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

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

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

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

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

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

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

Manual Accuracy

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

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

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

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

Contact Info

We stand behind our machines! If you have questions or need help, contact us with the information below. Before contacting, make sure you get the serial number and manufacture date from the machine ID label. This will help us help you faster.

Grizzly Technical Support
1815 W. Battlefield
Springfield, MO 65807
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

WARNING

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

A. **Crosscut Table**—Provides a wide, stable platform for supporting full-size panels during crosscutting operations.

B. **Flip Stops**—Used for quick measurements for crosscutting.

C. **Crosscut Fence**—Used during crosscutting operations. Features a scale and multiple flip-style stop blocks for precise, repeatable crosscutting operations.

D. **Sliding Table**—Conveniently glides the workpiece through the blade with effortless precision and ease.

E. **Blade Guard**—Fully-adjustable blade guard maintains maximum protection around the saw blade and a 2½" dust port effectively extracts dust from the cutting operation.

F. **Rip Fence**—Fully adjustable with micro-adjustment knob for precision adjustments. Fence face can be positioned for standard cutting operations, or in the lower position for blade guard clearance during narrow ripping operations.

G. **Switch**—Features push-button controls starting and stopping the table saw motor.

H. **Blade Angle Handwheel**—Adjusts the angle of the saw blades.

I. **Blade Elevation Handwheel**—Located on the right-hand side of the cabinet, this handwheel adjusts the height of the main saw blade.

---

**Figure 1.** Main view of machine features and controls.
### MODEL G0623X & G0623X3
10" SLIDING TABLE SAW SPECIFICATIONS

<table>
<thead>
<tr>
<th>Model Number</th>
<th>G0623X</th>
<th>G0623X3</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Product Dimensions</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Weight</td>
<td>533 lbs</td>
<td></td>
</tr>
<tr>
<td>Width (side-to-side)/Depth (front-to-back)/Height</td>
<td>76 x 124-3/4 x 46 in.</td>
<td></td>
</tr>
<tr>
<td>Foot Print (Width/Depth)</td>
<td>25-1/4 x 28 in.</td>
<td>25-1/4 x 28 in.</td>
</tr>
<tr>
<td><strong>Shipping Dimensions</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Carton 1</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Type</td>
<td>Wood Crate</td>
<td></td>
</tr>
<tr>
<td>Content</td>
<td>Machine</td>
<td></td>
</tr>
<tr>
<td>Weight</td>
<td>570 lbs.</td>
<td>556 lbs.</td>
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<tr>
<td>Width (side-to-side)/Depth (front-to-back)/Height</td>
<td>46 x 42 x 44 in.</td>
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<td>Carton 2</td>
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<td></td>
</tr>
<tr>
<td>Type</td>
<td>Cardboard</td>
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</tr>
<tr>
<td>Content</td>
<td>Sliding Table &amp; Fence</td>
<td></td>
</tr>
<tr>
<td>Weight</td>
<td>118 lbs.</td>
<td></td>
</tr>
<tr>
<td>Width (side-to-side)/Depth (front-to-back)/Height</td>
<td>67 x 18-1/2 x 10 in.</td>
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<td><strong>Electrical</strong></td>
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<td>Power Requirement</td>
<td>230V, Single-Phase, 60 Hz</td>
<td>220V or 440V, 3-Phase, 60 Hz</td>
</tr>
<tr>
<td>Prewired Voltage</td>
<td>230V</td>
<td>220V</td>
</tr>
<tr>
<td>Full-Load Current Rating</td>
<td>19A</td>
<td>18A @ 220V, 9A at 440V</td>
</tr>
<tr>
<td>Minimum Circuit Size</td>
<td>30A</td>
<td>30A @ 220V, 15A @ 440V</td>
</tr>
<tr>
<td>Switch</td>
<td>Magnetic with Thermal Overload Protection</td>
<td></td>
</tr>
<tr>
<td>Power Cord</td>
<td>“S”-Type, 3-Wire, 12 AWG, 300 VAC</td>
<td>Recommend “S”-Type, 4-Wire, 10 AWG, 300 VAC for 220V; Permanent Connection for 440V</td>
</tr>
<tr>
<td>Plug Included</td>
<td>Yes</td>
<td>No</td>
</tr>
<tr>
<td>Plug/Outlet Type</td>
<td>L6-30</td>
<td>Recommend L15-30 for 220V; Permanent Connection for 440V</td>
</tr>
<tr>
<td>Voltage Conversion Kit</td>
<td>Not Applicable</td>
<td>Requires Part# G440VG0623X3</td>
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<tr>
<td>Recommended Phase Converter</td>
<td>Not Applicable</td>
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<td><strong>Main Motor</strong></td>
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<td>Type</td>
<td>TEFC Capacitor Start Induction</td>
<td></td>
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<tr>
<td>Horsepower</td>
<td>5 HP</td>
<td>7.5 HP</td>
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<tr>
<td>Voltage</td>
<td>230V</td>
<td>220V/440V</td>
</tr>
<tr>
<td>Prewired</td>
<td>Not Applicable</td>
<td>220V</td>
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<td>Phase</td>
<td>Single</td>
<td>3-Phase</td>
</tr>
<tr>
<td>Amps</td>
<td>19A</td>
<td>18A @ 220V, 9A @ 440V</td>
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<tr>
<td>Speed</td>
<td>3450 RPM</td>
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<tr>
<td>Cycle</td>
<td>60 Hz</td>
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<td>Power Transfer</td>
<td>V-Belt Drive</td>
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<td>Bearings</td>
<td>Sealed and Lubricated</td>
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<td>G0623X</td>
<td>G0623X3</td>
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<td>--------------</td>
<td>--------</td>
<td>---------</td>
</tr>
<tr>
<td><strong>Operation Information</strong></td>
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<tr>
<td>Main Blade Size</td>
<td>10 in.</td>
<td></td>
</tr>
<tr>
<td>Main Arbor Size</td>
<td>5/8 in.</td>
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<tr>
<td>Scoring Blade Size</td>
<td>3-1/8 in.</td>
<td></td>
</tr>
<tr>
<td>Scoring Blade Arbor Size</td>
<td>22 mm</td>
<td></td>
</tr>
<tr>
<td>Maximum Width of Dado</td>
<td>13/16 in.</td>
<td></td>
</tr>
<tr>
<td>Main Blade Tilt</td>
<td>0 - 45 deg</td>
<td></td>
</tr>
<tr>
<td>Main Blade Speed</td>
<td>4000 RPM</td>
<td></td>
</tr>
<tr>
<td>Scoring Blade Tilt</td>
<td>0 - 45 deg</td>
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</tr>
<tr>
<td>Scoring Blade Speed</td>
<td>8000 RPM</td>
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<tr>
<td><strong>Cutting Capacities</strong></td>
<td></td>
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<tr>
<td>Max Depth of Cut At 90 Deg</td>
<td>3-1/8 in.</td>
<td></td>
</tr>
<tr>
<td>Max Depth of Cut At 45 Deg</td>
<td>2-1/4 in.</td>
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</tr>
<tr>
<td>Table With Rip Fence Max Cut Width</td>
<td>33 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table With Cross Fence Max Cut Width</td>
<td>78-1/2 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table With Cross Fence Max Cut Length</td>
<td>63 in.</td>
<td></td>
</tr>
<tr>
<td>Miter Fence Cut Width At 45 Deg</td>
<td>63 in.</td>
<td></td>
</tr>
<tr>
<td><strong>Table Information</strong></td>
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</tr>
<tr>
<td>Floor To Table Height</td>
<td>33-5/8 in.</td>
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</tr>
<tr>
<td>Table Size Length</td>
<td>27 in.</td>
<td></td>
</tr>
<tr>
<td>Table Size Width</td>
<td>14-3/8 in.</td>
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</tr>
<tr>
<td>Table Size Thickness</td>
<td>2 in.</td>
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</tr>
<tr>
<td>Table Size With Ext Wings Length</td>
<td>47 in.</td>
<td></td>
</tr>
<tr>
<td>Table Size With Ext Wings Width</td>
<td>40 in.</td>
<td></td>
</tr>
<tr>
<td>Table Size With Ext Wings Thickness</td>
<td>2 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table Length</td>
<td>63 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table Width</td>
<td>12-1/4 in.</td>
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</tr>
<tr>
<td>Sliding Table Thickness</td>
<td>3-1/2 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table T Slot Top Width</td>
<td>5/8 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table T Slot Height</td>
<td>1/2 in.</td>
<td></td>
</tr>
<tr>
<td>Sliding Table T Slot Bottom Width</td>
<td>1-1/4 in.</td>
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</tr>
<tr>
<td><strong>Fence Information</strong></td>
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<tr>
<td>Fence Type</td>
<td>Extruded Aluminum</td>
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<tr>
<td>Fence Size Length</td>
<td>33-1/2 in.</td>
<td></td>
</tr>
<tr>
<td>Fence Size Width</td>
<td>2 in.</td>
<td></td>
</tr>
<tr>
<td>Fence Size Height</td>
<td>4-1/4 in.</td>
<td></td>
</tr>
<tr>
<td>Fence Stops</td>
<td>2</td>
<td></td>
</tr>
<tr>
<td>Construction Materials</td>
<td>G0623X</td>
<td>G0623X3</td>
</tr>
<tr>
<td>--------------------------------</td>
<td>-----------------------</td>
<td>-----------------------</td>
</tr>
<tr>
<td>Table</td>
<td>Cast Iron</td>
<td></td>
</tr>
<tr>
<td>Sliding Table</td>
<td>Aluminum</td>
<td></td>
</tr>
<tr>
<td>Base</td>
<td>Steel</td>
<td></td>
</tr>
<tr>
<td>Body Assembly</td>
<td>Steel</td>
<td></td>
</tr>
<tr>
<td>Cabinet</td>
<td>Steel</td>
<td></td>
</tr>
<tr>
<td>Trunnions</td>
<td>Cast Iron</td>
<td></td>
</tr>
<tr>
<td>Fence Assembly</td>
<td>Extruded Aluminum</td>
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</tr>
<tr>
<td>Rails</td>
<td>Hardened Steel</td>
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</tr>
<tr>
<td>Guard</td>
<td>Plastic</td>
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<tr>
<td>Spindle Bearing Type</td>
<td>Radial Ball Bearing 6004LLB</td>
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<tr>
<td>Paint</td>
<td>Powder Coated</td>
<td></td>
</tr>
</tbody>
</table>

| Other Related Information      |                       |                       |
| No of Dust Ports               | 2                     |                       |
| Dust Port Size                 | 4, 2-1/2 in.          |                       |
MODEL G0623X/G0623X3 10" SLIDING TABLE SAW

Ripping Width

Cross Cut

Miter Cut 90°
(push cut)

Miter Cut 45°
(push cut)

Miter Cut 45°
(fence not extended)

Miter Cut 45°
(push cut, fence not extended)

Miter Cut 45°
(fence not extended)
For Your Own Safety, Read Instruction Manual Before Operating This Machine

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

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

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

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

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

Safety Instructions for Machinery

**WARNING**

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

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

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

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

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

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

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are NOT approved safety glasses.
WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

⚠️ **WARNING**

Serious cuts, amputation, or death can occur from contact with rotating saw blade during operation. Workpieces, broken blades, or flying particles thrown by blade can blind or strike operators or bystanders with deadly force. To reduce the risk of these hazards, operator and bystanders MUST completely heed the hazards and warnings below.

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

**BLADE GUARD.** The blade guard protects operator from rotating saw blade. Make sure blade guard is installed, adjusted correctly, and used for all possible “through cuts.” Promptly repair or replace if damaged. Re-install immediately after operations that require its removal.

**RIVING KNIFE.** Use riving knife for all “non-through cuts.” Make sure it is aligned and positioned correctly. Promptly repair or replace it if damaged.

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

**FEEDING WORKPIECE.** Feeding workpiece incorrectly increases risk of kickback. Always allow blade to reach full speed before cutting, feed workpiece from front of saw, making sure workpiece is flat against table and a fence, miter gauge, or other guide is used to feed workpiece in a straight line. Feed cuts through to completion. Never start saw with workpiece touching blade or pull workpiece from behind blade. Never back workpiece out of cut, move it sideways, or perform a “freehand” operation. Never plunge cut.

**PUSH STICKS/PUSH BLOCKS.** To reduce risk of accidental blade contact, use push sticks/push blocks whenever possible. In event of an accident, these will often take damage that would have occurred to hands/fingers.

**FENCE.** To reduce risk of kickback, make sure fence remains properly adjusted and parallel with blade. Always lock fence before using.

**CUT-OFF PIECES.** To avoid risk of injury due to blade contact, turn saw OFF and allow blade to completely stop before removing cut-off pieces near blade or trapped between blade and table insert. Never use your hands to move cut-off pieces away from blade while saw is running.

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

**CHANGING BLADES.** Accidental startup while changing saw blade can result in serious injury. To reduce risk of accidental blade contact, always disconnect power before changing blades.

**DAMAGED SAW BLADES.** Damaged saw blade teeth can become deadly projectiles. Never use blades that have been dropped or damaged.

**DADO AND RABBET OPERATIONS.** Dado and rabbeting operations require special attention since they must be performed with blade guard removed, which increases risk of blade contact. DO NOT attempt dado or rabbeting operations without first reading these sections in this manual.

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

Below are ways to avoid the most common causes of kickback:

• Only cut workpieces with at least one smooth and straight edge. DO NOT cut excessively warped, cupped or twisted wood. If the workpiece warpage is questionable, always choose another workpiece.

• Never attempt freehand cuts. If the workpiece is not fed parallel with the blade, a kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.

• Make sure the splitter/riving knife is aligned with the blade. A misaligned splitter/riving knife can cause the workpiece to catch or bind, increasing the chance of kickback. If you think that your splitter/riving knife is not aligned with the blade, check it immediately!

• Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are greatly increased. Take the time to check and adjust the sliding table to be parallel with the blade.

• Do not remove the splitter/riving knife. The splitter/riving knife maintains the kerf in the workpiece, reducing the chance of kickback.

• Keep the blade guard installed and working correctly for all through cuts.

• Feed cuts through to completion. Anytime you stop feeding a workpiece in the middle of a cut, the chance of kickback is increased.

• Never move the workpiece backwards while cutting or try to back it out of a cut while the blade is moving. If you cannot complete a cut for some reason, stop the saw motor and allow the blade to completely stop moving before backing the workpiece out. Promptly fix the condition that prevented you from completing the cut, before starting the saw again.

Protecting Yourself From Kickback

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

• Stand to the side of the blade during every cut. If a kickback does occur, the thrown workpiece usually travels directly in front of the blade.

• Wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.

• Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade, which could cause amputation.

• Use a push stick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.

• Use featherboards or anti-kickback devices to assist with feeding and prevent or slow down kickback.

⚠️ WARNING

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

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

**Arbor:** The metal shaft on which the blade is mounted.

**Bevel Edge Cut:** A cut made along the edge of a workpiece with the saw blade tilted between 0˚ and 45˚. Refer to Page 71 for more details.

**Blade Guard Assembly:** A safety device that mounts over the saw blade to help prevent accidental contact with the saw blade and to contain flying chips and dust. Refer to Page 37 for more details.

**Crosscut:** Cutting operation in which the miter gauge is used to hold the workpiece while it is cut across its shortest width. Refer to Page 46 for more details.

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

**Dado Cut:** Cutting operation that uses a dado blade to cut a flat bottomed groove into the face of the workpiece. Refer to Page 49 for more details.

**Featherboard:** Safety device used to keep the workpiece held firmly against the rip fence or table surface. Refer to Page 1 for more details.

**Kerf:** The resulting cut or gap in the workpiece after the saw blade passes through during a cutting operation.

**Kickback:** An event in which the spinning blade ejects the workpiece toward the front of the saw at a high rate of speed.

**Non-Through Cut:** A cut in which the blade does not cut through the top of the workpiece. Refer to Page 36 for more details.

**Parallel:** Being an equal distance apart at every point along two given lines or planes (i.e. the rip fence face is parallel to the face of the saw blade).

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

**Push Stick:** Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces. Refer to Page 58 for more details.

**Rabbet:** Cutting operation that creates an L-shaped channel along the edge of the workpiece. Refer to Page 51 for more details.

**Rip Cut:** Cutting operation in which the rip fence is used to cut across the widest width of the workpiece. Refer to Page 44 for more details.

**Splitter/Riving Knife:** Curved metal plate located behind the blade. Maintains kerf opening in wood when performing a cutting operation. Acts as a barrier behind blade to shield hands from being pulled into the blade if a kickback occurs. Refer to Page 39 for more details.

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

**Thin Kerf Blade:** A blade with a kerf or thickness that is thinner than a standard blade cannot be used on this saw.

**Through Cut:** A cut in which the blade cuts completely through the workpiece (refer to Page 36).
SECTION 2: POWER SUPPLY

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

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

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

- **G0623X** at 230V, 1-Ph......................... 19 Amps
- **G0623X3** at 220V, 3-Ph....................... 18 Amps
- **G0623X3** at 440V, 3-Ph......................... 9 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.)

**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.

**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.

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.

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.
G0623X Circuit Requirements
This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage ..........208V, 220V, 230V, 240V
Cycle ..........................................................60 Hz
Phase ........................................... Single-Phase
Circuit Rating ........................................ 30 Amps
Plug/Receptacle .......................... L6-30

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug. Only insert plug into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances. DO NOT modify the provided plug!

Figure 2. Typical L6-30 plug and receptacle.

G0623X3 Circuit Requirements 220V
This machine is prewired to operate on a power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage ..........208V, 220V, 230V, 240V
Cycle ..........................................................60 Hz
Phase ........................................... 3-Phase
Power Supply Circuit ................. 30 Amps
Plug/Receptacle .......................... L15-30
Cord ........... "S"-Type, 4-Wire, 10 AWG, 300 VAC

The power cord and plug used on this machine must have an equipment-grounding wire and grounding prong. The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances (see figure below).

Figure 3. Typical L15-30 plug and receptacle.

CAUTION
No adapter should be used with plug. If plug does not fit available receptacle, or if machine must be reconnected for use on a different type of circuit, reconnection must be performed by an electrician or qualified service personnel, and it must comply with all local codes and ordinances.
G0623X3 Circuit Requirements 440V

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 ....................... 440V, 480V
Cycle ............................................. 60 Hz
Phase .................................................. 3-Phase
Power Supply Circuit ..................... 15 Amps
Connection Type ............ Permanent (Hardwire)

A permanently connected (hardwired) power supply is typically installed with wires running through mounted and secured conduit. A disconnecting means, such as a locking switch (see following figure), must be provided to allow the machine to be disconnected (isolated) from the power supply when required. This installation must be performed by an electrician in accordance with all applicable electrical codes and ordinances.

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:

G0623X ............ 3 Wire, 10 AWG, 50 ft. or less
G0623X3 (220V) 4 Wire, 10 AWG, 50 ft. or less
G0623X3 (440V) ................. N/A (Hardwired)

![Figure 4. Typical setup of a permanently connected (hardwired) machine.](image-url)

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical current to reduce the risk of electric shock. A permanently connected machine must be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. All grounds must be verified and rated for the electrical requirements of the machine. Improper grounding can increase the risk of electric shock!
G0623X3 440V Voltage Conversion

The Model G0623X3 is prewired for 220V 3-phase operation, but it can be rewired for 440V operation.

To complete this conversion procedure, you must buy a 440V magnetic switch and rewire the motor for 440V operation. The 440V magnetic switch, Part P0623X30346A, can be purchased from Grizzly by calling 1-800-523-4777.

This rewiring job must be inspected by a qualified electrician before the saw is connected to the power source. Also, the junction box on the motor can be accessed easier for rewiring if the blade is moved to 0˚ (90˚ to table) before beginning.

To rewire the machine for 440V operation:

1. DISCONNECT SAW FROM POWER!
2. Remove cover of magnetic switch.
3. Disconnect all wires from incoming power cords.
4. Remove magnetic switch and install new magnetic switch in same manner as old switch was installed. Refer to wiring diagram on Page 79 if you need help remembering where wires are attached.
5. Remove cabinet cover from back of machine.
6. Rewire motor to 440V as shown in diagram on Page 79.
7. Replace junction box cover, cabinet door cover, and magnetic switch cover.
### SECTION 3: SETUP

#### 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.**

#### Needed for Setup

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

<table>
<thead>
<tr>
<th>Description</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>An Assistant</td>
<td>1</td>
</tr>
<tr>
<td>Safety Glasses (for each person)</td>
<td>1</td>
</tr>
<tr>
<td>Forklift</td>
<td>1</td>
</tr>
<tr>
<td>Lifting Straps</td>
<td>2</td>
</tr>
<tr>
<td>An Electrician</td>
<td>1</td>
</tr>
<tr>
<td>Straightedge 4' (or longer)</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrenches 3, 4, 5, 6, 8mm</td>
<td>1 Each</td>
</tr>
</tbody>
</table>

**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.

**WARNING**

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

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!

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Wear safety glasses during the entire setup process!

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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.

**WARNING**

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.
Inventory

After all the parts have been removed from the boxes in the crate, you should have the items listed below.

If any nonproprietary 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 Item (Figure 5):**

| Qty | A. Table Saw | 1 |

**Inventory Item (Figure 6):**

| Qty | B. Large Extension Table | 1 |
| Qty | C. Small Extension Table | 1 |
| Qty | D. Hose Support | 1 |

**Inventory Item (Figure 7):**

| Qty | E. Crosscut Fence | 1 |
| Qty | F. Support Bar | 1 |
| Qty | G. Crosscut Table | 1 |
| Qty | H. Crosscut Table Support Leg | 1 |
| Qty | I. Flip Stops | 2 |
| Qty | J. Lock Lever M12-1.75 x 55 | 1 |
| Qty | K. Flat Washer 12mm | 1 |
| Qty | L. T-Nut M12-1.75 | 1 |

**Inventory Item (Figure 8):**

| Qty | M. Rip Fence Rail | 1 |
| Qty | N. Rip Fence | 1 |
| Qty | O. Rip Fence Scale | 1 |
| Qty | P. Rip Fence Lever w/Hex Nut M8-1.25 | 1 |
| Qty | Q. Rip Fence Base | 1 |

**Inventory Item (Figure 9):**

| Qty | R. Blade Guard w/Cap Screw & Lock Nut | 1 |
| Qty | S. Arbor Lock Tool | 1 |
| Qty | T. Sliding Table Handle w/Lock | 1 |
| Qty | U. Push Stick | 1 |
| Qty | V. Splitter/Riving Knife | 1 |
| Qty | W. End Cover | 1 |
| Qty | X. Wrench 17mm (not shown) | 1 |
| Qty | Y. Wrench 19/22mm (not shown) | 1 |

**Figure 5.** Table saw.

**Figure 6.** Extension table items.

**Figure 7.** Crosscut table items.

**Figure 8.** Rip fence items.

**Figure 9.** Miscellaneous components.
Inventory Item (Figure 10): Qty
AA. Miter Clamp ......................................... 1
AB. Miter Flip Stop ........................................ 1
AC. Miter Handle w/Fender Washer 10mm ...... 1
AD. Miter Gauge Fence ................................. 1
AE. Miter Gauge Body .................................... 1
AF. Miter Guide Bar ...................................... 1

Inventory Item (Figure 11): Qty
AG. Sliding Table .......................................... 1
AH. Sliding Table Support Legs ..................... 2
AI. Feet M12-1.75 x 75 w/Nuts .................... 2

Inventory Item (Figure 12): Qty
AJ. Crosscut Brace Knobs M8-1.25 x 50 ....... 2
—Flat Washers 8mm .................................... 2
—Square Nuts M8-1.25 ............................... 2
AK. Crosscut Fence Knob M8-1.25 ................. 1
—Flat Washer 8mm ...................................... 1
—Crosscut Fence T-Stud M8-1.25 x 60 ....... 1
AL. Crosscut Fence Lock Knob M8-1.25 x 25 ... 1
—Square Nut M8-1.25 ................................. 1
AM. Pivot Stud .............................................. 1
—Special Washer 8 x 20mm ........................ 1
—Square Nut M8-1.25 ................................. 1

AN. Push Handle M12-1.75 x 14 .................... 1
—Flat Washer 12mm ................................... 1
—Plastic Washer 12mm .............................. 1
—Push Handle T-Nut M12-1.75 ..................... 1
AO. Support Leg T-Slot Plates ...................... 2
AP. Sliding Table T-Studs M12-1.75 x 35 ....... 2
—Flat Washers 12mm ................................. 2
—Lock Washers 12mm ............................... 2
—Hex Nuts M12-1.75 ................................. 2

Other Hardware (not shown) Qty
Cap Screws M10-1.5 x 25 (Extension Tables) .. 5
Flat Washers 10mm (Extension Tables) ........ 5
Lock Washers 10mm (Extension Tables) ........ 5
Set Screws M8-1.25 x 25 (Extension Tables) .. 5
Hex Nuts M8-1.25 (Extension Tables) ............ 5
Hex Bolts M6-1 x 16 (Fence Scale) ............... 2
Hex Bolt M6-1 x 25 (Fence Scale) ................. 1
Flat Washers 6mm (Fence Scale) .................. 3
Lock Washers 6mm (Fence Scale) ................. 3
Hex Nuts M6-1 (Fence Scale) ....................... 3
Cap Screws M6-1 x 16 (CT Support Leg) ....... 4
Lock Washers 6mm (CT Support Leg) ............ 4
Flat Washers 6mm (CT Support Leg) ............ 4
Button Head Screws M5-.8 x 25 (Switch) ...... 2
Flange Nuts M5-.8 (Switch) ......................... 2
Cap Screws M8-1.25 x 20 (ST Leg Plates) ...... 4
Lock Washers 8mm (ST Leg Plates) .............. 4
Lock Nut M10-1.5 (Hose Support) ............... 1
Lock Washer 10mm (Hose Support) .............. 1
Cap Screw M10-1.5 x 25 (Hose Support) ..... 1
Flat Washers 10mm (Hose Support) ............. 2
Button Head Cap Screws M6-1 x 16 (ST Handle) ....... 2
Lock Washers 6mm (ST Handle) ................. 2
Flat Washers 6mm (ST Handle) ................... 4
Hex Nuts M6-1 (ST Handle) ....................... 2
Hardware Recognition Chart

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

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- 5mm
- 5/16"
- 3/8"
- 7/16"
- 1/2"
- 1/4"
- 1/8"

LINES ARE 1MM APART

LINES ARE 1/8" INCH APART

WASHERS ARE MEASURED BY THE INSIDE DIAMETER

- 1/4"
- 5/32"
- 3/32"
- 7/32"
- 1/8"
- 3/16"
- 1/4"
- 5/32"
- 3/32"
- 7/32"
- 1/8"
- 3/16"
- 1/4"
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/detergent (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/detergent, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/detergent is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat Steps 2–3 as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

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

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

**NOTICE**
Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from your machine during clean up.

Figure 13. 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.

**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.

**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.**

**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.

---

**CAUTION**
Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

**Figure 14.** Minimum working clearances.

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Model G0623X/G0623X3 (Mfd. Since 09/17)
Moving & Placing Table Saw Cabinet

We strongly recommend using a forklift to move this saw. This will greatly reduce the risk of a lifting injury. If a forklift is not available, a minimum of four strong people are required to move the saw off the pallet. The saw can be "walked" off the pallet, then moved into place with a dolly or by sliding it.

**WARNING**

This machine and its components are heavy. Serious injury may occur if safe moving methods are not followed.

Get help when lifting or moving the machine and its components. Use a forklift to reduce the risk of a lifting strain or crushing injury.

To lift and move the machine:

1. Feed lifting straps around lifting bolts on back of table and sliding table saw mounts on front of cabinet (see Figure 15). Attach the ends of lifting straps to forklift forks

**WARNING**

DO NOT lift the table saw any higher than necessary to clear the floor. Serious personal injury and damage to the machine may occur if safe moving methods are not followed.

2. Lift table saw cabinet and move it to your predetermined location.

3. Remove red lifting bolts from back of table.

4. Place a level on cast-iron table to level table saw cabinet side to side and front to back. This will allow table to slide smoothly.

**Note:** There are three options for leveling the saw: 1) Place it on a mobile base (Grizzly Model G7315Z) and use the mobile base controls to level it, 2) shim under the cabinet, and 3) thread bolts down into the nuts welded on the stand corners (Figure 16).

**Figure 16.** Hex bolt in stand corners for leveling; the hex nut is used to secure bolt position.

**NOTICE**

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

Before shipping, the sliding table was installed on the machine and calibrated to the main table and blade. When the sliding table was removed for shipping, the lock nuts on the sliding table mounting brackets were carefully left in position to make re-installation easier. As such, be careful not to move any pre-installed nuts when installing the sliding table.

The sliding table and extension tables are heavy so you must get help lifting and holding them during the installation process. We recommend using a forklift or four strong helpers to lift the sliding table during installation.

To assemble the sliding table saw:

1. Place sliding table on cabinet.

2. On each side of sliding table, slide a T-stud down the center bottom T-slot until it is next to mounting bracket.

3. Lift one side of sliding table, position T-stud over hole in mounting bracket, then lower sliding table so T-stud fits through hole, as shown in Figure 17. Repeat on other side.

4. Put 12mm flat washer, lock washer and hex nut onto bottom of each T-stud and tighten hex nut to secure sliding table in place.

5. Install small extension table with two M10-1.5 x 25 cap screws, flat washers and lock washers (see Figure 18).

6. Thread one M8-1.25 hex nut halfway onto each M8-1.25 x 25 set screw, then thread two set screws where shown in Figure 18, to act as leveling set screws in a later step.

7. Install large extension table with three M10-1.5 x 25 cap screws, flat washers, and lock washers (see Figure 19).

8. Thread three M8-1.25 x 25 set screws with hex nuts where shown in Figure 19, to act as leveling set screws in a later step.
9. Level top of extension tables even with top of cast-iron table.

Using straightedg as a guide (Figure 20), adjust leveling cap screws to align top of extension tables with top of cast-iron table. Tighten hex nuts on leveling cap screws against extension table to lock cap screws when tables are aligned.

Figure 20. Extension wings mounted and even with cast-iron table.

10. Mount rip fence scale to large extension table and cast-iron table (Figure 21) using three 6mm hex nuts, lock washers, flat washers, two M6-1 x 16 hex bolts, and one M6-1 x 25 hex bolt. (The longer hex bolt is used in the cast-iron table.) Secure scale height so it is even with table tops.

11. Mount rip fence rail as shown in Figure 22. Make sure black tab is toward back end of saw. Adjust hex nuts so gap between rail and tables is even, but leave rail slightly loose for now.

Figure 22. Rip fence rail mounting.

12. Slide rip fence base on rail, and check spacing between rip fence base and scale bar (see Figure 23). There should be a minimum of \( \frac{1}{8} \)" between scale bar and fence base. Adjust mounting position of rip fence rail to create this space evenly along length of scale bar, then tighten rail mounting nuts.

Figure 23. Fence base installed; spacing between fence base and scale bar.
Note: The fence should slide smoothly on the rail; if it doesn’t, remove the fence base and adjust the spring pressure plate mounting position on the fence base (see Figure 24).

15. Place 12mm flat washer on crosscut table lock lever, then insert it through crosscut fence and thread M12-1.75 T-nut onto end approximately two turns.

16. Align T-nuts on crosscut table with T-slot in face of sliding table, then slide crosscut table into position on sliding table (see Figure 26) and tighten crosscut table lock lever.

17. Place crosscut table support leg on extension arm, and attach it to crosscut table with four M6-1 x 16 cap screws, 6mm lock washers, and 6mm flat washers (see Figure 27).

---

Figure 24. Location of spring pressure plate for fence slide adjustments.

Figure 25. Rip fence installed on fence base.

Figure 26. Crosscut table installation.

Figure 27. Support leg installed.
18. Insert two crosscut brace knobs with 8mm flat washers through crosscut table, then thread square nuts onto ends of knob threads (Figure 28, A). Slide T-slot in support bar over both T-nuts, and tighten knobs (Figure 28, B).

![Figure 28. Installing support bar on crosscut table.](Image)

19. Slide pivot stud assembly and M8-1.25 x 60 T-bolt into crosscut fence T-slot, as shown in Figure 29.

![Figure 29. Pivot stud and T-bolt installed in crosscut fence.](Image)

20. Align T-bolt and pivot stud with crosscut table insertion points (see Figure 29), and install fence on table.

21. Thread M8-1.25 knob with an 8mm flat washer onto bottom of T-bolt from underside of table.

22. Hold crosscut fence against positive stop bolt, shown in Figure 30, then tighten knob underneath crosscut table to lock crosscut fence in position.

**Note:** This positive stop bolt can be finetuned later to ensure that the crosscut fence is square to the blade.

![Figure 30. Use positive stop bolt to position the crosscut fence.](Image)

23. Install flip stops in T-slot on crosscut fence, as shown in Figure 31, and use crosscut fence lock knob to secure extendable end of fence in position.

![Figure 31. Flip stops installed on crosscut fence.](Image)
24. Remove shipping brace from sliding table (see Figure 32), then install sliding table end cover over fixed part of sliding table end, as shown in Figure 33, using premounted hardware.

25. Attach sliding table handle, as shown in Figure 34, with two button head screws and flat washers, using premounted hardware.

26. Verify that two M5-8 x 25 button head screws are threaded tightly into magnetic switch mounting bracket. Loosen two attached M5-8 flange nuts for clearance if needed, then slide mounting bracket and switch into sliding table base T-slot.

27. Adjust switch location, then tighten M5-8 flange nuts to secure (see Figure 35).

28. Thread feet fully into bottom of support legs. DO NOT remove hex nuts pre-installed on bottom of feet. They will be used to secure feet after legs are installed.

29. Thread two M8-1.25 x 20 cap screws and 8mm lock washers through each support leg and part way into T-slot plates for legs, slide T-slot plates into both ends of sliding table base, and tighten cap screws (see Figure 36).
30. Adjust feet downward so they press against floor, then tighten hex nuts up against support leg so feet are locked in place.

31. Open cabinet door and remove motor shipping brace shown in Figure 37.

![Figure 37. Motor shipping brace.](image)

32. Tilt blade assembly to 0˚, then slide sliding table forward all the way until you can open lower blade guard cover and access blade arbors.

33. Insert arbor lock tool into hole shown in Figure 38, rotate arbor until arbor lock tool seats, then install main blade, using included arbor wrench. There MUST be an arbor flange on both sides of blade.

![Figure 38. Installing main blade.](image)

34. Insert arbor lock tool into hole shown in Figure 39, rotate arbor until arbor lock tool seats, then install scoring blade, using arbor wrench. There MUST be an arbor flange on both sides of blade.

![Figure 39. Installing scoring blade.](image)

35. Install splitter/riving knife as shown in Figure 40, but do not tighten mounting bolt yet.

![Figure 40. Installing splitter/riving knife.](image)

36. Adjust splitter/riving knife approximately ⅛" away from main blade, using a ⅛" or 3mm hex wrench as guide (see Figure 41).

![Figure 41. Adjusting the riving knife spacing.](image)
37. Use straightedge to make sure splitter/riving knife and scoring blade are aligned with main blade. Alignment should be with blade bodies, not the carbide teeth.

—Splitter/riving knife position can be changed by adjusting set screws at splitter/riving knife mounting block. Refer to Page 75 for more details.

—Scoring blade alignment can be changed by adjusting set screws accessible through table top (see Figure 42).

38. Install blade guard on splitter/riving knife, as shown in Figure 43, with M10-1.5 x 25 cap screw and M10-1.5 lock nut shipped in blade guard assembly. (Blade guard/dust hood MUST be installed.)

39. Assemble miter gauge and push handle as shown in Figure 44.

Figure 42. Access holes for scoring blade adjustment controls.

Figure 43. Blade guard installed.

Figure 44. Miter gauge and push handle installed.
40. Attach hose support to large extension table as shown in Figure 45.

**Figure 45. Attaching hose support to large extension table.**

41. Secure 4" dust hose to dust port located under saw table and 2½" dust hose to blade guard (see Figure 46).

**Figure 46. Dust hoses attached.**

42. Run 2½" hose over hose support, as shown in Figure 47.

**Figure 47. Dust hose placement on hose support.**

**CAUTION**

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

Minimum CFM at 5" Dust Port: 625 CFM
Minimum CFM at 2½" Dust Port: 150 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.

**Tip:** Connect saw to a single dust collection branch line, using optional accessory shown in Figure 48.

**Figure 48. Optional accessories for consolidating dust lines.**
Power Connection

Before the machine can be connected to the power source, an electrical circuit must be made available that meets the minimum specifications given in Circuit Requirements on Page 14. If a power circuit has not been prepared for the machine, do that now. To ensure a safe and code-compliant setup, we strongly recommend that all electrical work be done by an electrician or qualified service personnel.

G0623X/G0623X3 230V/220V Power Connection

Insert the plug into a matching NEMA receptacle, (see Figure 2 for G0623X and Figure 3 for G0623X3 on Page 14).

G0623X3 440V Power Connection

Hardwire setups require power supply lines to be enclosed inside conduit, which is securely mounted and constructed in adherence to applicable electrical codes.

A hardwire setup for this machine must be equipped with a locking disconnect switch as a means to disconnect the power during adjustments or maintenance, which is a typical requirement for lock-out/tag-out safety programs (commonly required by OSHA).

Figure 4 on Page 15 shows a simple diagram of a hardwire setup with a locking disconnect switch between the power source and the machine. Due to the complexity required for planning, bending, and installing the conduit necessary for a hardwire setup, this type of setup should only be performed by an experienced electrician.

To connect the Model G0623X/G0623X3 to power:

1. Open power connection box shown in Figure 49.

   
   ![](figure49.png)
   
   Figure 49. Power connection box.

2. Loosen strain relief on bottom of connection box, then insert incoming power wires into connection box.

3. G0623X: Connect incoming power wires and ground wire to wires in connection box using wire nuts, (see Figure 50), then wrap each wire nut and their respective wires with electrical tape to secure them together.

   
   ![](figure50.png)
   
   Figure 50. Model G0623X incoming power wires connected.
After the machine has been connected to the power source, the machine MUST be test run to make sure all the controls and safety components function properly before the machine is placed into regular operation.

It is extremely important that all steps in this section be followed very closely, in the order given, to ensure that the safety features are tested correctly.

Before beginning the test run, review the power controls shown in Figure 52 and Identification on Page 3.

**WARNING**

If the machine does not operate as stated in this section, review the Troubleshooting section on Page 68. If you need additional help, call Tech Support at (570) 546-9663. DO NOT place a machine into regular operation if you suspect that it is malfunctioning, or serious injury could occur.
To test run the saw:

1. Put on safety glasses, make sure any bystanders are out of the way, and that all tools have been removed from saw.

2. Push in, then rotate both STOP buttons clockwise until they pop out. This resets switch so machine can be started.

3. Press ON button. Blades should start up and run smoothly without any problems. If any problems occur, immediately press the STOP button.

4. Press STOP button. As main blade comes to a stop, watch the direction that it spins.
   - The main blade should spin clockwise if you are standing at the front of the machine. If this is true, continue to Step 5.
   - If the main blade rotates counterclockwise, disconnect the saw from power and exchange wires R & T in the power connection box to change the motor direction (Model G0623X3 only). After exchanging the wires and closing the power connection box, connect the saw to power, and repeat Steps 3–4.

5. Make sure STOP button is pushed in, then press ON button.
   - The saw should NOT start if the disabling feature on the STOP button is working correctly. If this is true, continue to Step 6.
   - If the saw DOES start when the STOP button is pushed in, then the safety feature on the STOP button is not working correctly. Call Tech Support for advice before proceeding any further with the test run or machine operations.

6. DISCONNECT SAW FROM POWER!

7. Move sliding table all the way forward, then open orange blade guard (refer to Page 42 for details on accessing and opening blade guard). Opening blade guard triggers limit switch.

8. Connect saw to power source and rotate STOP button clockwise so it pops out.

9. (During this step, be prepared to immediately press STOP button if blades start operating.) Press ON button.
   - If the blade guard limit switch functions correctly, the machine will not start. If this is true, continue to Step 10.
   - If the machine starts during this test, the limit switch is NOT functioning correctly. Disconnect the saw from power, and call Tech Support for advice before proceeding any further with the test run or machine operations.

10. Close orange blade guard and move sliding table back to center of machine.
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 a typical operation, so the 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, read "how to" books, and seek additional training from experienced machine operators.

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

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the blade tilt, if necessary, to the correct angle of the desired cut.
3. Adjusts the blade height approximately 1⁄4" higher than the thickness of the workpiece.
4. Adjusts the fence to the desired width of cut then locks it in place.
5. Checks the outfeed side of the machine for proper support and to make sure the workpiece can safely pass all the way through the blade without interference.
6. Puts on safety glasses and a respirator, and locates push sticks if needed.
7. Starts the saw.
8. Feeds the workpiece all the way through the blade while maintaining firm pressure on the workpiece against the table and fence, and keeping hands and fingers out of the blade path and away from the blade.
9. Stops the machine immediately after the cut is complete.
Workpiece Inspection

Some workpieces are not safe to cut on this machine or may need to be modified before they can be safely 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 motor bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw greatly increases the risk of injury and damage to the saw or blade.

- **Foreign Objects:** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can’t be removed, DO NOT cut the workpiece.

- **Large/Loose Knots:** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- **Wet or “Green” Stock:** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.

- **Excessive Warping:** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and may move unpredictably when being cut.

- **Minor Warping:** Slightly cupped workpieces can be safely supported with cupped side facing the table or fence; however, workpieces supported on the bowed side will rock.

Non-Through & Through Cuts

Non-Through Cuts

A non-through cut is a sawing operation where the blade does not protrude above the top face of the wood stock, as shown in the Figure below.

![Figure 53. Example of a non-through cut.](image)

Examples of non-through cuts include dadoes and rabbets. Non-through cuts have a higher risk of injury from kickback because the blade guard must be removed. However, the riving knife MUST be installed because it still provides some protection.

**IMPORTANT:** When making non-through cuts with a dado blade, do not attempt to cut the full depth in one pass. Instead, take multiple light passes to reduce the load on the blade.

Through Cuts

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

![Figure 54. Example of a through cut (blade guard not shown for illustrative clarity).](image)
Blade Guard & Splitter/Riving Knife

The term "blade guard" refers to the assembly that consists of the guard and splitter/riving knife assembly (see Figure 55 below). Each of these components have important safety functions.

![Guard & Splitter/Riving Knife](image)

Figure 55. Blade guard assembly components.

Understanding the Blade Guard

The guard encloses the top of the blade to reduce the risk of accidental blade contact and contain flying chips or dust.

The guard is designed to lift as the workpiece is pushed into the blade, remain in contact with the workpiece during the cut, then return to a resting position against the table when the cut is complete. When installed and properly maintained, the guard is an excellent tool for reducing the risk of injury when operating the table saw.

To ensure that the guard does its job effectively, it MUST be installed and adjusted so that it moves up and down properly to accommodate workpieces and maintain coverage over the blade.

Understanding Splitter/Riving Knife

The splitter/riving knife is a metal plate that prevents the freshly cut pieces of the workpiece from pinching the backside of the blade and causing a kickback. It also acts as a barrier behind the blade to shield hands from being pulled into the blade if a kickback occurs and the operator is reaching behind the blade. (Reaching behind the blade is a major safety risk and should not be done).

⚠️ WARNING

To ensure that the splitter/riving knife works safely, it MUST be aligned with and correctly adjusted to the blade.

When to Use the Blade Guard

The blade guard MUST be installed on the saw for all normal through cuts (defined on owner's manual Page 36).

Sometimes the blade guard or its components can get in the way when cutting very narrow workpieces or other specialized cuts. Because the blade guard is provided to decrease your risk of injury, it should not be used if it gets in the way of making a safe cut. Use good judgment!

In general, the blade guard MUST remain installed on the saw—unless a specific operation requires its removal. If the blade guard is removed for specific operations, always immediately replace it after those operations are complete.

When to Use Riving Knife Only

Use the splitter/riving knife without the blade guard for any non-through cuts (defined on owner's manual Page 36) or narrow/specialized cuts in which the blade guard gets in the way of a safe cut.

Always immediately replace the blade guard when these cuts are complete!

When Not to Use Riving Knife

If you use a dado blade that has a diameter smaller than 10", the splitter/riving knife will be taller than the top of the blade, which will prevent the cut from being completed. In this case, the only way to complete the cut is to remove the splitter/riving knife.
Blade Guard Installation & Removal

The blade guard fits over the splitter/riving knife and is secured in place with an M10-1.5 x 25 cap screw and an M10-1.5 lock nut (see "Mounting Screw" in Figure 56). These are the only fasteners that need to be installed/removed when installing or removing the blade guard.

When installing the blade guard, the mounting screw and lock nut must be left loose enough that the guard can freely pivot up and down, but not so loose that there is side-to-side play when pivoting.

Testing Guard for Correct Operation

After installing the blade guard, you must verify that it functions correctly before making a cut. To test the blade guard operation, lift up the front end about 4" then release it.

- If the blade guard freely drops down against the table surface, then it is functioning correctly and is ready for operation.
- If the blade guard remains in the position where you released it, or it does not drop down against the surface of the table, then the mounting screw and lock nut are too tight. Loosen it slightly and repeat this test until the guard functions correctly.
- If the blade guard feels loose and easily moves back and forth as you raise it, then the mounting screw and lock nut are too loose. Tighten it slightly and repeat this test until the guard functions correctly.

For Your Own Safety Read Instruction Manual Before Operating Saw

a) Wear eye protection.
b) Use saw-blade guard and spreader for every operation for which it can be used, including all through sawing.

WARNING

c) Keep hands out of the line of saw blade.
d) Use a push-stick when required.
e) Pay particular attention to instructions on reducing risk of kickback.

f) Do not perform any operation freehand.
g) Never reach around or over saw blade.
**Splitter/Riving Knife Installation & Removal**

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

The splitter/riving knife attaches to the mounting block as shown in Figure 57. Always firmly tighten the hex nut when securing the splitter/riving knife in place.

![Figure 57. Installing splitter/riving knife on mounting block.](image)

Secure the splitter/riving knife so that the top of it is 1–5mm below the top level of the blade, as shown in Figure 58.

![Figure 58. Height difference between splitter/riving knife and blade.](image)

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

The splitter/riving knife also prevents the freshly cut sides of the workpiece from pinching the blade and causing kickback. For maximum effectiveness of this safety design, the splitter/riving knife must be positioned within 3–8mm from the blade, as shown in Figure 59.

![Figure 59. Allowable top and bottom distances between splitter/riving knife and blade.](image)

Once the splitter/riving knife is properly positioned at the correct distance from the blade, verify that it is aligned with the blade by checking the alignment with a straightedge in the top and bottom locations shown in Figure 60.

![Figure 60. Checking top and bottom splitter/riving knife alignment with blade.](image)

The splitter/riving knife should be parallel with the blade along its length at both positions and should be in the "Alignment Zone" shown in Figure 61.

![Figure 61. Verifying that splitter/riving knife is in the alignment zone behind the blade.](image)

If the splitter/riving knife is not aligned or parallel with the blade, refer to **Splitter/Riving Knife Mounting Block** on Page 75.
Safety Tips

Your safety is important. The tips below are intended to supplement SECTION 1: SAFETY. But remember, no safety list can cover every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

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

- Stand to the left of the blade line-of-cut when performing a cutting operation.
- Turn OFF the saw and allow the blade to come to a complete stop before removing cut-off pieces.
- Make sure that the splitter/riving knife is always aligned with the main blade before cutting!
- Always position the blade guard to the correct height above the workpiece.
- Carefully plan each cutting operation to avoid injuries.
- When you release the sliding table lock, make sure that the knob is positioned so that it will not lock the table during a cut.
- Plan your cut to avoid putting your hands near the blade or reaching across the blade.

Blade Requirements

The splitter/riving knife included with this machine is 0.090" (2.3mm) thick and is only designed for 10" diameter blades.

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

Blade Size Requirements:
- Body Thickness: 0.079"–0.090" (2.0mm–2.3mm)
- Kerf (Tooth) Thickness: 0.122"–0.129" (3.1mm–3.3mm)

Blade Selection

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

Ripping Blade Features:
- Best for cutting with the grain
- 20-40 teeth
- Flat-top ground tooth profile
- Large gullets for large chip removal

Figure 62. Ripping blade.
Crosscut blade features:
- Best for cutting across the grain
- 60-80 teeth
- Alternate top bevel tooth profile
- Small hook angle and a shallow gullet

**Figure 63.** Crosscutting blade.

Combination blade features:
- Designed to cut both with and across grain
- 40-50 teeth
- Alternate top bevel and flat, or alternate top bevel and raker tooth profile
- Teeth are arranged in groups
- Gullets are small and shallow (similar to a cross-cut blade), then large and deep (similar to a ripping blade)

**Figure 64.** Combination blade.

Laminate blade features:
- Best for cutting plywood or veneer
- 40-80 teeth
- Triple chip tooth profile
- Very shallow gullet

**Figure 65.** Laminate blade.

**Thin Kerf Blade:** A blade with thinner kerf than a standard blade. Since the spreader/riving knife included with this table saw is sized for standard blades, thin kerf blades cannot be used on this saw unless they meet the Blade Requirements specified in this manual; otherwise, they will increase the risk of kickback.

**Dado Blades**

**Stacked Dado Blade (see below):** Multiple blades are stacked together to control the cutting width. Stacked dado blades are more expensive than wobble blades, but typically produce higher quality results.

**Wobble Dado Blade:** A single blade mounted at a slight angle on an arbor hub. The blade angle is adjustable on the hub, and the width of the dado cut is controlled by the angle setting of the blade.

**Figure 66.** Stacked dado blade.
Changing Main Blade

This saw performs best with high-quality sharp blades. Whenever the blades become dull, replace or have them sharpened.

To change the main blade:

1. DISCONNECT SAW FROM POWER!

2. Move blade tilt to 0° (blade 90° to table) and raise main blade as far as it will go.

3. Move sliding table out of the way to expose lower blade cover that covers blades and splitter/riving knife, as shown in Figure 67.

4. Pull blade cover away from blades to expose mounting assembly. (Blade cover is held closed with a magnet.)

5. Insert arbor lock tool into hole shown in Figure 67, then rotate blade by hand until arbor lock tool seats.

6. Use arbor wrenches to remove arbor nut and arbor flange, as shown in Figure 68, then pull old blade off the arbor. Arbor nut has left-hand threads and loosens by turning clockwise.

7. Install blade as shown in Figure 69, making sure teeth face toward scoring blade. DO NOT overtighten arbor nut.

8. Move blade cover back into its original position next to blades, then center sliding table.

---

**CAUTION**

Before proceeding with the next step, wear gloves to protect your hands while handling and installing the blade.
Changing/Adjusting Scoring Blade

The scoring blade included with the Model G0623X/G0623X3 has wedge shaped teeth. With this style of scoring blade, the kerf thickness is adjusted by changing the height of the scoring blade. Raising the scoring blade higher increases the kerf thickness.

Changing Scoring Blade

1. DISCONNECT SAW FROM POWER!

2. Remove blade guard and move blade tilt to 0° (blade 90° to table).

3. Move sliding table to side and pull blade cover open.

4. Insert arbor lock tool in table, rotate scoring blade to seat arbor lock tool, and use arbor wrenches to remove arbor nut and scoring blade (see Figure 70).

5. Install new scoring blade as shown in Figure 70, tighten arbor nut, and adjust scoring blade alignment and height as necessary.

Adjusting Scoring Blade

1. DISCONNECT SAW FROM POWER!

2. Unlock scoring blade controls by inserting 6mm hex wrench into controls lock hole shown in Figure 71 and turning mechanism inside counterclockwise until loose.

3. Place straightedge across body of main blade (not the teeth) and align body of scoring blade to main blade by turning alignment control (Figure 71) with 6mm hex wrench.

4. Adjust height of scoring blade by turning height control (Figure 71) with a 6mm hex wrench, until exposed portion equals kerf thickness of main blade.

Note: The easiest way to match the scoring blade kerf is by laying a straightedge on the table, and placing it up against the main blade teeth and beyond the scoring blade, then adjusting the scoring blade height until its teeth align with the main blade teeth. Also check on the other side of the blades to verify that the kerf thickness matches and the scoring blade is aligned with the main blade.

5. Tighten controls lock.

6. Move blade cover back into its original position next to blades, then center sliding table.

7. Perform test cut and check for chip out on underside of test piece. If there is chip out, make adjustments necessary to match kerfs.
Rip Cutting

This saw has the capability of rip cutting large panels (Figure 72). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

Figure 72. Rip cutting with typical sliding table.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (Figure 73). Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.

Figure 73. Traditional rip cutting using the miter gauge and rip fence.

Determine which cutting operation will be best suited for the workpiece to be ripped.

- To use the sliding table, read the instructions titled “Rip Cutting w/Sliding Table.”
- To use the machine as a traditional table saw, skip ahead to “Rip Cutting w/Rip Fence.”

Rip Cutting with Sliding Table

1. Install crosscut fence on crosscut table, and rotate it until fence touches 90° stop bolt (Figure 74).

Figure 74. Place crosscut fence against 90° stop bolt.

2. Check to make sure fence is at 90˚ and, if necessary, adjust it as described in Squaring Crosscut Fence to Blade on Page 74.

3. Slide fence so plastic block on end is next to blade teeth—this calibrates scale to zero—then tighten lock knob.

   Note: Avoid cutting the plastic block on the end of the fence.

4. Set flip stop to desired width-of-cut.

5. Position blade guard to correct height for your workpiece.

6. Load workpiece onto table saw. Set up should look similar to Figure 72.

7. Take all necessary safety precautions, then perform cutting operation.
Rip Cutting with Rip Fence

1. Slide crosscut table out of the way.

2. Lock sliding table into a stationary position (see Figure 75).

   Note: The table will only lock in place when it is centered with the saw cabinet.

3. Place fence in vertical position for larger workpieces, or in horizontal position for angled cuts and for small workpieces (see Figure 76).

4. Slide leading end of rip fence so it is even with center of main saw blade as shown in Figure 77.

   Note: This technique allows the finished cut-off piece to “fall” away from the blade when the cutting operation is complete; reducing the possibility of kickback.

5. Tighten lock handles (Figure 78) to secure rip fence against base.

6. Pull up lock lever to loosen fence base on rail, position fence at correct distance away from blade (as needed for cut), then push down lock lever to lock fence base in position.

7. Take all necessary safety precautions, then make cut as you would with a traditional table saw.
Crosscutting

The Model G0623X/G0623X3 can crosscut full-size panels with the fence in the forward or rear position, although it is easier to load full-size panels with the crosscut fence mounted in the forward position (see Figure 79).

Additionally, this machine has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge (Figure 81).

Determine which cutting operation will be best suited for the workpiece to be crosscut.

—If you will be crosscutting full-size panels, then skip ahead to Crosscutting Full-Size Panels.

—If you will be crosscutting smaller panels, then skip ahead to Crosscutting Smaller Panels.

—If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to Crosscutting Using Rip Fence as a Cut-Off Gauge.
Crosscutting Full-Size Panels

1. Install crosscut fence in forward mounting location shown in Figure 82 and lock it in place.

2. Check to make sure fence is at 90˚ and adjust it as described in Squaring Crosscut Fence to Blade on Page 74 if necessary.

3. Set either flip stop to desired width-of-cut.

   Note: Extend the crosscut fence slide if the workpiece is more than 74”.

4. Load workpiece onto table saw. Setup should look similar to Figure 80.

5. Once all necessary safety precautions have been taken, perform cutting operation.

Crosscutting Smaller Panels

1. Install crosscut fence in rear mounting points shown in Figure 82 and lock it in place.

2. Check to make sure fence is at 90˚ and adjust it as described in Squaring Crosscut Fence to Blade on Page 74 if necessary.

3. Set either flip stop to desired width-of-cut.

   Note: Extend the crosscut fence slide if the workpiece is more than 74”.

4. Load workpiece onto table saw. Setup should look similar to Figure 79.

5. Once all necessary safety precautions have been taken, perform cutting operation.

Crosscutting Using Rip Fence as a Cut-Off Gauge

1. Install crosscut fence in rear mounting points shown in Figure 82 and lock it in place.

2. Check to make sure fence is at 90˚ and adjust it as described in Squaring Crosscut Fence to Blade on Page 74 if necessary.

3. Position rip fence for desired width.

4. Load workpiece onto table saw. Setup should look similar to Figure 81.

5. Slide leading end of rip fence behind front edge of blade as shown in Figure 83. (This step is critical to reduce the risk of blade binding and kickback.)

6. Take all necessary safety precautions, then perform cutting operation.
Miter Cutting

The crosscut fence allows miter cuts from 0° through 135°. The table mounted miter scale has a resolution of 1°.

To perform a miter cut:

1. Slide crosscut table to front edge of sliding table and lock it in place.

2. Place crosscut fence center stud in left or right stud hole of crosscut table. Fence can be installed as shown in Figure 84 for 90° to 135° cuts, or as shown in Figure 85 for 0° to 90° cuts.

3. Rotate fence to desired angle and lock it in place.

4. Position flip stop according to length of workpiece you want to cut off to the left of the blade.

5. Load workpiece onto table saw. Setup should look similar to Figure 85.

6. Once all necessary safety precautions have been taken, perform cutting operation.

Figure 84. Fence set-up for 90° to 135° cuts.

Figure 85. Example of miter cutting operation.
Dado Cutting

Commonly used in furniture joinery, a dado is a straight channel cut in the face of the workpiece. Dadoes are "non-through" cuts that can be made with a dado blade or a standard saw blade. The Figure below shows a cutaway view of a dado cut being made with a dado blade.

![Figure 86. Example of a dado being cut with a dado blade.](image)

This saw can only accept a dado blade with 5/8" arbor hole and maximum width of 13/16". If you have any doubts or questions about the size of dado blade you want to install, call our Technical Support before proceeding.

In order to install a dado blade, the scoring blade should be removed and a zero-clearance table insert must be made specifically for the dado blade you will install (see Figure 87). Refer to Zero-Clearance Insert on Page 60 for instructions on how to do this.

![Figure 87. Dado blade raised into shop-made zero-clearance table insert.](image)

If you plan on making dadoes at varying widths, we strongly recommend making a zero-clearance table insert for each thickness of dado blade that will be used.

### Installing Dado Blade

1. DISCONNECT SAW FROM POWER!

2. Move sliding table out of the way to expose lower blade cover.

3. Remove standard blade. To loosen arbor nut, insert arbor lock tool that came with saw and turn arbor nut clockwise (it has left-hand threads).

4. Remove spacer block installed on arbor behind standard blade you removed in Step 3. Spacer block is not used when dado blades are installed (see Figure 88).

![Figure 88. Dado blade installed on saw with new zero-clearance table insert.](image)

5. Assemble/adjust dado blade system to desired width of cut, according to dado blade manufacturer’s instructions.

6. Install dado blade on arbor shaft, as shown in Figure 89.

![Figure 89. Installing a dado blade.](image)

**WARNING**

DO NOT make through cuts with a dado blade. Dado blades are only intended for non-through cuts. Failure to heed this warning could result in serious injury.
Cutting Dadoes with a Dado Blade

Because dado blades are much wider than standard blades, they place a greater amount of force against the workpiece when cutting. This additional force increases the risk of kickback, requiring the operator to take additional steps when cutting to keep their injury risk at an acceptable level.

⚠️ WARNING

Dado blades have a higher risk of kickback than normal blades because their larger size applies stronger forces to the workpiece. This risk increases relative to the depth and width of the cut. To minimize your risk of serious personal injury, ensure that stock is flat and straight, and make multiple light cuts (rather than one deep cut) to achieve the desired cutting depth.

The Figure below demonstrates the sequential process of making multiple, light cuts that get progressively deeper. The actual number of cuts used should be determined by workpiece hardness, total dado depth, and feed rate. In general, if you hear the motor slow down during the cut, you are cutting too deep or feeding too fast.

Cutting Dadoes with a Standard Blade

A ripping blade is typically the best blade to use for cutting dadoes when using a standard blade because it removes sawdust very efficiently. See Page 44 for blade details.

To use a standard saw blade to cut dadoes:

1. DISCONNECT SAW FROM POWER!

2. Mark width of dado cut on workpiece. Include marks on edge of workpiece so cut path can be aligned when workpiece is lying on table.

3. Raise blade up to desired depth of cut (depth of dado channel desired).

4. Set saw up for type of cut you need to make, depending on if it is a rip cut (Page 44) or crosscut (Page 46).

5. Align blade to cut one of the dado sides, as shown in Figure 91.

Figure 90. Example of dado being cut with multiple light cuts, instead of one deep cut.

Figure 91. First cut for a single-blade dado.
6. Reconnect saw to power source and turn saw **ON**. Allow blade to reach full speed, then perform cutting operation.

7. Repeat cutting operation on other side of dado channel, as in **Figure 92**.

8. Make additional cuts in center of dado to clear out necessary material. The dado is complete when channel is completely cleared out.

---

**Rabbet Cutting**

Commonly used in furniture joinery, a rabbet is an L-shaped groove cut in the edge of the workpiece. Rabbets can be cut with either a dado blade or a standard saw blade.

Rabbet cutting on the edge of the workpiece with a dado blade requires a sacrificial fence (**Figure 94**). Make the sacrificial fence the same length as the fence and ¾" thick. Attach it to the fence with screws or clamps, making sure they are all secure and tight. Raise the blade into the sacrificial fence to the height needed.

---

**WARNING**

Dado blades have a higher risk of kickback than normal blades because their larger size applies stronger forces to the workpiece. This risk increases relative to the depth and width of the cut. To minimize your risk of serious personal injury, ensure that stock is flat and straight, and make multiple light cuts (rather than one deep cut) to achieve the desired cutting depth.

---

**CAUTION**

Always use push sticks, featherboards, push paddles and other safety accessories whenever possible to increase safety and control during operations which require that the blade guard to be removed from the saw. ALWAYS replace the blade guard after dadoing is complete.
Cutting Rabbets with a Dado Blade

1. DISCONNECT THE SAW FROM POWER!

2. Adjust dado blade to height needed for rabbeting operation. When cutting deep rabbets, take more than one pass to reduce risk of kickback.

3. Adjust fence and align workpiece to perform cutting operation as shown in Figure 95.

4. Reconnect saw to power source and turn saw ON. When blade has reached full speed, perform test cut with scrap piece of wood.

5. The cut is satisfactory, repeat the cut with the final workpiece.

6. Lay workpiece on its side, as shown in Figure 96, adjust saw blade height to intersect with first cut, and perform second cut to complete the rabbet.

Cutting Rabbets with a Standard Blade

A ripping blade is typically the best blade to use for cutting rabbets when using a standard blade because it removes sawdust very efficiently. (See Page 44 for blade details.) Also, a sacrificial fence is not required when cutting rabbets with a standard blade.

To cut rabbets with the standard blade:

1. DISCONNECT SAW FROM POWER!

2. Mark width of rabbet cut on edge of workpiece, so you can clearly identify intended cut while it is laying flat on saw table.

3. Raise blade up to desired depth of cut (depth of rabbet channel desired).

4. Adjust fence so blade is aligned with inside of your rabbet channel as shown in Figure 96.

5. Reconnect saw to power source and turn saw ON. When blade has reached full speed, perform test cut with scrap piece of wood.

6. If the cut is satisfactory, repeat the cut with the final workpiece.

7. Lay workpiece on its side, as shown in Figure 97, adjust saw blade height to intersect with first cut, and perform second cut to complete the rabbet.
Resawing

**WARNING**

Resawing operations require proper procedures to avoid serious injury. Extra care must be taken to prevent kickback when resawing. Any tilting or movement of the workpiece away from the fence will cause kickback. Be certain that stock is flat and straight. Failure to follow these warnings could result in serious personal injury.

Resawing is the process of cutting a thick piece of stock into one or more thinner pieces. Although resawing can be done with a table saw, we strongly recommend that you use a bandsaw instead.

A bandsaw is the ideal machine for resawing, and resawing with one is fairly easy and safe. A table saw is not intended for resawing, and resawing with one is difficult and dangerous due to the increased risk of kickback from binding and deep cuts, and the increased risk of injury from having to remove the guard.

If you insist on resawing with a table saw, DO NOT do so without using a resaw barrier and wearing a full face shield. The following instructions describe how to build a resaw barrier that can be used with the rip fence when resawing to reduce the risk injury.

**Note:** To determine the maximum resawing height for this table saw, find the maximum blade height, then double it and subtract ⅛".

**Tools Needed:**

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table Saw</td>
<td>1</td>
</tr>
<tr>
<td>Jointer and Planer</td>
<td></td>
</tr>
<tr>
<td>Clamps</td>
<td>2</td>
</tr>
<tr>
<td>Drill and Drill Bits</td>
<td></td>
</tr>
</tbody>
</table>

**Components Needed for Resaw Barrier:**

- Wood* ¾" x 5 ½" x Length of Fence
- Wood* ¾" x 3" x Length of Fence
- Wood Screws #8 x 2"
- Wood Glue

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

**Making Resaw Barrier**

The resaw barrier acts in tandem with the rip fence when resawing to provide tall support for the workpiece to minimize the probability of it binding against the blade and causing kickback.

**To build the resaw barrier:**

1. Cut your wood pieces to size specified above. If you are using hardwood, cut pieces oversize, then joint and plane them to correct size to make sure they are square and flat.

2. Pre-drill and countersink four holes approximately ⅛" from bottom of 5 ½" tall wood piece.

3. Glue end of 3" board, then clamp boards at a 90° angle with larger board in vertical position, as shown in **Figure 98**, fasten together with wood screws.

![Figure 98. Resaw barrier.](image-url)
Resawing Operations
The table saw motor is pushed to its limits when resawing. If the motor starts to bog down, slow down your feed rate. Motor overloading and blade wear can be reduced by using a ripping blade. Ripping blades are designed to clear the sawdust quickly.

Components Needed for Resawing:
Zero-clearance Insert ........................................... 1
Ripping Blade 10" .............................................. 1
Clamps ............................................................... 2
Shop Made Auxiliary Fence ............................... 1
Shop Made Resaw Barrier ................................. 1

To perform resawing operations:

1. DISCONNECT SAW FROM POWER!
2. Install rip fence in vertical position.
3. Place workpiece against rip fence and slide resaw barrier against workpiece. Now clamp resaw barrier to top of the table saw (see Figure 98).
4. Lower blade completely below table, and slide workpiece over blade to make sure it moves smoothly and fits between resaw barrier and fence.
5. Raise blade approximately 1", or close to half the height of workpiece, whichever is less.

WARNING
You may experience kickback during this procedure. Stand to the side of the blade path and wear safety glasses or a face shield to prevent injury.

Operations requiring the blade guard to be removed increase the risk of accidental contact with the blade. To reduce this risk, use push sticks/paddles and featherboards to keep your hands at a safe distance from the blade throughout the entire cut. Always replace guard after completing the cut!

6. Connect power to saw, turn it ON, and use push stick to feed workpiece through cut using a slow, steady feed rate.
7. Flip workpiece end for end, keeping same side against fence, and cut other side of workpiece.
8. Repeat Steps 4–6 until blade is close to half of the height of the board to be resawn. The ideal completed resaw cut will leave a 1⁄8" connection when resawing is complete as shown in Figure 100. Leaving a 1⁄8" connection will reduce risk of kickback.

Figure 99. Resaw setup with barrier.

Figure 100. Ideal completed resaw cut.

9. Turn OFF table saw, then separate parts of workpiece and hand plane remaining ridge.
10. When finished resawing, remove resaw barrier and re-install blade guard/splitter.
SECTION 5: SHOP-MADE SAFETY ACCESSORIES

Featherboards

Easily made from scrap stock, featherboards provide an added degree of protection against kickback, especially when used together with push sticks. They also maintain pressure on the workpiece to keep it against the fence or table while cutting, which makes the operation easier and safer because the cut can be completed without the operator’s hands getting near the blade. The angled ends and flexibility of the fingers allow the workpiece to move in only one direction.

Making a Featherboard

This sub-section covers the two basic types of featherboards: 1) Those secured by clamps to the table or fence, or 2) those secured by a wood runner that mounts in the table saw miter slot.

Material Needed for Featherboard Mounted with Clamps

Hardwood ¾" x 3" x 10" (Minimum)..........................1
Hardwood ¾" x 6" x 28" (Maximum)......................1

Material Needed for Featherboard Mounted in Miter Slot

Hardwood ¾" x 3" x 10" (Minimum)..........................1
Hardwood ¾" x 6" x 28" (Maximum)......................1
Hardwood ¾" x (Miter Slot Width) x 5"L ...........1
Wing Nut ¼"-20......................................................1
Flat Head Screw ¼"-20 x 2".................................1
Flat Washer ¼"-20..................................................1

To make a featherboard:

1. Cut hardwood board approximately ¾" thick to size. Length and width of board can vary according to your design. Most featherboards are 10"–28" long and 3"–6" wide. Make sure wood grain runs parallel with length of featherboard, so the fingers you will create in Step 3 will bend without breaking.

2. Cut a 30° angle at one end of board.

3. Make a series of end cuts with the grain ¾"–¼" apart and 2"–3" long, as shown in Figure 101 (A). Alternatively, start cuts at 2"-3" deep, then make them progressively deeper, as shown in Figure 101 (B). Cuts made across the grain will result in weak fingers that will easily break.

When complete, the fingers should flex when pushed with moderate pressure. If the fingers do not flex, they are too thick.

Note: We recommend using a bandsaw for making fingers because it tends to be safer. A table saw can be used, but it will over-cut the underside of the ends, produce a thicker kerf, and require you to stop the blade half-way through the cut, which can be dangerous.

If you are securing the featherboard with clamps, no further steps are necessary. Your featherboard is complete! If you are making a featherboard that mounts in the miter slot, continue with Step 4.
4. Rout a 1/4"–3/8" wide slot 4"–5" long in workpiece and 1"–2" from short end of featherboard (see Figure 102).

![Figure 102. Slot routed in featherboard.](image)

5. Cut a miter bar that will fit in table miter slot approximately 5" long (see Figure 103).

**Tip:** Consider making the miter bar longer for larger featherboards—approximately half the length of the total featherboard—to support the force applied to the featherboard during use.

![Figure 103. Miter bar pattern.](image)

6. Drill 1/4" hole in center of bar, then countersink bottom to fit 1/4"-20 flat head screw.

7. Mark 4" line through center of countersunk hole in center, then use jig saw with narrow blade to cut it out.

8. Assemble miter bar and featherboard with 1/4"-20 x flat head screw, flat washer, and wing nut or star knob (see Figure 104). Congratulations! Your featherboard is complete.

![Figure 104. Assembling miter slot featherboard components.](image)

**Tip:** The length of the flat head screw depends on the thickness of the featherboard—though 1 1/2" to 2" lengths usually work.

Now, proceed to Mounting Featherboard in Miter Slot on Page 57.
**Mounting Featherboards w/Clamps**

1. Lower saw blade, then adjust fence to desired width and secure it.

2. Place workpiece against fence, making sure it is 1" in front of the blade.

3. Place featherboard on table away from blade so all fingers point forward and contact workpiece (see Figure 105).

4. Secure featherboard to table with clamp.

5. Check featherboard by pushing it with your thumb to ensure it is secure.

   —If the featherboard moves, tighten the clamp more.

6. Mount second featherboard to fence with another clamp (see Figure 105), then repeat Step 5 to ensure it is secure.

**Mounting Featherboard in Miter Slot**

1. Lower saw blade, then adjust fence to desired width and secure it.

2. Place workpiece evenly against fence, making sure it is 1" in front of blade.

3. Slide featherboard miter bar into miter slot, making sure fingers slant toward blade, as shown in Figure 106.

4. Position fingered edge of featherboard against edge of workpiece, so that all fingers contact workpiece. Slide featherboard toward blade until first finger is nearly even with end of workpiece, which should be 1" away from blade.

5. Double check workpiece and featherboard to ensure they are properly positioned as described in Step 4. Then secure featherboard to table. Check featherboard by hand to make sure it is tight.

**Note:** The featherboard should be placed firmly enough against the workpiece to keep it against the fence but not so tight that it is difficult to feed the workpiece.

---

**Figure 105.** Example of featherboards secured with clamps.

**Figure 106.** Featherboard installed in miter slot and supporting workpiece for ripping cut.
Push Sticks

When used correctly, push sticks reduce the risk of injury by keeping hands away from the blade while cutting. In the event of an accident, a push stick can also absorb damage that would have otherwise happened to hands or fingers.

Using a Push Stick

Use push sticks whenever your hands will get within 12" of the blade. To maintain control when cutting large workpieces, start the cut by feeding with your hands then use push sticks to finish the cut, so your hands are not on the end of the workpiece as it passes through the blade.

Feeding: Place the notched end of the push stick against the end of the workpiece (see inset Figure below), and move the workpiece into the blade with steady downward and forward pressure.

Supporting: A second push stick can be used to keep the workpiece firmly against the fence while cutting. When using a push stick in this manner, only apply pressure before the blade; otherwise, pushing the workpiece against or behind the blade will increase the risk of kickback (see "Push Stick Prohibition Zone" in the Figure below).

Figure 107. Using push sticks to rip narrow stock.

Figure 108. Side view of a push stick in use.

SIZING: Push stick must be at least 15¾" long. Use ½”–¾” thick material.

MATERIAL: Only use hardwood, sturdy plywood, or high-density plastic. Do not use softwood that may break under pressure or metal that can break teeth from the blade!

SANDING: Sand edges to remove rough edges and increase comfort.

Figure 109. Template for a basic shop-made push stick (not shown at actual size).
Push Blocks

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

Using a Push Block

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

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

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

![Figure 111. Using a push block and push stick to make a rip cut.](image)

Making a Push Block

Use this template to make your own push block.

![Figure 112. Template for a shop-made push block (shown at 50% of full size).](image)
Zero-Clearance Insert

A zero-clearance insert can be made for the saw in about 30 minutes, and must be made of 3/4" furniture quality plywood or hardwood. (We recommend making at least 6–12 while you are going through the process, so you have plenty on hand for varying blade widths, heights, or angles.

A zero-clearance insert is required if you want to install a dado blade. When a dado blade is installed, the scoring blade and splitter/riving knife are removed—as neither will properly perform their intended function.

If you plan to use a standard blade with a zero-clearance insert, additional modifications will need to be made in order to install the scoring blade and splitter/riving knife.

**WARNING**

If you must use this saw to cut the dimensions of the zero-clearance insert you will fabricate in these instructions, make sure you DO NOT make any cuts while the included table insert is removed. THIS IS DANGEROUS. You must re-install the table insert, reassemble all saw components, and remove all tools before cutting.

### Items Needed

<table>
<thead>
<tr>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Table Saw</td>
</tr>
<tr>
<td>Drill Press</td>
</tr>
<tr>
<td>Sander</td>
</tr>
<tr>
<td>Drill Bits 7/32&quot; and 13/32&quot;</td>
</tr>
<tr>
<td>Plywood/Hardwood Piece 14&quot; x 1 7/8&quot; x 3/4&quot;</td>
</tr>
<tr>
<td>Bandsaw or Jigsaw (Optional)</td>
</tr>
<tr>
<td>Clamp (Optional)</td>
</tr>
</tbody>
</table>

### To make a zero-clearance table insert:

1. **DISCONNECT SAW FROM POWER**

2. Lower main blade all the way, remove blade guard, splitter/riving knife, and scoring blade. After removing scoring blade, reinstall and tighten scoring blade flanges and arbor nut.

3. Remove main blade and spacer block behind it (see Figure 113).

4. Remove table insert installed on saw.

5. Cut new table insert to exact length of included table insert and 1 1/16" wide.

6. Use included table insert as template, as shown in Figure 114, to mark mounting holes on new table insert. (Clamping pieces together while you do this will allow you to ensure hole spacing is exact.)

7. Use 7/32" drill bit to drill holes completely through new table insert.

8. Install 13/32" drill bit and use included table insert as guide to set depth stop on your drill press to countersink holes.

---

**Figure 113.** Original table insert and all necessary components removed.

**Figure 114.** Marking location for mounting holes in new insert.

Model G0623X/G0623X3 (Mfd. Since 09/17)
9. Countersink holes you drilled in Step 7 (see Figure 115), so heads of mounting screws can be recessed into table insert when installed.

10. Install blade you will use to cut insert, making sure blade flange is used on front of blade behind arbor nut, then lower blade fully.

11. Test fit new table insert in table, then sand corners or trim ends as necessary to get a precise fit.

12. Mount new table insert into table and check to make sure that it is flush with top of table. If necessary, remove insert and sand top of it down until it will mount up flush with table top (see Figure 116).

13. (This step only for standard blades.) Use bandsaw or jigsaw to cut slots or notches that will allow riving blade to be installed with minimal open space around it. If you plan to use scoring knife, do the same for that blade. (We do not recommend using the scoring blade to cut the slot in the insert because the adjustment screw is inside the cabinet).

14. Close cover over blade and move sliding table to center of saw.

15. Connect saw to power, start motor, and slowly raise blade into zero-clearance table insert (see Figure 117) only as high as you intend to cut with insert.

16. Outfeed Table

One of the best accessories for improving the safety and ease of using a table saw is simply placing a large table (outfeed table) behind the saw to catch the workpiece.

Figure 118. Example of outfeed table.
SECTION 6: AFTERMARKET ACCESSORIES FROM GRIZZLY

⚠️ WARNING
Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE
Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

10" Blades
H5190—Razor Variable Tooth Carbide 50T
H9146—Heavy-Duty ATB Carbide Tip 60T
G2804—Commercial Solid Surface Blade 60T
H9147—Heavy-Duty ATB Carbide Tip 80T
H9360—Commercial Melamine Blade 80T
H9148—Heavy-Duty ATB Carbide Tip 100T
These blades work especially well for most sliding table saw applications and are manufactured for heavy-duty, industrial use.

T21382—Scoring Blade
Replacement scoring blade. Measures 80mm in diameter with 22mm arbor hole. Blade is a solid, one-piece wedge-type blade. Kerf width is controlled by changing the height of the exposed portion of the blade from the table.

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

Figure 119. T21382 Scoring Blade.

Figure 120. Recommended products for protecting unpainted cast-iron/steel parts on machinery.

T23964—Armor Plate with Moly-D Multi-Purpose Grease, 14.5 oz. (NLGI#2 Equivalent)
Armor Plate with Moly-D is a rich green moly grease that provides excellent stability and unsurpassed performance under a wide range of temperatures and operating conditions. Armor Plate grease is entirely unique due to the fact that the moly in it is solubilized, which provides superior performance to other greases containing the black solid form of molybdenum disulfide.

Figure 121. T23964 Armor Plate with Moly-D Multi-Purpose Grease.
**H8029—5-Piece Safety Kit**
This kit has four essential jigs. Includes two push blocks, push stick, featherboard, and combination saw and router gauge. Featherboard fits 3/8” x 3/4” miter slots. Made of high-visibility yellow plastic.

![Figure 122. H8029 5-Piece Safety Kit.](image)

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

![Figure 123. Half-mask respirator with disposable cartridge filters.](image)

**T20501—Face Shield Crown Protector 4”**
**T20502—Face Shield Crown Protector 7”**
**T20503—Face Shield Window**
**T20451—“Kirova” Clear Safety Glasses**
**T20452—“Kirova” Anti-Reflective S. Glasses**
**H7194—Bifocal Safety Glasses 1.5**
**H7195—Bifocal Safety Glasses 2.0**
**H7196—Bifocal Safety Glasses 2.5**

![Figure 124. Eye protection assortment.](image)

**H4978—Deluxe Earmuffs - 27dB**
**H4979—Twin Cup Hearing Protector - 29dB**
**T20446—Classic Earplugs, 200-pair - 31dB**
Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.

![Figure 125. Hearing protection.](image)
H4753—Duraline HI/A-T, Melamine & Veneer 80T
For chipless cutting of two sided melamine, vinyl, polyester, and kortron. Recommended for thin, low pressure, two-sided laminates and veneer plywood. For thin veneers on flakeboard - fire-retardant, laminated (1 or 2 sides), masonite, fiber board, lumbercore, glue-ups, hard/soft woods and chemically impregnated wood. Arbor bore size is 1" and kerf is 0.125".rolling capacity

Figure 126. 10" 80T Duraline HI-A/T saw blade.

H4758 & H4759—Blade Stiffeners
For smoother, quieter cuts, a single FORREST Dampener-Stiffener is highly recommended for all applications. Made from top-quality saw steel and precision ground to within 0.001" of side runout. Mount one stiffener against the outside of the blade.

Figure 127. H4758 & H4759 Blade Stiffeners for 10" blades.

G2795—10" x 24t Stack Dado Set
Use these high-precision dado heads on wood, prefinished materials, Formica® and other related products. Fits standard 5/8" arbors and width can be varied from 1/8" to 13/16".
Set includes:
(2) 24 Tooth blades
(4) Chippers
(12) Shims: (4) .010" and (8) .020"
Blade carrier

Figure 128. G2795 Stack Dado Set.

H4758 & H4759—Blade Stiffeners
For smoother, quieter cuts, a single FORREST Dampener-Stiffener is highly recommended for all applications. Made from top-quality saw steel and precision ground to within 0.001" of side runout. Mount one stiffener against the outside of the blade.

Figure 127. H4758 & H4759 Blade Stiffeners for 10" blades.

H6290—Scissor Lift Table, 330 lb. Capacity
This rugged and affordable lifting table allows you to lift stacks of sheet goods right up to the saw table with just the power of your leg and the mechanical advantage of a scissor lift. The table features a hand lever release, fold-down handle, two locking swivel casters, and two fixed casters.

Figure 129. H6290 Scissor Lift Table.
D4218—Black Flexible Hose 5" x 10'
D4212—Black Flexible Hose 2½" x 10'
W1318—Wire Hose Clamp 5"
W1314—Wire Hose Clamp 2½"
W1008—Plastic Blast Gate 5"
We've hand picked a selection of commonly used dust collection components for the Model G0764Z.

Figure 130. Recommended dust collection accessories.

T21578—12” Beveled Straight Edges w/ Scale
T21579—24” Beveled Straight Edges w/ Scale
T21580—36” Beveled Straight Edges w/ Scale
These Bevel Straight Edges are made from hardened steel and feature a satin chrome finish and are ground and lapped for straightness and parallelism. Each straightedge offers true right angles for all edges, along with a beveled edge with scale in US standard. Accuracy of 0.001", and a resolution of ¼".

Figure 131. T21578, T21579, and T21580 straightedge.

D2058A—Super Heavy-Duty SHOP FOX® Mobile Base
This patented, super heavy-duty mobile machine base is the strongest mobile base on the market. 18” x 24½” minimum and adjusts to 28½” x 33½” maximum. 1200 lb. capacity. This base is extremely stable with outrigger type supports and a four wheel system. Weighs 38 lbs.

Figure 132. D2058A SHOP FOX® Mobile Base.

D2271—Shop Fox® Roller Table
Use these versatile roller tables wherever you need extra workpiece support. Features all-steel welded construction and measures 19” x 65” long. Comes with 9 ball bearing rollers and has four independently adjustable legs for any leveling requirement. Adjustable in height from 26¾” to 44¾”. Approximate shipping weight: 62 lbs. 1000 Lb. Capacity!

Figure 133. D2271 Shop Fox® Roller Table.
SECTION 7: MAINTENANCE

Cleaning

Cleaning the Model G0623X/G0623X3 is relative-
ly easy. Vacuum excess wood chips and sawdust
from the table saw and inside the cabinet. Wipe
off the remaining dust with a dry cloth.

Use compressed air (make sure to wear safety
glasses and a respirator when doing this) to blow
dust from between the two sections of the sliding
table. If any resin has built up, use a resin dissolv-
ing cleaner to remove it. Treat all unpainted cast
iron and steel with a non-staining lubricant after
cleaning.

Unpainted Cast Iron

Protect the unpainted cast-iron surfaces on the
table by wiping the table clean after every use—
this ensures moisture from wood dust does not
remain on bare metal surfaces. DO NOT clean
cast iron with water or it will rust!

Keep tables rust-free with regular applications of
products like G96® Gun Treatment, SLIPIT®, or
Boeshield® T-9 (see Page 62 for more details).

Schedule

The frequency of maintenance necessary for any
machine will always depend on the operating con-
ditions and environment. The schedule below is a
basic guideline for keeping your machine in prop-
er operating condition. Always repair any adverse
conditions immediately upon discovery.

Daily (Ongoing)
• Loose mounting bolts.
• Worn or damaged saw blades.
• Worn or damaged switches or wires.
• Any other unsafe condition.

Weekly
• Clean sliding table surface and grooves.
• Lubricate the sliding table ways (Page 67).
• Clean the cast iron saw table.
• Clean the sliding table roller guideways.
• Clean the rip fence.
• Clean the rip fence bracket and rail.

Monthly
• Clean/vacuum dust buildup from inside cabi-
et and off motor.
• Check V-belt tension, damage, or wear.

Every 6–12 Months
• Lubricate the trunnions (Page 67).
• Lubricate the elevation and tilt leadscrews
(Please 67).

Note: To ensure optimum power transmission
from the motor to the blades, the V-belts must be
in good condition (free from cracks, fraying and
wear) and operate under proper tension.
Lubrication

Bearsings: The bearings are sealed and pre-lubricated; they require no lubrication.

Trunnions: Use multi-purpose grease in the trunnion grooves (Figure 136) every 6–12 months, depending on the frequency of use. To grease the blade height trunnion, move the blade height all the way down and smear a dab of grease into the trunnion groove, behind the plate shown in Figure 136, then move the blade up all the way, then down all the way to spread the grease.

To grease the blade tilt trunnions, move the sliding table out of the way and open the blade guard. Tilt the blade to 90°. From the front of the saw, smear a dab of grease in the front of the trunnion grooves on both sides. Now, tilt the blade to 45° and reach inside the cabinet and smear a dab of grease into the back of the trunnion grooves on both sides. Tilt the blade back and forth to distribute the grease evenly.

Leadscrews: Use multi-purpose grease on the leadscrews (Figure 136) every 6-12 months, at the same time you lubricate the trunnions. Wipe the leadscrews clean with a dry rag and brush a light coat of new grease on them with a clean, dry brush. Only grease the area of the leadscrew between the stop nuts. Move the blade height and tilt back and forth to distribute the grease evenly.

Sliding Table Ways & Rip Fence Rail: Wipe on a light machine oil (such as Boeshield shown on Page 62) down the entire length of the sliding table steel rods (Figure 135) and rip fence rail.

Figure 135. Sliding table ways.

Figure 136. Lubrication locations (table removed for clarity).
SECTION 8: SERVICE

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

Troubleshooting

### Motor & Electrical

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine does not start or a breaker trips.</td>
<td>1. Stop push-button is engaged/faulty. 2. Power supply switched OFF or is at fault. 3. Motor connection wired incorrectly. 4. Thermal overload relay has tripped. 5. Wall fuse/circuit breaker is blown/tripped. 6. Contactor not getting energized/has burnt contacts. 7. Wiring is open/has high resistance. 8. Motor ON button or ON/OFF switch is at fault. 9. Motor is at fault.</td>
<td>1. Rotate clockwise slightly until it pops out/replace it. 2. Ensure power supply is switched on; ensure power supply has the correct voltage. 3. Correct motor wiring connections. 4. Wait for it to cool down, then it will reset automatically. If necessary, disconnect power and reset manually by pushing reset button inside switch. 5. Ensure circuit size is suitable for this machine; replace weak breaker. 6. Test for power on all legs and contactor operation. Replace unit if faulty. 7. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 8. Replace faulty ON button or ON/OFF switch. 9. Test/repair/replace.</td>
</tr>
<tr>
<td>Machine stalls or is underpowered.</td>
<td>1. Feed rate/cutting speed too fast for task. 2. Workpiece material is not suitable for this machine. 3. Belt(s) slipping. 4. Motor connection is wired incorrectly. 5. Motor bearings are at fault. 6. Start delay module is at fault. 7. Motor is at fault.</td>
<td>1. Decrease feed rate/cutting speed. 2. Only cut wood products; make sure moisture content is below 20% and there are no foreign materials in the workpiece. 3. Replace bad belt(s), align pulleys, and re-tension. 4. Correct motor wiring connections. 5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 6. Adjust to correct delay; replace module. 7. Test/repair/replace.</td>
</tr>
<tr>
<td>Symptom</td>
<td>Possible Cause</td>
<td>Possible Solution</td>
</tr>
<tr>
<td>------------------------------------------------------------------------</td>
<td>----------------------------------</td>
<td>-----------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>Machine has vibration or noisy operation.</td>
<td>1. Motor or component is loose.</td>
<td>1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid.</td>
</tr>
<tr>
<td></td>
<td>2. Blade is at fault.</td>
<td>2. Replace warped, bent, or twisted blade; resharpen dull blade.</td>
</tr>
<tr>
<td></td>
<td>3. Belt(s) worn or loose.</td>
<td>3. Inspect/replace belts (refer to Page 70).</td>
</tr>
<tr>
<td></td>
<td>4. Pulley is loose.</td>
<td>4. Realign/replace shaft, pulley, setscrew, and key as required.</td>
</tr>
<tr>
<td></td>
<td>5. Motor mount loose/broken.</td>
<td>5. Tighten/replace.</td>
</tr>
<tr>
<td></td>
<td>6. Machine is incorrectly mounted or sits unevenly.</td>
<td>6. Tighten/replace anchor studs in floor; relocate/shim machine.</td>
</tr>
<tr>
<td></td>
<td>7. Arbor pulley is loose.</td>
<td>7. Retighten/replace arbor pulley with shaft and thread locking liquid.</td>
</tr>
<tr>
<td></td>
<td>8. Motor fan is rubbing on fan cover.</td>
<td>8. Replace dented fan cover; replace loose/damaged fan.</td>
</tr>
<tr>
<td></td>
<td>9. Arbor bearings are at fault.</td>
<td>9. Replace arbor housing bearings; replace arbor.</td>
</tr>
<tr>
<td></td>
<td>10. Motor bearings are at fault.</td>
<td>10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</td>
</tr>
<tr>
<td>Main blade runs backwards (G0623X3 only).</td>
<td>1. Two of the power wires are reversed (3-phase version only).</td>
<td>1. Exchange wires R &amp; T in the terminal box (3-phase version only).</td>
</tr>
</tbody>
</table>

**Operation**

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Workpiece has burned edges, binds, or kicks back.</td>
<td>1. Sliding table is not parallel to blade.</td>
<td>1. Adjust sliding table parallel with the blade (Page 72).</td>
</tr>
<tr>
<td></td>
<td>2. Riving knife is not aligned with the blade.</td>
<td>2. Adjust the riving knife to align it with the main blade.</td>
</tr>
<tr>
<td></td>
<td>3. Blade is warped.</td>
<td>3. Replace the blade.</td>
</tr>
<tr>
<td>Workpiece has chip out on the bottom edge.</td>
<td>1. Scoring blade height is incorrect.</td>
<td>1. Adjust the height of the scoring blade.</td>
</tr>
<tr>
<td></td>
<td>2. Scoring blade is not aligned with the main blade.</td>
<td>2. Align the scoring blade (Page 43).</td>
</tr>
<tr>
<td></td>
<td>3. Scoring blade kerf does not match the main blade.</td>
<td>3. Adjust the scoring blade kerf (Page 43).</td>
</tr>
<tr>
<td>Cuts are not square.</td>
<td>1. Sliding table is not parallel to blade.</td>
<td>1. Adjust the sliding table (Page 73).</td>
</tr>
<tr>
<td></td>
<td>2. Rip fence is not parallel to blade.</td>
<td>2. Adjust the rip fence parallel to blade.</td>
</tr>
<tr>
<td></td>
<td>3. Crosscut fence is not perpendicular to the blade.</td>
<td>3. Adjust the crosscut fence perpendicular to the blade.</td>
</tr>
<tr>
<td>Fence hits table top when sliding across table.</td>
<td>1. Front rail is too low.</td>
<td>1. Raise the front rail.</td>
</tr>
<tr>
<td></td>
<td>2. Rip fence roller is too low.</td>
<td>2. Adjust the rip fence roller.</td>
</tr>
<tr>
<td>Blade does not reach 90°, or blade does not reach 45°.</td>
<td>2. Blade tilt stop bolts are out of adjustment.</td>
<td>2. Adjust the tilt stop bolts (Page 71).</td>
</tr>
<tr>
<td>The rip fence scale is not accurate.</td>
<td>1. The rip fence scale is out of calibration or was not set up correctly.</td>
<td>1. Adjust the rip fence scale so it is accurately calibrated with the blade.</td>
</tr>
<tr>
<td>Handwheels for blade adjustments will not turn or are difficult to turn.</td>
<td>1. Shipping braces still attached.</td>
<td>1. Remove shipping braces.</td>
</tr>
<tr>
<td></td>
<td>2. Lock knob is tight.</td>
<td>2. Release the lock knob.</td>
</tr>
<tr>
<td></td>
<td>3. Gears caked with dust.</td>
<td>3. Clean out dust and grease the gears.</td>
</tr>
</tbody>
</table>

Model G0623X/G0623X3 (Mfd. Since 09/17)
Belt Replacement

Main Belt Replacement
1. DISCONNECT SAW FROM POWER!

2. Tilt blade to 45° and lower it as far as it will go.

3. Remove motor cabinet door.

4. Loosen pivot bolt and two adjustment bolts (Figure 137).

   Note: DO NOT loosen these bolts more than 1/2” or you run the risk of the motor mount bolts coming out of their holes, which will be difficult to thread back in.

5. Push and hold motor all the way up to relieve tension on belt, remove belts from top pulley, and squeeze them between lower pulley and casting.

6. Fit new belts onto pulleys in same manner that you removed old belts.

7. Push down on motor with one hand, and tighten adjustment and pivot bolts with the other hand or have someone help you. The belts should be tight enough that they only deflect approximately 1/4” when pushed in the center with your thumb or index finger.

8. Replace motor cabinet door.

Scoring Belt Replacement
1. DISCONNECT SAW FROM POWER!

2. Tilt blade to 45° and lower it as far as it will go.

3. Remove motor cabinet door.

4. Pull tensioner away from scoring belt (Figure 138) to relieve belt tension and remove scoring belt from the pulleys.

   Note: Turn the belt sideways to squeeze the flat part through the small gap between the bottom pulley and the casting.

5. Put the scoring belt on pulleys as shown in Figure 139, and push tensioner against scoring belt to take up any slack.

6. Replace motor cabinet door.
Blade Tilt Calibration

The blade tilt is calibrated at the factory, but can be recalibrated if it changes during the life of the machine. The 0° stop positions the blade square with the table.

0° Stop
1. DISCONNECT SAW FROM POWER!
2. Move blade tilt to 0° according to gauge, and raise main blade as far as it will go.
3. Use a machinist's square to check if blade is square to table.
   —If the blade is not square to the table, loosen the two set screws that secure the 0° tilt stop nut shown in Figure 140.
4. Adjust stop nut and recheck blade tilt as many times as necessary until blade is square to table.
5. Tighten two set screws in stop nut.
6. Check blade tilt pointer mechanism to ensure that it points to 0°.
   —If the blade tilt pointer shows an incorrect tilt, adjust it by loosening the cap screws, rotating the pointer until it points to 0°, then tightening the cap screws.

45° Stop
1. DISCONNECT SAW FROM POWER!
2. Adjust blade angle until you hit the 45° positive stop and check blade angle with a 45° square.
   —If the blade is not 45° to the table, loosen the two set screws that secure the 45° tilt stop nut shown in Figure 141. (This nut can also be accessed from the front of the saw by moving the sliding table all the way forward.)
3. Adjust stop nut and recheck blade tilt as many times as necessary until blade is 45° to table.
4. Tighten two set screws in stop nut.

Figure 140. Blade tilt stop nut (0°).

Figure 141. Blade tilt stop nut (45°).
Sliding Table Parallel Adjustment

The table is calibrated at the factory, but can be adjusted slightly if it is not parallel to the blade.

**Tools Needed:**
- Felt Tip Pen
- 90° Square
- Precise Measuring Tool
- Wrench 17mm
- Hex Wrench 5mm

**To adjust the sliding table parallel with the main blade:**

1. **DISCONNECT SAW FROM POWER!**

2. Move blade tilt to 0° (blade 90° to table), and raise main blade up to maximum height.

3. Mark one blade tooth with a felt-tip pen. This will be your reference point when taking measuring points, so you take them in the same location each time.

4. Move sliding table all the way back, and measure distance "A" in **Figure 142**, between marked tooth and edge of miter slot.

5. Rotate blade 180°, move sliding table all the way forward, and measure distance between "B" in **Figure ??**.

6. Note difference between the two positions.
   - If the gap is the same on both sides or the difference is 0.004" or less, no adjustments to the table parallelism need to be made.
   - If the difference is greater than 0.004", then the sliding table parallelism must be adjusted. Proceed to **Step 7**.

7. Loosen sliding table mounting nuts (see **Figure 143**) at both mounting locations.

8. At side of the table that needs to move, loosen hex nut on parallel adjustment bolt.

9. Slowly rotate parallel adjustment bolt (see **Figure 143**) as necessary to move table. If you move adjustment bolt away from table, push table against bolt before proceeding.

10. Tighten hex nut on parallel adjustment bolt to secure it in place, then tighten table mounting nuts. Repeat **Steps 4–6** as necessary until sliding table is parallel with blade.

**Figure 142.** Measuring distance between table and blade.

**Figure 143.** Table parallelism adjustment controls.
Sliding Table Adjustment

The sliding table features an adjustment bar with bolts that control how easily the sliding table moves across the base (see Figure 144). These adjustment bolts are factory set. They can only be accessed by removing the end covers from both ends of the sliding table base and sliding the plastic plate out of the way.

If the adjustment bolts do require adjustments, turning them counterclockwise increases pressure against the steel rails. This reduces table movement slop, which increases accuracy, but makes it harder to slide the table.

Turning the adjustment bolts clockwise decreases the pressure against the steel rails. This increases table movement slop, which reduces accuracy, but makes it easier to slide the table.

Adjusting this part of the sliding table correctly is a matter of trial-and-error by making adjustments, moving the sliding table, then making additional adjustments. Ultimately, the table must move easily without any slop.

Figure 144. Adjustment bolt access location.
Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

To square the crosscut fence with the blade:

1. Make sure blade is parallel with sliding table and that crosscut fence is resting against 90° stop bolt (see Figure 146 for locations).

2. Prepare scrap test piece by cutting it to 32" x 32", then number all four sides of test piece.

3. Use crosscut fence to cut ½" off of each side of test piece, then cut side 1 again (make five cuts total).

4. Measure test piece diagonally from corner-to-corner as shown in Figure 145.

—If both measurements are not within ⅛", then the crosscut fence needs to be adjusted. Proceed to Steps 5–8.

—If both measurements are within ⅛" then no adjustments need to be made. You are finished with this procedure.

5. Loosen knob on crosscut fence to allow it to pivot (make sure 90° stop bolt remains against fence during adjustments).

6. Loosen hex nut on 90° stop bolt shown in Figure 146, and rotate 90° stop bolt to square crosscut fence.

7. Tighten hex nut on 90° stop bolt, then tighten crosscut fence knob, making sure block is touching 90° stop bolt.

8. Repeat Steps 3-4.

Figure 145. Fence adjustment test piece.

Figure 146. Crosscut fence adjustment cam.
Splitter/Riving Knife Mounting Block

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

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

![Mounting Block Diagram](image)

**Figure 147.** Splitter/riving knife mounting block adjustment controls.

All adjustment and alignment positions for the splitter/riving knife are covered on Page 39 in the subsection Splitter/Riving Knife Installation & Removal; the mounting block should not be adjusted unless you have been unable to mount the splitter/riving knife as instructed by these procedures.

### Tools Needed

<table>
<thead>
<tr>
<th>Tool</th>
<th>Qty</th>
</tr>
</thead>
<tbody>
<tr>
<td>Straightedge</td>
<td>1</td>
</tr>
<tr>
<td>Wrench 17mm</td>
<td>1</td>
</tr>
<tr>
<td>Hex Wrench 4mm</td>
<td>1</td>
</tr>
</tbody>
</table>

### To adjust the splitter/riving knife mount block:

1. **DISCONNECT SAW FROM POWER!**

2. Raise blade all the way up, move sliding table to side, and open lower blade cover to gain access to splitter/riving knife mounting block.

3. Loosen lock nut that secures splitter/riving knife to mounting block, and remove splitter/riving knife.

4. Adjust each pair of set screws that controls direction required to move mounting block so splitter/riving knife can be aligned with blade. Make sure to move both set screws in even increments.

5. Reinstall splitter/riving knife and check alignment with blade. Repeat Step 4 as necessary until splitter/riving knife is properly aligned to blade.

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

6. Properly re-install splitter/riving knife as described on Page 39, close blade cover, and move sliding table back to center position.
SECTION 9: 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

<table>
<thead>
<tr>
<th>BLACK</th>
<th>BLUE</th>
<th>GREEN</th>
<th>RED</th>
<th>WHITE</th>
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</thead>
<tbody>
<tr>
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<td>✱</td>
<td>✱</td>
<td>✱</td>
<td>✱</td>
</tr>
</tbody>
</table>

Note:

Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.
G0623X Wiring Diagram

- MAGNETIC SWITCH ASSEMBLY
- BLADE GUARD LIMIT SWITCH
- EMERGENCY STOP SWITCH
- POWER CONNECTION BOX

MOTOR 5HP 230V SINGLE-PHASE

L6-30 PLUG

230 VAC

READ ELECTRICAL SAFETY ON PAGE 76!
### SECTION 10: PARTS

#### Cabinet

<table>
<thead>
<tr>
<th>REF</th>
<th>PART #</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>P0623X0001</td>
<td>CABINET V1</td>
</tr>
<tr>
<td>2</td>
<td>P0623X0002</td>
<td>COVER PLATE</td>
</tr>
<tr>
<td>3</td>
<td>P0623X0003</td>
<td>EMERGENCY STOP BUTTON</td>
</tr>
<tr>
<td>4</td>
<td>P0623X0004</td>
<td>TAP SCREW M5 X 16</td>
</tr>
<tr>
<td>5</td>
<td>P0623X0005</td>
<td>BLADE TILT SCALE</td>
</tr>
<tr>
<td>6</td>
<td>P0623X0006</td>
<td>LOCK WASHER 10MM</td>
</tr>
<tr>
<td>7</td>
<td>P0623X0007</td>
<td>HEX NUT M10-1.5</td>
</tr>
<tr>
<td>8</td>
<td>P0623X0008</td>
<td>SWITCH BOX</td>
</tr>
<tr>
<td>9</td>
<td>P0623X0009</td>
<td>STRAIN RELIEF TYPE-3 PG-9</td>
</tr>
<tr>
<td>10</td>
<td>P0623X0010</td>
<td>BUTTON HD CAP SCR M6-1 X 20</td>
</tr>
<tr>
<td>11</td>
<td>P0623X0011</td>
<td>HEX NUT M6-1</td>
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<tr>
<td>12</td>
<td>P0623X0012</td>
<td>STRAIN RELIEF TYPE-3 PG-13.5</td>
</tr>
<tr>
<td>13</td>
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Model G0623X/G0623X3 (Mfd. Since 09/17)
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**Model G0623X/G0623X3 (Mfd. Since 09/17)**

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**G0623X 5HP, 230V, 1-PH SWITCH**

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**G0623X 7.5HP, 220V, 3-PH SWITCH**

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**G0623X 7.5HP, 440V, 3-PH SWITCH**

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## Rip Fence

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501 | P0623X0501 | RIP FENCE
502 | P0623X0502 | CLAMP PLATE
502A | P0623X0502A | REAR FENCE ASSEMBLY
503 | P0623X0503 | ROLL PIN 8 X 30
504 | P0623X0504 | ROD
505 | P0623X0505 | HDPE STRIP
506V2 | P0623X0506V2 | PHLP HD SCR M5-.8 X 10
507 | P0623X0507 | HEX NUT M8-1.25
508 | P0623X0508 | FIXED HANDLE 23 X 138, M8-1.25 X 22
509 | P0623X0509 | SLEEVE

**REF** | **PART #** | **DESCRIPTION**
--- | --- | ---
510 | P0623X0510 | SPRING PRESSURE PLATE
511 | P0623X0511 | COVER PLATE
512 | P0623X0512 | TAP SCREW M4 X 8
513 | P0623X0513 | ADJ. HANDLE 67L, M8-1.25
514 | P0623X0514 | FLAT WASHER 8MM
515V2A | P0623X0515V2A | RIP FENCE HOUSING ASSY
517 | P0623X0517 | PLASTIC SCREW
522 | P0623X0522 | HDPE STRIP 50 X 5MM
523 | P0623X0523 | EXT TOOTH WASHER 5MM
524 | P0623X0524 | HDPE STRIP
**Handwheels**

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## Swing Arm

**Diagram:**

*Illustration of Swing Arm components and assembly.*

### Parts List

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<tr>
<th>REF</th>
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**Miter Gauge**

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Crosscut Fence

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Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine MUST maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, REPLACE that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.
The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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