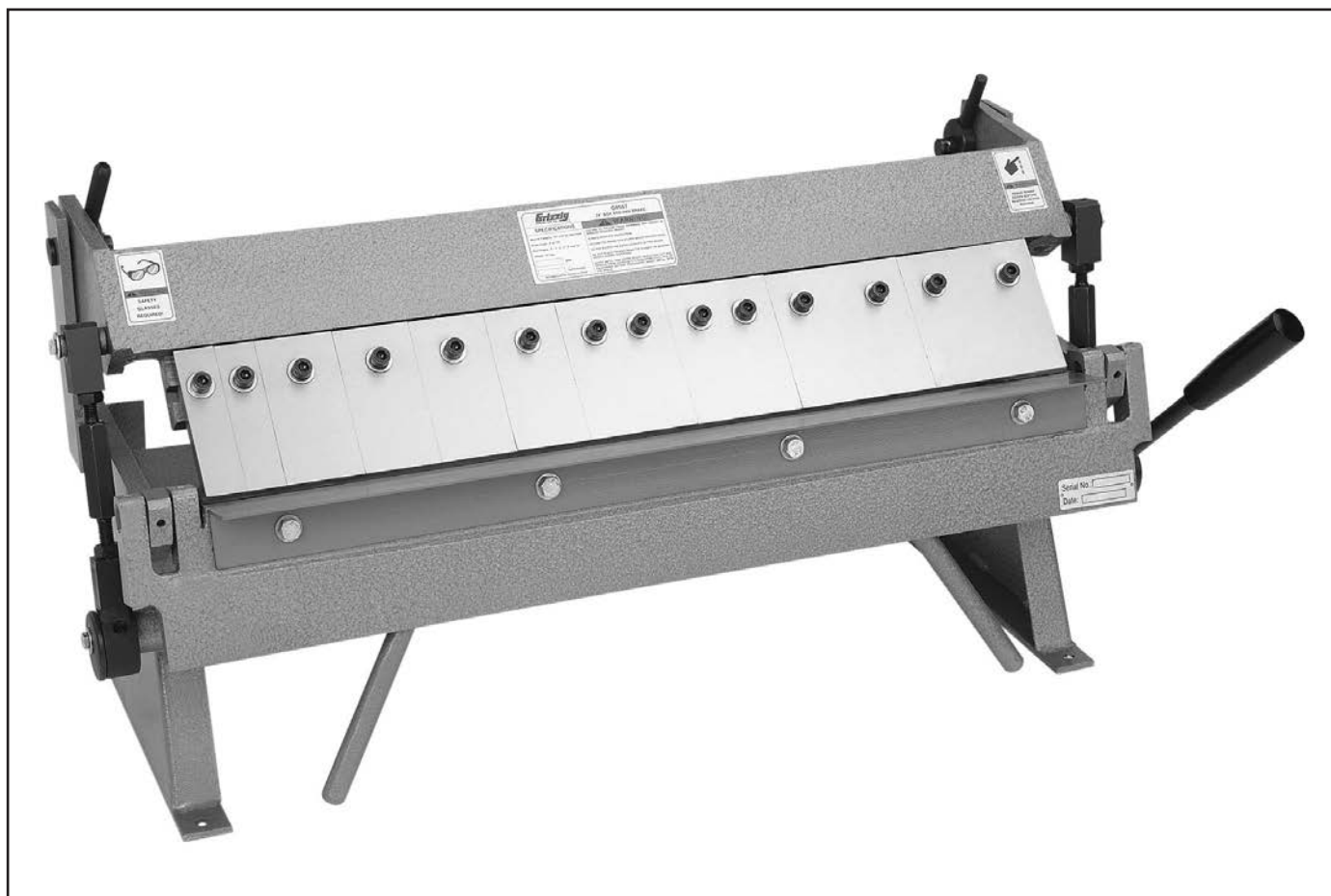


Grizzly *Industrial, Inc.*®

MODEL G0556/G0557 12" & 24" PAN AND BOX BRAKE OWNER'S MANUAL



COPYRIGHT © NOVEMBER, 2003 BY GRIZZLY INDUSTRIAL, INC. REVISED MARCH, 2018 (HE)
**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
(FOR MODELS MANUFACTURED SINCE 10/04) #MS5866 PRINTED IN CHINA



WARNING!

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

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

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

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



WARNING!

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

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

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

Table of Contents

- INTRODUCTION..... 2**
 - Manual Accuracy..... 2
 - Contact Info..... 2
- SECTION 1: SAFETY..... 3**
 - Safety Instructions for Machinery..... 3
 - Additional Safety for Pan and Box Brakes..... 5
- SECTION 2: SET UP..... 6**
 - About This Section..... 6
 - Inspection..... 6
 - Unpacking and Clean-Up..... 6
 - Mounting..... 6
 - Adjustments..... 7
- SECTION 3: OPERATIONS..... 8**
 - Technical Data..... 8
 - Bending Metal..... 8
 - Model G0556/G0557 Parts Breakdown..... 9
 - Model G0556/G0557 Parts List..... 10
- WARRANTY AND RETURNS..... 13**

INTRODUCTION


Manual Accuracy

We are proud to provide a high-quality owner's manual with your new machine!

We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual.**

If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **Manufacture Date** and **Serial Number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation is available for your machine.

		MODEL GXXXX	
		MACHINE NAME	
SPECIFICATIONS		⚠ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Make sure machine is properly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	power before adjustments, maintenance, or service.		
	5. DO NOT expose to rain or dampness.		
	6. DO NOT modify this machine in any way.		
	7.		
	8.		
	9. Do not use while impaired by drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		
	Manufactured for Grizzly in Taiwan		

Manufacture Date (indicated by an arrow pointing to the date field in the specifications section)

Serial Number (indicated by an arrow pointing to the serial number field in the specifications section)

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



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

This symbol is used to alert the user to useful information about proper operation of the machine.

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.



WARNING

Additional Safety for Pan and Box Brakes

- 1. OVERLOADING PAN AND BOX BRAKE.** Overloading this tool can cause injury from flying parts. Do not exceed the capacities specified on **Page 8**.
- 2. USAGE.** Do not use this pan and box brake as a press or a lever-operated crushing tool. Never use this machine without fully understanding its limitations.
- 3. METAL EDGES.** Always chamfer and deburr sharp sheet metal edges before bending in the pan and box brake. Sharp edges on sheet metal can cut your fingers to the bone.
- 4. PINCHING.** Always keep hands away from the clamping leaf. This area presents a severe pinching hazard.
- 5. GLOVES AND GLASSES.** Always wear leather gloves and approved safety glasses when using this tool.
- 6. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, STOP using the tool and contact our Technical Support at (570) 546-9663, or ask a qualified expert how the operation should be performed.
- 7. TOOLS IN POOR CONDITION.** Inspect the pan and box brake for any cracked linkage, levers, or loose fasteners. Correct any problems before use.

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

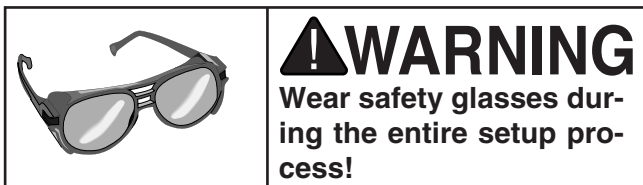
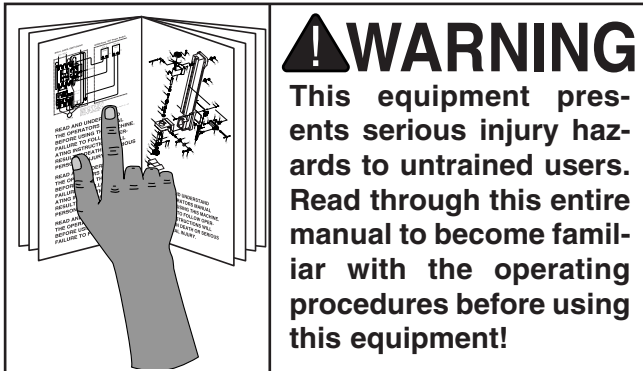
No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or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



SECTION 2: SET UP

About This Section

The purpose of this section is to guide you through the required steps to get your machine out of its packaging and into operating condition.



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.***

Clean-Up

1. Remove the box from around the Model G0556/G0557 Pan and Box Brake.
2. Clean the protective coating from machine surfaces. Note—*Use a mild solvent and soft rag. Thinners, gasoline, acetone ect. will damage painted surfaces.*
3. Place a light coat of machine oil on all machined surfaces to prevent rust.

Mounting

1. Before mounting the Model G0556/G0557 to a flat and level work surface, make sure the mounting surface is solid enough to hold the pan and box brake and the work material.
2. Place the pan and box brake onto the work surface and make sure adequate work room has been given on all sides.
3. Using a pen or pencil, transfer the hole location to the mounting surface.
4. Mount the pan and box brake to work surface using $\frac{5}{16}$ " bolts.



Adjustments

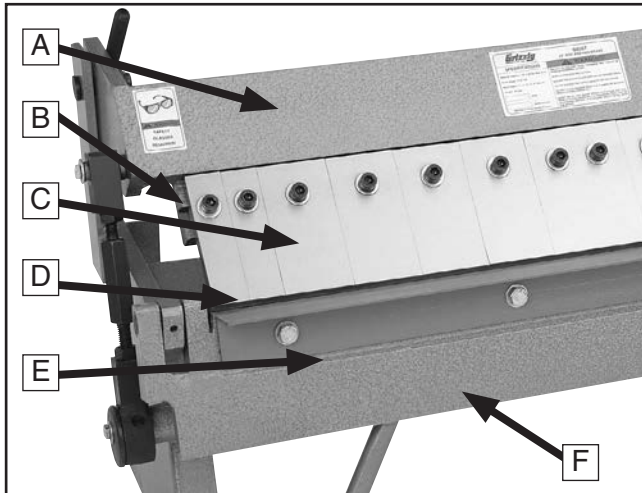


Figure 1. Brake parts.

- A. Hold Down Assembly
- B. Hold Down Stop
- C. Fingers
- D. Finger Knife Edge
- E. Apron Face
- F. Apron

To adjust the fingers:

1. Loosen the cap screws on the fingers, then push the fingers up into the hold down assembly stop.
2. Making sure the fingers are held square and tight to the hold down assembly stop (Figure 2), then tighten the cap screws to secure fingers.



Figure 2. Fingers located square and tight against hold down assembly stop.

To adjust for metal thickness:

1. Loosen the setscrews on the back of both sides of the hold down assembly.
2. Rotate the eccentric on the back of the hold down assembly. The hold down assembly will move in and out, moving the front of the fingers toward or away from the apron face.
3. When the fingers are adjusted to the proper offset and are parallel to the apron face and base, tighten the set screw to secure the eccentric. Note—*The offset between the front edge of the finger and the face of the apron needs to be approximately 1½ times the thickness of the material being bent or greater. It cannot be less than 1½ times or damage will occur to the finger knife edge.*
4. Loosen the two turnbuckle hex nuts on each side of the hold down assembly (Figure 3).

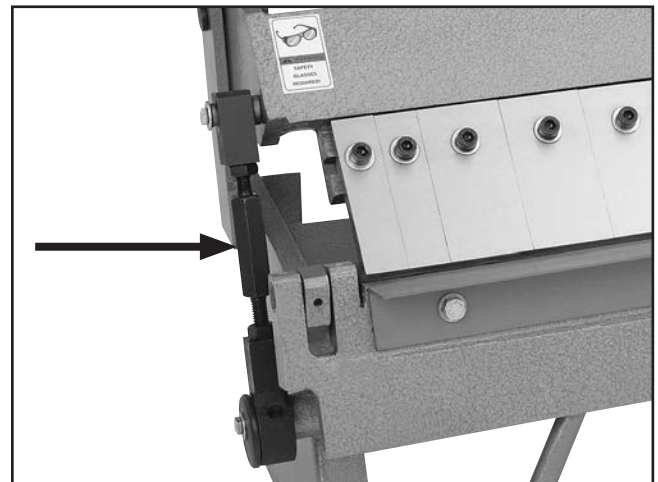
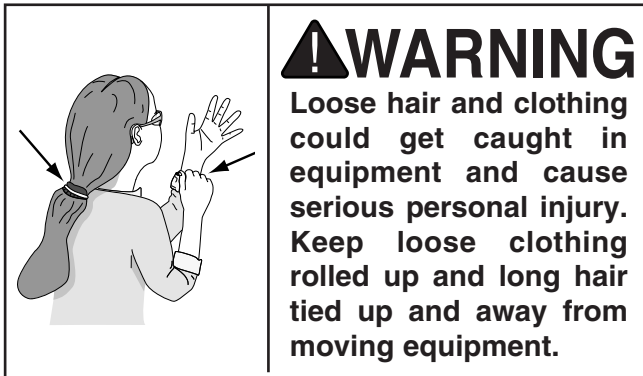


Figure 3. Turnbuckle.

5. Adjust the hold down assembly for the metal thickness, using the turnbuckle on each side of the hold down assembly. The holding pressure should be great enough to hold the metal from moving when bending, but not so tight that the hold down handle is hard to operate.
6. When the desired tension is reached, tighten hex nuts on each side of the hold down assembly.



SECTION 3: OPERATIONS



Technical Data

Steel Capacity:	20 gauge sheet metal (1mm) (MILD STEEL)
Width Capacity:	Model G0556 12" (305mm) Model G0557 24" (610mm)
Working Height:	9" (230mm)
Max. Pan Depth:	$\frac{7}{8}$ " (22mm)
Overall Dimensions:	Model G0556 12" $18\frac{1}{16}$ " x 11" x $14\frac{3}{8}$ " (475x280x365mm) Model G0557 24" $30\frac{1}{16}$ " x 11" x $14\frac{3}{8}$ " (780x280x365mm)
Weight:	Model G0556 79 lbs (27kgs) Model G0557 124 lbs (42kgs)

Bending Metal

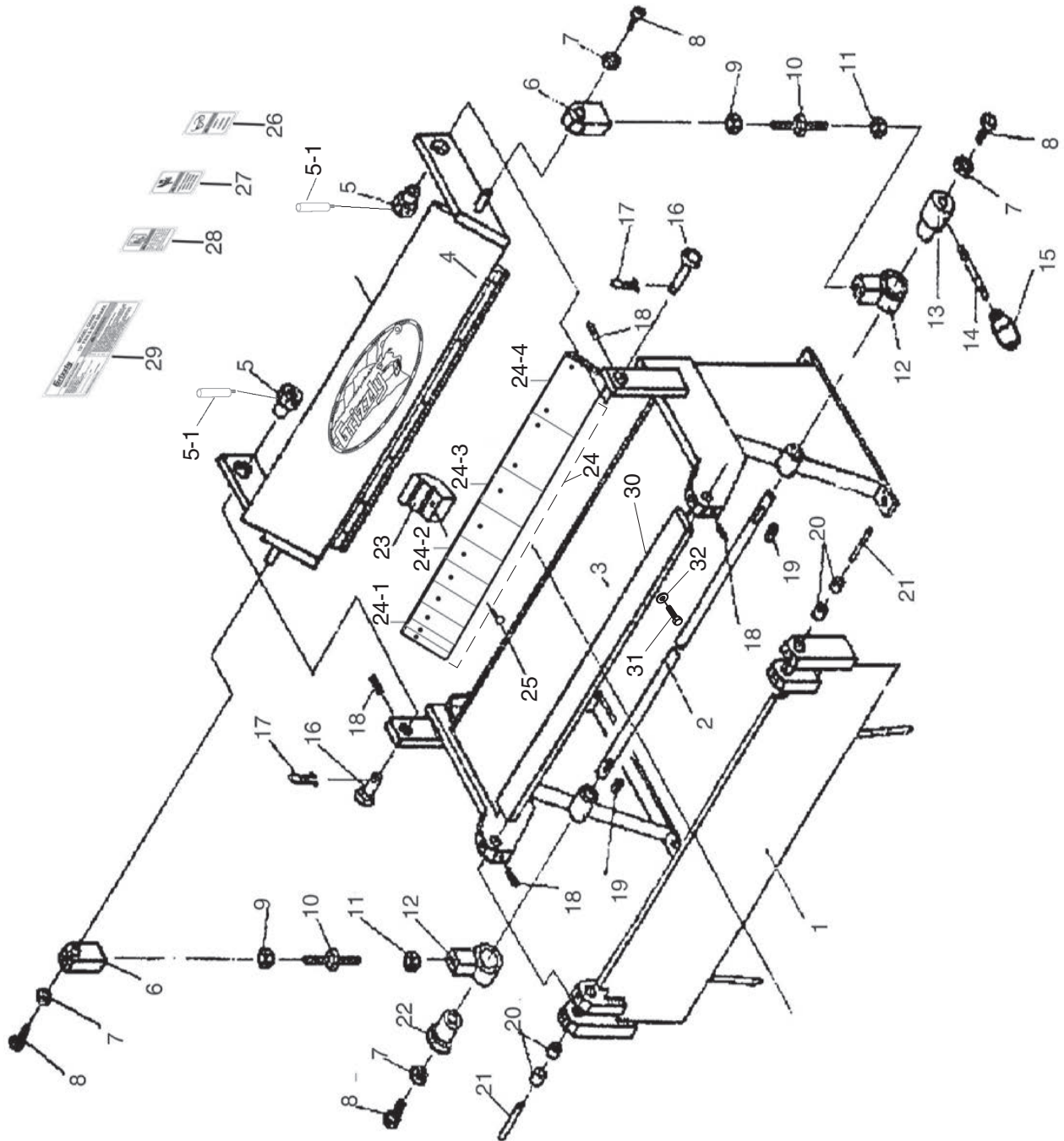
The fabrication of metal is a process which takes many years to learn and perfect. The steps below will help you in getting started with this process, and make it more enjoyable.

Bending metal procedures:

1. Lift the hold down handle to open the hold down assembly all the way.
2. Insert the sheet metal workpiece between the hold down assembly and the body.
3. Align the fingers of the hold down assembly to the bend mark on the workpiece.
4. Move the hold down handle to hold the workpiece with the hold down assembly. *Note—Do not force the hold down handle. If the handle is hard to put in the locked position, the brake may need to be adjusted for the workpiece thickness. The clamping pressure of the hold down assembly needs to be just tight enough to hold the workpiece from moving when bending.*
5. Lift up on the apron handles (using both hands) until the workpiece has reached the desired angle.
6. Lift the hold down handle to open the hold down assembly then remove the bent workpiece. *Note—If a pan or box bend is desired, choose a die or a selection of dies that are as close as possible to the length of pan or box side.*



Model G0556/G0557 Parts Breakdown



Model G0556/G0557 Parts List

REF	PART #	DESCRIPTION
1	P0556001	APRON (G0556)
1	P0557001	APRON (G0557)
2	P0556002	SHAFT (G0556)
2	P0557002	SHAFT (G0557)
3	P0556003	BODY (G0556)
3	P0557003	BODY (G0557)
4	P0556004	HOLD DOWN ASSEMBLY (G0556)
4	P0557004	HOLD DOWN ASSEMBLY (G0057)
5	P0556005	UPPER ECCENTRIC
5-1	P0556005-1	HANDLE M6-1 X 1-3/4
6	P0556006	CONNECTING BLOCK
7	P0556007	FLAT WASHER 6MM
8	P0556008	CAP SCREW M6-1 X 10
9	P0556009	HEX NUT M10-1.5
10	P0556010	TURNBUCKLE
11	P0556011	HEX NUT M10-1.5
12	P0556012	BUSHING
13	P0556013	LOWER RIGHT ECCENTRIC
14	P0556014	SCREW ROD
15	P0556015	HANDLE
16	P0556016	PIN SHAFT
17	P0556017	SPLIT PIN

REF	PART #	DESCRIPTION
18	P0556018	SET SCREW M6-1 X 10
19	P0556019	KEY 4 X 4 X 15MM
20	P0556020	BUSHING
21	P0556021	SMALL SHAFT
22	P0556022	LOWER LEFT ECCENTRIC
23	P0556023	T-NUT
24	P0556024	COMPLETE FINGER SET (G0556)
24	P0557024	COMPLETE FINGER SET (G0557)
24-1	P0556024-1	FINGER 1"
24-2	P0556024-2	FINGER 2"
24-3	P0556024-3	FINGER 3"
24-4	P0557024-4	FINGER 4" (G0557)
25	P0556025	CAP SCREW M8-1.25 X 20
26	P0556026	SAFETY GLASSES LABEL
27	P0556027	PINCH HAZARD LABEL
28	P0556028	READ MANUAL LABEL
29	P0556029	MACHINE ID LABEL (G0556)
29	P0557029	MACHINE ID LABEL (G0557)
30	P0556030	WORKPIECE SUPPORT
31	P0556031	HEX BOLT M8-1.25 X 16
32	P0556032	FLAT WASHER 8MM





WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____
 Model # _____ Order # _____ Serial # _____

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

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

2. Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinetmaker & FDM	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	

3. What is your annual household income?

\$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

20-29 30-39 40-49
 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value? Yes No

8. Would you recommend Grizzly Industrial to a friend? Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times. Yes No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

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

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

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

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

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

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

grizzly.com[®]

TOOL WEBSITE

Buy Direct and Save with Grizzly[®] – Trusted, Proven and a Great Value!
~Since 1983~

*Visit Our Website Today For
Current Specials!*

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

