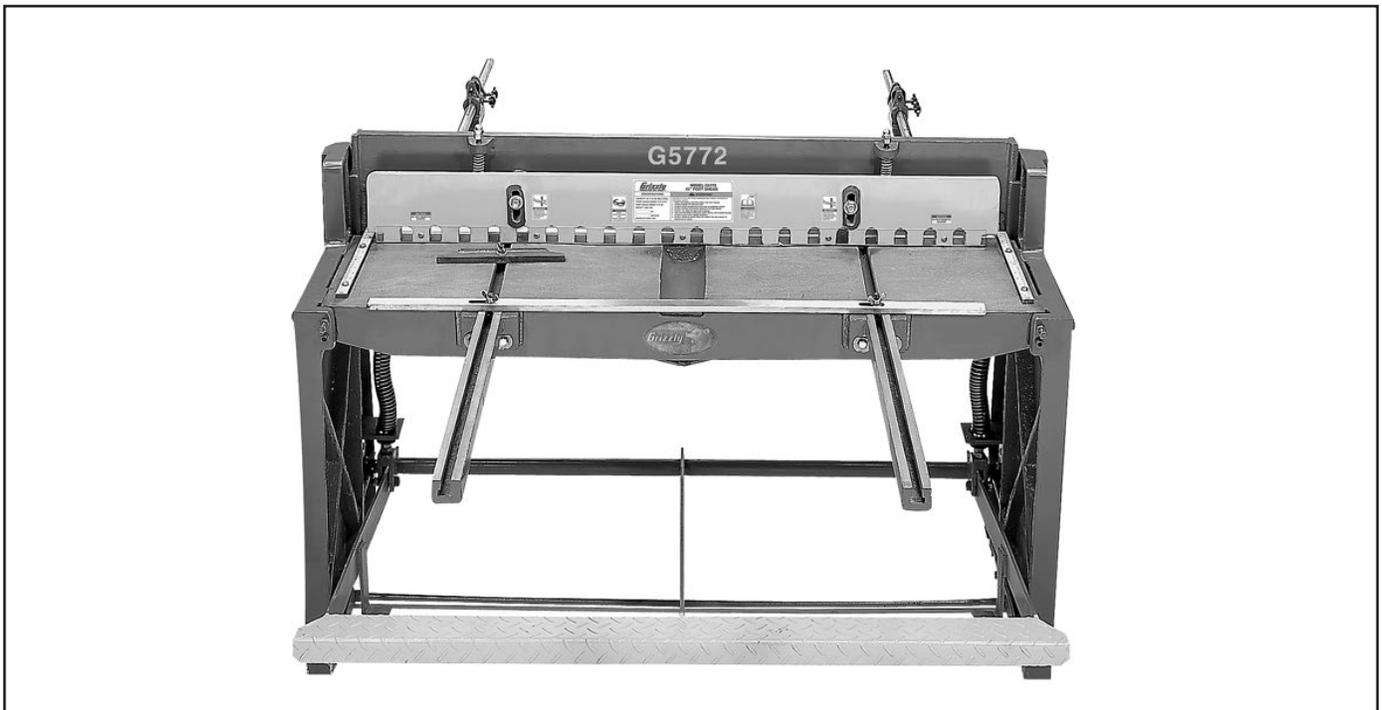


Grizzly *Industrial, Inc.*®

MODEL G5772 52" FOOT SHEAR OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#PC8081 PRINTED IN CHINA



WARNING!

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

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

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

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



WARNING!

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

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

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

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INTRODUCTION

Foreword

We are proud to offer the Model G5772 52" Foot Shear. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G5772. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G5772 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>





MACHINE DATA SHEET

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

MODEL G5772 52" SHEET METAL SHEAR

Product Dimensions:

Weight..... 1035 lbs.
 Width (side-to-side) x Depth (front-to-back) x Height..... 59-1/2 x 80 x 41 in.
 Footprint (Length x Width)..... 59-1/2 x 21-1/4 in.

Shipping Dimensions:

Type..... Wood Crate
 Content..... Machine
 Weight..... 1150 lbs.
 Length x Width x Height..... 46 x 65 x 30 in.

Main Specifications:

Capacities

Maximum Width..... 52 in.
 Maximum Thickness Mild Steel..... 18 Gauge
 Maximum Thickness at Half Width Mild Steel..... 16 Gauge
 Aluminum..... 16 Gauge
 Soft Brass..... 16 Gauge
 Annealed Phosphor Bronze..... 16 Gauge
 Soft Copper..... 16 Gauge
 Hard Copper..... 16 Gauge
 Stainless Steel..... 20 Gauge
 Working Height..... 32 in.
 Front Stop Scale Range..... 0 – 12-1/2 in.
 Rear Stop Scale Range..... 0 – 35 in.

Construction

Frame..... Cast Iron
 Shear Table..... Cast Iron
 Shear Hold-Down Clamp..... Cast Iron
 Shear Blades..... Precision-Ground Hardened Steel

Other Specifications:

Serial Number Location ID Label on front of machine



Identification

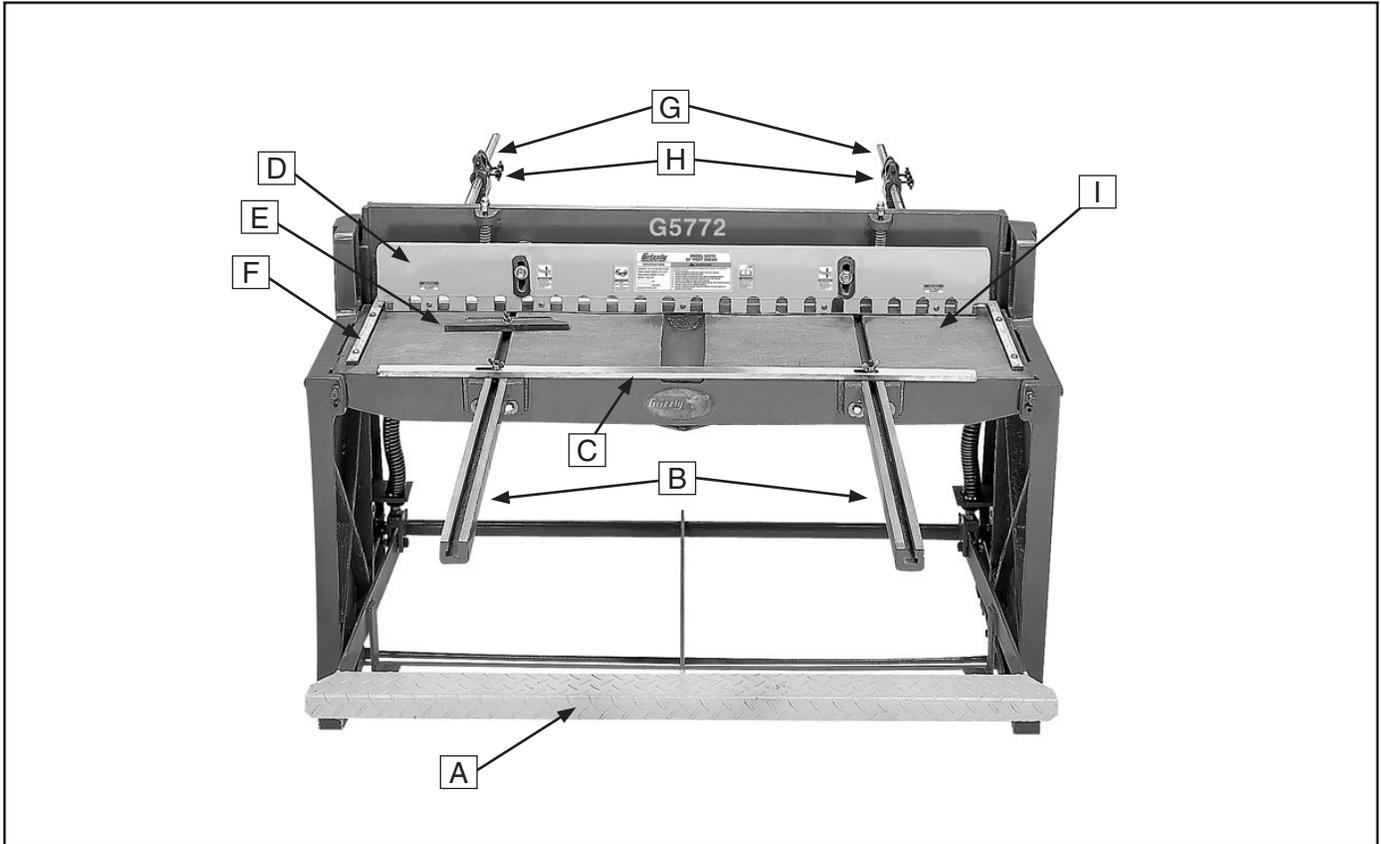


Figure 1. Model G5772 Controls and features.

- A.** Foot Pedal
- B.** Front Extension Arms
- C.** Front Stop
- D.** Hold Down
- E.** Bevel Gauge
- F.** Scale
- G.** Rear Extension Arms
- H.** Rear Adjustment Blocks
- I.** Table



SECTION 1: SAFETY

WARNING

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 which are 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.



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



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



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

NOTICE

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

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Make sure you know the hazards associated with the type of dust you will be exposed to and always wear a respirator approved for that type of dust.



WARNING

Additional Safety Instructions for Foot Shears

1. **GUARDS.** Keep all guards in place and in working order.
2. **FOOTING.** Never stand on the foot pedal with both feet. Keep one foot on the ground at all times to maintain your balance. Never jump on the foot pedal to make a cut.
3. **HANDS AND FINGERS.** Always keep hands and fingers away from the blade and hold down.
4. **OPERATOR POSITION.** Keep all body parts out of the way of all moving parts. Serious pinches and cuts could occur.
5. **CAPACITY.** Never exceed the rated capacity for this foot shear.
6. **PROPER USE.** Only use the foot shear for the purpose it was designed. **DO NOT** cut round stock.
7. **EXTENSION ARMS.** Always be aware of the extension arm location when working around the shear to avoid walking into them, causing injury and damage to the tool.
8. **COMFORTABLE CUTTING OPERATIONS.** Avoid awkward operations and hand positions where a sudden slip could cause your hand or body to fall into a sharp edge or corner.
9. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the shear! Contact Tech Support at (570) 546-9663.
10. **BLADE ADJUSTMENTS AND MAINTENANCE.** Always keep blades properly adjusted and sharp.

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.

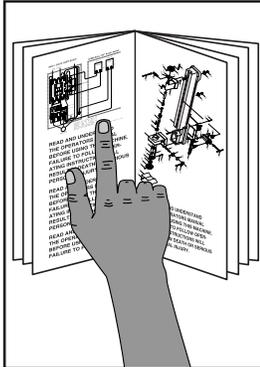
CAUTION

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.



SECTION 2: SET UP

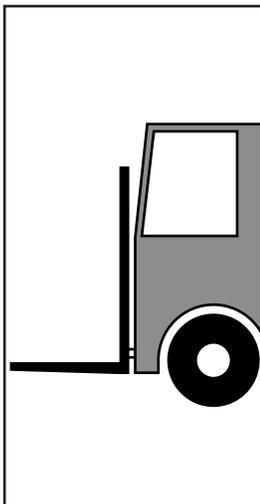
Set Up Safety



!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 set up process!



!WARNING
The Model G5772 is an extremely heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Forklift.....	1
• Lifting Slings.....	2
• Safety Glasses (for each person)	1
• Floor Anchors.....	4
• Power Drill w/ Masonry Drill Bit.....	1
• Shop Rags.....	1
• Cleaning Solvent.....	1
• Feeler Gauge	1
• Medium Weight Paper i.e. Magazine Cover	1-2 Sheets
• Helper.....	1
• Wrench 21mm.....	1
• Wrench 24mm.....	1
• 1/8" Stock for Shim.....	1

Unpacking

The Model G5772 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.



Inventory

After all the parts have been removed from the two boxes, you should have the following items:

Box 1: (Figures 2 & 3)	Qty
A. Foot Shear.....	1
B. Pedal Assembly.....	1
C. Front Extension Arms.....	1
D. Rear Extension Arms w/ Adjustable Stops 2	1
E. Bevel Gauge.....	1
F. Rear Stop.....	1
G. Front Stop.....	1

Hardware and Tools

- Hex Wrench 5mm 1
- Hex Wrench 6mm 1
- Hex Wrench 8mm 1
- Wrench 12/14mm 1
- Wrench 17/19mm 1

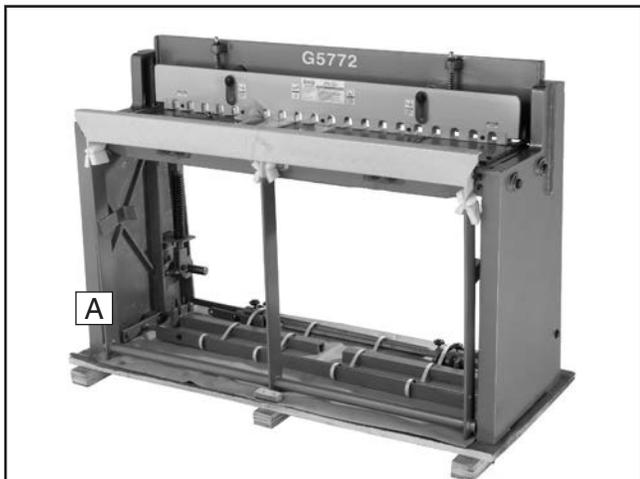


Figure 2. G5772 out of the crate.

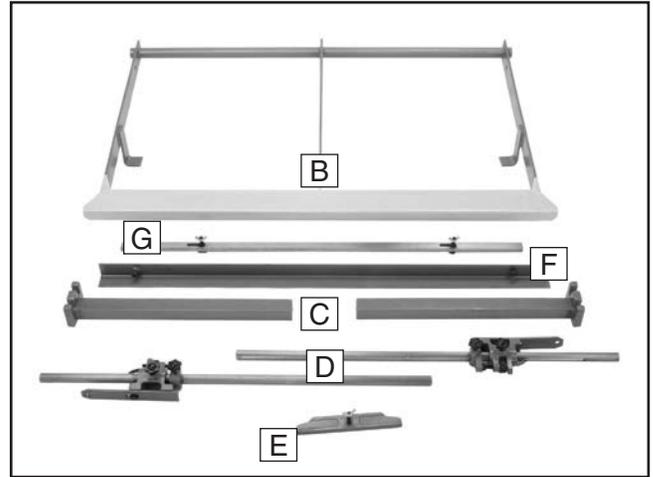


Figure 3. Loose parts inventory.

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

NOTICE

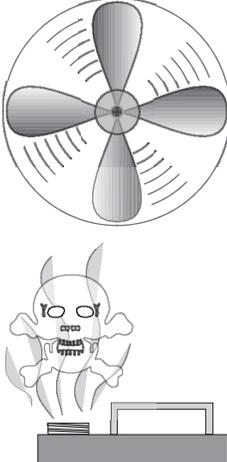
Some hardware/fasteners on the inventory list may arrive pre-installed on the machine. Check these locations before assuming that any items from the inventory list are missing.



Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>⚠️ WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
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	<p>⚠️ CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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Site Considerations

Floor Load

Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

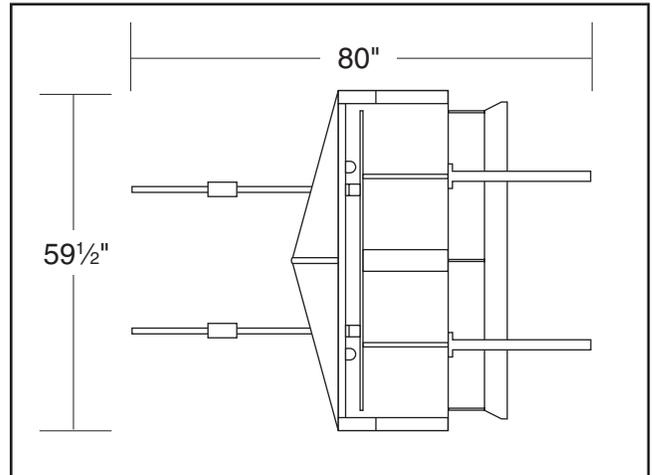
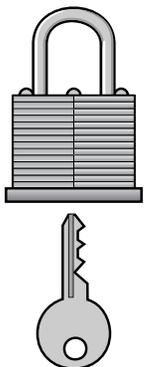


Figure 4. Minimum working clearances.

	<p>⚠️ CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
--	--



Lifting Foot Shear

Your foot shear is a heavy machine weighing in over 1000 lbs. A forklift or other mechanical device will be needed to lift the shear off of the pallet. Have a helper nearby to assist. Lift the foot shear as shown in **Figure 5**.

Mounting to Shop Floor

We recommend that you mount your new machine to the floor for safety, to reduce vibration and to offer the best overall performance. Since floor materials vary, floor mounting hardware is not included. Generally, you can either bolt your machine to the floor using the options described below. Whichever option you choose it will be necessary to use a precision level to level your machine.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (**Figure 6**) and anchor studs (**Figure 7**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine at a later point.

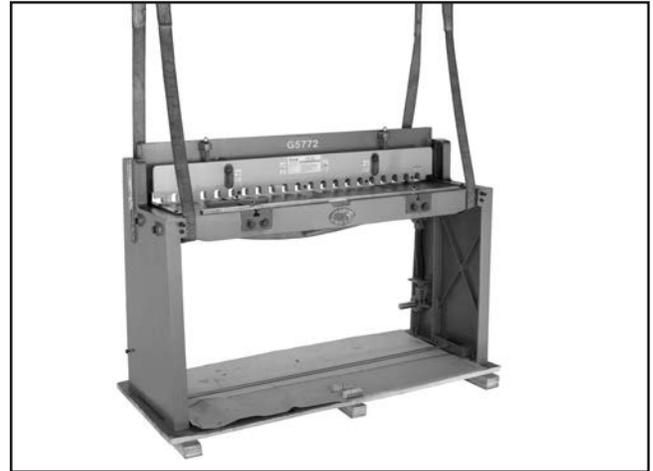


Figure 5. Lifting the foot shear.

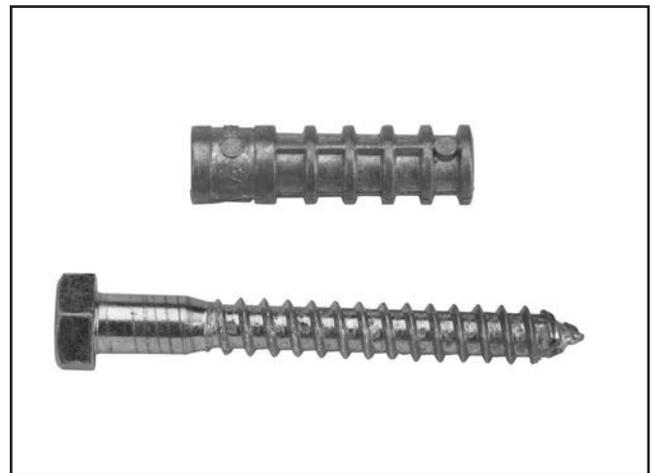


Figure 6. Typical lag shield anchor and lag bolt.

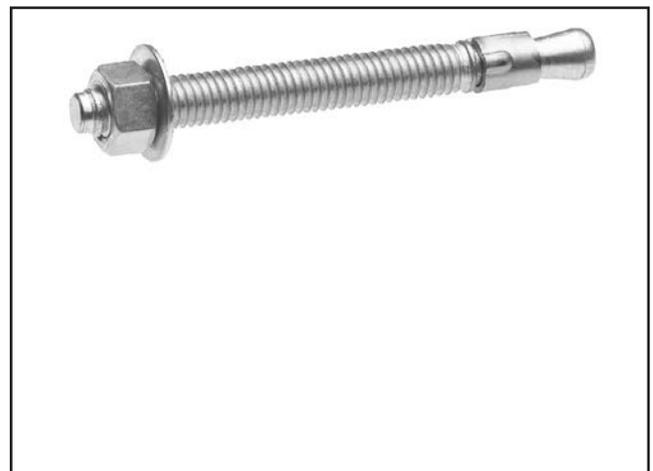


Figure 7. Typical anchor stud.



Foot Pedal

You will need the help of an assistant for this step.

Components and Hardware Needed:	Qty
Foot Pedal Assembly	1
Hinge Pins	2

To install the foot pedal:

1. Loosen the set screws that hold the hinge pins in place and slide them outward.
2. With the help of an assistant, position the foot pedal pivot over the hinge pin hole and insert the hinge pin.
3. Tighten the set screws to hold the hinge pin in position.
4. Link the two swivel bottoms through the side arms of the foot pedal with the supplied bolts and tighten in position.
5. When complete, the finished assembly should look like **Figure 8**.

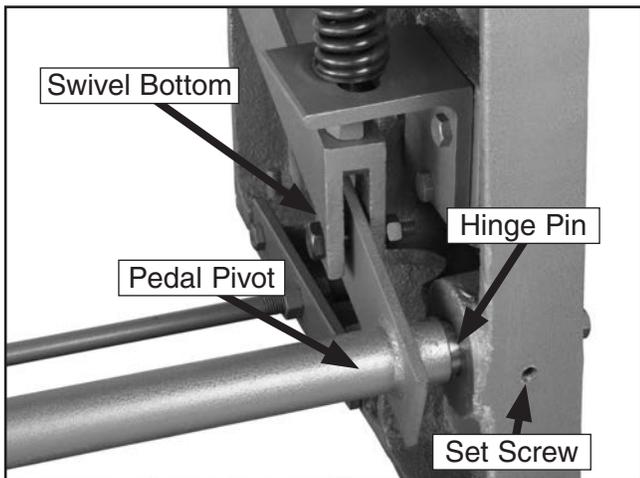


Figure 8. Foot pedal assembly.

Front Extension Arms

Components and Hardware Needed:	Qty
Front Extension Arms.....	2
19mm Bolts.....	4
Special Flat Washers	2

To install the front extension arms:

1. Loosen the four 19mm bolts on the front of the table.
2. Place the front extension arms over the bolt and behind the special washers.
3. Line up the channel of the front extension arm with the channel on the table.
4. Make sure the ground flat surface on the front extension arms are flush with the top of the table surface.
5. Tighten the bolts and check to make sure your alignments are still intact. If they are not, readjust.
6. When complete the finished assembly should look like **Figure 9**.

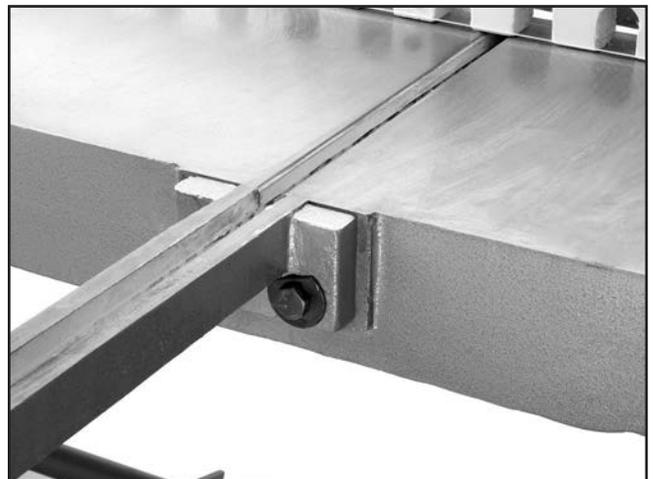


Figure 9. Front extension arm installed.



Rear Extension Arms

Components and Hardware Needed:	Qty
Rear Extension Arms	2
Rear Stop	1

To install the rear extension arms:

1. Slide the rear extension arms into the sockets on the back of the table with the scales face.
2. Tighten the set screws.
3. Attach the rear stop to the rear extension bars and secure with the provided knurled thumb screws.
4. When complete, the finished assembly should look like **Figure 10**.

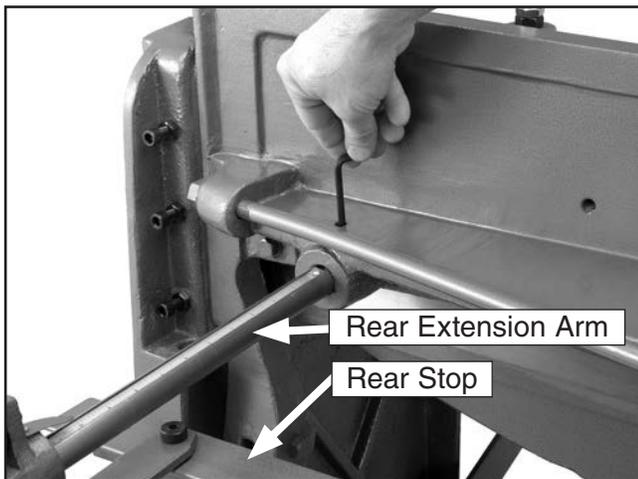


Figure 10. Installing rear extension arm.

Hold Down Adjustment

Components and Hardware Needed:	Qty
1/8" Stock for Shim.....	1

To adjust the hold down:

1. Tighten the hex nut on top of the spring to raise the hold down off the table.
2. Insert the shim stock under a hold down finger, turn the hex nut to lower the hold down until it makes light contact with your shim.
3. Repeat **Steps 1 & 2.** at the other side of the shear.
4. Tighten the two fixing bolts on the front of the hold down to secure it in place (see **Figure 11**).

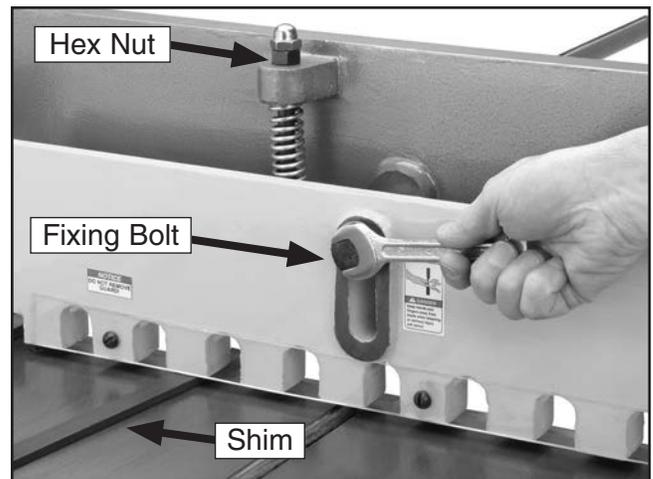


Figure 11. Tightening hold down.

5. Recheck the gap to make sure the distance is equal across the length of the hold down.

Tip: To avoid scratching the surface of your workpiece, apply thin rubber pads to the bottom of the hold down fingers.



Blade Adjustment

The blade adjustment has been made at the factory before shipment. A few test cuts will determine if this adjustment is satisfactory for your needs. If it is, you are ready to start using your foot shear. However, you may find it necessary to check the blade adjustment before continuing. Depending on how often you change the type and gauge of material you cut, this adjustment process will become routine.

To perform the blade set up:

1. Loosen, but do not remove the two table bolts and table adjustment screws on both sides of the foot shear (see **Figure 12**).

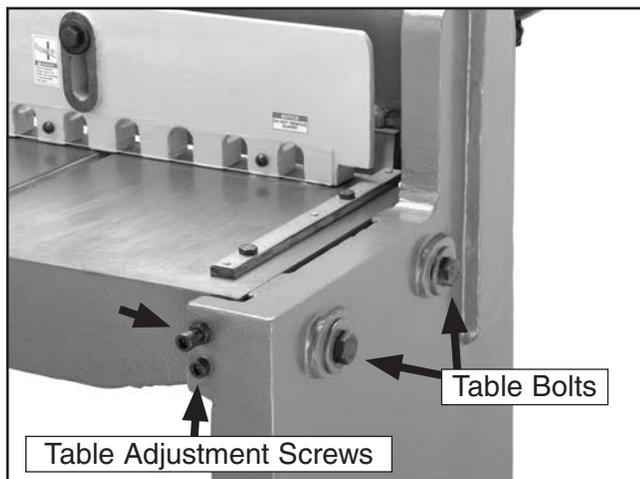


Figure 12. Adjustment screws.

2. Using the foot pedal, lower the blade and hold it in position. (It may help to have your assistant do this step.)
3. Turn the table adjustment screws to move the table and fixed blade until the fixed blade makes light contact with the moving blade.

NOTICE: The moving blade should never overlap the fixed blade. This will cause damage to both.

4. Looking behind the hold down, make sure the two blades surfaces appear to make light contact all the way across the length.

—If they do, proceed to the next step.

—If you observe a gap between the two blade surfaces, move to the next section **Adjusting Blade Bow** section.

5. Using a sheet of paper, confirm that you have proper contact by making several cuts along the length of the blade. The shear should cut through the paper cleanly.
6. Turn the table adjustment screws to move the fixed blade away from the moving blade so you have a gap of 0.002". Check this measurement with a feeler gauge as shown in **Figure 13**.

Note: The gap width will change depending on the type and gauge of the material being sheared. This is a trial-and-error process. Test with scrap pieces until you achieve satisfactory results.

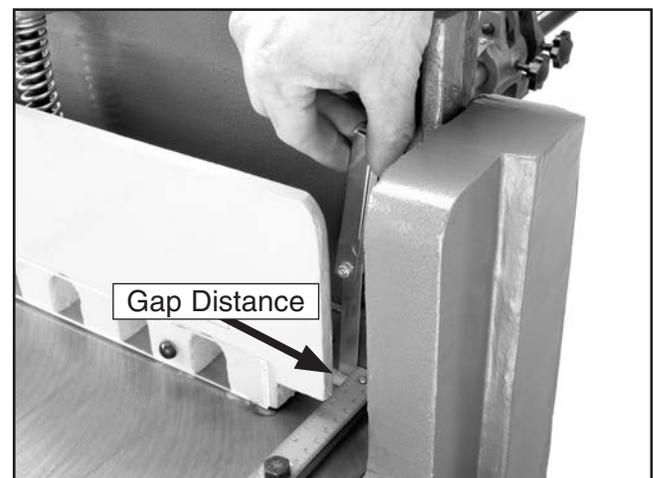


Figure 13. Measuring gap between blades.

7. Repeat step on the other side so the gap is uniform across the length of the blade.
8. Tighten the four leg bolts and double check the gap to make sure it has not changed.



Adjusting Blade Bow

The blade bow of the moving blade is adjusted by loosening or tightening the bow bolt at the center of the straightening rod (see **Figure 14.**) Observe the change in the gap when the moving blade is just below the top of the fixed blade. After making adjustments to the bow, repeat the **Blade Adjustment** section.

- If the shear cuts paper on the ends but not the center, turn the bow bolt clockwise until paper is cut across the length.
- If the shear cuts paper at the center but not the ends, turn the bow bolt counter-clockwise until the paper is cut across the length.

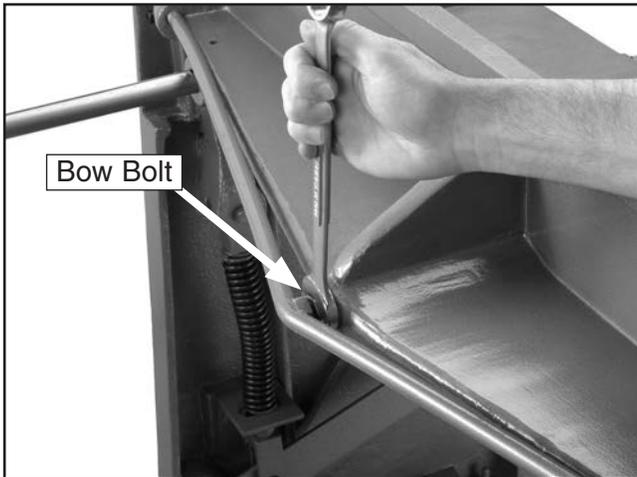


Figure 14. Adjusting bow bolt.



Figure 15. Paper shear test.

Finger Guard

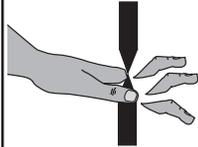
A clear plastic finger guard is fixed to the front of the hold down. Under no circumstances should this guard be removed. It will keep your fingers out of the blade but it will *NOT* protect you from the crushing force of the hold down. Never let any part of your body get behind this finger guard! Be sure to keep the guard in working order and maintain the position and readability of all the warning labels.

NOTICE
**DO NOT REMOVE
GUARD!**



SECTION 3: OPERATIONS

Operation Safety



⚠ DANGER

CRUSHING AND SEVERING HAZARD!

Keep hands and fingers away from hold down and blade when shearing or serious injury will occur!



⚠ WARNING

Damage to your eyes and ears could result from using this machine without proper protective gear. Always wear safety glasses, and hearing protection when operating this machine.

NOTICE

If you have never used this type of machine or equipment before, **WE STRONGLY RECOMMEND** that you read books, trade 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.

Stops & Guides

The front stop and angle guide are quickly adjusted by wing nuts on the top of the stops. The rear extension arms have micro-adjusting stops in **Figure 16** that allow you to fine tune your cut length. For the most accurate cuts, make sure that you have at least one square edge up against a stop.

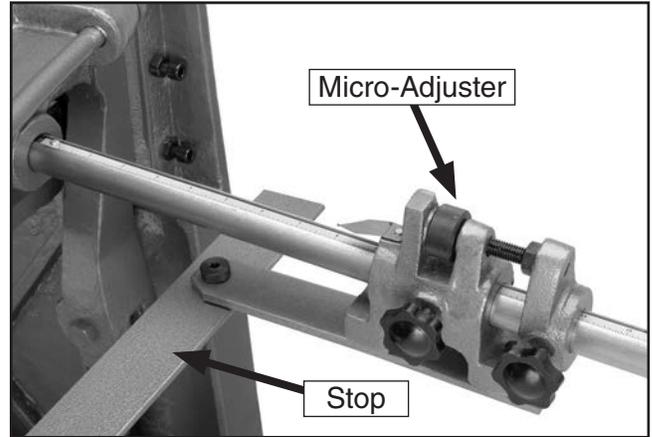


Figure 16. Micro-adjusting stop.

Shearing Tips

- For the best results, never cut any piece narrower than eight times the thickness of the material. For example 1/2" strip of .06 mild steel.
- Keep the blade gap to the smallest distance possible.
- The table below lists other materials and the equivalent decimal thicknesses that can be used on this shear.

	16 GA.	18 GA.	20 GA.
Mild Steel	.060	.048	.036
Stainless			.031
Cold Rolled	.048	.035	.030
Aluminum	.100	.090	.063
Brass, Yellow			
• Soft	.072	.064	.051
• 1/2 Hard	.064	.051	.036
• Hard	.054	.051	.036
Bronze, Phosphor			
• Annealed	.064	.051	.040
Copper			
• Soft	.072	.064	.051
• Hard	.064	.051	.040

Figure 17. Lists equivalent material thickness.



SECTION 4: ACCESSORIES

G5618—Deburring Tool with two Blades

G5619—Extra Aluminum Blades

G5620—Extra Brass and Cast Iron Blade

The quickest tool for smoothing freshly sheared metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



Figure 18. G5618 Deburring tool.

H3153—Pigskin Palm Gloves

H3154—Lined Pigskin Palm Gloves

Durable pigskin leather is combined with cloth backs for true comfort. One size fits many.

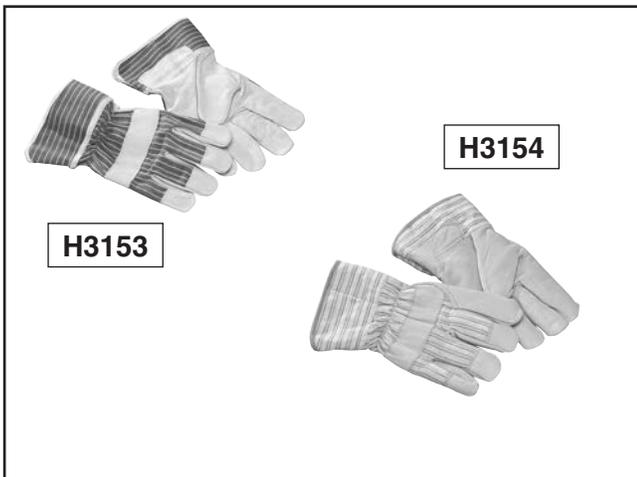


Figure 19. Work gloves.

H5614—Wire Gauge US Standard

Calibrated for sheet metal sized from 0 to 30 gauge. The front is marked with gauge sizes, the back is marked with actual inch measurements.



Figure 20. H5614 Wire Gauge.

H7205—Machinery's Handbook

For more than 90 years, this 2,704 page handbook has been the benchmark by which machinist and engineering texts have been judged. Includes a wealth of information on mathematics, mechanics, measurements, and materials. A must have for the amateur or professional.

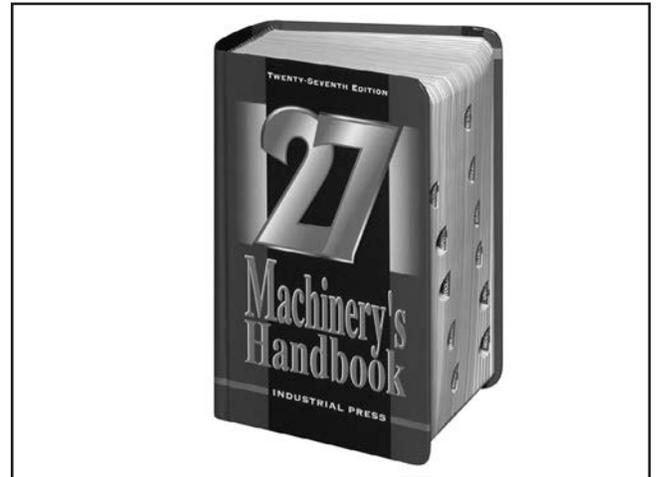


Figure 21. Model H7205 Machinery's Handbook.

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SECTION 5: MAINTENANCE

Blade Care

The blades can be removed by removing the eight hex bolts that attach the blades to the castings (see **Figure 22**).

The moving blade has two cutting edges that are ground with a 2° edge relief. Reverse the blade to expose the new cutting edge as soon as one edge is dull. The blade can be sharpened on a surface grinder by grinding both wide sides of the blade.

The fixed blade has one cutting edge with a 2° edge relief and a 1° face relief. It can be resharpened on a surface grinder by grinding the wide side of the blade.

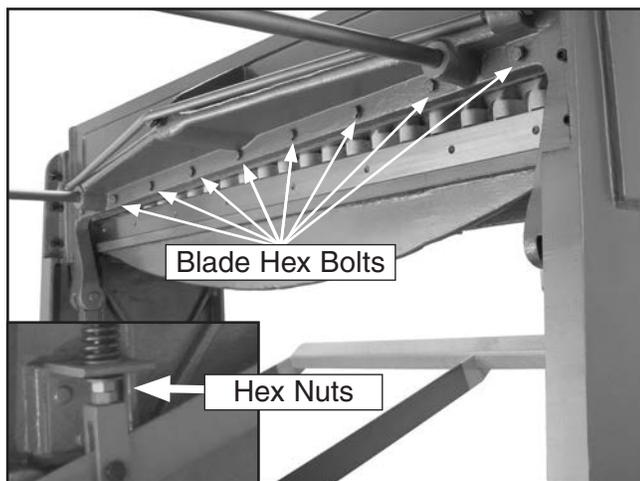


Figure 22. Blade bolts and return spring.

Return Spring Tension

The return spring can be adjusted on the foot lever. To increase the return rate, tighten the hex nuts against the spring as shown in **Figure 22**.

Gib Adjustment

When adjusting gibs, keep in mind that the goal of gib adjustment is to remove unnecessary slide movement without causing them to bind. Loose gibs may allow play in the moving blade resulting in poor cuts on the workpiece and undue wear on the slide. Over-tightening will make lowering the foot pedal difficult.

Adjust each of the three gib screws on each side in small, equal increments. Test for binding or play after each adjustment by pushing and pulling the top of the cutter bar.

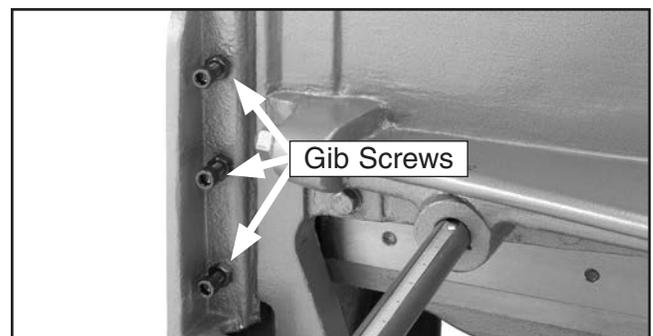


Figure 23. Gib screw location.

Lubrication

Lubricate all pivot and sliding points on this machine daily. Lightly oil the surface of the blades and other bare cast iron surfaces to ensure they don't develop rust.



SECTION 6: SERVICE

Review the troubleshooting and procedures in this section to fix your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

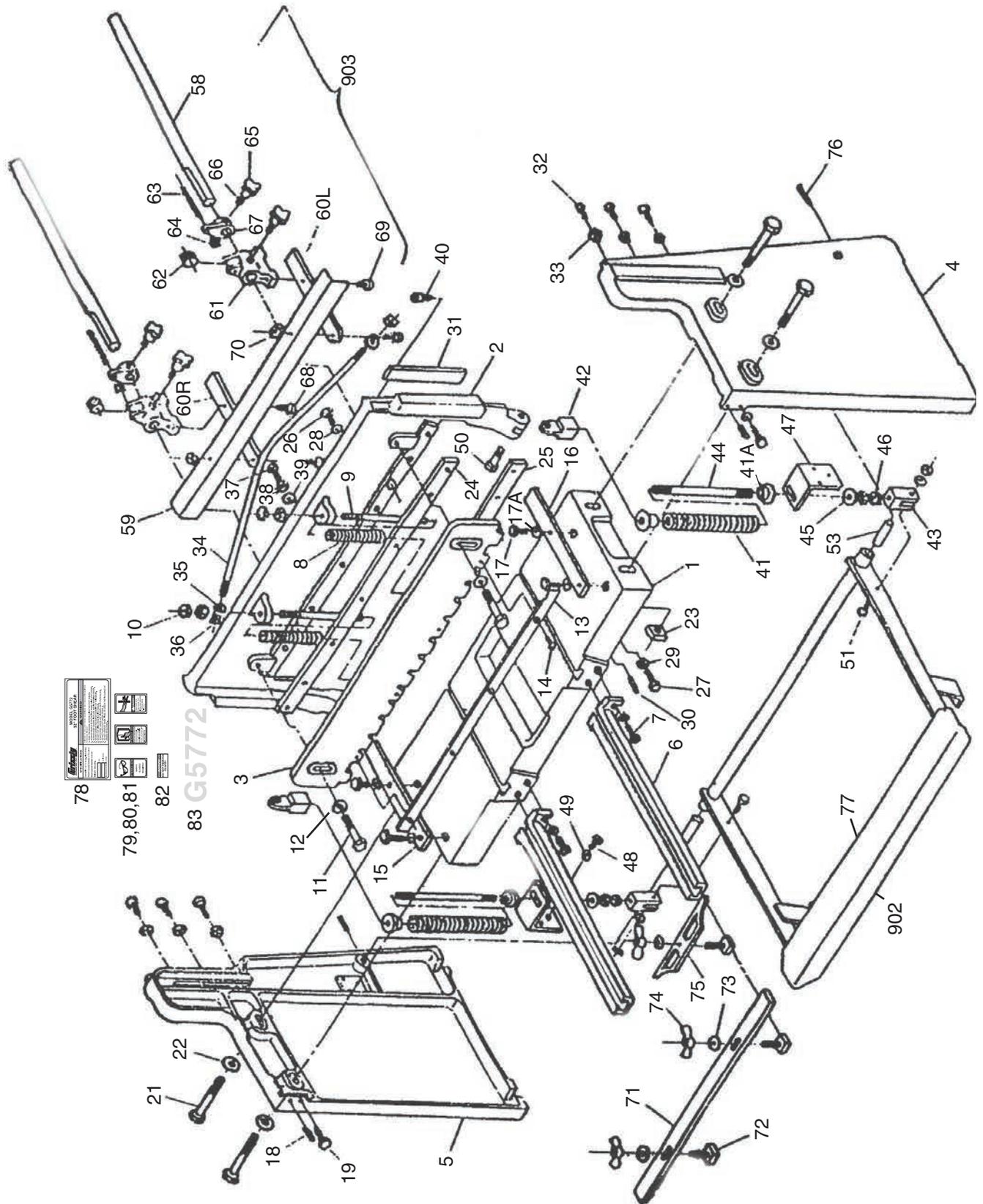
Troubleshooting

Operations

Symptom	Possible Cause	Possible Solution
Won't cut material.	1. Improper blade gap distance.	1. Widen gap to accommodate thicker gauge material.
Cuts aren't square.	1. Blade gap unequal across length. 2. Too much bow in blade. 3. Inadequate hold down pressure. 4. Uneven contact with guides.	1. Adjust blade gap to be equal across length. 2. Correct blade bow. 3. Adjust gap of hold down. 4. Maintain consistent contact with guides.
Poor quality of cuts, ripping or tearing.	1. Dull blades. 2. Poor blade gap set up. 3. Loose gibs.	1. Replace or sharpen blades. 2. Adjust blade set up. 3. Remove play from gibs.



Parts Breakdown



Parts List

REF	PART #	DESCRIPTION
1	P5772001	TABLE
2	P5772002	CUTTER BAR
3	P5772003	HOLD DOWN
4	P5772004	RH SIDE PANEL
5	P5772005	LH SIDE PANEL
6	P5772006	FRONT ARM EXT
7	P5772007	HEX BOLT M12-1.75 X 45
8	P5772008	HOLD DOWN SPRING 12
9	P5772009	HOLD DOWN SPRING STUD
10	P5772010	HEX NUT M12-1.75
11	P5772011	HEX BOLT M12-1.75 X 65
12	P5772012	FLAT WASHER 12MM
13	P5772013	FINGER GUARD
14	P5772014	CAP SCREW M8-1.25 X 12
15	P5772015	LH TABLE SCALE
16	P5772016	RH TABLE SCALE
17	P5772017	TABLE SCALE SCREW
17A	P5772017A	TABLE SCALE WASHER
18	P5772018	SET SCREW M10-1.5 X 50
19	P5772019	CAP SCREW M10-1.5 X 40
21	P5772021	HEX BOLT M16-2 X 120
22	P5772022	FLAT WASHER 16MM
23	P5772023	HEX NUT M16-1.5
24	P5772024	MOVING KNIFE (UPPER)
25	P5772025	FIXED KNIFE (LOWER)
26	P5772026	HEX BOLT M10-1.5 X 40
27	P5772027	CAP SCREW M10-1.5 X 55
28	P5772028	FLAT WASHER 10MM
29	P5772029	FLAT WASHER 10MM
30	P5772030	SET SCREW M12-1.75 X 12
31	P5772031	GIB
32	P5772032	CAP SCREW M10-1.5 X 30
33	P5772033	HEX NUT M10-1.5
34	P5772034	STRAIGHTENER ROD
35	P5772035	FLAT WASHER 16MM
36	P5772036	HEX NUT M16-1.5
37	P5772037	ADJ SCREW M16 X 50
38	P5772038	HEX NUT M16-1.5
39	P5772039	FLAT WASHER 16MM
40	P5772040	SET SCREW M10-1.5 X 20
41	P5772041	FOOT PEDAL SPRING

REF	PART #	DESCRIPTION
41A	P5772041A	CAP SPRING
42	P5772042	SWIVEL TOP
43	P5772043	SWIVEL BOTTOM
44	P5772044	STUD
45	P5772045	LOCK WASHER 16MM
46	P5772046	HEX NUT M16-1.5
47	P5772047	SPRING MOUNTING BRACKET
48	P5772048	CAP SCREW M10-1.5 X 25
49	P5772049	FLAT WASHER 10MM
50	P5772050	TOP SWIVEL SCREW
51	P5772051	BOTTOM SWIVEL SCREW
53	P5772053	HINGE PIN
58	P5772058	BACK GAUGE ROD
59	P5772059	BACK GAUGE STOP
60L	P5772060L	BACK GAUGE EXT BAR (L)
60R	P5772060R	BACK GAUGE EXT BAR (R)
61	P5772061	ADJUSTABLE BLOCK
62	P5772062	ADJUSTABLE DIAL
63	P5772063	ADJUSTABLE SCREW
64	P5772064	HEX NUT M10-1.5
65	P5772065	LOCK KNOB
66	P5772066	STUD
67	P5772067	ROD BRACKET
68	P5772068	EXT BAR SCREW
69	P5772069	HEX BOLT M10-1.5 X 25
70	P5772070	HEX NUT M10-1.5
71	P5772071	FRONT STOP
72	P5772072	T-BOLT
73	P5772073	FLAT WASHER 3/8"
74	P5772074	WING NUT
75	P5772075	BEVEL GAUGE
76	P5772076	SET SCREW M10-1.5 X 20
77	P5772077	FOOT PEDAL
78	P5772078	MACHINE ID LABEL
79	P5772079	SAFETY GLASSES LABEL
80	P5772080	READ MANUAL LABEL
81	P5772081	SHEARED FINGERS LABEL
82	P5772082	GUARD LABEL
83	P5772083	MODEL NUMBER LABEL
902	P57720902	PEDAL ASSY
903	P57720903	BACK GAUGE ASSY

WARNING

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



WARRANTY AND RETURNS

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

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

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

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

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

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





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<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
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<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
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<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
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- Do you think your machine represents a good value? Yes No
- Would you recommend Grizzly Industrial to a friend? Yes No
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