

Grizzly **Industrial, Inc.**®

MODEL G0636X **17" ULTIMATE BANDSAW** **OWNER'S MANUAL** *(For models manufactured since 09/18)*




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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#BL9291 PRINTED IN TAIWAN

V6.02.20



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



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

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the **serial number** and **manufacture date** from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

WARNING

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

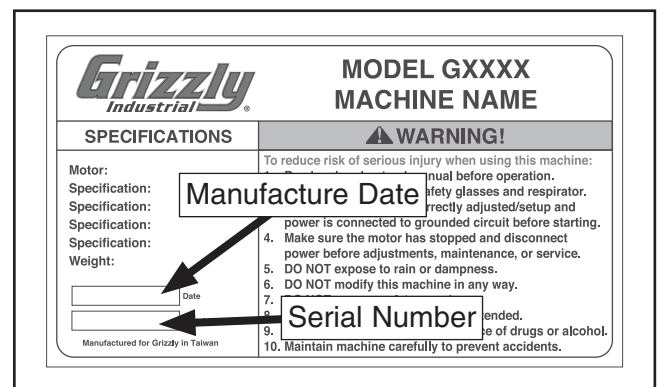
Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.





MACHINE DATA SHEET

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

MODEL G0636X ULTIMATE 17" 5 HP EXTREME SERIES BANDSAW

Product Dimensions:

Weight..... 620 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 35-1/4 x 33-3/4 x 78-1/2 in.
Footprint (Length x Width)..... 29-1/2 x 23-1/2 in.

Shipping Dimensions:

Type..... Wood Slat Crate
Content..... Machine
Weight..... 784 lbs.
Length x Width x Height..... 36 x 28 x 88 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 for 220V
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..... 1725 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Main Specifications

Bandsaw Size..... 17 in.
Max Cutting Width (Left of Blade)..... 16-1/2 in.
Max Cutting Width (Left of Blade) w/Fence..... 15-1/4 in.
Max Cutting Height (Resaw Height)..... 16 in.
Blade Speeds..... 4500 FPM



Blade Information

Standard Blade Length..... 162 in.
Blade Length Range..... 160 – 162 in.
Blade Width Range..... 1/8 – 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..... 21"
Table Width..... 25-1/2"
Table Thickness..... 2"
Table Tilt..... Left 5°, Right 45°
Table Tilt Adjustment Type..... Rack & Pinion
Floor-to-Table Height..... 35-1/2 in.
Fence Locking Position..... Front
Fence is Adjustable for Blade Lead..... Yes
Resaw Fence Attachment Included..... Yes
Miter Gauge Included..... Yes

Construction Materials

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

Other Related Information

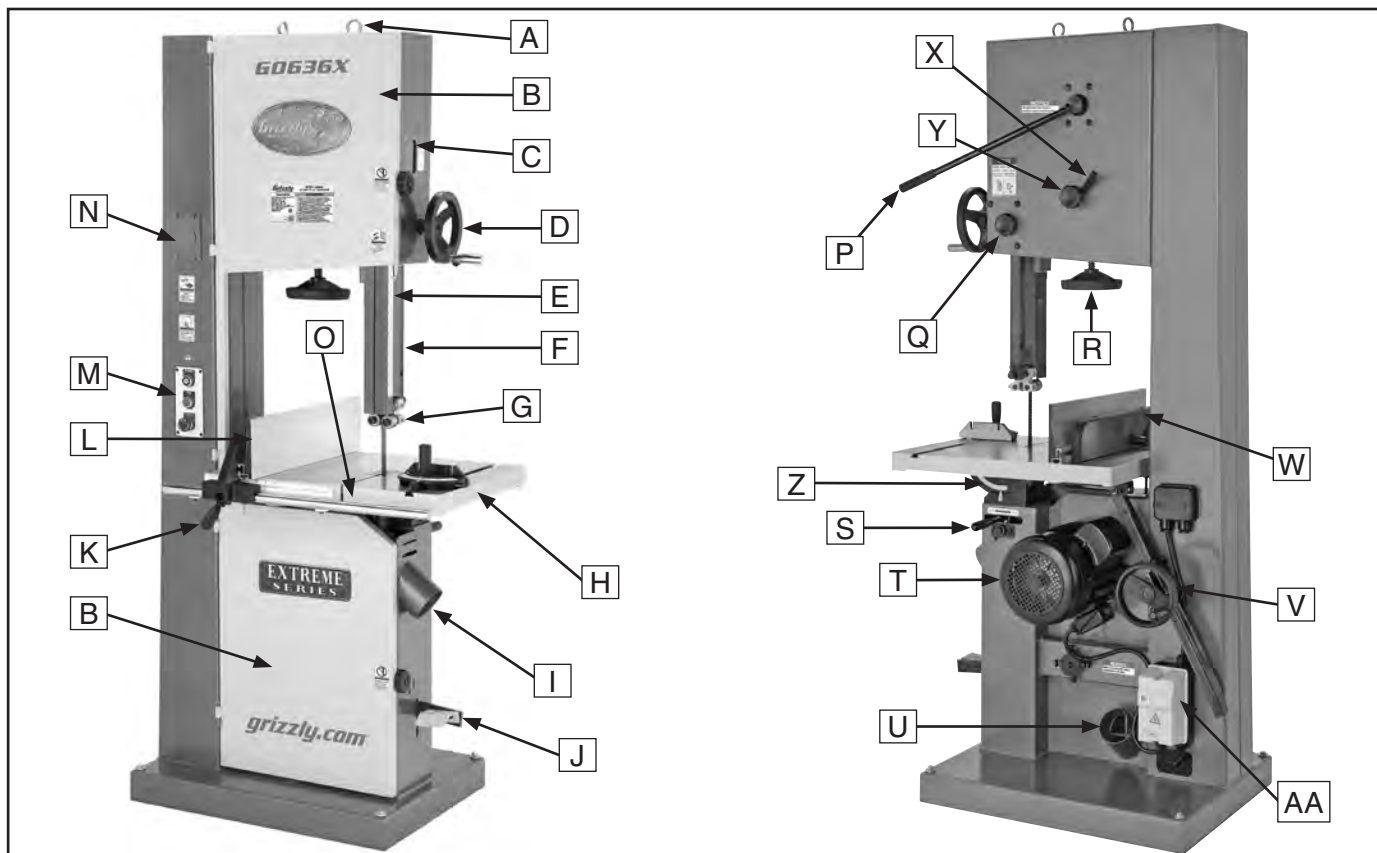
Wheel Diameter..... 17 in.
Wheel Width..... 1-3/4 in.
Number of Dust Ports..... 2
Dust Port Size..... 4 in.
Compatible Mobile Base..... D2058A

Other Specifications:

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



Identification



- | | |
|--|---|
| A. Eye Bolt | O. Rail |
| B. Hinged Wheel Cover | P. Quick-Release Blade Tension Lever |
| C. Blade Tracking Window | Q. Guide Post Lock Knob |
| D. Guide Post Handwheel | R. Blade Tension Handwheel |
| E. Cutting Height Scale | S. Table Tilt Lock Lever |
| F. Guide Post | T. Motor |
| G. Ball Bearing Blade Guides | U. 4" Dust Port |
| H. Miter Gauge | V. Table Tilt Handwheel |
| I. 4" Dust Port | W. Rip Fence |
| J. Foot Brake | X. Blade Tracking Lock Lever |
| K. Fence Lock Lever | Y. Blade Tracking Knob |
| L. Resaw Fence | Z. Table Tilt Scale |
| M. Key Switch, Start & Stop Buttons | AA. Magnetic Switch |
| N. Blade Tension Scale | |

⚠ CAUTION

For Your Own Safety, Read Instruction Manual Before Operating Saw.

- a) **Wear eye protection.**
- b) **Do not remove jammed cutoff pieces until blade has stopped.**
- c) **Maintain proper adjustment of blade tension, blade guides, and thrust bearings.**
- d) **Adjust upper guide to just clear workpiece.**
- e) **Hold workpiece firmly against table.**



Controls & Components

Front Controls

A. Power Switch: Disables ON/OFF buttons when key is turned to "0" position. Remove key to lock switch and prevent unauthorized use of machine.

IMPORTANT: Locking the power switch with the key only restricts its function. It is not a substitute for disconnecting power from the machine when adjusting or servicing.

B. ON Button: Starts motor only if OFF button is popped out and power switch is turned to "1" position.

C. OFF Button: Disables ON button. Enable ON button by twisting OFF button clockwise.

D. Blade Tension Scale: Allows for easy monitoring of blade tension.

E. Blade Tension Handwheel: Tensions blade in gradual increments.

F. Blade Tracking Window: Allows for easy monitoring of blade tracking (refer to **Page 19**).

G. Fence, Rail, and Miter Gauge: Allows for controlled cutting at various angles.

H. Foot Brake: Cuts power to motor and allows bandsaw blade to be quickly brought to a stop.

Rear Controls

I. Guide Post Handwheel and Lock Knob: Moves blade guide support quickly to the desired height on the guide post; locks setting (refer to **Page 34**).

J. Quick Release Blade Tension Lever: Releases blade tension for quick blade changes.

K. Blade Tracking Knob and Lock Lever: Moves and locks blade tracking.

L. Table Tilt Lock Lever: Locks or unlocks the table at the current angle.

M. Table Tilt Handwheel: Tilts the table up to 5° to the left or 45° to the right (refer to **Page 33**).

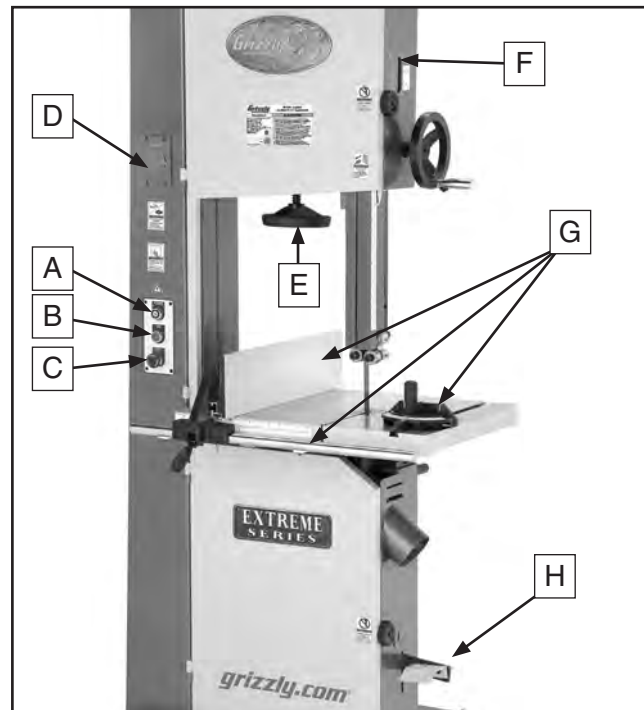


Figure 1. Front controls.

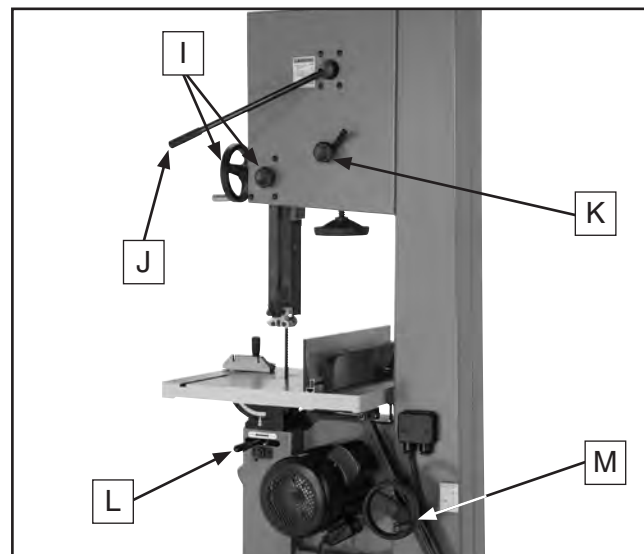


Figure 2. Rear controls.



SECTION 1: SAFETY

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 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. Always use common sense and good judgment.

⚠ 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 Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery

⚠ WARNING

OWNER'S MANUAL. Read and understand this owner's manual **BEFORE** using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply **BEFORE** making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are **NOT** approved safety glasses.



WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine **OFF** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.



Additional Safety for Bandsaws

WARNING

Serious cuts, amputation, or death can occur from contact with the moving saw blade during operation or if blade breakage occurs. Serious injury or death can also occur from getting fingers, hair, or clothing entangled in moving parts if the machine is operated while the doors are open. To reduce this risk, anyone operating this machine **MUST** completely heed the hazards and warnings below.

HAND PLACEMENT. Placing hands or fingers in line with blade during operation may result in serious injury if hands slip or workpiece moves unexpectedly. Do not position fingers or hands in line with blade, and never reach under table while blade is moving.

SMALL/NARROW WORKPIECES. If hands slip during a cut while holding small workpieces with fingers, serious personal injury could occur. Always support/feed small or narrow workpieces with push sticks, push blocks, jig, vise, clamping fixture.

BLADE SPEED. Cutting workpiece before blade is at full speed could cause blade to grab workpiece and pull hands into blade. Allow blade to reach full speed before starting cut. **DO NOT** start machine with workpiece contacting blade.

FEED RATE. To avoid risk of workpiece slipping and causing operator injury, always feed stock evenly and smoothly.

BLADE CONDITION. Dull blades require more effort to perform cut, increasing risk of accidents. Do not operate with dirty, dull, cracked or badly worn blades. Inspect blades for cracks and missing teeth before each use. Always maintain proper blade tension and tracking while operating.

CLEARING JAMS AND CUTOFFS. Always stop bandsaw and disconnect power before clearing scrap pieces that get stuck between blade and table insert. Use brush or push stick, not hands, to clean chips/cutoff scraps from table.

BLADE CONTROL. To avoid risk of injury due to blade contact, always allow blade to stop on its own. **DO NOT** try to stop or slow blade with your hand or the workpiece.

GUARDS/COVERS. Blade guards and covers protect operator from moving bandsaw blade. The wheel covers protect operator from getting entangled with rotating wheels or other moving parts. **ONLY** operate bandsaw with blade guard in proper position and wheel covers completely closed.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure blade teeth face down toward table and blade is properly tensioned and tracked before operating.

UPPER BLADE GUIDE SUPPORT. To reduce exposure of operator to blade and provide maximum blade support while cutting, keep upper blade guides adjusted to just clear workpiece.

CUTTING TECHNIQUES. To avoid blade getting pulled off wheels or accidentally breaking and striking operator, always turn bandsaw **OFF** and wait for blade to come to a complete stop before backing workpiece out of blade. **DO NOT** back workpiece away from blade while bandsaw is running. **DO NOT** force or twist blade while cutting, especially when sawing small curves. This could result in blade damage or breakage.

WORKPIECE SUPPORT. To maintain maximum control and reduce risk of blade contact/breakage, always ensure adequate support of long/large workpieces. Always keep workpiece flat and firm against table/fence when cutting to avoid loss of control. If necessary, use a jig or other workholding device.

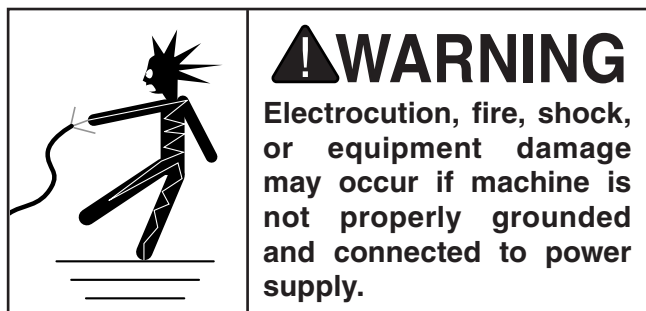
WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is **NOT** designed to cut metal, glass, stone, tile, etc.



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 at 230V 22 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.

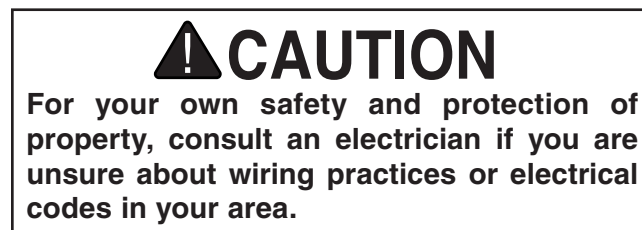
If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets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

Circuit Requirements for 230V

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

Nominal Voltage 230V/240V
Cycle 60 Hz
Phase 1-Phase
Power Supply Circuit 30 Amps
Plug/Receptacle NEMA L6-30
Cord “S”-Type, 3-Wire, 10 AWG, 300 VAC

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.)



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.*



Grounding Instructions

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.

The power cord and plug specified under “Circuit Requirements for 230V” on the previous page has an equipment-grounding wire and a grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see following figure).

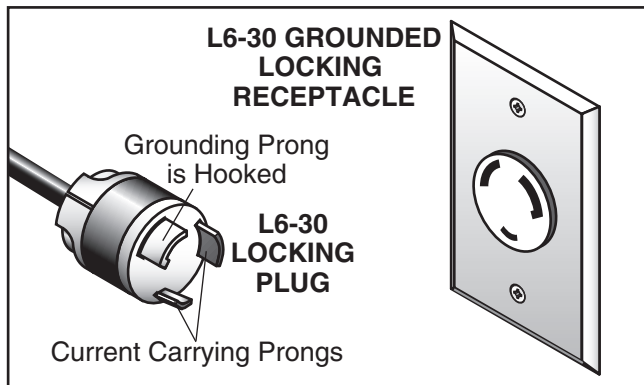
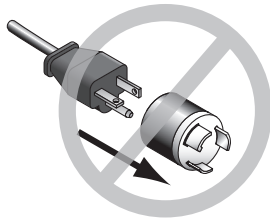


Figure 3. Typical L6-30 plug and receptacle.

⚠️ 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.

⚠️ 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.

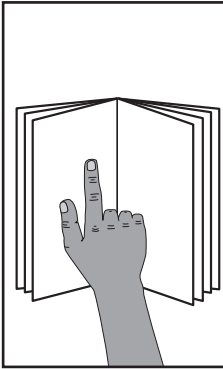
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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 Size10 AWG
Maximum Length (Shorter is Better).....50 ft.

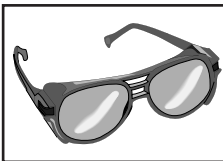


SECTION 3: SETUP



!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 setup process!



!WARNING

HEAVY LIFT!

Straining or crushing injury may occur from improperly lifting machine or some of its parts. To reduce this risk, get help from other people and use a forklift (or other lifting equipment) rated for weight of this machine.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Forklift, 1000 lb. Capacity.....	1
• Chain or Strap w/Hook, 1000 lb. Capacity.	1
• Machinist's Square	1
• Straightedge 3'	1
• Dust Collection System	1
• Dust Hoses 4"	2
• Hose Clamps 4"	2

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. *You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.*



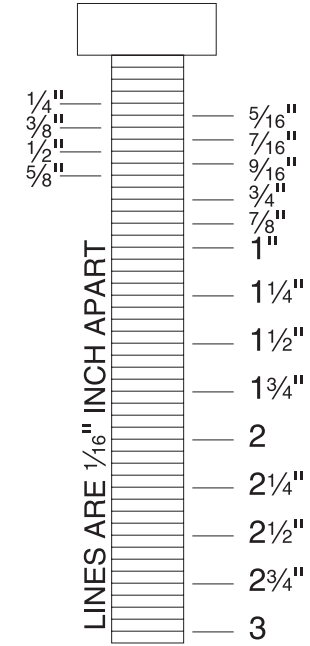
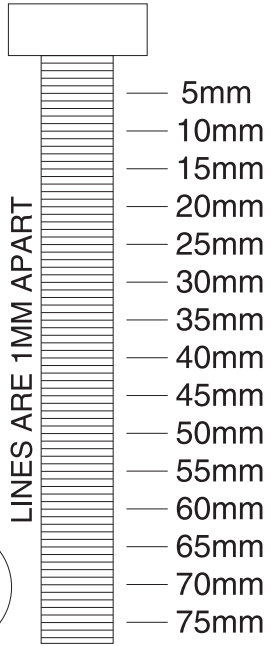
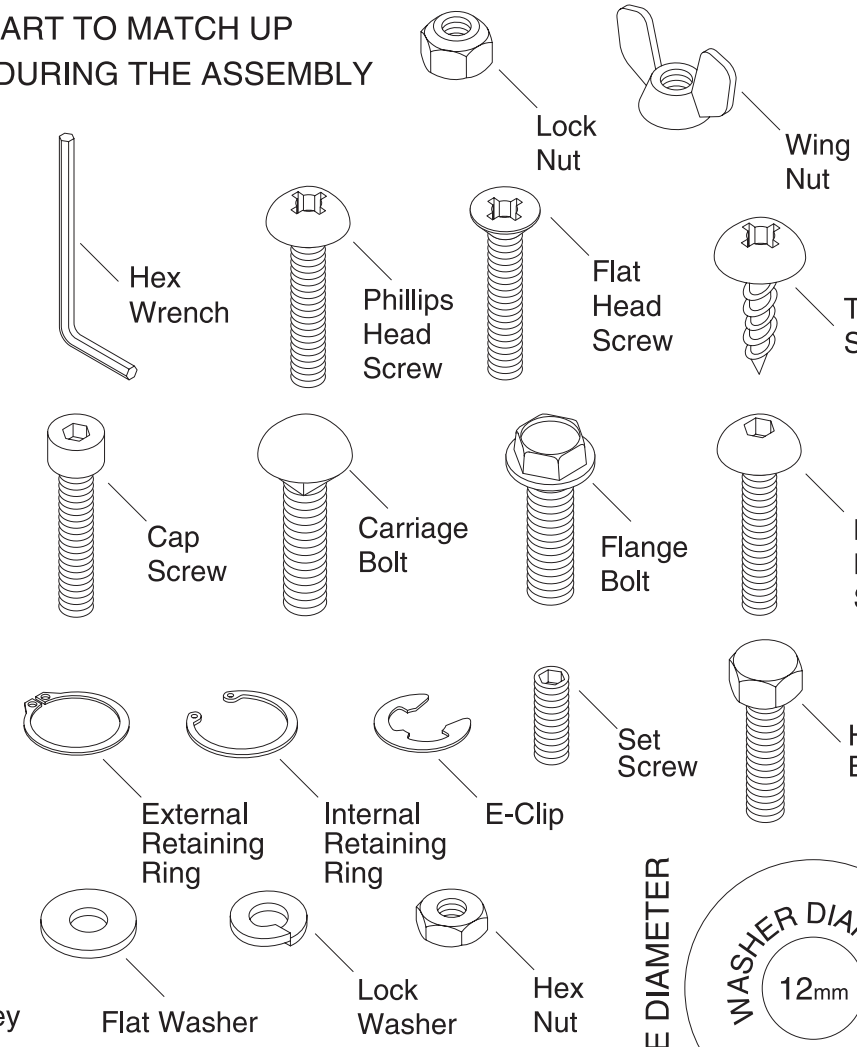
Hardware Recognition Chart

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

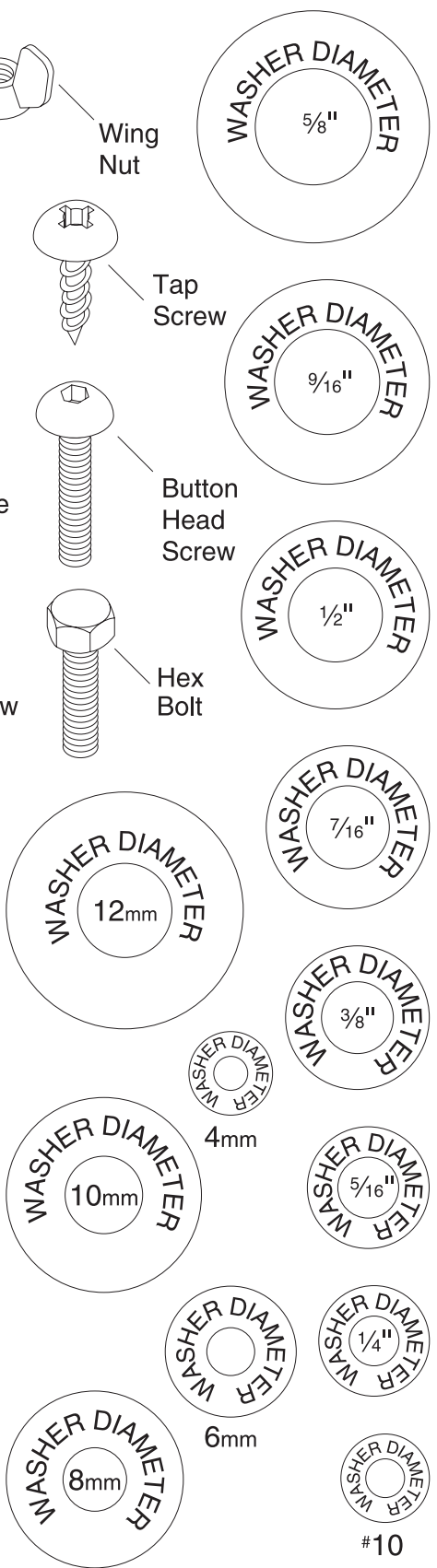
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

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

- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Inventory

The following is a list of items shipped with your machine. Before beginning setup, lay these items out and inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Crate Contents (Figure 4)	Qty
A. Bandsaw (not shown)	1
B. Cast Iron Fence Assembly	1
C. Resaw Fence	1
D. Guide Post Handwheel.....	1
E. Miter Gauge.....	1

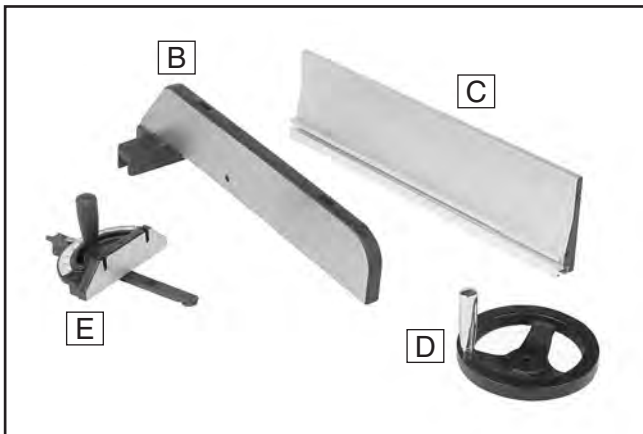


Figure 4. Loose inventory components.

Hardware and Tools (Not Shown)	Qty
• Eye Bolts M10-1.5 x 15	2
• Handle M8-1.25 x 45 (Resaw Fence).....	1
• Flat Washer 8mm (Resaw Fence).....	1
• Moving Plate (Resaw Fence)	1
• Open-End Wrench 10 x 13mm.....	1
• Open-End Wrench 17 x 19mm.....	1
• Hex Wrenches 5, 6mm.....	1 Ea

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

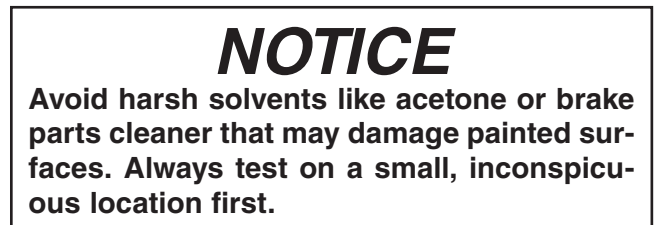
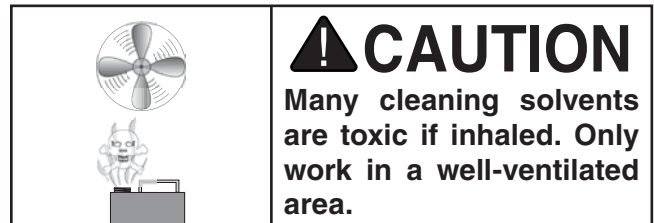
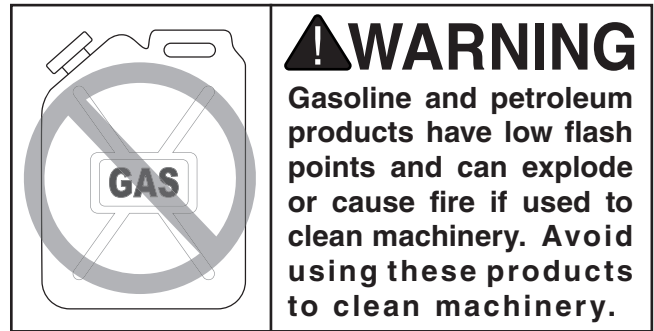
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from the **non-painted** parts of the machine during clean up.



Figure 5. T23692 Orange Power Degreaser



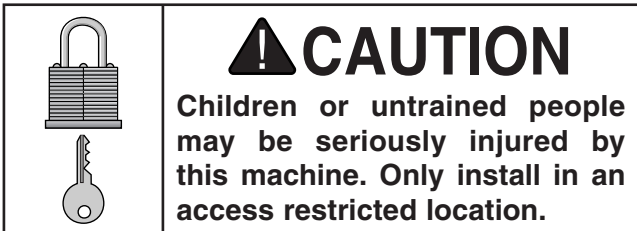
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20%–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave enough space around machine to disconnect power supply or apply a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

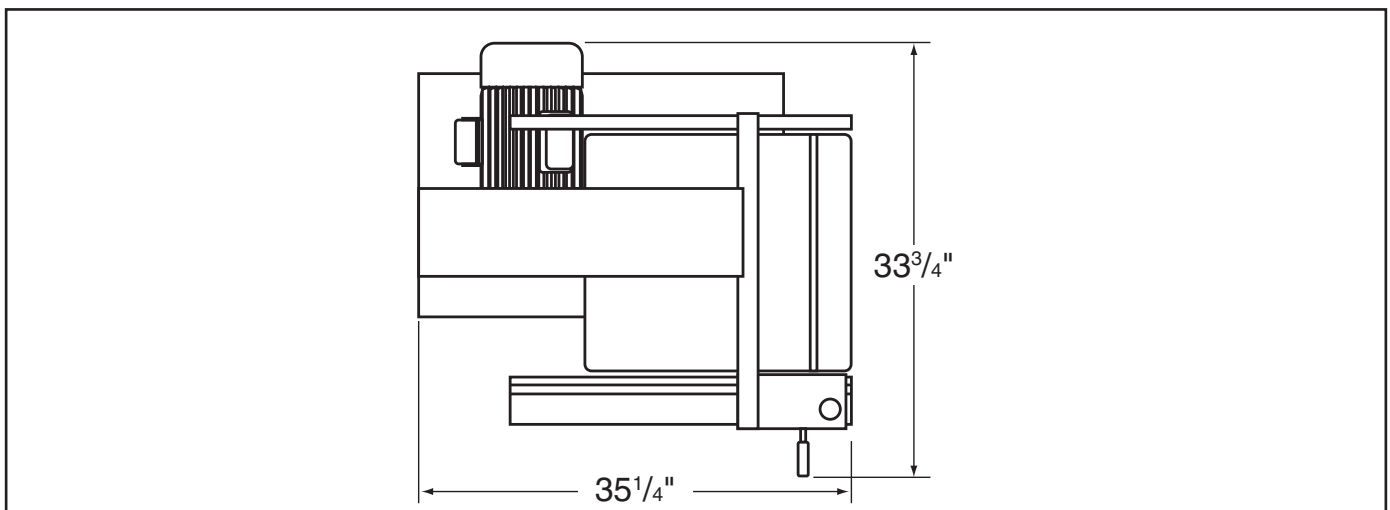


Figure 6. Minimum working clearances.



Moving & Placing Base Unit

!WARNING

This is an extremely heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and a forklift or a hoist when removing the machine from the crate. Use a chain or a lifting strap with a minimum of 1000 lbs. lifting capacity. If the chain or lifting strap breaks, serious personal injury may occur.

Take special care when moving this bandsaw. Only use the following methods to lift or move this bandsaw.

To move and place bandsaw:

1. Use a forklift to move bandsaw on the pallet to its final location.
2. Unbolt bandsaw from pallet.
3. Install eye bolts shown in **Figure 7**, making sure they are threaded all the way in, then place lifting hooks through eye bolts and lift slowly with a forklift.
4. Remove pallet and slowly set bandsaw into position.

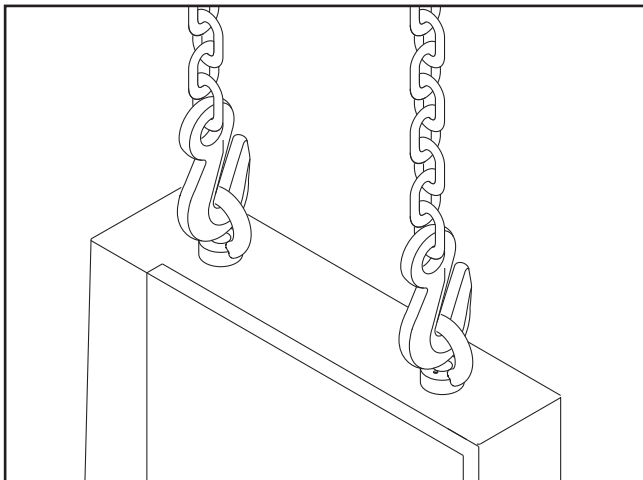


Figure 7. Lifting the bandsaw.

To move and place the bandsaw using wood shims:

1. Use a forklift to move bandsaw on the pallet to its final location.
2. Carefully place forklift forks under head and install a 1x4 shim between the head and the left fork, and a 2x4 shim between the head and right fork so bandsaw is level, as shown in **Figure 8**.
3. Unbolt bandsaw from pallet.

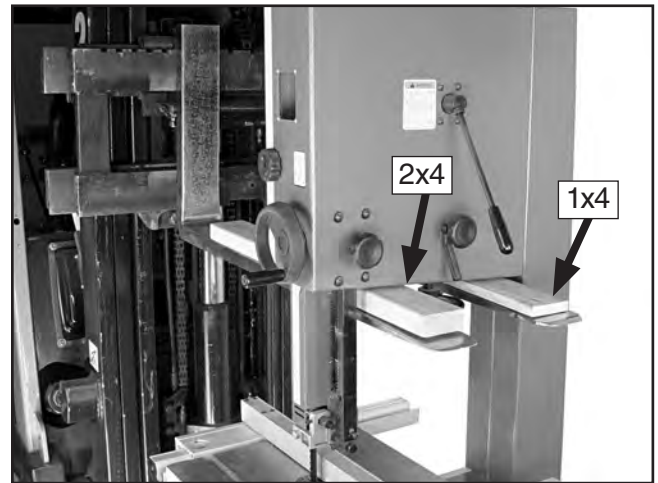


Figure 8. Example of lifting bandsaw with forklift using wood shims.

4. Lift bandsaw off of pallet, remove pallet, and slowly set bandsaw into position.

Note: If you are concerned about your forklift forks hitting the tension handwheel, remove the handwheel, then re-install it after lifting.



Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. However, you must level your machine with a precision level.

You may also mount your machine to a mobile base (see **Figure 10**) that has wheel locking or wheel retracting capabilities that keep the mobile base from rolling when the bandsaw is in use. We recommend using the Grizzly Model D2058A mobile base.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 9**) and anchor studs are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

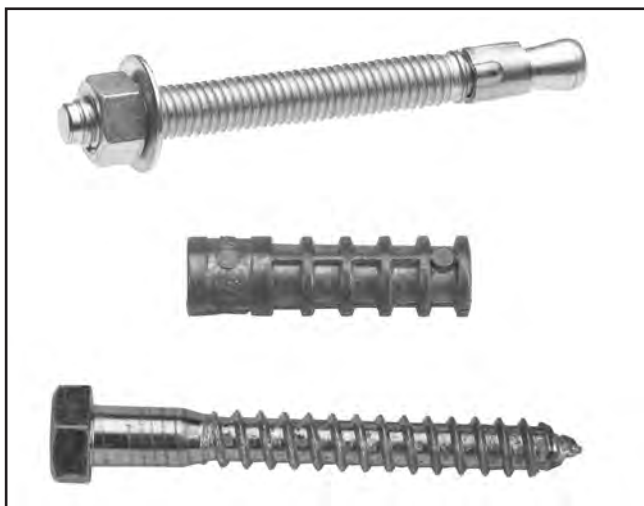


Figure 9. Typical fasteners for mounting to concrete floors.

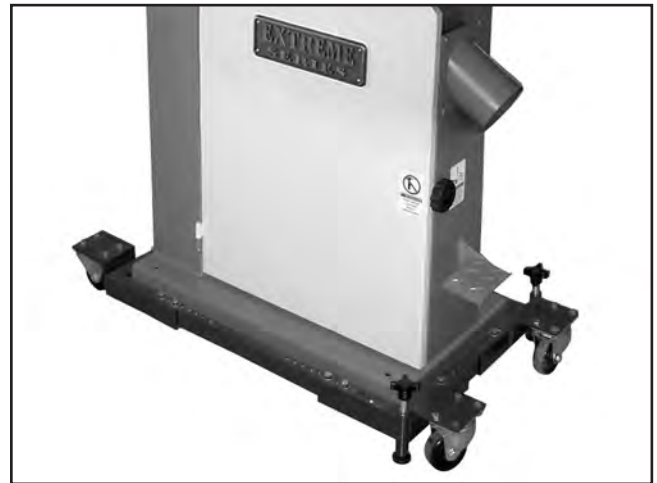


Figure 10. Bandsaw mounted on D2058A mobile base.

Guide Post Handwheel

To install guide post handwheel:

1. Insert guide post handwheel onto shaft, and secure it with cap screw on flat side of shaft, as shown in **Figure 11**.

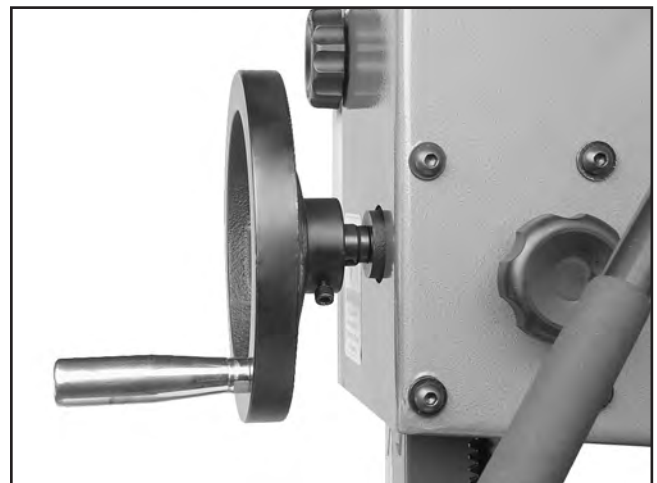
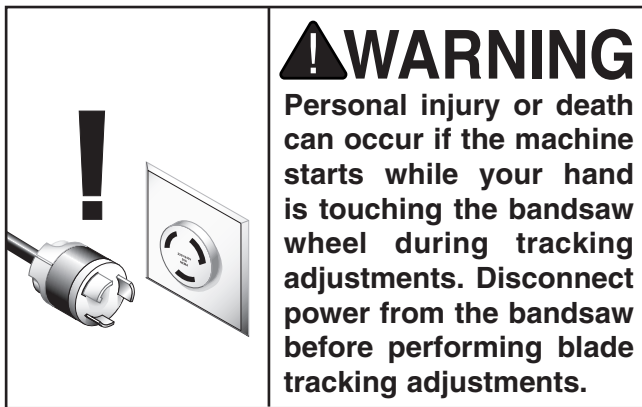


Figure 11. Guide post handwheel installed.



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." (For Coplanar Tracking, see the **Wheel Alignment** instructions on **Page 50**.)

The wheels on this bandsaw were aligned at the factory, so Center Tracking is the only adjustment that needs to be performed.

To center track the blade:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure upper and lower blade guides are adjusted away from blade (see **Page 24**).
3. Move quick tension lever to tightened position and turn blade tension handwheel until blade tension matches the mark on the blade tension scale for appropriate blade thickness (see **Figure 12**).

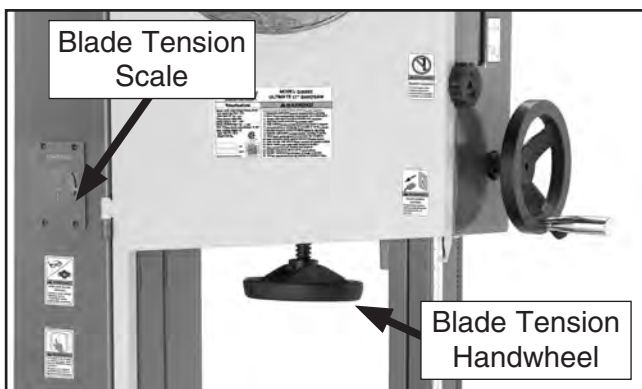


Figure 12. Blade tensioning controls.

4. Open upper wheel cover.
5. Spin upper wheel by hand at least three times and watch how blade rides on the crown of the wheel. Refer to **Figure 13** 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 center 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.

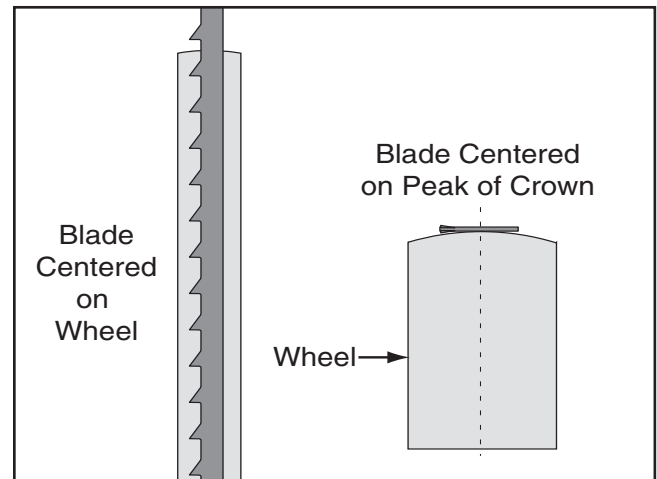


Figure 13. Center tracking profiles.



- Loosen lock lever (see **Figure 14**) so blade tracking knob can rotate.

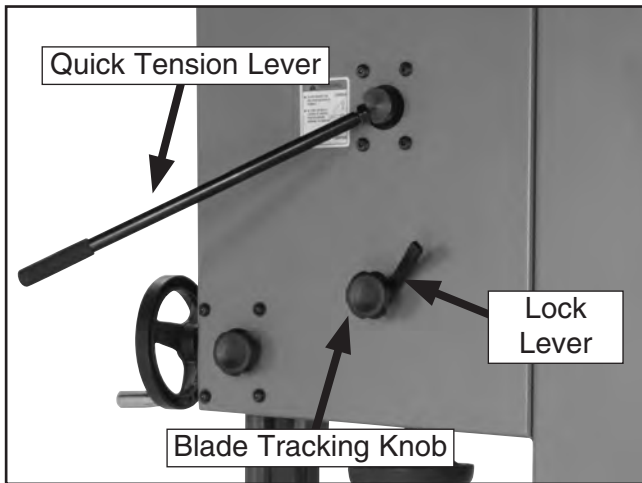


Figure 14. Blade tracking controls.

- Spin upper wheel with one hand and rotate blade tracking knob with other hand to make blade ride in center of bandsaw wheel tire.
- Tighten lock lever and close upper wheel cover.

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

NOTICE

Changes in the blade tension may change the blade tracking.

Positive Stop



The positive stop allows the table to be quickly and accurately returned to the horizontal (0°) position after being adjusted to a different angle.

To set the positive stop:

- DISCONNECT MACHINE FROM POWER!
- Adjust blade tension to appropriate level for blade size on blade tension scale (see **Page 24**).
- Loosen jam nut that locks positive stop bolt in place.

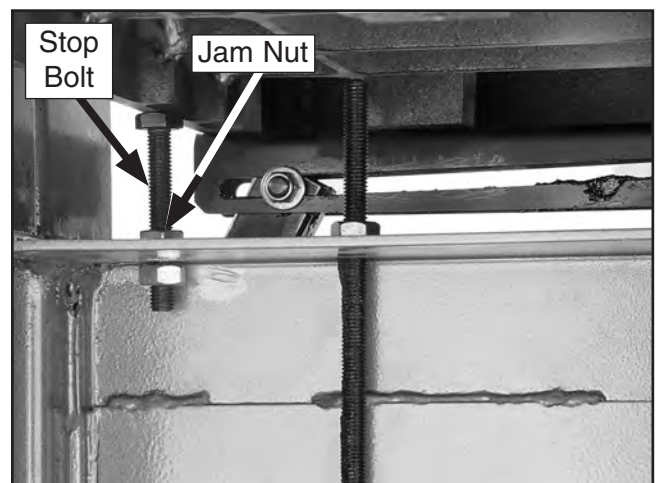


Figure 15. Positive stop bolt and jam nut (as viewed from front).



4. Raise guide post and place a machinist's square on table next to side of blade as illustrated in **Figure 16**. Adjust table square with blade using table tilt handwheel, then secure with table tilt lock lever.

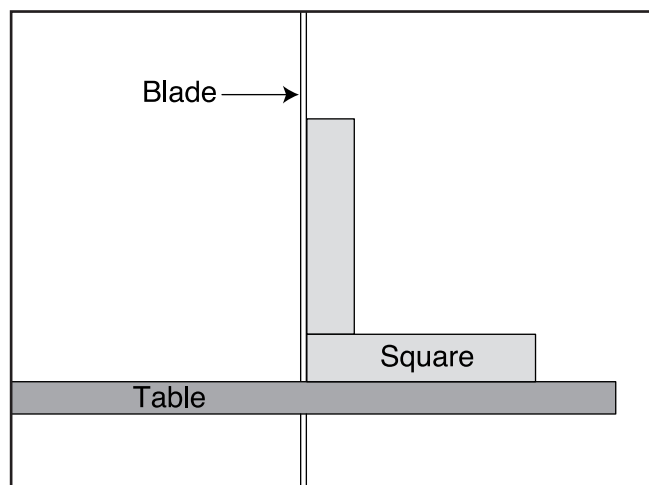


Figure 16. Squaring table to blade.

5. Adjust positive stop bolt so it just touches table, and secure it by tightening jam nut against bandsaw.
6. Check adjustment for accuracy once you have tightened jam nut.
7. Loosen screw on table tilt scale pointer, but do not remove it.
8. Align tip of pointer with 0° mark on table tilt scale, then tighten screw to secure setting.

Dust Collection

⚠ CAUTION

DO NOT operate the Model G0636X 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.

Recommended CFM at each Dust Port: 400

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 4" dust hose over each dust port, as shown in **Figure 17**, and secure in place with a hose clamp.
2. Tug each hose to make sure it does not come off.

Note: *A tight fit is necessary for proper performance.*

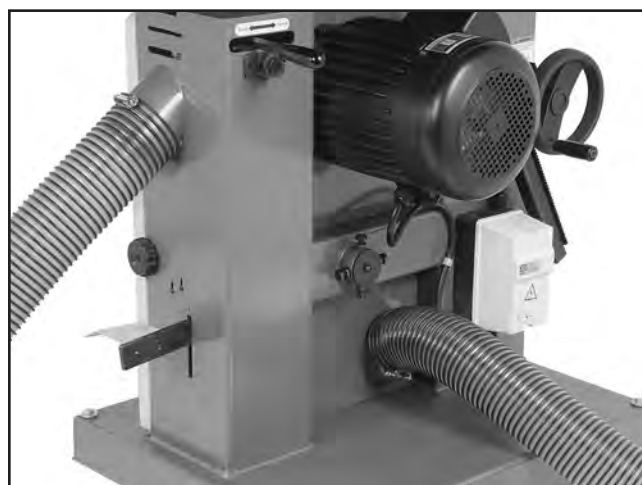


Figure 17. Dust hoses attached to dust port.



Installing Fence

The fence assembly mounts directly to the work table. Ensure all fence and rail fasteners remain tight for best performance.

To install fence:

1. Install resaw fence lock handle, 8mm fender washer, and moving plate onto standard fence (see **Figure 18**), then slide resaw fence over moving plate.

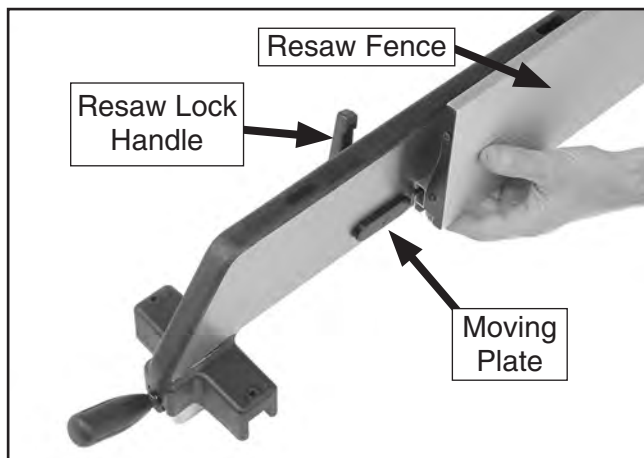


Figure 18. Example of attaching resaw fence to standard fence.

2. Tighten resaw lock handle.
3. Pull fence handle up and place fence assembly on rail, as shown in **Figure 19**.
4. Push fence handle down to lock fence assembly in place (see **Figure 19**).

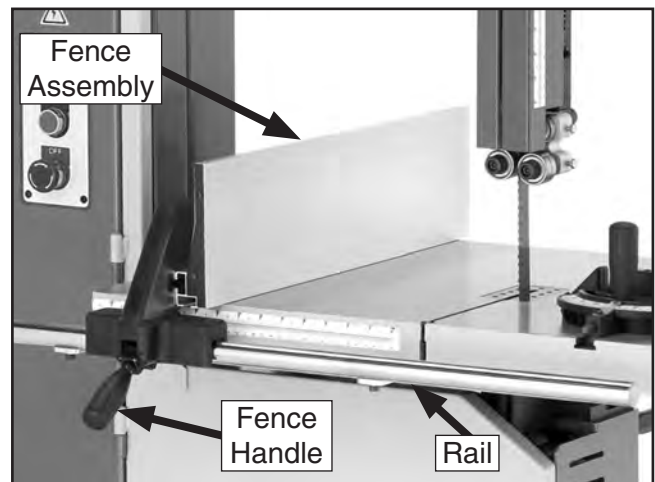


Figure 19. Fence installed on table.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, 2) the safety disabling mechanism on the switch works correctly, and 3) the stop button safety feature works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting on Page 46**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run machine:

1. Make sure you have read safety instructions at beginning of manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from machine.
3. Connect machine to power source.
4. Verify machine is operating correctly by turning switch disabling key (**Figure 20**) to "1" and turning machine **ON**.

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

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

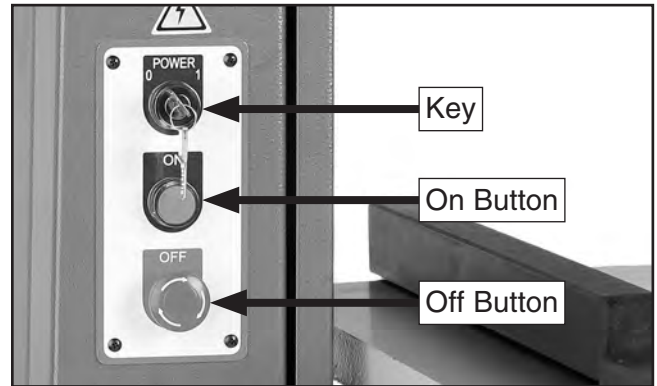


Figure 20. Location of switch disabling key and ON/OFF switch.

5. Press OFF button to stop machine.
6. WITHOUT resetting OFF button, press ON button. The machine should not start.
 - If machine does not start, the OFF button safety feature is working correctly.
 - If machine does start (with stop button pushed in), immediately disconnect power to 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.
7. Twist OFF button clockwise so it pops out. When OFF button pops out, switch is reset and ready for operation (see **Figure 21**).

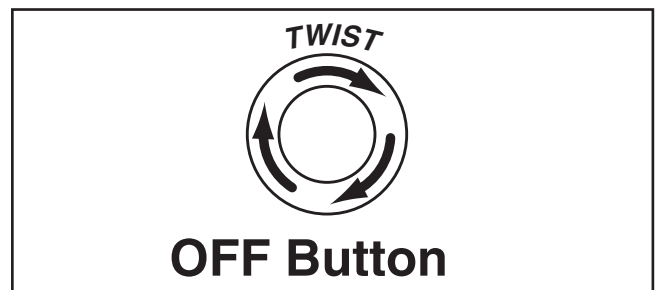


Figure 21. Resetting the switch.

8. Turn switch disabling key to "0", as shown in **Figure 20**.



9. Try to turn machine **ON**.
 - If bandsaw does not start, switch disabling feature is working as designed. Test Run is complete.
 - If 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.

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is required before making many bandsaw adjustments. (Every time you replace the blade, you should perform this procedure because all blades tension differently.)

To tension the bandsaw blade:

1. Complete **Test Run** procedure and make sure blade is tracking properly (see **Page 19**).
2. Raise upper blade guide assembly as high as it will go, and adjust upper and lower guide blocks as far away from blade as possible (see **Adjusting Blade Guide Bearings**).

Note: *This procedure will NOT work if guide blocks have any contact with blade.*

3. Move quick tension lever to tightened position and turn blade tension handwheel until blade tension matches mark on blade tension scale for appropriate blade thickness (See **Figure 12, Page 19**).
4. Turn bandsaw **ON**.
5. Slowly release tension one quarter of a turn at a time. When bandsaw blade starts to flutter, stop decreasing tension.

6. Now, slowly increase tension until blade stops fluttering, then tighten tension another quarter turn.
7. Look at what blade tension scale reads and use that as a guide for tensioning that blade in the future.

Note: *Always release blade tension after use to increase blade life and reduce strain on the bandsaw components.*

8. Re-adjust blade tracking as instructed on **Page 19**.

Adjusting Blade Guide Bearings

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

To adjust upper blade guides:

1. Make sure blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT MACHINE FROM POWER!**



3. Familiarize yourself with blade guide controls shown in **Figures 22 & 23**.

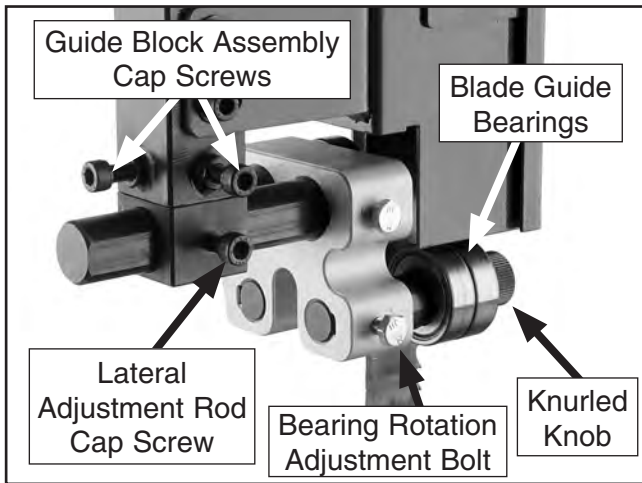


Figure 22. Upper blade guide controls (rear view).

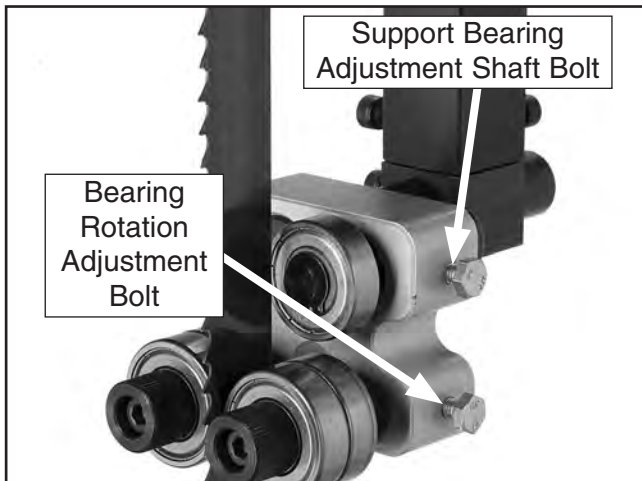


Figure 23. Upper blade guide controls (front view).

4. Loosen lateral adjustment rod cap screw, loosen support bearing adjustment shaft bolt, and adjust blade guides until edges of bearings are $\frac{1}{16}$ " behind blade gullets, as illustrated in **Figure 24**.

Note: The $\frac{1}{16}$ " spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the guide bearings as far forward to the blade gullets as possible, and still maintain the proper support bearing spacing adjustment.

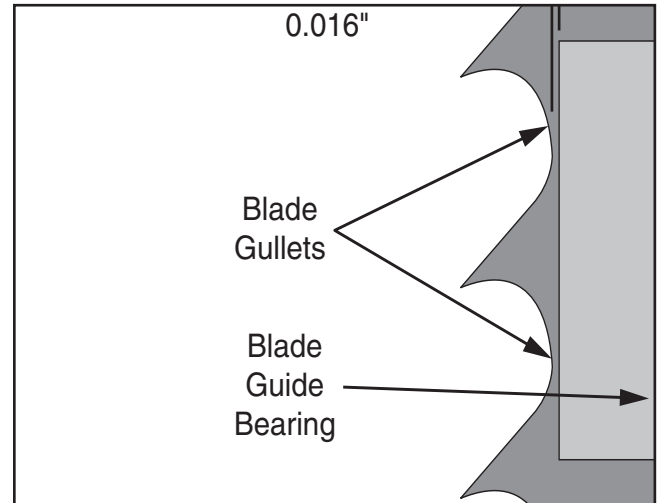


Figure 24. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut or the blade teeth will be ruined.

5. Tighten lateral adjustment rod cap screw.
6. Loosen bearing rotation adjustment bolts on both sides of blade.
7. Rotate knurled knobs to position bearings 0.004" away from blade.

Note: 0.004" is approximately the thickness of a dollar bill.

8. Tighten both bearing rotation adjustment bolts to lock blade guide bearings in position.



NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide bearings must be properly adjusted and locked before cutting operations.

To adjust lower blade guides:

1. Make sure blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT MACHINE FROM POWER!
3. Familiarize yourself with blade guide controls shown in **Figure 25**.

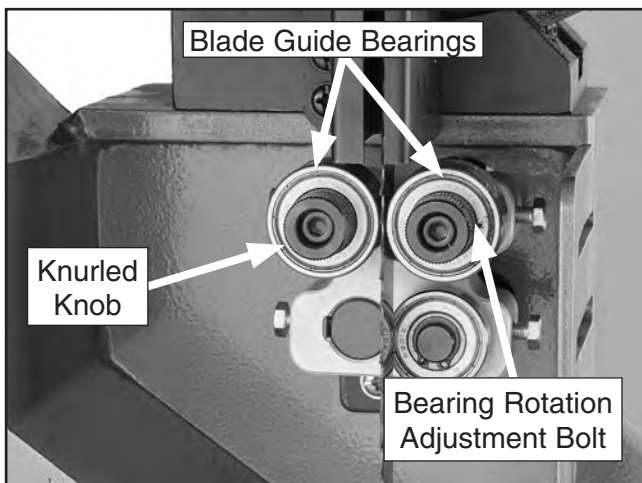


Figure 25. Lower blade guide controls (front view).

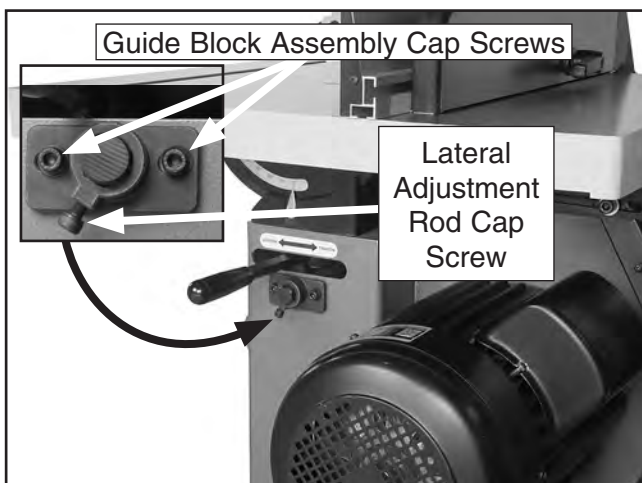


Figure 26. Lower blade guide controls (rear view).

4. Follow procedure for adjusting upper blade guides on **Page 24**.

Note: The lateral adjustment rod cap screw and guide block assembly cap screws are located below the table tilt lock lever (see **Figure 26**).

Adjusting Support Bearings

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and blade guide bearings must be properly adjusted before cutting operations.

The support bearings are positioned behind the blade for support 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.

To adjust upper support bearing:

1. Make sure blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT MACHINE FROM POWER!
3. Familiarize yourself with upper support bearing controls shown in **Figure 22 & 23**.



- Loosen guide block assembly cap screws and rotate blade guide assembly side to side until blade is perpendicular with face of support bearing, as illustrated in **Figure 27**.

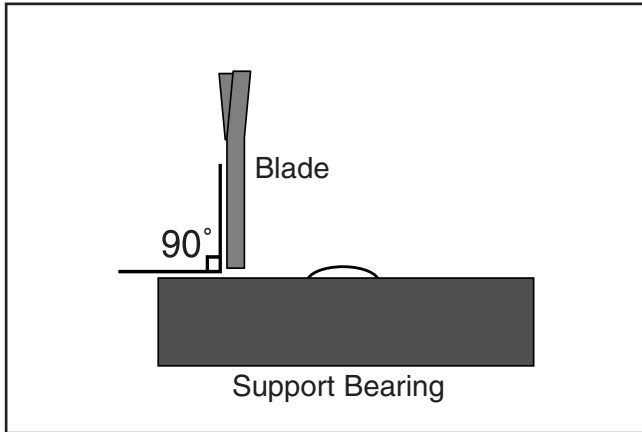


Figure 27. Illustration of blade set perpendicular (90°) to the support bearing face.

- Tighten guide block assembly cap screws.
- Loosen bolt on support bearing adjustment shaft—if it is not already loose.
- Using a feeler gauge between support bearing and blade, position bearing 0.016" away from back of blade, as illustrated in **Figure 28**.

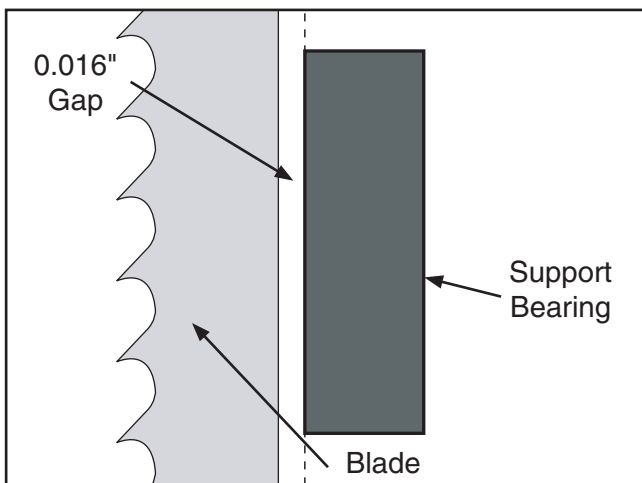


Figure 28. Blade aligned 0.016" away from the bearing edge.

Note: For a quick gauge, fold a crisp dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016") and place it between the support bearing and the blade as shown in **Figure 29**.

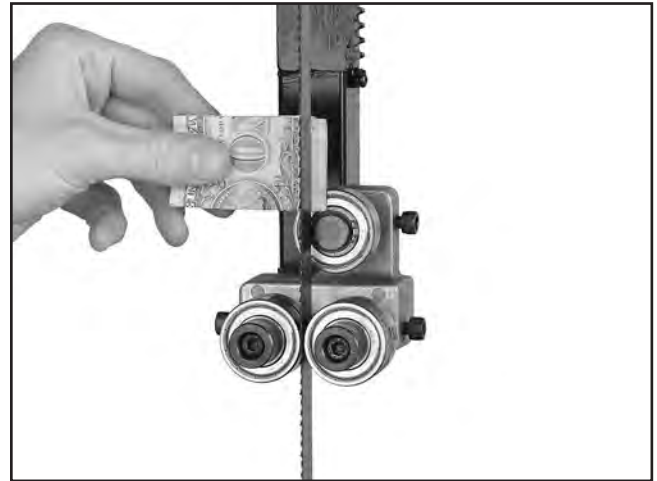


Figure 29. Example of dollar bill folded twice to make an approximate 0.016" gauge.

- Tighten bolt to keep support bearing locked in place.

To adjust lower support bearing:

- Make sure blade is tracking properly and is correctly tensioned.
- DISCONNECT MACHINE FROM POWER!
- Familiarize yourself with lower support bearing controls shown in **Figure 30**.

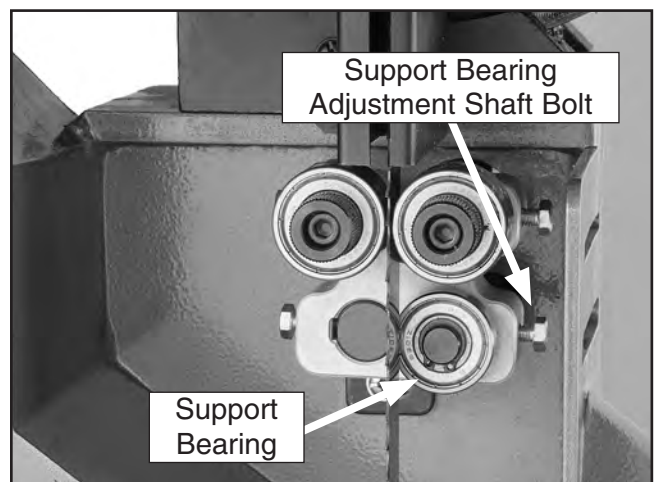


Figure 30. Lower support bearing controls.

- Open upper and lower wheel covers.



5. Make sure blade is perpendicular to face of support bearing, as illustrated in **Figure 27**.

—If blade is perpendicular to face of support bearing, continue on to next step.

—If blade is not perpendicular to support bearing, loosen lateral adjustment rod cap screw and guide block assembly cap screws (see **Figure 26**) and rotate assembly side to side until it is perpendicular to face of support bearing, then re-tighten cap screws.

6. Loosen bolt on support bearing adjustment shaft.
7. Using a feeler gauge, position bearing 0.016" away from back of blade, as illustrated in **Figure 28**, or use a dollar bill, as shown in **Figure 29**.
8. Tighten bolt to keep support bearing locked in place.

Aligning Table

To ensure cutting accuracy, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a 1³/₈" blade installed.

To align the table so the miter slot is parallel to the bandsaw blade:

1. Make sure blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT MACHINE FROM POWER!**
3. Loosen four trunnion cap screws that secure table to trunnions (see **Figure 31**).

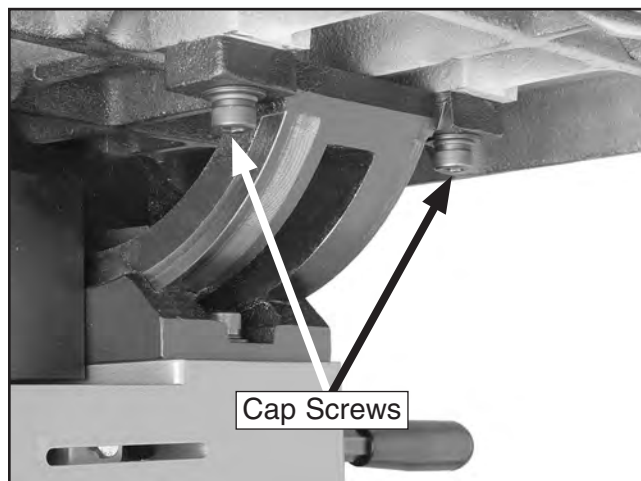


Figure 31. Cap screws securing table to trunnion.

4. Place an accurate straightedge along blade. Straightedge should lightly touch front and back of blade.

Note: Make sure straightedge does not go across a tooth.

5. Use a fine ruler to accurately gauge distance between straightedge and miter slot. The distance you measure should be the same at front and the back of table (see **Figure 32**).
6. Adjust table as needed for proper alignment.
7. Tighten trunnion cap screws when alignment is correct.

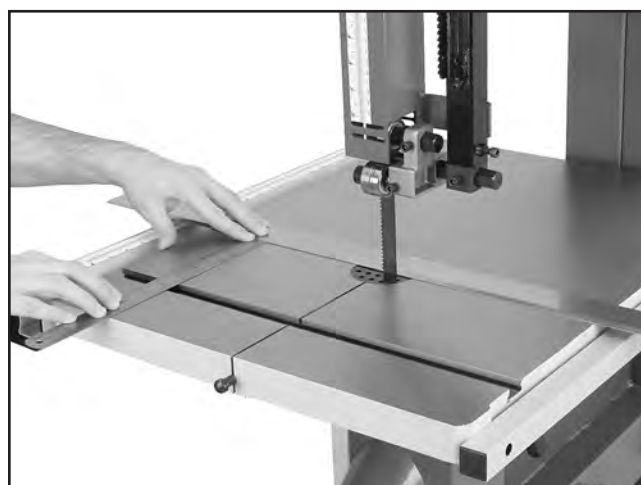


Figure 32. Example of measuring for miter slot to be parallel with blade.



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 **Page 28**).
3. Mount fence next to miter slot, then loosen knobs and cap screw that secure fence rail to table.
4. Adjust fence face parallel with edge of miter slot, as shown in **Figure 33**.



Figure 33. Example of fence square with miter slot.

5. Tighten knobs and cap screw that secure rail to table, being careful not to move 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 "Aligning Table" instructions on Page 28.

Calibrating Miter Gauge

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

To calibrate miter gauge:

1. Place one edge of a machinist's square against face of the miter gauge and other against blade face, as shown in **Figure 34**.

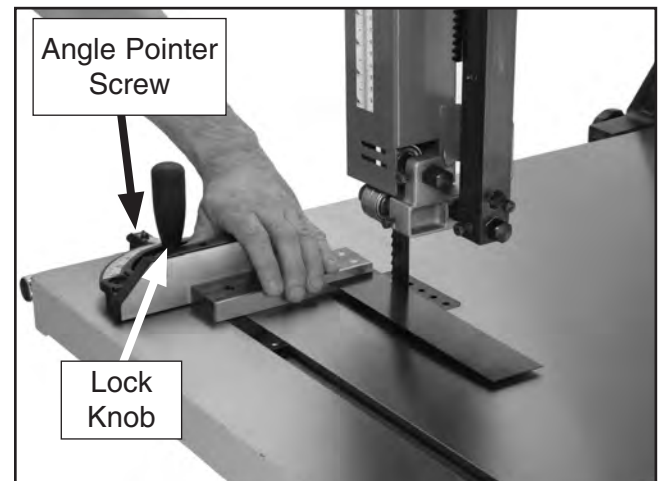


Figure 34. Example of squaring miter gauge to blade.

2. Loosen lock knob on miter gauge and adjust gauge flush with edge of square.
3. Tighten lock knob, and verify setting.

Note: Sometimes tightening procedure can affect adjustment.

4. Loosen screw that secures angle pointer and adjust pointer to 0° mark on scale.
5. Retighten screw that secures angle pointer.



Calibrating Pointer

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.

To calibrate pointer:

1. If fence is mounted on right-hand side of blade, remove it and re-install it on left-hand side of blade.
2. Place fence flush against bandsaw blade (see **Figure 35**).



Figure 35. Example of fence flush with blade.

3. Loosen pointer adjustment screw (see **Figure 36**) and set pointer in line with "0" and measurement scale on table.

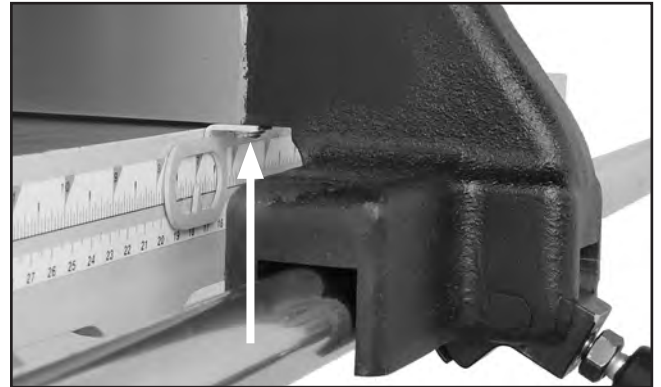


Figure 36. Location of fence pointer adjustment screw.

4. Tighten pointer adjustment nut.

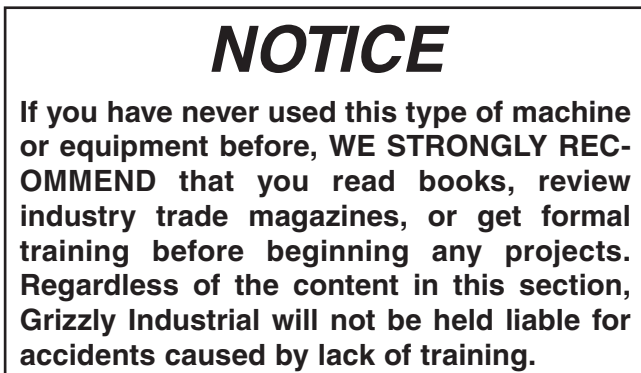
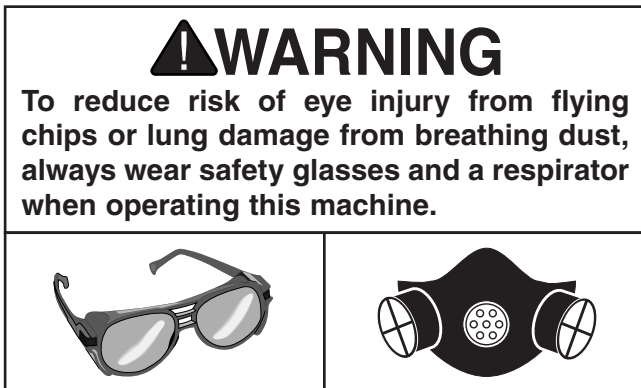


SECTION 4: OPERATIONS

Operation Overview

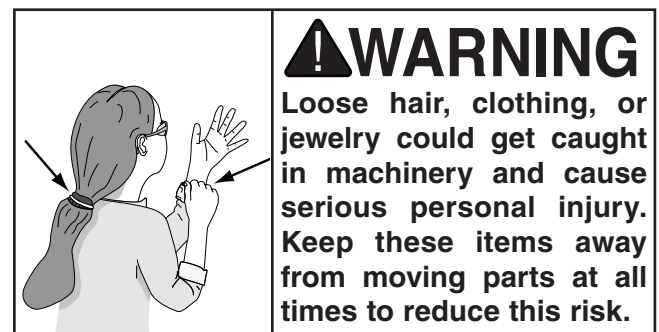
The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



To complete a typical operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for cutting.
 2. Adjusts fence away from blade the same width of desired cut and then locks it in place.
 3. Adjusts table tilt, if necessary, to correct angle of desired cut.
 4. Adjusts blade guide height to approximately 1" from top of workpiece.
 5. Checks to make sure workpiece can safely pass all the way through the blade without interference from other objects.
 6. Puts on safety glasses.
 7. Starts dust collector and bandsaw.
 8. Holds workpiece firmly and flatly against table and fence, and then pushes workpiece into blade at a steady and controlled rate until workpiece moves completely beyond blade.
- Note:** The operator is very careful to keep fingers away from blade and uses a push stick to feed narrow workpieces.
9. Stops bandsaw and removes workpiece when blade is completely stopped.



Basic Functions of a Bandsaw

A properly adjusted bandsaw can be safer to operate than most other saws and performs many types of cuts with ease and accuracy. It is capable of performing the following types of cuts:

Straight Cuts

- Mitters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades often for best performance. Check guides, tension, and alignment settings periodically and adjust when necessary to keep the saw running in top condition.
- Use light and even pressure while cutting. Light feeding pressure makes it easier to cut straight and prevents undue friction or strain on the bandsaw components and the blade.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw its way around the corners. Always use relief cuts when possible.
- Misusing the saw or using incorrect techniques (e.g. twisting the blade with the workpiece, incorrect feed rate, etc.) is unsafe and results in poor cuts.

Workpiece Inspection

Some workpieces are not safe to cut or may require modification before they are safe to cut.

Before cutting, inspect all workpieces for the following:

- **Material Type:** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a bandsaw may lead to injury.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- **Wet or "Green" Stock:** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!
- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.



Foot Brake

The Model G0636X is equipped with a foot brake (see **Figure 37**). Use the brake only in emergency situations to stop power from going 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.

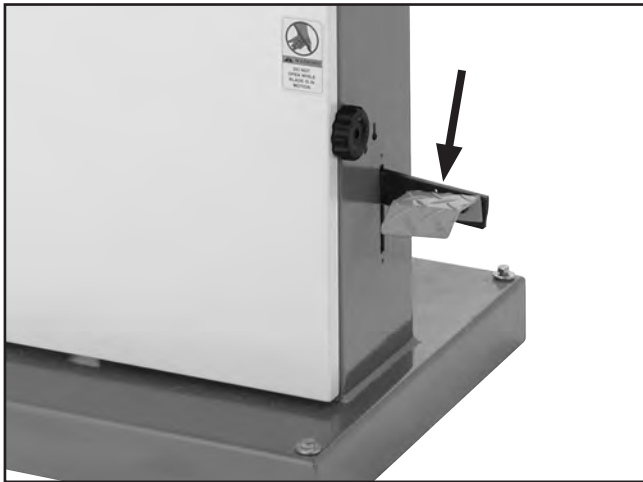
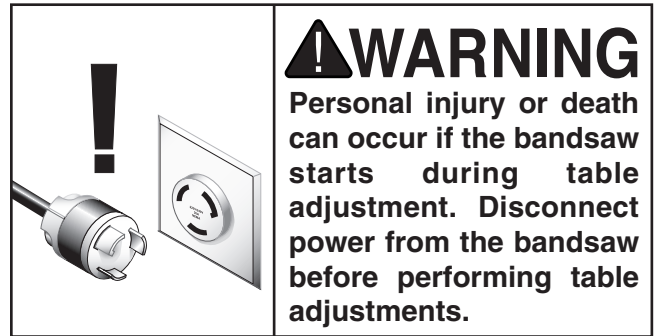


Figure 37. Foot brake location.

Table Tilt



The bandsaw table will tilt 5° left and 45° right to provide a wide range of cutting options.

To tilt table:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen table tilt lock lever shown in **Figure 38**.
3. To tilt table to the right, turn table tilt handwheel clockwise (see **Figure 38**).

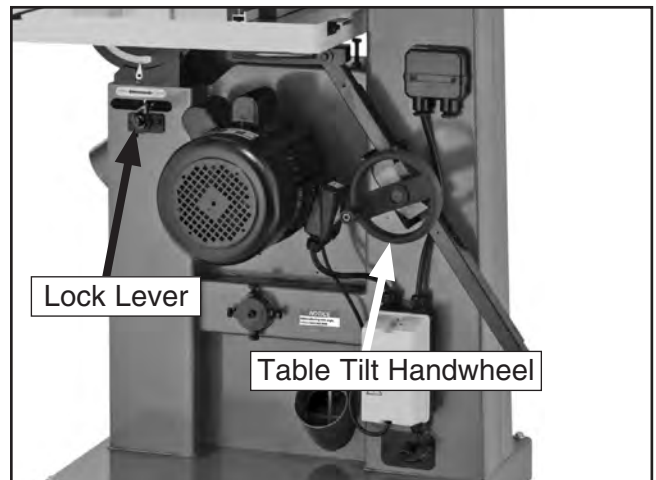


Figure 38. Table tilt controls.

4. To tilt table to the left, turn table tilt handwheel clockwise one turn, lower positive stop bolt, then turn handwheel counterclockwise.
5. Secure table tilt lock lever.
6. Follow "Positive Stop" instructions on **Page 20** for resetting stop bolt and table for horizontal (0°) operations.



Guide Post

The guide post, shown in **Figure 39**, connects the upper blade guide assembly to the bandsaw. The guide post allows the blade guide assembly to move up or down via a rack and pinion. In order to cut accurately, the blade guide assembly must be no more than 1" from the top of the workpiece at all times—this positioning provides the best support for the blade.

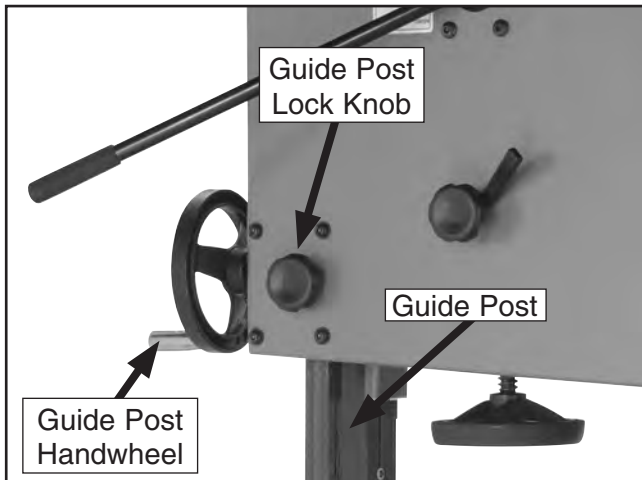


Figure 39. Guide post controls.

To adjust guide post:

1. Make sure blade tension, blade tracking, support bearings, and blade guides are adjusted correctly.
2. Loosen guide post lock knob shown in **Figure 39**.
3. Turn guide post handwheel to raise or lower guide post until upper blade guide assembly is within 1" from top of workpiece.
4. Lock guide post in place with lock knob.

Fine Tune Tracking

NOTICE

Adjusting the final blade tracking setting requires the machine to be turned *ON*.

To fine tune tracking:

1. Close wheel covers and turn bandsaw **ON**.
2. Observe blade tracking path through clear window on right edge of bandsaw, as shown in **Figure 40**.

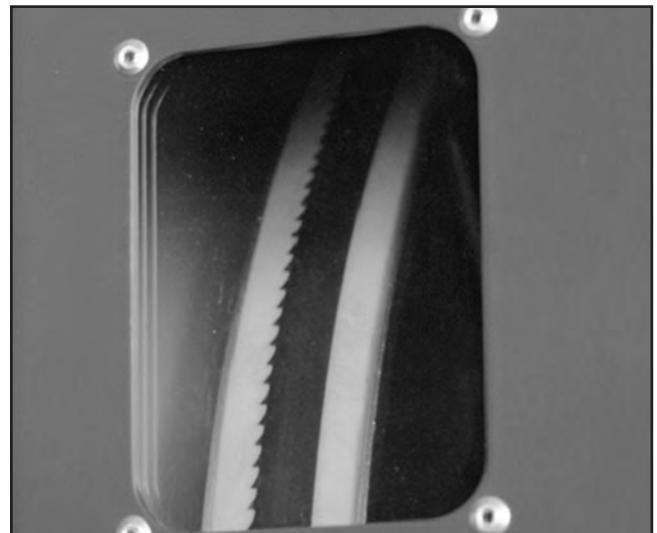


Figure 40. Blade tracking window.

3. Using tracking controls (**Page 20, Figure 14**), adjust blade so it tracks on the center of the wheel.
4. Tighten the lock lever so the tracking knob cannot move.



Blade Lead

Bandsaw blades commonly wander off the cut line when sawing, as shown in **Figure 41**. This is called blade lead. Blade lead is commonly caused by too fast of a feed rate, a dull or abused blade, or improper tension. If your blade is sharp/undamaged and you still have blade lead, perform the following instructions.

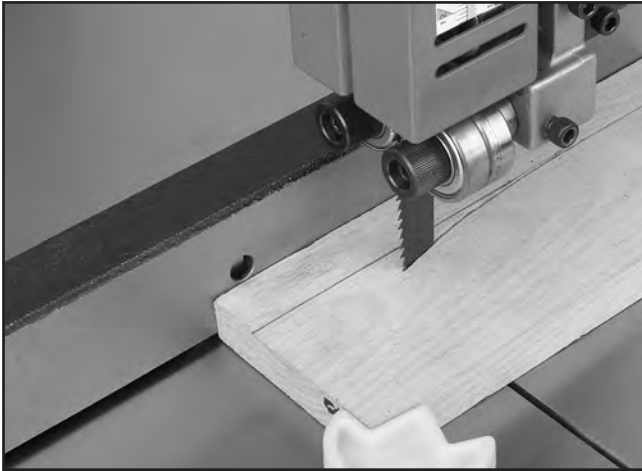


Figure 41. Example of blade leading away from line of cut.

To correct blade lead:

1. Use less pressure when feeding workpiece through cut.
2. Check that miter slot or fence is parallel to blade line, and correct if necessary (See **Aligning Table, Page 28** and **Aligning Fence, Page 29**).
3. Check for proper blade tension. If blade tension is correct and it is not convenient to replace blade, compensate for lead by skewing fence or adjusting table.

To skew fence:

1. Cut a piece of scrap wood approximately $\frac{3}{4}$ " thick x 3" wide x 17" long. On a wide face of the board, draw a straight line parallel to long edge.

2. Slide bandsaw fence out of the way and cut halfway through board on line by pushing it into blade. Turn bandsaw **OFF** and wait for blade to stop.
3. Clamp board to bandsaw table without moving it. Now slide fence over to board so it barely touches one end of board.
4. Loosen two cap screws that secure fence rail to underside of table (see **Page 29**).
5. Skew fence so it is parallel to edge of scrap piece.
6. While maintaining skew, tighten cap screws loosened in **Step 4**.
7. Make a few cuts using fence. If fence still does not seem parallel to blade, repeat **Steps 1–6** until blade and fence are parallel with each other.

To shift table:

1. On a scrap piece of wood, mark a line that is perpendicular to front edge.
2. Cut halfway through board on line by pushing it into blade.
3. Turn bandsaw **OFF** and wait for blade to stop.
4. Using an 8mm hex wrench, loosen four cap screws that mount table to trunnion (see **Figure 31**). Shift table to compensate for blade lead, then retighten cap screws.
5. Repeat **Steps 1–4** until blade cuts straight.



Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece. For ripping, a wider blade is better. In most ripping applications, a standard raker tooth style will be sufficient.

To make a rip cut:

1. Adjust fence to match width of cut on workpiece and lock fence in place.
2. Adjust blade guide assembly to correct height.
3. After all safety precautions have been met, turn bandsaw **ON**. Slowly feed workpiece into blade and continue with cut until blade is completely through workpiece. **Figure 42** shows a typical ripping operation. **Note:** *If you are cutting narrow pieces, use a push stick to protect your fingers.*

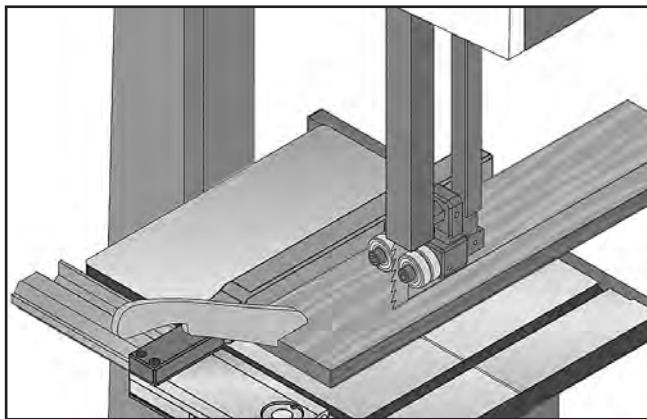


Figure 42. Example of typical ripping operation with a push stick.

⚠WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may slip into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!

Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To make a 90° crosscut:

1. Mark workpiece on edge where you want to begin cut.
2. Adjust blade guide assembly to correct height and make sure miter gauge is set to 0°.
3. Move fence out of the way. Place workpiece evenly against miter gauge.
4. Hold workpiece against miter gauge and line up mark with blade.
5. After all safety precautions have been met, turn bandsaw **ON**. Slowly feed workpiece into blade and continue cut until blade is all the way through workpiece. **Figure 43** shows a typical crosscutting operation.

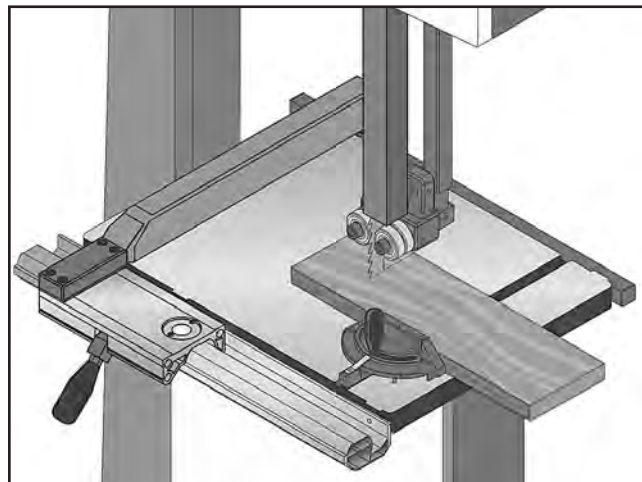


Figure 43. Example of crosscutting operation with miter gauge.



Resawing

Resawing (see **Figure 44**) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

One of the most important considerations when resawing is blade selection. Generally, wider blades are better. In most applications, a hook or a skip tooth style will be desirable. Choose blades with fewer teeth-per-inch (from 3 to 6), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.

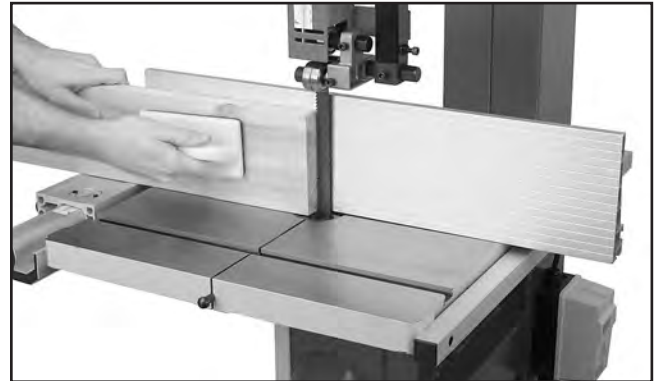


Figure 44. Example of resawing lumber.

!WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the surface of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep hands clear of blade.

To resaw a workpiece:

1. Verify bandsaw is set up properly and that fence is parallel to blade.
2. Adjust upper blade guide so it is about 1" above workpiece with a minimum amount of blade exposed.
3. Install resaw fence, set it to desired width of cut, and lock it in place.

NOTICE

The scale on the front rail will NOT be accurate when using the resaw fence.

4. Support ends of board if necessary.
5. Turn bandsaw **ON**.
6. Using push paddles and a push stick, keep pressure against fence and table, and slowly feed workpiece into moving blade until blade is completely through workpiece (see **Figure 44**).

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without twisting. 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 TPI (teeth per inch), or make more relief cuts.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

Width	Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"



Stacked Cuts

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° (see **Page 20**). Otherwise, any error will be compounded.

To complete a stacked cut:

1. Align pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all pieces together in a manner that will not interfere with the cutting. Hot glue on edges works well, as do brad nails through waste portion. (Be careful not to cut into brads or you may break the blade!)
3. On face of top piece, lay out shape you intend to cut.
4. Make relief cuts perpendicular to outline of intended shape in areas where changes in blade direction could strain woodgrain or cause blade kerf to bind.
5. Cut stack of pieces as though cutting a single piece. Follow layout line with blade kerf on waste side of line, as shown in **Figure 45**.

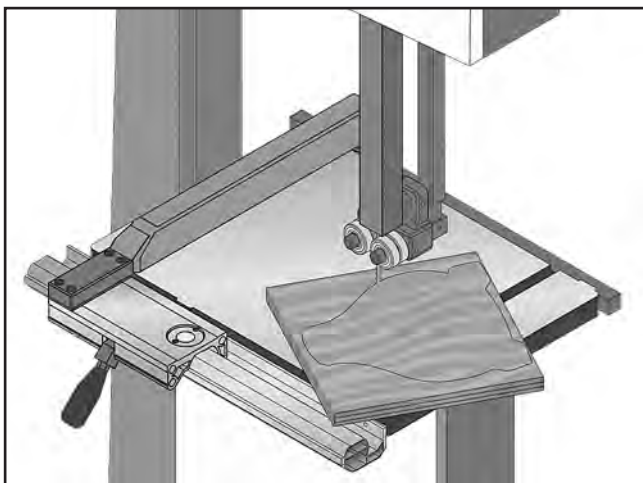


Figure 45. Typical stacked cut.

Blade Information

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0636X is designed for blades that are 160" long. Refer to **Page 41** for blade replacements.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. 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 G0636X can use blades from 1/8" to 1 3/8" in width. Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 46** 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.

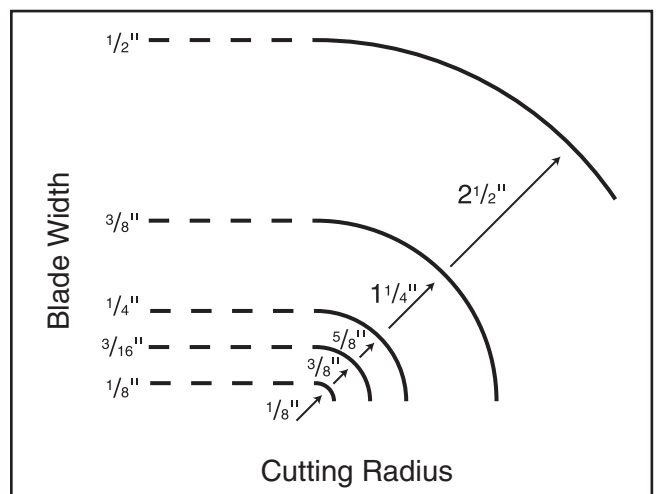


Figure 46. Blade width radii.



- **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.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as “Tooth Style.” **Figure 47** shows the three main categories of tooth style:

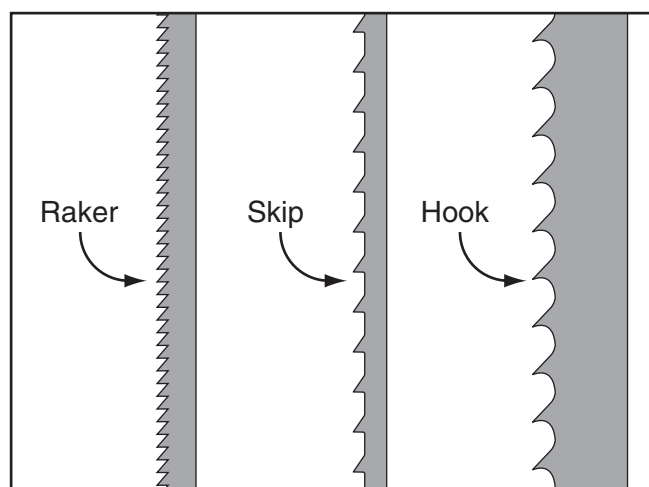


Figure 47. Raker, Skip & Hook tooth styles.

- **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 do not cut fast and generate more heat while cutting.
- **Skip:** This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.

- **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 TPI (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 obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

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

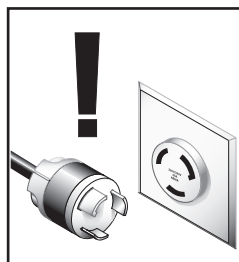
Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care 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:

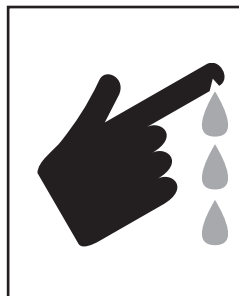
- Faulty alignment and adjustment of the guides.
- Forcing or twisting a wide blade around a curve of short radius.
- Feeding the workpiece into the blade too fast.
- Tooth dullness or absence of sufficient set.
- Incorrect tension.
- Top blade guide assembly set too high above the workpiece.
- Using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

Changing Blade



! WARNING

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.



! CAUTION

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

To remove a blade:

1. DISCONNECT MACHINE FROM POWER!
2. Release blade tension.

3. Remove table insert and table pin. Adjust upper and lower guide bearings as far away as possible from blade.
4. Open upper and lower wheel covers, and with gloved hands, slide blade off of both wheels.
5. Slide blade through slot in table.

To replace a blade:

1. Slide blade through table slot, ensuring that teeth are pointing forward and down toward table. **Note:** *If teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove blade, and twist it right side-out.*
2. Slip blade through guides, and mount it on upper and lower wheels (see **Figure 48**).

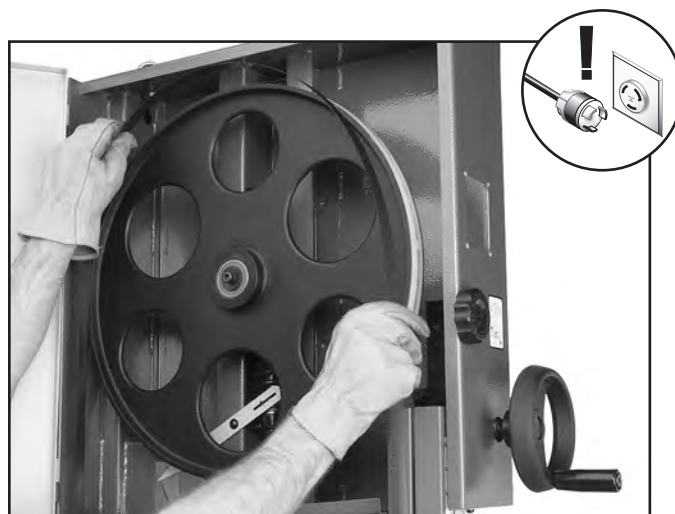


Figure 48. Typical example of placing blade on the wheels.

3. Adjust tension as described on **Page 24**.
4. Adjust tracking if needed (see **Page 19**).
5. Adjust upper/lower guide bearings and support bearings (see **Page 24**).
6. Replace table insert and table pin.
7. Close wheel covers.



SECTION 5: ACCESSORIES

⚠️ WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Replacement Blades

These replacement blades are milled for exact tooth set and are made with high quality tool steel.

160" Carbon Steel Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
H8416	3/16"	4 SKIP
H8417	3/16"	10 RAKER
H8418	3/16"	14 RAKER
H8419	1/4"	4 HOOK
H8420	1/4"	6 HOOK
H8429	1/2"	4 HOOK
H8476	1"	6 HOOK

160" Timber Wolf® Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
T20201	1/4"	4 POS. CLAW
T20202	1/4"	6 POS. CLAW
T20208	3/8"	6 POS. CLAW
T20209	3/8"	10 RAKER
T20211	1/2"	3 POS. CLAW
T20212	1/2"	4 POS. CLAW
T20214	1/2"	10 RAKER
T20215	1/2"	18 RAKER

162" Carbon Steel Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
H4819	3/8"	6 HOOK
H4820	3/8"	10 RAKER
H4821	1/2"	4 HOOK
H4822	1/2"	6 HOOK
H4823	3/4"	3 HOOK
H4824	1"	6 HOOK
H4825	1"	2 HOOK

162" Timber Wolf® Replacement Blades for the Model G0636X.

MODEL	WIDTH	TPI
H9567	1/2"	3 POS. CLAW
H9568	1/2"	4 POS. CLAW
H9569	1/2"	6 POS. CLAW
H9570	1/2"	10 RAKER
H9571	1"	3 POS. CLAW
H9572	1"	4 POS. CLAW
H9573	1"	10 RAKER
H9574	1 1/4"	3/4" PITCH

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.

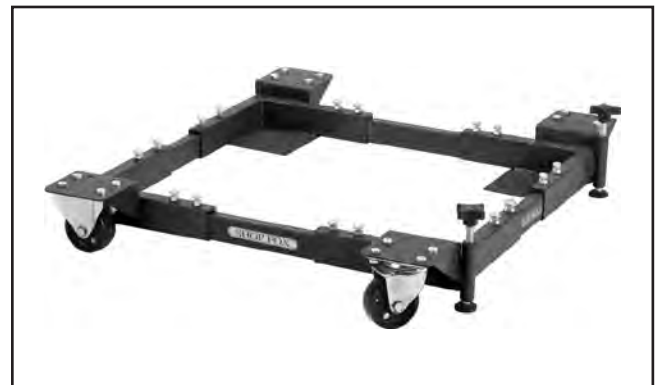


Figure 49. D2058A Shop Fox Mobile Base.

order online at www.grizzly.com or call 1-800-523-4777



Basic Eye Protection

- T20501—Face Shield Crown Protector 4"
- T20502—Face Shield Crown Protector 7"
- T20503—Face Shield Window
- T20451—"Kirova" Clear Safety Glasses
- T20452—"Kirova" Anti-Reflective S. Glasses
- T20456—DAKURA Safety Glasses, Black/Clear



Figure 50. Eye protection assortment.

- G5562—SLIPIT® 1 Qt. Gel
- G5563—SLIPIT® 12 Oz. Spray
- G2871—Boeshield® T-9 12 Oz. Spray
- G2870—Boeshield® T-9 4 Oz. Spray
- H3788—G96® Gun Treatment 12 Oz. Spray
- H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 51. Recommended products for protecting unpainted cast iron/steel on machinery.

- H2499—Small Half-Mask Respirator
- H3631—Medium Half-Mask Respirator
- H3632—Large Half-Mask Respirator
- H3635—Cartridge Filter Pair P100

Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 52. Half-mask respirator with disposable cartridge filters.

- G0862—3 HP Portable Cyclone Dust Collector
- The capstone of our new line of affordable, high-quality cyclones, the G0862 features a 3 HP motor, a whopping 1941 CFM of airflow capacity, and a 55-gallon collection capacity.



Figure 53. Model G0862 3 HP Portable Cyclone Dust Collector.

order online at www.grizzly.com or call 1-800-523-4777



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Worn or damaged saw blade.
- Worn or damaged wires.
- Check/clean wheel brushes.
- Clean/protect table surface.
- Check lubrication points.
- Any other unsafe condition.

Monthly Check

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning & Protecting

Cleaning the Model G0636X 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.

Protect the unpainted cast iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 42** for more details).

Brushes

The bandsaw is equipped with three lower brushes. The brushes should be checked daily and cleaned when they become dirty. There are adjustment brackets that allow the brushes to be adjusted for bristle wear. Refer to **Adjusting Brushes** on **Page 50** for adjustment details.

Lubrication

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.



Blade Guide Rack & Pinion

1. DISCONNECT MACHINE FROM POWER!
2. Lower blade guide until it reaches table.
3. Wipe off existing grease and sawdust buildup on rack (see **Figure 54**).

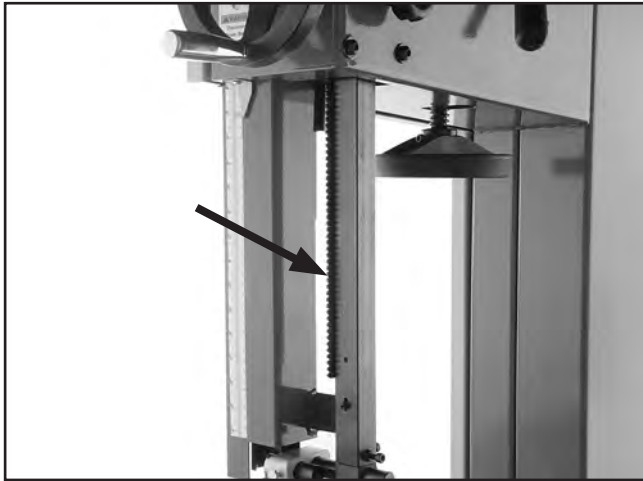


Figure 54. Rack lubrication location.

4. Apply a thin coat of light all-purpose grease to rack.
5. Move blade guide up and down several times and remove any excess grease to help prevent sawdust buildup.

Blade Tracking Knob

1. DISCONNECT MACHINE FROM POWER!
2. Unscrew blade tracking knob 5 turns.
3. Wipe off any existing grease and sawdust buildup on threads.
4. Apply a few dabs of a light all-purpose grease to threads.
5. Re-adjust tracking (see **Blade Tracking** on **Page 19**).

Tension Adjustment Assembly

1. DISCONNECT MACHINE FROM POWER!
2. Open top wheel cover and look through top of wheel.
3. Wipe off any existing grease and sawdust buildup on blade tension adjustment assembly and tension lever cam.
4. Apply a thin coat of grease to tension adjustment assembly and tension lever cam (see **Figure 55**).



Figure 55. Tension adjustment assembly locations (top wheel removed for clarity).



Table Tilt Rack & Pinion Assembly

1. DISCONNECT MACHINE FROM POWER!
2. With table perpendicular to blade, wipe off all existing grease and sawdust buildup from rack.
3. Move table up to its maximum 45° angle and wipe (see **Figure 56**) off all existing grease and sawdust buildup from rack.

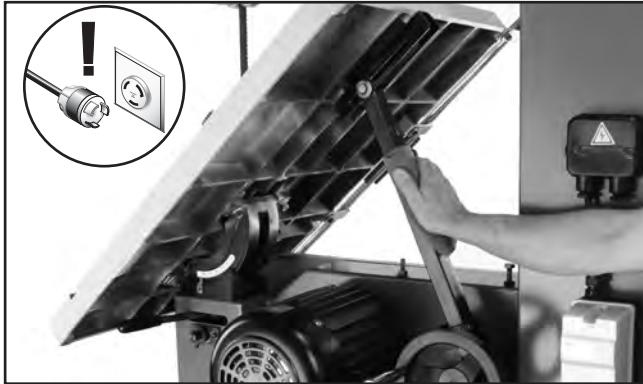


Figure 56. Table tilt rack and pinion assembly.

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

Trunnions

1. DISCONNECT MACHINE FROM POWER!
2. Move table up until it reaches its maximum 45° angle and wipe off all excess grease and sawdust from trunnions.
3. Apply a thin coat of light all-purpose grease to trunnions (see **Figure 57**).

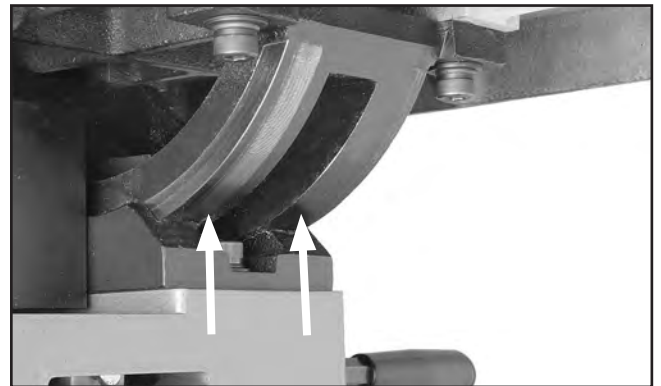


Figure 57. Trunnion lubrication location.

4. Move table down and then back up to distribute grease, then wipe off any excess grease from trunnions.



SECTION 7: SERVICE

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support. **Note:** *Please gather the serial number and manufacture date of your machine before calling.*

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Power switch key is turned to "0". 2. Stop/reset button engaged. 3. Plug/receptacle is at fault or wired incorrectly. 4. Motor connection wired incorrectly. 5. Thermal protection circuit breaker amperage is set too low or motor is at fault. 6. Power supply is at fault/switched OFF. 7. Motor ON/OFF switch is at fault. 8. Wiring is open/has high resistance. 9. Start capacitor is at fault. 10. Motor is at fault. 11. Wheel cover limit switch is not closed, wheel covers are open. 12. Foot brake limit switch is at fault or is pressed down (switch is not closed). 	<ol style="list-style-type: none"> 1. Turn power switch key to "1". 2. Rotate clockwise until it pops out/replace. 3. Test for good contact or correct the wiring. 4. Correct motor wiring connections (Page 57). 5. Unplug machine, open magnetic switch cover, turn amperage dial on Thermal Protection Circuit Breaker to a higher amperage setting. If switch is maxed out, replace motor. 6. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 7. Replace faulty ON/OFF switch. 8. Check for broken wires or corroded/disconnected connections, and repair/replace as necessary. 9. Test/replace if faulty. 10. Repair/replace. 11. Close wheel covers. 12. Repair/replace limit switch, or stop pressing foot brake.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Motor run capacitor at fault. 2. Wrong workpiece material. 3. Feed speed too fast for task. 4. V-belt slipping. 5. Blade is slipping on wheels. 6. Low power supply voltage. 7. Plug/receptacle is at fault. 8. Motor connection is wired incorrectly. 9. Motor bearings are at fault. 10. Motor has overheated. 11. Motor is at fault. 	<ol style="list-style-type: none"> 1. Replace run capacitor. 2. Use wood with correct moisture content, without glues, and little pitch/resins. 3. Decrease feed speed. See Basic Cutting Tips on Page 32. 4. Replace bad V-belt, align pulleys, and re-tension (Page 48 & 49). 5. Adjust blade tracking and tension to factory specifications. See Page 19 or 24. 6. Ensure all hot lines have correct voltage on all legs. 7. Test for good contacts and correct wiring. 8. Correct motor wiring connections (Page 57). 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 10. Let motor cool, clean it off, and reduce workload. 11. Repair/replace.



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation when running.	<ol style="list-style-type: none"> 1. Blade weld hits guides or teeth are broken. 2. Bent or worn out blade. 3. Motor or component is loose. 4. V-belt worn or loose. 5. Motor fan is rubbing on fan cover. 6. Pulley is loose. 7. Machine is incorrectly mounted or sits unevenly on floor. 8. Motor bearings are at fault. 9. Worn arbor bearings. 10. Wheels not coplanar/aligned correctly. 11. Wheels out of balance. 	<ol style="list-style-type: none"> 1. Replace blade (Page 40). 2. Replace blade (Page 40). 3. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 4. Inspect/replace belts with matched set (Page 49). 5. Replace dented fan cover and loose/damaged fan. 6. Realign/replace shaft, pulley, setscrew, and key as required. 7. Adjust the feet on the bottom of the stand; relocate machine. 8. Test by rotating shaft—rotational grinding/loose shaft requires bearing replacement. 9. Check/replace arbor bearings. 10. Adjust wheel alignment to coplaner (Page 50). 11. Replace wheels.

Cutting Operations

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. Blade is dull. 	<ol style="list-style-type: none"> 1. Reduce feed rate. See Basic Cutting Tips on Page 32. 2. Replace blade (Page 40).
Ticking sound when the saw is running.	<ol style="list-style-type: none"> 1. Blade weld contacting support bearing. 2. Blade weld may be failing. 	<ol style="list-style-type: none"> 1. Use file or stone to smooth and round the back of the blade. 2. Inspect and replace blade if necessary (Page 40).
Blade contacting table insert.	<ol style="list-style-type: none"> 1. Excessive side pressure when cutting. 2. Table improperly adjusted. 	<ol style="list-style-type: none"> 1. Reduce side pressure. 2. Adjust table (Page 28).
Vibration when cutting.	<ol style="list-style-type: none"> 1. Loose or damaged blade. 2. Blade is tracking incorrectly. 3. Blade tension is loose. 	<ol style="list-style-type: none"> 1. Tighten or replace blade. See Page 40 or 24. 2. Fix blade tracking (Page 19). 3. Fix blade tension (Page 24).
Burn marks on the edge of the cut.	<ol style="list-style-type: none"> 1. Too much side pressure when feeding workpiece. 2. Blade too wide for size of radius being cut. 	<ol style="list-style-type: none"> 1. Feed workpiece straight into the blade. See Basic Cutting Tips on Page 32. 2. Install a smaller width blade/increase blade tension. See Page 24 or 40.
Rough or poor quality cuts.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. Tracking and tension incorrect. 	<ol style="list-style-type: none"> 1. Reduce feed rate. See Basic Cutting Tips on Page 32. 2. Fix tracking and tension (see Page 19 and 24).
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean out dust port. 2. Three options: <ul style="list-style-type: none"> —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a stronger dust collector.
Blade wanders or won't follow line of cut.	<ol style="list-style-type: none"> 1. Blade lead. 	<ol style="list-style-type: none"> 1. Refer to Blade Lead on Page 35.



Checking and Tensioning V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition and operate under proper tension. 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.

Tools Needed:	Qty
Ruler	1
Hex Wrench 6mm.....	1
Wrench 17mm.....	1

To check V-belts:

1. DISCONNECT MACHINE FROM POWER!
2. Open wheel covers.
3. Note condition of V-belt. If V-belts are cracked, frayed, or glazed; they should be replaced.
4. Push center of V-belts. Note amount of deflection (see **Figure 58**). If deflection is more than $\frac{3}{4}$ ", tension V-belts.

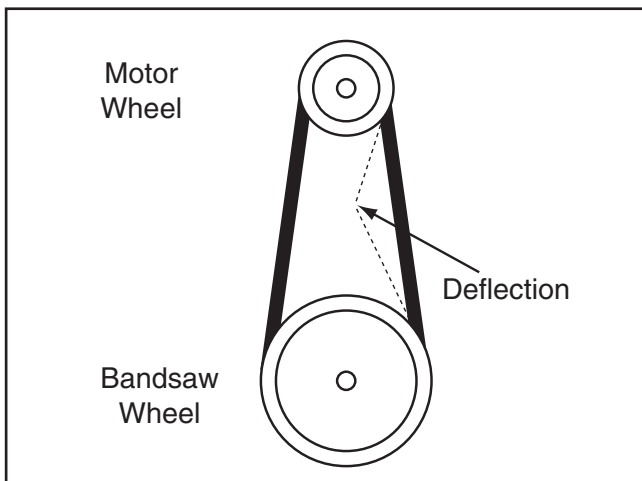


Figure 58. V-belt deflection.

To tension V-belt:

1. DISCONNECT MACHINE FROM POWER!
2. Open wheel covers.
3. Loosen motor adjustment bolts shown in **Figure 59**.

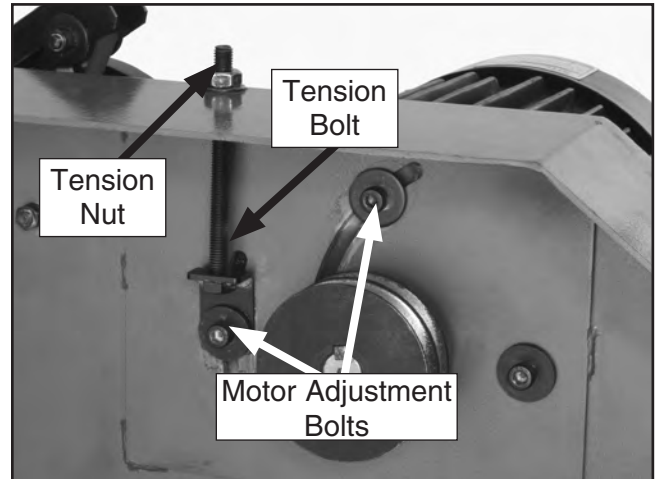


Figure 59. Motor mount bolts and tension bolt.

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



Replacing V-Belts

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

To replace V-belts:

1. DISCONNECT MACHINE FROM POWER!
2. Open wheel covers and remove bandsaw blade (see **Page 40**).
3. Loosen motor adjustment bolts and tension nut shown in **Figure 59**, then turn tension bolt counterclockwise.
4. Unthread wheel cap screw shown in **Figure 60** and slide lower wheel off of bearing shaft.

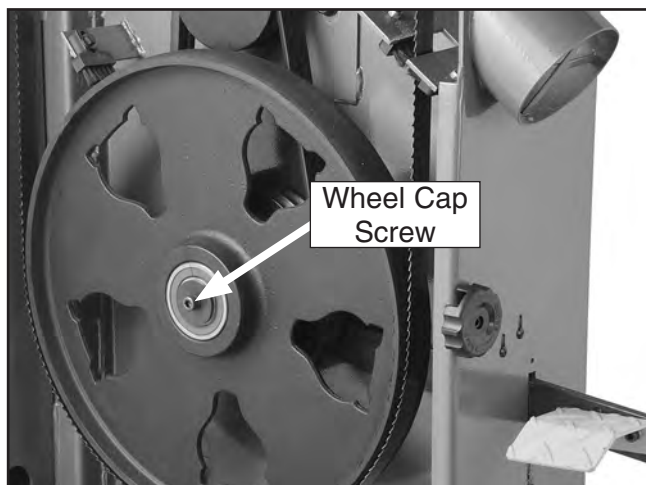


Figure 60. Wheel cap screw for removing the wheel.

5. Slip old V-belts off of pulleys and install new V-belt set in their place.
6. Install lower wheel back onto bearing shaft, tighten wheel mount cap screw, and tension V-beltS (see **Page 48**).
7. Close lower wheel cover.

Adjusting Tension Lever

The tension lever has an adjustment screw that allows you to adjust how much tension is released when the lever is used.

Tools Needed:	Qty
Wrench 13mm	1

To adjust tension lever:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen adjustment screw 5–10 turns.
3. Move tension lever to tightened position and tension blade.
4. Turn adjustment screw shown in **Figure 61** until gap between screw and wheel shaft hinge is $\frac{1}{16}$ "– $\frac{3}{16}$ ".

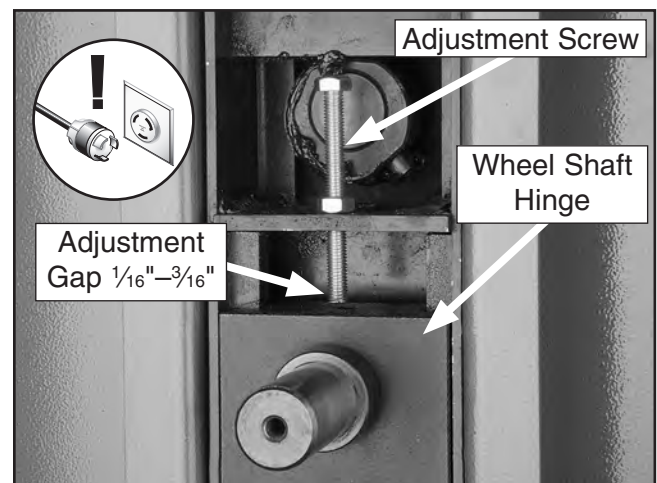


Figure 61. Tension lever adjustment components (top wheel removed for clarity).

5. Engage tension lever and test blade tension.
6. Repeat **Steps 1–5** until tension lever adds right amount of tension to blade when it is engaged.



Adjusting Wheel and Blade Brushes

The lower wheel compartment contains the brushes shown in **Figure 62**. These brushes are designed to sweep sawdust off the wheel tire and blade as the bandsaw is operating. In order to work properly, the brushes must be making contact with the wheel and blade.

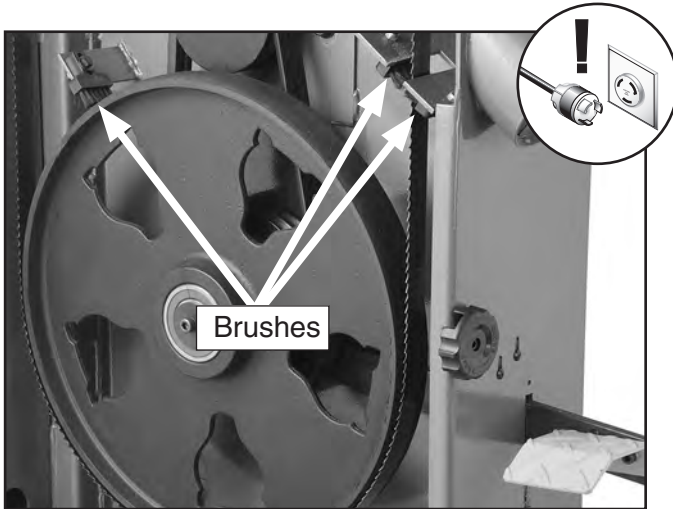


Figure 62. The wheel brush.

Tools Needed: Qty
Wrench/Socket 10mm2

To adjust brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Open lower wheel cover.
3. Loosen bolt/nut that secures each brush in place.
4. Adjust each brush so it makes good contact with wheel or blade—without bending bristles.
5. Tighten bolt/nuts to secure each brush in place.

Aligning Wheels

Components and Hardware Needed: Qty
70" Long Wood 2x4 1

Tools Needed:

Wrench 17mm..... 1
Tape Measure..... 1
Coplanarity Gauge (see **Figure 63**) 1

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.

To check if your wheels are coplanar (Checking coplanarity):

1. Make "Coplanarity Gauge" shown in **Figure 63** on **Page 51**.

Note: For best results, straighten 2x4 with a jointer before cutting.

2. Remove fence and open both wheel covers.
3. Adjust blade guides away from blade, loosen blade tension, remove table insert and pin, and remove blade.
4. Remove four trunnion cap screws and table.
5. Re-install blade (see **Page 40**), making sure guide bearings and support bearings are away from blade, then tighten blade to tension that it will be used during operation.



- Place your coplanarity gauge up against both wheels in the positions shown in **Figure 64**.

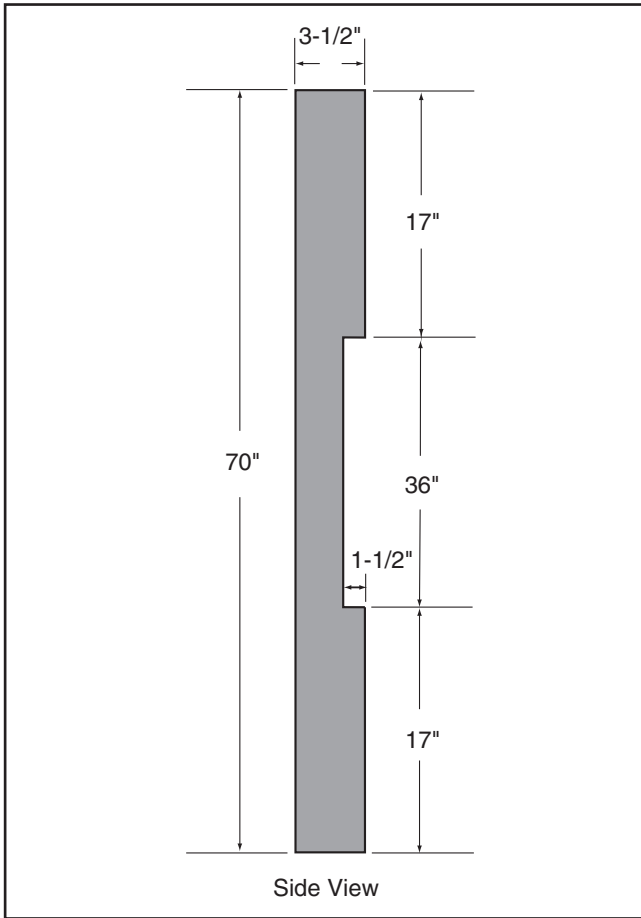


Figure 63. Dimensions of coplanarity gauge.

- Adjust tracking knob to get both wheels parallel. If wheels won't go parallel to each other, then move lower wheel at adjustment hub (see **Figure 65**) so they line up.

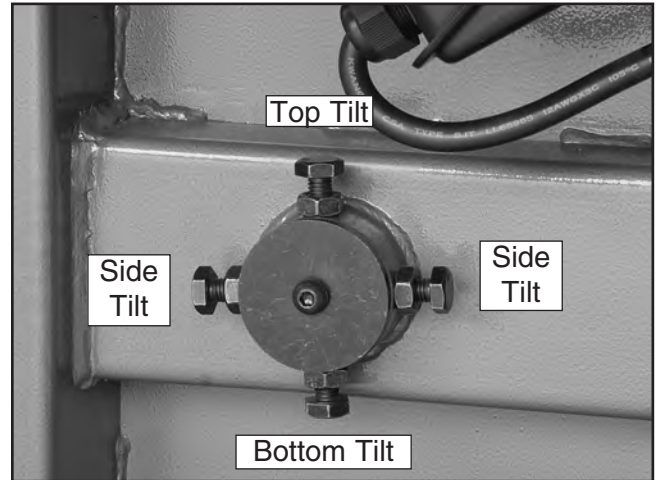


Figure 65. Lower wheel adjustment control.

- If wheels will go parallel but not coplanar, shim upper wheel out as needed using thin $\frac{3}{4}$ " washers on shaft behind wheel.

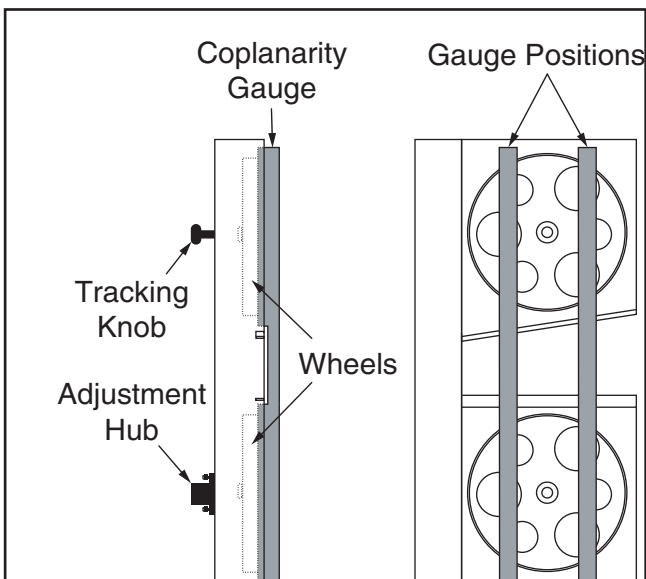


Figure 64. Checking for coplanarity.



9. **Figure 66** shows positions of wheels when coplanar. When wheels are coplanar, re-install table, table insert and pin, re-adjust guide blocks and rear support bearings, and close wheel covers.

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.*

10. Finally, check table and fence alignment (see **Pages 28 & 29**).

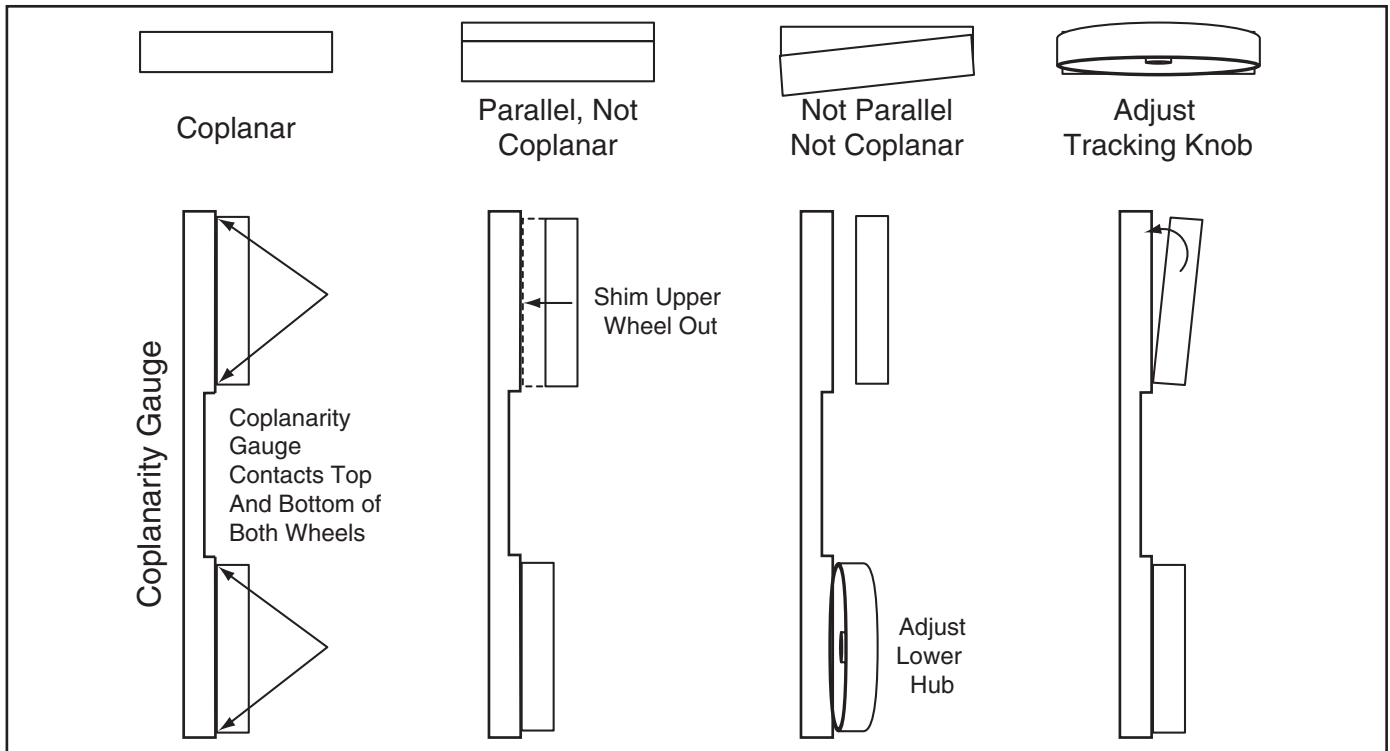


Figure 66. Coplanarity diagram.



Adjusting Guide Post Travel

The guide post assembly should remain parallel with the blade front-to-back and side-to-side along its length of travel. If it does not, follow these instructions to correctly adjust the guide post.

Tools Needed:

Machinist's Square	1
Small Ruler	1
Hex Wrench 5mm.....	1
Metal Shims.....	(As Needed)

To check if guide post is parallel side-to-side with blade:

1. DISCONNECT MACHINE FROM POWER!
2. Tighten blade to tension that will be used during operation.
3. Loosen guide post lock knob, raise guide post, then place a machinist's square on table next to side of blade, as illustrated in **Figure 67**.

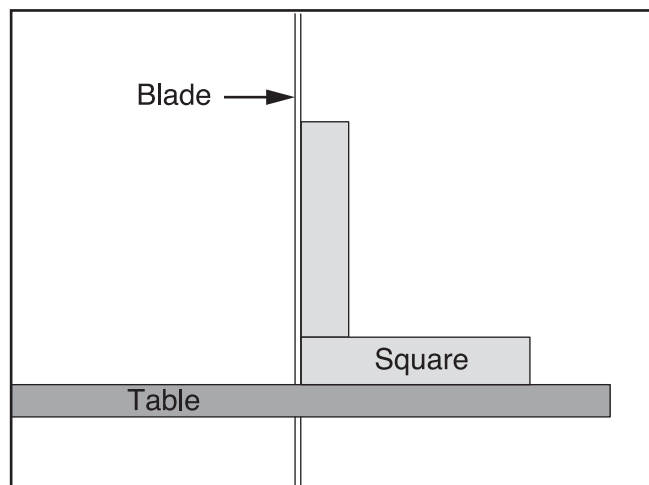


Figure 67. Squaring table to blade.

4. Adjust table square with blade using table tilt handwheel, then secure it with table tilt lock lever.

5. Loosen guide post lock knob, lower guide post to within 1" of table top, then tighten knob.
6. Place a machinist's square on table next to right hand side of guide post, as shown in **Figure 68**.

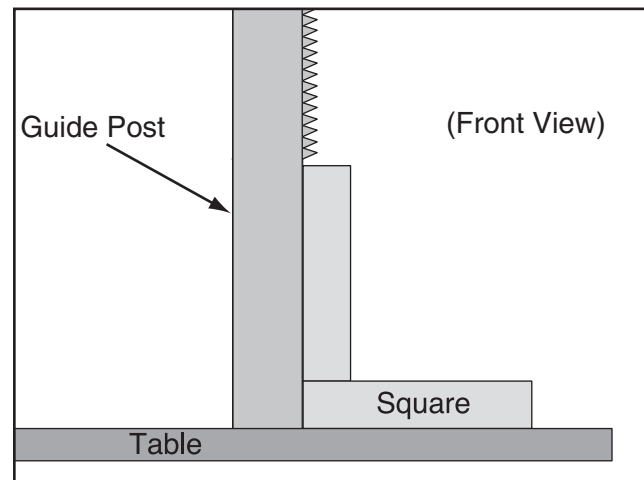


Figure 68. Example of checking guide post squareness.

—If there is no gap between square and guide post along its full length, no adjustments need to be made. Proceed to "To check if guide post is parallel with blade front-to-back."

—If there is a gap between square and guide post, guide post is not parallel to blade. Go to **Step 7**.

7. Loosen each of four screws shown in **Figure 69** ¼ turn.

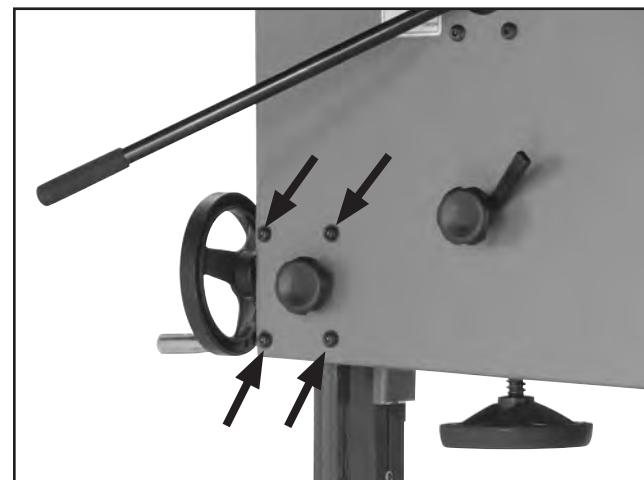


Figure 69. Guide post adjustment screws.



8. Gently tap lower part of guide post in appropriate direction until there is no gap between square and guide post.
9. Tighten screws shown in **Figure 69**.

To check if guide post is parallel with blade front-to-back:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen guide post lock knob, lower blade guide assembly to within 1" of table top, then tighten lock knob.
3. Remove screws that secure guide post guard and move it up and out of the way.
4. Measure distance "A" between top front face of guide post rack and back of blade (see **Figure 70**).

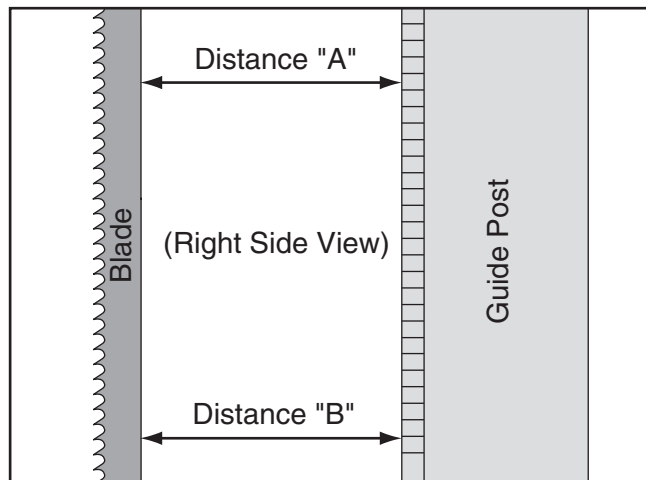


Figure 70. Example of measuring distance between rack and blade at top of guide post.

5. Measure distance "B" between bottom front face of guide post rack and back of blade (see **Figure 70**).

—If measurements taken in **Steps 4 & 5** are equal, no adjustments need to be made. Go to **Step 9**.

—If measurements taken in **Steps 4 & 5** are not equal, go to **Step 6**.

6. Place guide post guard on top of guide post assembly so you can access guide post bracket.
7. Loosen four screws shown in **Figure 69** enough to fit metal shims between frame and guide post bracket (see **Figure 71**).

—If guide post–blade distance is greater at bottom than at top, place a shim between bottom of bracket and frame (Shim "A"). This will tilt bottom of guide post toward blade.

—If guide post–blade distance is less at bottom than at top, place a shim between top of bracket and frame (Shim "B"). This will tilt bottom of guide post away from blade.

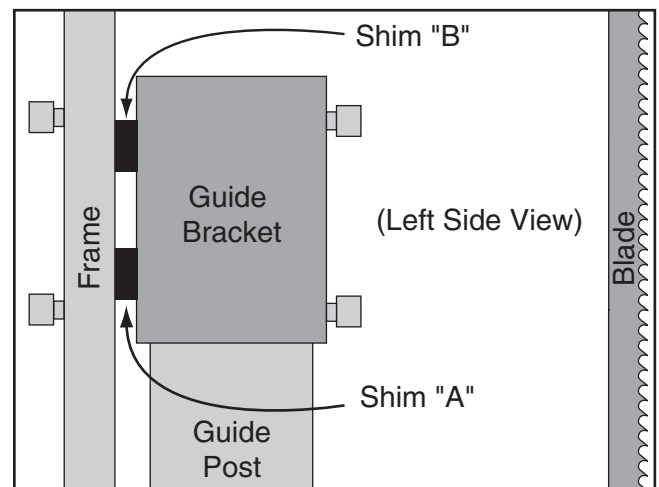


Figure 71. Location for placing shims.

8. Tighten four screws shown in **Figure 69**, then repeat **Steps 4–5**.

—If measurements are equal, go to **Step 9**.

—If measurements are not equal, continue adding shims as needed until guide post rack–blade distance is same at top and bottom.

9. Re-install guide post guard with screws removed in **Step 3**.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.
















CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



Electrical Components



Figure 72. Power supply wiring.



Figure 75. Motor junction box wiring.

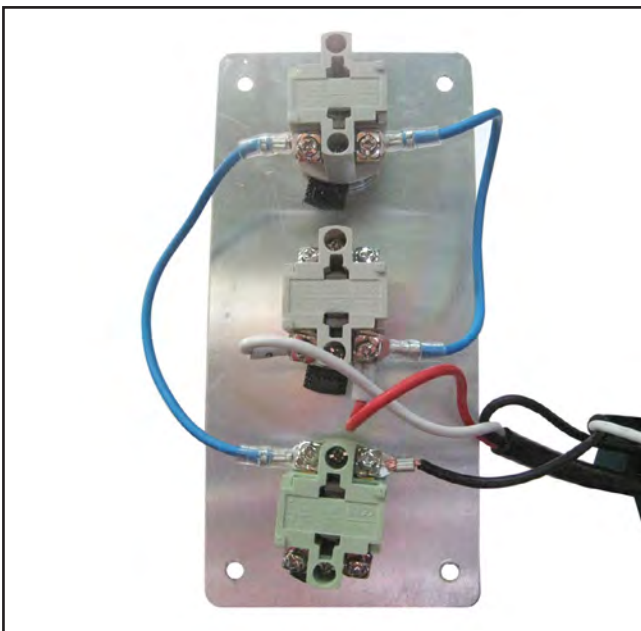


Figure 73. Control panel wiring.



Figure 74. Wheel cover limit switch (left) and foot brake switch (right).

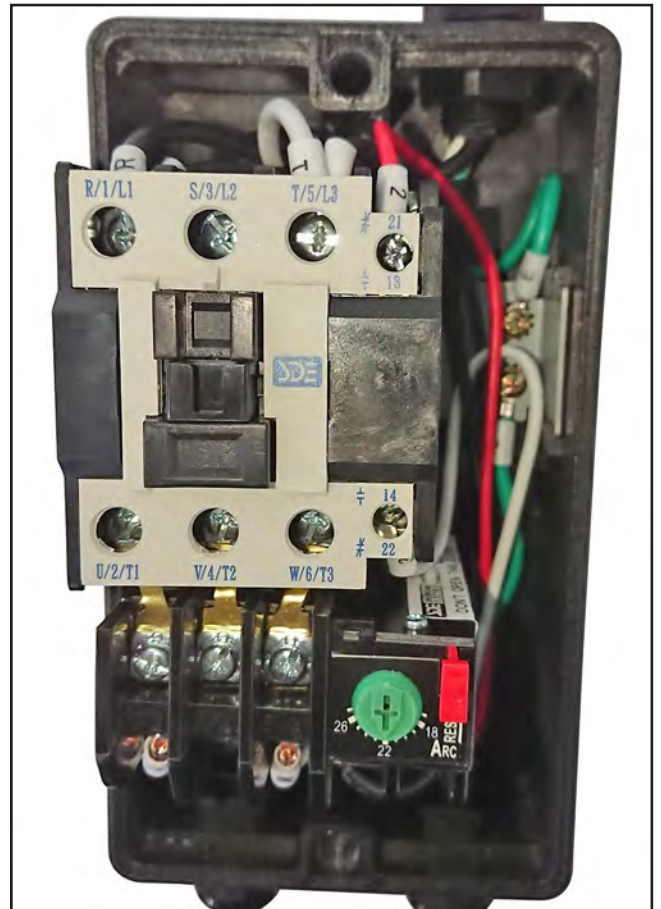
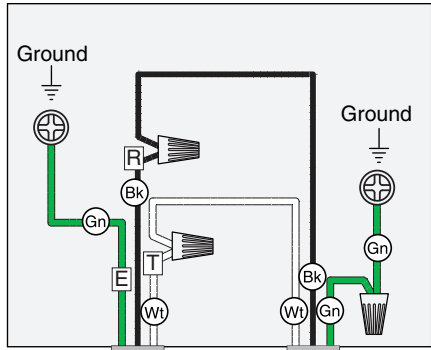


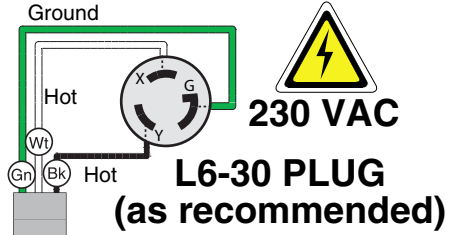
Figure 76. Magnetic switch wiring.



Wiring Diagram



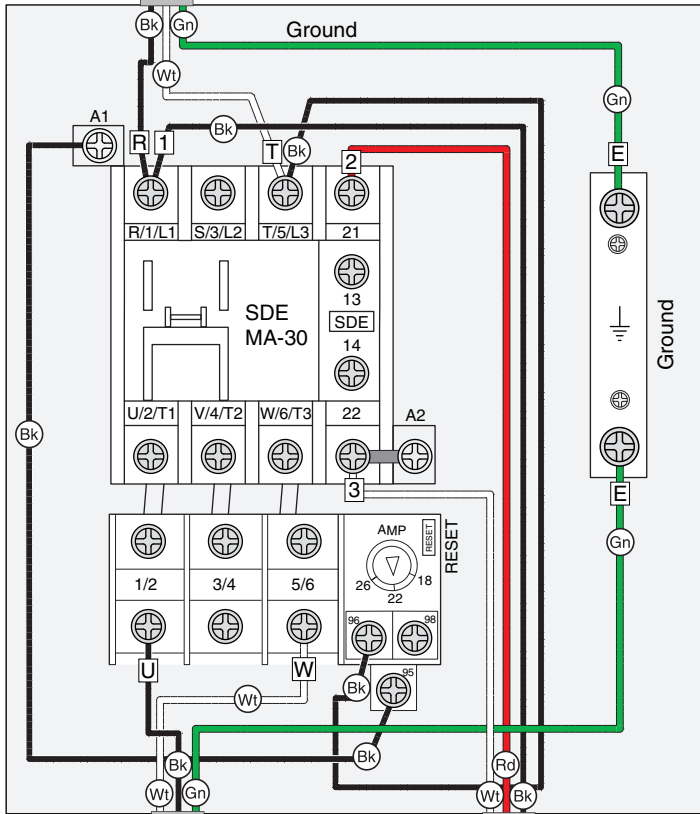
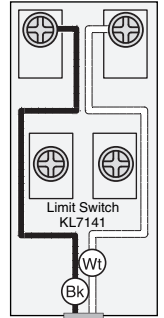
POWER SUPPLY JUNCTION BLOCK
(Figure 72)



230 VAC

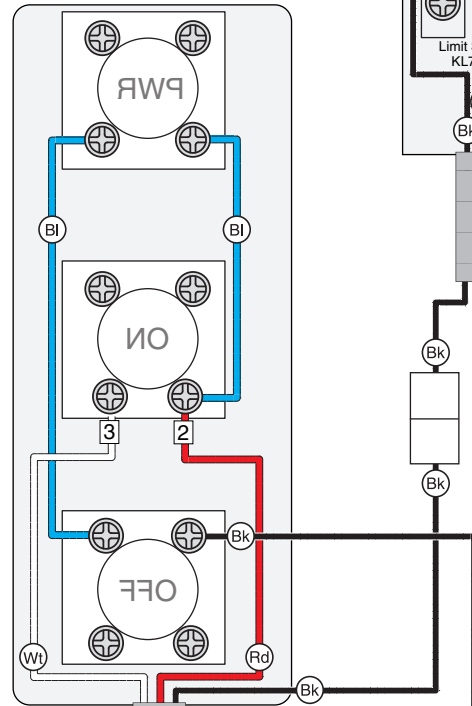
L6-30 PLUG
(as recommended)

LIMIT SWITCH (NC)
(Figure 74)

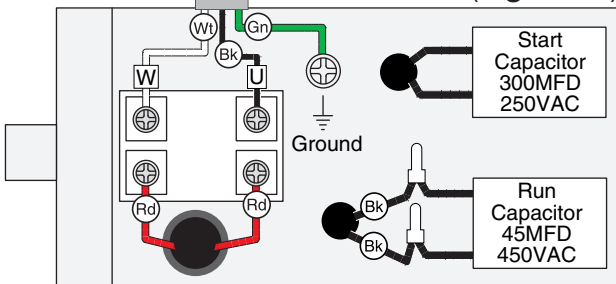


MAG SWITCH ASSY MPE-30
(Figure 76)

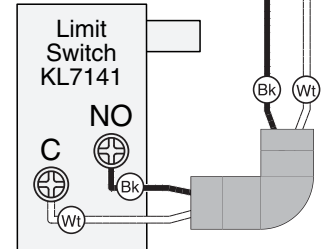
CONTROL PANEL
(viewed from behind)
(Figure 73)



230V MOTOR (Figure 75)

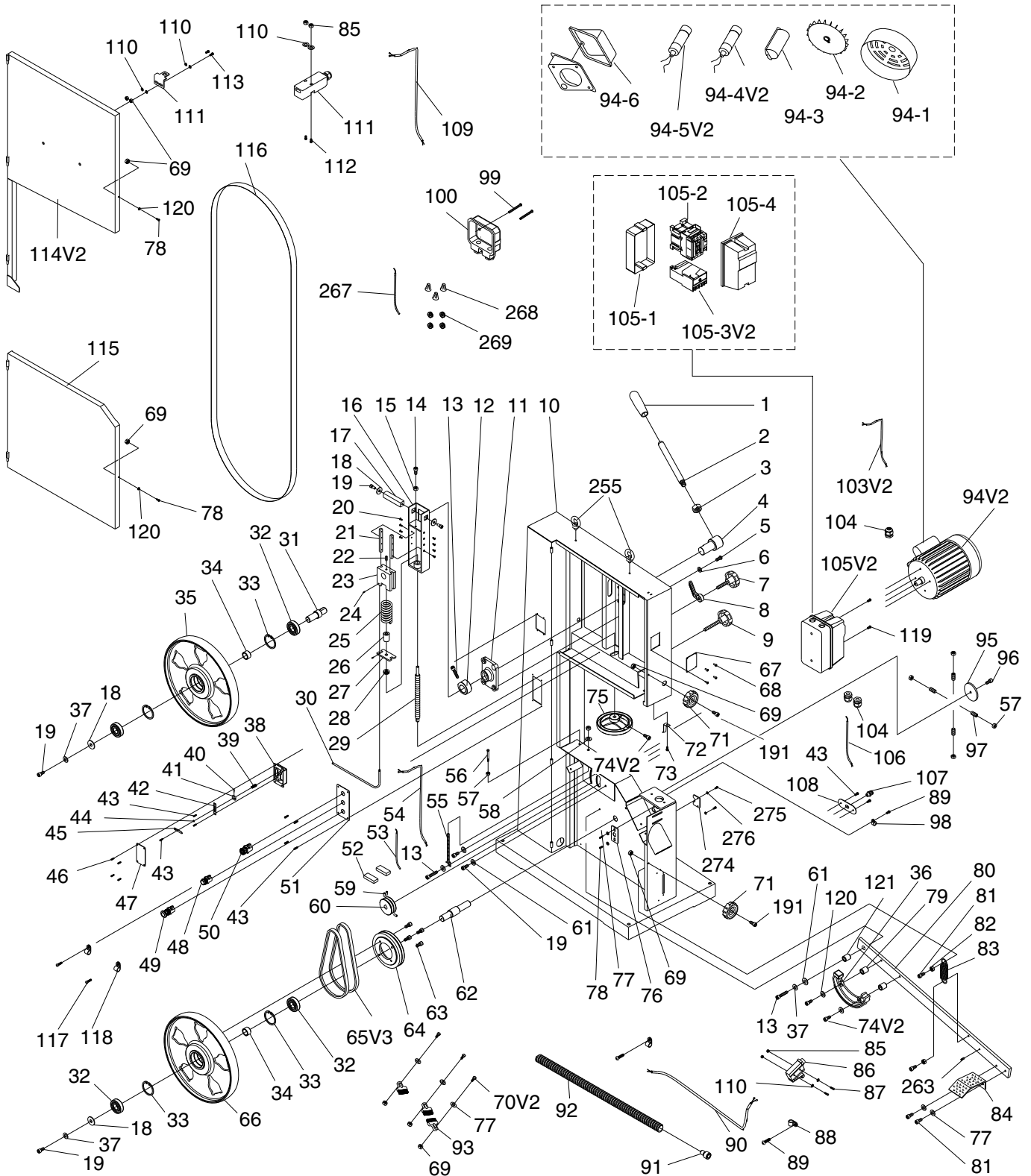


FOOT BRAKE
(Figure 74)



SECTION 9: PARTS

Main



Main Parts List

REF	PART #	DESCRIPTION	REF	PART #	DESCRIPTION
1	P0636X001	HANDLE	55	P0636X055	ADJUST BOLT
2	P0636X002	LEVER ROD M16-2	56	P0636X056	HEX BOLT M10-1.5 X 50
3	P0636X003	HEX NUT M16-2	57	P0636X057	HEX NUT M10-1.5
4	P0636X004	ROTATE SHAFT	58	P0636X058	FLAT WASHER 10MM
5	P0636X005	BUTTON HD CAP SCR M10-1.5 X 20	59	P0636X059	SET SCREW M6-1 X 12
6	P0636X006	LOCK WASHER 10MM	60	P0636X060	MOTOR PULLEY
7	P0636X007	BLADE TRACKING KNOB M10-1.5 x 25	61	P0636X061	FLAT WASHER 8MM
8	P0636X008	BLADE TRACKING LOCK LEVER 10MM	62	P0636X062	LOWER WHEEL SHAFT
9	P0636X009	GUIDE POST LOCK KNOB M10-1.5 X 25	63	P0636X063	BUTTON HD CAP SCR M8-1.25 X 20
10	P0636X010	MACHINE BODY	64	P0636X064	WHEEL PULLEY
11	P0636X011	PILLOW BLOCK	65V3	P0636X065V3	V-BELT A36 V3.09.17
12	P0636X012	CAM	66	P0636X066	LOWER WHEEL
13	P0636X013	CAP SCREW M8-1.25 X 25	67	P0636X067	TRACKING WINDOW
14	P0636X014	HEX BOLT M8-1.25 X 80	68	P0636X068	RIVET 3.2 X 10
15	P0636X015	HEX NUT M8-1.25	69	P0636X069	LOCK NUT M6-1
16	P0636X016	UPPER WHEEL HINGE	70V2	P0636X070V2	HEX BOLT M6-1 X 25 V2.11.11
17	P0636X017	SQUARE SHAFT	71	P0636X071	KNOB
18	P0636X018	SQUARE SHAFT WASHER 8MM	72	P0636X072	HEIGHT POINTER
19	P0636X019	CAP SCREW M8-1.25 X 20	73	P0636X073	FLANGE SCREW M5-.8 X 10
20	P0636X020	FLAT HD SCR M5-.8 X 16	74V2	P0636X074V2	CAP SCREW M6-1 X 30 V2.11.11
21	P0636X021	LOCATE PLATE	75	P0636X075	BLADE TENSION HANDWHEEL
22	P0636X022	SET SCREW M10-1.5 X 16	76	P0636X076	LOWER WHEEL SUPPORT
23	P0636X023	GUIDE BLOCK	77	P0636X077	FLAT WASHER 6MM
24	P0636X024	SET SCREW M5-.8 X 5	78	P0636X078	FLANGE SCREW M6-1 X 10
25	P0636X025	COMPRESSION SPRING	79	P0636X079	BUSHING
26	P0636X026	BUSHING	80	P0636X080	BRAKE LEVER
27	P0636X027	PRESS BLOCK	81	P0636X081	CAP SCREW M6-1 X 16
28	P0636X028	THRUST BEARING 51201	82	P0636X082	HEX NUT M6-1
29	P0636X029	BLADE TENSION SHAFT	83	P0636X083	EXTENSION SPRING
30	P0636X030	TENSION LINE	84	P0636X084	BRAKE STEP PLATE
31	P0636X031	UPPER WHEEL SHAFT	85	P0636X085	HEX NUT M4-.7
32	P0636X032	BALL BEARING 6306ZZ	86	P0636X086	LIMIT SWITCH KL7141
33	P0636X033	INT RETAINING RING 72MM	87	P0636X087	PHLP HD SCR M4-.7 X 30
34	P0636X034	BUSHING	88	P0636X088	CORD CLAMP 5/8"
35	P0636X035	UPPER WHEEL	89	P0636X089	TAP SCREW M4 X 8
36	P0636X036	BRAKE PAD	90	P0636X090	BRAKE LEVER CORD
37	P0636X037	LOCK WASHER 8MM	91	P0636X091	CORD BUSHING
38	P0636X038	UPPER WHEEL SLIDING BRACKET	92	P0636X092	PROTECT TUBE 1/2" X 43-5/16"
39	P0636X039	COMPRESSION SPRING	93	P0636X093	BRUSH
40	P0636X040	GUIDE PIN 3 X 12	94V2	P0636X094V2	MOTOR 5HP V2.06.08
41	P0636X041	MOVING PLATE	94-1	P0636X094-1	MOTOR COVER
42	P0636X042	FIXED PLATE	94-2	P0636X094-2	MOTOR FAN
43	P0636X043	TAP SCREW M4 X 10	94-3	P0636X094-3	CAPACITOR COVER
44	P0636X044	FLAT WASHER 4MM	94-4V2	P0636X094-4V2	S CAPACITOR 300M 250V 1-3/4 x 4 V2.06.08
45	P0636X045	TENSION POINTER	94-5V2	P0636X094-5V2	R CAPACITOR 45M 450V 2 x 3-1/2 V2.06.08
46	P0636X046	TAP SCREW M4 X 16	94-6	P0636X094-6	JUNCTION BOX
47	P0636X047	TENSION SCALE	95	P0636X095	ADJUSTMENT HUB COVER
48	P0636X048	START SWITCH	96	P0636X096	BUTTON HD CAP SCR M8-1.25 X 20
49	P0636X049	STOP SWITCH	97	P0636X097	SET BOLT M10-1.5 X 30
50	P0636X050	KEY SWITCH	98	P0636X098	CORD CLAMP 1/2"
51	P0636X051	SWITCH PLATE	99	P0636X099	FLANGE SCREW M5-.8 X 50
52	P0636X052	CONNECTING BLOCK	100	P0636X100	TERMINAL BOX
53	P0636X053	CONNECTING CORD	103V2	P0636X103V2	POWER CORD 12G 3W V2.11.10
54	P0636X054	SWITCH CORD	104	P0636X104	STRAIN RELIEF M20



Main Parts List (Cont.)

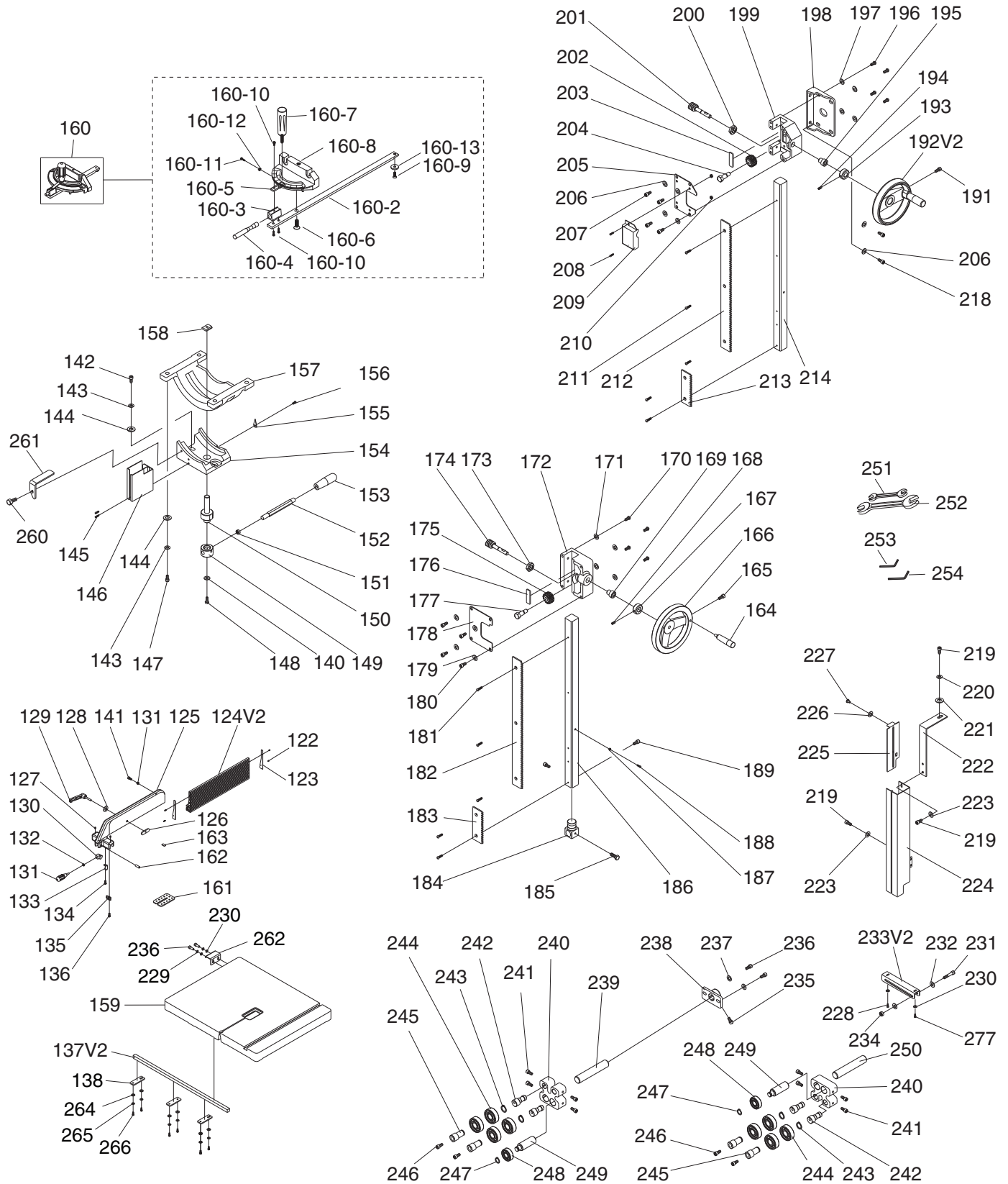
REF	PART #	DESCRIPTION
105V2	P0636X105V2	MAGNETIC SWITCH MPE-30 V2.11.10
105-1	P0636X105-1	MAG SWITCH BACK COVER
105-2	P0636X105-2	CONTACTOR SDE MA-30
105-3V2	P0636X105-3V2	OL RELAY SDE RA-30 18-26A V2.11.10
105-4	P0636X105-4	MAG SWITCH FRONT COVER
106	P0636X106	MOTOR CORD
107	P0636X107	STRAIN RELIEF M20
108	P0636X108	PLATE
109	P0636X109	SWITCH CORD 18G 2W
110	P0636X110	FLAT WASHER 4MM
111	P0636X111	DOOR LATCH SWITCH CANLIE AZD-S11
112	P0636X112	FLANGE SCREW M4-.7 X 35
113	P0636X113	PHLP HD SCR M4-.7 X 10
114V2	P0636X114V2	UPPER WHEEL COVER V2.06.08
115	P0636X115	LOWER WHEEL COVER

REF	PART #	DESCRIPTION
116	P0636X116	SAW BLADE 3TPI 162" X 1" X 0.035
117	P0636X117	TAP SCREW M4 X 10
118	P0636X118	CORD CLAMP 5/16"
119	P0636X119	FLANGE SCREW M5-.8 X 10
120	P0636X120	LOCK WASHER 6MM
121	P0636X121	BUSHING
191	P0636X191	CAP SCREW M6-1 X 25
255	P0636X255	EYE BOLT M10-1.5- X 15
263	P0636X263	NYLON SET SCREW M7 X 10
267	P0636X267	CONNECTING CORD 12G 3C
268	P0636X268	WIRE NUT P3
269	P0636X269	EXT TOOTH WASHER 5MM
274	P0636X274	STOP PLATE
275	P0636X275	CAP SCREW M5-.8 X 12
276	P0636X276	FLAT WASHER 5MM

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.



Fence/Guides/Trunnion



Fence/Guides/Trunnion Parts List

REF	PART #	DESCRIPTION
122	P0636X122	TAP SCREW 3.5 X 8
123	P0636X123	FENCE PIECE 148 X 22 X 1
124V2	P0636X124V2	RESAW FENCE AL 590MM V2.04.17
125	P0636X125	FENCE
126	P0636X126	MOVING PLATE
127	P0636X127	PLASTIC SET SCREW
128	P0636X128	FLAT WASHER 8MM
129	P0636X129	LOCK KNOB M8-1.25 X 44
130	P0636X130	PIVOT BLOCK
131	P0636X131	HEX NUT M8-1.25
132	P0636X132	FENCE HANDLE M8-1.25 X 20
133	P0636X133	SPRING PIECE
134	P0636X134	FLANGE SCREW M4-.7 X 8
135	P0636X135	POINTER
136	P0636X136	FLANGE SCREW M5-.8 X 8
137V2	P0636X137V2	GUARD RAIL SQUARE V2.09.11
138	P0636X138	GUARD RAIL PLATE
139	P0636X139	FLAT WASHER 8MM
140	P0636X140	LOCK WASHER 8MM
141	P0636X141	CAP SCREW M8-1.25 X 20
142	P0636X142	CAP SCREW M10-1.5 X 30
143	P0636X143	LOCK WASHER 10MM
144	P0636X144	FLAT WASHER 10MM
145	P0636X145	FLANGE SCREW M6-1 X 10
146	P0636X146	BLADE GUARD
147	P0636X147	CAP SCREW M10-1.5 X 35
148	P0636X148	HEX BOLT M8-1.25 X 20
149	P0636X149	MICRO ADJUSTING RING
150	P0636X150	PRESS SHAFT
151	P0636X151	HEX NUT M12-1.75
152	P0636X152	HANDLE SHAFT
153	P0636X153	HANDLE KNOB M12-1.75 FEMALE
154	P0636X154	TRUNNION HOUSING
155	P0636X155	POINTER
156	P0636X156	PHLP HD SCR M4-.7 X 10
157	P0636X157	TRUNNION BLOCK
158	P0636X158	PRESS BLOCK
159	P0636X159	TABLE
160	P0636X160	MITER GAUGE ASSEMBLY
160-2	P0636X160-2	GUIDE BAR
160-3	P0636X160-3	LOCKING BRACKET
160-4	P0636X160-4	LOCKING SHAFT
160-5	P0636X160-5	POINTER
160-6	P0636X160-6	STEP SCREW
160-7	P0636X160-7	HANDLE 5/16-18 X 1-1/2
160-8	P0636X160-8	MITER GAUGE BODY
160-9	P0636X160-9	FLAT HD SCR M6-1 X 6
160-10	P0636X160-10	PHLP HD SCR 10-24 X 3/8
160-11	P0636X160-11	PHLP HD SCR M4-.7 X 16
160-12	P0636X160-12	HEX NUT M4-.7
160-13	P0636X160-13	FLAT WASHER 8MM
161	P0636X161	TABLE INSERT
162	P0636X162	SHAFT
163	P0636X163	NYLON PIECE

REF	PART #	DESCRIPTION
164	P0636X164	HANDLE 3/8-16 X 1/2
165	P0636X165	CAP SCREW M6-1 X 25
167	P0636X167	LOCK COLLAR
166	P0636X166	HANDWHEEL
168	P0636X168	SET SCREW M5-.8 X 5
169	P0636X169	BUSHING
170	P0636X170	BUTTON HD CAP SCR M8-1.25 X 35
171	P0636X171	FLAT WASHER 8MM
172	P0636X172	UPPER GUIDE BRACKET
173	P0636X173	HEX NUT M16-1.5
174	P0636X174	WORM SHAFT
175	P0636X175	WORM GEAR
176	P0636X176	FIXED PLATE
177	P0636X177	FIXED BOLT
178	P0636X178	UPPER GUIDE BRACKET COVER
179	P0636X179	LOCK WASHER 8MM
180	P0636X180	CAP SCREW M8-1.25 X 16
181	P0636X181	FLAT HD SCR M4-.7 X 10
182	P0636X182	RACK
183	P0636X183	EXTENSION RACK
184	P0636X184	UPPER GUIDE SUPPORT BLOCK
185	P0636X185	HEX BOLT M6-1 X 10
186	P0636X186	UPPER GUIDE BAR
187	P0636X187	HEX NUT M4-.7
188	P0636X188	PHLP HD SCR M4-.7 X 10
189	P0636X189	CAP SCREW M6-1 X 16
191	P0636X191	CAP SCREW M6-1 X 25
192V2	P0636X192V2	HANDWHEEL W/HANDLE V2.06.08
193	P0636X193	LOCK COLLAR
194	P0636X194	SET SCREW M5-.8 X 5
195	P0636X195	BUSHING
196	P0636X196	BUTTON HD CAP SCR M8-1.25 X 20
197	P0636X197	FLAT WASHER 8MM
198	P0636X198	TRUNNION PLATE
199	P0636X199	TABLE TILT GUIDE BRACKET
200	P0636X200	HEX NUT M16-1.5
201	P0636X201	WORM CYLINDER
202	P0636X202	WORM GEAR
203	P0636X203	FIXED PLATE
204	P0636X204	FIXED BOLT
205	P0636X205	TABLE TILT GUIDE BRACKET COVER
206	P0636X206	LOCK WASHER 8MM
207	P0636X207	CAP SCREW M8-1.25 X 16
208	P0636X208	FLANGE SCREW M5-.8 X 10
209	P0636X209	COVER
210	P0636X210	HEX NUT M5-.8
211	P0636X211	FLAT HD SCR M4-.7 X 10
212	P0636X212	RACK
213	P0636X213	EXTENSION RACK
214	P0636X214	SQUARE TUBE
218	P0636X218	CAP SCREW M8-1.25 X 20
219	P0636X219	CAP SCREW M6-1 X 10
220	P0636X220	LOCK WASHER 6MM
221	P0636X221	FLAT WASHER 6MM



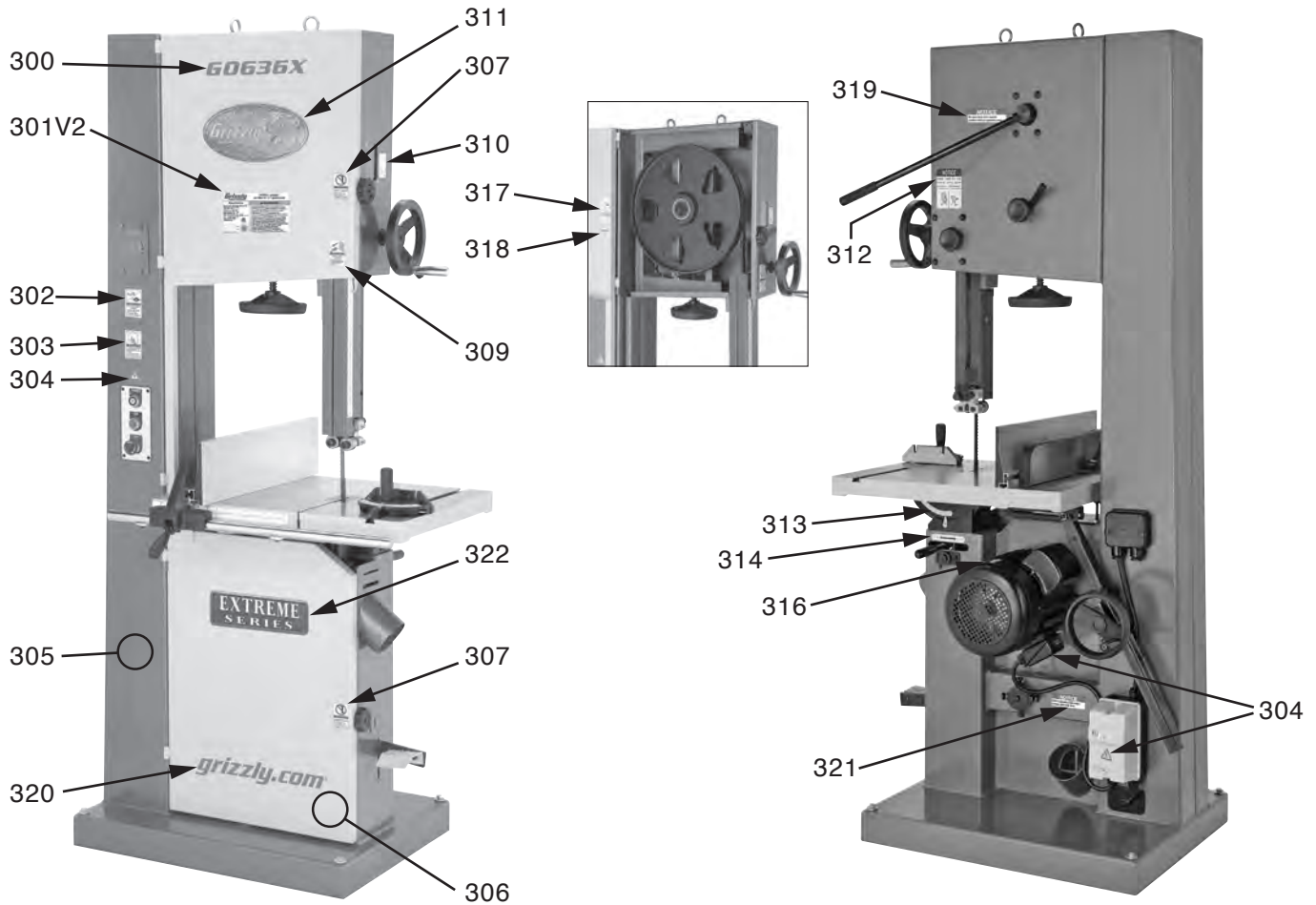
Fence/Guides/Trunnion Parts List (Cont.)

REF	PART #	DESCRIPTION
222	P0636X222	SUPPORT PLATE
224	P0636X224	PROTECT COVER ASM
225	P0636X225	SLIDING PLATE
226	P0636X226	FIBER WASHER 13MM
227	P0636X227	SHOULDER SCREW
228	P0636X228	CAP SCREW M6-1 X 10
229	P0636X229	LOCK WASHER 6MM
230	P0636X230	FLAT WASHER 6MM
231	P0636X231	CAP SCREW M8-1.25 X 55
232	P0636X232	FLAT WASHER 8MM
233V2	P0636X233V2	SLIDING PLATE V2.11.11
234	P0636X234	LOCK NUT M8-1.25
235	P0636X235	HEX BOLT M6-1 X 16
236	P0636X236	CAP SCREW M6-1 X 16
237	P0636X237	FLAT WASHER 6MM
238	P0636X238	LOWER SUPPORT BRACKET
239	P0636X239	SHAFT
240	P0636X240	BLADE GUIDE SUPPORT
241	P0636X241	HEX BOLT M6-1 X 16
242	P0636X242	ECCENTRIC SHAFT
243	P0636X243	EXT RETAINING RING 15MM

REF	PART #	DESCRIPTION
244	P0636X244	BALL BEARING 6202ZZ
245	P0636X245	HANDLE BUSHING
246	P0636X246	CAP SCREW M6-1 X 40
247	P0636X247	EXT RETAINING RING 12MM
248	P0636X248	BALL BEARING 6201ZZ
249	P0636X249	SPACING SLEEVE
250	P0636X250	SHAFT
251	P0636X251	WRENCH 10 X 13
252	P0636X252	WRENCH 17 X 19
253	P0636X253	HEX WRENCH 5MM
254	P0636X254	HEX WRENCH 6MM
257	P0636X257	LOCK WASHER 8MM
258	P0636X258	CAP SCREW M8-1.25 X 20
260	P0636X260	FLANGE SCREW M6-1 X 12
261	P0636X261	L-HOLDER PLATE
262	P0636X262	STOP BRACKET
264	P0636X264	FLAT WASHER 6MM
265	P0636X265	LOCK WASHER 6MM
266	P0636X266	CAP SCREW M6-1 X 20
277	P0636X277	CAP SCREW M6-1 X 12



Labels & Cosmetics



REF	PART #	DESCRIPTION
300	P0636X300	MODEL NUMBER LABEL
301V2	P0636X301V2	MACHINE ID LABEL V2.07.19
302	P0636X302	SAFETY GLASSES LABEL
303	P0636X303	READ MANUAL LABEL
304	P0636X304	ELECTRICITY LABEL
305	P0636X305	TOUCH UP PAINT, GRIZZLY GREEN
306	P0636X306	TOUCH UP PAINT, GREY PUTTY
307	P0636X307	DONT OPEN LABEL
309	P0636X309	UNPLUG BANDSAW LABEL
310	P0636X310	BLADE ASSEMBLY DIRECTION LABEL
311	P0636X311	GRIZZLY NAMEPLATE-LARGE

REF	PART #	DESCRIPTION
312	P0636X312	TENSION ADJ LABEL
313	P0636X313	TABLE ANGLE SCALE
314	P0636X314	TABLE LOCK LEVER LABEL
316	P0636X316	MOTOR LABEL
317	P0636X317	UPPER WHEEL HINGE/STOP LABEL
318	P0636X318	PATENT LABEL
319	P0636X319	LOCK LEVER LABEL
320	P0636X320	GRIZZLY.COM LABEL
321	P0636X321	HANDWHEEL LOCK LEVER LABEL
322	P0636X322	EXTREME SERIES PLATE

WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.



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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.

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/forms/warranty>, 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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