

Grizzly **Industrial, Inc.**®

MODEL G0926 **4" X 5½" VARIABLE-SPEED** **METAL-CUTTING BANDSAW** **OWNER'S MANUAL** *(For models manufactured since 11/20)*



COPYRIGHT © OCTOBER, 2020 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.**
#CS21416 PRINTED IN CHINA

V1.10.20



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	32
Contact Info.....	2	SECTION 6: MAINTENANCE	34
Manual Accuracy	2	Schedule.....	34
Identification.....	3	Cleaning & Protecting	34
Controls & Components.....	4	Lubrication	34
Machine Data Sheet	5	SECTION 7: SERVICE	35
SECTION 1: SAFETY	7	Troubleshooting	35
Safety Instructions for Machinery	7	Replacing Motor Brushes	37
Additional Safety for Horizontal Metal		Changing Blade	38
Bandsaws	9	Adjusting Blade Tracking.....	40
SECTION 2: POWER SUPPLY	10	Tensioning Blade	41
SECTION 3: SETUP	12	Adjusting Downfeed Stop Bolt	42
Needed for Setup.....	12	Squaring Blade to Table	42
Unpacking	12	Adjusting Blade Guide Bearings.....	43
Inventory	13	SECTION 8: WIRING	45
Hardware Recognition Chart	14	Wiring Safety Instructions	45
Cleanup.....	15	Wiring Diagram.....	46
Site Considerations.....	16	Electrical Component Photos	47
Assembly	17	SECTION 9: PARTS	48
Test Run	19	Main	48
Recommended Adjustments.....	20	Stand.....	51
SECTION 4: OPERATIONS	21	Labels & Cosmetics	52
Operation Overview	21	WARRANTY & RETURNS	53
Disabling Switch.....	22		
Operation Tips	22		
Inspecting Workpieces.....	23		
Selecting Blades	23		
Blade Care & Break-In.....	25		
Blade Breakage	25		
Chip Inspection Chart	26		
Adjusting Blade Guide	27		
Adjusting Feed Rate	27		
Using Vise.....	28		
Adjusting Work Stop	29		
Adjusting Blade Speed	29		
Blade Speed Chart	30		
Locking Headstock Position.....	31		

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 the motor has stopped and disconnect power before adjustments, maintenance, or service.	
Weight:		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
		Manufactured for Grizzly in Taiwan	

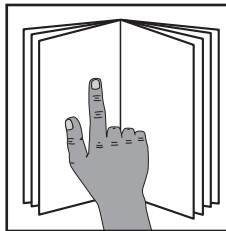
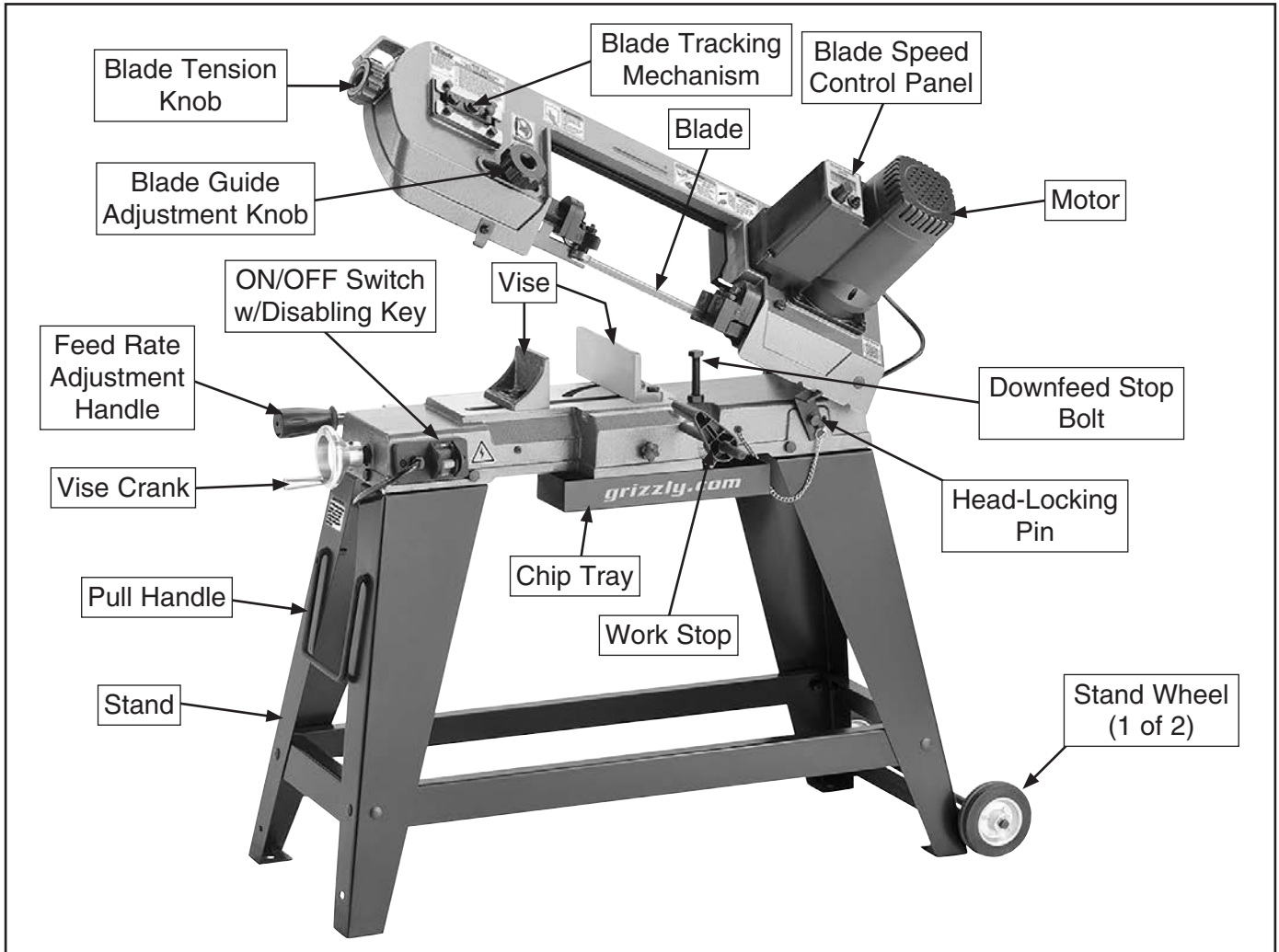
Manufacture Date

Serial Number



Identification

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

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.

Vise

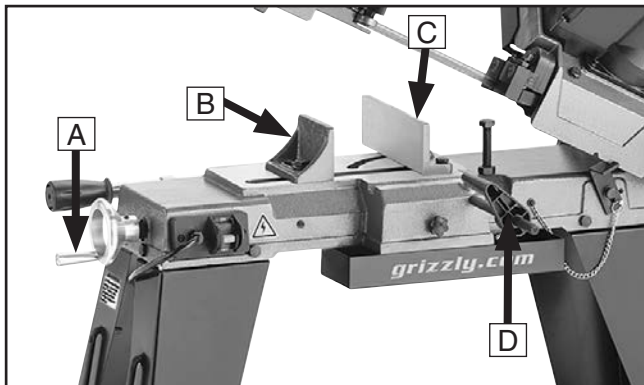


Figure 1. Vise controls and components.

- A. **Vise Crank:** Adjusts movable vise jaw.
- B. **Movable Vise Jaw:** Holds workpiece against fixed vise jaw during cutting operation. Angle is adjustable.
- C. **Fixed Vise Jaw:** Adjusts workpiece angle relative to blade.
- D. **Work Stop:** Supports repetitive cutting operations.

Electrical

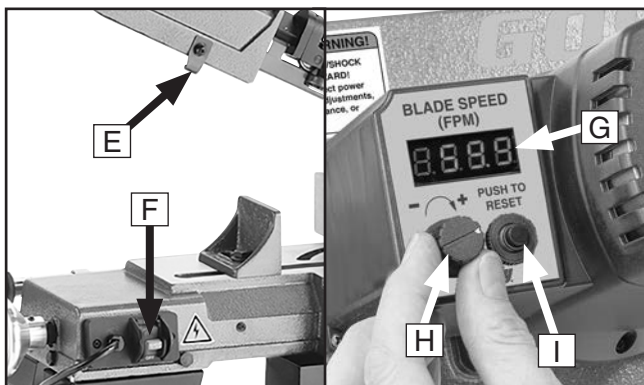


Figure 2. Electrical controls and components.

- E. **Auto-Off Tab:** Turns machine **OFF** when headstock is fully lowered.
- F. **ON/OFF Switch w/Disabling Key:** Turns motor **ON/OFF** and prevents accidental start-up when disabling key is removed.
- G. **Blade Speed Display:** Displays current blade speed in Feet Per Minute.
- H. **Blade Variable-Speed Dial:** Adjusts blade speed from 85–195 FPM.
- I. **Circuit Breaker Reset Button:** Restores power to motor when pressed after overload.

Headstock

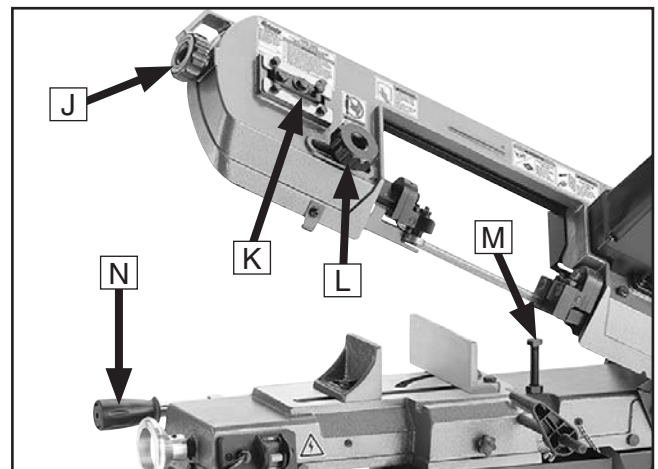


Figure 3. Headstock controls and components.

- J. **Blade Tension Knob:** Increases or decreases blade tension.
- K. **Blade Tracking Mechanism:** Adjusts front blade wheel tilt to move blade to or from wheel shoulder.
- L. **Blade Guide Adjustment Knob:** Adjusts front blade guide that supports blade. Position guide as close to workpiece as possible to prevent blade from twisting.
- M. **Downfeed Stop Bolt:** Stops headstock from lowering farther than completion of cut.
- N. **Feed Rate Adjustment Handle:** Increases feed rate when turned counterclockwise and decreases feed rate when turned clockwise.





MACHINE DATA SHEET

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

MODEL G0926 4" X 5-1/2" VARIABLE-SPEED METAL-CUTTING BANDSAW

Product Dimensions:

Weight..... 97 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 39-1/2 x 18-1/2 x 55-1/2 in.
Footprint (Length x Width)..... 35 x 17 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 102 lbs.
Length x Width x Height..... 35 x 17 x 19 in.

Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz
Full-Load Current Rating..... 4.5A
Minimum Circuit Size..... 15A
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 72 in.
Power Cord Gauge..... 18 AWG
Plug Included..... Yes
Included Plug Type..... NEMA 5-15
Switch Type..... Toggle ON/OFF w/Disabling Key

Motors:

Main

Horsepower..... 3/4 HP
Phase..... Single-Phase
Amps..... 4.5A
Speed..... 3000 RPM
Type..... Universal (DC)
Power Transfer..... Direct
Bearings..... Shielded & Permanently Lubricated

Main Specifications:

Operation Info

Blade Speeds..... 85 - 195 FPM
Std. Blade Length..... 64-1/2 in.
Blade Length Range..... 63-3/4 - 64-5/8 in.



Cutting Capacities

Cutting Height.....	4-1/2 in.
Angle Cuts.....	0 - 45 deg.
Vise Jaw Depth.....	6-1/4 in.
Vise Jaw Height.....	2-1/2 in.
Max. Capacity Rectangular Height at 90 Deg.....	4 in.
Max. Capacity Rectangular Width at 90 Deg.....	5-1/2 in.
Max. Capacity Round at 90 Deg.....	4-1/2 in.
Max. Capacity Rectangular Height at 45 Deg.....	3-1/2 in.
Max. Capacity Rectangular Width at 45 Deg.....	3 in.
Max. Capacity Round at 45 Deg.....	3 in.
Max. Capacity Rectangular Height at 60 Deg.....	4-1/2 in.
Max. Capacity Rectangular Width at 60 Deg.....	4-1/2 in.
Max. Capacity Round at 60 Deg.....	4-1/2 in.

Construction

Table.....	Cast Iron
Trunnions.....	Cast Aluminum
Upper Wheel.....	Cast Iron
Lower Wheel.....	Cast Iron
Body.....	Cast Iron
Base.....	Cast Iron
Stand.....	Pre-formed Steel
Wheel Cover.....	Pre-formed Steel
Paint Type/Finish.....	Hammertone Urethane

Other

Wheel Size.....	7-1/8 in.
Blade Guides Upper.....	Ball Bearing
Blade Guides Lower.....	Ball Bearing
Mobile Base.....	Built-In
Gear Box.....	Yes

Table Info

Table Size Length.....	11-1/2 in.
Table Size Width.....	5 in.
Table Size Thickness.....	3 in.
Floor To Cutting Area Height.....	23-3/4 in.

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 min.
Serial Number Location	ID Label
ISO 9001 Factory	Yes

Features:

- Variable-Speed Dial
- Digital Readout for Blade Speed FPM
- 3/4 HP Motor
- Work Stop
- Mobile Base w/Handle
- Automatic Blade Shut-Off
- Blade Included



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 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 headstock 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 or wheel covers 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

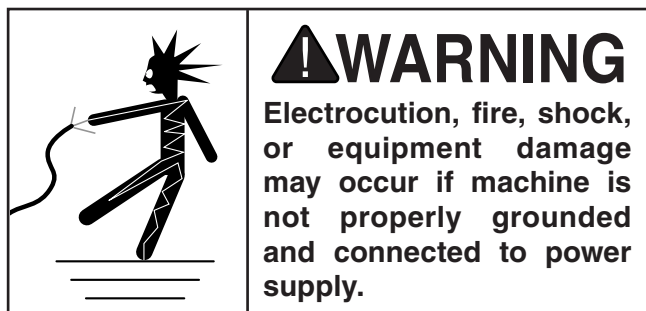
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or 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 ... 4.5 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!

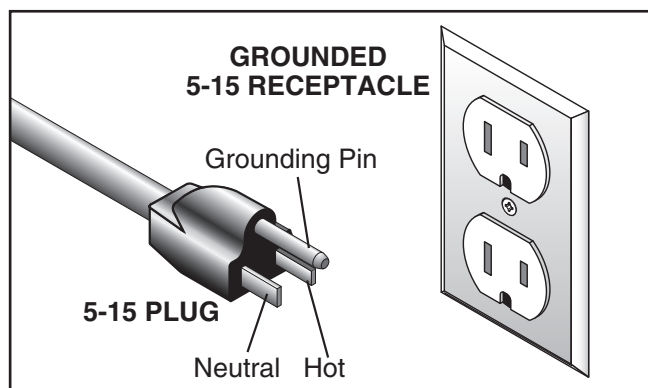


Figure 4. Typical 5-15 plug and receptacle.

⚠ CAUTION

The diagram shows three circular icons, each with a large 'X' over it, indicating that these practices are unsafe. The first icon shows a two-prong plug. The second icon shows a modified plug with a grounding pin inserted into a two-prong outlet. The third icon shows a two-prong outlet.

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.

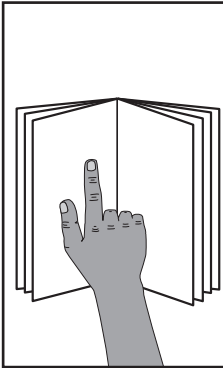
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

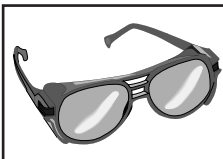


SECTION 3: SETUP



!WARNING

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



!WARNING

Wear safety glasses during the entire setup process!



!WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Safety Glasses (for each person).....	1
• Solvent/Cleaner.....	1
• Disposable Rags.....	1
• Disposable Gloves.....	1
• Saw Horses.....	2
• Assistant for Lifting.....	1
• Level.....	1
• Open-End Wrench 10, 13mm.....	2 Ea.
• Open-End Wrench 19mm.....	1
• Machinist's Square.....	1

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.***



Inventory

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

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

NOTICE

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

I.	Wheel Mounting Bracket	1
J.	Wheel Axle	1
K.	Pull Handle	1
L.	Long Braces	2
M.	Short Braces	2
N.	Wheels	2

Fasteners (Not Shown)

	Qty	
O.	Hex Bolts M8-1.25 x 20	8
P.	Carriage Bolts M8-1.25 x 16	8
Q.	Flat Washers 8mm	16
R.	Lock Washers 8mm	16
S.	Hex Nuts M8-1.25	16
T.	Hex Bolts M6-1 x 12	2
U.	Flat Washers 6mm	4
V.	Lock Washers 6mm	2
W.	Hex Nuts M6-1	2
X.	Cotter Pins	4

Box 1 (Figures 5–6)

	Qty	
A.	Bandsaw (Not Shown)	1
B.	Chip Tray	1
C.	Knob Bolt M8-1.25 x 16	1
D.	Work Stop Rod	1
E.	Hex Wrench 4mm	1
F.	Work Stop	1
G.	Left Stand Legs	2
H.	Right Stand Legs	2



Figure 5. Inventory items B–F.

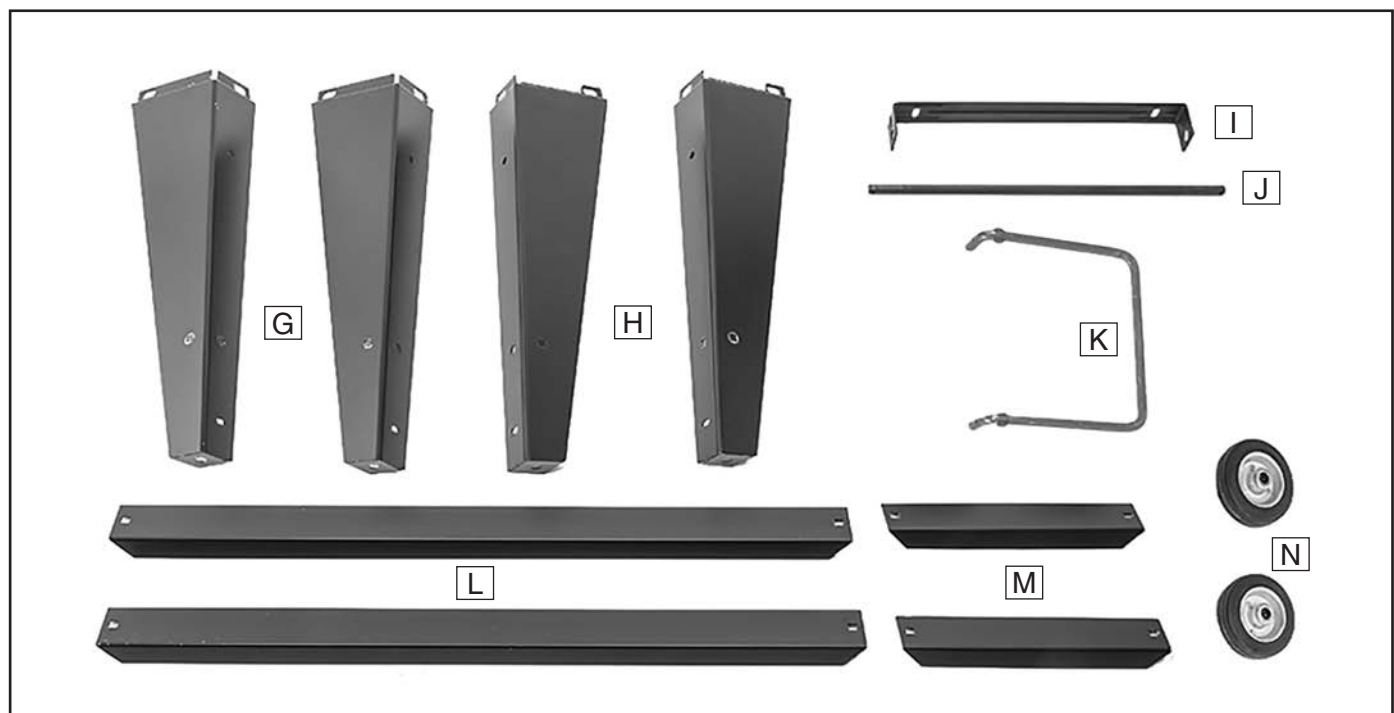


Figure 6. Inventory items G–N.



Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

#10

1/4"

5/16"

3/8"

7/16"

1/2"

4mm

5mm

6mm

8mm

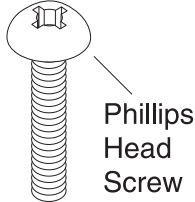
10mm

12mm

16mm



Hex
Wrench



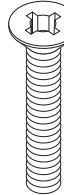
Phillips
Head
Screw



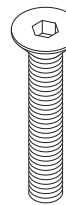
Lock
Nut



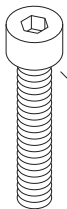
Wing
Nut



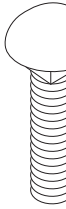
Flat
Head
Screw



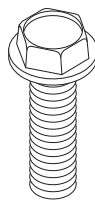
Flat
Head
Cap
Screw



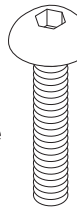
Cap
Screw



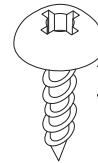
Carriage
Bolt



Flange
Bolt



Button
Head
Screw



Tap
Screw



External
Retaining
Ring



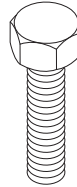
Internal
Retaining
Ring



E-Clip



Set
Screw



Hex
Bolt



Key



Flat Washer

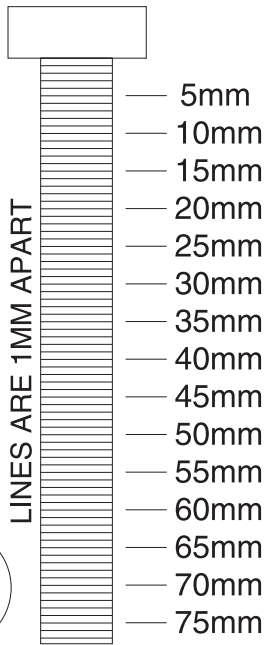


Lock
Washer

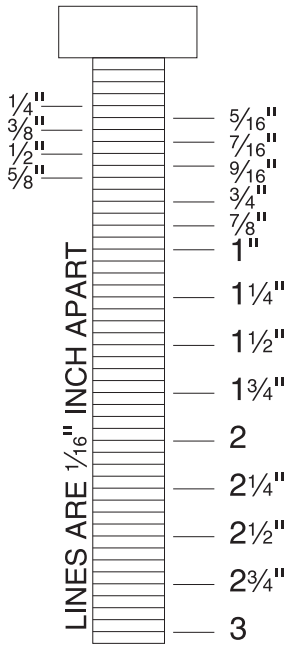


Hex
Nut

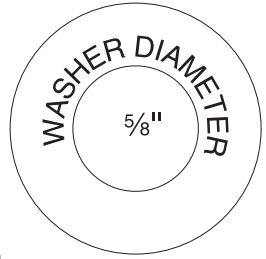
LINES ARE 1MM APART



LINES ARE 1/16" INCH APART



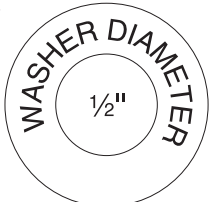
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



WASHER DIAMETER
5/8"



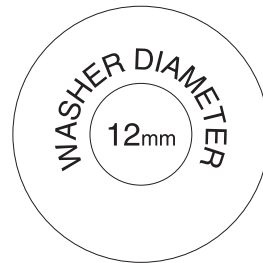
WASHER DIAMETER
9/16"



WASHER DIAMETER
1/2"



WASHER DIAMETER
7/16"



WASHER DIAMETER
12mm



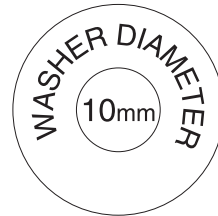
WASHER DIAMETER
3/8"



4mm



WASHER DIAMETER
5/16"



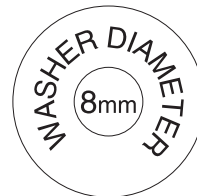
WASHER DIAMETER
10mm



5mm



WASHER DIAMETER
1/4"



WASHER DIAMETER
8mm



6mm



#10



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.

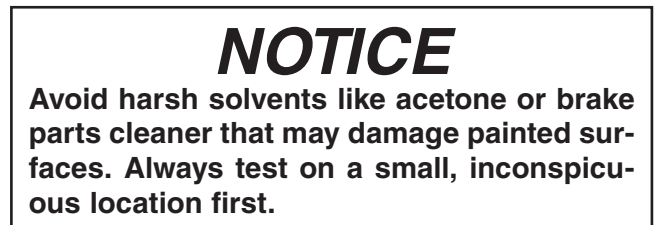
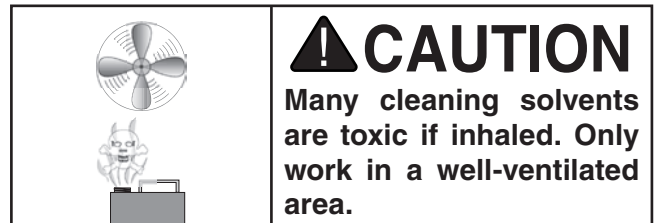
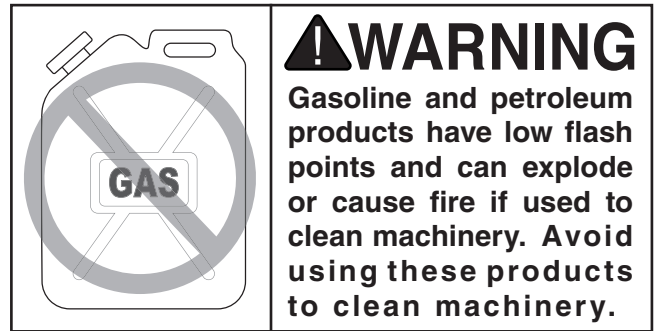
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

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 7. T23692 Orange Power Degreaser.



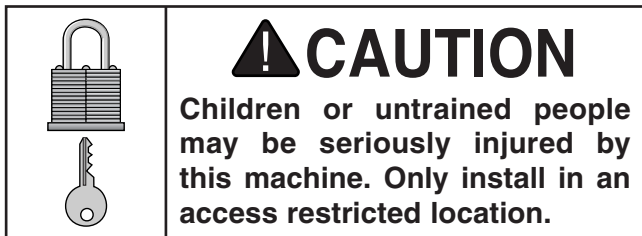
Site Considerations

Weight Load

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

Space Allocation

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



Physical Environment

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

Electrical Installation

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

Lighting

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

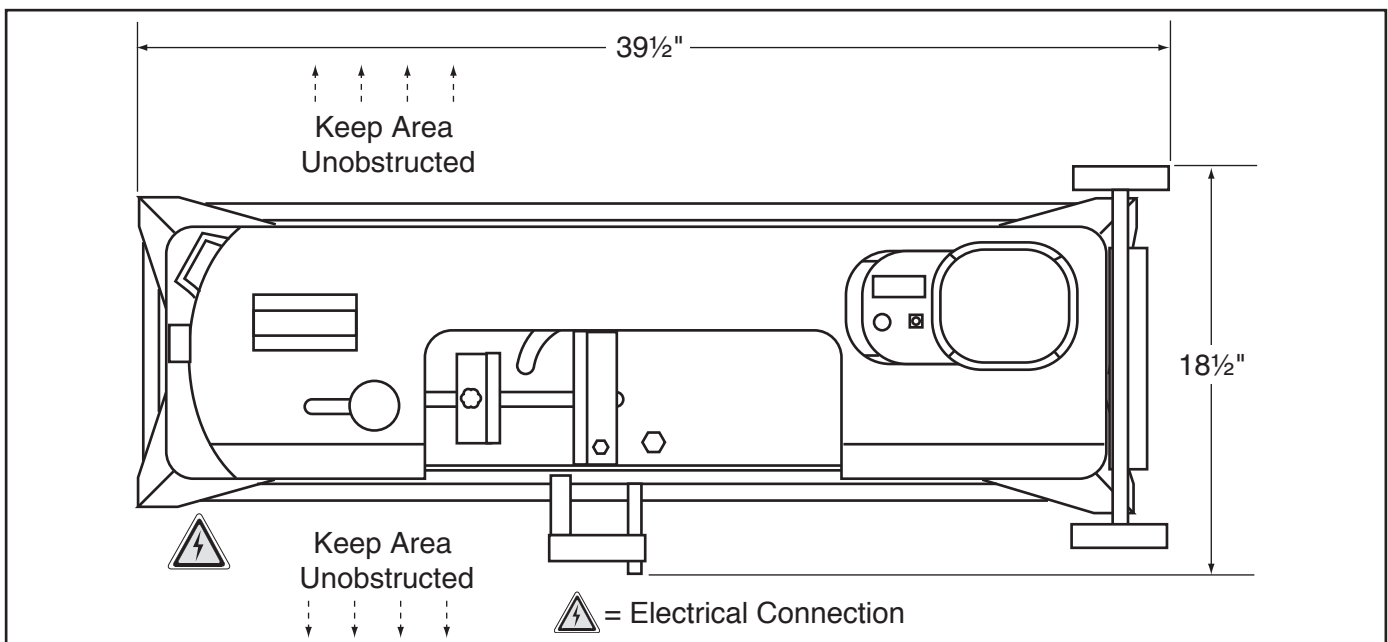


Figure 8. Minimum working clearances.



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. Slide head-locking pin into headstock pivot arm and base (see **Figure 9**).

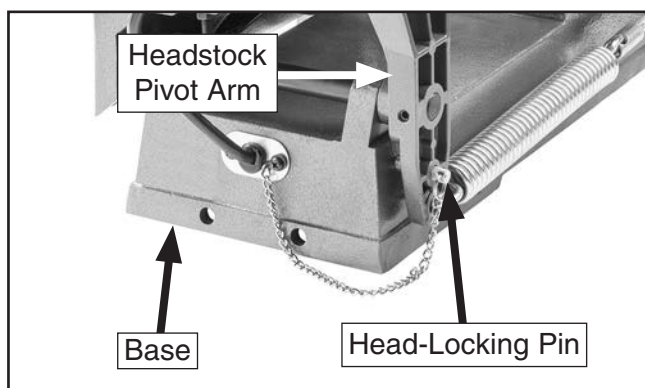


Figure 9. Headstock locked in down position.

2. With help from an assistant, lift bandsaw onto pair of closely spaced sawhorses or other suitable support (see **Figure 10**).
3. Attach legs to bandsaw with (8) M8-1.25 x 20 hex bolts, 8mm flat washers, 8mm lock washers, and M8-1.25 hex nuts (see **Figure 10**).

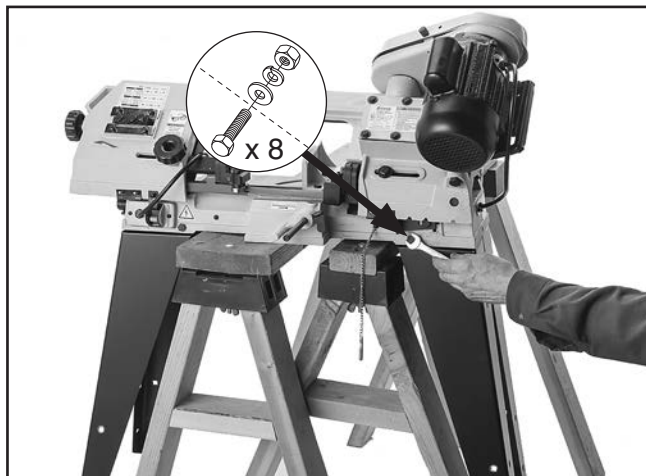


Figure 10. Example of attaching legs to bandsaw.

Note: Tighten just enough to secure parts. Final tightening will take place when stand is fully assembled.

4. Attach short braces to legs with (4) M8-1.25 x 16 carriage bolts, 8mm flat washers, 8mm lock washers, and M8-1.25 hex nuts (see **Figure 11**).

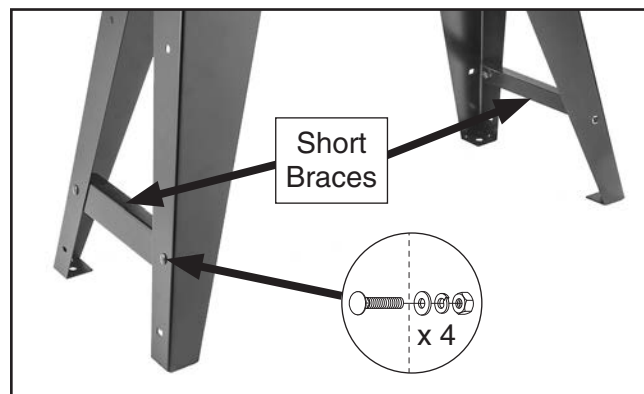


Figure 11. Short braces attached to legs.

Note: Tighten just enough to secure parts. Final tightening will take place when stand is fully assembled.

5. Remove bandsaw from sawhorses and attach long braces to legs with (4) M8-1.25 x 16 carriage bolts, 8mm flat washers, 8mm lock washers, and M8-1.25 hex nuts (see **Figure 12**).

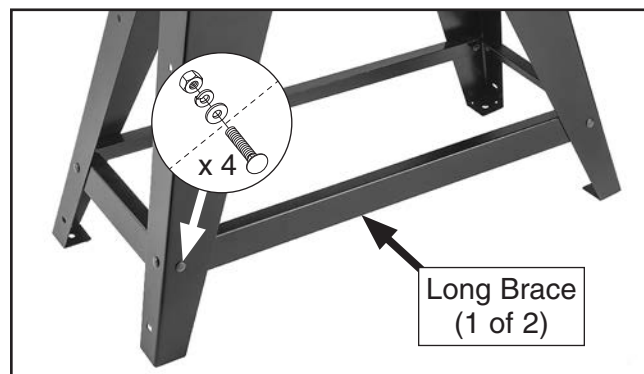


Figure 12. Long braces attached to legs.



- Attach wheel mounting bracket to bottom of two legs with (2) M6-1 x 12 hex bolts, (4) 6mm flat washers, (2) 6mm lock washers, and (2) M6-1 hex nuts, as shown in **Figure 13**.

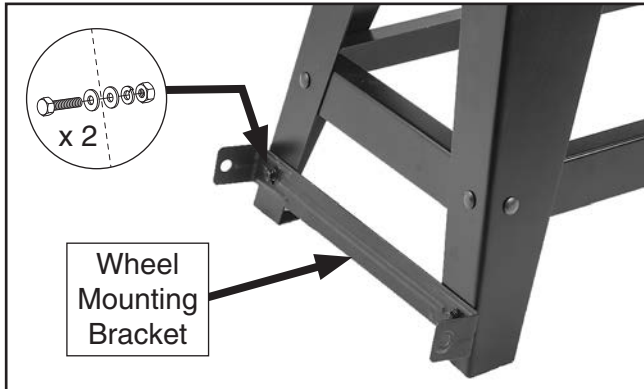


Figure 13. Wheel-mounting bracket attached to legs.

- Slide wheel axle through holes in wheel-mounting bracket (see **Figure 14**).
- Slide wheels onto axle on outside of mounting brackets, and secure with (2) cotter pins (see **Figure 14**).

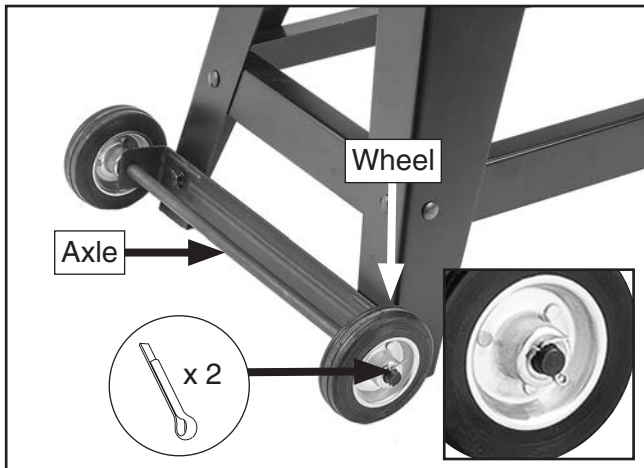


Figure 14. Wheels attached to axle.

- On opposite side of stand, insert pull handle into holes shown in **Figure 15** and secure with (2) cotter pins.

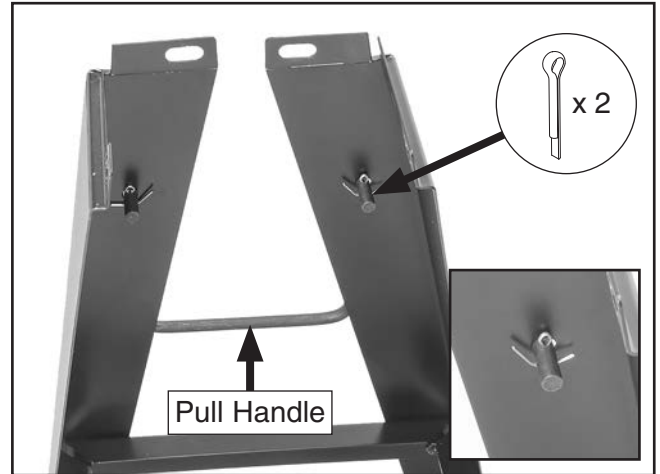


Figure 15. Cotter pins installed in handle.

- Check to see if bandsaw is relatively level, then fully tighten all bolts and nuts.
- Slide work stop rod into side of bandsaw, then lock it in place by tightening set screw shown in **Figure 16**.

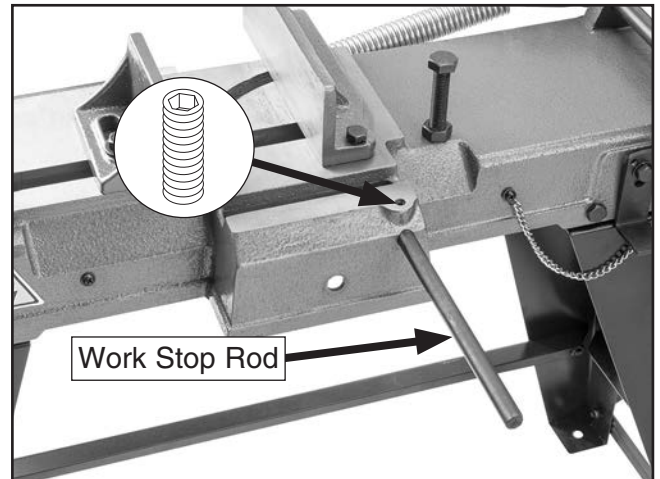


Figure 16. Work stop rod installed.



12. Slide work stop onto rod and secure with pre-installed wing nut (see **Figure 17**).

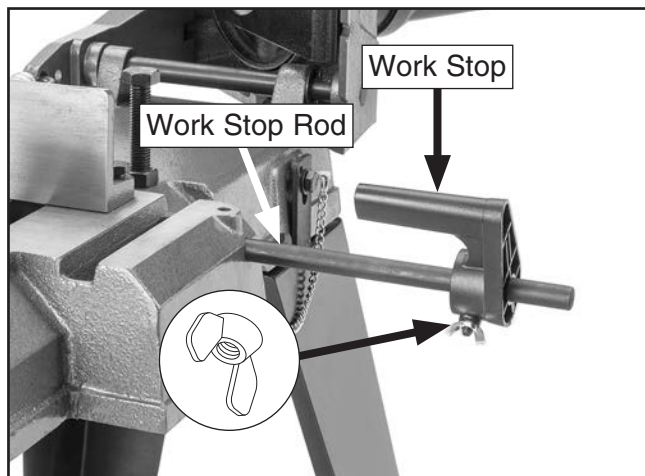


Figure 17. Work stop secured on rod.

13. Attach chip tray to base with M8-1.25 x 16 knob bolt (see **Figure 18**).

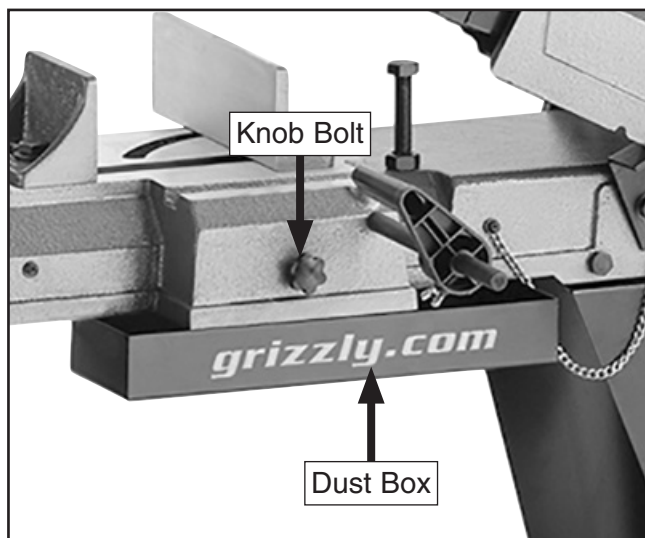


Figure 18. Dust box installed on base.

Test Run

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

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

The Test Run consists of verifying the following:

- 1) The motor powers up and runs correctly,
- 2) the switch disabling key disables the switch properly,
- 3) the auto-off tab shuts down power, and
- 4) the variable-speed dial works correctly.

!WARNING

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

!WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Remove head-locking pin and raise head-stock.
4. Turn machine **ON**, verify motor operation, and then turn machine **OFF**.

Motor should run smoothly and without unusual problems or noises.



5. Turn machine **ON** and fully lower headstock. When headstock is in lowest position, auto-off tab should switch power **OFF**.

— If auto-tab *does* switch power **OFF**, tab is functioning correctly. Proceed to **Step 6**.

— If auto-tab *does not* switch power **OFF**, tab is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

6. Test blade variable-speed dial by increasing and decreasing bandsaw blade speed.

7. Remove key from toggle switch, as shown below.

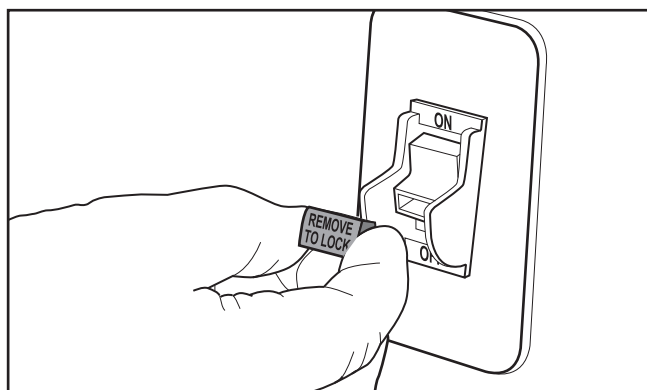


Figure 19. Removing key from toggle switch.

8. Raise headstock and try to start machine with switch.

— If machine *does not* start, toggle switch is working correctly. Congratulations! Test Run is complete.

— If machine *does* start (with toggle switch removed), immediately disconnect power to machine. Toggle switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure accurate cutting results.

Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE**.

Factory adjustments that should be verified:

1. Blade Tracking (**Page 40**).
2. Downfeed Stop Bolt (**Page 42**).
3. Squaring the Blade (**Page 42**).
4. Blade Guide Bearings (**Page 43**).

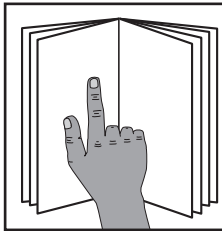


SECTION 4: OPERATIONS

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.

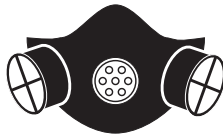


!WARNING

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.



!WARNING

Electrocution Hazard. The motor and switch on this bandsaw are not protected against liquids. Do not use water-based cutting fluids with this bandsaw.

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 operation, the operator does the following:

1. Examines workpiece to make sure it is suitable for cutting.
2. If needed, changes blade for workpiece material and verifies blade is tensioned correctly.
3. Sets up work stop if needed for operation.
4. Raises and locks headstock.
5. Adjusts vise angle for operation and securely clamps workpiece in vise. Ensures workpiece is stable and cutting area is free of obstructions.
6. Adjusts blade guide as close to workpiece as possible.
7. Adjusts spring tension for correct feed rate.
8. Puts on safety glasses and respirator.
9. Starts machine and adjusts blade speed.
10. Slowly lowers headstock until blade makes contact with workpiece, then releases headstock so spring-controlled feed rate continues to lower blade into workpiece until cut is finished.
11. Stops machine, raises headstock, and removes workpieces.



Disabling Switch

The switch can be disabled by removing the key, as shown below. Disabling the switch in this manner can prevent unauthorized operation of the machine, which is important if it is not kept inside an access-restricted building or in a location where children may be present.

IMPORTANT: Disabling the switch only restricts its function. It is not a substitute for disconnecting machine from power when adjusting or servicing.

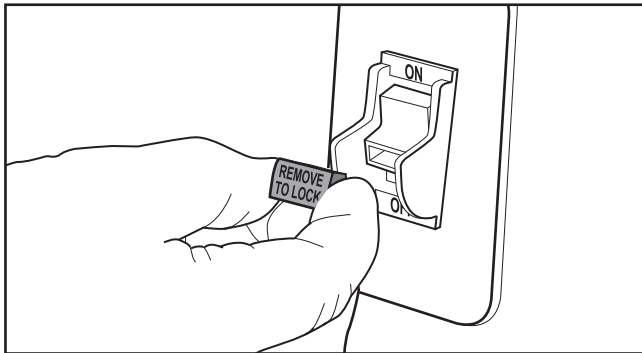


Figure 20. Disabling switch by removing key.

! WARNING

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

Operation Tips

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

NOTICE

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

Tips for cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp workpiece firmly in the vise jaws to ensure a straight cut through the material.
- Allow blade to reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece, and do not start a cut on a sharp edge.
- Chips should be curled and silvery. If the chips are thin and powder-like, increase your feed rate (refer to the **Metal Chip Inspection Chart** on **Page 26**).
- Burned chips indicate a need to reduce blade speed.
- Wait until blade has completely stopped before removing workpiece from vise. Avoid touching the cut end—it could be very hot!
- Support long pieces so they will not fall when cut. Flag long ends to alert passers-by of potential danger.
- Adjust blade guides as close as possible to the workpiece to minimize side-to-side blade movement.



Inspecting Workpieces

Some metal workpieces are not safe to cut with a metal cutting bandsaw; instead, a different tool or machine should be used.

Before cutting, inspect the material for any of the following conditions and take the necessary precautions:

- **Small or Thin Workpieces:** Small or thin workpieces may be damaged during cutting—avoid cutting these workpieces if possible. If you must cut a small or thin workpiece, attach it to or clamp it between larger scrap pieces that will both support the workpiece through the cut. Some thin sheet metals will not withstand the forces from this bandsaw during cutting; instead, use a shear, nibblers, or sheet metal nippers to cut these pieces.
- **Unstable Workpieces:** Workpieces that cannot be properly supported or stabilized with the vise should not be cut on this bandsaw. Examples are chains, cables, workpieces with internal or built-in moving or rotating parts, etc.
- **Material Hardness:** Always factor in the hardness of the metal before cutting it. Hardened metals will take longer to cut, may require lubrication, and may require a different type of blade in order to efficiently cut them.
- **Tanks, Cylinders, Containers, Valves, Etc:** Cutting into containers that are pressurized or contain gasses or liquids can cause explosions, fires, caustic burns, or machine damage. Avoid cutting any of these types of containers unless you have verified that the container is empty and it can be properly supported during a cut.
- **Magnesium:** Pure magnesium burns easily. Cutting magnesium with a dull blade can create enough friction to ignite the small magnesium chips. Avoid cutting magnesium if possible.

Selecting Blades

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

Blade Terminology

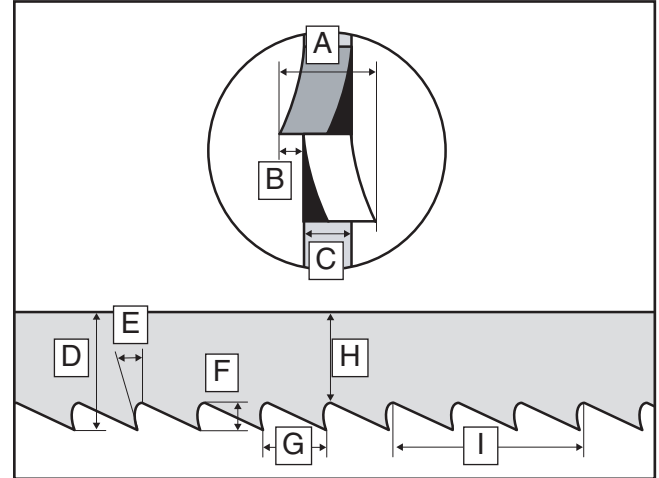


Figure 21. Bandsaw blade terminology.

- A. Kerf:** Amount of material removed by blade during cutting.
- B. Tooth Set:** Amount each tooth is bent left or right from blade.
- C. Gauge:** Thickness of blade.
- D. Blade Width:** Widest point of blade measured from tip of tooth to back edge of blade.
- E. Tooth Rake:** Angle of tooth face from line perpendicular to length of blade.
- F. Gullet Depth:** Distance from tooth tip to bottom of curved area (gullet).
- G. Tooth Pitch:** Distance between tooth tips.
- H. Blade Back:** Distance between bottom of gullet and back edge of blade.
- I. Blade Pitch or TPI:** 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 Range
G0926.....	63 ³ / ₄ "–64 ⁵ / ₈ "

Blade Width

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

Model	Blade Width
G0926.....	1/2"

Tooth Type

The most common tooth types are described as follows, and illustrated in **Figure 22**.

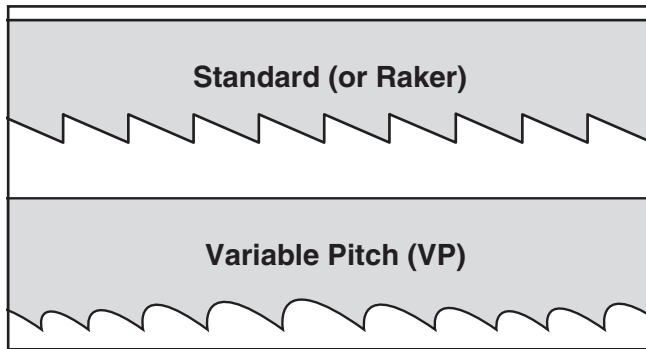


Figure 22. Bandsaw blade tooth types.

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

Variable Pitch (VP): Varying gullet depth and tooth spacing, "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 23**, 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 30** for further details.

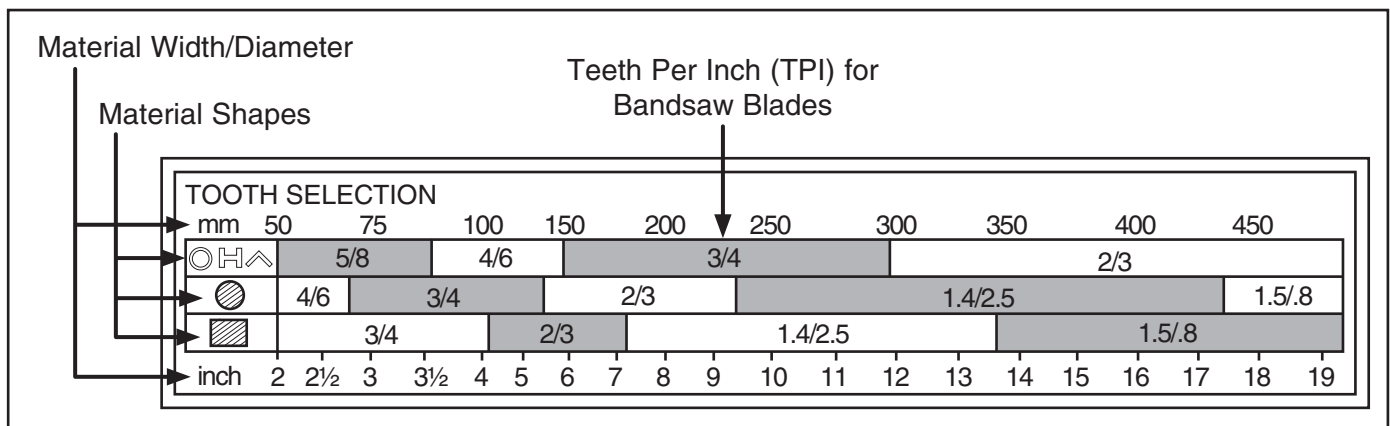


Figure 23. General guidelines for blade selection and speed chart.



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 30** and **Chip Inspection Chart** on **Page 26**). 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 26** 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 type.
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 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 set too high above the workpiece. Adjust left blade guide assembly as close to workpiece as possible.
- Using a blade with a lumpy or improperly finished braze or weld.
- 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.



Chip Inspection Chart

The best method of evaluating the performance of your metal cutting operation is to inspect the chips that are formed from cutting. Refer to the chart below for chip inspection guidelines.








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 24. Chip inspection chart.



Adjusting Blade Guide

The blade guide should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust blade guide:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen blade guide adjustment knob shown in **Figure 25** and slide blade guide as close to workpiece as possible, then tighten knob.

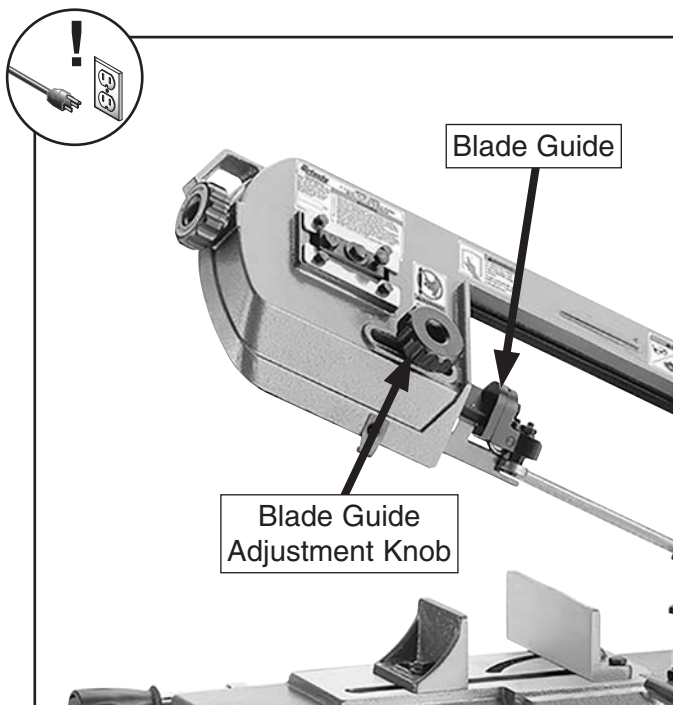


Figure 25. Blade guide.

Adjusting Feed Rate

The feed rate is controlled by the spring and handle shown in **Figure 26**.

To adjust the feed rate slower, twist the handle clockwise to add tension to the spring.

To adjust the feed rate faster, twist the handle counterclockwise to remove tension from the spring.

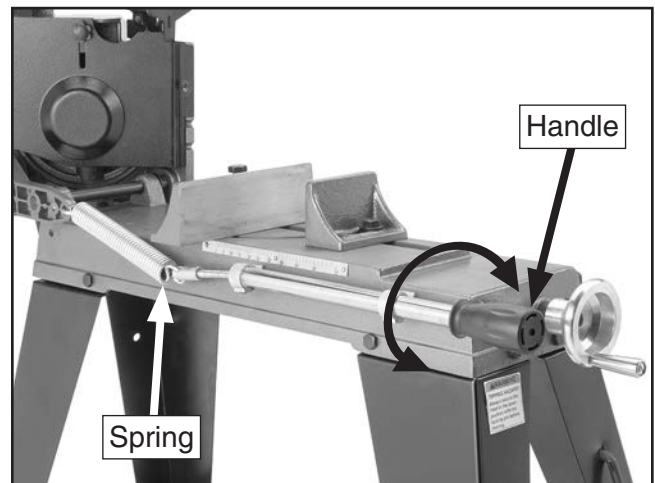


Figure 26. Feed rate adjustment.



Using Vise

The vise consists of a movable jaw and fixed jaw and can hold material up to 6 inches wide and be set to cut angles from 0° to 45°.

⚠ CAUTION

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

Tools Needed	Qty
Wrenches or Sockets 13mm	2
Wrench or Socket 17mm	1
Machinist's Square	1

To use vise:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen two hex bolts shown in **Figure 27**.

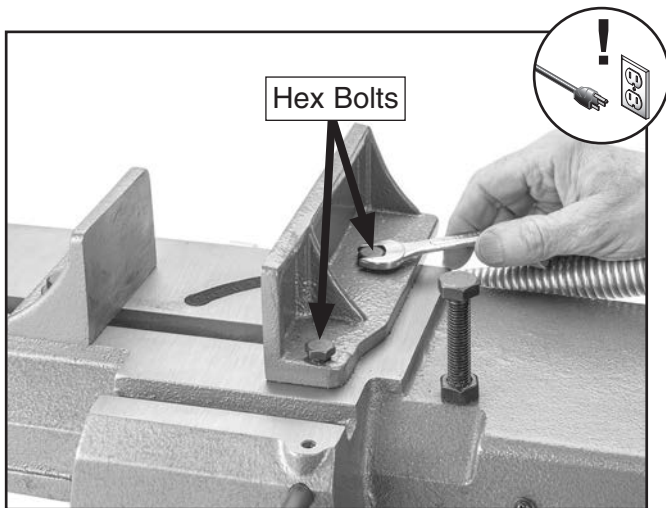


Figure 27. Setting vise angle.

3. Use scale as guide or use machinist's square to set angle of vise, as shown in **Figure 28**.

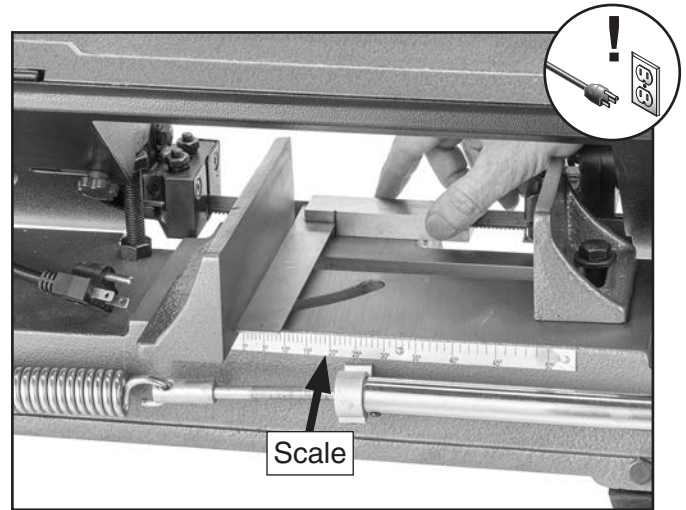


Figure 28. Squaring vise to blade.

4. Tighten hex bolts.
5. Loosen hex bolt on movable vise jaw so it can float, then match angle of workpiece and tighten hex bolt.
6. Tighten movable vise jaw against workpiece using vise crank.

Note: *Figure 29* shows correct methods of holding different workpiece shapes.

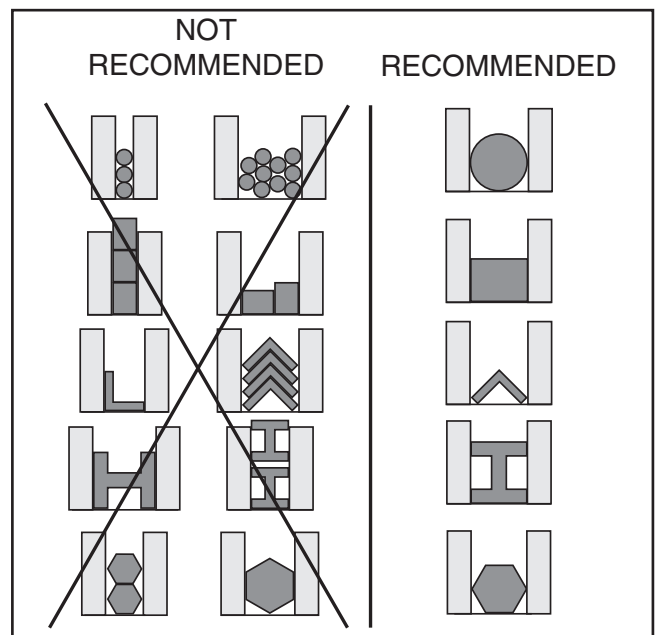


Figure 29. Example of workpiece holding options by material shape.



Adjusting Work Stop

The Model G0926 is equipped with a work stop for repetitive cutting operations. The work stop will need to be adjusted any time it is removed or repositioned, or anytime you change cutting length.

Tool Needed	Qty
Pencil.....	1

To adjust work stop:

1. DISCONNECT MACHINE FROM POWER!
2. Measure and mark workpiece for cut.
3. Clamp workpiece in vise and adjust to desired angle, aligning cutting line with cut mark.
4. Loosen wing nut shown in **Figure 30** and adjust work stop until it contacts workpiece. Tighten wing nut to secure work stop setting.

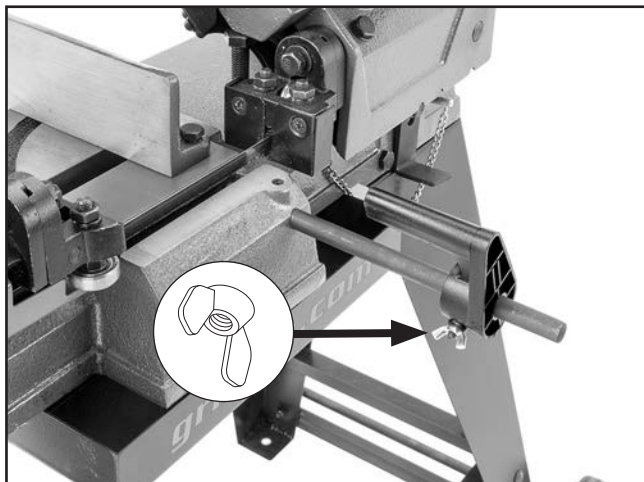


Figure 30. Work stop wing nut location.

Adjusting Blade Speed

The Model G0926 is capable of blade speeds between 85 and 195 FPM (Feet Per Minute). To adjust the speed, rotate the blade speed dial left or right until the speed display shows the speed desired (see **Figure 31**).

(Refer to **Blade Speed Chart** on **Page 30** for blade speed guidelines for various metals.)

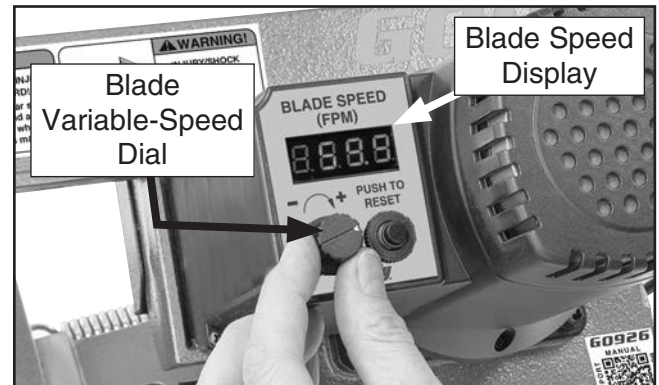


Figure 31. Adjusting blade speed.



Blade Speed Chart

The chart in **Figure 32** 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 32. Blade speed chart.



Locking Headstock Position

!WARNING

Head-locking pin secures headstock in down, horizontal position. You **MUST** secure headstock with locking pin before moving machine to prevent headstock unexpectedly springing up, causing machine to tip or fall. Otherwise, serious personal injury or property damage could occur.

The head-locking pin safely secures the head in the down position for transportation. To ensure the head does not unexpectedly spring up and tip the bandsaw over, this locking pin must be properly inserted when the bandsaw is not in use or before moving it.

The headstock can also be secured in an upright position using the safety bracket and pin on the other side of the base. This position is useful for a variety of maintenance and adjustments outlined later in this manual.

Locking Headstock Down

1. DISCONNECT MACHINE FROM POWER!
2. Fully lower headstock down then insert locking pin shown in **Figure 33** through holes in headstock pivot arm and base.

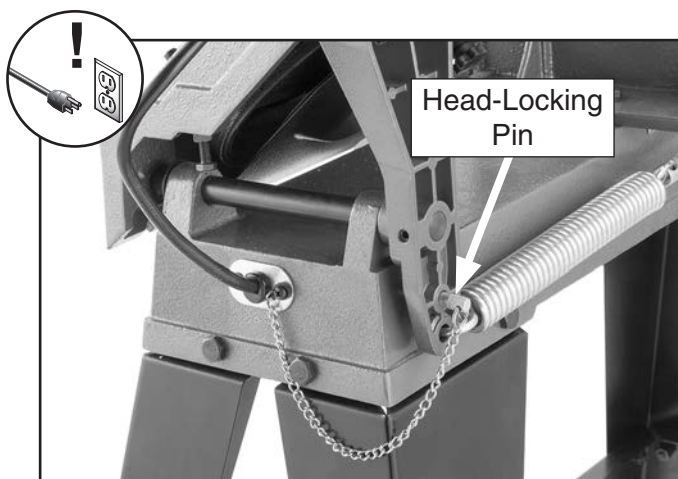


Figure 33. Head-locking pin correctly inserted.

3. Before connecting machine to power, remove locking pin.

Locking Headstock Up

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock, position safety bracket in one of the notches shown in **Figure 34**, then secure in place with locking pin.

Note: There are two different holes and locking positions; use best configuration for your needs.

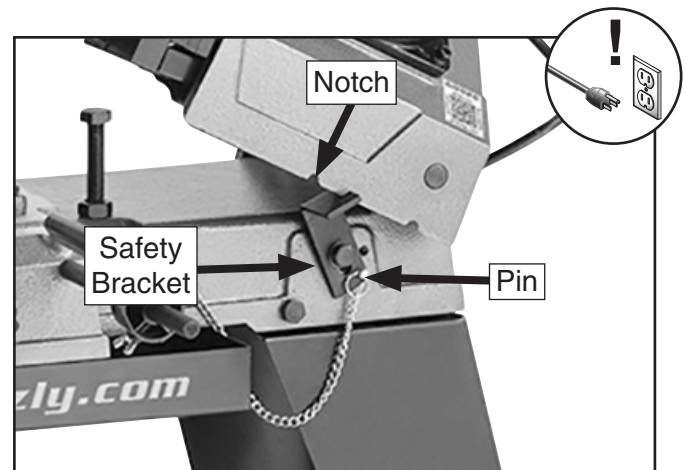


Figure 34. Components for securing raised headstock.

3. Before connecting machine to power, remove locking pin.



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.

- G5107—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 10 TPI Raker
- G5108—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 14 TPI Raker
- G5109—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 18 TPI Raker
- G5110—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 24 TPI Raker
- G5111—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 6-10 Variable Pitch
- G5112—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 8-12 Variable Pitch
- G5113—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 10-14 Variable Pitch
- G5114—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 14-18 Variable Pitch
- G5115—64 $\frac{1}{2}$ x $\frac{1}{2}$ x .025 20-24 Variable Pitch

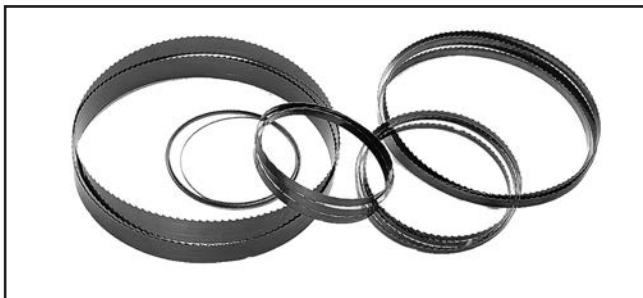


Figure 35. Variety of blades.

H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 36. H5408 Blade Tensioning Gauge.

G5618—Deburring Tool with Two Blades

The quickest tool for smoothing freshly sheared metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



Figure 37. G5618 Deburring Tool.

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



D2273—Single Roller Stand

D2274—5 Roller Stand

These roller stands are invaluable when working solo in any shop for outfeeding and support tasks. With 15⁷/₈" wide rollers, adjustable 26"–44⁵/₈" height, and all steel construction make them convenient and rugged.



Figure 38. D2273 and D2274 single and 5 roller stands.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray



Figure 39. Recommended products for protecting unpainted cast-iron and steel.

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 40. Eye protection assortment.

T26419—Syn-O-Gen Synthetic Grease

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

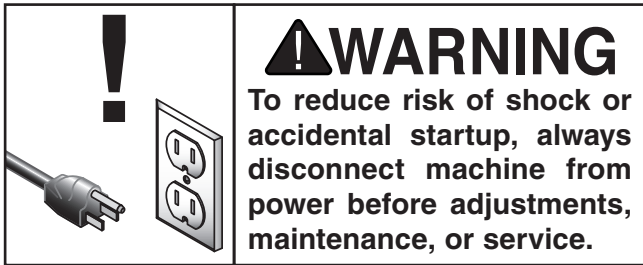


Figure 41. T26419 Syn-O-Gen Synthetic Grease.

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



SECTION 6: MAINTENANCE



Keep unpainted cast-iron surfaces rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 33** for more details).

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

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:

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

Monthly Check

- V-belt tension, damage, or wear.
- Lubricate vise screw.
- Clean/vacuum dust buildup off motor.

Cleaning & Protecting

Use a brush and shop vacuum to remove chips and other debris from the working surfaces.

Remove any rust build-up from unpainted cast-iron surfaces of your machine, and treat with a non-staining lubricant after cleaning.

Lubrication

The only location on the Model G0926 that requires lubrication is the vise screw. Before applying lubricant to this area, wipe the area clean to avoid contamination. Whenever you notice unusual resistance when closing the vise, lubricate the screw shown in **Figure 42** with multi-purpose gear grease.

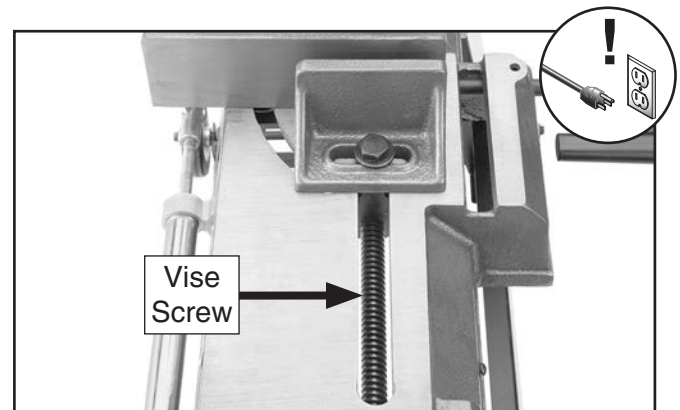


Figure 42. Location to lubricate vise screw.

Items Needed	Qty
NLGI#2 Grease (T26419 or Equivalent)	As Needed
Clean Shop Rags	As Needed
Stiff Brush	1

To lubricate vise screw:

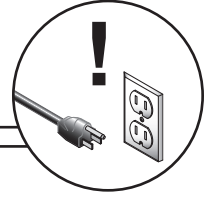
1. DISCONNECT MACHINE FROM POWER!
2. Clean grease and any built up dirt/dust from screw using brush and rags.
3. Apply new grease and move vise through its entire range of motion to distribute grease.



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. Switch disabling key removed. 2. Machine circuit breaker tripped. 3. Blown fuse. 4. Incorrect power supply voltage or circuit size. 5. Power supply circuit breaker tripped or fuse blown. 6. Wiring broken, disconnected, or corroded. 7. Motor brushes worn out. 8. ON/OFF or circuit breaker switch at fault. 9. Circuit board at fault. 10. Potentiometer/variable speed dial at fault. 11. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Install switch disabling key. 2. Reset circuit breaker. 3. Replace fuse/ensure no shorts. 4. Ensure correct power supply voltage and circuit size. 5. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 6. Fix broken wires or disconnected/corroded connections. 7. Remove/replace motor brushes (Page 37). 8. Replace switch/circuit breaker. 9. Inspect/replace if at fault. 10. Inspect/replace if at fault. 11. Replace motor.
Machine stalls, bogs down in cut, or is underpowered.	<ol style="list-style-type: none"> 1. Workpiece crooked; vise loose or misadjusted. 2. Wrong workpiece material (metal) or wrong blade type/TPI for material. 3. Gearbox at fault. 4. Blade slipping on wheels. 5. Machine undersized for task. 6. Blade wanders or gets pinched in cut. 7. Motor overheated, tripping machine circuit breaker. 8. Extension cord too long. 9. Circuit board at fault. 10. Motor brushes worn out. 11. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Straighten or replace workpiece/adjust vise (Page 28). 2. Use correct type/TPI/size of blade and metal (Page 23). 3. Replace broken or slipping gears. 4. Adjust blade tracking (Page 40) and tension (Page 41). 5. Use sharp blade; reduce feed rate/depth of cut. 6. Replace or replace guide bearings. 7. Clean motor/let cool, and reduce workload. Reset breaker. 8. Move machine closer to power supply; use shorter extension cord. 9. Inspect and replace if at fault. 10. Remove/replace motor brushes (Page 37). 11. Replace motor.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Stand or stand feet not adjusted properly. 3. Workpiece loose. 4. Blade damaged, warped, or has excessively large weld. 5. Motor bearings at fault. 6. Gearbox at fault. 	<ol style="list-style-type: none"> 1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Adjust stand or stand feet to stabilize machine. 3. Secure workpiece in vise (Page 28). 4. Replace warped/damaged blade (Page 38) or grind weld flush with blade. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Rebuild gearbox for bad gears/bearings.



Operation

Symptom	Possible Cause	Possible Solution
Vibration when operating or cutting.	<ol style="list-style-type: none"> Loose or damaged blade. Blade wheels have contaminants loaded up on wheel surface. Bent, damaged, or dull blade. Machine component(s) loose. Worn wheel bearing. Blade wheel worn/bent. Gearbox at fault. 	<ol style="list-style-type: none"> Tension blade (Page 41)/replace blade (Page 38). Remove blade (Page 38), clean bandsaw wheels. Replace blade (Page 38). Inspect/re-tighten component(s). Check/replace wheel bearing. Check/replace wheel. Rebuild gearbox for bad gears/bearings.
Ticking sound when saw is running.	<ol style="list-style-type: none"> Blade missing teeth. Blade weld contacting blade guides. Blade weld failing. 	<ol style="list-style-type: none"> Replace blade (Page 38). Grind weld down flush with blade. Cut and re-weld blade, or replace blade (Page 38).
Cuts not square, or intended angle is incorrect.	<ol style="list-style-type: none"> Loose vise. Blade not square to table. 	<ol style="list-style-type: none"> Tighten vise and secure workpiece (Page 28). Adjust blade square to table (Page 42).
Blade dulls prematurely, or metal sticks to blade.	<ol style="list-style-type: none"> Incorrect feed rate/blade speed. Blade gullets loading up with chips. Blade improperly broken in. 	<ol style="list-style-type: none"> Adjust feed rate (Page 27), adjust blade speed (Page 29). Use blade with larger gullets/fewer TPI (Page 23). Replace blade (Page 38); complete blade break-in procedure (Page 25).
Excessive blade breakage.	<ol style="list-style-type: none"> Workpiece loose. Blade contacting workpiece when started. Blade too thick/blade gullets too large. Workpiece too coarse for blade. Blade tension/tracking requires adjustment. Blade guide bearings require adjustment. Blade weld failing. 	<ol style="list-style-type: none"> Secure workpiece with vise (Page 28). Raise headstock, start blade, then contact workpiece. Use thinner blade/blade with smaller gullets (Page 23). Use coarser-tooth blade (Page 23); adjust feed rate (Page 27); adjust blade speed (Page 29). Adjust blade tension (Page 41)/tracking (Page 40). Adjust blade guide bearings (Page 43). Cut and re-weld blade, or replace blade (Page 38).
Blade wears on one side or overheats.	<ol style="list-style-type: none"> Blade guides mis-adjusted or worn. Blade not supported. Dull/incorrect blade. 	<ol style="list-style-type: none"> Re-adjust guides and bearings (Page 43)/replace. Move blade guide closer to workpiece (Page 27). Replace blade (Page 38).
Blade tracks incorrectly or comes off wheels.	<ol style="list-style-type: none"> Excessive feed rate/wrong TPI. Wrong blade TPI. Blade tension too low. Blade is bell-mouthed. Blade guide bearings require adjustment. Metal chip buildup on blade wheels. 	<ol style="list-style-type: none"> Reduce feed rate (Page 27). Replace blade with blade with correct TPI (Page 23). Increase blade tension (Page 41). Replace blade (Page 38); regularly remove tension from blade when not in use. Adjust blade guide bearings (Page 43). Clean metal chips from wheels.
Cuts are crooked/excessively rough.	<ol style="list-style-type: none"> Feed rate too fast, blade speed too low. Blade not supported. Blade tension too low. Blade too coarse/dull. 	<ol style="list-style-type: none"> Reduce feed rate (Page 27), increase blade speed (Page 29). Move blade guide closer to workpiece (Page 27). Increase blade tension (Page 41). Replace blade (Page 38).
Blade cuts into table, does not cut fully through workpiece.	<ol style="list-style-type: none"> Downfeed stop bolt requires adjustment. 	<ol style="list-style-type: none"> Adjust downfeed stop bolt (Page 42).



Replacing Motor Brushes

This machine is equipped with a universal motor that uses two carbon brushes to transmit electrical current inside the motor.

These brushes are considered to be regular "wear items" or "consumables" that will need to be replaced during the life of the motor. The frequency of required replacement is related to how much the motor is used and how hard it is pushed.

Always replace both carbon brushes at the same time when the motor no longer reaches full power, or when the brushes measure less than 1/4" long (new brushes are 5/8" long).

If your machine is used frequently, we recommend keeping a set of these replacement brushes on-hand to avoid any downtime.

Items Needed	Qty
Phillips Head Screwdriver #2	1
Flat Head Screwdriver 1/4"	1
Carbon Brushes (P0926216).....	2

To replace motor brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Remove (5) Phillips head screws shown in **Figure 43** and motor cover.

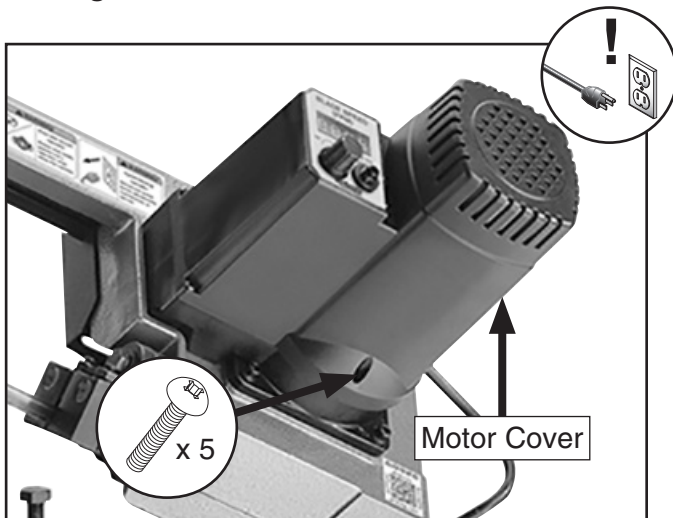


Figure 43. Motor cover and securing Phillips head screws.

3. Remove brush caps (see **Figure 44**) and worn brushes from motor.

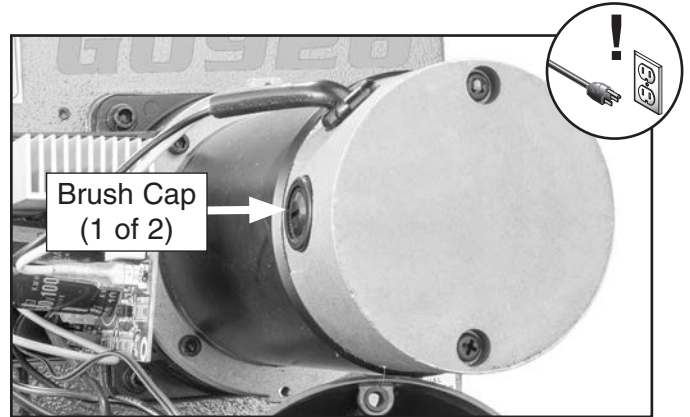


Figure 44. Motor brush cap location.

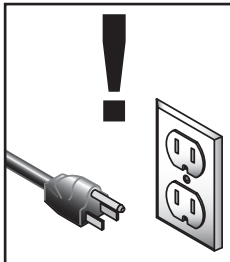
4. Replace both motor brushes and install brush caps.
5. Install motor cover and secure with Phillips head screws removed in **Step 2**.



Changing Blade

Blades should be changed when they become dull, damaged, or when your operation requires a different blade.

A list of optional replacement blades is listed on **Page 32**. We recommend keeping several sets of blades on-hand to avoid downtime and to be properly prepared to cut different types of material.

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

Tool Needed Qty
Phillips Head Screwdriver #2 1

To change blade:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock fully and use head-locking pin to keep headstock upright (see **Figure 45**).

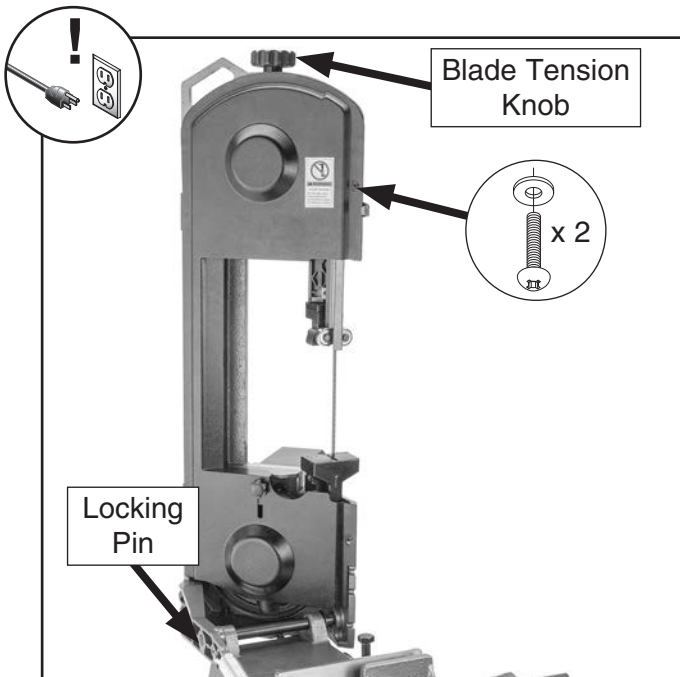


Figure 45. Headstock fully raised and locked in position.

3. Loosen blade tension knob fully.
4. Remove (2) Phillips head screws and flat washers shown in **Figure 45**.
5. Loosen extension guard lock knob, fully raise extension guard, and tighten lock knob to secure (see **Figure 46**).

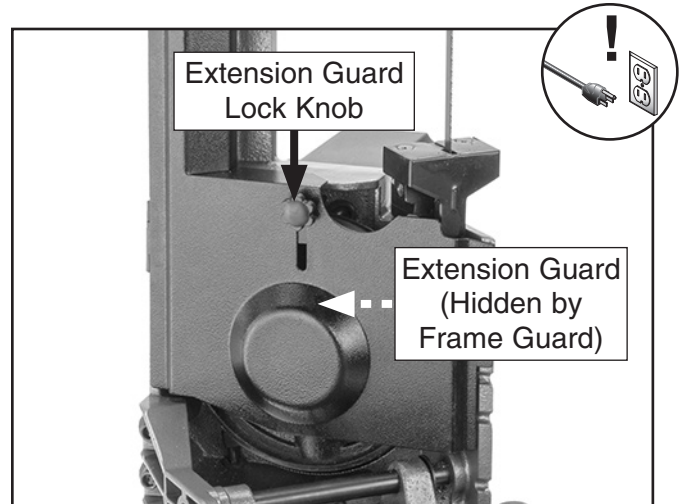


Figure 46. Extension guard in raised position.

<p>! CAUTION Before proceeding with the next step, wear gloves to protect your hands while handling and installing the blade.</p>
--

6. While wearing heavy gloves, open frame guard and remove blade from wheels.



7. Install new blade through both blade guide bearings, as shown in **Figure 47**, and around bottom wheel.

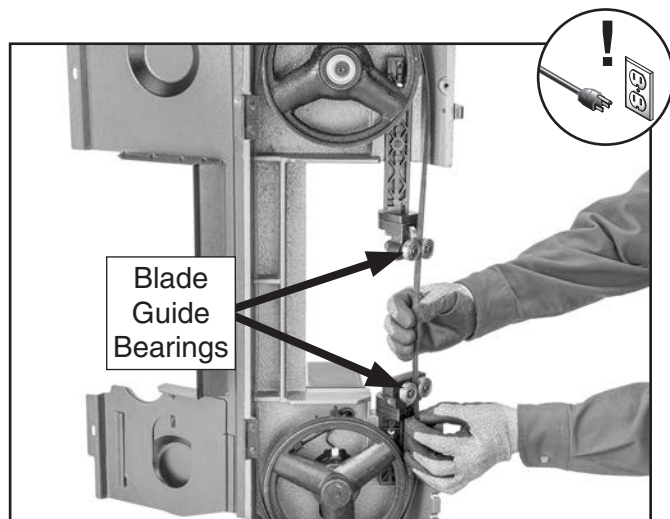


Figure 47. Installing blade.

8. Hold blade around bottom wheel with one hand and slip it around top wheel with other hand, keeping blade between blade guide bearings.

Note: It is sometimes possible to flip blade inside out, in which case blade will be installed in wrong direction. Check to make sure blade teeth are facing toward workpiece, as shown in **Figure 48**, after mounting to bandsaw. Some blades will have a directional arrow to use as a guide.

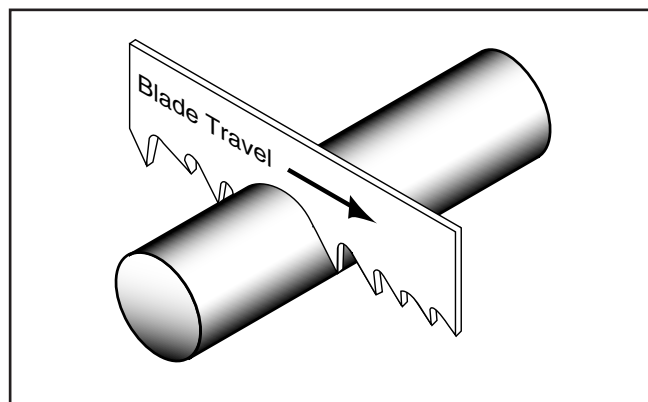


Figure 48. Blade cutting direction.

9. When blade is around both wheels, adjust position so back of blade is against wheel shoulder (see **Figure 49**).

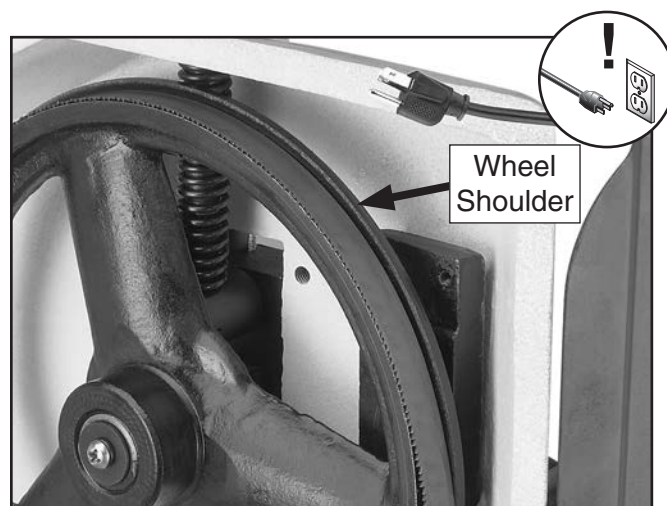


Figure 49. Example of blade positioned against wheel shoulder.

10. While holding blade in place, tighten blade tension knob so blade will not slip on wheels upon start up.
11. While keeping body parts away from blade and machine, connect machine to power.
12. Turn blade speed dial to slowest speed and briefly turn machine **ON** then **OFF** to position blade and resume previous tracking.

— Refer to **Step 6** of **Adjusting Blade Tracking** in next section to determine whether or not blade tracking needs adjustment.



Adjusting Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly, but verify tracking whenever you change blades or the **Troubleshooting** section on **Page 35** indicates a blade tracking problem.

Tools Needed	Qty
Phillips Head Screwdriver #2	1
Wrench or Socket 13mm	1

To adjust blade tracking:

1. DISCONNECT MACHINE FROM POWER!
2. Raise headstock fully and use head-locking pin to keep headstock in place.
3. Remove (2) Phillips head screws and flat washers shown in **Figure 50**.

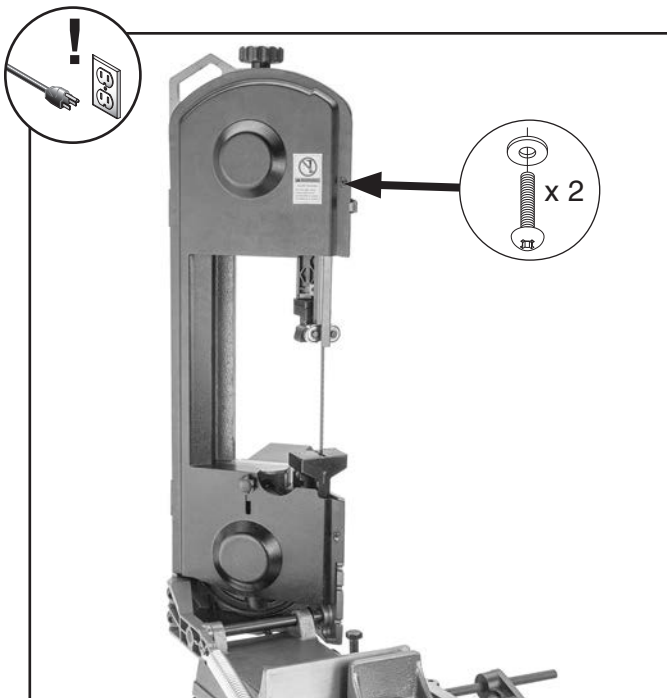


Figure 50. Location of Phillips head screws.

4. Loosen extension guard lock knob, fully raise extension guard, and tight lock knob to secure (see **Figure 51**).

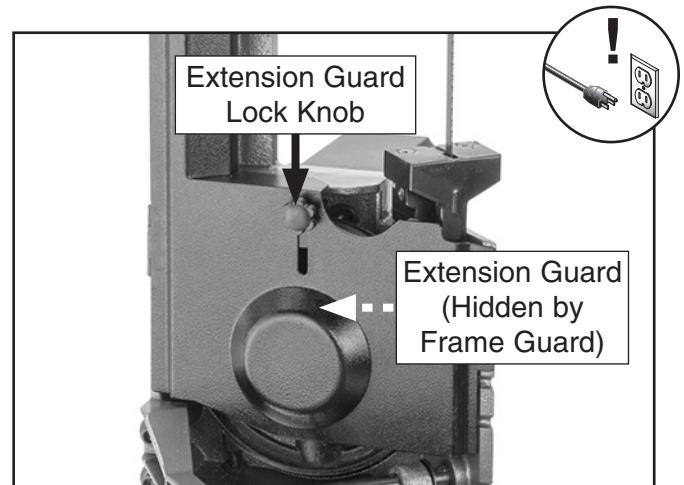


Figure 51. Extension guard in raised position.

5. Open frame guard and, while keeping body parts away from blade and machine, connect machine to power.
6. Turn blade speed dial to slowest speed, and turn machine **ON** to observe tracking.

— If blade tracks along wheel shoulder (without rubbing), blade is tracking properly and no adjustment is required.

— If blade walks away from wheel shoulder or hits shoulder, turn bandsaw **OFF**, disconnect from power, and proceed to **Step 7**.

7. Loosen, but do not remove, hex bolt shown in **Figure 52**.

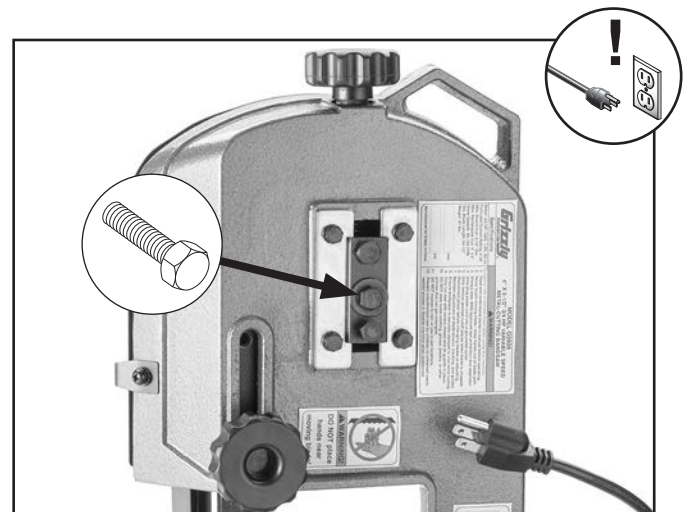


Figure 52. Blade tracking adjustments.



8. Use blade tension knob to release blade tension.
9. Adjust tracking hex bolt shown in **Figure 53**, then tighten lower hex bolt loosened in **Step 7**.
 - Tightening tracking hex bolt will move blade closer to shoulder.
 - Loosening tracking hex bolt will move blade away from shoulder.

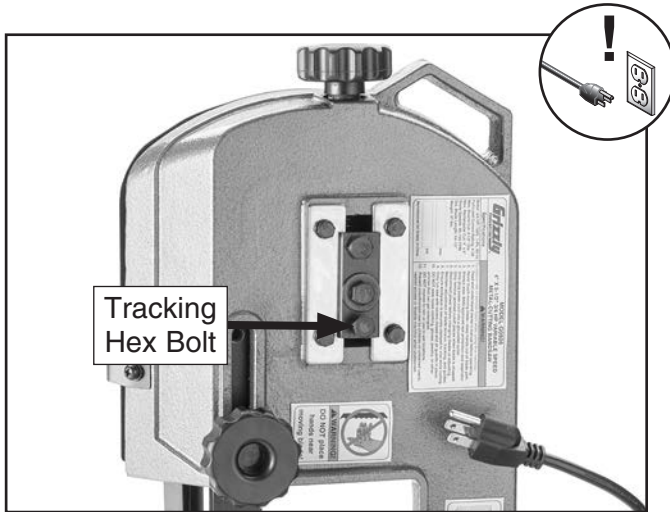


Figure 53. Location of tracking hex bolt.

10. Tension blade.
11. While keeping body parts away from blade and machine, connect machine to power.
12. Repeat **Steps 6–11** until blade tracks correctly.
13. **DISCONNECT MACHINE FROM POWER!**
14. Close frame guard and secure with (2) Phillips head screws removed in **Step 3**.

Tensioning Blade

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting times.

Two major signs that you do not have the correct blade tension are: 1) The blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too loose.

To tension blade:

1. Make sure blade is tracking properly (refer to **Adjusting Blade Tracking** on **Page 40**).
2. **DISCONNECT MACHINE FROM POWER!**
3. Loosen blade guide adjustment knob (see **Figure 54**) and slide guide as far from front guide as it will allow, then tighten knob.
4. Turn blade tension knob (see **Figure 54**) clockwise to tighten blade as tight as you can.

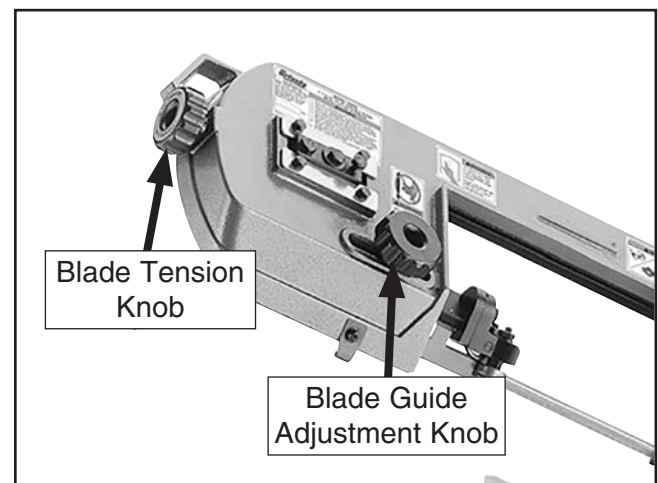


Figure 54. Blade tension components.

5. Using moderate finger pressure, push against side of blade. Blade should not move more than 0.004".

Note: We recommend using a blade tensioning gauge, like the one found in **ACCESSORIES** on **Page 32**. If you use this option, please follow instructions included with gauge.



Adjusting Downfeed Stop Bolt

If the blade does not travel far enough to complete the cut, or the blade contacts the vise table, then the downfeed stop bolt will need to be adjusted.

Tools Needed	Qty
Open-Ended Wrench 19mm.....	1

To adjust downfeed stop bolt:

1. DISCONNECT MACHINE FROM POWER!
2. Lower headstock all the way.
 - If blade is just below vise table, but not contacting it, no adjustment is required.
 - If blade contacts vise table, proceed to **Step 3**.
 - If blade is above vise table, proceed to **Step 4**.
3. Raise headstock until blade is just below vise table surface and adjust downfeed stop bolt and nut to secure headstock position (see **Figure 55**). Adjustment is complete.
4. Adjust downfeed stop bolt until blade is just below vise table, but not contacting it (see **Figure 55**). Tighten jam nut to secure.

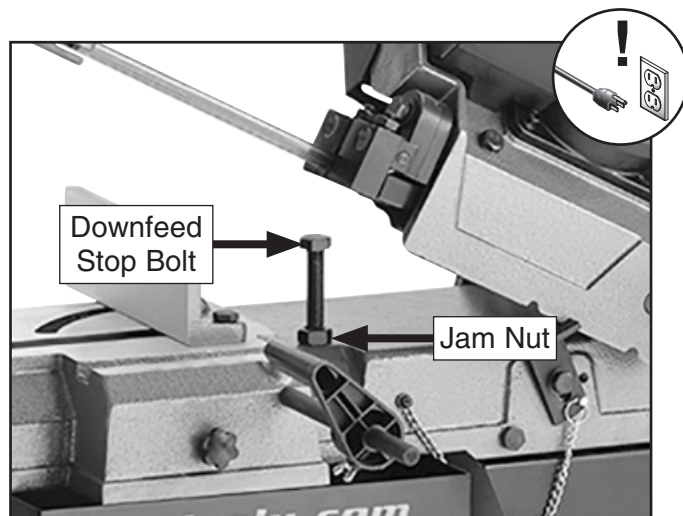


Figure 55. Location of downfeed stop bolt.

Squaring Blade to Table

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

Tools Needed	Qty
Machinist's Square	1
Wrench or Socket 13mm.....	1

To square blade to table:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen blade guide adjustment knob, slide guide as far from front guide as possible, and then tighten knob.
3. Lower headstock until it contacts downfeed stop bolt (see **Figure 56**).

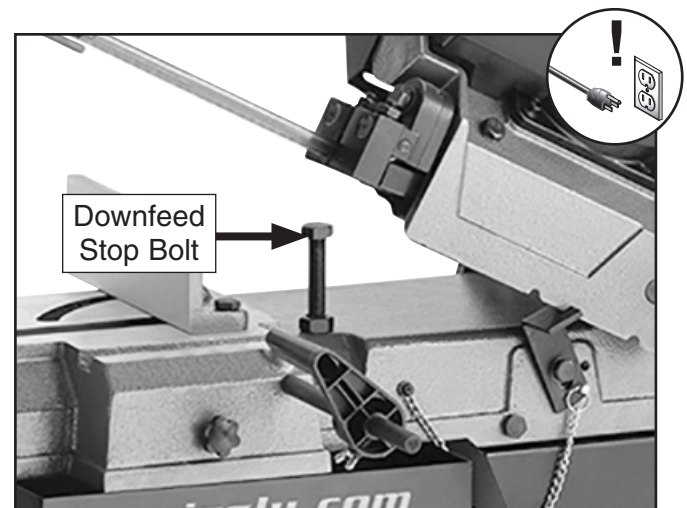


Figure 56. Location of downfeed stop bolt.



4. Place square on table bed and against edge of blade (see **Figure 57**), and check different points along length of table between blade guides.

5. Loosen hex bolt shown in **Figure 57**, and rotate blade guide seat until blade is perpendicular to bed, then tighten hex bolt.

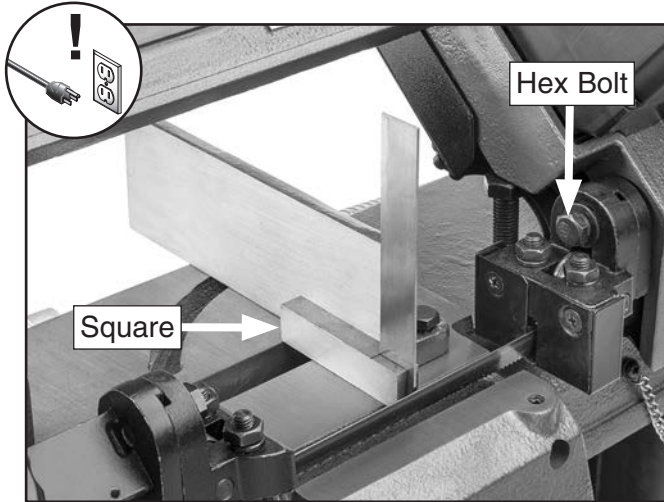


Figure 57. Squaring blade.

6. If adjustment from **Step 5** does not fully square blade to table, blade guide bearings can also be adjusted (refer to **Adjusting Blade Guide Bearings**).

Adjusting Blade Guide Bearings

The blade guide bearings must be properly adjusted to make square cuts. One bearing on each assembly has an eccentric bushing that allows it to be adjusted so the blade is square to the vise. The bearings are secured in place by a hex nut and lock washer, as shown in **Figure 58**.

Before adjusting the blade guide bearings, make sure that you have squared the blade to the table as discussed in the previous section.

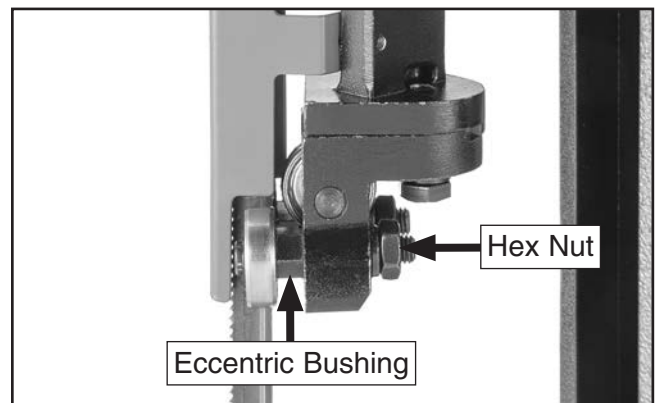


Figure 58. Blade guide adjustment components.

Tools Needed	Qty
Machinist's Square	1
Wrench or Socket 14mm	1
Open-Ended Wrench 13mm.....	1
Phillips Head Screwdriver #2	1

To adjust blade guide bearings:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust vise to 90°, then lock in place.



- Put square against face of vise and move it over to blade (see **Figure 59**).

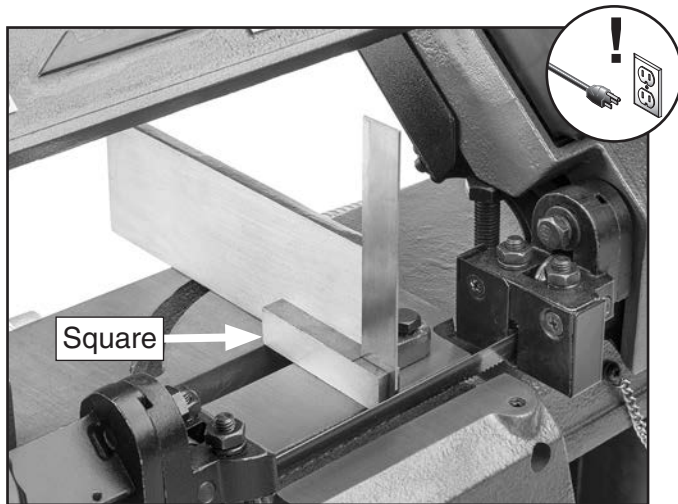


Figure 59. Square positioned against vise and blade to check blade squareness.

- If square evenly touches both face of vise and blade, no adjustment is necessary.
- If square *does not* evenly touch blade when evenly touching vise, proceed to **Step 4**.

- Loosen hex nuts securing eccentric bushings attached to guide bearings (see **Figure 58**).

Note: There is a guard on front blade guide assembly. Remove flat head screws shown in **Figure 60** to remove guard and access bushing.

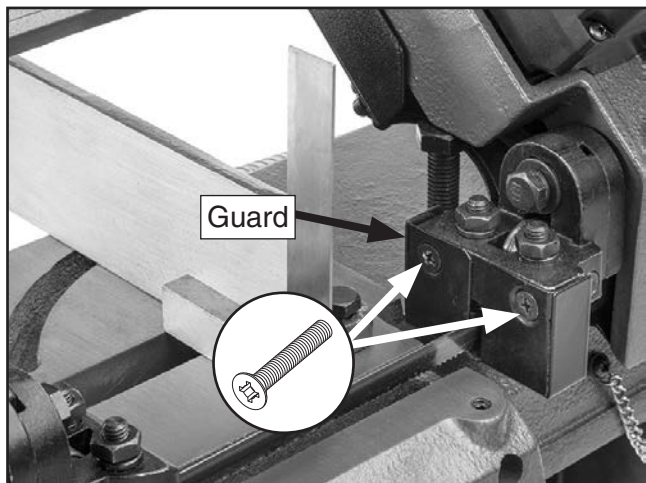


Figure 60. Front blade guide guard.

- Adjust bearings as necessary to force blade to be 90° to vise, then tighten hex nuts to secure.

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.

- Install front blade guide guard before resuming operation.



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.










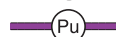

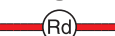

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

NOTICE

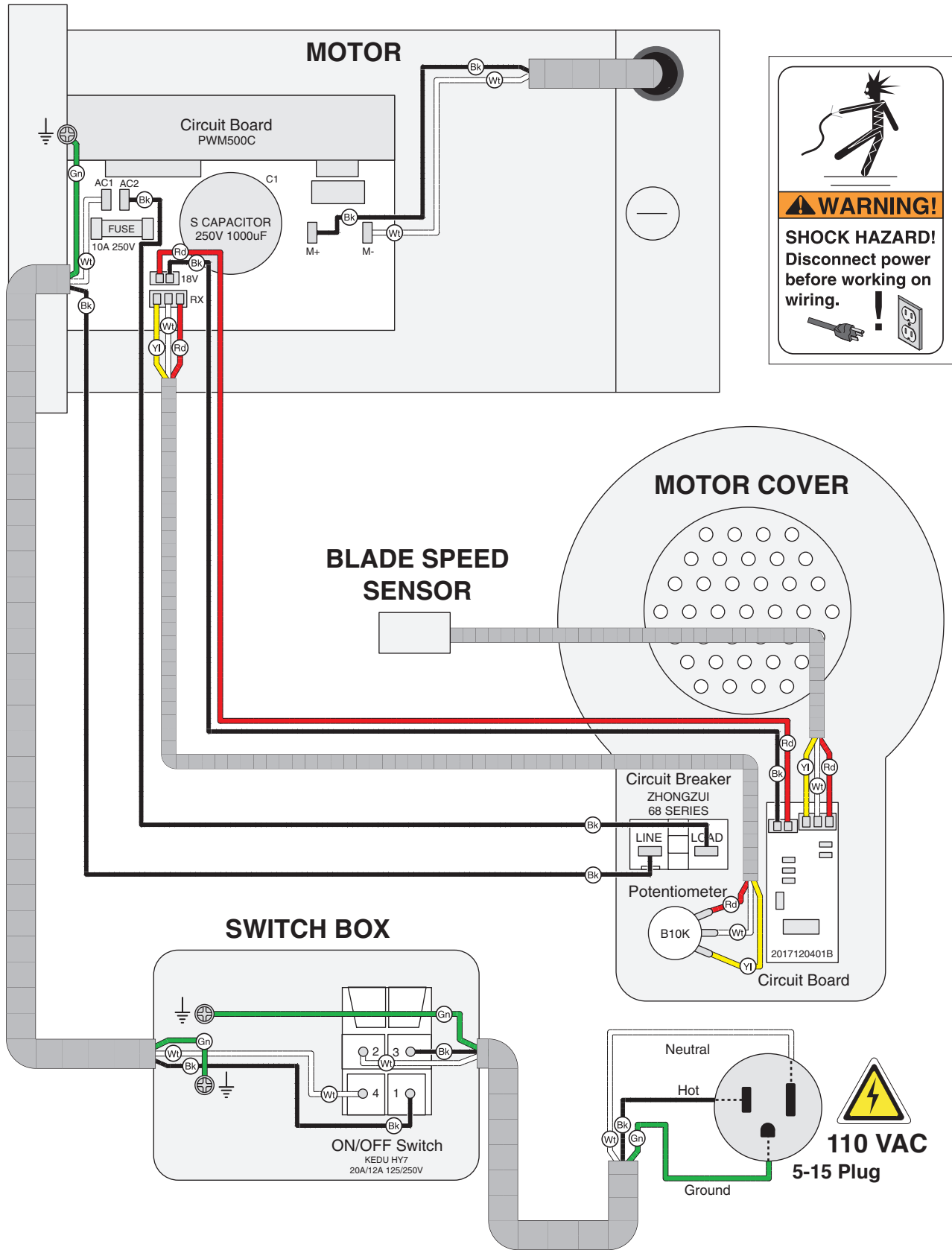
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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



Wiring Diagram



Electrical Component Photos

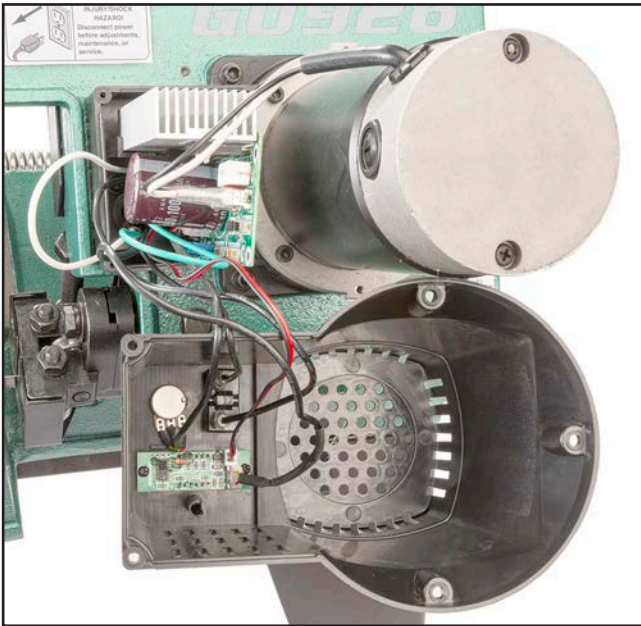


Figure 61. Speed controls wiring.

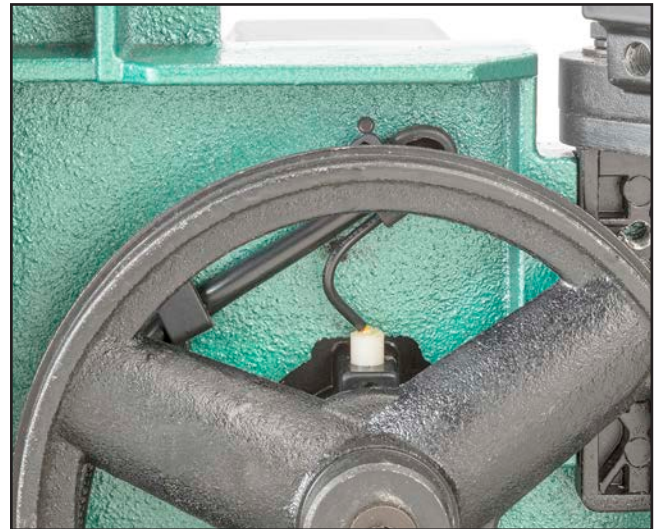


Figure 63. Speed sensor.



Figure 62. Circuit board wiring.

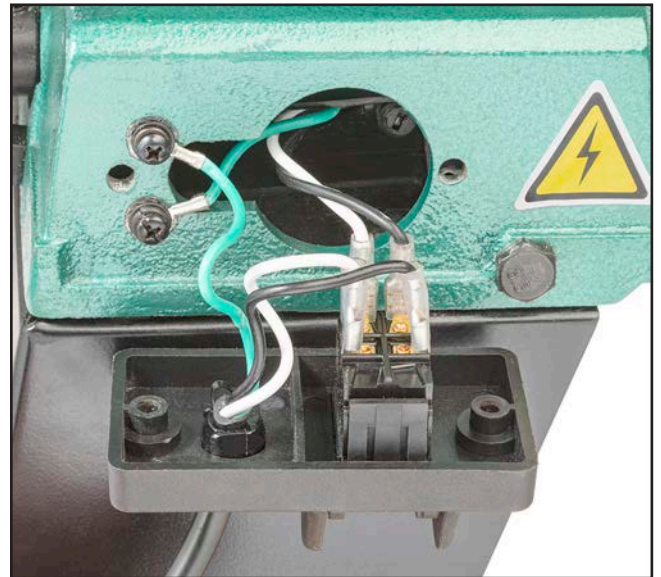
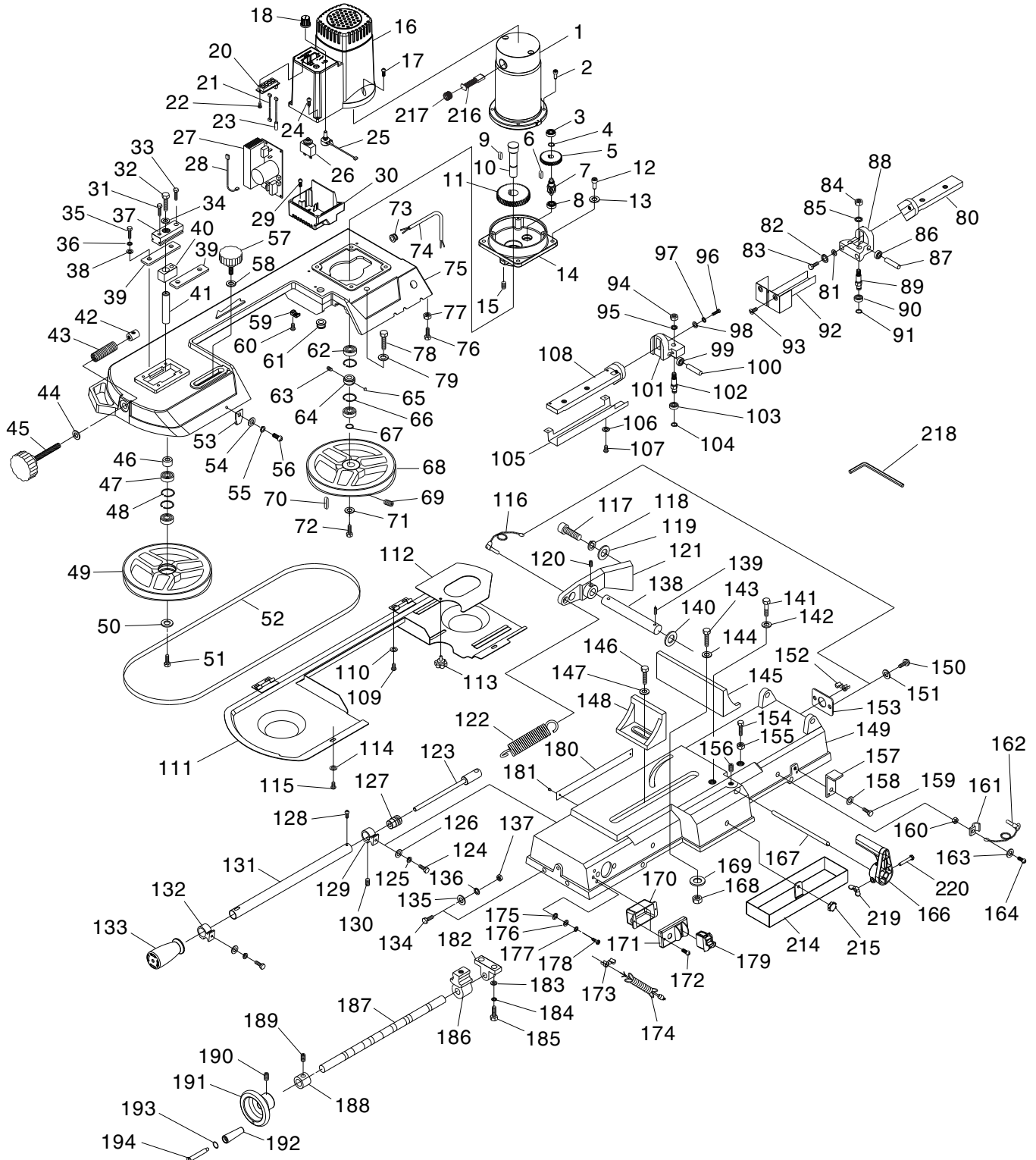


Figure 64. ON/OFF switch wiring.

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	P0926001	MOTOR 3/4HP 120V 1-PH
2	P0926002	CAP SCREW M5-.8 X 16
3	P0926003	BALL BEARING 607ZZ
4	P0926004	EXT RETAINING RING 11MM
5	P0926005	GEAR 43T
6	P0926006	KEY 4 X 4 X 6 RE
7	P0926007	GEAR 10T
8	P0926008	BALL BEARING 607ZZ
9	P0926009	KEY 5 X 5 X 10 RE
10	P0926010	WHEEL SHAFT (FRONT)
11	P0926011	GEAR 50T
12	P0926012	CAP SCREW M6-1 X 20
13	P0926013	FLAT WASHER 6MM
14	P0926014	GEARBOX
15	P0926015	SET SCREW M6-1 X 6
16	P0926016	MOTOR COVER
17	P0926017	PHLP HD SCR M4-.7 X 10
18	P0926018	BLADE SPEED DIAL
20	P0926020	DIGITAL SPEED DISPLAY 2017120401B
21	P0926021	DISPLAY WIRE
22	P0926022	TAP SCREW M3 X 10
23	P0926023	SPEED SENSOR 45L
24	P0926024	TAP SCREW M3.5 X 20
25	P0926025	POTENTIOMETER BK10
26	P0926026	CIRCUIT BREAKER ZHONGZUI 68-SERIES 4A
27	P0926027	CIRCUIT BOARD PWM500C
28	P0926028	CIRCUIT BREAKER WIRE
29	P0926029	PHLP HD SCR M5-.8 X 8
30	P0926030	CIRCUIT BOARD HOUSING
31	P0926031	HEX BOLT M8-1.25 X 30
32	P0926032	HEX BOLT M8-1.25 X 16
33	P0926033	HEX BOLT M8-1.25 X 30
34	P0926034	FLAT WASHER 8MM
35	P0926035	HEX BOLT M6-1 X 12
36	P0926036	LOCK WASHER 6MM
37	P0926037	TRACKING BRACKET
38	P0926038	FLAT WASHER 6MM
39	P0926039	TRACKING BRACKET MOUNT
40	P0926040	TRACKING ADJUSTMENT BLOCK
41	P0926041	WHEEL SHAFT (REAR)
42	P0926042	BLADE TENSION NUT
43	P0926043	COMPRESSION SPRING 2 X 14 X 76
44	P0926044	FLAT WASHER 10MM
45	P0926045	KNOB BOLT M10-1.5 X 90, 12-LOBE, D60
46	P0926046	BUSHING 16 X 19 X 6.5
47	P0926047	BALL BEARING 6202ZZ
48	P0926048	EXT RETAINING RING 35MM
49	P0926049	BLADE WHEEL (REAR)
50	P0926050	FLAT WASHER 5MM
51	P0926051	HEX BOLT M5-.8 X 16
52	P0926052	BLADE 64-1/2" X 1/2" X 1/4" 14 TPI
53	P0926053	AUTO-OFF TAB
54	P0926054	FLAT WASHER 6MM
55	P0926055	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
56	P0926056	PHLP HD SCR M6-1 X 16
57	P0926057	KNOB BOLT M10-1.5 X 30, 12-LOBE, D60
58	P0926058	FLAT WASHER 10MM
59	P0926059	CORD CLAMP
60	P0926060	BUTTON HD CAP SCR M5-.8 X 12
61	P0926061	GROMMET 5/16"
62	P0926062	BALL BEARING 6202ZZ
63	P0926063	SET SCREW M6-1 X 6
64	P0926064	MAGNET SEAT
65	P0926065	MAGNET 6 X 3MM
66	P0926066	EXT RETAINING RING 35MM
67	P0926067	INT RETAINING RING 15MM
68	P0926068	BLADE WHEEL (FRONT)
69	P0926069	SET SCREW M8-1.25 X 8
70	P0926070	KEY 5 X 5 X 25 RE
71	P0926071	FLAT WASHER 5MM
72	P0926072	HEX BOLT M5-.8 X 16
73	P0926073	GROMMET 5/16"
74	P0926074	MOTOR DRIVER CORD 18G 3W 45"
75	P0926075	FRAME
76	P0926076	HEX BOLT M6-1 X 25
77	P0926077	HEX NUT M6-1
78	P0926078	HEX BOLT M8-1.25 X 30
79	P0926079	FLAT WASHER 8MM
80	P0926080	BLADE GUIDE BASE (FRONT)
81	P0926081	FLAT WASHER 8MM
82	P0926082	LOCK WASHER 8MM
83	P0926083	HEX BOLT M8-1.25 X 30
84	P0926084	HEX NUT M8-1.25
85	P0926085	LOCK WASHER 8MM
86	P0926086	BALL BEARING 629ZZ
87	P0926087	BLADE GUIDE PIN (FRONT)
88	P0926088	BLADE GUIDE (FRONT)
89	P0926089	BLADE GUIDE SHAFT (FRONT)
90	P0926090	BALL BEARING 629ZZ
91	P0926091	EXT RETAINING RING 9MM
92	P0926092	BLADE GUARD (FRONT)
93	P0926093	FLAT HD SCR M6-1 X 16
94	P0926094	HEX NUT M8-1.25
95	P0926095	LOCK WASHER 8MM
96	P0926096	HEX BOLT M8-1.25 X 30
97	P0926097	LOCK WASHER 8MM
98	P0926098	FLAT WASHER 8MM
99	P0926099	BALL BEARING 629ZZ
100	P0926100	BLADE GUIDE PIN (REAR)
101	P0926101	BLADE GUIDE (REAR)
102	P0926102	BLADE GUIDE SHAFT (REAR)
103	P0926103	BALL BEARING 629ZZ
104	P0926104	EXT RETAINING RING 9MM
105	P0926105	BLADE GUARD (REAR)
106	P0926106	FLAT WASHER 4MM
107	P0926107	PHLP HD SCR M4-.7 X 6
108	P0926108	BLADE GUARD BASE (REAR)
109	P0926109	PHLP HD SCR M4-.7 X 8



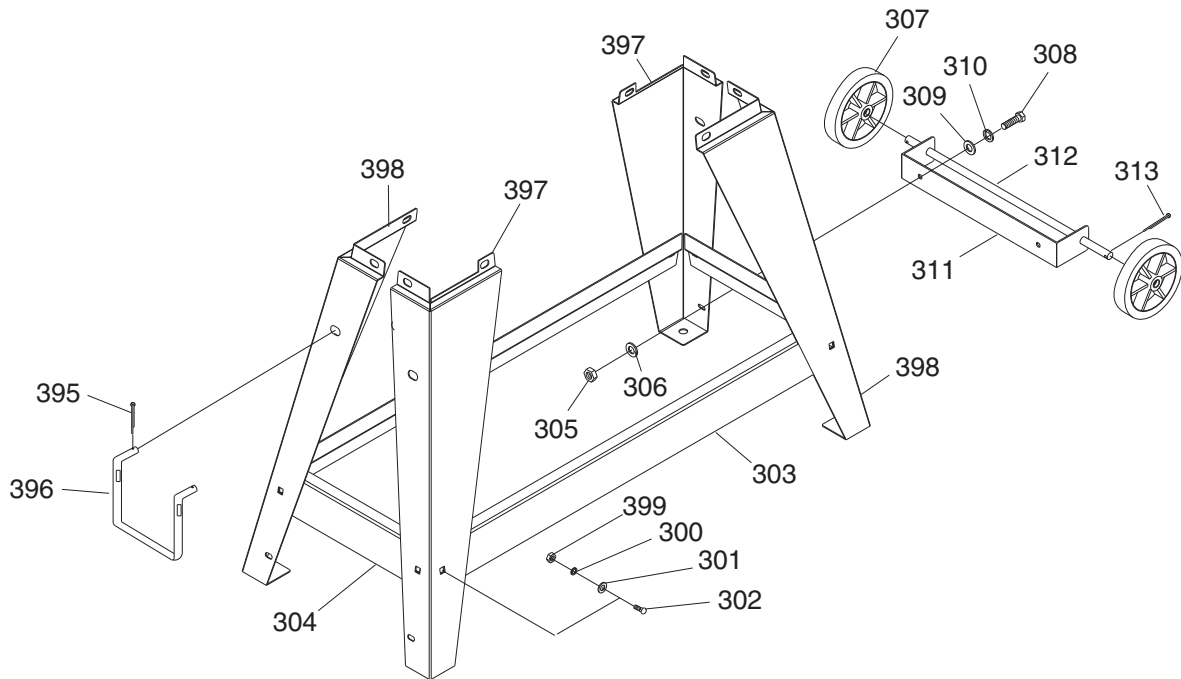
Main Parts List (Cont.)

REF	PART #	DESCRIPTION
110	P0926110	FLAT WASHER 4MM
111	P0926111	FRAME GUARD
112	P0926112	EXTENSION GUARD
113	P0926113	KNOB BOLT M6-1 X 8, 6-LOBE, D25
114	P0926114	FLAT WASHER 5MM
115	P0926115	PHLP HD SCR M5-.8 X 8
116	P0926116	LOCKING PIN W/CHAIN
117	P0926117	CAP SCREW M10-1.5 X 35
118	P0926118	LOCK WASHER 10MM
119	P0926119	FLAT WASHER 10MM
120	P0926120	SET SCREW M8-1.25 X 8
121	P0926121	PIVOT BLOCK
122	P0926122	EXTENSION SPRING 4.5 X 22 X 215
123	P0926123	SPRING ADJUSTMENT SCREW
124	P0926124	HEX BOLT M6-1 X 16
125	P0926125	LOCK WASHER 6MM
126	P0926126	FLAT WASHER 6MM
127	P0926127	FEED RATE ADJUSTMENT NUT
128	P0926128	PHLP HD SCR M4-.7 X 6
129	P0926129	ADJUSTMENT ROD BRACKET
130	P0926130	SET SCREW M8-1.25 X 8
131	P0926131	FEED RATE ADJUSTMENT ROD
132	P0926132	ADJUSTMENT ROD BRACKET
133	P0926133	FEED RATE ADJUSTMENT HANDLE
134	P0926134	HEX BOLT M8-1.25 X 20
135	P0926135	FLAT WASHER 8MM
136	P0926136	LOCK WASHER 8MM
137	P0926137	HEX NUT M8-1.25
138	P0926138	PIVOTING ROD
139	P0926139	ROLL PIN 4 X 25
140	P0926140	FLAT WASHER 16MM
141	P0926141	SHOULDER BOLT M8-1.25 X 13, 9 X 12
142	P0926142	FLAT WASHER 8MM
143	P0926143	HEX BOLT M8-1.25 X 40
144	P0926144	FLAT WASHER 8MM
145	P0926145	FIXED VISE JAW
146	P0926146	HEX BOLT M10-1.5 X 25
147	P0926147	FLAT WASHER 10MM
148	P0926148	SLIDING VISE JAW
149	P0926149	BASE
150	P0926150	PHLP HD SCR M5-.8 X 8
151	P0926151	FLAT WASHER 5MM
152	P0926152	STRAIN RELIEF TYPE-1 5/16"
153	P0926153	STRAIN RELIEF MOUNTING PLATE
154	P0926154	HEX BOLT M12-1.75 X 70
155	P0926155	HEX NUT M12-1.75

REF	PART #	DESCRIPTION
156	P0926156	SET SCREW M8-1.25 X 16
157	P0926157	VERTICAL LOCKING BRACKET
158	P0926158	FLAT WASHER 8MM
159	P0926159	HEX BOLT M8-1.25 X 16
160	P0926160	HEX NUT M5-.8
161	P0926161	CORD CLAMP
162	P0926162	LOCKING PIN W/CHAIN
163	P0926163	FLAT WASHER 5MM
164	P0926164	PHLP HD SCR M5-.8 X 18
166	P0926166	WORK STOP
167	P0926167	WORK STOP ROD
168	P0926168	HEX NUT M8-1.25
169	P0926169	FLAT WASHER 8MM
170	P0926170	SWITCH BOX
171	P0926171	SWITCH MOUNTING PLATE
172	P0926172	TAP SCREW M4.2 X 30
173	P0926173	STRAIN RELIEF TYPE-1 5/16"
174	P0926174	POWER CORD 18G 3W 72" 5-15P
175	P0926175	BELLEVILLE LOCK WASHER 5MM
176	P0926176	FLAT WASHER 5MM
177	P0926177	LOCK WASHER 5MM
178	P0926178	PHLP HD SCR M5-.8 X 8
179	P0926179	ON/OFF SWITCH KEDU HY7
180	P0926180	ANGLE SCALE
181	P0926181	RIVET 2 X 6 NAMEPLATE, STEEL
182	P0926182	LEADSCREW MOUNTING BLOCK
183	P0926183	FLAT WASHER 6MM
184	P0926184	LOCK WASHER 6MM
185	P0926185	HEX BOLT M6-1 X 18
186	P0926186	WISE NUT M16-4 TR LH
187	P0926187	LEADSCREW M16-4 TR LH
188	P0926188	LEADSCREW LOCK COLLAR
189	P0926189	SET SCREW M6-1 X 6
190	P0926190	SET SCREW M8-1.25 X 8
191	P0926191	HANDWHEEL TYPE-28 80D X 15B X M6-1
192	P0926192	HOLLOW HANDLE 40 X 75, 8
193	P0926193	O-RING 8.5 X 1.5 S9
194	P0926194	SHOULDER SCREW M6-1 X 8, 8 X 47
214	P0926214	CHIP TRAY
215	P0926215	KNOB BOLT M8-1.5 X 16, 6-LOBE, D25
216	P0926216	CARBON BRUSH (2-PC SET)
217	P0926217	CARBON BRUSH COVER
218	P0926218	HEX WRENCH 4MM
219	P0926219	WING NUT M5-.8
220	P0926220	HEX BOLT M5-.8 X 30



Stand

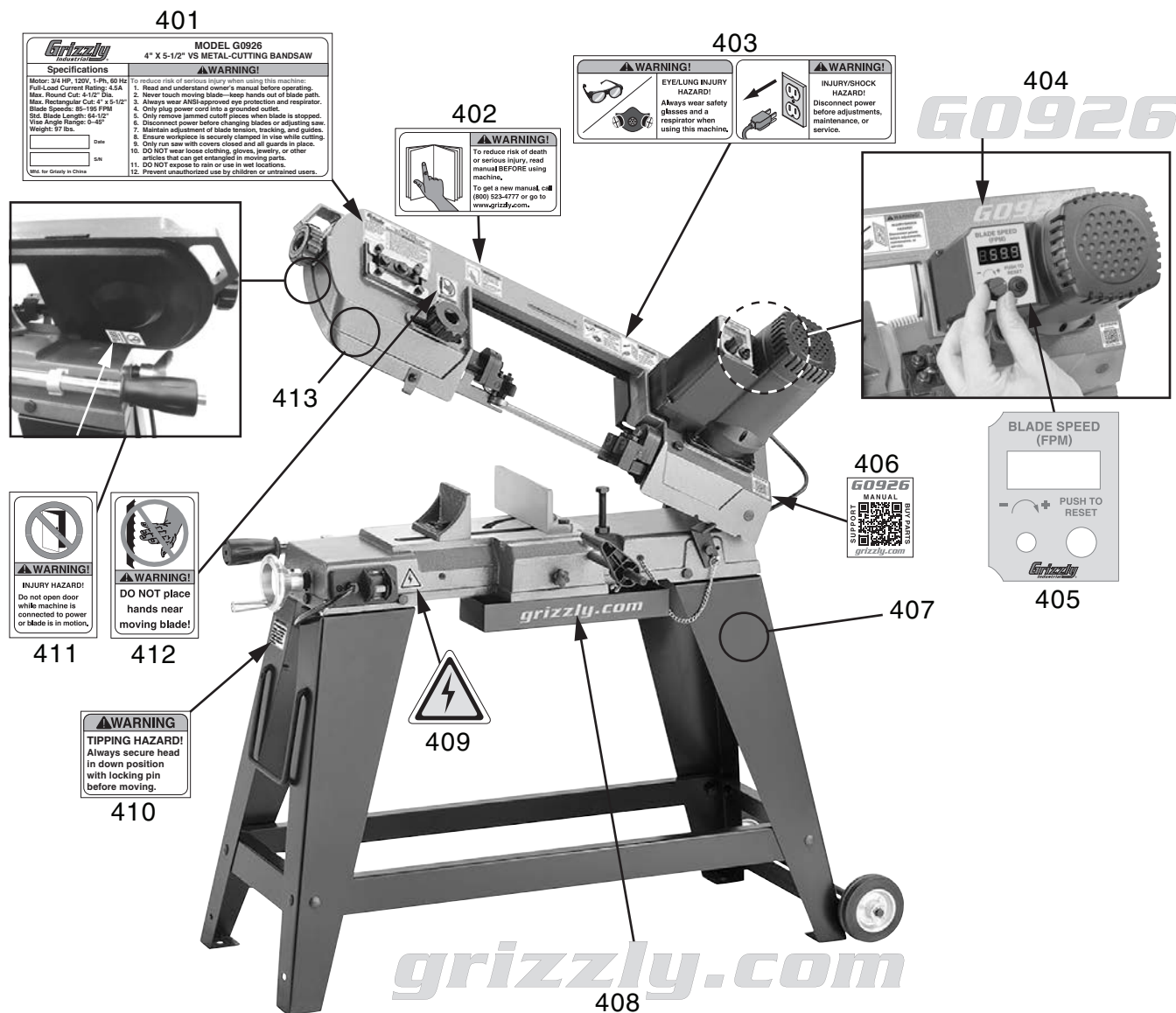


REF	PART #	DESCRIPTION
300	P0926300	LOCK WASHER 8MM
301	P0926301	FLAT WASHER 8MM
302	P0926302	CARRIAGE BOLT M8-1.25 X 16
303	P0926303	BRACE (LONG)
304	P0926304	BRACE (SHORT)
305	P0926305	HEX NUT M6-1
306	P0926306	FLAT WASHER 6MM
307	P0926307	WHEEL 4"
308	P0926308	HEX BOLT M6-1 X 12
309	P0926309	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
310	P0926310	LOCK WASHER 6MM
311	P0926311	AXLE BRACKET
312	P0926312	AXLE
313	P0926313	COTTER PIN 2.5 X 20MM STANDARD
395	P0926395	COTTER PIN 2.5 X 20MM STANDARD
396	P0926396	TRANSPORT HANDLE
397	P0926397	LEG (RIGHT, FRONT)
398	P0926398	LEG (LEFT, FRONT)
399	P0926399	HEX NUT M8-1.25



Labels & Cosmetics



REF	PART #	DESCRIPTION
401	P0926401	MACHINE ID LABEL
402	P0926402	READ MANUAL LABEL
403	P0926403	EYE/LUNG/SHOCK INJURY LABEL
404	P0926404	MODEL NUMBER LABEL
405	P0926405	BLADE SPEED LABEL
406	P0926406	QR CODE LABEL
407	P0926407	TOUCH-UP PAINT, GRIZZLY BLACK

REF	PART #	DESCRIPTION
408	P0926408	GRIZZLY.COM LABEL
409	P0926409	ELECTRICITY LABEL
410	P0926410	TIPPING HAZARD LABEL
411	P0926411	DOOR CLOSED LABEL
412	P0926412	MOVING BLADE LABEL
413	P0926413	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/secureforms/warranty-card>, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.



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**

