

# *Grizzly* **Industrial, Inc.**®

## **MODEL G0828/G0829 BENCHTOP METAL SHEAR OWNER'S MANUAL**

*(For models manufactured since 02/17)*



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

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 **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

## Machine Description

The main difference between the G0828 and G0829 is the size of the bed and cutting capacity. The G0828 can cut an 18-gauge sheet at a maximum width of 25<sup>7</sup>/<sub>8</sub>". The G0829 can cut a 20-gauge sheet at a maximum width of 41<sup>1</sup>/<sub>2</sub>".

## 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


## 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](http://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.

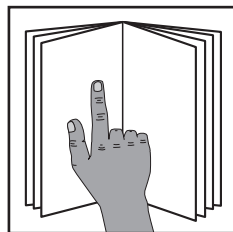
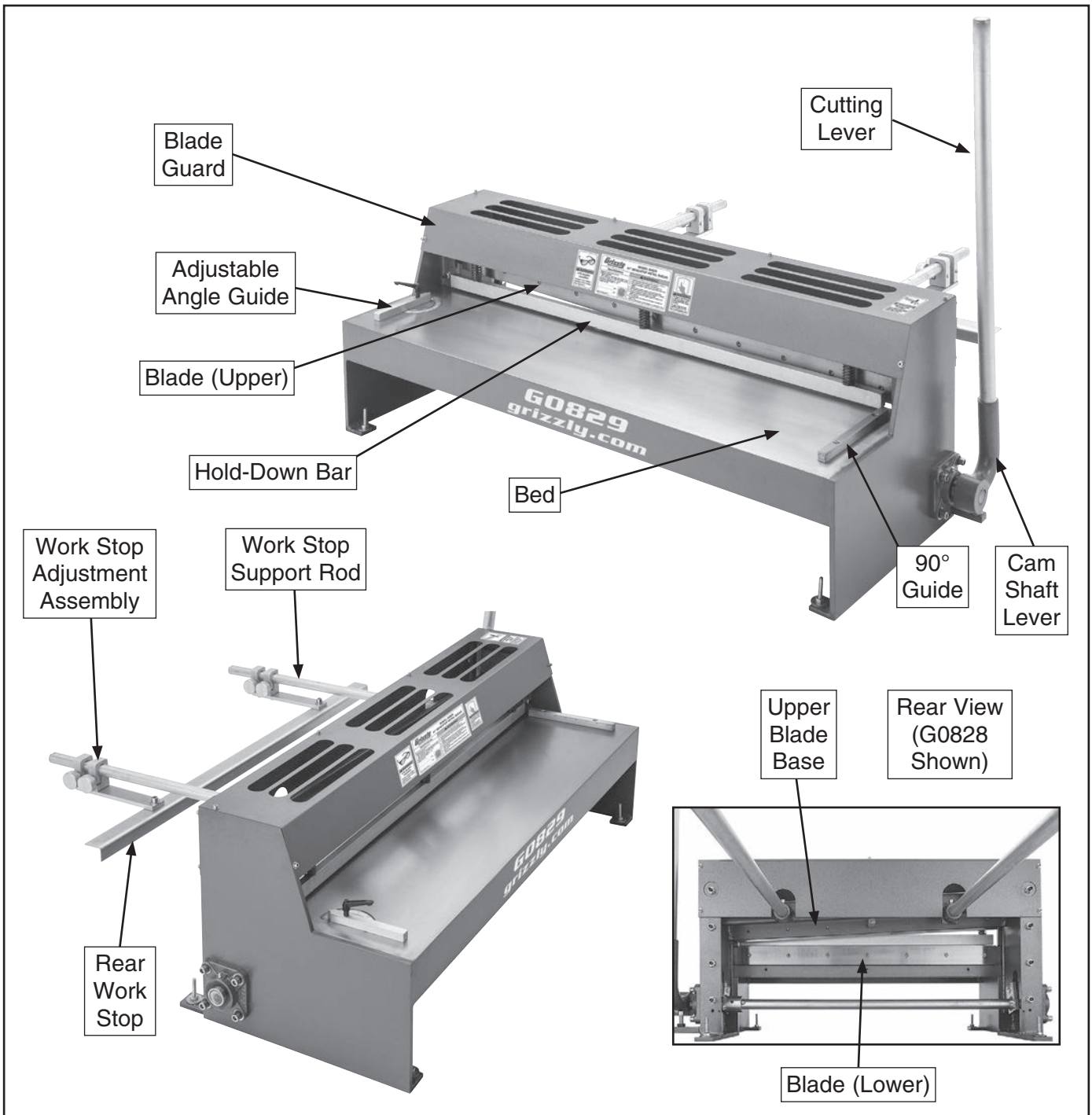
		<b>MODEL GXXXX</b> <b>MACHINE NAME</b>	
<b>SPECIFICATIONS</b>		<b>▲ WARNING!</b>	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure safety glasses and respirator are properly adjusted/setup and	
Specification:		4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.	
Weight:		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
		Manufactured for Grizzly in Taiwan	

Manufacture Date

Serial Number



# Identification



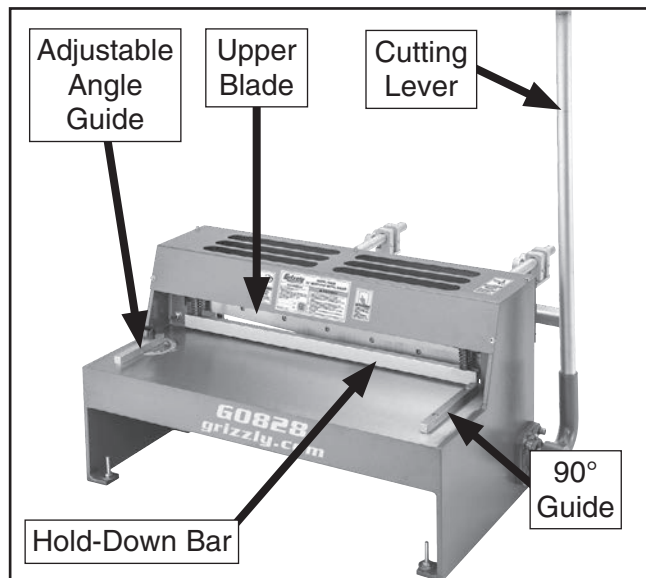
## **⚠️ WARNING**

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



# Controls & Components

Use **Figures 1-2** and the descriptions below to become familiar with the basic controls of the G0828 and G0829 metal shears. The controls on both models function identically.



**Figure 1.** Basic controls (front).

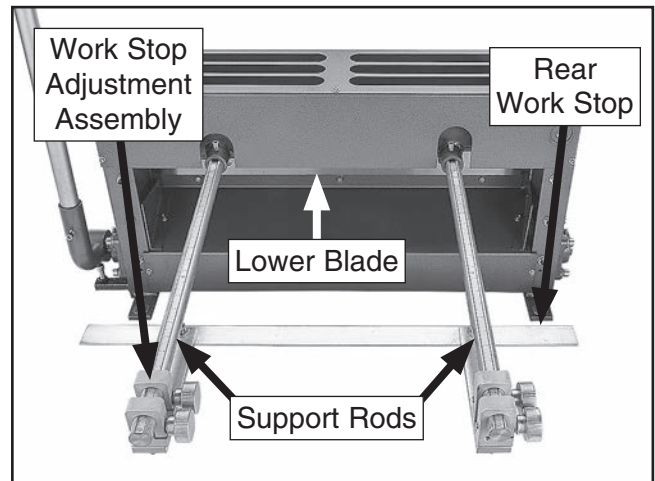
**Adjustable Angle Guide:** Adjusts from 0° to 180° for making angled cuts.

**Upper Blade:** Moves with the cutting lever to shear the workpiece against the lower blade for cutting operations. The upper and lower blades are interchangeable and reversible.

**Cutting Lever:** Controls movement of the upper blade for cutting.

**Hold-Down Bar:** Spring-loaded bar holds the workpiece in position during cutting operation as cutting lever is pulled down.

**90° Guide:** Helps the operator square the workpiece with the blades.



**Figure 2.** Basic controls (rear).

**Work Stop Adjustment Assembly:** Moves the rear work stop in or out at a specific distance from the lower blade. Allows the operator to set up the shear for multiple cuts of the same length.

**Lower Blade:** Fixed on frame. The upper and lower blades are interchangeable and reversible.

**Rear Work Stop:** Used for making repetitive cuts.

**Support Rods:** Provide a measurement reference from the blade to the work stops. Support the adjustable work stop assemblies and rear work stop.





# MACHINE DATA SHEET

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

## MODEL G0828 25" BENCHTOP METAL SHEAR

### Product Dimensions:

Weight..... 287 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 35-1/2 x 39 x 37 in.  
 Footprint (Length x Width)..... 31 x 19 in.  
 Space Required for Full Range of Movement (Width x Depth)..... 35-1/2 x 59 in.

### Shipping Dimensions:

Type..... Wood Crate  
 Content..... Machine  
 Weight..... 342 lbs.  
 Length x Width x Height..... 38 x 23 x 23 in.  
 Must Ship Upright..... Yes

### Main Specifications:

#### Capacities

Maximum Width..... 25-7/8 in.  
 Maximum Thickness at Half Width Mild Steel..... 16 Gauge  
 Maximum Thickness at Full Width Mild Steel..... 18 Gauge  
 Front Stop Scale Range..... 0 – 9-1/2 in.  
 Rear Stop Scale Range..... 0 – 21 in.

#### Construction

Frame..... Steel  
 Hold-Down Clamp..... Steel  
 Shear Table..... Steel  
 Shear Blades..... High-Speed Steel

### Other Specifications:

Country of Origin ..... China  
 Warranty ..... 1 Year  
 Approximate Assembly & Setup Time ..... 30 Minutes  
 Serial Number Location ..... Machine ID Label  
 ISO 9001 Factory ..... Yes  
 Certified by a Nationally Recognized Testing Laboratory (NRTL) ..... No

### Features:

- 18 Ga. Maximum Cutting Thickness
- Steel Body Construction
- Two-Sided Upper and Lower Blades
- Adjustable Gibs for Upper Blade Assembly
- Adjustable Protractor Stop
- Heavy-Duty Ball-Bearing Hinge Points







# MACHINE DATA SHEET

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

## MODEL G0829 41" BENCHTOP METAL SHEAR

### Product Dimensions:

Weight..... 397 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 51 x 39 x 37 in.  
 Footprint (Length x Width)..... 46-1/2 x 19 in.  
 Space Required for Full Range of Movement (Width x Depth)..... 51 x 59 in.

### Shipping Dimensions:

Type..... Wood Crate  
 Content..... Machine  
 Weight..... 463 lbs.  
 Length x Width x Height..... 54 x 23 x 23 in.  
 Must Ship Upright..... Yes

### Main Specifications:

#### Capacities

Maximum Width..... 41-1/2 in.  
 Maximum Thickness at Half Width Mild Steel..... 18 Gauge  
 Maximum Thickness at Full Width Mild Steel..... 20 Gauge  
 Front Stop Scale Range..... 0 – 9-1/2 in.  
 Rear Stop Scale Range..... 0 – 21 in.

#### Construction

Frame..... Steel  
 Hold-Down Clamp..... Steel  
 Shear Table..... Steel  
 Shear Blades..... High-Speed Steel

### Other Specifications:

Country of Origin ..... China  
 Warranty ..... 1 Year  
 Approximate Assembly & Setup Time ..... 30 Minutes  
 Serial Number Location ..... Machine ID Label  
 ISO 9001 Factory ..... Yes  
 Certified by a Nationally Recognized Testing Laboratory (NRTL) ..... No

### Features:

- 20 Ga. Maximum Cutting Thickness
- Steel Body Construction
- Two-Sided Upper and Lower Blades
- Adjustable Gibs for Upper Blade Assembly
- Adjustable Protractor Stop
- Heavy-Duty Ball Bearing Hinge Points







# SECTION 1: SAFETY

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

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

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

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

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

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

## Safety Instructions for Machinery

### **WARNING**

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

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

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

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

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

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

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



# WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Metal Shears

## WARNING

**AMPUTATION HAZARD.** The shear blades can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from the blades during operation.

**SHARP METAL EDGES.** Sharp edges on newly cut sheet metal workpieces can easily cause deep cuts while handling. Wear leather gloves to help protect your hands when handling workpieces, and always chamfer and debur sharp workpiece edges.

**PROPER WORKPIECE MATERIAL.** This shear is only intended for cutting ferrous and non-ferrous sheet metal or flat stock. Do not attempt to cut round metal stock, glass, wood, drywall, backer board, plywood, or other material not intended for this machine. Cutting incorrect materials can produce unexpected results, which increases the risk of injury, and may result in damage to the machine.

**SECURE SHEAR BEFORE USE.** Before using, fasten shear to a sturdy surface that can withstand the dynamic forces involved in shearing sheet metal. Otherwise, shear may unexpectedly move or fall, causing serious injury or property damage.

**STABLE FOOTING.** This shear requires you to apply a moderate/high level force while cutting. Without stable footing, you could slip or fall, which could cause personal injury. Always stand with both feet comfortably on a non-slip surface during operation.

**BODY POSITION.** The forces and body motion required to operate this shear can result in operator injury over time if proper technique is not used. Always keep your body centered with the machine and your back straight when applying pressure against handles.

**BLADE CONDITION.** Blades that are sharp, undamaged, and properly adjusted will reduce risk of injury and improve cutting results. Always keep blades properly maintained.

**BLADE GUARD.** The blade guard is designed to reduce risk of amputation. Always keep guard properly attached and in good condition during operation.

**RATED CAPACITY.** Only use sheet metal that is within the rated capacity of this shear (refer to the **Machine Data Sheets** on **Page 5** and **6**).

## 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.



# SECTION 2: SETUP

## Unpacking

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

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



## Needed for Setup

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

Description	Qty
• Additional People .....	As Needed
• Safety Glasses .....	1 for Each Person
• Cleaner/Degreaser ( <b>Page 11</b> ).....	As Needed
• Disposable Shop Rags.....	As Needed
• Hex Wrench 4mm, 5mm, 6mm .....	1 Each
• Open-End Wrench 14mm.....	2
• Mounting Hardware ( <b>Page 13</b> ) ...	As Needed
• Forklift.....	1
• Lifting Straps (rated for 500 lbs.).....	2

## 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.

G0828/G0829 Inventory (Figure 3)	Qty
A. Machine Base (Not Shown).....	1
B. Work Stop Adjustment Assembly .....	1
C. Cap Screws M8-1.25 x 15 .....	3
D. Work Stop Support Rods .....	2
E. Cutting Lever .....	1

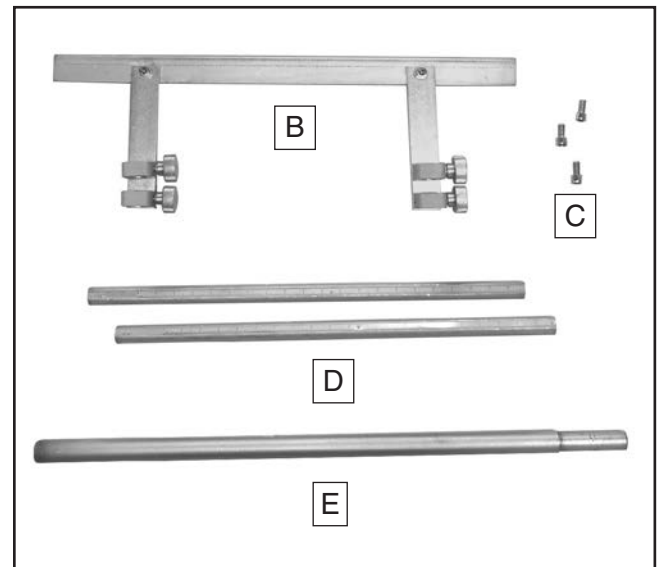


Figure 3. G0828/G0829 inventory.

## NOTICE

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



# Cleanup

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

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

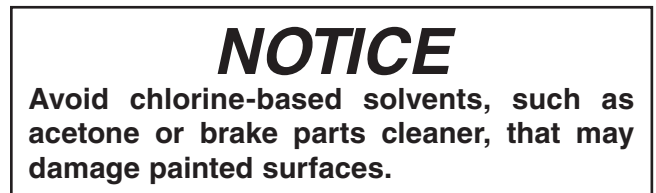
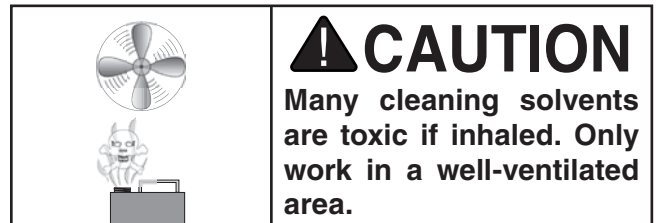
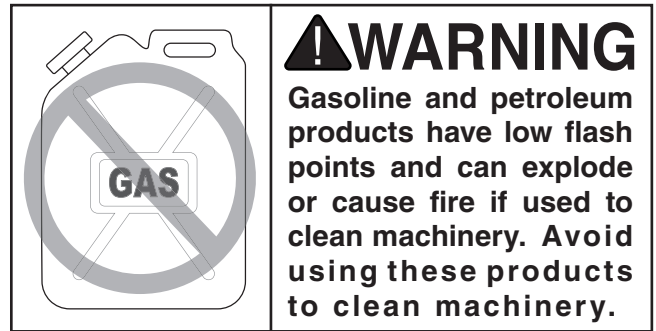
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## Before cleaning, gather the following:

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

## Basic steps for removing rust preventative:

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



## T23692—Orange Power Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.



Figure 4. T23692 Orange Power Degreaser.



# Site Considerations

## Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of 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 is outside 41°–104°F; the relative humidity range is outside 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

## 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.**

## 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.

## 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.

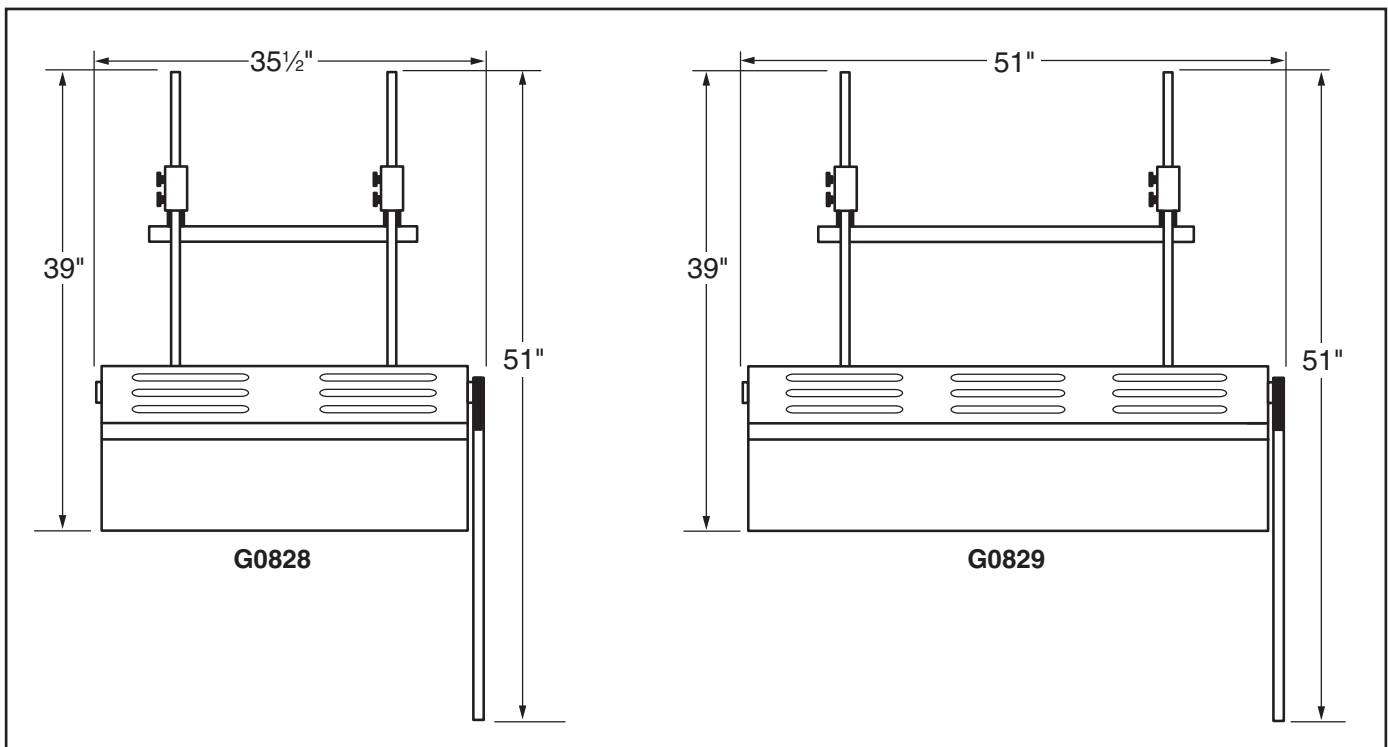
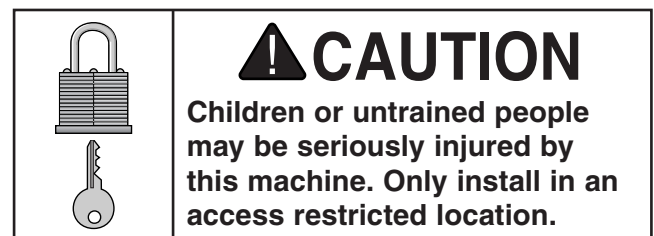
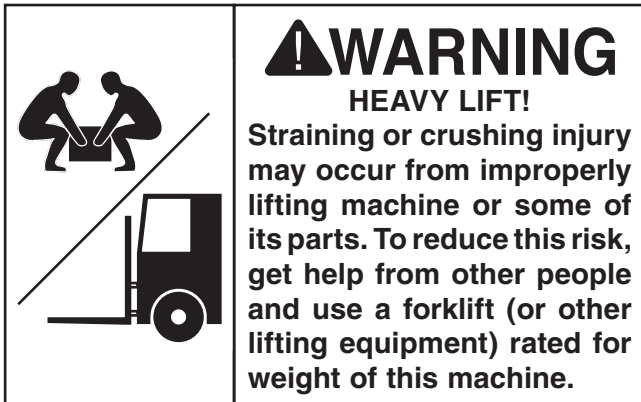


Figure 5. Working clearances.



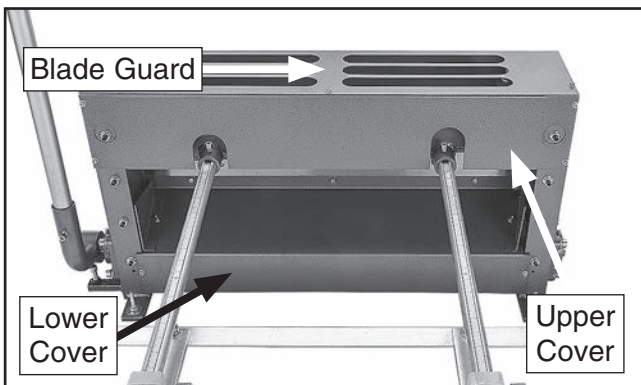


# Lifting & Placing



## To lift and place shear on workbench:

1. Move shear to installation location while it is still on shipping pallet.
2. To avoid damage from lifting straps, remove M6-1 x 12 cap screws and 6mm flat washers (14 on G0828, 16 on G0829) securing lower cover, blade guard, and upper cover, (see **Figure 6**).



**Figure 6.** Remove guard and covers before connecting lifting straps (G0828 shown).

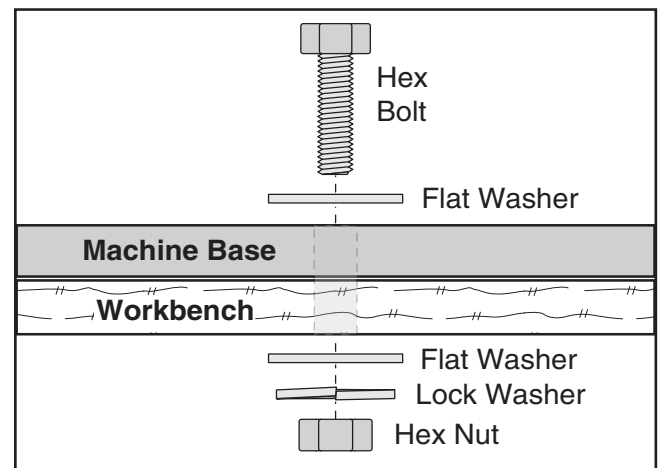
3. Remove fasteners securing shear to pallet. Save hardware for mounting in **Step 7**.
4. Position straps under shear and attach to forklift. Or, with help from others, lift shear onto workbench and proceed to **Step 6**.
5. Use forklift to raise shear. Remove pallet, then lower shear onto workbench.
6. Re-install guard and covers removed in **Step 2**.

7. Fasten shear to workbench as recommended in **Bench Mounting**.

# Bench Mounting

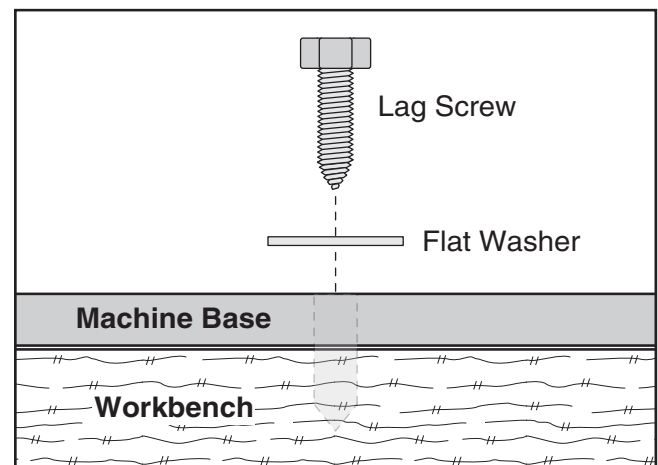
The base of this machine has mounting holes that allow it to be fastened to a workbench or other mounting surface to prevent it from moving during operation and causing accidental injury or damage.

The strongest mounting option is a "Through Mount" (see example below) where holes are drilled all the way through the workbench—and hex bolts, washers, and hex nuts are used to secure the machine in place.



**Figure 7.** Workbench through mount.

Another option is a "Direct Mount" (see example below) where the machine is secured directly to the workbench with lag screws and washers.



**Figure 8.** Workbench direct mount.





# Leveling

Leveling the shear helps the blades and other cast-iron components remain straight and flat during the life of the machine. Components on an unlevelled machine may slowly twist over time due to the dynamic loads placed on the machine during operation. Twisted components will impair the ability of the machine to cut straight or square.

If needed, use metal shims between the base and the workbench to level the machine. Measure with a precision level that is at least 12" long and sensitive enough to show a distance movement when a 0.003" shim is placed under one end of the level.

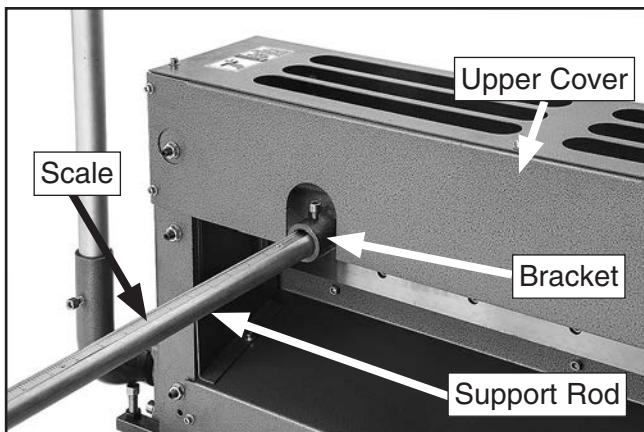
# Assembly

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).

Assembly of the Model G0828/G0829 consists of attaching the work stop support rods, work stop adjustment assembly, and cutting lever.

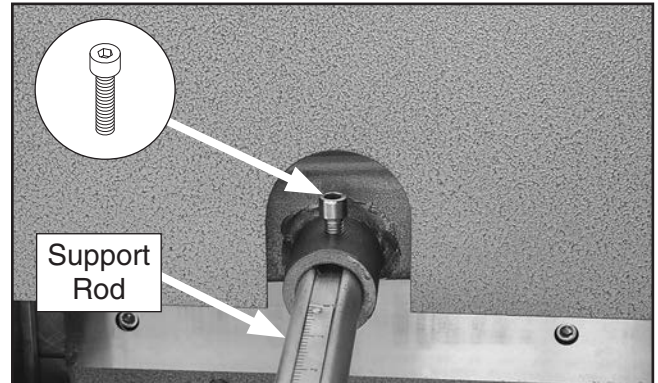
## To assemble shear:

1. Slide support rod into each bracket with measurement scale facing up (see **Figure 9**).



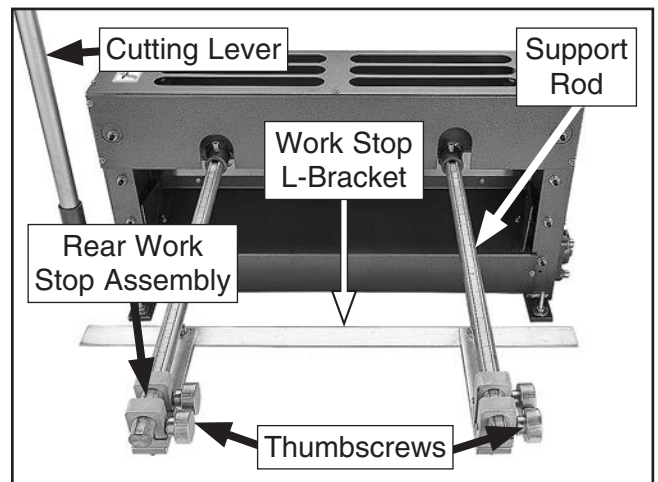
**Figure 9.** Connecting support rod to bracket.

2. Remove blade guard and upper cover.
3. Secure each support rod with (1) M8-1.25 x 15 cap screw (see **Figure 10**).



**Figure 10.** Support rod secured with cap screw.

3. Slide work stop adjustment assembly onto support rods, as shown in **Figure 11**, with flat side of L-bracket closest to shear. Tighten (4) knurled thumbscrews.



**Figure 11.** Work stop adjustment assembly installed.

4. Attach cutting lever and secure with pre-installed M8-1.25 x 10 set screw.



# SECTION 3: 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.

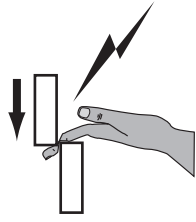
	<p><b>!WARNING</b> To reduce your risk of serious injury, read this entire manual <b>BEFORE</b> using machine.</p>
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<p><b>!WARNING</b> Bodily injury could result from using this machine. Always wear safety glasses, leather work boots, and heavy duty leather work gloves when operating this machine or whenever handling sheet metal.</p>
---



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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts rear work stop for length of cut.
3. Puts on safety glasses, leather boots, and leather gloves.
4. Places workpiece on bed and up against side work stop.
5. Slides workpiece under blades and against rear work stop.
6. Using good body position, firmly pulls down on cutting lever to make cut.
7. Lifts cutting lever and removes workpiece or repeats **Steps 5–6** to make additional cuts.

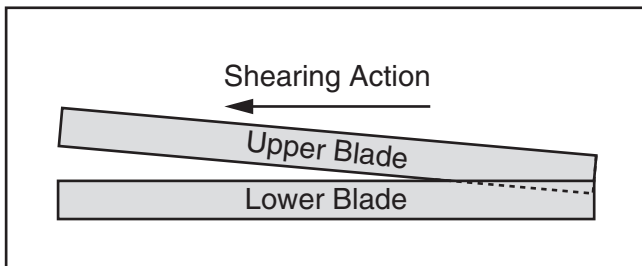
	<p><b>!WARNING</b> The shear blades or hold-down can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from the blades and hold-down during operation.</p>
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<p><b>NOTICE</b> If you are not experienced with this type of machine, <b>WE STRONGLY RECOMMEND</b> 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.</p>
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# Cutting Tips

- Keep the upper blade properly adjusted to the lower blade (refer to **Adjusting Blade Gap** on **Page 24** for detailed instructions). This will help ensure good cutting results and avoid blade damage.
- Before each operation, clear cut-offs or debris away from the shear.
- Make sure the 90° guide is square with the blades (see **Page 18**). This will help ensure the cut is square.
- Use the cutting lever to engage the hold-down bar with the workpiece, then check the workpiece position. If it is correct, continue lowering the cutting lever to complete the cut.
- The shearing action of the blades works similarly to a pair of scissors (see the illustration in **Figure 12**). Use even pressure on the cutting lever to produce good results.

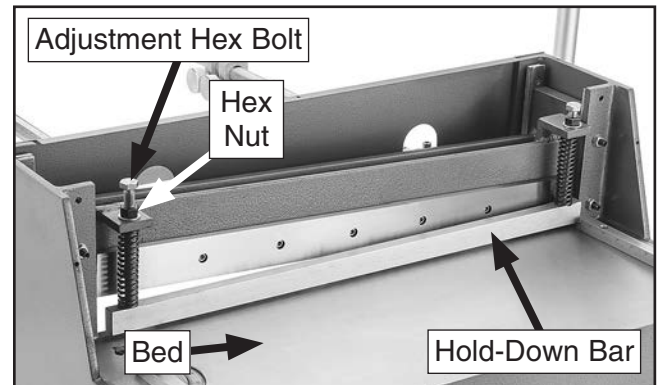


**Figure 12.** Blade shearing action.

# Adjusting Hold-Down Bar

The hold-down bar secures the workpiece to the bed before the blades shear the workpiece.

The hold-down bar is adjustable for height. The G0828 uses two adjustment hex bolts and hex nuts (see **Figure 13**). The G0829 uses three adjustment hex bolts and hex nuts.



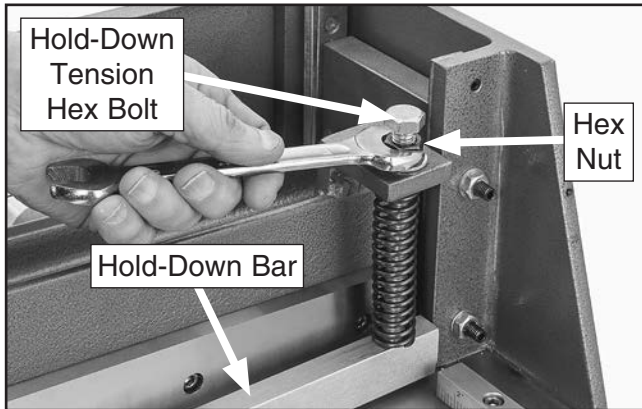
**Figure 13.** Hold-down bar adjustment (G0828 shown).

<b>Tools Needed</b>	<b>Qty</b>
Open-End Wrenches 18mm.....	2
Hex Wrench 4mm.....	1
Ruler or Depth Gauge .....	1



### To adjust height of hold-down bar:

1. Remove blade guard.
2. With blade raised, loosen hex nut, then rotate hold-down tension hex bolt (see **Figure 14**) to raise/lower hold-down bar to adjust clearance.



**Figure 14.** Loosening hex nut to adjust hold-down bar clearance.

3. Measure clearance between hold-down bar and bed to ensure it is even side to side. Adjust as necessary.
4. When clearance is even, tighten hex nut and re-install blade guard.

# Adjusting Rear Work Stop

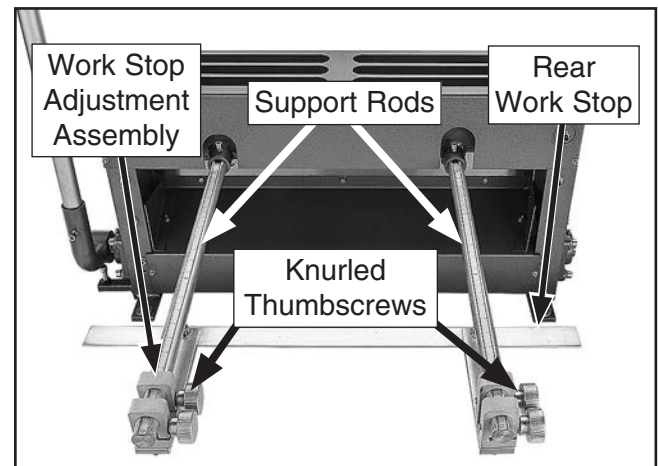
The rear work stop is used for making repetitive cuts. The adjustable assemblies allow for precise positioning of the work stop.

### To position rear work stop:

1. Slide work stop adjustment assembly evenly along support rods so rear work stop leading edge is at approximate desired distance from cutting edges of blades (see **Figure 15**).

**Note:** Move work stop assembly evenly on both sides to keep it parallel with blades. Use scales on top of support rods for approximate positioning. Use fine ruler or tape measure for precise positioning.

2. To keep rear work stop assemblies secured in desired position, tighten knurled thumbscrews (see **Figure 15**).



**Figure 15.** Rear work stop controls.

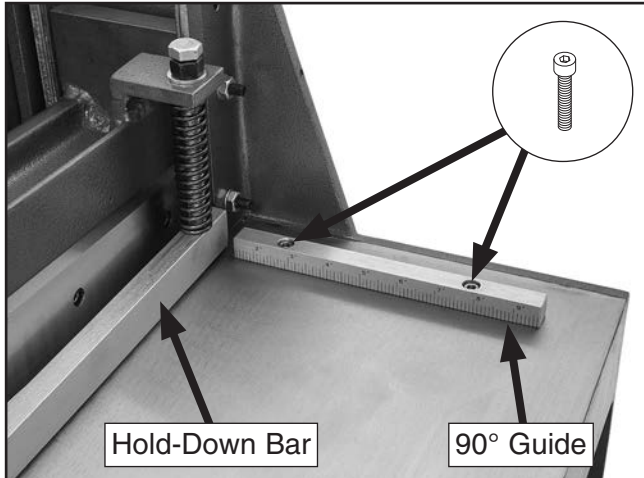
### To adjust rear work stop assembly position:

1. Measure distance between cutting edge of bed and leading edge of work stop. Compare to scale measurement on each support rod.
2. If measurement *does not* match scale, loosen cap screws securing support rods and adjust each one until measurements match.
3. Re-tighten cap screws to secure support rods.



# Adjusting 90° Guide

The 90° guide (see **Figure 16**) helps the operator square the workpiece with the blades. To work properly, it must be square with the blades.



**Figure 16.** 90° guide (blade cover removed for clarity).

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

## To square 90° guide with upper blade:

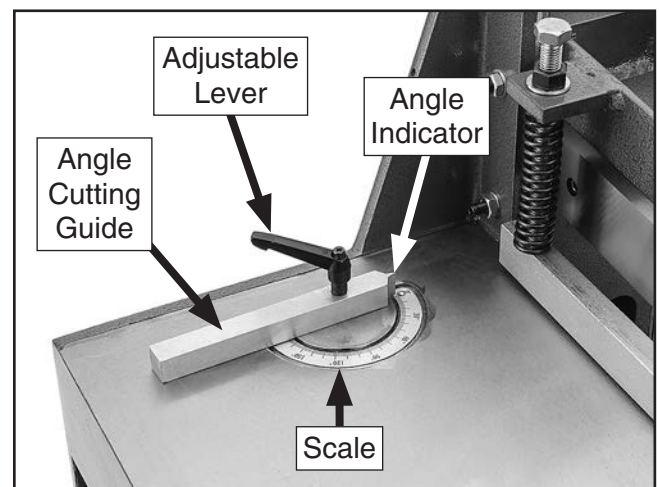
1. Loosen (2) cap screws securing 90° guide.
2. Use cutting lever to fully lower blade.
3. Place square against hold-down bar and 90° guide.
4. Keeping square even against hold-down bar, adjust 90° guide so it is even against square, then re-tighten cap screws on 90° guide to secure setting.
5. Lift cutting lever to return blade to up position.

# Using Angle Cutting Guide

Use the angle cutting guide as a side work stop to cut a workpiece at an angle other than 90°.

## To use angle cutting guide:

1. Calculate angle of cut and mark on workpiece.
2. Loosen adjustable lever on angle cutting guide, use scale to set angle to match desired cut, then tighten lever (see **Figure 17**).



**Figure 17.** G0828/G0829 angle cutting guide (blade cover removed for clarity).

3. Align workpiece with angle cutting guide and position cut mark beneath blade to verify cut angle.
4. Pull cutting lever to cut workpiece.





# SECTION 4: 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.

### **T25208—23-Pc. Deburring Set**

Includes: 380-0060 double burr; 2-piece 380-0088 handle; 380-0097, 380-0098, and 380-0091 holders; D25 and D40 scrapers; C20 countersink; ES100 and ES200 blades (5 each); V13, and A13 blades; wrench and hex wrenches; and case.



Figure 18. Model T25208 Deburring Set.

### **H5614—Sheet Metal Gauge US Standard**

Calibrated for sheet metal sized from 0- to 30-gauge. The front is marked with gauge sizes, the back is marked with actual inch measurements.

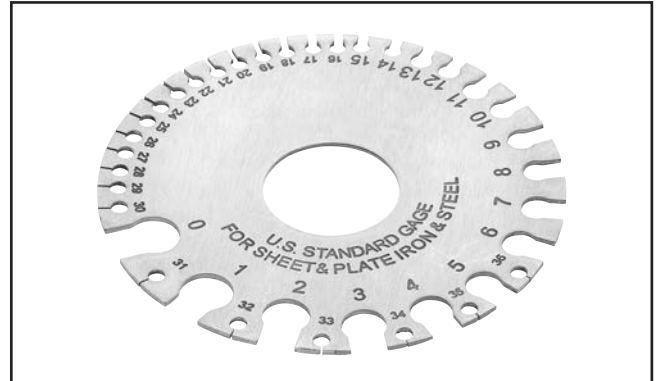


Figure 19. H5614 Sheet Metal Gauge.

## **Recommended Metal Protectants**

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

H3788—G96® Gun Treatment 12 oz Spray

H3789—G96® Gun Treatment 4.5 oz Spray



Figure 20. Recommended products for protecting unpainted cast-iron/steel parts on machinery.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



## Basic Eye Protection

T20501—Face Shield Crown Protector 4"

T20502—Face Shield Crown Protector 7"

T20503—Face Shield Window

T20451—"Kirova" Clear Safety Glasses

T20452—"Kirova" Anti-Reflective S. Glasses

H7194—Bifocal Safety Glasses 1.5

H7195—Bifocal Safety Glasses 2.0

H7196—Bifocal Safety Glasses 2.5



Figure 21. Assortment of basic eye protection.

## T21318—36" Slip Roll, 22 Gauge

Slip roll up to 36" wide and 22-gauge mild steel with this benchtop sheet metal roller. Cast-iron construction and 2" diameter ground and polished rolls make this slip roll ideal for many fabricating uses. Features heavy bearings and gearing, precision-ground cast-iron rollers, and the ability to slip roll 3/16"-5/16" diameter rod/wire stock.



Figure 22. Model T21318 36" Slip Roll.

## T10456—Heavy-Duty Anti-Fatigue Mat 3' x 5'

This heavy-duty anti-fatigue mat features beveled edges and no-slip tread for safety and comfort. Open-hole design allows liquid to drain through, so it's perfect for wet or oily conditions. Measures 3' wide x 5' long x 3/8" thick.

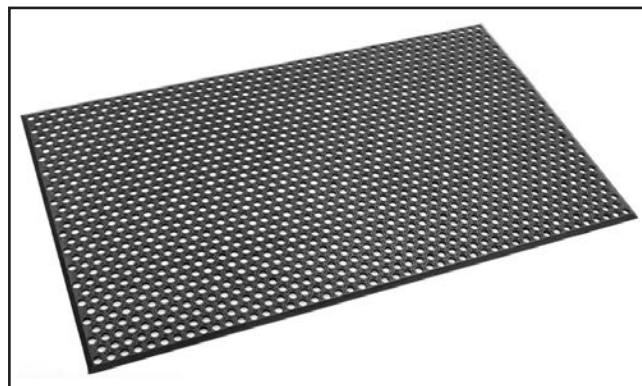


Figure 23. Model T10456 Anti-Fatigue Mat.

## G8782—10" Aviation Tin Snips - 3 pc. Set

Precision, hardened-steel cutting jaws ensure that you'll enjoy quality results each time you cut sheet metal. Color-coded to provide quick identification, these snips feature thick grips for cutting comfort and a positive lock to prevent accidents. An efficient, economical alternative to high-priced, name-brand aviation snips.



Figure 24. Model G8782 10" Tin Snips.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**





**G0830—5" x 6" VS Metal-Cutting Bandsaw Set**  
 Compact and powerful, the G0830 Metal-Cutting Bandsaw provides variable-speed blade control from 82–230 FPM, allowing you to conveniently "dial-in" the optimum cutting speed for nearly any type of metal workpiece size without having to first stop and change belt positions. Cut through round stock up to 5" in diameter and rectangular cuts up to 4-1/2" x 6" thick with ease.



**Figure 25.** Model G0830 5" x 6" Variable-Speed Metal-Cutting Bandsaw.

**H2867—Electric Sheet-Metal Shear**

This electric sheet-metal shear is double insulated and features a 110V, 2.4A motor with 4500 strokes per minute. Width of cut: 5/32". Cuts 1/16" mild steel and 3/64" stainless steel. Weighs 4 lbs. Made in an ISO 9001 factory.



**Figure 26.** Model H2867 Electric Sheet Metal Shear.

**G8780—Portable Hand Punch**

Producing 1 ton of force, this hand punch has a 16-gauge capacity in mild steel, brass and aluminum. Much quicker and safer than drilling thin stock and leaves no ragged edges. Includes 3/32", 1/8", 5/32", 3/16", 7/32", 1/4" and 9/32" dies and wrenches.



**Figure 27.** Model G8780 Portable Hand Punch.

**T23085—Pneumatic Nibbler**

This pneumatic nibbler features a lightweight aluminum housing and cuts up to 16-gauge steel without leaving burrs or deformed edges. Adjustable die can be turned to suit various cutting positions. Cuts at 3800 strokes per minute. Features 1/4" NPT air inlet and working pressure of 90 PSI.



**Figure 28.** Model T23085 Pneumatic Nibbler.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



# SECTION 5: MAINTENANCE

## Schedule

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

### Daily:

- Loose mounting bolts.
- Loose or damaged blade guard.
- Damaged or worn blades.
- Loose or bent support rods.
- Any other unsafe condition.

### Weekly:

- Lubricate copper gibs.

### Annually:

- Lubricate pivot cartridge bearings.

## Cleaning & Protecting

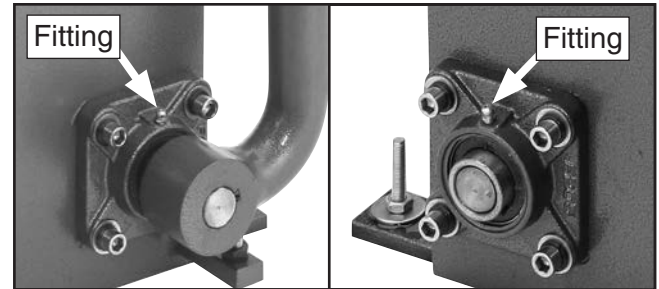
Use a brush to clear away any metal debris from the blades, hold-down bar, and the bed area in front of the blades. Use a shop rag to carefully apply a thin coat of quality metal protectant (see **Page 19** for offerings from Grizzly) to all exposed surfaces of the blades to prevent corrosion.

## Lubrication

### Pillow Bearings

Grease Type ..... Mobil 1 or NLGI#2 Equivalent  
 Grease Amount ..... One Pump  
 Lubrication Frequency ..... Annually

Clean the grease fittings (see **Figure 29**) to prevent any contamination. Fit the nozzle of the grease gun over the fitting and add one pump of grease.

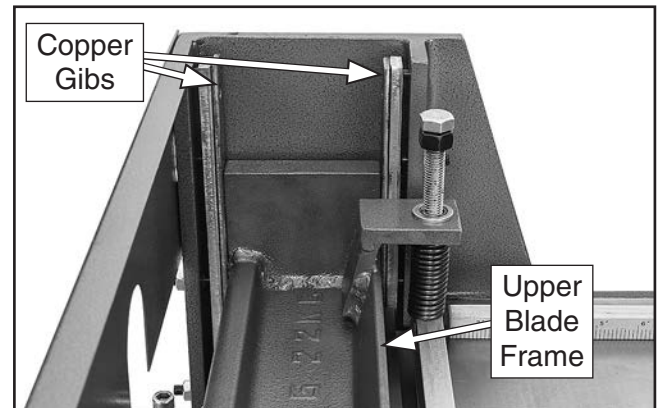


**Figure 29.** Pillow bearing grease fittings.

### Copper Gibs

Oil Type ..... ISO 68 or Equivalent  
 Lubrication Frequency ..... Weekly

Each end of the upper blade frame slides between two copper gibs (see **Figure 30**). Lubricate the sliding surfaces of the copper gibs with a light film of ISO 68 oil or equivalent.



**Figure 30.** Lubricate the copper gibs with the upper blade frame fully lowered.

### Tool Needed

Hex Wrench 4mm..... Qty 1

### To lubricate copper gibs:

Fully lower blade. With hex wrench, remove blade cover. Lubricate exposed areas of copper gibs. Raise and lower cutting lever several times to spread lubricant. Replace blade cover.



# SECTION 6: SERVICE

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

## Troubleshooting

Symptom	Possible Cause	Possible Solution
Shear will not cut workpiece.	<ol style="list-style-type: none"> <li>1. Workpiece thickness exceeds shear capacity.</li> <li>2. Blades worn or damaged.</li> <li>3. Blade gap not correct.</li> <li>4. Not enough pressure applied to cutting lever.</li> </ol>	<ol style="list-style-type: none"> <li>1. Only use workpiece material that is within shear capacity (<b>Pages 5–6</b>).</li> <li>2. Sharpen/replace blades (<b>Page 25</b>).</li> <li>3. Properly adjust blade gap (<b>Page 24</b>).</li> <li>3. Safely increase pressure on cutting lever.</li> </ol>
Cuts are not square.	<ol style="list-style-type: none"> <li>1. 90° guide not square with blades.</li> <li>2. Rear work stop not parallel to blades.</li> <li>3. Hold-down bar not properly securing workpiece during cut.</li> <li>4. Blade gap not correct.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust 90° guide square with blades (<b>Page 18</b>).</li> <li>2. Properly adjust rear work stop parallel to blades (<b>Page 17</b>).</li> <li>3. Adjust hold-down bar for even pressure on workpiece (<b>Page 16</b>).</li> <li>4. Properly adjust blade gap (<b>Page 24</b>).</li> </ol>
Poor quality of cuts (ripping or tearing).	<ol style="list-style-type: none"> <li>1. Blade gap not correct.</li> <li>2. Blades worn or damaged.</li> <li>3. Gibs too loose.</li> </ol>	<ol style="list-style-type: none"> <li>1. Properly adjust blade gap (<b>Page 24</b>).</li> <li>2. Sharpen/replace blades (<b>Page 25</b>).</li> <li>3. Properly adjust gibs (<b>Page 27</b>).</li> </ol>
Arm difficult to use.	<ol style="list-style-type: none"> <li>1. Blade gap not correct.</li> <li>2. Cutting lever movement difficult.</li> <li>3. Gibs too tight.</li> </ol>	<ol style="list-style-type: none"> <li>1. Properly adjust blade gap (<b>Page 24</b>).</li> <li>2. Lubricate pillow bearings (<b>Page 22</b>) and copper gibs (<b>Page 22</b>).</li> <li>3. Properly adjust gibs (<b>Page 27</b>).</li> </ol>



# Adjusting Blade Gap

The gap between the upper and lower blades (as they pass each other) must remain even along the length of the blades to produce clean cuts. Initially, this adjustment has been made at the factory. However, over time and with normal wear, you may need to re-adjust the blade gap.

If the blade gap is too wide, the workpiece will not cut correctly and show signs of bending, ripping, or tearing. If the blade gap is too narrow, the upper blade will have difficulty lowering past the lower blade and the cutting edges may become damaged.

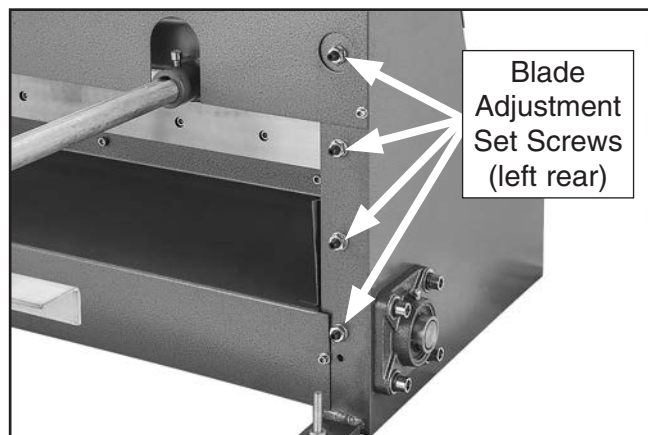
## Checking Blade Gap

Use the shear to cut a piece of paper along the full length of the blades. All cuts should be sharp without bending or tearing the paper.

- If the blades do not cut the paper cleanly on one end of the shear, the upper blade needs to be adjusted on that end.
- If the blades do not cut the paper cleanly along the entire length of the blades, both ends of the upper blade need to be adjusted.

## Adjusting Upper Blade

The blade gap is controlled by four set screws and hex nuts on the front and rear of each side of the upper blade base (see **Figure 31**).



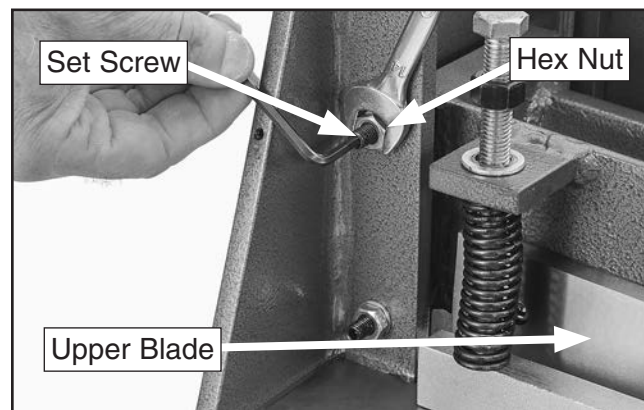
**Figure 31.** Upper blade adjustment set screws (4 of 16 shown) on the G0828 and G0829.

If the paper *does not* cut cleanly after proper adjustment of the upper blade, the blades may need to be sharpened or replaced (refer to **Replacing Blades on Page 25**).

Tools Needed	Qty
Open-End Wrench 14mm.....	1
Hex Wrench 4mm.....	1
Feeler Gauge 0.002" .....	1

### To adjust upper blade:

1. Remove blade guard.
2. Loosen hex nuts on set screws identified for adjustment in **Checking Blade Gap** (see **Figure 32**).



**Figure 32.** Adjusting set screws to align upper blade with lower blade.

3. Use feeler gauge to adjust blade gap to 0.002":
  - To move blade toward front, rotate rear set screws clockwise and front set screws counterclockwise.
  - To move blade toward back, rotate rear set screws counterclockwise and front set screws clockwise.
4. Repeat previous **Checking Blade Gap** procedure to test adjustments.
  - If blade gap is correct, hold each set screw in position and tighten its hex nut.
  - If blade gap is not correct, repeat **Steps 2–4** until cut is even.
5. Re-install blade guard when complete.





# Replacing Blades

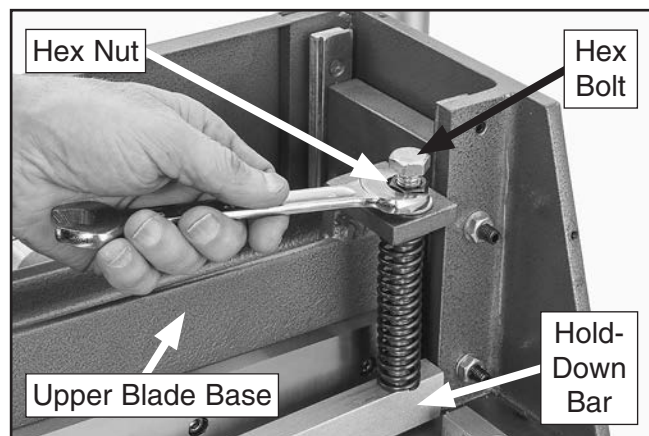
Both upper and lower blades are identical and have two cutting edges, so that if one cutting edge becomes dull, you can reverse the blade and use the fresh, sharp cutting edge. Both blades can be resharpened as an alternative to replacing.

If both cutting edges are dull, re-sharpen the blades on a surface grinder and make sure they stay flat along their entire length. If the blade becomes too thin and the cap screws that secure it extend beyond the opposite side of the cutting edge, you will need to replace it. If the blade is nicked or damaged, replace it. Contact Grizzly at (800) 523-4777 or online at [grizzly.com](http://grizzly.com) to purchase Part No. **P08280010** (Model G0828), or **P08290010** (Model G0829). Keep an extra set of blades on hand to avoid downtime.

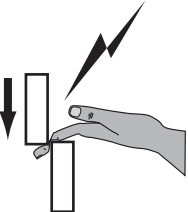
Items Needed	Qty
Another Person.....	1
Wood Block 2x4 .....	1
Heavy Leather Work Gloves.....	1
Hex Wrench 4mm, 5mm.....	1
Open-End Wrench 18mm.....	1

## To remove/re-install upper blade:

1. Remove blade guard.
2. Loosen hex nut, then loosen hex bolt to release spring tension on hold-down bar (see **Figure 33**).

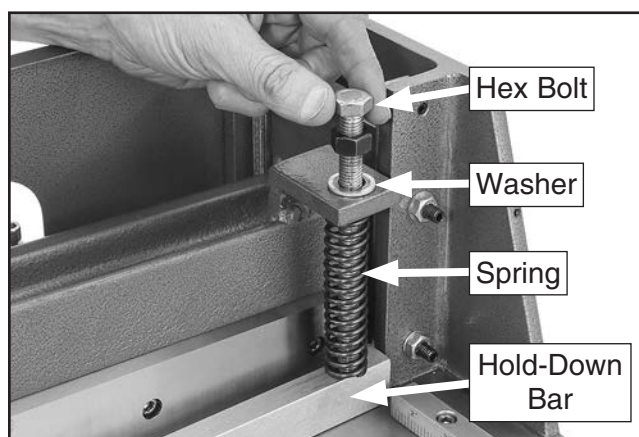


**Figure 33.** Loosening hex nut to release spring tension on hold-down bar.



**!WARNING**  
The shear blades or hold-down bar can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from the blades and hold-down bar when removing blades.

3. Unscrew hex bolt from hold-down bar, then remove spring, flat washer, and hold-down bar (see **Figure 34**).



**Figure 34.** Removing hold-down bar.

4. With blade fully raised, place wood block under open side of upper blade to prevent it from dropping in **Step 5** (see **Figure 35**).



**Figure 35.** Use a wood block to keep blade from dropping during the removal process.

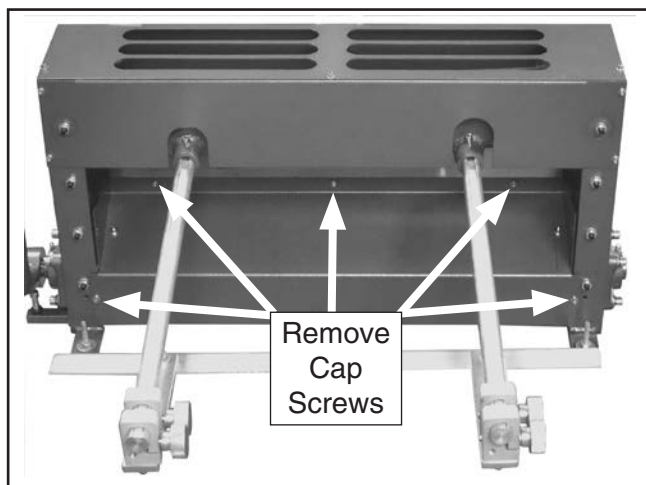
5. Remove cap screws (7 on G0828; 11 on G0829) and blade. Have another person wearing heavy leather work gloves hold blade during removal.



6. Clean blade with mineral spirits, then apply thin coat of quality metal protectant before re-installing blade.
7. Reverse **Steps 1–5** to re-install blade.

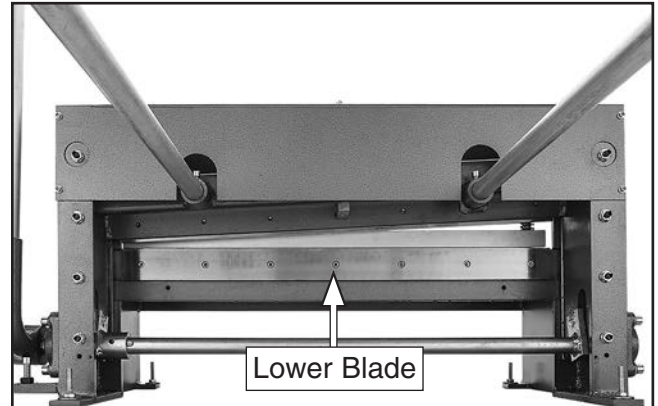
**To remove/re-install lower blade:**

1. Loosen cap screws securing support rods to rear work stop assembly. Remove assembly.
2. Remove (2) outer cap screws from lower cover, and cap screws (3 on G0828; 5 on G0829) from upper cover (see **Figure 36**).



**Figure 36.** Remove rear lower cover cap screws to access lower blade (G0828 shown).

3. Loosen cap screws securing lower blade to frame (see **Figure 37**). G0828 uses 7 cap screws; G0829 uses 11 cap screws.



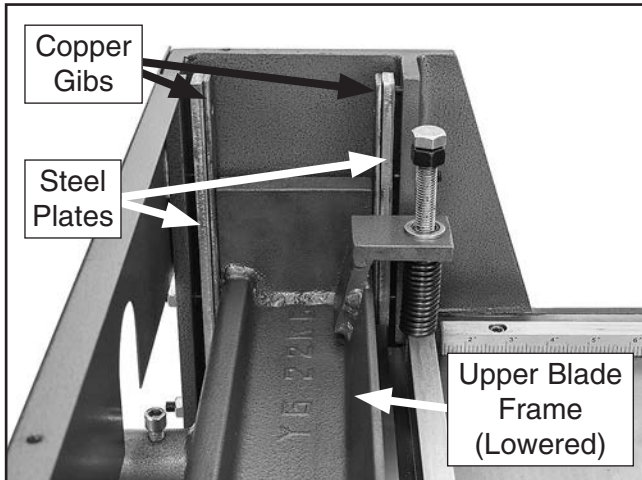
**Figure 37.** Lower blade removal (viewed from bottom).

4. Have another person wearing heavy leather work gloves support blade and remove it.
5. Clean blade with mineral spirits, then apply thin coat of quality metal protectant before re-installing blade.
6. Reverse **Steps 1–3** to re-install blade.
7. Check and adjust blade gap, following procedures on **Page 24**.



# Adjusting Gibs

There are two copper gibs on each end of the upper blade base (see **Figure 38**). They are made of copper so the plates wear instead of the upper blade base. Each copper gib screws into a steel plate and is adjusted with four set screws and hex nuts. The set screws maintain pressure between the copper gibs and upper blade base to keep the movement tight and precise.



**Figure 38.** Gib operation.

If the gibs are too loose, the quality of the cuts will suffer because the movement will be sloppy when the cutting lever is pulled down. If the gibs are too tight, it will be difficult to lower the upper blade, and the cutting edges of the blades may become damaged.

The goal of adjusting the gibs is to keep the front-to-back movement of the sliding shafts snug without interfering with the sliding action.

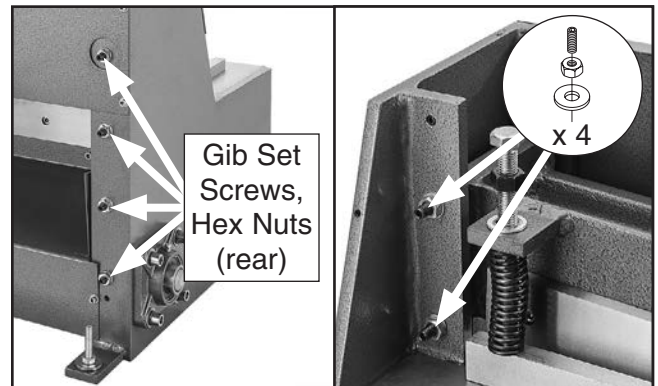
<b>Tools Needed</b>	<b>Qty</b>
Open-End Wrench 14mm.....	1
Hex Wrench 4mm.....	1

**To adjust gibs:**

1. Remove blade guard.

2. On each side of shear, loosen hex nuts on gib set screws (see **Figure 39**).

**Note:** On front, two gib set screws are above bed and two gib set screws are beneath bed.



**Figure 39.** Gib set screws and hex nuts.

3. Using wrench to keep hex nut slack, use hex wrench to tighten all gib set screws in even increments until gibs are snug against upper blade base (see **Figure 40**). Back off each set screw 1/8 turn and hold in place while tightening hex nut.



**Figure 40.** Tightening gib set screw.

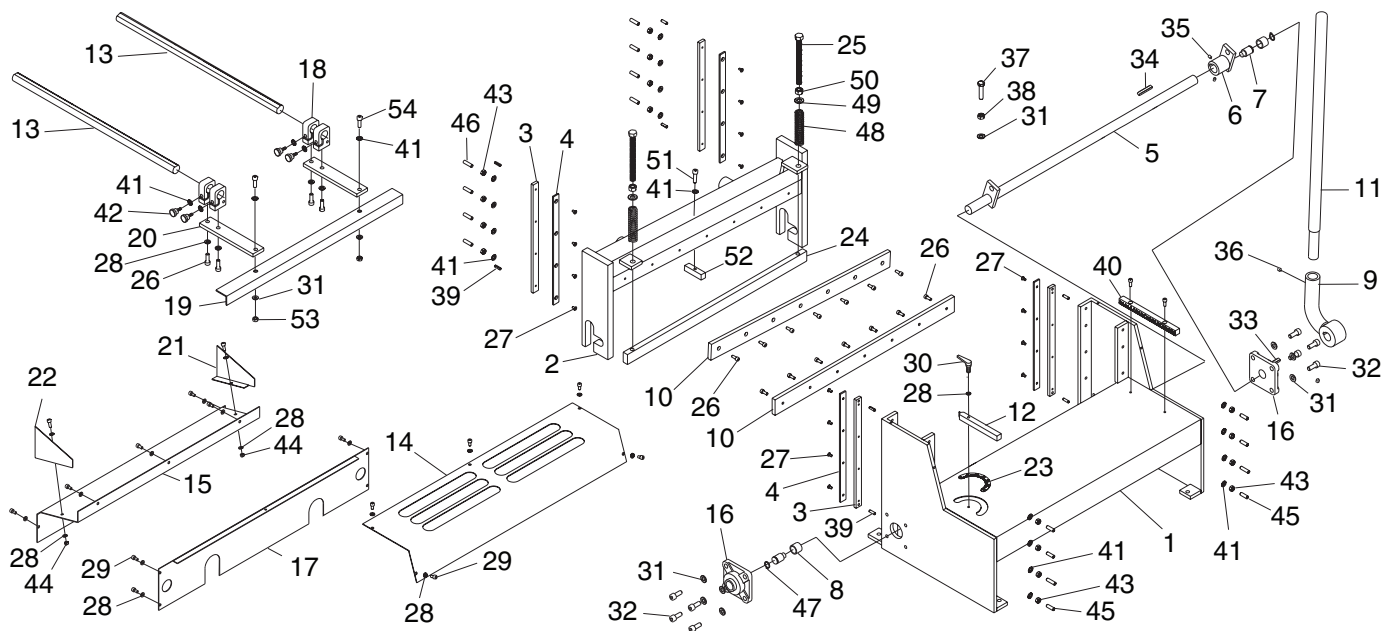
4. Make a test cut to check sliding action of knives. If necessary, rotate set screws clockwise to tighten gib or counterclockwise to loosen, then repeat test cut and adjust until you are satisfied with gib adjustment and shearing action.
5. Hold set screws with hex wrench and re-tighten hex nuts (see **Figure 40**).
6. Check and adjust blade gap (see **Page 24**).
7. Re-install blade guard.





# SECTION 7: PARTS

## G0828 Parts



### REF PART # DESCRIPTION

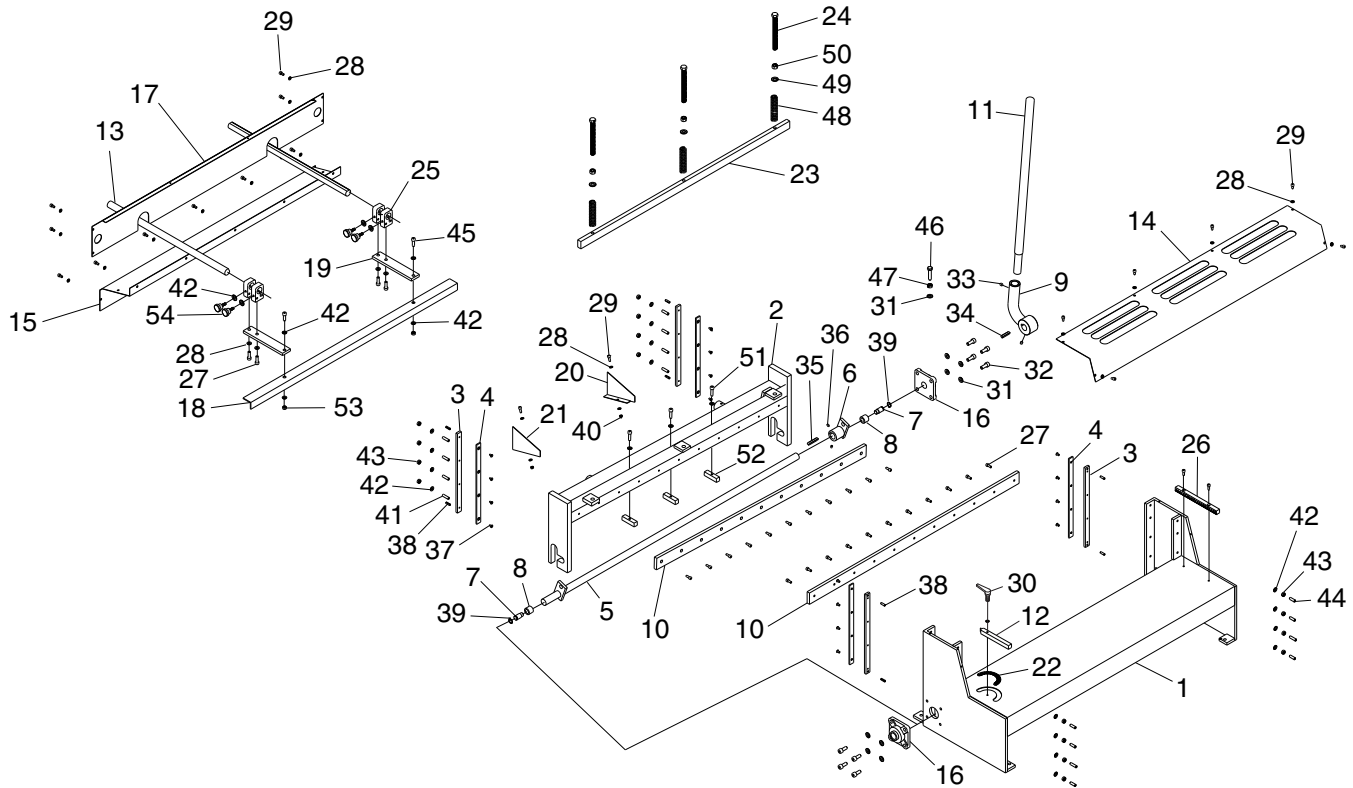
1	P0828001	FRAME
2	P0828002	UPPER BLADE FRAME
3	P0828003	PLATE 8 X 20 X 350 STEEL
4	P0828004	GIB 4 X 20 X 350 COPPER
5	P0828005	CAM COUPLER
6	P0828006	CAM
7	P0828007	CAM SHAFT
8	P0828008	CAM RING
9	P0828009	CAM SHAFT LEVER
10	P0828010	BLADE 11 X 50 X 680MM
11	P0828011	CUTTING LEVER 30 X 800MM
12	P0828012	ANGLE CUTTING GUIDE
13	P0828013	REAR SUPPORT ROD
14	P0828014	BLADE GUARD
15	P0828015	LOWER COVER
16	P0828016	PILLOW BEARING UCF205
17	P0828017	UPPER COVER
18	P0828018	REAR STOP SLIDER BRACKET (ALUM)
19	P0828019	REAR STOP PLATE
20	P0828020	REAR STOP SLIDER PLATE
21	P0828021	LOWER COVER PANEL (L)
22	P0828022	LOWER COVER PANEL (R)
23	P0828023	ANGLE CUTTING SCALE
24	P0828024	HOLD-DOWN BAR
25	P0828025	HEX BOLT M12-1.75 X 145
26	P0828026	CAP SCREW M6-1 X 16 SS
27	P0828027	FLAT HD SCR M5-.8 X 10

### REF PART # DESCRIPTION

28	P0828028	FLAT WASHER 6MM
29	P0828029	CAP SCREW M6-1 X 12 SS
30	P0828030	ADJUSTABLE HANDLE 49L, M6-1 X 25
31	P0828031	FLAT WASHER 10MM
32	P0828032	CAP SCREW M10-1.5 X 25
33	P0828033	KEY 8 X 8 X 40
34	P0828034	KEY 8 X 8 X 50
35	P0828035	SET SCREW M6-1 X 10
36	P0828036	SET SCREW M8-1.25 X 10
37	P0828037	HEX BOLT M10-1.5 X 45
38	P0828038	HEX NUT M10-1.5
39	P0828039	ROLL PIN 6 X 20
40	P0828040	90° GUIDE
41	P0828041	FLAT WASHER 8MM
42	P0828042	KNURLED THUMB SCREW M8-1.25 X 45
43	P0828-43	HEX NUT M8-1.25
44	P0828044	HEX NUT M6-1
45	P0828045	SET SCREW M8-1.25 X 25
46	P0828046	SET SCREW M8-1.25 X 30
47	P0828047	SHAFT SPACER 16MM
48	P0828048	COMPRESSION SPRING 3 X 22 X 94
49	P0828049	FLAT WASHER 12MM
50	P0828050	HEX NUT M12-1.75
51	P0828051	SET SCREW M8-1.25 X 30
52	P0828052	RETAINING BLOCK
53	P0828053	LOCK NUT M8-1.25
54	P0828054	CAP SCREW M8-1.25 X 25



# G0829 Parts



## REF PART # DESCRIPTION

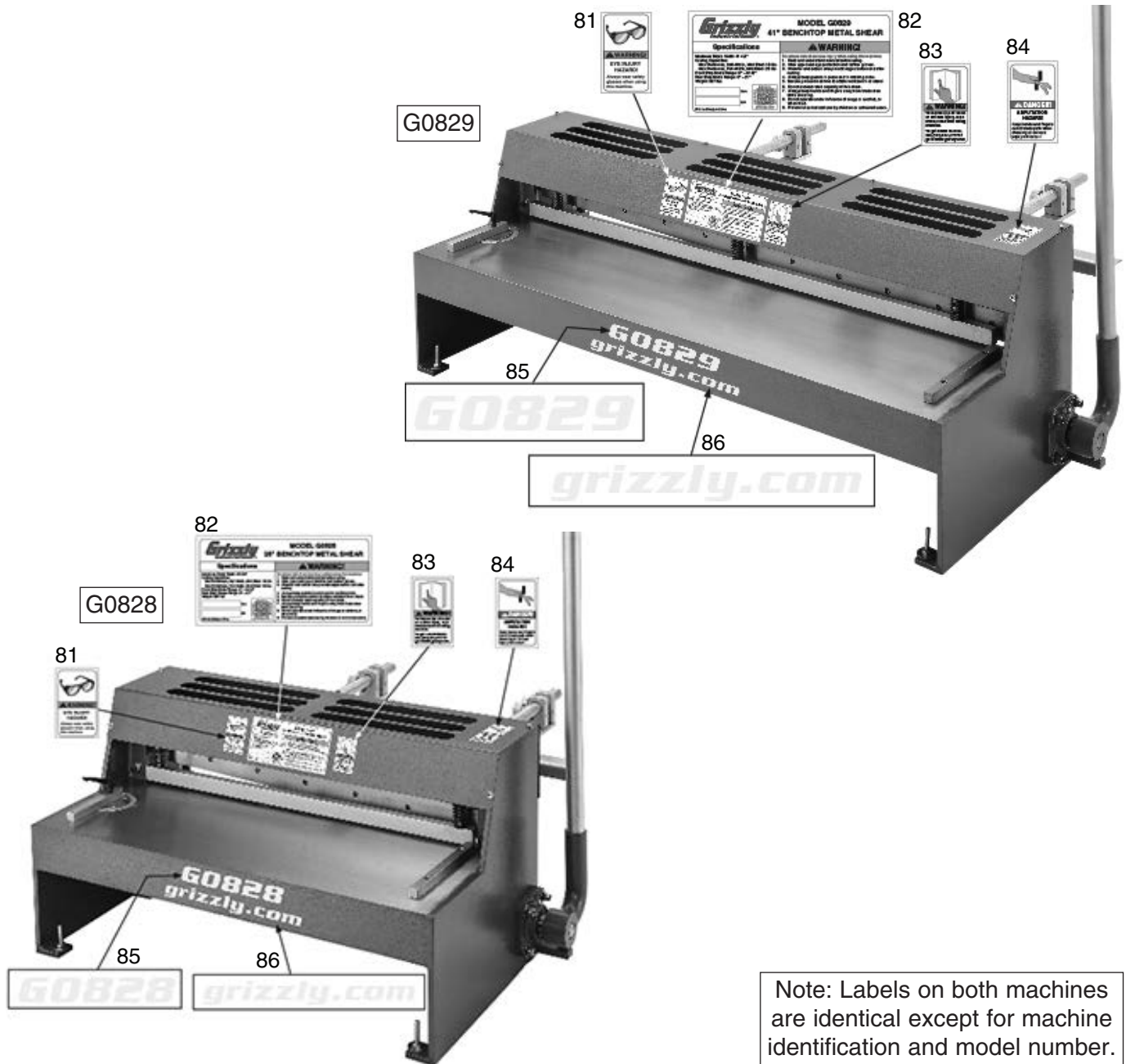
1	P0829001	FRAME
2	P0829002	UPPER BLADE FRAME
3	P0829003	PLATE 8 X 20 X 350 STEEL
4	P0829004	GIB 4 X 20 X 350 COPPER
5	P0829005	CAM COUPLER
6	P0829006	CAM
7	P0829007	CAM SHAFT
8	P0829008	CAM RING
9	P0829009	CAM SHAFT LEVER
10	P0829010	BLADE 11 X 50 X 1075MM
11	P0829011	CUTTING LEVER 30 X 800MM
12	P0829012	ANGLE CUTTING GUIDE
13	P0829013	REAR SUPPORT ROD
14	P0829014	BLADE GUARD
15	P0829015	LOWER COVER
16	P0829016	PILLOW BEARING UCF205
17	P0829017	UPPER COVER
18	P0829018	REAR STOP PLATE
19	P0829019	REAR STOP SLIDER PLATE
20	P0829020	LOWER COVER PANEL (L)
21	P0829021	LOWER COVER PANEL (R)
22	P0829022	ANGLE CUTTING SCALE
23	P0829023	HOLD-DOWN BAR
24	P0829024	HEX BOLT M12-1.75 X 145
25	P0829025	REAR STOP SLIDER BRACKET (ALUM)
26	P0829026	90° GUIDE
27	P0829027	CAP SCREW M6-1 X 16 SS

## REF PART # DESCRIPTION

28	P0829028	FLAT WASHER 6MM
29	P0829029	CAP SCREW M6-1 X 12 SS
30	P0829030	ADJUSTABLE HANDLE 49L, M6-1 X 25
31	P0829031	FLAT WASHER 10MM
32	P0829032	CAP SCREW M10-1.5 X 25
33	P0829033	SET SCREW M8-1.25 X 10
34	P0829034	KEY 8 X 8 X 40
35	P0829035	KEY 8 X 8 X 50
36	P0829036	SET SCREW M6-1 X 10
37	P0829037	FLAT HD SCR M5-.8 X 10
38	P0829038	ROLL PIN 6 X 20
39	P0829039	SHAFT SPACER 16MM
40	P0829040	HEX NUT M6-1
41	P0829041	SET SCREW M8-1.25 X 30
42	P0829042	FLAT WASHER 8MM
43	P0829043	HEX NUT M8-1.25
44	P0829044	SET SCREW M8-1.25 X 25
45	P0829045	CAP SCREW M8-1.25 X 25
46	P0829046	HEX BOLT M10-1.5 X 45
47	P0829047	HEX NUT M10-1.5
48	P0829048	COMPRESSION SPRING 3 X 22 X 94
49	P0829049	FLAT WASHER 12MM
50	P0829050	HEX NUT M12-1.75
51	P0829051	SET SCREW M8-1.25 X 30
52	P0829052	RETAINING BLOCK
53	P0829053	LOCK NUT M8-1.25
54	P0829054	KNURLED THUMB SCREW M8-1.25 X 45



# Labels & Cosmetics



Note: Labels on both machines are identical except for machine identification and model number.

REF	PART #	DESCRIPTION
81	P0828081	SAFETY GLASSES LABEL
82	P0828082	MACHINE ID LABEL (G0828)
82	P0829082	MACHINE ID LABEL (G0829)
83	P0828083	READ MANUAL LABEL
84	P0828084	AMPUTATION DANGER LABEL

REF	PART #	DESCRIPTION
85	P0828085	MODEL NUMBER LABEL (G0828)
85	P0829085	MODEL NUMBER LABEL (G0829)
86	P0828086	GRIZZLY.COM LABEL
87	P0828087	TOUCH-UP PAINT, GRIZZLY GREEN

## **⚠️ 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](http://www.grizzly.com).





# WARRANTY CARD

Name \_\_\_\_\_  
 Street \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Phone # \_\_\_\_\_ Email \_\_\_\_\_  
 Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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

1. How did you learn about us?

Advertisement       Friend       Catalog  
 Card Deck       Website       Other:

2. Which of the following magazines do you subscribe to?

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

3. What is your annual household income?

\$20,000-\$29,000       \$30,000-\$39,000       \$40,000-\$49,000  
 \$50,000-\$59,000       \$60,000-\$69,000       \$70,000+

4. What is your age group?

20-29       30-39       40-49  
 50-59       60-69       70+

5. How long have you been a woodworker/metalworker?

0-2 Years       2-8 Years       8-20 Years       20+ Years

6. How many of your machines or tools are Grizzly?

0-2       3-5       6-9       10+

7. Do you think your machine represents a good value?       Yes       No

8. Would you recommend Grizzly Industrial to a friend?       Yes       No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

**Note:** We never use names more than 3 times.       Yes       No

10. Comments: \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

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Place Stamp Here



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



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name \_\_\_\_\_
Street \_\_\_\_\_
City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

TAPE ALONG EDGES--PLEASE DO NOT STAPLE



# WARRANTY & RETURNS

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

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

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

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

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

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

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