

Grizzly ***Industrial, Inc.***®

MODEL G0555LX

14" DELUXE BANDSAW

OWNER'S MANUAL

(For models manufactured since 1/14)



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
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#KN14662 PRINTED IN TAIWAN

V3.05.23

*****Keep for Future Reference*****



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

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

WARNING

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

CAUTION

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


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
SPECIFICATIONS		 WARNING!
Motor:	To reduce risk of serious injury when using this machine:	
Specification:	1. Read manual before operation.	
Specification:	2. Wear safety glasses and respirator.	
Specification:	3. Make sure machine is properly adjusted/setup and	
Specification:	4. Make sure the motor has stopped and disconnect	
Weight:	5. DO NOT expose to rain or dampness.	
	6. DO NOT modify this machine in any way.	
	7.	
	8.	
	9.	
	10. Maintain machine carefully to prevent accidents.	

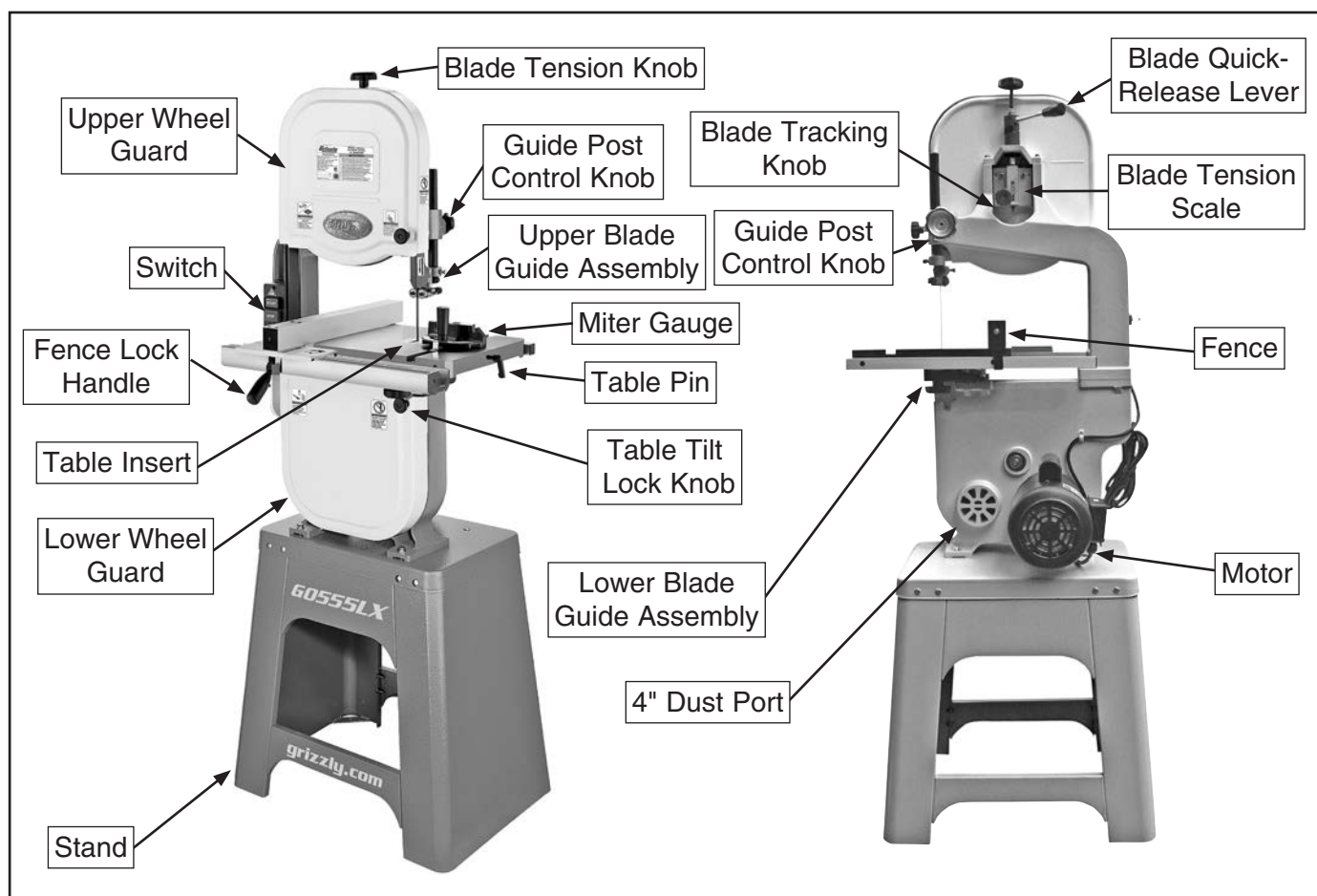
Manufactured for Grizzly in Taiwan

Manufacture Date:

Serial Number:



Identification



CAUTION

For Your Own Safety, Read Instruction Manual Before Operating Saw.

- a) Wear eye protection.
- b) Do not remove jammed cutoff pieces until blade has stopped.
- c) Maintain proper adjustment of blade tension, blade guides, and thrust bearings.
- d) Adjust upper guide to just clear workpiece.
- e) Hold workpiece firmly against table.





MACHINE DATA SHEET

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

MODEL G0555LX 14" DELUXE BANDSAW

Product Dimensions:

Weight..... 229 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 27 x 30 x 67-1/2 in.
Footprint (Length x Width)..... 23-1/2 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard Box
Content..... Machine
Weight..... 204 lbs.
Length x Width x Height..... 45 x 22 x 18 in.

Carton #2

Type..... Cardboard Box
Content..... Stand
Weight..... 42 lbs.
Length x Width x Height..... 28-1/2 x 23 x 9 in.

Electrical:

Power Requirement..... 110V or 220V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 11A at 110V, 5.5A at 220V
Minimum Circuit Size..... 15A at 110V, 15A at 220V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6 ft.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15 for 110V
Switch Type..... ON/OFF Push Button

Motors:

Main

Horsepower..... 1 HP
Phase..... Single-Phase
Amps..... 11A/5.5A
Speed..... 1725 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Main Specifications

Bandsaw Size..... 14 in.
Max Cutting Width (Left of Blade)..... 13-1/2 in.
Max Cutting Width (Left of Blade) w/Fence..... 11-7/8 in.
Max Cutting Height (Resaw Height)..... 6 in.
Blade Speeds..... 1800, 3100 FPM



Blade Information

Standard Blade Length.....	93-1/2 in.
Blade Length Range.....	92-1/2 – 93-1/2 in.
Blade Width Range.....	1/8 – 3/4 in.
Type of Blade Guides.....	Ball Bearing
Guide Post Adjustment Type.....	Rack & Pinion
Has Quick-Release.....	Yes

Table Information

Table Length.....	14 in.
Table Width.....	14 in.
Table Thickness.....	1-1/2 in.
Table Tilt.....	Left 10, Right 45 deg.
Table Tilt Adjustment Type.....	Manual
Floor-to-Table Height.....	43 in.
Fence Locking Position.....	Front
Fence is Adjustable for Blade Lead.....	Yes
Resaw Fence Attachment Included.....	No
Miter Gauge Included.....	Yes

Miter Gauge Information

Miter Angle.....	0 - 60 deg. L/R
Miter Gauge Slot Type.....	Straight Slot
Miter Gauge Slot Width.....	3/4 in.
Miter Gauge Slot Height.....	3/8 in.

Construction Materials

Table.....	Precision Ground Cast Iron
Trunnion.....	Aluminum
Fence.....	Deluxe Extruded Aluminum
Base/Stand.....	Pre-Formed Steel
Frame/Body.....	Cast Iron
Wheels.....	Computer-Balanced Cast Iron
Tire.....	Rubber
Wheel Cover	Pre-Formed Steel
Paint Type/Finish.....	Powder Coating & Ure

Other Related Information

Wheel Diameter.....	13-3/4 in.
Wheel Width.....	1-3/16 in.
Number of Dust Ports.....	1
Dust Port Size.....	4 in.
Compatible Mobile Base.....	D3757

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1-1/2 Hours
Serial Number Location	ID Label on Top Cover
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes



SECTION 1: SAFETY

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

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



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



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



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

NOTICE

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

Safety Instructions for Machinery



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

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

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

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

ELECTRICAL EQUIPMENT INJURY RISKS.

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

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

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



WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



Additional Safety for Bandsaws

WARNING

Serious cuts, amputation, or death can occur from contact with the moving saw blade during operation or if blade breakage occurs. Serious injury or death can also occur from getting fingers, hair, or clothing entangled in moving parts if the machine is operated while the doors are open. To reduce this risk, anyone operating this machine **MUST** completely heed the hazards and warnings below.

HAND PLACEMENT. Placing hands or fingers in line with blade during operation may result in serious injury if hands slip or workpiece moves unexpectedly. Do not position fingers or hands in line with blade, and never reach under table while blade is moving.

SMALL/NARROW WORKPIECES. If hands slip during a cut while holding small workpieces with fingers, serious personal injury could occur. Always support/feed small or narrow workpieces with push sticks, push blocks, jig, vise, clamping fixture.

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

FEED RATE. To avoid risk of workpiece slipping and causing operator injury, always feed stock evenly and smoothly.

BLADE CONDITION. Dull blades require more effort to perform cut, increasing risk of accidents. Do not operate with dirty, dull, cracked or badly worn blades. Inspect blades for cracks and missing teeth before each use. Always maintain proper blade tension and tracking while operating.

CLEARING JAMS AND CUTOFFS. Always stop bandsaw and disconnect power before clearing scrap pieces that get stuck between blade and table insert. Use brush or push stick, not hands, to clean chips/cutoff scraps from table.

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

GUARDS/COVERS. Blade guards and covers protect operator from moving bandsaw blade. The wheel covers protect operator from getting entangled with rotating wheels or other moving parts. **ONLY** operate bandsaw with blade guard in proper position and wheel covers completely closed.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure blade teeth face down toward table and blade is properly tensioned and tracked before operating.

UPPER BLADE GUIDE SUPPORT. To reduce exposure of operator to blade and provide maximum blade support while cutting, keep upper blade guides adjusted to just clear workpiece.

CUTTING TECHNIQUES. To avoid blade getting pulled off wheels or accidentally breaking and striking operator, always turn bandsaw **OFF** and wait for blade to come to a complete stop before backing workpiece out of blade. **DO NOT** back workpiece away from blade while bandsaw is running. **DO NOT** force or twist blade while cutting, especially when sawing small curves. This could result in blade damage or breakage.

WORKPIECE SUPPORT. To maintain maximum control and reduce risk of blade contact/breakage, always ensure adequate support of long/large workpieces. Always keep workpiece flat and firm against table/fence when cutting to avoid loss of control. If necessary, use a jig or other workholding device.

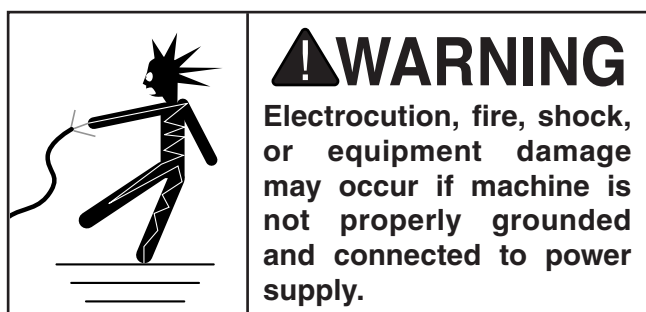
WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is **NOT** designed to cut metal, glass, stone, tile, etc.



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 110V..... 11 Amps

Full-Load Current Rating at 220V 5.5 Amps

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

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

Circuit Information

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

CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

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

Circuit Requirements for 110V

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

Nominal Voltage 110V, 115V, 120V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 5-15

Circuit Requirements for 220V

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

Nominal Voltage 208V, 220V, 230V, 240V
Cycle 60 Hz
Phase Single-Phase
Power Supply Circuit 15 Amps
Plug/Receptacle NEMA 6-15



Grounding Requirements

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

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

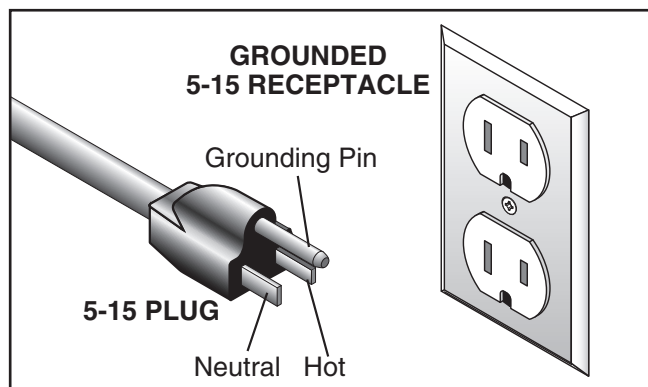
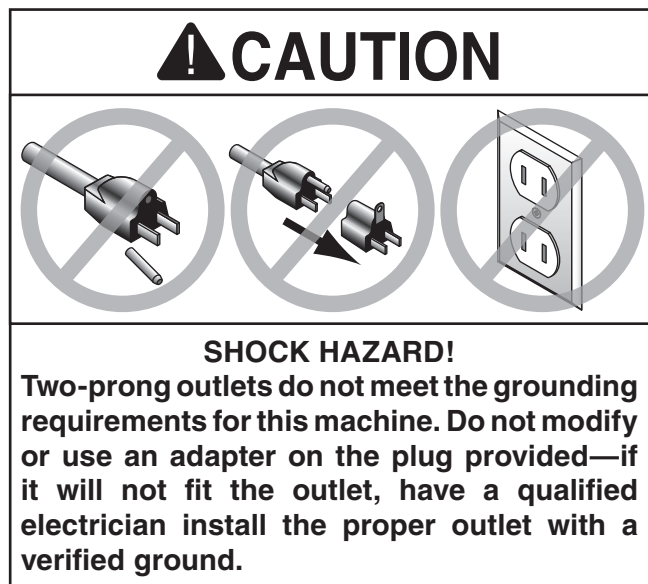


Figure 1. Typical 5-15 plug and receptacle.



For 220V operation: The plug specified under “Circuit Requirements for 220V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

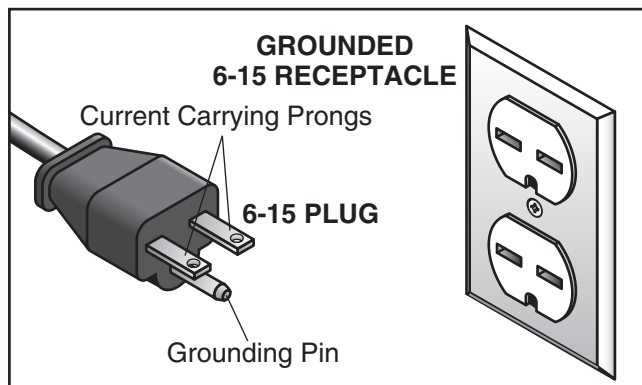


Figure 2. Typical 6-15 plug and receptacle.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

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

Any extension cord used with this machine must be in good condition and contain a ground wire and matching plug/receptacle. Additionally, it must meet the following size requirements:

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



Converting Voltage to 220V

⚠ CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

The voltage conversion MUST be performed by an electrician or qualified service personnel. The voltage conversion procedure consists of rewiring the motor and installing the correct plug. The necessary wiring diagrams are provided in the **Wiring** section, beginning on **Page 55** for your reference.

IMPORTANT: If the diagram on the motor conflicts with the diagrams in the **Wiring** section, the motor may have changed since the manual was printed. Use the diagram on the motor instead.

Items Needed	Qty
• Phillips Head Screwdriver #2	1
• Electrical Tape	As Needed
• Wire Nut 14 AWG	1
• NEMA Plug 6-15	1
• Wire Cutters/Stripper	1

To convert the machine to 220V:

1. DISCONNECT MACHINE FROM POWER!
2. Remove the 5-15 plug from the cord.

3. Remove the two wire nuts from the wires shown in **Figure 3**.

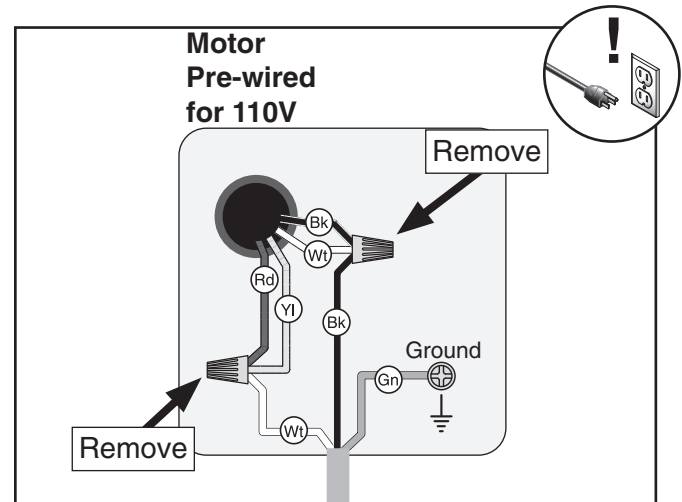


Figure 3. Motor pre-wired for 110V.

4. Re-wire the motor as shown in **Figure 3**.

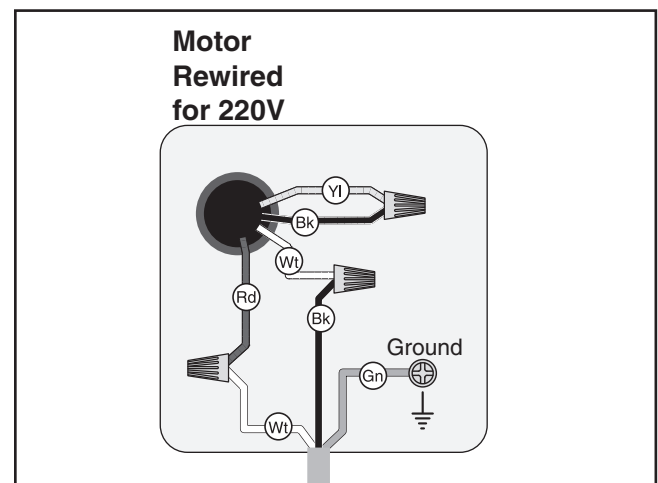
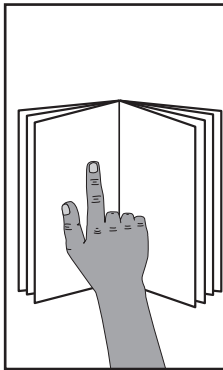


Figure 4. Motor rewired for 220V.

5. Tighten all wire nuts and secure them with electrical tape so they cannot vibrate loose during motor operation.
6. Install the 6-15 plug on the power cord per the plug manufacturer's instructions.

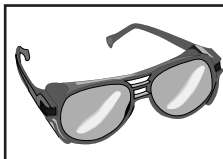


SECTION 3: SETUP



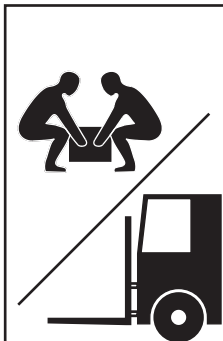
!WARNING

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 As Needed
- Safety Glasses 1
- Disposable Shop Rags..... As Needed
- Cleaner/Degreaser As Needed
- Level 1
- Wrench or Socket $\frac{7}{16}$ ", $\frac{1}{2}$ " 1 Ea.
- Wrenches or Sockets $\frac{9}{16}$ " 2
- Disposable Gloves As Needed
- Square 1
- Dust Hose 4" 1
- Hose Clamp 4" 1

Unpacking

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. ***If items are damaged, please call us immediately at (570) 546-9663.***

IMPORTANT: Save all packaging materials until you are completely satisfied with the machine and have resolved any issues between Grizzly or the shipping agent. *You MUST have the original packaging to file a freight claim. It is also extremely helpful if you need to return your machine later.*



Inventory

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

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

Inventory (see Figure 5)	Qty
A. Table Assembly	1
B. Bandsaw Body	1
C. Saw Blade 93½" x ⅜" x 6 TPI	1
D. Miter Gauge Assembly	1
E. Front Fence Rail	1
F. Rear Fence Rail	1
G. Fence Assembly	1
H. Upper Stand Braces	2
I. Stand Top	1
J. Stand Sides	2
K. Lower Stand Braces	2
L. Hardware (not shown)	
—Table Insert w/Large Slot	1
—Hex Bolts ⅝"-18 x 1½" (Bandsaw)	4
—Hex Nuts ⅝"-18 (Bandsaw)	4
—Lock Washers ⅝" (Bandsaw)	4
—Flat Washers ⅝" (Bandsaw)	8
—Cap Screws ¼"-20 x ⅝" (Fence)	2
—Hex Bolts ¼"-20 x ¾" (Fence)	2
—Flat Washers ¼" (Fence)	2
—Hex Bolts ¼"-20 x ⅝" (Stand)	16
—Flat Washers ¼" (Stand)	16
—Flange Nuts ¼"-20 (Stand)	16
—Stand Feet ⅜"-16 x 2" (Stand)	4
—Carriage Bolts ⅝"-18 x ⅝" (Stand)	8
—Flange Nuts ⅝"-18 (Stand)	8
—Hex Nuts ⅜"-16 (Stand Feet)	8
—Flat Washer ⅜" (Stand Feet)	8
—Open-End Wrench 10 x 12mm	1
—Hex Wrench 5mm	1
—Switch Padlock w/Keys	1
—Eccentrics ¼"	2
—Quick-Release Lever	1

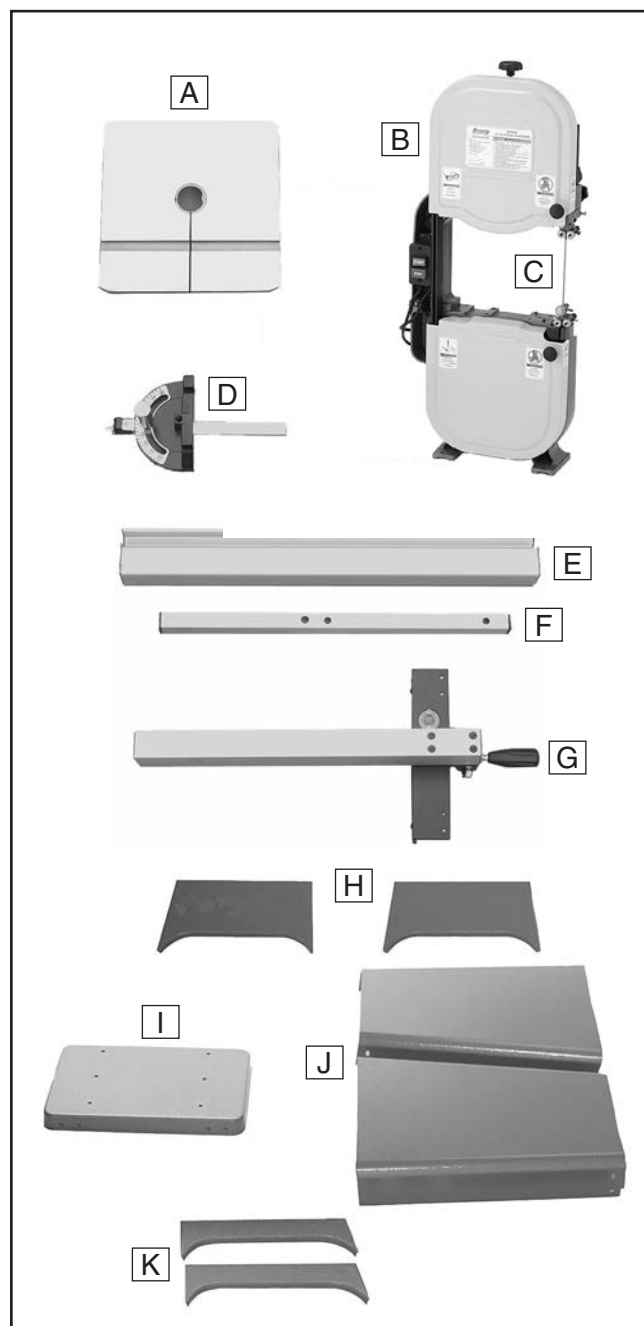


Figure 5. Main components inventory.

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.



Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

#10

1/4"

5/16"

3/8"

7/16"

1/2"



Key

4mm

5mm

6mm

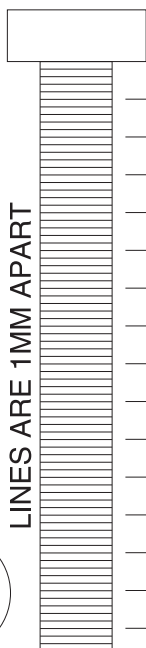
8mm

10mm

12mm

16mm

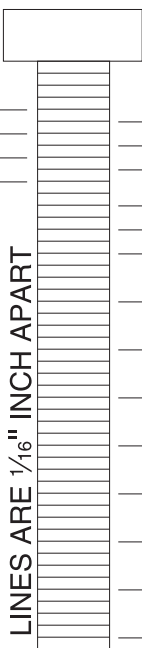
LINES ARE 1MM APART



5mm
10mm
15mm
20mm
25mm
30mm
35mm
40mm
45mm
50mm
55mm
60mm
65mm
70mm
75mm

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

LINES ARE 1/16" INCH APART



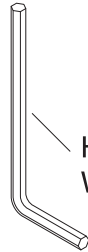
5/16"
7/16"
9/16"
3/4"
7/8"
1"
1 1/4"
1 1/2"
1 3/4"
2
2 1/4"
2 1/2"
2 3/4"
3



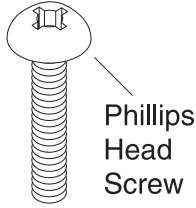
Lock
Nut



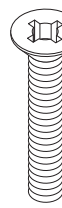
Wing
Nut



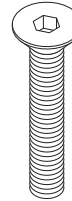
Hex
Wrench



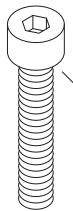
Phillips
Head
Screw



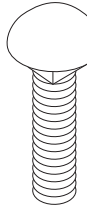
Flat
Head
Screw



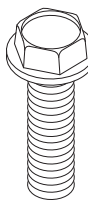
Flat
Head
Cap
Screw



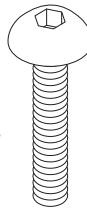
Cap
Screw



Carriage
Bolt



Flange
Bolt



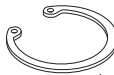
Button
Head
Screw



Tap
Screw



External
Retaining
Ring



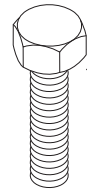
Internal
Retaining
Ring



E-Clip



Set
Screw



Hex
Bolt



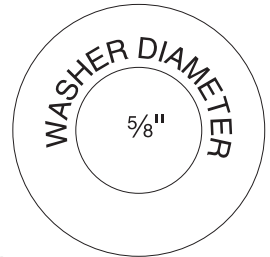
Flat Washer



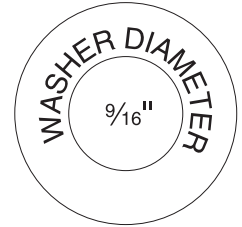
Lock
Washer



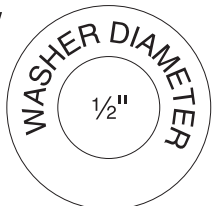
Hex
Nut



WASHER DIAMETER
5/8"



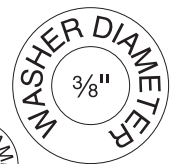
WASHER DIAMETER
9/16"



WASHER DIAMETER
1/2"



WASHER DIAMETER
7/16"



WASHER DIAMETER
3/8"



WASHER DIAMETER
4mm



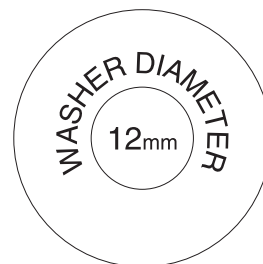
WASHER DIAMETER
5/16"



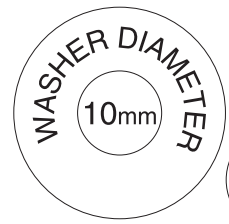
WASHER DIAMETER
5mm



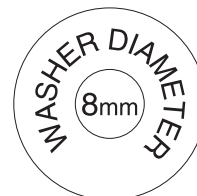
WASHER DIAMETER
1/4"



WASHER DIAMETER
12mm



WASHER DIAMETER
10mm



WASHER DIAMETER
8mm



WASHER DIAMETER
6mm



WASHER DIAMETER
#10

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.

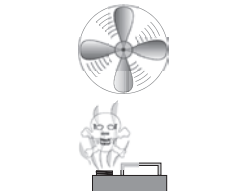
Before cleaning, gather the following:

- 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>Order online at www.grizzly.com OR Call 1-800-523-4777</p>	
--	---

Figure 6. T23692 Orange Power Degreaser.



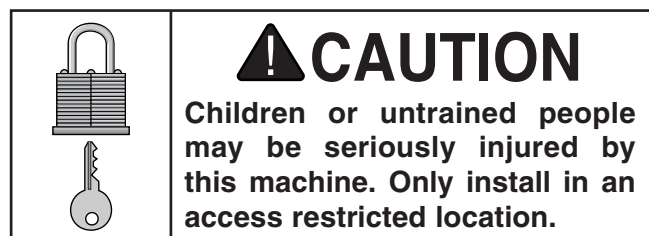
Site Considerations

Weight Load

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

Space Allocation

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



Physical Environment

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

Electrical Installation

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

Lighting

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

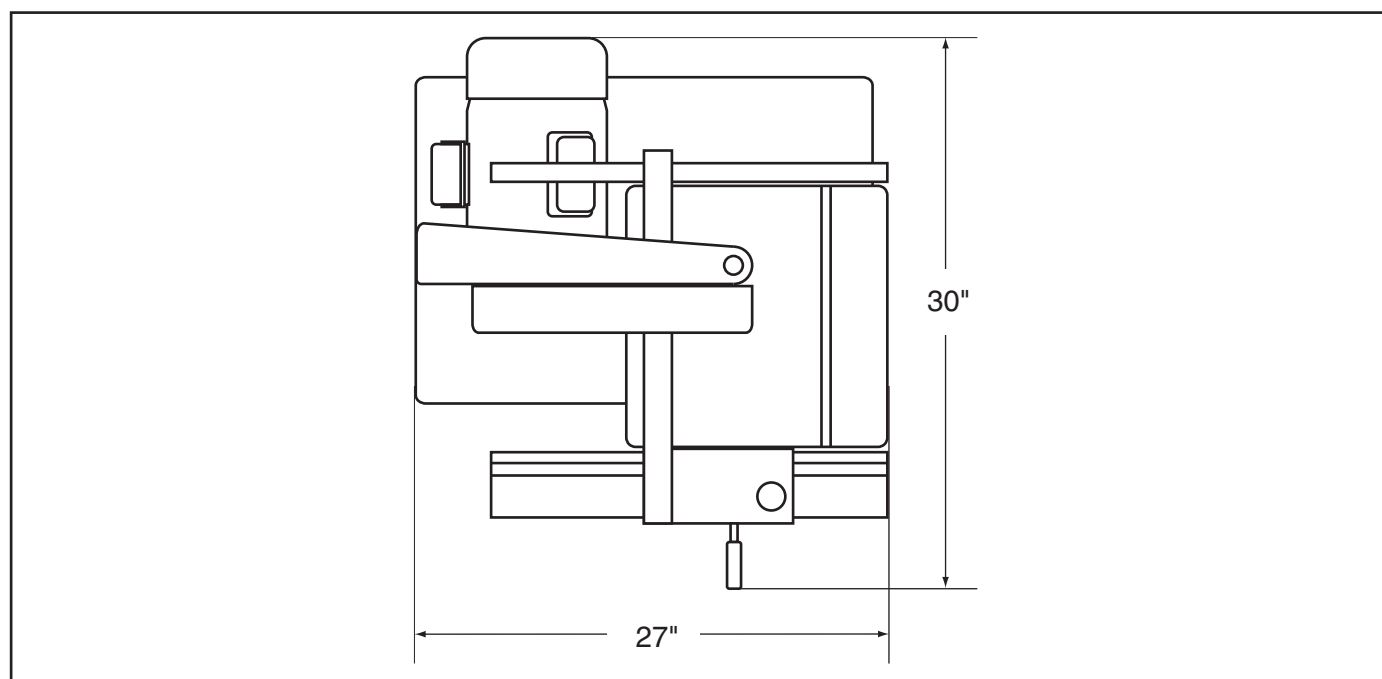


Figure 7. Minimum working clearances.



Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... $\frac{5}{16}$ "

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

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

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

Anchoring to Concrete Floors

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

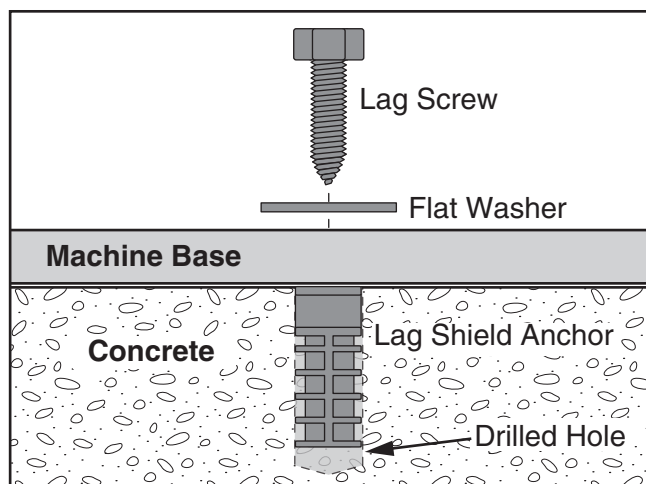


Figure 8. Popular method for anchoring machinery to a concrete floor.

Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, refer to **Needed for Setup** and gather all listed items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

To assemble the bandsaw:

1. Lay one stand side flat on a piece of cardboard to prevent scratching the paint, then attach the upper and lower stand braces to one side, as shown in **Figure 9**, with (8) $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " hex bolts, (8) $\frac{1}{4}$ " flat washers, and (8) $\frac{1}{4}$ "-20 flange nuts.

Note: Only hand-tighten the stand fasteners during these initial steps. Once the stand is completely assembled you will be instructed to fully tighten all fasteners.

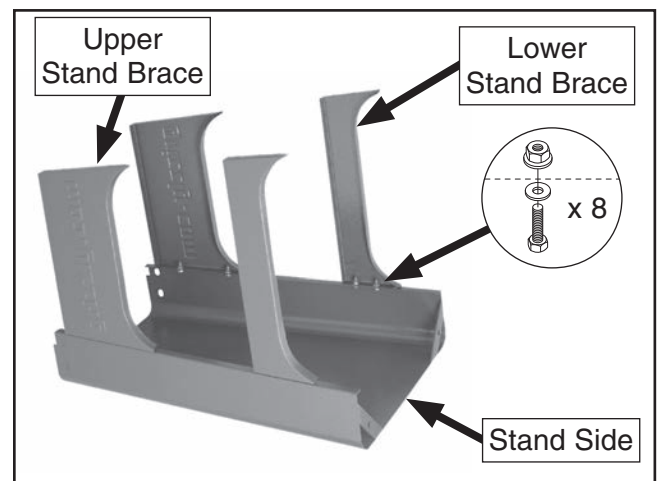


Figure 9. Upper and lower stand braces attached to the stand side.



2. Attach the remaining stand side to the assembly, as shown in **Figure 10**, with (8) $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " hex bolts, (8) $\frac{1}{4}$ " flat washers, and (8) $\frac{1}{4}$ "-20 flange nuts.



Figure 10. Second stand side attached.

3. Install the stand feet, as shown in **Figure 11**, in the bottom of the stand assembly, using a $\frac{3}{8}$ "-16 x 2" stand foot, (2) $\frac{3}{8}$ "-16 hex nuts and (2) $\frac{3}{8}$ " flat washers on each foot in the sequence shown.

Note: *Adjust the feet so that they are approximately the same height—this will make leveling the stand easier in a later step.*

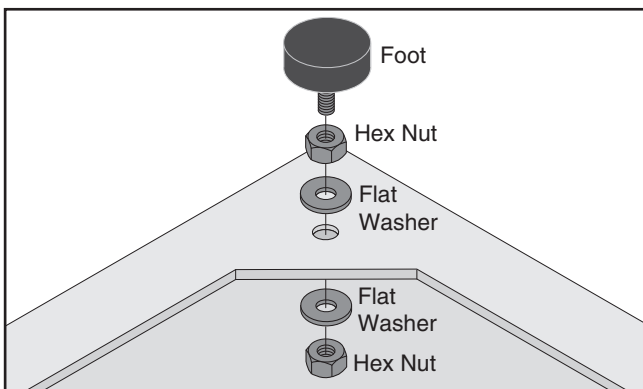


Figure 11. Stand foot installed (1 of 4).

4. Turn the stand assembly upright and attach the top, as shown in **Figure 12**, with (8) $\frac{5}{16}$ "-18 x $\frac{5}{8}$ " carriage bolts and (8) $\frac{5}{16}$ "-18 flange nuts.

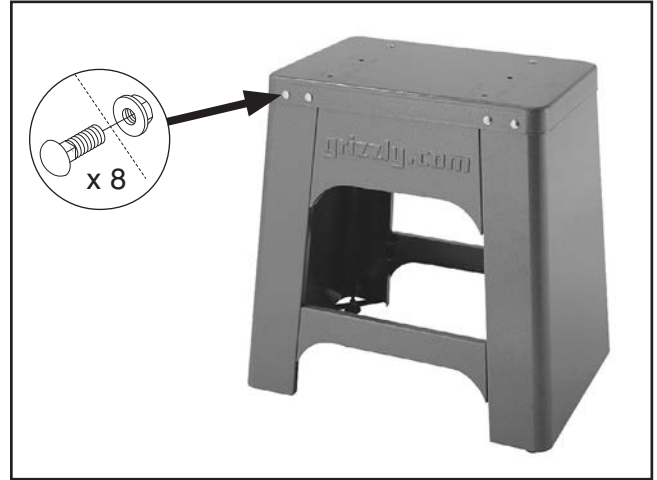


Figure 12. Stand top attached.

5. Square up the stand components and fully tighten all the fasteners.
6. Place the level on top of the stand assembly, as shown in **Figure 13**, then adjust the feet up or down to make the stand top level from side to side and front to back. Make sure that both hex nuts on the feet are tight against the stand assembly so they will not move.



Figure 13. Leveling the stand.



7. With the help of other people, lift the bandsaw assembly onto the stand and align the mounting holes. Have one person hold the bandsaw in place to keep it from falling until you can complete the next step.
8. Secure the bandsaw assembly to the stand with (4) $\frac{5}{16}$ "-18 x $1\frac{1}{2}$ " hex bolts, (4) $\frac{5}{16}$ " lock washers, (8) $\frac{5}{16}$ " flat washers, and (4) $\frac{5}{16}$ "-18 hex nuts, as shown in **Figure 14**.

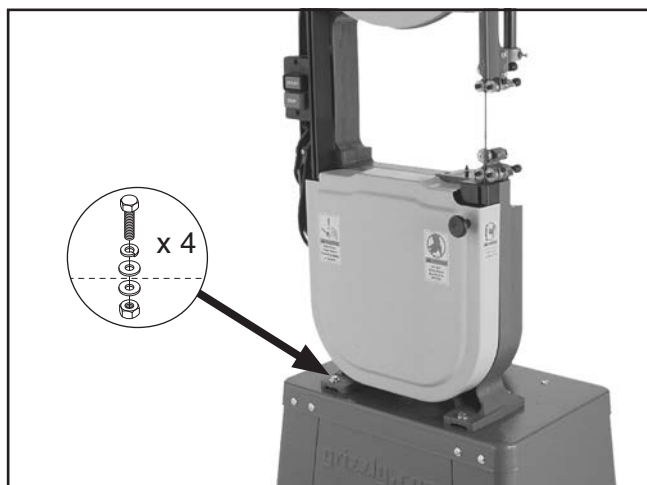


Figure 14. Bandsaw assembly attached to the stand.

9. Remove the table insert and table pin, line up the table slot with the blade, then position the table so that the blade is in the center cut-out.
10. Rotate the table so that the table slot faces to the right, then position the table trunnion on the bandsaw, as shown in **Figure 15**, and secure it with (2) $\frac{5}{16}$ "-18 x $1\frac{1}{4}$ " hex bolts and (2) $\frac{5}{16}$ " lock washers.

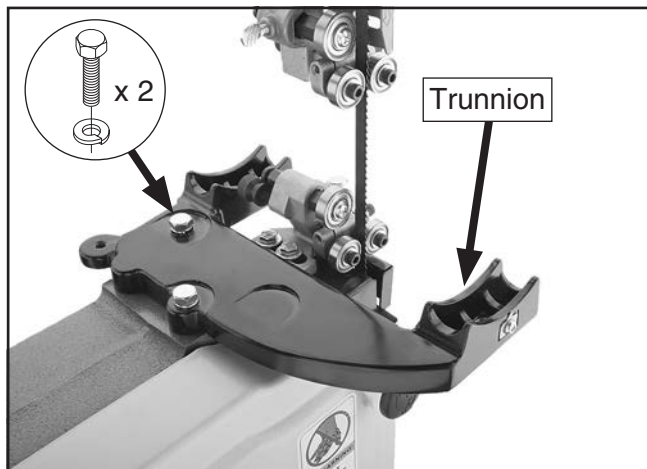


Figure 15. Trunnion installed (table removed for clarity).

11. Tighten the trunnion lock knobs to secure the table.
12. Re-install the table insert and table pin, as shown in **Figure 16**.

IMPORTANT: Make sure you re-install the table pin. This pin keeps the table surfaces on either side of the slot even with the changes in operating pressures and temperature changes.

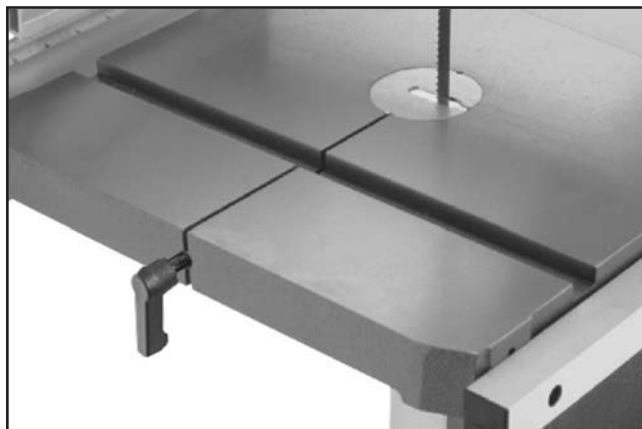


Figure 16. Table pin and insert installed.

13. Attach the rear fence rail to the rear of the table with (2) $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " cap screws, as shown in **Figure 17**.

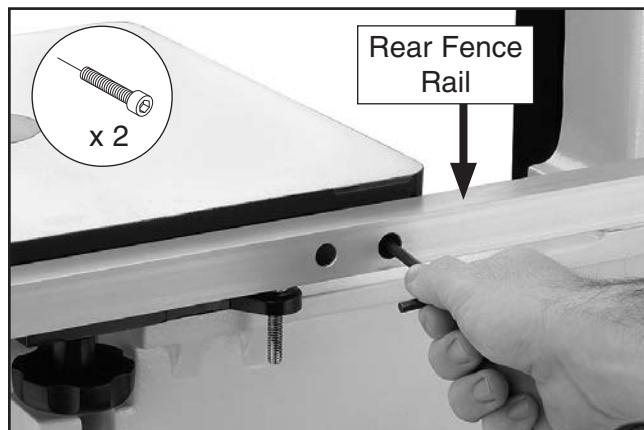


Figure 17. Installing rear fence rail.



14. Attach the front fence rail shown in **Figure 18**, with (2) ¼"-20 x ¾" hex bolts and ¼" flat washers.

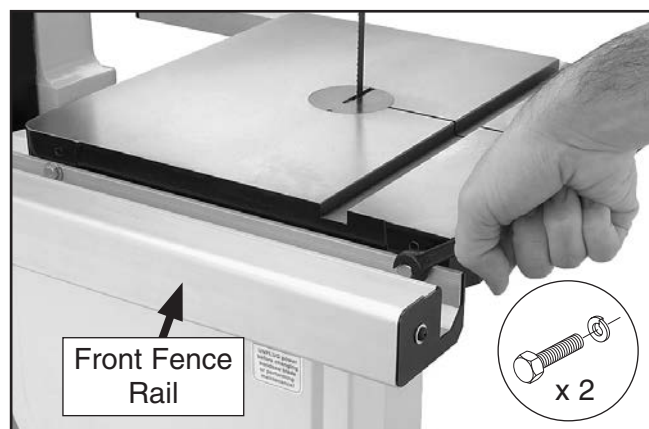


Figure 18. Installing front fence rail.

15. Pull the fence handle up, slip the L-brace over the back of the rear fence rail (see **Figure 19**), and lower the fence onto the front fence rail, as shown in **Figure 20**.

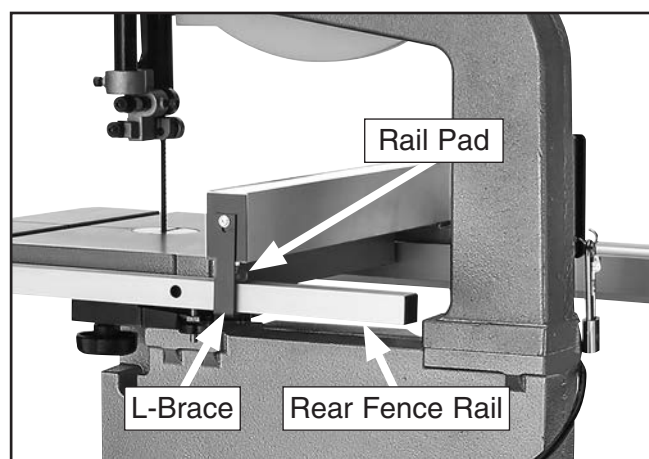


Figure 19. L-Brace positioned over rear fence rail.

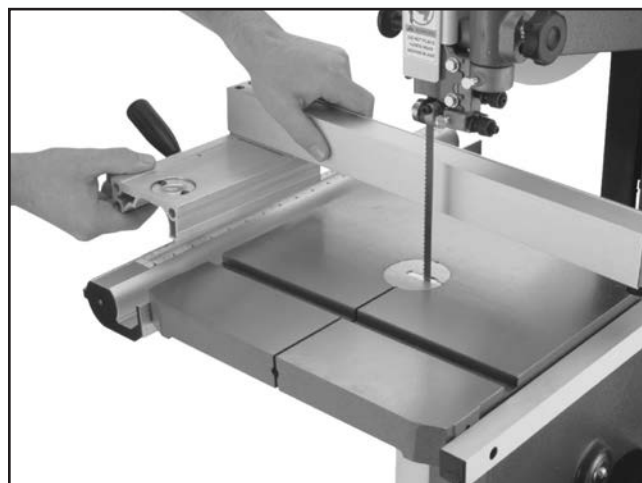


Figure 20. Installing fence onto rails.

16. Thread the quick-release lever (see **Figure 21**) into the upper clutch, and secure the position by tightening the jam nut.

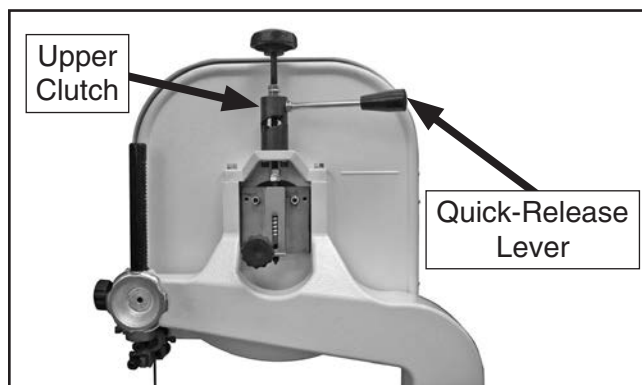


Figure 21. Quick-release lever installed.



Adjustment Overview

The bandsaw is one of the most versatile wood-working machines. However, it has multiple components that must be properly adjusted for the best cutting results.

For practical and safety reasons, some adjustments and test operations must be performed before performing other necessary adjustments. Below is an overview of all the adjustments and the order in which they should be performed:

1. Blade Tracking
2. Test Run
3. Tension Blade
4. Adjusting Blade Support Bearings
5. Adjusting Blade Guide Bearings
6. Table Tilt Calibration
7. Aligning Table
8. Aligning Fence

Blade Tracking

"Tracking" refers to how the blade rides on the bandsaw wheels. Proper tracking is important for maintaining bandsaw adjustments, achieving correct blade tension, and cutting accurately. Improper tracking reduces cutting accuracy, causes excess vibrations, and places stress on the blade and other bandsaw components. The shape of the wheels and the orientation of the wheels in relation to each other determine how the blade tracks.

Bandsaw wheels are either flat or crowned and both shapes track differently. The G0555LX has crowned wheels. As the wheels spin the blade naturally tracks to the highest point of the crown at the center of the wheel (see **Figure 22**).

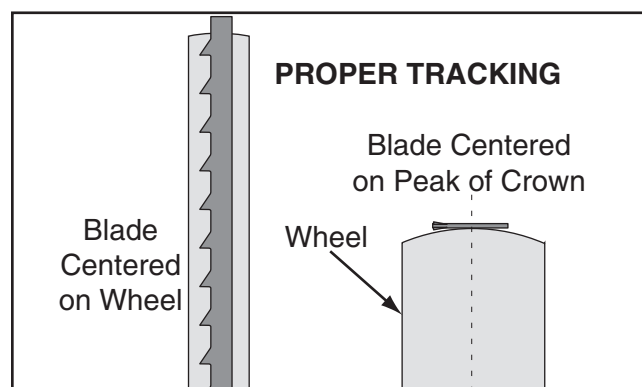


Figure 22. Blade centered on the crown of the wheel.

The wheels of the bandsaw must be aligned for the blade to track correctly on the crown of the wheel. Properly aligned wheels are parallel and coplanar (see **Figure 23**).

Improper blade tension and cutting practices can negatively affect blade tracking. Familiarizing yourself with the ideas and conditions described in **Figure 23** will help you recognize when your saws wheel alignment may need adjusted (refer to **Wheel Alignment** on **Page 50** for detailed instructions on adjusting the tracking).



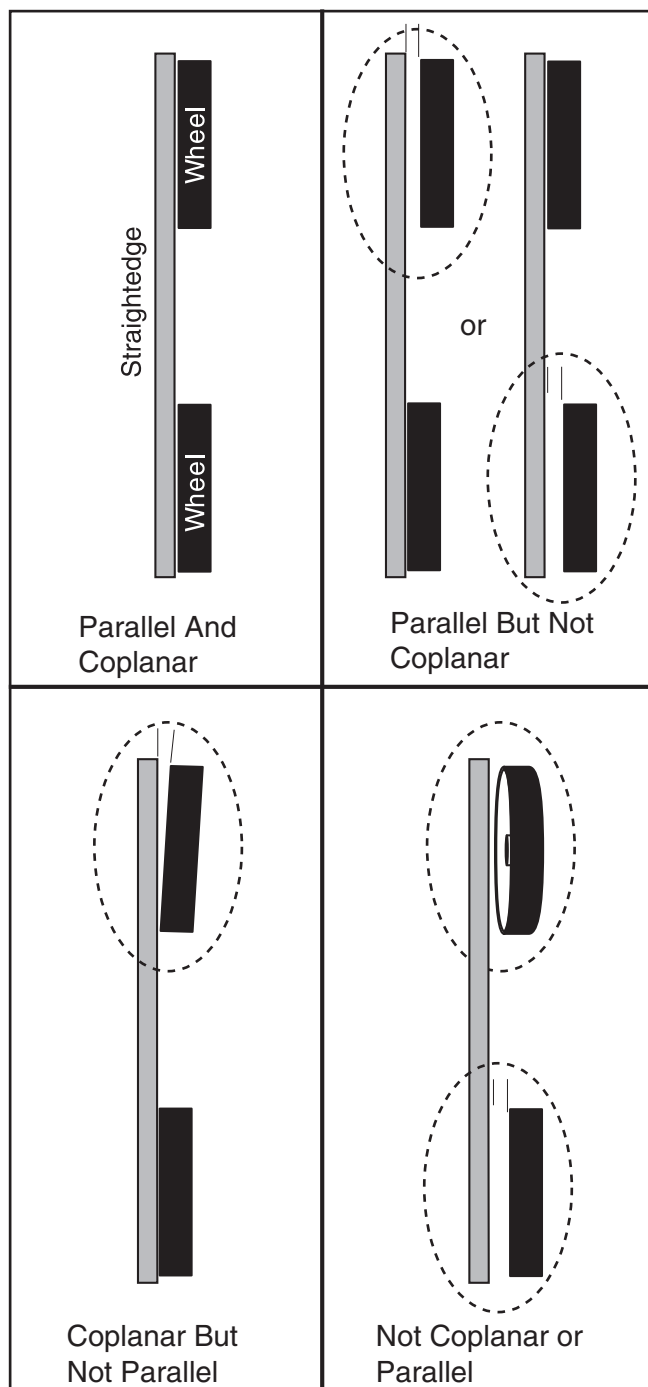


Figure 23. Wheel alignment and misalignment examples.

The wheels on the G0555LX were aligned at the factory, so center tracking is the only adjustment that needs to be performed when the saw is new. This adjustment is necessary before turning the saw **ON** or performing other adjustments.

To center track the blade:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust the upper and lower blade guides away from the blade (refer to **Adjusting Blade Guide Bearings** on **Page 27** for detailed instructions).

Note: When adjusting the blade tracking for the test run in this procedure, the blade must have a reasonable amount of tension to simulate operating conditions. After the test run is successfully completed, you will perform a thorough version of the following steps to more accurately tension the blade.

3. Move the blade tension quick-release lever all the way right (as viewed from the rear of the machine) to apply tension to the blade (see **Figure 24**).

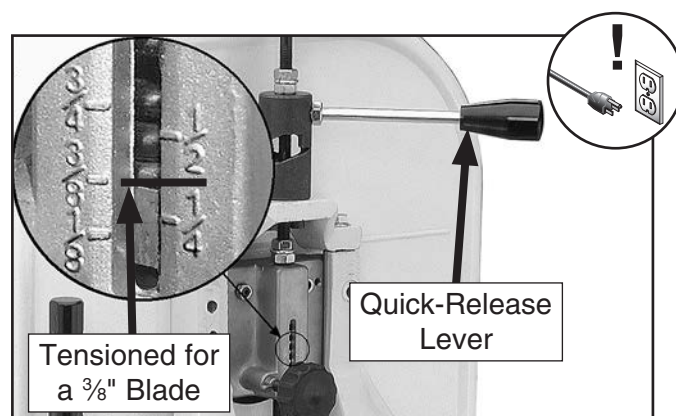


Figure 24. Example of tension applied for a $\frac{3}{8}$ " blade.

4. Use the tension knob on top of the bandsaw to bring the upper edge of the indicator block to the appropriate blade tension scale mark for the blade width (see **Figure 24**).

Note: If you are using the blade that was shipped with the machine, this would be $\frac{3}{8}$ ".

5. Open the upper wheel cover.
6. Rotate the upper wheel by hand several times and watch how the blade rides on the wheel crown (see **Figure 22** on **Page 21** for an illustration of this concept).



— If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, it is properly tracking and you are done with this procedure—proceed to **Dust Collection**.

— If the blade does is not properly tracking, then continue with this procedure to adjust it.

7. Loosen the wing nut on the tracking knob (see **Figure 25**).

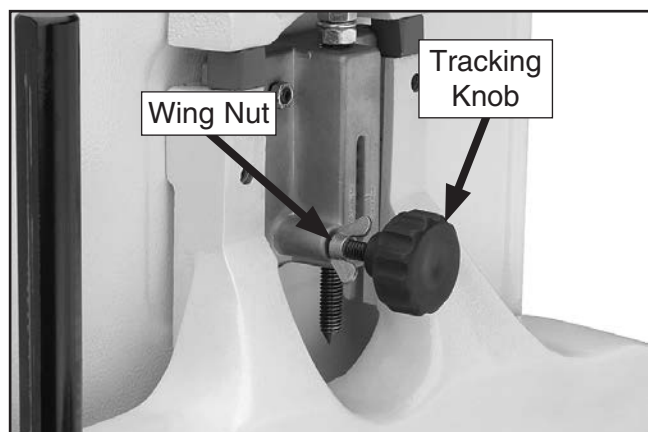


Figure 25. Tracking knob and wing nut.

8. Spin the upper wheel with one hand and slowly adjust the tracking knob with the other hand until the blade consistently tracks in the center of the wheel.
9. Tighten the wing nut to secure the setting, then spin the upper wheel several times to confirm the tracking. If necessary, repeat the adjustment procedure until the blade is tracking properly.
10. Re-adjust the blade guide bearings toward the blade (refer to **Adjusting Blade Guide Bearings** on **Page 27** for detailed instructions).
11. Close and secure the upper wheel cover before operating the bandsaw.

Dust Collection

CAUTION

This machine creates a lot of wood chips/dust during operation. Breathing airborne dust on a regular basis can result in permanent respiratory illness. Reduce your risk by wearing a respirator and capturing the dust with a dust-collection system.

Minimum CFM at 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 dust collection system to machine:

1. Fit the 4" dust hose over the dust port, as shown in **Figure 26**, and secure in place with a hose clamp.

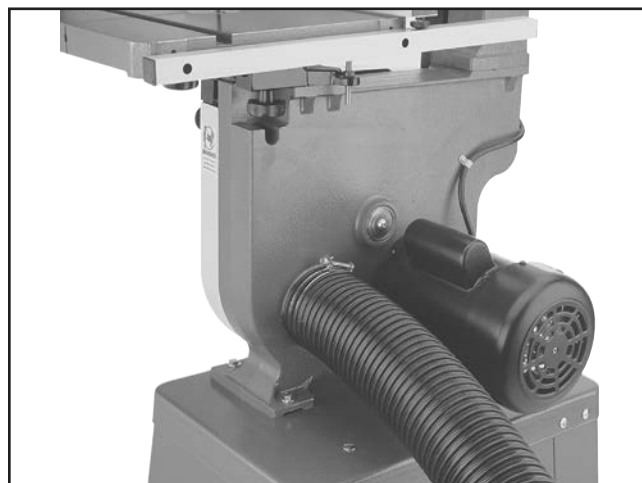


Figure 26. 4" dust hose attached to dust port.

2. Tug the hose to make sure it does not come off.

Note: *A tight fit is necessary for proper performance.*



Test Run

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

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

The Test Run consists of verifying the following:
1) The motor powers up and runs correctly, and 2) the switch disabling padlock disables the switch properly.

WARNING

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

WARNING

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

To test run machine:

1. Clear all setup tools away from machine.
2. Connect machine to power supply.
3. Turn machine **ON**, verify motor operation, and then turn machine **OFF**.

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

4. Insert disabling padlock through switch button.

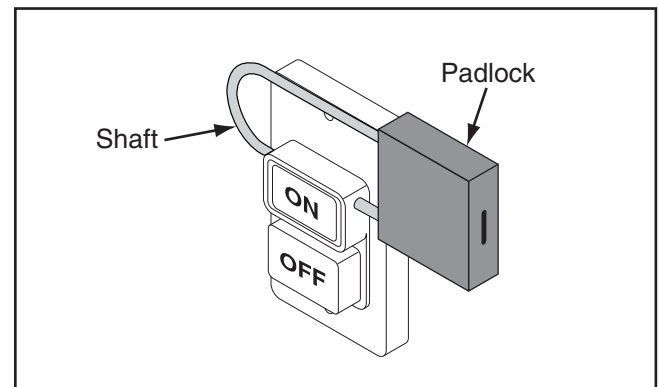


Figure 27. Switch disabling padlock inserted into ON button.

5. Try to start machine by pressing switch button.

Machine should **NOT** start. If it does start, the switch disabling feature is not functioning properly and the switch must be replaced.



Tensioning Blade

A properly tensioned blade is essential for making accurate cuts, maximizing the life of the blade, and making other bandsaw adjustments. However properly tensioned blade will not compensate for cutting problems caused by too rapid of a feed rate, hardness variations between workpieces, and improper blade selection.

The method used to tension the blade is often a matter of preference. Described below are the flutter method and the deflection method. Either method will help safely tension the blade. Experience and personal preference will help you decide which method your prefer. Optimal cutting results for any workpiece are a combination of correct blade selection, proper blade tension, and an appropriate feed rate. Improper blade tension is unsafe, produces inaccurate and inconsistent results, and introduces unnecessary wear on bandsaw components. Over-tensioning the blade increases the chance of the blade breaking or wheel misalignment. Under-tensioned blades wander excessively while cutting and will not track properly during operation.

Note: *Tensioning the blade according to the blade tension scale before the **Test Run** was an approximate tension. The following procedures fine-tunes the blade tension.*

Flutter Method

1. DISCONNECT MACHINE FROM POWER.
2. Make sure the blade is properly center tracking as instructed in the **Blade Tracking** on **Page 21**.

3. Raise the guide post all the way and move the upper and lower guide bearings away from the blade.
4. Engage the blade tension quick release lever to apply tension to the blade.
5. Connect the bandsaw to power, and turn the bandsaw **ON**.
6. Using the blade tension adjustment knob, slowly decrease blade tension until you see the blade start to flutter.
7. Slowly increase the tension until the blade stops fluttering, then tighten the blade tension adjustment knob and additional $\frac{1}{8}$ to $\frac{1}{4}$ of a turn.
8. Look at what the tension gauge reads and use that as a guide for tensioning that specific blade in the future.

Note: *Do not rely on this setting for other blades or for long periods of time because all blades require specific tensioning and stretch with use. If you notice a decrease in performance at the setting repeat this procedure.*

*With extended use, the blade tensioning system may need to be reset. Refer to **Blade Tensioner** on **Page 54** for details.*

9. Disconnect the machine from power.
10. Re-adjust blade guides as described in **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages 26– 27**.



Deflection Method

The deflection method is much more subjective than the flutter method. Each blade will deflect differently and every user will determine what "moderate pressure" means. The following are general guidelines for tensioning the blade with this method.

To tension the machine blade:

1. DISCONNECT MACHINE FROM POWER.
2. Make sure the blade is properly tracking as instructed in the **Blade Tracking** section on **Page 21**.
3. Raise the guide post all the way and move the upper and lower guide bearings away from the blade.
4. Engage the blade tension quick-release lever to apply tension to the blade.
5. Using moderate pressure, push the center of the blade sideways.

— If the blade deflects approximately $\frac{1}{4}$ " it is properly tensioned. Proceed to **Step 6**.

— If the blade deflects less than $\frac{1}{4}$ " it is over-tensioned. Turn the blade tensioning knob counter clockwise two full turns and repeat **Step 4**.

— If the blade deflects $\frac{1}{4}$ " or more, the blade is not properly tensioned. Apply tension to the blade incrementally and repeat **Step 6** until properly tensioned.

6. Re-adjust blade guides as described in **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages– 27**.

NOTICE

When using different size blades, the blade tensioning system may need to be reset for correct operation. Refer to *Blade Tensioner* on **Page 54** for detailed instructions.

Adjusting Blade Support Bearings

The support bearings are positioned behind the blade on the blade guides and prevent it from deflecting backward during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and keeps the blade teeth from coming in contact with the blade guides while cutting.

There are support bearings on the upper and lower blade guide assemblies. Both adjust in the same manner.

IMPORTANT: The blade is tracking and tensioned correctly before performing this procedure.

Tools Needed

Qty

Wrench 10mm	1
Feeler Gauge 0.016".....	1

To adjust the support bearings:

1. DISCONNECT MACHINE FROM POWER!
2. Familiarize yourself with the support bearing controls shown in **Figure 28**.

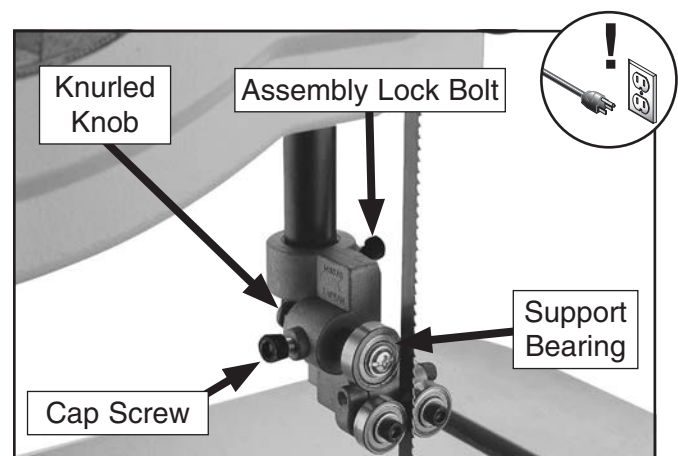


Figure 28. Upper support bearing assembly and controls.



3. Loosen the guide assembly lock bolt so that the support bearing can be rotated perpendicular to the blade in the next step.
4. Rotate the blade guide assembly until the face of the support bearing is perpendicular to the blade, as illustrated in the **Figure 29**.

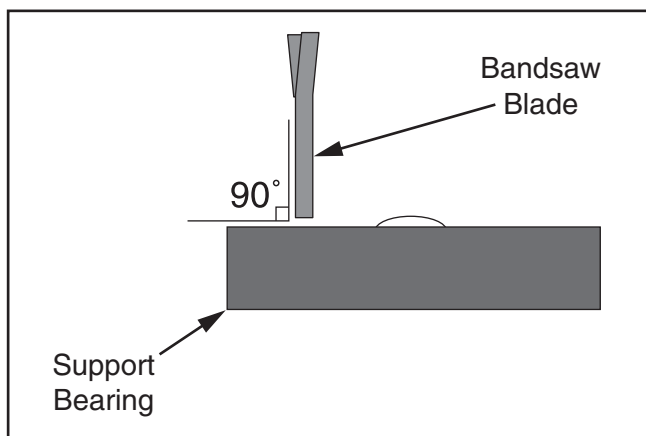


Figure 29. The face of the support bearing must be perpendicular (90°) to the blade.

5. Tighten the assembly lock bolt (see **Figure 28**).
6. Loosen the cap screw (see **Figure 28**) on the support bearing adjustment shaft.
7. Use the knurled knob to position the support bearing approximately 0.016" away from the back of the blade, as illustrated in **Figure 30**. This can be measured with a feeler gauge.

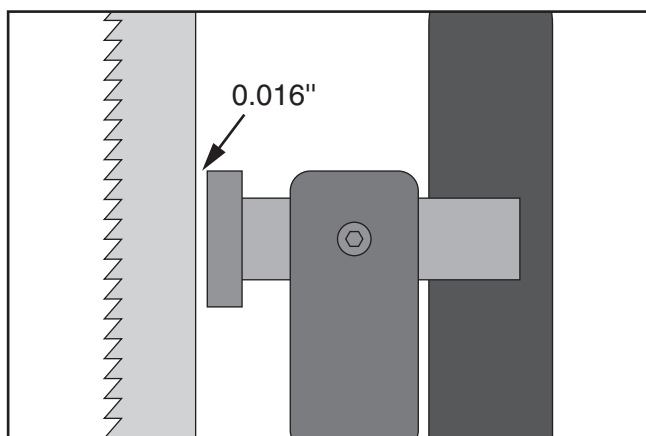


Figure 30. Blade should be aligned approximately 0.016" away from the bearing edge.

8. Tighten the cap screw to lock the support bearing in place.

Adjusting Blade Guide Bearings

Properly adjusting the blade guides provides side-to-side support to help keep the blade straight while cutting.

There are blade guide bearings on the upper and lower blade guide assemblies. Both adjust in the same manner.

IMPORTANT: The blade is tracking and tensioned correctly before performing this procedure (see **Tensioning Blade** on **Page 25**).

Tool Needed	Qty
Hex Wrench 4mm.....	1

To adjust the upper and lower blade guides:

1. DISCONNECT MACHINE FROM POWER!
2. Familiarize yourself with the blade guide controls shown in **Figure 31**.

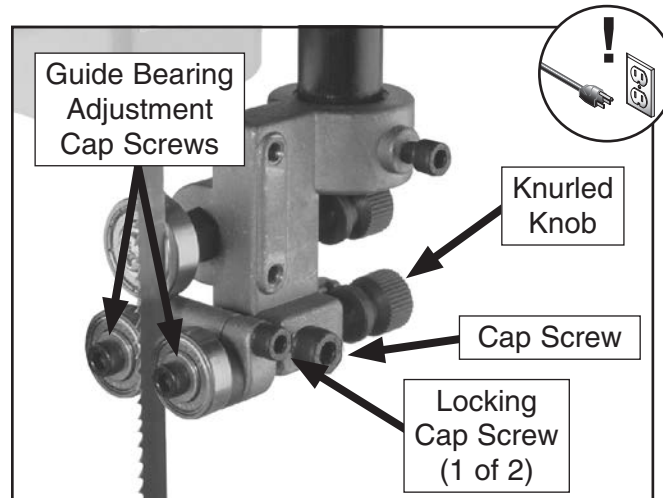


Figure 31. Blade guide bearing controls.



3. Loosen the cap screw shown in the figure above, then use the knurled knob to adjust the guide bearings laterally so the bearing faces are just behind the blade gullet, as illustrated in **Figure 32**, and re-tighten the thumbscrew to secure the setting.

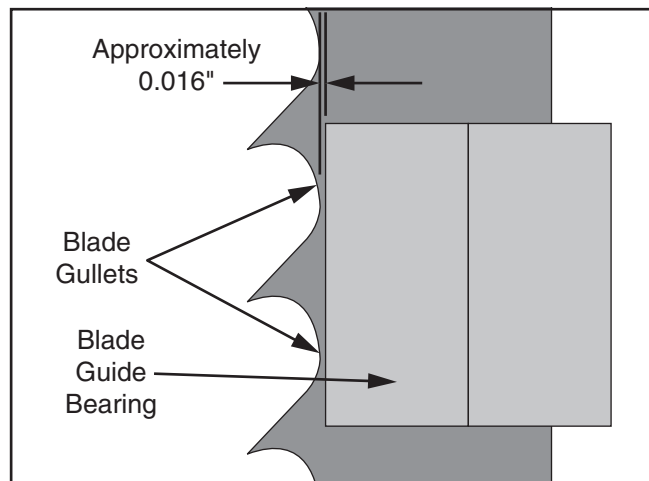


Figure 32. Blade guide bearing positioned just behind the blade gullets.

Note: With wider blades, it may not be possible to bring the guide bearings just behind the blade gullets. Position them as far forward as possible without allowing the guide bearing housing to touch the back of the blade.

NOTICE

The set of the teeth increase the chance of the bearings contacting the teeth during a cutting operation as the set of the teeth is wider than the blade. The support bearing must be set to prevent this.

4. Loosen both cap screws behind the guide bearings, then rotate the adjustment cap screws so the bearings evenly and lightly touch the sides of the blade (see the illustration in **Figure 33**) without deflecting it one way or the other.

Note: When the blade guide bearings are properly adjusted against the blade, they should rotate smoothly as the blade moves.

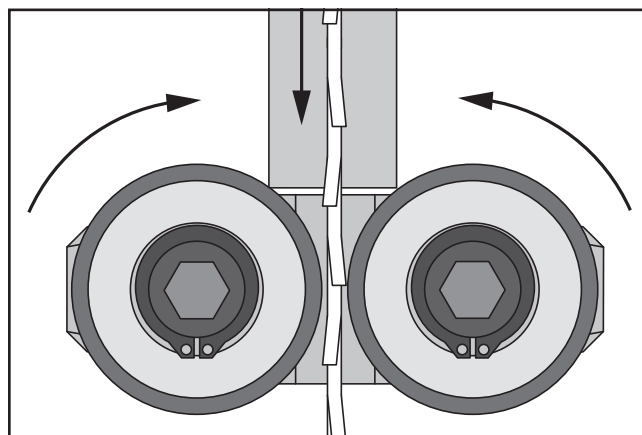


Figure 33. Blade guide bearings evenly and lightly touching the sides of the blade.

5. Using a hex wrench, tighten the locking cap screws to secure the settings. To prevent unwanted movement while tightening, use a hex wrench to hold the adjustment cap screws in place while re-tightening the locking cap screws. Re-check the setting after tightening.

NOTICE

Whenever changing a blade or adjusting the blade tension or tracking, the support and guide bearings must be re-adjusted before resuming operation to ensure proper blade support.



Table Tilt Calibration

When properly adjusted, the positive stop bolt enables the table to be quickly returned perpendicular to the blade.

To tilt the table to the left, the positive stop bolt (see **Figure 34**) must be lowered, then re-adjusted after the table is returned to 0°.

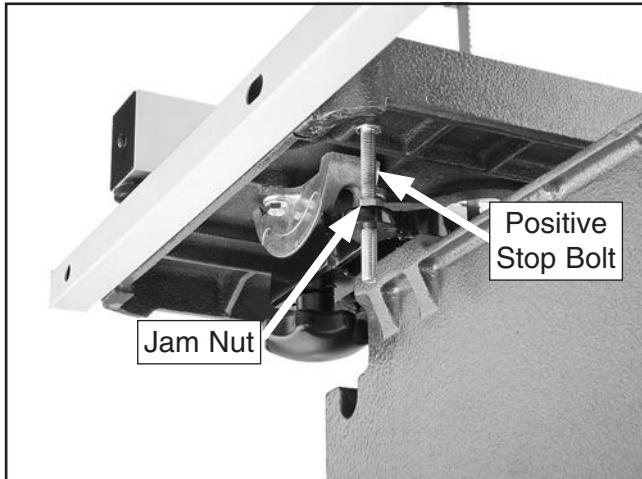


Figure 34. Positive stop bolt set so table is 90° to the blade (viewed from behind the table).

Tools Needed

	Qty
Wrench 13mm	1
Phillips Screwdriver #2	1
Machinist's Square	1

To set the positive stop so the table is 90° to the blade:

1. Make sure the blade is correctly tensioned as described in **Tensioning Blade** on **Page 25**.
2. DISCONNECT MACHINE FROM POWER!
3. Loosen the two table lock knobs that secure the table to the trunnions.
4. Loosen the jam nut that locks the positive stop bolt in place.

5. Completely raise the upper blade guide assembly, then place the machinist's square flat on the table and against the side of the blade, as illustrated in **Figure 35**.

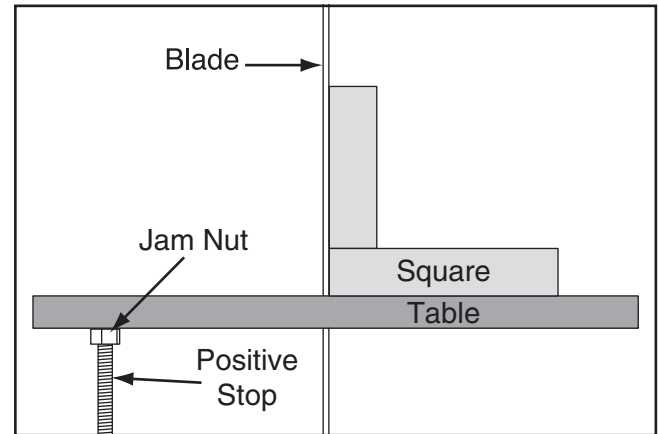


Figure 35. Using a square to adjust the table perpendicular to the side of the blade.

6. Raise or lower the positive stop bolt until the table is perpendicular to the side of the blade, then re-tighten the jam nut (see **Figure 34**) against the casting to secure the setting.
7. Rest the table on the positive stop bolt, then re-tighten the table lock knobs.
8. Observe the position of the table tilt pointer on the tilt scale located underneath the front of the table (see **Figure 36**).

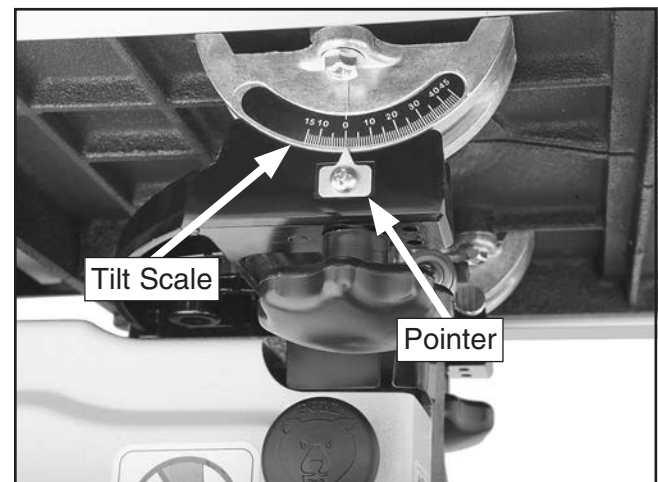


Figure 36. Location of the table tilt scale.

9. Loosen the Phillips head screw securing the pointer, adjust the pointer to 0°, then retighten the Phillips head screw.



Aligning Table

To ensure cutting accuracy, the table must be aligned so the miter slot is parallel with the bandsaw blade.

Tools Needed	Qty
Straightedge 2'	1
Fine Ruler	1
Masking Tape	As Needed
Wrench 10mm	1

To align the table miter slot parallel to the blade:

1. Make sure the blade is correctly tensioned as described in the **Tensioning Blade** subsection earlier in this manual.
2. **DISCONNECT MACHINE FROM POWER!**
3. Make sure the table is perpendicular to the side of the blade and is locked in place.
4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade (see **Figure 37**).

Note: Make sure the straightedge does not go across a tooth while performing this step.

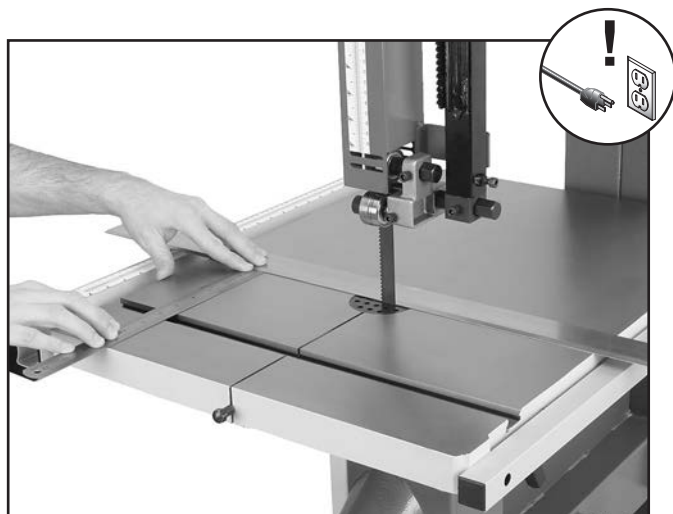


Figure 37. Placing a straightedge along the blade and measuring to the miter slot.

5. Use the fine ruler to measure the distance between the straightedge and miter slot at the front and back of the table (see **Figure 37**).

— If the distances are the same, no further adjustments are required.

— If the distances are different, continue with **Step 6**.

6. Loosen the six flange bolts that secure the table to the trunnion brackets (see **Figure 38**).

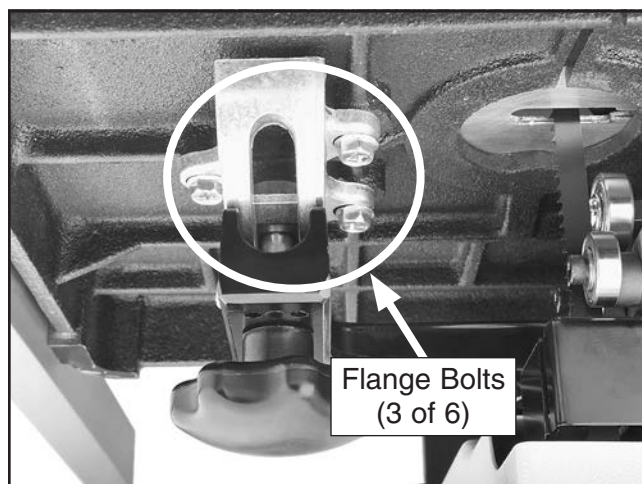


Figure 38. Location of trunnion bracket flange bolts.

7. Position the table so that the distances are equal between the straightedge and miter slot at the front and the back of the table.
8. Taking care not to move the table further, retighten the flange bolts.
9. Verify the setting and, if necessary, repeat this procedure until you are satisfied with the adjustment.



Aligning Fence

To ensure accurate cutting when using the fence, the face of the fence must be parallel to the table miter slot and, thus, to the side of the blade.

Tool Needed	Qty
Hex Wrench 5mm.....	1

To align the fence parallel with the miter slot:

1. Make sure the miter slot is parallel with the blade, as instructed in the previous **Aligning Table** procedure.
2. DISCONNECT MACHINE FROM POWER!
3. Install the fence on the right side of the blade, even with the edge of the miter slot, then lock it in place.
 - If the fence is parallel with the miter slot, no additional adjustment is necessary.
 - If the fence is not parallel with the miter slot, proceed to **Step 4**.
4. Loosen the four fence adjustment cap screws shown in **Figure 39**, adjust the fence parallel to the miter slot, then re-tighten the cap screws to secure the setting.



Figure 39. Location of the fence adjustment cap screws.

Calibrating Miter Gauge

The miter gauge needs to be calibrated to the blade when it is first mounted in the miter slot.

Tools Needed	Qty
Phillips Screwdriver #2	1
Square	1

To calibrate miter gauge:

1. DISCONNECT MACHINE FROM POWER!
2. Place one edge of square against face of miter gauge and other edge of square against blade side, as shown in **Figure 40**.
 - If square rests flush and evenly against *both* miter gauge face *and* blade side, then no adjustments are necessary.
 - If square *does not* rest flush and evenly against *both* miter gauge face *and* blade side, the miter gauge must be calibrated; proceed to **Step 3**.

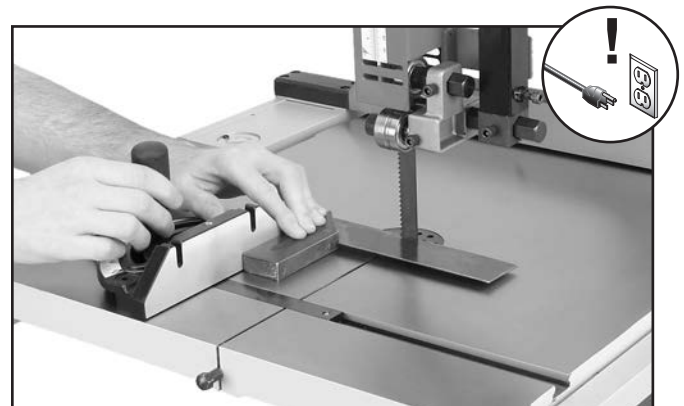


Figure 40. Example of squaring miter gauge to blade.

3. Loosen lock knob on miter gauge and adjust face flush with edge of square.
4. Tighten lock knob, and verify square rests flush and evenly against *both* miter gauge face *and* blade side.
5. Loosen screw that secures angle pointer, adjust pointer to 0° mark on scale, then retighten screw to secure setting.

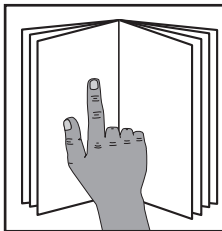


SECTION 4: OPERATIONS

Operation Overview

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

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



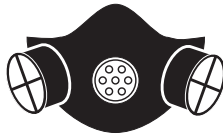
WARNING

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



WARNING

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



NOTICE

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

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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts table tilt, if necessary, to correct angle of desired cut.
3. If using fence, adjusts it for width of cut and then locks it in place. If using miter gauge, adjusts angle and locks it in place.
4. Loosens guide post lock knob, adjusts upper blade guide height to just clear the workpiece (no more than $\frac{1}{4}$ "), then retightens guide post lock knob.
5. Checks to make sure workpiece can safely pass all the way through blade without interference from other objects.
6. Puts on safety glasses and respirator.
7. Starts dust collector and bandsaw.
8. Holds workpiece firmly and flatly against both table and fence (or miter gauge), and then pushes workpiece into blade at a steady and controlled rate until cut is complete.

Operator is very careful to keep fingers away from blade and uses a push stick to feed narrow workpieces.

9. Stops bandsaw.



Basic Functions of a Bandsaw

A properly adjusted bandsaw can be safer to operate than most other saws and performs many types of cuts with ease and accuracy. It is capable of performing the following types of cuts:

Straight Cuts

- Mitters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades often for best performance. Check guide, tension, and alignment settings periodically and adjust when necessary to keep the saw running in top condition.
- Use light and even pressure while cutting. Light feeding pressure makes it easier to cut straight and prevents undue friction or strain on the bandsaw components.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners. Use relief cuts when possible.
- Misusing the saw or using incorrect techniques (e.g. twisting the workpiece, incorrect feed rate, etc.) is unsafe and results in poor cuts.

Disabling & Locking Switch

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

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

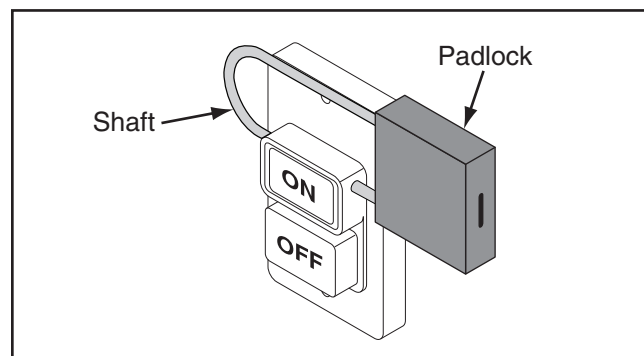


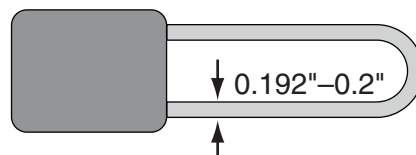
Figure 41. Switch disabled by a padlock.

WARNING

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

NOTICE

The padlock shaft diameter is important to the disabling function of the switch. With any padlock used to lock the switch, test the switch after installation to ensure that it is properly disabled.



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 bandsaw 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 and bind 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 break blade teeth and cause 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. A workpiece supported on the bowed side may move unexpectedly resulting in severe injury.

Guide Post

The guide post, shown in **Figure 42**, allows the upper blade guide assembly to be quickly adjusted for height. When cutting, the blade guides must always be positioned so they just clear (no more than $\frac{1}{4}$ ") the workpiece.

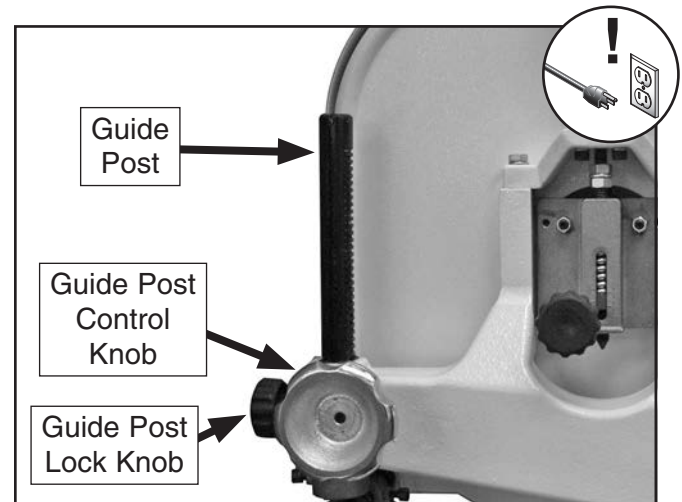


Figure 42. Guide post and lock knob.

To adjust the height of the guide post:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen the guide post lock knob.
3. Using the guide post control knob, adjust the height of the guide post so that the blade guide assembly just clears (no more than $\frac{1}{4}$ ") the workpiece.
4. Tighten the lock knob to secure the setting.



Table Tilt

The table can be tilted to make angled or beveled cuts. A simple tilt scale is provided on the trunnion for a quick gauge (see **Figure 43**). For more accurate results use a protractor.

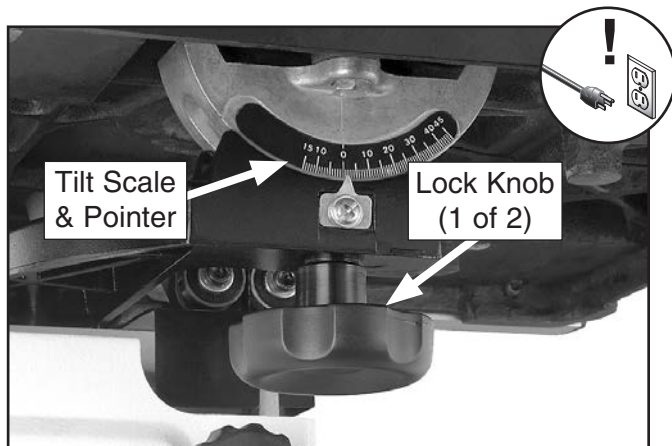


Figure 43. Table tilt controls.

Note: When tilting the table to the left, the positive stop bolt must be lowered. Be sure to re-adjust it when returning the table to be perpendicular with the blade.

To tilt the table:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen both table lock knobs underneath the table.
3. Tilt the table to the desired angle, then re-tighten the lock knobs.

Blade Speed

The Model G0555LX offers blade speeds of 1800 and 3100 FPM. Speed changes are made by re-positioning the V-belt in different pulley grooves.

Keep in mind, cutting results are not just related to blade speed. Other factors include: the type of workpiece, the blade being used for the operation, and the feed rate.

Use the chart below as a general guide for which blade speeds to use for various operations:

Type of Cutting Operation	Blade Speed (FPM)
General Woodworking	3100
Super Dense Hardwood	1800
Fast/Average Feed Rate	3100
Requires Slow Feed Rate	1800
Rough Edges Acceptable	3100
Requires Smooth Edges	1800
Quick, Production Cuts	3100
Detailed, Intricate Cuts	1800

Tool Needed	Qty
Hex Wrench 6mm.....	1

To change the blade speed:

1. DISCONNECT MACHINE FROM POWER!
2. Open the lower wheel cover, and loosen the motor mount cap screws shown in **Figure 44**.

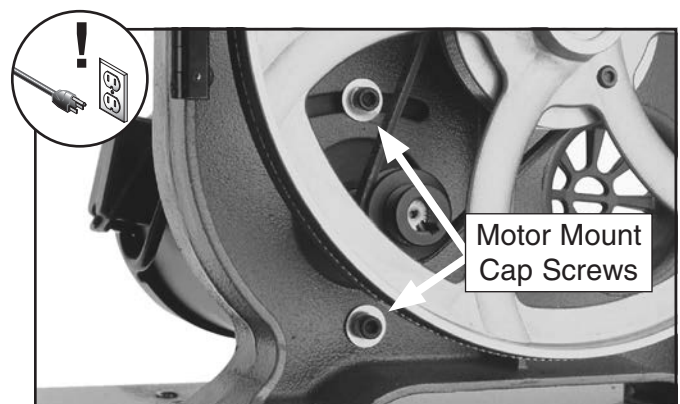


Figure 44. Motor mount cap screws.



3. Pivot the motor so the upper cap screw slides to the right of the slot. This releases the belt tension.
4. Position the belt in the pulley grooves needed (see **Figure 45**) for the desired speed.

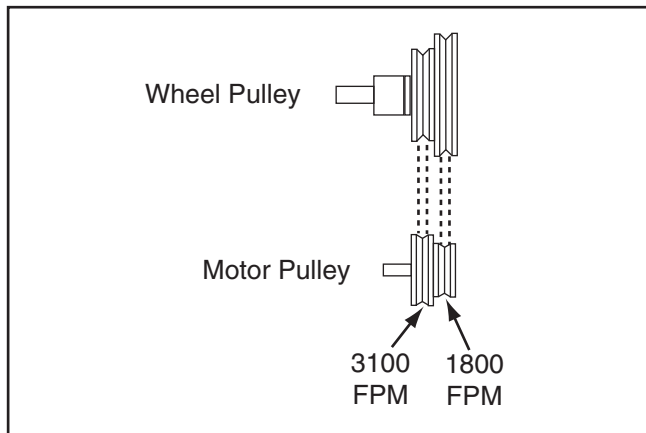


Figure 45. Belt positions for different speeds.

5. Pivot the motor so the upper cap screw slides left in the slot.
6. Apply pressure on the motor so there is approximately $\frac{1}{4}$ " V-belt deflection (see **Figure 46**), then re-tighten the motor mount cap screws.

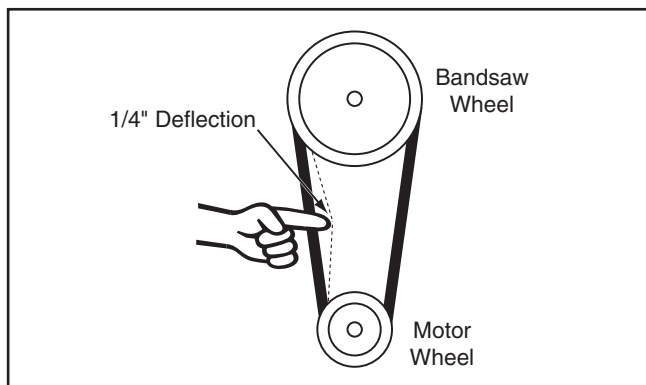


Figure 46. $\frac{1}{4}$ " V-belt deflection.

7. Close the lower wheel cover before re-connecting the bandsaw to power.

Blade Information

Blade Dimensions

Length Range..... $93\frac{1}{2}$ "
Width Range..... $\frac{1}{8}$ "– $\frac{3}{4}$ "

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. Blades will vary slightly even in the same length because of how they are welded. Refer to the **Accessories** section later in this manual for blade replacements from Grizzly.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 47** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

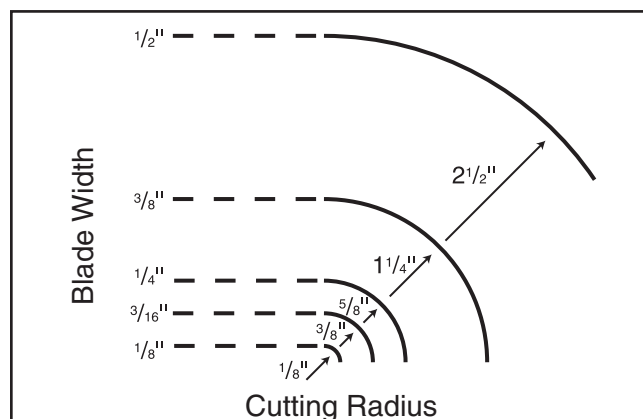


Figure 47. Recommended cutting radius per blade width.



- **Straight Cutting:** Use the largest width blade that you own. Large blades excel at cutting straight lines and are less prone to wander.

Tooth Style

Figure 48 illustrates the three main blade tooth styles:

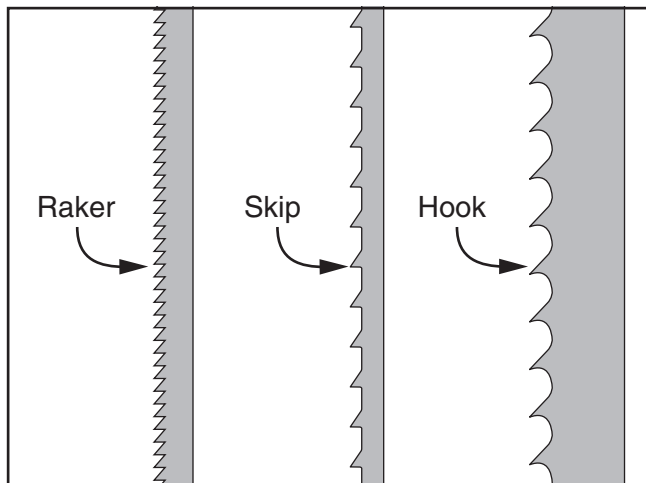


Figure 48. Main blade tooth styles.

- **Raker:** Considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material. As a result, smooth cuts can be achieved without cutting fast or generating more heat than other tooth types.
- **Skip:** Similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades.
- **Hook:** The teeth have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Measured as TPI (teeth per inch), tooth pitch determines the number of teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine-pitched blades on harder woods and coarse-pitched blades on softer woods.

Blade Care

A bandsaw blade is a thin piece of steel that is subjected to tremendous stresses when cutting. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation. Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat. Resin/pitch cleaners are excellent for cleaning dirty blades.

Blade Breakage

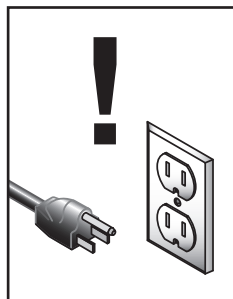
Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or blade guides.

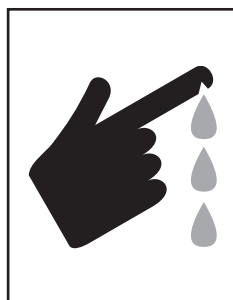


The most common causes of blade breakage are:

- Faulty alignment/adjustment of the guides.
- Forcing/twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull teeth or damaged tooth set.
- Over-tensioned blade.
- Upper blade guide assembly set too high above the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving blade tensioned when not in use.
- Using the wrong TPI for the workpiece thickness. (The general rule of thumb is three teeth in the workpiece at all times.)

Changing Blade

	<p>! WARNING</p> <p>Disconnect bandsaw from power BEFORE changing blade. Serious personal injury could occur if machine is started during this procedure.</p>
--	---

	<p>! CAUTION</p> <p>LACERATION HAZARD! Bandsaw blades are sharp and difficult to handle. Wear heavy leather gloves while handling to reduce the risk of being cut.</p>
---	--

To change blade:

1. DISCONNECT MACHINE FROM POWER!
2. Move the blade tension quick release lever to the left to release blade tension.

3. Adjust the upper blade guide assembly all the way up, and move the blade guides completely away from the blade.
4. Remove the fence and miter gauge from the table, then remove the table insert and table pin (see **Figure 49**).

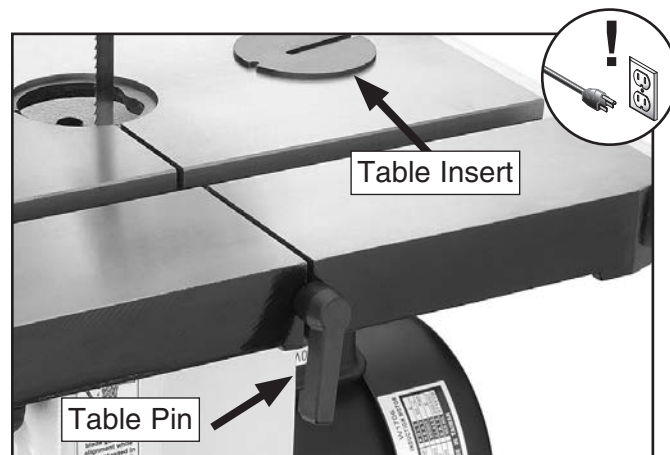


Figure 49. Table insert and table pin.

5. Open the upper and lower wheel covers.
6. Put on heavy leather gloves.
7. Slip the blade off the wheels, rotate it 90°, and slide it through the table slot and off the machine.



Figure 50. Changing the blade.



8. Position the blade so that the teeth are facing to the right and down toward the table, then slide it through the table slot.

Note: *If the teeth will not point downward in any orientation, the blade is inside out. Remove the blade and twist it right-side out.*

9. Rotate the blade 90°, then slip it over the wheels while making sure it is properly positioned between the blade guards and guides.

10. Move the blade tension quick release lever to the right, for rough tensioning the blade. Using the blade tension adjustment knob and tension scale, fine tune the tension for the new blade.

— If you successfully move the quick release lever to the right and the blade is properly tensioned, continue with **Step 6**.

— If you have difficulty moving the blade tension quick release lever to the right or the blade is a different length from the previous blade, adjust the blade tensioner, as instructed in the **Blade Tensioner** on **Page 54**, then continue with **Step 6**.

11. Adjust the blade tracking (see **Blade Tracking** on **Page 21**).

12. Adjust the support bearings and the upper/lower blade guides (see **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages 26–27**).

13. Close the wheel covers, and replace the table insert and table pin.

Installing 1/4" Eccentrics

The model G0555LX comes with 3/8" eccentrics (PN P0555LX129) installed behind the guide bearings. To make guide bearing adjustments easier when using 1/8" blades, a set of 1/4" eccentrics (PN P0555LX136) has also been included.

The reduced thickness of the 1/4" eccentrics provides more space for guide bearing adjustments with 1/8" blades, helping ensure blade support bearings will not damage the blade tooth set.

Tool Needed	Qty
Hex Wrench 4mm.....	1

To install 1/4" eccentrics:

1. DISCONNECT MACHINE FROM POWER!
2. Put on heavy leather gloves and open wheel covers. Remove blade as described in **Changing Blade** on **Page 38**.
3. Remove (2) guide bearing adjustment cap screws and guide bearings (see **Figure 51**).

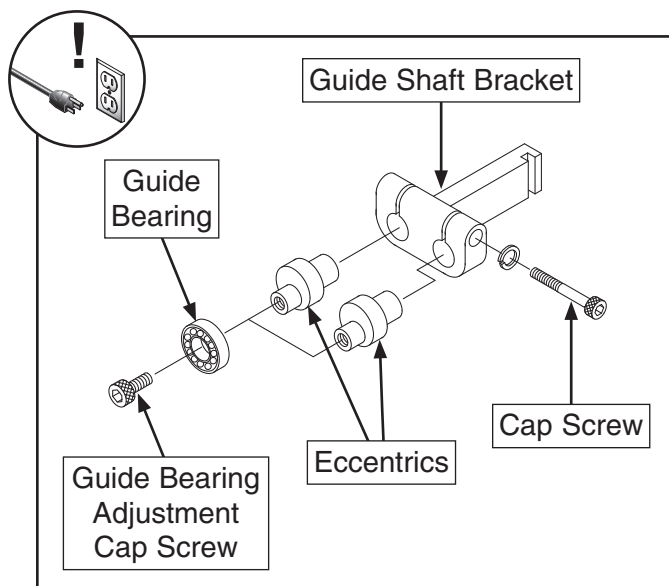


Figure 51. Blade support assembly.



4. Loosen cap screw on guide shaft bracket $\frac{1}{2}$ turn.
5. Remove $\frac{3}{8}$ " eccentrics from guide shaft bracket, and replace with $\frac{1}{4}$ " eccentrics.
6. Tighten cap screw on guide shaft bracket, then re-install guide bearings and guide bearing adjustment cap screws.
7. Install $\frac{1}{8}$ " blade as described in and close wheel covers.
8. Adjust upper and lower guide bearings and support bearings as described in manual.
9. Properly adjust blade tracking (refer to **Blade Tracking** on **Page 21**) and tension blade correctly (refer to **Tensioning Blade** on **Page 25**).

Ripping

"Ripping" means cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece. Beveled rip cuts may be performed by tilting the table.

To make a rip cut:

1. Adjust fence to match width of cut on your workpiece, then lock fence in place.
2. Adjust blade guide assembly to proper height above workpiece.
3. After all safety precautions have been met, turn bandsaw **ON** and wait for it to come to full speed. Slowly feed workpiece into blade until blade is completely through workpiece. **Figure 52** shows an example of a ripping operation.

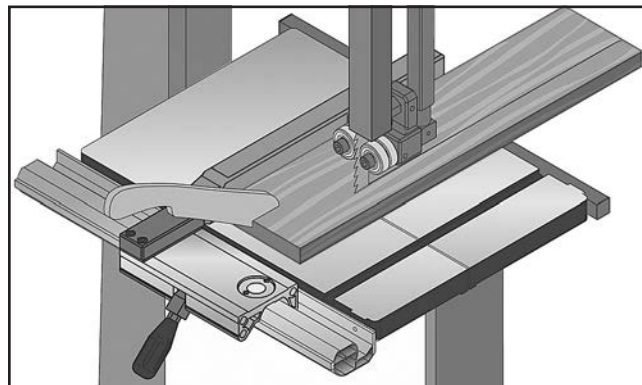


Figure 52. Example of a ripping operation.

!WARNING

ALWAYS use a push stick when ripping narrow pieces. Failure to follow these warnings may result in amputation or laceration injuries!

!WARNING

NEVER place fingers or hands in the line of cut. If you slip, your hands or fingers may go into the blade and may be cut.



Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material. Crosscuts can be 90° or angled using the miter gauge. Compound crosscuts are those where the miter is angled and the table tilted.

To make a crosscut:

1. Mark workpiece on edge where you want to begin cut.
2. Adjust blade guide assembly to proper height above workpiece.
3. Adjust miter gauge to correct angle needed for cut.
4. Move fence out of the way. Place workpiece evenly against miter gauge, then line up mark with blade.
5. After all safety precautions have been met, turn bandsaw **ON** and wait for it to come to full speed. Slowly feed workpiece into blade until blade is all the way through workpiece. **Figure 53** shows an example of a crosscutting operation.

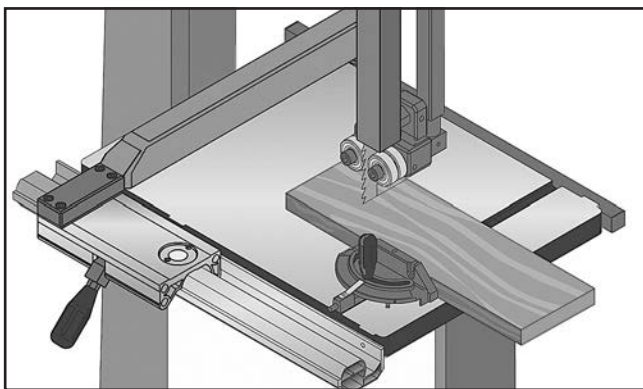


Figure 53. Example of a crosscutting operation with the miter gauge.

Resawing

"Resawing" means cutting the thickness of a board into two or more thinner boards (see **Figure 54** for an example). The maximum height of a board that can be resawn is limited by the maximum cutting height of the bandsaw.

One of the most important considerations for resawing is blade selection—a wide blade cuts straighter and is less prone to blade lead (see the **Blade Lead** subsection later in this manual for more information).

For most applications, use a blade with a hook or a skip tooth style. Choose blades with fewer teeth-per-inch (from 3 to 6 TPI), because they offer larger gullet capacities for clearing sawdust, which reduces heat buildup and strain on the motor.

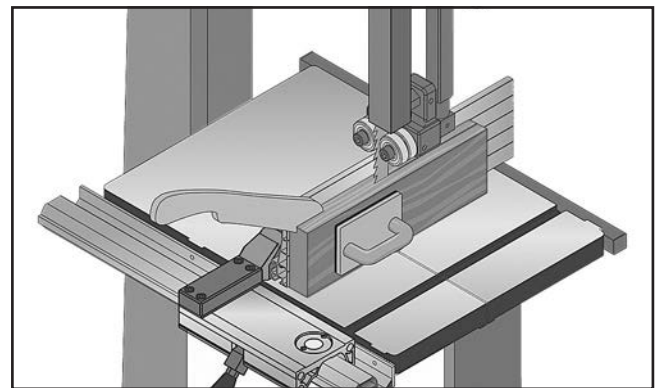


Figure 54. Example of a resawing operation.

⚠ WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the side of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.



Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so the blade follows the layout line without twisting. If curves are sharp or tight, use a narrower blade with more TPI (teeth per inch) and make relief cuts to avoid having to back the workpiece away from the blade.

Always make short cuts first, then proceed to the longer cuts. Relief cuts reduce the chance of the blade being pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line, so when you're cutting along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make it easier to back the workpiece out once the saw blade has come to a stop, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

Width	Min. Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together. However, before making stacked cuts, ensure that the table is perpendicular (90°) to the blade—otherwise, any error in this setting will be compounded in the workpieces.

To complete a stacked cut:

1. Align workpieces from top to bottom.
2. Secure all pieces together in a manner that will not interfere with cutting. Hot gluing along edges works well, as does brad nailing through waste portion. (Be careful not to cut into brads or you may break blade!)
3. Lay out shape you intend to cut on face of top piece.
4. Make relief cuts perpendicular to outline of your intended shape in areas where changes in blade direction could strain woodgrain or cause blade to bind.
5. Cut stack of pieces along your layout line as though you were cutting a single piece (see **Figure 55** for an example of a stacked cut setup).

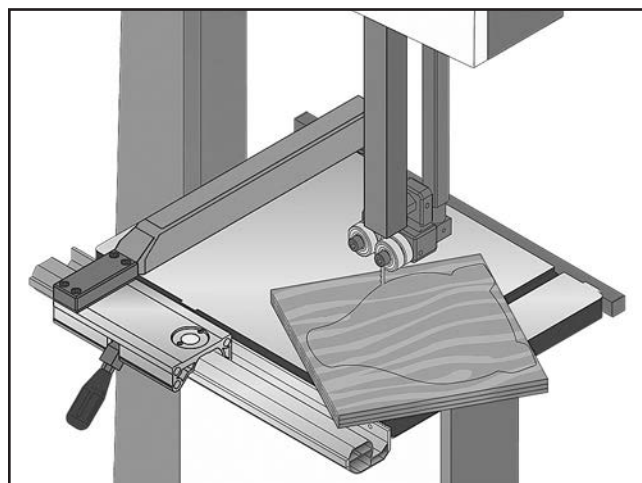


Figure 55. Example of a stacked cut setup.



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.

Grizzly Bandsaw Blades

MODEL	LENGTH	WIDTH	TPI	GAUGE
G5152	93½"	⅛"	14 Raker	0.025
G5153	93½"	⅛"	18 Raker	0.025
G5154	93½"	⅜"	4 Skip	0.025
G5155	93½"	⅜"	10 Raker	0.025
G5156	93½"	⅜"	14 Raker	0.025
G5157	93½"	¼"	4 Hook	0.025
G5158	93½"	¼"	6 Hook	0.025
G5159	93½"	¼"	10 Raker	0.025
G5160	93½"	¼"	14 Raker	0.025
G5161	93½"	¼"	18 Raker	0.025
G5162	93½"	⅜"	4 Hook	0.025
G5163	93½"	⅜"	6 Hook	0.025
G5164	93½"	⅜"	10 Raker	0.025
G5165	93½"	⅜"	14 Raker	0.025
G5166	93½"	½"	3 Hook	0.025
G5167	93½"	½"	4 Hook	0.025
G5168	93½"	½"	6 Hook	0.025
G5169	93½"	½"	10 Raker	0.025
G5170	93½"	½"	14 Raker	0.025
G5171	93½"	¾"	3 Hook	0.032
G5172	93½"	¾"	6 Hook	0.032
G5173	93½"	¾"	10 Raker	0.032

Basic Eye Protection

T32323—Woodturners Face Shield

T32401—EDGE Brazeau Safety Glasses, Clear

T32402—EDGE Khor G2 Safety Glasses, Tint

T32404—EDGE Mazeno Safety Glasses, Clear



Figure 56. Assortment of basic eye protection.

T25555—6" Riser Block Kit

This Riser Block Kit increases the maximum cutting height of the G0555LX 14" bandsaw from 6" to 12". The T25555 has the green color scheme of the G0555LX and includes all necessary hardware plus an extended blade guard and a ⅜" x 105" x 6 TPI blade.

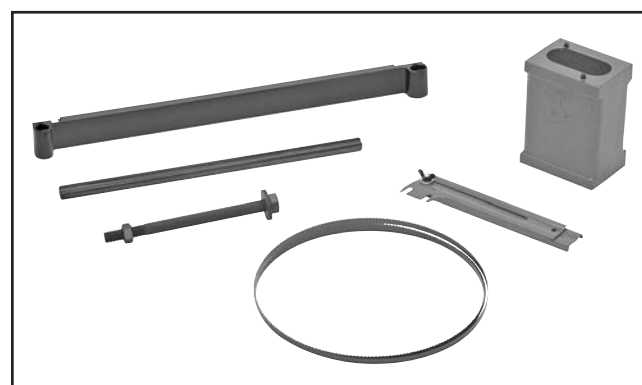
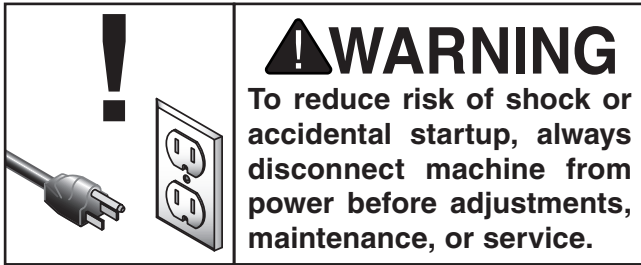


Figure 57. T25555 Riser Block Kit.

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



SECTION 6: MAINTENANCE



Schedule

For optimum performance from this machine, this maintenance schedule must be strictly followed.

Ongoing

To minimize your risk of injury and maintain proper machine operation, shut down the machine immediately if you ever observe any of the items below, and fix the problem before continuing operations:

- Loose mounting bolts.
- Worn or damaged saw blade.
- Worn or damaged wires.
- Dirty table surface.
- Any other unsafe condition.

Monthly Check

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.
- Remove blade and thoroughly clean built-up sawdust from blade wheels.

Lubrication

If the table becomes difficult to tilt, remove it and lubricate the trunnions and the slides in the trunnion base.

Cleaning & Protecting

Cleaning the bandsaw 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.

Protect the unpainted cast iron surfaces on the table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 Oz. Spray

G2871—Boeshield® T-9 12 Oz. Spray

G2870—Boeshield® T-9 4 Oz. Spray

H3788—G96® Gun Treatment 12 Oz. Spray



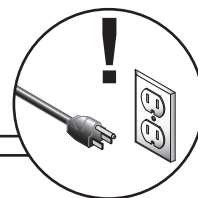
Figure 58. Recommended products for protecting unpainted cast iron/steel part on machinery.



SECTION 7: SERVICE

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

Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> 1. Switch disabling padlock installed. 2. Incorrect power supply voltage or circuit size. 3. Plug/receptacle at fault/wired incorrectly. 4. Power supply circuit breaker tripped or fuse blown. 5. Motor wires connected incorrectly. 6. Start capacitor at fault. 7. Centrifugal switch adjustment/contact points at fault. 8. Wiring broken, disconnected, or corroded. 9. ON/OFF or circuit breaker switch at fault. 10. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Remove switch disabling padlock (Page 33). 2. Ensure correct power supply voltage and circuit size (Pages 9–10). 3. Test for good contacts; correct the wiring. 4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse. 5. Correct motor wiring connections (Page 56). 6. Test/replace if at fault. 7. Adjust centrifugal switch/clean contact points. Replace either if at fault. 8. Fix broken wires or disconnected/corroded connections. 9. Replace switch/circuit breaker. 10. Replace motor.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Dull blade. 2. Workpiece material unsuitable for machine. 3. Feed rate/cutting speed too fast. 4. Machine undersized for task. 5. Blade slipping on wheels or not properly tensioned. 6. Belt(s) slipping/pulleys misaligned. 7. Motor wires connected incorrectly. 8. Plug/receptacle at fault/wired incorrectly. 9. Pulley slipping on shaft. 10. Motor overheated. 11. Extension cord too long. 12. Centrifugal switch/contact points at fault. 13. Motor or motor bearings at fault. 	<ol style="list-style-type: none"> 1. Sharpen/replace blade (Page 38). 2. Only cut wood/ensure moisture is below 20% (Page 34). 3. Decrease feed rate/cutting speed (Page 35). 4. Use correct blade/reduce feed rate or depth of cut. 5. Adjust blade tracking and tension (Pages 21 & 25). 6. Clean/tension/replace belt(s) (Pages 48–49); ensure pulleys are aligned. 7. Correct motor wiring connections (Page 56). 8. Test for good contacts/correct wiring. 9. Tighten/replace loose pulley/shaft. 10. Clean motor, let cool, and reduce workload. 11. Move machine closer to power supply; use shorter extension cord. 12. Adjust centrifugal switch/clean contact points. Replace either if at fault. 13. Replace motor.



Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor or component loose. 2. Stand or feed not adjusted properly. 3. Blade weld at fault/teeth broken. 4. V-belt(s) worn, loose, pulleys misaligned or belt slapping cover. 5. Pulley loose. 6. Motor mount loose/broken. 7. Motor fan rubbing on fan cover. 8. Centrifugal switch needs adjustment/at fault. 9. Motor bearings at fault. 	<ol style="list-style-type: none"> 1. Replace damaged or missing bolts/nuts or tighten if loose. 2. Adjust feet to stabilize machine. 3. Replace blade (Page 38). 4. Inspect/replace belt (Pages 48–49). Re-align pulleys if necessary. 5. Secure pulley on shaft. 6. Tighten/replace. 7. Fix/replace fan cover; replace loose/damaged fan. 8. Adjust/replace if at fault. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operations

Symptom	Possible Cause	Possible Solution
Blade or teeth break/crack.	<ol style="list-style-type: none"> 1. Blade tension incorrect. 2. Blade incorrect for application. 3. Excessive feed rate/pressure. 4. Cutting corners too sharply. 5. Blade dull. 6. Blade tracking wrong. 7. Blade guides/support bearings not adjusted properly, allowing guides to hit blade teeth. 8. Blade guide height in wrong position. 9. Blade weld at fault. 10. Wheel tires worn or incorrectly installed. 11. Fence or miter slot out of alignment with blade. 12. Bad bearings on wheels or guide bearings. 	<ol style="list-style-type: none"> 1. Adjust blade tension (Page 25). 2. Use correct blade for application. 3. Reduce feed rate/pressure. 4. Use a wider arc on outside cuts, or use relief cuts to make tight inside cuts. 5. Replace blade (Page 38). 6. Adjust blade tracking (Page 21). 7. Adjust blade guides/support bearings properly, so guides cannot hit teeth during operation (Pages 26–27). 8. Adjust upper blade guide so blade is as close to workpiece as possible (Page 34). 9. Replace blade (Page 38). 10. Redress rubber tires (Page 54); replace/re-install tires. 11. Align table and fence with blade (Pages 30–31). 12. Replace wheels and/or guide bearings.
Blade slows, smokes, shows overheating or wear on one side.	<ol style="list-style-type: none"> 1. Too much side pressure when feeding workpiece. 2. Blade contacting table insert. 3. Blade guides worn or misadjusted. 4. Blade has insufficient support. 5. Blade installed backwards or inside out. 6. Wheels out of alignment. 7. Dull/incorrect blade; blade is bell-mouthed. 8. Fence not parallel with blade. 	<ol style="list-style-type: none"> 1. Feed workpiece straight into blade. 2. Adjust blade guide bearings to eliminate excess side pressure (Pages 26–27). 3. Adjust blade guide bracket (Pages 26–27). 4. Adjust blade guides as close to workpiece as possible (Pages 26–27). 5. Check blade installation (Page 38); make sure teeth face front of machine and point down in table throat. Re-install blade if necessary. 6. Adjust wheels so they are coplanar (Page 50). 7. Replace blade (Page 38). 8. Adjust fence/miter slot with blade (Pages 30–31).
Finished workpieces are rough or show scoring.	<ol style="list-style-type: none"> 1. Blade overloaded and twists while cutting. 2. Blade TPI too coarse. 3. Blade loose and fluttering. 4. Blade tracking incorrect. 5. Blade has missing/bent teeth; faulty weld. 	<ol style="list-style-type: none"> 1. Decrease feed rate. 2. Use correct blade for material and type of cut. 3. Increase blade tension as required (Page 25). 4. Adjust blade tracking (Page 21). 5. Replace blade (Page 38).



Symptom	Possible Cause	Possible Solution
Table does not tilt to 0 or 45 degrees	<ol style="list-style-type: none"> 1. Pointer or scale not calibrated correctly. 2. Positive stop bolt not set correctly. 	<ol style="list-style-type: none"> 1. Calibrate pointer/scale at true 0 degrees (Page 29). 2. Adjust positive stop bolt (Page 29).
Table is hard to tilt.	<ol style="list-style-type: none"> 1. Table tilt lock knobs are tightened. 2. Sawdust/pitch trapped between trunnion/ base. 3. Metal burrs on trunnion. 	<ol style="list-style-type: none"> 1. Loosen table tilt lock knobs (Page 29). 2. Remove sawdust or pitch. 3. Remove burrs.
Miter bar binds in miter slot.	<ol style="list-style-type: none"> 1. Miter slot dirty or gummed up. 2. Miter bar bent. 	<ol style="list-style-type: none"> 1. Carefully clean miter slot. 2. Replace.
Blade tracks incorrectly or comes off wheels.	<ol style="list-style-type: none"> 1. Tracking is not adjusted properly. 2. Wheels are not coplanar. 3. Blade tension too loose. 4. Blade guides too tight against blade. 5. Feeding workpiece too fast. 6. Incorrect blade for bandsaw. 7. Blade is bell-mouthed, worn, or dull. 8. Wheel tire damaged or worn. 	<ol style="list-style-type: none"> 1. Adjust tracking (Page 21). 2. Adjust wheel coplanarity (Page 50). 3. Increase blade tension (Page 25). 4. Adjust blade guides (Pages 26–27). 5. Feed workpiece slower. 6. Install correct blade. 7. Install new blade (Page 38); remove tension from blade when not in use. 8. Redress or replace wheel tires (Page 54).
Cut is crooked or blade wanders (blade lead).	<ol style="list-style-type: none"> 1. Excessive feed rate/pressure. 2. Blade tension too loose. 3. Blade dull or damaged. 4. Inadequate blade support. 5. Blade too narrow for cut type/TPI is incorrect for the cut. 6. Blade tracking incorrect. 7. Table loose. 8. Fence or miter slot out of alignment w/blade. 9. Blade guides or support bearing improperly adjusted. 10. Tooth set uneven or teeth sharper on one side than the other. 11. Blade is following grain of wood. 	<ol style="list-style-type: none"> 1. Reduce feed rate/pressure. 2. Increase blade tension (Page 25). 3. Replace blade (Page 38). 4. Adjust upper blade guide as close to workpiece as possible (Pages 26–27). 5. Use wider blade; ensure tooth type and TPI are correct. 6. Adjust blade tracking (Page 21). 7. Tighten table trunnion mounting bolts or tilt lock knobs. 8. Align table and fence with blade (Pages 30–31). 9. Properly adjust blade guide bearings and support bearing (Pages 26–27). 10. Replace blade (Page 38). 11. Increase blade tension (Page 25).
Blade dulls prematurely.	<ol style="list-style-type: none"> 1. Wrong blade tooth type or TPI. 2. Excessive feed pressure. 3. Blade is twisted. 4. Blade is slipping on wheel. 5. Guides hitting teeth and ruining tooth set. 	<ol style="list-style-type: none"> 1. Use blade with correct tooth type and TPI. 2. Reduce feed rate/pressure. 3. Re-install/replace blade (Page 38). 4. Adjust blade tension (Page 25). Clean wheel tire. 5. Properly adjust blade guides/support bearings (Pages 26–27).
Backside of blade deformation/cracking.	<ol style="list-style-type: none"> 1. Excessive feed rate/pressure. 2. Blade tension too high. 3. Incorrect blade guide alignment. 4. Guides are worn. 5. Blade tracking too far back; hitting lip of wheels. 	<ol style="list-style-type: none"> 1. Reduce feed rate/pressure. 2. Adjust blade tension (Page 25). 3. Correct blade guide alignment (Pages 26–27). 4. Replace guides. 5. Adjust tracking (Page 21).
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean dust port. 2. Repair ducting for leaks or clogs, move dust collector closer to machine, install a stronger dust collector.
Gullets loaded with chips.	<ol style="list-style-type: none"> 1. Excessive feed rate/pressure. 2. Blade TPI is too fine. 	<ol style="list-style-type: none"> 1. Reduce feed rate/pressure. 2. Install correct blade.



Checking/Tensioning V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension.

V-belt tension should be checked at least every month—more often if the bandsaw is used daily. If the belt shows signs of cracks, fraying, and excessive wear, replace it as instructed in **Replacing V-Belt** on **Page 49**.

Checking V-Belt Tension

1. DISCONNECT MACHINE FROM POWER!
2. Open the lower wheel cover.
3. Check V-Belt deflection. The V-belt is properly tensioned if there is approximately $\frac{1}{4}$ " deflection. Deflection is checked by pushing the V-belt with moderate pressure, as shown in **Figure 59**, and noting how much it moves.

— If the V-belt is not properly tensioned, perform the following **Tensioning V-Belt** procedure.

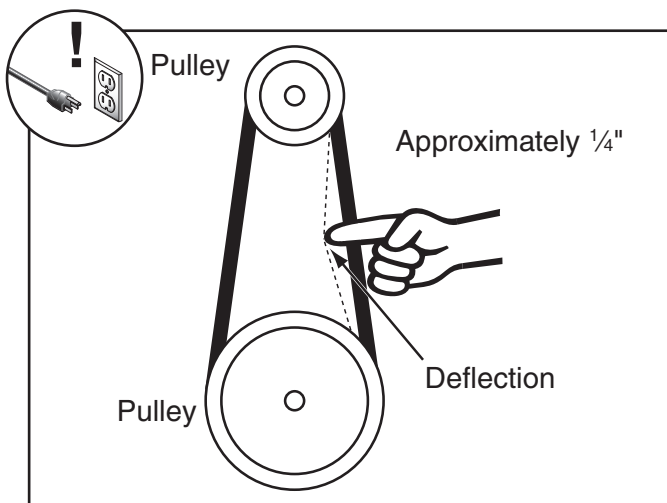


Figure 59. Checking the V-belt tension.

Tensioning V-Belt

Tool Needed

Hex Wrench 6mm..... 1

Qty

To properly tension the V-belt:

1. DISCONNECT MACHINE FROM POWER!
2. Open the lower wheel cover, and loosen the motor adjustment and hinge cap screws shown in **Figure 60**.

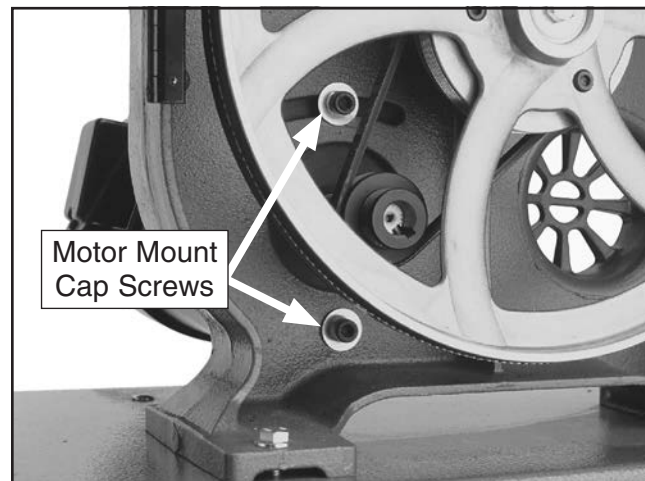


Figure 60. Locations of the motor adjustment and hinge cap screws.

3. Push the motor to the left (as viewed from the front of the machine) until there is approximately $\frac{1}{4}$ " deflection in the V-belt.
4. Re-tighten both cap screws and close the wheel cover.



Replacing V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and be properly tensioned.

Replace the V-belt if it shows signs of cracking, fraying, and excessive wear.

Tools Needed	Qty
Hex Wrench 6mm.....	1
Wrench or Socket 13mm.....	1
Replacement V-Belt (Part No. P0555LX068)	1

To replace the V-belt:

1. DISCONNECT MACHINE FROM POWER!
2. Put on heavy leather gloves and remove the blade from the machine.
3. Loosen the motor mount cap screws shown in **Figure 61**.

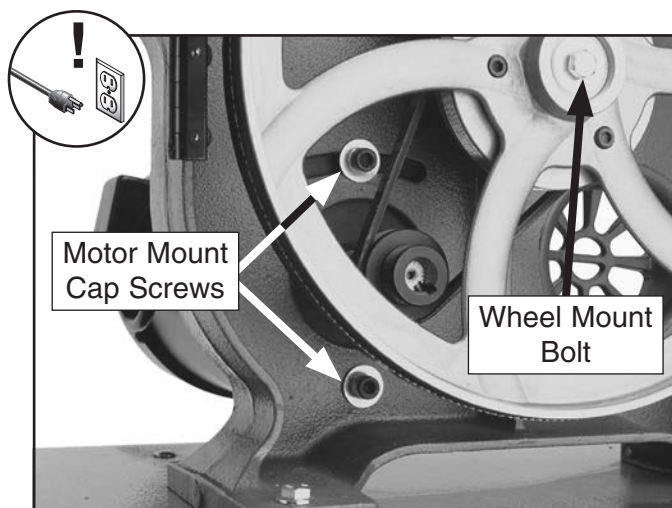


Figure 61. Locations of the wheel mount bolt, and motor mount cap screws.

4. Pivot the motor to the right (as viewed from the front of the bandsaw) so the upper cap screw slides to the right in the slot—this will release the V-belt tension.
5. Roll the V-belt off the pulleys.
6. Remove the wheel mount (it has left hand threads, so it loosens by turning clockwise).

7. Remove the wheel from the shaft. Make sure not to misplace the shaft key.
8. Put new belt on.
9. Align the wheel keyway with the shaft key, and slide the wheel back onto the shaft.
10. Secure the wheel with the wheel mount bolt and flat washer.
11. Position the V-belt on the desired pulleys, then properly tension it, as instructed in **Tensioning V-Belt** on **Page 48**.
12. Replace the blade, then properly track and tension it (see **Pages 21** and **25**) and adjust the guide and support bearings.

Shimming Table

To ensure accuracy when cutting stacked cuts or circles, the table must be 90° to the back of the blade, as shown in **Figure 62**.

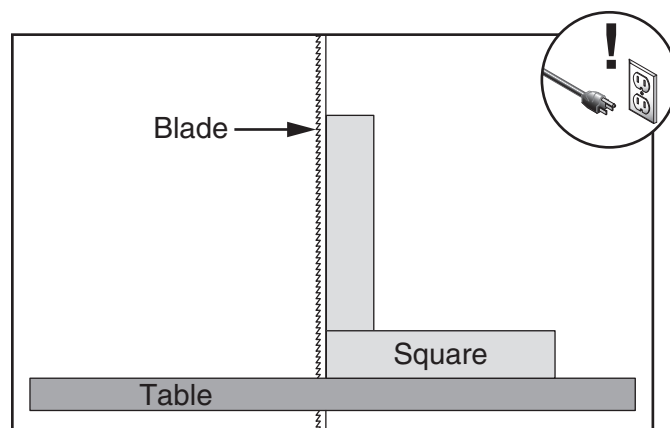


Figure 62. Checking the table to be perpendicular to the back of the blade.

If the table is not perpendicular to the back of the blade, correct this condition by placing shims between the table and trunnions underneath it.

Follow the procedures in **Aligning Table** on **Page 30** to ensure accurate cutting.



Wheel Alignment

Wheel alignment is important for optimal performance from your bandsaw. Wheels are properly aligned when they are parallel with each other and in the same plane or “coplanar” (see the illustration in the figure to the right).

When wheels are coplanar, the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel.

Bringing the wheel into alignment may require a combination of shimming a wheel and center/lateral tracking the blade.

Tools Needed	Qty
Straightedge 4 ft.....	1
Fine Ruler.....	1
Wrench or Socket 13mm.....	1
Wrench or Socket 19mm.....	1

Checking Wheel Alignment

1. DISCONNECT MACHINE FROM POWER!
2. Remove the table.
3. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure the straightedge fully extends across the rims of both wheels, as shown in **Figure 63**.
4. Referring to **Figure 64**, check wheel alignment.

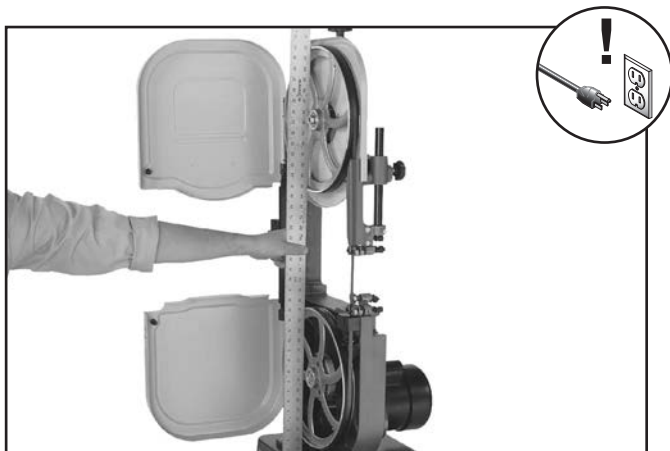


Figure 63. Checking if the wheels are coplanar.

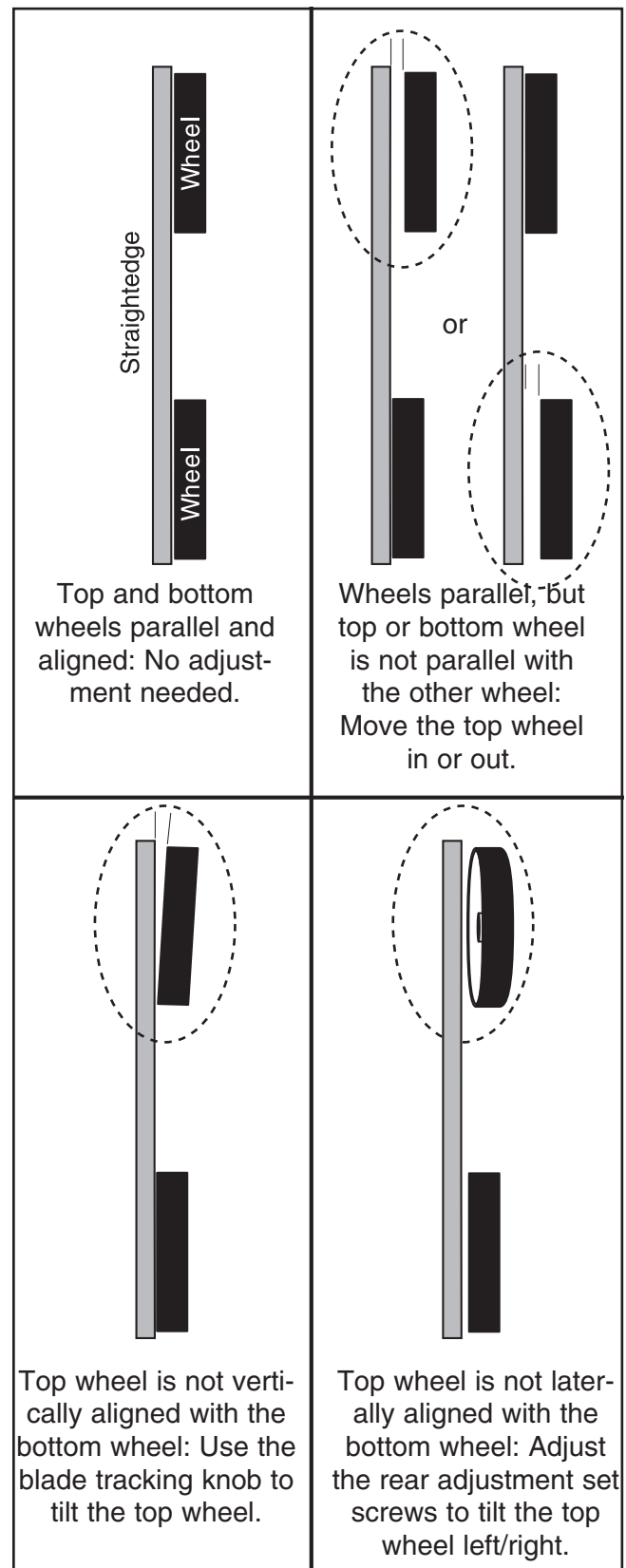


Figure 64. Wheel alignment illustration.



Shimming a Wheel

A wheel that is parallel with the other wheel, but is not coplanar, must be shimmed by the distance that it is not in the same plane with the other wheel.

Tip: *Electrical washers work well for shimming the wheel because they can easily be stacked to get the desired height.*

To shim a wheel:

1. DISCONNECT MACHINE FROM POWER!
2. Adjust the upper wheel tracking so that it is parallel with the bottom wheel.
3. With the straightedge touching both rims of the wheel that does not need to be adjusted, measure the distance away from the other wheel with a fine ruler, as shown in **Figure 65**. The distance measured with the ruler is the distance this wheel must be shimmed.

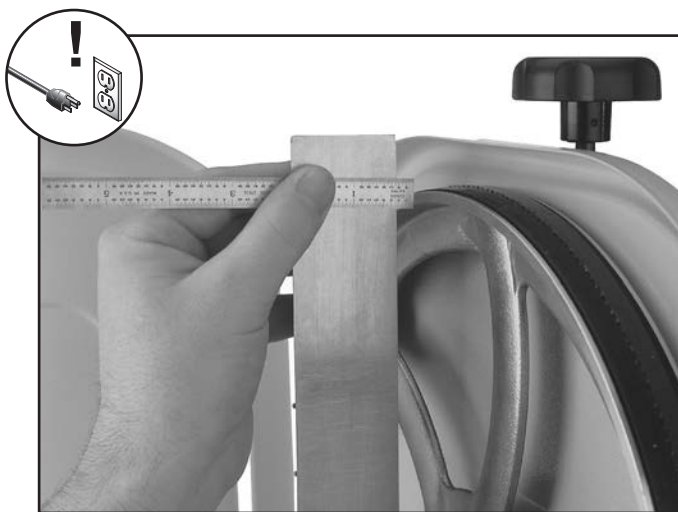


Figure 65. Measuring the distance to shim the wheel to be coplanar.

4. Remove the blade.
5. Remove the wheel to be shimmed. Place as many shims as necessary to correct the gap measured in **Step 3** onto the wheel shaft.
6. Re-install the wheel and secure it in place.
7. Re-install the blade and properly tension it.

8. Perform the previous **Checking Wheel Alignment** procedure. If necessary to make the wheels parallel, repeat this procedure.
9. Close the wheel covers.
10. The first time you get the wheels coplanar, place a mark on each wheel where you held the straightedge, then use this position again in the future if you need to repeat the procedure. This assures repeated accuracy every time you adjust the wheels.

Upper Wheel Lateral Adjustment

If the upper wheel is tilted laterally (side to side), perform the following procedure to make it coplanar with the lower wheel.

There are two set screws in the upper wheel bracket, shown in **Figure 66**, that adjust the wheel tilt from side to side.

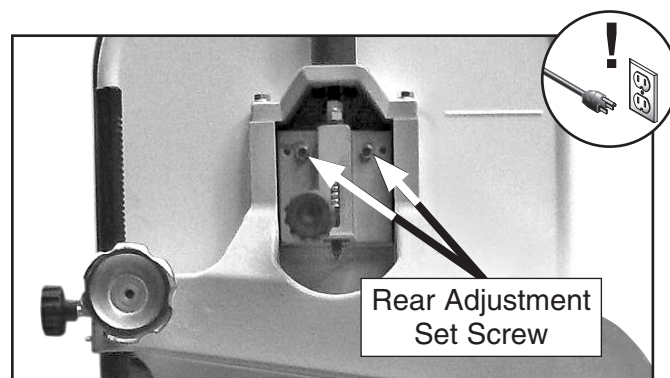


Figure 66. Rear lateral adjustment set screw.

Tools Needed	Qty
Hex Wrench 3mm.....	1
Wrench or Socket 10mm.....	1

To adjust the upper wheel laterally:

1. DISCONNECT MACHINE FROM POWER!
2. Remove the fence and table from the machine.



- Using a white crayon or other light color marker, mark the upper and lower wheels to indicate the measuring locations, as illustrated in **Figure 67**.

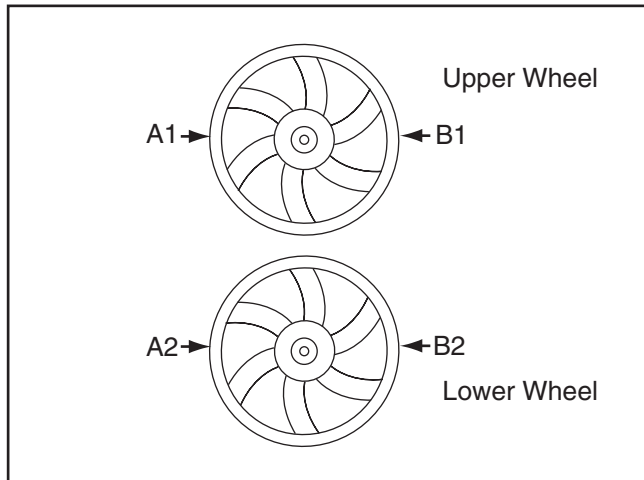


Figure 67. Example of marking upper and lower wheels for consistent measurements.

Note: *Marking the wheels ensures more accurate results in case there are irregularities in the wheels.*

- Using a straightedge, check the wheels at the A and B locations (see **Figure 67**).
- Using the 10mm wrench, loosen the hex nuts on the rear adjustment set screws.
- Using the 3mm hex wrench, adjust the set screws until the upper wheel is coplanar with the lower wheel, see **Figure 68**.

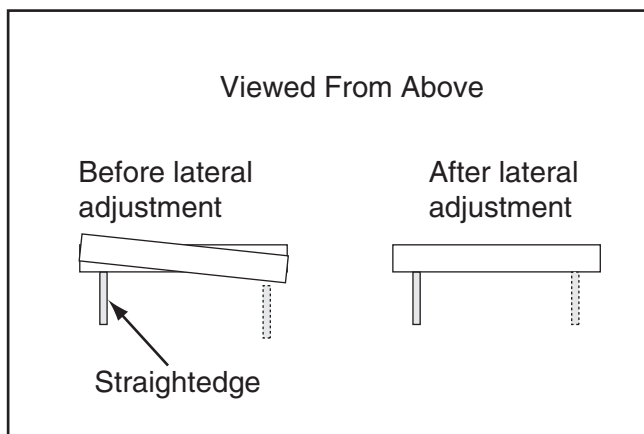


Figure 68. Before and after lateral wheel alignment (viewed from above).

- Re-tighten the hex nuts loosened in **Step 6**.

Blade Lead

Bandsaw blades may wander off the cut line when sawing, as shown in **Figure 69**. This is called blade lead.

Blade lead is usually caused by too fast of a feed rate, a dull or abused blade, or improper blade tension. If your blade is sharp/undamaged, properly tensioned, and you still have blade lead, perform the following procedures.

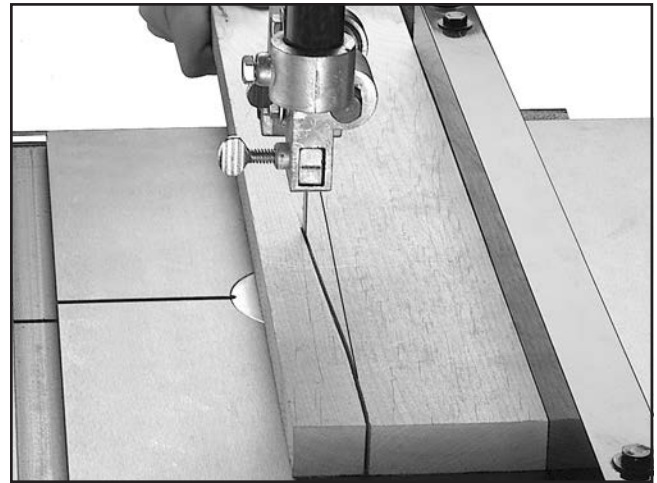


Figure 69. Example of blade lead.

Correcting Blade Lead

- Make sure the blade is properly tensioned and the blade guides are adjusted correctly.
- Use less pressure when feeding the workpiece through the cut.
- Make sure the miter slot and fence are parallel to the blade line (see the **Aligning Table** and **Aligning Fence** procedures in this manual for detailed information).
- Perform a test cut with the bandsaw.
 - If there is still blade lead present, compensate for this condition by skewing the fence or shifting the table, as instructed in the following procedures.



Skewing Your Fence

1. Cut a piece of scrap wood approximately $\frac{3}{4}$ " thick x 3" wide x 17" long. On the wide face of the board, draw a straight line parallel to the long edge.
2. Slide the bandsaw fence out of the way and cut along the line halfway through the board. Turn the bandsaw **OFF** and wait for the blade to stop. Do not move the board.
3. Clamp the board to the bandsaw table, then slide the fence over to the board so it barely touches one end of the board.
4. Use a 4mm hex wrench to loosen the four fence adjustment cap screws on top of the fence, skew the fence so that it is parallel with the scrap piece, then re-tighten the cap screws.
5. Make a few cuts using the fence.
 - If blade lead is still present, repeat **Steps 1–4** until the blade and fence are parallel with each other.
 - Or, shift the table, as instructed in the following procedure.

Shifting the Table

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut halfway through the board on the line by pushing it into the blade.
3. Turn the bandsaw **OFF** and wait for the blade to stop.
4. Disconnect the machine from power, then use a 10mm wrench to loosen the six hex bolts underneath the table that secure it to the trunnion brackets.
5. Shift the table to compensate for the blade lead, re-tighten the hex bolts, then re-connect the bandsaw to power.
6. Repeat **Steps 1–5** until there is no longer any blade lead.

Fence Scale Calibration

You may need to recalibrate the fence scale after changing or adjusting the blade, or if the scale is not producing accurate cuts. Recalibrate the fence scale by adjusting the hairline indicator on the fence and testing your adjustment by cutting a piece of scrap wood.

Tool Needed

Qty

Phillips Screwdriver #1 1

To calibrate the scale:

1. Set the fence anywhere along the scale and locate a piece of scrap wood with at least one straight edge.

Note: Joint the edge with a jointer if needed to make the edge straight.

2. Hold the straight edge of the workpiece firmly against the fence, and feed the workpiece through the saw blade with a push stick.
3. Measure the width of the cut workpiece. The width of the workpiece should match the reading on the fence scale.
4. If the reading on the scale is not the same as the width of the cut workpiece, loosen the two screws on the magnifying window (see **Figure 70**) and adjust it to match the width of the cut workpiece.



Figure 70. Fence scale window and screws.

5. Re-tighten the screws—the scale is now correctly calibrated.



Blade Tensioner

The blade tensioner may need to be reset for one of the following reasons:

- The blade tension quick release lever will not move to the right position when the tension scale is correctly adjusted for the installed blade.
- You have installed a blade of a different length and the tensioner needs tightened.

The procedure below describes how to decompress the spring in the blade tensioner to allow the quick release lever to perform its intended purpose. If the tensioner needs tightened, reverse the procedure to get the desired results.

Tools Needed	Qty
Wrenches 14mm.....	2

To reset the blade tensioner:

1. DISCONNECT MACHINE FROM POWER!
2. Move the blade tension quick release lever to the left position to release blade tension.
Figure 71.

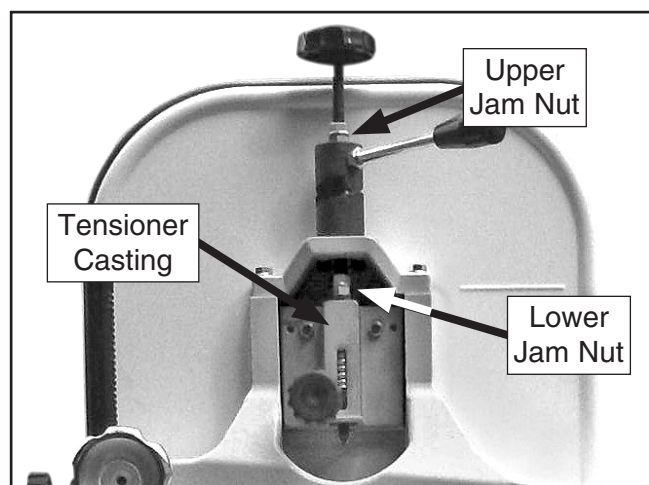


Figure 71. Location of spacers and crossbar.

3. Using two 14mm wrenches, loosen the lower jam nuts and thread them up the shaft.
4. Using the two 14mm wrenches, loosen the upper jam nuts and thread them up the shaft the same distance as the lower jam nuts.

5. Test the blade tensioner setting by moving the quick release lever to the right.
6. Use the blade tensioner knob to final tension the blade.
7. Repeat the procedure until the proper tension and release are achieved with the quick release lever.

Note: Over compressing the spring will wear it out prematurely, making the blade tensioner sloppy and inaccurate. Only compress the spring as needed to remove play in the system.

Redressing Rubber Tires

As the bandsaw ages, the rubber tires on the wheels may need to be redressed if they harden or glaze over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult because wheel crown will lose their proper shape. At that point, redressing will no longer be effective and the rubber tires must be replaced.

To redress the rubber tires:

1. DISCONNECT MACHINE FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires.
5. Hold 100-grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.

WARNING

Wiring Safety Instructions

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

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

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

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

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

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
















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

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

NOTICE

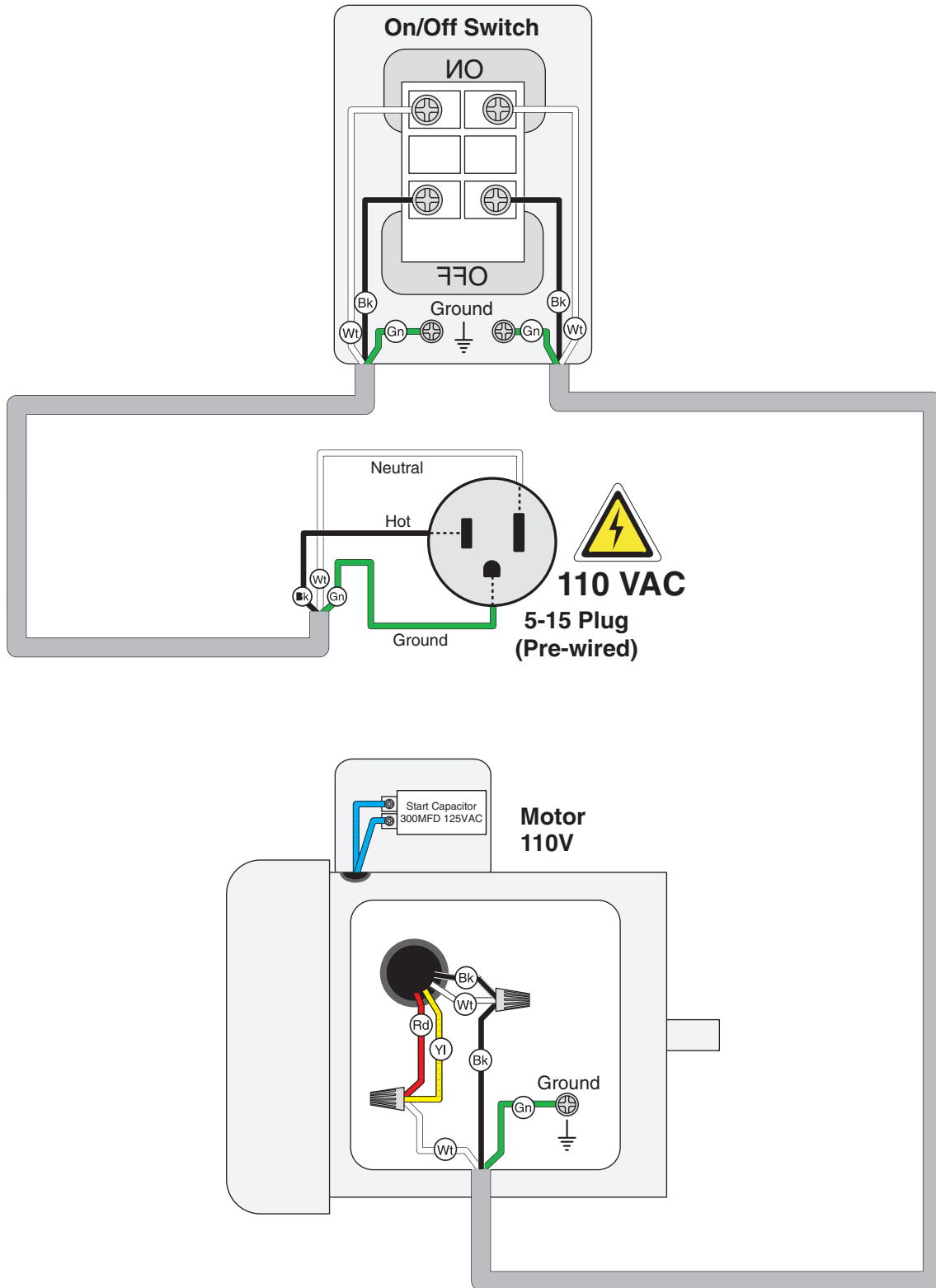
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

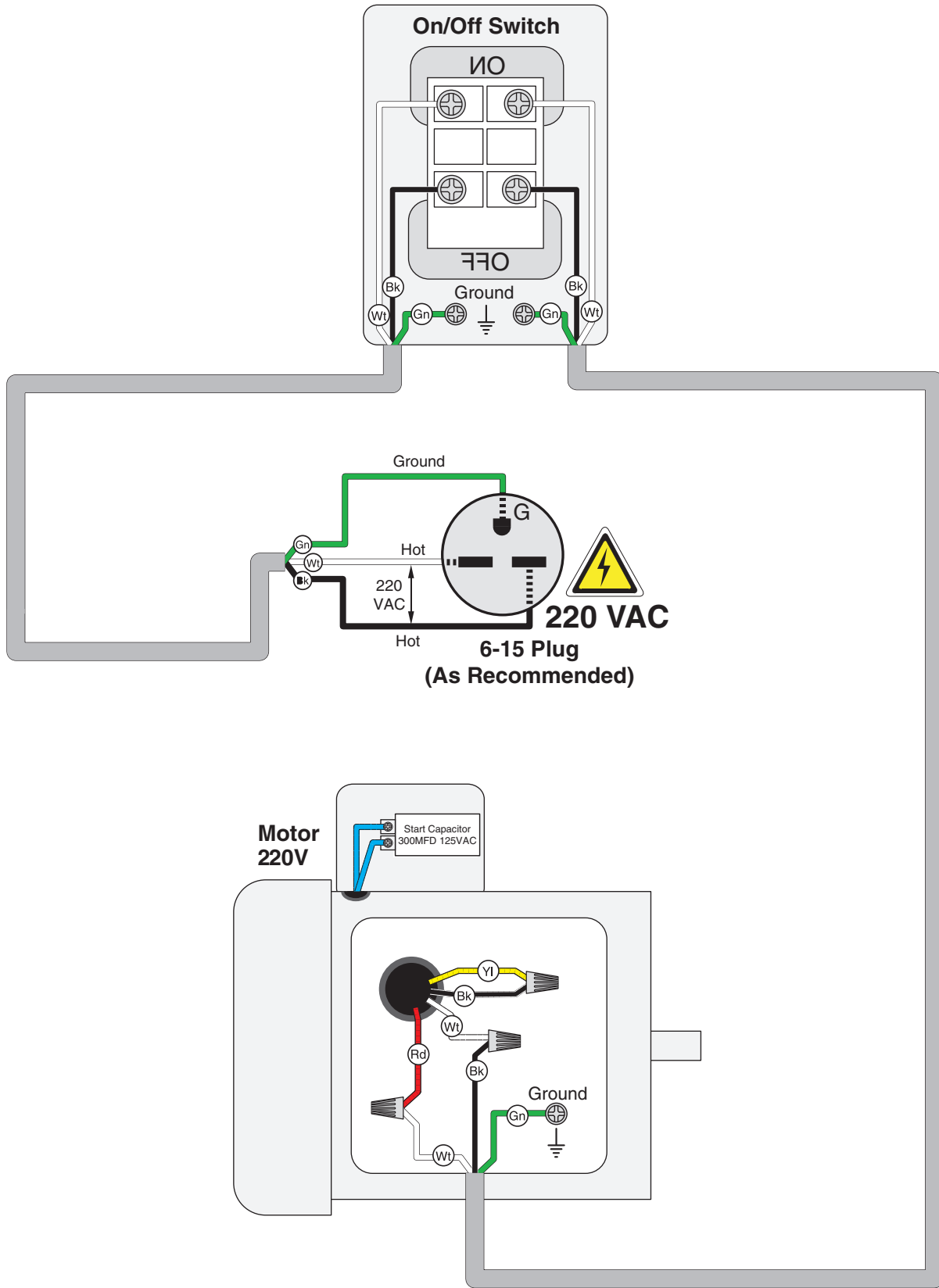
BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	



Wiring Diagram (110V)



Wiring Diagram (220V)



Electrical Photos



Figure 72. ON/OFF switch wiring.



Figure 73. Motor wiring.

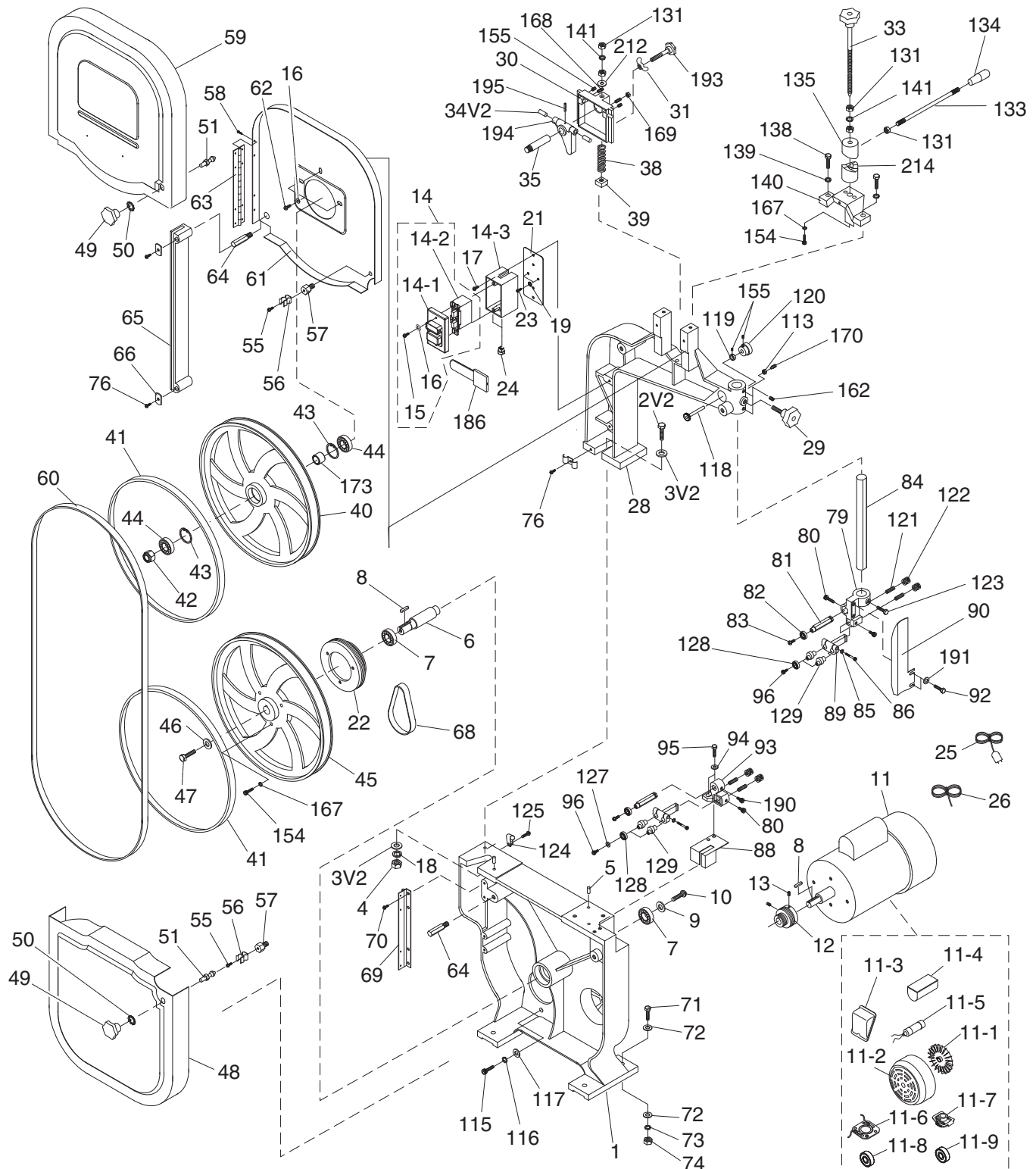


Figure 74. Start capacitor wiring.



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

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0555LX001	BASE
2V2	P0555LX002V2	HEX BOLT 5/8-11 X 3 V2.11.22
3V2	P0555LX003V2	FLAT WASHER 16.5 X 38 X 8MM V2.11.22
4	P0555LX004	HEX NUT 5/8-11
5	P0555LX005	GUIDE PIN 6 X 15MM
6	P0555LX006	LOWER WHEEL SHAFT
7	P0555LX007	BALL BEARING 6204-2RS
8	P0555LX008	KEY 5 X 5 X 25
9	P0555LX009	FLAT WASHER 5/16
10	P0555LX010	HEX BOLT 5/16-18 X 5/8
11	P0555LX011	MOTOR 1HP 110V/220V 1PH
11-1	P0555LX011-1	MOTOR FAN
11-2	P0555LX011-2	FAN COVER
11-3	P0555LX011-3	WIRING BOX
11-4	P0555LX011-4	CAPACITOR COVER
11-5	P0555LX011-5	S CAPACITOR 300M 125V 2 X 3-1/2
11-6	P0555LX011-6	CONTACTOR PLATE
11-7	P0555LX011-7	CENTRIFUGAL SWITCH 1725 RPM
11-8	P0555LX011-8	BALL BEARING 6205-2RS
11-9	P0555LX011-9	BALL BEARING 6204-2RS
12	P0555LX012	MOTOR PULLEY J5-TYPE
13	P0555LX013	SET SCREW 1/4-20 X 1/2
14	P0555LX014	ON/OFF SWITCH ASSEMBLY
14-1	P0555LX014-1	SWITCH COVER
14-2	P0555LX014-2	ON/OFF SWITCH 994542 18A 125V
14-3	P0555LX014-3	SWITCH BOX
15	P0555LX015	TAP SCREW #10 X 1
16	P0555LX016	FLAT WASHER #10
17	P0555LX017	PHLP HD SCR 10-24 X 5/8
18	P0555LX018	LOCK WASHER 5/8
19	P0555LX019	EXT TOOTH WASHER 10MM
21	P0555LX021	SWITCH PLATE
22	P0555LX022	WHEEL PULLEY J5-TYPE
23	P0555LX023	PHLP HD SCR 10-24 X 1/4
24	P0555LX024	STRAIN RELIEF TYPE-1 3/4" SNAP-IN
25	P0555LX025	POWER CORD 16G 3W 72" 5-15P
26	P0555LX026	MOTOR CORD 16G 3W
28	P0555LX028	UPPER FRAME ARM
29	P0555LX029	KNOB BOLT 5/16-18 X 3/4
30	P0555LX030	SLIDING HOUSING
31	P0555LX031	WING NUT 5/16-18
33	P0555LX033	TENSION BOLT 3/8-16 X 11-5/8
34V2	P0555LX034V2	PIVOT PIN W/FLAT SIDE V2.07.12
35	P0555LX035	UPPER WHEEL SHAFT
38	P0555LX038	COMPRESSION SPRING
39	P0555LX039	INDICATOR NUT 3/8 X 16
40	P0555LX040	UPPER WHEEL

REF	PART #	DESCRIPTION
41	P0555LX041	WHEEL TIRE
42	P0555LX042	LOCK NUT 1/2"-20 THIN
43	P0555LX043	INT RETAINING RING 35MM
44	P0555LX044	BALL BEARING 6202-2RS
45	P0555LX045	LOWER WHEEL
46	P0555LX046	FLAT WASHER 5/16
47	P0555LX047	HEX BOLT 5/16-18 X 3/4 LH
48	P0555LX048	LOWER WHEEL GUARD
49	P0555LX049	KNOB 5/16-18
50	P0555LX050	INT TOOTH WASHER 8MM
51	P0555LX051	STUD LATCH
55	P0555LX055	PHLP HD SCR 10-24 X 1/2
56	P0555LX056	CATCH
57	P0555LX057	LOCATING BOLT
58	P0555LX058	TAP SCREW #8 X 3/8
59	P0555LX059	FRONT UPPER COVER
60	P0555LX060	SAW BLADE 93-1/2 X 3/8 X 6TPI HOOK
61	P0555LX061	BACK UPPER COVER
62	P0555LX062	PHLP HD SCR 10-24 X 5/16
63	P0555LX063	UPPER HINGE
64	P0555LX064	STANDOFF STUD-HEX MF
65	P0555LX065	SAW BLADE GUARD
66	P0555LX066	BLADE GUARD WASHER #10
68	P0555LX068	RIBBED V-BELT 200J5
69	P0555LX069	LOWER WHEEL COVER HINGE
70	P0555LX070	PHLP HD SCR 10-24 X 3/8
71	P0555LX071	HEX BOLT 5/16-18 X 1-1/2
72	P0555LX072	FLAT WASHER 5/16
73	P0555LX073	LOCK WASHER 5/16
74	P0555LX074	HEX NUT 5/16-18
76	P0555LX076	PHLP HD SCR 10-24 X 1/2
79	P0555LX079	UPPER BLADE GUIDE CASTING
80	P0555LX080	CAP SCREW 1/4-20 X 1/2
81	P0555LX081	BEARING ARBOR
82	P0555LX082	BALL BEARING 6000-2RS
83	P0555LX083	FLANGE SCREW 1/4-20 X 5/16
84	P0555LX084	GUIDE POST
85	P0555LX085	LOCK WASHER #10
86	P0555LX086	CAP SCREW 10-24 X 1-3/4
88	P0555LX088	LOWER BLADE GUIDE BRACKET
89	P0555LX089	GUIDE SHAFT BRACKET
90	P0555LX090	UPPER BLADE GUARD
92	P0555LX092	PHLP HD SCR 10-24 X 3/8
93	P0555LX093	LOWER BRACKET POST
94	P0555LX094	FLAT WASHER 1/4
95	P0555LX095	HEX BOLT 1/4-20 X 3/4
96	P0555LX096	CAP SCREW 10-32 X 1/4



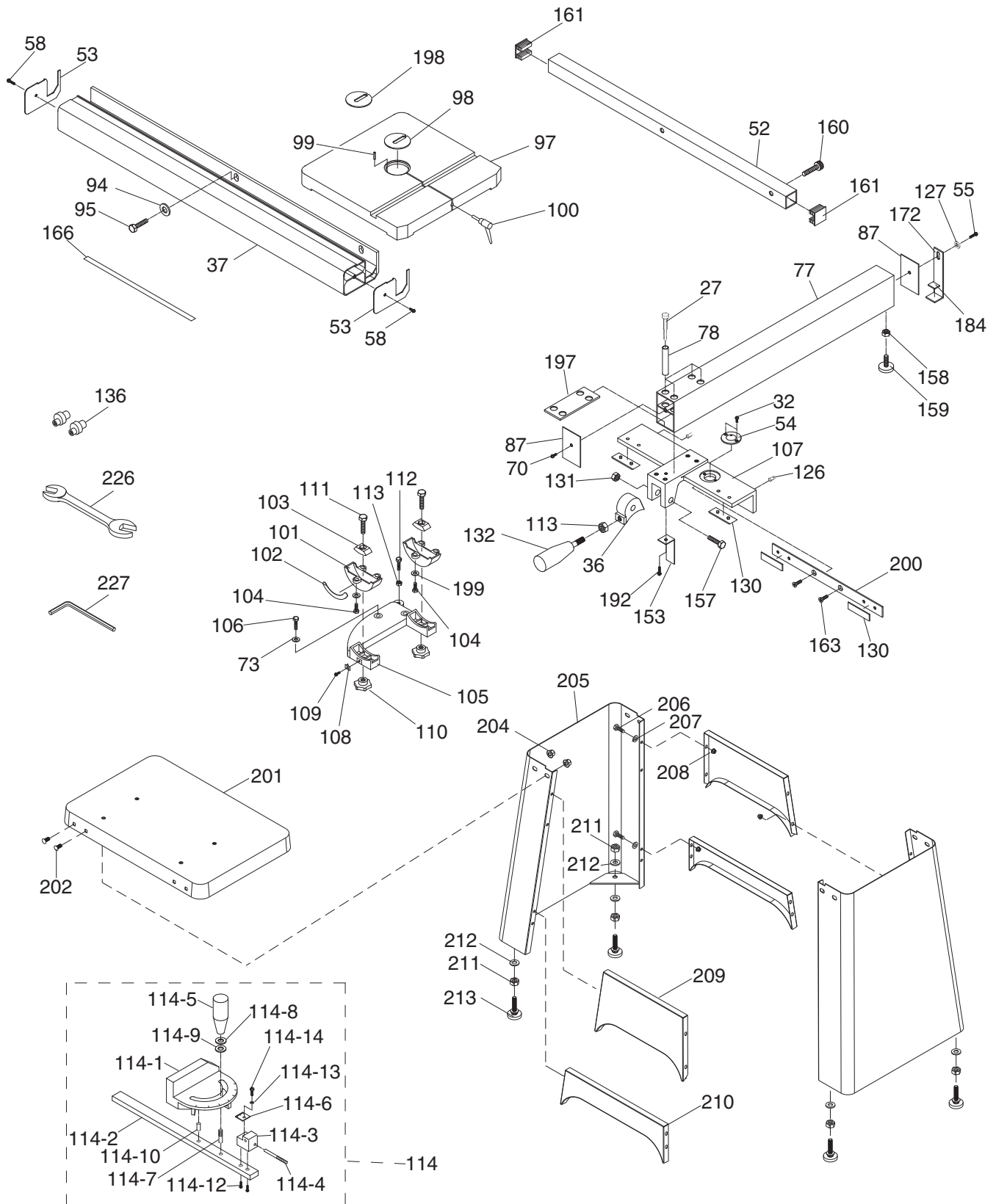
Main Parts List (Cont.)

REF	PART #	DESCRIPTION
113	P0555LX113	HEX NUT 5/16-18
115	P0555LX115	HEX BOLT 5/16-18 X 1
116	P0555LX116	LOCK WASHER 5/16
117	P0555LX117	FLAT WASHER 5/16
118	P0555LX118	PINION SHAFT
119	P0555LX119	LOCK COLLAR
120	P0555LX120	GUIDE POST CONTROL KNOB
121	P0555LX121	SET SCREW 5/16-24 X 1-1/2
122	P0555LX122	ADJUST NUT
123	P0555LX123	CAP SCREW 1/4-20 X 5/8
124	P0555LX124	CORD CLAMP 3/8
125	P0555LX125	PHLP HD SCR 10-24 X 1/2
127	P0555LX127	FLAT WASHER #10
128	P0555LX128	BALL BEARING 608-2RS
129	P0555LX129	ECCENTRIC 3/8"
131	P0555LX131	HEX NUT 3/8-16
133	P0555LX133	STUD-UDE 3/8-16 X 10 1, 3/4
134	P0555LX134	PLASTIC HANDLE 3/8-16
135	P0555LX135	UPPER CLUTCH
138	P0555LX138	HEX BOLT 5/16-18 X 1-1/4

REF	PART #	DESCRIPTION
139	P0555LX139	LOCK WASHER 5/16
140	P0555LX140	CLUTCH SUPPORT BRACKET
141	P0555LX141	LOCK WASHER 3/8
154	P0555LX154	CAP SCREW 1/4-20 X 1
155	P0555LX155	SET SCREW 1/4-20 X 5/16
162	P0555LX162	BALL PLUNGER 1/4-20 X 1/2
167	P0555LX167	LOCK WASHER 1/4
168	P0555LX168	SET SCREW 1/4-20 X 1
169	P0555LX169	HEX NUT 1/4-20
170	P0555LX170	SET SCREW 5/16-18 X 1/2 DOG-PT
173	P0555LX173	BUSHING
186	P0555LX186	SWITCH PADLOCK
190	P0555LX190	CAP SCREW 1/4-20 X 3/8
191	P0555LX191	FLAT WASHER 5MM
193	P0555LX193	KNOB BOLT 5/16-18 X 2
194	P0555LX194	SHAFT BRACKET
195	P0555LX195	ROLL PIN 4 X 30
212	P0555LX212	FLAT WASHER 3/8
214	P0555LX214	LOWER CLUTCH



Table, Fence & Stand



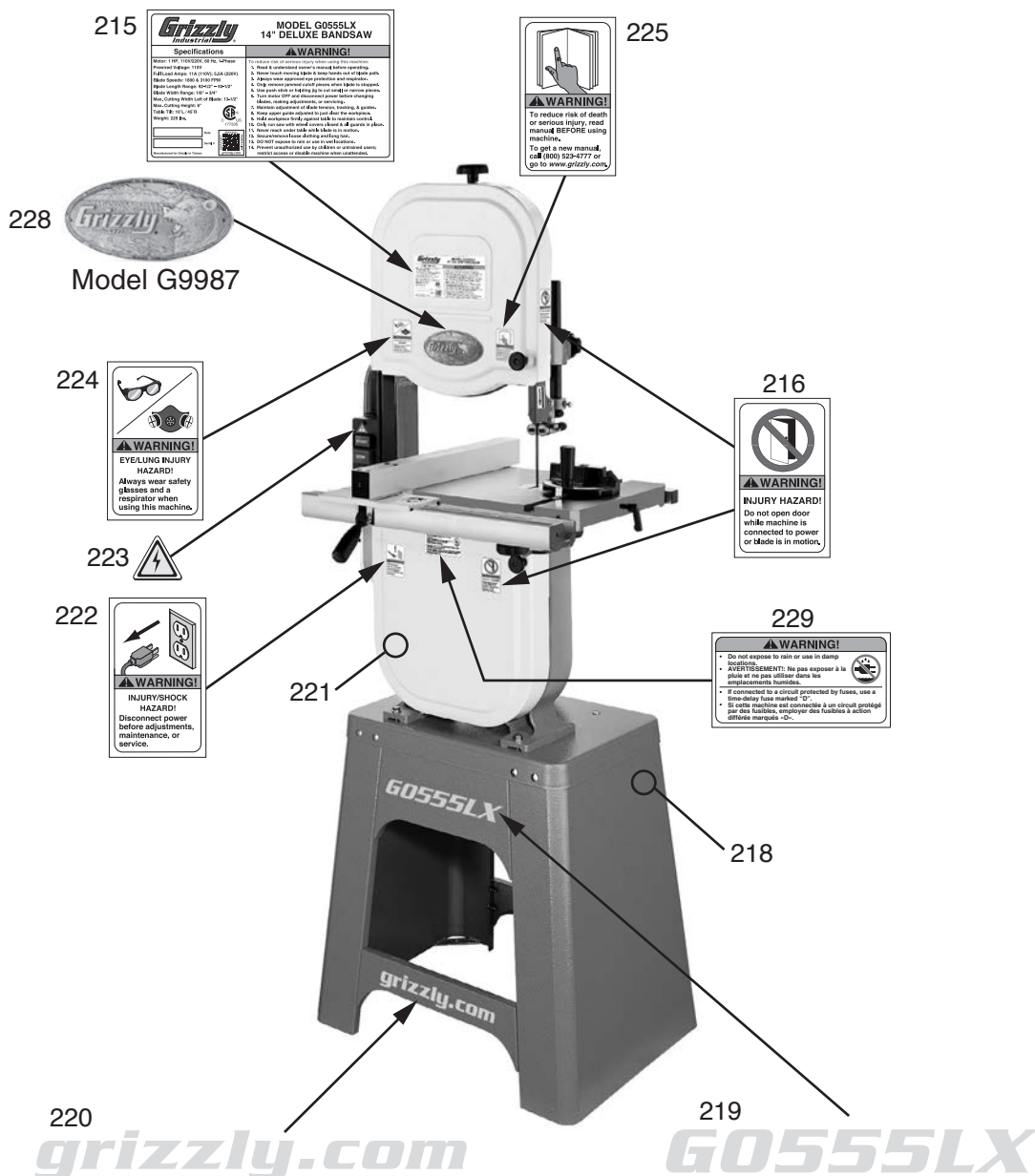
Table, Fence & Stand Parts List

REF	PART #	DESCRIPTION
27	P0555LX027	CAP SCREW 1/4-20 X 2-1/2
32	P0555LX032	PHLP HD SCR 8-32 X 1/4
36	P0555LX036	LOCK CAM
37	P0555LX037	FRONT FENCE RAIL
52	P0555LX052	REAR FENCE RAIL
53	P0555LX053	FRONT RAIL END CAP
54	P0555LX054	MAGNIFYING LENS
55	P0555LX055	PHLP HD SCR 10-24 X 1/2
58	P0555LX058	TAP SCREW #8 X 3/8
70	P0555LX070	PHLP HD SCR 10-24 X 3/8
73	P0555LX073	LOCK WASHER 5/16
77	P0555LX077	FENCE
78	P0555LX078	SPACER
87	P0555LX087	FENCE END CAP
94	P0555LX094	FLAT WASHER 1/4
95	P0555LX095	HEX BOLT 1/4-20 X 3/4
97	P0555LX097	TABLE
98	P0555LX098	TABLE INSERT W/LARGE SLOT
99	P0555LX099	ROLL PIN 3 X 8
100	P0555LX100	TABLE LOCK PIN
101	P0555LX101	TRUNNION
102	P0555LX102	TILT SCALE
103	P0555LX103	TRUNNION CLAMP SHOE
104	P0555LX104	HEX BOLT 1/4-20 X 1/2
105	P0555LX105	TRUNNION BASE
106	P0555LX106	HEX BOLT 5/16-18 X 1-1/4
107	P0555LX107	FENCE CARRIAGE, ALUMINUM
108	P0555LX108	POINTER
109	P0555LX109	PHLP HD SCR 10-24 X 1/4
110	P0555LX110	KNOB 3/8-16, 6-LOBE, D2-1/4
111	P0555LX111	TRUNNION HEX BOLT 3/8-16 x 2
112	P0555LX112	HEX BOLT 5/16-18 X 1-3/4
113	P0555LX113	HEX NUT 5/16-18
114	P0555LX114	MITER GAUGE ASSY
114-1	P0555LX114-1	MITER GAUGE BODY
114-2	P0555LX114-2	MITER BAR
114-3	P0555LX114-3	STOP BLOCK
114-4	P0555LX114-4	STOP DOWEL
114-5	P0555LX114-5	MITER HANDLE 1/4-20
114-6	P0555LX114-6	SCALE PLATE
114-7	P0555LX114-7	STUD-SE 1/4-20 X 1-1/8, 1/2
114-8	P0555LX114-8	FLAT WASHER 1/4 PL

REF	PART #	DESCRIPTION
114-9	P0555LX114-9	FLAT WASHER 1/4
114-10	P0555LX114-10	STUD-SE 1/4-20 X 3/4, 1/4
114-12	P0555LX114-12	FLAT HD SCR 10-24 X 1/2
114-13	P0555LX114-13	FLAT WASHER 5MM
114-14	P0555LX114-14	PHLP HD SCR 10-24 X 1/2
126	P0555LX126	SET SCREW 5/16-18 X 3/8
127	P0555LX127	FLAT WASHER #10
130	P0555LX130	BEARING PAD
131	P0555LX131	HEX NUT 3/8-16
132	P0555LX132	HANDLE BOLT 5/16-18
136	P0555LX136	ECCENTRIC 1/4"
153	P0555LX153	CAM WEAR PLATE
157	P0555LX157	HEX BOLT 3/8-16 X 2
158	P0555LX158	HEX NUT M6-1
159	P0555LX159	RUB FOOT M6-1
160	P0555LX160	CAP SCREW 1/4-20 X 5/8
161	P0555LX161	REAR RAIL END CAP
163	P0555LX163	FLAT HD SCR 1/4-20 X 3/8
166	P0555LX166	FENCE SCALE
169	P0555LX169	HEX NUT 1/4-20
172	P0555LX172	L-BRACE
184	P0555LX184	FENCE PAD
192	P0555LX192	FLANGE SCREW 10-24 X 3/8
197	P0555LX197	FENCE MOUNTING PLATE
198	P0555LX198	TABLE INSERT W/SMALL SLOT
199	P0555LX199	FLAT WASHER 1/4
200	P0555LX200	FENCE ADJUSTMENT PLATE
201	P0555LX201	STAND TOP
202	P0555LX202	CARRIAGE BOLT 5/16-18 X 5/8
204	P0555LX204	FLANGE NUT 5/16-18
205	P0555LX205	STAND SIDE
206	P0555LX206	HEX BOLT 1/4-20 X 5/8
207	P0555LX207	FLAT WASHER 1/4
208	P0555LX208	FLANGE NUT 1/4-20
209	P0555LX209	UPPER STAND BRACE
210	P0555LX210	LOWER STAND BRACE
211	P0555LX211	HEX NUT 3/8-16
212	P0555LX212	FLAT WASHER 3/8
213	P0555LX213	STAND FOOT 3/8-16 X 2
226	P0555LX226	WRENCH 10 X 12MM OPEN-ENDS
227	P0555LX227	HEX WRENCH 5MM



Labels & Cosmetics



REF	PART #	DESCRIPTION
215	P0555LX215	MACHINE ID LABEL CSA
216	P0555LX216	BLADE DOOR LABEL
218	P0555LX218	TOUCH-UP PAINT, GRIZZLY GREEN
219	P0555LX219	MODEL NUMBER LABEL
220	P0555LX220	GRIZZLY.COM LABEL
221	P0555LX221	TOUCH-UP PAINT, GREY PUTTY

REF	PART #	DESCRIPTION
222	P0555LX222	DISCONNECT POWER LABEL
223	P0555LX223	ELECTRICITY LABEL
224	P0555LX224	SAFETY GLASSES LABEL
225	P0555LX225	READ MANUAL LABEL
228	P0555LX228	GRIZZLY NAMEPLATE-MINI
229	P0555LX229	DAMPNESS WARNING LABEL

WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine **MUST** replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.



WARRANTY & RETURNS

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

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

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

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

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

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

To take advantage of this warranty, you must register it at <https://www.grizzly.com/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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