



DOWNDRAFT SANDING TABLE

MODEL G0534/G0535

INSTRUCTION MANUAL



COPYRIGHT © OCTOBER, 2003 BY GRIZZLY INDUSTRIAL, INC.

WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.

#5670 REVISED SEPTEMBER, 2004. PRINTED IN TAIWAN

ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE. CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

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.

Table of Contents

SECTION 1: SAFETY	2
Safety Instructions for Power Tools	2
Additional Safety for Downdraft Tables	4
SECTION 2: GENERAL INFORMATION	5
Commentary	5
SECTION 3: CIRCUIT REQUIREMENTS	6
110V Operation	6
220V Operation	7
SECTION 4: MACHINE FEATURES	8
Machine Features	8
SECTION 5: SET UP	9
Unpacking	9
Inventory	9
Hardware Recognition Chart	11
Site Considerations	12
Feet and Casters	13
Filter Box	13
Collection Box	14
Curtains	16
Table Top	17
Filter Drawer	17
SECTION 6: OPERATIONS	18
Operations	18
Emptying Dust	18
SECTION 7: REFERENCE INFO	19
G0534 Data Sheet	20
G0535 Data Sheet	21
G0534 Parts Breakdown and Parts Lists	22
G0535 Parts Breakdown and Parts Lists	24
Warranty and Returns	26

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. Read the manual accompanying the machine thoroughly.

- 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 Downdraft Tables

1. **THIS DOWNDRAFT TABLE IS TO BE USED FOR WOOD DUST COLLECTION ONLY.** DO NOT use this machine to filter or collect liquids (especially flammables), metal shavings, lead paint, or asbestos. DO NOT use this machine to dissipate smoke or fumes.
2. **UNPLUG MACHINE BEFORE REMOVING FILTER.** Removing filter exposes the impeller, which may cause serious injury during contact if the machine is connected to the power source.
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 this machine 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 or open flames.
5. **AVOID COLLECTING ANY MATERIAL THAT IS BURNING OR SMOKING,** this includes matches, cigarettes, and hot ashes.
6. **ALWAYS OPERATE THE MACHINE WITH THE FILTER IN PLACE.** When the filter is removed, the impeller is exposed both from the filter opening and the intake ports.
7. **WHEN EMPTYING DUST FROM THE COLLECTION BAGS,** wear a respirator and safety glasses. Empty dust into an approved container and dispose of properly.
8. **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.
9. **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 ANSI approved respirator!
10. **THIS MACHINE WILL NOT PROTECT AGAINST LEAD-PAINT DUST OR ASBESTOS FIBERS.** These materials must be collected with special equipment because of the high hazard to human health. DO NOT attempt to collect these materials with this machine.

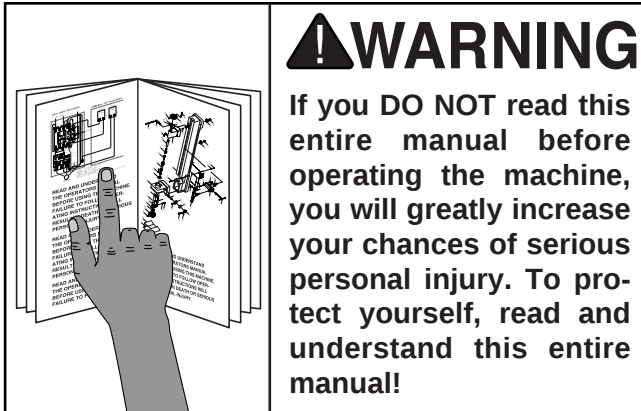
WARNING

Like all machines there is danger associated with the Model G0534/G0535. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility 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: GENERAL INFORMATION



Commentary

Grizzly Industrial, Inc. is proud to offer the Model G0534/G0535 Downdraft Tables. This downdraft table is part of Grizzly's growing family of fine woodworking machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

We are also pleased to provide this manual for the Model G0534/G0535. 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 G0534/G0535 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

110V Operation

WARNING

Serious personal injury could occur if you connect your machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Wiring

Both Models G0534 and G0535 are prewired for 110V operation (see **Figure 1**).

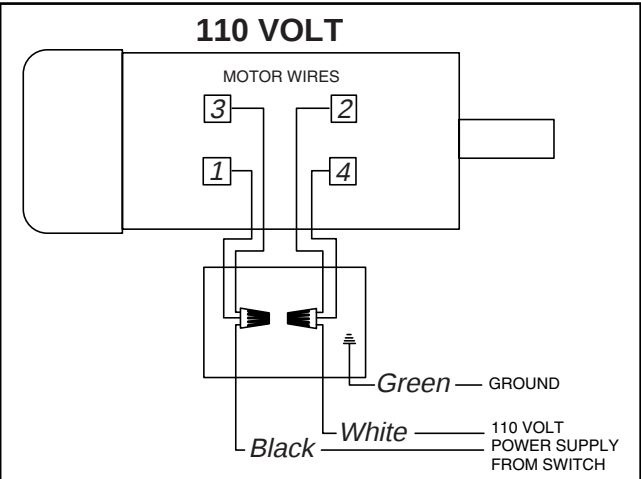


Figure 1. G0534/G0535 110V Wiring Diagram.

Amperage Draw

The machines draw the following amps:

G0534	10 Amps
G0535	14 Amps

Circuit Breaker Requirements

Install your machine on a dedicated circuit to reduce the possibility of tripping the circuit breaker. If the circuit breaker frequently trips, have the circuit inspected by a qualified electrician. Never use a larger circuit breaker than stated below, or you will increase the risk of fire.

Circuit Breaker15 Amp, 1 Pole

Plug Type

Both Models G0534 and G0535 are supplied with a 5-15 plug, similar to **Figure 2**.

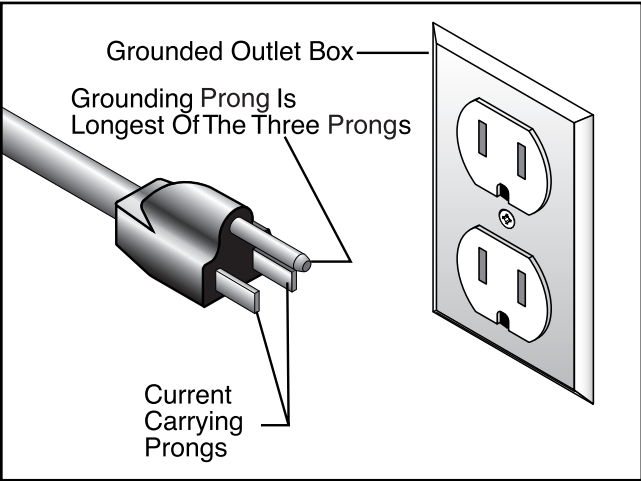


Figure 2. Typical type 5-15 plug and receptacle.

Your Shop Circuit Capacity

Always check to see if your circuit is 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.

Grounding

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 a plug with an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.

CAUTION

A fire may occur if your particular electrical configuration does not comply with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician.



220V Operation

⚠ WARNING

Serious personal injury could occur if you connect your machine to the power source before you have completed the setup process. **DO NOT** connect the machine to the power source until instructed to do so.

Wiring

The Model G0534/G0535 is prewired for 110V operation, but can be rewired to 220V. To rewire for single-phase 220V, the plugs must be changed and the motor must be rewired. When rewiring, refer to the wiring diagram in **Figure 3**.

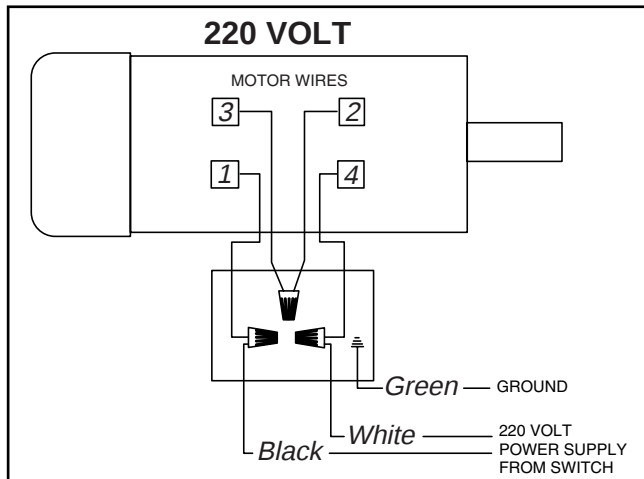


Figure 3. G0534/G0535 220V Wiring Diagram.

Amperage Draw

The motor for your machine draws the following amps at 220V:

G0534	5 Amps
G0535	7 Amps

⚠ CAUTION

A fire may occur if your particular electrical configuration does not comply with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician.

Circuit Breaker Requirements

Install your machine on a dedicated circuit to reduce the possibility of overloading the circuit and tripping the circuit breaker. If the circuit breaker trips and the circuit is of the correct load capacity, have the circuit inspected by a qualified electrician. Never use a larger circuit breaker than stated below, or you will increase the risk of fire.

Circuit Breaker10 Amp, 2 Pole

Plug Type

For 220V operation, this machine requires a NEMA 6-15 plug and receptacle, as shown in **Figure 4**.

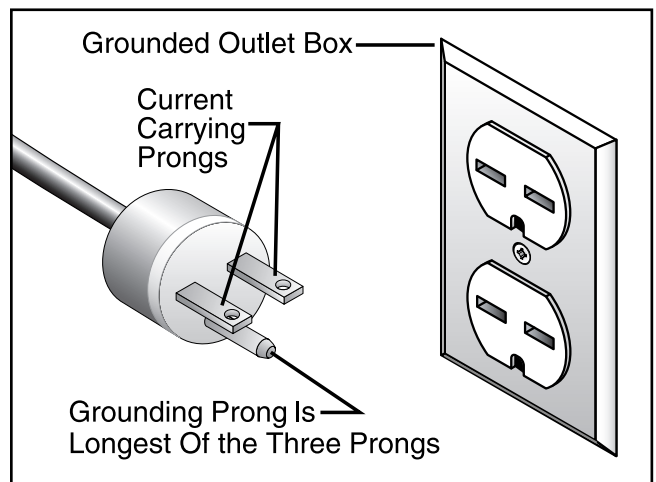


Figure 4. Typical type 6-15 plug and receptacle.

Your Shop Circuit Capacity

Always check to see if your circuit is 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.

Grounding

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 a plug with an equipment-grounding prong. The outlet must be properly installed and grounded in accordance with all local codes and ordinances.



SECTION 4: MACHINE FEATURES



Figure 5. Main view of machine features.

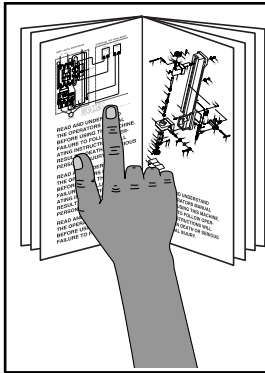
Machine Features

1. **Sanding Table**—Features both regular and rubber inlet ports to provide great dust collection and a non-marring surface for delicate workpieces.
2. **Filter Drawer**—Slides out for easy clean-up of collected dust.
3. **ON/OFF Switch**—Starts and stops the motor. *Not a replacement for unplugging machine during maintenance.*

4. **Stand Mounted Casters**—Allow the user to move the machine where best needed in the shop, without having to purchase an additional mobile base.
5. **Dust Curtains**—Improve the dust collection, especially when sanding long workpieces.

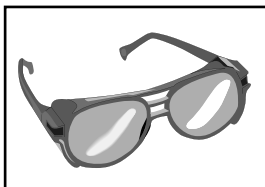


SECTION 5: SET UP



!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!

Unpacking

Your machine left our warehouse in a carefully packed crate or box. 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

Please refer to **Figures 6–9** and the list in this subsection to inventory your equipment. In the event that any non-proprietary parts are missing (e.g. nuts or washers), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

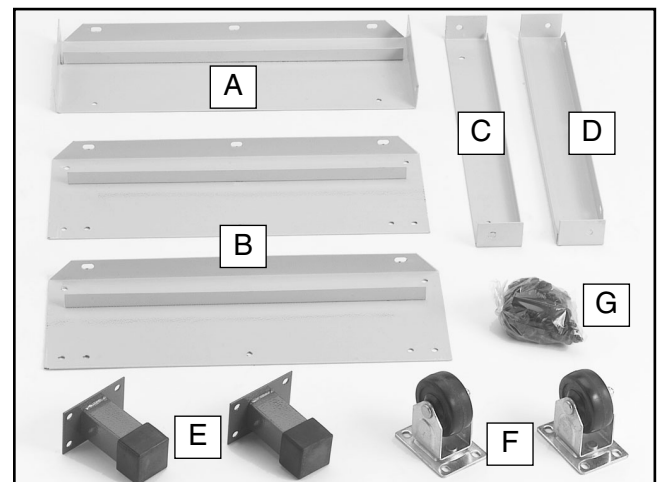


Figure 7. Filter box walls, motor cabinet feet/casters, and hardware bag.

A.	Rear Filter Wall	1
B.	Side Filter Walls	2
C.	Upper Front Filter Wall.....	1
D.	Lower Front Filter Wall.....	1
E.	Cabinet Feet	2
F.	Casters	2
G.	Hardware Bag (Model G0534)	
	—Hex Bolts 1/4"-20 x 5/8"	72
	—Flat Washers 1/4"	138
	—Hex Nuts 1/4"-20	66
	—Flat Head Screws 1/4"-20 x 7/8"	6
G.	Hardware Bag (Model G0535)	
	—Hex Bolts 1/4"-20 x 5/8"	76
	—Flat Washers 1/4"	146
	—Hex Nuts 1/4"-20	70
	—Flat Head Screws 1/4"-20 x 7/8"	6



Figure 6. Motor Cabinet.

H. Motor Cabinet

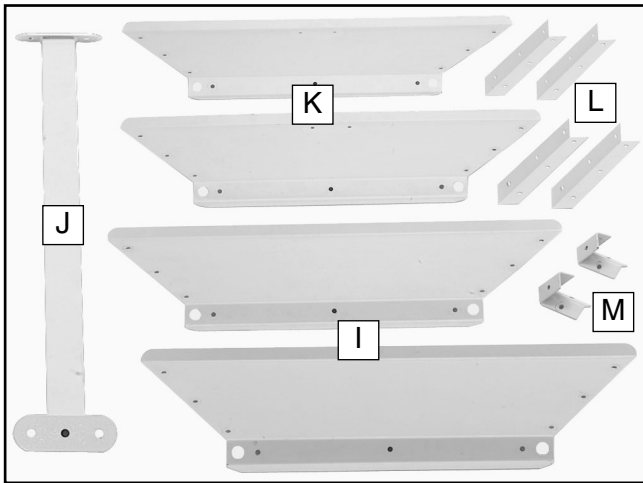


Figure 8. Collection box components and curtain brackets.

I.	Side Skewed Walls	2
J.	Brace (<i>Model G0535 Only</i>)	1
K.	Front/Rear Skewed Walls	2
L.	Angle Brackets	4
M.	Curtain Brackets	2

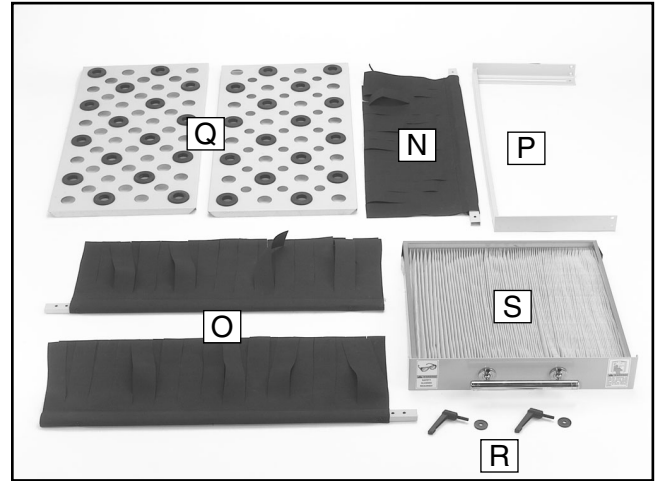


Figure 9. Table tops, dust drawer, and curtain components.

N.	Rear Curtain w/Rod	1
O.	Side Curtains w/Rods	2
P.	Curtain Frame	1
Q.	Table Top (<i>G0534-not shown</i>)	1
Q.	Table Tops (<i>G0535</i>)	1
R.	Lock Handles w/Washers	2
S.	Filter Drawer	1
T.	Switch Padlock (<i>not shown</i>)	1



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

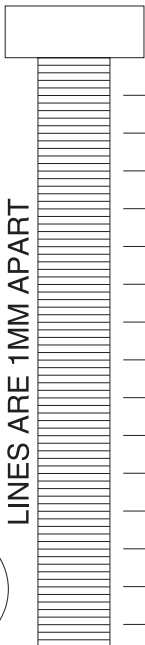
8mm

10mm

12mm

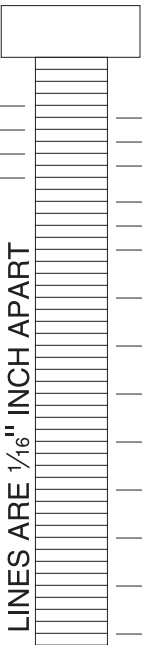
16mm

LINES ARE 1MM APART

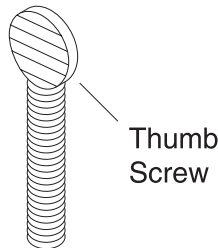


5mm
10mm
15mm
20mm
25mm
30mm
35mm
40mm
45mm
50mm
55mm
60mm
65mm
70mm
75mm

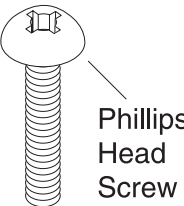
LINES ARE 1/16" INCH APART



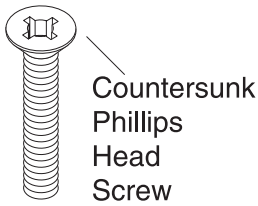
1/4"
3/8"
1/2"
5/8"
5/16"
7/16"
9/16"
3/4"
7/8"
1"
1 1/4"
1 1/2"
1 3/4"
2
2 1/4"
2 1/2"
2 3/4"
3



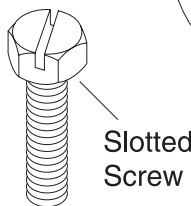
Thumb
Screw



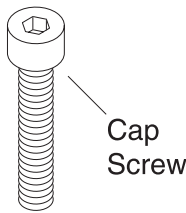
Phillips
Head
Screw



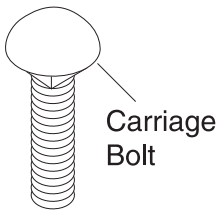
Countersunk
Phillips
Head
Screw



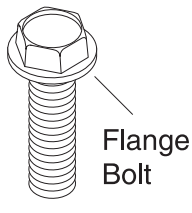
Slotted
Screw



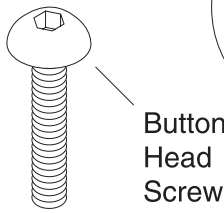
Cap
Screw



Carriage
Bolt



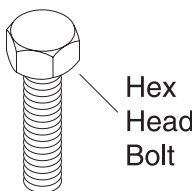
Flange
Bolt



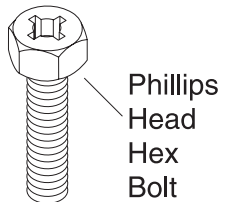
Button
Head
Screw



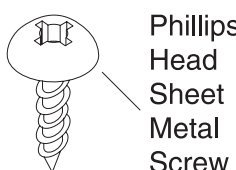
Setscrew



Hex
Head
Bolt



Phillips
Head
Hex
Bolt



Phillips
Head
Sheet
Metal
Screw



Washer



Lock
Washer

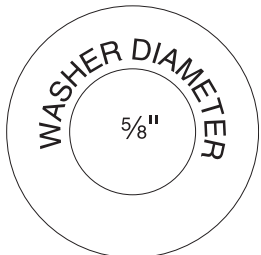


Hex
Nut

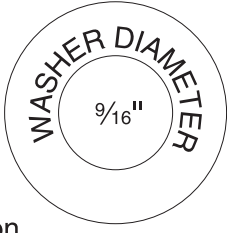
Lock
Nut



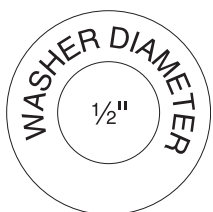
Wing
Nut



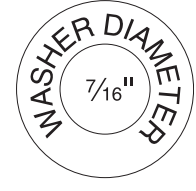
WASHER DIAMETER
5/8"



WASHER DIAMETER
9/16"



WASHER DIAMETER
1/2"



WASHER DIAMETER
7/16"



WASHER DIAMETER
3/8"



WASHER DIAMETER
5/16"

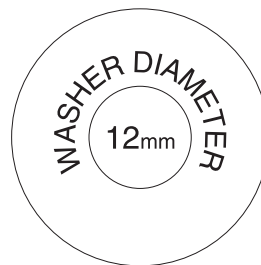


WASHER DIAMETER
1/4"

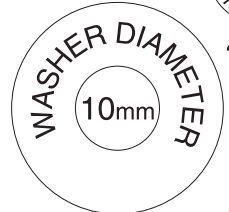


WASHER DIAMETER
#10

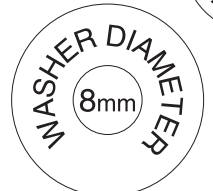
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



WASHER DIAMETER
12mm



WASHER DIAMETER
10mm



WASHER DIAMETER
8mm



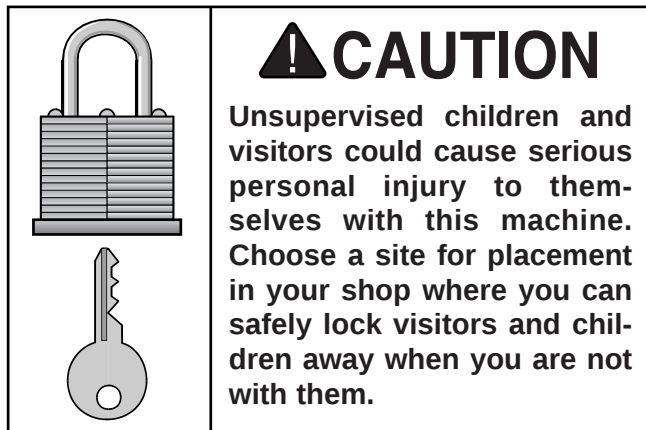
WASHER DIAMETER
4mm



WASHER DIAMETER
6mm

#10

Site Considerations



Floor Load

The Model G0534 weighs 106 lbs. and has a base footprint of 13" x 13". The Model G0535 weighs 154 lbs. and has a base footprint of 19½" x 19½".

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 your machine. See **Figure 10** for the minimum working clearances of the Model G0534/G0535.

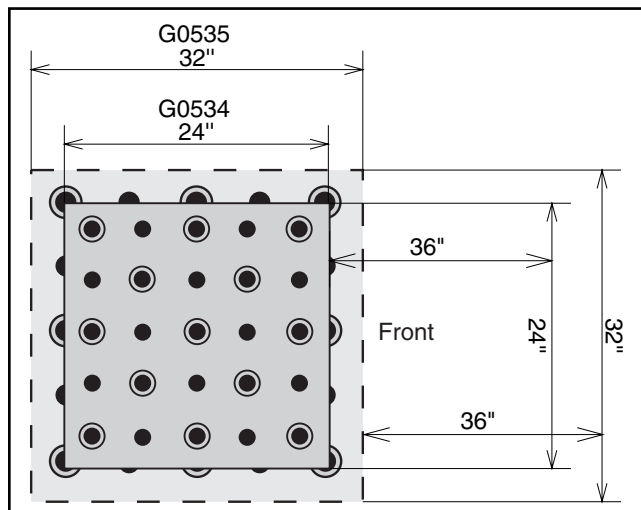


Figure 10. Minimum working clearances.



Feet and Casters

Components and Hardware Needed:	Qty
Motor Cabinet	1
Cabinet Feet	2
Casters	2
Hex Bolts 1/4"-20 x 5/8"	16
Flat Washers 1/4"	32
Hex Nuts 1/4"	16

Tools Needed:	
10mm Wrench or Socket.....	2

To mount the feet and casters:

1. Lay the motor cabinet on its back.
2. Attach both cabinet feet to the bottom front of the motor cabinet with 8 hex bolts, 16 flat washers and 8 hex nuts.
3. Attach both casters to the bottom rear of the motor cabinet with 8 hex bolts, 16 flat washers and 8 hex nuts. (See assembly in **Figure 11.**)



Figure 11. Casters and feet installed on motor cabinet.

4. Turn the motor cabinet to its upright position on the feet and casters.



Filter Box

Components and Hardware Needed:	Qty
Rear Filter Wall	1
Side Filter Walls	2
Lower Front Filter Wall	1
Hex Bolts 1/4"-20 x 5/8"	16
Flat Washers 1/4"	20
Hex Nuts 1/4"	4

Tools Needed:	
10mm Wrench or Socket.....	2

To assemble the filter box:

1. Attach the rear filter wall to the base with 3 hex bolts and 3 flat washers (see **Figure 12.**)

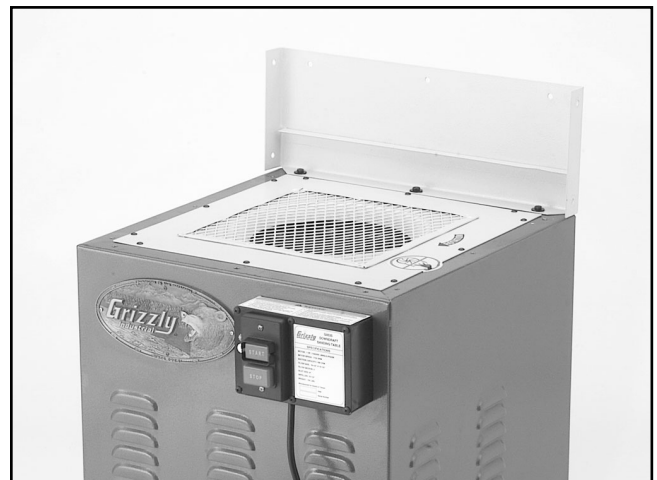


Figure 12. Rear filter wall installed on motor cabinet.

2. Attach both side filter walls to the base with 6 hex bolts and 6 flat washers.

- Secure both lower corners of the side filter walls to the rear filter wall with 2 hex bolts, 4 flat washers, and 2 hex nuts (**Figure 13**).



Figure 13. Side and rear filter walls installed on motor cabinet.

- Attach the lower front filter wall to the front of the base and both side walls with 5 hex bolts, 7 flat washers, and 2 hex nuts (**Figure 14**).



Figure 14. Lower front filter wall secured to motor cabinet and side walls.



Collection Box

Components and Hardware Needed:	Qty
Side Skewed Walls	2
Brace (G0535 Only)	1
Front/Rear Skewed Walls (w/2 holes at top).....	2
Upper Front Filter Wall	1
Angle Brackets	4
Hex Bolts 1/4"-20 x 5/8"	36 (G0535-40)
Flat Washers 1/4"	72 (G0535-80)
Hex Nuts 1/4"	36 (G0535-40)

Tools Needed:	
10mm Wrench or Socket.....	2

To assemble the collection box:

- Attach one of the side skewed walls to one of the front/rear skewed walls by placing an angle bracket over the holes and securing the bottom two holes together with 4 hex bolts, 8 flat washers, and 4 hex nuts, as shown in **Figure 15**. Note—*DO NOT* secure the top holes of the angle brackets, because they will be used later.

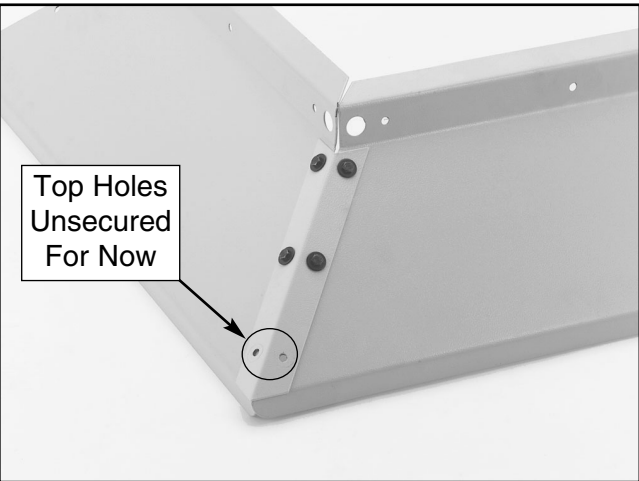


Figure 15. Side skewed wall partially attached to the rear skewed wall with an angle bracket.

2. Using the other 3 angle brackets, attach the remaining side skewed wall and front/rear skewed wall with 12 hex bolts, 24 flat washers, and 12 hex nuts. Your completed assembly should look like **Figure 16**.



Figure 16. Partially assembled collection box—all skewed walls and angle brackets installed.

3. If you have the Model G0535, attach the brace to the front and rear walls with 4 hex bolts, 8 flat washers, and 4 hex nuts (see **Figure 17**). Note—If you have the Model G0534, skip this step.



Figure 17. Brace installed on Model G0535.

4. Attach the upper front filter wall to the front skewed wall with 3 hex bolts, 6 flat washers, and 3 hex nuts.
5. Place the collection box on top of the filter box and align the holes.
6. Secure the collection box to the filter box with 13 hex bolts, 26 flat washers, and 13 hex nuts, (see **Figure 18**).



Figure 18. Collection box installed on motor cabinet.

7. At the front corners of the collection box, secure the top holes of the angle brackets with 4 hex bolts, 8 flat washers, and 4 hex nuts.



Curtains

Components and Hardware Needed:		Qty
Rear Curtain Rod		1
Side Curtain Rods		2
Curtain Brackets		2
Curtain Frame		1
Lock Handles w/Washers		2
Hex Bolts 1/4"-20 x 5/8"		4
Flat Washers 1/4"		14
Hex Nuts 1/4"		10
Flat Head Screws 1/4"-20 x 7/8"		6

Tools Needed:

10mm Wrench or Socket.....	2
----------------------------	---

To assemble the curtains:

1. At the rear corners of the collection box, install both curtain brackets over the top holes of the angle brackets with 4 hex bolts, 8 flat washers, 4 hex nuts (see **Figure 19**).



Figure 19. Curtain brackets installed over angle brackets.

2. Attach the curtain frame on the curtain brackets with both lock handles w/washers (**Figure 20**).



Figure 20. Curtain frame installed on curtain brackets.

3. Install the rear curtain rod to the curtain frame with 2 flat head screws, 2 flat washers, and 2 hex nuts.
4. Attach both side curtain rods to the curtain frame with 4 flat head screws, 4 flat washers, and 4 hex nuts (**Figure 21**).



Figure 21. Curtains installed on curtain frame.



Table Top

Components and Hardware Needed:		Qty
Table Top (G0534)		1
Table Tops (G0535)		2

Tools Needed:
None

To install the table top:

Fit the table top(s) into the top of the collection box, so that your final assembly resembles **Figure 22**.

NOTICE

The table top(s) are designed to fit tightly into the collection box. Some assembly situations may require loosening the collection box fasteners to allow the table top(s) to fit.



Figure 22. Table top(s) installed on collection box.



Filter Drawer

Components and Hardware Needed:		Qty
Filter Drawer		1

Tools Needed:
None

To install the filter:

Slide the filter drawer into the filter box as shown in **Figure 23**.



Figure 23. Sliding filter drawer into filter box.

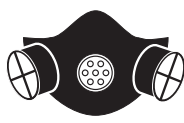


SECTION 6: OPERATIONS

Operations

WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



The Model G0534/G0535 is operated by a push button switch that is clearly labeled START/STOP.

This switch can be locked out with the switch padlock, as shown in **Figure 24**, when the downdraft table is not in use.

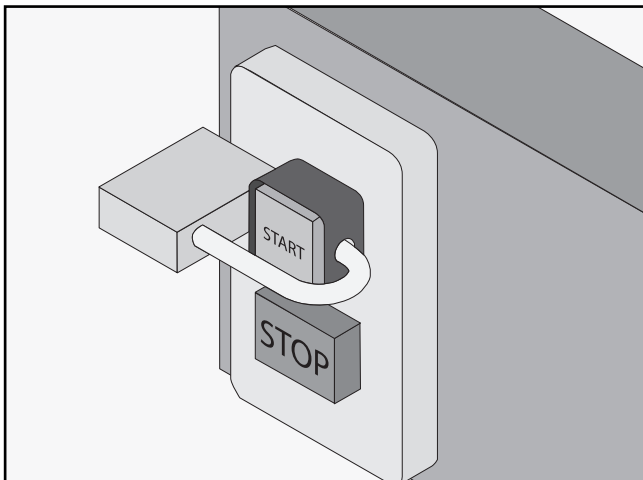
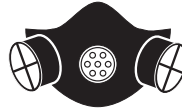


Figure 24. ON/OFF Switch locked out to prevent accidental operation.



Emptying Dust

WARNING



RESPIRATORY HAZARD!
Always wear a respirator approved for wood dust while emptying the dust drawer on this machine.

The dust filter is a pleated-type filter and is permanently attached to the drawer. Frequently monitor the dust build-up on the filter and empty the dust drawer before it reaches the top edge of the dust drawer shown in **Figure 25**.

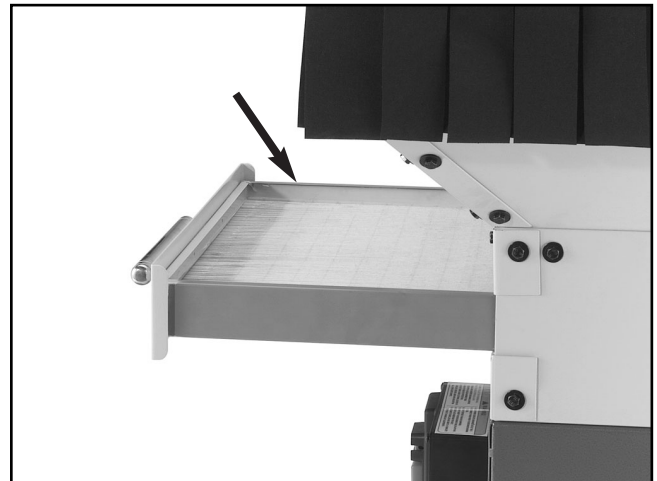


Figure 25. Top edge of dust drawer.

NOTICE

Any dust that rises over the top of the filter drawer will be pulled into the motor compartment when the filter drawer is removed for cleaning. For best results, empty the filter drawer **BEFORE** the dust levels build-up this high.



SECTION 7: REFERENCE INFO

The following pages contain the machine data sheets, parts diagrams, parts lists, and the Warranty/Return information for the Model G0534/G0535.

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 G0534 DOWNDRAFT SANDING TABLE

Design Type..... Floor Model

Overall Dimensions:

Table Height41½"
Table Size24"D x 24"W
Shipping Weight (2 Boxes)115 lbs.
Net Machine Weight.....106 lbs.
Box 1 Size25½"W x 18½"D x 19"H
Box 2 Size26"W x 26"D x 6½"H
Footprint13"W x 13"D

Construction:

Main TablePre-Formed Steel
CabinetPre-Formed Steel
Side Wall.....Canvas
Filter.....Pleated Fabric
ImpellerAluminum
BearingsShielded & Permanently Lubricated

Capacities:

Air Delivery.....600 CFM
Filter Area15½" x 15½"
Filtration Capacity5 Microns
Filter EfficiencyAFI 97%
Impeller Size9"
Inlet Hole8"
Rubber Inserts1⅞" Hole x 18 pcs

Motor:

TypeTEFC Capacitor Start Induction
Horsepower½ HP
Phase/CycleSingle-Phase/60 Hz
Voltage110/220V
Prewired Voltage110V
Amps10/5A
RPM.....1725 RPM
Power TransferDirect Drive
Power Switch.....On/Off Push Button

*Specifications, while deemed accurate, are not guaranteed.
August, 2003*



MACHINE DATA SHEET

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

MODEL G0535 DOWNDRAFT SANDING TABLE

Design Type..... Floor Model

Overall Dimensions:

Table Height44½"
Table Size31⅝"D x 31⅝"W
Shipping Weight (2 Boxes)165 lbs.
Net Machine Weight.....154 lbs.
Box 1 Size26¹³/₃₂"W x 22¹³/₁₆"D x 21²³/₃₂"H
Box 2 Size34¼"W x 22¹³/₁₆"D x 6½"H
Footprint17"W x 16"D

Construction:

Main TablePre-Formed Steel
CabinetPre-Formed Steel
Side Wall.....Canvas
Filter.....Pleated Fabric
ImpellerAluminum
BearingsShielded & Permanently Lubricated

Capacities:

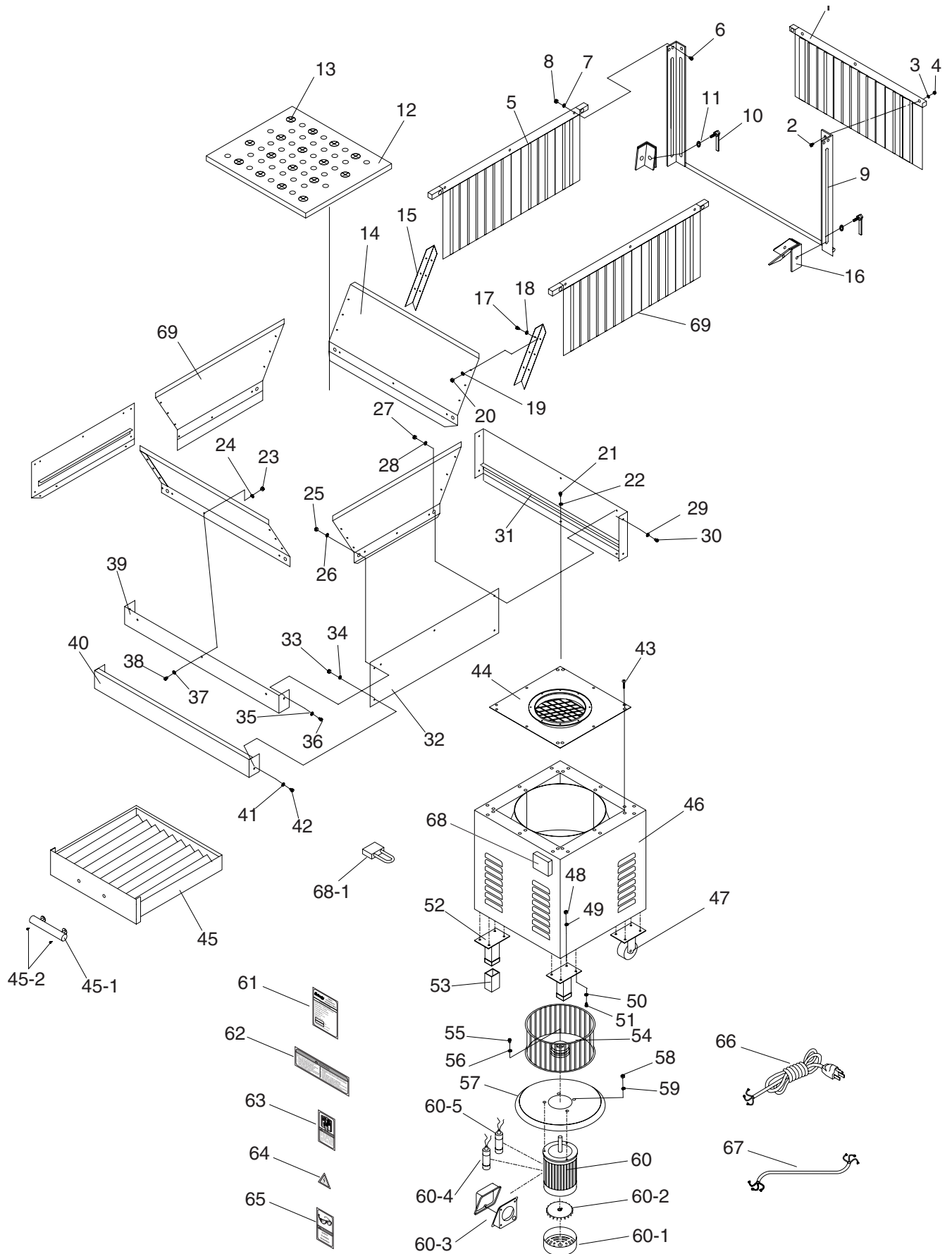
Air Delivery.....780 CFM
Filter Area.....19½" x 19½"
Filtration Capacity5 Microns
Filter EfficiencyAFI 97%
Impeller Size.....10½"
Inlet Hole9"
Rubber Inserts.....1⅛" Hole x 32 pcs

Motor:

TypeTEFC Capacitor Start Induction
Horsepower1 HP
Phase/CycleSingle-Phase/60 Hz
Voltage110/220V
Prewired Voltage110V
Amps14/7A
RPM1725 RPM
Power TransferDirect Drive
Power Switch.....On/Off Push Button

*Specifications, while deemed accurate, are not guaranteed.
August, 2003*

G0534

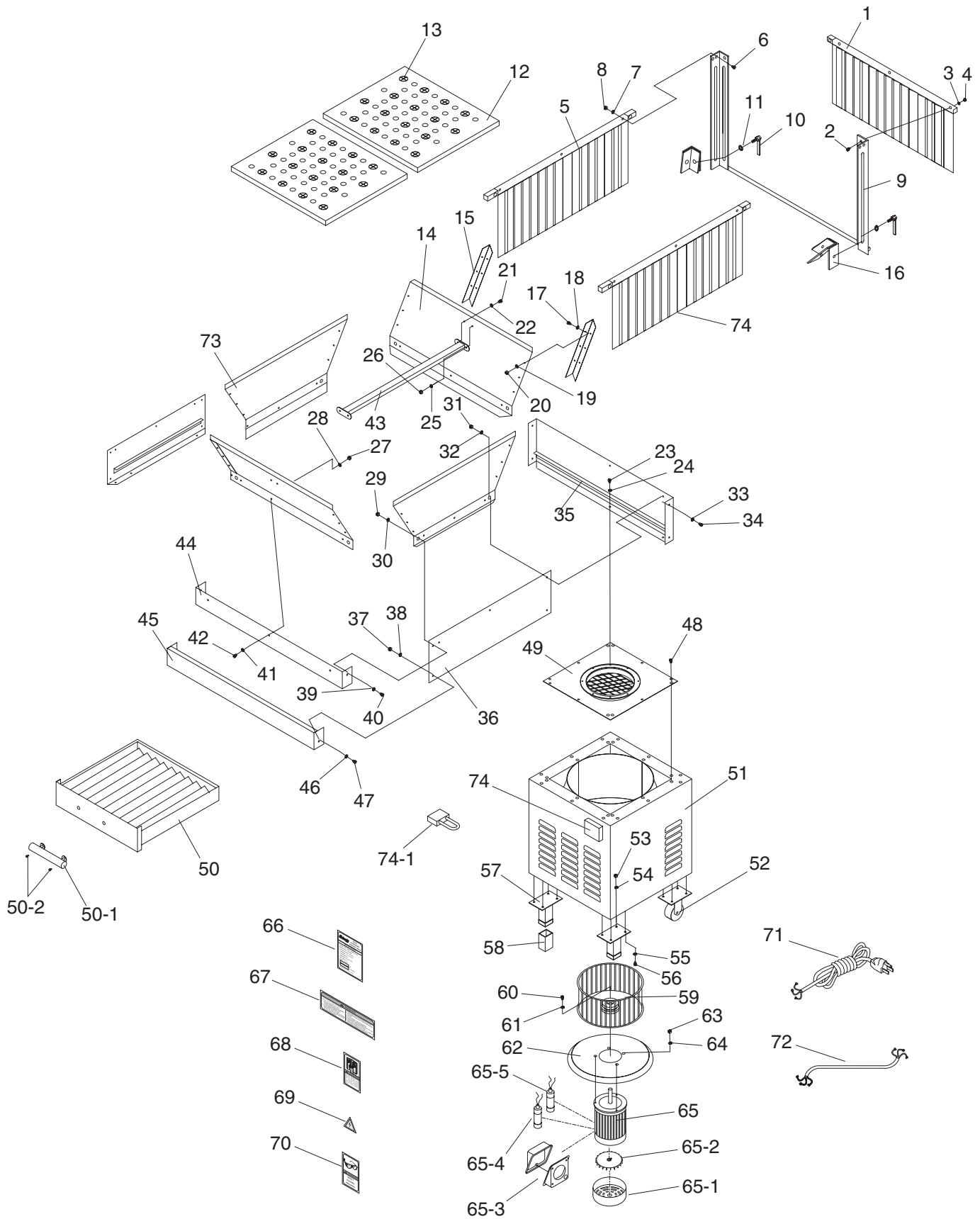


G0534

REF	PART #	DESCRIPTION
1	P0534001	REAR CURTAIN
2	P0534002	FLAT HD SCR 1/4-20 X 7/8
3	PW06	FLAT WASHER 1/4
4	PN05	HEX NUT 1/4-20
5	P0534005	SIDE CURTAIN
6	P0534002	FLAT HD SCR 1/4-20 X 7/8
7	PW06	FLAT WASHER 1/4
8	PN05	HEX NUT 1/4-20
9	P0534009	CURTAIN FRAME
10	P0534010	LOCK HANDLE 5/16-18 X 1
11	PW07	FLAT WASHER 5/16
12	P0534012	TABLE BOARD
13	P0534013	RUBBER GROMMET
14	P0534014	FRONT/REAR SKEWED WALL
15	P0534015	ANGLE BRACKET
16	P0534016	CURTAIN BRACKET
17	PB02	HEX BOLT 1/4-20 X 5/8
18	PW06	FLAT WASHER 1/4
19	PW06	FLAT WASHER 1/4
20	PN05	HEX NUT 1/4-20
21	PB02	HEX BOLT 1/4-20 X 5/8
22	PW06	FLAT WASHER 1/4
23	PN05	HEX NUT 1/4-20
24	PW06	FLAT WASHER 1/4
25	PN05	HEX NUT 1/4-20
26	PW06	FLAT WASHER 1/4
27	PN05	HEX NUT 1/4-20
28	PW06	FLAT WASHER 1/4
29	PW06	FLAT WASHER 1/4
30	PB02	HEX BOLT 1/4-20 X 5/8
31	P0534031	REAR FILTER WALL
32	P0534032	SIDE FILTER WALL
33	PN05	HEX NUT 1/4-20
34	PW06	FLAT WASHER 1/4
35	PW06	FLAT WASHER 1/4
36	PB02	HEX BOLT 1/4-20 X 5/8
37	PW06	FLAT WASHER 1/4
38	PB02	HEX BOLT 1/4-20 X 5/8
39	P0534039	UPPER FRONT FILTER WALL

REF	PART #	DESCRIPTION
40	P0534040	LOWER FRONT FILTER WALL
41	PW06	FLAT WASHER 1/4
42	PB02	HEX BOLT 1/4-20 X 5/8
43	PS01	PHLP HD SCR 10-24 X 1/2
44	P0534044	SAFETY NET
45	P0534045	FILTER DRAWER
45-1	P0534045-1	DRAWER HANDLE
45-2	PHTEK10	TAP SCREW #8 X 5/8
46	P0534046	MOTOR CABINET
47	P0534047	CASTER
48	PN05	HEX NUT 1/4-20
49	PW06	FLAT WASHER 1/4
50	PW06	FLAT WASHER 1/4
51	PB02	HEX BOLT 1/4-20 X 5/8
52	P0534052	CABINET FOOT
53	P0534053	FOOT BOOT
54	P0534054	FAN
55	PB07	HEX BOLT 5/16-18 X 3/4
56	PW06	FLAT WASHER 1/4
57	P0534057	DEFLECTOR
58	PN05	HEX NUT 1/4-20
59	PW06	FLAT WASHER 1/4
60	P0534060	COMPLETE MOTOR 1/2 HP
60-1	P0534060-1	FAN COVER
60-2	P0534060-2	MOTOR FAN
60-3	P0534060-3	WIRING BOX
60-4	P0534060-4	S CAPACITOR 200M 125V SM
60-5	P0534060-5	R CAPACITOR 30M 250V SM
61	P0534061	G0534 MACHINE ID LABEL
62	P0534062	DOWNDRAFT WARNING LBL
63	PLABEL-12	READ MANUAL LABEL
64	PLABEL-14	ELECTRICITY LABEL
65	PLABEL-11	SAFETY GLASSES LABEL
66	PWRCRD110L	110V CORD W/5-15 PLUG
67	PWRCRD110S	110V MOTOR CORD
68	P0534068	PUSH BUTTON SWITCH
68-1	P0534068-1	SWITCH PADLOCK
69	P0534069	SIDE SKEWED WALL

G0535



G0535 Parts List

REF	PART #	DESCRIPTION
1	P0535001	REAR CURTAIN
2	P0534002	FLAT HD SCR 1/4-20 X 7/8
3	PW06	FLAT WASHER 1/4
4	PN05	HEX NUT 1/4-20
5	P0535005	SIDE CURTAIN
6	P0534002	FLAT HD SCR 1/4-20 X 7/8
7	PW06	FLAT WASHER 1/4
8	PN05	HEX NUT 1/4-20
9	P0535009	CURTAIN FRAME
10	P0534010	LOCK HANDLE 5/16-18 X 1
11	PW07	FLAT WASHER 5/16
12	P0535012	TABLE BOARD
13	P0534013	RUBBER GROMMET
14	P0535014	FRONT/REAR SKEWED WALL
15	P0535015	ANGLE BRACKET
16	P0535016	CURTAIN BRACKET
17	PB02	HEX BOLT 1/4-20 X 5/8
18	PW06	FLAT WASHER 1/4
19	PW06	FLAT WASHER 1/4
20	PN05	HEX NUT 1/4-20
21	PB02	HEX BOLT 1/4-20 X 5/8
22	PW06	FLAT WASHER 1/4
23	PB02	HEX BOLT 1/4-20 X 5/8
24	PW06	FLAT WASHER 1/4
25	PW06	FLAT WASHER 1/4
26	PN05	HEX NUT 1/4-20
27	PN05	HEX NUT 1/4-20
28	PW06	FLAT WASHER 1/4
29	PN05	HEX NUT 1/4-20
30	PW06	FLAT WASHER 1/4
31	PN05	HEX NUT 1/4-20
32	PW06	FLAT WASHER 1/4
33	PW06	FLAT WASHER 1/4
34	PB02	HEX BOLT 1/4-20 X 5/8
35	P0535035	REAR FILTER WALL
36	P0535036	SIDE FILTER WALL
37	PN05	HEX NUT 1/4-20
38	PW06	FLAT WASHER 1/4
39	PW06	FLAT WASHER 1/4
40	PB02	HEX BOLT 1/4-20 X 5/8
41	PW06	FLAT WASHER 1/4

REF	PART #	DESCRIPTION
42	PB02	HEX BOLT 1/4-20 X 5/8
43	P0535043	BRACE
44	P0535044	UPPER FRONT FILTER WALL
45	P0535045	LOWER FRONT FILTER WALL
46	PW06	FLAT WASHER 1/4
47	PB02	HEX BOLT 1/4-20 X 5/8
48	PS01	PHLP HD SCR 10-24 X 1/2
49	P0535049	SAFETY NET
50	P0535050	FILTER DRAWER
50-1	P0534045-1	DRAWER HANDLE
50-2	PHTEK10	TAP SCREW #8 X 5/8"
51	P0535051	MOTOR CABINET
52	P0535052	CASTER
53	PN05	HEX NUT 1/4-20
54	PW06	FLAT WASHER 1/4
55	PW06	FLAT WASHER 1/4
56	PB02	HEX BOLT 1/4-20 X 5/8
57	P0534057	CABINET FOOT
58	P0534058	FOOT BOOT
59	P0535059	FAN
60	PB07	HEX BOLT 5/16-18 X 3/4
61	PW07	FLAT WASHER 5/16
62	P0535062	DEFLECTOR
63	PN05	HEX NUT 1/4-20
64	PW06	FLAT WASHER 1/4
65	P0535065	MOTOR
65-1	P0535065-1	FAN COVER
65-2	P0535065-2	MOTOR FAN
65-3	P0535060-3	WIRING BOX
65-4	P0534060-4	S CAPACITOR 200M 125V SM
65-5	P0534060-5	R CAPACITOR 30M 250V SM
66	P0535066	G0535 MACHINE ID LABEL
67	P0534062	DOWNDRAFT WARNING LBL
68	PLABEL-12	READ MANUAL LABEL
69	PLABEL-14	ELECTRICITY LABEL
70	PLABEL-11	SAFETY GLASSES LABEL
71	PWRCRD110L	110V CORD W/5-15 PLUG
72	PWRCRD110S	110 MOTOR CORD
73	P0534068	SIDE SKEWED WALL
74	P0535074	PUSH BUTTON SWITCH
74-1	P0535074-1	SWITCH PADLOCK

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.

1. How did you learn about us?
____ Advertisement _____ Friend
____ Catalog _____ Card Deck
____ World Wide Web
____ Other _____
2. Which of the following magazines do you subscribe to.
____ American Woodworker _____ Practical Homeowner
____ Cabinetmaker _____ Shop Notes
____ Family Handyman _____ Today's Homeowner
____ Fine Homebuilding _____ WOOD
____ Fine Woodworking _____ Wooden Boat
____ Home Handyman _____ Woodshop News
____ Journal of Light Construction _____ Woodsmith
____ Old House Journal _____ Woodwork
____ Popular Mechanics _____ Woodworker
____ Popular Science _____ Woodworker's Journal
____ Popular Woodworking _____ Workbench
____ Other _____
3. Which of the following woodworking/remodeling shows do you watch?
____ Backyard America _____ The New Yankee Workshop
____ Home Time _____ This Old House
____ The American Woodworker _____ Woodwright's Shop
____ Other _____
4. What is your annual household income?
____ \$20,000-\$29,999 _____ \$60,000-\$69,999
____ \$30,000-\$39,999 _____ \$70,000-\$79,999
____ \$40,000-\$49,999 _____ \$80,000-\$89,999
____ \$50,000-\$59,999 _____ \$90,000 +
5. What is your age group?
____ 20-29 _____ 50-59
____ 30-39 _____ 60-69
____ 40-49 _____ 70 +
6. How long have you been a woodworker?
____ 0 - 2 Years _____ 8 - 20 Years
____ 2 - 8 Years _____ 20+ Years
7. How would you rank your woodworking skills?
____ Simple _____ Advanced
____ Intermediate _____ Master Craftsman
8. What stationary woodworking tools do you own? Check all that apply.
____ Air Compressor _____ Panel Saw
____ Band Saw _____ Planer
____ Drill Press _____ Power Feeder
____ Drum Sander _____ Radial Arm Saw
____ Dust Collector _____ Shaper
____ Horizontal Boring Machine _____ Spindle Sander
____ Jointer _____ Table Saw
____ Lathe _____ Vacuum Veneer Press
____ Mortiser _____ Wide Belt Sander
9. _____ Other _____
How many of your woodworking machines are Grizzly? _____
10. Which benchtop tools do you own? Check all that apply.
____ 1" x 42" Belt Sander _____ 6" - 8" Grinder
____ 5" - 8" Drill Press _____ Mini Lathe
____ 8" Table Saw _____ 10" - 12" Thickness Planer
____ 8" - 10" Bandsaw _____ Scroll Saw
____ Disc/Belt Sander _____ Spindle/Belt Sander
____ Mini Jointer
____ Other _____
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?
____ Builders Hardware _____ Hand Tools
____ Fasteners _____ Wood Components
____ Other _____
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: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____
Street_____
City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

grizzly.com

TOOL WEBSITE

Buy Direct and Save with Grizzly® – Trusted, Proven and a Great Value!

*Visit Our Website Today And Discover Why
Grizzly® Is The Industry Leader!*

- SECURE ORDERING
- ORDERS SHIPPED WITHIN 24 HOURS
- E-MAIL RESPONSE WITHIN ONE HOUR

-OR-

Call Today For A **FREE**
Full Color Catalog

1-800-523-4777

