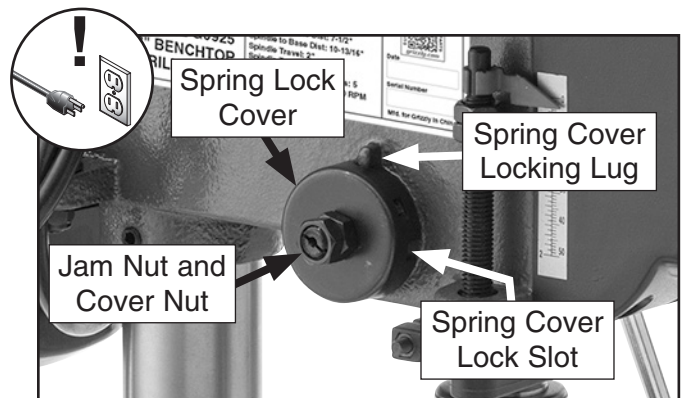


Figure 41. Spindle return spring assembly.

8. Tighten cover nut against spring cover just until nut stops, and then back off nut approximately 1/3 turn.
9. Hold cover nut and tighten jam nut to cover nut.
10. Check return spring tensioning by downfeeding spindle. Spindle should return quickly when downward pressure is released.

— If spindle does not retract quickly, repeat **Steps 4–9**, and re-check tension until return speed is adequate.



Aligning Pulleys

Pulley alignment is an important factor in power transmission and belt life. The pulleys should be parallel to each other and in the same plane (coplanar) for optimum performance.

Each pulley can be adjusted by loosening the set screws that secure them to their respective shafts.

Tools Needed	Qty
Hex Wrench 3mm.....	1
Straightedge 12".....	1

To align pulleys:

1. DISCONNECT MACHINE FROM POWER.
2. Open belt cover.
3. Turn belt tension knob counterclockwise to loosen motor tension spring (see **Figure 42**).

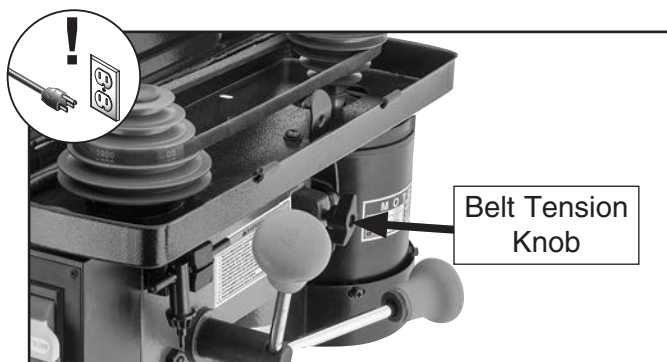


Figure 42. Belt tension knob location.

4. Pull motor toward front of drill press and remove V-belt.

Note: If V-belt is tight, have an assistant pull motor while you change drill speeds.

⚠ CAUTION

Use care when handling V-belts as they could pinch your fingers. They may also get hot after extended use so wait to handle if drill has been in use.

— If drive belt is cracked, torn, excessively worn, or damaged, replace it.

5. Place a straightedge against both pulleys (see **Figure 43**) and check that they are aligned. There should be no space anywhere between straightedge or pulleys.
 - If pulleys *are* aligned, proceed to **Step 8**.
 - If pulleys *are not* aligned, proceed to **Step 6**.
6. Loosen set screw on spindle pulley shown in **Figure 43**.

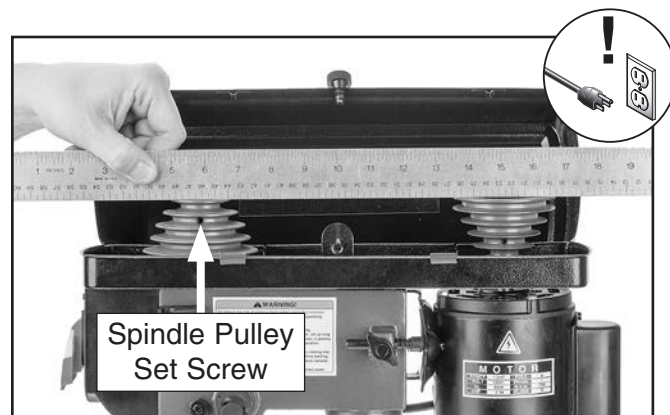


Figure 43. Checking pulley alignment.

7. Use straightedge to adjust pulley on shaft until it aligns with motor pulley, then tighten set screw from **Step 6**.
8. Replace V-belt and move onto desired sheave on motor and spindle pulleys.
9. Push motor away from drill press to increase belt tension and tighten belt tension knob to secure.

Note: Belt should be tight enough to prevent slippage. Correct tension is set if belt flexes 1/4" when thumb pressure is applied at midpoint of belt between pulleys (refer to **Changing Spindle Speeds** on **Page 20** for more information).



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.











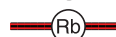

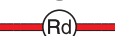

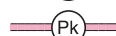
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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 	RED BLACK 	TURQUOISE 
RED 	ORANGE 	PINK 	



Wiring Diagram

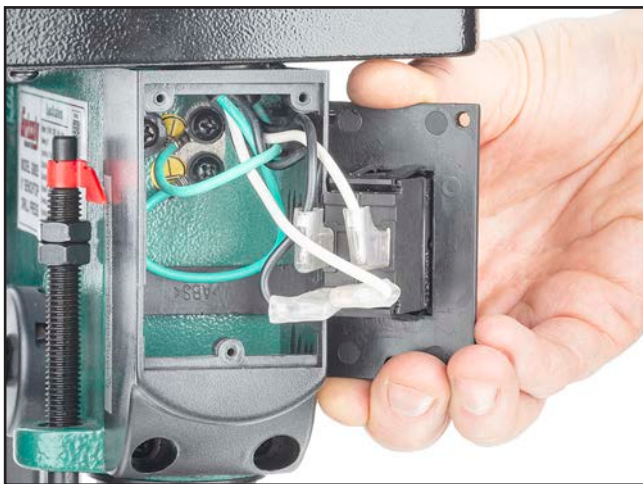
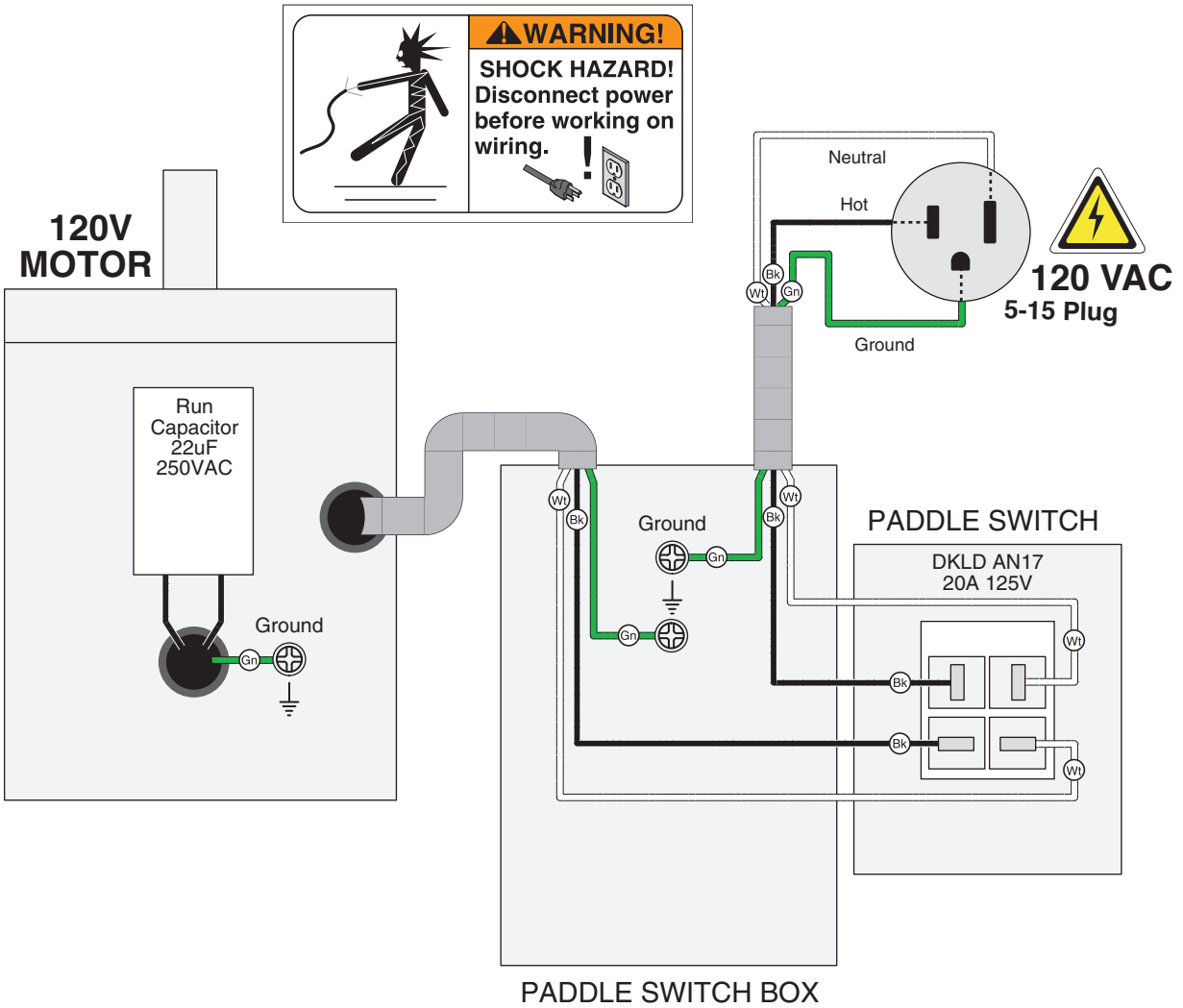


Figure 44. Switch box.



Figure 45. Run capacitor.



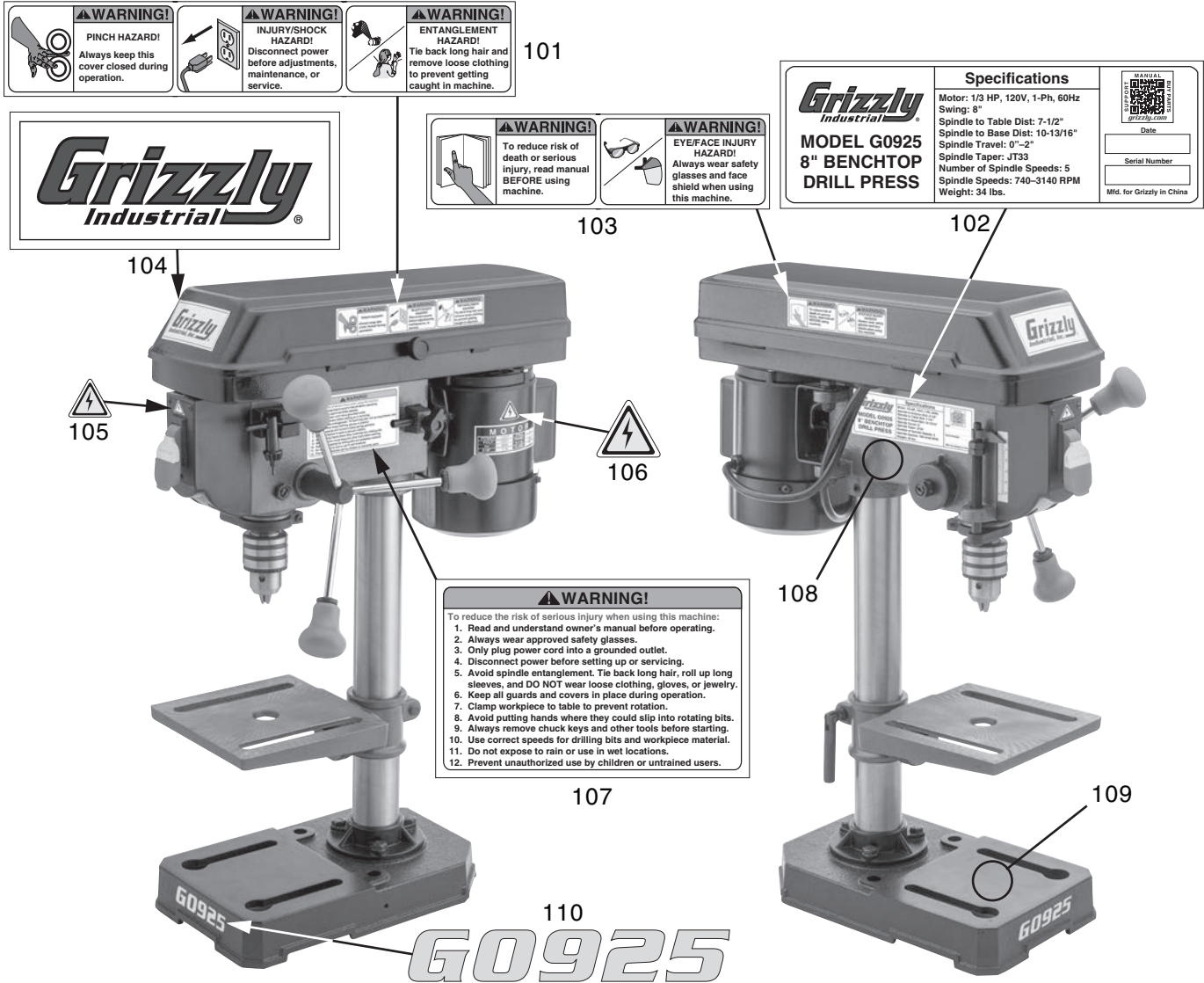
Main Parts List

REF	PART #	DESCRIPTION
1	P0925001	V-BELT M26 3L260
2	P0925002	MOTOR PULLEY
3	P0925003	SET SCREW M6-1 X 8
4	P0925004	POWER CORD 18G 3W 72" 5-15P
5	P0925005	SET SCREW M6-1 X 8
6	P0925006	SPINDLE PULLEY
7	P0925007	PULLEY CAP
8	P0925008	KNOB BOLT M5-.8 X 9, D20, ROUND KD
9	P0925009	BELT COVER
10	P0925010	FLAT WASHER 5MM
11	P0925011	ACORN NUT M5-.8
12	P0925012	HEX NUT M5-.8
13	P0925013	CORD CLAMP
14	P0925014	EXT RETAINING RING 21MM
15	P0925015	SPINDLE PULLEY SHAFT
16	P0925016	INT RETAINING RING 42MM
17	P0925017	BALL BEARING 6203ZZ
18	P0925018	FLAT WASHER 5MM
19	P0925019	PHLP HD SCR M5-.8 X 12
20	P0925020	PHLP HD SCR M6-1 X 8
21	P0925021	FLAT WASHER 6MM
22	P0925022	FLAT WASHER 9MM RUBBER
23	P0925023	GASKET 15 X 26 X 10MM
24	P0925024	HEX NUT M10-1.5
25	P0925025	RETURN SPRING COVER
26	P0925026	FLAT COIL SPRING
27	P0925027	TAP SCREW M3 X 10
28	P0925028	PADDLE SWITCH W/KEY DKLD AN17 20A 125V
29	P0925029	SWITCH PLATE
30	P0925030	SWITCH BOX
31	P0925031	BELLEVILLE LOCK WASHER 8MM
32	P0925032	LOCK WASHER 8MM
33	P0925033	PHLP HD SCR M5-.8 X 8
34	P0925034	PHLP HD SCR M5-.8 X 10
35	P0925035	DEPTH SCALE
36	P0925036	POINTER
37	P0925037	HEX NUT M10-1.5
38	P0925038	THREADED DEPTH ROD
39	P0925039	HEX NUT M6-1
40	P0925040	*DISCD*DEPTH STOP BRACKET
41	P0925041	HEX NUT M5-.8
42	P0925042	PHLP HD SCR M5-.8 X 25
43	P0925043	DRILL CHUCK JT33 X 1.5-13MM

REF	PART #	DESCRIPTION
44	P0925044	SPINDLE
45	P0925045	BALL BEARING 6201ZZ
46	P0925046	QUILL
47	P0925047	BALL BEARING 6201ZZ
48	P0925048	EXT RETAINING RING 12MM
49	P0925049	RUBBER SPACER 39 X 50 X 2
50	P0925050	HEX NUT M8-1.5
51	P0925051	SET SCREW M8-1.5 X 16 DOG-PT
52	P0925052	PINION GEAR
53	P0925053	LEVER SHAFT M8 X 1.25
54	P0925054	KNOB M8-1.25, D41
55	P0925055	FLAT WASHER 6MM
56	P0925056	PHLP HD SCR M6-1 X 6
57	P0925057	CHUCK KEY SEAT
58	P0925058	KNOB BOLT M8-1.25 X 12, D33, WING
59	P0925059	COMPRESSION SPRING 0.8 X 11 X 24
60	P0925060	BELT TENSION SHAFT
61	P0925061	BELT TENSION SHAFT CAP
62	P0925062	HEADSTOCK
63	P0925063	SET SCREW M8-1.25 X 8
64	P0925064	LOCK NUT M8-1
65	P0925065	FLAT WASHER 8MM
66	P0925066	HEX BOLT M8-1 X 25
67	P0925067	MOTOR 1/3HP 120V 1-PH
67-1	P0925067-1	MOTOR FAN COVER
67-2	P0925067-2	MOTOR FAN
67-3	P0925067-3	R CAPACITOR 22M 250V 5/16 X 2-1/2
67-4	P0925067-4	CAPACITOR COVER
67-5	P0925067-5	BALL BEARING 6202Z FRONT
67-6	P0925067-6	BALL BEARING 6201Z REAR
68	P0925068	FOLDING HANDLE 115L, M10-1.5 X 25
69	P0925069	TABLE TILT SCALE
70	P0925070	TABLE CLAMPING BRACKET
71	P0925071	TABLE
72	P0925072	HEX BOLT M12-1.75 X 30
73	P0925073	COLUMN
74	P0925074	HEX BOLT M8-1.25 X 20
75	P0925075	COLUMN SEAT
76	P0925076	BASE
77	P0925077	HEX WRENCH 4MM
78	P0925078	DRILL CHUCK KEY 3MM STD-SE 12T SD 13MM
79	P0925079	LOCK WASHER 12MM
80	P0925080	LOCK WASHER 5MM



Labels & Cosmetics



REF	PART #	DESCRIPTION
101	P0925101	PINCH/SHOCK/ENTANGLEMENT LABEL
102	P0925102	MACHINE ID LABEL
103	P0925103	READ MANUAL/PPE LABEL
104	P0925104	GRIZZLY LOGO LABEL
105	P0925105	ELECTRICITY LABEL - SMALL

REF	PART #	DESCRIPTION
106	P0925106	ELECTRICITY LABEL - LARGE
107	P0925107	MACHINE WARNING LABEL
108	P0925108	TOUCH-UP PAINT, GRIZZLY GREEN
109	P0925109	TOUCH-UP PAINT, GRIZZLY BLACK
110	P0925110	MODEL NUMBER 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.



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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