Grizzly Industrial, Inc.®

MODEL G0817
14" RESAW BANDSAW w/FOOT BRAKE
OWNER'S MANUAL
(For models manufactured since 05/25)

C US
181721

#WK18234 PRINTED IN TAIWAN V4.06.25

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

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INTRODUCTION

Contact Info

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

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

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

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

⚠WARNING

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

⚠CAUTION

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

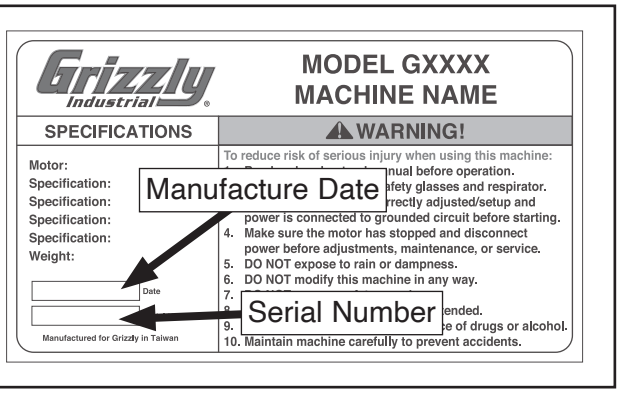
Manual Accuracy

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

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

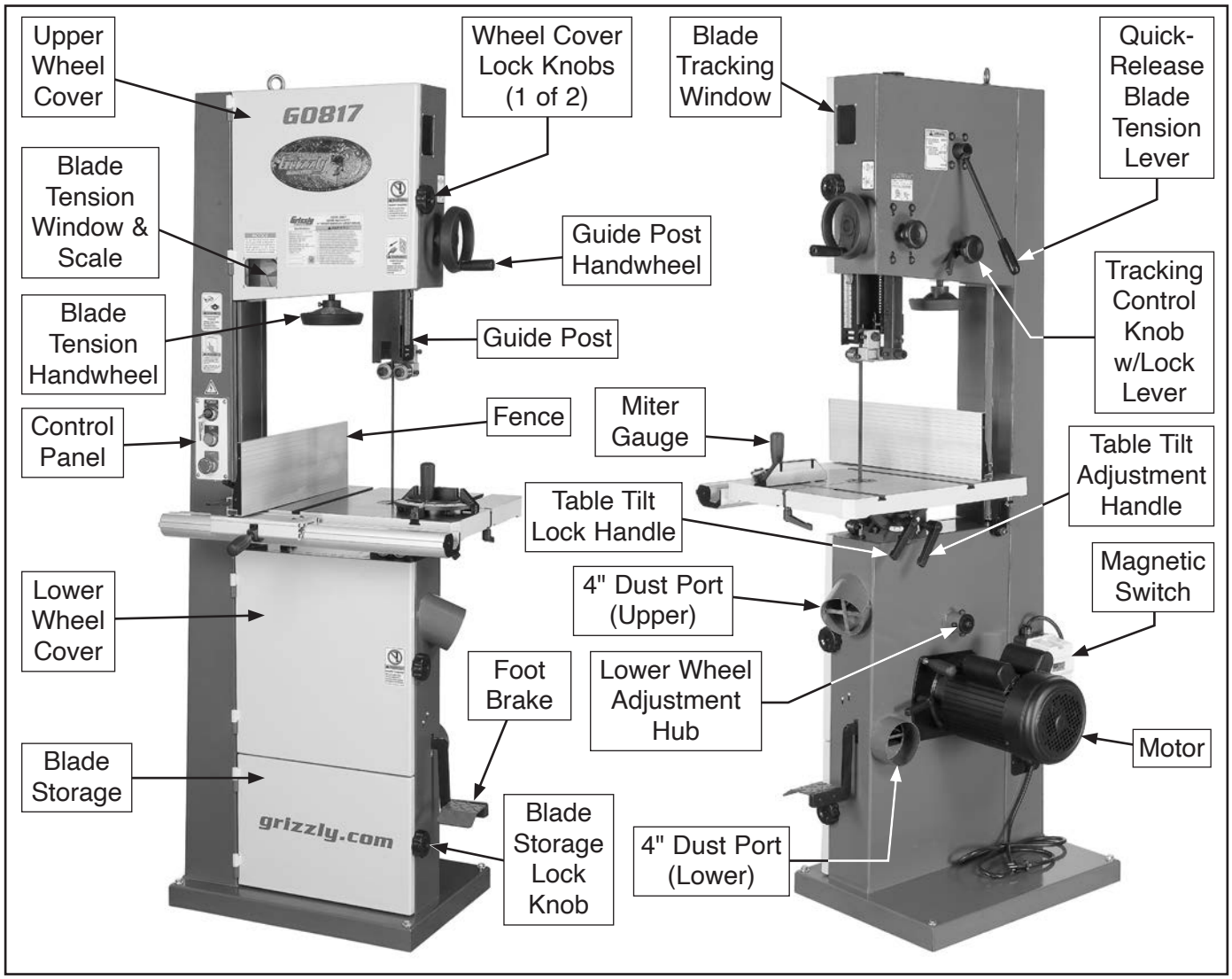
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

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



Identification

Become familiar with the names and locations of the controls and features shown below to better understand the instructions in this manual.

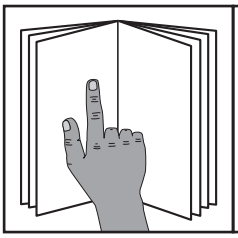


⚠CAUTION

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

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

Controls & Components



⚠WARNING

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

Refer to **Figures 1–10** and the following descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and stay safe when operating this machine.

Control Panel

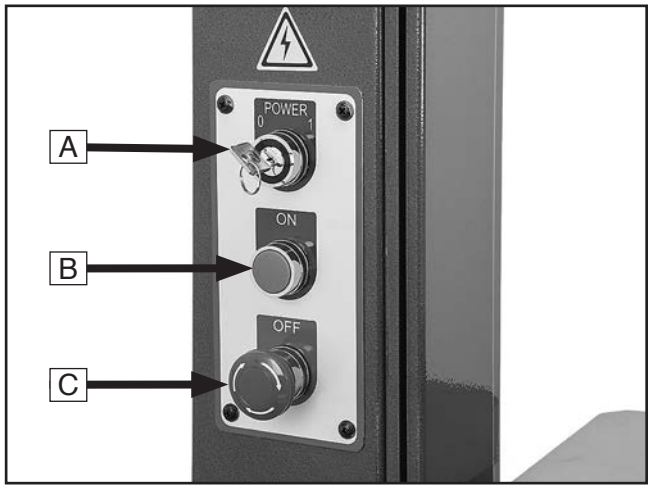


Figure 1. Control panel.

A. Master Power Key Switch: Turns incoming power ***ON*** and ***OFF***. Requires key.

B. ON Button: Turns motor ***ON*** when pressed.

C. Emergency Stop/Reset Button: Turns motor ***OFF*** when pressed. Motor will not start until switch is reset. Twist clockwise to reset.

Fence & Miter Gauge

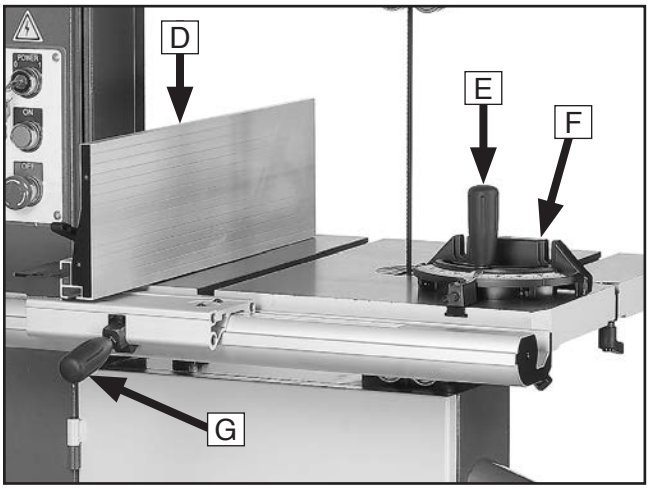


Figure 2. Fence and miter gauge controls.

Figure 3. Fence mounted in horizontal position.

D. Fence: Used for ripping or resawing. Distance from blade determines width of cut. Can be used in vertical position (as shown in **Figure 2**) for normal workpieces, or in horizontal position (as shown in **Figure 3**) for thin workpieces.

E. Miter Gauge Lock Knob: Secures angle position of miter gauge.

F. Miter Gauge: Typically used for cross cuts. Can be adjusted from 0°–60° left or right, and has stops at 45°L, 90°, and 45°R.

G. Fence Lock Handle: Secures fence position.

Guide Post

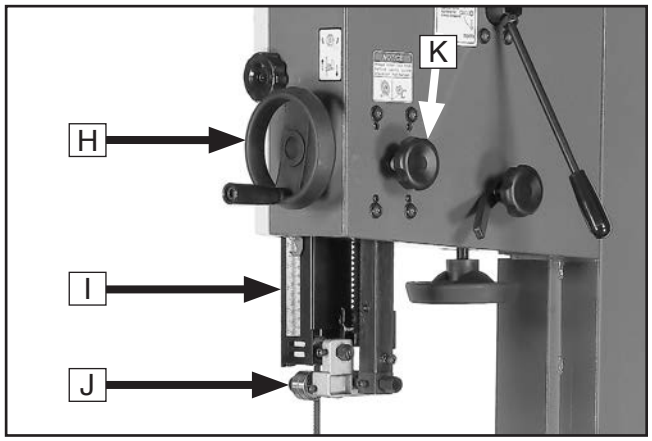


Figure 4. Guide post controls.

H. Guide Post Handwheel: Adjusts height of guide post above workpiece, using a rack-and-pinion system.

I. Guide Post w/Scale: Houses upper blade guides and support bearing, and shields operator from upper portion of blade. Adjusts up or down as necessary to position upper blade guides/support bearing as close as possible to workpiece for maximum cutting accuracy and minimum blade exposure to operator. Scale on side of guide post indicates height of upper blade guide above table.

J. Upper Blade Guide & Support Bearing: Support blade above workpiece during operations.

K. Guide Post Lock Knob: Secures guide post in position after adjustment.

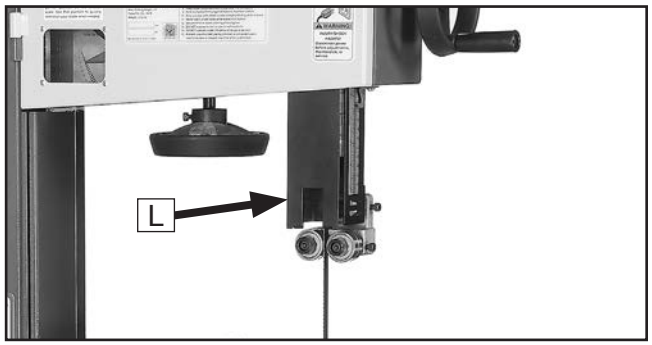


Figure 5. Hinge-open blade cover.

L. Hinge-Open Blade Cover: Opens for blade changes and upper blade guide adjustments (refer to **Pages 31–32**).

Blade Tension & Tracking

Figure 6. Blade tension handwheel, tension scale, and tracking window.

M. Blade Tension Scale: Displays blade tension using numbers 1–8. For reference purposes only—after you have found the proper tension for the particular blade installed.

N. Blade Tension Handwheel: Increases/decreases blade tension (refer to **Page 28** for more information).

O. Blade Tracking Window: Allows monitoring/adjustment of blade tracking without requiring wheel cover to be open (refer to **Page 25** for more information).

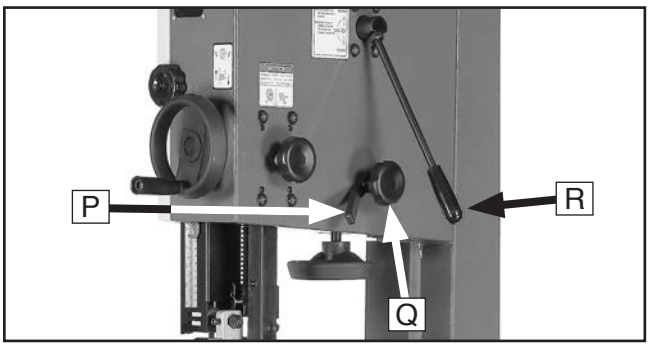


Figure 7. Blade tracking controls and blade tension quick-release lever.

P. Tracking Control Lock Lever: Secures position of blade tracking control knob.

Q. Tracking Control Knob: Adjusts tilt position of upper wheel to set/control blade tracking (refer to **Page 25** for more information).

R. Blade Tension Quick-Release Lever: Quickly releases blade tension to speed up blade changes and prevent unnecessary wear on blade and saw components when not in use. Move UP to quickly release blade tension. Move DOWN to re-tension blade.

Table Tilt

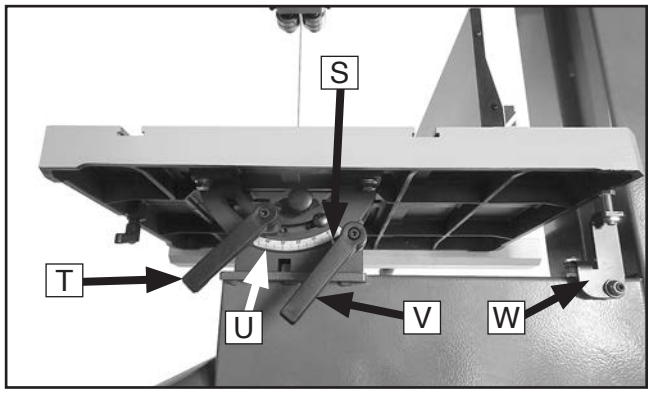


Figure 8. Table tilt controls.

S. Table Tilt Indicator: Shows table tilt angle.

T. Table Tilt Lock Lever: Secures table tilt position on trunnion. Must be loosened before table tilt can be adjusted.

U. Trunnion w/Table Tilt Scale: Functions as a tilting base for table. Graduated in degrees from 5° left–45° right for setting bevel angle.

V. Table Tilt Adjustment Lever: Adjusts angle of table tilt using a rack-and-pinion system.

W. Positive Stop: Allows for quickly returning table to a calibrated 0° setting after it has been tilted to the right (refer to **Page 47** for more information).

Lower Wheel Adjustment

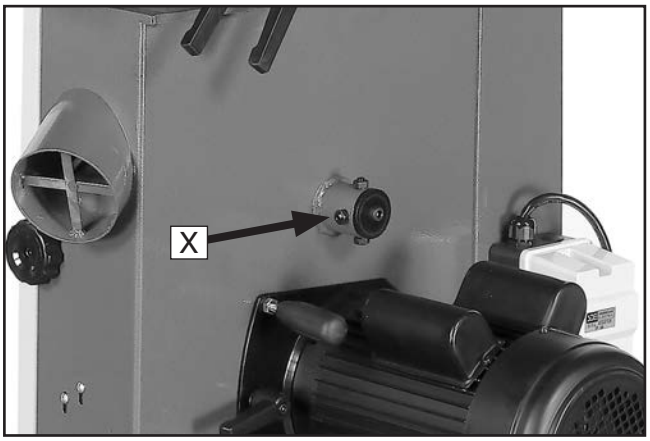


Figure 9. Lower wheel adjustment controls.

X. Lower Wheel Adjustment Hub: Adjusts position of lower wheel to upper wheel if coplanar adjustments become necessary (refer to **Page 68** for more information).

Note: *The wheels are factory-set to be coplanar, so we strongly recommend that you avoid making adjustments here unless it becomes absolutely necessary.*

Foot Brake

Figure 10. Location of foot brake.

Y. Foot Brake: Stops blade wheels and turns motor ***OFF***.

Important: *After the foot brake is pressed, the machine can be restarted by pressing the ON button. The Emergency Stop button does not have to be reset.*

MACHINE DATA SHEET

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

MODEL G0817 14" SUPER HD 2 HP RESAW BANDSAW W/ FOOT BRAKE

Product Dimensions:

Weight	319 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	29 x 32-1/2 x 76 in.
Footprint (Length x Width)	24 x 18 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	388 lbs.
Length x Width x Height	30 x 24 x 79 in.
Must Ship Upright	Yes

Electrical:

Power Requirement	110V or 220V, Single-Phase, 60Hz
Prewired Voltage	110V
Full-Load Current Rating	19A at 110V, 9.5A at 220V
Minimum Circuit Size	20A at 110V, 15A at 220V
Connection Type	Cord & Plug
Power Cord Included	Yes
Power Cord Length	6 ft.
Power Cord Gauge	12 AWG
Plug Included	Yes
Included Plug Type	5-20
Recommended Plug Type	6-15 for 220V
Switch Type	Control Panel w/Magnetic Switch Protection & Lockout Key

Motors:

Main

Horsepower	2 HP
Phase	Single-Phase
Amps	19A/9.5A
Speed	1720 RPM
Type	TEFC Capacitor-Start Induction
Power Transfer	Belt Drive
Bearings	Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type	External

Main Specifications:

Main Specifications

Bandsaw Size	14 in.
Max Cutting Width (Left of Blade)	13-1/2 in.
Max Cutting Width (Left of Blade) w/Fence	12 in.
Max Cutting Height (Resaw Height)	14 in.
Blade Speeds	2820 FPM

Blade Information

Standard Blade Length	120 in.
Blade Width Range	1/8–3/4 in.
Type of Blade Guides	Dual Roller Bearings
Guide Post Adjustment Type	Knob
Has Quick-Release	Yes

Table Information

Table Length	21-3/4 in.
Table Width	16-1/8 in.
Table Thickness	1-1/2 in.
Table Tilt	Left 5, Right 45 Deg.
Table Tilt Adjustment Type	Lever
Floor-to-Table Height	37 in.
Fence Locking Position	Front
Fence is Adjustable for Blade Lead	Yes
Resaw Fence Attachment Included	Yes
Miter Gauge Included	Yes

Construction Materials

Table	Cast Iron
Trunnion	Cast Iron
Fence	Extruded Aluminum
Base/Stand	Sheet Metal
Frame/Body	Sheet Metal
Wheels	Cast Iron
Tire	Polyurethane
Wheel Cover	Sheet Metal
Paint Type/Finish	Powder Coat

Other Related Information

Wheel Diameter	14 in.
Wheel Width	1-1/8 in.
Number of Dust Ports	2
Dust Port Size	4 in.
Compatible Mobile Base	D2057A

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	Machine ID Label
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features:

14" Resaw Capacity
2 HP, 110V/220V (Prewired 110V), Single-Phase
Ball-Bearing Blade Guides
Foot-Operated Brake System
Modular Blade-Guide Design for Easy Changeovers Between Styles
Lever-Action Table Trunnion for Quick Table Tilt Adjustment
Cast-Iron Fence with 2-Position Extruded Aluminum Resaw Fence
Storage Area for Extra Blades and Miter Gauge When Not In Use
Cast-Iron Wheels and Table Trunnion
Included Miter Gauge
Blade Tension Indicator

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Bandsaws

⚠WARNING

Serious cuts, amputation, or death can occur from contact with the moving saw blade during operation or if blade breakage occurs. To reduce this risk, anyone operating this machine MUST completely heed the hazards and warnings below.

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

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

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

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

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

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

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

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

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

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

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

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

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

Full-Load Current Rating

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

Full-Load Current Rating at 110V ..... 19 Amps
Full-Load Current Rating at 220V .... 9.5 Amps

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

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

Circuit Information

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

⚠CAUTION

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

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

Circuit Requirements for 110V

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

Nominal Voltage 110V, 115V, 120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Power Supply Circuit ..... 20 Amps
Plug/Receptacle ..... NEMA 5-20

Circuit Requirements for 220V

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

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

Grounding Requirements

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

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

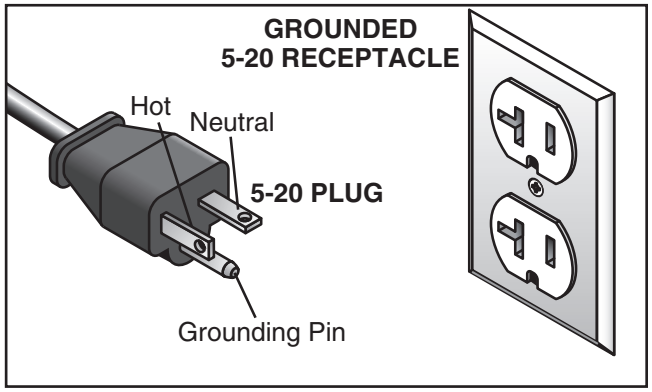
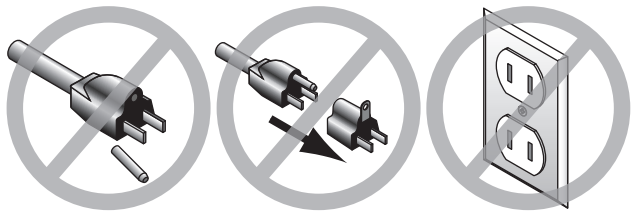


Figure 11. Typical 5-20 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!
Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

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

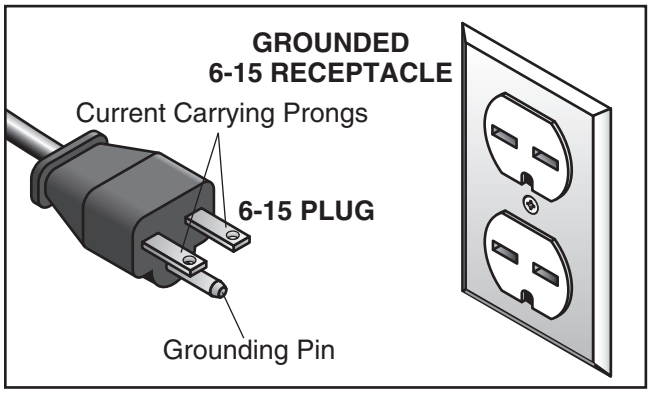


Figure 12. Typical 6-15 plug and receptacle.

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

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

Extension Cords

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

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

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

Minimum Gauge Size.....12 AWG
Maximum Length (Shorter is Better).....50 ft.

Converting Voltage to 220V

⚠CAUTION

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

The voltage conversion MUST be performed by an electrician or qualified service personnel. The voltage conversion procedure requires purchasing/installing the 220V Conversion Kit (**Grizzly Part #P0817161V2**), rewiring the motor, and installing the correct plug. The necessary wiring diagrams are provided in the **Wiring** section, beginning on **Page 71** for your reference.

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

Items Needed	Qty
• Phillips Head Screwdriver #2	1
• Electrical Tape	As Needed
• Wire Nut (14 AWG x 3)	1
• Plug 6-15	1
• Wire Cutters/Stripper	1

To convert Model G0817 to 220V:

1. DISCONNECT MACHINE FROM POWER!

2. Cut off existing 5-20 plug.

3. Open motor junction box, then remove two wire nuts indicated in **Figure 13**.

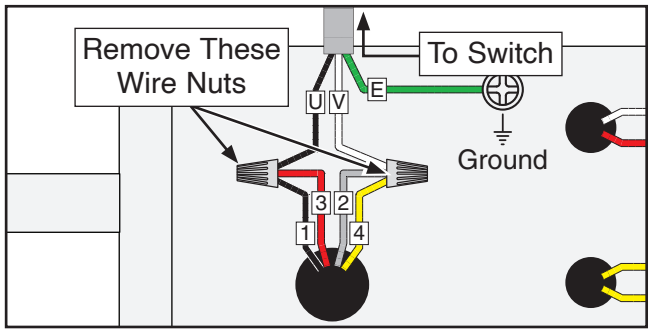


Figure 13. Inside motor junction box.

4. Connect wires as indicated in **Figure 14**. Secure wire connections with wire nuts, and wrap them with electrical tape so they will not vibrate loose during operation.

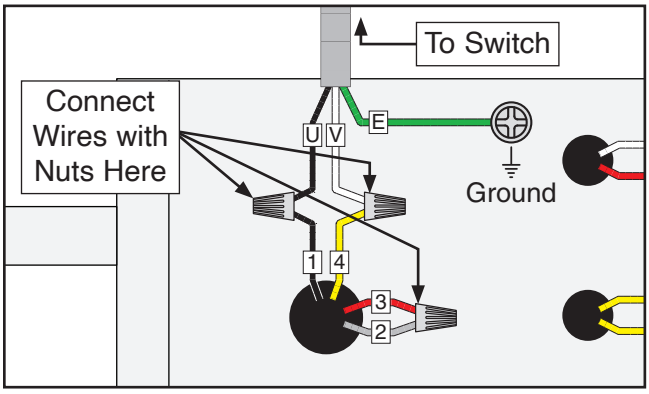


Figure 14. Motor rewired to 220V.

5. Close and secure motor junction box.

6. Remove 110V magnetic switch assembly (see **Figure 15**), and replace it with 220V conversion kit (**Grizzly Part# P0817161V2**).

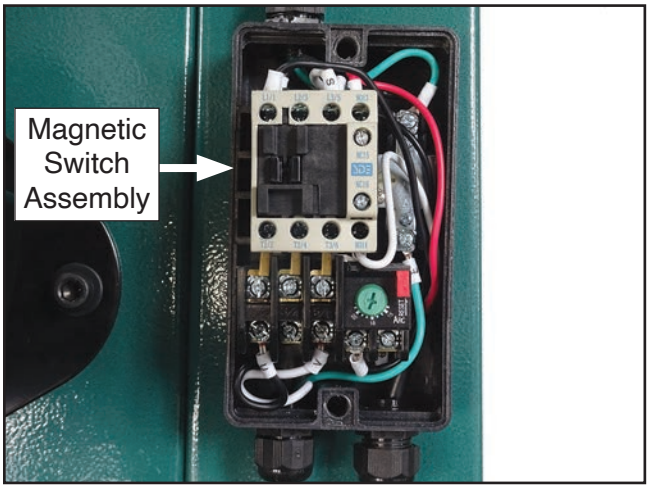
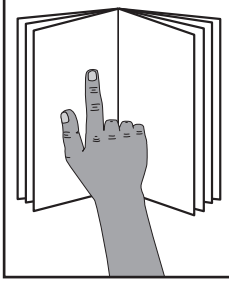


Figure 15. Magnetic switch.

7. Install a 6-15 plug on power cord, according to plug manufacturer's instructions. If plug manufacturer's instructions are not available, NEMA standard 6-15 plug wiring is provided on **Page 73**.

SECTION 3: SETUP

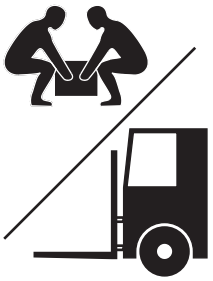


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Safety Glasses (for each person)	1
• Solvent/Cleaner	1
• Shop Rags	1
• Lifting Strap/Chain (Rated for at least 450 lbs.)	1
• Lifting Equipment (Rated for at least 450 lbs.)	1
• Another Person	1

Unpacking

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

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

Inventory

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

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

If you cannot find an item on this list, check around/inside the machine and packaging materials. Often, these items get lost while unpacking or they are pre-installed at the factory.

Inventory (Figures 16–18) **Qty**

A. Main Bandsaw Body (not shown) 1
B. Table 1
C. Table Insert 1
D. Fence Face 1
E. Fence Base Assembly 1
F. Hardware Bag 1
- —Hex Bolts M6-1 x 20 2
- —Lock Washers 6mm 2
- —Flat Washers 6mm 2
- —Fence Face Adjustable Handle 1
- —Flat Washer 8mm 1
- —Fence Guide Plate 1
- —Fence Base Lock Lever 1
- —Hex Nut M8-1.25 1

G. Fence Rail 1
H. Miter Gauge 1
I. Fence Support 1
J. Hardware Bag (**Page 17**) 1
- —Lock Washers 8mm 4
- —Flat Washers 8mm 4
- —Hex Bolts M8-1.25 x 25 4
- —Open-End Wrench 10/13mm 1
- —Table Gap Screw Assembly 1
- —Hex Nut M8-1.25 1
- —Flat Washer 8mm 1
- —Flat Washers 6mm 2
- —Cap Screws M6-1 x 12 2
- —Hex Wrench 5mm 1
- —Hex Wrench 8mm 1

K. Guide Post Handwheel 1
L. Dust Deflector 1

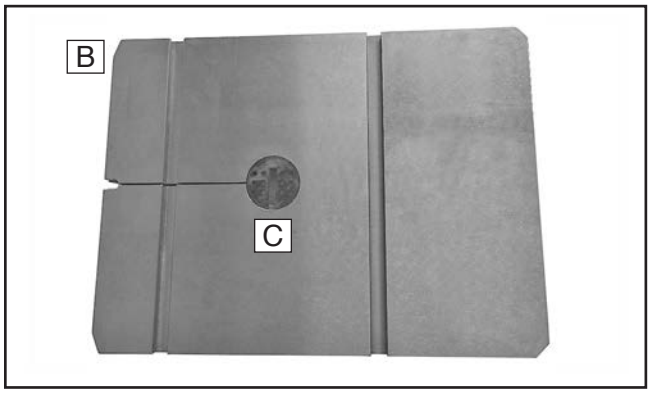


Figure 16. Box 1 inventory.

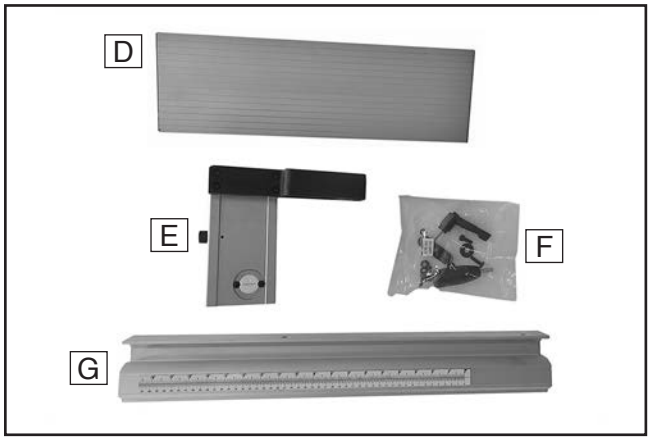


Figure 17. Box 2 inventory.

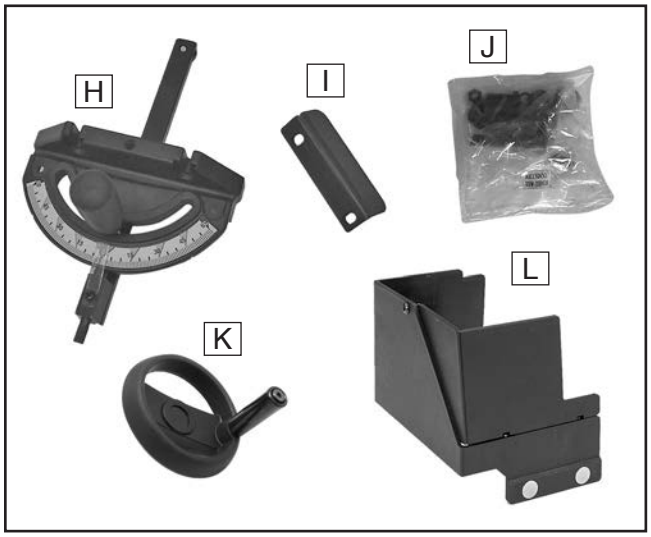
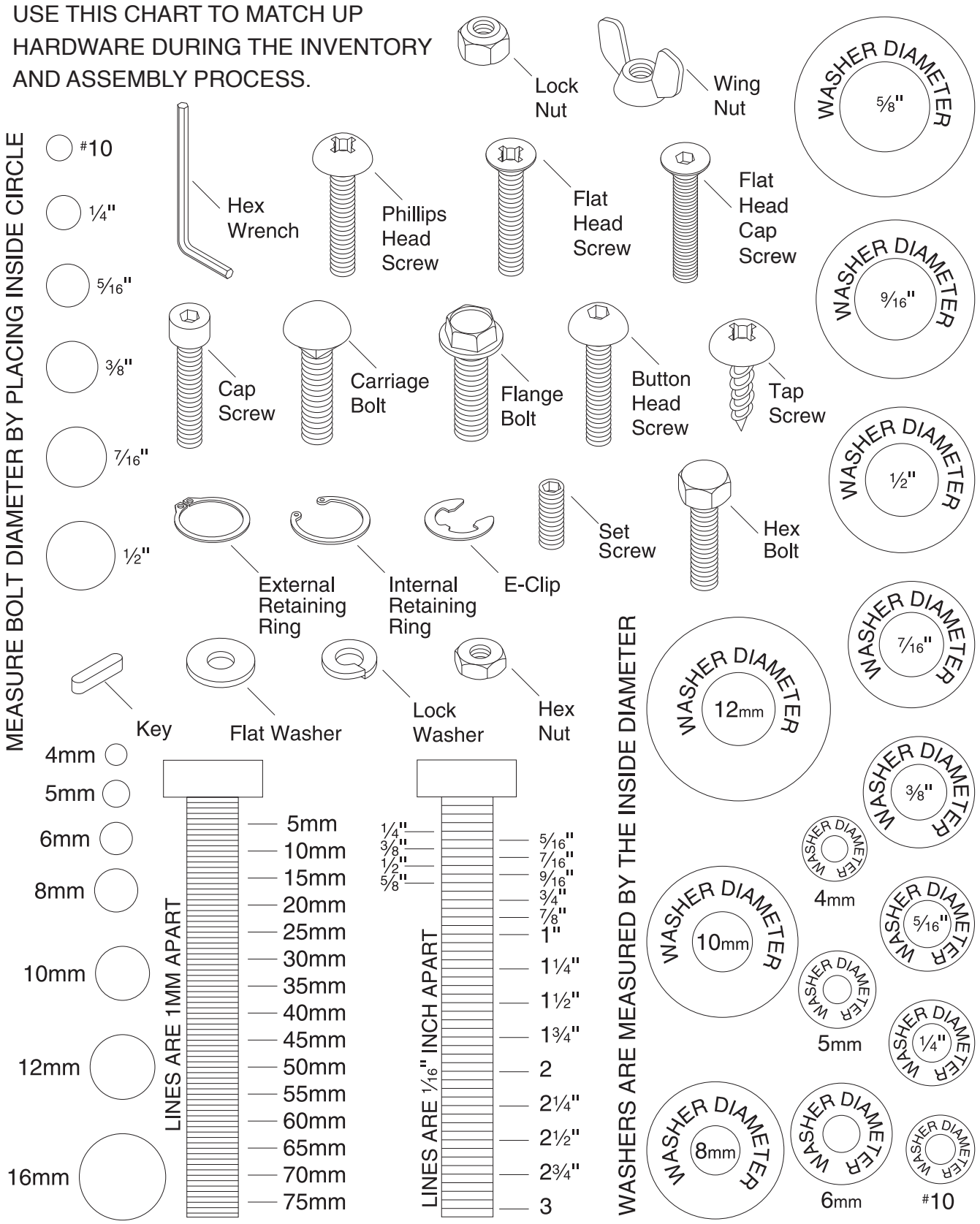


Figure 18. Loose item inventory.

Hardware Recognition Chart



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:
- Disposable rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

⚠WARNING

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

⚠CAUTION

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

NOTICE

Avoid harsh solvents like acetone or brake parts cleaner that may damage painted surfaces. Always test on a small, inconspicuous location first.

T23692—Orange Power Degreaser
A great product for removing the waxy shipping grease from the ***non-painted*** parts of the machine during clean up.

Order online at www.grizzly.com OR Call 1-800-523-4777

Figure 19. T23692 Orange Power Degreaser.

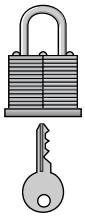
Site Considerations

Weight Load

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

Space Allocation

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



⚠CAUTION

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

Physical Environment

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

Electrical Installation

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

Lighting

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

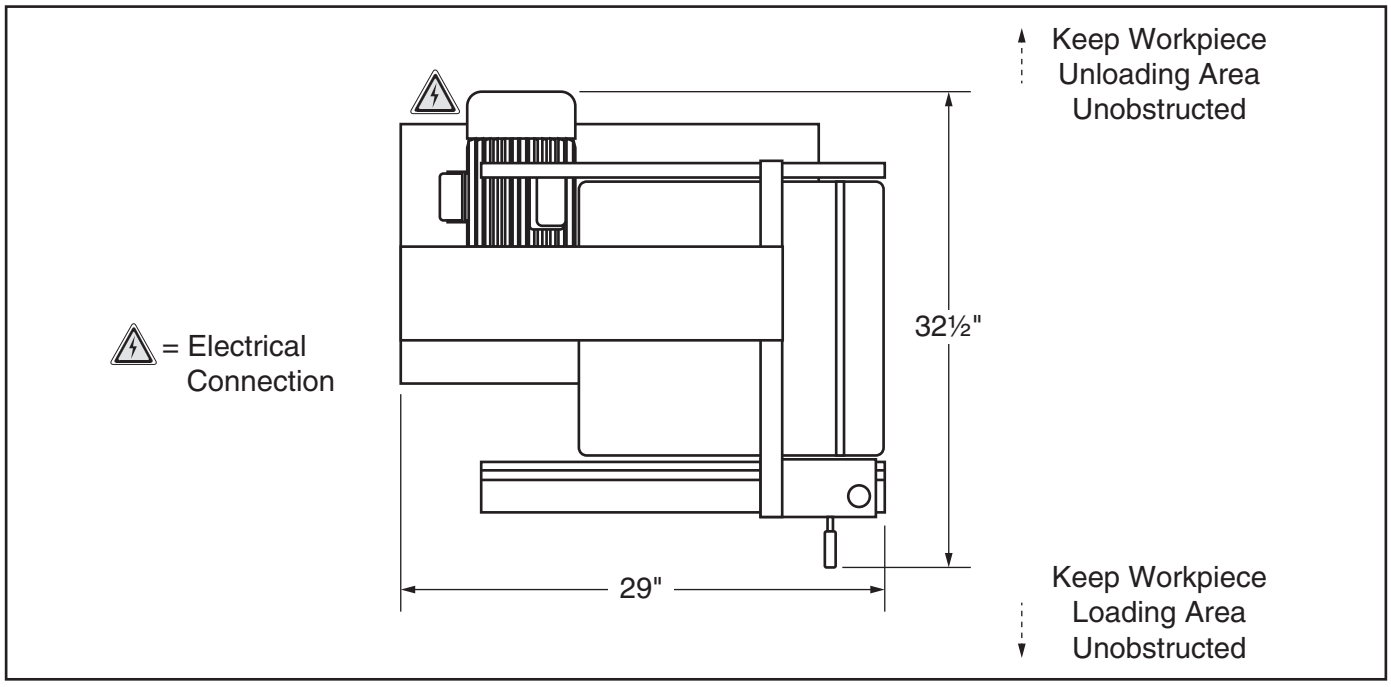
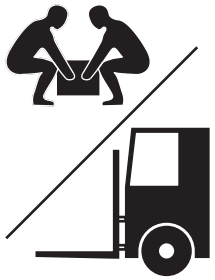


Figure 20. Minimum working clearances.

Lifting & Placing



⚠WARNING

HEAVY LIFT!

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

Special care should be taken when moving this bandsaw. To reduce your risk of injury or accidental damage, use one of the following methods to lift or move this bandsaw.

Using Forklift & Eye Bolt

1. Use forklift to move crate to prepared location, then remove crate from shipping pallet.

2. Unbolt bandsaw from pallet.

3. Install eye bolt. Make sure it is threaded all the way in, then place lifting hook through eye bolt (see **Figure 21**) and lift bandsaw slowly with forklift enough to clear pallet.

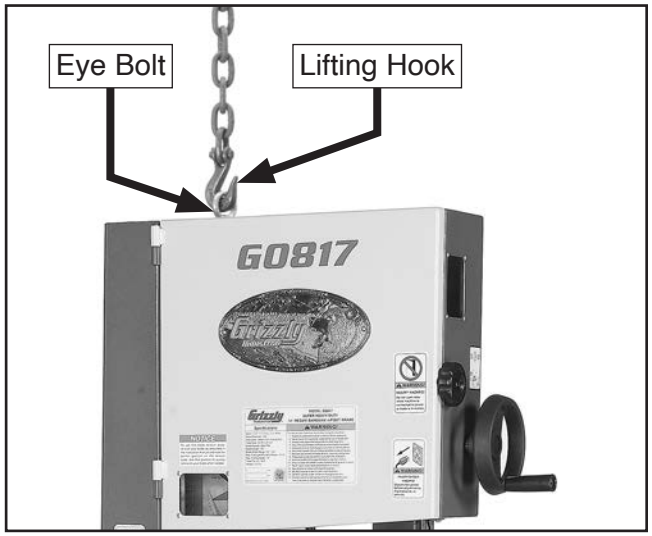


Figure 21. Lifting bandsaw with eye bolt and chain.

4. Remove pallet and slowly set bandsaw into position.

Using Forklift & Wood Blocks

1. Use forklift to move crate to prepared location, then remove crate from shipping pallet.

2. Unbolt bandsaw from pallet.

3. Carefully place forklift forks under bandsaw head. Insert a 1x4 block between head and left fork, and a 2x4 block between head and right fork so bandsaw is level, as shown in **Figure 22**.

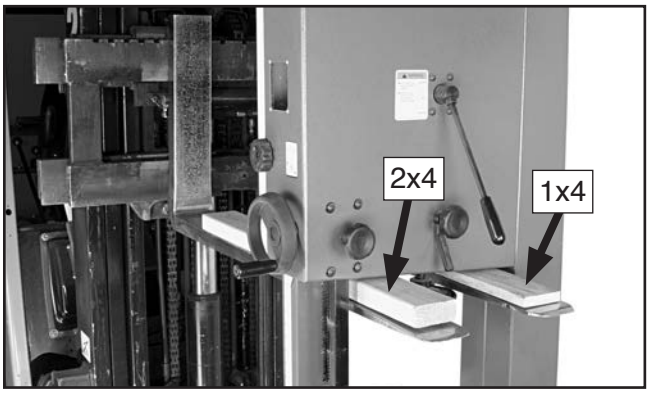


Figure 22. Example of lifting bandsaw with forklift using wood shims.

4. Lift bandsaw off of pallet, remove pallet, then slowly set bandsaw into position.

Note: *If you are concerned about your forklift forks hitting the tension handwheel, remove handwheel before positioning forks, then re-install it after placing bandsaw in final location.*

Using Pallet Jack & Furniture Dolly

1. Use pallet jack to move crate to prepared location, then remove crate from shipping pallet.

2. Unbolt bandsaw from pallet.

3. With help of another person, carefully "walk" bandsaw (or use furniture dolly to move bandsaw) off of pallet and into position.

⚠WARNING

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

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 3/8"

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

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

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

Anchoring to Concrete Floors

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

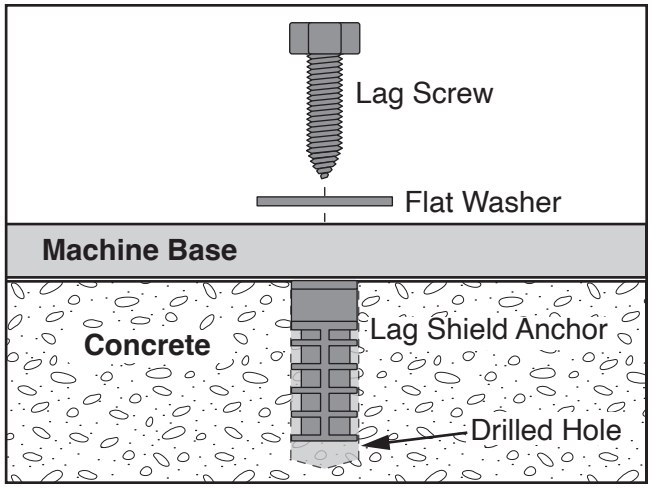


Figure 23. Popular method for anchoring machinery to a concrete floor.

Assembly

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

To assemble bandsaw:

1. Secure guide post handwheel onto handwheel shaft flat with included cap screw (see **Figure 24**).

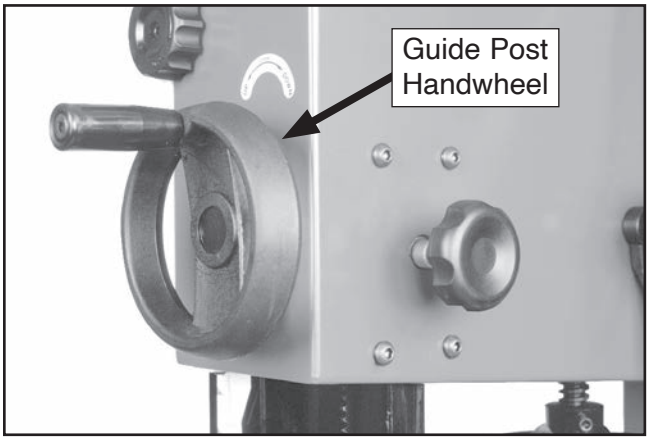


Figure 24. Guide post handwheel installed.

2. Remove protective shipping cover from blade, then remove table insert and shipping screw from table (see **Figure 25**).

3. Place table on saw, sliding table gap around blade (see **Figure 25**).

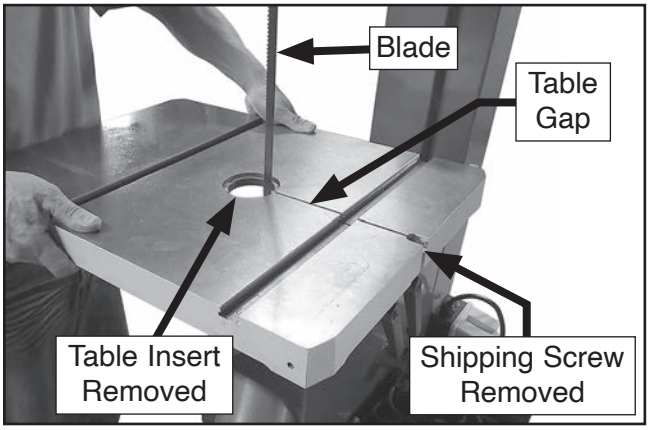


Figure 25. Placing table on saw with gap positioned around blade.

4. Carefully position table so gap faces to the right (see **Figure 26**).

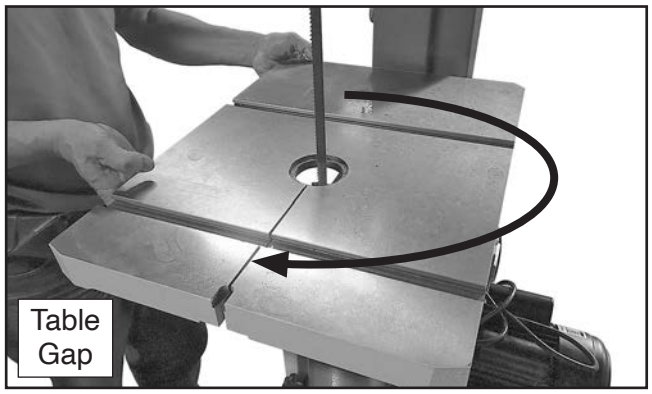


Figure 26. Table rotated with gap facing right.

5. Secure table to trunnion using (4) M8-1.25 x 25 hex bolts, (4) 8mm lock washers, and (4) 8mm flat washers (see **Figure 27**).

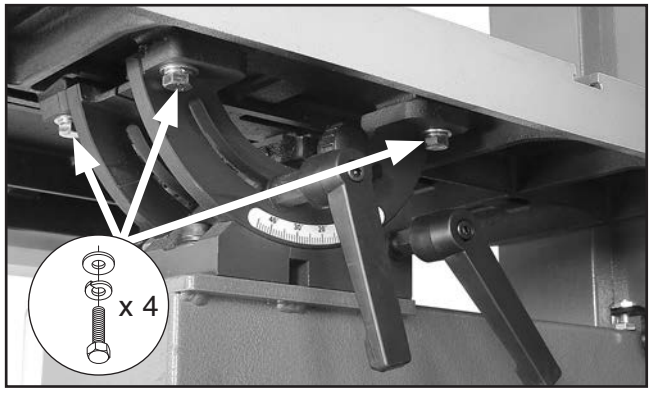


Figure 27. Table to trunnion mounting hardware installed.

6. Install table insert (see **Figure 28**).

7. Install table gap screw assembly, secure with (1) M8-1.25 hex nut and (1) 8mm flat washer (see **Figure 28**), then tighten gap screw to ensure table surface is flush across gap.

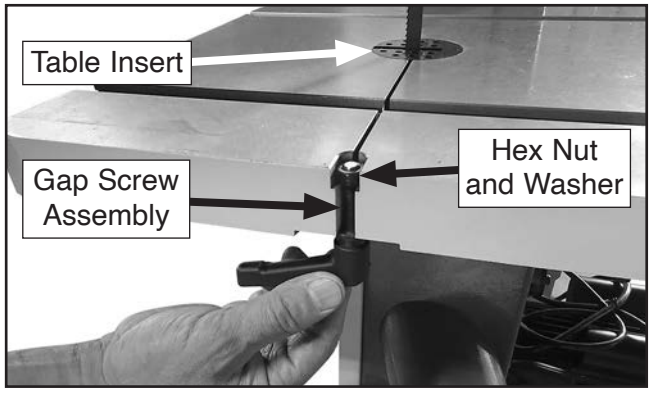


Figure 28. Table insert and gap screw installed.

8. Install fence support using (2) M6-1 x 12 cap screws and 6mm flat washers (see **Figure 29**).

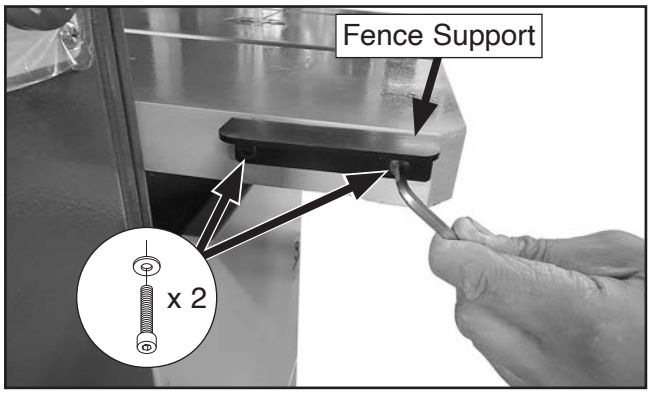


Figure 29. Installing fence support.

9. Install fence rail using (2) M6-1 x 20 hex bolts, (2) 6mm lock washers, and (2) 6mm flat washers (see **Figure 30**).

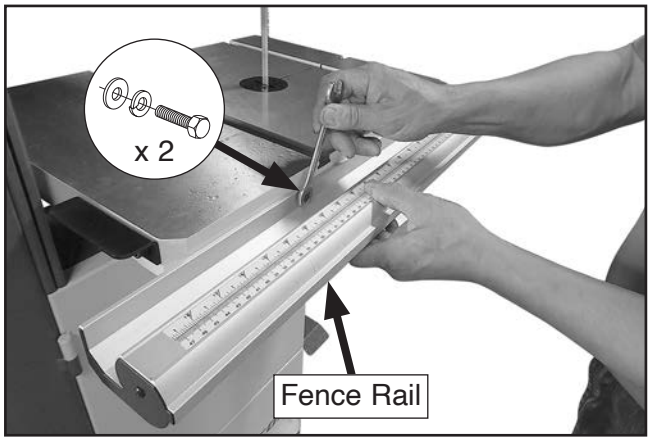


Figure 30. Installing fence rail.

10. Thread (1) M8-1.25 hex nut onto lock lever, install lock lever onto fence base, then tighten hex nut to secure (see **Figure 31**).

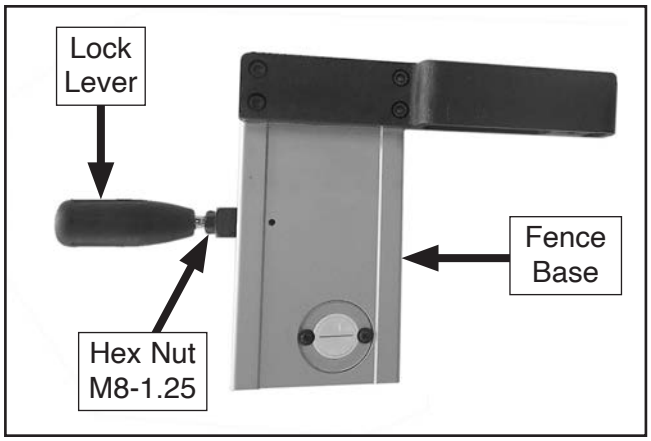


Figure 31. Fence base lock lever installed.

11. Install adjustable handle onto fence base with (1) 8mm flat washer, and thread into fence base guide plate (see **Figure 32**).

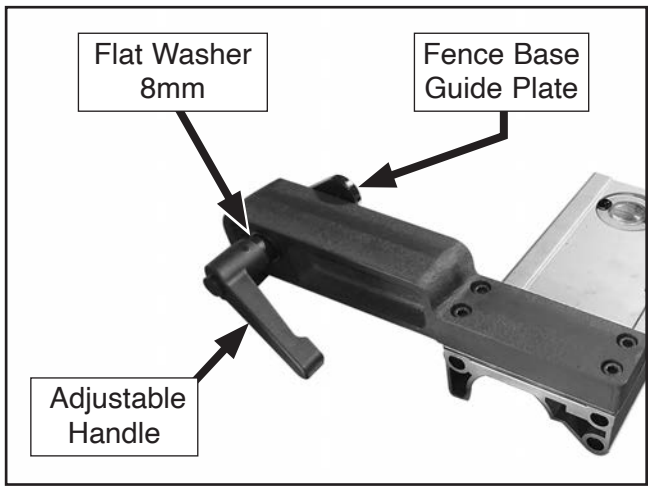


Figure 32. Fence base adjustable handle and guide plate installed.

12. Place fence base on fence rail with lock lever raised up. Push lock lever down to secure fence in place (see **Figure 33**).

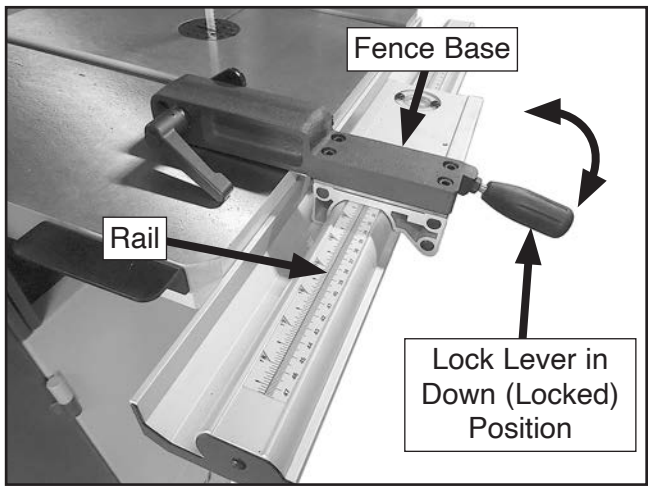


Figure 33. Fence base installed on fence rail.

13. Mount fence face to fence base, sliding T-channel (see **Figures 34–35**) around fence base guide plate (see **Figure 32**).

— For *normal* workpieces, mount fence in vertical position, as shown in **Figure 34,** then rotate fence base lock lever to secure.

— For *thin* workpieces, mount fence in horizontal position, as shown in **Figure 35,** then rotate fence base lock lever to secure.

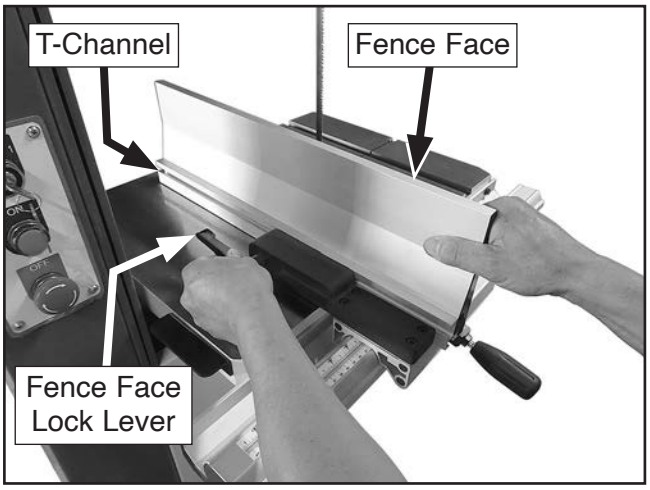


Figure 34. Installing fence in vertical position.

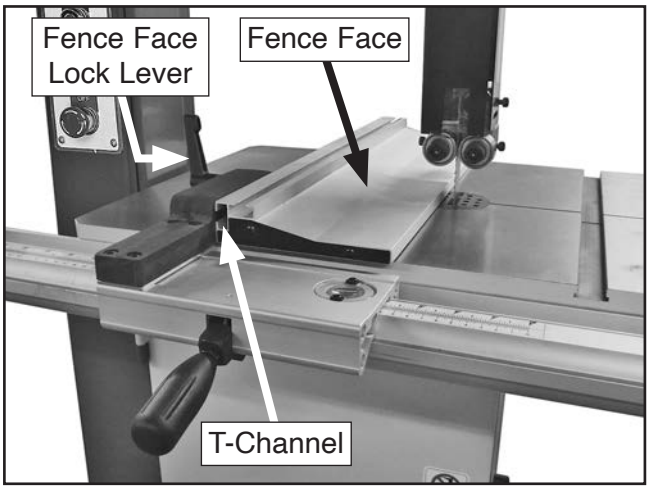


Figure 35. Fence installed in horizontal position.

14. Install dust deflector under table so it rests on door and frame, as shown in **Figure 36**. Ensure (2) magnets on face of deflector attach securely to bandsaw frame.

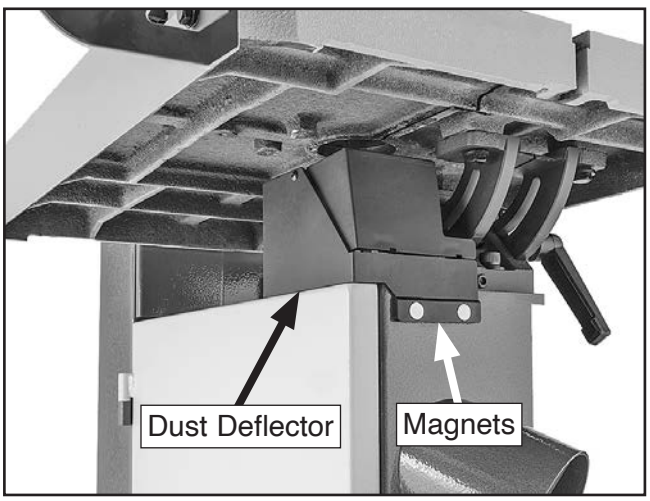


Figure 36. Dust deflector installed.

Dust Collection

⚠CAUTION

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

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

To connect dust collection system to machine:

1. Fit a 4" dust hose over each dust port, and secure them in place with hose clamps (see **Figure 37**).

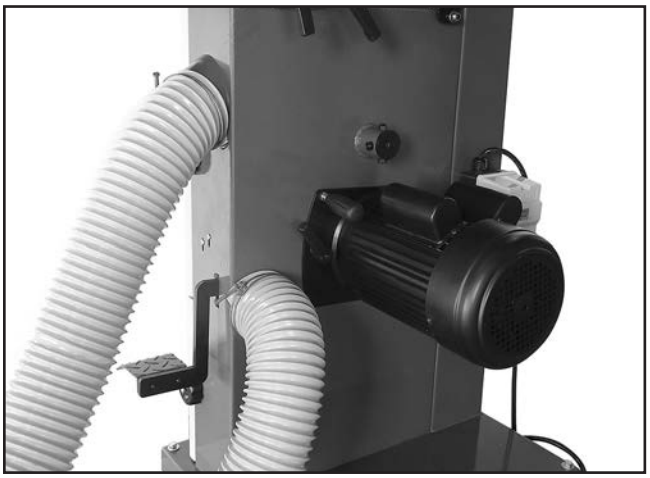


Figure 37. Dust hoses attached to dust ports.

Note: *For best results, connect free ends of hoses to a 4" Y fitting and secure with hose clamps, then connect fitting to your dust collection system. See **Accessories**, beginning on **Page 51**, for more information.*

2. Tug hoses to make sure they do not come off.

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

Adjustment Overview

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

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

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

Initial Blade Tracking

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

Bandsaw wheels are either flat or crowned and both shapes track differently. This bandsaw has crowned wheels. As the wheels spin, a properly tracking blade naturally tracks at the center of the wheel (see **Figure 38**).

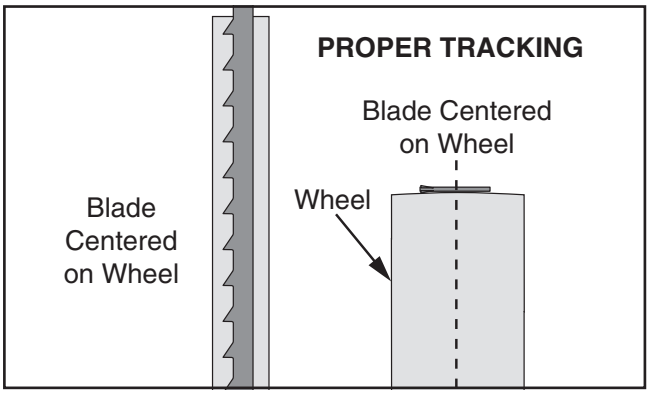
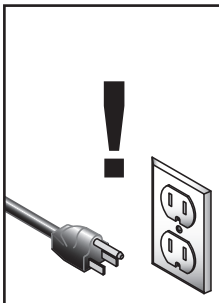


Figure 38. Blade centered on crown of wheel.

Blade tracking is primarily affected by the tilt of the upper wheel, known as “center tracking.” However, the alignment of both wheels plays an important part as well (see **Wheel Alignment** on **Page 66** for more details).

The wheels on this bandsaw were aligned at the factory, so center tracking is the only adjustment that needs to be checked/performed when the saw is new.



⚠WARNING

Serious personal injury can occur if the machine starts while your hand is touching the bandsaw wheel during tracking adjustments. Disconnect power from the bandsaw before performing blade tracking adjustments.

To adjust blade tracking:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust upper and lower blade guides away from blade, and raise upper guides approximately ⅔ of the way up (refer to **Adjusting Blade Guide Bearings** on **Page 32** for detailed instructions).

   Note: *When adjusting the blade tracking for the test run in this procedure, the blade must have approximately the same amount of tension as when under operating conditions. After the test run is successfully completed, you will be instructed on how to more accurately tension the blade for optimum results.*

3. Move blade tension quick-release lever down to apply tension to blade (see **Figure 39**).

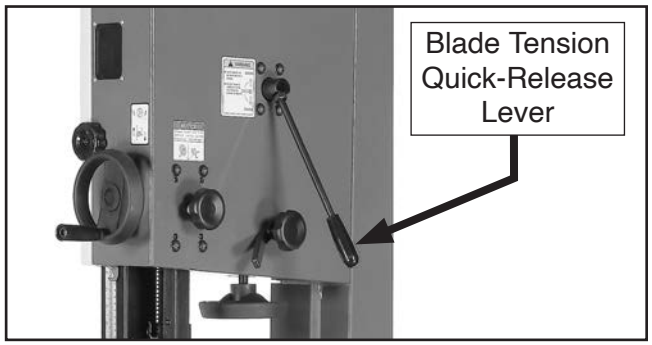


Figure 39. Blade tension quick-release lever in down position, applying tension to blade.

4. Open upper wheel cover (see **Figure 40**).

5. Rotate blade tension handwheel until tension scale (see **Figure 40**) is between 4 and 6. Rotate handwheel *clockwise* to *increase* blade tension. Rotate handwheel *counterclockwise* to *decrease* blade tension.

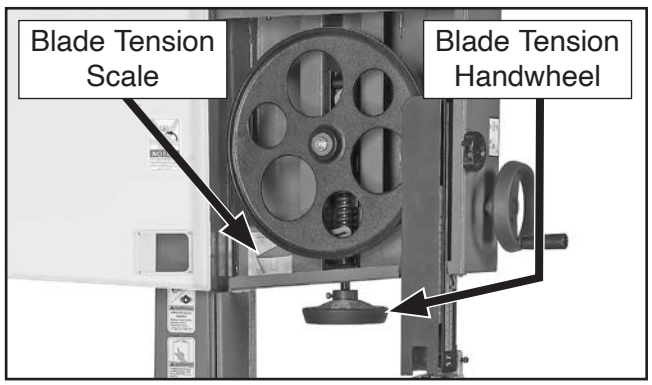


Figure 40. Blade tensioning controls.

6. Loosen tracking control lock lever on back of bandsaw (see **Figure 41**).

7. Rotate upper wheel by hand several times and watch how blade rides on wheel (see **Figure 41**).

   — If the blade consistently rides in the center of the upper wheel, it is tracking properly and no adjustments are necessary; proceed to **Step 9**.

   — If the blade does *not* consistently ride in the center of the upper wheel, it is not tracking properly; proceed to **Step 8**.

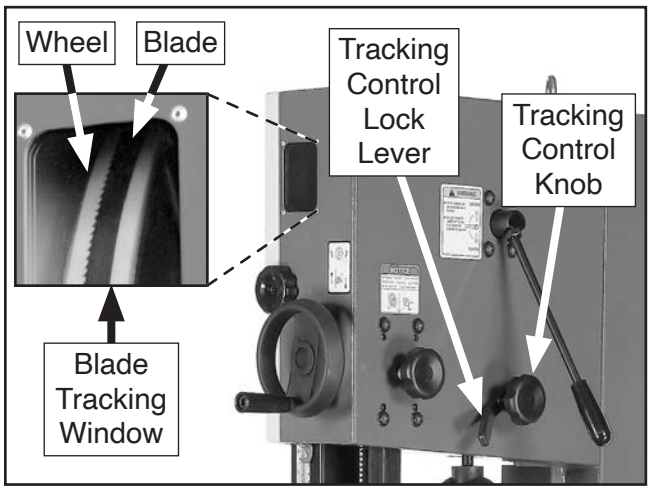


Figure 41. Blade tracking controls.

8. Adjust tracking control knob (see **Figure 41** on **Page This Page**) in small amounts and continue to rotate upper wheel by hand at the same time until blade consistently rides in center of bandsaw tire.

9. Tighten tracking control lock lever, and close and secure upper wheel cover.

   Note: *For the best performance from your saw, regularly maintain proper tracking of the blade. Fine tune tracking must be done with the bandsaw turned **ON**. Refer to **Page 30** for more information.*

Test Run

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

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

⚠WARNING

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

⚠WARNING

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

The test run consists of verifying the following:

- Motor powers up and runs correctly.
- Emergency Stop button works correctly.
- Foot brake pedal works correctly.

To test run machine:

1. Clear all setup tools away from machine.

2. Press Emergency Stop button in.

3. Connect machine to power by inserting power cord plug into a matching receptacle.

4. Insert key into Master Power Key Switch, then rotate switch to "1" position (see **Figure 42**). This turns incoming power ***ON***.

5. Twist Emergency Stop button clockwise until it springs out (see **Figure 42**). This resets switch so machine can start.

6. Press ON button (see **Figure 42**) to turn machine ***ON***. Verify motor starts up and runs smoothly without any unusual problems or noises.

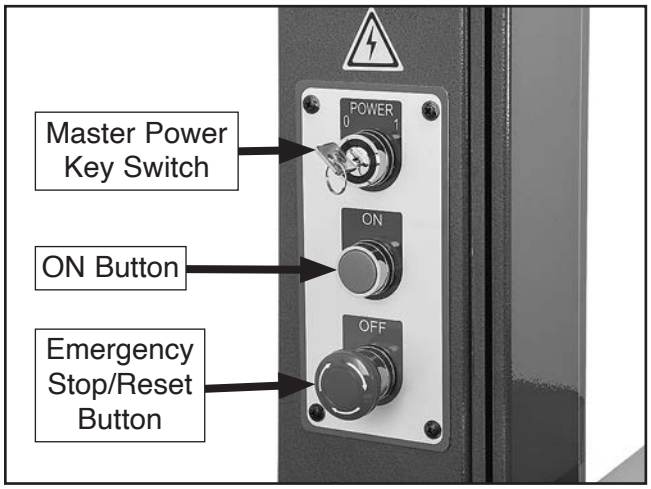


Figure 42. Location of power controls for turning machine ***ON*** and ***OFF***.

7. Press Emergency Stop button to turn machine ***OFF***.

8. WITHOUT resetting Emergency Stop button, try to start machine by pressing ON button. Machine should not start.

   — If the machine *does not* start, the safety feature of the Emergency Stop button is working correctly.

   — If the machine *does* start, immediately turn it ***OFF***, disconnect power, and contact customer service for assistance. The safety feature of the Emergency Stop button is NOT working properly and must be replaced before further using the machine.

9. Repeat **Steps 5–6** to turn machine ***ON***.

10. Allow motor to reach full speed, then step on foot brake pedal (see **Figure 43**). Blade should stop moving and motor should turn ***OFF***.

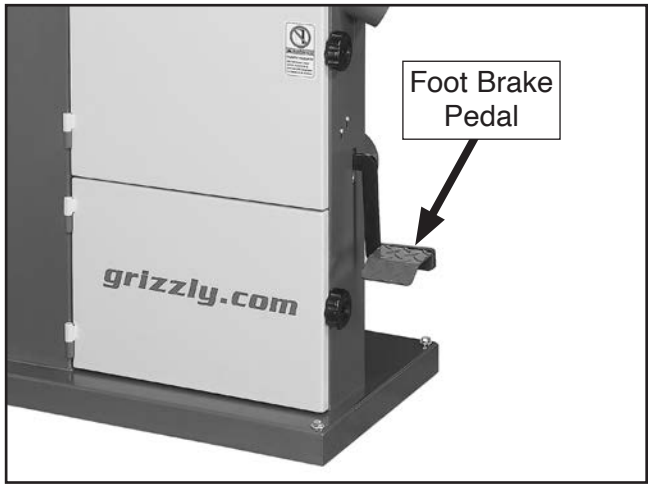


Figure 43. Location of foot brake pedal.

— If the blade stops moving and the motor turns ***OFF***, the foot brake feature is working correctly. Congratulations! The Test Run is complete.

— If the blade *does not* stop moving, or the motor *does not* turn ***OFF***, the foot brake feature is not working correctly. Turn machine ***OFF***, disconnect power immediately, and contact customer service for assistance.

Tensioning Blade

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

Optimal cutting results for any type of workpiece are achieved through a combination of correct blade selection, proper blade tension, properly adjusted blade guides and other bandsaw components, and using an appropriate feed rate.

Improper blade tension is unsafe, produces inaccurate and inconsistent results, and introduces unnecessary wear on bandsaw components. Over-tensioning the blade increases the chance of the blade breaking or wheel misalignment. Under-tensioned blades wander excessively while cutting and will not track properly during operation.

The method used to tension the blade is often a matter of preference. This manual describes two methods: the flutter method and the deflection method. Either method will help you properly tension the blade. Experience and personal preference will help you decide which method you prefer.

Note: *Tensioning the blade before the **Test Run** was an approximate tension. The following procedures fine-tune the blade tension.*

The Flutter Method

Using the flutter method, you intentionally loosen the blade until it just passes the point of being too loose (when it begins to flutter). Then you gradually tighten the blade until proper tension is reached.

To tension bandsaw blade using flutter method:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure blade is properly tracking as instructed in **Initial Blade Tracking** subsection on **Page 25**.
3. Raise guide post all the way, and move upper and lower guide bearings away from blade (refer to **Page 31** for more information).
4. Engage blade tension quick-release lever to apply tension to blade.
5. Connect bandsaw to power, then turn it ***ON***.
6. Use blade tension handwheel to slowly decrease blade tension until you see blade start to flutter.
7. Slowly increase tension until blade stops fluttering, then tighten blade tension adjustment knob an additional ⅛ to ¼ of a turn.
8. DISCONNECT MACHINE FROM POWER!
9. Adjust blade guides as described in **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages 31–32**.

The Deflection Method

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

To tension bandsaw blade using deflection method:

1. DISCONNECT MACHINE FROM POWER!
2. Make sure blade is properly tracking as instructed in **Initial Blade Tracking** subsection on **Page 25**.
3. Raise guide post all the way and move upper and lower guide bearings away from blade (refer to **Page 31** for more information).
4. Engage blade tension quick-release lever to apply tension to blade.
5. Using moderate pressure, push center of blade sideways.
   - — If blade deflects approximately ¼", it is properly tensioned. Proceed to **Step 6**.
   - — If blade deflects less than ¼", it is over-tensioned. Rotate blade tension handwheel counterclockwise two full turns and repeat **Step 5**.
   - — If blade deflects ¼" or more, blade is not properly tensioned. Rotate blade tension handwheel clockwise to incrementally tension blade, and repeat **Step 5** until blade is properly tensioned.
6. Adjust blade guides as described in **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages 31–32**.

Fine Tune Tracking

During setup, the blade was tracked without the machine connected to power (refer to **Page 25**). In this procedure, the bandsaw is turned ***ON*** to perform fine tuning of the tracking. Make small changes with the blade tracking knob as you monitor the effect on the blade tracking.

To fine tune blade tracking:

1. Close wheel covers and turn bandsaw ***ON***.

2. Observe blade tracking path through clear tracking window on right edge of bandsaw (see **Figures 44–45**).

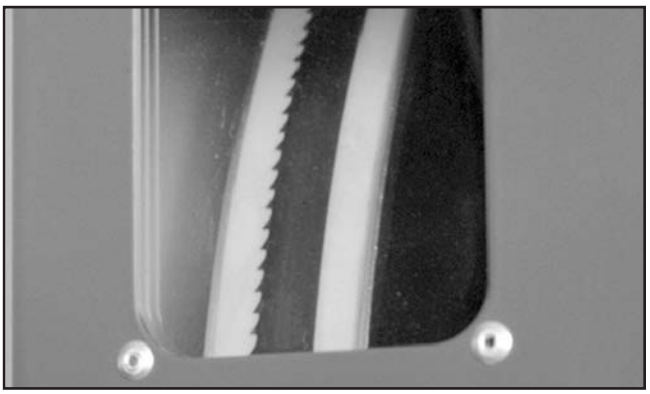


Figure 44. Example of blade, viewed through tracking window.

3. If necessary, loosen tracking control lock lever and use tracking control knob (see **Figure 45**) to adjust the blade so it tracks on the center of the wheel.

4. Tighten tracking control lock lever (see **Figure 45**) to secure setting, then turn machine ***OFF***.

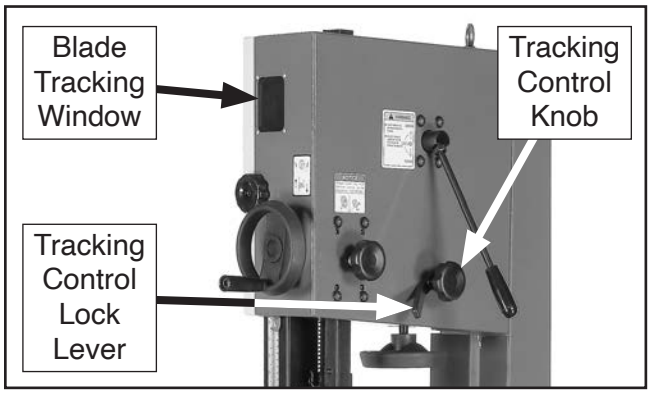


Figure 45. Fine-tune tracking controls.

Adjusting Blade Support Bearings

The support bearings are positioned behind the blade near the blade guides and prevent the blade from pushing backward during cutting operations. Proper adjustment of the support bearings helps you make accurate cuts and prevents the blade teeth from coming in contact with the blade guides while cutting. If this happens, the blade "tooth set" can be ruined, which will greatly reduce the blade's ability to make good cuts.

There are support bearings on the upper and lower blade guide assemblies. Both adjust in the same manner. The following instructions refer to the upper support bearings.

Important: *To ensure best results while cutting, make sure the blade is tracking and tensioned correctly before performing this procedure.*

Tools Needed	**Qty**
Hex Wrench 5mm	1

To adjust support bearing:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen support bearing adjustment screw (see **Figure 46**).

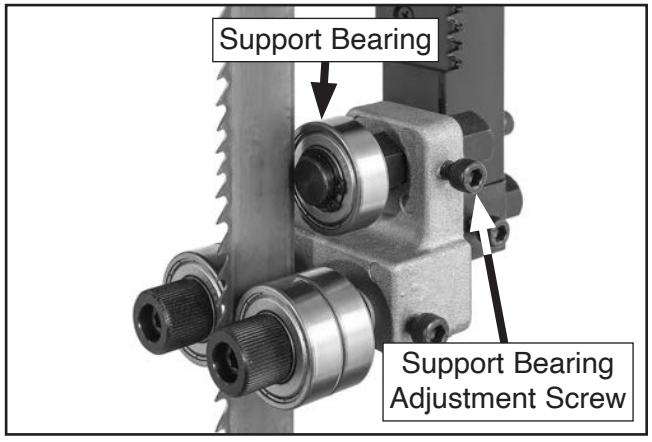


Figure 46. Upper support bearing assembly and controls (guide post cover removed for clarity).

3. Position support bearing approximately 0.016" away from back of blade, as illustrated in **Figure 47**.

   Note: *The main purpose of this adjustment is to prevent the blade from being pushed backward far enough that the blade guides will contact (and ruin) the "tooth set" of the blade during cutting operations.*

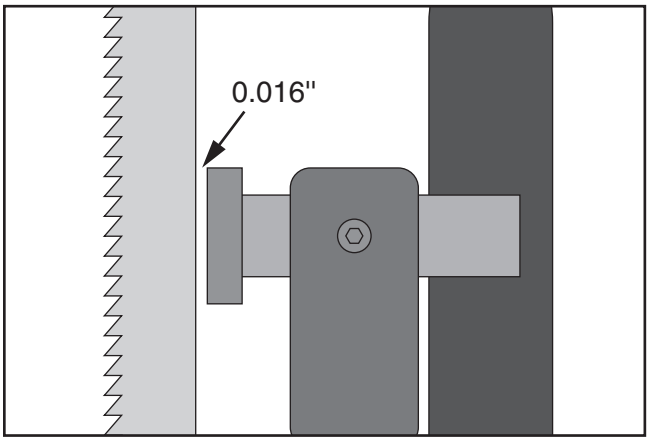


Figure 47. Bearing positioned approximately 0.016" away from back of blade.

4. Tighten adjustment cap screw to lock support bearing in place.

Adjusting Blade Guide Bearings

The blade guide bearings can be adjusted left-to-right, as well as front-to-back, relative to the blade. Properly adjusted blade guide bearings provide side-to-side support, from just behind the gullets to the back of the blade, to help keep the blade straight while cutting.

There are blade guide bearings on the upper and lower blade guide assemblies. Both adjust in the same manner. The following instructions refer to the upper guide bearings.

Important: *Make sure the blade is tracking and tensioned correctly before performing this procedure (see **Tensioning Blade** on **Page 28**).*

Tools Needed	**Qty**
Hex Wrench 5mm	1

To adjust blade guides:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen guide block adjustment cap screw shown in **Figure 48**, then position guide bearings just behind blade gullets, as illustrated in **Figure 49**. Retighten cap screw to secure setting.

   Note: *The guide bearings should be positioned behind the gullets a distance equal to that of the support bearing behind the blade (see **Page 31**).*

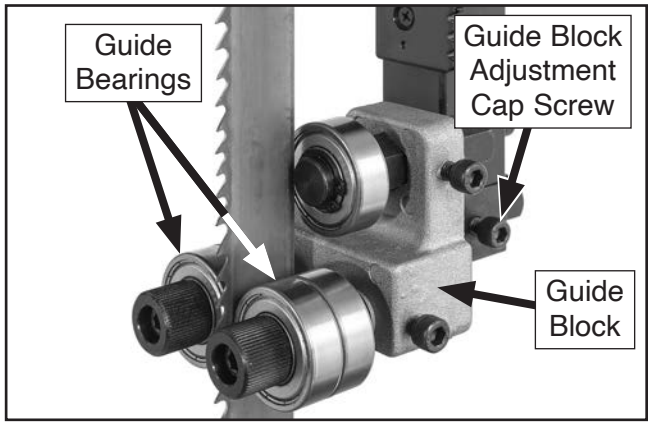


Figure 48. Upper guide bearing components (guide post cover removed for clarity).

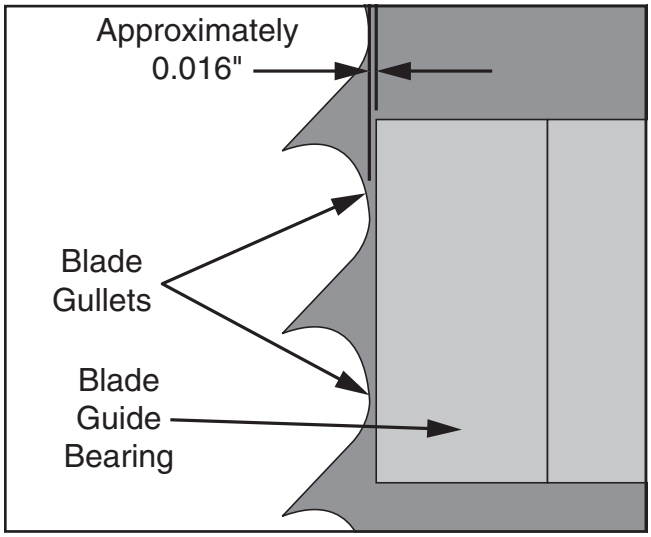


Figure 49. Blade guide bearing positioned just behind blade gullets.

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

NOTICE

Blade teeth are angled out slightly, protruding wider than the blade thickness; this is known as blade "tooth set" (see Figure 50). If angled out parts of the teeth contact guide bearings during operation, they will get bent inward, ruining the tooth set. Therefore, the support bearing must be set to prevent teeth from contacting guide bearings during operation (refer to Page 31 for details).

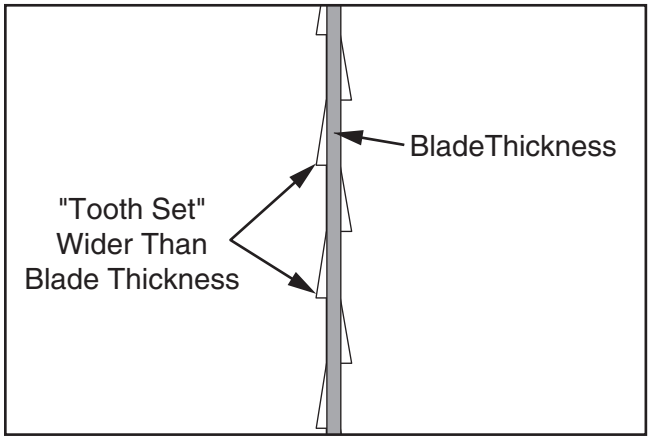


Figure 50. Illustration of blade "tooth set."

3. Loosen both guide bearing adjustment cap screws (see **Figure 51**), then position guide bearings so they are close to—but not quite touching—sides of blade.

   Note: *When the blade guide bearings are properly adjusted, they should only rotate during cutting operations, or when the blade is deflected to the left or right (see* ***Figure*** **52***).*

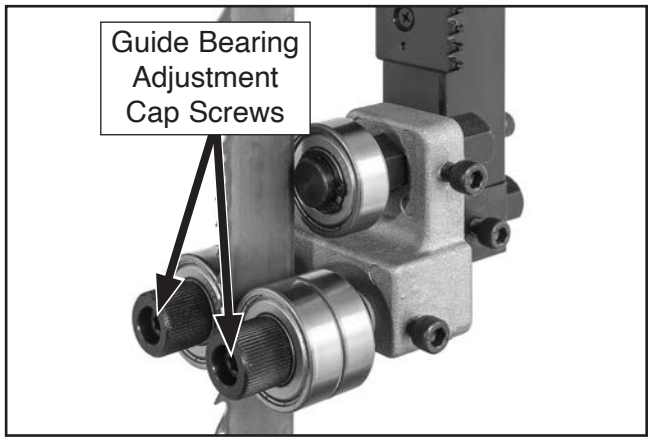


Figure 51. Location of upper guide bearing adjustment cap screws (guide post cover removed for clarity).

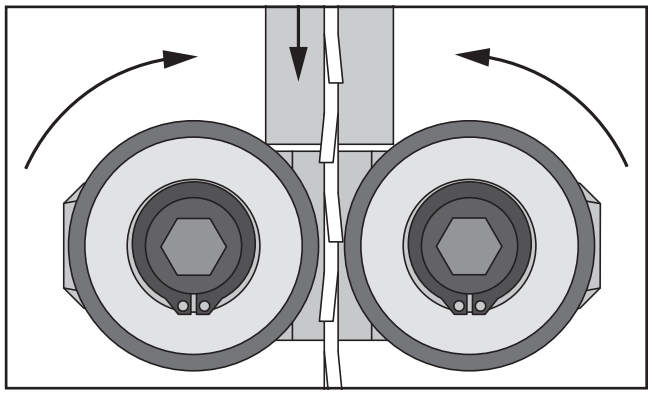


Figure 52. Blade guide bearings rotating during cutting operation.

4. Retighten cap screws to secure settings. Rotate blade by hand to check the setting, and, if necessary, repeat **Steps 3–4**.

NOTICE

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

Installing "Euro-Style" Roller-Disc Guides

Many woodworkers prefer the type of support provided by "Euro-Style" roller-disc guides for certain types of cuts, such as when cutting curves. With these guides, the blade is supported side to side by the larger surface area of the disc faces, rather than the edges of two bearings (see **Figure 53**). These discs also roll with the movement of the blade when contact does occur, thus minimizing any friction against the blade.

Grizzly offers accessory "Euro-Style" Roller-Disc Guides specially designed to fit Model G0817 (see **Accessories** on **Page 51**). Installing these blade guides is relatively easy, though it requires first removing the blade and existing blade guide assemblies.

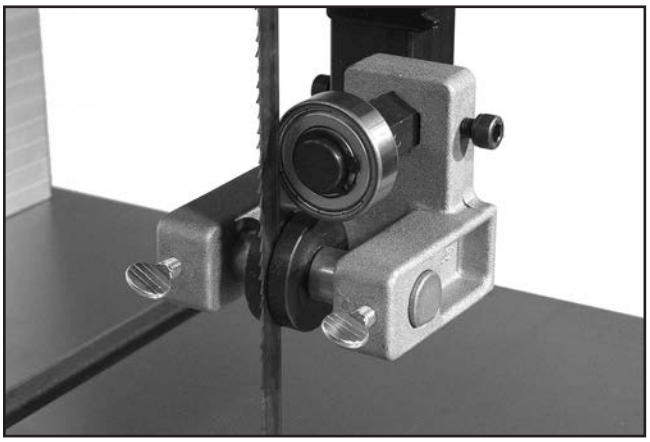


Figure 53. "Euro-style" roller-disc guides installed.

Tools Needed	**Qty**
Hex Wrench 5mm	1

To install "Euro-Style" Roller-Disc Guides:

1. DISCONNECT MACHINE FROM POWER!

2. Remove blade (refer to **Page 46**).

3. Loosen two cap screws on guide post that secure upper blade guide assembly, remove upper blade guide assembly, and replace it with upper "Euro-style" roller-disc guide assembly (see **Figure 54**).

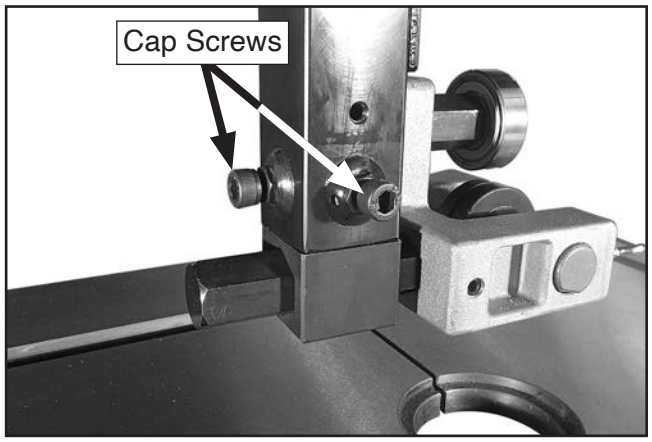


Figure 54. "Euro-style" roller-disc guide assembly installed.

4. Loosen cap screw shown in **Figure 55**, remove lower blade guide assembly, and replace it with lower "Euro-style" roller-disc guide assembly.

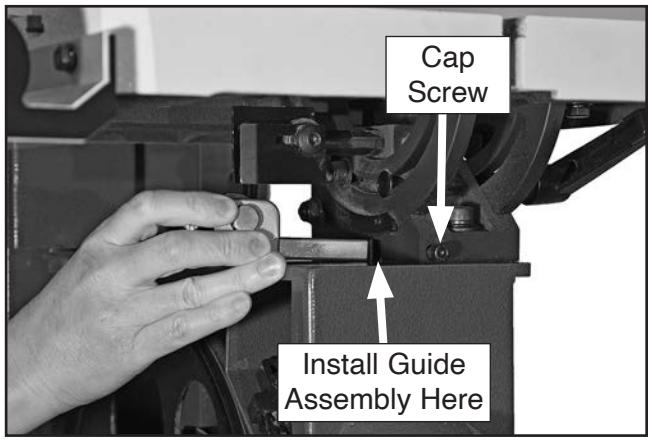


Figure 55. Installing lower "Euro-style" roller-disc guide assembly.

5. Re-install blade (refer to **Page 46**).

6. Proceed to **Adjusting "Euro-Style" Roller-Disc Guides** in next section.

Adjusting "Euro-Style" Roller-Disc Guides

The "Euro-style" roller-discs (see **Figure 56**) can be adjusted left to right, as well as front to back, relative to the blade. Properly adjusted roller-discs provide side-to-side support, from just behind the gullets to the back of the blade, to help keep the blade straight while cutting. There are roller-discs on the upper and lower "Euro-style" roller-disc guide assemblies. Both adjust in the same manner.

Important: *Make sure the blade is tracking and tensioned correctly before adjusting roller disc guides (see **Tensioning Blade** on **Page 28**).*

The "Euro-style" roller-disc guide support bearing (see **Figure 56**) functions in the same way as the support bearing that came with your saw. It is positioned behind the blade near the roller-discs and prevents the blade from pushing backward during cutting operations. To adjust the support bearings, refer to **Page 31** for more detailed instructions.

Important: *Always adjust roller-discs before adjusting roller-disc guide support bearing.*

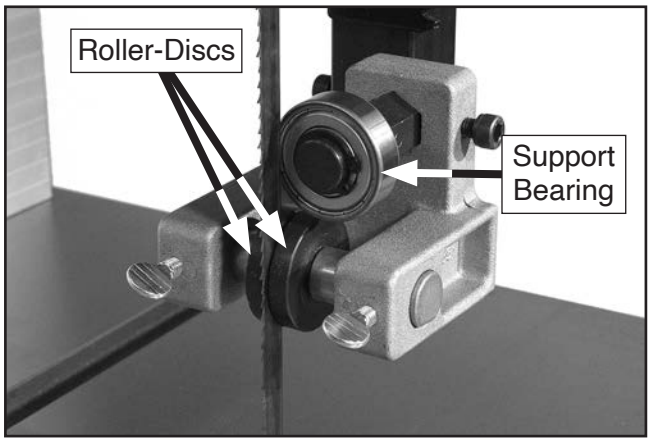


Figure 56. Upper "Euro-style" roller-disc guide assembly.

To adjust "Euro-style" roller-discs:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen guide block adjustment cap screw shown in **Figure 57**, then position roller-discs just behind blade gullets, as illustrated in **Figure 58**. Retighten cap screw to secure setting.

   Note: *The roller-discs should be positioned behind the gullets at a distance equal to that of the support bearing behind the blade (see **Figure 47** on **Page 31**).*

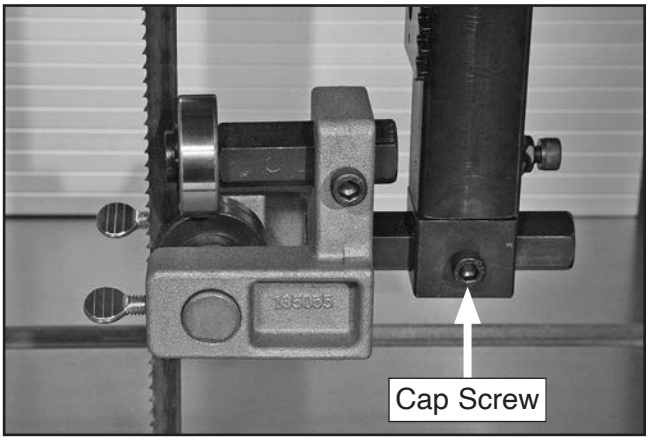


Figure 57. Location of guide block adjustment cap screw (guide post cover removed for clarity).

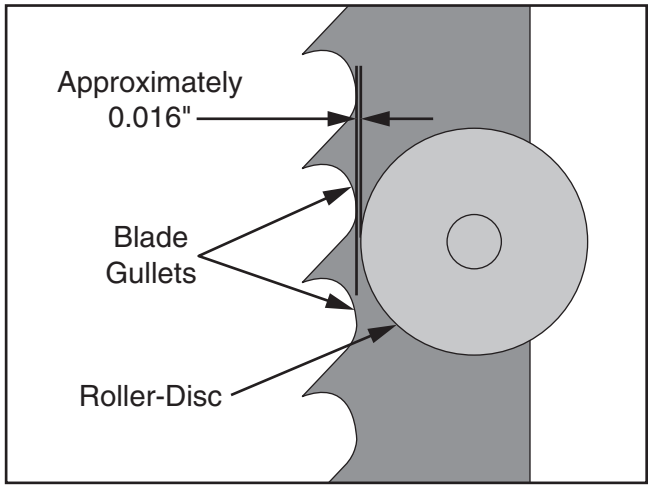


Figure 58. Roller-disc positioned just behind blade gullets.

Note: *With wider blades, it may not be possible to bring the roller-discs just behind the blade gullets. Position them as far forward as possible without allowing the roller-disc housing to touch the back of the blade.*

NOTICE

Blade teeth are angled out slightly, protruding wider than the blade thickness; this is known as blade "tooth set" (see Figure 59). If angled out parts of the teeth contact roller-discs during operation, they will get bent inward, ruining the tooth set. Therefore, the support bearing must be set to prevent teeth from contacting roller-discs during operation (refer to Page 31 for details).

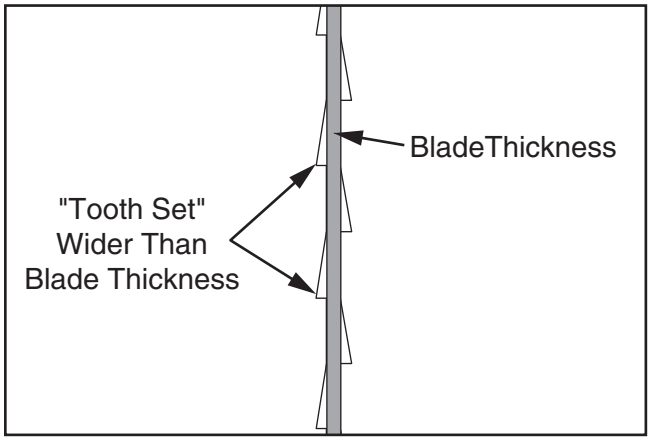


Figure 59. Illustration of blade "tooth set."

Continued on next page ➔

3. Loosen both roller-disc adjustment thumb screws (see **Figure 60**), then position roller-discs so they are close to—but not quite touching—sides of blade.

   Note: *When the roller-discs are properly adjusted, they should only contact the blade during cutting operations, or when the blade is deflected to the left or right. The discs may or may not rotate during operations.*

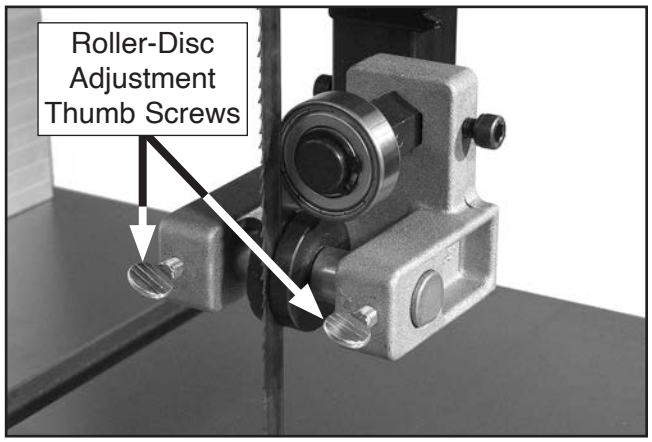


Figure 60. Location of upper roller-disc adjustment thumb screws (guide post cover removed for clarity).

4. Retighten thumb screws to secure settings. Rotate blade by hand to check setting, and if necessary, repeat **Steps 3–4**.

NOTICE

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

Aligning Table

To ensure cutting accuracy, the table should be aligned so that the miter slot is parallel to the bandsaw blade, and that the table is perpendicular (front to back) to the blade. These procedures work best with a wide (¾") blade installed.

Tools Needed	Qty
Straightedge	1
Fine Ruler	1
Square	1
Wrench or Socket 13mm	1

Adjusting Miter Slot Parallelism

1. Make sure blade is tracking properly and that it is correctly tensioned (refer to **Pages 25** & **28**).

2. DISCONNECT MACHINE FROM POWER!

3. Place an accurate straightedge along blade so that it lightly touches both front and back of blade without going across a tooth (see **Figure 61**).

4. Use a fine ruler to measure distance between straightedge and miter slot (see **Figure 61**). Distance should be the same at front and back of table.

   — If the distance *is* the same at the front and back of the table, no adjustment is necessary; proceed to **Adjusting Table Perpendicular to Blade** on **Page 37**.

   — If the distance *is not* the same at the front and back of the table, it must be adjusted; proceed to **Step 5**.

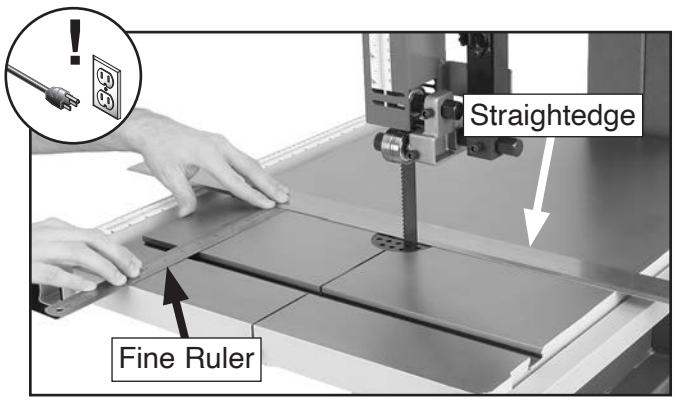


Figure 61. Checking miter slot parallelism.

5. Loosen trunnion bolts that secure table (see **Figure 62**).

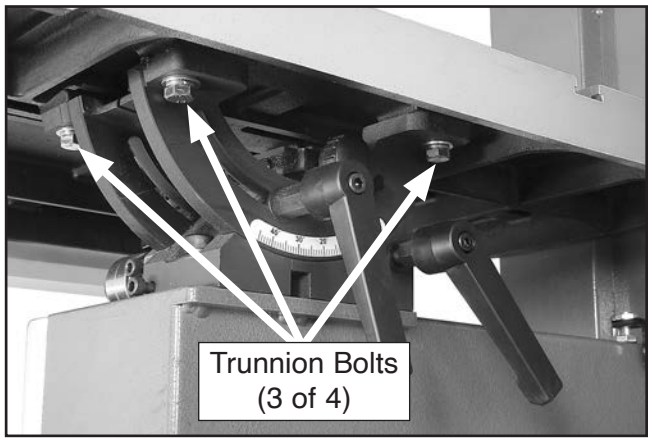


Figure 62. Location of trunnion bolts.

6. Adjust table until distance between straightedge and miter slot is the same at front and back of table.

7. Retighten trunnion bolts, then repeat **Step 4** to verify adjustment.

Adjusting Table Perpendicular to Blade

1. DISCONNECT MACHINE FROM POWER!

2. Place a square on table and against back of blade, as illustrated in **Figure 63**. Table should be perpendicular to back of blade.

   — If the table *is* perpendicular to the back of the blade, no adjustment is necessary; proceed to **Aligning Fence** on **This Page**.

   — If the table *is not* perpendicular to the back of the blade, you must shim the table; proceed to **Step 3**.

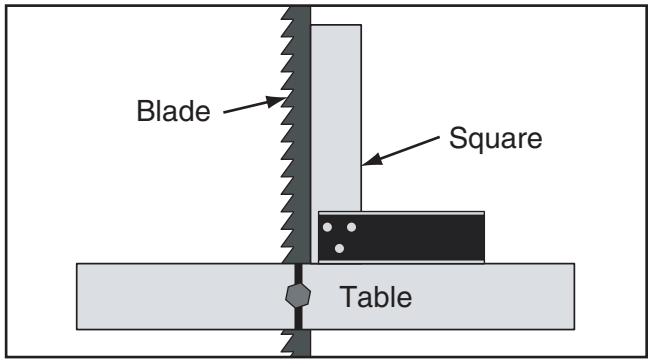


Figure 63. Squaring back of blade and table.

3. Determine which trunnion is on low side of table, then remove two trunnion bolts (see **Figure 62**) from low trunnion.

4. Insert a shim, such as a thin washer, between table and low trunnion at each mounting location.

5. Re-install and tighten trunnion bolts, then repeat **Step 2** to verify adjustment.

Aligning Fence

To ensure cutting accuracy, the fence should be aligned parallel with the blade. This is achieved by aligning the fence to the miter slot *after* miter slot parallelism is properly adjusted, as instructed on **Page 36**.

Note: *Occasionally, even after aligning the fence, a symptom known as "blade lead" will develop, requiring the fence to be skewed slightly to compensate for the blade lead problem. Refer to* ***Blade Lead****, beginning on* ***Page 61*** *for more information on blade lead and skewing the fence.*

Tools Needed	**Qty**
Hex Wrench 5mm	1

To align fence:

1. DISCONNECT MACHINE FROM POWER!

2. Make sure table is aligned with blade (see **Adjusting Miter Slot Parallelism** on **Page 36** for detailed instructions).

3. Install fence next to miter slot (see **Figure 64**).

4. Loosen four cap screws located to the left of fence face (see **Figure 64**).

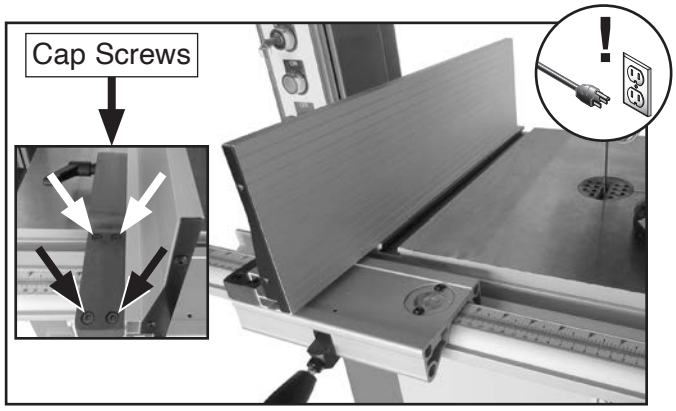


Figure 64. Fence installed next to miter slot for alignment adjustment.

5. Adjust fence face parallel with edge of miter slot, then retighten the four cap screws, being careful not to move fence.

6. Re-check fence alignment and, if necessary, repeat **Steps 4–5**.

Calibrating Miter Gauge

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

Tools Needed	**Qty**
Phillips Screwdriver #2	1
Square	1

To calibrate miter gauge:

1. DISCONNECT MACHINE FROM POWER!

2. Place one edge of square against face of miter gauge and other edge of square against blade side, as shown in **Figure 65**.

   Note: *Make sure square does not go across a blade tooth when performing this step.*

   — If square rests flush and evenly against *both* miter gauge face *and* blade side, then no adjustments are necessary.

   — If square *does not* rest flush and evenly against *both* miter gauge face *and* blade side, the miter gauge must be calibrated; proceed to **Step 5**.

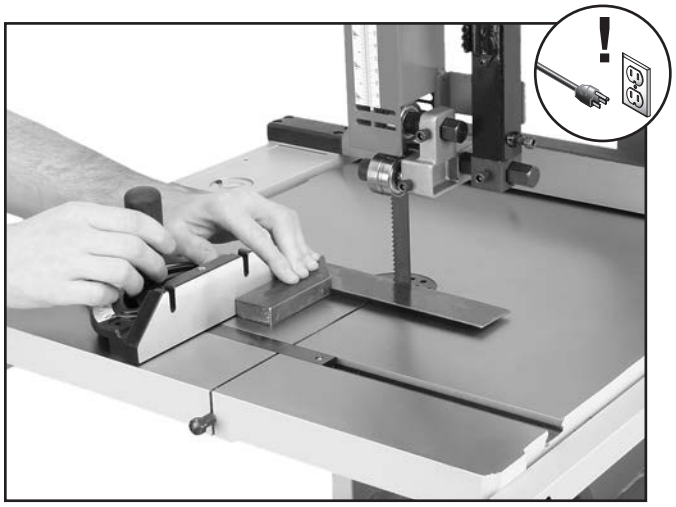


Figure 65. Example of squaring miter gauge to blade.

3. Loosen lock knob on miter gauge and adjust face flush with edge of square.

4. Tighten lock knob, and verify square rests flush and evenly against *both* miter gauge face *and* blade side.

   Note: *Sometimes the tightening procedure can affect the adjustment.*

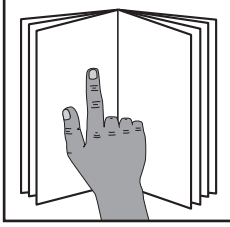
5. Loosen screw that secures angle pointer, adjust pointer to 0° mark on scale, then retighten screw to secure setting.

SECTION 4: OPERATIONS

Operation Overview

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

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

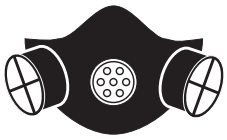


⚠WARNING

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

⚠WARNING

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



NOTICE

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

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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts table tilt, if necessary, to correct angle of desired cut.
3. If using fence, adjusts it for width of cut and then locks it in place. If using miter gauge, adjusts angle and locks it in place.
4. Loosens guide post lock knob, adjusts upper blade guide height to just clear the workpiece (no more than ¼"), then retightens guide post lock knob.
5. Checks to make sure workpiece can safely pass all the way through blade without interference from other objects.
6. Puts on safety glasses and respirator.
7. Starts dust collector and bandsaw.
8. Holds workpiece firmly and flatly against both table and fence (or miter gauge), and then pushes workpiece into blade at a steady and controlled rate until cut is complete.

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

Basic Functions of a Bandsaw

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

Straight Cuts

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

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

Basic Cutting Tips

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

- Replace, sharpen, and clean blades often for best performance. Check guides, tension, and alignment settings periodically and adjust when necessary to keep the saw running in top condition.

- Use light and even pressure while cutting. Light feeding pressure makes it easier to cut straight and prevents undue friction or strain on the bandsaw components and the blade.

- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw its way around the corners. Always use relief cuts when possible.

- Misusing the saw or using incorrect techniques (e.g. twisting the blade with the workpiece, incorrect feed rate, etc.) is unsafe and results in poor cuts.

Workpiece Inspection

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

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a bandsaw may lead to injury.

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

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

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

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

Setting Upper Blade Guide Height

When cutting, the blade guides must always be positioned so they just clear (no more than ¼") the workpiece. The guide post, shown in **Figure 66**, allows the upper blade guide assembly to be quickly adjusted for height.

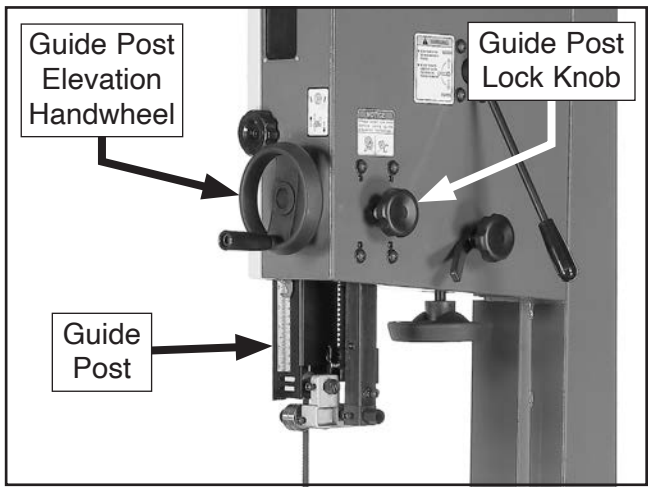


Figure 66. Location of guide post, elevation handwheel, and lock knob.

To adjust height of upper blade guides:

1. DISCONNECT MACHINE FROM POWER!
2. Loosen guide post lock knob.
3. Use guide post elevation handwheel to adjust height of guide post so that blade guide assembly just clears (no more than ¼") workpiece.
4. Retighten lock knob to secure setting.

Blade Selection

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

Blade Terminology

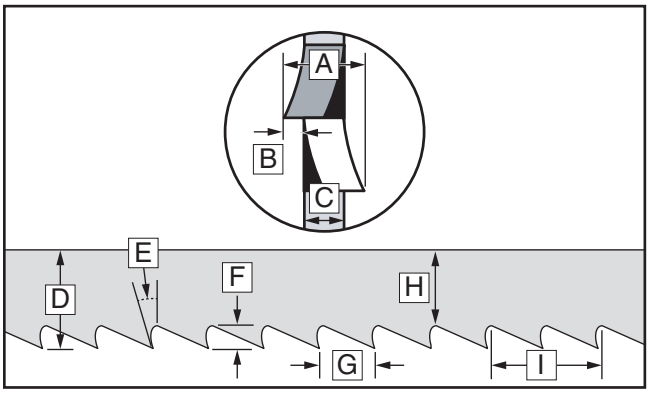


Figure 67. Bandsaw blade components.

A. Kerf: The amount of material removed by the blade during cutting.

B. Tooth Set: The amount each tooth is bent left or right along the blade.

C. Gauge: The thickness of the blade.

D. Blade Width: The widest point of the blade measured from the tip of the tooth to the back edge of the blade.

E. Tooth Rake: The angle of the tooth face from a line perpendicular to the length of the blade.

F. Gullet Depth: The distance from the tooth tip to the bottom of the curved area (gullet).

G. Tooth Pitch: The distance between tooth tips.

H. Blade Back: The distance between the bottom of the gullet and the back edge of the blade.

I. TPI: The number of teeth per inch measured from gullet to gullet.

Blade Dimensions

Length Range..... 120"–120½"
Width Range..... ⅛"–¾"

Blade Length

Measured by the blade circumference, blade lengths are specific to each bandsaw. They are determined by the wheel diameter and distance between the wheels. Blades will vary slightly even in the same length because of how they are welded. Refer to the **Accessories** section later in this manual for blade replacements from Grizzly.

Blade Width

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

- **Curve Cutting:** Use the chart in **Figure 68** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width (refer to **Cutting Curves** on **Page 50** for more information).

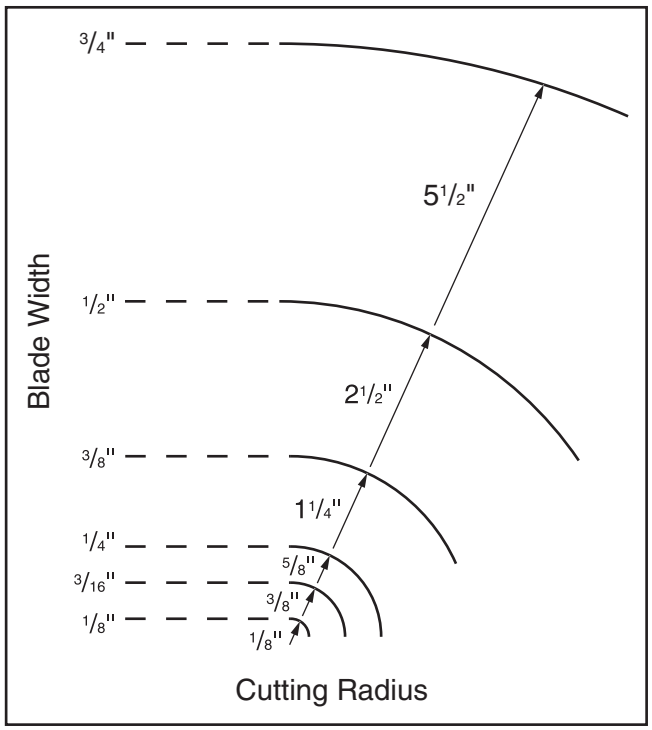


Figure 68. Recommended cutting radius per blade width.

- **Straight Cutting:** Use the largest width blade that you own. Large blades excel at cutting straight lines and are less prone to wander (known as blade lead—refer to **Page 61** for more information on blade lead).

Tooth Style

Figure 69 illustrates the three main blade tooth styles:

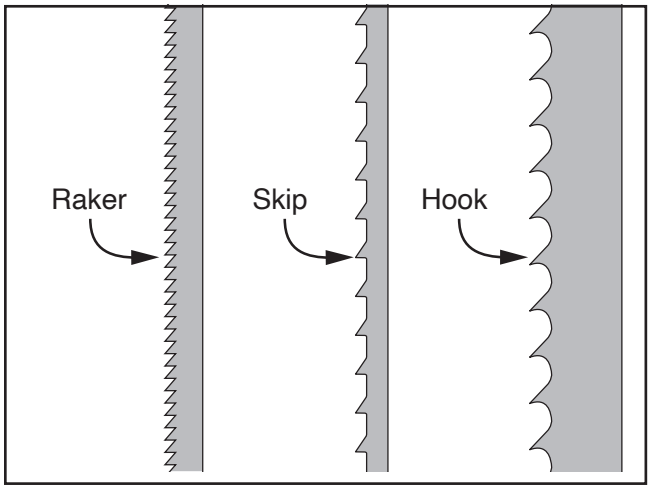


Figure 69. Main blade tooth styles.

- **Raker**: Considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material. As a result, smooth cuts can be achieved without cutting fast or generating more heat than other tooth types.

- **Skip**: Similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades.

- **Hook**: The teeth have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

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

Tooth Set

Two common tooth sets for wood bandsaw blades are alternate and raker. Each different type of tooth set removes material in a different manner, leaving cuts with different characteristics (see **Figure 70**).

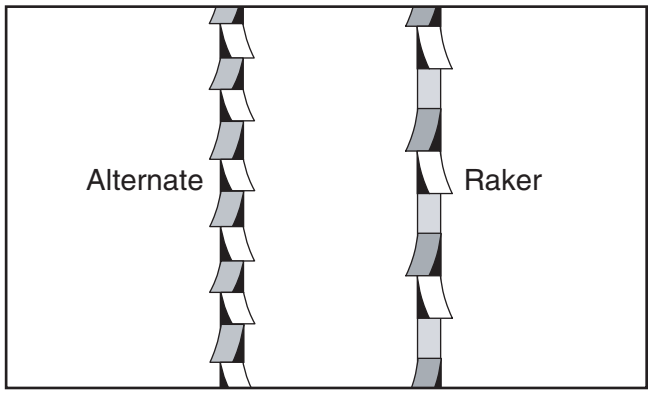


Figure 70. Common woodcutting bandsaw blade tooth sets.

- **Alternate:** An all-purpose arrangement where the teeth are bent evenly left and right of the blade.
- **Raker:** Three teeth in a recurring group—one bent left, one bent right, and then one that is not bent. The raker set is ideal for most contour cuts.

Blade Material

Bandsaw blades must meet two requirements: flexibility and hardness. The flexibility of a blade allows it to travel on the wheel as a band, while hardness allows the teeth to cut and hold an edge. Modern materials technology has allowed bandsaw blades to meet these requirements in various ways.

Carbon Steel: These blades are differentially heat treated to provide hard teeth that will hold an edge, and yet be flexible in the back.

Carbide Tooth: Extremely hard carbide is either welded onto or impregnated into the carbon steel blades, providing superior edge-holding characteristics (see **Figure 71**).

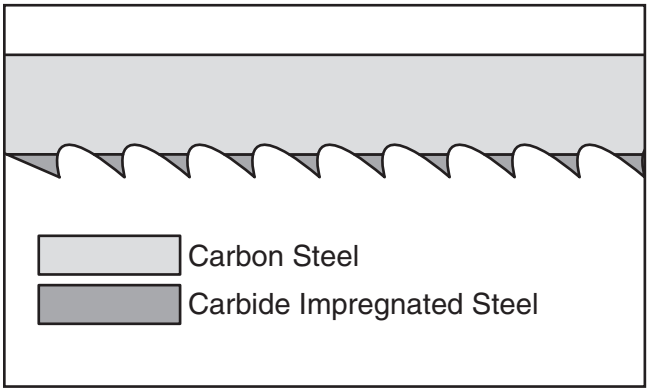


Figure 71. Carbide-tooth blade composition.

Bi-metal Blade: A strip of high-speed tool steel is precision welded to a flexible carbon blade, then teeth are ground into the blade to provide good edge-holding qualities for blades taking a lot of abuse (see **Figure 72**).

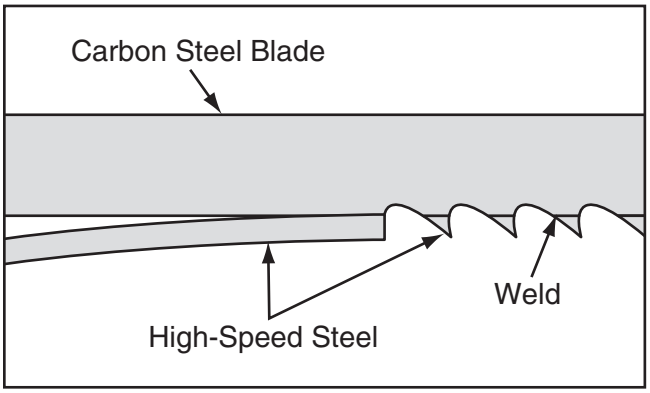


Figure 72. Bi-metal blade composition.

Blade Selection Chart

Use the blade selection chart below as a general guide when selecting a blade for your operation.

Cutting Operation	Blade Width		
	Narrow (⅛" –¼")	Medium (3/16"– ½")	Wide (½"– ¾")
Resawing			H C
Ripping Thin Stock			H M
Ripping Thick Stock			H C
Ripping Round Stock		R M	R M
Crosscutting Thin Stock			R F
Crosscutting Thick Stock			R M
Crosscutting Round Stock		R F M	R F M
Miter Cut			R F M
Tenons		R M	R M
Sharp Curves	R F		
Gradual Curves		S F M	

Key					
Tooth Type			Tooth Pitch (Teeth Per Inch or TPI)		
H	R	S	F	M	C
Hook	Raker	Skip	Fine (14-32 TPI)	Medium (4-12 TPI)	Coarse (2-4 TPI)

Blade Care & Break-In

Blade Care

A bandsaw blade is a thin piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, set, type, and pitch for each application. Using the wrong blade will produce unnecessary heat and shorten the life of the blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

Blade Break-In

The tooth tips and edges of a new blade are extremely sharp, and cutting at too fast of a feed rate fractures the beveled edges of the teeth and causes premature blade wear.

To properly break in a new blade:

1. Choose correct speed for blade and material of operation.

2. Reduce feed pressure by half for first 50–100 in^2 of material cut.

3. To avoid twisting blade when cutting, adjust feed pressure when total width of blade is in cut.

Blade Breakage

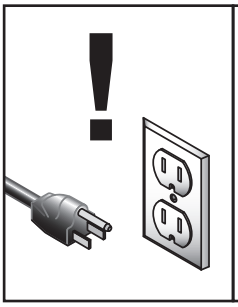
Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to.

Blade breakage is also due to avoidable circumstances. Avoidable blade breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Faulty alignment or adjustment of the blade guides.
- Forcing or twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull or damaged teeth.
- Over-tensioned blade.
- Upper blade guide assembly set too high above the workpiece. Adjust the top blade guide assembly so that there is approximately ⅛"–¼" between the bottom of the assembly and the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Leaving the blade tensioned when not in use.
- Using the wrong pitch (TPI) for the workpiece thickness. The general rule of thumb is to have no less than two teeth in contact with the workpiece at all times during cutting.

Changing Blade



⚠WARNING

Disconnect bandsaw from power BEFORE changing blade. Serious personal injury could occur if machine is started during this procedure.

⚠CAUTION

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

Blade changes entail removing the existing blade, installing the new blade, then properly adjusting the blade tension, tracking, and guides.

Removing Blade

1. DISCONNECT MACHINE FROM POWER!

2. Release blade tension by rotating blade tension quick-release lever (see **Figure 73**) clockwise to up position.

3. Remove table insert and table pin. Adjust upper and lower guide bearings as far away as possible from blade (see **Figure 73**).

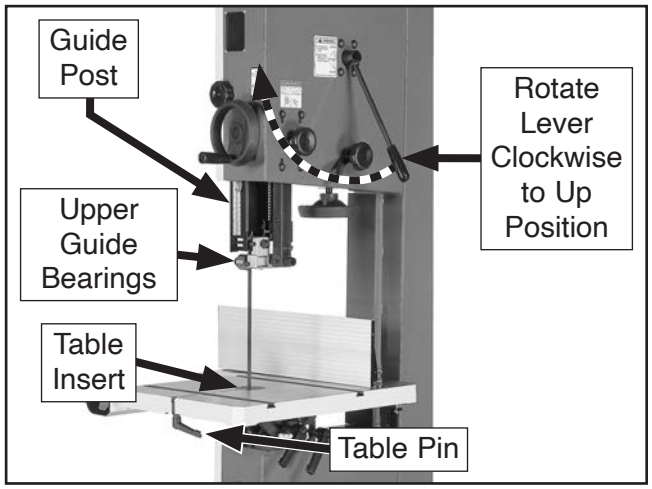


Figure 73. Blade changing controls.

4. Open upper and lower wheel covers and blade cover on guide post, then with gloved hands, slide blade off of both wheels.

5. Rotate blade 90˚ and slide it through slot in table to remove it.

Installing Blade

1. DISCONNECT MACHINE FROM POWER!

2. Slide blade through table slot, ensuring that teeth are pointing down toward front of table.

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

3. Slip blade through blade guides, and mount it on upper and lower wheels (see **Figure 74**).

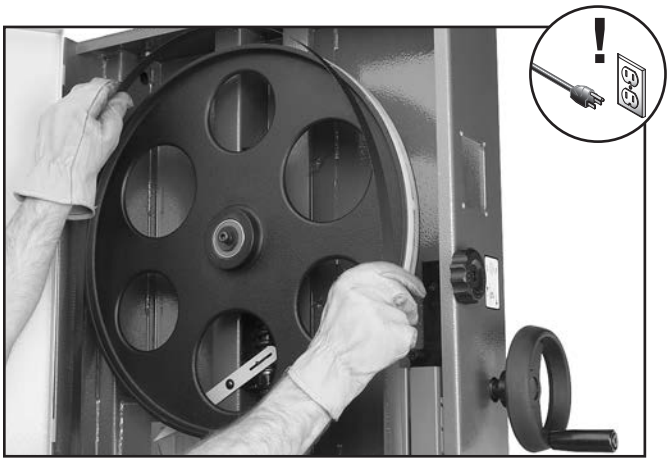


Figure 74. Example of placing blade on upper wheel.

4. Rotate blade tension quick-release lever counterclockwise to down position.

5. Adjust blade tension (refer to **Page 28**) and blade tracking (refer to **Page 30**).

6. Adjust upper/lower guide bearings and support bearings (refer to instructions beginning on **Page 31**).

7. Close and secure wheel covers and guide post blade cover, and re-install table insert and table pin.

8. If necessary, adjust blade tension quick-release lever (refer to **Page 62** for more information).

Tilting Table

The table can be tilted from 5° left–45° right to make beveled cuts. A table tilt scale with pointer is provided on the trunnion, and a positive stop is provided for quickly returning the table back to 0° from a right-tilt setting (see **Figure 75**).

Note: *The tilt scale on the trunnion serves as a guide only. For more accurate results use a bevel gauge or protractor to set the desired table tilt relative to the blade.*

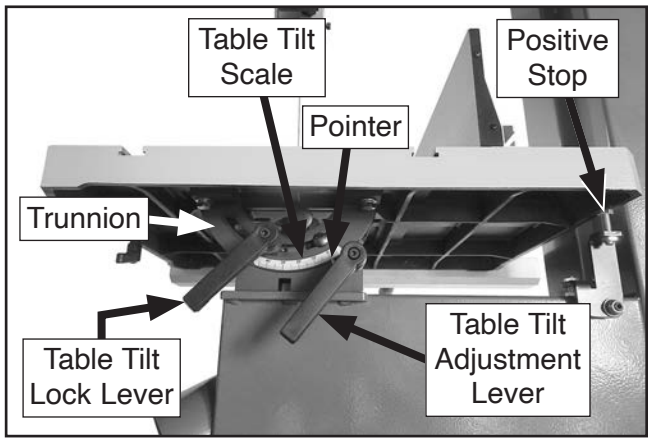


Figure 75. Table tilt controls.

Tilting Table

1. DISCONNECT MACHINE FROM POWER!

2. Loosen table tilt lock lever (see **Figure 75**).

3. Rotate table tilt adjustment lever until table reaches desired angle, then retighten lock lever.

Using Positive Stop

The positive stop (see **Figure 76**) allows you to quickly return the table to 0 from a right-tilt setting. The stop can be set to the up position for use, or set to the down position if you choose not to use it. In addition, the positive stop is adjustable, allowing for calibration, or if desired, minor deviations from 0.

To use positive stop:

1. DISCONNECT MACHINE FROM POWER!

2. Tilt table to approximately 10° right-tilt (see **Figure 76**).

3. Rotate positive stop to up position (see **Figure 76**).

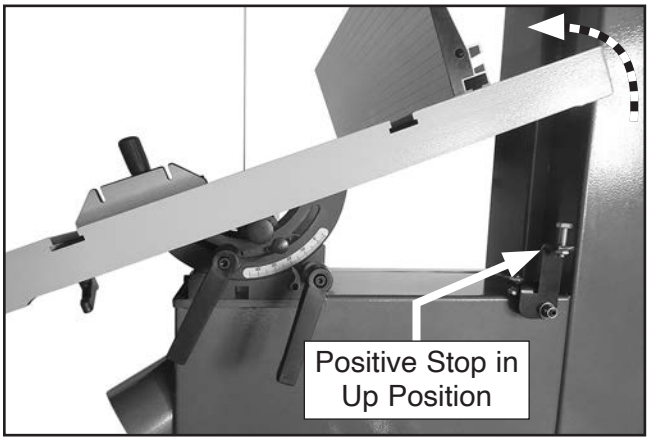


Figure 76. Table tilted to approximately 10°.

4. Tilt table down until it rests on positive stop, then tighten table tilt lock lever.

   Note: *It is always a good idea to check the table tilt scale and make sure the positive stop is calibrated. See* ***Checking/ Calibrating Positive Stop*** *on* ***Page 48*** *for more information.*

Checking/Calibrating Positive Stop

Tools Needed	Qty
Wrench or Socket 13mm	1

To check/calibrate positive stop:

1. Tilt table to approximately 10° right-tilt.

2. Set positive stop to up position (see **Figure 76**).

3. Test positive stop setting by tilting table all the way left.

   — If table stops at 0, no further adjustments are necessary.

   — If table does not stop at 0, proceed to **Step 4**.

4. Loosen jam nut, then rotate adjustment bolt until table contacts bolt when at 0 (see **Figure 77**).

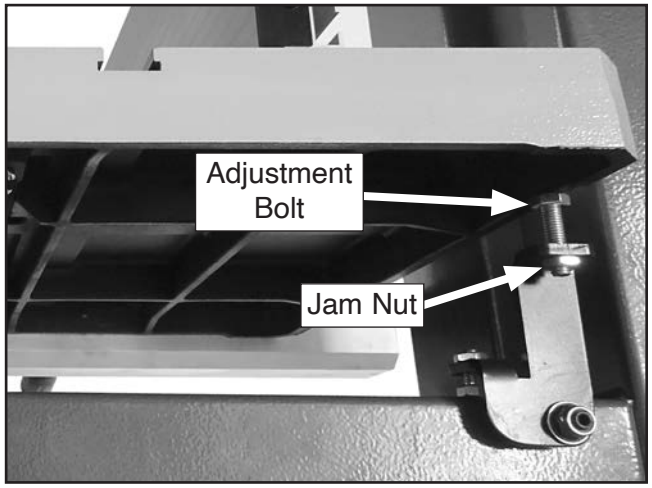


Figure 77. Positive stop in up position.

5. Repeat **Step 3** to test adjustment. If necessary, repeat **Step 4**.

   Note: *If you wish to set the positive stop to an angle other than 0, follow **Steps 1–5** for the desired angle.*

Ripping

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

To make a rip cut:

1. Adjust fence to match width of cut on your workpiece, then lock fence in place.

2. Adjust blade guide assembly to proper height above workpiece.

3. After all safety precautions have been met, turn bandsaw ***ON*** and wait for it to come to full speed. Slowly feed workpiece into blade until blade is completely through workpiece. **Figure 78** shows an example of a ripping operation.

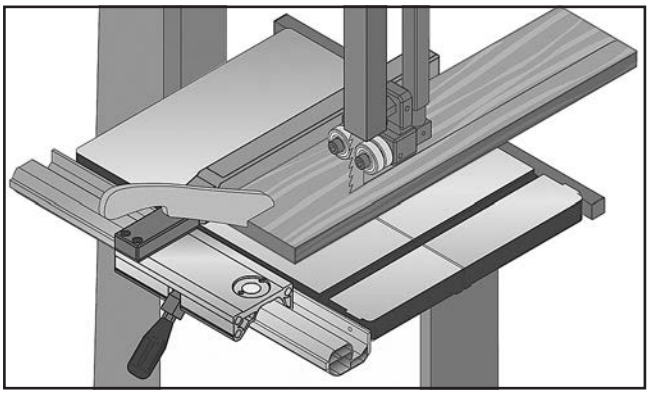


Figure 78. Example of a ripping operation.

⚠WARNING

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

⚠WARNING

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

Crosscutting

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

To make a crosscut:

1. Mark workpiece on edge where you want to begin cut.

2. Adjust blade guide assembly to proper height above workpiece.

3. Adjust miter gauge to correct angle needed for cut.

4. Move fence out of the way. Place workpiece evenly against miter gauge, then line up mark with blade.

5. After all safety precautions have been met, turn bandsaw ***ON*** and wait for it to come to full speed. Slowly feed workpiece into blade until blade is all the way through workpiece. **Figure 79** shows an example of a crosscutting operation.

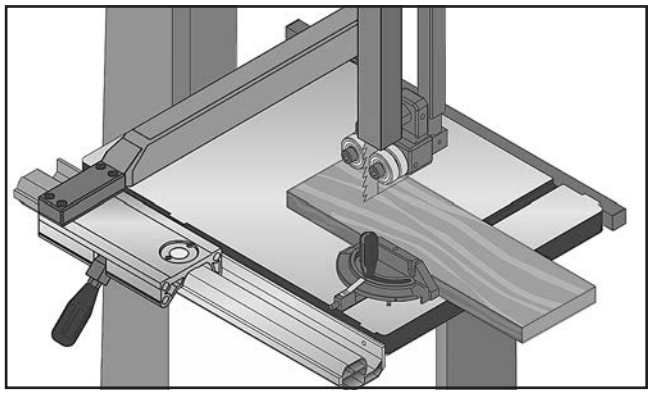


Figure 79. Example of a crosscutting operation with the miter gauge.

Resawing

"Resawing" means cutting the thickness of a board into two or more thinner boards (see **Figure 80** for an example). The maximum height of a board that can be resawn is limited by the maximum cutting height of the bandsaw.

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

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

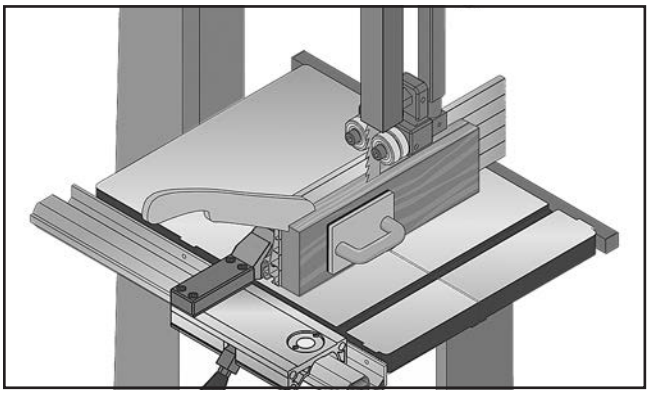


Figure 80. Example of a resawing operation.

⚠WARNING

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

Cutting Curves

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

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

NOTICE

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

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

Stacked Cuts

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

To complete a stacked cut:

1. Align workpieces from top to bottom.

2. Secure all pieces together in a manner that will not interfere with cutting. Hot gluing along edges works well, as does brad nailing through waste portion. (Be careful not to cut into brads or you may break blade!)

3. Lay out shape you intend to cut on face of top piece.

4. Make relief cuts perpendicular to outline of your intended shape in areas where changes in blade direction could strain woodgrain or cause blade to bind.

5. Cut stack of pieces along your layout line as though you were cutting a single piece (see **Figure 81** for an example of a stacked cut setup).

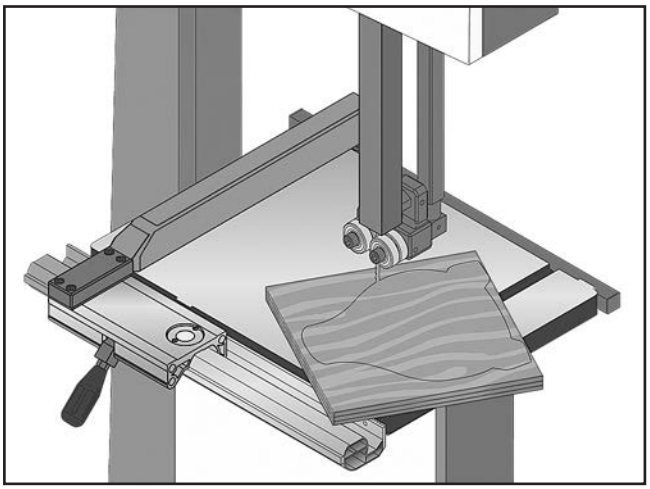


Figure 81. Example of a stacked cut setup.

SECTION 5: ACCESSORIES

⚠WARNING

Installing unapproved accessories may cause machine to malfunction, resulting in serious personal injury or machine damage. To reduce this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

120" Replacement Blades

Model	Width	TPI	Type	Gauge
T27855	1/8"	14	Raker	0.025
T27856	1/8"	18	Raker	0.025
T27866	3/8"	6	Hook	0.025
T27871	1/2"	6	Hook	0.025
T27872	1/2"	10	Raker	0.025
T27873	1/2"	14	Raker	0.025
T27874	3/4"	3	Hook	0.032
T27875	3/4"	6	Hook	0.032

W1015—4" Y Fitting

Y's are used to attach branch lines to service more than one dust port. This design provides increased lateral air flow and efficiency over other types of fittings. These popular fittings are made with an anti-static additive. Size: 4" x 4" x 4" OD.

Figure 82. W1015 4" Y Fitting.

T27908—"Euro-Style" Roller-Disc Guides

Convert your G0817 blade guides to "Euro-Style" with these easy-to-install upper and lower blade guide assemblies. Just loosen the screws that hold the old assemblies in place and swap them out with these replacements.

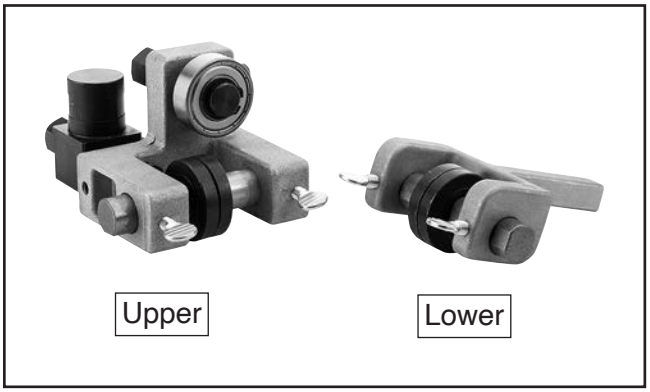


Figure 83. T27908 "Euro-Style" Roller-Disc Guides.

G1029Z2P—2HP Dust Collector

The great combination of price and performance make this one of the most popular dust collectors we sell. Perfect for use as a central dust collector in a small shop or as a "dedicated" dust collector next to an industrial machine. Features 220V single-phase power, 1550 CFM, 2.5 micron filtration, and a 6" main inlet w/included 4" x 2" "Y" fitting.

Figure 84. G1029Z2P 2HP dust collector.

D2057A—Heavy-Duty Mobile Base
This patented base is the most stable on the market with outrigger type supports. Adjusts from 20" x 20½" to 29½" x 29½". 700 lb. capacity. Weighs 47 lbs.

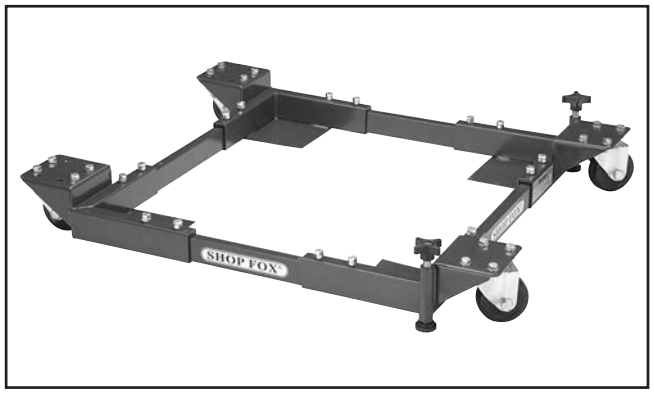


Figure 85. D2057A Mobile Base.

T26544—LED Light with 30 lb. Mag Base and Flexible Arm
This high-intensity LED worklight features a powerful magnetic base and a 9" flexible clamp arm, allowing you to mount this wherever you need light. It's also removable, doubling as a flashlight! This ultra-bright, zoomable light has three modes: high beam, low beam, and an emergency flash. The fish eye lens is 1x2000 zoom. Includes the LED light, base, and 3 AAA batteries.

Figure 86. T26544 LED Light with 30 lb. Mag Base and Flexible Arm.

D2272—Tilting Roller Stand
Adjusts from 26" to 44", 0º-45º. 150 lb. capacity.
D2273—Single Roller Stand
Adjusts from 26 ⅝" to 45". 250 lb. capacity.
D2274—5 Roller Stand
Adjusts from 26" to 44⅝". 250 lb. capacity.
These super heavy-duty roller stands feature convenient hand knobs for fast height adjustment.

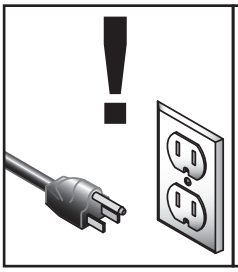
Figure 87. Accessory roller stands.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 Oz. Spray

Figure 88. Recommended products for protecting unpainted cast iron/steel part on machinery.

SECTION 6: MAINTENANCE



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Schedule

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

Daily Check:
- Loose mounting bolts.
- Worn or damaged saw blade.
- Worn or damaged wires.
- Check/clean wheel brush.
- Clean/protect table surface.
- Check lubrication points.
- Any other unsafe condition.

Monthly Check:
- V-belt tension, damage, or wear.
- Clean/vacuum dust build-up from inside cabinet and off motor.

Wheel Brushes

The bandsaw is equipped with lower wheel brushes to keep saw dust from building up on the tire. The brushes should be checked daily and cleaned when they become dirty.

There are adjustment brackets that allow the brushes to be adjusted for bristle wear (refer to **Adjusting Wheel Brushes** on **Page 62** for detailed instructions).

Cleaning & Protecting

Cleaning the bandsaw is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron surfaces on the table by wiping it clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep the table rust-free with regular applications of products like SLIPIT® (see **Accessories** on **Page 52** for more details).

Lubrication

An essential part of lubrication is cleaning the components before lubricating them. This step is critical because dust and chips build up on lubricated components, which makes them hard to move. Simply adding more grease to built-up grime will not result in smooth moving parts. Clean the components in this section with an oil/grease solvent cleaner or mineral spirits before applying lubrication.

All bearings are sealed and permanently lubricated. Leave them alone until they need to be replaced.

Guide Post Rack

Lubrication Type ... NLGI#2 Grease or Equivalent
Amount .....Thin Coat
Frequency..... As Needed

To lubricate guide post rack and pinion:

1. DISCONNECT MACHINE FROM POWER!

2. Lower guide post all the way.

3. Use a rag and mineral spirits to wipe off any grease and sawdust build-up on rack (see **Figure 89**).

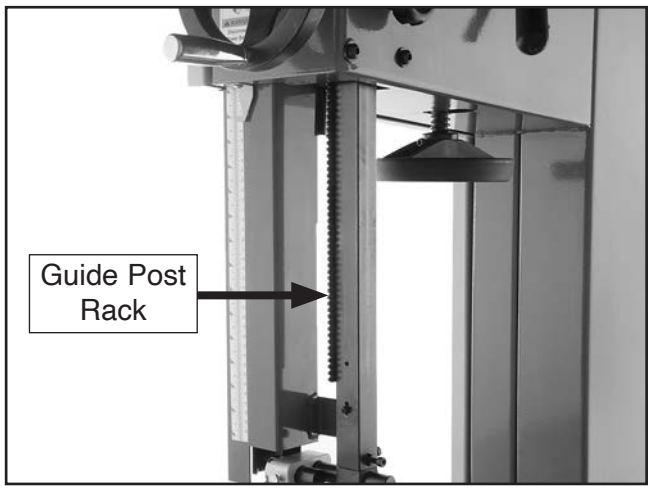


Figure 89. Guide post rack exposed for lubrication.

4. Apply a thin coat of lubricant to rack.

5. Move guide post up and down several times to distribute lubricant, then remove any excess grease to help reduce potential sawdust build-up.

Blade Tension Adjustment Assembly

Lubrication Type ... NLGI#2 Grease or Equivalent
Amount .....Thin Coat
Frequency..... As Needed

To lubricate tension adjustment assembly:

1. DISCONNECT MACHINE FROM POWER!

2. Open upper wheel cover and look through top of wheel (see **Figure 90**).

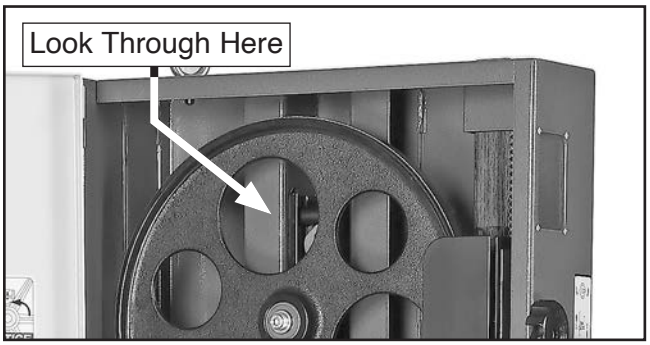


Figure 90. Location of blade tension adjustment assembly.

3. Use a rag and mineral spirits to wipe off any grease and sawdust build-up on blade tension adjustment assembly and tension lever cam (see **Figure 91**), then apply thin coat of lubricant to these areas.

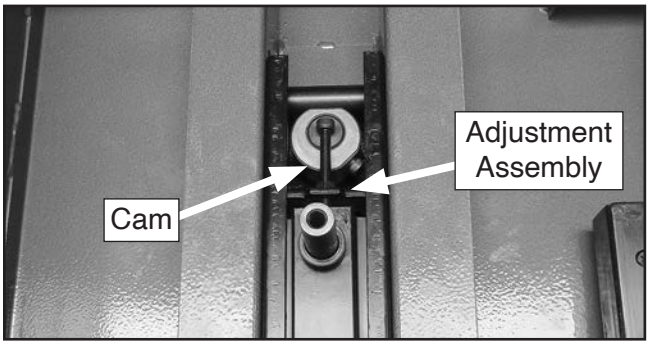


Figure 91. Lubrication locations for tension adjustment assembly (wheel removed for clarity).

Trunnions

The cast iron trunnions (see **Figure 92**) produce a fine graphite powder over time that acts as a lubricant. We recommend not adding lubricant to the trunnions, which could make a sticky substance that would prevent smooth movement.

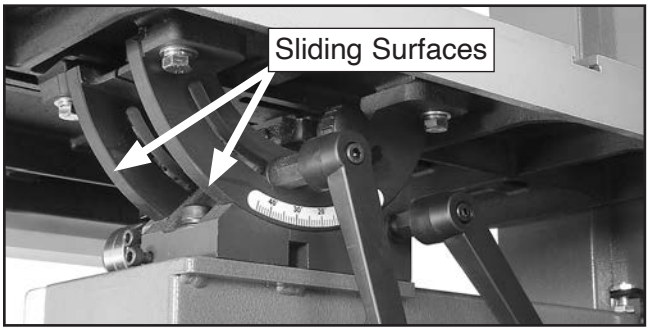


Figure 92. Cast iron trunnions produce their own lubricant.

SECTION 7: SERVICE

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

Troubleshooting

Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips immediately upon startup.	1. Emergency Stop button depressed/at fault. 2. Incorrect power supply voltage or circuit size. 3. Power supply circuit breaker tripped or fuse blown. 4. Motor wires connected incorrectly. 5. Wiring open/has high resistance. 6. ON/OFF switch at fault. 7. Start capacitor at fault. 8. Thermal overload relay has tripped. 9. Contactor not energized/has poor contacts. 10. Centrifugal switch at fault. 11. Motor at fault.	1. Rotate button head to reset. Replace. 2. Ensure correct power supply voltage and circuit size. 3. Ensure circuit is sized correctly and free of shorts. Reset circuit breaker or replace fuse. 4. Correct motor wiring connections (**Page 71**). 5. Check/fix broken, disconnected, or corroded wires. 6. Replace switch. 7. Test/replace. 8. Reset; contact tech support if relay frequently trips. 9. Test all legs for power/replace. 10. Adjust/replace centrifugal switch if available. 11. Test/repair/replace.
Machine stalls or is underpowered.	1. Dull blade. 2. Workpiece material not suitable for machine, or machine undersized. 3. Belt slipping; oil/grease on belt. 4. Feed rate/cutting speed too fast. 5. Blade slipping on wheels. 6. Motor overheated. 7. Motor wired incorrectly. 8. Plug/receptacle at fault. 9. Run capacitor at fault. 10. Pulley/sprocket slipping on shaft. 11. Contactor not energized/has poor contacts. 12. Centrifugal switch at fault. 13. Motor bearings at fault.	1. Sharpen/replace blade (**Page 46**). 2. Only cut wood—ensure moisture is below 20%. Use correct blade/reduce feed rate or depth of cut. 3. Clean/tension/replace belt (**Page 59**). 4. Decrease feed rate/cutting speed. 5. Increase blade tension (**Page 28**); ensure proper blade size. 6. Allow motor to cool, reset thermal overload relay if necessary, and reduce depth of cut. 7. Wire motor correctly (**Page 71**). 8. Test for good contacts/correct wiring. 9. Test/repair/replace. 10. Replace loose pulley/shaft. 11. Test all legs for power/replace. 12. Adjust/replace centrifugal switch if available. 13. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Motor & Electrical (Continued)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	1. Motor or component loose.	1. Inspect/replace damaged bolts/nuts, and retighten with thread locking fluid.
	2. Blade at fault.	2. Replace warped/bent/broken blade; replace/ resharpen dull blade (**Page 46**).
	3. V-belt worn or loose.	3. Inspect/replace belt(**Page 59**).
	4. Motor fan rubbing on fan cover.	4. Fix/replace fan cover; replace loose/damaged fan.
	5. Motor mount loose/broken.	5. Tighten/replace.
	6. Pulley loose.	6. Re-align/replace shaft, pulley set screw, and key.
	7. Machine incorrectly mounted.	7. Tighten mounting bolts; relocate/shim machine.
	8. Motor bearings at fault.	8. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	9. Centrifugal switch is at fault.	9. Replace.

Operating Machine

Symptom	Possible Cause	Possible Solution
Blade or teeth break/ crack.	1. Blade tension is incorrect.	1. Adjust blade tension (**Page 28**).
	2. Blade is incorrect for application.	2. Use correct blade for application (**Page 41**).
	3. Excessive feed rate/pressure.	3. Reduce feed rate/pressure.
	4. Cutting corners too sharply.	4. Use a wider arc on outside cuts, or use relief cuts to make tight inside cuts.
	5. Blade is dull/weld at fault.	5. Replace blade (**Page 46**).
	6. Blade is tracking incorrectly.	6. Adjust blade tracking (**Page 30**).
	7. Blade guides/support bearings not adjusted properly, allowing guides to hit blade teeth.	7. Adjust blade guides/support bearings properly, so guides cannot contact teeth during operation (**Pages 31–33**).
	8. Wheel tires worn or incorrectly installed.	8. Replace or re-install tire.
	9. Fence or miter slot out of alignment with blade.	9. Align table miter slot and fence with blade (**Page 36**).
	10. Bad blade-guide bearings.	10. Replace blade-guide bearings.
Blade slows, smokes, shows overheating or wears on one side.	1. Blade contacting table insert.	1. Adjust blade guides to eliminate any side pressure (**Page 32**). Properly align table (**Page 37**).
	2. Blade guides are worn or misadjusted.	2. Adjust upper blade guides as close to workpiece as possible.
	3. Blade installed backwards.	3. Check blade rotation. Re-install blade if necessary (**Page 46**).
	4. Too much side pressure when feeding workpiece.	4. Feed workpiece straight into blade.
	5. Wheels are out of alignment.	5. Adjust wheels to be coplanar (**Page 66**).
	6. Dull, bell-mouthed, or incorrect blade.	6. Replace blade (**Page 46**).
	7. Fence not parallel with blade.	7. Adjust fence parallelism with blade (**Page 37**).
	8. Table top surface is not parallel or square to blade.	8. Adjust/shim table/trunnion position until blade and table are parallel and square (**Page 37**).
	9. V-belt loose or slipping.	9. Tighten V-belt. Replace if worn or oily. (**Page 59**).

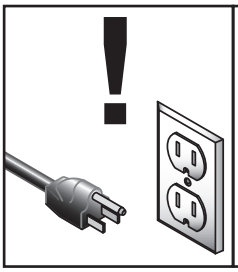
Operating Machine (Continued)

Symptom	Possible Cause	Possible Solution
Finished workpieces are rough or show scoring.	1. Blade is overloaded and twists. 2. Blade TPI is too coarse. 3. Blade is loose and fluttering. 4. Blade tracking is incorrect. 5. Blade has missing/bent teeth, or faulty weld.	1. Decrease feed rate; ensure proper TPI (**Page 44**). 2. Use correct blade for material and speed of cut (**Page 41**). 3. Adjust blade tension as required (**Page 28**). 4. Adjust blade tracking (**Page 25**). 5. Replace blade (**Page 46**).
Table is hard to tilt.	1. Table tilt lock lever is engaged. 2. Sawdust or pitch trapped between trunnion and base. 3. Metal burrs on trunnion.	1. Disengage table tilt lock lever (**Page 47**). 2. Remove table and clean trunnion sliding surfaces free of sawdust or pitch. 3. Remove burrs.
Table does not tilt to 45 or 0 degrees.	1. Table tilt scale pointer not calibrated. 2. Positive stop not set correctly.	1. Calibrate table tilt scale pointer (**Page 69**). 2. Adjust positive stop (**Page 47**).
Miter bar binds in miter slot.	1. Miter slot dirty or gummed up. 2. Miter bar is bent.	1. Carefully clean miter slot. 2. Replace.
Blade tracks incorrectly, or comes off wheels.	1. Tracking is not adjusted properly. 2. Wheels are not coplanar. 3. Blade tension too loose. 4. Blade guides/support bearings improperly adjusted. 5. Feeding workpiece too fast. 6. Incorrect blade for operation. 7. Blade is bell-mouthed, worn, or dull. 8. Rubber tire or wheel is damaged or worn.	1. Adjust tracking (**Page 25**). 2. Adjust wheels to be coplanar (**Page 66**). 3. Increase blade tension (**Page 28**). 4. Properly adjust blade guides/support bearings (**Pages 31–33**). 5. Feed workpiece slower. 6. Install correct blade (**Page 41**). 7. Install new blade and remove tension from blade when not in use. 8. Replace rubber tires or wheel.
Cut is crooked or blade wanders (blade lead).	1. Excessive feed rate/pressure. 2. Blade tension too loose. 3. Blade is too narrow or tooth type/TPI is incorrect for the cut. 4. Inadequate blade support. 5. Blade dull or has damaged tooth set from improper guides/support bearing adjustment. 6. Blade tracking is incorrect. 7. Table is loose. 8. Fence or miter slot out of alignment with blade. 9. Blade guides/support bearings improperly adjusted. 10. Tooth set is uneven or teeth are more sharp on one side than the other.	1. Reduce feed rate/pressure. 2. Increase blade tension (**Page 28**). 3. Use wider blade. Ensure tooth type & TPI is correct. (**Page 41**). 4. Position upper blade guides to just clear workpiece. Properly adjust blade guides/support bearings (**Pages 31–33**). 5. Replace blade (**Page 46**). 6. Adjust blade tracking (**Page 25**). 7. Tighten table trunnion mounting bolts or tilt lock lever. 8. Align table miter slot and fence with blade (**Pages 36–37**). 9. Properly adjust blade guides/support bearings (**Pages 31–33**). 10. Replace blade (**Page 46**).
Blade dulls prematurely.	1. Excessive feed rate/pressure. 2. Wrong blade tooth type or TPI. 3. Blade is twisted. 4. Blade is slipping on wheel. 5. Blade guides hitting teeth and ruining tooth set.	1. Reduce feed rate/pressure. 2. Use blade with correct tooth type and TPI. (**Page 41**). 3. Re-install blade; replace (**Page 46**). 4. Adjust blade tension (**Page 28**). 5. Properly adjust guide bearings (**Page 32**).

Operating Machine (Continued)

Symptom	Possible Cause	Possible Solution
Gullets loaded with chips.	1. Excessive feed rate/pressure. 2. Blade TPI is too fine.	1. Reduce feed rate/pressure. 2. Install correct blade (**Page 41**).
Backside of blade deformation/ cracking.	1. Excessive feed rate/pressure. 2. Blade tension too high. 3. Blade support bearing improperly adjusted.	1. Reduce feed rate/pressure. 2. Adjust blade tension (**Page 28**). 3. Properly adjust blade support bearing (**Page 31**).
Sawdust buildup inside cabinet.	1. Blade brushes under table are worn or mis-adjusted. 2. Clogged dust port. 3. Low CFM (airflow) from dust collection system.	1. Properly adjust brushes; replace if necessary (**Page 62**). 2. Clean dust port. 3. Inspect ducting for leaks/clogs and repair as necessary; move dust collector closer to machine; install a stronger dust collector.

Tensioning/ Replacing V-Belt



⚠WARNING

To reduce risk of shock or accidental startup, always disconnect machine from power before adjustments, maintenance, or service.

Tensioning/Replacing V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be properly tensioned, and free of cracks, fraying, and wear. Belt tension and condition should be checked at least every 3 months—more often if the bandsaw is used daily.

Tools Needed	Qty
Hex Wrench 8mm	1

To check/adjust V-belt tension:

1. DISCONNECT MACHINE FROM POWER!

2. Open lower wheel cover.

3. Inspect V-belt; if it is cracked, frayed, or glazed, replace it (refer to **Replacing V-Belt** on **Page 60**).

4. Check V-belt tension by applying moderate pressure between pulleys (see **Figure 93**).

   — If V-belt deflection *is* approximately ¼", belt is correctly tensioned and no adjustment is necessary.

   — If deflection is *not* approximately ¼", V-belt is not correctly tensioned. Proceed to **Step 5**.

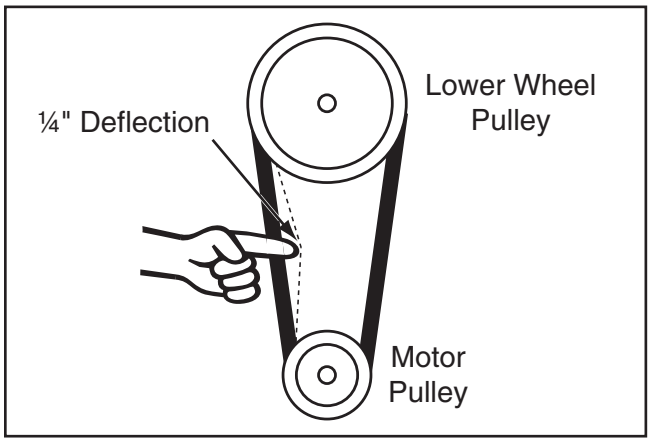


Figure 93. V-belt deflection.

5. Loosen motor mount cap screw and lock lever (see **Figure 94**).

6. Use motor mount handle (see **Figure 94**) to adjust motor position until V-belt is correctly tensioned.

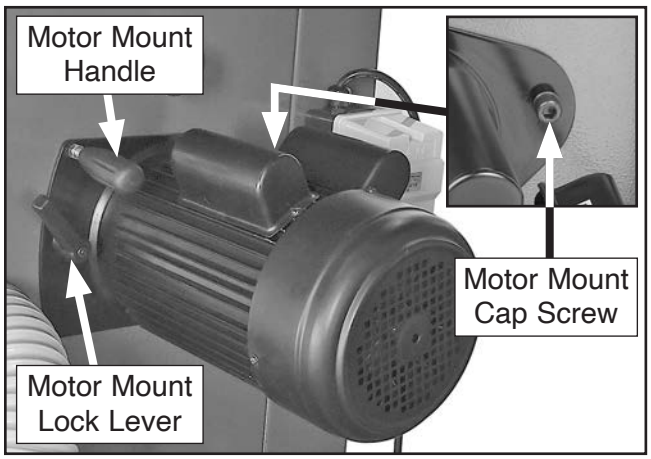


Figure 94. Location of V-belt tension controls.

7. Retighten motor mount lock lever, then retighten cap screw to secure adjustment.

Replacing V-Belt

To replace the V-belt, you must remove the blade and the lower wheel. After re-installation, you must properly re-tension the V-belt.

Tools Needed:	**Qty**
Hex Wrench 6mm	1
Hex Wrench 8mm	1

To replace V-belt:

1. DISCONNECT MACHINE FROM POWER!

2. Open both wheel covers, and remove blade (refer to **Changing Blade** on **Page 46**).

3. Remove lower wheel mount cap screw and washer shown in **Figure 95**, then slide lower wheel with bearing off of shaft.

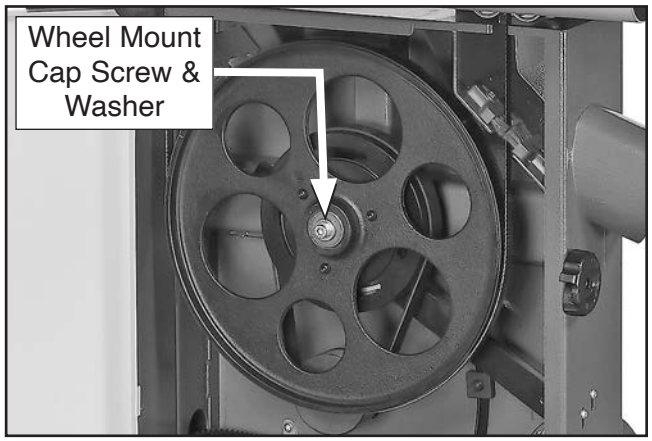


Figure 95. Location of wheel mount cap screw and washer.

4. Loosen motor mount cap screw and lock lever (see **Figure 96**).

5. Use motor mount handle (see **Figure 96**) to raise motor all the way, completely de-tensioning V-belt, then retighten lock lever to secure motor in UP position.

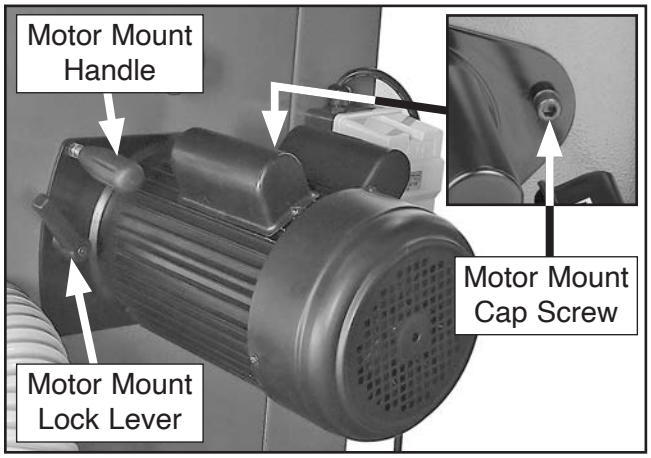


Figure 96. Location of V-belt removal controls.

6. Slip old V-belt off of lower wheel and motor pulleys, then install new V-belt in its place.

7. Properly tension V-belt (refer to **Tensioning/ Replacing V-belt** on **Page 59** for detailed instructions).

8. Re-install lower wheel with bearing and secure it with wheel mount cap screw and washer removed in **Step 3**.

9. Re-install blade, and close and secure wheel covers.

Blade Lead

Bandsaw blades may wander off of the layout line when sawing, as shown in **Figure 97**. This is called blade lead.

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

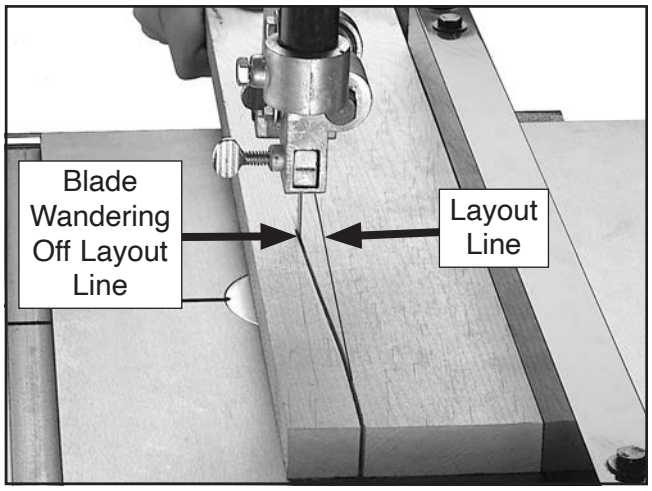


Figure 97. Example of blade lead.

Items Needed	Qty
Wood Board ¾" x 3" x 16"	1
Hex Wrench 5mm	1

To correct blade lead:

1. Make sure blade is properly tensioned and blade guides are adjusted correctly.

2. Make sure miter slot and fence are parallel to blade line (see **Aligning Table** and **Aligning Fence** procedures for detailed information).

3. Perform test cut with bandsaw, using less pressure when feeding workpiece through cut.

   — If there is still blade lead present, compensate for this condition by skewing the fence, as instructed in the following procedure.

To skew fence:

1. Cut a straight and parallel wood board approximately ¾" thick x 3" wide x 16" long.

   Tip: *Cut your board out of a new piece of ¾" plywood, using a tablesaw. The straight "factory edge" of the plywood will ensure accuracy during the following steps. Alternatively, you can use a jointer and tablesaw to straighten a piece of scrap wood.*

2. On wide face of board, draw a straight line parallel to long edge, similar to layout line shown in **Figure 97** on **This Page**.

3. Slide fence out of the way and cut along layout line halfway through board. Turn bandsaw ***OFF*** and wait for blade to stop. Do not move board.

4. Clamp board to bandsaw table, then slide fence over to board so it barely touches one edge of board.

5. Loosen the four fence adjustment cap screws to the left of fence face (see **Figure 98**), skew fence so that it is parallel with wood board, contacting it evenly along its length, then retighten cap screws.

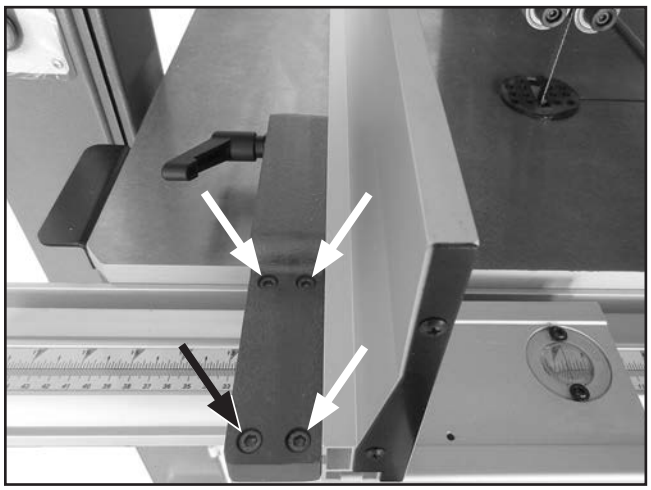


Figure 98. Location of fence adjustment cap screws.

6. Finish cut using fence.

   — If blade lead is still present, repeat **Steps 1–5** until cutting results are satisfactory.

Adjusting Wheel Brushes

The lower wheel has brushes (see **Figure 99**) that are designed to sweep sawdust off the tire and blade during operation. In order to work properly, the brushes must make firm contact with the tire.

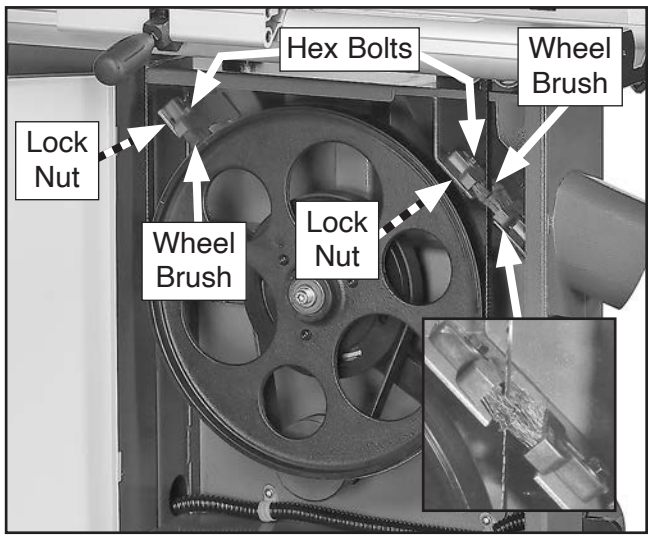


Figure 99. Location of wheel brushes.

Tools Needed: **Qty**
Wrench/Socket 10mm 2

To adjust wheel brushes:

1. DISCONNECT MACHINE FROM POWER!
2. Open lower wheel cover.
3. Loosen hex bolts and lock nuts that secure wheel brushes in place (see **Figure 99**).
4. Adjust wheel brushes so they make firm, even contact with the wheel without bending the bristles, then retighten hex bolts and cap screws to secure wheel brushes in place.

Adjusting Quick-Release Lever

The blade tension quick-release lever was adjusted at the factory for use with the pre-installed blade. However, because actual blade lengths may vary slightly by manufacturer, whenever you install a new blade, you may need to adjust the quick-release adjustment screw so that the blade tension quick-release lever works correctly.

Tools Needed: **Qty**
Hex Wrench 5mm..... 1
Wrench 10mm 1

To adjust blade tension quick-release lever:

1. Tension blade (refer to **Tensioning Blade**, beginning on **Page 28** for more information).
2. DISCONNECT MACHINE FROM POWER!
3. Rotate blade tension quick-release lever clockwise to up position to release blade tension.
4. Loosen jam nut on tension adjustment screw, then loosen screw 7-10 turns (see **Figure 100**).

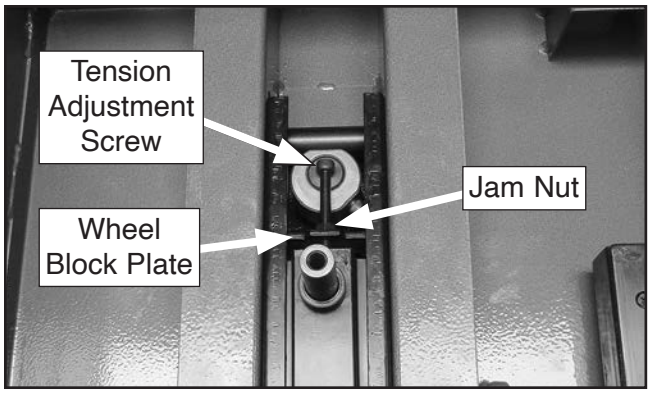


Figure 100. Location of tension adjustment screw, jam nut, and wheel block plate.

5. Rotate blade tension quick-release lever counterclockwise to down position to apply tension to blade.

6. Tighten tension adjustment screw (see **Figure 100**) until it contacts wheel block plate, then back it off 1-2 turns.

7. Retighten jam nut.

Adjusting Guide Post Parallelism

The guide post assembly should remain parallel with the blade front to back and side to side along its length of travel. If it does not, follow these instructions to adjust it.

Important: Make sure the table is aligned with the blade from side to side and front to back before beginning these procedures (refer to **Aligning Table** on **Page 36** for detailed instructions).

Tools Needed:

Machinist's Square	1
Small Ruler	1
Hex Wrench 4mm	1
Hex Wrench 5mm	1
Hex Wrench 8mm	1

Checking/Adjusting Guide Post Parallel with Blade Side to Side

1. DISCONNECT MACHINE FROM POWER!

2. Loosen guide post lock knob, lower guide post to within 1" of table top, then tighten knob.

3. Place machinist's square on table next to right-hand side of guide post, as shown in **Figure 101**.

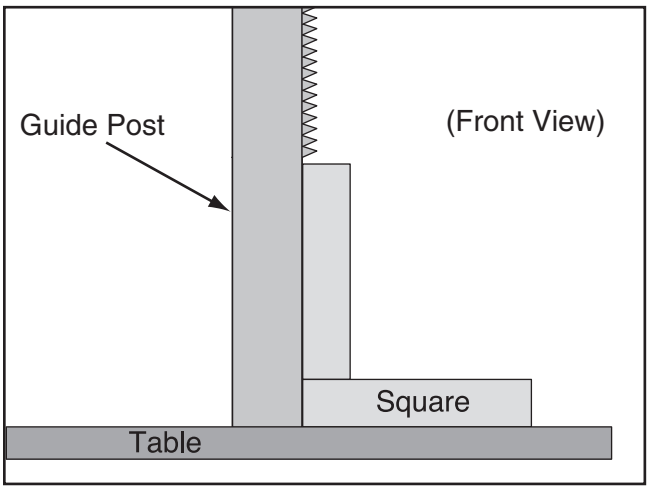


Figure 101. Example of checking guide post squareness.

— If there is no gap between square and guide post along its full length, no adjustments need to be made. Proceed to next procedure.

— If there *is* a gap between square and the guide post, guide post is not parallel to blade. Go to **Step 4**.

4. Loosen each of the four cap screws shown in **Figure 102** ¼-turn**.**

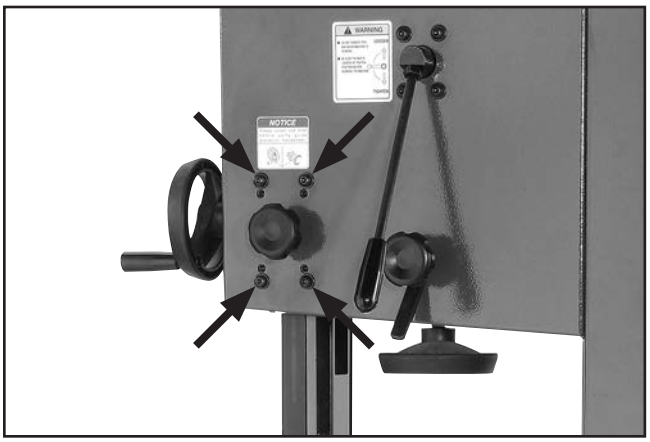


Figure 102. Guide post adjustment screws.

5. Gently tap lower part of guide post in appropriate direction until there is no gap between square and guide post.

6. Tighten cap screws shown in **Figure 102**.

Checking/Adjusting Guide Post Parallel with Blade Front to Back

1. DISCONNECT MACHINE FROM POWER!

2. Loosen guide post lock knob, lower blade guide assembly all the way, then tighten lock knob.

3. Remove (2) M5-.8 x 10 cap screws and 5mm flat washers that secure guide post guard, then carefully remove guard (see **Figures 103–104**).

Note: *It helps to rotate guard counterclockwise while removing it.*

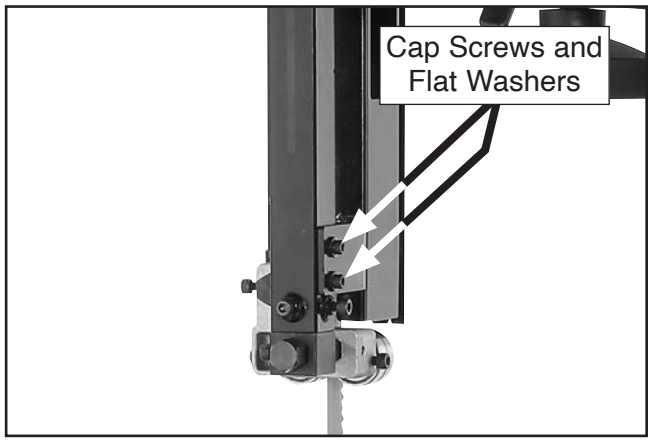


Figure 103. Location of cap screws and flat washers that secure guide post guard.

Figure 104. Guide post guard removed.

4. Measure distance "A" between upper front face of guide post rack back of blade (see **Figure 105**).

5. Measure distance "B" between bottom front face of guide post rack and back of blade (see **Figure 105**).

— If measurements taken in **Steps 4–5** are equal, no adjustments need to be made. Go to **Step 9**.

— If measurements taken in **Steps 4–5** are *not* equal, proceed to **Step 6**.

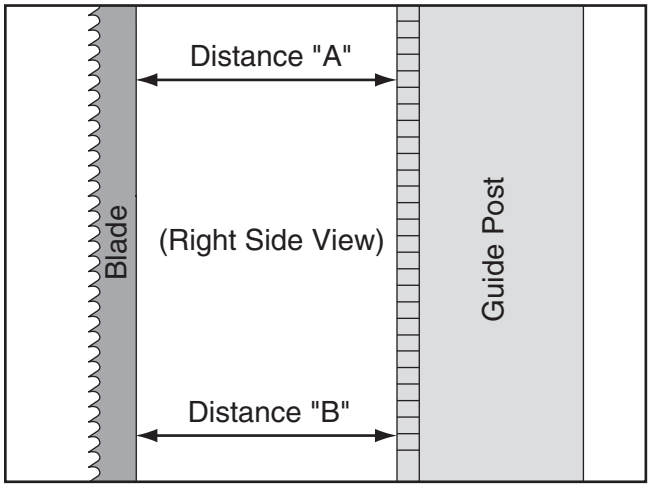


Figure 105. Example of measuring distance between guide post rack and blade.

6. Loosen four cap screws shown in **Figure 106**.

   — If guide post to blade distance is greater at *bottom* than at *top*, tighten two *upper* set screws shown in **Figure 106** an equal amount until guide post is parallel with blade.

   — If guide post to blade distance is greater at *top* than at *bottom*, tighten two *lower* set screws shown in **Figure 106** an equal amount until guide post is parallel with blade.

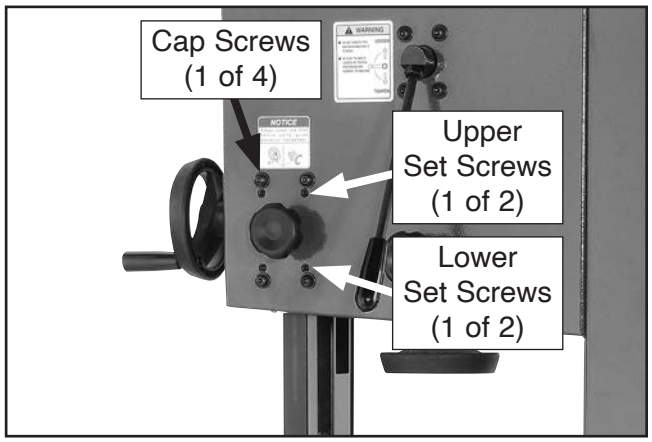


Figure 106. Guide post parallelism adjustment screws.

7. Tighten four cap screws shown in **Figure 106**, then repeat **Steps 4–5**.

   — If measurements *are* equal, proceed to **Step 9**.

   — If measurements are *not* equal, repeat **Steps 6–7** until guide post is parallel with blade.

8. Re-install guide post guard using screws removed in **Step 3**.

9. Rotate upper wheel by hand and make sure blade does not contact guide post guard. If it does, loosen cap screws from **Step 3**, adjust guard so that blade will not make contact with it, then retighten screws.

Aligning Wheels

The following adjustment was performed at the factory and should not need to be performed again unless there is a wheel alignment problem, or one or more wheels are replaced.

When wheels are coplanar (see **Figure 107**), the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel.

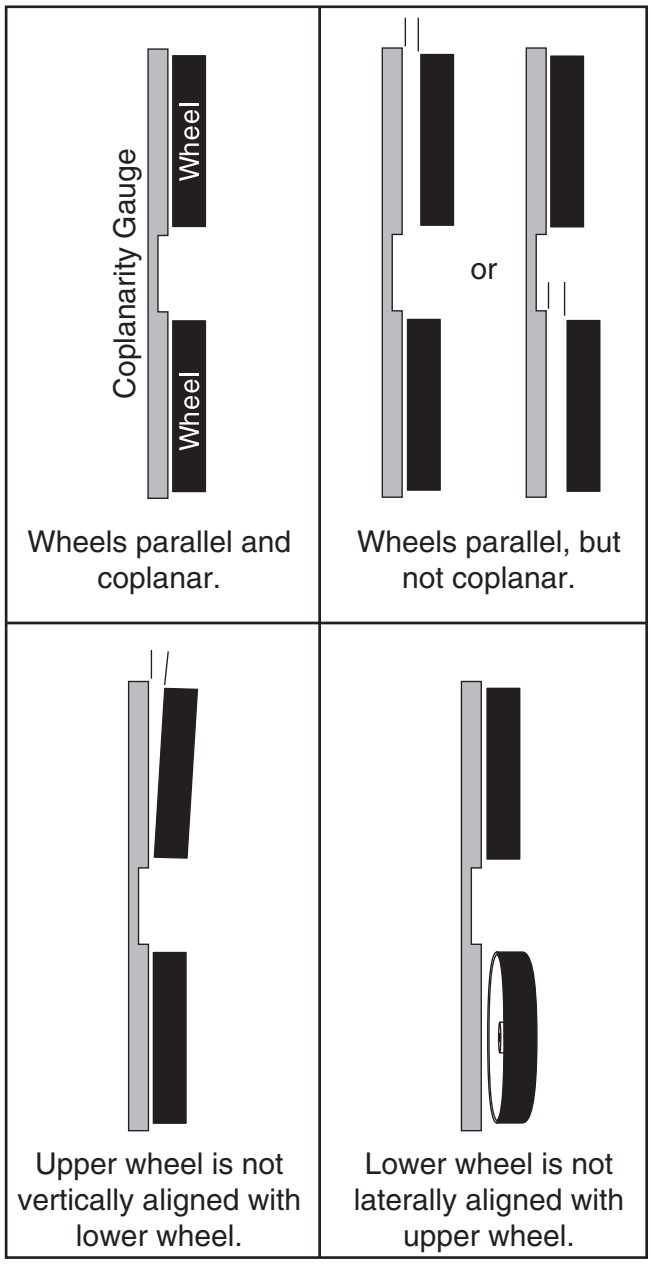


Figure 107. Wheel alignment illustration.

Bringing the wheel into alignment may require a combination of shimming a wheel and adjusting the position of the lower wheel shaft.

Items Needed	**Qty**
53" Long 2x4	1
Hex Wrenches 4 & 6 mm	1 Ea
Wrench 13mm	1
Tape Measure	1
Fine Ruler	1

Checking Wheel Alignment

1. Make "Coplanarity Gauge" shown in **Figures 107** & **108**.

Note: *For best results, straighten the 2x4 with a jointer before cutting. Alternatively, you can cut the gauge out of a new sheet of ½"–¾" plywood using a tablesaw. The "factory edge" of the plywood will ensure a straight and parallel gauge.*

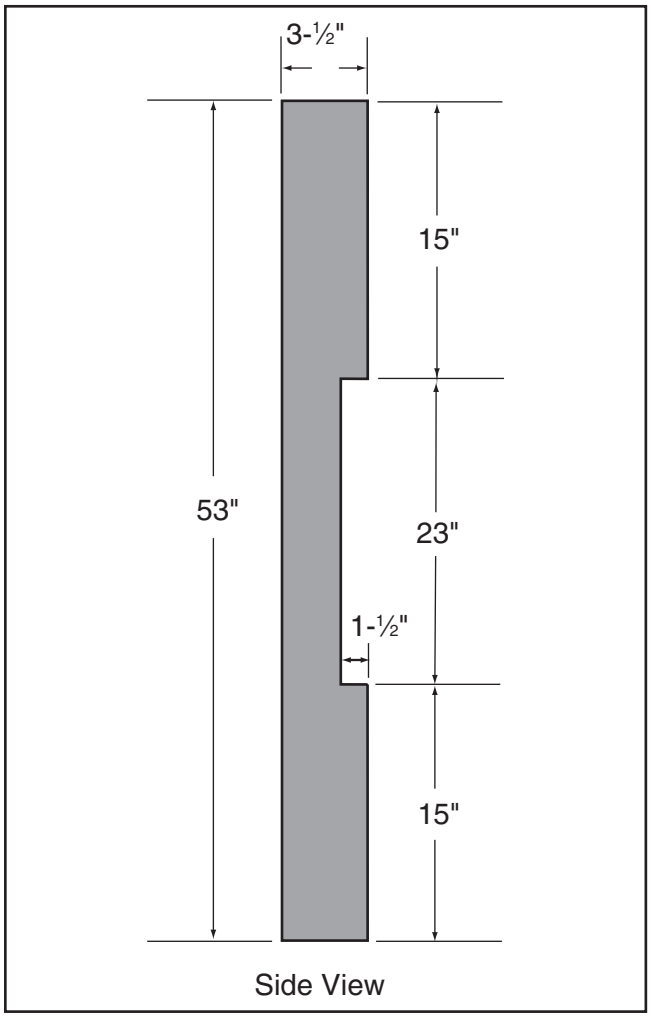


Figure 108. Dimensions of coplanarity gauge.

2. DISCONNECT MACHINE FROM POWER!

3. Remove blade (refer to **Changing Blade** on **Page 46**), remove table, then re-install and properly tension blade (refer to **Tensioning Blade** beginning on **Page 28**).

4. Place coplanarity gauge up against both wheels in positions shown in **Figure 109**. Make sure gauge fully extends across rims of both wheels.

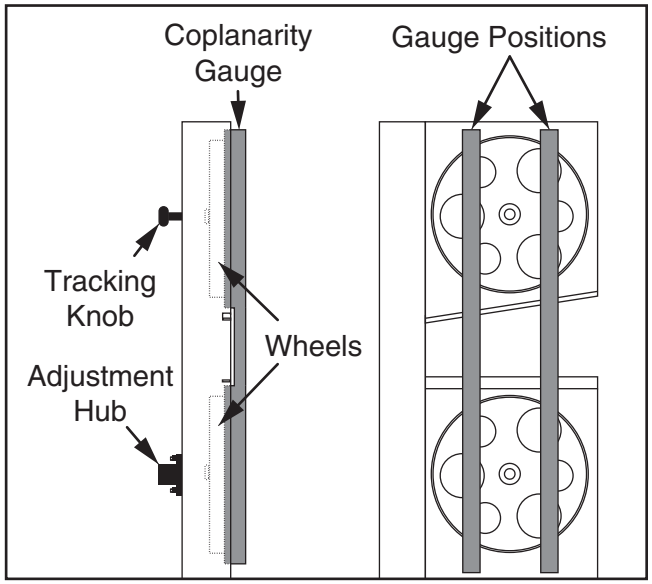


Figure 109. Illustration of using coplanarity gauge to check wheel alignment.

5. Check wheel alignment and adjust tracking knob to bring both wheels into alignment as much as possible. If wheels cannot be adjusted coplanar, use **Figure 110** to determine how to proceed with alignment adjustments.

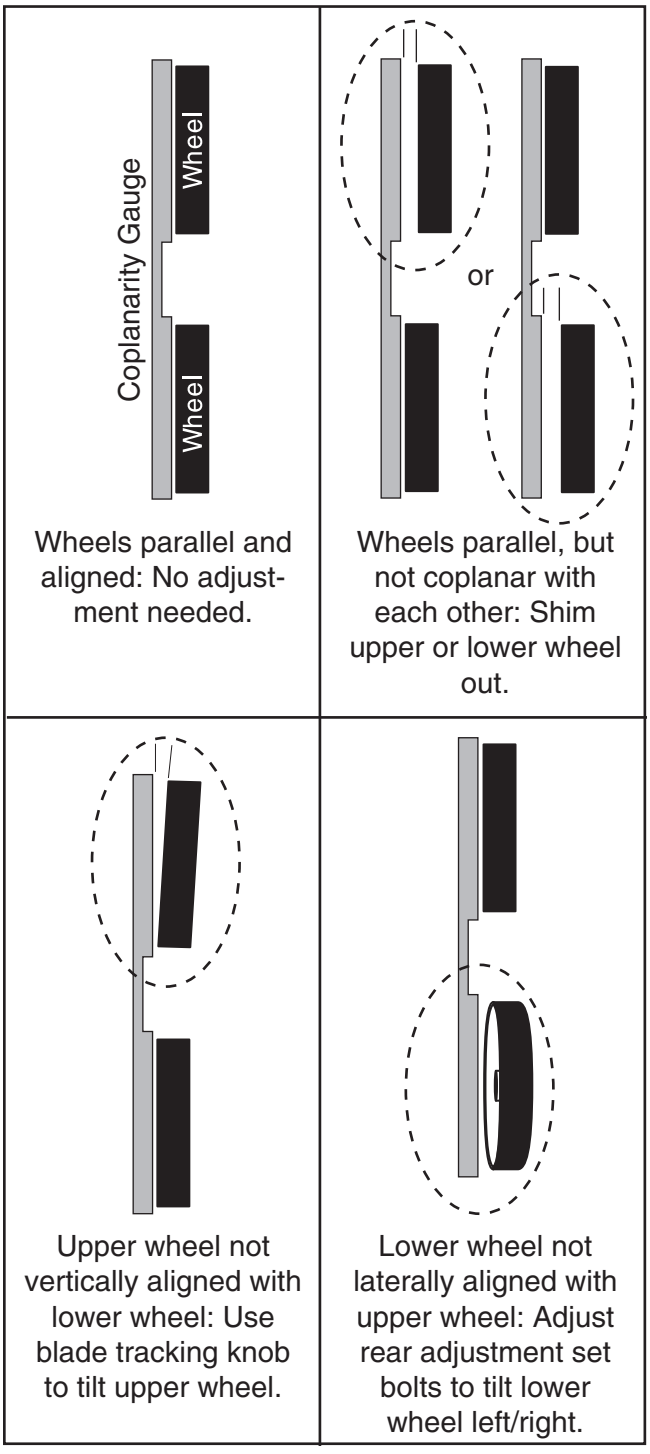


Figure 110. Wheel alignment illustration with solutions to misalignment problems.

Shimming a Wheel

When the wheels are parallel but not coplanar, one of the wheels must be shimmed out to bring it into the same plane as the other wheel.

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

To shim a wheel:

1. DISCONNECT MACHINE FROM POWER!

2. Adjust upper wheel tracking so that it is parallel with lower wheel.

3. With coplanarity gauge touching both rims of wheel that does not need to be shimmed out, measure distance away from other wheel with a fine ruler (see **Figure 111**). The distance measured with ruler is distance this wheel must be shimmed.

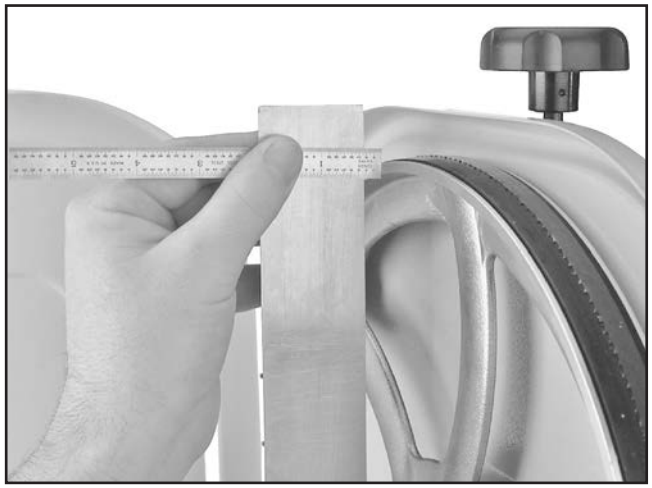


Figure 111. Example of measuring the distance to shim the wheel to be coplanar.

4. Remove blade.

5. Remove wheel to be shimmed. Place as many shims as necessary to correct gap measured in **Step 3** onto wheel shaft.

6. Re-install and secure wheel.

7. Re-install and properly tension blade.

8. Perform previous **Checking Wheel Alignment** procedure, beginning on **Page 66**, and adjust wheels as necessary make them parallel and coplanar.

   Tip: *The first time you get the wheels coplanar, place a mark on each wheel where you held the coplanarity gauge, then use this position again in the future if you need to repeat the procedure. This assures repeated accuracy every time you adjust the wheels.*

   — If no further adjustments are necessary, remove blade, re-install table, and then re-install blade.

   — If the lower wheel is tilted in relation to the upper wheel, proceed to **Adjusting Lower Wheel Shaft Position**.

Adjusting Lower Wheel Shaft Position

If the lower wheel is tilted in relation to the upper wheel, perform the following procedure to make it coplanar with the upper wheel.

There are four adjustment bolts with hex nuts in the lower wheel adjustment hub, shown in **Figure 112**. These adjust the wheel tilt from side to side and up and down.

Note: *If you make a mistake during the following procedure, it can be very difficult to correct. Therefore, it is important to double check wheel alignment (see **Page 66**), and troubleshoot all other possible solutions (see **Troubleshooting** on **Page 55**) prior to adjusting the lower wheel shaft position.*

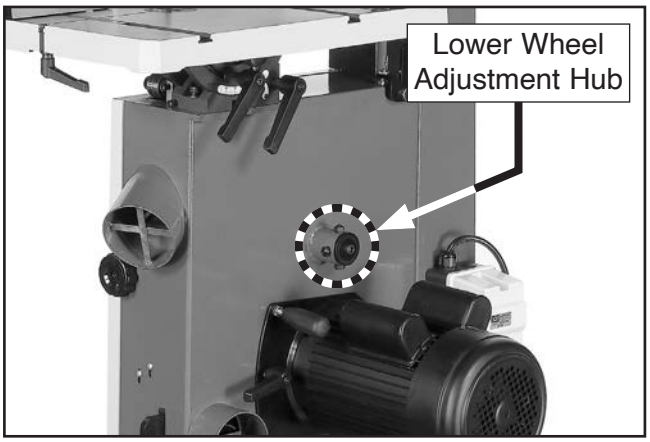


Figure 112. Location of rear lateral adjustment components.

To adjust lower wheel shaft position:

1. DISCONNECT MACHINE FROM POWER!

2. Loosen jam nuts on lower wheel adjustment hub (see **Figure 113**).

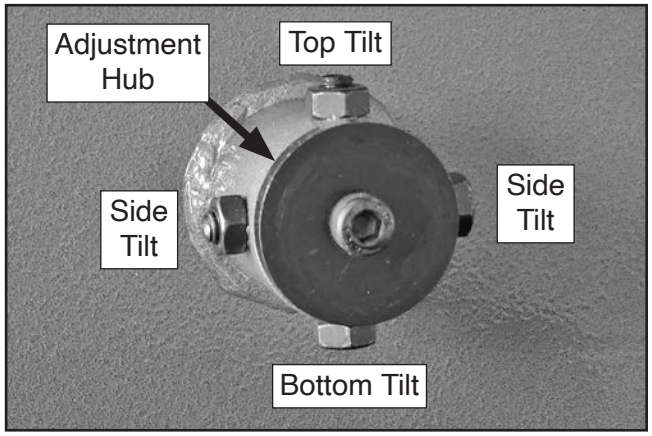


Figure 113. Lower wheel adjustment controls.

3. Loosen one tilt adjustment set screw, then tighten opposing set screw approximately an equal amount.

4. Check wheels with coplanarity gauge, and repeat **Step 3** as needed until lower wheel is parallel and coplanar with upper wheel.

5. Tighten jam nuts to lock tilt adjustment set screws in position.

6. Perform previous **Checking Wheel Alignment** procedure, beginning on **Page 66**, and adjust wheels as necessary to make them parallel and coplanar.

7. When wheels are parallel and coplanar, remove blade, re-install table, and then re-install blade.

Calibrating Table Tilt Scale Pointer

The table tilt scale pointer (see **Figure 114**) was calibrated at the factory. However, after prolonged use the pointer may shift, requiring adjustment.

Note: *The table tilt scale functions as a basic guide only. For high-precision cuts, use a protractor or bevel gauge to set the angle of table tilt.*

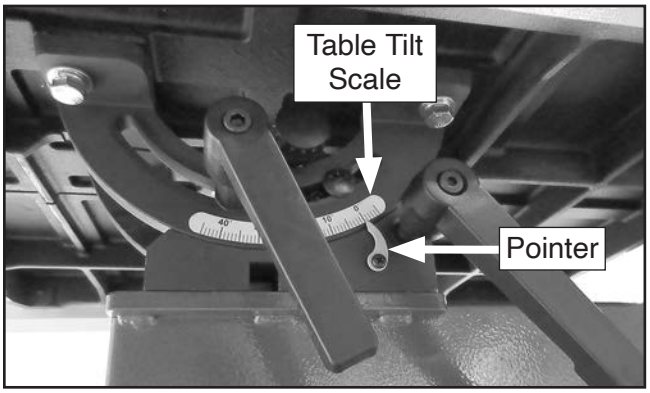


Figure 114. Location of table tilt scale and pointer.

Tools Needed	**Qty**
Machinist's Square	1
Phillips Screwdriver #2	1

To calibrate table tilt scale pointer:

1. DISCONNECT MACHINE FROM POWER!

2. Place one edge of square on table and other edge of square against blade side, as shown in **Figure 115**.

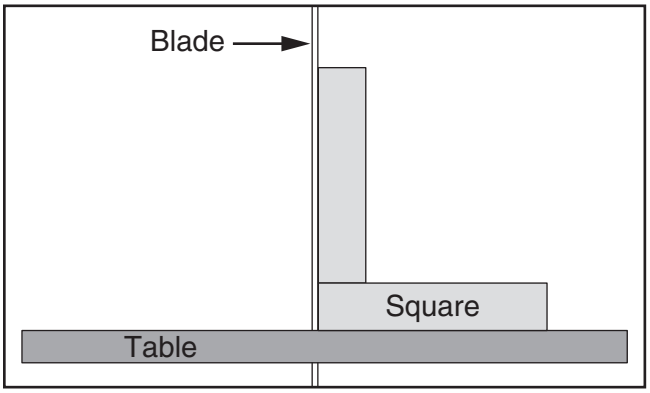


Figure 115. Adjusting table perpendicular to blade (side to side).

3. Adjust table tilt (refer to **Tilting Table**, beginning on **Page 47** for more information) until square rests flush and evenly against *both* table *and* blade side.

   Note: *Make sure square does not go across a blade tooth when performing this step.*

4. Loosen Phillips head screw that secures table tilt pointer (see **Figure 116**), adjust pointer to "0" on scale, then retighten screw.

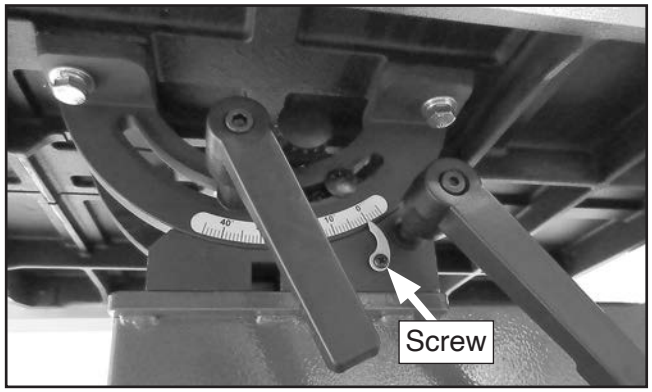


Figure 116. Location of screw that secures table tilt pointer.

Replacing Brake Shoe

The brake shoe needs to be replaced if one or more of the following conditions are met:

- If the bandsaw takes noticeably longer to stop when the foot brake is pushed.
- The foot brake makes metal-to-metal grinding sounds.
- The thickness of the brake shoe pad measures 1mm or less.

Components and Hardware Needed:
Replacement Brake Shoe 1

Tools Needed:
Hex Wrench 5mm..... 1
Hex Wrench 6mm..... 1
Wrench 10mm 1
Wrench 17mm 1

To replace brake shoe:

1. DISCONNECT MACHINE FROM POWER!

2. Remove lower wheel and V-belt (refer to **Steps 1-6** in **Replacing V-Belts** on **Page 60**).

3. Remove (2) cap screws and lock washers that secure brake shoe to brake lever, then remove brake shoe (see **Figure 117**).

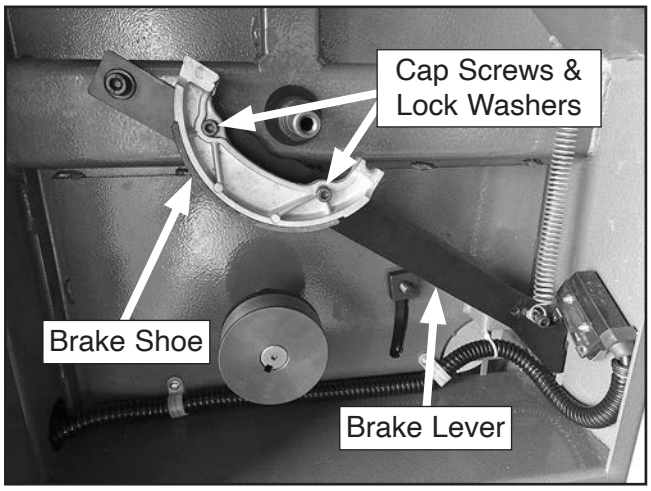


Figure 117. Lower wheel removed to expose brake shoe components.

4. Install new brake shoe using cap screws and lock washers removed in **Step 3**.

5. Re-install V-belt and lower wheel.

6. Tension V-belt (refer to **Tensioning/ Replacing V-belt** on **Page 59**).

7. Re-install, tension, and track blade, then adjust upper and lower blade guides and support bearings as needed (refer to **Changing Blade** on **Page 46**).

8. Close wheel covers.

SECTION 8: WIRING

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

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

⚠WARNING
Wiring Safety Instructions

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

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

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

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

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

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

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

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

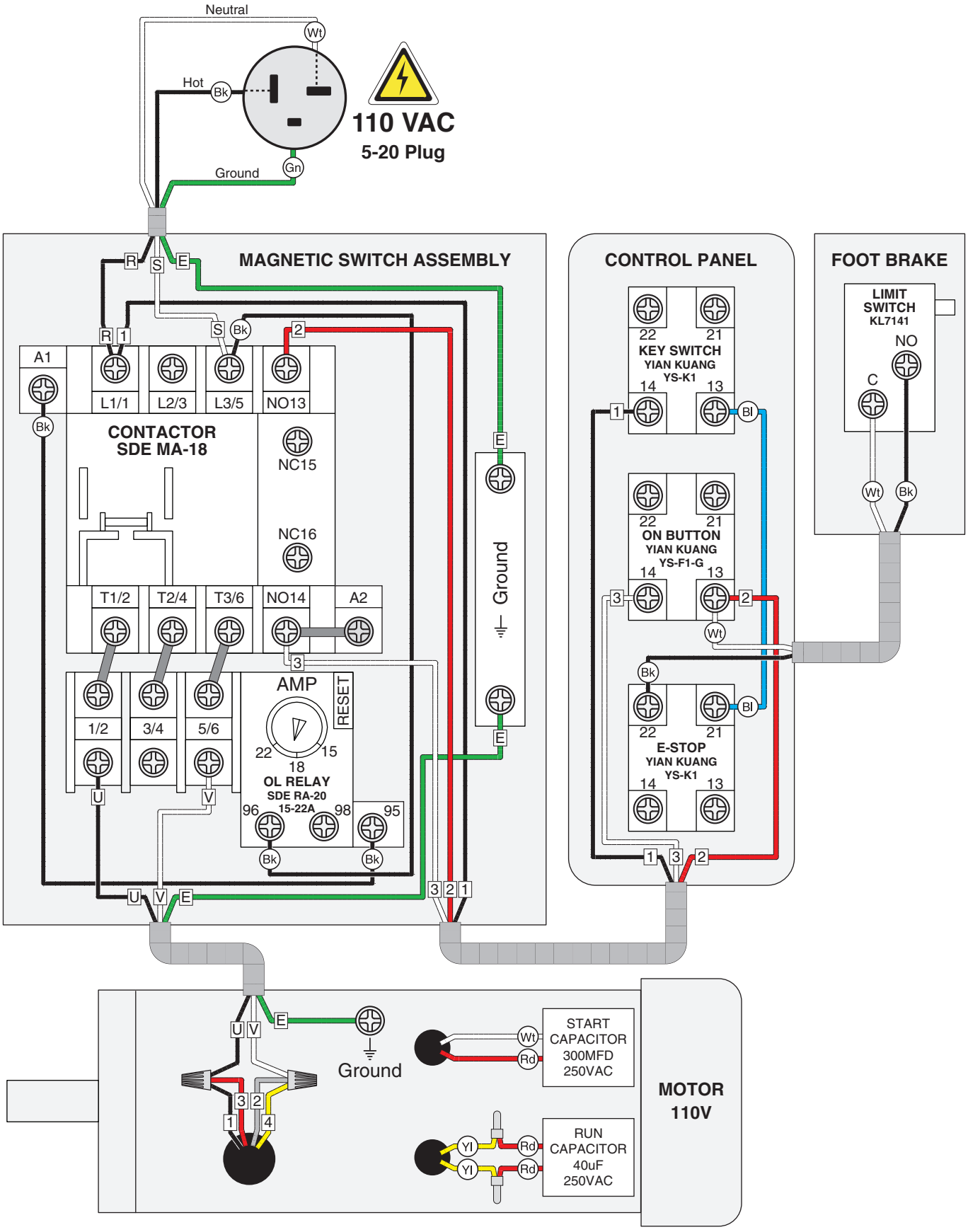
NOTICE

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

COLOR KEY

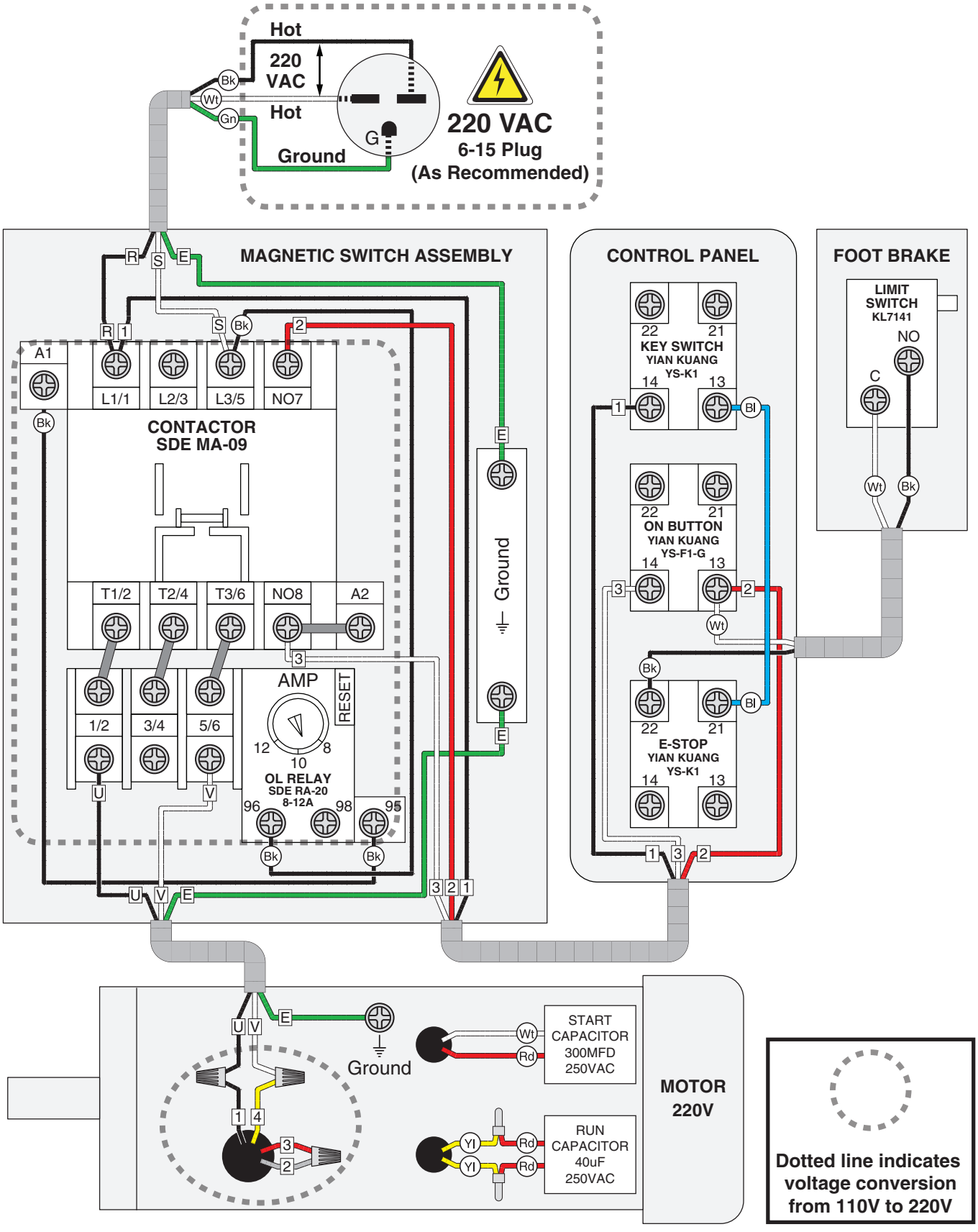
BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram 110V



STOP *READ ELECTRICAL SAFETY ON PAGE 71!*

Wiring Diagram 220V



Electrical Component Wiring Photos

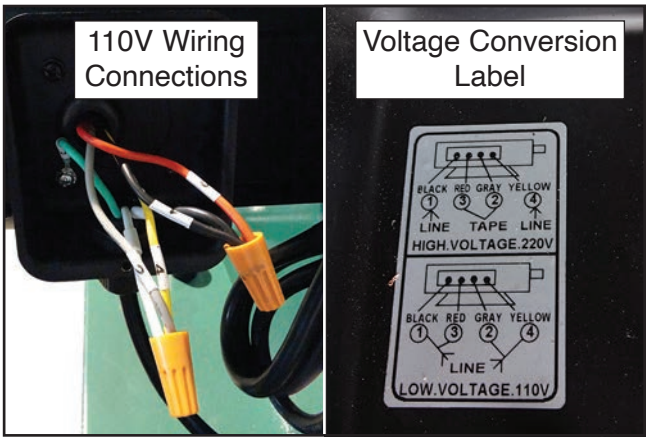


Figure 118. Motor junction box wiring.

Figure 119. Start and run capacitors.

Figure 120. Control panel wiring.

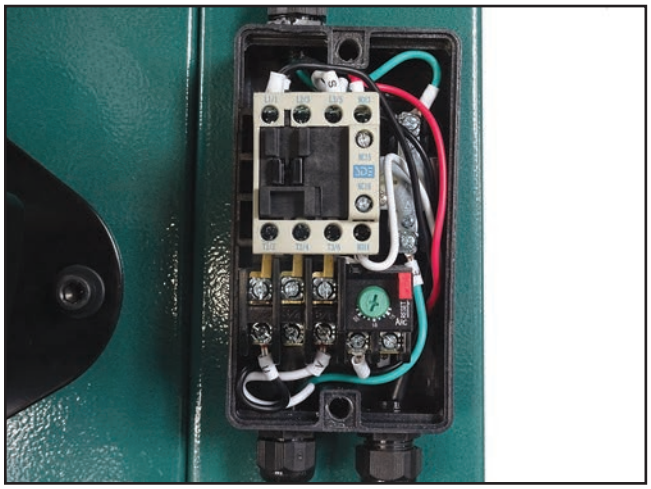


Figure 121. Magnetic switch wiring 110V.

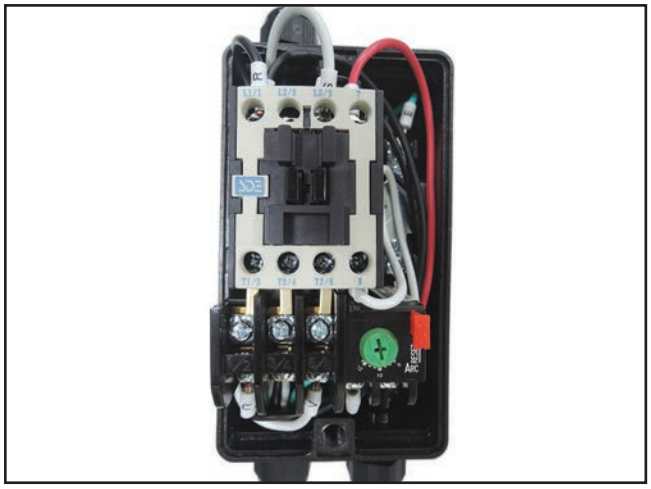


Figure 122. Magnetic switch wiring 220V.

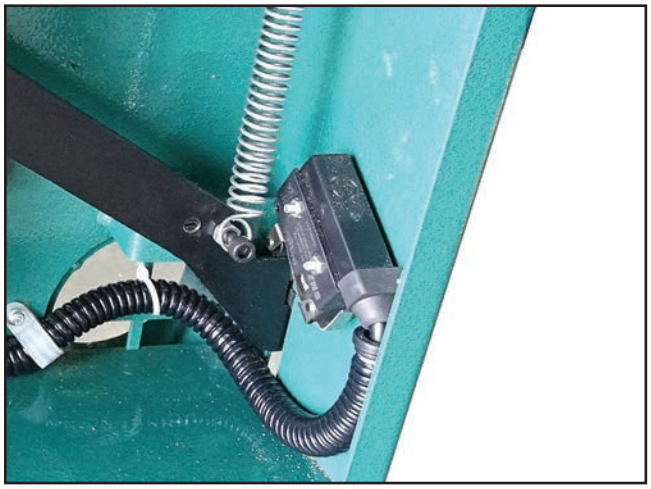


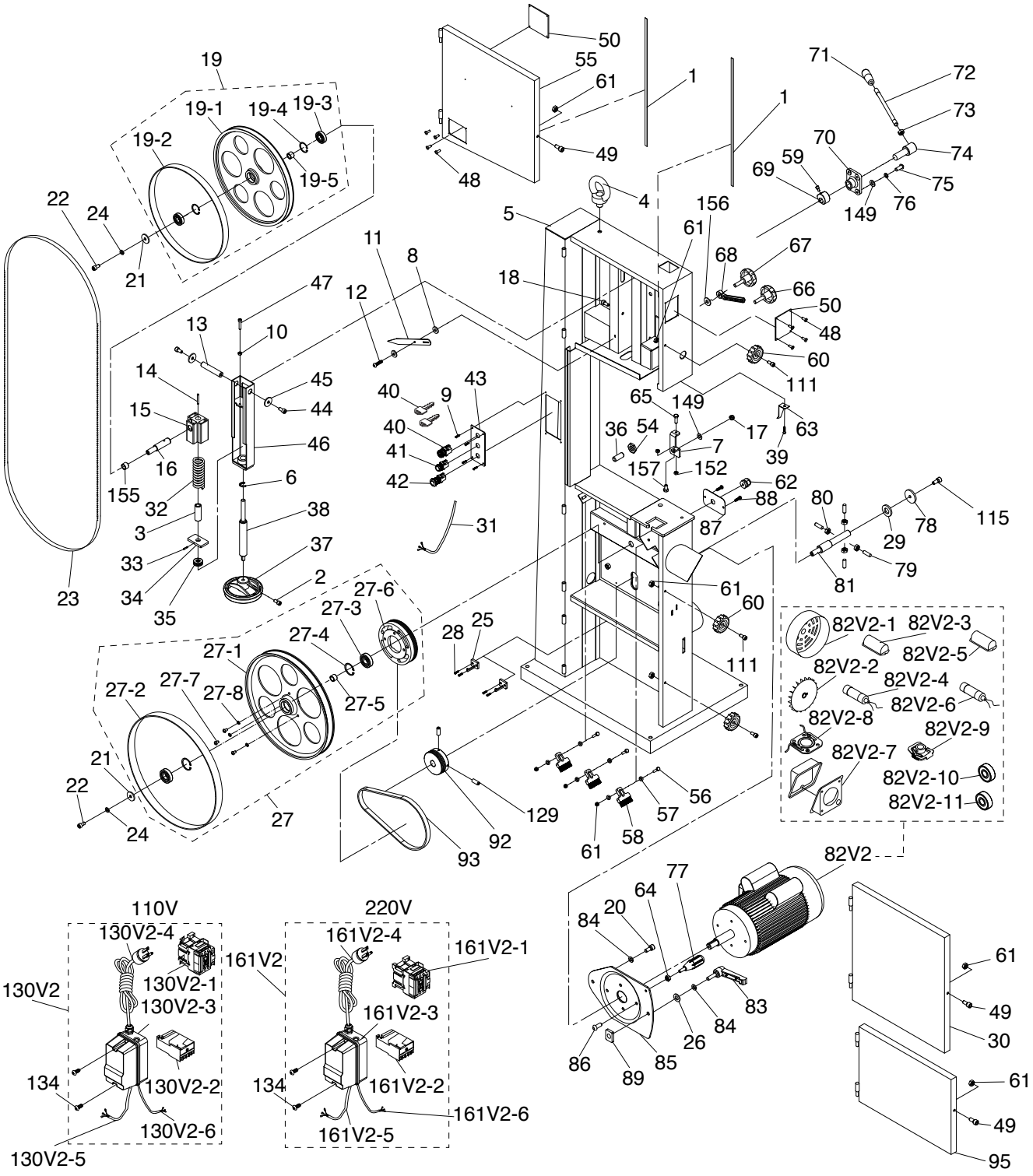
Figure 123. Foot brake limit switch.

STOP *READ ELECTRICAL SAFETY ON PAGE 71!*

SECTION 9: PARTS

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

Main



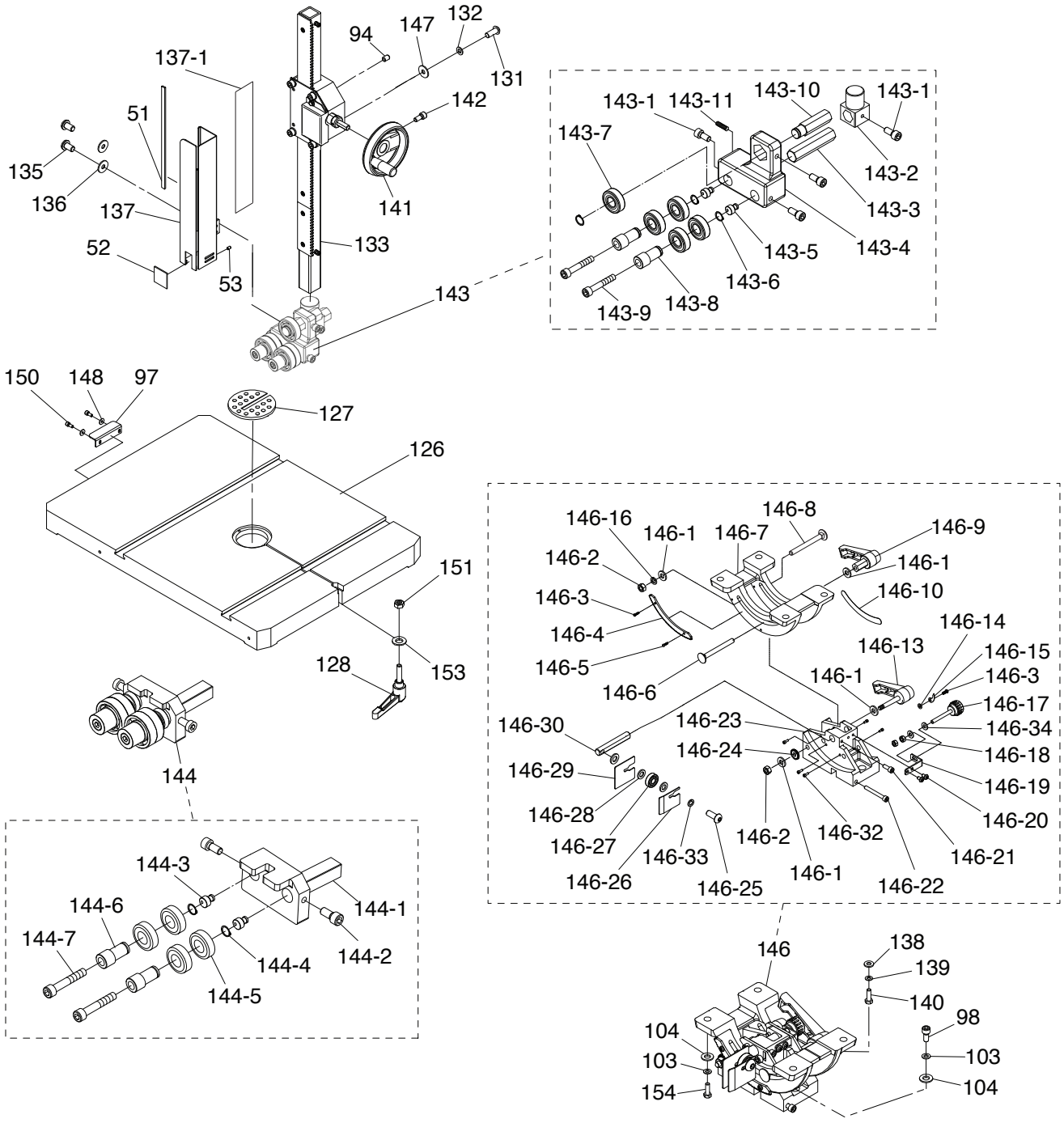
Main Parts List

REF	PART #	DESCRIPTION
1	P0817001	DOOR SEAL 10 X 760 X 1MM
2	P0817002	CAP SCREW M6-1 X 20
3	P0817003	BUSHING
4	P0817004	EYE BOLT M10-1.5
5	P0817005	MACHINE BODY
6	P0817006	E-CLIP 15MM
7	P0817007	TABLE TILT STOP BRACKET
8	P0817008	FLAT WASHER 6MM
9	P0817009	PHLP HD SCR M5-.8 X 8
10	P0817010	HEX NUT M6-1
11	P0817011	POINTER
12	P0817012	SHOULDER SCREW M4-.7 X 5, 6 X 3
13	P0817013	UPPER BLADE PIVOT SHAFT
14	P0817014	ROLL PIN 5 X 36
15	P0817015	UPPER WHEEL SHAFT BLOCK
16	P0817016	UPPER WHEEL SHAFT
17	P0817017	LOCK NUT M8-1.25
18	P0817018	CAP SCREW M6-1 X 12
19	P0817019	UPPER WHEEL ASSEMBLY
19-1	P0817019-1	UPPER WHEEL 14"
19-2	P0817019-2	WHEEL TIRE
19-3	P0817019-3	BALL BEARING 6202LLU
19-4	P0817019-4	INT RETAINING RING 35MM
19-5	P0817019-5	BUSHING
20	P0817020	CAP SCREW M10-1.5 X 35
21	P0817021	FENDER WASHER 8MM
22	P0817022	CAP SCREW M8-1.25 X 16
23	P0817023	SAW BLADE 120" X 3/8" 6-TPI HOOK
24	P0817024	LOCK WASHER 8MM
25	P0817025	SPARE BLADE HOLDER
26	P0817026	FLAT WASHER 10MM
27	P0817027	LOWER WHEEL ASSEMBLY
27-1	P0817027-1	LOWER WHEEL 14"
27-2	P0817027-2	WHEEL TIRE
27-3	P0817027-3	BALL BEARING 6202LLU
27-4	P0817027-4	INT RETAINING RING 35MM
27-5	P0817027-5	BUSHING
27-6	P0817027-6	WHEEL PULLEY
27-7	P0817027-7	BUTTON HD CAP SCR M6-1 X 25
27-8	P0817027-8	LOCK WASHER 6MM
28	P0817028	PHLP HD SCR M4-.7 X 8
29	P0817029	SPACER
30	P0817030	LOWER WHEEL COVER
31	P0817031	SWITCH CORD 16G 1W 7.9"
32	P0817032	COMPRESSION SPRING 7 X 34 X 90
33	P0817033	ROLL PIN 3 X 16
34	P0817034	ALIGNMENT PLATE
35	P0817035	THRUST BEARING 51201
36	P0817036	SET SCREW M8-1.25 X 30
37	P0817037	HANDWHEEL TYPE-4 140D X 10B-S
38	P0817038	BLADE TENSION ADJUSTING ROD
39	P0817039	BUTTON HD CAP SCR M5-.8 X 8
40	P0817040	KEYED SWITCH YIAN KUANG YS-K1
41	P0817041	ON BUTTON YIAN KUANG YS-F1-G
42	P0817042	OFF BUTTON YIAN KUANG YS-K1
43	P0817043	SWITCH PLATE
44	P0817044	CAP SCREW M8-1.25 X 16
45	P0817045	FENDER WASHER 8MM
46	P0817046	UPPER WHEEL SLIDING BRACKET
47	P0817047	CAP SCREW M6-1 X 50
48	P0817048	RIVET 3.2 X 10 BLIND
49	P0817049	CAP SCREW M6-1 X 10
50	P0817050	CLEAR WINDOW 90 X 70 X 3MM
54	P0817054	LOCK NUT M8-1.25
55	P0817055	UPPER WHEEL COVER
56	P0817056	HEX BOLT M6-1 X 25
57	P0817057	FLAT WASHER 6MM
58	P0817058	WHEEL BRUSH 1-3/4"
59	P0817059	CAP SCREW M6-1 X 25
60	P0817060	LOCK KNOB 60MM DIA
61	P0817061	LOCK NUT M6-1
62	P0817062	STRAIN RELIEF TYPE-3 PG13.5
63	P0817063	GUIDE POST HEIGHT INDICATOR
64	P0817064	HEX NUT M8-1.25
65	P0817065	HEX BOLT M8-1.25 X 35
66	P0817066	KNOB BOLT 6-LOBE M10-1.5 X 20
67	P0817067	KNOB BOLT 6-LOBE M10-1.5 X 53
68	P0817068	LOCK LEVER M10-1.5
69	P0817069	CAM
70	P0817070	BLADE TENSION PILLOW BLOCK
71	P0817071	HANDLE M12-1.75, 26 X 85
72	P0817072	STUD-DE M12-1.75 X 240, 30
73	P0817073	HEX NUT M12-1.75
74	P0817074	LEVER HUB
75	P0817075	BUTTON HD CAP SCR M8-1.25 X 20
76	P0817076	LOCK WASHER 8MM
77	P0817077	HANDLE M8-1.25 X 20, 30 X 78L
78	P0817078	DOCK WASHER 8 X 45 X 5
79	P0817079	SET SCREW M8-1.25 X 20
80	P0817080	HEX NUT M8-1.25
81	P0817081	LOWER WHEEL SHAFT
82V2	P0817082V2	MOTOR 2HP 110V/220V 1-PH V2 .06.19
82V2-1	P0817082V2-1	MOTOR FAN COVER
82V2-2	P0817082V2-2	MOTOR FAN
82V2-3	P0817082V2-3	S CAPACITOR COVER
82V2-4	P0817082V2-4	S CAPACITOR 300M 250V 1-3/4 X 4
82V2-5	P0817082V2-5	R CAPACITOR COVER
82V2-6	P0817082V2-6	R CAPACITOR 40M 250V 1-5/8 X 3-3/4
82V2-7	P0817082V2-7	MOTOR JUNCTION BOX
82V2-8	P0817082V2-8	CONTACT PLATE
82V2-9	P0817082V2-9	CENTRIFUGAL SWITCH 1720 RPM
82V2-10	P0817082V2-10	BALL BEARING 6205ZZ (FRONT)
82V2-11	P0817082V2-11	BALL BEARING 6203ZZ (REAR)
83	P0817083	ADJUSTABLE HANDLE M10-1.5 X 35
84	P0817084	LOCK WASHER 10MM
85	P0817085	MOTOR MOUNT BRACKET

Main Parts List (Cont.)

REF	PART #	DESCRIPTION
86	P0817086	BUTTON HD CAP SCR M8-1.25 X 20
87	P0817087	STRAIN RELIEF PLATE
88	P0817088	TAP SCREW M4 X 8
89	P0817089	MOTOR MOUNT PILLOW BLOCK
91	P0817091	LOCK WASHER 5MM
92	P0817092	MOTOR PULLEY
93	P0817093	POLY-V BELT 290J5
95	P0817095	BLADE STORAGE COVER
111	P0817111	CAP SCREW M6-1 X 20
115	P0817115	CAP SCREW M8-1.25 X 16
130V2	P0817130V2	MAG SWITCH ASSY 110V SDE MPE-18 V2.06.19
130V2-1	P0817130V2-1	CONTACTOR SDE MA-18 110V
130V2-2	P0817130V2-2	OL RELAY SDE RA-20 15-22A
130V2-3	P0817130V2-3	SWITCH BOX
130V2-4	P0817130V2-4	POWER CORD 12G 3W 83" 5-20P
130V2-5	P0817130V2-5	MOTOR CORD 12G 3W 22"
130V2-6	P0817130V2-6	CONTROL CORD 16G 3W 60"
134	P0817134	PHLP HD SCR M5-.8 X 16
152	P0817152	HEX NUT M8-1.25 THIN
155	P0817155	BUSHING
156	P0817156	FLAT WASHER 10MM
157	P0817157	HEX BOLT M8-1.25 X 12
161V2	P0817161V2	MAG SWITCH ASSY 220V SDE MPE09 V2.06.19
161V2-1	P0817161V2-1	CONTACTOR SDE MA-09 220V
161V2-2	P0817161V2-2	OL RELAY SDE RA-20 8–12A
161V2-3	P0817161V2-3	SWITCH BOX
161V2-4	P0817161V2-4	POWER CORD 12G 3W 83" 6-15P
161V2-5	P0817161V2-5	MOTOR CORD 12G 3W 22"
161V2-6	P0817161V2-6	CONTROL CORD 16G 3W 60"

Table, Trunnion & Blade Guides

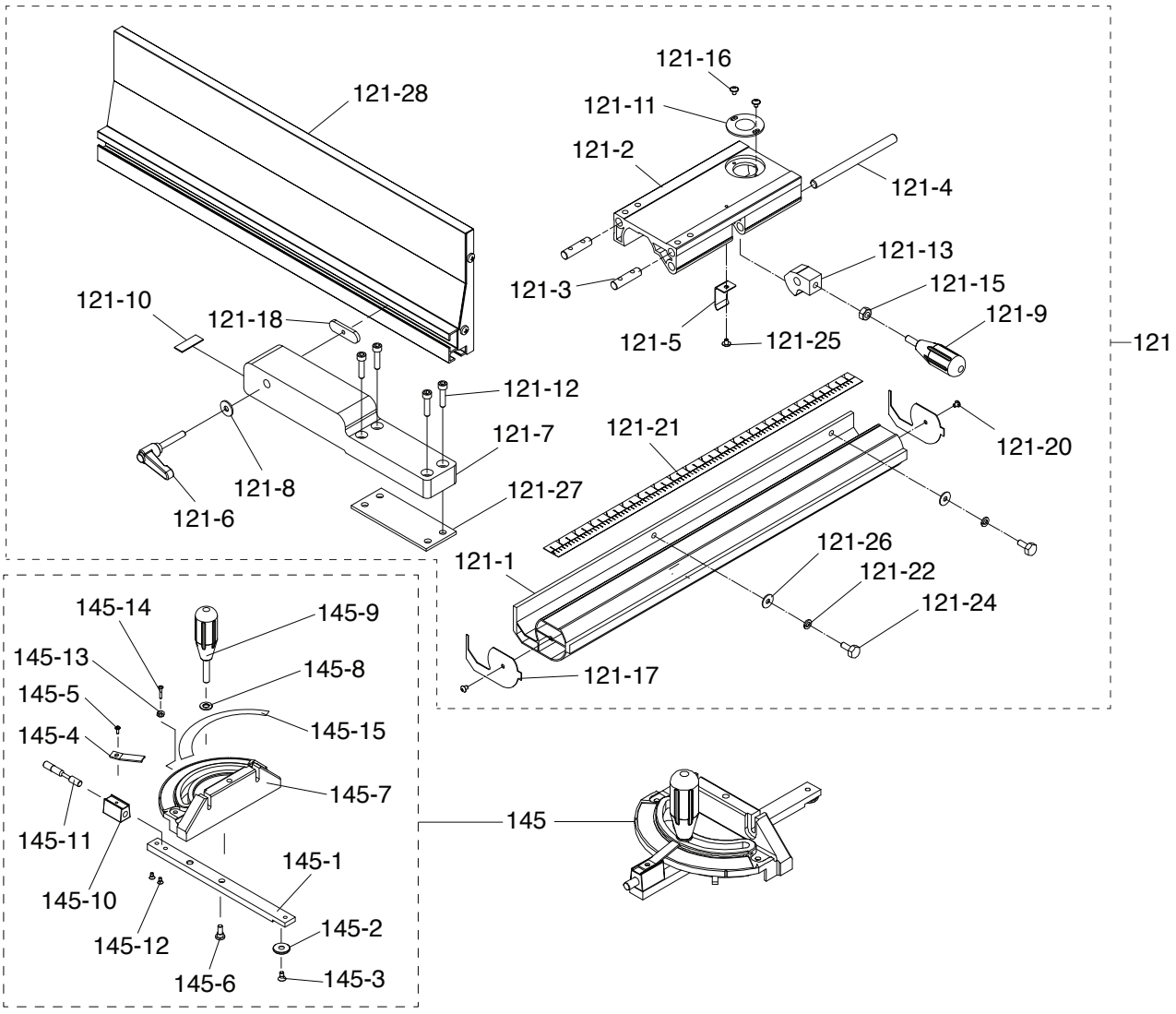


Table, Trunnion & Blade Guides Parts List

REF	PART #	DESCRIPTION
51	P0817051	MAGNET STRIP 7 X 340MM
52	P0817052	GUARD CLEAR WINDOW
53	P0817053	SET SCREW M4-.7 X 4
94	P0817094	SET SCREW M8-1.25 X 6
97	P0817097	TABLE END BRACKET
98	P0817098	CAP SCREW M10-1.5 X 35
103	P0817103	LOCK WASHER 10MM
104	P0817104	FLAT WASHER 10MM
126	P0817126	TABLE
127	P0817127	TABLE INSERT
128	P0817128	ADJUSTABLE HANDLE M8-1.25 X 35, 76L
131	P0817131	BUTTON HD CAP SCR M8-1.25 X 20
132	P0817132	LOCK WASHER 8MM
133	P0817133	GUIDE POST ASSEMBLY
135	P0817135	CAP SCREW M5-.8 X 12
136	P0817136	FLAT WASHER 5MM
137	P0817137	BLADE COVER
137-1	P0817137-1	BLADE COVER SCALE
138	P0817138	FLAT WASHER 8MM
139	P0817139	LOCK WASHER 8MM
140	P0817140	HEX BOLT M8-1.25 X 25
141	P0817141	HANDWHEEL TYPE-4 140D X 10B-S
142	P0817142	CAP SCREW M6-1 X 20
143	P0817143	UPPER BLADE GUIDE ASSEMBLY
143-1	P0817143-1	CAP SCREW M6-1 X 12
143-2	P0817143-2	UPPER BLADE GUIDE SUPPORT BLOCK
143-3	P0817143-3	UPPER GUIDE ADJUSTMENT SHAFT
143-4	P0817143-4	UPPER BLADE GUIDE MOUNTING BLOCK
143-5	P0817143-5	ECCENTRIC SHAFT
143-6	P0817143-6	EXT RETAINING RING 15MM
143-7	P0817143-7	BALL BEARING 6202ZZ
143-8	P0817143-8	BEARING BUSHING
143-9	P0817143-9	CAP SCREW M6-1 X 35
143-10	P0817143-10	UPPER SUPPORT BEARING ADJ SHAFT
143-11	P0817143-11	SET SCREW M6-1 X 10
144	P0817144	LOWER BLADE GUIDE ASSEMBLY
144-1	P0817144-1	LOWER BLADE GUIDE MOUNTING BLOCK
144-2	P0817144-2	CAP SCREW M6-1 X 16
144-3	P0817144-3	ECCENTRIC SHAFT
144-4	P0817144-4	EXT RETAINING RING 15MM
144-5	P0817144-5	BALL BEARING 6202ZZ

REF	PART #	DESCRIPTION
144-6	P0817144-6	BEARING BUSHING
144-7	P0817144-7	CAP SCREW M6-1 X 35
146	P0817146	TRUNNION SUPPORT ASSEMBLY
146-1	P0817146-1	FLAT WASHER 8MM
146-2	P0817146-2	LOCK NUT M8-1.25
146-3	P0817146-3	PHLP HD SCR M4-.7 X 6
146-4	P0817146-4	GEAR PLATE
146-5	P0817146-5	FLAT HD SCR M4-.7 X 6
146-6	P0817146-6	CARRIAGE BOLT M8-1.25 X 85
146-7	P0817146-7	TRUNNION BLOCK
146-8	P0817146-8	CARRIAGE BOLT M8-1.25 X 80
146-9	P0817146-9	ADJ HANDLE M8-1.25, 100L
146-10	P0817146-10	ANGLE SCALE
146-13	P0817146-13	ADJ HANDLE M8-1.25 X 85, 100L
146-14	P0817146-14	FLAT WASHER 4MM
146-15	P0817146-15	POINTER
146-16	P0817146-16	LOCK WASHER 8MM
146-17	P0817146-17	STAR KNOB BOLT M6-1 X 50
146-18	P0817146-18	HEX NUT M6-1
146-19	P0817146-19	TENSION PLATE
146-20	P0817146-20	FLANGE SCREW M5-.8 X 8
146-21	P0817146-21	CAP SCREW M6-1 X 16
146-22	P0817146-22	CAP SCREW M6-1 X 50
146-23	P0817146-23	TRUNNION SUPPORT BRACKET
146-24	P0817146-24	TRUNNION GEAR
146-25	P0817146-25	BUTTON HD CAP SCR M10-1.5 X 30
146-26	P0817146-26	SUPPORT BEARING COVER (R)
146-27	P0817146-27	BALL BEARING 6000ZZ
146-28	P0817146-28	FLAT WASHER 10MM
146-29	P0817146-29	SUPPORT BEARING COVER (L)
146-30	P0817146-30	LOWER SUPPORT ADJUSTMENT SHAFT
146-32	P0817146-32	CAP SCREW M5-.8 X 6
146-33	P0817146-33	LOCK WASHER 10MM
146-34	P0817146-34	FLAT WASHER 6MM
147	P0817147	FLAT WASHER 8MM
148	P0817148	FLAT WASHER 6MM
149	P0817149	FLAT WASHER 8MM
150	P0817150	CAP SCREW M6-1 X 12
151	P0817151	HEX NUT M8-1.25
153	P0817153	FLAT WASHER 8MM
154	P0817154	HEX BOLT M10-1.5 X 35

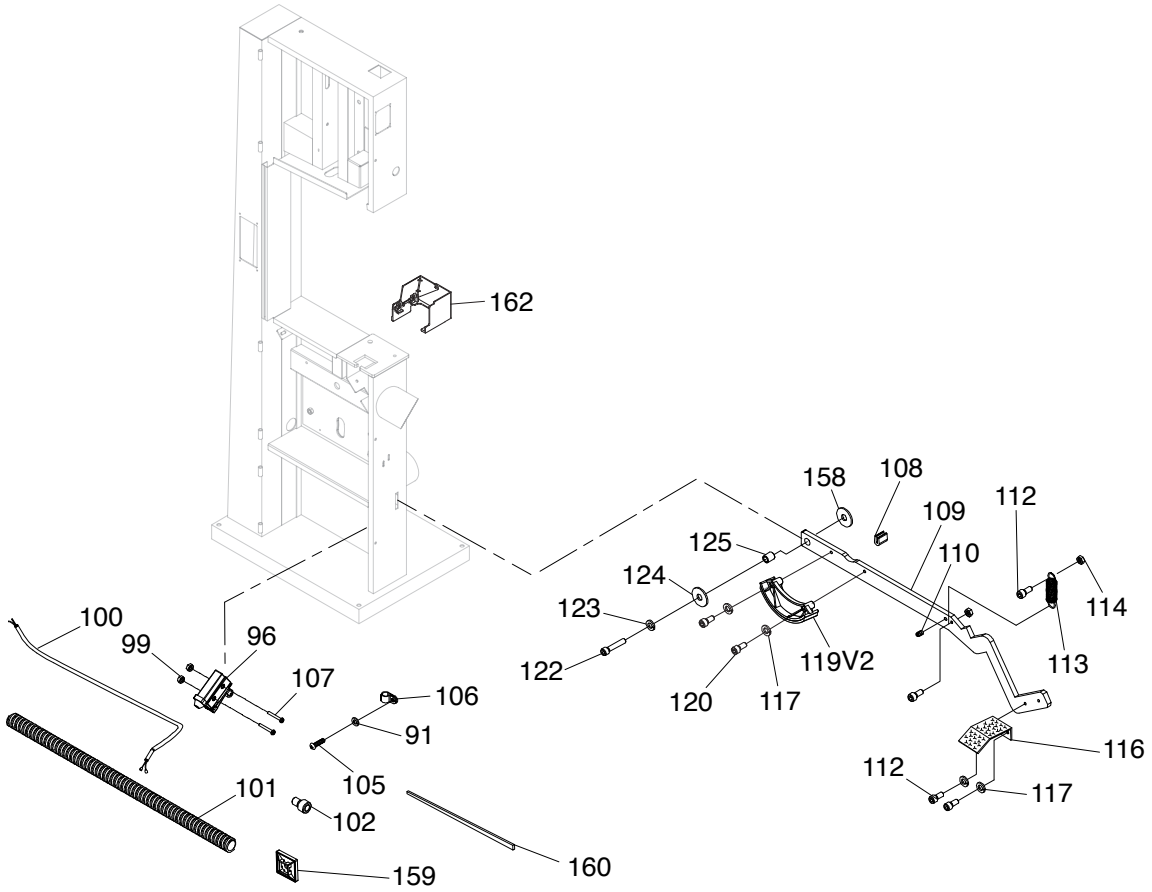
Fence



REF	PART #	DESCRIPTION
121	P0817121	FENCE ASSEMBLY
121-1	P0817121-1	FENCE RAIL
121-2	P0817121-2	FENCE BASE
121-3	P0817121-3	ALIGNMENT PIN
121-4	P0817121-4	LOCK CAM SHAFT
121-5	P0817121-5	SPRING PLATE
121-6	P0817121-6	ADJUSTABLE HANDLE M8-1.25 X 50, 78L
121-7	P0817121-7	FENCE MOUNT BRACKET
121-8	P0817121-8	FLAT WASHER 8MM
121-9	P0817121-9	FENCE LOCK HANDLE M8-1.25 X 22, 30 X 77
121-10	P0817121-10	SLIDE (NYLON)
121-11	P0817121-11	SCALE WINDOW
121-12	P0817121-12	CAP SCREW M6-1 X 25
121-13	P0817121-13	LOCK CAM
121-15	P0817121-15	HEX NUT M8-1.25
121-16	P0817121-16	FLANGE SCREW M4-.7 X 6
121-17	P0817121-17	FENCE RAIL END CAP
121-18	P0817121-18	FENCE GUIDE PLATE
121-20	P0817121-20	TAP SCREW 3.5 X 12
121-21	P0817121-21	FENCE SCALE
121-22	P0817121-22	LOCK WASHER 6MM

REF	PART #	DESCRIPTION
121-24	P0817121-24	HEX BOLT M6-1 X 20
121-25	P0817121-25	FLANGE SCREW M4-.7 X 8
121-26	P0817121-26	FLAT WASHER 6MM
121-27	P0817121-27	FENCE MOUNTING PLATE
121-28	P0817121-28	FENCE
145	P0817145	MITER GAUGE ASSEMBLY
145-1	P0817145-1	MITER BAR
145-2	P0817145-2	MITER BAR GUIDE WASHER 6MM
145-3	P0817145-3	FLAT HD SCR M6-1 X 8
145-4	P0817145-4	POINTER
145-5	P0817145-5	PHLP HD SCR 3/8-24 X 1/2
145-6	P0817145-6	SHOULDER SCREW M6-1 X 12, 8 X 4MM
145-7	P0817145-7	MITER GAUGE BODY
145-8	P0817145-8	FLAT WASHER 8MM
145-9	P0817145-9	HANDLE M8-1.25 X 38, 30 X 77
145-10	P0817145-10	INDEXING BLOCK
145-11	P0817145-11	INDEXING PIN
145-12	P0817145-12	PHLP HD SCR 3/8-24 X 1/2
145-13	P0817145-13	HEX NUT M4-.7
145-14	P0817145-14	PHLP HD SCR M4-.7 X 16
145-15	P0817145-15	MITER SCALE

Foot Brake & Dust Deflector



REF	PART #	DESCRIPTION
91	P0817091	LOCK WASHER 5MM
96	P0817096	LIMIT SWITCH KL7141
99	P0817099	HEX NUT M4-.7
100	P0817100	LIMIT SWITCH CORD 18G 2W 63"
101	P0817101	FLEXIBLE CONDUIT 1/2"ID X 43-1/2"L
102	P0817102	CORD BUSHING
105	P0817105	PHLP HD SCR M5-.8 X 8
106	P0817106	CORD CLAMP 5/8" (PLASTIC)
107	P0817107	PHLP HD SCR M4-.7 X 30
108	P0817108	RUBBER BUMPER 9 X 10
109	P0817109	FOOT BRAKE ARM
110	P0817110	SET SCREW M7-1 X 10 (NYLON)
112	P0817112	CAP SCREW M6-1 X 16
113	P0817113	EXTENSION SPRING 1.6 X 16 X 63

REF	PART #	DESCRIPTION
114	P0817114	HEX NUT M6-1
116	P0817116	FOOT BRAKE PEDAL
117	P0817117	LOCK WASHER 6MM
119V2	P0817119V2	BRAKE SHOE V2.05.25
120	P0817120	CAP SCREW M6-1 X 25
122	P0817122	CAP SCREW M8-1.25 X 25
123	P0817123	LOCK WASHER 8MM
124	P0817124	FLAT WASHER 8MM
125	P0817125	BUSHING
158	P0817158	FLAT WASHER 13 X 22 X .05 (STEEL)
159	P0817159	ADHESIVE CABLE-TIE MOUNT
160	P0817160	CABLE TIE 300MM
162	P0817162	DUST DEFLECTOR

Labels & Cosmetics

REF	PART #	DESCRIPTION
201V2	P0817201V2	MACHINE ID LABEL V2 03.19
202	P0817202	MODEL NUMBER LABEL
203	P0817203	GRIZZLY NAMEPLATE
204	P0817204	DO NOT OPEN DOOR LABEL
205	P0817205	DISCONNECT POWER LABEL
206	P0817206	ELECTRICITY LABEL

REF	PART #	DESCRIPTION
207	P0817207	GRIZZLY.COM LABEL
208	P0817208	TOUCH-UP PAINT, GRIZZLY BEIGE
209	P0817209	TOUCH-UP PAINT, GRIZZLY GREEN
210	P0817210	READ MANUAL LABEL
211	P0817211	EYE/RESPIRATORY HAZARD LABEL
212	P0817212	BLADE TENSION SCALE NOTICE

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

For further information about the warranty, visit **https://www.grizzly.com/forms/warranty** or scan the QR code below to be automatically directed to our warranty page.