



**MODEL T32304**  
**10" 3/4 HP MEAT**  
**CUTTING BANDSAW**  
**OWNER'S MANUAL**  
*(For models manufactured since 02/21)*



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#KS21596 PRINTED IN CHINA

V1.09.22

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



## **WARNING!**

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

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

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

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



## **WARNING!**

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

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

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

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## WARNING

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

## WARNING

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.

# 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


## Manual Accuracy

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

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

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

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

		MODEL GXXXX MACHINE NAME	
<b>SPECIFICATIONS</b>		<b>WARNING!</b>	
Motor:		To reduce risk of serious injury when using this machine:	
Specification:		1. Read manual before operation.	
Specification:		2. Wear safety glasses and respirator.	
Specification:		3. Make sure machine is properly adjusted/setup and	
Specification:		4. Make sure the motor has stopped and disconnect	
Weight:		power before adjustments, maintenance, or service.	
		5. DO NOT expose to rain or dampness.	
		6. DO NOT modify this machine in any way.	
		7.	
		8.	
		9. Do not use while under the influence of drugs or alcohol.	
		10. Maintain machine carefully to prevent accidents.	
Manufactured for Grizzly in Taiwan			

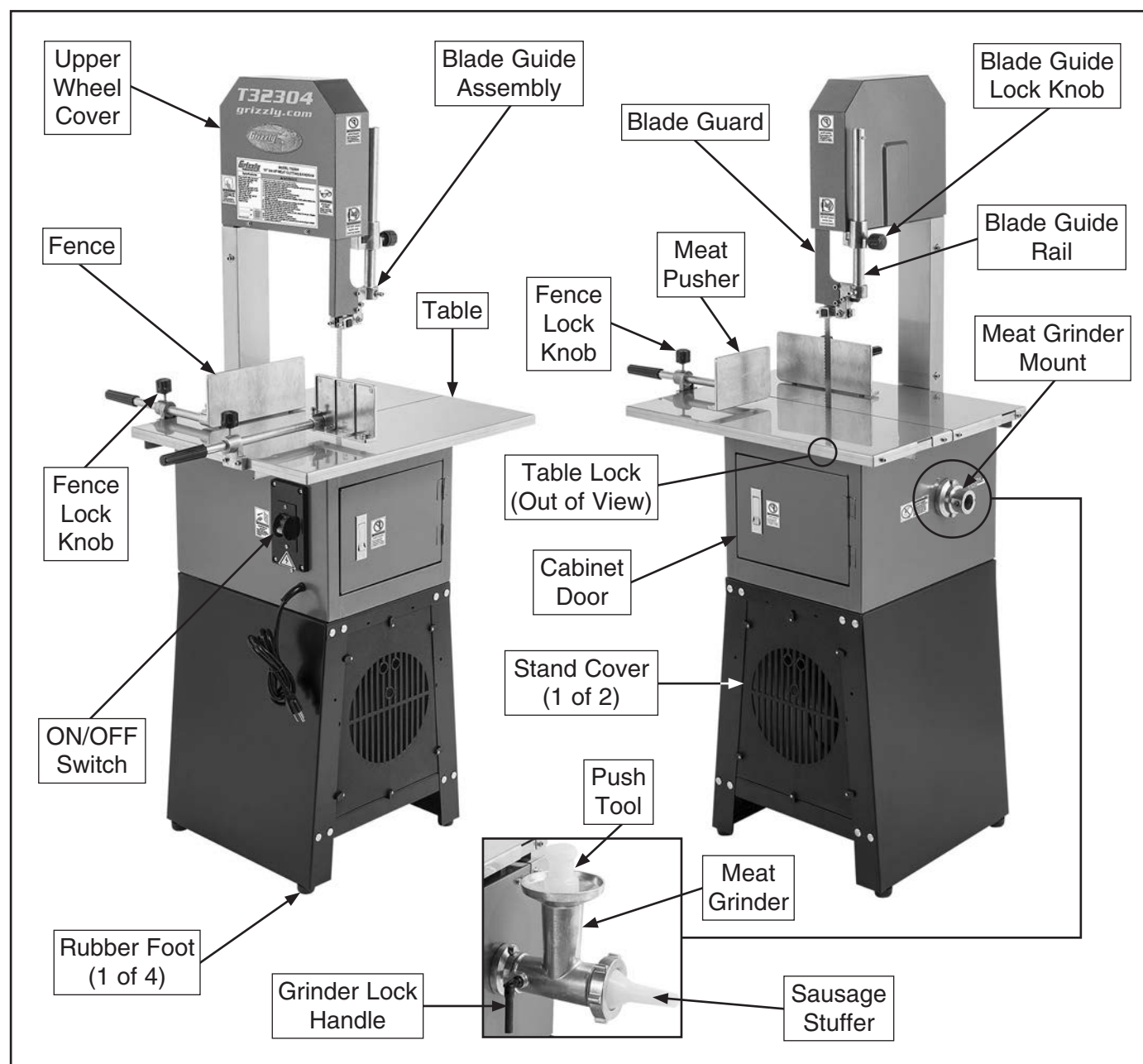
**Manufacture Date** [ ]

**Serial Number** [ ]



# 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.**

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

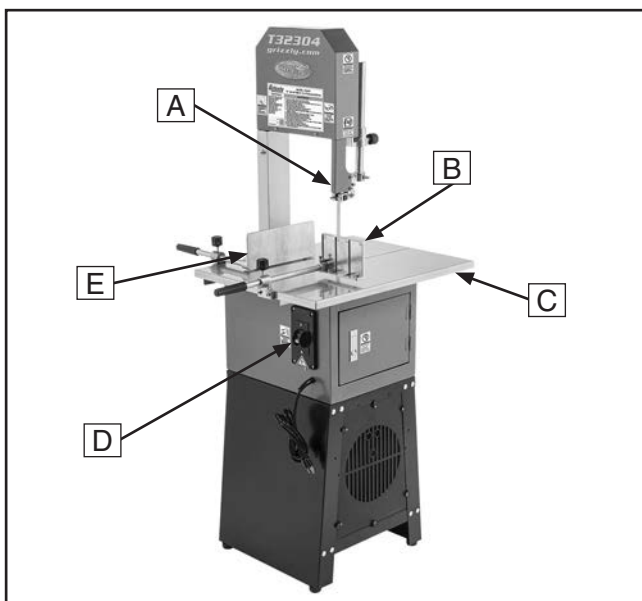


# Controls & Components



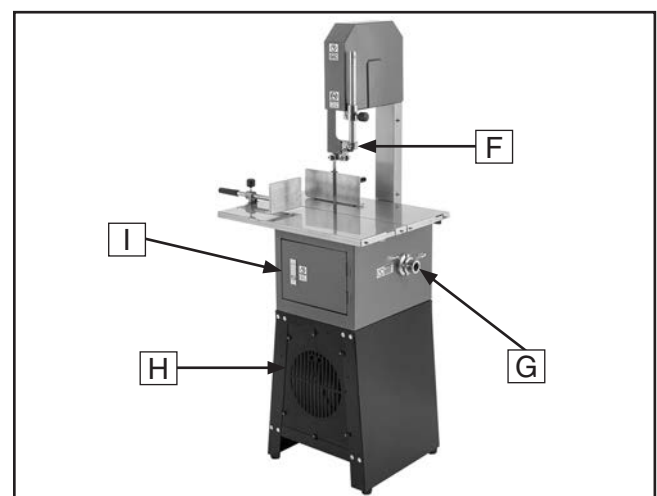
Refer to the following figures and descriptions to become familiar with the basic controls and components of this machine. Understanding these items and how they work will help you understand the rest of the manual and minimize your risk of injury when operating this machine.

- A. Blade Guard:** Protects operator from accidental contact with portion of blade not cutting through a workpiece.
- B. Meat Pusher:** Moves workpiece through entire range of cut while providing adequate support to keep hands out of the way.
- C. Table:** Slides across saw body to support large workpieces through entire range of cut.
- D. ON/OFF Push Button Switch:** Push the green "-" button to turn motor **ON**. Push the red "O" button to turn motor **OFF**.



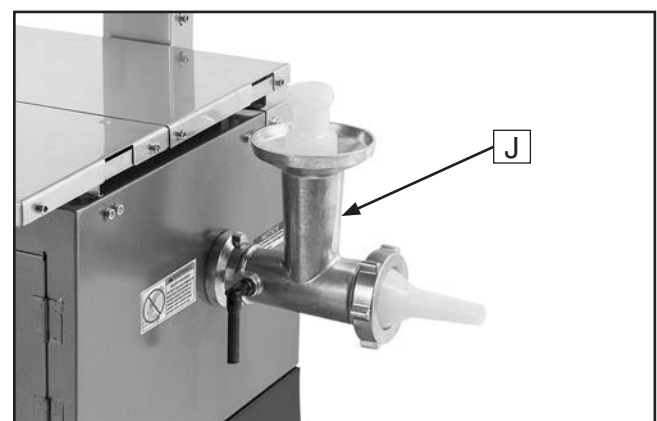
**Figure 1.** Front components.

- E. Fence:** Supports workpiece and adjusts to desired width of cut.
- F. Blade Guide Assembly:** Uses blade guides and a support bearing to help keep blade straight while cutting. Can be adjusted up or down depending on workpiece height.
- G. Meat Grinder Mount:** Connects meat grinder to saw body.
- H. Stand Cover:** Slotted design provides airflow to prevent motor from overheating. Can be removed to access internal components for cleaning and maintenance.
- I. Cabinet Door:** Access internal saw components for cleaning and maintenance.



**Figure 2.** Rear components.

- J. Meat Grinder:** Grinds hamburger or sausage. Automatically engages when installed.



**Figure 3.** Meat grinder.





# MACHINE DATA SHEET

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

## MODEL T32304 10" 3/4 HP MEAT CUTTING BANDSAW

### Product Dimensions:

Weight..... 94 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 44-1/2 x 24 x 58 in.  
Footprint (Length x Width)..... 16-1/2 x 16-1/2 in.

### Shipping Dimensions:

Type..... Cardboard Box and Wood Pallet  
Content..... Machine  
Weight..... 117 lbs.  
Length x Width x Height..... 39 x 20 x 25 in.  
Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 120V, Single-Phase, 60 Hz  
Full-Load Current Rating..... 4.6A  
Minimum Circuit Size..... 15A  
Connection Type..... Cord & Plug  
Power Cord Included..... Yes  
Power Cord Length..... 72 in.  
Power Cord Gauge..... 18 AWG  
Plug Included..... Yes  
Included Plug Type..... 5-15  
Switch Type..... ON/OFF Push Button Switch

### Motors:

#### Main

Horsepower..... 3/4 HP  
Phase..... Single-Phase  
Amps..... 4.6A  
Speed..... 1725 RPM  
Type..... TEFC Induction  
Power Transfer ..... Belt  
Bearings..... Shielded & Permanently Lubricated

### Main Specifications:

#### Main Specifications

Bandsaw Size..... 10 in.  
Max Cutting Width (Left of Blade)..... 9-3/8 in.  
Max Cutting Width (Left of Blade) w/Fence..... 8 in.  
Max Cutting Height (Resaw Height)..... 9-3/8 in.  
Blade Speeds..... 933 FPM

#### Blade Information

Standard Blade Length..... 82 in.  
Blade Width Range..... 5/8 in.



**Table Information**

Table Length.....	23-1/2 in.
Table Width.....	18-1/4 in.
Table Thickness.....	1/32 in.
Floor-to-Table Height.....	33-7/8 in.

**Construction Materials**

Table.....	Stainless Steel
Fence.....	Aluminum
Base/Stand.....	Steel
Frame/Body.....	Steel
Wheels.....	Aluminum
Wheel Cover .....	Steel
Paint Type/Finish.....	Powder Coated

**Other Related Information**

Wheel Diameter.....	10 in.
Wheel Width.....	1 in.

**Other Specifications:**

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	60 Minutes
Serial Number Location .....	ID Label
ISO 9001 Factory .....	Yes

**Features:**

Detachable #8 Meat Grinder  
Full-Length Blade Guard  
Stainless Steel Table  
Non-Slip Rubber Feet  
Adjustable Fence  
Meat Pusher

**Accessories Included:**

3/16" Grinding Plate for Grinding Meat  
Sausage Stuffer  
Push Tool  
Grinder Cover  
Hex Wrenches 3, 4, 5mm

**Accessories Recommended:**

T32848 82" x 5/8" .025" x 4 TPI Stainless Steel Blade for T32304



# SECTION 1: SAFETY

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

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



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



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



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

### **NOTICE**

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

## Safety Instructions for Machinery

### **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 clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce risk of slipping and losing control or accidentally contacting cutting tool or moving parts.

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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



# Additional Safety for Meat Saws

## 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.

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

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

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

**CLEARING JAMS AND CUTOFFS.** Always stop saw and disconnect power **BEFORE** clearing scrap pieces that get stuck between blade and table. Use brush or push stick, not hands, to clean 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.

**CLEANING & SANITIZING.** Keep machine and work area clean and sanitary using solutions approved for food processing by the USDA. **DO NOT** use solvents that can contaminate meat and cause illness. Properly clean and sanitize saw before and after each use.

**BLADE REPLACEMENT.** Under normal conditions, saw blade should be replaced after cutting approximately 4400 lbs. of meat or bone. To avoid mishaps that could result in operator injury, make sure blade teeth face down toward table and blade is properly tensioned and tracked before operating.

**SUPPORTING CUTS.** Cuts should always be fully supported by table, fence, and included meat pusher. If necessary to maintain safe cuts, use auxiliary fixtures. Do not cut very small or thin pieces that are hard to control.

**CUTTING TECHNIQUES.** To avoid blade getting pulled off wheels or accidentally breaking and striking operator, always turn saw **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 saw is running. **DO NOT** force or twist blade while cutting. This could result in blade damage or breakage.

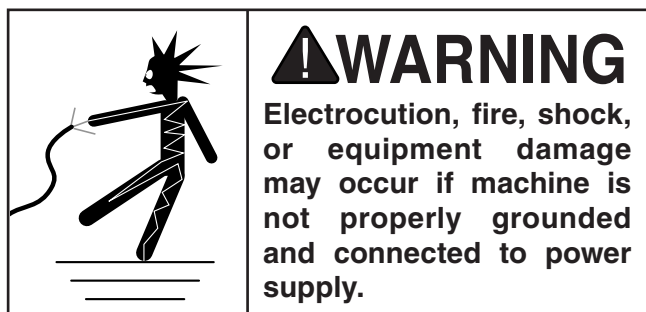
**WORKPIECE MATERIAL.** This machine is designed to cut fresh and frozen meat and bones. This machine is **NOT** designed to cut wood, metal, glass, stone, tile, etc.



# SECTION 2: POWER SUPPLY

## Availability

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



## Full-Load Current Rating

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

### Full-Load Current Rating at 120V ..... 4.6 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.

## **! 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.**

## 120V Circuit Requirements

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

**Nominal Voltage ..... 110V, 115V, 120V**  
**Cycle ..... 60 Hz**  
**Phase ..... Single-Phase**  
**Power Supply Circuit ..... 15 Amps**

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.**

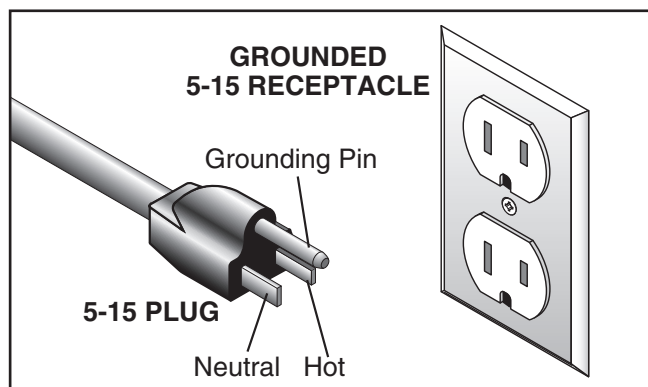
**Note:** *Circuit requirements in this manual apply to a dedicated circuit—where only one machine will be running on the circuit at a time. If machine will be connected to a shared circuit where multiple machines may be running at the same time, consult an electrician or qualified service personnel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



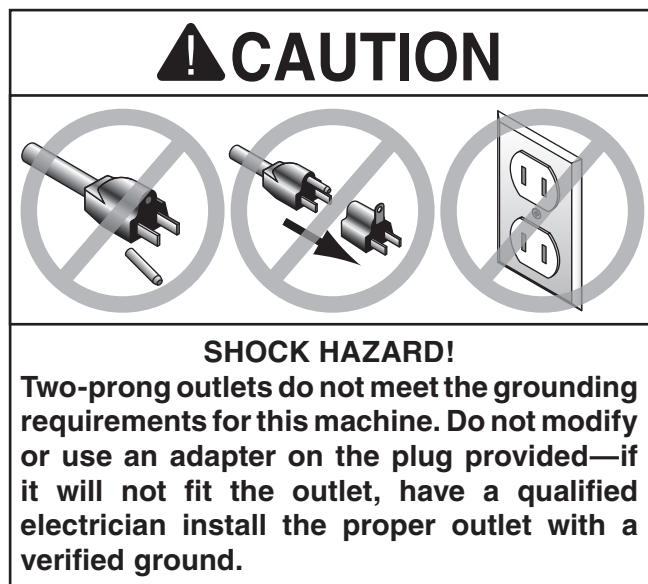
## Grounding & Plug Requirements

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.

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



**Figure 4.** Typical 5-15 plug and receptacle.



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

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

## Extension Cords

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

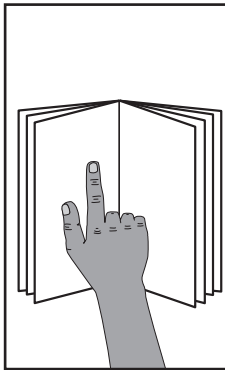
Extension cords cause voltage drop, which can damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

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

**Minimum Gauge Size ..... 16 AWG**  
**Maximum Length (Shorter is Better)..... 50 ft.**

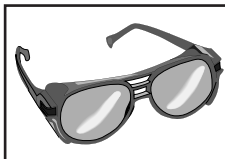


# SECTION 3: SETUP



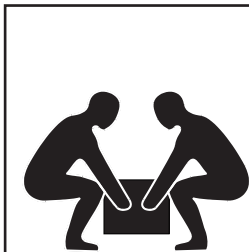
## ! WARNING

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

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.



## ! CAUTION

Saw blades are very sharp and can quickly cause cutting injuries. Always wear heavy-leather gloves when handling saw blades.

## Needed for Setup

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

### Description

### Qty

- Additional Person for Lifting ..... 1
- Safety Glasses (for each person)..... 1 Pr.
- Heavy Leather Gloves (for each person). 1 Pr.
- Phillips Head Screwdriver #2 ..... 1
- Hex Wrenches 4, 5mm..... 1 Ea.
- Open-End Wrenches 10, 13mm..... 2 Ea.
- Straightedge 36"..... 1
- Two/Three Compartment Sink ..... 1
- Dishwasher (Optional)..... 1
- Rubber Dishwashing Gloves ..... 1 Pr.
- Soft Sponge/Cloth ..... As Needed
- Hot Water ..... As Needed
- Dishwashing Detergent ..... As Needed
- Food-Grade Sanitizer ..... As Needed

## 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.

## NOTICE

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

Box 1 (Figures 5–7)	Qty
A. Model T32304 Saw Body.....	1
B. Stand Legs.....	2
C. Stand Top.....	1
D. Upper Brace.....	1
E. Side Braces.....	2
F. Motor Mount w/Cable Holder.....	1
G. Stand Covers.....	2
H. Motor $\frac{3}{4}$ HP 120V 1-PH.....	1
I. V-Belt.....	1
J. Table.....	1
K. Retention Bracket.....	1
L. Fence Shaft 370mm.....	1
M. Pusher Shaft 310mm.....	1
N. Fence.....	1
O. Meat Pusher.....	1
P. Meat Grinder Assembly w/Cover.....	1
Q. Push Tool.....	1
R. Sausage Stuffer.....	1
S. Locking Handle.....	2
T. Support Brackets w/Lock Knobs.....	2
U. Hardware Bag.....	1
—Hex Bolts M8-1.25 x 20.....	7
—Hex Bolts M6-1 x 20.....	4
—Carriage Bolts M8-1.25 x 16.....	20
—Cap Screws M6-1 x 16.....	6
—Cap Screws M6-1 x 10.....	4
—Flat Washers 8mm.....	31
—Lock Washers 8mm.....	7
—Hex Nuts M8-1.25.....	24
—Rubber Feet.....	4
—Hex Wrenches 3, 4, 5mm.....	1 Ea.



Figure 5. Model T32304 Saw Body.

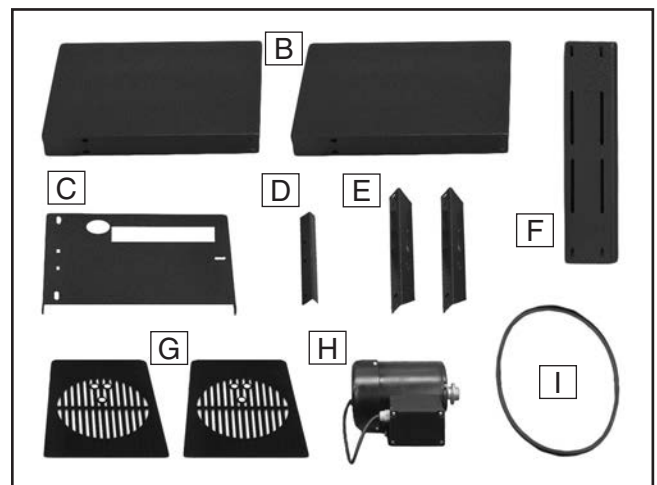


Figure 6. Stand and motor inventory.

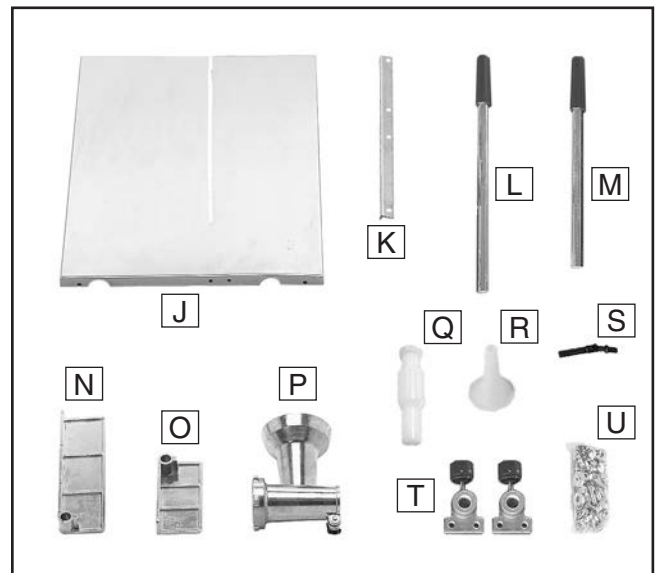


Figure 7. Table and hardware inventory.



# Hardware Recognition Chart

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

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

#10

1/4"

5/16"

3/8"

7/16"

1/2"

4mm

5mm

6mm

8mm

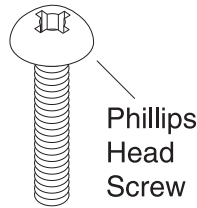
10mm

12mm

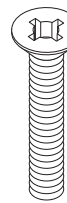
16mm



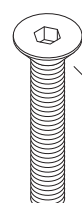
Hex  
Wrench



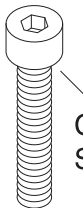
Phillips  
Head  
Screw



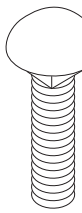
Flat  
Head  
Screw



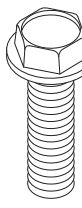
Flat  
Head  
Cap  
Screw



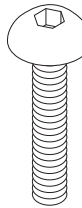
Cap  
Screw



Carriage  
Bolt



Flange  
Bolt



Button  
Head  
Screw



Tap  
Screw



External  
Retaining  
Ring



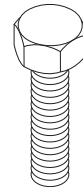
Internal  
Retaining  
Ring



E-Clip



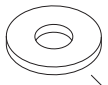
Set  
Screw



Hex  
Bolt



Key



Flat Washer

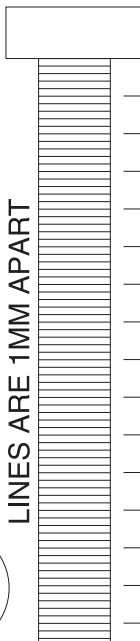


Lock  
Washer



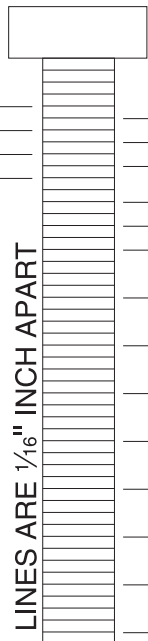
Hex  
Nut

LINES ARE 1MM APART



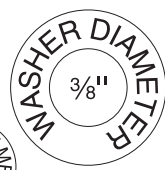
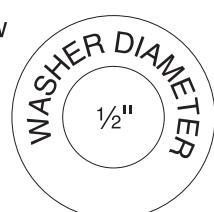
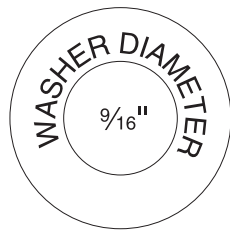
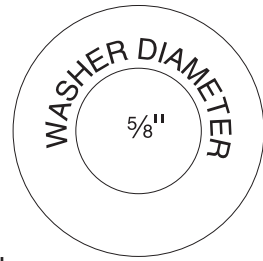
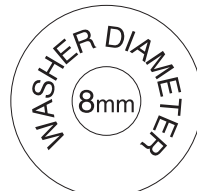
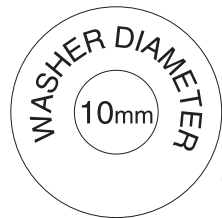
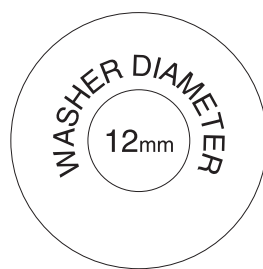
5mm  
10mm  
15mm  
20mm  
25mm  
30mm  
35mm  
40mm  
45mm  
50mm  
55mm  
60mm  
65mm  
70mm  
75mm

LINES ARE 1/16" INCH APART



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

WASHERS ARE MEASURED BY THE INSIDE DIAMETER



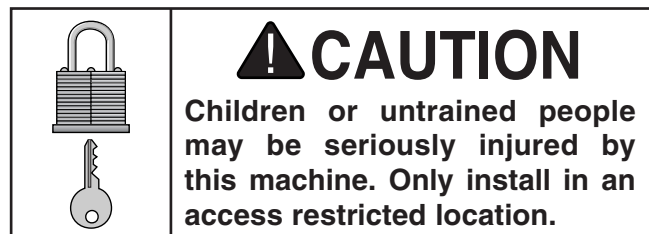
# Site Considerations

## Weight Load

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

## Space Allocation

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



## Physical Environment

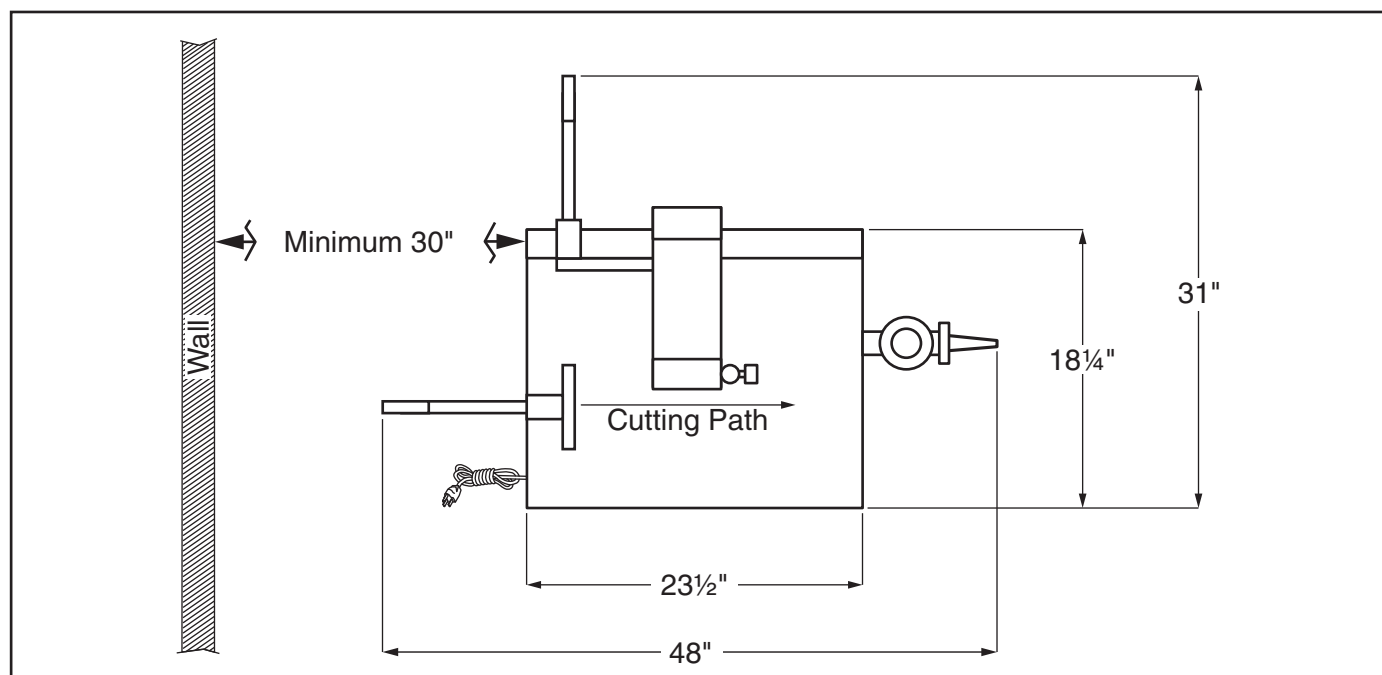
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions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

## Electrical Installation

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

## Lighting

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



**Figure 8.** Minimum working clearances.

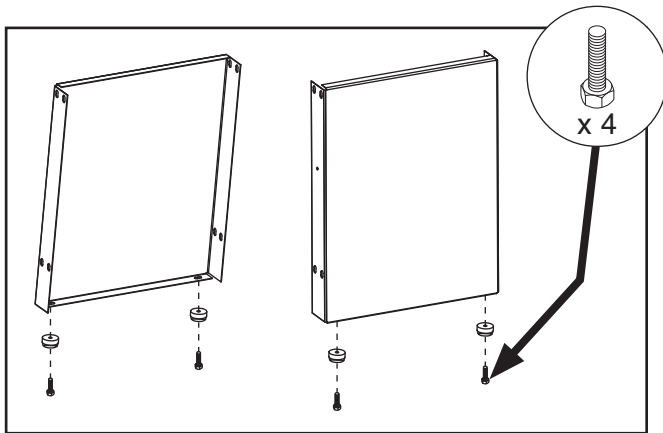


# Assembly

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 machine:

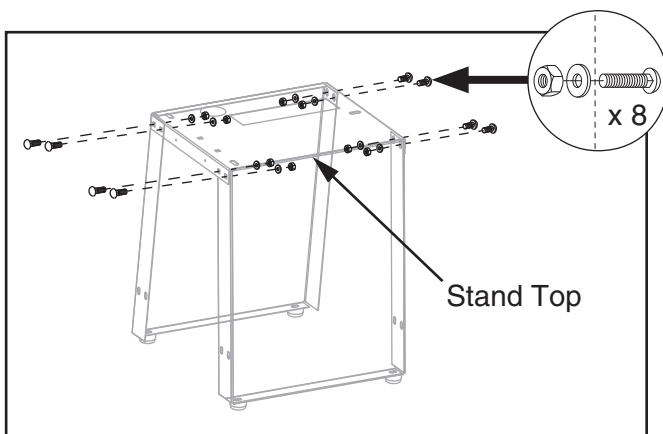
1. Insert (4) M6-1 x 20 hex bolts into rubber feet, and attach feet to each corner on stand legs (see **Figure 9**).



**Figure 9.** Attaching feet to stand legs.

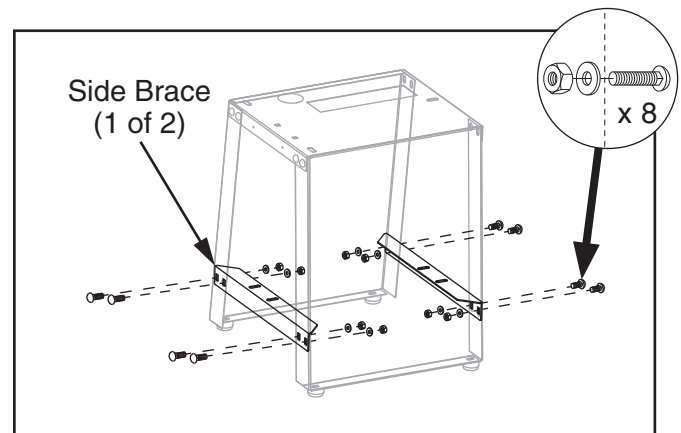
2. Attach stand legs to stand top with (8) M8-1.25 x 16 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts (see **Figure 10**).

**Note:** DO NOT completely tighten fasteners until instructed to in **Step 5**.



**Figure 10.** Attaching stand legs to stand top.

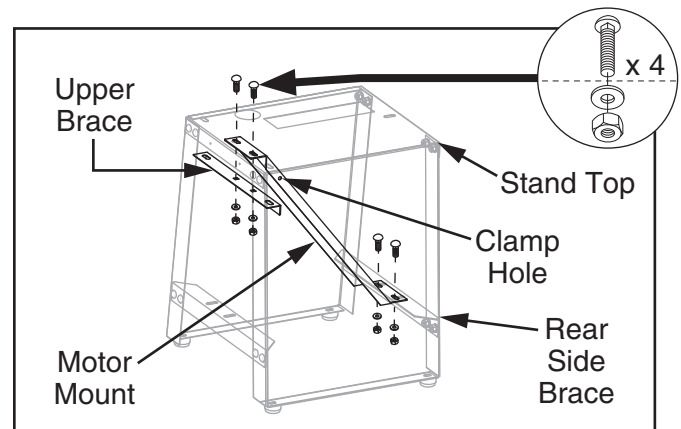
3. Attach side braces to stand legs with (8) M8-1.25 x 16 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts (see **Figure 11**).



**Figure 11.** Attaching side braces to stand legs.

4. Attach motor mount to upper brace through stand top with (2) M8-1.25 x 16 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts (see **Figure 12**), then attach motor mount to rear side brace with (2) M8-1.25 x 16 carriage bolts, 8mm flat washers, and M8-1.25 hex nuts.

**IMPORTANT:** Verify clamp hole on motor mount is positioned on top (see **Figure 12**) before proceeding to the next step.



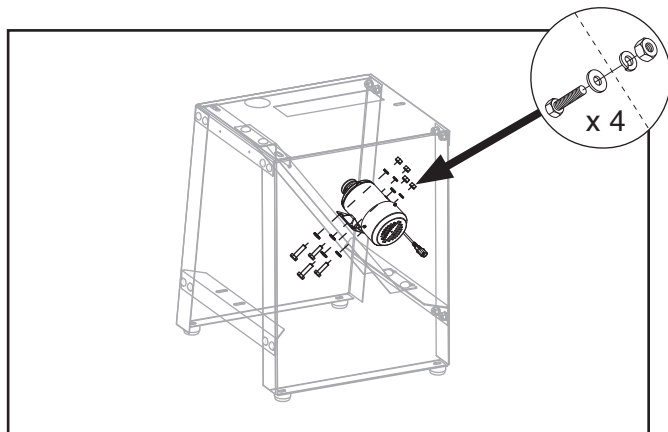
**Figure 12.** Attaching motor mount to stand.

5. Make sure stand top is centered over stand sides and tighten all loose hex nuts.



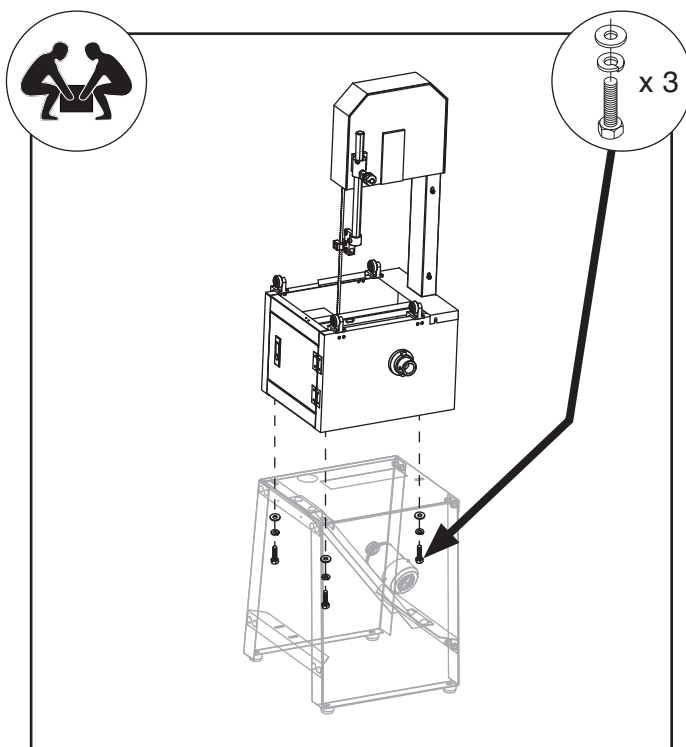
6. Attach motor to motor mount with (4) M8-1.25 x 20 hex bolts, 8mm flat washers, 8mm lock washers, and M8-1.25 hex nuts, as shown in **Figure 13**.

**Note:** *DO NOT* completely tighten fasteners until instructed to in **Step 9**.



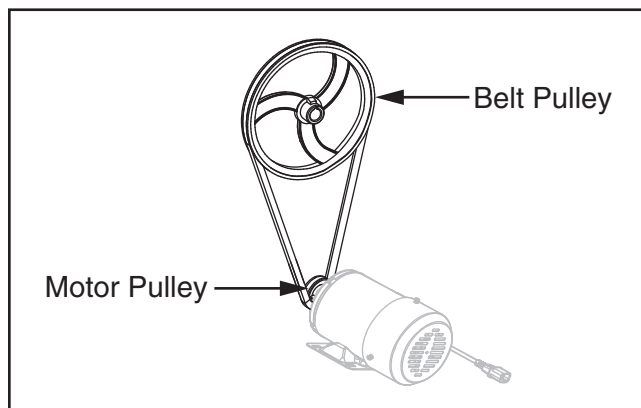
**Figure 13.** Attaching motor to motor mount.

7. With help from an assistant, lift saw body and place on stand (see **Figure 14**). Secure with (3) M8-1.25 x 20 hex bolts, 8mm flat washers, and 8mm lock washers through elongated holes on stand top.



**Figure 14.** Attaching saw body to stand top.

8. Fit V-belt into belt pulley groove, raise motor, then fit V-belt into motor pulley groove (see **Figure 15**).

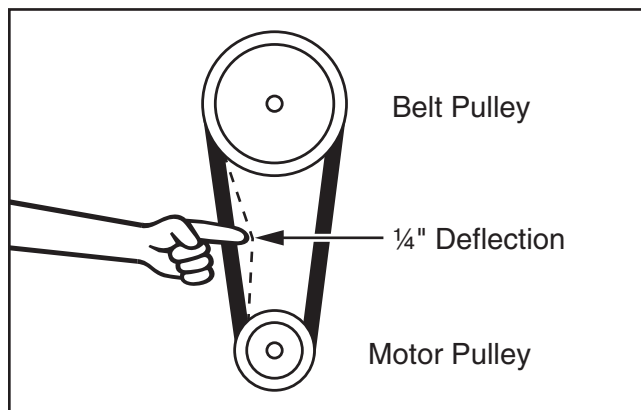


**Figure 15.** V-belt installed on pulley grooves (saw body removed for clarity).

9. Press down on center of motor to tension V-belt, then tighten (4) hex bolts to secure motor. Make sure that motor *does not* twist while applying pressure.

**Note:** *When properly tensioned, belt should deflect about 1/4" when moderate pressure is applied to belt mid-way between upper and lower pulley (see **Figure 16**).*

— If there is more than 1/4" deflection, loosen (4) motor mount hex bolts, then repeat **Step 9** until properly tensioned.

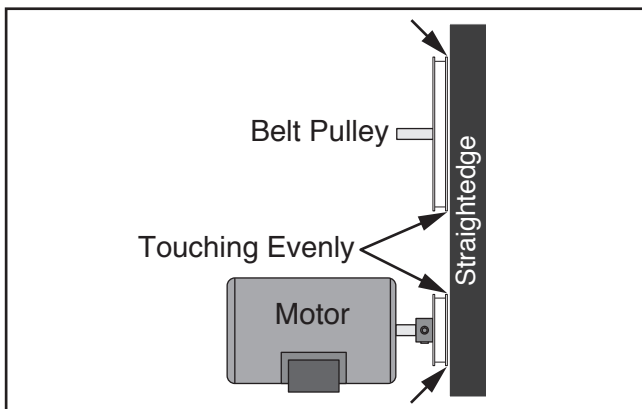


**Figure 16.** Testing for 1/4" V-belt deflection.



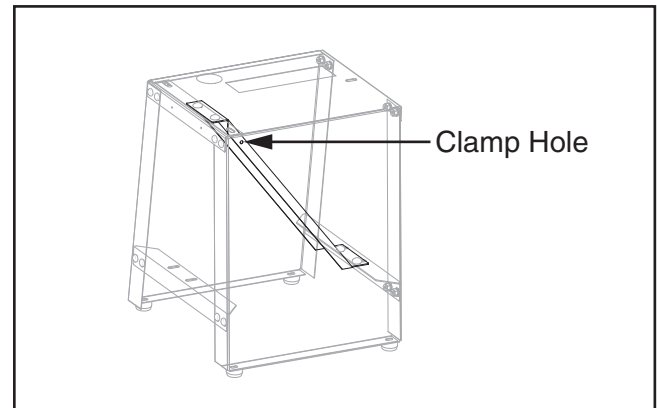
10. Hold a straightedge close to the center of both pulleys, and make sure straightedge fully extends across rims of both pulleys, as shown in **Figure 17**.

- If pulleys are parallel and coplanar, straightedge will touch the top and bottom rims on both pulleys. No further adjustment is required.
- If pulleys are parallel but not coplanar, straightedge will touch the top and bottom rims on one pulley, but will not touch either rim on the other pulley. In this case, loosen (4) carriage bolts securing motor mount, then re-position motor so straightedge touches the top and bottom rims on both pulleys. Repeat **Steps 9–10**.



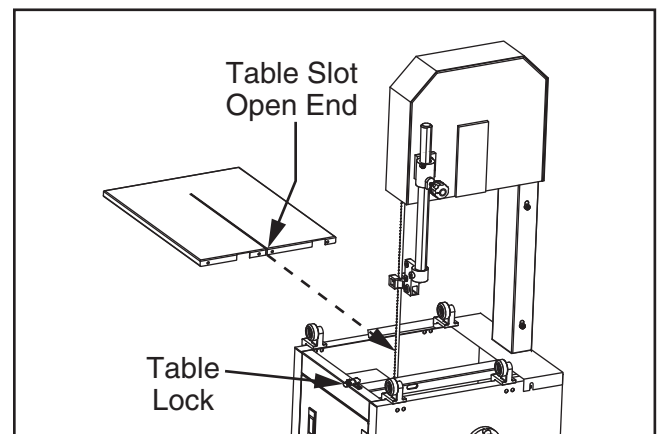
**Figure 17.** Checking pulley alignment with a straightedge.

11. Connect motor power cord to power cord receptacle on rear ON/OFF switch housing, and secure to motor mount clamp hole (see **Figure 18**) with cable holder.



**Figure 18.** Motor mount clamp hole location (components removed for clarity).

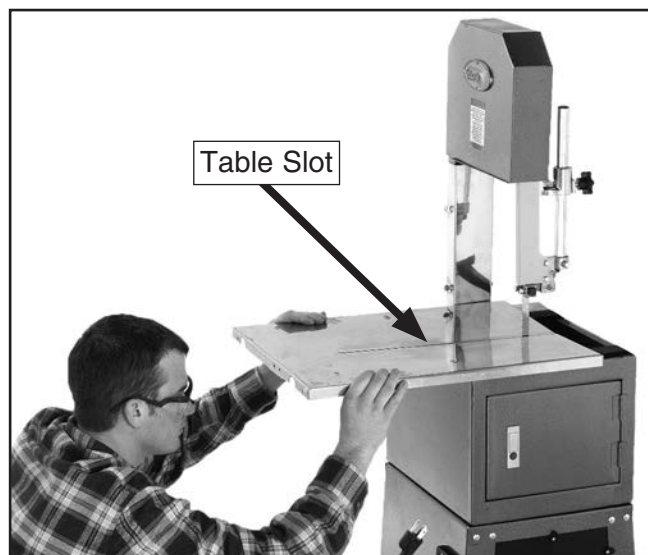
12. Verify table lock location (see **Figure 19**), and align open end of table slot with blade.



**Figure 19.** Table lock located, and open table slot aligned with blade.



13. Looking from underside of table, line up grooves in table rails with rollers on saw body. Slide table on first group of rollers and make sure blade fits into slot in table (see **Figure 20**).

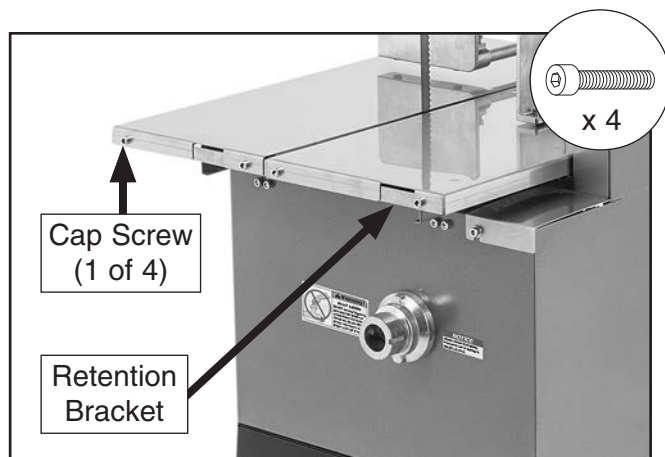


**Figure 20.** Example of aligning table with rollers and table slot with blade.

14. Pull back on table lock to slide table over second group of rollers.

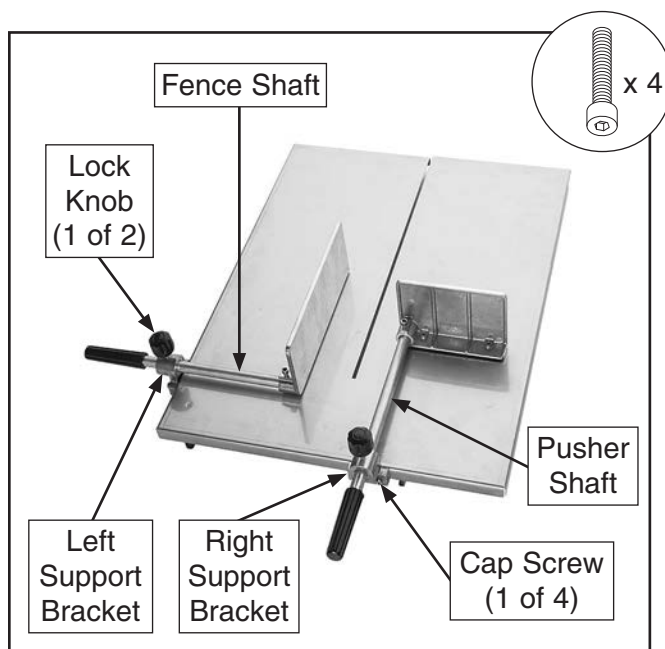
**Note:** Table lock is spring-loaded and will engage with hole in table rail to prevent table from sliding.

15. Attach retention bracket underneath open end of table and secure with (4) M6-1 x 10 cap screws (see **Figure 21**).



**Figure 21.** Retention bracket installed.

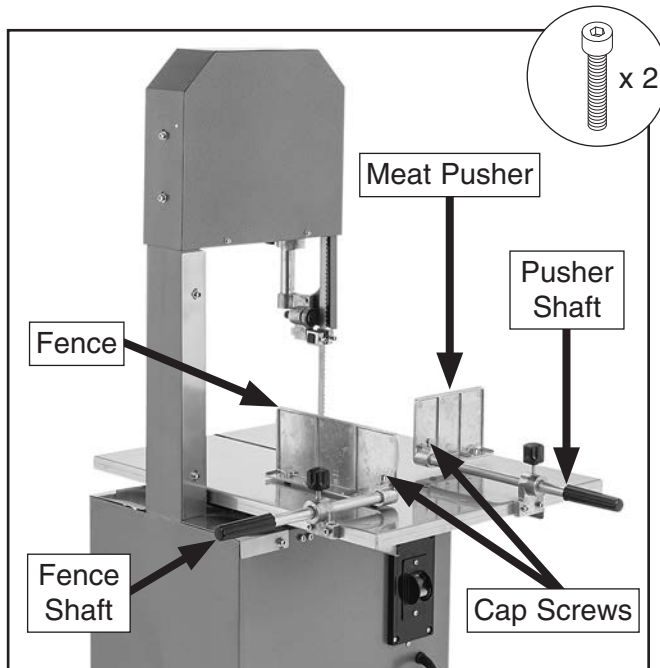
16. Pull back on table lock and verify table slides back and forth, then lock table.
17. Attach (2) support brackets to table using (4) M6-1 x 16 cap screws (see **Figure 22**).
18. Slide fence shaft through left support bracket, then secure with (1) lock knob, as shown in **Figure 22**.
19. Slide pusher shaft through right support bracket, then secure with (1) lock knob (see **Figure 22**).



**Figure 22.** Location of fence and meat pusher components (saw body removed for clarity).

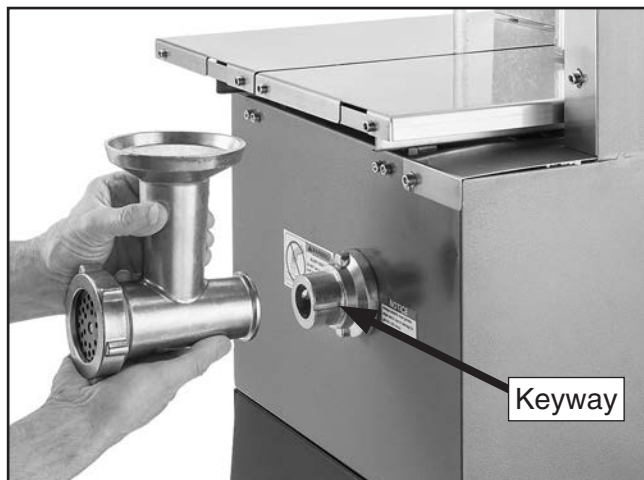


20. Install fence on fence shaft and secure with (1) M6-1 x 16 cap screw (see **Figure 23**).
21. Install meat pusher on pusher shaft and secure with (1) M6-1 x 16 cap screw (see **Figure 23**).



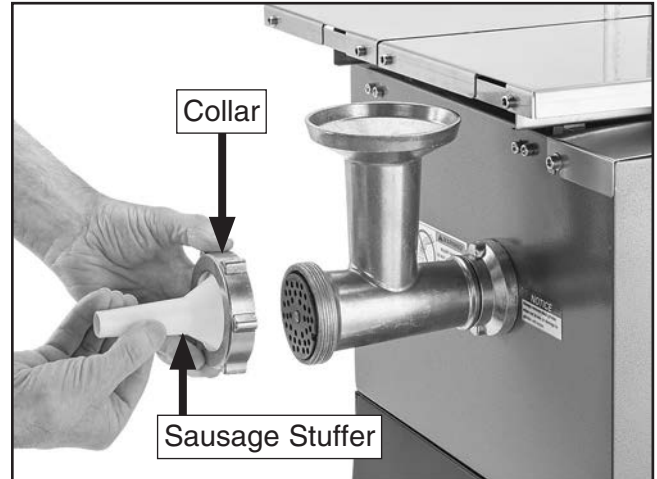
**Figure 23.** Fence and meat pusher installed on shafts.

22. Loosen lock handle on meat grinder, and line up fixed key on grinder with keyway on grinder mount (see **Figure 24**).



**Figure 24.** Installing meat grinder.

23. Remove collar from end of meat grinder (see **Figure 25**), fit collar over sausage stuffer, and tighten on meat grinder.



**Figure 25.** Installing sausage stuffer on meat grinder.

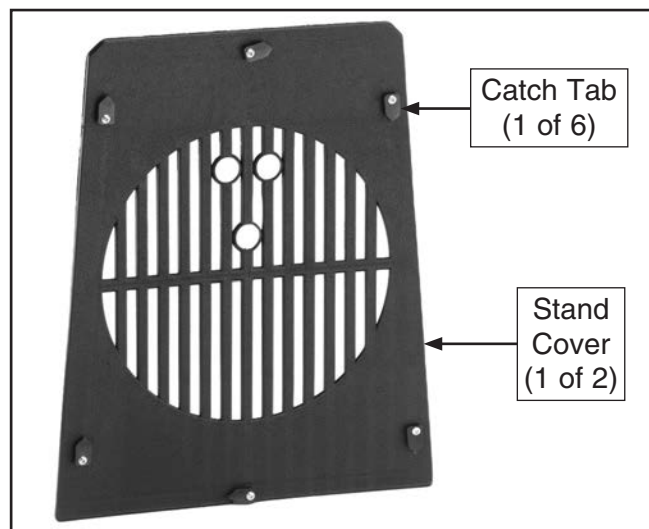
24. Slide meat grinder all the way on grinder mount and tighten lock handle to secure meat grinder in place (see **Figure 26**).

**Note:** If meat grinder does not fully seat, it may be necessary to spin pulley wheel by hand so meat grinder tongue fits into groove on auger.



**Figure 26.** Meat grinder installed.

25. Use a #2 Phillips head screwdriver to verify catch tabs on stand covers are tight enough to give resistance so they will stay in place, but not overly tight so they no longer rotate (see **Figure 27**).



**Figure 27.** Catch tabs on stand cover.

26. Install stand covers inside stand openings and attach by turning catch tabs over edges of the stand (see **Figure 28**).



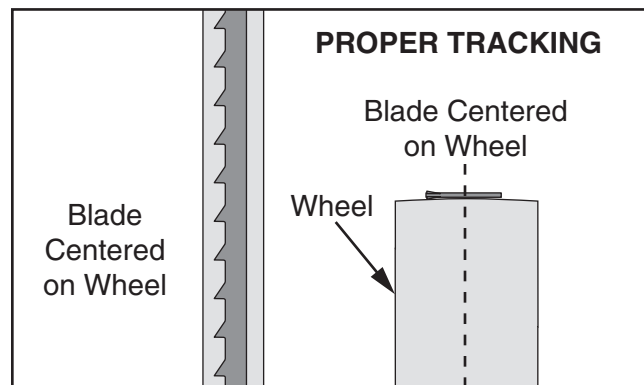
**Figure 28.** Front stand cover installed.

## Adjusting Blade Tracking

"Tracking" refers to how the blade rides on the bandsaw wheels. Proper tracking is important for maintaining bandsaw adjustments and achieving correct blade tension. The shape of the wheels and the orientation of the wheels in relation to each other determine how the blade tracks.

**IMPORTANT:** Improper tracking reduces cutting accuracy, causes excess vibrations, and places stress on the blade and other components!

The Model T32304 has crowned wheels. As the wheels spin, a properly tracking blade naturally tracks at the center of the wheel (see **Figure 29**).



**Figure 29.** Correct tracking of blade on wheel.

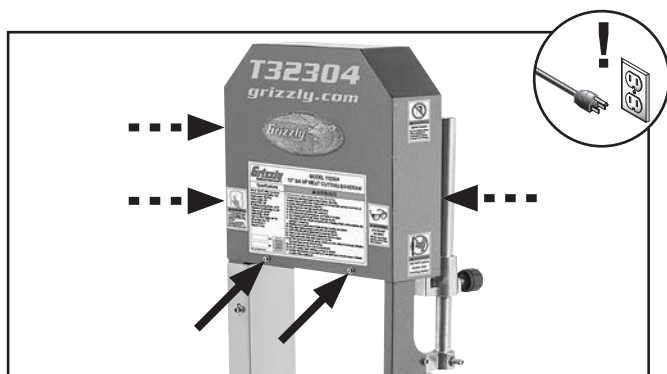
Items Needed	Qty
Heavy Leather Gloves .....	1 Pair
Open-End Wrenches 10, 13, 17mm .....	1 Ea.
Hex Wrenches 4, 5mm .....	1 Ea.

### To adjust blade tracking:

1. DISCONNECT MACHINE FROM POWER!



2. Loosen and remove (5) cap screws securing upper wheel cover (see **Figure 30**), then remove cover.



**Figure 30.** Five cap screws securing upper wheel cover (three are out of view).

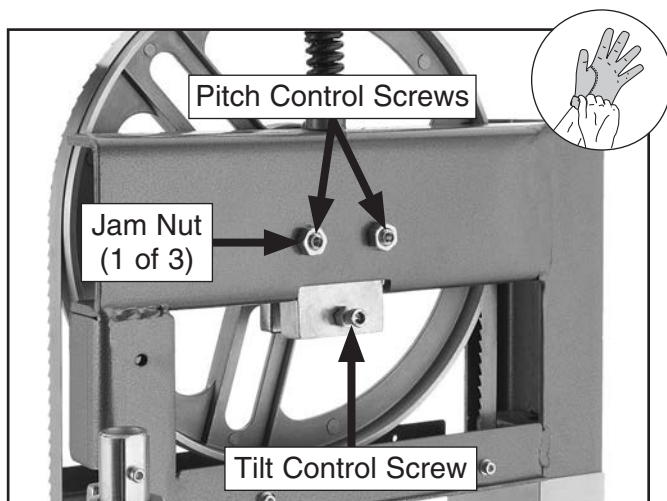
3. Put on heavy leather gloves, then rotate upper wheel by hand several times and observe how blade rides on wheel.

— If blade consistently rides in center of upper wheel, blade is tracking properly. Proceed to **Step 7**.

— If blade *does not* consistently ride in center of upper wheel, blade *is not* tracking properly. Proceed to **Step 4**.

4. Locate blade tracking control screws (see **Figure 31**), loosen jam nuts, then tighten or loosen screws to adjust pitch/tilt of upper wheel.

**Note:** *Pitch control screws control left and right pitch, and tilt control screw controls up and down tilt of the wheel.*



**Figure 31.** Blade tracking control screws.

5. While adjusting screws, rotate upper wheel by hand and observe direction of blade movement.

— If blade tracks towards front or rear of wheel, adjust tilt control screw until blade is centered.

— If blade tracks towards front or rear of one side of wheel but tracks opposite on the other side, adjust pitch control screws until blade is centered.

6. Once blade appears to be tracking correctly, spin upper wheel at least three full revolutions to ensure blade remains centered.
7. Verify blade is properly tensioned (refer to **Step 4** of **Tensioning Blade** on **Page 25**).
8. Verify blade support bearing is properly adjusted (see **Adjusting Blade Support Bearing** on **Page 26**).
9. Verify blade guides are properly adjusted (see **Steps 2–7 & 9** of **Adjusting Blade Guides** on **Page 27**).
10. Install upper wheel cover removed in **Step 2** and secure.

## NOTICE

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



# Test Run

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

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

The Test Run consists of verifying the following:

- 1) The motor powers up and runs correctly.

## WARNING

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

## WARNING

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

To test run machine:

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

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

## CAUTION

Always remove meat grinder when not being used. Failure to comply may result in damage to meat grinder due to insufficient lubrication without meat being processed.

# Cleanup

After unpacking machine and performing initial setup, peel off any protective plastic sheeting and thoroughly clean and sanitize the saw as directed in **CLEANING & SANITIZING (Page 33)** before beginning operation. Get in the habit of properly cleaning and sanitizing the saw before and after each use to avoid contamination and illness.



## WARNING

If you are not familiar with safe meat handling techniques, contact your local Board of Health or the USDA for proper sanitizing procedures.

## WARNING

When cleaning with sanitizers, make sure the product is approved for stainless steel food processing equipment and always follow the manufacturer's recommendations. To prevent illness or death, never use a product that will make the meat unsafe for human consumption.

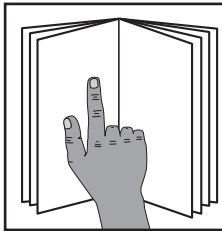


# SECTION 4: OPERATIONS

## 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 or face injury from flying debris, always wear safety glasses and face shield 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. Makes sure all components of saw are properly cleaned and sanitized (refer to **CLEANING & SANITIZING** on **Page 33**).
2. Adjusts fence for desired thickness of cut.
3. Tightens fence lock knob to secure fence in place.
4. Aligns workpiece to blade.
5. Adjusts blade guard to within 1" of workpiece height.
6. Turns saw **ON** and waits for blade to reach full speed.
7. Using meat pusher, slowly feeds meat through cut.

**Note:** If motor slows down or struggles with cut, reduce feed rate.

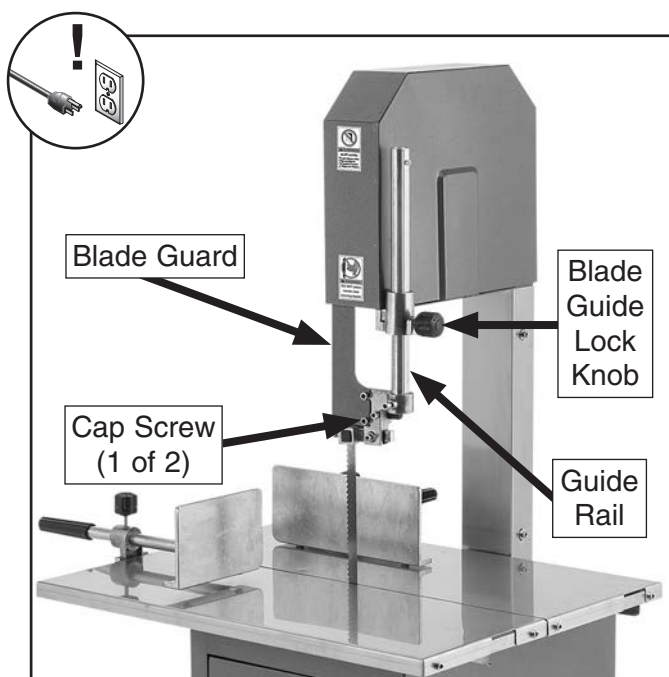
8. Turns machine **OFF**, waits for blade to completely stop, then removes cut-off piece.
9. Repeats **Steps 6–9** to make additional cuts.
10. Turns saw **OFF** once all cuts are completed, disconnects saw from power, then cleans and sanitizes saw as directed in **CLEANING & SANITIZING** on **Page 33**.



# Adjusting Blade Guard

The blade guard protects the operator from accidental contact with the portion of the blade that is not cutting through a workpiece.

The blade guide lock knob (see **Figure 32**) on the guide rail allows you to raise and lower the blade guard and blade guide assembly. To remove the blade guard, loosen and remove (2) cap screws securing the blade guard to the blade guide assembly (see **Figure 32**).



**Figure 32.** Location of blade guard and blade guide assembly components.

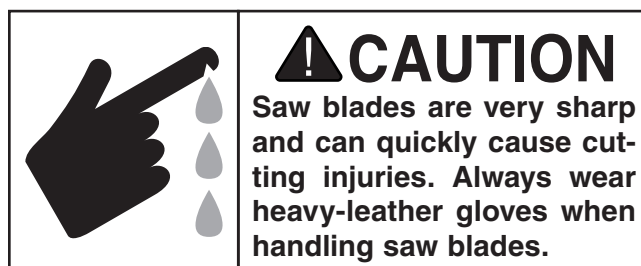
**IMPORTANT:** Keep the blade guide assembly within an inch of the material you are cutting. This will provide adequate support for the blade where the pressure is greatest. This adjustment is crucial when cutting through bone!

# 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 meats and bones, 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.

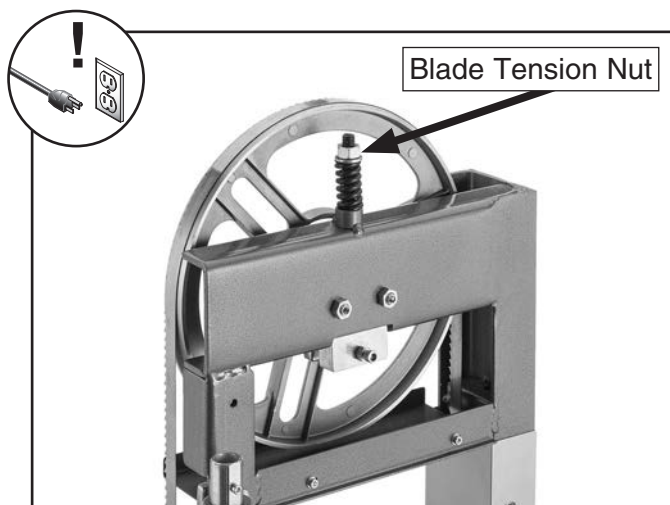


Items Needed	Qty
Heavy Leather Gloves.....	1 Pair
Open-End Wrench 17mm.....	1
Hex Wrenches 4, 5mm.....	1 Ea.

#### To tension blade:

1. DISCONNECT MACHINE FROM POWER!
2. Remove upper wheel cover.
3. Verify blade is tracking correctly by referring to **Adjusting Blade Tracking** on **Page 21**.
4. Tighten blade tension nut (see **Figure 33**) to tension blade until there is approximately 1/4" deflection when pressure is applied to middle of blade.

**Note:** Rotate blade tension nut clockwise to increase blade tension and counterclockwise to decrease blade tension.



**Figure 33.** Location of blade tension nut.

5. Install upper wheel cover and secure.

## NOTICE

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

# Adjusting Blade Support Bearings

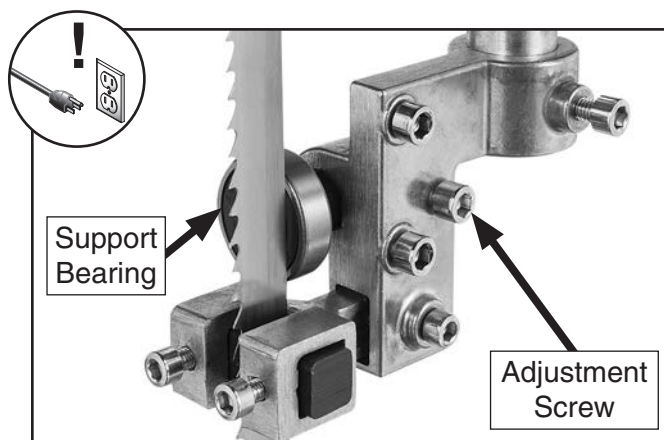
Support bearings are positioned behind the blade near the blade guides, and prevent the blade from moving backward during operations. Proper adjustment of the support bearings helps you make accurate cuts and prevents the blade teeth from contacting the blade guides while cutting.

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

Tools Needed	Qty
Hex Wrenches 5, 6mm.....	1 Ea.
Open-End Wrench 13mm.....	1

## Upper Blade Support Bearing

1. DISCONNECT MACHINE FROM POWER!
2. Remove blade guard.
3. Loosen support bearing adjustment screw (see **Figure 34**).



**Figure 34.** Upper blade guide support bearing (blade guard removed).

4. Position support bearing approximately 1/32" away from back of blade.
5. Tighten support bearing adjustment screw.
6. Re-install blade guard removed in **Step 2**.

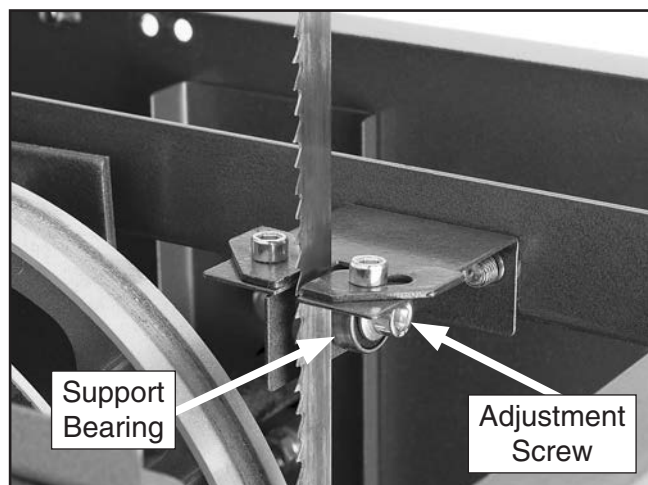


## Lower Blade Support Bearing:

1. DISCONNECT MACHINE FROM POWER!
2. Remove table.

**Note:** Fence and meat pusher can remain installed when removing table.

3. Loosen support bearing adjustment screw (see **Figure 35**).

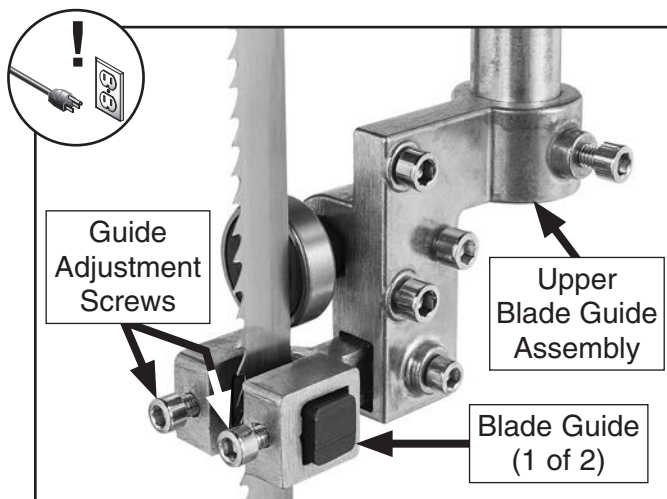


**Figure 35.** Lower blade guide support bearing (table removed).

4. Position support bearing approximately  $\frac{1}{32}$ " away from back of blade.
5. Tighten support bearing adjustment screw.
6. Re-install table removed in **Step 2**.

## Adjusting Blade Guides

The upper blade guides (see **Figure 36**) can be adjusted left-to-right, as well as front-to-back, relative to the blade. Properly adjusted blade guides provide side-to-side support, from just behind the gullets to the back of the blade, to help keep the blade straight while cutting.



**Figure 36.** Upper blade guide assembly (blade guard removed).

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

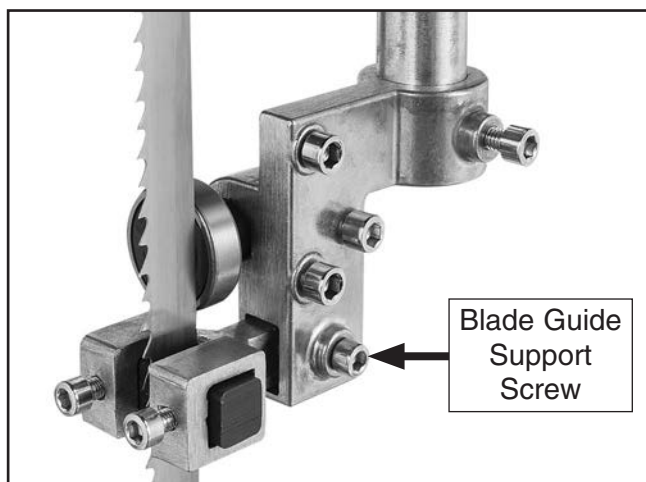
Tools Needed	Qty
Hex Wrench 5mm.....	1

### To adjust blade guides:

1. DISCONNECT MACHINE FROM POWER!
2. Remove blade guard.
3. Loosen (2) guide adjustment screws (see **Figure 36**), adjust blade guides approximately 0.004" (about the thickness of a dollar bill) away from blade, and tighten screws.

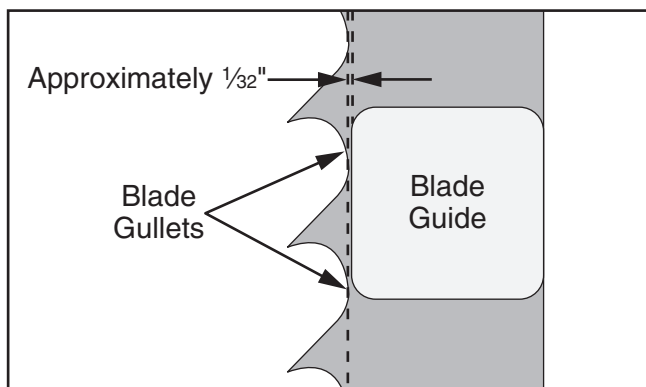


4. Loosen blade guide support screw (see **Figure 37**).



**Figure 37.** Location of blade guide support screw.

5. Position blade guides approximately  $\frac{1}{32}$ " behind gullet of blade teeth (see **Figure 38**), and tighten screw.

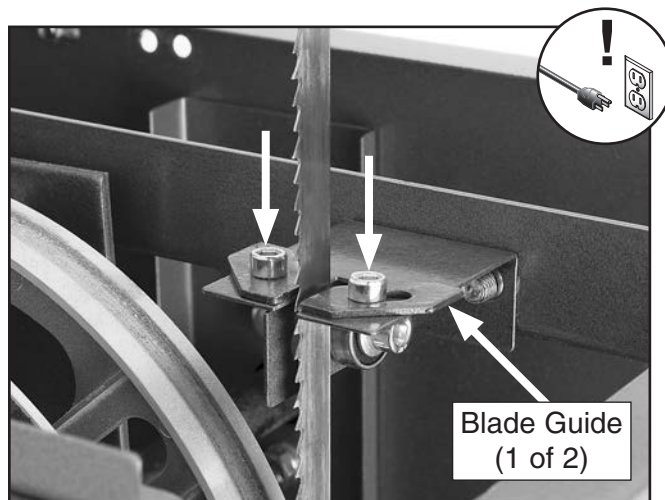


**Figure 38.** Blade guides positioned just behind blade gullets.

6. Remove table to gain access to lower blade guides.

**Note:** Fence and meat pusher can remain installed when removing table.

7. Loosen lower blade guide adjustment screws (see **Figure 39**), adjust blade guides to approximately 0.004" (about the thickness of a dollar bill) away from blade.



**Figure 39.** Adjustment screws securing lower blade guides.

8. Position blade guides just behind gullet of blade teeth (see **Figure 38**), and secure.
9. Re-install table removed in **Step 5**.
10. Re-install blade guard removed in **Step 2**.



# Changing Blade

The saw blade included with the Model T32304 is a general purpose 4 TPI (Teeth Per Inch) blade. Under normal conditions, the saw blade should be replaced after cutting approximately 4400 lbs. of meat or bone. Do research to help select the best 82" L x 5/8" W blade for the application.

## ⚠ WARNING

**ONLY use food-grade saw blades (typically stainless steel) to prevent food contamination from metal corrosion.**



## ⚠ CAUTION

**Saw blades are very sharp and can quickly cause cutting injuries. Always wear heavy-leather gloves when handling saw blades.**

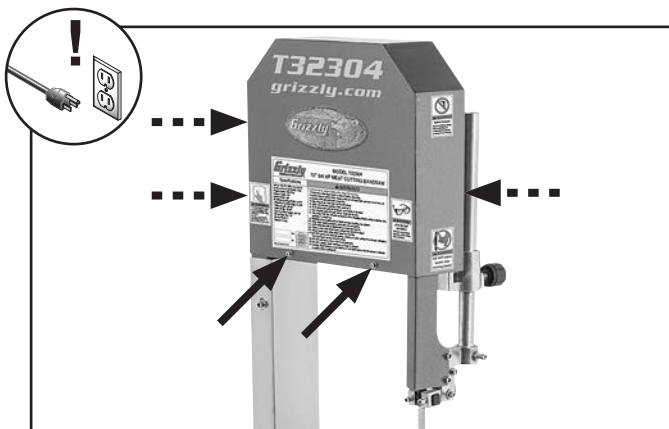
### Items Needed

### Qty

Heavy Leather Gloves .....	1 Pair
Open-End Wrench 17mm .....	1
Hex Wrenches 4, 5mm .....	1 Ea.

## Removing Blade

1. DISCONNECT MACHINE FROM POWER!
2. Remove (5) cap screws securing upper wheel cover (see **Figure 40**), then remove cover.



**Figure 40.** Five cap screws securing upper wheel cover (three are out of view).

3. Remove table and covers, then open cabinet door (see **Figure 41**).



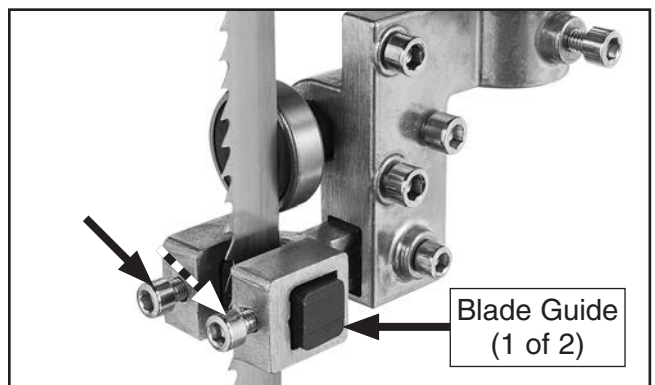
**Figure 41.** Table and covers removed.

4. Loosen (2) cap screws securing blade guard (see **Figure 42**) and remove guard.



**Figure 42.** Cap screws securing blade guard.

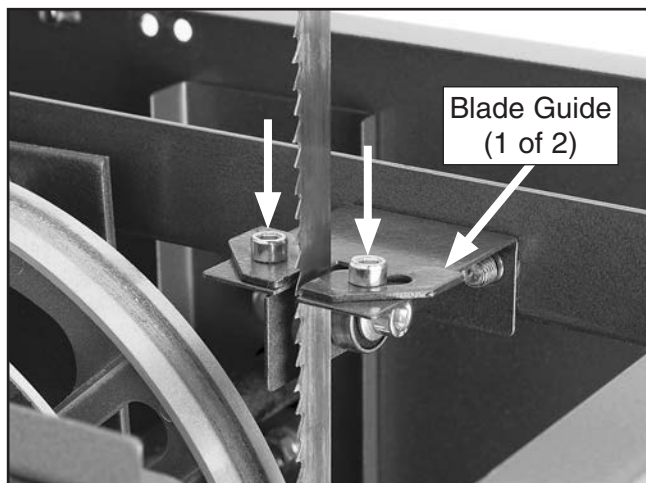
5. Loosen (2) cap screws securing upper blade guides (see **Figure 43**) and move blade guides away from blade.



**Figure 43.** Two cap screws securing upper blade guides.

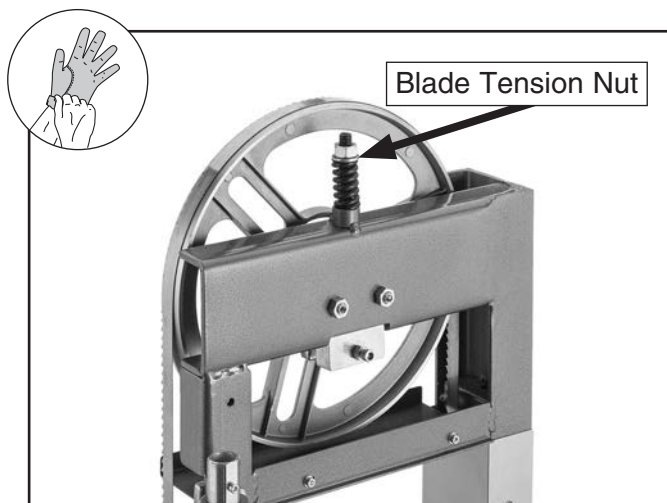


- Loosen (2) cap screws securing lower blade guides (see **Figure 44**) and move blade guides away from blade.



**Figure 44.** Two cap screws securing lower blade guides.

- Remove V-belt from belt pulley by performing **Steps 3–4 of Replacing V-Belt on Page 41**.
- Release tension from blade by turning blade tension nut (see **Figure 45**) counterclockwise until blade moves freely.



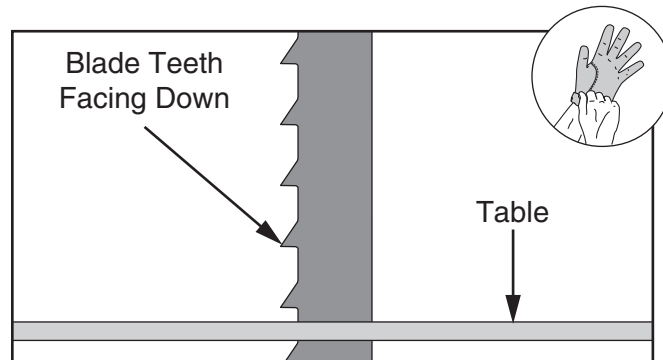
**Figure 45.** Location of blade tension nut.

- Put on a pair of heavy leather gloves to protect your hands from blade teeth, then carefully remove blade.

## Installing Blade

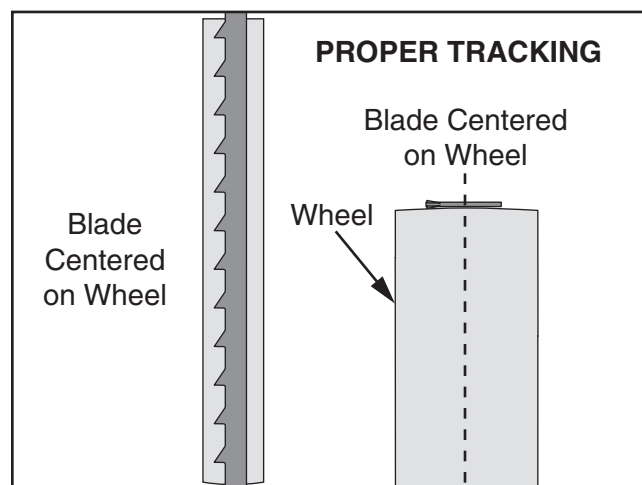
- DISCONNECT MACHINE FROM POWER!**
- Put on a pair of heavy leather gloves and slide blade through upper and lower blade guides, then mount blade on upper wheel. Verify blade teeth point down (see **Figure 46**).

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



**Figure 46.** Correct blade teeth orientation.

- Verify blade tension is released by turning blade tension nut counterclockwise.
- Mount blade on lower wheel and verify blade is centered on both wheels (see **Figure 47**).



**Figure 47.** Correct tracking of blade on wheel.



5. Re-install V-belt by performing **Steps 5–6 of Replacing V-Belt on Page 41.**
6. Verify blade is tracking correctly (see **Steps 3–9 of Blade Tracking on Page 21).**
7. Re-install blade guard and tighten (2) cap screws loosened in **Step 4 of Removing Blade on Page 29.**
8. Close cabinet door, re-install covers and table (see **Figure 48**) removed in **Steps 2–3 of Removing Blade on Page 29,** and secure.



**Figure 48.** Table, covers, and upper wheel cover installed.

## Cutting Meat & Bone

The Model T32304 10"  $\frac{3}{4}$  HP Meat Cutting Bandsaw is designed for cutting fresh or frozen meat and bones.

When cutting meat with your bandsaw, use the fence to gauge the thickness of your desired cut, and use the meat pusher to brace the meat. Make sure the fence will not be in line with cuts.

With frozen meat, pay attention to the rate at which you feed meat into the moving blade. All cuts should be slow and smooth. If you hear the motor slow down or struggle with a cut, reduce pressure.

When cutting bone, feed bone into the blade slowly. If you hear the motor slow down during cutting, release pressure at once. **DO NOT** twist the blade during cutting or the blade may bind or break.

	<p><b>!WARNING</b></p> <p>This saw can quickly cause cuts or amputation injuries. Use the included fence to guide the meat through the blade. <b>NEVER</b> place your hand or fingers in line with or near the moving blade.</p>
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	<p><b>!WARNING</b></p> <p>If you are not familiar with safe meat handling techniques, contact your local Board of Health or the USDA for proper sanitizing procedures.</p>
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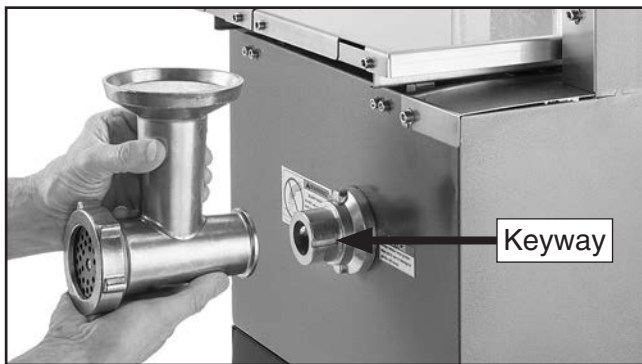


# Grinding Meat

The meat grinder is used for grinding hamburger or sausage. The meat grinder automatically engages when it is installed on the bandsaw.

## Installing Meat Grinder

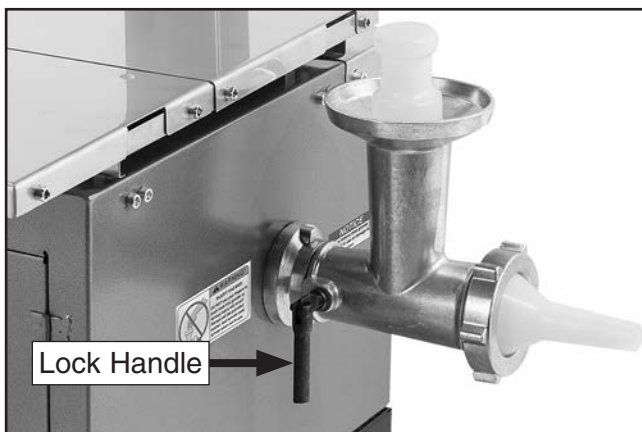
1. DISCONNECT MACHINE FROM POWER!
2. Make sure all components of meat grinder are properly cleaned and sanitized (refer to **CLEANING & SANITIZING** on Page 33).
3. Loosen lock handle on meat grinder, and line up fixed key on grinder with keyway on grinder mount (see **Figure 49**).



**Figure 49.** Installing meat grinder.

4. Slide meat grinder all the way on grinder mount and tighten lock handle to secure meat grinder in place (see **Figure 50**).

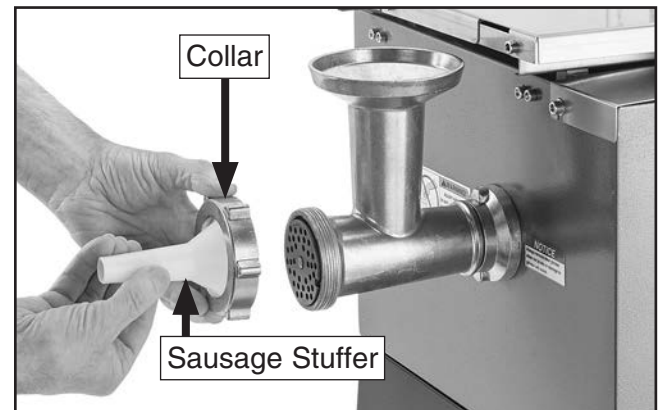
**Note:** If meat grinder does not fully seat, spin pulley wheel by hand so meat grinder tongue fits into groove on auger.



**Figure 50.** Meat grinder lock handle.

## Installing Sausage Stuffer

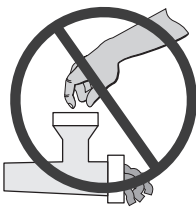
1. Remove collar from end of meat grinder (see **Figure 51**), fit collar over sausage stuffer, and tighten on meat grinder.



**Figure 51.** Installing sausage stuffer.

## Using Meat Grinder

1. Lower blade guard as low as it will go and lock it in place.
2. Prepare a place for ground meat to exit meat grinder, or place sausage casing around sausage stuffer.
3. Turn saw **ON** and wait for blade to reach full speed, then slowly drop portions of meat into meat grinder, one piece at a time.


	<p><b>⚠ WARNING</b></p> <p><b>DO NOT</b> use your fingers to push meat into grinder or serious injury will occur! Always use the provided pusher, and remove meat grinder when not in use.</p>
--	--

4. Turn saw **OFF** once grinding is completed, then clean and sanitize meat grinder (see **CLEANING & SANITIZING** on Page 33).

<p><b>⚠ CAUTION</b></p>	<p>Always remove meat grinder when not being used. Failure to comply may result in damage to meat grinder due to insufficient lubrication without meat being processed.</p>
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# SECTION 5: CLEANING & SANITIZING




**!WARNING**

If you are not familiar with safe meat handling techniques, contact your local Board of Health or the USDA for proper sanitizing procedures.




**!WARNING**

Always be as thorough as possible when cleaning and sanitizing the saw and its parts. Any surface that has been exposed to raw meat or bone may develop bacteria that could cause illness or death if not properly cleaned and sanitized.



**!WARNING**

Cleaning saw while it is connected to power could cause severe electrical shock or death. **ALWAYS** disconnect saw from power before cleaning and sanitizing. **DO NOT** reconnect it to power until all parts are completely dry.



**!WARNING**

When cleaning with sanitizers, make sure the product is approved for stainless steel food processing equipment and always follow the manufacturer's recommendations. To prevent illness or death, never use a product that will make the meat unsafe for human consumption.

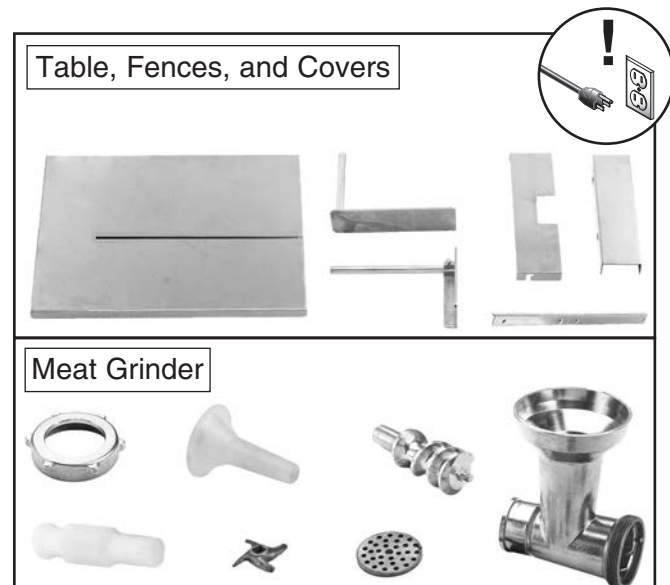
## Cleaning Saw

Get in the habit of properly cleaning and sanitizing the saw before and after each use to avoid contamination and illness.

Items Needed	Qty
Hex Wrenches 4, 5mm.....	1 Ea.
Two/Three Compartment Sink.....	1
Dishwasher (Optional) .....	1
Rubber Dishwashing Gloves .....	1 Pair
Soft Sponge/Cloth .....	As Needed
Hot Water .....	As Needed
Dishwashing Detergent .....	As Needed
Food-Grade Sanitizer .....	As Needed

### To clean saw and prepare for sanitizing:

1. Prepare a clean and sanitized area, preferably stainless steel, for placing parts as you remove them from saw.
2. DISCONNECT MACHINE FROM POWER!
3. Remove table, fences, covers, and meat grinder, then disassemble (see **Figure 52**).



**Figure 52.** Table and meat grinder components disassembled.



4. Remove upper wheel cover and open cabinet door (see **Figure 53**).



**Figure 53.** Upper wheel cover removed and cabinet door opened.

5. Remove saw blade (see **Changing Blade** on **Page 29**).
6. Remove and dispose of largest particles of meat/bone.
7. Using hot water and a soft sponge/cloth, rinse and wipe away as much leftover material as possible.

## NOTICE

**Never use abrasive material (course sponges, steel wool, steel brushes, etc.) to clean the machine. Abrasives remove the protective coating on stainless steel and should always be avoided.**

8. Clean sink compartments with hot water (minimum 171°F [77°C]) and dish soap, then rinse them thoroughly with hot water.
9. Sanitize sink compartment as instructed in **Proper Sanitation** on **Page 35**.

**Note:** Dishwashers are a good option for cleaning AND sanitizing at the same time because they use heat. Place any parts that will fit inside of the dishwasher, and use the highest possible heat settings (minimum 171°F [77°C]). If it is an option, use the dishwasher to dry parts with hot air.

10. Fill a clean and sanitized sink compartment with hot, soapy water (minimum 171°F [77°C]).
11. Submerge removed parts in hot, soapy water and scrub all surfaces thoroughly.
12. Rinse all parts with hot, clean water (minimum 171°F [77°C]) until all visible suds are removed.  
  
**Note:** If the soapy water becomes hazy, drain compartment, clean and sanitize, and refill with more hot, soapy water (minimum 171°F [77°C]).
13. Clean all other surfaces of saw body with a soft sponge/cloth and hot, soapy water (minimum 171°F [77°C]).

## NOTICE

**To avoid damaging electrical parts when reconnecting saw to power, DO NOT spray saw body with water or solutions. DO NOT allow any liquid to enter the side vents around the motor. Instead, use a cloth rag and hot, soapy water to thoroughly clean the surfaces of the saw body.**

14. Use hot, clean water (minimum 171°F [77°C]) and a clean, soft sponge/cloth to remove soapy residue.
15. Allow all parts and surfaces to air dry after rinsing.

**IMPORTANT:** DO NOT dry parts with a cloth or towel! This will help to prevent spreading contaminants after cleaning.

16. Sanitize removed parts and saw body as instructed in **Proper Sanitation** on **Page 35**.
17. Lubricate entire saw blade and table top as instructed in **Lubrication** on **Page 37**.
18. Re-assemble and install components removed in **Steps 3–5**.
19. Cover machine with a clean, dry cloth until next use.



# Proper Sanitation



All surfaces of the saw that are exposed to the cutting process must be properly cleaned and sanitized. Cleaning the food debris and residue away is only half of the process. These surfaces must now be disinfected with solutions that will remove bacteria and other micro-organisms, and prevent their growth.

Some sanitizers require direct applications, while others are designed to be diluted in water and used to soak the item for a specified period of time. The best method for choosing a chemical sanitizer is to do the research and determine which product is best for your particular situation. Sanitizing solutions should be changed as soon as they become dirty, or every two hours. One simple sanitizer that can be used for many applications is regular bleach.

**Note:** *DO NOT use bleach that contains odor-masking agents or surfactants. These chemicals have not been proven effective for this type of sanitation.*

To use bleach as a sanitizer, scrub a sink compartment with hot, soapy water (minimum 171°F [77°C]), then rinse it clear. Fill the sink with one tablespoon of bleach per gallon of COOL water.

**Note:** *NEVER exceed 200 ppm (parts per million) of available chlorine in equipment sanitizing solutions. Use a pH testing kit to confirm the effectiveness of your sanitizing solution.*

For removable parts, submerge each item for two minutes. For larger surfaces, use a clean cloth and the bleach solution to wipe down these surfaces for two minutes. Allow to air dry—**DO NOT rinse these items after sanitizing!**

If porous surfaces, such as wood, are used in the cutting process, clean as previously described, then soak for two minutes in a solution of three tablespoons of bleach to one gallon of COOL water. **Rinse items thoroughly after sanitizing!**

**!WARNING**

Bacteria from raw meat has been frequently linked to illness and even death! Describing proper meat handling techniques outside of cleaning the bandsaw is beyond the scope of this manual. If you are unclear about sanitary meat handling practices, contact your local Board of Health or the USDA to research proper methods of meat handling.

**NOTICE**

Acidic solutions, saline-based solutions, disinfectants, and sterilizers (hypochlorites, tetravalent ammonia salts, iodine compounds, nitric acid, etc.) will corrode stainless steel over time. Verify your cleaning compound is made for cleaning stainless steel before using on machine.



# SECTION 6: 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**

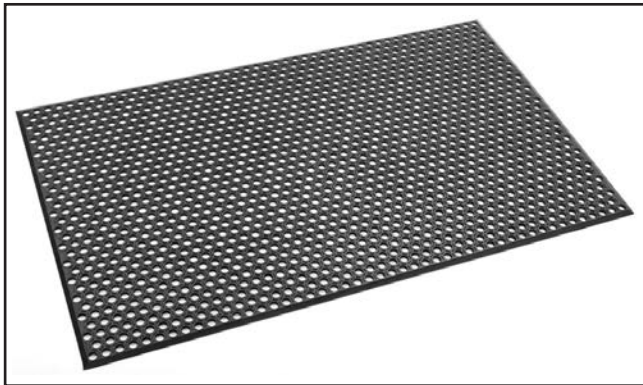
Refer to our website or latest catalog for additional recommended accessories.

### **T32848—82" x 5/8" 4 TPI Bandsaw Blade**

Food-grade stainless steel replacement blade for the Model T32304 Meat Cutting Bandsaw.

### **T10456—Heavy-Duty Anti-Fatigue Mat 3' x 5'**

This Heavy-Duty Anti-Fatigue Mat features beveled edges and no-slip tread for safety and comfort. Open-hole design allows liquid to drain through, so it's perfect for wet or oily conditions. Measures 3' wide x 5' long x 3/8" thick.



**Figure 54.** Model T10456 Heavy-Duty Anti-Fatigue Mat 3' x 5'.

## **Basic Eye Protection**

**T32323—Woodturners Face Shield**

**T32401—EDGE Brazeau Safety Glasses, Clear**

**T32402—EDGE Khor G2 Safety Glasses, Tint**

**T32404—EDGE Mazeno Safety Glasses, Clear**



**Figure 55.** Assortment of basic eye protection.

**T33434—Nitrile Disposable Gloves, Medium**

**T33435—Nitrile Disposable Gloves, Large**

**T33436—Nitrile Disposable Gloves, XL**

**T33437—Nitrile Disposable Gloves, XXL**

Nitrile disposable gloves are an inexpensive and effective form of hand protection. These heavy-duty gloves are 9 mil thick, designed with textured fingertips for better grip, and used as a protective barrier against dirt, paint, chemicals, solvents, and more.



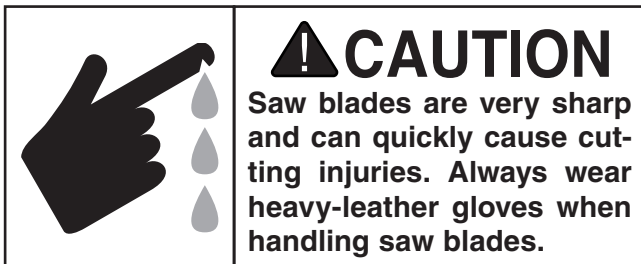
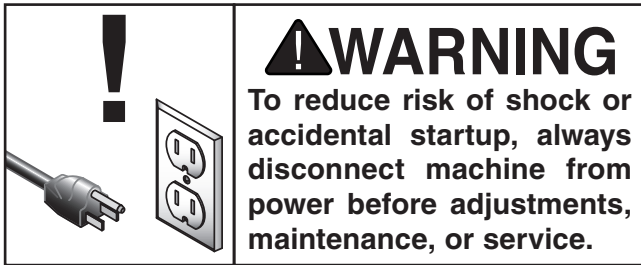
**Figure 56.** Nitrile disposable gloves.

**order online at [www.grizzly.com](http://www.grizzly.com) or call 1-800-523-4777**



# SECTION 7: MAINTENANCE

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## Schedule

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

### Ongoing

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

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.

### Daily Maintenance

- Clean and sanitize machine before and after every use.
- Lubricate entire blade and table top.
- Cover machine with a clean, dry cloth until next use.

### Monthly Check

- V-belt tension, damage, or wear.
- Under normal conditions, replace saw blade after cutting 4400 lbs. of meat or bone.

## Cleaning & Sanitizing

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Thoroughly clean and sanitize the saw as directed in **CLEANING & SANITIZING** on **Page 33** before and after every use. Get in the habit of properly cleaning and sanitizing the saw daily to avoid contamination and illness.

## Lubrication

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Maintain the blade and table top with a thin film of **food-grade lubricant** that will NOT support bacterial growth or become rancid.

**Note:** *DO NOT use food-grade oils typically used for cooking (vegetable oil, olive oil, etc.) that can become rancid over time and may cause illness.*

Make sure the product you use is specifically designed for protecting food processing equipment, such as 100% food-grade mineral oil certified by the NSF (National Science Foundation). Always follow the manufacturer's recommendations when using their products.

**Note:** *DO NOT lubricate meat grinder! The meat processed in the grinder serves as a natural lubricant during use.*

The wheel bearings are shielded and lubricated, and require no maintenance throughout their lifespan.

## V-Belt

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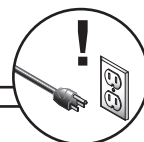
Avoid getting grease or oil on the V-belt or pulleys. Check the V-belt as part of a monthly inspection for proper tension and belt condition. Cracking and glazing could result in belt failure. Replace the belt if such conditions appear.



# SECTION 8: SERVICE

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

## Troubleshooting



### Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or power supply breaker trips immediately after startup.	<ol style="list-style-type: none"> <li>1. OFF button not reset.</li> <li>2. Incorrect power supply voltage or circuit size.</li> <li>3. Power supply circuit breaker tripped or fuse blown.</li> <li>4. Motor wires connected incorrectly.</li> <li>5. Centrifugal switch adjustment/contact points at fault.</li> <li>6. Wiring broken, disconnected, or corroded.</li> <li>7. ON/OFF switch at fault.</li> <li>8. Motor or motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Press OFF button completely until it clicks.</li> <li>2. Ensure correct power supply voltage and circuit size (<b>Page 10</b>).</li> <li>3. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.</li> <li>4. Correct motor wiring connections.</li> <li>5. Adjust centrifugal switch/clean contact points. Replace either if at fault.</li> <li>6. Fix broken wires or disconnected/corroded connections (<b>Page 43</b>).</li> <li>7. Replace switch.</li> <li>8. Replace motor.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Excessive feed rate/pressure.</li> <li>2. Workpiece material unsuitable for machine.</li> <li>3. Fence crooked, loose, or misadjusted.</li> <li>4. Machine undersized, blade dull, or wrong blade for task.</li> <li>5. Blade slipping on wheels.</li> <li>6. Belt slipping/pulleys misaligned.</li> <li>7. Motor wired incorrectly.</li> <li>8. Pulley/sprocket slipping on shaft.</li> <li>9. Motor overheated.</li> <li>10. Run capacitor at fault.</li> <li>11. Extension cord too long.</li> <li>12. Centrifugal switch/contact points at fault.</li> <li>13. Motor or motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate/pressure.</li> <li>2. Only cut fresh or frozen meat and bones.</li> <li>3. Straighten or adjust fence.</li> <li>4. Replace blade (<b>Page 29</b>). Use correct blade/reduce feed rate and depth of cut.</li> <li>5. Adjust blade tracking and tension (<b>Page 25</b>).</li> <li>6. Clean/tension/replace belt (<b>Page 41</b>); ensure pulleys are aligned.</li> <li>7. Wire motor correctly.</li> <li>8. Tighten/replace loose pulley/shaft.</li> <li>9. Clean motor, let cool, and reduce workload.</li> <li>10. Test/repair/replace.</li> <li>11. Move machine closer to power supply; use shorter extension cord.</li> <li>12. Adjust centrifugal switch/clean contact points. Replace either if at fault.</li> <li>13. Replace motor.</li> </ol>



## Motor & Electrical (Cont.)

Symptom	Possible Cause	Possible Solution
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor or component loose.</li> <li>2. Stand feet not adjusted properly.</li> <li>3. Blade weld at fault/teeth broken.</li> <li>4. V-belt worn, loose, pulleys misaligned or belt slapping cover.</li> <li>5. Pulley loose.</li> <li>6. Motor mount loose/broken.</li> <li>7. Motor fan rubbing on fan cover.</li> <li>8. Centrifugal switch.</li> <li>9. Motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace damaged or missing bolts/nuts or tighten if loose.</li> <li>2. Adjust stand feet to stabilize machine.</li> <li>3. Replace blade (<b>Page 29</b>).</li> <li>4. Inspect/replace belt (<b>Page 41</b>). Realign pulleys if necessary.</li> <li>5. Secure pulley on shaft.</li> <li>6. Tighten/replace.</li> <li>7. Fix/replace fan cover; replace loose/damaged fan.</li> <li>8. Replace.</li> <li>9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> </ol>

## Operations

Symptom	Possible Cause	Possible Solution
Blade or teeth break/crack.	<ol style="list-style-type: none"> <li>1. Blade tension is incorrect.</li> <li>2. Blade is incorrect for application.</li> <li>3. Excessive feed rate/pressure.</li> <li>4. Blade is dull/weld at end-of-life.</li> <li>5. Blade tracking is incorrect.</li> <li>6. Blade guides/support bearings improperly adjusted.</li> <li>7. Bone stuck in blade guides/support bearings.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust blade tension (<b>Page 25</b>).</li> <li>2. Use correct blade for application.</li> <li>3. Reduce feed rate/pressure.</li> <li>4. Replace blade (<b>Page 29</b>).</li> <li>5. Adjust blade tracking (<b>Page 21</b>).</li> <li>6. Adjust blade guides/support bearings (<b>Page 27</b>). Replace if faulty.</li> <li>7. Clean and sanitize blade guides/support bearings (<b>Page 33</b>).</li> </ol>
Blade tracks incorrectly or comes off wheels.	<ol style="list-style-type: none"> <li>1. Blade tracking is incorrect.</li> <li>2. Blade tension too loose.</li> <li>3. Blade guides/support bearings improperly adjusted.</li> <li>4. Excessive feed rate/pressure.</li> <li>5. Incorrect blade for machine.</li> <li>6. Blade is bell-mouthed, worn, or dull.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust blade tracking (<b>Page 21</b>).</li> <li>2. Increase blade tension (<b>Page 25</b>).</li> <li>3. Adjust blade guides/support bearings (<b>Page 27</b>).</li> <li>4. Reduce feed rate/pressure.</li> <li>5. Install correct blade (<b>Page 29</b>).</li> <li>6. Replace blade (<b>Page 29</b>). Remove tension from blade when not in use.</li> </ol>
Cut is crooked or blade wanders (blade lead).	<ol style="list-style-type: none"> <li>1. Excessive feed rate/pressure.</li> <li>2. Blade tension too loose.</li> <li>3. Blade is too narrow or tooth type/TPI is incorrect for operation.</li> <li>4. Blade guides/support bearings improperly adjusted.</li> <li>5. Blade dull or has damaged tooth set.</li> <li>6. Blade tracking is incorrect.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate/pressure.</li> <li>2. Increase blade tension (<b>Page 25</b>).</li> <li>3. Use wider blade. Ensure tooth type &amp; TPI are correct.</li> <li>4. Adjust blade guides/support bearings (<b>Page 27</b>).</li> <li>5. Replace blade (<b>Page 29</b>).</li> <li>6. Adjust blade tracking (<b>Page 21</b>).</li> </ol>
Blade dulls prematurely.	<ol style="list-style-type: none"> <li>1. Excessive feed rate/pressure.</li> <li>2. Incorrect blade tooth type or TPI.</li> <li>3. Blade is twisted.</li> <li>4. Blade is slipping on wheel.</li> <li>5. Blade guides hitting teeth and damaging tooth set.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate/pressure.</li> <li>2. Use blade with correct tooth type and TPI.</li> <li>3. Adjust/replace blade (<b>Page 29</b>).</li> <li>4. Adjust blade tension (<b>Page 25</b>).</li> <li>5. Adjust blade guides/support bearings (<b>Page 27</b>).</li> </ol>



# 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 every month—more often if the bandsaw is used daily under heavy load.

Items Needed	Qty
Straightedge 36".....	1
Open-End Wrench 13mm.....	1
Hex Wrench 5mm.....	1

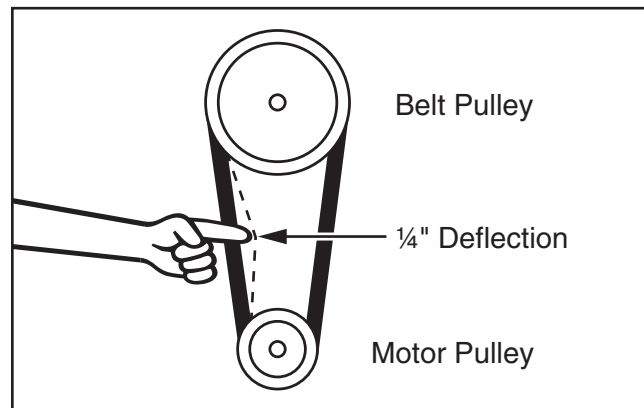
## Checking & Tensioning V-Belt

1. DISCONNECT MACHINE FROM POWER!
2. Remove table and both stand covers, then open cabinet door.

**Note:** *Fence and meat pusher can remain installed when removing table.*

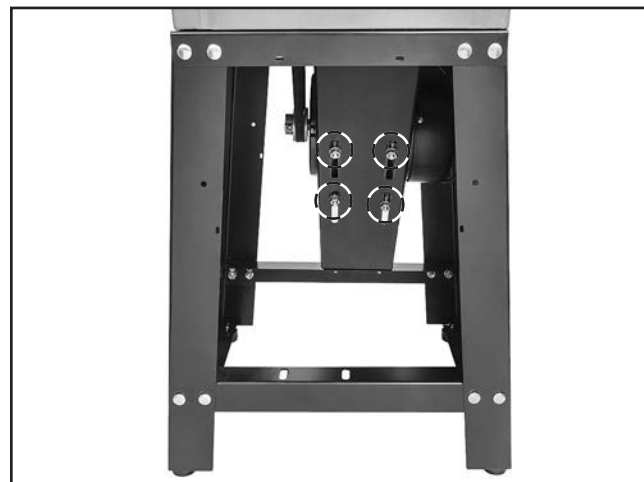
3. Inspect V-belt; if it is cracked, frayed, or glazed, proceed to **Replacing V-Belt** on **Page 41**.

4. Check V-belt tension by applying moderate pressure between pulleys (see **Figure 57**).
  - If V-belt deflection *is* approximately  $\frac{1}{4}$ ", belt is correctly tensioned and no adjustment is required.
  - If deflection *is not* approximately  $\frac{1}{4}$ ", V-belt requires tensioning. Proceed to **Step 5**.



**Figure 57.** Testing for  $\frac{1}{4}$ " V-belt deflection.

5. Loosen (4) hex nuts securing motor to motor mount (see **Figure 58**).



**Figure 58.** Location of motor mount hex nuts.

6. Press down on center of motor to tension V-belt, then tighten (4) hex bolts to secure motor. Make sure that motor *does not* twist while applying pressure.



7. Check V-belt tension by applying moderate pressure between pulleys (see **Figure 57** on **Page 40**).

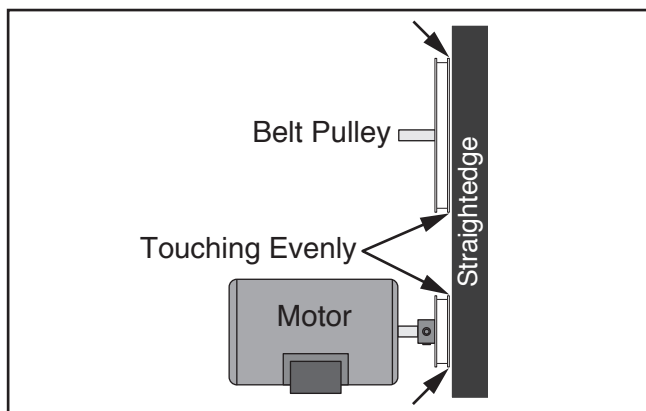
- If V-belt deflection *is* approximately  $\frac{1}{4}$ ", belt is correctly tensioned. Proceed to **Step 8**.

- If there is more than  $\frac{1}{4}$ " deflection, loosen (4) motor mount hex bolts and hex nuts, then repeat **Steps 6–7** until properly tensioned. If tension cannot be achieved, proceed to **Replacing V-Belt**.

8. Hold a straightedge close to the center of both pulleys, and make sure straightedge fully extends across rims of both pulleys (see **Figure 59**).

- If pulleys are parallel and coplanar, straightedge will touch the top and bottom rims on both pulleys. No further adjustment is required.

- If pulleys are parallel but not coplanar, straightedge will touch the top and bottom rims on one pulley, but will not touch either rim on the other pulley. In this case, loosen (4) carriage bolts securing motor mount, then re-position motor so straightedge touches the top and bottom rims on both pulleys. Repeat **Steps 6–8**.

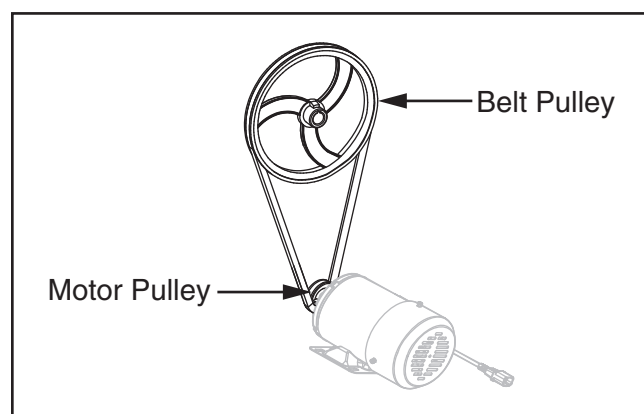


**Figure 59.** Checking pulley alignment with a straightedge.

9. Re-install table, fences, and both stand covers, then close cabinet door.

## Replacing V-Belt

1. DISCONNECT MACHINE FROM POWER!
2. Remove table, fences, and both stand covers, then open cabinet door.
3. Loosen (4) hex bolts securing motor to motor mount (see **Figure 58** on **Page 40**).
4. Raise motor, then remove V-belt from motor pulley and belt pulley.
5. Fit replacement V-belt into belt pulley groove, raise motor, then fit V-belt into motor pulley groove (see **Figure 60**).



**Figure 60.** V-belt installed on pulley grooves (saw body removed for clarity).

6. Properly tension V-belt (refer to **Steps 4–7** of **Tensioning V-Belt** on **Page 40**).
7. Re-install table and both stand covers, then close cabinet door.



# SECTION 9: WIRING

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

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

## WARNING

### Wiring Safety Instructions

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

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

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

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

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

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















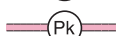
**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

#### NOTICE

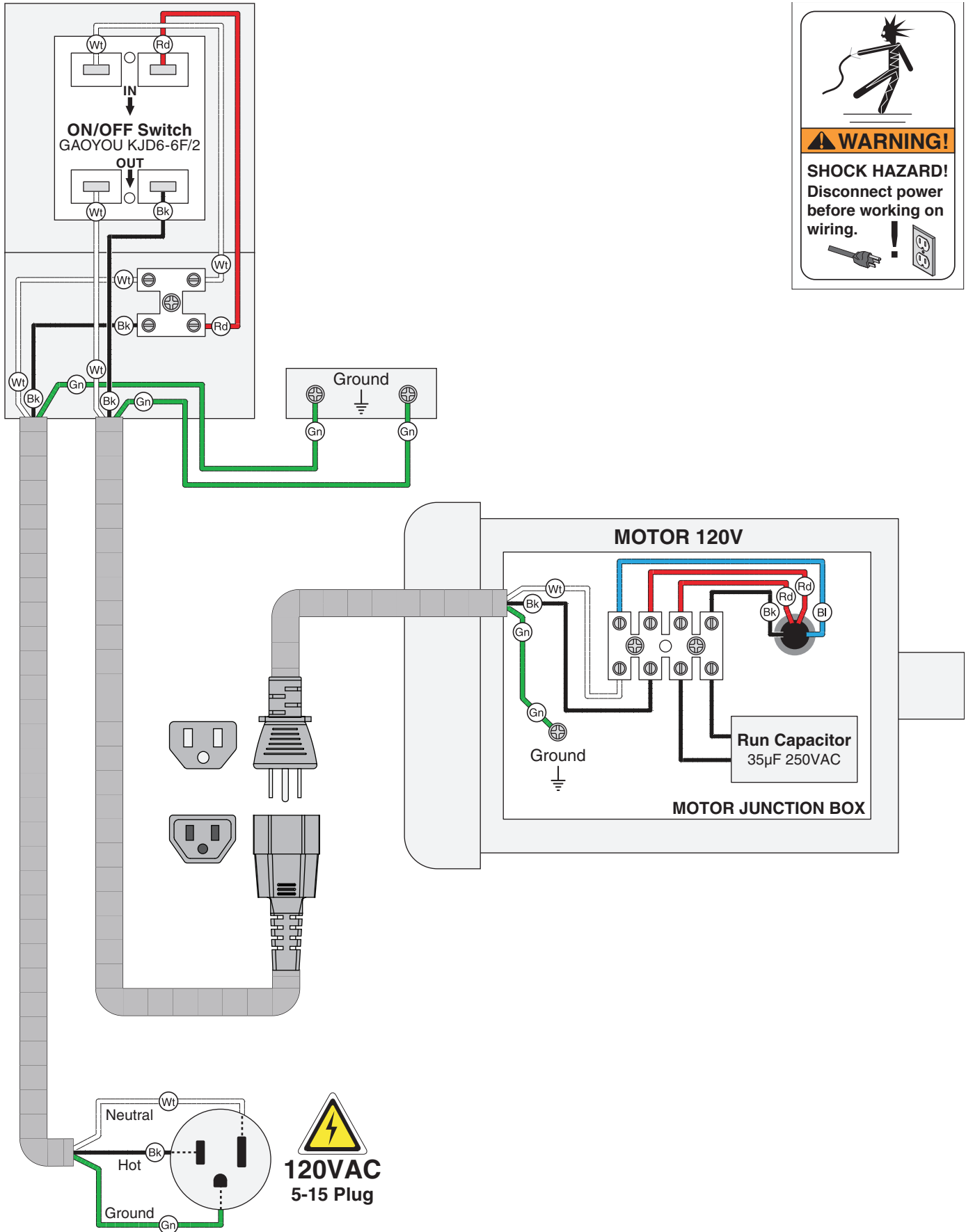
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

#### COLOR KEY

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



# Wiring Diagram



# Electrical Components



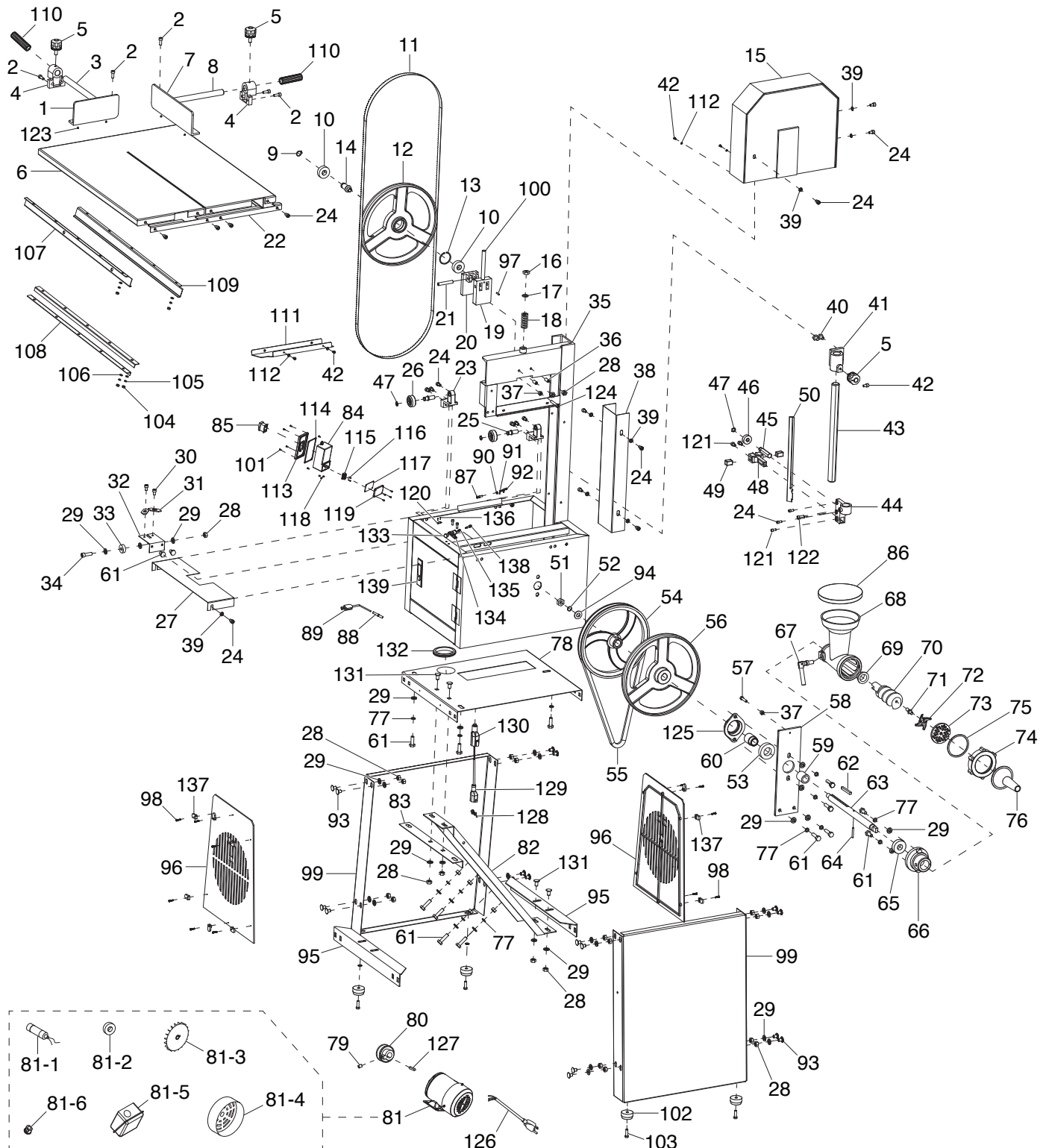
Figure 61. Motor junction box.



# SECTION 10: PARTS

**Please Note:** We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at [www.grizzly.com](http://www.grizzly.com) to check for availability.

## Main



# Main Parts List

REF	PART #	DESCRIPTION
1	PT32304001	MEAT PUSHER
2	PT32304002	CAP SCREW M6-1 X 16
3	PT32304003	PUSHER SHAFT 310MM
4	PT32304004	SHAFT SUPPORT BRACKET
5	PT32304005	KNOB BOLT M6-1 X 20, 8-LOBE, D30
6	PT32304006	TABLE 23-1/2" X 18-1/4"
7	PT32304007	FENCE
8	PT32304008	FENCE SHAFT 370MM
9	PT32304009	EXT RETAINING RING 14MM
10	PT32304010	BALL BEARING 6202RS
11	PT32304011	BLADE 5/8" X 82" 4 TPI
12	PT32304012	UPPER WHEEL 10"
13	PT32304013	INT RETAINING RING 38MM
14	PT32304014	WHEEL SHAFT M12-1.75 X 43
15	PT32304015	WHEEL COVER
16	PT32304016	HEX NUT M10-1.5
17	PT32304017	FLAT WASHER 10MM
18	PT32304018	COMPRESSION SPRING 4 X 18.5 X 42
19	PT32304019	TENSION PLATE
20	PT32304020	TRACKING PLATE
21	PT32304021	DOWEL PIN 8 X 50
22	PT32304022	RETENTION BRACKET
23	PT32304023	ROLLER BRACKET
24	PT32304024	CAP SCREW M6-1 X 10
25	PT32304025	ROLLER AXLE 10 X 34MM
26	PT32304026	ROLLER 10 X 33MM
27	PT32304027	REAR COVER
28	PT32304028	HEX NUT M8-1.25
29	PT32304029	FLAT WASHER 8MM
30	PT32304030	CAP SCREW M6-1 X 10
31	PT32304031	LOWER BLADE GUIDE
32	PT32304032	LOWER GUIDE SUPPORT BRACKET
33	PT32304033	BALL BEARING 608-2RS
34	PT32304034	CAP SCREW M8-1.25 X 25
35	PT32304035	SAW BODY
36	PT32304036	SET SCREW M8-1.25 X 16
37	PT32304037	HEX NUT M6-1
38	PT32304038	COLUMN COVER
39	PT32304039	FLAT WASHER 6MM
40	PT32304040	HEX BOLT M8-1.25 X 12

REF	PART #	DESCRIPTION
41	PT32304041	GUIDE RAIL SUPPORT BRACKET
42	PT32304042	CAP SCREW M4-.7 X 10
43	PT32304043	BLADE GUIDE RAIL
44	PT32304044	BLADE GUIDE SUPPORT BRACKET
45	PT32304045	SUPPORT BEARING PIN 10 X 34MM
46	PT32304046	BALL BEARING 6200-2RS
47	PT32304047	EXT RETAINING RING 10MM
48	PT32304048	BLADE GUIDE BRACKET
49	PT32304049	BLADE GUIDE
50	PT32304050	BLADE GUARD
51	PT32304051	HEX NUT M12-1.75
52	PT32304052	LOCK WASHER 12MM
53	PT32304053	BALL BEARING 6005ZZ
54	PT32304054	WHEEL PULLEY
55	PT32304055	V-BELT A-1000
56	PT32304056	LOWER WHEEL 10"
57	PT32304057	HEX BOLT M6-1 X 25
58	PT32304058	WHEEL SUPPORT PLATE
59	PT32304059	BUSHING 19.5ID X 27OD X 30L
60	PT32304060	BUSHING 19ID X 28.5OD X 30.5L
61	PT32304061	HEX BOLT M8-1.25 X 20
62	PT32304062	KEY 6 X 6 X 70
63	PT32304063	MEAT GRINDER SPINDLE
64	PT32304064	ROLL PIN 4 X 40
65	PT32304065	BALL BEARING 6203ZZ
66	PT32304066	MEAT GRINDER MOUNTING BRACKET
67	PT32304067	FOLDING HANDLE 11 X 74, M10-1.5 X 18
68	PT32304068	HOPPER FUNNEL
69	PT32304069	BUSHING 22.5ID X 35OD X 15L
70	PT32304070	AUGER
71	PT32304071	AUGER SCREW M8-1.25 X 29
72	PT32304072	REAMER
73	PT32304073	GRINDING PLATE 3/16"
74	PT32304074	LOCKING COLLAR
75	PT32304075	COLLAR GASKET 3.25 X 63.5 X 70
76	PT32304076	SAUSAGE STUFFER
77	PT32304077	LOCK WASHER 8MM
78	PT32304078	STAND TOP
79	PT32304079	SET SCREW M8-1.25 X 12
80	PT32304080	MOTOR PULLEY



# Main Parts List (Cont.)

REF	PART #	DESCRIPTION
81	PT32304081	MOTOR 3/4 HP 120V 1-PH
81-1	PT32304081-1	R CAPACITOR 35M 250V 1-1/2 X 2-7/8
81-2	PT32304081-2	BALL BEARING 6203ZZ
81-3	PT32304081-3	MOTOR FAN
81-4	PT32304081-4	FAN COVER
81-5	PT32304081-5	MOTOR JUNCTION BOX
81-6	PT32304081-6	STRAIN RELIEF TYPE-3 M18-2.5
82	PT32304082	MOTOR MOUNT
83	PT32304083	UPPER BRACE
84	PT32304084	SWITCH HOUSING
85	PT32304085	ON/OFF SWITCH GAOYOU KJD6 250V
86	PT32304086	MEAT GRINDER COVER
87	PT32304087	PHLP HD SCR M4-.7 X 6
88	PT32304088	CABLE BOOT 8 X 18MM
89	PT32304089	POWER CORD 14G 3W 72" 5-15P
90	PT32304090	LOCK WASHER 4MM
91	PT32304091	TERMINAL LUG 18AWG
92	PT32304092	EXT TOOTH WASHER 4MM
93	PT32304093	CARRIAGE BOLT M8-1.25 X 16
94	PT32304094	FLAT WASHER 12MM
95	PT32304095	SIDE BRACE
96	PT32304096	STAND COVER
97	PT32304097	ROLL PIN 3 X 16
98	PT32304098	TAP SCREW M2.2 X 12
99	PT32304099	STAND LEG
100	PT32304100	STUD-SE M10-1.5 X 104, 54
101	PT32304101	TAP SCREW M4.2 X 13
102	PT32304102	RUBBER FOOT
103	PT32304103	HEX BOLT M6-1 X 20
104	PT32304104	HEX NUT M5-.8
105	PT32304105	LOCK WASHER 5MM
106	PT32304106	FLAT WASHER 5MM
107	PT32304107	TABLE SLIDE RAIL (LEFT)


REF	PART #	DESCRIPTION
108	PT32304108	TABLE SUPPORT BEAM
109	PT32304109	TABLE SLIDE RAIL (RIGHT)
110	PT32304110	SHAFT HANDLE
111	PT32304111	PULLEY GUARD
112	PT32304112	FLAT WASHER 4MM
113	PT32304113	SWITCH COVER, FRONT
114	PT32304114	COVER SEAL
115	PT32304115	TERMINAL BLOCK PA10-2P
116	PT32304116	TAP SCREW M2.9 X 20
117	PT32304117	SWITCH HOUSING GASKET
118	PT32304118	RUBBER GROMMET 12MM
119	PT32304119	SWITCH COVER, REAR
120	PT32304120	CORD CLAMP
121	PT32304121	CAP SCREW M5-.8 X 10
122	PT32304122	CAP SCREW M5-.8 X 16
123	PT32304123	FRICTION PAD
124	PT32304124	CAP SCREW M6-1 X 35
125	PT32304125	BEARING SEAT
126	PT32304126	MOTOR CORD 18G 3W 18" 5-15P
127	PT32304127	KEY 5 X 5 X 30
128	PT32304128	CABLE HOLDER
129	PT32304129	MOTOR CORD 18G 3W 24" 5-15 (FEMALE)
130	PT32304130	SOCKET GUARD
131	PT32304131	CARRIAGE BOLT M8-1.25 X 16
132	PT32304132	GROMMET 45 X 57 X 6MM
133	PT32304133	KNOB M5-.8, D15, BALL
134	PT32304134	TABLE LOCK SUPPORT BRACKET
135	PT32304135	COMPRESSION SPRING 0.7 X 8.7 X 18
136	PT32304136	PHLP HD SCR M4-.7 X 16
137	PT32304137	CATCH TAB
138	PT32304138	TABLE LOCK PIN
139	PT32304139	DOOR LATCH



# Labels & Cosmetics

# T32304

grizzly.com



**MODEL T32304**  
**10" 3/4 HP MEAT CUTTING BANDSAW**

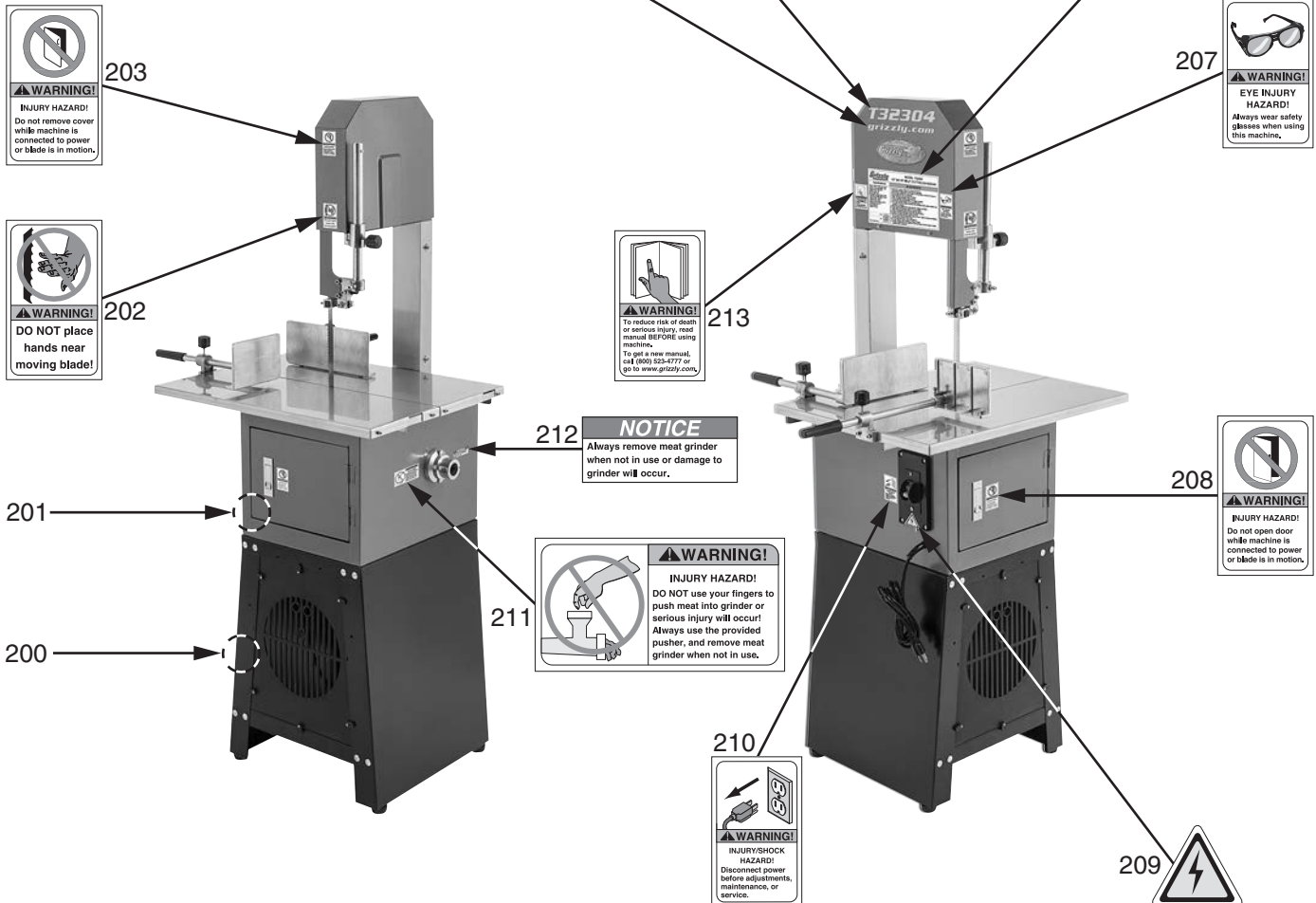
**Specifications**

Motor: 3/4 HP, 120V, 1-Phi, 60 Hz  
Full-Load Current Rating: 4.8A  
Blade Speed: 933 FPM  
Blade Length: 82"  
Blade Width: 5/8"  
Maximum Cutting Width: 6-3/8"  
Maximum Cutting Height: 9-3/8"  
Table Length: 25-1/2"  
Table Width: 16-1/4"  
Floor-to-Table Height: 33-7/8"  
Wheel Diameter: 10"  
Wheel Width: 1"  
Weight: 94 lbs.

**WARNING!**

To reduce risk of serious injury when using this machine:

1. Read and understand owner's manual before operating.
2. Never touch moving blade—keep hands out of blade path and never force the cut.
3. Always wear approved eye protection.
4. Only plug power cord into a grounded outlet.
5. Clean and sanitize machine after every use.
6. Only remove jammed cut-off pieces when blade is stopped.
7. Use attached push-through tool to complete all cuts.
8. Turn motor OFF and disconnect power before changing blades, making adjustments, cleaning, or servicing.
9. Maintain proper adjustment of blade tension, tracking, and guides.
10. Keep upper guide adjusted to just clear the workpiece.
11. Hold workpiece firmly against table to maintain control.
12. Only run saw with wheel covers closed and guards in place.
13. Never reach under table while blade is in motion.
14. DO NOT wear loose clothing, gloves, jewelry, or other articles that can get entangled.
15. The back long hair and roll up sleeves.
16. DO NOT expose to rain or use in wet locations.
17. Prevent unauthorized use by children or untrained users; restrict access or disable machine when unattended.



REF	PART #	DESCRIPTION
200	PT32304200	TOUCH-UP PAINT, GLOSS BLACK
201	PT32304201	TOUCH-UP PAINT, GRIZZLY GREEN
202	PT32304202	BANDSAW BLADE LABEL
203	PT32304203	COVER CLOSED LABEL
204	PT32304204	GRIZZLY.COM LABEL
205	PT32304205	MODEL NUMBER LABEL
206	PT32304206	MACHINE ID LABEL

REF	PART #	DESCRIPTION
207	PT32304207	SAFETY GLASSES LABEL
208	PT32304208	DOOR CLOSED LABEL
209	PT32304209	ELECTRICITY LABEL
210	PT32304210	DISCONNECT 110V LABEL
211	PT32304211	MEAT GRINDER LABEL
212	PT32304212	REMOVE GRINDER LABEL
213	PT32304213	READ MANUAL LABEL

## ! WARNING

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



# WARRANTY & RETURNS

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

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

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

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

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

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

To take advantage of this warranty, you must register it at **<https://www.grizzly.com/forms/warranty>**, or you can scan the QR code below to be automatically directed to our warranty registration page. Enter all applicable information for the product.





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