MODEL G0561
7" X 12" METAL-CUTTING
BANDSAW
OWNER'S MANUAL
(For models manufactured since 01/18)
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.

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

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

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

Machine Description

The Model G0561 Metal-Cutting Bandsaw has a flexible continuous blade that is used to make straight cuts in metal stock.

The clamping vise adjusts for cuts between 0° and 45°. There are four blade speeds (90, 135, 195, and 255 FPM), with an adjustable feed rate for the correct blade pressure on the workpiece. The pump-controlled coolant system helps provide optimum working results and extended longevity of blades.

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.

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
Identification

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

A. Blade Tension Handle  
B. Blade Guide Adjustment Knob  
C. Coolant Control Valve  
D. Blade Guides  
E. 1 HP Motor  
F. Feed Rate Control Knob  
G. Feed ON/OFF Valve Lever  
H. Pump ON/OFF Switch  
I. Motor ON/OFF Switch  
J. Vise Handwheel  
K. Automatic Shut-Off Tab  
L. Blade Tracking Controls

⚠️ 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.
Controls & Components

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

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

Headstock

Figure 1. Headstock controls and components.

A. Blade Tension Handle: Increases or decreases blade tension.

B. Blade Tracking Controls: Adjusts front blade wheel tilt to move blade to or from wheel shoulder.

C. Coolant Control Valve: Adjusts cutting fluid flow rate.

D. Blade Guide Adjustment Knob: Adjusts front blade guide that supports blade. Position guide as close to workpiece as possible to prevent blade from twisting.

Horizontal Downfeed

Figure 2. Downfeed controls and components.

E. Downfeed Stop Bolt: Stops headstock from lowering farther than completion of cut.

F. Automatic Shut-Off Tab: Turns machine OFF when headstock is fully lowered.

G. Feed ON/OFF Valve Lever: Opens to lower headstock until it contacts downfeed stop bolt; closes to stop headstock from lowering.

H. Feed Rate Control Knob: Increases feed rate when turned clockwise and decreases feed rate when turned counterclockwise.

Vertical Operation

Figure 3. Vertical work table.

I. Vertical Work Table: Supports workpiece during vertical cutting operations.
**Vise**

- **J. Rear Vise Jaw:** Adjusts workpiece angle relative to blade.
- **K. Work Stop:** Supports repetitive cutting operations.
- **L. Movable Vise Jaw:** Holds workpiece against rear vise jaw during cutting operation.
- **M. Vise Handwheel:** Adjusts movable vise jaw.

**Figure 4.** Vise controls and components.

**Electrical**

- **N. Motor ON/OFF Switch:** Turns motor ON when moved up and OFF when moved down.
- **O. Pump ON/OFF Switch:** Turns coolant pump ON when moved up and OFF when moved down.

**Figure 5.** Electrical controls and components.
# MODEL G0561 7" X 12" METAL-CUTTING BANDSAW

## Product Dimensions:
- **Weight:** 330 lbs.
- **Width (side-to-side) x Depth (front-to-back) x Height:** 48 x 16 x 40 in.
- **Footprint (Length x Width):** 38 x 13 in.

## Shipping Dimensions:
- **Type:** Wood Slat Crate
- **Content:** Machine
- **Weight:** 343 lbs.
- **Length x Width x Height:** 19 x 51 x 41 in.
- **Must Ship Upright:** Yes

## Electrical:
- **Power Requirement:** 115V or 230V, Single-Phase, 60 Hz
- **Prewired Voltage:** 115V
- **Full-Load Current Rating:** 12.6A at 115V, 6.3A at 230V
- **Minimum Circuit Size:** 15A at 115V, 15A at 230V
- **Connection Type:** Cord & Plug
- **Power Cord Included:** Yes
- **Power Cord Length:** 84 in.
- **Power Cord Gauge:** 14 AWG
- **Plug Included:** Yes
- **Included Plug Type:** 5-15 for 115V
- **Recommended Plug Type:** 6-15 for 230V
- **Switch Type:** Sealed Toggle Switch w/Automatic Shut-Off

## Motors:
### Main
- **Horsepower:** 1 HP
- **Phase:** Single-Phase
- **Amps:** 12A/6A
- **Speed:** 1720 RPM
- **Type:** TEFC Capistor-Start Induction
- **Bearings:** Shielded & Permanently Lubricated
- **Centrifugal Switch/Contacts Type:** External

### Coolant Pump
- **Horsepower:** 1/8 HP
- **Phase:** Single-Phase
- **Amps:** 0.6A/0.3A
- **Speed:** 3400 RPM
- **Type:** TEFC Induction
- **Power Transfer:** Direct
- **Bearings:** Shielded & Permanently Lubricated
Main Specifications:

Operation Info
Blade Speeds.......................................................................................................................... 90, 135, 195, 255 FPM
Std. Blade Length.................................................................................................................. 93 in.
Blade Length Range............................................................................................................. 3/4 in.

Cutting Capacities
Angle Cuts.............................................................................................................................. 0 - 45 deg.
Vise Jaw Depth....................................................................................................................... 9-3/4 in.
Vise Jaw Height..................................................................................................................... 4 in.
Max. Capacity Rectangular Height at 90 Deg................................................................. 7 in.
Max. Capacity Rectangular Width at 90 Deg................................................................. 12 in.
Max. Capacity Round at 90 Deg....................................................................................... 7 in.
Max. Capacity Rectangular Height at 30 Deg................................................................. 7-3/4 in.
Max. Capacity Rectangular Width at 30 Deg................................................................. 8 in.
Max. Capacity Round at 30 Deg....................................................................................... 7 in.
Max. Capacity Rectangular Height at 45 Deg................................................................. 4-3/4 in.
Max. Capacity Rectangular Width at 45 Deg................................................................. 4-1/2 in.
Max. Capacity Round at 45 Deg....................................................................................... 5 in.

Construction
Table.................................................................................................................................... Cast Iron
Upper Wheel.......................................................................................................................... Cast Iron
Lower Wheel....................................................................................................................... Cast Iron
Body..................................................................................................................................... Cast Iron
Base.................................................................................................................................. Stamped Steel
Wheel Cover..................................................................................................................... Pre-formed Steel
Paint Type/Finish............................................................................................................... Epoxy

Other
Wheel Size......................................................................................................................... 11-1/2 in.
Blade Guides Upper.......................................................................................................... Ball Bearing
Blade Guides Lower.......................................................................................................... Ball Bearing
Coolant Capacity............................................................................................................... 2-1/2 GAL

Table Info
Table Size Length............................................................................................................. 20-1/2 in.
Table Size Width............................................................................................................. 6-3/4 in.
Floor To Cutting Area Height......................................................................................... 21 in.

Other Specifications:
Country of Origin .............................................................................................................. China
Warranty .............................................................................................................................. 1 Year
Approximate Assembly & Setup Time .......................................................................... 30 Minutes
Serial Number Location .................................................................................................... ID Label on Body Frame
ISO 9001 Factory .............................................................................................................. Yes

Features:
Hydraulic Feed Control
Quick-Release Vise
Automatic Shut-Off
Coolant System
Includes Blade
SECTION 1: SAFETY

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

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

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

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

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

NOTICE Alerts the user to useful information about proper operation of the machine to avoid machine damage.

Safety Instructions for Machinery

⚠️ WARNING

OWNER’S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make your workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.
WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

HAZARDOUS DUST. Dust created by machinery operations may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material. Always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

USE CORRECT TOOL FOR THE JOB. Only use this tool for its intended purpose—do not force it or an attachment to do a job for which it was not designed. Never make unapproved modifications—modifying tool or using it differently than intended may result in malfunction or mechanical failure that can lead to personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTanders. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly BEFORE operating machine.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner’s manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine OFF and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

DAMAGED PARTS. Regularly inspect machine for damaged, loose, or mis-adjusted parts—or any condition that could affect safe operation. Immediately repair/replace BEFORE operating machine. For your own safety, DO NOT operate machine with damaged parts!

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.
Additional Safety for Metal Bandsaws

**WARNING**

Serious injury or death can occur from getting fingers, hair, or clothing entangled in rotating or moving parts. Long-term respiratory damage can occur from breathing metal dust created while cutting. 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. Make sure blade is properly tensioned and tracking before operating.

**CLEARING JAMS AND CUTOFFS.** Always stop bandsaw and disconnect power before clearing scrap pieces. Use brush or push stick, not hands, to clean swarf/cutoff scraps from table or vise.

**HAND PLACEMENT.** Never position hands or fingers in line with cut, under table during vertical cutting operations, or under bandsaw headstock while it is lowering or operating in horizontal position. Hands could be cut or crushed. Placing hands or fingers in line with blade or too close to blade during vertical cutting operations may result in serious injury if hands slip or workpiece moves unexpectedly.

**BLADE CONTROL.** To avoid risk of injury due to blade contact, always allow blade to stop on its own. DO NOT try to stop or slow blade with hand or workpiece.

**WORKPIECE HANDLING.** Always properly support workpiece with table, vise, or some type of support fixture. Always feed stock evenly and smoothly during vertical cutting operations; secure workpiece in vise and never hold workpiece with hands during horizontal cutting operations. Flag long workpieces to avoid tripping hazard.

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

**UNSTABLE WORKPIECES.** Workpiece cannot be held in vise while cutting in vertical position and an unstable workpiece that unexpectedly moves while cutting can draw operator's hand into blade, causing serious injury. If workpiece cannot be safely supported by hand in vertical position or by vise/jig in horizontal position, DO NOT cut workpiece on this machine. Examples are chains, cables, round/oblong-shaped workpieces, those with internal/built-in moving/rotating parts, etc.

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

**SMALL/NARROW WORKPIECES DURING VERTICAL CUTTING.** If hands slip during cut while holding small workpieces with fingers, serious personal injury could occur.

**BLADE SPEED.** Cutting workpiece before blade is at full speed could cause blade to grab workpiece and break blade or pull hands into blade while cutting in vertical position. Allow blade to reach full speed before starting cut. DO NOT start machine with workpiece contacting blade.

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

**ENTANGLEMENT HAZARDS.** Do not operate saw without blade guard and covers in place. Do not wear loose clothing, jewelry, long hair, and gloves that can be entangled in moving parts.

**BLADE REPLACEMENT.** When replacing blades, disconnect machine from power, wait for moving parts to come to complete stop, and wear gloves and safety glasses to protect hands and eyes. Make sure teeth of new blade face workpiece in direction of blade travel.

**FITTING 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.
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.

⚠️ WARNING
Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

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 115V... 12.6 Amps**
**Full-Load Current Rating at 230V .... 6.3 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 115V
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
- Plug/Receptacle ..................... NEMA 5-15

Circuit Requirements for 230V
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 ........... 208V, 220V, 230V, 240V
- Cycle............................................. 60 Hz
- Phase...................................... Single-Phase
- Power Supply Circuit .............. 15 Amps
- Plug/Receptacle ..................... NEMA 6-15
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.
Voltage Conversion
The voltage conversion MUST be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the main and coolant motors, replacing the circuit breaker, and installing the correct plug. A wiring diagram is provided in the WIRING section, beginning on Page 48, for your reference.

IMPORTANT: If the diagram included on either motors conflicts with the one in the WIRING section, the motor may have changed since the manual was printed. Use the diagram included on the applicable motor junction box cover instead.

Items Needed

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phillips Head Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket 7mm</td>
<td>1</td>
</tr>
<tr>
<td>Electrical Tape</td>
<td>1</td>
</tr>
<tr>
<td>Wire Nut (14#AWG x 3)</td>
<td>1</td>
</tr>
<tr>
<td>Hex Nut 8-36</td>
<td>1</td>
</tr>
<tr>
<td>Circuit Breaker 7A (#P0561300V4-6X)</td>
<td>1</td>
</tr>
<tr>
<td>Plug 6-15</td>
<td>1</td>
</tr>
<tr>
<td>Wire Stripper</td>
<td>1</td>
</tr>
</tbody>
</table>

To convert Model G0561 to 230V:

1. DISCONNECT MACHINE FROM POWER!

2. Cut off the included plug.

3. Open the main and coolant motor junction boxes, remove the wire nuts on the main motor, and loosen the terminal nut on the coolant motor, as indicated in Figure 8.

4. Connect the main motor wires with wire nuts (see Figure 9). Once snug, wrap electrical tape around each wire nut and the connected wires, to reduce the likelihood of the wire nut vibrating loose during motor operation.

5. Connect the wires on the coolant motor, as shown in Figure 9, with an 8-36 hex nut on the center terminal.

6. Replace the pre-installed 13A circuit breaker with a 7A circuit breaker (see Figure 10).

7. Close and secure the motor junction boxes.

8. Install a 6-15 plug on the end of the cord, according to the instructions and wiring diagrams provided by the plug manufacturer.

— If the plug manufacturer did not include instructions, the wiring of a generic NEMA 6-15 plug is illustrated on Page 49.
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.

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety Glasses (for each person)</td>
<td>1</td>
</tr>
<tr>
<td>Solvent/Cleaner</td>
<td>As Needed</td>
</tr>
<tr>
<td>Disposable Rags</td>
<td>As Needed</td>
</tr>
<tr>
<td>Disposable Gloves</td>
<td>As Needed</td>
</tr>
<tr>
<td>Phillips Head Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Open-End Wrenches 1/2&quot;, 14mm</td>
<td>1 Ea.</td>
</tr>
<tr>
<td>Wrench or Socket 1/2&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Open-End Wrenches 9/16&quot;</td>
<td>2</td>
</tr>
<tr>
<td>Straigntedge</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 1/8&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Round Steel Bar Stock (1/2&quot; x 3&quot;)</td>
<td>2</td>
</tr>
<tr>
<td>Lifting Slings (Rated for at least 400 lbs.)</td>
<td>2</td>
</tr>
<tr>
<td>Lifting Equipment (Rated for at least 400 lbs.)</td>
<td>1</td>
</tr>
<tr>
<td>Additional Person</td>
<td>As Needed</td>
</tr>
<tr>
<td>Wooden Blocks</td>
<td>As Needed</td>
</tr>
</tbody>
</table>

---

**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.

<table>
<thead>
<tr>
<th>Box Contents (Figure 11)</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Pulley Cover</td>
<td>1</td>
</tr>
<tr>
<td>B. Collar</td>
<td>1</td>
</tr>
<tr>
<td>C. Wheels</td>
<td>2</td>
</tr>
<tr>
<td>D. Axle</td>
<td>1</td>
</tr>
<tr>
<td>E. Leveling Feet</td>
<td>2</td>
</tr>
<tr>
<td>F. Chip Screen</td>
<td>1</td>
</tr>
<tr>
<td>G. Work Stop</td>
<td>1</td>
</tr>
<tr>
<td>H. Work Stop Rod</td>
<td>1</td>
</tr>
<tr>
<td>I. Vertical Work Table</td>
<td>1</td>
</tr>
<tr>
<td>J. Table Bracket</td>
<td>1</td>
</tr>
<tr>
<td>K. V-Belt 3V270 (Not Shown)</td>
<td>1</td>
</tr>
<tr>
<td>L. Motor (Not Shown)</td>
<td>1</td>
</tr>
</tbody>
</table>

Hardware Bag (Not Shown)
- Flat Washers 3/8" (Leveling Feet) ........ 2
- Hex Nuts 3/16"-16 (Leveling Feet) ....... 2
- Cotter Pins 3 x 30mm (Wheels) .......... 4
- Flat Washers 5/16" (Wheels) .............. 4
- Flat Head Screw 1/4"-20 x 1/2" (Table) .... 1
- Hex Nut 1/4"-20 (Table) ................... 1
- Knob 1/4"-20 x 5/8" (Pulley Cover) ...... 1
- Hose Clamps 5/8" (Coolant Hose) ........ 2
- Hex Bolts 5/16"-18 x 1" (Motor) ......... 4
- Hex Nuts 5/16"-18 (Motor) ............... 2
- Flat Washers 5/16" (Motor) ............... 2

Figure 11. Box contents.
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.

WARNING
Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. Avoid using these products to clean machinery.

CAUTION
Many cleaning solvents are toxic if inhaled. Only work in a well-ventilated area.

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

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 12. 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 13. 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. Remove hex bolt, flat washer, and hex nut shown in **Figure 14** to remove shipping bracket.

   **Note:** Bracket helps maintain bow alignment during shipping. Store bracket in case you need to move or ship the machine later.

![Figure 14](image)

   **Figure 14.** Location of shipping bracket and fasteners.

2. Remove motor from cabinet.

3. Slide motor mount plate into motor mount bracket (see **Figure 15**).

![Figure 15](image)

   **Figure 15.** Motor installed on motor mount bracket.

4. Install V-belt onto top sheaves of pulleys.

5. Loosely thread (2) 5/16"-18 x 1" hex bolts with 5/16" flat washers into motor mount bracket (see **Figure 16**).

![Figure 16](image)

   **Figure 16.** Motor mounting fasteners installed.

6. Thread (2) 5/16"-18 x 1" hex bolts with 5/16" hex nuts into side of motor mount plate (see Figure 16). Adjust hex bolts and motor until there is about 1/4" of belt deflection when belt is pressed with moderate pressure between center of pulleys (see **Figure 17**).

![Figure 17](image)

   **Figure 17.** Checking belt deflection.

7. Without moving hex bolts, tighten hex nuts from **Step 6** against motor mount plate to secure motor tension.

8. Tighten hex bolts from **Step 5**.
9. Use straightedge to check pulley alignment. If pulleys are not aligned, loosen motor pulley set screws (see Figure 15 on Page 18), adjust pulley, then re-tighten set screw.

10. Slide collar onto bottom side of pulley cover and snap in place, as shown in Figure 18.

![Figure 18. Collar installed.](image)

11. Remove (2) pre-installed ¼"-20 x ½" hex bolts and ¼" flat washers (see Figure 19).

12. Slide pulley cover over pulleys (see Figure 19).

13. Align holes and secure with fasteners you removed in Step 11 (see Figure 19).

![Figure 19. Pulley cover installed.](image)

14. Close pulley cover lid and secure with ¼"-20 x 5/8" knob (see Figure 20).

![Figure 20. Secured pulley cover lid.](image)

15. Move coolant tank into cabinet.

16. Push hose over coolant tank fitting and secure with hose clamp (see Figure 21).

![Figure 21. Coolant hose installed.](image)
17. Place chip screen into opening shown in Figure 22.

![Figure 22. Chip screen installed.](image)

18. Unbolt machine from pallet.

19. Insert round steel bar stock through (4) lifting holes in machine base (see Figure 23).

**Note:** Bar stock must be at least \( \frac{1}{2} \)" diameter and 3 feet long. Otherwise, it may not be big enough to properly support weight of machine.

20. Attach lifting slings to steel bar stock and power lifting equipment (see Figure 23).


22. Slide axle through rear holes in bottom of cabinet.

23. Slide (1) flat washer onto each end of axle, followed by (1) wheel and another washer. Secure wheels with cotter pins, as shown in Figure 24.

![Figure 24. Wheels secured with cotter pin.](image)

24. Install (1) \( \frac{3}{8} \)-16 hex nut and \( \frac{3}{8} \)" flat washer onto each leveling foot, then thread feet into front base of cabinet, as shown in Figure 25.

![Figure 25. Leveling feet attached.](image)
25. With help of an assistant, remove bandsaw from blocks.

26. Adjust feet to level bandsaw as needed, then tighten hex nuts against machine base to secure.

27. Insert work stop rod through hole in base and lock in place with hex bolt (see Figure 26).

28. Slide work stop over rod, then tighten thumb screw to secure (see Figure 26).

---

**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. Fill cutting fluid reservoir as described in Cutting Fluid System section on Page 38.

3. Open coolant control valve (see Figure 27).

---

**NOTICE**

NEVER turn ON coolant pump without cutting fluid in the reservoir or when cutting fluid is low or you will overheat pump and void warranty!

---

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 motors power up and run correctly, and 2) the automatic shut-off tab shuts down power.
4. Raise bow about halfway, then close feed ON/OFF valve to lock bow in place (see Figure 28).

5. Connect machine to power supply.

6. Use motor ON/OFF switch (see Figure 29) to turn machine ON and verify motor operation.

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

7. Use pump ON/OFF switch (see Figure 29) to turn coolant pump ON. Coolant should flow through blade guide and onto blade.

8. Turn OFF pump.

9. Open feed ON/OFF valve to fully lower headstock. When headstock is in lowest position, automatic shut-off tab should switch power OFF.

   — If shut-off tab does switch power OFF, tab is functioning correctly. Congratulations! Test Run is complete.

   — If shut-off 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.

Inspections & Adjustments

The following list of adjustments were performed at the factory before the machine was shipped:

- Blade Tension & Tracking..............Page 45
- Squaring the Blade......................Page 46
- Blade Guide Bearings .....................Page 46

Be aware that these can change during the shipping process. Pay careful attention to these adjustments when first operating the machine. If you find that the adjustments are not set to your personal preferences, re-adjust them.
SECTION 4: OPERATIONS

Operation Overview

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

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

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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts blade tilt, if necessary, to correct angle of desired cut.
3. Adjusts fence to desired width of cut, then locks it in place.
4. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through blade without interference.
5. Puts on personal protective equipment, and locates push sticks if needed.
7. Feeds workpiece all the way through blade while maintaining firm pressure on workpiece against table and fence, and keeping hands and fingers out of blade path and away from blade.
8. Stops machine.

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

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

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

Tips for horizontal cutting:

- Use work stop to quickly and accurately cut multiple pieces of stock to same length.
- Clamp material firmly in vise jaws to ensure a straight cut through the material.
- Let blade reach full speed before engaging workpiece (see Figure 30). Never start a cut with blade in contact with workpiece.
- Wait until blade has completely stopped before removing workpiece from vise, and avoid touching cut end—it could be very hot!
- Support long workpieces so they won’t fall when cut, and flag ends of workpieces to alert passers-by of potential danger.
- Position blade guides approximately 1/4” from workpieces to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

Tips for vertical cutting:

- Workpieces that cannot be properly supported or stabilized without a vise should not be cut in vertical position. Examples are chains, cables, round or oblong-shaped workpieces, workpieces with internal or built-in moving or rotating parts, etc.
- Make sure that vertical table assembly is securely fastened to bandsaw frame so it will adequately support workpiece.
- Always keep your fingers away from blade and always hold workpiece securely with appropriate clamping device.
- Adjust blade guides as close as possible to workpiece to minimize side-to-side blade movement.

NOTICE

Loosen blade tension at end of each day to prolong blade life.
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 31. 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
G0561 | ..........................................................93"

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

Model | Blade Width
G0561 | ...............................................................3/4"

Tooth Type
The most common tooth types are described as follows, and illustrated in Figure 32.

- **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 33, 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 35 for further details.

![Figure 32. Bandsaw blade tooth types.](image-url)

![Figure 33. General guidelines for blade selection and speed chart.](image-url)
Changing Blade

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

To change blade:

1. DISCONNECT MACHINE FROM POWER!

2. Raise bow of bandsaw to vertical position, close feed ON/OFF valve, and open wheel access cover.

3. Remove blade guards.

4. Loosen tension handle shown in Figure 34 and slip blade off of wheels.

5. Install new blade around bottom wheel and through both blade guide bearings.

6. With blade around bottom wheel, slip it around top wheel as shown in Figure 35, keeping blade between blade guide bearings.

![Figure 35. Installing blade.](image)

Note: It is 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 36. Some blades have a directional arrow as a guide.

7. When blade is around both wheels, adjust so back of blade is against shoulder of wheels.

8. Complete blade change by following steps in Adjusting Blade Tension on Page 28.

![Figure 34. Location of tension handle.](image)

![Figure 36. Blade teeth facing workpiece.](image)

CAUTION
CUTTING HAZARD! Bandsaw blades are sharp and awkward to hold. Protect your hands with heavy gloves when handling blade.
Adjusting Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting. The Model G0561 features a blade tension indicator to assist you with blade tensioning.

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

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

To adjust blade tension:

1. Turn blade tension handle clockwise to tension blade (see Figure 37).

2. Tension blade until blade tension guide indicator is in green zone (see Figure 38).

3. To fine tune blade tension, use a blade tensioning gauge, like one found in SECTION 5: ACCESSORIES on Page 39. Follow instructions included with your gauge and blade manufacturer’s recommendations on blade tension.

Figure 37. Location of blade tension handle.

Figure 38. Location of blade tension guide.
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 35 and Chip Inspection Chart on Page 30). 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 break-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 30 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.
- Blade guide assembly set too far away from workpiece. Adjust the blade guide assembly approximately ¼” away from workpiece.
- 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.

<table>
<thead>
<tr>
<th>Chip Appearance</th>
<th>Chip Description</th>
<th>Chip Color</th>
<th>Blade Speed</th>
<th>Feed Rate/Pressure</th>
<th>Other Actions</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thin &amp; Curled</td>
<td>Silver</td>
<td>Good</td>
<td>Good</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Hard, Thick &amp; Short</td>
<td>Brown or Blue</td>
<td>Increase</td>
<td>Decrease</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Hard, Strong &amp; Thick</td>
<td>Brown or Blue</td>
<td>Increase</td>
<td>Decrease</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Hard, Strong, Curled &amp; Thick</td>
<td>Silver or Light Brown</td>
<td>Good</td>
<td>Decrease Slightly</td>
<td>Check Blade Pitch</td>
<td></td>
</tr>
<tr>
<td>Hard, Coiled &amp; Thin</td>
<td>Silver</td>
<td>Increase</td>
<td>Decrease</td>
<td>Check Blade Pitch</td>
<td></td>
</tr>
<tr>
<td>Straight &amp; Thin</td>
<td>Silver</td>
<td>Good</td>
<td>Increase</td>
<td></td>
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<tr>
<td>Powdery</td>
<td>Silver</td>
<td>Decrease</td>
<td>Increase</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Coiled, Tight &amp; Thin</td>
<td>Silver</td>
<td>Good</td>
<td>Decrease</td>
<td>Check Blade Pitch</td>
<td></td>
</tr>
</tbody>
</table>

Figure 39. Chip inspection chart.

Adjusting Blade Guides

The blade guides should be positioned approximately 1/4" away from workpiece if possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust blade guides:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen blade guide knob shown in Figure 40.
3. Slide front blade guide as close to workpiece as possible.
4. Tighten knob.

Figure 40. Location of blade guide knob.
Adjusting Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by blade type, feed rate, and feed pressure.

Note: If a lubricant is used on the cut, the feed rate can be increased by approximately 15%.

Tool Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wrench or Socket 14mm</td>
<td>1</td>
</tr>
</tbody>
</table>

To adjust feed rate:

1. Raise bow to maximum height to remove spring tension. Close feed ON/OFF valve to lock bow in place (see Figure 41).

2. Adjust feed pressure tension spring by rotating adjustment nut (see Figure 42). Tighten enough to remove play but not enough to apply tension to spring.

Note: This spring adjustment is an initial setting. Depending on cutting circumstances, you will have to fine-tune the feed pressure with this adjustment. Increasing the spring tension will reduce the feed pressure.

3. Clamp workpiece in table vise.

4. Open feed ON/OFF valve, allow bow to lower until blade is a few inches above workpiece, then close valve.

5. With correct saw blade and blade speed selected, turn saw and coolant pump ON.

6. Open feed ON/OFF valve, then slowly rotate feed rate control knob clockwise to a slow feed rate until saw begins to cut workpiece (see Figure 41).

7. Observe chips that exit cut, and increase or decrease feed rate according to chip characteristics.

   — If chips are tightly curled, warm shavings, brown to black in color, there is too much downward pressure.

   — If chips are blue looking chips, blade speed is too high.

   — If chips are thin and powder-like, there is insufficient feed pressure. This will dull blade rapidly.

   — The best cut and feed rate will give you evenly shaped spiraled curls with very little color change, if any at all.
Using Vise

The vise can hold material up to 12 inches wide and be set to cut angles from 0 to 45 degrees.

**Tool Needed**

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wrench or Socket 3/4&quot;</td>
</tr>
</tbody>
</table>

To use vise:

1. Loosen angle hex nut on rear jaw shown in **Figure 43**.

2. Use scale to set angle of rear jaw (see **Figure 43**).
   - If desired angle *can* be reached with rear vise jaw in current position, tighten angle hex nut to secure. Proceed to Step 7.
   - If desired angle *cannot* be reached with rear vise jaw in current position, proceed to Step 3.

3. Remove angle hex nut, flat washer, and carriage bolt.

4. Remove pivot bolt and flat washer shown in **Figure 44**.

5. Move rear vise jaw so pivot bolt and flat washer can secure it through alternate pivot hole (see **Figure 44**).

6. Use scale to set angle of rear jaw, then secure with carriage bolt, flat washer, and angle hex nut removed in Step 3 (see **Figure 45**).

7. Loosen knob bolt in **Figure 46** on opposite jaw so jaw can float, and match angle of workpiece.

---

**Figure 43.** Location of rear jaw adjustment components.

**Figure 44.** Location of pivot bolt and alternate pivot hole.

**Figure 45.** Rear jaw positioned in alternate location.

**Figure 46.** Vise jaw knob bolt.
8. Use vise handwheel to tighten vise against workpiece (see Figure 47).

**Figure 47.** Location of vise handwheel.

## Adjusting Work Stop

The Model G0561 is equipped with a work stop for repetitive cutting operations. This stop will need to be adjusted any time it is removed or repositioned, or anytime you change the cutting length.

**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 thumb screw shown in Figure 48 and adjust work stop until it contacts workpiece. Tighten thumb screw to secure work stop.

**Figure 48.** Location of work stop and thumb screw.

### Changing Blade Speed

The Model G0561 is capable of blade speeds of 90, 135, 195, and 255 FPM (Feet Per Minute). To adjust the speed, position the V-belt on the pulleys that will provide your desired speed setting.

(Refer to Blade Speed Chart on Page 35 for blade speed guidelines for various metals.)

**Items Needed**

<table>
<thead>
<tr>
<th>Qty</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Wrench or Socket ½&quot;</td>
</tr>
<tr>
<td>As Needed</td>
<td>Replacement V-Belt (#P0561211)</td>
</tr>
<tr>
<td>1</td>
<td>Open-End Wrench ½&quot;</td>
</tr>
</tbody>
</table>

**To change blade speeds:**

1. **DISCONNECT MACHINE FROM POWER!**
2. Determine blade speed for your cut (refer to Blade Speed Chart on Page 35).
3. Open pulley cover.
4. Loosen hex bolts shown in Figure 49.

**Figure 49.** Location of motor mount hex bolts.
5. Loosen hex nuts shown in Figure 50, then tighten hex bolts to push motor toward spindle pulley and slacken V-belt.

— If belt is cracked, frayed, or worn, remove it, then install a new belt.

![Figure 50. Belt tension fasteners.](image)

6. Position V-belt on pulleys for desired FPM (see Figure 51).

![Figure 51. Illustration of V-belt placement for FPM selection.](image)

7. Loosen hex bolts from Step 5.

8. Adjust motor position until there is approximately ¼” belt deflection when moderate pressure is applied between pulleys (see Figure 52).

![Figure 52. Checking belt deflection.](image)

9. Tighten hex bolts in Figure 53, then tighten hex nuts against motor mount to secure.

![Figure 53. Location of motor mount hex bolts.](image)

10. Close pulley cover.
Blade Speed Chart

The chart in Figure 54 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 on Page 30 for recommendations on adjusting feed rate or blade speed based on the appearance of the chips produced.

<table>
<thead>
<tr>
<th>Material</th>
<th>Speed FPM (M/Min)</th>
<th>Material</th>
<th>Speed FPM (M/Min)</th>
<th>Material</th>
<th>Speed FPM (M/Min)</th>
<th>Material</th>
<th>Speed FPM (M/Min)</th>
</tr>
</thead>
</table>

Figure 54. Blade speed chart.
Vertical Operation

The Model G0561 can be set up for vertical cutting operations.

### Items Needed

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vertical Work Table</td>
<td>1</td>
</tr>
<tr>
<td>Table Bracket</td>
<td>1</td>
</tr>
<tr>
<td>Phillips Head Screwdriver #2</td>
<td>1</td>
</tr>
<tr>
<td>Wrench or Socket 7/16&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Flat Head Screw 1/4&quot;-20 x 1/2&quot;</td>
<td>1</td>
</tr>
<tr>
<td>Hex Nut 1/4&quot;-20</td>
<td>1</td>
</tr>
<tr>
<td>Square</td>
<td>1</td>
</tr>
<tr>
<td>Level</td>
<td>1</td>
</tr>
<tr>
<td>Open-End Wrenches 14mm</td>
<td>2</td>
</tr>
</tbody>
</table>

### To operate machine in vertical position:

1. **DISCONNECT MACHINE FROM POWER!**

2. Raise bow to maximum height, then close feed ON/OFF valve to lock bow in place (see Figure 55).

3. Remove (2) flat head screws and blade guide cover (see Figure 56).

4. Install vertical work table (see Figure 57) and replace flat head screws removed in Step 3.

5. Install table bracket with (1) 1/4"-20 x 1/2" flat head screw, 1/4"-20 hex nut, and hex bolt pre-installed in casting (see Figure 57). Fingertighten fasteners for now.

![Figure 55. Location of feed ON/OFF valve.](image)

![Figure 56. Location of flat head screws holding blade guide cover.](image)

![Figure 57. Table and bracket installed.](image)
6. Set square on table to side of blade, as shown in Figure 58, adjust table bracket until table is square to blade, then fully tighten fasteners from Step 5 to secure.

Figure 58. Squaring table to blade.

7. Place level on table, as shown in Figure 59, and turn adjustment bolt shown in Figure 60 until table is level.

Figure 59. Example of leveling table.

Cutting Fluid

While simple in concept and function, many issues must be taken into account to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

Use selections below to choose appropriate cutting fluid:

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use water soluble cutting fluid.

- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use “Neat Cutting Oil” (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).

- For cutting cast iron, cutting fluid is not recommended.

- For cutting magnesium, use only cutting fluid that is designed for cutting magnesium.

Remember: Too much flow at the cutting fluid nozzle will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.

WARNING

BIOLOGICAL AND POISON HAZARD! Use proper personal protection equipment when handling cutting fluid and dispose by following federal, state, and fluid manufacturer requirements to properly dispose of cutting fluid.
Cutting Fluid System

This bandsaw has a built-in cutting fluid system that extends the life of your bandsaw blades by lowering the cutting temperature and washing away chips.

See Cutting Fluid on Page 37 for more information.

To use cutting fluid system:

1. Thoroughly clean and remove any foreign material that may have fallen inside reservoir during shipping.

2. Place filter screen and drain tube in reservoir, as shown in Figure 61.

3. Fill reservoir to "High" mark with cutting fluid.

4. Adjust valve on coolant hose to control flow of coolant (see Figure 62). Make sure that pressure is not so high that coolant spills on floor and creates a slipping hazard.

5. Turn pump toggle switch ON before making your cut.

**WARNING**

FIRE HAZARD! DO NOT cut magnesium when using oil-water solutions as a cutting fluid! Always use a cutting fluid intended for magnesium. The water in the solution will cause a magnesium-chip fire.

**NOTICE**

Keep tray chip screen clear so coolant can recycle to pump reservoir. NEVER operate pump with reservoir below low mark or you will over-heat pump and void warranty!
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.

G5124—93" x ¾" x .032" 10 TPI Raker
G5125—93" x ¾" x .032" 14 TPI Raker
G5126—93" x ¾" x .032" 18 TPI Raker
G5127—93" x ¾" x .035" 4–6 Variable Pitch
G5128—93" x ¾" x .035" 5–8 Variable Pitch
G5129—93" x ¾" x .035" 6–10 Variable Pitch
G5130—93" x ¾" x .035" 8–12 Variable Pitch
G5131—93" x ¾" x .035" 10–14 Variable Pitch

H5408—Lenox 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.

G517—Deburring Tool w/2 Blades
The quickest tool for smoothing freshly machined metal edges. Comes with two blades—one for steel/aluminum and one for brass/cast iron.

Basic Eye Protection
T32323—Woodturners Face Shield
T32401—EDGE Brazeau Safety Glasses, Clear
T32402—EDGE Khor G2 Safety Glasses, Tint
T32404—EDGE Mazeno Safety Glasses, Clear

Figure 63. Metal-cutting blade assortment.

Figure 64. G5618 Deburring Tool.

Figure 65. H5408 Blade Tensioning Gauge.

Figure 66. Assortment of basic eye protection.

Figure 67.
SECTION 6: MAINTENANCE

WARNING
To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

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.
- Incorrect blade tension.
- Worn or damaged wires.
- Any other unsafe condition.

Weekly Maintenance

- Lubricate vise screw.
- Check gearbox lubrication.

Biannual (6-Month) Maintenance

- Change gearbox oil.

Cleaning

Cleaning the Model G0561 is relatively easy. Use a brush and a shop vacuum to remove chips and other debris from the machine. Keep the non-painted surfaces rust-free with regular applications of a high-quality rust preventative.

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

Lubrication

An essential part of lubrication is cleaning the components before lubricating them.

This step is critical because grime and chips build up on lubricated components over time, which makes them hard to move.

Clean all exterior components in this section with mineral spirits, shop rags, and brushes before lubricating.

DISCONNECT MACHINE FROM POWER BEFORE PERFORMING LUBRICATION!

NOTICE
Follow reasonable lubrication practices as outlined in this manual. Failure to do so could lead to premature failure of machine and will void warranty.

Vise Leadscrew

Lube Type.....Model G4682 or Dry Coating Lube
Lube Amount..................................Thin Coat
Lubrication Frequency........40 hrs. of Operation

Items Needed

<table>
<thead>
<tr>
<th>Qty</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Mineral Spirits</td>
</tr>
<tr>
<td>1</td>
<td>Model G4682 or Dry Coating Lube</td>
</tr>
</tbody>
</table>

To lubricate vise leadscrew:

1. DISCONNECT MACHINE FROM POWER!

2. Using vise handwheel, move vise as far forward as possible.

3. Use mineral spirits and a brush to clean existing lubricant and debris off of vise leadscrew shown in Figure 67. Allow leadscrew to dry.
4. Apply thin coat of dry coating lube to exposed leadscrew threads, then move vise through its full range of motion several times to disperse lube along full length of leadscrew.

Gearbox

Lube Type........Model T28042 or ISO 320 Equiv.  
Lube Amount............................ As Needed  
Check Frequency..........................Weekly  
Lubrication Frequency.After 50 Hrs., Bi-annually

IMPORTANT: To maximize gearbox life, replace the oil after the first 50 hours of use.

After the first 50 hours of use, the fluid level of the gearbox should be checked weekly. Use an 8mm wrench to remove the vent plug shown in Figure 68 to check fluid level. If oil is not visible when plug is removed, slowly add just enough oil so you can see oil level. Clean vent plug threads, then wrap them with thread-sealing tape before replacing.

As routine maintenance, the gearbox oil should be replaced every 6 months.

To replace gearbox oil:

1. DISCONNECT MACHINE FROM POWER!

2. With shop rags positioned to catch any oil run off, remove (4) hex bolts shown in Figure 69 to remove gearbox cover.

3. Use shop rags to absorb and remove oil in gearbox.

4. Use mineral spirits to clean oil off of gears and inside of box, then let gears dry.

5. Install gearbox cover removed in Step 2.

6. Remove vent plug shown in Figure 68, then fill gearbox with oil until you can see it in vent plug hole.

7. Clean vent plug threads, then wrap threads in thread-sealing tape before replacing.
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**

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
</table>
| Machine does not start, or power supply breaker immediately trips after startup. | 1. Machine circuit breaker tripped.  
2. Incorrect power supply voltage or circuit size.  
3. Plug/receptacle at fault/wired incorrectly.  
4. Power supply circuit breaker tripped or fuse blown.  
5. Motor wires connected incorrectly.  
6. Start capacitor at fault.  
7. Centrifugal switch adjustment/contact points at fault.  
8. Wiring broken, disconnected, or corroded.  
9. ON/OFF or circuit breaker switch at fault.  
10. Motor or motor bearings at fault. | 1. Reset circuit breaker.  
2. Ensure correct power supply voltage and circuit size (Page 11).  
3. Test for good contacts; correct wiring (Page 48).  
4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.  
6. Test/replace if at fault.  
7. Adjust centrifugal switch/clean contact points. Replace either if at fault.  
8. Fix broken wires or disconnected/corroded connections (Page 48).  
9. Replace switch/circuit breaker.  
10. Replace motor. |
| Machine stalls or is underpowered. | 1. Dull blade.  
2. Feed rate/cutting speed too fast.  
3. Workpiece crooked; vise loose or misadjusted.  
4. Wrong workpiece material (metal) or wrong blade type/TPI for material.  
5. Gearbox at fault.  
6. Blade slipping on wheels or not properly tensioned.  
7. Belt slipping/pulleys misaligned.  
8. Motor wires connected incorrectly.  
10. Pulley slipping on shaft.  
12. Extension cord too long.  
13. Centrifugal switch/contact points at fault.  
2. Decrease feed rate (Page 31)/cutting speed (Page 33); use cutting fluid if possible.  
3. Straighten or replace workpiece/adjust vise (Page 32).  
4. Use correct metal (Page 25) and type/TPI/size of blade (Page 25).  
5. Replace broken or slipping gears.  
6. Adjust blade tracking (Page 45) and tension (Page 28).  
7. Clean/tension (Page 33)/replace belt; ensure pulleys are aligned (Page 19).  
9. Test for good contacts; correct wiring (Page 48).  
10. Tighten/replace loose pulley shaft.  
12. Move machine closer to power supply; use shorter extension cord (Page 12).  
13. Adjust centrifugal switch/clean contact points. Replace either if at fault.  
## Motor & Electrical (Cont.)

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine has vibration or noisy operation.</td>
<td>1. Motor or component loose.</td>
<td>1. Replace damaged or missing bolts/nuts or tighten if loose.</td>
</tr>
<tr>
<td></td>
<td>2. Stand feet not adjusted properly.</td>
<td>2. Adjust stand feet to stabilize machine.</td>
</tr>
<tr>
<td></td>
<td>3. V-belt worn, loose, pulleys misaligned or belt slipping cover.</td>
<td>3. Inspect/replace belt (Page 33). Realign pulleys if necessary.</td>
</tr>
<tr>
<td></td>
<td>4. Pulley loose.</td>
<td>4. Secure pulley on shaft.</td>
</tr>
<tr>
<td></td>
<td>5. Motor mount loose/broken.</td>
<td>5. Tighten/replace.</td>
</tr>
<tr>
<td></td>
<td>7. Motor fan rubbing on fan cover</td>
<td>7. Fix/replace fan cover; replace loose/damaged fan.</td>
</tr>
<tr>
<td></td>
<td>8. Blade damaged, warped, or has excessively large weld.</td>
<td>8. Replace warped/damaged blade (Page 27) or grind weld flush with blade.</td>
</tr>
<tr>
<td></td>
<td>10. Motor bearings at fault.</td>
<td>10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</td>
</tr>
<tr>
<td>Coolant pump is not functioning.</td>
<td>1. Pump wires connected incorrectly.</td>
<td>1. Correct pump wiring connections (Page 48).</td>
</tr>
<tr>
<td></td>
<td>2. Wiring broken, disconnected, or corroded.</td>
<td>2. Fix broken wires or disconnected/corroded connections (Page 48).</td>
</tr>
<tr>
<td></td>
<td>3. ON/OFF switch at fault.</td>
<td>3. Replace switch.</td>
</tr>
<tr>
<td></td>
<td>4. Coolant pump at fault.</td>
<td>4. Test/repair/replace.</td>
</tr>
</tbody>
</table>

## Operation

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vibration when operating or cutting.</td>
<td>1. Loose or damaged blade.</td>
<td>1. Tension blade (Page 28)/replace blade (Page 27).</td>
</tr>
<tr>
<td></td>
<td>2. Machine component(s) loose.</td>
<td>2. Inspect/re-tighten component(s).</td>
</tr>
<tr>
<td></td>
<td>3. Bent, or dull blade.</td>
<td>3. Replace blade (Page 27).</td>
</tr>
<tr>
<td></td>
<td>5. Wheels worn or incorrectly installed.</td>
<td>5. Replace wheels; adjust blade tracking (Page 45).</td>
</tr>
<tr>
<td></td>
<td>6. Wheel appears bent.</td>
<td>6. Check/replace wheel.</td>
</tr>
<tr>
<td>Ticking sound when saw is running.</td>
<td>1. Blade teeth missing or broken.</td>
<td>1. Inspect/replace blade (Page 27).</td>
</tr>
<tr>
<td></td>
<td>2. Blade weld contacting blade guides.</td>
<td>2. Grind weld down flush with blade.</td>
</tr>
<tr>
<td></td>
<td>3. Blade weld failing.</td>
<td>3. Cut and re-weld blade, or replace blade (Page 27).</td>
</tr>
<tr>
<td>Cuts not square, or intended angle is incorrect.</td>
<td>1. Loose vise.</td>
<td>1. Tighten vise and secure workpiece (Page 32).</td>
</tr>
<tr>
<td></td>
<td>2. Blade not square to table.</td>
<td>2. Adjust blade square to table (Page 46).</td>
</tr>
<tr>
<td>Blade dulls prematurely, or metal sticks to blade.</td>
<td>1. Blade improperly broken in.</td>
<td>1. Replace blade (Page 27); complete blade break-in procedure (Page 29).</td>
</tr>
<tr>
<td></td>
<td>2. Blade gullets loading up with chips.</td>
<td>2. Use blade with larger gullets/fewer TPI (Page 25).</td>
</tr>
<tr>
<td></td>
<td>3. Blade tension is too low.</td>
<td>3. Increase blade tension (Page 28).</td>
</tr>
<tr>
<td></td>
<td>4. Blade TPI too fine or coarse for material; teeth load up and overheat.</td>
<td>4. Use coarser-tooth or finer-tooth blade (Page 25); adjust feed rate (Page 31); adjust blade speed (Page 33); make sure blade brush works and is adjusted correctly.</td>
</tr>
<tr>
<td></td>
<td>5. Incorrect coolant mixture for workpiece/cut.</td>
<td>5. Use correct coolant mixture.</td>
</tr>
<tr>
<td></td>
<td>6. Incorrect feed rate/blade speed.</td>
<td>6. Adjust feed rate (Page 31), adjust blade speed (Page 33).</td>
</tr>
</tbody>
</table>
### Operation (Cont.)

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Excessive blade breakage.</td>
<td>1. Workpiece loose.</td>
<td>1. Secure workpiece with vise (<a href="#">Page 32</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Blade contacting workpiece when started.</td>
<td>2. Raise headstock, start blade, then lower blade into workpiece.</td>
</tr>
<tr>
<td></td>
<td>3. Blade too thick/blade gullets too large.</td>
<td>3. Use thinner blade/blade with smaller gullets (<a href="#">Page 25</a>).</td>
</tr>
<tr>
<td></td>
<td>4. Workpiece too coarse for blade.</td>
<td>4. Use coarser-tooth blade (<a href="#">Page 25</a>); adjust feed rate (<a href="#">Page 31</a>); adjust blade speed (<a href="#">Page 33</a>).</td>
</tr>
<tr>
<td></td>
<td>5. Blade tension/tracking requires adjustment.</td>
<td>5. Adjust blade tension (<a href="#">Page 28</a>)/tracking (<a href="#">Page 45</a>).</td>
</tr>
<tr>
<td></td>
<td>7. Blade weld failing.</td>
<td>7. Cut and re-weld blade, or replace blade (<a href="#">Page 27</a>).</td>
</tr>
<tr>
<td>Blade wears on one side or shows overheating.</td>
<td>1. Blade guides worn or mis-adjusted.</td>
<td>1. Re-adjust guides and bearings (<a href="#">Page 46</a>)/replace.</td>
</tr>
<tr>
<td></td>
<td>2. Blade not supported.</td>
<td>2. Move blade guide closer to workpiece (<a href="#">Page 30</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Dull/incorrect blade.</td>
<td>3. Replace blade (<a href="#">Page 27</a>).</td>
</tr>
<tr>
<td></td>
<td>4. Incorrect coolant mixture for workpiece/cut.</td>
<td>4. Use correct coolant mixture.</td>
</tr>
<tr>
<td></td>
<td>5. Blade is bell-mouthed.</td>
<td>5. Replace blade (<a href="#">Page 27</a>).</td>
</tr>
<tr>
<td>Blade tracks incorrectly or comes off wheels.</td>
<td>1. Feed rate too fast/wrong TPI.</td>
<td>1. Reduce feed rate (<a href="#">Page 31</a>), reduce blade TPI (<a href="#">Page 25</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Blade tension/tracking requires adjustment.</td>
<td>2. Adjust blade tracking (<a href="#">Page 45</a>), tension (<a href="#">Page 28</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Blade guides need adjustment.</td>
<td>3. Adjust blade guides (<a href="#">Page 46</a>).</td>
</tr>
<tr>
<td></td>
<td>4. Blade is bell-mouthed.</td>
<td>4. Replace blade (<a href="#">Page 27</a>).</td>
</tr>
<tr>
<td>Cuts are crooked/ excessively rough.</td>
<td>1. Feed rate too fast, blade speed incorrect.</td>
<td>1. Reduce feed rate (<a href="#">Page 31</a>), adjust blade speed (<a href="#">Page 33</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Blade too coarse or dull.</td>
<td>2. Replace blade (<a href="#">Page 27</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Blade not supported.</td>
<td>3. Move blade guide closer to workpiece (<a href="#">Page 30</a>).</td>
</tr>
<tr>
<td></td>
<td>4. Blade guides out of adjustment.</td>
<td>4. Adjust blade guides (<a href="#">Page 46</a>).</td>
</tr>
<tr>
<td></td>
<td>5. Blade tension/tracking requires adjustment.</td>
<td>5. Adjust blade tracking (<a href="#">Page 45</a>), tension (<a href="#">Page 28</a>).</td>
</tr>
<tr>
<td>Blade cuts into table or does not cut fully through workpiece.</td>
<td>1. Downfeed stop bolt requires adjustment.</td>
<td>1. Adjust downfeed stop bolt (<a href="#">Page 47</a>).</td>
</tr>
<tr>
<td>Coolant system is not functioning.</td>
<td>1. Coolant valve is closed.</td>
<td>1. Open coolant valve.</td>
</tr>
<tr>
<td></td>
<td>2. Coolant level is low.</td>
<td>2. Check/ﬁll coolant level (<a href="#">Page 38</a>).</td>
</tr>
<tr>
<td></td>
<td>3. Coolant system is leaking.</td>
<td>3. Inspect/test for leaks/repair.</td>
</tr>
<tr>
<td></td>
<td>4. Flow blocked or impeded.</td>
<td>4. Make sure coolant line(s) are not pinched or damaged.</td>
</tr>
<tr>
<td>Coolant system is pulling sludge from reservoir.</td>
<td>1. Coolant level is low.</td>
<td>1. Check/ﬁll coolant level (<a href="#">Page 38</a>).</td>
</tr>
<tr>
<td></td>
<td>2. Coolant needs to be changed/reservoir is dirty.</td>
<td>2. Clean and change coolant (<a href="#">Page 38</a>).</td>
</tr>
</tbody>
</table>
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.

Tools Needed

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wrench or Socket ½&quot;</td>
</tr>
<tr>
<td>Hex Wrench 4mm</td>
</tr>
</tbody>
</table>

To adjust blade tracking:

1. DISCONNECT MACHINE FROM POWER!

2. Position bandsaw in vertical position and close feed ON/OFF valve.

3. Open wheel access cover.

4. Loosen, but do not remove lower hex bolt in blade wheel tilting mechanism (see Figure 70).

5. Relax blade tension.

6. Adjust tracking set screw (see Figure 70), then tighten hex bolt loosened in Step 4.

7. Tension blade.

8. Connect machine to power and turn machine ON.

   — If blade tracks along shoulder of wheel (without rubbing), blade is tracking properly and this adjustment is completed.

   — If blade walks away from shoulder of wheel or hits shoulder, turn machine OFF, disconnect it from power, and repeat Steps 4–7 until blade tracks properly.

9. Turn OFF bandsaw.

10. Close wheel access cover.

---

Figure 70. Location of lower hex bolt.

Figure 71. Location of wheel shoulder.

WARNING

Moving blade can easily cut body parts. Keep body parts away from blade and machine in following step to prevent personal injury.
Squaring Blade to Bed 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**

<table>
<thead>
<tr>
<th>Item</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Square</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 6mm</td>
<td>1</td>
</tr>
</tbody>
</table>

**To square blade to bed of table:**

1. DISCONNECT MACHINE FROM POWER!

2. Lower head of bandsaw until it contacts horizontal stop.

3. Place square on table bed and against edge of blade (see **Figure 72**), and check different points along length of table between blade guides.

4. Loosen cap screw shown in **Figure 72**, and rotate blade guide until blade is vertical to bed.

**Note:** *Both blade guides can be adjusted to achieve the results you want.*

![Cap Screw](image)

**Figure 72.** Square placed on table bed against edge of blade.

5. Tighten cap screw.

---

Adjusting Blade Guide Bearings

The blade guide bearings come adjusted from the factory and the need for adjustment should rarely occur. Uneven blade wear and crooked cuts may be the result of improper adjustment. Each bearing assembly has an eccentric bushing that allows the distance between the blade and bearings to be adjusted. The bearings are secured in place by a hex nut and a lock washer.

**Tools Needed**

<table>
<thead>
<tr>
<th>Item</th>
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<tr>
<td>Square</td>
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</tr>
<tr>
<td>Wrench or Socket 14mm</td>
<td>1</td>
</tr>
<tr>
<td>Open-Ended Wrench 6mm</td>
<td>1</td>
</tr>
</tbody>
</table>

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

**To adjust blade guide bearings:**

1. DISCONNECT MACHINE FROM POWER!

2. Position vise to 90°, then lock in place.

3. Put square against face of vise and move it over to blade (see **Figure 72**).
   - If square *does* evenly touch face of vise and blade, proceed to Step 6.
   - If square *does not* evenly touch face of vise and blade at the time, continue with next step.

4. Position square to be against horizontal stop (see **Figure 72**).

5. Tighten cap screw.
4. Loosen hex nuts that secure eccentric bushings attached to guide bearings (see Figure 73).

![Figure 73. Guide bearing components.](image)

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

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

The backing bearing is not adjustable and should make light contact with blade.

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**

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</thead>
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<td>Wrench or Socket 14mm ......................... 1</td>
</tr>
<tr>
<td>Open-Ended Wrench 14mm ........................ 1</td>
</tr>
</tbody>
</table>

**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 jam nuts to secure headstock position (see Figure 74). Adjustment is complete.

4. Adjust downfeed stop bolt until blade is just below vise table, but not contacting it (see Figure 74). Tighten jam nuts to secure.

![Figure 74. Location of downfeed stop bolt.](image)
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 aftermarket 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**

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---

Model G0561 (Mfd. Since 01/18)
Wiring Diagrams

115V Wiring Diagram

230V Wiring Diagram
Electrical Components

Figure 75. Main motor wiring (115V).

Figure 76. Capacitor wiring.

Figure 77. Power switch.

Figure 78. Pump motor (115V).

Figure 79. Coolant pump ON/OFF switch.
## Cabinet & Base Parts List

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**Note:** For more parts, visit GRIZZLY.COM or scan the QR code.
Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.
## Bow & Motor Parts List

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<td>SET SCREW 5/16-18 X 1/2</td>
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### Specifications

- **Motor:** 1 HP, 110⁄220 V
- **Motor Speed:** 1725 RPM
- **Blade Speeds:** 90, 135, 195, 255 FPM
- **Blade Size:** 3/4" X 93"
- **Maximum Round Cut 90˚:** 7"
- **Maximum Width of Cut 90˚:** 12"
- **Maximum Height of Cut 90˚:** 7"
- **Angle Cuts:** 45˚-90˚
- **Weight:** 330 LBS.

Manufactured for Grizzly in China

### Safety

- **WARNING!** READ and UNDERSTAND instruction manual to avoid serious injury. If a manual is not available, DO NOT use machine. Go to www.grizzly.com or call (800) 523-4777.

### Labels & Cosmetics

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<td>READ MANUAL LABEL</td>
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**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.

- **BUY PARTS ONLINE AT GRIZZLY.COM!** Scan QR code to visit our Parts Store.

Model G0561 (Mfd. Since 01/18)
Grizzly Industrial, Inc. warrants every product it sells for a period of 1 year to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

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

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

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

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

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

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

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