

Grizzly **Industrial, Inc.**®

MODEL G0806/G0807 **VARIABLE-SPEED VERTICAL** **METAL-CUTTING BANDSAW** **OWNER'S MANUAL** *(For models manufactured since 12/15)*



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
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V2.07.17

 **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

Machine Differences

Models G0806 and G0807 are the same machines in all respects with one exception: the Model G0806 is a 14" bandsaw and the Model G0807 is an 18" bandsaw.

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.

Grizzly Industrial MODEL GXXXX MACHINE NAME

WARNING!

To reduce risk of serious injury when using this machine:

1. Read manual before operation.
2. Wear safety glasses and respirator.
3. Make sure safety devices are correctly adjusted/setup and power is connected to grounded circuit before starting.
4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.
5. DO NOT expose to rain or dampness.
6. DO NOT modify this machine in any way.
- 7.
- 8.
9. Do not use while tired, drowsy, or under the influence of drugs or alcohol.
10. Maintain machine carefully to prevent accidents.

SPECIFICATIONS

Motor: _____
Specification: _____
Specification: _____
Specification: _____
Weight: _____

Manufacture Date: _____ date _____ ended.

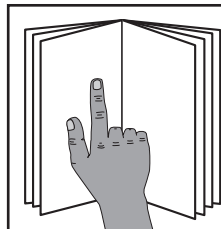
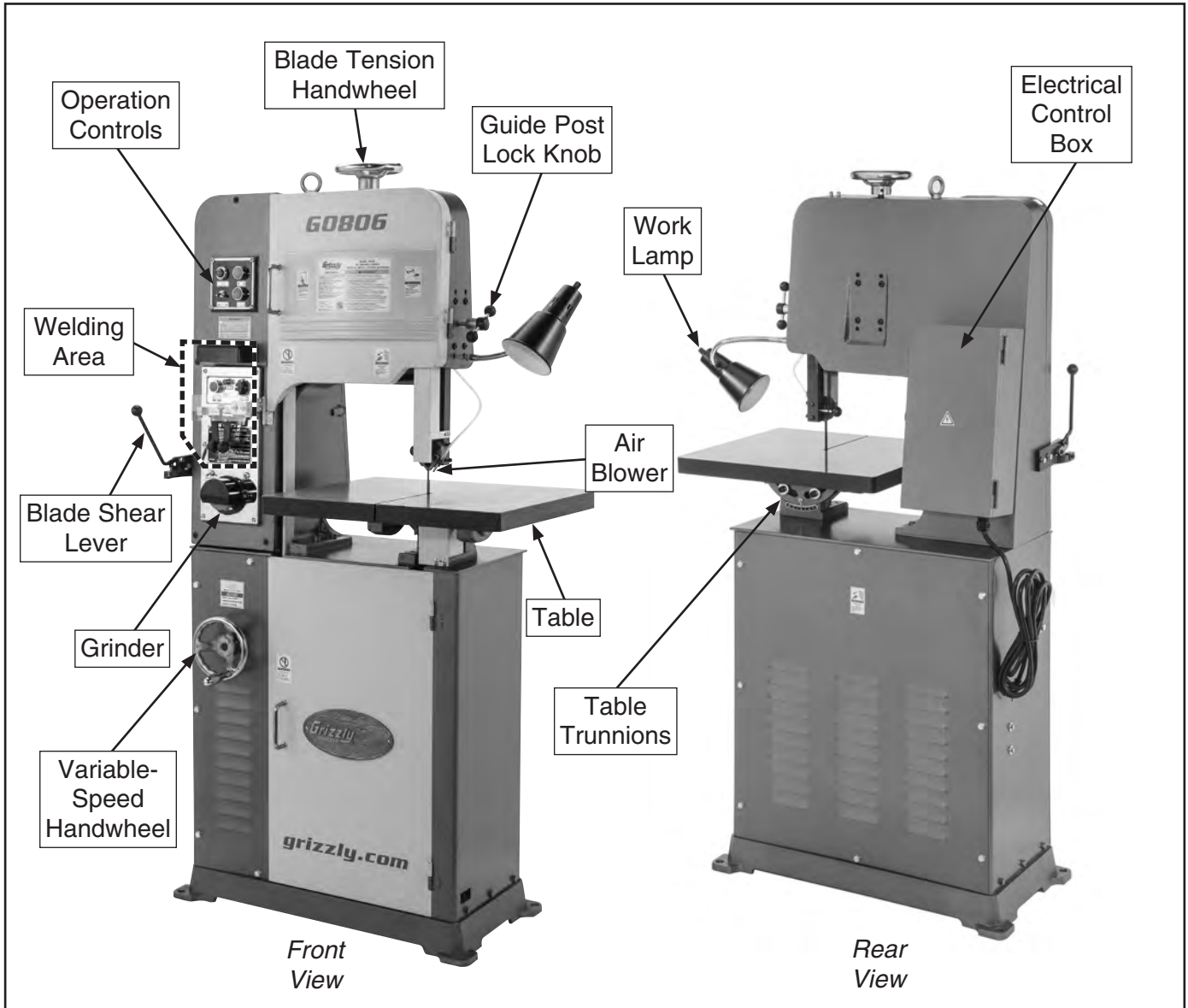
Serial Number: _____

Manufactured for Grizzly in Taiwan



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.



!WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.



Controls & Components



Refer to **Figures 1–3** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

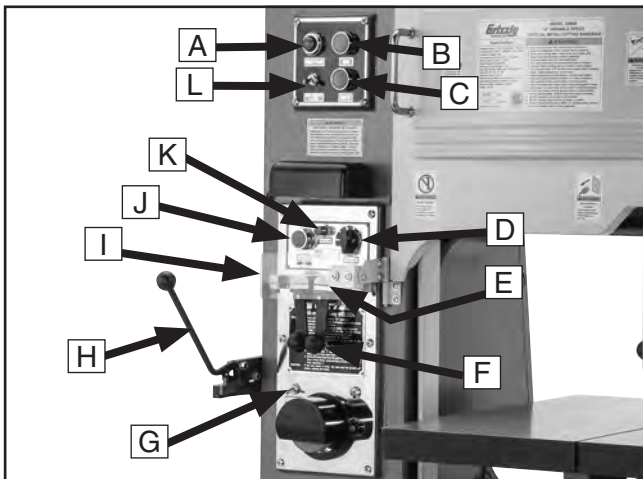


Figure 1. Front controls.

- A. Motor Light:** Lights when the ON button is pressed and there is power to the machine.
- B. ON Button:** Turns the main motor **ON**.
- C. OFF Button:** Turns the main motor **OFF**.
- D. Clamping Pressure Dial:** Adjusts the pressure for pressing the ends of the blades against each other when welding.
- E. Welding Clamp:** Holds a segment of the bandsaw blade to be welded.
- F. Lock Lever:** Secures bandsaw blade for welding operations when rotated up.

- G. Grinder Switch:** Turns grinder **ON/OFF**.
- H. Shear Lever:** Cuts the bandsaw blade.
- I. Spark Deflector:** Provides additional protection from sparks during operations. Proper personal protective equipment **MUST** still be worn during operations; do not rely on spark deflector alone.
- J. Welder Button:** Activates the process of fusing the two blades together.
- K. Annealing Button:** Heats up the blade joint, then allows it to cool in a gradual manner to establish weld strength.
- L. Welder's Lamp Switch:** Illuminates welding station when turned **ON**.



Figure 2. Variable-speed handwheel.

- M. Variable-Speed Handwheel:** Adjusts blade speed from 88 to 384 FPM.

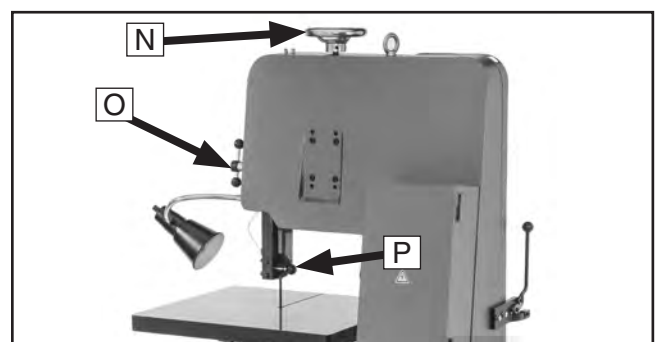


Figure 3. Blade controls.

- N. Blade Tension Handwheel:** Increases or decreases blade tension when rotated.
- O. Guide Post Lock Knob:** Secures guide post and upper blade guide assembly.
- P. Guide Post Knob:** A knob to hold onto when manually adjusting guide post height.





MACHINE DATA SHEET

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

MODEL G0806 14" VARIABLE-SPEED VERTICAL METAL-CUTTING BANDSAW

Product Dimensions:

Weight..... 728 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 36 x 22 x 67-1/2 in.
Footprint (Length x Width)..... 16-1/2 x 31 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 926 lbs.
Length x Width x Height..... 76 x 43 x 29 in.

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 14A at 110V, 7A at 220V
Minimum Circuit Size..... 20A at 110V, 15A at 220V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 12-1/2 ft.
Power Cord Gauge..... 12 AWG
Plug Included..... Yes
Included Plug Type..... 5-15 for 110V
Recommended Plug Type..... 6-15 for 220V
Switch Type..... Magnetic Switch w/Overload Protection

Motors:

Grinder

Type..... ODP Permanent-Split Capacitor
Horsepower..... 1/8 HP
Phase..... Single-Phase
Amps..... 0.6A
Speed..... 3600 RPM
Power Transfer..... Direct Drive
Bearings..... Sealed & Permanently Lubricated

Main

Type..... TEFC Capacitor-Start Induction
Horsepower..... 1.5 HP
Phase..... Single-Phase
Amps..... 14A/7A
Speed..... 1720 RPM
Power Transfer..... Belt Drive
Bearings..... Shielded & Permanently Lubricated



Main Specifications:

Main Specifications

Bandsaw Size.....	14-5/8 in.
Max Cutting Width (Left of Blade).....	14-1/8 in.
Max Cutting Height.....	7-7/8 in.
Blade Speeds.....	88 – 384 FPM

Blade Information

Blade Length Range.....	118-1/4 – 119-1/2 in.
Blade Width Range.....	1/8 – 1/2 in.
Blade Guides.....	Hardened Steel/Tungsten

Table Information

Table Length.....	19-7/8 in.
Table Width.....	22-1/8 in.
Table Thickness.....	1-5/8 in.
Table Tilt - Left/Right.....	15 deg.
Table Tilt - Front/Back.....	10 deg.
Floor-to-Table Height.....	39-1/2 in.

Blade Welding Station Information

Blade Width Range (Bi-Metal).....	1/8 – 3/8 in.
Blade Width Range (Carbon).....	1/8 – 1/2 in.
Blade Thickness.....	0.025 in.
Welding Power.....	2.0 KVA
Grinder Wheel Size.....	2-1/2 x 1/4 x 5/8 in.
Grinder Wheel Grit.....	#80
Grinder Wheel Speed.....	3600 RPM

Construction Materials

Table.....	Precision-Ground Cast Iron
Base/Stand.....	Cast Iron
Body/Frame.....	Cast Iron (Upper), Steel (Lower)
Wheels.....	Balanced Cast Iron
Tires.....	Rubber
Wheel Covers.....	Cast Aluminum (Upper), Pre-Formed Steel (Lower)
Paint Type/Finish.....	Urethane

Other Related Information

Wheel Diameter.....	14-1/8 in.
---------------------	------------

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

Features:

- Includes Blade Cutter, Grinder, and Welding/Annealing Station
- Variable Cutting Speeds
- Lower Wheel Cleaning Brush
- Work Light
- Chip Blower





MACHINE DATA SHEET

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

MODEL G0807 18" VARIABLE-SPEED VERTICAL METAL-CUTTING BANDSAW

Product Dimensions:

Weight..... 803 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 40-1/2 x 21-1/4 x 73-1/2 in.
Footprint (Length x Width)..... 16-1/2 x 34 in.

Shipping Dimensions:

Type..... Wood Crate
Content..... Machine
Weight..... 999 lbs.
Length x Width x Height..... 84 x 46 x 29 in.

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60Hz
Prewired Voltage..... 220V
Full-Load Current Rating..... 19.6A at 110V, 9.5A at 220V
Minimum Circuit Size..... 30A at 110V, 15A at 220V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 12-1/2 ft.
Power Cord Gauge..... 12 AWG
Plug Included..... Yes
Included Plug Type..... 6-15
Switch Type..... Magnetic Switch w/Overload Protection

Motors:

Main

Type..... TEFC Capacitor-Start Induction
Horsepower..... 2 HP
Phase..... Single-Phase
Amps..... 19A/9.5A
Speed..... 1720 RPM
Power Transfer Belt Drive
Bearings..... Shielded & Permanently Lubricated

Grinder

Type..... ODP Permanent-Split Capacitor
Horsepower..... 1/8 HP
Phase..... Single-Phase
Amps..... 0.6A
Speed..... 3600 RPM
Power Transfer Direct Drive
Bearings..... Sealed & Permanently Lubricated



Main Specifications:

Main Specifications

Bandsaw Size.....	18 in.
Max Cutting Width (Left of Blade).....	17-9/16 in.
Max Cutting Height.....	9-5/8 in.
Blade Speeds.....	88 – 384 FPM

Blade Information

Blade Length Range.....	139-3/8 – 140-1/2 in.
Blade Width Range.....	1/8 – 5/8 in.
Blade Guides.....	Hardened Steel/Tungsten

Table Information

Table Length.....	19-7/8 in.
Table Width.....	22-1/8 in.
Table Thickness.....	1-5/8 in.
Table Tilt - Left/Right.....	Right 15 deg.
Table Tilt - Front/Back.....	10 deg.
Floor-to-Table Height.....	38-1/2 in.
Includes Fence.....	No

Blade Welding Station Information

Blade Width Range (Bi-Metal).....	1/8 – 1/2 in.
Blade Width Range (Carbon).....	1/8 – 5/8 in.
Blade Thickness.....	0.025 in.
Welding Power.....	2.4 KVA
Grinder Wheel Size.....	2-1/2 x 1/4 x 5/8 in.
Grinder Wheel Grit.....	#80
Grinder Wheel Speed.....	3600 RPM

Construction Materials

Table.....	Precision-Ground Cast Iron
Base/Stand.....	Cast Iron
Body/Frame.....	Cast Iron (upper), Steel (lower)
Wheels.....	Fully-Balanced Cast Iron
Tires.....	Rubber
Wheel Covers.....	Cast Aluminum (upper), Pre-Formed Steel (lower)
Paint Type/Finish.....	Urethane

Other Related Information

Wheel Diameter.....	18-1/8 in.
Wheel Width.....	1-1/4 in.
Tire Width.....	23/32 in.

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label
ISO 9001 Factory	No
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

Features:

- Includes Blade Cutter, Grinder, and Welding/Annealing Station
- Variable Cutting Speeds from 88 – 384 FPM
- Lower Wheel Cleaning Brush
- Work Light




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

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 Metal Bandsaws

WARNING

Serious injury or death can occur from getting fingers, hair, or clothing entangled in rotating or moving parts. Workpieces can be ejected by saw, striking operator or bystanders. Long-term respiratory damage can occur from breathing metal dust created while cutting. To minimize risk of injury, anyone operating this machine **MUST** completely heed hazards and warnings below.

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position fingers or thumbs in line with the cut. Hands could be crushed in vise or from falling machine components.

ENTANGLEMENT HAZARDS. Do not operate this saw without blade guard in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.

BLADE REPLACEMENT. When replacing blades, disconnect the machine from power, wear gloves to protect hands and safety glasses to protect eyes.

WORKPIECE HANDLING. Always support the workpiece with table, vise, or some type of support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.

LOSS OF STABILITY. Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall which could cause serious injury.

POWER INTERRUPTION. Unplug machine after power interruption. Machines without magnetic switches can start up after power is restored.

FIRE HAZARD. Use EXTREME CAUTION if cutting magnesium. Using the wrong cutting fluid will lead to chip fire and possible explosion.

CUTTING FLUID SAFETY. Always follow manufacturer's cutting-fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid invites slipping hazards.

ATTENTION TO WORK AREA. Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.

MAINTENANCE/SERVICE. All inspections, adjustments, and maintenance are to be done with the power OFF and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.

HEARING PROTECTION & HAZARDS. Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals.

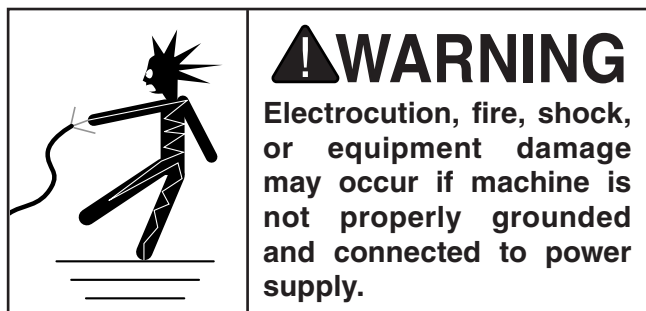
HOT SURFACES. Contact with hot surfaces from machine components, ejections of hot chips, swarf, and the workpiece itself can cause burns.



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.

G0806 Current Rating at 110V 14 Amps

G0806 Current Rating at 220V 7 Amps

G0807 Current Rating at 110V 19.6 Amps

G0807 Current Rating at 220V 9.5 Amps

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

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

Circuit Information

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

! CAUTION

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

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

Grounding Requirements

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

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.



G0806 Circuit Requirements for 110V Operation (Prewired)

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

Nominal Voltage 110V, 115V, 120V
 Cycle 60 Hz
 Phase Single-Phase
 Power Supply Circuit 20 Amps
 Plug/Receptacle NEMA 5-15

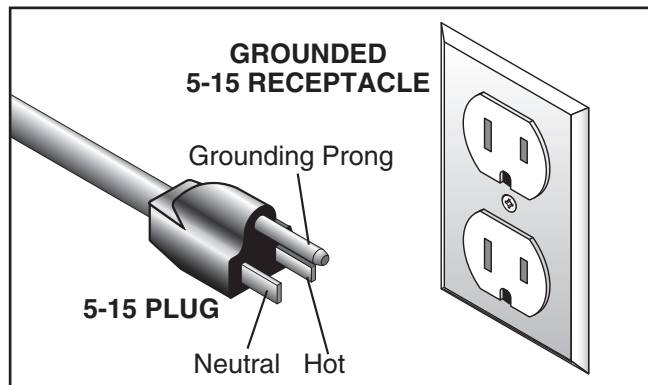


Figure 4. Typical 5-15 plug and receptacle.

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

⚠ CAUTION

SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

G0806 Circuit Requirements for 220V Operation

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 208V, 220V, 230V, 240V
 Cycle 60 Hz
 Phase Single-Phase
 Power Supply Circuit 15 Amps
 Plug/Receptacle NEMA 6-15

For 220V operation: The plug specified under “Circuit Requirements for 220V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

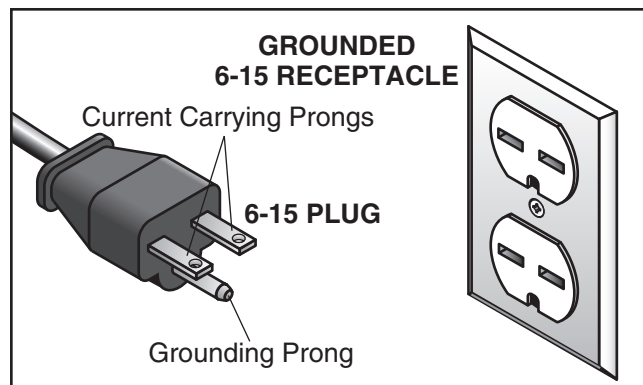


Figure 5. Typical 6-15 plug and receptacle.

⚠ 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.



G0807 Circuit Requirements for 220V Operation (Prewired)

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

Nominal Voltage208V, 220V, 230V, 240V
 Cycle60 Hz
 Phase Single-Phase
 Power Supply Circuit 15 Amps
 Plug/Receptacle NEMA 6-15

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

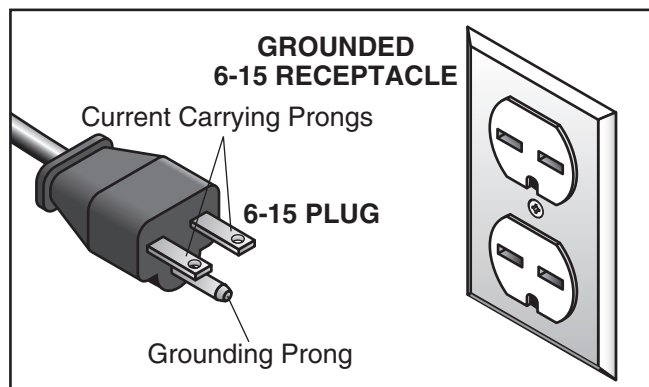


Figure 6. Typical 6-15 plug and receptacle.

⚠ 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.

G0807 Circuit Requirements for 110V Operation

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 110V, 115V, 120V
 Cycle60 Hz
 Phase Single-Phase
 Power Supply Circuit 30 Amps
 Plug/ReceptacleNEMA L5-30

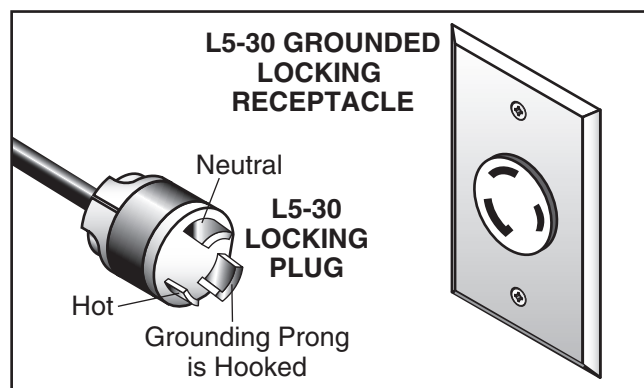


Figure 7. Typical L5-30 plug and receptacle.

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 Size12 AWG
 Maximum Length (Shorter is Better).....50 ft.

⚠ 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.



Voltage Conversion (G0806)

The voltage conversion **MUST** be performed by an electrician or qualified service personnel.

IMPORTANT: To perform the voltage conversion, rewire the motor to the new voltage, rewire the power transformer, correctly set the overload relay dial, rewire the welding transformer, and install the correct plug, according to the provided wiring diagram.

Note: If the diagram included on the motor conflicts with the one on **Pages 58–59**, the motor may have changed since the manual was printed. The diagram provided inside the motor wiring junction box supersedes what is printed in this manual.

Items Needed

	Qty
• Phillips Head Screwdriver #2	1
• Wire Cutters/Stripper.....	1
• Electrical Tape.....	As Needed
• Wire Nut (12 AWG x 3).....	1
• NEMA 6-15 Plug.....	1
• Overload Relay (P0806422).....	1

To convert G0806 for 220V operation:

1. DISCONNECT MACHINE FROM POWER!
2. Remove 5-15 plug from power cord.
3. Remove motor junction box cover, then loosen wire nuts indicated in **Figure 8**.

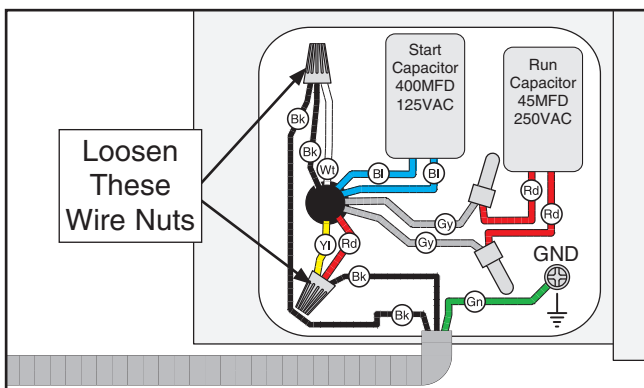


Figure 8. Location of wire nuts to be loosened on Model G0806 when converting voltage.

4. Use wire nuts to connect wires, as indicated in **Figure 9**. Twist all three wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose.

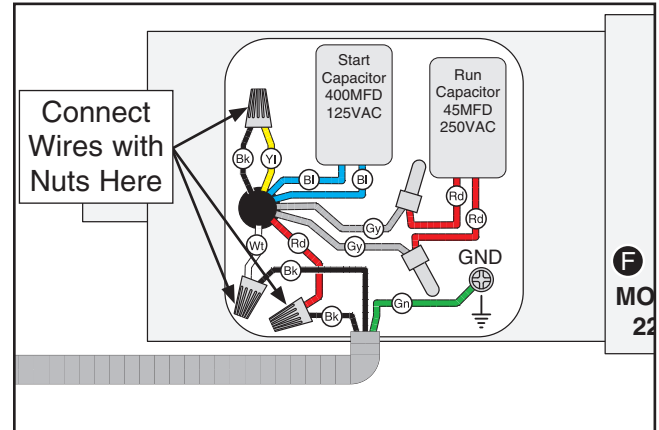


Figure 9. Model G0806 motor rewired to 220V.

5. Open the electrical cabinet and remove the wire attached to the 110V terminal on the power transformer in the electrical panel (see **Figure 10**). Connect it to the 220V terminal.

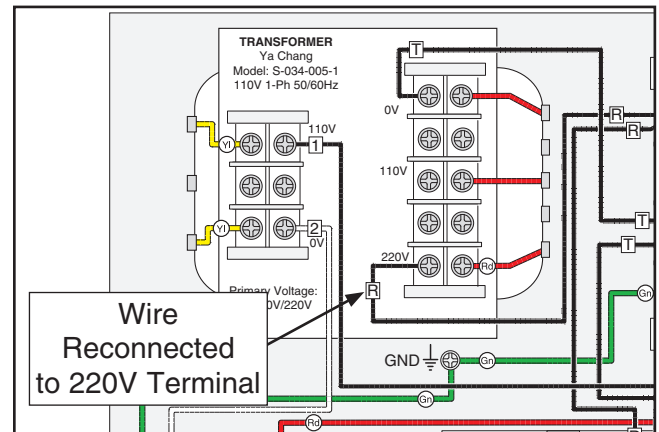


Figure 10. Power transformer wire relocated from 110V to 220V.

6. Remove the pre-installed overload relay and replace it with the overload relay from the voltage conversion kit (Part P0806422).



- Turn the dial on the new overload relay to 7.2A for 220V (see **Figure 11**).

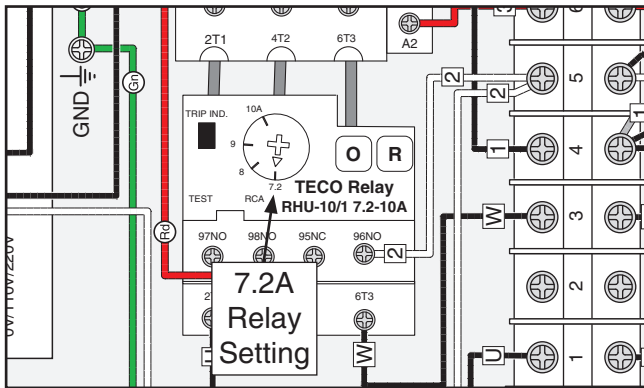


Figure 11. Model G0806 overload relay set to 7.2A.

- Remove the six screws securing the grinding and welding control panel to access grinding unit wiring.

- Remove the wire connected to the #4 terminal on the welding transformer and move it to the #7 terminal; remove the wire connected to the #2 terminal and move it to the #5 terminal (see **Figure 12**). The machine is now wired for 220V.

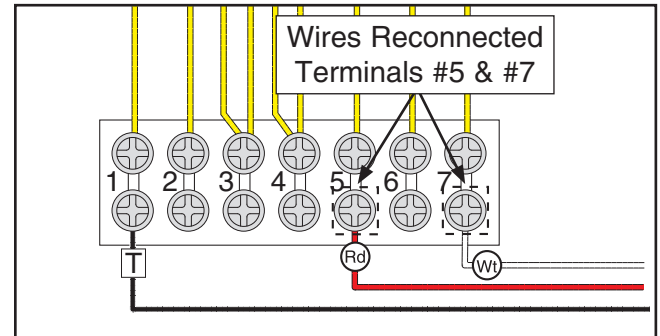


Figure 12. Welding transformer rewired for 220V.

- Close and secure the electrical cabinet, re-install control panel, and secure the motor junction box.
- Install a 6-15 plug according to manufacturer's instructions.



Voltage Conversion (G0807)

The voltage conversion **MUST** be performed by an electrician or qualified service personnel.

IMPORTANT: To perform the voltage conversion, rewire the motor to the new voltage, rewire the power transformer, correctly set the overload relay dial, rewire the welding transformer, and install the correct plug, according to the provided wiring diagram.

Note: If the diagram included on the motor conflicts with the one on **Pages 61–62**, the motor may have changed since the manual was printed. The diagram provided inside the motor wiring junction box supersedes what is printed in this manual.

Items Needed

	Qty
• Phillips Head Screwdriver #2	1
• Wire Cutters/Stripper.....	1
• Electrical Tape.....	As Needed
• NEMA L5-30 Plug	1
• Contactor(P0807420).....	1
• Overload Relay (P0807422)	1

To convert G0807 for 110V operation:

1. DISCONNECT MACHINE FROM POWER!
2. Remove 6-15 plug from power cord.
3. Remove motor junction box cover, then loosen all three wire nuts indicated in **Figure 13**.

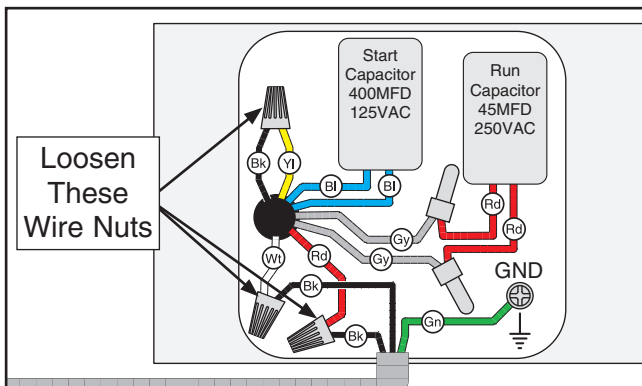


Figure 13. Location of terminal screws to be loosened on Model G0807.

4. Use wire nuts to connect wires, as indicated in **Figure 14**. Twist the two wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose.

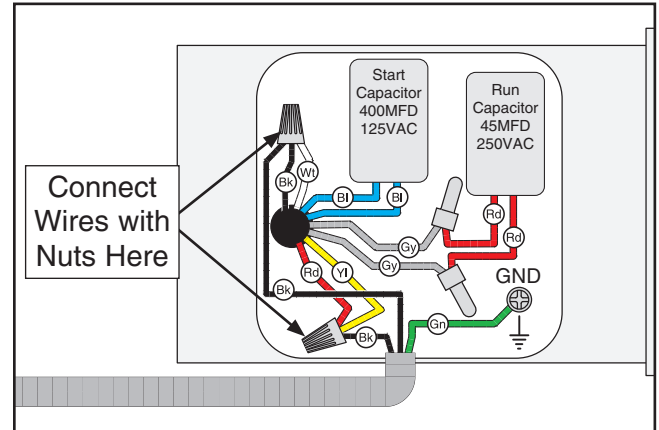


Figure 14. Model G0807 motor rewired to 110V.

5. Open the electrical cabinet and remove the wire attached to the 220V terminal on the power transformer in the electrical panel, and connect it to the 110V terminal, as shown in **Figure 15**.

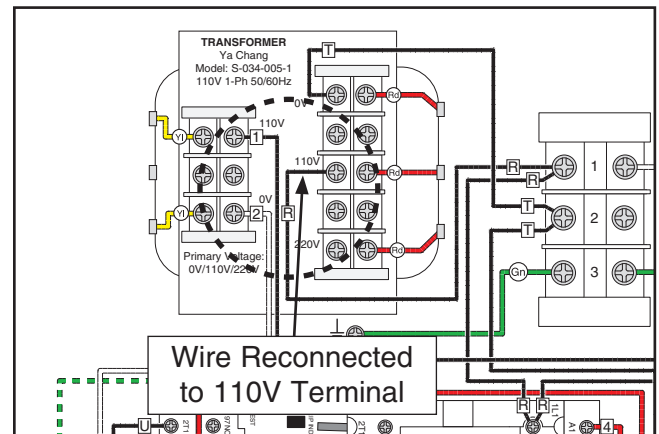


Figure 15. Power transformer wire relocated from 220V to 110V.

6. Remove the factory-installed contactor and overload relay and replace it with the 110V conversion kit (Part P0807425).



- Turn the dial on the overload relay to 19.5A for 110V (see **Figure 16**).

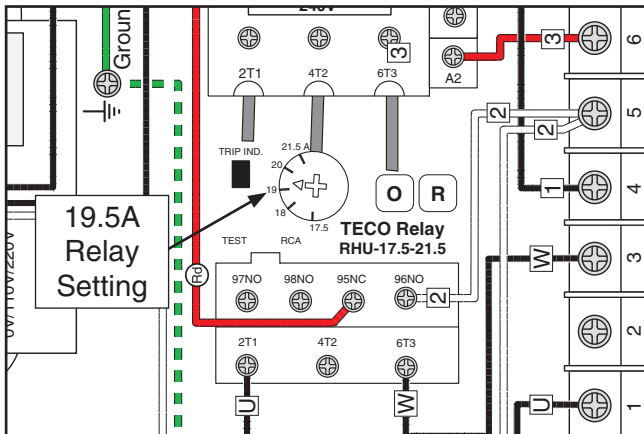


Figure 16. Model G0807 overload relay set to 19.5A.

- Remove six screws securing the grinding and welding control panel to access grinding unit wiring.

- Remove the wire connected to the #4 terminal on the welding transformer, and move it to the #2 terminal; remove the wire connected to the #5 terminal, and move it to the #3 terminal (see **Figure 17**). The machine is now wired for 110V.

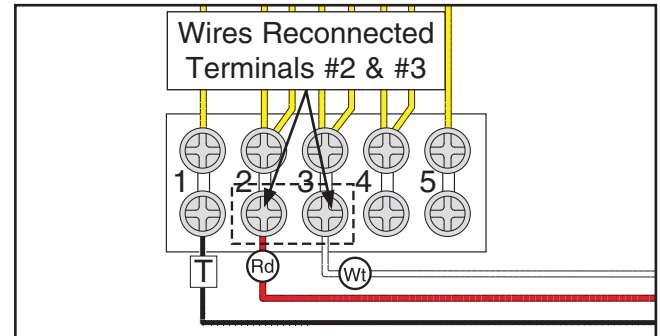


Figure 17. Welding transformer rewired for 110V.

- Close and secure the electrical cabinet, re-install control panel, and secure the motor junction box.
- Install an L5-30 plug according to manufacturer's instructions.



SECTION 3: SETUP

Preparation

The list below outlines the basic process of preparing your machine for operation. Specific steps are covered later in this section.

The typical preparation process is as follows:

1. Unpack the machine and inventory the contents of the box/crate.
2. Clean the machine and its components.
3. Identify an acceptable location for the machine and move it to that location.
4. Level the machine and either bolt it to the floor or place it on mounts.
5. Assemble the loose components and make any necessary adjustments or inspections to ensure the machine is ready for operation.
6. Connect the machine to the power source.
7. Test run the machine to make sure it functions properly and is ready for operation.

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.*



Needed for Setup

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

- **For Lifting and Moving:**
 - A forklift or other power lifting device rated for at least 1200 lbs.
 - Lifting strap or chain w/safety hook rated for at least 1200 lbs.
- **For Power Connection:**
 - A power source that meets the minimum circuit requirements for this machine (review **Power Supply** beginning on **Page 12** for details).
 - An electrician or qualified service personnel to ensure a safe and code-compliant connection to the power source.
- **For Assembly:**
 - Shop Rags
 - Cleaner/degreaser
 - Safety Glasses for Each Person
 - Oil Can with any General Machine Oil
 - Blade Tension Tool
 - Grease Gun with any API GL 2 Grease
 - Stiff Grease Brush
 - Phillips Screwdriver #2
 - Floor mounting hardware (see **Page 22**)
 - Hex Wrench 5mm
 - Hex Wrench 6mm
 - Open-End Wrench 1/2" (or Ratchet and 1/2" Socket)
 - Open-End Wrenches 13mm and 17mm
 - Additional Person



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.

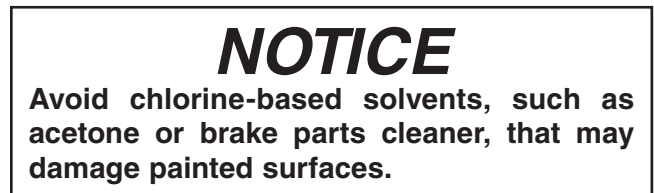
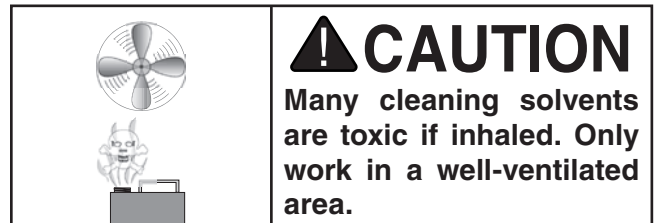
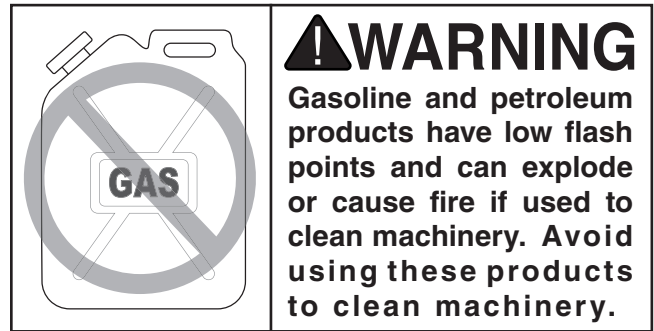
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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 18. T23692 Orange Power Degreaser.



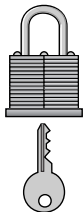
Site Considerations

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.**



CAUTION
Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

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.

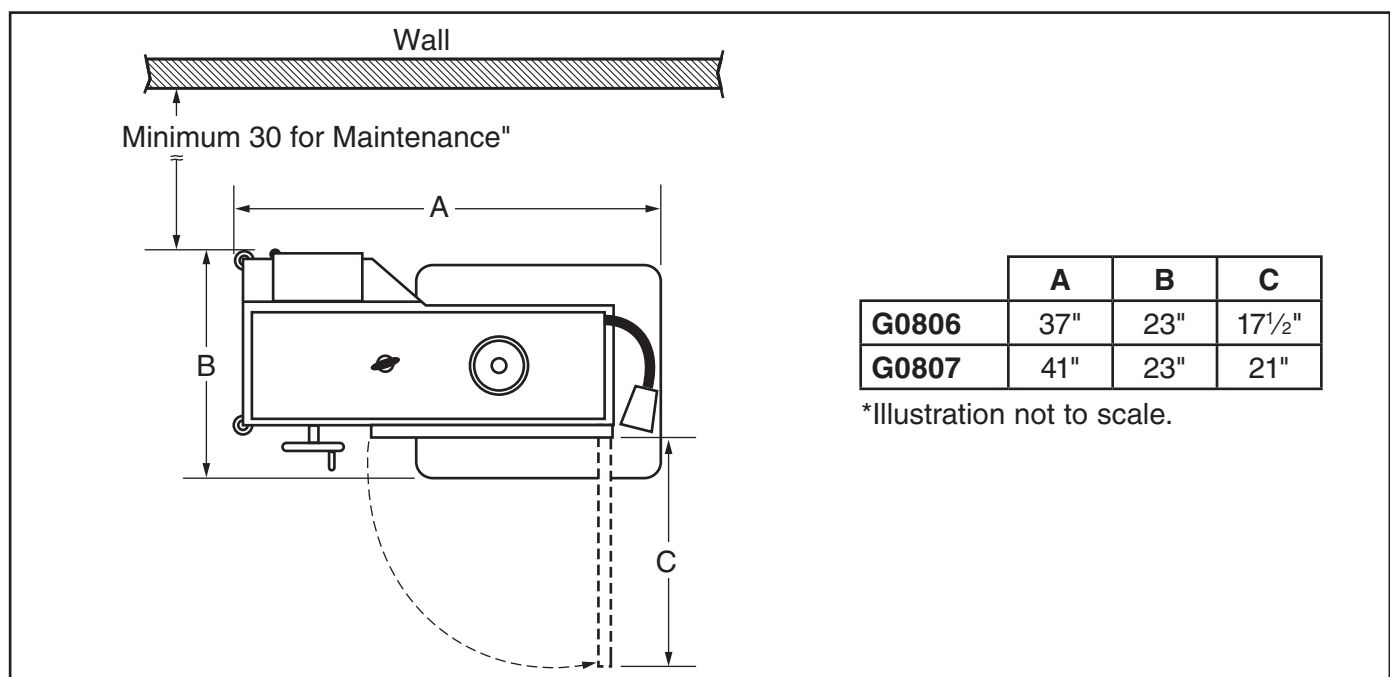
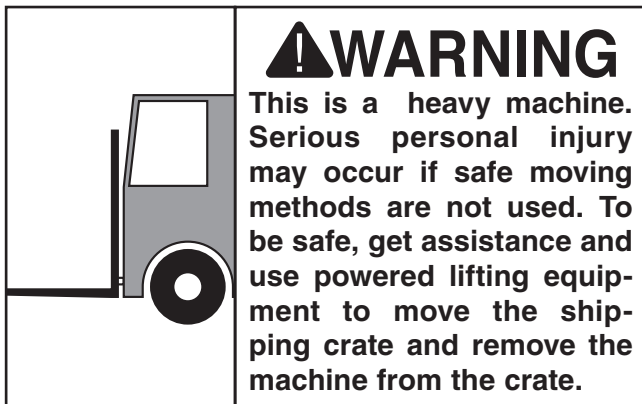


Figure 19. Minimum working clearances.



Lifting & Placing



To lift and place the bandsaw:

1. Prepare the bandsaw operation site for machine placement (refer to **Anchoring to Floor**) and the electrical connection (refer to **Page 12**).
2. With the bandsaw still secured to the shipping pallet, move it to the operation site, then remove the shipping straps securing the bandsaw to the pallet.
3. Attach the safety hook and chain between the forklift and bandsaw lifting eyebolt (see **Figure 20** for an example).

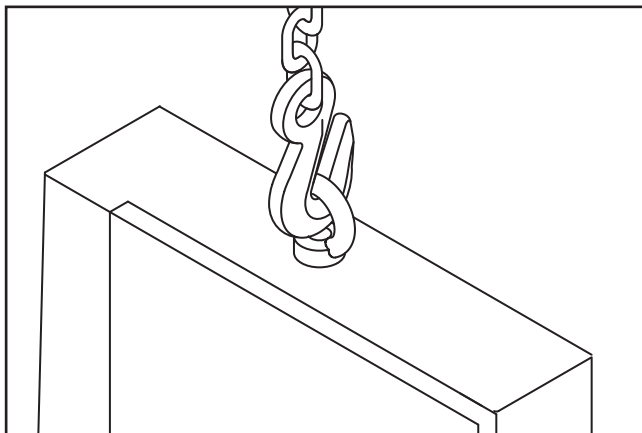


Figure 20. Example of using safety hook and chain to lift bandsaw.

4. With the help from another person to steady the load and prevent the bandsaw from swinging, lift the bandsaw enough to clear the pallet, remove the pallet, then slowly place the bandsaw into position.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 5/8"

Anchoring machinery to the floor prevents tipping or shifting and reduces vibration that may occur during operation, resulting in a machine that runs slightly quieter and feels more solid.

If the machine will be installed in a commercial or workplace setting, or if it is permanently connected (hardwired) to the power supply, local codes may require that it be anchored to the floor.

If not required by any local codes, fastening the machine to the floor is an optional step. If you choose not to do this with your machine, we recommend placing it on machine mounts, as these provide an easy method for leveling and they have vibration-absorbing pads.

Anchoring to Concrete Floors

Lag shield anchors with lag screws (see below) are a popular way to anchor machinery to a concrete floor, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later, if needed. However, anytime local codes apply, you **MUST** follow the anchoring methodology specified by the code.

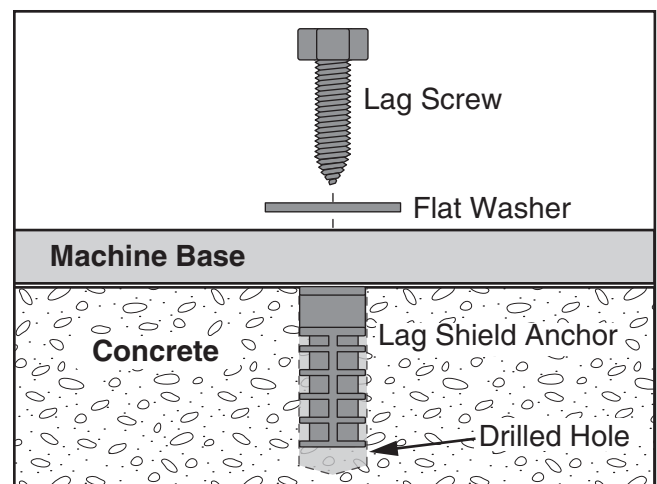


Figure 21. Popular method for anchoring machinery to a concrete floor.



Assembly

This machine comes pre-assembled from the factory. However, tension has been removed from the blade for shipping purposes. Before operating the machine for the first time, you **MUST** make sure the blade is properly tensioned. Refer to the **Tensioning Blade** procedure on this page for instructions about how to do this.

Initial Lubrication

Your machine was lubricated at the factory, but we strongly recommend that you inspect all lubrication points yourself and provide additional lubrication if necessary. Refer to **Lubrication** on **Page 43** for specific details.

Tensioning & Tracking Blade

Blade tension directly affects blade tracking so it is important to adjust them together.

Tensioning Blade

Proper blade tension maximizes the life of the blade and bandsaw components, improves cutting performance, and reduces the risks related to blade breakage.

When tensioning the blade, avoid the urge to over-tension it. Too much tension reduces the life of the bandsaw bearings and the blade.

Tools Needed	Qty
Hex Wrench 5mm, 6mm.....	1 Each
Open-End Wrench or Socket 17mm.....	1

To tension the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the upper wheel door.

3. Use the guide post knob (see **Figure 22**) to raise the upper blade guides to the highest position.

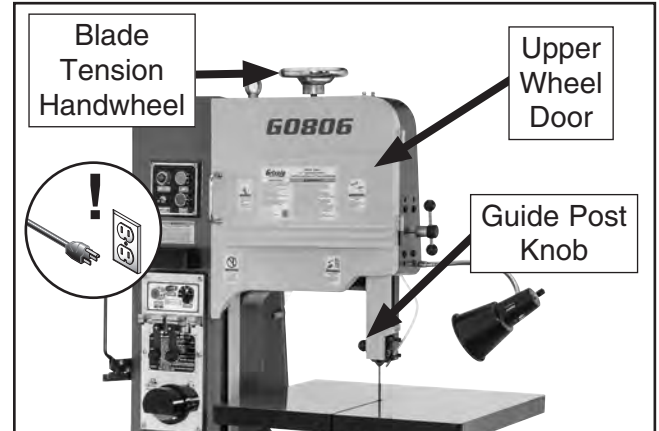


Figure 22. Guide post knob and blade tension handwheel.

4. Check the deflection of the blade by pushing it with moderate pressure midway between the upper blade guides and the table (see **Figure 23**). The proper amount of deflection is approximately $\frac{1}{4}$ ".

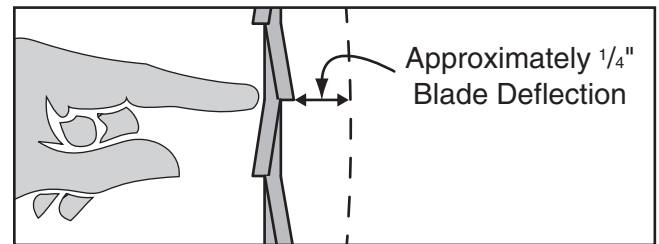


Figure 23. Proper amount of blade deflection.

Note: The most accurate way to check blade tension is to use a tensioning gauge. Grizzly offers the Model H5408 Blade Tensioning Gauge (refer to **Page 41**).

5. Use the blade tension handwheel (see **Figure 22**) to make adjustments until the blade is properly tensioned.

Note: Turn the handwheel counterclockwise (as viewed from underneath it) to decrease tension, and clockwise to increase tension.



Tracking Blade

Blade "tracking" refers to where the blade rides on the wheels as they rotate.

A blade that is tracking correctly runs cooler, reduces wear-and-tear on the machine, and increases cutting performance. When tracking correctly, the blade rides next to, but not against, the wheel flange (see **Figure 24**).

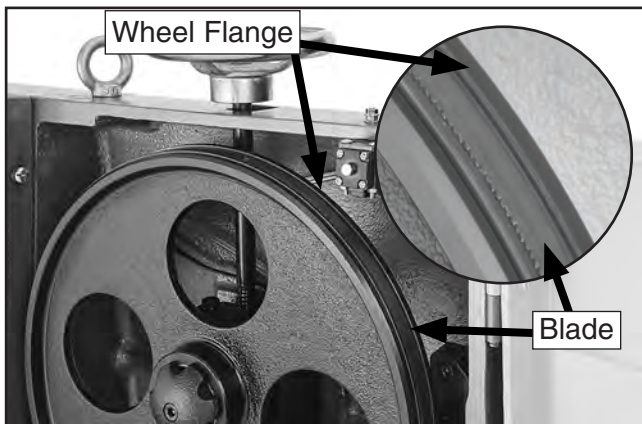


Figure 24. Back edge of blade next to wheel flange.

NOTICE

Blade tension affects blade tracking. It is important to make sure blade is properly tensioned before tracking.

Adjust the blade tracking by adjusting the upper and lower pairs of set screws shown in **Figure 25**.

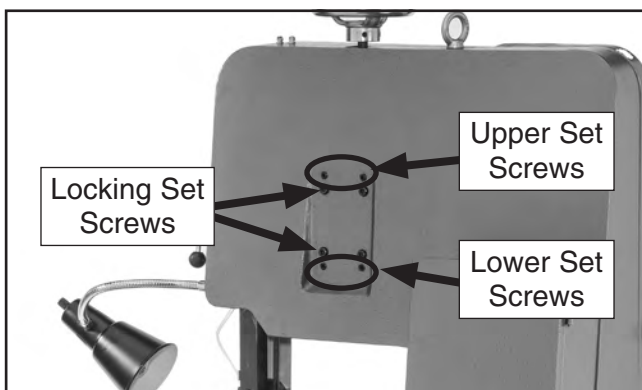


Figure 25. Location of set screws for adjusting blade tracking.

When the upper or lower pair of set screws is adjusted, the bottom of the upper wheel moves in or out, which changes how the blade tracks.

To adjust blade tracking:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the blade is properly tensioned, as instructed on the previous page.
3. Open the upper wheel door.
4. Watch the position of the blade on the wheel as you rotate the upper wheel by hand several times.
 - If the blade rides next to the wheel flange without pressure and does not wander, then no further adjustments are needed.
 - If the blade does not ride next to the wheel flange or it wanders, proceed to the next step.
5. Loosen the four locking set screws (see **Figure 25**).
6. Rotate the upper wheel by hand several times, watching the blade position on the wheel.
7. Adjust the upper and lower pairs of set screws (see **Figure 25**) an equal amount—to tilt the upper wheel in or out—until the blade rides next to the wheel flange without pressure and without wandering across the wheel. Adjust each pair of screws in small increments, then repeat **Step 6**.
 - If the blade is tracking correctly, no further adjustments need to be made. Proceed to **Step 8**.
 - If the blade is *not* tracking correctly, repeat **Steps 6–7** until the blade is tracking correctly.
8. Tighten all four locking set screws and recheck the tracking to make sure it did not change. If it did, repeat **Steps 5–8**.



Adjusting Blade Guide Assemblies

The blade guide assemblies were properly adjusted at the factory; however, due to the variables involved with shipping, we recommend that you check the blade guide assemblies. Properly adjusted blade guide assemblies are essential to making accurate cuts because they keep the blade supported during operation, which prevents the blade from wandering.

The blade guide assemblies help to keep the blade straight while cutting. Use **Figures 26–28** and the following descriptions to better understand the components of the blade guide assembly.

Note: Both the upper and lower blade guide assemblies are adjusted in the same manner. To access the lower assembly, you will need to first remove the lower blade guards.

Blade Guides: Support the blade on both sides.

Blade Guide Bracket: Holds the blade guides.

Blade Support: Supports the blade from behind.

Blade Guide Support Cap Screws: Secure the blade guides in the proper position on both sides of the blade.

Blade Guide Bracket and Blade Support Adjustment Cap Screws: Secure the position of the blade guide brackets and the blade supports.

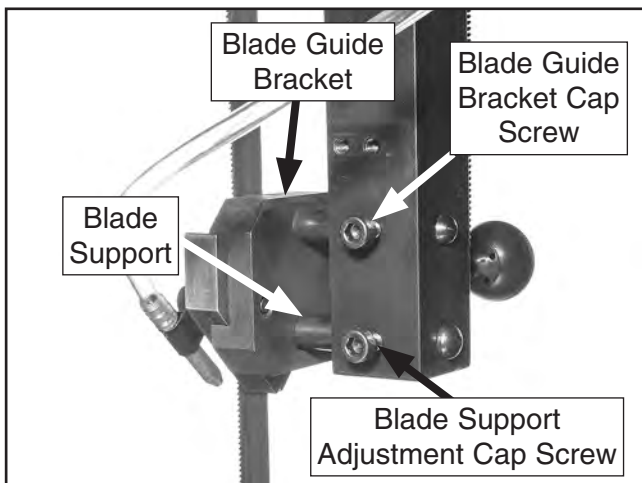


Figure 26. Blade guide assembly components.

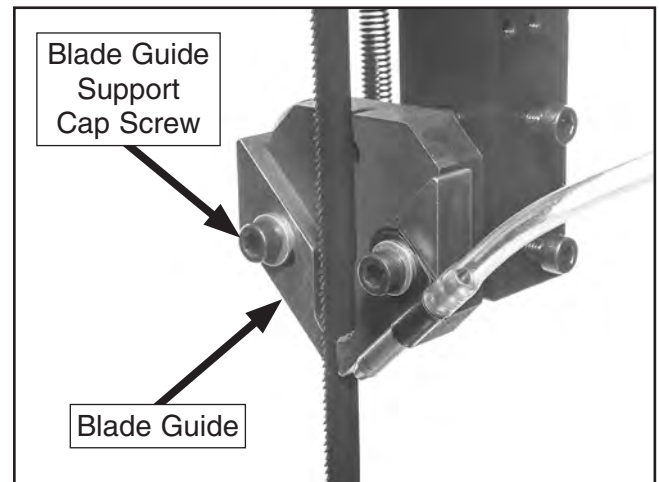


Figure 27. Front view of upper blade guide assembly.

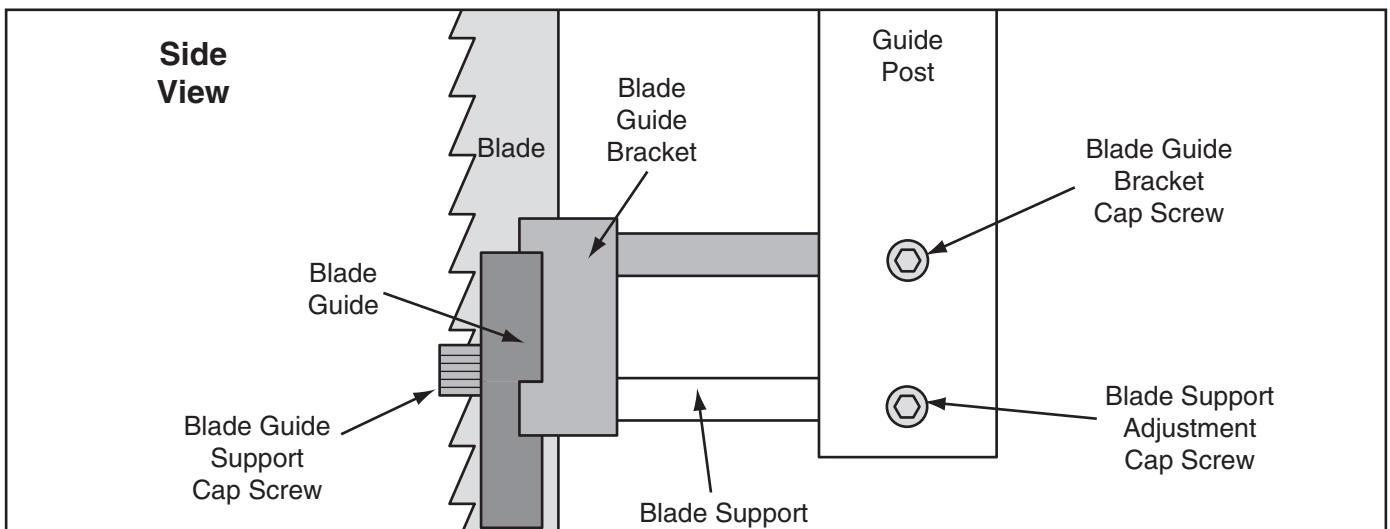


Figure 28. Upper blade guide components.



Blade Support Adjustment

The blade support is a round rod that is positioned 0.016" behind the blade to support it while cutting.

Tools Needed	Qty
Hex Wrench 3mm, 5mm.....	1 Each
Feeler Gauge 0.016".....	1
Dollar Bill (instead of feeler gauge)*	1

*A dollar bill folded twice (four thicknesses) is approximately 0.016".

To adjust the blade support:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the blade guard.
3. Loosen the blade guide bracket cap screw on the guide post (see **Figure 29**).

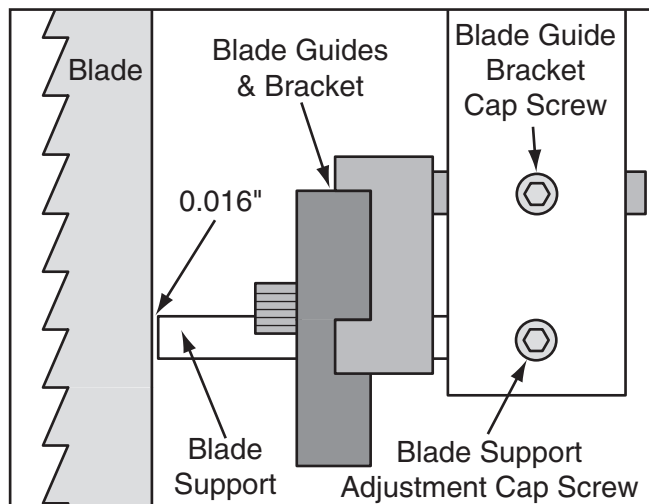


Figure 29. Blade guides and bracket positioned away from blade.

4. Move the blade guide bracket (with the guides) away from the blade so that only the blade support is near the blade, as illustrated in **Figure 29**.
5. Loosen the blade support adjustment cap screw on the guide post.
6. Using a feeler gauge or a dollar bill as a gauge, position the blade support 0.016" behind the blade.
7. Retighten the blade support adjustment cap screw to secure the setting.

8. Perform the **Blade Guide Adjustments** procedure in the next subsection.
9. Re-install the blade guard.

Note: Ensure blade guard does not contact upper wheel or blade.

Blade Guide Adjustments

The blade guides should be positioned 0.004" away from each side of the blade and 1/16" behind the teeth gullets.

The goal is to position the guides as close as possible to the blade from side-to-side without touching it. The guides are positioned behind the teeth gullets to provide support without allowing the guides to ruin the teeth set when the blade is pushed back during cutting.

Tools Needed	Qty
Hex Wrench 3mm, 5mm.....	1 Each
Phillips Head Screwdriver #2	1
Feeler Gauges 0.004"	1
Dollar Bill (instead of feeler gauge)*	1
Fine Ruler.....	1

*The thickness of a dollar bill is approximately 0.004", so it can be used in the place of the 0.004" feeler gauge.

To adjust the blade guides:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the blade guard.
3. Make sure the blade support is correctly positioned behind the blade (refer to **Blade Support Adjustment** in the previous subsection).
4. Make sure the blade guide bracket cap screw is loose (see **Figure 29**).



5. Move the blade guide bracket in or out from the guide post until the blade guides are approximately $\frac{1}{16}$ " (0.063") behind the teeth gullets (see **Figure 30**), then retighten the blade guide bracket cap screw.

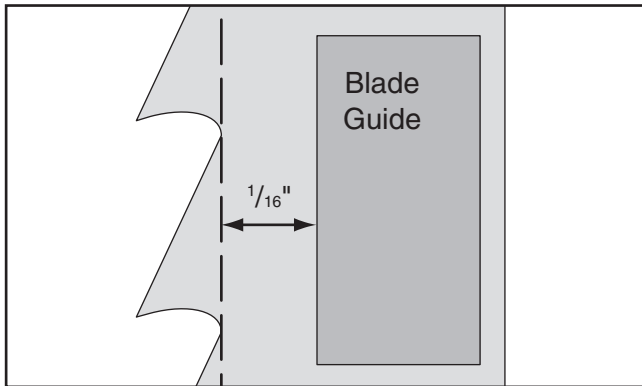


Figure 30. Blade guide positioned approximately $\frac{1}{16}$ " behind tooth gullets.

6. Loosen the blade guide support cap screws (see **Figure 31**).

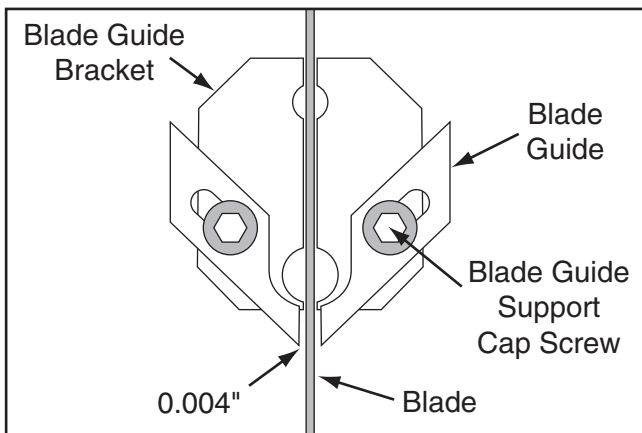


Figure 31. Example of blade guides adjusted 0.004" away from the blade sides.

7. Place the feeler gauge between the blade guide and the blade.

Note: If you use the dollar bill, fold it in half and place it over the blade, as shown in **Figure 32**.

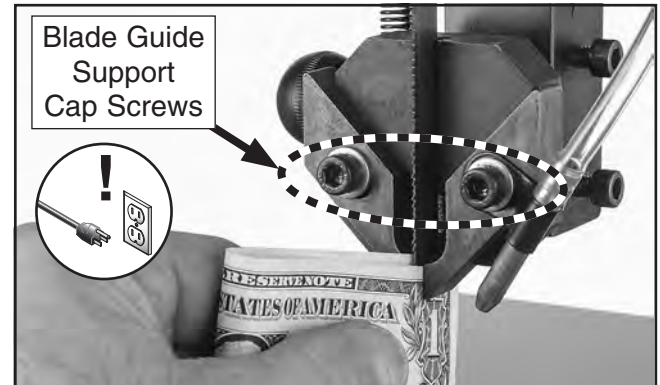


Figure 32. Using a dollar bill to set blade guide spacing.

8. Adjust the blade guide to lightly pinch the feeler gauge or dollar bill between each guide and blade side, then retighten the blade guide support cap screws.

Note: When retightening right blade guard support cap screw, make sure air hose nozzle remains positioned out of blade path.

9. Re-install the blade guard.

Note: Ensure the blade guard does not contact upper wheel or blade.



Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. The **Troubleshooting** table in the **SERVICE** section of this manual can help.

WARNING

Serious injury or death can result from using this machine BEFORE understanding its controls and related safety information. DO NOT operate, or allow others to operate, machine until the information is understood.

WARNING

DO NOT start machine until all preceding setup instructions have been performed. Operating an improperly set up machine may result in malfunction or unexpected results that can lead to serious injury, death, or machine/property damage.

To test run the machine:

1. Make sure the blade is properly tensioned and tracked (refer to **Tensioning & Tracking Blade** on **Page 23**) and the blade guides are positioned correctly (refer to **Adjusting Blade Guide Assemblies** on **Page 25**).
2. Clear all setup tools away from machine.
3. Connect the machine to the power source.
4. Push the ON button (see **Figure 33**). The green motor light will illuminate and the motor will start.
5. Verify that the machine is operating correctly. When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.
6. Adjust the blade speed through the full range of operation using the variable speed handwheel (see **Figure 33**). The speed should change as you make the adjustments.

Continued on next page 



7. Press the OFF button (see **Figure 33**), the green motor light will go out, and the bandsaw will stop.

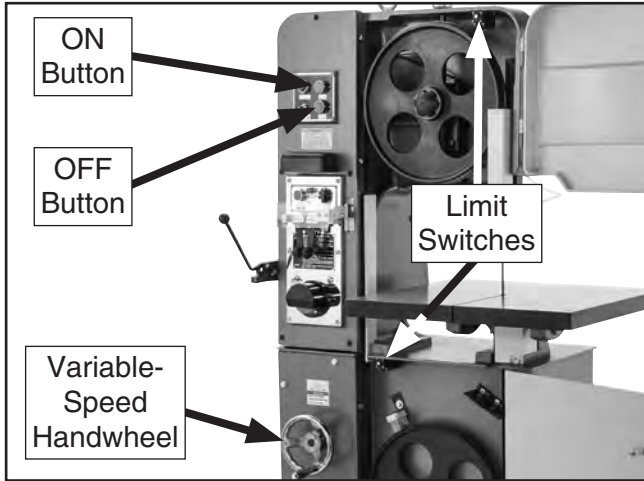


Figure 33. Location of door limit switches (doors shown fully open for clarity).

8. Make sure the blade has fully stopped, open the upper and lower wheel doors a few inches, then turn the bandsaw **ON**.

— If the bandsaw does not start, the upper and lower wheel door limit switches (see **Figure 33**) are working correctly; continue to the next step.

— If the bandsaw starts, immediately turn the machine **OFF** and disconnect power. The upper and lower wheel door limit switches are not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

9. Close the upper and lower wheel doors.
10. Turn the work lamp and the welding lamp **ON** and **OFF**.
11. Turn the grinder **ON** and **OFF**.

Congratulations! You have completed the setup and test run procedures. The bandsaw is now ready for operations.

Inspections & Adjustments

The following list of adjustments were performed at the factory before your machine was shipped:

- **Blade Tracking**Page 23
- **Blade Guide Adjustment**Page 25
- **V-Belt Adjustment** Page 45
- **Table Calibration** Page 50
- **Guide Post Alignment**.....Page 51

Be aware that machine components can shift during the shipping process. Pay careful attention to these adjustments as you test run your machine. If you find that the adjustments are not set according to the procedures in this manual or they do not suit your personal preferences, re-adjust them.

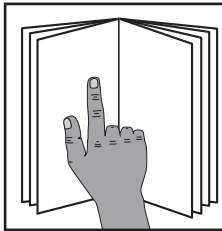


SECTION 4: OPERATIONS

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.

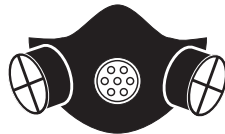


!WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

!WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.



NOTICE

If you are not experienced with this type of machine, **WE STRONGLY RECOMMEND** that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

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

1. Examines the workpiece to make sure it is suitable for cutting.
2. Checks to make sure blade tension is correct, and the blade guides are positioned correctly.
3. Marks the cut line on the workpiece.

!WARNING

Workpieces that cannot be stabilized from unexpected movement should not be cut with a vertical metal bandsaw due to the increased risk of the operator's hands slipping into the blade. Examples are chains, cables, balls, or workpieces with built-in moving parts.

4. Adjusts the upper blade guide height to approximately $\frac{1}{8}$ "– $\frac{1}{4}$ " above the workpiece for maximum blade support.
5. Puts on safety glasses, and rolls up sleeves or secures any clothing or hair that could get entangled with moving parts.
6. Turns the bandsaw **ON**, and adjusts blade speed for the type of material being cut.
7. Presses the workpiece against the blade, using light and even pressure and following the cut line with the blade.

Depending on the workpiece material, the operator may squirt a small amount of cutting fluid at the cutting area to keep it from overheating and smoking.

8. Turns the bandsaw **OFF**.



Blade Selection

Selecting the right blade for the cut requires a knowledge of various blade characteristics.

Blade Terminology

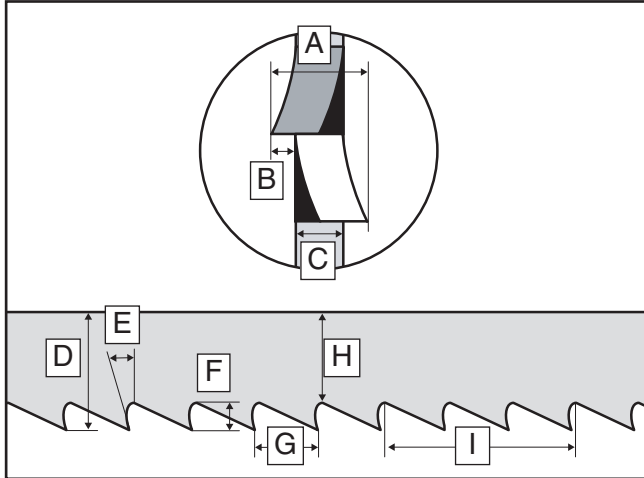


Figure 34. Bandsaw blade terminology.

- A. Kerf:** The amount of material removed by the blade during cutting.
- B. Tooth Set:** The amount each tooth is bent left or right from the blade.
- C. Gauge:** The thickness of the blade.
- D. Blade Width:** The widest point of the blade measured from the tip of the tooth to the back edge of the blade.
- E. Tooth Rake:** The angle of the tooth face from a line perpendicular to the length of the blade.
- F. Gullet Depth:** The distance from the tooth tip to the bottom of the curved area (gullet).
- G. Tooth Pitch:** The distance between tooth tips.
- H. Blade Back:** The distance between the bottom of the gullet and the back edge of the blade.
- I. Blade Pitch or TPI:** The number of teeth per inch measured from gullet to gullet.

Blade Length

Measured by the blade circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between the wheels.

Model	Blade Length Range
G0806.....	118 ¹ / ₄ "–119 ¹ / ₂ "
G0807.....	139 ³ / ₈ "–140 ¹ / ₂ "

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—generally the wider the blade, the straighter it will cut.

Model	Blade Width Range (Carbon Blade)
G0806.....	¹ / ₈ "– ¹ / ₂ "
G0807.....	¹ / ₈ "– ⁵ / ₈ "

Always pick the blade width that best suits your operation.

Curve Cutting: Use the chart in **Figure 35** to choose the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

Minimum Radius of Cut	Blade Width
¹ / ₈ "	¹ / ₈ "
³ / ₈ "	³ / ₁₆ "
⁵ / ₈ "	¹ / ₄ "
1 ¹ / ₄ "	³ / ₈ "
2 ¹ / ₂ "	¹ / ₂ "
3 ³ / ₄ "	⁵ / ₈ "

Figure 35. Blade width radii chart.



Tooth Set

Three common tooth sets are alternate, wavy, and raker (see **Figure 36**). Each removes material in a different manner to make the kerf in the workpiece.

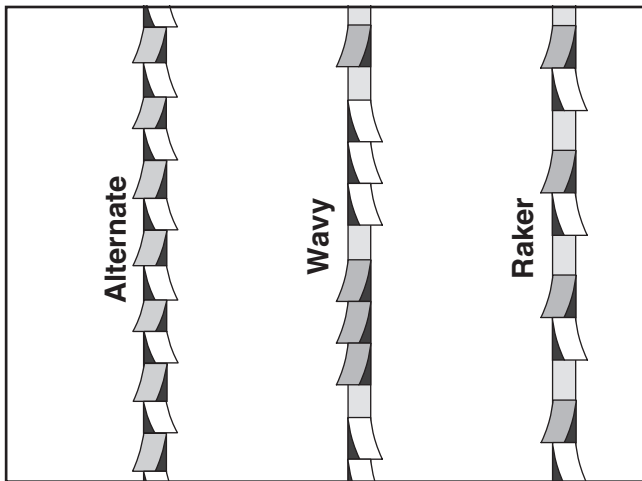


Figure 36. Bandsaw blade tooth sets.

Alternate: An all-purpose arrangement of bending the teeth evenly left and right of the blade. Generally used for milder metals.

Wavy: Generally three or more teeth in a group that are bent one way, followed by a non-set tooth, and then a group bent the other way. Recommended for straight cuts in thin metals or thin-wall tubing.

Raker: Three teeth in a recurring group—one bent left, next one bent right, and then a non-set tooth. The raker set is ideal for most contour cuts.

Tooth Type

The most common tooth types are described below and illustrated in **Figure 37**.

Standard or Raker: Equally spaced teeth set at a "0" rake angle. Recommended for all purpose use.

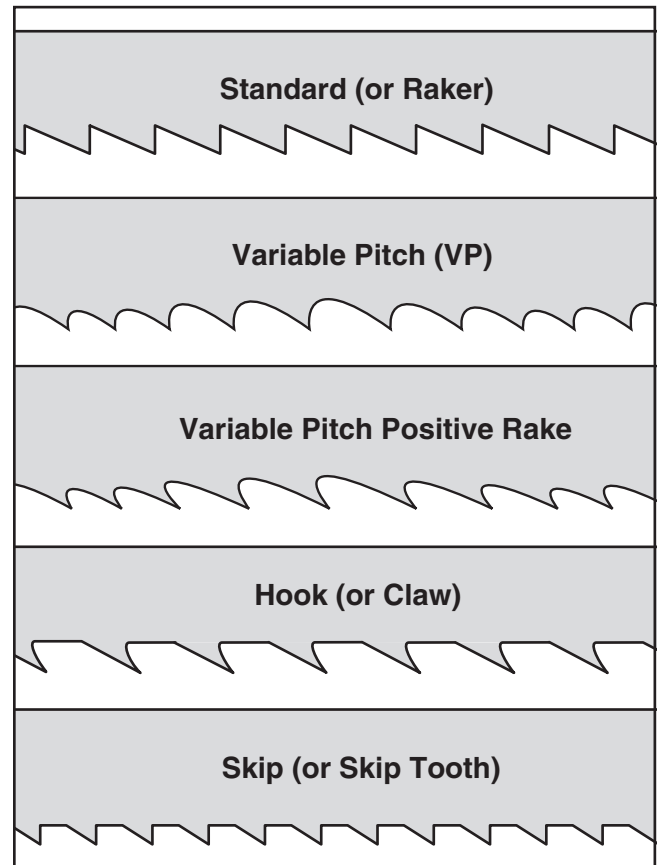


Figure 37. Bandsaw blade tooth types.

Variable Pitch (VP): Varying gullet depth and tooth spacing, a "0" rake angle, excellent chip removing capacity, and smooth cutting.

Variable Pitch with Positive Rake: Varying gullet depth and tooth spacing, a positive rake angle, better chip formation, and aggressive cutting.

Hook or Claw: Wide gullets (round or flat), equally spaced teeth, positive rake angle, and fast cut with good surface finish.

Skip or Skip Tooth: Wide, flat gullets, a "0" rake angle, equally spaced teeth, and recommended for non-ferrous materials.



Blade Pitch (TPI)

The chart below is a basic starting point for choosing teeth per inch (TPI) for variable tooth pitch blades and standard raker set bi-metal blades/HSS blades. However, for exact specifications of bandsaw blades that are correct for your operation, contact the blade manufacturer.

To select the correct blade pitch:

1. Measure the material thickness. This measurement is the length of cut taken from where the tooth enters the workpiece, sweeps through, and exits the workpiece.
2. Refer to the "Material Width/Diameter" row of the blade selection chart in **Figure 38**, and read across to find the workpiece thickness you need to cut.

3. Refer to the "Material Shapes" row and find the shape of the material to be cut.
4. In the applicable row, read across to the right and find the box where the row and column intersect. Listed in the box is the minimum TPI recommended for the variable tooth pitch blades.
5. The "Cutting Speed Rate Recommendation" section of the chart offers guidelines for various metals, given in feet per minute (FPM). Choose the speed closest to the number shown in the chart.

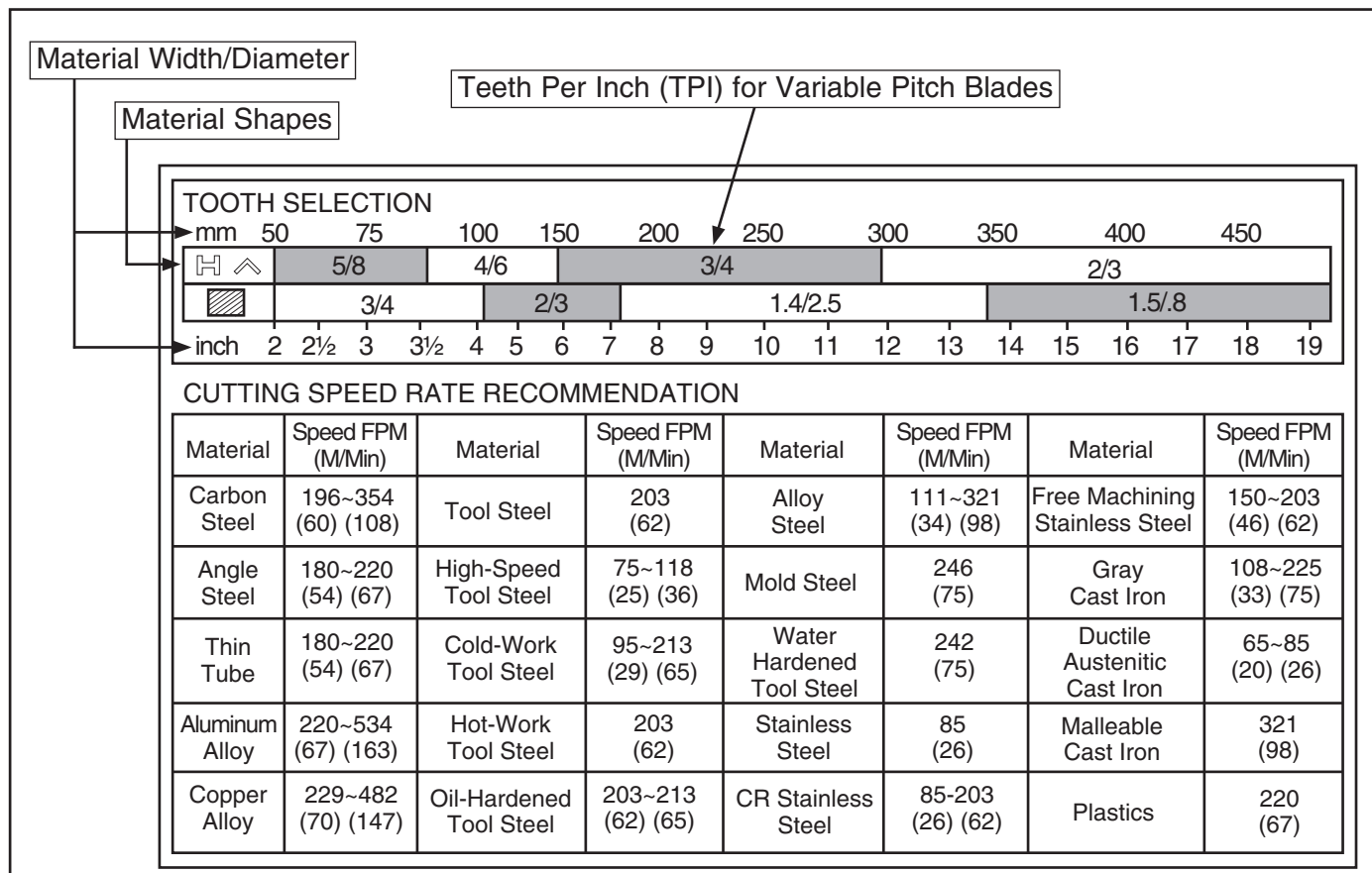



Figure 38. General guidelines for blade selection and speed chart.



Blade Changes

	<p>⚠ CAUTION All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling and uncoiling saw blades.</p>
---	--

Items Needed	Qty
Hex Wrench 3mm.....	1
Hex Wrench 5mm.....	1
Leather Gloves	1

To replace the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the blade guard.
3. Open the upper and lower wheel doors, release tension on the blade, and move the blade guides away from the blade.
4. Put on heavy gloves, then slide the blade off the upper and lower wheels, around the blade post, and through the table slit.
5. Install a new blade in reverse order.

6. Position the back edge of the blade so that it is next to, but not against, the flange of the top wheel (see **Figure 39**).

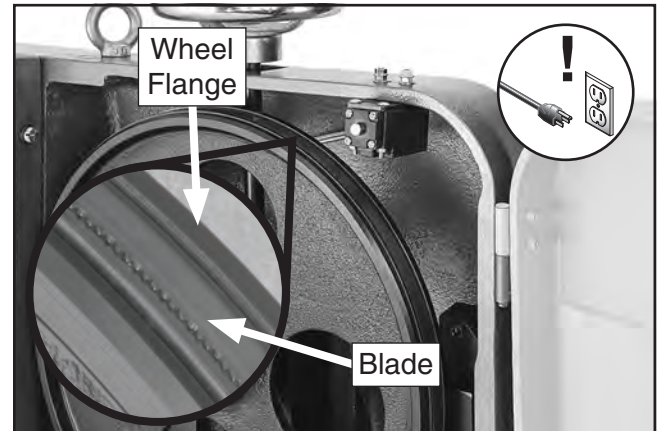


Figure 39. Back edge of blade next to wheel flange.

Note: Excessive blade contact with the wheel flange during operation could lead to blade and wheel damage.

7. Retension the blade (refer to **Tensioning & Tracking Blade** on **Page 23**).
 8. Rotate the top wheel clockwise by hand several times to make sure the blade tracks evenly without wandering across the wheel surface.
- Note:** If the blade wanders across the wheel and away from the flange, the blade tracking alignment may need to be adjusted. Refer to **Tracking Blade** on **Page 23** for detailed instructions.
9. Adjust the upper and lower blade guides (refer to **Adjusting Blade Guide Assemblies** on **Page 25**).

10. Re-install the blade guard.

Note: Ensure the blade guard does not contact upper wheel or blade.

11. Close and secure the upper and lower wheel doors.



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 must endure. Blade breakage is also due to avoidable circumstances. Avoidable blade breakage is most often the result of poor care or judgment 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 or adjustment of the blade guides.
- Being too aggressive when making cuts, or forcing or twisting a wide blade around a tight radius.
- Feeding the workpiece too fast.
- Dull or damaged teeth.
- Over-tensioned blade.
- Top blade guide assembly set too high above the workpiece. Adjust the top blade guide assembly so that there is approximately $\frac{1}{8}$ "– $\frac{1}{4}$ " between the bottom of the assembly and the workpiece.

Note: *The blade guide assembly can be lowered to within 2½" of the table surface.*

- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving the blade tensioned when not in use.
- Using the wrong blade pitch (TPI) for the workpiece thickness. The general rule of thumb is to have no fewer than two teeth in contact with the workpiece at all times during cutting.

Blade Care & Break-In

Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. A bandsaw blade will last longer 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, set, type, and pitch for each application. The wrong blade will produce unnecessary heat and have a shortened life.

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 Break-In

The tips and edges of a new blade are extremely sharp. Cutting at too fast of a feed rate can fracture these tips and edges, causing the blade to quickly become dull. Properly breaking-in a blade allows these sharp edges to wear properly without fracturing, thus keeping the blade sharp longer.

To properly break-in a new blade:

1. Choose the correct speed for the blade and material of the operation.
2. Reduce the feed pressure by half for the first 50–100 in² of material cut.
3. To avoid twisting the blade when cutting, adjust the feed pressure when the total width of the blade is in the cut.
4. Use the **Chip Inspection Chart** on **Page 36** to ensure that the optimal blade speed and feed rate are being used.



Chip Inspection Chart

The best method for choosing the cutting speed and feed rate for a cutting operation is to inspect the chips created by the cut. These chips are indicators of what is commonly referred to as the "chip load." Refer to the chip inspection chart below to evaluate chip characteristics and determine whether to adjust feed rate/pressure, blade speed, or both.









Chip Appearance	Chip Description	Chip Color	Blade Speed	Feed Rate/Pressure	Other Actions
	Thin & Curled	Silver	Good	Good	
	Hard, Thick & Short	Brown or Blue	Increase	Decrease	
	Hard, Strong & Thick	Brown or Blue	Increase	Decrease	
	Hard, Strong, Curled & Thick	Silver or Light Brown	Good	Decrease Slightly	Check Blade Pitch
	Hard, Coiled & Thin	Silver	Increase	Decrease	Check Blade Pitch
	Straight & Thin	Silver	Good	Increase	
	Powdery	Silver	Decrease	Increase	
	Coiled, Tight & Thin	Silver	Good	Decrease	Check Blade Pitch

Figure 40. Chip inspection chart.



Positioning Guide Post

The guide post assembly is used for two purposes: 1) To properly position the blade guard to protect the operator from the exposed blade between the workpiece and the upper wheel housing, and 2) to position the upper blade guides close to the workpiece for maximum blade support.

To properly position the guide post:

1. DISCONNECT BANDSAW FROM POWER!
2. Hold the guide post knob with one hand and loosen the guide post lock knob with the other (see **Figure 41**).

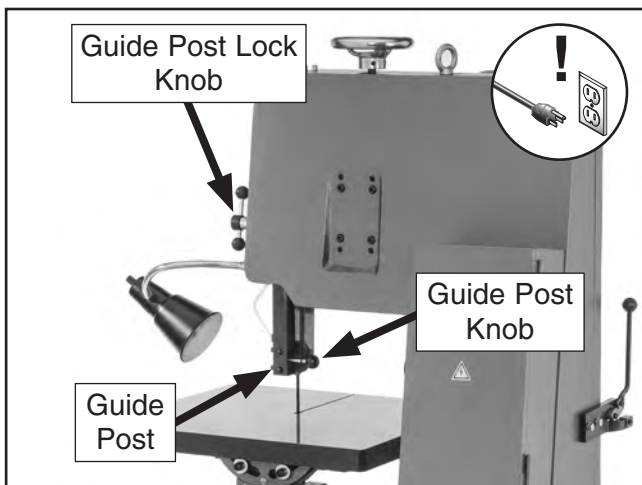
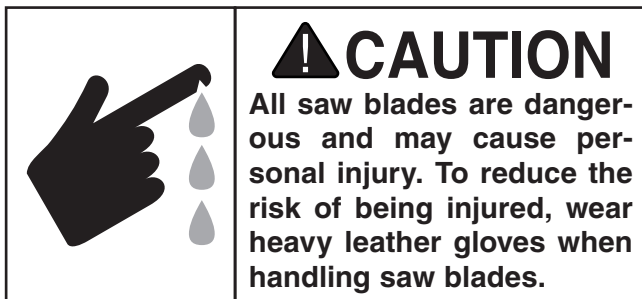


Figure 41. Guide post assembly.

3. Position the bottom of the upper blade guides approximately $\frac{1}{8}$ "– $\frac{1}{4}$ " above the workpiece, then retighten the lock knob to secure the setting.



Adjusting Table Tilt

The bandsaw table tilts 15° to the left and 15° to the right for basic cut angles, and 10° to the front and 10° to the back for feed angles. When used together, compound angled cuts can be made.

Tools Needed	Qty
Hex Wrench 6mm.....	1
Hex Wrench 8mm.....	1

To tilt the table left or right:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the two cap screws on the cut angle trunnion underneath the rear of the table (see **Figure 42**).

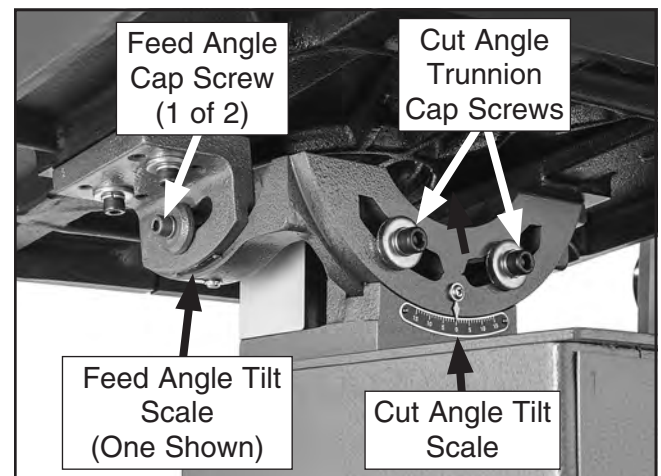


Figure 42. Table tilt adjustment controls.

3. Using the cut angle tilt scale, adjust the angle of the table for your operation, then retighten the cap screws.

To tilt the table forward or backward:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen both cap screws on the two feed angle tilt scale brackets (see **Figure 42**).
3. Using the scales, adjust the angle of the table for cutting a compound angle, then retighten the cap screws.



Blade Welding

Being able to quickly and safely weld a bandsaw blade comes in handy for the following situations:

- To re-join a blade that has been purposely cut for making an internal contour cut.
- To repair a broken blade that is still sharp and useful.
- To make a new blade from a roll of bulk blade banding.

Your metal cutting bandsaw is equipped with a blade welder that uses electrical current to heat and fuse the blade ends together. This process will leave the joint brittle, so an annealer is also included to give the blade strength and flexibility.

!WARNING

The electric current that flows through the blade welder during operation could cause serious personal injury or death. To reduce the risk of electrocution or burns, never touch any metal part of the welding station or blade during welding or annealing.

To weld the ends of a blade together:

1. Turn the bandsaw motor **OFF**.
2. Place the blade evenly against the back of the blade shear and firmly pull the handle down to square off the blade end (see **Figure 43**).



Figure 43. Using the blade shear to cut the blade.

Note: To make a proper blade weld, the ends of the blade must be evenly butted together during the welding process. If necessary, use the grinder to square up the ends or remove any teeth that are in the welding zone (see **Figures 44–45**).



Figure 44. Using the grinder to square up the blade end.

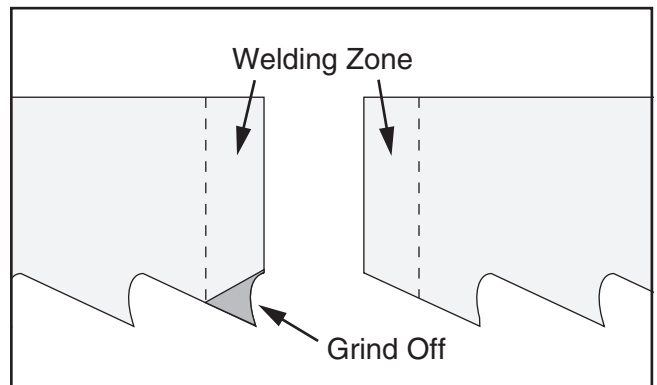


Figure 45. Blade ends and welding zone.

NOTICE

For good metal-to-metal contact between the welding clamps and the blade, make sure the blade material and the clamps are free from any debris or flashing before each use.

3. To ensure correct electrical continuity while welding, use mineral spirits to clean off all oil and debris from the first 6" of each end of the blade.
4. Turn the clamping pressure dial fully clockwise (see **Figure 46** on **Page 39**).



- Loosen the welding clamps by rotating the lock levers down.
- Position the back of one blade end evenly against the back of the welding clamp so that the end is midway between the two clamps, then rotate the lock lever as far up as possible to hold the blade end in place (see **Figure 46**).

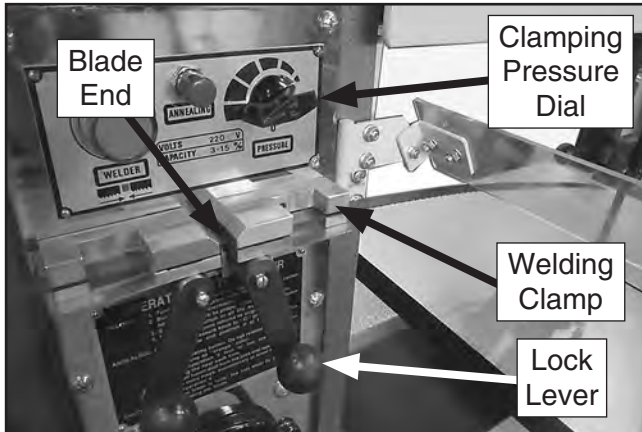


Figure 46. Blade end properly positioned in welding clamp and locked in place.

- Use the illustration in **Figure 47** and set the correct clamping pressure setting for width of the blade.

Note: The clamping pressure presses the blade ends together to help form a strong weld. The pressure scale is an approximation only. If you have difficulty getting satisfactory welds, experiment by increasing or decreasing this pressure.

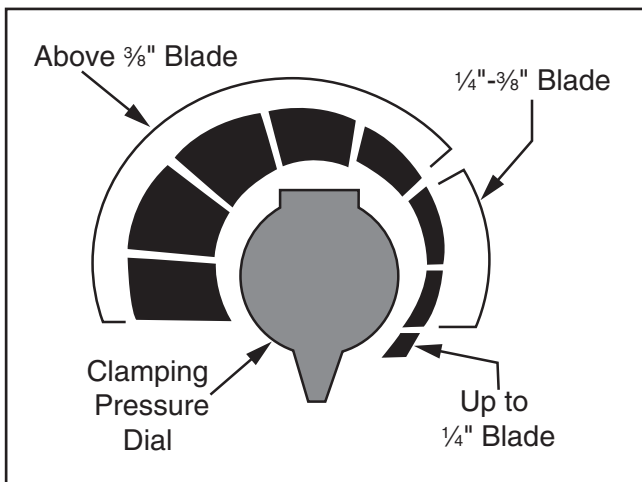


Figure 47. Blade clamping settings.

- Place the other blade end in the opposite welding clamp and position it so that it evenly butts up against the opposing blade end, then lock it in place by rotating the lock lever all the way up, as shown in **Figure 48**.

Note: For a good blade weld, it is critical that the blade ends evenly butt up against each other without overlap, gaps, or misalignment.

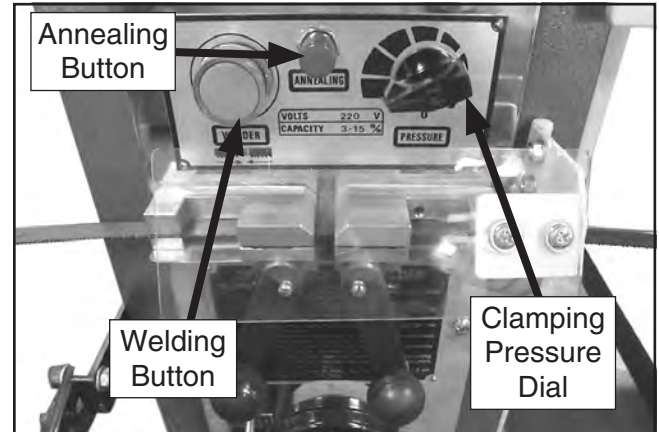


Figure 48. Blade ends in correct position for welding.

! WARNING

Light generated during the welding process could cause serious eye damage. To reduce your risk, always use eye protection approved for welding when using the blade welder.

! CAUTION

Burning sparks may be thrown in all directions while welding. Protect yourself from injury by not welding near flammables and wearing spark-resistant clothing/gloves. Keep fire extinguishing equipment readily available.

- Press and hold the welding button until the blade joint returns to the original color. **IMPORTANT:** Releasing the welder button immediately may cause weld failure.
- Allow the blade to cool, rotate the lock levers down to release the welding clamps, then rotate the clamping pressure dial fully clockwise.



11. Inspect the weld. The welded joint should be even across the width of the blade with no gaps (see **Figure 49**).

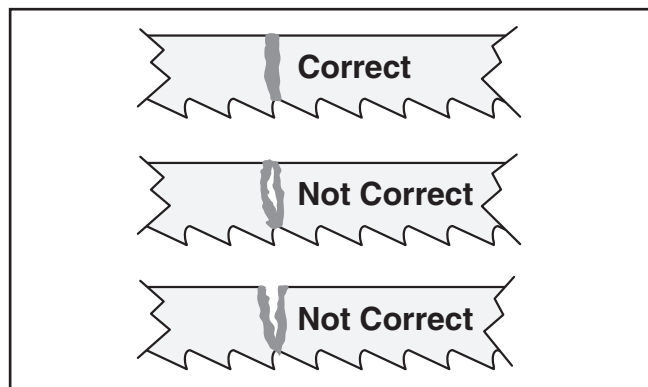


Figure 49. Blade welded joint examples.

- If the weld is satisfactory, continue to **Step 12**.
- If the weld is NOT satisfactory, begin again at **Step 2**.

12. Place the blade in the welding clamps with the weld centered between the clamps and retighten the lock levers.

Note: *The welding operation leaves the blade joint brittle. Annealing allows the material to cool in a gradual manner, giving the weld strength and flexibility. When annealing, the blade is heated until it turns a specific color that is determined by the blade material. The annealing process is unsuccessful (blade breaks easily) if the weld is not heated enough or if it is heated too much. For best results, contact the blade manufacturer for the proper annealing color.*

13. Press and hold the annealing button until the weld zone turns the appropriate color, then release the button.

Note: *If you cannot get the proper annealing color from the blade manufacturer, use the recommendations below as a baseline and experiment from there.*

- Carbon Steel..... Dull Cherry Red
- Carbon Steel Hard Back..... Blue
- Bi-Metal Orange
- High Speed Steel..... Dull Cherry Red

14. Repeat **Step 13** three to four more times, allowing the weld to cool for about 30 seconds between each repetition. Each time reduce the amount of time you press the anneal button, to successively reduce the amount of heat.

15. Allow the blade to cool, then re-inspect the weld.

16. Grind away the weld bead on the top and bottom of the joint so that the blade is flat and will run smoothly on the wheels and between the blade guides.

Note: *Make sure not to grind the teeth or blade body, or overheat the blade during grinding—this will weaken the blade. A small amount of ticking sounds is acceptable during cutting operations.*

17. Re-clamp the blade in the welding clamps with the joint centered, then repeat the annealing process twice more. Each time gradually reduce the amount of time you anneal the weld.

18. Test the strength and flexibility of the weld by bending the blade in an arc similar to that of the bandsaw wheels. The blade should bend in a smooth circular, rounded shape—rather than a pointed fold (see **Figure 50**).

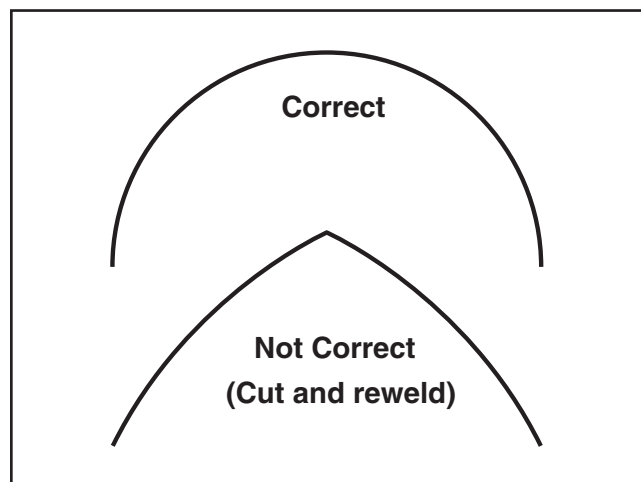


Figure 50. Correct blade weld bend for strength and flexibility.



SECTION 5: ACCESSORIES

! WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

G0807 Replacement Blades (140", Bi-Metal)

Model	Length	Width	TPI	Gauge
T24351	140"	1/4"	6 Hook	0.025
T24352	140"	1/4"	10-14 VP	0.025
T24353	140"	1/2"	10-14 VP	0.025

H7435—Leather Welding Apron w/42" Bib

This Kevlar double-stitched bib-style apron provides complete front body protection. Adjustable neck strap for a comfortable fit and two chest pockets for easy access to welding accessories.



Figure 51. H7435 Welding Apron.

H5408—Blade Tensioning Gauge

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



Figure 52. H5408 Blade Tensioning Gauge.

H7787—Welding Helmet

This full face mask Welding Helmet conforms to ANSI standard Z87.1 and has a flip-up protective lens, adjustable suspension head gear, and tension adjustment screws for just the right head nod action. Made of impact-resistant polypropylene.

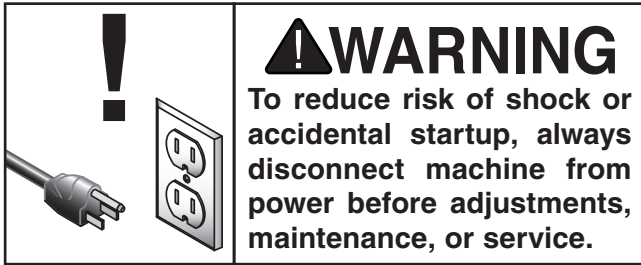


Figure 53. H7787 Welding Helmet.

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



SECTION 6: MAINTENANCE



Schedule

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

Daily:

- Check/correct loose mounting bolts.
- Check/correct damaged or dull saw blade.
- Check/correct worn or damaged wires.
- Clean/protect table.
- Clean metal chips from upper and lower wheel areas, and empty the chip chute.
- Correct any other unsafe condition.

Monthly:

- Check for V-belt tension, damage, or wear (**Page 45**).
- Lubricate tension leadscrews and guide post rack.
- Remove the blade and clean the wheels.

Yearly:

- Open rear lower access panel, inspect belts, and tighten all fasteners (see **Page 45**).

Cleaning & Protecting

Use a brush and a shop vacuum to remove chips and other debris from the machine. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 41** for more details).

Once a month, remove the blade and thoroughly clean all metal chips or oil from the wheel surfaces. Redress the rubber tires if they become glazed.

When cleaning the wheel areas, empty and clean the chip chute and brush (see **Figure 54**).

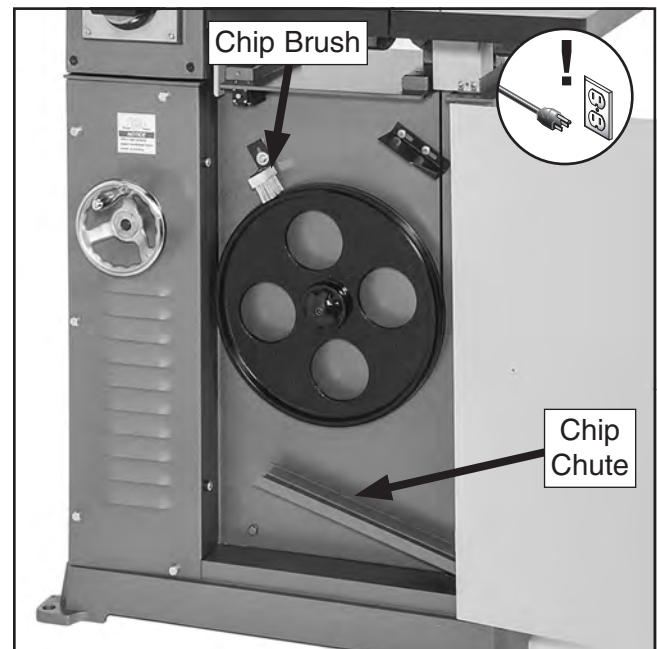


Figure 54. Lower wheel and chip chute.



Lubrication

The bearings on your bandsaw are factory lubricated and sealed. Leave them alone unless they need to be replaced.



Use the schedule below and the following instructions to properly lubricate the other components that require lubrication.

Items Needed	Qty
NLGI#2 Grease or Equivalent	As Needed
Grease Gun.....	1
Mineral Spirits.....	As Needed
Clean Shop Rags	As Needed
Light Machine Oil.....	As Needed
Air Tool Oil.....	As Needed

Tension Leadscrew

Grease Type	T26419 or NLGI#2 Equivalent
Amount	Light Coat Pumps
Lubrication Frequency	Every 80 Hours

To lubricate the tension leadscrew:

1. Remove the blade.
2. Rotate the blade tension handwheel clockwise to fully expose the tension leadscrew (see **Figure 55**).

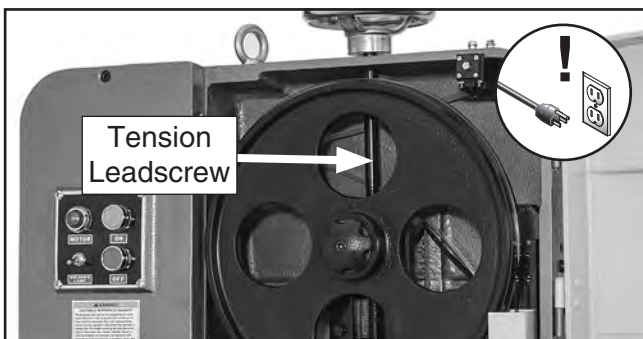


Figure 55. Upper wheel leadscrew lubrication.

3. Use shop rags and mineral spirits to clean away any grease or grime from the leadscrew threads and the surrounding area.
4. Use a clean shop rag to apply a thin coat of NLGI#2 grease or equivalent. Make sure to rub the grease into the threads.
5. Re-install and retension the blade and check/adjust the blade tracking (refer to **Page 23** for detailed instructions).

Drive System

T26419 or NLGI#2 Equivalent	2–4 Pumps
Light Machine Oil.....	1 or 2 Squirts
Lubrication Frequency	Every 80 Hours

To lubricate the drive system:

1. Remove the lower rear access panel, and use shop rags and mineral spirits to clean away any grease or grime from the grease fittings (see **Figure 56**). This will ensure the new grease is not contaminated.

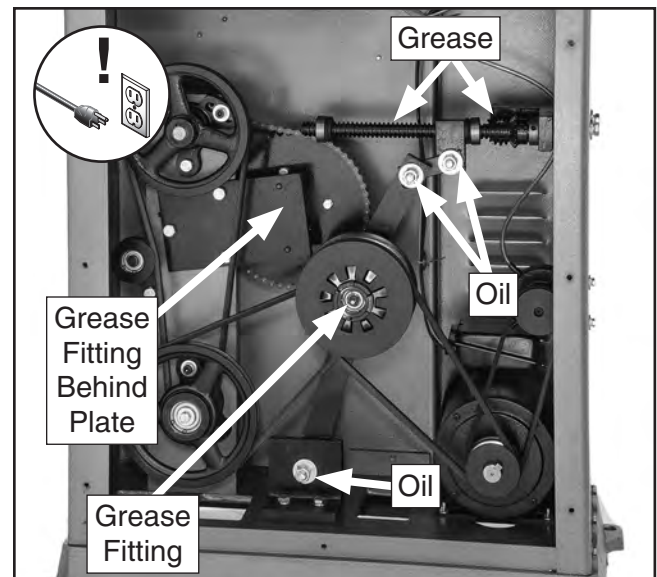


Figure 56. Drive system lubrication points.

2. Use a grease gun to add 2-4 pumps of NLGI#2 grease or equivalent to the fittings, then wipe away any excess grease from the fittings or pulley.
3. Lubricate the hinge points (see **Figure 56**) with oil.
4. Re-install the lower rear access panel.



Trunnion Sliding Surfaces

Grease Type T26419 or NLGI#2 Equivalent
Amount Thin Coat
Lubrication Frequency As Needed

If the table becomes difficult to tilt, position it so that you can brush a thin coat of multi-purpose grease on the trunnion sliding surfaces (see **Figure 57**), then move the table back and forth to distribute.

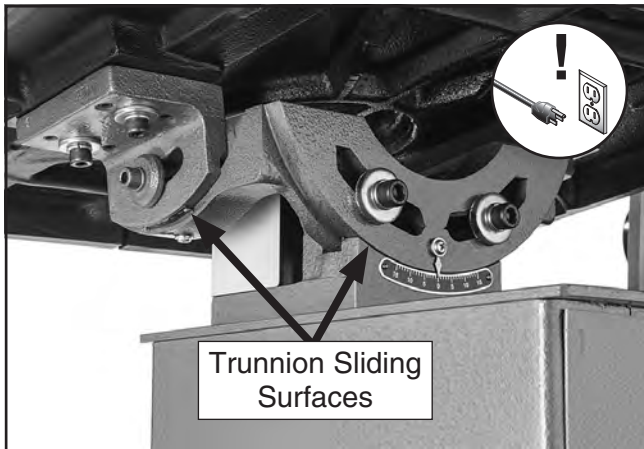


Figure 57. Trunnion lubrication.

Guide Post Sliding Surfaces

Oil Type Light Machine Oil
Amount Thin Coat
Lubrication Frequency Occasionally

The sliding surfaces on the guide post (see **Figure 58**) may occasionally need to be lubricated if the movement becomes stiff.

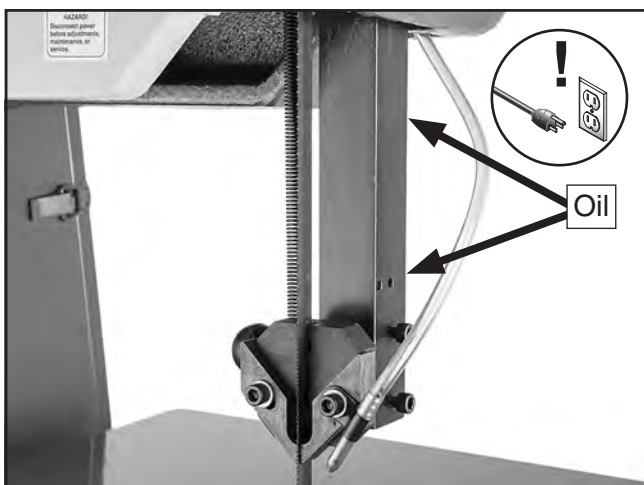


Figure 58. Guide post lubrication location.

Air Pump

Oil Type Air Tool Oil
Amount Four Drops
Lubrication Frequency Every 4 Hours

To lubricate the air pump:

1. Open the rear access panel.
2. Remove the air line from the fitting (see **Figure 59**), add two drops of quality air tool oil to the fitting, then re-install the air line.

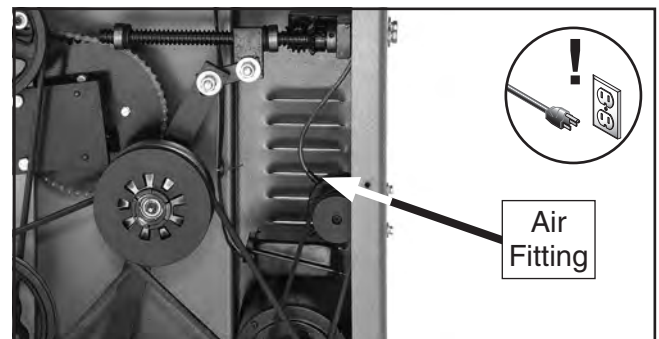


Figure 59. Drive system lubrication points.

3. Clean away any oil from outside the air pump, bandsaw frame, or floor.
4. Close and secure the rear access panel.

Dressing Grinding Wheel

Periodically dress the grinding wheel to square it up and renew the abrasive surface. Dressing is done in the same manner as a typical grinding operation but using a diamond-tipped dressing tool (see **Figure 60**).

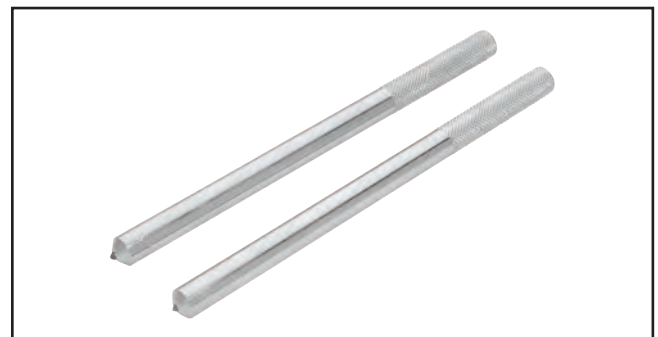


Figure 60. Example of diamond dressing tools.



Tensioning/ Replacing V-Belts

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

Check V-belt tension at least once every three months—more often if the bandsaw is used daily. V-belts stretch with use and must be periodically retensioned. Replace the V-belts if they are cracked, frayed, or badly worn. Refer to **Figure 61** to identify V-belt locations.

Tools Needed	Qty
Wrench/Socket 10mm	1
Wrench/Socket 13mm	1
Wrench/Socket 17mm.....	1
Hex Wrench 6mm.....	1

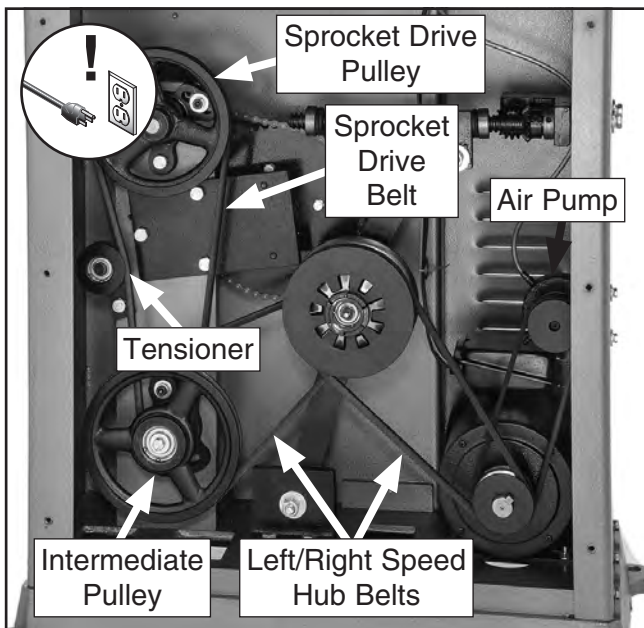


Figure 61. System belt and pulley layout.

To check/tension/replace the V-belts:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the rear motor access panel.
3. Push the center of each V-belt with moderate force. When tensioned correctly, there should be approximately $\frac{3}{16}$ " of deflection. DO NOT overtighten the belts or the bearings will wear prematurely.

Speed Hub Belts

Rotate the speed handwheel left or right until the belts are loose. Roll the belts off the pulleys to replace them. (If you get them mixed up when replacing, the belt on left is the larger of the two.)

Note: *When the machine is started, the belts will automatically adjust to the correct tension.*

Sprocket Drive Belt

Loosen the tensioner hex bolt, then loosen the three intermediate pulley retaining cap screws so the belt is loose. Replace the sprocket drive belt. Retighten the intermediate hub and adjust the tensioner hub to tension the new belt.

Air Pump Belt

Loosen the pump mounting bolts, replace the belt and tension it by positioning the air pump, then tighten the mounting bolts.

Note: *Make sure that when tightened, the pump pulley is aligned with the motor drive pulley.*



Redressing Rubber Tires

As the bandsaw ages, the rubber tires on the wheel may need to be redressed if they become hardened or glazed-over. Dressing the rubber tires improves blade tracking and reduces vibration/blade lead (blade wanders from a straight-line cut).

If the rubber tires become too worn, then blade tracking will become extremely difficult. At that point, redressing will no longer be effective, and the rubber tires must be replaced.

To redress the rubber tires:

1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy gloves and remove the blade (refer to **Page 34**).
3. Use a brush and shop vacuum to clean any chips from the rubber tires.
4. Hold a piece of 100-grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.
5. Check surface area of tire to ensure a uniformly sanded surface.

Machine Storage

All machinery will develop serious rust problems and corrosion damage if it is not properly prepared for storage. If decommissioning this machine, use the steps in this section to ensure that it remains in good condition.

To prepare your machine for storage or decommission it from service:

1. DISCONNECT BANDSAW FROM POWER!
2. Thoroughly clean all unpainted, bare metal surfaces, then coat them with a light weight grease or rust preventative. Take care to ensure these surfaces are completely covered but that the grease or rust preventative is kept off of painted surfaces.

Note: *If the machine will be out of service for only a short period of time, use way oil or a good grade of medium-weight machine oil (not auto engine oil) in place of the grease or rust preventative.*

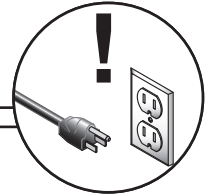
3. Loosen or remove the belts and blade so they do not become stretched while the machine is out of use. Tag the machine to indicate that the belts and blade are loose.
4. Completely cover the machine with a tarp or plastic sheet that will keep out dust and resist liquid or moisture. If machine will be stored in/near direct sunlight, use a cover that will block the sun's rays.



SECTION 7: SERVICE

Review the troubleshooting and 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. Door/cover left open. 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped or fuse blown. 4. Motor wires connected incorrectly. 5. Wiring open/has high resistance. 6. ON/OFF switch at fault. 7. Start capacitor at fault. 8. Run capacitor at fault. 9. Door safety/limit switch at fault. 10. Thermal overload relay has tripped/at fault. 11. Contactor not energized; at fault. 12. Motor at fault. 	<ol style="list-style-type: none"> 1. Close door. 2. Ensure correct power supply voltage and circuit size. 3. Ensure circuit is sized correctly and free of shorts; reset circuit breaker or replace fuse. 4. Correct motor wiring connections. 5. Check/fix broken, disconnected, or corroded wires. 6. Replace switch. 7. Test/replace. 8. Test/replace. 9. Replace door safety/limit switch. 10. Allow to cool and reset; replace if at fault. 11. Test all legs and ensure good contacts; replace if at fault. 12. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Feed rate/cutting speed too fast. 2. Machine undersized for task. 3. Wrong workpiece material for saw/blade. 4. Blade is not correct for material being cut. 5. Workpiece is binding against blade. 6. Blade slipping on wheels. 7. Belt(s) slipping. Oil/grease on belt(s). 8. Motor overheated. 9. Motor wired incorrectly. 10. Dull blades. 11. Pulley/sprocket slipping on shaft. 12. Contactor not energized; at fault. 	<ol style="list-style-type: none"> 1. Decrease feed rate/cutting speed. 2. Use correct, sharp blade; reduce feed rate/depth of cut; use lubricant if necessary. 3. Only cut correct material for saw blade/type. 4. Use the correct blade for the operation. Refer to Blade Selection section beginning on Page 31. 5. Maintain better workpiece control, or cut workpiece with different technique or machine. 6. Adjust blade tracking and tension (Page 23). 7. Tension/replace belt(s) (Page 45). Clean belt(s). 8. Clean motor, let cool, and reduce workload. 9. Wire motor correctly (Page 55). 10. Replace blades (Page 34). 11. Replace loose pulley/shaft. 12. Test all legs and ensure good contacts; replace if at fault.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Blade at fault. 3. V-belt(s) worn or loose. 4. Motor fan rubbing on fan cover. 5. Pulley loose or misaligned. 6. Machine incorrectly mounted. 7. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Retighten/replace damaged bolts/nuts. 2. Replace warped/bent blade. 3. Inspect/replace belts with a new matched set. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Re-align pulley/replace pulley set screw and key. 6. Tighten mounting bolts; relocate/shim machine. 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.



Cutting Operations

Symptom	Possible Cause	Possible Solution
Vibration when cutting.	<ol style="list-style-type: none"> 1. Workpiece is loose. 2. Loose or damaged blade. 3. Metal chip buildup on wheels. 4. Worn wheel bearing. 5. Wheel tires worn or incorrectly installed. 6. Loose/damaged, or bent/dull blade. 7. Wheels out of balance. 8. Loose machine component. 9. Belt has a high spot. 10. Blade wheel is out of balance. 11. Motor at fault. 	<ol style="list-style-type: none"> 1. Use the correct holding fixture and reclamp workpiece. 2. Re-tension or replace blade (Page 34). 3. Clean metal chips from wheels. 4. Check/replace wheel bearing. 5. Replace or dress rubber tires (Page 45). 6. Re-tension/replace blade (Page 34). 7. Replace wheels. 8. Tighten loose component. 9. Replace/adjust the V-belt (Page 45). 10. Replace bad wheel. 11. Test/repair/replace.
Ticking sound when the saw is running.	<ol style="list-style-type: none"> 1. Blade weld contacting blade guide/support (a light ticking is normal). 2. Blade weld may be failing. 	<ol style="list-style-type: none"> 1. Inspect/re-grind blade weld (Page 38); readjust blade support/guides (Page 25). 2. Inspect weld and re-weld blade if necessary (Page 38), or replace blade (Page 34).
Machine or blade bogs down in the cut.	<ol style="list-style-type: none"> 1. Feeding workpiece too fast. 2. V-belts slipping from improper tension, oil/grease or wear. 3. Blade is loading up. 4. Blade is dull, wanders, and gets pinched in the cut. 5. The blade TPI is too coarse. 6. Blade is loose. 7. Material requires cutting fluid/lubrication. 	<ol style="list-style-type: none"> 1. Reduce feed rate/increase blade speed. 2. Tighten/clean/replace V-belt(s) (Page 45). 3. Install a blade with more suitable TPI or different style of teeth (Page 31). 4. Replace blade, adjust guides and tracking (see Page 23). 5. Use a blade with at least 2 teeth contacting the material at all times (Page 31). 6. Clean wheels and increase blade tension (Page 23). 7. Use applicable cutting fluid/lubricant.
Cuts are not square, or the intended angle is incorrect.	<ol style="list-style-type: none"> 1. Pointer or scale not calibrated, or loose table. 2. Table guide post is loose or out of alignment. 	<ol style="list-style-type: none"> 1. Calibrate table (Page 50). Tighten any loose fasteners. 2. Tighten any loose hardware or lock levers. Align the guide post (Page 51).
Blade dulls prematurely, or metal sticking to the blade.	<ol style="list-style-type: none"> 1. Blade is improperly broken in. 2. The blade gullets are loading up with chips. 3. Blade TPI is too fine for thick workpiece, and teeth load up and overheat. 4. The workpiece has hard spots, welds, or scale. 	<ol style="list-style-type: none"> 1. Replace blade, and complete blade break-in procedure (Page 35). 2. Use a blade that has larger gullets to carry out material. 3. Use a coarser-tooth blade, adjust feed rate, adjust blade speed, make sure the blade brush is working. 4. Replace the blade with a special blade for cutting hardened materials.
Handwheel has excessive backlash, endplay, binds, or is difficult to move.	<ol style="list-style-type: none"> 1. Leadscrew dirty; lacks proper lubrication. 2. Bevel gears out of adjustment. 3. Bearing or leadscrew collar is worn or loose. 4. Linkage bolts, pins, and holes are loose or worn. 5. Leadscrew or leadscrew nut worn. 	<ol style="list-style-type: none"> 1. Clean and lubricate the leadscrew (Page 43). 2. Readjust bevel gears to reduce backlash (Page 52). 3. Replace bearing or readjust leadscrew collar (Page 52). 4. Replace linkage bolts, pins, and re-bush any worn pin holes. 5. Replace leadscrew or leadscrew nut.



Symptom	Possible Cause	Possible Solution
Blade tracks incorrectly, or comes off wheels.	<ol style="list-style-type: none"> 1. Feed rate is too fast/wrong TPI. 2. Blade tracking requires adjustment. 3. Blade is bell-mouthed. 4. Blade is dull, wanders, and gets pinched in the cut. 5. Rubber tire(s) on wheel damaged, glazed, or worn. 6. Blade tension is too loose. 7. Blade guides need adjustment. 8. Incorrect blade for bandsaw operation. 9. The blade has insufficient support. 10. Metal chip buildup on wheels. 	<ol style="list-style-type: none"> 1. Reduce feed rate/decrease blade TPI. 2. Adjust blade tracking (Page 23). 3. Install new blade, and regularly remove tension from blade when not in use (Page 23). 4. Replace blade, re-secure the workpiece from shifting. 5. Replace or dress rubber tire(s) (Page 46). 6. Increase blade tension (Page 23). 7. Adjust blade guides (Page 25). 8. Install correct blade for machine (Page 34). 9. Tighten the blade guide as close to the workpiece as possible. 10. Clean metal chips from wheels.
The cut is crooked, the blade wanders, slow cuts, or shows overheating on one side of the cut or the blade.	<ol style="list-style-type: none"> 1. Feed rate is too fast. 2. Too much side pressure when feeding workpiece. 3. Blade is loading up. 4. Blade installed backwards. 5. Dull blade; missing teeth. 6. Blade too wide for size of radius being cut. 7. The blade speed is wrong. 8. The blade tracking is wrong. 	<ol style="list-style-type: none"> 1. Reduce the feed rate. 2. Feed workpiece straight into the blade. 3. Install a blade with more suitable TPI or different style of teeth. 4. Reverse blade if necessary. 5. Replace blade (Page 34). 6. Install a smaller width blade. 7. Adjust blade speed as required. 8. Adjust the blade tracking (Page 23).

Welding Operations

Symptom	Possible Cause	Possible Solution
Grinder does not work.	<ol style="list-style-type: none"> 1. Wiring or grinder ON/OFF switch at fault. 2. Grinder motor at fault. 	<ol style="list-style-type: none"> 1. Repair wiring or replace grinder switch. 2. Replace grinder motor.
Work lamp or welding lamp does not work.	<ol style="list-style-type: none"> 1. Bulb, wiring, or switch at fault. 2. Transformer is at fault. 	<ol style="list-style-type: none"> 1. Replace bulb, repair wiring (Page 55); replace switch. 2. Replace transformer.
Welder is inoperative or welds poorly.	<ol style="list-style-type: none"> 1. Operator error. 2. Wiring or welding switch at fault. 3. Welder transformer at fault. 	<ol style="list-style-type: none"> 1. Use welder as outlined in operations section and practice on scrap blades (Page 38). 2. Repair wiring or replace welding switch (Page 55). 3. Replace welder transformer.
Weld is mis-aligned.	<ol style="list-style-type: none"> 1. Debris or flash on weld clamps or blade. 2. Blade ends not cut off square. 3. Blade ends not evenly butted in clamps. 4. Clamping pressure not set correctly. 	<ol style="list-style-type: none"> 1. Remove debris, oily substances, or flash from weld clamps and blade. 2. Use blade shear to cut blades; grind ends together. 3. Make sure blade ends are evenly butted against each other before securing with lock levers. 4. Set clamping pressure correctly (Page 39).
Weld not complete (has holes)	<ol style="list-style-type: none"> 1. Blade ends not clamped properly. 2. Blade ends not even with each other. 	<ol style="list-style-type: none"> 1. Make sure blade ends are evenly butted against each other in clamps; use correct clamping pressure (Page 39). 2. Use blade shear to cut blades; grind ends together.
Weld breaks or is brittle.	<ol style="list-style-type: none"> 1. Weld not correctly annealed. 2. Weld is ground too thin. 3. Debris or oil in weld. 	<ol style="list-style-type: none"> 1. Correctly perform annealing procedure (Page 40). 2. Only grind flash even with blade body. 3. Make sure clamps and blade ends are clean of debris, oily substances, and flash.



Table Calibration

To ensure the accuracy of angle cuts and compound angle cuts, the scale pointers must point to "0" when the table is perpendicular or 90° to the blade.

Tools Needed	Qty
Hex Wrench 6mm.....	1
Hex Wrench 8mm.....	1
Machinist's Square	1
Phillips Head Screwdriver #2	1

To calibrate the table:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the blade tracking and tension are set correctly.
3. Loosen the trunnion cap screws (see **Figure 62**).

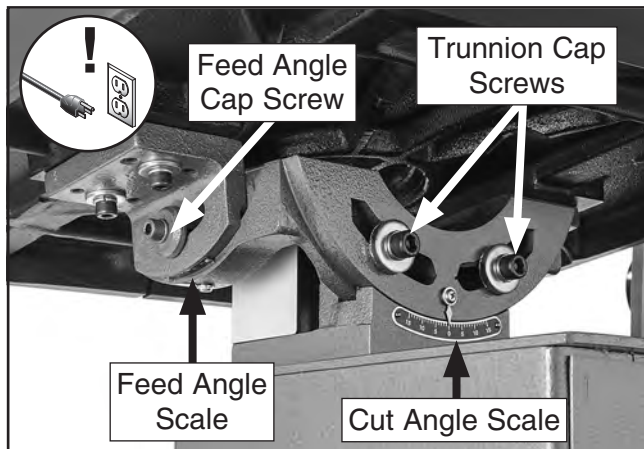


Figure 62. Location of table scales.

4. Place a machinist's square on the table and against the side of the blade, as shown in **Figure 63**.

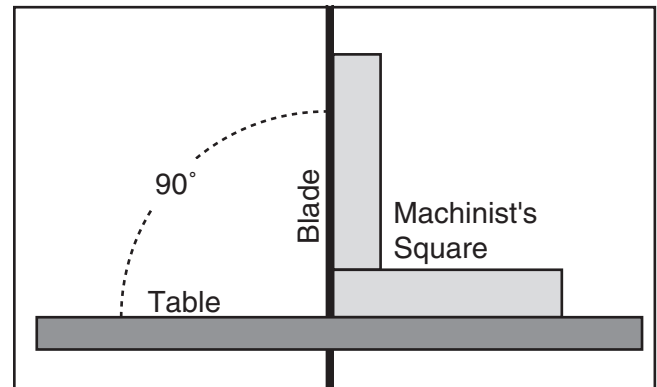


Figure 63. Checking that table is perpendicular to blade.

5. Tilt the table until the blade and table top are perpendicular side-to-side, then tighten the trunnion cap screws.
6. Loosen the scale pointer for the cut angle scale (on the trunnion) and point it to zero.
7. Loosen the feed angle cap screw and place the machinist's square against the back of the blade.
8. Position the table perpendicular to the blade front-to-back.
9. Tighten the feed angle cap screws.
10. Loosen the pointer for the feed angle scale, point it to "0", then retighten it. The table and blade are now calibrated.



Guide Post Alignment

If the blade guide post does not raise and lower exactly parallel with the blade, the clearances between the blade guides and blade will change as the guide post is moved, causing rubbing, wear, and blade deflection. Blade guide clearance must stay the same when the guide post is raised and lowered along its full length of travel.

Tools Needed	Qty
Hex Wrench 5mm.....	1
Hex Wrench 6mm.....	1

To align the guide post:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the blade tracking and tension are set correctly (refer to **Page 23**).
3. Lower the blade guide post to the bottom of its travel and lock it in place.
4. Adjust the blade guides as described on **Page 25**.
5. Unlock the post just enough to allow it to slide, move it all the way up, then examine the clearances between the blade and blade guides to see if they changed.

Note: *If these clearances changed beyond your acceptable tolerances, the blade guide receiver (see **Figure 64**) can be adjusted to fix this condition.*

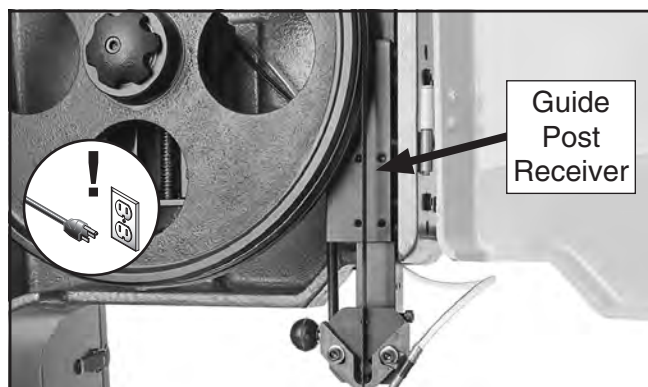


Figure 64. Guide post system.

6. Loosen the four receiver cap screws (see **Figure 65**).

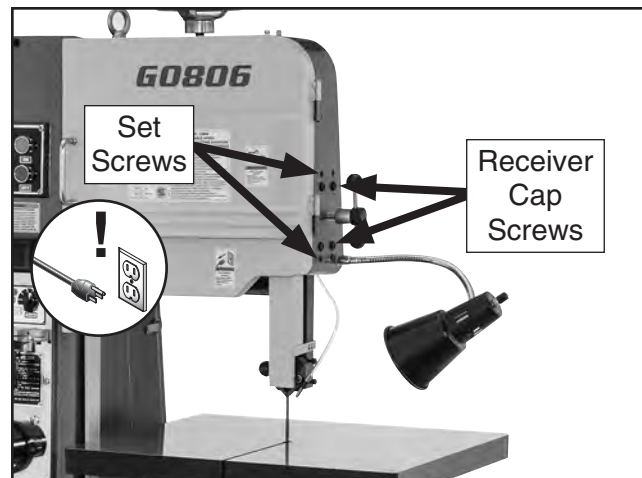


Figure 65. Guide post alignment controls.

7. Adjust the four set screws to tilt the blade guide receiver in the required direction.
8. Tighten the cap screws and recheck blade guide clearance along the guide post path of travel.
9. Repeat this procedure if necessary to fine-tune the guide post travel to acceptable tolerances.



Bevel Gear Backlash

During the life of the machine, the variable-speed handwheel may develop extra backlash due to normal wear of the bevel gears. If this lash becomes unacceptable, use this procedure to reduce the backlash.

Tools Needed	Qty
Hex Wrench 4mm.....	1
Open-End Wrench/Socket 13mm.....	1

To reduce the bevel gear backlash:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the rear lower access panel, and loosen both bevel gear locking set screws (see **Figure 66**) just enough to adjust the bevel gears.

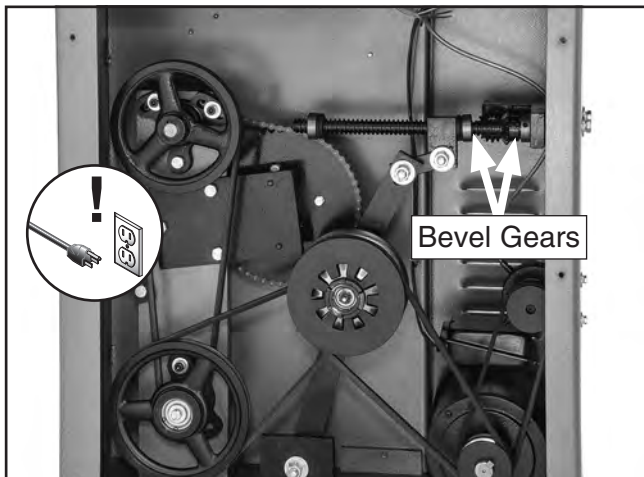


Figure 66. Location of bevel gears.

3. Slide the bevel gears closer together and tighten the set screws. If excess backlash still exists, refer to **Leadscrew End Play**, then proceed to **Step 4**.

Note: Make sure that the set screws remain aligned with the flats on the shaft. If one or both set screws does not return to their original depth in the bevel gear after tightening, the alignment has probably been lost and needs to be corrected.

4. Clean and grease the bevel gears and the leadscrew, then re-install the access panel.

Leadscrew End Play

If you notice that the leadscrew has end play and the variable-speed handwheel has excess backlash after the bevel gear lash has been set, you can adjust the leadscrew collars as an additional measure to reduce the backlash.

Tools Needed	Qty
Hex Wrench 4mm.....	1
Open-End Wrench/Socket 13mm.....	1

To adjust the leadscrew collars:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the rear lower access panel, and loosen both collar locking set screws just enough to adjust the collars (see **Figure 67**).

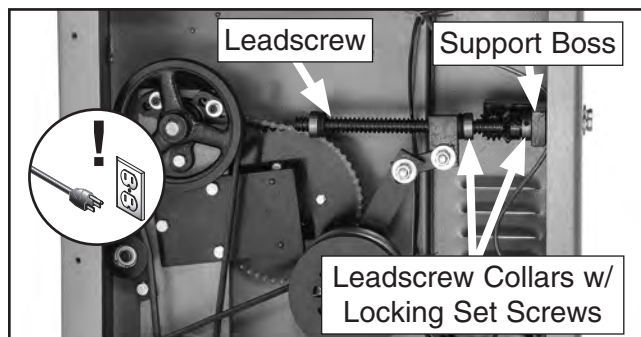


Figure 67. Leadscrew adjustment locations.

3. Slide the right-hand leadscrew collar against the support boss and tighten the set screws. If excess backlash still exists at the handwheel, you may have to readjust the bevel gear lash, replace the leadscrew half nut, or replace worn bolts or linkage (see **Figure 68**).

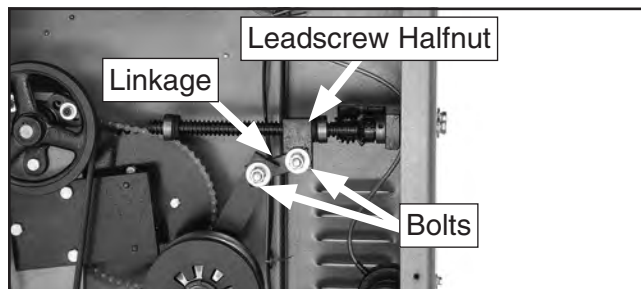


Figure 68. Linkage location and parts.

4. Re-install the access panel.



Replacing Blade Guides & Supports

With use, the faces of the blade guides will wear at an angle and it may become difficult to properly adjust them. If this is the case, swap and turn blade guides over so that they are reversed relative to the blade (see **Figure 69**).

When the blade guides are no longer effective after reversing them, then replace them with new guides (Grizzly Part Number P0806247).

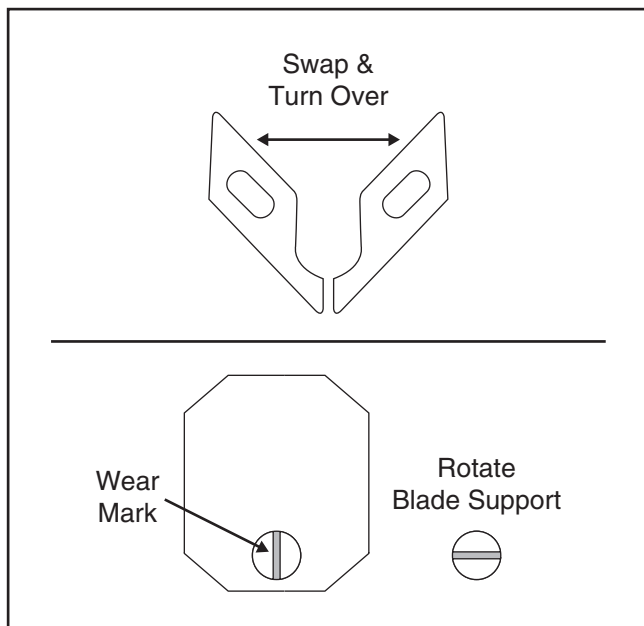


Figure 69. Blade guide and support orientation.

As the blade is deflected back into the blade support during operation, a groove will eventually wear into the blade support. As this groove becomes deeper, it can affect the accuracy of the cut. When this happens, loosen the blade support cap screw and rotate the blade support 90°, as shown in **Figure 69**.

If necessary, the end of the blade support can be ground flat to extend its life. When it becomes too short to properly support the blade, replace it with a new one (Grizzly Part Number P0806249).

Note: Make sure to readjust the blade guides and support as directed in **Adjusting Blade Guide Assemblies** on **Page 25** after making these changes.



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.















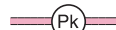
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

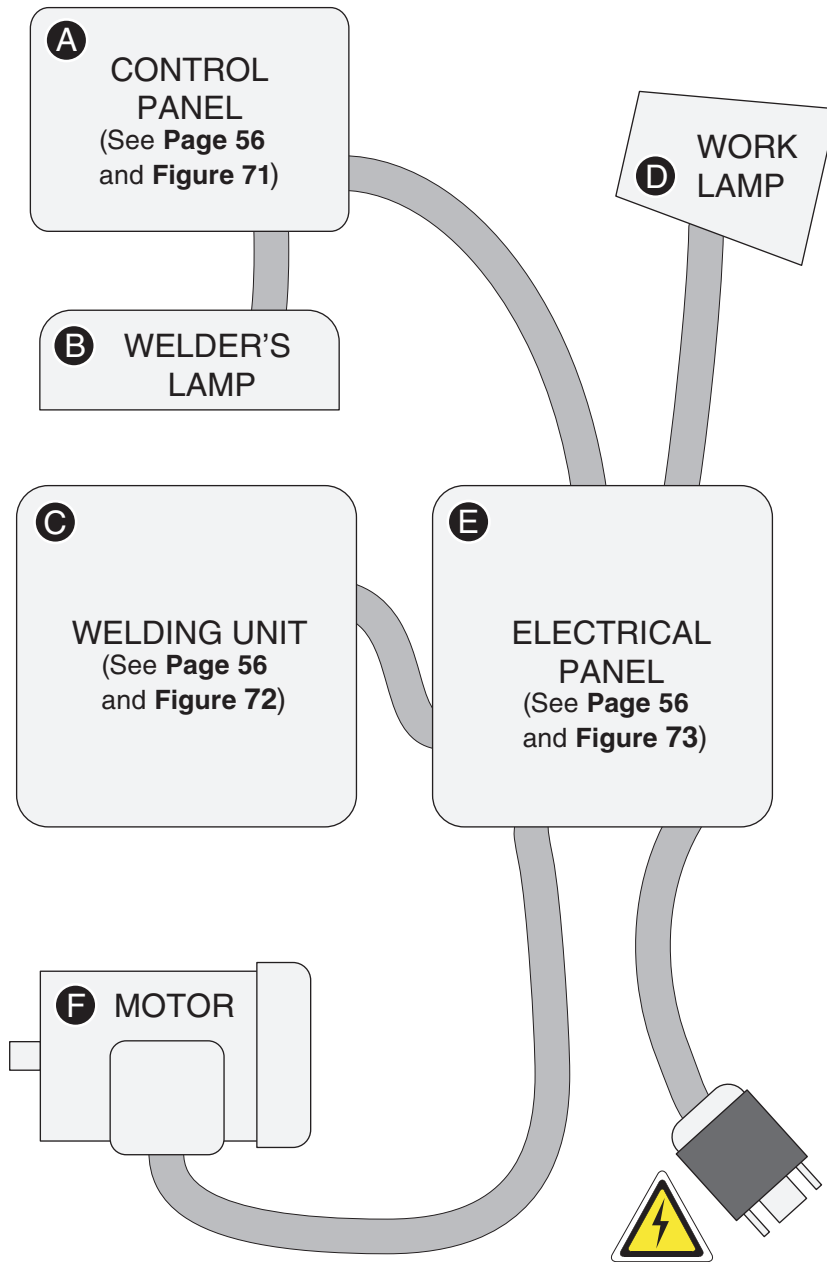
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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



Electrical Overview



*  May Represent Multiple Wires



Electrical Component Pictures

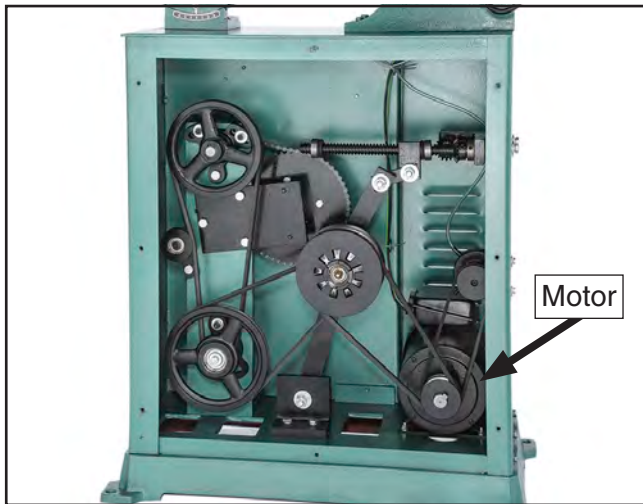


Figure 70. Motor.

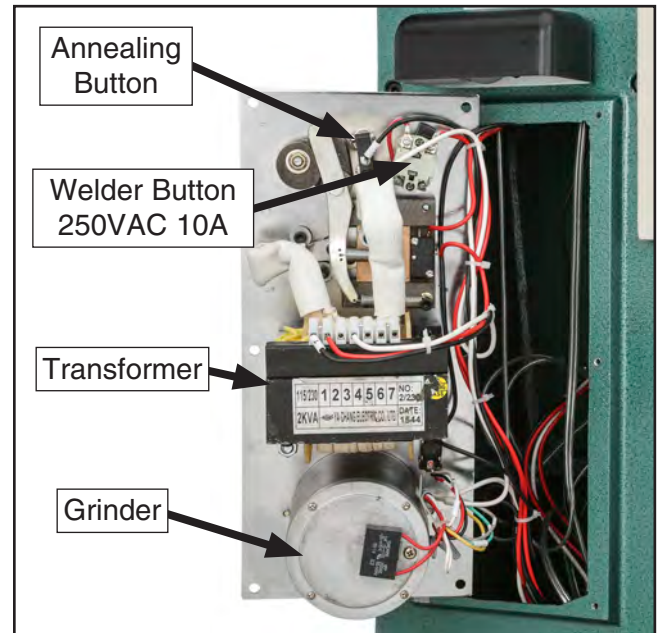


Figure 72. Welding panel.

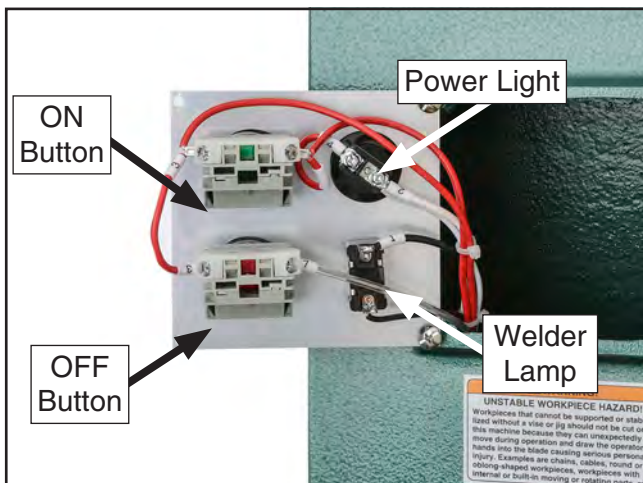


Figure 71. Control panel wiring (viewed from rear).

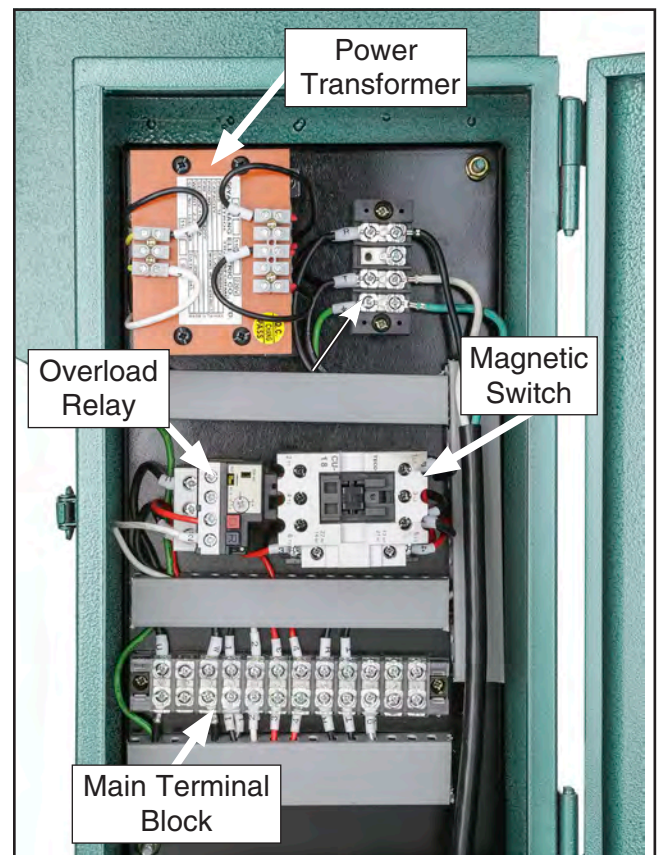
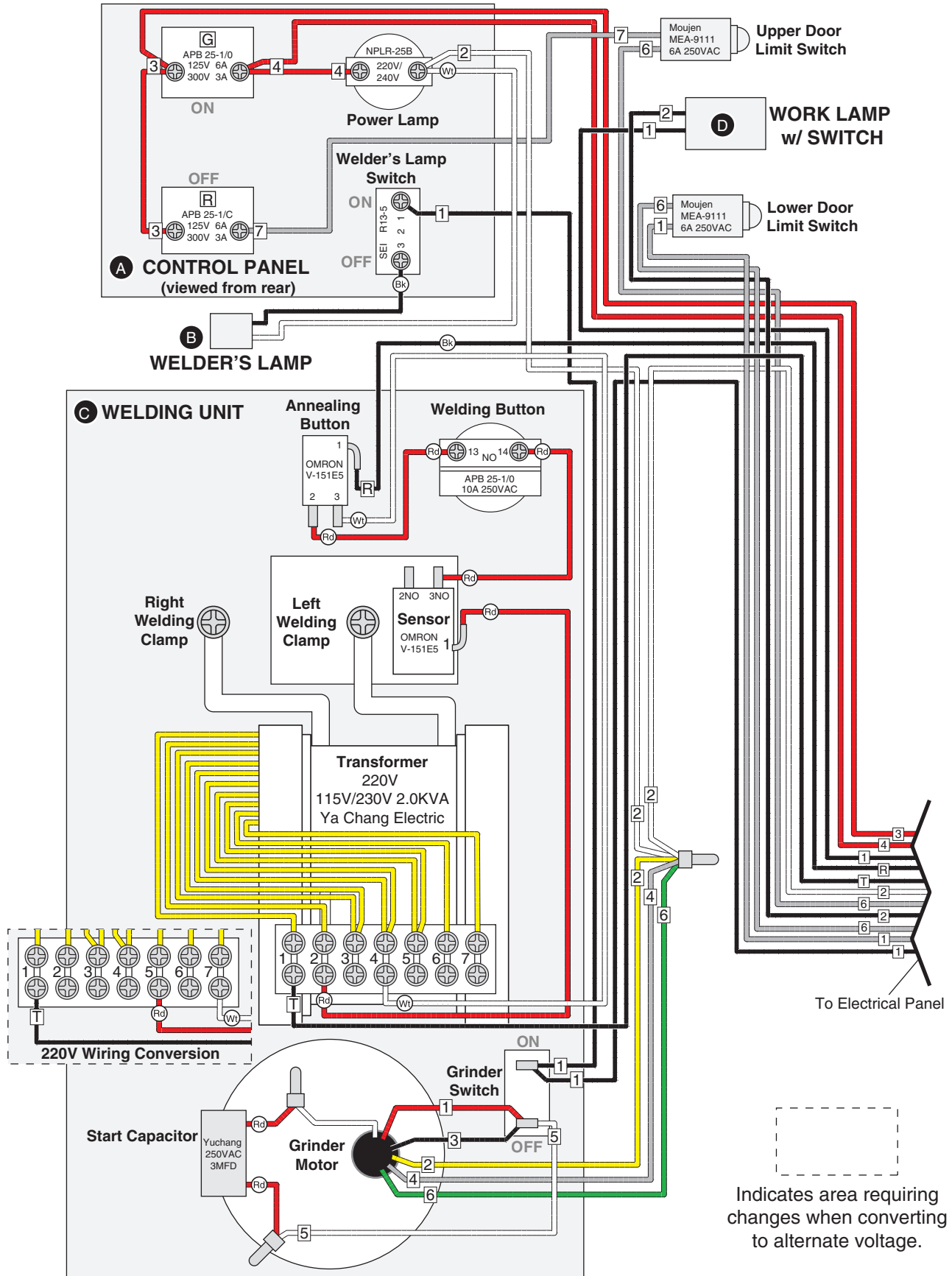


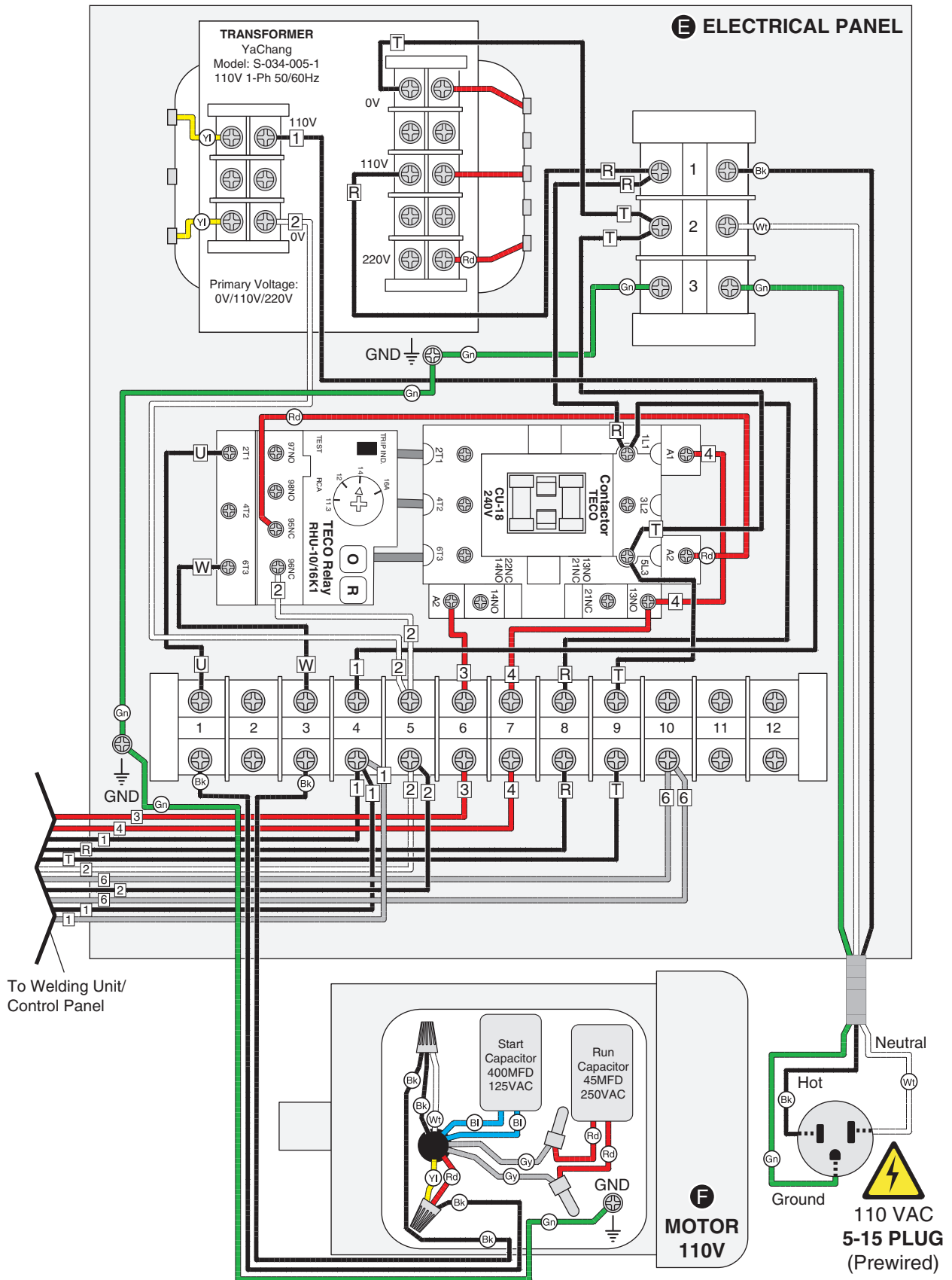
Figure 73. Electrical box.



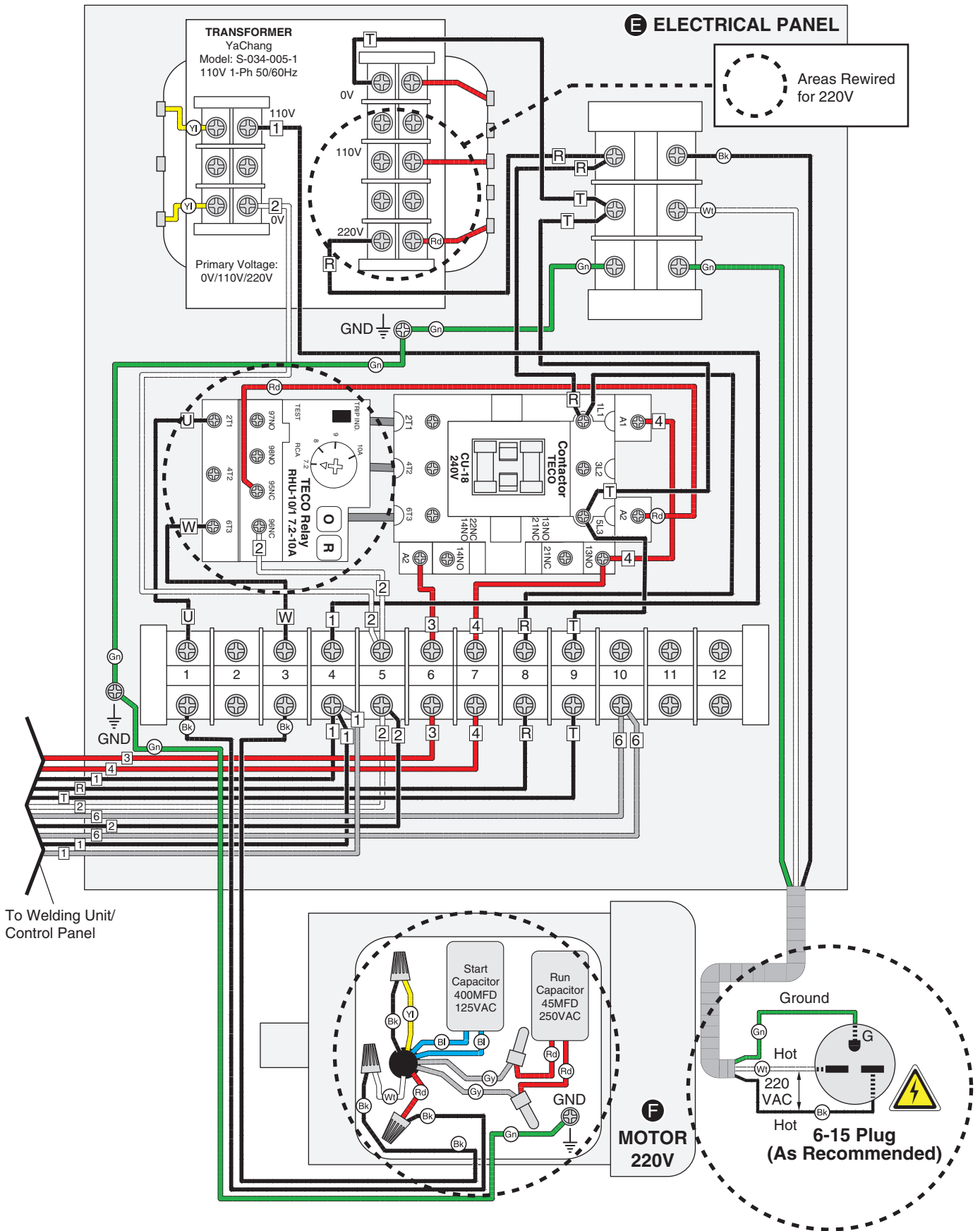
G0806 Control Panel & Welding Unit



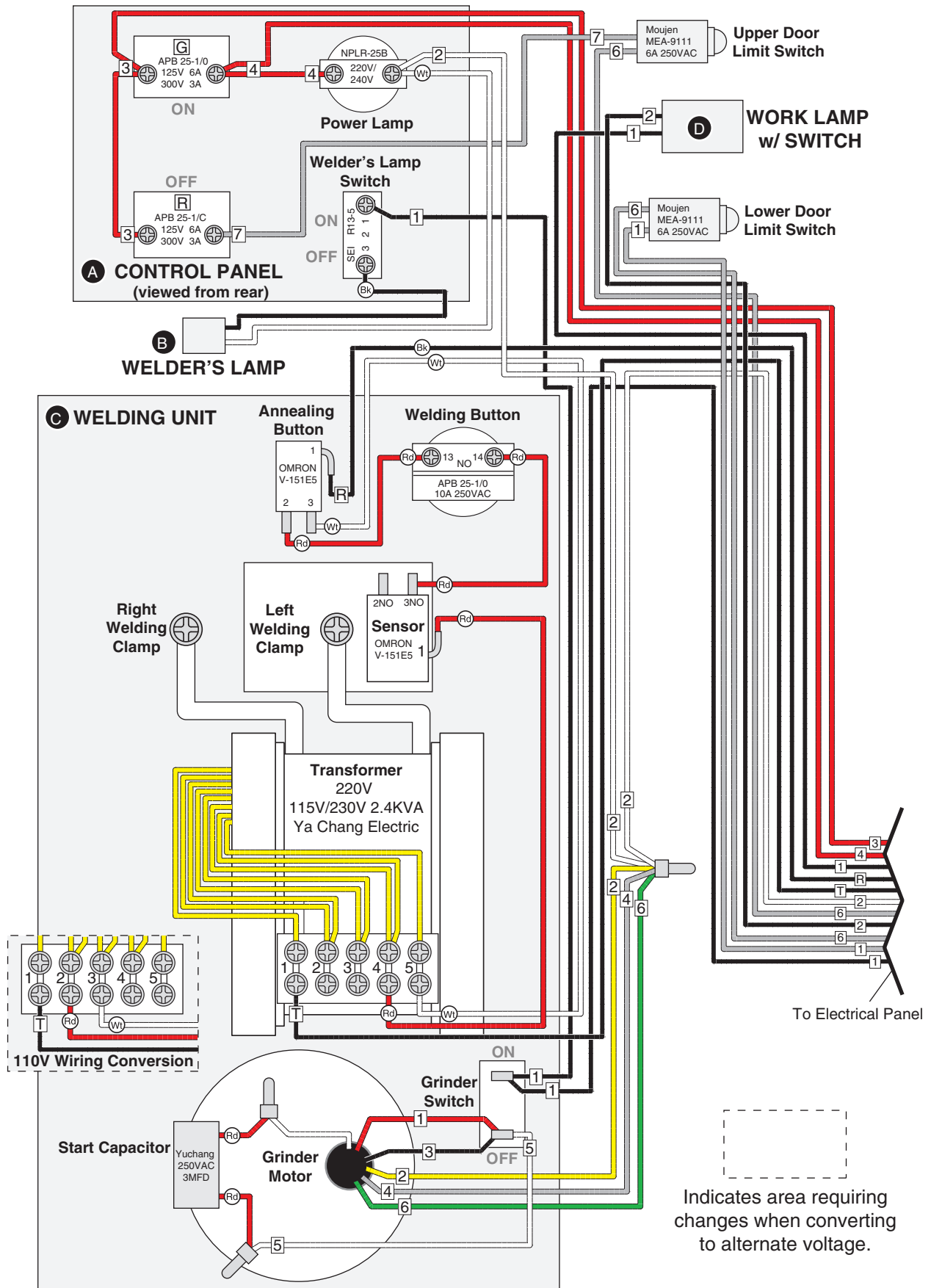
G0806 110V Electrical Panel & Motor



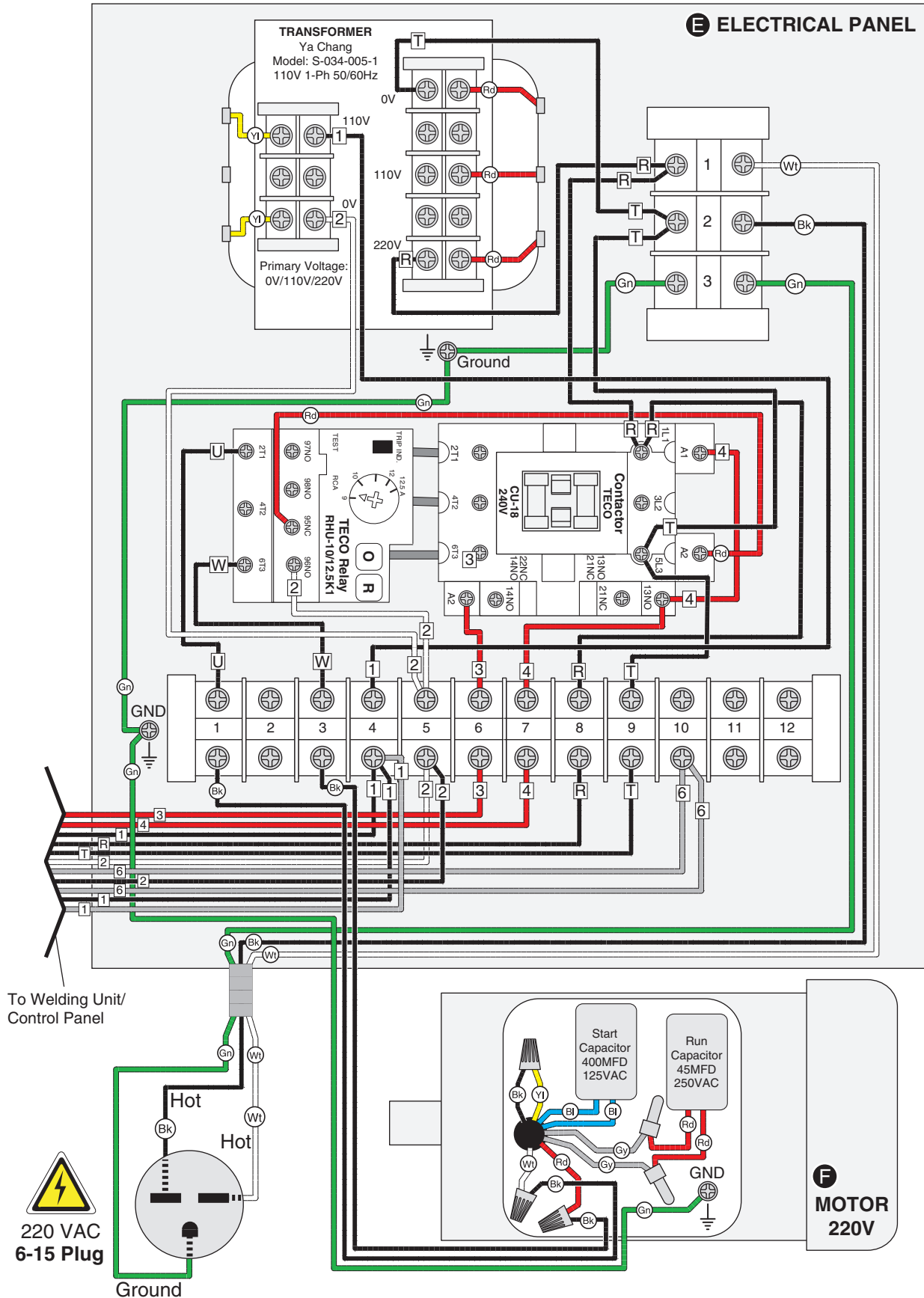
G0806 220V Electrical Panel & Motor



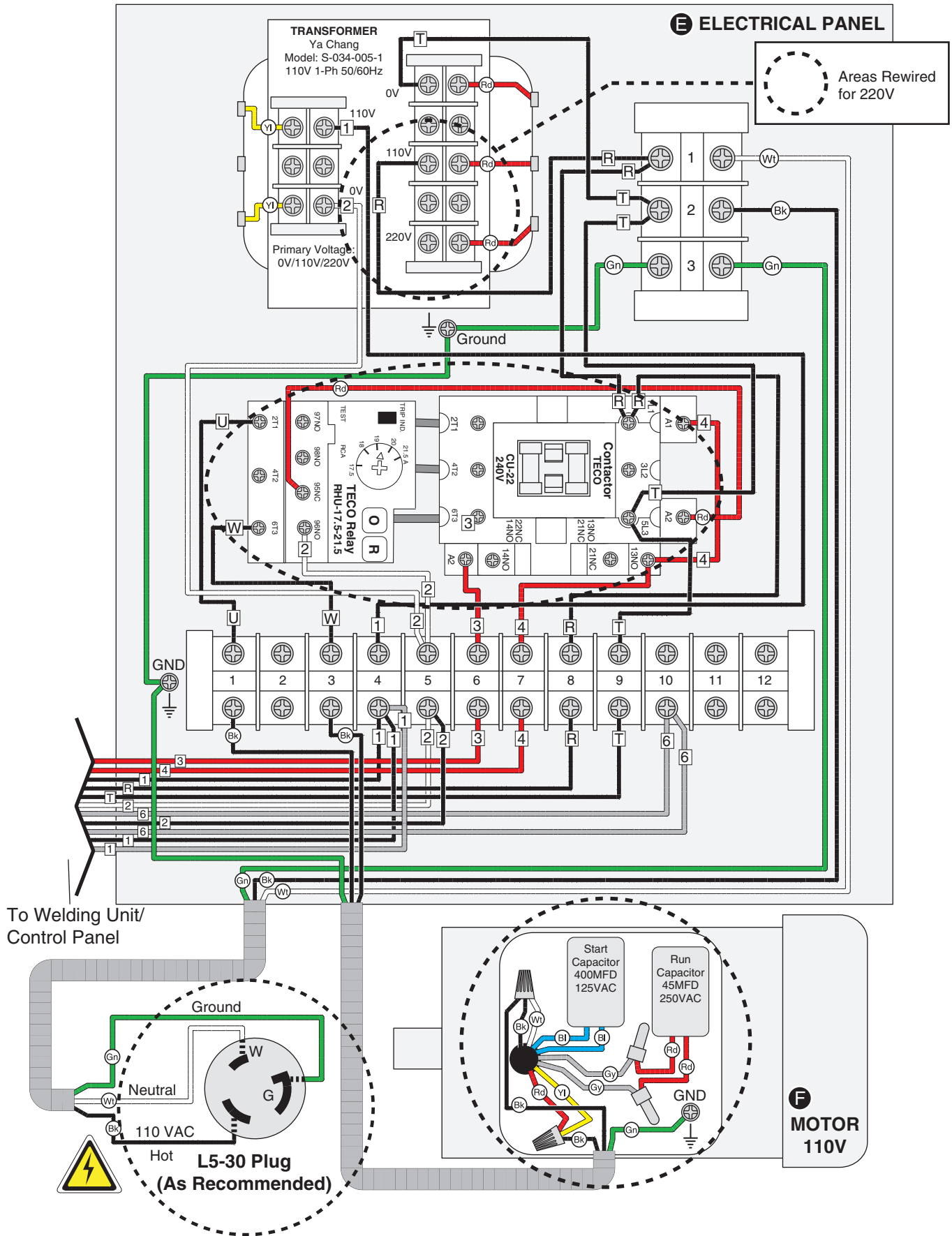
G0807 Control Panel & Welding Unit



G0807 220V Electrical Panel & Motor

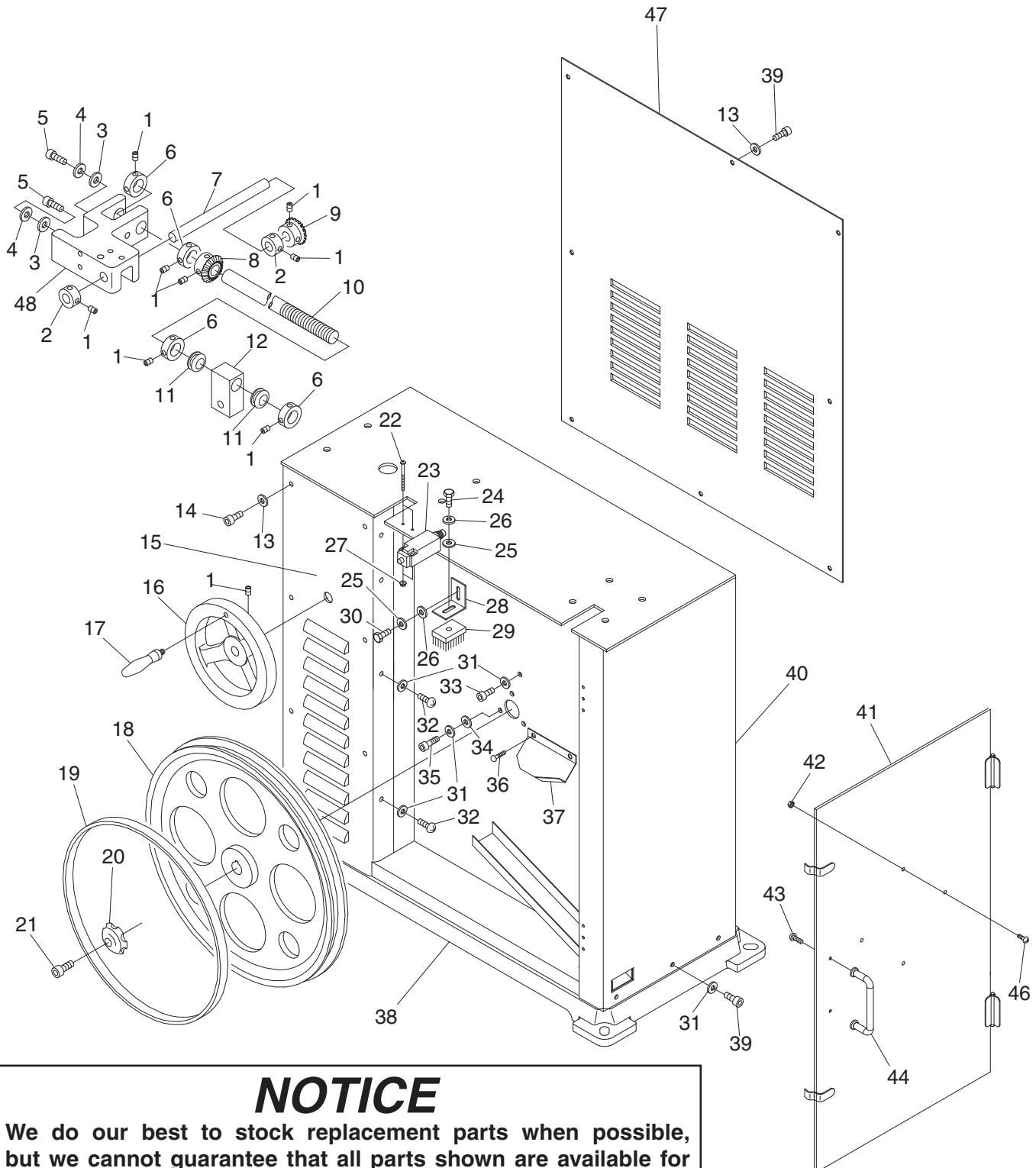


G0807 110V Electrical Panel & Motor



SECTION 9: PARTS

Lower Frame



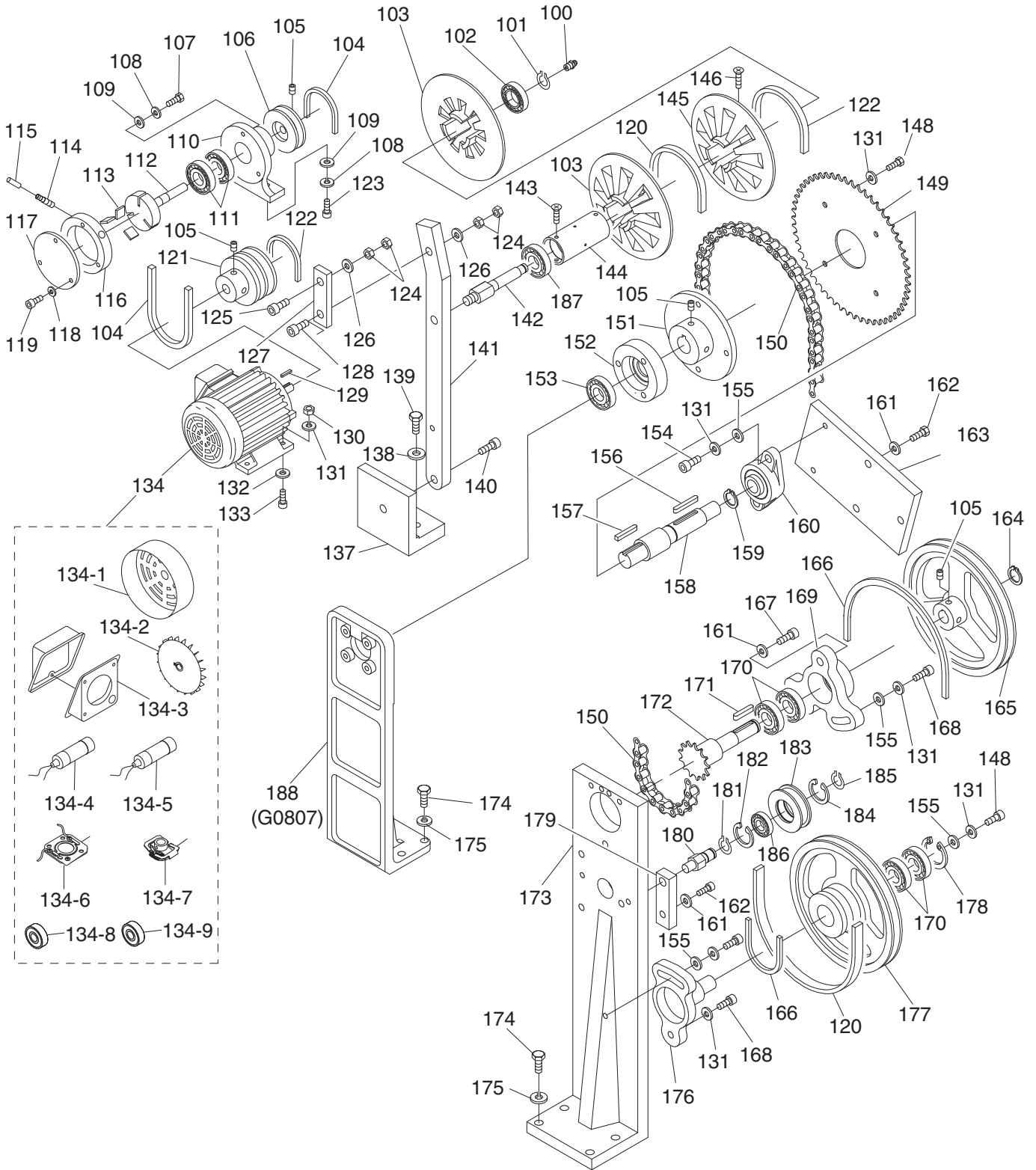
Lower Frame Parts List

REF	PART #	DESCRIPTION
1	P0806001	SET SCREW M8-1.25 X 8
2	P0806002	LOCK COLLAR 16 X 16
3	P0806003	FLAT WASHER 10MM
4	P0806004	LOCK WASHER 10MM
5	P0806005	CAP SCREW M10-1.5 X 30
6	P0806006	LOCK COLLAR 22 X 13
7	P0806007	BEVEL GEAR SHAFT
8	P0806008	BEVEL GEAR 2.5 X 17
9	P0806009	BEVEL GEAR 2.5 X 17
10	P0806010	LEADSCREW
11	P0806011	GROMMET 25 X 7
12	P0806012	LEADSCREW NUT 30 X 40 X 70
13	P0806013	FLAT WASHER 8MM
14	P0806014	CAP SCREW M8-1.25 X 20
15	P0806015	FRONT VENT COVER
16	P0806016	HANDWHEEL TYPE 23 6D 5/8B-S X 3/18-16
17	P0806017	REVOLVING HANDWHEEL HANDLE 3/8-16
18	P0806018	LOWER WHEEL 14" (G0806)
18	P0807018	LOWER WHEEL 18" (G0807)
19	P0806019	RUBBER TIRE 14" (G0806)
19	P0807019	RUBBER TIRE 18" (G0807)
20	P0806020	LOCK KNOB
21	P0806021	CAP SCREW M8-1.25 X 25
22	P0806022	PHLP HD SCR M4-.7 X 50
23	P0806023	LIMIT SWITCH MOUJEN MEA-9111
24	P0806024	HEX BOLT M6-1 X 20
25	P0806025	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
26	P0806026	LOCK WASHER 6MM
27	P0806027	FLANGE NUT M4-.7
28	P0806028	BRUSH BRACKET
29	P0806029	BRUSH
30	P0806030	HEX BOLT M6-1 X 20
31	P0806031	LOCK WASHER 8MM
32	P0806032	PHLP HD SCR M8-1.25 X 16
33	P0806033	CAP SCREW M8-1.25 X 25
34	P0806034	FLAT WASHER 8MM
35	P0806035	CAP SCREW M8-1.25 X 30
36	P0806036	RIVET 5 X 20
37	P0806037	CHIP DEFLECTOR
38	P0806038	BASE (G0806)
38	P0807038	BASE (G0807)
39	P0806039	CAP SCREW M8-1.25 X 20
40	P0806040	LOWER FRAME (G0806)
40	P0807040	LOWER FRAME (G0807)
41	P0806041	LOWER DOOR (G0806)
41	P0807041	LOWER DOOR (G0807)
42	P0806042	HEX NUT M5-.8
43	P0806043	PHLP HD SCR M6-1 X 8
44	P0806044	DOOR HANDLE
46	P0806046	PHLP HD SCR M5-.8 X 8
47	P0806047	LOWER REAR COVER (G0806)
47	P0807047	LOWER REAR COVER (G0807)
48	P0806048	BRACKET



Drive System



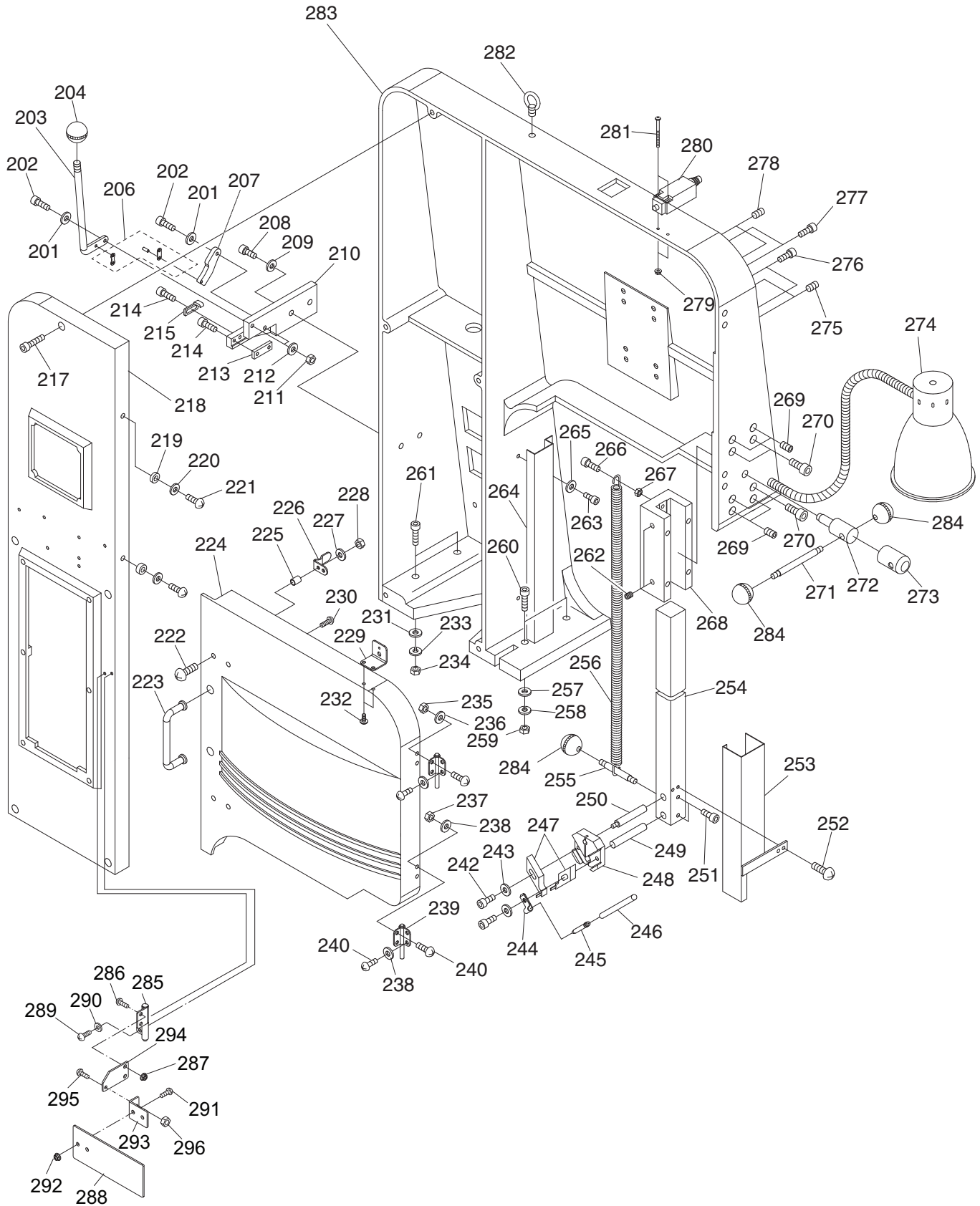
Drive System Parts List

REF	PART #	DESCRIPTION
100	P0806100	GREASE FITTING 1/4 28PF STRAIGHT
101	P0806101	EXT RETAINING RING 12MM
102	P0806102	BALL BEARING 6201ZZ
103	P0806103	STATIONARY PULLEY
104	P0806104	V-BELT M26 3L260
105	P0806105	SET SCREW M8-1.25 X 8
106	P0806106	AIR PUMP PULLEY
107	P0806107	HEX BOLT M6-1 X 20
108	P0806108	LOCK WASHER 6MM
109	P0806109	FLAT WASHER 6MM
110	P0806110	PUMP HOUSING
111	P0806111	BALL BEARING 6202ZZ
112	P0806112	PUMP ROTOR
113	P0806113	ROTOR BLADE
114	P0806114	AIR NOZZLE
115	P0806115	AIR HOSE 6.6 X 1 X 2200MM (G0806)
115	P0807115	AIR HOSE 6.6 X 1 X 2600MM (G0807)
116	P0806116	NOZZLE HOUSING
117	P0806117	END CAP
118	P0806118	LOCK WASHER 6MM
119	P0806119	CAP SCREW M6-1 X 16
120	P0806120	V-BELT A40 (G0806)
120	P0807120	V-BELT A43 (G0807)
121	P0806121	MOTOR PULLEY
122	P0806122	V-BELT A37
123	P0806123	CAP SCREW M6-1 X 20
124	P0806124	HEX NUT M12-1.75
125	P0806125	CAP SCREW M12-1.75 X 70
126	P0806126	FLAT WASHER 12MM
127	P0806127	CONNECTOR
128	P0806128	CAP SCREW M12-1.75 X 55
129	P0806129	KEY 5 X 5 X 25
130	P0806130	HEX NUT M8-1.25
131	P0806131	LOCK WASHER 8MM
132	P0806132	FLAT WASHER 8MM
133	P0806133	CAP SCREW M8-1.25 X 35
134	P0806134	MOTOR 1.5HP 110V/220V 1-PH (G0806)
134	P0807134	MOTOR 2HP 110V/220V 1-PH (G0807)
134-1	P0806134-1	MOTOR FAN COVER (G0806)
134-1	P0807134-1	MOTOR FAN COVER (G0807)
134-2	P0806134-2	MOTOR FAN (G0806)
134-2	P0807134-2	MOTOR FAN (G0807)
134-3	P0806134-3	MOTOR JUNCTION BOX (G0806)
134-3	P0807134-3	MOTOR JUNCTION BOX (G0807)
134-4	P0806134-4	S CAPACITOR 400M 125V 1-3/8 X 2-3/4
134-5	P0806134-5	R CAPACITOR 45M 250V 1-5/8 X 2-1/2
134-6	P0806134-6	CONTACT PLATE
134-7	P0806134-7	CENTRIFUGAL SWITCH
134-8	P0806134-8	FRONT MOTOR BEARING
134-9	P0806134-9	REAR MOTOR BEARING
137	P0806137	BRACKET
138	P0806138	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
139	P0806139	HEX BOLT M10-1.5 X 35
140	P0806140	CAP SCREW M12-1.75 X 60
141	P0806141	SUPPORT ARM
142	P0806142	SHAFT
143	P0806143	FLAT HD SCR M5-.8 X 12
144	P0806144	SLEEVE
145	P0806145	MOVABLE PULLEY
146	P0806146	FLAT HD SCR M5-.8 X 12
148	P0806148	HEX BOLT M8-1.25 X 16
149	P0806149	SPROCKET 55T
150	P0806150	CHAIN 33 LINKS
151	P0806151	HUB
152	P0806152	BEARING SEAT
153	P0806153	BALL BEARING 6205-OPEN
154	P0806154	CAP SCREW M8-1.25 X 30
155	P0806155	FLAT WASHER 8MM
156	P0806156	KEY 6 X 6 X 65
157	P0806157	KEY 6 X 6 X 30
158	P0806158	SHAFT (G0806)
158	P0807158	SHAFT (G0807)
159	P0806159	EXT RETAINING RING 25MM
160	P0806160	PILLOW BLOCK BEARING UCFL204
161	P0806161	LOCK WASHER 10MM
162	P0806162	HEX BOLT M10-1.5 X 35
163	P0806163	PLATE
164	P0806164	EXT RETAINING RING 19MM
165	P0806165	PULLEY
166	P0806166	V-BELT A46 (G0806)
166	P0807166	V-BELT A49 (G0807)
167	P0806167	CAP SCREW M10-1.5 X 35
168	P0806168	CAP SCREW M8-1.25 X 35
169	P0806169	BEARING SEAT
170	P0806170	BALL BEARING 6204ZZ
171	P0806171	KEY 6 X 6 X 35
172	P0806172	SPROCKET SHAFT 13T
173	P0806173	BRACKET
174	P0806174	HEX BOLT M10-1.5 X 35
175	P0806175	LOCK WASHER 10MM
176	P0806176	PIVOT SHAFT
177	P0806177	PULLEY
178	P0806178	INT RETAINING RING 47MM
179	P0806179	BLOCK
180	P0806180	SHAFT
181	P0806181	EXT RETAINING RING 15MM
182	P0806182	INT RETAINING RING 35MM
183	P0806183	PULLEY
184	P0806184	INT RETAINING RING 35MM
185	P0806185	EXT RETAINING RING 15MM
186	P0806186	BALL BEARING 6202ZZ
187	P0806187	BALL BEARING 6202ZZ
188	P0807188	DRIVE CHAIN SUPPORT BRACKET (G0807)



Upper Frame



Upper Frame Parts List

REF	PART #	DESCRIPTION
201	P0806201	FLAT WASHER 6MM
202	P0806202	CAP SCREW M6-1 X 25
203	P0806203	SHEAR LEVER 5/16-18
204	P0806204	BALL KNOB 5/16-18 (BLACK)
206	P0806206	LOCKING LINK ASSEMBLY
207	P0806207	UPPER SHEAR BLADE
208	P0806208	CAP SCREW M8-1.25 X 30
209	P0806209	FLAT WASHER 8MM
210	P0806210	SHEAR BRACKET
211	P0806211	HEX NUT M6-1
212	P0806212	FLAT WASHER 6MM
213	P0806213	LOWER SHEAR BLADE
214	P0806214	CAP SCREW M5-.8 X 8
215	P0806215	ALIGNMENT BRACKET
217	P0806217	CAP SCREW M8-1.25 X 35
218	P0806218	WELDING STATION COVER (G0806)
218	P0807218	WELDING STATION COVER (G0807)
219	P0806219	SPACER 4.5 X 15 X 6MM
220	P0806220	LOCK WASHER 8MM
221	P0806221	PHLP HD SCR M8-1.25 X 20
222	P0806222	PHLP HD SCR M5-.8 X 16
223	P0806223	HANDLE M6-1
224	P0806224	UPPER DOOR (G0806)
224	P0807224	UPPER DOOR (G0807)
225	P0806225	SPACER 4.5 X 15 X 6MM
226	P0806226	DOOR LATCH
227	P0806227	LOCK WASHER 5MM
228	P0806228	HEX NUT M5-.8
229	P0806229	SAFETY SWITCH BRACKET
230	P0806230	PHLP HD SCR M6-1 X 16
231	P0806231	FLAT WASHER 10MM
232	P0806232	PHLP HD SCR M5-.8 X 12
233	P0806233	LOCK WASHER 10MM
234	P0806234	HEX NUT M10-1.5
235	P0806235	HEX NUT M5-.8
236	P0806236	LOCK WASHER 5MM
237	P0806237	HEX NUT M5-.8
238	P0806238	LOCK WASHER 5MM
239	P0806239	HINGE
240	P0806240	PHLP HD SCR M5-.8 X 16
242	P0806242	CAP SCREW M6-1 X 25
243	P0806243	FLAT WASHER 6MM
244	P0806244	HOSE CLAMP
245	P0806245	AIR NOZZLE
246	P0806246	AIR HOSE 6.6 X 1 X 2200MM (G0806)
246	P0807246	AIR HOSE 6.6 X 1 X 2600MM (G0807)
247	P0806247	BLADE GUIDE ASSEMBLY
248	P0806248	BLADE GUIDE BRACKET
249	P0806249	DOWEL PIN 11 X 70
250	P0806250	THREADED PIN 10 X 65
251	P0806251	CAP SCREW M6-1 X 10

REF	PART #	DESCRIPTION
252	P0806252	PHLP HD SCR M6-1 X 16
253	P0806253	UPPER BLADE GUARD (G0806)
253	P0807253	UPPER BLADE GUARD (G0807)
254	P0806254	BLADE GUIDE BAR (G0806)
254	P0807254	BLADE GUIDE BAR (G0807)
255	P0806255	STUD-UDE M8-1.25 X 66, 18, 12
256	P0806256	EXT SPRING 1.3 X 193 X 9.4 (G0806)
256	P0807256	EXT SPRING 1.2 X 213 X 9.4 (G0807)
257	P0806257	FLAT WASHER 10MM
258	P0806258	LOCK WASHER 10MM
259	P0806259	HEX NUT M10-1.5
260	P0806260	CAP SCREW M10-1.5 X 45
261	P0806261	CAP SCREW M10-1.5 X 60
262	P0806262	SET SCREW M8-1.25 X 12
263	P0806263	CAP SCREW M6-1 X 16
264	P0806264	BLADE COVER (G0806)
264	P0807264	BLADE COVER (G0807)
265	P0806265	LOCK WASHER 6MM
266	P0806266	CAP SCREW M6-1 X 16
267	P0806267	HEX NUT M6-1
268	P0806268	BLADE GUIDE BAR HOUSING
269	P0806269	SET SCREW M10-1.5 X 25
270	P0806270	CAP SCREW M8-1.25 X 35
271	P0806271	STUD-DE M8-1.25 X 100, 10
272	P0806272	LOCKING HUB
273	P0806273	LOCKING HUB COVER
274	P0806274	WORK LAMP 110V ASSEMBLY
275	P0806275	SET SCREW M10-1.5 X 20
276	P0806276	CAP SCREW M8-1.25 X 30
277	P0806277	CAP SCREW M8-1.25 X 30
278	P0806278	SET SCREW M10-1.5 X 20
279	P0806279	HEX NUT M4-.7
280	P0806280	LIMIT SWITCH MOUJEN MEA-9111
281	P0806281	PHLP HD SCR M4-.7 X 50
282	P0806282	EYE BOLT 1/2"-12 X 7/8 (G0806)
282	P0807282	EYE BOLT 5/8"-12 X 1 (G0807)
283	P0806283	UPPER FRAME (G0806)
283	P0807283	UPPER FRAME (G0807)
284	P0806284	BALL KNOB M8-1.25 (BLACK)
285	P0806285	SPARK DEFLECTOR HINGE
286	P0806286	PHLP HD SCR M5-.8 X 8
287	P0806287	HEX NUT M5-.8
288	P0806288	SPARK DEFLECTOR
289	P0806289	PHLP HD SCR M5-.8 X 12
290	P0806290	FLAT WASHER 5MM
291	P0806291	PHLP HD SCR M5-.8 X 12
292	P0806292	HEX NUT M5-.8
293	P0806293	SPARK DEFLECTOR BRACKET (LEFT)
294	P0806294	SPARK DEFLECTOR BRACKET (RIGHT)
295	P0806295	PHLP HD SCR M5-.8 X 12
296	P0806296	HEX NUT M5-.8



Table & Tensioning System

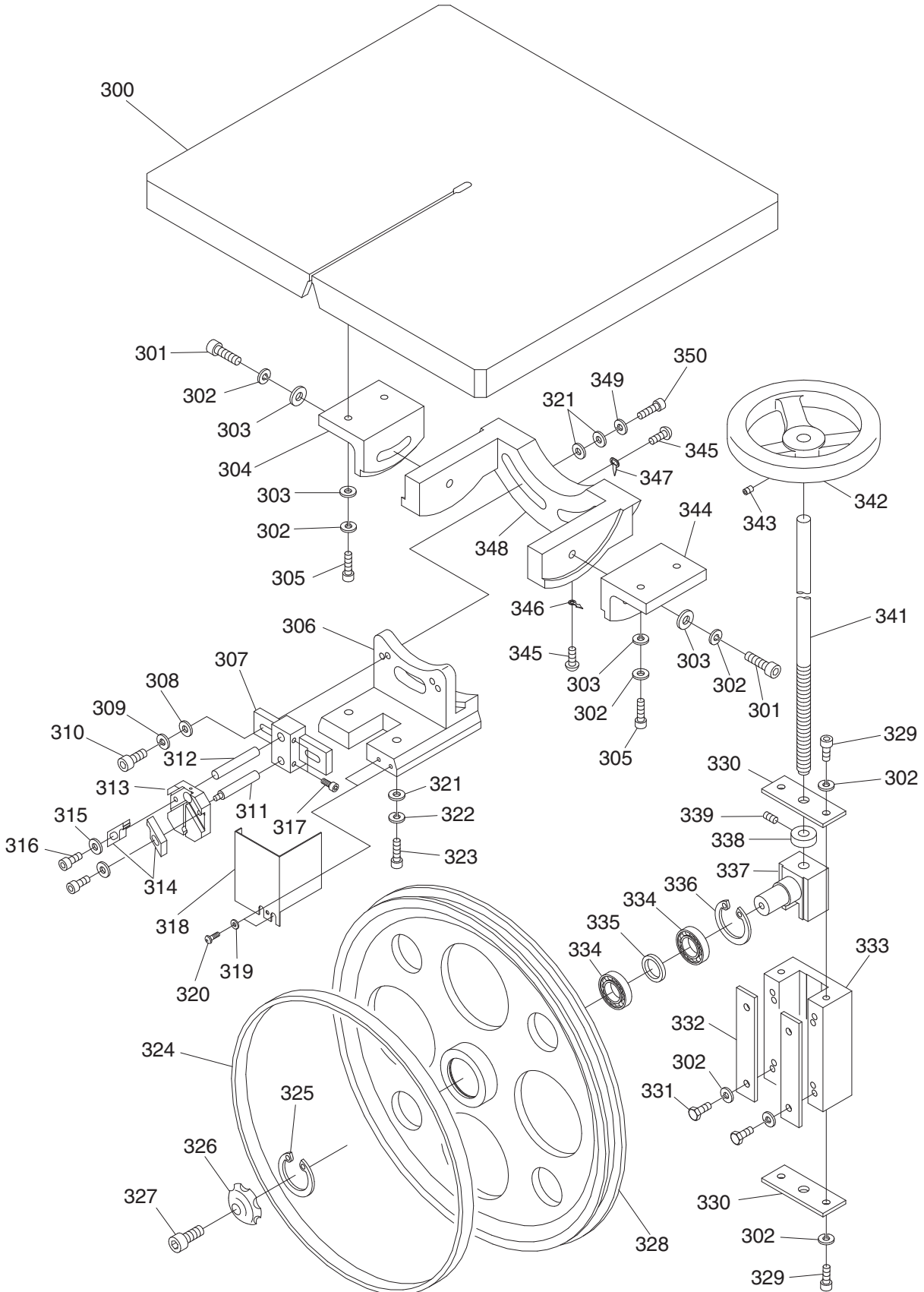


Table & Tensioning System Parts List

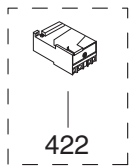
REF	PART #	DESCRIPTION
300	P0806300	TABLE
301	P0806301	CAP SCREW M8-1.25 X 50
302	P0806302	LOCK WASHER 8MM
303	P0806303	FLAT WASHER 8MM
304	P0806304	TRUNNION BRACKET (LEFT)
305	P0806305	CAP SCREW M8-1.25 X 35
306	P0806306	TABLE SUPPORT
307	P0806307	BLADE GUIDE SUPPORT
308	P0806308	FLAT WASHER 6MM
309	P0806309	LOCK WASHER 6MM
310	P0806310	CAP SCREW M6-1 X 30
311	P0806311	THREADED PIN 10 X 65
312	P0806312	BLADE GUIDE BRACKET DOWEL PIN 11 X 70
313	P0806313	BLADE GUIDE BRACKET
314	P0806314	BLADE GUIDE ASSEMBLY
315	P0806315	FLAT WASHER 6MM
316	P0806316	CAP SCREW M6-1 X 25
317	P0806317	CAP SCREW M6-1 X 10
318	P0806318	LOWER BLADE GUARD
319	P0806319	FLAT WASHER 5MM
320	P0806320	PHLP HD SCR M5-.8 X 16
321	P0806321	FLAT WASHER 10MM
322	P0806322	LOCK WASHER 10MM
323	P0806323	CAP SCREW M10-1.5 X 30
324	P0806324	RUBBER TIRE (G0806)
324	P0807019	RUBBER TIRE (G0807)
325	P0806325	INT RETAINING RING 52MM

REF	PART #	DESCRIPTION
326	P0806326	LOCK KNOB
327	P0806327	CAP SCREW M8-1.25 X 30
328	P0806328	UPPER WHEEL 14" (G0806)
328	P0807328	UPPER WHEEL 18" (G0807)
329	P0806329	CAP SCREW M8-1.25 X 20
330	P0806330	RETAINING PLATE (HORIZONTAL)
331	P0806331	HEX BOLT M8-1.25 X 16
332	P0806332	RETAINING PLATE (VERTICAL)
333	P0806333	TRACKING BRACKET
334	P0806334	BALL BEARING 6205ZZ
335	P0806335	SPACER 32 X 25 X 15MM
336	P0806336	INT RETAINING RING 52MM
337	P0806337	IDLER SHAFT
338	P0806338	LOCK COLLAR
339	P0806339	SET SCREW M8-1.25 X 8
341	P0806341	TENSION LEADSCREW (G0806)
341	P0807341	TENSION LEADSCREW (G0807)
342	P0806342	HANDWHEEL TYPE 23 6D 5/8B-S X 3/18-16
343	P0806343	SET SCREW M8-1.25 X 8
344	P0806344	TRUNNION BRACKET (RIGHT)
345	P0806345	PHLP HD SCR M5-.8 X 12
346	P0806346	FEED ANGLE TILT SCALE POINTER
347	P0806347	CUT ANGLE TILT SCALE POINTER
348	P0806348	TABLE TRUNNION
349	P0806349	FLAT WASHER 10MM
350	P0806350	CAP SCREW M10-1.5 X 55

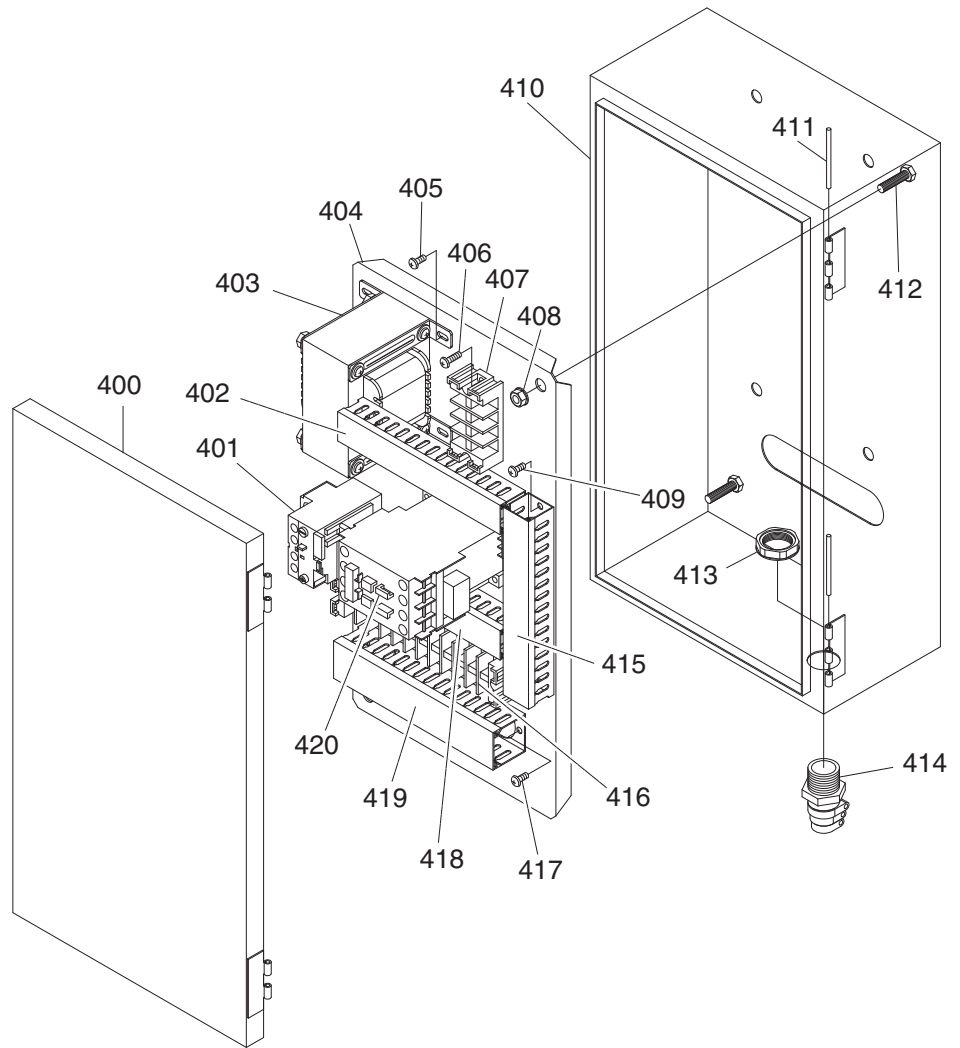
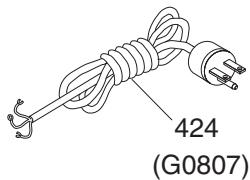
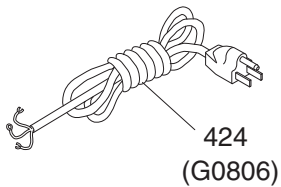
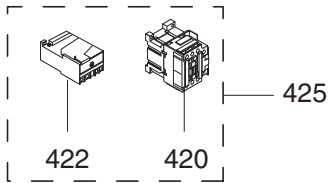


Electrical Cabinet

G0806 (220V Conversion Kit)



G0807 (110V Conversion Kit)

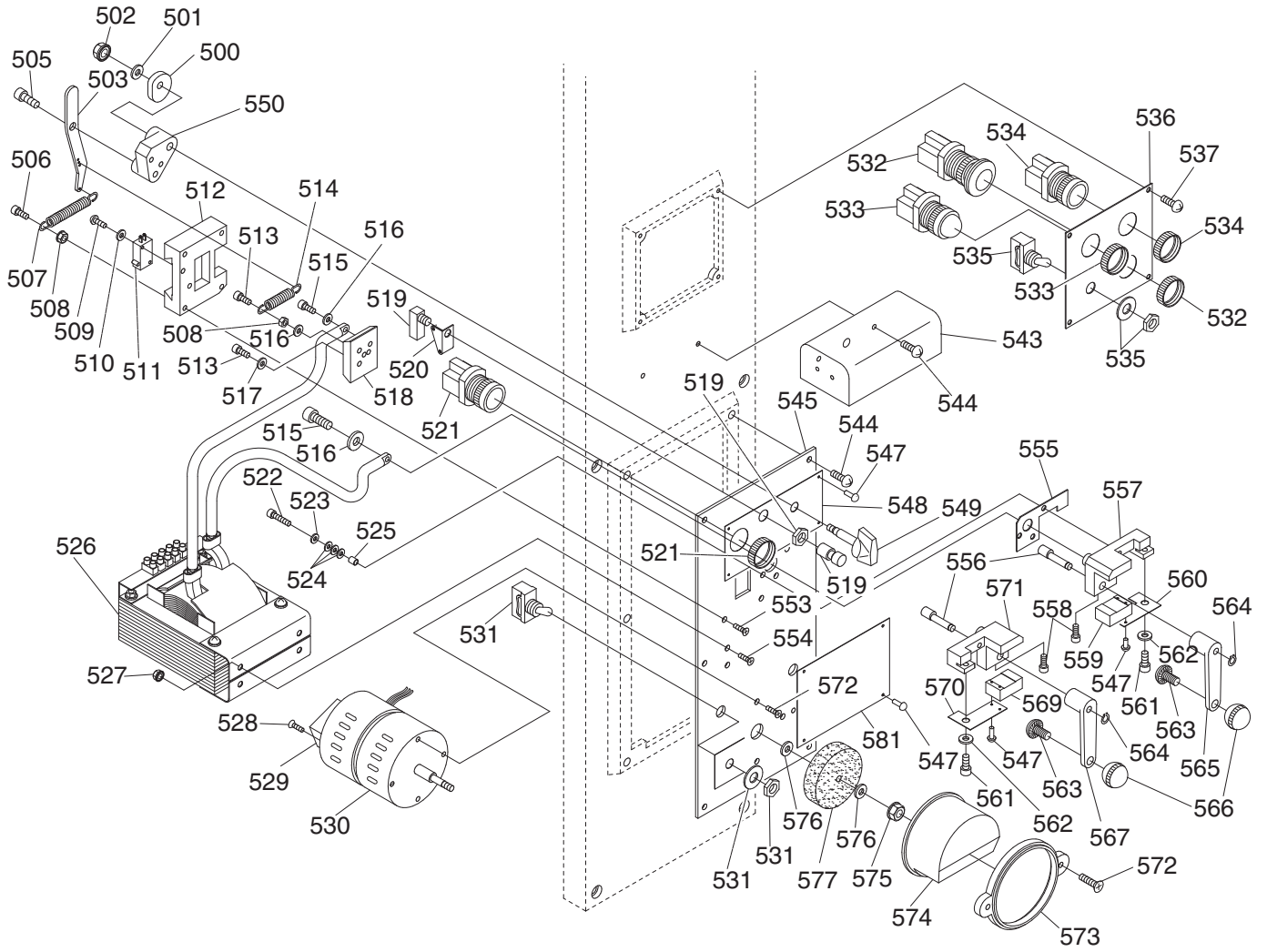


REF	PART #	DESCRIPTION
400	P0806400	CABINET DOOR
401	P0806401	OL RELAY TECO RHU-10/1 11.3-16A (G0806)
401	P0807401	OL RELAY TECO RHU-10/1 9-12.5A (G0807)
402	P0806402	WIRE LOOM (UPPER)
403	P0806403	TRANSFORMER YA CHANG S-034-005-1
404	P0806404	ELECTRICAL PANEL
405	P0806405	PHLP HD SCR M4-.7 X 8
406	P0806406	PHLP HD SCR M4-.7 X 12
407	P0806407	TERMINAL BLOCK 4P
408	P0806408	HEX NUT M6-1
409	P0806409	PHLP HD SCR M4-.7 X 8
410	P0806410	ELECTRICAL CABINET
411	P0806411	HINGE PIN 3 X 50
412	P0806412	HEX BOLT M6-1 X 40

REF	PART #	DESCRIPTION
413	P0806413	STRAIN RELIEF NUT M20-1.5
414	P0806414	STRAIN RELIEF M20-1.5 TYPE-3
415	P0806415	WIRE LOOM (RIGHT)
416	P0806416	TERMINAL BLOCK 12P
417	P0806417	PHLP HD SCR M4-.7 X 8
418	P0806418	WIRE LOOM (MIDDLE)
419	P0806419	WIRE LOOM (LOWER)
420	P0806420	CONTACTOR TECO CU-18 240V
420	P0807420	CONTACTOR TECO CU-22 240V (G0807)
422	P0806422	OL RELAY TECO RHU-10/1 7.2-10A (G0806)
422	P0807422	OL RELAY TECO RHU-10/1 17.5-21.5 (G0807)
424	P0806424	POWER CORD 12G 3W 72" 5-15 (G0806)
424	P0807424	POWER CORD 12G 3W 72" 6-15 (G0807)
425	P0807425	110V CONVERSION KIT (G0807)



Welder & Control Panel



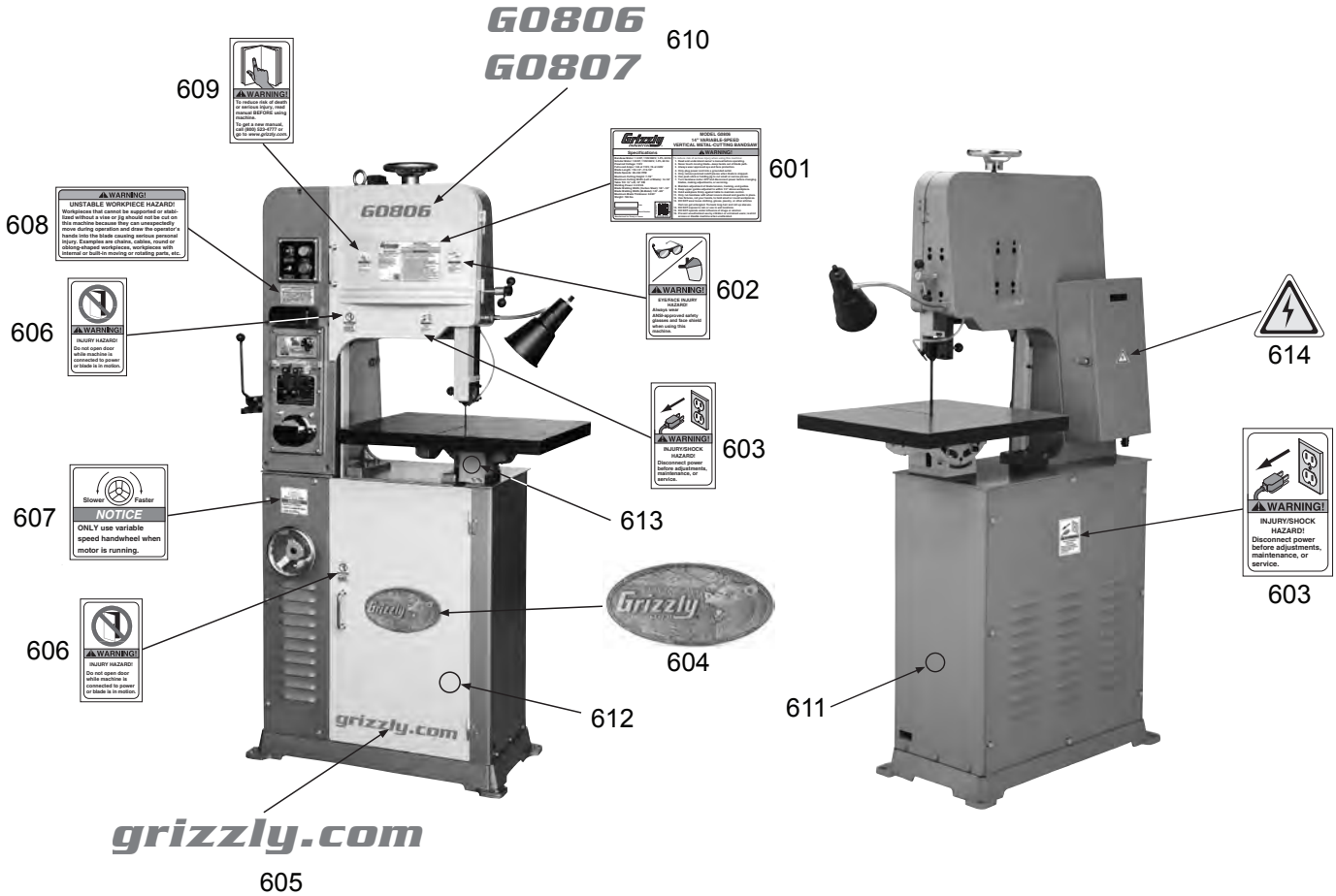
Welder & Control Panel Parts List

REF	PART #	DESCRIPTION
500	P0806500	CAM
501	P0806501	FLAT WASHER 6MM
502	P0806502	FLANGE NUT M6-1
503	P0806503	SPRING ARM
505	P0806505	CAP SCREW M6-1 X 16
506	P0806506	CAP SCREW M5-.8 X 25
507	P0806507	LOWER EXTENSION SPRING 1 X 45 X 10
508	P0806508	HEX NUT M5-.8
509	P0806509	PHLP HD SCR 5-40 x 3/4
510	P0806510	LOCK WASHER #5
511	P0806511	SWITCH OMRON V-151E5 110V/220V
512	P0806512	SLIDE SEAT
513	P0806513	CAP SCREW M5-.8 X 25
514	P0806514	UPPER EXTENSION SPRING 1 X 23 X 9
515	P0806515	CAP SCREW M5-.8 X 8
516	P0806516	FLAT WASHER 5MM
517	P0806517	LOCK WASHER 5MM
518	P0806518	SLIDE BLOCK
519	P0806519	ANNEAL SWITCH OMRON V-151E5 110V/220V
520	P0806520	ANNEAL SWITCH BRACKET
521	P0806521	ON BUTTON AUSPICIOUS APB 25-1/0
522	P0806522	CAP SCREW M5-.8 X 16
523	P0806523	FLAT WASHER 5MM
524	P0806524	INSULATING WASHER 5MM
525	P0806525	INSULATING SPACER 5MM
526	P0806526	WELDING TRANSFORMER 2.0KVA (G0806)
526	P0807526	WELDING TRANSFORMER 2.4KVA (G0807)
527	P0806527	FLANGE NUT M5-.8
528	P0806528	FLAT HD SCR M5-.8 X 8
529	P0806529	CAPACITOR YACHANG 3M 250V
530	P0806530	GRINDER MOTOR 1/8HP 110V
531	P0806531	TOGGLE SWITCH SEI R13-5
532	P0806532	OFF BUTTON AUSPICIOUS APB 25-1/C
533	P0806533	POWER INDICATOR LIGHT NPLR-25B GRN
534	P0806534	ON BUTTON AUSPICIOUS APB 25-1/0

REF	PART #	DESCRIPTION
535	P0806535	TOGGLE SWITCH SEI R13-5
536	P0806536	CONTROL PANEL
537	P0806537	PHLP HD SCR M5-.8 X 10
543	P0806543	LAMP COVER
544	P0806544	PHLP HD SCR M5-.8 X 10
545	P0806545	WELDING PANEL
547	P0806547	RIVET M2 X 6
548	P0806548	WELDING CONTROL PANEL
549	P0806549	PRESSURE KNOB
550	P0806550	SPRING ARM BRACKET
553	P0806553	FLAT HD SCR M5-.8 X 15
554	P0806554	FLAT HD SCR M5-.8 X 12
555	P0806555	JAW INSULATOR
556	P0806556	CAM PIVOT SHAFT
557	P0806557	ELECTRODE (RIGHT)
558	P0806558	CAP SCREW M5-.8 X 12
559	P0806559	LOWER JAW (RIGHT)
560	P0806560	CONNECTING PLATE (RIGHT)
561	P0806561	CAP SCREW M5-.8 X 6
562	P0806562	LOCK WASHER 5MM
563	P0806563	LOCKING FLANGE SCREW M8-1.25 X 16
564	P0806564	EXT RETAINING RING 5MM
565	P0806565	CLAMP LEVER (RIGHT)
566	P0806566	BALL KNOB M8-1.25 (BLACK)
567	P0806567	CLAMP LEVER (LEFT)
569	P0806569	LOWER JAW (LEFT)
570	P0806570	CONNECTING PLATE (LEFT)
571	P0806571	ELECTRODE (LEFT)
572	P0806572	FLAT HD SCR M5-.8 X 10
573	P0806573	GUARD RETAINING RING
574	P0806574	GRINDING WHEEL GUARD
575	P0806575	HEX NUT 1/4-20
576	P0806576	FLAT WASHER 1/4
577	P0806577	GRINDING WHEEL 1/4 X 5/8 X 2-1/2
581	P0806581	WELDING INSTRUCTION PLATE



Machine Labels & Cosmetics



REF	PART #	DESCRIPTION
601	P0806601	MACHINE ID LABEL (G0806)
601	P0807601	MACHINE ID LABEL (G0807)
602	P0806602	FACE SHIELD & SAFETY GLASSES LABEL
603	P0806603	DISCONNECT POWER LABEL
604	P0806604	GRIZZLY NAMEPLATE
605	P0806605	GRIZZLY.COM LABEL
606	P0806606	DOOR INJURY HAZARD LABEL
607	P0806607	SPEED CHANGE NOTICE LABEL

REF	PART #	DESCRIPTION
608	P0806608	UNSTABLE W/P HAZARD LABEL
609	P0806609	READ MANUAL LABEL
610	P0806610	MODEL NUMBER LABEL (G0806)
610	P0807610	MODEL NUMBER LABEL (G0807)
611	P0806611	GRIZZLY GREEN TOUCH-UP PAINT
612	P0806612	GRIZZLY BEIGE TOUCH-UP PAINT
613	P0806613	YELLOW TOUCH-UP PAINT
614	P0806614	ELECTRICITY LABEL

⚠ 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.





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____
 Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

- How did you learn about us?

<input type="checkbox"/> Advertisement	<input type="checkbox"/> Friend	<input type="checkbox"/> Catalog
<input type="checkbox"/> Card Deck	<input type="checkbox"/> Website	<input type="checkbox"/> Other:
- Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	
- What is your annual household income?

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
- What is your age group?

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
- How long have you been a woodworker/metalworker?

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
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- How many of your machines or tools are Grizzly?

<input type="checkbox"/> 0-2	<input type="checkbox"/> 3-5	<input type="checkbox"/> 6-9	<input type="checkbox"/> 10+
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- Do you think your machine represents a good value? Yes No
- Would you recommend Grizzly Industrial to a friend? Yes No
- Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: We never use names more than 3 times. Yes No

10. Comments: _____

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Place Stamp Here



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P.O. BOX 2069
BELLINGHAM, WA 98227-2069



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Street _____
City _____ State _____ Zip _____

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WARRANTY & RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

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

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