

Grizzly **Industrial, Inc.**®

MODEL G0699 **12" SLIDING TABLE SAW** **w/SCORING MOTOR** **OWNER'S MANUAL** *(For models manufactured since 5/15)*



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 **WARNING!**

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

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

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

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

 **WARNING!**

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

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

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

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INTRODUCTION

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.

Grizzly Industrial MODEL GXXXX MACHINE NAME

WARNING!

To reduce risk of serious injury when using this machine:

1. Read manual before operation.
2. Wear safety glasses and respirator.
3. Make sure blade is properly adjusted/setup and power is connected to grounded circuit before starting.
4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service.
5. DO NOT expose to rain or dampness.
6. DO NOT modify this machine in any way.
- 7.
- 8.
9. Do not use while intoxicated or fatigued.
10. Maintain machine carefully to prevent accidents.

Manufacture Date

Serial Number

Manufactured for Grizzly in Taiwan

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

Machine Description

A sliding table saw is primarily used to rip and crosscut sheet stock or panels in a production setting. The sliding table saves time and increases accuracy by removing the burden of sliding large and heavy panels over a stationary table surface. This saw can also be used as a traditional table saw for most types of through-cuts.

The Model G0699 is equipped with a scoring blade, which is a smaller blade located in front of the main blade. It makes a shallow cut in the workpiece in the opposite direction of the main blade, greatly reducing tear-out and chipped edges.

When using the sliding table saw as a traditional table saw, the sliding table is locked in place and the rip fence is then used to guide the workpiece through the cut.



Identification

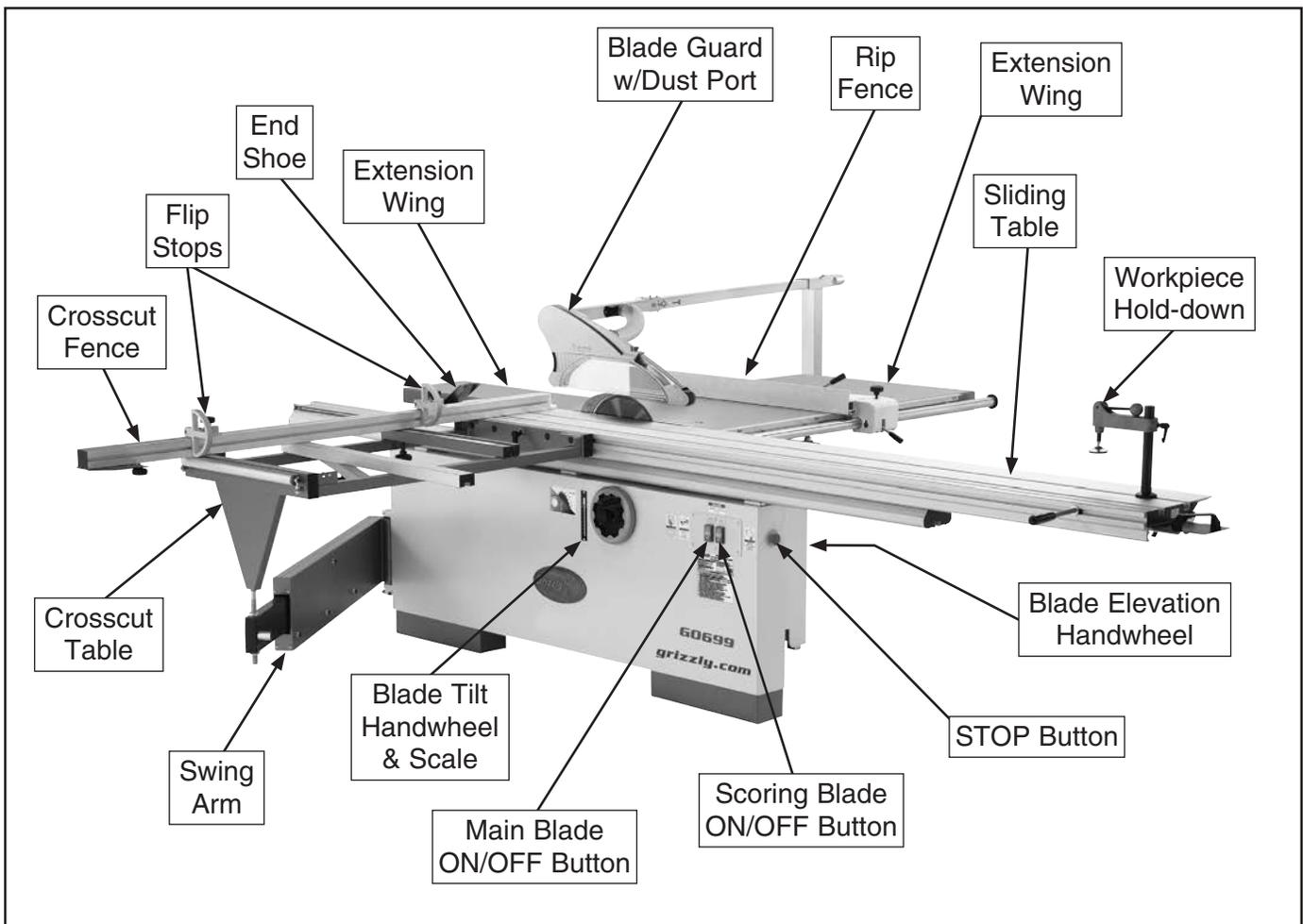


Figure 1. Model G0699 identification.

⚠ CAUTION

For Your Own Safety Read Instruction Manual Before Operating Saw

- a) Wear eye protection.
- b) Use saw-blade guard and riving knife for every operation for which it can be used, including all through sawing.
- c) Keep hands out of the line of saw blade.
- d) Use a push-stick when required.
- e) Pay particular attention to instructions on reducing risk of kickback.
- f) Do not perform any operation freehand.
- g) Never reach around or over saw blade.





MACHINE DATA SHEET

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

MODEL G0699 12" 7-1/2 HP 3-PHASE SLIDING TABLE SAW WITH SCORING BLADE MOTOR

Product Dimensions:

Weight..... 1274 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 139 x 133 x 45 in.
 Footprint (Length x Width)..... 74-1/2 x 35-1/2 in.
 Space Required for Full Range of Movement (Width x Depth)..... 280 x 139 in.

Shipping Dimensions:

Carton #1

Type..... Wood Crate
 Content..... Machine
 Weight..... 1236 lbs.
 Length x Width x Height..... 45 x 82 x 44 in.
 Must Ship Upright..... Yes

Carton #2

Type..... Wood Crate
 Content..... Sliding Table
 Weight..... 262 lbs.
 Length x Width x Height..... 19 x 133 x 12 in.
 Must Ship Upright..... No

Electrical:

Power Requirement..... 220V or 440V, 3-Phase, 60 Hz
 Prewired Voltage..... 220V
 Full-Load Current Rating..... 23A at 220V, 11.5A at 440V
 Minimum Circuit Size..... 30A at 220V, 15A at 440V
 Connection Type..... Cord at 220V, Perman
 Power Cord Included..... No
 Recommended Power Cord..... "S"-Type, 4-Wire, 8 AWG, 300 VAC for 220V
 Plug Included..... No
 Recommended Plug Type..... L15-30 for 220V
 Switch Type..... Button Controls w/Magnetic Switch Protection
 Voltage Conversion Kit..... P06991310 for 440V
 Recommended Phase Converter..... G5845

Motors:

Main

Horsepower..... 7.5 HP
 Phase..... 3-Phase
 Amps..... 20A/10A
 Speed..... 3450 RPM
 Type..... TEFC Induction
 Power Transfer..... V-Belt Drive
 Bearings..... Shielded & Permanently Lubricated
 Centrifugal Switch/Contacts Type..... N/A



Scoring Blade

Horsepower.....	1 HP
Phase.....	3-Phase
Amps.....	3.2A/1.6A
Speed.....	3450 RPM
Type.....	TEFC Induction
Power Transfer	Belt Drive
Bearings.....	Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type.....	N/A

Main Specifications:

Operation Information

Main Blade Size.....	12 in.
Main Blade Arbor Size.....	1 in.
Scoring Blade Size.....	4-3/4 in. (120 mm)
Scoring Blade Arbor Size.....	20 mm
Main Blade Tilt.....	0 – 45 deg.
Main Blade Speed.....	4000 RPM
Scoring Blade Tilt.....	0 – 45 deg.
Scoring Blade Speed.....	8000 RPM

Cutting Capacities

Max Depth of Cut At 90 Deg.....	3-5/16 in.
Max Depth of Cut At 45 Deg.....	2-3/8 in.
Rip Fence Max Cut Width.....	49-3/4 in.
Sliding Table w/Crosscut Fence Max Cut Width.....	126 in.
Sliding Table w/Crosscut Fence Max Cut Length.....	126 in.
Miter Fence Max Cut Width at 45 Deg.....	126 in.

Table Information

Floor To Table Height.....	36 in.
Table Size Length.....	21-1/2 in.
Table Size Width.....	35-1/4 in.
Table Size Thickness.....	3 in.
Table Size With Ext Wings Length.....	59 in.
Table Size With Ext Wings Width.....	68 in.
Table Size With Ext Wings Thickness.....	3 in.
Sliding Table Length.....	126 in.
Sliding Table Width.....	14 in.

Fence Information

Crosscut Fence Type.....	Single Lever Locking, Extruded Aluminum
Crosscut Fence Size Length.....	73 in.
Crosscut Fence Size Width.....	2-3/8 in.

Construction Materials

Table.....	Precision-Ground Cast Iron
Sliding Table.....	Aluminum
Cabinet.....	Steel
Rip Fence Rails.....	Hardened Steel
Guard.....	Plastic
Spindle Bearing Type.....	Lubricated & Permanently Sealed Ball Bearing
Cabinet Paint Type/Finish.....	Powder Coated

Other Related Information

No of Dust Ports.....	2
Dust Port Size.....	4, 5 in.

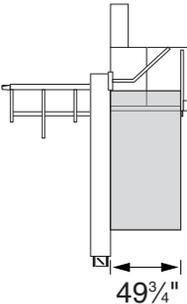
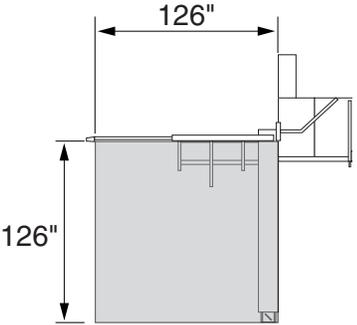
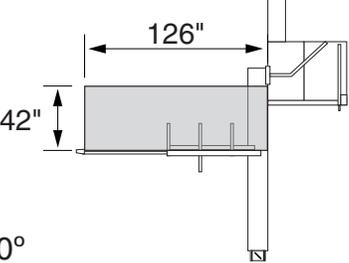
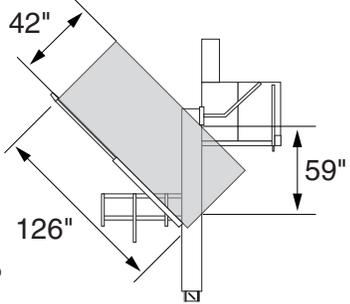
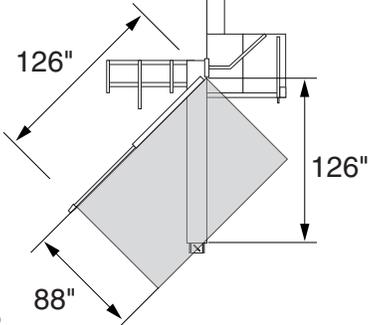
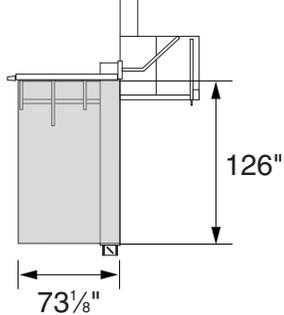
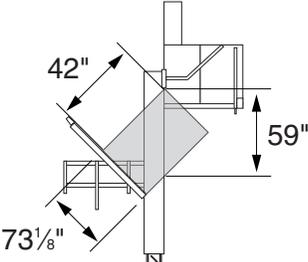
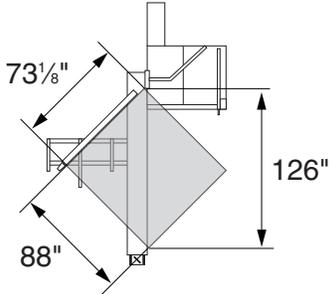




SLIDING TABLE SAW CAPACITIES

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

MODEL G0699 12" SLIDING TABLE SAW

 <p>Ripping Width</p>	 <p>Cross Cut</p>
 <p>Miter Cut 90° (push cut)</p>	 <p>Miter Cut 45° (push cut)</p>
 <p>Miter Cut 45°</p>	 <p>Cross Cut (fence not extended)</p>
 <p>Miter Cut 45° (push cut, fence not extended)</p>	 <p>Miter Cut 45° (fence not extended)</p>



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 Sliding Table Saws

WARNING

Serious injury or death can occur from getting cut or having body parts, such as fingers, amputated by rotating saw blade. Workpieces thrown by kickback can strike operators or bystanders with deadly force. Flying particles from cutting operations or broken blades can cause eye injuries or blindness. To minimize risk of getting hurt or killed, anyone operating machine **MUST** completely heed hazards and warnings below.

HAND & BODY POSITIONING. Keep hands away from saw blade and out of blade path during operation, so they cannot slip accidentally into blade. Stand to side of blade path. Never reach around, behind, or over blade. Only operate at front of machine.

BLADE GUARD. Use blade guard for all cuts that allow it to be used safely. Make sure blade guard is installed and adjusted correctly. Promptly repair or replace if damaged. Re-install blade guard immediately after operations that require its removal.

RIVING KNIFE. Use riving knife for all cuts. Make sure riving knife is aligned and positioned correctly. Promptly repair or replace it if damaged.

KICKBACK. Kickback occurs when saw blade ejects workpiece back toward operator. Know how to reduce risk of kickback. Learn how to protect yourself if it does occur.

WORKPIECE CONTROL. Feeding workpiece incorrectly increases risk of kickback. Make sure workpiece is in stable position on tables and supported by rip fence or crosscut fence during cutting operation. Never start saw with workpiece touching blade. Allow blade to reach full speed before cutting. Only feed workpiece against direction of main blade rotation. Always use some type of guide to feed workpiece in a straight line. Never back workpiece out of cut or move it backwards or sideways after starting a cut. Feed cuts all the way through to completion. Never perform any operation “freehand”. Turn OFF saw and wait until blade is completely stopped before removing workpiece.

FENCE ADJUSTMENTS. Make sure rip fence remains properly adjusted and parallel with blade. Never move fence while blade is rotating. Adjusting fence during operation increases risk of crashing fence and sending metal fragments flying with deadly force at operator or bystanders. Only adjust fence when blade is completely stopped and saw is **OFF**. Always lock fence before using.

PUSH STICKS/BLOCKS. Use push sticks or push blocks whenever possible to keep your hands farther away from blade while cutting. In event of an accident these devices will often take damage that would have happened to hands/fingers.

BLADE ADJUSTMENTS. Adjusting blade height or tilt during operation increases risk of crashing blade and sending metal fragments flying with deadly force at operator or bystanders. Only adjust blade height and tilt when blade is completely stopped and saw is **OFF**.

CHANGING BLADES. Always disconnect power before changing blades. Changing blades while saw is connected to power greatly increases injury risk if saw is accidentally powered up.

DAMAGED SAW BLADES. Never use blades that have been dropped or otherwise damaged.

CUTTING CORRECT MATERIAL. Never cut materials not intended for this saw. Only cut natural and man-made wood products, laminate covered wood products, and some plastics. Cutting metal, glass, stone, tile, etc. increases risk of operator injury due to kickback or flying particles.



Preventing Kickback

Do the following to prevent kickback:

- When rip cutting, only cut workpieces that have at least one smooth and straight edge. DO NOT cut excessively warped, cupped or twisted wood. If workpiece warpage is questionable, always choose another workpiece.
- Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.
- Ensure sliding table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table before cutting.
- Always use the riving knife whenever possible. It reduces risk of kickback and reduces your risk of injury if it does occur.
- Always keep blade guard installed and in good working order.
- Feed cuts through to completion. Any time you stop feeding a workpiece in the middle of a cut, the chance of kickback is greatly increased.
- Ensure rip fence is adjusted parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the rip fence before cutting.

Protecting Yourself From Kickback

Even if you know how to prevent kickback, it may still happen. Here are some precautions to help protect yourself if kickback DOES occur:

- Stand to the side of the blade path when cutting. If a kickback does occur, the thrown workpiece usually travels directly towards the front of the blade.
- Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable parts of your body.
- Never, for any reason, place your hand behind the blade path. Should kickback occur, your hand will be pulled into the blade.
- Use a push stick or push block to keep your hands farther away from the moving blade. If a kickback occurs, these safety devices will most likely take the damage that your hand would have received.
- Use featherboards or anti-kickback devices to prevent or slow down kickback.

WARNING

Statistics show that the most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward the operator. In addition to the danger of the operator or others in the area being struck by the flying stock, it is often the case that the operator's hands are pulled into the blade during the kickback.



Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this sliding table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is VERY important to us at Grizzly!

Arbor: Metal shaft extending from the drive mechanism, to which saw blade is mounted.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

Blade Guard: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

Crosscut: Cutting operation in which the cross-cut fence is used to cut across the grain, or across the shortest width of the workpiece.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that cuts a flat bottomed groove into the face of the workpiece.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface.

Kerf: The resulting cut or gap in the workpiece from the saw blade passing through it while cutting.

Kickback: A dangerous event that happens if the blade catches on the workpieces while cutting. The force of the blade then throws the workpiece back toward the operator with what sounds like a horrible explosion. The danger comes from flying stock striking the operator or bystanders. The operator's hands may also be pulled into the blade during the kickback. Refer to **Preventing Kickback** on **Page 100** for additional information.

Non-Through Cut: A sawing operation in which the workpiece is not completely sawn through. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock.

Parallel: When two objects are spaced an equal distance apart at every point along two given lines or planes (I.e. the rip fence face is parallel to the face of the saw blade).

Perpendicular: Lines or planes that intersect and form right angles. I.e. the blade is perpendicular to the table surface.

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece.

Rip Cut: Cutting operation in which the rip fence is used to cut with the grain, or cut across the widest width of the workpiece.

Riving Knife: Metal plate located behind the blade maintains the kerf opening in the wood when cutting, and helps reduce the risk of injury from a kickback that otherwise would result in amputation.

Straightedge: A tool with a perfectly straight edge used to check the flatness, parallelism, or consistency of a surface(s).

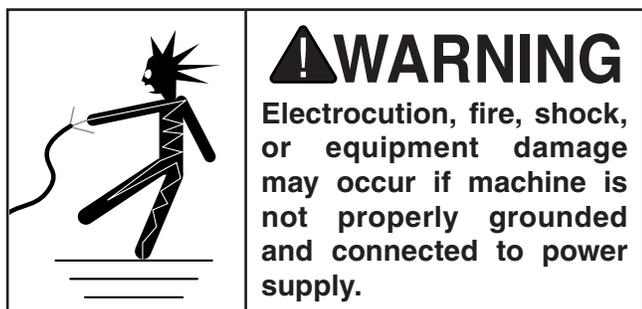
Through Cut: A sawing operation in which the workpiece is completely sawn through.



SECTION 2: POWER SUPPLY

Availability

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



Full-Load Current Rating

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

Full-Load Current Rating at 220V 23 Amps

Full-Load Current Rating at 440V .. 11.5 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 Requirements for 220V

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 220V/240V
Cycle 60 Hz
Phase 3-Phase
Circuit Rating 30 Amps
Plug/Receptacle NEMA L15-30
Cord 4-Wire, 8 AWG, 300VAC, “S”-Type

Circuit Requirements for 440V

This machine can be converted to operate on a 440V power supply (refer to **Voltage Conversion** instructions) that has a verified ground and meets the following requirements:

Nominal Voltage 440V/480V
Cycle 60 Hz
Phase 3-Phase
Rated Size 15 Amps
Connection Hardwire with Locking Switch

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.)



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



Grounding Instructions

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 220V operation: The power cord and plug specified under “Circuit Requirements for 220V” on the previous page have an equipment-grounding wire and a grounding prong. 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 (see figure below).

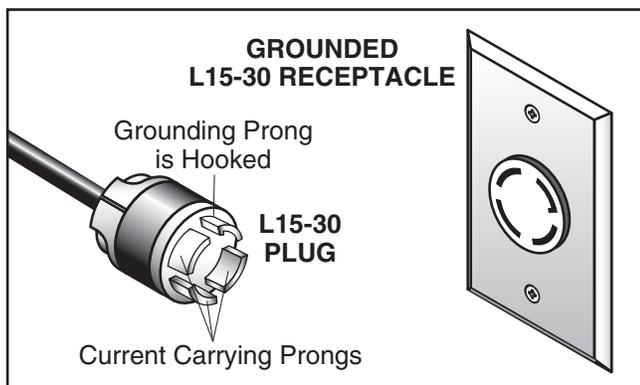


Figure 2. Typical L15-30 plug and receptacle.

For 440V operation: As specified in “Circuit Requirements for 440V” on the previous page, the machine must be hardwired to the power source, using a locking switch as a disconnecting means (see below). The machine must also be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. Due to the complexity and high voltage involved, this type of installation **MUST** be done by a qualified electrician.

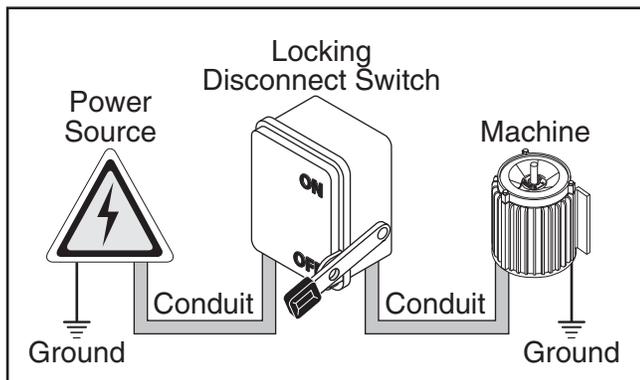


Figure 3. Typical hardwire setup with a locking disconnect switch.

!WARNING

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

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 (220V Only)

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 Size8 AWG
Maximum Length (Shorter is Better).....50 ft.



440V Conversion

The Model G0699 can be converted for 440V operation. This conversion job consists of disconnecting the saw from the power source, replacing both overload relays, moving the fuse to the 440V holder, and rewiring the main and scoring blade motors for 440V operation.

Purchase the Model G0699 440V Conversion Kit (Part No. P06991310) that includes the necessary overload relays for this procedure by calling Grizzly Customer Service at (800) 523-4777.

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

To rewire the Model G0699 for 440V operation:

1. DISCONNECT SAW FROM POWER!
2. Remove the electrical panel cover from the back of the frame (see **Figure 4**).

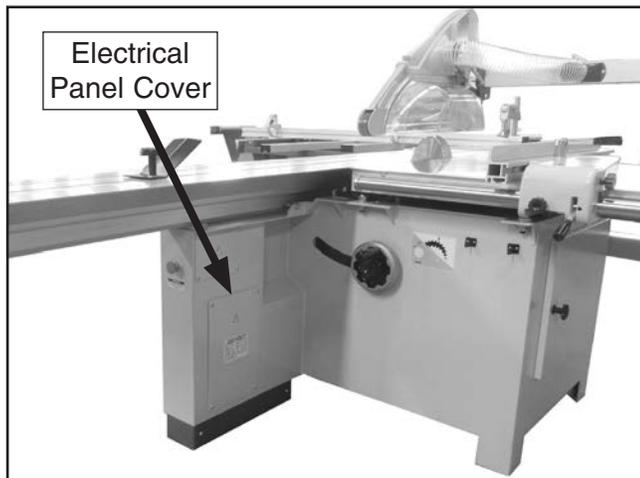


Figure 4. Location of electrical panel cover.

3. Make note of wire locations on both overload relays installed on the electrical panel (see **Figure 5** and refer to **Electrical Cabinet Wiring Diagram** on **Page 80**).

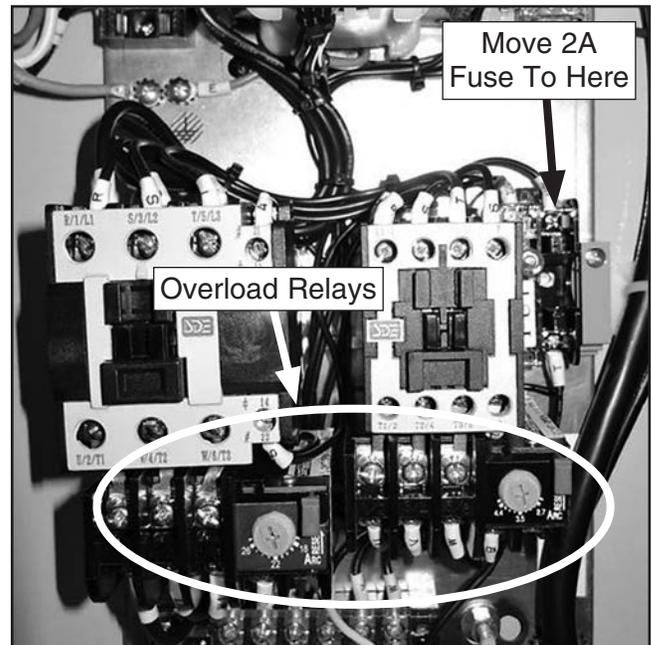


Figure 5. Locations of the overload relays on the electrical panel.

4. Disconnect and remove both overload relays, then replace them with the relays included in the 440V conversion kit.

Note: Although the two 220V relays look similar, they are not the same models. However, the two 440V relays are the same models and can be installed in either position.

5. Set the amperage dial on the left relay to 10A and the right relay to 2A.
6. Move the 2 amp fuse from the 220V fuse holder to the 440V fuse holder, as shown in **Figure 5**.
7. Open the junction boxes on the main and scoring blade motors, then rewire the motors as shown on the diagrams located inside the motor junction box covers.

Note: When changing the motor wiring for the 440V conversion, refer to the wiring diagrams inside the motor junction box covers, as they will reflect any changes to the motors shipped with the machine. As an aid to understanding these wiring diagrams or if they are missing, refer to the motor wiring diagrams on **Page 82**.



Correcting Phase Polarity

This subsection is only provided for troubleshooting. If you discover during the test run that the saw will not operate, or that the blades spin backward, the power connections may be wired out-of-phase. Without the proper test equipment to determine the polarity of the power source legs, wiring machinery to 3-phase power may require trial-and-error. Correcting phase polarity is simply a matter of reversing the positions where two of the incoming power source wires are connected at the junction box.

⚠️ WARNING

If this machine is wired out-of-phase, the blades will spin in the wrong directions. If you attempt a cutting operation with the blades spinning backward, the workpiece could be thrown aggressively from the table during the cutting operation. This could result in death or serious personal injury. You **MUST** make sure the blades are spinning in the correct directions before attempting any cutting operations. Perform **Step 9** of the test run on **Page 41** to make sure the machine is correctly wired.

To correct phase polarity:

1. DISCONNECT SAW FROM POWER!
2. Remove the power connection junction box cover (see **Figure 6**).

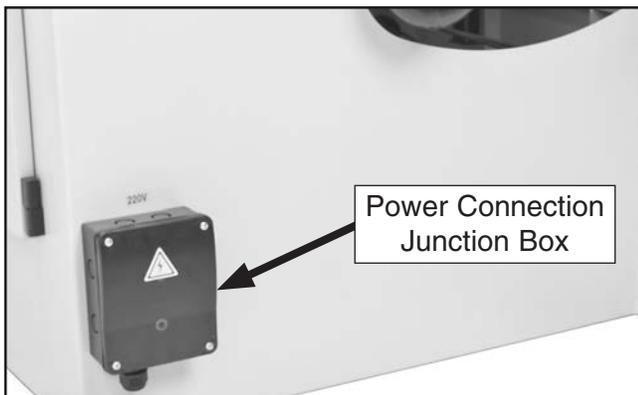


Figure 6. Location of power connection junction box.

3. Swap any two of the hot incoming power connections (see **Figure 7**), then replace the junction box cover.

⚠️ WARNING

Make sure the incoming ground wire is connected to the right-most terminal post in the power connection junction box to ensure the machine is properly grounded. An ungrounded or improperly grounded machine could cause electrocution.

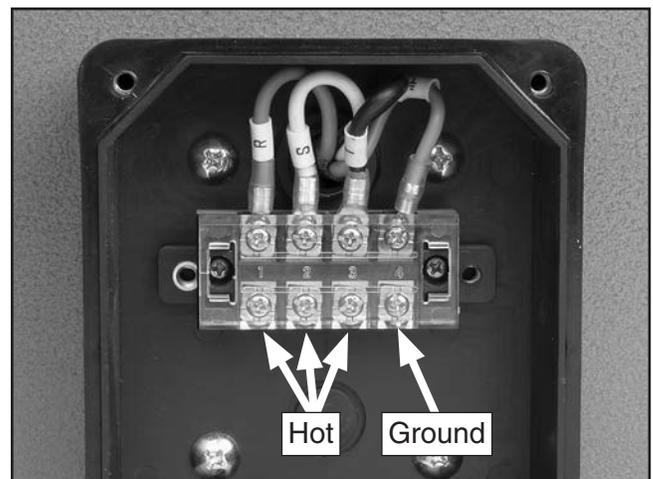


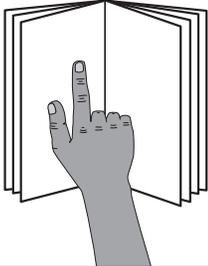
Figure 7. Incoming power connections.

4. Perform **Step 9** of the test run on **Page 41** to confirm that the power connections are correct.

—If the motors and blades are still rotating in the wrong direction, contact our Tech Support at (570) 546-9663 for assistance.



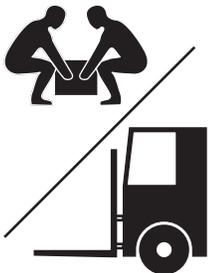
SECTION 3: SETUP



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



!WARNING
Wear safety glasses during the entire setup process!



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

Needed for Setup

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

Description	Qty
• Additional People	At Least 3
• Safety Glasses	1 Per Person
• Cleaner/Degreaser (Page 20)	As Needed
• Disposable Shop Rags.....	As Needed
• Forklift (Rated for At Least 1500 lbs.).....	1
• Saw Blade 12"	1
• Straightedge 3'	1
• Precision Ruler	1
• Felt Tip Pen	1
• Adjustable Carpenter's Square	1
• Feeler Gauge Set.....	1
• 90° Square	1
• Screwdriver Phillips #2	1
• Hex Wrench 3mm.....	1
• Hex Wrench 4mm.....	1
• Hex Wrench 5mm.....	1
• Hex Wrench 6mm.....	1
• Hex Wrench 8mm.....	1
• Wrench 12mm	1
• Dust Collection System	1
• Dust Hose 2½"	1
• Dust Hose 5"	1
• Hose Clamps 5"	2

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.

Crate 1 (Figure 8)	Qty
A. Forward Extension Wing	1
B. Rear Extension Wing	1
C. Crosscut Table	1
D. Crosscut Fence	1
E. Crosscut Table Brace	1
F. Rip Fence Rail w/Fasteners	1
G. Rip Fence Scale	1
H. Rip Fence	1
I. Rip Fence Body Assembly	1
J. Crosscut Fence Flip Stops	2
K. End Shoe Assembly	1
L. Push Stick	1
M. Riving Knife	1
N. Hold-Down Assembly	1
O. Blade Guard Cover (Wide)	1
P. Blade Guard Cover (Straight)	1
Q. Blade Guard Dust Hood	1
R. Blade Guard Connection Plate Assembly ..	1
S. Arm Support Pedestal	1
T. Arm Support Base	1
U. Upper Support Arm	1
V. Dust Hose 3"	1
W. Dust Port Connection 3"	1
X. Tool Box (Not Shown)	1
—Scoring Arbor Wrench	1
—Combo Wrench 17/19mm	1
—Wrench 30mm	1
—T-Handle Wrench 8mm	1

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.

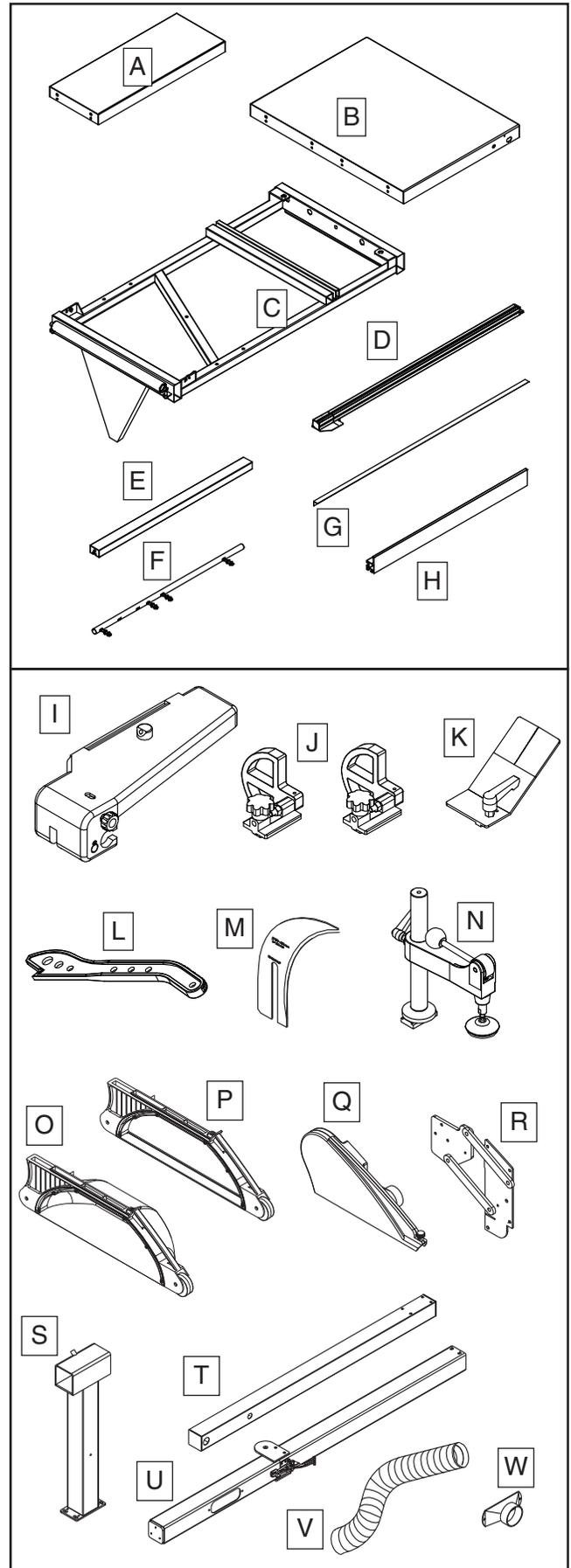


Figure 8. Crate 1 inventory.



Hardware (Not Shown)	Qty
Sliding Table:	
—T-Bolts M12-1.75 x 50.....	3
—Flat Washers 12mm.....	3
—Lock Washers 12mm.....	3
—Hex Nuts M12-1.75.....	3
—Push Handle M12-1.75 x 12.....	1
—Flat Washer 12mm.....	1
—Copper Flat Washer 12mm.....	1
—T-Nut M12-1.75.....	1

Wings:	
—Set Screws M10-1.5 x 20.....	5
—Hex Nuts M10-1.5.....	5

Rip Fence:	
—Handles M10-1.5 x 12.....	2
—Knob M10-1.5 x 70.....	1
—Button Head Cap Screws M6-1 x 12.....	3
—Flat Washers 6mm.....	4
—Hex Nut M6-1.....	1

Rip Fence Rail:	
—Rip Fence Stop Ring w/Set Screw.....	1
—Flat End Cap.....	1
—Lock Washer 8mm.....	1
—Cap Screw M8-1.25 x 16.....	1

Cross Cut Table:	
—Lock Handle M12-1.75 x 55.....	1
—Flat Washer 12mm.....	1
—T-Nut Plate M12-1.75.....	1

Cross Cut Table Brace:	
—T-Nuts M8-1.25.....	2
—Fender Washers 8mm.....	2
—Knobs M8-1.25 x 50.....	2

Cross Cut Fence:	
—T-Bolt M8-1.25 x 35.....	1
—Fender Washer 8mm.....	1
—Knobs M8-1.25.....	2
—Pivot Stud M8-1.25 x 15.....	1
—Fiber Flat Washers 8mm.....	2
—T-Nuts M8-1.25.....	3
—Knob M8-1.25 x 25 w/Nylon Tip.....	1
—Knob M8-1.25 x 50.....	1
—Stop Block.....	1
—Cap Screw M8-1.25 x 35.....	1
—Lock Washer 8mm.....	1
—Plastic T-Washer 8mm.....	1
—Hex Nuts M8-1.25.....	2
—Flat Washers 8mm.....	2

Dust Port Adapter:	
—Button Head Cap Screws M6-1 x 12.....	2
—Lock Washers 6mm.....	2
—Flat Washers 6mm.....	2

Upper Support Arm Dust Port:	
—Button Head Cap Screws M6-1 x 12.....	2
—Lock Washers 6mm.....	2

Blade Guard:	
—Wire Clamps 3¼".....	2
—Compression Cylinder.....	1
—Dust Port Adapter 4".....	1

Blade Guard Support Base, Pedestal, Arm, and Connection Plate:

—Cap Screws M8-1.25 x 25.....	4
—Flat Washers 8mm.....	4
—Lock Washers 8mm.....	4
—Cap Screws M6-1 x 20.....	3
—Lock Washers 6mm.....	3
—Flat Washers 6mm.....	3
—L-Block.....	1
—Cap Screws M6-1 x 20.....	2
—Flat Washers 6mm.....	3
—Lock Washers 6mm.....	2
—Hex Nut M6-1.....	1

Crate 2 (Figure 9)	Qty
Y. Sliding Table Assembly.....	1
Z. End Handle Assembly.....	1
—Button Hd. Cap Screws M8-1.25 x 16.....	2

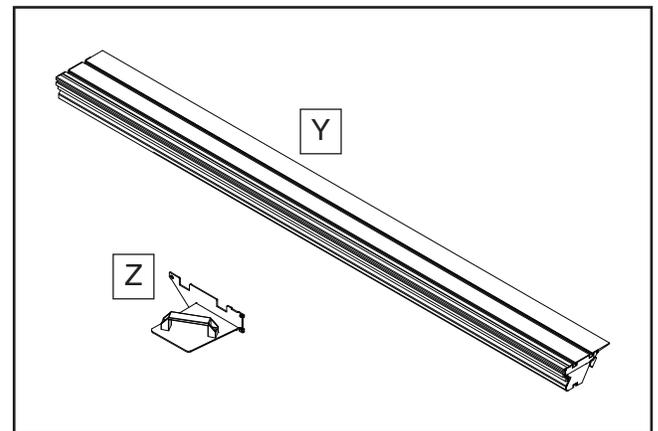


Figure 9. Crate 2 inventory.



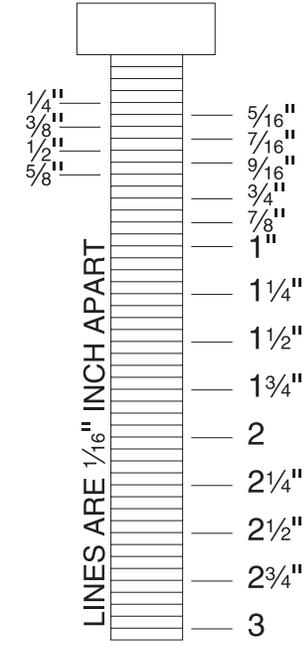
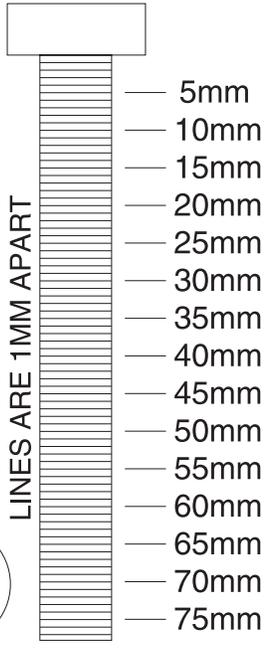
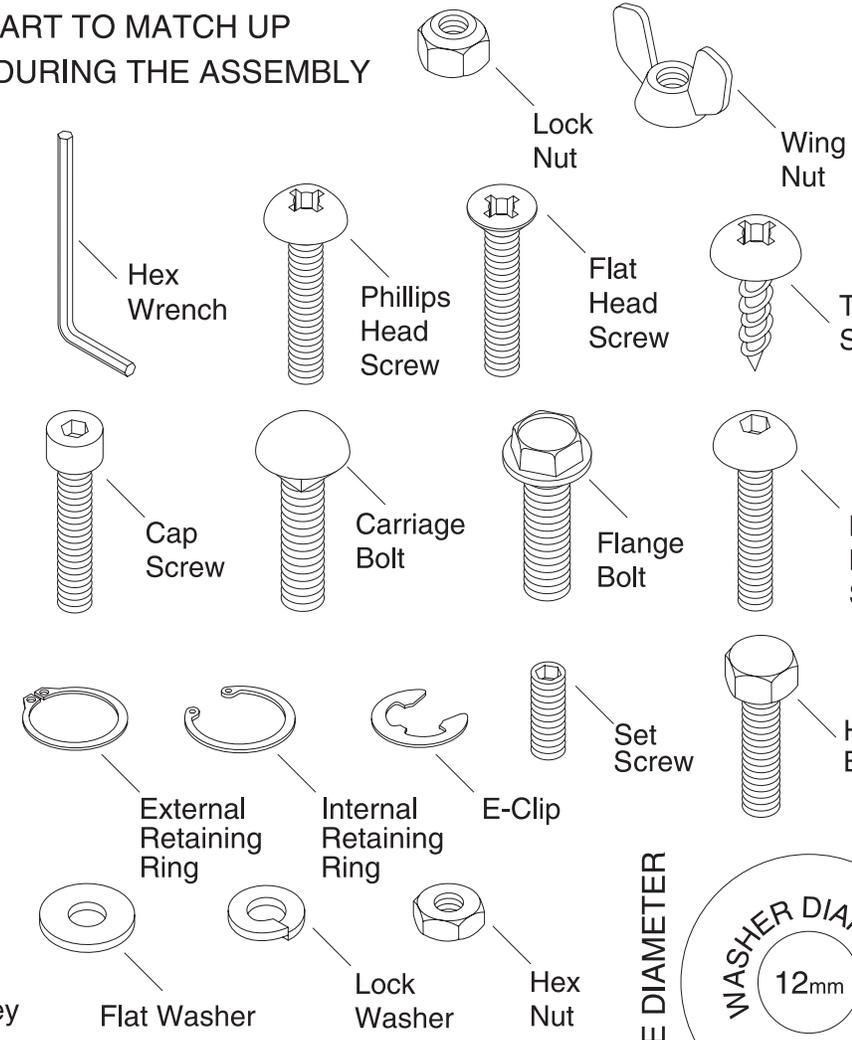
Hardware Recognition Chart

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

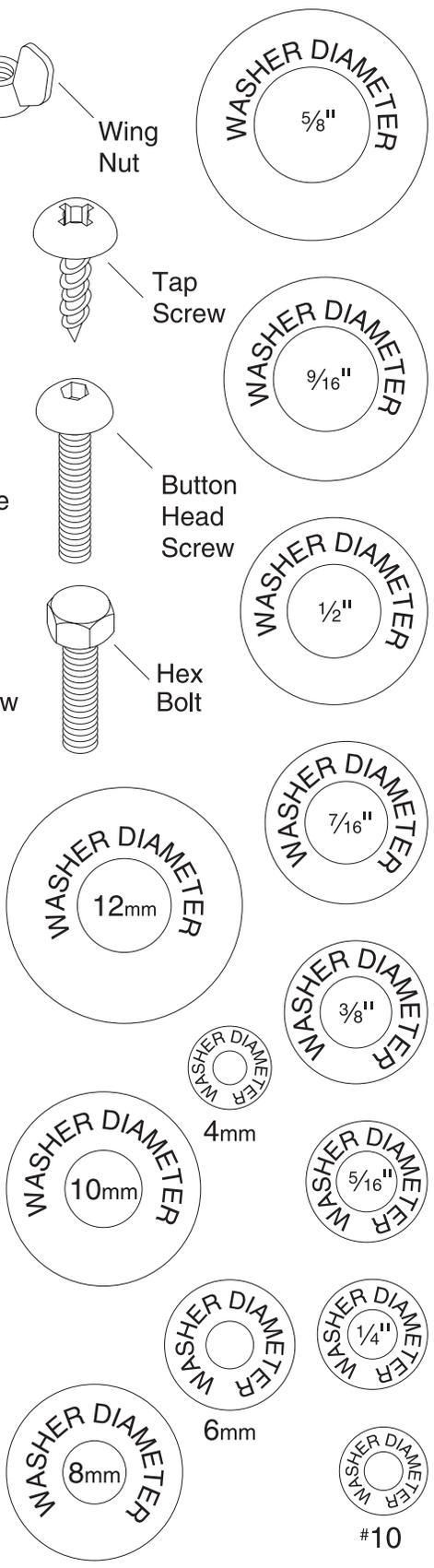
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"

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



WASHERS ARE MEASURED BY THE INSIDE DIAMETER



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.

<p>Call 1-800-523-4777 To Order</p>	
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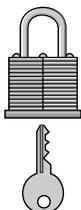
Site Considerations

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.**

	<p>CAUTION</p> <p>Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
---	--

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.

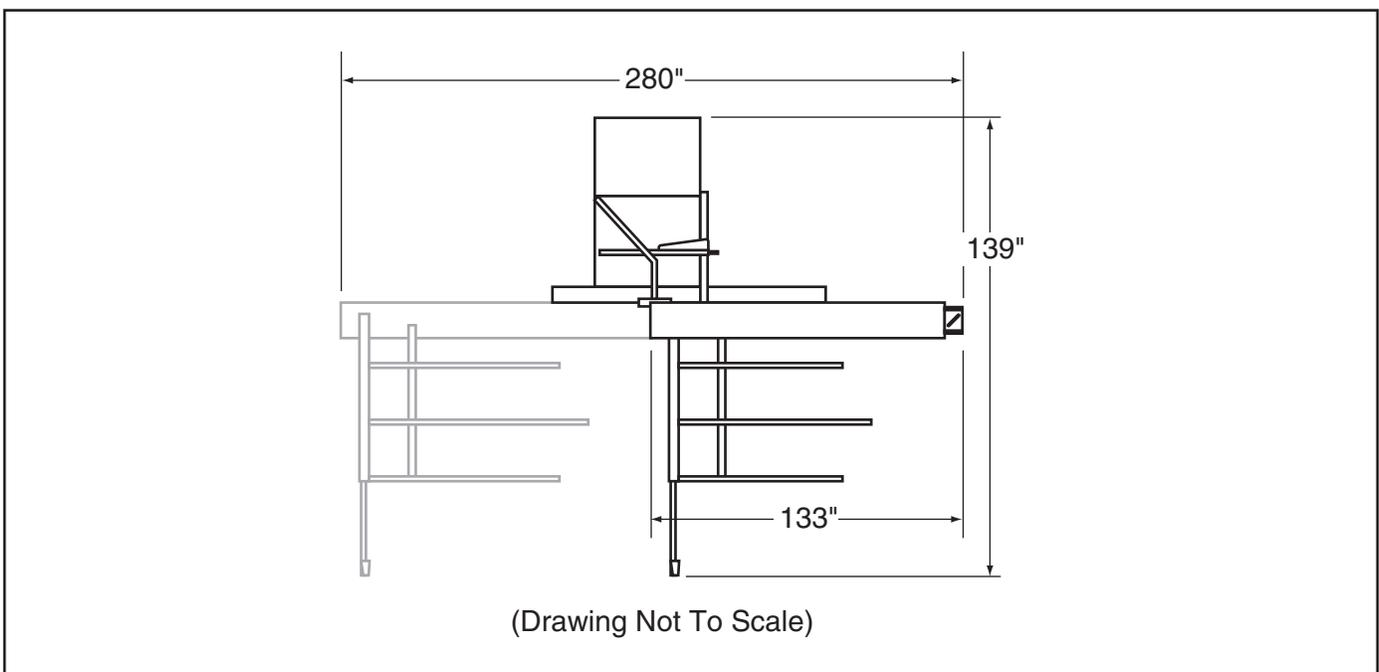
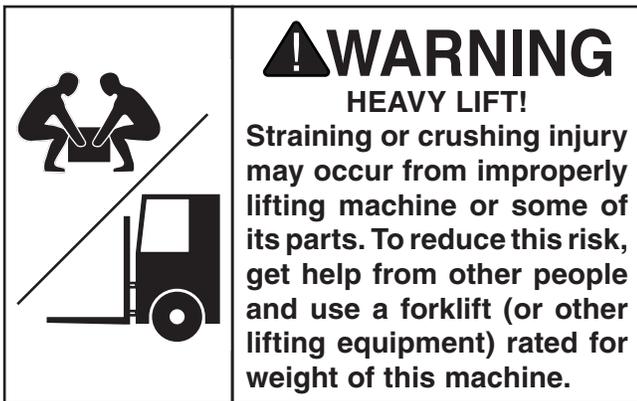


Figure 11. Minimum working clearances.



Lifting & Placing



To lift and move the machine:

1. After removing the shipping crate from the pallet, move the smaller components and boxes to a safe area.
2. Position the forklift forks completely under the cabinet, as illustrated in **Figure 12**.

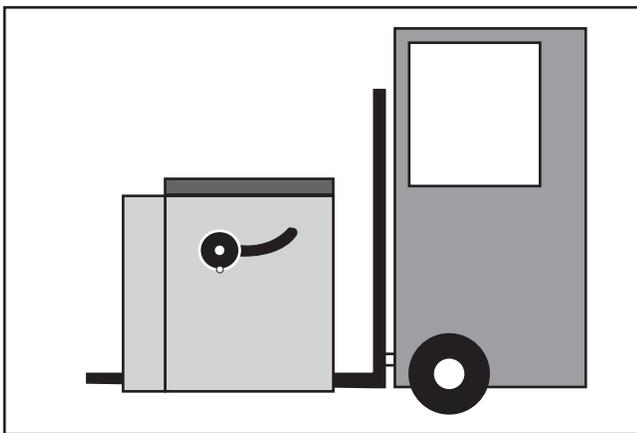
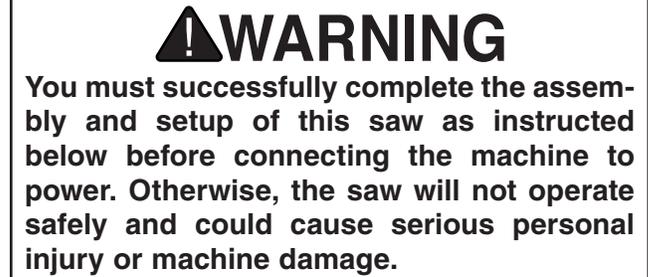


Figure 12. Example of lifting the table saw assembly.

3. With the help of additional people to steady the load, lift the machine enough to clear the pallet and any floor obstacles, then move it to its permanent location.

Assembly & Setup



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 the sliding table saw:

1. Use the elevation handwheel on the right side of the cabinet to raise the main blade arbor all the way up, then open the blade safety cover to expose the blade arbors, as shown in **Figure 13**.

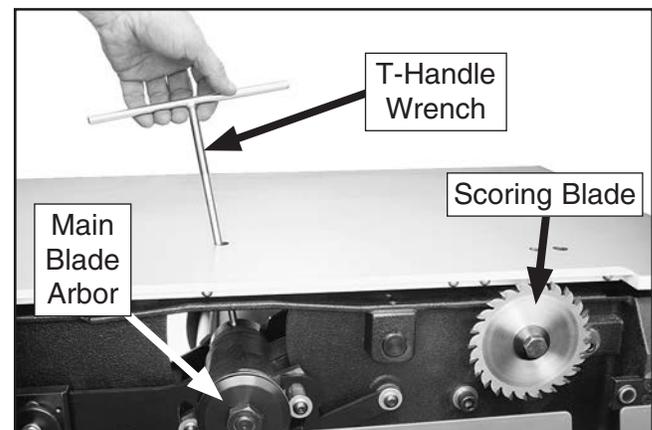


Figure 13. Blade arbors exposed.



2. Insert the provided T-handle wrench through the table top hole shown in **Figure 13** and into one of the holes in the main blade pulley under the table top. This will keep the blade arbor from rotating during the next step.
3. While holding the T-handle wrench with one hand, rotate the arbor nut clockwise to remove it and the flange (see **Figure 14**).

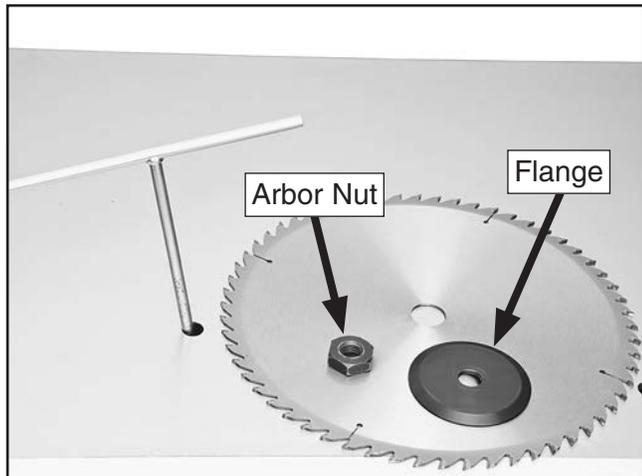


Figure 14. Main blade arbor nut and flange.

4. Slide the saw blade over the arbor with the teeth facing to the right, then re-install the flange and arbor nut while holding the arbor steady with the T-handle wrench, as shown in **Figure 15**.

The beveled edge of the flange must be facing out and the arbor nut must be fully tightened to safely secure the blade.



Figure 15. Installing main blade.

5. Install and align riving knife (refer to **Riving Knife Alignment** beginning on **Page 48** for detailed information).
6. To make sure the scoring blade arbor nut is fully tightened, hold the arbor wrench on the arbor behind the blade and use the wrench on the nut to tighten it clockwise, as shown in **Figure 16**.

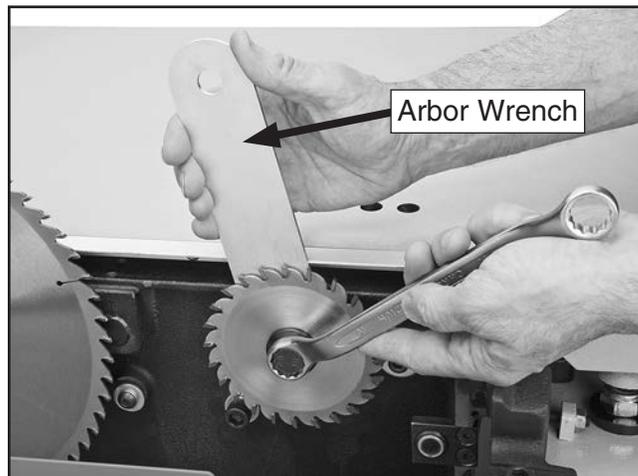


Figure 16. Tightening the scoring blade arbor nut.

7. Close the blade cover and lower the main blade all the way down so that it does not present a hazard during the following steps.

NOTICE

The sliding table is heavy, so you must get help lifting it during the installation process. We recommend two strong people lift the sliding table and an additional person help position the T-bolts into the mounting holes as the table is lowered.



8. Turn the sliding table assembly upside down, as shown in **Figure 17**.

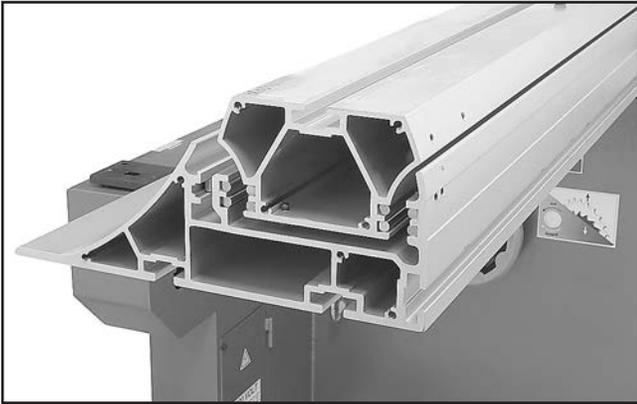


Figure 17. Sliding table saw upside down.

9. Remove the four cap screws threaded into the end of the sliding table assembly, the cap screw securing the lock handle, and the two cap screws pre-installed in the end handle (see **Figure 18**).

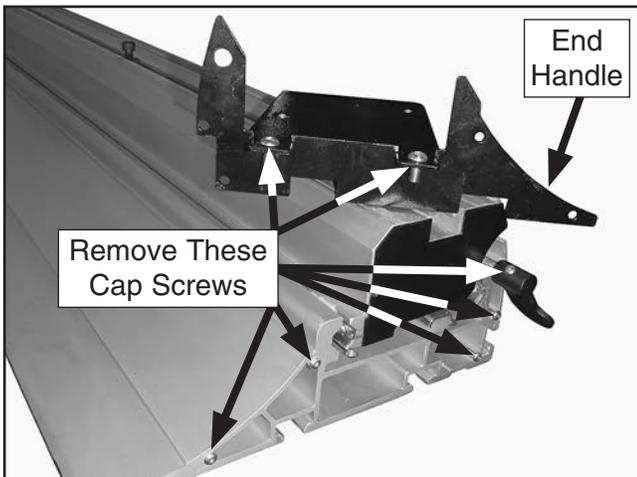


Figure 18. Cap screws to remove for end handle installation.

10. Attach the end handle to sliding table with the cap screws removed in **Step 9**. Slide the sliding table base out of the way to install the two larger cap screws shown in **Figure 19**.

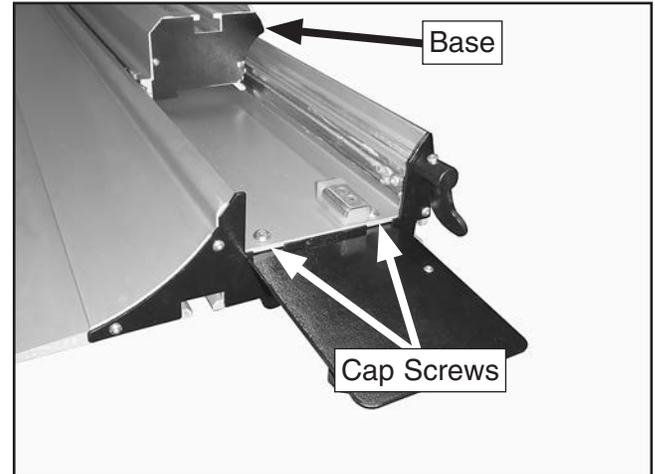


Figure 19. End handle installed.

11. Insert the (3) M12-1.75 x 60 T-bolts into the sliding table T-slot, as shown in **Figure 20**, and space them apart the same distance as the mounting holes in the frame top.

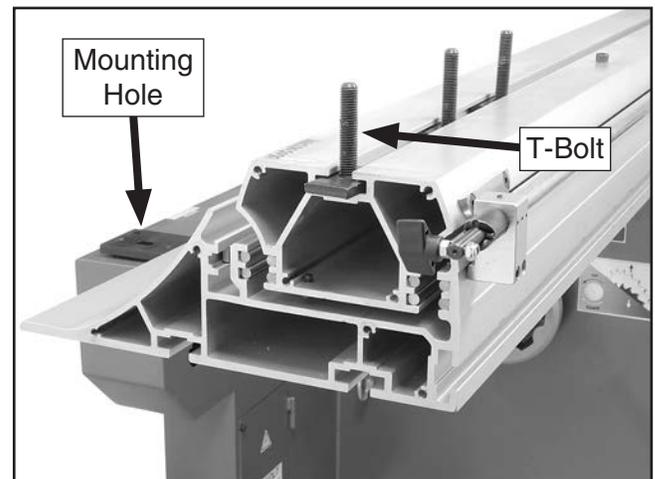


Figure 20. T-bolts inserted into the sliding table T-slot.



12. Have two people turn the sliding table assembly right side up, then have another person guide the T-bolts into the mounting holes as the sliding table is lowered onto the frame.

Important: As you align the sliding table parallel with the main saw blade in the next steps, the locating cap screw shown in **Figure 21** must remain against the right side of the frame before securing the sliding table in place. This will correctly position the sliding table with the rest of the machine.



Figure 21. Sliding table locating cap screw against the right side of the frame.

In the next steps, you will align the sliding table parallel with the table saw. This is necessary to ensure straight cutting operations and to prevent workpieces from binding and kicking back.

13. Move the sliding table all the way back.
14. Tilt the main saw blade to 0° and raise it all the way up.
15. Use the felt tip pen to mark the right blade edge that is even with the table.

16. Use the adjustable square and feeler gauges to measure the distance between the sliding table T-slot and the main saw blade at the mark you made in **Step 15**. This is distance "A" shown in **Figure 22**.

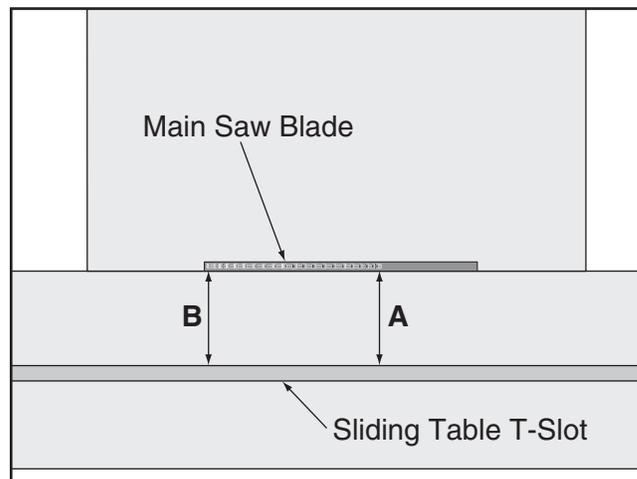


Figure 22. Measuring the distance between sliding table T-slot and main blade.

17. Move the sliding table all the way forward, rotate the saw blade so the mark you made in **Step 15** is at location "B", then take the measurement of "B".

—If the difference is equal to or less than 0.004" between the "A" and "B" measurements, the sliding table parallelism is acceptable. Continue with **Step 21**.

—If the difference between the "A" and "B" measurements is greater than 0.004", the sliding table parallel adjustment bolts need to be re-adjusted. Continue with the next step.



- Loosen the jam nuts on the sliding table parallel bolts (see **Figure 23**) that are on both sides of the cabinet behind the sliding table, then adjust the bolts in or out in small increments to change the sliding table parallelism to the saw blade.

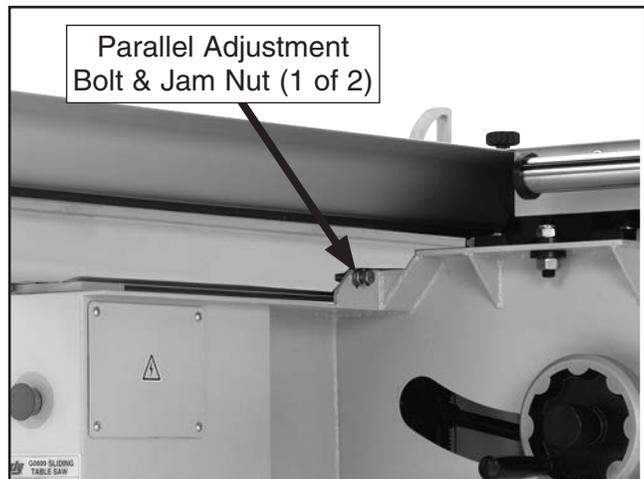


Figure 23. Sliding table parallel adjustment bolt (1 of 2).

- Make sure the sliding table is against the adjustment bolts, then repeat **Steps 16–17** until the difference between the "A" and "B" measurements is acceptable.
- Re-tighten the jam nuts.
- Remove the panels on both sides of the frame to gain access to the forward and rear sliding table T-bolts (see **Figure 24** for the location of the forward access T-bolt).



Figure 24. Location of the forward sliding table T-bolt from the rear of the frame.

- Locate the middle sliding table T-bolt through the 5" dust chute hole on the forward side of the cabinet, as shown in **Figure 25**.



Figure 25. Location of the middle sliding table T-bolt.

- Make sure the sliding table is against both parallel adjustment bolts and the locating cap screw shown in **Figure 21** on **Page 25**, then secure the sliding table with (3) M12-1.75 hex nuts, 12mm lock washers, and 12mm flat washers. Replace the forward and rear access panels.
- Install the sliding table push handle into the front T-slot with a 12mm flat washer, 12mm nylon flat washer, and a M12-1.75 T-nut, as shown in **Figure 26**.

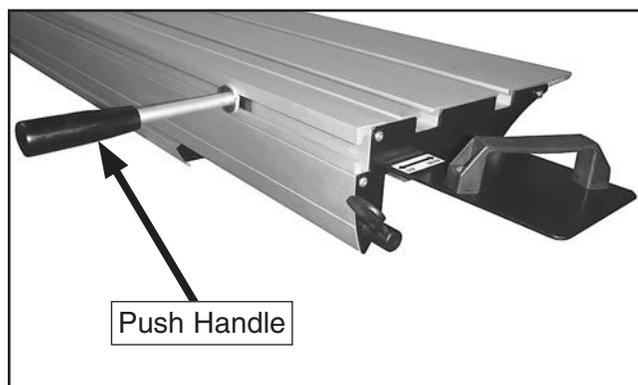


Figure 26. Sliding table push handle installed.



25. With the help of another person to hold the forward extension wing, attach it to the cast iron table with (2) M10-1.5 x 25 cap screws, 10mm lock washers, and 10mm flat washers, as shown in **Figure 27**.

Hand tighten the cap screws for now—they will be fully tightened in a later step.

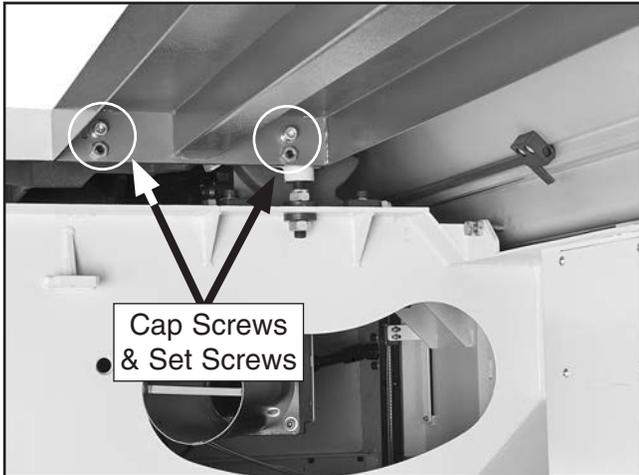


Figure 27. Forward extension wing attached (as viewed under the wing).

26. With the help of two other people to hold the rear extension wing, attach it to the cast iron table with (3) M10-1.5 x 25 cap screws, 10mm lock washers, and 10mm flat washers, as shown in **Figure 28**.

Hand tighten the cap screws for now—they will be fully tightened in a later step.

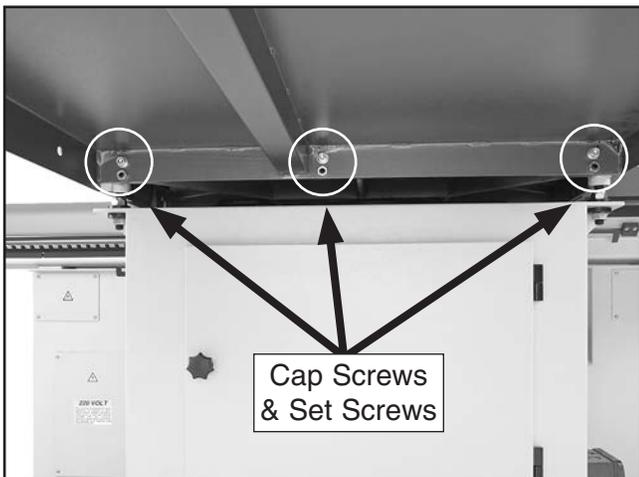


Figure 28. Rear extension wing attached.

27. Thread (5) M10-1.5 x 20 set screws into the threaded holes under each of the extension wing cap screws on both wings (see **Figures 27–28**).

Make sure the set screws do not stick out from the wing mating surface, which would interfere with the leveling process in the next step.

28. Place the straightedge across the cast iron table and an extension wing, then adjust the set screws in or out to make the top surface of the wings even with that of the cast iron table (see **Figure 29**).

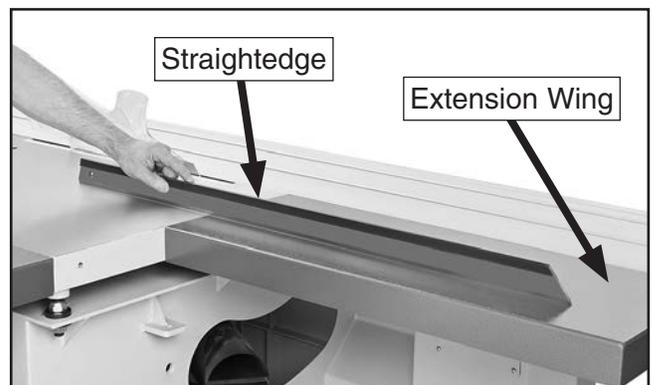


Figure 29. Using a straightedge to make sure the table/wing top surfaces are even.

29. When the top surfaces are even, thread (5) M10-1.5 hex nuts onto the set screws without changing their settings. Fully tighten the hex nuts to secure the set screws in place.
30. Fully tighten the extension wing cap screws, then re-check to make sure the top surfaces remain even.

—If the top surfaces did not remain even after tightening the cap screws, loosen them, then repeat **Steps 28–30** until they remain even.



31. Attach the rip fence scale to the rear side of the cast iron table and rear extension wing with (3) M6-1 x 12 button head cap screws and 6mm flat washers, as shown in **Figure 30**.

Hand-tighten the cap screws for now—they will be fully tightened in a later step.



Figure 30. Rip fence scale attached.

32. Remove one hex nut, lock washer, and flat washer from each of the fence rail mounting studs.
33. Install the rip fence rail by inserting the studs into the provided holes in the cast iron table and rear extension wing, as shown in **Figure 31**, then secure them with the hex nuts, lock washers, and flat washers removed in **Step 32**.

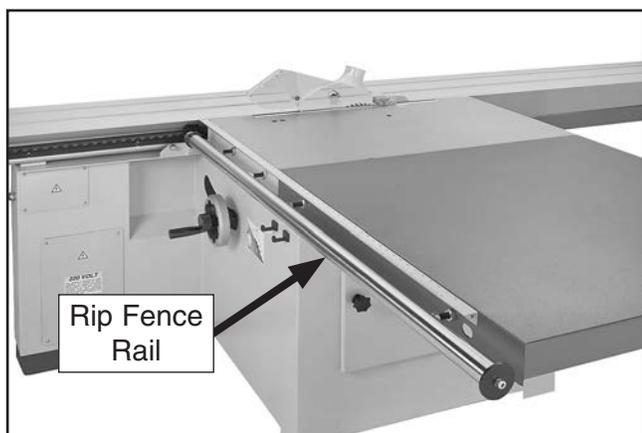


Figure 31. Rip fence rail installed.

34. Slide the rip fence body assembly onto the rip fence rail, then install the two handles and one knob, as shown in **Figure 32**.

You may have to adjust the rip fence rail hex nuts on both sides so that the fence body does not rub against the sides of the table and extension wing.

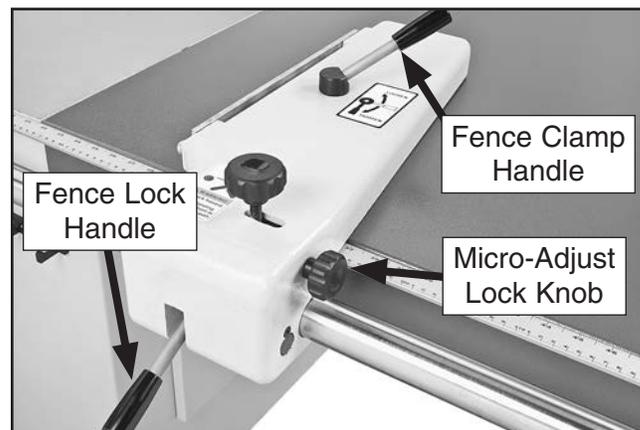


Figure 32. Rip fence body assembly installed.

⚠ WARNING

The rip fence stop screws keep the fence from moving forward and slipping off the fence body, which could draw your hands and arms into the spinning blade during operation. Always keep these stop screws properly installed.

35. Remove the rip fence stop screw from the tall side of the rip fence (see **Figure 33**).

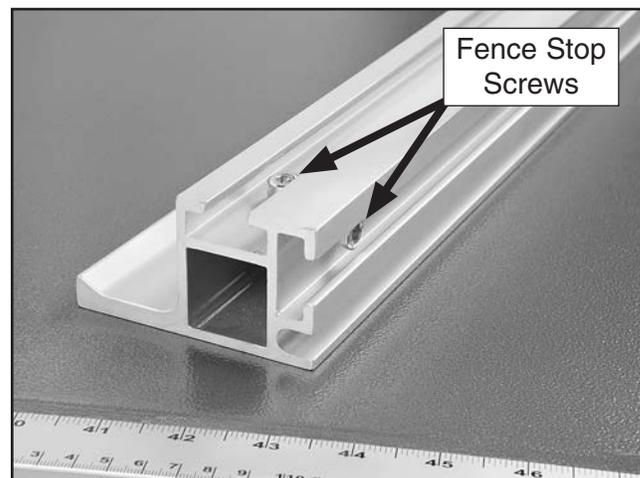


Figure 33. Rip fence stop screws.



36. Loosen the fence clamp handle (see **Figure 34**), then slide the fence onto the T-slot plates and the clamp plate so that the tall side of the fence is facing the blade.

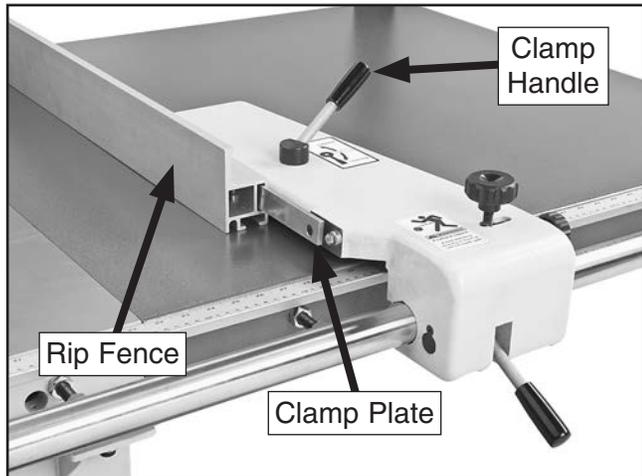


Figure 34. Installing the rip fence.

37. Slide the rip fence toward you, re-install the stop screw that you removed in **Step 35**, move the fence forward until it stops, then tighten the fence clamp handle.
38. Insert the T-handle wrench into the left-hand hole of the two shown in **Figure 35**, engage it with the scoring blade elevation bolt under the table top, and rotate it counterclockwise to lower the scoring blade below the table surface.

Note: This will keep the scoring blade from interfering with the rip fence alignment process in the next steps.

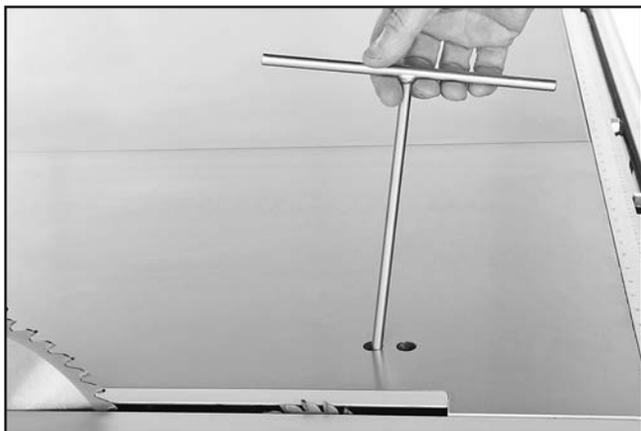


Figure 35. Lowering the scoring blade.

39. Raise the main saw blade all the way up, then slide the rip fence against it without pushing on it, as shown in **Figure 36**.

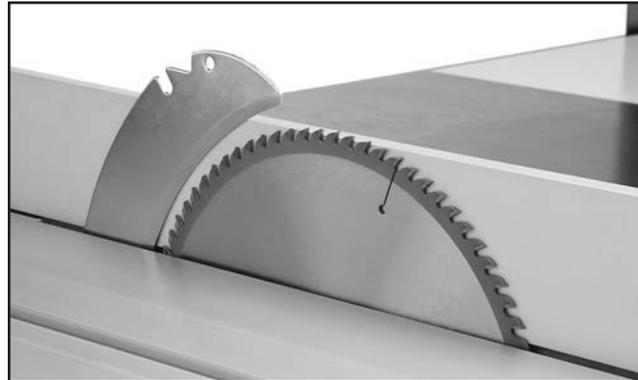


Figure 36. Rip fence against the saw blade.

40. Loosen the fence rail hex nuts on both sides and adjust the rail in or out until the rip fence is even with the saw blade along its full length, then hand-tighten the hex nuts again.

NOTICE

The rip fence body will scratch the table and rear extension wing surfaces if the ride height is not adjusted correctly.

Note: The goal of the adjustments in the next step is to make the rip fence body ride height as close to and even with the table and extension wing surfaces without touching or scratching them.



41. Check if the any part of the metal rip fence body rests on the surface of the table.

—If the forward end of the fence body rests on the table, lift the fence up so that you can access the roller and acorn nut shown in **Figure 37**. Loosen the acorn nut, adjust the roller until it extends slightly beyond the body, then re-tighten the acorn nut.

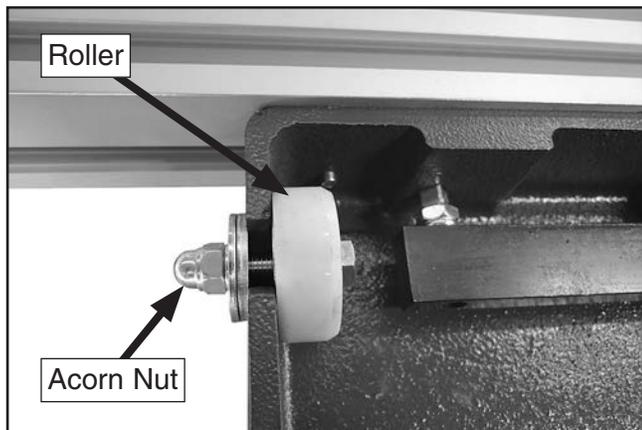


Figure 37. Rip fence body roller controls.

—If the rear end of the fence body rests on the table, adjust the height of the fence rail.

42. If you have not already fully tightened the outer fence rail hex nuts in a previous step, do so now.
43. Make sure the rip fence is still even with the saw blade and the ride height is still correct. If necessary, repeat previous steps to make the rip fence position correct.

44. Move the rip fence up against the saw blade, then position the rip fence scale so that the zero mark is even with face of the rip fence, as shown in **Figure 38**.

Make sure the scale is even with the top surfaces of the table and extension wing, then fully tighten the cap screws that secure the scale in place.

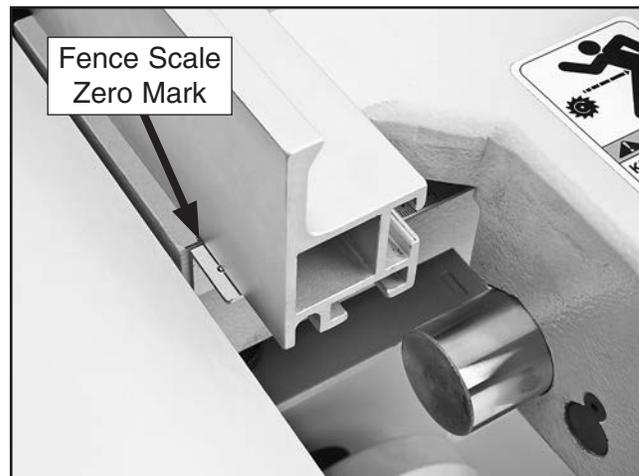


Figure 38. Rip fence scale zero mark even with the rip fence face.

⚠ WARNING

When properly positioned, the rail stop ring prevents the rip fence from contacting the saw blade. If this happens during cutting operations, flying metal debris could cause serious personal injury. Always make sure the rail stop ring is secured in the proper position before beginning operations.



45. Back the rip fence away from the saw blade at least $\frac{1}{8}$ ", then slide the fence rail stop ring onto the rail and secure it against the fence body by tightening the pre-installed set screw, as shown in **Figure 39**.

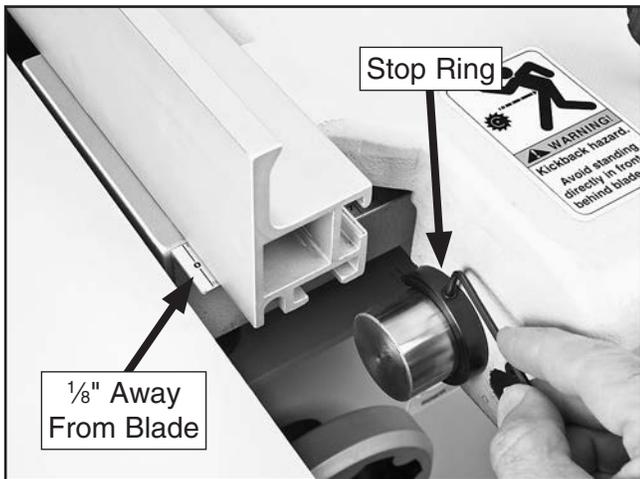


Figure 39. Installing the rip fence stop ring.

46. Attach the flat end cap to the other end of the rail with the M8-1.25 x 16 cap screw and 8mm lock washer, as shown in **Figure 40**.

Note: The purpose of the end cap is to prevent the rip fence assembly from slipping off the end of the rail.

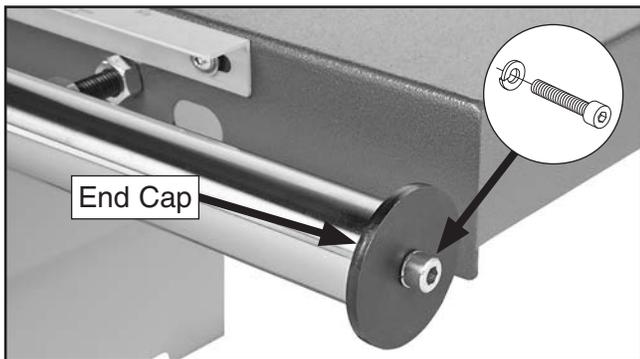


Figure 40. Rip fence rail end cap attached.

The scoring blade has wedge-shaped teeth so that the higher the blade is raised, the wider the scoring kerf will be.

The goal in the next step is to adjust the scoring blade vertical and horizontal positions so that the scoring kerf is the same width as the main saw blade kerf. This procedure requires placing the straightedge on both sides of the blades multiple times as you make adjustments.

47. When positioning the straightedge, place it against teeth at both ends of the main saw blade to obtain an accurate reading of the main saw blade kerf.

—*Horizontal Adjustment:* Insert the T-handle wrench into the right hole shown in **Figure 41**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

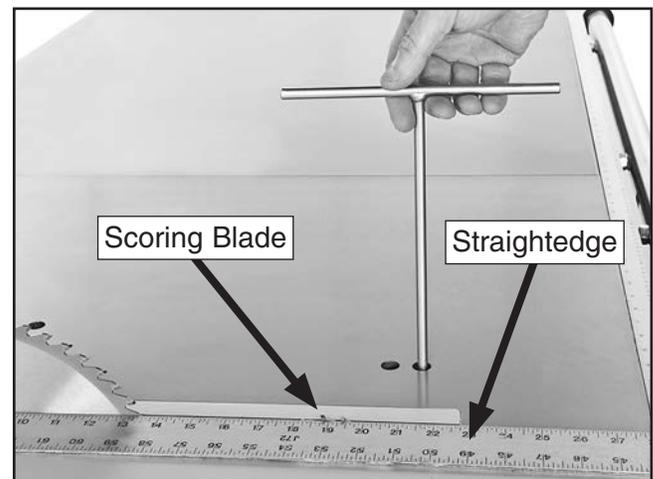


Figure 41. Adjusting the horizontal position of the scoring blade.



—*Vertical Adjustment:* Insert the T-handle wrench into the left hole shown in **Figure 42**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

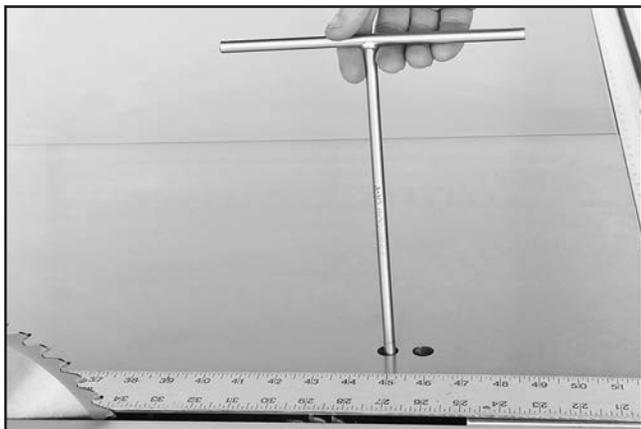


Figure 42. Adjusting the vertical height of the scoring blade.

48. Insert the M12-1.75 x 55 lock handle with a 12mm flat washer through the middle hole of the crosscut table, as shown in **Figure 43**, then loosely thread it into the T-nut plate.

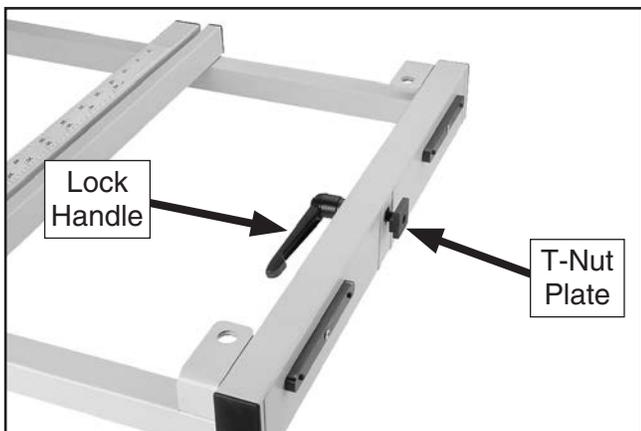


Figure 43. Crosscut lock handle installed.

49. With the help of another person, place the crosscut table on the swing arm pivot pin, as shown in **Figure 44**, then slide the T-plate into the sliding table T-slot.

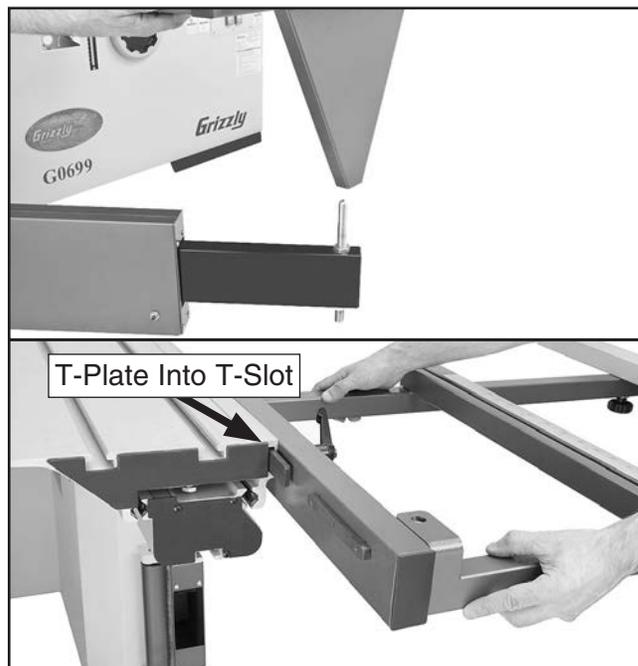


Figure 44. Installing the crosscut table into the sliding table.

50. Position the crosscut table approximately in the middle of the sliding table, then tighten the lock handle to secure it in place.

51. Slide (2) M8-1.25 T-nuts into the crosscut table brace, align the T-nuts with the holes in the crosscut table, then secure the brace with (2) M8-1.25 x 50 knobs and 8mm fender washers, as shown in **Figure 45**.

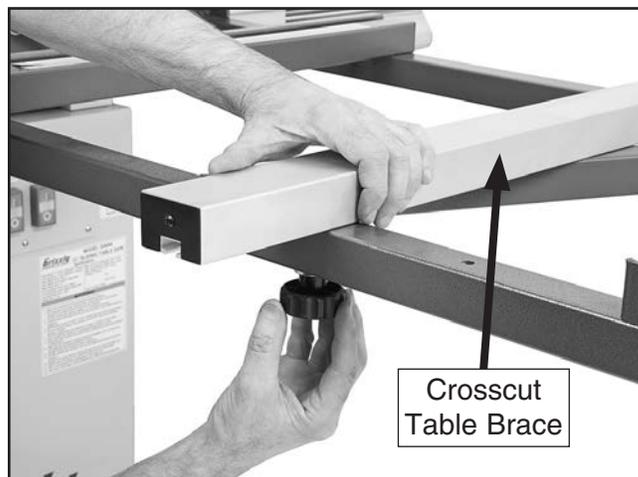


Figure 45. Installing the crosscut table brace.



52. To install the bottom T-slot components of the crosscut fence, lay the fence across the left side of the crosscut table with the polyurethane end block facing the main blade, then do the following:

- a) Insert and align an M8-1.25 T-nut with the hole in the slot that is farthest from the saw blade, then thread (1) M8-1.25 x 25 knob with the nylon end through the T-nut and into the fence hole, as shown in **Figure 46**. This will secure the fence extension in place when fully tightened.

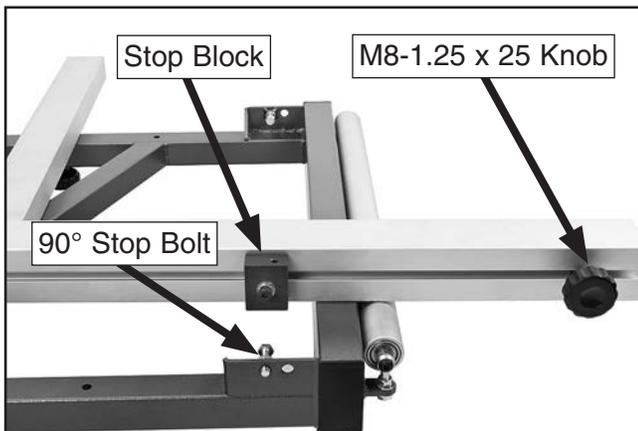


Figure 46. Front end crosscut T-slot components.

- b) Align an M8-1.25 T-nut with the 90° stop bolt shown in **Figure 46**, insert (1) M8-1.25 x 35 cap screw with a 8mm lock washer through the stop block, then thread the cap screw into the T-nut.
- c) Align the M8-1.25 x 60 T-bolt with the placement position shown in **Figure 47**.

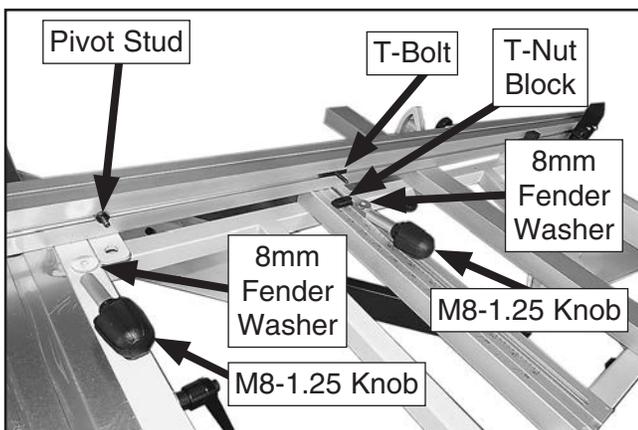


Figure 47. Back end crosscut T-slot components.

- d) Align (1) M8-1.25 T-nut with the pivot stud placement position, then hand-tighten the M8-1.25 x 10 pivot stud with the 8mm fiber flat washer into the T-nut, as shown in **Figure 47**.

53. Turn the crosscut fence over, insert the pivot stud in its placement hole (see **Figure 47**), then slide the fence up to the main saw blade so that polyurethane end block is against the blade.

54. Using the precision ruler against a tooth of the blade, adjust the fence so that the 2" mark on the fence scale is exactly 2" from a blade tooth, as shown in **Figure 48**.

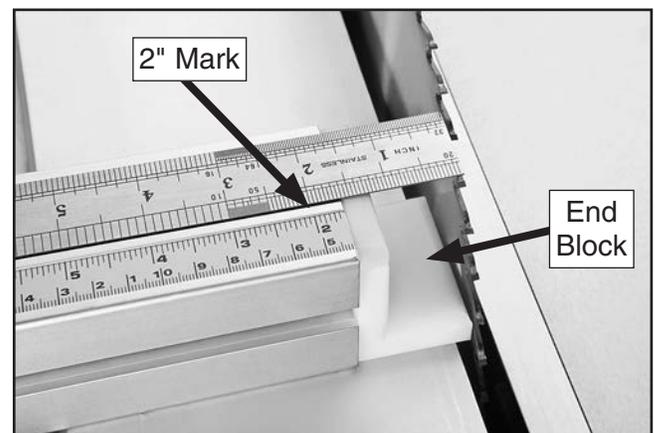


Figure 48. Setting the correct space between the crosscut fence and blade.

55. Carefully lift the crosscut fence up, fully tighten the pivot stud, then re-insert the stud into the hole. Re-check the distance between the scale and blade—if necessary, loosen the stud and repeat **Steps 54–55** until the distance is correct.



56. Slide the crosscut fence against the 90° stop bolt, then secure it in place by tightening the M8-1.25 knob with the T-Nut block and 8mm fender washer on the T-bolt (see **Figure 47** on **Page 33** and **Figure 49** below). Tighten M8-1.25 knob with 8mm fender washer onto pivot stud.

Note: Adjusting the crosscut fence in different positions will be discussed in the **Operations** section later in this manual.

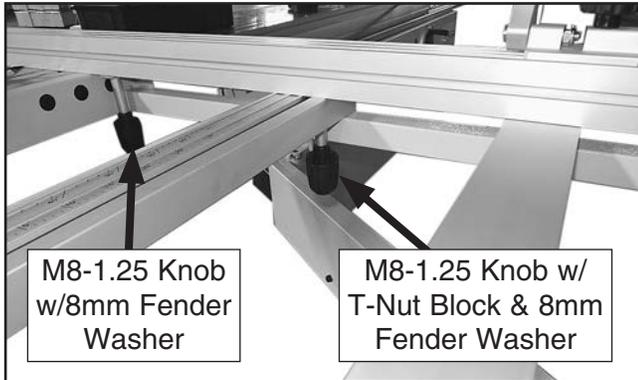


Figure 49. Crosscut fence secured.

57. Move the crosscut extension fence out so that you can install the flip stop assemblies, as shown in **Figure 50**.

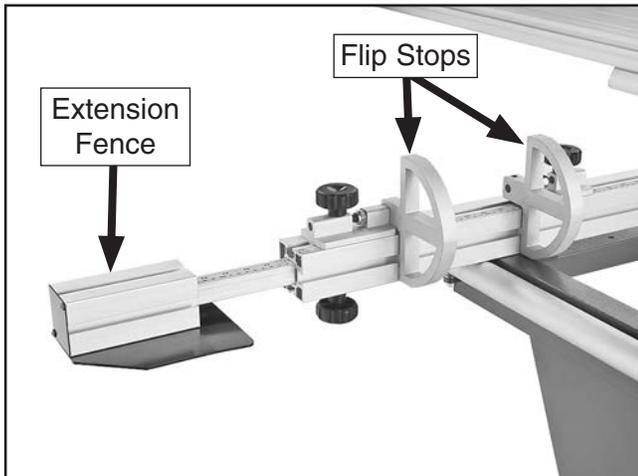


Figure 50. Crosscut flip stops installed.

58. Thread (1) M12-1.75 x 70 arm-leveling bolt with M12-1.75 jam nut into bracket connected to rear of machine body, as shown in **Figure 51**.

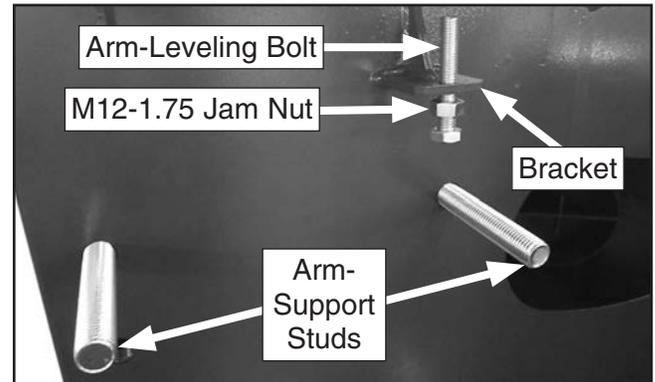


Figure 51. Arm-support studs installed in body and arm-leveling bolt installed in bracket.

59. Remove hex nuts from pre-installed arm-support studs (see **Figure 51**), and install support-arm base onto arm-support studs, as shown in **Figure 52**.

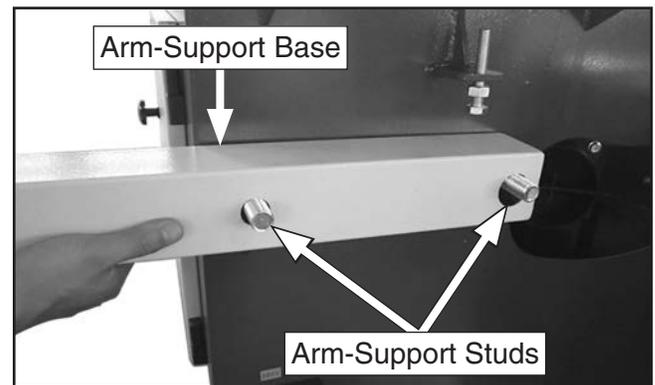


Figure 52. Installing arm-support base.

60. Adjust arm-leveling bolt until arm support base is parallel with floor (see **Figure 53** on **Page 35**).

Tip: Check this position by using a tape to measure the distance between each end of the arm-support base and the floor.

Note: This parallel position helps ensure the blade guard is parallel with the table once it is installed. For now, this positioning should be very close. It will be checked, and if necessary, fine-tuned in a later step.



- 61. Tighten jam nut against bracket (see **Figure 53**) to secure arm-leveling bolt.
- 62. Secure arm-support base with (2) M20-2.5 hex nuts and (2) 20mm fender washers (see **Figure 53**).

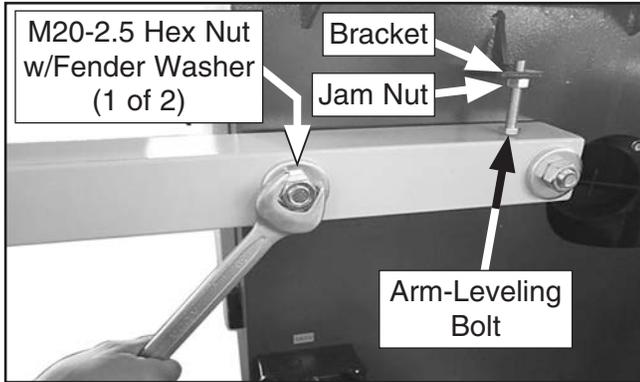


Figure 53. Securing arm-support base.

- 63. Install arm-support pedestal on arm-support base, using (4) M8-1.25 x 25 cap screws, (4) 8mm lock washers, and (4) 8mm flat washers (see **Figure 54**).

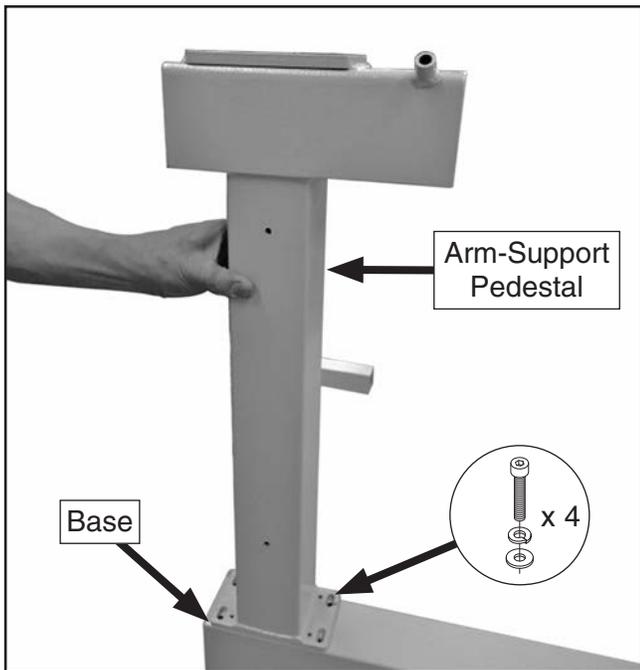


Figure 54. Installing arm-support pedestal.

- 64. Insert upper support arm into top of arm-support pedestal, as shown in **Figure 55**.
- 65. Install (1) M10-1.5 x 30 hex bolt into location shown in **Figure 55**. Do not tighten yet.

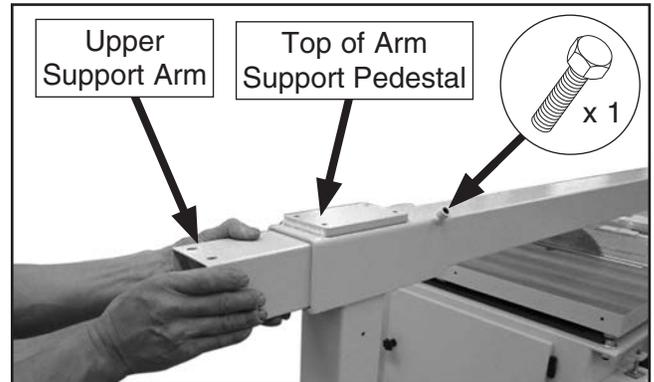


Figure 55. Installing upper support-arm.

- 66. Install 4" dust port adapter on upper support arm, using (2) M6-1 x 12 button head cap screws, (2) 6mm lock washers, and (2) 6mm flat washers (see **Figure 56**).

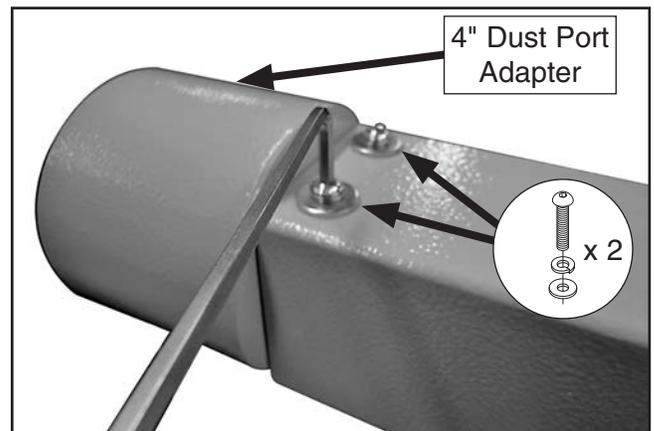


Figure 56. Installing 4" dust port adapter.



67. Attach connection plate assembly with return spring to blade guard using (2) M6-1 lock nuts (see **Figure 57**).

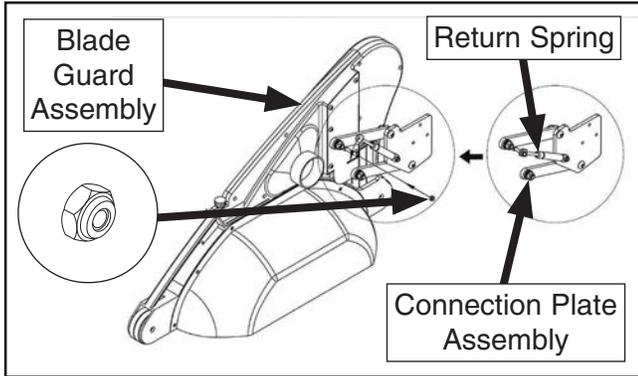


Figure 57. Installing blade guard connection plate assembly onto blade guard assembly.

68. Attach connection plate assembly to end of upper support arm, using (3) M6-1 x 20 cap screws, (3) 6mm lock washers, and (3) 6mm flat washers (see **Figure 58**).

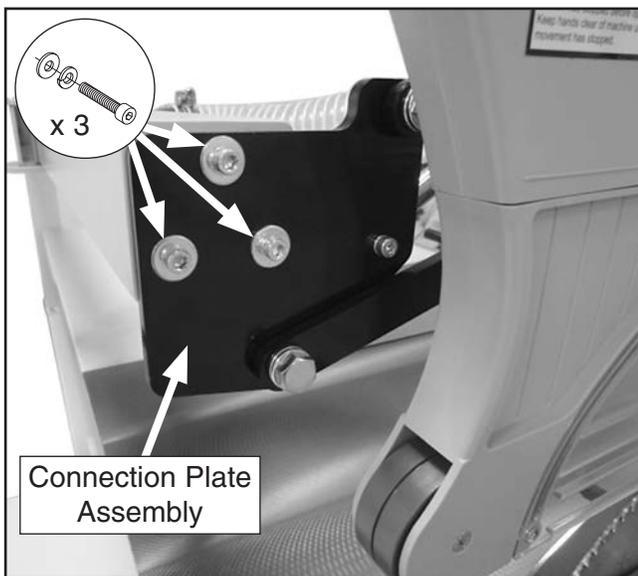


Figure 58. Connection plate assembly attached to upper support arm.

69. Slide upper support arm until at least one blade guard roller is centered over blade (see **Figure 59**), then tighten hex bolt from **Step 65** on **Page 35** to secure upper support arm.

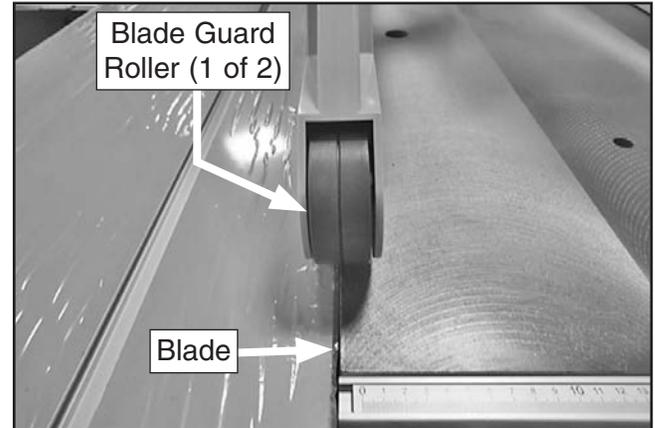


Figure 59. Blade guard rollers centered over blade.

70. Ensure front and rear blade guard rollers are parallel with blade (see **Figure 59**).

—If rollers *are* parallel with blade, proceed to **Step 62**.

—If rollers *are not* parallel with blade, loosen cap screws shown in **Figure 60**, adjust arm-support pedestal until rollers are parallel with blade, then re-tighten cap screws to secure. Check to make sure both blade rollers are centered over blade, and if necessary, loosen hex bolt from **Step 65** on **Page 35**, slide upper support arm until rollers are centered over blade, then re-tighten hex bolt to secure.

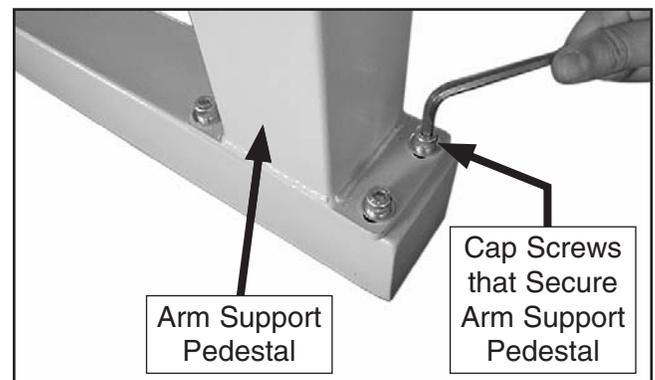


Figure 60. Adjusting alignment of arm-support pedestal.



71. Make sure rollers are parallel with table. If necessary, loosen M20-2.5 hex nuts from **Step 62**, repeat **Steps 60–61** until rollers are parallel with table, then re-tighten hex nuts.
72. Attach dust port to upper support arm, using (2) M6-1 x 12 button head cap screws and (2) 6mm lock washers (see **Figure 61**).

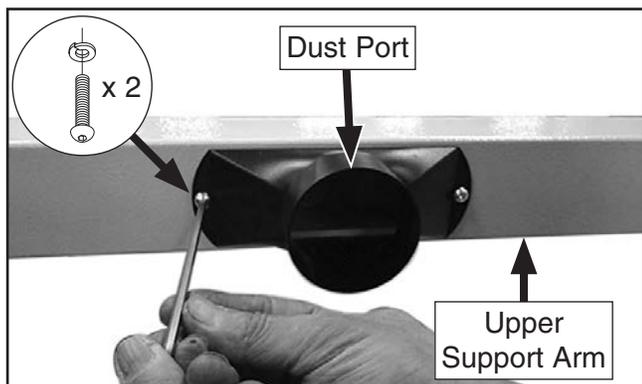


Figure 61. Installing dust port on upper support-arm.

73. Attach dust hose to blade guard and upper support arm dust ports, and secure with hose clamps (see **Figure 62**).

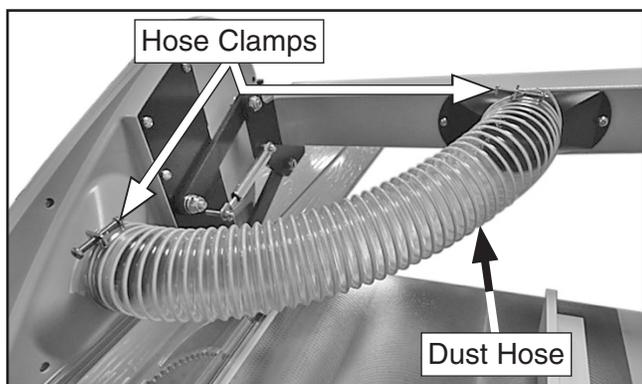


Figure 62. Dust hose attached to blade guard and upper support arm.

74. Tug hose to make sure it is secure. If it pulls off easily, re-install it and tighten hose clamps until it is secure.

Changing Blade Guard For Angled Cuts

The Model G0699 blade guard comes with two assemblies—a "flat" insert for 90° cuts, and a "bubble" insert for angled cuts. To switch between these two inserts, remove the lock knob shown in **Figure 63**, slide the insert out and replace it with the appropriate insert, then re-install the lock knob to secure the insert.

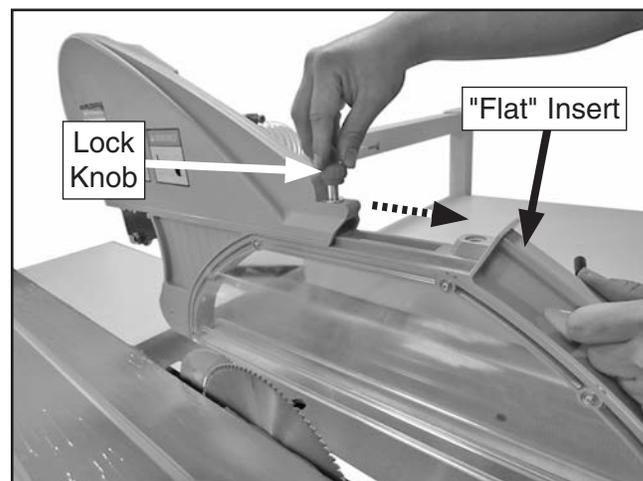


Figure 63. Removing blade guard insert.



Dust Collection

⚠ CAUTION

DO NOT operate the Model G0699 without an adequate dust collection system. This saw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Required CFM at 5" Dust Port: 615 CFM
Required CFM at 4" Dust Port: 400 CFM
Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect the saw to dust collection system:

1. Secure a 5" dust hose to the port located under the table on the left side with a hose clamp, as shown in **Figure 64**.

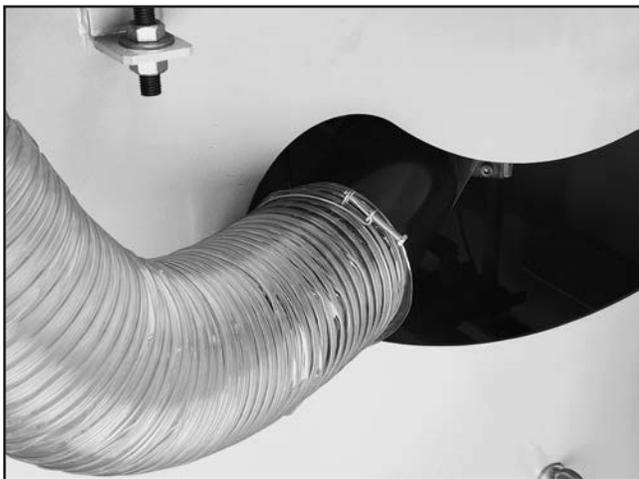


Figure 64. 5" dust port location.

2. Connect 4" dust hose to end of horizontal arm, then attach it to a single dust collection branch line.

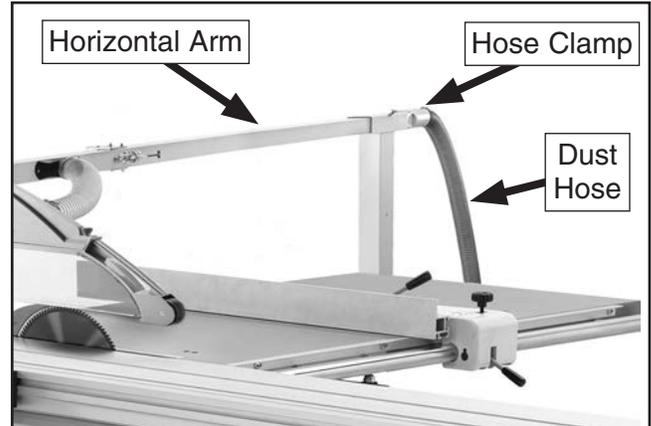


Figure 65. Example of dust hose attached to blade guard.

3. Tug on dust hoses to make sure they do not come off. A tight fit is necessary for proper performance.



Power Connection

Before the machine can be connected to the power source, an electrical circuit must be made available that meets the minimum specifications given in the **Circuit Requirements** subsection on **Page 12**. If a power circuit has not been prepared for the machine, do that now. To ensure a safe and code-compliant setup, we strongly recommend that all electrical work be done by a qualified electrician.

NOTICE

The Model G0699 is prewired for 220V. If you plan to operate the machine at 440V, the two overload relays on the electrical panel must be replaced and the motors must be rewired (refer to *440V Conversion* on *Page 14* for detailed instructions).

To connect the saw to the power source:

1. Open the power connection junction box shown in **Figure 66**.

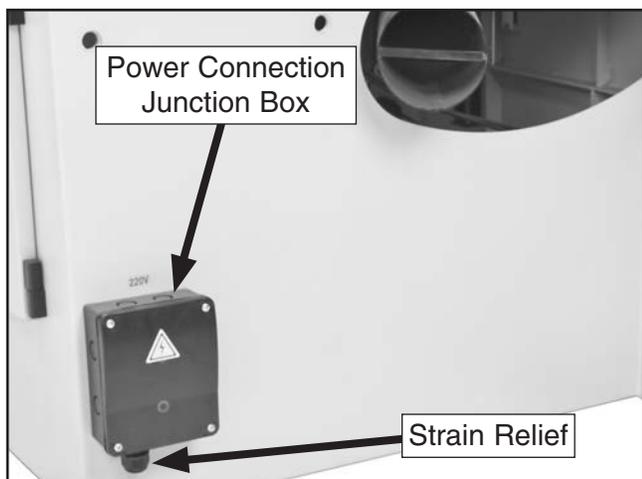


Figure 66. Location of power connection junction box.

2. Feed the incoming power cord through the strain relief at the bottom of the junction box (see **Figure 66**).

3. Make sure there is enough power cord inside the junction box to make the connections with the same amount of slack as the wires connected on top of the terminal bar, then tighten the strain relief around the cord.
4. Tug on the cord with moderate force to make sure it does not move.

—If the power cord comes loose when you tug on it, re-position it and re-tighten the strain relief. If the strain relief does not adequately secure the cord, then replace it with one that is correctly sized for the cord.

In the next step, connect the incoming hot wires to the three left terminals and the ground wire to the right-most terminal, as shown in **Figure 67**.

5. Loosen the terminal screw, insert the wires between the terminal plates, then fully tighten the terminal screw. Tug on the wires to make sure that they are secure.

—If a wire comes loose when you tug on it, repeat this step. If you continue to have difficulty connecting the wires securely, consider using clamp-on ring or spade terminals on the ends of the wires.

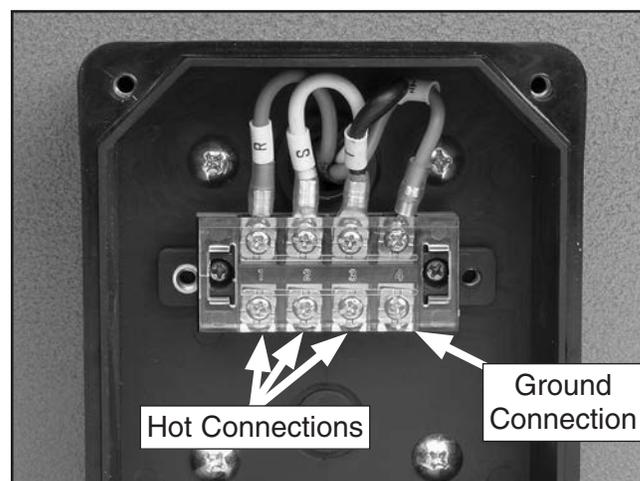


Figure 67. Incoming power connections.

6. Re-install the junction box lid before continuing with the test run.



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, 2) the safety features of the Emergency Stop button and blade cover switch work correctly, and 3) the main blade turns forward (clockwise when viewed from front of saw) and the scoring blade turns opposite the main blade.

!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 you understand the safety instructions at the beginning of the manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Review the power controls shown in **Figure 68**.

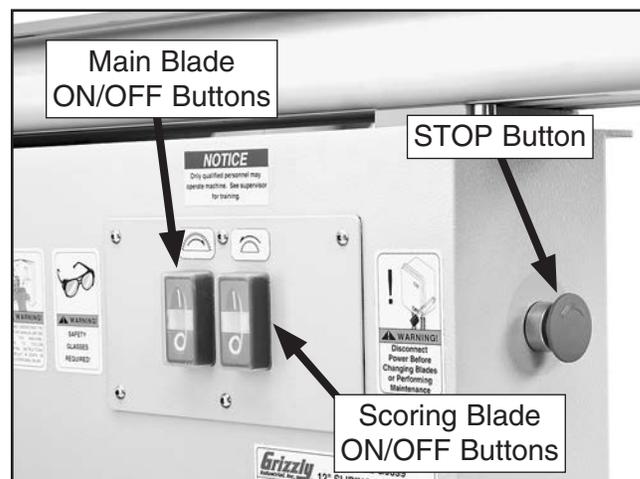


Figure 68. Power controls.

4. Push the STOP button in, then twist it clockwise so it pops out. When the STOP button pops out, the switch is reset and ready for operation (see **Figure 69**).

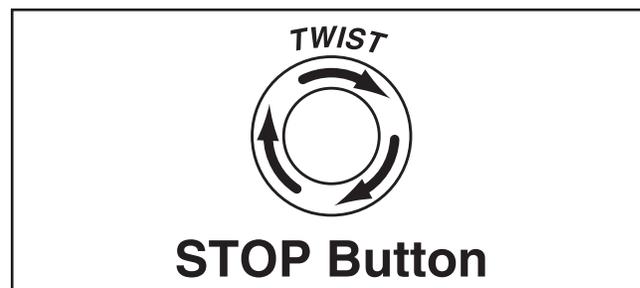


Figure 69. Resetting the STOP button.

5. Verify that the machine is operating correctly by pushing the main and scoring blade ON buttons.
 - 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 stop the machine and disconnect it from power before investigating or correcting potential problems.
6. Press the STOP button to stop the machine.



7. WITHOUT resetting the STOP button, press the main blade ON button. The machine should not start.

—If the machine does not start, the STOP button safety feature is working correctly.

—If the machine does start (with the STOP button pushed in), turn the main blade motor **OFF** and immediately disconnect the power. The STOP button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

8. Reset the STOP button.

9. Verify that the power is not connected out-of-phase by starting/stopping the main blade and determining if the motor and blade turn in the correct direction, using the criteria below:

—If the main blade turns clockwise (when standing in front of the machine), it is turning in the correct direction (see **Figure 70**).

—If the main blade turns counterclockwise, it is turning in the wrong direction. Stop the machine, disconnect it from the power source, then refer to **Correcting Phase Polarity** on **Page 15** to correct this condition.

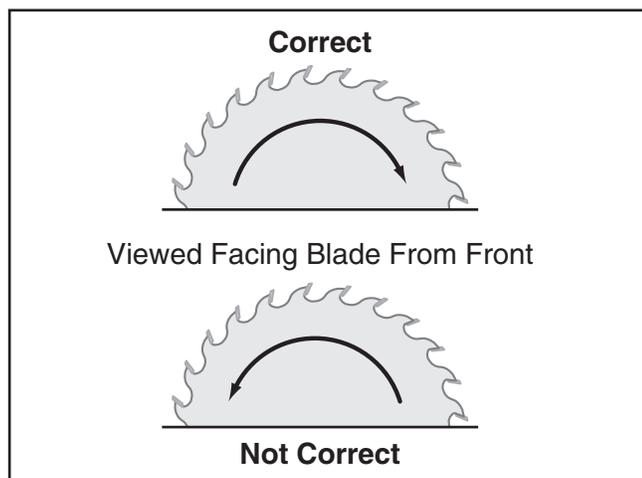


Figure 70. Correct and incorrect rotation directions for the main blade.

10. Push the STOP button, move the sliding table all the way to the left, then carefully open the red blade cover, as shown in **Figure 71**. This activates the blade cover safety switch to prevent the saw from starting while the cover is open.

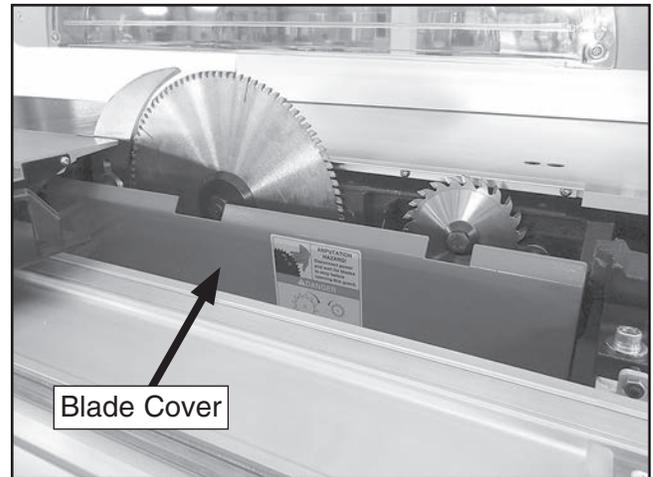


Figure 71. Blade cover open.

11. While staying safely away from the blade, reset the STOP button, then attempt to start the scoring blade.

—If the machine does not start, the blade cover safety switch safety feature is working correctly.

—If the machine does start (with the blade cover open), immediately turn the machine **OFF** and disconnect the power. The blade cover safety switch safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

12. Push the STOP button, carefully close the blade cover, then move the sliding table back to the center of the machine.

Congratulations! You have completed the assembly, setup, and test run of the saw. Continue with the recommended adjustments in the next section.



Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory.

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

Step-by-step instructions for these adjustments can be found on the referenced page for each item.

Factory adjustments that should be verified:

- Riving knife alignment (**Page 48**)
- Blade tilt calibration (**Page 73**)
- Sliding table parallelism to blade (**Page 74**)
- Crosscut fence 90° to blade (**Page 76**)

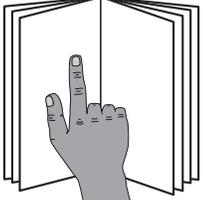


SECTION 4: OPERATIONS

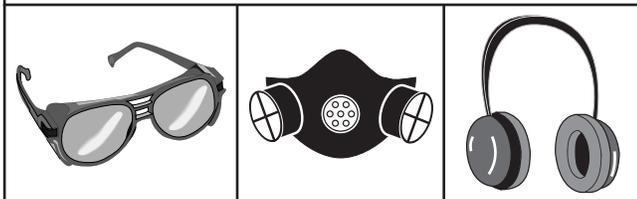
Operation Overview

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.

	<p>!WARNING To reduce your risk of serious injury, read this entire manual BEFORE using machine.</p>
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<p>!WARNING Damage to your eyes, lungs, and hearing could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.</p>		
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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 blade height approximately ¼" higher than thickness of workpiece.
4. Adjusts fence to desired width of cut, then locks it in place.
5. Adjusts blade guard for workpiece height.
6. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through the blade without interference.
7. Puts on safety glasses, respirator, and hearing protection. Locates push sticks, if needed.
8. Feeds workpiece all the way through blade while maintaining firm pressure on workpiece against table and fence.
9. Turns machine **OFF** immediately after cut is complete and waits for blades to completely stop before removing workpiece.

<p>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.</p>
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Safety Precautions

Your safety is important. The items below are intended to supplement the **SAFETY** section in the front of the manual. But remember, no safety list can cover every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

Please follow these safety precautions EVERY time you use your saw:

- Stand to the side of the blade line-of-cut when performing a cutting operation.
- Turn **OFF** the saw and allow the blade to come to a complete stop before removing the cut-off piece.
- Make sure that the riving knife is always aligned with the main blade before cutting!
- Always keep the blade guard properly installed.
- Carefully plan each cutting operation to avoid injuries.
- When you release the sliding table lock, make sure that the lock lever is positioned so that it will not lock the table during a cut.

Machine Controls

Review the control descriptions and **Figures 72–76** to better understand their functions and how to use them.

Main Blade ON/OFF Buttons: Starts and stops the main saw blade.

Scoring Blade ON/OFF Buttons: Starts and stops the scoring blade.

STOP Button: Cuts power to both motors.

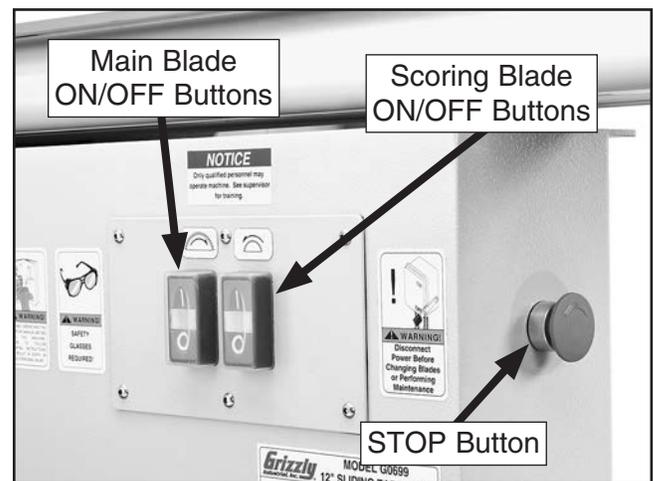


Figure 72. Power controls.

Blade Tilt Handwheel & Lock Knob: Handwheel tilts the blades from 0° to 45°. The lock knob secures the handwheel to prevent it from moving during operation.

Blade Tilt Scale: Displays the degree of blade tilt.

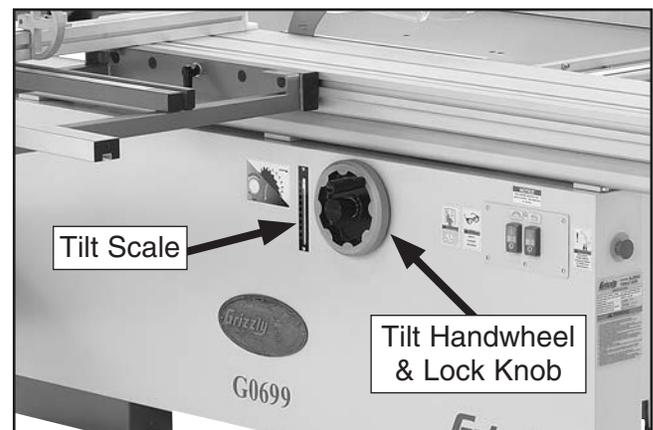


Figure 73. Blade tilt controls.



Blade Elevation Handwheel & Lock Knob: Handwheel raises and lowers the blades. The lock knob secures the handwheel to prevent it from moving during operation.



Figure 74. Blade elevation control.

Sliding Table Lock Lever: Locks the sliding table in position. When rotated to the left, the locking mechanism under the sliding table engages. When the lever is rotated to the right, the lock releases and allows the table to slide freely.

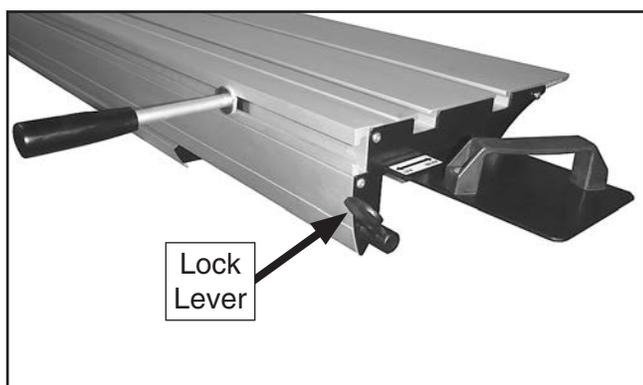


Figure 75. Sliding table locking mechanism.

Rip Fence Clamp Lever: Secures the rip fence to the rip fence body.

Rip Fence Lock Lever: Clamps the rip fence assembly in place on the fence rail.

Micro-Adjust Knob: Provides for fine-tune adjustment for the width-of-cut (the rip fence lock lever must be loose to use this).

Micro-Adjust Lock Knob: Clamps the rip fence assembly to the fence rail and allows the use of the micro-adjust knob.

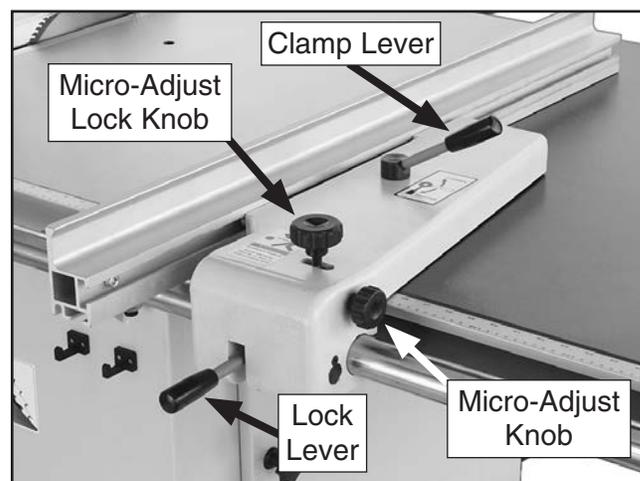


Figure 76. Rip fence controls.



Workpiece Inspection

Some workpieces are not safe to cut or may require modification before they are safe to cut. **Before cutting, inspect all workpieces for the following:**

- **Material Type:** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.
- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.
- **Large/Loose Knots:** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.
- **Wet or "Green" Stock:** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.
- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!
- **Minor Warping:** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

Non-Through and Through Cuts

Through Cuts

A through cut is a sawing operation in which the workpiece is completely sawn through, as shown in the **Figure** below. Examples of through cuts are rip cuts, cross cuts, miter cuts, and beveled cuts. The blade guard assembly **MUST** be used when performing through cuts.

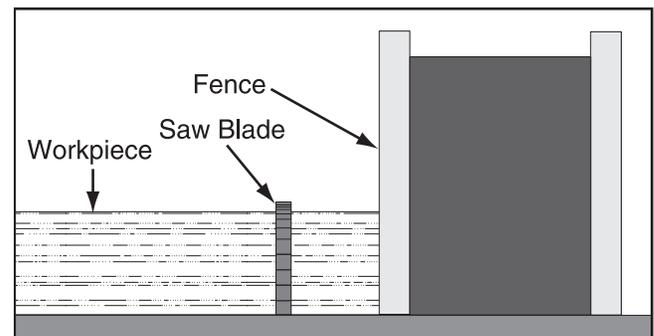


Figure 77. Example of a through cut (blade guard not shown for illustrative clarity).

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in the **Figure** below. The blade guard assembly **MUST** be used when performing all non-through cuts, except when the guard will not safely accommodate the workpiece.

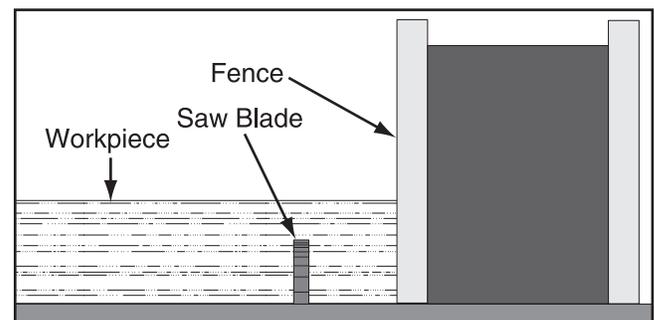


Figure 78. Example of a non-through cut.



Blade Guard

The term "blade guard" refers to the assembly shown in **Figure 79**.

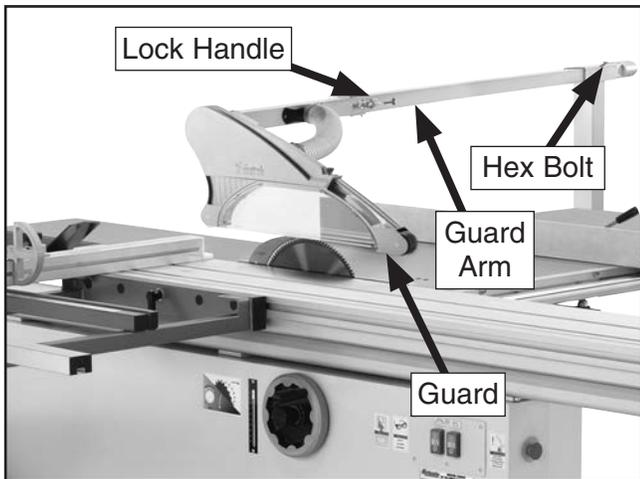


Figure 79. Blade guard assembly.

Understanding & Using Blade Guard

The blade guard **MUST** be installed on the saw for all cuts (see **Page 14**). The guard encloses the top of the blade to reduce the risk of accidental blade contact and contain flying chips or dust. When installed and properly maintained, it is an excellent tool for reducing the risk of injury when operating the table saw.

Sometimes the guard or its components can get in the way when cutting very narrow workpieces or other specialized cuts. Use the lock handle shown in **Figure 79** to move the guard out of the way. The blade guard **MUST** remain installed on saw. If blade guard is removed for specific operations, always replace it immediately after those operations are complete.

As the workpiece is pushed into the blade, the guard lifts and remains in contact with the workpiece during the cut, then returns to a resting position against the table when workpiece is pushed completely past the guard.

To ensure that the guard does its job effectively, it **MUST** be centered over blade and properly adjusted so it moves up and down to accommodate workpieces, yet properly maintains blade after the workpiece exits.

Adjusting Blade Guard

Loosen the hex bolt securing the guard arm (see **Figure 79**), and adjust the guard so the distance between the blade and both side covers is equal.

For stock up to 1" thick, loosen the (4) lock nuts securing guard to guard arm, (see inset image in **Figure 79**), ¼-turn each so the blade guard moves smoothly up and down with the workpiece. For stock thicker than 1", set the guard to rest on the workpiece, then tighten the (4) lock nuts.

IMPORTANT: Every time the blade guard is re-installed, you must verify that it functions correctly before making a cut.

To test blade guard operation, lift the front end all the way up, then release it. The blade guard should freely drop down and both wheels should contact table surface.

If blade guard remains in the same position where you released it, loosen lock nuts securing blade guard upper guard arm, and re-test operation until guard freely drops all the way down.

Guard Covers

The G0699 features two dust hood assemblies for either straight cuts or angled cuts. Use the flat blade cover when performing straight (90°) cuts or the bubble cover for angled cuts. To change between covers, remove lock knob (see **Figure 80**) then secure the guard assembly to the dust hood, install the other cover, and re-tighten the lock knob.

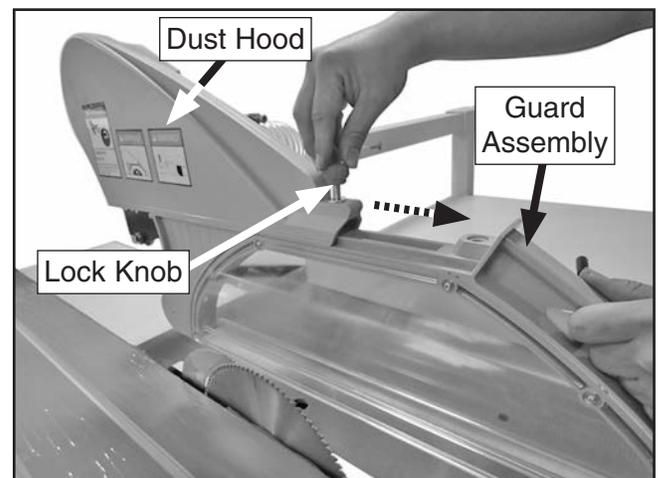


Figure 80. Removing blade guard assembly.



Riving Knife

The riving knife (see **Figure 81**) is a metal plate that prevents the workpiece from pinching the backside of the blade and causing kickback. It also acts as a barrier behind the blade to shield hands from being pulled into the blade if a kickback occurs while the operator is reaching behind the blade. (Reaching behind the blade is a major safety risk and should never be done.) Use the riving knife for all operations.

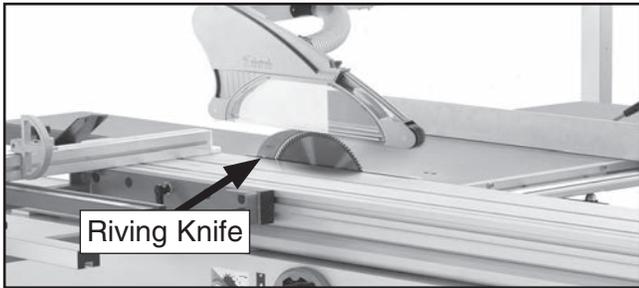


Figure 81. Riving knife location.

!WARNING

To ensure riving knife works safely, it **MUST** be aligned with and correctly adjusted to blade.

Riving Knife Installation & Removal

The riving knife must be correctly installed, adjusted, and aligned in order to provide the maximum safety benefit.

The riving knife attaches to the mounting block as shown in **Figure 82**. Always firmly tighten the hex nut when securing the riving knife in place.

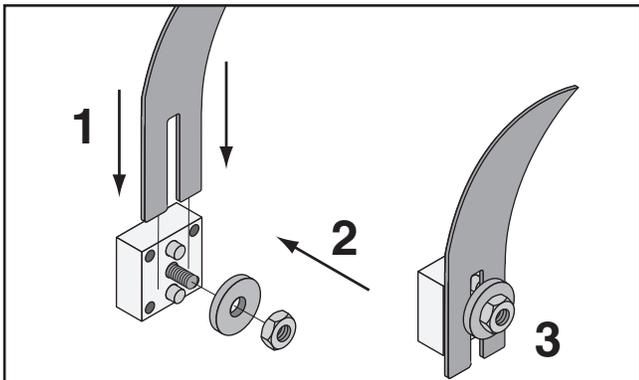


Figure 82. Installing riving knife on mounting block.

Secure the riving knife 1–5mm below the top level of the blade, as shown in **Figure 83**.

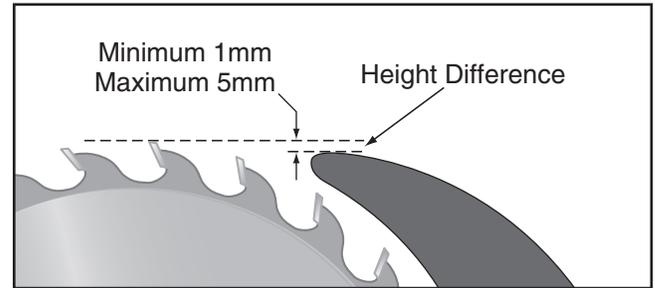


Figure 83. Height difference between riving knife and blade.

The height difference between the riving knife and the blade allows the workpiece to pass over the blade during non-through cuts (those in which the blade does not cut all the way through the thickness of the workpiece).

The riving knife also prevents the freshly cut sides of the workpiece from pinching the blade and causing kickback. For maximum effectiveness of this safety design, the riving knife must be positioned within 3–8mm of the blade, as shown in **Figure 84**.

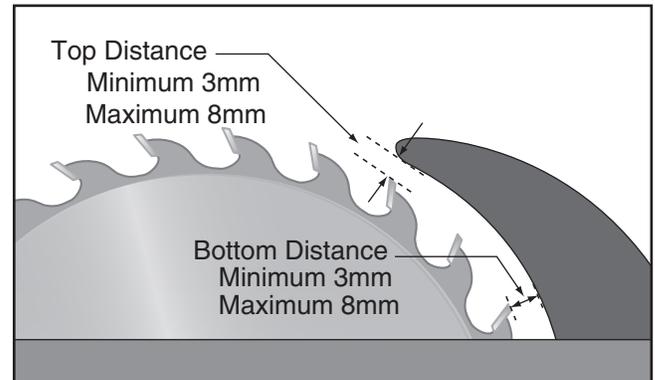


Figure 84. Allowable top and bottom distances between riving knife and blade.



Once the riving knife is properly positioned at the correct distance from the blade, verify that it is aligned with the blade by checking the alignment with a straightedge in the top and bottom locations shown in **Figure 85**.

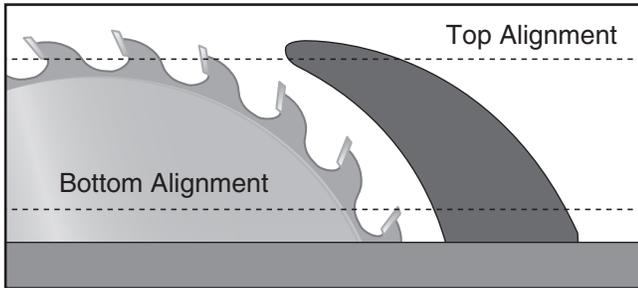


Figure 85. Checking top and bottom riving knife alignment with blade.

The riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in **Figure 86**.

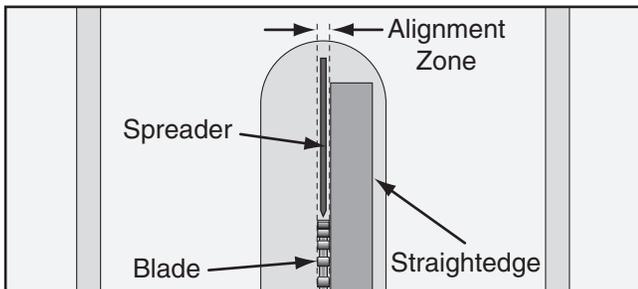


Figure 86. Verifying that riving knife is in the alignment zone behind the blade.

If the riving knife is not aligned or parallel with the blade, refer to **Riving Knife Mounting Block** on **Page 77**.

Blade Requirements

The riving knife included with this machine is 0.10" (2.5mm) thick and is only designed for 12" diameter blades.

When choosing a main blade, make sure the blade size meets the requirements listed below. The thickness of the blade body and teeth can be measured with calipers or any precision measuring device.

Blade Size Requirements:

- Body Thickness: 0.079"–0.094" (2.0mm–2.4mm)
- Kerf (Tooth) Thickness: 0.102"–0.126" (2.6mm–3.2mm)

Blade Selection

This section on blade selection is by no means comprehensive. Always follow the saw blade manufacturer's recommendations to ensure safe and efficient operation of your table saw.

Ripping Blade Features:

- Best for cutting with the grain
- 30-40 teeth
- Flat-top ground tooth profile
- Large gullets for large chip removal

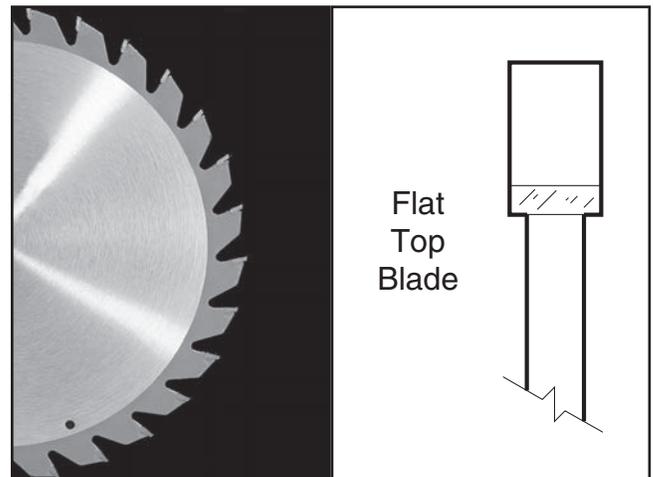


Figure 87. Ripping blade.



Crosscut blade features:

- Best for cutting across the grain
- 80–100 teeth
- Alternate top bevel tooth profile
- Small hook angle and a shallow gullet

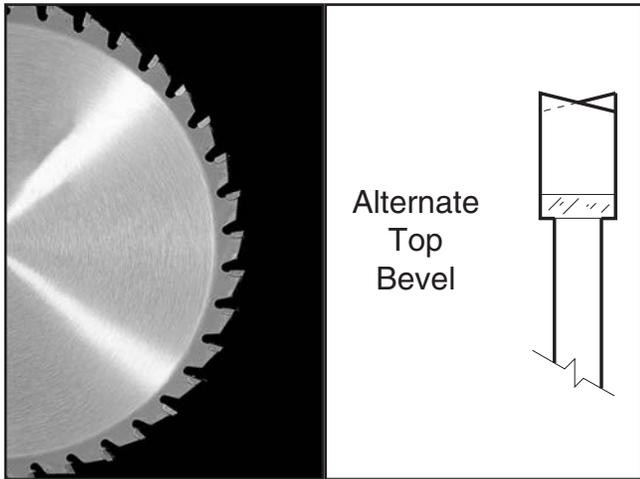


Figure 88. Crosscutting blade.

Laminate blade features:

- Best for cutting plywood or veneer
- 100–120 teeth
- Triple chip tooth profile
- Very shallow gullet

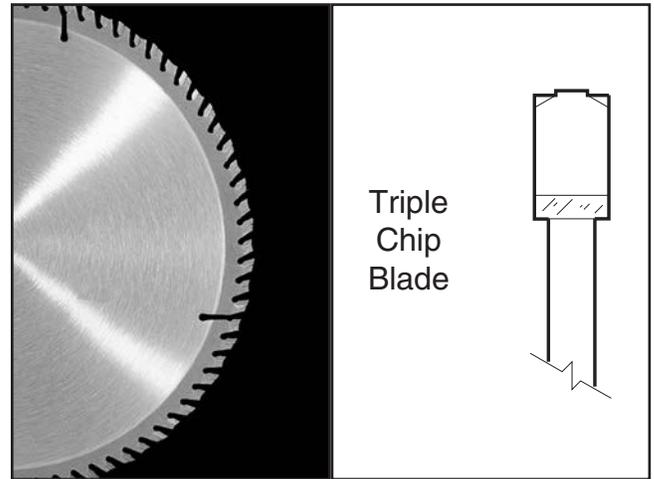


Figure 90. Laminate blade.

Combination blade features:

- Designed to cut both with and across grain
- 50–80 teeth
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile
- Teeth are arranged in groups
- Gullets are small and shallow (similar to a cross-cut blade), then large and deep (similar to a ripping blade)

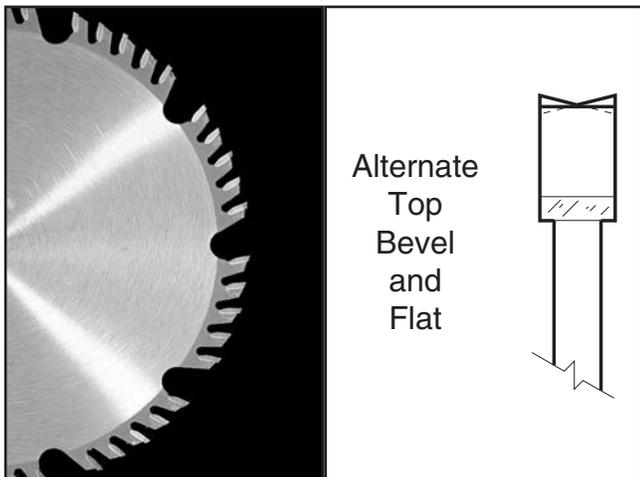


Figure 89. Combination blade.

Thin Kerf Blade: A blade with thinner kerf than a standard blade. Since the spreader/riving knife included with this table saw is sized for standard blades, thin kerf blades cannot be used on this saw.



Changing Main Blade

The Model G0699 performs best when using high quality, sharp blades. Whenever the main blade starts to get dull, sharpen or replace it with a new blade.

Tools Needed	Qty
Hex Wrench 8mm.....	1
Wrench 30mm.....	1
T-Handle Wrench 8mm.....	1

To change the main blade:

1. DISCONNECT SAW FROM POWER!
2. Adjust the blade tilt to 0° and raise the blade all the way up.
3. Raise blade guard up.
4. Move the sliding table all the way forward to expose the blade cover, lock it in place, then open the blade cover.
5. Insert the provided T-handle wrench through the table top hole shown in **Figure 91** and into one of the holes in the main blade pulley under the table top. This will keep the blade arbor from rotating during the next step.

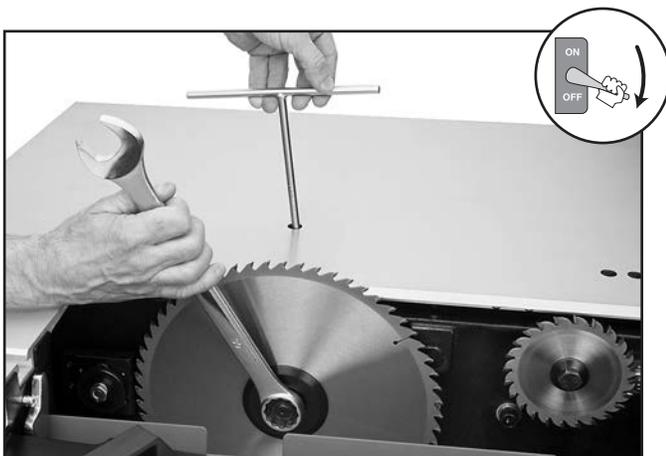


Figure 91. Loosening the main blade arbor nut.

CAUTION

Before proceeding with the next steps, wear leather gloves to protect your hands when handling the saw and scoring blades.

6. While holding the T-handle wrench with one hand, rotate the arbor nut clockwise until you can remove it and the flange (see **Figure 92**).

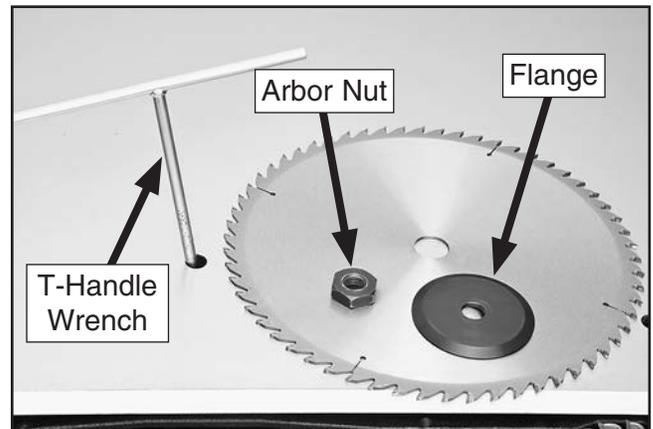


Figure 92. Main blade arbor nut and flange.

7. Remove the existing blade, slide the replacement blade over the arbor with the teeth facing to the right, then re-install the flange with the beveled edge facing out.
8. Thread the arbor nut on counterclockwise and fully tighten it to secure the flange and blade.
9. Re-check the riving knife alignment with the blade, as instructed in the next section.
10. Close the blade cover, reposition blade guard over blade, then move the sliding table back to the center of the machine.



Adjusting & Replacing Scoring Blade

The scoring blade rotates in the opposite direction from the main blade and makes a shallow cut into the workpiece surface. This prevents workpiece tear-out.

Some replacement scoring blades consist of an inner and outer blade with internal shims. The shims are provided so the scoring blade set can match the kerf thickness of the main blade. **Figure 93** shows a typical scoring blade set with shims.

The scoring blade provided with the Model G0699 has wedge-shaped teeth so that scoring kerf widens as the blade is raised.

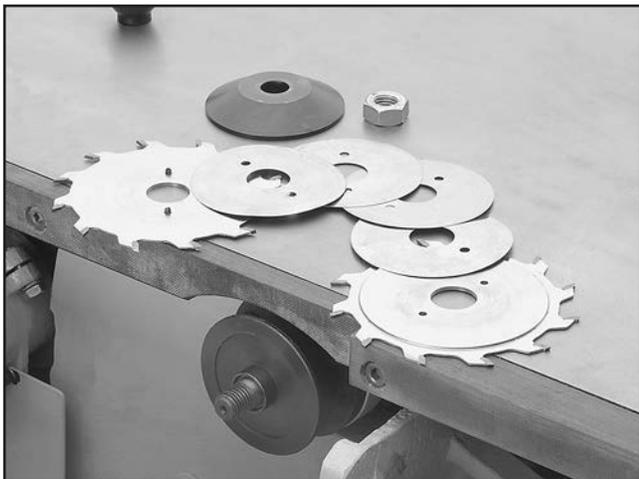


Figure 93. Typical scoring blade set with shims.

NOTICE

To make sure that the scoring blade kerf is the same as the main blade kerf, you will need to adjust the scoring blade as instructed in this procedure whenever the dimensions of the main blade change.

Changing Scoring Blade

Tools Needed	Qty
Hex Wrench 8mm.....	1
Scoring Blade Arbor Wrench.....	1
Wrench 19mm	1

To change the scoring blade:

1. DISCONNECT SAW FROM POWER!
2. Adjust the blade tilt to 0° and raise the blade all the way up.
3. Raise blade guard up and move it away from blade.
4. Move the sliding table all the way forward to expose the blade cover, lock it in place, then open the blade cover.
5. Place the arbor wrench on the flange behind the scoring blade, then turn the arbor nut counterclockwise until you can remove it and the flange (see **Figure 94**).

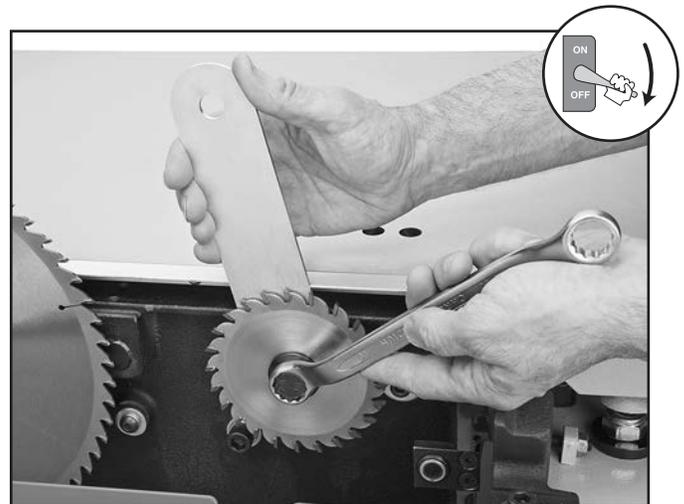


Figure 94. Removing the scoring blade.

6. Replace the scoring blade with the teeth facing the main blade, then re-install the flange and arbor nut. Make sure the nut is fully tightened.
7. Adjust the scoring blade position, as instructed below, then close the blade cover, properly reposition blade guard, and move the sliding table back to the center.



Adjusting Scoring Blade

The goal in this procedure is to adjust the scoring blade vertical and horizontal positions so that the scoring kerf is the same width as the main blade kerf and is aligned with it. This will require placing the straightedge on both sides of the blades multiple times as you make adjustments.

Tools Needed	Qty
Hex Wrench 8mm.....	1
T-Handle Wrench 8mm	1
Straightedge	1

To adjust the scoring blade position:

1. DISCONNECT SAW FROM POWER!
2. Adjust the blade tilt to 0° and raise the blade all the way up.
3. Raise blade guard up and move it away from blade.
4. Move the sliding table all the way forward to expose the red blade cover, lock it in place, then open the blade cover.
5. When positioning the straightedge, place it against teeth on both sides of the main saw blade to obtain an accurate reading of the main saw blade kerf.

—*Horizontal Adjustment:* Insert the T-handle wrench into the right hole shown in **Figure 95**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

—*Vertical Adjustment:* Insert the T-handle wrench into the left hole shown in **Figure 96**, engage it with the adjustment bolt under the table, then rotate the wrench to position the scoring blade.

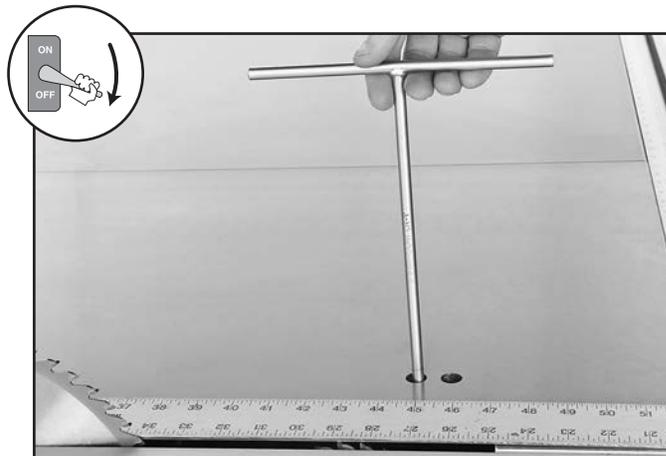


Figure 96. Adjusting the vertical height of the scoring blade.

6. Close the blade cover, properly reposition blade guard, and move the sliding table back to the center.

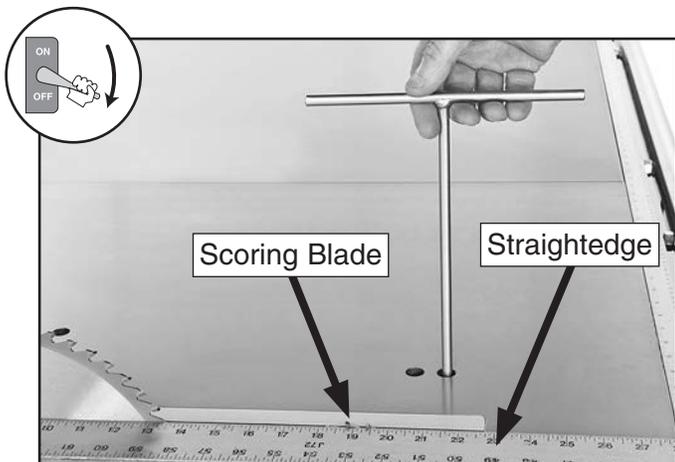


Figure 95. Adjusting the horizontal position of the scoring blade.



Rip Cutting

The Model G0699 has the capability of rip cutting full-size panels, as shown in **Figure 97**. The sliding table saves time and increases accuracy by removing the burden of sliding a large and heavy panel over a stationary table surface.

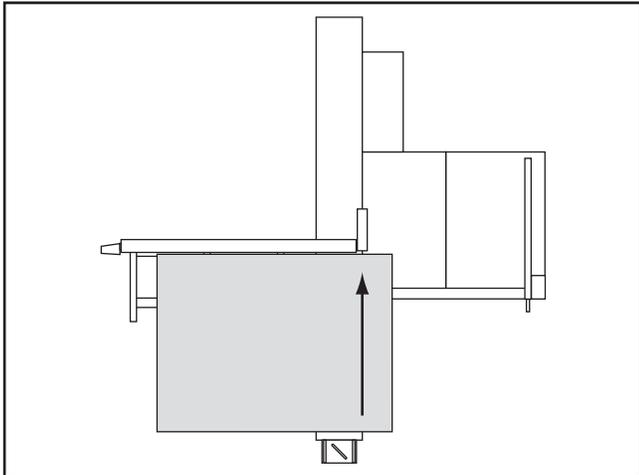


Figure 97. Example of full panel rip cutting.

This saw also has the capability of rip cutting smaller workpieces, using the machine as a traditional table saw, as shown in **Figure 98**. Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade with the use of the rip fence.

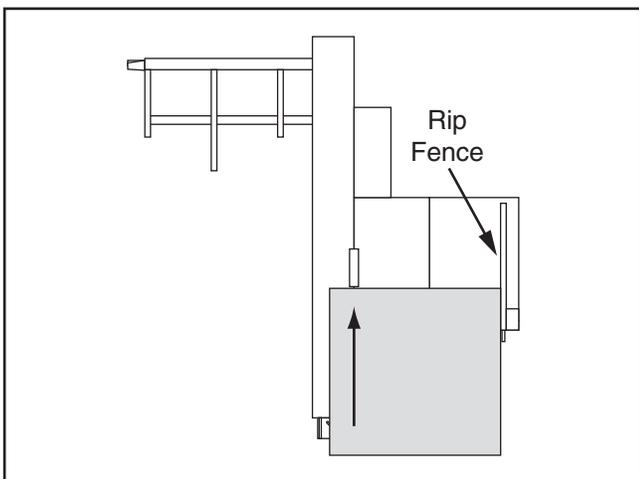


Figure 98. Example of using the rip fence with smaller workpieces.

⚠ CAUTION

Use hold-down and end shoe to hold down workpiece ends to prevent it from raising up, which could cause kickback.

Rip Cutting With Sliding Table

1. DISCONNECT SAW FROM POWER!
2. Make sure the 90° stop bolt is properly adjusted, as instructed in the **Squaring Crosscut Fence to Blade on Page 76**.
3. Loosen the crosscut fence pivot stud under the crosscut fence, insert it into its hole in the crosscut table, then rotate the fence against the 90° stop bolt.

Note: The fence can be mounted in the forward or rear position, depending on the size of the workpiece and which position will provide the safest operation.

4. Use a precision ruler against a tooth of the blade, then adjust the fence so that the 2" mark on the fence scale is exactly 2" from the blade tooth, as shown in **Figure 99**.

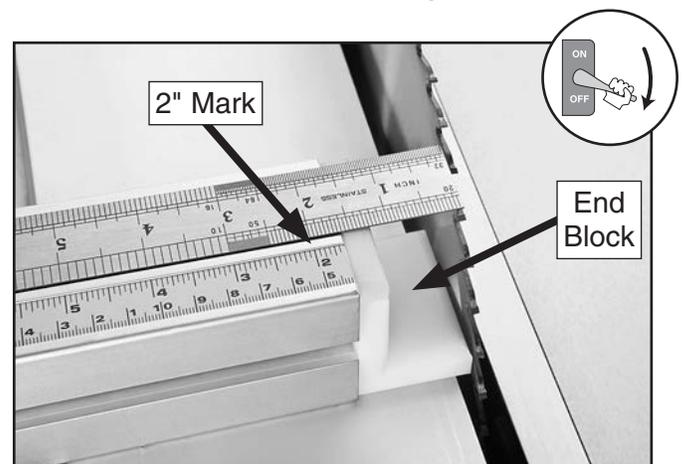


Figure 99. Setting the correct space between the crosscut fence and blade for rip cutting.

5. Carefully lift the crosscut fence up, fully tighten the pivot stud, then re-insert the stud into the hole. Re-check the spacing between the end block and blade—if necessary, loosen the stud and repeat **Steps 3–5** until the spacing is correct.
6. Set a flip stop to the desired width-of-cut.



7. Load the workpiece onto the sliding and crosscut tables.
8. Install the hold-down into the sliding table T-slot and use it to secure the workpiece to the sliding table. The set up should look similar to **Figure 97** on the previous page.
9. Take all the necessary safety precautions, connect the saw to power, then perform the cutting operation.

Rip Cutting With Rip Fence

1. DISCONNECT SAW FROM POWER!
2. Move the sliding table forward out of the way, then lock it place.
3. The rip fence can be installed in the vertical position for thicker workpieces, or in the horizontal position for smaller workpieces (see **Figure 100**).

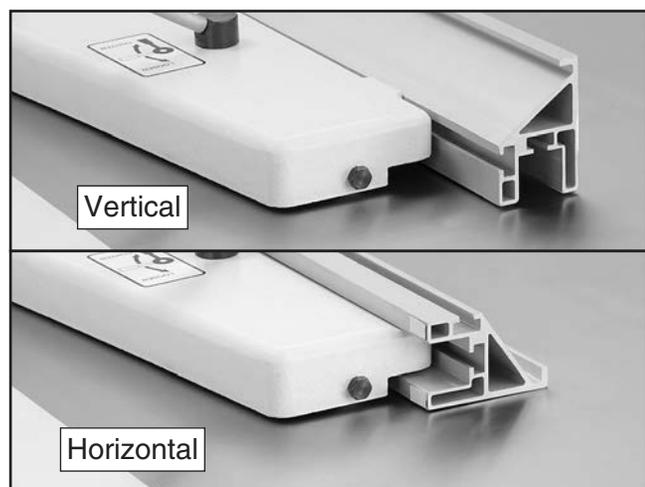


Figure 100. Rip fence positions.

4. Loosen the rip fence clamp handle, position the leading edge of the fence so it is either across the full width of the table or (optionally) even with the center of the main saw blade, as shown in **Figure 101**, then re-tighten the clamp handle.

Note: The rip fence position shown below is favored by European standards because it allows the cut-off piece to “fall” away from the blade when the cutting operation is complete; thereby reducing risk of kickback from the backside of the blade catching on the railing corner of the workpiece.

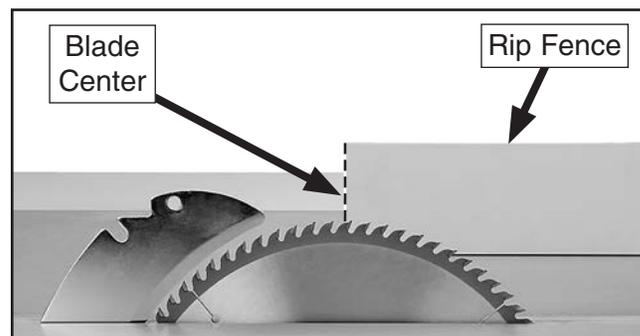


Figure 101. Example of rip fence set even with center of main saw blade.

5. Lift the fence lock lever and position the rip fence to the approximate width-of-cut (see **Figure 102**).

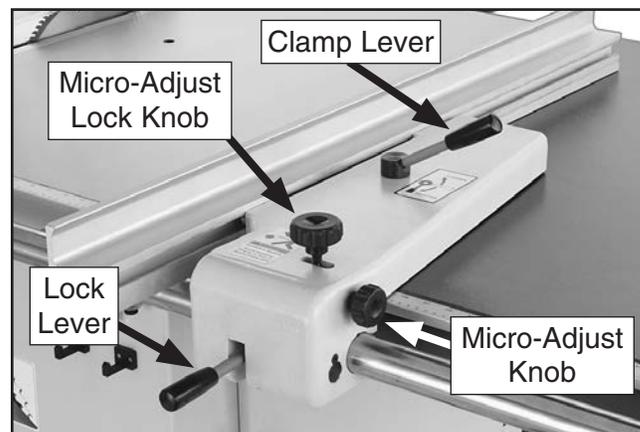


Figure 102. Rip fence controls.

6. Tighten the micro-adjust lock knob, then turn the micro adjust knob to fine tune the desired width-of-cut.
7. Push the lock lever down to lock the fence assembly in place, connect the saw to power, then perform the cutting operation.



Crosscutting

The Model G0699 crosscuts full size panels with the fence in the forward or rear position. However, it is easier to load full size panels with the crosscut fence mounted in the forward position, as shown in **Figure 103**.

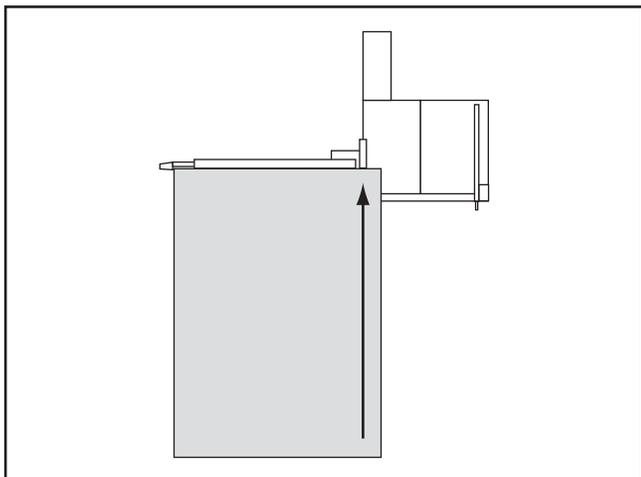


Figure 103. Crosscut fence mounted forward to handle full size panel.

Mounting the crosscut fence in the rear position provides greater stability for crosscutting smaller panels, as shown in **Figure 104**.

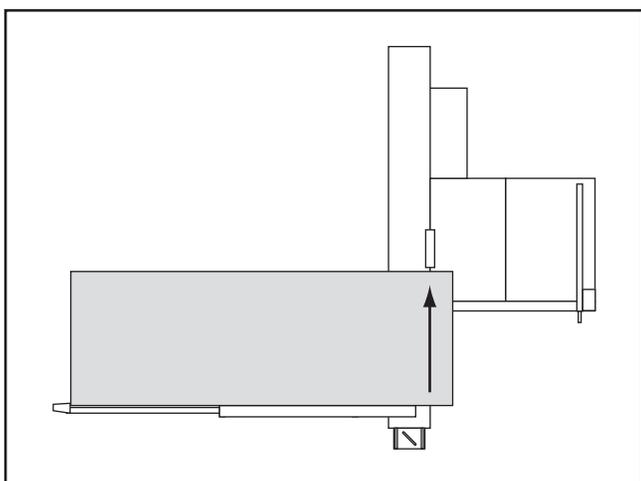


Figure 104. Crosscut fence mounted in the rear position for smaller panels.

When setup properly, this table saw also has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge, as shown in **Figure 105**.

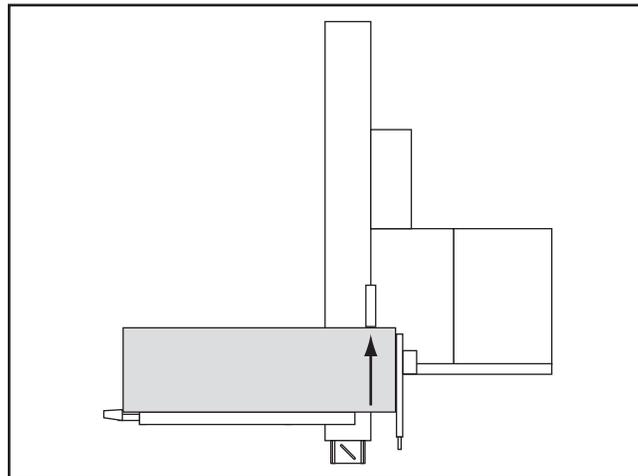


Figure 105. Crosscutting using the rip fence as a cut off gauge.

Crosscutting Full Size Panels

1. DISCONNECT SAW FROM POWER!
2. Make sure the forward 90° stop bolt is properly adjusted, as instructed in the **Squaring Crosscut Fence to Blade** on **Page 76**.
3. Loosen the crosscut fence pivot stud under the crosscut fence, install the fence in the forward position, as indicated in **Figure 106**, then rotate the fence against the 90° stop bolt.

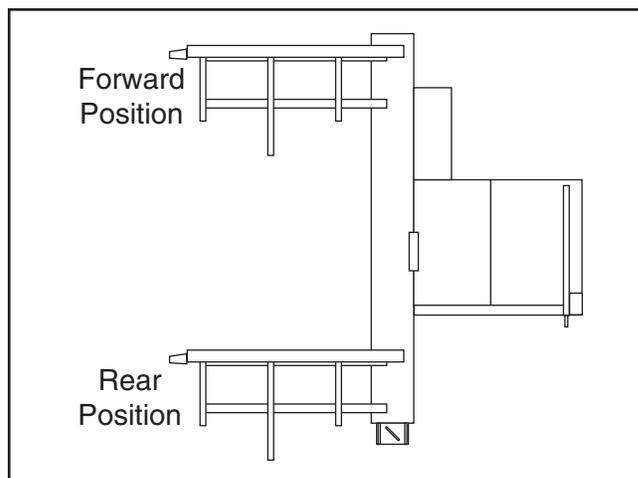


Figure 106. Forward and rear crosscut fence mounting positions.



- Use a precision ruler against a tooth of the blade, then adjust the fence so that the 2" mark on the fence scale is exactly 2" from the blade tooth, as shown in **Figure 107**.

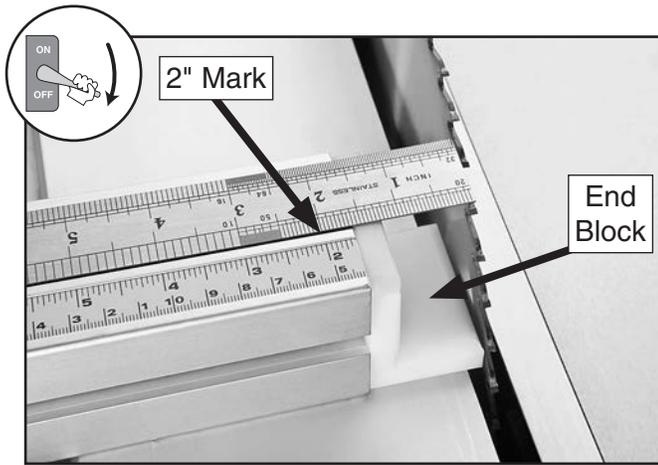


Figure 107. Setting the correct space between the crosscut fence and blade for rip cutting.

- Carefully lift the crosscut fence up, fully tighten the pivot stud, then re-insert the stud into the hole. Re-check the spacing between the end block and blade—if necessary, loosen the stud and repeat **Steps 3–5** until the spacing is correct.
 - Set either crosscut fence flip stop to the desired width-of-cut.
- Note:** *Extend the crosscut fence slide if the workpiece is more than 74".*
- Load the workpiece onto the table saw. The set up should look similar to **Figure 103** on the previous page.
 - Once all the necessary safety precautions have been taken, then perform the cutting operation.

Crosscutting Smaller Panels

Follow the same steps in the **Crosscutting Full Size Panels** subsection on **Page 56**, but mount the crosscut fence in the rear position, as indicated in **Figure 106** on the previous page. Then, load the workpiece so your setup looks similar to **Figure 104** on the previous page.

Crosscutting Using Rip Fence as a Cut-Off Gauge

- Follow the same steps in the **Crosscutting Full Size Panels** subsection on **Page 56**, but mount the crosscut fence in the rear position, as indicated in **Figure 106** on the previous page.

!WARNING

When using the rip fence with the crosscut fence, the rip fence must be positioned behind the front edge of the blade to prevent the workpiece from binding and causing a kickback hazard.

- Position the rip fence for the desired width-of-cut, then slide the leading end of the rip fence behind the front edge of the main blade, as shown in **Figure 108**.

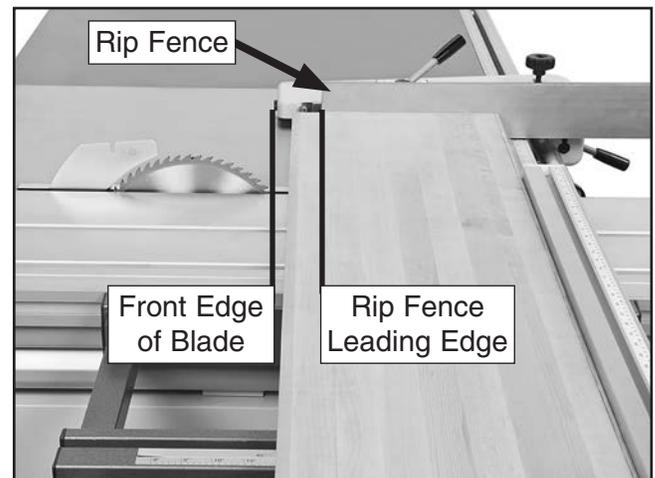


Figure 108. Proper rip fence position when using it as a cut-off gauge.

- Take all the necessary safety precautions, connect the saw to power, then perform the cutting operation.



Miter Cutting

The crosscut fence can be positioned for miter cuts from 0° to 135°. The miter scale on top of the crosscut table has a resolution of 1".

To perform a miter cut:

1. DISCONNECT SAW FROM POWER!
2. Position the crosscut table to provide the greatest amount of workpiece support, then lock it in place.
3. Install the crosscut fence onto the crosscut table in the position that will allow for the desired angle of cut.

—For miter cuts from 0° to 90°, insert the fence pivot stud into the rear hole and angle the fence forward, as shown in **Figure 109**.

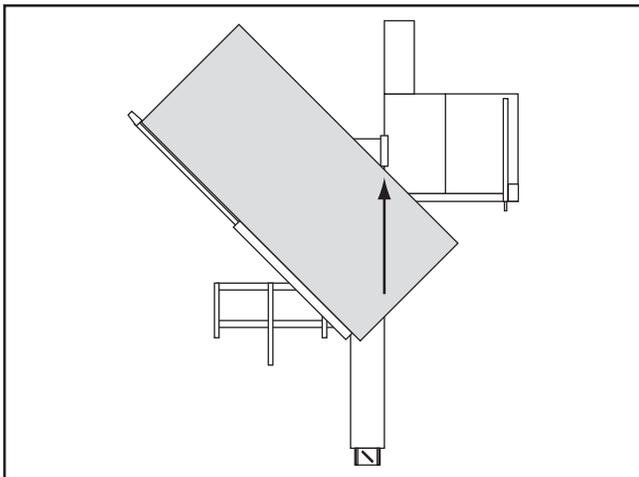


Figure 109. Crosscut fence positioned for miter cuts from 0° to 90°.

—For miter cuts from 90° to 135°, insert the fence pivot stud into the forward hole and angle the fence to the rear, as shown in **Figure 110**.

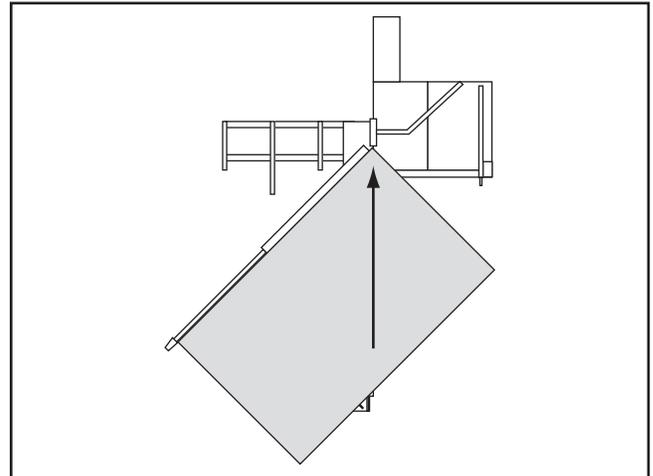


Figure 110. Crosscut fence positioned for miter cuts from 90° to 135°.

4. Rotate the fence to the desired angle of cut, make sure the fence end block is clear of the blade so that it will not be cut during the operation, then use the fence lock knob to secure the fence in place.
5. Position the flip stop for the desired width-of-cut, then load the workpiece onto the table. The set up should look similar to **Figures 109–110**.
6. Once all the necessary safety precautions have been taken, connect the saw to power, then perform the cutting operation.



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.

Recommended Metal Protectants

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



Figure 111. Recommended products for protecting unpainted cast iron/steel part on machinery.

- 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 112. Half-mask respirator with disposable cartridge filters.

- G4173—Baby Power Feeder 120V
- G4176—1/4 HP Power Feeder 120V
- G4179—1/2 HP Power Feeder 220V
- G4181—1 HP Power Feeder 240V

Installing a power feeder on your table saw will make repetitive cuts much easier and safer. Can be installed on nearly any table saw. Easy to adjust wherever needed, including out of the way when not needed! A must for any shop.



Figure 113. G4179 Power Feeder.

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



Cyclone Dust Collectors

G0440HEP—2 HP, 1354 CFM @ 2.5" SP

G0441—3 HP, 1654 CFM @ 2.0" SP

G0442—5 HP, 2184 CFM @ 1.9" SP

Cyclone action separates the heavy dust particles from the fine particles and drops them into the steel drum. Any remaining fine dust travels past the impeller and is then trapped by a cartridge filter made of spun-bond polyester that filters 99.9% of particles from 0.2–2.0 microns in size. The cartridge filter is pleated to provide a large surface area for efficient air movement and a clear plastic bag collect the fine cake that shakes off the filter for consistent dust collector performance. Casters mounted to the steel drum also make disposal of the larger chips and dust as easy as it gets.



Figure 114. Model G0440HEP Cyclone Dust Collector.

T23037—Scoring Blade Replacement

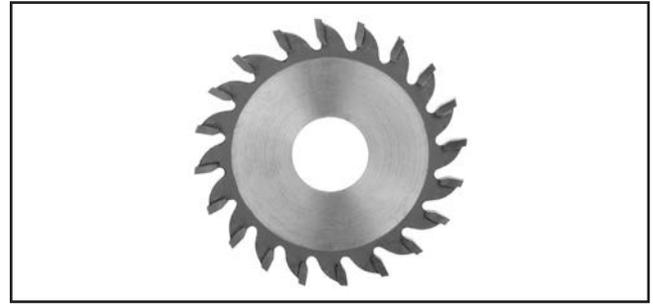


Figure 115. Model T23037 Scoring Blade.

G7581—Superbar™

G7582—Master Plate

The miter slot mounted Superbar™ will align, tune and calibrate your table saw to within ± 0.001 in just minutes. Replace your table saw blade when calibrating the double disk ground Master Plate for a precision measurement, with no run out!

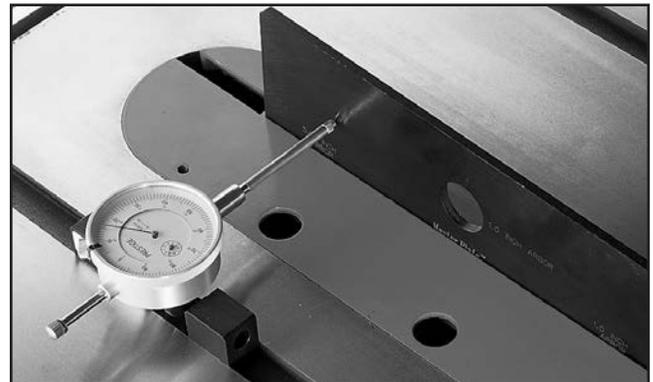


Figure 116. Superbar™ and Master Plate.

H8029—5 Piece Safety Kit

This kit has four essential jigs. Includes two push blocks, push stick, featherboard and combination saw and router gauge. Featherboard fits $\frac{3}{8}$ " x $\frac{3}{4}$ " miter slots.



Figure 117. H8029 5 Piece Safety Kit.

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



SECTION 6: SHOP-MADE SAFETY ACCESSORIES

Safety devices such as push sticks, featherboards, and push blocks can be made easily and inexpensively. They increase safety by keeping hands a safe distance from the blade when feeding workpieces into the blade.

Push Sticks

Push sticks are particularly useful when cutting small or narrow workpieces. They provide added leverage, enabling the operator to keep the workpiece firmly supported against the fence and table. At the same time, the push stick keeps the operator's hands safely away from the saw blade. A push stick is included with your table saw. To make additional push sticks, refer to the template in **Figure 118** for construction details.

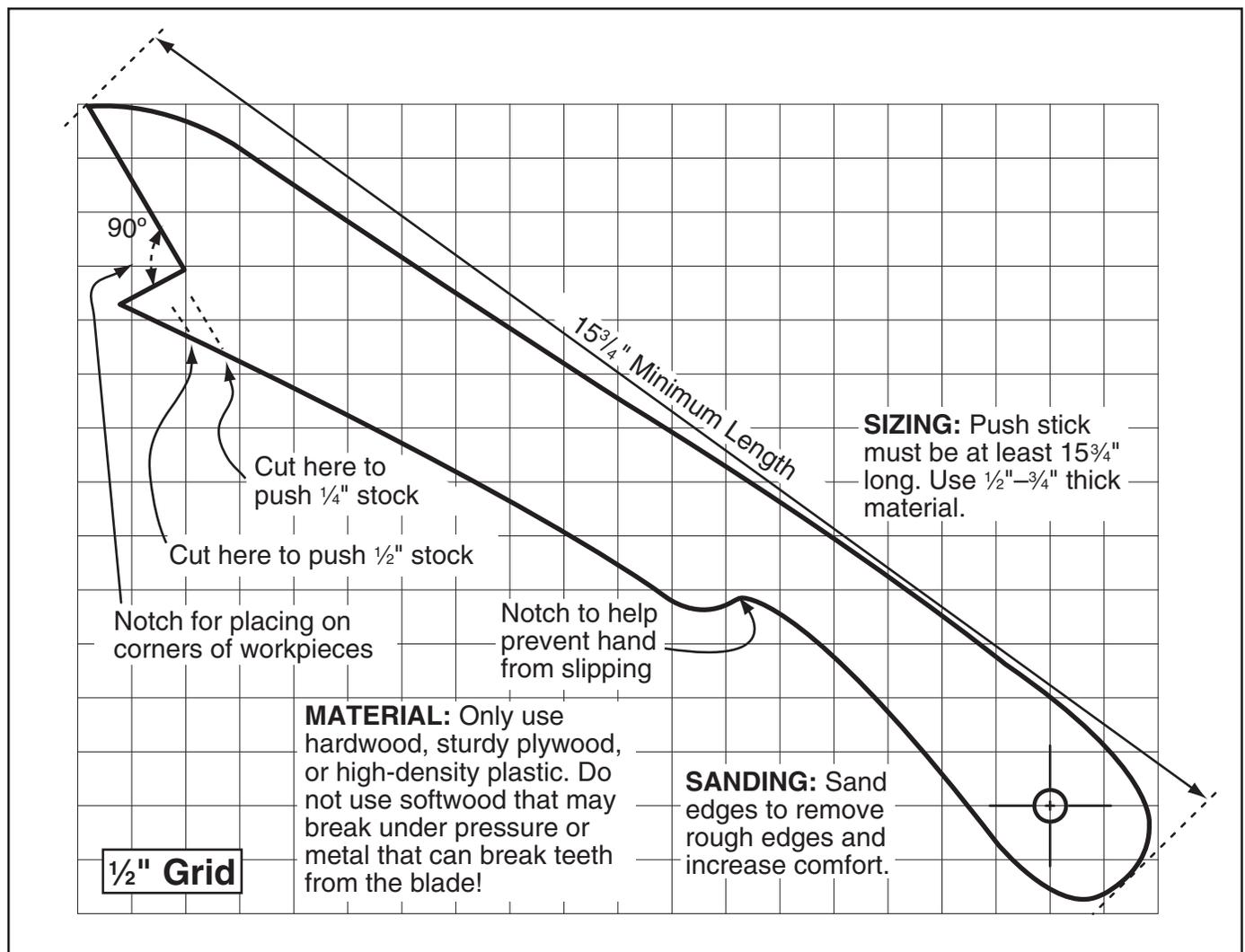


Figure 118. Template for a shop-made push stick (shown at 70% of full size).



Push sticks should be made of plywood or hard wood and can be made in a variety of shapes and sizes. Avoid making push sticks out of material that may break under pressure (soft wood or particle board) or out of material that may damage the blade during accidental contact (metal).

The push stick must be at least 15³/₄" long. The pattern for making a basic push stick, such as the one shown in **Figure 118**, can be laid out on a piece of wood and cut out using a bandsaw, jig saw, or scroll saw. Sand the handle area and edges to increase comfort and safety.

Using a Push Stick

Figure 119 shows an example of push sticks used to feed and support a workpiece.

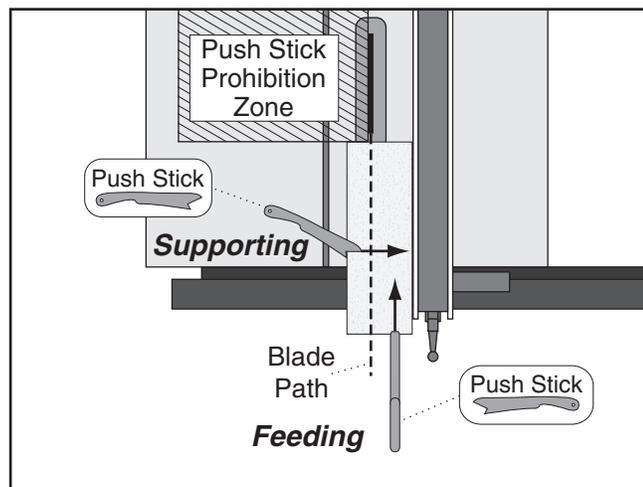


Figure 119. Example of shop-made push stick used to rip narrow stock.

Feeding: Place the notched end of the push stick against the end of the workpiece and out of the blade path. Use steady downward and forward pressure to push the workpiece into the blade.

Supporting: A second push stick may also be used with the other hand to apply sideways pressure on the workpiece to keep it held firmly against the fence while starting the cut. When using a push stick in this manner, do not apply pressure to the workpiece against or behind the blade (see "Push Stick Prohibition Zone" in **Figure 119**). Otherwise, pressure from the push stick will increase the risk of kickback.



Push Blocks

When used correctly, a push block reduces the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push block often takes the damage that would have otherwise happened to hands or fingers.

Using a Push Block

A push block can be used in place of or in addition to a push stick for feeding workpieces into the blade. Due to their design, push blocks allow the operator to apply firm downward pressure on the workpiece that could not otherwise be achieved with a push stick.

The push block design on this page can be used in two different ways (see inset **Figure** below). Typically, the bottom of the push block is used until the end of the workpiece reaches the blade.

The notched end of the push block is then used to push the workpiece the rest of the way through the cut, keeping the operator's hands at a safe distance from the blade. A push stick is often used at the same time in the other hand to support the workpiece during the cut (see "Using a Push Stick" on previous page).

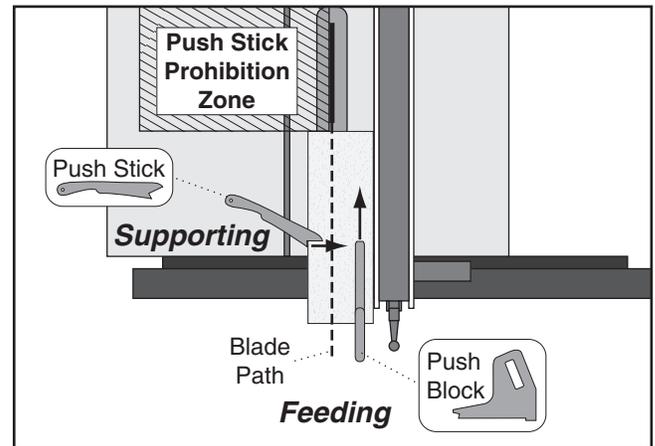


Figure 121. Using a push block and push stick to make a rip cut.

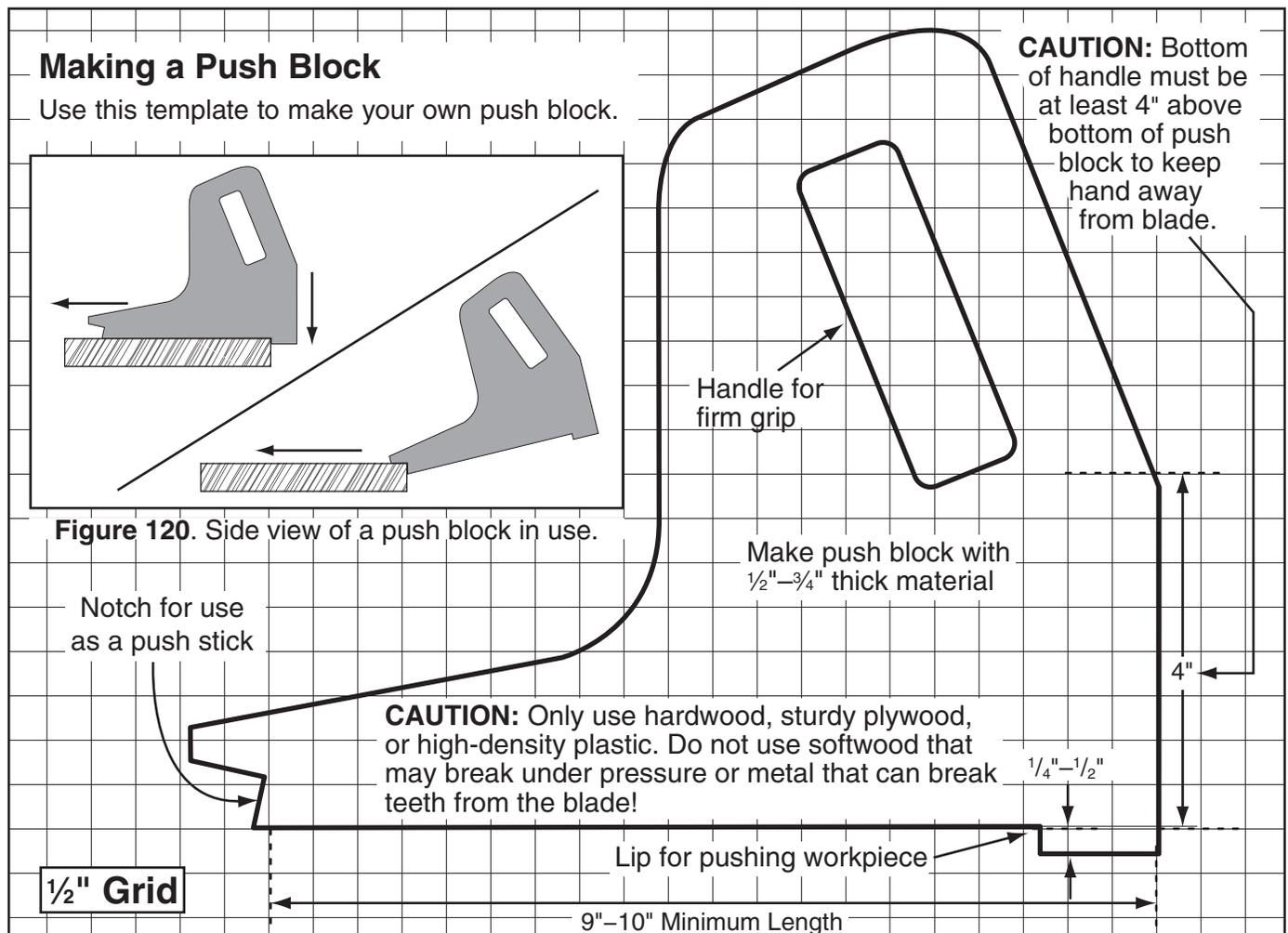


Figure 122. Template for a shop-made push block (shown at 50% of full size).



Using a Push Block

1. Place the lip of the push block (**Figure 122, Page 63**) against the end of the workpiece, and use steady downward and forward pressure to push the workpiece into the blade. Use a push stick to apply sideways pressure on the workpiece to keep it held firmly against the fence, as shown in the example of **Figure 123**.

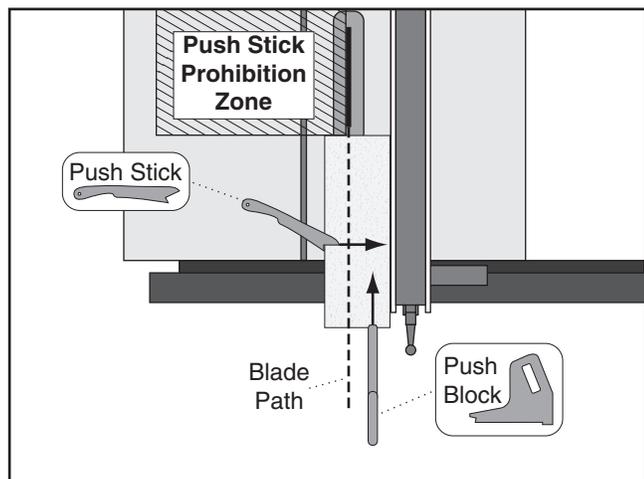


Figure 123. Example of using a push block to feed a workpiece into the blade.

2. As the workpiece nears the end of the cut, release the push stick just before the blade, (see **Figure 123**).
3. Use steady downward and forward pressure to push the workpiece the rest of the way through the blade.

Making a Narrow-Rip Push Block for an Auxiliary Fence

1. Cut a piece of $\frac{1}{2}$ " thick plywood 6" by $39\frac{1}{2}$ ", and cut a piece of $\frac{3}{4}$ " thick hardwood 3" by $39\frac{1}{2}$ ", as shown in **Figure 124**.

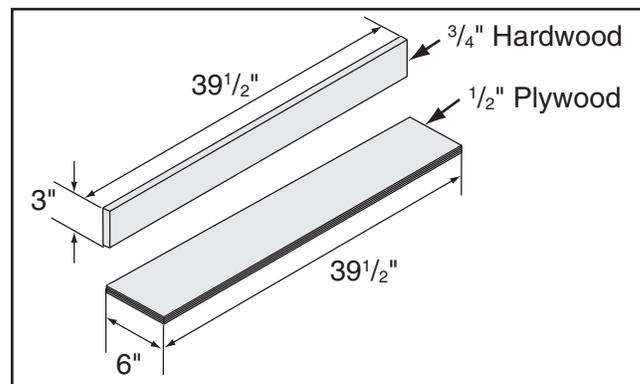


Figure 124. Auxiliary fence dimensions.

Note: We recommend cutting the hardwood board oversize, then jointing and planing it to the correct size to make sure the board is square and flat.

Only use furniture-grade plywood or kiln-dried hardwood to prevent warping.

2. Pre-drill and countersink eight pilot holes $\frac{3}{8}$ " in from the edge of the 6" wide board, as shown in **Figure 125**, for the wood screws that will attach the boards together in next step.

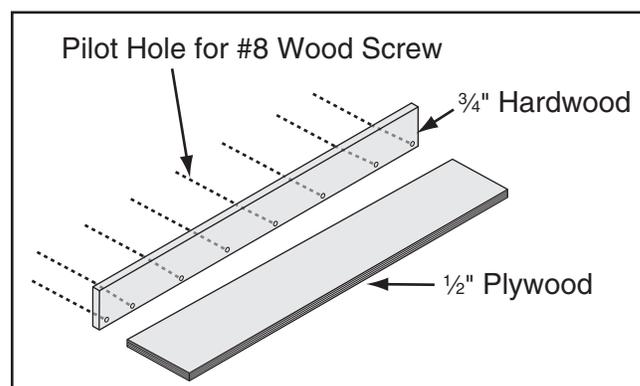


Figure 125. Location of pilot holes.



- Fasten the 6" and 3" wide boards with eight #6 x 1/4" wood screws through the holes you drilled in **Step 2**; the fence should look like the one shown in **Figure 126**.

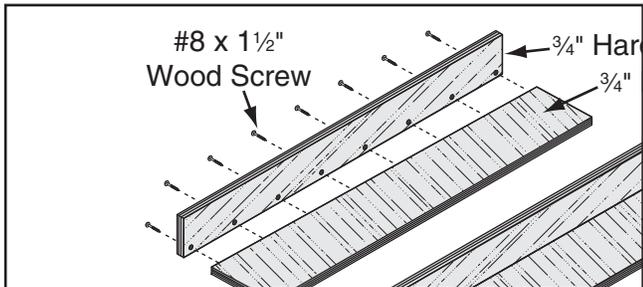


Figure 126. Auxiliary fence complete.

- Cut a piece of plywood 15" long and 5 1/4" wide for the base of a push block, then cut off a strip 3/8" wide by 12 1/2" long (see **Figure 127**).

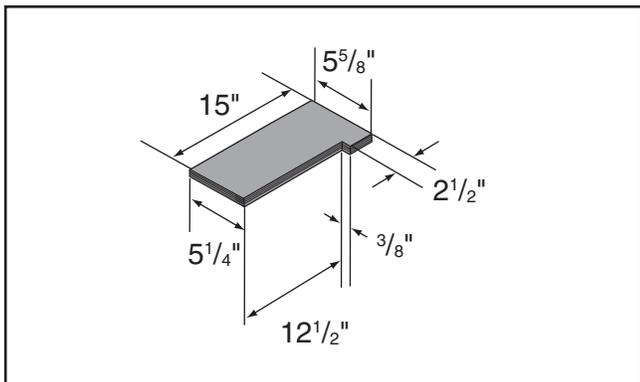


Figure 127. Push block base pattern.

- Cut a piece of 1/2" plywood 10" long by 5"-9" high for the handle, then cut it to the desired final shape.
- Pre-drill and countersink three holes through the bottom center of the base, then attach the handle to the base with #6 x 1/4" wood screws (see **Figure 128**).

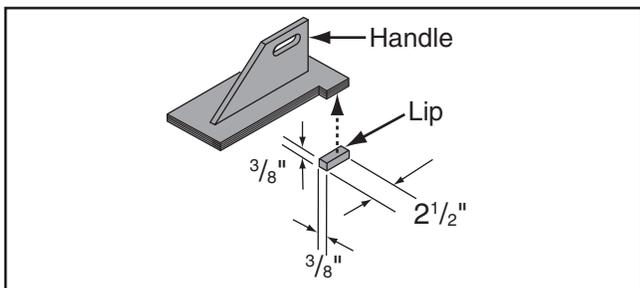


Figure 128. Push block and lip.

- Make a lip from scrap wood that is approximately 2 1/2 x 3/8 x 3/8", then fasten this piece to the bottom of the base, as shown in **Figure 128**.

Tip: Try using cyanoacrylate type wood glue or small wood screws to secure the lip to the push block base.

Using the Auxiliary Fence and Push Block

- Place the auxiliary fence on the table and clamp it to the fence at both ends, then adjust the distance between the auxiliary fence and the blade—this determines how wide the workpiece will be ripped (see the example in **Figure 129**).

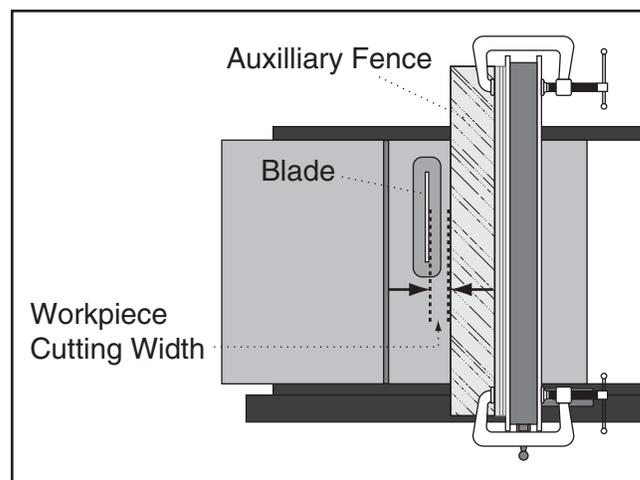


Figure 129. Example of adjusting ripping distance between blade and auxiliary fence.

⚠️ WARNING

Keep the riving knife and blade guard properly installed during cutting operations. Failure to do this present amputation hazards!



2. Place the workpiece 1" in front of the blade and evenly against the table and the auxiliary fence.

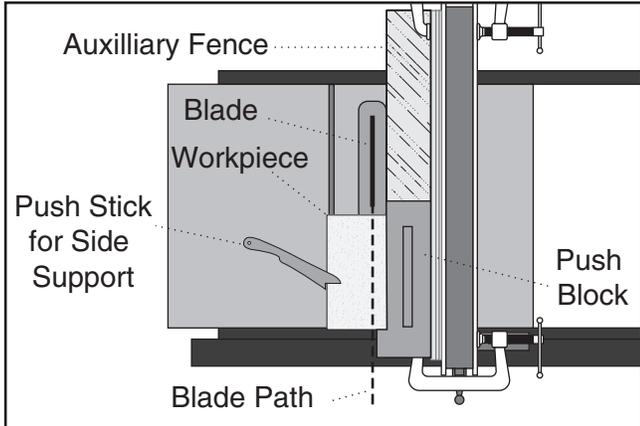


Figure 130. Push block in position to push workpiece through blade.

3. Turn the saw **ON**, then begin ripping the workpiece using a push stick for side support.

As the workpiece nears the end of the cut, place the push block on the auxiliary fence with the lip directly behind the workpiece, then release the push stick just before it is even with the blade (see the example in **Figure 131**).

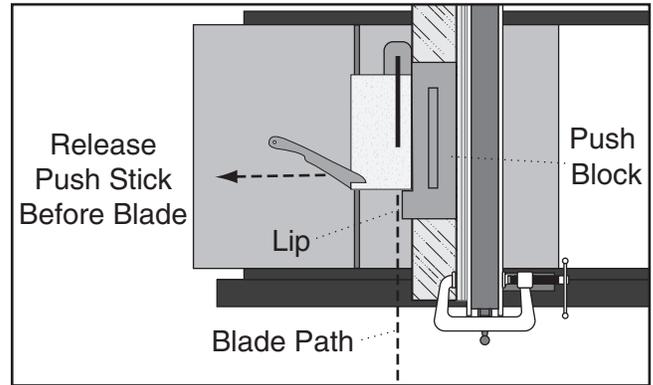


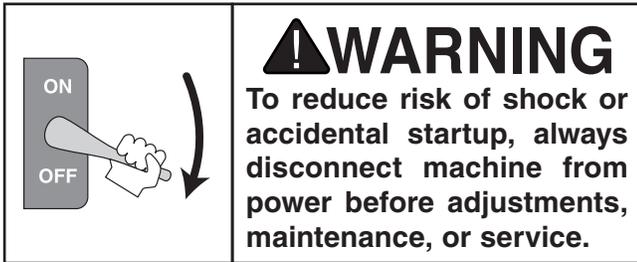
Figure 131. Example of ripping with push block.

! WARNING

Turn the saw **OFF** and allow the blade to come to a complete stop before removing the cut-off piece. Failure to follow this warning could result in serious personal injury.



SECTION 7: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Ongoing Check:

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

Weekly Maintenance:

- Clean sliding table surface and grooves
- Clean and lubricate sliding table ways (Page 69)
- Clean cast iron saw table
- Clean the rip fence assembly

Monthly Check:

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Every 6-12 Weeks:

- Lubricate tilt and elevation trunnions (Page 68)
- Lubricate tilt and elevation leadscrews (Page 69)

Cleaning

Cleaning the Model G0699 is relatively easy. 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 cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 59** for more details).



Lubrication

Other than the lubrication points covered in this section, all other bearings are internally lubricated and sealed at the factory. Simply leave them alone unless they need to be replaced.

Although it is not necessary to remove the table to complete the lubrication tasks for the trunnions and leadscrews, to do so makes it easier to access these areas for proper inspection, cleaning, and lubrication.

Important: Take care not to get any lubrication on the drive V-belts to prevent slippage and damage. If you do, replace them.

Removing Main Table

Tools Needed	Qty
Hex Wrench 4mm.....	1
Hex Wrench 6mm.....	1
Hex Wrench 8mm.....	1
Wrench 19mm	1
Wrench 24mm	1

To remove the table:

1. DISCONNECT SAW FROM POWER!
2. Remove the rip fence assembly, rip fence rail, rip fence scale, and both extensions wings from the cast iron table.
3. Move the sliding table all the way forward and vlock it in place.
4. Remove the four hex nuts and spacers from the bottom of the studs that secure the cast iron table to the cabinet (see **Figure 132**).

Important: The position of the four upper lock nuts were set at the factory so that the cast iron table is square with the saw blade from side to side and back to front. DO NOT change the position of these lock nuts (see **Figure 132**). Otherwise, you will have to perform the time consuming procedure of bringing the table back to square with the blade.

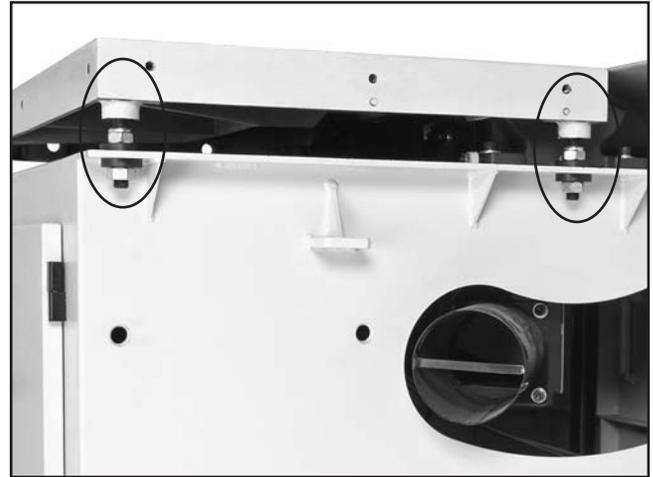


Figure 132. Main table mounting fasteners.

5. With the help of another person for lifting, remove the table from the cabinet and place it in a safe location.
6. Remove the four spacers from the top of the cabinet.

Trunnions

The tilt and elevation trunnions (see **Figure 133**) are curved cast iron surfaces that allow the heavy motors, arbor assemblies, and blades to tilt and change elevation.

It will be necessary to use the tilt and elevation handwheels to gain access to the full lengths of the trunnion sliding surfaces. Use mineral spirits and shop rags to clean away the grime and debris, then apply a thin coat of multi-purpose grease to the full length of the trunnions. Move the trunnions through their full range of movement several times to evenly distribute the grease.

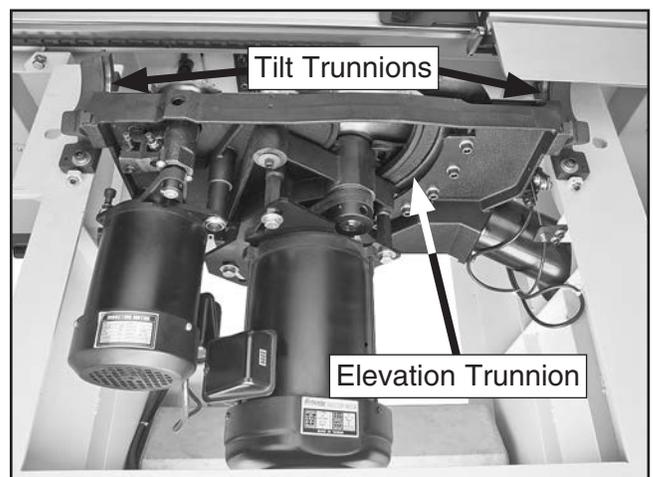


Figure 133. Locations of the trunnions.



Leadscrews

Use mineral spirits and shop rags to clean away grime and debris from the full lengths of the tilt and elevation leadscrews (see **Figures 134–135**). Then, apply a thin coat of light machine oil (see **Accessories on Page 59**) to their full lengths with a shop rag. Move the leadscrews through their full range of movement several times to evenly distribute the oil.

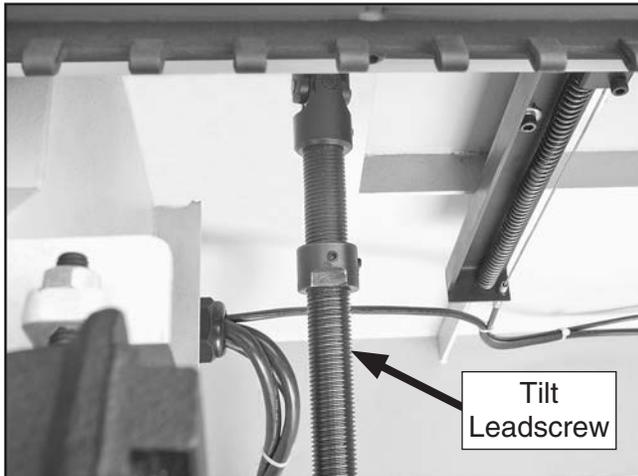


Figure 134. Tilt leadscrew (viewed through the gap between the sliding table and cabinet).

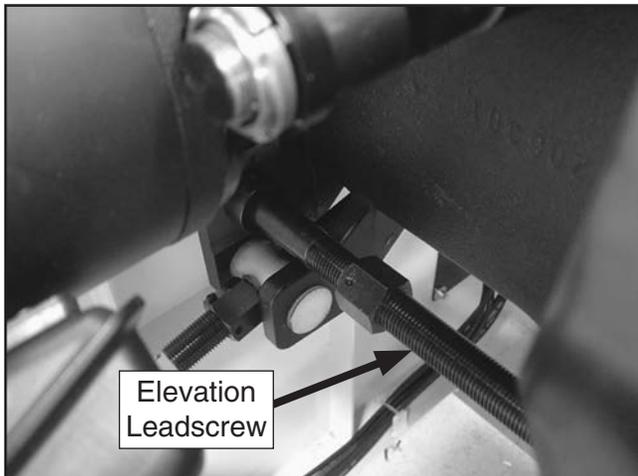


Figure 135. Elevation leadscrew (viewed from between the motors).

Sliding Table Ways

There are steel ways (see **Figure 136**) on both sides of the sliding table that fit between the top and the base and allow these parts to slide past each other. Clean the ways with mineral spirits and shop rags, then apply a thin coat of light machine oil with a shop rag. Move the sliding table through its full range of movement several times to evenly distribute the oil.

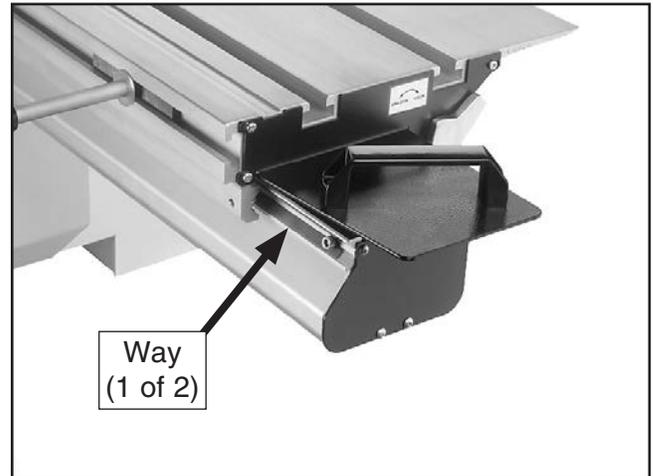


Figure 136. Sliding table way (1 of 2).

Replacing Main Table

Replace the main table in the reverse steps from which it was removed.

Before re-tightening the mounting hex nuts, use a straightedge to adjust the table position so that the leading edge of the blade gap is parallel to saw blade, as illustrated in **Figure 137**.

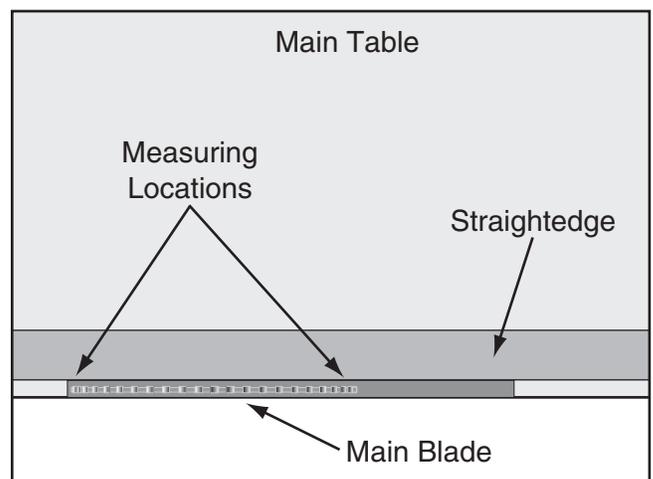


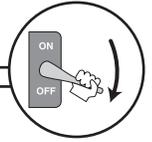
Figure 137. Measuring locations for squaring the main table to the blade.



SECTION 8: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. STOP push-button is engaged/faulty. 2. Power supply switched OFF or is at fault. 3. Blade cover limit switch engaged/at fault. 4. Motor connection wired incorrectly. 5. Thermal overload relay has tripped. 6. Wall fuse/circuit breaker is blown/tripped. 7. Contactor not getting energized/has burnt contacts. 8. Wiring is open/has high resistance. 9. Motor ON/OFF switch is at fault. 10. Motor is at fault. 	<ol style="list-style-type: none"> 1. Rotate clockwise slightly until it pops out/replace it. 2. Ensure power supply is switch on; ensure power supply has the correct voltage. 3. Move blade cover to the working position; replace faulty limit switch. 4. Correct motor wiring connections. 5. Turn amperage dial to 110% of motor full-load amperage and push the reset pin. Replace if tripped multiple times (weak relay). 6. Ensure circuit size is suitable for this machine; replace weak breaker; check wiring at machine. 7. Test for power on all legs and contactor operation. Replace unit if faulty. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Replace faulty ON/OFF switch. 10. Test/repair/replace.
Machine stalls or is overloaded.	<ol style="list-style-type: none"> 1. Feed rate/cutting speed too fast for task. 2. Workpiece material is not suitable for this machine. 3. Belt(s) slipping. 4. Motor connection is wired incorrectly. 5. Motor bearings are at fault. 6. Motor is at fault. 	<ol style="list-style-type: none"> 1. Decrease feed rate/cutting speed. 2. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece (see Page 46). 3. Replace bad belt (if V-belts, replace as matched set, align pulleys, and re-tension (see Page 72). 4. Correct motor wiring connections. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Test/repair/replace.



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component is loose. 2. Blade is at fault. 3. Belt(s) worn or loose. 4. Pulley is loose. 5. Motor mount loose/broken. 6. Machine is sits unevenly. 7. Arbor pulley is loose. 8. Motor fan is rubbing on fan cover. 9. Arbor bearings are at fault. 10. Motor bearings are at fault. 	<ol style="list-style-type: none"> 1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid. 2. Replace warped, bent, or twisted blade; resharpen dull blade. 3. Re-tension (see Page 72). Replace is necessary. 4. Realign/replace shaft, pulley, setscrew, and key as required. 5. Tighten/replace. 6. Relocate/shim machine. 7. Retighten/replace arbor pulley with shaft and thread locking liquid. 8. Reposition fan cover; replace if damaged; replace loose/damaged fan. 9. Replace arbor housing bearings; replace arbor. 10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
Main blade runs counterclockwise.	<ol style="list-style-type: none"> 1. Two of the incoming power wires are reversed. 	<ol style="list-style-type: none"> 1. Swap any two hot wires in the main power junction box (Page 15).

Operation

Symptom	Possible Cause	Possible Solution
Workpiece has burned edges, binds, or kicks back.	<ol style="list-style-type: none"> 1. Sliding table or rip fence is not parallel to blade. 2. Riving knife is not aligned with the blade. 3. Blade is warped or damaged. 	<ol style="list-style-type: none"> 1. Make sliding table or rip fence parallel to the blade (Pages 74 & 78). 2. Align riving knife with main blade (Page 48). 3. Replace the blade.
Workpiece has chip out on the bottom edge.	<ol style="list-style-type: none"> 1. Scoring blade kerf does not match the main blade. 	<ol style="list-style-type: none"> 1. Properly adjust the scoring blade to the main blade (Page 53).
Sliding table saw does not cut square.	<ol style="list-style-type: none"> 1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Crosscut fence is not perpendicular to the blade. 	<ol style="list-style-type: none"> 1. Make sliding table parallel to the blade (Page 74). 2. Adjust the rip fence parallel to blade (Page 29). 3. Adjust the 90° stop bolts so that the fence is perpendicular to the blade (Page 76).
Rip fence hits table top when sliding across table.	<ol style="list-style-type: none"> 1. Rip fence rail is too low. 2. Rip fence roller is too low. 	<ol style="list-style-type: none"> 1. Raise the rip fence rail (Page 78). 2. Adjust the rip fence roller (Page 78).
Blade does not reach 90°, or blade does not reach 45°.	<ol style="list-style-type: none"> 1. Blade stop bolts are out of adjustment. 	<ol style="list-style-type: none"> 1. Adjust the stop bolts (Page 73).
The rip fence scale is not accurate.	<ol style="list-style-type: none"> 1. The rip fence scale is out of calibration or was not set up correctly. 	<ol style="list-style-type: none"> 1. Adjust the rip fence scale (Page 78).
Tilt or elevation handwheels difficult to turn.	<ol style="list-style-type: none"> 1. Lock knob is tight. 2. Gears caked with dust. 	<ol style="list-style-type: none"> 1. Release the lock knob. 2. Clean out dust and grease the gears.



Belt Service

To ensure the efficient transfer of power from the motors to the blade arbors, the drive belts must be in good condition and properly tensioned. As the belts wear with normal use, they will stretch and need to be re-tensioned. If the belts show signs of cracking, fraying, or damage, replace them.

Although it is not necessary, removing the cast iron table from the cabinet could make most belt servicing tasks safer and easier. Refer to the **Removing Main Table** subsection on **Page 68** and the **Replacing Main Table** on **Page 69** for detailed instructions.

Note: Replace the main motor V-belts as a matched set so that they will wear evenly.

Main Motor V-Belts

1. DISCONNECT SAW FROM POWER!
2. Loosen the three mounting hex bolts shown in **Figure 138** to allow the motor to rotate.

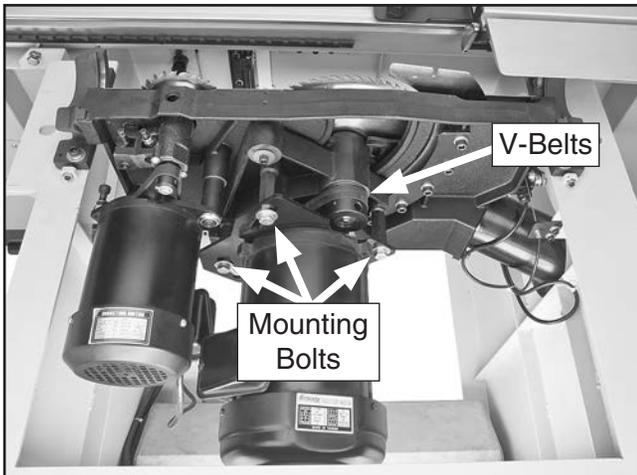


Figure 138. Locations of main motor mounting bolts (cast iron table removed).

3. If the V-belts need replacing, lift the motor up to release the tension, roll the old V-belts off the pulleys, then install the new V-belts as a matched set.
4. Adjust the motor until there is approximately $\frac{1}{4}$ " deflection when you use moderate pressure between the pulleys, as illustrated in **Figure 139**, then re-tighten the motor mounting bolts.

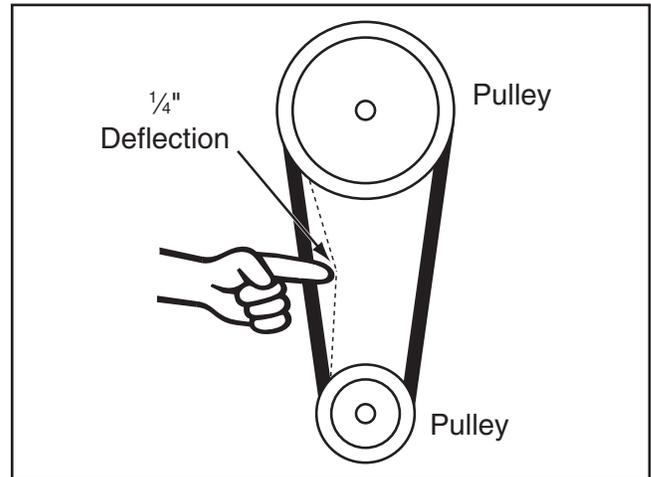


Figure 139. Testing for the correct amount of belt tension.



Scoring Motor Ribbed V-Belt

The scoring motor ribbed V-belt is automatically correctly tensioned by a spring that puts downward pressure on the motor.

To replace the scoring motor ribbed V-belt:

1. DISCONNECT SAW FROM POWER!
2. Lift up on the scoring motor, roll the old V-belt off the pulleys (see **Figure 140**).

Note: It takes considerable upward pressure against the spring to raise the motor.

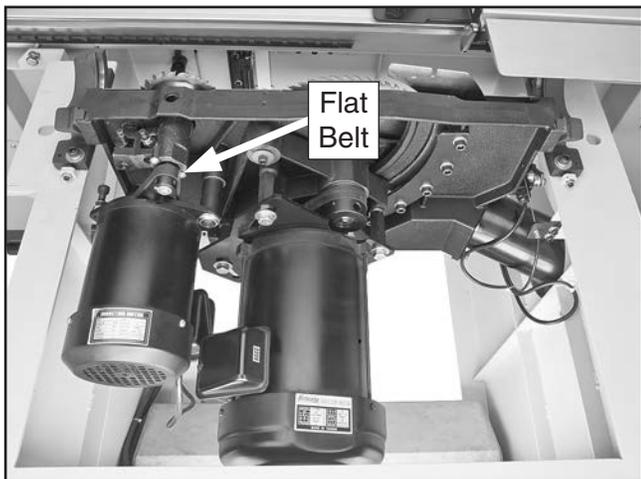


Figure 140. Scoring motor flat belt.

3. Make sure all of the ribs of the V-belt are seated in the grooves of the pulleys as you install the new V-belt.

Calibrating Blade Tilt

The blade tilt stop nuts were correctly calibrated at the factory, but can be re-calibrated if they change position during the life of the machine.

Tools Needed	Qty
Hex Wrench 2.5mm.....	1
90° Square	1
45° Square	1

To calibrate the tilt stop nuts:

1. DISCONNECT SAW FROM POWER!
2. Raise the main blade all the way up and tilt it all the way toward the 0° mark until it stops. This moves the leadscrew clamp up against the 0° stop nut and the blade perpendicular to the table.
3. Place the 90° square flat on the table and against the main blade.

—If the main blade is not 90° to the table, reach through the rear door, loosen the two set screws on the 0° tilt stop nut (see **Figure 141**), then adjust the stop nut until you can move the blade so that it is 90° to the table. Re-tighten the set screws on the stop nut.

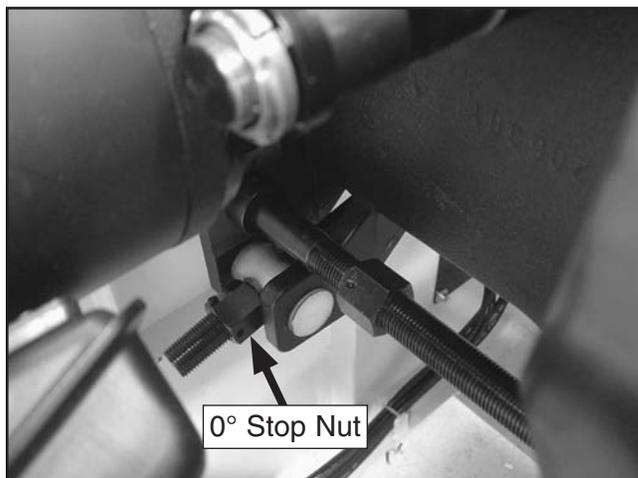


Figure 141. Tilt leadscrew 0° stop nut (viewed from between the motors).



4. Move the sliding table all the way forward and lock it in place.
5. Tilt the main blade all the way to the 45° mark, then place the 45° square against the blade and table.

—If the blade is not 45° to the table, reach through the gap between the main table and sliding table base (see **Figure 142**), loosen the two set screws on the 45° stop nut, then adjust the nut on the leadscrew until you can move the blade to be 45° to the main table. Re-tighten the set screws on the stop nut.

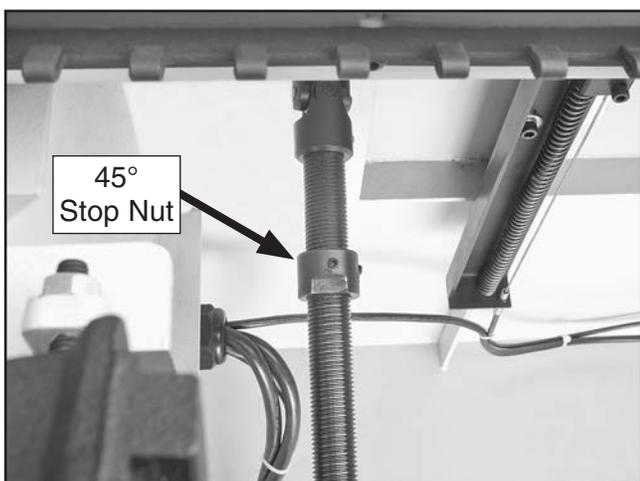


Figure 142. Tilt leadscrew 45° stop nut (viewed with main table removed for clarity).

Adjusting Sliding Table Parallelism

If the cuts are not square when using the sliding table, the table may not be parallel to the main blade. Making sure that the sliding table is parallel to the blade is necessary to ensure straight cutting operations and to prevent the workpiece from binding and kicking back.

Tools Needed	Qty
Felt Tip Pen	1
Adjustable Square	1
Wrench 17mm.....	1
Wrench 19mm	1

To check and adjust the sliding table parallelism:

1. DISCONNECT SAW FROM POWER!
2. Move the sliding table all the way back.
3. Move the main saw blade to 0° and raise it all the way up.
4. Use the felt tip pen to make a mark on the right blade edge that is even with the table.
5. Use the adjustable square to measure the distance from the sliding table T-slot and the main saw blade at the mark you made in **Step 4**. This is distance "A" shown in **Figure 143**.

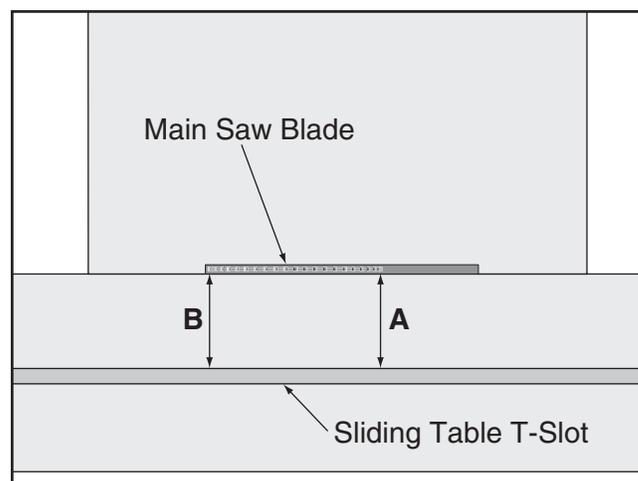


Figure 143. Measuring the distance between sliding table T-slot and main blade.



6. Move the sliding table all the way forward, rotate the saw blade so the mark you made in **Step 4** is at location "B", then take the measurement of "B".

—If the difference is equal to or less than 0.004" between the "A" and "B" measurements, the sliding table parallelism to the saw blade is acceptable and adjustment is necessary.

—If the difference between the "A" and "B" measurements is greater than 0.004", the sliding table parallel adjustment bolts need to be re-adjusted. Continue with the next step.

7. Loosen the three sliding table mounting hex nuts that hold the sliding table in place.

Note: Access two of the hex nuts by removing the access panels on both sides of the frame, and the middle hex nut through the 5" dust port gap in the cabinet side.

8. Loosen the jam nuts on the sliding table parallel adjustment bolts (see **Figure 144**) that are on both sides of the frame behind the sliding table, then adjust the bolts in or out in small increments to change the parallel relationship of the sliding table to the saw blade.

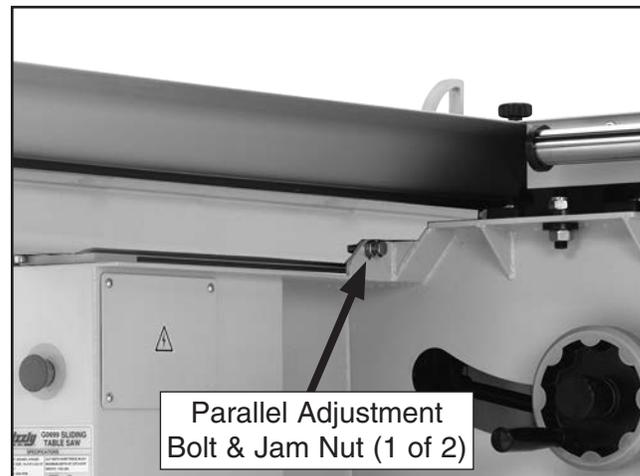


Figure 144. Sliding table parallel adjustment bolt (1 of 2).

9. Make sure the sliding table is up against the adjustment bolts, then repeat **Steps 5, 6** and **8** until the difference between the "A" and "B" measurements is acceptable.
10. Re-tighten the jam nuts on the adjustment bolts.
11. Make sure the sliding table is against both adjustment bolts, then re-tighten the mounting hex nuts to secure the table in place.



Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with this fence will be square. This procedure is done by using a piece of scrap plywood as a test piece and making five test cuts, then adjusting the 90° stop bolts on both ends of the crosscut table (see **Figure 145**).

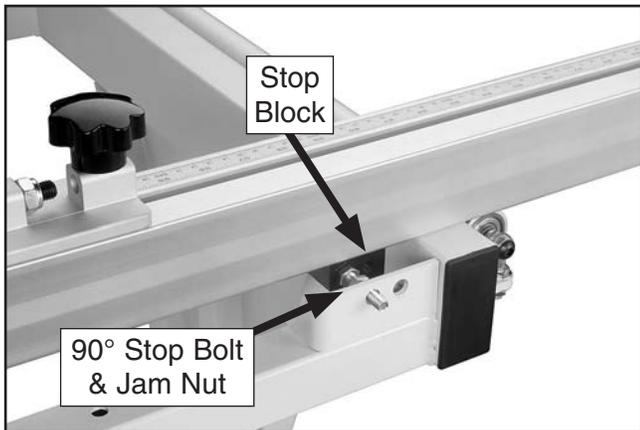


Figure 145. Crosscut fence stop block and 90° stop bolt.

Tool Needed	Qty
Wrench 13mm	1

To adjust the 90° stop bolts:

1. Make sure the sliding table is parallel to the main saw blade (see the **Sliding Table Parallel Adjustment** procedure on **Page 74** for detailed instructions).
2. Prepare the test piece by cutting it to a dimension of 32" x 32", then number all four sides, as illustrated in **Figure 146**.

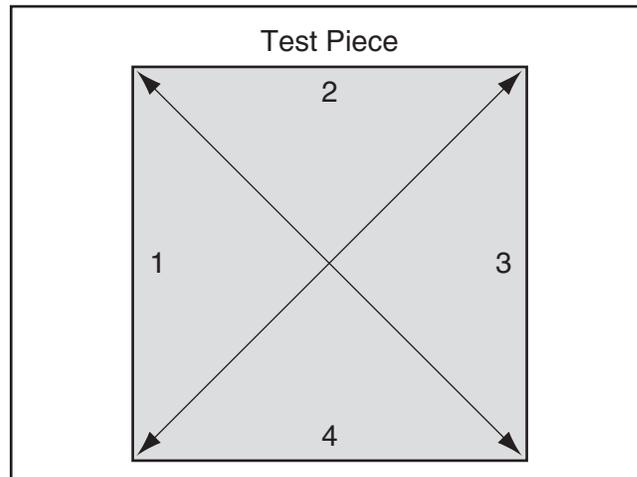


Figure 146. Crosscut fence adjustment test piece.

3. Move the crosscut fence stop block against one of the 90° stop bolts, then use the fence to cut 1/2" off each side of the test piece, then cut side 1 again—five cuts total.
4. Measure the test piece diagonally from corner to corner, as illustrated in **Figure 146**.

—If both measurements are within 1/16" of each other, then no further adjustments are necessary.

—If both measurements are not within 1/16" of each other, then the stop bolt needs to be adjusted. Proceed to the next step.

5. Loosen the 90° stop bolt jam nut, adjust the bolt in or out, repeat **Steps 3–4** until the diagonal measurements are within 1/16" of each other, then tighten the stop bolt jam nut.
6. Repeat **Steps 3–5** with the other 90° stop bolt.



Riving Knife Mounting Block

The riving knife must be aligned with the blade when installed. If the riving knife is not aligned with the blade, then the workpiece will be forced sideways during the cut, which will increase the risk of kickback.

The riving knife mounts to a block that can be repositioned to correctly align the riving knife to the blade. The mounting block adjusts by turning the set screws in each corner of the block. **Figure 147** shows the set screws associated with controlling the mounting block position. Have patience when adjusting the mounting block, because it requires trial-and-error to perform with accuracy.

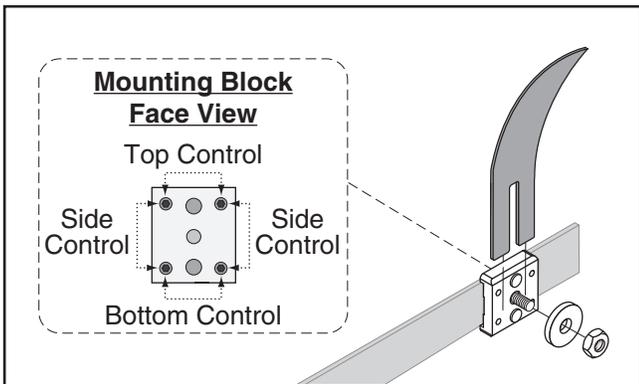


Figure 147. Riving knife mounting block adjustment controls.

All adjustment and alignment positions for the riving knife are covered on **Page 48** in the subsection **Riving Knife Installation & Removal**; the mounting block should not be adjusted unless you have been unable to mount the riving knife as instructed by these procedures.

Tools Needed	Qty
Straightedge	1
Wrench 19mm	1
Hex Wrench 4mm.....	1

To adjust riving knife mount block:

1. DISCONNECT MACHINE FROM POWER!
2. Raise blade guard and move it away from blade, then adjust blade tilt to 0° and raise blade all the way up.
3. Move sliding table all the way forward to expose blade cover, then lock it in place.
4. Open blade cover to gain access to riving knife mounting block.
5. Loosen hex nut that secures riving knife to mounting block, and remove riving knife.
6. Adjust each pair of set screws that controls the direction required to move mounting block so riving knife can be aligned with blade. Make sure to move both set screws in even increments.
7. Re-install riving knife and check alignment with blade. Repeat **Step 6** as necessary until riving knife is properly aligned with blade.

Note: *If you discover that riving knife is bent and cannot be properly aligned with the blade, it is possible to bend it into alignment, but make sure that the final result is precisely aligned so the risk of kickback is not increased. If the riving knife is bent, and you cannot easily bend it back into alignment, we recommend replacing it with a new one.*

8. Properly re-install riving knife as described on **Page 48**, close blade cover, properly reposition blade guard, and move sliding table back to center position.



Rip Fence Adjustments

There are three adjustments that affect the accuracy and operation of the rip fence: 1) Height above the table, 2) parallelism to the blade, and 3) rip fence scale position. If your cuts are not square when using the rip fence, check these adjustments.

Height Above Table

The rip fence and body should ride as close to the table surface as possible without touching it and with an even gap along the length. This is accomplished by adjusting the rip fence rail and the roller at the end of the fence body.

Tools Needed	Qty
Hex Wrench 2.5mm.....	1
Wrench 17mm.....	1
Wrench 19mm	1

To adjust rip fence height above the table:

1. Observe the gap between the fence body and the table along the entire length.

—If the near end of the fence body is too low, loosen the hex nuts that secure the rail, raise the rail until the fence body gap is even, then re-tighten the rail hex nuts.

—If the far end of the fence body is too low, pull the body up from the table to access wheel underneath. Loosen acorn nut (see **Figure 148**), adjust wheel position, retighten acorn nut, and place rip fence base back on table.

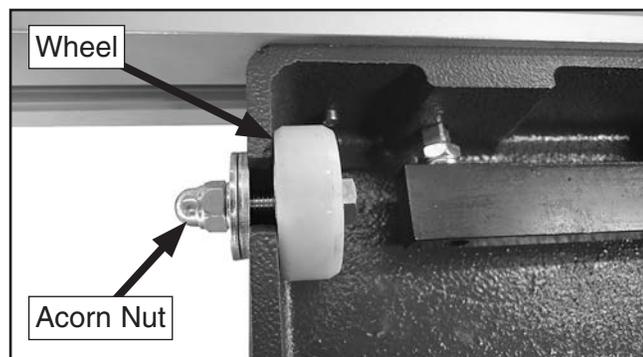


Figure 148. Rip fence body roller controls.

Parallelism To Blade

Tool Needed	Qty
Wrench 19mm	1

To adjust the rip fence parallel to the main blade:

1. DISCONNECT SAW FROM POWER!
2. Raise the main blade all the way up and bring the tilt to 0°.
3. Slide the rip fence against the main blade and check if it touches both ends of the blade evenly.

—If the rip fence does not touch both ends of the blade evenly, loosen the rail hex nuts and adjust one end in or out until the rip fence is parallel with the blade, then re-tighten the hex nuts.

Calibrating Rip Fence Scale

Tool Needed	Qty
Phillips Screwdriver #2	1

To calibrate the rip fence scale:

1. DISCONNECT SAW FROM POWER!
2. Make sure the rip fence is parallel to the main blade, then move it against the blade so that it just touches the teeth.
3. Observe the reading on the scale underneath the rip fence (see **Figure 149**).

—If the scale reading is not zero, loosen the screws that secure it to the table, adjust it so that it does read zero, then re-tighten the screws to secure the setting.

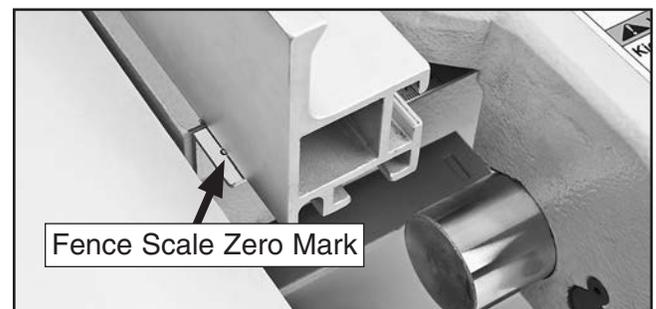


Figure 149. Rip fence scale zero mark.



SECTION 9: WIRING & ELECTRICAL

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. 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.

WARNING

Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

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

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

NOTICE

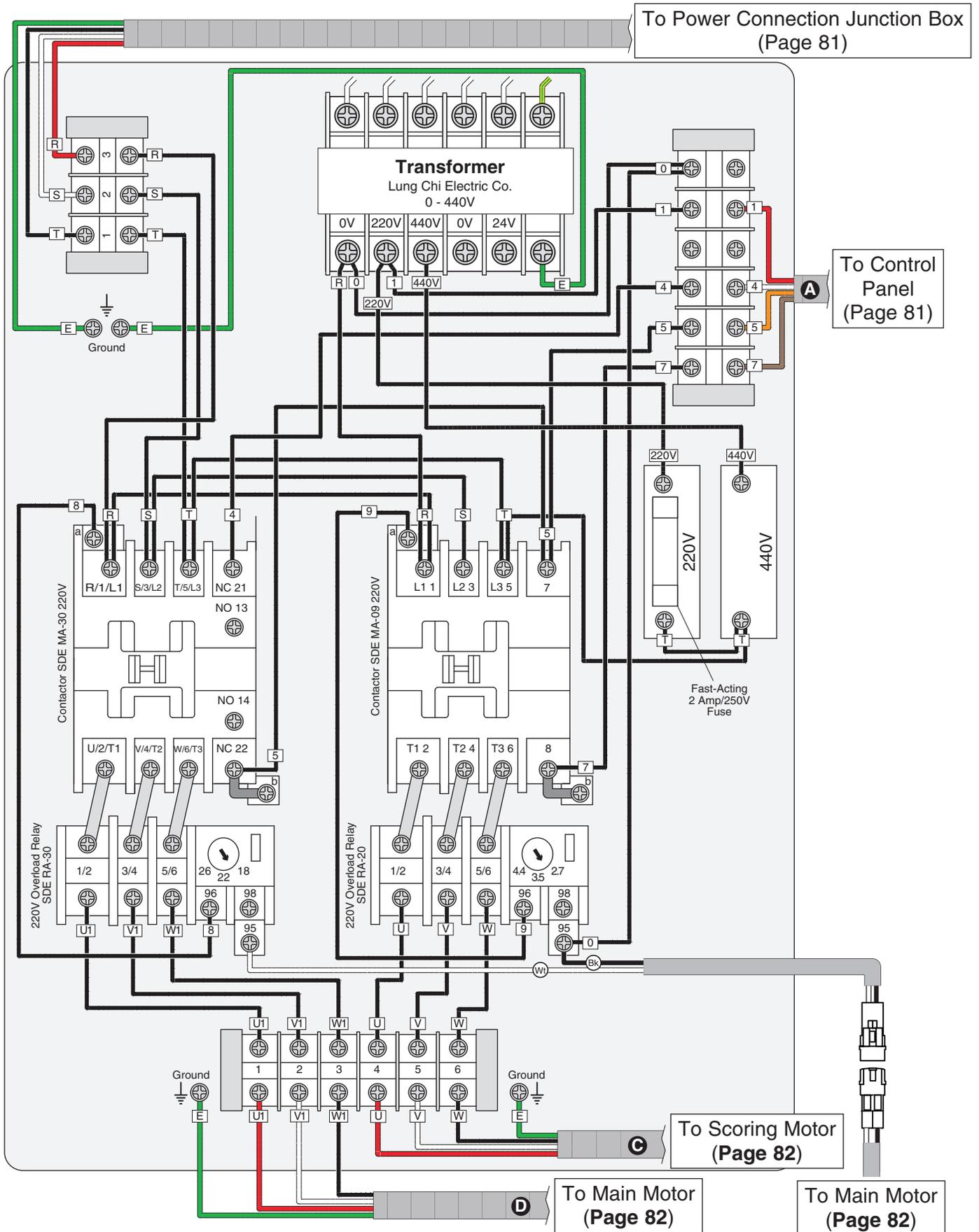
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

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

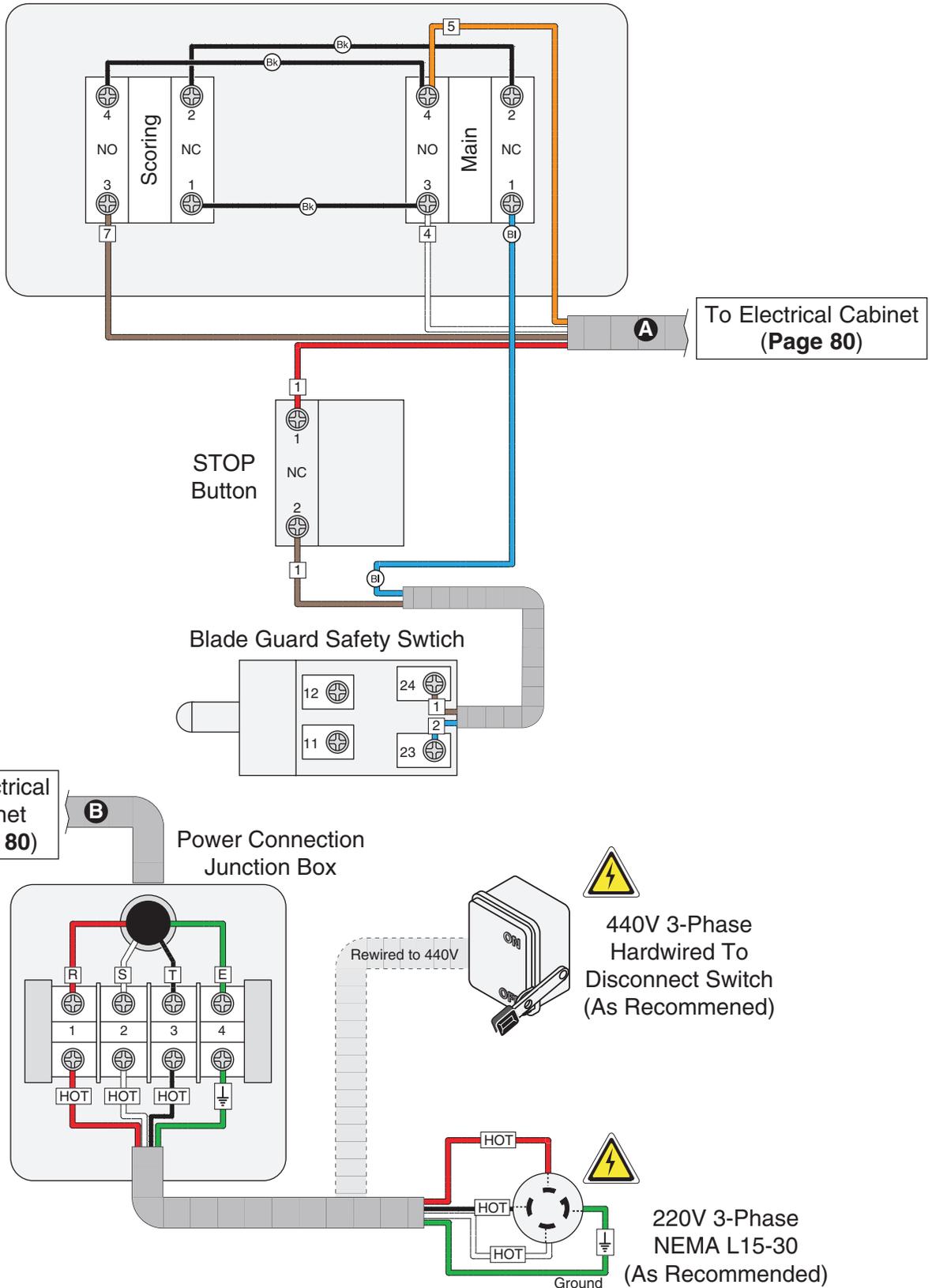


220V Electrical Cabinet Wiring Diagram



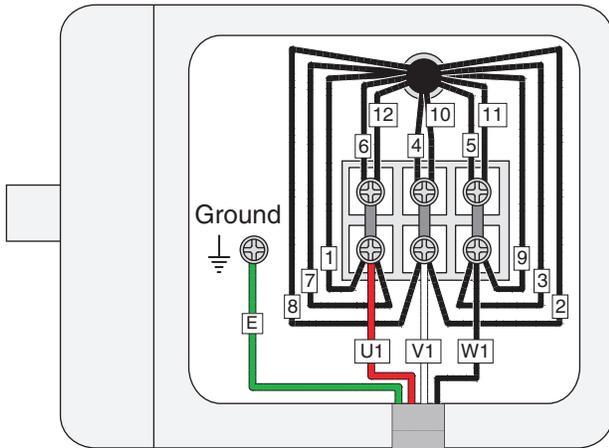
Component Wiring Diagrams

Control Panel
(Viewed From Behind)

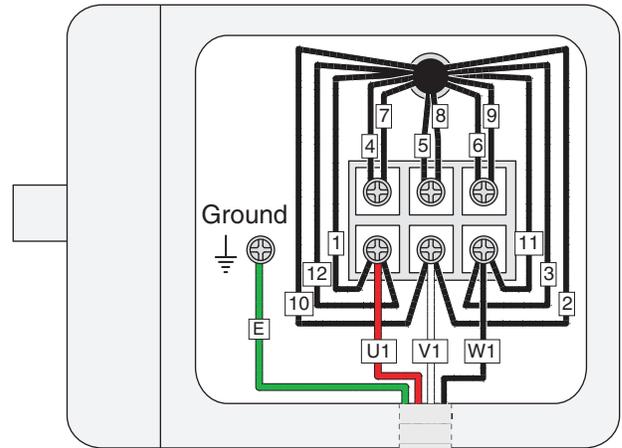


Main & Scoring Motor Wiring Diagrams

220V Main Motor



440V Main Motor

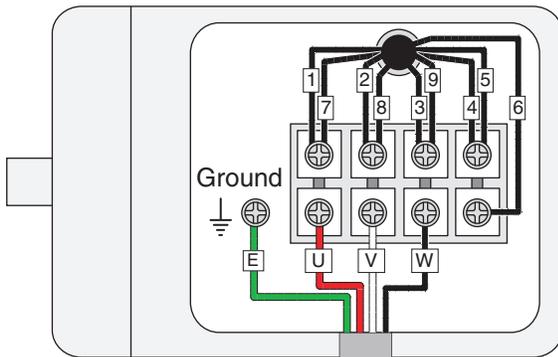


To Electrical Cabinet
(Page 80)

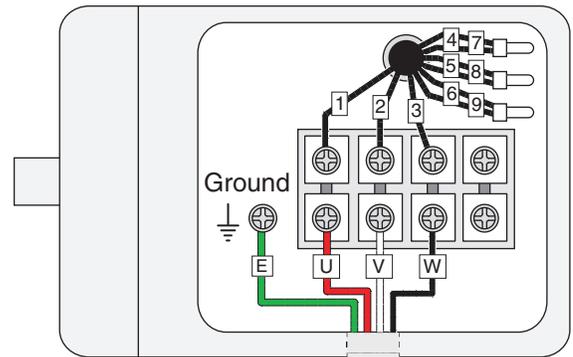
D

(Additional 440V Conversion Steps Required)

220V Scoring Motor



440V Scoring Motor



To Electrical Cabinet
(Page 80)

C

(Additional 440V Conversion Steps Required)



Electrical Component Photographs

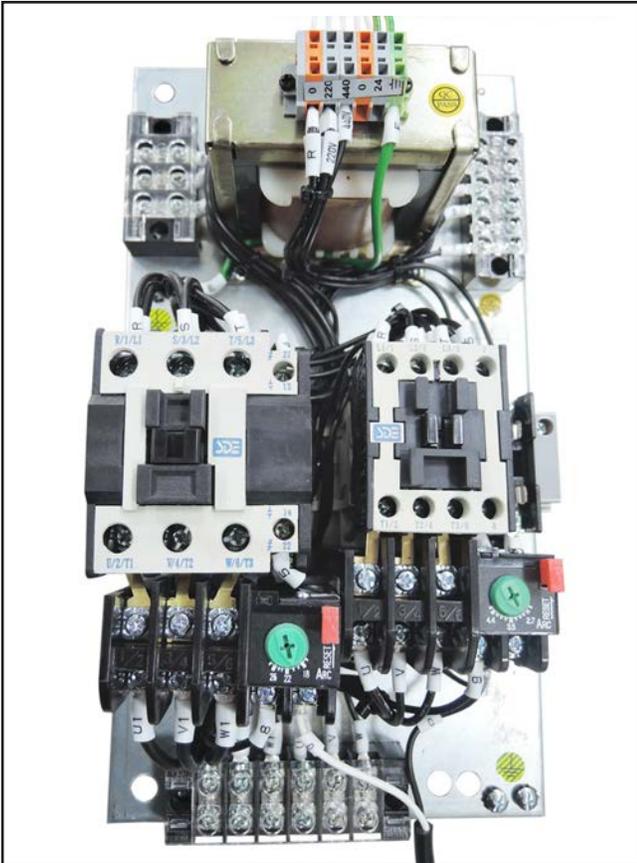


Figure 150. Electrical panel wiring.



Figure 152. Main motor wiring.



Figure 153. Scoring motor wiring.

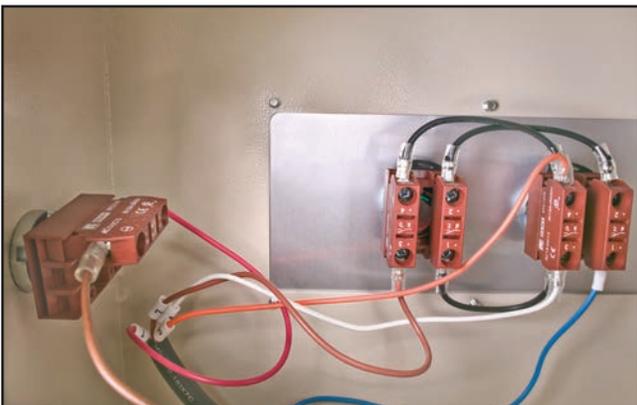


Figure 151. Control panel wiring.

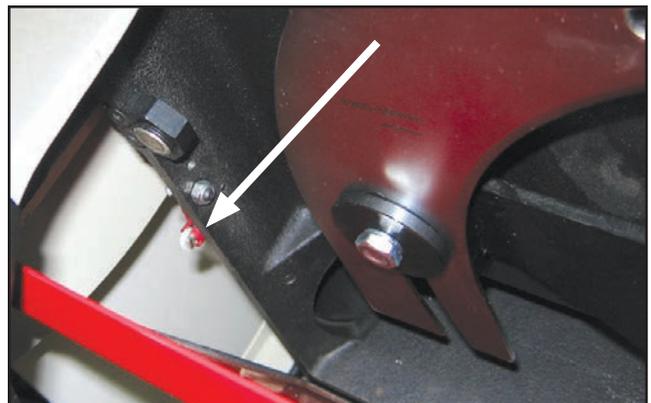
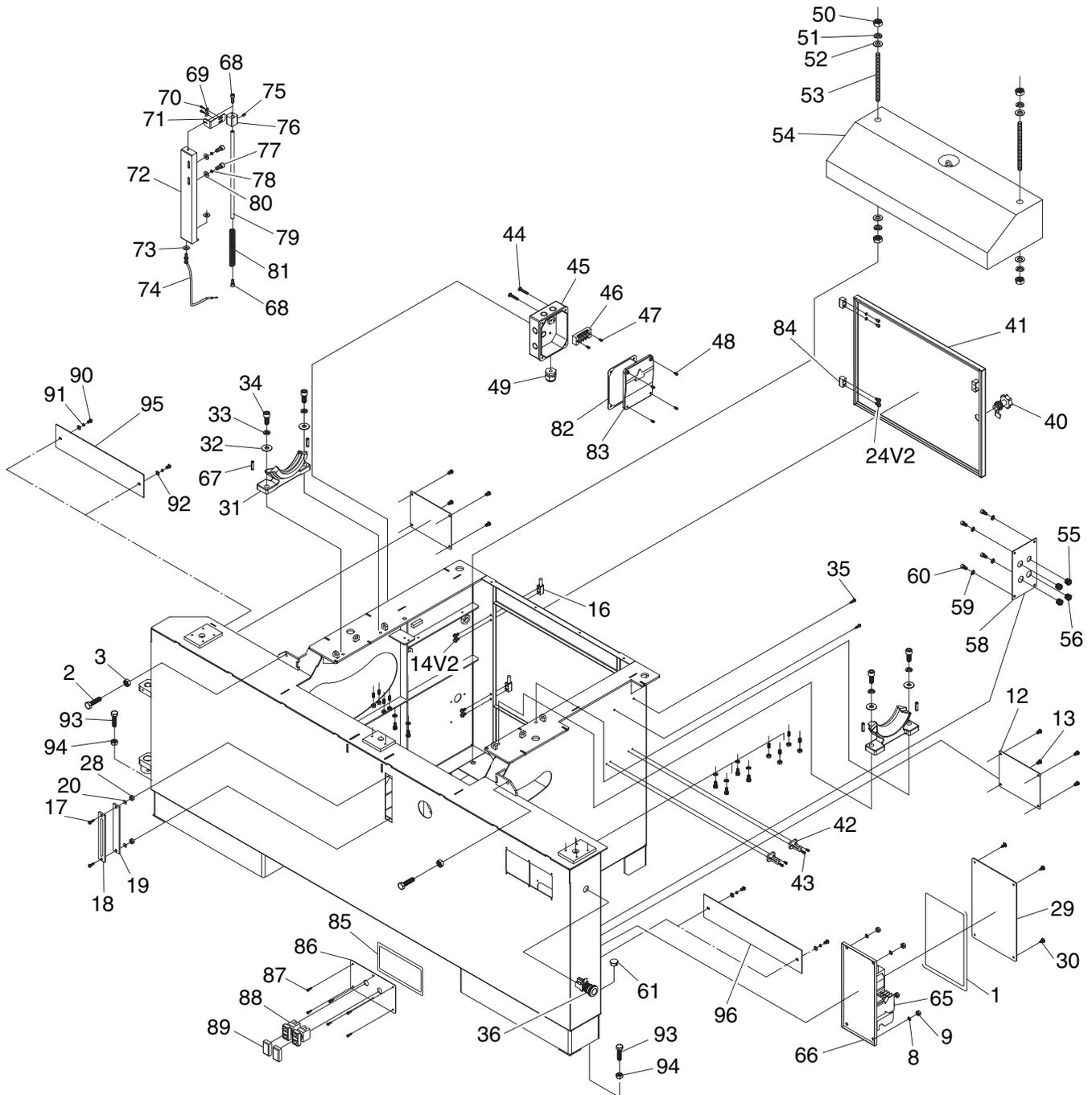


Figure 154. Blade guard safety switch.

SECTION 10: PARTS

Cabinet Body



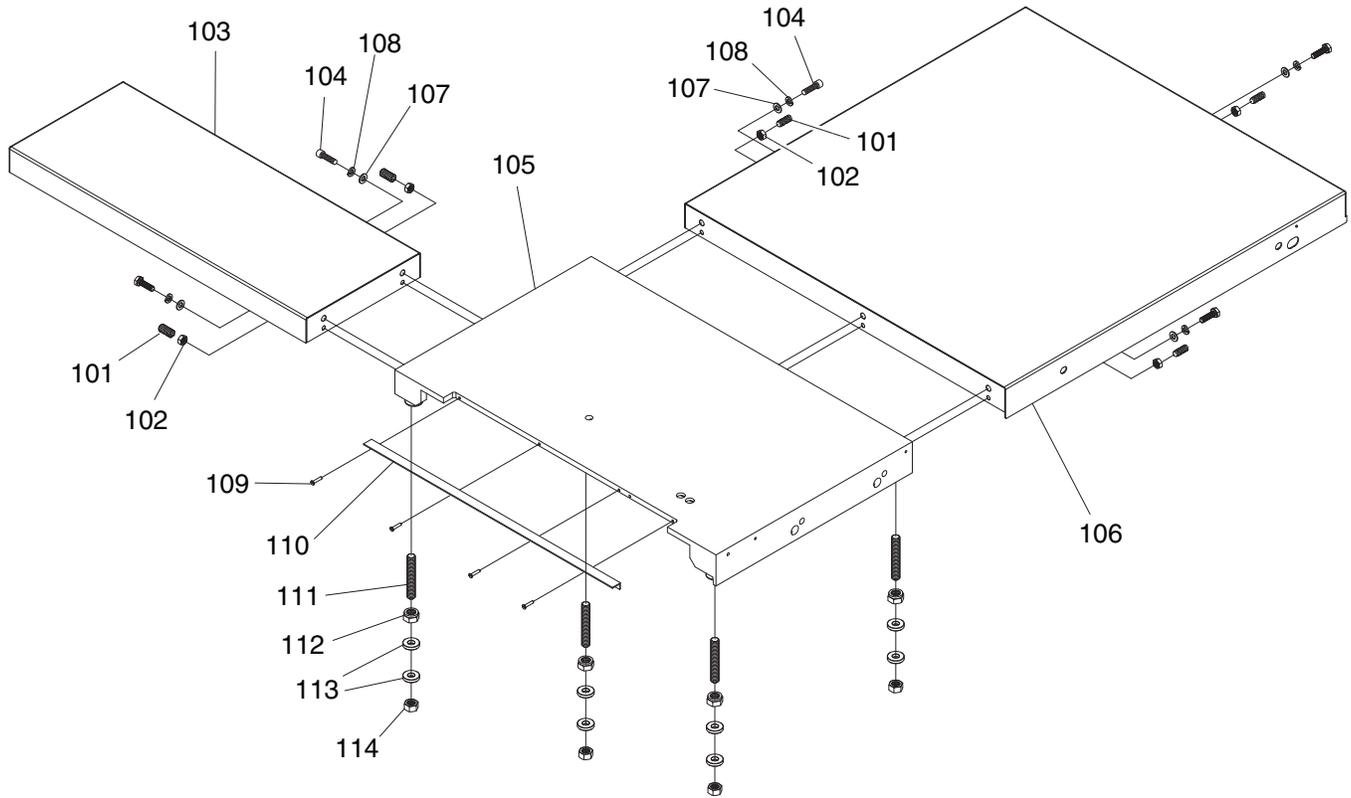
Cabinet Body Parts List

REF	PART #	DESCRIPTION
1	P06990001	ELECTRICAL PANEL GASKET
2	P06990002	HEX BOLT M10-1.5 X 40
3	P06990003	HEX NUT M10-1.5
8	P06990008	FLAT WASHER 6MM
9	P06990009	FLANGE NUT M6-1
12	P06990012	FRAME REAR ACCESS PANEL
13	P06990013	BUTTON HD CAP SCR M6-1 X 12
14V2	P06990014V2	FLANGE BOLT M5-.8 X 10
16	P06990016	DOOR HINGE W/BLOCK
17	P06990017	PHLP HD SCR M4-.7 X 20
18	P06990018	TILT SCALE COVER
19	P06990019	TILT SCALE
20	P06990020	FLAT WASHER 4MM
24V2	P06990024V2	FLANGE BOLT M5-.8 X 6
28	P06990028	HEX NUT M4-.7
29	P06990029	ELECTRICAL PANEL COVER
30	P06990030	BUTTON HD CAP SCR M6-1 X 10
31	P06990031	BLADE TILT TRUNNION
32	P06990032	FLAT WASHER 10MM
33	P06990033	LOCK WASHER 10MM
34	P06990034	CAP SCREW M10-1.5 X 35
35	P06990035	TAP SCREW M5 X 20
36	P06990036	STOP BUTTON
40	P06990040	DOOR LOCK
41	P06990041	DOOR
42	P06990042	HANGER
43	P06990043	TAP SCREW M5 X 20
44	P06990044	BUTTON HD CAP SCR M6-1 X 20
45	P06990045	JUNCTION BOX
46	P06990046	TERMINAL BLOCK 4P
47	P06990047	PHLP HD SCR M5-.8 X 8
48	P06990048	BUTTON HD CAP SCR M5-.8 X 12
49	P06990049	STRAIN RELIEF M20 TYPE-6 ST
50	P06990050	HEX NUT M12-1.75
51	P06990051	LOCK WASHER 12MM
52	P06990052	FLAT WASHER 12MM
53	P06990053	ALL-THREAD STUD M12-1.75 X 185
54	P06990054	CONCRETE BLOCK

REF	PART #	DESCRIPTION
55	P06990055	STRAIN RELIEF M16 TYPE-6 ST
56	P06990056	STRAIN RELIEF M20 TYPE-6 ST
58	P06990058	CORD PLATE
59	P06990059	LOCK WASHER 6MM
60	P06990060	CAP SCREW M6-1 X 12
61	P06990061	PLUG
65	P06990065	ELECTRICAL PANEL ASSEMBLY
66	P06990066	ELECTRICAL BACK PANEL
67	P06990067	ROLL PIN 6 X 25
68	P06990068	CAP SCREW M5-.8 X 10
69	P06990069	FLAT WASHER 5MM
70	P06990070	PHLP HD SCR M5-.8 X 10
71	P06990071	POINTER
72	P06990072	TILT SCALE BRACKET
73	P06990073	FLAT WASHER 6MM
74	P06990074	STEEL WIRE
75	P06990075	SET SCREW M5-.8 X 10
76	P06990076	POINTER BRACKET
77	P06990077	CAP SCREW M6-1 X 12
78	P06990078	LOCK WASHER 6MM
79	P06990079	SHAFT
80	P06990080	FLAT WASHER 6MM
81	P06990081	COMPRESSION SPRING
82	P06990082	JUNCTION BOX GASKET
83	P06990083	JUNCTION BOX COVER
84	P06990084	DOOR HINGE W/BLOCK
85	P06990085	CONTROL PANEL GASKET
86	P06990086	CONTROL PANEL
87	P06990087	BUTTON HD CAP SCR M5-.8 X 10
88	P06990088	ON/OFF BUTTON SWITCH
89	P06990089	BUTTON SWITCH DUST COVER
90	P06990090	BUTTON HD CAP SCR M6-1 X 10
91	P06990091	LOCK WASHER 6MM
92	P06990092	FLAT WASHER 6MM
93	P06990093	HEX BOLT M16-2 X 50
94	P06990094	HEX NUT M16-2
95	P06990095	LEFT BOTTOM CABINET PANEL
96	P06990096	RIGHT BOTTOM CABINET PANEL



Tables

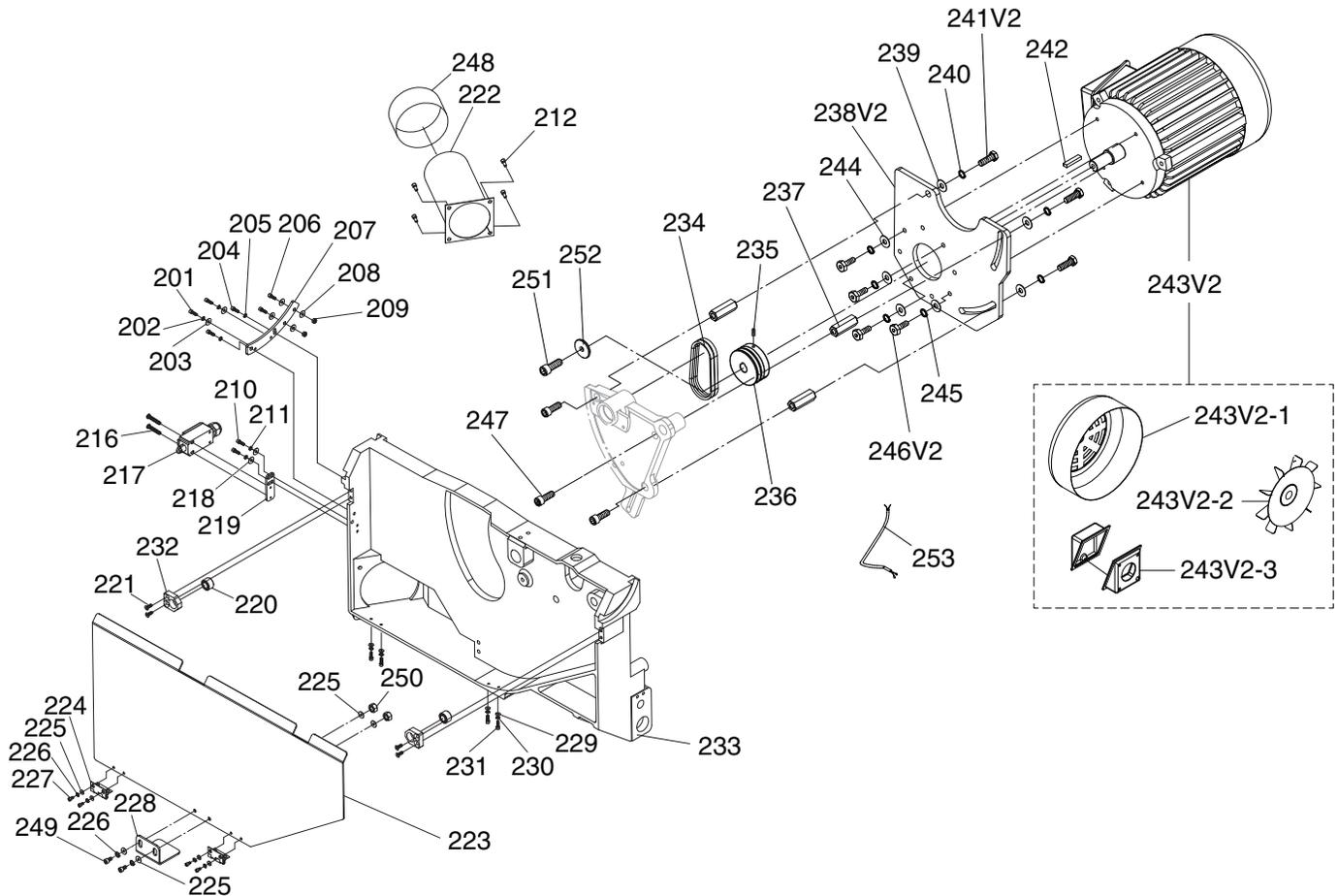


REF	PART #	DESCRIPTION
101	P06990101	SET SCREW M10-1.5 X 20
102	P06990102	HEX NUT M10-1.5
103	P06990103	LEFT EXTENSION WING
104	P06990104	CAP SCREW M10-1.5 X 25
105	P06990105	SAW TABLE
106	P06990106	REAR EXTENSION WING
107	P06990107	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
108	P06990108	LOCK WASHER 10MM
109	P06990109	BUTTON HD CAP SCR M6-1 X 12
110	P06990110	SAW TABLE ANGLE INSERT
111	P06990111	ALL-THREAD STUD M16-2 X 100
112	P06990112	LOCK NUT M16-2
113	P06990113	TABLE MOUNT SPACER 16MM
114	P06990114	HEX NUT M16-2



Main Blade Trunnion & Motor

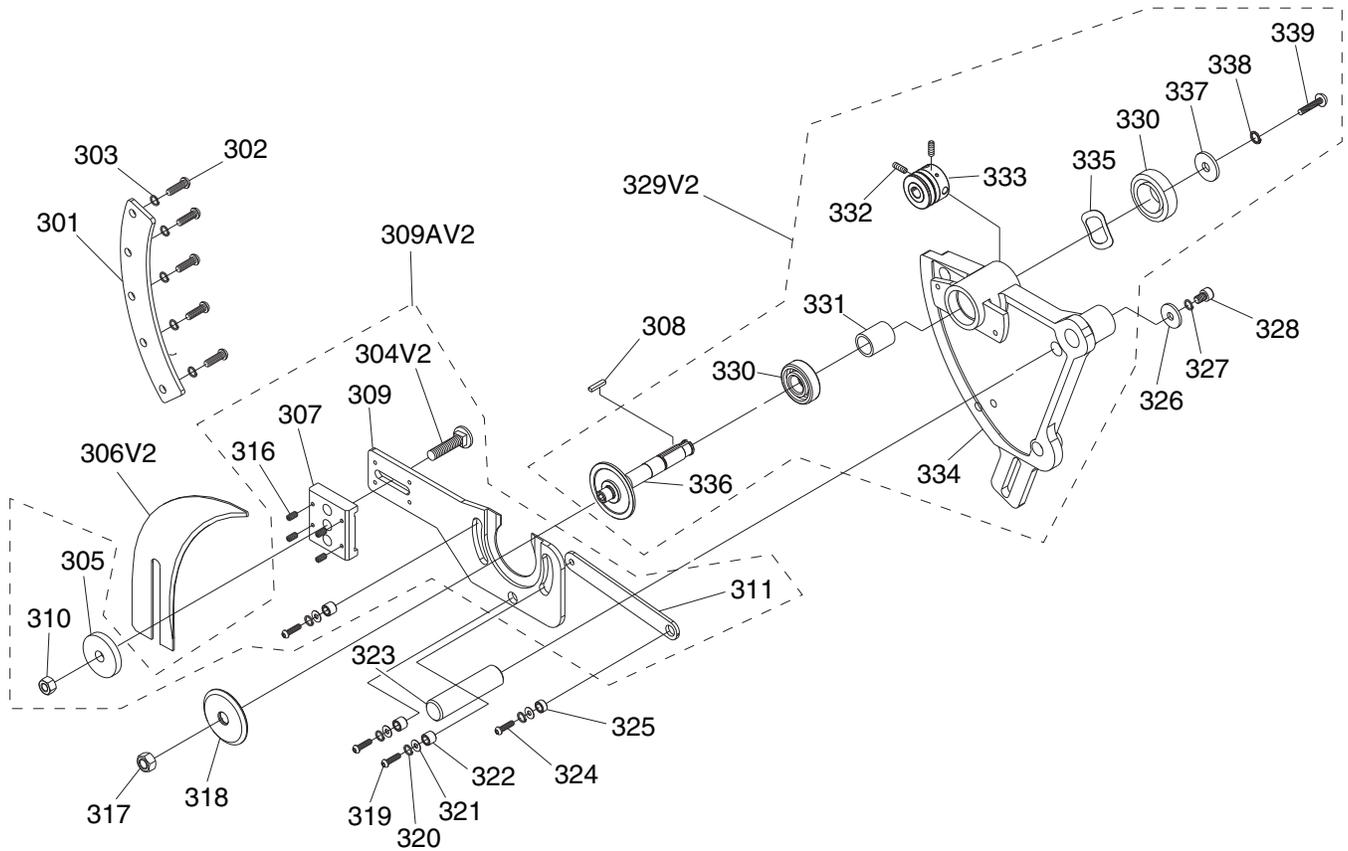


REF	PART #	DESCRIPTION
201	P06990201	CAP SCREW M5-.8 X 8
202	P06990202	LOCK WASHER 5MM
203	P06990203	FLAT WASHER 5MM
204	P06990204	CAP SCREW M6-1 X 12
205	P06990205	LOCK WASHER 6MM
206	P06990206	CAP SCREW M5-.8 X 16
207	P06990207	ANGLE PLATE
208	P06990208	FLAT WASHER 5MM
209	P06990209	LOCK NUT M5-.8
210	P06990210	CAP SCREW M5-.8 X 12
211	P06990211	LOCK WASHER 5MM
212	P06990212	CAP SCREW M8-1.25 X 12
216	P06990216	PHLP HD SCR M4-.7 X 35
217	P06990217	BLADE COVER SAFETY SWITCH
218	P06990218	FLAT WASHER 5MM
219	P06990219	SWITCH BRACKET
220	P06990220	BLADE COVER MAGNET
221	P06990221	FLAT HD CAP SCR M6-1 X 20
222	P06990222	DUST PORT
223	P06990223	BLADE COVER
224	P06990224	BLADE COVER DOOR HINGE
225	P06990225	FLAT WASHER 5MM
226	P06990226	LOCK WASHER 5MM
227	P06990227	CAP SCREW M5-.8 X 8
228	P06990228	HINGE BRACKET
229	P06990229	FLAT WASHER 5MM
230	P06990230	LOCK WASHER 5MM

REF	PART #	DESCRIPTION
231	P06990231	CAP SCREW M5-.8 X 10
232	P06990232	MAGNET HOLDER
233	P06990233	ELEVATION TRUNNION
234	P06990234	V-BELT 3VX-250
235	P06990235	SET SCREW M8-1.25 X 10
236	P06990236	MAIN BLADE MOTOR PULLEY
237	P06990237	SPACER
238V2	P06990238V2	MAIN BLADE MOUNTING PLATE V2.06.15
239	P06990239	MOTOR MOUNT FLAT WASHER 12MM
240	P06990240	LOCK WASHER 12MM
241V2	P06990241V2	HEX BOLT M12-1.75 X 35 V2.06.15
242	P06990242	KEY 8 X 7 X 40
243V2	P06990243V2	MAIN MOTOR 7-1/2HP 220/440V 3-PH V2.06.15
243V2-1	P06990243V2-1	MAIN MOTOR FAN COVER V2.06.15
243V2-2	P06990243V2-2	MAIN MOTOR FAN V2.06.15
243V2-3	P06990243V2-3	MAIN MOTOR JUNCTION BOX V2.06.15
244	P06990244	FLAT WASHER 8MM
245	P06990245	LOCK WASHER 8MM
246V2	P06990246V2	HEX BOLT M8-1.25 X 25 V2.06.15
247	P06990247	CAP SCREW M12-1.75 X 30
248	P06990248	DUST PORT CAP
249	P06990249	CAP SCREW M5-.8 X 16
250	P06990250	HEX NUT M5-.8
251	P06990251	CAP SCREW M10-1.5 X 20 (LH)
252	P06990252	FLAT WASHER 10MM
253	P06990253	THERMOSTAT WIRING



Main Blade Arbor

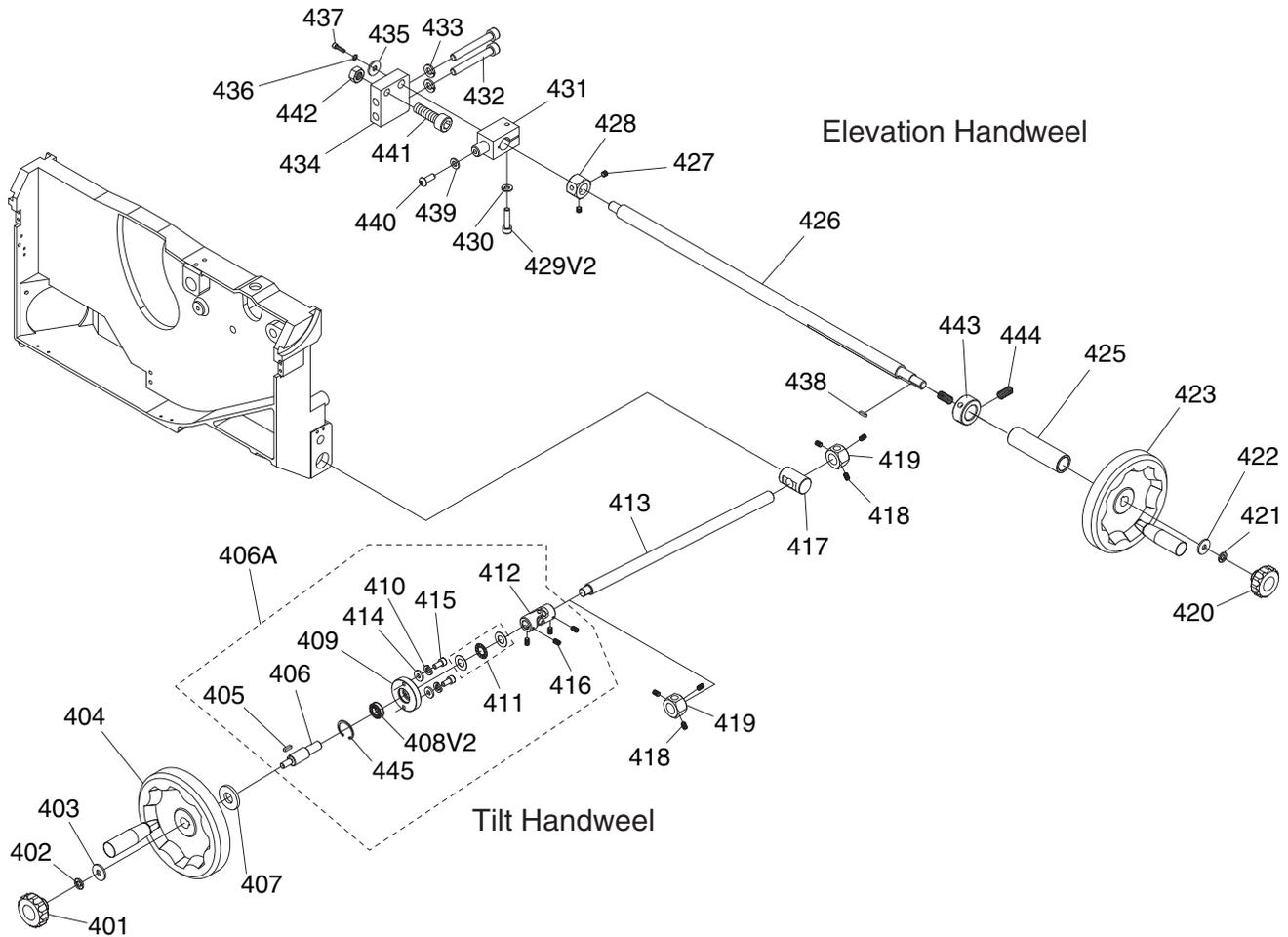


REF	PART #	DESCRIPTION
301	P06990301	GIB
302	P06990302	BUTTON HD CAP SCR M10-1.5 X 25
303	P06990303	LOCK WASHER 10MM
304V2	P06990304V2	CARRIAGE BOLT M10-1.5 X 35 V2.10.12
305	P06990305	RIVING KNIFE FLAT WASHER 10MM
306V2	P06990306V2	RIVING KNIFE V2.10.16
307	P06990307	FRONT RIVING KNIFE BRACKET
308	P06990308	KEY 5 X 5 X 20
309AV2	P06990309AV2	RIVING KNIFE BRACKET ASSY V2.11.12
309	P06990309	BRACKET
310	P06990310	HEX NUT M10-1.5
311	P06990311	PIVOT LINK
316	P06990316	SET SCREW M5-.8 X 10
317	P06990317	HEX NUT M16-2
318	P06990318	MAIN BLADE ARBOR FLANGE
319	P06990319	BUTTON HD CAP SCR M8-1.25 X 20
320	P06990320	LOCK WASHER 8MM
321	P06990321	FLAT WASHER 8MM

REF	PART #	DESCRIPTION
322	P06990322	BUSHING
323	P06990323	ARBOR HOUSING PIVOT SHAFT
324	P06990324	BUTTON HD CAP SCR M8-1.25 X 20
325	P06990325	BUSHING
326	P06990326	PIVOT SHAFT FLAT WASHER
327	P06990327	LOCK WASHER 8MM
328	P06990328	CAP SCREW M8-1.25 X 20
329V2	P06990329V2	ARBOR-HOUSING ASSEMBLY V2.05.11
330	P06990330	BALL BEARING 6206 LLB
331	P06990331	SPACER
332	P06990332	SET SCREW M6-1 X 8
333	P06990333	ARBOR PULLEY
334	P06990334	ARBOR HOUSING
335	P06990335	WAVE WASHER
336	P06990336	MAIN BLADE ARBOR
337	P06990337	FLAT WASHER 8MM
338	P06990338	LOCK WASHER 8MM
339	P06990339	BUTTON HD CAP SCR M8-1.25 X 20



Tilt & Elevation Handwheels

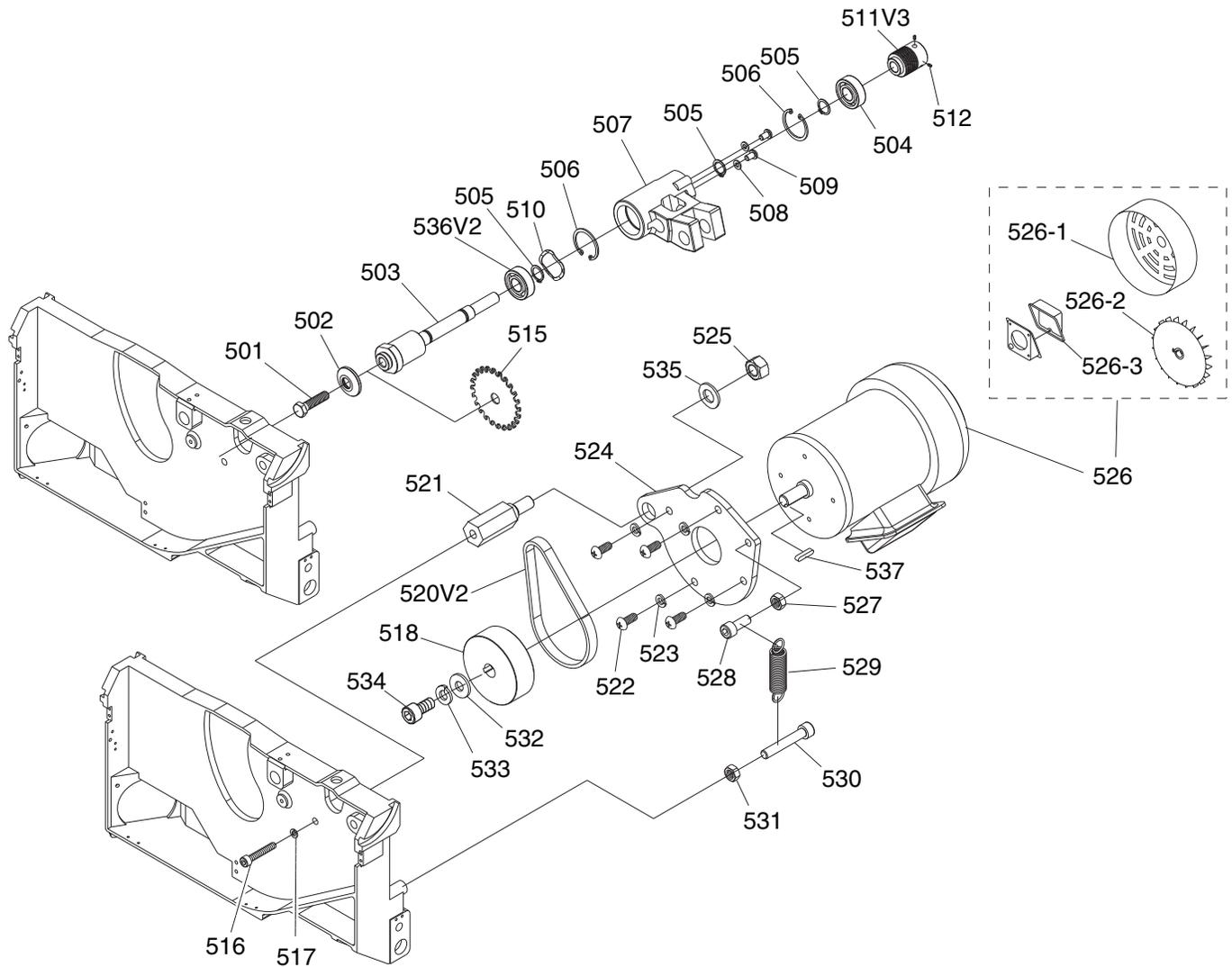


REF	PART #	DESCRIPTION
401	P06990401	LOCK KNOB M10-1.5
402	P06990402	FLAT WASHER 10MM
403	P06990403	HANDWHEEL FLAT WASHER 10MM
404	P06990404	TILT HANDWHEEL ASSEMBLY
405	P06990405	KEY 7 X 7 X 20
406A	P06990406A	HANDWHEEL SHAFT ASSEMBLY
406	P06990406	HANDWHEEL SHAFT
407	P06990407	BEARING WASHER
408V2	P06990408V2	BALL BEARING 6902-2RS V2.11.13
409	P06990409	BEARING SEAT
410	P06990410	LOCK WASHER 8MM
411	P06990411	THRUST BEARING NTB1528 AS
412	P06990412	UNIVERSAL JOINT
413	P06990413	TILT LEADSCREW
414	P06990414	FLAT WASHER 8MM
415	P06990415	CAP SCREW M8-1.25 X 20
416	P06990416	SET SCREW M6-1 X 6
417	P06990417	TRUNNION CONNECTOR
418	P06990418	SET SCREW M6-1 X 6
419	P06990419	TILT LEADSCREW NUT
420	P06990420	LOCK KNOB M10-1.5
421	P06990421	FLAT WASHER 10MM
422	P06990422	HANDWHEEL FLAT WASHER 10MM

REF	PART #	DESCRIPTION
423	P06990423	ELEVATION HANDWHEEL ASSEMBLY
425	P06990425	LEADSCREW SLEEVE
426	P06990426	ELEVATION LEADSCREW
427	P06990427	SET SCREW M6-1 X 6
428	P06990428	ELEVATION LEADSCREW NUT
429V2	P06990429V2	CAP SCREW M6-1 X 30 V2.09.13
430	P06990430	LOCK WASHER 6MM
431	P06990431	ELEVATION LEADSCREW CLAMP
432	P06990432	CAP SCREW M8-1.25 X 60
433	P06990433	LOCK WASHER 8MM
434	P06990434	LEADSCREW BRACKET
435	P06990435	FLAT WASHER 6MM
436	P06990436	LOCK WASHER 6MM
437	P06990437	CAP SCREW M6-1 X 12
438	P06990438	KEY 5 X 5 X 20
439	P06990439	FLAT WASHER 6MM
440	P06990440	CAP SCREW M6-1 X 10
441	P06990441	CAP SCREW M10-1.5 X 35
442	P06990442	HEX NUT M10-1.5
443	P06990443	LOCK COLLAR
444	P06990444	SET SCREW M8-1.25 X 10
445	P06990445	EXT RETAINING RING 28MM



Scoring Blade Arbor & Motor

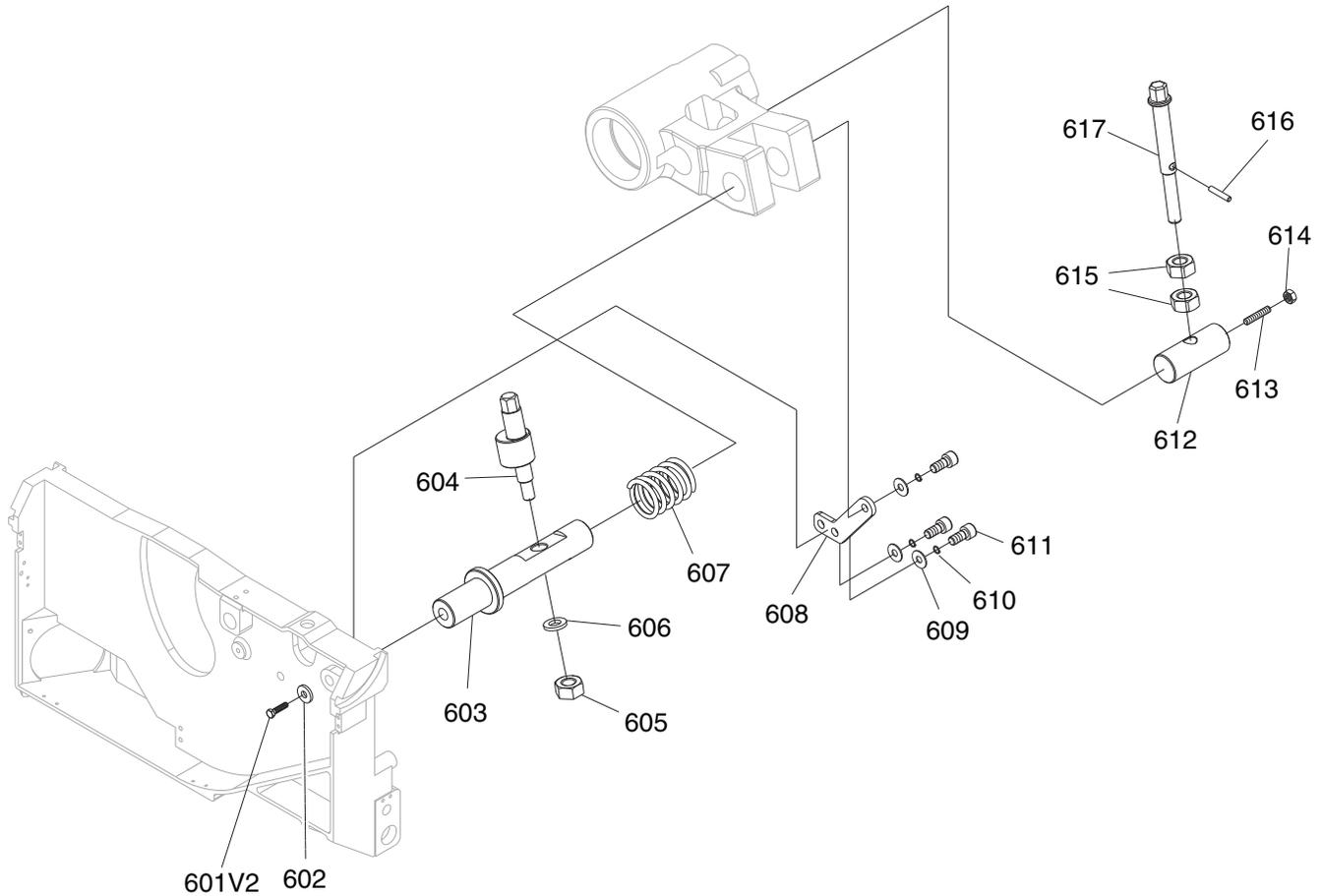


REF	PART #	DESCRIPTION
501	P06990501	HEX BOLT M12-1.75 X 20
502	P06990502	SCORING BLADE ARBOR FLANGE
503	P06990503	SCORING BLADE ARBOR
504	P06990504	BALL BEARING 6202-2RS
505	P06990505	INT RETAINING RING 15MM
506	P06990506	INT RETAINING RING 35MM
507	P06990507	ARBOR HOUSING
508	P06990508	FLAT WASHER 6MM
509	P06990509	FLAT HD SCR M6-1 X 16
510	P06990510	WAVE WASHER 26MM
511V3	P06990511V3	SCORING BLADE PULLEY V3.01.16
512	P06990512	ROLL PIN 5 X 25
515	P06990515	SCORING BLADE 20T
516	P06990516	CAP SCREW M12-1.75 X 100
517	P06990517	LOCK WASHER 12MM
518	P06990518	SCORING MOTOR PULLEY
520V2	P06990520V2	FLAT BELT 18 X 355MM V2.01.16
521	P06990521	PIVOT SHAFT
522	P06990522	BUTTON HD CAP SCR M8-1.25 X 20

REF	PART #	DESCRIPTION
523	P06990523	LOCK WASHER 8MM
524	P06990524	SCORING MOTOR MOUNTING PLATE
525	P06990525	LOCK NUT M14-2
526	P06990526	SCORING MOTOR 1HP 220/440V 3PH
526-1	P06990526-1	SCORING MOTOR FAN COVER
526-2	P06990526-2	SCORING MOTOR FAN
526-3	P06990526-3	SCORING MOTOR JUNCTION BOX
527	P06990527	HEX NUT M10-1.5
528	P06990528	CAP SCREW M10-1.5 X 20
529	P06990529	TENSION SPRING
530	P06990530	CAP SCREW M10-1.5 X 50
531	P06990531	HEX NUT M10-1.5
532	P06990532	FLAT WASHER 6MM
533	P06990533	LOCK WASHER 6MM
534	P06990534	CAP SCREW M6-1 X 16
535	P06990535	FLAT WASHER 14MM
536V2	P06990536V2	BALL BEARING 6003-2RS V2.12.11
537	P06990537	KEY 5 X 5 X 20



Scoring Blade Adjustment System

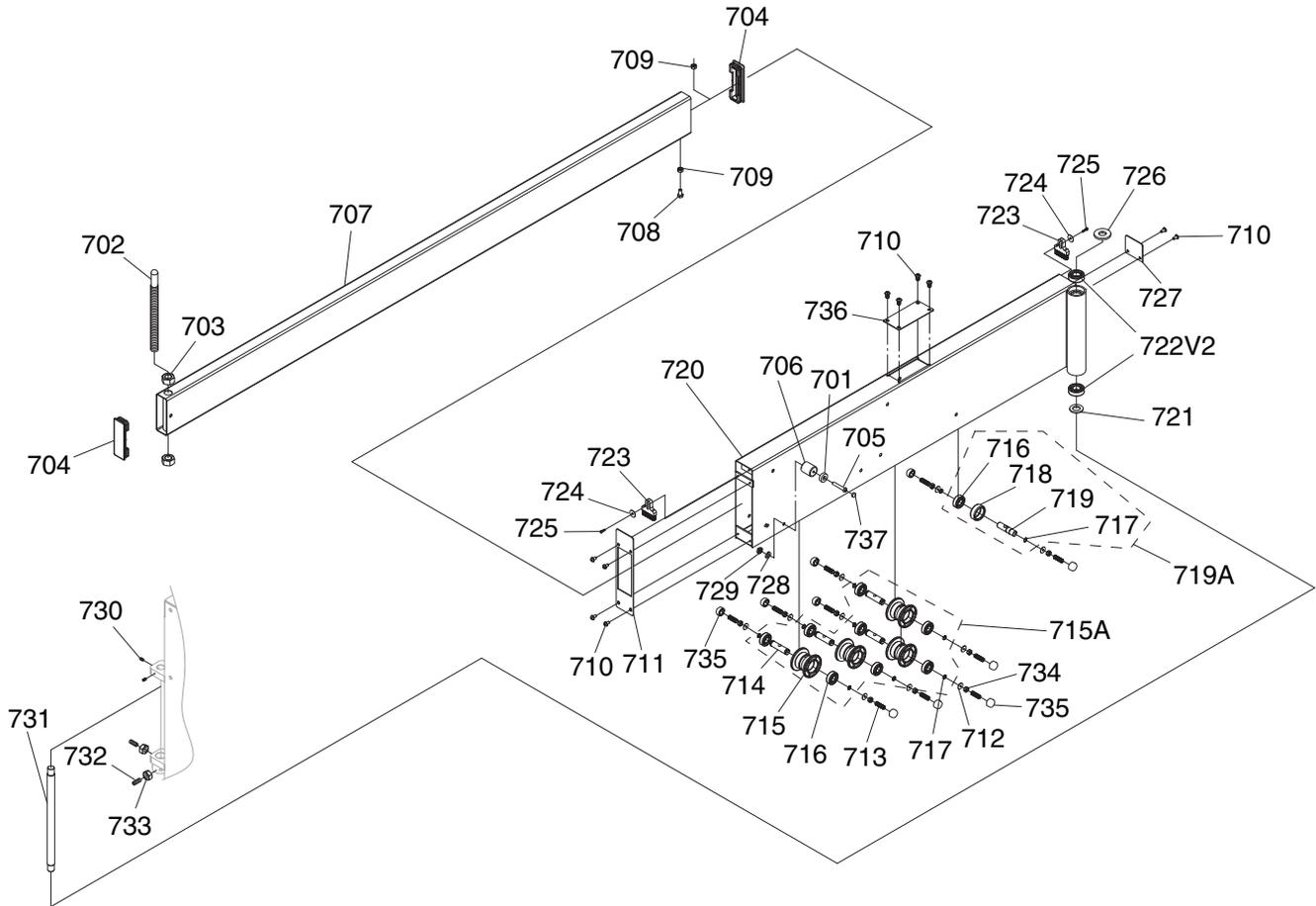


REF	PART #	DESCRIPTION
601V2	P06990601V2	HEX BOLT M8-1.25 X 16 V2.01.16
602	P06990602	FLAT WASHER 8MM
603	P06990603	HORIZONTAL ADJUSTMENT SHAFT
604	P06990604	ECCENTRIC SHAFT
605	P06990605	LOCK NUT M6-1
606	P06990606	BELLEVILLE DISC SPRING 6MM
607	P06990607	COMPRESSION SPRING
608	P06990608	PIVOT ARM
609	P06990609	FLAT WASHER 6MM

REF	PART #	DESCRIPTION
610	P06990610	LOCK WASHER 6MM
611	P06990611	CAP SCREW M6-1 X 16
612	P06990612	VERTICAL ADJUSTMENT SHAFT
613	P06990613	SET SCREW M6-1 X 25
614	P06990614	HEX NUT M6-1
615	P06990615	HEX NUT M8-1.25
616	P06990616	ROLL PIN 3 X 12
617	P06990617	VERTICAL ADJUSTMENT BOLT



Swing Arm

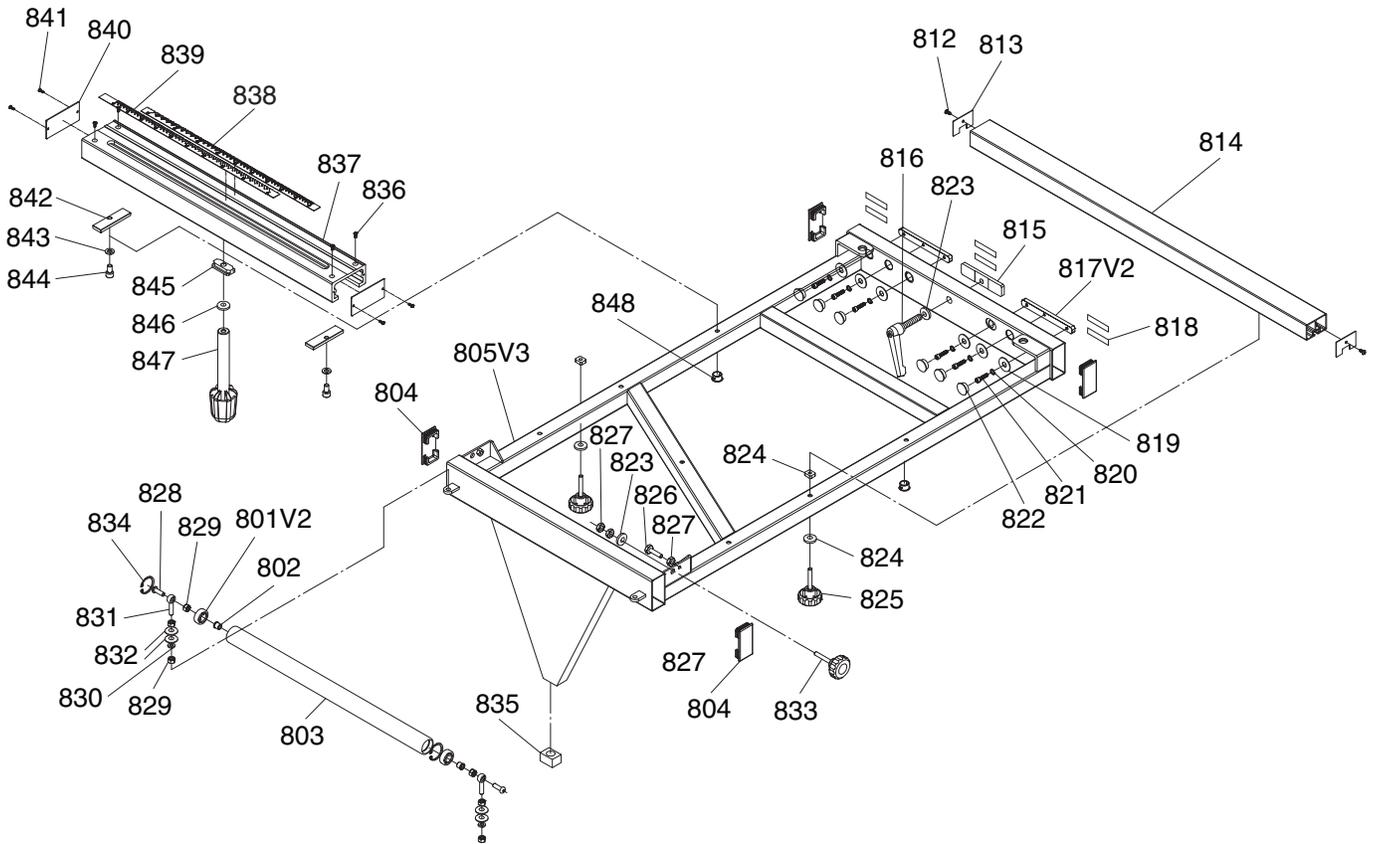


REF	PART #	DESCRIPTION
701	P06990701	SWING ARM MAGNET
702	P06990702	CROSSCUT PIVOT STUD M20-2.5
703	P06990703	HEX NUT M20-2.5
704	P06990704	END PLUG 40 X 120MM
705	P06990705	SET SCREW M8-1.25 X 35
706	P06990706	MAGNET HOLDER
707	P06990707	SLIDING TUBE
708	P06990708	HEX BOLT M8-1.25 X 20
709	P06990709	HEX NUT M8-1.25
710	P06990710	BUTTON HD CAP SCR M6-1 X 10
711	P06990711	SWING ARM END PLATE
712	P06990712	FLAT WASHER 8MM
713	P06990713	SET SCREW M8-1.25 X 25
714	P06990714	ROLLER AXLE
715A	P06990715A	ROLLER ASSEMBLY
715	P06990715	ROLLER
716	P06990716	BALL BEARING 6202ZZ
717	P06990717	EXT RETAINING RING 15MM
718	P06990718	BEARING SPACER
719A	P06990719A	BEARING SHAFT ASSEMBLY

REF	PART #	DESCRIPTION
719	P06990719	BEARING SHAFT
720	P06990720	SWING ARM
721	P06990721	BEARING WASHER 20 X 37MM
722V2	P06990722V2	BALL BEARING 6004-2RS V2.11.13
723	P06990723	BRUSH
724	P06990724	FLAT WASHER 6MM
725	P06990725	CAP SCREW M6-1 X 20
726	P06990726	FLAT WASHER 20MM
727	P06990727	BRUSH COVER
728	P06990728	LOCK WASHER 8MM
729	P06990729	HEX NUT M8-1.25
730	P06990730	SET SCREW M10-1.5 X 12
731	P06990731	SWING ARM PIVOT SHAFT
732	P06990732	SET SCREW M10-1.5 X 20
733	P06990733	HEX NUT M10-1.5
734	P06990734	HEX NUT M8-1.25
735	P06990735	COVER NUT 13MM
736	P06990736	SWING ARM TOP PLATE
737	P06990737	PAD



Crosscut Table

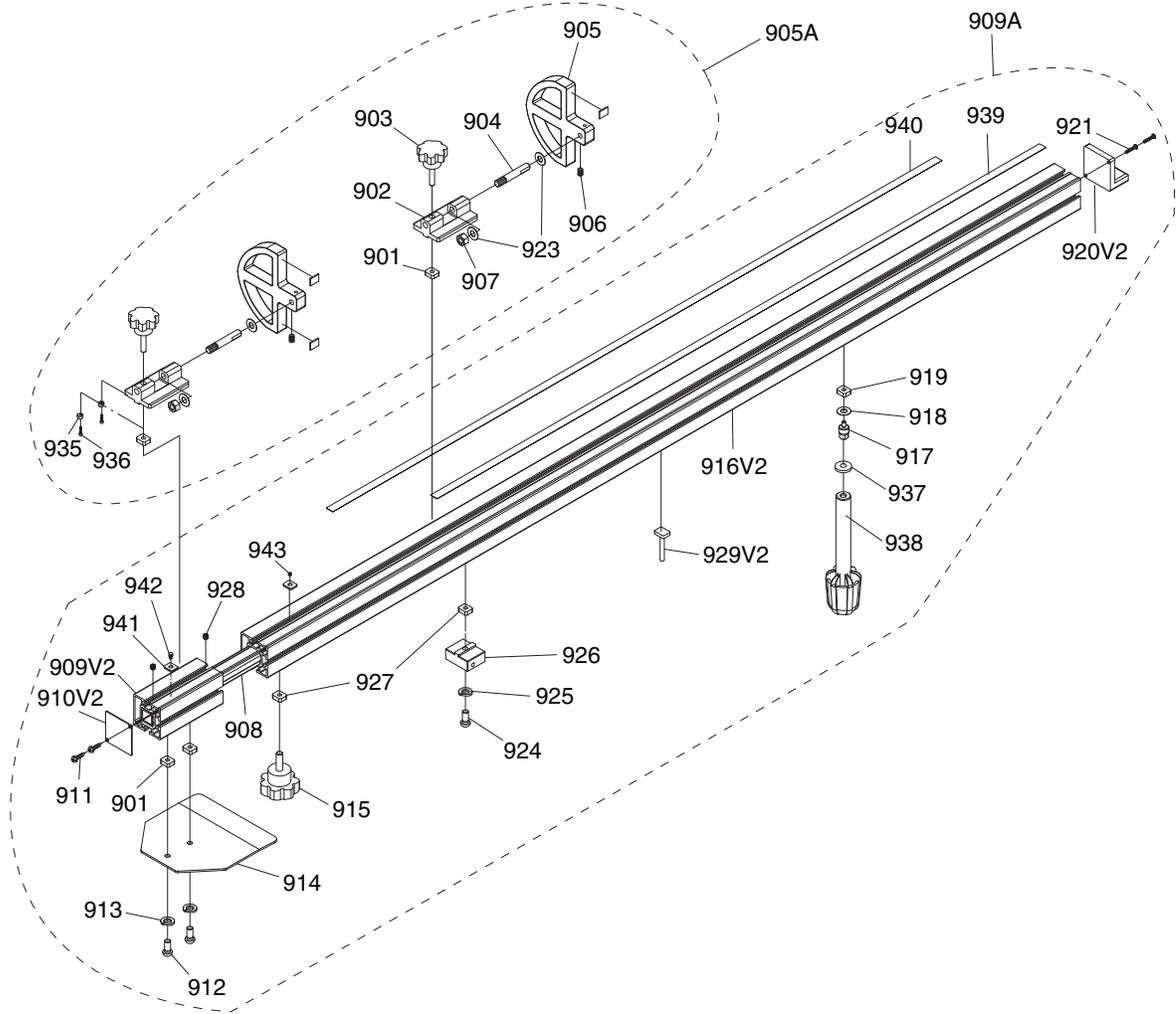


REF	PART #	DESCRIPTION
801V2	P06990801V2	BALL BEARING 6201-2RS V2.11.13
802	P06990802	SPACER
803	P06990803	ROLLER
804	P06990804	LARGE FRAME END PLUG
805V3	P06990805V3	CROSSCUT TABLE FRAME V3.04.12

REF	PART #	DESCRIPTION
828	P06990828	BUTTON HD CAP SCR M8-1.25 X 25
829	P06990829	HEX NUT M8-1.25
830	P06990830	LOCK WASHER 8MM
831	P06990831	ROLLER EYE BOLT M8-1.25 X 40
832	P06990832	FLAT WASHER 8MM
833	P06990833	KNOB BOLT M8-1.25 X 50
834	P06990834	INT RETAINING RING 32MM
835	P06990835	PIVOT BLOCK
836	P06990836	SET SCREW M5-.8 X 10
837	P06990837	TUBE
838	P06990838	SCALE
839	P06990839	SCALE
840	P06990840	END COVER PLATE
841	P06990841	TAP SCREW M3 X 6
842	P06990842	FIXED BLOCK
843	P06990843	LOCK WASHER 8MM
844	P06990844	CAP SCREW M8-1.25 X 25
845	P06990845	T-NUT BLOCK
846	P06990846	FLAT WASHER 8MM
847	P06990847	HANDLE
848	P06990848	PLASTIC PLUG HP-16



Crosscut Fence

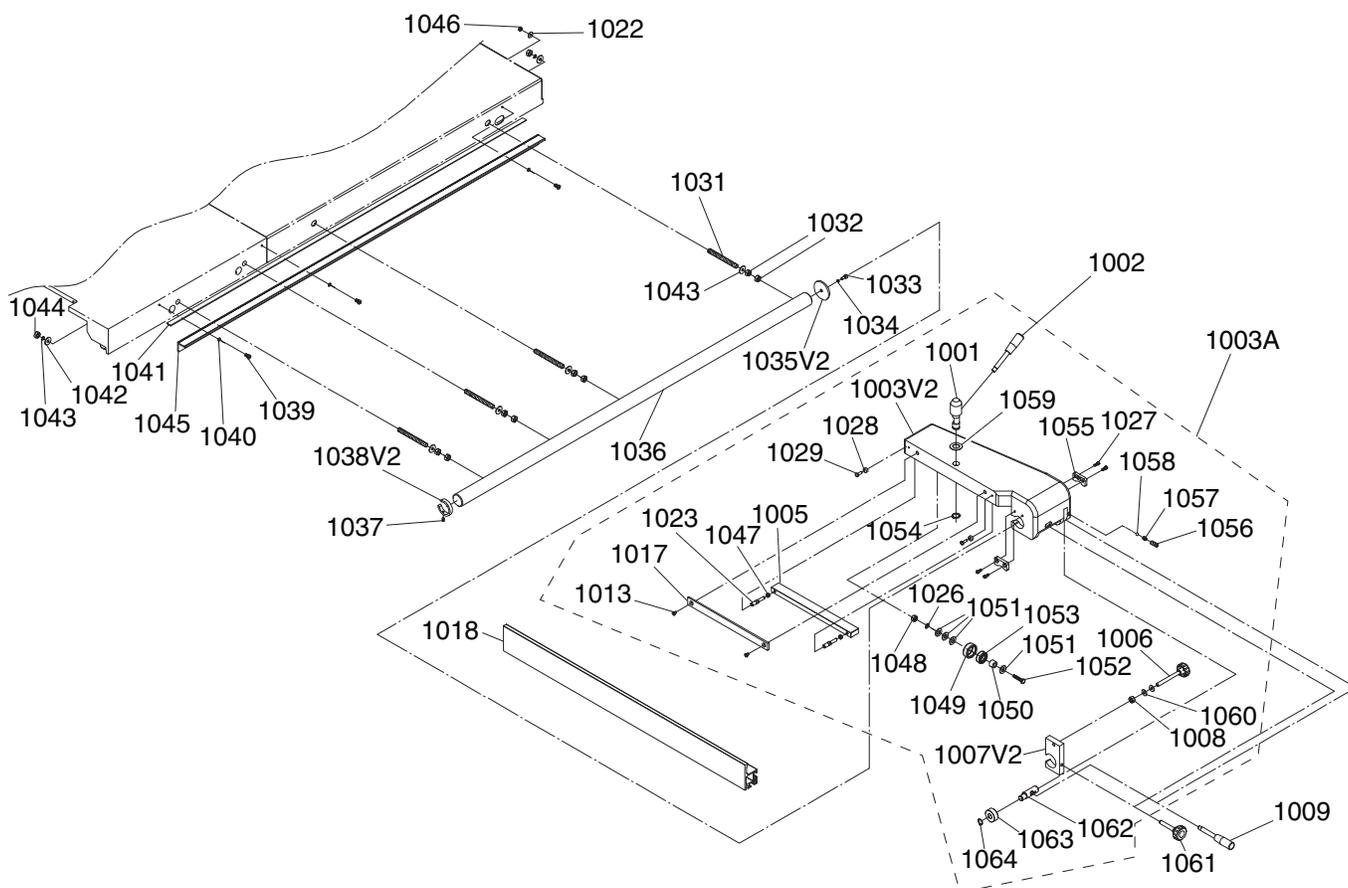


REF	PART #	DESCRIPTION
901	P06990901	T-NUT M8-1.25
902	P06990902	STOP BRACKET
903	P06990903	KNOB BOLT M8-1.25 X 40
904	P06990904	FLIP STOP PIVOT SHAFT
905A	P06990905A	FLIP STOP ASSEMBLY
905	P06990905	FLIP STOP
906	P06990906	SET SCREW M8-1.25 X 10
907	P06990907	LOCK NUT M10-1.5
908	P06990908	EXTENSION CONNECTOR
909A	P06990909A	EXTENSION FENCE ASSEMBLY
909V2	P06990909V2	EXTENSION FENCE V2.04.12
910V2	P06990910V2	EXTENSION FENCE END PLATE V2.04.12
911	P06990911	TAP SCREW M4 X 10
912	P06990912	BUTTON HD CAP SCR M8-1.25 X 16
913	P06990913	LOCK WASHER 8MM
914	P06990914	SUPPORT PLATE
915	P06990915	KNOB BOLT M8-1.25 X 25
916V2	P06990916V2	CROSSCUT FENCE V2.04.12
917	P06990917	PIVOT SHAFT
918	P06990918	FIBER FLAT WASHER 10MM

REF	PART #	DESCRIPTION
919	P06990919	T-NUT M8-1.25
920V2	P06990920V2	POLYURETHANE FENCE END PIECE V2.04.12
921	P06990921	PHLP HD SCR M4-.7 X 10
923	P06990923	FIBER FLAT WASHER
924	P06990924	CAP SCREW M8-1.25 X 35
925	P06990925	LOCK WASHER 8MM
926	P06990926	T-BLOCK
927	P06990927	T-NUT M8-1.25
928	P06990928	SET SCREW M6-1 X 6
929V2	P06990929V2	T-BOLT M8-1.25 X 35 V2.05.12
935	P06990935	SLEEVE
936	P06990936	CAP SCREW M3-.5 X 12
937	P06990937	FENDER WASHER 8MM
938	P06990938	FENCE LOCK HANDLE
939	P06990939	FENCE SCALE 0"-78"
940	P06990940	FENCE SCALE 67"-135"
941	P06990941	T-SLOT NUT M5-.8 (THIN)
942	P06990942	CAP SCREW M5-.8 X 6
943	P06990943	SET SCREW M5-.8 X 5



Rip Fence

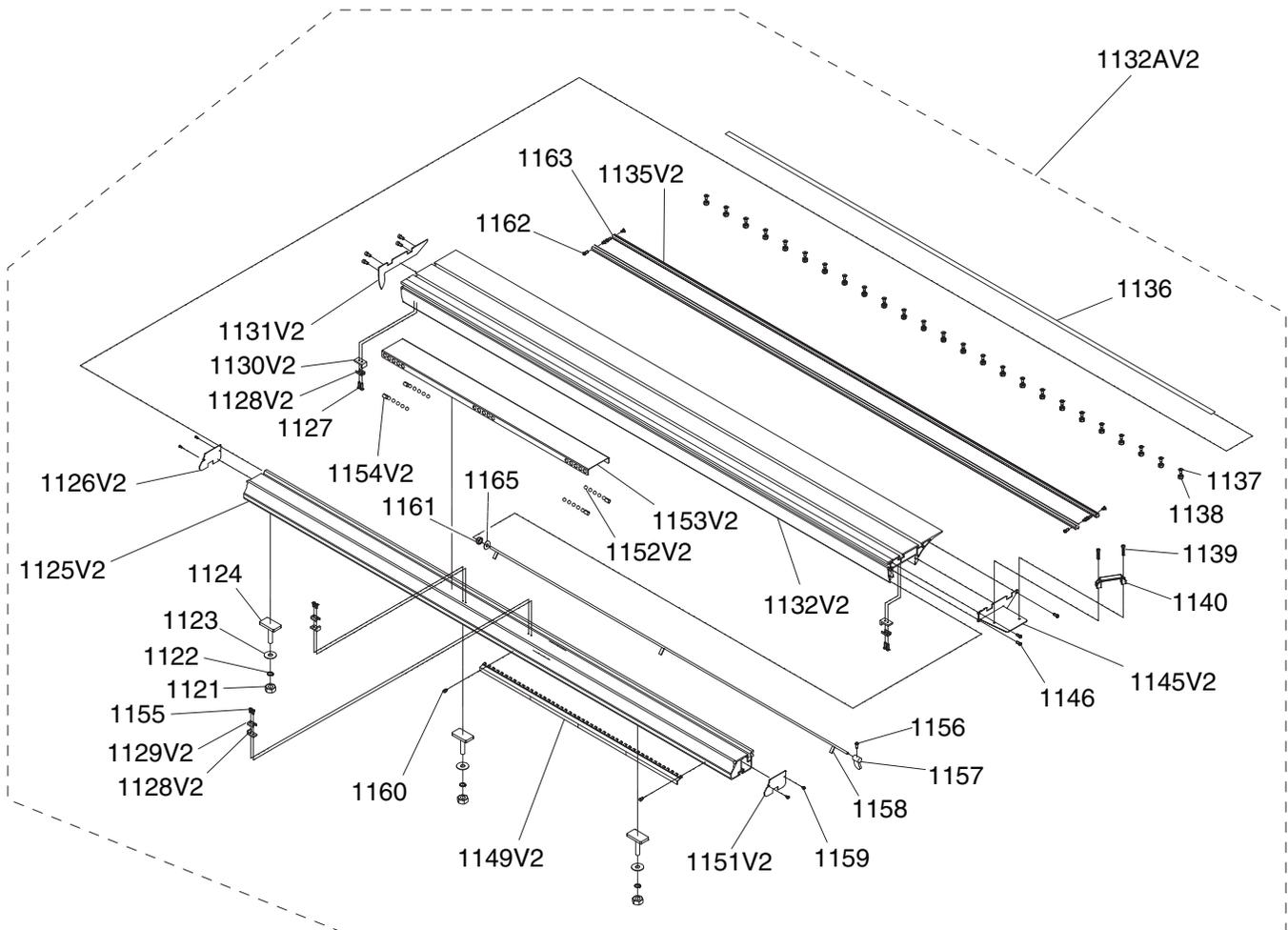


REF	PART #	DESCRIPTION
1001	P06991001	FENCE SLIDE LOCK KNOB
1002	P06991002	LOCK KNOB HANDLE
1003A	P06991003A	RIP FENCE CASTING ASSEMBLY
1003V2	P06991003V2	RIP FENCE CASTING V2.04.12
1005	P06991005	CASTING SUPPORT BAR
1006	P06991006	MICRO-ADJUST KNOB BOLT
1007V2	P06991007V2	FENCE RAIL BRACKET V2.04.12
1008	P06991008	LOCK NUT M10-1.5
1009	P06991009	LOCK-DOWN HANDLE
1013	P06991013	FLAT HD SCR M6-1 X 16
1017	P06991017	CLAMP PLATE
1018	P06991018	RIP FENCE
1022	P06991022	FLAT WASHER 6MM
1023	P06991023	ECCENTRIC SHAFT
1026	P06991026	LOCK WASHER 8MM
1027	P06991027	CAP SCREW M6-1 X 10
1028	P06991028	ECCENTRIC RING
1029	P06991029	HEX BOLT M6-1 X 16
1031	P06991031	ALL-THREAD STUD M12-1.75 X 115
1032	P06991032	HEX NUT M12-1.75
1033	P06991033	CAP SCREW M8-1.25 X 16
1034	P06991034	LOCK WASHER 8MM
1035V2	P06991035V2	RIP FENCE RAIL END PLATE V2.04.12
1036	P06991036	RIP FENCE RAIL
1037	P06991037	SET SCREW M6-1 X 10
1038V2	P06991038V2	RIP FENCE STOP RING V2.04.12

REF	PART #	DESCRIPTION
1039	P06991039	BUTTON HD CAP SCR M6-1 X 12
1040	P06991040	FLAT WASHER 6MM
1041	P06991041	RIP FENCE SCALE
1042	P06991042	FLAT WASHER 12MM
1043	P06991043	LOCK WASHER 12MM
1044	P06991044	HEX NUT M12-1.75
1045	P06991045	SCALE RAIL
1046	P06991046	HEX NUT M6-1
1047	P06991047	LOCK NUT M8-1.25
1048	P06991048	HEX NUT M8-1.25
1049	P06991049	ROLLER
1050	P06991050	SPACER
1051	P06991051	FLAT WASHER 8MM
1052	P06991052	HEX BOLT M8-1.25 X 35
1053	P06991053	BALL BEARING 6202ZZ
1054	P06991054	INT RETAINING RING 20MM
1055	P06991055	WAY WIPER
1056	P06991056	SET SCREW M10-1.5 X 10
1057	P06991057	COMPRESSION SPRING
1058	P06991058	STEEL BALL 8MM
1059	P06991059	LOCK KNOB FLAT WASHER
1060	P06991060	FLAT WASHER 10MM
1061	P06991061	KNOB BOLT M10-1.5 X 55
1062	P06991062	SHAFT
1063	P06991063	ROLLER
1064	P06991064	INT RETAINING RING 15MM



Sliding Table V2



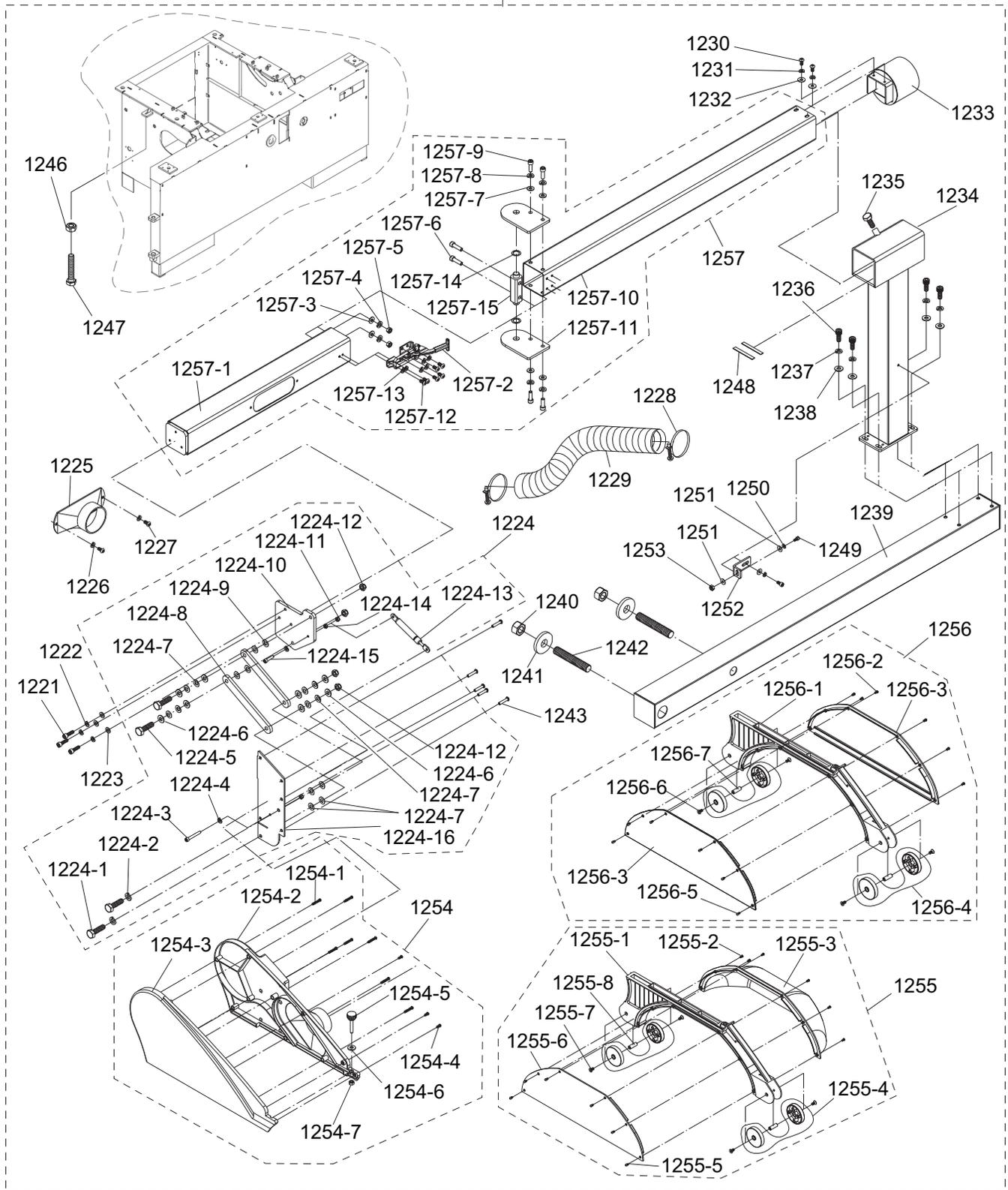
REF	PART #	DESCRIPTION
1121	P06991121	HEX NUT M12-1.75
1122	P06991122	LOCK WASHER 12MM
1123	P06991123	FLAT WASHER 12MM
1124	P06991124	T-BOLT M12-1.75 X 40
1125V2	P06991125V2	SLIDING TABLE BASE 3200MM V2.05.11
1126V2	P06991126V2	BASE LEFT SIDE COVER V2.05.11
1127	P06991127	FLAT HD SCR M6-1 X 30
1128V2	P06991128V2	BLOCK PLATE V2.05.11
1129V2	P06991129V2	BLOCK PLATE V2.05.11
1130V2	P06991130V2	BLOCK PLATE V2.05.11
1131V2	P06991131V2	SLIDING TABLE LEFT SIDE COVER V2.05.11
1132AV2	P06991132AV2	SLIDING TABLE ASSY V2.05.11
1132V2	P06991132V2	SLIDING TABLE 3200MM V2.05.11
1135V2	P06991135V2	SLIDING TABLE WAY V2.05.11
1136	P06991136	COVER STRIP
1137	P06991137	FLAT HD CAP SCR M10-1.5 X 20
1138	P06991138	LOCK NUT M10-1.5
1139	P06991139	CAP SCREW M8-1.25 X 12

REF	PART #	DESCRIPTION
1140	P06991140	HANDLE
1145V2	P06991145V2	SLIDING TABLE RIGHT END PLATE V2.05.11
1146	P06991146	BUTTON HD CAP SCR M6-1 x 12
1149V2	P06991149V2	LOCK PLATE V2.05.11
1151V2	P06991151V2	BASE RIGHT SIDE COVER V2.05.11
1152V2	P06991152V2	HARDENED STEEL BALL V2.05.11
1153V2	P06991153V2	SLIDE PLATE V2.05.11
1154V2	P06991154V2	WOOL PAD V2.05.11
1155	P06991155	FLAT HD SCR M6-1 X 30
1156	P06991156	BUTTON HD CAP SCR M5-.8 X 10
1157	P06991157	LOCK GUIDE
1158	P06991158	LOCK ROD
1159	P06991159	TAP SCREW M4 X 10
1160	P06991160	BUTTON HD CAP SCR M6-1 X 16
1161	P06991161	LOCK ROD END CAP
1162	P06991162	BUTTON HD CAP SCR M6-1 X 10
1163	P06991163	WAY ADHESIVE STRIP
1165	P06991165	LOCK ROD FLAT WASHER



Blade Guard V2

1202AV2



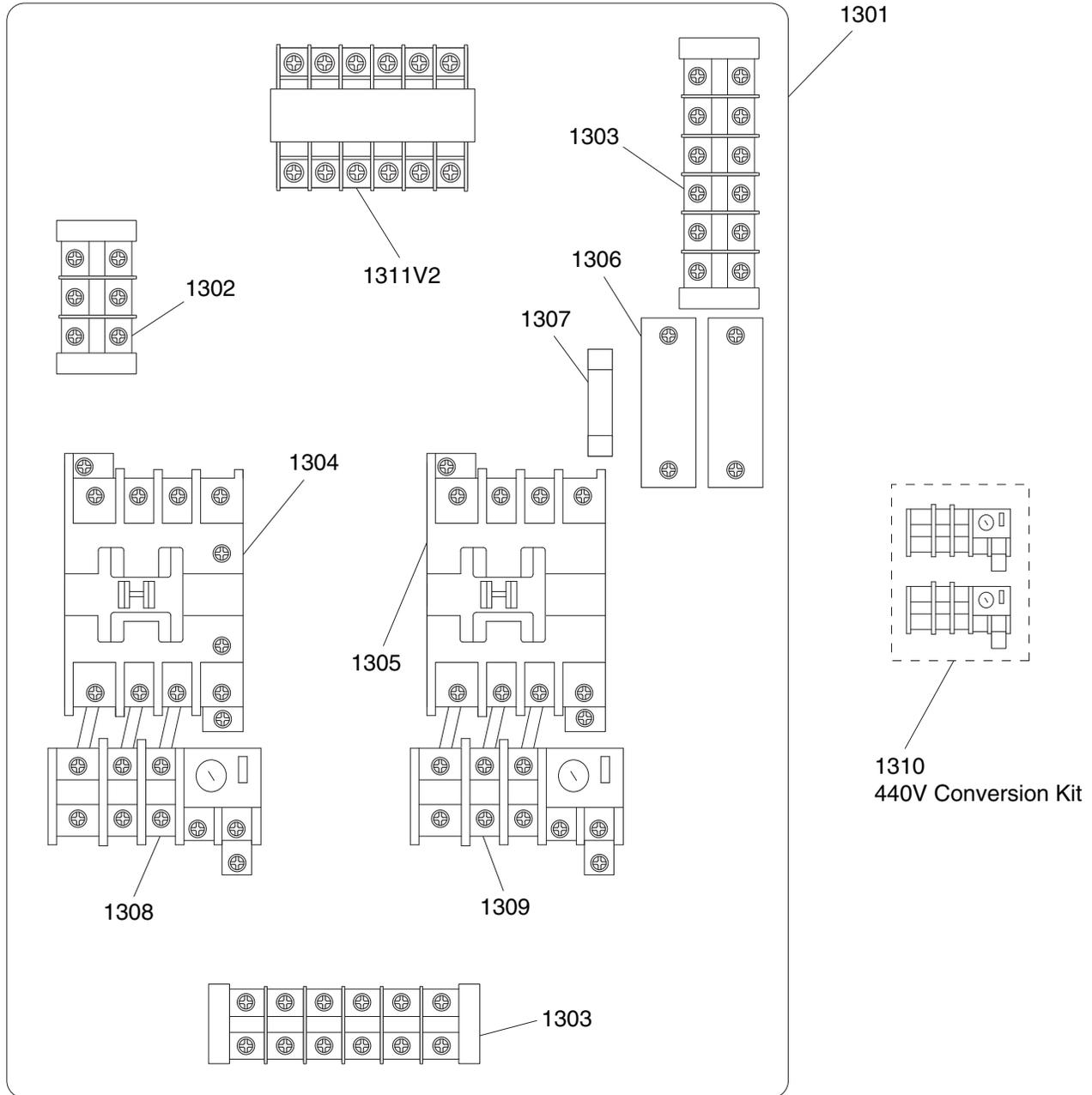
Blade Guard Parts List

REF	PART #	DESCRIPTION
1202AV2	P06991202AV2	BLADE GUARD ASSY V2.10.16
1221	P06991221	CAP SCREW M6-1 X 20
1222	P06991222	LOCK WASHER 6MM
1223	P06991223	FLAT WASHER 6MM
1224	P06991224	HOOD MOUNTING BRACKET ASSY
1224-1	P06991224-1	HEX BOLT M10-1.5 X 35
1224-2	P06991224-2	LOCK WASHER 10MM
1224-3	P06991224-3	CAP SCREW M6-1 X 45
1224-4	P06991224-4	LOCK WASHER 6MM
1224-5	P06991224-5	HEX BOLT M10-1.5 X 35
1224-6	P06991224-6	FLAT WASHER 10MM
1224-7	P06991224-7	FLAT WASHER 10MM NYLON
1224-8	P06991224-8	PIVOT LINKAGE BAR
1224-9	P06991224-9	FLAT WASHER 10MM COPPER
1224-10	P06991224-10	ARM MOUNTING PLATE
1224-11	P06991224-11	LOCK NUT M6-1
1224-12	P06991224-12	LOCK NUT M10-1.5
1224-13	P06991224-13	GAS RETURN SPRING
1224-14	P06991224-14	HEX NUT M6-1
1224-15	P06991224-15	CAP SCREW M6-1 X 25
1224-16	P06991224-16	DUST HOOD MOUNTING PLATE
1225	P06991225	DUST PORT 3"
1226	P06991226	LOCK WASHER 6MM
1227	P06991227	CAP SCREW M6-1 X 12
1228	P06991228	HOSE CLAMP 3-1/4"
1229	P06991229	DUST HOSE 3" X 16-1/2"
1230	P06991230	CAP SCREW M6-1 X 12
1231	P06991231	LOCK WASHER 6MM
1232	P06991232	FLAT WASHER 6MM
1233	P06991233	DUST PORT ARM ADAPTER 4"
1234	P06991234	ARM SUPPORT PEDESTAL
1235	P06991235	HEX BOLT M10-1.5 X 30
1236	P06991236	CAP SCREW M8-1.25 X 25
1237	P06991237	LOCK WASHER 8MM
1238	P06991238	FLAT WASHER 8MM
1239	P06991239	ARM SUPPORT BASE
1240	P06991240	HEX NUT M20-2.5
1241	P06991241	FLAT WASHER 20MM
1242	P06991242	STUD-FT M20-2.5 X 130
1243	P06991243	BUTTON HD CAP SCR M6-1 X 30
1246	P06991246	HEX NUT M12-1.75
1247	P06991247	HEX BOLT M12-1.75 X 70
1248	P06991248	SKID PAD
1249	P06991249	CAP SCREW M6-1 X 20
1250	P06991250	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
1251	P06991251	FLAT WASHER 6MM
1252	P06991252	MOUNTING BRACKET
1253	P06991253	HEX NUT M6-1
1254	P06991254	DUST HOOD ASSY
1254-1	P06991254-1	TAP SCREW M3.5 X 25
1254-2	P06991254-2	HOOD REAR COVER
1254-3	P06991254-3	HOOD FRONT COVER
1254-4	P06991254-4	TAP SCREW M4 X 10
1254-5	P06991254-5	KNURLED KNOB M8-1.25 X 30
1254-6	P06991254-6	FLAT WASHER 8MM
1254-7	P06991254-7	HEX NUT M8-1.25
1255	P06991255	BLADE GUARD ASSY (WIDE)
1255-1	P06991255-1	BLADE GUARD BODY
1255-2	P06991255-2	FLANGE SCREW M4-.7 X 10
1255-3	P06991255-3	GUARD COVER (WIDE)
1255-4	P06991255-4	ROLLER
1255-5	P06991255-5	FLANGE SCREW M4-.7 X 10
1255-6	P06991255-6	GUARD COVER (FLAT)
1255-7	P06991255-7	FLAT HD CAP SCR M6-1 X 10
1255-8	P06991255-8	ROLLER SHAFT
1256	P06991256	BLADE GUARD ASSY (NARROW)
1256-1	P06991256-1	BLADE GUARD BODY
1256-2	P06991256-2	FLANGE SCREW M4-.7 X10
1256-3	P06991256-3	GUARD COVER (FLAT)
1256-4	P06991256-4	ROLLER
1256-5	P06991256-5	FLANGE SCREW M4-.7 X10
1256-6	P06991256-6	FLAT HD CAP SCR M6-1 X 10
1256-7	P06991256-7	ROLLER SHAFT
1257	P06991257	UPPER SUPPORT ARM ASSY
1257-1	P06991257-1	UPPER SUPPORT ARM (SHORT)
1257-2	P06991257-2	ELBOW CLAMP
1257-3	P06991257-3	FLAT WASHER 8MM
1257-4	P06991257-4	LOCK WASHER 8MM
1257-5	P06991257-5	HEX NUT M8-1.25
1257-6	P06991257-6	CAP SCREW M8-1.25 X 30
1257-7	P06991257-7	FLAT WASHER 8MM
1257-8	P06991257-8	LOCK WASHER 8MM
1257-9	P06991257-9	CAP SCREW M8-1.25 X 25
1257-10	P06991257-10	UPPER SUPPORT ARM (LONG)
1257-11	P06991257-11	PIVOT PLATE
1257-12	P06991257-12	CAP SCREW M6-1 X 10
1257-13	P06991257-13	LOCK WASHER 6MM
1257-14	P06991257-14	FLAT WASHER 16MM COPPER
1257-15	P06991257-15	PIVOT SHAFT



Electrical Cabinet

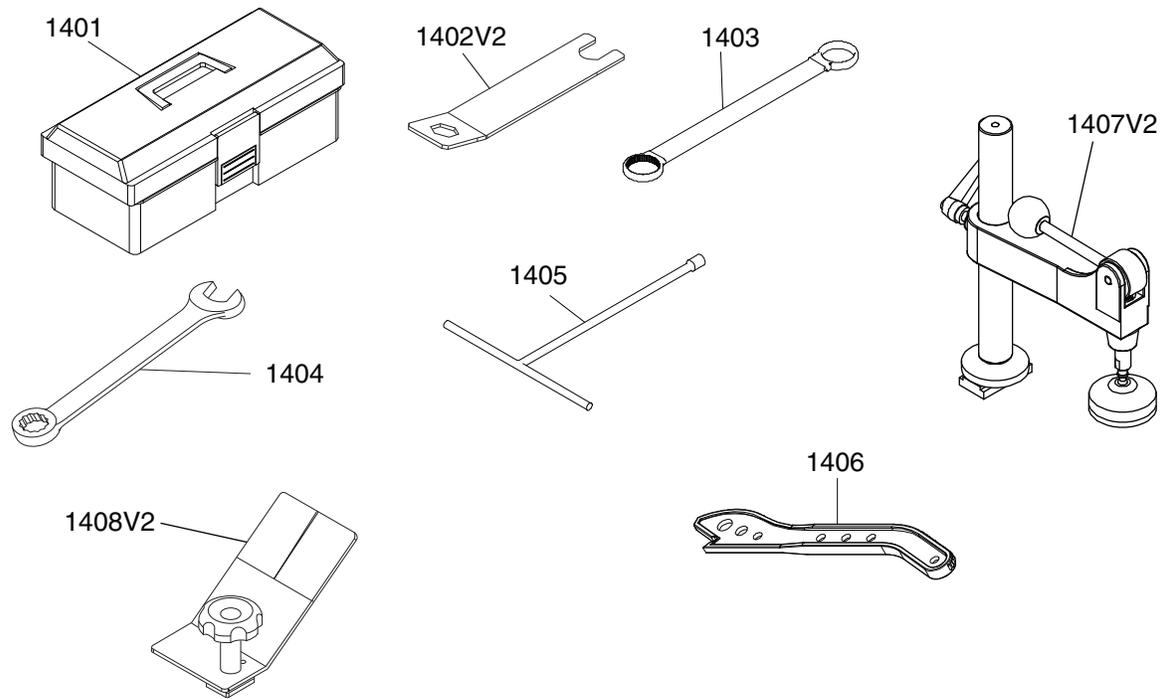


REF	PART #	DESCRIPTION
1301	P06991301	ELECTRICAL CABINET BACK PLATE
1302	P06991302	TERMINAL BAR 3-POST
1303	P06991303	TERMINAL BAR 6-POST
1304	P06991304	CONTACTOR SDE MA-30 220V
1305	P06991305	CONTACTOR SDE MA-09 220V
1306	P06991306	FUSE HOLDER

REF	PART #	DESCRIPTION
1307	P06991307	FUSE 2A
1308	P06991308	OL RELAY SDE RA-30 18-26A
1309	P06991309	OL RELAY SDE RA-20 2.7-4.4A
1310	P06991310	440V CONVERSION KIT
1311V2	P06991311V2	TRANSFORMER LUNG CHI 0-440V V2.05.15



Accessories

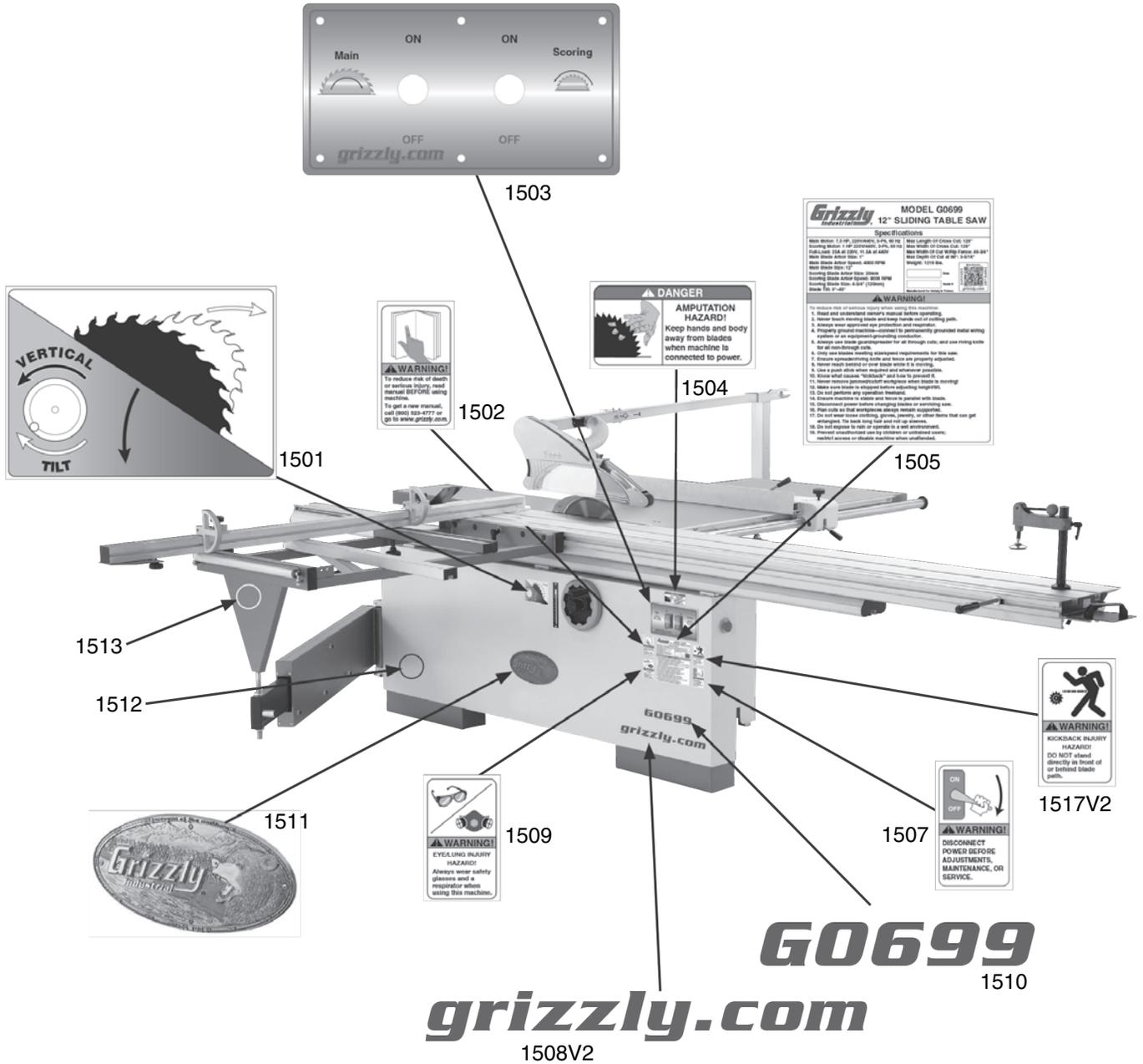


REF	PART #	DESCRIPTION
1401	P06991401	TOOL BOX
1402V2	P06991402V2	SCORING ARBOR WRENCH V2.04.12
1403	P06991403	WRENCH 17 X 19MM OPEN-ENDS
1404	P06991404	WRENCH 30MM

REF	PART #	DESCRIPTION
1405	P06991405	T-HANDLE WRENCH 8MM
1406	P06991406	PUSH STICK
1407V2	P06991407V2	HOLD-DOWN ASSEMBLY V2.10.17
1408V2	P06991408V2	EDGE SHOE ASSEMBLY V2.04.12



Front Machine Labels



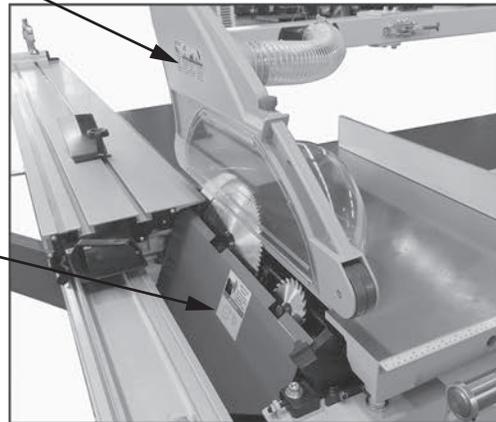
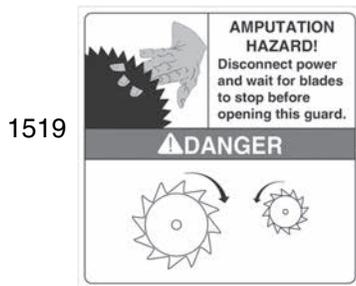
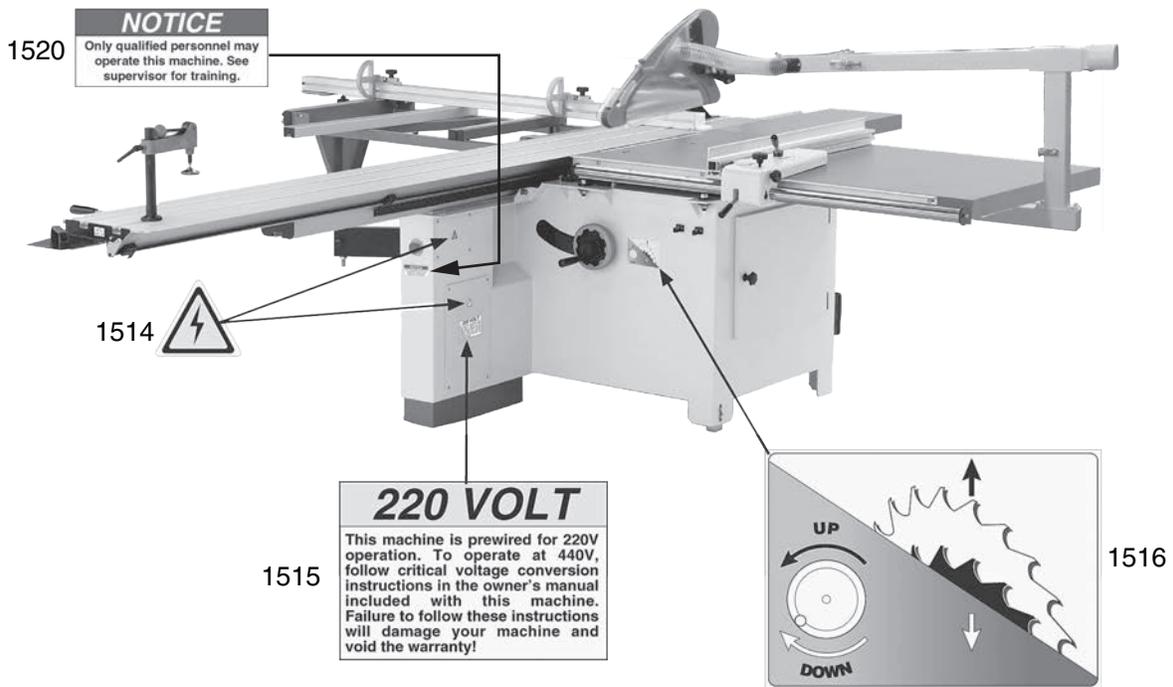
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1510
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1508V2

! WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.



Rear & Blade Guard Machine Labels



REF	PART #	DESCRIPTION
1501	P06991501	SAW BLADE TILT LABEL
1502	P06991502	READ MANUAL LABEL
1503	P06991503	CONTROL PANEL LABEL
1504	P06991504	AMPUTATION HAZARD LABEL
1505	P06991505	MACHINE ID LABEL
1507	P06991507	DISCONNECT POWER LABEL
1508V2	P06991508V2	GRIZZLY.COM LABEL V2.08.16
1509	P06991509	EYE/LUNG HAZARD LABEL
1510	P06991510	MODEL NUMBER LABEL
1511	P06991511	GRIZZLY OVAL NAMEPLATE

REF	PART #	DESCRIPTION
1512	P06991512	GRIZZLY PUTTY TOUCH-UP PAINT
1513	P06991513	GRIZZLY GREEN TOUCH-UP PAINT
1514	P06991514	ELECTRICITY LABEL
1515	P06991515	PREWIRED 220V LABEL
1516	P06991516	SAW BLADE ELEVATION LABEL
1517V2	P06991517V2	KICKBACK HAZARD LABEL V2.08.16
1518V2	P06991518V2	BLADE GUARD WARNING LABEL V2.08.16
1519	P06991519	CUTTING HAZARD LABEL
1520	P06991520	QUALIFIED PERSONNEL NOTICE LABEL



WARRANTY & RETURNS

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

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

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

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

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

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

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



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