

Grizzly *Industrial, Inc.*®

MODEL G0846 HORIZONTAL SLOT MORTISER OWNER'S MANUAL

(For models manufactured since 02/18)



COPYRIGHT © JUNE, 2018 BY GRIZZLY INDUSTRIAL, INC.
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**

#KBABJH19339 PRINTED IN CHINA

V1.06.18

 **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.

Table of Contents

INTRODUCTION	2	SECTION 5: ACCESSORIES	26
Machine Description	2	SECTION 6: MAINTENANCE	27
Contact Info.....	2	Schedule	27
Manual Accuracy	2	Cleaning & Protecting	27
Identification.....	3	Bit Care.....	27
Controls & Components.....	4	Lubrication	28
Machine Data Sheet	5	SECTION 7: SERVICE	30
SECTION 1: SAFETY	7	Troubleshooting	30
Safety Instructions for Machinery	7	Adjusting Fence & Miter Gauge Indicator....	32
Additional Safety for		Adjusting Table Gib	32
Horizontal Slot Mortisers.....	9	Adjusting Table Roller Bearings	33
SECTION 2: POWER SUPPLY	10	Squaring Chuck With Table	33
SECTION 3: SETUP	12	Adjusting Table Parallelism With Chuck.....	35
Unpacking	12	Adjusting Table Vertical Height.....	36
Needed for Setup.....	12	SECTION 8: WIRING	37
Inventory	13	Wiring Safety Instructions	37
Cleanup.....	14	Electrical Components	38
Site Considerations.....	15	Wiring Diagram	39
Lifting & Placing	16	SECTION 9: PARTS	40
Anchoring to Floor	16	Base, Column & Motor.....	40
Assembly	17	Table Knee.....	42
Dust Collection.....	18	Table	44
Test Run	19	Hold-Down Assembly.....	45
SECTION 4: OPERATIONS	20	Miter Gauge & Fence.....	45
Operation Overview	20	Labels & Cosmetics	46
Operating Tips	21	WARRANTY AND RETURNS	49
Changing Bits.....	21		
Adjusting Table	22		
Using & Adjusting Miter Gauge & Fence....	23		
Using Hold-Down Clamp Assembly.....	24		
Using Indexing Guide	24		
Boring Workpiece Freehand	25		

INTRODUCTION

Machine Description

The Model G0846 Horizontal Slot Mortiser comes with an 8" x 20" precision-ground, cast-iron table with a cam-locking clamp to secure the workpiece. The table glides along two hardened V-ways using four ball bearings for smooth, effortless motion. The bearing tracks are equipped with two left/right direction stops and one forward/backward stop, which are crucial for repeatable operations. There is also an indexing bar with four different spacing patterns for left/right table movement.

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

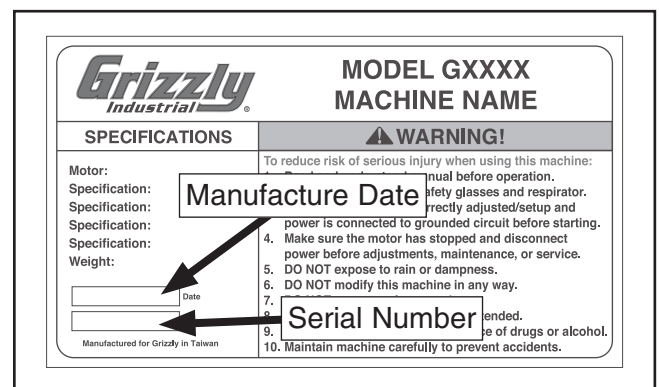
Manual Accuracy

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.**

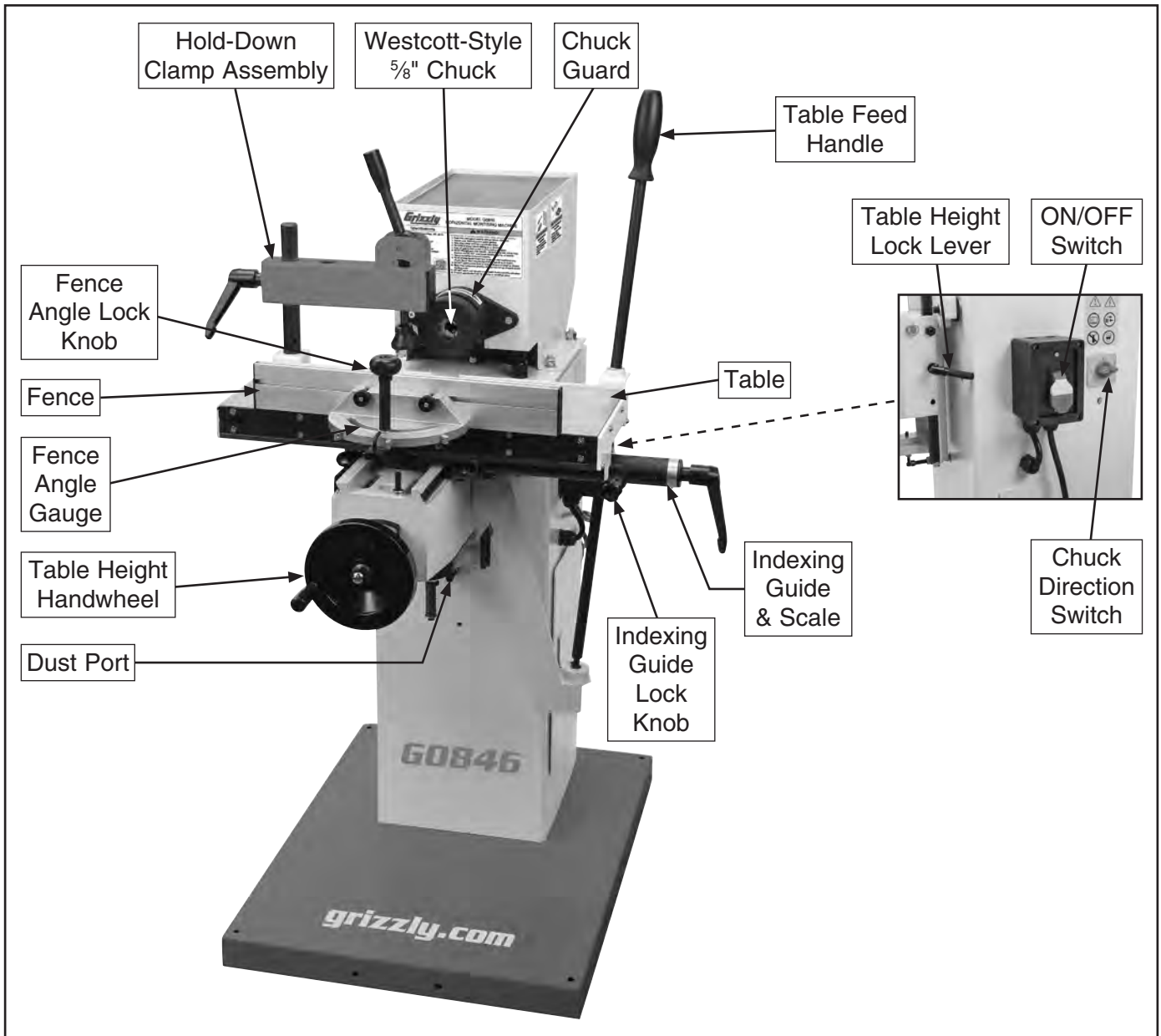
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at www.grizzly.com.

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.



Identification

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



Controls & Components



Refer to the following figure 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.

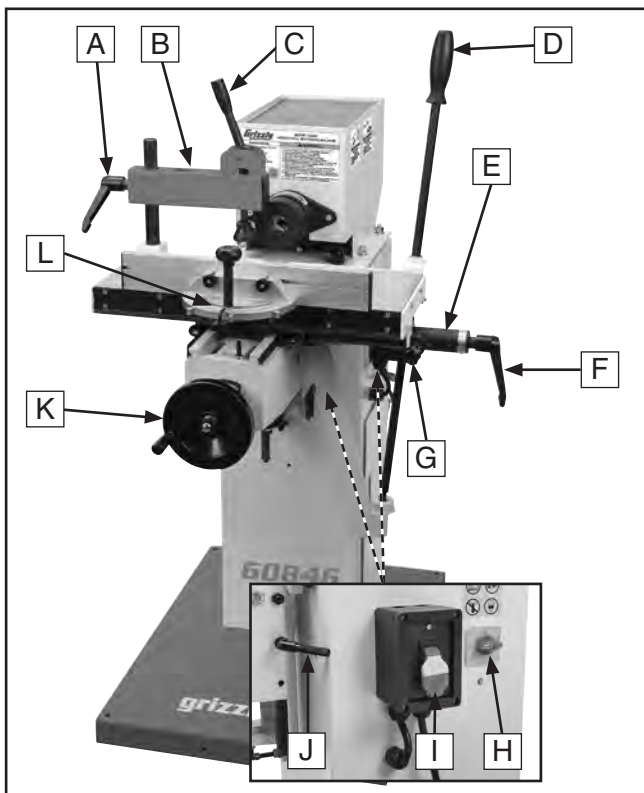


Figure 1. Basic control locations.

- A. **Hold-Down Clamp Lock Handle:** Allows user to adjust and lock height of hold-down clamp assembly on hold-down post.
- B. **Hold-Down Clamp Assembly:** Secures workpiece to table. Two mounting holes allow the clamp to accommodate different-sized workpieces.

- C. **Hold-Down Clamp Lock Lever:** Holds and releases pressure against workpiece.
- D. **Table Feed Handle:** Moves the table in and out and side to side during boring operations.
- E. **Indexing Guide:** Has four pre-spaced indexing sizes ($\frac{5}{8}$ ", $\frac{3}{4}$ ", $\frac{7}{8}$ ", and 1" on-center) for repeat line-boring operations up to $7\frac{1}{2}$ " wide when used with indexing guide lock pin (G).
- F. **Indexing Guide Lock Handle:** Locks indexing guide (E) in position.
- G. **Indexing Guide Lock Pin:** Features a spring-loaded head to drop into holes on the indexing guide collar (E) to control side-to-side table travel. Pull the pin out and rotate the knob 90° for free table movement side to side and front to back.

- H. **Chuck Direction Switch:** Features an L (left), N (neutral), and R (right/clockwise) rotation setting depending upon operation and bit type.

IMPORTANT: Always turn switch to 0 (neutral) and allow chuck to stop spinning before changing chuck direction. Bit rotates counterclockwise on L (left) and clockwise on R (right) as user faces chuck.

- I. **ON/OFF Switch:** Starts and stops motor. Remove switch disabling key to prevent motor from starting when machine is unattended.
- J. **Table Height Lock Lever:** Secures table at selected elevation.
- K. **Table Height Handwheel:** Moves the table up and down.
- L. **Fence Angle Gauge:** Allows fence adjustment of up to 60° left/right, and adjusts inward/outward depending upon workpiece size. The fence and angle gauge are removable for oversized workpieces.





MACHINE DATA SHEET

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

MODEL G0846 HORIZONTAL SLOT MORTISER

Product Dimensions:

Weight..... 236 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 32 x 36 x 48-1/2 in.
 Footprint (Length x Width)..... 27-1/2 x 20-1/2 in.

Shipping Dimensions:

Type..... Wood Crate
 Content..... Machine
 Weight..... 315 lbs
 Length x Width x Height..... 37 x 31 x 46 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 220V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 10A
 Minimum Circuit Size..... 15A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 14 AWG
 Plug Included..... Yes
 Included Plug Type..... NEMA 6-15
 Switch Type..... ON/OFF Paddle Safety Switch

Motors:

Main

Horsepower..... 2 HP
 Phase..... Single-Phase
 Amps..... 10A
 Speed..... 3400 RPM
 Type..... TEFC Capacitor-Run Induction
 Power Transfer Direct Drive
 Bearings..... Sealed & Permanently Lubricated

Main Specifications:

Operation

Table Cross Travel..... 6 in.
 Table Longitudinal Travel..... 12-1/2 in.
 Table Vertical Travel..... 5-1/2 in.

Cutting Capacities

Maximum Stock Thickness..... 10-3/4 in.

Table Information

Table Size Length..... 20 in.
 Table Size Width..... 8-1/4 in.
 Table Size Thickness..... 1-1/2 in.
 Floor to Table Height..... 30 – 35-3/8 in.



Chuck Information

Chuck Size..... 5/8 in.
Chuck Capacity..... 5/8 in.

Construction

Head..... Steel
Table..... Precision-Ground Cast Iron
Paint Type/Finish..... Powder Coated
Cabinet..... Steel
Fence..... Extruded Aluminum

Other

Handle Length..... 32 in.
Dust Port Size..... 4 in.
Mobile Base..... D2057A

Other Specifications:

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

Features:

- Locking Storage Cabinet
- Forward and Reverse Spindle Control
- Combo Fence/Miter Gauge
- Adjustable X- and Y-Axis Table Stops
- Smooth Ball-Bearing Table Operation
- Cam Action Hold-Down Clamp

Accessories Included:

- Hex Wrench Set



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 Horizontal Slot Mortisers

WARNING

Serious injury or death can occur from getting entangled in, crushed between, or struck by rotating bits on a horizontal slot mortising machine! Unsecured tools or workpieces that fly loose from rotating objects can strike operators and bystanders with deadly force. To minimize the risk of getting hurt or killed, anyone operating this machine **MUST** completely heed the hazards and warnings below.

EYE/FACE/LUNG/HAND PROTECTION. Debris from cutting operations can be thrown at operator. Always wear safety glasses or a face shield to protect your eyes and face during cutting operations. Always wear a respirator to protect your lungs from dust created during cutting operations. The spinning bit is sharp and can cause serious injury. Always keep hands and fingers away from moving bit and chuck. To reduce risk of entanglement, **DO NOT** wear gloves when operating this machine.

GUARD. Chuck guard reduces risk of entanglement and debris being thrown at operator. **DO NOT** operate this machine with guard removed.

CUTTING OPERATION. Cutting bits rotate with high torque, especially at startup. To avoid a bit grabbing workpiece and unexpectedly moving it, **DO NOT** start the machine with a bit touching the workpiece. **DO NOT** perform "climb milling"—only move workpiece against rotation of cutting bit.

CUTTING BITS. A rapidly spinning cutting bit can be thrown at operator and bystanders if it comes loose from chuck. Only use bits with a shank diameter of $\frac{5}{8}$ " for safest operation. Properly secure bit in chuck before beginning operations. **DO NOT** use chisel bits of any kind.

DULL OR WORN BITS. Dull or damaged bits may break apart during operation, be thrown at operator or bystanders, or reduce performance. Thoroughly inspect bit before each use. **DO NOT** operate machine with a dull or damaged bit.

SECURING WORKPIECE. To keep workpiece from moving during cutting operations, make sure it is placed in a stable position on work table and is secured by hold-down clamp or additional support fixtures.

SURFACE/WORKPIECE PREPARATION. Never turn machine **ON** before clearing work table of all tools, scrap wood, etc. Only drill wood products that are free of imperfections or foreign objects.

USE CORRECT MATERIALS. **DO NOT** use machine for anything except cutting/mortising in wood. **DO NOT** use this machine to drill metal, plastics, glass, or other non-wood material, which can damage machine and result in personal injury. **DO NOT** use chisel bits with this machine.

ADJUSTMENTS. **DO NOT** adjust machine or workpiece while machine is running. Wait for chuck to come to a complete stop and unplug machine before continuing.

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.

WARNING

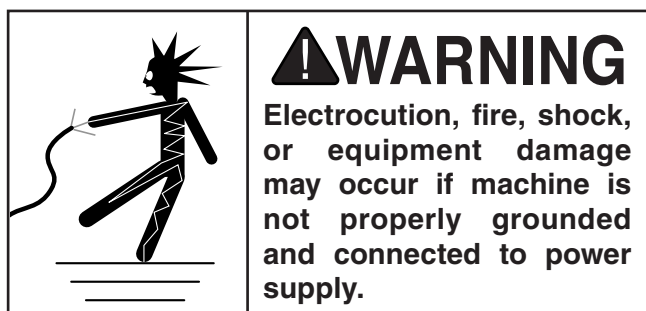
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: 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.

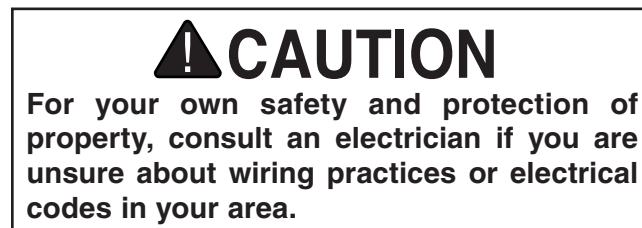
Full-Load Current Rating at 220V 10 Amps

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

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

Circuit 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

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

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



Grounding Requirements

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

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

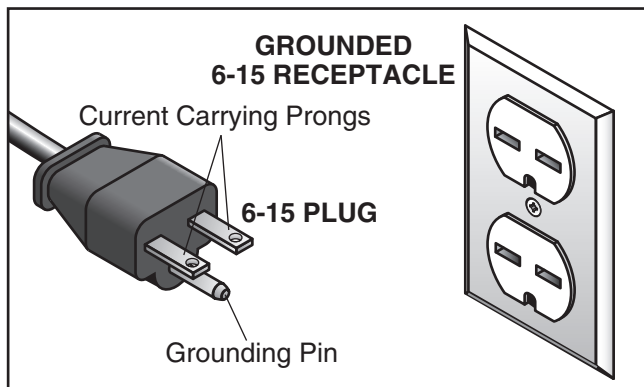
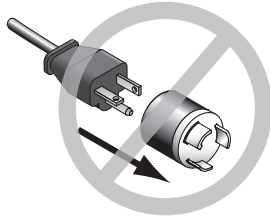


Figure 2. Typical 6-15 plug and receptacle.

CAUTION



No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.

WARNING

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

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

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

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

Minimum Gauge Size 14 AWG
Maximum Length (Shorter is Better).....50 ft.



SECTION 3: SETUP

Unpacking

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

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

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

Needed for Setup

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

Description	Qty
• Additional Person	1
• Safety Glasses (Per Person)	1 Pair
• Cleaner/Degreaser (Page 14)	As Needed
• Disposable Shop Rags.....	As Needed
• Phillips Screwdriver #2	1
• Standard Screwdriver #2.....	1
• Open-End Wrenches 18, 15, 10mm.....	1 Ea.
• Hex Wrench 2.5mm.....	1
• 4 x 4 Wood Block	1
• Dust-Collection System	1
• 4" Dust Hose	Length As Needed
• 4" Hose Clamps	2

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.



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.

Box 1 (Figure 3)	Qty
A. Hold-Down Clamp Assembly	1
B. Adjustable Feet w/Hex Nuts	4
C. Hold-Down Bar	1
D. Shoulder Screws	2
E. Handle Springs.....	2
F. Lock Handles.....	2
G. Handle Standoff Hex Nuts.....	2
H. Lock Washer 12mm.....	1
I. Flat Washer 12mm	1
J. Hex Nut M12-1.75	1
K. Fender Washer 8mm.....	1
L. Indexing Guide Collar.....	1
M. Hex Wrenches 4, 5, 6, 8mm.....	1 Ea.

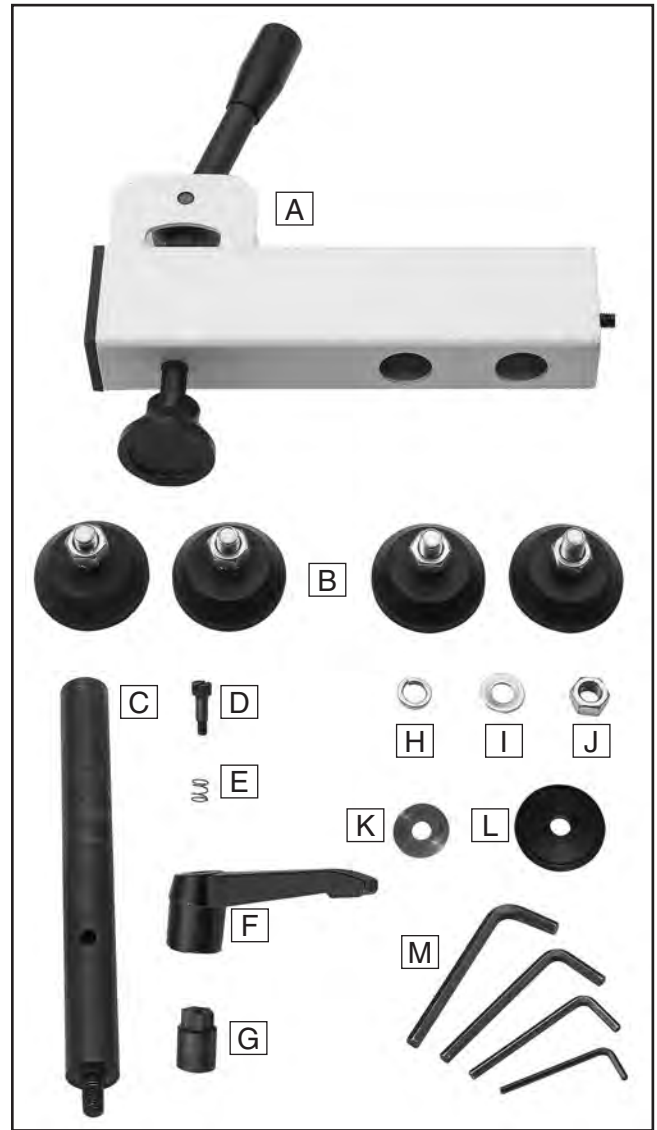


Figure 3. Inventory items.



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.

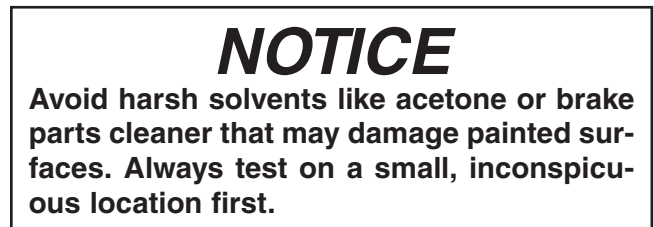
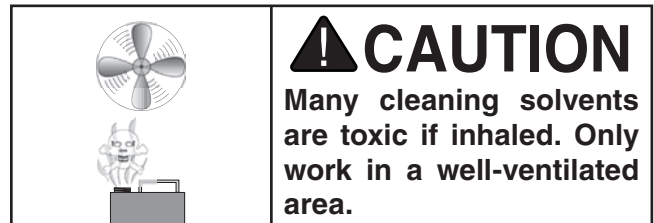
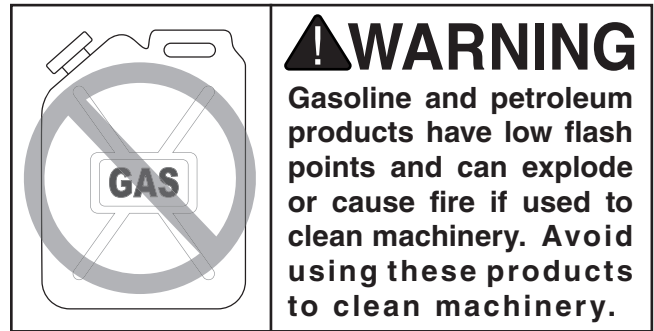
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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 4. T23692 Orange Power Degreaser.



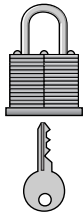
Site Considerations

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.**

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

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.

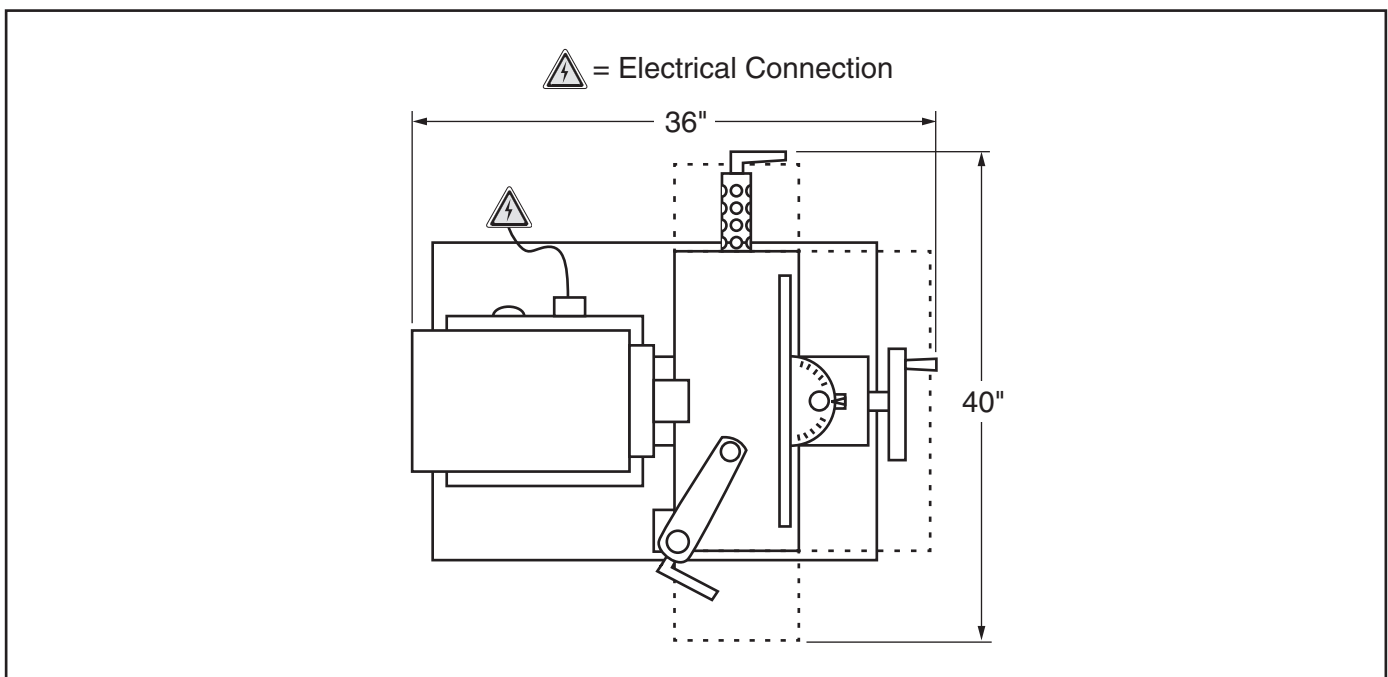
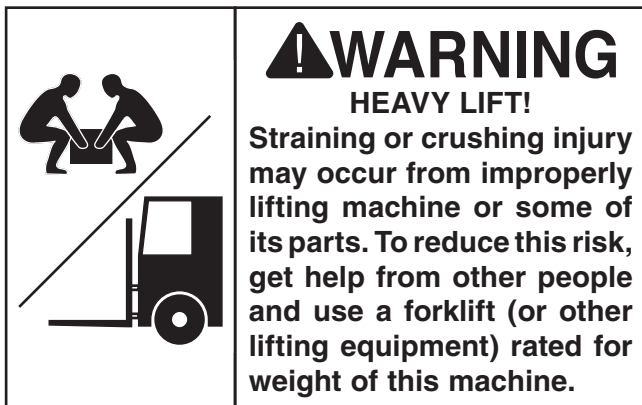


Figure 5. Minimum working clearances.



Lifting & Placing



Use a forklift and lifting strap rated for at least 500 lbs. to lift the machine.

To lift and place machine:

1. Thread lifting strap between elevation leadscrew and vertical elevation ways, as shown in **Figure 6**.

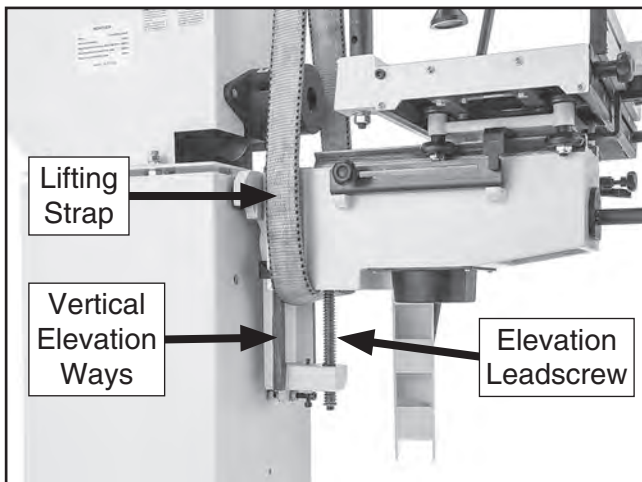


Figure 6. Lifting strap placement.

2. Attach lifting strap to forklift forks, then center and lock all table adjustments.
3. Remove fasteners securing machine to shipping pallet.
4. Lift machine enough to remove pallet and place in position.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 3/8"

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

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

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

Anchoring to Concrete Floors

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

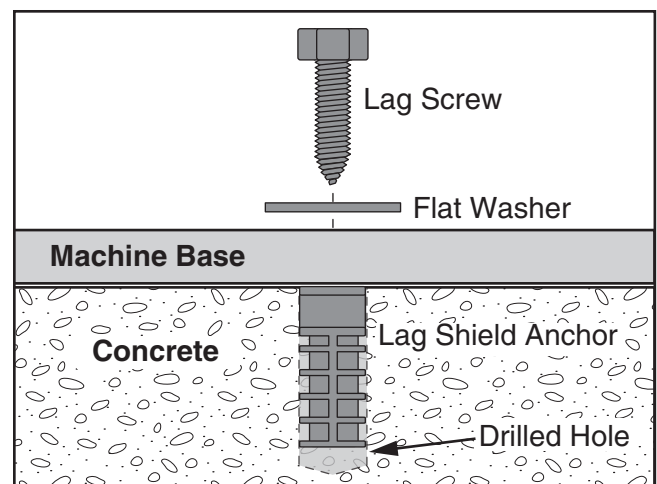


Figure 7. Popular method for anchoring machinery to a concrete floor.



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).

To assemble machine:

1. Loosely attach (1) lock handle to hold-down clamp assembly (see **Figure 8**).

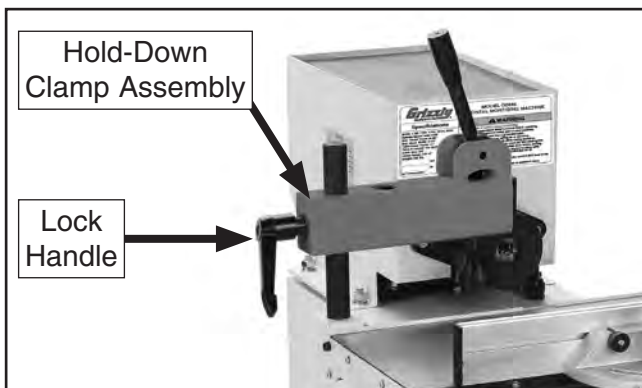


Figure 8. Lock handle attached to hold-down clamp assembly.

2. Attach hold-down post to table with 12mm flat washer, 12mm lock washer, and M12-1.75 hex nut (see **Figure 9**).

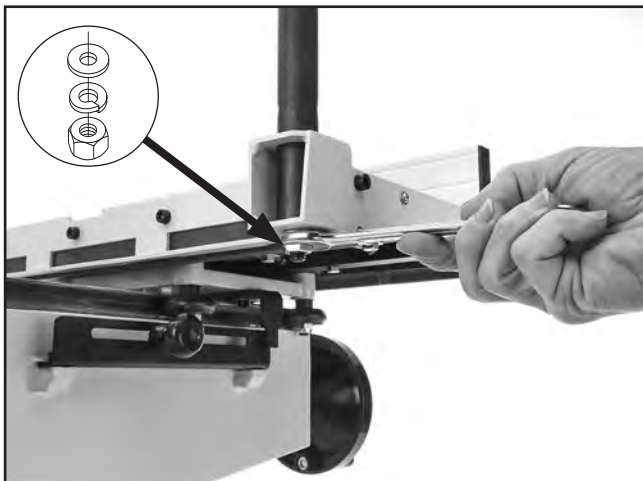


Figure 9. Mounting hold-down post to table.

3. Slide hold-down clamp assembly over hold-down post using either mounting hole for now (see **Figure 10**). Tighten lock handle.

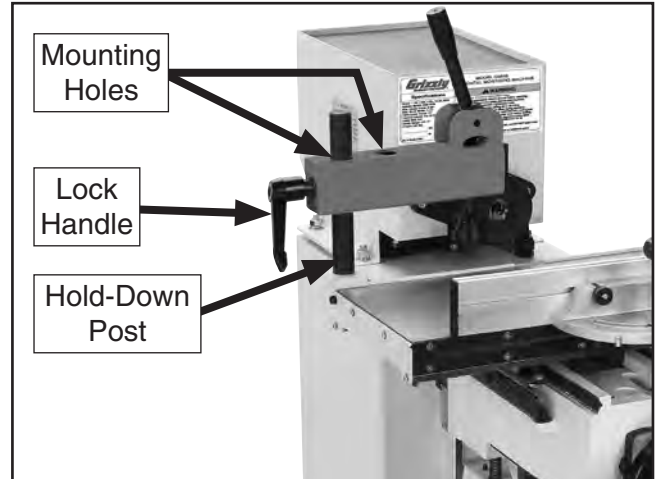


Figure 10. Placement of hold-down clamp assembly.

4. Place collar inside end of indexing guide with flat side facing out, then secure to stud with 8mm fender washer, standoff hex nut, lock handle, compression spring, and shoulder screw (see **Figure 11**).

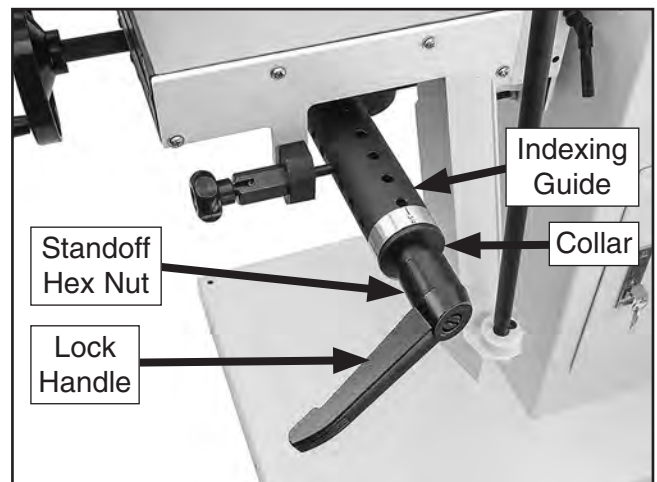


Figure 11. Installing components on indexing guide shaft.



- Attach handle to table height handwheel (see **Figure 12**) and tighten.



- To install adjustable feet, have an assistant tilt machine and place it on 4 x 4 wood block for safety, as shown in **Figure 12**.
- Attach (2) feet in mounting holes under main cabinet and secure each foot with hex nut (see **Figure 12**). Repeat for opposite side.

Note: For permanent floor mounting, refer to **Anchoring to Floor** on **Page 16**.

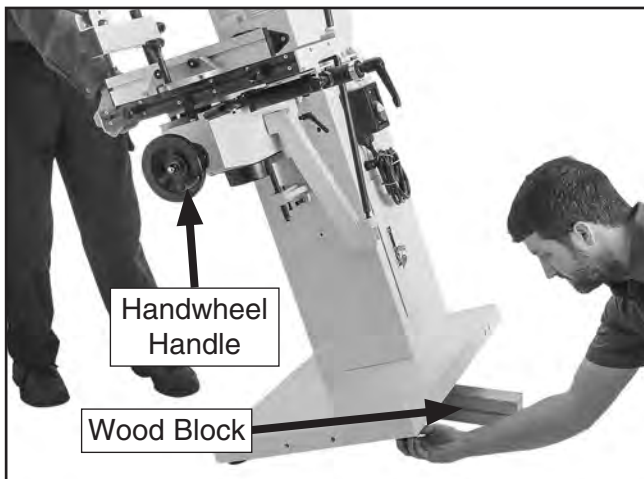


Figure 12. Installing adjustable feet to base.

Dust Collection

CAUTION

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

Minimum CFM at Dust Port: 400 CFM

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

To connect dust collection system to machine:

- Attach 4" dust hose to dust port under work table where shown in **Figure 13**, and secure in place with a hose clamp.

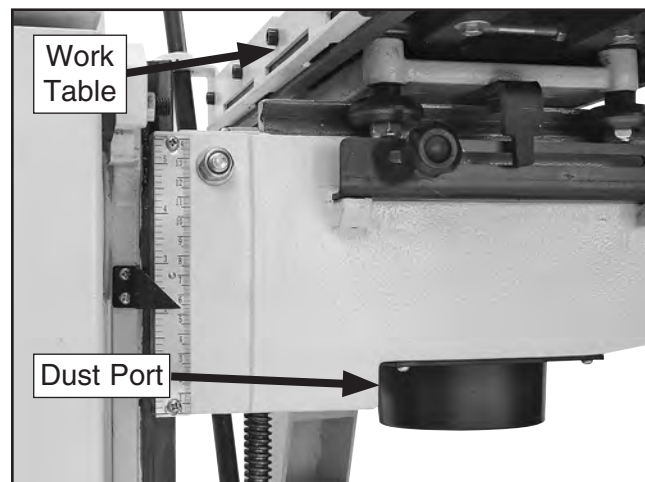


Figure 13. Dust port location.

- Tug hose to make sure it does not come off.

Note: A tight fit is necessary for proper performance.



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 verifying the following:

- 1) The motor powers up and runs correctly, and
- 2) the safety disabling mechanism on the switch works correctly.

To test run machine:

1. Clear all setup tools away from machine and make sure chuck key is removed.
2. Connect machine to power supply.
3. Turn spindle direction switch to "R" (right) position.

4. Turn machine **ON**, verify motor operation and chuck rotation direction, then turn machine **OFF**.

When spindle direction switch is turned to "R," the chuck should rotate clockwise as you face it. The motor should run smoothly and without problems, vibration, or noises.

5. Turn spindle direction switch to "L" (left) position, then turn machine **ON**. Verify motor operation and chuck rotation direction, then turn machine **OFF**.

When switch is turned to "L," the chuck should rotate counterclockwise as you face it.

6. Remove switch disabling key, as shown in **Figure 14**. Try to start machine with paddle switch. The machine should not start.

—If the machine *does not* start, the switch disabling feature is working correctly.

—If the machine *does* start, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work correctly before proceeding with regular operations. Call Tech Support for help.

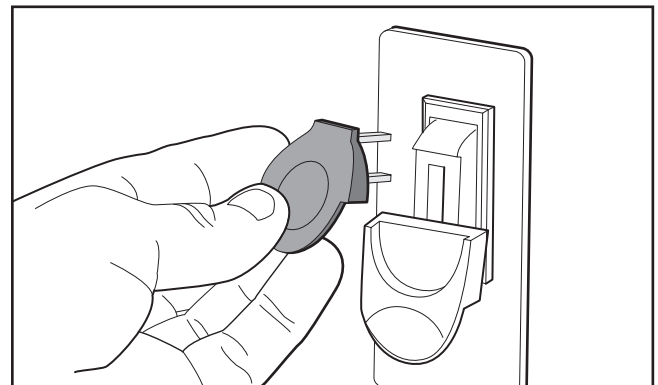


Figure 14. Removing switch disabling key from paddle switch.

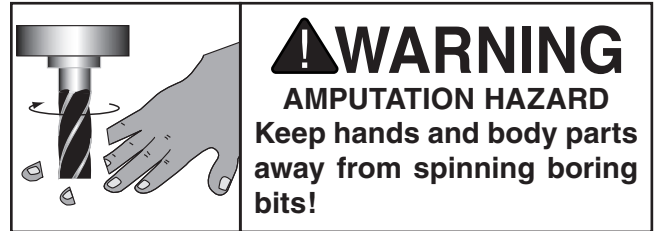
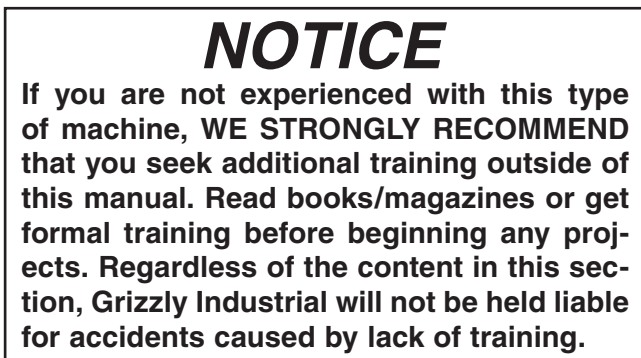
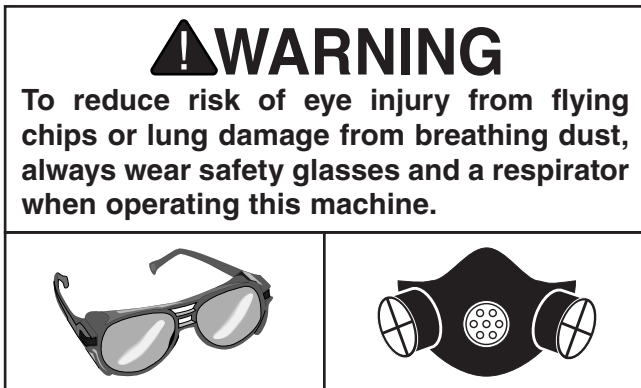


SECTION 4: OPERATIONS

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. Installs appropriate boring bit, mill end, or router bit for operation, then removes hex wrench.

IMPORTANT: *DO NOT* use mortising chisels.

2. Measures and marks cutting area on workpiece, adjusts table travel stops, and selects on-center index on indexing collar.
3. Places workpiece flat on work table and fence and ensures fence is set properly.
4. Uses work table feed handle and handwheel to align workpiece measurements with bit.
5. Secures workpiece to work table with hold-down clamp assembly.
6. Puts on safety glasses or face shield and respirator.
7. Inspects bit spiral, selects appropriate chuck rotation direction, and turns machine **ON**.

IMPORTANT: *Ensure bit rotates so it pulls out chips during operation.*

CAUTION: *Avoid plunging or mortising deeper than the spiral of the bid is designed. Avoid mortising holes deeper than 4 times the diameter of the bit. Whip can occur.*

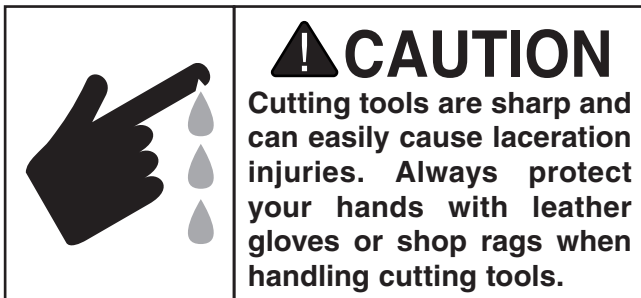
8. If using an end mill or performing a side-cutting operation, uses conventional milling method and moves workpiece against rotation of the bit. **DO NOT** use climb-milling method.



- 9. Uses work table feed handle to slowly move workpiece into bit, bores hole, then moves workpiece away from bit.
- 10. Limits depth of each cutting pass to 1/16" or less.
- 11. Turns machine **OFF** when operations are complete.
- 12. Unclamps and removes workpiece only after chuck has come to a complete stop.

- When mortising through hard spots in wood, use shorter bits with 4-flute design so small bites can be made and bit is less likely to grab hard spots as 2-flute bits can do.
- Avoid deep cuts with bits where spirals become buried or partially buried in workpiece and cannot expel shavings. When mortising, limit cutting depth to 1/16" per pass.
- Never rush a drilling or mortising procedure. Extra care during setup will ensure satisfactory results.

Operating Tips



Here are a few things you can do to ensure easy operation and better workpiece results:

- Use the correct bit for the job. Adjust the chuck rotation so the bit pulls out chips during the boring operation.
- When using bits of different profiles and design, take time to understand what makes them different and how your process or technique may have to change.
- Use bits with a 5/8" shank for safe, consistent results during operation. Bits with smaller-diameter shanks have an increased risk of breaking or coming loose during boring operations, which may result in injury.
- To use bits with a 3/4" shank, use the T28358 Westcott-style chuck (refer to **Accessories** on **Page 26**).
- For longer or deeper mortises, 4-flute bits are recommended for smaller chip size and faster chip removal.

Changing Bits

The Westcott-style 5/8" chuck included with the Model G0846 is designed to work best with 5/8" shank slot mortising bits (see **Figure 15**). DO NOT install or use vertical mortiser chisel bits.



Figure 15. A selection of Grizzly 5/8" fluted bits suitable for use with the Model G0846.

Always ensure the bit is firmly secured in place before any boring or mortising operation. When changing bits, follow the instructions below.

Items Needed	Qty
Hex Wrench 6mm.....	1
Leather Gloves	1 Pair

To change bit:

1. DISCONNECT MACHINE FROM POWER!
2. Put on leather gloves to reduce the chance of laceration injuries from sharp flute edges when handling bits.



- If necessary, rotate bit by hand to gain access to chuck collar hex screw.
- Rotate hex wrench counterclockwise to open chuck jaws and remove bit (see **Figure 16**).



Figure 16. Removing bit from chuck.

- Install bit into chuck and rotate hex wrench clockwise to firmly tighten chuck (see **Figure 17**). *DO NOT* allow chuck to grab drill bit flutes.

IMPORTANT: *When installing a bit, ensure it is centered in the chuck jaw before tightening the chuck.*



Figure 17. Tightening bit in chuck.

- When bit is secure, remove hex wrench and re-connect machine to power.

Adjusting Table

The Model G0846 has a handwheel to move the table up and down up to 5½". A scale on the left rear side of the table measures vertical table movement (see **Figure 19**). A lock lever on the right side of the knee secures table elevation height.

Adjustable stop knobs limit table travel. Two stop knobs on the front of the table control up to 12½" of side-to-side travel. One stop knob under the left side of the table controls 6" of table travel depth.

When calculating table height and boring measurements for the operation, always test settings on a scrap workpiece, and use it to mark layout lines for setting the three stop knobs.

Items Needed	Qty
Tape Measure or Ruler.....	1
Scrap Workpiece.....	As Needed

Adjusting Table Height and Depth Stop

- Install bit (see **Changing Bits** on **Page 21**).
- Loosen table lock lever, then rotate handwheel to adjust table height (see **Figure 18**). Refer to scale as needed (see **Figure 19**).

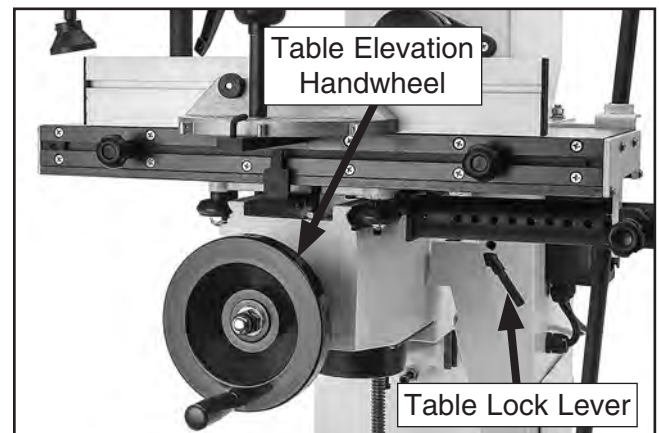


Figure 18. Table elevation adjustments.

- Loosen depth-stop knob and push table toward chuck until bit extends beyond table lip (see **Figure 19**) for drilling operation. Place a tape measure or ruler against fence face to measure bit depth.



4. Move depth-stop knob against side-stop pin to match position measured in **Step 3** (see **Figure 19**). Tighten knob.

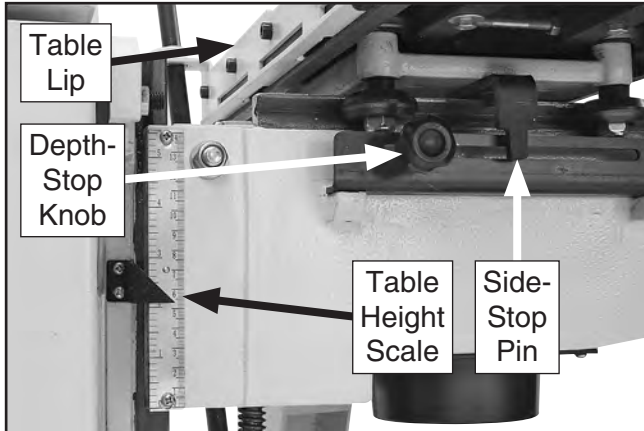


Figure 19. Table height and depth stop adjustments.

5. Move table in and out to confirm depth setting. If necessary, repeat **Steps 2–3**.
6. Tighten table lock lever.

Adjusting Table Side-To-Side Stops

1. After adjusting table depth stop, loosen and move left and right stop knobs away from front stop pin (see **Figure 20**).

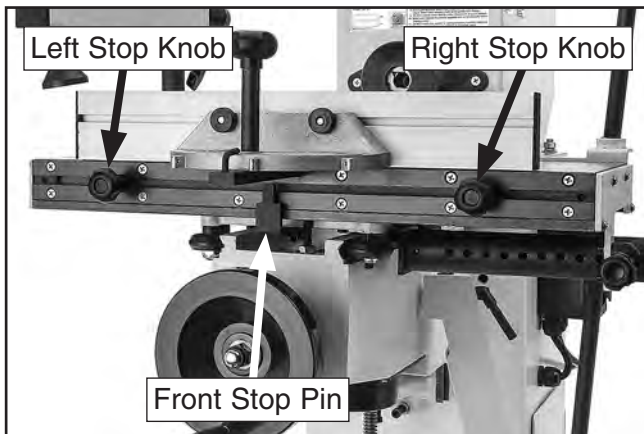


Figure 20. Left-to-right table stop adjustments.

2. Align layout lines on scrap workpiece with drill bit, then move corresponding stop knobs against front stop pin to set side-to-side travel.
3. Tighten stop knobs and move table side to side to confirm measurement.
4. Perform boring operation on scrap workpiece to confirm measurements.

Using & Adjusting Miter Gauge & Fence

The Model G0846 features an adjustable fence with miter gauge that pivots up to 60° left or right for angled boring operations (see **Figure 21**).

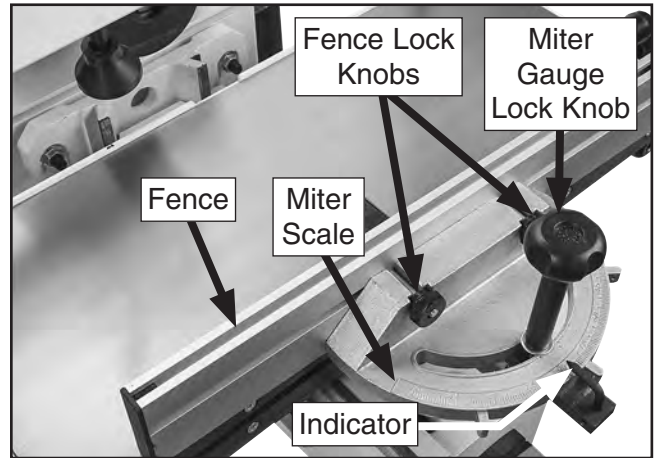


Figure 21. Fence and miter gauge components.

Always ensure the workpiece sits firmly against the fence. Use a backer board for additional support if needed (see **Using Hold-Down Clamp Assembly** on **Page 24**).

The fence, miter gauge, and indicator can be removed for larger workpieces.

Items Needed	Qty
Hex Wrench 2.5mm.....	1
Precision Square	1

Adjusting Miter Gauge

1. Loosen lock knob (see **Figure 21**), adjust fence to desired angle shown on miter scale, then tighten lock knob to secure setting.
2. Refer to **Adjusting Miter Gauge Indicator** on **Page 32** to calibrate miter scale accurately.

Adjusting Fence Position

1. Loosen fence lock knobs (see **Figure 21**) and shift fence as needed to support workpiece.
2. When complete, tighten fence lock knobs.



Removing Fence, Miter Gauge, and Indicator

1. Remove lock knob and flat washer, then lift fence and miter gauge as assembly off table (see **Figure 21** on **Page 23**).
2. Loosen set screw in miter gauge bar to remove indicator.

Using Hold-Down Clamp Assembly

The Model G0846 table features an adjustable hold-down clamp assembly to secure your workpiece to the table during boring operations. Always clamp your workpiece to the table. Place the hold-down clamp assembly in the hold-down post mounting hole (see **Figure 22**) that best supports the workpiece.

To operate hold-down clamp:

1. With clamp lock handle in unlocked position (as shown in **Figure 22**), loosen lock handle and center hold-down clamp arm and hold-down pad over workpiece.

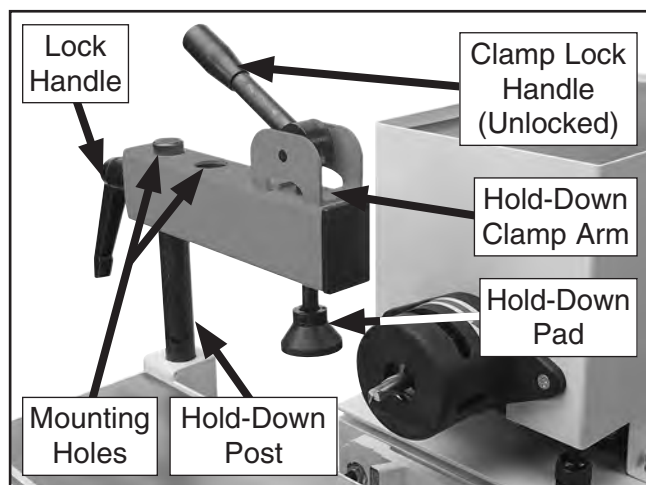


Figure 22. Hold-down clamp assembly components.

2. Lower hold-down arm until hold-down pad lightly touches work surface, then tighten lock handle.
3. Lift clamp lock handle and pull it forward to securely clamp workpiece to table.

4. Ensure your workpiece is held securely to table so it does not move during drilling operation. If necessary, lower hold-down clamp arm to increase clamping pressure.
5. To ensure a small workpiece is clamped securely, insert backer board between fence and workpiece to extend fence reach (see **Figure 23**).

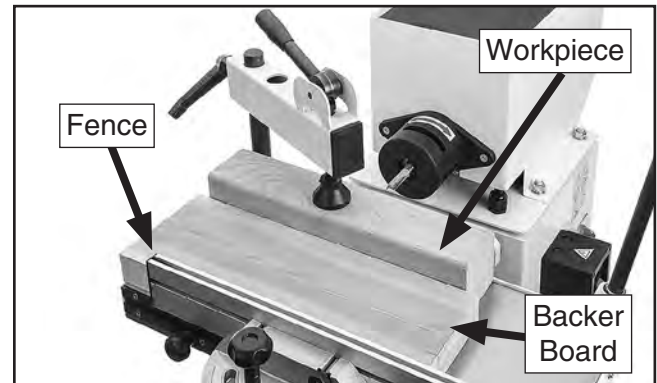


Figure 23. Small workpiece supported with backer board.

Using Indexing Guide

The work table features an adjustable indexing guide for repeatable boring operations in increments of $\frac{5}{8}$ ", $\frac{3}{4}$ ", $\frac{7}{8}$ ", and 1". This is typically used for line-boring operations or drilling holes for dowel joinery.

To use and adjust indexing guide:

1. Pull lock pin out and rotate it clockwise 90° to disengage indexing guide (see **Figure 24**).

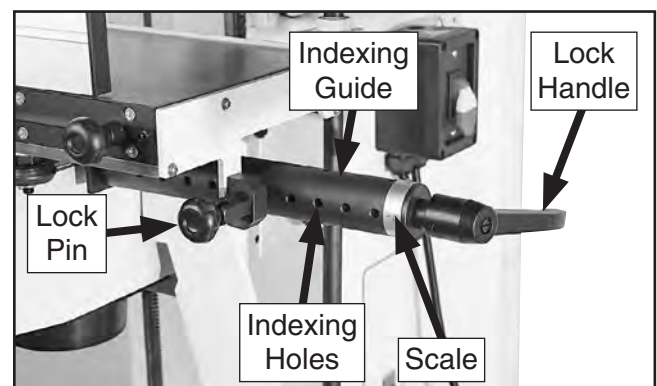


Figure 24. Indexing guide components.



- Loosen lock handle, rotate indexing guide to desired bore spacing shown on scale, then tighten lock handle to secure setting (see **Figure 24**).

Note: *Indexing guide clicks into position on each row of indexing holes.*

- Attach workpiece to table, then adjust table stops for boring operation (refer to **Adjusting Table** on **Page 22**).
- Rotate lock pin clockwise and move table to seat pin in desired indexing hole (see **Figure 24**) to lock table in position for drilling operation.
- Move table and workpiece away from bit, then turn machine **ON**.
- Use feed handle to slowly move table and workpiece into bit to drill first hole, then move table and workpiece away from bit.
- Pull lock pin out, then move table sideways until lock pin seats in next indexing hole. Repeat **Steps 6–7** until index drilling operation is complete.
- When complete, disconnect machine from power and remove workpiece.

Boring Workpiece Freehand

When the indexing guide is disengaged, this machine can be used "freehand" by the operator to perform a wide range of slotting and boring operations, making it ideal for slot mortises and other loose tenon joinery.

To bore a workpiece freehand:

- Measure and mark workpiece, then install selected boring bit into chuck.
- Clamp workpiece to table and adjust table as necessary for workpiece operation (refer to **Adjusting Table** on **Page 22**).

- Pull lock pin out and rotate it 90° clockwise to disengage indexing guide (see **Figure 25**).

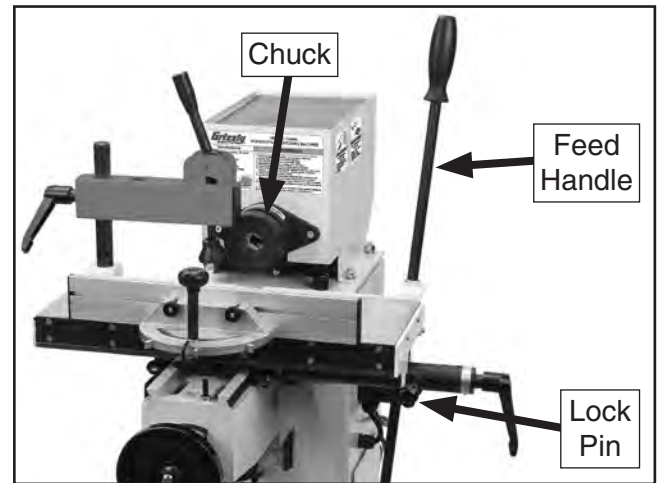


Figure 25. Controls for freehand boring operation.

- Use feed handle to align bit with one outer reference mark and feed workpiece no more than $\frac{1}{16}$ " into bit, then move workpiece across bit to remove material between reference marks (see **Figure 26**).

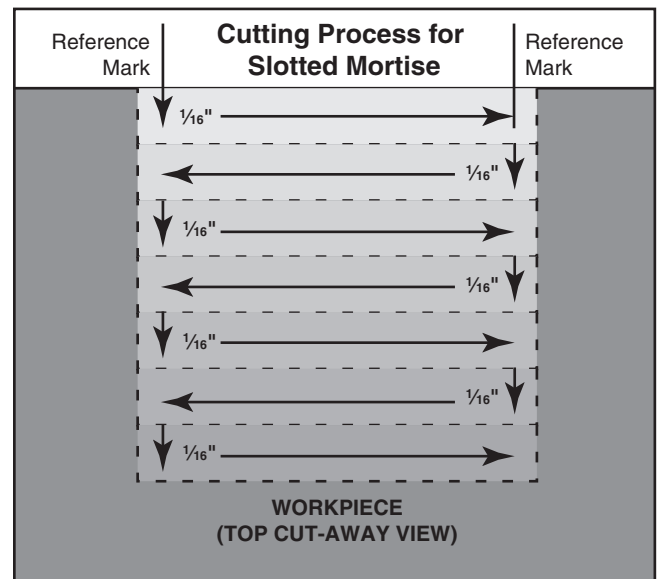


Figure 26. Cutting process for slotted mortise.

- Repeat **Step 4**, moving workpiece into bit in $\frac{1}{16}$ " increments until all material is removed to measured depth.
- When complete, disconnect machine from power and remove workpiece.



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.

Basic Eye Protection

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



Figure 27. Basic eye protection.

Slot Mortising Bits for G0846

- T32923— $\frac{1}{2}$ " Bit, $\frac{1}{2}$ " Shank
- T32924— $\frac{5}{8}$ " Bit, $\frac{1}{2}$ " Shank
- T32925— $\frac{3}{4}$ " Bit, $\frac{1}{2}$ " Shank

T28358—20mm Chuck for G0846

This Westcott-style chuck allows use of bits with $\frac{3}{4}$ " shanks on the G0846 Horizontal Slot Mortiser.



Figure 28. T28358 20mm Chuck.

Recommended Metal Protectants

- G5562—SLIPIT® 1 Qt. Gel
- G5563—SLIPIT® 12 Oz. Spray

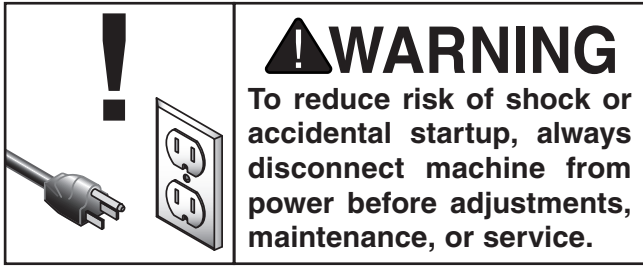


Figure 29. Recommended products for protecting unpainted cast iron/steel parts on machinery.

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:

- Vibration.
- Loose mounting bolts.
- Damaged chuck or bit.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly/Monthly Maintenance (as required based on workload and operating environment)

- Clean/vacuum wood chips and sawdust off of motor, and out of chuck jaws.
- Lubricate work table handle points, hold-down clamp, chuck jaws, work table elevation ways, work table leadscrew, and work table roller bearing tracks (refer to **Lubrication on Page 28**).

Cleaning & Protecting

Cleaning the Model G0846 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use mineral spirits to remove it, then when dry apply a light coat of oil.

Protect the unpainted cast-iron work table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like SLIPIT® (see **Page 26** for more details).

Bit Care

A horizontal boring machine bit requires proper care.

- Store the bits so their sharp points and flutes are protected. A wooden or plastic box that keeps bits from touching one another works best.
- Keep bits clean and rust free.
- Store lightly oiled.
- Have bits sharpened as soon as they show any signs of dulling.



Lubrication

It is essential to clean components before lubricating them. Dust and chips build up on lubricated components, causing sludge that makes them hard to move. Simply adding more lubricant to gummy components will *not* yield smooth movement.

Clean the components in this section with mineral spirits, a rag, or a bristle brush as directed.

The following components need lubrication:

- Work table handle points
- Hold-down clamp
- Chuck jaws
- Table elevation ways
- Table leadscrew
- Table roller bearing V-ways

Items Needed

Qty

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

Table Handle Points

Lubrication Frequency..... 8 hrs. of Operation
Oil Grizzly T27914 or ISO 68 Equivalent

Clean sawdust and debris from table handle points (see **Figure 30**) with mineral spirits and a brush. When dry, apply a thin coat of oil to the points shown. Move the table through the entire range of motion to evenly distribute the oil.

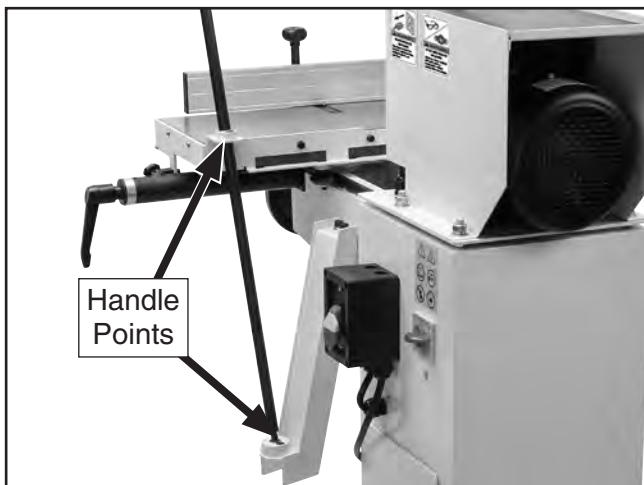


Figure 30. Handle lubrication points.

Hold-Down Clamp & Chuck Jaws

Lubrication Frequency..... 8 hrs. of Operation
Oil Grizzly T27914 or ISO 68 Equivalent

Apply a drop of oil to the hold-down clamp cam (see **Figure 31**).

To clean and lubricate chuck jaws:

1. DISCONNECT MACHINE FROM POWER!
2. Remove chuck guard (see **Figure 31**).

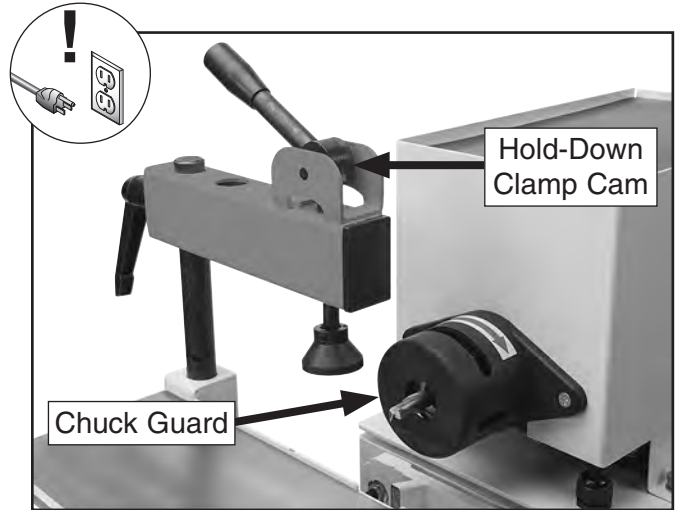


Figure 31. Lubrication points for hold-down clamp cam and chuck jaws.

3. Brush, vacuum, or blow out dust and wood chips.
4. Clean any accumulated oil and wood dust off of chuck with mineral spirits.
5. Apply a drop of oil to each chuck jaw.
6. Re-install chuck guard.



Table Elevation Ways

Lubrication Frequency..... 8 hrs. of Operation
Oil Grizzly T27914 or ISO 68 Equivalent

To lubricate table elevation ways, fully lower the table with the elevation handwheel (see **Figure 32**). Clean each way with mineral spirits, let dry, then apply a light coat of oil. Raise and lower the table to evenly distribute the oil.

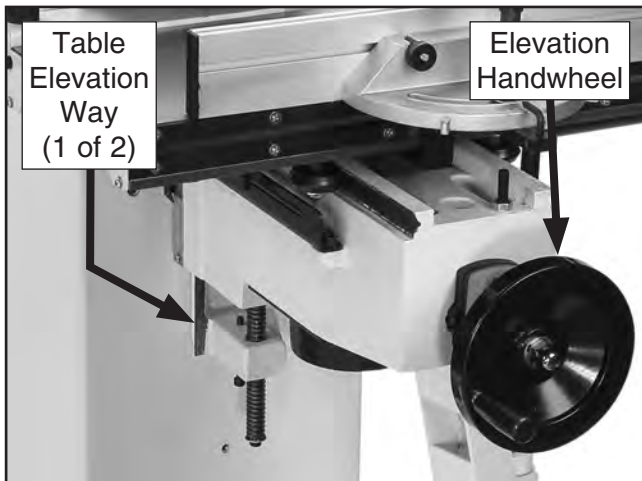


Figure 32. Table elevation ways lubrication points.

Table Elevation Leadscrew

Lubrication Frequency..... 90 hrs. of Operation
Grease..... Grizzly T26419 or NLGI#2 Equivalent

To lubricate table elevation leadscrew:

1. Fully lower table (see **Figure 33**).

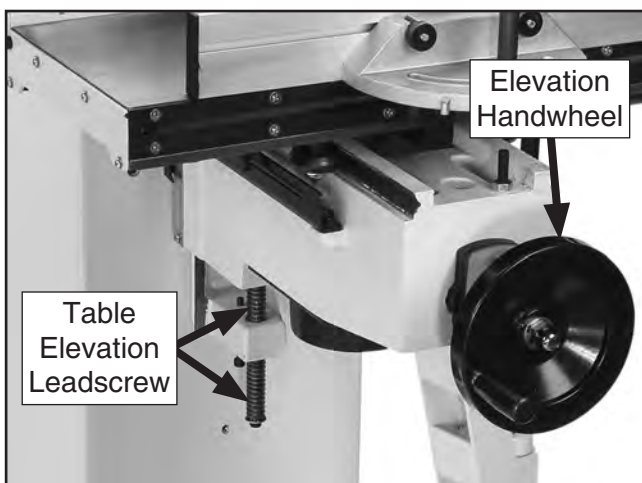


Figure 33. Leadscrew lubrication point.

2. Clean threads with mineral spirits and allow to dry.

Model G0846 (Mfd. Since 02/18)



3. Apply thin coat of NLGI#2 grease to threads.
4. Raise and lower table to evenly distribute grease.

Table Roller Bearing V-Ways

Lubrication Frequency... 8 hrs. Or As Necessary
Grease..... Grizzly T26419 or NLGI#2 Equivalent

Remove accumulated sludge caused by sawdust and debris from the table roller bearing V-ways and wheels as often as necessary to maintain smooth table movement.

To lubricate table roller bearing V-ways:

1. Use mineral spirits, stiff brush, and shop rags to clean table roller bearing V-ways and roller bearing wheels where shown in **Figure 34**.

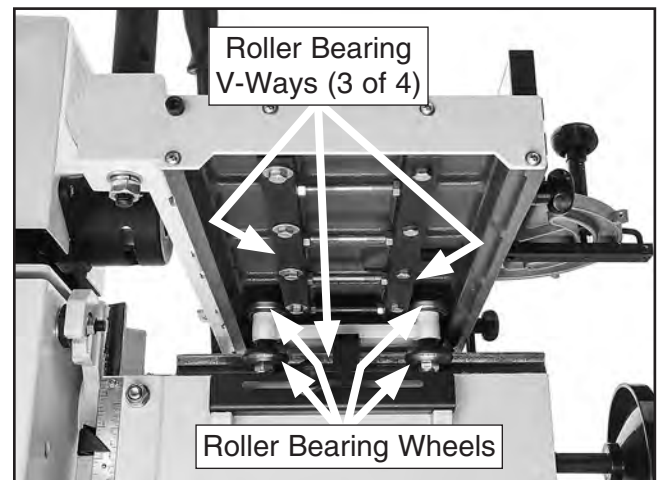


Figure 34. Cleaning and lubrication points for table roller bearing V-ways and wheels (left side shown).

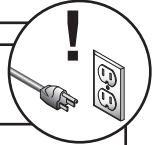
2. Allow to dry.
3. Apply thin coat of grease to V-ways.
4. Move table back and forth and side to side to evenly distribute grease.

Note: If after lubrication you notice that the table has excessive free play, two eccentric rods under the right side of the work table can be adjusted. Refer to **Adjusting Table Roller Bearings on Page 33**.

SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. Incorrect power supply voltage or circuit size. 2. Power supply circuit breaker tripped or fuse blown. 3. Motor wires connected incorrectly. 4. Spindle rotation switch miswired or at fault. 5. Switch disabling key removed. 6. Start capacitor is at fault. 7. Wiring is open/has high resistance. 8. Power ON/OFF switch is at fault. 9. Centrifugal switch is at fault. 10. Spindle rotation switch at fault. 11. Motor is at fault. 	<ol style="list-style-type: none"> 1. Ensure correct power supply voltage and circuit size. 2. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 3. Correct motor wiring connections (Page 39). 4. Rewire or replace switch. 5. Install switch disabling key (Page 19). 6. Test/replace if faulty. 7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 8. Replace faulty ON/OFF switch. 9. Adjust/replace the centrifugal switch if available. 10. Test/replace switch. 11. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor mount loose. 2. Motor or component is loose. 3. Bit not mounted correctly. 4. Machine is incorrectly mounted or sits unevenly on floor. 5. Motor fan is rubbing on fan cover. 6. Centrifugal switch is at fault. 7. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Tighten. 2. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread-locking fluid. 3. Remove and re-install bit (Page 21). 4. Tighten/replace fasteners; relocate/shim machine. 5. Replace dented fan cover; replace loose/damaged fan. 6. Replace centrifugal switch. 7. Test by rotating chuck; rotational grinding/loose shaft requires bearing replacement.
Machine slows or stalls.	<ol style="list-style-type: none"> 1. Workpiece material is not suitable for this machine, or machine undersized for the task. 2. Motor connection is wired incorrectly. 3. Workpiece crooked; hold-down clamp loose or misadjusted. 4. Motor has overheated. 5. Centrifugal switch is at fault. 6. Motor is at fault. 	<ol style="list-style-type: none"> 1. Only drill wood products; make sure moisture content is below 20% and use sharp bits/reduce feed pressure. 2. Correct motor wiring connections (Page 39). 3. Straighten or replace workpiece/adjust hold-down clamp pressure (Page 24). 4. Clean off motor, let cool, and reduce workload. 5. Adjust/replace centrifugal switch. 6. Test/repair/replace.



Operation

Symptom	Possible Cause	Possible Solution
Mortises are irregular.	<ol style="list-style-type: none"> 1. Chip or feed pressure too great. 2. Chips loading up bit. 	<ol style="list-style-type: none"> 1. Use bit with bigger cleanout spirals/reduce feed pressure. 2. Reduce cutting depth, make more passes, or sharpen/replace bit.
Machine slows when operating.	<ol style="list-style-type: none"> 1. Applying too much pressure to workpiece. 2. Too many chips binding the cut. 3. Bit is dull, or bit rotation is incorrect. 	<ol style="list-style-type: none"> 1. Feed workpiece slower; use less pressure. 2. Pull workpiece frequently out of bit to clear chips. 3. Replace bit/inspect, reverse chuck rotation.
Holes not drilled straight into workpiece.	<ol style="list-style-type: none"> 1. Work table loose. 2. Chuck is not square to the table. 3. Motor is not parallel to the table. 4. Bit is loose in chuck. 5. Bit comes loose or slips during boring operation. 	<ol style="list-style-type: none"> 1. Tighten table lock lever to increase rigidity during operations; adjust table roller bearings (Page 33). 2. Inspect and square chuck to table (Page 33). 3. Adjust motor-table parallelism (Page 35). 4. Service/clean/tighten chuck (Page 28). 5. Use bits with $\frac{5}{8}$" shank/use shorter bit/reduce cutting depth/avoid plunge cuts.
Mortise and tenons don't line up well.	<ol style="list-style-type: none"> 1. Table wheels loose in V-ways. 2. Table gib out of adjustment. 	<ol style="list-style-type: none"> 1. Clean table wheels/V-ways; adjust wheel eccentric rods (Page 29). 2. Adjust gib (Page 32).
Erratic work table movement.	<ol style="list-style-type: none"> 1. Wood chips, sawdust and debris caught in work table handle points. 2. Wood chips, sawdust and debris caught in work table roller bearing tracks. 3. Wood chips, sawdust and debris caught in work table leadscrew. 4. Wood chips, sawdust and debris caught in work table elevation ways. 5. Work table gib too loose/too tight. 	<ol style="list-style-type: none"> 1. Clean and lubricate table handle points (Page 28). 2. Clean and lubricate table roller bearing V-ways and wheels (Page 29). 3. Clean and lubricate table leadscrew (Page 29). 4. Clean and lubricate table elevation ways (Page 29); adjust table roller bearings (Page 33). 5. Adjust gib (Page 32).



Adjusting Fence & Miter Gauge Indicator

The miter gauge indicator is adjusted at the factory and shows the angle of the fence relative to the table.

Adjust the indicator if it shifts out of alignment, or if the fence, miter gauge, and indicator were removed to perform an oversized boring operation.

Items Needed	Qty
Precision Square.....	1
Hex Wrench 2.5mm.....	1

To adjust fence and miter gauge indicator:

1. Loosen miter gauge lock knob (see **Figure 35**).

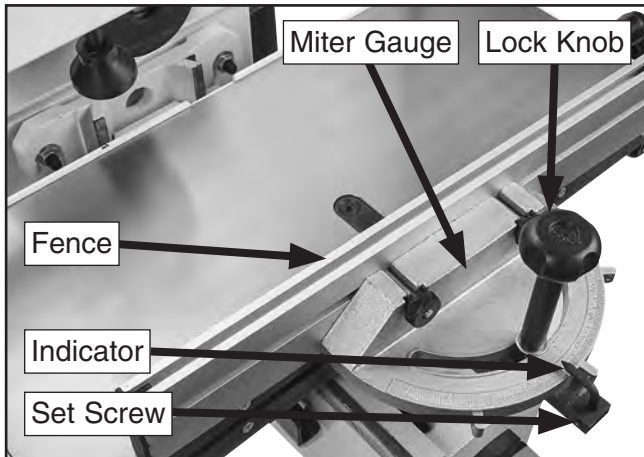


Figure 35. Miter gauge adjustments.

2. Place precision square against fence face. Adjust fence until it is 90° to table, then tighten miter gauge lock knob.
3. Loosen set screw in miter gauge bar and move indicator to align it with 90° mark on miter gauge scale (see **Figure 35**). Tighten set screw to secure setting.

Adjusting Table Gib

The Model G0846 has a gib on the right side of the knee that applies pressure on the elevation way dovetail as the work table moves up and down. It is adjustable with two set screws. The upper set screw has a lock nut (see **Figure 36**).

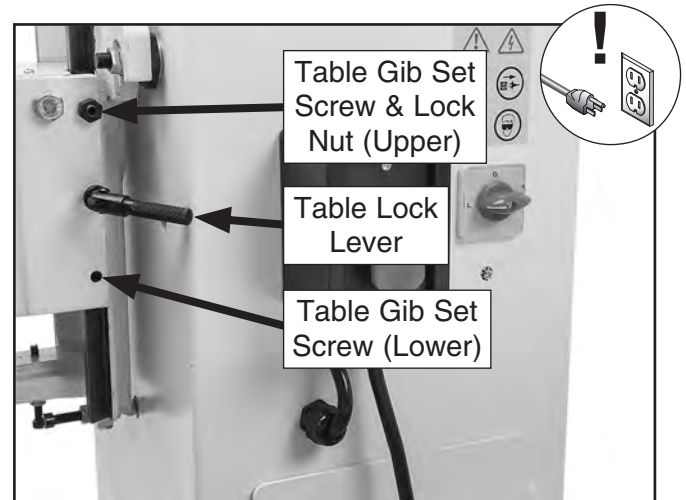


Figure 36. Table elevation gib adjustment locations.

If the gib is too loose, the quality of boring operations will suffer because the table will have loose, sloppy movement against the dovetails. If the gib is too tight, it will be difficult to raise and lower the table.

The goal of adjusting the gib is to keep the vertical movement of the table snug, without excessive looseness or binding.

Items Needed	Qty
Open-End Wrench 14mm.....	1
Hex Wrench 4mm.....	1

To adjust gib:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen table lock lever (see **Figure 36**).
3. Loosen lock nut on upper gib adjustment set screw (see **Figure 36**).



- If table moves up and down with excessive looseness, tighten both gib adjustment set screws until gib is snug against elevation way dovetail, then back off gib adjustment set screws $\frac{1}{8}$ turn.
- Use elevation handwheel to move table up and down to test gib adjustment. Table should move easily without excessive looseness or binding. If necessary, re-adjust set screws and test table movement again.
- After completing gib adjustment, hold upper set screw in position and tighten lock nut to secure gib in position.

Adjusting Table Roller Bearings

If you notice that the table has excessive free play when moving left/right, two eccentric rods on the two roller bearings under the right side of the table can be adjusted to reduce free play.

Items Needed	Qty
Open-End Wrench 16mm.....	1

To adjust table roller bearings:

- DISCONNECT MACHINE FROM POWER!
- Clean table roller bearings and V-ways (refer to **Table Roller Bearings Tracks on Page 29**).
- Use wrench on each upper hex nut to turn eccentric rod and adjust roller bearing wheel location in V-way track, then lift table to test for free play.
- Adjust each eccentric rod until table free play is eliminated and table moves smoothly in all directions.

Squaring Chuck with Table

The axis of the chuck was set 90° to the table at the factory. This ensures boring operations will be horizontally squared in the workpiece.

If boring holes are no longer accurate on a workpiece, as shown in **Figure 37**, refer to **Troubleshooting on Page 30** to rule out other solutions first, then perform the following procedure to realign the chuck and table.

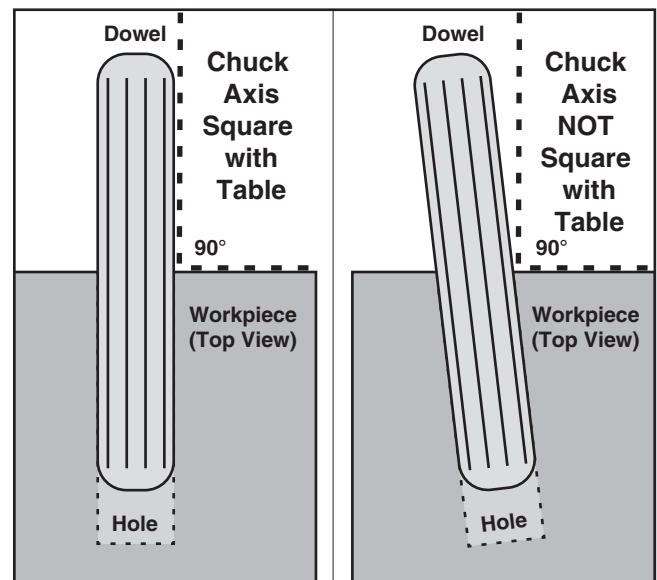


Figure 37. Determining if chuck axis is square to table.

IMPORTANT: Refer to **Adjusting Fence & Miter Gauge Indicator on Page 32**, **Adjusting Table Gib on Page 32**, and **Adjusting Table Roller Bearings on this page** before proceeding with these instructions.

Items Needed	Qty
Precision Square 6".....	1
Drill Rod $\frac{5}{8}$ " x 8"	1
Open-End Wrench 13mm.....	2
Open-End Wrench 16mm.....	1
Hex Wrench 6mm.....	1

To inspect and square chuck with table:

- DISCONNECT MACHINE FROM POWER!



2. Clean and service chuck (refer to **Hold-Down Clamp & Chuck Jaws** on **Page 28**).
3. Follow instructions in **Adjusting Table Roller Bearings** on **Page 33**.
4. Mount drill rod (round, straight metal $\frac{5}{8}$ " diameter) in chuck (see **Figure 38**). Rotate by chuck hand to ensure rod is straight and doesn't wobble.
5. Raise table just under drill rod, then tighten table lock lever (see **Figure 38**).
6. Place precision square evenly along table lip so it touches drill rod (see **Figure 38**).

—If there is no gap between the square and drill rod anywhere along its length, no adjustment is necessary. The chuck is square to the table. No further adjustments are necessary.

—If there is a gap between the square and drill rod at either end of the table, the chuck is not square to the table. Proceed to **Step 7**.

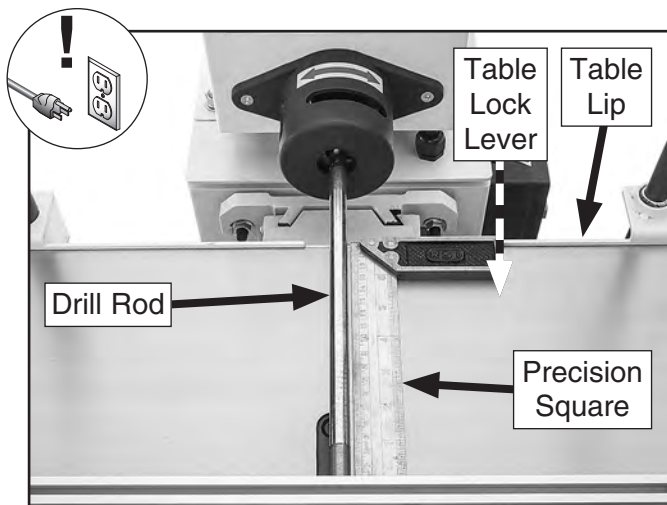


Figure 38. Checking chuck-to-table square.

7. Remove (2) flat head screws from chuck guard and separate it from motor cover (see **Figure 39**).

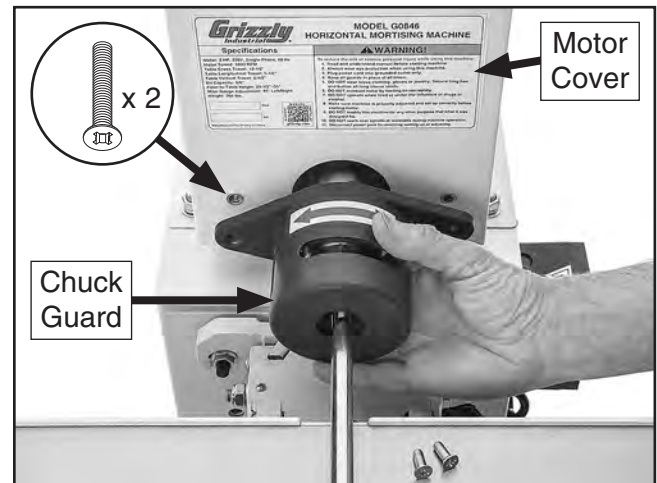


Figure 39. Removing chuck guard.

8. Remove (4) hex nuts, lock washers, and flat washers securing motor cover to machine body, then lift off cover.
9. Loosen (4) hex nuts securing motor to machine body (see **Figure 40**), and shift motor to square chuck with table. Repeat **Steps 5–6** to adjust motor position until chuck is square to table.

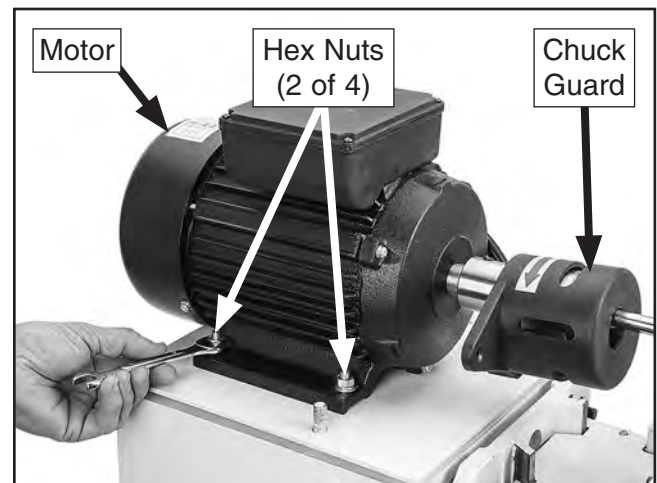


Figure 40. Loosening motor mount hex nuts.

10. Tighten hex nuts to secure motor setting.
11. Re-install motor cover and chuck guard.



Adjusting Table Parallelism with Chuck

The motor and chuck axis was set parallel with the table by the factory. This ensures boring operations will be vertically squared in the workpiece

If boring holes are no longer perpendicular to the workpiece, as shown in **Figure 41**, refer to **Troubleshooting on Page 30** to rule out other solutions first, then perform the following procedure to reset table parallelism.

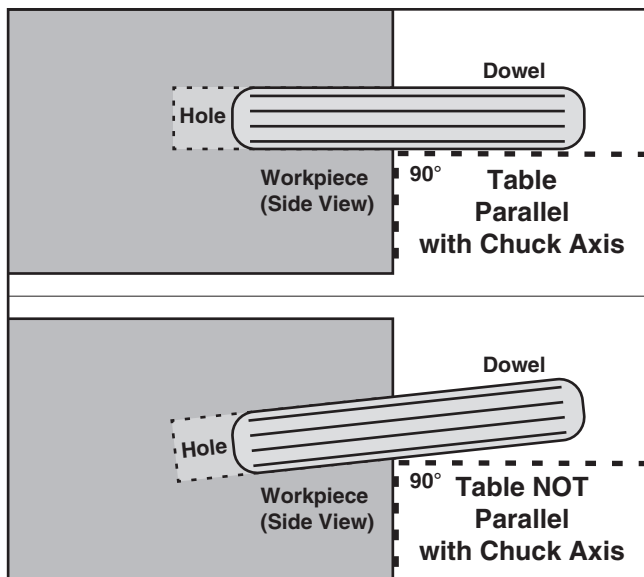


Figure 41. Determining if chuck axis is parallel with table.

IMPORTANT: Refer to **Adjusting Table Gib on Page 32** and **Adjusting Table Roller Bearings on Page 33** before proceeding with these instructions.

Items Needed	Qty
Adjustable Square	1
Drill Rod $\frac{5}{8}$ " x 8"	1
Open-End Wrench 13mm.....	1
Hex Wrench 6mm.....	1

To verify table parallelism with chuck:

1. DISCONNECT MACHINE FROM POWER!
2. Clean and service chuck (refer to **Hold-Down Clamp & Chuck Jaws on Page 28**).
3. Follow instructions in **Adjusting Table Roller Bearings on Page 33**.
4. Mount drill rod (round, straight metal $\frac{5}{8}$ " diameter) in chuck. Rotate by chuck hand to ensure rod is straight and doesn't wobble.
5. Raise table until there is approximately 1" gap between table surface and bottom of drill rod (see **Figure 42**), then tighten table lock.
6. Set adjustable square against drill rod and table at chuck end, as shown in **Figure 42**, then tighten square to secure measurement.

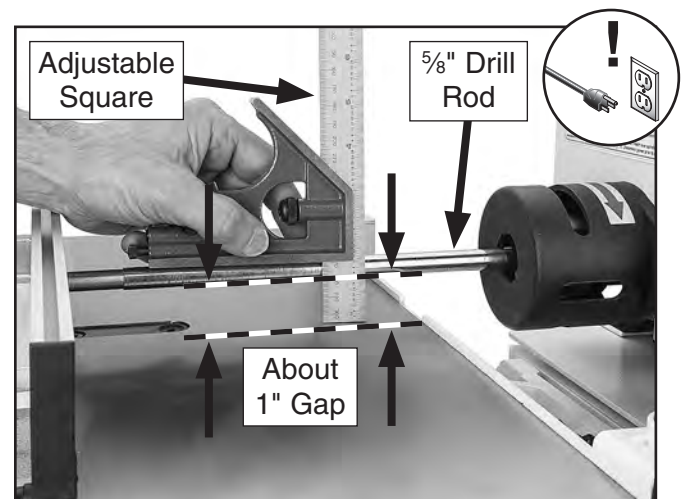


Figure 42. Checking table-chuck axis parallelism.

7. Move square to opposite end of drill rod to check parallelism.
 - If measurements at both ends of drill rod are equal, no adjustment is necessary. The chuck is parallel to the table.
 - If measurements at both ends of drill rod are not equal, the chuck is not parallel to the table. Proceed to **Step 8**.



8. Loosen (3) lock nuts on adjustment cap screw (see **Figure 43**).

—To lower outer edge of table, rotate cap screw clockwise.

—To raise outer edge of table, rotate cap screw counterclockwise.

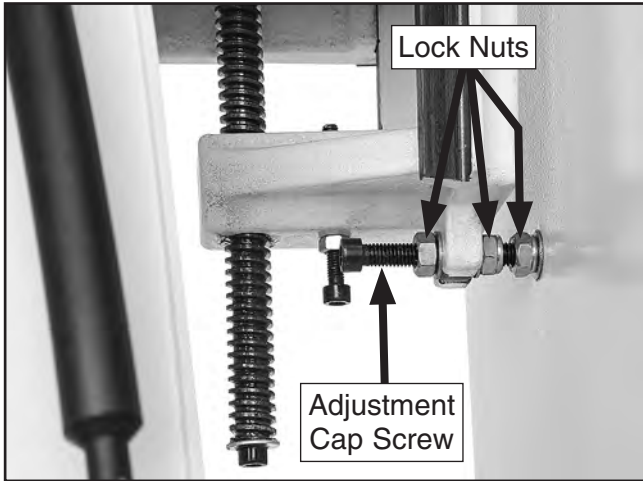


Figure 43. Adjustments for table-motor parallelism.

9. Repeat **Steps 6–8** and adjust cap screw as needed until table is parallel to chuck axis.
10. Tighten lock nuts on adjustment cap screw to secure table parallelism.

Adjusting Table Vertical Height

The table moves a total of 5½" and features a cap screw that functions as a depth stop to adjust the table height for boring operations.

Items Needed	Qty
Open-End Wrench 14mm.....	1
Hex Wrench 6mm.....	1

To adjust table vertical height:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen lock nut (see **Figure 44**).
 - To raise table height, turn cap screw counterclockwise.
 - To lower table height, turn cap screw clockwise.

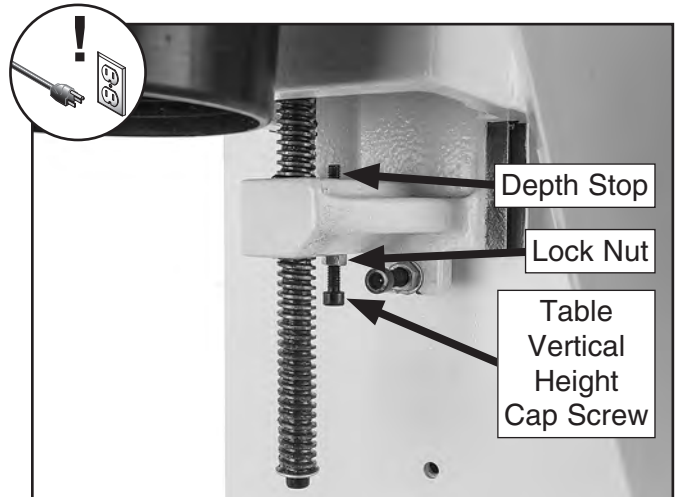


Figure 44. Table vertical height adjustments.

3. Test depth stop by inserting boring bit into chuck, clamping a sample workpiece to table, and raising table with elevation handwheel until depth stop contacts stop block.
4. Adjust depth stop as needed, then tighten lock nut to secure setting.



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

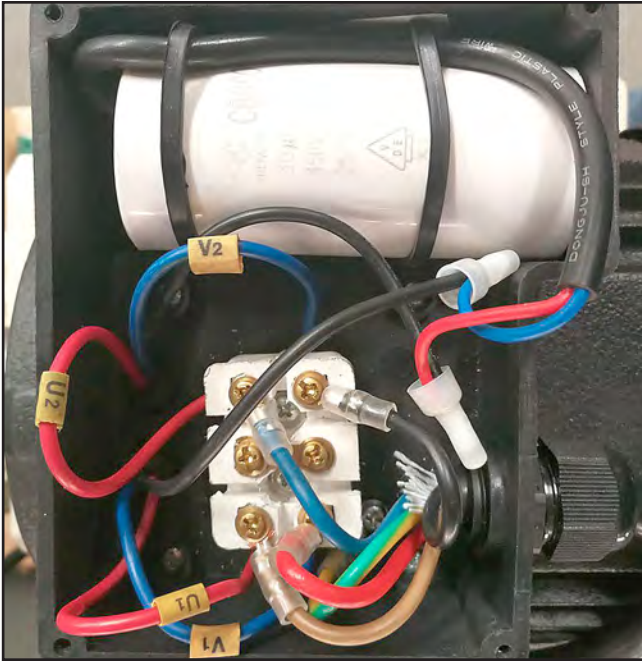


Figure 45. Junction box wiring.

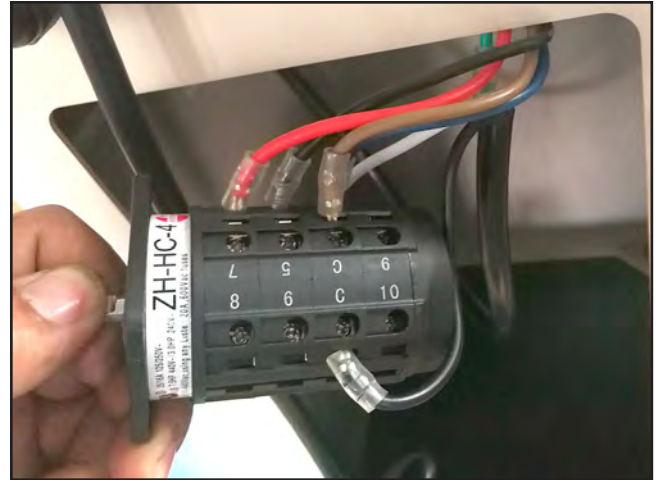


Figure 47. Rotary switch (left side).

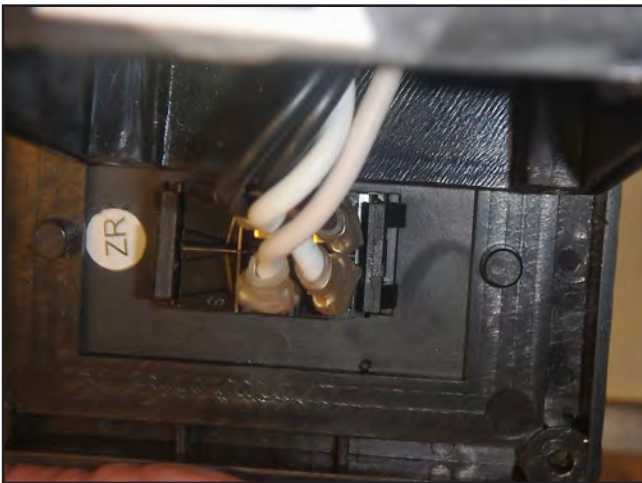


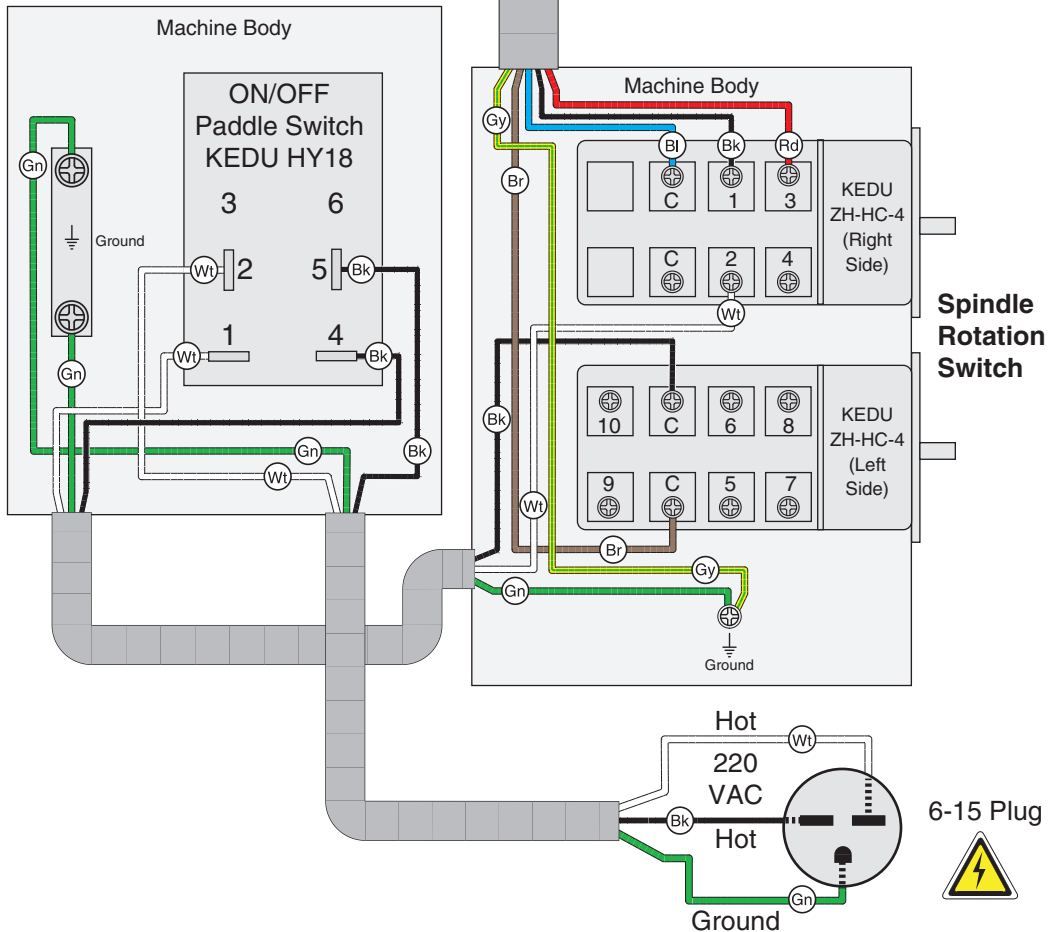
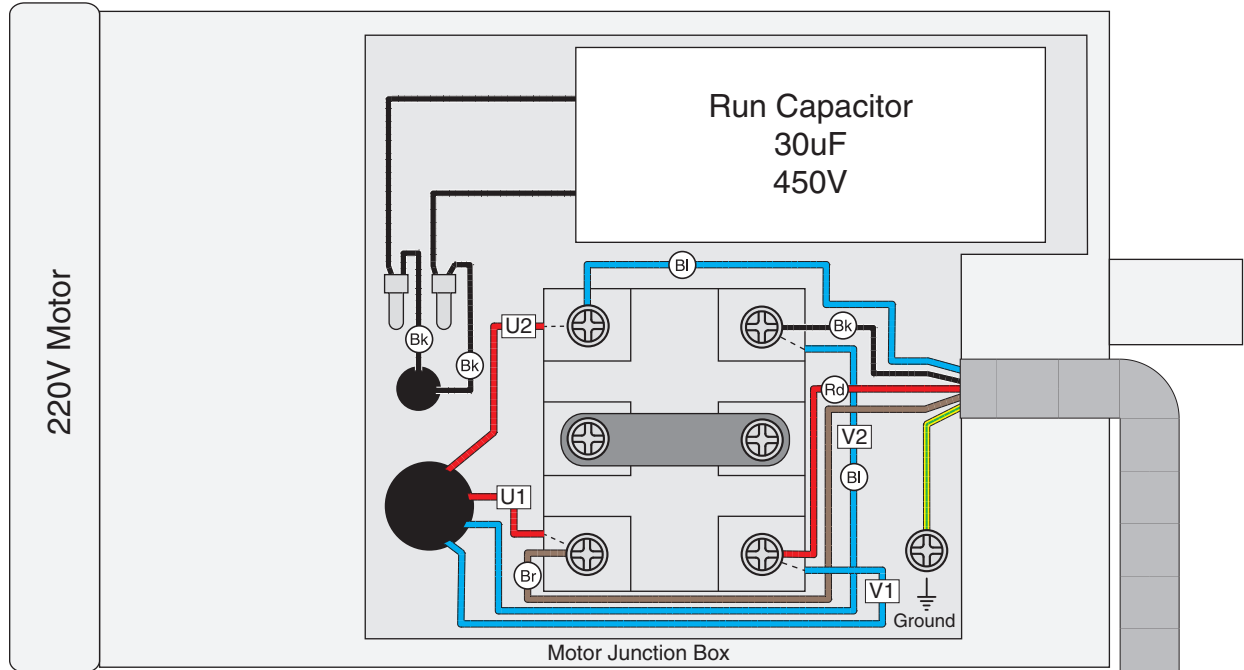
Figure 46. ON/OFF switch wiring (rear view).



Figure 48. Rotary switch (right side).

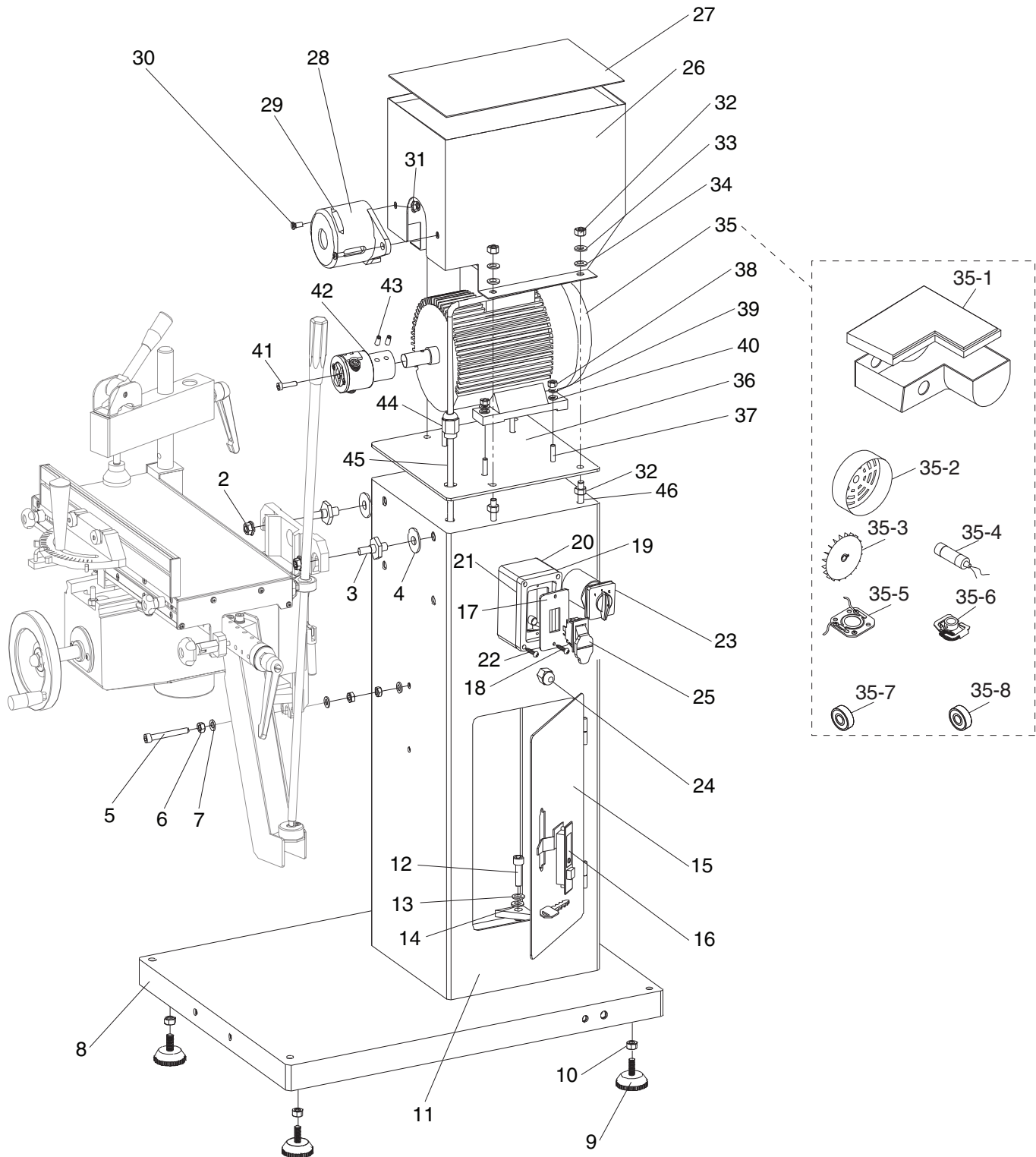


Wiring Diagram



SECTION 9: PARTS

Base, Column & Motor



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



Base, Column & Motor Parts List

REF	PART #	DESCRIPTION
2	P0846002	HEX NUT M10-1.5
3	P0846003	DOUBLE-BOLT M10-1.5
4	P0846004	FENDER WASHER 10MM
5	P0846005	CAP SCREW M8-1.25 X 70
6	P0846006	HEX NUT M8-1.25
7	P0846007	FLAT WASHER 8MM
8	P0846008	BASE
9	P0846009	ADJUSTABLE FOOT M10-1.5 X 24, 50D
10	P0846010	HEX NUT M10-1.5
11	P0846011	COLUMN
12	P0846012	CAP SCREW M10-1.5 X 35
13	P0846013	FLAT WASHER 10MM
14	P0846014	LOCK WASHER 10MM
15	P0846015	DOOR
16	P0846016	DOOR LOCK W/ 2 KEYS
17	P0846017	SWITCH COVER PLATE
18	P0846018	PHLP HD SCR M4-.7 X 10
19	P0846019	SWITCH BOX GASKET
20	P0846020	SWITCH BOX
21	P0846021	SWITCH ADAPTER PLATE
22	P0846022	PHLP HD SCREW M4-.7 X 16
23	P0846023	FWD/REV SWITCH KEDU ZH-HC-4
24	P0846024	STRAIN RELIEF TYPE-3 M20-1.5
25	P0846025	PADDLE SWITCH KEDU HY18
26	P0846026	MOTOR COVER
27	P0846027	RUBBER PLATE

REF	PART #	DESCRIPTION
28	P0846028	CHUCK GUARD
29	P0846029	ROTATION DIRECTION LABEL
30	P0846030	PHLP HD SCR M6-1 X 16
31	P0846031	HEX NUT M6-1
32	P0846032	HEX NUT M10-1.5
33	P0846033	FLAT WASHER 10MM
34	P0846034	LOCK WASHER 10MM
35	P0846035	MOTOR 2HP 220V 1-PH
35-1	P0846035-1	MOTOR JUNCTION BOX
35-2	P0846035-2	MOTOR FAN COVER
35-3	P0846035-3	MOTOR FAN
35-4	P0846035-4	R CAPACITOR 30M 450V 1-5/8" X 3"
35-5	P0846035-5	CONTACT PLATE
35-6	P0846035-6	CENTRIFUGAL SWITCH
35-7	P0846035-7	BALL BEARING 6204-2RS
35-8	P0846035-8	BALL BEARING 6204-2RS
36	P0846036	MOTOR MOUNTING BASE
37	P0846037	HEX BOLT M8-1.25 X 30
38	P0846038	HEX NUT M8-1.25
39	P0846039	FLAT WASHER 8MM
40	P0846040	LOCK WASHER 8MM
41	P0846041	CAP SCREW M6-1 X 20
42	P0846042	CHUCK
43	P0846043	SET SCREW M8-1.25 X 16
44	P0846044	STRAIN RELIEF TYPE-3 M20-1.5
45	P0846045	MOTOR CORD 10G 3W 24"



Table Knee

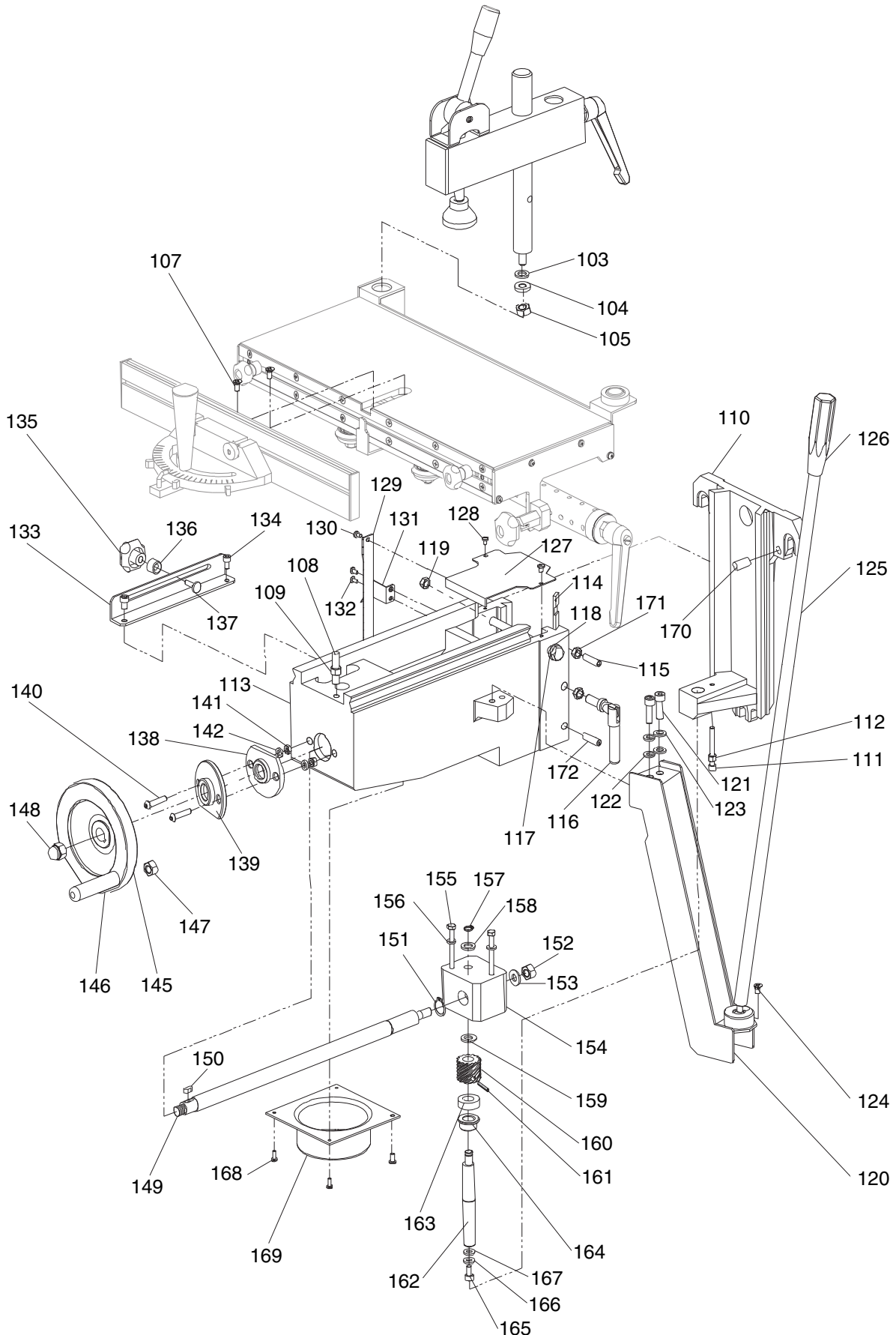


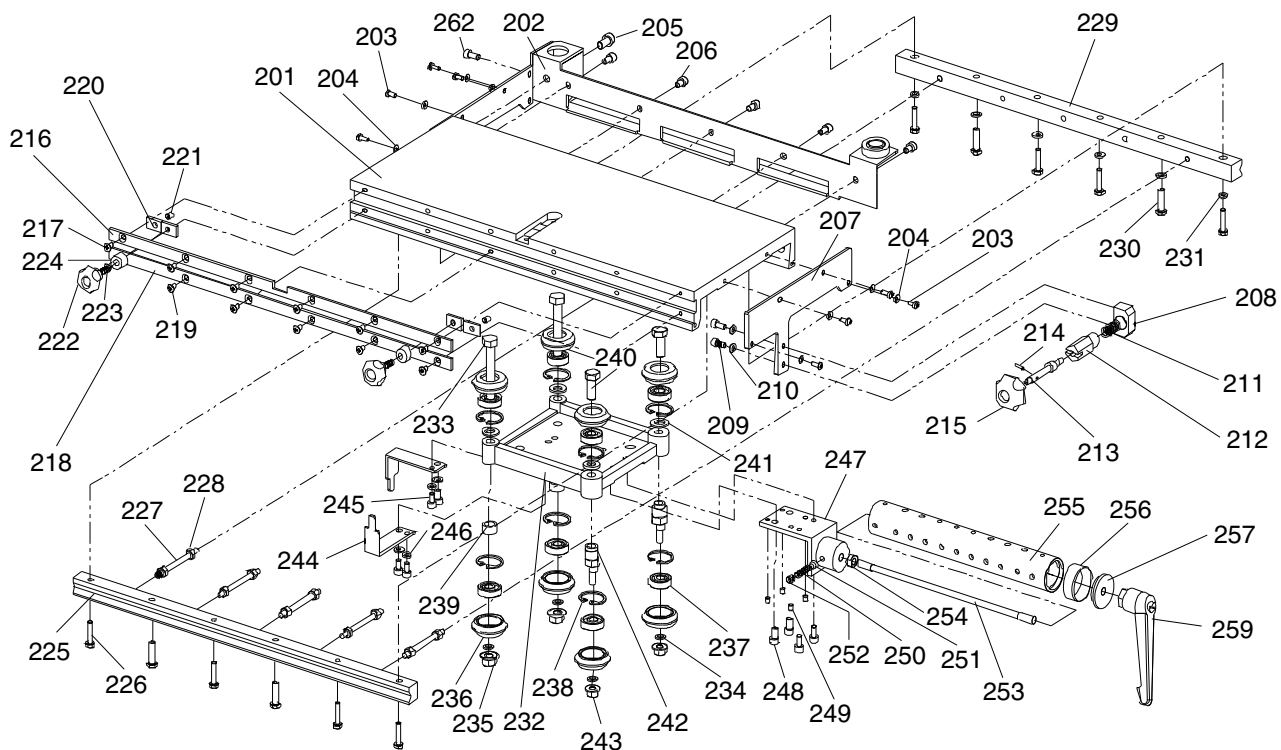
Table Knee Parts List

REF	PART #	DESCRIPTION
103	P0846103	LOCK WASHER 10MM
104	P0846104	FLAT WASHER 10MM
105	P0846105	HEX NUT M10-1.5
107	P0846107	SET SCREW M6-1 X 12
108	P0846108	SET SCREW M8-1.25 X 40
109	P0846109	HEX NUT M8-1.25
110	P0846110	TABLE KNEE WAYS
111	P0846111	CAP SCREW M6-1 X 55
112	P0846112	HEX NUT M6-1
113	P0846113	TABLE KNEE
114	P0846114	INSERT PLATE
115	P0846115	SET SCREW M8-1.25 X 25
116	P0846116	LOCKING HANDLE M10-1.5 X 25
117	P0846117	HEX BOLT M10-1.5 X 150
118	P0846118	FLAT WASHER 10MM
119	P0846119	HEX NUT M10-1.5
120	P0846120	HANDLE BRACKET
121	P0846121	HEX BOLT M8-1.25 X 25
122	P0846122	LOCK WASHER 8MM
123	P0846123	FLAT WASHER 8MM
124	P0846124	FLAT HD CAP SCR M6-1 X 12
125	P0846125	HANDLE LEVER
126	P0846126	HANDLE GRIP
127	P0846127	COVER PLATE
128	P0846128	PHLPS HD SCR M4-.7 X 6
129	P0846129	DEPTH SCALE
130	P0846130	PHLPS HD SCR M4-.7 X 6
131	P0846131	POINTER
132	P0846132	PHLPS HD SCR M4-.7 X 6
133	P0846133	LOCK PLATE
134	P0846134	CAP SCREW M6-1 X 12
135	P0846135	KNOB M6-1 30D, 22L, 4LOBES
136	P0846136	SPACER
137	P0846137	CARRIAGE BOLT M6-1 X 20

REF	PART #	DESCRIPTION
138	P0846138	HANDWHEEL HUB PLATE
139	P0846139	PLATE
140	P0846140	CAP SCREW M8-1.25 X 35
141	P0846141	HEX NUT M8-1.25
142	P0846142	FLAT WASHER 8MM
145	P0846145	HANDWHEEL TYPE-18 138D X 15B-K
146	P0846146	HANDWHEEL HANDLE
147	P0846147	HEX NUT M8-1.25
148	P0846148	ACORN NUT M12-1.75
149	P0846149	GEAR SHAFT M12-1.75 X 12
150	P0846150	PIN 5 X 12
151	P0846151	EXT RETAINING RING 18MM
152	P0846152	HEX NUT M10-1.5
153	P0846153	FLAT WASHER 10MM
154	P0846154	GEARBOX
155	P0846155	HEX BOLT M6-1 X 65
156	P0846156	LOCK WASHER 6MM
157	P0846157	EXT RETAINING RING 10MM
158	P0846158	FLAT WASHER 10MM
159	P0846159	FLAT WASHER 10MM
160	P0846160	HELICAL GEAR
161	P0846161	ROLL PIN 4 X 25
162	P0846162	GUIDE SCREW
163	P0846163	THRUST BEARING 51102
164	P0846164	BUSHING
165	P0846165	CAP SCREW M6-1 X 12
166	P0846166	LOCK WASHER 6MM
167	P0846167	FLAT WASHER 6MM
168	P0846168	PHLP HD SCR M4-.7 X 10
169	P0846169	DUST PORT 4"
170	P0846170	SET SCREW M8-1.25 X 25
171	P0846171	HEX NUT M8-1.25 THIN
172	P0846172	SET SCREW M8-1.25 X 20



Table

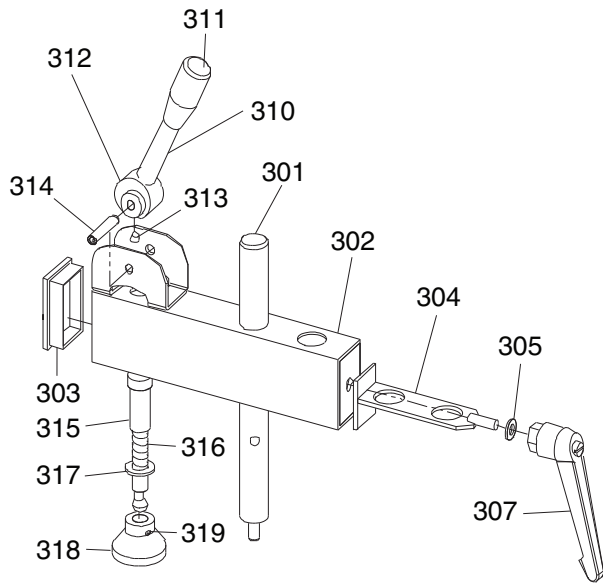


REF	PART #	DESCRIPTION
201	P0846201	WORK TABLE
202	P0846202	TABLE MOUNTING BRACKET
203	P0846203	PHLP HD SCR M4-.7 X 10
204	P0846204	FLAT WASHER 4MM
205	P0846205	CAP SCREW M8-1.25 X 16
206	P0846206	CAP SCREW M6-1 X 12
207	P0846207	END PLATE
208	P0846208	PIN BASE
209	P0846209	CAP SCREW M5-.8 X 12
210	P0846210	LOCK WASHER 5MM
211	P0846211	COMPRESSION SPRING
212	P0846212	PIN TUBE
213	P0846213	LOCKING PIN
214	P0846214	ROLL PIN 3 X 12
215	P0846215	KNOB M6-1, D30, 4-LOBE
216	P0846216	X-AXIS LOCKING PLATE
217	P0846217	PHLP HD SCREW M5-.8 X 10
218	P0846218	Y-AXIS LOCKING PLATE
219	P0846219	PHLP HD SCREW M5-.8 X 10
220	P0846220	LOCKING BLOCK
221	P0846221	SET SCREW M6-1 X 8
222	P0846222	KNOB BOLT M6-1 X 20, 30D, 4-LOBE
223	P0846223	SPACER
224	P0846224	LOCKING BLOCK
225	P0846225	FIXED TRACK
226	P0846226	HEX BOLT M6-1 X 25
227	P0846227	DOUBLE HEAD PIN M6-1 X 80
228	P0846228	HEX NUT M6-1
229	P0846229	ADJUSTING TRACK
230	P0846230	HEX BOLT M6-1 X 25

REF	PART #	DESCRIPTION
231	P0846231	FLAT WASHER 6MM
232	P0846232	SLIDING BASE
233	P0846233	LOCKING AXLE
234	P0846234	FLAT WASHER 10MM
235	P0846235	HEX NUT M10-1.5
236	P0846236	IDLER WHEEL
237	P0846237	BALL BEARING 6000-2RS
238	P0846238	EXT RETAINING RING 26MM
239	P0846239	TUBE
240	P0846240	HEX BOLT M10-1.5 X 25
241	P0846241	FLAT WASHER 10MM
242	P0846242	ECCENTRIC ROD
243	P0846243	HEX NUT M8-1.25
244	P0846244	TABLE STOP
245	P0846245	CAP SCREW M6-1 X 12
246	P0846246	FLAT WASHER 6MM
247	P0846247	INDEXING BAR BRACKET
248	P0846248	CAP SCREW M6-1 X 12
249	P0846249	SET SCREW M5-.8 X 6
250	P0846250	COMPRESSION SPRING
251	P0846251	STEEL BALL 6MM
252	P0846252	SET SCREW M8-1.25 X 8
253	P0846253	LOCKING AXLE
254	P0846254	HEX NUT M8-1.25
255	P0846255	INDEXING BAR
256	P0846256	INDEXING SCALE
257	P0846257	COVER PLATE
259	P0846259	ADJUSTABLE HANDLE 116L, M5-8 X 8
262	P0846262	CAP SCREW M6-1 X 8

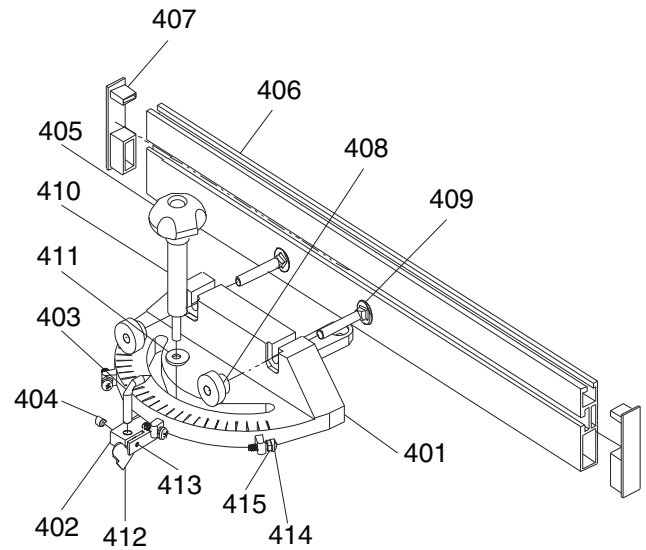


Hold-Down Assembly



REF	PART #	DESCRIPTION
301	P0846301	SUPPORT BAR
302	P0846302	HOLD DOWN BAR
303	P0846303	PLASTIC COVER
304	P0846304	LOCKING PLATE
305	P0846305	FLAT WASHER 8MM
307	P0846307	ADJUSTABLE HANDLE M8-1.25
310	P0846310	LOCKING BAR M8-1.25 X12
311	P0846311	LOCK LEVER
312	P0846312	ECCENTRIC BLOCK
313	P0846313	SET SCREW M6-1 X 8
314	P0846314	PIN 8 X 40
315	P0846315	PRESS AXLE
316	P0846316	COMPRESSION SPRING
317	P0846317	FLAT WASHER 12MM
318	P0846318	PRESS BLOCK
319	P0846319	ROLL PIN 4 X 20

Miter Gauge & Fence



REF	PART #	DESCRIPTION
401	P0846401	MITER GAUGE BODY
402	P0846402	SCALE LOCKING BLOCK
403	P0846403	POINTER
404	P0846404	SET SCREW M5-.8 X 8
405	P0846405	KNOB M8-1.25, D40, 4-LOBE
406	P0846406	MITER GAUGE FENCE
407	P0846407	END CAP
408	P0846408	KNURLED NUT M6-1
409	P0846409	HEX BOLT M6-1 X 40
410	P0846410	STUD-UDE M8-1.25 X 12, M6-1 X 20, 96L
411	P0846411	FENDER WASHER 6MM
412	P0846412	BLOCK
413	P0846413	ROLL PIN 3 X 6
414	P0846414	PHLP HD SCR M4-.7 X 16
415	P0846415	HEX NUT M4-.7



Labels & Cosmetics

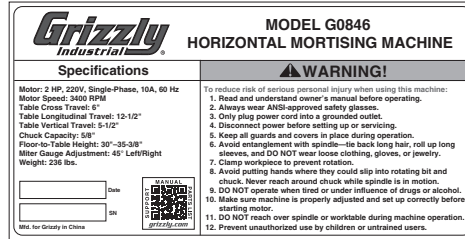
501



502



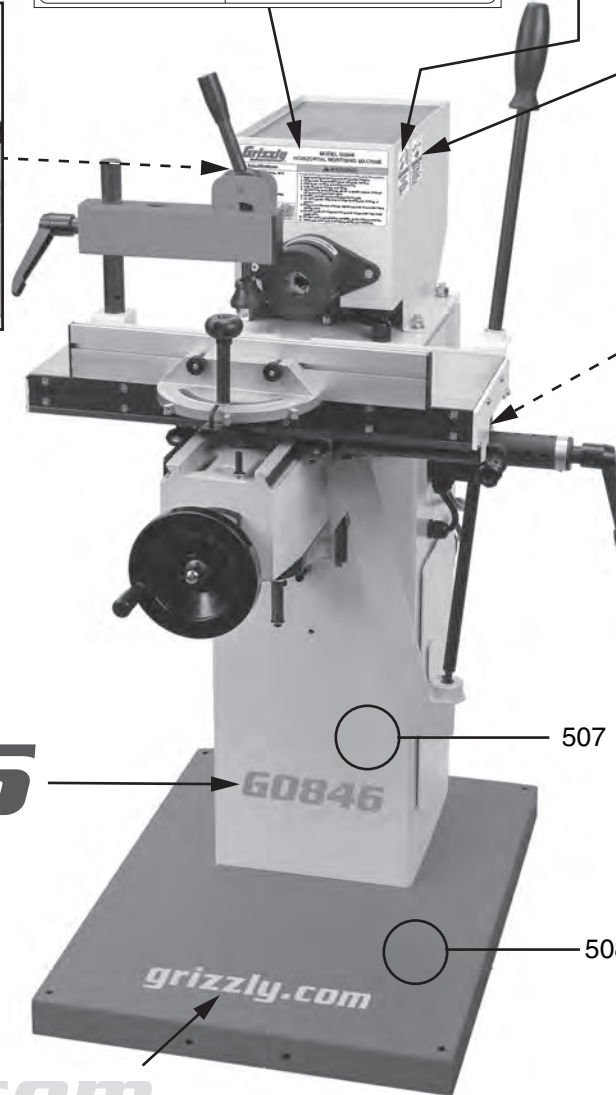
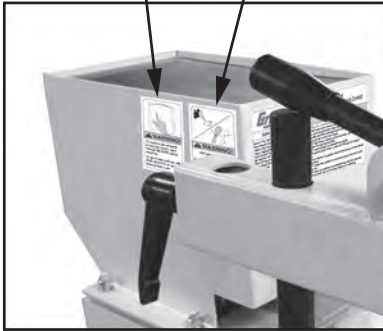
503



504



505



510

G0846

509

grizzly.com

REF	PART #	DESCRIPTION
501	P0846501	READ MANUAL WARNING
502	P0846502	ENTANGLEMENT WARNING
503	P0846503	MACHINE ID LABEL
504	P0846504	INJURY/SHOCK WARNING
505	P0846505	EYE/LUNG WARNING

REF	PART #	DESCRIPTION
506	P0846506	ELECTRICAL WARNING
507	P0846507	TOUCH-UP PAINT, GRIZZLY BEIGE
508	P0846508	TOUCH-UP PAINT, GRIZZLY GREEN
509	P0846509	GRIZZLY.COM LABEL
510	P0846510	MODEL NUMBER LABEL





WARRANTY CARD

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

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

- How did you learn about us?

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

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

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

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

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

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

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



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



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____
Street_____
City_____ State_____ Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

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

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

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

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

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

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

grizzly.com[®]
TOOL WEBSITE

Buy Direct and Save with Grizzly[®] – Trusted, Proven and a Great Value!
~Since 1983~

*Visit Our Website Today For
Current Specials!*

**ORDER
24 HOURS A DAY!
1-800-523-4777**

