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.
# Table of Contents

INTRODUCTION ............................................. 2  
  Manual Accuracy ........................................... 2  
  Contact Info ............................................... 2  
  Identification ............................................. 3  
  Machine Data Sheet ........................................ 4  

SECTION 1: SAFETY ........................................ 5  
  Safety Instructions for Machinery .......................... 5  
  Additional Safety for Line Boring Machines............. 7  

SECTION 2: POWER SUPPLY .............................. 8  

SECTION 3: SETUP ............................................ 10  
  Setup Safety ................................................ 10  
  Items Needed for Setup .................................... 10  
  Unpacking ................................................... 10  
  Inventory ..................................................... 11  
  Clean Up ..................................................... 12  
  Site Considerations ....................................... 13  
  Mounting to Shop Floor .................................... 14  
  Lifting & Placing ........................................... 15  
  Assembly ..................................................... 16  
  Test Run ..................................................... 17  

SECTION 4: OPERATIONS ................................. 18  
  Disabling & Locking Switch ............................... 18  
  Installing Boring Bits ..................................... 19  
  Adjusting Drilling Depth ................................... 20  
  Adjusting Hold-Down Height ................................ 21  
  Positioning the Workpiece .................................. 21  
  Drilling Overview .......................................... 22  

SECTION 5: ACCESSORIES ................................. 23  

SECTION 6: MAINTENANCE ............................... 25  
  Schedule ..................................................... 25  
  Cleaning ..................................................... 25  
  Lubrication .................................................. 25  

SECTION 7: SERVICE ....................................... 27  
  Troubleshooting ............................................ 27  
  Adjusting Table Parallel to Boring Head ............... 29  
  Aligning Boring Bit Height ................................ 30  
  Wiring Diagram .............................................. 31  

SECTION 8: PARTS ......................................... 32  
  Column & Electrical ........................................ 32  
  Table .......................................................... 34  
  Cabinet & Tools ............................................. 36  
  Boring Head .................................................. 37  
  Labels & Cosmetics .......................................... 38  

WARRANTY AND RETURNS .............................. 39
INTRODUCTION

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
Figure 1. Model G0642 identification.

A. Longitudinal Fence and Scale
B. Longitudinal Locking Lever and Stop
C. Boring Head Assembly
D. Drilling Depth Control
E. Downfeed Handle
F. 1 HP Motor
G. ON/OFF Switch
H. Indexing Pin
I. Boring Head Guard
J. Table
K. Cabinet Door
L. Cabinet Mounting Point
M. Workpiece Hold-down
N. Cross Fence and Scale

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

Refer to Figure 2 and the following descriptions to become familiar with the basic controls of this machine.

A. Workpiece Hold-Down: Secures the workpiece firmly against the table and fence. Adjusts to accommodate different workpiece thicknesses.

B. Fence Extension and Scale: Mounts on the left end of the table fence for longer workpieces.

C. Fence Locking Lever and Stops: Mount anywhere along the fence so holes can be drilled in multiple workpieces at the same location.

D. Drilling Depth Control: Sets the maximum boring bit depth.

E. Downfeed Handle: Raises and lowers boring bits for drilling operations.

F. ON/OFF Switch: Starts and stops motor.

G. Throat Position Lock: Locks the boring head lateral position when adjusting the setback distance.

H. Indexing Pin: Positions the workpiece for additional drilling beyond 15 holes.

I. Throat Adjustment Knob: Adjusts the boring head bit position laterally.

J. Table Fence and Scale: The fence supports the workpiece during the boring operation. The fence scale is used to position the workpiece relative to the boring bits.

⚠️WARNING

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

⚠️WARNING

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.
MODEL G0642 15 BIT LINE BORING MACHINE

Product Dimensions:
- Weight: 242 lbs.
- Width (side-to-side) x Depth (front-to-back) x Height: 28 x 25-3/4 x 62-5/8 in.

Shipping Dimensions:
- Type: Cardboard
- Weight: 276 lbs.
- Length x Width x Height: 32 x 29 x 63 in.
- Must Ship Upright: Yes

Electrical:
- Power Requirement: 110V or 220V, Single-Phase, 60 Hz
- Prewired Voltage: 110V
- Full-Load Current Rating: 10A at 110V, 5A at 220V
- Minimum Circuit Size: 15A at 110V, 15A at 220V
- Connection Type: Cord & Plug
- Power Cord Included: Yes
- Power Cord Length: 9-1/2 ft.
- Power Cord Gauge: 14 AWG
- Plug Included: Yes
- Included Plug Type: 5-15
- Switch Type: ON/OFF Push Button Switch w/Large Shut-Off Paddle

Motors:
- Main
  - Horsepower: 1 HP
  - Phase: Single-Phase
  - Amps: 10A/5A
  - Speed: 3450 RPM
  - Type: TEFC Capacitor-Start Induction
  - Power Transfer: Gear Drive
  - Bearings: Shielded & Permanently Lubricated

Main Specifications:
- Operation Information
  - Spindle Travel: 3 in.
  - Spindle RPM: 3450
  - Maximum Stock Width: 12-1/2 in.
  - Drill Bit Type: Flat Shank Boring Bit
  - Bit Cap: 10 mm

- Table Information
  - Table Travel Front To Back: 8 in.
  - Floor To Table Height: 34-1/4 in.
  - Table Size Length: 28 in.
  - Table Size Width: 15-3/4 in.
  - Table Size Thickness: 3/4 in.
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** This symbol is used to alert the user to useful information about proper operation of the machine.

### 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.
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 Boring Machines

⚠️ WARNING

Serious injury or death can occur from getting clothing, jewelry, or long hair entangled in rotating boring bit. Contact with rotating boring bit can result in severe cuts or amputation of fingers. Flying debris can cause blindness or eye injuries. Broken bits, unsecured workpieces, or other adjustment tools thrown from rotating chucks can strike nearby operator or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders MUST completely heed hazards and warnings below.

WEARING PROPER PPE. Flying chips created by drilling can cause eye injuries or blindness. Always wear a face shield in addition to safety glasses. Always keep hands and fingers away from drill bit/cutting tool. Avoid awkward hand positions, where a sudden slip could cause hand to move into bit/cutting tool.

AVOIDING ENTANGLEMENT. DO NOT wear loose clothing, gloves, or jewelry, and tie back long hair. Keep all guards in place and secure. Always allow spindle to stop on its own. DO NOT stop spindle using your hand or any other object.

REMOVING ADJUSTMENT TOOLS. Chuck key, drawbar wrench, and other tools left on machine can become deadly projectiles when spindle is started. Remove all loose items or tools used on spindle immediately after use.

SECURING BIT/CUTTING TOOL. Firmly secure bit/cutting tool so it does not fly out of spindle during operation or startup.

SECURING TABLE AND HEADSTOCK. To avoid accidental contact with tool/bit, tighten all table and headstock locks before operating drill.

CORRECT SPINDLE SPEED. Using wrong spindle speed can cause bits/cutting tools to break and strike operator or bystanders. Follow recommended speeds and feeds for each size/type of bit/cutting tool and workpiece material.

WORKPIECE PREPARATION. To avoid loss of workpiece control, DO NOT drill material with an uneven surface on the table, unless a suitable support is used. To avoid impact injuries, make sure workpiece is free of nails or foreign objects in area to be drilled.

WORKPIECE CONTROL. An unsecured workpiece may unexpectedly shift, spin out of control, or be thrown if bit/cutting tool “grabs” during operation. Clamp workpiece to table or in table-mounted vise, or brace against column to prevent rotation. NEVER hold workpiece by hand during operation. NEVER start machine with bit/cutting tool touching workpiece; allow spindle to gain full speed before drilling.

INSPECTING BIT/CUTTING TOOL. Damaged bits/cutting tools may break apart during operation and hit operator or bystanders. Dull bits/cutting tools increase cutting resistance and are more likely to grab and spin/throw workpiece. Always inspect bits/cutting tools for sharpness, chips, or cracks before each use. Replace dull, chipped, or cracked bits/cutting tools immediately.

MAINTAINING MACHINE. Keep machine in proper working condition to help ensure that it functions safely and all guards and other components work as intended. Perform routine inspections and all necessary maintenance. Never operate machine with damaged or worn parts that can break or result in unexpected movement during operation.

CLEANING MACHINE SAFELY. To avoid contact with tool/bit, never clear chips while spindle is turning. To avoid cuts and eye injuries, DO NOT clear chips by hand or with compressed air—use a brush or vacuum instead.

DISCONNECT POWER FIRST. To reduce risk of electrocution or injury from unexpected startup, make sure drill is turned OFF, disconnected from power, and all moving parts have come to a complete stop before changing bits/cutting tools or starting any inspection, adjustment, or maintenance procedure.
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 110V ...... 10 Amps
Full-Load Current Rating at 220V ...... 5 Amps

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

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

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 110V
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 220V
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
Grounding Requirements

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

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

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 ......................... 12 AWG
Maximum Length (Shorter is Better)........50 ft.
Voltage Conversion

This section shows how to convert the Model G0642 from 110V to 220V. The plug needed for this conversion can be purchased at any local hardware store or electrical supply store.

**Items Needed**
- Phillips Head Screwdriver #2 ................. 1
- NEMA 6-15 Plug ........................................ 1
- Wire Cutters ............................................... 1
- Wire Strippers ............................................. 1

**NOTICE**
This manual was current at the time of printing; however, if the wiring diagram provided on the inside cover of the motor junction box conflicts with this manual, always use that wiring diagram instead, as it will reflect any changes that may have occurred after printing.

To convert to 220V:

1. **DISCONNECT BORING MACHINE FROM POWER!**
2. Cut off the pre-installed 5-15 plug from the end of the power cord.
3. Open the motor junction box (see **Figure 5**) by removing the four screws from the front.

4. Loosen the screws indicated in **Figure 6**.

5. Reposition wires 1–4 as shown in **Figure 7**, then tighten the screws loosened in **Step 4**.

6. Close and secure the motor junction box.

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

   —If instructions and a wiring diagram are not provided by the plug manufacturer, the wiring diagram shown on **Page 34** shows the wiring of a standard NEMA 6-15 plug. This diagram may be used as long as your plug matches the one shown.
SECTION 3: SETUP

Setup Safety

⚠️ 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 or a face shield during the entire setup process!

⚠️ WARNING
This machine and its components are very heavy. Use assistants and safe methods to lift and move this machine.

Items Needed for Setup

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

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Assistants (for moving machine)</td>
<td>2</td>
</tr>
<tr>
<td>Accurate Level</td>
<td>1</td>
</tr>
<tr>
<td>Eye &amp; Face Protection (for each person)</td>
<td>1</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.**

⚠️ WARNING
SUFFOCATION HAZARD!
Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.
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.

Inventory (Figure 8):

<table>
<thead>
<tr>
<th>Item Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Boring Machine (not shown)</td>
<td>1</td>
</tr>
<tr>
<td>B. Longitudinal Fence Extension</td>
<td>1</td>
</tr>
<tr>
<td>C. Combo Open-End Wrenches 8/10mm, 11/13 mm, 12/14mm, 17/19mm</td>
<td>1 Each</td>
</tr>
<tr>
<td>D. Hex Wrenches 2.5mm</td>
<td>2</td>
</tr>
<tr>
<td>E. Hex Wrench Set 1.5, 2, 2.5, 3, 4, 5, 6, 8, &amp; 10mm</td>
<td>1 Each</td>
</tr>
<tr>
<td>F. Set Screws M5-.8 x 5mm (not shown)</td>
<td>30</td>
</tr>
</tbody>
</table>

Figure 8. G0642 inventory.
Hardware Recognition Chart

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

- Hex Wrench
- Phillips Head Screw
- Flat Head Screw
- Flat Head Cap Screw
- Wing Nut
- Lock Nut
- Tap Screw
- Button Head Screw
- Carriage Bolt
- Flange Bolt
- E-Clip
- Key
- External Retaining Ring
- Internal Retaining Ring
- Flat Washer
- Set Screw
- Washer Diameter
- Hex Nut

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

5mm
- 5/6" Flat Head Cap Screw

5/16" Cap Screw

3/8" Cap Screw

1/4"

1/2" Cap Screw

Lines are 1mm apart

- 4mm
- 5mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm

Lines are 1/8" inch apart

- 10mm
- 15mm
- 20mm
- 25mm
- 30mm
- 35mm
- 40mm
- 45mm
- 50mm
- 55mm
- 60mm
- 65mm
- 70mm
- 75mm

Washers are measured by the inside diameter

- 4mm
- 5mm
- 5/16"
- 1/2"
- 3/8"
- 7/16"
- 1/4"
- 5/32"
- 3/32"
- 1/8"
- 5/64"
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 chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

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 9. 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 10. Minimum working clearances.
Anchoring to Floor

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

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

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

Anchoring to Concrete Floors

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

NOTICE

We strongly recommend securing your machine to the floor if it is hardwired to the power source. Consult with your electrician to ensure compliance with local codes.

Using Machine Mounts

Using machine mounts, shown in Figure 12, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine to reduce strain on the floor.

Figure 12. Machine mount example.
Lifting & Placing

**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.

To move your boring machine:

1. Prepare the permanent location for the boring machine. Refer to **Power Supply**, on **Page 9**, and **Site Considerations** on **Page 14** for requirements.

2. Unbolt the machine from the shipping crate.

3. Use assistants and safe lifting methods to move the machine to its prepared location.

4. Make sure the top of the cabinet is level and mount the machine to the floor.
   
   —If you are using permanent fasteners, use shims between the base and the floor to make sure the machine is level.

   **Note:** To avoid cracking or warping the cast iron base, tighten the four corners down evenly.

   —If you are using machine feet, adjust these until the machine is level.

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).

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

To assemble your machine:

1. Insert the fence extension rod assemblies half way into the fence extension, and use a 4mm hex wrench to tighten the cap screws (see **Figure 13**).

   **Figure 13.** Extension fence rods and cap screws (shown from right rear of table).
2. Slide the extension fence rods into the main longitudinal fence, and tighten the cap screws to hold the extension fence in place (see Figure 14).

Figure 14. Extension fence installed.

3. Clean any debris off the shafts of the indexing pins, and apply a thin film of light machine oil to the entire length.

4. Slide the indexing pins with springs into the holes at the ends of the boring head assembly, as shown in Figure 15.

Figure 15. Indexing pin mounted in the boring head assembly.

Test Run

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

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

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the safety disabling mechanism on the switch works correctly.

⚠️ WARNING

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

⚠️ WARNING

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

To test run the machine:

1. Make sure all tools and objects used during set up are cleared away from the machine.

2. If there are boring bits installed in the machine, remove them.

3. Make sure the boring head guard is in place and is free to move up as the boring head assembly comes down.

4. Connect the machine to the power source.
5. Verify that the machine is operating correctly by turning the machine **ON**.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

6. Turn the machine **OFF**.

7. Insert the switch disabling pin through the green ON button, as shown in **Figure 16**.

8. Press the green ON button to test the disabling feature on the switch.

—If the machine does not start, the switch disabling feature is working as designed.

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

**Figure 16.** Switch disabling pin installed.
SECTION 4: OPERATIONS

Disabling & Locking Switch

The switch can be disabled and locked by inserting a padlock through the ON/START button, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

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

Figure 17. Switch disabled by a padlock.

NOTICE
If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade 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.

WARNING
Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, disable and lock the switch before leaving machine unattended! Place key in a well-hidden or secure location.

WARNING
Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.

NOTICE
If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade 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.

WARNING
To reduce the risk of serious injury when using this machine, read and understand this entire manual before operating.
Installing Boring Bits

The Model G0642 boring machine accepts boring bits with the following specifications:

Total Quantity ................................................. 15
Total Left Rotating ............................................. 8
Total Right Rotating ........................................... 7
Shank Diameter ................................................. 10mm

The boring bits have a flat surface on the shank (see Figure 18), and an adjusting screw inside for height alignment.

CAUTION
Boring bits are sharp and can cut your hands. Protect your hands when removing or installing the bits.

To install boring bits:

1. DISCONNECT MACHINE FROM POWER!

2. Unscrew the two knurled knobs and remove the front see-through guard from the boring head assembly.

Note: Make sure the boring bits to be installed match the rotation direction of the chucks, as shown in the information circle above the chuck on the boring head assembly.

For example, in Figure 19, the center chuck will rotate to the right, as viewed from above the chuck. This is shown by the letter "R" in the information circle. The boring bit will also be 64mm on center from the middle or number "0" boring bit, as shown by the number in the top of the information circle.

3. Align the flat surface of the bit shank with the chuck set screws and insert the bit completely into the chuck.

4. Use a 2.5mm hex wrench to firmly tighten two M5-.8 x 5mm set screws (see Figure 20) against the flat shank of the boring bit.

5. Repeat Steps 3–4 with the rest of the bits to be installed, making sure the bit direction matches that of the chuck.

6. Re-install the boring head guard.

Note: Generally, slight differences of drilling depth from one bit to another is acceptable. However, if the drilling depth across all boring bits is required, see Aligning Boring Bit Height on Page 30.
Adjusting Drilling Depth

The drilling depth is precisely adjusted by using the depth control on top of the headstock column (see Figure 21). The depth control window shows the drilling depth in inches, with the last two digits as decimals.

To adjust the drilling depth of the boring bits:

1. Loosen the depth locking screw shown in Figure 21.
2. Use the adjusting knob to bring the depth control to "0".
3. Calculate the drilling depth by using the following formula:
   \[ A + B = \text{Drilling Depth} \]
   - \( A \) = The distance from the bottom of the boring bit to the workpiece.
   - \( B \) = The desired depth of the hole to be drilled.

   Note: Use the following case and Figure 22 for an example of calculating drilling depth.

   In this example, the distance from the bottom of the boring bit to the workpiece is 2\( \frac{1}{4} \)" (\( A \)), and the depth of the desired hole in the workpiece is \( \frac{1}{2} \)" (\( B \)). Thus, the drilling depth is 2\( \frac{3}{4} \)".

   Calculation: \( 2\frac{1}{4}" + \frac{1}{2}" = 2\frac{3}{4}" \)

4. Convert any fraction of the calculated drilling depth to a 2-place decimal (\( \frac{3}{4} \)" in the above example is converted to 0.75").
5. Set the depth control to the calculated drilling depth and re-tighten the depth locking screw to secure the setting.

   Note: In the above example, the depth control would be set so that 2.75 would show in the depth control window.

6. Test the drilling depth setting on a scrap piece of stock that is the same thickness as your workpiece. Fine tune the depth control setting until you are satisfied with the drilling depth.

   **NOTICE**

   This line boring machine is designed to drill only wood products. Drilling any other material may damage the machine and will void the warranty.
**Adjusting Hold-down Height**

The hold-downs must firmly hold the workpiece during the boring operation. They are adjustable to accommodate the thickness of your stock.

To adjust the height of the workpiece hold-downs:

1. **DISCONNECT THE BORING MACHINE FROM POWER!**

2. Loosen the lock collar set screw so that the collar moves freely on the hold-down shaft (see Figure 23).

3. Lift the hold-down up until the bottom is just slightly higher than your workpiece when the boring head assembly is in the upper position, then re-tighten the locking collar set screw to secure the setting.

**NOTICE**

Make sure the hold-downs exert enough pressure to keep the workpiece in place against the rotational force of the boring bits. Otherwise, the workpiece may move during the boring operation, resulting in a drilling line that is out of alignment.

**Positioning the Workpiece**

The workpiece is positioned along the longitudinal and cross paths to align the boring bits with the desired line of drilling.

To position the workpiece for drilling:

1. Turn the machine **OFF**.

2. Unlock the longitudinal fence and move it along the cross fences to reach the correct distance from the boring bits along its entire length, then use the locking levers to secure it in place.

**Note:** The distance from the longitudinal fence to the boring bit centers can be measured on the cross fence scale, as shown in Figure 24.

**NOTICE**

If both ends of the longitudinal fence are not the same distance from the boring bit centers, the drilled holes will not line up correctly. Make sure that both ends of the longitudinal fence are the same distance from the boring bit centers before you tighten the locking levers.
3. Determine the drilling starting point of your workpiece, then position it under the boring head assembly and firmly against the longitudinal fence.

4. Use the longitudinal fence stops (Figure 25) to preserve the starting point when drilling workpieces that are the same length.

![Fence Stop](image)

**Figure 25.** Longitudinal fence stop.

5. If you need to drill more than 15 holes, push the indexing pin into the last previously drilled hole to position the workpiece, as shown in Figure 26.

![Indexing Pin](image)

**Figure 26.** Using the indexing pin to position workpiece for additional drilling (boring head guard removed for photo clarity).

---

**Drilling Overview**

Before beginning the boring operation, take these precautions:

- Make sure the boring head guard is in place and is free to move up as the boring head assembly comes down.
- Lock the table in the correct position.
- Set the depth control to the calculated drilling depth.
- Make sure that your workpiece is firmly against the longitudinal fence, and use push sticks to hold it in position.

When ready, use the downfeed handle to lower the boring head assembly in a controlled manner. The rate that you move the boring bits into the workpiece is determined by the workpiece material and your experience, and will affect the quality of the operation.

After the drilling is complete, raise the downfeed handle so that the boring head assembly is in the uppermost position, and turn the machine **OFF**.

---

**CAUTION**

To avoid personal injury, always keep hands and body away from the spinning boring bits.
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.

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

Figure 27. Recommended products for protecting unpainted cast iron/steel part on machinery.

T28172—14" x 39" Heavy-Duty Roller Table
T28369—14" x 78" Heavy-Duty Roller Table
T28370—14" x 118" Heavy-Duty Roller Table
Increase material handling and processing efficiency with one or more of these Heavy-Duty Roller Tables. Ideal for easily positioning material for cross cutting or cutting to length using a chop saw or metal cutting bandsaw. Simply place a roller table on one or both sides of your saw and production time is automatically improved!

Figure 28. G8982 Shop Fox roller table.

H3361—Clear Shelf Supports
H3362—White Shelf Supports
These Shelf Supports are ideal for easy to adjust shelving. Available in clear and white. Pins measure 13/64" (5mm) diameter by 5/16" long. 12 per pack.

Figure 29. Shelf Supports.

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

Model G0642 (Mfd. Since 11/14)
T20546—5mm Left Bit for Line Boring Machine
T20547—5mm Right Bit for Line Boring Machine
These 5mm Bits are for the G0642 & G0643 Line Boring Machines. Sold as singles.

Figure 30. T20546 Bit.

T20548—Bit Set for G0642 Boring Machine
These bits in the 15-pc. Boring Bit Set for G0642 Boring Machine are 10mm flat shank.

Figure 31. T20548 Bit Set.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!

Figure 32. Half-mask respirator with disposable cartridge filters.

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

Figure 33. Assortment of basic eye protection.

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

Model G0642 (Mfd. Since 11/14)
SECTION 6: MAINTENANCE

Lubrication

It is essential to clean components before lubricating them because dust and chips build up on lubricated components and make them hard to move. Simply adding more lubricant to them will not yield smooth moving components.

Lubricate Boring Head Assembly

Use a grease gun to inject two pumps of multi-purpose grease into each of the two grease fittings, located on either end of the boring head rear face (see Figure 34).

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted steel with a non-staining lubricant after cleaning.
Lubricate Headstock Slide Shafts and Leadscrew

1. DISCONNECT THE BORING MACHINE FROM POWER!

2. Set the depth control to "0".

3. Clean sawdust and debris from the visible sections of the headstock slide shafts and leadscrew (see Figure 35).

   Note: There is one headstock slide shaft on both sides of the column.

4. Apply a thin coat of light machine oil to the slide shafts and leadscrew.

5. With the power still disconnected, use the downfeed handle to move the boring head assembly through the entire range of motion to evenly distribute the lubrication.

   **NOTICE**

   Failure to perform proper lubrication maintenance on this machine will lead to premature wear of the moving parts, and will void the warranty.
## SECTION 7: SERVICE

Review the troubleshooting and 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>
<tbody>
<tr>
<td>Machine does not start or a breaker trips.</td>
<td>1. Plug/receptacle is at fault or wired incorrectly. &lt;br&gt;2. Start capacitor is at fault. &lt;br&gt;3. Motor connection wired incorrectly. &lt;br&gt;4. Wall fuse/circuit breaker is blown/tripped. &lt;br&gt;5. Power supply switched OFF or is at fault. &lt;br&gt;6. Wiring is open/has high resistance. &lt;br&gt;7. Power ON/OFF switch is at fault. &lt;br&gt;8. Centrifugal switch is at fault. &lt;br&gt;9. Motor is at fault.</td>
<td>1. Test for good contacts; correct the wiring. &lt;br&gt;2. Test/replace if faulty. &lt;br&gt;3. Correct motor wiring connections. &lt;br&gt;4. Ensure circuit size is suitable for this machine; replace weak breaker. &lt;br&gt;5. Ensure power supply is switched on; ensure power supply has the correct voltage. &lt;br&gt;6. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. &lt;br&gt;7. Replace faulty ON/OFF switch. &lt;br&gt;8. Adjust/replace the centrifugal switch if available. &lt;br&gt;9. Test/repair/replace.</td>
</tr>
<tr>
<td>Machine has vibration or noisy operation.</td>
<td>1. Motor or component is loose. &lt;br&gt;2. Motor mount loose/broken. &lt;br&gt;3. Machine is incorrectly mounted or sits unevenly on floor. &lt;br&gt;4. Motor fan is rubbing on fan cover. &lt;br&gt;5. Motor/boring head bearings are at fault. &lt;br&gt;6. Centrifugal switch is faulty. &lt;br&gt;7. Chuck or boring bit is at fault.</td>
<td>1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. &lt;br&gt;2. Tighten/replace. &lt;br&gt;3. Tighten/replace anchor studs in floor; relocate/shim machine. &lt;br&gt;4. Replace dented fan cover; replace loose/damaged fan. &lt;br&gt;5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. &lt;br&gt;6. Replace. &lt;br&gt;7. Replace out-of-round chuck, dull, or bent boring bit.</td>
</tr>
<tr>
<td>Machine stalls or is overloaded.</td>
<td>1. Workpiece material is not suitable for this machine. &lt;br&gt;2. Run capacitor is at fault. &lt;br&gt;3. Motor connection is wired incorrectly. &lt;br&gt;4. Plug/receptacle is at fault. &lt;br&gt;5. Motor/boring head bearings are at fault. &lt;br&gt;6. Machine undersized for task. &lt;br&gt;7. Motor has overheated. &lt;br&gt;8. Motor is at fault. &lt;br&gt;9. Centrifugal switch is at fault.</td>
<td>1. Only drill wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece. &lt;br&gt;2. Test/repair/replace. &lt;br&gt;3. Correct motor wiring connections. &lt;br&gt;4. Test for good contacts; correct the wiring. &lt;br&gt;5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. &lt;br&gt;6. Use sharp bits/reduce downfeed rate. &lt;br&gt;7. Clean off motor, let cool, and reduce workload. &lt;br&gt;8. Test/repair/replace. &lt;br&gt;9. Adjust/replace centrifugal switch if available.</td>
</tr>
</tbody>
</table>
## Operation

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
</table>
| Machine slows when operating. | 1. Applying too much pressure to workpiece.  
2. Boring bits are dull.      | 1. Reduce the downfeed rate.  
2. Replace boring bits.        |
| Holes do not line up correctly.| 1. Longitudinal fence is not parallel with the boring head.  
2. Workpiece not kept firmly against longitudinal fence. | 1. Make sure that both ends of the longitudinal fence are the same distance from the boring head/bit centers before tightening the locking levers.  
2. Use push sticks to keep workpiece firmly against longitudinal fence during drilling operation. |
| Holes bored at an angle.      | 1. Table is not parallel with boring head.  
2. Chuck or boring bit is at fault. | 1. Align table parallel to boring head (see **Page 32**).  
2. Replace out-of-round chuck; replace/re-install boring bit. |
| Depth of holes are not equal. | 1. Table is not parallel with boring head.  
2. Heights of boring bits are not aligned. | 1. Align table parallel to boring head (see **Page 32**).  
2. Align the height of boring bits (see **Page 33**). |
Adjusting Table Parallel to Boring Head

If the table is not parallel to the boring head, drilled holes will be at an angle or at different depths.

To check and adjust the table parallel to the boring head:

1. DISCONNECT THE BORING MACHINE FROM POWER!

2. Use a dial indicator or a planed piece of stock to measure the distance between the table and boring head at the four corners of the boring head (refer to the X's illustrated in Figure 36).

   — If these distances are not equal, the table and boring head are not parallel to one another. Continue to Step 3.

   — If these distances are equal, the table and boring head are parallel, and no further adjustments are necessary.

3. Loosen the cap screws that secure the cross fence (see Figure 37), and shim between the mounting bracket and the cross fence.

4. Re-tighten the cross fence cap screws, and re-check the parallelism of the table and boring head. Repeat this procedure if necessary.
Aligning Boring Bit Height

To ensure drilled holes are consistent in depth along the length of the workpiece, the height of all boring bits must be equal.

Note: The table must be parallel to the boring head assembly before aligning the boring bits. Refer to Adjusting Table Parallel to Boring Head on Page 32.

To align boring bit height:

1. DISCONNECT THE BORING MACHINE FROM POWER!

![CAUTION]

Boring bits are sharp and can cut your hands. Protect yourself by using a shop rag to handle the bits during removal or installation.

2. Make sure that all boring bits are inserted fully into the chuck.

   Note: This can be done by loosening the two set screws that hold the bit into the chuck, and, while applying moderate upward pressure on the bit, re-tightening the set screws.

3. Use a dial indicator or planed piece of stock and feeler gauges to determine if all boring bits are the same distance from the table.

4. The height of a boring bit can be adjusted by removing the bit from the chuck, turning the center screw of the bit (see Figure 38), then re-installing the bit into the chuck.

![Figure 38. Boring bit height adjusting screw.]

Note: Threading the adjusting screw into the bit raises the working height of the boring bit.
Model G0642 Motor & ON/OFF Switch Wiring Diagram

Motor Wired for 110V (Pre-Wired)

Motor Wired for 220V

NOTICE

The motor wiring shown here is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.

Figure 39. Motor wiring.

Figure 40. Switch wiring (110V).
SECTION 8: PARTS

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

Column & Electrical

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

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<thead>
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<th>DESCRIPTION</th>
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<th>DESCRIPTION</th>
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<tbody>
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<td>FLAT WASHER 10MM</td>
<td>33 P0642033</td>
<td>STRAIN RELIEF</td>
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<td>2 P0642002</td>
<td>LOCK WASHER 8MM</td>
<td>34 P0642034</td>
<td>CABLE CLAMP</td>
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<td>3 P0642003</td>
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<td>35 P0642035</td>
<td>MOTOR 1HP 110/220V 1PH</td>
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<td>4 P0642004</td>
<td>HEADSTOCK SPRING BRACKET</td>
<td>35-1 P0642035-1</td>
<td>S CAPACITOR 300M 125V 1.38 X 3.38</td>
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<tr>
<td>5 P0642005</td>
<td>HAIRPIN COTTER PIN</td>
<td>35-2V2 P0642035-2V2</td>
<td>R CAPACITOR 50M 250V 2-1/4 X 1-1/2 V2.11.14</td>
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<td>MOTOR FAN COVER</td>
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<tr>
<td>8 P0642008</td>
<td>KNURLED KNOB</td>
<td>36 P0642036</td>
<td>HANDLE</td>
</tr>
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<td>HEADSTOCK EXTENSION SPRING</td>
<td>37 P0642037</td>
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<td>10 P0642010</td>
<td>DEPTH CONTROL GAUGE</td>
<td>38 P0642038</td>
<td>HEADSTOCK WAY</td>
</tr>
<tr>
<td>11 P0642011</td>
<td>CAP SCREW M6-1 X 20</td>
<td>39 P0642039</td>
<td>BUSHING</td>
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<tr>
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<td>INT RETAINING RING 32MM</td>
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<td>DEPTH CONTROL GAUGE MOUNT</td>
<td>41 P0642041</td>
<td>FLAT WASHER 6MM</td>
</tr>
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<td>42 P0642042</td>
<td>PIVOT PIN</td>
</tr>
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</tr>
<tr>
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<td>30 P0642030</td>
<td>SWITCH BOX</td>
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*Model G0642 (Mfd. Since 11/14)*
## Table Parts List

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## Cabinet & Tools

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## Labels & Cosmetics

![Image of a machine with labels highlighted]

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<td>DISCONNECT WARNING LABEL</td>
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<td>ENTANGLEMENT HAZARD LABEL</td>
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<td>P0642407</td>
<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.
WARRANTY CARD

Name: ____________________________________________
Street: __________________________________________
City _______________________ State _________________________ Zip _____________________
Phone #: ____________________ Email: ________________________________
Model #: ____________________ Order #: _______________________ Serial #: __________________

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

1. How did you learn about us?
   - Advertisement
   - Friend
   - Catalog
   - Card Deck
   - Website
   - Other: __________________________

2. Which of the following magazines do you subscribe to?
   - Cabinetmaker & FDM
   - Family Handyman
   - Hand Loader
   - Handy
   - Home Shop Machinist
   - Journal of Light Cont.
   - Live Steam
   - Model Airplane News
   - Old House Journal
   - Popular Mechanics
   - Wooden Boat
   - Popular Science
   - Precision Shooter
   - Projects in Metal
   - RC Modeler
   - Rifle
   - Shop Notes
   - Other: __________________________

3. What is your annual household income?
   - $20,000-$29,000
   - $30,000-$39,000
   - $40,000-$49,000
   - $50,000-$59,000
   - $60,000-$69,000
   - $70,000+

4. What is your age group?
   - 20-29
   - 30-39
   - 40-49
   - 50-59
   - 60-69
   - 70+

5. How long have you been a woodworker/metalworker?
   - 0-2 Years
   - 2-8 Years
   - 8-20 Years
   - 20+ Years

6. How many of your machines or tools are Grizzly?
   - 0-2
   - 3-5
   - 6-9
   - 10+

7. Do you think your machine represents a good value?  _____Yes  _____No

8. Would you recommend Grizzly Industrial to a friend?  _____Yes  _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?  
   Note: We never use names more than 3 times.  _____Yes  _____No

10. Comments: _____________________________________________________________
    _______________________________________________________________________
    _______________________________________________________________________
    _______________________________________________________________________
    _______________________________________________________________________
Send a Grizzly Catalog to a friend:

Name____________________________________________________
Street____________________________________________________
City______________________ State_______ Zip________

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

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

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

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

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

Thank you again for your business and continued support. We hope to serve you again soon.
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24 HOURS A DAY!
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