

Grizzly **Industrial, Inc.**®

MODEL G0845P HEAVY-DUTY 50" ELECTRIC METAL SHEAR OWNER'S MANUAL

(For models manufactured since 01/18)



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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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V1.05.18



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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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.

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


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

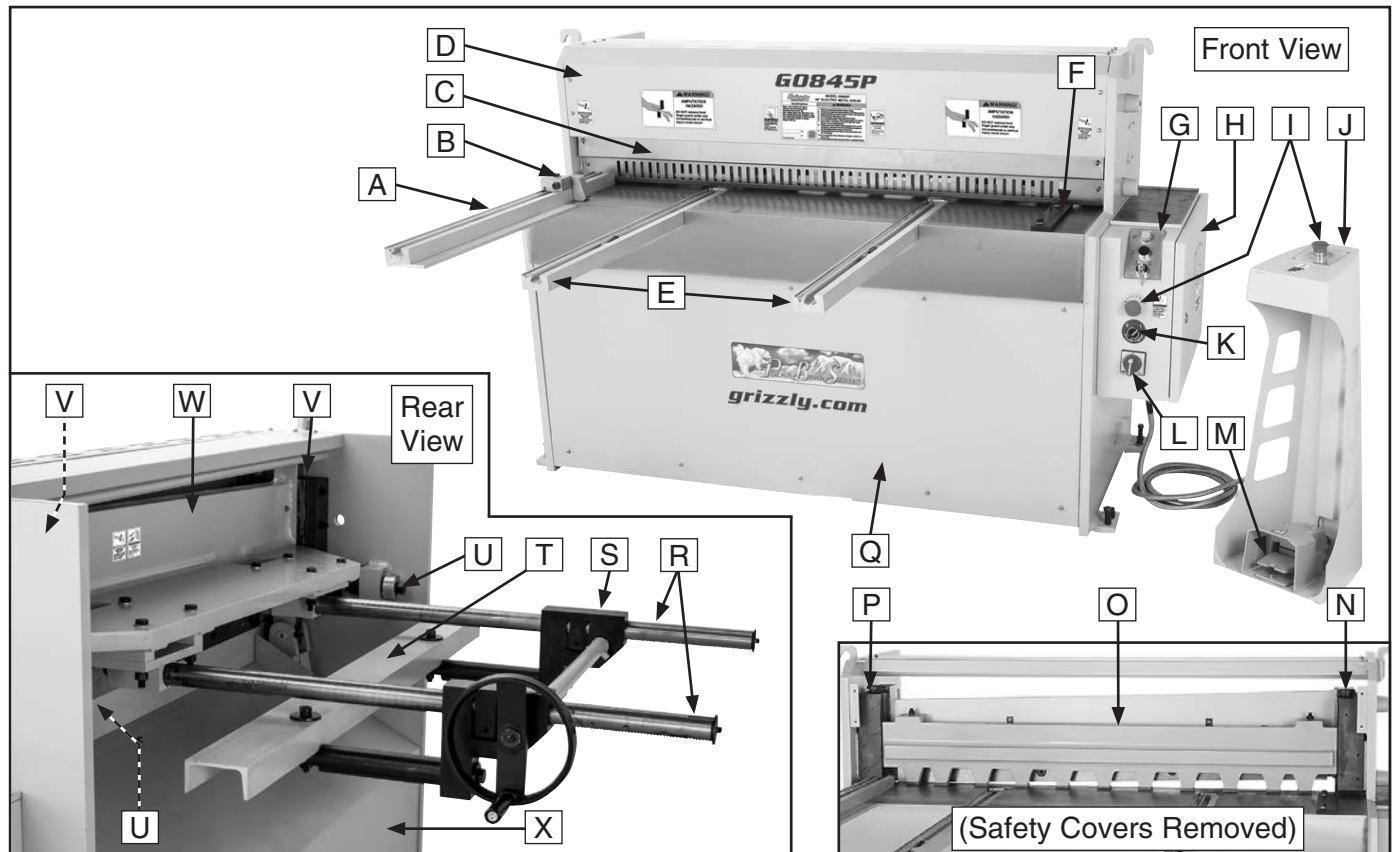
Manufacture Date

Serial Number



Identification

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



- | | |
|----------------------------|--------------------------------|
| A. Left Work Stop | M. Foot Pedal |
| B. Adjustable Stop Block | N. Right Blade Guide |
| C. Blade Finger Guard | O. Hold-Down Clamp |
| D. Blade Cover | P. Left Blade Guide |
| E. Workpiece Support Rods | Q. Front Cover |
| F. Right Work Stop | R. Rear Work Stop Support Rods |
| G. Control Panel | S. Rear Work Stop Assembly |
| H. Electrical Box | T. Rear Work Stop |
| I. Emergency Stop Buttons | U. Blade Gap Adjusters |
| J. Foot Pedestal | V. Blade Gibs |
| K. Blade Light Switch | W. Upper Blade Frame |
| L. ON/OFF Switch w/Lockout | X. Rear Cover |



Controls & Components

Basic Controls

Refer to the following figures and 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 minimize your risk of injury when operating this machine.

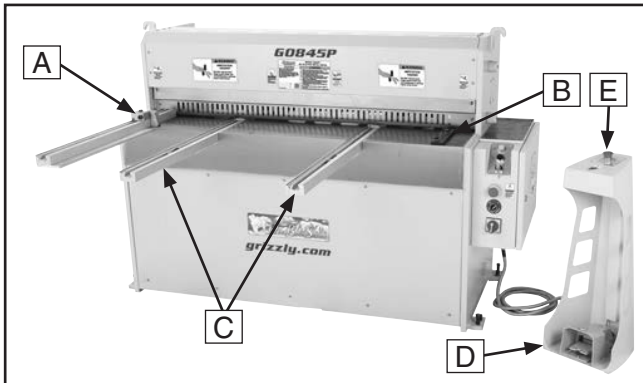


Figure 1. G0845P controls and components (front).

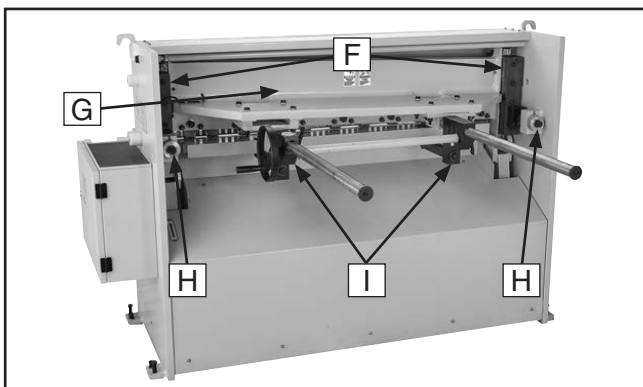


Figure 2. G0845P basic controls (rear).

- A. Left Work Stop w/Stop Block:** Helps the operator square large workpieces. Scale shows distance to blades. Adjustable stop block allows repeated cuts of same depth.
- B. Right Work Stop:** Lets the operator square smaller workpieces for left-hand cuts.
- C. Workpiece Support Rods:** Provide support for large workpieces. Scales show distance to blades.
- D. Foot Pedestal:** Contains foot pedal to operate blade, and Emergency Stop button.

- E. Emergency Stop Button:** Turns machine **OFF** when pressed. Twist clockwise to reset.
- F. Blade Guides:** Control position of upper blade relative to lower blade.
- G. Upper Blade Frame:** Holds upper blade and supports rear work stop assembly.
- H. Blade Gap Adjusters:** Change blade gap to account for workpiece gauge and material hardness. **ALWAYS** set gap adjusters equally.
- I. Rear Work Stop Assembly:** Allows operator to set shear for multiple cuts of the same depth.

Control Panel

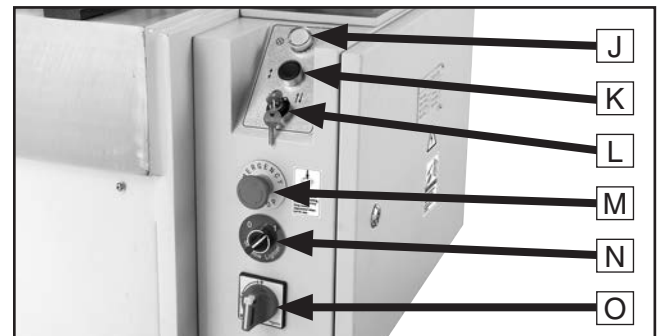


Figure 3. G0845P control panel.

- J. Power Indicator:** Illuminates when machine is connected to power.
- K. Jog Button:** Engages shear when pushed in; disengages shear when released.
- L. Shear Switch:** Use to select jog operation (left) or foot-switch operation (right).
- M. EMERGENCY STOP Button:** Turns machine **OFF** when pressed. Twist clockwise to reset.
- N. Shadow Lighter:** Turn right to turn light **ON** behind cutting guard. Turn left to turn **OFF**.
- O. ON/OFF Switch w/Lockout:** Turn right to turn machine **ON**. Turn left to turn machine **OFF**. To disable and lock machine, turn switch to **OFF**, then press white tab in to install padlock through center slot.





MACHINE DATA SHEET

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

MODEL G0845P HEAVY-DUTY 50" ELECTRIC METAL SHEAR - POLAR BEAR SERIES

Product Dimensions:

Weight..... 3197 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 72-1/2 x 80 x 48 in.
 Footprint (Length x Width)..... 28-1/2 x 66-1/2 in.
 Space Required for Full Range of Movement (Width x Depth)..... 96 x 80 in.

Shipping Dimensions:

Type..... Wood Crate
 Content..... Machine
 Weight..... 3748 lbs.
 Length x Width x Height..... 79 x 45 x 63 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, 3-Phase, 60 Hz
 Full-Load Current Rating..... 20.7A
 Minimum Circuit Size..... 30A
 Connection Type..... Hardwire
 Switch Type..... Foot-Operated ON/OFF Switch w/External Safety Padlock

Motors:

Main

Horsepower..... 7.5 HP
 Phase..... 3-Phase
 Amps..... 20.7A
 Speed..... 1720 RPM
 Type..... TEFC w/Integrated Brake
 Power Transfer V-Belt Drive
 Bearings..... Sealed & Permanently Lubricated
 Centrifugal Switch/Contacts Type..... N/A

Main Specifications:

Capacities

Maximum Width..... 50 in.
 Maximum Thickness Mild Steel..... 10 Gauge
 Maximum Thickness at Full Width Mild Steel..... 10 Gauge
 Aluminum..... 8 Gauge
 Maximum Beam Lift..... 1/2 – 1-13/16 in.
 Bed Height Above Floor..... 31-1/2 in.
 Working Height..... 31-1/2 in.
 Front Stop Scale Range..... 3-15/16 – 39-5/16 in.
 Rear Stop Scale Range..... 0 – 25-5/8 in.



Construction

Frame.....	Steel
Shear Table.....	Steel
Shear Hold-Down Clamp.....	Steel
Shear Blades.....	Steel
Shear Blade Type.....	Hardened Alloy

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	2 Hours
Serial Number Location	Machine ID Label
Certified by a Nationally Recognized Testing Laboratory (NRTL)	No

Features:

- Remote On/Off Foot Pedal Control
- Reversible, Hardened Steel Alloy Cutting Shear Dies for Extended Life
- Adjustable Front and Rear Stop Scales
- Hand and Foot-Pedal Operation
- Super-Quiet Operation
- Built-In, Non-Marring Hold-Down Clamp
- Shadow Light



SECTION 1: SAFETY

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

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

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

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

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

NOTICE 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 Electric Metal Shears

WARNING

Serious cuts, amputation, or death can occur from contact with the shear blades during operation, adjustment, or maintenance. To reduce this risk, anyone using this machine **MUST** completely heed the hazards and warnings below.

FINGER AMPUTATION. 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 blades and hold-down (point-of-operation) during shearing operations.

GUARDS. Keep all guards in place, properly positioned, and in working order. Never operate shear with blade guard removed. If blade guard is removed or not properly positioned, fingers may accidentally be cut or amputated by shear blades. Always position guard just high enough to allow workpiece to enter, but not fingers.

CAPACITY. Exceeding cutting capacity of shear may result in breakage or machine damage that ejects dangerous metal debris at operator or bystanders. Only use sheet metal within the rated capacity of this shear (refer to the **Machine Data Sheet**).

PROPER WORKPIECE MATERIAL. Shear is only intended for cutting ferrous and non-ferrous mild 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 risk of injury, and may result in damage to machine.

USE OF HAND TOOLS. Hand tools are intended for placing and removing materials from shear point-of-operation. Use of hand tools is intended to prevent need for operator to place hands or fingers within point-of-operation. Always use hand tools to place or remove any workpiece within point-of-operation, in conjunction with all blade guards.

WORK AREA. Provide sufficient clearance around machine to permit safe use by regular operators and performance of maintenance procedures. Keep work area clear of materials or substances that may create a slip, trip, or fall hazard.

SHARP METAL EDGES. The sharp edges of sheet metal can easily cut fingers, hands, and other body parts. Always wear heavy leather gloves when handling sheet metal. Always chamfer and deburr sharp workpiece edges.

OPERATOR POSITION. Avoid awkward body and hand positions where a sudden slip could cause your hand or body to enter point-of-operation or make accidental contact with shear blades.

MAINTENANCE/SERVICE. Always disconnect machine from power and wait for all moving parts to come to a complete stop before performing any adjustments, service, or maintenance.

BLADE CONDITION. Sharp, undamaged, and properly adjusted blades will reduce risk of injury from breakage or sharp burrs left on workpiece. Always keep blades properly adjusted and sharp.

SHEAR BLADE ADJUSTMENT. When adjusting or replacing shear blades, always disconnect machine from power, wear heavy leather gloves to protect hands, and wear safety glasses to protect eyes.

CHECK MACHINE. Before using machine, carefully check components for wear that could affect operation. Check blade alignment and gib play, and ensure guards are properly installed. **DO NOT** operate machine until all defects are corrected.

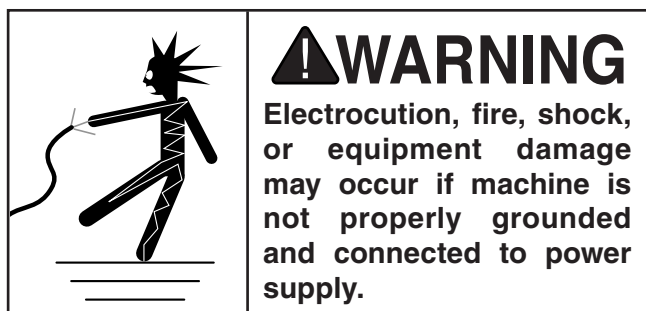
STRAY SHEET METAL PIECES. Sheet metal cut-off pieces left on the floor can easily slide under foot and cause falling injuries. Always remove cut-off sheet metal pieces from the floor after operation. Keep work area clean.



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.

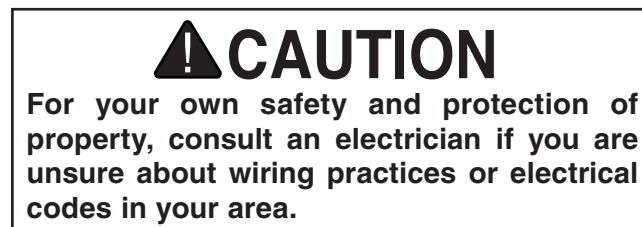
Full-Load Current Rating at 220V .. 20.7 Amps

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

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

Circuit Information

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



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

Circuit Requirements for 220V

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

Nominal Voltage 220V, 230V, 240V
Cycle 60 Hz
Phase 3-Phase
Power Supply Circuit 30 Amps



Connection Type

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

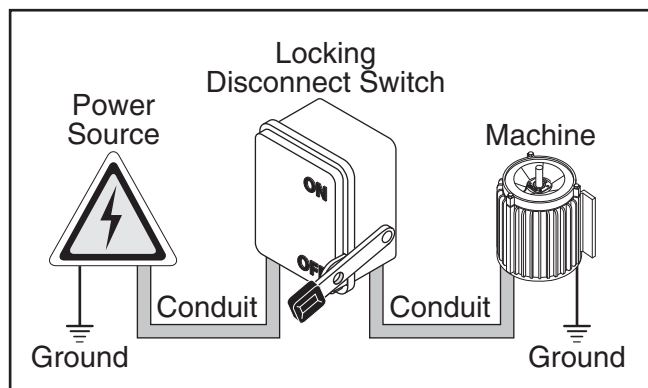


Figure 4. Typical setup of a permanently connected machine.

Extension Cords

Since this machine must be permanently connected to the power supply, an extension cord cannot be used.

Grounding Instructions

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!

⚠️ 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.

Phase Converters

Please note that this machine cannot be run on a phase converter; you must use a true 3-phase power supply.



Disabling & Locking ON/OFF Switch

⚠️ WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, disable and lock the switch before leaving machine unattended! Place key in a well-hidden or secure location.

NOTICE

The padlock shaft diameter is important to the disabling function of the switch. With any padlock used to lock the switch, test the switch after installation to ensure that it is properly disabled.

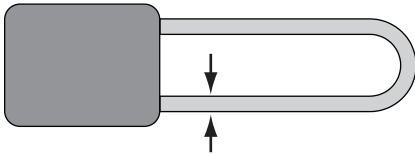


Figure 5. Minimum lock shaft requirements.

The machine can be disabled and locked by pushing the tab in and inserting a padlock through the rotary ON/OFF switch, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

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

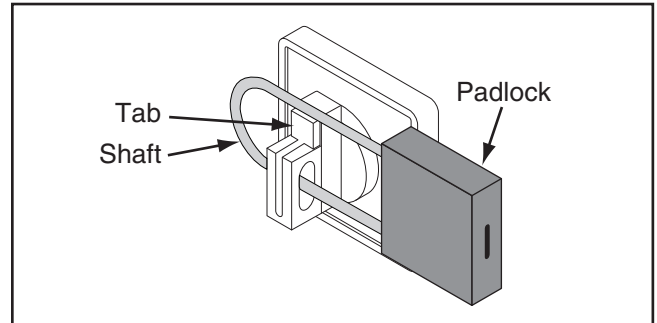
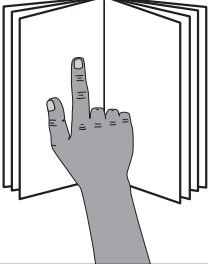


Figure 6. ON/OFF switch disabled by a padlock.




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.

!WARNING
 This is an extremely heavy machine! Serious personal injury or death may occur if safe lifting and moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate. Seek assistance from a professional rigger if you are unsure about your abilities or maximum load ratings of your lifting equipment.

Needed for Setup

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

Description	Qty
Precision Level	1
Assistants	At Least 2
Safety Glasses (per person).....	1 Ea
Solvent/Cleaner (Page 16)	As Needed
Shop Rags.....	As Needed
Wrenches 25, 18, 17mm.....	1 Ea
Brass Hammer	1
Forklift.....	1
Floor Mounting Hardware.....	As Needed

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.*



!WARNING
SUFFOCATION HAZARD!
 Keep children and pets away from plastic bags or packing materials shipped with this machine.



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 1 (Figures 7–9)	Qty
A. Electric Shear	1
B. Foot Pedestal Assembly.....	1
C. Rear Work Stop Assembly	1
D. Left Side Stop w/Flip Stop.....	1
E. Workpiece Support Rods	2
F. Grease Gun.....	1
G. Flat Head Screwdriver #2.....	1
H. Adjustable Wrench	1
I. Hex Wrench Set 3, 4, 5, 6, 8, 10mm.....	1 Ea
J. Feeler Gauge Set.....	1
K. Hardware Bag	
—Hex Bolts M16-2 x 25	2
—Dock Washers 16 x 44 x 6mm	2
—Cap Screws M8-1.25 x 16.....	6

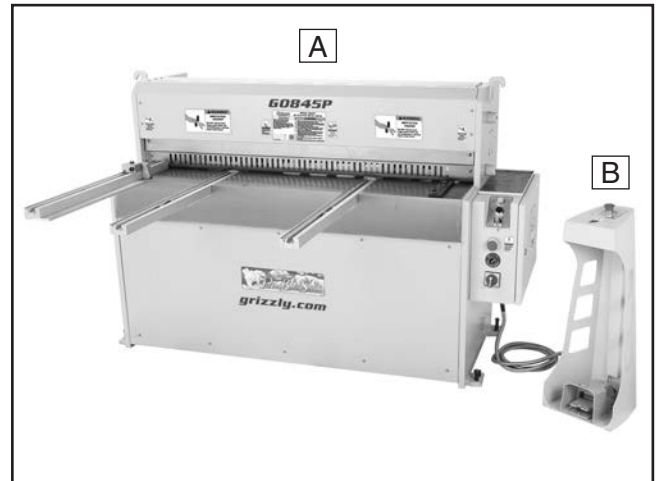


Figure 7. G0845P electric shear and foot pedestal assembly.

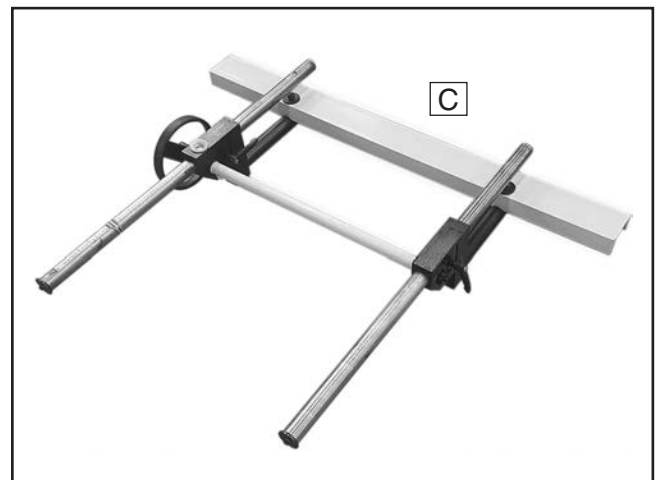


Figure 8. G0845P rear work stop assembly.

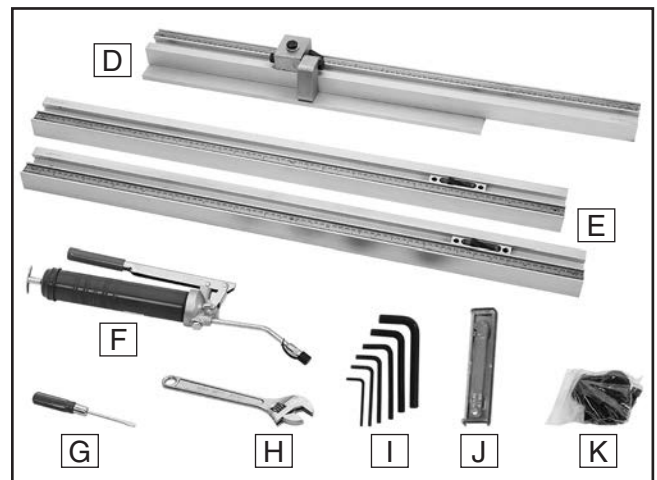


Figure 9. G0845P inventory.



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

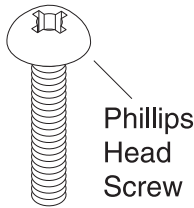
10mm

12mm

16mm



Hex Wrench



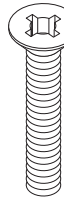
Phillips Head Screw



Lock Nut



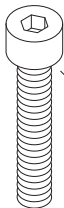
Wing Nut



Flat Head Screw



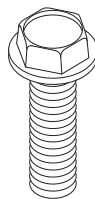
Flat Head Cap Screw



Cap Screw



Carriage Bolt



Flange Bolt



Button Head Screw



Tap Screw



External Retaining Ring



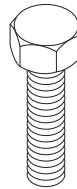
Internal Retaining Ring



E-Clip



Set Screw



Hex Bolt



Key



Flat Washer

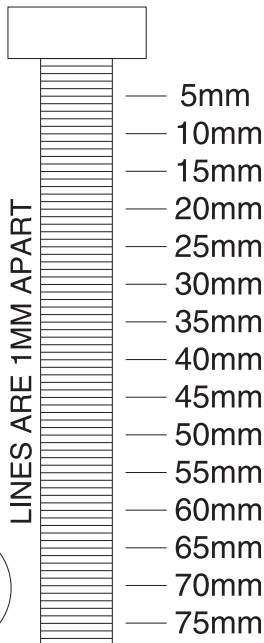


Lock Washer



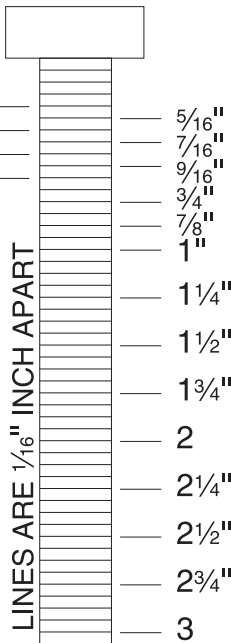
Hex Nut

LINES ARE 1MM APART

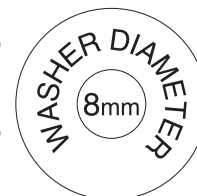
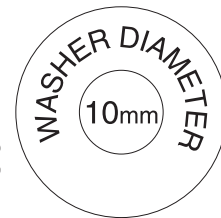
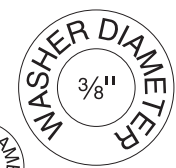
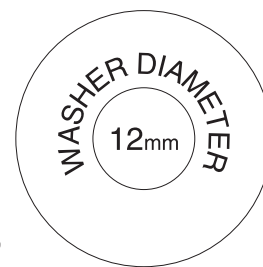
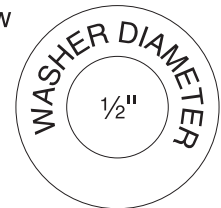
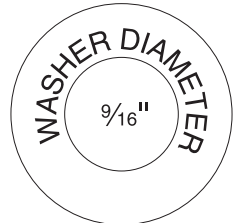
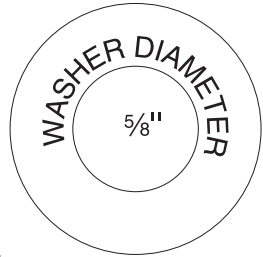


1/4"
3/8"
1/2"
5/8"

LINES ARE 1/16" INCH APART



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



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.

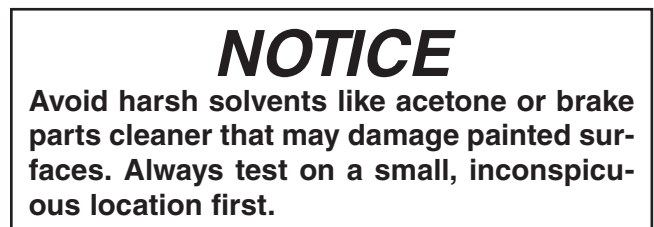
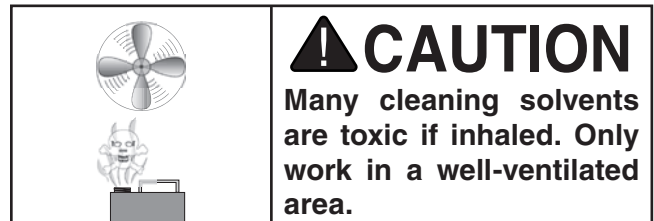
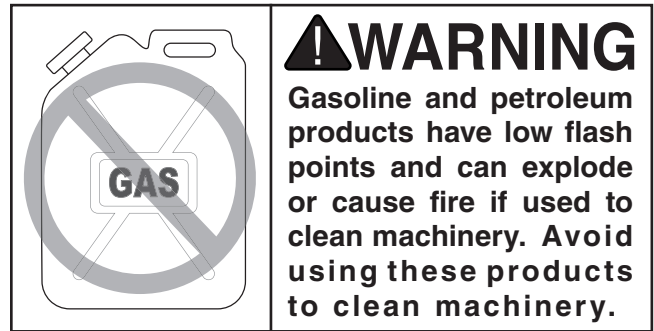
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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 10. T23692 Orange Power Degreaser.



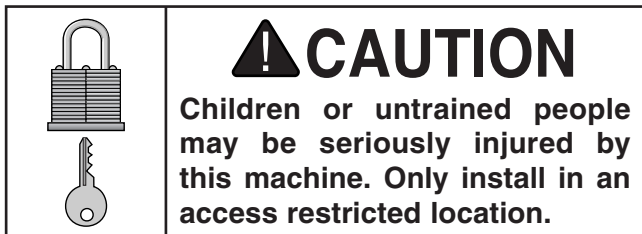
Site Considerations

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.

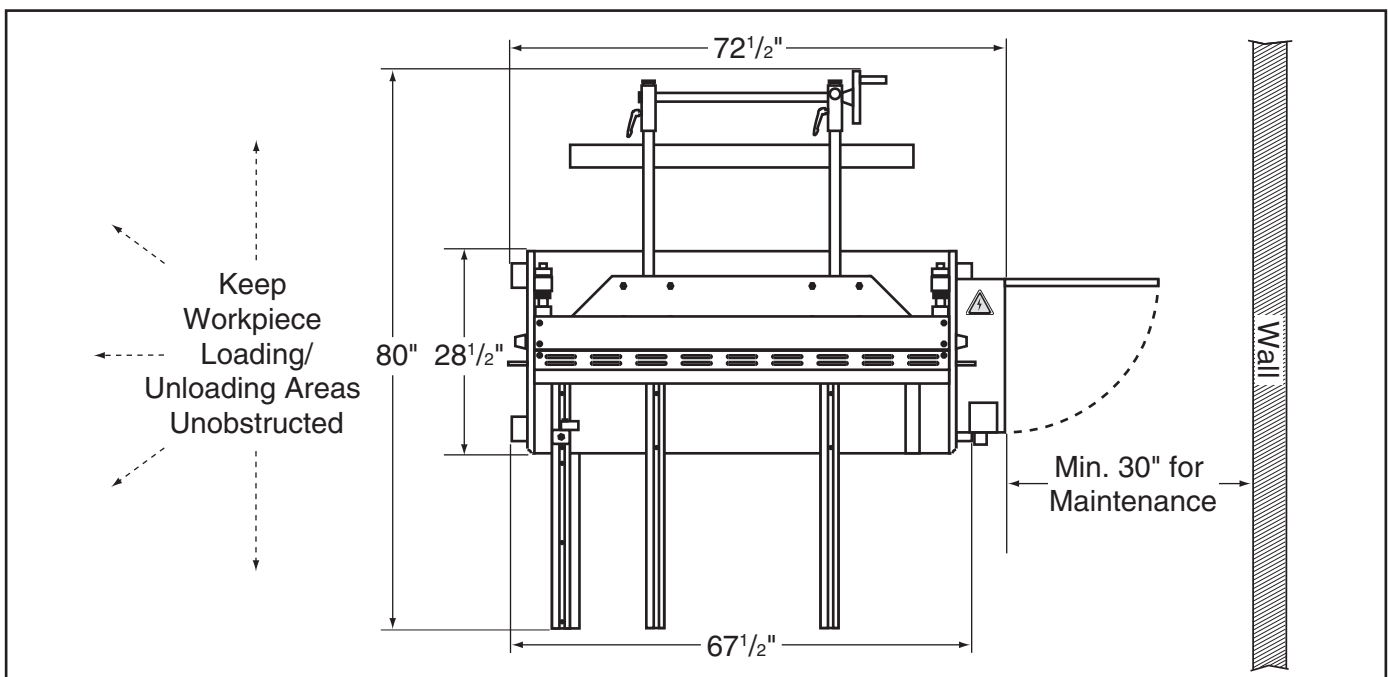


Figure 11. Minimum working clearances.



Lifting & Placing

!WARNING

This is an extremely heavy machine! Serious personal injury or death may occur if safe lifting and moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate. Seek assistance from a professional rigger if you are unsure about your abilities or maximum load ratings of your lifting equipment.

DO NOT attempt to lift or move machine without using proper lifting equipment (such as forklift or crane) and assistance from other people. Each piece of lifting equipment must be rated for **at least 4000 lbs.** to support dynamic loads that may be applied while lifting.

Review the **Power Supply** section beginning on **Page 10**, then prepare a permanent location for the machine.

Note: Place the G0845P on a level concrete floor. Position the machine to provide clear access for the loading and unloading areas (refer to **Site Considerations** on **Page 17**).

Items Needed	Qty
Forklift (Rated For At Least 4000 lbs.)	1
Wrench or Socket 18mm.....	1
Another Person.....	1

To move machine:

1. Remove shipping crate and accessories box.

2. Remove (2) hex nuts and (1) flat washer on each mounting foot (see **Figure 12**).

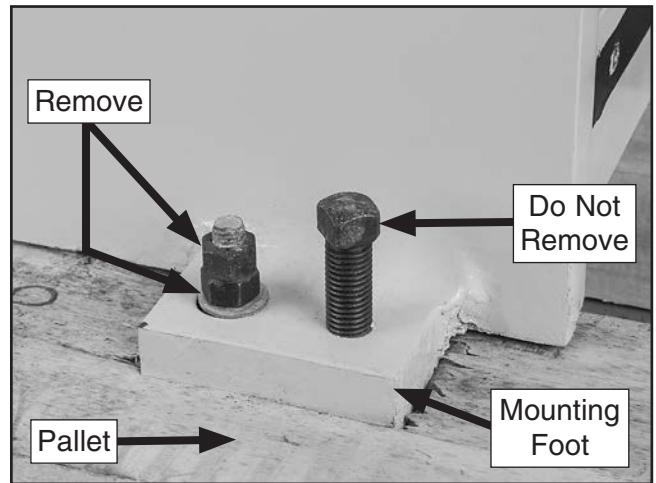


Figure 12. Remove hex nuts and flat washers securing machine to pallet.

3. Carefully slide forklift forks under machine base (see **Figure 13**).



Figure 13. Lifting the Model G0845P.

4. Lift machine enough to just clear shipping pallet.
5. Move machine to prepared location.



Leveling

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

Items Needed	Qty
Open-End Wrench 17mm.....	1
Precision Level (at least 12" long)	1

Use the square-head bolt in each mounting foot to level the machine (see **Figure 14**). If needed, place a metal shim under the mounting foot.

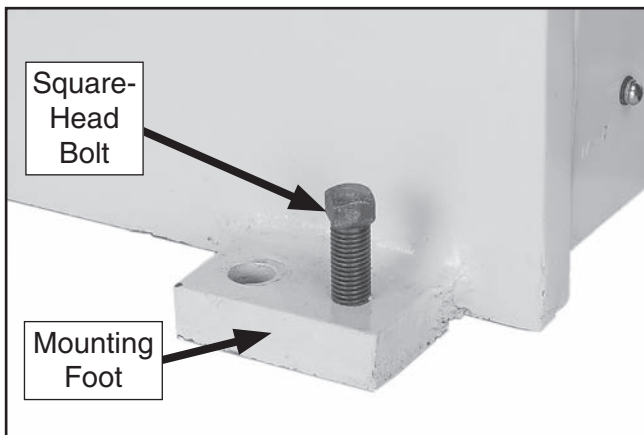


Figure 14. Use square-head bolt to adjust level.

For best results, use a precision level that is at least 12" long and sensitive enough to show a distance movement when a 0.003" shim (approximately the thickness of one sheet of standard newspaper) is placed under one end of the level. The Model H2683 Master Machinist's Level is one example available from Grizzly.

Anchoring to Floor

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

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

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

Anchoring to Concrete Floors

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

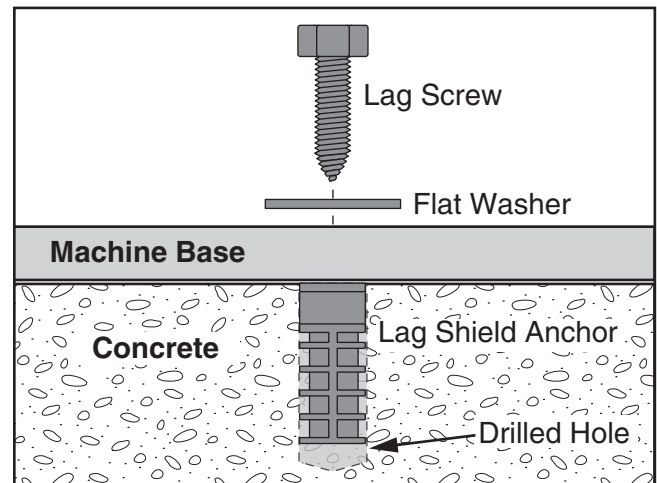


Figure 15. Popular method for anchoring machinery to a concrete floor.



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).

The G0845P comes mostly assembled from the factory. The rear work stop assembly, left work stop, workpiece support rods, and control pedestal must be assembled or attached.

Items Needed	Qty
Hex Wrench 6mm.....	1
Open-End Wrench 25mm.....	1
Another Person.....	1

To assemble machine:

1. With help from another person, lift rear work stop assembly and place support rods in mounting holes on upper blade frame (see **Figure 16**). Secure with (2) M16-2 x 25 hex bolts and (2) 16 x 44 x 6mm dock washers.

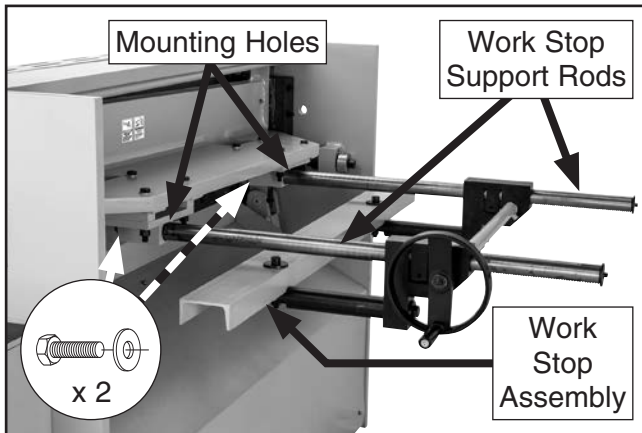


Figure 16. Rear work stop assembly mounted to upper blade frame.

2. Attach (2) workpiece support rods and left work stop to table using (6) M8-1.25 x 16 cap screws (see **Figure 17**).

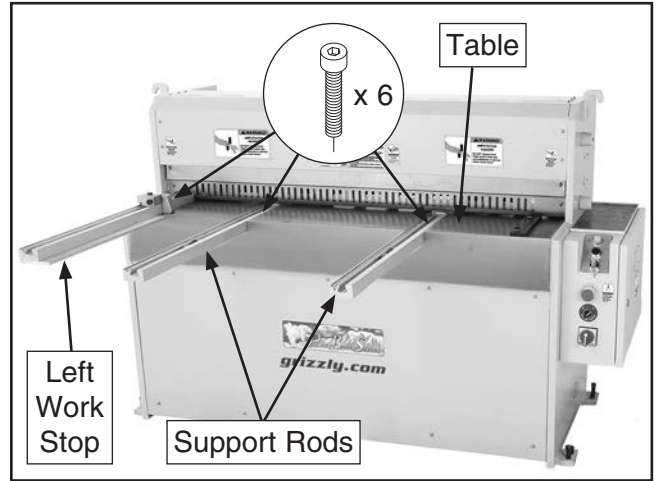


Figure 17. Workpiece support rods and left work stop attached to table.

3. Plug foot pedestal wiring harness into electrical box plug as shown in **Figure 18**. Thread collar onto plug to secure.

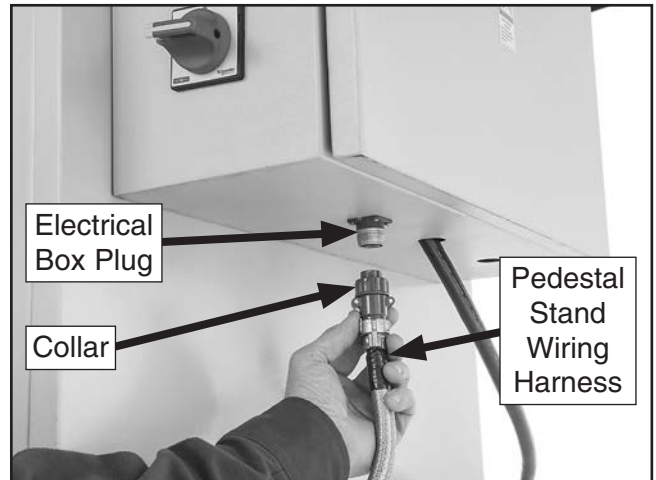
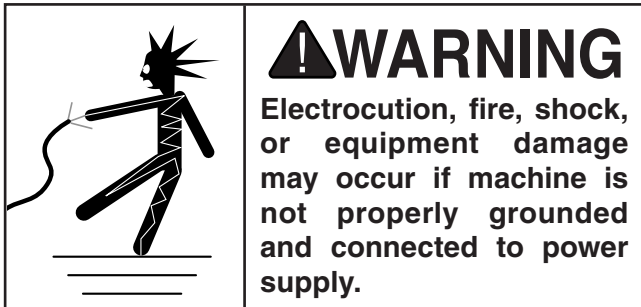


Figure 18. Connecting foot pedestal wiring harness.



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.



To connect shear to power:

1. Open electrical box door (see **Figure 19**) with included key.
2. Insert incoming power cord and strain relief (both sold separately) through bottom of electrical box where shown in **Figure 19**.

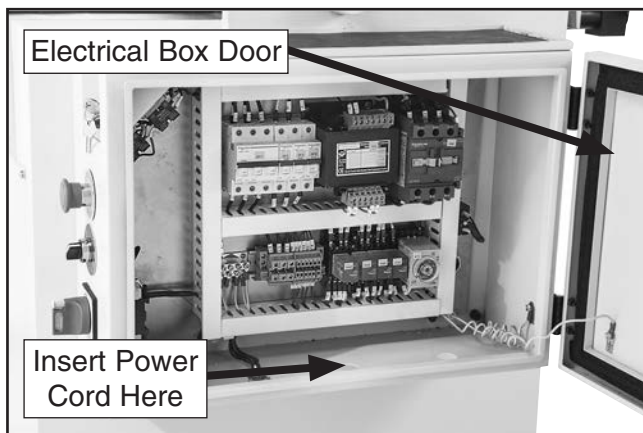


Figure 19. Location of electrical box and power cord access hole.

! WARNING

During next step, make sure incoming ground wire is connected to ground terminal post in the power junction box so machine is properly grounded. An ungrounded or improperly grounded machine may have an electrified frame that could cause electrocution when touched.

3. Connect ground wire to an open ground terminal, then connect incoming power wires to terminals shown in **Figure 20**.

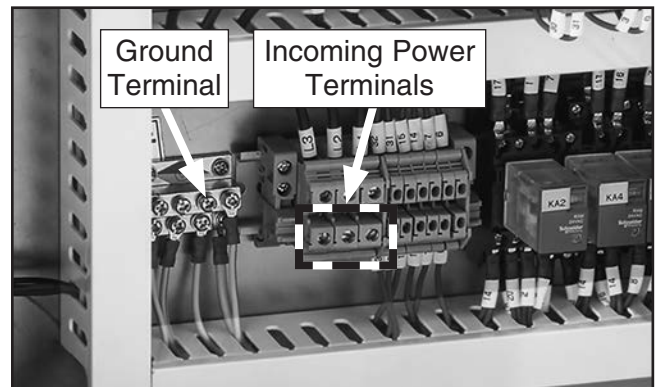


Figure 20. Terminal locations to connect ground wire and incoming power wires.

4. Make sure wires have enough slack so they are not pulled tight or stretched.
5. Close and secure electrical box door, then perform **Test Run**.



Connecting to Power Source

Move the disconnect switch handle to the ON position, as illustrated below. The machine is now connected to the power source.

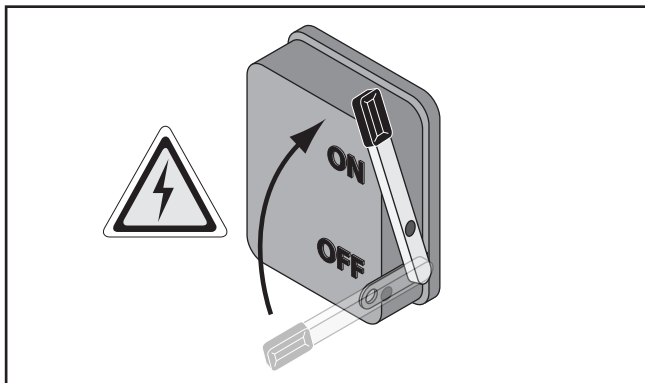


Figure 21. Connecting power to machine.

Disconnecting from Power Source

Move the disconnect switch handle to the OFF position, as illustrated below. The machine is now disconnected from the power source.

Note: Lock the switch in the OFF position to restrict others from starting the machine.

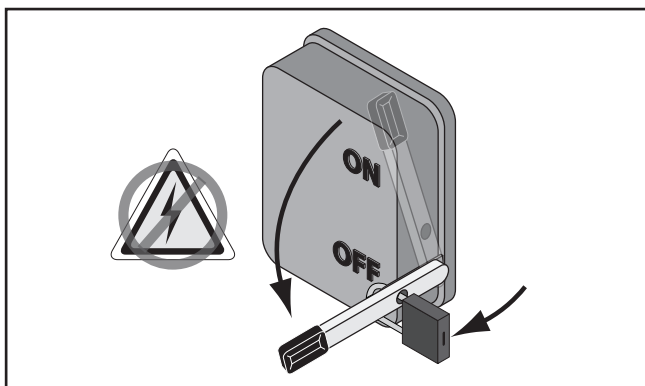


Figure 22. Disconnecting power from machine.

Test Run

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

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

!WARNING

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

!WARNING

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

The test run consists of the following: 1) the motor powers up and runs correctly, 2) the phase polarity is correct, 3) the shear blades have adequate clearance, and 4) the safety feature works correctly on both EMERGENCY STOP buttons.

To test run shear:

1. Clear all setup tools away from machine.



2. Press EMERGENCY STOP buttons on control panel and foot pedestal (see **Figure 23**).

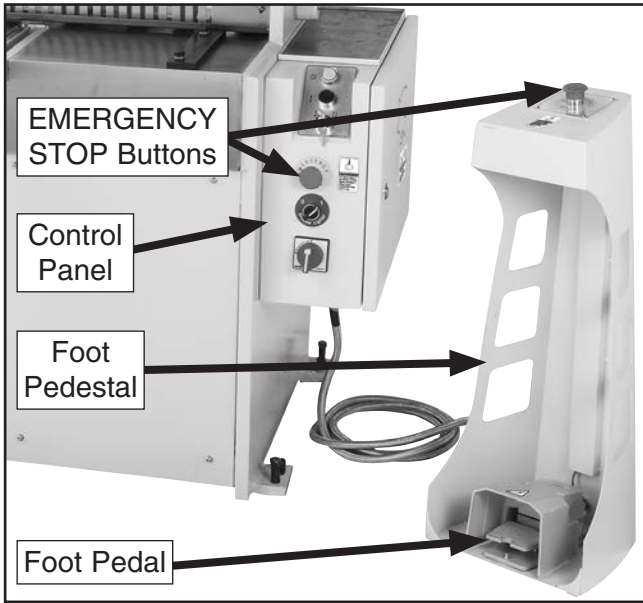


Figure 23. EMERGENCY STOP button locations.

3. Set both blade gap adjusters at 0.010" as indicated on each dial (see **Figure 24**).

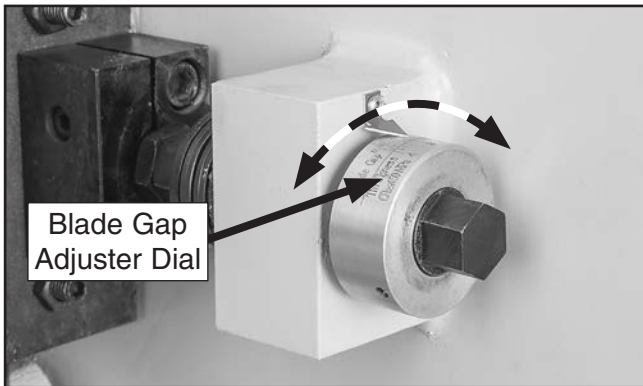


Figure 24. Location of blade gap adjuster (right).

4. Connect machine to power (see **Page 22**).

5. Twist each EMERGENCY STOP button clockwise until it springs out (see **Figure 25**). This resets switches so machine can start.

Note: Both EMERGENCY STOP buttons must be reset before shear motor will run.

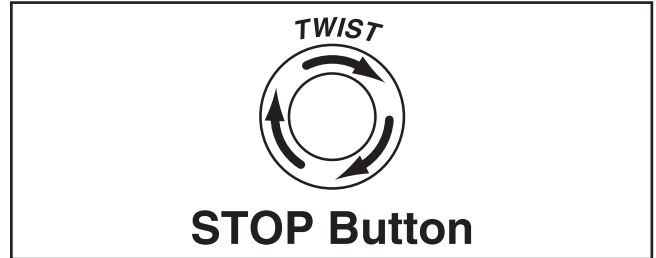


Figure 25. Resetting EMERGENCY STOP button.

6. Turn ON/OFF switch ON. Power indicator should illuminate (see **Figure 26**).

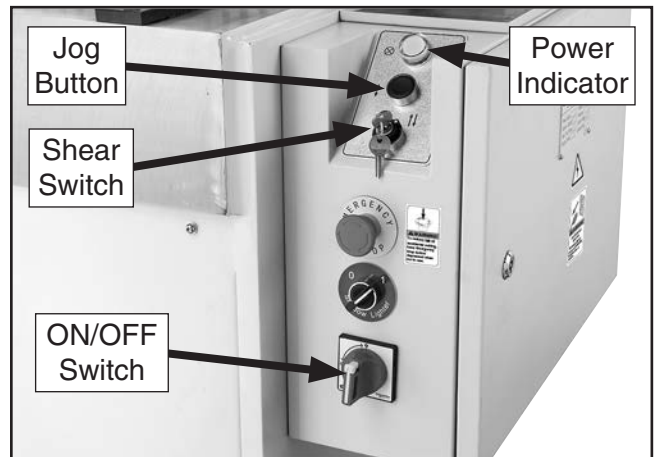


Figure 26. ON/OFF switch, shear switch, jog button, and power indicator.

7. Turn shear switch left, then press and hold jog button (see **Figure 26**). Motor should engage shear and operate smoothly without vibration or excessive noise as long as button is held *in*. Release jog button to stop machine.



- Turn shear switch to right. Press foot pedal one time (see **Figure 23** on **Page 23**) and release. Motor should engage shear and operate smoothly for one full cycle.

Note: *If shear was stopped with jog button in the middle of a cycle, the foot pedal will only move the upper blade to top dead center. Press foot pedal again to verify motor engages shear and operates for one full cycle.*

NOTICE

If the blade returns to top dead center but the hold-down clamp remains on the work table, the motor is running backwards because it is out of phase. Check wiring connections in the electrical control box and at the wall, and correct as necessary before completing remaining Test Run steps.

- Press foot pedal again. During cutting cycle, press EMERGENCY STOP button on foot pedestal (see **Figure 27**) to immediately stop machine.



Figure 27. Foot pedestal EMERGENCY STOP button.

- WITHOUT resetting EMERGENCY STOP button, try to start machine by pressing foot pedal, then turn shear switch left and press jog button. The machine should not start with shear switch in either position.

— If the machine *does not* start, the safety feature of the foot pedestal EMERGENCY STOP button is working correctly. Proceed to **Step 11**.

— If the machine *does* start, immediately turn it **OFF** and disconnect power. The safety feature of the EMERGENCY STOP button is NOT working properly and must be replaced before further using the machine.

- Reset foot pedestal EMERGENCY STOP button, then repeat **Steps 8–10** to test EMERGENCY STOP button on control panel (see **Figure 28**).



Figure 28. Control panel EMERGENCY STOP button.

- If test run is successful, press foot pedal to return upper blade to top dead center.



SECTION 4: OPERATIONS

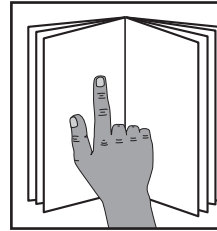
Operation Overview

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. Sets blade gap adjusters equally to suit workpiece gauge and material.
3. Uses appropriate tools to place and remove materials in machine point-of-operation.
4. Adjusts rear work stop for length of cut.
5. Turns machine **ON** and uses shear switch to select foot switch cutting operation.
6. Puts on safety glasses, leather boots, and heavy leather gloves.
7. Places workpiece on front support rods and up against left side work stop.
8. Slides workpiece under blade and up against rear work stop.
9. Presses foot pedal to make cut.
10. Removes workpiece and cut-off piece, or repeats **Steps 7–9** to make additional cuts of same length.

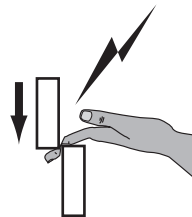
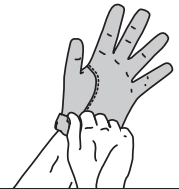


!WARNING

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

!WARNING

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.



!WARNING

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.

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.

11. Turns machine **OFF** when operation is complete.



Cutting Tips

- Before each operation, remove cut-offs from machine.
- Never place hands/fingers under blades. Use a push stick or other tool to clear small cut-offs. Always turn machine **OFF** and disconnect power to clear around cut-off pieces. Use of hand tools is intended to prevent need for operator to place hands or fingers within shear point-of-operation.
- Keep the upper blade properly adjusted to the lower blade (refer to **Adjusting Blade Gap** on **Page 38** for detailed instructions). This will help ensure good cutting results and avoid blade damage.
- Make sure both side work stops are square with the blades.
- Always check the workpiece position before engaging the shear. If it is correct, press the foot pedal to make the cut.

Cutting Procedure

The Model G0845P can cut up to 10-gauge mild sheet steel and 8-gauge sheet aluminum. Two blade gap adjusters on the back of the shear allow quick adjustment of the blade gap to accommodate different workpiece thicknesses. ALWAYS set the blade gap adjusters equally.

The shearing action of the blades works similarly to a pair of scissors (see illustration in **Figure 29**).

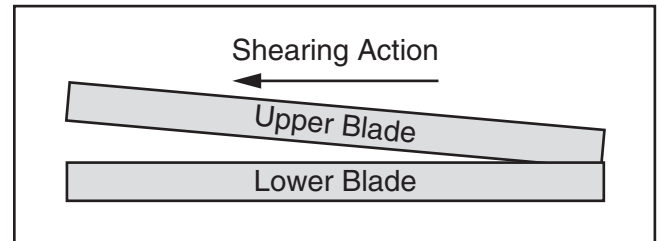



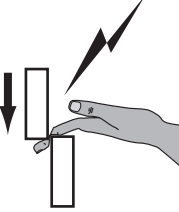
Figure 29. Blade shearing action.

Items Needed	Qty
Sheet Metal Gauge	1
Wrench or Socket 25mm.....	1



WARNING

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 clear of blades and hold-down during operation.



⚠ CAUTION

Bodily injury can result from improper use of this machine. Always wear safety glasses, leather work boots, and heavy leather work gloves when operating this machine or whenever handling sheet metal.







To cut a workpiece:

1. Measure workpiece for thickness and mark for length of cut.
2. Set blade gap adjusters equally to match workpiece material thickness (see **Figure 30**).

IMPORTANT: *DO NOT* exceed maximum blade gap measurements listed on adjusters.

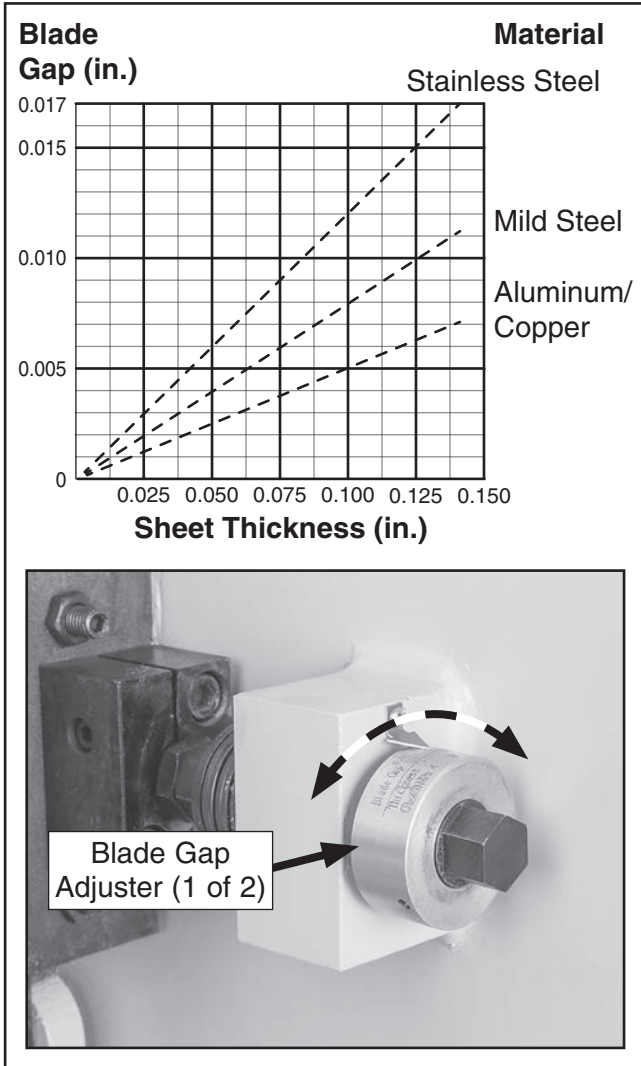


Figure 30. Measure workpiece, then set both blade gap adjusters according to chart.

3. Use scale and magnifier on rear work stop assembly to set workpiece depth of cut (see **Figure 31**), then tighten lock handles.

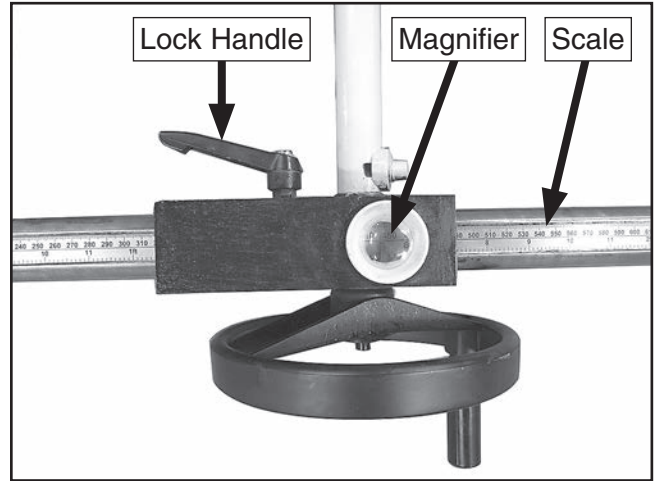


Figure 31. Rear work stop assembly features.

4. Square workpiece against left work stop, then push workpiece against rear work stop, as shown in **Figure 32**.

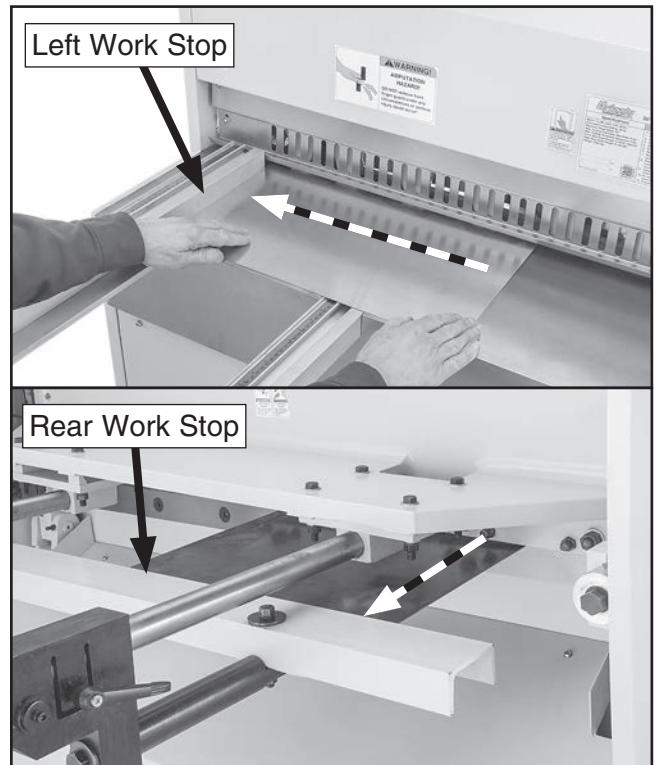


Figure 32. Properly placing workpiece against left work stop and rear work stop for cut.



5. Turn ON/OFF switch ON, then turn shear switch right to select foot pedal operation.
6. With hands and fingers clear of blade area, press foot pedal to cut workpiece. Hold-down clamp will automatically engage to hold workpiece.
7. Remove cut-off workpiece from table after cutting cycle is complete.

Using Work Stops

The Model G0845P has an adjustable stop block on the left work stop, and adjustable work stops on both workpiece support arms. Use the stop block and work stops to set the length of cut on workpieces that don't require use of the rear work stop.

Left Work Stop & Stop Block

The position of the stop block is adjustable along the left work stop. The pointer and scale show the distance of the stop block from the blade. It can be adjusted from 3¹⁵/₁₆" to 36¹/₂".

Item Needed	Qty
Wrench or Socket 18mm.....	1

To use stop block on left work stop:

1. Measure workpiece for length of cut.

2. Loosen hex bolt and move stop block to match measurement in **Step 1** (see **Figure 33**). Tighten hex bolt.
3. Place stop block finger in down position, as shown in **Figure 33**.

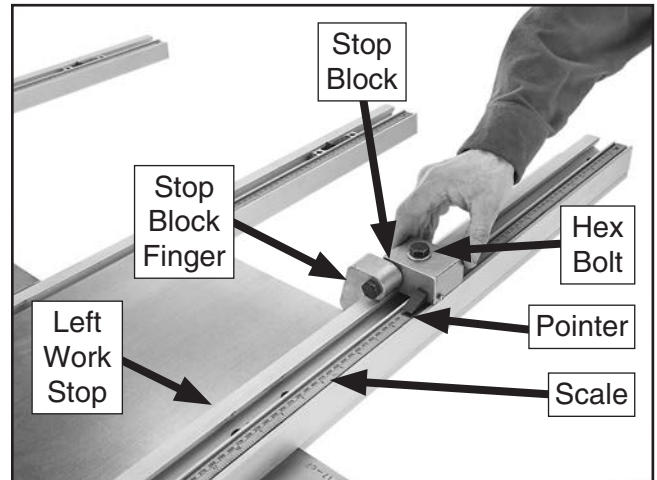


Figure 33. Positioning stop block on left work stop to cut workpiece.

4. Square workpiece against left work stop, then position workpiece against stop block finger.
5. Turn ON/OFF switch ON, then turn shear switch to the right to select foot pedal operation.
6. With hands and fingers clear of blade area, press foot pedal to cut workpiece.

Note: *Hold-down clamp will automatically engage to hold workpiece.*
7. Remove workpiece from table after cutting cycle is complete.



- Put stop block finger in up position when not in use (see **Figure 34**).

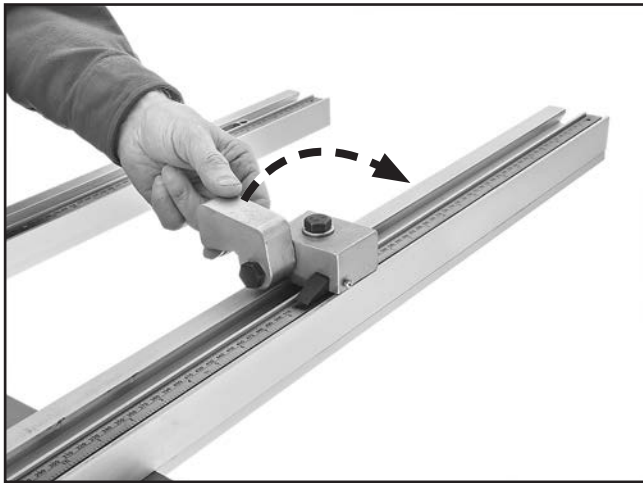


Figure 34. Moving stop block finger to up position.

Workpiece Support Rod Work Stops

Each workpiece support rod has an adjustable work stop. After the workpiece slides over the work stop, a raised edge flips up to support the back of the workpiece. Each work stop can be set from 5¹/₈" to 37" away from the blade.

Items Needed	Qty
Hex Wrench 5mm.....	1
Machinist's Square	1

To adjust and use workpiece support rod work stops:

- Measure workpiece for length of cut or cuts.

- Loosen (2) cap screws on center workpiece support rod work stop (see **Figure 35**). Move work stop to match measurement taken in **Step 1**, using machinist's square to align raised edge with scale. Tighten cap screws.

Note: To make two cuts on one workpiece, set right work stop to desired depth of cut by following directions in **Step 2**.

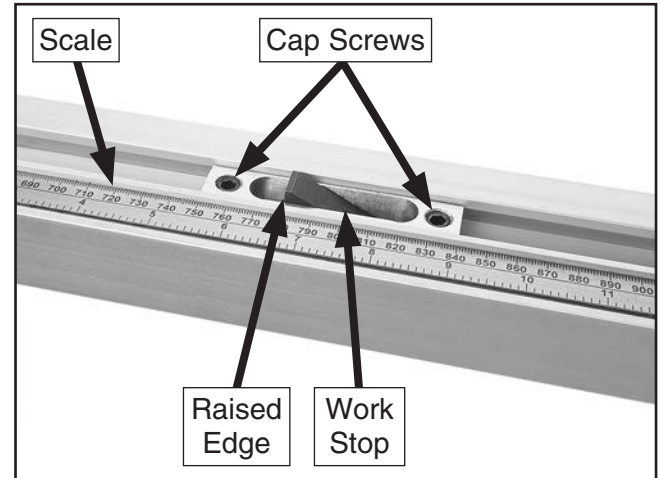


Figure 35. Workpiece support rod work stop adjustments.

- Push workpiece over middle work stop, square workpiece with left work stop, then pull workpiece back against raised edge of work stop.
- Turn ON/OFF switch ON, then turn shear switch to the right to select foot pedal operation.
- With hands and fingers clear of blade area, press foot pedal to cut workpiece.
- To make second cut on workpiece, repeat **Steps 3–5** using right work stop.



SECTION 5: ACCESSORIES

!WARNING

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

NOTICE

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

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; case.



Figure 36. 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 37. H5614 Sheet Metal Gauge.

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.

- Strokes per minute: 3,800
- Air inlet: 1/4" NPT
- Average air consumption: 9.8 CFM
- Working pressure: 90 PSI



Figure 38. Model T23085 Pneumatic Nibbler.

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



H3328—Multi-Purpose Magnetic Base

This Multi-Purpose Magnetic Base fixes indicators and test equipment to all ferrous metal with just the turn of a dial. Locking arm attachment point measures 0.400" diameter. V base attaches to round pipe as well as flat surfaces. The side opposite the dial is also activated by the dial. Base measures 2½" long by 2" wide. You can make a variety of jigs with this base.

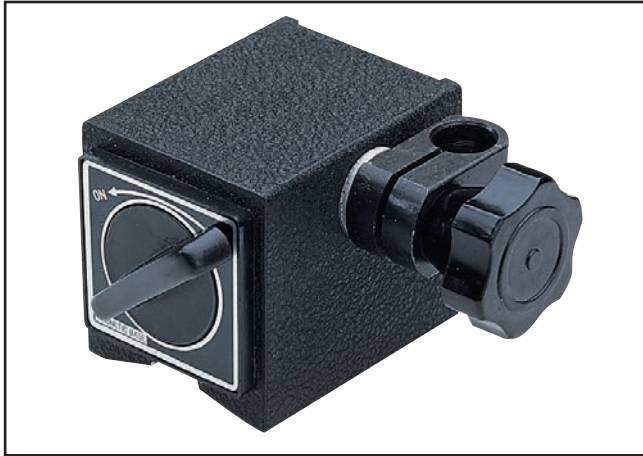


Figure 39. H3328 Magnetic Base.

T21321—Hand Punch

For repetitive hole punching, nothing beats the speed of a hand puncher. With a throat depth of 6⁹/₃₂", this versatile puncher can punch a hole in mild steel up to 3/16" thick. Measures 5½" wide by 31½" tall (without handle). ½" hole die included.



Figure 40. T21321 Hand Punch.

T21320—12" Combination 3-in-1 Sheet Metal Machine

This "little" machine has got to be the slickest sheet metal machine on the market! It shears, it brakes and it slip rolls! Large capacity lets you carry out all 3 functions with ease. Brake attachment comes with sectional fingers for forming various sized boxes. Heavy-duty roller mechanisms are ground for ultra smooth rolling functions. Includes a hinged roller cover for added safety and security.

- Maximum capacity in mild steel: 22-Ga.
- Roll diameter: 1½"

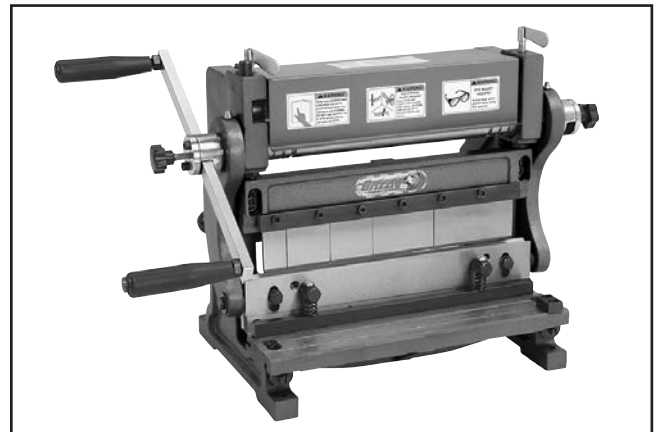


Figure 41. T21320 12" Combination 3-in-1 Sheet Metal Machine.

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

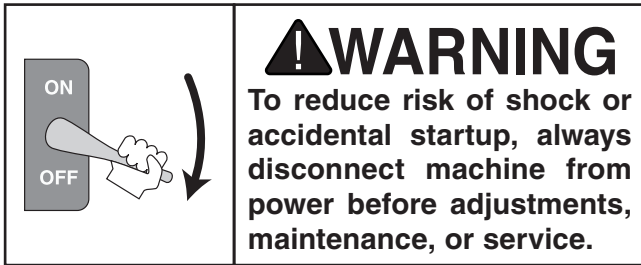


Figure 42. Recommended products for protecting unpainted cast-iron/steel areas.

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



SECTION 6: MAINTENANCE



Schedule

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

Ongoing

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

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

Every 8 Hours

- Lubricate the upper blade frame and gibs (**Page 33**).

Every Month

- Lubricate the eccentric cam copper bushings (**Page 33**).
- Lubricate the rear work stop support rods and gear racks (**Page 34**).
- Lubricate the connecting rod pin shafts (**Page 34**).
- Inspect V-belts for tension, damage, or wear (**Page 46**).
- Clean/vacuum dust buildup from inside cabinet and off motor.

Every 6 Months

- Lubricate the main shaft roller bearings (**Page 35**).
- Change the gearbox oil (**Page 35**).

Cleaning & Protecting

Cleaning the Model G0845P is relatively easy. Protect the unpainted cast-iron bed by wiping it clean after every use. Keep the bed rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 31** for more details).

Lubrication

The Model G0845P has 10 grease fittings that are used to lubricate moving parts of the machine with Grizzly T26419—Syn-o-Gen High Speed Bearing Grease.

Grease fittings for the gibs are on the upper blade frame. Grease fittings for the main shaft bearings and eccentric gear copper bushings are accessible behind the front cover.

The connecting rod pin shafts are located just above the rear cover.

For the oil-bath gearbox, use Grizzly T27914—Moly-D Machine and Way Oil ISO 68. Changing the gearbox oil requires removal of the front cover and rear cover.



Figure 43. Recommended lubricants for Model G0845P.



Upper Blade Frame & Gibs

Frequency..... Every 8 Hours of Operation

Two grease fittings on the back of the upper blade frame lubricate the front and rear gibs inside the blade guides.

Items Needed	Qty
Grease Gun.....	1
Shop Rags.....	As Needed
NLGI#2 Grease or Grizzly T26419	As Needed

To lubricate upper blade frame and gibs:

1. DISCONNECT MACHINE FROM POWER!
2. Clean grease fittings on upper blade frame, and wipe old grease off blade guides behind gibs (see **Figure 44**).

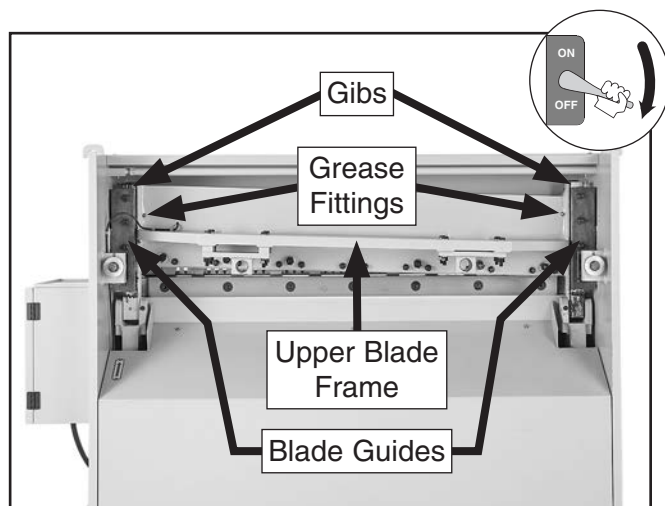


Figure 44. Lubrication points for blade guides and gibs (rear work stop removed for clarity).

3. Pump in new grease just until it seeps from fittings.
4. Apply thin coating of grease on exposed areas of upper blade frame and gibs.
5. Run machine through several cutting cycles to evenly distribute grease.

Eccentric Cam Bushings

Frequency..... Every Month

The eccentric cam transfers power from the motor to the upper blade frame. The copper bushings inside the cam require regular lubrication.

Items Needed	Qty
Grease Gun.....	1
Hex Wrench 4mm.....	1
Shop Rags.....	As Needed
NLGI#2 Grease or Grizzly T26419	As Needed

To lubricate eccentric cam bushings:

1. DISCONNECT MACHINE FROM POWER!
2. Remove front cover.
3. Clean each grease fitting, then pump in new grease until it just seeps from cam bushing housing and grease fitting (see **Figure 45**).

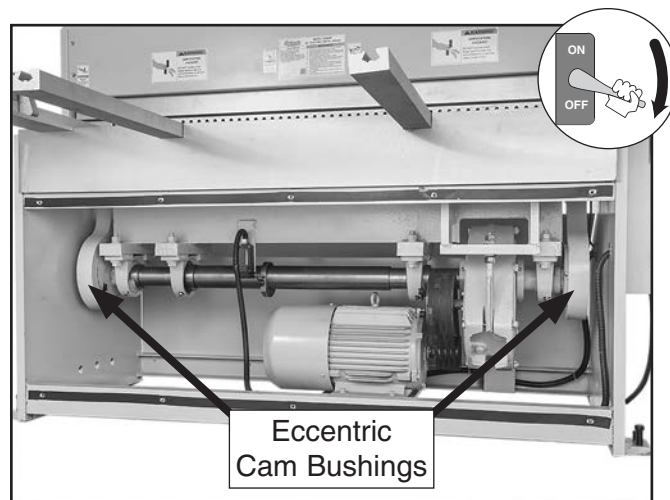


Figure 45. Eccentric cam bushing grease fittings (front cover removed).

4. Replace front cover.
5. Run machine through several cutting cycles to evenly distribute grease.



Rear Work Stop Support Rods

Lubrication Frequency Every Month

Keep the rear work stop support rods lubricated for smooth operation.

Items Needed	Qty
Stiff Cleaning Brush	1
Shop Rags.....	As Needed
Mineral Spirits.....	As Needed
NLGI#2 Grease or Grizzly T26419	As Needed
ISO 68 Oil or Grizzly T27914.....	As Needed

To lubricate rear work stop support rods:

1. DISCONNECT MACHINE FROM POWER!
2. Use mineral spirits and stiff cleaning brush to clean gear racks on bottom of support rods (see **Figure 46**).

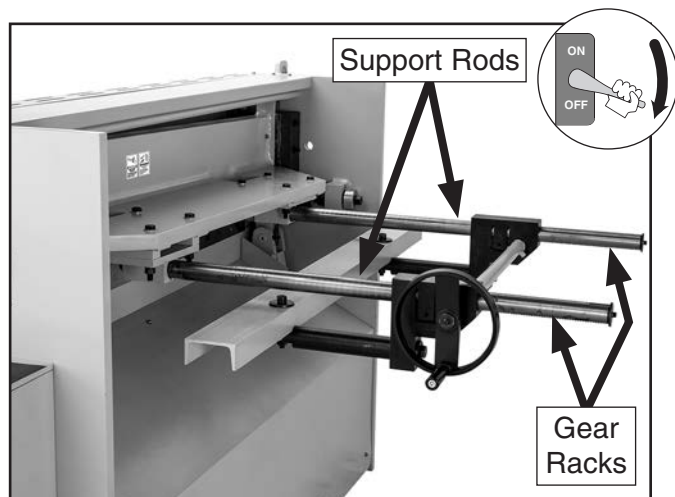


Figure 46. Rear work stop support rod lubrication.

3. Wipe support rods clean with mineral spirits. Allow to air dry.
4. Apply light coating of ISO 68 machine oil or equivalent on upper surface of support rods.
5. Apply light coating of NLGI #2 grease or equivalent to gear racks.
6. Move work stop assembly across support rods several times to evenly distribute lubricant.

Connecting Rod Pin Shafts

Lubrication Frequency Every Month

The connecting rods transfer power between the eccentric cams and upper blade frame. The pin shaft links the connecting rod with the upper blade frame.

Items Needed	Qty
Grease Gun.....	1
NLGI#2 Grease or Grizzly T26419	As Needed
Shop Rags.....	As Needed

To lubricate connecting rod pin shafts:

1. DISCONNECT MACHINE FROM POWER!
2. Clean area around grease fittings on bottom of blade frame where shown in **Figure 47**.

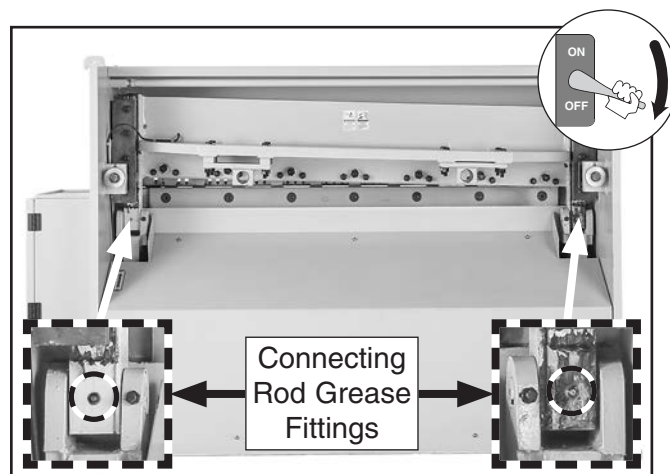


Figure 47. Connecting rod lubrication.

3. Pump in new grease until it just seeps from fitting. Repeat for second grease fitting.
4. Run machine through several cutting cycles to evenly distribute grease.

Main Shaft Roller Bearings

Lubrication Frequency Every 6 Months

Grease the four main shaft roller bearings whenever changing the gearbox oil.

Items Needed	Qty
Grease Gun.....	1
Hex Wrench 4mm.....	1
Shop Rags.....	As Needed
NLGI#2 Grease or Grizzly T26419	As Needed



To lubricate main shaft roller bearings:

1. DISCONNECT MACHINE FROM POWER!
2. Remove front cover.
3. Remove dust cap and clean grease fitting, then pump in new grease until it just seeps from fitting (see **Figure 48**). Repeat for all (4) bearings.

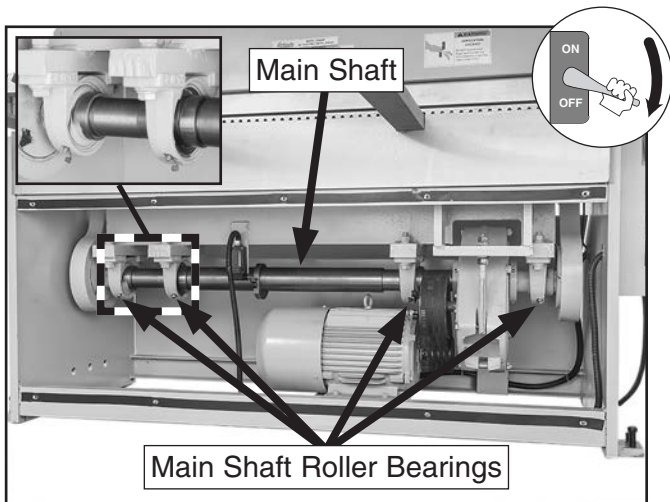


Figure 48. Main shaft roller bearing lubrication.

4. Replace front cover.
5. Run machine through several cutting cycles to evenly distribute grease.

Gearbox Oil

Lubrication Frequency..... Every 6 Months

Change the gearbox oil whenever greasing the main shaft roller bearings.

Items Needed	Qty
Drain Pan 1 Gallon.....	1
Hex Wrench 4mm.....	1
Open-End Wrench 17mm.....	1
Shop Rags.....	As Needed
ISO68 Oil or Grizzly T27914.....	As Needed

To change gearbox oil:

1. DISCONNECT MACHINE FROM POWER!

2. Remove front cover and rear cover.
3. Working at front of machine, place drain pan under gearbox drain plug (see **Figure 49**).

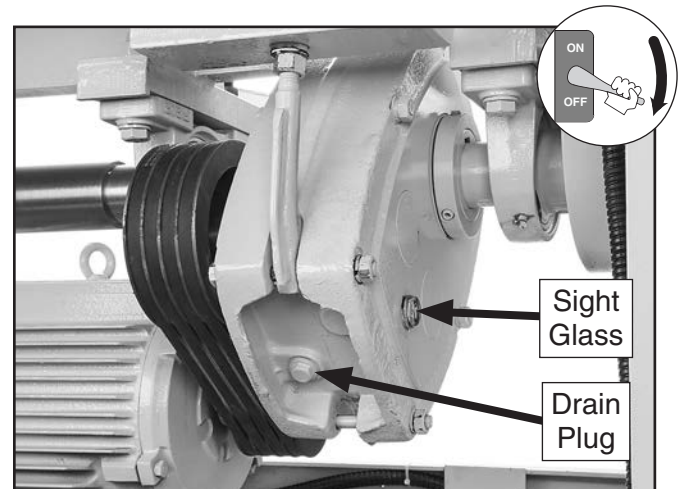


Figure 49. Gearbox drain plug and sight glass (front of machine).

4. Remove drain plug and allow oil to drain, then clean drain plug opening, re-install drain plug, and carefully remove drain pan.
5. Working at rear of machine, remove fill plug (see **Figure 50**).

Note: The fill plug is made of plastic. Be careful if using a wrench to remove it.

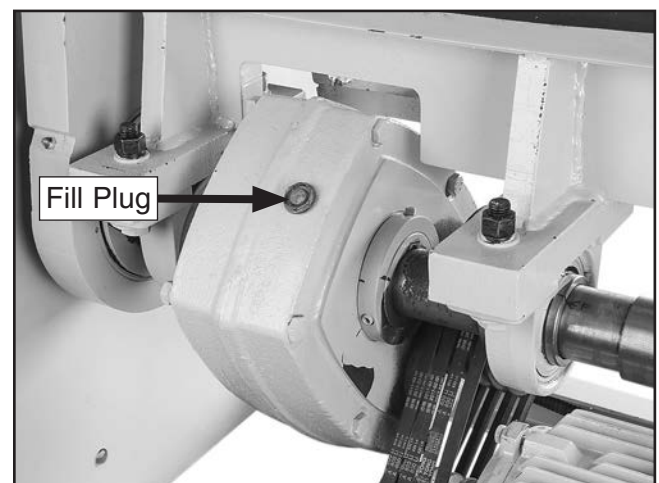


Figure 50. Gearbox fill plug (rear of machine).

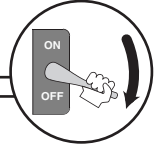
6. Fill gearbox with ISO 68 machine oil or equivalent until oil level is centered in sight glass (see **Figure 49**), then re-install fill plug.
7. Replace front and rear covers.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. Power turned off/disconnected. 2. E-Stop Button(s) depressed/at fault. 3. Tripped circuit breaker. 4. Incorrect power supply voltage or circuit size. 5. Receptacle at fault/wired incorrectly. 6. Power supply circuit breaker tripped or fuse blown. 7. Motor wires connected incorrectly. 8. ON/OFF switch at fault. 9. Shear switch at fault. 10. Blade guard limit switch at fault. 11. Foot pedal time-delay relay at fault. 12. Motor at fault. 	<ol style="list-style-type: none"> 1. Turn ON/OFF switch to ON. 2. Rotate E-Stop Button heads on control panel and control pedestal to reset. Replace if at fault. 3. Re-set circuit breaker/ensure no shorts. 4. Ensure correct power supply voltage and circuit size (Page 10). 5. Test for good contacts; correct the wiring. 6. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 7. Correct motor wiring connections (Page 49). 8. Inspect/replace. 9. Inspect/replace. 10. Inspect/replace. 11. Inspect/replace (Page 48). 12. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Workpiece thickness exceeds shear capacity. 2. Blade gap not correct. 3. Gibs too tight. 4. Motor overheated, tripping machine circuit breaker(s). 5. Machine undersized for task. 6. Belt(s) slipping. 	<ol style="list-style-type: none"> 1. Only use workpiece material that is within shear capacity (Page 5). 2. Properly adjust blade gap (Page 38). 3. Properly adjust gibs (Page 43). 4. Clean motor/let cool, and reduce workload. Reset breaker(s). 5. Use sharp blade (Page 41). 6. Tension/replace belt(s); ensure pulleys are aligned (Page 46).
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. V-belt(s) worn, loose. 3. Pulley(s) loose/misaligned. 4. Motor mount loose/broken. 5. Machine incorrectly mounted/resting on floor. 6. Motor fan rubbing on fan cover. 7. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace damaged bolts/nuts, and re-tighten with blue thread-locking fluid. 2. Inspect/replace belts with a new matched set (Page 46). 3. Realign/replace shaft, pulley, set screw, and key. 4. Tighten/replace. 5. Tighten mounting bolts; relocate/shim machine (Page 19). 6. Fix/replace fan cover; replace loose/damaged fan. 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Motor does not stop when jog button is released.	<ol style="list-style-type: none"> 1. Motor electromagnetic brake at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace.



Cutting Operations

Symptom	Possible Cause	Possible Solution
Shear will not cut workpiece.	<ol style="list-style-type: none"> 1. Workpiece thickness exceeds shear capacity. 2. Blade gap not correct. 3. Hold-down clamp pressure inadequate. 	<ol style="list-style-type: none"> 1. Only use workpiece material that is within shear capacity (Page 5). 2. Inspect/adjust blade gap (Page 38). 3. Adjust hold-down clamp (Page 45).
Cuts are not square.	<ol style="list-style-type: none"> 1. Side work stop not square with blades. 2. Rear work stop not parallel to blades. 3. Blade gap not correct. 	<ol style="list-style-type: none"> 1. Adjust side work stop square with blades (Page 44). 2. Adjust rear work stop parallel to blades (Page 45). 3. Inspect/adjust blade gap (Page 38).
Poor quality of cuts (ripping or tearing).	<ol style="list-style-type: none"> 1. Blade gap not correct. 2. Blades worn or damaged. 3. Hold-down clamp pressure inadequate. 4. Gibs too loose. 	<ol style="list-style-type: none"> 1. Inspect/adjust blade gap to suit workpiece (Page 38). 2. Reverse/sharpen/replace blades (Page 41). 3. Adjust hold-down clamp pressure (Page 45). 4. Adjust gibs (Page 43).
Upper blade does not return to or stop at top dead center.	<ol style="list-style-type: none"> 1. Motor/power cord wiring connected incorrectly/out of phase. 2. Blade travel limit switch cam is out of position. 3. Blade travel limit switch faulty. 4. Motor electromagnetic brake at fault. 	<ol style="list-style-type: none"> 1. Correct motor wiring connections (Page 49). 2. Inspect/adjust cam position (Page 48). 3. Inspect/replace (Page 48). 4. Inspect/replace.

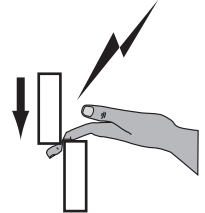


Adjusting Blade Gap

The gap between the upper and lower blades (as they pass each other) must remain even along the length of blades to produce clean, sharp cuts. Two blade gap adjusters (see **Figure 51**) allow operator to quickly adjust blade gap to accommodate different workpiece thicknesses.

Initially, this blade gap adjustment has been made at the factory. However, over time and with normal wear, and after replacing the blades, you will need to re-adjust the blade gap. The position of the upper blade is adjustable. The lower blade is fixed.

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 passing the lower blade and the cutting edges may become damaged.



⚠ WARNING

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.

Checking Blade Gap

Set both blade gap adjusters to "0". Use a piece of construction paper to make cuts along the full length of the blades. All cuts should be clean without bending or tearing the paper.

- If the paper does not cut cleanly only on one end of the shear, the upper blade needs to be adjusted on that end.
- If the paper does not cut cleanly in the middle of the shear, adjust the gap in the middle of the upper blade.
- If the paper does not cut cleanly along the entire length of the shear, adjust the upper blade along its length.

Adjusting Upper Blade

The primary blade gap adjustment is done with an eccentric cam on the top of each blade guide. The blade gap can be fine-tuned with 14 jack screws on the upper blade frame (see **Figure 51**). Blade clearance when the blade gap adjusters are set to 0" should be 0.002"–0.003"; clearance with the adjusters set to 0.0175" is 0.010"–0.012".

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 **Removing & Replacing Blade** on **Page 41** for instructions).

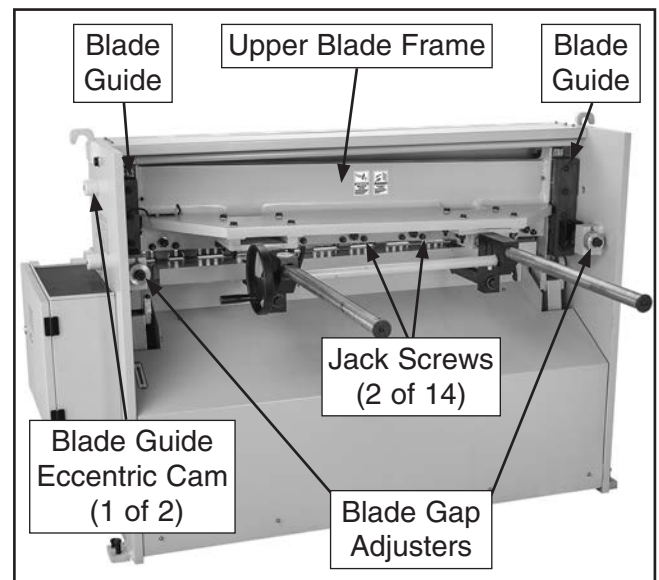


Figure 51. Upper blade adjustments.

Items Needed

	Qty
Sheet of Construction Paper	As Needed
Feeler Gauge Set, 0.002" – 0.012"	1
Wrench or Socket 25mm	1
Wrench or Socket 30mm	1
Wrench or Socket 36mm	1
Wrench Open-End 19mm	1
Wrench Open-End 12mm	1
Hex Wrench 4mm	1
Hex Wrench 3mm	1

To adjust upper blade:

1. DISCONNECT MACHINE FROM POWER!
2. Remove rear cover.
3. Remove blade cover.



- Loosen (2) pressure regulating hex bolts at end of hold-down clamp (see **Figure 52**).

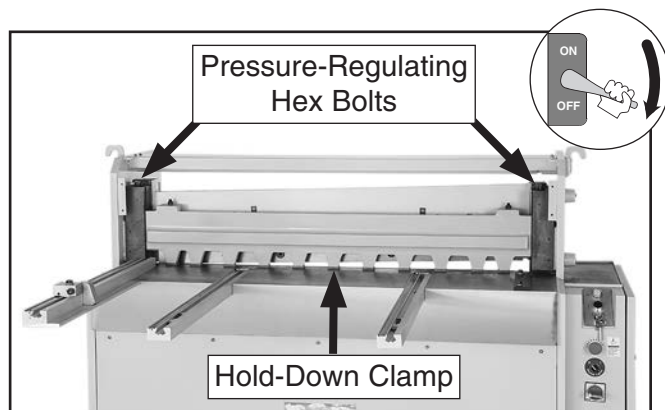


Figure 52. Pressure-regulating hex bolts on hold-down clamp.

- Move rear stop assembly away from blades.
- To release motor brake, push lever right, as shown in **Figure 53**, then turn drive pulley by hand until upper and lower blades completely overlap.

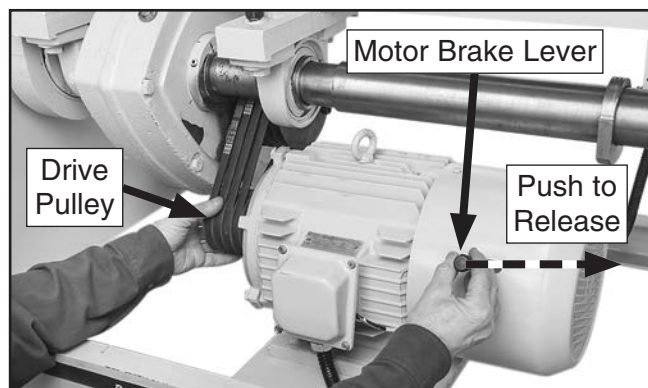


Figure 53. Releasing motor brake to turn motor by hand.

- Turn both blade gap adjusters counterclockwise to 0" setting (see **Figure 54**).

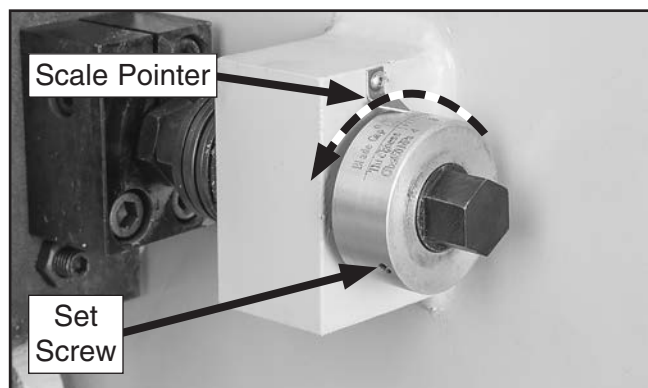


Figure 54. Blade gap adjuster detail.

- Remove (4) plastic caps on side of frame to expose blade guide eccentric cams and blade guide retaining studs (see **Figure 55**).

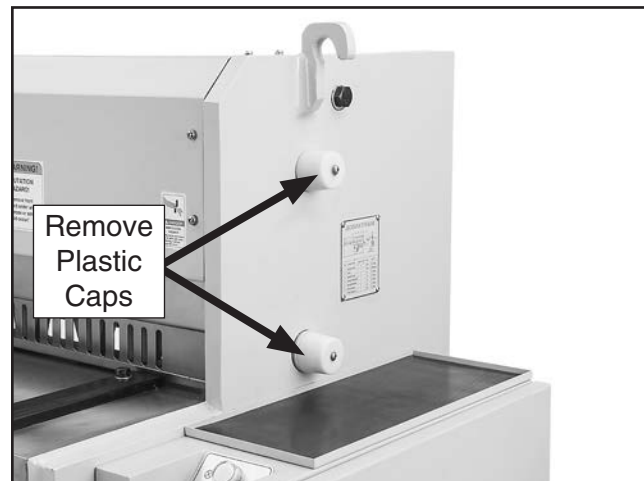


Figure 55. Location of covers for blade guide eccentric cam and retaining stud (right side).

- Slightly loosen hex nuts on both blade guide retaining studs, then loosen hex nuts on both blade guides just enough to adjust eccentric cams (see **Figure 56**).

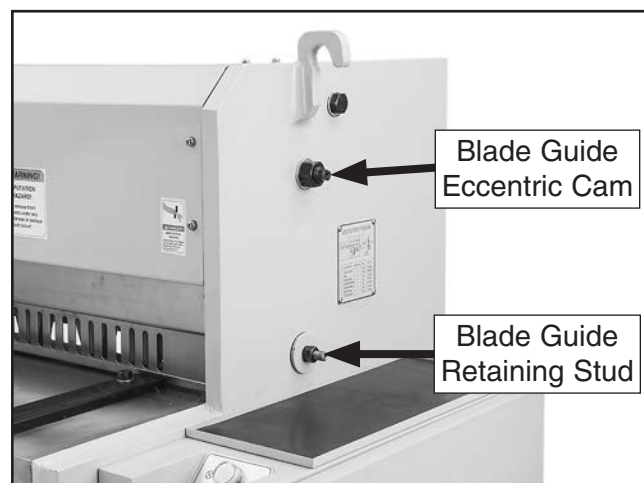


Figure 56. Location of blade guide retaining hex nut and eccentric cam (right side).



- Use feeler gauge to measure gap along length of blades. Turn eccentric cam, as shown in **Figure 57**, to adjust gap to 0.002" along blade length.

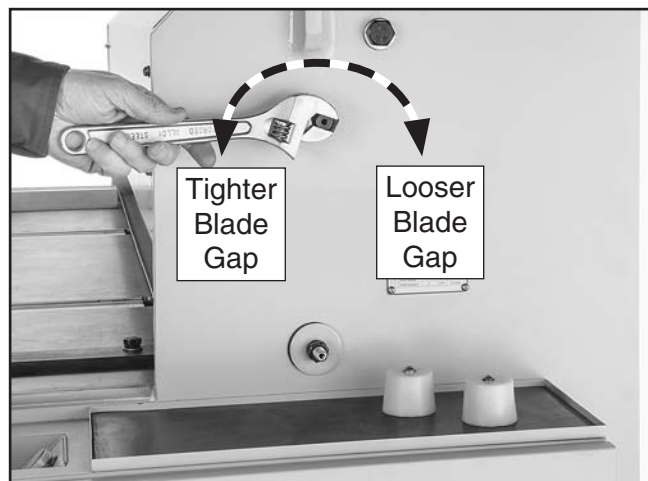


Figure 57. Adjusting blade gap with blade guide eccentric cam (right side).

- Tighten hex nuts loosened in **Step 9**.
- Re-check blade gap. If necessary to achieve blade gap of 0.002" between blade guides, loosen hex nuts and turn jack screws to adjust gap (see **Figure 58**).

— To move blade forward (tighter gap), turn jack screws clockwise.

— To move blade backward (looser gap), turn jack screws counterclockwise.

IMPORTANT: *DO NOT* loosen any of the blade mounting hex nuts between the 14 jack screws on the upper blade frame.

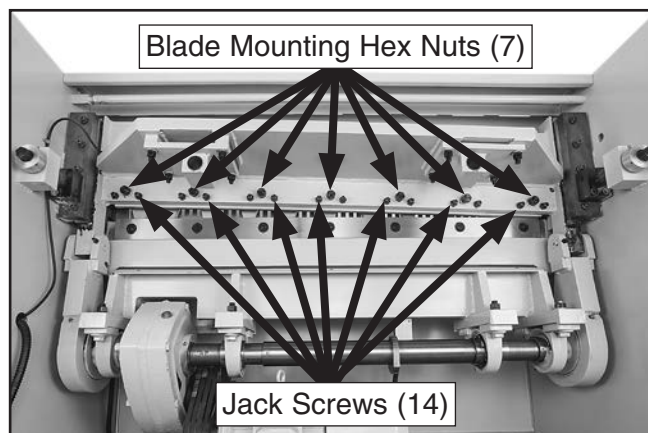


Figure 58. Upper blade jack screws and mounting hex nuts.

- Repeat **Checking Blade Gap** procedure on **Page 38** to test blade gap adjustments.

— If blade gap is correct, hold each jack screw in position and tighten its hex nut, then proceed to **Step 14**.

— If blade gap is not correct, repeat **Steps 9–12** until cut is even.

- Loosen set screw on outside of both blade gap adjusters and align pointers with "0" setting (see **Figure 54** on **Page 39**). Tighten set screws.

Note: *Settings on both adjusters must match in order to maintain gap adjuster accuracy for cutting operations.*

- Evenly tighten pressure-regulating hex bolts on hold-down clamp (see **Figure 52** on **Page 39**).

CAUTION: *DO NOT* overtighten hex bolts to avoid possible damage to hold-down clamp disc springs.

- Re-install plastic caps removed in **Step 8**.
- Re-install upper blade cover and rear cover.



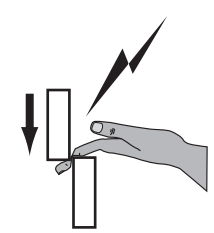
Reversing & Replacing Blades

Each blade has two cutting edges so that if one cutting edge becomes dull, you can reverse the blade and use the fresh, sharp cutting edge. Each flat head cap screw is keyed to align with mounting slots in the blades.

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 screw heads extend beyond the cutting edge, you will need to replace it. If the blade is nicked or damaged, replace it.

IMPORTANT: ALWAYS check the blade gap after installation if you reverse, sharpen, or replace the blades (see **Adjusting Blade Gap** on Page 38).

Contact Grizzly at (800) 523-4777 or online at grizzly.com to purchase Part No. P0845P034. We recommend you keep an extra set of blades on hand to minimize downtime.



! WARNING
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.

Reversing & Replacing Upper Blade

Items Needed	Qty
Hex Wrench 10mm.....	1
Hex Wrench 4mm.....	1
Wrench or Socket 36mm.....	1
Socket 25mm and 12" Extension	1 Ea
Eye Bolts M10-1.5.....	2
Lifting Strap or Chain (Rated for 500 lbs.).....	1
Forklift.....	1
Mineral Spirits.....	As Needed
Shop Rags.....	As Needed
Another Person.....	1
1x4 and 2x4 Wood Blocks.....	1 Ea
Heavy Leather Gloves.....	1 Pair Per Person

Model G0845P (Mfd. Since 01/18)



1. DISCONNECT MACHINE FROM POWER!
2. Remove upper blade cover and finger guard (see **Figure 59**).

IMPORTANT: Note how the finger guard engages blade guard limit switch. The shear will not operate if the finger guard is removed or does not engage the limit switch.

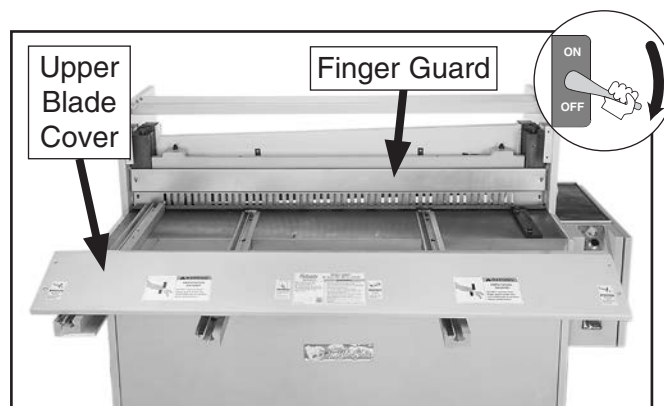


Figure 59. Upper blade cover and finger guard removal.

3. Remove two pressure-regulating hex bolts on hold-down clamp (see **Figure 60**), then lift out shaft and disc spring stack on each side.

IMPORTANT: DO NOT remove any disc springs from shaft. Store the disc spring stack in a safe location until re-installing the blade.

4. Install (2) M10-1.5 eye bolts into top of hold-down clamp where shown in **Figure 60**.

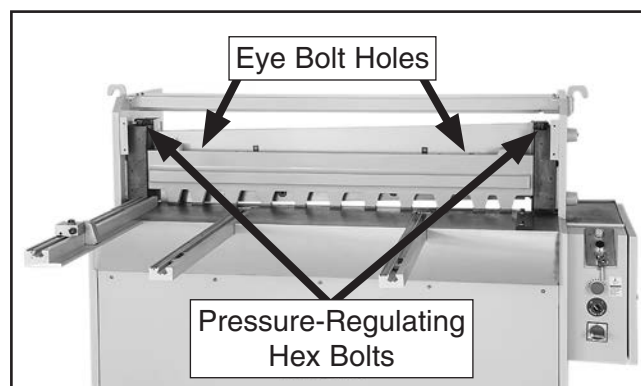


Figure 60. Hold-down clamp removal.

5. Attach lifting strap or chain to eye bolts, then lift hold-down clamp with forklift while assistant guides it evenly out of blade guide slots.

6. Move rear work stop assembly all the way forward.
7. Place 1x4 and 2x4 wood blocks on top of table and rear stop assembly to support upper blade should it slip during **Step 9**.
8. While assistant holds keyed flat head cap screw at front of upper blade, loosen but **DO NOT** remove (7) corresponding hex nuts and (7) flat washers on back of blade frame (see **Figure 61**).

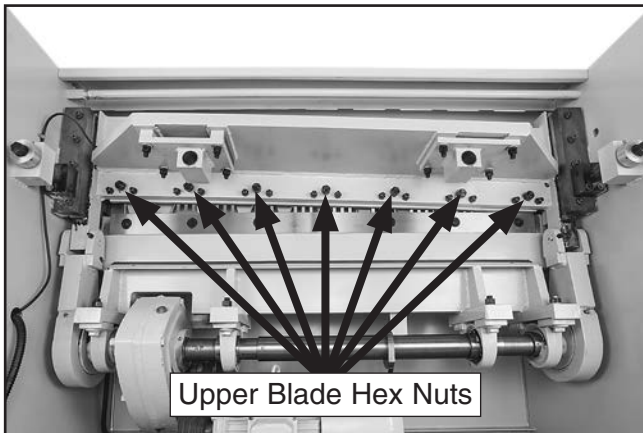


Figure 61. Upper blade hex nut removal (rear work stop and rear cover removed for clarity).

9. Put on heavy leather gloves, then remove (7) hex nuts and (7) flat washers before pulling upper blade and (7) upper keyed flat head cap screws from frame.
10. Installation is reverse of removal.

IMPORTANT: *Align keyed flat head cap screws with slots in blade before tightening fasteners. Check blade gap after installing blade (see **Page 38**).*

Note: *Clean mounting surface and blade with mineral spirits before re-installing blade.*

NOTICE

If shear does not start after reassembly, inspect blade guard limit switch. The shear will not operate if the finger guard is removed or does not engage the limit switch after reassembly. If necessary, adjust finger guard position and/or limit switch mounting plate to engage limit switch.

Reversing & Replacing Lower Blade

Items Needed	Qty
Hex Wrench 10mm.....	1
Hex Wrench 4mm.....	1
Open-End Wrench 25mm.....	1
Another Person.....	1
Heavy Leather Gloves.....	1 Pair Per Person
Mineral Spirits.....	As Needed
Shop Rags.....	As Needed

1. **DISCONNECT MACHINE FROM POWER!**
2. Remove front cover, rear cover, and rear work stop assembly.
3. Have assistant wearing heavy leather gloves hold keyed flat head cap screws at rear of machine. Working from front of machine, loosen but do not remove (7) hex nuts and flat washers securing lower blade to rear of table (see **Figures 62 & 63**).

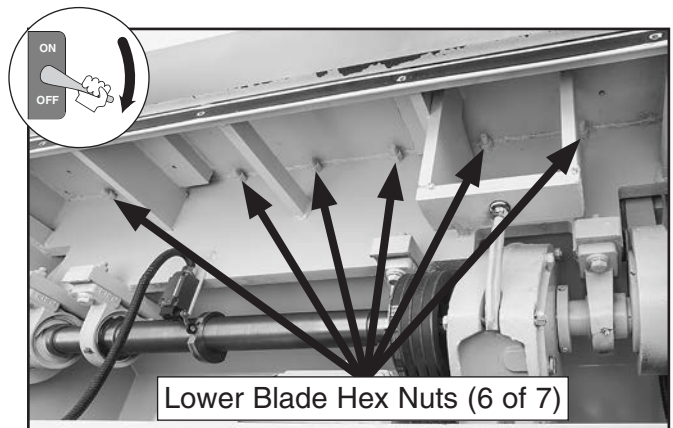


Figure 62. Location of hex nuts and flat washers securing lower blade to frame.

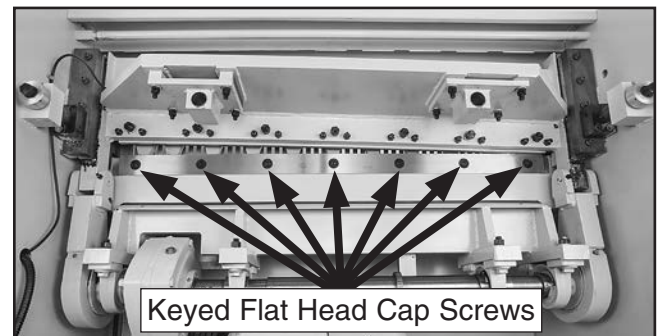


Figure 63. Location of keyed flat head cap screws in lower blade.



4. With assistant at rear of machine to support blade, remove hex nuts and flat washers loosened in **Step 3**, then have assistant pull blade off frame (see **Figure 63**).
5. Installation is reverse of removal.

IMPORTANT: *Align keyed flat head cap screws with slots in blade before tightening fasteners. Check blade gap after installing blade (see **Page 38**).*

Note: *Clean mounting surface and blade with mineral spirits before re-installing blade.*

Adjusting Gibs

There are four copper plates on each side of the upper blade frame that ride between the blade guide and upper blade frame—two front, two rear (see **Figure 64**). They are made of copper so the plates wear instead of the frame. The rear copper plates act as gibs that apply pressure to keep movement of the upper blade tight and precise within the blade guide.

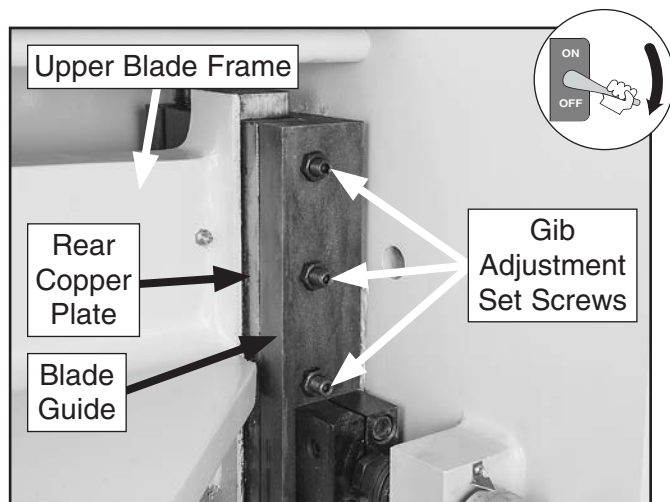


Figure 64. Gib adjustment controls (right side).

If the gibs are too loose, the quality of the cuts will suffer because the movement will be sloppy when the shear is engaged. 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 upper blade frame snug without interfering with the sliding action.

Items Needed	Qty
Open-End Wrench 19mm.....	1
Hex Wrench 6mm.....	1

To adjust gibs:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen (6) hex nuts on gib adjustment set screws (see **Figure 64**).
3. Tighten all (6) gib adjustment set screws evenly until gibs are snug against copper sliding plates, then back off gib adjustment set screws $\frac{1}{8}$ turn.
4. Make test cut to check sliding action and quality of cut. If necessary, turn gib adjustment set screws clockwise to tighten gib or counterclockwise to loosen gib, then repeat test and adjust as necessary until you are satisfied with gib adjustment.
5. Hold set screw in position and tighten hex nut to secure gib adjustment.



Squaring Side Work Stops

The Model G0845P left and right work stops are adjusted at the factory to be square, but they can be adjusted if cutting operations are no longer producing satisfactory results.

Items Needed	Qty
Hex Wrench 6mm.....	1
Wrench or Socket 18mm.....	1
Magnetic Base Blocks (See Page 31).....	2
Carpenter's Square 16" x 24"	1

Squaring Left Work Stop

1. Place upper blade at top dead center using foot switch.
2. DISCONNECT MACHINE FROM POWER!
3. Place (2) magnetic base blocks 12" apart on right side of lower blade (see **Figure 65**).

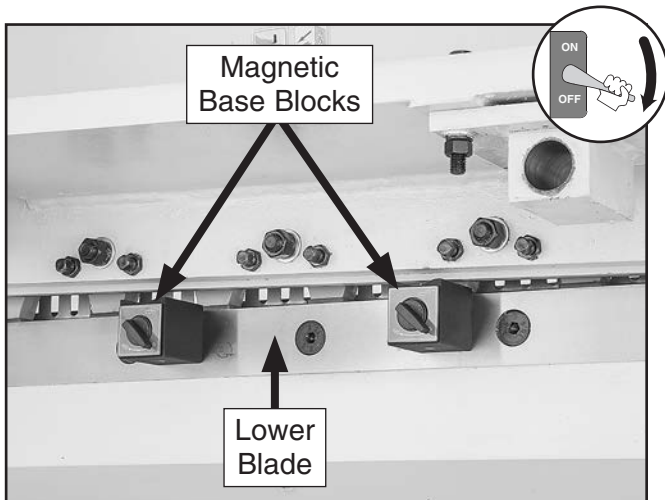


Figure 65. Magnetic base blocks used to check squareness of work stops.

4. Place carpenter's square against magnetic base blocks and left work stop.
5. If square aligns with base blocks and left work stop, no adjustment is necessary.
6. If left work stop does not align with square, loosen (2) cap screws securing work stop to table and adjust work stop to align with square. Tighten cap screws.

Squaring Right Work Stop

1. Place upper blade at top dead center using foot switch.
2. DISCONNECT MACHINE FROM POWER!
3. Place (2) magnetic base blocks 12" apart on left side of lower blade (see **Figure 65**).
4. Place carpenter's square against magnetic base blocks and right work stop.
5. If square aligns with base blocks and right work stop, no adjustment is necessary.
6. If right work stop does not align with square, loosen (2) hex bolts securing work stop to table and adjust work stop to align with square. Tighten hex bolts.



Squaring Rear Work Stop

The Model G0845P rear work stop is adjusted at the factory to be square, but it can be adjusted if cutting operations are no longer producing satisfactory results.

Note: Make sure left and right work stops are square before attempting to adjust rear work stop.

Items Needed	Qty
Wrench or Socket 18mm.....	2
Carpenter's Square 16" x 24".....	2
Fine Ruler 24".....	2

To square rear work stop:

1. Place upper blade at top dead center using foot switch.
2. DISCONNECT MACHINE FROM POWER!
3. Use handwheel to move rear work stop all the way forward (see **Figure 66**).



Figure 66. Checking rear work stop parallelism.

4. Place fine rulers against each side work stop and rear work stop, then use carpenter's squares to measure rear work stop for parallelism.

5. To adjust rear work stop, loosen (4) hex nuts attaching lower support rods to rear work stop, then adjust rear work stop until it is parallel with lower blade (see **Figure 67**).

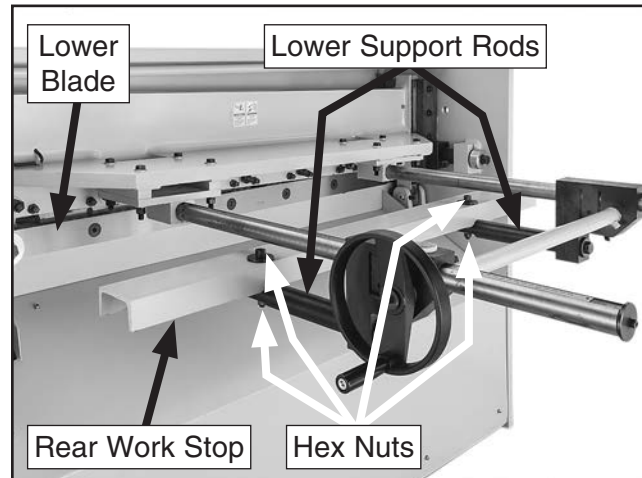


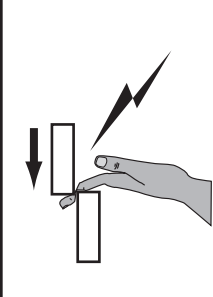
Figure 67. Adjusting rear work stop parallelism.

6. Tighten hex nuts when complete.

Adjusting Hold-Down Clamp

The Model G0845P uses a polyester-faced hold-down clamp to secure the workpiece in position during cutting operations, without marring the workpiece surface. The clamp pressure and worktable gap are adjustable.

Items Needed	Qty
Hex Wrench 4mm.....	1
Flat Screwdriver #2.....	1
Wrench Open-Ends 18mm.....	1
Wrench or Socket 36mm.....	1
Sheet Stock (Up to 9/32").....	1
Scrap Sheet Stock (Up to 10 Ga.).....	As Needed



⚠ WARNING
The hold-down can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from the hold-down during operation.



To adjust hold-down clamp pressure and gap:

1. Position upper blade at top dead center.
2. DISCONNECT MACHINE FROM POWER!
3. Remove blade cover (see **Figure 68**).

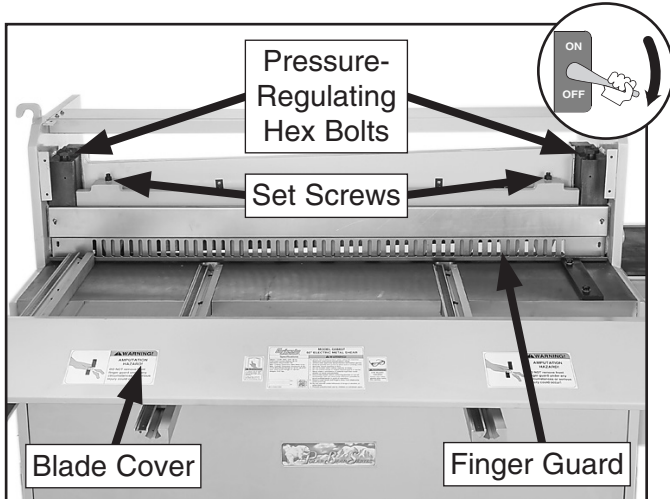


Figure 68. Hold-down clamp adjustments.

3. To adjust hold-down clamp pressure, loosen hex bolts to reduce pressure; tighten hex bolts to increase pressure (see **Figure 68**). Perform test cut and re-adjust bolts if needed.

IMPORTANT: Always adjust hex bolts evenly in order to avoid possible damage to disc spring stack.

4. To adjust hold-down clamp gap, place sheet stock under hold-down clamp, loosen hex nuts at each end of clamp, then adjust set screws until clearance is even on both ends. Tighten hex nuts to secure gap setting.

CAUTION: DO NOT exceed $\frac{9}{32}$ " for hold-down clamp gap. A larger gap can reduce clamp pressure and possibly damage workpiece by marring surface if it slips during cutting operation. When cutting thinner material, reduce hold-down clamp gap and perform **Step 3**.

5. Re-install blade cover.

Tensioning & Replacing V-Belts

The Model G0845P is fitted with four V-belts that transfer power between the motor and gearbox. After initial break-in, the V-belts slightly stretch and seat into the pulley. It is important to check and adjust them to compensate for this initial wear. Check the tension thereafter on a monthly basis. If one or more belts become excessively worn or damaged, replace all four as a set.

Items Needed	Qty
Hex Wrench 4mm.....	1
Wrench 19mm	2
Wrench 24mm	1
V-Belts (Part Number P0845P063)	4

Checking V-Belt Tension

1. DISCONNECT MACHINE FROM POWER!
2. Remove front cover.
3. Check belt tension. Each belt is correctly tensioned when there is approximately $\frac{1}{4}$ " deflection when it is pushed with moderate pressure, as shown in **Figure 69**.

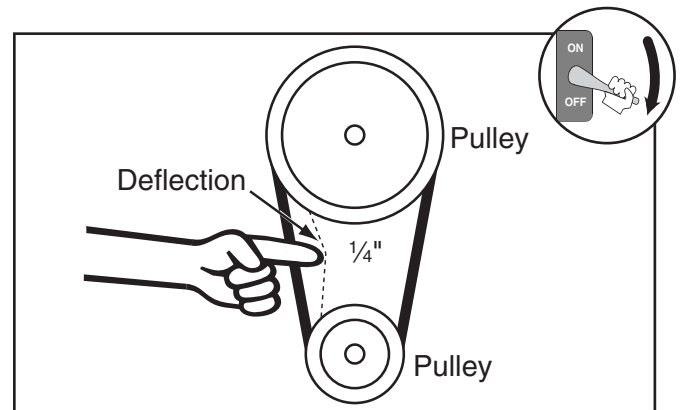


Figure 69. Correct V-belt deflection.

— If there is more than $\frac{1}{4}$ " deflection when each belt is pushed with moderate pressure, refer to **Adjusting V-Belt Tension** on **Page 47**.

4. If belt tension is correct, replace front cover.



Adjusting V-Belt Tension

1. DISCONNECT MACHINE FROM POWER!
2. Loosen hex bolt and hex nut that pass through bottom of motor mount shaft, then loosen lower hex nut and tighten upper hex nut in equal amounts to tighten belts until deflection equals $\frac{1}{4}$ " (see **Figure 70**).

Note: If belt deflection cannot be adjusted to equal $\frac{1}{4}$ ", replace all four belts. Refer to **Replacing V-Belts**.

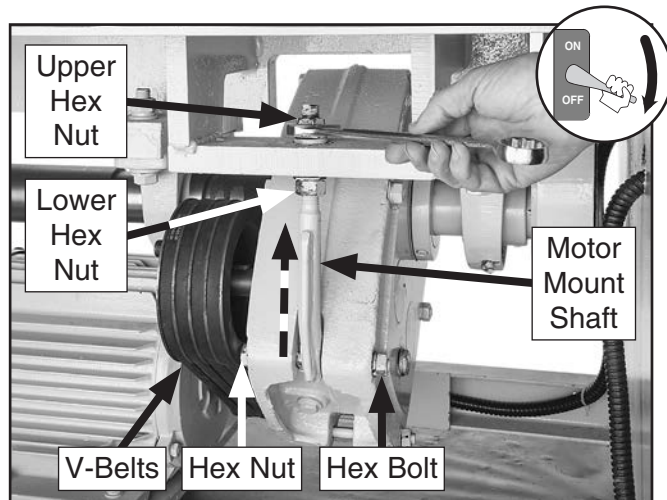


Figure 70. Adjusting motor mount shaft upward to tighten V-belt tension.

3. After properly tensioning belts, tighten all nuts and bolts.
4. Replace front cover.

Replacing V-Belts

1. DISCONNECT MACHINE FROM POWER!
2. Remove front cover.

3. Loosen hex bolt and hex nut that pass through motor mount shaft (see **Figure 71**).

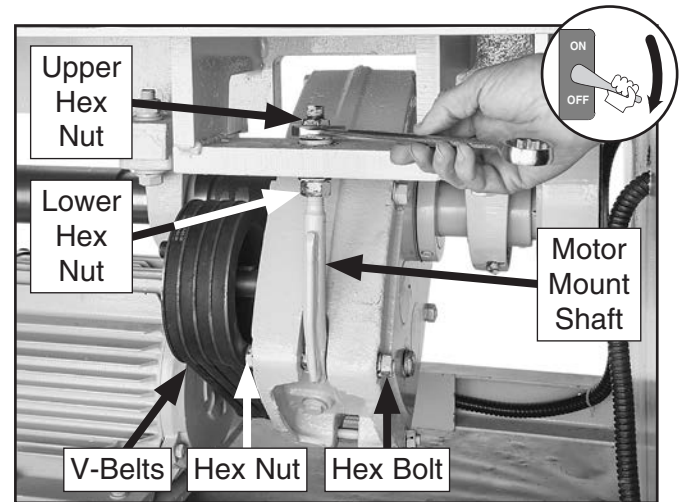


Figure 71. Loosening motor to remove V-belts.

4. Remove upper hex nut and spherical washer at top of motor mount shaft (see **Figure 72**). Tighten lower hex nut to shift motor down for clearance to roll V-belts off gearbox pulley.

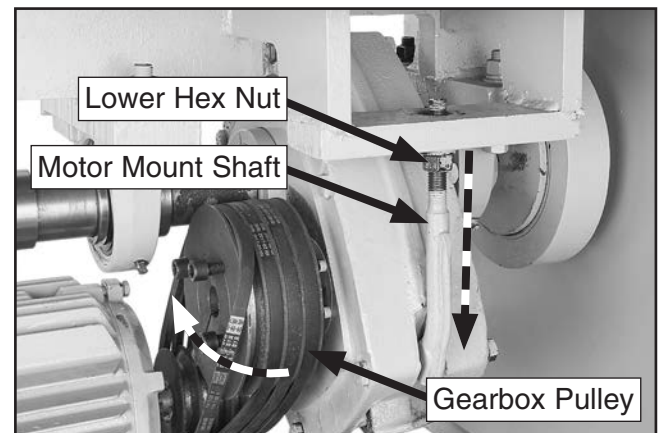


Figure 72. V-belt removal from gearbox pulley.

5. Install (4) new V-belts as a set.
6. Lift motor up, then replace spherical washer and upper hex nut removed in **Step 4**.
6. Tension belts (refer to **Tensioning V-Belts** on this page.)
7. Replace front cover.



Adjusting Foot-Pedal Time Delay

The Model G0845P features an adjustable time-delay relay for foot-pedal operation. The relay sets a delay of 0 seconds to 10 seconds before the upper blade begins a cutting cycle after the foot pedal is pressed down.

To adjust foot-pedal time delay:

1. DISCONNECT MACHINE FROM POWER!
2. Open electrical box door.
3. Turn knob on time-delay relay to adjust foot pedal time delay (see **Figure 73**).

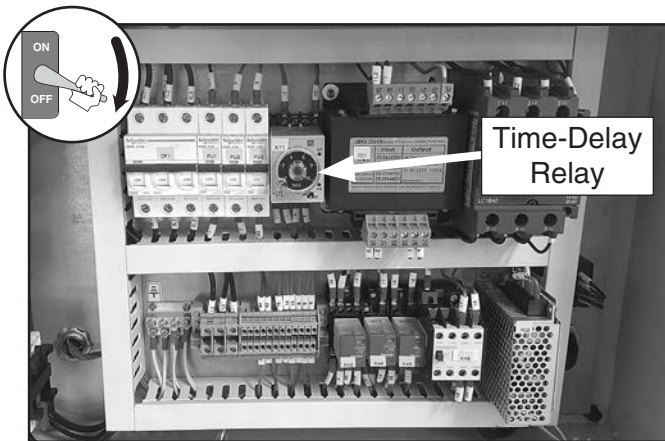


Figure 73. Location of foot pedal time-delay relay.

4. Turn machine **ON**, then press foot pedal to test setting.
5. When complete, turn machine **OFF**, then close and lock electrical control box door.

Adjusting Blade-Travel Limit Switch

The Model G0845P uses a limit switch on the main shaft to stop the upper blade travel at top dead center when using the foot pedal. Adjust or replace the limit switch if the upper blade does not stop at top dead center.

Items Needed	Qty
Hex Wrench 4mm.....	1

To adjust blade-travel limit switch:

1. DISCONNECT MACHINE FROM POWER!
2. Remove front cover and rear cover.
3. Position upper blade at top dead center. If necessary, disengage motor brake (see **Figure 53** on **Page 39**), then turn drive pulley by hand to move blade to top dead center.
4. If cam is not in "stop" position 90° to floor as shown in **Figure 74**, loosen (2) set screws, rotate cam, then tighten set screws.

IMPORTANT: Keep limit switch wheel centered over cam when adjusting cam position.

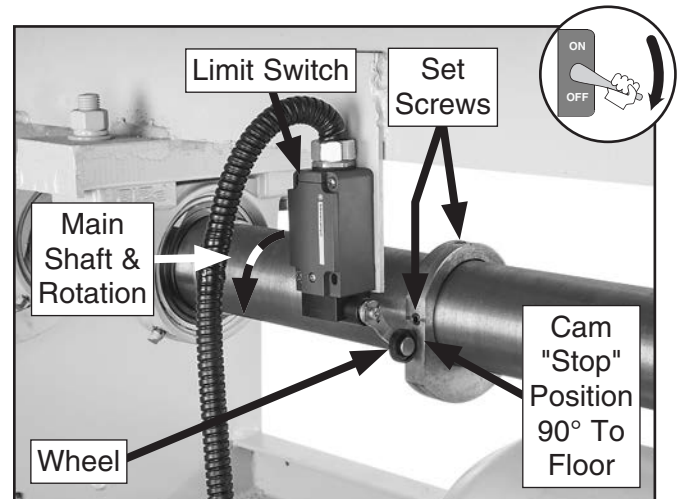


Figure 74. Blade travel limit switch location.

5. Turn machine **ON** and use foot pedal to test limit switch.
 - If main shaft *does* stop where shown in **Figure 74**, limit switch works properly. Mark cam and shaft for future reference.
 - If main shaft *does not* stop where shown in **Figure 74**, replace limit switch and perform **Steps 3–5** if necessary.
6. Replace front cover and rear cover.



SECTION 8: WIRING

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

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

WARNING

Wiring Safety Instructions

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

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

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

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

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

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













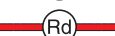

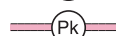
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

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

COLOR KEY

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



Electrical Components

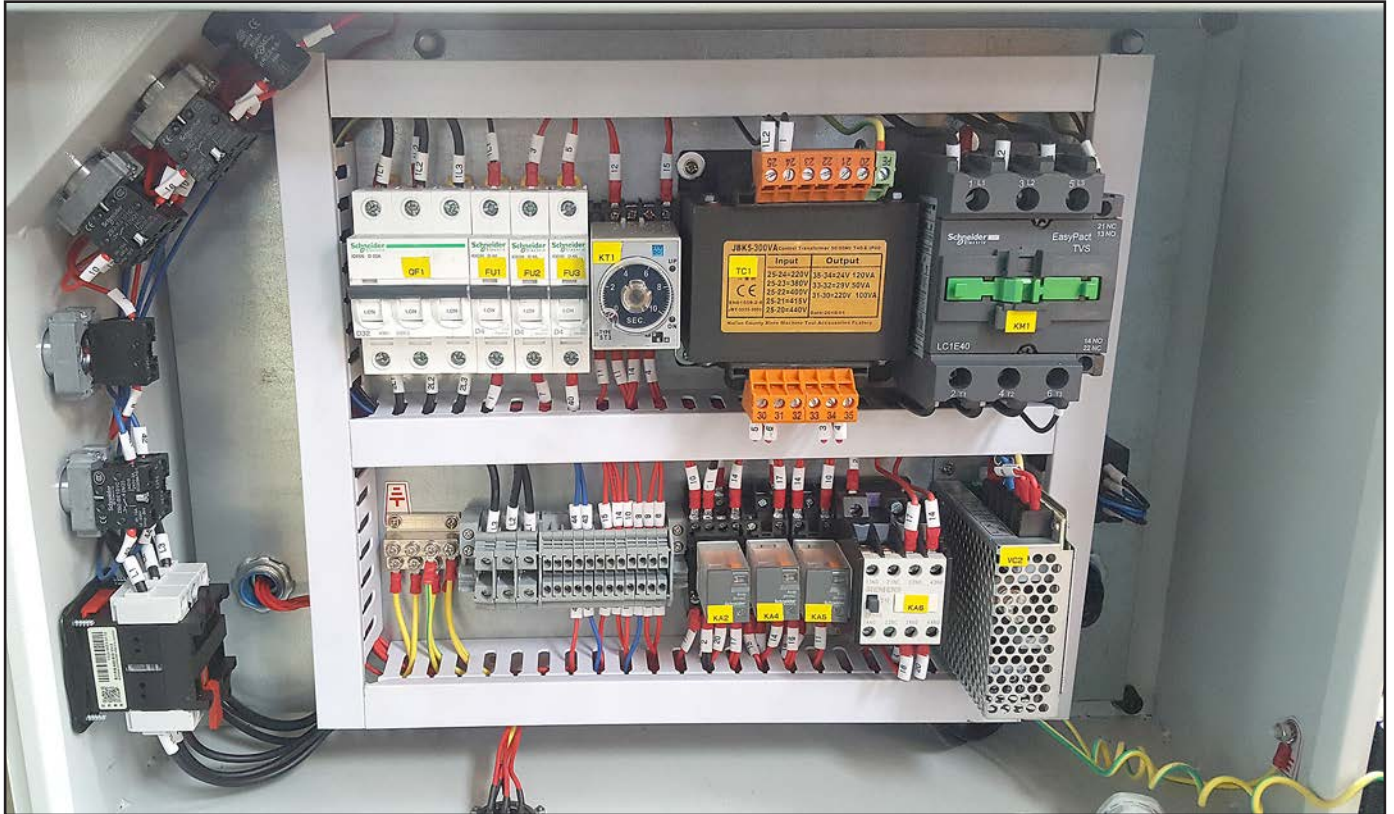


Figure 75. Electrical box components.



Figure 76. Control panel.

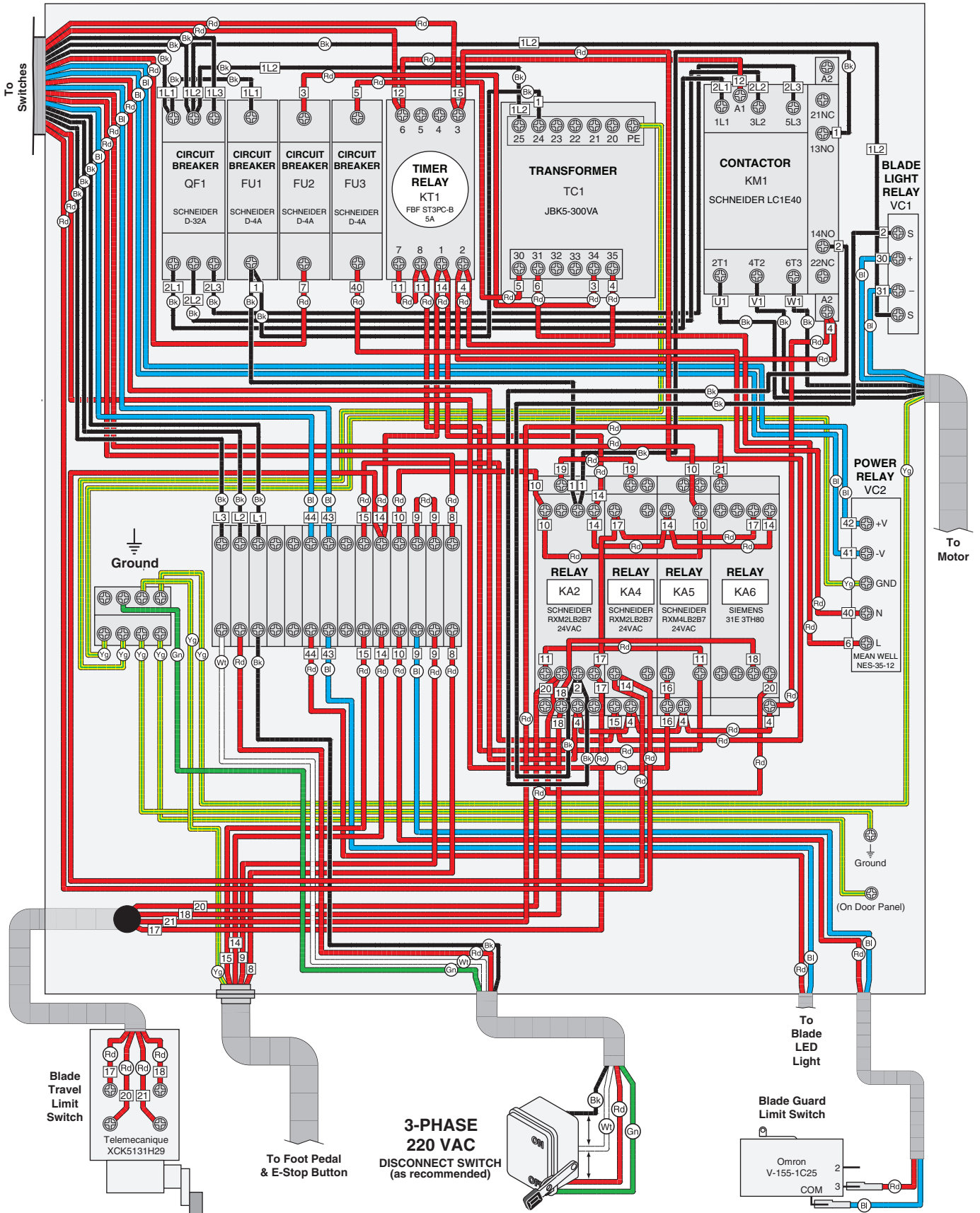


Figure 77. Blade travel limit switch (top) and blade guard limit switch (bottom).



Electrical Box Wiring Diagram

Electrical Box



Control Panel Wiring Diagram

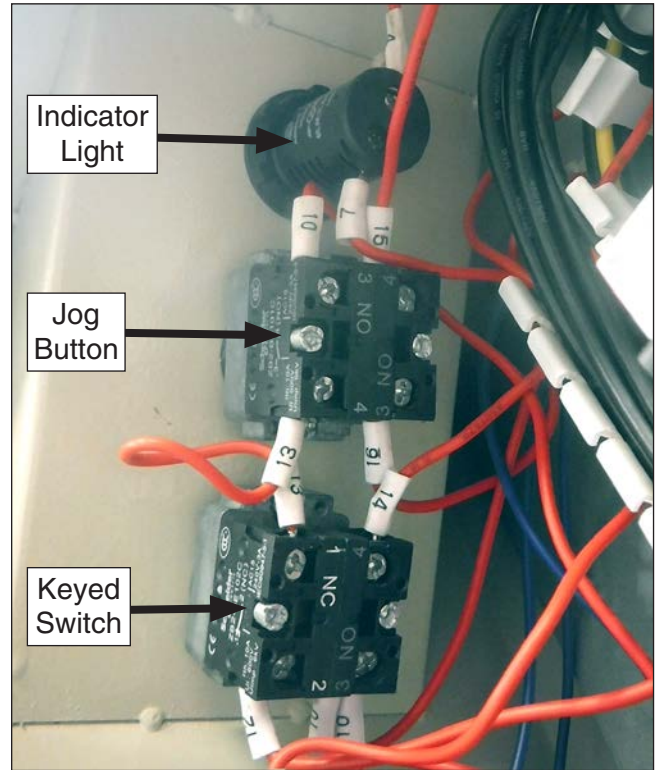
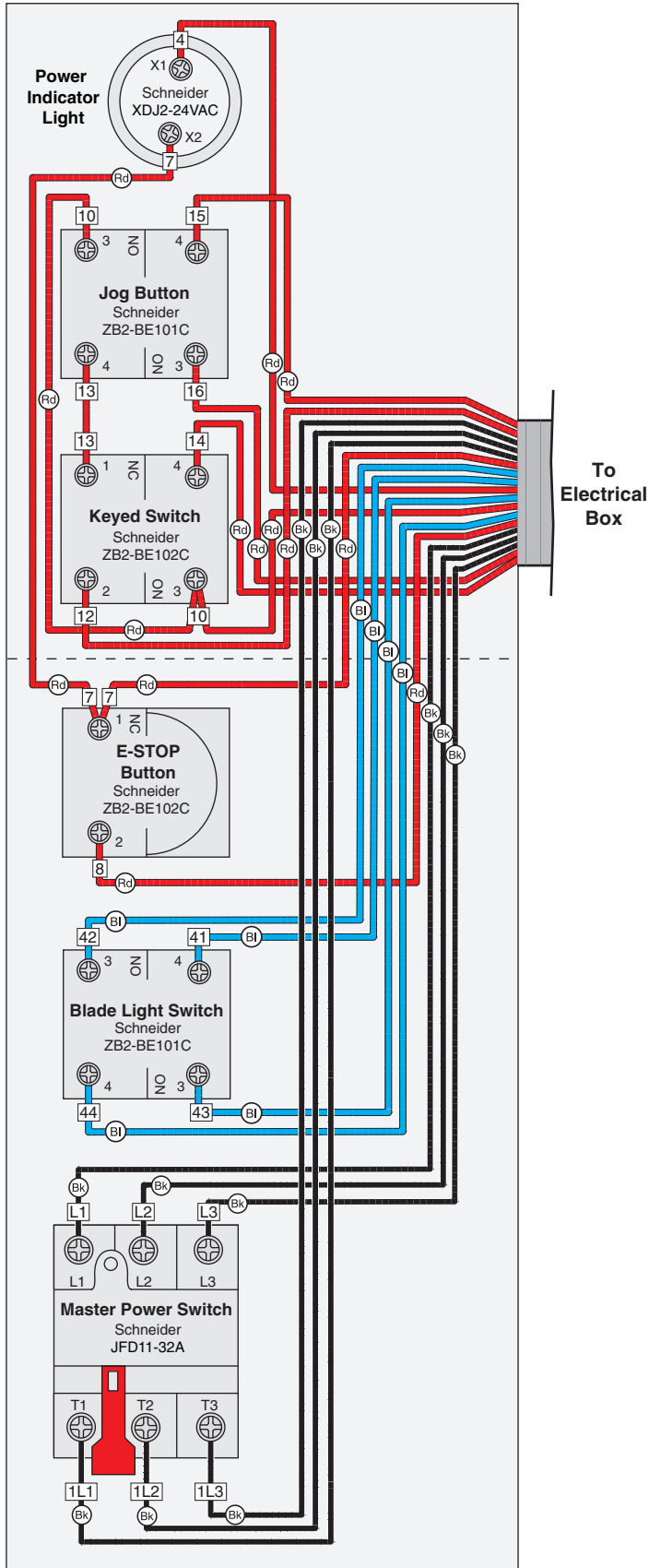


Figure 78. Upper control panel components.

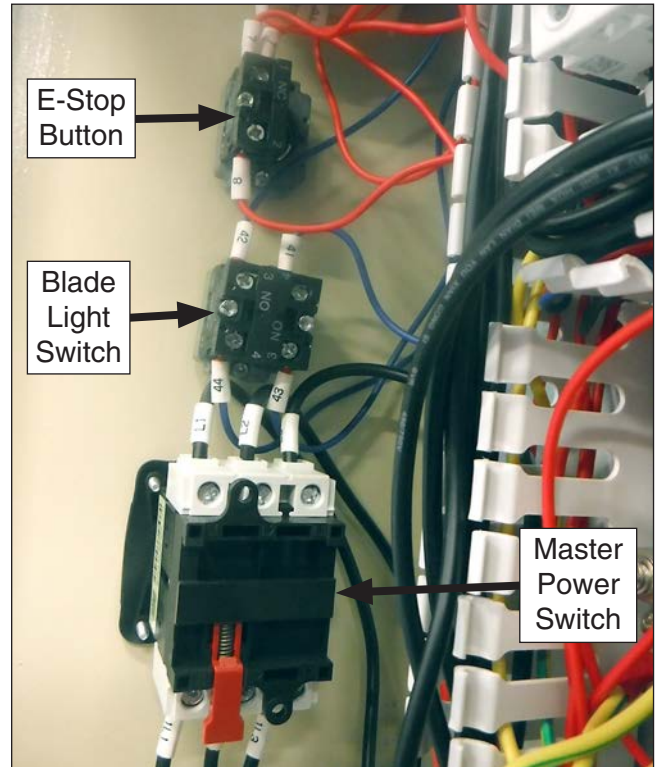


Figure 79. Lower control panel components.



Foot Pedestal & Motor Wiring

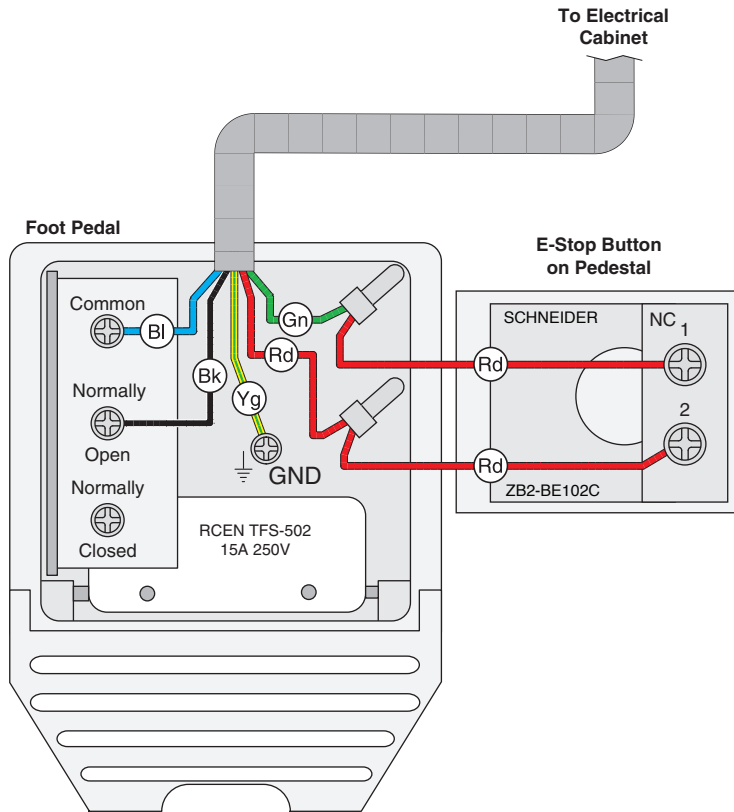


Figure 80. Foot pedestal.

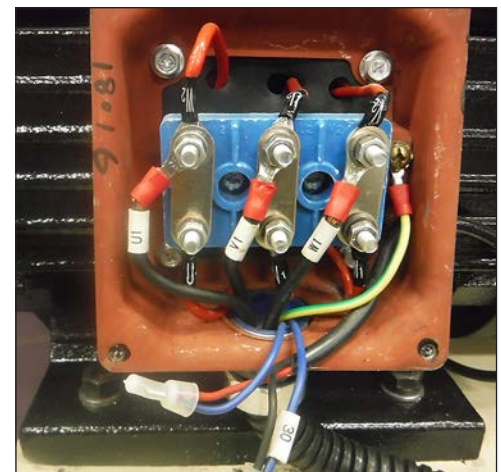
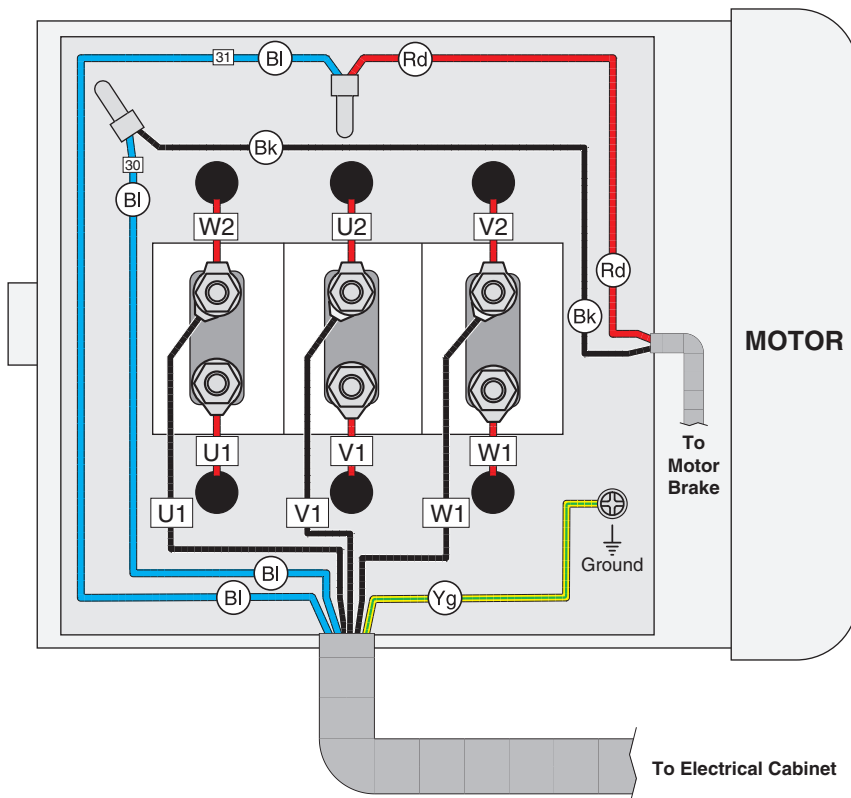
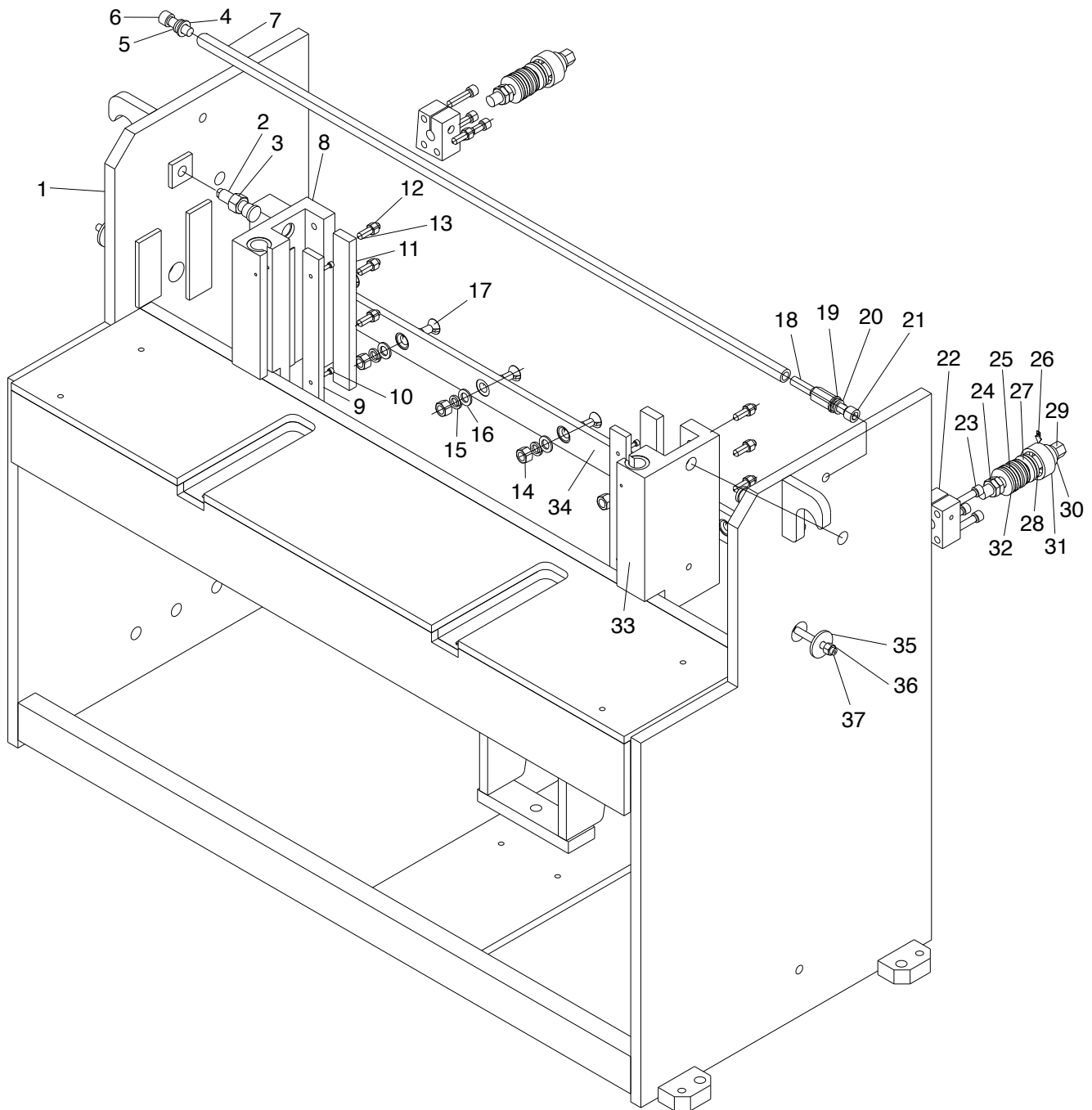


Figure 81. Motor junction box.



SECTION 9: PARTS

Frame



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.



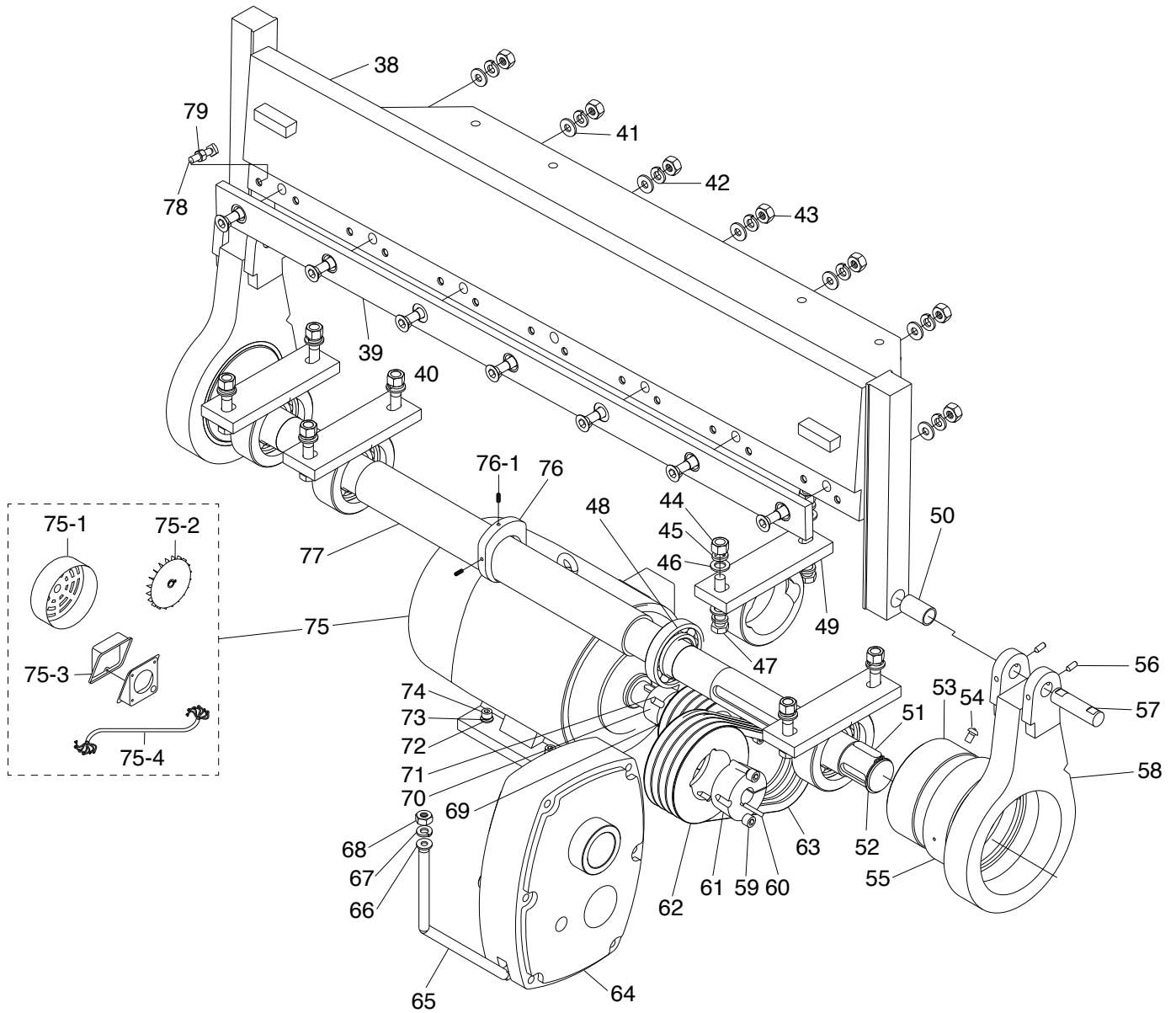
Frame Parts List

REF	PART #	DESCRIPTION
1	P0845P001	FRAME
2	P0845P002	ECCENTRIC SHAFT
3	P0845P003	HEX NUT M20-2.5
4	P0845P004	LOCK WASHER 16MM
5	P0845P005	FLAT WASHER 16MM
6	P0845P006	CAP SCREW M16-2 X 50
7	P0845P007	SUPPORT BAR
8	P0845P008	BLADE GUIDE (LEFT)
9	P0845P009	FRONT GIB
10	P0845P010	CAP SCREW M16-2 X 16
11	P0845P011	REAR GIB
12	P0845P012	HEX NUT M12-1.75
13	P0845P013	SET SCREW M12-1.75 X 50
14	P0845P014	HEX NUT M16-2
15	P0845P015	LOCK WASHER 16MM
16	P0845P016	FLAT WASHER 16MM
17	P0845P017	FLAT HD SCR KEYED M16-2 X 70
18	P0845P018	CONNECTING ROD
19	P0845P019	LOCK WASHER 16MM

REF	PART #	DESCRIPTION
20	P0845P020	FLAT WASHER 16MM
21	P0845P021	CAP SCREW M16-2 X 50
22	P0845P022	BLADE QUICK ADJUST BASE
23	P0845P023	CAP SCREW M12-1.75 X 50
24	P0845P024	HEX NUT M20-2.5
25	P0845P025	COMPRESSION SPRING
26	P0845P026	POINTER
27	P0845P027	SPHERICAL WASHER 24MM
28	P0845P028	FLAT WASHER 20MM
29	P0845P029	BLADE QUICK ADJUST SHAFT
30	P0845P030	FLAT WASHER 26MM
31	P0845P031	BLADE GAP DIAL
32	P0845P032	FLAT WASHER 20MM
33	P0845P033	BLADE GUIDE (RIGHT)
34	P0845P034	LOWER BLADE
35	P0845P035	FLAT WASHER 13MM
36	P0845P036	HEX NUT M12-1.75
37	P0845P037	BLADE GUIDE RETAINING STUD



Upper Blade-Motor-Gearbox Parts



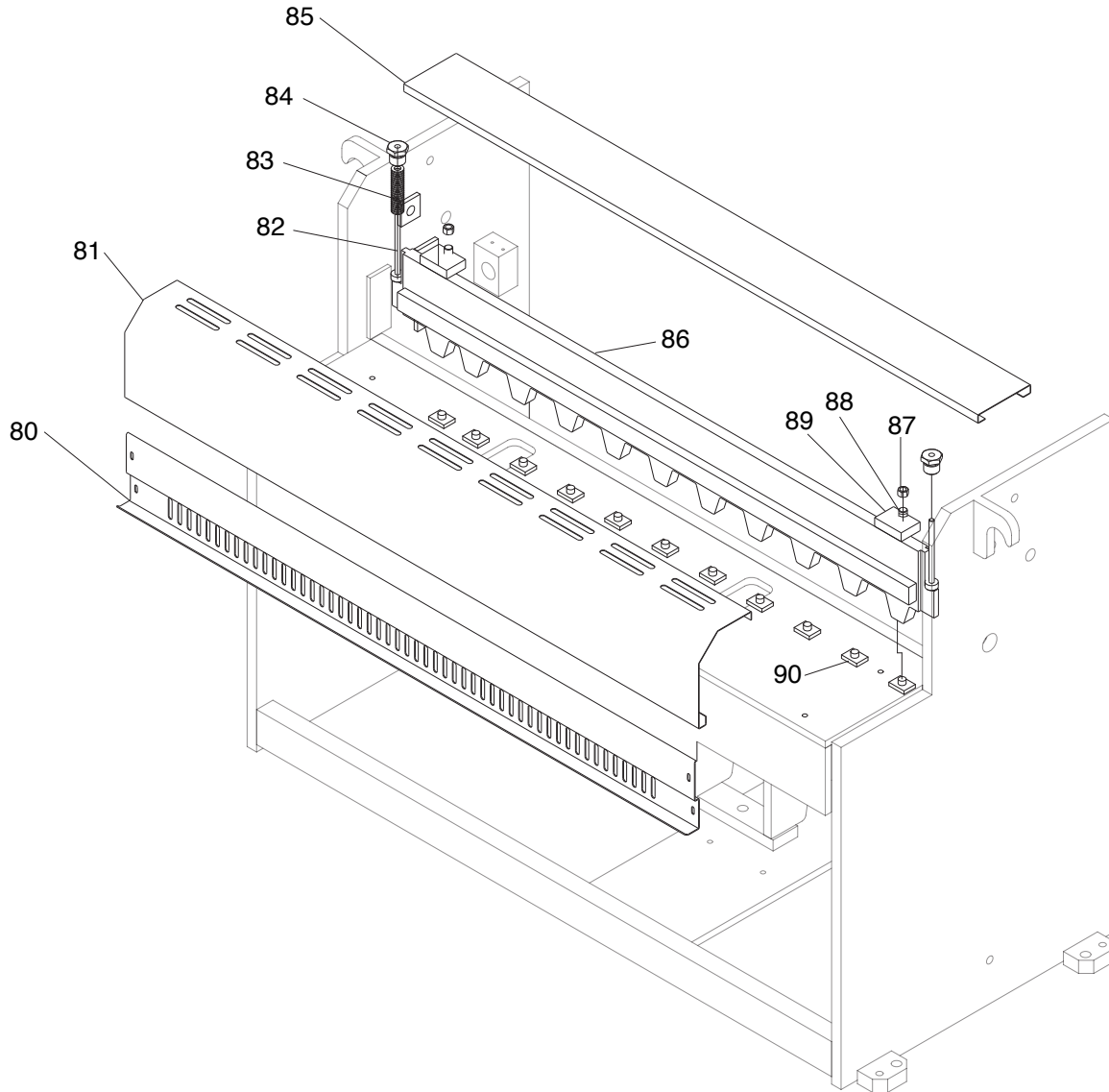
Upper Blade-Motor-Gearbox Parts List

REF	PART #	DESCRIPTION
38	P0845P038	UPPER BLADE FRAME
39	P0845P039	UPPER BLADE
40	P0845P040	FLAT HD SCR KEYED M16-2 X 70
41	P0845P041	FLAT WASHER 16MM
42	P0845P042	LOCK WASHER 16MM
43	P0845P043	HEX NUT M16-2
44	P0845P044	HEX NUT M10-1.5
45	P0845P045	LOCK WASHER 16MM
46	P0845P046	FLAT WASHER 16MM
47	P0845P047	HEX BOLT M16-2 X 80
48	P0845P048	BALL BEARING ER-212 SEALMASTER
49	P0845P049	BEARING SEAT
50	P0845P050	SLEEVE
51	P0845P051	KEY 16 X 10 X 55
52	P0845P052	EXT RETAINING RING 55MM
53	P0845P053	ECCENTRIC CAM BUSHING
54	P0845P054	GREASE FITTING M10-1 STRAIGHT
55	P0845P055	BUSHING
56	P0845P056	SET SCREW M8-1.25 X 16
57	P0845P057	SHAFT
58	P0845P058	CONNECTING ROD
59	P0845P059	CAP SCREW M12-1.75 X 40
60	P0845P060	KEY 8 X 6 X 40
61	P0845P061	GEARBOX PULLEY SLEEVE

REF	PART #	DESCRIPTION
62	P0845P062	GEARBOX PULLEY
63	P0845P063	V-BELT A 800 LT
64	P0845P064	REDUCTION GEARBOX
65	P0845P065	GEARBOX MOUNT ROD
66	P0845P066	FLAT WASHER 16MM
67	P0845P067	LOCK WASHER 16MM
68	P0845P068	HEX NUT M16-2
69	P0845P069	DRIVE PULLEY
70	P0845P070	DRIVE PULLEY SLEEVE
71	P0845P071	CAP SCREW M10-1.5 X 40
72	P0845P072	CAP SCREW M10-1.5 X 40
73	P0845P073	FLAT WASHER 10MM
74	P0845P074	LOCK WASHER 10MM
75	P0845P075	MOTOR 7.5HP 220V 3-PH
75-1	P0845P075-1	MOTOR FAN COVER
75-2	P0845P075-2	MOTOR FAN
75-3	P0845P075-3	JUNCTION BOX
75-4	P0845P075-4	MOTOR POWER CORD 6W 48"
76	P0845P076	BLADE LIMIT SWITCH CAM
76-1	P0845P076-1	SET SCREW M8-1.25 X 10
77	P0845P077	MAIN SHAFT
78	P0845P078	JACK SCREW M10-1.5 X 45
79	P0845P079	HEX NUT M10-1.5



Blade Guards & Hold-Down Clamp Parts

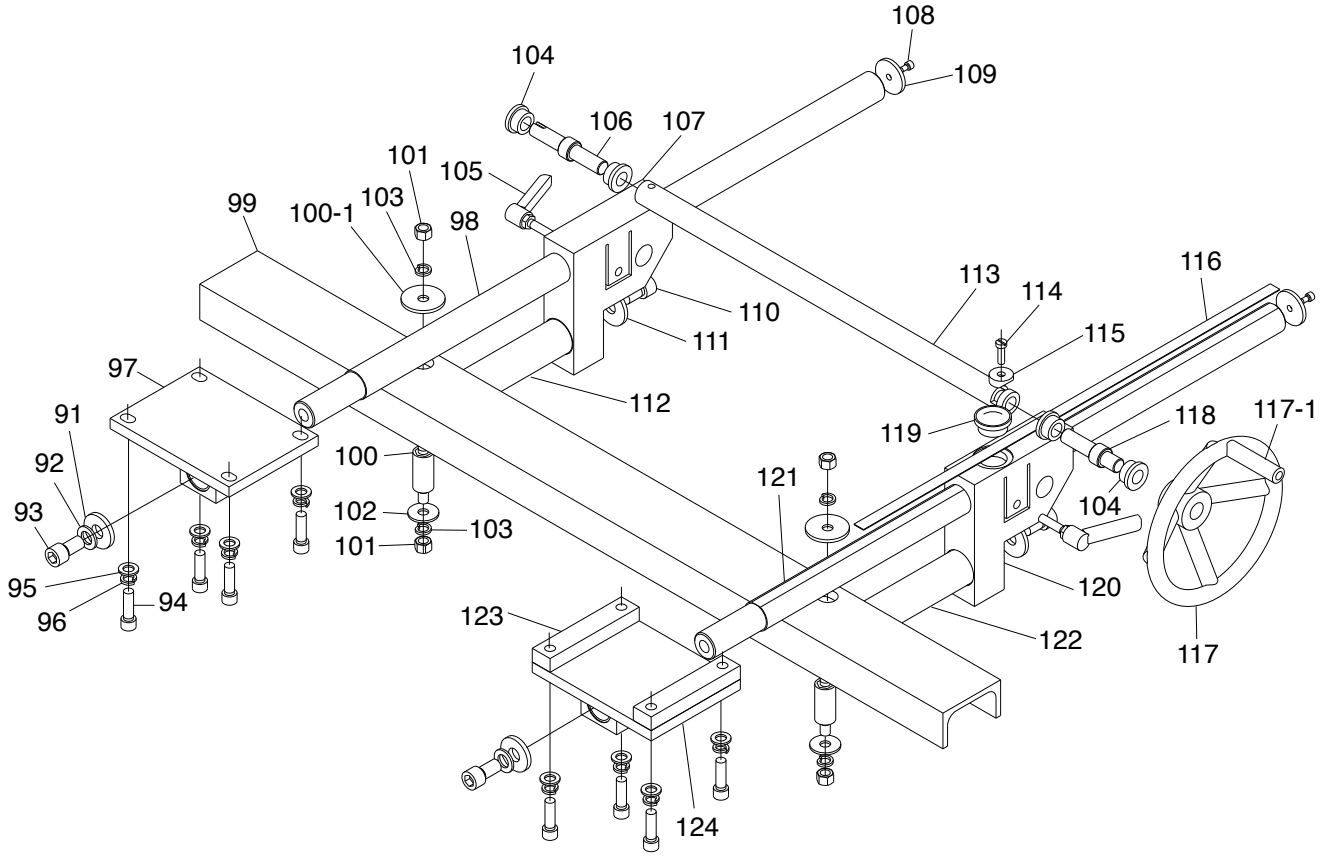


REF PART #	DESCRIPTION
80	P0845P080 FINGER GUARD
81	P0845P081 FRONT COVER
82	P0845P082 DISC SPRING STACK BAR
83	P0845P083 DISC SPRING STACK
84	P0845P084 CLAMP PRESSURE REGULATING NUT
85	P0845P085 TOP COVER

REF PART #	DESCRIPTION
86	P0845P086 HOLD DOWN PLATE
87	P0845P087 HEX NUT M16-2
88	P0845P088 KNURLED THUMB SCREW M12-1.75 X 56
89	P0845P089 CRASH PAD
90	P0845P090 CLAMP FOOT PAD



Rear Work Stop Parts

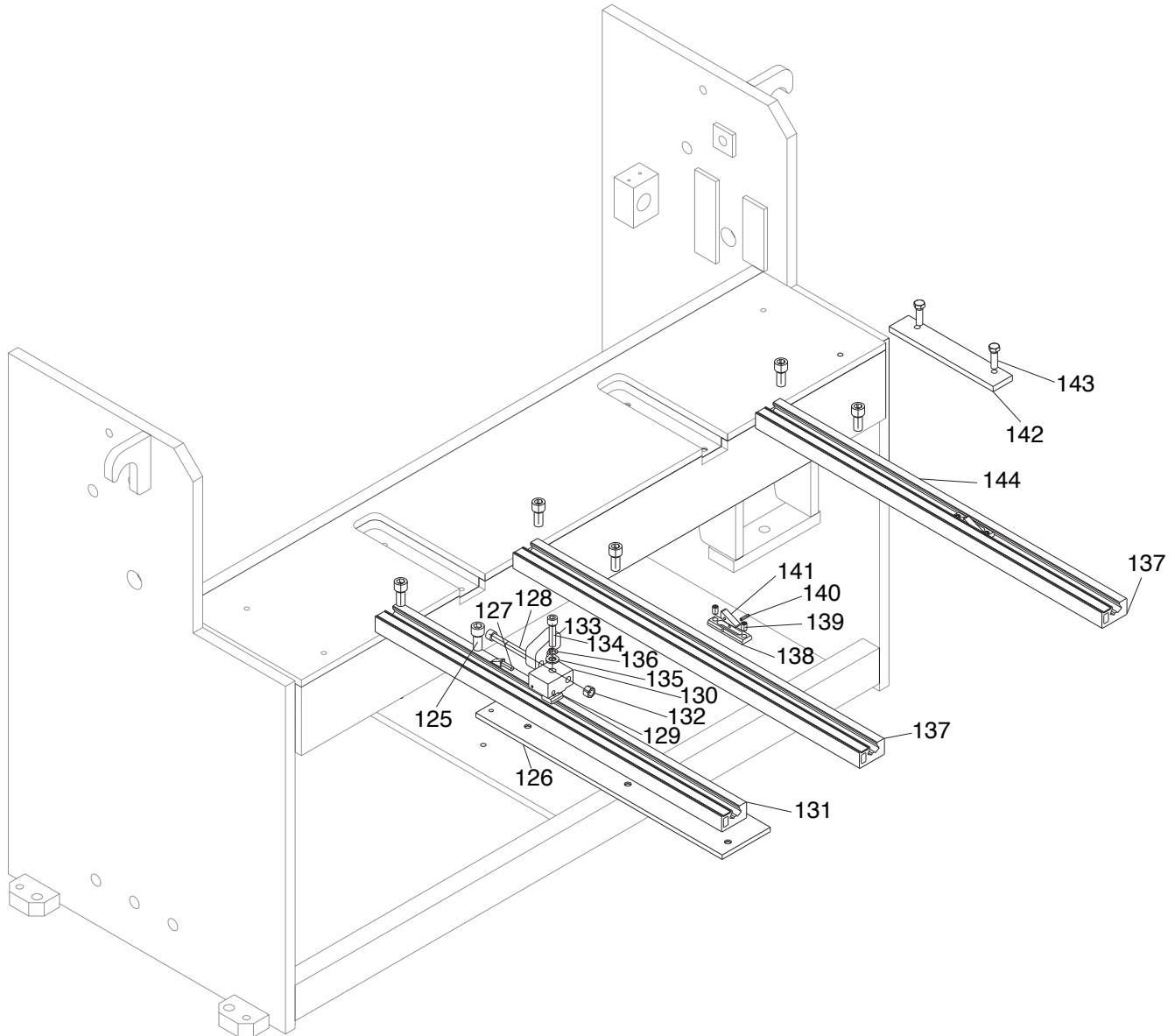


REF PART #	DESCRIPTION
91	P0845P091 DOCK WASHER 16 X 44 X 6MM
92	P0845P092 FLAT WASHER 16MM
93	P0845P093 CAP SCREW M16-2 X 30
94	P0845P094 CAP SCREW M12-1.75 X 40
95	P0845P095 FLAT WASHER 12MM
96	P0845P096 LOCK WASHER 12MM
97	P0845P097 MOUNTING PLATE (LEFT)
98	P0845P098 SUPPORT ROD (LEFT)
99	P0845P099 REAR WORK STOP
100	P0845P100 STANDOFF-RD MM, M12-1.75, 25 X 100
101	P0845P101 HEX NUT M12-1.75
102	P0845P102 FLAT WASHER 12MM
103	P0845P103 LOCK WASHER 12MM
104	P0845P104 COLLAR
105	P0845P105 ADJUSTABLE HANDLE M10-1.5 X 40, 94L
106	P0845P106 GEAR SHAFT (LEFT)
107	P0845P107 TRANSMISSION BLOCK (LEFT)
108	P0845P108 CAP SCREW M16-2 X 10

REF PART #	DESCRIPTION
109	P0845P109 FENDER WASHER 6MM
110	P0845P110 CAP SCREW M16-2 X 25
111	P0845P111 FENDER WASHER 16MM
112	P0845P112 CONNECTING ROD (LEFT)
113	P0845P113 SHAFT
114	P0845P114 SET SCREW M8-1.25 X 25
115	P0845P115 LOCK BLOCK
116	P0845P116 SCALE 0 – 25-1/2"
117	P0845P117 HANDWHEEL TYPE-16 195D X 22B-K X M10-1.5
117-1	P0845P117-1 HANDWHEEL HANDLE, M10-1.5 X 16, 25 X 84
118	P0845P118 GEARSHAFT (RIGHT)
119	P0845P119 MAGNIFYING LENS
120	P0845P120 TRANSMISSION BLOCK (RIGHT)
121	P0845P121 SUPPORT ROD (RIGHT)
122	P0845P122 CONNECTING ROD (RIGHT)
123	P0845P123 SUPPORT BLOCK
124	P0845P124 MOUNTING BLOCK (RIGHT)



Support Rods Parts

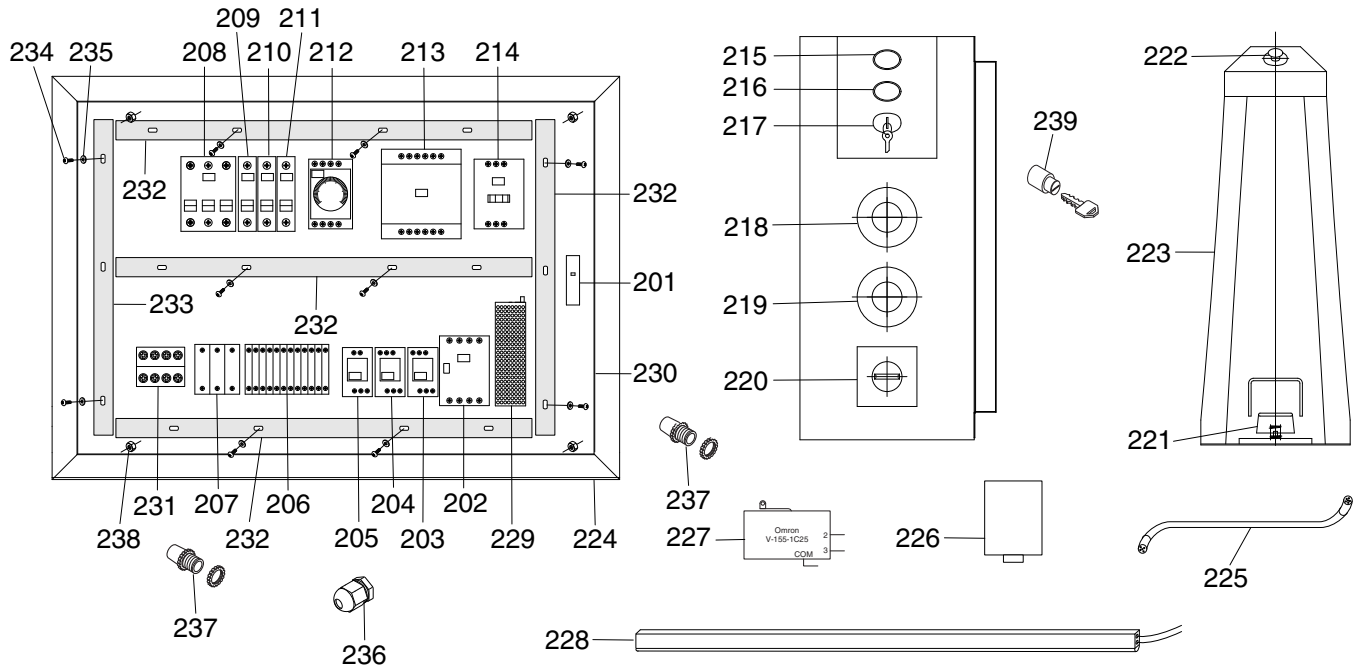


REF	PART #	DESCRIPTION
125	P0845P125	CAP SCREW M16-2 X 35
126	P0845P126	SUPPORT PLATE
127	P0845P127	INDICATOR
128	P0845P128	CAP SCREW M12-1.75 X 90
129	P0845P129	LOCK BLOCK
130	P0845P130	MOVING BLOCK
131	P0845P131	WORK STOP (LEFT)
132	P0845P132	HEX NUT M12-1.75
133	P0845P133	STOP BLOCK
134	P0845P134	CAP SCREW M12-1.75 X 50

REF	PART #	DESCRIPTION
135	P0845P135	FLAT WASHER 12MM
136	P0845P136	LOCK WASHER 12MM
137	P0845P137	FRONT SUPPORT
138	P0845P138	ADJUSTABLE BLOCK
139	P0845P139	SET SCREW M10-1.5 X 16
140	P0845P140	ROLL PIN 5 X 20
141	P0845P141	FLIP STOP
142	P0845P142	WORK STOP (RIGHT)
143	P0845P143	HEX BOLT M12-1.75 X 40
144	P0845P144	SCALE 4" - 38"



Electrical Parts

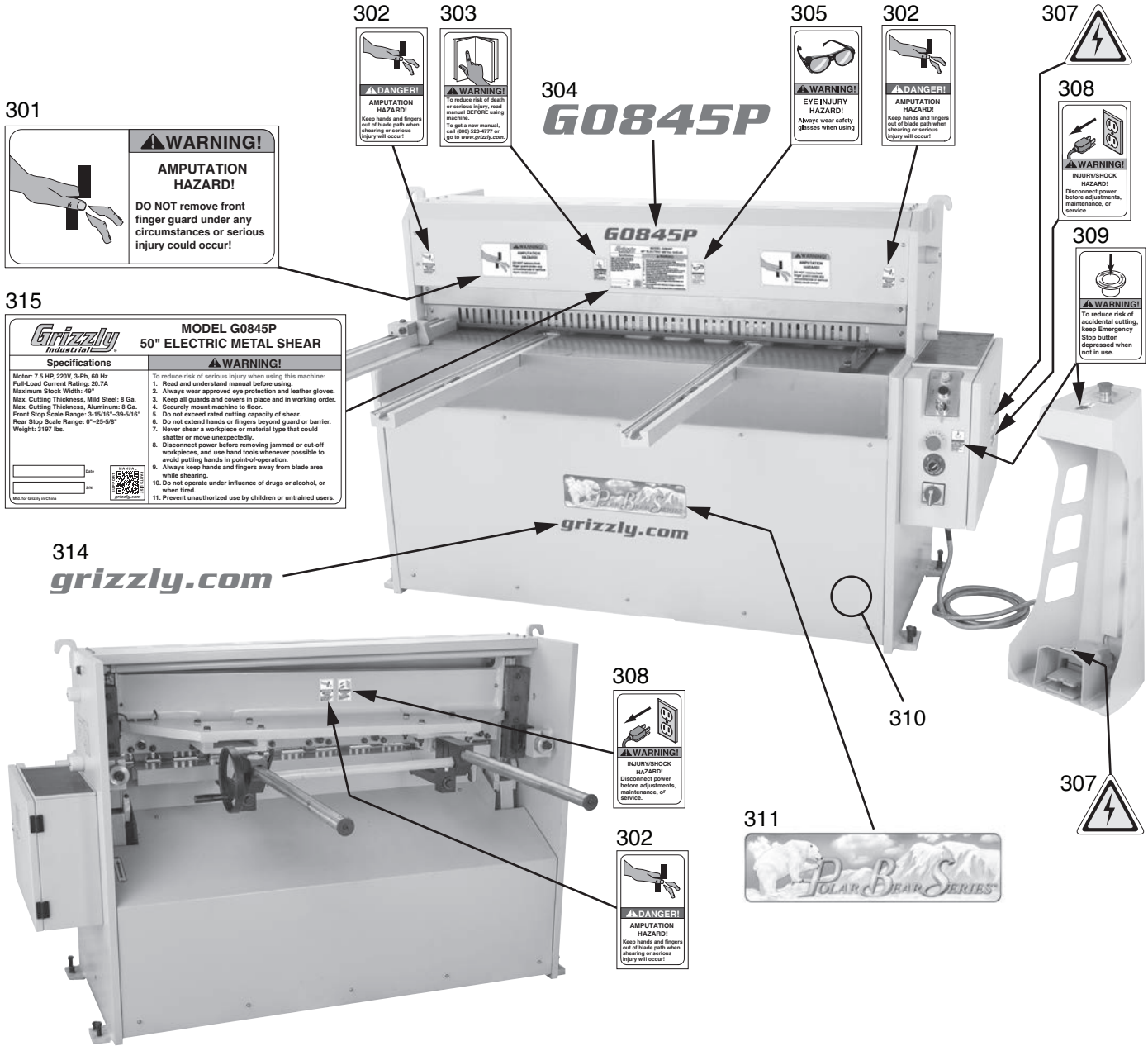


REF PART #	DESCRIPTION
201	P0845P201 BLADE LIGHT RELAY RV-1 270V 1A
202	P0845P202 RELAY SIEMENS 31E 3TH80
203	P0845P203 RELAY SCHNEIDER RXM4LB2B7 3A
204	P0845P204 RELAY SCHNEIDER RXM2LB2B7 5A
205	P0845P205 RELAY SCHNEIDER RXM2LB2B7 5A
206	P0845P206 TERMINAL BAR 11P
207	P0845P207 TERMINAL BAR 3P
208	P0845P208 BREAKER SCHNEIDER IC65N D-32A
209	P0845P209 BREAKER SCHNEIDER IC65N D-4A
210	P0845P210 BREAKER SCHNEIDER IC65N D-4A
211	P0845P211 BREAKER SCHNEIDER IC65N D-4A
212	P0845P212 TIME RELAY FBF ST3PC-B 5A
213	P0845P213 TRANSFORMER JBK5-300VA
214	P0845P214 CONTACTOR SCHNEIDER LC1E40
215	P0845P215 INDICATOR LIGHT SCHNEIDER XDJ2-24VAC
216	P0845P216 JOG BUTTON SCHNEIDER ZB2-BE101C
217	P0845P217 KEY SWITCH SCHNEIDER ZB2-BE102C
218	P0845P218 E-STOP SCHNEIDER ZB2-BE102C
219	P0845P219 LIGHT SWITCH SCHNEIDER ZB2-BE101C
220	P0845P220 POWER SWITCH SCHNEIDER JFD11-32A

REF PART #	DESCRIPTION
221	P0845P221 PEDAL SWITCH RCEN TFS-502
222	P0845P222 E-STOP SCHNEIDER ZB2-BE102C
223	P0845P223 FOOT PEDESTAL
224	P0845P224 ELECTRICAL BOX
225	P0845P225 PEDESTAL CORD SHIELDED 7-PIN 140"
226	P0845P226 LIMIT SWITCH TELEMACH XCK5131H29
227	P0845P227 LIMIT SWITCH OMRON V-155-1C25
228	P0845P228 BLADE LIGHT LED T5 12W 185-265VAC
229	P0845P229 POWER RELAY MEAN WELL NES-35-12
230	P0845P230 ELECTRICAL BOX MOUNTING PLATE
231	P0845P231 GROUNDING BLOCK 8P
232	P0845P232 WIRE LOOM 13"
233	P0845P233 WIRE LOOM 10"
234	P0845P234 PHLP HD SCR M4-.7 X 8
235	P0845P235 FENDER WASHER 5MM
236	P0845P236 STRAIN RELIEF TYPE-3 M24-1.5
237	P0845P237 STRAIN RELIEF TYPE-6 7/8"
238	P0845P238 HEX NUT M8-1.25
239	P0845P239 ELECTRICAL BOX LOCK WITH KEYS (2-PC)



Labels & Cosmetics



REF	PART #	DESCRIPTION
301	P0845P301	AMPUTATION WARNING
302	P0845P302	AMPUTATION DANGER
303	P0845P303	READ MANUAL WARNING
304	P0845P304	MODEL NUMBER LABEL
305	P0845P305	EYE INJURY HAZARD
307	P0845P307	ELECTRICAL LABEL

REF	PART #	DESCRIPTION
308	P0845P308	INJURY/SOCK HAZARD
309	P0845P309	EMERGENCY STOP BUTTON WARNING
310	P0845P310	TOUCH-UP PAINT, POLAR BEAR WHITE
311	P0845P311	POLAR BEAR SERIES LABEL
314	P0845P314	GRIZZLY.COM LABEL
315	P0845P315	MACHINE ID LABEL

⚠ WARNING

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

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 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: _____

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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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