

Grizzly ***Industrial, Inc.***®

MODEL G0524 **RIP SAW**

OWNER'S MANUAL

(For models manufactured since 9/21)



COPYRIGHT © NOVEMBER 2003 BY GRIZZLY INDUSTRIAL, INC., REVISED NOVEMBER, 2021 (SS)

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

#DS5689 PRINTED IN TAIWAN

V7.11.21



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

SECTION 1: SAFETY	2	SECTION 8: SERVICE	30
Safety Instructions for Machinery	2	About Service.....	30
Additional Safety for Rip Saws	4	Fence Alignment.....	30
SECTION 2: INTRODUCTION	5	V-Belt Tension	31
Contact Info.....	5	Fence Ride Height.....	32
Manual Accuracy	5	Pressure Rollers	33
Machine Data Sheet	6	Gibs.....	34
SECTION 3: POWER SUPPLY	8	SECTION 9: ACCESSORIES	35
SECTION 4: FEATURES.....	12	SECTION 10: PARTS	37
Controls & Components.....	12	Upper Saw Breakdown	37
Control Panel	13	Motors & Conveyor Track.....	39
SECTION 5: SETUP	14	Updated	39
Unpacking.....	14	Updated	40
Loose Parts Inventory.....	15	Main Spindle	41
Hardware Recognition Chart	17	Updated	41
Site Considerations.....	18	Head	43
Clean Up.....	18	Table & Cabinet.....	45
Placement.....	19	Auxiliary Rollers	47
Power Connection.....	19	Electrical Panel	48
Remove the Blade	21	Laser Guide	49
Test Run	21	Accessories.....	50
Scale Calibration.....	22	Troubleshooting	51
Dust Collection.....	23	G0524 Control Panel Wiring.....	52
Auxiliary Rollers	23	G0524 Electrical Box Wiring.....	53
SECTION 6: OPERATIONS	25	G0524 Main & Feed Motor Wiring.....	54
Safe Operation.....	25	WARRANTY & RETURNS	57
Adjusting Feed Rate	26		
Rip Cutting	26		
SECTION 7: MAINTENANCE.....	28		
Grease Fittings.....	28		
Gear Box.....	28		
V-Belts	29		
Lube System.....	29		

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.



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



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



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



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 Rip Saws

WARNING

BLADE GUARD. Always use the blade guard on all cutting operations.

KICKBACK. Be familiar with kickback. Kickback happens when the workpiece is thrown towards the operator at a high rate of speed. Until you have a clear understanding of kickback and how it occurs, DO NOT operate this saw!

WORKPIECE CONTROL. Make sure the workpiece is placed in a stable position on the table and is supported by the rip fence during cutting operations.

SAFETY ACCESSORIES. Use safety glasses, a respirator, and hearing protection to make cutting operations safe.

OPERATOR POSITION. Never stand or have any part of your body directly in-line with the cutting path of the saw blade.

STALLED BLADE. Turn the saw off and disconnect from the power source before attempting to “free” a stalled saw blade.

COMFORTABLE CUTTING OPERATIONS. Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the conveyor track.

EXPERIENCING DIFFICULTIES. If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Service Department at (570) 546-9663.

DAMAGED SAW BLADES. Never use blades that have been dropped or damaged; otherwise, serious personal injury could occur.

WARNING

Like all machines there is danger associated with the Model G0524. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility 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: 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:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety is correctly adjusted/setup and		
Weight:	power is connected to grounded circuit before starting.		
	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not use if damaged, or if exposed to drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		

Manufactured for Grizzly in Taiwan





MACHINE DATA SHEET

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

MODEL G0524 STRAIGHT LINE RIP SAW

Product Dimensions:

Weight 1980 lbs.
Width (side-to-side) x Depth (front-to-back) x Height 43-1/2 x 61-1/2 x 80-1/2 in.
Footprint (Length x Width) 35 x 35 in.

Shipping Dimensions:

Type Wood Crate
Content..... Machine
Weight..... 2243 lbs.
Length x Width x Height..... 59 x 46 x 64 in.
Must Ship Upright Yes

Electrical:

Power Requirement 220V or 440V, 3-Phase, 60 Hz
Pre-Wired Voltage..... 220V
Full-Load Current Rating..... 48.2A at 220V, 24.1A at 440V
Minimum Circuit Size 70A at 220V, 35A at 440V
Connection Type..... Permanent (Hardwire to Shutoff Switch)
Switch Type Control Panel w/Magnetic Switch Protection
Voltage Conversion Kit P0524067 for 440V
Recommended Phase Converter..... G7979

Motors:

Main

Type..... TEFC Induction
Horsepower 15 HP
Phase 3-Phase
Amps 42A/21A
Speed 1720 RPM
Power Transfer..... V-Belt Drive
Bearings Shielded & Permanently Lubricated

Feed

Type..... TEFC Induction
Horsepower 2 HP
Phase 3-Phase
Amps 6.2A/3.1A
Speed 1720 RPM
Power Transfer..... V-Belt Drive
Bearings Shielded & Permanently Lubricated



Main Specifications:

Operation Information

Max Blade Diameter.....	10 – 12 in.
Max Cutting Height.....	3-7/8 in.
Max Cutting Height w/Auxiliary Rollers	2-1/4 in.
Max Width of Cut.....	18 in.
Max Distance Blade to Column.....	18 in.
Min Length of Cut w/Auxiliary Hold-Down Roller Kit.....	8 in.
Arbor Size.....	1 in.
Spindle Speed	4500 RPM
Feed Speed.....	30 – 112 RPM

Construction

Table.....	Precision Machined Steel
Cabinet	Steel
Rails.....	Hardened & Precision-Ground Steel
Anti-Kickback Fingers.....	Steel
Spindle Bearings	Steel
Blade Guard	Pre-Formed Steel
Fence.....	Precision Machined Cast-Iron Body

Other Specifications:

Country of Origin.....	Taiwan
Warranty.....	1 Year
Approximate Assembly & Setup Time	15 Minutes
Serial Number Location	Machine ID Label
ISO 9001 Factory.....	No
Certified by a Nationally Recognized Testing Laboratory (NRTL).....	No

Features:

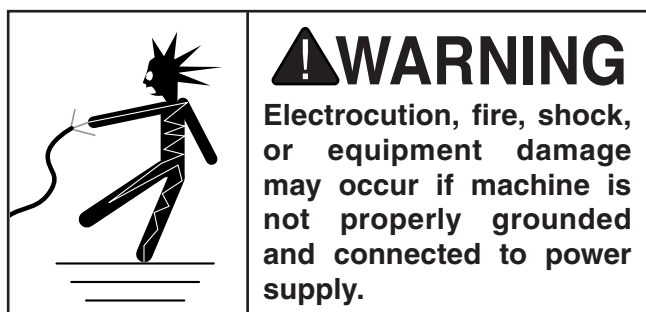
- Extra-Long Infeed Table and Rip Fence for Handling Large Workpieces
- Includes Auxiliary Hold-Down Roller Kit
- Variable Feed Conveyor
- 4 Heavy-Duty Pressure Rollers
- Adjustable Automatic Conveyor Track Lubrication System
- Convenient and Easy-to-Reach Control Panel
- Double Row of Anti-Kickback Fingers
- Dual Bearing Driveline for Conveyor Table
- Dual Spindle Elevation Lock
- Exclusive 6" Wide Chain Feeding Conveyor Table for Smooth Operation



SECTION 3: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrician or qualified service personnel in accordance with all applicable codes and standards.



Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 220V .. 48.2 Amps
Full-Load Current Rating at 440V .. 24.1 Amps

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

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

Circuit Information

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

! 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.*

Circuit Requirements for 220V

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

Nominal Voltage 220V, 230V, 240V
Cycle 60 Hz
Phase 3-Phase
Power Supply Circuit 70 Amps

Circuit Requirements for 440V

This machine can be converted to operate on a power supply circuit that has a verified ground and meets the requirements listed below. (Refer to **Voltage Conversion** instructions for details.)

Nominal Voltage 440V, 480V
Cycle 60 Hz
Phase 3-Phase
Power Supply Circuit 35 Amps



Note About Phase Converters: If your machine is connected to a phase converter, it **MUST** be a rotary-type. A static phase converter must not be used or motor and electrical component damage will occur.

The voltage from the manufactured power leg of the phase converter (sometimes called the wild leg or wild wire) can fluctuate. Connect the manufactured leg to the "S" terminal for incoming power (see location on **Page 53**). Otherwise, your machine may not start properly, and magnetic switch chatter or electrical component damage will occur.

Connection Type

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

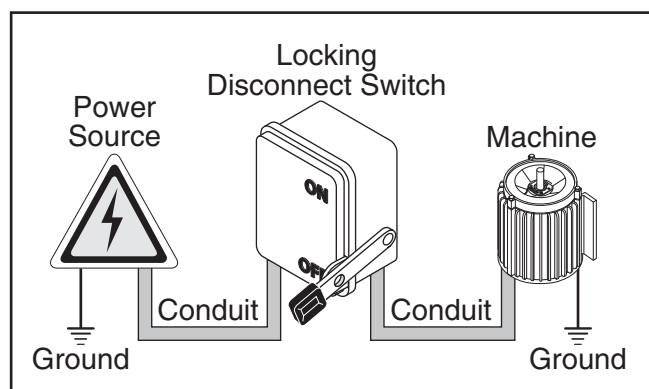


Figure 1. Typical setup of a permanently connected machine.

Grounding Instructions

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

WARNING

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

Extension Cords

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



Voltage Conversion

The Model G0524 can be converted for 440V operation. This conversion job consists of disconnecting the rip saw from the power source, changing wire connections on the transformer, changing the overload relays for the motors, and rewiring the motors.

The necessary conversion kit (P0524067V3) for this procedure can be purchased by calling our customer service number at (800) 523-4777.

All wiring changes must be inspected by a qualified electrician before the machine is connected to the power source. If you need help at any time during this procedure, call Grizzly Tech Support at (570) 546-9663.

NOTICE

Wiring diagrams in this manual were current at the time of printing; however, they will not reflect any future changes made in the spirit of improvement. Before doing any wiring work, **ALWAYS** carefully compare these diagrams with the machine to verify no changes have been made. If you have any doubt about diagrams not matching the machine, contact Grizzly Tech Support **BEFORE** proceeding.

To convert Model G0524 for 440V operation:

1. DISCONNECT MACHINE FROM POWER!
2. Open the electrical panel (see **Figure 2**).

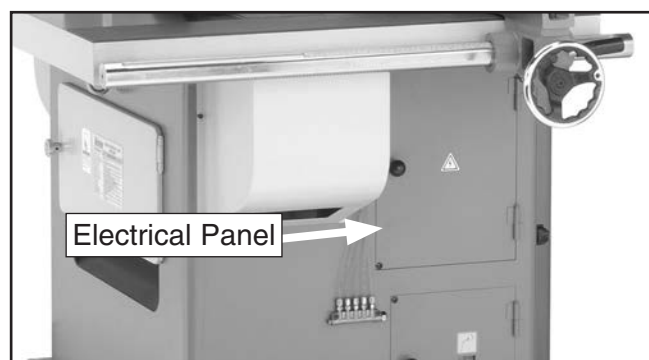


Figure 2. Location of electrical panel.

3. Remove the wire labeled "T" at the 220V terminal of the transformer (see **Figure 3**) and connect it to the 440V terminal.

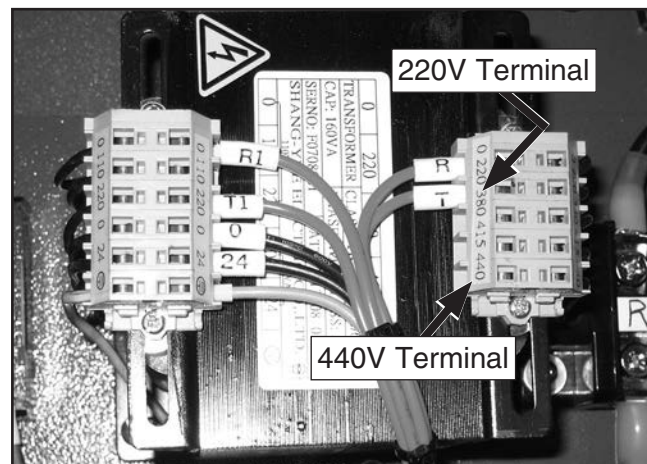


Figure 3. "T" wire connected to 220V post.

4. Remove RHU-10 (5.5-7.5A) overload relay (see **Figure 4**) and replace it with an RHU-10 (2.9-4A) overload relay. Set dial to 4A.

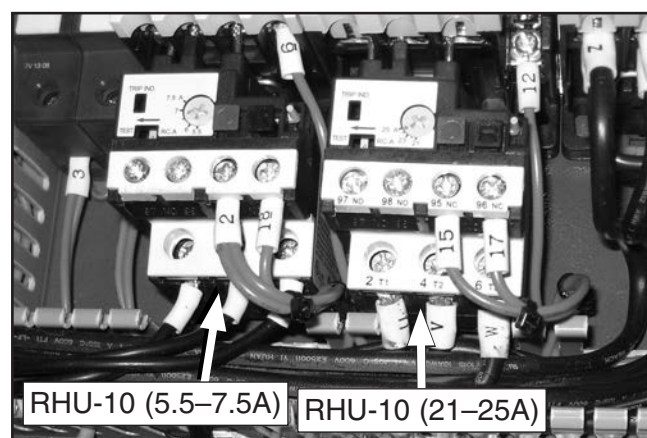


Figure 4. Overload relays.

5. Remove RHU-10 (21-25A) overload relay (see **Figure 4**) and replace it with an RHU-10 (11.3-16A) overload relay. Set dial to 12A.



6. Wire main motor as shown in **Figure 5**.

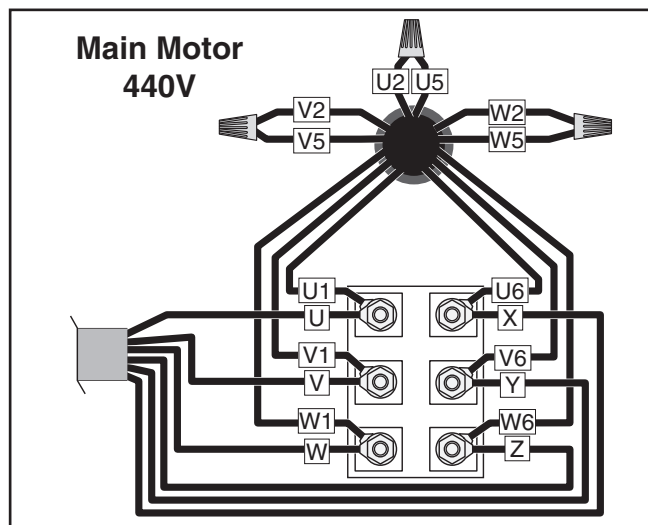


Figure 5. Main motor wired for 440V.

7. Wire feed motor as shown in **Figure 6**.

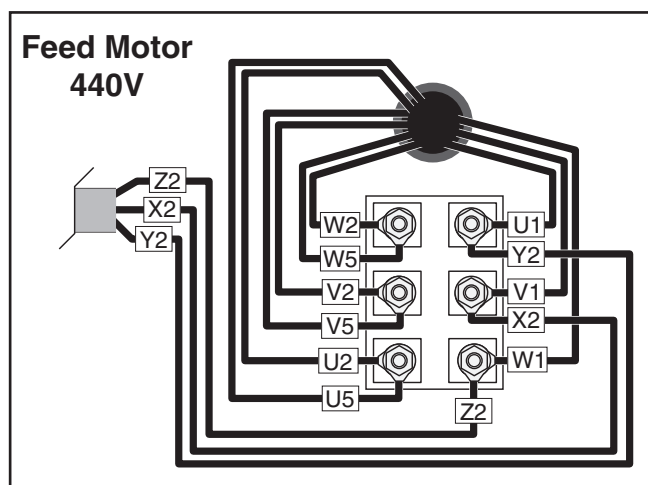


Figure 6. Feed motor wired for 440V.

NOTICE

Feed motor rotation must be counterclockwise to prevent permanent damage to caterpillar block. Before operating, remove belt from feed motor and test motor rotation.

8. Remove motor cover, then remove cog tooth belt from feed motor pulley (see **Figure 7**).

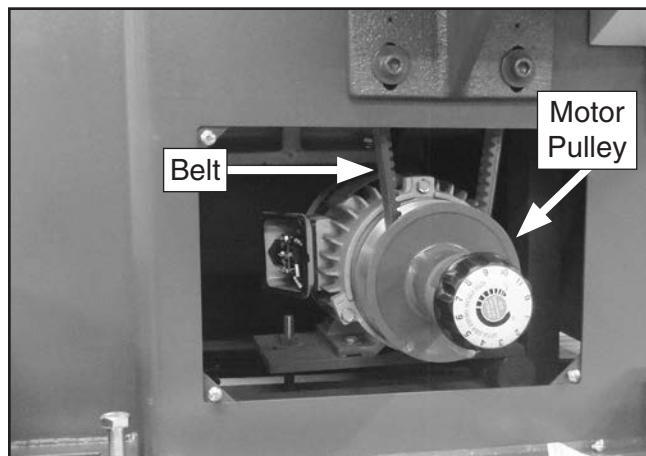


Figure 7. Feed motor components.

9. Connect machine to power. Press the Feed Motor Start Button to check counterclockwise rotation of feed motor pulley.

—If motor rotation is correct, proceed to **Step 10**.

—If motor rotation is incorrect, disconnect machine from power and swap wire connections X2 and Y2 (see **Figure 6**), then repeat **Step 9**.

10. Re-install cog tooth belt and motor cover.



SECTION 4: FEATURES

Controls & Components

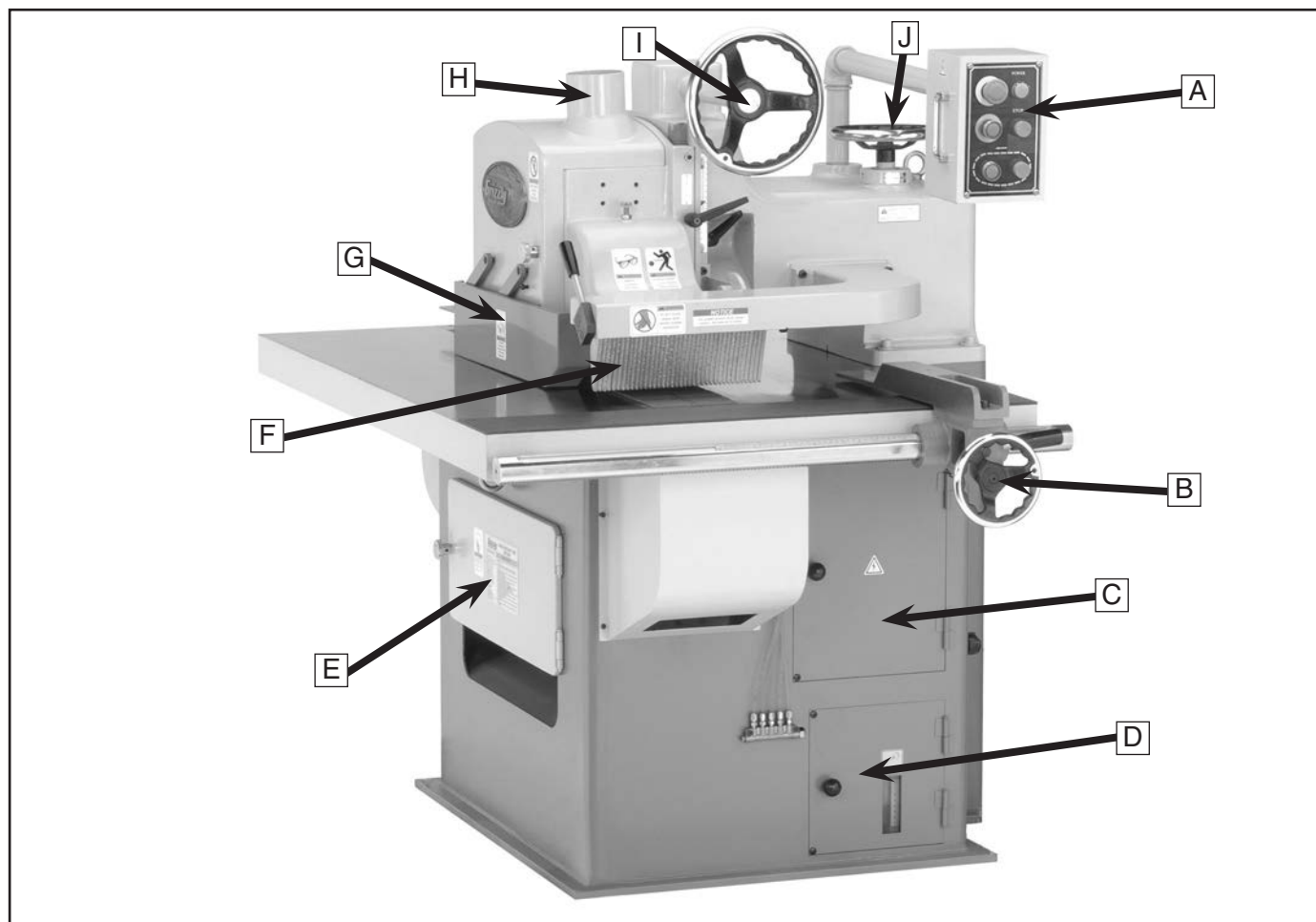


Figure 8. Front view.

- A. **Control Panel**—Location of the START & STOP buttons that power the saw.
- B. **Fence Handwheel**—Moves the rip fence along the fence rail.
- C. **Electrical Access Door**—Provides access to the electrical components.
- D. **Oil Reservoir Access Door**—Provides access to the oil reservoir.
- E. **Lower Conveyor Track Access Door**—Provides access to the conveyor track and the lubrication brushes.
- F. **Anti-Kickback Fingers**—Prevents the workpiece from being ejected out of the saw towards the operator.
- G. **Blade Guard**—Protects the operator and bystanders from the saw blade.
- H. **Dust Port**—4" dust hook-up for efficient dust extraction from the cutting operation.
- I. **Pressure Roller Height Handwheel**—Adjusts the height of the pressure roller assembly.
- J. **Blade Height Handwheel**—Adjusts the height of the saw blade. Note—*Only adjust the handwheel when making blade changes.*



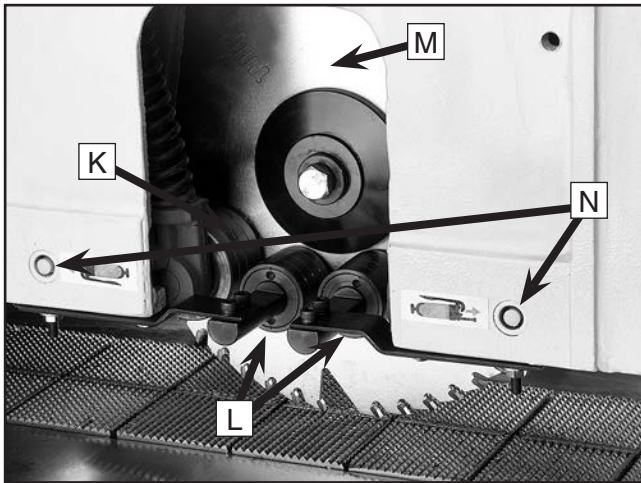


Figure 9. Blade compartment close-up.

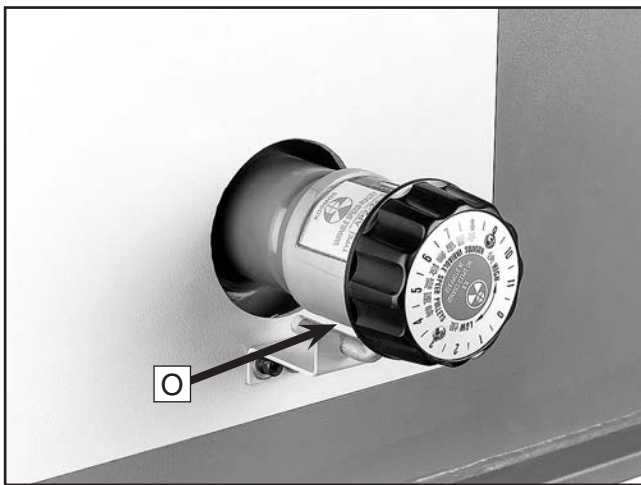


Figure 10. Variable speed knob close-up.

- K. Pressure Rollers**—(1 of 4) Holds the work-piece against the conveyor track during the cutting operation.
- L. Auxiliary Pressure Rollers**—(2 of 4) Must be used when rip cutting workpieces shorter than 8½" long.
- M. Saw Blade**—Performs the cutting operation.
- N. Lubrication Points**—(2 of 4) Grease fittings that need to be lubed periodically with a grease gun.
- O. Variable Speed Adjustment Knob**—Turn the dial clockwise to decrease the feed rate and counterclockwise to increase it. The feed rate is variable between 30-112 FPM.

Control Panel

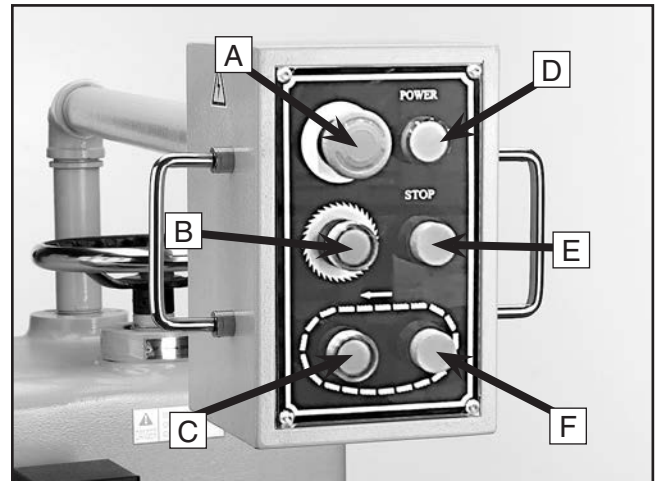
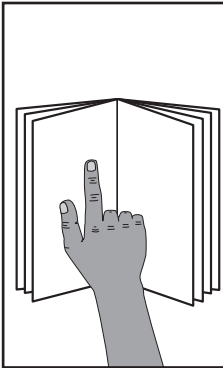


Figure 11. Control panel.

- A. EMERGENCY STOP Button**—Disconnects power to all motors in the motor cabinet.
- B. MAIN MOTOR START Button**—Starts the saw blade.
- C. FEED MOTOR START Button**—Starts the conveyor track.
- D. POWER Light**—Indicates there is power to the control panel.
- E. MAIN MOTOR STOP Button**—Stops the saw blade.
- F. FEED MOTOR STOP Button**—Stops the conveyor track.



SECTION 5: SETUP



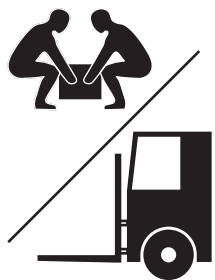
!WARNING

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.

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.*



Loose Parts Inventory



Figure 12. Tool Box Contents.

DESCRIPTION	QTY
A. T-Handle Wrench 19mm	1
B. Grease Gun	1
C. Combo Wrench 8 x 10mm	1
D. Combo Wrench 10 x 12mm	1
E. Combo Wrench 11 x 13mm	1
F. Combo Wrench 14 x 17mm	1
G. Combo Wrench 17 x 19mm	1
H. Combo Wrench 22 x 24mm	1
I. 10 pc Allen Wrench Set (1.5-10mm)	1
J. Arbor Wrench 45mm	1
K. Cast Iron Feet.....	4





Figure 13. Auxiliary Roller Box Contents.

DESCRIPTION	QTY
L. Auxiliary Roller Brackets (Left)	2
M. Auxiliary Roller Brackets (Right)	2
N. Auxiliary Rollers	4
O. Hardware Bag	1



Figure 14. Hardware Bag Contents.

DESCRIPTION	QTY
P. Cap Screws M6-1.0 x 16	8
Q. Setscrews M6-1.0 x 30	4
R. Lock Washers 6mm	8
S. Flat Washers 6mm	4
T. Hex Nuts 6-1.0	4



Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

○ #10

○ 1/4"

○ 5/16"

○ 3/8"

○ 7/16"

○ 1/2"

○ 5/8"

○ 4mm

○ 6mm

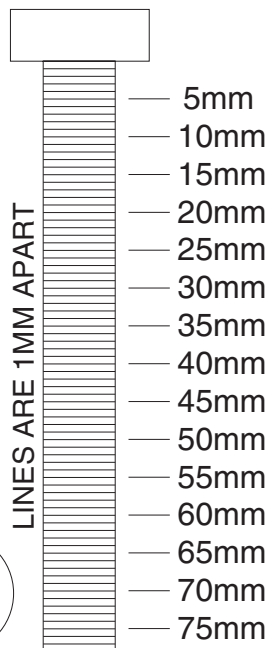
○ 8mm

○ 10mm

○ 12mm

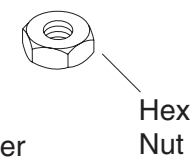
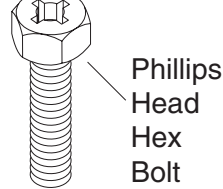
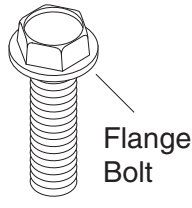
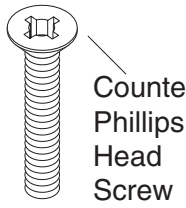
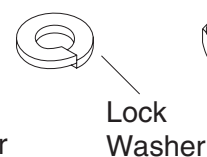
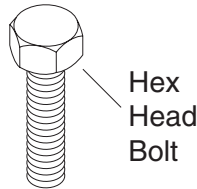
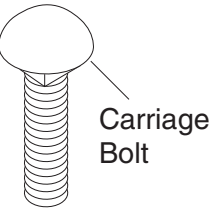
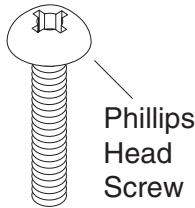
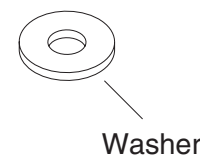
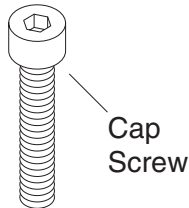
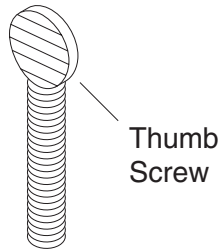
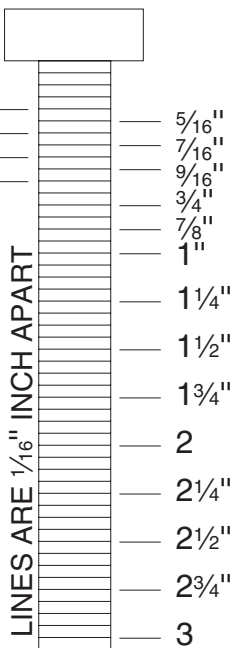
○ 16mm

LINES ARE 1MM APART

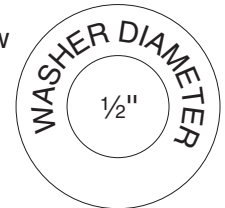
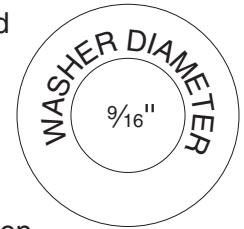
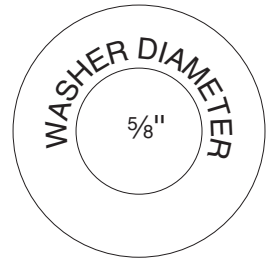
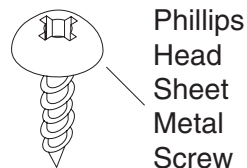
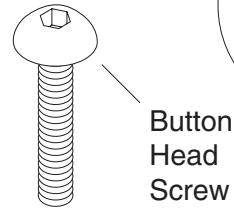
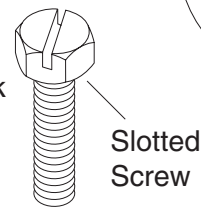


1/4"
3/8"
1/2"
5/8"

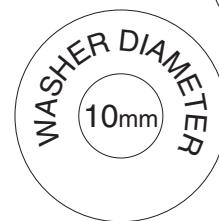
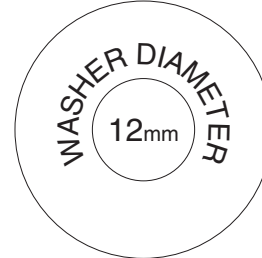
LINES ARE 1/16" INCH APART



Lock Nut



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Site Considerations

Floor Load

The Model G0524 weighs 1980 lbs. Most commercial floors are suitable for your machine. Some floors may require additional reinforcement to support the machine, the operator, and the workpiece.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 15** for the footprint of the Model G0524.

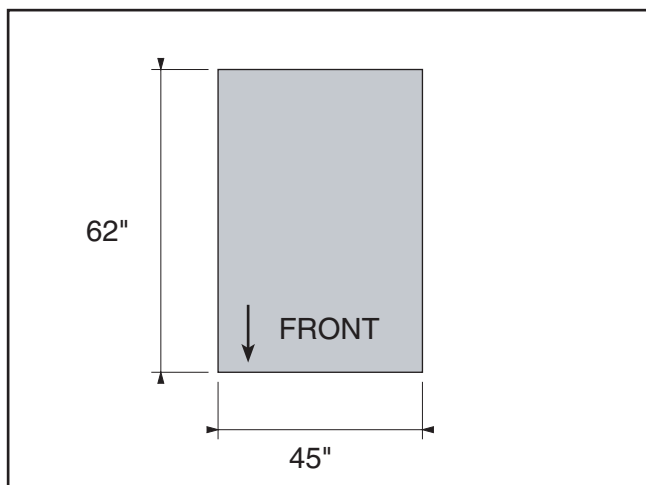
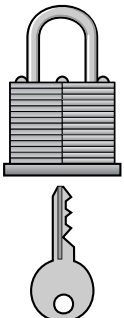




Figure 15. Model G0524 footprint.

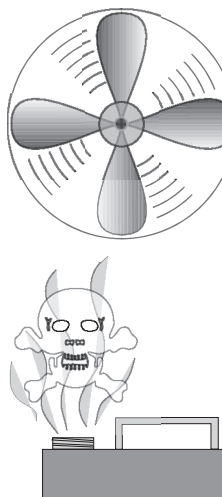
	<p>! CAUTION</p> <p>Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
---	--

Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact.

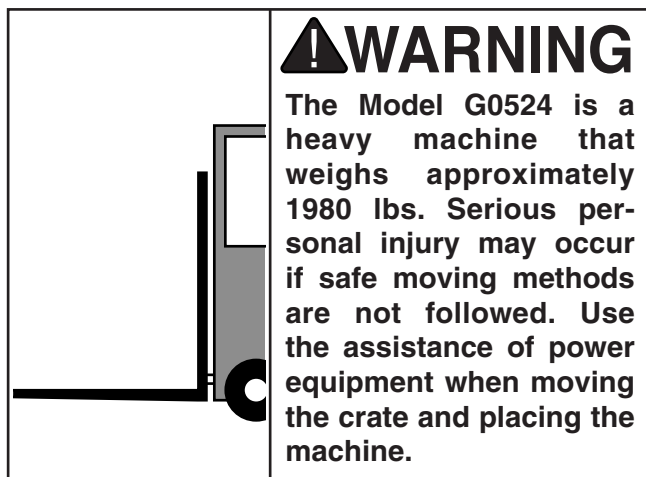
	<p>! WARNING</p> <p>Gasoline and petroleum products have low flash points and could explode if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
--	---

	<p>! WARNING</p> <p>Smoking near solvents could ignite an explosion or fire and cause serious injury. DO NOT smoke while using solvents.</p>
--	--

	<p>! WARNING</p> <p>Lack of ventilation while using solvents could cause serious personal health risks, fire, or environmental hazards. Always work in a well ventilated area to prevent the accumulation of dangerous fumes. Supply the work area with a constant source of fresh air.</p>
--	--



Placement



To remove the saw base unit from the crate pallet:

1. Cut off and remove all plastic straps from the crate.
2. Using a forklift, position the saw over the final location.
3. Place the cast iron feet under the leveling screws.
4. Lower the saw onto the cast iron feet as shown in **Figure 16**.

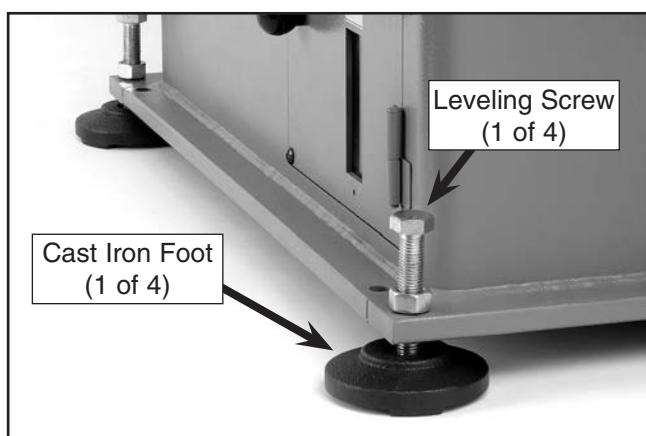
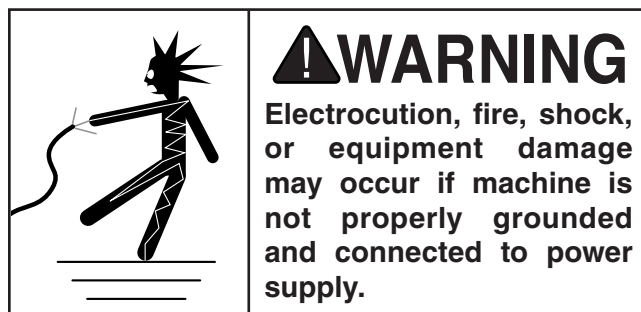


Figure 16. Cast iron feet.

5. Adjust the leveling screws until the saw table is level.

Power Connection

Before the machine can be connected to the power source, an electrical circuit and connection device must be prepared per the **CIRCUIT REQUIREMENTS** section in this manual; and all previous setup instructions in this manual must be complete to ensure that the machine has been assembled and installed properly. The disconnect switch installed by the electrician (as recommended) is the primary means for disconnecting or connecting the machine to the power source.



Note About Phase Converters: If your machine is connected to a phase converter, it **MUST** be a rotary-type. A static phase converter must not be used or motor and electrical component damage will occur.

The voltage from the manufactured power leg of the phase converter (sometimes called the wild leg or wild wire) can fluctuate. Connect the manufactured leg to the "S" terminal for incoming power (see location on **Page 53**). Otherwise, your machine may not start properly, and magnetic switch chatter or electrical component damage will occur.

To connect the saw to power:

1. Open the electrical access door.

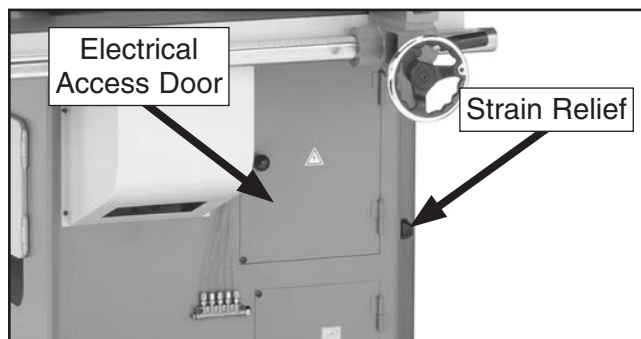


Figure 17. Location of electrical access door.



2. Insert incoming power wires where strain relief is located on side of electrical access door.
3. Connect ground wire to ground terminal shown in **Figure 18** on grounding plate.

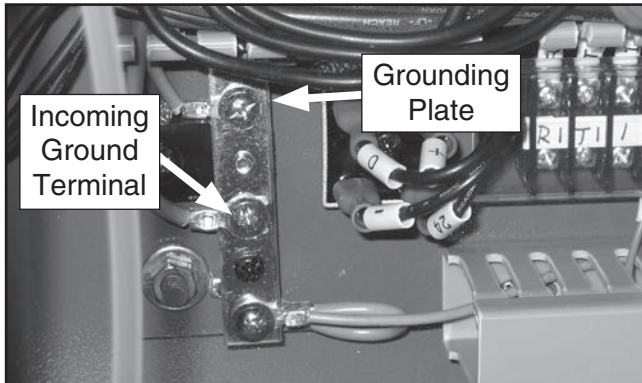


Figure 18. Location to connect incoming ground wire on grounding plate.

4. Connect incoming power wires to top R, S, T terminals shown in **Figure 19**.

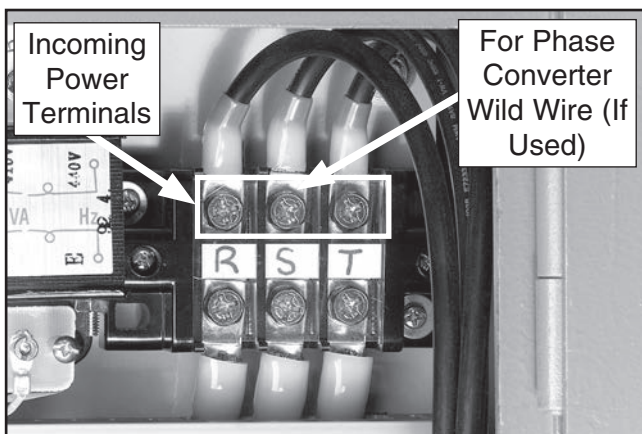


Figure 19. Terminal locations to connect incoming power wires.

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

Connecting to Power Source

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

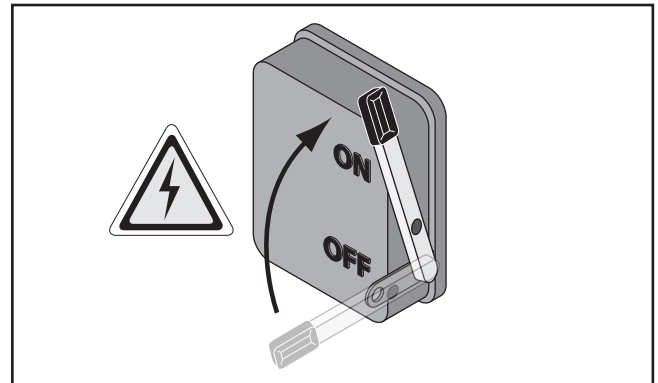


Figure 20. Connecting power to machine.

Disconnecting from Power Source

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

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

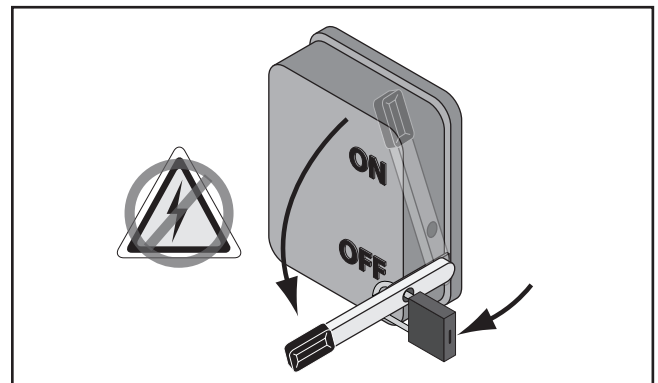


Figure 21. Disconnecting power from machine.



Remove the Blade

For safety reasons, the saw blade must be removed before the saw is test run to ensure the wiring is not reversed at the main terminal (**Figure 19**). If the wiring is reversed, the saw arbor and the conveyor track will run in the wrong direction.

CAUTION

The saw blade is very sharp and can cause personal injury. Always wear thick leather gloves when working on or around the saw blade.

To remove the blade:

1. If not already done, make sure the saw is not connected to the power source!
2. Loosen the saw arbor lock lever.
3. Using the blade height handwheel, raise the blade until it is approximately $\frac{1}{4}$ " above the conveyor track.
4. Open the blade access door.
5. Using the arbor wrench, hold the blade arbor stationary.
6. Using the T-handle wrench, remove the arbor bolt by rotating it counterclockwise.
7. Remove the large blade flange and carefully slide the blade off the arbor.
8. **DO NOT** re-install the arbor bolt or flange at this time.

Test Run

WARNING

Before starting the saw, make sure you have removed the saw blade, performed the preceding assembly and adjustment instructions, and have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the saw:

1. Connect the power cord to an adequate power source.
2. Put on safety glasses and make sure any bystanders are out of the way and are also wearing safety glasses.
3. At the front of the control panel, rotate the red EMERGENCY STOP button until it springs up. The control panel is now live and any buttons you push will react accordingly.
4. Press the MAIN MOTOR START button. The arbor should start and run smoothly.
5. The arbor should spin counterclockwise.
— If the arbor spins counterclockwise, then skip ahead to the **step 6**.

CAUTION

DO NOT turn the conveyor track **ON** if the arbor rotates clockwise. Reverse any two of the power wires at the main terminal.

— If the arbor spins clockwise, **DO NOT** start the conveyor track. Press the red EMERGENCY STOP button and disconnect the power cord from the power source. Phase of incoming power supply is reversed. Open the electrical panel box and reverse the "R" and "T" power wires at the main terminal (see **Figure 22**) and start again at **step 1**.





Figure 22. Close-up view of power supply terminals inside electrical panel.

6. Approximately 5 seconds after the arbor is started, press the FEED MOTOR START button. The conveyor track should start and run smoothly. Note—*An automatic time delay prevents the conveyor track from starting up until 5 seconds after the main motor has started.*
7. Press both the MAIN MOTOR STOP and the FEED MOTOR STOP buttons to turn the machine off.
8. **Disconnect the machine from the power source.**
9. Install the saw blade by reversing the steps in the “Remove the Blade” subsection on the previous page. Note—*Make sure the blade is NOT making contact with any part of the conveyor track.*

Scale Calibration

The distance between the right edge of the blade teeth and the fence face should be equal to the scale reading on the fence rail. The scale can be adjusted back and forth once the two Phillips head screws (**Figure 23**) are loosened.



Figure 23. Phillips head screws securing the fence scale.

Dust Collection

An efficient and clean dust collection system is essential to the proper function of the rip saw. Ensuring a healthy work environment is also dependent upon cleaning and maintaining the dust collection system. Clamp a 4" hose from the dust collection system to the dust port (**Figure 24**).

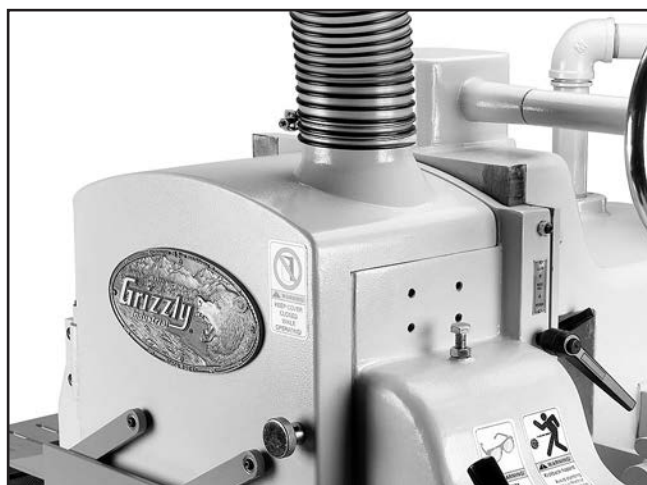


Figure 24. Dust collection hook-up.

Auxiliary Rollers

Components and Hardware Needed:	Qty
Auxiliary Roller Brackets (Left)	2
Auxiliary Roller Brackets (Right)	2
Auxiliary Rollers.....	4
Hardware Bag	
—Cap Screws M6-1.0 x 16	8
—Setscrews M6-1.0 x 30	4
—Lock Washers 6mm	8
—Flat Washers 6mm	4
—Hex Nuts 6-1.0	4

Tools Needed:

Allen Wrench 3mm	1
Allen Wrench 4mm	1
Allen Wrench 5mm	1
Wrench 10mm	1
Wrench 13mm	1

The Model G0524 is supplied with 4 auxiliary rollers (**Figure 25**) that can be attached when rip cutting workpieces shorter than 8". Note—*These auxiliary rollers can be left on the machine when cutting longer boards; however, the maximum thickness cutting capacity of the saw is reduced to 2¼".*

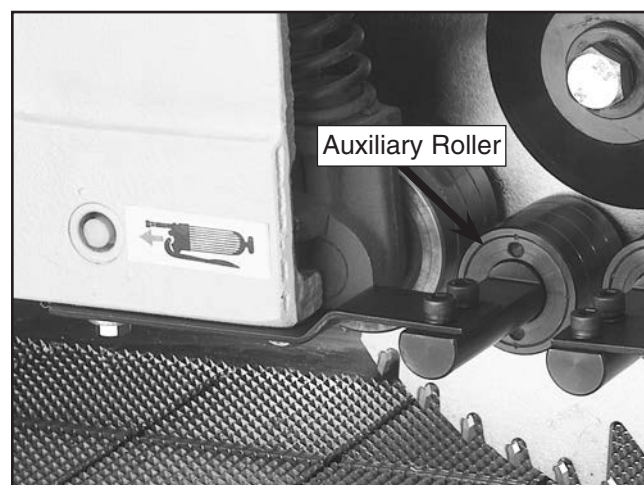


Figure 25. Auxiliary roller (1 of 4).



To install the auxiliary rollers:

1. Using a 13mm wrench, remove the 4 hex nuts from the setscrews on the underside of the head casting (**Figure 26**).

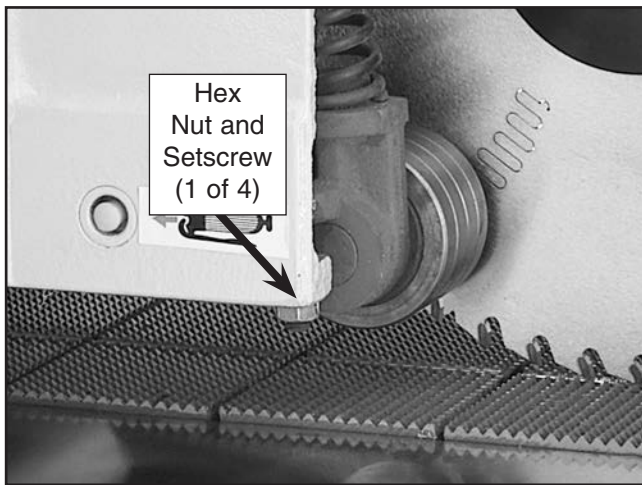


Figure 26. Hex nut.

2. Using a 3mm Allen wrench, remove the four M6-1.0 x 10 setscrews from the bottom edge of the head casting and replace with the four M6-1.0 x 30 setscrews (**Figure 27**). Note—*The head of the M6-1.0 x 10 setscrews will be recessed up in the head casting.*

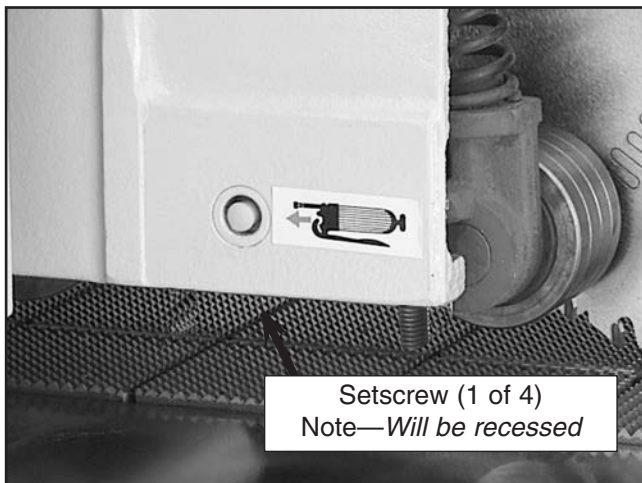


Figure 27. Setscrew.

3. Slide the 4 auxiliary roller brackets over the setscrews and secure them with the four M6-1.0 hex nuts and 6mm flat washers, as well as the 4 hex nuts removed in **step 1** (**Figure 28**).

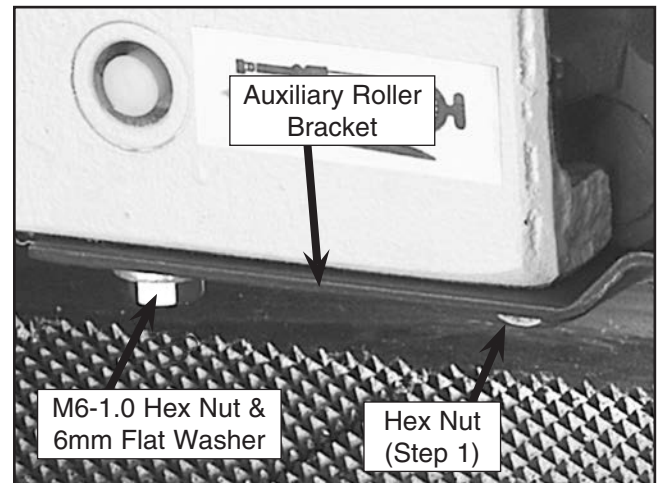


Figure 28. Auxiliary roller bracket.

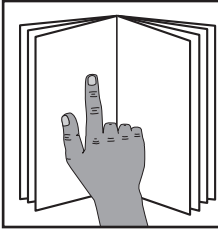
4. Using a 5mm Allen wrench, secure the 4 auxiliary rollers to the brackets with the 8 cap screws and lock washers (**Figure 29**).



Figure 29. Auxiliary roller mounting configuration.



SECTION 6: OPERATIONS

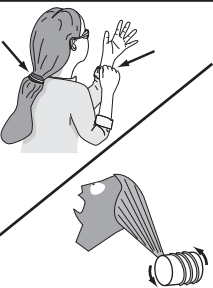
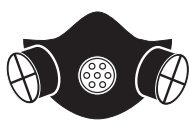


!WARNING

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

!WARNING

Eye injuries, respiratory problems, or hearing loss can occur while operating this tool. Wear personal protective equipment to reduce your risk from these hazards.



!WARNING

Keep hair, clothing, and jewelry away from moving parts at all times. Entanglement can result in death, amputation, or severe crushing injuries!

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.

Safe Operation

Your safety is important. The bullets below are intended to supplement *Section 2: Safety*. But remember, no safety list can be comprehensive of every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

Please follow these tips EVERY time the saw is operated:

- Stand to the right of the blade line-of-cut when performing a cutting operation.
- Turn the saw *OFF* and allow the blade to come to a complete stop before making any adjustments.
- Make sure the blade guard is installed and that it raises and drops as the workpiece enters and leaves the cutting operation.
- Carefully plan each cutting operation to avoid injuries.



Adjusting Feed Rate

NOTICE

The conveyor track must be moving when adjusting the feed rate.

Turn the variable speed adjustment knob (**Figure 30**) clockwise to decrease the feed rate and counterclockwise to increase it. The feed rate is variable between 30-112 FPM.



Figure 30. Variable speed adjustment knob.

Determining Ideal Feed Rates—There are no definitive rules to follow when determining the best feed rate. As a general rule, always start with the slowest feed rate and work up from there. Always perform a test cut with a piece of scrap wood similar to the actual workpiece.

Rip Cutting

To make a rip cut:

1. Read and understand *Section 1: Safety*, beginning on **page 1**.
2. Before making the very first rip cut, adjust the blade height handwheel to lower the saw blade to within $\frac{1}{16}$ " of the orange insert located in the conveyor track.
3. **Disconnect the saw from the power source.**
4. Rock the blade back and forth to ensure it is NOT making contact with the conveyor track. Note—*Once the height of the blade is correctly set, DO NOT adjust it until the next time the blade is removed.*
5. Connect the saw to the power source.
6. If not already done, plane the workpiece on both sides and joint one edge.
7. Set the fence to the desired width of cut on the scale.
8. Adjust the pressure roller height handwheel until the distance between the pressure rollers and the table is approximately $\frac{1}{8}$ " less than the thickness of the workpiece.
9. Press the MAIN MOTOR START button. The arbor should start and run smoothly.

! WARNING

DO NOT adjust the height of the pressure roller/head assembly higher than $2\frac{1}{4}$ " when the auxiliary rollers are attached. Doing so will cause the blade arbor flange to make contact with the auxiliary rollers.



!WARNING

Never attempt to rip a board that does not have one perfectly straight edge. Always guide the straight edge of the board against the rip fence. Failure to do this could result in kickback and serious personal injury.

10. Approximately 5 seconds after the arbor is started, press the FEED MOTOR START button. The conveyor track should start and run smoothly. Note—*An automatic time delay prevents the conveyor track from starting up until 5 seconds after the main motor has started.*
11. Place the jointed edge of the workpiece against the fence and keep fingers and hands on top side of the workpiece. Note—*Placing hands or fingers underneath the workpiece could cause them to become pinched onto the conveyor track and pulled into the saw blade.*



!WARNING

Placing hands or fingers under the workpiece could cause them to be pulled into the rip saw, causing serious personal injury. Do not place hands or fingers under the workpiece.

!WARNING

Never stand directly behind the workpiece while feeding it through the rip saw. Stand to the left or right of the workpiece to avoid serious personal injury in the event of kickback.

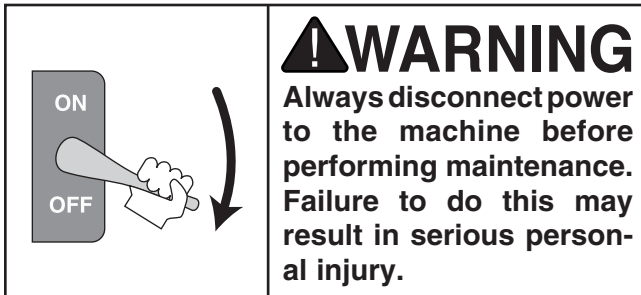
12. Push the workpiece into the saw to perform the cutting operation (**Figure 31**).
 - If the saw is not cutting completely through to the bottom face of the workpiece, the blade needs to be lowered. Only lower the blade just enough to cut completely through the workpiece. Lowering the blade too far could cause the blade to make contact with the conveyor track.



Figure 31. Rip cutting operation. The operator is standing to the side of the workpiece to avoid injury in the event of kickback.



SECTION 7: MAINTENANCE



Schedule

Check for the following conditions before each use:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Leaking or broken lube lines.
- Empty lube reservoir.
- Any other condition that could hamper the safe operation of this machine.

Monthly:

- Grease Fittings
- V-belts

After the first 100 hours:

- Gear Box

Every 2500 Hours:

- Gear Box

Grease Fittings

Lubricate the four grease fittings (**Figure 32**) with a general purpose grease after every month (160 Hours) of regular use.

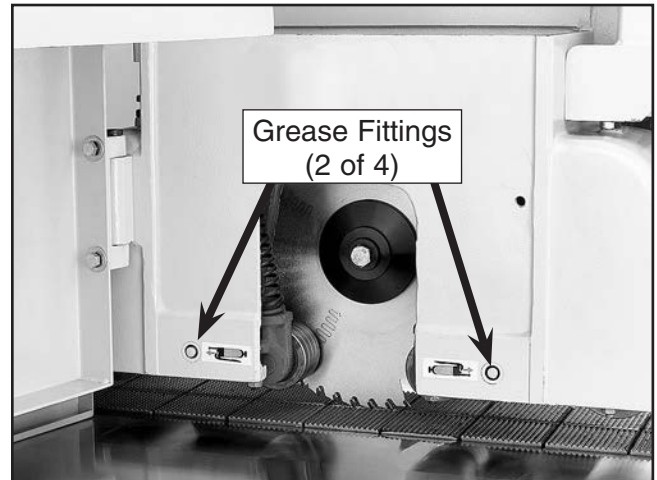


Figure 32. Grease fittings (Additional 2 fittings are on opposite side of head casting).

Gear Box

The oil inside the gear reducer should be replaced after the first month (160 hours) of regular use. We recommend 90 Wt. gear oil.

After the first oil change, the oil inside the gear reducer should be replaced after every 2500 hours of use. We recommend 90 Wt. gear oil.



V-Belts

Inspect V-belts for damage or cracks after every month (160 Hours) of regular use.

Bearings

The sealed ball bearings in this machine are permanently sealed and lubricated. There is no need to lubricate them. If the bearing wears out, simply replace it with one ordered from our service department.

Lube System

Oil TypeMobil Vactra 2 or ISO 68 Equivalent

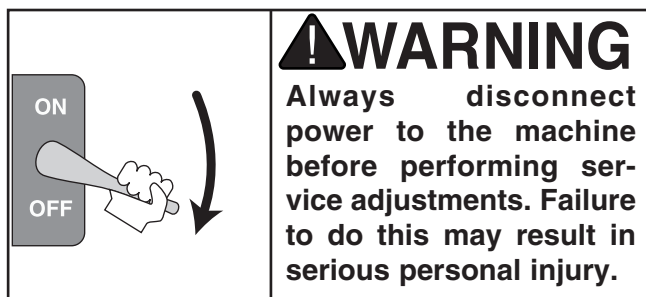
The lube reservoir (**Figure 33**) houses the oil that lubricates the conveyor track. The oil is pumped through a series of plastic tubes at a rate of 3-6 cc every 5 minutes, and onto a brush under the main table. When the oil level in the reservoir becomes low, a switch is triggered that prevents the saw from being operated. If this occurs, fill the reservoir above the “low” line and the saw will operate normally.



Figure 33. Lube reservoir.



SECTION 8: SERVICE



About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.

Fence Alignment

If the face of the fence is not parallel to the saw blade (cut line), the resulting rip cut will yield a workpiece that is wider at one end or the other.

To adjust the fence alignment:

1. Rip cut a scrap workpiece.
2. Measure the width at each end of a workpiece that has been cut on the rip saw.
 - If end A is wider than end B, then the tip of the fence needs to be adjusted to the left to make the fence parallel to the blade (**Figure 34**).

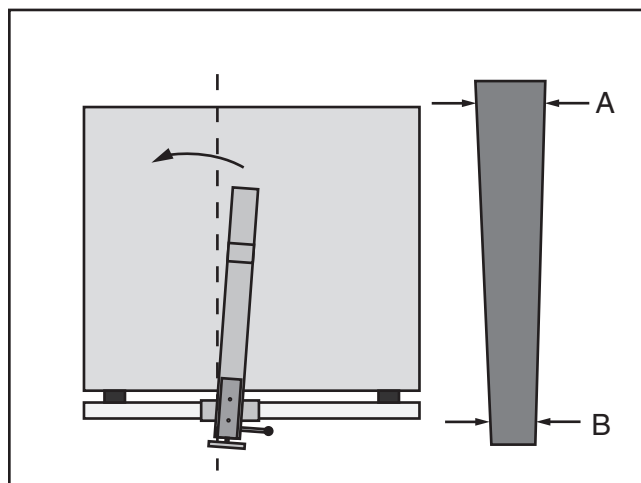


Figure 34. Adjusting the fence to the left.



- If end B is wider than end A, then the tip of the fence needs to be adjusted to the right to make the fence parallel to the blade (**Figure 35**).

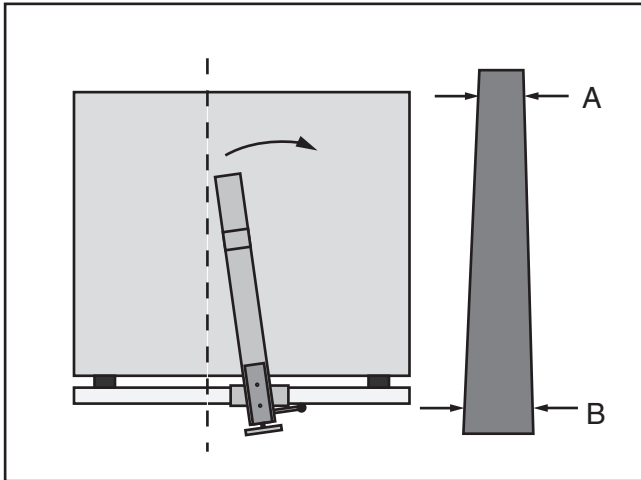


Figure 35. Adjusting the fence to the right.

3. Loosen the cap screws (**Figure 36**) on the top of the fence to allow adjustment of the fence. Retighten when complete.

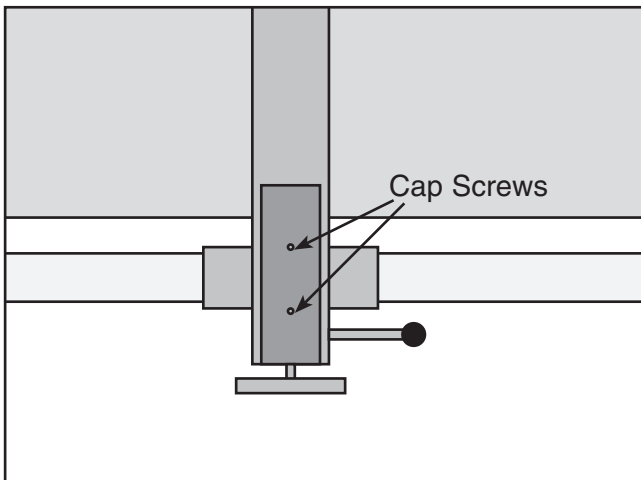


Figure 36. Cap screws to loosen fence.

4. Repeat **step 1** to verify that the adjustments are correct.

V-Belt Tension

To adjust the main motor V-belt tension:

1. **Disconnect the saw from the power source!**
2. Remove the side access panel to reveal the adjustment mechanism.
3. Loosen the jam nut (**Figure 37**).

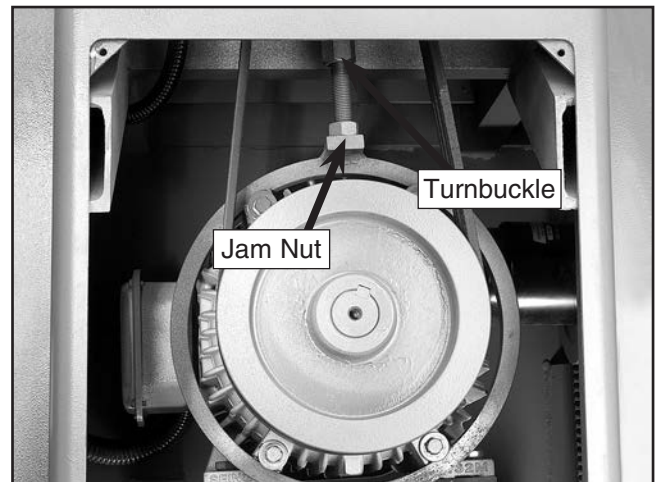


Figure 37. Arbor motor V-belt adjustment.

4. Adjust the turnbuckle to increase or decrease the V-belt tension. Note—*Turning the turnbuckle clockwise lowers the tension and counterclockwise increases it.*
5. Retighten the jam nut when the V-belt has been tensioned correctly and re-install the side access panel.



To adjust the feed motor V-belt tension:

1. Disconnect the saw from the power source!
2. Remove the side access panel to reveal the adjustment mechanism.
3. Loosen the jam nut (**Figure 38**).

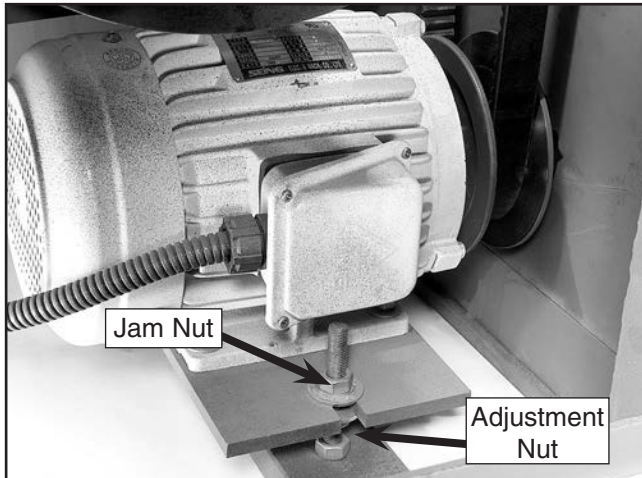


Figure 38. Feed motor V-belt adjustment.

4. Raise or lower the adjustment nut to change the V-belt tension. Note—*Raise the adjustment nut to decrease the tension and lower it to increase the tension.*
5. Retighten the jam nut when the V-belt has been tensioned correctly and re-install the side access panel.

Fence Ride Height

To adjust the ride height of the fence:

Adjust the setscrew (**Figure 39**) to raise and lower the ride height of the fence. Note—*The fence could scratch the steel table surface if the ride height is set too low.*



Figure 39. Fence ride height adjustment.



Pressure Rollers

The pressure rollers must all be the same distance away from the table surface (conveyor track).

To adjust the pressure rollers:

1. **Disconnect the saw from the power source!**
2. Using the blade height handwheel, raise the bottom edge of the blade above the bottom-dead-center of the pressure rollers.
3. Using the pressure roller height handwheel, raise the head of the saw high enough to allow a flat board to be placed under all the pressure rollers.
4. Slowly lower the head.
 - If the pressure rollers make contact with the board at the same time, they are adjusted correctly.
 - If the pressure rollers do not make contact with the board at the same time, they need to be adjusted so they do. Continue with the next step.

5. Each pressure roller can be independently adjusted by loosening the jam nut and turning the small setscrew (**Figure 40**). Note— *Turning the setscrew clockwise, as viewed from the top, lowers the pressure roller; counterclockwise raises the pressure roller.*

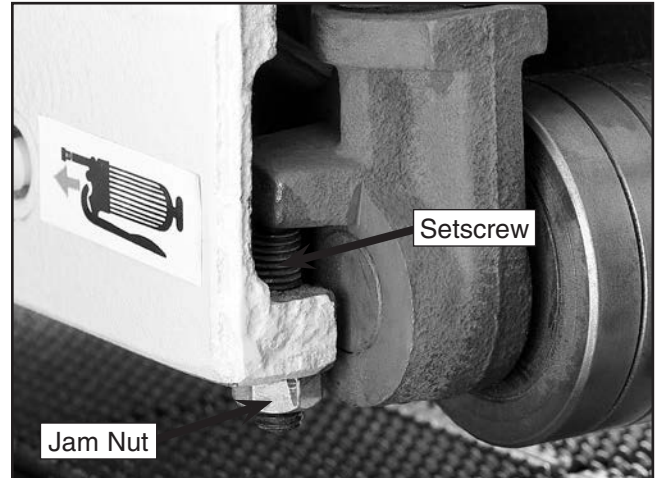


Figure 40. Setscrew for height adjustment.

6. Once the pressure rollers are adjusted correctly, retighten the jam nuts.



Gibs

The head of the saw slides up and down on gibs. Over time, the gibs may need to be tightened to compensate for wear. Loosen the jam nuts and adjust the setscrews to reduce the “play” along the gibs (**Figure 41**). Always make small adjustments to the setscrews, starting with $\frac{1}{4}$ turn increments. When adjusted correctly, tighten the jam nuts and make sure the head slides up and down smoothly.



Figure 41. Gib adjustment setscrews.



SECTION 9: ACCESSORIES

⚠ WARNING

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

NOTICE

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

Basic Eye Protection

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



Figure 42. Assortment of basic eye protection.

Basic Hearing Protection

- H4978—Deluxe Earmuffs - 27dB
 - H4979—Twin Cup Hearing Protector - 29dB
 - T20446—Ear Plugs 200 Pair - 31dB
- A must have if you or employees operate for hours at a time.



Figure 43. Hearing protection assortment.

Recommended Metal Protectants

- G5562—SLIPIT® 1 Qt. Gel
- G5563—SLIPIT® 12 Oz. Spray
- G2871—Boeshield® T-9 12 Oz. Spray
- G2870—Boeshield® T-9 4 Oz. Spray
- H3788—G96® Gun Treatment 12 Oz. Spray
- H3789—G96® Gun Treatment 4.5 Oz. Spray



Figure 44. Recommended products for protecting unpainted cast iron/steel part on machinery.

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



Laser Guide with Arm - H5749

Improve rip cutting accuracy, work more efficiently, and increase yields with the optional Grizzly H5749 Laser Guide. This bolt-on accessory is perfect for production shop looking to make the most of their Grizzly G0524 Rip Saw.

Inventory	Qty
• Steel Arm.....	1
• Laser Bracket	1
• Laser Clamp	1
• Laser.....	1
• Power Box	1
• Cap Screws M8-1.25 x 25.....	4
• Flat Washers 8mm	4
• Lock Washers 8mm.....	4
• Cap Screws M6-1 x 16.....	2
• Flat Washers 6mm	2
• Cap Screws M6-1 x 35.....	2
• Phillips Head Screws M5-.8 x 8	2

To install the laser guide on the Model G0524 Rip Saw:

1. **Disconnect the Model G0524 Rip Saw from the power source!**
2. Attach the steel arm to the head casting with the (4) M8-1.25 x 25 cap screws, (4) 8mm flat washers, and (4) M8 lock washers. Note—*The mounting location and drill pattern for the steel arm are shown on **page 46**. The holes must be drilled and tapped to accept M8-1.25 threads.*
3. Mount the laser bracket to the top of the steel arm with the (2) M6-1 x 16 cap screws and (2) 6mm flat washers.
4. Place the laser clamp around the laser and secure the assembly to the laser bracket with the (2) M6-1 x 35 cap screws.
5. Attach the black power box to the rip saw with the (2) M5-8 x 8 Phillips head screws. Note—*Make sure the loose end of the green ground wire is secured between the head of the Phillips screw and the black power box.*
6. Route the power wires from the power box through the side of the saw base and into the electrical panel compartment.

7. Connect the R1 and T1 power wires to their respective R1 and T1 locations on the main terminal at the electrical panel.
8. Feed the laser power wire through the access holes on the steel arm, and plug the power wire into the back of the power box.
9. Cut a board, turn the saw *OFF*, place the board against the fence, and finally, adjust the laser beam along the freshly cut edge.

WARNING

DO NOT look into the end of the laser. Serious eye damage will occur.

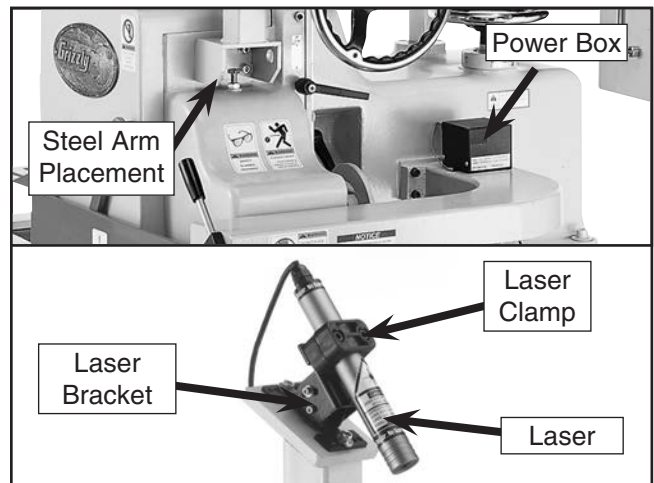


Figure 44. Model H5749 Laser Guide.

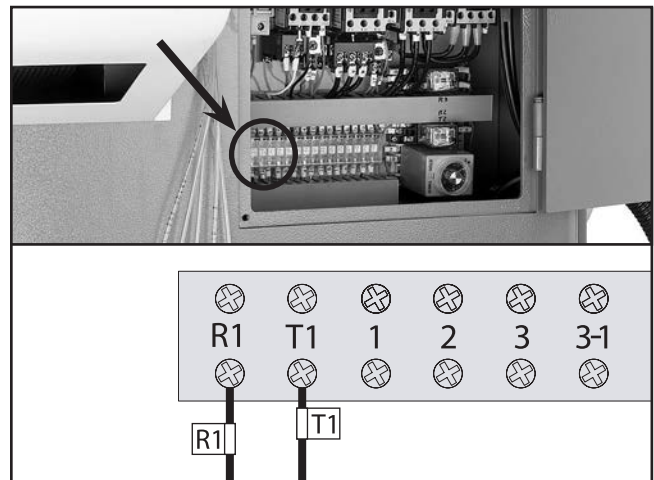


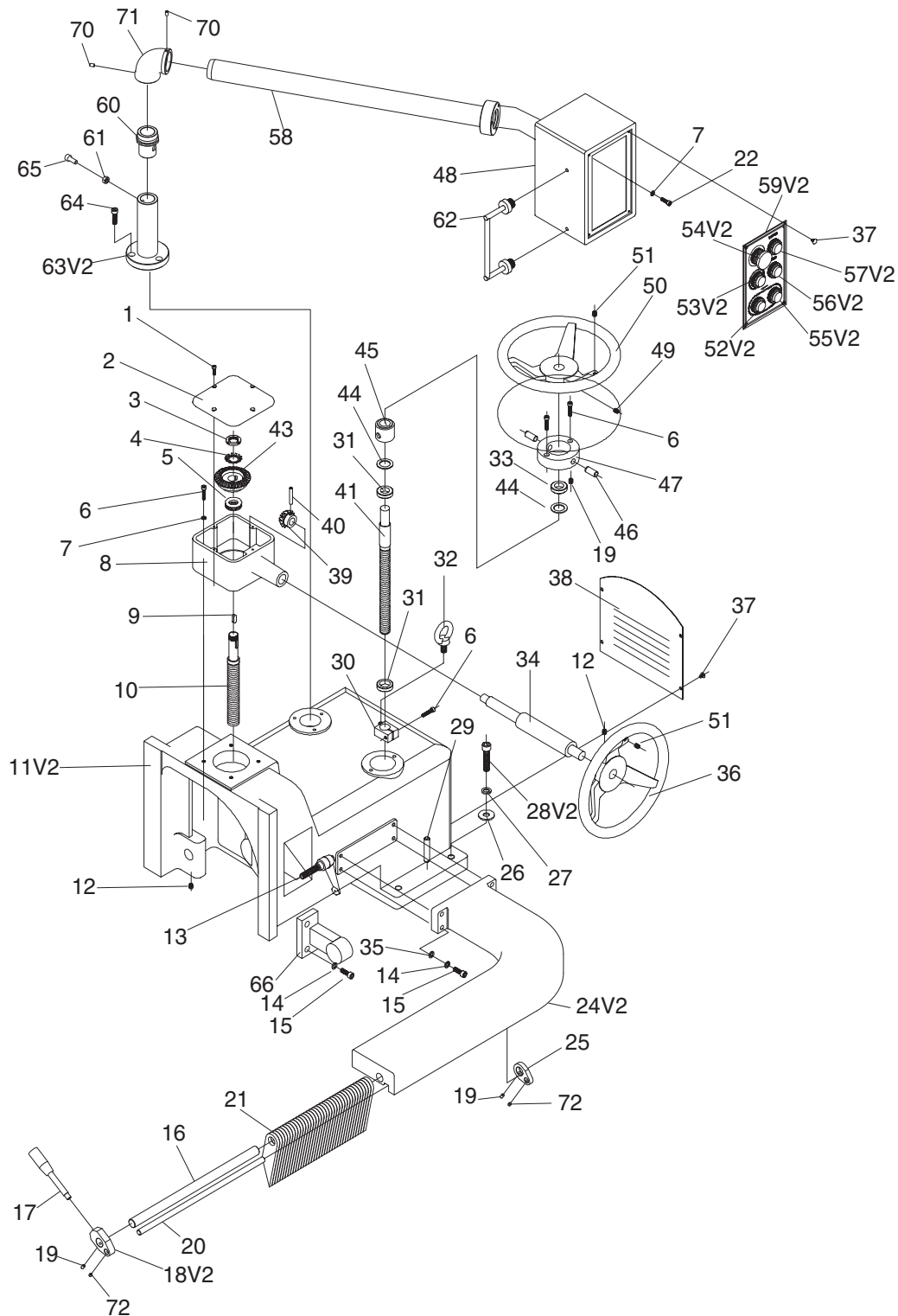
Figure 45. Electrical wiring.



SECTION 10: 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.

Upper Saw Breakdown



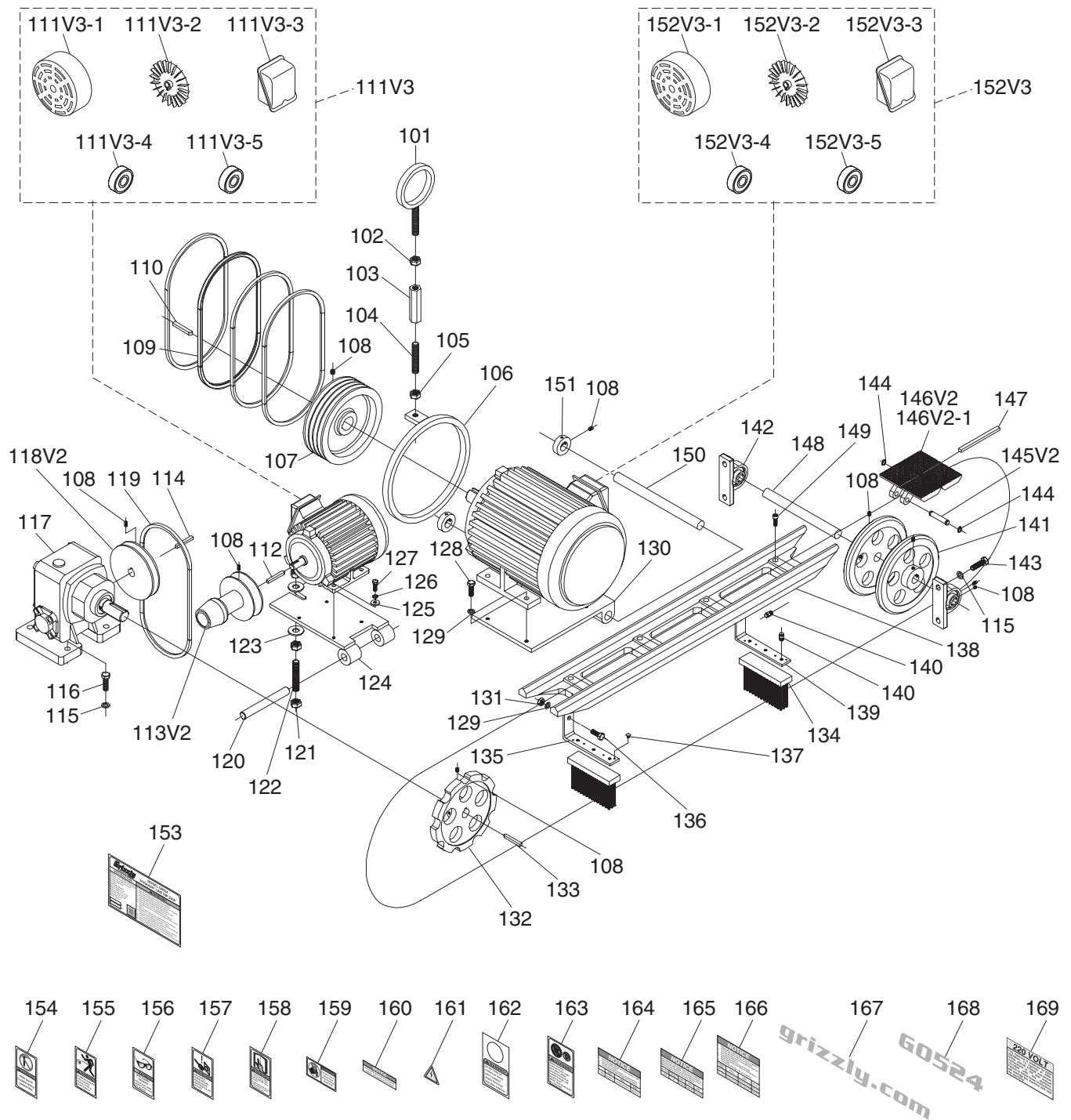
Upper Saw Parts List

REF	PART #	DESCRIPTION
1	P0524001	CAP SCREW M5-.8 X 16
2	P0524002	GEARBOX COVER
3	P0524003	SPANNER NUT M20-1.0
4	P0524004	EXT TOOTH WASHER 20MM
5	P0524005	THRUST BEARING 51104
6	P0524006	CAP SCREW M6-1 X 30
7	P0524007	LOCK WASHER 6MM
8	P0524008	GEAR BOX
9	P0524009	KEY 7 X 7 X 18
10	P0524010	BLADE GUARD LEADSCREW
11V2	P0524011V2	BLADE GUARD HOUSING V2.07.13
12	P0524012	SET SCREW M8-1.25 X 16
13	P0524013	ADJUSTABLE HANDLE
14	P0524014	LOCK WASHER 8MM
15	P0524015	CAP SCREW M8-1.25 X 35
16	P0524016	FINGER SHAFT
17	P0524017	LEVER M10-1.5 X 125 W/KNOB
18V2	P0524018V2	FINGER SHAFT BRACKET (LH) V2.07.13
19	P0524019	SET SCREW M6-1 X 10
20	P0524020	FINGER STOP SHAFT
21	P0524021	ANTI-KICKBACK FINGER
22	P0524022	CAP SCREW M6-1 X 16
24V2	P0524024V2	SEAT W/FIXED PLATE ASSEMBLY V2.07.13
25	P0524025	FINGER SHAFT BRACKET (RH)
26	P0524026	FLAT WASHER 12MM
27	P0524027	LOCK WASHER 12MM
28V2	P0524028V2	CAP SCREW M12-1.75 X 60
29	P0524029	LOCK SEAT TAPER PIN
30	P0524030	LOCKING STOPPER
31	P0524031	LEAD SCREW RING
32	P0524032	LIFTING EYE BOLT M12-1.75 X 22
33	P0524033	HANDWHEEL RING
34	P0524034	HANDWHEEL SHAFT
35	P0524035	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
36	P0524036	HANDWHEEL
37	P0524037	PHLP HD SCR M5-.8 X 8
38	P0524038	COVER W/VENTS
39	P0524039	BEVEL GEAR (SMALL)
40	P0524040	ROLL PIN 5 X 25
41	P0524041	BLADE LEADSCREW
43	P0524043	BEVEL GEAR (BIG)
44	P0524044	SPACER
45	P0524045	BUSHING
46	P0524046	HANDWHEEL PIN
47	P0524047	HANDWHEEL BRACKET
48	P0524048	CONTROL BOX
49	P0524049	SET SCREW M8-1.25 X 10
50	P0524050	HANDWHEEL
51	P0524051	SET SCREW 3/8-16 X 3/8
52V2	P0524052V2	ON BUTTON KN KB2-EW33M1 22MM V2.09.21
53V2	P0524053V2	ON BUTTON KN KB2-EW33M1 22MM V2.09.21
54V2	P0524054V2	E-STOP BUTTON KN KB2-ES542 22MM V2.09.21
55V2	P0524055V2	OFF BUTTON KN KB2-EL42 22MM V2.09.21
56V2	P0524056V2	OFF BUTTON KN KB2-EL42 22MM V2.09.21
57V2	P0524057V2	POWER BUTTON KN KE-22DS 22MM V2.09.21
58	P0524058	CONTROL BOX ARM, HORIZONTAL
59V2	P0524059V2	CONTROL BOX PANEL 22MM V2.09.21
60	P0524060	ROTATION SEAT
61	P0524061	HEX NUT M8-1.25
62	P0524062	CONTROL BOX HANDLE
63V2	P0524063V2	ROTATION SEAT W/VERTICAL ARM V2.06.14
64	P0524064	CAP SCREW M8-1.25 X 20
65	P0524065	SET SCREW M8-1.25 X 20
66	P0524066	BRACKET
70	P0524070	SET SCREW M6-1 X 10
71	P0524071	ELBOW PT 1-1/4
72	P0524072	SET SCREW M6-1 X 6



Motors & Conveyor Track



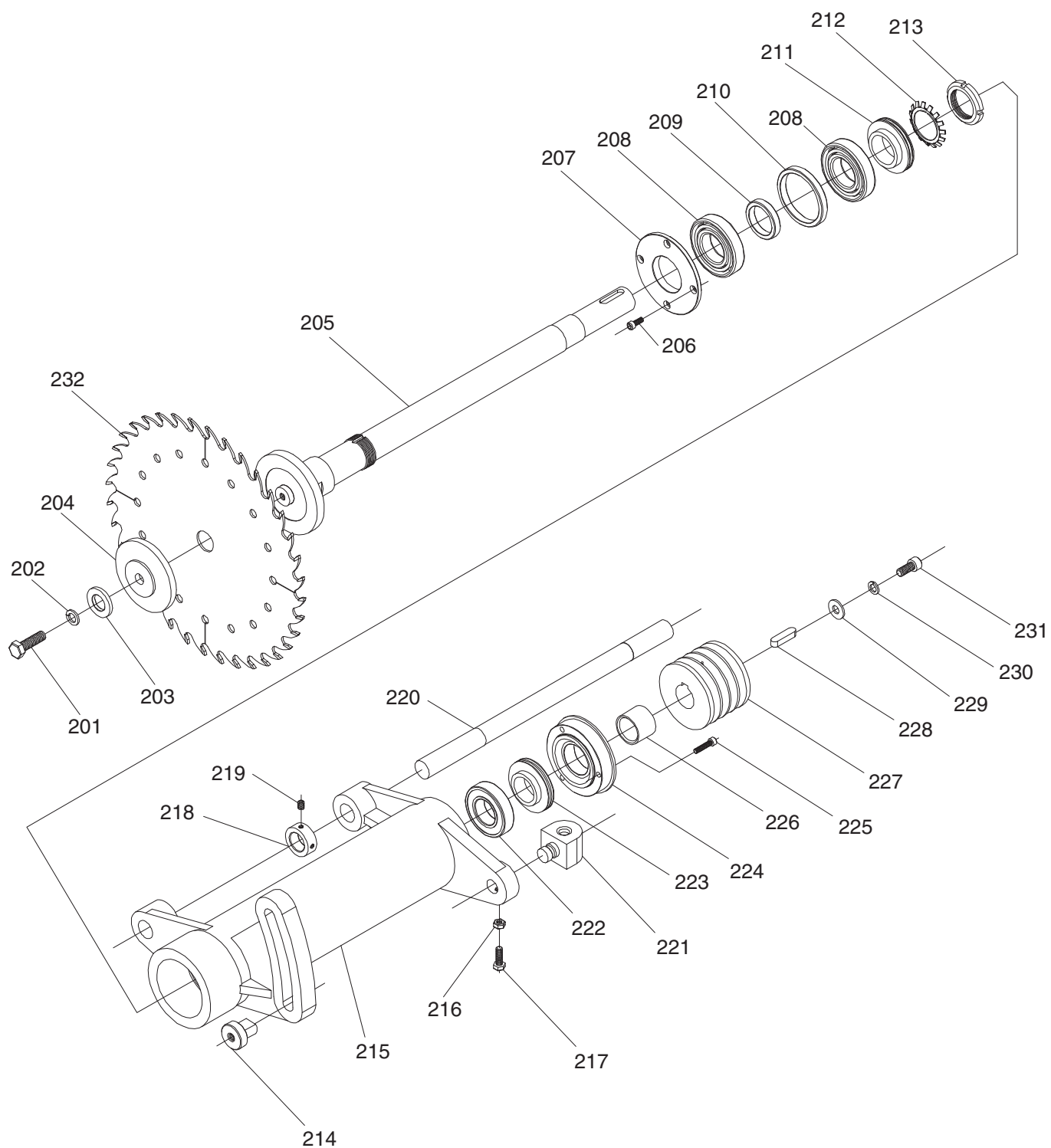
Motors & Conveyor Track Parts List

REF	PART #	DESCRIPTION
101	P0524101	PULLEY EYE BOLT M16-2 X 90 LH
102	P0524102	HEX NUT M16-2 LH
103	P0524103	PULLEY COUPLING NUT M16-2 LH/RH
104	P0524104	STUD-FT M16-2 X 110
105	P0524105	HEX NUT M16-2
106	P0524106	MOTOR LIFTING RING
107	P0524107	MOTOR PULLEY
108	P0524108	SET SCREW M8-1.25 X 16
109	P0524109	V-BELT A55
110	P0524110	KEY 10 X 8 X 70
111V3	P0524111V3	CONVEYOR MOTOR 2HP 220V/440V 3-PH V3.07.16
111V3-1	P0524111V3-1	MOTOR FAN COVER
111V3-2	P0524111V3-2	MOTOR FAN
111V3-3	P0524111V3-3	MOTOR JUNCTION BOX
111V3-4	P0524111V3-4	BALL BEARING 6205LLB
111V3-5	P0524111V3-5	BALL BEARING 6204 CM LLB
112	P0524112	KEY 8 X 8 X 40
113V2	P0524113V2	REDUCER PULLEY V2.11.20
114	P0524114	KEY 7 X 7 X 45
115	P0524115	LOCK WASHER 12MM
116	P0524116	HEX BOLT M12-1.75 X 40
117	P0524117	REDUCER WORM GEAR
118V2	P0524118V2	REDUCER PULLEY V2.11.20
119	P0524119	COGGED BELT 1922V30-22
120	P0524120	CONVEYOR MOTOR PIVOT SHAFT
121	P0524121	HEX NUT M12-1.75
122	P0524122	STUD-FT M12-1.75 X 100
123	P0524123	FLAT WASHER 12MM
124	P0524124	CONVEYOR MOTOR MOUNT
125	P0524125	FLAT WASHER 12MM
126	P0524126	LOCK WASHER 8MM
127	P0524127	HEX BOLT M8-1.25 X 25
128	P0524128	HEX BOLT M10-1.5 X 35
129	P0524129	LOCK WASHER 10MM
130	P0524130	BLADE MOTOR MOUNT
131	P0524131	HEX NUT M10-1.5
132	P0524132	SPROCKET 10T
133	P0524133	KEY 10 X 8 X 30
134	P0524134	BRUSH
135	P0524135	BRUSH L-BRACKET (LH)
136	P0524136	HEX BOLT M10-1.5 X 30

REF	PART #	DESCRIPTION
137	P0524137	PHLP HD SCR 1/8-40 X 3/4
138	P0524138	CONVEYOR BODY
138-1	P0524138-1	CAT. BLOCK FITTED BAKELITE
139	P0524139	BRUSH L-BRACKET (RH)
140	P0524140	BALL OILER 1/8 NPT THREADED
141	P0524141	IDLE WHEEL
142	P0524142	PILLOW BLOCK BEARING
143	P0524143	HEX BOLT M12-1.75 X 30
144	P0524144	EXT RETAINING RING 12MM
145V2	P0524145V2	BLOCK PIVOT SHAFT 74MM V2.01.12
146V2	P0524146V2	ENTIRE FEED CHAIN ASSY V2.01.12
146V2-1	P0524146V2-1	SINGLE LINK FOR FEED CHAIN V2.01.12
147	P0524147	BAKELITE PLASTIC INSERT
148	P0524148	IDLER WHEEL AXLE
149	P0524149	CAP SCREW M8-1.25 X 25
150	P0524150	BLADE MOTOR MOUNT PIVOT SHAFT
151	P0524151	LOCK COLLAR
152V3	P0524152V3	MOTOR 15HP 220V/440V 3-PH V3.07.16
152V3-1	P0524152V3-1	MOTOR FAN COVER
152V3-2	P0524152V3-2	MOTOR FAN
152V3-3	P0524152V3-3	MOTOR JUNCTION BOX
152V3-4	P0524152V3-4	BALL BEARING 6308 CM LLB
152V3-5	P0524152V3-5	BALL BEARING 6308 CM LLB
153	P0524153	MACHINE ID LABEL
154	P0524154	KEEP COVER CLOSED LABEL
155	P0524155	KICKBACK LABEL
156	P0524156	SAFETY GLASSES
157	P0524157	UNPLUG LABEL 220V
158	P0524158	READ MANUAL
159	P0524159	INFEED HAND LABEL
160	P0524160	TRAINING LABEL
161	P0524161	ELECTRICITY
162	P0524162	HANGING BUTTON LABEL
163	P0524163	ARBOR ROTATION LABEL
164	P0524164	GREASE FITTING LABEL
165	P0524165	LUBRICANT OIL LABEL
166	P0524166	GEAR OIL LABEL
167	P0524167	GRIZZLY.COM LABEL
168	P0524168	MODEL NUMBER LABEL
169	P0524169	PREWIRED 220V LABEL



Main Spindle



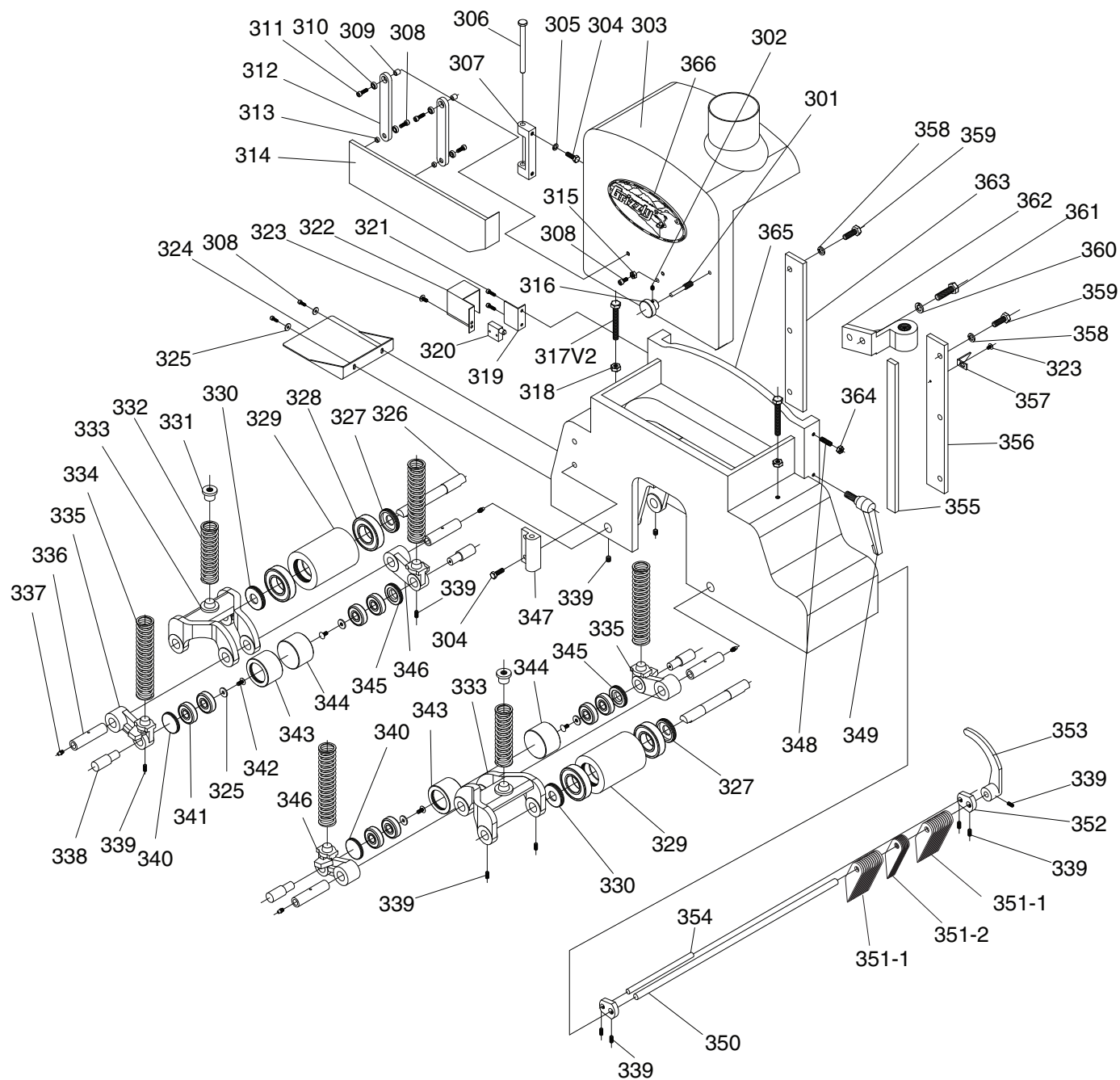
Main Spindle Parts List

REF	PART #	DESCRIPTION
201	P0524201	HEX BOLT M12-1.75 X 40
202	P0524202	LOCK WASHER 12MM
203	P0524203	SAW BLADE WASHER 12 X 30 X 5MM
204	P0524204	BLADE FLANGE
205	P0524205	BLADE ARBOR
206	P0524206	CAP SCREW M6-1 X 16
207	P0524207	BEARING COVER
208	P0524208	ANGULAR CONTACT BEARING 7208CYDB
209	P0524209	SPACER
210	P0524210	SPACER
211	P0524211	BEARING SEAT
212	P0524212	EXT TOOTH WASHER 40MM
213	P0524213	SPANNER LOCK NUT M40-15 LH
214	P0524214	ARBOR HOUSING NUT M12-1.75
215	P0524215	ARBOR HOUSING
216	P0524216	HEX NUT M8-1.25

REF	PART #	DESCRIPTION
217	P0524217	HEX BOLT M8-1.25 X 35
218	P0524218	LOCK COLLAR
219	P0524219	SET SCREW M8-1.25 X 10
220	P0524220	ARBOR HOUSING PIVOT SHAFT
221	P0524221	ARBOR HOUSING NUT TW22-P5
222	P0524222	BALL BEARING 6207ZZ
223	P0524223	BEARING SEAT
224	P0524224	ARBOR HOUSING END CAP
225	P0524225	CAP SCREW M6-1 X 30
226	P0524226	BUSHING
227	P0524227	ARBOR PULLEY
228	P0524228	KEY 10 X 8 X 40
229	P0524229	FLAT WASHER 10MM
230	P0524230	LOCK WASHER 10MM
231	P0524231	CAP SCREW M10-1.5 X 25
232	P0524232	SAW BLADE 12" X 1" X 48T X 4MM W



Head



Head Parts List

REF	PART #	DESCRIPTION
301	P0524301	STUD-SE M10-1.5 X 100, 20
302	P0524302	SET SCREW M6-1 X 6
303	P0524303	CHIP FUNNEL
304	P0524304	PHLP HD SCR M8-1.25 X 25
305	P0524305	LOCK WASHER 8MM
306	P0524306	SHAFT
307	P0524307	SIDE GUARD HINGE
308	P0524308	PHLP HD SCR M6-1 X 16
309	P0524309	BUSHING 6 X 10 X 10T
310	P0524310	BALL BEARING 696ZZ
311	P0524311	PHLP HD SCR M6-1 X 25
312	P0524312	WOBBLE ARM
313	P0524313	BUSHING 6 X 10 X 6T
314	P0524314	SIDE GUARD
315	P0524315	HEX NUT M6-1
316	P0524316	KNOB 7MM, STEEL
317V2	P0524317V2	HEX BOLT M10-1.5 X 70 V2.06.18
318	P0524318	HEX NUT M10-1.5
319	P0524319	LIMIT SWITCH BRACKET
320	P0524320	LIMIT SWITCH
321	P0524321	CAP SCREW M5-.8 X 12
322	P0524322	LIMIT SWITCH COVER
323	P0524323	PHLP HD SCR M5-.8 X 8
324	P0524324	BACK SAFETY GUARD
325	P0524325	FLAT WASHER 6MM
326	P0524326	SHAFT
327	P0524327	BEARING SEAT (RH)
328	P0524328	BALL BEARING 6204ZZ
329	P0524329	ROLLER, LARGE
330	P0524330	BEARING SEAT (LH)
331	P0524331	SPRING NUT M10-1.5
332	P0524332	COMPRESSION SPRING
333	P0524333	ROLLER ARM
334	P0524334	COMPRESSION SPRING 26 X 30 X 155

REF	PART #	DESCRIPTION
335	P0524335	ROLLER BRACKET
336	P0524336	ROLLER ARM PIVOT SHAFT
337	P0524337	GREASE FITTING M6-1 X 5
338	P0524338	SHOULDER SHAFT
339	P0524339	SET SCREW M6-1 X 10
340	P0524340	BEARING SEAT (LH)
341	P0524341	BALL BEARING 6302ZZ
342	P0524342	PHLP HD SCR M6-1 X 12
343	P0524343	ROLLER (LH)
344	P0524344	ROLLER (RH)
345	P0524345	BEARING SEAT (RH)
346	P0524346	ROLLER BRACKET
347	P0524347	HINGE
348	P0524348	SET SCREW M8-1.25 X 30
349	P0524349	ADJUSTABLE HANDLE M12-1.75 X 30
350	P0524350	FINGER PIVOT SHAFT
351-1	P0524351-1	ANTI-KICKBACK FINGER 5MM
351-2	P0524351-2	ANTI-KICKBACK FINGER 3MM
352	P0524352	PIVOT SHAFT BRACKET
353	P0524353	HOOK-TYPE BRACKET
354	P0524354	FINGER STOP SHAFT
355	P0524355	GIB
356	P0524356	CLAMP BAR (RH)
357	P0524357	POINTER
358	P0524358	LOCK WASHER 10MM
359	P0524359	HEX BOLT M10-1.5 X 30
360	P0524360	LOCK WASHER 12MM
361	P0524361	HEX BOLT M12-1.75 X 40
362	P0524362	PIVOT BRACKET
363	P0524363	CLAMP BAR (LH)
364	P0524364	HEX NUT M8-1.25
365	P0524365	ROLLER HOUSING
366	P0524366	GRIZZLY NAMEPLATE (LARGE)



Table & Cabinet

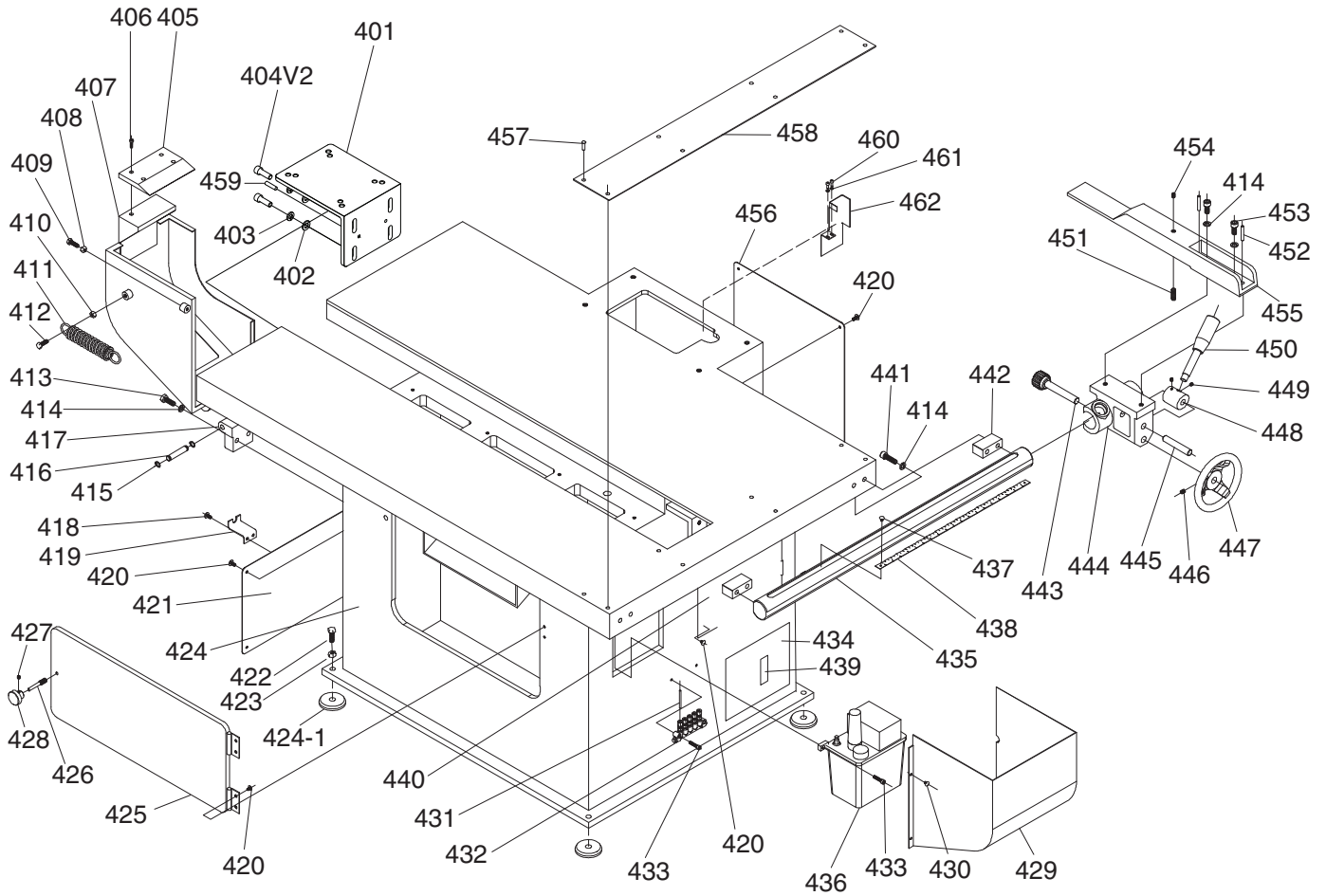


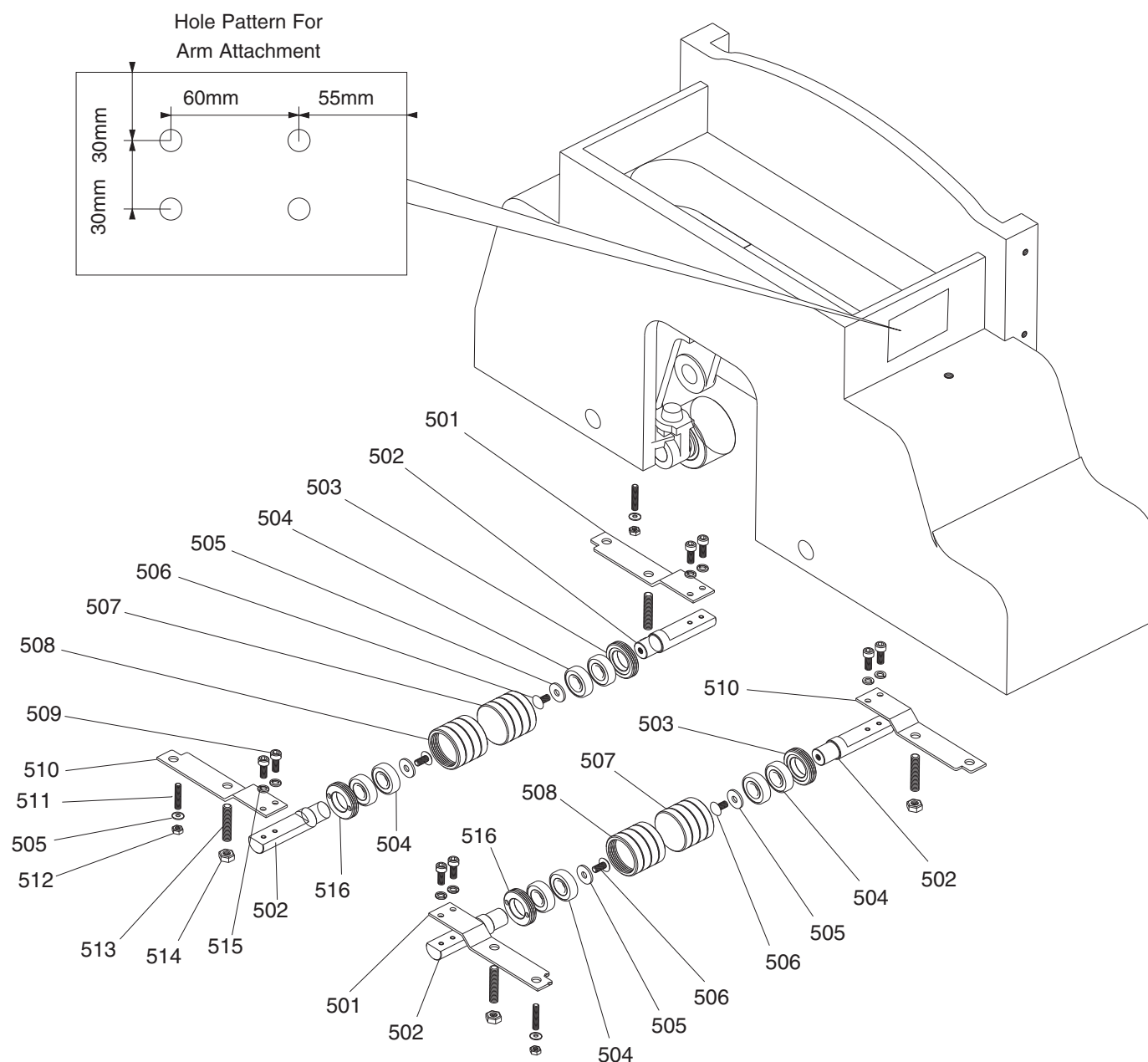
Table & Cabinet Parts List

REF	PART #	DESCRIPTION
401	P0524401	SUPPORT L-BRACKET
402	P0524402	FLAT WASHER 12MM
403	P0524403	LOCK WASHER 12MM
404V2	P0524404V2	CAP SCREW M12-1.75 X 35 V2.06.18
405	P0524405	COVER PLATE
406	P0524406	CAP SCREW M5-.8 X 16
407	P0524407	COVER PLATE BRACKET
408	P0524408	HEX NUT M8-1.25
409	P0524409	HEX BOLT M8-1.25 X 35
410	P0524410	HEX NUT M10-1.25
411	P0524411	COMPRESSION SPRING 22 X 25 X 152
412	P0524412	CAP SCREW M10-1.25 X 35
413	P0524413	HEX BOLT M10-1.5 X 45
414	P0524414	LOCK WASHER 10MM
415	P0524415	EXT RETAINING RING 12MM
416	P0524416	SHAFT
417	P0524417	BRACKET
418	P0524418	CAP SCREW M6-1 X 10
419	P0524419	BRACKET
420	P0524420	PHLP HD SCR M6-1 X 12
421	P0524421	COVER
422	P0524422	HEX BOLT M16-1.5 X 80
423	P0524423	HEX NUT M16-1.5
424	P0524424	CABINET
424-1	P0524424-1	CAST IRON FEET
425	P0524425	CABINET COVER (LH)
426	P0524426	STUD-SE M10-1.5 X 100, 20
427	P0524427	SET SCREW M6-1 X 6
428	P0524428	KNOB 7MM, STEEL
429	P0524429	LUBRICATOR COVER
430	P0524430	PHLP HD SCR M5-.8 X 8
431	P0524431	OIL TUBE

REF	PART #	DESCRIPTION
432	P0524432	LUBRICATION DISTRIBUTOR
433	P0524433	CAP SCREW M6-1 X 20
434	P0524434	CABINET COVER, FRONT
435	P0524435	RAIL W/RACK
436	P0524436	LUBRICATOR
437	P0524437	PHLP HD SCR M3-.5 X 8
438	P0524438	SCALE 480MM
439	P0524439	WINDOW, ACRYLIC
440	P0524440	ELECTRICAL CABINET DOOR
441	P0524441	CAP SCREW M10-1.5 X 60
442	P0524442	RAIL BRACKET
443	P0524443	GEAR SHAFT
444	P0524444	GEARBOX
445	P0524445	SHAFT
446	P0524446	SET SCREW M8-1.25 X 10
447	P0524447	HANDWHEEL
448	P0524448	LEVER HUB
449	P0524449	SET SCREW M6-1 X 10
450	P0524450	LEVER M12-1.75 X 140 W/KNOB
451	P0524451	STUD-FT M10 X 15 X 28
452	P0524452	DOWEL PIN #7 X 1-1/2"
453	P0524453	CAP SCREW M10-1.25 X 35
454	P0524454	SET SCREW M10-1.5 X 16
455	P0524455	FENCE
456	P0524456	CABINET COVER (RH)
457	P0524457	FLAT HD SCR M6-1 X 20
458	P0524458	SAFETY COVER
459	P0524459	TAPER PIN 7 X 35
460	P0524460	CAP SCREW M5-.8 X 12
461	P0524461	LOCK WASHER 5MM
462	P0524462	WIRING COVER



Auxiliary Rollers

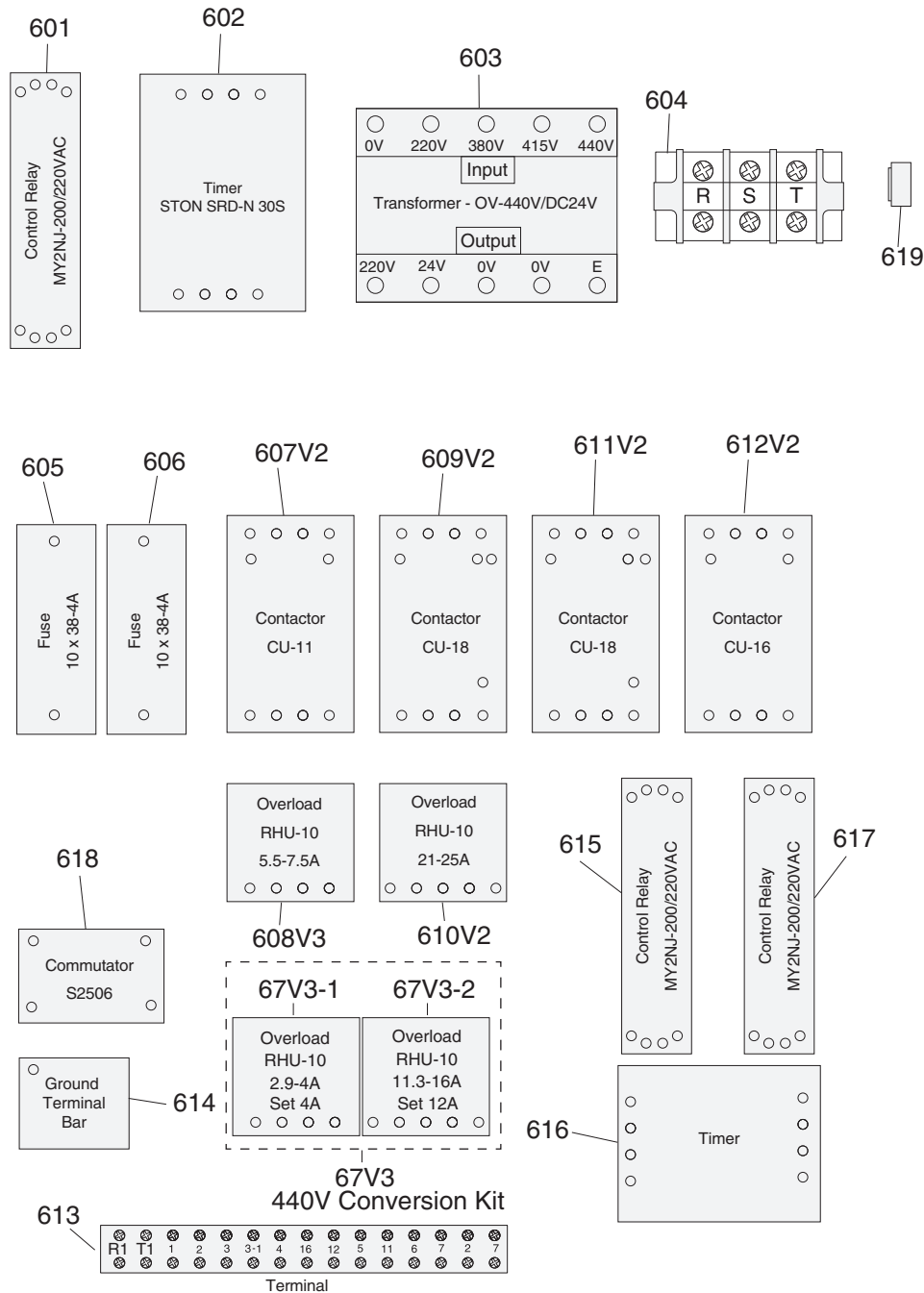


REF	PART #	DESCRIPTION
501	P0524501	SPRING BRACKET (RH)
502	P0524502	ROLLER SHAFT
503	P0524503	BEARING SEAT (RH)
504	P0524504	BALL BEARING 6003ZZ
505	P0524505	FLAT WASHER 6MM
506	P0524506	PHLP HD SCR M6-1 X 12
507	P0524507	ROLLER (RH)
508	P0524508	ROLLER (LH)

REF	PART #	DESCRIPTION
509	P0524509	CAP SCREW M6-1 X 16
510	P0524510	SPRING BRACKET (LH)
511	P0524511	SET SCREW M6-1 X 30
512	P0524512	HEX NUT M6-1
513	P0524513	STUD-FT M8-1.25 X 100
514	P0524514	HEX NUT M8-1.25
515	P0524515	LOCK WASHER 6MM
516	P0524516	BEARING SEAT (LH)



Electrical Panel

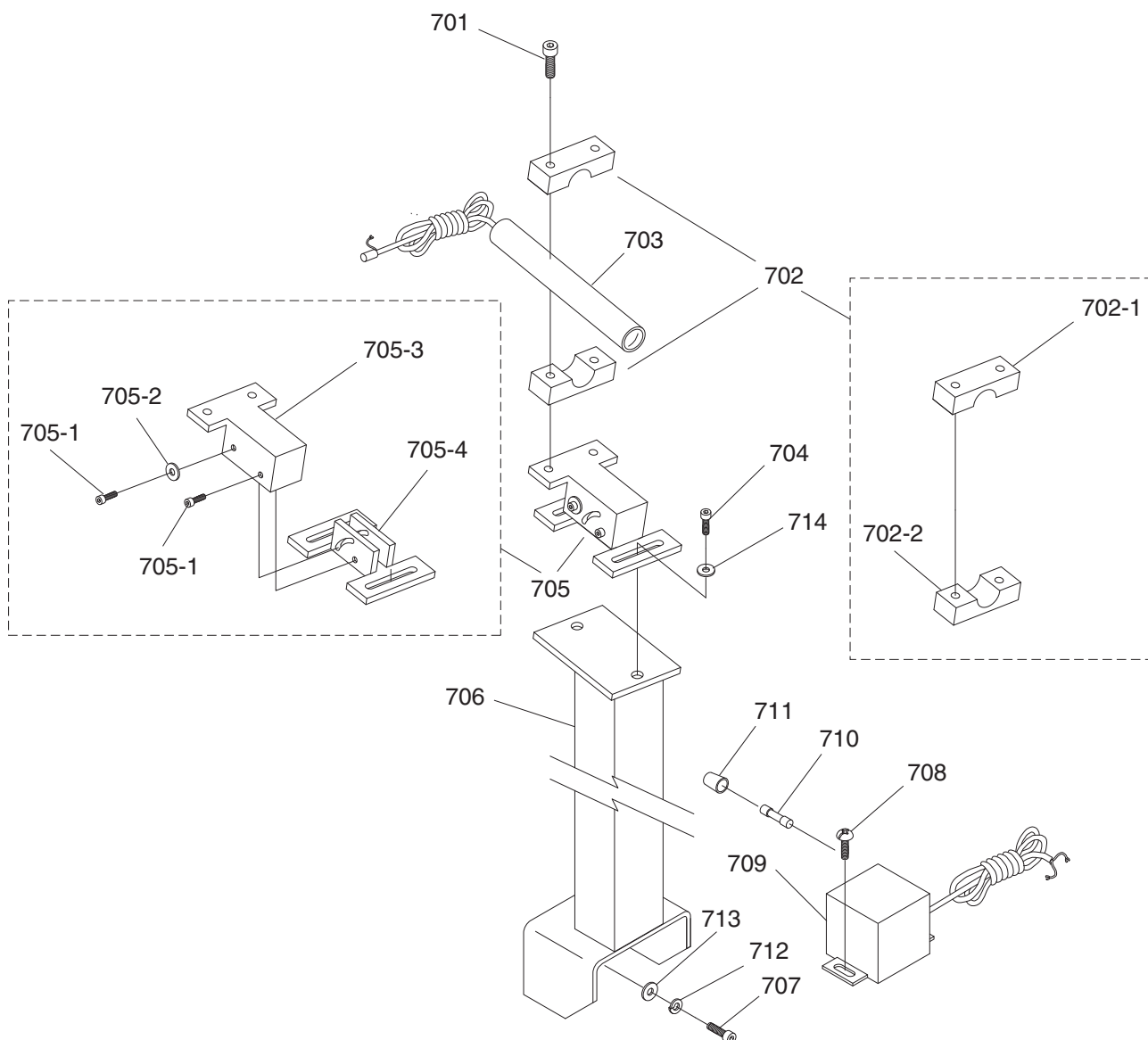


REF	PART #	DESCRIPTION
67V3	P0524067V3	440V CONVERSION KIT TECO V3.07.13
67V3-1	P0524067V3-1	OL RELAY RHU-10 2.9-4A V3.07.13
67V3-2	P0524067V3-2	OL RELAY RHU-10 11.3-16A V3.07.13
601	P0524601	RELAY OMROM MY2NJ-200/220VAC
602	P0524602	TIMER STON SRD-N 30S
603	P0524603	TRANSFORMER OV-440V/DC24V
604	P0524604	TERMINAL BAR 3-P
605	P0524605	FUSE 10 X 38 4A
606	P0524606	FUSE 10 X 38 4A
607V2	P0524607V2	CONTACTOR TECO CU-11 220V V2.09.10
608V3	P0524608V3	OL RELAY RHU-10 5.5-7.5A V3.07.13

REF	PART #	DESCRIPTION
609V2	P0524609V2	CONTACTOR TECO CU-18 220V V2.09.10
610V2	P0524610V2	OL RELAY RHU-10 21-25A V2.07.13
611V2	P0524611V2	CONTACTOR TECO CU-18 220V V2.09.10
612V2	P0524612V2	CONTACTOR TECO CU-16 220V V2.07.13
613	P0524613	TERMINAL BAR 15-P
614	P0524614	GROUND TERMINAL BAR 4-P
615	P0524615	RELAY OMROM MY2NJ-200/220VAC
616	P0524616	TIMER
617	P0524617	RELAY OMROM MY2NJ-200/220VAC
618	P0524618	COMMUTATOR S2506
619	P0524619	STRAIN RELIEF



Laser Guide

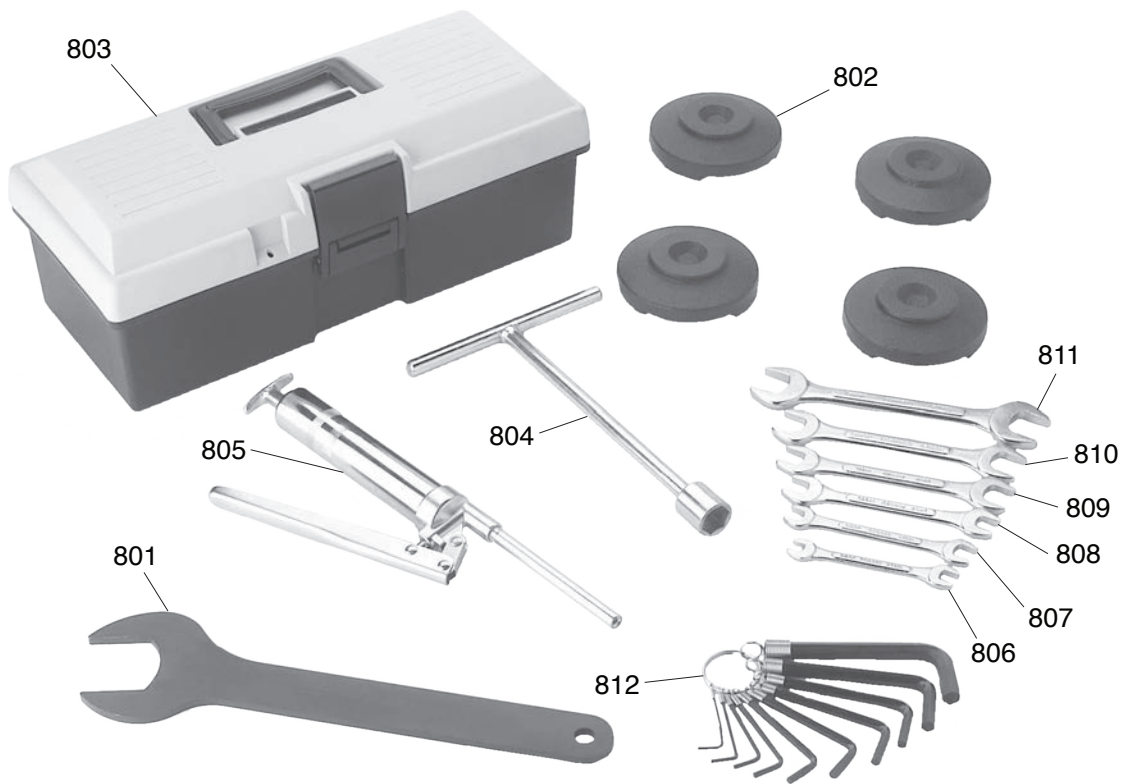


REF	PART #	DESCRIPTION
701	P0524701	CAP SCREW M6-1 x 35
702	P0524702	LASER CLAMP ASSY
702-1	P0524702-1	LASER CLAMP (TOP)
702-2	P0524702-2	LASER CLAMP (BOTTOM)
703	P0524703	LASER
704	P0524704	CAP SCREW M6-1 X 16
705	P0524705	LASER BRACKET ASSY
705-1	P0524705-1	CAP SCREW M4-.7 X 8
705-2	P0524705-2	FLAT WASHER 4MM
705-3	P0524705-3	LASER BRACKET (TOP)

REF	PART #	DESCRIPTION
705-4	P0524705-4	LASER BRACKET (BOTTOM)
706	P0524706	LASER SUPPORT ARM
707	P0524707	CAP SCREW M8-1.25 X 25
708	P0524708	PHLP HD SCR M5-.8 X 8
709	P0524709	LASER POWER BOX
710	P0524710	FUSE T1AL250V
711	P0524711	FUSE COVER
712	P0524712	LOCK WASHER 8MM
713	P0524713	FLAT WASHER 8MM
714	P0524714	FLAT WASHER 8MM



Accessories



REF	PART #	DESCRIPTION
801	P0524801	ARBOR WRENCH 45MM
802	P0524802	CAST IRON FOOT
803	P0524803	TOOLBOX
804	P0524804	T-HANDLE WRENCH 19MM
805	P0524805	GREASE GUN
806	P0524806	WRENCH 8 X 10MM OPEN-ENDS

REF	PART #	DESCRIPTION
807	P0524807	WRENCH 10 X 12MM OPEN-ENDS
808	P0524808	WRENCH 11 X 13MM OPEN-ENDS
809	P0524809	WRENCH 14 X 17MM OPEN-ENDS
810	P0524810	WRENCH 17 X 19MM OPEN-ENDS
811	P0524811	WRENCH 22 X 24MM OPEN-ENDS
812	P0524812	HEX WRENCH 1.5-10MM 10PC SET



Troubleshooting

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Motor will not start.	<ol style="list-style-type: none"> 1. Low voltage. 2. Open circuit in motor or loose connections. 	<ol style="list-style-type: none"> 1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	<ol style="list-style-type: none"> 1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Incorrect fuses or circuit breakers in power line. 	<ol style="list-style-type: none"> 1. Inspect cord or plug for damaged insulation and shorted wires. 2. Inspect all connections on motor for loose or shorted terminals or worn insulation. 3. Install correct fuses or circuit breakers.
Motor overheats.	<ol style="list-style-type: none"> 1. Motor overloaded. 2. Air circulation through the motor restricted. 	<ol style="list-style-type: none"> 1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	<ol style="list-style-type: none"> 1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded. 	<ol style="list-style-type: none"> 1. Inspect connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows when operating.	<ol style="list-style-type: none"> 1. Belts loose. 	<ol style="list-style-type: none"> 1. Tighten belts.
Loud, repetitious noise coming from machine.	<ol style="list-style-type: none"> 1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective. 	<ol style="list-style-type: none"> 1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Tighten fan or shim cover. 3. Replace V-belts.
Hand wheels will not turn.	<ol style="list-style-type: none"> 1. Hand wheel key is inserted too far. 2. Bullets are wedged. 3. Roll pin or setscrew in worm gear is contacting geared trunnion. 	<ol style="list-style-type: none"> 1. Remove hand wheel and adjust key. 2. Remove hand wheel and adjust bullets. 3. Inspect roll pins and setscrews in the worm gear. Tighten if necessary.



G0524 Control Panel Wiring

DANGER

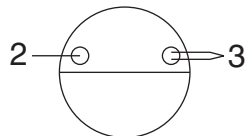
Disconnect power from machine before performing any electrical service. Failure to do this will result in a shock hazard, leading to injury or death.

NOTICE

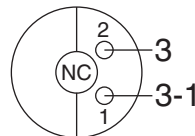
The wires from the power supply, except the green ground wire, are interchangeable, therefore colors are not specified.

Control Panel (Back-Side)

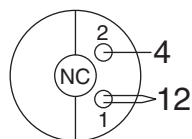
Power Light



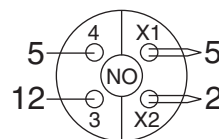
Emergency Stop



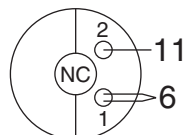
Saw Blade Stop



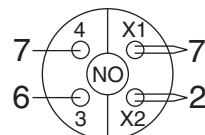
Saw Blade Start



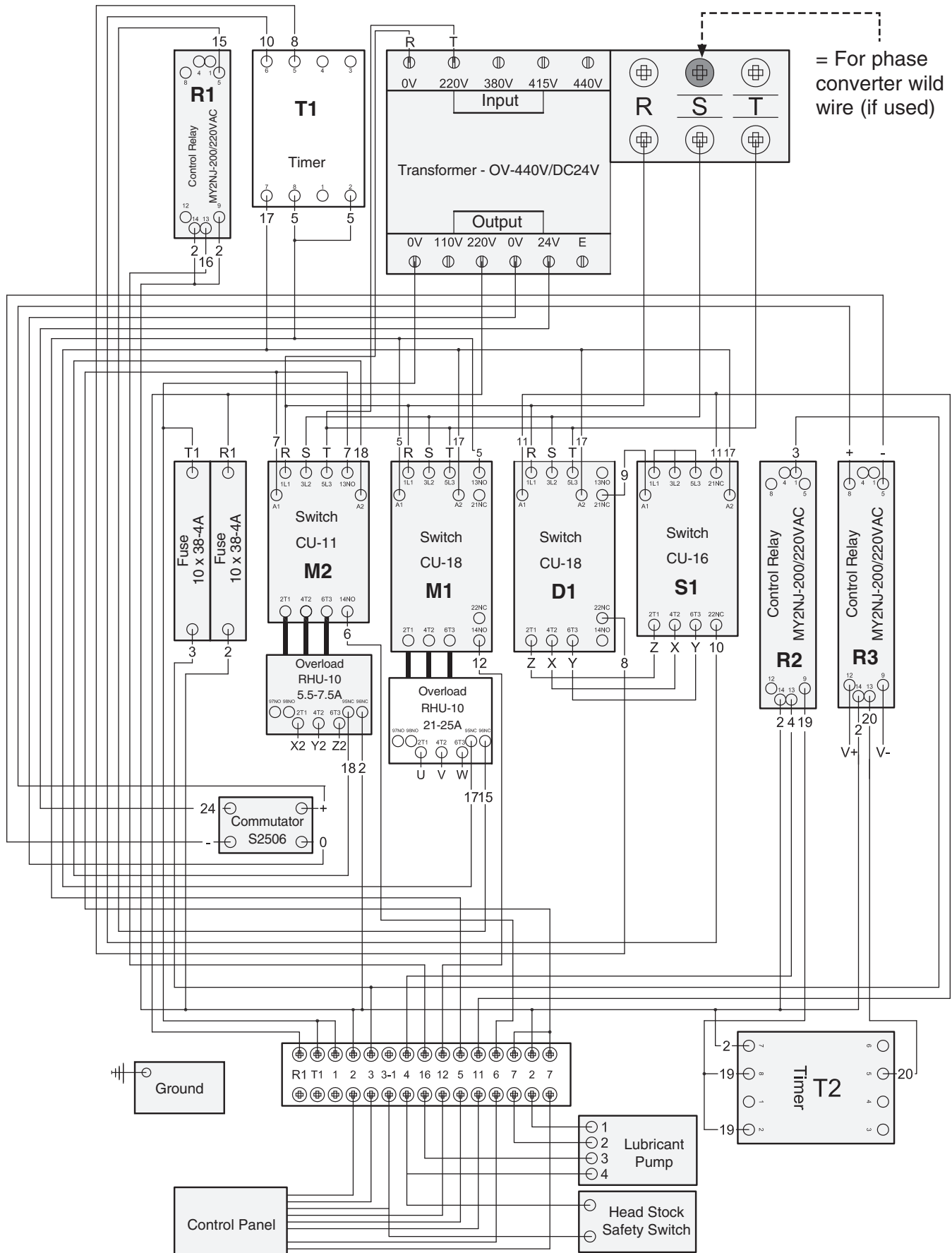
Conveyor Stop



Conveyor Start



G0524 Electrical Box Wiring



G0524 Main & Feed Motor Wiring

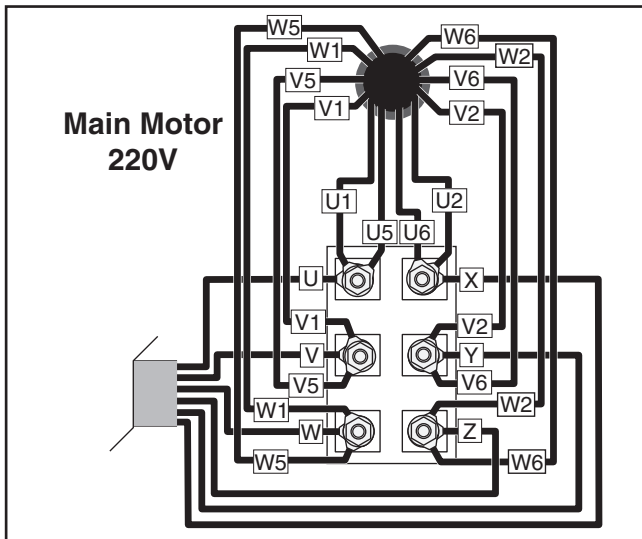


Figure 46. 220V main motor wiring.

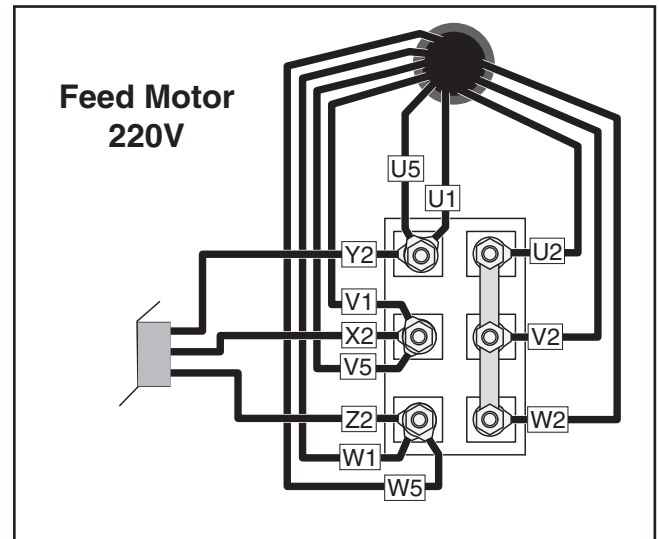


Figure 49. 220V feed motor wiring.

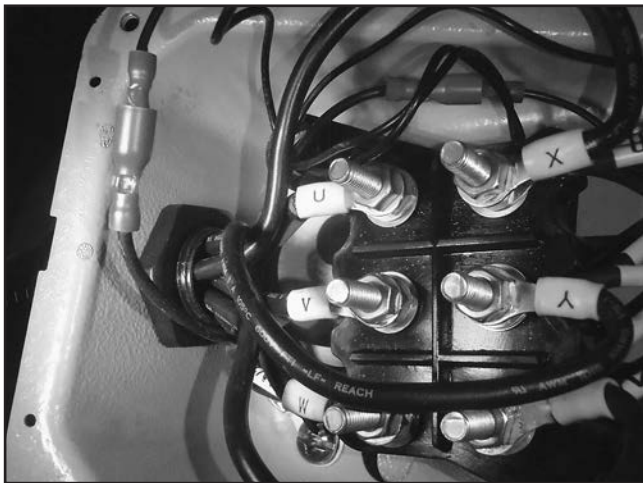


Figure 47. 220V main motor wiring.



Figure 50. 220V feed motor wiring.

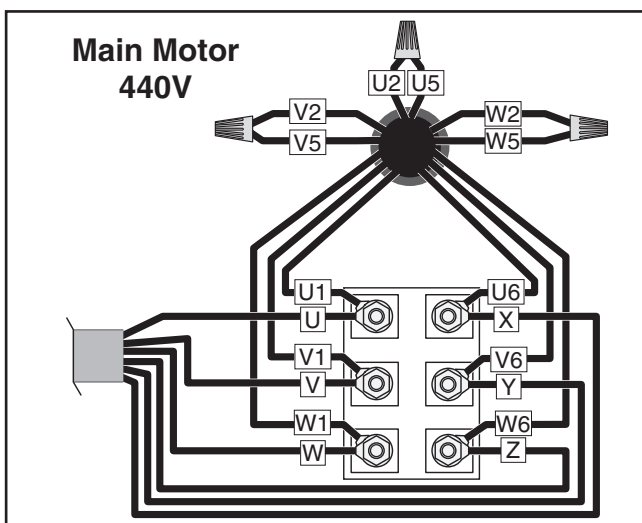


Figure 48. Main motor wired for 440V.

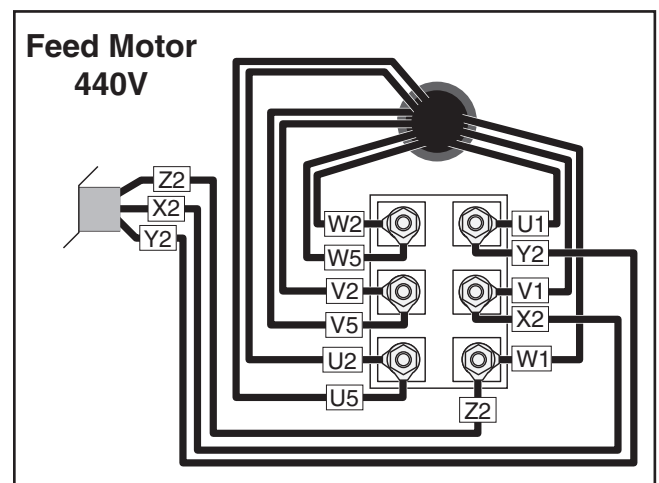


Figure 51. Feed motor wired for 440V.



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.

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

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

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

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



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**

