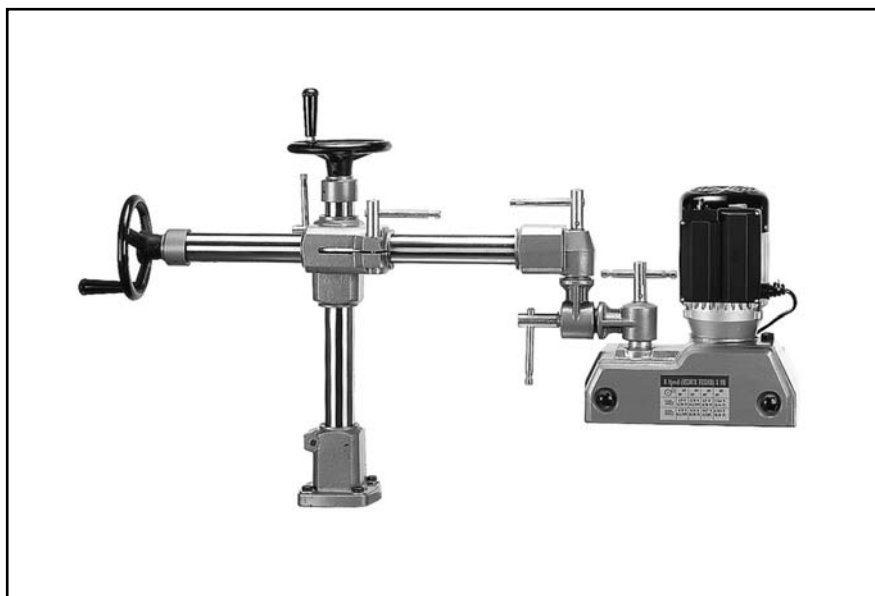




# **POWER FEEDER**

## **MODEL G1128 AND MODEL G1129**

### **INSTRUCTION MANUAL**



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#### **DISCONTINUED MACHINE MANUAL DISCLAIMER**

THE INFORMATION IN THIS MANUAL REPRESENTS THE LAST CONFIGURATION OF THE MACHINE BEFORE IT WAS DISCONTINUED. MACHINE CONFIGURATIONS MAY HAVE CHANGED AS PRODUCT IMPROVEMENTS WERE 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.

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# SECTION 1: SAFETY

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## WARNING: For Your Own Safety Read Instruction Manual Before Operating Power Feeder

- a) Always wear eye protection.
- b) Always keep guards in place and in proper operating condition.
- c) The power feeder must be fixed rigid to the your power tool.
- d) Support the workpiece adequately at all times during operation; maintain control of the work at all times.
- e) Do not attempt to perform an abnormal or little-used operation without study and the use of adequate hold-downs, jigs, fixtures, stops, and the like.

## Safety Instructions For Power Tools

These safety rules cannot cover every situation in a workshop. Consider your conditions when setting up or operating your power feeder.

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form 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. **DON'T USE IN DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from work area.
6. **MAKE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
9. **USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. When using an extension cord, be sure it is rated Hard Service (grade S) or better. Conductor size must be 14 A.W.G. for cords up to 50 feet in length. 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.
10. **WEAR PROPER APPAREL** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip 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's safer than using your hand and frees both hands to operate tool.

13. **DON'T 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. **DISCONNECT TOOLS** before servicing and changing accessories, such as blades, bits, cutters, and the like.
16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
17. **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.
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 alignment of moving parts, binding of moving parts, breakage of parts and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
20. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.

## Additional Safety Instructions For Power Feeders

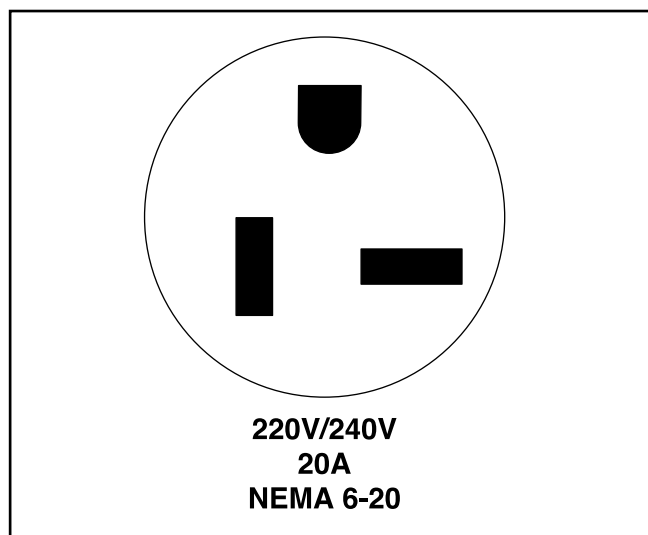
1. Inspect your stock carefully before you feed it through the machine. If you have any doubts about the stability or structural integrity of your stock, **DO NOT USE IT!**
2. **Never** mill stock that has loose knots. All defects should be cut out of the board before it is processed.
3. **DO NOT** jam workpiece into the wheels. Firmly grasp the workpiece in both hands and ease it into the rotating wheels. Guide the workpiece to ensure that it properly contacts the cutterhead or blade.
4. **DO NOT** place hands near, or in contact with moving wheels. **DO NOT** place hands near any spinning blades or cutterheads.
5. Replace wheels when they become worn or disfigured.
6. Do not stand directly in front of or in back of the workpiece as it is feeding through your power tool. Stand to one side.
7. Extension cords , if used, must be rated Hard Service (grade S) or better. Conductor size must be 14 A.W.G. for cords up to 50 feet in length. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.
8. Habits – good and bad – are hard to break. Develop good habits in your shop and safety will become second-nature to you.

# SECTION 2: CIRCUIT REQUIREMENTS

## 220V Operation

The G1128 and G1129 is supplied with a 220V only motor. The ½ HP motor on the G1128 will draw roughly 4 amps. The 1 HP motor on the G1129 will draw about 3.5 amps. These loads are not excessive, but if you operate your machine on any circuit that is already close to capacity, it might blow a fuse or trip a circuit breaker. If an unusual load does not exist and power failure still occurs, consult a qualified electrician. Otherwise, consider a dedicated circuit for your machine. A 15 amp circuit breaker or fuse should be used for a 220V undedicated circuit. The general rule is to use the lightest breaker or fuse that will hold under regular loads. Circuit breakers or fuses that are rated higher may not adequately protect the motor.

You must provide your own plug with both power feeders. **Figure 1.** Ensure that the plug type matches the outlet you intend to use. Connect the plug to the power cord per the plug instructions. Ensure that the ground wire is connected to the plug.



**Figure 1.** Recommended receptacle.



## Grounding

**CAUTION:** THIS TOOL MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

In the event of an electrical short, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in risk of electric shock. The conductor with green or green and yellow striped insulation is the electrical-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

Under no circumstances should the grounding pin from any plug be removed. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Check with a qualified electrician or one of our service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Be sure that your particular electrical configuration complies with local and state codes. The best way to ensure compliance is to check with your local municipality or licensed electrician.

Repair or replace damaged or worn cord immediately.



# SECTION 3: GENERAL INFORMATION

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We are proud to introduce the Model G1128 and G1129 Power Feeders. These power feeders are part of a growing Grizzly family of fine woodworking tools. When used according to the guidelines in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The Models G1128 and G1129 are suitable for use in larger professional shops. The G1128's heavy-duty  $\frac{1}{2}$  H.P. motor and the G1129's heavy-duty 1 H.P. motor, combined with versatile reduction gearing and spring activated rollers, provide plenty of power and traction on large workpieces.

All running parts utilize shielded ball bearings, which require no lubrication for the life of the bearings.

We are also pleased to provide this manual with the Model G1128/G1129. 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 criticisms that you feel we should address in our next printing, please write to us at the Bellingham, WA address at the end of this section.

Most important, we stand behind our machines. We have two 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>

To comment on this manual write to:

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

To operate this or any power tool safely and efficiently, it is essential to become as familiar with it as possible. The time you invest before you begin to use your Model G1128/G1129 will be time well spent. **DO NOT** operate this machine until you are completely familiar with the contents of this manual.

# Unpacking

---

The G1128 Power Feeder is shipped from the factory in a carefully packed carton. The G1129 is shipped in two cartons. If you find the machine to be damaged after you've signed for delivery and the truck and driver are already gone, you will need to file a freight claim with the carrier. Save the containers and all packing materials for inspection by the carrier or their agent. Without the packing materials, filing a freight claim can be difficult. If you need advice regarding this situation, please call us.

Caution: The G1128 and G1129 are relatively heavy machines (105 lbs. and 152 lbs. respective shipping weights). **DO NOT** over-exert yourself while unpacking or moving your machine – get assistance.

When you are completely satisfied with the condition of your shipment, you should inventory its parts.



# Piece Inventory

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After all the parts have been removed from the carton, you should have:

## G1128:

- Power Feeder Motor/Wheels
- Pivot Joint Assembly
- Horizontal/Vertical Column Assembly w/Base
- Gears (2)
- Wheel Handles (2)

## G1129:

- Power Feeder Motor/Wheels
- Pivot Joint Assembly
- Vertical Column Assembly w/Base
- Horizontal Column
- Wheel Handles (2)
- Grease Gun

In the event that any non-proprietary 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.





# Clean up

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The columns and other unpainted parts of the Model G1128/G1129 are coated with a waxy oil that protects them from corrosion during shipment. Remove the protective coating with mineral spirits and paper towels. Do not use gasoline or other petroleum based solvents because of their extremely low flash points. Do not use chlorine-based solvents – if you happen to splash some onto a painted surface, you'll ruin the finish.

## **WARNING!**

***Follow the safety rules listed below when working with solvents:***

1. Read and follow all directions and warnings on the solvent label.
2. Work only in a well ventilated area.
3. Do not work near any type of open flame (e.g., pilot lights, kerosene heaters, and so on).
4. **DO NOT** smoke while working with flammable material.
5. Paper towels from the cleaning process are extremely combustible. Dispose of waste towels so they do not create a fire hazard.



# Site Considerations

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1. **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 power feeder.
2. **Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.



# SECTION 4: ASSEMBLY

---

Most of your G1128/G1129 Power Feeder has been assembled at the factory, but some parts must be assembled or installed after delivery. We have organized the assembly process into steps. Please follow along in the order presented here.

**Note:** Read **Section 4** in its entirety before beginning assembly.

1. (Step 1 for G1129 only) Insert the **horizontal shaft** through the **shaft coupler**. The gear rack on the **horizontal shaft** should engage.
2. Turn the **distance adjustment wheel** so that the **shaft coupler** is approximately centered on the **horizontal shaft**. Turn the **height adjustment wheel** so that the **shaft coupler** is approximately centered on the **vertical shaft**.
3. Attach the **pivot joint assembly** to the end of the **horizontal shaft**. Secure with the **locking handle**.
4. Remove the **base** by loosening the **lock handle**. Set the **shaft assembly** to the side.
5. Find the best mounting location on your woodworking machine. Guidelines:
  - a. The power feeder should not affect any moving machine parts.
  - b. It should be as close to the work area as possible, i.e., keep the distance between the base and rollers to a minimum.
  - c. Test the location by temporarily mounting the base on a stable piece of hardwood which is clamped to the machine. Swing the power feeder in a variety of positions to ensure that the base is best suited to your anticipated needs.

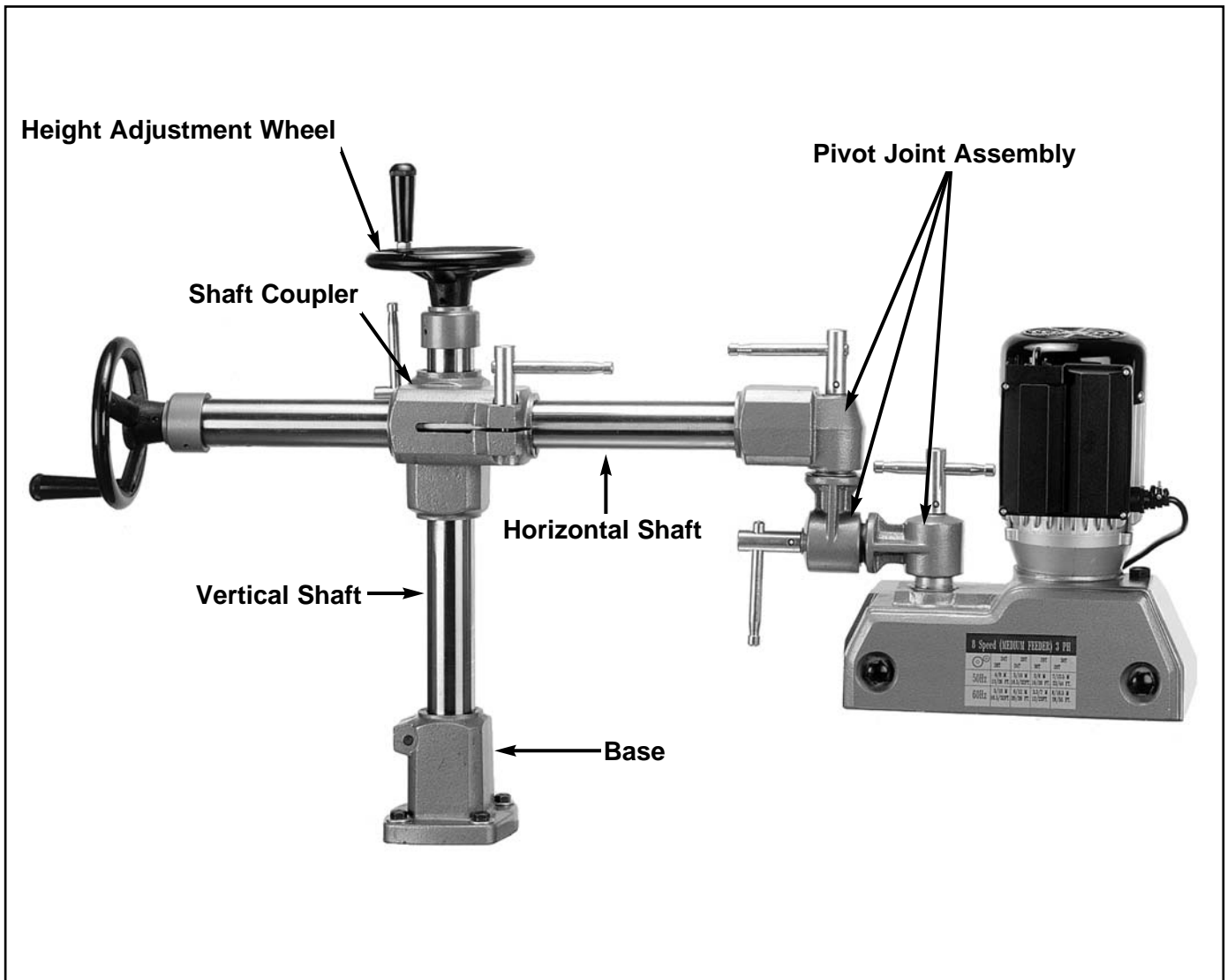
**WARNING: DO NOT ATTEMPT TO OPERATE THE POWER FEEDER UNTIL IT IS PERMANENTLY MOUNTED TO THE TABLE TOP! MOUNTING THE POWER FEEDER TO YOUR MACHINE WILL MAKE IT TOP HEAVY. SECURELY ATTACH YOUR MACHINE TO THE FLOOR OF YOUR SHOP.**

6. Use the **base** as your template and mark the outside perimeter of the **base** and the locations of the four bolt holes on your table.
7. Measure the distances of the four mounting holes from the edges of the table with an accurate ruler. Compare those measurements with the bottom of the table. Ensure that the mounting holes will not be over the cast braces on the underside of the table.
8. Drill  $\frac{3}{8}$ " diameter holes through your table. Use  $\frac{5}{16}$ " through bolts of sufficient length with flat and lock washers to attach the base. They will provide added support.
9. Re-insert the **shaft assembly** into the **base**. Orient the **horizontal shaft** properly. Tighten the **lock handle**.
- G1129 ONLY:** Tighten the **cap screw** on the **base** to inhibit spinning of the vertical shaft.
10. Mount the **motor/wheel assembly** to the **pivot joint assembly**.

**G1128:** Screw the lower lock handle into the hole on the wheel housing.

**G1129:** Remove the handle and screw from the **motor clamp assembly (MCA)**. Place the outer half of the **MCA** off to one side. Position the **motor/wheel assembly** so the **MCA** clamps around the bottom of the motor. Replace the outer half of the **MCA**. Tighten securely with the handle and screw.





**Figure 2.**

# SECTION 5: ADJUSTMENTS

## Roller Placement

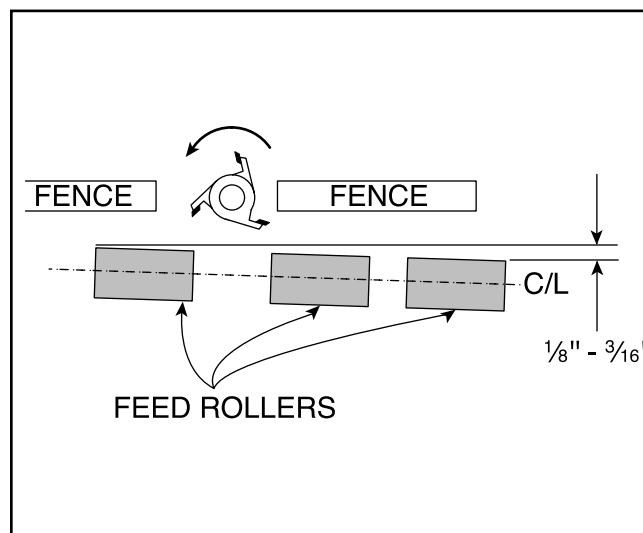
Your power feeder will operate best if the rollers are properly placed and their speed is correct for the job.

**G1129:** If you look at the rollers on the G1129, you will notice that the gap between the first and second rollers is larger than that between the second and third rollers. This arrangement allows you to place the rollers so the first wheel is slightly ahead of your cutting tool, while the middle and third wheels are behind. Thus, the rollers feed your workpiece into, through and past the cutting surface smoothly. This feature provides consistent application of force without binding the cutting tool.

**G1128:** The G1128 does not have different sized gaps between the wheels. However, the first wheel must be placed slightly ahead of the cutter for the power feeder to work effectively.

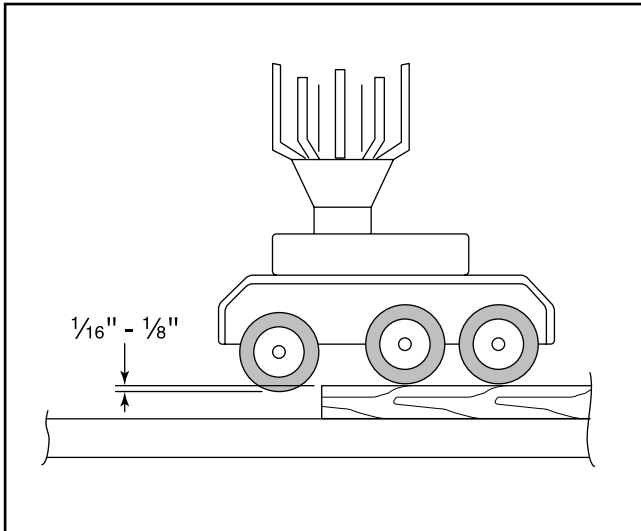
To position the rollers correctly on the G1128 / G1129:

1. Raise the horizontal column so the rollers are just above the table.
2. Swing the motor and roller assembly so the rollers are just slightly away from the cutter, with the first roller slightly forward of the cutting region.
3. Skew the feed rollers so they are angled just slightly toward the fence. The first wheel should be just about  $\frac{1}{8}$ " -  $\frac{3}{16}$ " closer to the fence than the third wheel. **Figure 3.**



**Figure 3.**

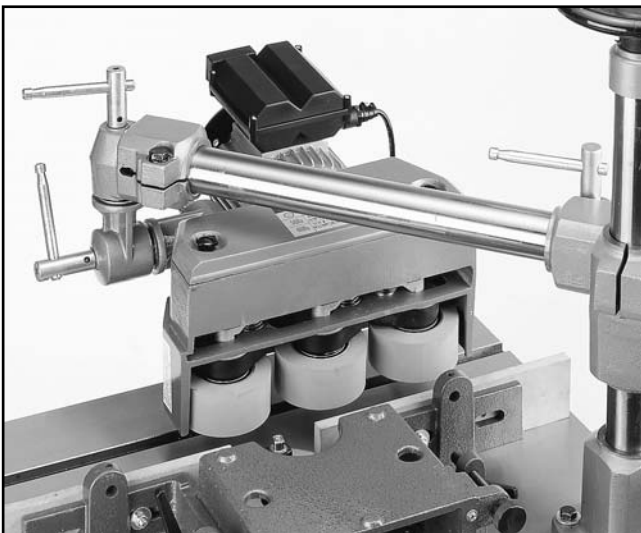
4. Set the wheel height between  $\frac{1}{16}$ " and  $\frac{1}{8}$ " below the height of the material you intend to mill. The wheels, when properly adjusted, will put consistent downward pressure on your workpiece. **Figure 4.**



**Figure 4.**

The power feeder can also be set to support your work against a fence. **Figure 5.**

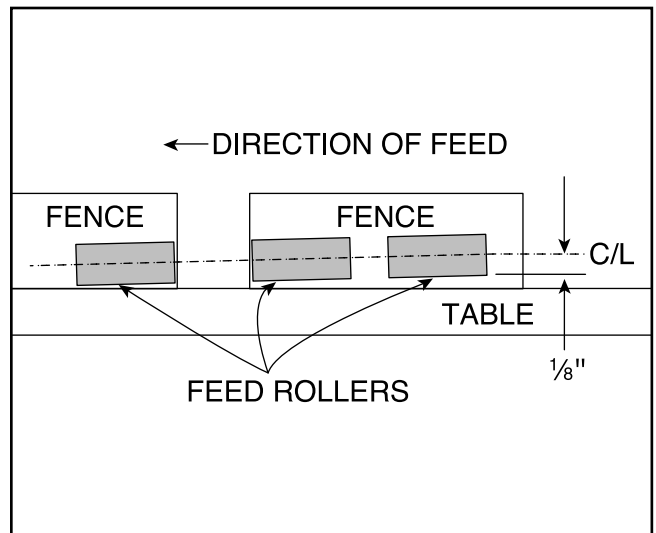
1. Raise the horizontal shaft so that when the power feeder head is turned, there will be no interference with the fence.



**Figure 5.**

2. Loosen the lock handles on the pivot joint assembly.
3. Rotate head to the desired position.
4. Adjust the height and distance from the fence.
5. Re-tighten the lock handles.

As with the previous arrangement, you will want to set the distance between the rollers and (in this case) the fence about  $\frac{1}{8}$ " to  $\frac{3}{16}$ " under the thickness of the material to be milled. The rollers should also be skewed slightly toward the direction of feed to hold the workpiece against the table. **Figure 6.** When using the power feeder this way, it is essential to make sure that the fence is fastened tightly in place.

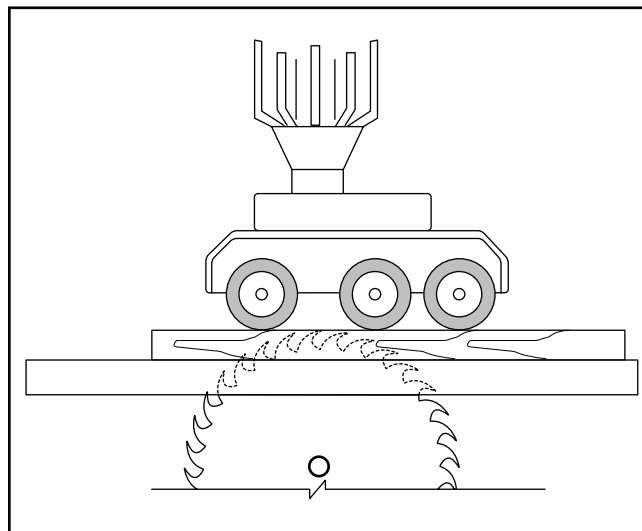


**Figure 6.**

## Table Saw Adjustments:

Pinching, binding and blade height are issues of concern when using the power feeder with a table saw. If you are **ripping** boards **4" or wider**, place the power feeder between the fence and blade with the rollers turned slightly toward the fence. If you are **ripping** materials **less than 4"**, set the rollers as close as possible to the fence. Do not set the rollers so the waste side of your material binds or pinches the blade. The rollers should be angled with **no more than 1/8"** of variation between the leading and trailing wheels.

**IMPORTANT:** The blade height on your table saw must just slightly exceed the height of your workpiece. **Do Not** allow the blade to cut into your rollers. **Figure 7.**



**Figure 7.**

**You may elect to remove the middle wheel to gain even more clearance.**

Some fences clamp at the front only. You will need to use an auxiliary clamp for the back of your fence if this is the case. The power feeder will push the fence out of alignment if it is not clamped adequately.



# G1128 Feed Rates

The optimum feed rate for the power feeder will depend on the thickness of the material to be cut, the hardness of the workpiece, the speed of the cutting tool and number of teeth, tool shape etc. Generally, the following rules can be followed with a good level of success.

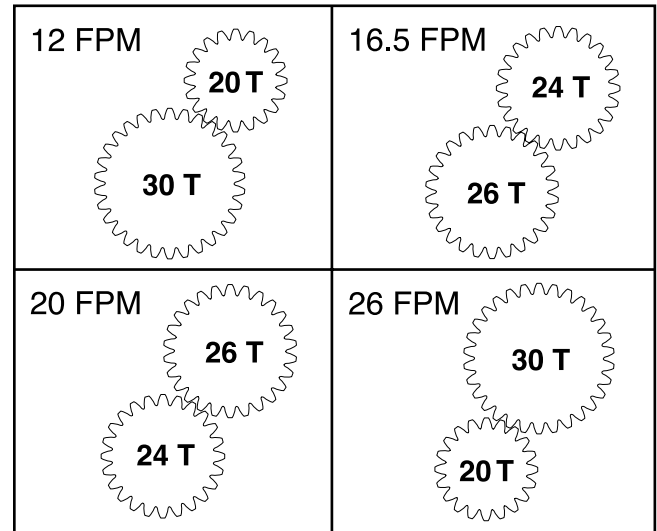
**When selecting feed rates, remember these important tips:**

- The thicker the material to be cut, the slower the feed rate.
- The harder the material, the slower the feed rate.
- The faster the cutter speed, the faster the feed rate.
- The greater the number of teeth or cutting surfaces, the slower the feed rate.

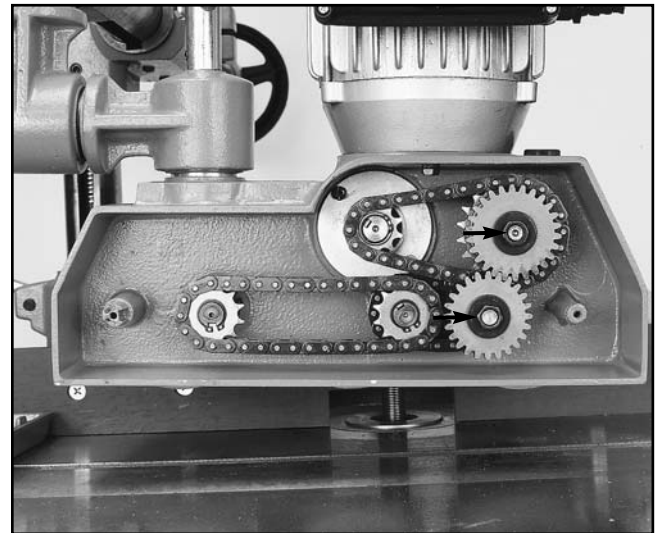
G1128 speeds: 12, 16.5, 20, 26 FPM

To change the speed of the G1128:

1. Remove the gearbox cover by unscrewing the knobs on the front of the power head.
2. Determine the speed you desire, based on your material and cutter configuration.
3. Locate the desired feed rate on the chart shown in **Figure 8**. The numbers on the gears refer to the number of teeth on the gear. **Do not try different arrangements!**



**Figure 8.**



**Figure 9.**

4. Remove the hex nuts and washers which hold the drive gears in place. **Figure 9.**
5. Remove the existing gears and replace with the new gears.
6. Replace the hex nuts and attach the drive gear cover.



# G1129 Feed Rates

The optimum feed rate for the power feeder will depend on the thickness of the material to be cut, the hardness of the workpiece, the speed of the cutting tool and number of teeth, tool shape etc. Generally, the following rules can be followed with a good level of success.

**When selecting feed rates, remember these important tips:**

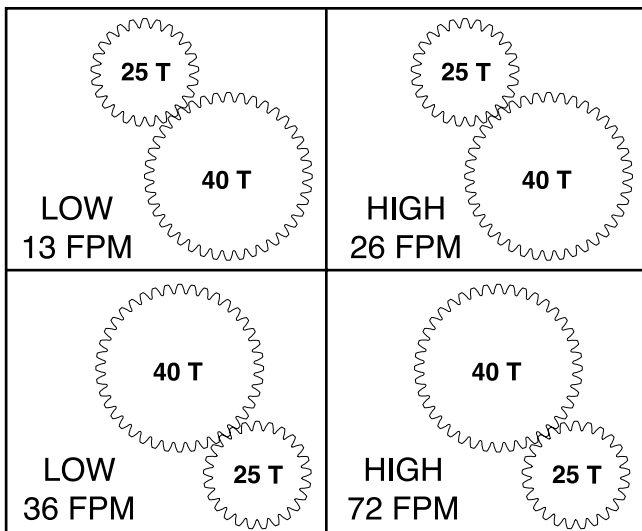
- The thicker the material to be cut, the slower the feed rate.
- The harder the material, the slower the feed rate.
- The faster the cutter speed, the faster the feed rate.
- The greater the number of teeth or cutting surfaces, the slower the feed rate.

G1129 speeds: 13, 26, 36, 72 FPM

There are two speed ranges on the motor (low and high) that are controlled by the switch.

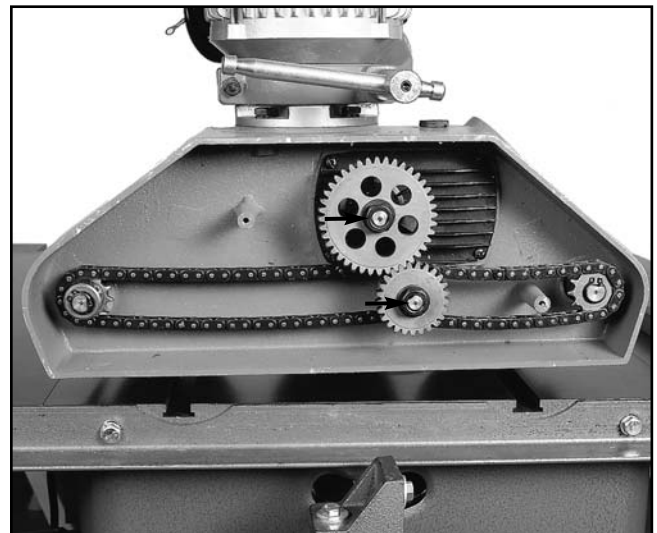
To change the speed of the G1129:

1. Choose your speed range based on your material and cutter configuration. Using **Figure 10**, determine whether you need to switch the gears or just the switch setting.



**Figure 10.**

2. If you need to switch the gears, remove the gearbox cover by unscrewing the knurled knobs on the front of the power head.
3. Remove the hex nuts and washers which hold the drive gears in place. **Figure 11.**
4. Remove the gears and alternate their positions. Slide them back onto their shafts.
5. Replace the hex nuts and attach the drive gear cover.



**Figure 11.**





# SECTION 6: OPERATIONS

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## Test Run

---

**Before you test your Power Feeder, give it a quick inspection.**

1. Are all fasteners tight?
2. Are the mounting bolts secured to the machine table top?
3. Is the power feeder oriented properly for the type of job you will do?
4. Are each of the lock handles tightened securely?

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

**Do Not** feed stock through at this time.

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's a problem. The power feeder 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.

***WARNING: DO NOT attempt to investigate or adjust the machine while it is running. Wait until the machine is turned off, unplugged and all working parts have come to a rest before you do anything!***

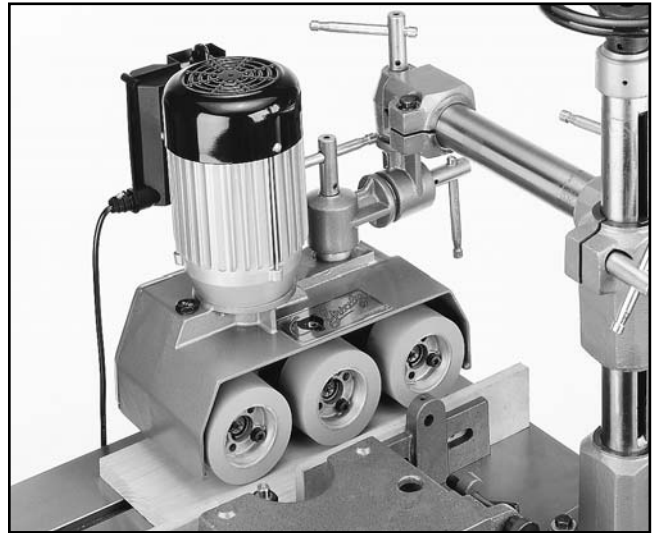
If noises occur that cannot be found by visual inspection, feel free to contact our service department for help.



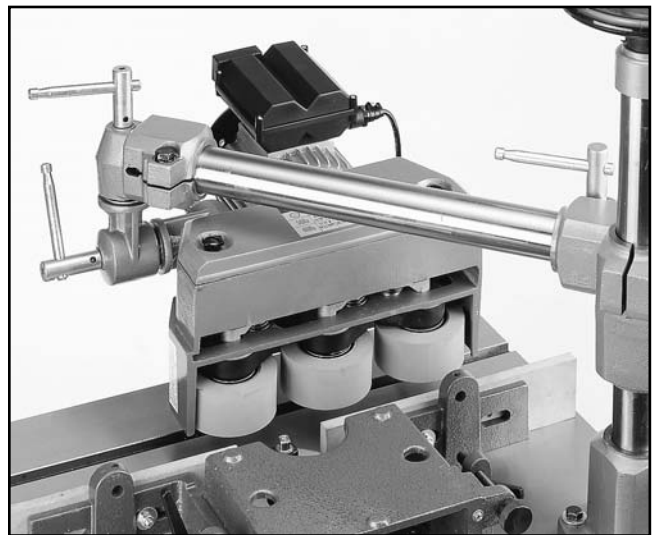
# Operation

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1. Choose the feed rate at which to operate your power feeder. The speed of the wheels will have a large impact on how well your table saw or shaper will perform.
2. Orient your power feeder depending on your job. The motor/wheel assembly can be oriented so that the wheels are either horizontal or vertical. **Figure 12** and **Figure 13**.
3. Adjust the distance between the wheels and the table top or fence (depending on the orientation of the wheels). The distance should be about  $\frac{1}{16}$ "- $\frac{1}{8}$ " less than the thickness of the wood.
4. Ensure that the power feeder position is securely locked. Also ensure that the fence is securely locked.
5. Turn on the power feeder and the tool it is mounted to. Slowly feed your workpiece into and under the wheels of the power feeder.
6. Retrieve the workpiece as it feeds out of the machine. **Do not stand directly in front of or in back of the workpiece as it is feeding through your power tool. Stand to one side.**



**Figure 12.**



**Figure 13.**



# SECTION 7: MAINTENANCE

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## General

---

Regular periodic maintenance on your Model G1128/G1129 Power Feeder will ensure its optimum performance. Make a habit of inspecting your Power Feeder each time you use it. Check for the following conditions and repair or replace when necessary.

**Caution:** Always perform any maintenance with the power off and the machine unplugged.

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.



## Drive Gears

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Lubricate drive gears and chains with grease after every 80 hours of operation. Clean and lubricate all the machined surfaces with light machine oil.



## Rollers

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Each of the three roller wheels is fitted with a grease fitting. Lubricate after every 80 hours of use. The G1129 comes with a grease gun. The G1128 requires purchasing a grease gun from your local hardware store.

Replace rollers when they become worn or disfigured. Rollers may be ordered through the Grizzly parts department. Contact the appropriate service department.

Clean the wheels when they become dirty. Use a moist brush with light detergent. Do not allow dirty wheels to leave unwanted marks on your workpiece.



## Gearbox Lubrication

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The internal gearbox oil should be drained and replaced after every 500 hours of operation. A drain plug at the top of the wheel housing provides access for removal of old oil. Remove the motor/wheel apparatus from the pivot joint, remove the plug, tip over and drain. Be careful not to get oil all over the motor. Re-fill to within 1/2" of the filler plug with 80-90 weight gear oil.



# SECTION 8: CLOSURE

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The following pages contain general machine data, parts diagrams/lists, trouble shooting guide and Warranty/Return information for your Model G1128/G1129 Power Feeder.

If you need parts or help in assembling your machine, or if you need operational information, we encourage you to call the appropriate regional Service Department. Our trained service technicians will be glad to help you.

If you have comments dealing specifically with this manual, please write to our Bellingham, Washington location using the address in the Introduction. The specifications, drawings, and photographs illustrated in this manual represent the Model G1128/G1129 as supplied when the manual was prepared. However, due to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. Whenever possible, though, we send manual updates to all owners of a particular tool or machine. Should you receive one, add the new information to this manual and keep it for reference.

We have included some important safety measures that are essential to this machine's operation. While most safety measures are generally universal, Grizzly reminds you that each workshop is different and safety rules should be considered *as they apply to your specific situation*.

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 appropriate regional Service Department listed in the introduction.

Additional information sources are necessary to realize the full potential of this machine. Trade journals, woodworking magazines, and your local library are good places to start.

## **WARNING!**

*As with all power tools, there is danger associated with the Model G1128/G1129 Power Feeder. Use the tool with respect and caution to lessen the possibility of mechanical damage or operator injury. If normal safety precautions are overlooked or ignored, injury to the operator or others in the area is likely.*

The Model G1128/G1129 was specifically designed for feeding wood through a table saw or shaper. **DO NOT MODIFY AND/OR USE THIS POWER FEEDER FOR ANY OTHER PURPOSE. Modifications or improper use of this tool will void the warranty.** If you are confused about any aspect of this machine, **DO NOT** use it until you have answered all your questions.

## MACHINE DATA

### GRIZZLY MODEL G1128/G1129 Power Feeder

**Model:** ..... **G1128** ..... **G1129**

#### Overall Dimensions:

Height (w/handle) .....	27"	30"
Overall Length (fully extended) .....	45"	42"
Overall Width .....	13 1/2"	17 3/4"
Shipping Weight.....	105 lbs.	152 lbs.
Net Weight .....	100 lbs.	147 lbs.

#### Construction:

Columns .....	Steel	Steel
Supports .....	Cast Iron	Case Iron
Housing.....	Cast Aluminum	Cast Aluminum
Wheels .....	(3) 2" W x 4" D, Rubber	(3) 2 1/4" W x 4 3/4" D, Rubber

#### Motor:

Type.....	TEFC	TEFC
Horsepower .....	1/2 H.P.	1 H.P.
Amps (220V) .....	4	3.2-3.8
Phase Type/Voltage .....	Single Phase/220V	Single Phase/220V
Cycle/RPM .....	60 Hertz/1720 RPM	60 Hertz/3420 or 1720 RPM
Switch .....	Forward/Reverse	High/Low/Forward/Reverse
Bearings .....	Shielded	Shielded

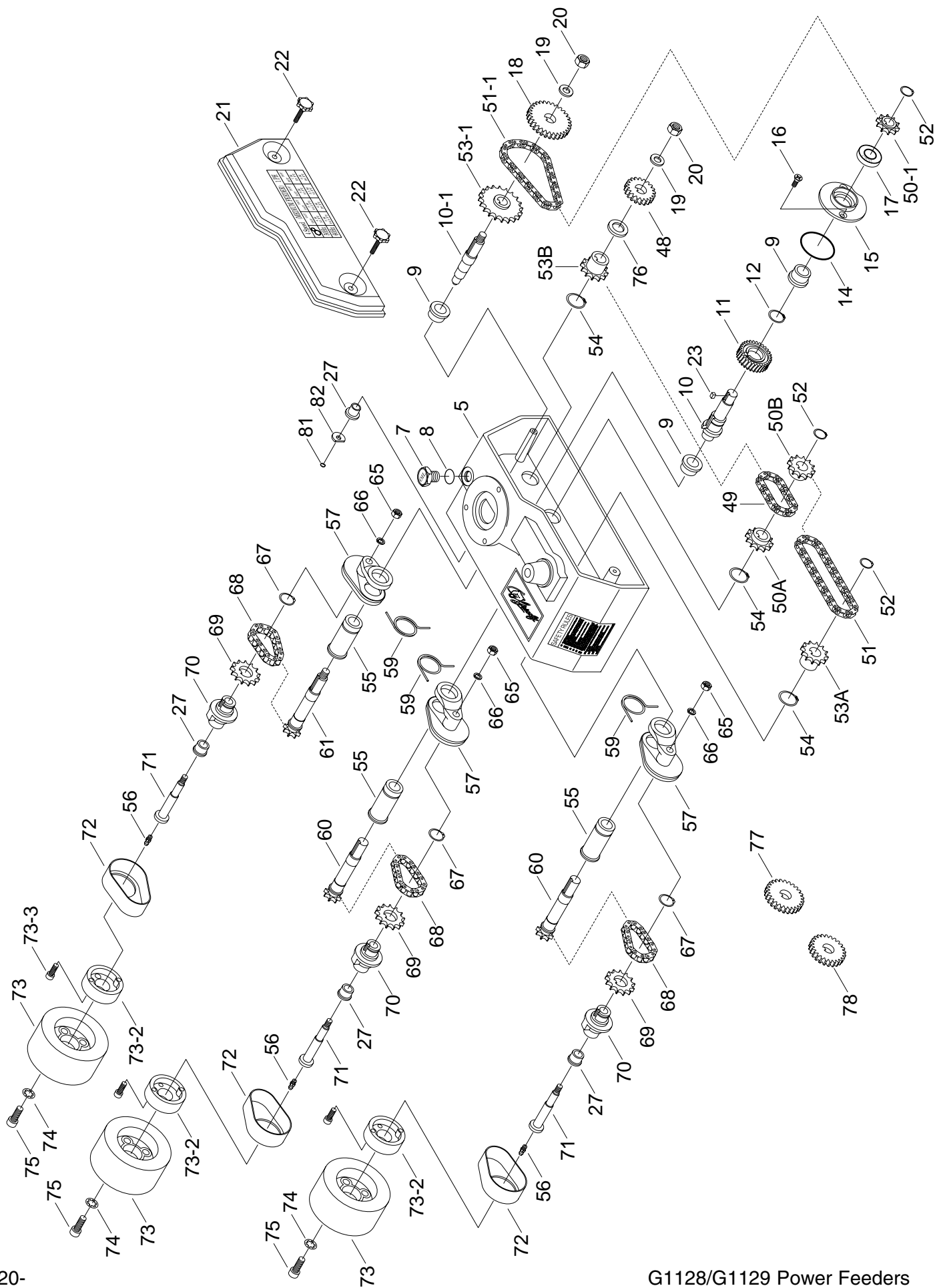
#### Specifications:

Number of Speeds .....	4	4
Range (approx.) .....	12, 16.5, 20, 26 FPM	13, 26, 36, 72 FPM
Swing .....	360°	360°
Vertical Movement.....	8 3/4"	11 1/2"
Horizontal Movement.....	16"	16 3/4"
Max. Height of Rollers to Table .....	5"	7"

#### Features:

Rollers.....	Spring Tension	Spring Tension
HD Gear Reduction .....	Hardened Gears	Hardened Gears
Universal Positioning .....	w/Handle Locks	w/Handle Locks

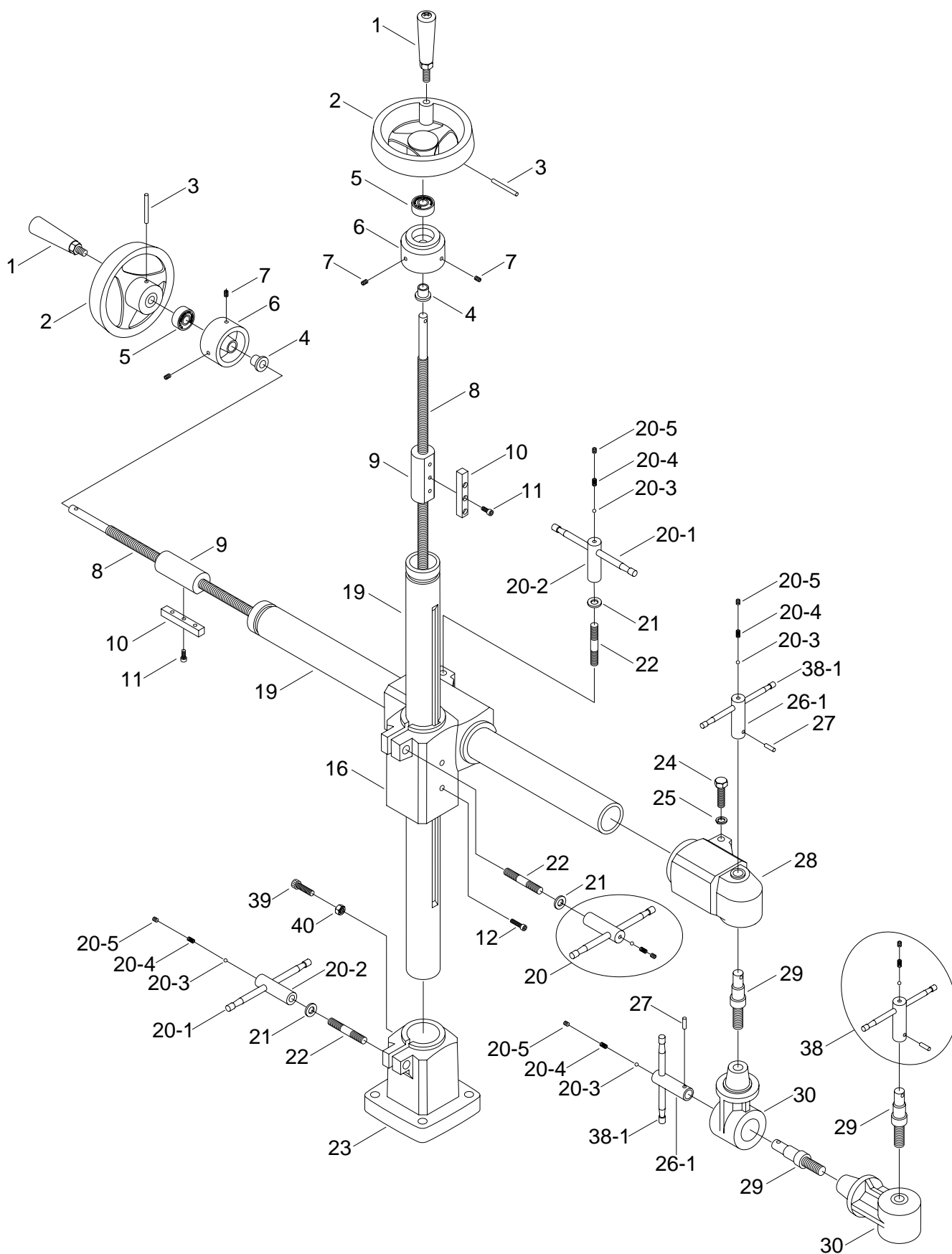
*Specifications, while deemed accurate, are subject to change without notice.*



# G1128 Gear Box

REF#	PART#	DESCRIPTION
05	P1128005	FRAME
07	P1128007	OIL CAP
08	P1128008	O-RING
09	P1128009	BUSHING
10	P1128010	WORM GEAR SHAFT
10-1	P1128010-1	SHAFT
11	P1128011	WORM GEAR 30T
12	PR10M	SNAP RING 22mm
14	P1128014	O-RING
15	P1128015	COVER
16	PFH05M	FLAT HD SCR M5-0.8 x 12
17	P1128017	OIL SEAL 17 - 32 - 7
18	P1128018	GEAR 30T
19	PW04M	FLAT WASHER 10mm
20	PN02M	HEX NUT M10 - 1.5
21	P1128021	COVER
22	P1128022	KNOB
23	PK46M	KEY 6 x 6 x 8mm
27	P1128027	BUSHING
48	P1128048	GEAR 20T
49	P1128049	CHAIN 11 LINKS
50A	P1128050A	SPROCKET 12T
50B	P1128050B	SPROCKET 12T
50-1	P1128050-1	SPROCKET 10T
51	P1128051	CHAIN 18 LINKS
51-1	P1128051-1	CHAIN 16 LINKS
52	PR05M	SNAP RING 15mm
53A	P1128053A	SPROCKET 12T

REF#	PART#	DESCRIPTION
53B	P1128053B	SPROCKET 12T
53-1	P1128053-1	SPROCKET 20T
54	PR17M	SNAP RING 26mm
55	P1128055	TUBE/BUSHING
56	P1128056	GREASE FITTING
57	P1128057	ROLLER STAND
59	P1128059	SPRING
60	P1128060	SPROCKET/SHAFT
61	P1128061	SPROCKET/SHAFT
65	PN03M	HEX NUT M8 - 1.25
66	PLN04M	LOCK WASHER 8mm
67	PR09M	SNAP RING 20mm
68	P1128068	CHAIN 9 LINKS
69	P1128069	SPROCKET 13T
70	P1128070	ROLLER SUPPORT
71	P1128071	SHAFT
72	P1128072	COVER
73	P1128073	FEED ROLLER
73-2	P1128073-2	FEED ROLLER MOUNT
73-3	PSB01M	CAP SCREW M6 - 1.0 x 16
74	P1128074	STAR WASHER 8mm
75	PSB14M	CAP SCREW M8 - 1.25 x 20
76	P1128076	SPACER
77	P1128077	GEAR 26T
78	P1128078	GEAR 24T
81	PR01M	SNAP RING 10mm
82	P1148082	SPACER

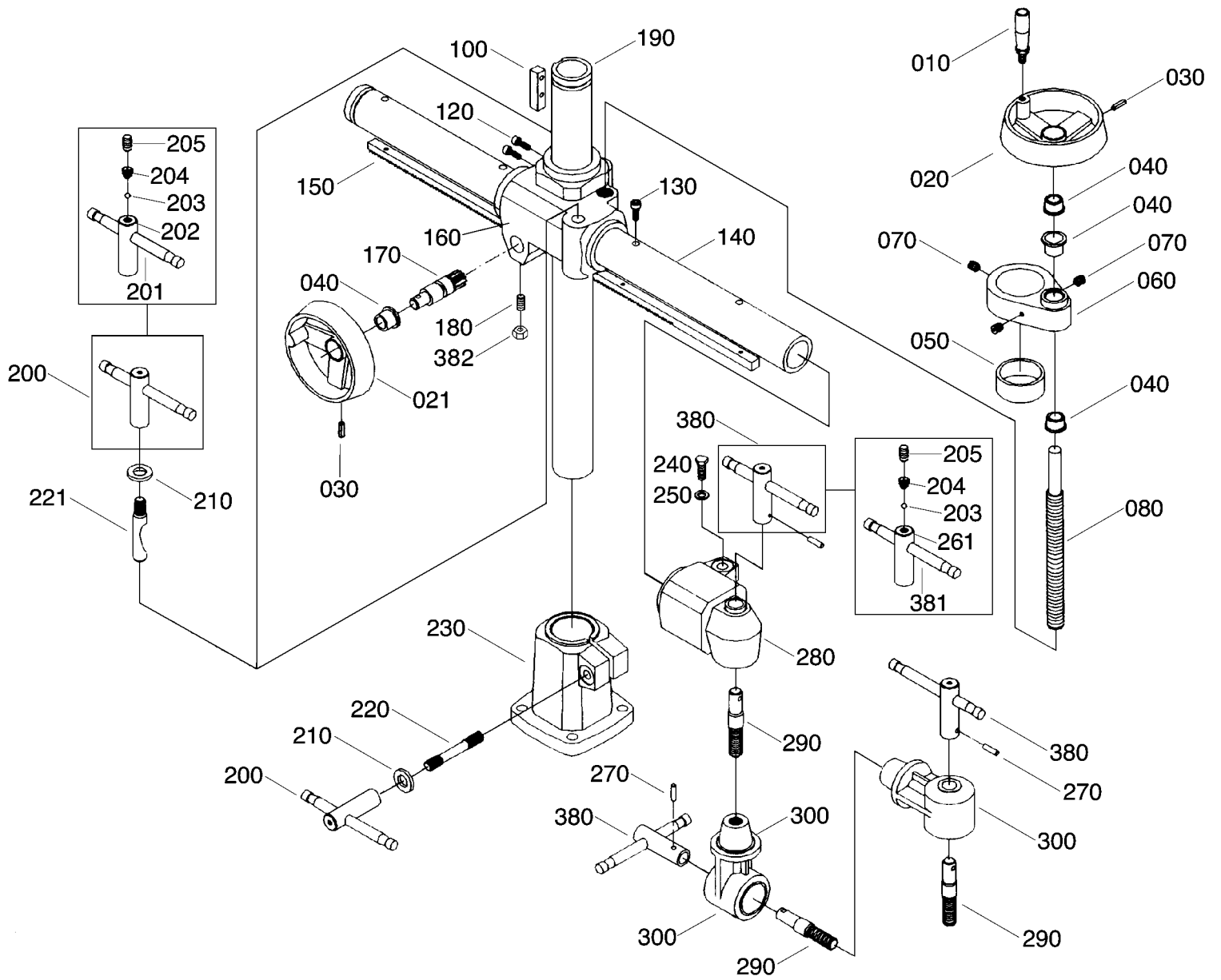




# G1128 Base Type I

REF#	PART#	DESCRIPTION
01	P1128101	HANDLE ASSEMBLY
02	P1128102	HAND WHEEL
03	PRP31M	ROLL PIN 6 x 36
04	P1128104	BUSHING
05	P6202	BEARING 6202 - 2RS
06	P1128106	SPACER
07	PSS02M	SET SCREW M6 - 1.0 x 6
08	P1128108	ELEVATING SCREW
09	P1128109	ELEVATING NUT
10	P1128110	KEY
11	PSB26M	CAP SCREW M6 - 1.0 x 12
12	PSB02M	CAP SCREW M6 - 1.0 x 20
16	P1128116	ELEVATING BRACKET
19	P1128119	COLUMN
20	P1128120	LOCK HANDLE ASSEMBLY
20-1	P1128120-1	HANDLE
20-2	P1128120-2	HANDLE BODY

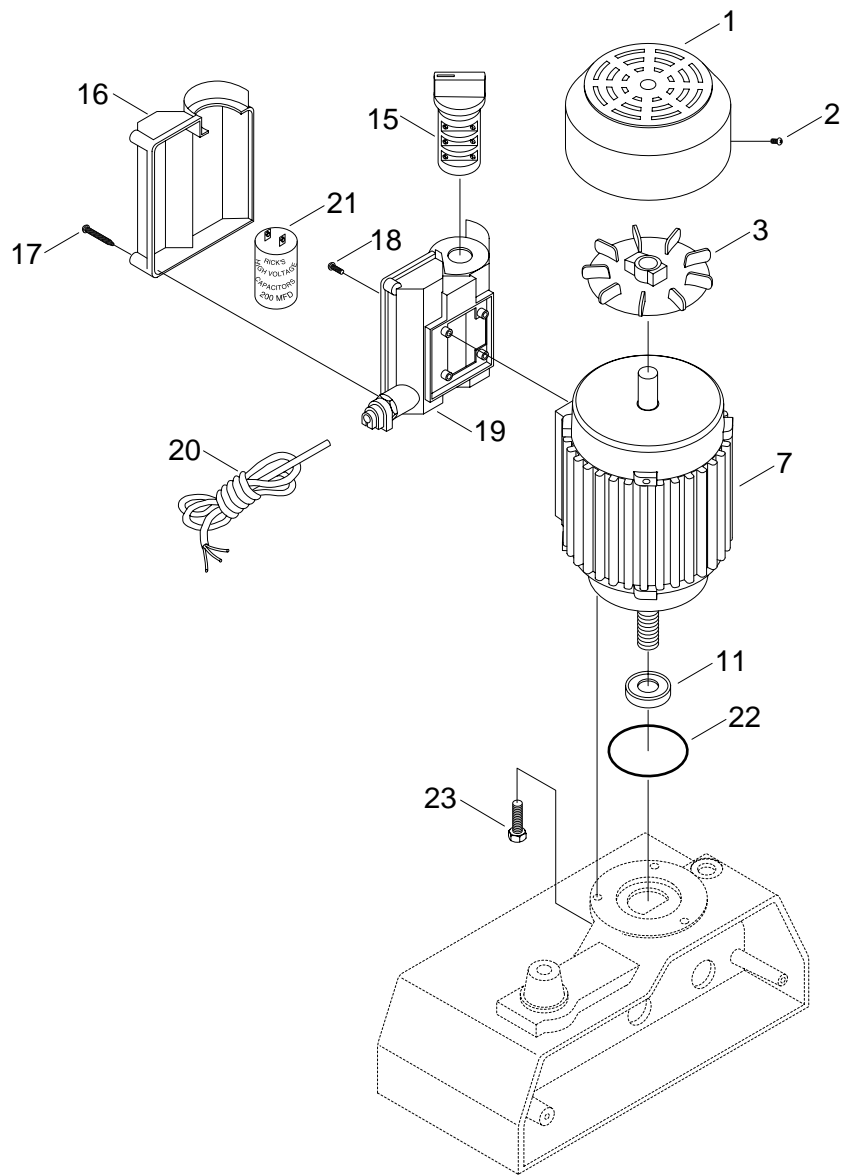
REF#	PART#	DESCRIPTION
20-3	P1128120-3	BALL 6mm
20-4	P1128120-4	SPRING
20-5	PSS17M	SETSCREW M8 - 1.25 x 6
21	PW06M	FLAT WASHER 12mm
22	P1128122	STUD
23	P1128123	BASE
24	PB33M	HEX BOLT M12 - 1.75 x 50
25	PLW05M	LOCK WASHER 12mm
26-1	P1128126-1	HANDLE BODY
27	PRP07M	ROLL PIN 6 x 20
28	P1128128	HORIZONTAL BRACKET
29	P1128129	LOCK STUD
30	P1128130	SWIVEL CASTING
38	P1128138	HANDLE ASSEMBLY
38-1	P1128138-1	HANDLE
39	PSB31M	CAP SCREW M8 - 1.25 x 25
40	PN03M	HEX NUT M8 - 1.25



# G1128 Base Type II

REF#	PART#	DESCRIPTION
010	P1128101	HANDLE ASSEMBLY
020	P1128102	HAND WHEEL
021	P1128021-1	HAND WHEEL
030	PRP31M	ROLL PIN 6 x 36
040	P1128104	BUSHING
050	P1128050	BUSHING
060	P1128060-1	COLUMN CAP
070	PSS04M	SETSCREW M6-1.0 X 12
080	P1128080	ELEVATING SCREW
100	P1128110	ELEVATING KEY
120	PSB04M	CAP SCREW M6-1.0 X 10
130	PSB50M	CAP SCREW M5-0.8 X 10
140	P1128140-1	HORIZONTAL COLUMN
150	P1128150	RACK
160	P1128160	ELEVATING BRACKET
170	P1128170	PINION
180	P1128180	SPECIAL SETSCREW
190	P1128190	VERTICAL COLUMN
200	P1128120	HANDLE ASSEMBLY

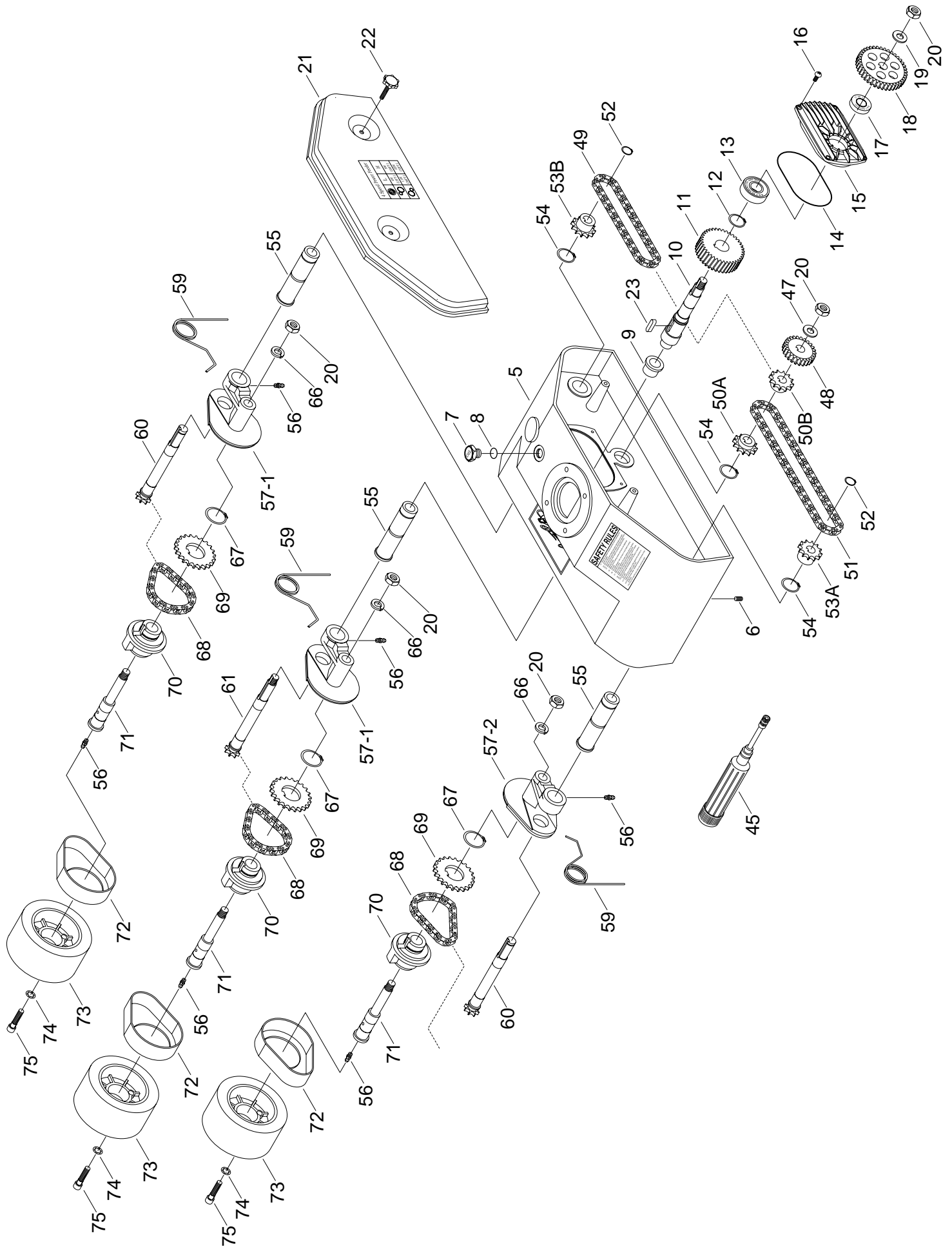
REF#	PART#	DESCRIPTION
201	P1128120-1	HANDLE
202	P1128120-2	HANDLE BODY
203	P1128120-3	BALL
204	P1128120-4	SPRING
205	PSS17M	SETSCREW M8 - 1.25 X 6
210	PW06M	FLAT WASHER 12MM
220	P1128122	STUD
221	P1128221-1	STUD
230	G1130	BASE
240	PB33M	HEX BOLT M12 - 1.75 X 50
250	PLW05M	LOCK WASHER 12MM
261	P1128126-1	HANDLE BODY
270	PRP07M	ROLL PIN 6 X 20
280	P1128128	HORIZONTAL BRACKET
290	P1128129	LOCK STUD
300	P1128130	SWIVEL CASTING
380	P1128138	HANDLE ASSEMBLY
381	P1128138-1	HANDLE
382	PN01M	HEX NUT M6-1.0



# G1128 Motor

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REF#	PART#	DESCRIPTION
01	P1128201	FAN COVER
02	PS18	PHLP HD SCRW 10 - 24 x 1/4"
03	P1128203	FAN
07	P1128207	MOTOR
11	P1128211	SEAL
15	P1128215	FORWARD/REVERSE SWITCH
16	P1128216	OUTER COVER
17	P1128217	SCREW
18	PS21M	PHLP HD SCRW M4 - 0.7 x 15
19	P1128219	INNER COVER
20	P1128220	POWER CORD
21	PC200	CAPACITOR
22	P1128222	O-RING
23	PB08M	HEX BOLT M6 - 1.0 x 20



# G1129 Gear Box

REF#	PART#	DESCRIPTION
05	P1129005	FRAME
06	PSS04M	SET SCREW M6 - 1.0 x 12
07	P1128007	OIL CAP
08	P1128008	O-RING
09	P1129009	BUSHING
10	P1129010	WORM GEAR SHAFT
11	P1128011	WORM GEAR 38T
12	PR10M	SNAP RING 22mm
13	P6203	BEARING 6203 - 2RS
14	P1129014	O-RING
15	P1129015	WORM GEAR COVER
16	PS08M	PHLP HD SCRW M5-0.8 x 12
17	P1128017	OIL SEAL 17-32-7
18	P1129018	GEAR 40T
19	PW06M	FLAT WASHER 12mm
20	P1129020	JAM NUT M12 - 1.75
21	P1129021	COVER PLATE
22	P1128022	KNOB
45	P1129045	GREASE GUN
47	PW06M	FLAT WASHER 12mm
48	P1129048	GEAR 25T
49	P1129049	CHAIN 20.5 LINKS
50A	P1128050A	SPROCKET 12T
50B	P1128050B	SPROCKET 12T
50-1	P1128050-1	SPROCKET 10T
51	P1129051	CHAIN 31 LINKS
51-1	P1128051-1	CHAIN 16 LINKS

REF#	PART#	DESCRIPTION
52	PR05M	SNAP RING 15mm
53A	P1128053A	SPROCKET 12T
53B	P1128053B	SPROCKET 12T
54	PR17M	SNAP RING 26mm
55	P1129055	BUSHING
56	P1128056	GREASE FITTING
57-1	P1129057-1	ROLLER STAND
57-2	P1129057-2	ROLLER STAND
59	P1129059	SPRING
60	P1129060	SPROCKET/ SHAFT
61	P1129061	SPROCKET/ SHAFT
66	PLW05M	LOCK WASHER 12mm
67	PR37M	SNAP RING 32mm
68	P1129068	CHAIN 13 LINKS
69	P1129069	SPROCKET 22T
70	P1129070	FEED ROLLER MOUNT
71	P1129071	SHAFT
72	P1129072	COVER
73	P1129073	FEED ROLLER
74	P1128074	STAR WASHER 8mm
75	PSB40M	CAP SCREW M8 - 1.25 x 35
76	P1128076	SPACER
77	P1128077	GEAR 26T
78	P1128078	GEAR 24T
81	PR01M	SNAP RING 10mm
82	P1148082	SPACER

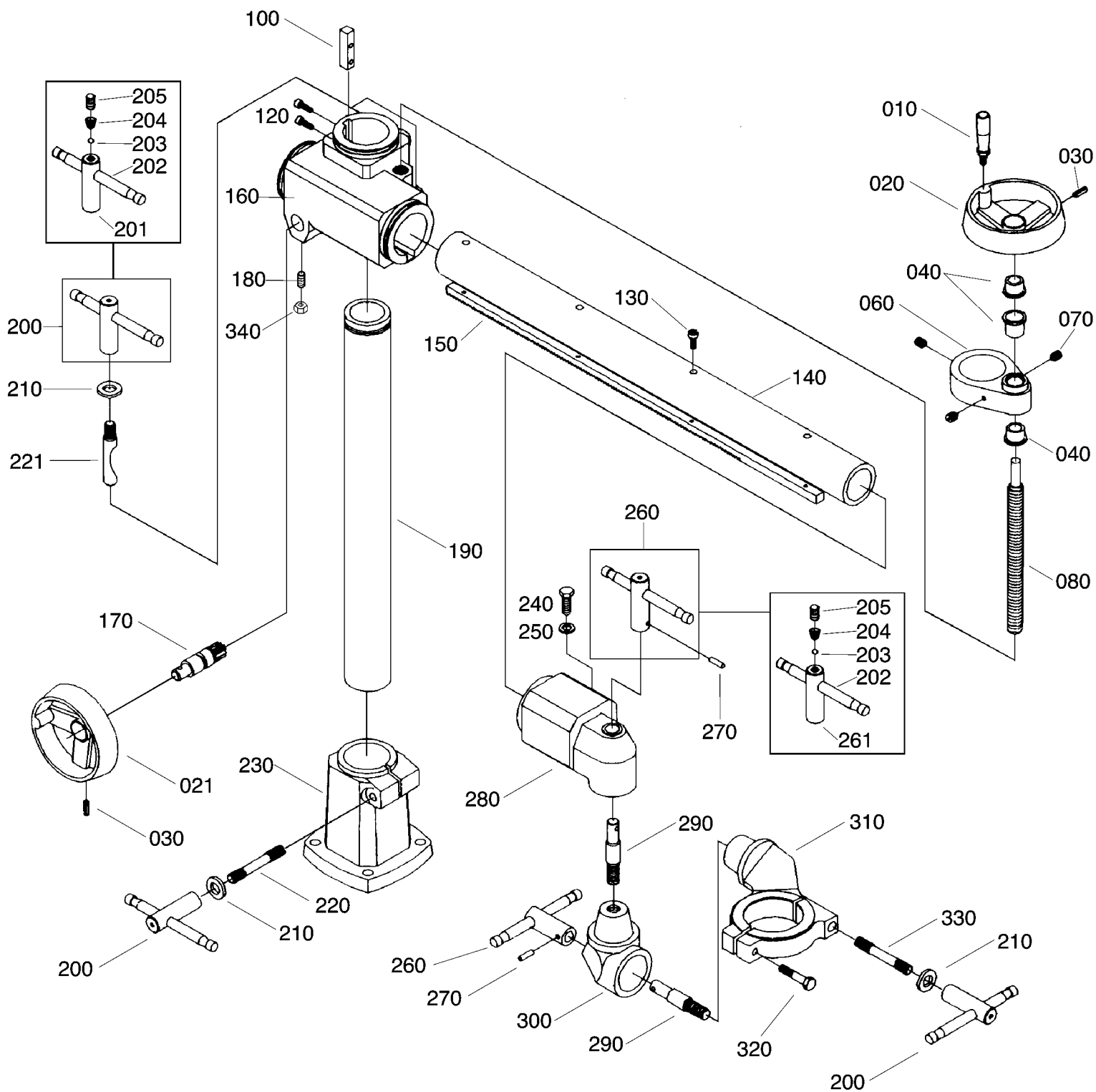




# G1129 Base Type I

REF#	PART#	DESCRIPTION
01	P1128101	HANDLE ASSEMBLY
02	P1128102	HAND WHEEL
03	PRP31M	ROLL PIN 6 x 36
04	P1128104	BUSHING
05	P6202	BEARING 6202 - 2RS
06	P1129106	SPACER
07	PSS02M	SET SCREW M6 - 1.0 x 6
08	P1128108	ELEVATING SCREW
09	P1129109	ELEVATING NUT
10	P1129110	KEY
11	PSB26M	CAP SCREW M6 - 1.0 x 12
12	PSB10M	CAP SCREW M6 - 1.0 x 25
13	PSB50M	CAP SCREW M5 - 0.8 x 10
14	P1129114	HORIZONTAL COLUMN
15	P1129115	RACK
16	P1129116	ELEVATING BRACKET
19	P1129119	COLUMN
20	P1128120	HANDLE ASSEMBLY
20-1	P1128120-1	HANDLE
20-2	P1128120-2	HANDLE BODY

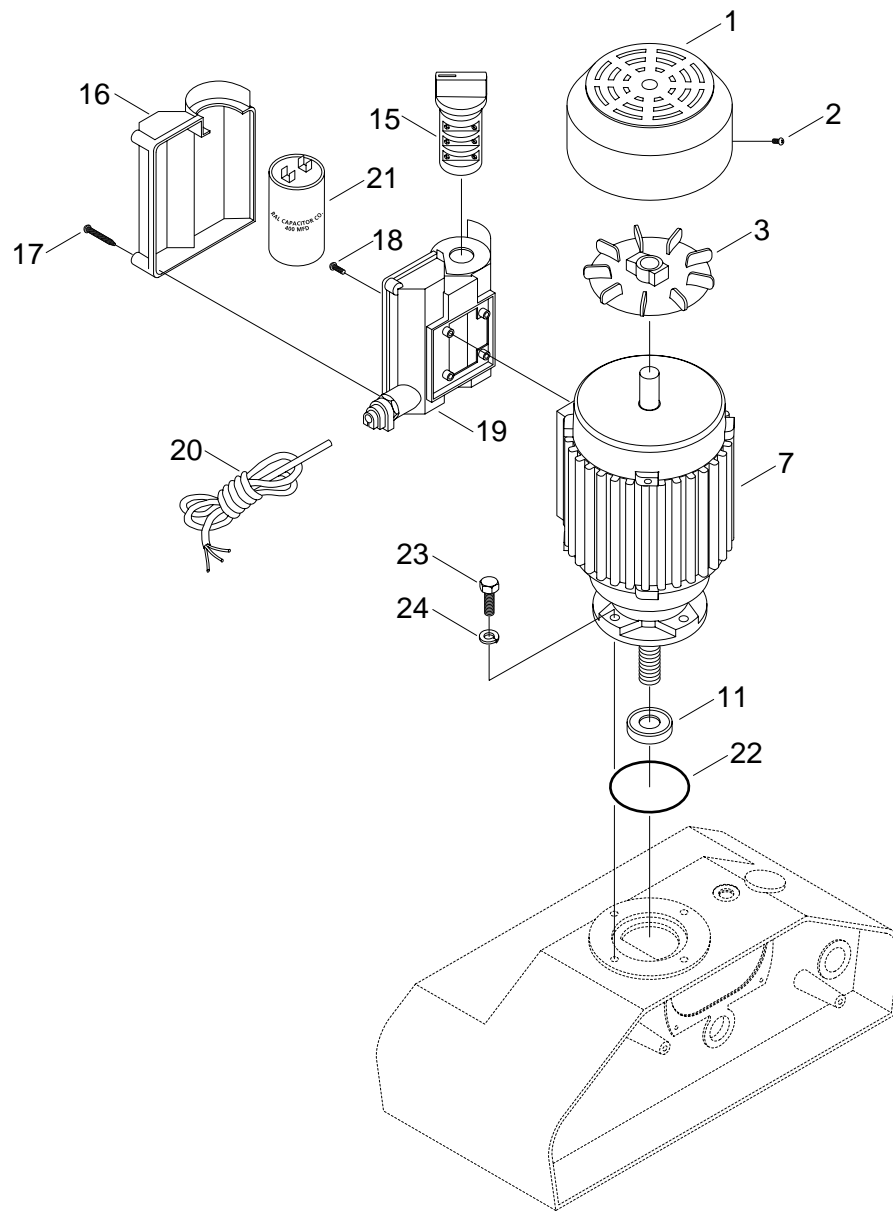
REF#	PART#	DESCRIPTION
20-3	P1128120-3	BALL 6mm
20-4	P1128120-4	SPRING
20-5	PSS17M	SETSCREW M8 - 1.25 x 6
21	PW06M	FLAT WASHER 12mm
22	P1128122	STUD
23	P1129123	BASE
24	PB33M	HEX BOLT M12 - 1.75 x 50
25	PLW05M	LOCK WASHER 12mm
26	P1128138	HANDLE ASSEMBLY
26-1	P1128126-1	HANDLE BODY
26-2	P1128138-1	HANDLE
27	PRP07M	ROLL PIN 6 x 20
28	P1129128	HORIZONTAL BRACKET
29	P1128129	LOCK STUD
30	P1129130	SWIVEL CASTING
31	P1129131	MOTOR CLAMP
32	PB22M	HEX BOLT M8 - 1.25 x 50
33	P1129133	STUD
34	PSB31M	CAP SCREW M8 - 1.25 x 25
35	PN03M	HEX NUT M8 - 1.25



# G1129 Base Type II

REF#	PART#	DESCRIPTION
010	P1128101	HANDLE ASSEMBLY
020	P1128102	HAND WHEEL
021	P1128021-1	HAND WHEEL
030	PRP31M	ROLL PIN 6 x 36
040	P1128104	BUSHING
060	P1128060-1	COLUMN CAP
070	PSS04M	SETSCREW M6-1.0 X 12
080	P1129080	ELEVATING SCREW
100	P1128110	ELEVATING KEY
120	PSB04M	CAP SCREW M6-1.0 X 10
130	PSB50M	CAP SCREW M5-0.8 X 10
140	P1129140	HORIZONTAL COLUMN
150	P1129150	RACK
160	P1129160	ELEVATING BRACKET
170	P1128170	PINION
180	P1128180	SPECIAL SETSCREW
190	P1129190	VERTICAL COLUMN
200	P1128120	HANDLE ASSEMBLY
201	P1128120-1	HANDLE

REF#	PART#	DESCRIPTION
202	P1128120-2	HANDLE BODY
203	P1128120-3	BALL
204	P1128120-4	SPRING
205	PSS17M	SETSCREW M8 - 1.25 X 6
210	PW06M	FLAT WASHER 12MM
220	P1128122	STUD
221	P1129221-1	STUD
230	G1137	BASE
240	PB33M	HEX BOLT M12 - 1.75 X 50
250	PLW05M	LOCK WASHER 12MM
261	P1128126-1	HANDLE BODY
270	PRP07M	ROLL PIN 6 X 20
280	P1129128	HORIZONTAL BRACKET
290	P1128129	LOCK STUD
300	P1129130	SWIVEL CASTING
310	P1129131	MOTOR CLAMP
320	PB22M	HEX BOLT
330	P1128122	STUD
340	PN01M	HEX NUT M6-1.0



# G1129 Motor

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REF#	PART#	DESCRIPTION
01	P1129201	FAN COVER
02	PS17M	PHLP HD SCRW M4 - 0.7 x 6
03	P1129203	FAN
07	P1129207	MOTOR 1 HP
11	P1129211	SEAL 30-52-10
15	P1129215	F/R SWITCH
16	P1128216	OUTER COVER
17	P1128217	SCREW
18	PS21M	PHLP HD SCRW M4 - 0.7 x 15
19	P1128219	INNER COVER
20	P1129220	POWER CORD
21	P1129221	CAPACITOR 35MFD
22	P1129222	O-RING
23	PB08M	HEX BOLT M8 - 1.25 x 20
24	PLW04M	LOCK WASHER 8mm

# TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	<ol style="list-style-type: none"> <li>1. Low voltage.</li> <li>2. Open circuit in motor or loose connections.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power line for proper voltage.</li> <li>2. Inspect all lead connections on motor for loose or open connections.</li> </ol>
Motor will not start; fuses or circuit breakers blow.	<ol style="list-style-type: none"> <li>1. Short circuit in line cord or plug.</li> <li>2. Short circuit in motor or loose connections.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect cord or plug for damaged insulation and shorted wires.</li> <li>2. Inspect all connections on motor for loose or shorted terminals or worn insulation.</li> <li>3. Install correct fuses or circuit breakers.</li> </ol>
Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals).	<ol style="list-style-type: none"> <li>1. Power line overloaded with lights, appliances, and other motors.</li> <li>2. Undersized wires or circuits too long.</li> <li>3. General overloading of power company facilities.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on power line.</li> <li>2. Increase wire sizes or reduce length of wire.</li> <li>3. Request a power check from the power company.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>1. Motor overloaded.</li> <li>2. Air circulation through the motor restricted.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on motor.</li> <li>2. Clean out motor to provide normal air circulation.</li> </ol>
Motor stalls (resulting in blown fuses or tripped circuit breaker).	<ol style="list-style-type: none"> <li>1. Short circuit in motor or loose connections.</li> <li>2. Low voltage.</li> <li>3. Incorrect fuses or circuit breakers in power line.</li> <li>4. Motor overloaded.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect connections on motor for loose or shorted terminals or worn insulation.</li> <li>2. Correct the low voltage conditions.</li> <li>3. Install correct fuses or circuit breakers.</li> <li>4. Reduce load on motor.</li> </ol>
Machine slows when operating.	Applying too much pressure to workpiece.	Feed workpiece slower.
Workpiece stalls, but wheels continue to turn.	<ol style="list-style-type: none"> <li>1. Excessive friction between workpiece and table.</li> <li>2. Insufficient friction between the rollers and workpiece.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean and wax the tabletop on a regular basis. Do not use silicone lubricants.</li> <li>2. Wipe sawdust from boards and wheels. Sand wheels slightly if they become glazed.</li> </ol>

# WARRANTY AND RETURNS

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Grizzly Imports, 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.