

Grizzly **Industrial, Inc.**®

2 HP DUST COLLECTOR MODEL G0548 INSTRUCTION MANUAL



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#5933 PRINTED IN TAIWAN

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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SECTION 1: SAFETY


WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Equipment

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

 **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 This symbol is used to alert the user to useful information about proper operation of the equipment.

WARNING

Safety Instructions for Power Tools

- 1. KEEP GUARDS IN PLACE** and in working order.
- 2. REMOVE ADJUSTING KEYS AND WRENCHES.** Form a habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
- 3. KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- 4. DO NOT USE IN DANGEROUS ENVIRONMENT.** DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
- 5. KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
- 6. MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
- 7. DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
- 8. USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

⚠️ **WARNING**

Safety Instructions for Power Tools

- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

- 10. WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
- 13. DO NOT OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

- 15. USE RECOMMENDED ACCESSORIES.** Consult the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.

- 16. REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

- 17. MANY WOODWORKING TOOLS CAN “KICKBACK” THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create “kickback” and know how to avoid them. Thoroughly read the manual accompanying the machine.

- 18. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

- 19. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. DO NOT** leave tool until it comes to a complete stop.

- 20. NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

- 21. NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

WARNING

Additional Safety For Dust Collectors

- 1. THIS DUST COLLECTOR IS TO BE USED FOR WOOD DUST COLLECTION ONLY.**
Do not use this dust collector to pick up liquids and metal scrap including, but not limited to, nails and filings. Metallic debris will contact the spinning impeller and could spark. The spark could then cause a sawdust explosion and severe fire hazard. Also, do not pick up material which cannot safely pass through the impeller such as solid wood scraps.
- 2. DO NOT PLACE YOUR HANDS OR TOOLS NEAR THE OPEN INLET** during operation for any reason including, but not limited to, unclogging material and testing suction. The impeller could cause serious damage to body parts if touched while spinning.
- 3. PROBLEMS CONCERNED WITH ANY MOVING PARTS** or accessories must be investigated and corrected with the power disconnected and after everything has come to a complete stop.
- 4. SUSPENDED DUST PARTICLES IN CONJUNCTION WITH AN IGNITION SOURCE,** may cause an explosion. Do not operate the dust collector in areas where explosion risks would be high if dust were dispersed into the area. Areas of high risk include, but are not limited to, areas near pilot lights and/or open flames.
- 5. DO NOT ALLOW STEEL TO STRIKE AGAINST IMPELLER WHICH MAY PRODUCE A SPARK.** Sparks can smolder in wood dust for a long time before fire or flame is detected. If metal contacts metal during operation, immediately turn off the dust collector, unplug the power cord from the outlet or flip the disconnect switch and wait for all moving parts to stop. Remove collection bags and empty the dust into an approved air tight metal container in case of spark. Remedy the metal to metal contact problem before resuming operation.
- 6. WHEN EMPTYING DUST FROM THE COLLECTION BAGS,** wear a respirator and safety glasses. Empty dust into an approved container and dispose of properly.
- 7. IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION,** stop using the machine! Then contact our service department or ask a qualified expert how the operation should be performed.
- 8. BE AWARE THAT CERTAIN WOODS MAY CAUSE AN ALLERGIC** reaction in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to in case there is a possibility of an allergic reaction. Always wear an approved respirator!

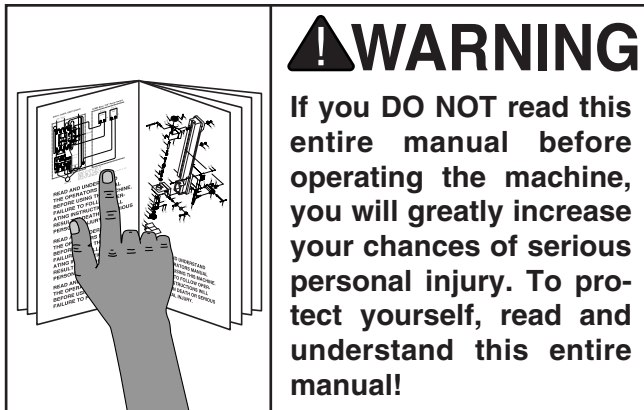
CAUTION

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

CAUTION

DO NOT use the dust collector for any other purpose besides collecting dust from connected woodworking machines. A dust collector should **NEVER** be used as an air cleaner. For safest use, wear a respirator and use an air cleaner in addition to the dust collector.

SECTION 2: GENERAL INFORMATION



Commentary

Grizzly Industrial, Inc. is proud to offer the Model G0548 2 HP Dust Collector. This machine is part of Grizzly's growing family of fine machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation.

We are also pleased to provide this manual with the Model G0548. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible.

If you have any comments or criticisms that you feel we should address in our next printing, please write to us at:

Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

Most important, we stand behind our machines. We have excellent regional service departments at your disposal should the need arise.

If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone:(570) 546-9663
Fax:(800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the Model G0548 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete.



SECTION 3: CIRCUIT REQUIREMENTS

Amperage Draw

The Model G0548 features a single phase 220V 2 HP motor.

Amperage Draw

220V 12 Amps



Circuit Breaker

Use the following guidelines when choosing a circuit breaker (circuit breakers rated any higher are not adequate to protect the circuit):

Circuit Breaker

220V 15 Amp, 2 Pole



Plug-Type

We recommend using a NEMA 6-15 plug (Figure 1). You may also “hard-wire” the dust collector directly to your panel, provided you place a disconnect near the machine. Check the electrical codes in your area for specifics on wiring requirements. The motor is wired according to the diagram in Figure 1a.

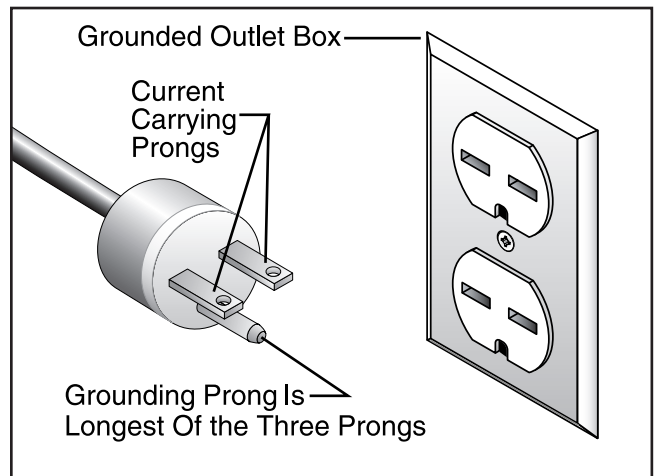


Figure 1. NEMA 6-15 plug and receptacle.

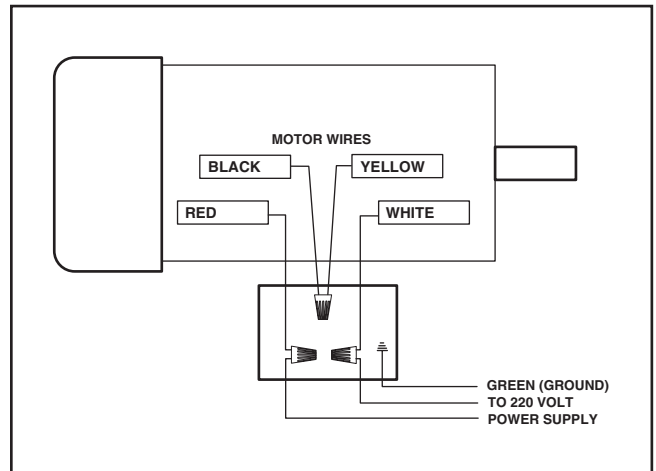
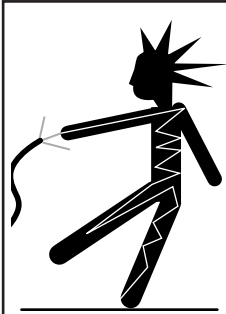


Figure 1a. 220 wiring diagram.



Grounding



⚠️ WARNING

Electrocution or a fire can result if the machine is not grounded correctly. Make sure all electrical circuits are grounded. **DO NOT** use the machine if it is not grounded.

NOTICE

The wire on the power cord with green or green and yellow striped insulation is the grounding conductor.

In the event of an electrical short, grounding reduces the risk of electric shock by providing a path of least resistance to disperse electric current. This tool is equipped with a power cord that has an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.



Circuit Capacity

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

If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified electrician.



Extension Cords

We do not recommend the use of extension cords with 220V equipment. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords. Should the situation be necessary to use an extension, make sure the cord is rated Standard Service (grade S) or better. The extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords when they become worn or damaged.



SECTION 4: MACHINE FEATURES

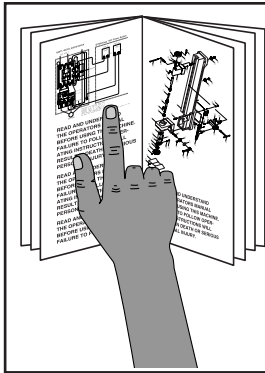


Figure 2. Main view of machine features.

1. Canister Filter Cleaning Handle
2. Canister Filter
3. 6" Inlet with Three 4" Ports
4. Clear Collection Bag

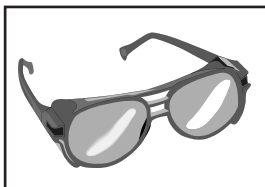


SECTION 5: SET UP



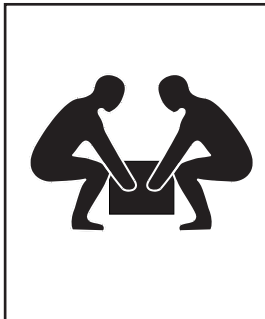
!WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations **BEFORE** starting the machine!



!WARNING

Wear safety glasses during the entire set up process!



!WARNING

The Model G0548 is a heavy machine (165 lbs. shipping weight). **DO NOT** over-exert yourself while unpacking or moving your machine—get assistance.

Unpacking

Your machine left our warehouse in two carefully packed boxes. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of the shipment, you should inventory the equipment.



Inventory

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

Box 1: Canister Filter Components (Figure 3)

- A. Canister Filter 1
- B. Foam Adhesive Bag 1
 - Wide Foam Strip 1
 - Narrow Foam Strip 1
- C. Canister Filter Cleaning Handle 1
- D. Belt Clamp 1

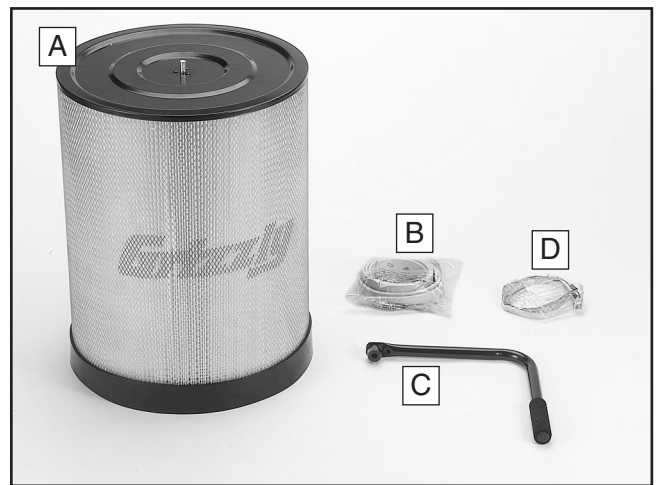


Figure 3. Canister filter box components.

Box 2: Main Components (Figure 4)

E.	Motor & Impeller.....	1
F.	6" Inlet w/Three 4" Fittings	1
G.	Base	1
H.	Metal "L" Outlet	1
I.	Collector (Not Shown)	1
J.	Hardware Bag	1
	— Casters	4
	— Flange Bolts 5/16"-18 x 1/2"	40
	— Phillips Head Tap Screw #10 x 3/8"	1
	— Combo Wrench 10 x 12mm.....	1
	— Hex Wrench 4mm	1
K.	Canister Support	1
L.	Collection Hardware Bag	1
	— Metal Belt Clamp	1
	— Clear Collection Bags	2
M.	Rubber Gaskets	2

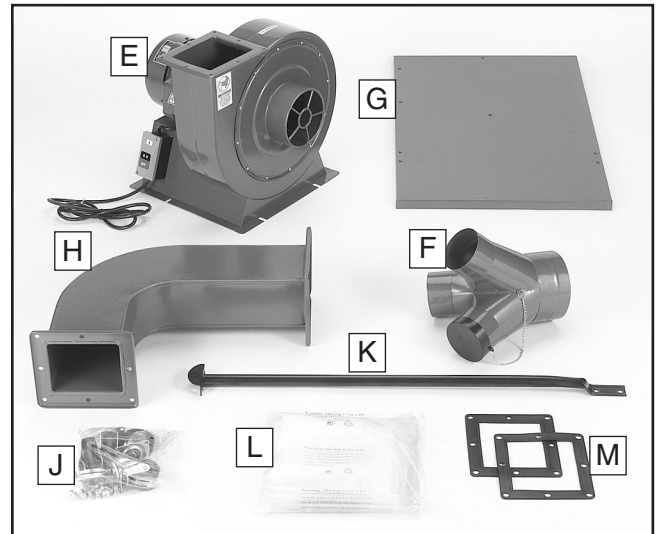


Figure 4. Main box items.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or, for the sake of expediency, replacements can be obtained at your local hardware store.

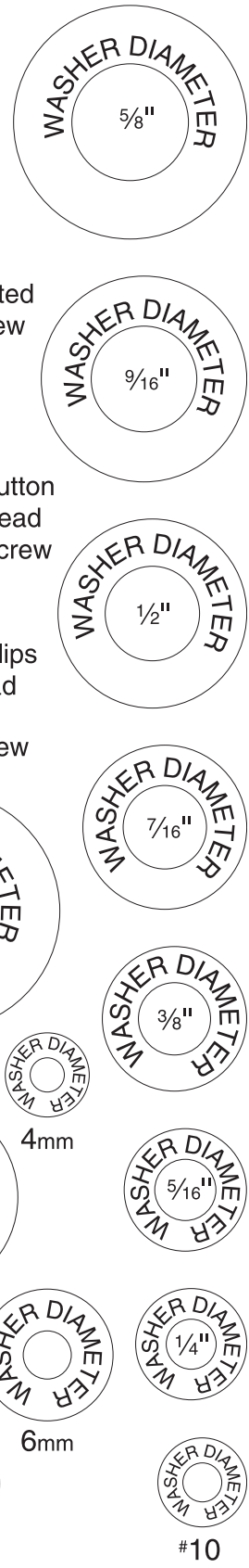
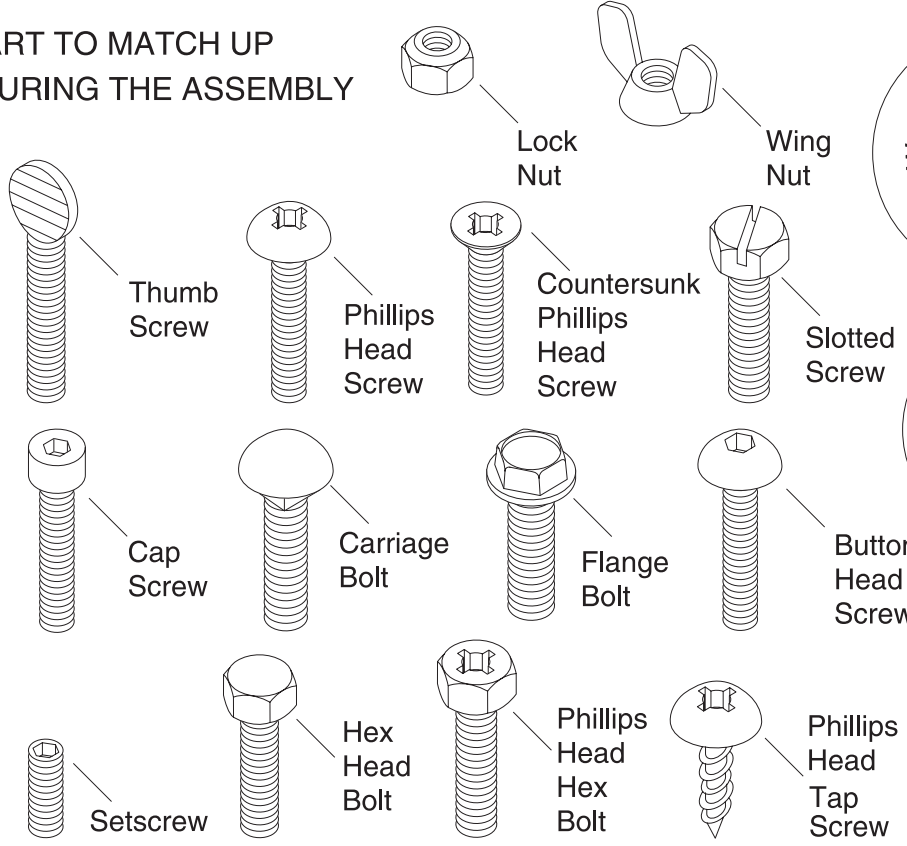


Hardware Recognition Chart

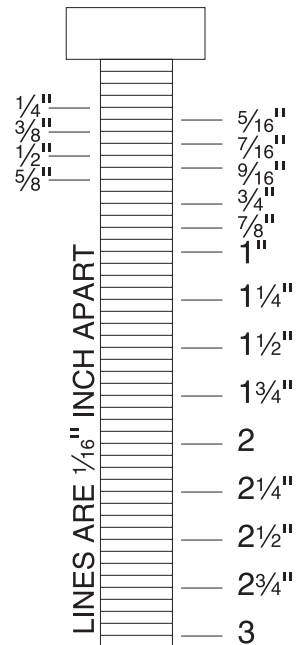
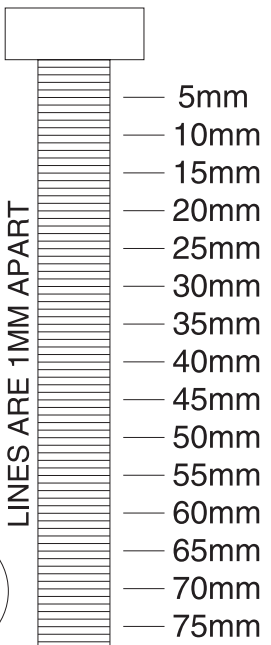
USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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



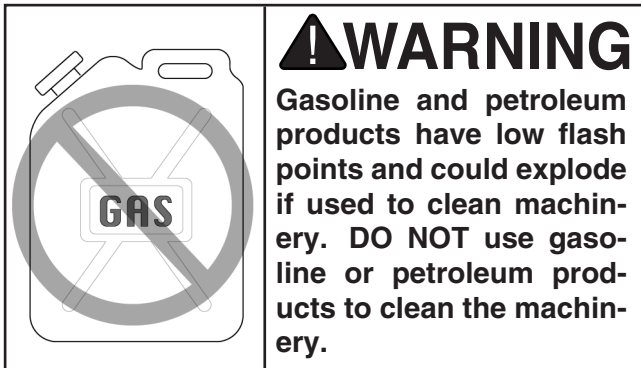
- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER

Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.



Site Considerations

Floor Load

The Model G0548 weighs 145 lbs and has a base footprint of 31½" x 37⅞". Most commercial floors are suitable for the machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for the machine. See **Figure 6** for the overall dimensions of the Model G0548.

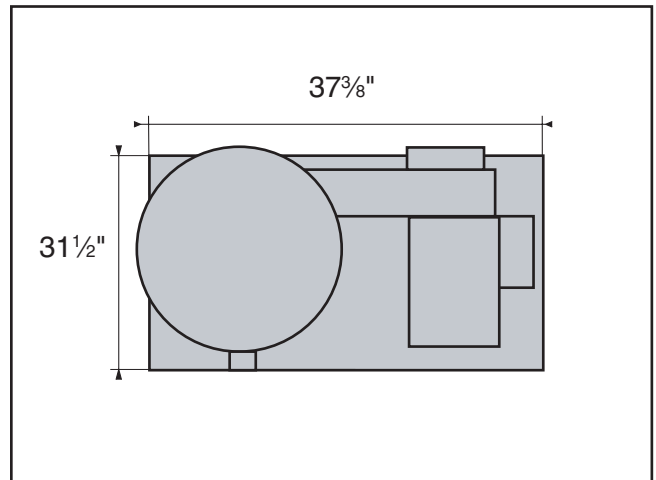
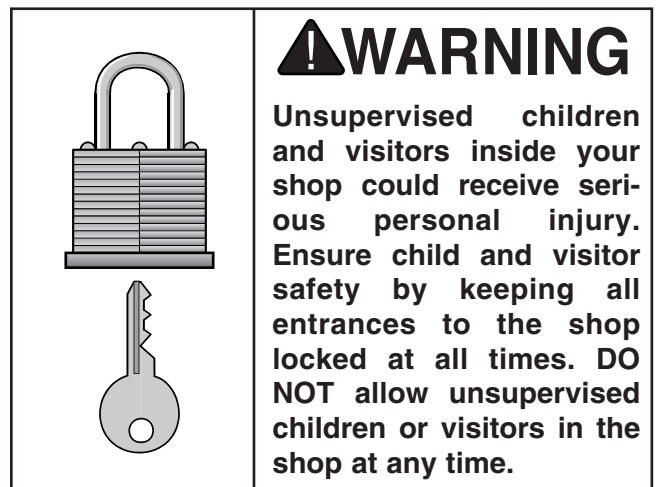


Figure 6. Overall machine dimensions.



Base

Components and Hardware Needed:	Qty
Base	1
Casters	4
Flange Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ "	16

Tools Needed:

Wrench or Socket 12mm.....	1
----------------------------	---

To assemble the dust collector base:

1. Position the base upside down.
2. Secure the casters into the mounting brackets under the base with the flange bolts (**Figure 7**).

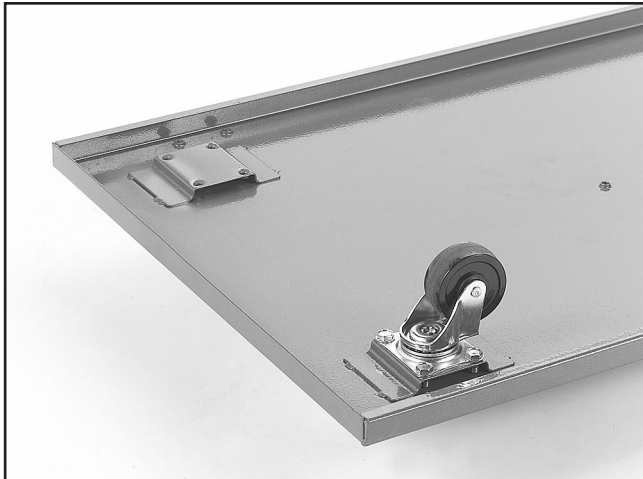


Figure 7. Caster installed on the base mounting bracket.



Motor and Impeller

Components and Hardware Needed:	Qty
Base	1
Motor and Impeller	1
Flange Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ "	4

Tools Needed:

Wrench or Socket 12mm.....	1
----------------------------	---

To assemble the motor and impeller:

1. Flip the base over on the casters and locate the mounting holes for the motor and impeller.
2. Position the motor and impeller on the base and secure them with the flange bolts (**Figure 8**).

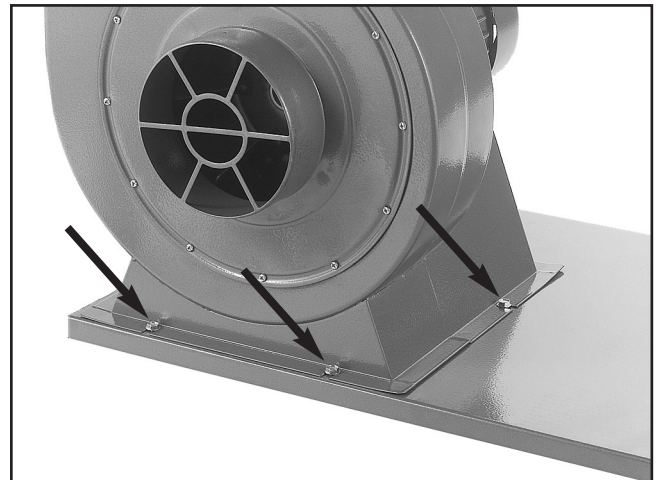


Figure 8. Motor and impeller attached to base.



Outlet

Components and Hardware Needed:	Qty
Metal "L" Outlet	1
Flange Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ ".....	8
Rubber Gasket	1

Tools Needed:

Wrench or Socket 12mm.....	1
----------------------------	---

To install the metal "L" outlet:

1. Place the rubber gasket around the impeller outlet rim as shown in **Figure 9**.



Figure 9. Placing rubber gasket over outlet.

2. Secure the metal "L" outlet in place with the flange bolts (**Figure 10**).



Figure 10. Metal "L" outlet attached to impeller.



Canister Support

Components and Hardware Needed:	Qty
Base	1
Canister Support	1
Flange Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ ".....	2

Tools Needed:

Wrench or Socket 12mm.....	1
----------------------------	---

To install the canister support brace:

1. Place the canister support over the holes on the base edge (**Figure 11**).



Figure 11. Canister support attached to base.

2. Secure the canister support in place with the flange bolts.



Collector Ring

Components and Hardware Needed:	Qty
Collector	1
Flange Bolts $\frac{5}{16}$ "-18 x $\frac{1}{2}$ ".....	10
Rubber Gasket	1

Tools Needed:

Wrench or Socket 12mm.....	1
----------------------------	---

To install the collector:

1. Place the rubber gasket in the outlet of the collector.
2. Secure the collector to the metal intake with 8 flange bolts, (**Figure 12**).



Figure 12. Collector installed.

3. Attach the canister support to the side of the collector with the 2 remaining flange bolts.



Canister Filter

Components and Hardware Needed:	Qty
Canister Filter	1
Canister Filter Cleaning Handle	1
Belt Clamp	1
Wide Foam Strip	1

Tools Needed:

Wrench or Socket 10mm.....	1
----------------------------	---

To install the canister:

1. Secure the wide foam strip around the outside top rim of the collector as shown in **Figure 14**.



Figure 14. Installing wide foam strip.

2. Trim the excess foam strip so the ends come together evenly, (**Figure 15**).

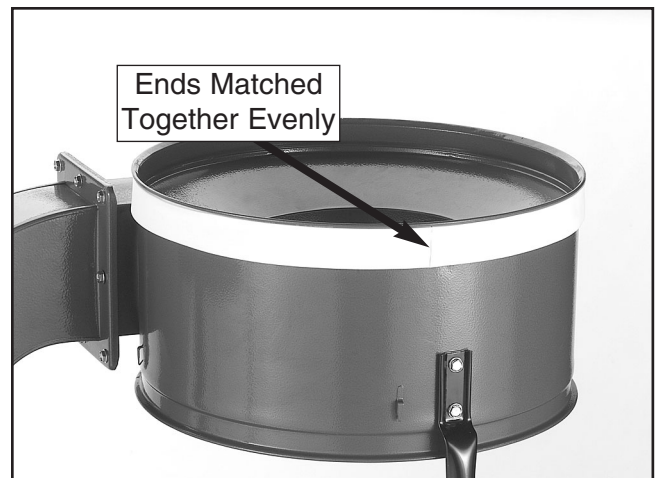


Figure 15. Trimmed foam strip.

3. Install the handle onto the top of the canister filter by tightening the hex bolt against the flat of the shaft (**Figure 15**).

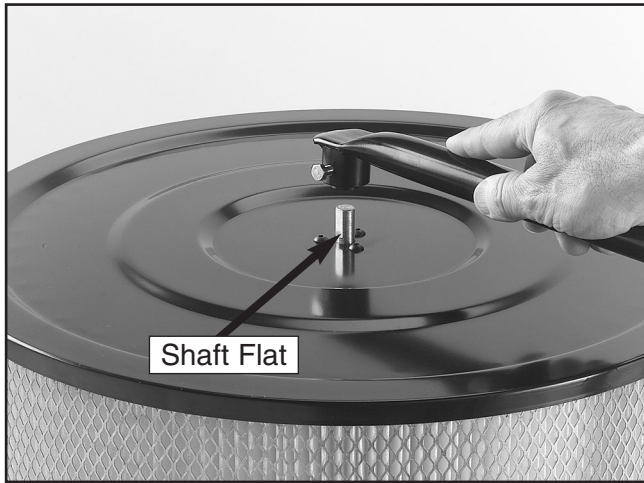


Figure 16. Installing canister handle.

4. Place the canister filter on top of the collector.
5. Position the metal belt clamp around the bottom of the canister filter so it will compress around the foam strip (**Figure 17**).



Figure 17. Installed and secured canister filter.



Collection Bag

Components and Hardware Needed:		Qty
Clear Collection Bag		1
Metal Belt Clamp		1
Narrow Foam Strip		1

Tools Needed:

Wrench or Socket 10mm.....	1
----------------------------	---

To install the collection bag:

1. Secure the narrow foam strip around the outside bottom rim of the collector and trim the excess.
2. Hook the clear collection bag on the hooks around the bottom of the collector. (**Figure 18**).



Figure 18. Trimmed foam strip and collector hook locations.

3. Tighten the metal belt clamp around the narrow foam strip to seal and secure the lower collection bag (**Figure 19**).



Figure 19. Lower collection bag installed.



Inlet

Components and Hardware Needed:		Qty
6" Inlet with Three 4" Ports		1
Phillips Head Tap Screw #10 x 3/8"		1

Tools Needed:	
Phillips Screwdriver	1

To install the inlet:

1. Insert the inlet over the impeller intake hole.
2. Secure the inlet in place with the Phillips head tap screw, (**Figure 20**).

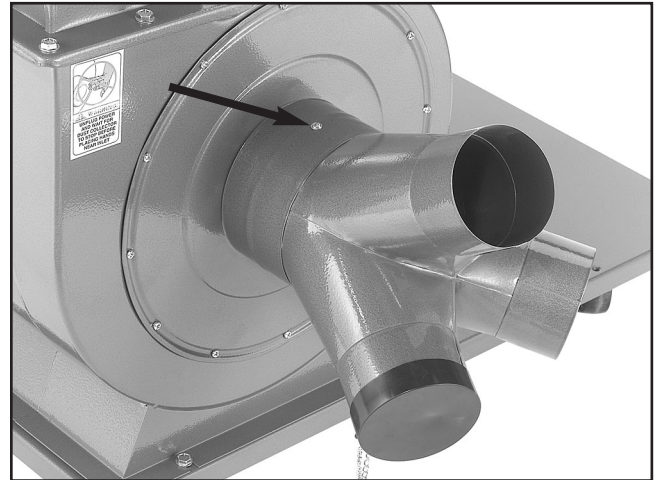


Figure 20. Installed inlet.



SECTION 6: COLLECTION SYSTEM

General

The Model G0548 can be operated as either a stationary or a mobile unit. There are advantages and disadvantages to both set-ups. The advantage of the mobile system is eliminating the cost of many ducts and fittings. On the other hand, the stationary system is more versatile and convenient.

The Model G0548 is designed to be a central dust collector system. Locate the dust collector in an out of the way location such as a corner or separate room. The dust collector is capable of collecting dust from up to two machines running simultaneously. Because of the large suction capacity of the Model G0548, great flexibility is possible in the planning and designing of your dust collection duct layout. Grizzly offers a complete line of dust collection accessories for setting up a stationary system. Additionally, Grizzly offers a guide book entitled *Dust Collection Basics*.

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



Material Selection

You have many choices regarding main line and branch line duct material. In most commercial workshops, the main line and branch lines are usually metal duct. Flexible hose is then used to connect each machine to the branch lines. In the case of small home shops, flexible hose may be used for both main line and branch line ducts. Plastic duct is also a popular material for home shops. Please be aware that there is a fire or explosion hazard if plastic duct material is used for dust collection without being grounded against static electrical charge build-up. This topic will be discussed later in the manual.

METAL DUCT

Metal duct comes in many varieties. Stove pipe, heating/ventilation duct and duct made especially for dust collection are all options. Advantages of metal duct is its conductivity and that it does not contribute to static electrical charge build-up. However, static charges are still produced when dust particles strike other dust particles as they move through the duct. Since metal duct is a conductor, it can be grounded quite easily to dissipate any static electrical charges. However, metal duct is generally more expensive than plastic duct and it is not usually airtight unless specifically manufactured for dust collection. Specially manufactured metal duct, on the other hand, is quite expensive. Metal duct is also generally more difficult to cut and assemble.

FLEXIBLE HOSE

Flexible rubber hose, polyethylene, plastic flex-hose and other flexible ribbed hose is generally used for short runs, small shops and at rigid duct-to-tool connections. There are many different types of flex hose on the market today. These are manufactured from materials such as polyethylene, PVC, cloth hose dipped in rubber and even metal, including steel and aluminum.

There are also many kinds of pure plastic flexible hose, such as non-perforated drainage type hose and dryer vent hose. Drainage type hose, while being economical, does not quite have the flexibility required for dust collection. The inside of the duct is also deeply corrugated and can increase the static pressure loss by as much as 50% over smooth wall duct. Dryer vent hose, while being completely flexible, is non-resistant to abrasion and has a tendency to collapse in a negative pressure system.

If using flex-hose, you should choose one of the many types that are designed specifically for the movement of solid particles, i.e. dust, grains and plastics. However, the cost of specifically designed flexible duct can vary greatly. Grizzly offers polyethylene hose which is well suited for the removal of particulate matter, especially sawdust, since it is durable and completely flexible. Polyethylene is also very economical and available in a wide variety of diameters and lengths for most applications.

PLASTIC DUCT

The popularity of plastic duct is due to the fact that it is an economical and readily available product. It is also simple to assemble and easily sealed against air loss. The primary disadvantage of plastic duct for dust collection, whether black ABS or white PVC and even rubber or polyethylene flex-hose, is the inherent danger of static electrical build-up.

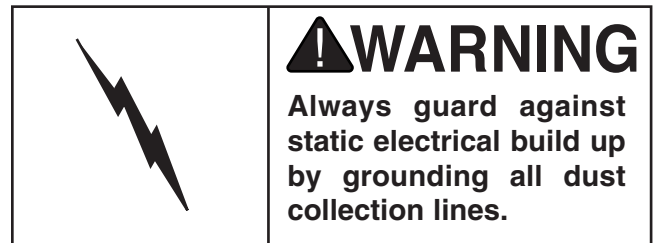


System Grounding

Since plastic hose is abundant, relatively inexpensive, easily assembled and air tight, it is a very popular material for conveying dust from woodworking machines to the dust collector. We recommend using flexible hose (flex-hose) to connect the woodworking machine to the dust collector. However, plastic flex-hose and plastic duct are an insulator, and dust particles moving against the walls of the plastic duct create a static electrical build up. This charge will build until it discharges to a ground. If a grounding medium is not available to prevent static electrical build up, the electrical charge will arc to the nearest grounded source. This electrical discharge may cause an explosion and subsequent fire inside the system.

To protect against static electrical build up inside a non-conducting duct, a bare copper wire should be placed inside the duct along its length and grounded to the dust collector. You must also confirm that the dust collector is continuously grounded through the electrical circuit to the electric service panel.

If you connect the dust collector to more than one machine by way of a non-conducting branching duct system and blast gates, the system must still be grounded as mentioned above. We recommend inserting a continuous bare copper ground wire inside the entire duct system and attaching the wire to each grounded woodworking machine and dust collector.



Be sure that you extend the bare copper wire down all branches of the system. Do not forget to connect the wires to each other with wire nuts when two branches meet at a “Y” or “T” connection.

Ensure that the entire system is grounded. If using plastic blast gates to direct air flow, the grounding wire must be jumped (**Figure 22**) around the blast gate without interruption to the grounding system.

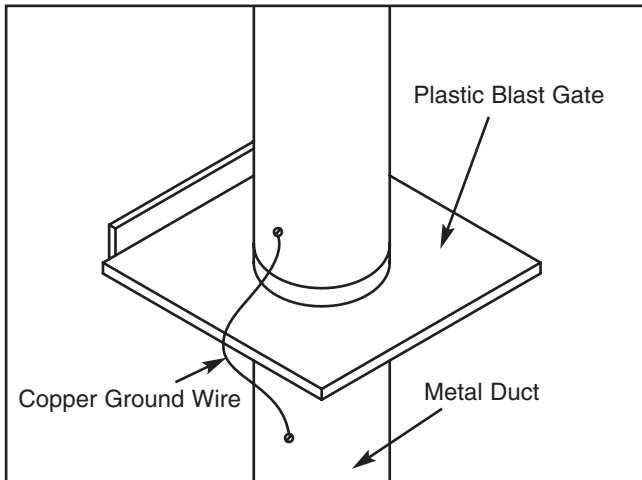


Figure 22. Ground jumper wire when using plastic blast gates and metal duct.

We also recommend wrapping the outside of all plastic ducts with bare copper wire to ground the outside of the system against static electrical build up. Wire connections at Y’s and T’s should be made with wire nuts.

Attach the bare ground wire to each stationary woodworking machine and attach the dust collector frame with a ground screw as shown in **Figure 23**. Ensure that each machine is continuously grounded to the grounding terminal in your electric service panel.

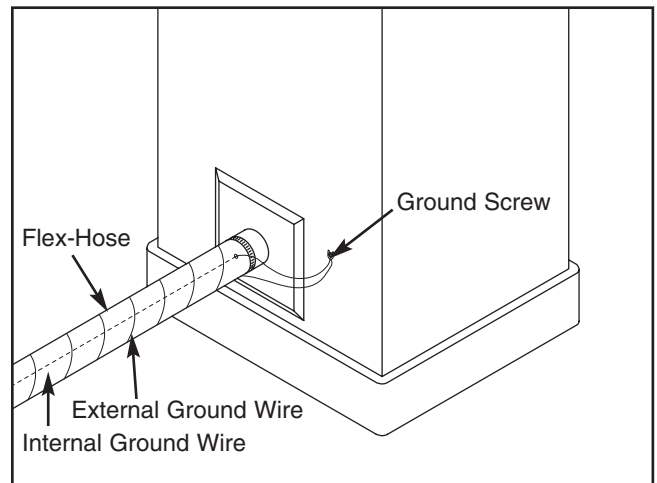


Figure 23. Flex-hose grounded to machine.



Design Suggestions

When designing a successful dust collection system, planning is the most important step. Before you set out to run the first section of duct, consider these general guidelines for an efficient system:

1. Machines that produce the most saw dust should be placed closest to the dust collector. These machines include thickness planers, shapers, sanders and bandsaws.
2. Ideally, you should design the duct system to have the shortest possible mainline run and to have short secondary branch ducts.
3. Directional changes should be kept to a minimum. The more directional change fittings you use, the greater the loss of overall pressure.
4. Gradual directional changes are more efficient than sudden directional changes (i.e. use the largest corner radius possible when changing hose or pipe direction).
5. Each individual machine should have a blast gate to control suction from one machine to another.
6. The simpler the system, the more efficient and less costly it will be.

The best way to plan your new system is to draw a bird's eye view (as shown in **Figure 24**) of your shop and sketch the following:

1. Your desired location of the dust collector, usually in a corner or along a wall.
2. The location of each machine in the system.
3. The location of the main line duct and each branch line.
4. The location of any obstruction such as a joist or heating duct, that will require special duct routing.

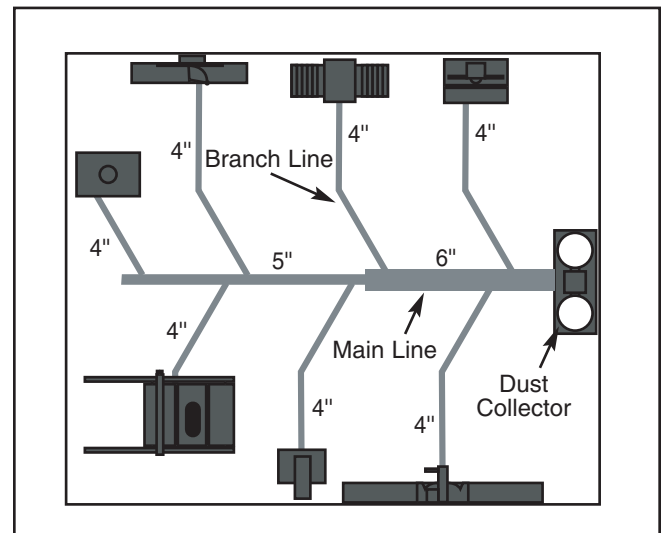



Figure 24. Bird's eye planning view.





SECTION 7: OPERATION

Test Run

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

	<p>⚠️ WARNING Keep loose clothing rolled up and out of the way of machinery and keep hair pulled back.</p>
--	---

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

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

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

Turn on the power supply at the main panel. Press the *START* button. Make sure that your finger is poised on the *STOP* button, just in case there is a problem. The dust collector should run smoothly, with little or no vibration or rubbing noises. Strange or unnatural noises should be investigated and corrected before operating the machine further.

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



General

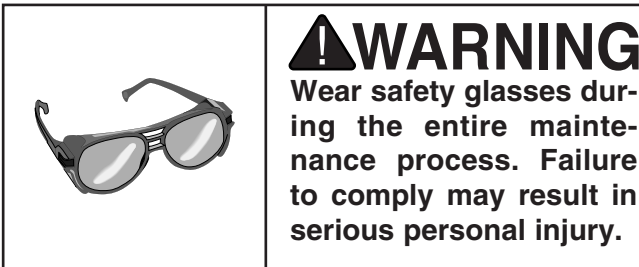
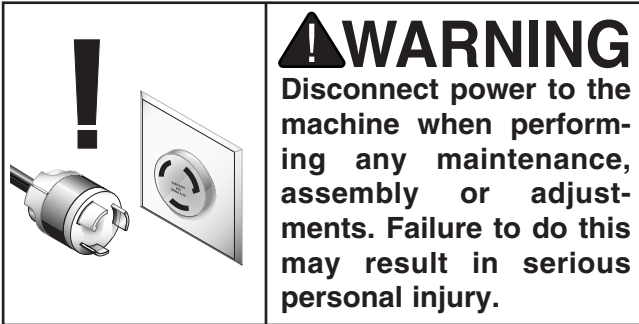
Operating your Model G0548 is simple and straightforward. Blast gates located at each of the machines controls the air flow from the woodworking machine to the dust collector. If a machine is not being used, keep the blast gate closed to maintain higher levels of efficiency throughout the system.



⚠️ CAUTION

DO NOT use the dust collector for any other purpose besides collecting dust from connected woodworking machines. A dust collector should **NEVER** be used as an air cleaner. For safest use, wear a respirator and use an air cleaner in addition to the dust collector.

SECTION 8: MAINTENANCE



General

Regular periodic maintenance on your Model G0548 Dust Collector will ensure its optimum performance. Make a habit of inspecting your machine each time you use it. Check for the following conditions and repair or replace when necessary:

1. Loose mounting bolts.
2. Worn switch.
3. Worn or damaged cords and plugs.
4. Any other condition that could hamper the safe operation of this machine.
5. Do not let collection bags get completely full.

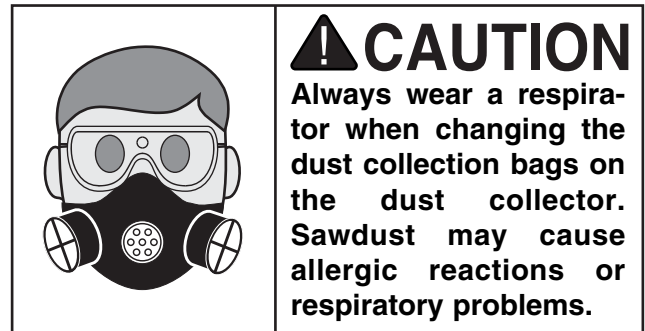


Lubrication

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



Bag and Canister Cleaning



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

Grizzly offers replacement collection bags and canister filters for your Model G0548 Dust Collector.

Model H5783 Replacement Canister Filter

Model H6899 Replacement Collection Bag

To clean the canister filters:

1. Move the canister handle back and forth to free trapped dust particles from the filter (**Figure 25**). The particles will fall into the collection bag.

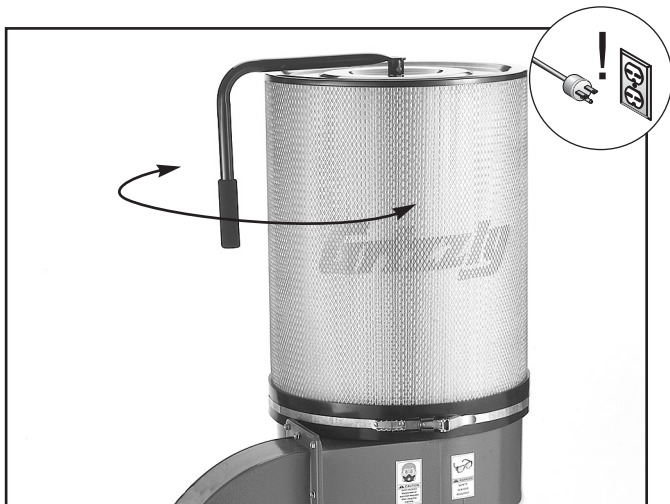


Figure 25. Move canister handle back and forth.

To empty the collection bag:

1. Make sure you are wearing a respirator and the dust collector is unplugged.
2. When the collection bag is full, unclamp the collection bag and dispose of the dust.
3. Install a new collection bag.

While the Model G0548 excels at collecting the majority of wood dust produced by your machines, it is not an air filter; therefore, **we strongly recommend** the supplemental aid of a shop air filter such as the Grizzly G5955 or G9956. Air filters are designed to collect the smaller dust particles that dust collector bags cannot trap.



SECTION 9: REFERENCE INFO

The following pages contain the machine data sheets, parts diagrams, parts lists, and the Warranty/Return information for the Model G0548.

If you need parts or help in assembling your machine, or if you need operational information, call the Grizzly Service Department. Trained service technicians will be glad to help you.

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

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

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>.





MACHINE DATA SHEET

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

MODEL G0548 2 HP DUST COLLECTOR

Design TypeSingle Stage Floor Model

Overall Dimensions:

Base21¼" x 33½"
Height78"
Shipping Weight165 lbs.
Net Weight145 lbs.
1st Box Size36¼" L x 23" W x 23" H
2nd Box Size22" L x 22" W x 28½" H

Specifications:

Intake Hole Size6"
Intake Adapter Hole Size(3) 4" Inlets
Canister Filter Size19⁵/₈" x 23⁵/₈"
Canister Filtration Rating2.5 Micron
Lower Bag Size19½" x 33"
Lower Bag MaterialPlastic
Lower Bag Capacity (Replacement Bag H6899)5.4 Cubic Feet
Air Suction Capacity1700 CFM
Static Pressure (Inches of Water)14.3"

Construction:

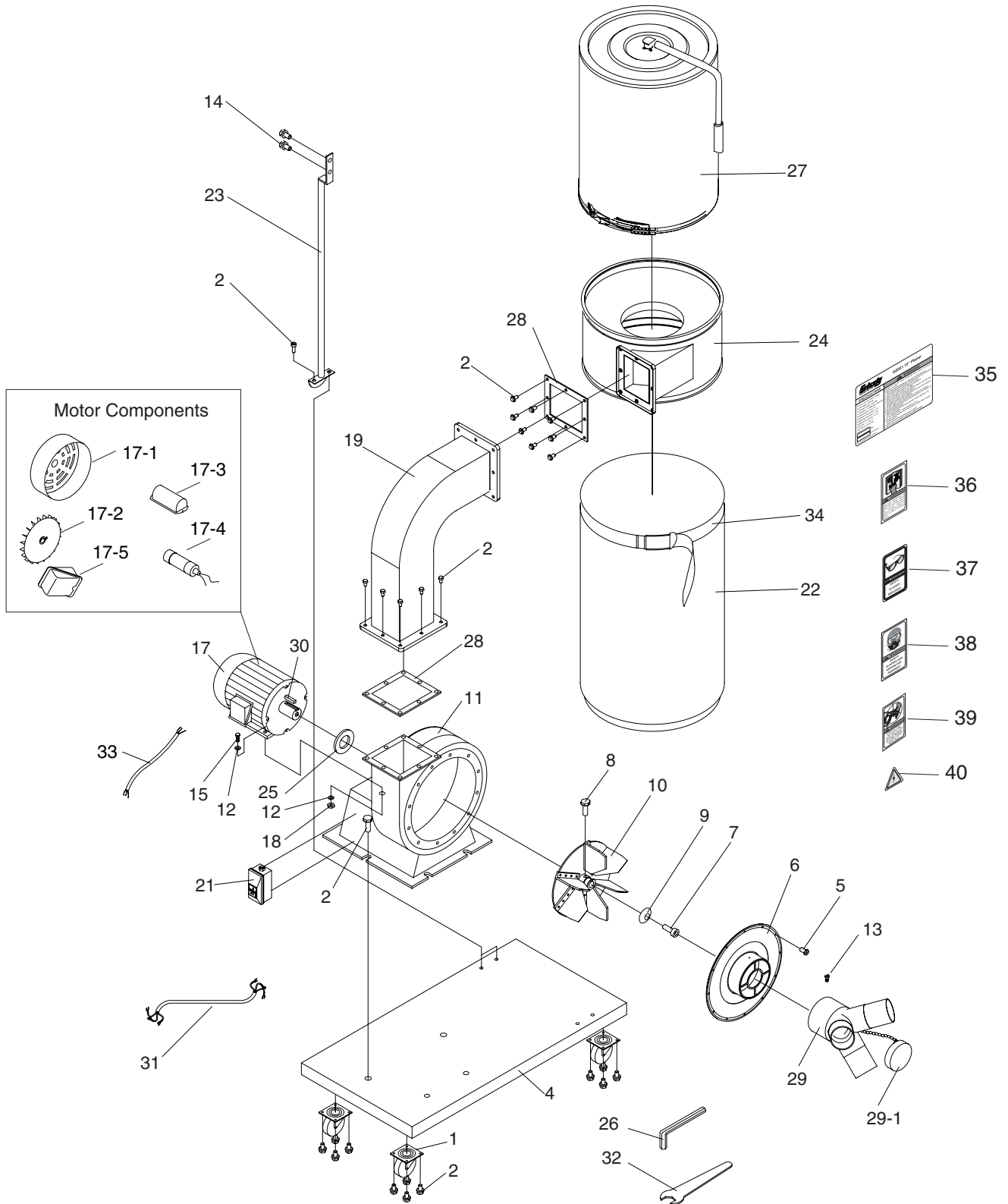
BaseFabricated Sheet Metal with Casters
BodyFabricated Sheet Metal
Impeller TypeRadial Fin
Impeller Construction³/₃₂" Steel, Riveted Fins
Impeller Size12"

Motor:

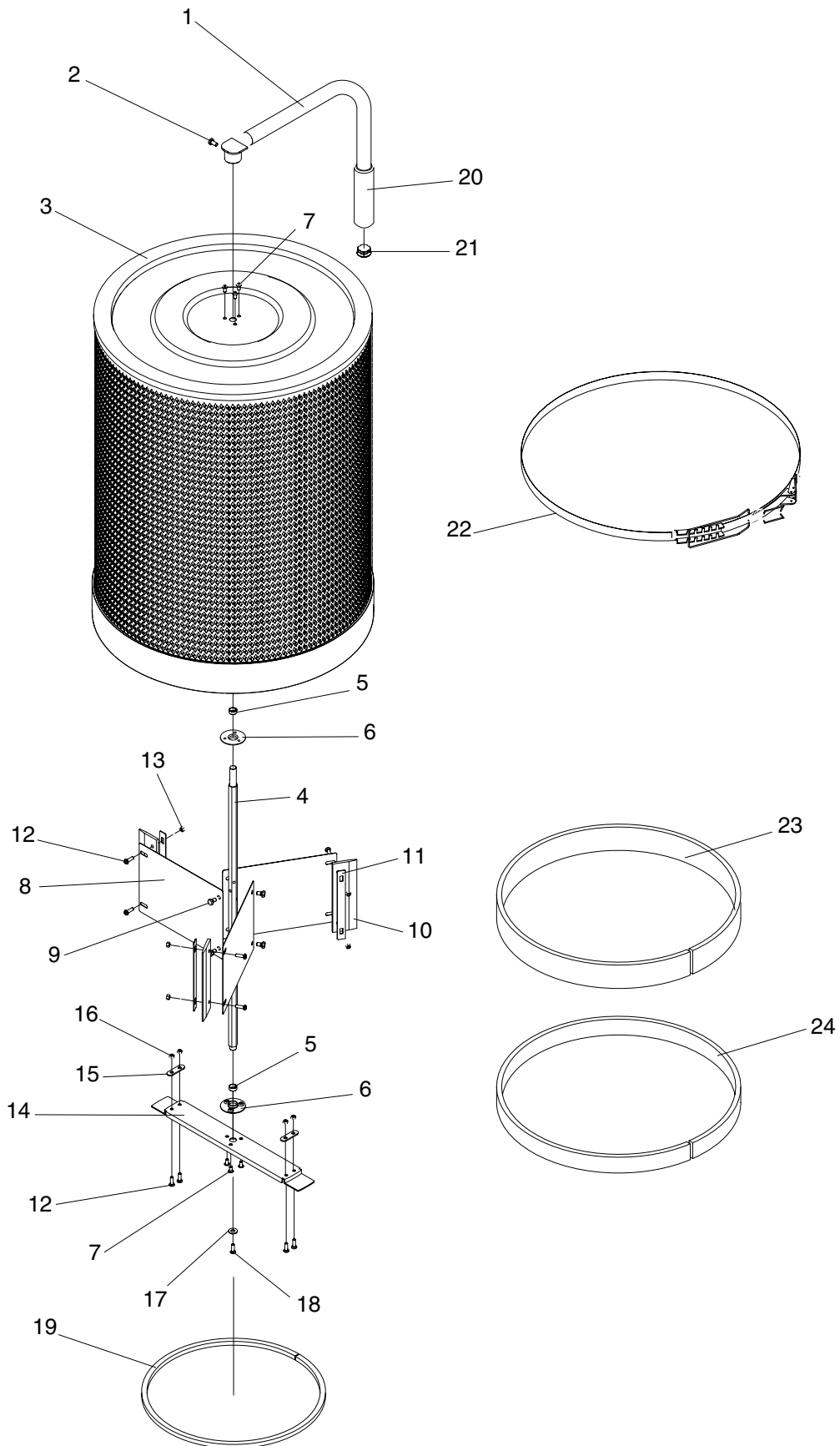
TypeTEFC Capacitor-Start Induction
Horsepower2 HP
Phase / VoltageSingle Phase / 220 V
Amps12A
Cycle/ RPM60 Hertz / 3450 RPM
SwitchOn / Off Push-Button
BearingsSealed & Permanently Lubricated

Specifications, while deemed accurate, are not guaranteed.

G0548 Dust Collector Parts



H5783 Canister Filter Parts



G0548 Parts List

REF	PART #	DESCRIPTION
1	P0548001	CASTERS
2	PFB01	FLANGE BOLT 5/16"-18 X 1/2"
4	P0548004	BASE PLATE
5	PS06	PHLP HD SCR 10-24 X 3/8"
6	P0548006	INLET COVER
7	P1028007	CAP SCREW M6-1 X 19 LH
8	PB09	HEX BOLT 5/16-18 X 1/2
9	P0548009	SPECIAL WASHER
10	P0548010	12" IMPELLER
11	P0548011	COLLECTOR BODY
12	PW07	FLAT WASHER 5/16
13	PS06	PHLP HD SCR 10-24 X 3/8"
14	PFB01	FLANGE BOLT 5/16-18 X 1/2
15	PB03	HEX BOLT 5/16-18 X 1
17	P0548017	MOTOR 2HP
17-1	P0548017-1	MOTOR FAN COVER
17-2	P0548017-2	MOTOR FAN
17-3	P0548017-3	CAPACITOR COVER
17-4	PC400A	S CAPACITOR 400M 125V
17-5	P0548017-5	WIRING BOX
18	PN02	HEX NUT 5/16-18
19	P0548019	METAL "L" OUTLET
21	P0548021	SWITCH
22	H6899	BAG, LOWER PLASTIC
23	P0548023	COLLECTOR SUPPORT
24	P0548024	COLLECTOR
25	P0548025	SPACER
26	PAW05M	HEX WRENCH 5MM
27	H5783	CANISTER FILTER ASSY
28	P0548028	RUBBER GASKET
29	P0548029	6" INLET W/THREE 4" PORTS
29-1	P0548029-1	INLET CAP
30	PK28M	KEY 7 X 7 X 29
31	PWCRD220L	POWER CORD
32	P0548032	WRENCH 12MM
33	PWCRD220S	MOTOR CORD
34	P0548034	METAL BAG CLAMP
35	P0548035	MACHINE ID LABEL
36	PLABEL-12	READ MANUAL LABEL
37	PLABEL-11	SAFETY GLASSES LABEL
38	PLABEL-39	RESPIRATOR LABEL
39	P0548039	NO HAND IN INLET LABEL
40	PLABEL-14	ELECTRICITY LABEL

H5783 Parts List

REF	PART #	DESCRIPTION
1	PH5783001	HANDLE
2	PB83M	HEX BOLT M6-1 X 16
3	PH5783003	CANISTER FILTER
4	PH5783004	HEX SPINDLE
5	PH5783005	THREAD BEARING
6	PH5783006	BEARING PLATE
7	PS09M	PHLP HD SCR M5-.8 X 10
8	PH5783008	FLAP BOARD
9	PB04M	HEX BOLT M6-1 X 10
10	PH5783010	RUBBER FLAP
11	PH5783011	FLAP PLATE
12	PS20M	PHLP HD SCR M5-.8 X 15
13	PLN02M	LOCK NUT M5-.8
14	PH5783014	BOTTOM PLATE
15	PH5783015	SUPPORT TAB
16	PN06M	HEX NUT M5-.8
17	PW06	FLAT WASHER 1/4
18	PS68M	PHLP HD SCR M6-1 X 10
19	PH5783019	SPONGE 10 X 15 MM
20	PH5783020	HANDLE SLEEVE
21	PH5783021	CAP
22	PH5783022	METAL BELT CLAMP
23	PH5783023	FOAM STRIP 6 X 20 MM
24	PH5783024	FOAM STRIP 5 X 42MM

WARRANTY AND RETURNS

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

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

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

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

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

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

WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone Number _____ E-Mail _____ FAX _____
MODEL: _____ **Serial #** _____ **Order** _____

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.

CUT ALONG DOTTED LINE

1. How did you learn about us?

<input type="checkbox"/> Advertisement <input type="checkbox"/> Catalog <input type="checkbox"/> World Wide Web <input type="checkbox"/> Other _____	<input type="checkbox"/> Friend <input type="checkbox"/> Card Deck
---	---
2. Which of the following magazines do you subscribe to.

<input type="checkbox"/> American Woodworker <input type="checkbox"/> Cabinetmaker <input type="checkbox"/> Family Handyman <input type="checkbox"/> Fine Homebuilding <input type="checkbox"/> Fine Woodworking <input type="checkbox"/> Home Handyman <input type="checkbox"/> Journal of Light Construction <input type="checkbox"/> Old House Journal <input type="checkbox"/> Popular Mechanics <input type="checkbox"/> Popular Science <input type="checkbox"/> Popular Woodworking <input type="checkbox"/> Other _____	<input type="checkbox"/> Practical Homeowner <input type="checkbox"/> Shop Notes <input type="checkbox"/> Today's Homeowner <input type="checkbox"/> WOOD <input type="checkbox"/> Wooden Boat <input type="checkbox"/> Woodshop News <input type="checkbox"/> Woodsmith <input type="checkbox"/> Woodwork <input type="checkbox"/> Woodworker <input type="checkbox"/> Woodworker's Journal <input type="checkbox"/> Workbench
--	---
3. Which of the following woodworking/remodeling shows do you watch?

<input type="checkbox"/> Backyard America <input type="checkbox"/> Home Time <input type="checkbox"/> The American Woodworker <input type="checkbox"/> Other _____	<input type="checkbox"/> The New Yankee Workshop <input type="checkbox"/> This Old House <input type="checkbox"/> Woodwright's Shop
---	---
4. What is your annual household income?

<input type="checkbox"/> \$20,000-\$29,999 <input type="checkbox"/> \$30,000-\$39,999 <input type="checkbox"/> \$40,000-\$49,999 <input type="checkbox"/> \$50,000-\$59,999	<input type="checkbox"/> \$60,000-\$69,999 <input type="checkbox"/> \$70,000-\$79,999 <input type="checkbox"/> \$80,000-\$89,999 <input type="checkbox"/> \$90,000 +
--	---
5. 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 +
--	---
6. How long have you been a woodworker?

<input type="checkbox"/> 0 - 2 Years <input type="checkbox"/> 2 - 8 Years	<input type="checkbox"/> 8 - 20 Years <input type="checkbox"/> 20+ Years
--	---
7. How would you rank your woodworking skills?

<input type="checkbox"/> Simple <input type="checkbox"/> Intermediate	<input type="checkbox"/> Advanced <input type="checkbox"/> Master Craftsman
--	--
8. What stationary woodworking tools do you own? Check all that apply.

<input type="checkbox"/> Air Compressor <input type="checkbox"/> Band Saw <input type="checkbox"/> Drill Press <input type="checkbox"/> Drum Sander <input type="checkbox"/> Dust Collector <input type="checkbox"/> Horizontal Boring Machine <input type="checkbox"/> Jointer <input type="checkbox"/> Lathe <input type="checkbox"/> Mortiser	<input type="checkbox"/> Panel Saw <input type="checkbox"/> Planer <input type="checkbox"/> Power Feeder <input type="checkbox"/> Radial Arm Saw <input type="checkbox"/> Shaper <input type="checkbox"/> Spindle Sander <input type="checkbox"/> Table Saw <input type="checkbox"/> Vacuum Veneer Press <input type="checkbox"/> Wide Belt Sander
--	--
9. How many of your woodworking machines are Grizzly? _____
 Other _____
10. Which benchtop tools do you own? Check all that apply.

<input type="checkbox"/> 1" x 42" Belt Sander <input type="checkbox"/> 5" - 8" Drill Press <input type="checkbox"/> 8" Table Saw <input type="checkbox"/> 8" - 10" Bandsaw <input type="checkbox"/> Disc/Belt Sander <input type="checkbox"/> Mini Jointer <input type="checkbox"/> Other _____	<input type="checkbox"/> 6" - 8" Grinder <input type="checkbox"/> Mini Lathe <input type="checkbox"/> 10" - 12" Thickness Planer <input type="checkbox"/> Scroll Saw <input type="checkbox"/> Spindle/Belt Sander
---	---
11. How many of the machines checked above are Grizzly? _____
12. Which portable/hand held power tools do you own? Check all that apply.

13. What machines/supplies would you like Grizzly Industrial to carry?

14. What new accessories would you like Grizzly Industrial to carry?

<input type="checkbox"/> Builders Hardware <input type="checkbox"/> Fasteners <input type="checkbox"/> Other _____	<input type="checkbox"/> Hand Tools <input type="checkbox"/> Wood Components
--	---
15. What other companies do you purchase your tools and supplies from?

16. Do you think your purchase represents good value?
 Yes No
17. Would you recommend Grizzly Industrial to a friend?
 Yes No
18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**
 Yes No
19. Comments: _____

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