



# MODEL G0531B/G0566B 21" BANDSAW MANUAL INSERT

For Machines Mfd. Since 09/18  
and Owner's Manual Revised 10/04

The Model G0531B/G0566B is the same as the Model G0566, except it has a magnetic brake motor, resaw fence, and square fence rail. Besides the instructions, data sheet, circuit requirements, parts, and wiring diagram in this insert, the content in the Model G0566 owner's manual is the same for both machines. Before operating your new machine, you **MUST** read and understand this insert and the entire Model G0566 manual to reduce the risk of injury from improper use or setup.

If you have any further questions about this manual insert or the differences between the Model G0531B/G0566B and the Model G0566, contact our Technical Support at (570) 546-9663 or email [techsupport@grizzly.com](mailto:techsupport@grizzly.com).

## Machine Inventory

Box Contents (Figure 1)	Qty
A. Bandsaw (not shown) .....	1
B. Miter Gauge.....	1
C. Fence.....	1
D. Resaw Fence .....	1
E. Guide Post Handwheel.....	1
F. Hex Wrenches 5, 6mm.....	1 Ea
G. Open-End Wrenches 10/13, 17/19mm..	1 Ea
H. Lifting Rings.....	2
I. Resaw Fence Lock Handle (Fence).....	1
J. Sliding Plate M8-1.25 (Fence).....	1
K. Flat Washer 8mm (Fence) .....	1

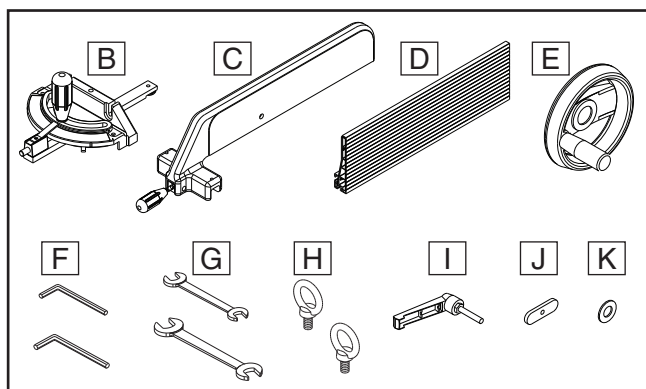


Figure 1. G0531B/G0566B inventory.

## Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

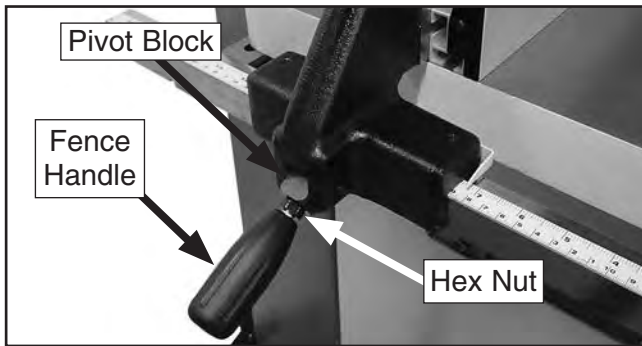
Tools Needed	Qty
Hex Wrenches 5, 6mm.....	1 Ea
Open-End Wrenches 10/13, 17/19mm.....	1 Ea

### To assemble machine:

1. Remove cap screw, knobs, and washers that hold fence rail to table, then remove rail.
2. Flip rail over and re-install with fasteners removed in **Step 1**.
3. Install fence handle on fence.



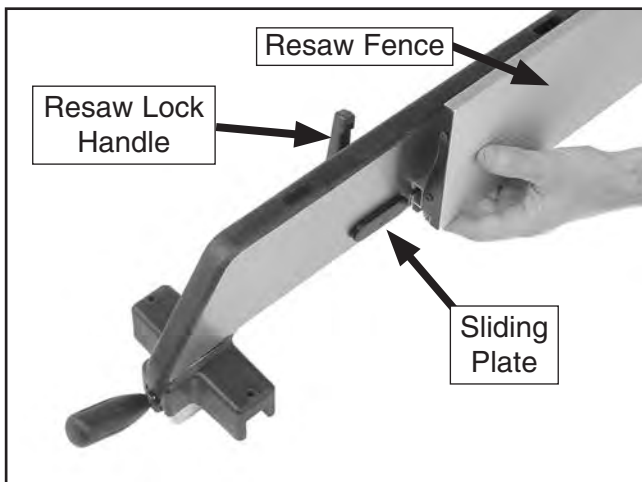
4. Tighten hex nut on fence handle against fence pivot block (see **Figure 2**).



**Figure 2.** Fence handle components.

5. Install resaw fence lock handle (with 8mm washer and sliding plate) onto fence, then slide resaw fence over sliding plate as shown in **Figure 3**.

**Note:** Leave moving plate and lock handle loose enough to slide onto resaw fence.



**Figure 3.** Example of attaching resaw fence to standard fence.

6. Tighten resaw lock handle.
7. Pull fence handle up and place fence assembly on rail.
8. Push fence handle down to lock fence assembly in place.

## Test Run

1. Follow **Steps 1-3** in the G0566 Manual on **Page 24**.

2. Verify that the machine is operating correctly by turning the switch disabling key (see **Figure 4**) to "1" and turning the machine **ON**.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.



**Figure 4.** G0531B switch disabling key and ON/OFF switch.

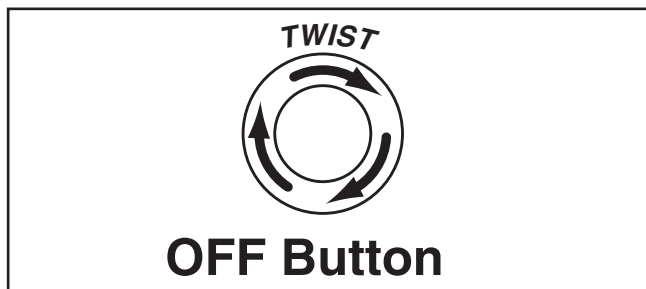
3. Press the OFF button to stop the machine.
4. **WITHOUT** resetting the OFF button, press the ON button. The machine should not start.

—If the machine does not start, the OFF button safety feature is working correctly.

—If the machine does start (with the stop button pushed in), immediately disconnect power to the machine. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.



5. Twist the OFF button clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 5**).



**Figure 5.** Resetting the switch.

6. Turn the switch disabling key to "0", as shown in **Figure 4**.
7. Try to turn the machine **ON**.

—If the bandsaw does not start, the switch disabling feature is working as designed. The Test Run is complete.

—If the bandsaw starts, immediately disconnect power. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

## Motor Brake

The motor brake is activated automatically when the OFF button is pushed, quickly bringing the blade to a stop.

## Aligning Fence

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

### To align fence parallel with miter slot:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure miter slot is aligned with bandsaw blade (see G0566 Manual **Page 22, Table Alignment**).
3. Mount fence next to miter slot, then loosen knobs and cap screw that secure fence rail to the table.
4. Adjust fence face parallel with edge of the miter slot, as shown in **Figure 6**.



**Figure 6.** Example of fence square with miter slot.

5. Tighten knobs and cap screw that secure rail to the table, being careful not to move the fence.

## NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the "Table Alignment" instructions in the G0566 Manual on Page 22.



## Magnetic Brake Adjustment

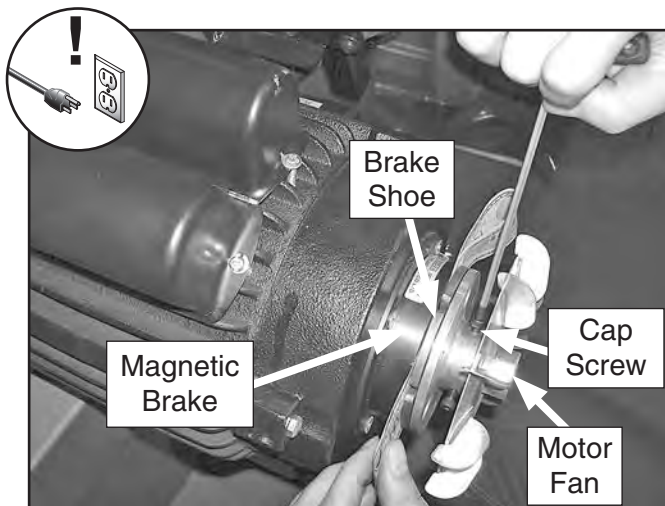
The space between the magnetic brake and brake shoe is preset by the factory at 0.2mm (0.008"). However, you should adjust this space every two to three years, or when it takes over five seconds for the brake to stop the motor.

### Tools Needed

Phillips Head Screwdriver .....	1
US Dollar Bills or Feeler Gauges 0.008" .....	2
Hex Wrench 3mm.....	1
Hex Wrench 4mm.....	1

### To adjust the space between the magnetic brake and brake shoe:

1. DISCONNECT MACHINE FROM POWER!
2. Remove motor fan cover, then loosen cap screws securing motor fan and brake shoe (see **Figure 7**).
3. Fold two dollar bills in half and slide them (or use feeler gauges) between brake shoe and magnetic brake on both sides (see **Figure 7**).
4. Slide fan toward brake until you feel a slight resistance when moving the bills, then tighten cap screws on brake shoe and motor fan, and re-install motor fan cover.



**Figure 7.** Adjusting distance between magnetic brake and brake shoe.

## Accessories

### 165" Steel Replacement Blades

Model	Width	TPI	Type	Gauge
H6978	1/2"	3	Hook	0.025
H6979	1/2"	4	Hook	0.025
H6980	1/2"	6	Hook	0.025
H6981	1/2"	10	Raker	0.025
H6982	1/2"	14	Raker	0.025
H6983	1"	2	Hook	0.035
H6984	1"	6	Hook	0.035
H6985	1"	10	Raker	0.035
H6986	1 1/4"	1.3	Hook	0.035
H6987	1"	3	Hook	0.025

### 165" Timber Wolf Replacement Blades

Model	Width	TPI	Type	Gauge
T25019	3/8"	3	Raker AS	0.032
T25036	1/2"	3	Raker AS	0.032
T25053	3/4"	2/3	Pos. Claw	0.025
T25064	3/4"	2/3	Pos. Claw	0.035
T25075	1"	1	Pos. Claw	0.035
T25086	1"	2/3	Pos. Claw	0.035

### D2058A—Heavy-Duty Shop Fox Mobile Base

This patented base is the most stable on the market with outrigger type supports. Adjusts from 18 1/2 x 24 1/2" to 28 1/2" x 33 1/2". 1300 lb. capacity. Weighs 39 lbs.



**Figure 8.** D2058A Shop Fox Mobile Base.





# MACHINE DATA SHEET

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

## MODEL G0531B 21" 5 HP INDUSTRIAL BANDSAW WITH BRAKE

### Product Dimensions:

Weight..... 594 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 39-1/2 x 32-1/4 x 78 in.  
 Footprint (Length x Width)..... 21-5/8 x 33-1/2 in.

### Shipping Dimensions:

Type..... Wood Slat Crate  
 Content..... Machine  
 Weight..... 684 lbs.  
 Length x Width x Height..... 30 x 38 x 84 in.  
 Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 230V, Single-Phase, 60 Hz  
 Full-Load Current Rating..... 22A  
 Minimum Circuit Size..... 30A  
 Connection Type..... Cord & Plug  
 Power Cord Included..... No  
 Recommended Power Cord..... "S"-Type, 3-Wire, 10 AWG, 300 VAC  
 Plug Included..... No  
 Recommended Plug Type..... L6-30  
 Switch Type..... Control Panel w/Magnetic Switch Protection & Lockout Key

### Motors:

#### Main

Horsepower..... 5 HP  
 Phase..... Single-Phase  
 Amps..... 22A  
 Speed..... 1720 RPM  
 Type..... TEFC Capacitor-Start Induction  
 Power Transfer..... Belt Drive  
 Bearings..... Shielded & Permanently Lubricated  
 Centrifugal Switch/Contacts Type..... External

### Main Specifications:

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Bandsaw Size..... 21 in.  
 Max Cutting Width (Left of Blade)..... 20 in.  
 Max Cutting Width (Left of Blade) w/Fence..... 18-3/4 in.  
 Max Cutting Height (Resaw Height)..... 14-1/4 in.  
 Blade Speeds..... 4600 FPM



**Blade Information**

Standard Blade Length.....	165 in.
Blade Length Range.....	164 – 165-1/2 in.
Blade Width Range.....	1/4 – 1-3/8 in.
Type of Blade Guides.....	Double Ball Bearing
Guide Post Adjustment Type.....	Rack & Pinion
Has Quick-Release.....	Yes

**Table Information**

Table Length.....	29-1/2 in.
Table Width.....	20-3/4 in.
Table Thickness.....	1-7/8 in.
Table Tilt.....	Left 5, Right 45 deg.
Table Tilt Adjustment Type.....	Rack & Pinion
Floor-to-Table Height.....	35-1/2 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	No
Resaw Fence Attachment Included.....	Yes
Miter Gauge Included.....	Yes

**Construction Materials**

Table.....	Precision Ground Cast Iron
Trunnion.....	Cast Iron
Fence.....	Precision Ground Cast Iron
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Pre-Formed Steel
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Polyurethane
Wheel Cover .....	Pre-Formed Steel
Paint Type/Finish.....	Powder Coated

**Other Related Information**

Wheel Diameter.....	21 in.
Wheel Width.....	1-1/2 in.
Number of Dust Ports.....	2
Dust Port Size.....	4 in
Compatible Mobile Base.....	D2058A, D2246A

**Other Specifications:**

Country of Origin .....	Taiwan
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	15 Minutes
Serial Number Location .....	ID Label
ISO 9001 Factory .....	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL) .....	Yes





# MACHINE DATA SHEET

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

## MODEL G0566B 21" SUPER HEAVY-DUTY 3 HP BANDSAW WITH MOTOR BRAKE

### Product Dimensions:

Weight..... 581 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 39-1/2 x 28-5/8 x 78 in.  
Footprint (Length x Width)..... 21-5/8 x 33-1/2 in.

### Shipping Dimensions:

Type..... Wood Slat Crate  
Content..... Machine  
Weight..... 680 lbs.  
Length x Width x Height..... 30 x 38 x 84 in.  
Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 230V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 16A  
Minimum Circuit Size..... 20A  
Connection Type..... Cord & Plug  
Power Cord Included..... No  
Recommended Power Cord..... "S"-Type, 3-Wire, 12 AWG, 300 VAC  
Plug Included..... No  
Recommended Plug Type..... 6-20 or L6-20  
Switch Type..... Control Panel w/Magnetic Switch Protection & Lockout Key

### Motors:

#### Main

Horsepower..... 3 HP  
Phase..... Single-Phase  
Amps..... 16A  
Speed..... 1720 RPM  
Type..... TEFC Capacitor-Start Induction  
Power Transfer ..... V-Belt Drive  
Bearings..... Shielded & Permanently Lubricated  
Centrifugal Switch/Contacts Type..... External

### Main Specifications:

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Bandsaw Size..... 21 in.  
Max Cutting Width (Left of Blade)..... 20 in.  
Max Cutting Width (Left of Blade) w/Fence..... 18-3/4 in.  
Max Cutting Height (Resaw Height)..... 14-1/4 in.  
Blade Speeds..... 4600 FPM



**Blade Information**

Standard Blade Length.....	165 in.
Blade Length Range.....	164 – 165-1/2 in.
Blade Width Range.....	1/4 – 1-3/8 in.
Type of Blade Guides.....	Double Ball Bearing
Guide Post Adjustment Type.....	Rack & Pinion
Has Quick-Release.....	Yes

**Table Information**

Table Length.....	29-1/2 in.
Table Width.....	20-3/4 in.
Table Thickness.....	1-7/8 in.
Table Tilt.....	Left 5, Right 45 deg.
Table Tilt Adjustment Type.....	Rack & Pinion
Floor-to-Table Height.....	35-1/2 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	No
Resaw Fence Attachment Included.....	No
Miter Gauge Included.....	Yes

**Construction Materials**

Table.....	Precision Ground Cast Iron
Trunnion.....	Cast Iron
Fence.....	Precision Ground Cast Iron
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Pre-Formed Steel
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Polyurethane
Wheel Cover.....	Pre-Formed Steel
Paint Type/Finish.....	Powder Coated

**Other Related Information**

Wheel Diameter.....	20-3/4 in.
Wheel Width.....	1-1/2 in.
Number of Dust Ports.....	2
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D2058A, D2246A

**Other Specifications:**

Country of Origin.....	Taiwan
Warranty.....	1 Year
Approximate Assembly & Setup Time.....	15 Minutes
Serial Number Location.....	ID Label on Upper Cover
ISO 9001 Factory.....	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL).....	Yes

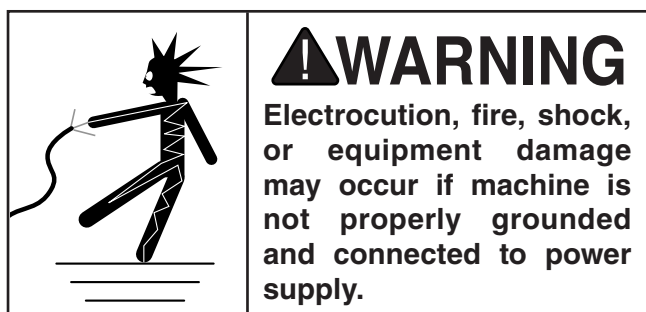




# SECTION 2: POWER SUPPLY

## Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



## Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

**Full-Load Current Rating (G0531B)... 22 Amps**  
**Full-Load Current Rating (G0566B)... 16 Amps**

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the specified circuit requirements.

## Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

**! CAUTION**  
For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel to ensure circuit is properly sized for safe operation.*

## Circuit Requirements for G0531B

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

**Nominal Voltage** ..... 208V, 220V, 230V, 240V  
**Cycle** ..... 60 Hz  
**Phase** ..... Single-Phase  
**Power Supply Circuit** ..... 30 Amps  
**Plug/Receptacle** ..... L6-30  
**Cord** ..... “S”-Type, 3-Wire, 10 AWG, 300 VAC

## Circuit Requirements for G0566B

This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

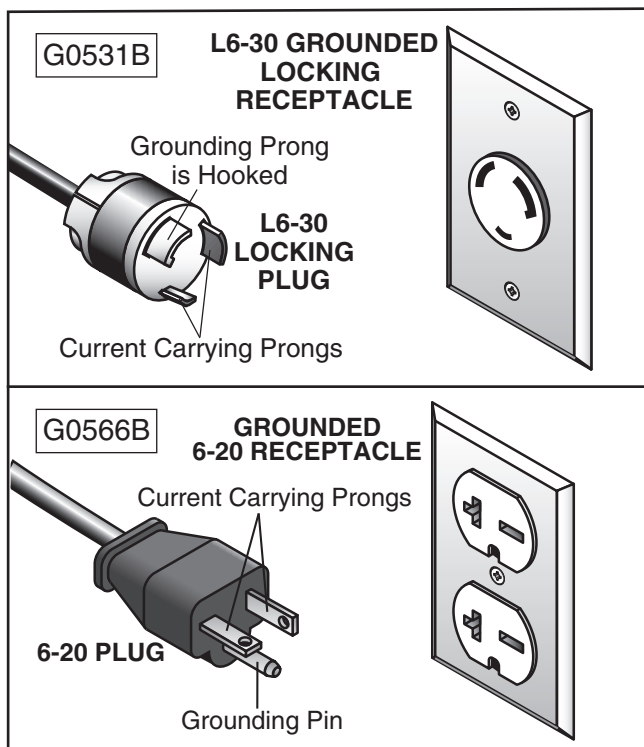
**Nominal Voltage** ..... 208V, 220V, 230V, 240V  
**Cycle** ..... 60 Hz  
**Phase** ..... Single-Phase  
**Power Supply Circuit** ..... 20 Amps  
**Plug/Receptacle** ..... 6-20 or L6-20  
**Cord** ..... “S”-Type, 3-Wire, 12 AWG, 300 VAC



## Grounding Requirements

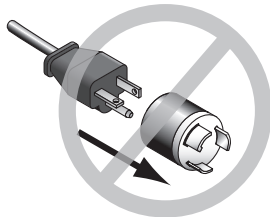
This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. **DO NOT** modify the provided plug!



**Figure 9.** Typical 220V plugs and receptacles.

## **! CAUTION**



**No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.**

## **! WARNING**

**Serious injury could occur if you connect machine to power before completing setup process. DO NOT connect to power until instructed later in this manual.**

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

## Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

**Minimum Gauge Size (G0531B) ..... 10 AWG**  
**Minimum Gauge Size (G0566B)..... 12 AWG**  
**Maximum Length (Shorter is Better)..... 50 ft.**



# G0531B/G0566B Electrical Components



Figure 10. G0531B magnetic switch.

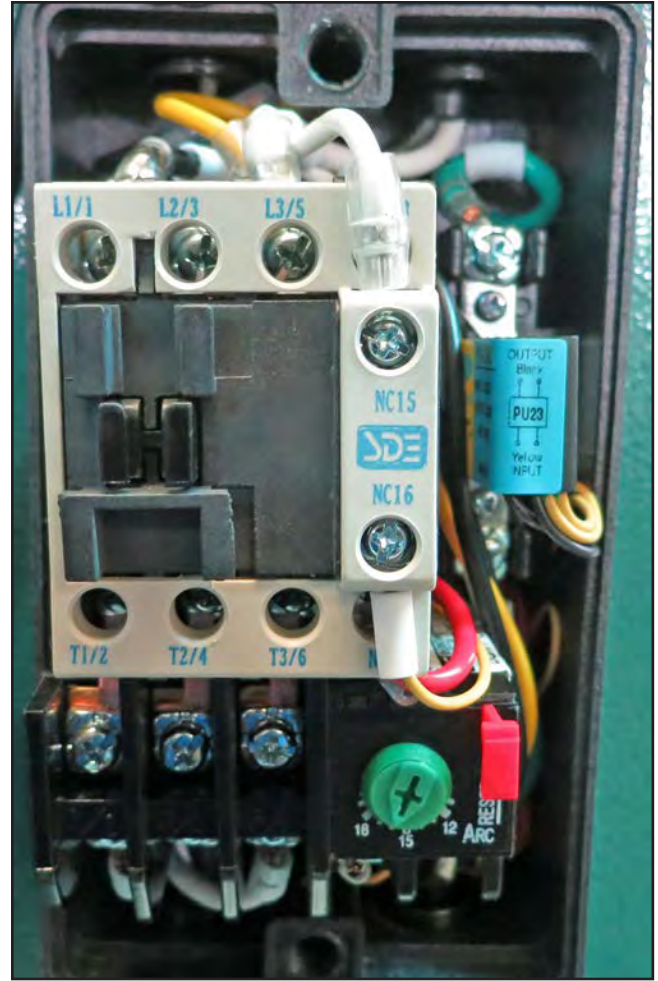
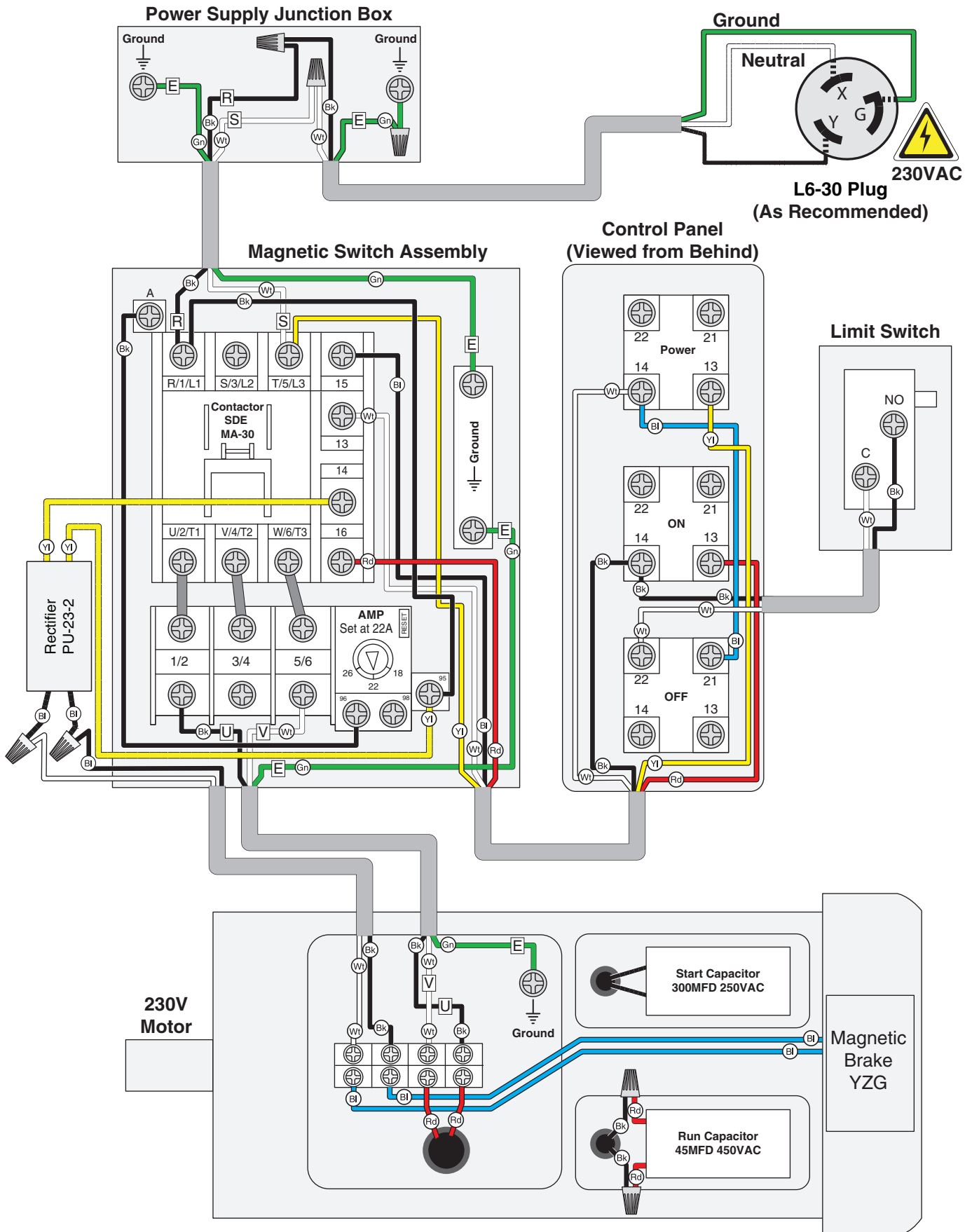


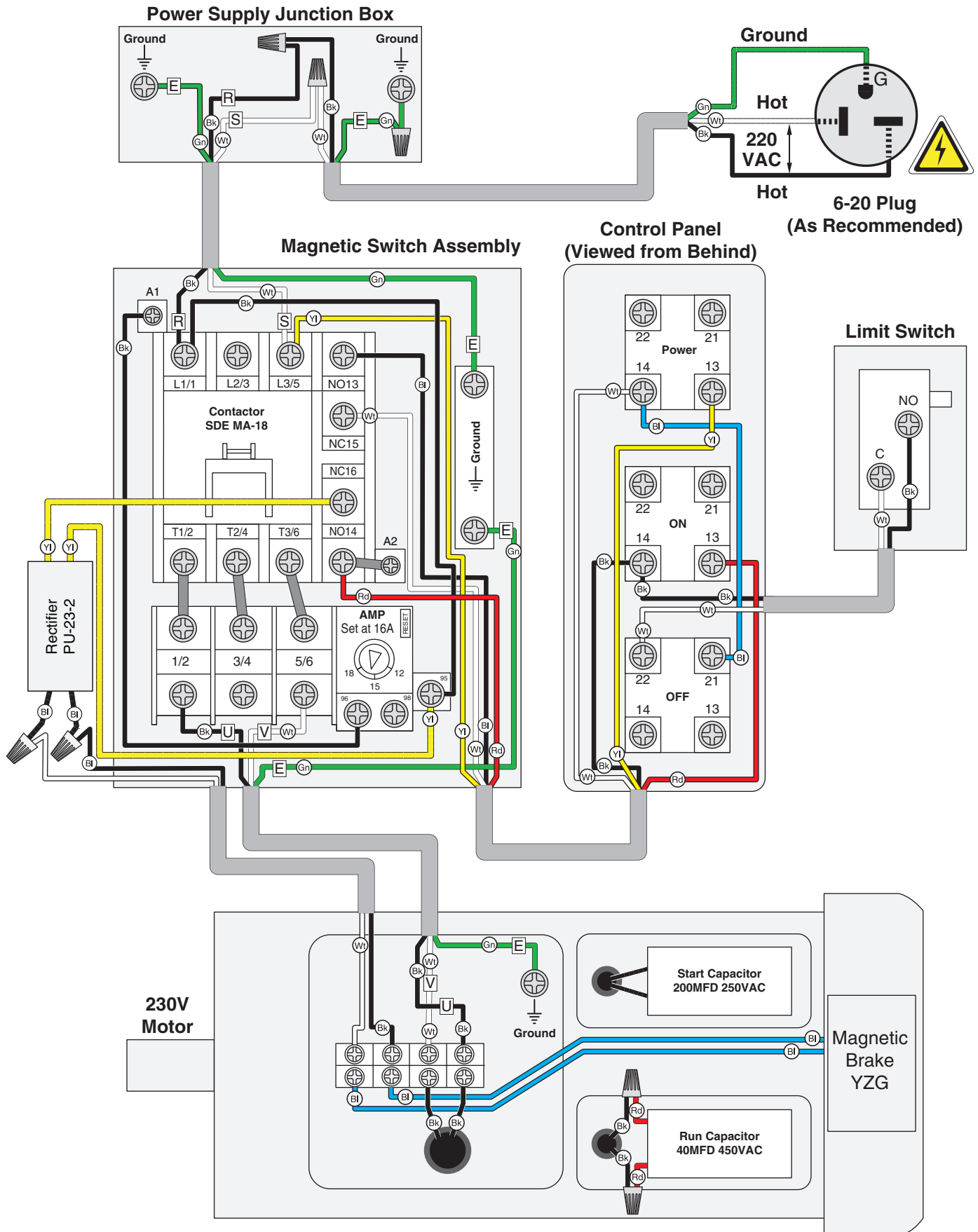
Figure 11. G0566B magnetic switch.



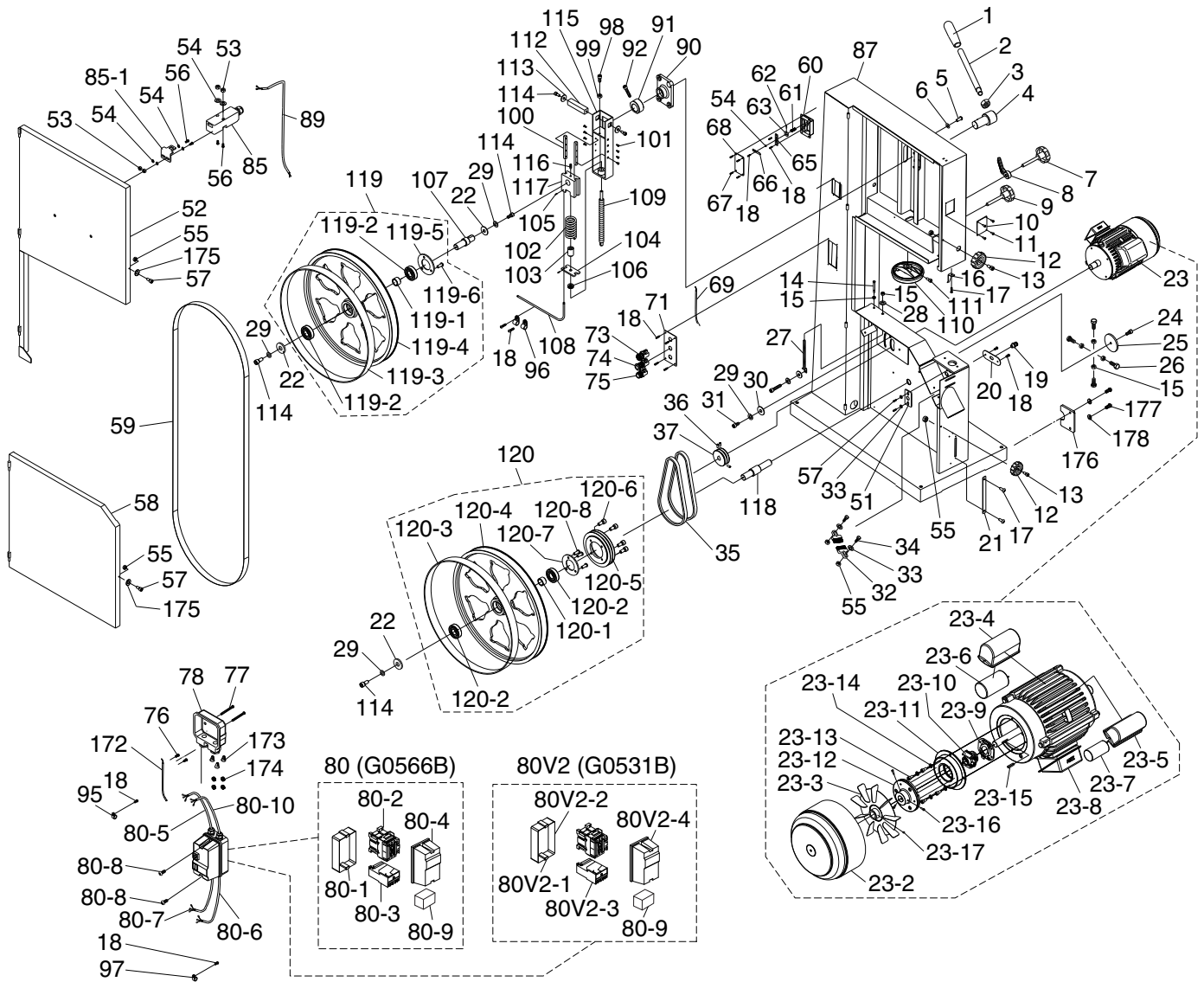
# G0531B Wiring Diagram 5HP 230V, 1-Ph



# G0566B Wiring Diagram 3HP 230V, 1-Ph



# Main



# Main Parts List

REF	PART #	DESCRIPTION
1	P0566B001	HANDLE KNOB M16-1.5
2	P0566B002	HANDLE SHAFT
3	P0566B003	HEX NUT M16-1.5
4	P0566B004	ECCENTRIC SHAFT
5	P0566B005	BUTTON HD CAP SCR M10-1.5 X 20
6	P0566B006	LOCK WASHER 10MM
7	P0566B007	KNOB SCREW M10-1.5 X 25
8	P0566B008	LOCK HANDLE M10-1.5
9	P0566B009	KNOB SCREW M10-1.5 X 25
10	P0566B010	WINDOW, PLASTIC
11	P0566B011	RIVET 3 X 10MM NAMEPLATE, STEEL
12	P0566B012	LATCH KNOB 6MM
13	P0566B013	CAP SCREW M6-1 X 20
14	P0566B014	HEX BOLT M10-1.5 X 70
15	P0566B015	HEX NUT M10-1.5
16	P0566B016	HEIGHT POINTER
17	P0566B017	FLANGE SCREW M5-.8 X 10
18	P0566B018	TAP SCREW M4 X 10
19	P0566B019	STRAIN RELIEF PG 13.5
20	P0566B020	PLATE
21	P0566B021	STEP COVER
22	P0566B022	FENDER WASHER 8MM
23	P0566B023	MOTOR 3HP 230V 1-PH W/BRAKE (G0566B)
23	P0531B023	MOTOR 5HP 230V 1-PH W/BRAKE (G0531B)
23-2	P0566B023-2	MOTOR FAN COVER (G0566B)
23-2	P0531B023-2	MOTOR FAN COVER (G0531B)
23-3	P0566B023-3	MOTOR FAN (G0566B)
23-3	P0531B023-3	MOTOR FAN (G0531B)
23-4	P0566B023-4	R CAPACITOR COVER (G0566B)
23-4	P0531B023-4	R CAPACITOR COVER (G0531B)
23-5	P0566B023-5	S CAPACITOR COVER (G0566B)
23-5	P0531B023-5	S CAPACITOR COVER (G0531B)
23-6	P0566B023-6	R CAPACITOR 40M 450V 2 X 3-7/16 (G0566B)
23-6	P0531B023-6	R CAPACITOR 45M 450V (G0531B)
23-7	P0566B023-7	S CAPACITOR 200M 250V 1-3/4 X 3-1/2 (G0566B)
23-7	P0531B023-7	S CAPACITOR 300M 250V 2 X 4 (G0531B)
23-8	P0566B023-8	JUNCTION BOX (G0566B)
23-8	P0531B023-8	JUNCTION BOX (G0531B)
23-9	P0566B023-9	CONTACT PLATE (G0566B)
23-9	P0531B023-9	CONTACT PLATE (G0531B)
23-10	P0566B023-10	CENTRIFUGAL SWITCH (G0566B)
23-10	P0531B023-10	CENTRIFUGAL SWITCH (G0531B)
23-11	P0566B023-11	MAGNETIC BRAKE W/SHOE (G0566B)
23-11	P0531B023-11	MAGNETIC BRAKE W/SHOE (G0531B)
23-12	P0566B023-12	BRAKE SHOE (G0566B)
23-12	P0531B023-12	BRAKE SHOE (G0531B)
23-13	P0566B023-13	CAP SCREW M6-1 X 12 (G0566B)
23-13	P0531B023-13	CAP SCREW M6-1 X 12 (G0531B)
23-14	P0566B023-14	LOCK WASHER 6MM (G0566B)
23-14	P0531B023-14	LOCK WASHER 6MM (G0531B)
23-15	P0566B023-15	KEY 5 X 5 X 25 (G0566B)
23-15	P0531B023-15	KEY 5 X 5 X 25 (G0531B)
23-16	P0566B023-16	CAP SCREW M5-.8 X 16 (G0566B)
23-16	P0531B023-16	CAP SCREW M5-.8 X 16 (G0531B)
23-17	P0566B023-17	SET SCREW M6-1 X 6 (G0566B)
23-17	P0531B023-17	SET SCREW M6-1 X 6 (G0531B)

REF	PART #	DESCRIPTION
24	P0566B024	BUTTON HD CAP SCR M8-1.25 X 25
25	P0566B025	WHEEL SHAFT COVER
26	P0566B026	HEX BOLT M10-1.5 X 35
27	P0566B027	ADJUST BOLT
28	P0566B028	FLAT WASHER 10MM
29	P0566B029	LOCK WASHER 8MM
30	P0566B030	FLAT WASHER 8MM
31	P0566B031	CAP SCREW M8-1.25 X 25
32	P0566B032	WHEEL BRUSH
33	P0566B033	FLAT WASHER 6MM
34	P0566B034	CAP SCREW M6-1 X 25
35	P0531B035	V-BELT 17-320 (G0531B)
35	P0566B035	V-BELT 17-320 (G0566B)
36	P0566B036	SET SCREW M6-1 X 12
37	P0566B037	MOTOR PULLEY
51	P0566B051	BRACKET
52	P0566B052	UPPER WHEEL COVER
53	P0566B053	HEX NUT M4-.7
54	P0566B054	FLAT WASHER 4MM
55	P0566B055	LOCK NUT M6-1
56	P0566B056	PHLP HD SCR M4-.7 X 10
57	P0566B057	CAP SCREW M6-1 X 10
58	P0566B058	LOWER WHEEL COVER
59	P0566B059	SAW BLADE 164" X 1" X 0.035" HOOK
60	P0566B060	UPPER WHEEL SLIDING BRACKET
61	P0566B061	COMPRESSION SPRING 1 X 8 X 40
62	P0566B062	ROLL PIN 3 X 12
63	P0566B063	SLIDING PLATE
65	P0566B065	TENSIONS INDICATOR PLATE
66	P0566B066	TENSION POINTER
67	P0566B067	TAP SCREW M4 X 16
68	P0566B068	TENSION SCALE
69	P0566B069	CONNECTING WIRE 16G
71	P0566B071	SWITCH PLATE
73	P0566B073	KEY SWITCH 22
74	P0566B074	E-STOP BUTTON 250V 10A
75	P0566B075	START SWITCH 22
76	P0566B076	PHLP HD SCR M4-.7 X 10
77	P0566B077	FLANGE SCREW M5-.8 X 50
78	P0566B078	TERMINAL BOX
80	P0566B080	MAG SWITCH SDE MPE-18 (G0566B)
80V2	P0531B080V2	MAG SWITCH SDE MPE-30 V2.08.13 (G0531B)
80-1	P0566B080-1	MAG SWITCH BACK COVER (G0566B)
80V2-1	P0531B080V2-1	MAG SWITCH BACK COVER MPE-30 (G0531B)
80-2	P0566B080-2	CONTACTOR SDE MA-18 230V (G0566B)
80V2-2	P0531B080V2-2	CONTACTOR SDE MA-30 230V (G0531B)
80-3	P0566B080-3	RELAY SDE RA-20 12-18A (G0566B)
80V2-3	P0531B080V2-3	RELAY SDE RA-30 18-26A (G0531B)
80-4	P0566B080-4	MAG SWITCH FRONT COVER (G0566B)
80V2-4	P0531B080V2-4	MAG SWITCH FRONT COVER MPE-30 (G0531B)
80-5	P0566B080-5	POWER CORD 12G 3W
80-6	P0566B080-6	CONTROL PANEL CORD 16G 5W
80-7	P0566B080-7	MOTOR CORD 12G 3W
80-8	P0566B080-8	FLANGE SCREW M5-.8 X 10
80-9	P0566B080-9	RECTIFIER PU-23-2
80-10	P0566B080-10	BRAKE CORD 18G 2W



# Main Parts List (Cont.)

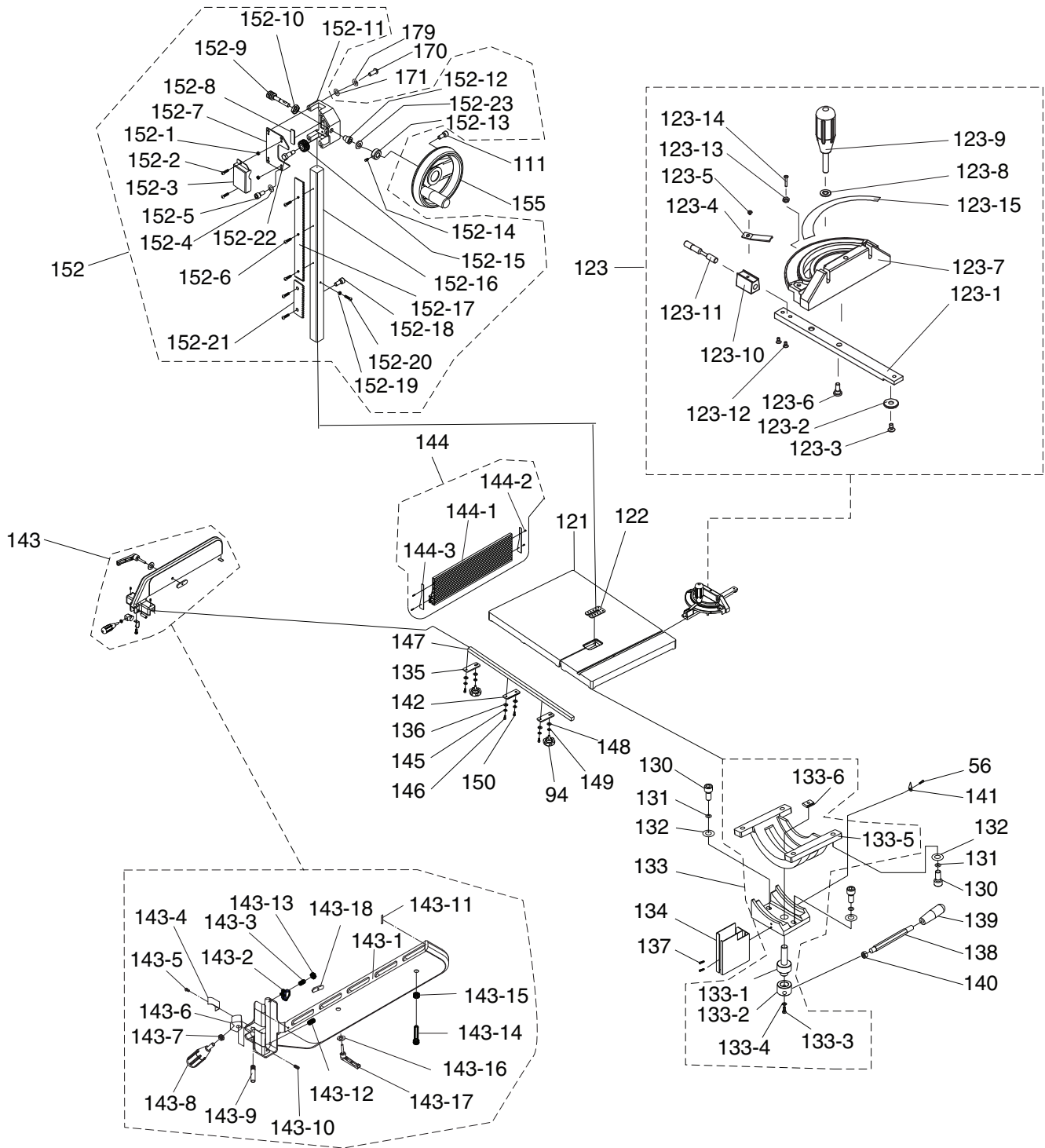
REF	PART #	DESCRIPTION
85	P0566B085	DOOR LATCH SWITCH ASM ADZ-S11
85-1	P0566B085-1	DOOR LATCH SWITCH PLATE
87	P0566B087	MACHINE BODY
89	P0566B089	SWITCH CORD 18G 2W
90	P0566B090	GUIDE BLOCK
91	P0566B091	CAM
92	P0566B092	CAP SCREW M8-1.25 X 25
95	P0566B095	CORD CLAMP 1/2"
96	P0566B096	CORD CLAMP 5/16"
97	P0566B097	CORD CLAMP 3/8"
98	P0566B098	CAP SCREW M8-1.25 X 50
99	P0566B099	HEX NUT M8-1.25
100	P0566B100	SLIDING BAR
101	P0566B101	FLAT HD SCR M5-.8 X 16
102	P0566B102	COMPRESSION SPRING
103	P0566B103	BUSHING
104	P0566B104	SPRING BASE
105	P0566B105	SET SCREW M5-.8 X 5
106	P0566B106	THRUST BEARING 51201
107	P0566B107	UPPER WHEEL SHAFT
108	P0566B108	TENSION LINE
109	P0566B109	ADJUSTING BOLT
110	P0566B110	BLADE TENSION HANDWHEEL
112	P0566B112	SQUARE SHAFT
113	P0566B113	FLAT WASHER 8MM
114	P0566B114	CAP SCREW M8-1.25 X 20
115	P0566B115	UPPER WHEEL HINGE ASSEMBLY

REF	PART #	DESCRIPTION
116	P0566B116	SET SCREW M10-1.5 X 16
117	P0566B117	GUIDE BLOCK
118	P0566B118	LOWER WHEEL SHAFT
119	P0566B119	UPPER WHEEL ASSEMBLY
119-1	P0566B119-1	BUSHING
119-2	P0566B119-2	BALL BEARING 6205-2RS
119-3	P0566B119-3	WHEEL TIRE 21"
119-4	P0566B119-4	UPPER WHEEL 21"
119-5	P0566B119-5	UPPER WHEEL SHAFT PLATE
119-6	P0566B119-6	CAP SCREW M6-1 X 8
120	P0566B120	LOWER WHEEL ASSEMBLY
120-1	P0566B120-1	BUSHING
120-2	P0566B120-2	BALL BEARING 6205-2RS
120-3	P0566B120-3	WHEEL TIRE 21"
120-4	P0566B120-4	LOWER WHEEL 21"
120-5	P0566B120-5	WHEEL PULLEY
120-6	P0566B120-6	BUTTON HD CAP SCR M8-1.25 X 20
120-7	P0566B120-7	UPPER WHEEL SHAFT PLATE
120-8	P0566B120-8	CAP SCREW M6-1 X 8
172	P0566B172	CONNECTING CORD 12G 1W
173	P0566B173	WIRE NUT 14-22 AWG
174	P0566B174	EXT TOOTH WASHER 5MM
175	P0566B175	LOCK WASHER 6MM
176	P0566B176	ADJUSTMENT PLATE
177	P0566B177	CAP SCREW M5-.8 X 12
178	P0566B178	FLAT WASHER 5MM





# Table, Fence & Trunnion



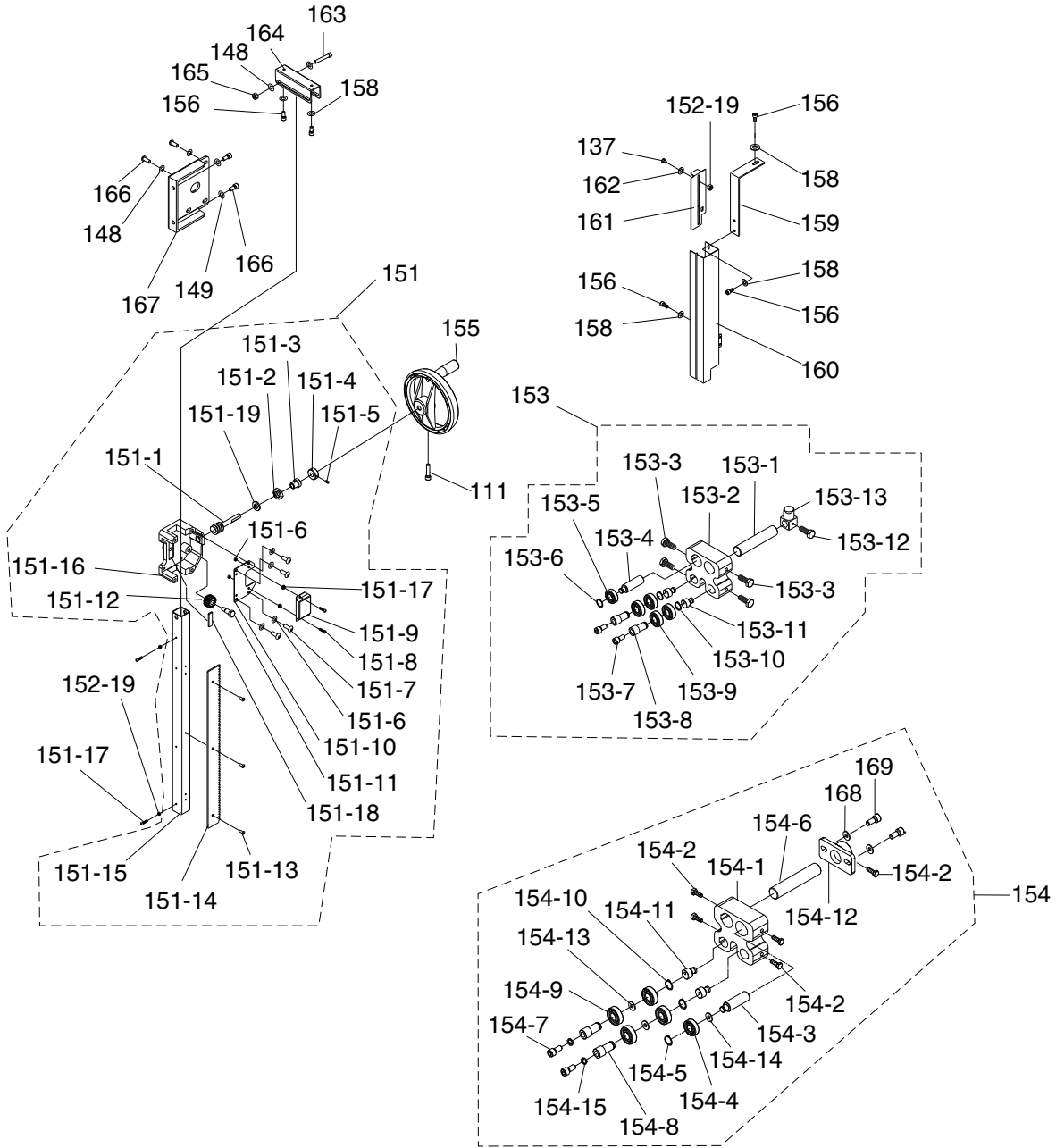
# Table, Fence & Trunnion Parts List

REF	PART #	DESCRIPTION
94	P0566B094	KNOB M8-1.25 X 20
111	P0566B111	CAP SCREW M6-1 X 25
121	P0566B121	TABLE 20-3/4" X 29-1/2"
122	P0566B122	TABLE INSERT
123	P0566B123	MITER GAUGE ASSY
123-1	P0566B123-1	GUIDE BAR
123-2	P0566B123-2	T-SLOT WASHER
123-3	P0566B123-3	FLAT HD SCR M6-1 X 8
123-4	P0566B123-4	POINTER
123-5	P0566B123-5	PHLP HD SCR 10-24 X 3/8
123-6	P0566B123-6	SHOULDER SCREW
123-7	P0566B123-7	MITER GAUGE BODY
123-8	P0566B123-8	FLAT WASHER 8MM
123-9	P0566B123-9	HANDLE
123-10	P0566B123-10	LOCKING BLOCK
123-11	P0566B123-11	LOCKING SHAFT
123-12	P0566B123-12	PHLP HD SCR 10-24 X 3/8
123-13	P0566B123-13	HEX NUT M4-.7
123-14	P0566B123-14	PHLP HD SCR M4-.7 X 16
123-15	P0566B123-15	SCALE
130	P0566B130	CAP SCREW M10-1.5 X 35
131	P0566B131	LOCK WASHER 10MM
132	P0566B132	FLAT WASHER 10MM
133	P0566B133	TRUNNION BRACKET ASSEMBLY
133-1	P0566B133-1	PRESS SHAFT
133-2	P0566B133-2	MICRO ADJUSTING RING
133-3	P0566B133-3	CAP SCREW M8-1.25 X 25
133-4	P0566B133-4	LOCK WASHER 8MM
133-5	P0566B133-5	TRUNNION BLOCK
133-6	P0566B133-6	TRUNNION T-SLIDE
134	P0566B134	LOWER BLADE GUARD
135	P0566B135	OUTER RAIL PLATE
136	P0566B136	FLAT WASHER 6MM
137	P0566B137	FLANGE BOLT M6-1 X 10
138	P0566B138	HANDLE SHAFT
139	P0566B139	SHAFT KNOB
140	P0566B140	HEX NUT M12-1.75
141	P0566B141	POINTER
142	P0566B142	INNER RAIL PLATE
143	P0566B143	FENCE ASSEMBLY
143-1	P0566B143-1	FENCE
143-2	P0566B143-2	POINTER
143-3	P0566B143-3	SET SCREW M8-1.25 X 25
143-4	P0566B143-4	SPRING PLATE
143-5	P0566B143-5	FLANGE SCREW M4-.7 X 8
143-6	P0566B143-6	PIVOT BLOCK
143-7	P0566B143-7	HEX NUT M8-1.25
143-8	P0566B143-8	FENCE LOCK HANDLE

REF	PART #	DESCRIPTION
143-9	P0566B143-9	SHAFT
143-10	P0566B143-10	SET SCREW M7-1 X 10, PLASTIC
143-11	P0566B143-11	NYLON PAD
143-12	P0566B143-12	SET SCREW M8-1.25 X 12
143-13	P0566B143-13	HEX NUT M8-1.25
143-14	P0566B143-14	HEX BOLT M8-1.25 X 20
143-15	P0566B143-15	HEX NUT M8-1.25
143-16	P0566B143-16	FLAT WASHER 8MM
143-17	P0566B143-17	LOCK HANDLE M8-1.25 X 45
143-18	P0566B143-18	SLIDE PLATE
144	P0566B144	RESAW FENCE ASSEMBLY
144-1	P0566B144-1	RESAW FENCE 590MM, ALUMINUM
144-2	P0566B144-2	TAP SCREW M3.5 X 12
144-3	P0566B144-3	FENCE END PLATE 148 X 22 X 1
145	P0566B145	LOCK WASHER 6MM
146	P0566B146	CAP SCREW M6-1 X 20
147	P0566B147	GUARD RAIL
148	P0566B148	FLAT WASHER 8MM
149	P0566B149	LOCK WASHER 8MM
150	P0566B150	CAP SCREW M8-1.25 X 20
152	P0566B152	UPPER GUIDE ASSEMBLY
152-1	P0566B152-1	HEX NUT M5-.8
152-2	P0566B152-2	FLANGE SCREW M5-.8 X 10
152-3	P0566B152-3	GUIDE BRACKET COVER
152-4	P0566B152-4	LOCK WASHER 8MM
152-5	P0566B152-5	CAP SCREW M8-1.25 X 16
152-6	P0566B152-6	FLAT HD SCR M4-.7 X 10
152-7	P0566B152-7	UPPER GUIDE BRACKET COVER
152-8	P0566B152-8	ALIGNMENT PLATE
152-9	P0566B152-9	WORM SHAFT
152-10	P0566B152-10	HEX NUT M16-1.5
152-11	P0566B152-11	GUIDE BRACKET
152-12	P0566B152-12	BUSHING
152-13	P0566B152-13	LOCK COLLAR
152-14	P0566B152-14	SET SCREW M5-.8 X 5
152-15	P0566B152-15	PINION GEAR
152-16	P0566B152-16	UPPER GUIDE SUPPORT BLOCK
152-17	P0566B152-17	UPPER GUIDE RACK
152-18	P0566B152-18	CAP SCREW M6-1 X 16
152-19	P0566B152-19	HEX NUT M4-.7
152-20	P0566B152-20	PHLP HD SCR M4-.7 X 10
152-21	P0566B152-21	EXTENSION RACK
152-22	P0566B152-22	STEP BOLT M10-1.5 X 12 X 43
152-23	P0566B152-23	FLAT WASHER 16MM, FIBER
155	P0566B155	HANDWHEEL
170	P0566B170	CAP SCREW M8-1.25 X 30
171	P0566B171	FLAT WASHER 8MM
179	P0566B179	LOCK WASHER 8MM



# Guides



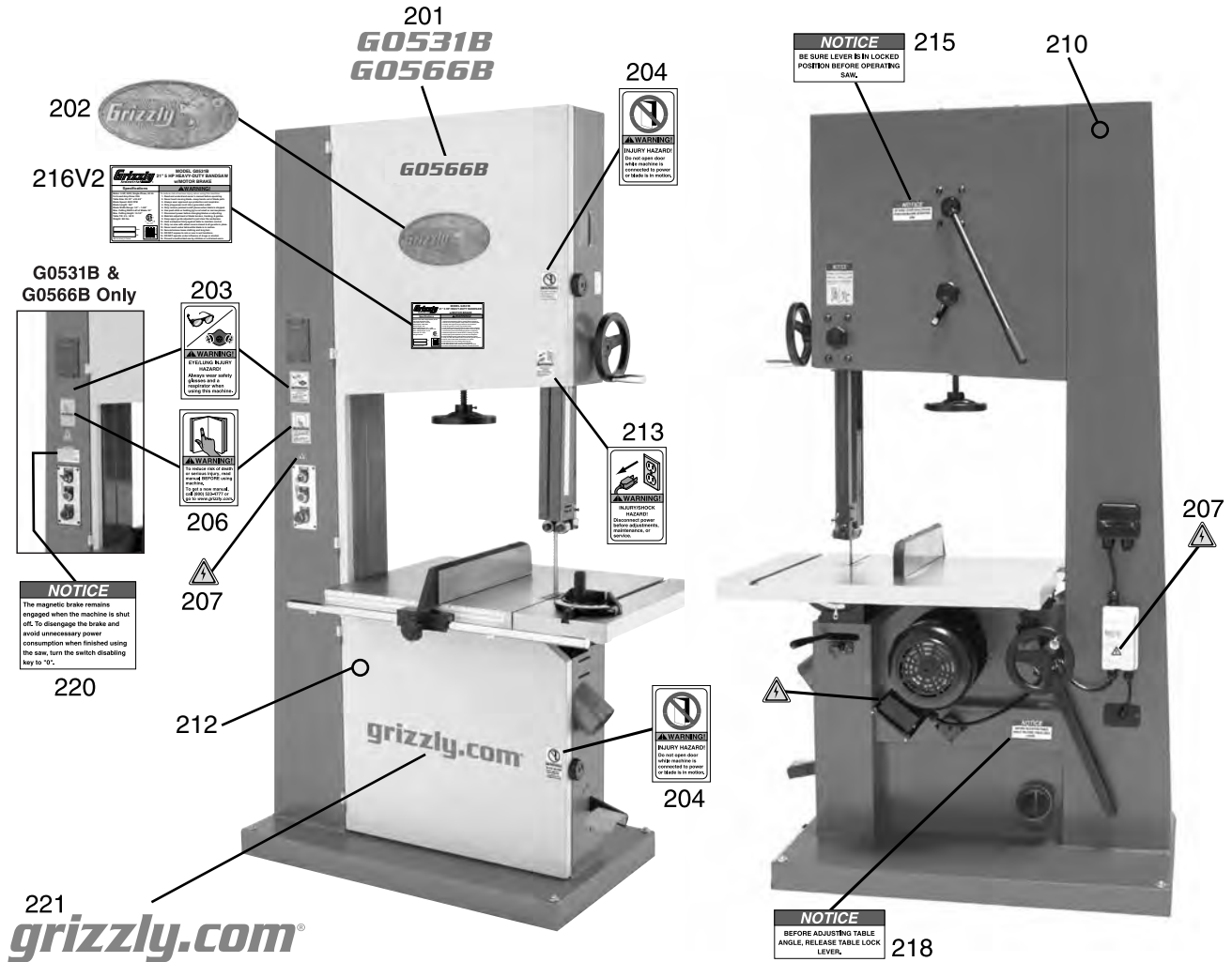
# Guides Parts List

REF	PART #	DESCRIPTION
137	P0566B137	FLANGE BOLT M6-1 X 10
148	P0566B148	FLAT WASHER 8MM
149	P0566B149	LOCK WASHER 8MM
151	P0566B151	TABLE TILT ASSEMBLY
151-1	P0566B151-1	WORM CYLINDER
151-2	P0566B151-2	HEX NUT M16-1.5
151-3	P0566B151-3	BUSHING
151-4	P0566B151-4	LOCK COLLAR 22 X 10 X 10MM
151-5	P0566B151-5	SET SCREW M5-.8 X 5
151-6	P0566B151-6	LOCK WASHER 8MM
151-7	P0566B151-7	CAP SCREW M8-1.25 X 16
151-8	P0566B151-8	FLANGE SCREW M5-.8 X 10
151-9	P0566B151-9	OUTER GUIDE BRACKET COVER
151-10	P0566B151-10	LOWER GUIDE BRACKET COVER
151-11	P0566B151-11	PINION GEAR STEP BOLT
151-12	P0566B151-12	PINION GEAR 15T
151-13	P0566B151-13	FLAT HD SCR M4-.7 X 10
151-14	P0566B151-14	LOWER GUIDE RACK
151-15	P0566B151-15	SQUARE TUBE
151-16	P0566B151-16	GUIDE BRACKET
151-17	P0566B151-17	PHLP HD SCR M4-.7 X 10
151-18	P0566B151-18	ALIGNMENT PLATE
151-19	P0566B151-19	FLAT WASHER 16MM, FIBER
153	P0566B153	UPPER BLADE GUIDE ASSEMBLY
153-1	P0566B153-1	ADJUSTMENT ROD
153-2	P0566B153-2	BLADE GUIDE SUPPORT
153-3	P0566B153-3	HEX BOLT M6-1 X 16
153-4	P0566B153-4	SPACING SLEEVE
153-5	P0566B153-5	BALL BEARING 6201ZZ
153-6	P0566B153-6	EXT RETAINING RING 12MM
153-7	P0566B153-7	CAP SCREW M6-1 X 40
153-8	P0566B153-8	PIVOT SLEEVE
153-9	P0566B153-9	BALL BEARING 6202ZZ

REF	PART #	DESCRIPTION
153-10	P0566B153-10	EXT RETAINING RING 15MM
153-11	P0566B153-11	ECCENTRIC SHAFT
153-12	P0566B153-12	HEX BOLT M6-1 X 16
153-13	P0566B153-13	UPPER GUIDE SUPPORT BLOCK
154	P0566B154	LOWER BLADE GUIDE ASSEMBLY
154-1	P0566B154-1	BLADE GUIDE SUPPORT
154-2	P0566B154-2	CAP SCREW M6-1 X 16
154-3	P0566B154-3	SPACING SLEEVE
154-4	P0566B154-4	BALL BEARING 6201ZZ
154-5	P0566B154-5	EXT RETAINING RING 12MM
154-6	P0566B154-6	ADJUSTMENT ROD
154-7	P0566B154-7	HEX BOLT M6-1 X 40
154-8	P0566B154-8	PIVOT SLEEVE
154-9	P0566B154-9	BALL BEARING 6202ZZ
154-10	P0566B154-10	EXT RETAINING RING 15MM
154-11	P0566B154-11	ECCENTRIC SHAFT
154-12	P0566B154-12	SUPPORT BRACKET
154-13	P0566B154-13	SPACER
154-14	P0566B154-14	SPACER
154-15	P0566B154-15	LOCK WASHER 6MM
156	P0566B156	CAP SCREW M6-1 X 10
158	P0566B158	FLAT WASHER 6MM
159	P0566B159	SUPPORT PLATE
160	P0566B160	UPPER BLADE GUARD
161	P0566B161	SLIDING PLATE
162	P0566B162	FLAT WASHER 6MM, FIBER
163	P0566B163	HEX BOLT M8-1.25 X 55
164	P0566B164	SLIDING PLATE
165	P0566B165	LOCK NUT M8-1.25
166	P0566B166	CAP SCREW M8-1.25 X 20
167	P0566B167	SUPPORT BRACKET
168	P0566B168	FLAT WASHER 6MM
169	P0566B169	CAP SCREW M6-1 X 12



# Labels & Cosmetics



REF	PART #	DESCRIPTION
201	P0531B201	MODEL NUMBER LABEL (G0531B)
201	P0566B201	MODEL NUMBER LABEL (G0566B)
202	P0566B202	GRIZZLY LOGO PLATE
203	P0566B203	GLASSES/RESPIRATOR LABEL
204	P0566B204	DOOR CLOSED LABEL
206	P0566B206	READ MANUAL LABEL
207	P0566B207	ELECTRICITY LABEL
210	P0566B210	TOUCH-UP PAINT, GRIZZLY GREEN

REF	PART #	DESCRIPTION
212	P0566B212	TOUCH-UP PAINT, GREY PUTTY
213	P0566B213	DISCONNECT POWER LABEL
215	P0566B215	TENSION ADJ LABEL
216V2	P0531B216V2	MACHINE ID LABEL V2.09.18 (G0531B)
216V2	P0566B216V2	MACHINE ID LABEL V2.09.18 (G0566B)
218	P0566B218	TABLE LOCK LABEL
220	P0566B220	MAGNETIC BRAKE NOTICE
221	P0566B221	GRIZZLY.COM LABEL

## WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or [www.grizzly.com](http://www.grizzly.com) to order new labels.





# Warranty & 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.

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.

In the event you need to use 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.

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.

To take advantage of this warranty, you must register it at <https://www.grizzly.com/secureforms/warranty-card>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.



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## **Industrial Bandsaw MODEL G0566/G0568/G0569 INSTRUCTION MANUAL**



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#CA6450. REVISED OCTOBER, 2004. PRINTED IN TAIWAN

# WARNING

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

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

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

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# INTRODUCTION

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## Foreword

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We are proud to offer the Model G0566/G0568/G0569 Industrial Bandsaw. This machine is part of a growing Grizzly family of fine woodworking 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 G0566/G0568/G0569. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0566/G0568/G0569 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](http://www.grizzly.com). Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!



## Contact Info

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

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

We stand behind our machines. 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](mailto: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 G0566 21" HEAVY-DUTY BANDSAW

Design Type ..... Floor Model

### Overall Dimensions:

Table Size ..... 29½" x 20¾" x 1⅞"  
 Height From Floor To Table ..... 35½"  
 Overall Height ..... 78"  
 Overall Width ..... 39½"  
 Overall Depth (Including Fence) ..... 28⅝"  
 Shipping Weight ..... 678 lbs.  
 Machine Weight ..... 581 lbs.  
 Crate Size ..... 26½" L x 39" W x 87" H  
 Footprint ..... 33½" W x 21⅝" L

### Capacities:

Throat Capacity (Left of Blade) ..... 20"  
 Max Cutting Width w/Fence ..... 18½"  
 Height Capacity ..... 14"  
 Table Tilt ..... 45°R  
 Blade Size Range ..... ¼"—1⅜"  
 Standard Blade Length ..... 165"  
 Blade Speeds ..... 4600 FPM

### Construction:

Table ..... Precision Ground Cast Iron  
 Wheels ..... Fully Balanced Cast Iron w/Polyurethane Tires  
 Rip Fence ..... Precision Ground Cast Iron  
 Wheel Covers ..... Pre-Formed Steel  
 Guides ..... Ball Bearing

### Main Motor:

Type ..... TEFC Capacitor-Start Induction  
 Horsepower ..... 3 HP  
 Phase / Voltage ..... Single-Phase / 220V  
 Amps ..... 15A  
 Cycle / RPM ..... 60 Hertz / 1725 RPM  
 Switch ..... Magnetic w/Thermal Overload Protection  
 Bearings ..... Shielded & Permanently Lubricated Ball Bearings

### Features:

..... 4" Dust Port x 2  
 ..... Quick Change Blade Release/Tensioner  
 ..... Blade Tension Indicator  
 ..... Micro-Adjusting Rack & Pinion Table Tilt  
 ..... Height Scale Measurement  
 ..... Foot Brake Stop  
 ..... Included Miter Gauge  
 ..... Rack & Pinion Upper Guide Adjustment  
 ..... Magnifying Window Over Fence Scale  
 ..... Hinged Wheel Covers w/Safety Lock

Specifications, while deemed accurate, are not guaranteed.



# MACHINE DATA SHEET

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

## MODEL G0568 24" HEAVY-DUTY BANDSAW

Design Type ..... Floor Model

### Overall Dimensions:

Table Size ..... 33½" x 23⅝" x 2"  
 Height From Floor To Table ..... 34½"  
 Overall Height ..... 83½"  
 Overall Width ..... 47⅝"  
 Overall Depth (Including Fence) ..... 31¼"  
 Shipping Weight ..... 957 lbs.  
 Machine Weight ..... 836 lbs.  
 Crate Size ..... 29" L x 45¼" W x 88" H  
 Footprint ..... 41⅜" W x 23½" L

### Capacities:

Throat Capacity (Left of Blade) ..... 24½"  
 Height Capacity ..... 16"  
 Table Tilt ..... 45°R  
 Blade Size Range ..... ¼"-1½"  
 Standard Blade Length ..... 181"  
 Blade Speeds ..... 5300 FPM

### Construction:

Table ..... Precision Ground Cast Iron  
 Wheels ..... Fully Balanced Cast Iron w/Rubber Tires  
 Rip Fence ..... Precision Ground Cast Iron  
 Wheel Covers ..... Pre-Formed Steel  
 Guides ..... Ball Bearing

### Main Motor:

Type ..... TEFC Capacitor-Start Induction  
 Horsepower ..... 5 HP  
 Phase / Voltage ..... Single-Phase / 220V  
 Amps ..... 30A  
 Cycle / RPM ..... 60 Hertz / 1725 RPM  
 Switch ..... Magnetic w/Thermal Overload Protection

Bearings ..... Shielded & Permanently Lubricated Ball Bearings

### Features:

..... 4" Dust Port x 2  
 ..... Quick Change Blade Release/Tensioner  
 ..... Blade Tension Indicator  
 ..... Micro-Adjusting Rack & Pinion Table Tilt  
 ..... Height Scale Measurement  
 ..... Foot Brake Stop  
 ..... Included Miter Gauge  
 ..... Rack & Pinion Upper Guide Adjustment  
 ..... Magnifying Window Over Fence Scale  
 ..... Hinged Wheel Covers w/Safety Lock

Specifications, while deemed accurate, are not guaranteed.



# MACHINE DATA SHEET

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

## MODEL G0569 24" HEAVY-DUTY BANDSAW

Design Type ..... Floor Model

### Overall Dimensions:

Table Size ..... 33½" x 23⅝" x 2"  
 Height From Floor To Table ..... 34½"  
 Overall Height ..... 83½"  
 Overall Width ..... 47⅝"  
 Overall Depth (Including Fence) ..... 31¼"  
 Shipping Weight ..... 957 lbs.  
 Machine Weight ..... 836 lbs.  
 Crate Size ..... 29" L x 45¼" W x 88" H  
 Footprint ..... 41⅜" W x 23½" L

### Capacities:

Throat Capacity (Left of Blade) ..... 24½"  
 Height Capacity ..... 16"  
 Table Tilt ..... 45° R  
 Blade Size Range ..... ¼"–1½"  
 Standard Blade Length ..... 181"  
 Blade Speeds ..... 5300 FPM

### Construction:

Table ..... Precision Ground Cast Iron  
 Wheels ..... Fully Balanced Cast Iron w/Rubber Tires  
 Rip Fence ..... Precision Ground Cast Iron  
 Wheel Covers ..... Pre-Formed Steel  
 Guides ..... Ball Bearing

### Main Motor:

Type ..... TEFC Induction  
 Horsepower ..... 7½ HP  
 Phase / Voltage ..... 3-Phase / 220V/440V  
 Amps ..... 20A/10A  
 Cycle / RPM ..... 60 Hertz / 1725 RPM  
 Switch ..... Magnetic w/Thermal Overload Protection

Bearings ..... Shielded & Permanently Lubricated Ball Bearings

### Features:

..... 4" Dust Port x 2  
 ..... Quick Change Blade Release/Tensioner  
 ..... Blade Tension Indicator  
 ..... Micro-Adjusting Rack & Pinion Table Tilt  
 ..... Height Scale Measurement  
 ..... Foot Brake Stop  
 ..... Included Miter Gauge  
 ..... Rack & Pinion Upper Guide Adjustment  
 ..... Magnifying Window Over Fence Scale  
 ..... Hinged Wheel Covers w/Safety Lock

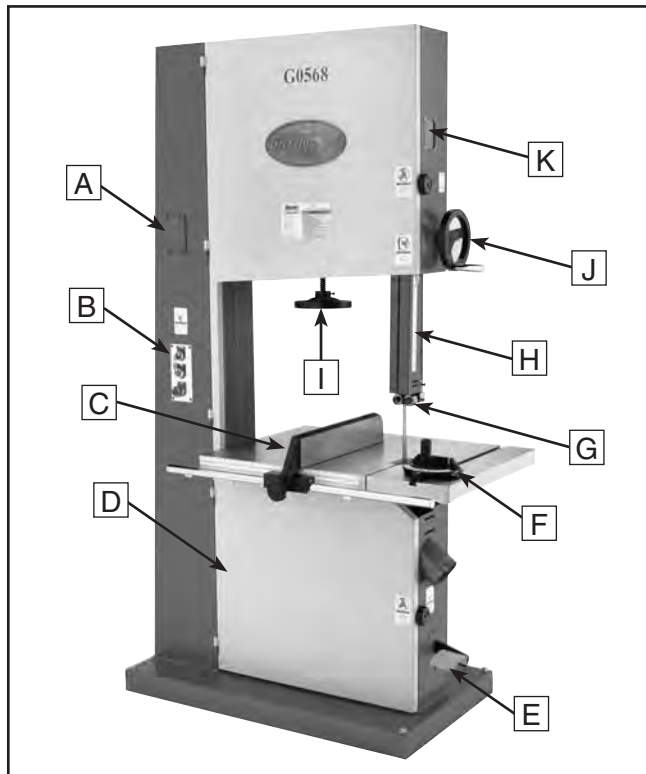
Specifications, while deemed accurate, are not guaranteed.



# Machine Features

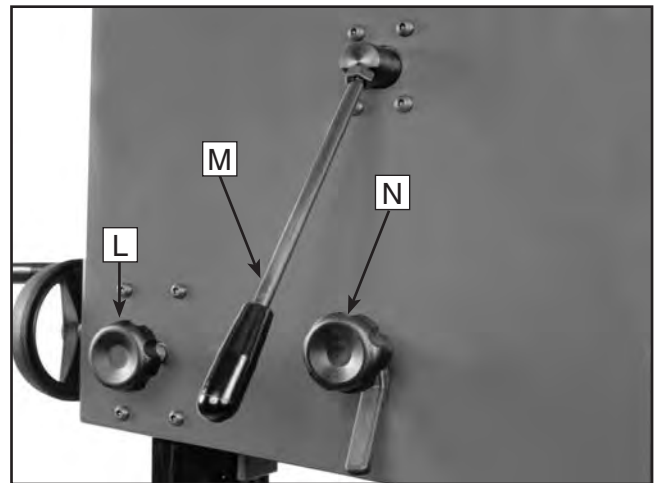
The instructions in this manual will be easier to understand if you become familiar with the location and names of the basic features of your new machine.

Match up the feature list below with the letters in **Figures 1, 2, and 3** to identify the external bandsaw feature locations.



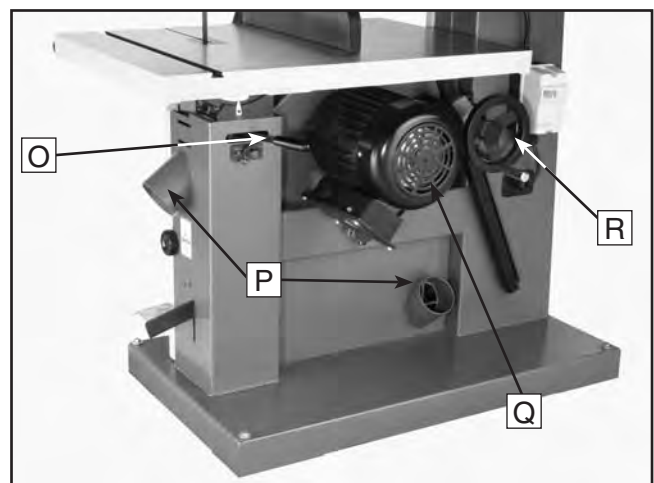
**Figure 1.** Front of the bandsaw.

- A. Tension Indicator Window
- B. Key Switch, Start & Stop Buttons
- C. Rip Fence
- D. Hinged Wheel Cover
- E. Foot Brake
- F. Miter Gauge
- G. Ball Bearing Blade Guides
- H. Cutting Height Scale
- I. Blade Tension Handwheel
- J. Guide Post Handwheel
- K. Blade Tracking Window



**Figure 2.** Rear, top-side of the bandsaw.

- L. Guide Post Lock Knob
- M. Blade Tension Lever
- N. Blade Tracking Knob



**Figure 3.** Rear, lower-side of the bandsaw.

- O. Table Lock Lever
- P. (2) 4" Dust Ports
- Q. Motor
- R. Table Tilt Handwheel




# SECTION 1: SAFETY


## **WARNING**

### **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.

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

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

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

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

## **WARNING**

### **Safety Instructions for Machinery**

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. MAKE SURE ALL GUARDS ARE IN THEIR CORRECT PLACE AND WORK CORRECTLY BEFORE USING MACHINERY. NEVER OPERATE MACHINE WITHOUT GUARDS.**
- 3. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 4. 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.
- 5. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 6. 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.

# WARNING

## Safety Instructions for Machinery

7. **NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.
8. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
9. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
10. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
11. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power OFF and allow all moving parts to come to a complete stop before leaving machine unattended.
12. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
13. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
14. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and reduce voltage. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
15. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
16. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery 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 machine 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 machine 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 machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to be ejected.
24. **ALWAYS LOCK MOBILE BASES BEFORE OPERATING MACHINERY.**

# WARNING

## Additional Safety Instructions for Bandsaws

- 1. BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.
- 2. HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Serious personal injury could occur.
- 3. GUARDS.** Do not operate this bandsaw without blade guard in place.
- 4. BLADE REPLACEMENT.** When replacing blades, make sure teeth face down toward the table. The force of the cut is always down. Make sure the blade is properly tensioned after installing.
- 5. WORKPIECE HANDLING.** Always support the workpiece with table or some type of support fixture. Always support round stock in a V-block.
- 6. WORKPIECE HANDLING.** Plan your cuts so you always cut out of the wood. Do not back workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw OFF and wait for the blade to come to a complete stop. Do not twist or put excessive stress on the blade while backing work away.
- 7. BLADE SPEED.** Blade should be running at full speed before beginning a cut.
- 8. WORKPIECE PRESSURE.** Always feed stock evenly and smoothly. Do not force or twist blade while cutting, especially when sawing small radii.
- 9. MATERIAL.** This machine is not designed to cut metal or any material except wood.
- 10. BLADE CONTROL.** Do not attempt stop or slow blade with anything other than the foot brake. Allow it to come to a complete stop before you leave it unattended.
- 11. MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the power OFF and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
- 12. HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
- 13. IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.

### WARNING

Like all machines there is danger associated with the Model G0566/G0568/G0569. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with caution to reduce the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

### CAUTION

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

# SECTION 2: CIRCUIT REQUIREMENTS

## G0566/G0568

### **WARNING**

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

The Model G0566/G0568 requires a 220V, single-phase power circuit for safe operation. A cord is not provided because the style of cord used will vary depending upon the type electrical service of each particular shop.

### **Amperage Draw**

G0566 3HP Motor ..... 15 Amps  
G0568 5HP Motor ..... 30 Amps

### **Circuit Breaker Requirements**

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

G0566.....20 Amp  
G0568.....35 Amp

### **Minimum Cord Requirements**

For 220V single-phase operation, use the following type of cord:

Cord.....3 Wire, Copper  
G0566 Gauge..... 14 AWG  
G0568 Gauge.....8 AWG



### **Plug Type**

We recommend using the following plug and receptacle to connect your machine to power.

G0566..... L6-20  
G0568..... L6-35

### **Grounding**

In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded as well. All electrical connections must be made in accordance with local codes and ordinances.

	<h3> <b>WARNING</b></h3> <p><b>Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!</b></p>
---	--

### **Your Shop Circuit Capacity**

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



# G0569

## **!WARNING**

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

The Model G0569 is prewired for 220V 3-phase power, but can be rewired for 440V 3-Phase power operation. A cord is not provided because the style of cord used will vary depending upon the type of electrical service in each particular shop.

### **Amperage Draw**

The Model G0569 has a 7<sup>1</sup>/<sub>2</sub> HP motor that will draw the following amps:

220 Volt 3-Phase.....	20 Amps
440 Volt 3-Phase.....	10 Amps

### **Circuit Breaker Requirements**

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

220 Volt 3-Phase.....	25 Amp
440 Volt 3-Phase.....	15 Amp

### **Minimum Cord Requirements**

220V 3-phase:

Cord.....	Copper
Gauge.....	12 AWG

440V 3-phase:

Cord.....	Copper
Gauge.....	12 AWG


### **Plug Type**

The plug you install on your cord will depend upon the type of service you currently have or plan to install. We recommend using the following plug and receptacle for your machine on a dedicated circuit only:

220 Volt Plug & Receptacle .....	L15-30
440 Volt Plug & Receptacle .....	L16-20

### **Grounding**

In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded as well. All electrical connections must be made in accordance with local codes and ordinances.

	<b>!WARNING</b> Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!
---	---

### **Your Shop Circuit Capacity**

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

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



# Rewiring G0569 to 440V

The Model G0569 can be rewired for 440V operation. This rewiring job consists of disconnecting the saw from the power source, changing the magnetic switch, and rewiring the cutting motor.

The Model G0569082A 440V Conversion Kit needed for this procedure can be purchased from Grizzly Industrial by calling our customer service number at (800) 523-4777.

This procedure takes moderate electrical skill and the rewiring job must be inspected by a qualified electrician before the saw is connected to the power source.

**To rewire the Model G0569 for 440V operation:**

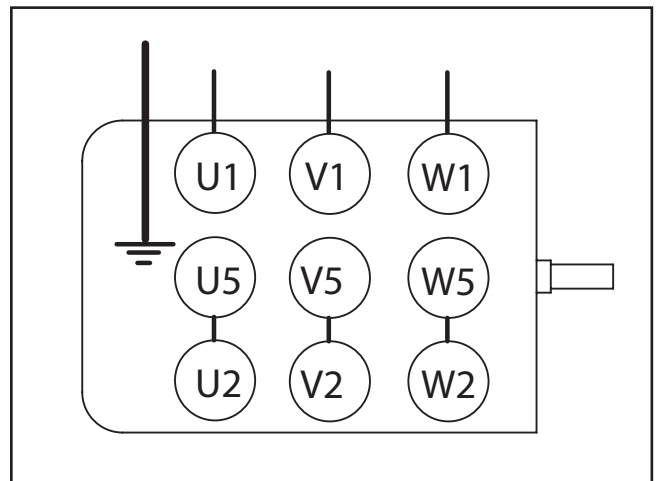
1. **Unplug the Bandsaw!**
2. Open the electrical panel (**Figure 4**), disconnect and remove the magnetic switch.
3. Install the 440V magnetic switch and wire



**Figure 4.** 220V Magnetic Switch

it according to the **G0569 Wiring Diagram** on **page 51**. Note—Consult the wiring diagram on the inside of the switch cover. If that diagram differs from the manual, use the diagram in the switch cover.

4. Raise the table, open the motor wiring cover and remove the motor wiring caps from the motor.
5. Rewire the motor as shown in **Figure 5**. Note—Consult the wiring diagram on the inside of the motor cover. If that diagram differs from the manual, use the diagram in the motor cover.
6. Install the switch cover and lower the table.

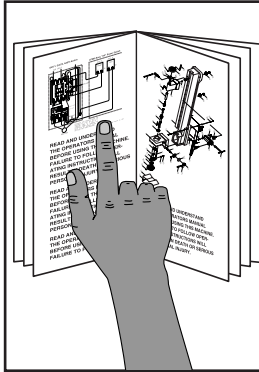


**Figure 5.** 440V motor wiring.



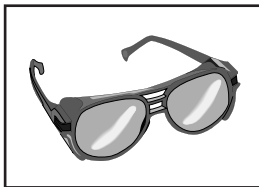
# SECTION 3: SET UP

## Set Up Safety



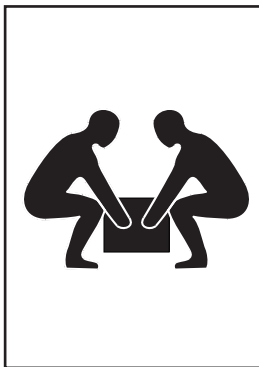
### **!WARNING**

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



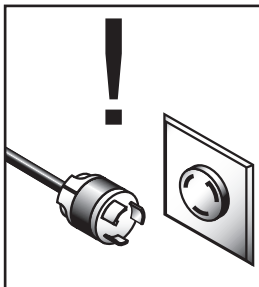
### **!WARNING**

Wear safety glasses during the entire set up process!



### **!WARNING**

The Model G0566/G0568/G0569 is a heavy machine (581/863 lbs. shipping weight). DO NOT over-exert yourself while unpacking or moving your machine—get assistance.



### **!WARNING**

Perform all set up procedures with the machine disconnected from its power source. Failure to do so may result in serious personal injury.



## Items Needed for Set Up

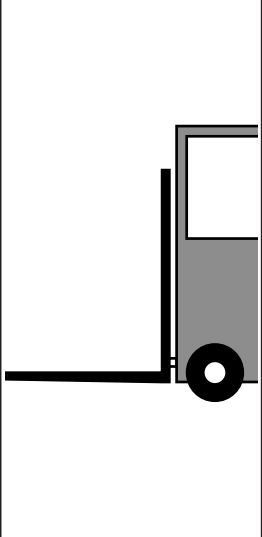
The following items are needed to complete the set up process, but are not included with your machine:

DESCRIPTION	QTY
• Safety Glasses (for each person) .....	1
• Phillips Screwdriver .....	1
• Straight Slot Screwdriver.....	1
• Feeler Gauge .016", .004".....	1
• Machinists Square.....	1
• Straightedge (approximately 24").....	1
• Fine Ruler.....	1
• Dust Collection System .....	1
• 4" Dust Hose (length as needed) .....	2
• 4" Hose Clamp .....	4





# Unpacking

	<p><b>⚠️ WARNING</b></p> <p>The Model G0566/G0568/G0569 is a heavy machine that weighs approximately 581/836 lbs. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.</p>
---	---

The Model G0566/G0568/G0569 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 the contents.

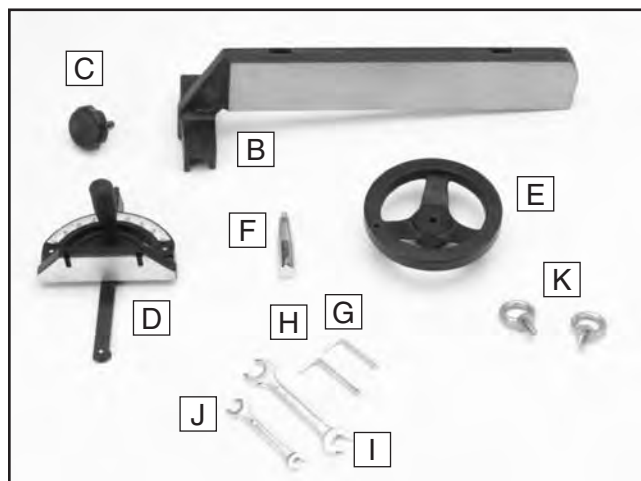


# Inventory

After everything has been removed from the crate, you should have the following items:

## Inventory (Figure 6):

- A. Bandsaw (not shown)..... 1
- B. Fence ..... 1
- C. Hand Knob ..... 1
- D. Miter Gauge..... 1
- E. Handwheel ..... 1
- F. Handle (G0568/G0569)..... 1
- G. Hex Wrench 5mm..... 1
- H. Hex Wrench 6mm..... 1
- I. Open End Wrench 10mm x 13mm..... 1
- J. Open End Wrench 17mm x 19mm ..... 1
- K. Lifting Rings ..... 2



**Figure 6.** Inventory

## Inventory G0568 / G0569 only (not shown):

- L. Riser Blocks ..... 2
- N. Hardware Bag ..... 1
  - Hex Bolt M12-1.75 x 110..... 4
  - Flat Washers 12mm ..... 4
  - Lock Washers 12mm..... 4

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

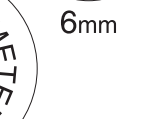
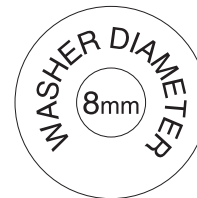
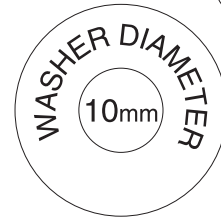
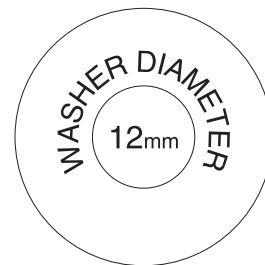
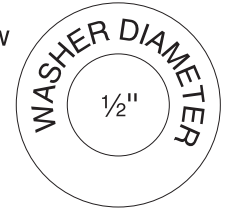
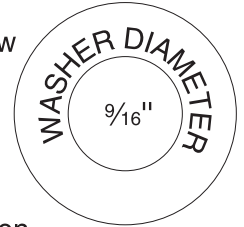
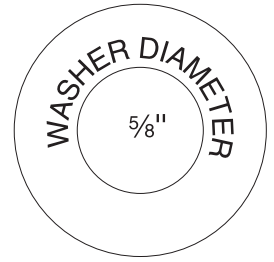
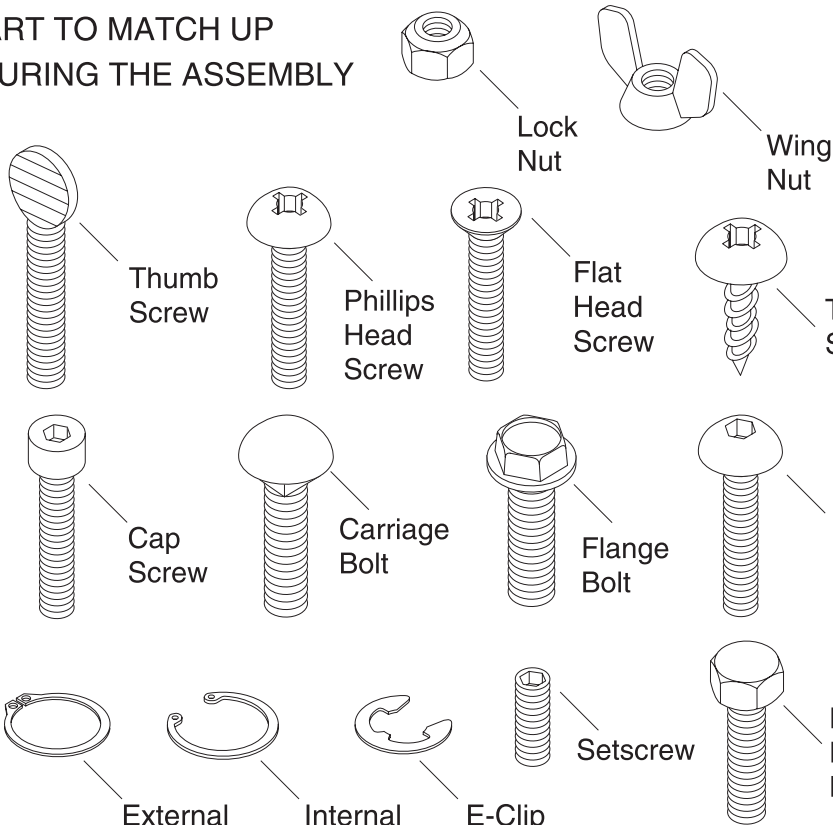


# Hardware Recognition Chart

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

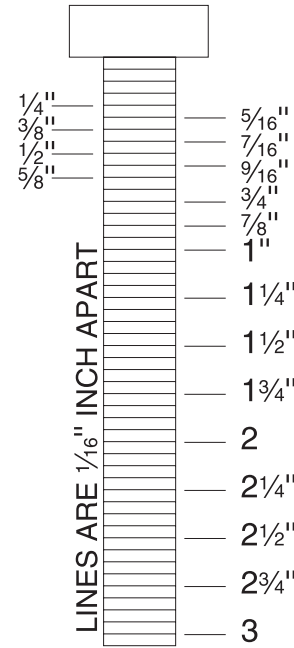
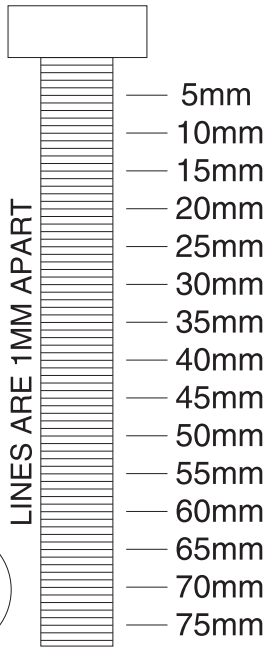
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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



#10

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



WASHERS ARE MEASURED BY THE INSIDE DIAMETER

LINES ARE 1MM APART

LINES ARE 1/16" INCH APART

# Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.



## Site Considerations

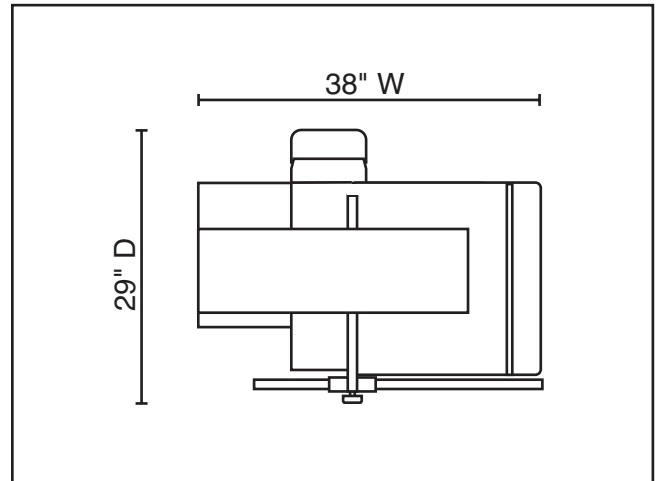
	<p><b>⚠ CAUTION</b></p> <p><b>Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</b></p>
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### G0566 Floor Load

The Model G0566 weighs 581 lbs. and has a base footprint of 33 $\frac{1}{2}$ " W x 21 $\frac{5}{8}$ " D. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

### G0566 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 saw. See **Figure 7** for the minimum working clearances of the Model G0566.



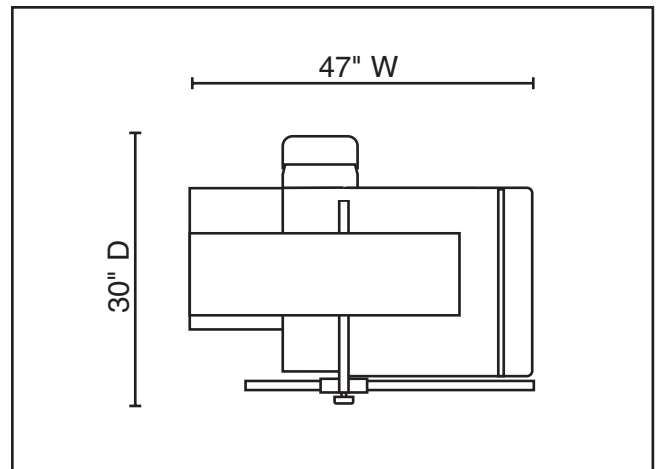
**Figure 7.** G0566 working clearances.

### G0568/G0569 Floor Load

The Model G0568/G0569 weighs 836 lbs. and has a base footprint of 41 $\frac{3}{8}$ " W x 23 $\frac{1}{2}$ " L. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

### G0568/G0569 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 saw. See **Figure 8** for the minimum working clearances of the Model G0568/G0569.



**Figure 8.** G0568/G0569 working clearances.



# Riser Blocks

Riser blocks, shown in **Figure 9**, are included with the Model G0568/G0569 to match the height of the table to your personal preference or needs. This added feature, when installed, lifts the working table height from 32<sup>1</sup>/<sub>2</sub>" to 34<sup>1</sup>/<sub>2</sub>".

<b>Components and Hardware Needed:</b>	<b>Qty</b>
Hex Bolts M12-1.75 x 110.....	4
Flat Washers 12mm .....	4
Lock Washers 12mm.....	4
Riser Bars.....	2

**Tools Needed:**

Hex Wrench/Socket 19mm.....	1
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**Figure 9.** Optional riser blocks and hardware.

**To install the riser blocks:**

1. Lift the Model G0568/G0569 with a forklift or other power equipment.
2. Place the four hex bolts, lock washers, and flat washers, down through the holes in the base.
3. Locate and align the threaded holes in the riser bars, then securely tighten the bolts.

Note—The riser bars have tabs with holes for mounting the bandsaw unit to the floor to maximize stability. We highly recommend utilizing them and securing the bandsaw to the floor.



# Fence

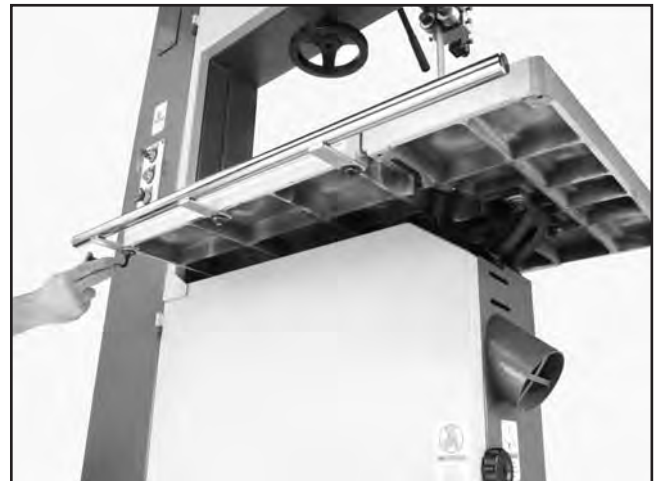
<b>Components and Hardware Needed:</b>	<b>Qty</b>
Fence.....	1
Hand Knob .....	1

**Tools Needed:**

Hex Wrench 6mm.....	1
Phillips Screwdriver .....	1

**To install the fence:**

1. Remove the cap screws holding the rail onto the table, and remove the rail.
2. Flip the rail over and reinstall with the cap screws removed in **step 1 (Figure 10)**.



**Figure 10.** Tightening guard rail cap screws.

3. Place the fence on the rail (**Figure 11**) and tighten securely with the hand knob. See **page 23** to calibrate the pointer.

# Handwheel



**Figure 11.** Installing fence onto rail.



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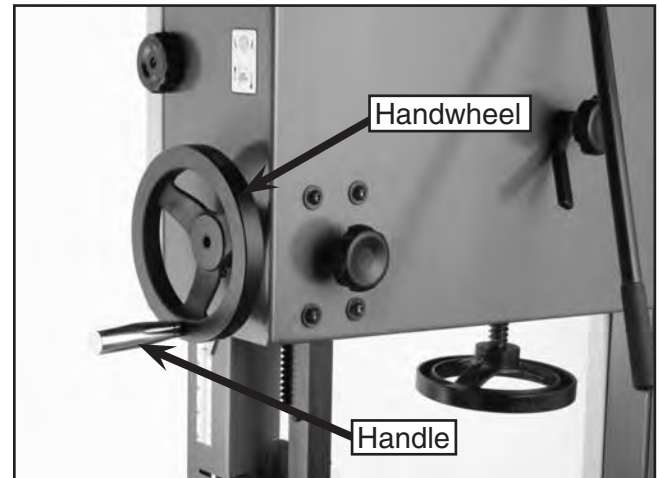
Components and Hardware Needed:	Qty
Handwheel.....	1
Handle (G0568/G0569 only) .....	1

## Tools Needed:

Hex Wrench 5mm.....	1
Wrench 14mm (G0568/G0569 only) .....	1

## To install the handwheel (Figure 12):

1. Slide the handwheel on to the shaft.
2. Tighten the cap screw in the handwheel securely.
3. Thread the handle in to the handwheel (G0568/G0569 only) and tighten with the 14mm wrench.



**Figure 12.** Handwheel correctly installed.



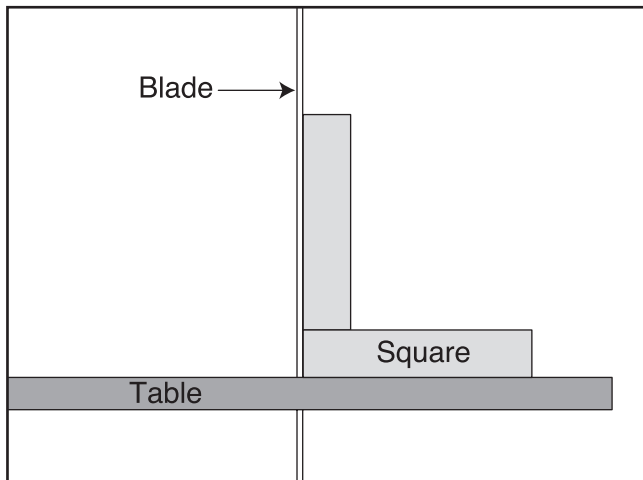
# Adjusting Positive Stop

The adjustable positive stop allows the table to be reset perpendicular (90°) to the blade after tilting to the right.

<b>Tools Needed:</b>	<b>QTY</b>
Wrenches 17mm .....	2
Machinist's Square .....	1

## To set the positive stop:

1. Tension the tension to the appropriate level for the blade size by referencing the tension gauge.
2. **Unplug the bandsaw!**
3. Loosen the check-nut that locks the positive stop adjusting bolt in place.
4. Raise the guide post and place a 6" machinist's square on the table next to the side of the blade as illustrated in **Figure 13**. Tilt the table until the table rests at 90° to the blade, then secure with the table tilt lock lever.



**Figure 13.** Squaring table to blade.

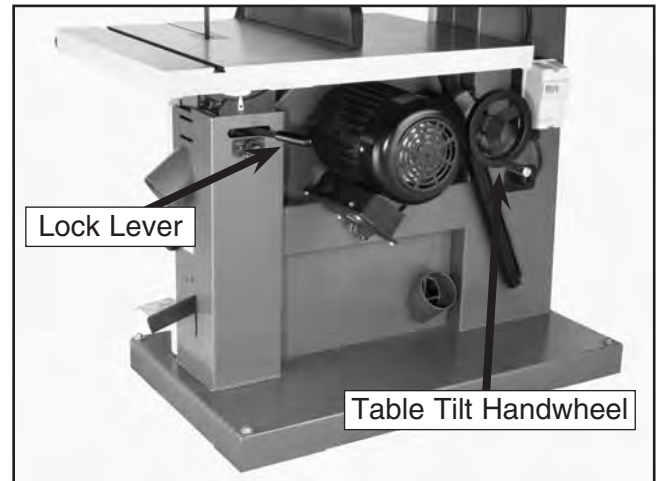
5. Adjust the positive stop bolt to the adjusted height of the table.
6. Secure the positive stop bolt by tightening the check-nut with another wrench.



# Table Tilt

The table can be tilted 5° to the left and 45° to the right for performing angled cuts. Study **Figure 14** to become familiar with the table tilt controls.

<b>Tools Needed:</b>	<b>QTY</b>
Wrenches 17mm .....	2



**Figure 14.** Table tilt controls.

## To adjust the table tilt:

1. Loosen the table tilt lock lever.
2. To tilt the table to the right, turn the table tilt handwheel clockwise.
3. To tilt the table to the left, turn the table tilt handwheel clockwise one turn, lower the positive stop bolt, then turn the handwheel counterclockwise.
4. Secure the table tilt lock lever.



# Blade Tracking

The blade tracking is primarily affected by the tilt of the upper wheel, also known as **Center Tracking**; and the alignment of both wheels, also known as **Coplanar Tracking** (see “Wheel Alignment” on page 46)

The wheels were aligned at the factory, so center tracking is the only adjustment that needs to be performed during set up.

## To center track the blade:

1. Adjust the upper and lower guide bearings and support bearings away from the blade.
2. Open the upper wheel cover.
3. Adjust blade tension to match the size of the installed blade with the mark on the blade tension scale. Note—Changes in blade tension may change the blade tracking.

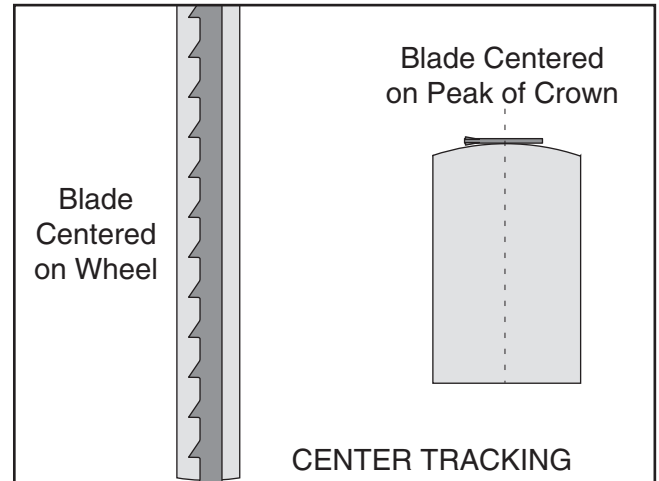
## CAUTION

The cast iron wheels may have sharp edges and blade teeth may extend beyond the edge of the wheel, creating a laceration hazard. Be careful when hand turning the wheels.

4. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 15** for an illustration of this concept.

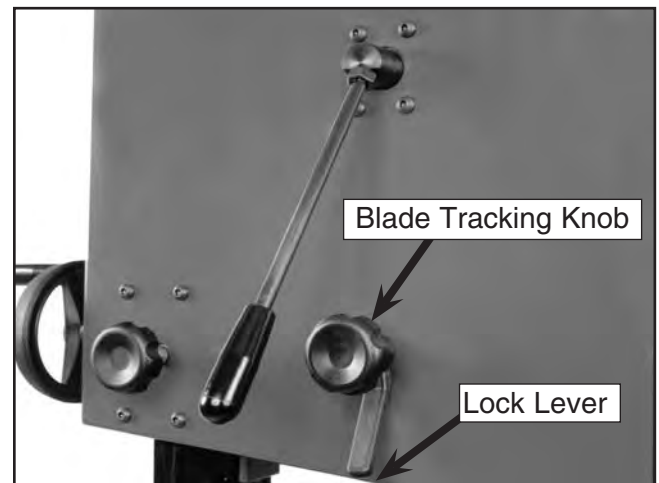
—If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, then the bandsaw is already tracked properly and no further adjustments are needed at this time.

—If the blade does not ride in the center of the upper wheel and is not centered on the peak of the wheel crown, then continue with the following steps.



**Figure 15.** Center tracking profiles.

5. Loosen the lock lever (**Figure 16**) on the blade tracking knob.



**Figure 16.** Blade lock lever and tracking knob.

6. Spin the upper wheel with one hand and rotate the blade tracking knob with the other hand to make the blade ride in the center of the bandsaw tire, while observing the tracking path through the blade tracking window.
7. When the blade is tracking correctly, tighten the tracking control lock handle and close the upper wheel cover.

Note—For the best performance from your saw, regularly maintain the proper tracking of the blade.



# Table Alignment

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To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade.

<b>Tools Needed:</b>	<b>QTY</b>
Hex Wrench 8mm.....	1
Straightedge .....	1
Fine Ruler.....	1

## To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and is correctly tensioned.
2. Loosen the trunnion cap screws that secure the table to the trunnions.
3. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.
4. Use a fine ruler to gauge the distance between the blade and the miter slot. The distance you measure should be the same at both the front and the back of the table.
5. Rotate the table in the direction needed to correctly align the table.
6. Tighten the trunnion cap screws when the alignment is correct.



# Miter Gauge

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The miter gauge needs to be calibrated to the blade when it is first mounted in the table slot.

## To calibrate the miter gauge:

1. Use a machinist square with one edge against the face of the miter gauge and the other against the belt face as shown in **Figure 17**.



**Figure 17.** Squaring miter gauge to blade.

2. Loosen the lock knob on the miter gauge and adjust it flush with the edge of the square.
3. Tighten the lock knob, and verify the setting. **Note**—Sometimes the tightening procedure can affect the adjustment.
4. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.
5. Retighten the screw that secures the angle pointer.





# Fence Alignment

Fence alignment is critical for optimum performance from your new bandsaw. Follow these steps to properly align the fence with the miter slot.

**Tools Needed:** **QTY**  
Hex Wrench 8mm..... 1

## To align the fence parallel to the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and re-install it on the right-hand side of the blade.
2. Loosen the three cap screws that secure the rail to the table.
3. Adjust the fence face parallel with the edge of the miter slot as shown in **Figure 18**.



**Figure 18.** Fence square with miter slot.

4. Tighten the three cap screws that secure the rail to the table.



# Pointer Calibration

Your new bandsaw is equipped with a fence measurement system that includes a fence pointer which must be calibrated when the bandsaw is first set up.

**Tools Needed:** **QTY**  
Phillips Screwdriver ..... 1

## To calibrate the pointer:

1. If the fence is mounted on the right-hand side of the blade, remove it and re-install it on the left-hand side of the blade.
2. Place the fence flush against the bandsaw blade (**Figure 19**).



**Figure 19.** Fence flush with blade.

3. Loosen the pointer adjustment screw and set the pointer in line with "0" and the measurement scale on the table.
4. Tighten the pointer adjustment screw.



# Dust Collection

## **⚠ CAUTION**

**DO NOT** operate the Model G0566/G0568/G0569 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Components and Hardware Needed:	Qty
4" Dust Hose (length varies) .....	2
4" Hose Clamps .....	4

Tools Needed:	
Phillips Screwdriver .....	1

### To connect a dust collection hose:

1. Place the hose clamps over the end of the 4" flexible hoses.
2. Fit the 4" flexible hoses over the dust ports, as shown in **Figure 20**, and tighten.



**Figure 20.** Dust hose attached to dust port.


3. Tug the hoses to make sure that they do not come off. A tight fit is necessary for best performance!
4. Connect the hoses to a dust collection system with the remaining hose clamps.



# Test Run

Once the assembly is complete and you have performed all the procedures in this manual up to this step, a test run of the machine is necessary to continue with the remainder of the Set Up procedures.

If, during the test run, there is a source of unusual noise or vibration that you can not easily locate, feel free to contact our service department for help.

	<h2><b>⚠ WARNING</b></h2> <p><b>Wear safety glasses during the entire test run process. Failure to comply may result in serious personal injury.</b></p>
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### To test run the machine:

1. Make sure that you have performed all procedures in this manual up to this step before continuing with these instructions.
2. Make sure that the blade guides are moved away from the blade and that the blade is not touching the table or table insert.
3. Plug the machine into the power source.
4. Turn the key ON, rotate the OFF button to the right, then press the ON button. Keep your hand poised over the switch in case you need to quickly turn the machine OFF.
5. Watch and listen to the bandsaw for abnormal noises or actions. The bandsaw should run smoothly with little or no vibration or rubbing noises. Note—Strange or unnatural noises should be investigated and corrected before further operation of the machine; always unplug the machine when investigating or correcting any situation with the machine. Refer to Troubleshooting on **page 68**.



# Tensioning Blade

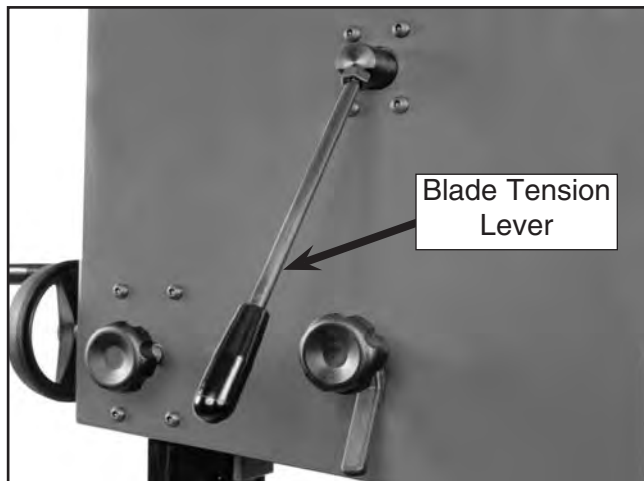
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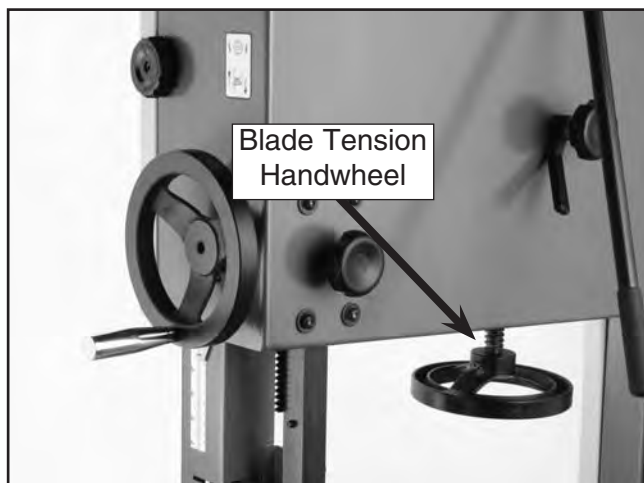
A properly tensioned blade is essential for making accurate cuts and is a prerequisite before making many bandsaw adjustments. Release the blade tension when not in use to minimize undue strain on the blade.

## To tension the bandsaw blade:

1. Make sure you have performed all procedures in this manual up to this point, and the blade guides are adjusted as far away as possible from the blade path.
2. With the blade tension lever in the down (engaged) position (**Figure 21**), adjust the blade tension handwheel (**Figure 22**) until the blade tension scale matches the size of blade that is installed on the bandsaw.



**Figure 21.** Blade tension lever engaged.



**Figure 22.** Blade tension handwheel.

3. Turn the bandsaw ON.
4. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.
5. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension one more quarter of a turn.
6. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future.

## NOTICE

**After blade tension and tracking are set correctly, properly adjust the upper and lower support bearings and guide-block assemblies into position before cutting operations.**



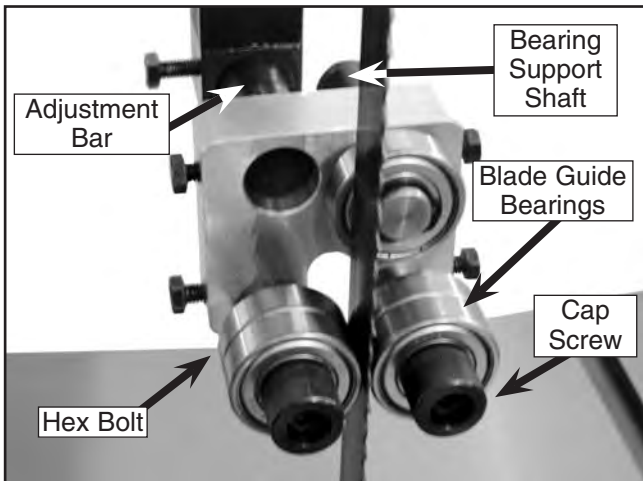
# Blade Guides

The blade guides provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side. Properly adjusted blade guides are essential to making accurate cuts.

<b>Tools Needed:</b>	<b>QTY</b>
Wrench 10mm .....	1
Hex Wrench 5mm.....	1

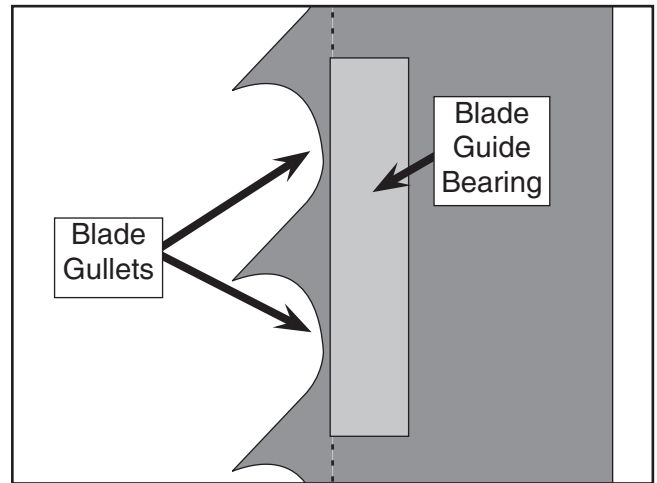
## To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Familiarize yourself with the blade guide controls shown in **Figure 23**.



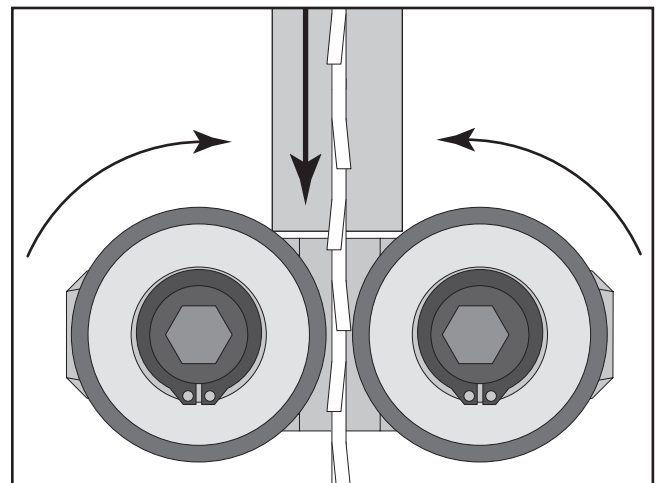
**Figure 23.** Blade guide controls.

4. Loosen the hex bolt on the bearing support shaft, and slide the blade support bearing all the way back.
5. Loosen the hex bolt on the adjustment bar and slide the bar forward or backward until the bearings rest  $\frac{1}{16}$ " back from the blade gullets as shown in **Figure 24**.



**Figure 24.** Proper position of blade guides.

6. Tighten the hex bolt on the adjustment bar to secure the guide bearings position.
7. Loosen the lower two hex bolts on the blade guide support bracket.
8. Rotate the bearings with the hex wrench until the bearings almost touch the blade as illustrated in **Figure 25**. Note—Fold a dollar bill in half, place it over the blade. Slide the dollar bill and bearing through the blade guides. If the dollar bill and blade do not fit through the guides, they are too tight.



**Figure 25.** Blade guides bearings properly adjusted.

9. Tighten the hex bolts to lock the blade guides in position. Note—after the blade guides are tightened, the bearings should still spin.



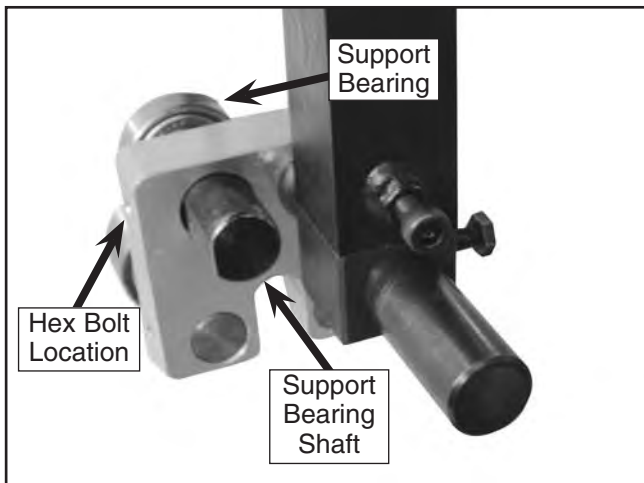
# Support Bearings

The support bearings are positioned behind the blade and support the back of the blade during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

Tools Needed:	QTY
Wrench 10mm .....	1
Feeler Gauge .016" .....	1

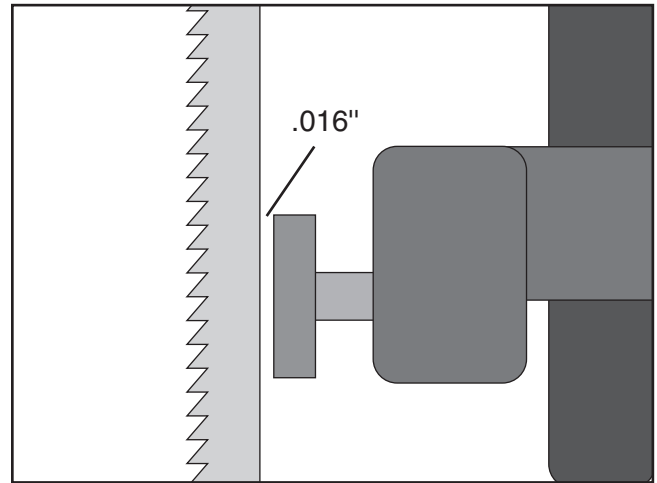
### To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **Unplug the bandsaw!**
3. Familiarize yourself with the support bearing detail shown in **Figure 26**.



**Figure 26.** Support bearing detail.

7. Loosen the hex bolt on the support bearing shaft.
8. Using the feeler gauge, position the support bearing approximately .016" away from the back of the blade as illustrated in **Figure 27**.



**Figure 27.** Support bearing spacing.

10. Tighten the hex bolt on the support bearing shaft to keep the support bearing locked in place.

## NOTICE

**When changing a blade or adjusting tension and tracking, all blade support bearings and guide-blocks must be properly adjusted before cutting operations.**

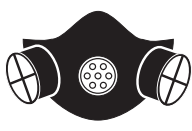


# SECTION 4: OPERATIONS

## Operation Safety

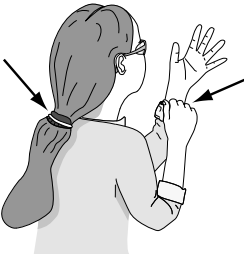
### ⚠️ WARNING

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



### ⚠️ WARNING

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



### NOTICE

If you have never used this type of machine or 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.

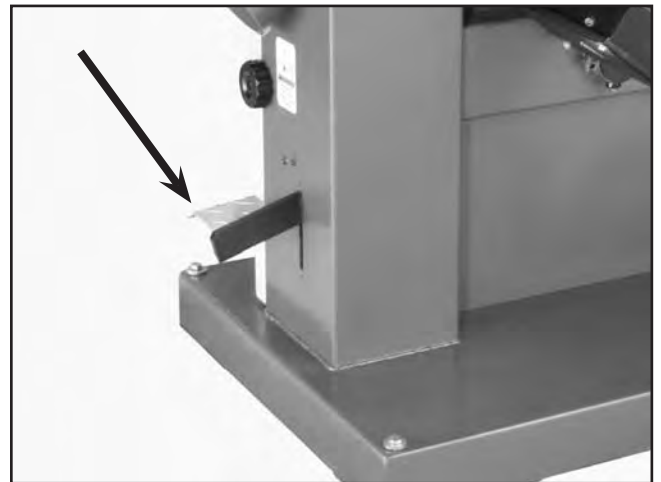


## Foot Brake

The Model G0566/G0568/G0569 is equipped with a foot brake (**Figure 28**). Use the brake only in emergency situations to disconnect power to the motor and bring the blade to a halt.

### ⚠️ CAUTION

The foot brake will not stop the bandsaw wheels and blade instantly. **DO NOT** become over confident and relax your safety awareness because of the foot brake feature.



**Figure 28.** The foot brake is located below the dust collection port.



# Key Switch

One of the most useful safety features of the Model G0566/G0568/G0569 is the key switch (**Figure 29**). To disable the ON and OFF controls turn the key to "0" and remove the key if desired. To enable the ON and OFF controls, turn the key to "1". The OFF button functions also as an emergency stop switch. If at any time during operation of the bandsaw a safety hazard present itself, immediately press the OFF button, or use the foot brake to bring the blade to a halt.



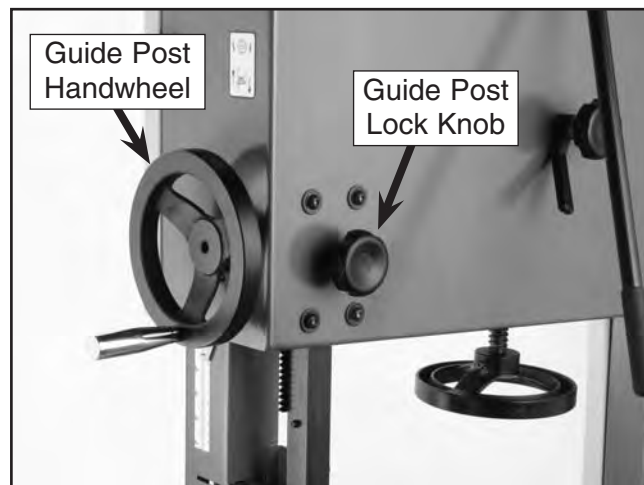
**Figure 29.** G0566/G0568/G0569 control panel.

	<p><b>⚠ CAUTION</b></p> <p>Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and <b>DO NOT</b> allow unsupervised children or visitors in your shop at any time!</p>
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# Guide Post

The guide post moves up and down on a rack-and-pinion system that is adjusted by turning the guide post handwheel shown in **Figure 30**. The upper blade guide assembly is attached to the bottom end of the guide post. The guide post/upper blade guide assembly is set correctly when the bottom edge of the guide bearings are approximately  $\frac{1}{4}$ " above the top surface of the workpiece.



**Figure 30.** Guide post handwheel and lock knob.

## To adjust the guide post:

1. Loosen the guide post lock knob.
2. Turn the guide post handwheel to raise or lower the guide post/upper blade guide assembly  $\frac{1}{4}$ " above the workpiece.
3. Tighten the guide post lock knob.



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# Ripping

Ripping is cutting with the grain direction of the workpiece. Ripping man-made wood products like plywood is cutting parallel with the longest side.

## To make a rip cut:

1. Set the fence to the desired width of cut on the fence rail scale.
2. Adjust the guide post/blade guide assembly to the correct height.
3. Square one long edge of the workpiece on a jointer.
4. Place jointed edge of the workpiece against the fence, and feed the workpiece into the saw blade with a push stick as shown in **Figure 31**. Refer to "Blade Lead" on **page 32** for further instruction.



**Figure 31.** Ripping with a push stick.



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# Crosscutting

Crosscutting is cutting across the grain direction of the workpiece. Crosscutting man-made wood products like plywood is cutting parallel with the shortest side.

## To make a 90° crosscut:

1. Adjust the miter gauge to the 90° position.
2. Adjust the guide post to the correct height.
3. Position the workpiece against the miter gauge and line up the cut with the blade.
4. While holding the workpiece against the miter gauge, feed the workpiece through the saw blade as shown in **Figure 32**. Refer to "Blade Lead" on **page 32** for further instruction.



**Figure 32.** Crosscutting with the miter gauge.





# Resawing

Resawing is cutting a board into two thinner pieces. The width and length dimensions remain the same. The maximum workpiece height that can be resawn is 20" on the Model G0566 and 24<sup>1</sup>/<sub>2</sub>" G0568 & G0569.

## To make a resaw cut:

1. For the most accurate and straight cut, install the widest blade available for your bandsaw when performing resaw operations. The best tooth style is a hook tooth between 3 and 6 teeth-per-inch.
2. Joint one face of the workpiece on a jointer.
3. Adjust the guide post/blade guide assembly to the correct height for the workpiece.
4. Adjust the fence to the desired location for the planned cut.
5. The jointed face of the workpiece must be against the fence during the operation. Use a push paddle, and slowly feed the workpiece into the blade (**Figure 33**). Refer to "Blade Lead" on **page 32** for further instruction.



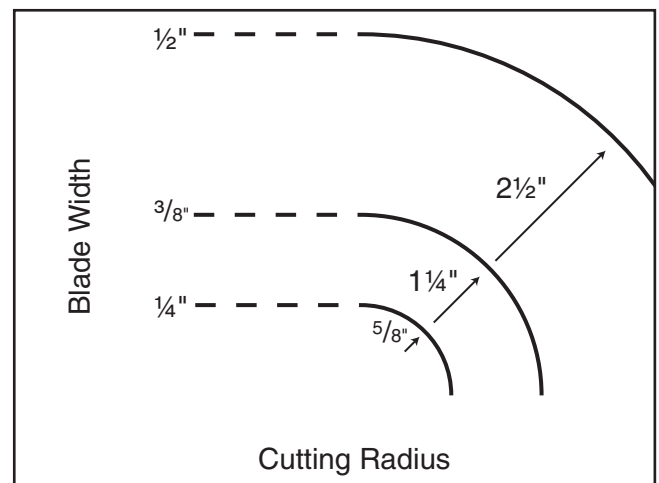
**Figure 33.** Resawing lumber.



# Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without being twisted. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more teeth-per-inch (TPI), or make relief cuts into the tight corners. A blade with more TPI can cut relatively tighter curves, though the cut is usually rougher than cuts produced by a blade with a medium amount of TPI.

Always make short cuts first, then proceed to the longer cuts. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the cut line. Make relief cuts from the workpiece edge to points along the cut line where there are sharp changes in direction. Relief cuts will reduce the chance that the blade will be pinched or twisted. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. (**Figure 34**).



**Figure 34.** Blade width to cutting radius chart.



# Blade Lead

It is common for a bandsaw blade to wander off the cut line when sawing as shown in **Figure 35**. This is called blade lead.



**Figure 35.** Blade leading away from line of cut.

## To correct blade lead:

1. Check that the miter slot or fence is parallel to the blade line, and correct if necessary.
2. Check for proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by adjusting the table.

## To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut the board on the line by pushing it into the blade with the miter gauge.
3. **Unplug the bandsaw!**
4. Loosen the table mounting bolts. Shift the table to compensate for the blade lead.
5. Repeat **Steps 1-4** until the blade cuts straight.
6. Tighten the table bolts.



# Stacked Cuts

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One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together.

Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90°. Any misalignment will be magnified with each piece.

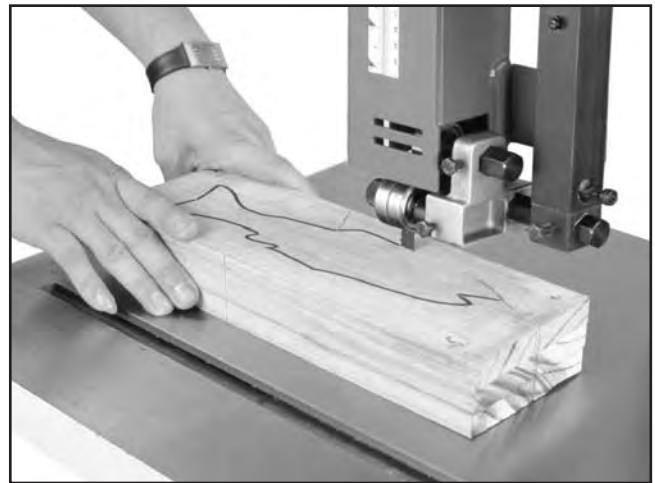
## To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads!)

## CAUTION

Cutting into brad nails used to secure the multiple pieces can cause the blade to break and may cause an injury to the operator. Be extremely careful of where you are cutting when performing this operation.

3. On the face of the top piece, lay out the shape you intend to cut.
4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the wood grain or cause the blade kerf to bind.
5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line as shown in **Figure 36**.



**Figure 36.** Cutting multiple pieces at once.



# Blade Information

Selecting the right blade requires a combination of the various blade characteristics mentioned below, the type of material you plan to cut, and the type of cut you are going to perform.

## Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. Refer to the current Grizzly catalog for prices and ordering information.

G0566 Blade Length ..... 163"-166"  
 G0568/G0569 Blade Length..... 179"-182"

## Blade Width

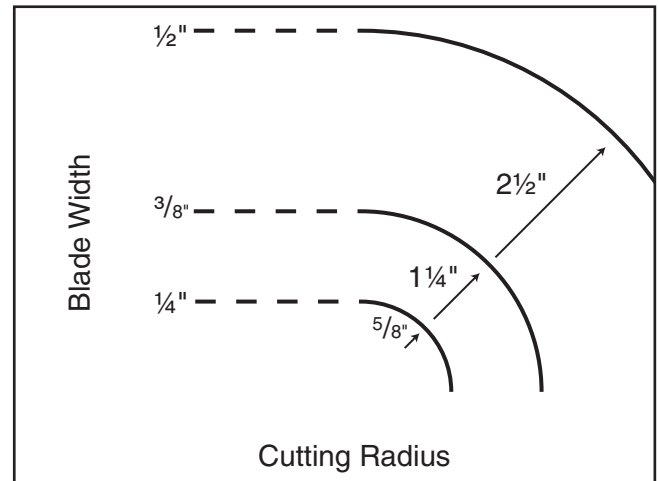
Measured from the back of the blade to the tip of the blade tooth, blade width is often the first consideration. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0566 can use blades from 1/4" to 1-3/8" in width. The Models G0568 & G0569 can use blades that range from 1/4" to 1-1/2". Always pick the blade size to best suit your application.

- **Straight Cutting**—Use the largest width blade that you own. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines, but function poorly at cutting small curves because of their size.
- **Curve Cutting**—Use the chart in **Figure 37** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

## Blade Tooth Type

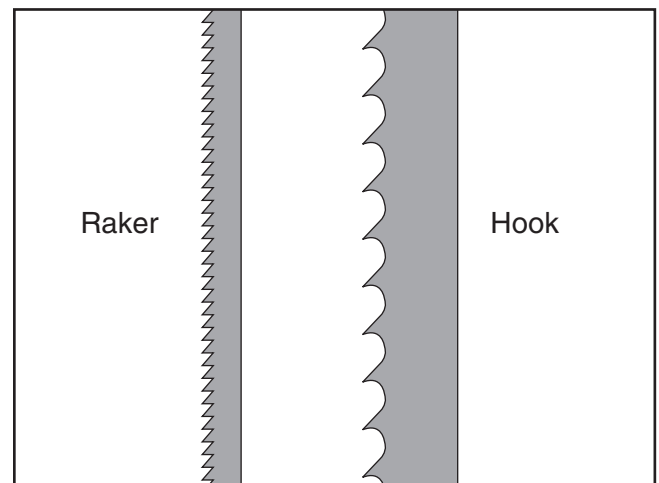
**Carbon Steel**—The less expensive carbon steel blades are adequate for most cutting applications; however, they dull quickly and for economical reasons they are usually replaced rather than resharpened.



**Figure 37.** Ideal cutting radius/blade sizes.

**Carbide Tipped**—The more expensive carbide-tipped blades are designed for continuous use in production shop situations. They hold an edge longer than carbon steel and they can be resharpened many times before needing to be replaced.

**Figure 38** shows the two of blades available for this saw:



**Figure 38.** Raker, & Hook tooth styles.

- **Raker**—This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on Raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but at the same time do not cut fast and generate more heat while cutting.

- **Hook**—The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

## Tooth Pitch

Usually measured as T.P.I. (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

## Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can optimize the longest use from a bandsaw blade if you give it fair treatment. Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

## Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

### The most common causes of blade breakage are:

- improperly aligned and adjusted guides.
- Forcing or twisting a wide blade around a curve of short radius.
- Feeding the workpiece into the blade too fast.
- Tooth dullness or absence of sufficient set.
- Excessive/insufficient tension.
- Top blade guide assembly set too high above the work piece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.



# Saw Blade Removal

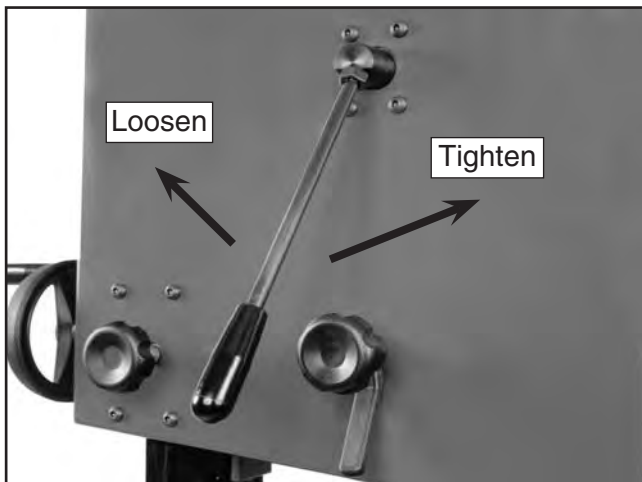


## ! WARNING

All saw blades are dangerous and may cause personal injury or death. To reduce the risk of being injured, wear leather gloves when handling saw blades.

To remove the blade:

1. **Unplug the bandsaw!**
2. Release tension on the blade by rotating the quick release tension lever clockwise as shown in **Figure 39**.



**Figure 39.** Quick release tension lever.

3. Open the upper and lower wheel covers and slide the blade off both wheels. Note—If the blade does not slide off easily, loosen the blade tension handwheel.
4. Feed the blade through the blade guards, table slot and fence rail, and remove from the saw.



# Installing Saw Blade



## ! WARNING

All saw blades are dangerous and may cause personal injury or death. To reduce the risk of being injured, wear leather gloves when handling saw blades.

**Components and Hardware Needed:** Qty  
Saw Blade ..... 1

To install the blade:

1. **Unplug the bandsaw!**
2. Make sure the quick release tension lever shown in **Figure 39** is released.
3. With the blade teeth pointing downward, slide the blade around the fence rail and through the table slot. Note—If the blade cannot be positioned with the teeth pointing downward, it may be inside out. While wearing leather gloves, flip the blade right-side out.
4. Slide the blade through the upper and lower blade guides, and blade guard, then place and center it on the upper and lower wheels.
5. Tighten the quick release tension lever.
6. Close the wheel covers.
7. Check tracking and tensioning.

## ! CAUTION

Operating the bandsaw before the blade tracking and tension have been adjusted could cause the blade to fall off the wheels resulting in operator injury.



# SECTION 5: ACCESSORIES

## Replacement Blades

Replacement blades for the Model G0566 Industrial Bandsaw. Hook blades are signified by the H after the TPI, and raker blades are signified by the R after TPI.

MODEL	TYPE	WIDTH	GAUGE	TPI
H6978	Carbon	1/2"	0.025"	3H
H6979	Carbon	1/2"	0.025"	4H
H6980	Carbon	1/2"	0.025"	6H
H6981	Carbon	1/2"	0.025"	10R
H6982	Carbon	1/2"	0.025"	14R
H6983	Carbon	1"	0.035"	2H
H6984	Carbon	1"	0.035"	6H
H6985	Carbon	1"	0.035"	10R
H6986	Carbon	1 1/4"	0.035"	1.3H
H6987	Carbon	1"	0.035"	3H

Replacement blades for the Model G0568/G0569 Industrial Bandsaw.

MODEL	TYPE	WIDTH	GAUGE	TPI
H6988	Carbon	1/2"	0.025"	3H
H6989	Carbon	1/2"	0.025"	4H
H6990	Carbon	1/2"	0.025"	6H
H6991	Carbon	1/2"	0.025"	10R
H6992	Carbon	1/2"	0.025"	14R
H6993	Carbon	1"	0.035"	2H
H6994	Carbon	1"	0.035"	6H
H6995	Carbon	1"	0.035"	10R
H6996	Carbon	1 1/4"	0.035"	1.3H
H6997	Carbon	1"	0.035"	3H

**Call 1-800-523-4777 To Order**

## G7984—Face Shield

## H1298—Dust Sealed Safety Glasses

## H1300—UV Blocking, Clear Safety Glasses

## H2347—Uvex® Spitfire Safety Glasses

## H0736—Shop Fox® Safety Glasses

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



Figure 40. Our most popular safety glasses.

## H1302—Standard Earmuffs

## H4979—Deluxe Twin Cup Hearing Protector

## H4977—Work-Tunes Radio Headset Earmuffs

Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 41. Our most popular earmuffs.

### H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.

The Blade Tensioning Gauge is made of lightweight, cast aluminum for optimum accuracy. Bright color coding makes it easy to use and easy to read. The Blade Tensioning Gauge comes in a handy metal box with instructions on the lid.



Figure 42. H5408 Blade Tensioning Gauge.

### H3788—G96® Gun Treatment 12 oz Spray

### H3789—G96® Gun Treatment 4.5 oz Spray

This triple action gun treatment cleans, lubricates and protects all metal parts. Contains solvents that completely remove all traces of rust and corrosion and leaves no gummy residue.



Figure 43. G96® Gun Treatment spray.

### G5562—SLIPIT® 1 Qt. Gel

### G5563—SLIPIT® 12 oz Spray

Used on cast iron table surfaces and other unpainted metal surfaces to reduce rust and corrosion. This product is perfect for keeping tools clean, especially during long-term storage.



Figure 44. SLIPIT® gel and spray.

### G1955—OxiSolv® Blade & Bit Cleaner

Used to clean the gummy pitch and residue from saw blades and router bits, this high quality cleaner will make blades and bits last longer while improving cutting action.



Figure 45. G1955 OxiSolv® spray.

Call 1-800-523-4777 To Order

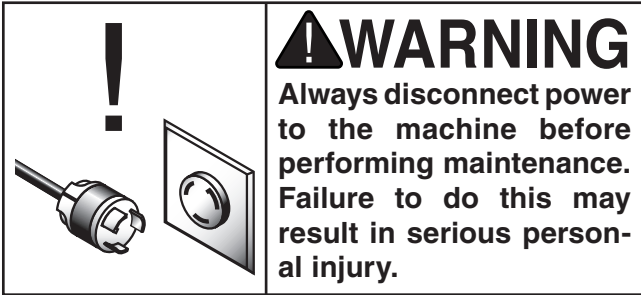




# SECTION 6: MAINTENANCE

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## Schedule

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For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

### Daily Maintenance:

- Check for loose mounting bolts.
- Check for damaged saw blade.
- Check for worn or damaged wires.
- Check for worn or damaged guide bearings.
- Check for any other unsafe condition.
- Check guide bearing for sawdust build-up, clean when necessary.
- Check wheel brushes for sawdust build-up, clean/adjust when necessary.
- Wipe sawdust buildup from table surface.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Wipe a lubricant such as SLIPIT® onto the cast iron table.

### Monthly Maintenance:

- Check V-belt tension, damage, and wear; replace as necessary.
- Lubrication as shown on the next page.



## Cleaning

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Cleaning the Model G0566/G0568/G0569 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.



## Unpainted Cast Iron

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Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see Section 5: Accessories on **page 37** for more details).



# Lubrication

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Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or a bearing supply store.

Most other moving parts need to be lubricated as needed to maintain smooth function of the bandsaw.

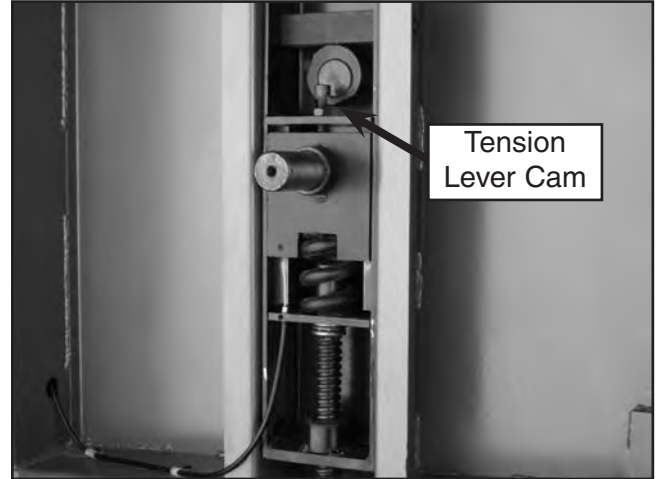
## To lubricate the blade guide rack and pinion:

1. **Unplug the bandsaw!**
2. Lower the blade guide until it reaches the table.
3. Wipe off any existing grease and sawdust buildup on the rack.
4. Apply a thin coat of light all-purpose grease to the rack.
5. Move the blade guide up and down several times and remove any excess grease to help prevent sawdust buildup.

## To lubricate the blade tracking knob:

1. **Unplug the bandsaw!**
2. Unscrew the blade tracking knob 5-6 turns.
3. Wipe off any existing grease and sawdust buildup on the threads.
4. Apply a few dabs of a light all-purpose grease to the threads.
5. Re-adjust tracking (see Section 3: Set Up on **page 14**).

## To lubricate the tension adjustment assembly (Figure 46):

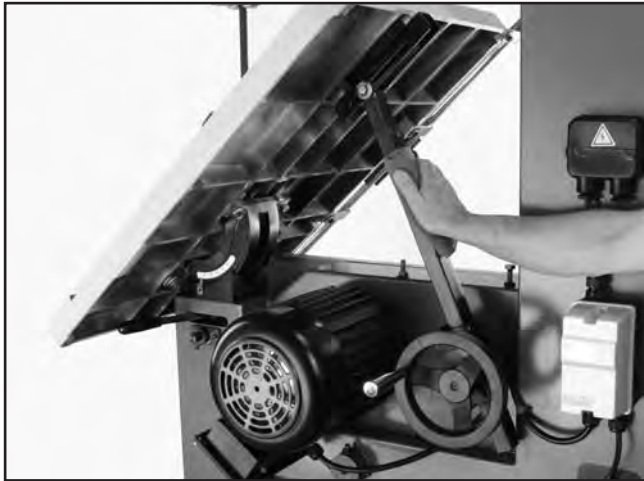


**Figure 46.** Tension adjustment assembly.

1. **Unplug the bandsaw!**
2. Wipe off any existing grease and sawdust buildup on the blade tension adjustment assembly and tension lever cam.
3. Apply a thin coat of grease to the tension adjustment assembly and tension lever cam.

## To lubricate the table tilt rack and pinion assembly:

1. **Unplug the bandsaw!**
2. With the table perpendicular to the blade, wipe off all existing grease and sawdust buildup from the rack.
3. Move the table up to its maximum 45° angle and wipe (**Figure 47**) off all existing grease and sawdust buildup from the rack.



**Figure 47.** Table tilt rack and pinion assembly.

4. Apply a thin coat of light all-purpose grease to the rack.
5. Move the table up and down several times and wipe off any excess grease.

**To lubricate the trunnions:**

1. **Unplug the bandsaw!**
2. Move the table up until it reaches its maximum 45° angle and wipe off all excess grease and sawdust from the trunnions.
3. Apply a thin coat of light all purpose grease to the trunnions.
4. Move the table down and then back up. Wipe off any excess grease from the trunnions.



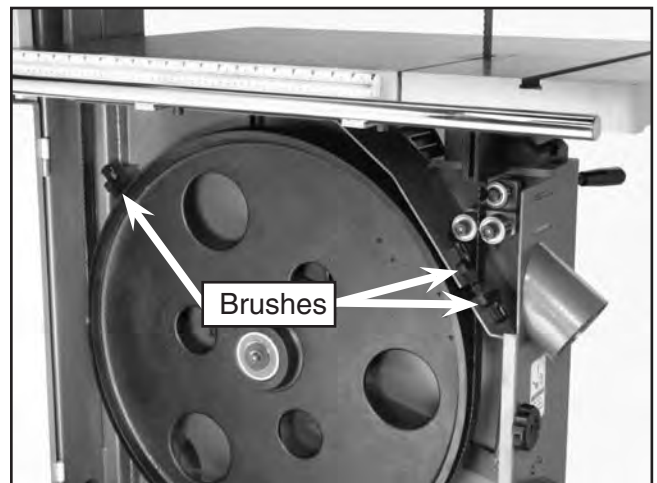
# Brushes

The bandsaw is equipped with three brushes. The brushes should be checked daily and cleaned when they become dirty. Adjust the brushes to keep them in contact with the wheel and blade.

<b>Tools Needed:</b>	<b>QTY</b>
Wrenches 10mm .....	2

**To adjust the wheel brushes:**

1. **Unplug the bandsaw!**
2. Open the wheel covers, and locate the brushes (**Figure 48**).
3. Loosen the hex bolts holding the brushes in place.
4. Adjust the brushes so light contact with the wheel/blade is made.
5. Tighten the hex bolts.

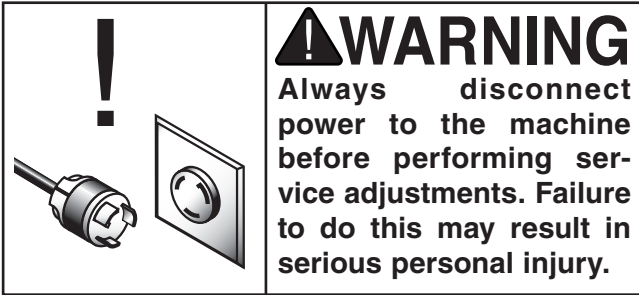


**Figure 48.** Brush locations.





# SECTION 7: SERVICE



## About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.



## Items Needed for Service

The following items are needed, but not included, to complete the service process:

DESCRIPTION	QTY
• Safety Glasses (for each person) .....	1
• Board 2" x 4" x 70 <sup>1</sup> / <sub>4</sub> " .....	1
• Tape Measure .....	1
• Circular Saw .....	1
• Jointer .....	1
• Calipers .....	1
• Hex Wrench 5mm .....	1
• Hex Wrench 6mm .....	1
• Wrench 13mm .....	1
• Wrench 12mm .....	1



## Checking V-Belts

For optimal power transmission from the motor to the blade, the V-belts must be in good condition and properly tensioned. The belts should be checked for cracks, fraying, and wear. Belt tension should be checked at least every 3 months; more often if the bandsaw is used daily.

### To check the V-belts:

1. **Unplug the bandsaw!**
2. Open the lower wheel cover.
3. Push the center of the V-belts. Note the amount of deflection. If deflection is more than approximately  $\frac{3}{4}$ " with moderate pressure, tighten the V-belt. Note—If the V-belt is cracked, frayed, or glazed; it should be immediately replaced.

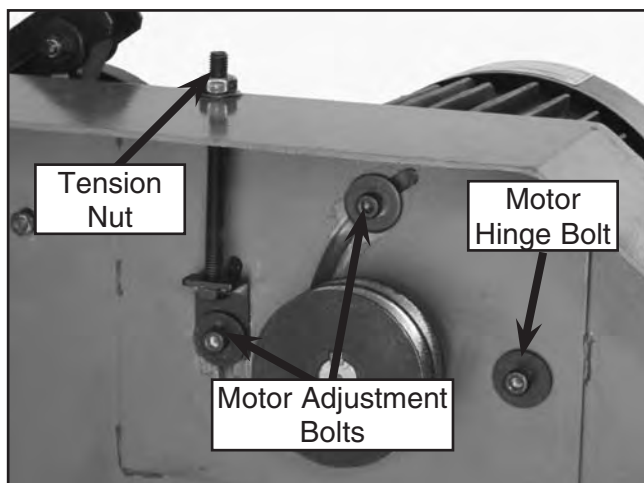


# Tensioning V-Belts

Tools Needed:	QTY
Hex Wrench 6mm.....	1
Wrench 13mm.....	1

## To tension the V-belt:

1. **Unplug the bandsaw!**
2. Open the wheel covers.
3. Loosen the motor adjustment and hinge bolts shown in **Figure 49**.



**Figure 49.** Motor mount bolts and tension bolt.

4. Adjust the belt tension:
  - If the belt is too loose, turn the tension nut clockwise to tighten the belts.
  - If the belt is too tight, turn the tension nut counterclockwise to loosen the belts
5. Push the center of the V-belt. If deflection is approximately  $\frac{3}{4}$ " with moderate pressure from your thumb or finger, then the tension is correct. If the deflection is more/less than  $\frac{3}{4}$ ", repeat **step 4**.
7. When the V-belt tension is correct, tighten the motor adjustment and hinge bolts, and close the wheel covers.

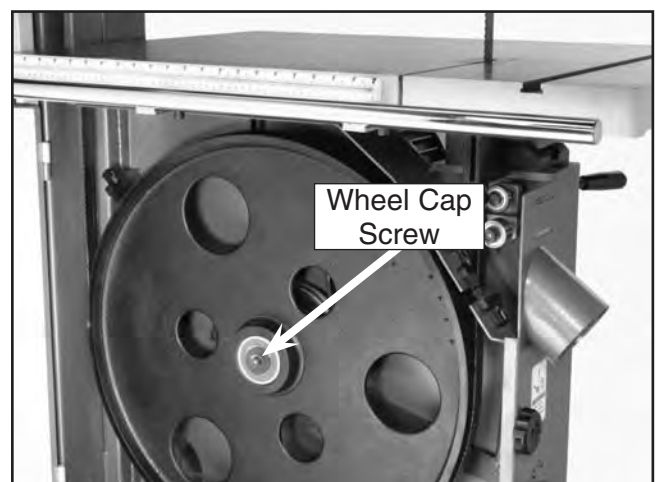


# Replacing V-Belt

Tools Needed:	QTY
Hex Wrench 6mm.....	1
Wrench 13mm.....	1

## To replace the V-belt:

1. **Unplug the bandsaw!**
2. Open the wheel covers and remove the bandsaw blade.
3. Loosen the motor mount bolts shown in **Figure 49**, then turn the tension bolt counterclockwise, and pull the V-belts off.
5. Unthread the wheel cap screw shown in **Figure 50** and slide the lower wheel off of the bearing shaft.



**Figure 50.** Wheel cap screw for removing the wheel.

6. Slip the old V-belts off of the wheel pulley and install the new V-belts in their place.
7. Install the lower wheel back onto the bearing shaft, tighten the wheel mount bolt, place the V-belts over the motor pulley, and turn the tension bolt clockwise to tighten the V-Belt tension.
8. When the tension is correct, tighten the motor hinge bolt and close the lower wheel cover.



# Wheel Height Limiting Screw

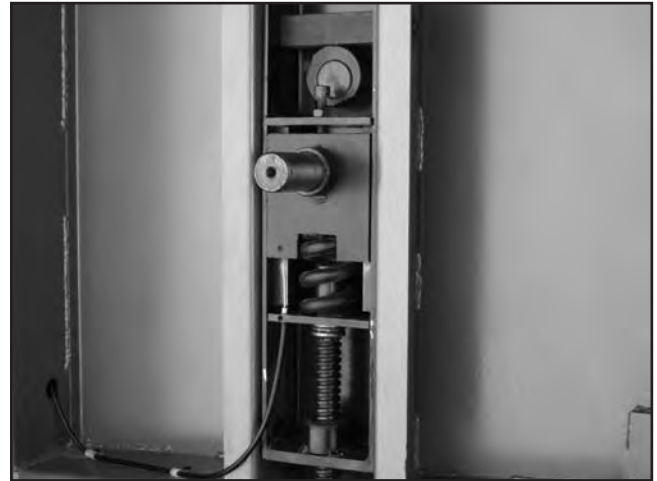
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The wheel height limiting screw, when set properly, prevents the wheel from making contact with the top of the bandsaw body. The screw must be set  $\frac{3}{16}$ "– $\frac{1}{4}$ " below the plate and secured with the check nut to be effective.

Tools Needed:	QTY
Hex Wrench 5mm.....	1
Hex Wrench 6mm.....	1
Wrench 12mm.....	1
Calipers .....	1

1. **Unplug the bandsaw!**
2. Remove the blade.
3. Remove the upper wheel.
4. Measure how far the screw is threaded through the plate (**Figure 51**):
  - If it measures  $\frac{3}{16}$ "– $\frac{1}{4}$ " beneath the plate, the limiting screw is set correctly.
  - If it measures more or less than  $\frac{3}{16}$ "– $\frac{1}{4}$ " beneath the plate continue to **step 4**.



**Figure 51.** Wheel height limiting screw.

4. Adjust the screw in or out until the screw sticks out  $\frac{3}{16}$ "– $\frac{1}{4}$ " beneath the plate, and secure it with the check nut.
5. Install the upper wheel and blade.
6. After this procedure you will need to track and tension the blade (**page 21 & page 25**).



# Wheel Alignment

Wheel alignment is one of the most critical factors for optimal performance from your bandsaw.

Heat, vibration, wandering, blade wear, tire wear and overall bandsaw wear are considerably decreased when the wheels are properly aligned or “coplanar.”

Coplanar wheels automatically track the blade by balancing it on the crown of the wheel. This is known as coplanar tracking.

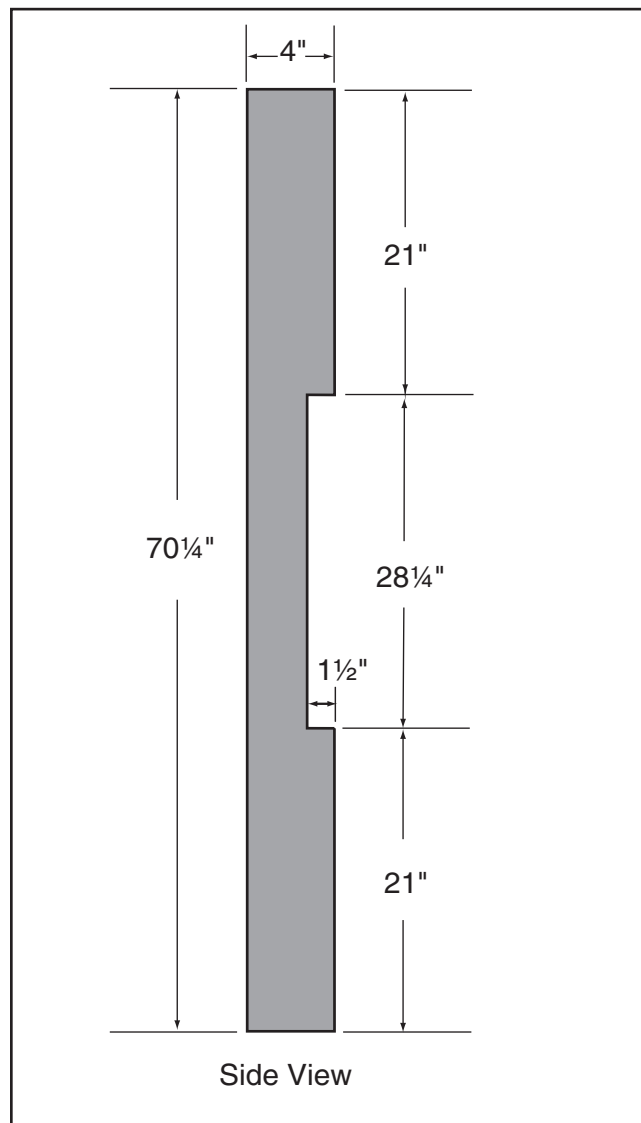
**Components and Hardware Needed:** Qty  
Board 2" x 4" x 70<sup>1</sup>/<sub>4</sub>" ..... 1

**Tools Needed:**

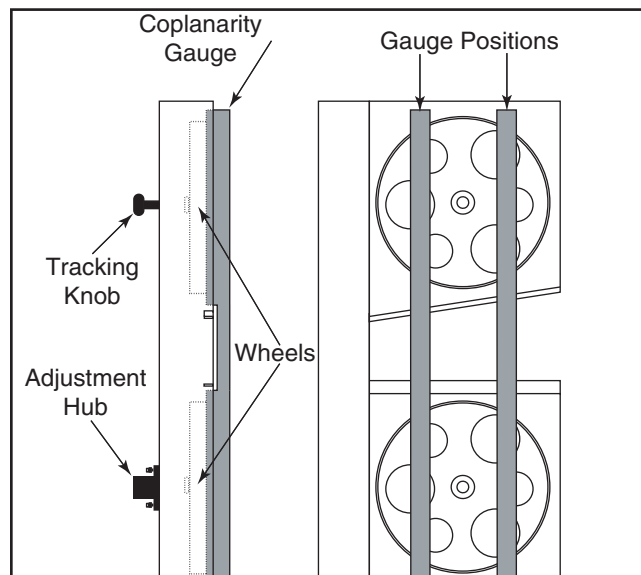
Wrench 17mm ..... 1  
Tape Measure ..... 1  
Circular Saw ..... 1  
Jointer..... 1

**To check if your wheels are coplanar:**

1. The body of the bandsaw does not allow you to place a regular straightedge across both wheels at the same time. We’ve found a simple way to overcome this situation. All you need is a 70<sup>1</sup>/<sub>4</sub> x 2" x 4" board, a jointer and a circular saw. Run the 2" x 4" across a jointer on the side to be placed against the wheels, then cut a 1<sup>1</sup>/<sub>2</sub> x 28<sup>1</sup>/<sub>4</sub>" notch out of the center. Refer to **Figure 52** for more details on how to make this gauge.
2. After you’ve made your coplanarity gauge, remove the fence and table, then open both wheel covers.
3. Make sure the guide blocks and rear support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.
4. Place your gauge up against both wheels in the positions shown in **Figure 53**.



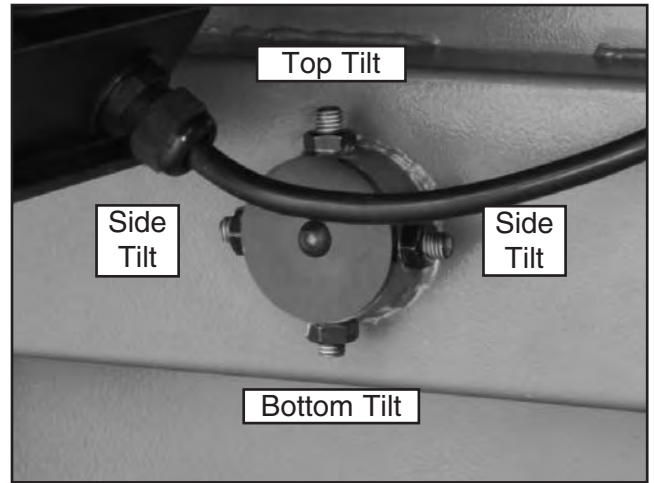
**Figure 52.** Dimensions of coplanarity gauge.



**Figure 53.** Checking for coplanarity.



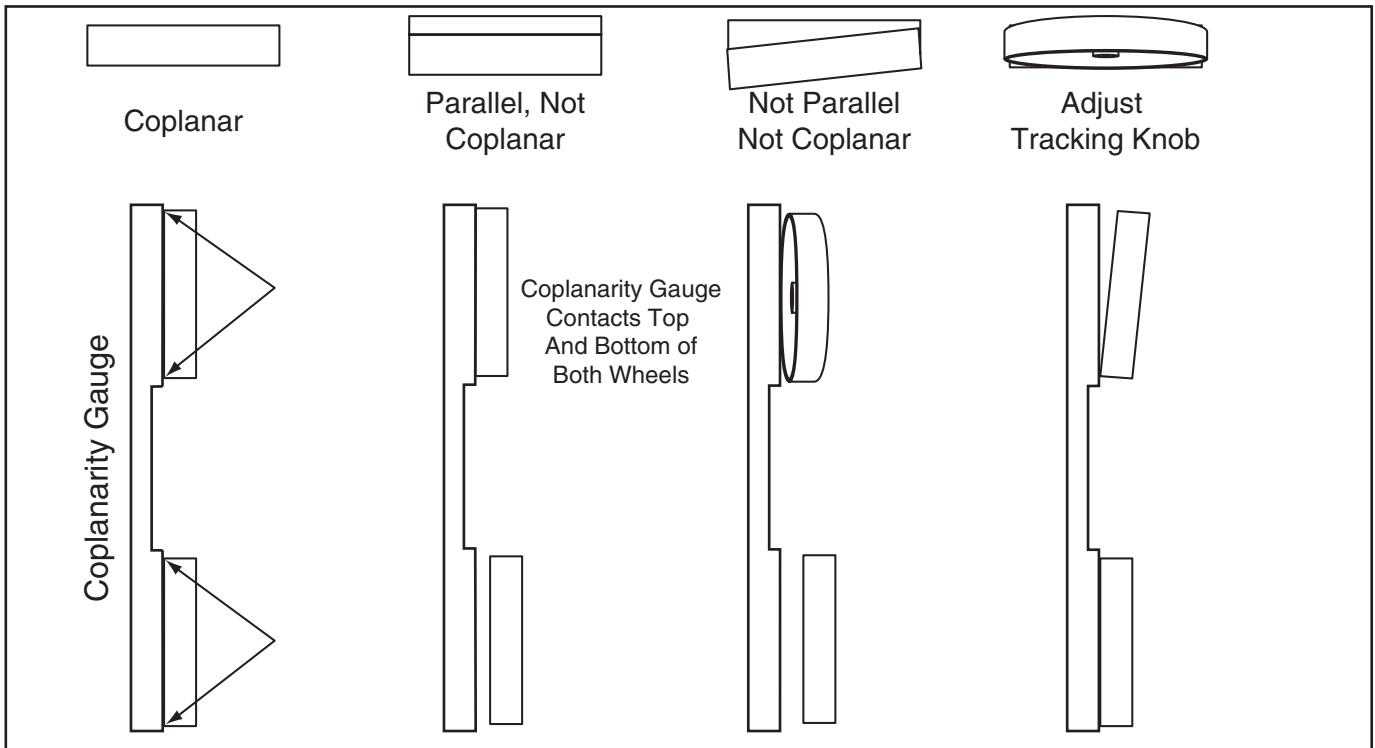
5. The adjustment hub allows you to move the lower wheel in the desired direction. Turning all the bolts clockwise in equal amounts pushes the wheel forward. Turning all the bolts counterclockwise brings the wheel backward, closer to the adjustment hub. Used individually, each bolt can control the direction that the wheel tilts.
6. Adjust the tracking knob to get both wheels parallel. If the wheels won't go parallel to each other, then move the lower wheel at the adjustment hub so they line up.
7. If the wheels will go parallel but not coplanar, then move the lower wheel at the adjustment hub (**Figure 54**) as necessary.
8. **Figure 55** shows the positions of the wheels when coplanar. When your wheels are coplanar, readjust the guide blocks and rear support bearings, and replace the wheel covers.



**Figure 54.** Lower wheel adjustment control.



Note—The blade may track slightly off center when the wheels are coplanar. This is natural because the blade will be balanced on the crown of the tire, rather than just in the center of the tire. This will be more noticeable with larger blades.

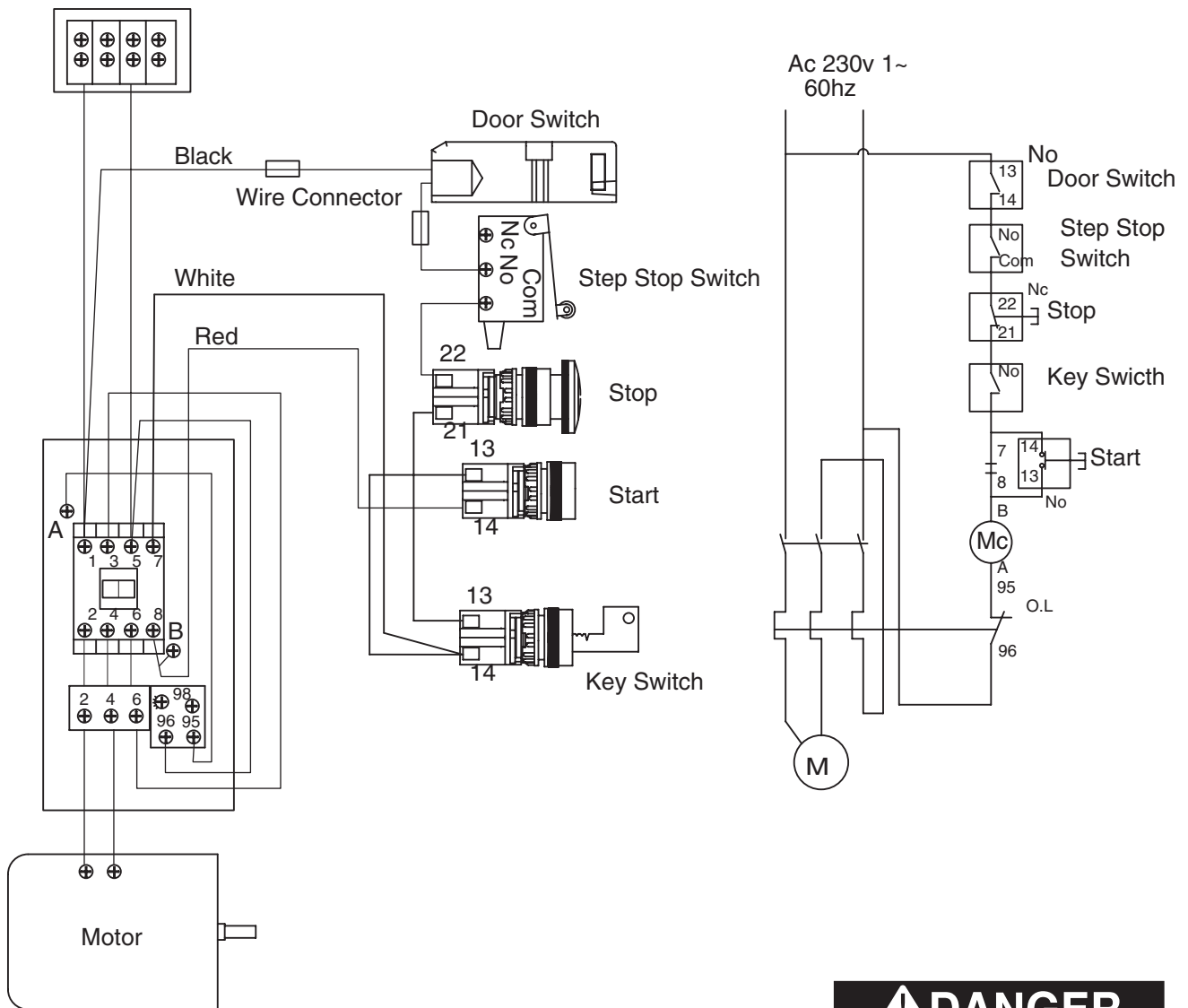


**Figure 55.** Coplanarity diagram.





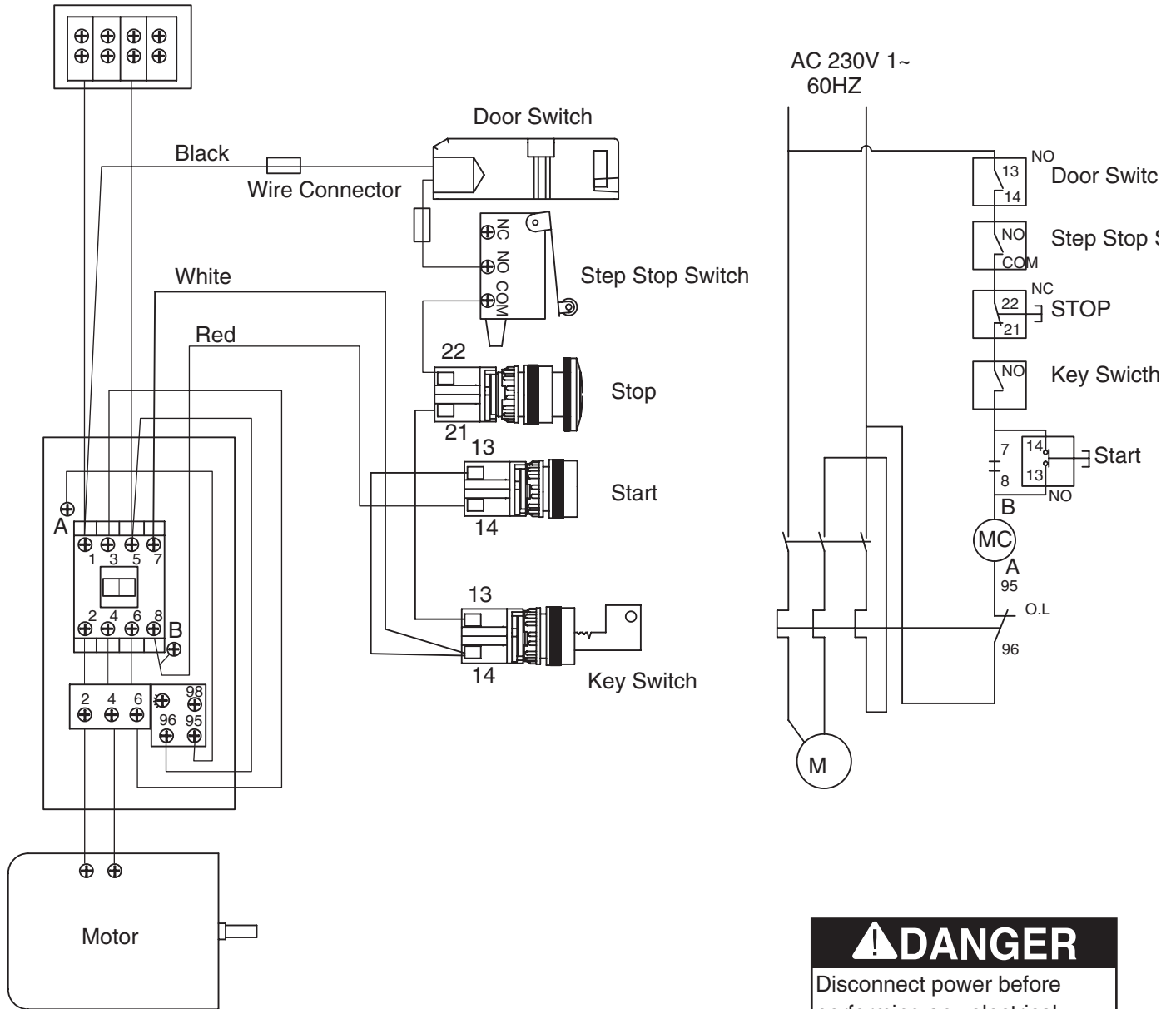
G0566  
220v Single-Phase



**⚠ DANGER**  
Disconnect Power Before  
Performing Any Electrical  
Service. Electricity Presents  
Serious Shock Hazards That  
Will Result In Severe



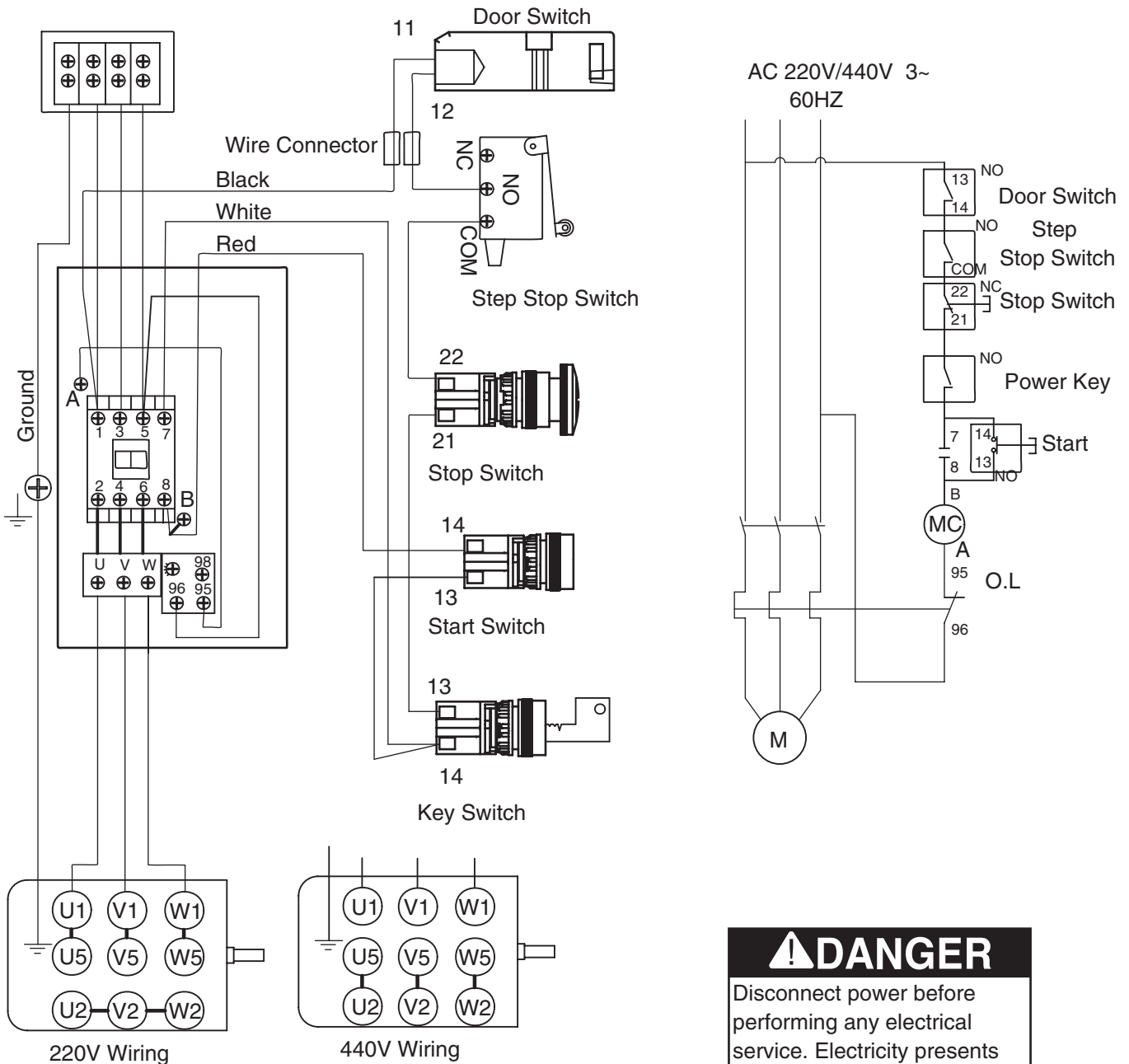
G0568  
220V Single-Phase



**⚠ DANGER**  
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal

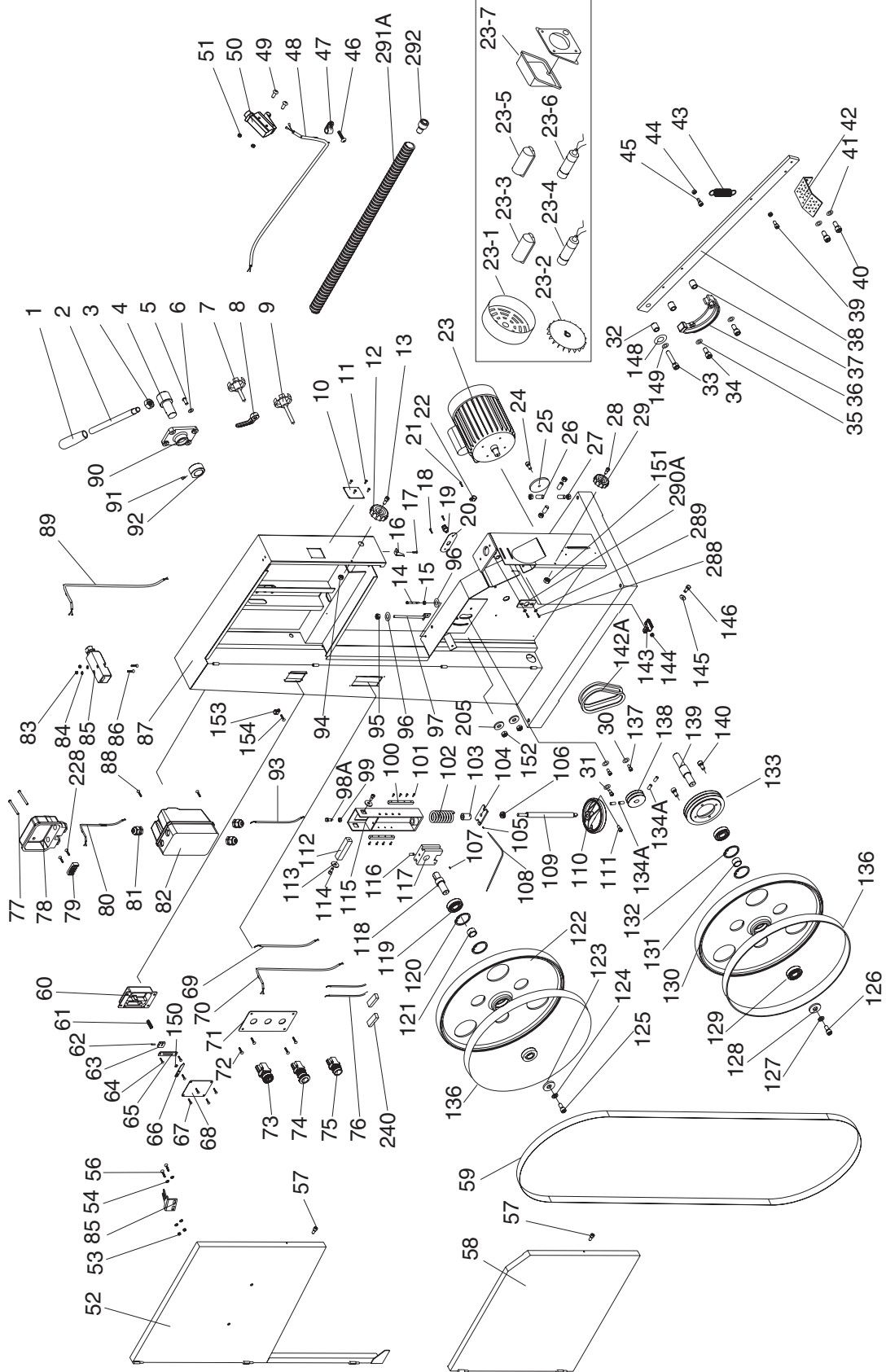


G0569  
220/440v 3-Phase

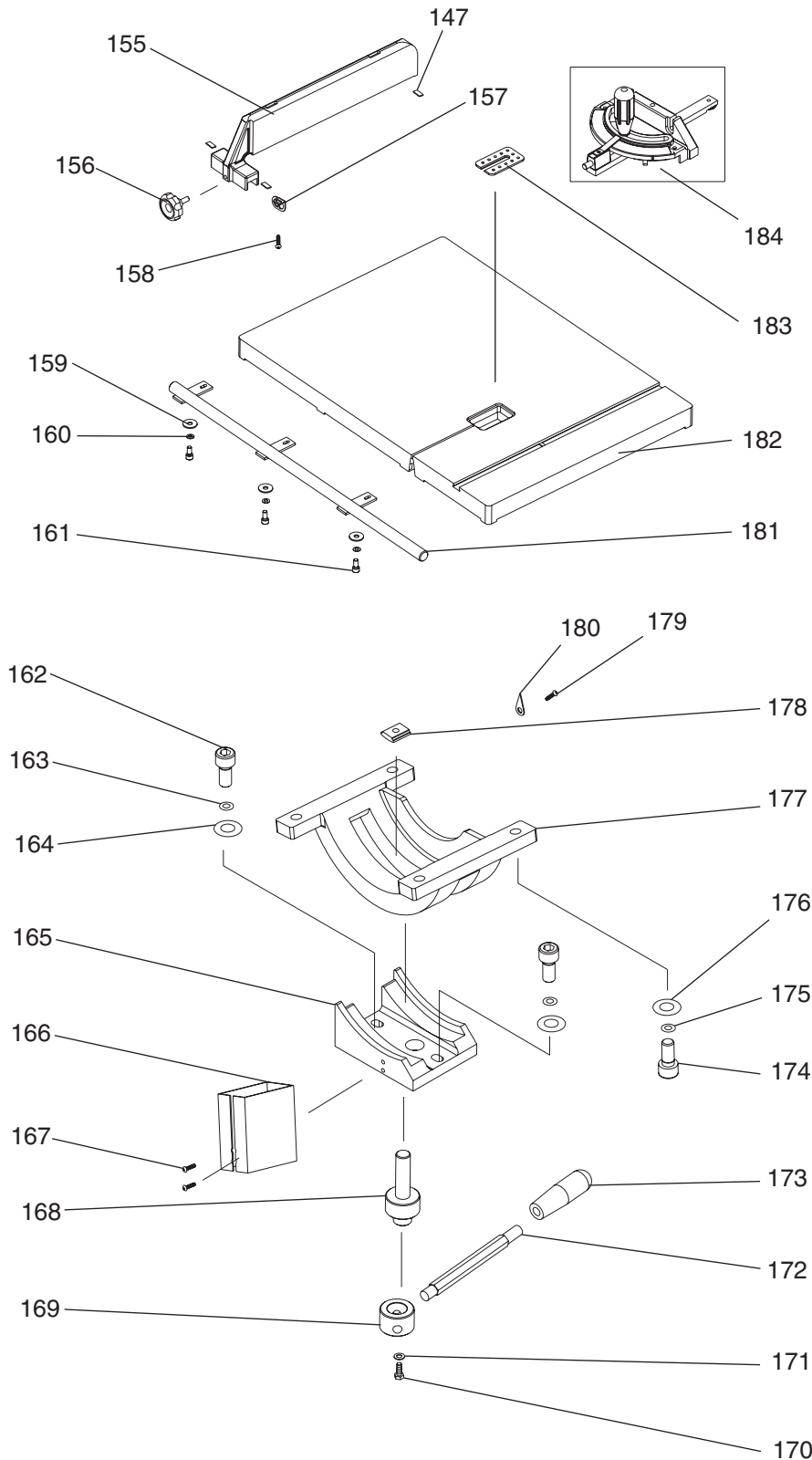


**⚠ DANGER**  
Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal

# G0566 Parts Breakdown



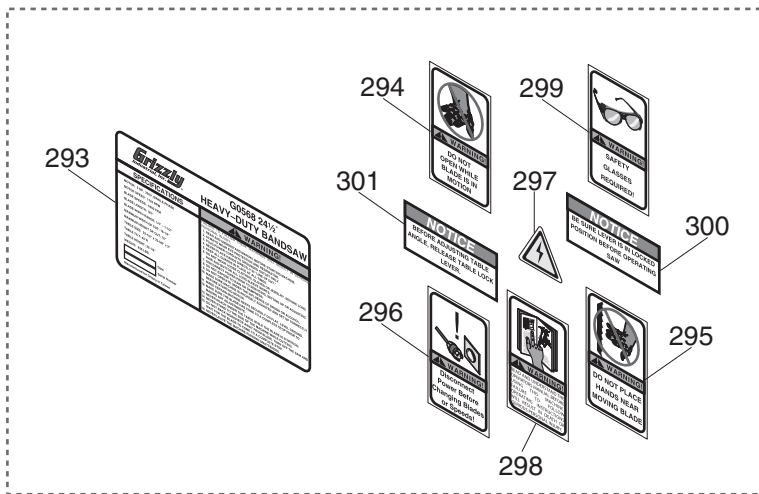
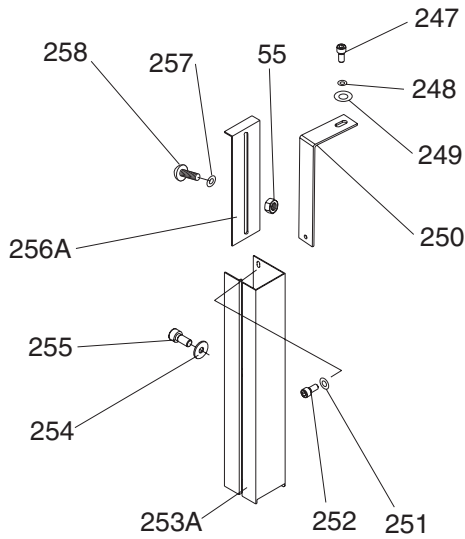
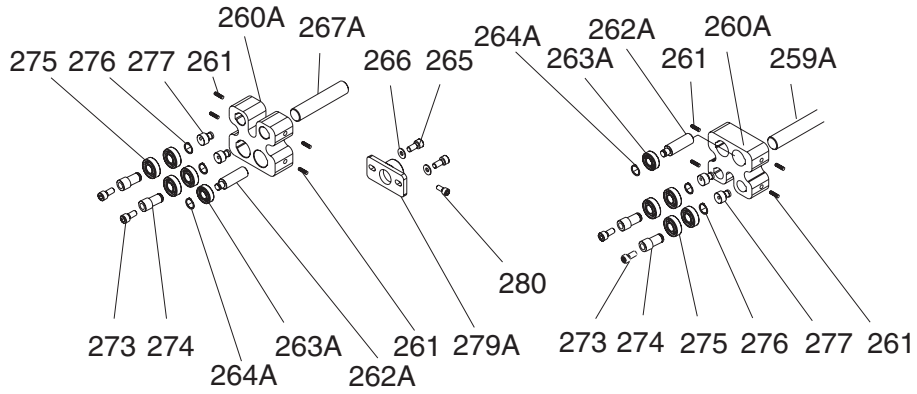
# G0566 Parts Breakdown







# G0566 Parts Breakdown



# G0566 Parts List

REF	PART #	DESCRIPTION
1	P0566001	HANDLE KNOB M16-1.5
2	P0566002	HANDLE SHAFT
3	PN05M	NUT M16-1.5
4	P0566004	ECCENTRIC SHAFT
5	PSBS03M	BUTTON HD CAP SCR M10-1.5 X 20
6	PLW06M	LOCK WASHER 10MM
7	P0566007	KNOB SCREW M10-1.5 X 25
8	P0566008	LOCK HANDLE M10-1.5
9	P0566009	KNOB SCREW M10-1.5 X 25
10	P0566010	TRANSLUCENT PIECE
11	P0566011	RIVET 3.2 X 10
12	P0566012	LATCHING KNOB 6MM
13	PSB02M	CAP SCREW M6-1 X 20
14	PB73M	HEX BOLT M10-1.5 X 50
15	PN02M	HEX NUT M10-1.5
16	P0566016	HEIGHT POINTER
17	PFS07M	FLANGE SCREW M5-.8 X 10
18	PHTEK4M	TAP SCREW M4 X 8
19	P0566019	STRAIN RELIEF M20
20	P0566020	PLATE
21	PHTEK4M	TAP SCREW M4 X 8
22	P0566022	CORD CLAMP 1/2"
23	P0566023	MOTOR 3HP 220V 1PHASE
23-1	P0566023-1	FAN COVER
23-2	P0566023-2	FAN
23-3	P0566023-3	CAPACITOR COVER
23-4	P0566023-4	START CAPACITOR 250MFD/250V
23-5	P0566023-5	CAPACITOR COVER
23-6	PC20A	CAPACITOR 20MFD/400V
23-7	P0566023-7	WIRING BOX
24	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
25	P0566025	COVER
26	PB01M	HEX BOLT M10-1.5 X 30
27	PN02M	HEX NUT M10-1.5
28	PSB02M	CAP SCREW M6-1 X 20
29	P0566029	LATCHING KNOB 6MM
30	PW01M	FLAT WASHER 8MM
31	PSB31M	CAP SCREW M8-1.25 X 25
32	P0566032	BUSHING

REF	PART #	DESCRIPTION
33	PSB31M	CAP SCREW M8-1.25 X 25
34	PSB06M	CAP SCREW M6-1 X 25
35	PLW03M	LOCK WASHER 6MM
36	P0566036	BRAKE PAD
37	P0566037	BUSHING
38	P0566038	BRAKE LEVER
39	PSB01M	CAP SCREW M6-1 X 16
40	PSB01M	CAP SCREW M6-1 X 16
41	PLW03M	LOCK WASHER 6MM
42	P0566042	BRAKE STEP PLATE
43	P0566043	SPRING
44	PN01M	HEX NUT M6-1
45	PSB01M	CAP SCREW M6-1 X 16
46	PHTEK4M	TAP SCREW M4 X 8
47	P0566047	CORD CLAMP 5/8"
48	P0566048	STEP CORD
49	PB41M	HEX BOLT M4-.7 X 30
50	P0566050	LIMIT SWITCH KL7141
51	PN04M	HEX NUT M4-.7
52	P0566052	UPPER WHEEL COVER
53	PN04M	HEX NUT M4-.7
54	PW05M	FLAT WASHER 4MM
55	PLN03M	LOCK NUT M6-1
56	PS38M	PHLP HD SCR M4-.7 X 10
57	PSB04M	CAP SCREW M6-1 X 10
58	P0566058	LOWER WHEEL COVER
59	P0566059	SAW BLADE 4190X25.4X0.9mm
60	P0566060	UPPER WHEEL SLIDING BRACKET
61	P0566061	SPRING
62	PRP61M	PIN 3 X 12
63	P0566063	MOVING PLATE
64	PHTEK15M	TAP SCREW M4 X 10
65	P0566065	FIX PLATE
66	P0566066	TENSION POINTER
67	PHTEK6M	TAP SCREW M4 X 16
68	P0566068	TENSION SCALE
69	P0566069	CONNECTING CORD
70	P0566070	SWITCH CORD
71	P0566071	SWITCH PLATE

# G0566 Parts List

REF	PART #	DESCRIPTION
72	PHTEK15M	TAP SCREW M4 X 10
73	P0566073	KEY SWITCH Ø22
74	P0566074	STOP SWITCH Ø22
75	P0566075	START SWITCH Ø22
76	P0566076	CONNECTING CORD
77	PFS09M	FLANGE SCREW M5-.8 X 50
78	P0566078	TERMINAL BOX
79	P0566079	TERMINAL HOUSE
80	P0566080	POWER CORD
81	P0566081	STRAIN RELIEF M20
82	P0566082	MAGNETIC SWITCH MPE-18 22A
83	PN04M	HEX NUT M4-.7
84	PW05M	FLAT WASHER 4MM
85	P0566085	DOOR LATCH SWITCH ADZ-S11
86	PFS10M	FLANGE SCREW M4-.7 X 35
87	P0566087	MACHINE BODY
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0566089	SWITCH CORD
90	P0566090	HOUSING PLATE
91	PSB31M	CAP SCREW M8-1.25 X 25
92	P0566092	CAM
93	P0566093	MOTOR CORD
94	PLN03M	LOCK NUT M6-1
95	PN02M	HEX NUT M10-1.5
96	PW04M	FLAT WASHER 10MM
97	P0566097	ADJUST BOLT
98A	PSB60M	CAP SCREW M8-1.25 X 55
99	PN03M	HEX NUT M8-1.25
100	P0566100	LOCATE PLATE
101	PFH39M	FLAT HD SCR M5-.8 X 16
102	P0566102	SPRING
103	P0566103	BUSHING
104	P0566104	PRESS BLOCK
105	PSS07M	SET SCREW M5-.8 X 5
106	P0566106	BEARING 51201
107	PSS07M	SET SCREW M5-.8 X 5
108	P0566108	TENSION LINE
109	P0566109	SHAFT

REF	PART #	DESCRIPTION
110	P0566110	HANDWHEEL
111	PSB06M	CAP SCREW M6-1 X 25
112	P0566112	SQUARE SHAFT
113	PW01M	FLAT WASHER 8MM
114	PSB14M	CAP SCREW M8-1 X 20
115	P0566115	UPPER WHEEL HINGE ASSY
116	PSS75M	SET SCREW M10-1.5 X 16
117	P0566117	GUIDE BLOCK
118	P0566118	UPPER WHEEL SHAFT
119	P6205	BALL BEARING 6205LLU
120	PR26M	INT RETAINING RING 52MM
121	P0566121	BUSHING
122	P0566122	UPPER WHEEL Ø21"
123	PW01M	FLAT WASHER 8MM
124	PLW04M	LOCK WASHER 8MM
125	PSB14M	CAP SCREW M8-1 X 20
126	PSB14M	CAP SCREW M8-1 X 20
127	PLW04M	LOCK WASHER 8MM
128	PW01M	FLAT WASHER 8MM
129	P6205	BALL BEARING 6205LLU
130	P0566130	LOWER WHEEL Ø21"
131	P0566131	BUSHING
132	PR26M	INT RETAINING RING 52MM
133	P0566133	PULLEY
134A	PSS04M	SET SCREW M6-1 X 12
136	P0566136	TIRE
137	PSB14M	CAP SCREW M8-1.25 X 20
138	P0566138	PULLEY
139	P0566139	LOWER SHAFT
140	PSBS01M	BUTTN HD CAP SCR M8-1.25 X 20
141	PW03M	FLAT WASHER 6MM
142A	PVA30	V-BELT A-30 4L300
143	P0566143	BRUSH
144	PLN03M	LOCK NUT M6-1
145	PW03M	FLAT WASHER 6MM
146	PSB02M	CAP SCREW M6-1 X 20
147	P0566147	NYLON PIECE
148	PW01M	FLAT WASHER 8MM

# G0566 Parts List

REF	PART #	DESCRIPTION
149	PLW04M	LOCK WASHER 8MM
150	PW05M	FLAT WASHER 4MM
151	PLN03M	LOCK NUT M6-1
152	PN03M	HEX NUT M8-1.25
153	P0566153	CORD CLAMP 5/16"
154	PHTEK15M	TAP SCREW M4 X 10
155	P0566155	FENCE
156	P0566156	KNOB SCREW M10-1.5 X 25
157	P0566157	POINTER
158	PFS01M	FLANGE SCREW M5-.8 X 8
159	PW01M	FLAT WASHER 8MM
160	PLW04M	LOCK WASHER 8MM
161	PB09M	HEX BOLT M8-1.25 X 20
162	PSB72M	CAP SCREW M10-1.5 X 30
163	PLW06M	LOCK WASHER 10MM
164	PW04M	FLAT WASHER 10MM
165	P0566165	TRUNNION HOUSING
166	P0566166	BLADE GUARD
167	PFS11M	FLANGE SCREW M6 X 10
168	P0566168	PRESS SHAFT
169	P0566169	MICRO ADJUSTING RING
170	PSB14M	CAP SCREW M8-1.25 X 20
171	PLW04M	LOCK WASHER 8MM
172	P0566172	HANDLE SHAFT
173	P0566173	HANDLE KNOB M12-1.75 (FEMALE)
174	PSB84M	CAP SCREW M10-1.5 X 35
175	PLW06M	LOCK WASHER 10MM
176	PW04M	FLAT WASHER 10MM
177	P0566177	TRUNNION BLOCK
178	P0566178	PRESS BLOCK
179	PS38M	PHLP HD SCR M4-.7 X 10
180	P0566180	POINTER
181	P0566181	GUARD RAIL
182	P0566182	TABLE
183	P0566183	TABLE INSERT
184	P0566184	MITER GAUGE ASSY
184-1	P0566184-1	GUIDE
184-2	P0566184-2	GUIDE BAR
184-3	P0566184-3	LOCATE BRACKET

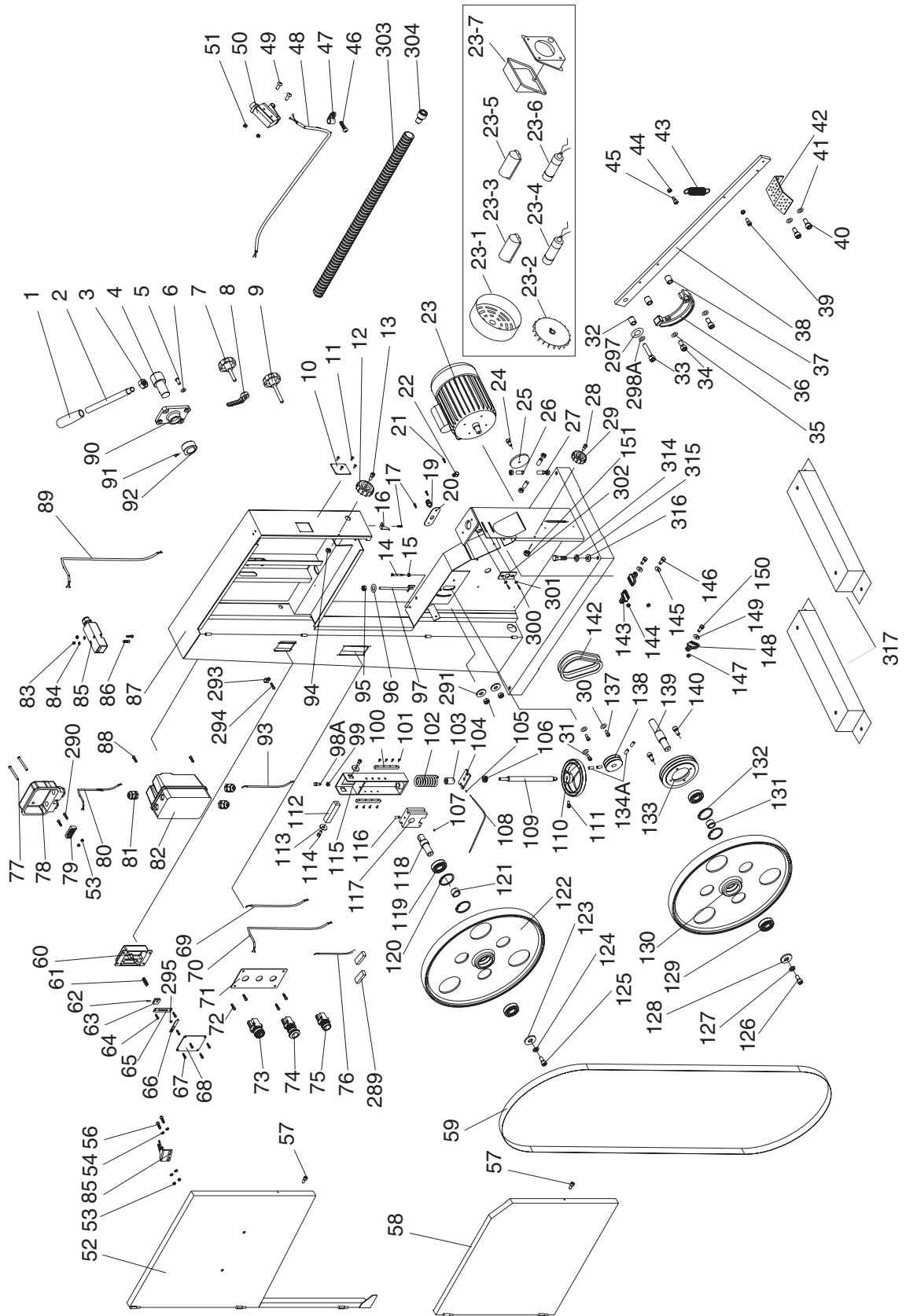
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184-4	P0566184-4	LOCATE SHAFT
184-5	P0566184-5	POINTER
184-6	P0566184-6	STEP SCREW
184-7	P0566184-7	HANDLE
184-8	P0566184-8	MITER GAUGE BODY
184-9	PFH9M	FLAT HEAD SCR M6-1 X 8
184-10	PS06	PHLP HD SCR 10-24 X 3/8
184-11	PS56M	PHLP HD SCR M4-.7 X 16
184-12	PN04M	HEX NUT M4-.7
184-13	PW01M	FLAT WASHER 8MM
185	PN06M	HEX NUT M5-.8
186	PFS07M	FLANGE SCREW M5-.8 X 10
187	P0566187	COVER
188	PLW04M	LOCK WASHER 8MM
189	PSB11M	CAP SCREW M8-1.25 X 16
190	PFH19M	FLAT HD SCR M4-.7 X 10
191	P0566191	EXTENSION RACK
192	P0566192	COVER
193	P0566193	FIXED BOLT
194	P0566194	PINION GEAR
195	P0566195	FIXED PLATE
196	P0566196	WORM CYLINDER
197	PN05M	HEX NUT M16-1.5
198	P0566198	GUIDE BRACKET
199	PW01M	FLAT WASHER 8MM
200	PSBS04M	BUTTON HD CAP SCR M8-1.25 X 35
201	P0566201	BUSHING
202	P0566202	SWITCH BUSHING
203	PSB06M	CAP SCREW M6-1 X 25
204	P0566204	HANDWHEEL
205	PW01M	FLAT WASHER 8MM
206	P0566206	UPPER GUIDE BAR
207	P0566207	RACK
208	PSB01M	CAP SCREW M6-1 X 16
209	PN04M	HEX NUT M4-.7
210	PS38M	PHLP HD SCR M4-.7 X 10
211A	P0566211A	UPPER GUIDE SUPPORT BLOCK
212	PB83M	HEX BOLT M6-1 X 16
213	P0566213	GUIDE BRACKET

# G0566 Parts List

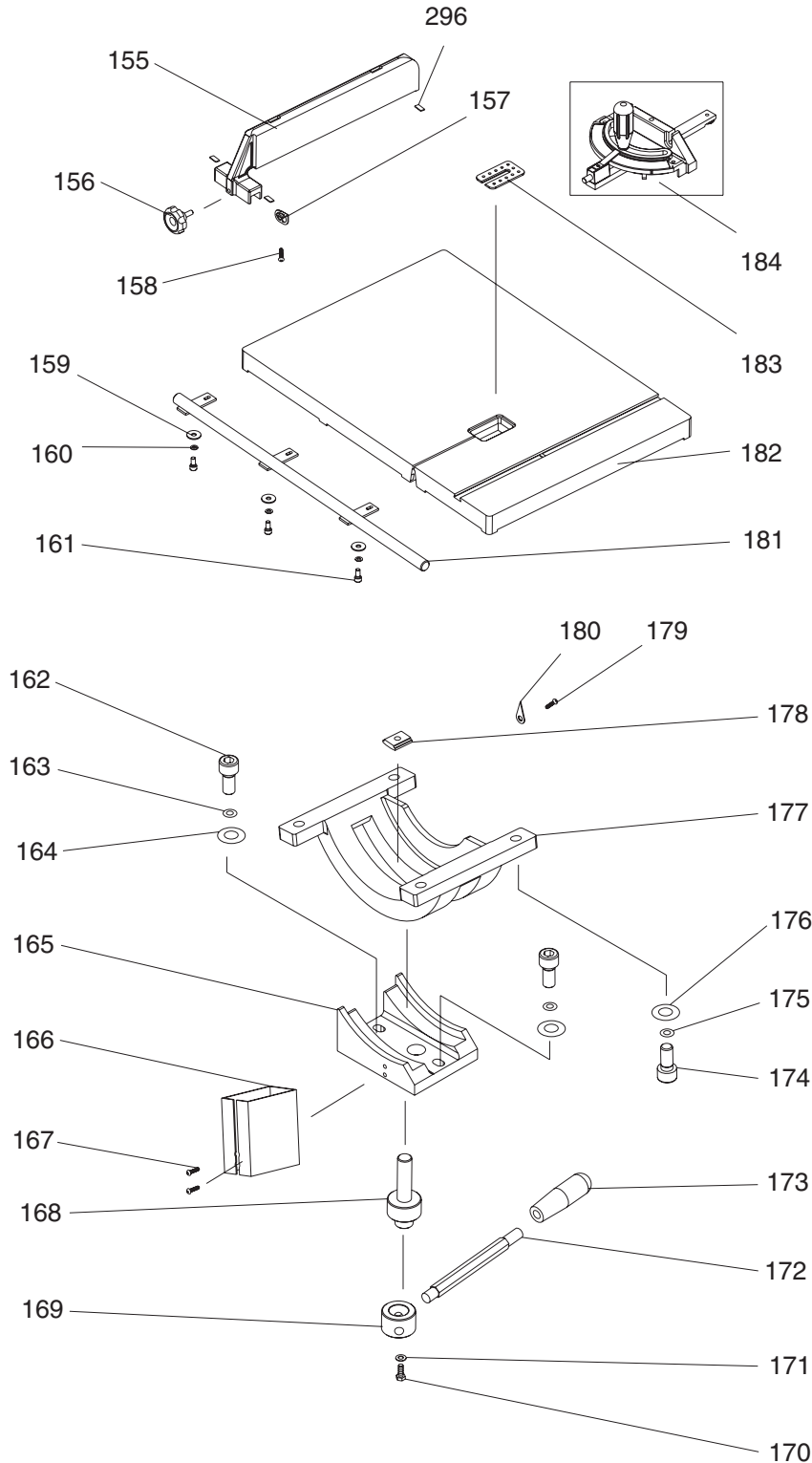
REF	PART #	DESCRIPTION
214	PSB14M	CAP SCREW M8-1.25 X 20
215	PLW04M	LOCK WASHER 8MM
216	P0566216	SUPPORT PLATE
217	PW01M	FLAT WASHER 8MM
218	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
219	PSB04M	CAP SCREW M6-1 X 10
220	PLN04M	LOCK NUT M8-1.25
221	PW01M	FLAT WASHER 8MM
222	P0566222	SLIDING PLATE
223	PB30M	HEX BOLT M8-1.25 X 55
224	PLW03M	LOCK WASHER 6MM
225	P0566225	WORM CYLINDER
226	PN05M	HEX NUT M16-1.5
227	P0566227	HANDWHEEL
228	PS52M	PHLP HD SCR M4-.7 X 20
229	PSB06M	CAP SCREW M6-1 X 25
230	P0566230	BUSHING
231	P0566231	SWITCH BUSHING
232	PSS07M	SET SCREW M5-.8 X 5
233	PN06M	HEX NUT M5-.8
234	PLW04M	LOCK WASHER 8MM
235	PSB11M	CAP SCREW M8-1.25 X 16
236	PFS07M	FLANGE SCREW M5-.8 X 10
237	P0566237	COVER
238	P0566238	COVER
239	P0566239	SPECIAL BOLT
240	P0566240	CORD CONNECTOR 224-201
241	PFH19M	FLAT HD SCR M4-.7 X 10
242	P0566242	RACK
243	P0566243	SQUARE TUBE
244	PFS05M	FLANGE SCREW M4-.7 X 10
245	PN04M	HEX NUT M4-.7
246	P0566246	PINION GEAR
247	PSB04M	CAP SCREW M6-1 X 10
248	PLW03M	LOCK WASHER 6MM
249	PW03M	FLAT WASHER 6MM
250	P0566250	SUPPORT PLATE
251	PW03M	FLAT WASHER 6MM
252	PSB04M	CAP SCREW M6-1 X 10

REF	PART #	DESCRIPTION
253A	P0566253A	PROTECT COVER ASSY
254	PW03M	FLAT WASHER 6MM
255	PSB04M	CAP SCREW M6-.1 X 10
256A	P0566256A	SLIDING PLATE
257	P0566257	PLASTIC WASHER 6MM
258	PFS11M	FLANGE SCREW M6-1 X 10
259A	P0566259A	ADJUST BAR
260A	P0566260A	BLADE GUIDE SUPPORT
261	PB83M	HEX BOLT M6-1 X 16
262A	P0566262A	UPPER SPACING SLEEVE
263A	P6201	BALL BEARING 6201ZZ
264A	PR03M	EXT RETAINING RING 12MM
265	PSB01M	CAP SCREW M6-1 X 16
266	PW03M	FLAT WASHER 6MM
267A	P0566267A	ADJUSTING SHAFT
273	PCAP29M	CAP SCREW M6-1 X 40
274	P0566274	HANDLE BUSHING
275	P6202	BALL BEARING 6202ZZ
276	PR05M	EXT RETAINING RING 15MM
277A	P0566277A	ECCENTRIC SHAFT
279A	P0566279A	SUPPORT BRACKET
280	PB83M	HEX BOLT M6-1 X 16
287	PSS07M	SET SCREW M5-.8 X 5
288	PSB04M	CAP SCREW M6-1 X 10
289	PW03M	FLAT WASHER 6MM
290A	P0566290A	SUPPORT
291A	P0566291A	PROTECT TUBE 1/2"X1100mm(L)
292	P0566292	CORD BUSHING
293	P0566293	MACHINE ID LABEL
294	PLABEL-20	DON'T OPEN LABEL
295	PLABEL-19	HANDS/BS BLADE 2"X3 5/16"H.
296	PLABEL-18	UNPLUG BANDSAW LABEL
297	PLABEL-14	ELECTRICITY LABEL
298	PLABEL-12	READ MANUAL 2"W X 3 5/16"
299	PLABEL-11	SAFETY GLASSES 2" X 3 5/16"
300	P0566300	TENSION LEVER LABEL
301	P0566301	TABLE LOCK LABEL

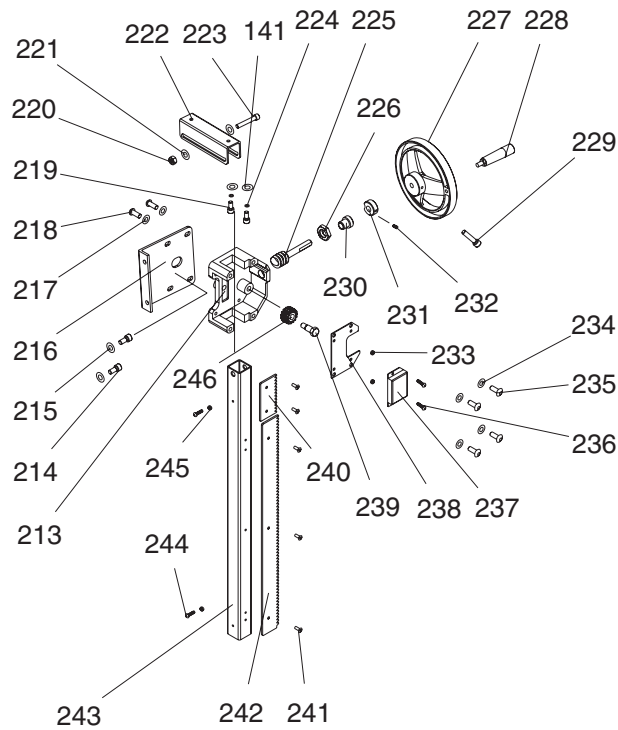
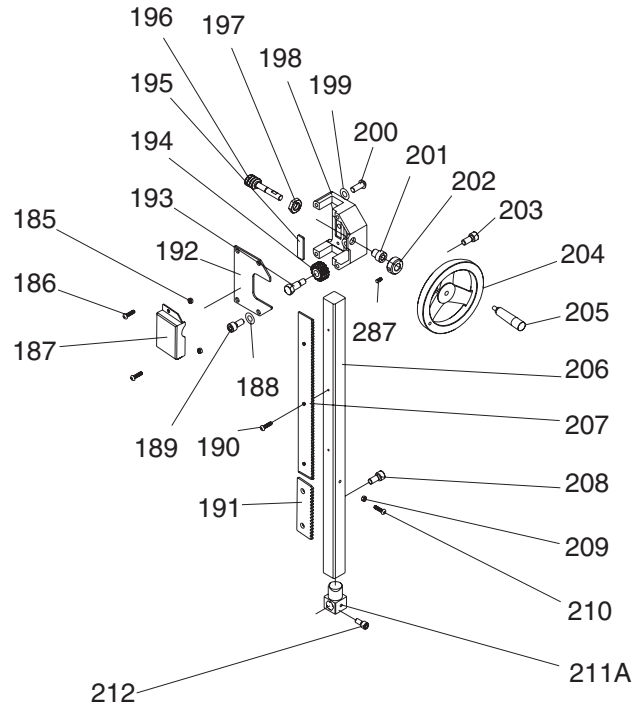
# G0568/G0569 Parts Breakdown



# G0568/G0569 Parts Breakdown

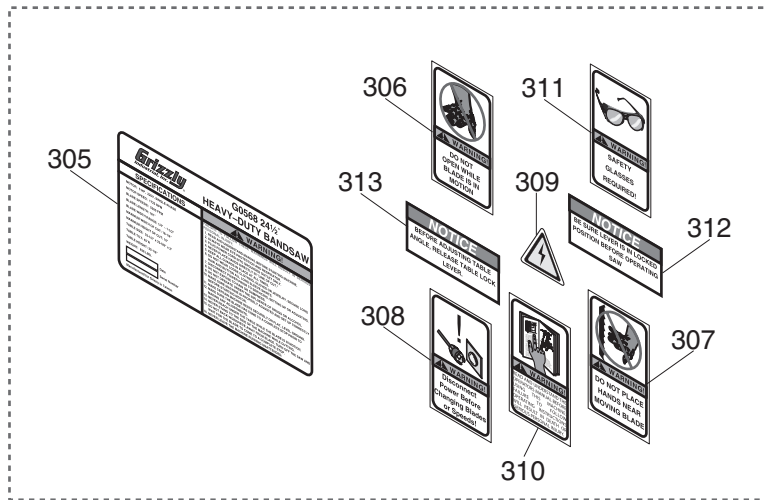
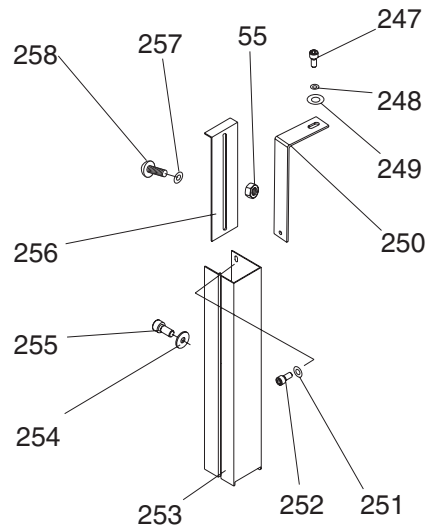
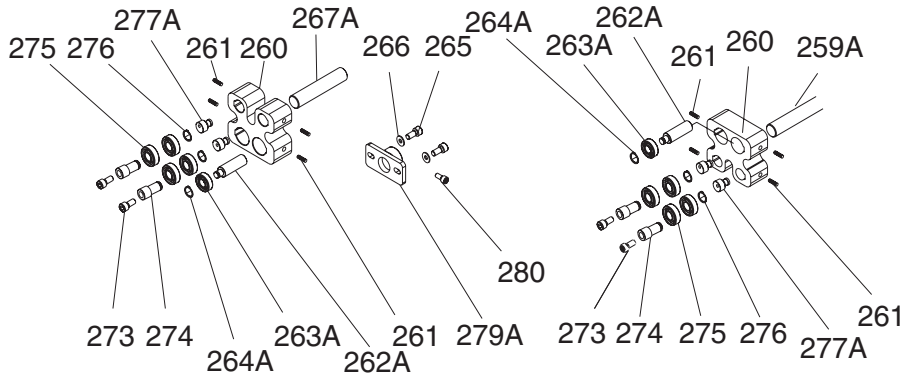


# G0568/G0569 Parts Breakdown





# G0568/G0569 Parts Breakdown



# G0568/G0569 Parts List

REF	PART #	DESCRIPTION
1	P0566001	HANDLE KNOB
2	P0566002	HANDLE SHAFT
3	PN05M	HEX NUT M16-1.5
4	P0566004	ROTATE SHAFT
5	PSBS03M	BUTTON HD CAP SCR M10-1.5 X 20
6	PLW06M	LOCK WASHER 10MM
7	P0566007	KNOB SCREW M10-1.5 X 25
8	P0566008	LOCATE HANDLE M10-1.5
9	P0566009	KNOB SCREW M10-1.5 X 25
10	P0566010	TRANSLUCENT PIECE
11	P0566011	RIVET 3.2 X 10
12	P0566012	LATCHING KNOB 6MM
13	PSB02M	CAP SCREW M6-1 X 20
14	PB73M	HEX BOLT M10-1.5 X 50
15	PN02M	NUT M10-1.5
16	P0566016	HEIGHT POINTER
17	PFS07M	FLANGE SCREW M5-.8 X 10
18	PHTEK15M	TAP SCREW M4 X 10
19	P0566019	STRAIN RELIEF M20
20	P0566020	PLATE
21	PHTEK4M	TAP SCREW M4 X 8
22	P0566022	CORD CLAMP 1/2"
23	P0568023	MOTOR 5HP G0568
23	P0569023	MOTOR 7-1/2HP G0569
23-1	P0568023-1	FAN COVER G0568
23-1	P0569023-1	FAN COVER G0569
23-2	P0568023-2	FAN G0568
23-2	P0569023-2	FAN G0569
23-3	P0568023-3	CAPACITOR COVER G0568
23-4	PC200A	CAPACITOR 200MFD 250V. G0568
23-5	P0568023-5	CAPACITOR COVER G0568
23-6	PC20A	CAPACITOR 20MFD/400V G0568
23-7	P0568023-7	ELECTRICAL BOX G0568
23-7	P0569023-7	WIRING BOX G0569
24	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
25	P0566025	PIECE
26	PB01M	HEX BOLT M10-1.5 X 30
27	PN02M	HEX NUT M10-1.5
28	PSB02M	CAP SCREW M6-1 X 20
29	P0566029	LATCHING KNOB 6MM
30	PW01M	FLAT WASHER 8MM
31	PSB31M	CAP SCREW M8-1.25 X 25

REF	PART #	DESCRIPTION
32	P0566032	BUSHING
33	PSB31M	CAP SCREW M8-1.25 X 25
34	PSB06M	CAP SCREW M6-1 X 25
35	PLW02M	LOCK WASHER 6MM
36	P0566036	BRAKE PAD
37	P0566037	BUSHING
38	P0568038	BRAKE LEVER
39	PSB01M	CAP SCREW M6-1 X 16
40	PSB01M	CAP SCREW M6-1 X 16
41	PLW03M	LOCK WASHER 6MM
42	P0566042	BRAKE STEP PLATE
43	P0566043	SPRING
44	PN01M	HEX NUT M6-1
45	PSB01M	CAP SCREW M6-1 X 16
46	PHTEK4M	TAP SCREW M4 X 8
47	P0566047	CORD CLAMP 5/8"
48	P0566048	STEP CORD
49	PB41M	HEX BOLT M4-.7 X 30
50	P0566050	LIMIT SWITCH KL7141
51	PN04M	HEX NUT M4-.7
52	P0568052	UPPER WHEEL COVER
53	PN04M	HEX NUT M4-.7
54	PW05M	FLAT WASHER 4MM
56	PS38M	PHLP HD SCR M4-.7 X 10
57	PS68M	PHLP HD SCR M6-1 X 10
58	P0568058	LOWER WHEEL COVER
59	P0568059	SAW BLADE 4600X25.4X.9MM
60	P0566060	TENSION GAUGE HOUSING
61	P0566061	SPRING
62	PRP61M	PIN 3 X 12
63	P0566063	MOVING PLATE
64	PHTEK15M	TAP SCREW M4 X 10
65	P0566065	FIX PLATE
66	P0566066	TENSION POINTER
67	PHTEK6M	TAP SCREW M4 X 16
68	P0568068	TENSION SCALE
69	P0566069	CONNECTING CORD
70	P0566070	SWITCH CORD
71	P0566071	SWITCH PLATE
72	PHTEK15M	TAP SCREW M4 X 10
73	P0566073	KEY SWITCH
74	P0566074	STOP SWITCH

# G0568/G0569 Parts List

REF	PART #	DESCRIPTION
75	P0566075	START SWITCH
76	P0566076	CONNECTING CORD
77	PFS09M	FLANGE SCREW M5-.8 X 50
78	P0566078	TERMINAL BOX
79	P0566079	TERMINAL HOUSE
80	P0568080	POWER CORD
81	P0566081	STRAIN RELIEF M20
82	P0568082	MAGNETIC SWITCH 220V G0568
82	P0569082	MAGNETIC SWITCH 220V G0569
82A	P0569082A	MAGNETIC SWITCH 440V G0569
83	PN04M	HEX NUT M4-.7
84	PW05M	FLAT WASHER 4MM
85	P0566085	DOOR LATCH SWITCH ADZ-S11
86	PFS10M	FLANGE SCREW M4-.7 X 35
87	P0568087	MACHINE BODY
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0566089	SWITCH CORD
90	P0566090	PLATE
91	PSB31M	CAP SCREW M8-1.25 X 25
92	P0566092	CAM
93	P0566093	MOTOR CORD
94	PLN03M	LOCK NUT M6-1
95	PN02M	HEX NUT M10-1.5
96	PW04M	FLAT WASHER 10MM
97	PSB14M	CAP SCREW M8-1.25 X 30
98A	PSB60M	CAP SCREW M8-1.25 X 55
99	PN03M	HEX NUT M8-1.25
100	P0566100	LOCATE PLATE
101	PFH39M	FLAT HD SCR M5-.8 X 16
102	P0568102	SPRING
103	P0566103	BUSHING
104	P0566104	PRESS BLOCK
105	PSS07M	SET SCREW M5-.8 X 5
106	P51201	BEARING 51201
107	PSS07M	SET SCREW M5-.8 X 5
108	P0566108	TENSION LINE
109	P0568109	SHAFT
110	P0566110	HANDWHEEL
111	PSB06M	CAP SCREW M6-1 X 25
112	P0566112	SQUARE SHAFT
113	PW01M	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
114	PSB31M	CAP SCREW M8-1.25 X 25
115	P0566115	UPPER WHEEL HINGE (ASM.)
116	PSS75M	SET SCREW M10-1.5 X 16
117	P0566117	GUIDE BLOCK
118	P0568118	UPPER WHEEL SHAFT
119	P6306	BALL BEARING 6306LLU
120	PR64M	INT RETAINING RING 72MM
121	P0568121	BUSHING
122	P0568122	UPPER WHEEL 25"
123	PW01M	FLAT WASHER 8MM
124	PLW04M	LOCK WASHER 8MM
125	PSB14M	CAP SCREW M8-1.25 X 20
126	PSB14M	CAP SCREW M8-1.25 X 20
127	PLW04M	LOCK WASHER 8MM
128	PW01M	FLAT WASHER 8MM
129	P6306	BALL BEARING 6306LLU
130	P0568130	LOWER WHEEL 25"
131	P0568131	BUSHING
132	PR64M	INT RETAINING RING 72MM
133	P0566133	PULLEY
134	PSS04M	SET SCREW M6-1 X 12
137	PSB14M	CAP SCREW M8-1.25 X 20
138	P0566138	PULLEY
139	P0568139	LOWER SHAFT
140	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
141	PW03M	FLAT WASHER 6MM
142	PVA33	V-BELT A-33 4L330
143	P0566143	BRUSH
144	PLN03M	LOCK NUT M6-1
145	PW03M	FLAT WASHER 6MM
146	PSB02M	CAP SCREW M6-1 X 20
147	PLN03M	LOCK NUT M6-1
148	P0566148	BRUSH
149	PW03M	FLAT WASHER 6MM
150	PSB02M	CAP SCREW M6-1 X 20
151	PLN03M	LOCK NUT M6-1
155	P0566155	FENCE
156	P0566156	KNOB SCREW M10-1.5 X 25
157	P0566157	POINTER
158	PFS01M	FLANGE SCREW M5-.8 X 8
159	PW03M	FLAT WASHER 6MM

# G0568/G0569 Parts List

REF	PART #	DESCRIPTION
160	PLW02M	LOCK WASHER 6MM
161	PSB14M	CAP SCREW M8-1.25 X 20
162	PSB72M	CAP SCREW M10-1.5 X 30
163	PLW06M	LOCK WASHER 10MM
164	PW04M	FLAT WASHER 10MM
165	P0566165	TRUNNION HOUSING
166	P0566166	BLADE GUARD
167	PFS11M	FLANGE SCREW M6 X 10
168	P0566168	PRESS SHAFT
169	P0566169	MICRO ADJUSTING RING
170	PSB14M	CAP SCREW M8-1.25 X 20
171	PLW04M	LOCK WASHER 8MM
172	P0566172	HANDLE SHAFT
173	P0566173	HANDLE KNOB M12-1.75
174	PSB84M	CAP SCREW M10-1.5 X 35
175	PLW04M	LOCK WASHER 8MM
176	PW04M	FLAT WASHER 10MM
177	P0566177	TRUNNION BLOCK
178	P0566178	PRESS BLOCK
179	PS38M	PHLP HD SCR M4-.7 X 10
180	P0566180	POINTER
181	P0568181	GUARD RAIL
182	P0568182	TABLE
183	P0566183	TABLE INSERT
184	P0566184	MITER GAUGE ASSY
184-1	P0566184-1	GUIDE
184-2	P0566184-2	GUIDE BAR
184-3	P0566184-3	LOCATE BRACKET
184-4	P0566184-4	LOCATE SHAFT
184-5	P0566184-5	POINTER
184-6	P0566184-6	STEP SCREW
184-7	P0566184-7	HANDLE
184-8	P0566184-8	MITER GAUGE BODY
184-9	PFH9M	FLAT HD SCR M6-1 X 6
184-10	PS06	PHLP HD SCR 10-24 X 3/8
184-11	PS56M	PHLP HD SCR M4-.7 X 16
184-12	PN04M	HEX NUT M4-.7
184-13	PW01M	FLAT WASHER 8MM
185	PLW04M	LOCK WASHER 8MM
186	PFS07M	FLANGE SCREW M5-.8 X 10
187	P0566187	COVER

REF	PART #	DESCRIPTION
189	PSB11M	CAP SCREW M8-1.25 X 16
190	PFH19M	FLAT HD SCR M4-.7 X 10
191	P0566191	EXTENSION RACK
192	P0566192	COVER
193	P0566193	FIXED BOLT
194	P0566194	PINION GEAR
195	P0566195	FIXED PLATE
196	P0566196	WORM CYLINER
197	PN05M	HEX NUT M16-1.5
198	P0566198	GUIDE BRACKET
199	PW01M	FLAT WASHER 8MM
200	PSBS04M	BUTTON HD CAP SCR M8-1.25 X 35
201	P0566201	BUSHING
202	P0566202	SWITCH BUSHING
203	PSB06M	CAP SCREW M6-1 X 25
204	P0568204	HANDWHEEL
205	P0568205	HANDLE
206	P0568206	UPPER GUIDE SUPPORT BLOCK
207	P0566207	RACK
208	PSB01M	CAP SCREW M6-1 X 16
209	PN04M	HEX NUT M4-.7
210	PS38M	PHLP HD SCR M4-.7 X 10
211A	P0566211A	UPPER GUIDE SUPPORT BLOCK
212	PB83M	HEX BOLT M6-1 X 16
213	P0566213	GUIDE BRACKET
214	PSB14M	CAP SCREW M8-1.25 X 20
215	PLW04M	LOCK WASHER 8MM
216	P0566216	SUPPORT PLATE
217	PW01M	FLAT WASHER 8MM
218	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
219	PB04M	HEX BOLT M6-1 X 10
220	PLN04M	LOCK NUT M8-1.25
221	PLW04M	FLAT WASHER 8MM
222	P0566222	SLIDING PLATE
223	PB30M	HEX BOLT M8-1.25 X 55
224	PLW03M	LOCK WASHER 6MM
225	P0566225	WORM CYLINDER
226	PN05M	HEX NUT M16-1.5
227	P0566227	HANDWHEEL
228	P0566228	KNOB M10-1.5 X 12
229	PSB06M	CAP SCREW M6-1 X 25

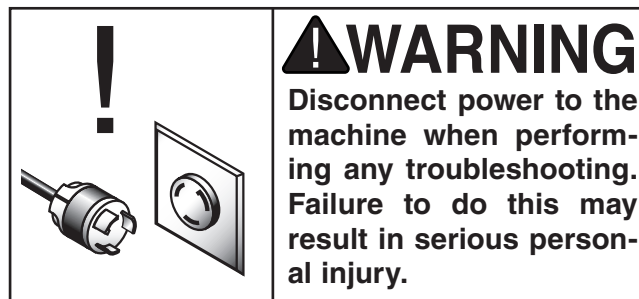
# G0568/G0569 Parts List

REF	PART #	DESCRIPTION
230	P0566230	BUSHING
231	P0566231	SWITCH BUSHING
232	PSS07M	SET SCREW M5-.8 X 5
233	PN03M	HEX NUT M5-.8
234	PLW04M	LOCK WASHER 8MM
235	PSB11M	CAP SCREW M8-1.25 X 16
236	PFS07M	FLANGE SCREW M5-.8 X 10
237	P0566237	COVER
238	P0566238	COVER
239	P0566239	SPECIAL BOLT
240	P0568240	STRETCH RACK
241	PFH19M	FLAT HD SCR M4-.7 X 10
242	P0566242	RACK
243	P0568243	SQUARE TUBE
244	PS38M	PHLP HD SCR M4-.7 X 10
245	PN04M	HEX NUT M4-.7
246	P0568246	PINION GEAR
247	PSB04M	CAP SCREW M6-1 X 10
248	PLW03M	LOCK WASHER 6MM
249	PW03M	FLAT WASHER 6MM
250	P0566250	SUPPORT PLATE
251	PW03M	FLAT WASHER 6MM
252	PSB04M	CAP SCREW M6-1 X 10
253	P0568253	PROTECT COVER ASSY
254	PW03M	FLAT WASHER 6MM
255	PSB04M	CAP SCREW M6-1 X 10
256	P0568256	SLIDING PLATE
257	P0566257	PLASTIC WASHER 6MM
258	PS68M	PHLP HD SCR M6-1 X 10
259A	P0566259A	ADJUST BAR
260A	P0566260A	BLADE GUIDE SUPPORT
261	PSS01M	SET SCREW M6-1 X 10
262A	P0566262A	UPPER SPACING SLEEVE
263A	P6201	BALL BEARING 6201ZZ
264A	PR03M	EXT RETAINING RING 12MM
265	PSB01M	CAP SCREW M6-1 X 16
266	PW03M	FLAT WASHER 6MM
267A	P0566267A	ADJUSTING SHAFT

REF	PART #	DESCRIPTION
273	PB47M	HEX BOLT M6-1 X 40
274	P0566274	HANDLE BUSHING
275	P6202	BALL BEARING 6202ZZ
276	PR05M	EXT RETAINING RING 15MM
277A	P0566277A	ECCENTRIC SHAFT
279A	P0566279A	LOWER SUPPORT BRACKET
280	PS83M	HEX BOLT M6-1 X 16
287	PSS07M	SET SCREW M5-.8 X 5
289	P0568289	CORD CONNECTOR 224-201
290	PS52M	PHLP HD SCR M4-.7 X 20
291	PW01M	FLAT WASHER 8MM
292	PN03M	HEX NUT M8-1.25
293	P0568293	CORD CLAMP 5/16"
294	PHTEK15M	TAP SCREW M4 X 10
295	PW01M	FLAT WASHER 8MM
296	P0568296	NYLON PIECE
297	PW01M	FLAT WASHER 8MM
298	PLW04M	LOCK WASHER 8MM
299	P0568299	PIN 6 X 15
300	PFS11M	FLANGE SCREW M6-1 X 10
301	PW03M	FLAT WASHER 6MM
302	P0568302	SUPPORT
303	P0568303	PROTECT TUBE 1/2" X 1100MM(L)
304	P0568304	CORD BUSHING
305	P0568305	MACHINE ID LABEL G0568
305	P0569305	MACHINE ID LABEL G0569
306	PLABEL-20	DON'T OPEN LABEL
307	PLABEL-19	HANDS/BS BLADE 2"X3 5/16"H.
308	PLABEL-18	UNPLUG BANDSAW LABEL
309	PLABEL-14	ELECTRICITY LABEL
310	PLABEL-12	READ MANUAL 2"W X 3 5/16"
311	PLABEL-11	SAFETY GLASSES 2" X 3 5/16"
312	P0566312	TESNSION LEVER LABEL
313	P0566313	TABLE LOCK LABEL
314	PB76M	HEX BOLT M12-1.75 X 110
315	PLW05M	LOCK WASHER 12MM
316	PW06M	FLAT WASHER 12MM
317	P0568317	RISER BAR

# Troubleshooting

Symptom	Possible Cause	Possible Solution
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> </ol>	<ol style="list-style-type: none"> <li>1. Repair or replace cord or plug for damaged insulation and shorted wires.</li> </ol>
Motor fails to develop full 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 the circuit.</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).	<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. Repair or replace 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>
Main blade runs backwards.	<ol style="list-style-type: none"> <li>1. Two of the power wires are reversed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Switch two of the current carrying wires at the terminal strip.</li> </ol>
Blade slows when cutting. Blade makes a squealing noise, especially on start-up.	<ol style="list-style-type: none"> <li>1. V-belts loose.</li> <li>2. V-belts worn out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten V-belts (page 44).</li> <li>2. Replace V-belts (page 44).</li> </ol>
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> <li>1. Pulley setscrews or keys are missing or loose.</li> <li>2. Motor fan is hitting the cover.</li> <li>3. V-belts are defective.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect keys and setscrews. Replace or tighten if necessary.</li> <li>2. Adjust fan cover mounting position, tighten fan, or shim fan cover.</li> <li>3. Replace V-belts (page 44).</li> </ol>



# Troubleshooting

Symptom	Possible Cause	Possible Solution
Wood cuts slow or smokes during cut.	<ol style="list-style-type: none"> <li>1. Worn or dull blade.</li> <li>2. Blade installed backwards.</li> <li>3. Blade spinning backwards due to reversed wires at terminal strip.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace blade (see page 36).</li> <li>2. Check blade rotation as described in "Test Run" on page 24 and reverse blade if necessary.</li> <li>3. Switch two of the current carrying wires at the terminal strip.</li> </ol>
Rough or poor quality cuts.	<ol style="list-style-type: none"> <li>1. Feeding workpiece too fast.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate.</li> </ol>
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> <li>1. Clogged dust port.</li> <li>2. Low CFM (airflow) from dust collection system.</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean out dust port.</li> <li>2. Three options: <ul style="list-style-type: none"> <li>—Check dust lines for leaks or clogs.</li> <li>—Move dust collector closer to saw.</li> <li>—Install a stronger dust collector.</li> </ul> </li> </ol>



	<p><b>⚠ WARNING</b></p> <p>Disconnect power to the machine when performing any troubleshooting. Failure to do this may result in serious personal injury.</p>
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# Warranty and Returns

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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.

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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.

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 Advertisement       Friend  
 Catalog       Card Deck  
 World Wide Web  
 Other \_\_\_\_\_
- Which of the following magazines do you subscribe to.  
 Practical Homeowner       Cabinetmaker  
 Shop Notes       Family Handyman  
 Today's Homeowner       Fine Homebuilding  
 WOOD       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 \_\_\_\_\_
- 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 \_\_\_\_\_
- 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 +
- What is your age group?  
 20-29       50-59  
 30-39       60-69  
 40-49       70 +
- How long have you been a woodworker?  
 0 - 2 Years       8 - 20 Years  
 2 - 8 Years       20+ Years
- How would you rank your woodworking skills?  
 Simple       Advanced  
 Intermediate       Master Craftsman
- 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  
 Other \_\_\_\_\_
- How many of your woodworking machines are Grizzly? \_\_\_\_\_
- 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 \_\_\_\_\_
- How many of the machines checked above are Grizzly? \_\_\_\_\_
- Which portable/hand held power tools do you own?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
- What machines/supplies would you like Grizzly Industrial to carry?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
- What new accessories would you like Grizzly Industrial to carry?  
 Builders Hardware       Hand Tools  
 Fasteners       Wood Components  
 Other \_\_\_\_\_
- What other companies do you purchase your tools and supplies from?  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_
- Do you think your purchase is good value?  
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- Would you recommend Grizzly Industrial to a friend?  
 Yes       No
- 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
- Comments: \_\_\_\_\_  
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