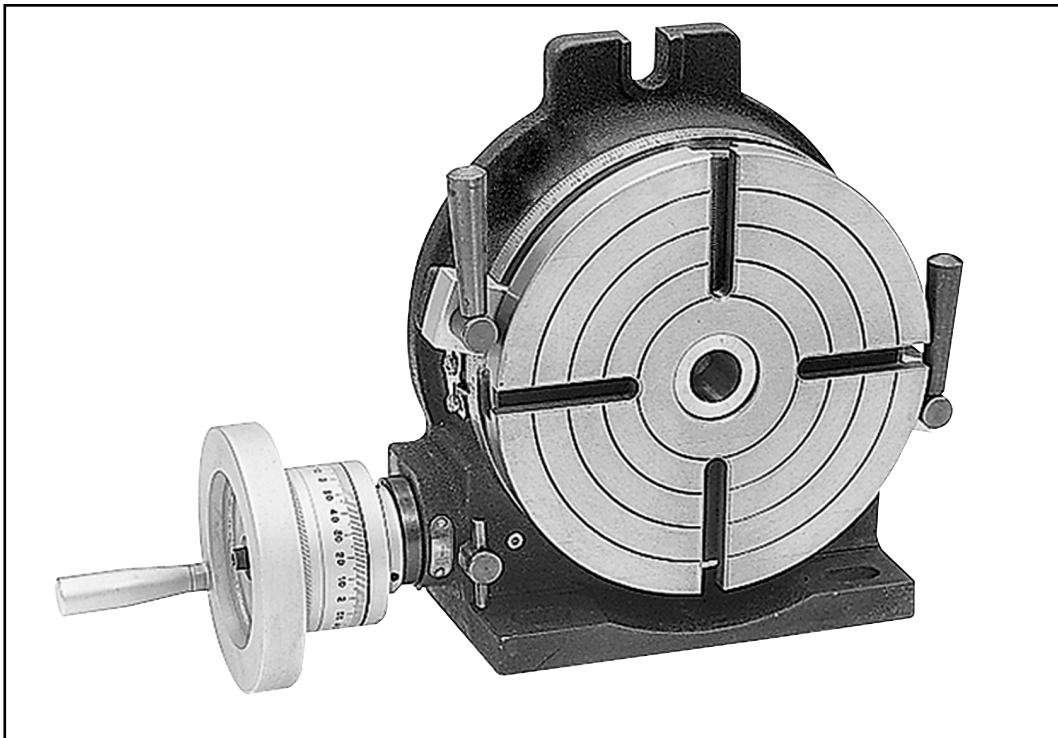




6" COMBINATION ROTARY TABLE MODEL G1049 INSTRUCTION MANUAL



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#5824 PRINTED IN TAIWAN

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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.



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



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



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment or property damage hazards.

WARNING

Safety Instructions For Metalworking Machines

1. **READ AND UNDERSTAND MACHINE OWNERS MANUAL FOR THIS EQUIPMENT.**
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 WORK SHOP 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 Metalworking 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.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use properly secured clamps or vises to hold work while performing the machining operation.
- 13. DO NOT OVER-REACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS AND MACHINERY 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 owner's 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 equipment. Make sure switch is in OFF position before reconnecting.

- 17. 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.

- 18. NEVER LEAVE MACHINE RUNNING UNATTENDED. TURN POWER OFF.** DO NOT leave machine until it comes to a complete stop.

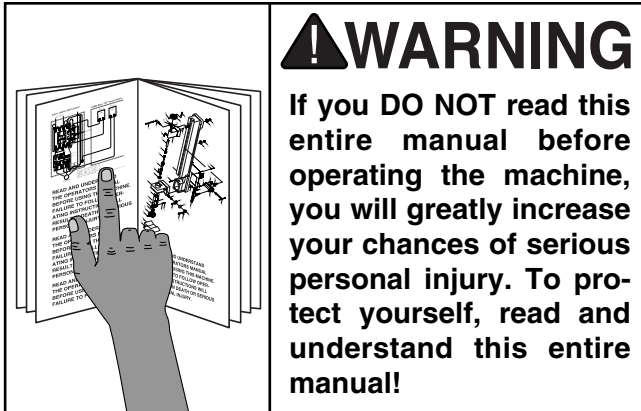
- 19. SOME COOLANTS USED FOR MACHINING MAY CONTAIN HAZARDOUS CHEMICALS.** Read and understand all user information on the coolant container and protect yourself accordingly.

- 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.

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 G1049 6" Combination Rotary Table. This rotary table is part of Grizzly's growing family of fine metalworking equipment. 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 G1049 6" Combination Rotary Table. 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>

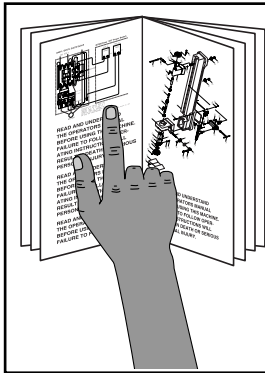
The specifications, drawings, and photographs illustrated in this manual represent the Model G1049 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we 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: SET UP

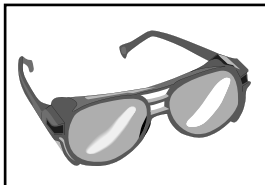
About this Section

The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.



!WARNING

This equipment presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before using the equipment



!WARNING

Wear safety glasses during the entire setup process!



Unpacking

The Model G1049 6" Combination Rotary Table was carefully packed when it left our warehouse. 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 your shipment, you should inventory its parts.



Piece Inventory

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

- 6" Combination Rotary Table
- Handwheel Crank Handle
- Handwheel

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.

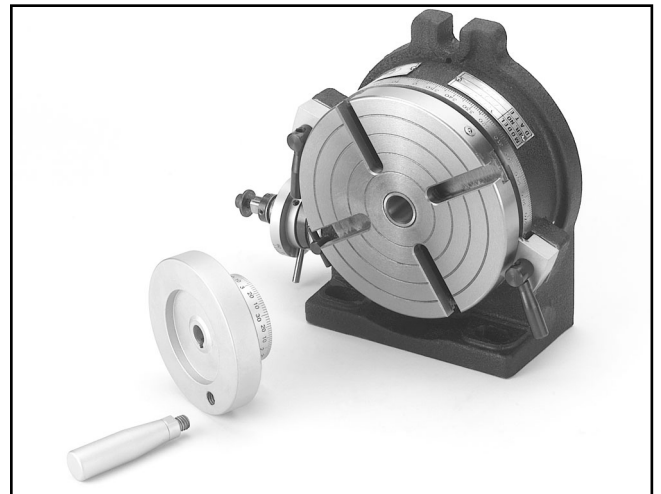


Figure 1. Piece inventory from packing box.



Installation

Before installing the Model G1049 6" Combination Rotary Table, make sure that your mill table and spindle are aligned correctly as described in your milling machine instruction manual.

To install your Model G1049 onto your mill table:

1. **Disconnect power to the milling machine before installing the rotary table.**
2. Position the 1/2" T-bolt slots on the rotary table over the T-slots in the milling table.
3. Insert the T-slot nuts into the milling table grooves.
4. Secure the rotary table in place. It is important to secure the rotary table to the mill table in a very strong and solid set up. This will help with accuracy, efficiency and general safety.

Note—The T-slots for the rotary table are 2" between centers. You will need to have the same distance between centers on your milling table to be able to use T-nuts and bolts. If your milling table has different T-slot centers, you will need to incorporate step blocks or clamps to secure the rotary table.

NOTICE

Make sure the rotary table handle is free of any obstruction. Depending on your setup in the vertical or horizontal positions, the rotary table may have to be blocked up or mounted so the handle is hanging over the edge of the milling table. Once making a setup, check for any possible obstructions that may interfere with rotary table handle.

CAUTION

Make sure the rotary table is secured to the milling table. Check the T-slot clamps before each cutting operation. If rotary table is not secured, serious personal injury and damage to your mill and rotary table could result.



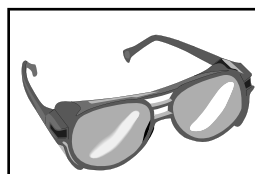
Alignment

Aligning the center of the rotary table to the spindle is essential for achieving quality results.

There are many ways to align the Model G1049 to a vertical mill spindle. It is up to the machinist and his capabilities to decide which approach is best.

Here are a couple of ways to align the spindle accurately to the center of the rotary table:

1. Using a test indicator, (see Models G9610, G9611 & G9612 in the current Grizzly catalog) indicate the inside or the outside of the rotary table. Position the spindle over center of the rotary table and touch all four sides (inside or outside) until all sides read "0" on the indicator (remember to rotate the spindle and not the rotary table). Using this procedure of indicating, no measuring tools are needed.



WARNING

Wear safety glasses during the entire setup process!

2. Use an edge finder, like the Model H2939, to locate the center of the rotary table by contacting two outside edges (**Figure 2**) and then moving the mill table half of the rotary table diameter in both directions. Note—*Make sure to account for radius of the edge finder and use a precision measuring instrument when determining the diameter of the rotary table.*

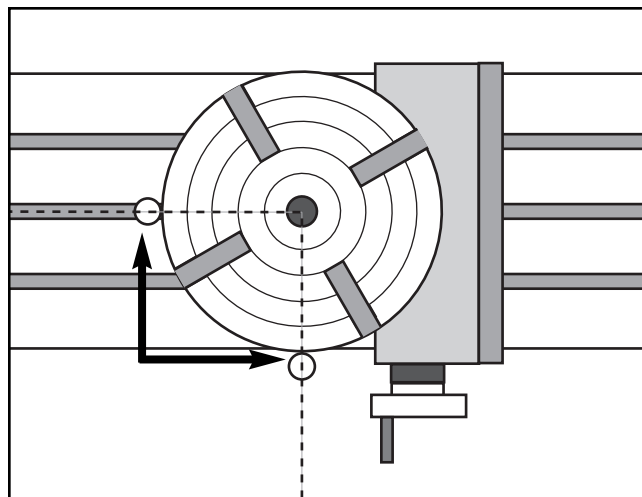


Figure 2. Locations for edge finding.



SECTION 4: OPERATIONS

Operation Safety

Your safety is important! Please follow the warnings below:

WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a respirator and hearing protection while using this equipment. Make sure proper filter is worn while wearing respirator.



WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from moving machinery.



NOTICE

The following section was designed to give instructions on the basic operations of this equipment. However, it is in no way comprehensive of all of the equipment applications. WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training to maximize the potential of your equipment.

Table Movement

The rotary table moves by turning the handwheel which engages a precision worm gear. The worm gear ratio is 1:90. One complete turn of the handwheel moves the table 4 degrees. The micro collar is graduated in steps of 1 minute and the vernier scale can be set to indicate to 20 seconds.

Basic Example:

You are making a flange and you need to index six holes for the bolt pattern:

$$\text{Crank turns} = \frac{90}{N}$$

N = the desired division number (6).

$$\frac{90}{6} = 15 \text{ full crank turns}$$

1. Turn the handwheel before making the first hole to take up any play in the worm gears.
2. Make your first hole then turn the crank 15 times. *Note—When you are cranking to a desired number and crank too far, do not just immediately back up to the number. You must back up one revolution then dial back to desired number. Then lock the table in place to locate the second hole. This procedure eliminates backlash in the worm gear.*
3. Repeat **step 2** for the remaining holes.



Rotary Table Maintenance

Keep oiled to prevent rust. Do not use air to blow off chips. A few drops of oil before each use will prevent excessive wear. The worm gear is greased at the factory.



FEATURES & CONTROLS

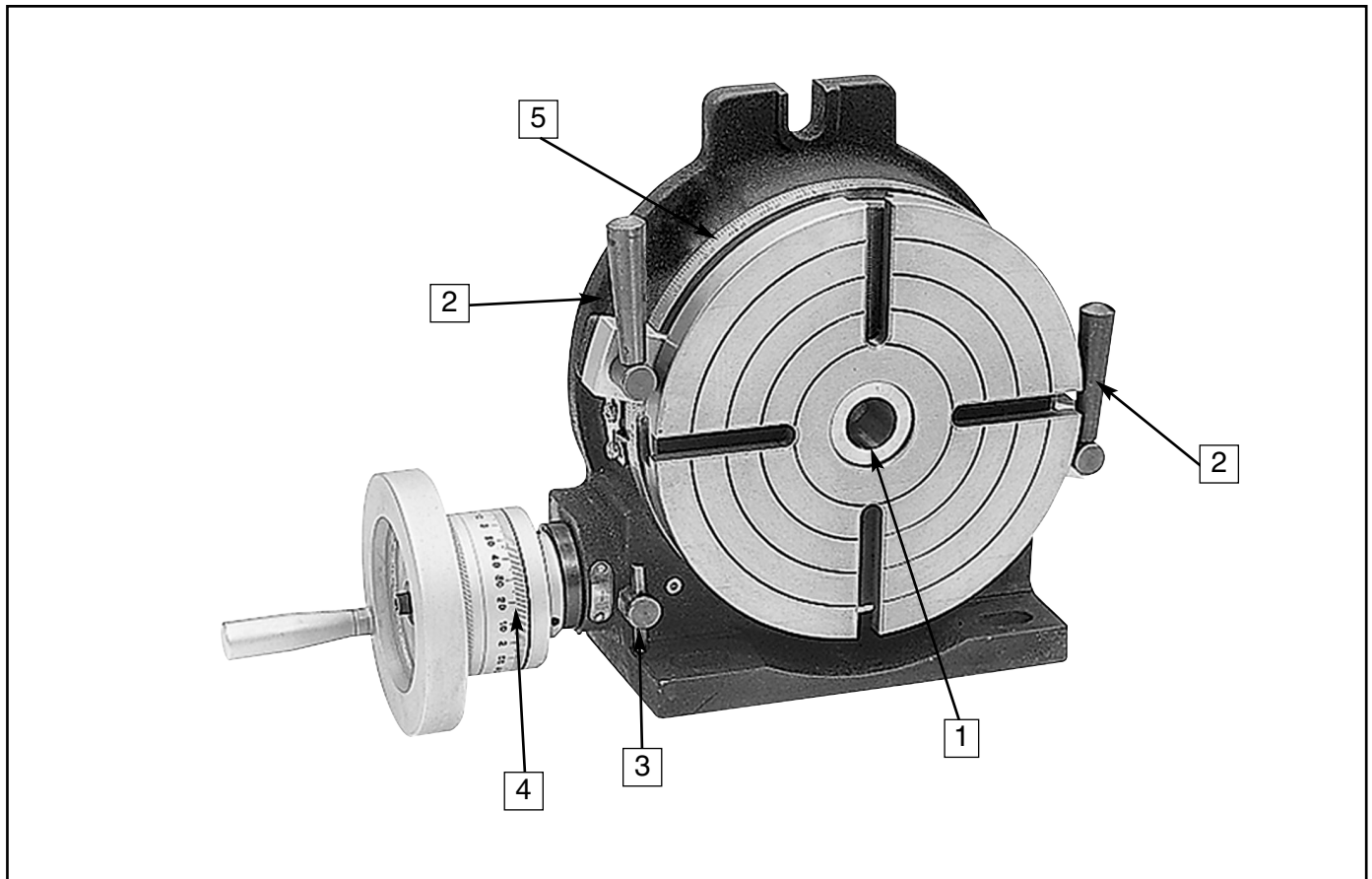


Figure 3. Main view of rotary table features .

Main Features

1. **MT#2**—Used for quick setups by placing a dead center into the taper and aligning centers, picking up hole centers, ect and just general machining operations.
2. **Rotary Table Lock**—Used during milling operations to lock the table solid. This feature keeps the stresses of the milling operations off of the wormgear to extend the life of the rotary table and ensure that accuracy is not compromised. Simply tighten the handles to lock the table.
3. **Free Wheeling**—This is a convience feature which allows the operator to rotate the table by hand and not having to turn the crank handle. just loosen the lock handle (#3) and rotate the adjustment ring (#6) C.W. By rotating the adjustment ring, this disengages the wormgear and allows the table to rotate.
4. **Vernier Scale**—Allows precise rotary movements. The vernier scale allows graduations of 20" seconds.
5. **Gross Scale**—This scale will allow you keep track of where the rotary table is going and where its been. The scale reads from 0° - 360° in one degree graduations.



Vernier Scale

The model G1049 comes supplied with a direct reading scale marked in whole degrees along the edge of the table as well as the handwheel dial marked with whole degrees with divisions in minutes. Graduations of 20 seconds can be extracted using the vernier scale.

When the handwheel is rotated clockwise those markers to the left of the "0" on the vernier scale are used. When the handwheel is rotated counterclockwise those on the right hand side are used.

We will be setting the table to $16^{\circ} 42' 20''$ in the example below. This exercise assumes the table position starts at 0° , as read along the edge of the table and the "0" on the handwheel dial and the "0" on the stationary vernier scale are aligned.

1. Rotate the handwheel 4 times in the clockwise direction. Watch for the "0" marker on the dial and slow down the rotation as the "0" comes into view the 4th time.
2. Rotate the dial clockwise 2 graduations past the second "10" (42°) and align with the "0". Be careful not to let the handwheel turn any further!

It is important to understand that the graduations-between each degree on the handwheel dial are marked in 10's of minutes and marked as 10, 20, 30, 10, 20 and then the next whole degree. To get 42 minutes in our example we simply added 12 to the 30 minute marker.

3. Finally, rotate the handle until the next nearest mark aligns with the 20 second mark on the left hand side of the zero on the vernier scale. It is important the handwheel is not rotated past this point. If it is you must rotate it counterclockwise one full turn and "sneak" up on the mark again. Once satisfied with the table position lock it in place with the table locks.

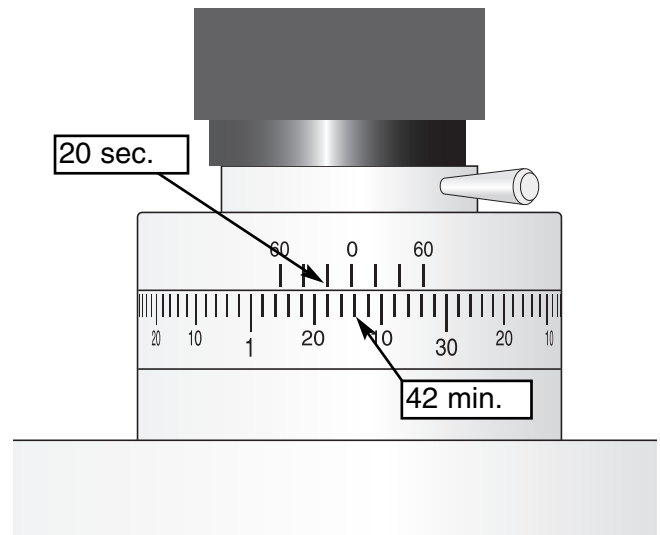


Figure 4. This dial reads $0^{\circ} 42$ minutes and 20 seconds.



Tailstock

Grizzly offers the Model G1763 Tailstock for the G1049 Rotary Table. This tailstock allows the operator to support larger workpieces that normally cannot be supported while maintaining a high level of accuracy. The tailstock is manageable, easy to use and can be found in the Grizzly catalog or at Grizzly's website, www.grizzly.com.

To install the Model G1763 Tailstock to your milling table:

1. Secure the Model G1049 Rotary Table in the vertical position on the milling table.
2. Install the tailstock onto the milling table so the dead center of the tailstock is inline with the center of the rotary table. Slots are provided for keys to help with alignment of centers. The alignment of the Y and Z axes are shown in **Figures 5 & 6**.

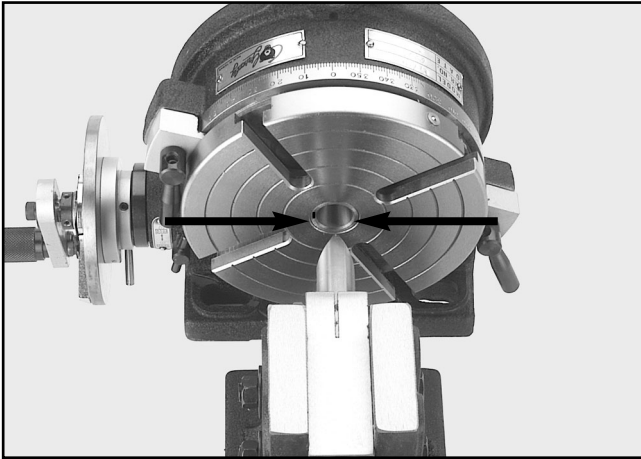


Figure 5. Alignment of Y axis.

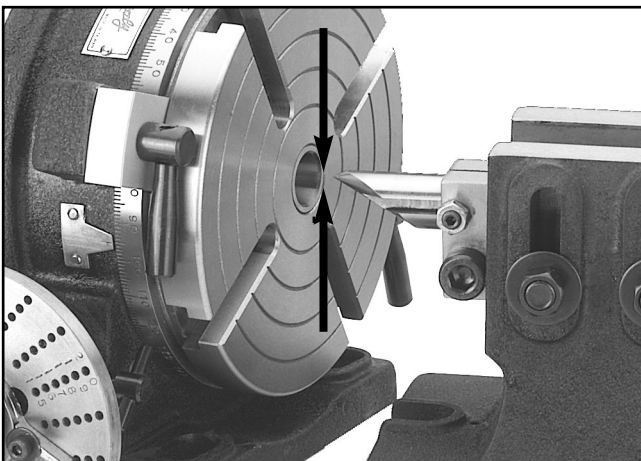


Figure 6. Alignment of Z axis.

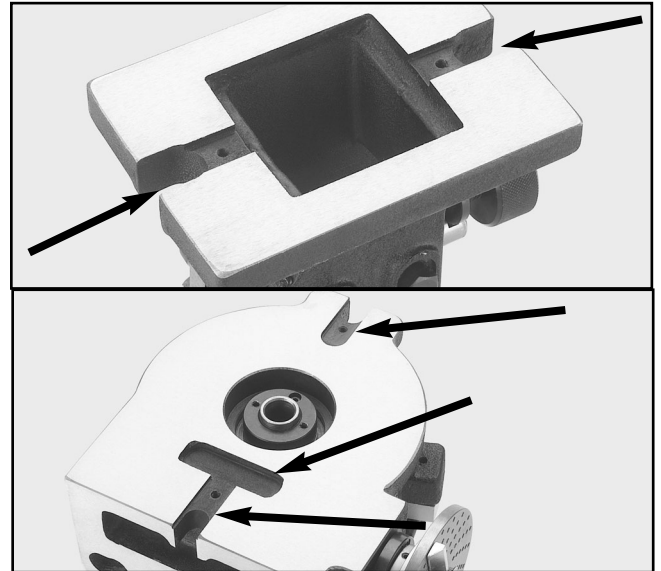


Figure 7. Key placement.

3. Align the dead center of the tailstock by loosening the hex bolts located on the side of the tailstock. With a precision level or indicator (depending on tolerance of work being performed), make the dead center parallel to the horizontal plane and on center with rotary table center.

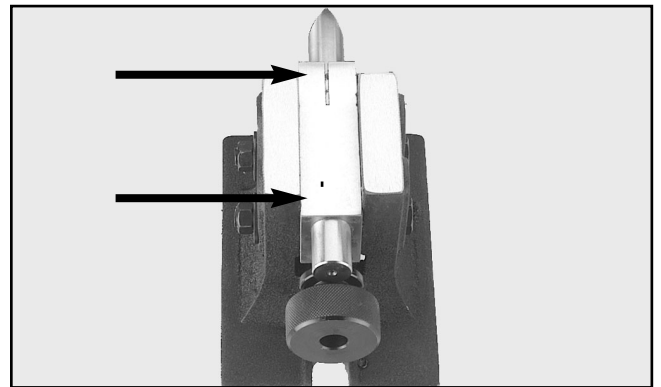


Figure 8. Indicating surface.

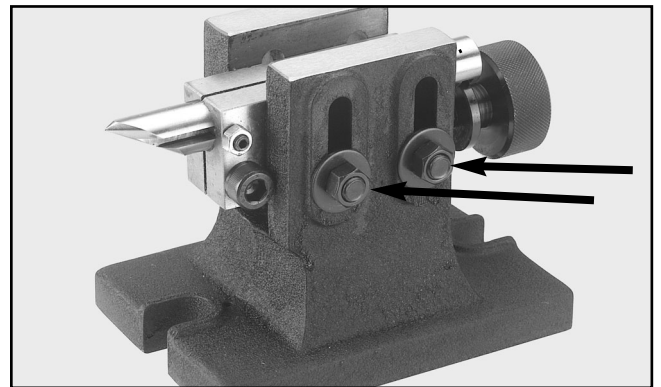


Figure 9. Adjustment hex bolts

Dividing Plates

Grizzly offers the Model G1760 Dividing Plates for this rotary table. These dividing plates can be installed to achieve a higher precision of hole placement, spot facing and gear making. These dividing plates can be found in the Grizzly catalog or at Grizzly's website, www.grizzly.com.

This dividing plate assembly is extremely easy to use and setup, but we recommend that you refer to the Index table in the instruction sheet that comes with the G1760 to index complex patterns.

Piece inventory

1. 3 Dividing Plates
2. Crank Handle & Index Pin
3. 2 Piece Sector Arm Assembly w/Set Screw
4. Sector Spring
5. Allen Wrench

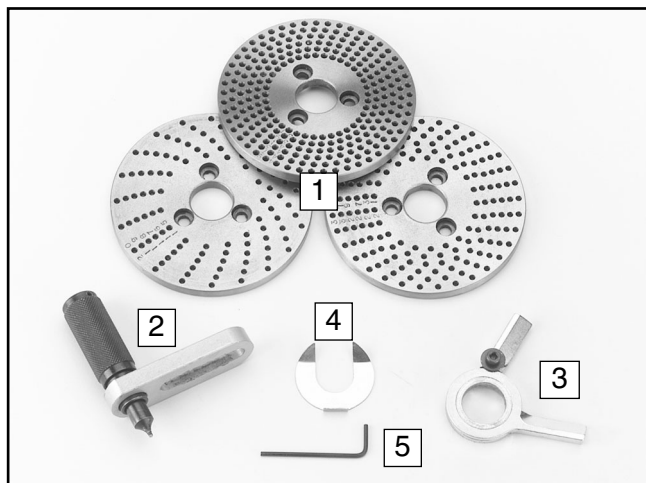
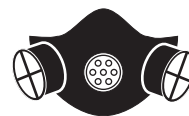


Figure 10. Dividing plate parts.

⚠ WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a respirator and hearing protection while using this equipment. Make sure proper filter is worn while wearing respirator.



⚠ WARNING



Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from moving machinery.

To install the Model G1760 Dividing Plate:

1. Remove the crank handle cap screw as shown in **Figures 11 & 12**.
2. Gently tap the crank handle off the shaft with a rubber mallet.
3. Insert the dividing plate with the holes facing out and secure it with the provided screw.
4. Place the sector arm assembly over the shaft, followed by the sector spring.
5. Install the crank handle with the indexing pin and secure it with the cap screw removed in **step 1**.

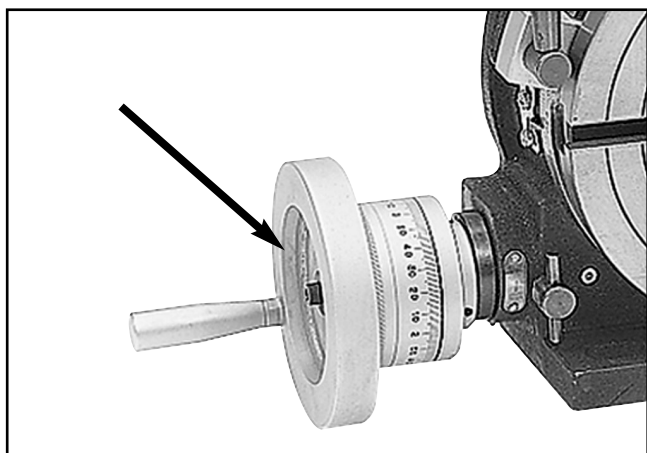


Figure 11. Crank handle cap screw.

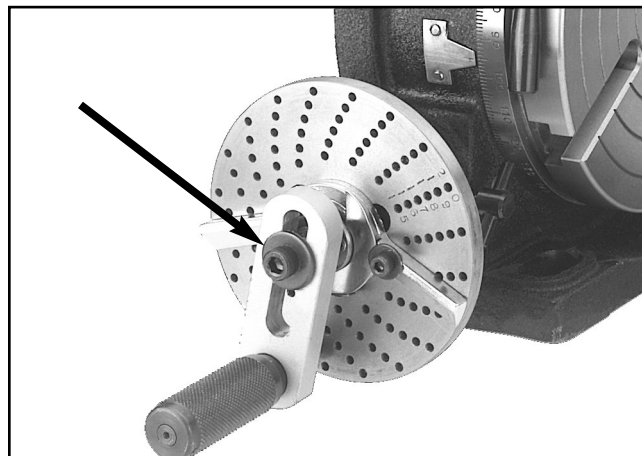
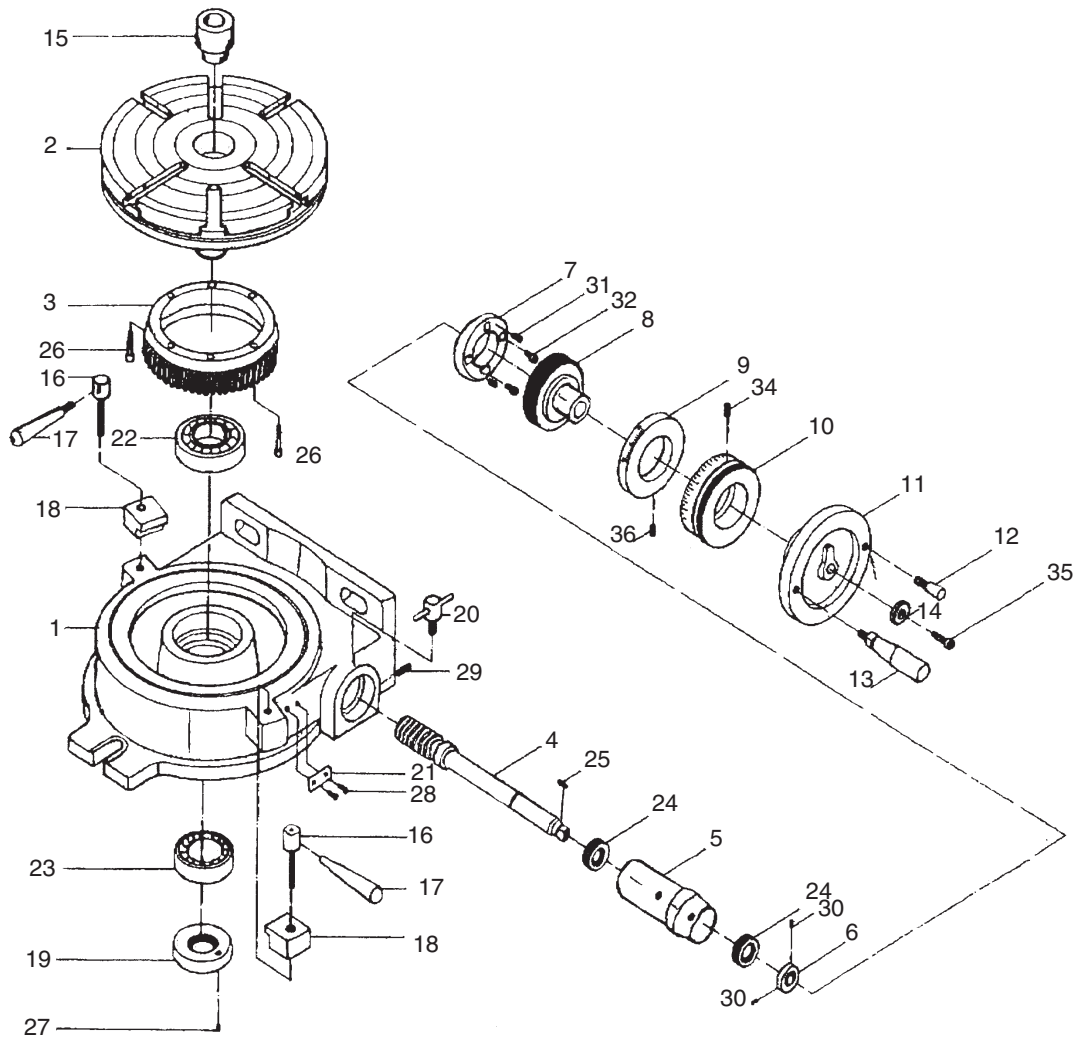


Figure 12. Completed assembly with dividing plates.



G1049 6" Rotary Table Parts Breakdown



G1049 6" Rotary Table Parts List

REF	PART #	DESCRIPTION
1	P1049001	MAIN BODY
2	P1049002	TABLE
3	P1049003	WORM GEAR
4	P1049004	WORM SHAFT
5	P1049005	ECCENTRIC HOUSING
6	P1049006	LOCK COLLAR
7	P1049007	HOLDING COVER
8	P1049008	ADJUSTMENT RING
9	P1049009	VERNIER RING
10	P1049010	MICRO COLLAR
11	P1049011	HANDWHEEL
12	P1049012	SMALL HANDLE
13	P1049013	HANDLE
14	P1049014	SPACER
15	P1049015	BUSHING
16	P1049016	CLAMP BOLT
17	P1049017	CLAMP HANDLE
18	P1049018	CLAMP

REF	PART #	DESCRIPTION
19	P1049019	LOCK NUT
20	P1049020	LOCK HANDLE
21	P1049021	POINTER
22	P1049022	BEARING 30 X 45 X 20T
23	P1049023	BEARING 25 X 42 X 4T
24	P1049024	SPACER
25	PK65M	KEY 4 X 4 X 7MM
26	PSB15M	CAP SCREW M5-.8 X 20
27	PSB18M	CAP SCREW M4-.7 X 8
28	P4000809	RIVET 2 X 5
29	PSS50M	SET SCREW M4-.7 X 20
30	PSS08M	SET SCREW M4-.7 X 5
31	PSS08M	SET SCREW M4-.7 X 5
32	PSB08M	CAP SCREW M4-.7 X 13
34	PSS07M	SET SCREW M5-.8 X 5
35	PSB27M	CAP SCREW M6-1. X 14
36	PSS07M	SET SCREW M5-.8 X 5

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: _____

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