

Grizzly **Industrial, Inc.**®

MODEL G0885 **5" PORTABLE METAL-CUTTING** **BANDSAW** **OWNER'S MANUAL** *(For models manufactured since 04/19)*



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V1.03.22

WARNING!

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

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

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

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

WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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


Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

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

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

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

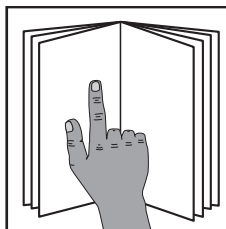
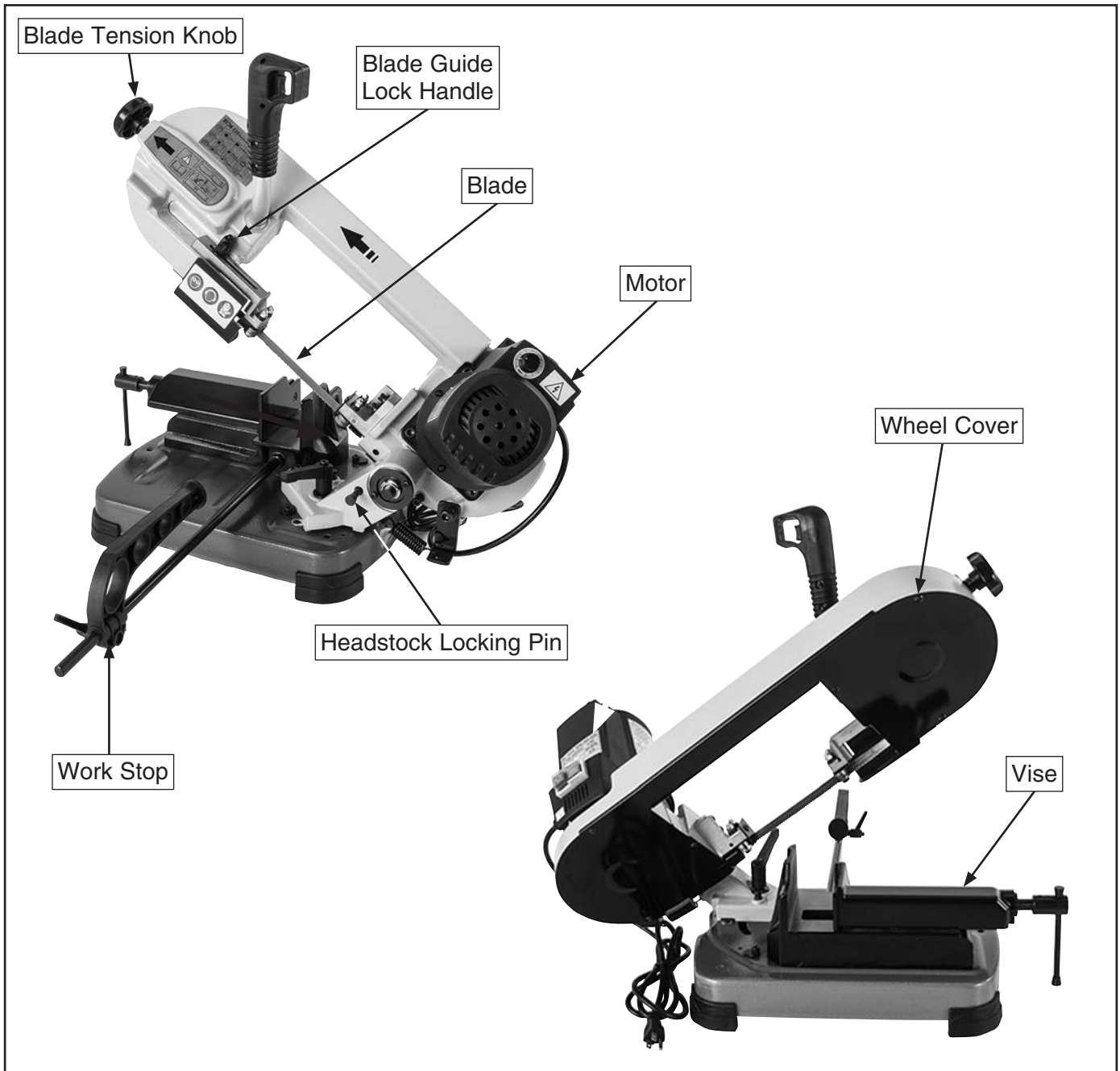
Manufacture Date

Serial Number



Identification

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

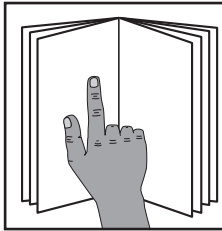


⚠️ WARNING

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



Controls & Components



!WARNING

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

Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

Control or Component Description

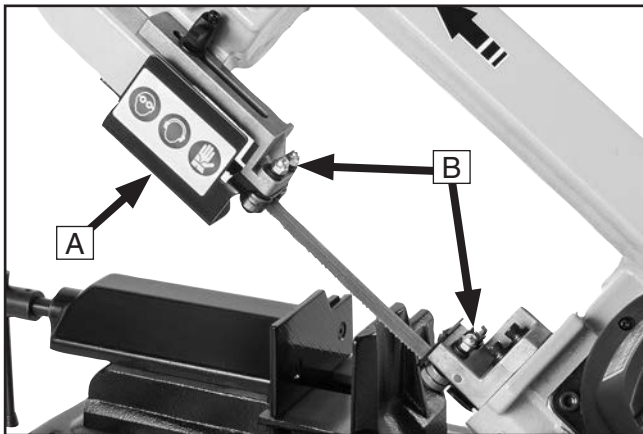


Figure 1. Blade guard & blade guide bearing assemblies.

- A. Blade Guard:** Guard covers unused part of blade to minimize operator exposure to blade.
- B. Blade Guide Bearing Assemblies:** Keeps the cut perpendicular to the cutting surface. There are two assemblies—a left and a right assembly. The blade guide lock handle secures the left-hand blade guides in position.

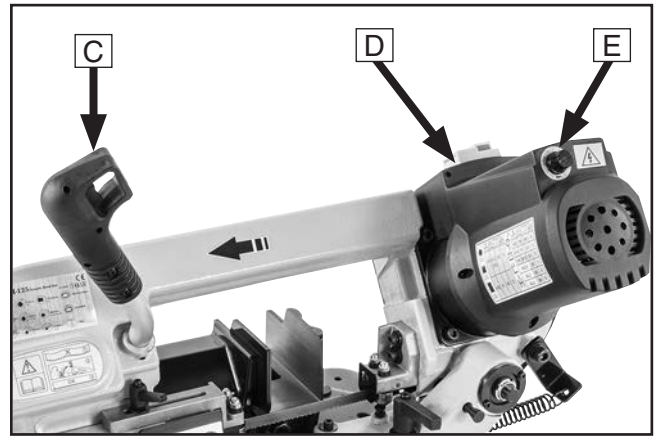


Figure 2. Power and speed controls.

- C. Trigger Switch:** Power switch must be turned **ON** and the trigger must be pulled to move blade.
- D. Power Switch:** Supplies power to the bandsaw.
- E. Variable-Speed Blade Dial:** Adjusts blade speed from 100-260 FPM.

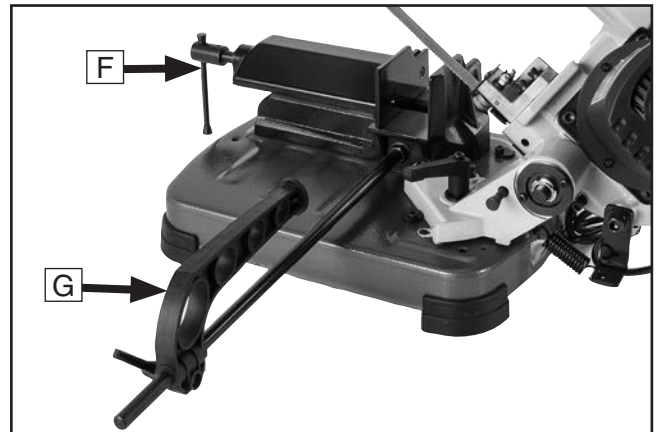


Figure 3. Vise components.

- F. Vise:** Secures workpiece material in position for cutting operation.
- G. Work Stop:** Positions for repeatable cuts. The work stop lock handle secures work stop position.





MACHINE DATA SHEET

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

MODEL G0885 5" PORTABLE METAL CUTTING BANDSAW

Product Dimensions:

Weight..... 44 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 27 x 25 x 26 in.
 Footprint (Length x Width)..... 12-1/2 x 16 in.

Shipping Dimensions:

Type..... Cardboard Box
 Content..... Machine
 Weight..... 51 lbs.
 Length x Width x Height..... 29 x 15 x 18 in.
 Must Ship Upright..... Yes

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
 Full-Load Current Rating..... 5A
 Minimum Circuit Size..... 15A
 Connection Type..... Cord & Plug
 Power Cord Included..... Yes
 Power Cord Length..... 6 ft.
 Power Cord Gauge..... 18 AWG
 Included Plug Type..... 5-15
 Switch Type..... On/Off Push Button

Motors:

Main

Horsepower..... 1/2 HP
 Phase..... Single-Phase
 Amps..... 5A
 Speed..... 2000 - 4200 RPM
 Type..... Universal
 Power Transfer Direct
 Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Info

Blade Speeds..... 100 - 260 FPM
 Std. Blade Length..... 56-1/2 in.
 Blade Length Range..... 1/2 in.

Cutting Capacities


Angle Cuts..... 0 - 60 deg.
 Vise Jaw Depth..... 5 in.
 Vise Jaw Height..... 2-3/4 in.
 Max. Capacity Rectangular Height at 90 Deg..... 4-3/4 in.
 Max. Capacity Rectangular Width at 90 Deg..... 5 in.
 Max. Capacity Round at 90 Deg..... 4-3/4 in.




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 Metal Bandsaws

WARNING

Serious injury or death can occur from getting fingers, hair, or clothing entangled in rotating or moving parts or making direct contact with the moving blade. To minimize risk of injury, anyone operating this machine **MUST** completely heed hazards and warnings below.

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

HAND PLACEMENT. Never position hands or fingers in line with the cut or under bandsaw head-stock while lowering or operating. Hands could be cut or crushed.

BLADE GUARD POSITION. Adjust blade guard as close to workpiece as possible before cutting to minimize operator exposure to unused portion of blade.

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

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

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

WORKPIECE HANDLING. Always properly support workpiece with table, vise, or some type of support fixture. Always secure workpiece in vise before cutting. Never hold the workpiece with your hands during a cut.

UNSTABLE WORKPIECES. Avoid cutting workpieces that cannot be properly supported or clamped in a vise or jig, because they can unexpectedly move while cutting and draw the operator's hands into the blade causing serious personal injury. Examples are chains, cables, round or oblong-shaped workpieces, and those with internal or built-in moving or rotating parts, etc.

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

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

WARNING

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

CAUTION

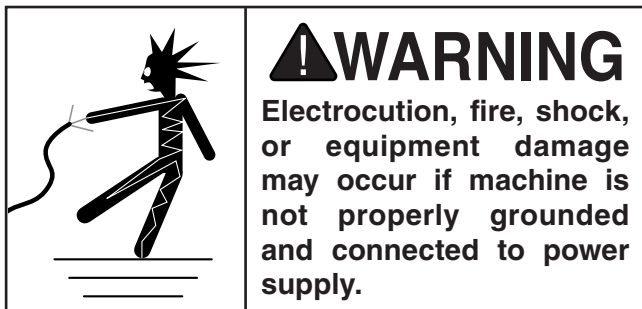
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: 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 120V 5 Amps

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

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

! 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.

120V 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 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps

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

! CAUTION

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

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



Grounding & Plug 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!

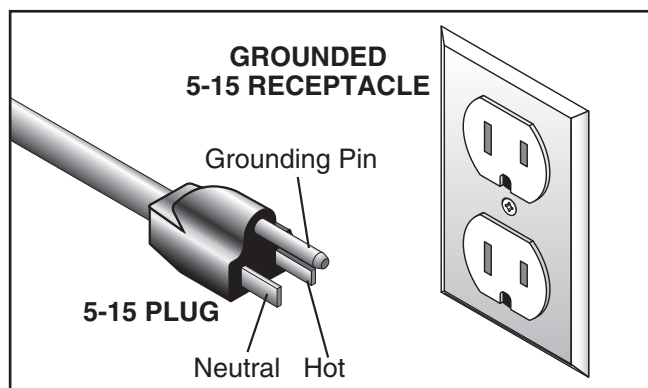


Figure 4. Typical 5-15 plug and receptacle.

⚠ CAUTION

SHOCK HAZARD!

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

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 16 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.*

Needed for Setup

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

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed

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 5)	Qty
A. Bandsaw (not shown)	1
B. Base Feet (4)	4
C. Work Stop Rod with Hex Nut	1
D. Work Stop.....	1
E. Work Stop Hardware Bag.....	1
—Adjustable Handle.....	1
—Hex Bolt M6-1	1

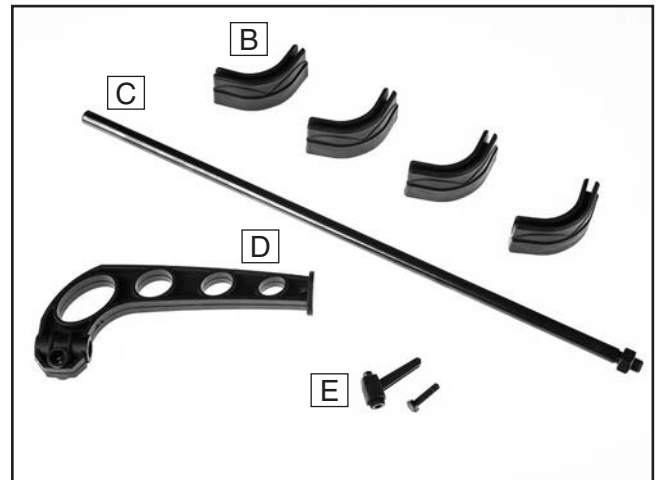


Figure 5. Loose inventory.

NOTICE

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



Cleanup

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

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

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

Before cleaning, gather the following:

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

Basic steps for removing rust preventative:

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

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

Site Considerations

Workbench Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support the weight of the machine and workpiece materials.

Placement Location

Consider anticipated workpiece sizes and additional space needed for auxiliary stands, work tables, or other machinery when establishing a location for this machine in the shop. Below is the minimum amount of space needed for the machine.

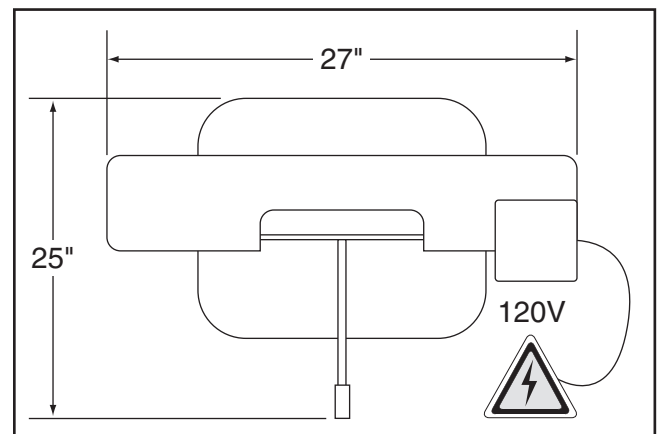


Figure 6. Minimum working clearances.

	<h2>CAUTION</h2> <p>Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
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Bench Mounting

Number of Mounting Holes 3
Diameter of Mounting Hardware Needed .. 1/4"

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

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

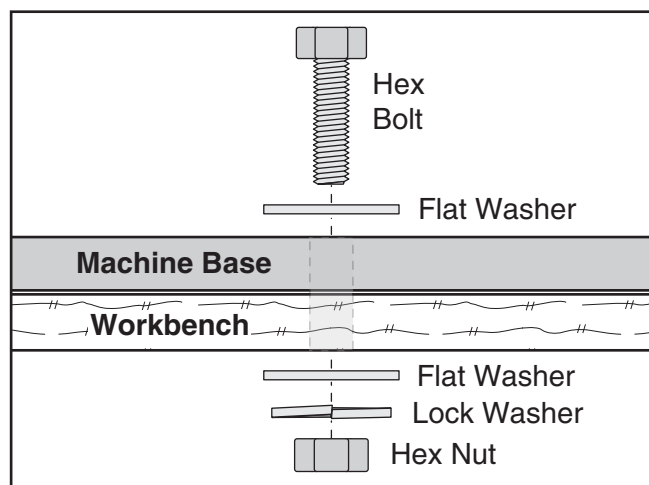


Figure 7. "Through Mount" setup.

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

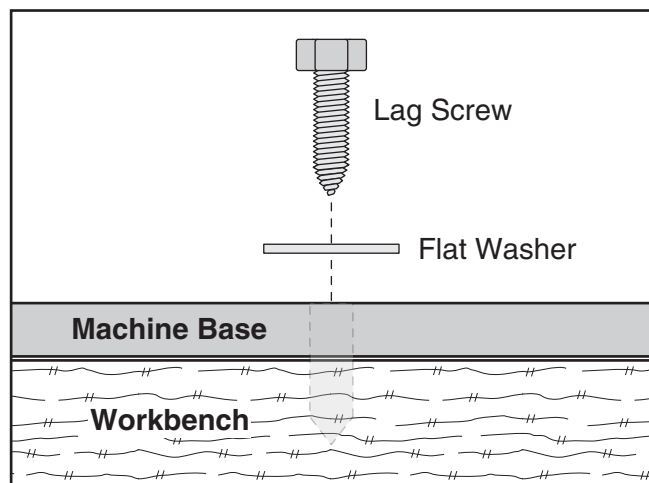


Figure 8. "Direct Mount" setup.

Assembly

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

The G0885 work stop and base feet are the only components requiring assembly.

To assemble machine:

1. Thread work stop rod with hex nut into vise base (see **Figure 9**).
2. Slide work stop onto work stop rod (see **Figure 9**).
3. Insert hex bolt into work stop and thread work stop lock handle onto hex bolt (see **Figure 9**).

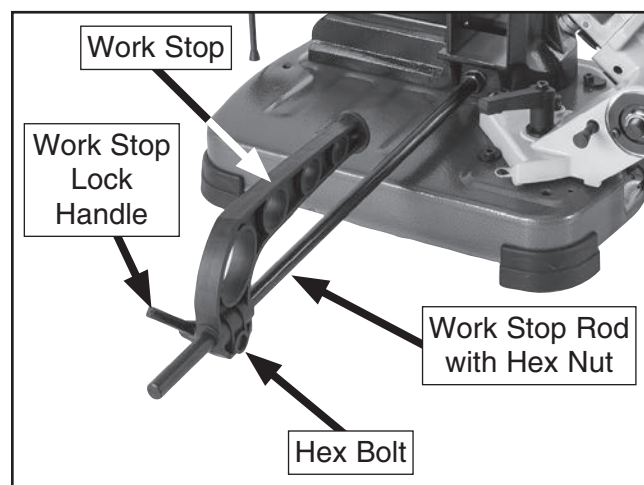


Figure 9. Work stop installed.



4. Install (1) base foot onto each base corner (see **Figure 10**).



Figure 10. Installing base foot.

Test Run

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

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

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the blade guide bearings are functioning properly.

!WARNING

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

!WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Put on safety glasses and secure loose clothing or long hair.
3. Turn variable-speed blade dial counterclockwise to its lowest setting, 1.
4. Remove headstock locking pin and raise headstock all the way up.
5. Connect machine to power supply.
6. Turn machine **ON**, pull trigger switch to verify motor operation, and then let go of trigger switch and turn machine **OFF**.

The motor should run smoothly and without unusual problems or noises.

The guide bearings should spin freely and without unusual problems or noises.





SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

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

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

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

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

1. Examines workpiece to make sure it is suitable for cutting.
2. Raises headstock all the way.
3. Adjusts vise angle, then securely clamps workpiece in vise.
4. Adjusts upper blade guide assembly as close to workpiece as possible.
5. Verifies blade is properly tensioned.
6. Adjusts variable-speed dial to ensure correct cutting speed for workpiece.
7. Makes sure workpiece and machine are stable and that there are no obstructions in the way of cut.
8. Puts on safety glasses and respirator.
9. Presses green button on ON/OFF switch to turn machine **ON**.
10. Starts blade by pulling trigger switch and waits for blade to reach full speed.
11. Slowly lowers blade into workpiece until cut is finished.
12. Stops blade by releasing trigger switch.
13. Presses red button on ON/OFF switch to turn machine **OFF**.
14. Raises headstock and removes workpiece.



Blade Selection

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

Blade Terminology

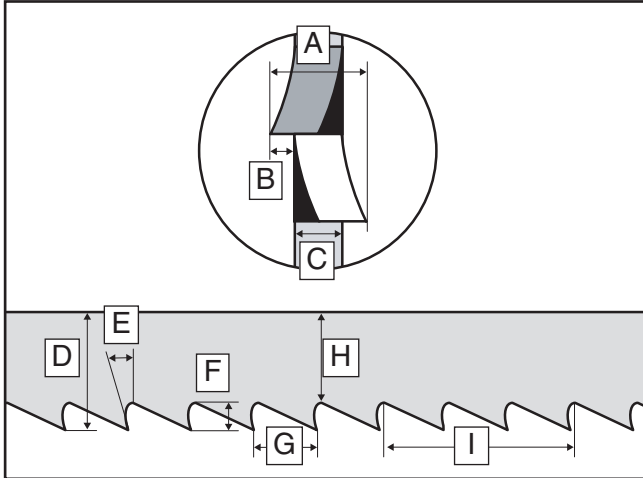


Figure 11. Bandsaw blade terminology.

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

Blade Length

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

Model	Blade Length
G0885.....	56½"

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point).

Model	Blade Width
G0885.....	1½"

Tooth Type

The most common tooth types are described as follows, and illustrated in Figure 12.

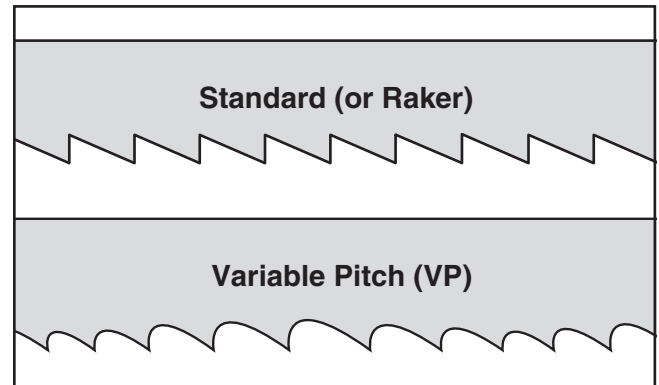


Figure 12. Bandsaw blade tooth types.

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

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



Blade Pitch (TPI)

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

To select correct blade pitch:

1. Measure material thickness. This measurement is distance from where each tooth enters workpiece to where it exits workpiece.
2. Refer to "Material Width/Diameter" row of blade selection chart in **Figure 13**, and read across to find workpiece thickness you need to cut.

3. Refer to "Material Shapes" row and find shape of material to be cut.
4. In applicable row, read across to right and find box where row and column intersect. Listed in the box is minimum TPI recommended for variable tooth pitch blades.

The TPI range is represented by a "/" between numbers. For example, 3/4 TPI is the same as 3–4 TPI.

The "Cutting Speed Rate Recommendation" chart, which is located on the machine just below the Blade Pitch Chart, offers guidelines for various metals, given in feet per minute (FPM). Refer to **Blade Speed Chart** section on **Page 21** for further details.

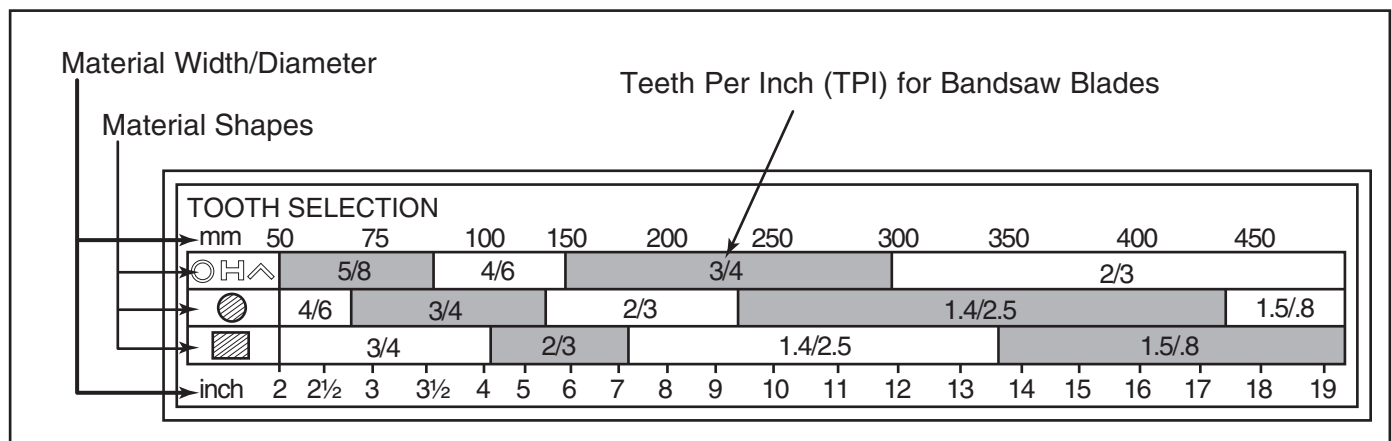



Figure 13. General guidelines for blade selection and speed chart.



Changing Blade



⚠ CAUTION

All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling and uncoiling saw blades.

Items Needed	Qty
Leather Gloves	1 Pair

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

To change blade on bandsaw:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock all the way.
3. Remove six wheel cover screws (see **Figure 14**).

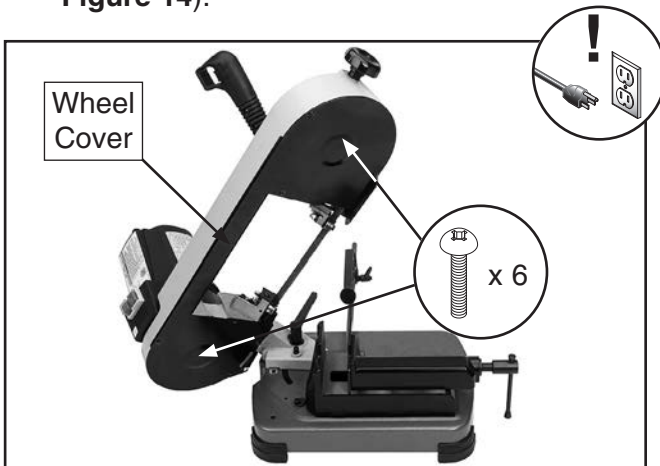


Figure 14. Location of rear wheel cover.

4. Move blade guard all the way to left.
5. Clean chips and shavings with brush/vacuum.
6. Loosen blade tension knob.
7. Slip blade off wheels, then out from between blade guide bearings (see **Figure 15**).

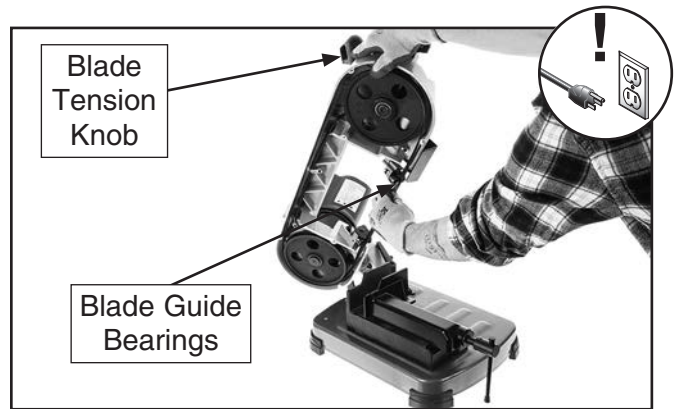


Figure 15. Headstock opened for blade removal.

8. Install new blade between left and right blade guide bearings, as shown in **Figure 15**.

Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth face the same direction as blade travel, as shown in **Figure 16**, after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

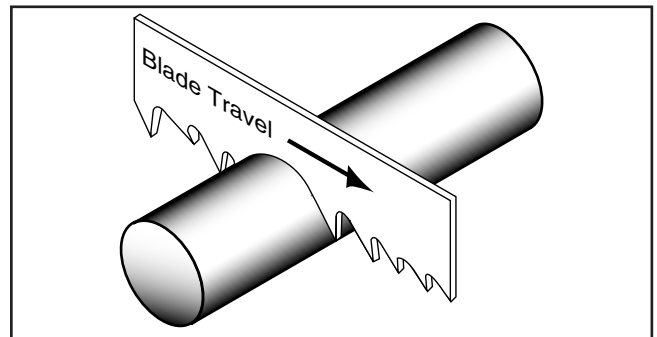


Figure 16. Example of blade cutting direction.

9. Work your way around blade to adjust position so back of blade is against shoulder of wheels, as shown in **Figure 17**.

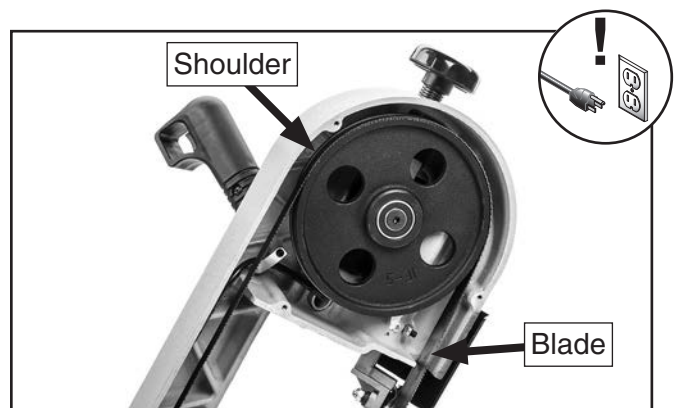


Figure 17. Blade against wheel shoulder.



10. Complete blade change using the **Tensioning Blade** procedure below.
11. Re-install wheel cover.
12. Reposition blade guard and left blade guide bearing assembly.

Tensioning Blade

Proper blade tension is essential to avoid blade vibration, twist, or slippage on the wheels. A correctly tensioned blade provides long blade life, straight cuts, and efficient cutting times.

The three major signs of incorrect blade tension are: 1) The blade stalls in the cut and slips on the wheels, 2) the blade frequently breaks, and 3) the bandsaw does not make straight cuts.

To tension bandsaw blade:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen and slide blade guard and blade guide bearing assemblies (see **Figure 18**) as far left as they will go, then secure.
3. Turn tension knob shown in **Figure 18** clockwise to tighten blade or counterclockwise to loosen blade.

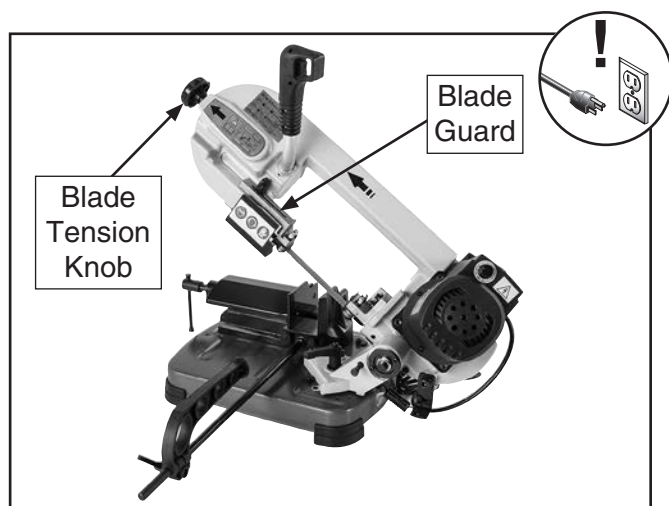


Figure 18. Location of left blade guide arm.

4. Adjust blade tension knob clockwise until there is no deflection. Do not over tighten.

Blade Breakage

Many conditions may cause a bandsaw blade to break. Some of these conditions are unavoidable and are the natural result of the stresses placed on the bandsaw; other causes of blade breakage are avoidable.

The most common causes of avoidable blade breakage are:

- Faulty alignment or adjustment of the blade guides.
- Feeding blade through the workpiece too fast.
- Dull or damaged teeth.
- Improperly-tensioned blade.
- Left blade-guide assembly set too high above the workpiece. Adjust left blade-guide bearing assembly as close to workpiece as possible.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running motor without cutting anything.
- Leaving the blade tensioned when not in use.
- Using the wrong blade pitch (TPI) for the workpiece thickness. The general rule of thumb is to have no fewer than three teeth in contact with the workpiece when starting a cut and at all times during cutting.



Blade Care & Break-In

Blade Care

To prolong blade life, always use a blade with the proper width, set, type, and pitch for each application. Maintain the appropriate feed rate, feed pressure, and blade speed, and pay attention to the chip characteristics (Refer to **Blade Speed Chart** on **Page 21** and **Chip Inspection Chart** on **Page 22**). Keep your blades clean, since dirty or gummed up blades pass through the cutting material with much more resistance than clean blades, causing unnecessary heat.

Blade Break-In

The tips and edges of a new blade are extremely sharp. Cutting at too fast of a feed rate or too slow of a blade speed can fracture these tips and edges, quickly dulling the blade. Properly breaking in a blade allows these sharp edges to wear without fracturing, thus keeping the blade sharp longer. Below is a typical break in procedure. For aftermarket blades, refer to the manufacturer's break-in procedure to keep from voiding the warranty.

Use the **Chip Inspection Chart** on **Page 22** as a guide to evaluate the chips and ensure that the optimal blade speed and feed rate are being used.

To properly break in new blade:

1. Choose correct speed for blade and material of operation (refer to **Blade Speed Chart** on **Page 21**).
2. Reduce feed pressure by half for first 50–100 in² of material cut.
3. To avoid twisting blade when cutting, adjust feed pressure when total width of blade is in cut.

Blade Speed

The Model G0885 is variable-speed. The speed ranges from 100-260 (FPM). Refer to the chart on **Page 21** for cutting speed recommendations by material type.

During operation, pay attention to the chips being produced from the cut and compare them to the **Chip Inspection Chart** on **Page 22** to properly set the feed rate.

To change blade speed:

1. Turn variable-speed dial counter-clockwise to decrease blade speed.
2. Turn variable-speed dial clockwise to increase blade speed.

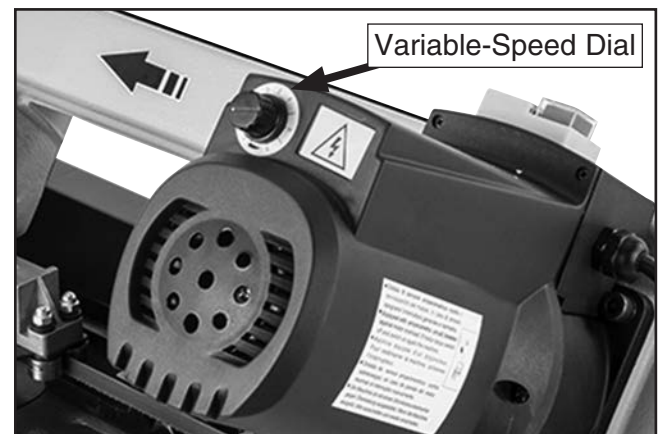


Figure 19. Location of variable-speed dial.



Blade Speed Chart

The chart in **Figure 20** offers blade speed guidelines for various metals, given in feet per minute (FPM) and meters per minute (M/Min). Choose the closest available speed on the machine, then adjust the feed rate as necessary, using the appearance of the chips produced as a guide. Refer to the **Chip Inspection Chart** that follows for recommendations on adjusting feed rate or blade speed based on the appearance of the chips produced.

Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)
Carbon Steel	196~354 (60) (108)	Tool Steel	203 (62)	Alloy Steel	111~321 (34) (98)	Free Machining Stainless Steel	150~203 (46) (62)
Angle Steel	180~220 (54) (67)	High-Speed Tool Steel	75~118 (25) (36)	Mold Steel	246 (75)	Gray Cast Iron	108~225 (33) (75)
Thin Tube	180~220 (54) (67)	Cold-Work Tool Steel	95~213 (29) (65)	Water Hardened Tool Steel	242 (74)	Ductile Austenitic Cast Iron	65~85 (20) (26)
Aluminum Alloy	220~534 (67) (163)	Hot-Work Tool Steel	203 (62)	Stainless Steel	85 (26)	Malleable Cast Iron	321 (98)
Copper Alloy	229~482 (70) (147)	Oil-Hardened Tool Steel	203~213 (62) (65)	CR Stainless Steel	85~203 (26) (62)	Plastics & Lumber	220 (67)

Figure 20. Dry cutting blade speed chart.



Chip Inspection Chart

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









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

Figure 21. Chip inspection chart.



Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by the blade type and feed rate. The feed rate is controlled by how hard the user pulls the saw down into the material.

The feed rate should be proportional to the speed of the saw. Allow the blade to remove chips as it cuts through the material. Here are some signs that the feed rate is too fast.

- Saw binding in cut and motor slows down.
- Saw blade flexing as it moves through cut.

Work Stop

The Model G0885 is equipped with a work stop that can be used to quickly position the workpiece during a repetitive cutting operation. Adjust the work stop as needed, then tighten the lock handle to secure it in place, as shown in **Figure 22**.



Figure 22. Setting work stop to support repetitive cutting operation.

Vise

⚠ CAUTION

Always turn saw **OFF** and allow blade to come to complete stop before adjusting vise! Failure to follow this caution may lead to injury.

The vise allows the jaw width to be adjusted up to 5" wide.

Using Vise

1. Turn vise handle (see **Figure 23**) counter-clockwise to relieve any pressure on vise jaws.

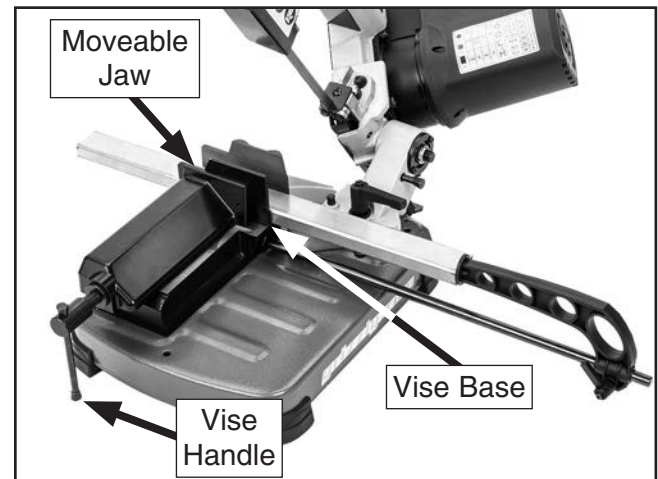


Figure 23. Location of vise components.

2. Place workpiece flat on the vise table.
3. Finish tightening movable jaw against workpiece with vise handle.

Note: *Figure 24 on Page 24 shows correct methods of holding different workpiece shapes.*



Operation Tips

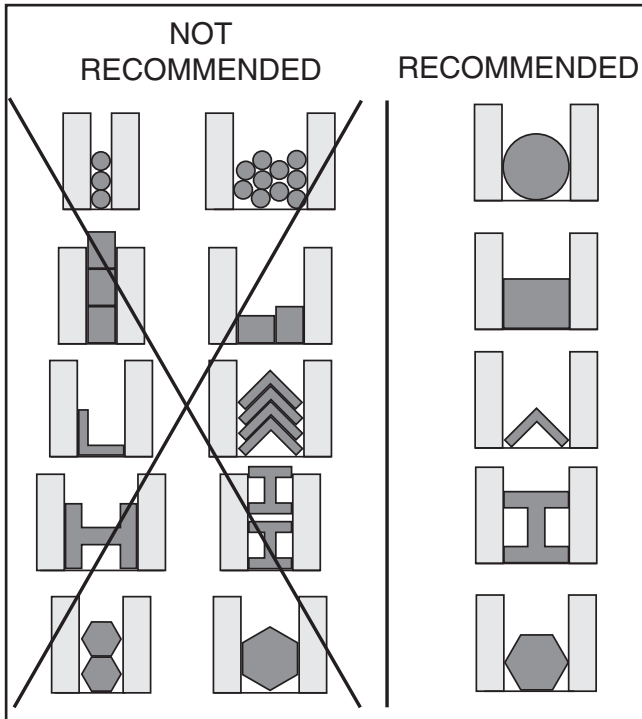


Figure 24. Example of work holding options by material shape.

Headstock Angle

Before adjusting headstock, verify workpiece is held firmly in place by the vise. The headstock can be adjusted to cut any angle, from a straight 90-degree cut-off to a 60-degree angle, by loosening the angle lock handle. Angles between 90° and 60° can be read using the scale on top of the saw base. Use a combination square or bevel protractor if higher precision is required when finding these angles (see **Figure 25**).

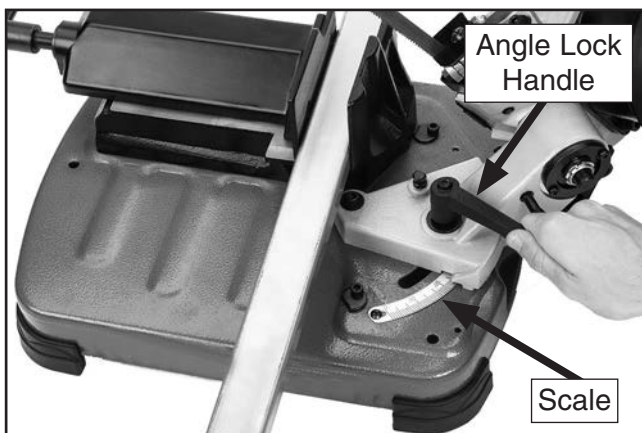


Figure 25. Example of headstock angle adjustment.

The following tips will help you safely and effectively operate your bandsaw and get the maximum life out of your saw blades.

Tips for cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material.
- Let the blade reach full speed before engaging the workpiece. Never start a cut while the blade is in contact with the workpiece, and do not start a cut on the sharp edge of a workpiece.
- Chips should be curled and silvery. If the chips are thin and powder-like, increase your feed rate.
- Burned chips indicate a need to reduce your blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut, and flag the ends to alert passers-by of potential danger.
- Adjust the blade guide assemblies as close as possible to the workpiece to minimize side-to-side blade movement.

NOTICE

Loosen blade tension at the end of each day to prolong blade life.



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.

Bi-Metal Blades

- T31609—56½ x ½ x .025 10-14 VP Bi-Metal
- T31610—56½ x ½ x .025 14-18 VP Bi-Metal
- T31611—56½ x ½ x .025 20-24 VP Bi-Metal
- T31612—56½ x ½ x .025 14 TPI Raker
- T31613—56½ x ½ x .025 18 TPI Raker
- T31614—56½ x ½ x .025 24 TPI Raker



Figure 26. Typical variable pitch bi-metal cutting blade.

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. Eye protection assortment.

D2056—Tool Table

Get that bench-top tool off your bench and put it on this sturdy Shop Fox® stand instead! Flared legs and adjustable rubber feet ensure stability and reduce machine vibration. Butcher block finish table top measures 1" x 13" x 23" and is 30½" from the floor. Bottom measures 21" x 32". 700 lb. Capacity!

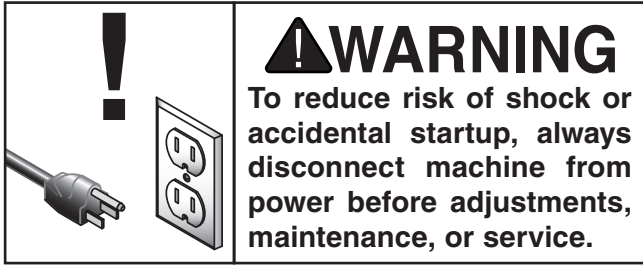


Figure 28. D2056 Tool Table.

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SECTION 6: MAINTENANCE



Schedule

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

Ongoing

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

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

Monthly Check

- Check blade guide bearing assemblies for damage or wear.
- Remove blade and clean all surfaces.

Cleaning & Protecting

Cleaning the Model G0885 is relatively easy. Use a chip brush and vacuum excess metal chips and other debris. Wipe off the remaining metal dust with a dry cloth.

Periodically, remove the blade and thoroughly clean all metal chips or built-up grease from the wheel surfaces and blade housing.

Protect the unpainted vise base surface by wiping it clean after every use.

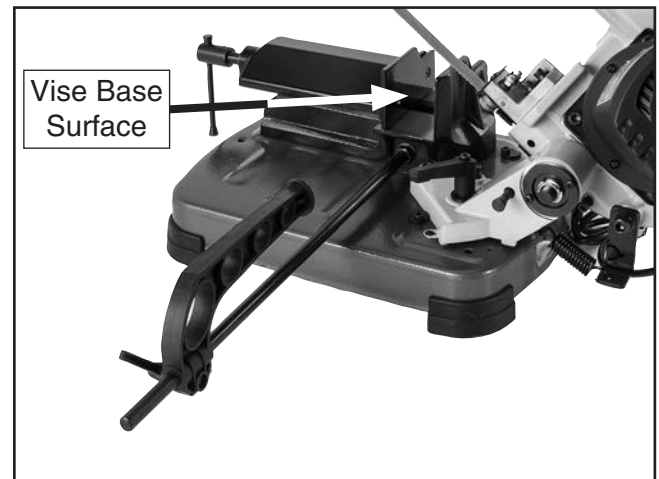


Figure 29. Location of vise base surface.

Lubrication

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



Replacing Motor Brushes

The motor brushes wear with use. When they require replacement, the motor will stop operating correctly, fail to start, or cut in and out during operation. Always replace both brushes at the same time.

Item(s) Needed	Qty
Flat Head Screwdriver	1
Phillips Head Screwdriver #1	1
Phillips Head Screwdriver #2	1

To inspect/replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Take off motor cover by removing 5 screws (see **Figure 30**).

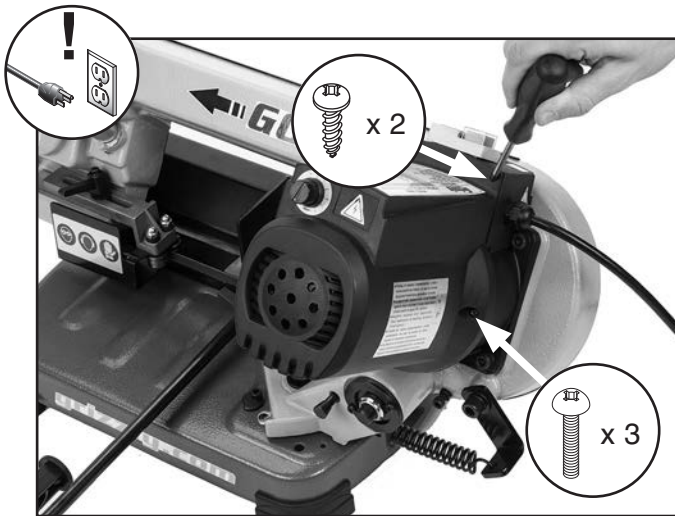


Figure 30. Removing motor cover.

3. Remove upper and lower motor brush caps and motor brushes, as shown in **Figure 31**.

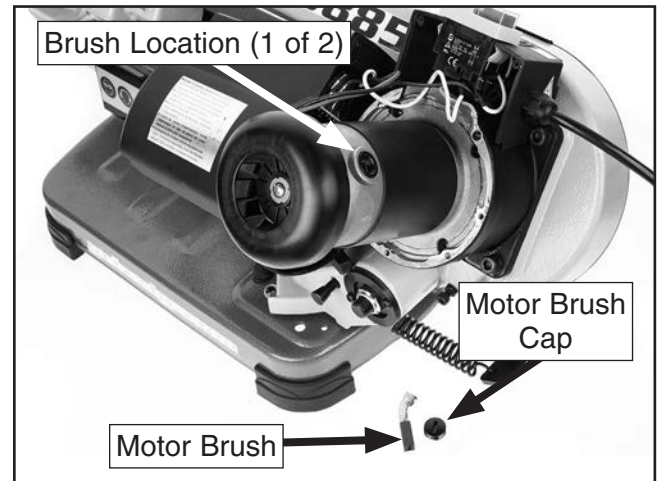


Figure 31. Motor brush cap location.

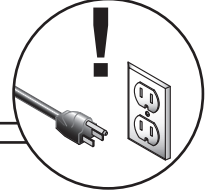
4. Replace brushes (2) and re-install brush caps.
5. Re-attach motor cover and secure with screws.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. Incorrect power supply voltage or circuit size. 2. Power supply circuit breaker tripped or fuse blown. 3. Wiring broken, disconnected, or corroded. 4. Potentiometer/variable-speed dial at fault. 5. ON button at fault. 6. Motor brushes at fault. 7. Motor 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. Fix broken wires or disconnected/corroded connections. 4. Test/replace. 5. Replace switch. 6. Replace motor brushes (Page 27). 7. Test/repair/replace.
Machine stalls or underpowered.	<ol style="list-style-type: none"> 1. Feed rate too fast; blade speed too low. 2. Machine undersized for task. 3. Blade too course for material being cut. 4. Blade slipping on wheels. 5. Motor overheated. 6. Motor at fault. 	<ol style="list-style-type: none"> 1. Reduce feed rate/pressure; increase blade speed. 2. Use correct/sharp blade; reduce feed rate/pressure. Correct blade cut alignment to eliminate binding. 3. Use correct blade for operation (Page 16). 4. Adjust blade tension (Page 19). 5. Clean motor, let cool, reduce workload, or replace brushes (Page 27). 6. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Saw component loose. 2. Blade at fault. 3. Motor is noisy. 	<ol style="list-style-type: none"> 1. Retighten/replace damaged bolts/nuts. 2. Replace/resharpen blade. 3. Replace brushes (Page 27).



Operation

Symptom	Possible Cause	Possible Solution
Vibration when operating or cutting.	<ol style="list-style-type: none"> 1. Loose or damaged blade. 2. Bandsaw wheels have contaminants loaded up on wheel surface. 3. Bent, damaged or dull blade. 4. Machine component loose. 5. Worn wheel bearing. 6. Wheel bent/worn. 	<ol style="list-style-type: none"> 1. Tighten or replace blade (Pages 18-19). 2. Remove blade; clean bandsaw wheels. 3. Replace blade (Page 18). 4. Fix/replace fan cover; replace loose/damaged fan. 5. Check/replace wheel bearing. 6. Check/replace wheel and wheel bearing.
Ticking sound when saw is running.	<ol style="list-style-type: none"> 1. Blade missing teeth. 2. Blade weld contacting blade guides. 3. Blade weld may be failing. 	<ol style="list-style-type: none"> 1. Replace blade (Page 18). 2. Replace blade if excessive ticking. 3. Cut and reweld blade, or replace blade (Page 18).
Machine or blade bogs down in cut.	<ol style="list-style-type: none"> 1. Feed rate too fast; blade speed too low. 2. Blade tension too low. 3. Blade gullets loading up with chips. 4. Blade dull, wanders, or gets pinched in cut. 5. Blade TPI too coarse. 	<ol style="list-style-type: none"> 1. Reduce feed rate (Page 23); increase blade speed (Page 21). 2. Increase blade tension (Page 19). 3. Install blade with more suitable TPI or tooth style for cooler cuts (Page 17). 4. Replace blade (Page 18) or replace guide bearings (Page 30). 5. Use blade with at least 2 teeth contacting material at all times (Page 17).
Cuts are not square, or the intended angle is incorrect.	<ol style="list-style-type: none"> 1. Loose angle adjustable handle or vise crank. 2. Blade not square to table. 	<ol style="list-style-type: none"> 1. Tighten loose angle adjustable handle or vise crank (Page 23). 2. Adjust blade square to table (Page 31).
Blade dulls prematurely, or metal sticking to the blade.	<ol style="list-style-type: none"> 1. Incorrect feed/speed. 2. Blade gullets loading up with chips. 3. Blade improperly broken in. 	<ol style="list-style-type: none"> 1. Adjust feed rate (Page 23) or blade speed (Page 21). 2. Use blade with larger gullets/fewer TPI (Page 17). 3. Replace blade (Page 18); complete blade break in procedure (Page 20).
Blade wears on one side or shows overheating.	<ol style="list-style-type: none"> 1. Blade guides worn or misadjusted. 2. Blade support inadequate. 3. Dull/incorrect blade. 	<ol style="list-style-type: none"> 1. Re-adjust (Page 18)/replace. 2. Tighten blade guide close to workpiece as possible. 3. Replace blade (Page 18).
Blade tracks incorrectly, or comes off wheels.	<ol style="list-style-type: none"> 1. Feed rate too fast/wrong TPI. 2. Blade tension too low. 3. Blade bell-mouthed. 4. Blade guide bearings need adjustment. 5. Metal chip buildup on wheels. 	<ol style="list-style-type: none"> 1. Reduce feed rate/pressure (Page 23); decrease blade TPI (Page 17). 2. Increase blade tension (Page 19). 3. Install new blade (Page 18); regularly remove tension from blade when not in use (Page 19). 4. Adjust blade guide bearings (Page 30) 5. Clean metal chips from wheels.
Cuts are crooked.	<ol style="list-style-type: none"> 1. Feed rate too fast; blade speed too low. 2. Guide bearings assembly too far from workpiece. 3. Blade tension too low. 4. Blade dull. 5. Headstock is loose. Headstock pivot bolt/bushings loose or worn. 	<ol style="list-style-type: none"> 1. Reduce feed rate (Page 23); increase blade speed (Page 21). 2. Re-adjust (Page 18). 3. Increase blade tension (Page 19). 4. Replace blade (Page 18). 5. Remove/clean/lubricate/readjust bushing/bolt/nut.



Adjusting Guide Bearings

The guide bearings come adjusted from the factory, but due to blade changes, shipping, storage, and time they may need adjustment. Uneven blade wear and crooked cuts may be the result of improper adjustment.

Tools Needed	Qty
Open-End Wrench 10mm.....	2
Feeler Gauge (Optional)	1

To adjust guide bearings:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure blade is properly tensioned (refer to **Tensioning Blade** on **Page 19**).
3. Raise headstock all the way.
4. On left guide bearing assembly, loosen acorn nut on front eccentric shaft (see **Figure 32**).
5. Turn eccentric shaft and adjust roller bearing (see **Figure 32**) so it lightly contacts blade or has maximum clearance of 0.002".

Note: *Since bearings twist blade into position, it is acceptable if there is 0.001"-0.002" gap between blade and front or back of bearing. Just make sure not to squeeze blade too tightly with bearings. After guide bearings are set, you should be able to rotate guide bearings (although they will be stiff) with your fingers.*

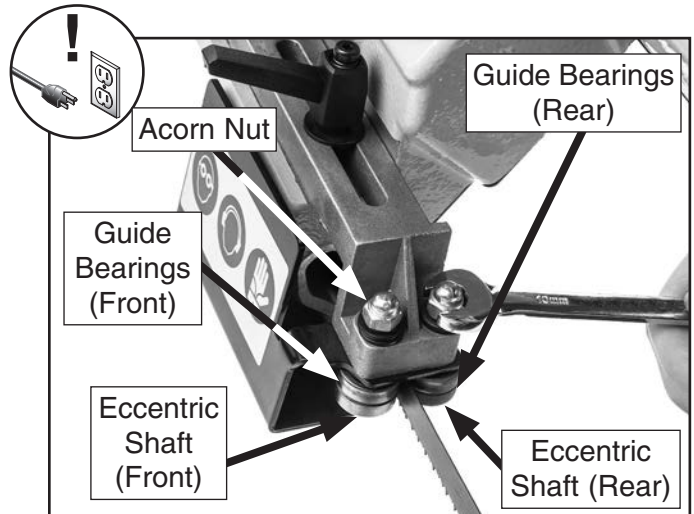


Figure 32. Location of guide bearings.

6. While holding eccentric shaft in place, tighten acorn nut to secure setting.
7. Repeat Steps 4–6 on rear eccentric shaft.
8. Repeat **Steps 4–7** on right guide bearing assembly.



Squaring Blade to Table

This setting has been made at the factory and should not need to be adjusted under normal circumstances. However, if you find the saw is not cutting square, you may need to adjust the blade. Only make this adjustment after ruling out other potential factors, such as excessive feed rate or the blade guide bearing assembly and blade guard being set too far away from the workpiece.

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

To square blade to table:

1. DISCONNECT MACHINE FROM POWER!
2. Lower headstock until it is slightly above vise base surface.
3. Place square on vise base surface and against edge of blade (see **Figure 33**), and check different points along length of base surface between blade guide assemblies.

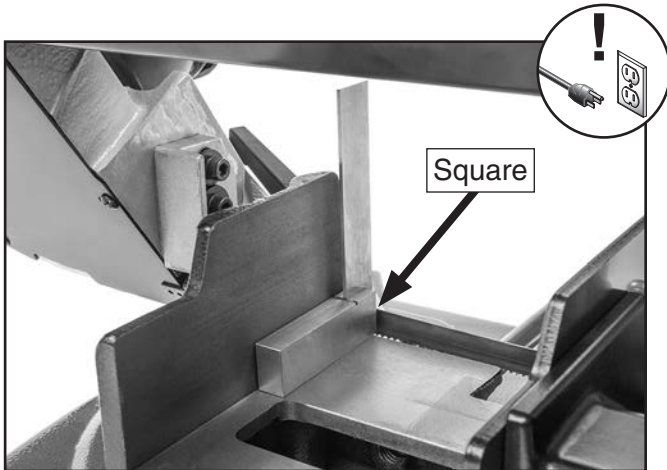


Figure 33. Checking blade-to-table squareness.

- If blade *is* square to table, no further adjustments need to be made.
- If blade *is not* square to table, loosen cap screws (2) shown in **Figure 34** one to two turns on right guide bearing assembly.

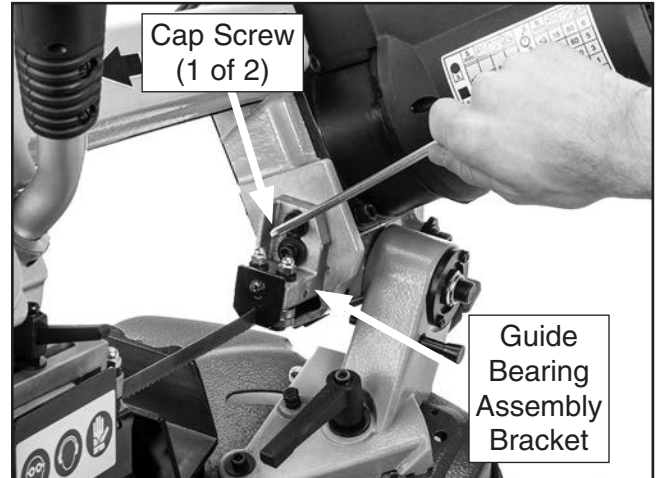


Figure 34. Cap screws for adjusting blade-to-table squareness.

4. Tilt guide bearing assembly bracket left or right until it is square with vise base surface.
5. Tighten cap screws loosened earlier.
6. Repeat **Step 3** and adjustments above as necessary until blade is perfectly square to table.

Tip: *Cut small section from scrap piece of material with known square end and measure for uniform thickness. If thickness is not uniform, repeat adjustments above until your personal requirements are met.*



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.


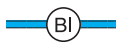
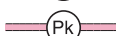







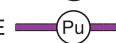

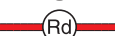
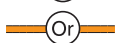
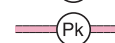
CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

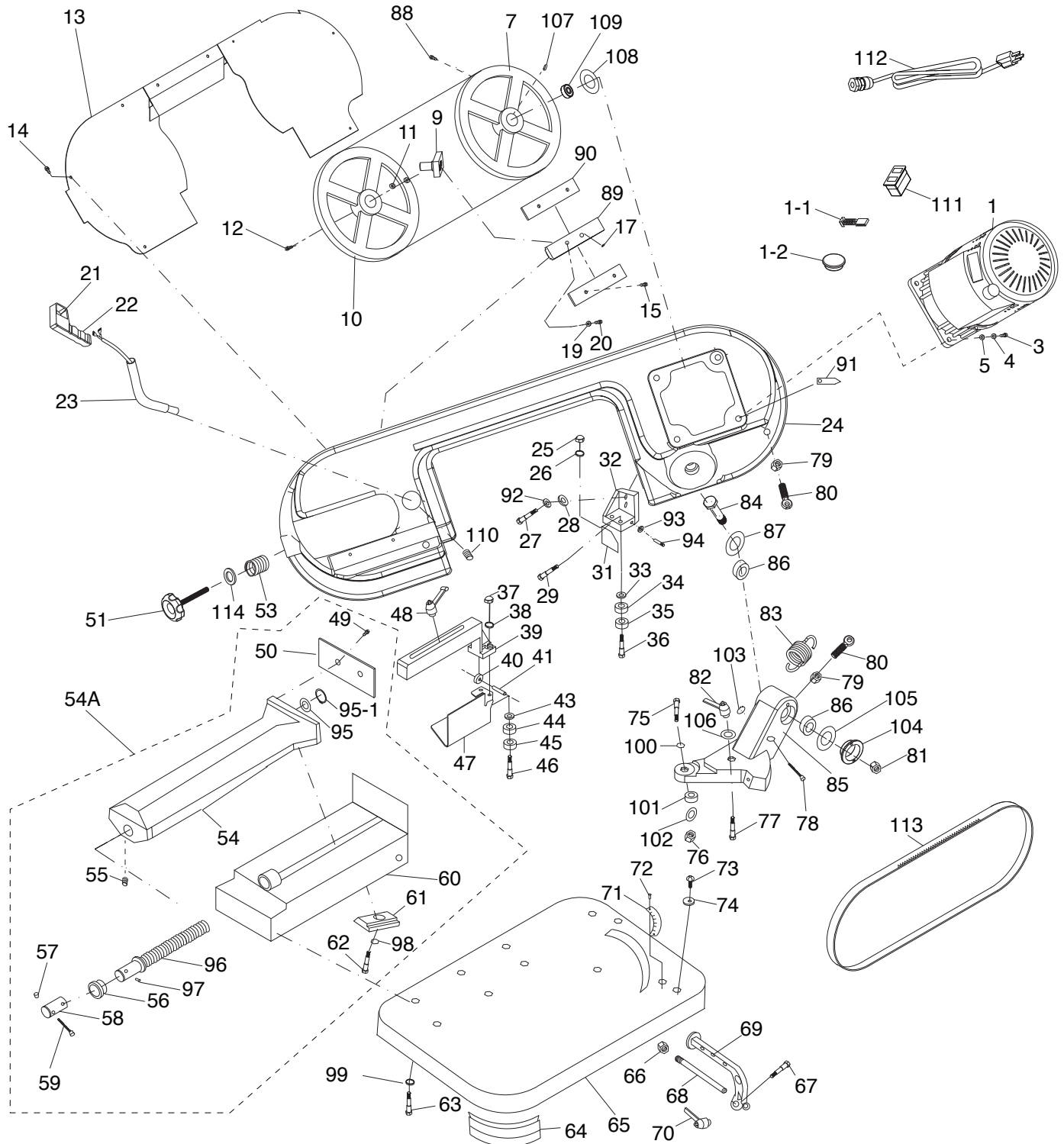
BLACK		BLUE		YELLOW		LIGHT BLUE	
WHITE		BROWN		YELLOW GREEN		BLUE WHITE	
GREEN		GRAY		PURPLE		TURQUOISE	
RED		ORANGE		PINK			



SECTION 9: PARTS

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

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0885001	MOTOR 1/2HP 120VDC
1-1	P0885001-1	MOTOR CARBON BRUSH 2-PC SET
1-2	P0885001-2	BRUSH CAP
3	P0885003	CAP SCREW M8-1.25 X 25
4	P0885004	LOCK WASHER 8MM
5	P0885005	FLAT WASHER 8MM
7	P0885007	DRIVE WHEEL
9	P0885009	IDLER SHAFT BLOCK
10	P0885010	IDLER WHEEL
11	P0885011	BALL BEARING 6202ZZ
12	P0885012	FLAT HD CAP SCR M8-1.25 X 16
13	P0885013	BLADE COVER
14	P0885014	PHLP HD SCR M4-.7 X 8
15	P0885015	CAP SCREW M5-.8 X 25
17	P0885017	SET SCREW M8-1.25 X 16
19	P0885019	LOCK WASHER 8MM
20	P0885020	CAP SCREW M8-1.25 X 25
21	P0885021	TRIGGER SWITCH TWCHT CMV100D 220V
22	P0885022	TRIGGER HOUSING
23	P0885023	TRIGGER HANDLE BAR
24	P0885024	BODY FRAME
25	P0885025	ACORN NUT M6-1
26	P0885026	LOCK WASHER 6MM
27	P0885027	CAP SCREW M6-1 X 25
28	P0885028	FENDER WASHER 6MM
29	P0885029	PHLP HD SCR M5-.8 X 8
31	P0885031	CHIP FENCE
32	P0885032	FIXED BLADE GUIDE BLOCK
33	P0885033	FLAT WASHER 6MM
34	P0885034	BALL BEARING 607-2RS
35	P0885035	BALL BEARING 607-2RS
36	P0885036	ECCENTRIC HEX BOLT M6-1 X 40
37	P0885037	ACORN NUT M6-1
38	P0885038	FLAT WASHER 6MM
39	P0885039	ADJUSTABLE BLADE GUIDE BLOCK
40	P0885040	BALL BEARING 625-2RS
41	P0885041	DOWEL PIN 5 X 24
43	P0885043	FLAT WASHER 6MM
44	P0885044	BALL BEARING 607-2RS
45	P0885045	BALL BEARING 607-2RS
46	P0885046	ECCENTRIC HEX BOLT M6-1 X 40
47	P0885047	BLADE GUARD
48	P0885048	ADJUSTABLE HANDLE M6-1, 42L
49	P0885049	FLAT HD CAP SCR M6-1 X 8
50	P0885050	WISE PLATE
51	P0885051	KNOB BOLT M10-1.5 X 80, 6-LOBE, D60
53	P0885053	SPRING WASHER 10MM
54	P0885054	WISE JAW
54A	P0885054A	WISE ASSEMBLY
55	P0885055	SET SCREW M4-.7 X 6
56	P0885056	BUSHING
57	P0885057	HANDLE ROD END M8-1, D13, TAPERED
58	P0885058	HANDLE HUB 25OD X 42L
59	P0885059	HANDLE ROD M8-1, 132L
60	P0885060	WISE BASE

REF	PART #	DESCRIPTION
61	P0885061	LEADSCREW GUIDE
62	P0885062	HEX BOLT M6-1 X 25
63	P0885063	CAP SCREW M8-1.25 X 16
64	P0885064	PLASTIC FOOT
65	P0885065	BASE
66	P0885066	HEX NUT M12-1.75
67	P0885067	HEX BOLT M6-1 X 25
68	P0885068	STUD-SE M12-1.75 X 500, 22
69	P0885069	WORK STOP
70	P0885070	ADJUSTABLE HANDLE M6-1, 42L
71	P0885071	MITER SCALE
72	P0885072	PHLP HD SCR M4-.7 X 8
73	P0885073	CAP SCREW M6-1 X 12
74	P0885074	CAM 6 X 21.5 X 3MM
75	P0885075	CAP SCREW M6-1 X 40
76	P0885076	HEX NUT M6-1
77	P0885077	CARRIAGE BOLT M10-1.5 X 35
78	P0885078	LOCKING PIN 8.5 X 78MM
79	P0885079	HEX NUT M10-1.5
80	P0885080	EYE BOLT 7MM, M10-1.5 X 25
81	P0885081	LOCK NUT M12-1.75
82	P0885082	ADJUSTABLE HANDLE M10-1.5, 84L
83	P0885083	EXTENSION SPRING 3 X 20 X 40
84	P0885084	HEX BOLT M12-1.75 X 75
85	P0885085	MITER PLATE BRACKET
86	P0885086	TAPERED ROLLER BEARING 30202
87	P0885087	LOCK WASHER 10MM
88	P0885088	FLAT HD CAP SCR M6-1 X 16
89	P0885089	BLADE TENSION SLIDE BLOCK
90	P0885090	BLADE TENSION SLIDE
91	P0885091	POINTER
92	P0885092	FLAT WASHER 6MM
93	P0885093	BALL BEARING 625-2RS
94	P0885094	DOWEL PIN 5 X 32
95	P0885095	FLAT WASHER 10MM
95-1	P0885095-1	EXT RETAINING RING 9MM
96	P0885096	WISE LEADSCREW
97	P0885097	ROLL PIN 5 X 25
98	P0885098	LOCK WASHER 6MM
99	P0885099	LOCK WASHER 8MM
100	P0885100	FENDER WASHER 6MM
101	P0885101	BUSHING
102	P0885102	FENDER WASHER 8MM
103	P0885103	E-CLIP 7MM
104	P0885104	BUSHING 12 X 28 X 2MM
105	P0885105	BEARING COVER
106	P0885106	FENDER WASHER 10MM
107	P0885107	KEY 4 X 4 X 18
108	P0885108	FENDER WASHER 6MM
109	P0885109	BALL BEARING 6202-2RS
110	P0885110	SET SCREW M6-1 X 8
111	P0885111	ON/OFF SWITCH KEDU KJD20-2 120V
112	P0885112	POWER CORD 18G 3W 72" 5-15P
113	P0885113	BLADE 56.5" X 1/2" X 0.025" 12-TPI RAKER
114	P0885114	SPACER 21ID x 23OD X 9L



Labels & Cosmetics



201

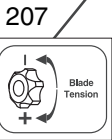


202



203

G0885



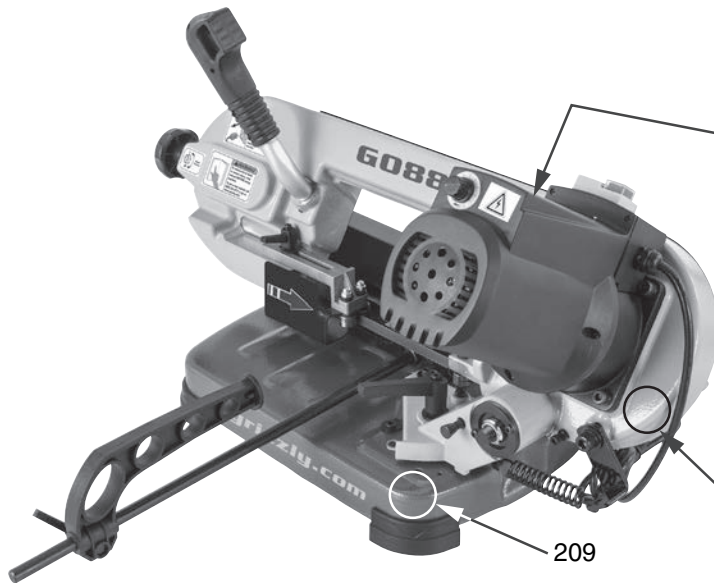
207



206

grizzly.com

204



205

Grizzly Industrial		MODEL G0885
Specifications		PORTABLE METAL-CUTTING BANDSAW
⚠ WARNING!		
Main Motor: 1/2 HP, 120V, 1-Ph, 60 Hz Full-Load Current Rating: 5A Blade Speeds: 100 – 260 FPM Blade Length: 56-1/2" Blade Size Range: 1/2" Max Round at 90°: 4-3/4" Max Rect. at 90°: 4-3/4" H x 5" W Angle Cuts: 0° – 60° Weight: 44 lbs.		To reduce risk of serious injury when using this machine: 1. Read and understand owner's manual before operating. 2. Never touch moving blade—keep hands out of blade path. 3. Always wear approved eye protection and respirator. 4. Only plug power cord into a grounded outlet. 5. Only remove jammed cutoff pieces when blade is stopped. 6. Disconnect power before changing blades or adjusting. 7. Maintain adjustment of blade tension, tracking, & guides. 8. Always ensure workpiece is securely clamped in vise during cutting operation. 9. Only run saw with wheel covers closed & all guards in place. 10. DO NOT wear loose clothing, gloves, jewelry, or other articles that can get entangled. Tie back long hair and roll up sleeves. 11. DO NOT expose to rain or use in wet locations. 12. Prevent unauthorized use by children or untrained users; restrict access or disable machine when unattended.
Date	MANUAL	
S/N	QR CODE	
Mfd. for Grizzly in Taiwan		grizzly.com

209

208

REF	PART #	DESCRIPTION
201	P0885201	DISCONNECT POWER LABEL
202	P0885202	ELECTRICITY LABEL
203	P0885203	MODEL NUMBER LABEL
204	P0885204	GRIZZLY.COM LABEL
205	P0885205	MACHINE ID LABEL

REF	PART #	DESCRIPTION
206	P0885206	READ MANUAL LABEL
207	P0885207	BLADE TENSION LABEL
208	P0885208	TOUCH-UP PAINT, GRIZZLY BEIGE
209	P0885209	TOUCH-UP PAINT, GRIZZLY GREEN

⚠ WARNING

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



WARRANTY & RETURNS

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

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

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

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

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

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

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



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