

MODEL G0474 20-GALLON & G0475 10-GALLON SANDBLASTER OWNER'S MANUAL



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Some dust created by power sanding, sawing,

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 chemical are:

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

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

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INTRODUCTION

Foreword

We are proud to offer the Model G0474/G0475 Sandblasters. This equipment is a part of a growing Grizzly family of fine wood and metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0474/G0475. It was written to guide you through assembly, review safety considerations, and cover general operating procedures.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0474/G0475 as supplied when the manual was prepared. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your equipment will be reflected in these manuals as soon as they are complete.

Contact Info

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

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

We stand behind our equipments. If you have any service questions or parts requests, please call or write 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



MACHINE DATA SHEET

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

MODEL G0475 SANDBLASTER

Design Type General Specifications:	Portable Floor Model
Width	
Height	34-1/2"
Depth	20"
Operating Air Pressure Range	65-125 PSI
Recommended Air Supply	6-25 CFM
Hose Length	10 ft.
Tank Size	10 gal.
Abrasive Capacity	40 lbs.
Abrasive Type	Dry Only
Weight	40 lbs

MODEL G0474 SANDBLASTER

Design Type	Portable Floor Model
General Specifications:	
Width	
Height	35-1/2"
Depth	27-1/2"
Operating Air Pressure Range	65-125 PSI
Recommended Air Supply	6-25 CFM
Hose Length	10 ft.
Tank Size	20 gal.
Abrasive Capacity	80 lbs.
Abrasive Type	Dry Only
Weight	

Specifications, while deemed accurate, are not guaranteed.



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

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words 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.

AWARNING 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. 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.

AWARNING Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY. Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST. Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.

- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY. Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL. Be mentally alert at all times when running equipment.

AWARNING Safety Instructions for Machinery

- 7. ONLY ALLOW TRAINED AND PROP-ERLY SUPERVISED PERSONNEL TO OPERATE EQUIPMENT. Make sure operation instructions are safe and clearly understood.
- 8. KEEP CHILDREN AND VISITORS AWAY. Keep all children and visitors a safe distance from the work area.
- 9. MAKE WORKSHOP CHILD PROOF. Use padlocks, master switches, and remove start switch keys.
- **10. NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power *OFF* and allow all moving parts to come to a complete stop before leaving equipment unattended.
- 11. DO NOT USE IN DANGEROUS ENVIRONMENTS. DO NOT use this equipment in damp, wet locations, or where any flammable or noxious fumes may exist.
- 12. KEEP WORK AREA CLEAN AND WELL LIT. Clutter and dark shadows may cause accidents.
- 13. USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE. Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V equipment.
- 14. ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY. Make sure switch is in OFF position before reconnecting.
- **15. MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- 16. MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.
 17. DEMOVE AD UISTING KEYS AND
- 17. REMOVE ADJUSTING KEYS AND

WRENCHES. Make a habit of checking for keys and adjusting wrenches before turning equipment *ON*.

- 18. CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY. Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect equipment operation. Repair or replace damaged parts.
- **19. USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
- **20. DO NOT FORCE MACHINERY.** Work at the speed for which the equipment or accessory was designed.
- 21. SECURE WORKPIECE. Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the equipment.
- 22. DO NOT OVERREACH. Keep proper footing and balance at all times.
- 23. MANY MACHINES CAN EJECT THE WORKPIECE TOWARD THE OPERATOR. Know and avoid conditions that cause the workpiece to "kickback."
- 24. ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.
- 25. BE AWARE THAT CERTAIN DUST MAY CAUSE AN ALLERGIC REACTION in people and animals, especially when exposed to fine dust. Make sure you know what type of dust you will be exposed to and always wear an approved respirator.



Additional Safety Instructions for Sandblasters

- 1. CORRECT ABRASIVES. Never use wet abrasives in this sandblaster, it is designed for dry abrasives only.
- 2. **PROTECTING LUNGS.** Make sure that you always use an OSHA approved respirator when using or cleaning the sandblaster.
- **3. LEAVING THE AREA.** Always disconnect air supply when leaving the sandblaster.
- 4. **PROTECTING EYES.** Make sure that you always use the dust hood when using or cleaning the sandblaster.
- 5. **PROTECTING ENVIRONMENT.** Always sandblast in an area where the spread of abrasive dust can be contained.
- 6. WORK AREA SAFETY. Clean compressor and equipment air filters often, and repair any air hose leaks immediately.
- 7. MAINTAINING COMPONENTS. Replace nozzles, hoses, lenses, and safety gear when they become worn.

- 8. MAINTAINING EQUIPMENT. Check air lines and fittings for any leaks, and replace lines and reseal fittings immediately.
- 9. SAFE SAND BLASTING. Do not use system over the rated PSI.
- **10. CORRECT LIGHTING.** Always make sure that you have adequate lighting when sandblasting.
- **11. LOADING & UNLOADING.** Close the air supply ball valve and discharge the air tank before disconnecting the air supply line.
- **12. SAFE MAINTENANCE.** Disconnect air supply and discharge the air tank and all lines before doing maintenance.
- **13. SAFE SANDBLASTING.** Always secure the workpiece before sandblasting.

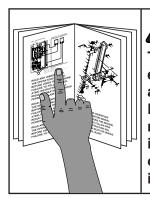
AWARNING

There is potential danger when operating this equipment. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this equipment with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

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 equipment with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: SET UP

Set Up Safety



WARNING

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

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your equipment:

Description

•	Phillips Screwdriver #2	. 1
•	Standard Screwdriver #2	. 1
•	Teflon Tape	. 1
•	Wrench 10mm	. 1
•	Wrench 17mm	. 1
•	Wrench 22mm	1

Unpacking

The Model G0474/G0475 was carefully packed when it left our warehouse. If you discover the equipment 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.*

Compressor

Sandblasting operations are extremely demanding on some compressors and can cause a compressor overload or overheated condition. Refer to your compressor Owner's Manual and make sure that it can handle the load of sandblasting. If it can, you must follow these setup recommendations:

We recommend using a compressor that is 5 HP and above with a minimum of a 12 CFM rating.

Keep your compressor completely isolated from your sandblasting environment, or keep the work area downwind from the compressor. Airborne abrasive dust will destroy rings, pistons, valves, and bearings.

Make sure to increase the maintenance interval of your compressor if using it in sandblasting operations.



Qty

Assembly

To assemble the sandblaster:

1. Install the wheels, handles, and leg to the tank with the screws, washers, nuts, and cotter pins as shown in **Figure 1**.

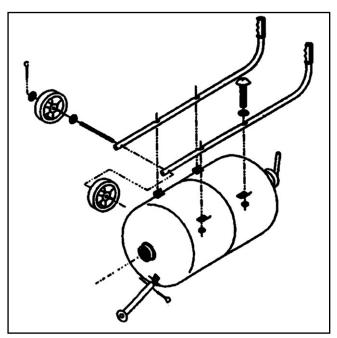


Figure 1. Wheel and handle installation.

 Seal all pipe threads with Teflon tape, and assemble and install one of the four ball valves to the bottom of the tank with two ³/₈" nipples, and the sand outlet elbow as shown in Figure 2.

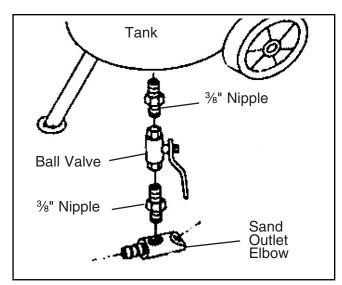


Figure 2. Sand outlet control installation.

- **3.** Assemble one of the remaining three ball valves with a ³/₈" hose nipple, and the nozzle arbor as shown in **Figure 3**.
- 4. Install one of four sand blasting nozzles into the nozzle arbor as shown in **Figure 3**.

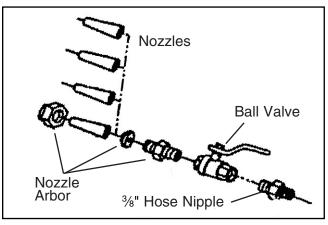


Figure 3. Sand blaster handle and nozzle assembly.

5. With the two hose clamps, secure the sandblaster hose to the sand outlet elbow and the sand blaster nozzle assembly as shown in **Figure 4**.

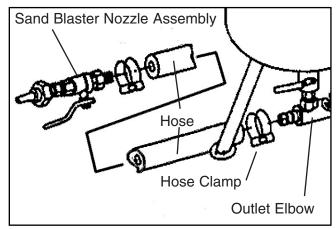


Figure 4. Sand blaster hose installation.



6. Attach to the manifold one of the remaining ball valves and ³/₈" hose nipple, the red hose, pressure gauge, and the pipe as shown in **Figure 5**.

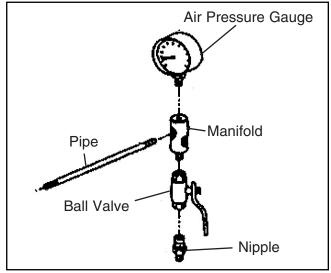


Figure 5. Gauge/air supply control installation.

 Install the remaining ball valve to the water separator with two ³/₈" nipples, and the ³/₈" female nipple as shown in Figure 6.

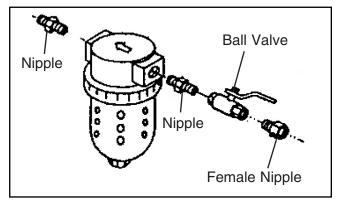


Figure 6. Water separator assembly.

- 8. Connect the water separator assembly to the air supply Manifold as shown in **Figure 7**.
- 9. Now connect the gauge and water separator assembly to the top of the tank as shown in **Figure 7**.

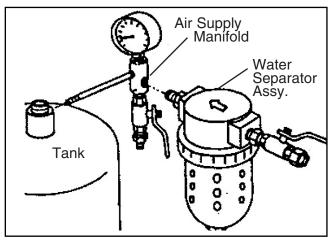


Figure 7. Air supply control system installation.

10. Connect the tank air supply hose to the sand outlet elbow at the bottom of the tank, and the other end to the air pressure gauge ball valve nipple.



SECTION 3: OPERATIONS

Sandblasting presents a real hazard of silicosis and other lung contamination injuries! These Injuries are permanent and can get worse over time. If you use sandblasting equipment without the proper headgear, eye protection, and respirator, your lungs and eyes may become irreversibly contaminated. DO NOT use this sandblaster unless you know how to use it, protect yourself correctly, and keep all unprotected bystanders away. For latest types of protective equipment and acceptable respirator types, contact your local OSHA or NIOSH office.

Operation Safety

NOTICE

If you have never used this type of equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Basic Operation

The Model G0474/G0475 Sandblasters are equipped with an industrial-duty blast nozzle, tank, ball valves, hoses, pressure gauge, and water separator.

To use the sandblaster:

- 1. PUT ON safety glasses, gloves, and respirator. Always wear these protective items when operating and while servicing your sandblaster!
- 2. Select the appropriate sanblasting abrasive for your sandblaster. Refer to **Page 13** for types.
- **3.** Install the correct nozzle into the arbor for the abrasive type hose size, air pressure and CFM you will use. Refer to **Page 13** for options.

4. Move the tank air supply lever to the *OFF* or closed position (see **Figure 8**).



Figure 8. Tank air supply valve, closed.

5. Move the blast hose air supply lever to the *OFF* or the closed position (see **Figure 9**).



Figure 9. Blast hose air supply valve, closed.

- 6. Point the blast nozzle in a safe direction, and slowly move the blast nozzle lever to the *ON* or open position to exhaust any air from the tank (see **Figure 10**).
- 7. Make sure the air pressure gauge reads zero (see Figure 10).

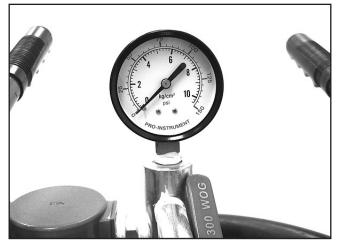


Figure 10. Tank air pressure at zero PSI.

8. Remove the filler cap, insert the funnel, and carefully—without causing a hazardous dust cloud—pour or spade-in the abrasive into the sandblaster. Use only enough abrasive for your project.

Note: For the Model G0475 10 gallon tank, you can use up to 40 lbs of abrasive, or you can fill the tank to $\frac{3}{4}$ full. The Model G0474 20 gallon tank can use up to 80 lbs of abrasive, or be filled to $\frac{3}{4}$ also.

Note: If you fill the tank to ³/₄ full, and the local humidity is 90-100%, the water trap will not be able to trap all of the moisture from the compressed air. So you must reduce the load of abrasive and fill the tank more often and empty the water trap more often. Otherwise, the sand will clog in the tank outlet and in the blast hose.

9. Brush sand away from the sealing cap and O-ring, and close the filler cap.

10. Close the blast nozzle lever, and turn the compressor on (see **Figure 11**).



Figure 11. Blast nozzle valve, closed.

- **11.** Adjust the air supply line regulator to an air pressure between 65-125 PSI, depending on your requirements.
- **12.** Move the tank air supply lever to **ON** or the open position (**Figure 12**), and the tank will pressurize to your regulated air pressure indicated by the tank gauge.

Note: If the tank relief valve trips open and exhausts air, immediately turn the compressor off and correct the over-pressurization problem with the compressor. If the tank exceeds its rated pressure, it may explode, causing severe injury or death.



Figure 12. Tank air supply valve, opened.



13. Move the blast nozzle air supply lever to *ON* or the open position (see **Figure 13**).



Figure 13. Blast nozzle air supply valve, opened.

14. Move the sand metering valve lever to your required sand flow volume requirement (see **Figure 14**).



Figure 14. Sand metering valve in the full-open position.

15. Point the blast nozzle at the workpiece and slowly move the blast nozzle lever (Figure 15) to the *ON* or open position. Sand blasting will begin.



Figure 15. Blast nozzle valve, open.

16. Move the blast nozzle in a slow circular motion.

Note: A good starting point for tip distance is four inches away from the workpiece. Start out with a low air pressure setting to avoid excess peening and abrasive wear.

Note: *Experiment with different pressures, abrasives, sand flow, and tips to gain practical experience.*

Note: Keep the sandblasting abrasives moisture-free; otherwise, the sand elbow and the sand flow valve at the bottom of the tank will clog frequently.

17. When sandblasting is complete, ALWAYS close the air supply lever before you disconnect the air supply line. Otherwise the residual air in the tank will expel sand backwards through the water separator and out of the air supply fitting, damaging the water separator.

Grizzly Blasting Media Part

G6535: 15 lbs. Aluminum Oxide 220 Grit. **G6536:** 15 lbs. Aluminum Oxide 120 Grit. **G6537:** 15 lbs. Aluminum Oxide 60 Grit. **G6538:** 15 lbs. Glass Bead 50-Micron Grit.

Some common blasting abrasives are listed below. All abrasives have benefits and drawbacks such as quality of surface finish, abrasive life, toxicity, and what precautions you must take to prevent environmental damage or personal injury to your respiratory system.

Steel Type Abrasives

This aggressive abrasive creates a rough finish that accepts paint well. The abrasive is very durable and has a long life; however, it MUST be kept very dry to prevent rusting.

Alumina Type Abrasives

This multi-purpose abrasive creates a smoother finish than the steel abrasives, but has a shorter life span. Less of the workpiece surface is removed with this more forgiving abrasive.

Glass and Garnet Type Abrasives

Typically this abrasive works well for soft metals and addressing surface issues with equipment parts where tolerances cannot be affected. The life of this abrasive is limited and not well suited for repetitive recycling.

Sand Type Abrasives

This abrasive is easy to find and gives an average finish that is acceptable for most projects. Sand has a good recycling life and is very economical.

Other Types of Abrasives Available

Plastic beads. Ground walnut or peanut shells. Ground corn cob. Sodium bicarbonate. Wheat starch.

Grizzly Blast Nozzles Part

P0574002: Nozzle Set (%4",1/8",7/64",3/32" ID). P0574002-1: #1 Nozzle (%4" ID). P0574002-2: #2 Nozzle (1/8" ID). P0574002-3: #3 Nozzle (7/64" ID). P0574002-4: #4 Nozzle (3/32" ID).

Sandblasting requires a high volume of compressed air. The quality of sandblasting can be reduced by using the incorrect combination of nozzle, hose size, air pressure and CFM. Use the chart below as an estimate to get you started. Experimentation will lead you to your optimum settings for your particular sandblasting task.

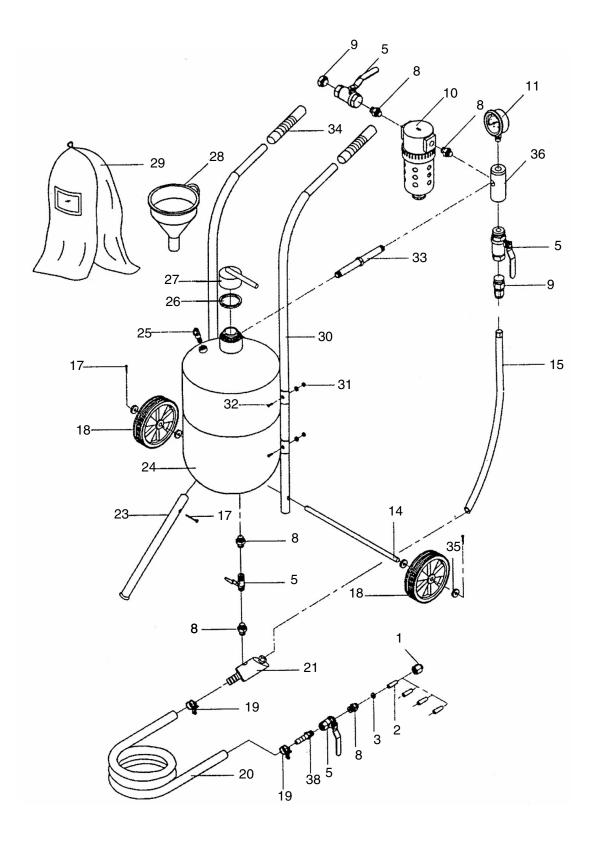
Hose	Hose	Nozzle	Compressor	CFM at	Sand Use
ID	Length	ID	HP	125 PSI	Per-Hour
3/8"	50 ft	3/32"	2	6	60 lbs
3/8"	25 ft	7/64"	4	12	100 lbs
1/2"	50 ft	1/8"	7	20	150 lbs
1/2"	25 ft	9/64"	10	25	200 lbs

Maintenance

Depressurize the sandblaster, and check the following items each time you use the sandblaster and replace any parts immediately if found to be worn:

- Look for excessively worn or cracked nozzles.
- Look for leaking thread fittings with soapy water and a spray bottle.
- Look at the sand blasting hose for thin walls and bubbling.
- Look for worn or leaking ball valves with soapy water and a spray bottle.

Parts Breakdown



Parts List

REF	PART #	DESCRIPTION
1	P0474001	NOZZLE ARBOR NUT
2	P0474002	NOZZLE SET
2-1	P0474002-1	9/64" NOZZLE
2-2	P0474002-2	1/8" NOZZLE
2-3	P0474002-3	7/64" NOZZLE
2-4	P0474002-4	3/32" NOZZLE
3	P0474003	GASKET
5	P0474005	3/8" BALL VALVE
8	P0474008	NOZZLE ARBOR
9	P0474009	3/8" FEMALE CONNECTOR
10	P0474010	WATER TRAP FILTER
11	P0474011	PRESSURE GAUGE
14	P0474014	AXLE
15	P0474015	AIR HOSE
17	P0474017	1/8" X 1" COTTER PIN
18	P0474018	WHEEL
19	P0474019	1" HOSE CLAMP
20	P0474020	1" THICK-WALLED BLAST HOSE
21	P0474021	SAND ELBOW

REF	PART #	DESCRIPTION
23	P0474023	LEG (G0474)
23	P0475023	LEG (G0475)
24	P0474024	TANK 20 GALLON (G0474)
24	P0475024	TANK 10 GALLON (G0475)
25	P0474025	SAFETY RELIEF VALVE
26	P0474026	SPECIAL O-RING
27	P0474027	FILLER CAP
28	P0474028	FUNNEL
29	P0474029	HOOD W/LENSE
30	P0474030	HANDLEBAR (G0474)
30	P0475030	HANDLEBAR (G0475)
31	PN01M	HEX NUT M6-1
32	PS62M	PHLP HD SCR M6-1 X 30
33	P0474033	PIPE
34	P0474034	HANDLE GRIP
35	PW06M	FLAT WASHER 12MM
36	P0474036	MANIFOLD
38	P0474038	3/8" PUSH-ON HOSE NIPPLE

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 equipment or the manual.

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



Grizzly WARRANTY CARD

City		State	_ Zip
		_ Email	
Мо	del #	_ Order #	_ Serial #
	•	a voluntary basis. It will be used for ma Irse, all information is strictly confide	
1.	How did you learn about us? Advertisement Card Deck	Friend Website	Catalog Other:
2.	Which of the following magaz	zines do you subscribe to?	
	 Cabinet Maker Family Handyman Hand Loader Handy Home Shop Machinist Journal of Light Cont. Live Steam Model Airplane News Modeltec Old House Journal 	Popular MechanicsPopular SciencePopular WoodworkingPractical HomeownerPrecision ShooterProjects in MetalRC ModelerRifleShop NotesShotgun News	Today's HomeownerWoodWooden BoatWoodshop NewsWoodsmithWoodworkWoodworkWoodworker WestOther:
3.	What is your annual househo \$20,000-\$29,000 \$50,000-\$59,000	old income? \$30,000-\$39,000 \$60,000-\$69,000	\$40,000-\$49,000 \$70,000+
4.	What is your age group? 20-29 50-59	30-39 60-69	40-49 70+
5.	How long have you been a w 0-2 Years	oodworker/metalworker? 2-8 Years8-20 Year	rs20+ Years
6.	How many of your equipmen 0-2	ts or tools are Grizzly? 3-56-9	10+
7.	Do you think your equipment	represents a good value?Y	/esNo
8.	Would you recommend Grizz	ly Industrial to a friend?	/esNo
9.	Would you allow us to use yo Note: We never use names r	our name as a reference for Grizzly c more than 3 times.	2
10.	Comments:		

FOLD ALONG DOTTED LINE



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

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