



MODEL T32417/21/23/29/30 BLADE GUIDE INSTRUCTIONS

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

Introduction

These blade guides replace the blade guides on your G0555-series bandsaw. Each guide set uses the same support assembly for easy swapping between blade guide styles.

Bearing guides for standard bandsaw operations are included with models T32417 and T32423.

Ceramic guides are included with models T32421 and T32423. Ceramics are great for reducing heat during resaw operations and/or with wide blades (up to $\frac{3}{4}$ " for G0555 machines).

Scrolling guides are included with model T32429. These guides provide stability and support for thin blades ($\frac{1}{4}$ " or less) for use with fine workpieces and scrollsaw-type operations. Model T32430 includes only the scrolling guides for use with support assemblies from another model.

Blade Guide Inventory

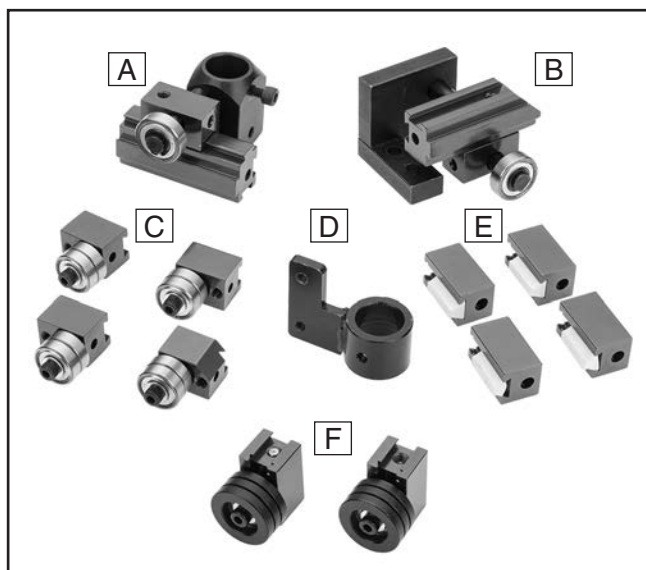


Figure 1. Blade guide components.

T32417 Components	Qty
A. Upper Support Assembly	1
B. Lower Support Assembly	1
C. Bearing Guides.....	4
D. Guard Bracket	1

T32421 Components	Qty
A. Upper Support Assembly	1
B. Lower Support Assembly	1
D. Guard Bracket	1
E. Ceramic Guides.....	4

T32423 Components	Qty
A. Upper Support Assembly	1
B. Lower Support Assembly	1
C. Bearing Guides.....	4
D. Guard Bracket	1
E. Ceramic Guides.....	4

T32429 Components	Qty
A. Upper Support Assembly	1
B. Lower Support Assembly	1
D. Guard Bracket	1
F. Scrolling Guides	2

Note: T32429 support assemblies do not include support bearing blocks.

T32430 Components	Qty
F. Scrolling Guides	2

Required for Setup

Description	Qty
$\frac{1}{4}$ "-20 x $\frac{1}{4}$ " Phillips Head Screws	2

Installing Blade Guides

Installing the blade guides involves removing the blade and table from the bandsaw, installing the guard bracket to the guide post, and replacing the existing blade guide assemblies with the new ones. The bearing, ceramic, and scrolling blade guides use the same support assemblies; all three styles follow the same installation procedure.

Tools Needed

	Qty
Phillips Head Screwdriver #2	1
Wrench 10mm	1
Hex Wrench 5mm.....	1

To install blade guides:

1. DISCONNECT BANDSAW FROM POWER!
2. Follow instructions in your bandsaw Owner's Manual to remove blade and table from bandsaw.
3. Remove and set aside (2) Phillips head screws and flat washers that secure upper guide assembly to blade guard (see **Figure 2**).
4. While holding upper blade guide assembly with one hand, loosen (1) cap screw that secures assembly to guide post, then remove assembly (see **Figure 2**). Set aside cap screw.

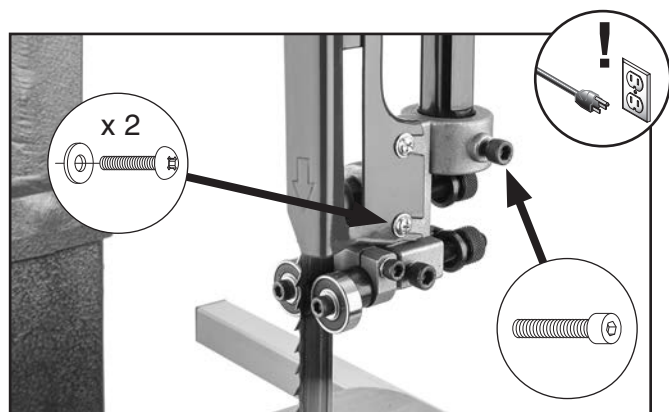


Figure 2. Existing upper blade guide assembly and fasteners.

5. Slide guide bracket on guide bar, then attach bracket to blade guard with (2) 1/4"-20 x 1/4" Phillip head screws (see **Figure 3**).
6. Secure guide bracket to guide post with cap screw removed in **Step 4** (see **Figure 3**).

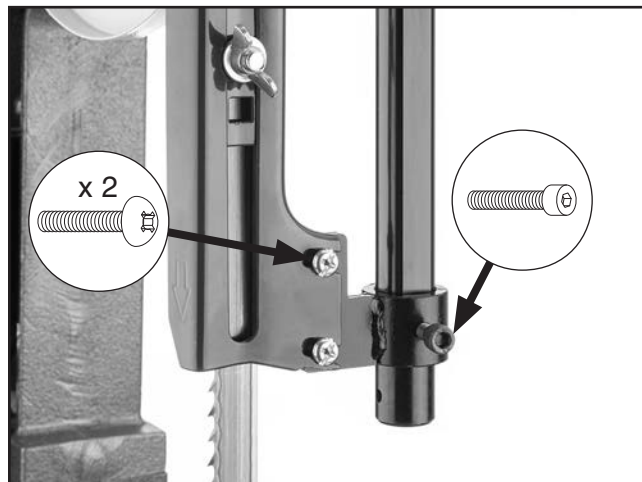


Figure 3. Guard bracket installed on guide post and blade guard.

7. Install new upper blade guide assembly on guide post with (1) included cap screw.

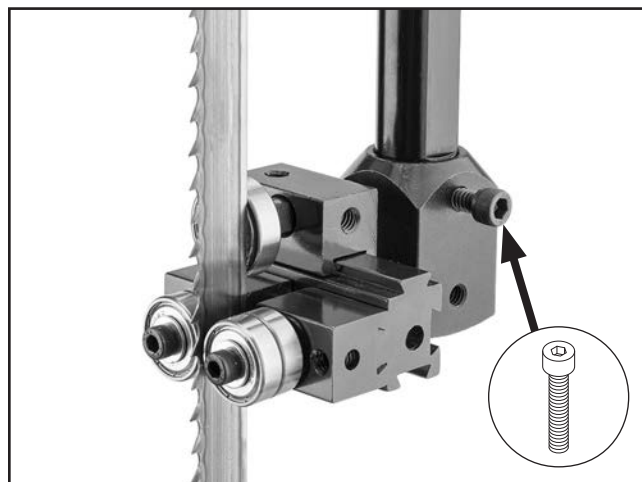


Figure 4. Upper blade guide installed on guide post.



8. Loosen (6) flange bolts that secure bandsaw table to trunnion brackets, then remove table from saw.
9. Loosen (2) hex bolts that secure lower blade guide assembly to bandsaw base, then remove assembly (see **Figure 5**).

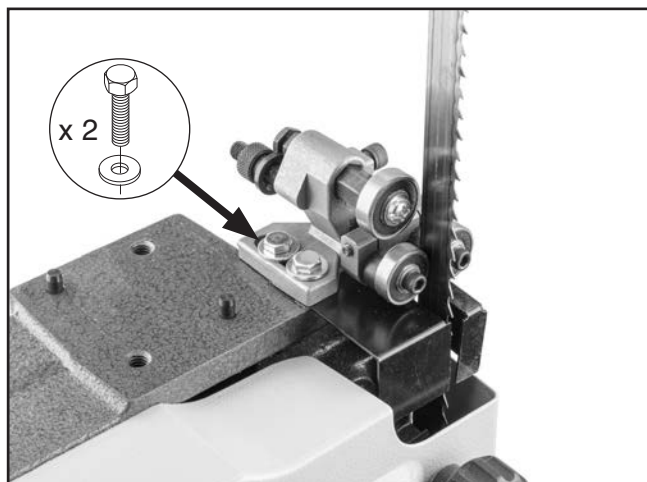


Figure 5. Existing lower blade guide assembly and fasteners.

10. Install new lower blade guide assembly on bandsaw base with (2) hex bolts from **Step 9**.

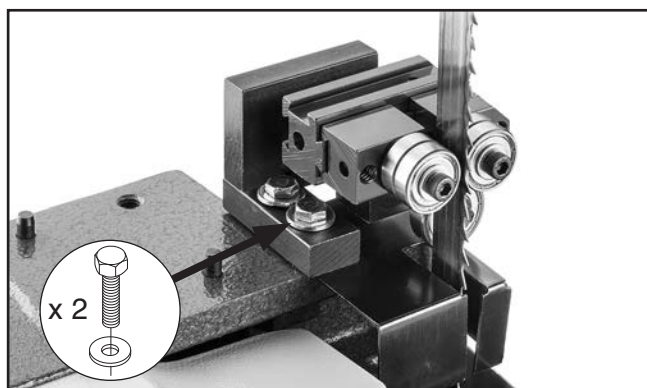


Figure 6. Lower blade guide installed on bandsaw base.

11. Install bandsaw table on trunnion bracket with (6) flange bolts removed in **Step 5**, then follow instructions in your Owner's Manual to adjust table tilt and table alignment.
12. Follow instructions in your Owner's Manual to install blade on bandsaw.
13. Adjust blade guides according to the type installed, see **Pages 3–5**.

Adjusting Bearing & Ceramic Blade Guides

Tools Needed	Qty
Hex Wrench 3mm.....	1
Feeler Gauge Set.....	1

To adjust bearing & ceramic blade guides:

1. DISCONNECT BANDSAW FROM POWER!
2. Follow instructions in your bandsaw Owner's Manual to adjust blade tension and blade tracking.
3. Adjust upper blade guide assembly approximately 2" above bandsaw table.
4. Loosen set screw on left guide block shown in **Figure 7**.

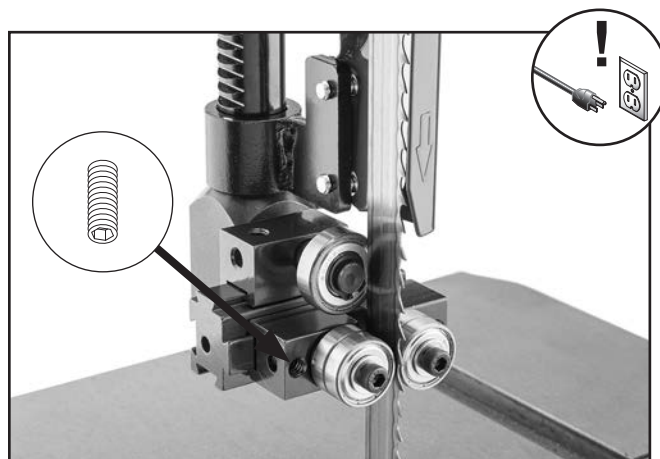


Figure 7. Guide block adjustment location.

5. Place feeler gauge between bearing and blade, then slide block until bearing touches feeler gauge without deflecting the blade.
 - For bearing blade guides, use 0.001"–0.002" feeler gauge.
 - For ceramic blade guides, use 0.005"–0.007" feeler gauge.
6. Hold bearing block in place and tighten set screw from **Step 4**.
7. Repeat **Steps 4–6** for right guide block.
8. Verify gap between blade and both guides with feeler gauge. Ensure gap is equal on both sides and guides do not deflect blade.



9. Verify that guides are $\frac{1}{32}$ "– $\frac{1}{64}$ " behind blade gullet.

— If guides are too close or far from teeth, loosen set screw shown in **Figure 8**, then adjust guides until front edge is within $\frac{1}{32}$ "– $\frac{1}{64}$ " behind blade gullet.

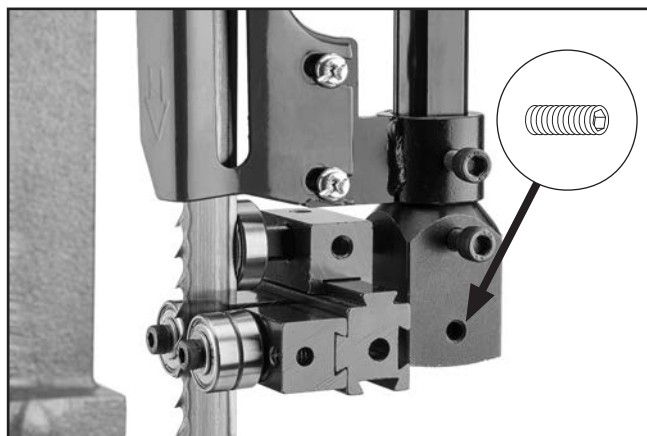


Figure 8. Blade guide position set screw location.

10. Loosen set screw shown in **Figure 9**.
11. Slide support bearing block until outer race extends past blade (see **Figure 9**).

— If support bearing shaft is too long to adjust properly, proceed to **Modifying Support Bearing Shaft** on **Page 5** before continuing with adjustment.

12. Hold support bearing block in position and tighten set screw shown in **Figure 9**.

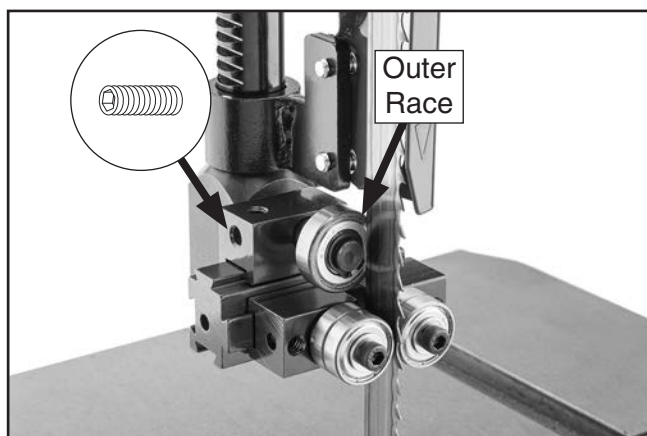


Figure 9. Support bearing set in correct lateral position.

13. Loosen set screw shown in **Figure 10**.

14. Adjust support bearing shaft forward or back until bearing is 0.016" away from blade spine (see **Figure 10**).

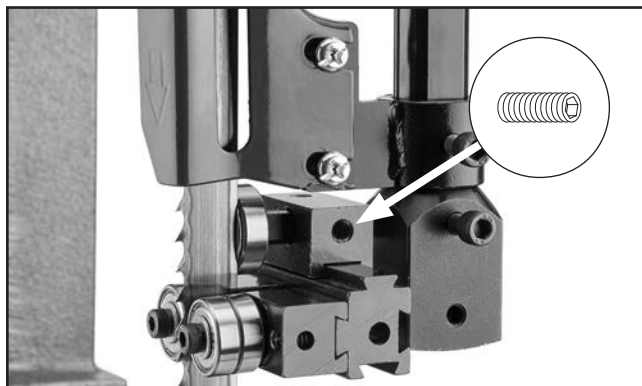


Figure 10. Bearing set against blade spine.

15. Repeat **Steps 4–14** to install lower blade guide assembly.

Adjusting Scrolling Blade Guides

Tools Needed	Qty
Hex Wrench 3mm.....	1

To adjust scrolling blade guides:

1. DISCONNECT BANDSAW FROM POWER!
2. Follow instructions in your bandsaw Owner's Manual to adjust blade tension and blade tracking.
3. Adjust upper blade guide assembly approximately 2" above bandsaw table.
4. Loosen set screw on guide block shown in **Figure 11**.

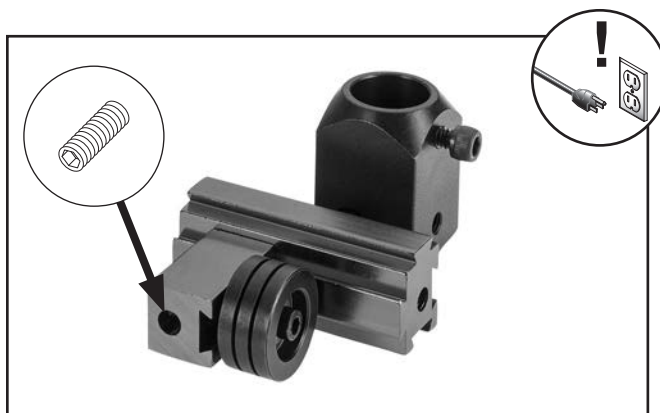


Figure 11. Guide block adjustment set screw location.



5. Move guide block so roller is behind blade spine.
6. Hold guide block in place and tighten set screw from **Step 4**.
7. Loosen set screw on support block shown in **Figure 12**.

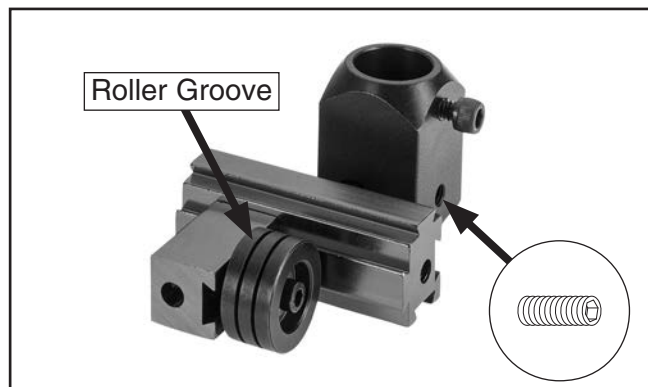


Figure 12. Support block set screw location.

8. Adjust assembly until blade spine rests in roller groove without deflecting blade.
9. Hold assembly in place and tighten set screw from **Step 8**.
10. Repeat **Steps 4–10** for lower blade guide assembly.

Modifying Support Bearing Shaft

On some machines, when using wide blades with the bearing or ceramic guides, the included support bearing shaft might be too long to adjust properly. If this is the case, the support bearing shaft may be shortened to allow proper adjustment. If the shaft touches the support block when the support bearing is adjusted properly, or if the support block prevents proper adjustment, the shaft should be shortened (see **Figure 13**).

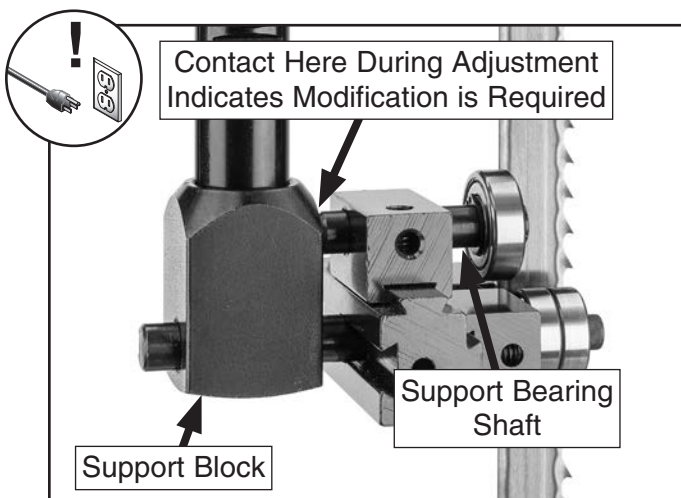


Figure 13. Location of shaft and support block contact on upper assembly.

Tools Needed	Qty
Vise	1
Hacksaw	1

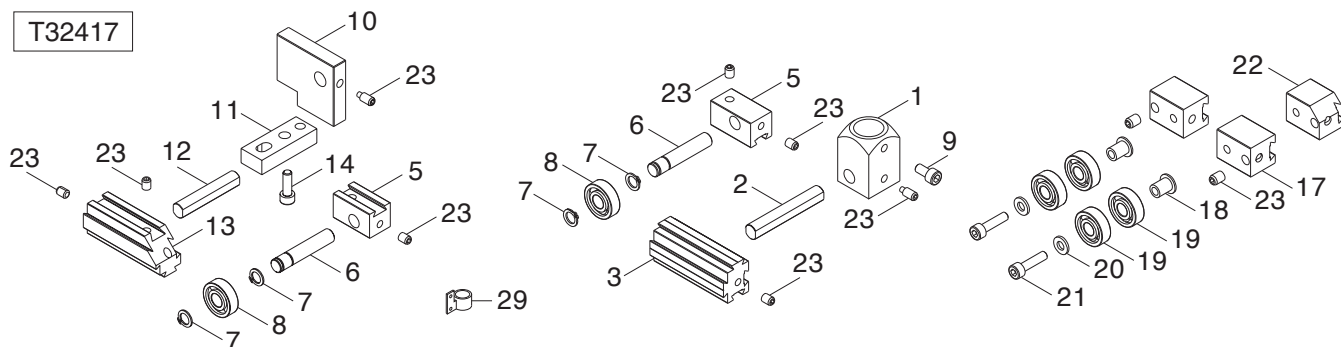
To modify support bearing shaft:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen set screw and remove support bearing shaft from adjustment block.
3. Secure shaft with vise.
4. Use hacksaw to shorten support bearing shaft enough for proper adjustment. Avoid cutting so much shaft that support bearing cannot be used with thinner blades.
5. Re-install support bearing shaft in adjustment block and tighten set screw to secure.

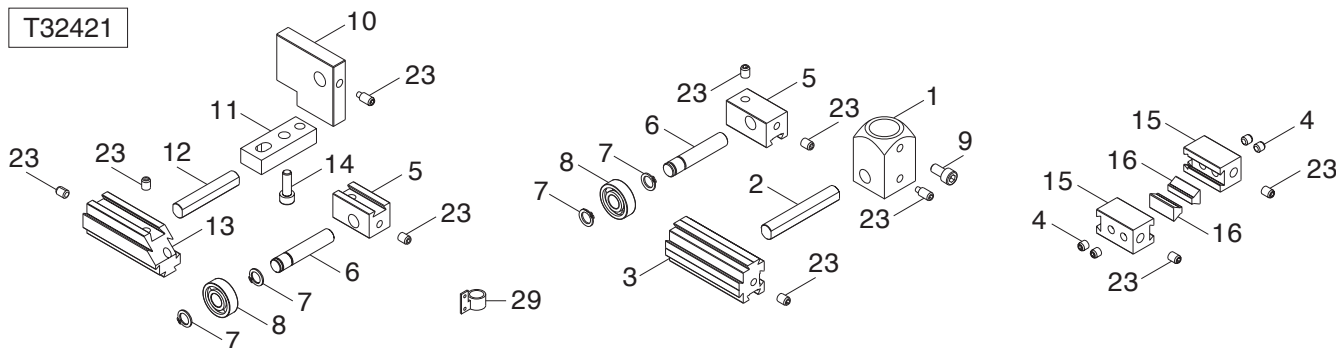


T32417/T32421/T32423 Parts Breakdown & List

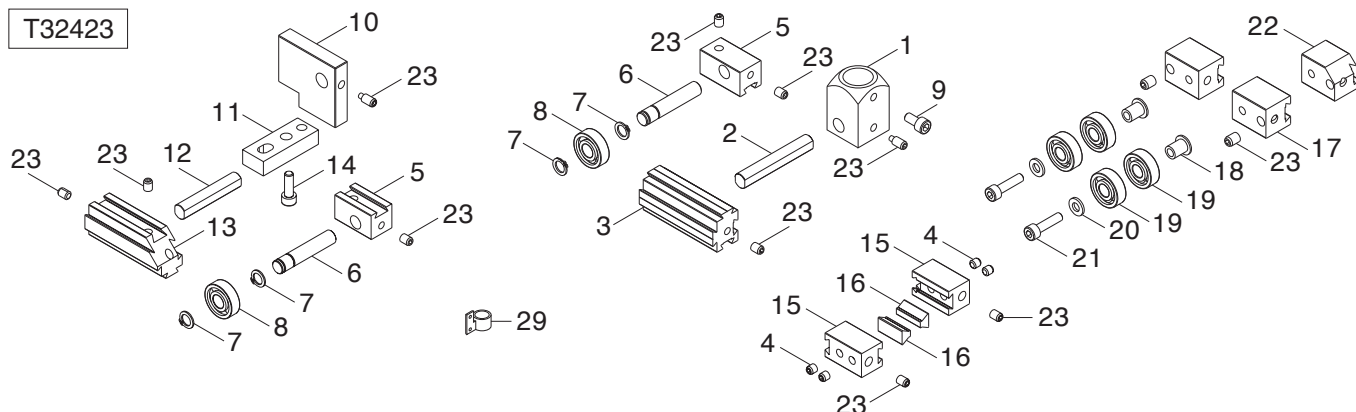
T32417



T32421



T32423



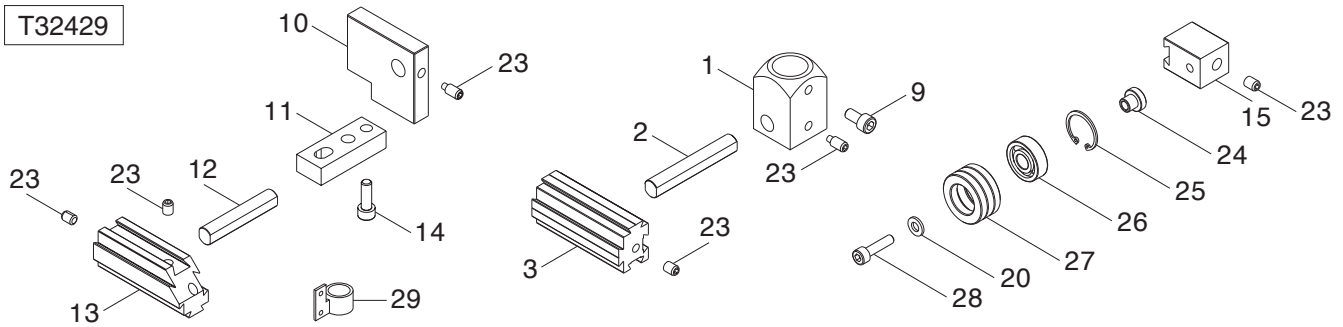
REF	PART #	DESCRIPTION
1	PT32417001	UPPER SUPPORT BLOCK
2	PT32417002	UPPER BLOCK SHAFT
3	PT32417003	UPPER DOVETAIL BLOCK
4	PT32421004	SET SCREW 1/4-20 X 1/4
5	PT32417005	SUPPORT BEARING BLOCK
6	PT32417006	SUPPORT BEARING SHAFT
7	PT32417007	EXT RETAINING RING 10MM
8	PT32417008	BALL BEARING 6000ZZ
9	PT32417009	CAP SCREW 1/4-20 X 1/2
10	PT32417010	LOWER SUPPORT BLOCK
11	PT32417011	LOWER MOUNT BLOCK
12	PT32417012	LOWER BLOCK SHAFT

REF	PART #	DESCRIPTION
13	PT32417013	LOWER DOVETAIL BLOCK
14	PT32417014	CAP SCREW 1/4-20 X 5/8
15	PT32421015	GUIDE BLOCK
16	PT32421016	CERAMIC GUIDE
17	PT32417017	GUIDE BLOCK
18	PT32417018	BUSHING
19	PT32417019	BALL BEARING 608ZZ
20	PT32417020	FLAT WASHER 5MM
21	PT32417021	CAP SCREW M5-.8 X 22
22	PT32417022	GUIDE BLOCK (CHAMFERED)
23	PT32417023	SET SCREW 1/4-20 X 1/2
29	PT32417029	BLADE GUARD BRACKET

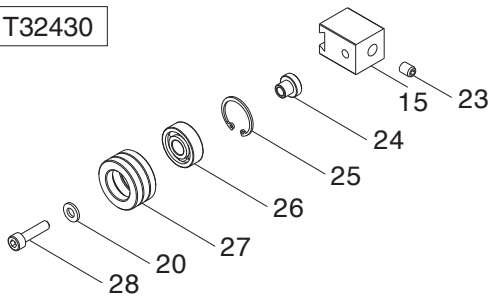


T32429/T32430 Parts Breakdown & List

T32429



T32430



REF	PART #	DESCRIPTION
1	PT32429001	UPPER SUPPORT BLOCK
2	PT32429002	UPPER BLOCK SHAFT
3	PT32429003	UPPER DOVETAIL BLOCK
9	PT32429009	CAP SCREW 1/4-20 X 1/2
10	PT32429010	LOWER SUPPORT BLOCK
11	PT32429011	LOWER MOUNT BLOCK
12	PT32429012	LOWER BLOCK SHAFT
13	PT32429013	LOWER DOVETAIL BLOCK
14	PT32429014	CAP SCREW 1/4-20 X 5/8

REF	PART #	DESCRIPTION
15	PT32429015	GUIDE BLOCK
20	PT32429020	FLAT WASHER 5MM
23	PT32429023	SET SCREW 1/4-20 X 1/2
24	PT32429024	BUSHING
25	PT32429025	INT RETAINING RING 22MM
26	PT32429026	BALL BEARING 608ZZ
27	PT32429027	SCROLLING WHEEL
28	PT32429028	CAP SCREW M5-.8 X 22
29	PT32429029	BLADE GUARD BRACKET

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 to check for availability.



WARRANTY & RETURNS

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

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

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

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

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

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

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.

