

Grizzly **Industrial, Inc.**®

MODEL G0820 **12" COMPACT** **SLIDING TABLE SAW** **OWNER'S MANUAL**

(For models manufactured since 05/22)



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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.**
#BL18666 PRINTED IN TAIWAN

V3.06.22

*****Keep for Future Reference*****



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

WARNING

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

CAUTION

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


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.

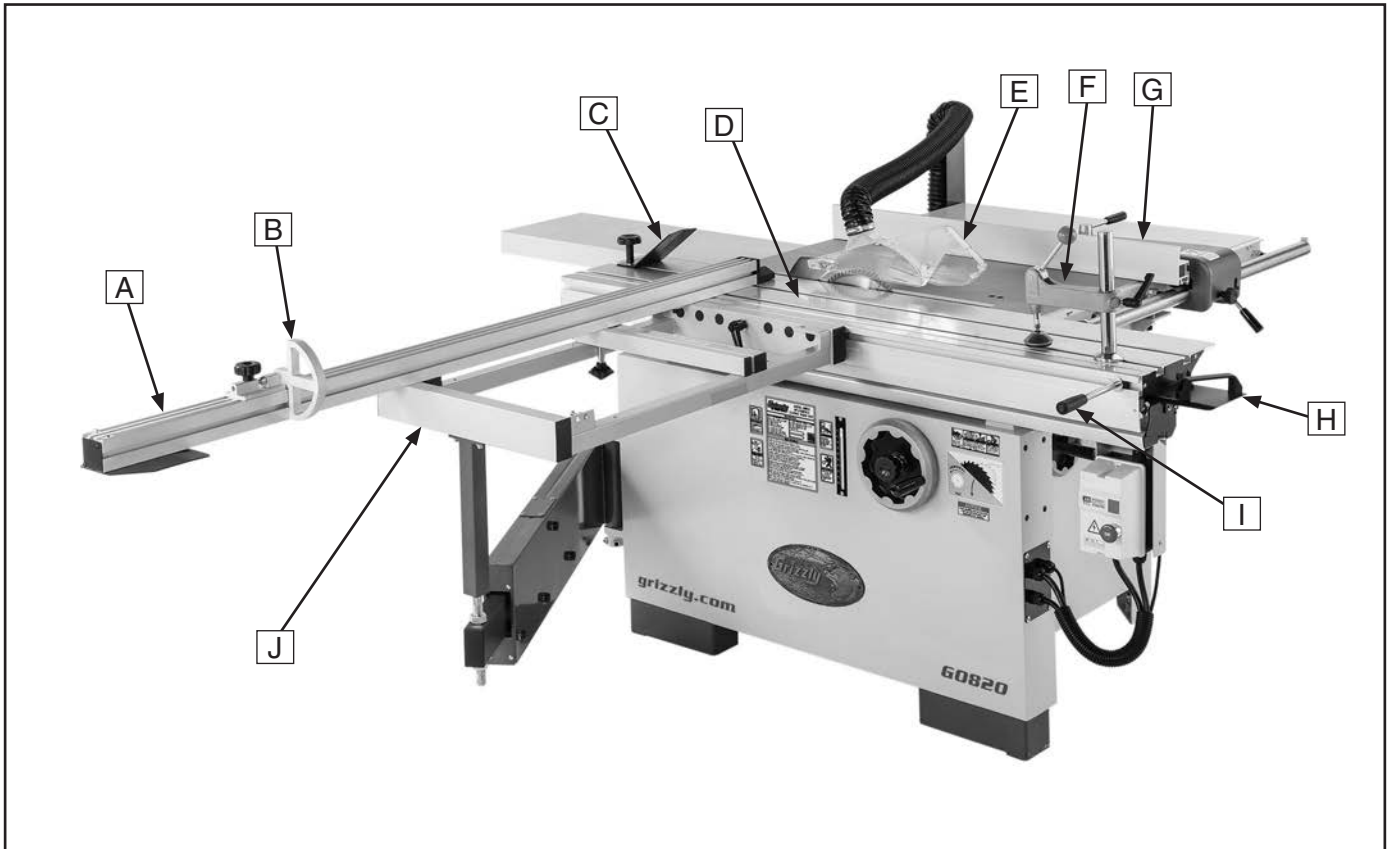
| | | | |
|--|---|-----------------------------|--|
|  | | MODEL GXXXX MACHINE NAME | |
| SPECIFICATIONS | | ▲ WARNING! | |
| Motor: | To reduce risk of serious injury when using this machine: | | |
| Specification: | Manual before operation. | | |
| Specification: | Safety glasses and respirator. | | |
| Specification: | Correctly adjusted/setup and | | |
| Specification: | power is connected to grounded circuit before starting. | | |
| Weight: | 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. ended. | | |
| | 10. Maintain machine carefully to prevent accidents. | | |

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.



- A. Crosscut Fence:** Used during crosscutting operations to keep panels at 90° angle to blade. Features a scale and flip stop.
- B. Flip Stop:** Used for quick, precise measurements for repeatable cuts when using crosscutting fence.
- C. Edge Shoe:** Used with hold-down, keeps opposite end of workpiece secured to sliding table.
- D. Sliding Table:** Ball-bearing rollers make it quick and easy to guide large, heavy panels through cut.
- E. Blade Guard:** Fully enclosed, adjustable blade guard maintains maximum protection around saw blade with a 2½" dust port that effectively extracts dust from cutting operation.
- F. Hold-Down:** Quickly clamps one end of workpiece to sliding table.
- G. Rip Fence:** Fully adjustable with micro-adjust knob for precision cuts. Fence face can be positioned for standard cutting operations, or placed in lower position for blade guard clearance during narrow ripping operations.
- H. End Plate w/Handle:** Used to move sliding table during cutting operation.
- I. Push Handle:** Used to move sliding table during cutting operation.
- J. Crosscut Table:** Provides wide, stable platform for supporting full-size panels during crosscutting operations.



Controls & Components



Refer to **Figures 1–5** 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 saw.

Rip Fence

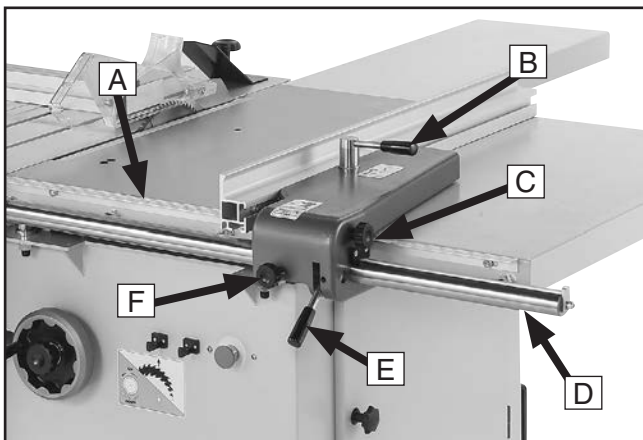


Figure 1. Rip fence controls.

- A. Rip Fence Scale:** Use scale to measure cut during ripping operations.
- B. Slide Lock Handle:** Secures aluminum fence face on forward/backward slide track.
- C. Micro-Adjust Knob:** Provides precise adjustment of fence. Tighten micro-adjust lock knob to use this feature.

- D. Rip Fence Rail:** Provides a stable side-to-side path for sliding rip fence assembly toward or away from blade.
- E. Rip Fence Lock Handle:** Secures rip fence assembly in position along fence rail so workpiece is stable when cutting.
- F. Micro-Adjust Lock Knob:** Enables use of micro-adjust knob for precise positioning of rip fence.

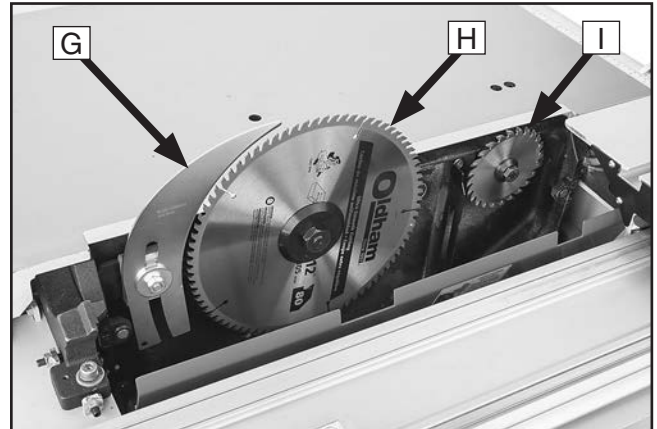


Figure 2. Saw blades and riving knife.

- G. Riving Knife:** Maintains kerf opening during cutting operations. This function is crucial to preventing kickback caused by kerf closing behind blade.
- H. Main Blade:** Performs cutting operation.
- I. Scoring Blade:** Rotates in opposite direction of main blade and pre-cuts surface of workpiece before actual cutting operation is performed to reduce tearout or chipping. Scoring blade is adjustable for kerf thickness and alignment with main blade.



Front Controls

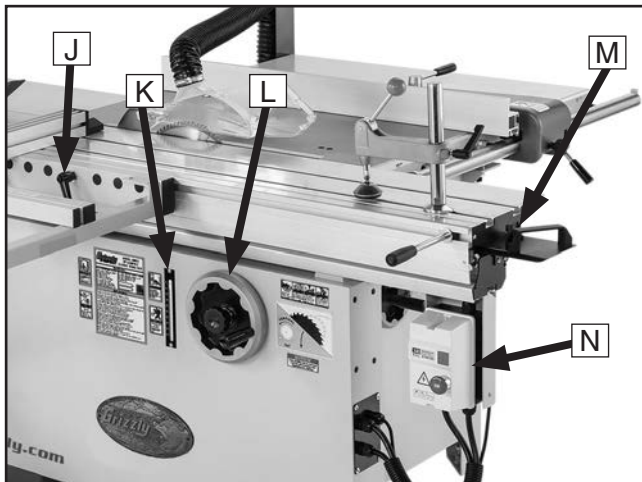


Figure 3. Front controls.

- J. Crosscut Table Lock Lever:** Secures crosscut table when locked; allows crosscut table to be repositioned along sliding table when unlocked.
- K. Tilt Scale:** Displays tilt angle of blades in degrees.
- L. Blade Tilt Handwheel:** Adjusts tilt angle of both blades. Lock knob in center secures handwheel to prevent blade from moving during operation.
- M. Sliding Table Lock Lever:** Allows sliding table to be locked in stationary position when turned clockwise; allows sliding table to move horizontally when turned counterclockwise.
- N. Magnetic ON/OFF Switch:** Green start button turns motor **ON** when pressed. Red Emergency Stop button turns motor **OFF** when pressed; for safety purposes, this button will remain depressed and prevent restarting until reset. Reset by rotating clockwise until it pops out.

Rear Controls

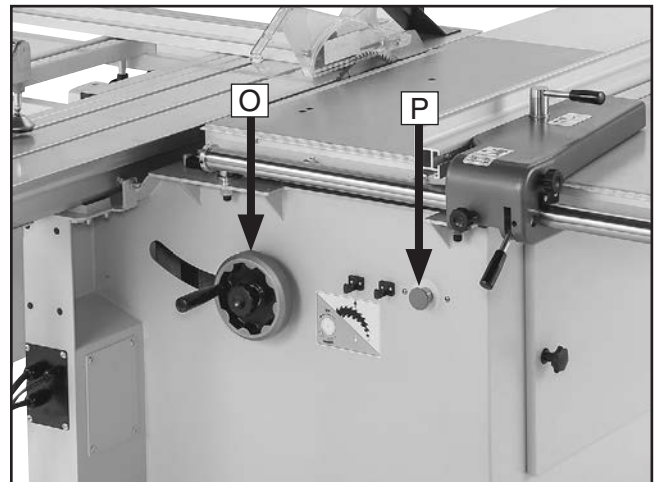


Figure 4. Rear controls.

- O. Main Blade Elevation Handwheel:** Raises and lowers main blade. Lock knob in center secures handwheel to prevent blade from moving during operation.
- P. Rear Emergency Stop Button:** Turns motor **OFF**. Twist clockwise until it pops out to reset.

Scoring Blade Controls

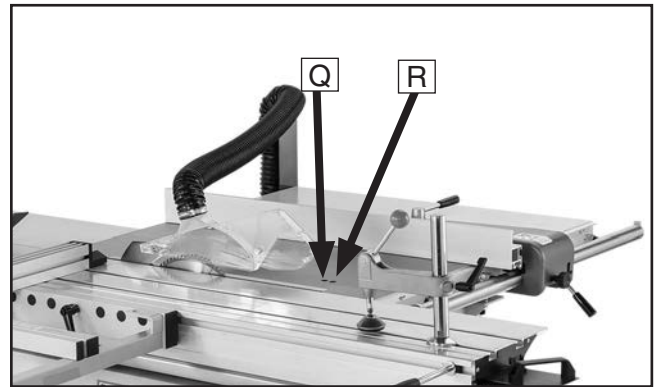


Figure 5. Riving knife controls.

- Q. Scoring Blade Elevation Bolt:** Raises and lowers scoring blade to match kerf thickness of main blade using T-handle wrench.
- R. Scoring Blade Alignment Bolt:** Adjusts alignment of scoring blade to main blade using T-handle wrench.



Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this sliding table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is VERY important to us at Grizzly!

Arbor: Metal shaft extending from the drive mechanism, to which saw blade is mounted.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

Blade Guard: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

Crosscut: Cutting operation in which the cross-cut fence is used to cut across the grain, or across the shortest width of the workpiece.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that cuts a flat bottomed groove into the face of the workpiece.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface.

Kerf: The resulting cut or gap in the workpiece from the saw blade passing through it while cutting.

Kickback: A dangerous event that happens if the blade catches on the workpieces while cutting. The force of the blade then throws the workpiece back toward the operator with what sounds like a horrible explosion. The danger comes from flying stock striking the operator or bystanders. The operator's hands may also be pulled into the blade during the kickback. Refer to **Preventing Kickback** on **Page 13** for additional information.

Non-Through Cut: A sawing operation in which the workpiece is not completely sawn through. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock.

Parallel: When two objects are spaced an equal distance apart at every point along two given lines or planes (i.e. the rip fence face is parallel to the face of the saw blade).

Perpendicular: Lines or planes that intersect and form right angles, i.e. the blade is perpendicular to the table surface.

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece.

Rip Cut: Cutting operation in which the rip fence is used to cut with the grain, or cut across the widest width of the workpiece.

Riving Knife: Metal plate located behind the blade maintains the kerf opening in the wood when cutting, and helps reduce the risk of injury from a kickback that otherwise would result in amputation.

Straightedge: A tool with a perfectly straightedge used to check the flatness, parallelism, or consistency of a surface(s).

Through Cut: A sawing operation in which the workpiece is completely sawn through.

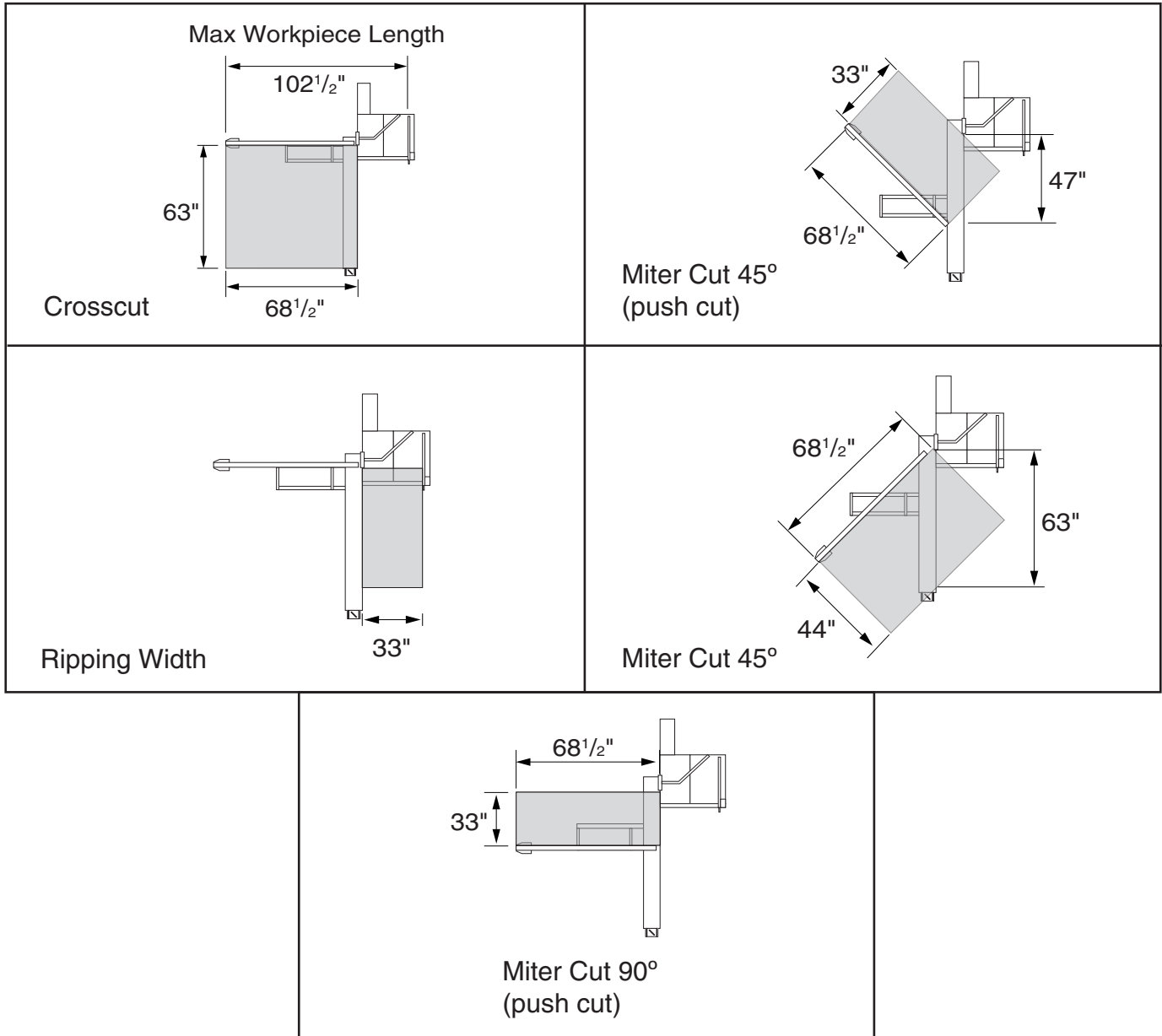




SLIDING TABLE SAW CAPACITIES

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

MODEL G0820 12" COMPACT SLIDING TABLE SAW





MACHINE DATA SHEET

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

MODEL G0820 12" COMPACT SLIDING TABLE SAW

Product Dimensions:

Weight..... 828 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 118 x 90 x 45 in.
 Footprint (Length x Width)..... 35 x 45 in.
 Space Required for Full Range of Movement (Width x Depth)..... 134 x 118 in.

Shipping Dimensions:

Type..... Wood Crate
 Content..... Machine & Sliding Table
 Weight..... 996 lbs.
 Length x Width x Height..... 67 x 46 x 45 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
 Prewired Voltage..... 220V
 Full-Load Current Rating..... 20A at 220V, 10A at 440V
 Minimum Circuit Size..... 30A at 220V, 15A at 440V
 Connection Type..... Cord at 220V, Permanent (Hardwire) at 440V
 Power Cord Included..... No
 Recommended Power Cord..... "S"-Type, 4-Wire, 12 AWG, 300 VAC for 220V
 Recommended Plug Type..... L15-30 for 220V
 Switch Type..... Magnetic Switch w/Overload Protection

Motors:

Main

Horsepower..... 7.5 HP
 Phase..... 3-Phase
 Amps..... 20A/10A
 Speed..... 3450 RPM
 Type..... TEFC Induction
 Power Transfer Belt Drive
 Bearings..... Shielded & Permanently Lubricated
 Centrifugal Switch/Contacts Type..... N/A

Main Specifications:

Operation Information

Main Blade Size..... 12 in.
 Riving Knife/Spreader Thickness..... 0.0984 in.
 Required Blade Body Thickness..... 0.087 in.
 Required Blade Kerf Thickness..... 0.118 in.
 Main Blade Arbor Size..... 1 in.
 Scoring Blade Size..... 4-3/4 in.
 Scoring Blade Arbor Size..... 20 mm
 Main Blade Tilt..... 0 – 45 deg.
 Main Blade Speed..... 4000 RPM
 Scoring Blade Tilt..... 0 – 45 deg.
 Scoring Blade Speed..... 8000 RPM



Cutting Capacities

| | |
|--|------------|
| Max Depth of Cut At 90 Deg..... | 3-5/16 in. |
| Max Depth of Cut At 45 Deg..... | 2-3/8 in. |
| Rip Fence Max Cut Width..... | 33 in. |
| Sliding Table w/Crosscut Fence Max Cut Width..... | 68-1/2 in. |
| Sliding Table w/Crosscut Fence Max Cut Length..... | 63 in. |

Table Information

| | |
|--|------------|
| Floor To Table Height..... | 34-1/4 in. |
| Table Size Length..... | 35-1/4 in. |
| Table Size Width..... | 21-1/2 in. |
| Table Size Thickness..... | 2-1/4 in. |
| Table Size With Ext Wings Length..... | 68 in. |
| Table Size With Ext Wings Width..... | 40 in. |
| Table Size With Ext Wings Thickness..... | 2-3/8 in. |
| Sliding Table Length..... | 63 in. |
| Sliding Table Width..... | 12-1/4 in. |
| Sliding Table Thickness..... | 6 in. |
| Sliding Table T-Slot Top Width..... | 5/8 in. |
| Sliding Table T-Slot Height..... | 5/8 in. |
| Sliding Table T-Slot Bottom Width..... | 1-1/4 in. |

Fence Information

| | |
|---------------------------------|-------------------|
| Crosscut Fence Type..... | Extruded Aluminum |
| Crosscut Fence Size Length..... | 73-1/4 in. |
| Crosscut Fence Size Width..... | 2-3/8 in. |
| Crosscut Fence Size Height..... | 2-3/8 in. |
| Rip Fence Size Length..... | 39-3/8 in. |
| Rip Fence Size Width..... | 2 in. |
| Rip Fence Size Height..... | 3-1/2 in. |

Construction Materials

| | |
|--------------------------------|-----------------------------------|
| Table..... | Cast Iron |
| Sliding Table..... | Aluminum |
| Extension Table..... | Steel |
| Cabinet..... | Steel |
| Rip Fence..... | Aluminum |
| Miter Fence..... | Aluminum |
| Rip Fence Rails..... | Steel |
| Guard..... | Plastic |
| Spindle Bearing Type..... | Sealed and Permanently Lubricated |
| Cabinet Paint Type/Finish..... | Powder Coated |

Other Related Information

| | |
|-----------------------|--------------|
| No of Dust Ports..... | 2 |
| Dust Port Size..... | 2-1/2, 5 in. |

Other Specifications:

| | |
|--|------------------|
| Country of Origin | Taiwan |
| Warranty | 1 Year |
| Approximate Assembly & Setup Time | 3 Hours |
| Serial Number Location | Machine ID Label |
| Sound Rating | 82 dB |
| ISO 9001 Factory | Yes |
| Certified by a Nationally Recognized Testing Laboratory (NRTL) | No |



SECTION 1: SAFETY

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

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgment.

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

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

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

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

Safety Instructions for Machinery

⚠ WARNING

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

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

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

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

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Sliding Table Saws

WARNING

Serious injury or death can occur from getting cut or having body parts, such as fingers, amputated by rotating saw blade. Workpieces thrown by kickback can strike operators or bystanders with deadly force. Flying particles from cutting operations or broken blades can cause eye injuries or blindness. To minimize risk of getting hurt or killed, anyone operating machine **MUST** completely heed hazards and warnings below.

HAND & BODY POSITIONING. Keep hands away from saw blade and out of blade path during operation, so they cannot slip accidentally into blade. Stand to side of blade path. Never reach around, behind, or over blade. Only operate at front of machine.

BLADE GUARD. Use blade guard for all cuts that allow it to be used safely. Make sure blade guard is installed and adjusted correctly. Promptly repair or replace if damaged. Re-install blade guard immediately after operations that require its removal.

RIVING KNIFE. Use riving knife for all cuts. Make sure riving knife is aligned and positioned correctly. Promptly repair or replace it if damaged.

KICKBACK. Kickback occurs when saw blade ejects workpiece back toward operator. Know how to reduce risk of kickback. Learn how to protect yourself if it does occur.

WORKPIECE CONTROL. Feeding workpiece incorrectly increases risk of kickback. Make sure workpiece is in stable position on tables and supported by rip fence or crosscut fence during cutting operation. Never start saw with workpiece touching blade. Allow blade to reach full speed before cutting. Only feed workpiece against direction of main blade rotation. Always use some type of guide to feed workpiece in a straight line. Never back workpiece out of cut or move it backwards or sideways after starting a cut. Feed cuts all the way through to completion. Never perform any operation “freehand”. Turn OFF saw and wait until blade is completely stopped before removing workpiece.

FENCE ADJUSTMENTS. Make sure rip fence remains properly adjusted and parallel with blade. Never move fence while blade is rotating. Adjusting fence during operation increases risk of crashing fence and sending metal fragments flying with deadly force at operator or bystanders. Only adjust fence when blade is completely stopped and saw is **OFF**. Always lock fence before using.

PUSH STICKS/BLOCKS. Use push sticks or push blocks whenever possible to keep your hands farther away from blade while cutting. In event of an accident these devices will often take damage that would have happened to hands/fingers.

BLADE ADJUSTMENTS. Adjusting blade height or tilt during operation increases risk of crashing blade and sending metal fragments flying with deadly force at operator or bystanders. Only adjust blade height and tilt when blade is completely stopped and saw is **OFF**.

CHANGING BLADES. Always disconnect power before changing blades. Changing blades while saw is connected to power greatly increases injury risk if saw is accidentally powered up.

DAMAGED SAW BLADES. Never use blades that have been dropped or otherwise damaged.

CUTTING CORRECT MATERIAL. Never cut materials not intended for this saw. Only cut natural and man-made wood products, laminate covered wood products, and some plastics. Cutting metal, glass, stone, tile, etc. increases risk of operator injury due to kickback or flying particles.



Preventing Kickback

To prevent kickback:

- When rip cutting, only cut workpieces that have at least one smooth and straightedge. DO NOT cut excessively warped, cupped or twisted wood. If workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.
- Ensure sliding table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table before cutting.
- Always use the riving knife whenever possible. It reduces risk of kickback and reduces your risk of injury if it does occur.
- Always keep blade guard installed and in good working order.
- Feed cuts through to completion. Any time you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.
- Ensure rip fence is adjusted parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the rip fence before cutting.

WARNING

Statistics show that the most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward the operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some precautions to help protect yourself if kickback DOES occur:

- Stand to the side of the blade path when cutting. If a kickback does occur, the thrown workpiece usually travels directly towards the front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable parts of your body.
- Never, for any reason, place your hand behind the blade path. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick or push block to keep your hands farther away from the moving blade. If a kickback occurs, these safety devices will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to prevent or slow down kickback.

WARNING

For Your Own Safety Read Instruction Manual Before Operating Saw

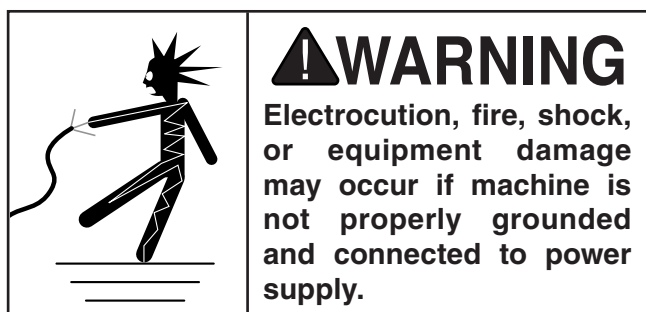
- a) Wear eye protection.
- b) Use saw-blade guard and splitter/riving knife for every operation for which it can be used, including all through sawing.
- c) Keep hands out of the line of saw blade.
- d) Use a push-stick when required.
- e) Pay particular attention to instructions on reducing risk of kickback.
- f) Do not perform any operation freehand.
- g) Never reach around or over saw blade.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 220V 20 Amps

Full-Load Current Rating at 440V 10 Amps

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

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

Circuit Requirements for 220V

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

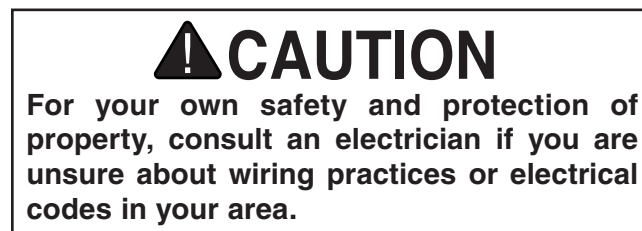
Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase 3-Phase
Power Supply Circuit 30 Amps
Plug/Receptacle NEMA L15-30
Cord "S"-Type, 4-Wire, 12 AWG, 300 VAC

Circuit Requirements for 440V

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 440V, 480V
Cycle 60 Hz
Phase 3-Phase
Power Supply Circuit 15 Amps
Connection Hardwire w/Locking Switch

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



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



Grounding Instructions

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

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

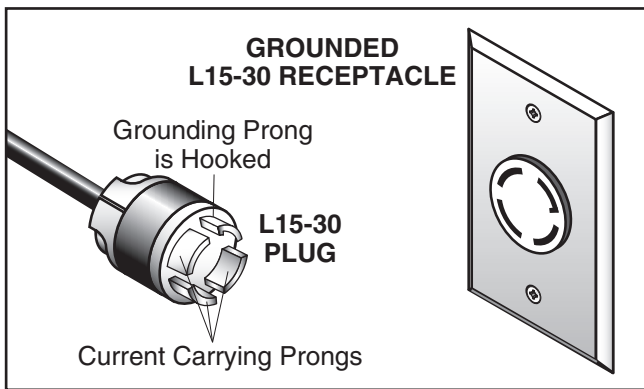


Figure 6. Typical L15-30 plug and receptacle.

For 440V operation: As specified in “Circuit Requirements for 440V” on the previous page, the machine must be hardwired to the power source, using a locking switch as a disconnecting means (see below). The machine must also be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. Due to the complexity and high voltage involved, this type of installation **MUST** be done by a qualified electrician.

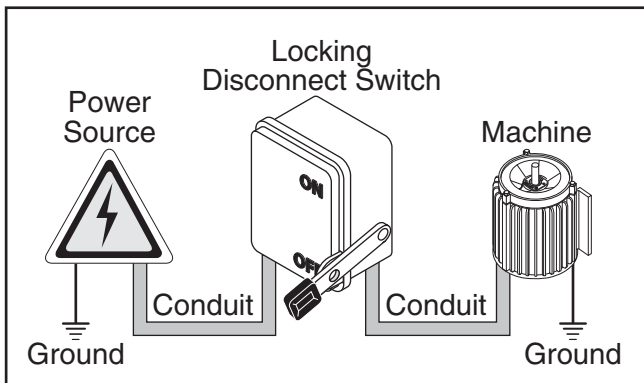


Figure 7. Typical hardwire setup with a locking disconnect switch.

!WARNING

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

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

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

Extension Cords (220V Only)

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.**

NOTICE

Avoid using static phase converter to supply 3-Phase power, as it could damage or decrease life of sensitive electrical components. If you must use a phase converter, only use a rotary phase converter that is sized at least 50% larger than largest HP rating of this machine.



440V Conversion

The Model G0820 can be converted from 220V to 440V operation using the optional part #P08200084. This can be purchased from the Grizzly Order desk at (800) 523-4777. This conversion consists of: 1) Disconnecting the saw from the power source, 2) moving the fuse to the 440V holder, 3) replacing the magnetic switch overload relay, and 4) rewiring the motor junction box for 440V operation. Refer to **Page 83** for the detailed 440V wiring diagram.

All wiring changes must be done by an electrician or qualified service personnel before the saw is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

Before performing the conversion procedure, we recommend setting the blade to 0° and raising it all the way up to create clearance under the motor junction box for rewiring.

To convert G0820 for 440V operation:

1. DISCONNECT MACHINE FROM POWER!
2. Remove magnetic switch cover (see **Figure 8**).

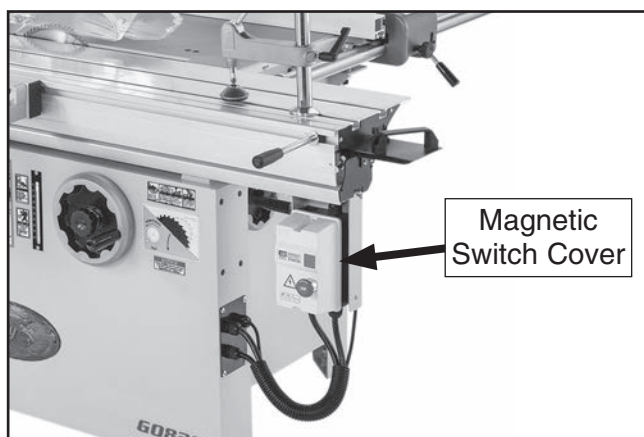


Figure 8. Location of magnetic switch cover.

3. Remove fuse from "220V" fuse holder and insert into "440V" fuse holder (see **Figure 9**).

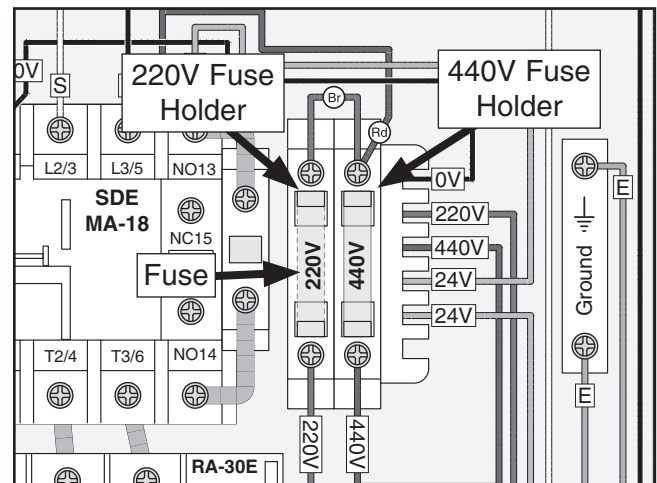


Figure 9. Moving fuse to "440V" fuse holder.

4. Remove overload relay for 220V and replace with overload relay from 440V Conversion Kit. Set amperage dial to 10A (see **Figure 10**).

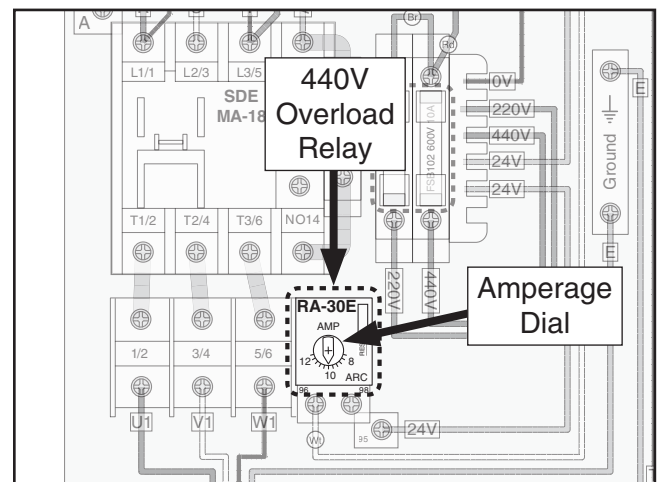
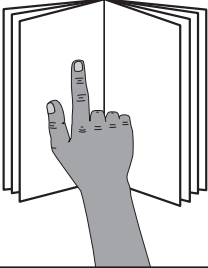


Figure 10. Overload relay for 440V Conversion Kit installed and set for specified trip current.

5. Open cabinet door on back of saw and remove motor junction box cover.
6. Rewire motor according to wiring diagram on **Page 83**.
7. Re-install motor junction box cover and close cabinet door.
8. After **Setup** and **Assembly** procedures are completed, connect machine to power, as instructed on **Page 34**.



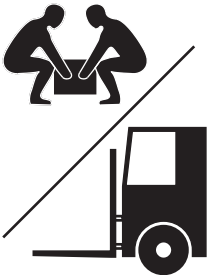
SECTION 3: SETUP



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



!WARNING
Wear safety glasses during the entire setup process!



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

Needed for Setup

The following items are needed, but not included, for the setup/assembly of this machine.

| Items Needed | Qty |
|---|-----------|
| • Additional People | 2 |
| • Safety Glasses (for each person)..... | 1 |
| • Heavy Leather Gloves..... | 1 Pair |
| • Forklift (Rated for at least 1200 lbs.) | 1 |
| • Cleaner/Degreaser (Page 21) | As Needed |
| • Disposable Shop Rags..... | As Needed |
| • Disposable Gloves | As Needed |
| • Main Blade (Page 66) | 1 |
| • Prybar..... | 1 |
| • Straightedge 4' | 1 |
| • Level | 1 |
| • Phillips Screwdriver #2 | 1 |
| • Open-End Wrenches 10, 13, 24mm | 1 Ea. |
| • Hex Wrenches 2.5, 3, 4, 5, 6, 8mm | 1 Ea. |
| • Dust Collection System | 1 |
| • Branch Line 5" | 1 |
| • Y-Fitting 2½" x 5" x 5" | 1 |
| • Dust Hose 5" | 1 |
| • Hose Clamps 5" | 2 |
| • Dust Hose 2½" | 1 |
| • Hose Clamps 2½" | 2 |

Unpacking

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

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



Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

#10

1/4"

5/16"

3/8"

7/16"

1/2"

4mm

5mm

6mm

8mm

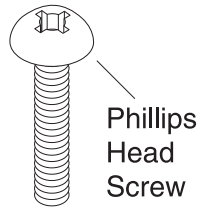
10mm

12mm

16mm



Hex Wrench



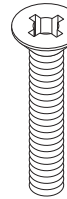
Phillips Head Screw



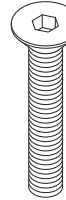
Lock Nut



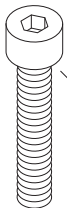
Wing Nut



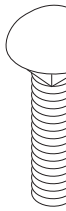
Flat Head Screw



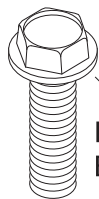
Flat Head Cap Screw



Cap Screw



Carriage Bolt



Flange Bolt



Button Head Screw



Tap Screw



External Retaining Ring



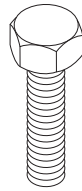
Internal Retaining Ring



E-Clip



Set Screw



Hex Bolt



Key



Flat Washer

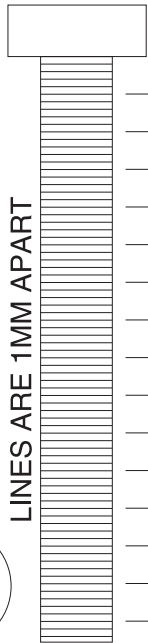


Lock Washer



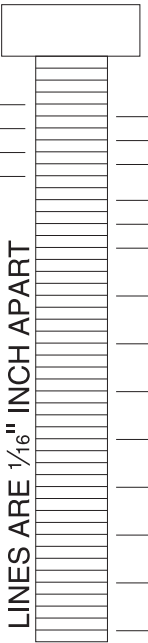
Hex Nut

LINES ARE 1MM APART



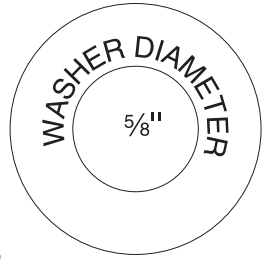
5mm
10mm
15mm
20mm
25mm
30mm
35mm
40mm
45mm
50mm
55mm
60mm
65mm
70mm
75mm

LINES ARE 1/16" INCH APART

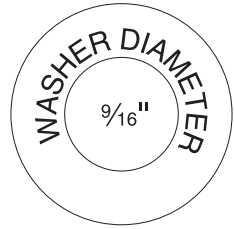


1/4"
3/8"
1/2"
5/8"
5/16"
7/16"
9/16"
3/4"
7/8"
1"
1 1/4"
1 1/2"
1 3/4"
2
2 1/4"
2 1/2"
2 3/4"
3

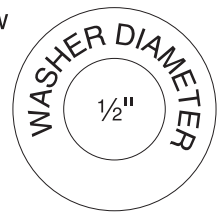
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



WASHER DIAMETER
5/8"



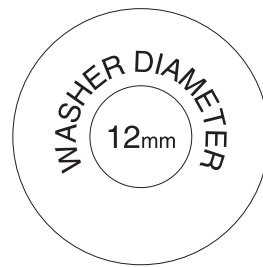
WASHER DIAMETER
9/16"



WASHER DIAMETER
1/2"



WASHER DIAMETER
7/16"



WASHER DIAMETER
12mm



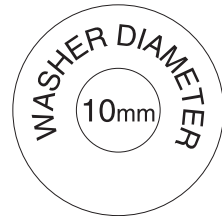
WASHER DIAMETER
3/8"



WASHER DIAMETER
4mm



WASHER DIAMETER
5/16"



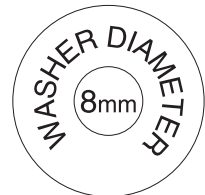
WASHER DIAMETER
10mm



WASHER DIAMETER
5mm



WASHER DIAMETER
1/4"



WASHER DIAMETER
8mm



WASHER DIAMETER
6mm



WASHER DIAMETER
#10



Inventory

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

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

NOTICE

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

| Box Inventory 1 (Figure 11) | Qty |
|-------------------------------------|-----|
| A. Small Extension Table..... | 1 |
| B. Large Extension Table | 1 |
| C. Crosscut Table | 1 |
| D. Rip Fence Rail w/Fasteners | 1 |
| E. Crosscut Fence Assembly | 1 |
| F. Rip Fence | 1 |
| G. Rip Fence Scale..... | 1 |
| H. Access Door..... | 1 |

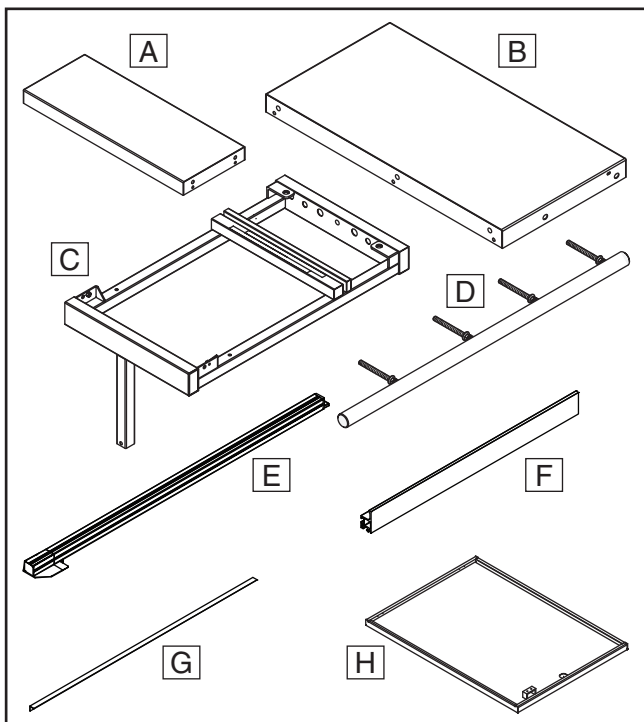


Figure 11. G0820 Box Inventory 1.

| Box Inventory 2 (Figure 12) | Qty |
|--|-----|
| I. Rip Fence Base..... | 1 |
| J. Push Handle..... | 1 |
| K. Flip Stop | 1 |
| L. Push Stick | 1 |
| M. Edge Shoe Assembly..... | 1 |
| N. Hold-Down Assembly..... | 1 |
| O. Splitter/Riving Knife | 1 |
| P. Blade Guard | 1 |
| Q. Riving Knife (Toolbox) | 1 |
| R. End Plate..... | 1 |
| S. End Cover..... | 1 |
| T. End Cap | 1 |
| U. Arbor Wrench (Toolbox) | 1 |
| V. Closed-End Wrench 17/19mm (Toolbox).... | 1 |
| W. Combo Wrench 30mm (Toolbox) | 1 |
| X. T-Handle Wrench 8mm (Toolbox) | 1 |
| Y. Toolbox..... | 1 |

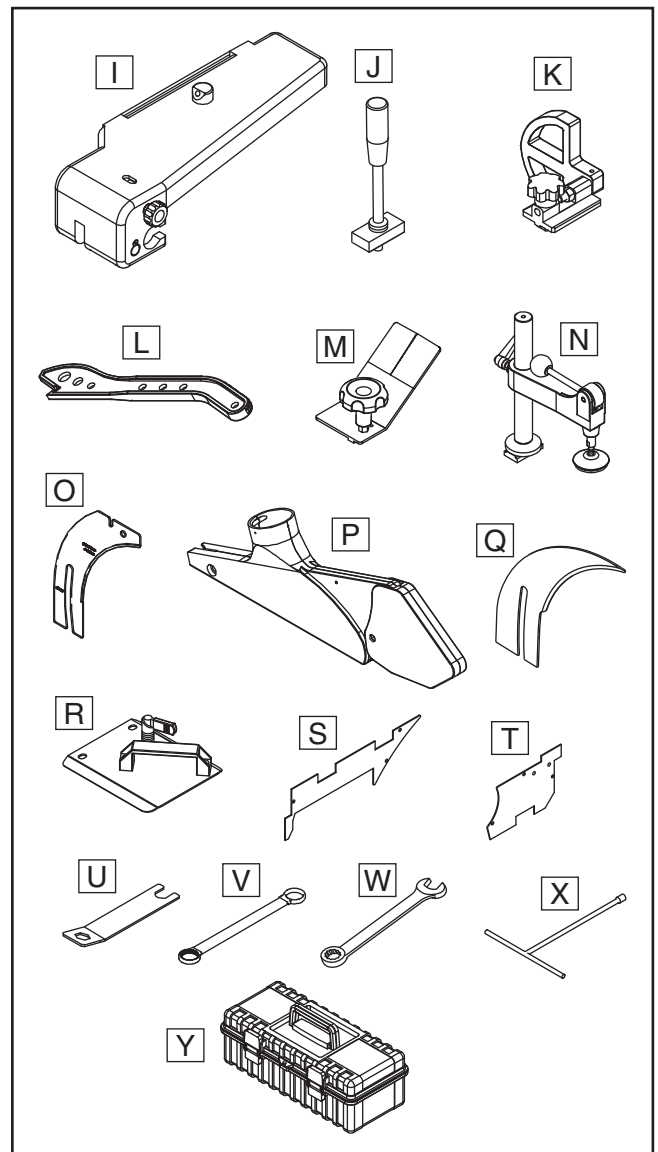


Figure 12. G0820 Box Inventory 2.



| Box Inventory 3 (Figure 13) | Qty |
|---|------------|
| Z. Lock Handles M10-1.5 x 12 | 2 |
| AA. Lock Knob Bolt M10-1.5 x 55 | 1 |
| AB. Rip Fence Stop Ring w/Set Screw | 1 |
| AC. Rip Fence End Stop | 1 |
| AD. Adjustable Lock Handle M12-1.75 x 55 | 1 |
| AE. T-Nut M12-1.75..... | 1 |
| AF. T-Nuts M8-1.25..... | 2 |
| AG. 0° Stop Block..... | 1 |
| AH. T-Bolt M8-1.25 x 60..... | 1 |
| AI. Pivot Bolt M8-1.25..... | 1 |
| AJ. Long Knob M8-1.25..... | 1 |
| AK. Knob Bolt M8-1.25 x 50 | 1 |
| AL. Hose Clamps 2½" | 2 |
| AM. Dust Hose Support..... | 1 |

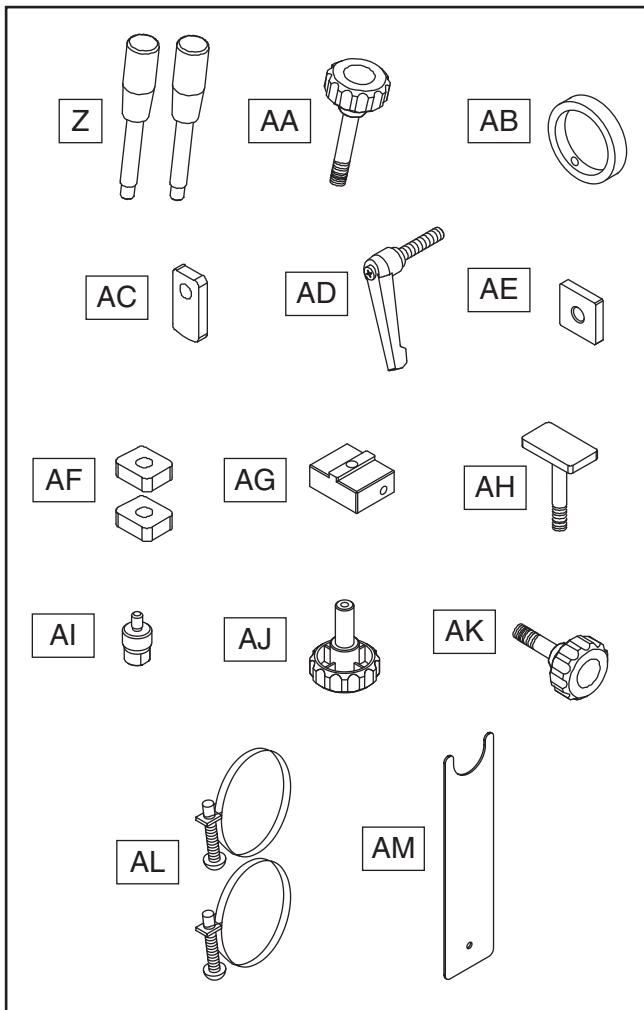


Figure 13. G0820 Box Inventory 3.

Fasteners (see Hardware Recognition Chart)

| | |
|------------------------------------|---|
| Hex Bolts M16-2 x 40 (Stand) | 4 |
| Hex Nuts M16-2 (Stand)..... | 4 |

| | |
|---|---|
| B.H. Cap Screws M6-1 x 20 (End Plate) | 2 |
| Flat Washers 6mm (End Plate) | 4 |
| Lock Washers 6mm (End Plate)..... | 2 |
| Hex Nuts M6-1 (End Plate)..... | 2 |

| | |
|--|---|
| Cap Screws M10-1.5 x 25 (Large Ext. Table).... | 3 |
| Lock Washers 10mm (Large Ext. Table) | 3 |
| Flat Washers 10mm (Large Ext. Table)..... | 3 |
| Set Screws M10-1.5 x 20 (Large Ext. Table).... | 3 |
| Hex Nuts M10-1.5 (Large Ext. Table) | 3 |

| | |
|---|---|
| Cap Screws M10-1.5 x 25 (Small Ext. Table) | 2 |
| Lock Washers 10mm (Small Ext. Table) | 2 |
| Flat Washers 10mm (Small Ext. Table)..... | 2 |
| Set Screws M10-1.5 x 20 (Small Ext. Table) | 2 |
| Hex Nuts M10-1.5 (Small Ext. Table)..... | 2 |

| | |
|---|---|
| B.H. Cap Screws M6-1 x 12 (Rip Fence Scale) 3 | |
| Flat Washers 6mm (Rip Fence Scale) | 4 |
| Hex Nut M6-1 (Rip Fence Scale) | 1 |
| Cap Screw M8-1.25 x 15 (Rip Fence Rail) | 1 |
| Lock Washer 8mm (Rip Fence Rail) | 1 |

| | |
|---|---|
| Cap Screw M8-1.25 x 35 (Crosscut Fence) | 1 |
| Lock Washer 8mm (Crosscut Fence)..... | 1 |
| Flat Washer 8mm Fiber (Crosscut Fence) | 1 |

| | |
|--|---|
| Flat Washer 12mm (Crosscut Table) | 1 |
| Fender Washer 8mm (Crosscut Table) | 1 |
| Hex Nuts M8-1.25 (Crosscut Table)..... | 2 |
| Flat Washer 8mm (Crosscut Table) | 1 |

| | |
|---|---|
| Cap Screw M10-1.5 x 25 (Blade Guard)..... | 1 |
| Lock Nut M10-1.5 (Blade Guard) | 1 |

| | |
|--|---|
| Cap Screw M10-1.5 x 20 (Dust Hose) | 1 |
| Flat Washer 10mm (Dust Hose) | 1 |
| Lock Nut M10-1.5 (Dust Hose) | 1 |



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.

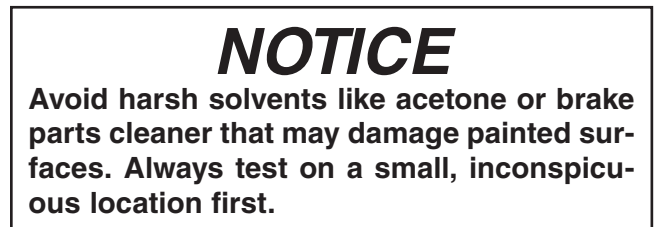
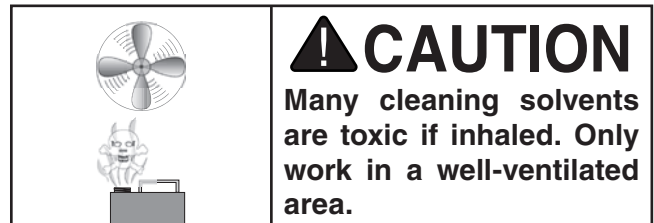
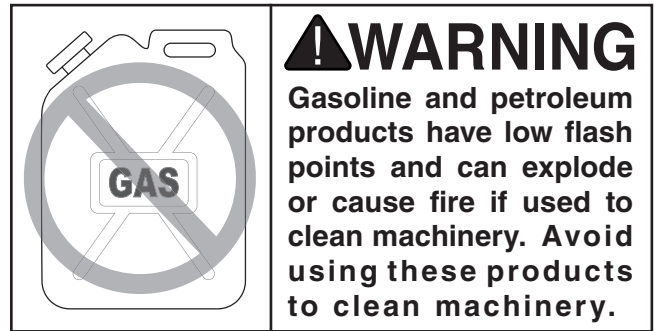
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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 14. T23692 Orange Power Degreaser.



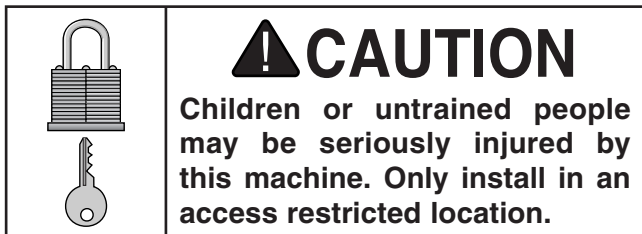
Site Considerations

Weight Load

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

Space Allocation

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



Physical Environment

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

Electrical Installation

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

Lighting

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

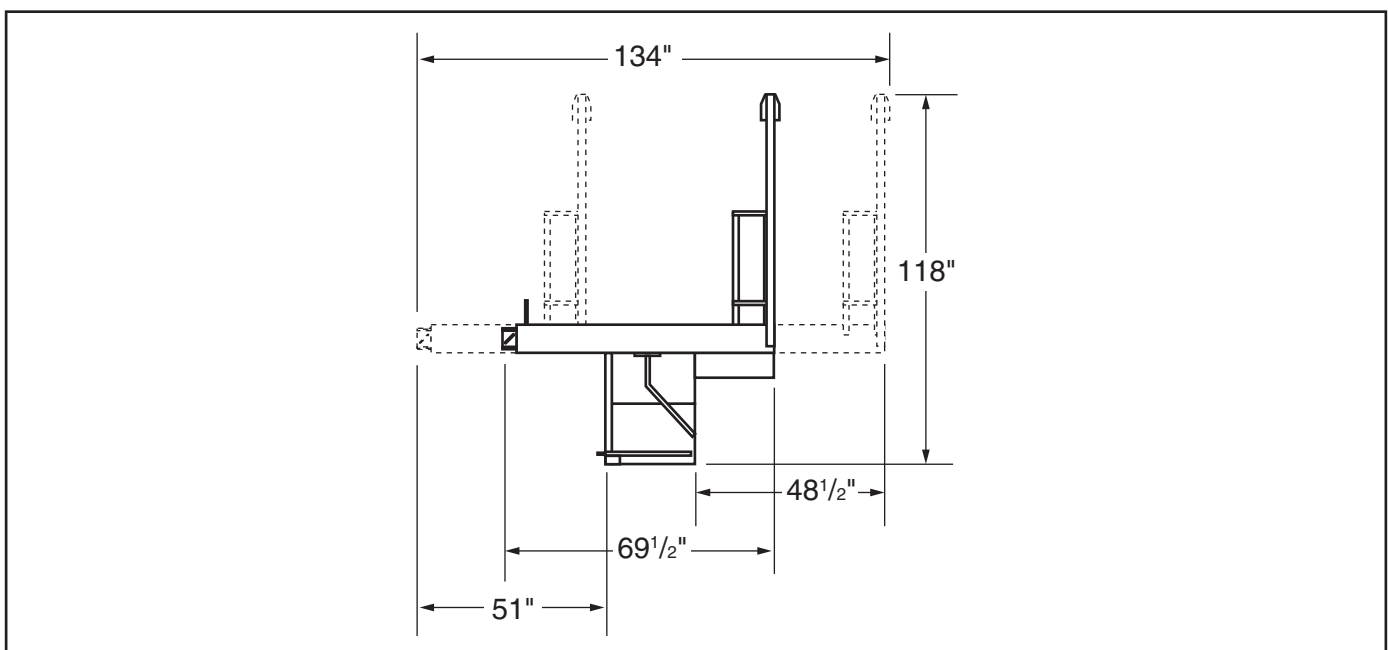



Figure 15. Minimum working clearances.



Lifting & Placing



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

| Item Needed | Qty |
|-------------------------------------|-----|
| Forklift (rated for 1200 lbs.)..... | 1 |

To lift and place saw:

1. Position crate as close to installation location as possible.
2. Remove top of crate. Position forklift forks as wide as possible while still fitting under center opening (see **Figure 16**).



Figure 16. Inserting forks for lifting table saw off pallet.

3. Remove small items packed around saw and unbolt saw from pallet.

!WARNING

DO NOT lift saw any higher than necessary to clear pallet. Serious personal injury and machine damage may occur if safe moving methods are not followed.

4. With an assistant holding each end to help stabilize load, lift saw with forklift just high enough to clear pallet, and move it to your predetermined location.
5. Lower saw onto ground and back forklift away.
6. Place level on cast-iron table.
7. If not already installed, thread (1) M16-2 hex nut onto each M16-2 x 40 hex bolt, then thread each bolt into stand corners (see **Figure 17**).

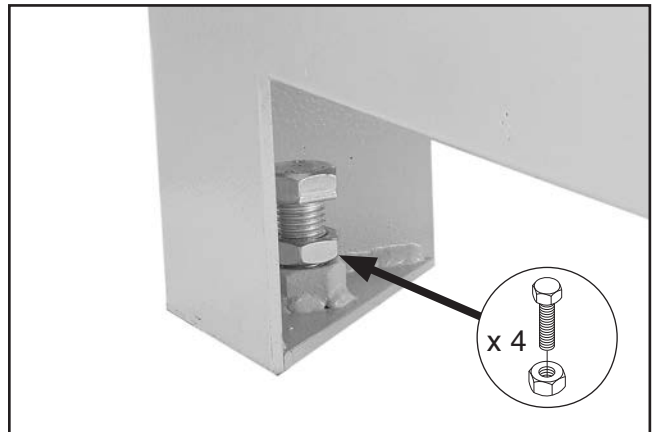


Figure 17. Hex bolt (1 of 4) in stand corner for leveling.

8. Use hex bolts to level saw table from left-to-right and from front-to-back. Leveling saw allows sliding table to move smoothly.
9. Tighten hex nuts against frame to prevent hex bolts from moving after leveling.

NOTICE

Hardwired machines *must* be secured to the floor.



Assembly

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

To assemble sliding table saw:

1. Remove shipping brace shown in **Figure 18** from end of sliding table.

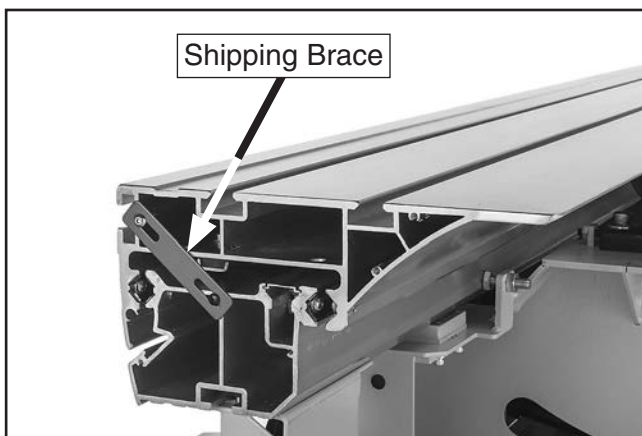


Figure 18. Shipping brace location.

2. Attach end cap with (2) pre-installed M4 x 8 tap screws (see **Figure 19**).

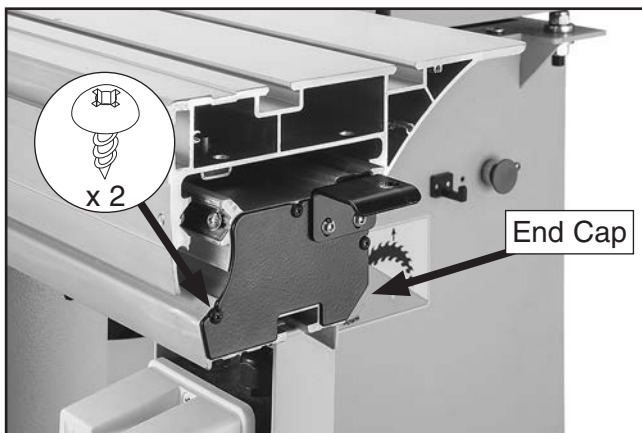


Figure 19. End cap attached to sliding table.

3. Pull sliding table forward a few inches and attach end plate with handle, as shown in **Figure 20**, using (2) M6-1 x 20 button head cap screws, (4) 6mm flat washers, (2) 6mm lock washers, and (2) M6-1 hex nuts.

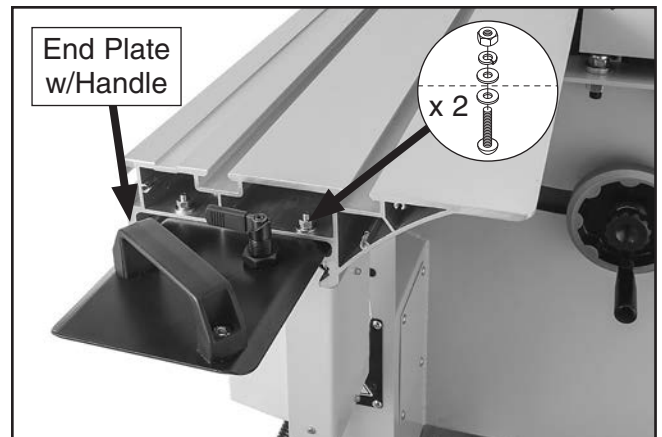


Figure 20. End plate with handle installed onto sliding table.

4. Attach end cover to sliding table with (3) pre-installed M5-.8 x 10 button head cap screws (see **Figure 21**).
5. Slide M12-1.75 T-nut on push handle assembly into T-slot at front end of sliding table, as shown in **Figure 21**, then tighten handle. It may be necessary to loosen T-nut first.

Note: Make sure pre-installed 12mm flat washer and 12mm copper washer are positioned in front of T-slot, as shown in **Figure 21**.

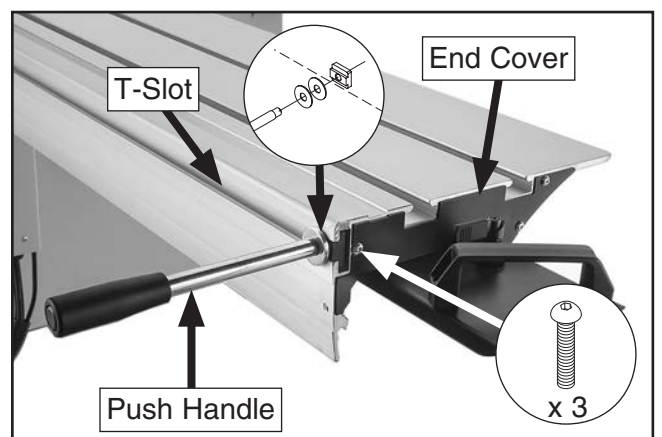


Figure 21. End cover and push handle installed.



- Attach cabinet door by sliding hinge sleeves over pins of already attached hinge (see **Figure 22**).

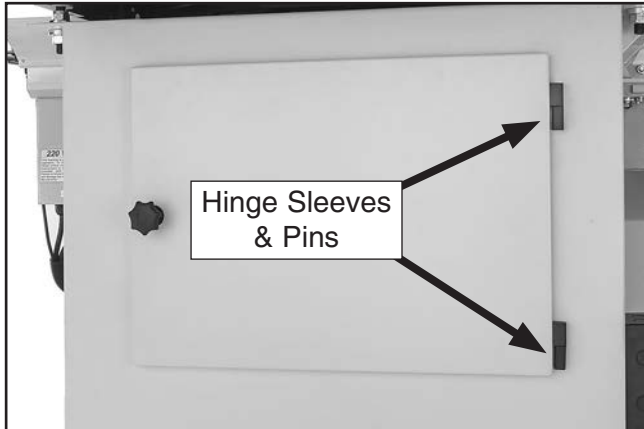


Figure 22. Cabinet door attached on hinges.

- With help from another person, attach large extension table to cast-iron table with (3) M10-1.5 x 25 cap screws, (3) 10mm lock washers, and (3) 10mm flat washers (see **Figure 23**). Finger-tighten only, for now.
- Thread (3) M10-1.5 x 20 set screws with (3) M10-1.5 hex nuts shown in **Figure 23**.

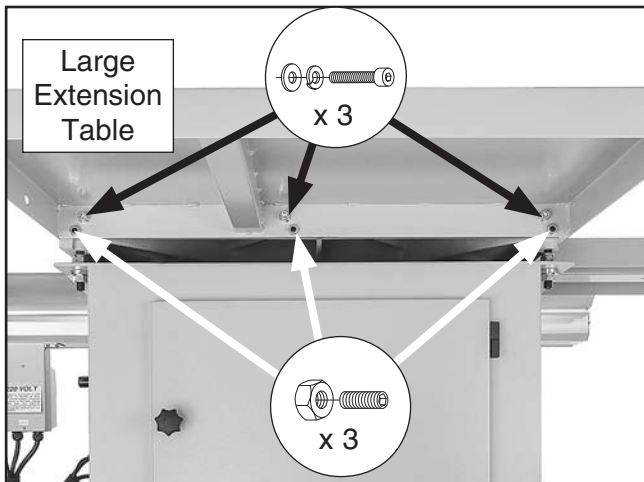


Figure 23. Large extension table attached to cabinet.

- Place straightedge across cast-iron table and large extension table to verify table parallelism.

- If entire length of straightedge *is* parallel with both tables, proceed to **Step 10**.

- If both tables are *not* parallel with straight-edge, loosen hex nuts on set screws shown in **Figure 23**. Adjust set screws to align top of extension table with top of cast-iron table, then re-tighten hex nuts to secure setting.

- Fully tighten cap screws from **Step 7**.

- Attach small extension table to cast-iron table with (2) M10-1.5 x 25 cap screws, (2) 10mm flat washers, and (2) 10mm lock washers (see **Figure 24**). Finger-tighten for now.

- Thread (2) M10-1.5 x 20 set screws with (2) M10-1.5 hex nuts where shown in **Figure 24**.

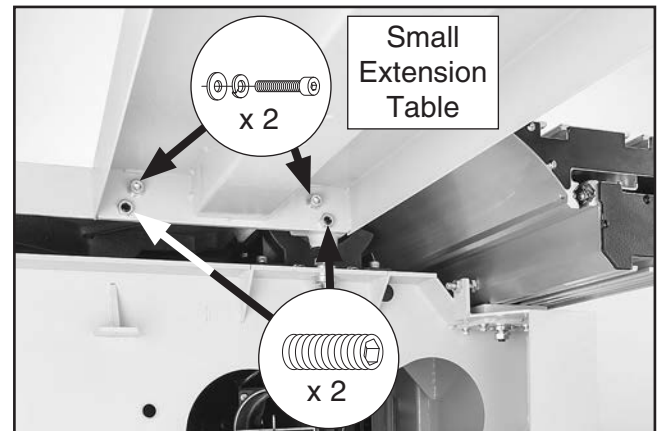


Figure 24. Small extension table attached to cabinet.

- Place straightedge across cast-iron table and small extension table to verify table parallelism.

- If entire length of straightedge *is* parallel with both tables, move on to **Step 14**.

- If both tables are *not* parallel with straight-edge, loosen hex nuts on set screws shown in **Figure 24**. Adjust set screws to align top of small extension table with top of cast-iron table, then re-tighten hex nuts to secure setting.



14. Fully tighten cap screws from **Step 11**.
15. Attach rip fence scale flush along top edge of cast-iron table and large extension table (see **Figure 25**) with (3) M6-1 x 12 button head cap screws, (4) 6mm flat washers, and (1) M6-1 hex nut.

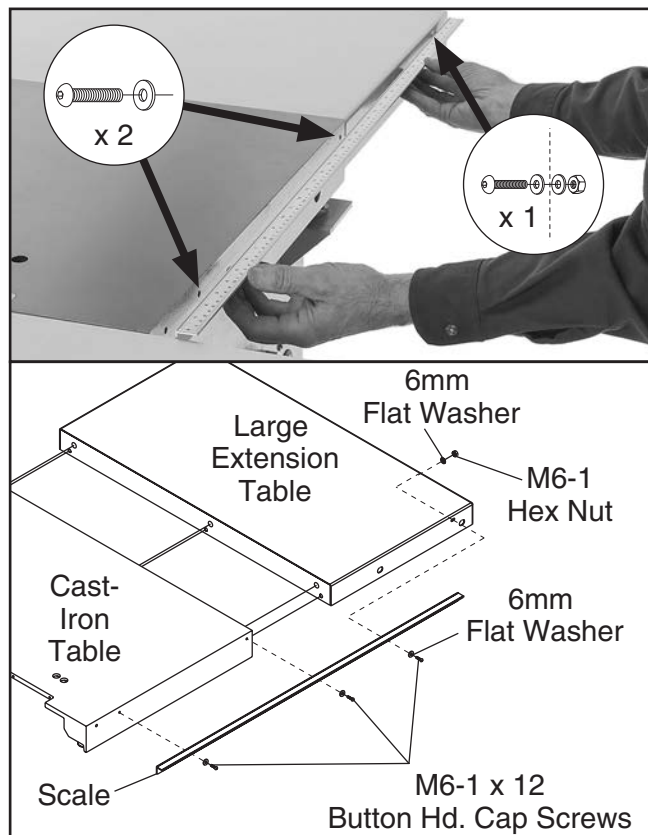


Figure 25. Mounting rip fence scale.

16. Rip fence rail is pre-assembled with (4) rail studs and accompanying hardware. Remove (1) hex nut, (1) lock washer, and (1) flat washer from end of each stud, as shown in **Figure 26**.

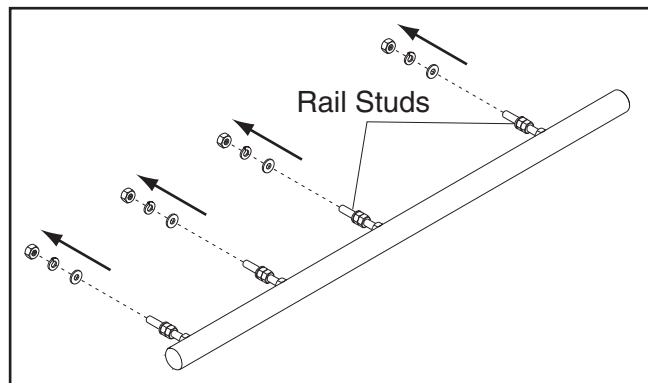


Figure 26. Removing rip fence rail hardware to prepare for installation.

17. Insert studs into tables (see **Figure 27**), and attach with hardware removed in **Step 16**.

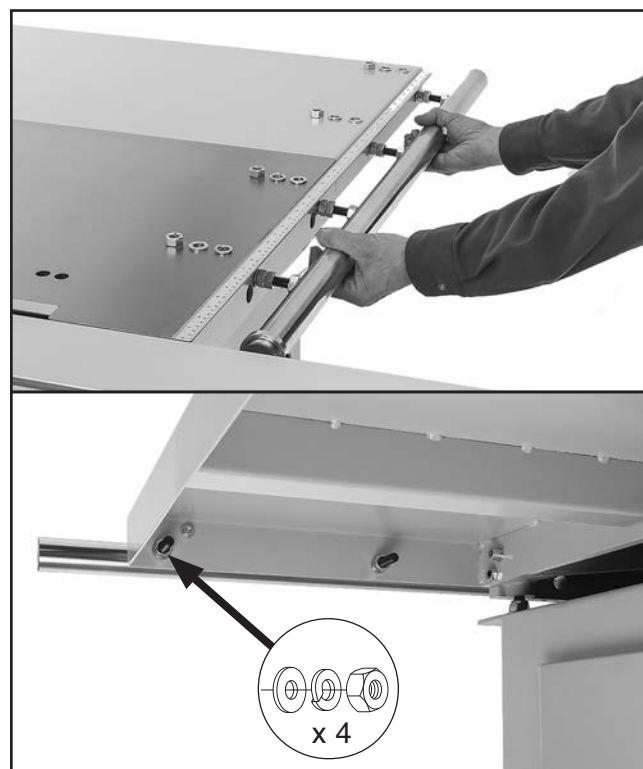


Figure 27. Installing rip fence rail.

18. Slide rip fence base onto fence rail, as shown in **Figure 28**.
19. Thread (2) M10-1.5 x 12 lock handles and M10-1.5 x 55 lock knob bolt into rip fence base, as shown in **Figure 28**.

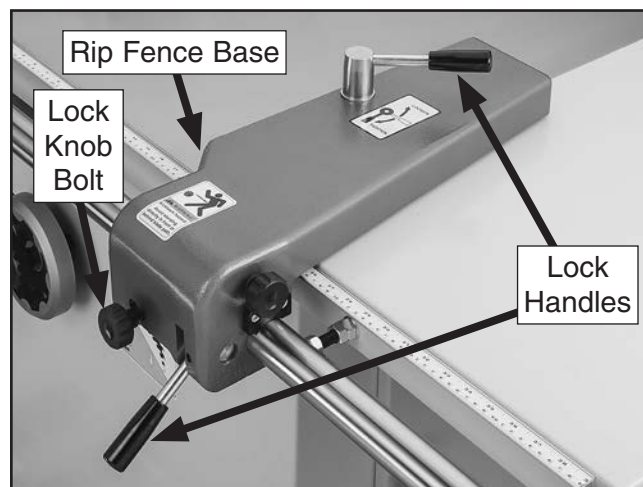


Figure 28. Rip fence attached with lock handles and lock knob installed.



- Slide rip fence onto clamping plate and lock with slide-lock handle (see **Figure 29**).

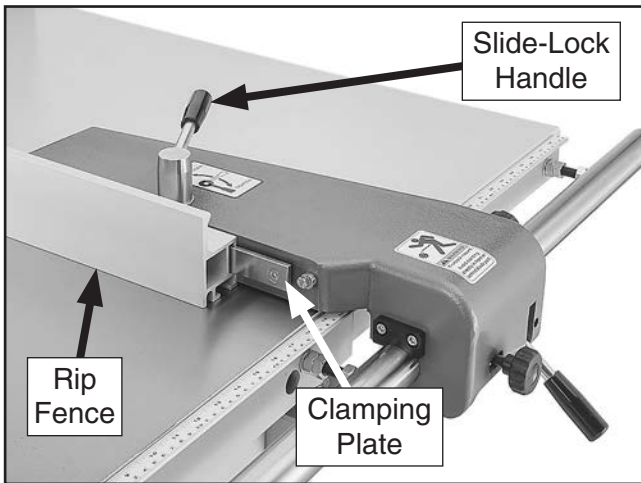


Figure 29. Rip fence attached to rip fence base.

- Move sliding table all the way forward to expose blade cover. Pull blade cover toward front of machine to disengage magnetic catches (see **Figure 30**).

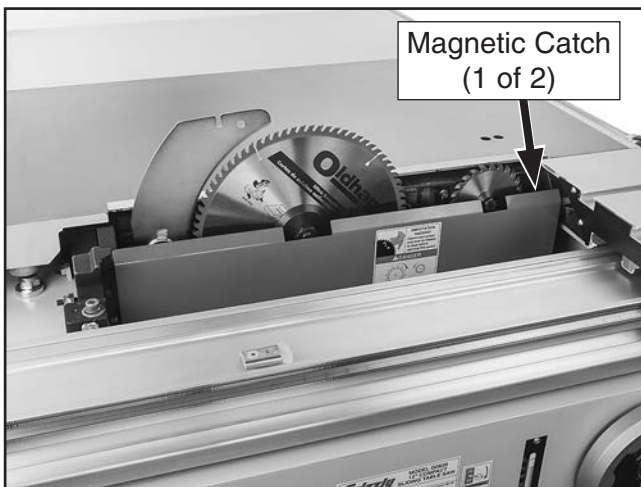


Figure 30. Location of magnetic catches that secure blade cover.

NOTICE

The Model G0820 does not ship with a 12" main blade. Refer to *Blade Requirements* and *Blade Selection* beginning on Page 44 when purchasing the main blade.

- Insert T-handle wrench into access hole shown in **Figure 31**.

Note: Main blade is shown here only for illustrative purposes.

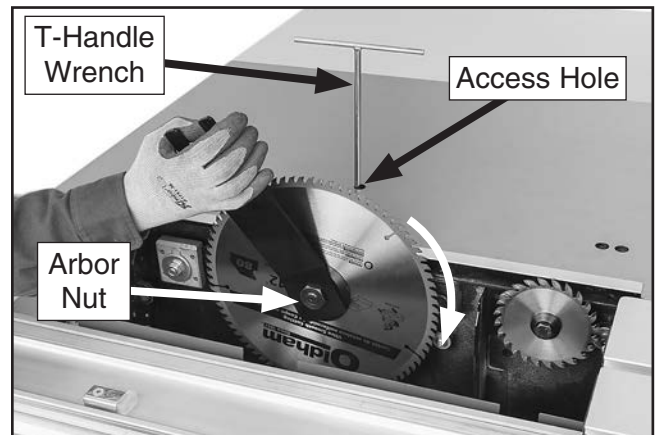


Figure 31. Loosening main blade arbor bolt.

- Push down on T-handle wrench with one hand and rotate arbor nut clockwise (left-handed threads) to force end of T-handle wrench into arbor indent and prevent arbor from rotating in next steps.
- Continue loosening arbor nut clockwise until blade flange can be removed (see **Figure 32**).

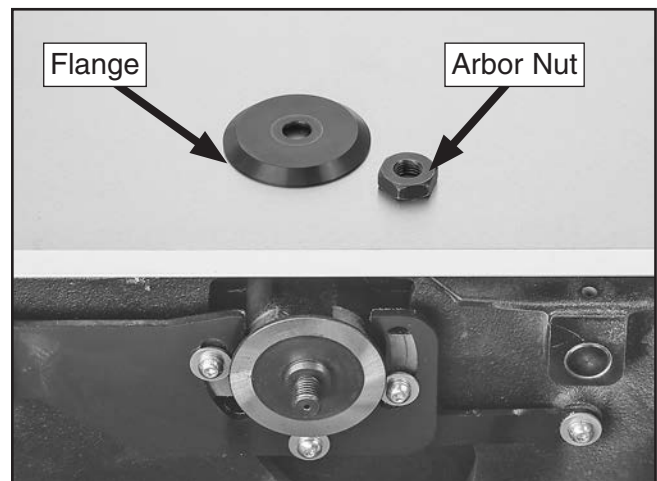


Figure 32. Flange and arbor nut removed from arbor.



⚠ CAUTION

Before proceeding with the next steps, wear gloves to protect your hands when handling and installing blade.

25. Slide main blade (not included) over arbor with teeth facing right, then install flange (see **Figure 33**).

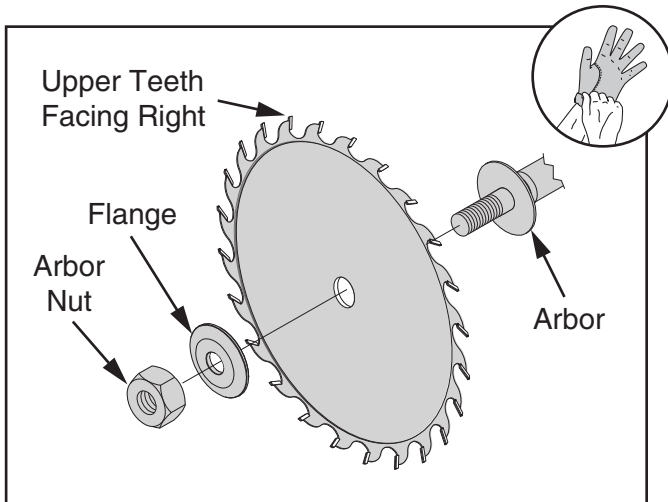


Figure 33. Main blade component assembly.

26. While still holding T-handle wrench, thread arbor nut on counterclockwise and fully tighten to secure blade (see **Figure 34**).

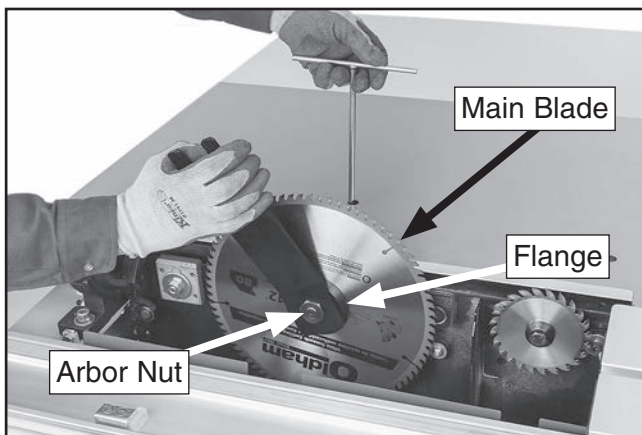


Figure 34. Main blade installed on arbor.

27. Close blade cover, then move sliding table all the way back and remove T-handle wrench.

28. Install riving knife or splitter/riving knife (see **Figure 35**). DO NOT tighten mounting bolt at this time (see **Riving Knife Alignment** on **Page 43** for detailed information).

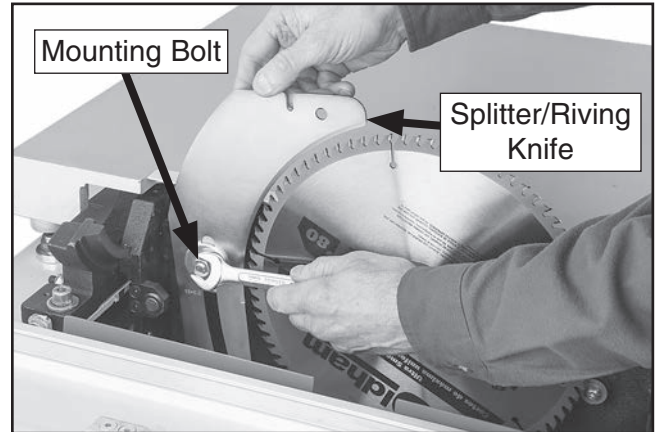


Figure 35. Installing splitter/riving knife.

29. Adjust riving knife or splitter/riving knife approximately $\frac{1}{8}$ " away from main blade, using a $\frac{1}{8}$ " or 3mm hex wrench as a guide (see **Figure 36**).

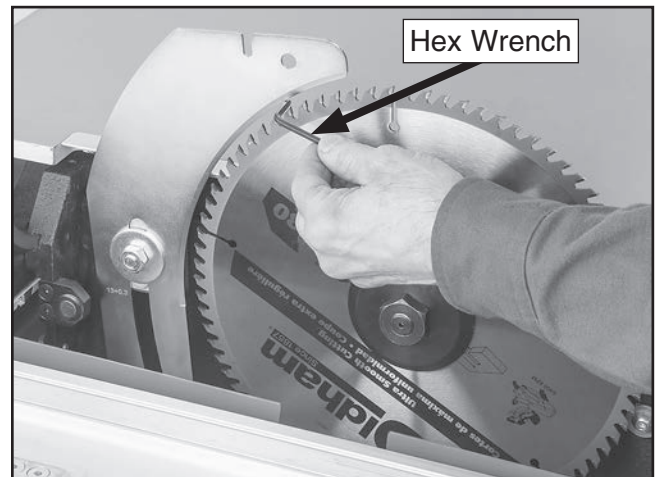


Figure 36. Adjusting splitter/riving knife-to-blade spacing.



30. Use straightedge to make sure riving knife or splitter/riving knife and scoring blade are aligned with main blade, as shown in **Figure 37**. Alignment should be with blade bodies, not carbide teeth (see inset).

— Riving knife or splitter/riving knife position can be changed by adjusting set screws at splitter/riving knife mounting block. Refer to **Riving Knife Mounting Block** on **Page 78** for more details.

— Scoring blade alignment can be changed by adjusting bolt accessible through table top (see **Figure 37**). See **Aligning to Scoring Blade** on **Page 48**.

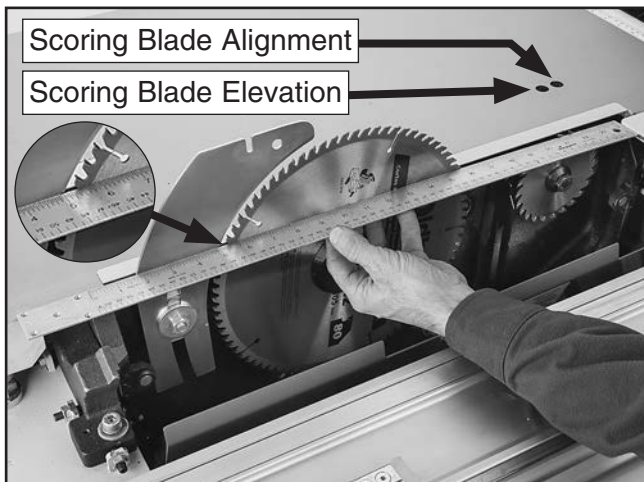


Figure 37. Access holes for scoring blade adjustment controls.

31. Close blade cover. Center sliding table over cabinet body and lock in place with sliding table lock lever (see **Figure 38**).

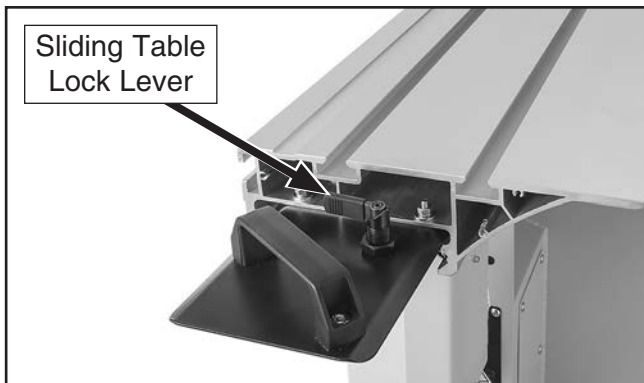


Figure 38. Location of sliding table lock lever.

32. Position rip fence $\frac{1}{8}$ " away from main blade.

33. Slide rip fence stop ring onto left end of rail and tighten pre-installed set screw to secure (see **Figure 39**). When installed correctly, stop ring will prevent rip fence from contacting blade.

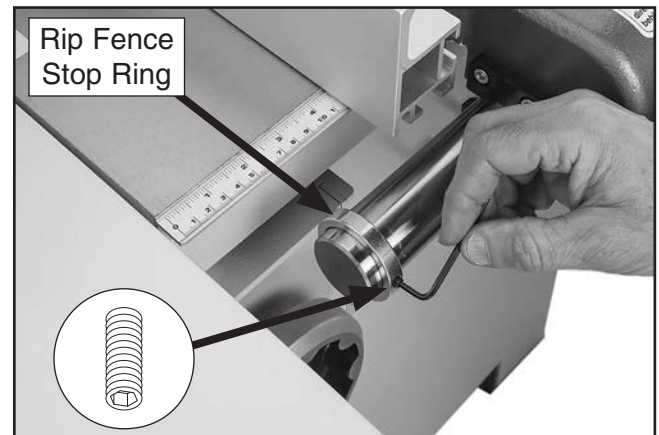


Figure 39. Rip fence stop ring attached to rail.

34. Attach rip fence end stop on opposite end of rip fence rail with (1) M8-1.25 x 15 cap screw and (1) 8mm lock washer (see **Figure 40**).

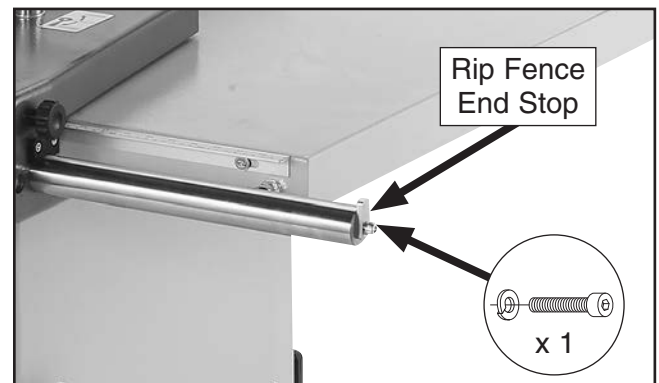


Figure 40. Rip fence end stop attached to rail.

35. Adjust rip fence to main blade and tables, as instructed in **Calibrating Rip Fence** on **Page 79**.



36. Thread M12-1.75 x 55 adjustable lock handle with (1) 12mm flat washer through hole in short side of crosscut table and into (1) M12-1.75 T-nut, as shown in **Figure 41**.

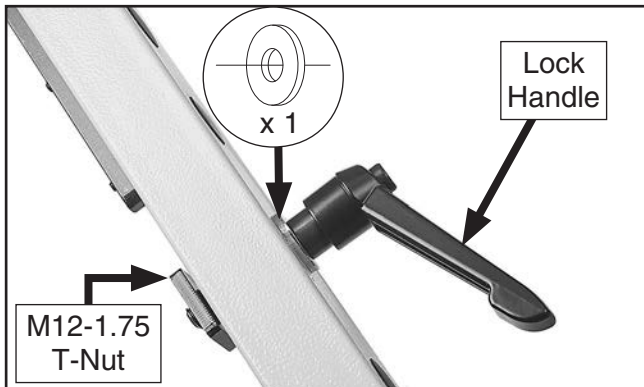


Figure 41. Crosscut lock handle installed on crosscut table.

37. With assistance from other people, place crosscut table on swing arm pivot pin and slide T-slot alignment plates and T-nut into sliding table T-slot (see **Figure 42**).

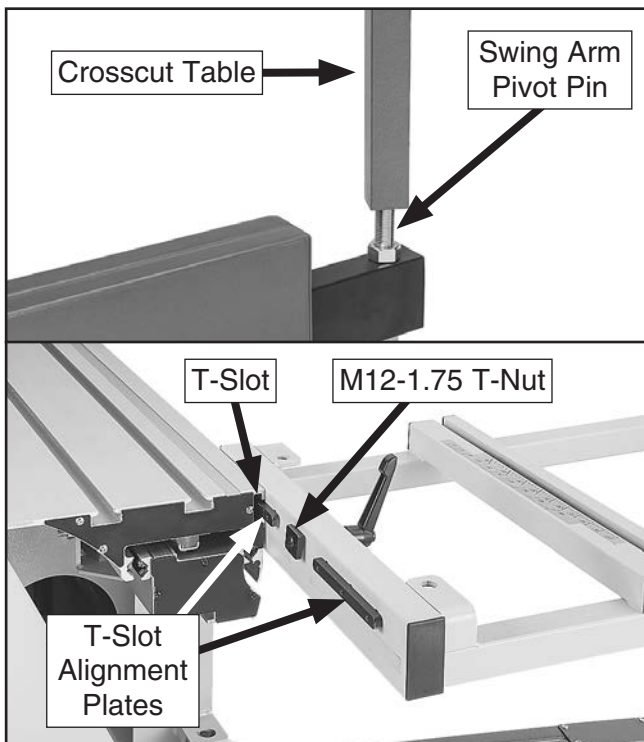


Figure 42. Attaching crosscut table to machine frame.

38. Remove tap screws and end cap from crosscut fence (see **Figure 43**).

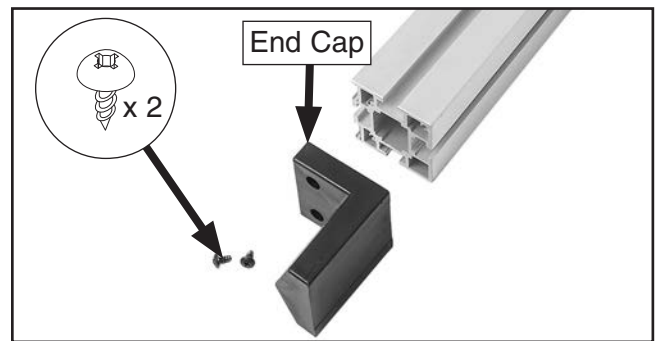


Figure 43. End cap removed from crosscut fence.

39. Slide (1) M8-1.25 T-nut into T-slot in bottom of crosscut fence (see **Figure 44**) and position in front of stop bolt.

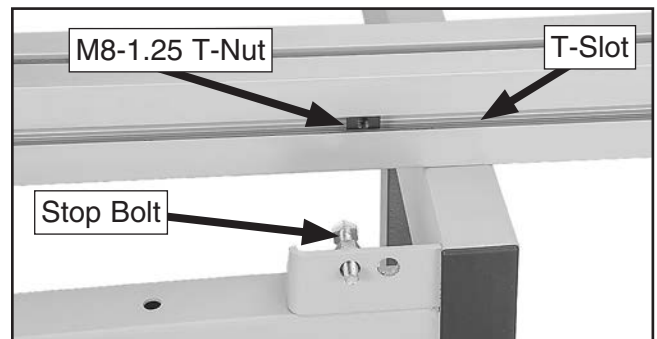


Figure 44. T-nut installed in bottom T-slot of crosscut fence for stop block.

40. Attach 0° stop block to T-nut with (1) M8-1.25 x 35 cap screw and (1) 8mm lock washer (see **Figure 45**).

Note: Make sure threaded hole in stop block is positioned right of cap screw and aligned with hole to right of stop bolt.

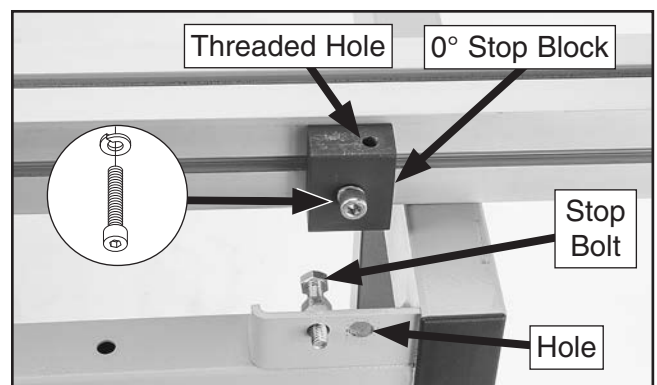


Figure 45. 90° stop block installed.



41. Slide M8-1.25 x 60 T-bolt into bottom T-slot of crosscut fence (see **Figure 46**).

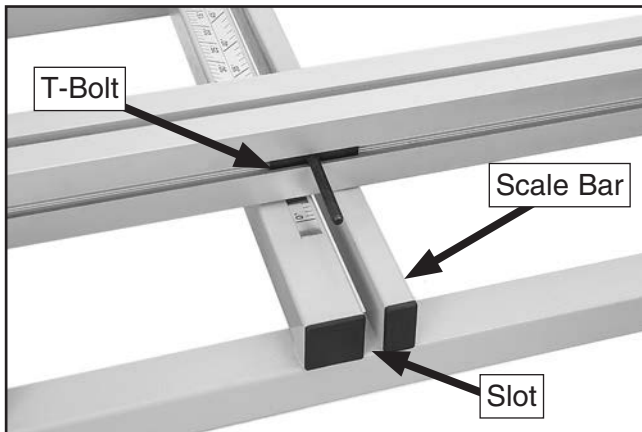


Figure 46. T-bolt installed in middle of crosscut table T-slot.

42. Slide (1) M8-1.25 T-nut into bottom T-slot of crosscut fence, then loosely thread M8-1.25 pivot bolt with (1) 8mm fiber flat washer into T-nut (see **Figure 47**).

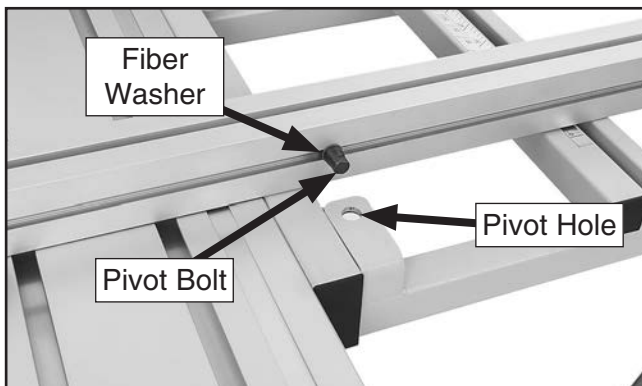


Figure 47. Pivot bolt installed in left end of crosscut table T-slot.

43. Slide (1) M8-1.25 T-nut into top T-slot of crosscut fence (see **Figure 48**). This will be used to attach flip stop in **Step 51**.



Figure 48. T-nut installed on right end of crosscut table T-slot.

44. Re-install end cap, then position crosscut fence so end cap is close to, but not touching main blade (see **Figure 49**).

45. Align pivot bolt with pivot hole (see **Figure 49**), then fully tighten pivot bolt.

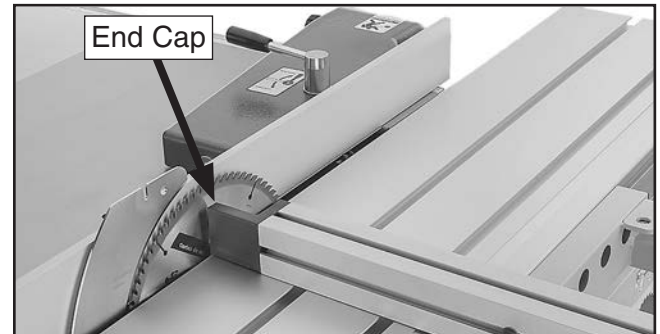


Figure 49. End cap positioned near blade.

46. Align T-slot bolt with slot in pre-installed scale bar (see **Figure 46**).

Note: Long knob and fender washer will help secure crosscut fence in later step.

47. Align 0° stop block with stop bolt, and align threaded hole in block with hole to right of stop bolt (see **Figure 45** on **Page 30**).

48. Without moving previously installed hardware, flip crosscut fence over and insert pivot bolt and T-slot bolt into appropriate hole/slot.

49. From underneath middle of crosscut fence, thread M8-1.25 long knob with (1) 8mm fender washer onto previously installed T-bolt (see **Figure 50**).

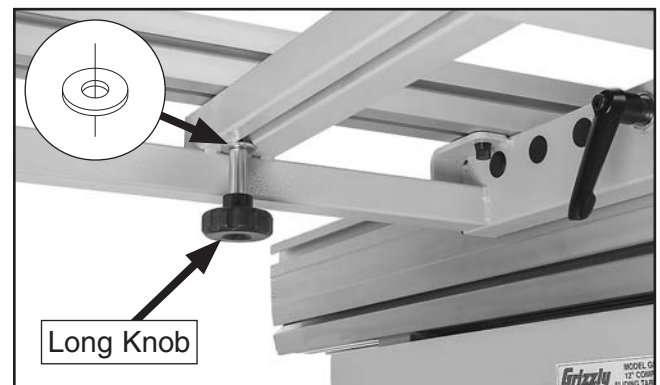


Figure 50. Long knob installed under middle of crosscut fence.



50. On right side of crosscut fence, make sure 0° stop block is against stop bolt, then secure fence by threading M8-1.25 x 50 knob bolt with (1) 8mm flat washer, and (2) M8-1.25 hex nuts into threaded hole on stop block, as shown in **Figure 51**.

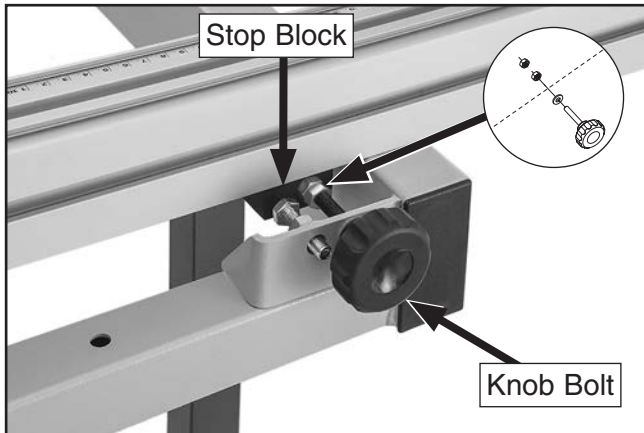


Figure 51. Knob bolt threaded into 90° stop block.

51. Attach flip stop (see **Figure 52**) by threading knob bolt into T-nut previously installed in top T-slot of fence.

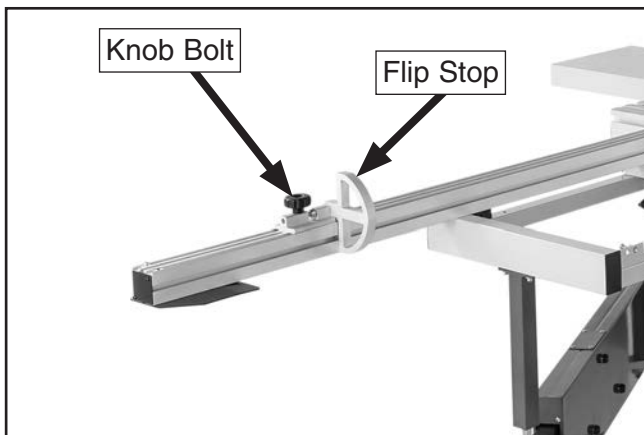


Figure 52. Flip stop installed onto crosscut fence.

52. If splitter/riving knife was installed earlier—instead of riving knife—raise main blade all the way up and attach blade guard with (1) M10-1.5 x 25 cap screw and (1) M10-1.5 lock nut, as shown in **Figure 53**.

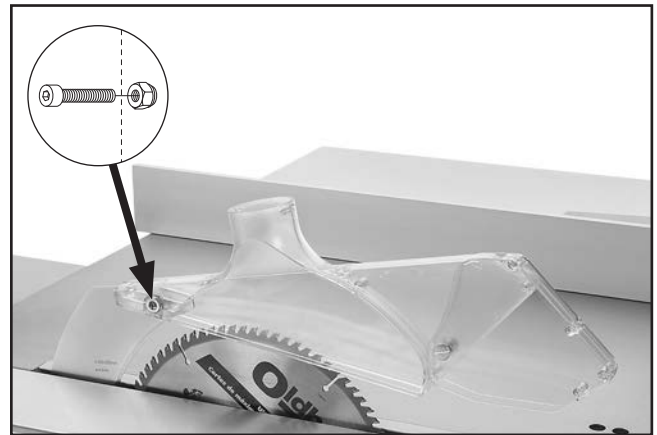


Figure 53. Blade guard installed onto splitter.

53. Attach dust hose support to large extension table with (1) M10-1.5 x 20 cap screw, (1) 10mm flat washer, and (1) M10-1.5 lock nut (see **Figure 54**).

Note: Support can be placed on either rear or side of extension table using two available mounting holes.

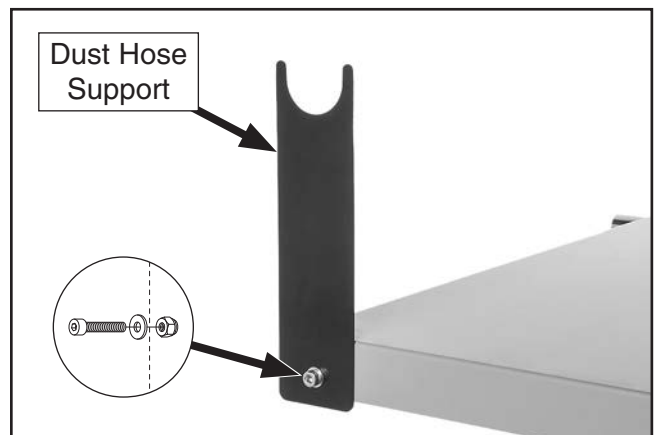


Figure 54. Dust hose support attached to rear of large extension table.



Dust Collection

⚠ CAUTION

This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

Required CFM for 5" Dust Port: 615 CFM
Required CFM for 2½" Dust Port: 150 CFM

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

To connect saw to dust collection system:

1. Secure 5" dust hose to port located under table with hose clamp, as shown in **Figure 55**.

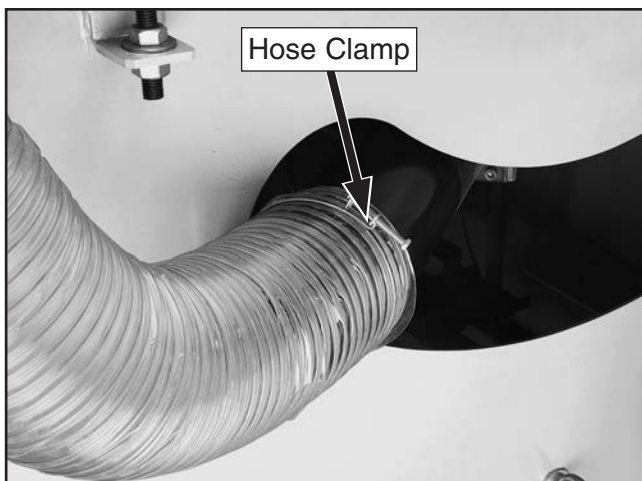


Figure 55. 5" Dust hose connected.

2. Connect 2½" dust hose to blade guard with hose clamp, as shown in **Figure 56**.

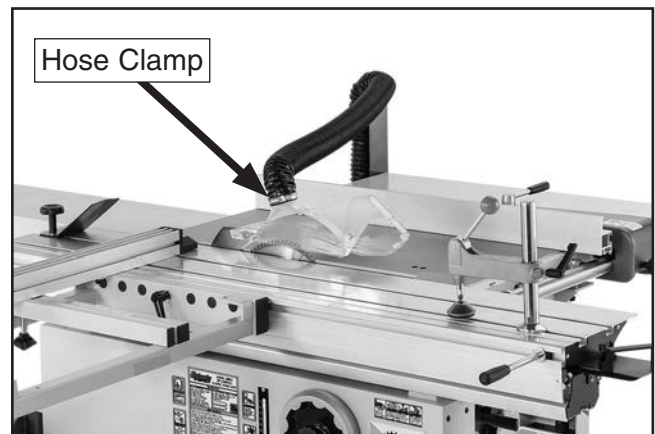


Figure 56. Blade guard and 2½" dust hose attached.

3. Run 2½" dust hose over dust hose support, as shown in **Figure 57**.

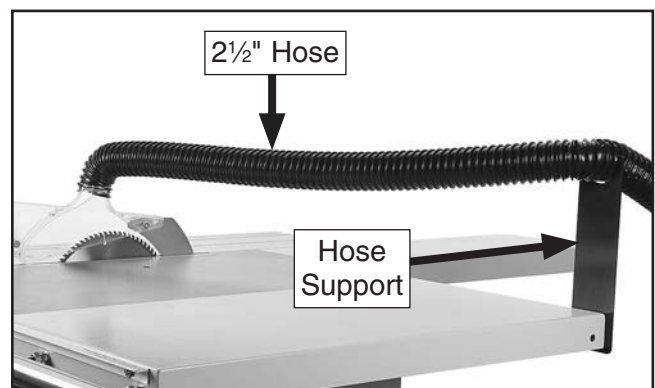


Figure 57. 2½" Dust hose held by hose support.

4. Connect 5" and 2½" dust hoses to Y-fitting, as shown in example in **Figure 58**, then attach it to single dust collection branch line.

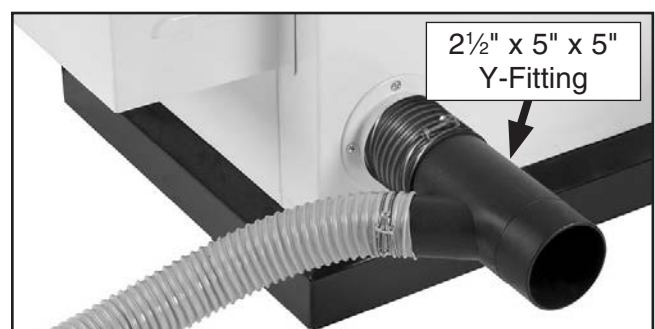


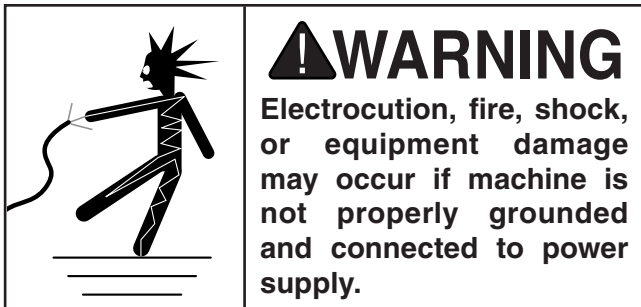
Figure 58. Example of dust hoses connected with Y-fitting.

5. Tug on all hose connections to make sure they are tight and secure.



Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **POWER SUPPLY** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.



Note About Phase Converters: Avoid using a static phase converter to supply 3-Phase power for this machine, as it could damage or decrease the life of sensitive electrical components. If you must use a phase converter, only use a rotary phase converter that is sized at least 50% larger than the largest HP rating of this machine. If using a phase converter to supply power, only connect the manufactured leg or "wild wire" to the "S" terminal (see location **on this page**). The S terminal can handle power fluctuations because it is wired directly to the motor.

NOTICE

The Model G0820 is prewired for 220V. If you plan to operate the machine at 440V, refer to *440V Conversion* on Page 16 for detailed instructions).

To connect incoming power wires:

1. Remove power junction box cover shown in **Figure 59**.
2. Insert incoming power cord through strain relief at bottom of junction box (see **Figure 59**).

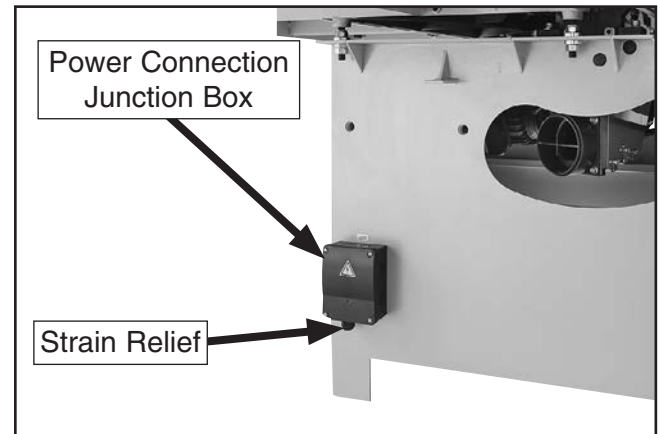


Figure 59. Power connection junction box location.

3. Connect ground wire to ground wire terminal, then connect incoming power wires to terminals shown in **Figure 60**. Refer to **Pages 82–83** for detailed wiring diagrams.

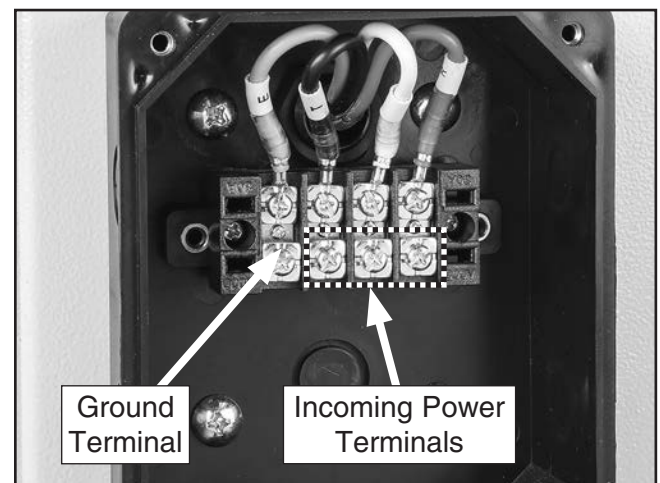


Figure 60. Terminal locations to connect incoming power wires and ground wire.

4. Make sure wires have enough slack so they are not pulled tight or stretched.
5. Re-install junction box cover, and perform **Test Run** in following section to verify correct phase polarity.



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.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, 2) the main blade turns forward (clockwise when viewed from front of saw) and the scoring blade turns opposite the main blade, and 3) the safety features of the Emergency Stop button, blade cover switch, and cabinet door work correctly.

!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 machine:

1. Clear all setup tools away from machine.
2. Make sure saw blades are installed tightly and blade guard cover is closed.
3. Connect machine to power supply.
4. Twist Emergency Stop button clockwise until it pops out (see **Figure 61**). This resets switch so machine can start.
5. Press ON button (see **Figure 61**) to turn machine **ON**. Verify motor starts up and runs smoothly without any unusual problems or noises.

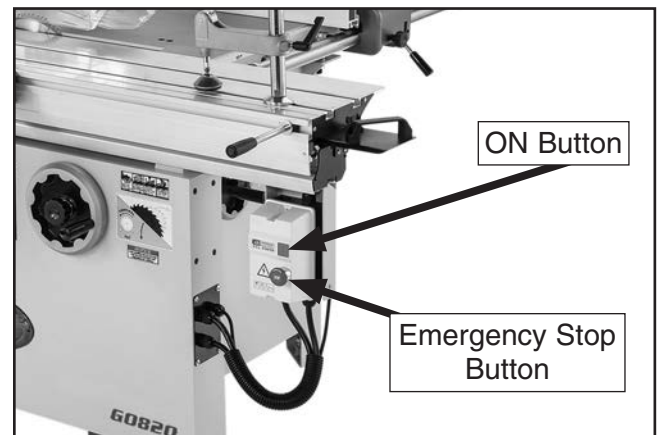


Figure 61. Emergency Stop switch button.

6. Verify main blade is rotating clockwise (when standing in front of machine) and scoring blade is rotating counterclockwise (opposite direction of main blade).

Note: *You may need to stop blade rotation and watch blades come to a stop to determine which direction they are rotating.*

— If blades are rotating in wrong direction, stop machine and **DISCONNECT FROM POWER!** Phase of incoming power supply is reversed. Remove power connection junction box cover and swap wires at "R" and "T" terminals (see **Figure 62**), then re-install junction box cover and re-connect machine to power.



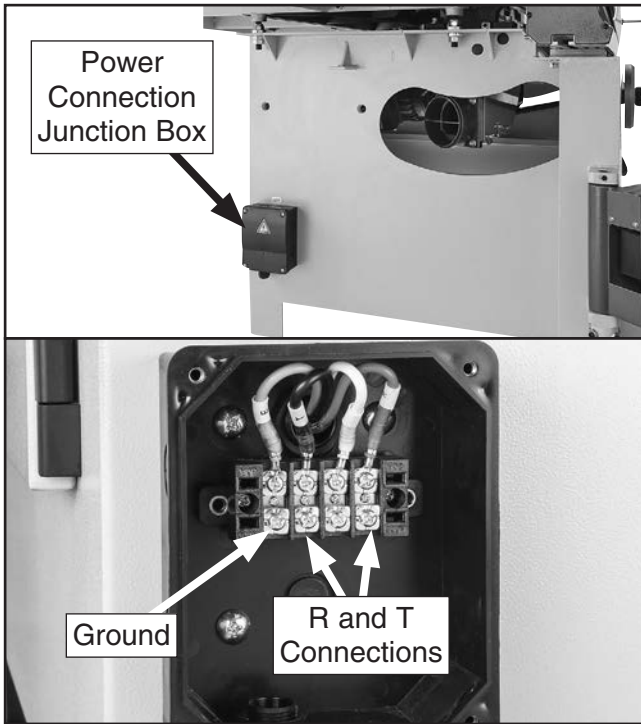


Figure 62. Up-close view of power supply terminal inside junction box.

!WARNING

Do not swap "R" or "T" wires with ground wire inside power connection junction box. Doing so will electrify machine frame, which could cause electrocution. Make sure incoming ground wire is only connected to left-most terminal post in the power connection junction box so machine is properly grounded.

7. Press Emergency Stop button on front of machine to turn machine **OFF**.
8. WITHOUT resetting Emergency Stop button, press ON button. Machine should *not* start.
 - If machine *does* start (with Emergency Stop button pushed in), immediately disconnect power to machine. Emergency Stop button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.
9. Reset Emergency Stop button on front of machine.

10. Repeat **Steps 7–9** with Emergency Stop button on rear of cabinet (see **Figure 63**).

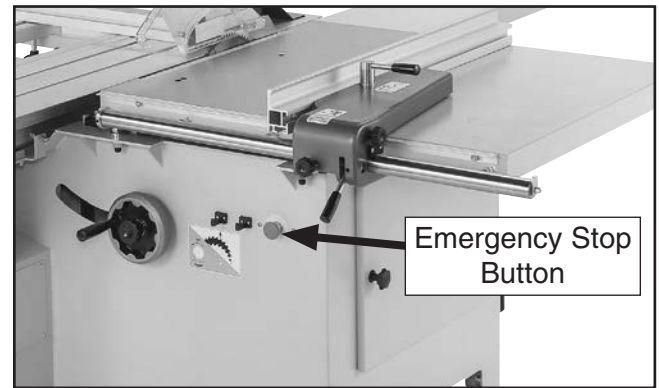


Figure 63. Emergency Stop on cabinet.

11. Move sliding table all the way right, then open blade cover, as shown in **Figure 64**. This activates blade cover safety switch to prevent saw from starting while cover is open.

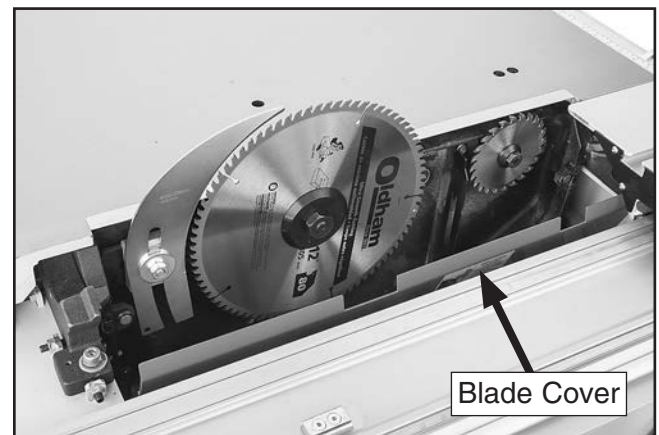


Figure 64. Blade cover open.

12. While staying safely away from blade, reset Emergency Stop button, then try to start main blade and scoring blade.
 - If blades *do not* start, blade cover safety switch safety feature is working correctly.
 - If blades *do* start (with blade cover open), immediately turn machine **OFF** and disconnect power. The blade cover safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.
13. Carefully close blade cover, then move sliding table back to center of machine.



14. Open cabinet door shown in **Figure 65**. This activates cabinet door safety switch to prevent saw from starting while door is open.

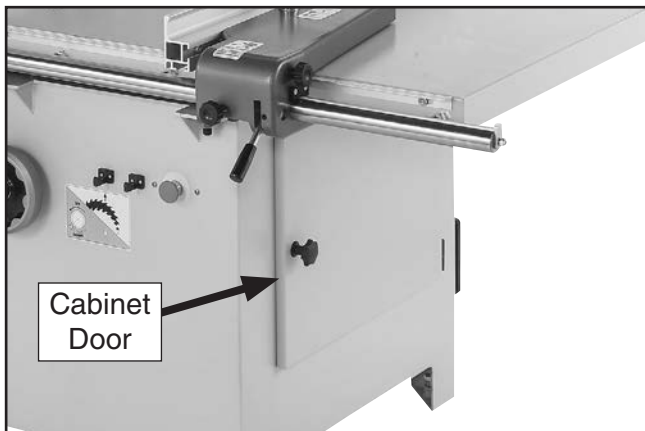


Figure 65. Cabinet door location.

15. While staying safely away from blade, try to start main blade and scoring blade.
- If blades *do not* start, cabinet door safety switch safety feature is working correctly.
 - If blades *do* start (with cabinet door open), immediately turn machine **OFF** and disconnect power. The cabinet door safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.
16. Close cabinet door, then push Emergency Stop button.

Congratulations, **Test Run** is complete!

Recommended Adjustments

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

- Riving Knife Alignment **Page 43**
- Aligning Scoring Blade **Page 48**
- Blade Tilt Calibration **Page 75**
- Sliding Table Parallel Adjustment.... **Page 76**
- Squaring Crosscut Fence to Blade **Page 77**
- Calibrating Rip Fence..... **Page 79**

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

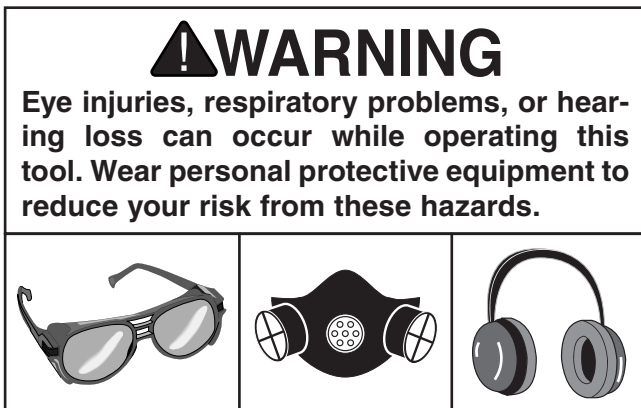


SECTION 4: OPERATIONS

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.



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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts blade tilt, if necessary, to correct angle of desired cut.
3. Adjusts blade height approximately $\frac{1}{4}$ " higher than thickness of workpiece.
4. Adjusts fence to desired width of cut, then locks it in place.
5. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through the blade without interference.
6. Puts on safety glasses, respirator, and hearing protection. Locates push sticks, if needed.
7. Turns on dust collection system.
8. Feeds workpiece all the way through blade while maintaining firm pressure on workpiece against table and fence.
9. Turns machine **OFF** immediately after cut is complete and waits for blades to completely stop before removing workpiece.

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.



Workpiece Inspection

Some workpieces are not safe to cut on this machine or may need to be modified before they can be safely cut. **Before cutting, inspect all workpieces for the following:**

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

Through & Non-Through Cuts

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through, as shown in the **Figure** below. Examples of through cuts are rip cuts, cross cuts, miter cuts, and beveled cuts. The blade guard assembly **MUST** be used when performing through cuts.

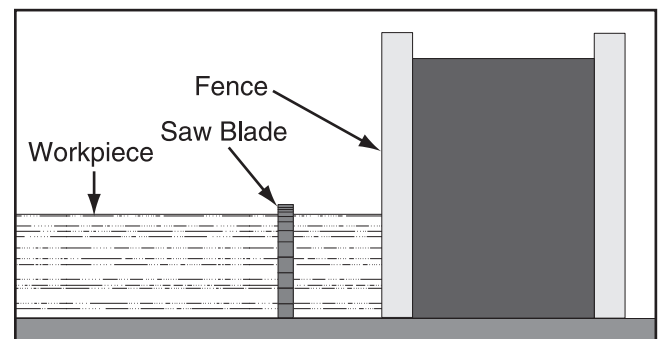


Figure 66. Example of a through cut (blade guard not shown for illustrative clarity).

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in the **Figure** below. The blade guard assembly **MUST** be used when performing all non-through cuts, except when the guard will not safely accommodate the workpiece.

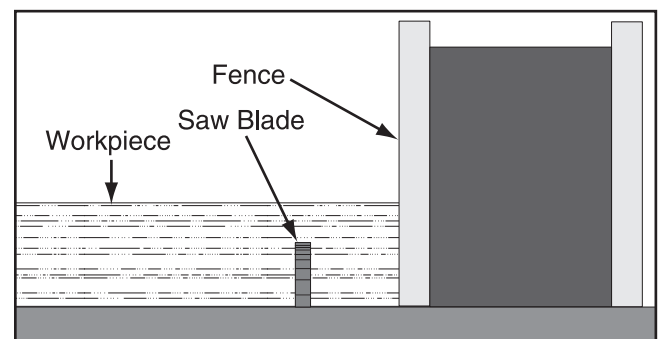


Figure 67. Example of a non-through cut.



Blade Guard & Splitter/Riving Knife

The term "blade guard" refers to the assembly that consists of the guard and splitter/riving knife assembly (see **Figure 68**). Each of these components have important safety functions.

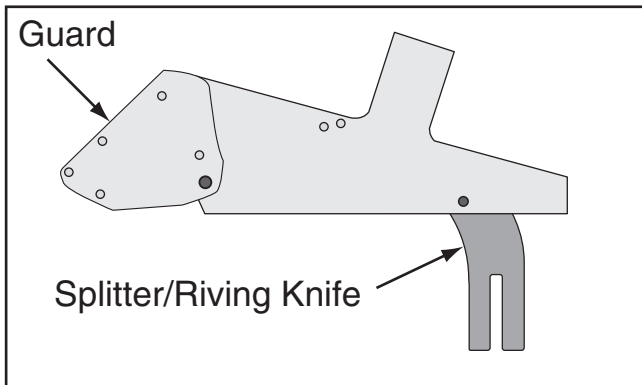


Figure 68. Blade guard assembly components.

Understanding Blade Guard

The guard encloses the top of the blade to reduce the risk of accidental blade contact and contain flying chips or dust.

The guard is designed to lift as the workpiece is pushed into the blade, remain in contact with the workpiece during the cut, then return to a resting position against the table when the cut is complete. When installed and properly maintained, the guard is an excellent tool for reducing the risk of injury when operating the table saw.

To ensure that the guard does its job effectively, it **MUST** be installed and adjusted so that it moves up and down properly to accommodate workpieces and maintain coverage over the blade.

Understanding Splitter/Riving Knife

The splitter/riving knife is a metal plate that prevents the freshly cut pieces of the workpiece from pinching the backside of the blade and causing a kickback. It also acts as a barrier behind the blade to shield hands from being pulled into the blade if a kickback occurs and the operator is reaching behind the blade. (Reaching behind the blade is a major safety risk and should not be done).

!WARNING

To ensure that the splitter/riving knife works safely, it **MUST** be aligned with and correctly adjusted to the blade.

When to Use Blade Guard

The blade guard assembly **MUST** always be installed on the saw for all normal through cuts (those where the blade cuts all the way through the thickness of the workpiece). Operating the saw without the guard increases the risk of kickback or blade contact. If the blade guard is removed for specific operations, immediately replace it after those operations are complete.

When Not to Use Blade Guard

The blade guard cannot be used for any non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

IMPORTANT: *Whenever the blade guard cannot be used, the riving knife **MUST** be installed.*

Sometimes the blade guard or its components can get in the way when cutting very narrow workpieces or other specialized cuts. Because the blade guard is provided to decrease your risk of injury, it should not be used if it gets in the way of making a safe cut. Use good judgment!

Blade Guard Installation & Removal

The blade guard fits over the splitter/riving knife and is secured in place with an M10-1.5 x 25 cap screw and an M10-1.5 lock nut (see "Mounting Screw" in **Figure 69**). These are the only fasteners that need to be installed/removed when installing or removing the blade guard.



Figure 69. Blade guard mounted to splitter/riving knife.



When installing the blade guard, the mounting screw and lock nut must be left loose enough that the guard can freely pivot up and down, but not so loose that there is side-to-side play when pivoting.

Testing Guard for Correct Operation

After installing the blade guard, you must verify that it functions correctly before making a cut. To test the blade guard operation, lift up the front end about 4" then release it.

- If the blade guard freely drops down against the table surface, then it is functioning correctly and is ready for operation.
- If the blade guard remains in the position where you released it, or it does not drop down against the surface of the table, then the mounting screw and lock nut are too tight. Loosen it slightly and repeat this test until the guard functions correctly.
- If the blade guard feels loose and easily moves back and forth as you raise it, then the mounting screw and lock nut are too loose. Tighten it slightly and repeat this test until the guard functions correctly.

Splitter/Riving Knife Installation & Removal

The splitter/riving knife must be correctly installed, adjusted, and aligned in order to provide the maximum safety benefit.

The splitter/riving knife attaches to the mounting block, as shown in **Figure 70**. Always firmly tighten the hex nut when securing the splitter/riving knife in place.

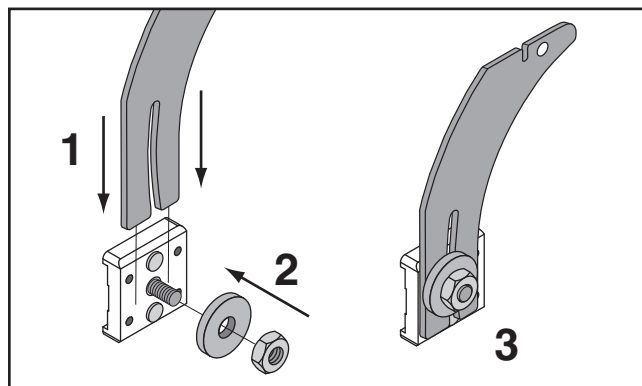


Figure 70. Installing splitter/riving knife on mounting block.

The splitter/riving knife also prevents the freshly cut sides of the workpiece from pinching the blade and causing kickback. For maximum effectiveness of this safety design, the splitter/riving knife must be positioned 3–8mm from the blade, as shown in **Figure 71**.

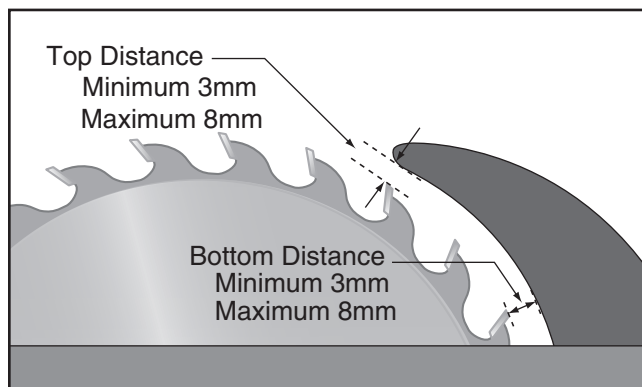


Figure 71. Allowable top and bottom distances between splitter/riving knife and blade.



Once the splitter/riving knife is properly positioned at the correct distance from the blade, verify that it is aligned with the blade by checking the alignment with a straightedge in the top and bottom locations shown in **Figure 72**.

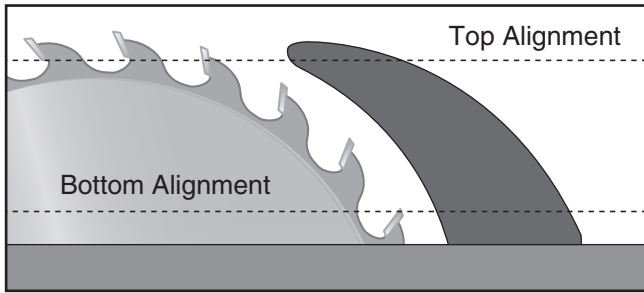


Figure 72. Checking top and bottom splitter/riving knife alignment with blade.

The splitter/riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in **Figure 73**.

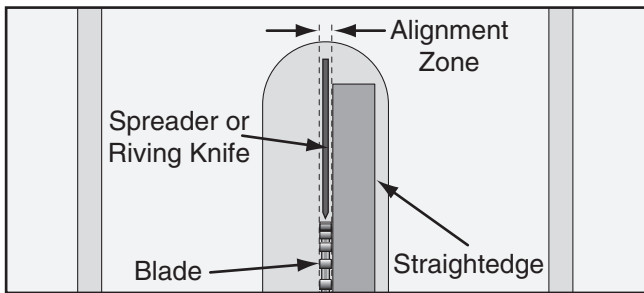


Figure 73. Verifying that splitter/riving knife is in the alignment zone behind the blade.

If the splitter/riving knife is not aligned or parallel with the blade, refer to **Riving Knife Mounting Block** on **Page 78**.

Riving Knife

The riving knife works in the same manner as the splitter/riving knife on the blade guard assembly. It is a metal plate that prevents the newly cut workpiece from pinching the backside of the blade and causing kickback.

The key difference between the splitter/riving knife and the riving knife is that the riving knife mounts below the blade's highest point of rotation, as shown in **Figure 74**, so that it can remain installed for non-through cuts.

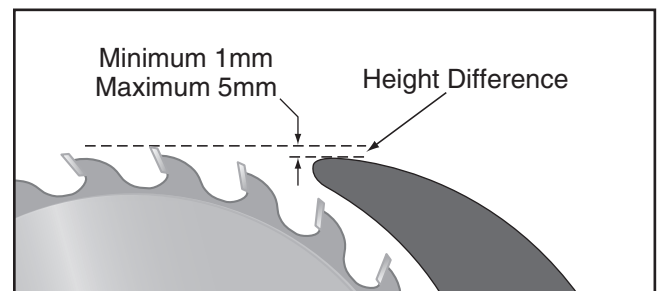


Figure 74. Height difference between riving knife and blade.

Similar to the splitter/riving knife, the riving knife acts as a barrier behind the blade to reduce the risk of hands being pulled into the blade if kickback occurs.

The riving knife must be kept within the range shown in **Figure 75**. For that reason, a 12" blade is required for operations that use a riving knife.

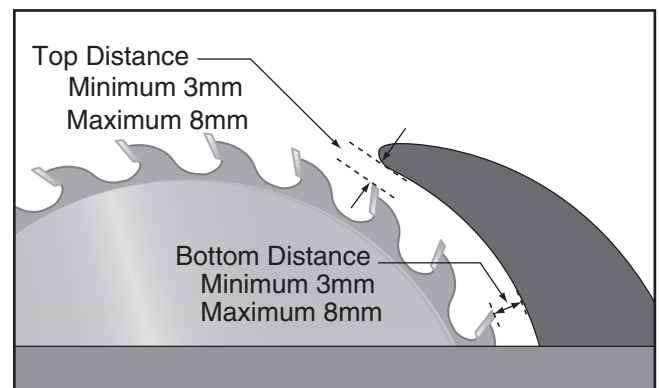


Figure 75. Allowable top and bottom distances between riving knife and blade.



Once the riving knife is properly positioned at the correct distance from the blade, verify that it is aligned with the blade by checking the alignment with a straightedge in the top and bottom locations shown in **Figure 76**.

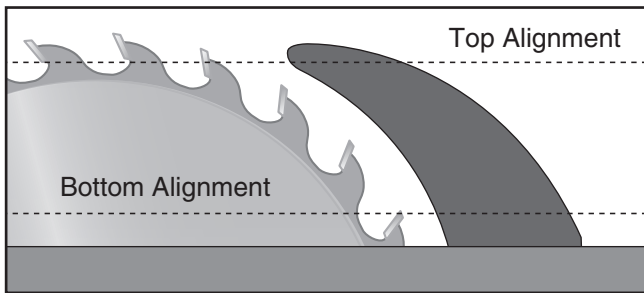


Figure 76. Checking top and bottom riving knife alignment with blade.

The riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in **Figure 77**.

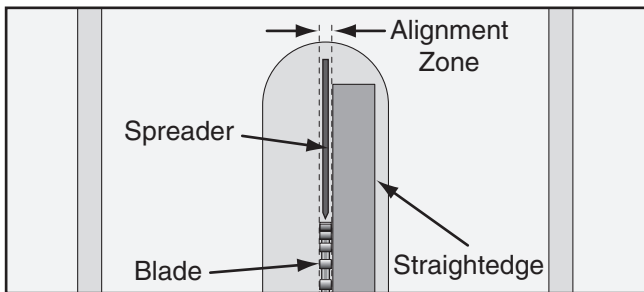


Figure 77. Verifying that riving knife is in the alignment zone behind the blade.

If the riving knife is not aligned or parallel with the blade, refer to **Riving Knife Mounting Block** on **Page 78**.

Riving Knife Installation & Removal

The riving knife must be correctly installed and adjusted in order to provide the maximum safety benefit.

The riving knife attaches to the mounting block as shown in **Figure 78**. Always firmly tighten the hex bolt when securing the riving knife in place.

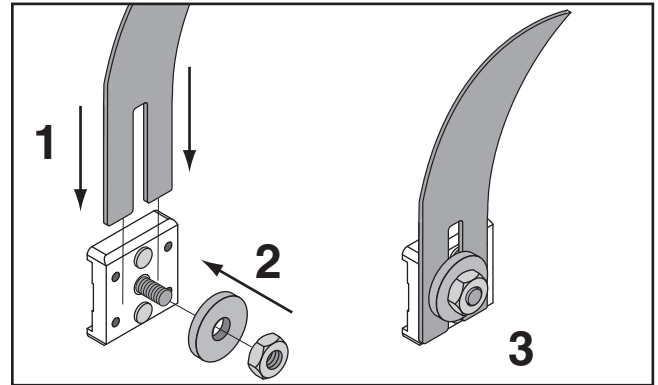


Figure 78. Installing riving knife on mounting block.

When to Use Riving Knife

Use the riving knife for all non-through cuts (see **Glossary of Terms** on **Page 6**) or for those special operations where the blade guard or its components get in the way of safe operation, such as with very narrow cuts.

When Not to Use Riving Knife

Although it is possible to use the riving knife for through-cutting operations, the blade guard assembly offers far more injury protection and risk reduction than the riving knife. Therefore, **we strongly recommend** that you use the blade guard assembly and splitter/riving knife instead of the riving knife for through-cuts.



Blade Requirements

The riving knife included with this machine is 0.098" (2.5mm) thick and is only designed for 12" blades.

When choosing a main blade, make sure the blade size meets the requirements listed below. The thickness of the blade body and teeth can be measured with calipers or any precision measuring device.

Blade Size Requirements:

- Body Thickness: 0.087" (2.2mm)
- Kerf (Tooth) Thickness: 0.118" (2.99mm)

Blade Selection

This section on blade selection is by no means comprehensive. Always follow the saw blade manufacturer's recommendations to ensure safe and efficient operation of your table saw.

Ripping Blade Features:

- Best for cutting with the grain
- 30-40 teeth
- Flat-top ground tooth profile
- Large gullets for large chip removal

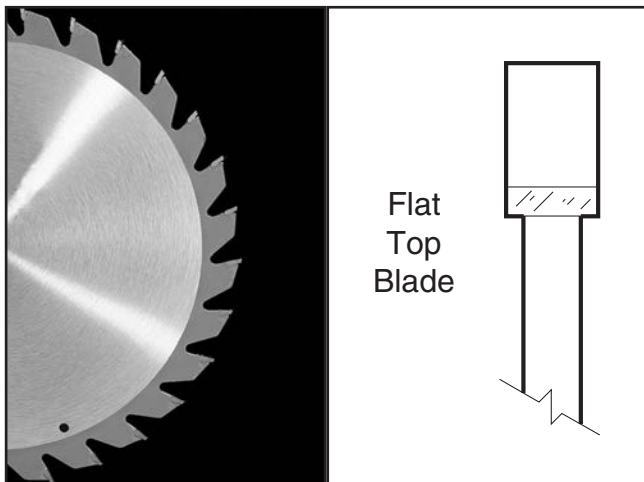


Figure 79. Ripping blade.

Crosscut Blade Features:

- Best for cutting across the grain
- 80–100 teeth
- Alternate top bevel tooth profile
- Small hook angle and a shallow gullet

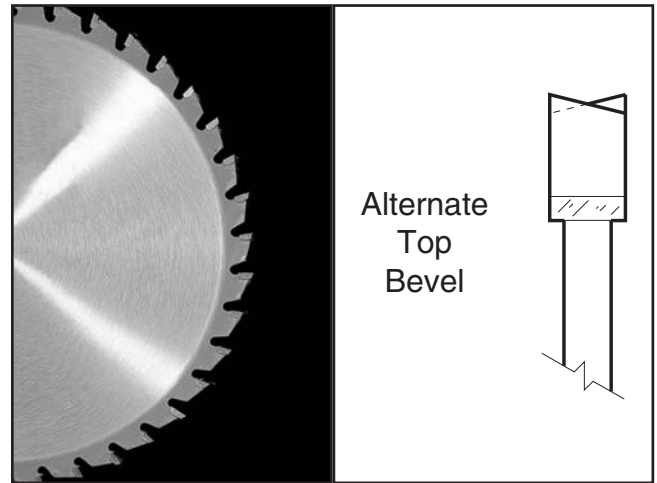


Figure 80. Crosscutting blade.

Combination Blade Features:

- Designed to cut both with and across grain
- 50–80 teeth
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile
- Teeth are arranged in groups
- Gullets are small and shallow (similar to a cross-cut blade), then large and deep (similar to a ripping blade)

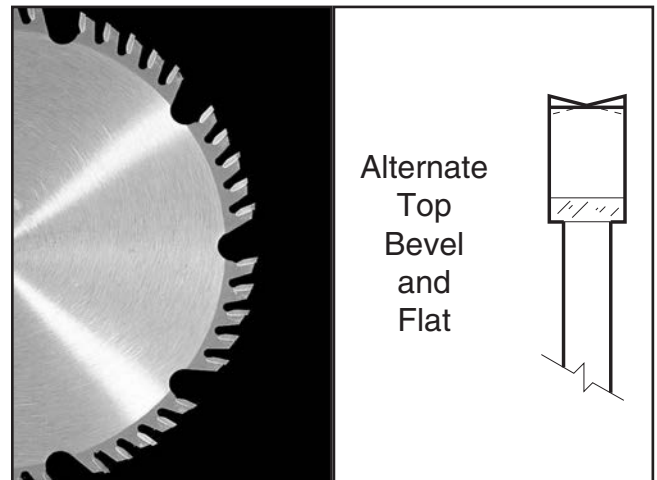


Figure 81. Combination blade.



Laminate Blade Features:

- Best for cutting plywood or veneer
- 100–120 teeth
- Triple chip tooth profile
- Very shallow gullet

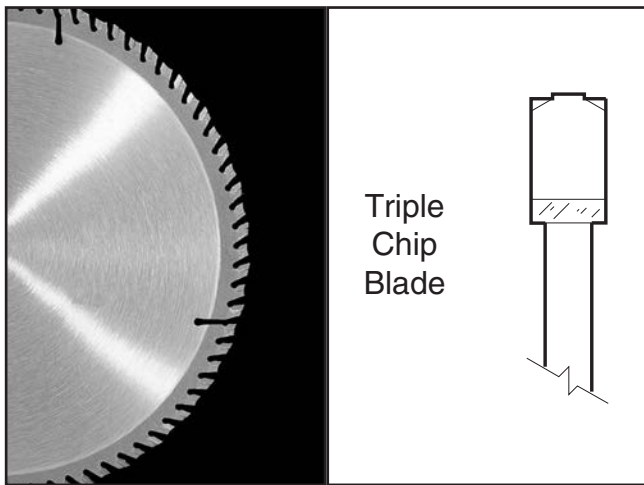


Figure 82. Laminate blade.

Thin Kerf Blade: A blade with thinner kerf than a standard blade.

IMPORTANT: The splitter/riving knife included with this table saw is sized for standard blades, thin kerf blades *cannot* be used on this saw.

Changing Main Blade

The Model G0820 performs best when using sharp, high-quality blades. Whenever the main blade starts to get dull, sharpen or replace it with a new blade.

NOTICE

The Model G0820 does not ship with a 12" main blade. Refer to *Blade Requirements* and *Blade Selection* beginning on Page 44 when purchasing the main blade.

| Tools Needed | Qty |
|----------------------------|--------|
| Heavy Leather Gloves | 1 Pair |
| Hex Wrench 8mm | 1 |
| Wrench 30mm | 1 |
| T-Handle Wrench 8mm | 1 |

To change main blade:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust blade tilt to 0° and raise blade all the way up.
3. Remove blade guard from splitter/riving knife.
4. Move sliding table all the way right to expose blade cover, then open blade cover.
5. Insert T-handle wrench through table top hole (see **Figure 83**) and into one of the holes in main blade pulley under table. This will keep blade arbor from rotating during next step.

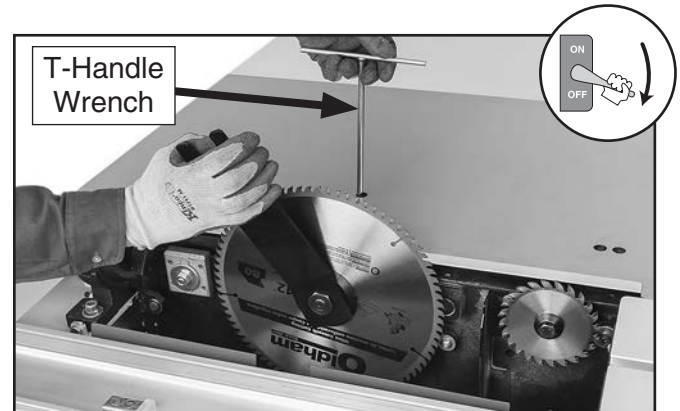


Figure 83. Loosening main blade arbor nut.



⚠ CAUTION

Before proceeding with the next steps, wear gloves to protect your hands when handling and installing blade.

- While holding T-handle wrench with one hand, rotate arbor nut clockwise and remove nut, flange, and blade (see **Figure 84**).

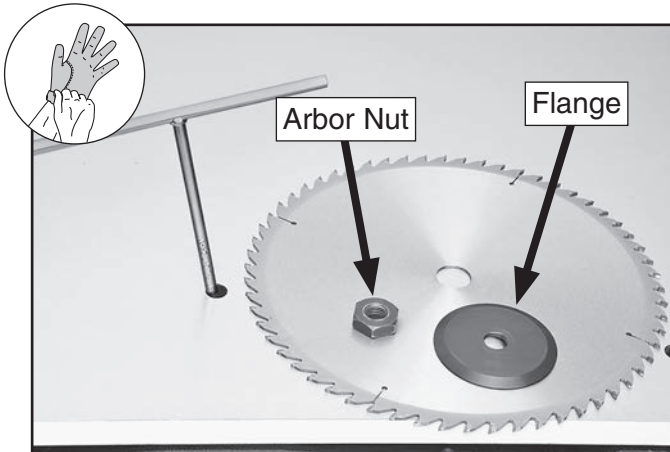


Figure 84. Main blade arbor nut and flange.

- Install new blade, flange, and arbor nut in reverse order from removal, making sure upper blade teeth face **RIGHT** (see **Figure 85**), then tighten arbor nut.

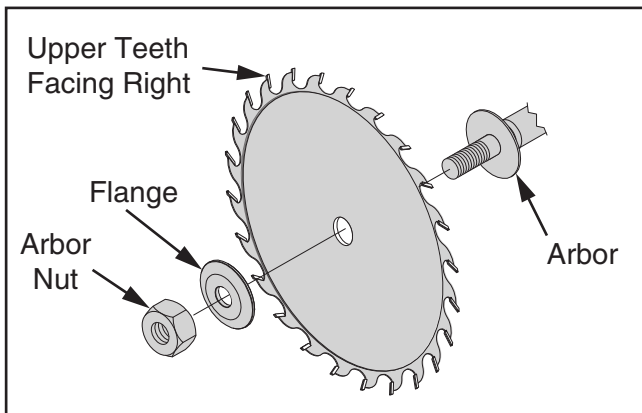


Figure 85. Order of assembly when installing main blade on arbor.

- Close blade cover, re-install blade guard onto splitter/riving knife, then move sliding table back to center of machine.
- Check scoring blade alignment with main blade, and adjust if necessary (see **Aligning Scoring Blade** on **Page 48**).

Replacing & Aligning Scoring Blade

The scoring blade rotates in the opposite direction from the main blade and makes a shallow cut into the workpiece surface. This prevents workpiece tearout.

The scoring blade included with the Model G0820 has wedge-shaped teeth that narrow at the top, as shown in **Figure 86**. With this style of scoring blade, the kerf thickness is adjusted by changing the height of the scoring blade. Raising the scoring blade higher increases the kerf thickness.

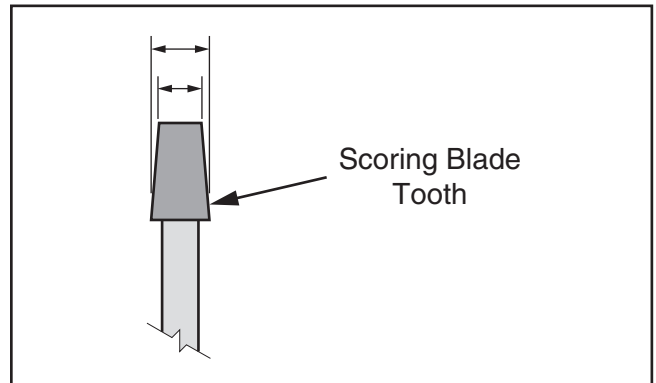


Figure 86. Scoring blade tooth that narrows at the top.

Replacing Scoring Blade

| Tools Needed | Qty |
|------------------------|-----|
| Combo Wrench 19mm..... | 1 |
| Arbor Wrench | 1 |

To replace scoring blade:

- DISCONNECT MACHINE FROM POWER!**
- Adjust blade tilt to 0° and raise blade all the way up.
- Remove splitter/riving knife if it is installed.
- Move sliding table all the way right to expose blade cover, then open blade cover.



- Slide arbor wrench behind scoring blade onto flats of arbor (see **Figure 87**) to prevent blade from spinning.

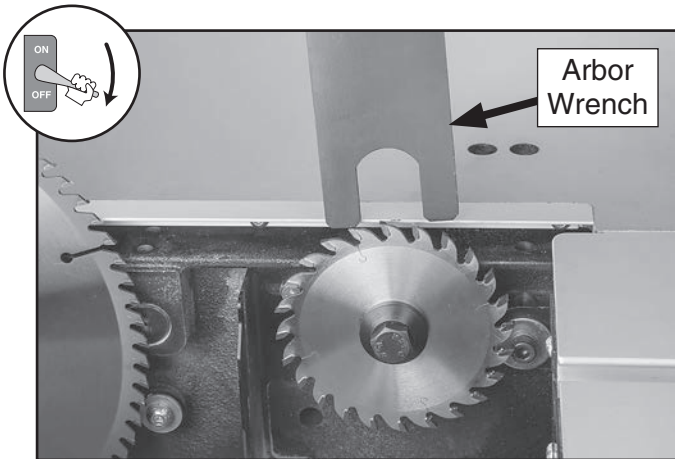


Figure 87. Inserting arbor wrench behind scoring blade to prevent blade from spinning.

- Loosen arbor hex bolt counterclockwise (left-handed threads), and remove arbor hex bolt, flange, and blade (see **Figure 88**).

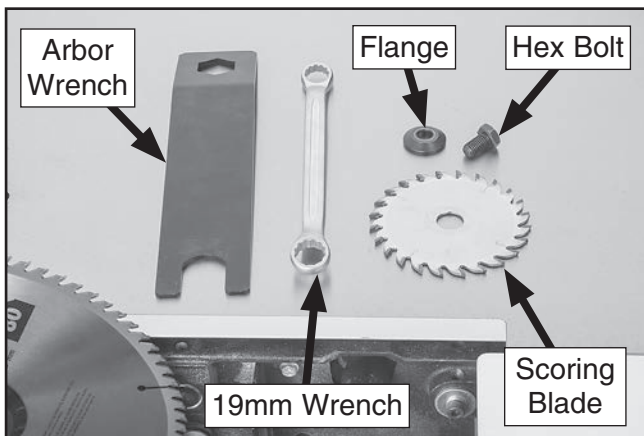


Figure 88. Scoring blade, flange, arbor hex bolt, 19mm wrench, and arbor wrench.

- Install scoring blade set, flange, and arbor hex bolt in reverse order from removal, making sure upper blade teeth face LEFT (see **Figure 89**), then tighten arbor hex bolt.

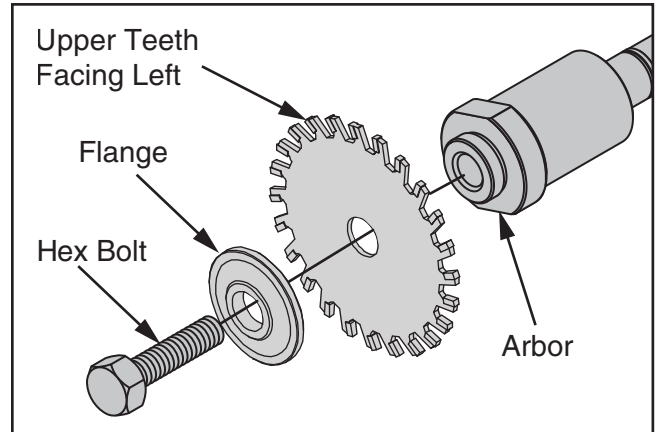


Figure 89. Scoring blade order of assembly.

- Align scoring blade with main blade, as instructed in **Aligning Scoring Blade** on **Page 48**.



Aligning Scoring Blade

This procedure aligns the scoring blade in the vertical and horizontal positions so that the scoring kerf is the same width as the main blade kerf. This requires placing the straightedge on both sides of the blades multiple times as you make adjustments.

| Tools Needed | Qty |
|---------------------------|-----|
| Hex Wrench 8mm..... | 1 |
| T-Handle Wrench 8mm | 1 |
| Straightedge 36"+..... | 1 |

To adjust scoring blade position:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust blade tilt to 0° and raise blade all the way up.
3. If splitter/riving knife is installed, remove blade guard.
4. Move sliding table all the way forward to expose blade cover, lock in place, then open blade cover.
5. Align scoring blade horizontally to main blade body:
 - Position straightedge against flat area of main blade body (not teeth), and extend over scoring blade body.
 - Insert T-handle wrench into right hole shown in **Figure 90**, engaging it with adjustment bolt under table, then rotate wrench to align bodies of blades.

Note: Rotating T-handle wrench clockwise moves scoring blade left, and counterclockwise moves it right.

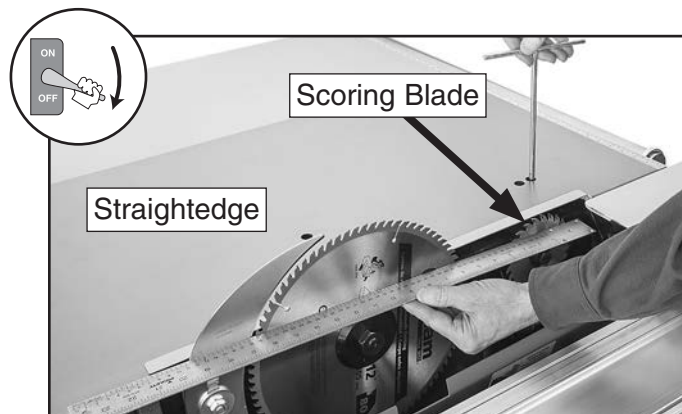


Figure 90. Adjusting horizontal position of scoring blade.

6. Align scoring blade kerf to main blade kerf:
 - Position straightedge flat on table on one side of main blade, and against main blade teeth and scoring blade teeth.
 - Insert T-handle wrench into left hole shown in **Figure 91**, engaging it with adjustment bolt under table, then rotate wrench to position scoring blade so edge of scoring blade teeth are aligned with main blade teeth.

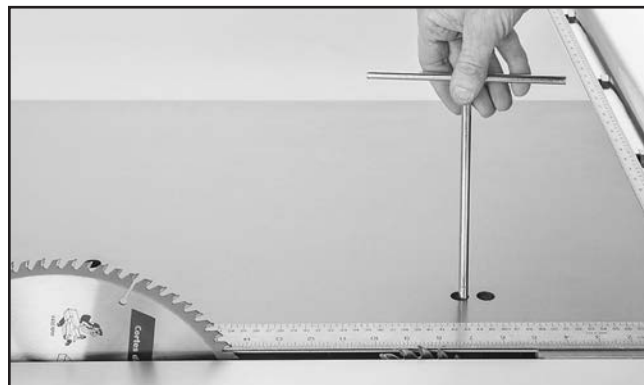


Figure 91. Adjusting vertical height of scoring blade.

7. Repeat **Step 6** for opposite side of blades to verify kerf thickness matches, and scoring blade is aligned with main blade.
8. Close blade cover, properly reposition blade guard, then slide table back to center of machine.
9. Perform a test cut and check for chip-out. If there is chip-out, repeat **Steps 4–9** until chip-out is corrected.



Setting Up Crosscut Fence

Before using the crosscut fence to perform cutting operations, it must be set up properly. This includes positioning the crosscut fence on the crosscut table, adjusting the crosscut fence distance from the blade, and positioning the crosscut table along the sliding table.

Positioning Crosscut Fence

The crosscut fence can be mounted in the front or rear position (see **Figure 92**) depending upon the size of the workpiece and which position will provide the safest operation.

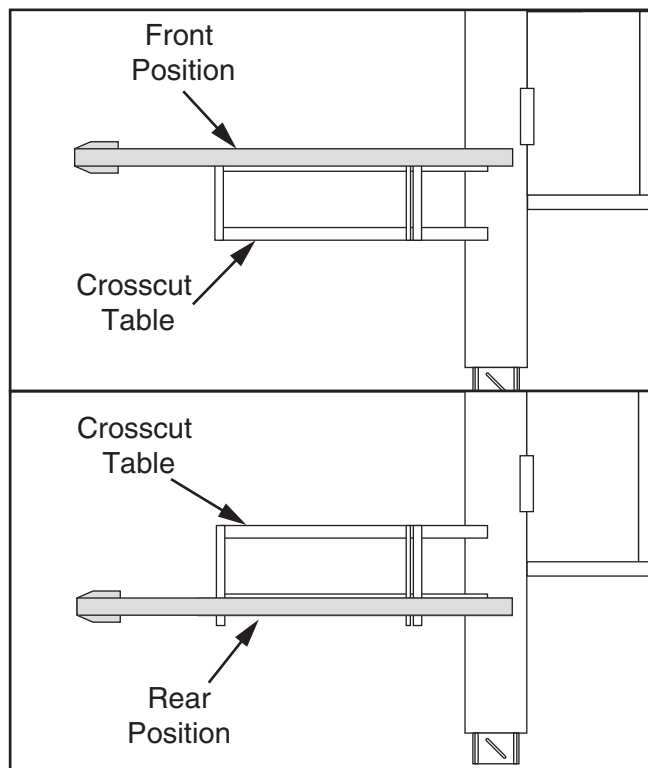


Figure 92. Crosscut fence front and rear table mounting positions.

Whenever the crosscut fence is moved between the front and rear positions, you must verify the fence is square to the blade, and the 0° stop bolts are properly adjusted before using the fence. Refer to **Squaring Crosscut Fence to Blade** on **Page 77** for further details.

To position crosscut fence:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen and remove knob bolts shown in **Figure 93**.

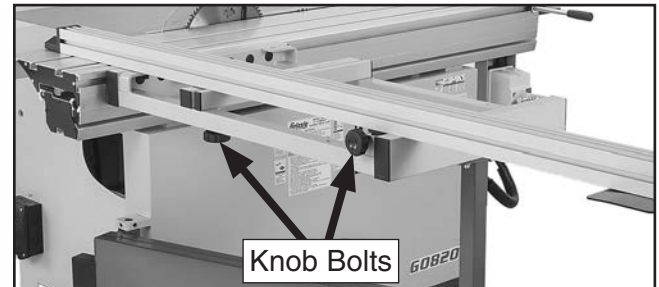


Figure 93. Locations of knob bolts securing crosscut fence.

3. Lift fence and loosen pivot bolt (see **Figure 94**).
4. Re-insert pivot bolt into front or rear hole, and re-insert angle scale T-bolt into angle scale slot (see **Figure 94**).

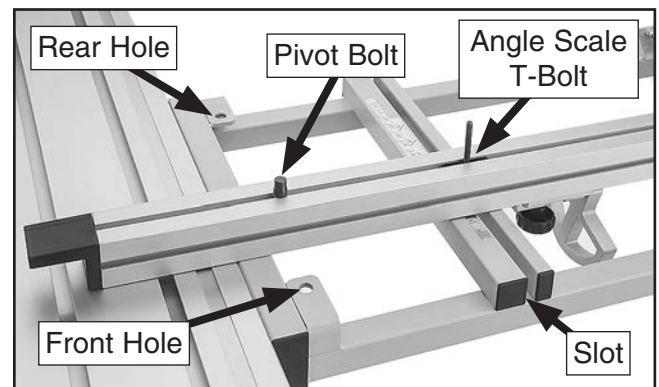


Figure 94. Crosscut fence pivot bolt.

5. Rotate fence so stop block is against 0° stop bolt (see **Figure 95**).

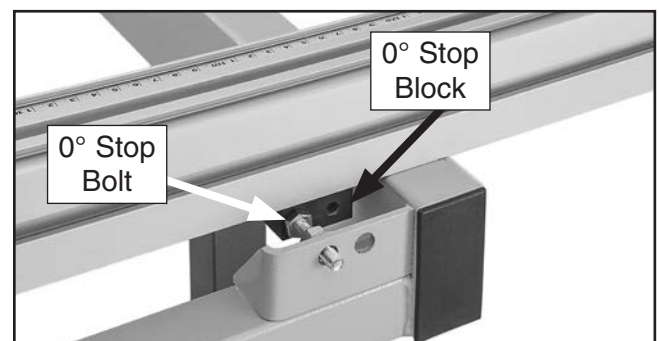


Figure 95. Stop block against 0° stop bolt.



Calibrating Crosscut Fence

To accurately use the crosscut fence scale and ensure the end cap does not contact the blade, the distance between the crosscut fence and the blade must be properly adjusted.

| Tool Needed | Qty |
|--------------------------|-----|
| Precision Ruler 6"+..... | 1 |

To adjust distance between crosscut fence and blade:

1. DISCONNECT MACHINE FROM POWER!
2. Perform **Positioning Crosscut Fence** on **Page 49**.
3. Move crosscut table (see **Positioning Crosscut Table Along Sliding Table** on this page) so fence end cap is aligned with center of blade body (see **Figure 96**).

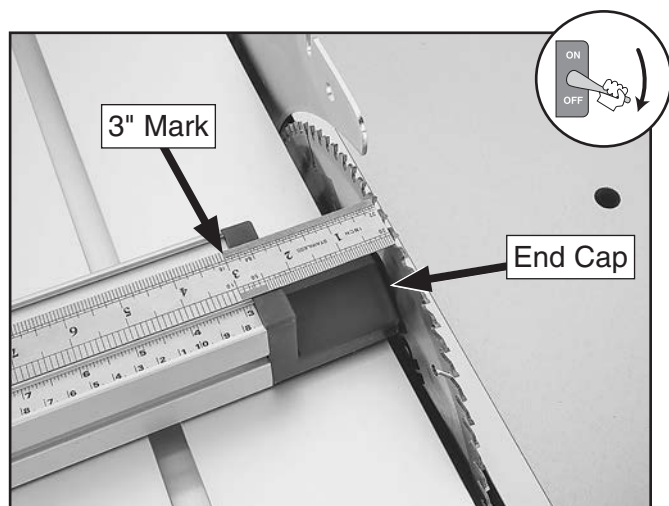


Figure 96. End cap aligned with blade.

4. Place precision ruler against a blade tooth, as shown in **Figure 96**, then adjust fence so that 3" mark on fence scale is exactly 3" from blade tooth.
5. Without disturbing pivot bolt position, lift fence up (see **Figure 94**), tighten pivot bolt, then re-insert pivot bolt into hole.
6. Repeat measurement in **Step 4**.
 - If measurement is not exactly 3", repeat **Step 4** until it is.
7. Re-install knob bolts removed earlier to secure setting.

Positioning Crosscut Table Along Sliding Table

The crosscut table can be positioned as necessary along the sliding table (see **Figure 97**).

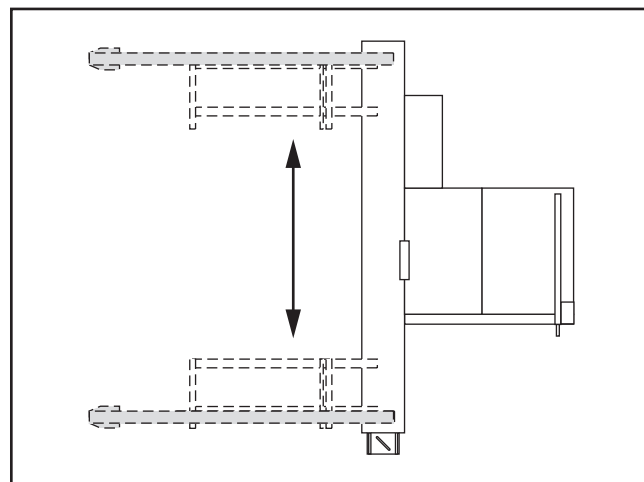


Figure 97. Crosscut table positions along sliding table.



To position crosscut table along sliding table:

1. DISCONNECT MACHINE FROM POWER!
2. Use sliding table lock lever (see **Figure 98**) to secure table in position.

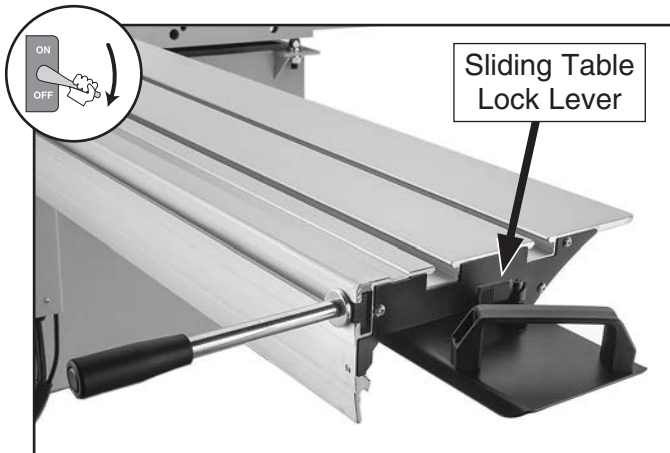


Figure 98. Location of sliding table lock lever.

3. Loosen crosscut table lock lever shown in **Figure 99**.

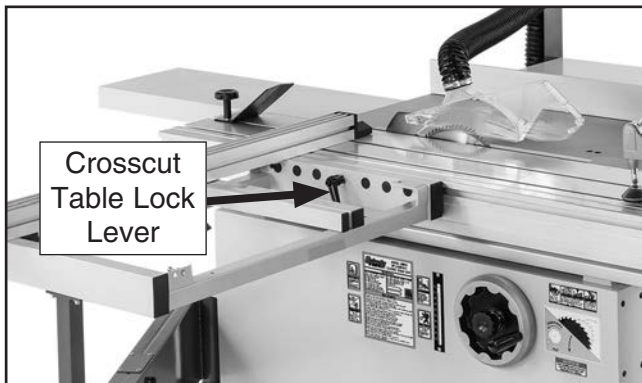


Figure 99. Location of crosscut table lock lever.

4. Position crosscut table along sliding table T-slot to desired position, then retighten lock lever to secure table.

Rip Cutting

The Model G0820 has the capability of rip cutting large panels (see **Figure 100**). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

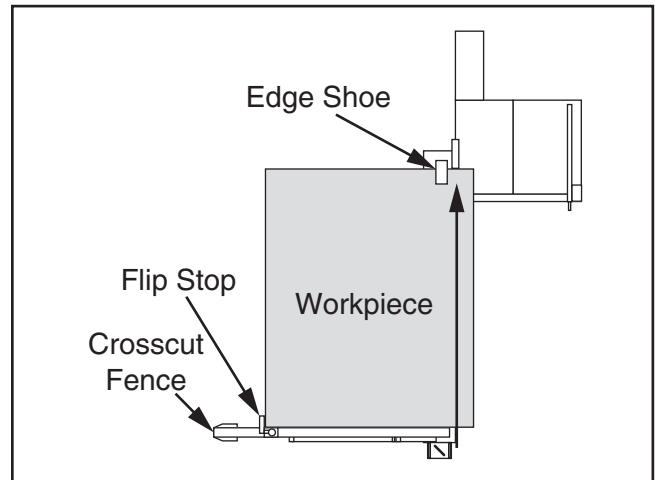


Figure 100. Rip cut with sliding table and crosscut fence.

The edge shoe (see **Figure 100**) is used to stabilize the front end of a workpiece when otherwise unsecured.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (see **Figure 101**). Smaller, lighter boards are easier to slide across the stationary cast-iron table surface to the right of the saw blade.

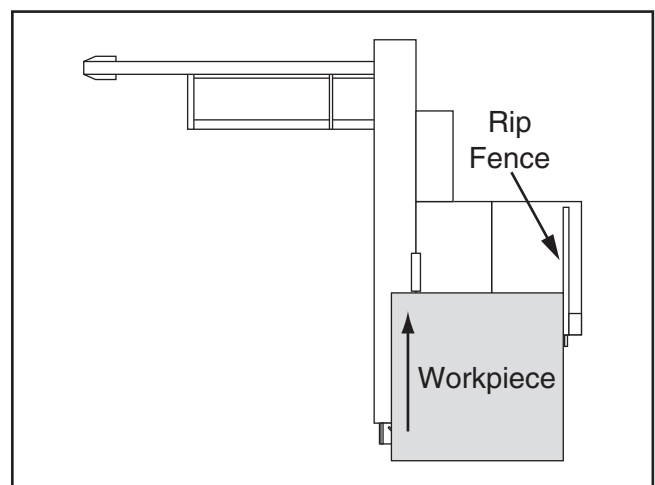


Figure 101. Traditional rip cut with rip fence.



Determine which cutting operation will be best suited for workpiece.

- To use sliding table, see **Rip Cutting with Sliding Table** on this page.
- To use machine as a traditional table saw, see **Rip Cutting with Rip Fence** on this page.

Rip Cutting with Sliding Table

1. Position crosscut fence on crosscut table according to cutting operation (see **Setting Up Crosscut Fence on Page 49**) and rotate crosscut fence until 0° stop block touches 0° stop bolt (see **Figure 102**).

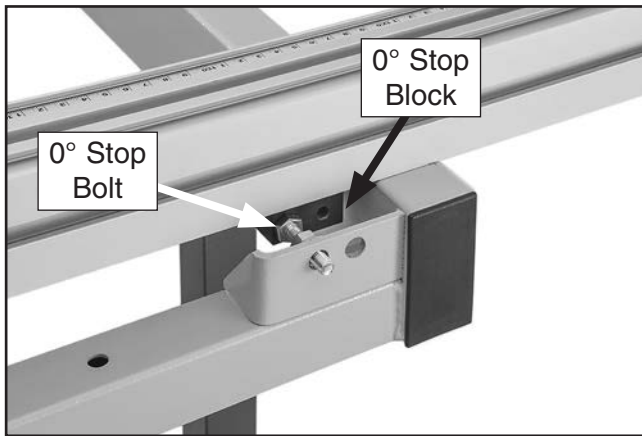


Figure 102. Stop block against 0° stop bolt.

2. Make sure fence is at 0°. If necessary, adjust as described in **Squaring Crosscut Fence to Blade on Page 77**.
3. Calibrate crosscut fence (see **Calibrating Crosscut Fence on Page 50**).

4. Set flip stop to desired width of cut (see **Figure 103**) by loosening flip stop knob bolt, sliding flip stop until it aligns with desired mark on scale, then tightening knob bolt.

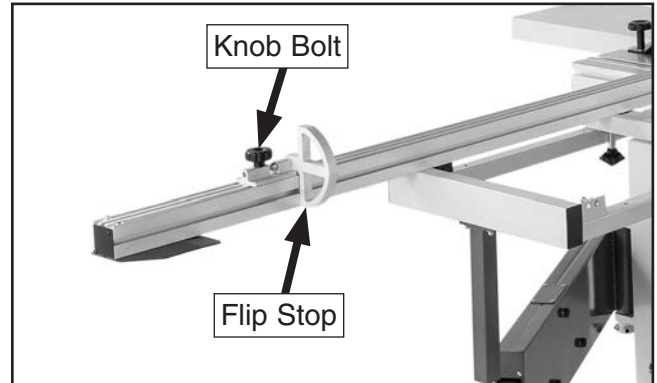


Figure 103. Location of flip stop and flip stop knob bolt.

5. Load workpiece onto table saw. Setup should look similar to **Figure 100 on Page 51**.
6. Take all necessary safety precautions, then perform cutting operation.

Rip Cutting with Rip Fence

1. Move crosscut table and fence to front of sliding table, then lock them in place with crosscut table lock lever (see **Figure 104**).

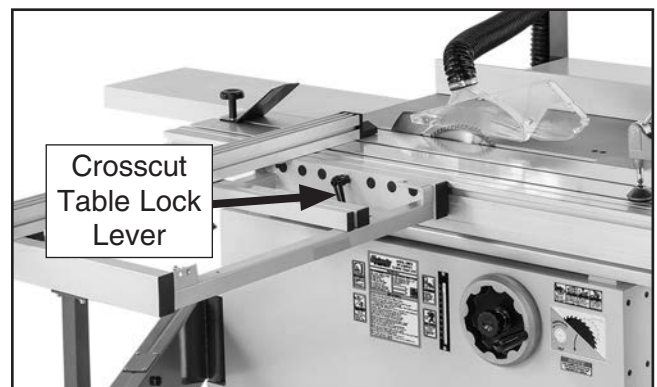


Figure 104. Location of crosscut table lock lever.



2. Lock sliding table in place with sliding table lock lever (see **Figure 105**).



Figure 105. Location of sliding table lock lever.

3. Loosen slide lock lever shown in **Figure 106**.



Figure 106. Location of slide lock lever.

4. Place fence in vertical position for thicker workpieces, or horizontal position for thinner workpieces and angled cuts where blade is tilted over fence (see **Figure 107**).

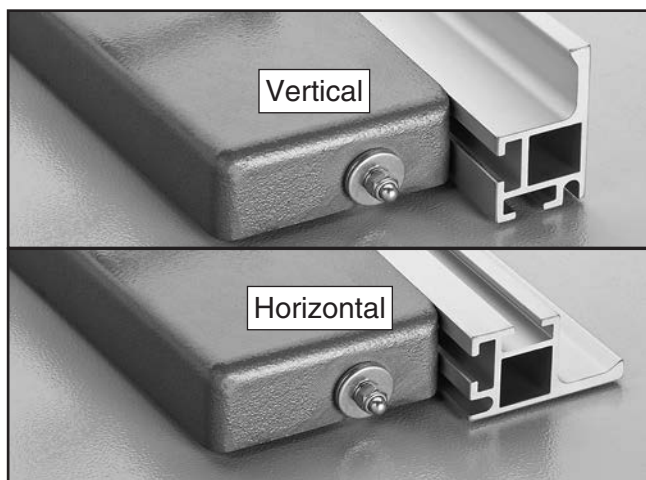


Figure 107. Rip fence positions.

5. Position leading edge of rip fence so it extends across extension wing, as shown in **Figure 108**, then tighten lock lever.
6. Lift rip fence lock lever (see **Figure 108**) and adjust fence to approximate width of cut.
7. Tighten micro-adjust lock knob (see **Figure 108**), then turn micro-adjust knob to fine tune width of cut.

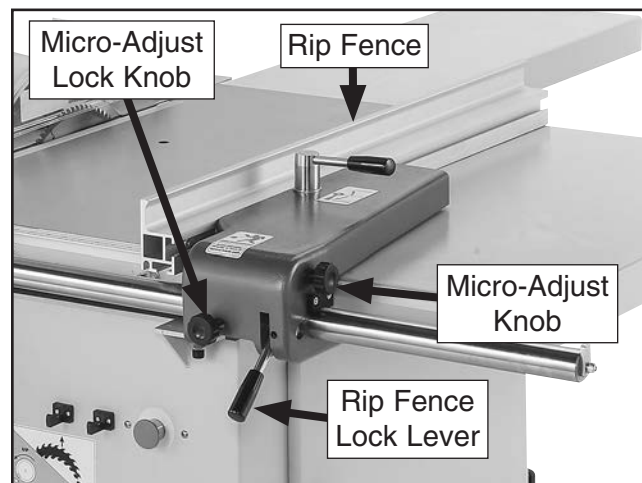


Figure 108. Proper position of rip fence.

8. Push rip fence lock lever down to secure fence assembly in position.
9. Load workpiece onto table saw. Setup should look similar to **Figure 101** on **Page 51**.
10. Take all necessary safety precautions, then perform cutting operation.



Crosscutting

The Model G0820 can crosscut full-size panels with the fence in the front or rear position, although it is easier to load full-size panels with the crosscut fence mounted in the front position (see **Figure 109**).

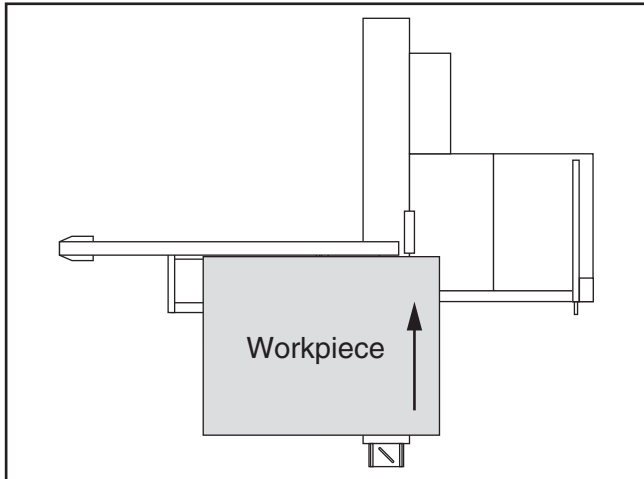


Figure 109. Crosscut with fence mounted in front position.

Mounting the crosscut fence in the rear position (see **Figure 110**) gives greater stability for crosscutting smaller panels.

The edge shoe is used to stabilize the front end of the workpiece when otherwise unsecured.

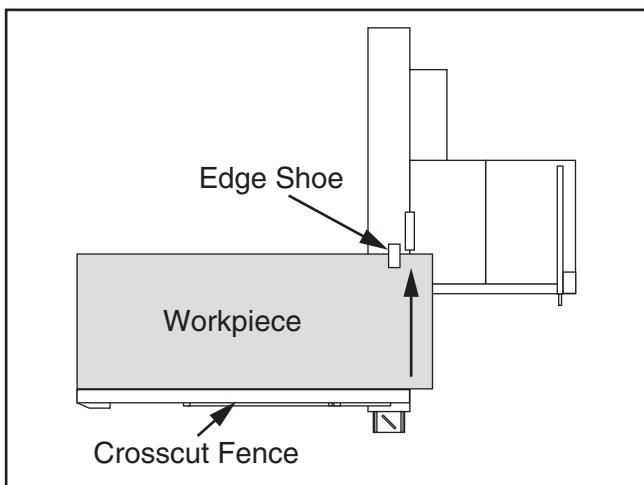


Figure 110. Crosscut with fence mounted in rear position.

When set up properly, the crosscut fence can support workpieces while using the rip fence as a cut-off gauge, as shown in **Figure 111**.

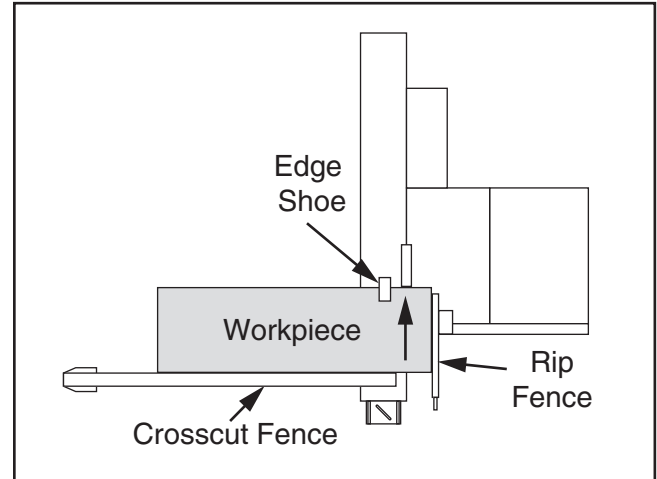


Figure 111. Crosscutting using rip fence as a cut-off gauge.

Determine which cutting operation will be best suited for the workpiece to be crosscut.

- If you will be crosscutting full-size panels, then proceed to **Crosscutting Full-Size Panels**.
- If you will be crosscutting smaller panels, then proceed to **Crosscutting Smaller Panels**.
- If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then proceed to **Crosscutting Using Rip Fence as Cut-Off Gauge**.

To understand how to move the crosscut table, see **Positioning Crosscut Table Along Sliding Table** on **Page 50**.



Crosscutting Full-Size Panels

1. Install crosscut fence in front mounting location shown in **Figure 112**.

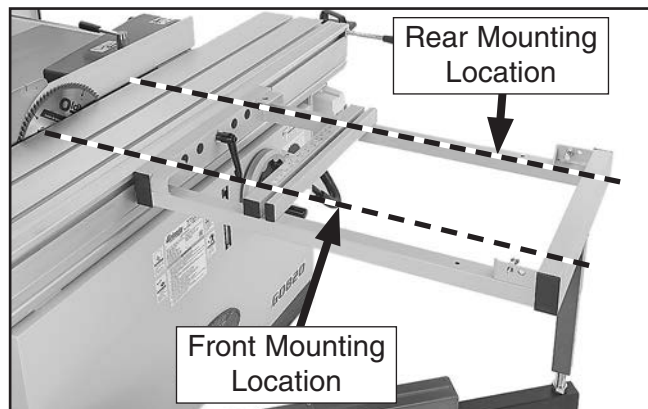


Figure 112. Crosscut fence mounting locations.

2. Make sure fence is at 0°, and if necessary, adjust as described in **Squaring Crosscut Fence to Blade** on **Page 77**.
3. Adjust distance between crosscut fence and blade (see **Page 50** for further details).
4. Set flip stop to desired width of cut.
5. Load workpiece onto table saw in front mounting location shown in **Figure 109**.
6. Take all necessary safety precautions, then perform cutting operation.

Crosscutting Smaller Panels

1. Install crosscut fence in rear mounting location shown in **Figure 110** and lock in place.
2. Perform **Steps 2–3** in **Crosscutting Full-Size Panels**.
3. Set flip stop to desired width of cut.
4. Load workpiece onto table saw in rear mounting location, shown in **Figure 110**. If necessary, use edge shoe to secure workpiece to sliding table.
5. Take all necessary safety precautions, then perform cutting operation.

Crosscutting Using Rip Fence as Cut-Off Gauge

1. Install crosscut fence in rear position of crosscut table, as shown in **Figure 111** on **Page 54**.
2. Perform **Steps 2–3** in **Crosscutting Full-Size Panels**.
3. Set rip fence to desired width of cut.
4. Slide leading end of rip fence behind front edge of blade (see **Figure 113**).

IMPORTANT: This step is critical to reducing the risk of blade binding and kickback!

5. Load workpiece onto table saw and against rip fence. Setup should look similar to **Figure 113**.

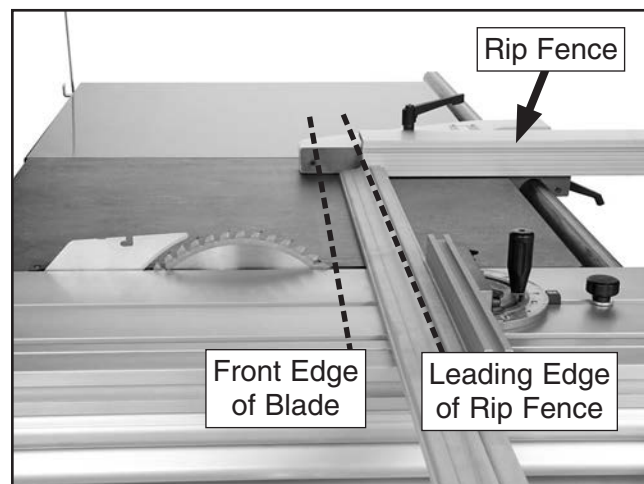


Figure 113. Example photo of correct rip fence position when using as a cut-off gauge (blade guard removed for clarity).

6. Take all necessary safety precautions, then perform cutting operation.



Miter Cutting

The crosscut fence can be positioned for miter cuts from 0°–45° using the front or rear crosscut table holes (see **Figure 114**). The angle scale on top of the crosscut table has a resolution of 1°.

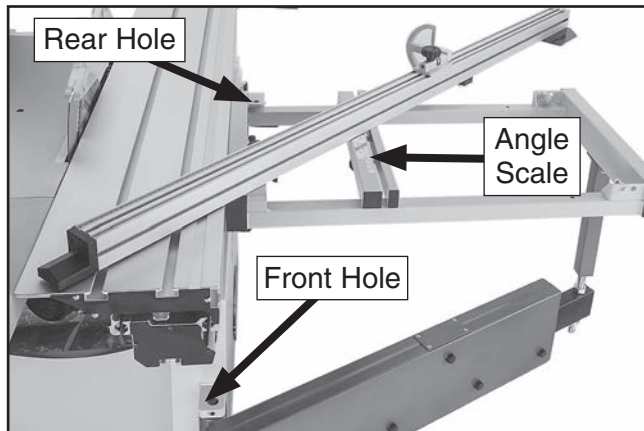


Figure 114. Crosscut fence positioned for miter cut.

To perform a miter cut:

1. DISCONNECT MACHINE FROM POWER!
2. Position crosscut table to provide greatest amount of workpiece support, then lock in place.
3. Install fence pivot bolt into front or rear holes shown in **Figure 114** to position table for desired angle of cut (see **Figures 115–116**).

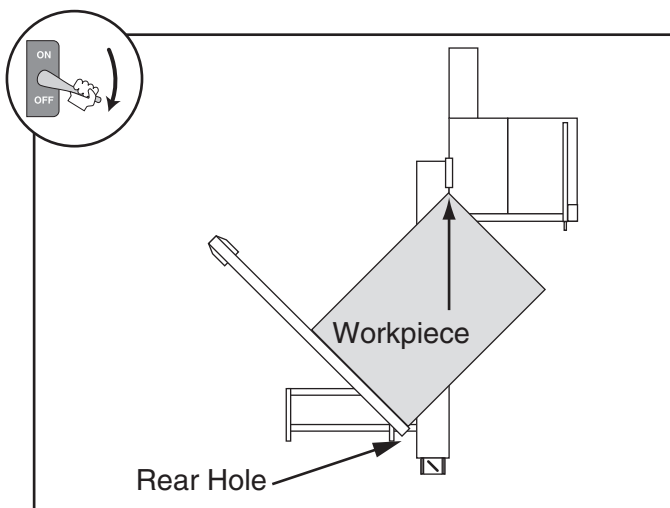


Figure 115. Crosscut fence mounted in rear hole for miter cuts from 0° to 45°.

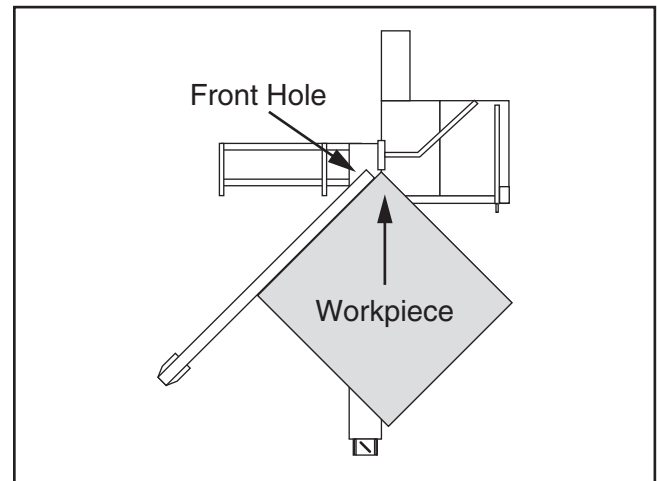


Figure 116. Crosscut fence mounted in front hole for miter cuts from 0° to 45°.

4. Install angle scale knob bolt (see **Figure 117**).

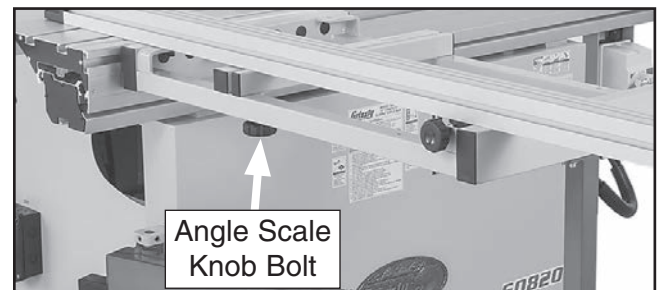


Figure 117. Location of angle scale knob bolt.

5. Pivot crosscut fence to desired angle, making sure fence end cap is clear of blade so it will not be cut during operation.
6. Tighten angle scale knob bolt to secure setting.

!WARNING

If crosscut fence moves during cutting, kickback could occur and cause serious personal injury. Always make sure crosscut fence is properly secured before using.

7. Set flip stop according to length of workpiece being cut off to left of blade.
8. Load workpiece onto crosscut table. Setup should look similar to **Figures 115–116**.
9. Take all necessary safety precautions, connect machine to power, then perform cutting operation.



Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece.

Typically, dados can be cut using either a dedicated dado blade or a standard saw blade. However, since the Model G0820 cannot accept dado blades, a standard blade must be used.

To use standard saw blade to cut a dado:

1. DISCONNECT MACHINE FROM POWER!
2. Mark width of dado cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is lying on table.
3. Raise blade to desired depth of dado channel.
4. Align workpiece with blade to cut one dado side, as shown in **Figure 118**, then align rip fence with workpiece.

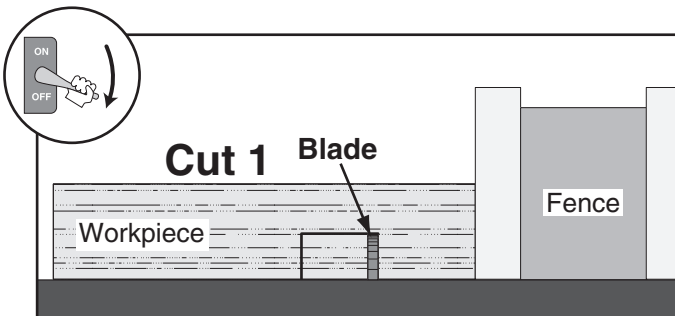


Figure 118. First cut for a single-blade dado.

5. Connect machine to power and turn saw **ON**.
6. Allow blade to reach full speed, then perform cutting operation.

7. Adjust fence and repeat cutting operation on other side of dado channel, as shown in **Figure 119**.

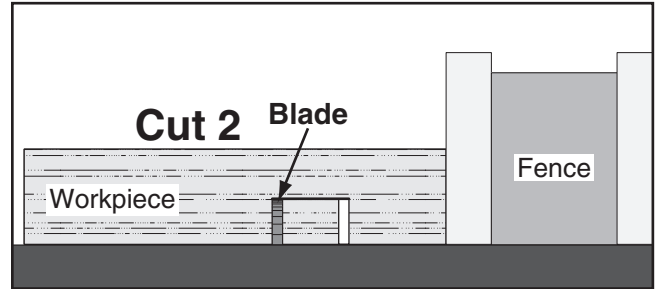


Figure 119. Second cut for a single-blade dado.

8. Make additional cuts in center of dado to clear out necessary material (see **Figure 120**). Dado is complete when channel is completely cleared out.

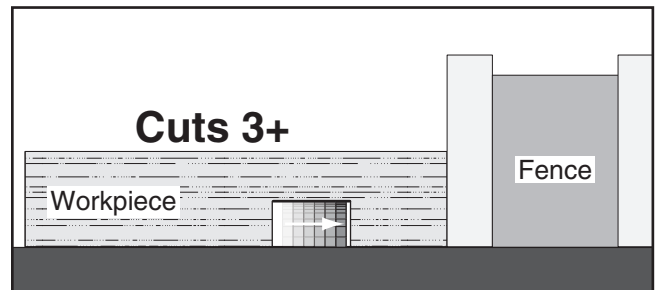


Figure 120. Additional single-blade dado cuts.

! WARNING

Adjust rip fence to properly support workpiece for each of the dado cuts. This will reduce likelihood of kickback and injury.



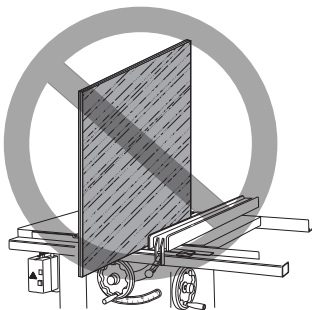
Rabbet Cutting

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece.

Typically, rabbets can be cut with either a dado blade or a standard saw blade. However, because the Model G0820 cannot accept dado blades, rabbets must be cut with a standard saw blade only.

A ripping blade is typically the best blade to use for cutting rabbets when using a standard blade because it removes sawdust very efficiently. (See **Page 44** for blade details.) Also, a sacrificial fence is not required when cutting rabbets with a standard blade.

! WARNING



DO NOT place a tall board on edge when cutting a rabbet. Overly tall workpieces cannot be properly supported with the fence and can easily shift during operation, causing kickback or loss of control. Instead, use another tool to cut these types of rabbets.

To cut rabbets with standard blade:

1. DISCONNECT MACHINE FROM POWER!
2. Mark width of rabbet cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is supported on table.

! CAUTION

Always use push sticks, featherboards, push paddles, and other safety accessories whenever possible to increase safety and control during operations which require removal of blade guard. **ALWAYS** replace blade guard after operation is complete.

3. Raise blade to desired depth of rabbet channel being cut.
4. Stand workpiece on edge, as shown in **Figure 121**, then adjust rip fence so blade is aligned with inside of rabbet channel.

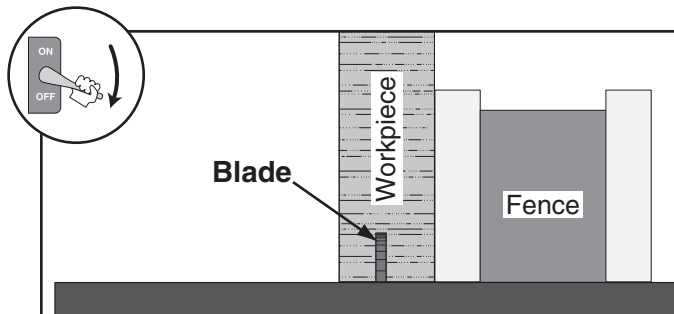


Figure 121. First rabbet cut.

5. Connect machine to power source, then perform cutting operation.
6. Lay workpiece flat on table, as shown in **Figure 122**, adjust saw blade height to intersect with first cut, then perform second cut to complete rabbet.

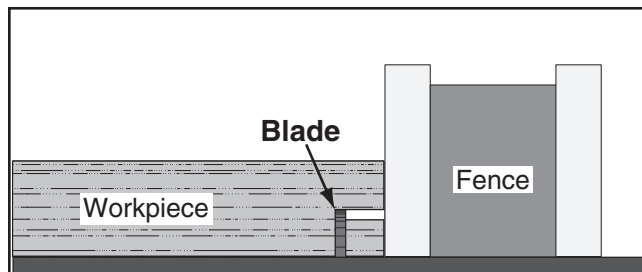


Figure 122. Second cut to create a rabbet.



Resawing

!WARNING

Resawing operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when resawing. Any tilting or movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

Resawing is the process of cutting a thick piece of stock into one or more thinner pieces. Although resawing can be done with a table saw, we strongly recommend that you use a bandsaw instead.

A bandsaw is the ideal machine for resawing, and resawing with one is fairly easy and safe. A table saw is not intended for resawing, and resawing with one is difficult and dangerous due to the increased risk of kickback from binding and deep cuts, and the increased risk of injury from having to remove the blade guard.

If you insist on resawing with a table saw, DO NOT do so without using a resaw barrier and wearing safety glasses and a full face shield.

The following instructions describe how to build a resaw barrier that can be used with the rip fence when resawing to reduce the risk of injury.

IMPORTANT: This table saw can only resaw wood that is less than 8" tall, and the rip fence must be used (rather than the sliding table).

Making a Resaw Barrier

The resaw barrier acts in tandem with the rip fence when resawing to provide tall support for the workpiece to minimize the probability of it binding against the blade and causing kickback.

Tools Needed

| | Qty |
|--------------------------|-------------|
| Table Saw | 1 |
| Jointer and Planer | As Needed |
| Clamps | 2 (Minimum) |
| Power Drill | 1 |
| Drill Bits | As Needed |

Components Needed for Resaw Barrier Qty

| | |
|---|-----------|
| Wood* 3/4" x 5 1/2" x Length of Fence | 1 |
| Wood* 3/4" x 3" x Length of Fence | 1 |
| Wood Screws #8 x 2" | 8 |
| Wood Glue | As Needed |

**Only use furniture-grade plywood or kiln-dried hardwood to prevent warping.*

To make a resaw barrier:

1. Cut wood pieces to sizes specified above. If using hardwood, cut pieces oversize, then joint and plane them to correct size to make sure they are square and flat.
2. Pre-drill and countersink four holes approximately 3/8" from bottom of 5 1/2" tall wood piece.
3. Glue end of 3" board and clamp boards at a 90° angle with larger board in vertical position, the fasten together with wood screws (see **Figure 123**).

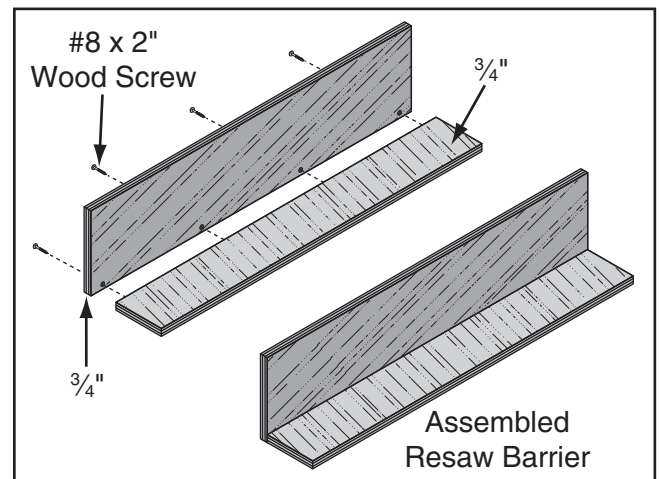


Figure 123. Resaw barrier.



Resawing Operations

The table saw motor is pushed to its limits when resawing. If the motor starts to bog down, slow down your feed rate. Motor overloading and blade wear can be reduced by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.

| Components Needed for Resawing | Qty |
|--------------------------------|-----|
| Ripping Blade 12" | 1 |
| Clamps | 2 |
| Shop-Made Resaw Barrier | 1 |

⚠ WARNING

You may experience kickback during this procedure. Stand to the side of the blade path and wear safety glasses and a full face shield to reduce risk of injury.

To perform resawing operations:

1. DISCONNECT MACHINE FROM POWER!
2. Raise blade guard up and out of the way.
3. Install rip fence in vertical position.
4. Place workpiece against rip fence and slide resaw barrier against workpiece (see **Figure 124**).

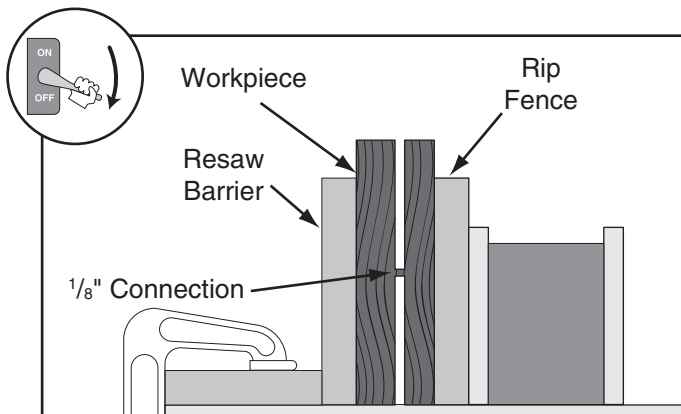


Figure 124. Ideal completed resaw cut.

5. Clamp resaw barrier to table top.
6. Connect saw to power, lower blade completely below table, and slide workpiece over blade to make sure it moves smoothly and fits between resaw barrier and rip fence.
7. Raise blade approximately 1", or close to half the height of the workpiece, whichever is less.
8. Turn machine **ON**, and use push stick to feed workpiece through blade using a slow, steady feed rate.
9. Flip workpiece end over end, keeping same side against rip fence, and run workpiece through blade.
10. Repeat **Steps 7–9** until blade is close to half the height of workpiece to be resawn.

IMPORTANT: Ideal resaw cut will leave approximately $\frac{1}{8}$ " connection when resawing is complete (see **Figure 124**). Leaving a $\frac{1}{8}$ " connection will reduce risk of kickback.

11. Turn saw **OFF**, then separate parts of workpiece and hand plane remaining ridge.
12. When finished resawing, remove resaw barrier and reposition blade guard over blade.



SECTION 5: SHOP MADE SAFETY ACCESSORIES

Featherboards

Easily made from scrap stock, featherboards provide an added degree of protection against kickback, especially when used together with push sticks. They also maintain pressure on the workpiece to keep it against the fence or table while cutting, which makes the operation easier and safer because the cut can be completed without the operator's hands getting near the blade. The angled ends and flexibility of the fingers allow the workpiece to move in only one direction.

Making a Featherboard

This sub-section covers the two basic types of featherboards: 1) Those secured by clamps, and 2) those secured with the miter slot.

Material Needed for Featherboard

Hardwood $\frac{3}{4}$ " x 3" x 10" (Minimum)
 Hardwood $\frac{3}{4}$ " x 6" x 28" (Maximum) 1

Additional Material Needed for Mounting Featherboard in Miter Slot

Hardwood $\frac{3}{8}$ " x Miter Slot Width x 5" Length 1
 Wing Nut $\frac{1}{4}$ "-20 1
 Flat Head Screw $\frac{1}{4}$ "-20 x 2" 1
 Flat Washer $\frac{1}{4}$ " 1

To make a featherboard:

1. Cut hardwood board approximately $\frac{3}{4}$ " thick to size. The length and width of board can vary according to your design. Most featherboards are 10"–28" long and 3"–6" wide. Make sure wood grain runs parallel with length of featherboard, so fingers you will create in **Step 3** will bend without breaking.
2. Cut a 30° angle on one end of board.

⚠ CAUTION

We recommend using a bandsaw for making fingers in the next step because it tends to be safer. A table saw can be used, but it will over-cut the underside of the ends, produce a thicker kerf, and require you to stop the blade half-way through the cut, which can be dangerous.

3. Make a series of end cuts with grain $\frac{3}{8}$ "– $\frac{1}{4}$ " apart and 2"–3" long (see **Figure 125A**). Alternatively, start cuts at 2"-3" deep, then make progressively deeper (see **Figure 125B**).

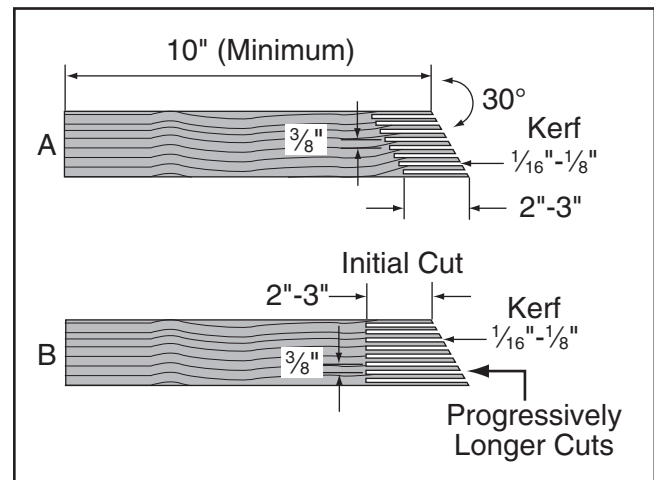


Figure 125. Patterns for featherboards (top view shown).

IMPORTANT: Cuts made across grain result in weak fingers that easily break when flexed. When made correctly, fingers should withstand flexing from moderate pressure. To test the finger flexibility, push firmly on the ends with your thumb. If the fingers do not flex, they are likely too thick (the cuts are too far apart).

NOTICE

Only Steps 1–3 are required to make a clamp-mounted featherboard. See Page 63 for instructions on clamping.



- Route $\frac{1}{4}$ "– $\frac{3}{8}$ " wide slot 4"–5" long in workpiece and 1"–2" from short end of featherboard (see **Figure 126**).

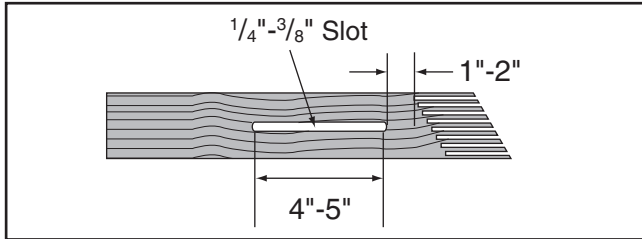


Figure 126. Slot routed in featherboard.

- Cut a miter bar that will fit in table miter slot approximately 5" long, as shown in **Figure 127**.

Tip: Consider making miter bar longer for larger featherboards—approximately half the length of total featherboard—to support force applied to featherboard during use.

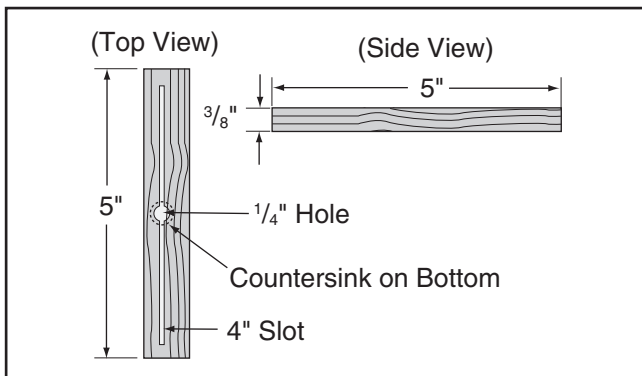


Figure 127. Miter bar pattern.

- Drill $\frac{1}{4}$ " hole in center of bar, then countersink bottom to fit $\frac{1}{4}$ "-20 flat head screw.

- Mark 4" line through center of countersunk hole, then use jig saw with narrow blade to cut holed.

- Assemble miter bar and featherboard with $\frac{1}{4}$ "-20 x flat head screw, flat washer, and a wing nut or a star knob (see **Figure 128**). Congratulations! Featherboard is complete.

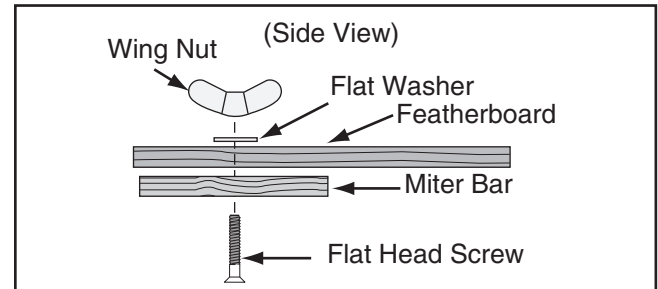


Figure 128. Assembling miter slot featherboard components.

Note: Routed slot, countersink hole, and flat head screw are essential for miter bar to clamp into miter slot. When wing nut is tightened, it will draw flat head screw upward into countersunk hole. This will spread sides of miter bar and force them into walls of miter slot, locking featherboard in place.

Tip: Length of flat head screw depends on thickness of featherboard—though $1\frac{1}{2}$ " to 2" lengths usually work.

- Proceed to **Mounting Featherboard in Miter Slot** on **Page 63**.



Mounting Featherboards w/Clamps

1. Lower saw blade, then adjust fence to desired width and secure.
2. Place workpiece against fence, making sure it is 1" in front of blade.
3. Place featherboard on table away from blade so all fingers point forward and contact workpiece (see **Figure 129**).

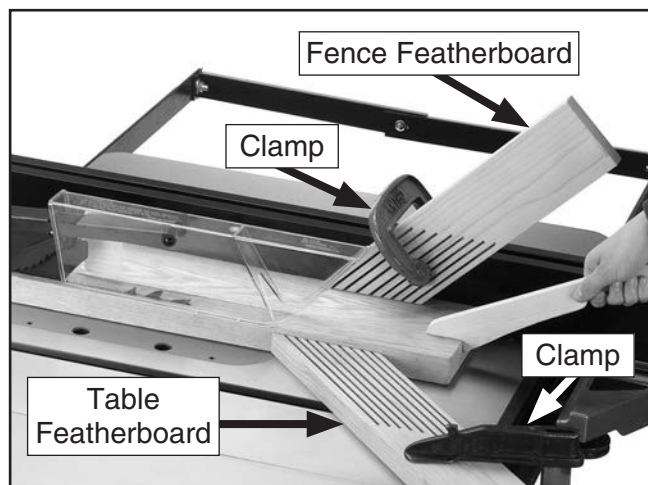


Figure 129. Example of featherboards secured with clamps.

4. Secure featherboard to table with clamp.
5. Check featherboard by pushing it with your thumb to ensure it is secure.
— If featherboard moves, tighten clamp more.
6. Mount second featherboard to fence with a clamp (see **Figure 129**), then repeat **Step 5** to ensure it is secure.

Mounting Featherboard in Miter Slot

1. Lower saw blade, then adjust fence to desired width and secure.
2. Place workpiece evenly against fence, making sure it is 1" in front of blade.
3. Slide featherboard miter bar into miter slot, making sure fingers slant toward blade, as shown in **Figure 130**.

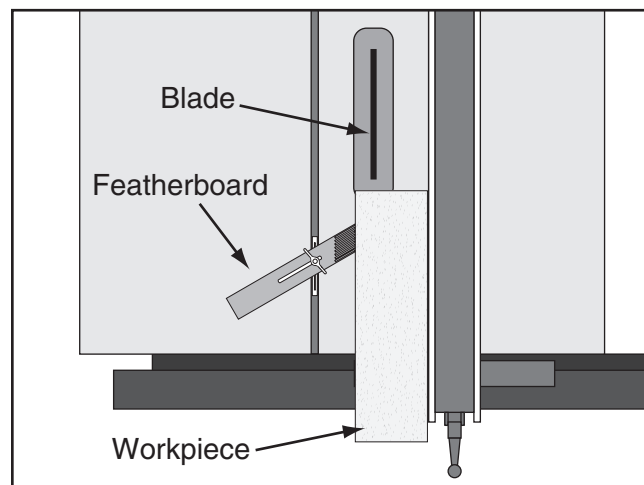


Figure 130. Featherboard installed in miter slot and supporting workpiece for ripping cut.

4. Position fingered edge of featherboard against edge of workpiece so that all fingers contact workpiece. Slide featherboard toward blade until first finger is nearly even with end of workpiece, which should be 1" away from blade.
5. Verify workpiece and featherboard are properly positioned as described in **Step 4**. Secure featherboard to table, then check featherboard by hand to make sure it is tight.

Note: Featherboard should be placed firmly enough against workpiece to keep it against fence, but not so tight that it is difficult to feed workpiece.



Push Sticks

When used correctly, push sticks reduce the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push stick can also absorb damage that would have otherwise happened to hands or fingers.

Using a Push Stick

Use push sticks whenever your hands will get within 12" of the blade. To maintain control when cutting large workpieces, start the cut by feeding with your hands then use push sticks to finish the cut, so your hands are not on the end of the workpiece as it passes through the blade.

Feeding: Place the notched end of the push stick against the end of the workpiece (see inset **Figure** below), then move the workpiece into the blade with steady, downward and forward pressure through full length of the cut.

Supporting: A second push stick can be used to keep the workpiece firmly against the fence while cutting. When using a push stick in this manner, only apply pressure before the blade; otherwise, pushing the workpiece against or behind the blade will increase the risk of kickback (see **Push Stick Prohibition Zone** in the **Figure** below).

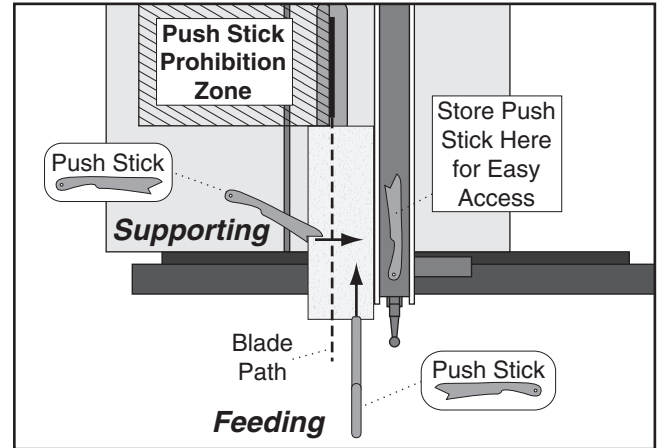


Figure 131. Using push sticks to rip narrow stock.

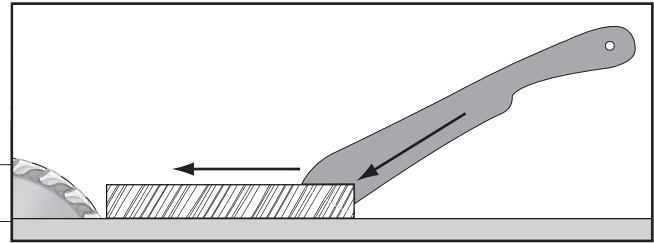
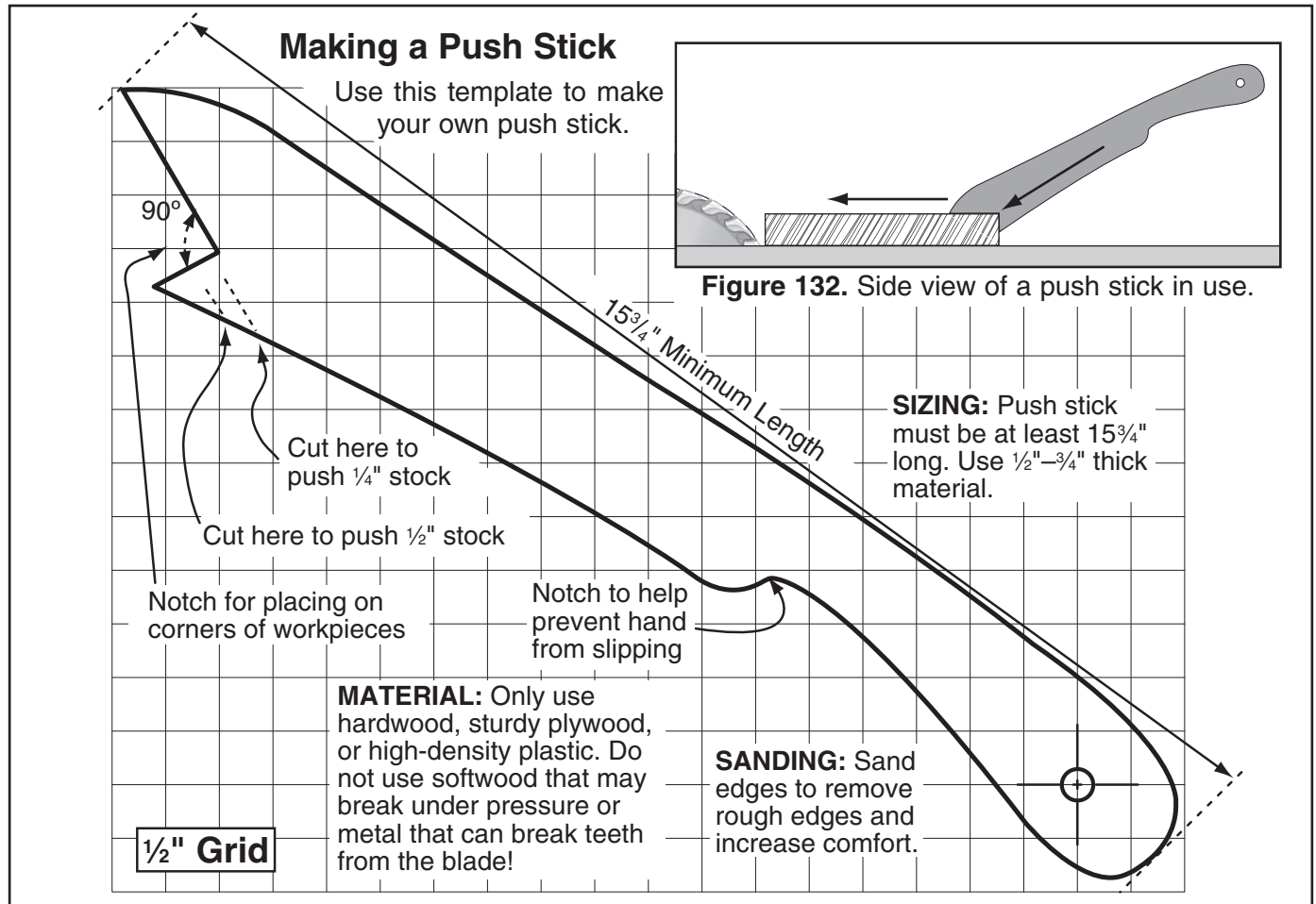


Figure 132. Side view of a push stick in use.

Figure 133. Template for a basic shop-made push stick (not shown at actual size).



Push Blocks

When used correctly, a push block reduces the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push block often takes the damage that would have otherwise happened to hands or fingers.

Using a Push Block

A push block can be used in place of or in addition to a push stick for feeding workpieces into the blade. Due to their design, push blocks allow the operator to apply firm downward pressure on the workpiece that could not otherwise be achieved with a push stick.

The push block design on this page can be used in two different ways (see inset **Figure** below). Typically, the bottom of the push block is used until the end of the workpiece reaches the blade.

The notched end of the push block is then used to push the workpiece the rest of the way through the cut, keeping the operator's hands at a safe distance from the blade. A push stick is often used at the same time in the other hand to support the workpiece during the cut (see **Using a Push Stick** on previous page).

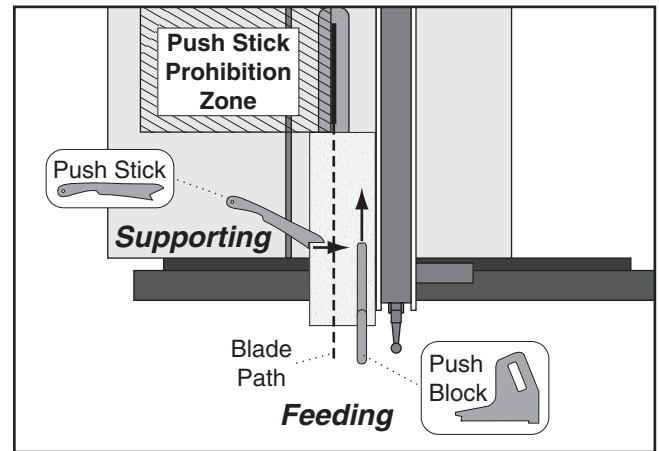


Figure 135. Using a push block and push stick to make a rip cut.

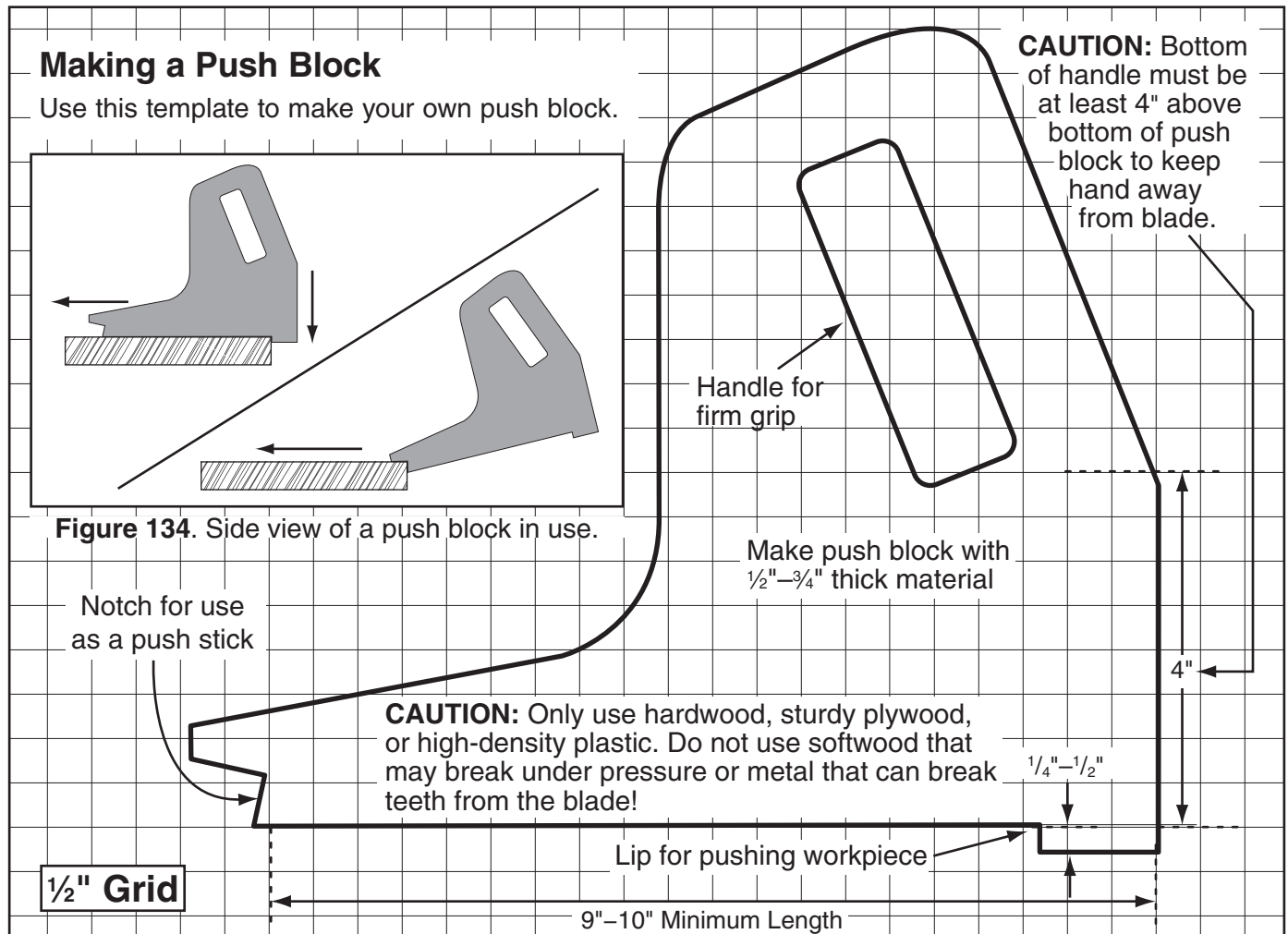


Figure 136. Template for a shop-made push block (shown at 50% of full size).



SECTION 6: 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.

T26419—Syn-O-Gen Synthetic Grease

Formulated with 100% pure synthesized hydrocarbon basestocks that are compounded with special thickeners and additives to make Syn-O-Gen non-melt, tacky, and water resistant. Extremely low pour point, extremely high temperature oxidation, and thermal stability produce a grease that is unmatched in performance.



Figure 137. Model T26419 Syn-O-Gen Synthetic Grease.

T23037—Replacement Scoring Blade



Figure 138. Model T23037 Scoring Blade.

H4754—Duraline HI-A/T, Melamine & Veneer Blade 80T

For chipless cutting of two-sided melamine, vinyl, polyester, and kortron. Recommended for thin, low pressure, two-sided laminates and veneer plywood. For thin veneers on flakeboard - fire-retardant, laminated (1 or 2 sides), masonite, fiber board, lumbercore, glue-ups, hard/soft woods and chemically impregnated wood. Arbor bore size is 1" and kerf is 0.125".



Figure 139. 12" 80T Duraline HI-A/T saw blade.

T26700—12" Carbide-Tipped Ripping Blade, 40T

ATB grind on micro-grain carbide tips ensure consistent performance over a long cutting life. Arbor bore size is 1" and kerf is 0.125". This 40-tooth blade is designed for ripping and cross cutting.



Figure 140. 12" 40T Carbide-tipped saw blade.

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



G0572—Hanging Air Filter with Remote

This Hanging Air Filter has a convenient remote control and features a three-speed motor, automatic shutoff timer, 1-micron secondary filter, and 5-micron primary filter. Air flow is 556, 702, and 1044 CFM. Overall size is 26" long x 19¼" wide x 15" high. Approximate shipping weight is 58 lbs.



Figure 141. Model G0572 Hanging Air Filter with Remote.

W1732—Adjustable Roller Stand

- Roller size: 19½" long x 2" dia., 9 each
- Minimum stand length: 19½"
- Maximum stand length: 54"
- Minimum stand height: 24½"
- Maximum stand height: 38"
- Casters: Polyurethane, 4¼" dia., locking
- Legs: Independently adjustable
- Maximum weight capacity: 300 lbs.

Multiple stands can be connected for unlimited rolling capacity.

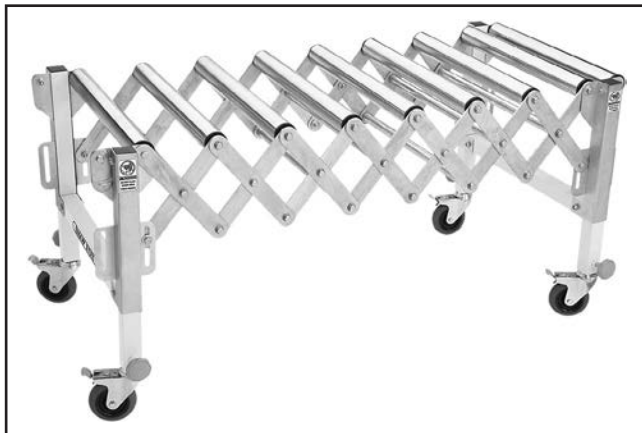


Figure 142. Model W1732 Adjustable Roller Stand.

G0777HEP—1.5 HP Ultra-Quiet Cyclone Dust Collector

Specifications:

- Motor: 1½ HP, 110V/220V, single-phase, TEFC, prewired 110V
- Airflow capacity: 880 CFM at 1.9" SP
- Maximum static pressure: 9"
- Filtration: Primary is 99.9% at 0.2-2 microns, secondary is 99.97% at 0.3 microns
- Intake port: 6"
- Cartridge filter surface area: 48 sq. ft.
- Overall size: 44"W x 72½"H x 34"D



Figure 143. Model G0777 Ultra-Quiet Cyclone Dust Collector.

G7978—15 HP Rotary Phase Converter

This rotary phase converters allow you to operate 3-phase machinery from a single-phase power source at 100% power and 95% efficiency. This model operates up to twice its nameplate rating in mixed-motor load. For heavily-loaded or hard-start machinery, such as CNC routers or dust collectors, choose a nameplate rating 3 times the HP of the most heavily loaded motor.

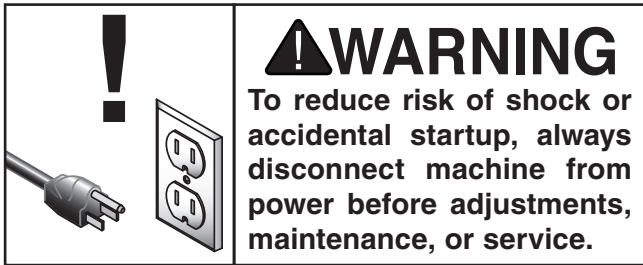


Figure 144. Model G7978 15 HP Rotary Phase Converter.

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



SECTION 7: MAINTENANCE



Schedule

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

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance:

- Clean sliding table surface and grooves.
- Clean and protect cast iron-table.
- Clean rip fence and slide ways.

Monthly Maintenance:

- Clean/vacuum dust buildup from inside cabinet and off motors.
- Check/replace belts for proper tension, damage or wear (**Page 73**).

Every 6–12 Months:

- Lubricate trunnions (**Page 69**).
- Lubricate leadscrews (**Page 70**).
- Lubricate sliding table ways (**Page 70**).

Cleaning & Protecting

Cleaning the Model G0820 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin-dissolving cleaner to remove it.

Protect the unpainted cast-iron table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Figure 145**).

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray



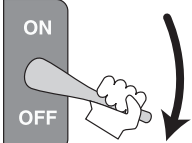
Figure 145. Recommended products for protecting unpainted cast iron/steel parts on machinery.



Lubrication

An essential part of lubrication is cleaning the components before lubricating them. This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more lubrication to built-up grime will not result in smooth-moving parts. Clean the components in this section with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

All bearings are sealed and permanently lubricated. Leave them alone until they need to be replaced.

| | |
|---|---|
|  | <p>⚠ WARNING</p> <p>To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.</p> |
|---|---|

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

Trunnions

| | |
|--|-------------|
| Lubrication Type ... T26419 or NLGI#2 Equivalent | |
| Amount | 1–2 Dabs |
| Lubrication Frequency | 6–12 Months |

To grease the blade-height trunnion, move the blade all the way down and smear a dab of grease into the trunnion groove shown in **Figure 146**, then move the blade through its full range of movement to spread the grease.

To grease the blade-tilt trunnions, move the sliding table out of the way, open the blade guard, then tilt the blade to 0°. From the front of the saw, smear a dab of grease in the front of the trunnion grooves on both sides. Now, tilt the blade to 45° and reach inside the cabinet and smear a dab of grease into the back of the trunnion grooves on both sides. Tilt the blade through its full range of movement to spread the grease.

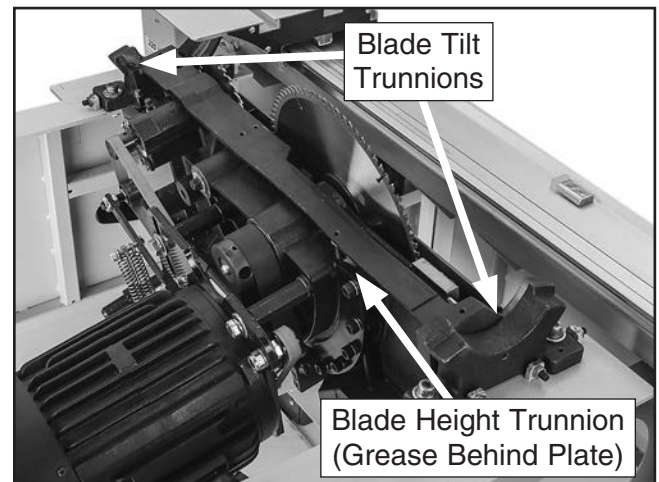


Figure 146. Trunnion lubrication locations (table removed for clarity).



Leadscrews

Lubrication Type ... T26419 or NLGI#2 Equivalent
AmountDab
Lubrication Frequency6-12 Months

Clean the threads of the elevation and tilt leadscrews (see **Figure 147**) with a stiff brush and mineral spirits. When dry, apply a thin coat of lubricant into the threads with a brush, and tilt the blade back and forth and raise and lower it a few times to distribute the grease.

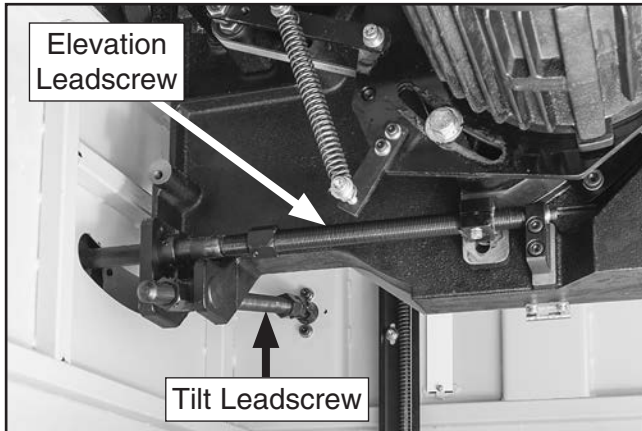


Figure 147. Elevation leadscrew locations.

Sliding Table Ways

Lubrication Type Light Machine Oil
AmountThin Coat
Lubrication Frequency6-12 Months

Steel ways (see **Figure 148**) on both sides of the sliding table fit between the top and the base and allow these parts to slide past each other. Clean the ways with mineral spirits and shop rags, then apply a thin coat of light machine oil with a shop rag. Move the sliding table through its full range of movement several times to evenly distribute the oil.

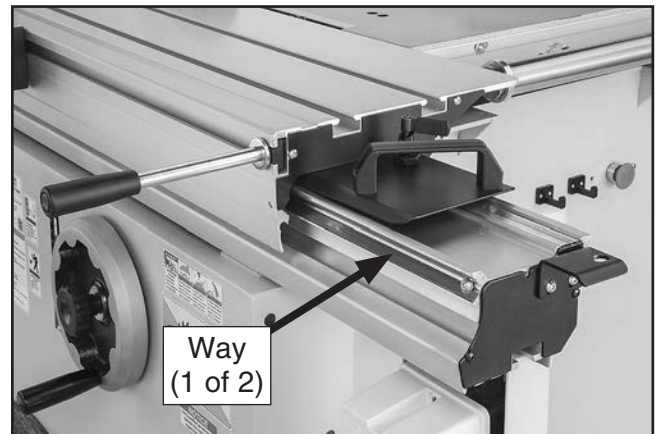


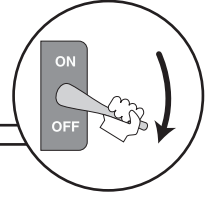
Figure 148. Sliding table way (1 of 2).



SECTION 8: SERVICE

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

Troubleshooting



Motor & Electrical

| Symptom | Possible Cause | Possible Solution |
|---|--|---|
| Machine does not start or a breaker trips immediately upon startup. | <ol style="list-style-type: none"> Spindle lever not engaged. Emergency Stop button engaged/not reset. Power supply switched OFF or at fault. Blade guard limit switch engaged/at fault. Cabinet door open/door safety switch at fault. Power supply circuit breaker tripped or fuse blown. Thermal overload relay has tripped. Contactors not energized/has poor contacts. Wires are disconnected, damaged, or connected incorrectly. ON button or Emergency Stop button at fault. Motor at fault. | <ol style="list-style-type: none"> Engage spindle lever. Rotate button head to reset. Ensure power supply switch is on; ensure power supply has correct voltage. Move blade guard to working position; replace faulty limit switch. Close door/replace faulty safety switch. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. Reset; adjust trip load dial if necessary; replace. Test all legs for power/replace. Fix or replace damaged, disconnected, or misconnected wires. Replace faulty switch button. Test/repair/replace. |
| Blades rotate in opposite direction than they should. | <ol style="list-style-type: none"> Incoming power supply connected out-of-phase. | <ol style="list-style-type: none"> Reverse R & T incoming power connections in junction box (Page 35). |
| Machine stalls or is underpowered. | <ol style="list-style-type: none"> Cutting improper workpiece material. Feed rate/cutting speed too fast. Workpiece crooked; fence loose or misadjusted. Belt(s) slipping. Oil/grease on belt(s). Motor wired incorrectly. Machine undersized for task. Motor overheated. Dull blades. Pulley slipping on shaft. Magnetic switch contactor at fault (not energized/has poor contacts). | <ol style="list-style-type: none"> Only cut proper workpiece material (Page 39). Decrease feed rate/cutting speed. Straighten or replace workpiece/adjust fence. Tension/clean/replace belt(s); ensure pulleys are aligned. Wire motor correctly. Use correct, sharp blade; reduce feed rate or depth of cut. Clean motor, let cool, and reduce workload. Sharpen/replace blades. Replace loose pulley/key/set screw. Test all legs for power/replace. |



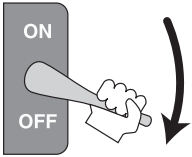
Machine Operation

| Symptom | Possible Cause | Possible Solution |
|--|--|---|
| Machine has vibration or noisy operation. | <ol style="list-style-type: none"> 1. Motor or component is loose/broken. 2. Blade dull, damaged, or otherwise at fault. 3. Worn, damaged, or loose belts. 4. Pulley loose. 5. Machine incorrectly mounted or sits unevenly on floor. 6. Motor fan rubbing on fan cover. 7. Arbor bearings at fault. 8. Motor bearings at fault. | <ol style="list-style-type: none"> 1. Tighten loose fasteners. Replace stripped or damaged bolts/nuts. Use thread-locking fluid, if necessary. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Tighten belt. Replace worn or damaged belts (Page 73). 4. Tighten fasteners. Re-align/replace shaft, pulley, set screw, and key as required. 5. Tighten/replace anchor studs in floor; relocate/shim machine. 6. Fix/replace fan cover; replace loose/damaged fan. 7. Replace arbor bearings; replace arbor. 8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. |
| Workpiece has burned edges, binds, or kicks back. | <ol style="list-style-type: none"> 1. Sliding table or rip fence not parallel with blade. 2. Riving knife not aligned with blade. 3. Blade is warped. | <ol style="list-style-type: none"> 1. Make sliding table parallel to blade (Page 76). 2. Align riving knife with main blade (Page 43). 3. Replace blade (Page 45). |
| Workpiece has chip out on the bottom edge. | <ol style="list-style-type: none"> 1. Scoring blade height incorrect. 2. Scoring blade not aligned with main blade. 3. Scoring blade kerf does not match main blade. | <ol style="list-style-type: none"> 1. Adjust height of scoring blade (Page 48). 2. Align scoring blade (Page 48). 3. Adjust scoring blade kerf (Page 48). |
| Sliding table saw does not cut square. | <ol style="list-style-type: none"> 1. Sliding table not parallel with blade. 2. Crosscut fence not perpendicular to blade. | <ol style="list-style-type: none"> 1. Make sliding table parallel to blade (Page 76). 2. Adjust crosscut fence perpendicular to blade (Page 77). |
| Rip fence hits table top when sliding across table. | <ol style="list-style-type: none"> 1. Rail too low. 2. Rip fence roller too low. | <ol style="list-style-type: none"> 1. Raise front rail (Page 79). 2. Adjust rip fence roller (Page 79). |
| Blade tilt does not stop at perfect 90°(0°), or 45°. | <ol style="list-style-type: none"> 1. Blade tilt stop nuts are out of adjustment. | <ol style="list-style-type: none"> 1. Adjust stop nuts (Page 75). |
| Rip fence scale is not accurate. | <ol style="list-style-type: none"> 1. Rip fence scale out of calibration or was not set up correctly. | <ol style="list-style-type: none"> 1. Adjust rip fence scale (Page 79). |
| Tilt or blade height handwheels difficult to turn. | <ol style="list-style-type: none"> 1. Lock knob tight. 2. Leadscrews caked with dust. 3. Stop nuts hitting end of tilt leadscrew travel. | <ol style="list-style-type: none"> 1. Loosen lock knob. 2. Clean off dust and lubricate leadscrews/gears. 3. Turn handwheel in opposite direction. |



Belt Service

Over time, belts will stretch and wear. To maintain efficient power transfer to the blade, make sure the belts are properly tensioned and in good condition. If belts show any glazing, fraying, or cracking, replace them. We recommend replacing both the main and scoring blade belts at the same time for convenience.

| | |
|---|---|
|  | <p>⚠ WARNING</p> <p>To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.</p> |
|---|---|

| | |
|---------------------------|------------|
| Items Needed | Qty |
| Open-End Wrench 19mm..... | 1 |

Tensioning Scoring Blade Belt

Proper tension of the scoring blade flat belt is automatically maintained by a spring between the tensioner pulley and motor shown in **Figure 149**.

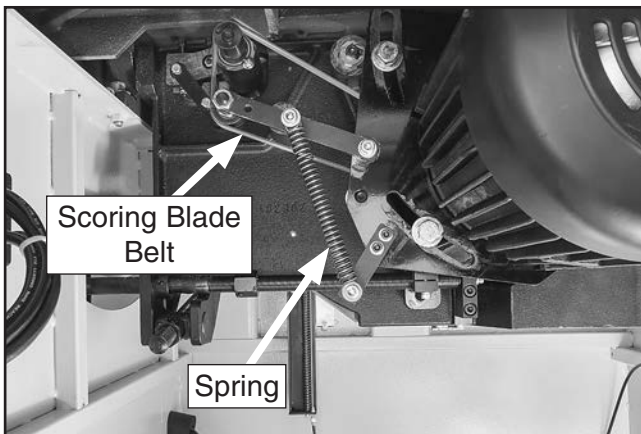


Figure 149. Location of scoring blade spring.

Tensioning Main Motor Belt

1. DISCONNECT MACHINE FROM POWER!
2. Open motor cabinet door.
3. Loosen pivot bolt and two adjustment bolts shown in **Figure 150**.

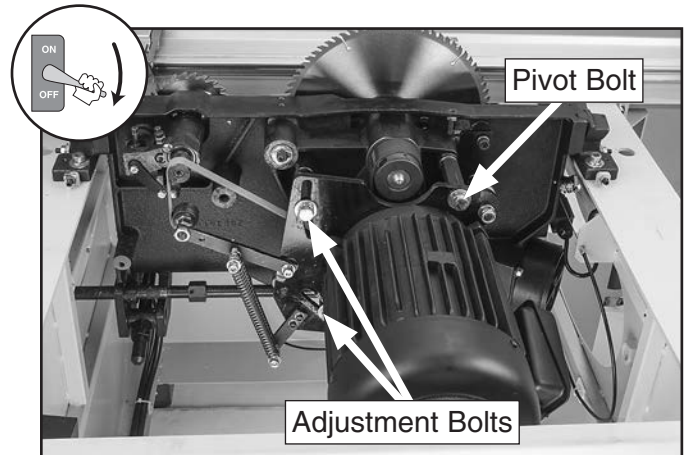


Figure 150. Location of adjustment and pivot bolts (cast-iron table removed).

4. Push motor down until there is approximately 1/4" deflection when you use moderate pressure between pulleys (see **Figure 151**), then tighten bolts loosened in **Step 3**.

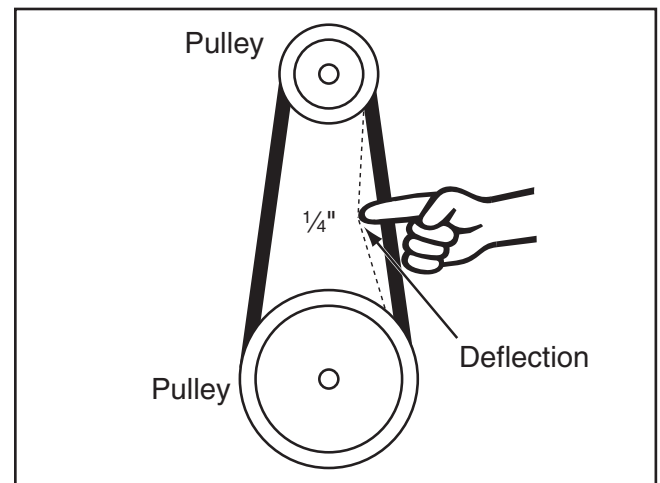


Figure 151. Testing for correct of belt tension.

5. Close motor cabinet door.



Replacing Main Belt & Scoring Belt

1. DISCONNECT MACHINE FROM POWER!
2. Open motor cabinet door.
3. Loosen pivot bolt and two adjustment bolts (see **Figure 152**).

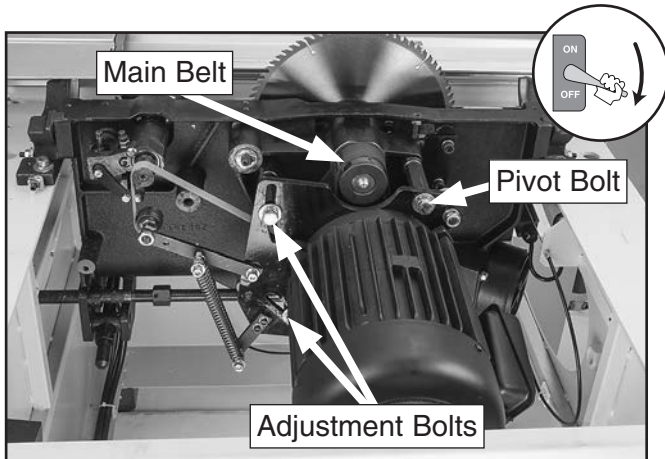


Figure 152. Locations of adjustment and pivot bolts (cast-iron table removed for clarity).

4. Raise motor to top position, then tighten bolts loosened in **Step 3**.
5. Remove scoring belt, then remove main belt from pulleys.

6. Replace main belt (shown in **Figure 152 & 153**), then place scoring belt onto pulleys, as shown in **Figure 153**.

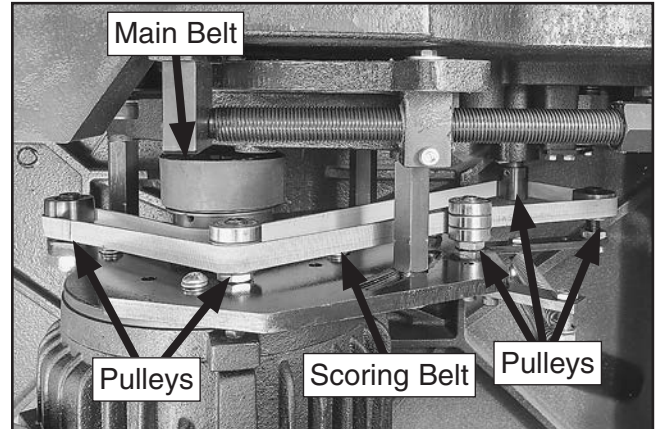


Figure 153. Scoring belt installed onto pulleys (cast-iron table removed for clarity).

7. Loosen pivot bolt and two adjustment bolts (see **Figure 152**), and lower motor to apply proper belt tension (see **Tensioning Main Belt** on **Page 73**).
8. Tighten pivot bolt and two adjustment bolts.
9. Close motor cabinet door.



Blade Tilt Calibration

The blade tilt stops are calibrated at the factory, but they can be recalibrated if they change during the life of the machine. The 0° stop positions the blade square to the table.

| Tools Needed | Qty |
|--------------------------------------|-------|
| Hex Wrench 3mm..... | 1 |
| Open-End Wrench 8mm..... | 1 |
| Machinist's Squares, 90° & 45° | 1 Ea. |

Calibrating 0° Stop

1. DISCONNECT MACHINE FROM POWER!
2. Move blade tilt to 0° and raise main blade all the way up.
3. Open cabinet door and identify stop nuts shown in **Figure 154**.

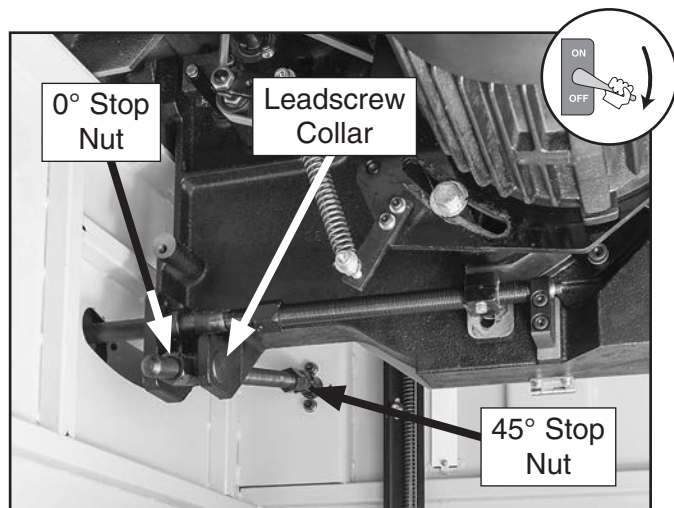


Figure 154. Blade tilt stop nuts.

4. Use machinist's square to check if main blade is square to table (see **Figure 155**).

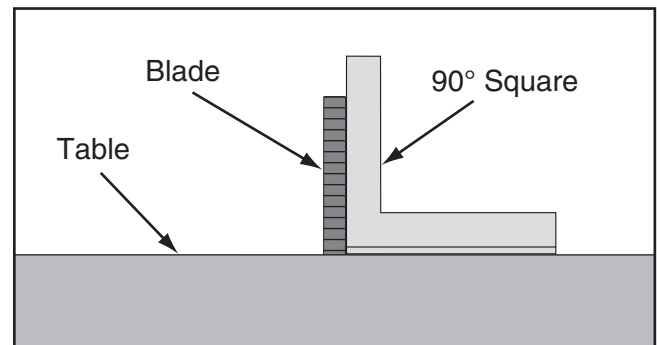


Figure 155. Machinist's square against blade and table.

- If main blade is *not* square to table, loosen (2) set screws on 0° stop nut, then loosen stop nut away from leadscrew collar.
- Adjust main blade tilt angle square to table.
- Tighten 0° stop nut against leadscrew collar, then tighten (2) set screws.

Calibrating 45° Stop

Use a similar procedure for the 45° stop nut shown in **Figure 154**, as previously instructed for the 0° stop nut.

Tilt Scale Calibration

If necessary, the blade tilt scale on the front of the saw can be adjusted by using the hex nuts shown on the tilt scale cable in **Figure 156**. These are accessed inside the cabinet.

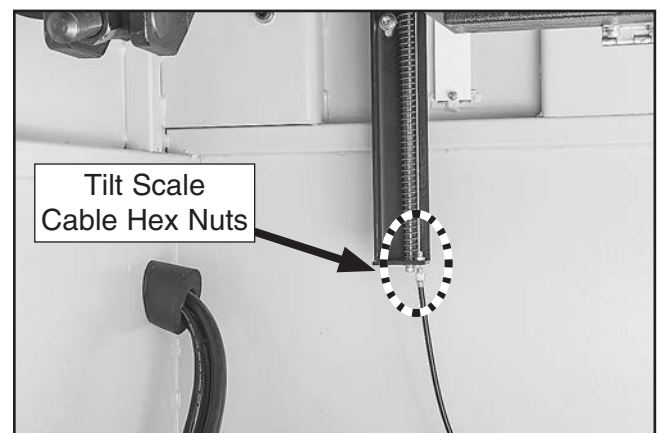


Figure 156. Tilt scale cable hex nuts.



Sliding Table Parallel Adjustment

The sliding table is adjusted parallel with the main blade at the factory, but it can be re-adjusted if necessary.

| Tools Needed | Qty |
|-----------------------------------|-------|
| Felt Tip Pen | 1 |
| 90° Square | 1 |
| Precision Ruler 6"+..... | 1 |
| Wrenches or Sockets 17, 19mm..... | 1 Ea. |

To adjust sliding table parallel with main blade:

1. DISCONNECT MACHINE FROM POWER!
2. Raise main blade all the way up and adjust tilt angle to 0° (verify with square).
3. Mark one blade tooth with felt tip pen. This will be your reference point when taking measurements in following steps.
4. Move sliding table all the way forward, and measure distance **A** shown in **Figure 157**, which is between marked blade tooth and edge of sliding table miter slot.

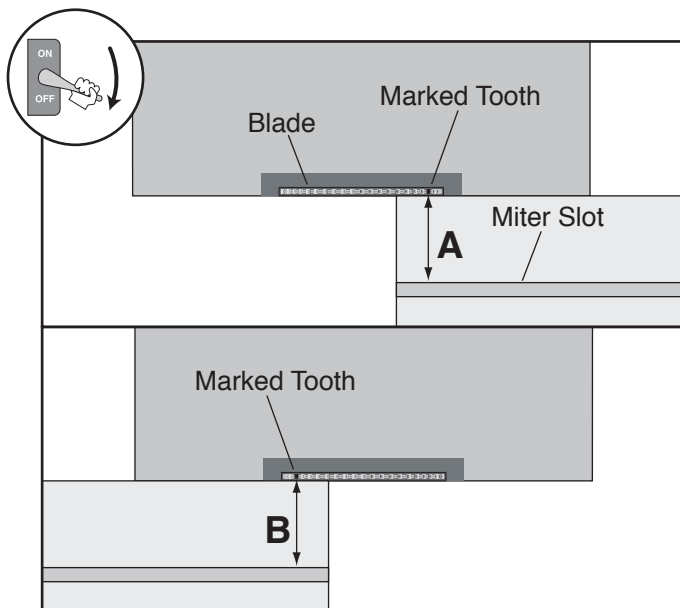


Figure 157. Measuring distance between miter slot and blade at each end of sliding table.

5. Rotate blade 180°, move sliding table all the way back, then measure distance **B** shown in **Figure 157**.

— If **A** and **B** measurements *are* the same, or difference is *less* than 0.004", no adjustments are required.

— If **A** and **B** measurements *are not* the same, or difference is *greater* than 0.004", sliding table parallelism must be adjusted. Proceed to **Step 6**.

6. Loosen (2) hex nuts on sliding table T-bolts, then loosen hex nuts on adjustment bolts (see **Figures 158–159**).

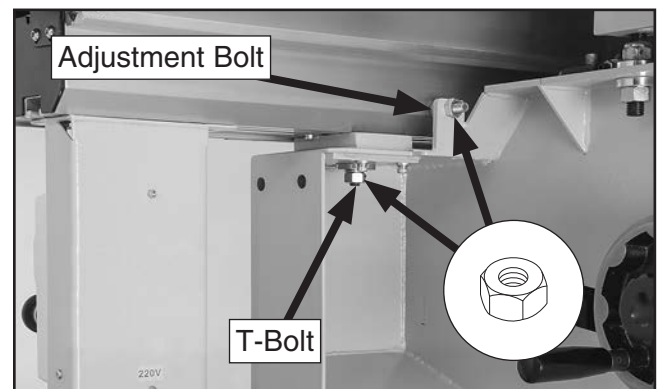


Figure 158. Front parallelism adjustment bolt and T-bolt.

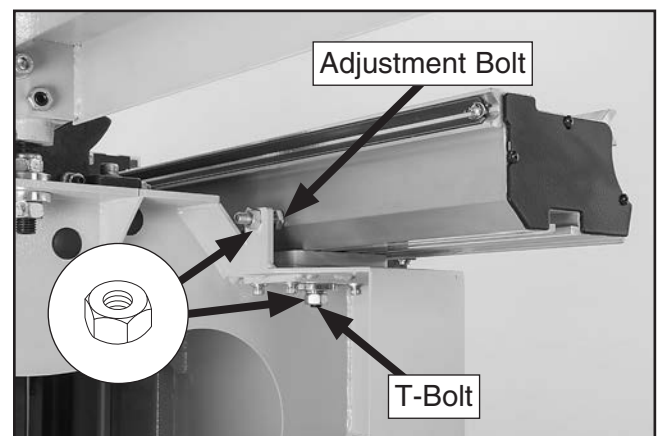


Figure 159. Rear parallelism adjustment bolt and T-bolt.

7. Turn adjustment bolt under each end of sliding table to make sliding table parallel with main blade.
8. Once sliding table parallelism is within 0.004" from one end to the other, tighten hex nuts.



Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a 32" x 32" piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

Note: Getting accurate results with this procedure is a matter of trial-and-error and patience.

To square crosscut fence with blade:

1. Make sure sliding table is parallel with main blade (see **Sliding Table Parallel Adjustment** on **Page 76**).
2. Loosen 0° stop block knob bolt and loosen angle scale knob bolt to allow fence to pivot (see **Figure 160**).



Figure 160. Locations of knob bolts securing crosscut fence.

3. Move crosscut fence stop block against 0° stop bolt, then tighten angle scale knob bolt to secure fence in place (see **Figure 161**).

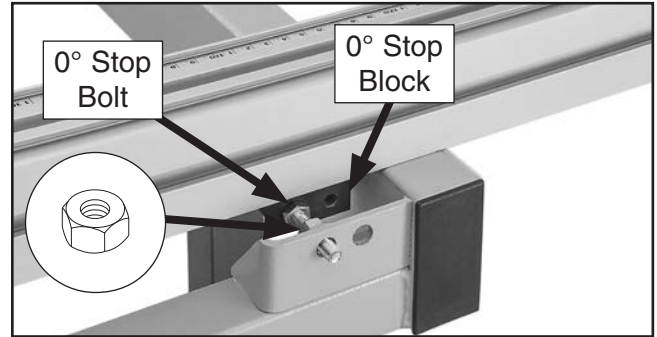


Figure 161. Stop block against 0° stop bolt.

4. Prepare scrap test piece by cutting it to 32" x 32" square, then number all four sides 1–4 (see **Figure 162**).

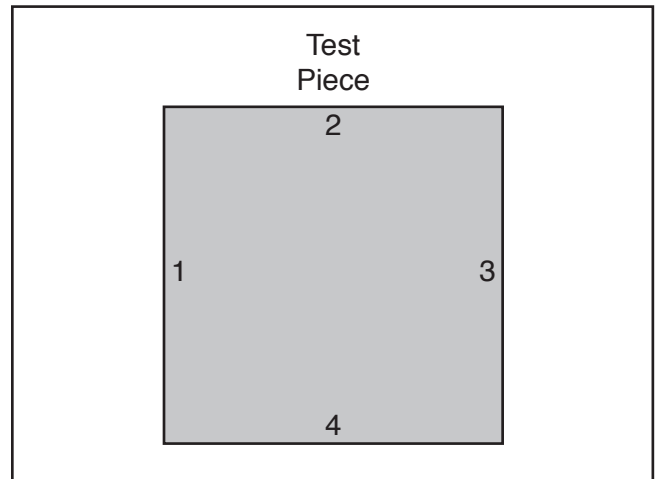


Figure 162. Fence adjustment test piece.

5. Use crosscut fence to cut 1/2" off of each side of test piece, then cut side 1 again (make five cuts total).



6. Measure test piece diagonally from corner-to-corner, as shown in **Figure 163**.
 - If both measurements *are* within $\frac{1}{16}$ ", no adjustment is required.
 - If both measurements *are not* within $\frac{1}{16}$ ", crosscut fence needs to be adjusted. Proceed to **Step 7**.

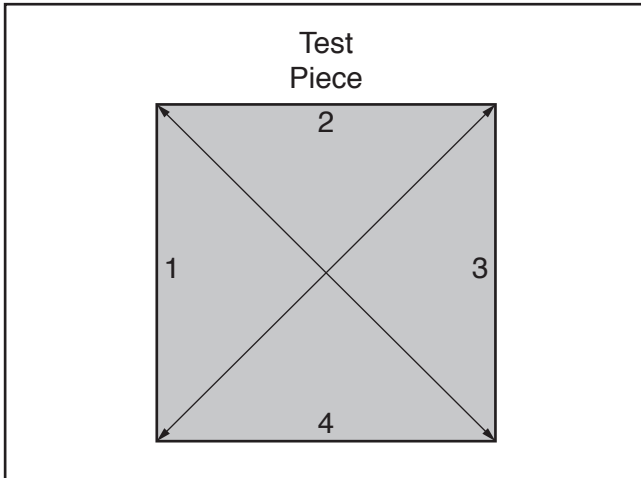


Figure 163. Diagonals to measure on test piece.

7. Loosen angle scale knob bolt to allow fence to pivot (see **Figure 160** on **Page 77**).
8. Loosen hex nut on 0° stop bolt (see **Figure 161**), rotate 0° stop bolt to square crosscut fence, then tighten hex nut.
9. Move crosscut fence stop block against 0° stop bolt, then tighten angle scale knob bolt to secure fence in place.
10. Repeat **Steps 5–6** until both measurements are within $\frac{1}{16}$ ".

Riving Knife Mounting Block

The riving knife and splitter/riving knife must be aligned with the blade when installed. If either one is not aligned with the blade, then the workpiece will be forced sideways during the cut, which will increase the risk of kickback.

The riving knife and splitter/riving knife mount to a block that can be repositioned to correctly align the riving knife or splitter/riving knife to the blade. The mounting block adjusts by turning the set screws in each corner of the block. **Figure 164** shows the set screws associated with controlling the mounting block position. Have patience when adjusting the mounting block, because it requires trial-and-error to perform with accuracy.

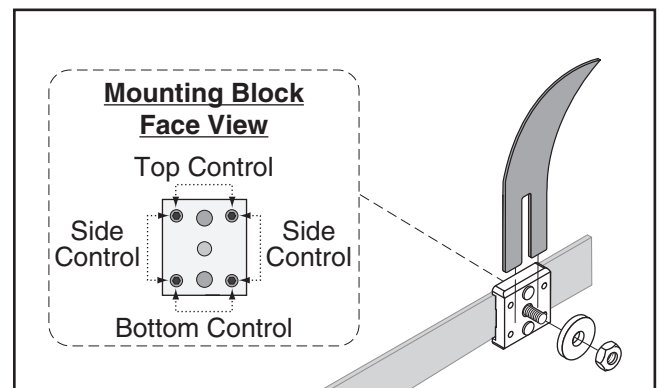


Figure 164. Riving knife and splitter/riving knife mounting block adjustment controls.

All adjustment and alignment positions for the riving knife and splitter/riving knife are covered on **Page 43** in the subsection **Riving Knife Installation & Removal**, and on **Page 41** in the subsection **Splitter/Riving Knife Installation & Removal**. The mounting block should not be adjusted unless you have been unable to mount the riving knife or splitter/riving knife as instructed in these procedures.

| Tools Needed | Qty |
|----------------------------|------------|
| Straightedge | 1 |
| Open-End Wrench 17mm | 1 |
| Hex Wrench 2.5mm..... | 1 |



To adjust riving knife mounting block:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust blade tilt to 0° and raise main blade all the way up.
3. Move sliding table all the way right to expose blade cover.
4. Open blade cover to gain access to riving knife mounting block (see **Figure 165**).
5. Loosen hex nut securing riving knife to mounting block, then remove riving knife or splitter/riving knife (see **Figure 165**).

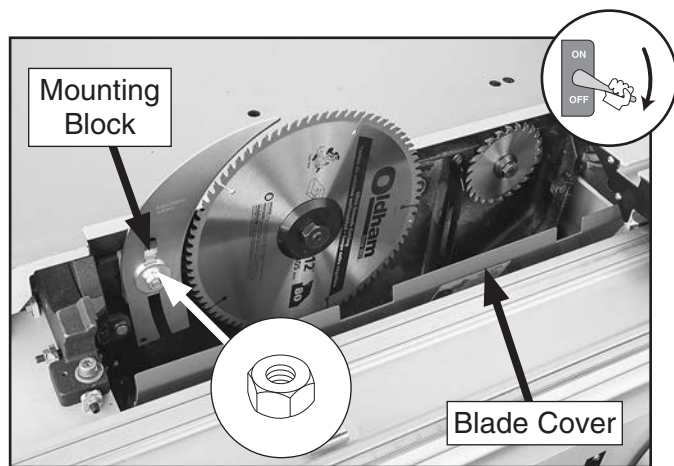


Figure 165. Blade cover open.

6. Adjust each pair of set screws in **Figure 164** to move mounting block so riving knife can be aligned with blade. Make sure to adjust both set screws evenly.
7. Re-install riving knife and check alignment with blade. Repeat **Step 6** as necessary until riving knife is properly aligned with blade.

Note: If you discover riving knife is bent and cannot be properly aligned with blade, it is possible to bend it into alignment, but make sure final result is precisely aligned so risk of kickback is not increased. If riving knife is bent, and you cannot easily bend it back into alignment, we recommend replacing it with a new one.

8. Properly re-install riving knife as instructed on **Page 43**, close blade cover, then move sliding table back to center position.

Calibrating Rip Fence

There are three adjustments that affect the accuracy and operation of the rip fence: 1) Height above the table, 2) parallelism with the blade, and 3) rip fence scale position. If cuts are not square when using the rip fence, check these adjustments. Parallelism is an important safety adjustment and the rip fence **MUST** be parallel with blade to minimize the risk of kickback.

Height Above Table

The rip fence and base should ride as close to the table surface as possible without touching, and with an even gap along the length. This is accomplished by adjusting the rip fence rail and the roller at the end of the fence base.

Tools Needed

| | Qty |
|-----------------------------|-------|
| Hex Wrenches 6, 8mm..... | 1 Ea. |
| Open-End Wrenches 13mm..... | 2 |
| Open-End Wrench 19mm..... | 1 |

To adjust rip fence height above table:

1. Observe gap between fence base and table along entire length.
 - If rail end of fence body is too low, loosen hex nuts that secure rail, raise rail until fence body gap is even, then re-tighten rail hex nuts.
 - If far end of fence base is too low, loosen fence lock and pivot rip fence base upwards to access wheel underneath (see **Figure 166**). Loosen acorn nut, adjust wheel position, tighten acorn nut, then place rip fence base back on table.

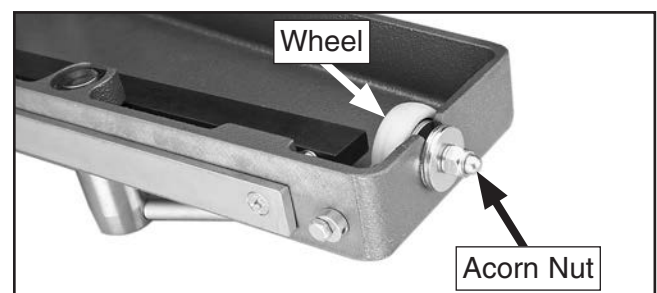


Figure 166. Rip fence base roller controls.



Parallelism To Blade

CAUTION

Parallelism is an important safety adjustment. Rip fence **MUST** be parallel with blade to minimize risk of kickback.

| Tools Needed | Qty |
|---------------------------|-------|
| Open-End Wrench 19mm..... | 1 |
| Hex Wrenches 4, 8mm..... | 1 Ea. |

To adjust rip fence parallel to main blade:

1. DISCONNECT MACHINE FROM POWER!
2. Raise main blade all the way up and tilt to 0°.
3. Remove blade guard cover from splitter/riving knife if installed.
4. Slide rip fence as close to main blade as possible and check remaining gap.

— If gap between rip fence and main blade *is not* even at both ends, loosen rail hex nuts and adjust one end in or out until fence is parallel with blade, then tighten hex nuts.

5. Re-install blade guard cover.

Calibrating Rip Fence Scale

| Tool Needed | Qty |
|--------------------------|-------|
| Hex Wrenches 4, 8mm..... | 1 Ea. |

To calibrate rip fence scale:

1. DISCONNECT MACHINE FROM POWER!
2. Remove blade guard cover from splitter/riving knife if installed.
3. Make sure rip fence is parallel with main blade, then move fence against blade so that it just touches teeth.
4. Observe reading on scale underneath rip fence (see **Figure 167**).

— If scale *is not* at "0", loosen button head cap screws that secure scale to table, then adjust fence until scale indicates "0".

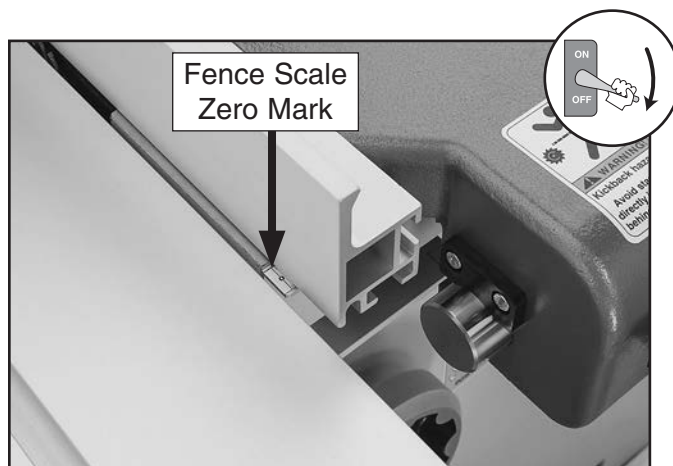


Figure 167. Rip fence scale zero mark.

5. Re-install blade guard cover.



SECTION 9: 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.













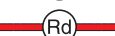

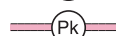
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

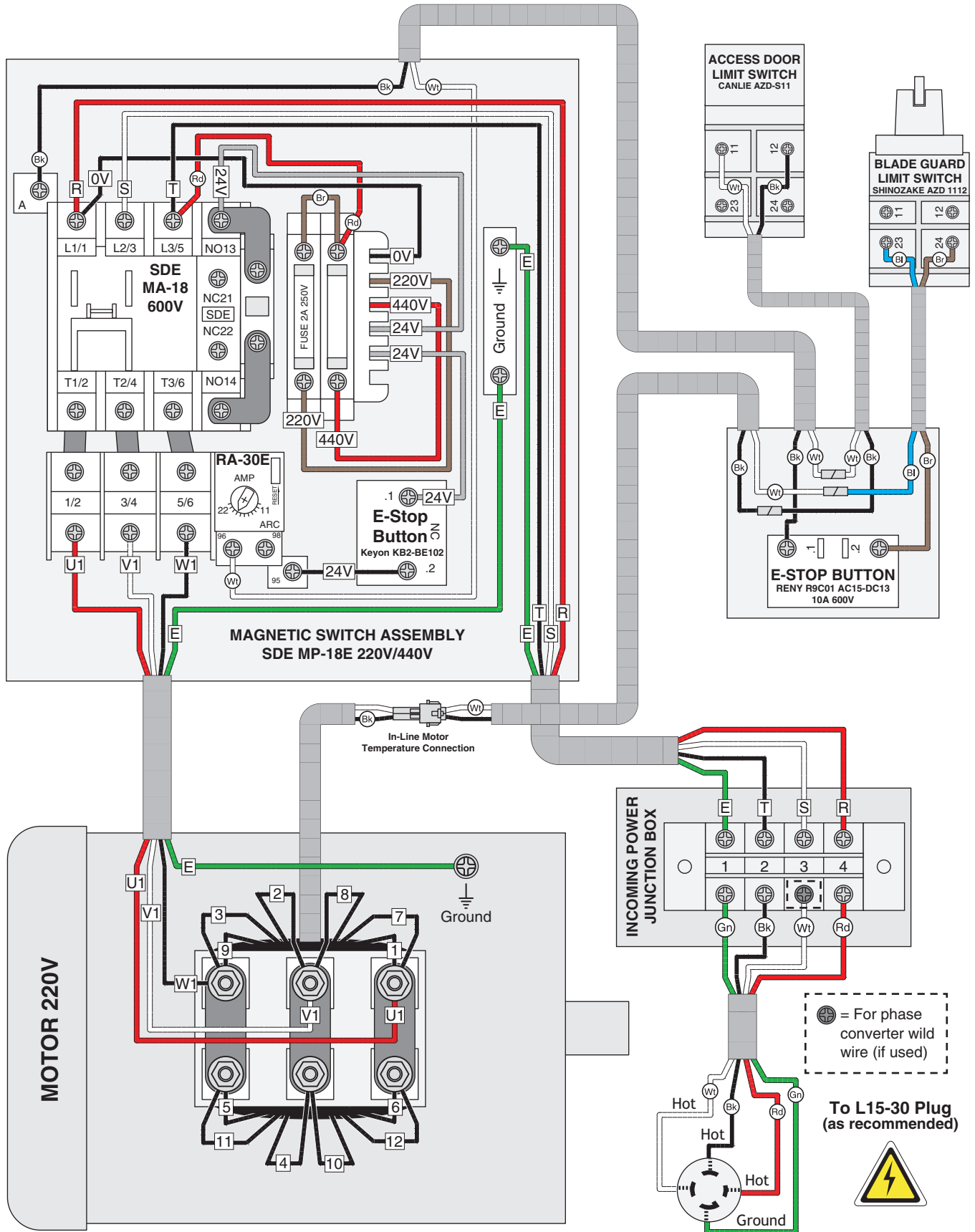
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

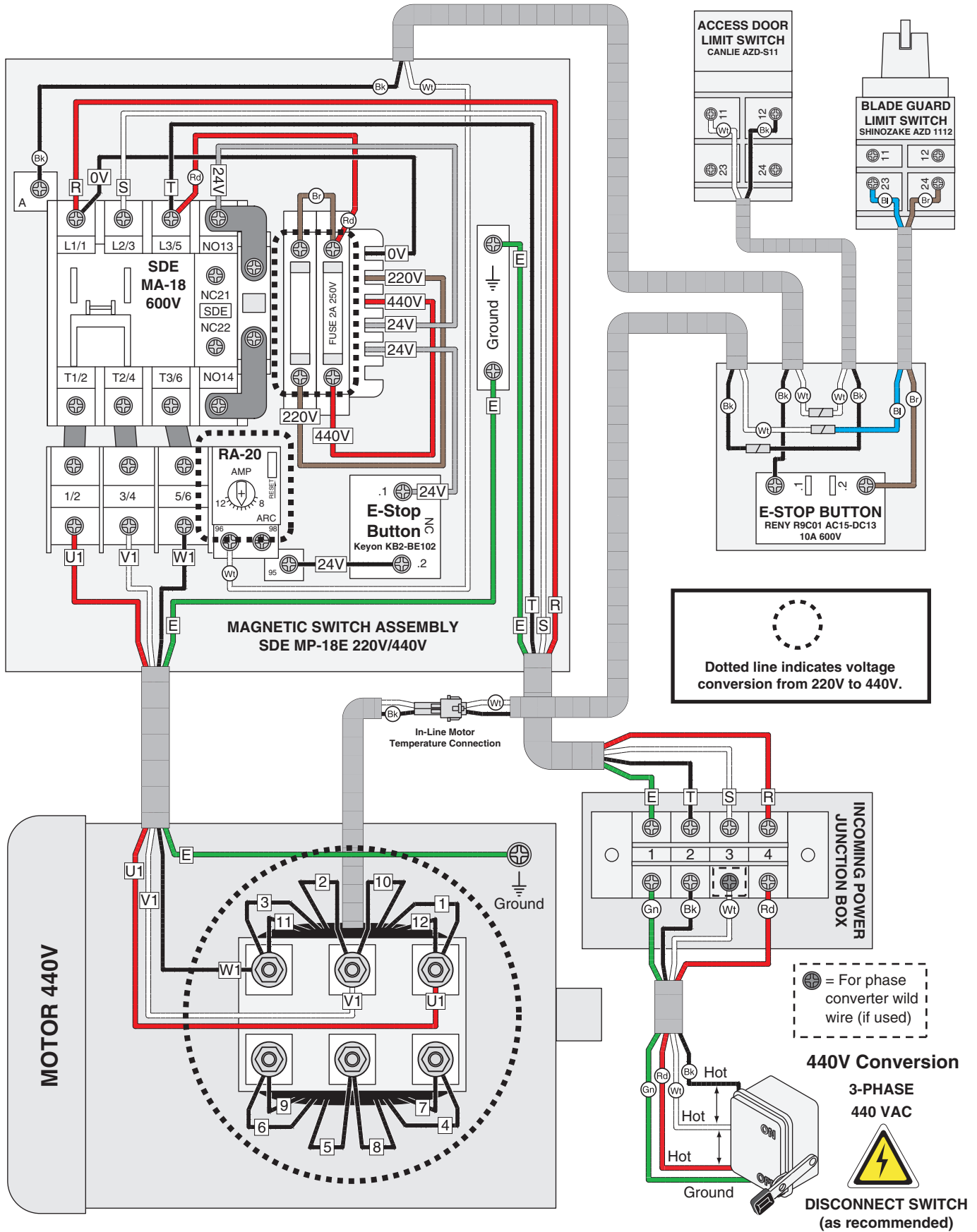
| | | | |
|---|--|--|--|
| BLACK  | BLUE  | YELLOW  | LIGHT BLUE  |
| WHITE  | BROWN  | YELLOW GREEN  | BLUE WHITE  |
| GREEN  | GRAY  | PURPLE  | TURQUOISE  |
| RED  | ORANGE  | PINK  | |



Wiring Diagram 220V



Wiring Diagram 440V



Electrical Components



Figure 168. Motor wiring (220V).



Figure 171. Access door limit switch wiring.



Figure 169. Incoming power wiring connections.

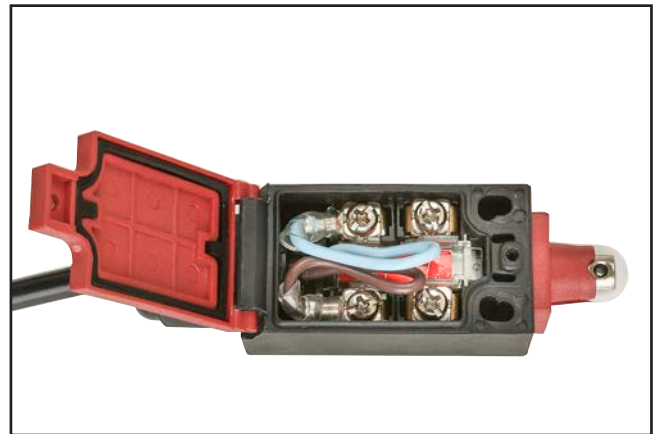


Figure 172. Blade guard limit switch wiring.

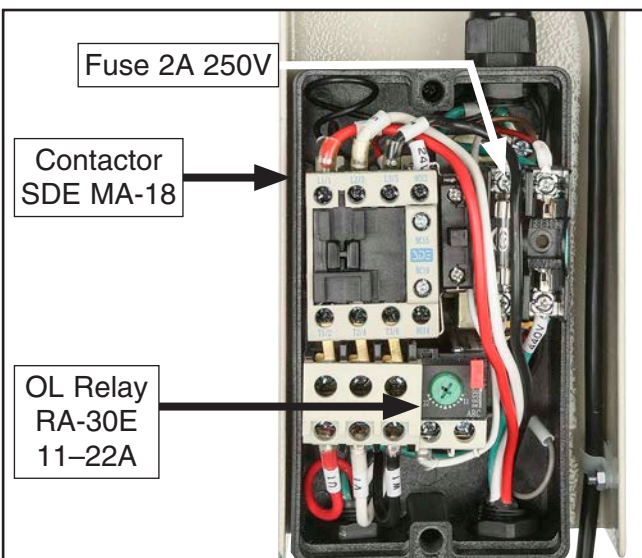


Figure 170. Magnetic switch wiring (220V).

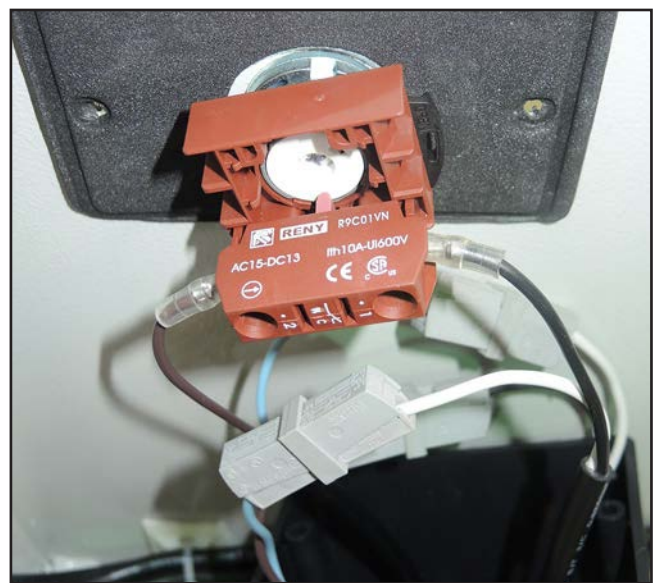


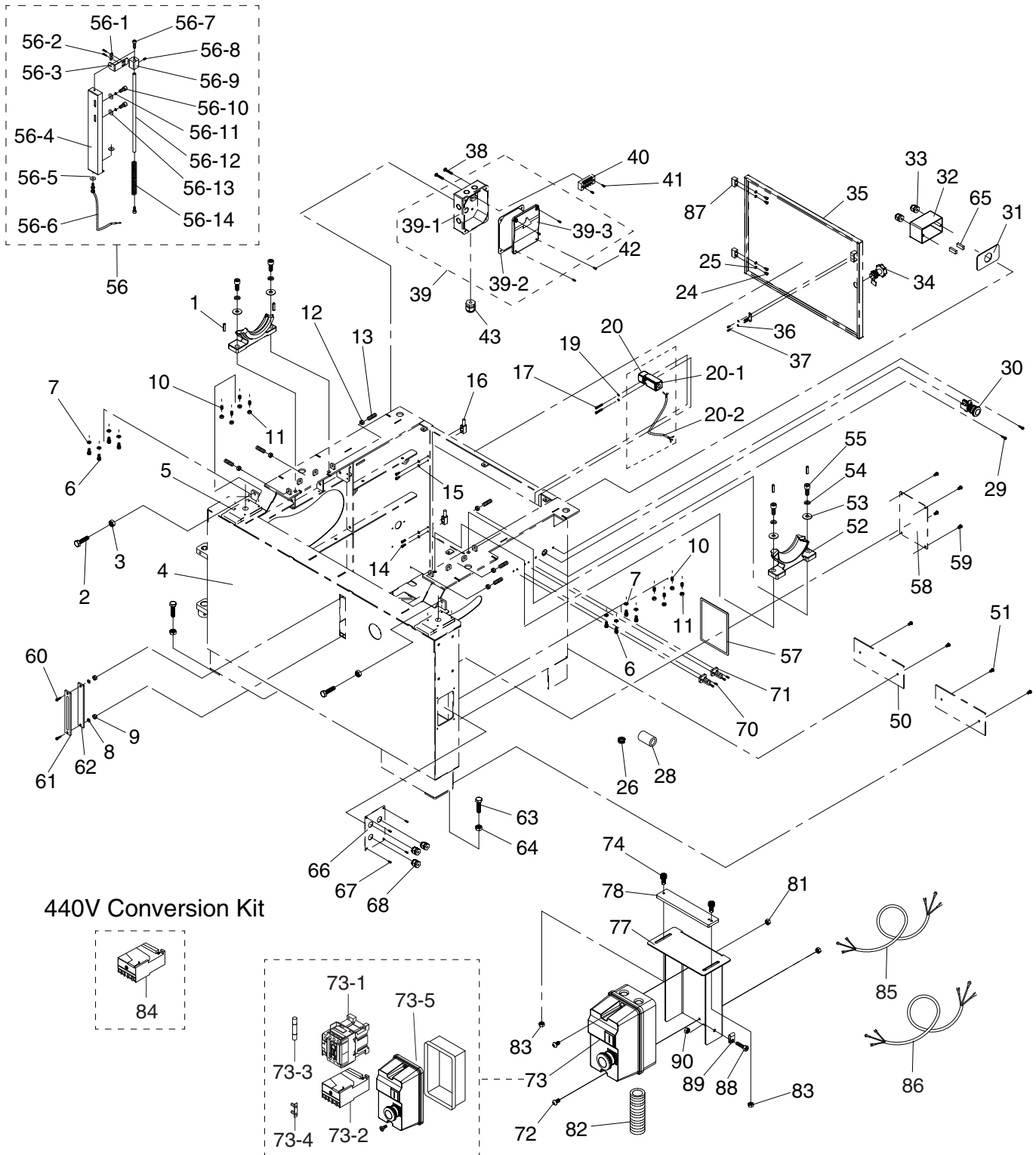
Figure 173. Cabinet E-stop button wiring.



SECTION 10: PARTS

We do our best to stock replacement parts when possible, but we cannot guarantee that all parts shown are available for purchase. Call (800) 523-4777 or visit www.grizzly.com/parts to check for availability.

Body



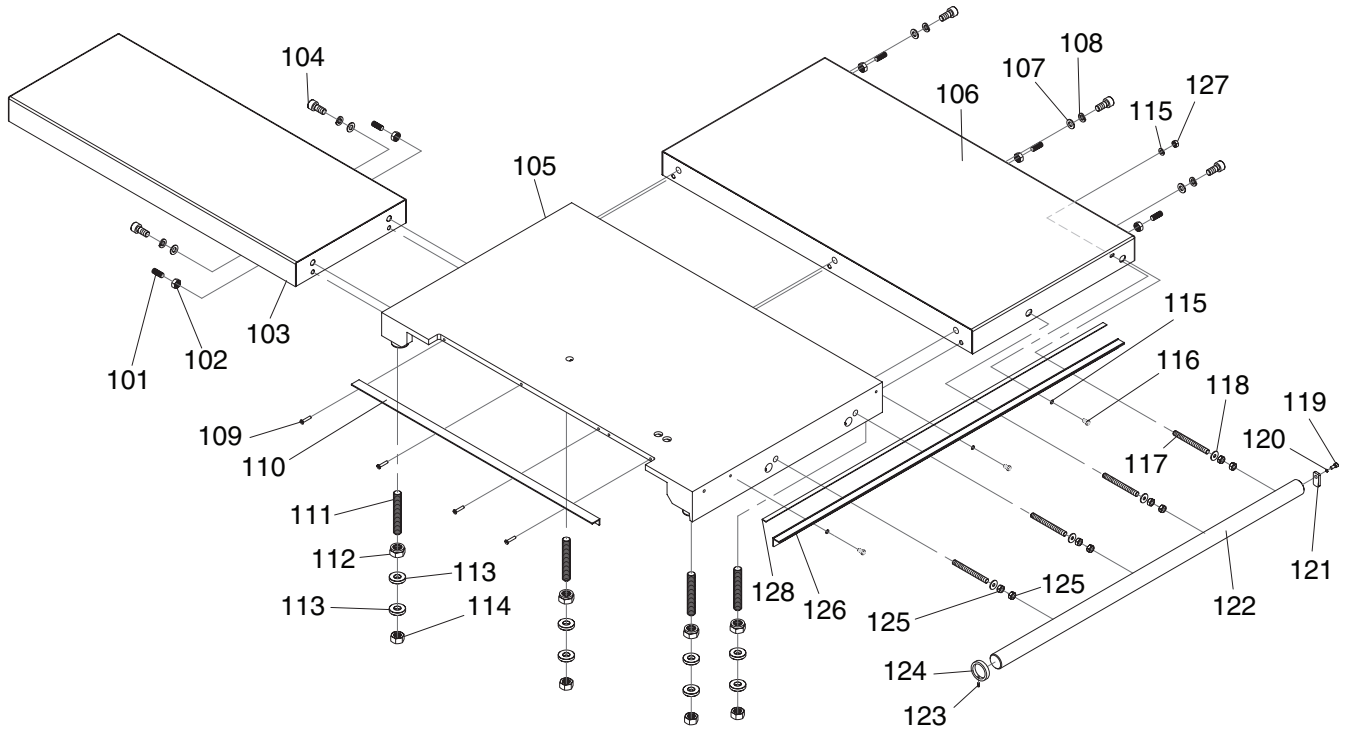
Body Parts List

| REF | PART # | DESCRIPTION |
|------|-------------|------------------------------|
| 1 | P08200001 | ROLL PIN 6 X 25 |
| 2 | P08200002 | HEX BOLT M10-1.5 X 40 |
| 3 | P08200003 | HEX NUT M10-1.5 |
| 4 | P08200004 | SAW BODY |
| 5 | P08200005 | TABLE PLATE |
| 6 | P08200006 | CAP SCREW M6-1 X 12 |
| 7 | P08200007 | LOCK WASHER 6MM |
| 8 | P08200008 | FLAT WASHER 4MM |
| 9 | P08200009 | HEX NUT M4-.7 |
| 10 | P08200010 | SET SCREW M6-1 X 20 |
| 11 | P08200011 | HEX NUT M6-1 |
| 12 | P08200012 | HEX NUT M8-1.25 |
| 13 | P08200013 | SET SCREW M8-1.25 X 25 |
| 14 | P08200014 | CAP SCREW M5-.8 X 6 |
| 15 | P08200015 | LOCK WASHER 5MM |
| 16 | P08200016 | HINGE POST |
| 17 | P08200017 | PHLP HD SCR M4-.7 X 30 |
| 19 | P08200019 | FLAT WASHER 4MM |
| 20 | P08200020 | LIMIT SWITCH ASSEMBLY |
| 20-1 | P08200020-1 | LIMIT SWITCH AZD-S11 |
| 20-2 | P08200020-2 | SWITCH CORD 18G X 2W X 16" |
| 24 | P08200024 | CAP SCREW M5-.8 X 8 |
| 25 | P08200025 | LOCK WASHER 5MM |
| 26 | P08200026 | HOLE CAP 22MM |
| 28 | P08200028 | SPONGE SEAL 5 X 20 |
| 29 | P08200029 | TAP SCREW M5 X 20 |
| 30 | P08200030 | E-STOP BUTTON RENY R9C01VN |
| 31 | P08200031 | SWITCH BOX MOUNTING PAD |
| 32 | P08200032 | SWITCH BOX |
| 33 | P08200033 | STRAIN RELIEF PG13 TYPE-1 |
| 34 | P08200034 | ACCESS DOOR LATCH |
| 35 | P08200035 | ACCESS DOOR |
| 36 | P08200036 | LOCK WASHER 4MM |
| 37 | P08200037 | PHLP HD SCR M4-.7 X 25 |
| 38 | P08200038 | BUTTON HD CAP SCR M6-1 X 20 |
| 39 | P08200039 | JUNCTION BOX ASSEMBLY |
| 39-1 | P08200039-1 | JUNCTION BOX |
| 39-2 | P08200039-2 | COVER SEAL |
| 39-3 | P08200039-3 | JUNCTION BOX COVER |
| 40 | P08200040 | TERMINAL 4P |
| 41 | P08200041 | PHLP HD SCR M5-.8 X 8 |
| 42 | P08200042 | BUTTON HD CAP SCR M5-.8 X 12 |
| 43 | P08200043 | STRAIN RELIEF PG20 TYPE-3 |
| 50 | P08200050 | SKID PLATE |
| 51 | P08200051 | PHLP HD SCR M6-1 X 10 |
| 52 | P08200052 | TRUNNION BASE |
| 53 | P08200053 | FLAT WASHER 10MM |
| 54 | P08200054 | LOCK WASHER 10MM |
| 55 | P08200055 | CAP SCREW M10-1.5 X 35 |

| REF | PART # | DESCRIPTION |
|-------|--------------|---|
| 56 | P08200056 | TILT INDICATOR ASSEMBLY |
| 56-1 | P08200056-1 | FLAT WASHER 5MM |
| 56-2 | P08200056-2 | PHLP HD SCR M5-.8 X 10 |
| 56-3 | P08200056-3 | POINTER |
| 56-4 | P08200056-4 | SUPPORT PLATE |
| 56-5 | P08200056-5 | FLAT WASHER 6MM |
| 56-6 | P08200056-6 | STEEL WIRE |
| 56-7 | P08200056-7 | CAP SCREW M5-.8 X 10 |
| 56-8 | P08200056-8 | SET SCREW M5-.8 X 10 |
| 56-9 | P08200056-9 | POINTER MOUNT BLOCK |
| 56-10 | P08200056-10 | CAP SCREW M6-1 X 12 |
| 56-11 | P08200056-11 | LOCK WASHER 6MM |
| 56-12 | P08200056-12 | SHAFT |
| 56-13 | P08200056-13 | FLAT WASHER 6MM |
| 56-14 | P08200056-14 | COMPRESSION SPRING 10-1/2" X 3/4" |
| 57 | P08200057 | COVER SEAL |
| 58 | P08200058 | COVER PLATE |
| 59 | P08200059 | BUTTON HD CAP SCR M6-1 X 12 |
| 60 | P08200060 | PHLP HD SCR M4-.7 X 20 |
| 61 | P08200061 | TILT SCALE COVER |
| 62 | P08200062 | TILT SCALE |
| 63 | P08200063 | HEX BOLT M16-2 X 50 |
| 64 | P08200064 | HEX NUT M16-2 |
| 65 | P08200065 | TERMINAL 4P |
| 66 | P08200066 | STRAIN RELIEF PLATE |
| 67 | P08200067 | BUTTON HD CAP SCR M6-1 X 12 |
| 68 | P08200068 | STRAIN RELIEF PG20 TYPE-3 |
| 70 | P08200070 | TAP SCREW M4 X 10 |
| 71 | P08200071 | HANGER HOOK |
| 72 | P08200072 | PHLP HD SCR M4-.7 X 12 |
| 73 | P08200073 | MAG SWITCH ASSY SDE MP-18E |
| 73-1 | P08200073-1 | CONTACTOR SDE MA-18 600V |
| 73-2 | P08200073-2 | OL RELAY SDE RA-30E 11-22A |
| 73-3 | P08200073-3 | FUSE 2A 250V 0.25" FAST-ACTING, GLASS |
| 73-4 | P08200073-4 | GROUND TERMINAL BLOCK 2-POSITION |
| 73-5 | P08200073-5 | SWITCH BOX |
| 74 | P08200074 | CAP SCREW M5-.8 X 25 |
| 77 | P08200077 | SWITCH MOUNTING PLATE |
| 78 | P08200078 | MOUNTING PLATE SPACER |
| 81 | P08200081 | HEX NUT M4-.7 |
| 82 | P08200082 | FLEXIBLE CONDUIT NFE-08B (PLASTIC) |
| 83 | P08200083 | HEX NUT M5-.8 |
| 84 | P08200084 | 440V CONVERSION, OL RELAY SDE RA-20 8-12A |
| 85 | P08200085 | E-STOP CORD 18AWG 2W X 96" |
| 86 | P08200086 | POWER CORD 12AWG 4W X 96" |
| 87 | P08200087 | HINGE RECEIVER |
| 88 | P08200088 | HEX BOLT M5-.8 X 12 |
| 89 | P08200089 | WIRE LOOP CLAMP |
| 90 | P08200090 | HEX NUT M5-.8 |



Main Tables

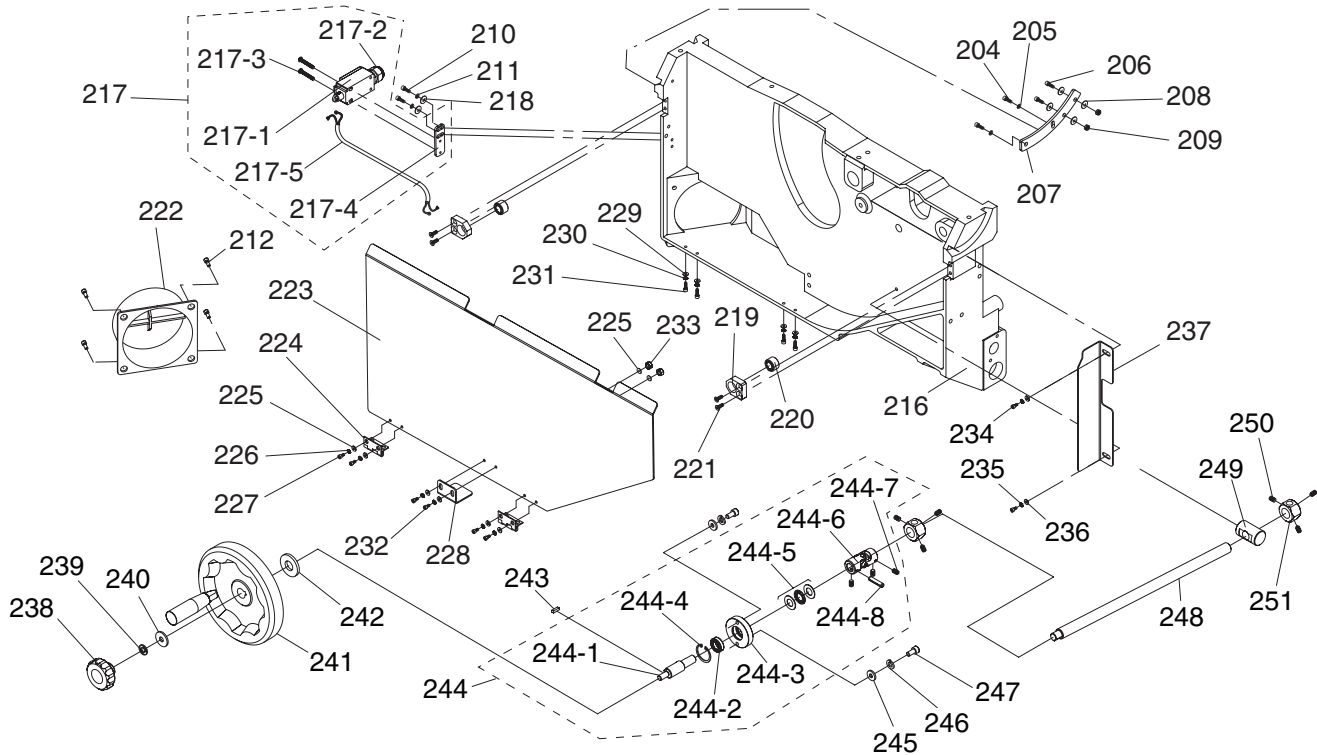


| REF | PART # | DESCRIPTION |
|-----|-----------|-----------------------------|
| 101 | P08200101 | SET SCREW M10-1.5 X 20 |
| 102 | P08200102 | HEX NUT M10-1.5 |
| 103 | P08200103 | EXTENSION WING (LEFT) |
| 104 | P08200104 | CAP SCREW M10-1.5 X 25 |
| 105 | P08200105 | MAIN TABLE |
| 106 | P08200106 | EXTENSION WING (RIGHT) |
| 107 | P08200107 | FLAT WASHER 10MM |
| 108 | P08200108 | LOCK WASHER 10MM |
| 109 | P08200109 | BUTTON HD CAP SCR M6-1 X 12 |
| 110 | P08200110 | TABLE INSERT |
| 111 | P08200111 | SET SCREW M16-2 X 100 |
| 112 | P08200112 | LOCK NUT M16-2 |
| 113 | P08200113 | FLAT WASHER 16MM |
| 114 | P08200114 | HEX NUT M16-2 |

| REF | PART # | DESCRIPTION |
|-----|-----------|-----------------------------|
| 115 | P08200115 | FLAT WASHER 6MM |
| 116 | P08200116 | BUTTON HD CAP SCR M6-1 X 12 |
| 117 | P08200117 | STUD-FT M12-1.75 X 115 |
| 118 | P08200118 | FLAT WASHER 12MM |
| 119 | P08200119 | CAP SCREW M8-1.25 X 16 |
| 120 | P08200120 | LOCK WASHER 8MM |
| 121 | P08200121 | RIP FENCE END STOP |
| 122 | P08200122 | ROUND RAIL |
| 123 | P08200123 | SET SCREW M6-1 X 10 |
| 124 | P08200124 | RIP FENCE STOP RING |
| 125 | P08200125 | HEX NUT M12-1.75 |
| 126 | P08200126 | RIP FENCE SCALE PLATE |
| 127 | P08200127 | HEX NUT M6-1 |
| 128 | P08200128 | RIP FENCE SCALE |



Blade Enclosure

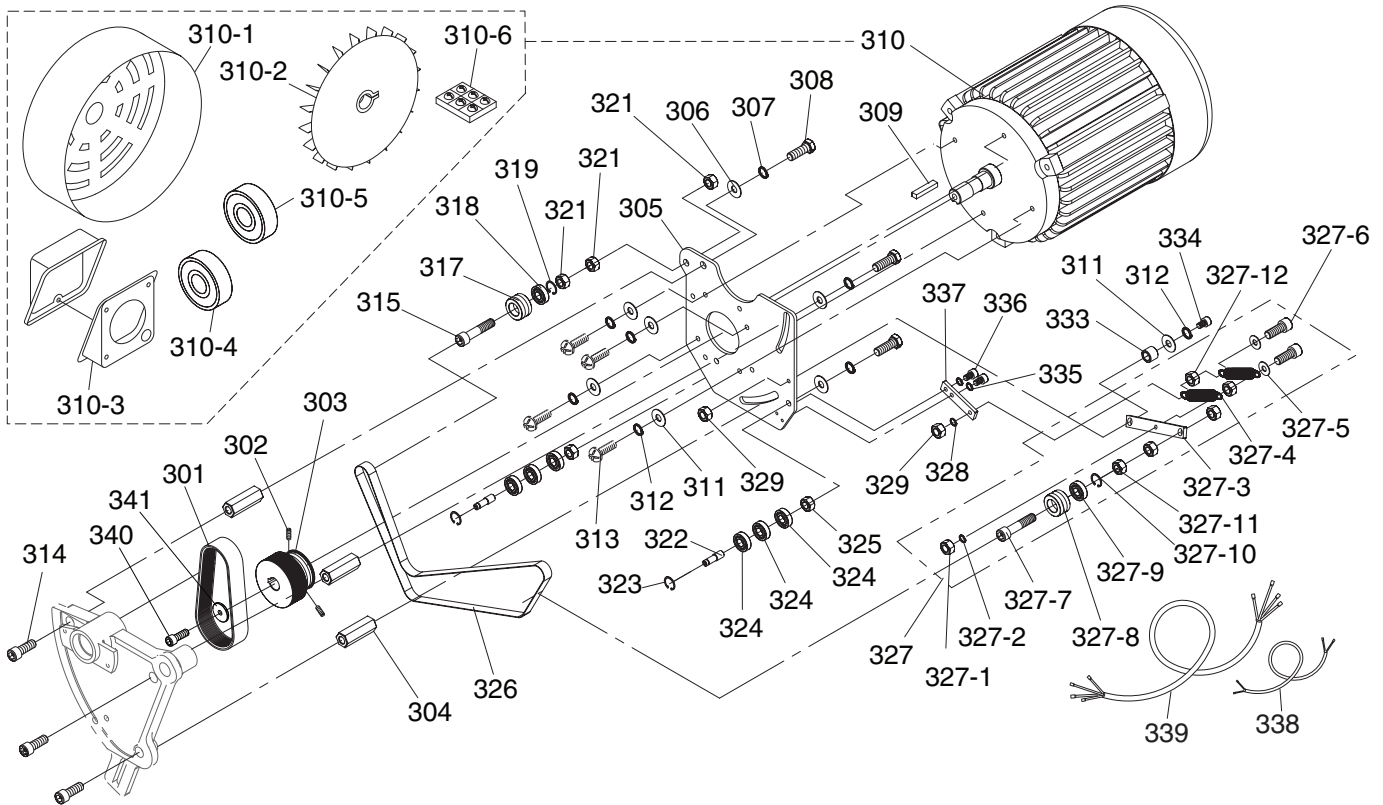


| REF | PART # | DESCRIPTION |
|-------|-------------|-----------------------------|
| 204 | P08200204 | CAP SCREW M6-1 X 12 |
| 205 | P08200205 | LOCK WASHER 6MM |
| 206 | P08200206 | CAP SCREW M5-.8 X 16 |
| 207 | P08200207 | HOUSING ANGLE PLATE |
| 208 | P08200208 | FLAT WASHER 5MM |
| 209 | P08200209 | LOCK NUT M5-.8 |
| 210 | P08200210 | CAP SCREW M5-.8 X 12 |
| 211 | P08200211 | LOCK WASHER 5MM |
| 212 | P08200212 | HEX BOLT M8-1.25 X 12 |
| 216 | P08200216 | BLADE ENCLOSURE |
| 217 | P08200217 | LIMIT SWITCH ASSY |
| 217-1 | P08200217-1 | LIMIT SWITCH AZD-S11 |
| 217-2 | P08200217-2 | STRAIN RELIEF PG11 TYPE-3 |
| 217-3 | P08200217-3 | PHLP HD SCR M4-.7 X 35 |
| 217-4 | P08200217-4 | LIMIT SWITCH MOUNTING PLATE |
| 217-5 | P08200217-5 | CORD 18AWG 2W X 72" |
| 218 | P08200218 | FLAT WASHER 5MM |
| 219 | P08200219 | MAGNET MOUNTING BRACKET |
| 220 | P08200220 | MAGNET |
| 221 | P08200221 | FLAT HD CAP SCR M6-1 X 20 |
| 222 | P08200222 | DUST PORT 5" |
| 223 | P08200223 | BLADE ENCLOSURE COVER |
| 224 | P08200224 | ENCLOSURE HINGE |
| 225 | P08200225 | FLAT WASHER 5MM |
| 226 | P08200226 | LOCK WASHER 5MM |
| 227 | P08200227 | CAP SCREW M5-.8 X 8 |
| 228 | P08200228 | COVER SUPPORT BRACKET |
| 229 | P08200229 | FLAT WASHER 5MM |
| 230 | P08200230 | LOCK WASHER 5MM |

| REF | PART # | DESCRIPTION |
|-------|-------------|--------------------------------|
| 231 | P08200231 | CAP SCREW M5-.8 X 10 |
| 232 | P08200232 | CAP SCREW M5-.8 X 16 |
| 233 | P08200233 | HEX NUT M5-.8 |
| 234 | P08200234 | CAP SCREW M6-1 X 10 |
| 235 | P08200235 | LOCK WASHER 6MM |
| 236 | P08200236 | FLAT WASHER 6MM |
| 237 | P08200237 | ENCLOSURE END PLATE |
| 238 | P08200238 | KNOB 12-LOBE M10-1.25 |
| 239 | P08200239 | LOCK WASHER 10MM |
| 240 | P08200240 | FLAT WASHER 10MM |
| 241 | P08200241 | HANDWHEEL TYPE-11 200D X 16B-K |
| 242 | P08200242 | SPACER |
| 243 | P08200243 | KEY 7 X 7 X 20 |
| 244 | P08200244 | HANDWHEEL SHAFT ASSY |
| 244-1 | P08200244-1 | HANDWHEEL SHAFT |
| 244-2 | P08200244-2 | BALL BEARING 6902-2RS |
| 244-3 | P08200244-3 | SHAFT MOUNTING RING |
| 244-4 | P08200244-4 | EXT RETAINING RING 28MM |
| 244-5 | P08200244-5 | THRUST BEARING NTB1528+AS |
| 244-6 | P08200244-6 | U-JOINT 14MM PIN-AND-BLOCK |
| 244-7 | P08200244-7 | SET SCREW M6-1 X 6 |
| 244-8 | P08200244-8 | ROLL PIN 6 X 26MM |
| 245 | P08200245 | FLAT WASHER 8MM |
| 246 | P08200246 | LOCK WASHER 8MM |
| 247 | P08200247 | CAP SCREW M8-1.25 X 20 |
| 248 | P08200248 | STUD-SE M20-2.5 X 415 |
| 249 | P08200249 | PIVOT COUPLER |
| 250 | P08200250 | SET SCREW M6-1 X 6 |
| 251 | P08200251 | SET NUT M20-2.5 |



Main Motor

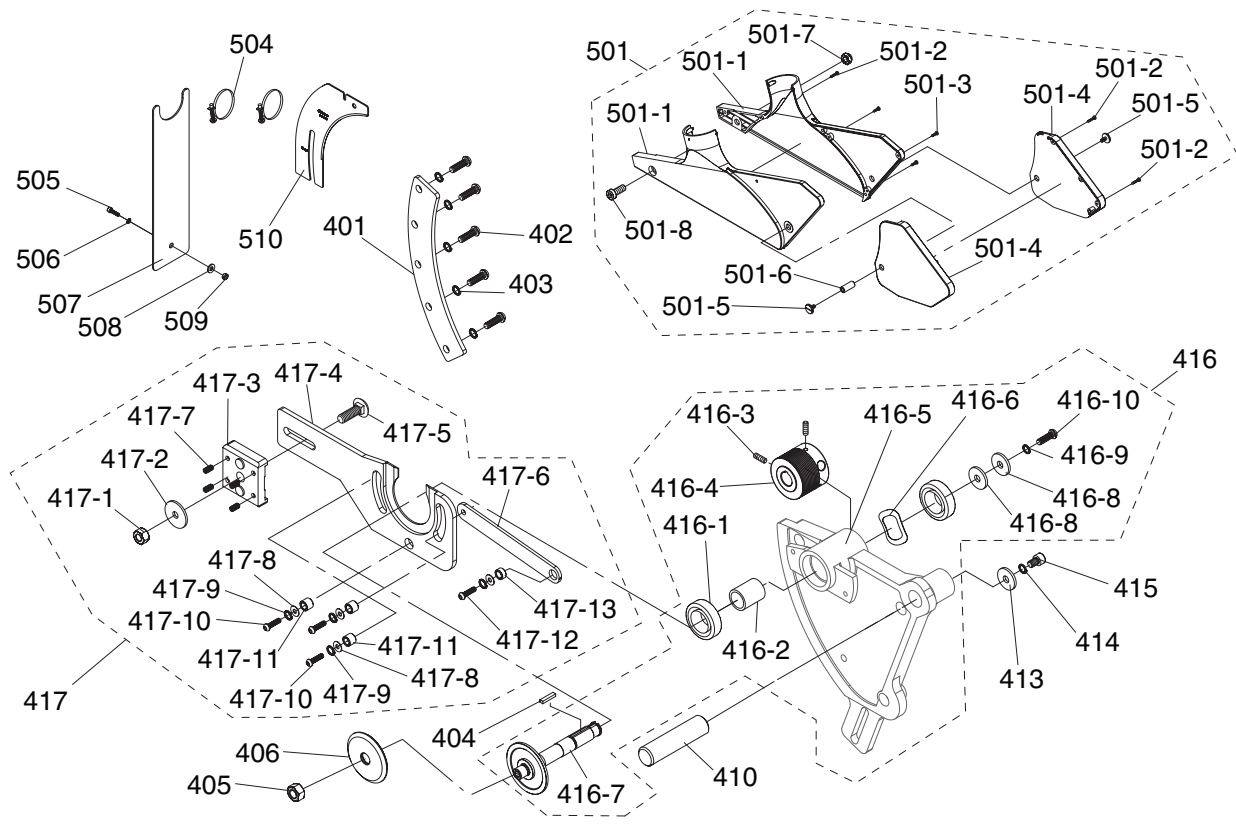


| REF | PART # | DESCRIPTION |
|-------|-------------|-----------------------------|
| 301 | P08200301 | V-BELT 180PJ13 RIBBED |
| 302 | P08200302 | SET SCREW M6-1 X 8 |
| 303 | P08200303 | DUAL PULLEY |
| 304 | P08200304 | HEX SHAFT SPACER |
| 305 | P08200305 | MOTOR MOUNTING PLATE |
| 306 | P08200306 | FLAT WASHER 12MM |
| 307 | P08200307 | LOCK WASHER 12MM |
| 308 | P08200308 | HEX BOLT M12-1.75 X 35 |
| 309 | P08200309 | KEY 8 X 7 X 40 |
| 310 | P08200310 | MOTOR 7.5 HP 220V/440V 3-PH |
| 310-1 | P08200310-1 | MOTOR FAN COVER |
| 310-2 | P08200310-2 | MOTOR FAN |
| 310-3 | P08200310-3 | MOTOR JUNCTION BOX |
| 310-4 | P08200310-4 | MOTOR BEARING 6206ZZ |
| 310-5 | P08200310-5 | MOTOR BEARING 6205ZZ |
| 310-6 | P08200310-6 | TERMINAL BAR 3P |
| 311 | P08200311 | FLAT WASHER 8MM |
| 312 | P08200312 | LOCK WASHER 8MM |
| 313 | P08200313 | PHLP HD SCR M8-1.25 X 25 |
| 314 | P08200314 | CAP SCREW M12-1.75 X 30 |
| 315 | P08200315 | CAP SCREW M12-1.75 X 50 |
| 317 | P08200317 | IDLER PULLEY |
| 318 | P08200318 | BALL BEARING 6001-2RS |
| 319 | P08200319 | EXT RETAINING RING 28MM |
| 321 | P08200321 | HEX NUT M12-1.75 |
| 322 | P08200322 | PULLEY BEARING SHAFT |
| 323 | P08200323 | EXT RETAINING RING 10MM |

| REF | PART # | DESCRIPTION |
|--------|--------------|-------------------------------|
| 324 | P08200324 | BALL BEARING 6200-2RS |
| 325 | P08200325 | HEX NUT M12-1.75 |
| 326 | P08200326 | FLAT BELT 15 X 1160 |
| 327 | P08200327 | PULLEY TENSIONER ASSY |
| 327-1 | P08200327-1 | HEX NUT M8-1.25 |
| 327-2 | P08200327-2 | LOCK WASHER 8MM |
| 327-3 | P08200327-3 | TENSIONER PLATE |
| 327-4 | P08200327-4 | EXTENSION SPRING 180 X 16 X 2 |
| 327-5 | P08200327-5 | FLAT WASHER 8MM |
| 327-6 | P08200327-6 | HEX BOLT M8-1.25 X 40 |
| 327-7 | P08200327-7 | CAP SCREW M12-1.75 X 50 |
| 327-8 | P08200327-8 | IDLER PULLEY |
| 327-9 | P08200327-9 | BALL BEARING 6001-2RS |
| 327-10 | P08200327-10 | EXT RETAINING RING 28MM |
| 327-11 | P08200327-11 | HEX NUT M12-1.75 |
| 327-12 | P08200327-12 | HEX NUT M8-1.25 |
| 328 | P08200328 | LOCK WASHER 8MM |
| 329 | P08200329 | HEX NUT M8-1.25 |
| 333 | P08200333 | SPACER |
| 334 | P08200334 | CAP SCREW M8-1.25 X 25 |
| 335 | P08200335 | LOCK WASHER 6MM |
| 336 | P08200336 | CAP SCREW M6-1 X 16 |
| 337 | P08200337 | LOWER TENSIONER PLATE |
| 338 | P08200338 | E-STOP CORD 18AWG 2W X 72" |
| 339 | P08200339 | MOTOR CORD 12AWG 4W X 108" |
| 340 | P08200340 | CAP SCREW M10-1.5 X 20 LH |
| 341 | P08200341 | FLAT WASHER 10MM |



Main Blade Arbor & Dust Hood



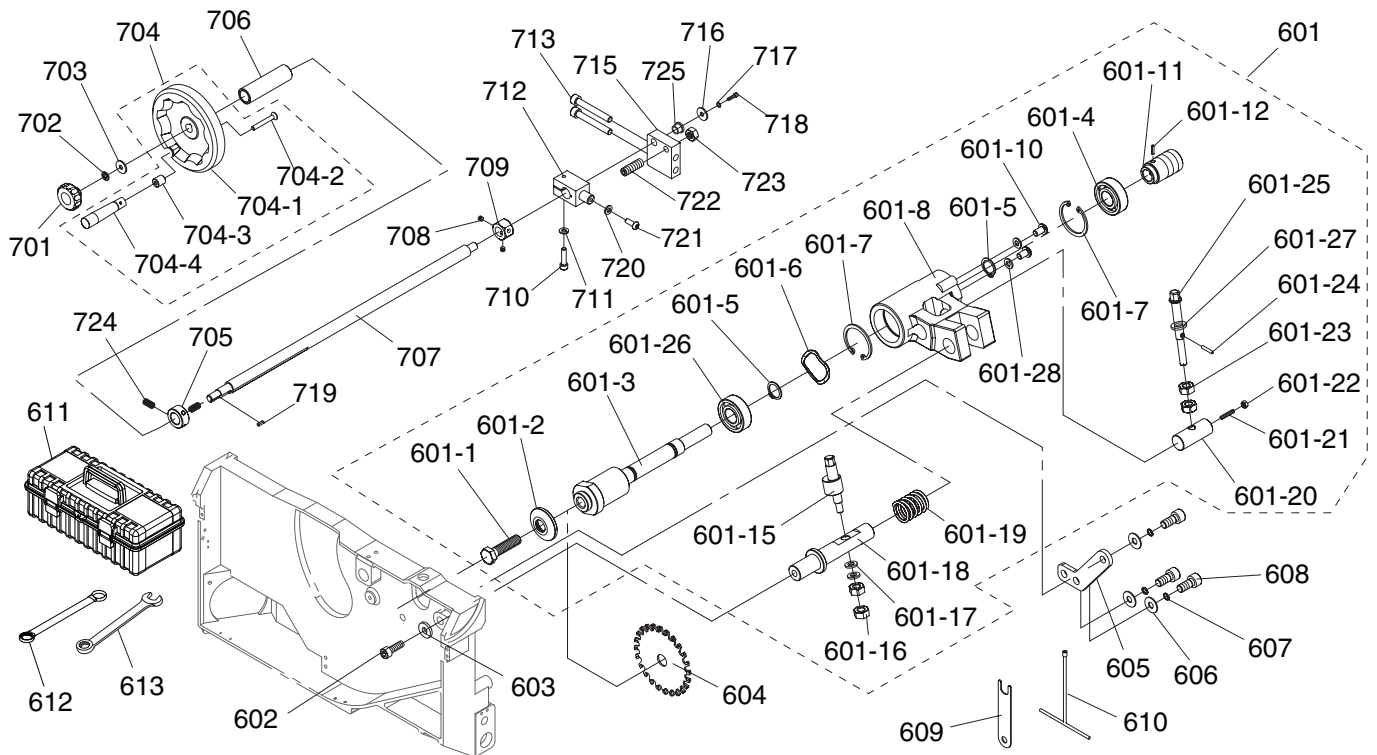
| REF | PART # | DESCRIPTION |
|--------|--------------|--------------------------------|
| 401 | P08200401 | GIB PLATE |
| 402 | P08200402 | BUTTON HD CAP SCR M10-1.5 X 25 |
| 403 | P08200403 | LOCK WASHER 10MM |
| 404 | P08200404 | KEY 5 X 5 X 20 |
| 405 | P08200405 | ARBOR NUT M16-2 |
| 406 | P08200406 | ARBOR FLANGE 1" |
| 410 | P08200410 | PIVOT SHAFT |
| 413 | P08200413 | FENDER WASHER 8MM |
| 414 | P08200414 | LOCK WASHER 8MM |
| 415 | P08200415 | CAP SCREW M8-1.25 X 20 |
| 416 | P08200416 | MAIN BLADE ARBOR ASSY |
| 416-1 | P08200416-1 | BALL BEARING 6206LLB |
| 416-2 | P08200416-2 | ARBOR SPACER |
| 416-3 | P08200416-3 | SET SCREW M6-1 X 8 |
| 416-4 | P08200416-4 | MAIN BLADE ARBOR PULLEY |
| 416-5 | P08200416-5 | ARBOR SUPPORT BRACKET |
| 416-6 | P08200416-6 | WAVE WASHER 47 X 60MM |
| 416-7 | P08200416-7 | MAIN BLADE ARBOR 25.4MM |
| 416-8 | P08200416-8 | FENDER WASHER 8MM |
| 416-9 | P08200416-9 | LOCK WASHER 8MM |
| 416-10 | P08200416-10 | BUTTON HD CAP SCR M8-1.25 X 20 |
| 417 | P08200417 | RIVING KNIFE MOUNTING ASSY |
| 417-1 | P08200417-1 | HEX NUT M10-1.5 |
| 417-2 | P08200417-2 | FENDER WASHER 10MM |
| 417-3 | P08200417-3 | RIVING KNIFE MOUNTING BLOCK |
| 417-4 | P08200417-4 | MOUNTING PLATE |

| REF | PART # | DESCRIPTION |
|--------|--------------|--------------------------------|
| 417-5 | P08200417-5 | CARRIAGE BOLT M10-1.5 X 35 |
| 417-6 | P08200417-6 | LINK ARM |
| 417-7 | P08200417-7 | SET SCREW M5-.8 X 10 |
| 417-8 | P08200417-8 | FENDER WASHER 8MM |
| 417-9 | P08200417-9 | LOCK WASHER 8MM |
| 417-10 | P08200417-10 | BUTTON HD CAP SCR M8-1.25 X 20 |
| 417-11 | P08200417-11 | BUSHING |
| 417-12 | P08200417-12 | BUTTON HD CAP SCR M8-1.25 X 20 |
| 417-13 | P08200417-13 | LINK PLATE BUSHING |
| 501 | P08200501 | BLADE GUARD ASSEMBLY |
| 501-1 | P08200501-1 | BLADE GUARD |
| 501-2 | P08200501-2 | PHLP HD SCR M3-.5 X 16 |
| 501-3 | P08200501-3 | PHLP HD SCR M3-.5 X 12 |
| 501-4 | P08200501-4 | FRONT PIVOT GUARD |
| 501-5 | P08200501-5 | PHLP HD SCR M5-.8 X 10 |
| 501-6 | P08200501-6 | SHAFT |
| 501-7 | P08200501-7 | LOCK NUT M10-1.5 |
| 501-8 | P08200501-8 | CAP SCREW M10-1.5 X 25 |
| 504 | P08200504 | HOSE CLAMP 2-1/2" |
| 505 | P08200505 | CAP SCREW M10-1.5 X 25 |
| 506 | P08200506 | LOCK WASHER 10MM |
| 507 | P08200507 | HOSE SUPPORT PLATE |
| 508 | P08200508 | FLAT WASHER 10MM |
| 509 | P08200509 | HEX NUT M10-1.5 |
| 510 | P08200510 | SPLITTER/RIVING KNIFE |

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Scoring Blade Arbor & Handwheel

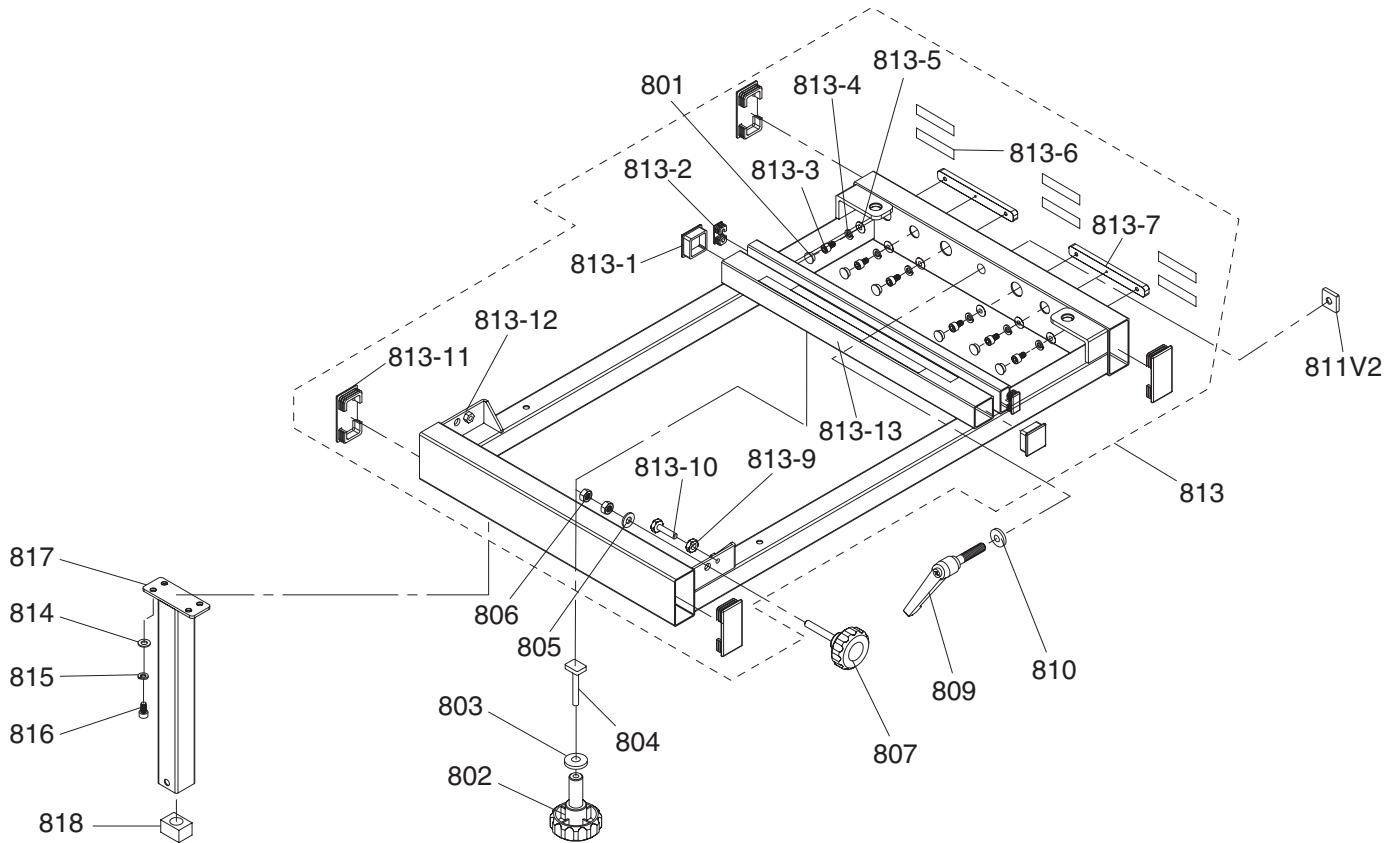


| REF | PART # | DESCRIPTION |
|--------|--------------|--|
| 601 | P08200601 | SCORING BLADE PULLEY ASSY |
| 601-1 | P08200601-1 | HEX BOLT M12-1.75 X 20 |
| 601-2 | P08200601-2 | SCORING BLADE FLANGE |
| 601-3 | P08200601-3 | SCORING BLADE ARBOR |
| 601-4 | P08200601-4 | BALL BEARING 6202ZZ |
| 601-5 | P08200601-5 | INT RETAINING RING 15MM |
| 601-6 | P08200601-6 | WAVE WASHER 26 X 34MM |
| 601-7 | P08200601-7 | INT RETAINING RING 35MM |
| 601-8 | P08200601-8 | SCORING BLADE ARBOR HOUSING |
| 601-10 | P08200601-10 | HEX BOLT M6-1 X 12 |
| 601-11 | P08200601-11 | SCORING BLADE ARBOR PULLEY |
| 601-12 | P08200601-12 | ROLL PIN 5 X 25 |
| 601-15 | P08200601-15 | ECCENTRIC SHAFT |
| 601-16 | P08200601-16 | LOCK NUT M6-1 |
| 601-17 | P08200601-17 | COMPRESSION SPRING 15 X 6.2 X 0.5T |
| 601-18 | P08200601-18 | ELEVATION SHAFT |
| 601-19 | P08200601-19 | COMPRESSION SPRING 26.5 X 22.5 X 2.5MM |
| 601-20 | P08200601-20 | BUSHING |
| 601-21 | P08200601-21 | SET SCREW M6-1 X 25 |
| 601-22 | P08200601-22 | HEX NUT M6-1 |
| 601-23 | P08200601-23 | HEX NUT M8-1.25 |
| 601-24 | P08200601-24 | ROLL PIN 2.5 X 12 |
| 601-25 | P08200601-25 | CONNECTION BOLT |
| 601-26 | P08200601-26 | BALL BEARING 6003LLB |
| 601-27 | P08200601-27 | FLAT WASHER 8MM |
| 601-28 | P08200601-28 | FLAT WASHER 6MM |
| 602 | P08200602 | CAP SCREW M8-1.25 X 16 |
| 603 | P08200603 | FENDER WASHER 8MM |
| 604 | P08200604 | SCORING BLADE 120MM DIA X 20MM BORE |
| 605 | P08200605 | FIXED PLATE |
| 606 | P08200606 | FLAT WASHER 6MM |
| 607 | P08200607 | LOCK WASHER 6MM |
| 608 | P08200608 | CAP SCREW M6-1 X 16 |

| REF | PART # | DESCRIPTION |
|-------|-------------|------------------------------------|
| 609 | P08200609 | SCORING BLADE ARBOR WRENCH |
| 610 | P08200610 | T-HANDLE WRENCH 8MM |
| 611 | P08200611 | TOOLBOX |
| 612 | P08200612 | WRENCH 17 X 19 CLOSED ENDS |
| 613 | P08200613 | WRENCH 30MM COMBO |
| 701 | P08200701 | KNOB 12-LOBE M8-1.25 |
| 702 | P08200702 | FLAT WASHER 10MM |
| 703 | P08200703 | FENDER WASHER 10MM |
| 704 | P08200704 | HANDWHEEL ASSEMBLY |
| 704-1 | P08200704-1 | HANDWHEEL TYPE-11 200D X 16B-K |
| 704-2 | P08200704-2 | FLAT HD SCR M6-1 X 12 |
| 704-3 | P08200704-3 | SPACER |
| 704-4 | P08200704-4 | HANDWHEEL HANDLE |
| 705 | P08200705 | LOCK COLLAR |
| 706 | P08200706 | SLEEVE |
| 707 | P08200707 | CONNECTING SHAFT |
| 708 | P08200708 | SET SCREW M6-1 X 6 |
| 709 | P08200709 | SHAFT LOCK COLLAR |
| 710 | P08200710 | CAP SCREW M6-1 X 30 |
| 711 | P08200711 | LOCK WASHER 6MM |
| 712 | P08200712 | CONNECTING SHAFT GUIDE |
| 713 | P08200713 | CAP SCREW M8-1.25 X 50 |
| 715 | P08200715 | LOCATING BLOCK |
| 716 | P08200716 | FLAT WASHER 6MM |
| 717 | P08200717 | LOCK WASHER 6MM |
| 718 | P08200718 | CAP SCREW M6-1 X 12 |
| 719 | P08200719 | KEY 5 X 5 X 20 |
| 720 | P08200720 | FLAT WASHER 6MM |
| 721 | P08200721 | CAP SCREW M6-1 X 10 |
| 722 | P08200722 | SET SCREW M10-1.5 X 35 |
| 723 | P08200723 | HEX NUT M10-1.5 |
| 724 | P08200724 | SET SCREW M6-1 X 8 |
| 725 | P08200725 | SELF-LUBRICATING BEARING 16 X 10MM |



Crosscut Table

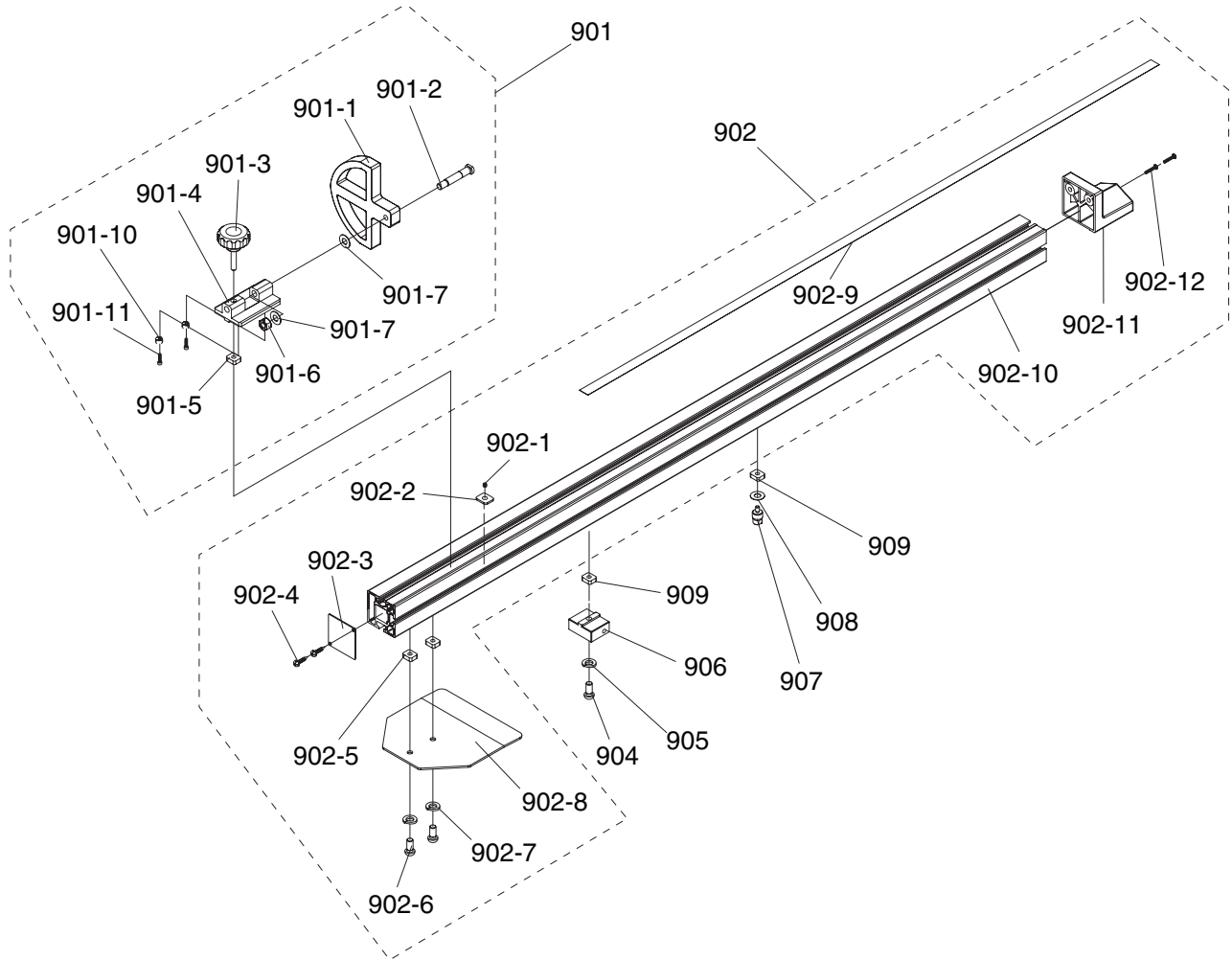


| REF | PART # | DESCRIPTION |
|-------|-------------|------------------------------|
| 801 | P08200801 | SCREW CAP |
| 802 | P08200802 | KNOB M8-1.25 X 50 |
| 803 | P08200803 | FENDER WASHER 8MM |
| 804 | P08200804 | T-BOLT M8-1.25 X 60 |
| 805 | P08200805 | FLAT WASHER 8MM |
| 806 | P08200806 | HEX NUT M8-1.25 |
| 807 | P08200807 | KNOB M8-1.25 X 50 |
| 809 | P08200809 | ADJ HANDLE 95L M12-1.75 X 57 |
| 810 | P08200810 | FLAT WASHER 12MM |
| 811V2 | P08200811V2 | T-NUT M12-1.75 V2.05.22 |
| 813 | P08200813 | CROSSCUT TABLE ASSY |
| 813-1 | P08200813-1 | FRAME END-CAP 38 X 38MM |
| 813-2 | P08200813-2 | FRAME END-CAP 40 X 20MM |
| 813-3 | P08200813-3 | BUTTON HD CAP SCR M6-1 X 16 |

| REF | PART # | DESCRIPTION |
|--------|--------------|-------------------------|
| 813-4 | P08200813-4 | LOCK WASHER 6MM |
| 813-5 | P08200813-5 | FLAT WASHER 6MM |
| 813-6 | P08200813-6 | CUSHION PAD 5 X 55MM |
| 813-7 | P08200813-7 | T-SLOT ALIGNMENT PLATE |
| 813-9 | P08200813-9 | HEX NUT M8-1.25 |
| 813-10 | P08200813-10 | HEX BOLT M8-1.25 X 30 |
| 813-11 | P08200813-11 | FRAME END-CAP 80 X 40MM |
| 813-12 | P08200813-12 | CROSSCUT TABLE FRAME |
| 813-13 | P08200813-13 | MITER ANGLE SCALE |
| 814 | P08200814 | FLAT WASHER 6MM |
| 815 | P08200815 | LOCK WASHER 6MM |
| 816 | P08200816 | CAP SCREW M6-1 X 16 |
| 817 | P08200817 | SUPPORT LEG |
| 818 | P08200818 | END PLUG |



Crosscut Fence

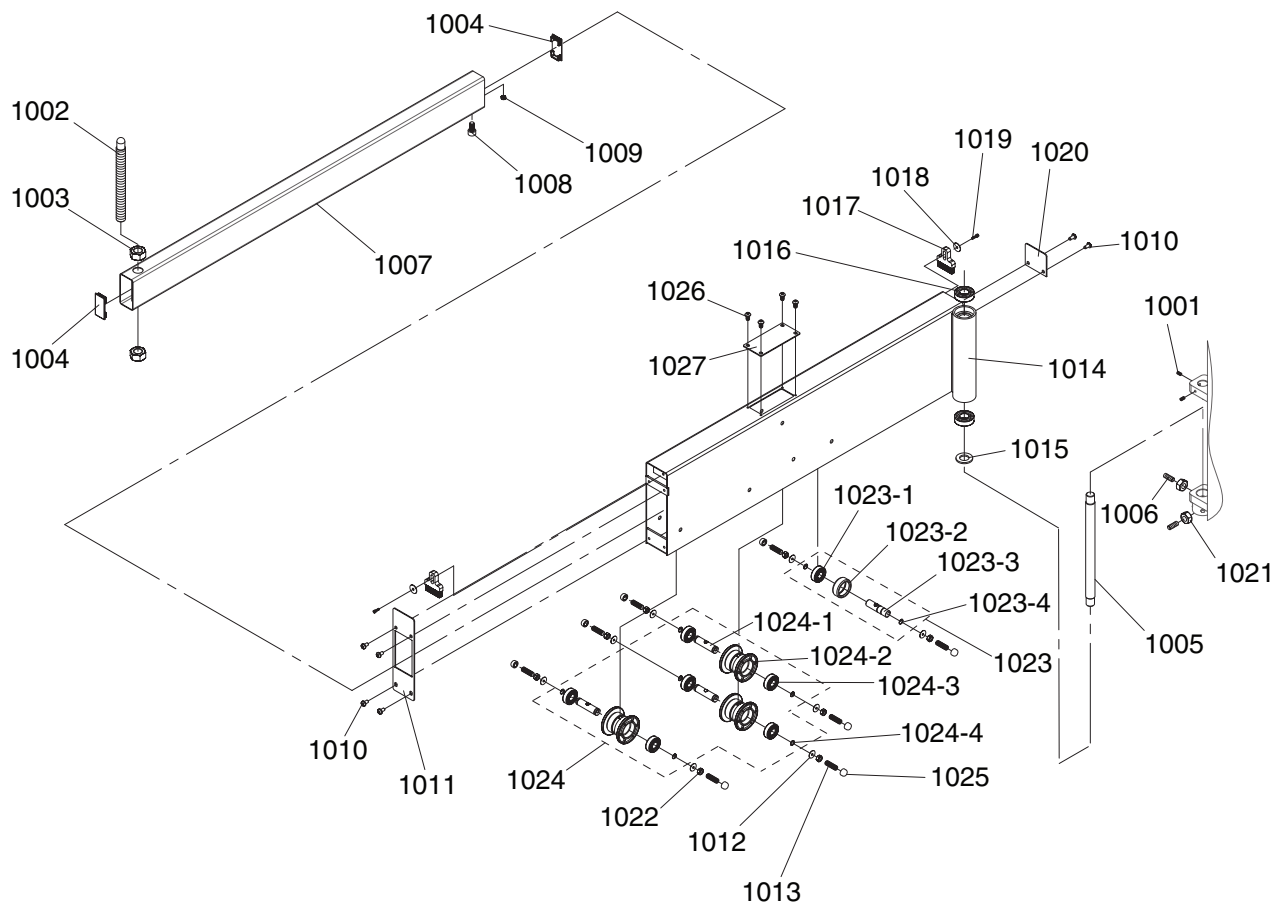


| REF | PART # | DESCRIPTION |
|--------|--------------|-----------------------------------|
| 901 | P08200901 | FLIP-STOP ASSEMBLY |
| 901-1 | P08200901-1 | FLIP-STOP |
| 901-2 | P08200901-2 | PIVOT SHAFT |
| 901-3 | P08200901-3 | KNOB BOLT M8-1.25 X 40 |
| 901-4 | P08200901-4 | FLIP-STOP BRACKET |
| 901-5 | P08200901-5 | SQUARE NUT M8-1.25 |
| 901-6 | P08200901-6 | LOCK NUT M10-1.5 |
| 901-7 | P08200901-7 | FLAT WASHER 10 X 18 X 0.5T COPPER |
| 901-10 | P08200901-10 | SLEEVE |
| 901-11 | P08200901-11 | CAP SCREW M3-.5 X 12 |
| 902 | P08200902 | CROSSCUT FENCE ASSEMBLY |
| 902-1 | P08200902-1 | SET SCREW M5-.8 X 5 |
| 902-2 | P08200902-2 | SQUARE NUT M5-.8 (THIN) |
| 902-3 | P08200902-3 | EXTENSION FENCE END CAP |
| 902-4 | P08200902-4 | TAP SCREW M4-.7 X 10 |

| REF | PART # | DESCRIPTION |
|--------|--------------|--------------------------------|
| 902-5 | P08200902-5 | T-SLOT NUT M8-1.25 |
| 902-6 | P08200902-6 | BUTTON HD CAP SCR M8-1.25 X 16 |
| 902-7 | P08200902-7 | LOCK WASHER 8MM |
| 902-8 | P08200902-8 | STOCK SUPPORT PLATE |
| 902-9 | P08200902-9 | FENCE SCALE 0"-78" |
| 902-10 | P08200902-10 | CROSSCUT MAIN FENCE |
| 902-11 | P08200902-11 | CROSSCUT MAIN FENCE END CAP |
| 902-12 | P08200902-12 | PHLP HD SCR M4-.7 X 10 |
| 904 | P08200904 | CAP SCREW M8-1.25 X 35 |
| 905 | P08200905 | LOCK WASHER 8MM |
| 906 | P08200906 | FLIP-STOP CLAMP BLOCK |
| 907 | P08200907 | ROTATE SHAFT |
| 908 | P08200908 | FLAT WASHER 10MM NYLON |
| 909 | P08200909 | SQUARE NUT M8-1.25 |



Crosscut Swing-Arm

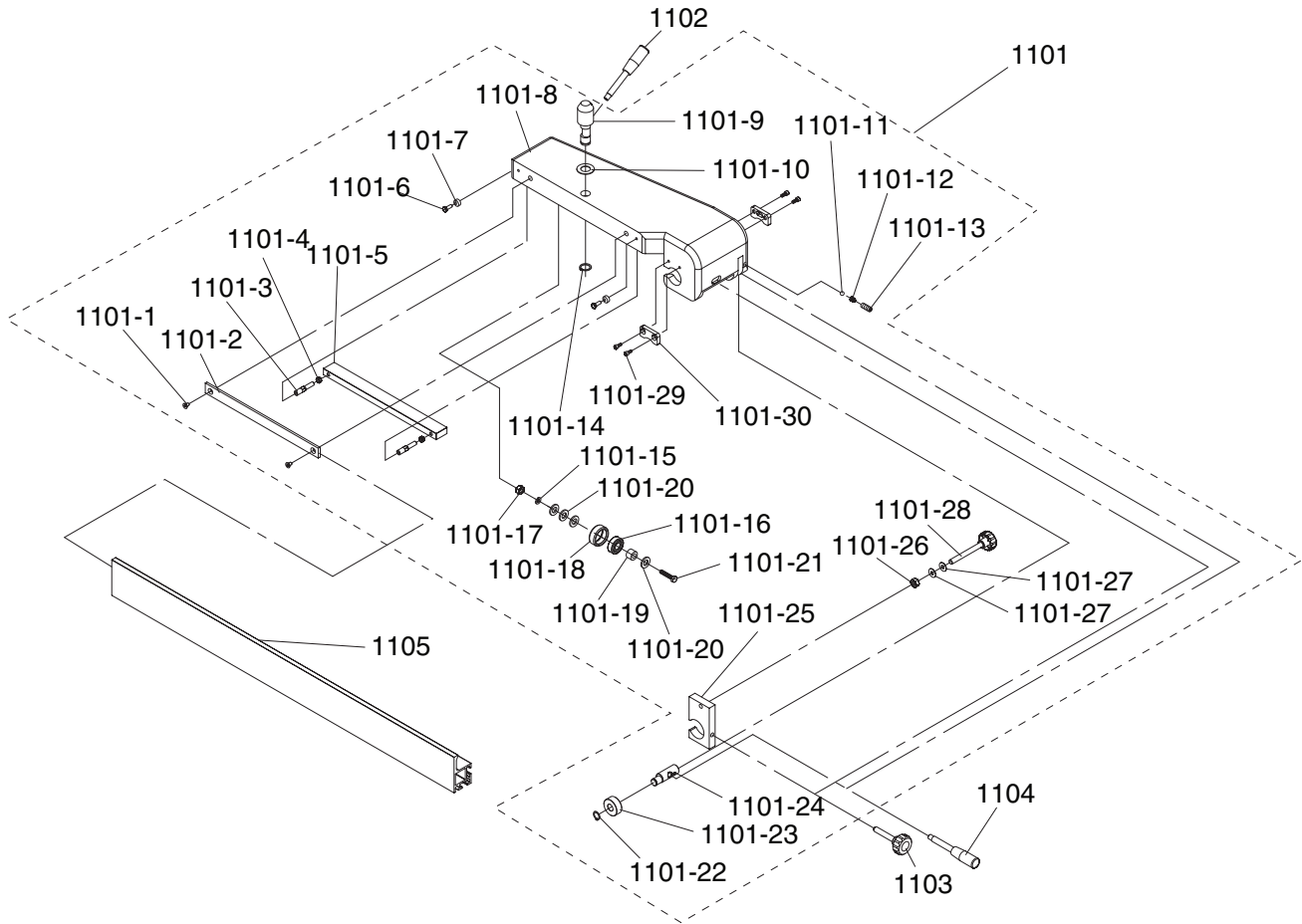


| REF | PART # | DESCRIPTION |
|------|-----------|-----------------------------------|
| 1001 | P08201001 | SET SCREW M10-1.5 X 10 |
| 1002 | P08201002 | CROSS-CUT PIVOT ROD M20-2.5 X 215 |
| 1003 | P08201003 | HEX NUT M20-2.5 |
| 1004 | P08201004 | SLIDING TUBE END CAP |
| 1005 | P08201005 | PIVOT SHAFT |
| 1006 | P08201006 | SET SCREW M10-1.5 X 20 |
| 1007 | P08201007 | SLIDING TUBE |
| 1008 | P08201008 | CAP SCREW M8-1.25 X 20 |
| 1009 | P08201009 | HEX NUT M8-1.25 |
| 1010 | P08201010 | BUTTON HD CAP SCR M6-1 X 10 |
| 1011 | P08201011 | SWING ARM END CAP (LH) |
| 1012 | P08201012 | FLAT WASHER 8MM |
| 1013 | P08201013 | SET SCREW M8-1.25 X 25 |
| 1014 | P08201014 | SWING ARM |
| 1015 | P08201015 | FLAT WASHER 20MM |
| 1016 | P08201016 | BALL BEARING 6004ZZ |
| 1017 | P08201017 | BRUSH |
| 1018 | P08201018 | FLAT WASHER 6MM |

| REF | PART # | DESCRIPTION |
|--------|-------------|-------------------------------|
| 1019 | P08201019 | CAP SCREW M6-1 X 20 |
| 1020 | P08201020 | SWING ARM END CAP (RH) |
| 1021 | P08201021 | HEX NUT M10-1.5 |
| 1022 | P08201022 | HEX NUT M8-1.25 |
| 1023 | P08201023 | TUBE ROLLER ASSEMBLY (UPPER) |
| 1023-1 | P08201023-1 | BALL BEARING 6202ZZ |
| 1023-2 | P08201023-2 | ROLLER |
| 1023-3 | P08201023-3 | ROLLER SHAFT |
| 1023-4 | P08201023-4 | EXT RETAINING RING 15MM |
| 1024 | P08201024 | TUBE ROLLER ASSEMBLY (LOWER) |
| 1024-1 | P08201024-1 | ROLLER SHAFT |
| 1024-2 | P08201024-2 | ROLLER |
| 1024-3 | P08201024-3 | BALL BEARING 6202ZZ |
| 1024-4 | P08201024-4 | EXT RETAINING RING 15MM |
| 1025 | P08201025 | SET SCREW PROTECTIVE CAP 13MM |
| 1026 | P08201026 | BUTTON HD CAP SCR M5-.8 X 8 |
| 1027 | P08201027 | SWING-ARM TOP PLATE |



Rip Fence

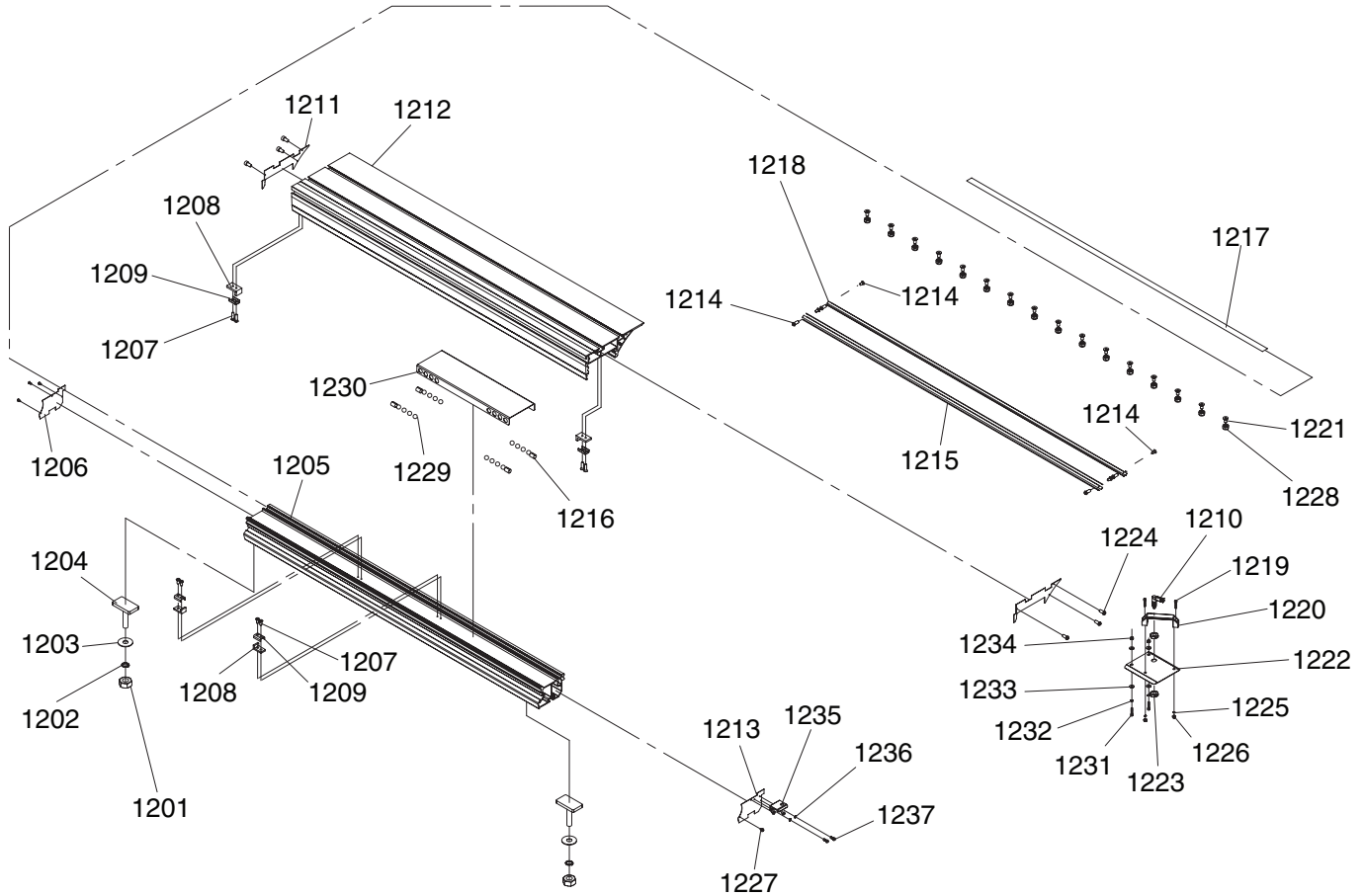


| REF | PART # | DESCRIPTION |
|---------|--------------|----------------------------------|
| 1101 | P08201101 | RIP FENCE ASSEMBLY |
| 1101-1 | P08201101-1 | FLAT HD SCR M6-1 X 16 |
| 1101-2 | P08201101-2 | FENCE T-SLOT PLATE |
| 1101-3 | P08201101-3 | THREADED SHAFT M8-1.25 X 16 |
| 1101-4 | P08201101-4 | LOCK NUT M8-1.25 |
| 1101-5 | P08201101-5 | ALIGNMENT PLATE |
| 1101-6 | P08201101-6 | HEX BOLT M6-1 X 16 |
| 1101-7 | P08201101-7 | ECCENTRIC RING |
| 1101-8 | P08201101-8 | RIP FENCE BODY |
| 1101-9 | P08201101-9 | ECCENTRIC SHAFT |
| 1101-10 | P08201101-10 | FLAT WASHER 20MM |
| 1101-11 | P08201101-11 | STEEL BALL 8MM |
| 1101-12 | P08201101-12 | COMPRESSION SPRING 9 X 7.5 X 1MM |
| 1101-13 | P08201101-13 | SET SCREW M10-1.5 X 10 |
| 1101-14 | P08201101-14 | EXT RETAINING RING 20MM |
| 1101-15 | P08201101-15 | LOCK WASHER 8MM |
| 1101-16 | P08201101-16 | BALL BEARING 6202ZZ |
| 1101-17 | P08201101-17 | ACORN NUT M8-1.25 |

| REF | PART # | DESCRIPTION |
|---------|--------------|---------------------------------|
| 1101-18 | P08201101-18 | SPACER |
| 1101-19 | P08201101-19 | BUSHING |
| 1101-20 | P08201101-20 | FENDER WASHER 8MM |
| 1101-21 | P08201101-21 | HEX BOLT M8-1.25 X 35 |
| 1101-22 | P08201101-22 | EXT RETAINING RING 15MM |
| 1101-23 | P08201101-23 | SPACER |
| 1101-24 | P08201101-24 | RAIL LOCK SHAFT |
| 1101-25 | P08201101-25 | FENCE RAIL BRACKET |
| 1101-26 | P08201101-26 | LOCK NUT M10-1.5 |
| 1101-27 | P08201101-27 | FLAT WASHER 10MM |
| 1101-28 | P08201101-28 | KNOB BOLT M10-1.5 X 110 |
| 1101-29 | P08201101-29 | CAP SCREW M6-1 X 10 |
| 1101-30 | P08201101-30 | RAIL WIPER |
| 1102 | P08201102 | LEVER HANDLE M10-1.5 X 12, 140L |
| 1103 | P08201103 | KNOB BOLT M10-1.5 X 55 |
| 1104 | P08201104 | LEVER HANDLE M10-1.5 X 12, 140L |
| 1105 | P08201105 | FENCE 36" (ALUMINUM) |



Sliding Table

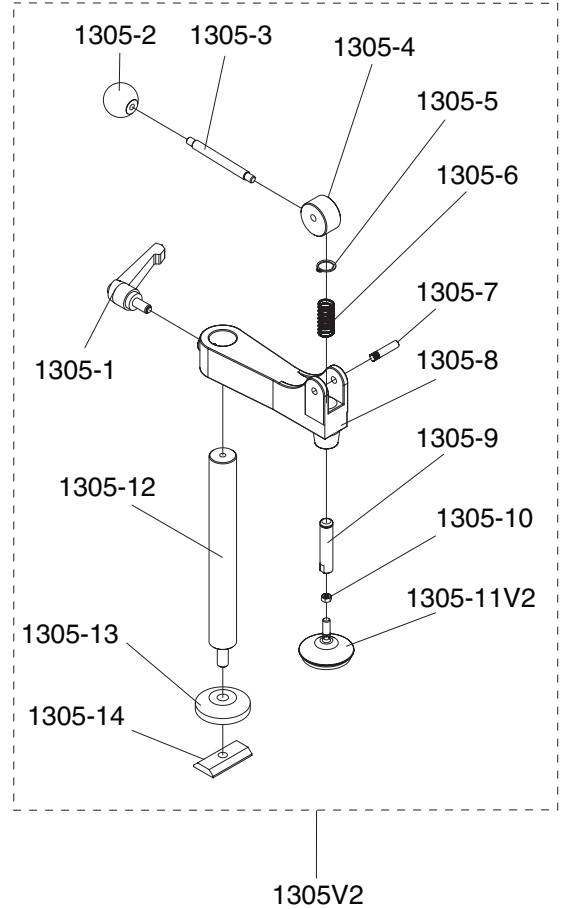
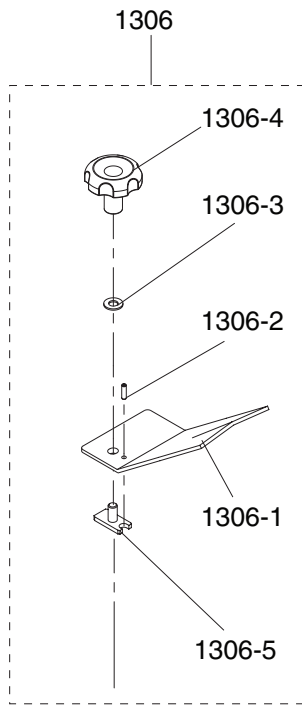
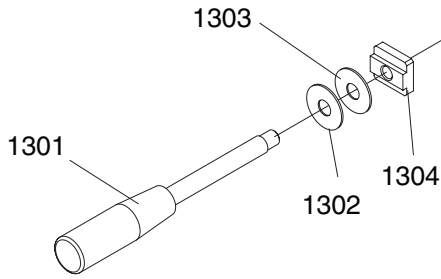


| REF | PART # | DESCRIPTION |
|------|-----------|-----------------------------------|
| 1201 | P08201201 | HEX NUT M12-1.75 |
| 1202 | P08201202 | LOCK WASHER 12MM |
| 1203 | P08201203 | FLAT WASHER 12MM |
| 1204 | P08201204 | T-SLOT BOLT M12-1.75 X 50 |
| 1205 | P08201205 | SLIDING TABLE BASE |
| 1206 | P08201206 | SLIDING TABLE BASE END CAP (LH) |
| 1207 | P08201207 | FLAT HD SCR M6-1 X 30 |
| 1208 | P08201208 | STOP BLOCK (RUBBER) |
| 1209 | P08201209 | STOP BLOCK BRACKET |
| 1210 | P08201210 | PIN LOCK |
| 1211 | P08201211 | SLIDING TABLE END COVER (R/L) |
| 1212 | P08201212 | SLIDING TABLE TOP 1600MM |
| 1213 | P08201213 | SLIDING TABLE BASE END COVER (RH) |
| 1214 | P08201214 | BUTTON HD CAP SCR M6-1 X 10 |
| 1215 | P08201215 | STEEL RAIL |
| 1216 | P08201216 | COTTON PAD |
| 1217 | P08201217 | COVER STRIP |
| 1218 | P08201218 | ADHESIVE STRIP |
| 1219 | P08201219 | CAP SCREW M8-1.25 X 16 |

| REF | PART # | DESCRIPTION |
|------|-----------|------------------------------|
| 1220 | P08201220 | PULL HANDLE |
| 1221 | P08201221 | FLAT HD SCR M10-1.5 X 20 |
| 1222 | P08201222 | HANDLE MOUNTING PLATE |
| 1223 | P08201223 | HEX NUT M16-1.5 |
| 1224 | P08201224 | BUTTON HD CAP SCR M5-.8 X 12 |
| 1225 | P08201225 | LOCK WASHER 8MM |
| 1226 | P08201226 | HEX NUT M8-1.25 |
| 1227 | P08201227 | TAP SCREW M4-.7 X 12 |
| 1228 | P08201228 | LOCK NUT M10-1.5 |
| 1229 | P08201229 | STEEL BALL 16.6MM |
| 1230 | P08201230 | SLIDING PLATE |
| 1231 | P08201231 | BUTTON HD CAP SCR M6-1 X 16 |
| 1232 | P08201232 | LOCK WASHER 6MM |
| 1233 | P08201233 | FLAT WASHER 6MM |
| 1234 | P08201234 | HEX NUT M6-1 |
| 1235 | P08201235 | END CAP BRACKET |
| 1236 | P08201236 | LOCK WASHER 6MM |
| 1237 | P08201237 | BUTTON HD CAP SCR M6-1 X 12 |



Sliding Table Accessories

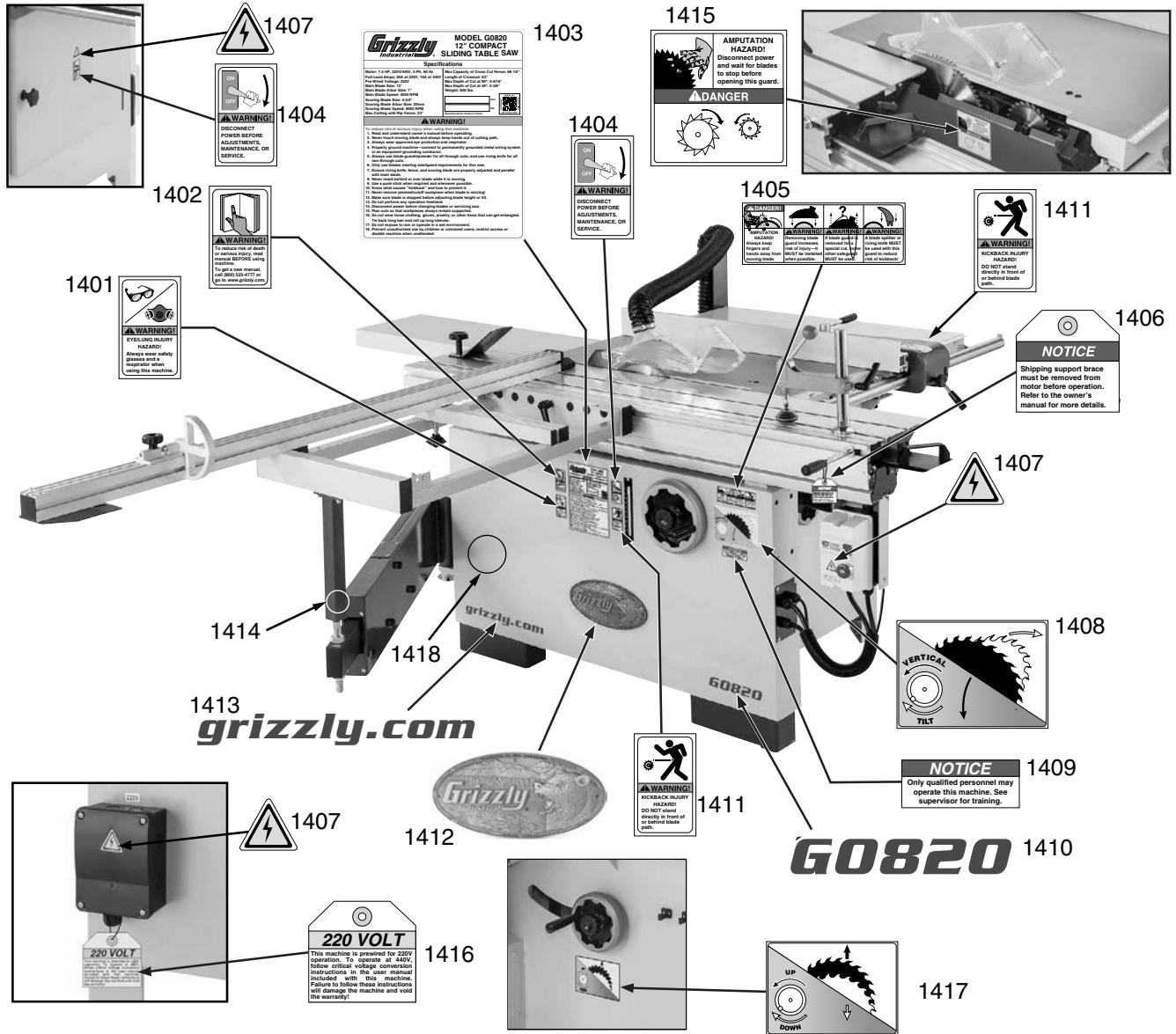


| REF | PART # | DESCRIPTION |
|--------|-------------|------------------------------------|
| 1301 | P08201301 | LEVER HANDLE M12-1.75 X 20, 215L |
| 1302 | P08201302 | FLAT WASHER 12MM |
| 1303 | P08201303 | FLAT WASHER 12MM COPPER |
| 1304 | P08201304 | T-SLOT NUT M12-1.75 |
| 1305V2 | P08201305V2 | HOLD-DOWN ASSEMBLY V2.10.17 |
| 1305-1 | P08201305-1 | ADJ HANDLE 70L M10-1.5 X 25 |
| 1305-2 | P08201305-2 | BALL KNOB M8-1.25 |
| 1305-3 | P08201305-3 | STUD-DE M8-1.25 X 100, 10MM |
| 1305-4 | P08201305-4 | CAM |
| 1305-5 | P08201305-5 | EXT RETAINING RING 14MM |
| 1305-6 | P08201305-6 | COMPRESSION SPRING 40 X 18 X 1.6MM |
| 1305-7 | P08201305-7 | FLUTED PIVOT PIN |
| 1305-8 | P08201305-8 | HOLD-DOWN BRACKET |

| REF | PART # | DESCRIPTION |
|-----------|----------------|----------------------------|
| 1305-9 | P08201305-9 | HOLD-DOWN SHAFT |
| 1305-10 | P08201305-10 | HEX NUT 5/16-18 |
| 1305-11V2 | P08201305-11V2 | HOLD-DOWN PAD V2.10.17 |
| 1305-12 | P08201305-12 | SUPPORT SHAFT |
| 1305-13 | P08201305-13 | SHAFT BASE |
| 1305-14 | P08201305-14 | T-NUT 14MM W/HOLE M12-1.75 |
| 1306 | P08201306 | EDGE SHOE ASSEMBLY |
| 1306-1 | P08201306-1 | EDGE SHOE PLATE |
| 1306-2 | P08201306-2 | ROLL PIN 5 X 16 |
| 1306-3 | P08201306-3 | FLAT WASHER 10MM |
| 1306-4 | P08201306-4 | KNOB M10-1.5 |
| 1306-5 | P08201306-5 | T-SLOT BOLT M10-1.5 X 25 |



Labels & Cosmetics



| REF | PART # | DESCRIPTION |
|------|-----------|-----------------------------|
| 1401 | P08201401 | GLASSES/RESPIRATOR LABEL |
| 1402 | P08201402 | READ MANUAL LABEL |
| 1403 | P08201403 | MACHINE ID LABEL |
| 1404 | P08201404 | DISCONNECT HARDWIRED LABEL |
| 1405 | P08201405 | TABLE SAW BLADE GUARD LABEL |
| 1406 | P08201406 | SHIPPING BRACE TAG |
| 1407 | P08201407 | ELECTRICITY LABEL |
| 1408 | P08201408 | BLADE TILT LABEL |
| 1409 | P08201409 | QUALIFIED PERSONNEL LABEL |

| REF | PART # | DESCRIPTION |
|------|-----------|-------------------------------|
| 1410 | P08201410 | MODEL NUMBER LABEL |
| 1411 | P08201411 | KICKBACK HAZARD LABEL |
| 1412 | P08201412 | GRIZZLY NAMEPLATE |
| 1413 | P08201413 | GRIZZLY.COM LABEL |
| 1414 | P08201414 | TOUCH-UP PAINT, GRIZZLY GREEN |
| 1415 | P08201415 | AMPUTATION DANGER LABEL |
| 1416 | P08201416 | PREWIRED 220V TAG |
| 1417 | P08201417 | BLADE ELEVATION LABEL |
| 1418 | P08201418 | TOUCH-UP PAINT, GREY PUTTY |

⚠ 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 & RETURNS

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

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

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

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

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

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

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



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