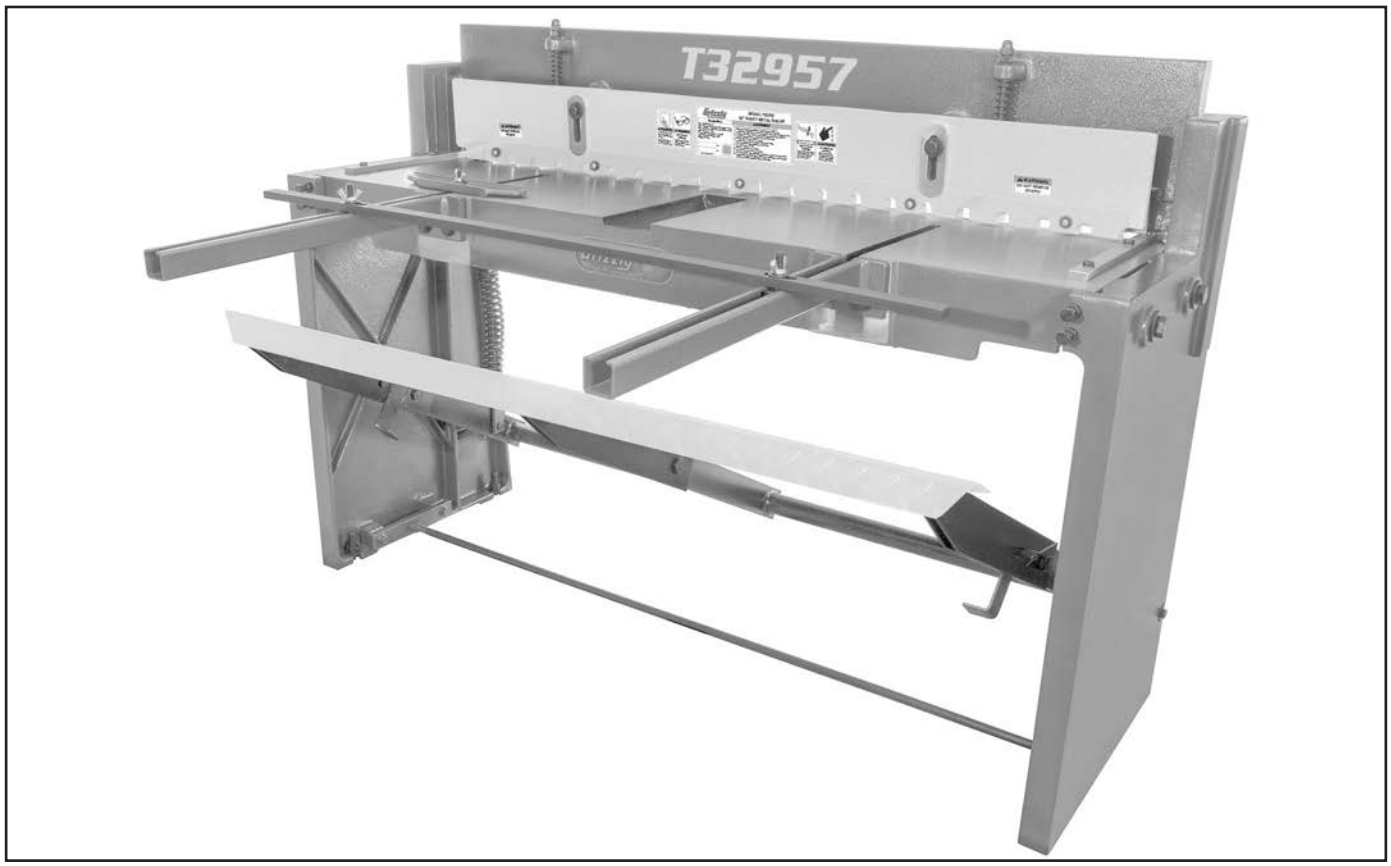
MODEL T32957
52" SHEET METAL SHEAR
OWNER'S MANUAL
(For models manufactured since 09/21)



#CS22037 PRINTED IN CHINA V1.01.25

******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.

Table of Contents

INTRODUCTION

Contact Info

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

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

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

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

⚠WARNING

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

⚠CAUTION

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

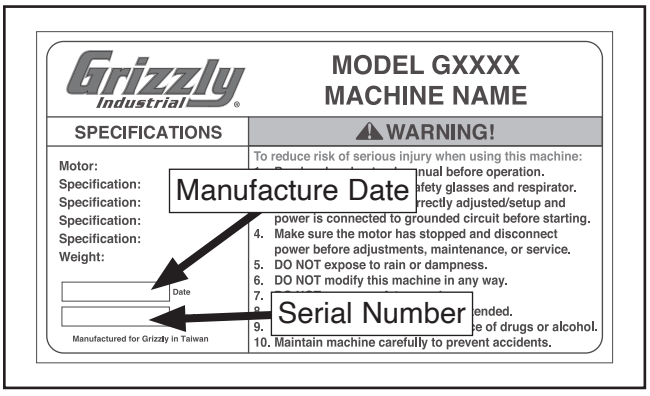
Manual Accuracy

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

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

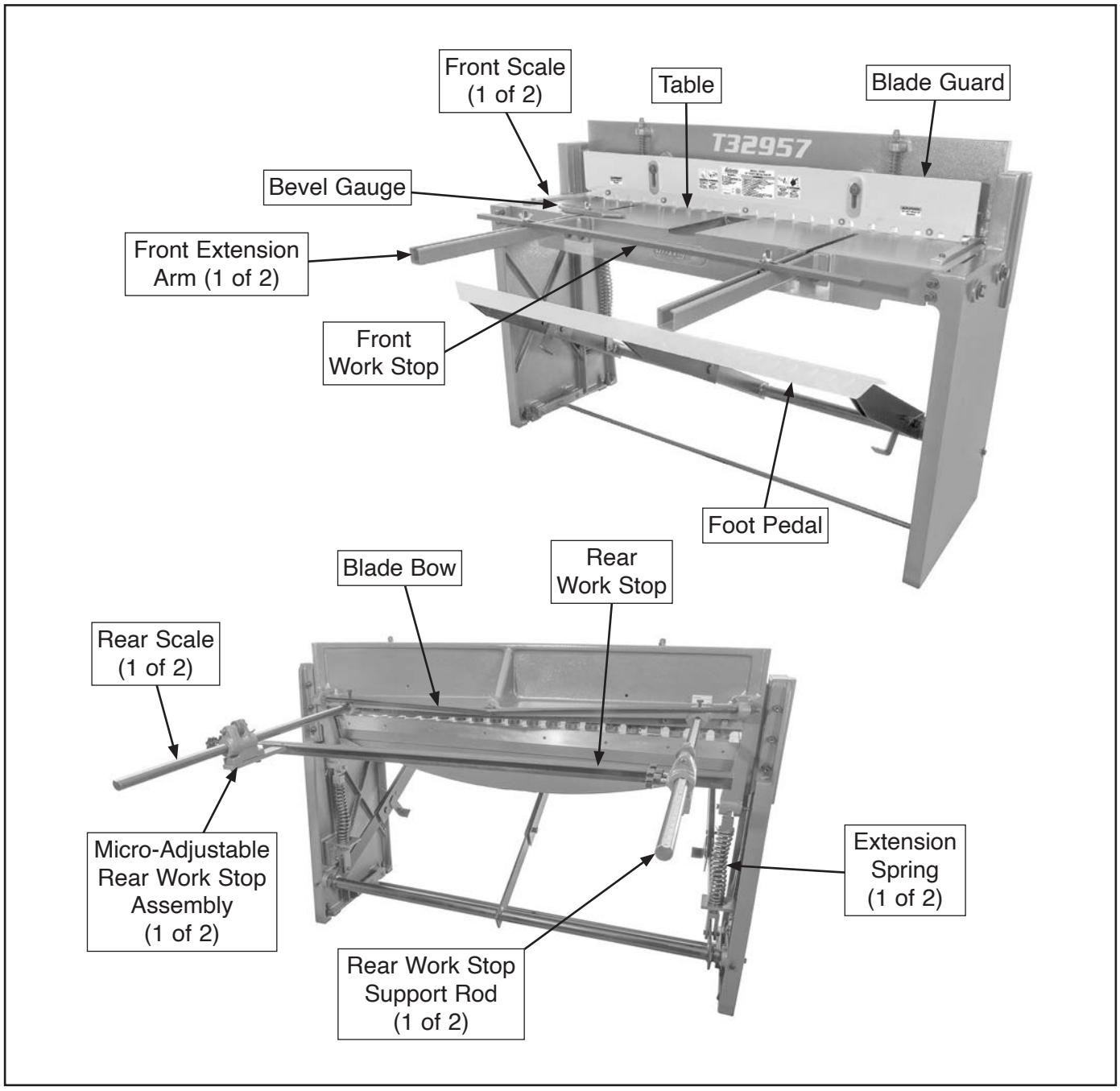
If you find this to be the case, and the difference between the manual and machine leaves you confused or unsure about something, check our website for an updated version. We post current manuals and manual updates for free on our website at **www.grizzly.com**.

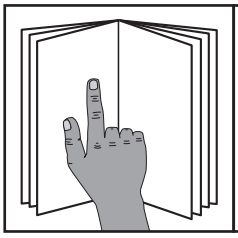
Alternatively, you can call our Technical Support for help. Before calling, make sure you write down the **manufacture date** and **serial number** from the machine ID label (see below). This information is required for us to provide proper tech support, and it helps us determine if updated documentation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



Identification

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





⚠WARNING

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

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.

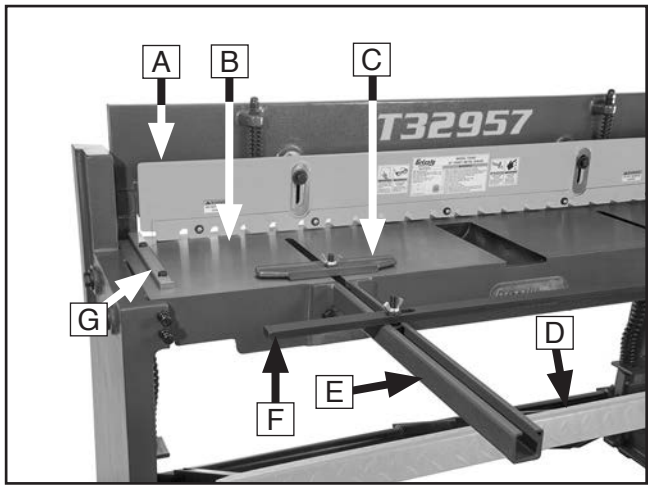


Figure 1. Infeed components and controls.

A. Hold-Down/Blade Guard: Holds down workpiece and protects user from blades during shearing operation.

B. Table: Supports infeed side of workpiece.

C. Bevel Gauge: Secures front edge of angled workpieces.

D. Foot Pedal: Controls cutting action of upper blade.

E. Front Extension Arm (1 of 2): Provides infeed support for large workpieces and extends front work stop and bevel track.

F. Front Work Stop: Adjusts on front extension arms and holds workpiece in place during shearing operation.

G. Front Scale (1 of 2): Indicates distance from cutting line; keeps workpiece square with blades.

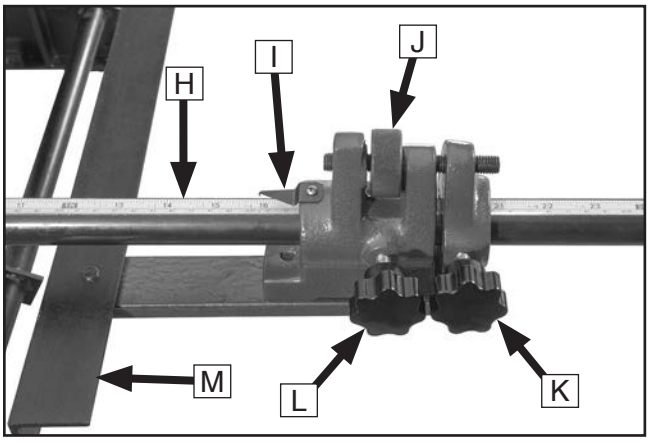


Figure 2. Outfeed components and controls.

H. Rear Work Stop Support Rod (1 of 2): Supports work stop and has scale for approximate positioning from 0–33".

I. Rear Work Stop Indicator: Indicates rear work stop position on scale.

J. Micro-Adjustment Knob (1 of 2): Fine-tunes rear work stop position.

K. Rear Work Stop Lock Knob (1 of 2): Loosen to adjust rear work stop position; tighten to secure.

L. Micro-Adjustment Lock Knob (1 of 2): Loosen to fine-tune rear work stop position; tighten to secure.

M. Rear Work Stop: Adjusts on rear work stop support rods to measure and support workpieces for repeatable cuts.

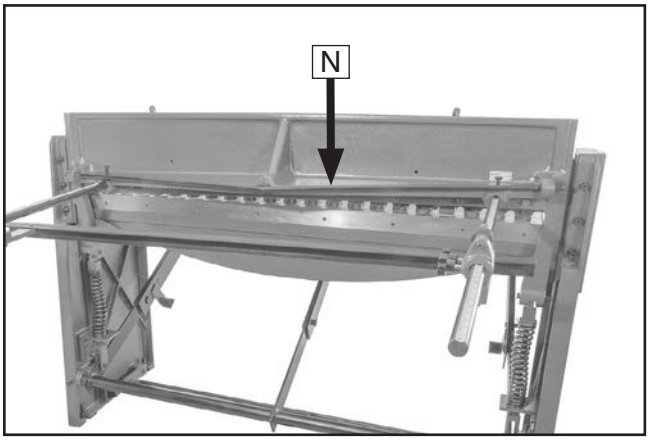


Figure 3. Location of blade bow.

N. Blade Bow: Adjusts to keep upper blade straight along its length.

MACHINE DATA SHEET

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

MODEL T32957 52" SHEET METAL SHEAR

Product Dimensions:

Weight	982 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	62 x 74 x 42 in.
Footprint (Length x Width)	60 x 21 in.

Shipping Dimensions:

Type	Wood Crate
Content	Machine
Weight	1120 lbs.
Length x Width x Height	67 x 30 x 46 in.
Must Ship Upright	Yes

Main Specifications:

Capacities

Maximum Width	52 in.
Maximum Thickness Mild Steel	18 Gauge
Maximum Thickness at Half Width Mild Steel	16 Gauge
Maximum Thickness at Full Width Mild Steel	18 Gauge
Aluminum	12 Gauge
Soft Brass	14 Gauge
Annealed Phosphor Bronze	17 Gauge
Soft Copper	14 Gauge
Hard Copper	14 Gauge
ABS Plastic	2.2 mm
Stainless Steel	20 Gauge
Maximum Beam Lift	1-3/4 in.
Bed Height Above Floor	42-1/8 in.
Working Height	31-1/4 in.
Front Stop Scale Range	0 - 12-1/2 in.
Rear Stop Scale Range	0 - 33 in.

Construction

Frame	Steel
Head and Tail Supports	Steel
Shear Table	Cast Iron
Shear Hold-Down Clamp	Cast Iron
Shear Blades	9CrSi Alloy Steel

Other Specifications:

Country of Origin	China
Warranty	1 Year
Approximate Assembly & Setup Time	30 Minutes
Serial Number Location	Machine ID Label

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Metal Shears

⚠WARNING

Serious cuts, amputation, or death can occur from contact with the shear blades during operation, adjustment, or maintenance. To reduce this risk, anyone using this machine MUST completely heed the hazards and warnings below.

FINGER AMPUTATION. The shear blades or hold-down can easily pinch, crush, or amputate fingers or other body parts. Always keep hands, fingers, and other body parts away from blades and hold-down (point-of-operation) during shearing operations.

CAPACITY. Exceeding cutting capacity of shear may result in breakage or machine damage that ejects dangerous metal debris at operator or bystanders. Only use sheet metal within the rated capacity of this shear (refer to the **Machine Data Sheet**).

BLADE CONDITION. Sharp, undamaged, and properly adjusted blades will reduce risk of injury from breakage or sharp burrs left on workpiece. Always keep blades properly adjusted and sharp.

SHEAR BLADE ADJUSTMENT. When adjusting or replacing shear blades, always wear heavy leather gloves to protect hands and wear safety glasses to protect eyes.

PROPER WORKPIECE MATERIAL. Shear is only intended for cutting ferrous and non-ferrous mild sheet metal or flat stock. Do not attempt to cut round metal stock, glass, wood, drywall, backer board, plywood, or other material not intended for this machine. Cutting incorrect materials can produce unexpected results, which increases risk of injury, and may result in damage to machine.

WORK AREA. Provide sufficient clearance around machine to permit safe use by regular operators and performance of maintenance procedures. Keep work area clear of materials or substances that may create a slip, trip, or fall hazard.

SHARP METAL EDGES. The sharp edges of sheet metal can easily cut fingers, hands, and other body parts. Always wear heavy leather gloves when handling sheet metal. Always chamfer and deburr sharp workpiece edges.

OPERATOR POSITION. Avoid awkward body and hand positions where a sudden slip could cause your hand or body to enter point-of-operation or make accidental contact with shear blades.

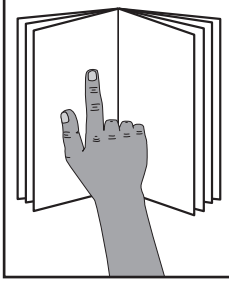
MAINTENANCE/SERVICE. Always wait for all moving parts to come to a complete stop before performing any adjustments, service, or maintenance. Do not contact foot pedal while performing these adjustments.

GUARDS. Keep all guards in place, properly positioned, and in working order. Never operate shear with blade guard removed. If blade guard is removed or not properly positioned, fingers may accidentally be cut or amputated by shear blades. Always position guard just high enough to allow workpiece to enter, but not high enough for fingers.

CHECK MACHINE. Before using machine, carefully check components for wear that could affect operation. Check blade alignment and gib play, and ensure guards are properly installed. DO NOT operate machine until all defects are corrected.

STRAY SHEET METAL PIECES. Sheet metal cut-off pieces left on the floor can easily slide under foot and cause falling injuries. Always remove cut-off sheet metal pieces from the floor after operation. Keep work area clean.

SECTION 2: SETUP

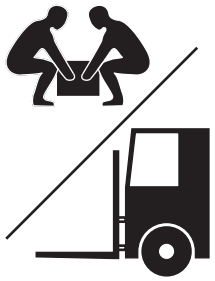


⚠WARNING

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

⚠WARNING

Wear safety glasses during the entire setup process!



⚠WARNING

HEAVY LIFT!

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

Needed for Setup

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

Description	Qty
• Safety Glasses (For Each Person)	1 Pair
• Disposable Rags	As Needed
• Disposable Gloves	As Needed
• Cleaner/Degreaser	As Needed
• Lifting Equipment (Rated for 1500 lbs.)	1
• Another Person	1
• Floor Mounting Hardware	As Needed
• Precision Level	As Needed
• Wrench or Socket 10, 12mm	1 Ea.
• Tape Measure	1

Unpacking

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

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

Inventory

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

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

Loosen Inventory (Figure 4)	Qty
A. Front Extension Arms	2
B. Rear Work Stop Support Rods	2
C. Front Work Stop	1
D. Rear Work Stop Assemblies	2
E. Rear Work Stop	1
F. Bevel Gauge	1

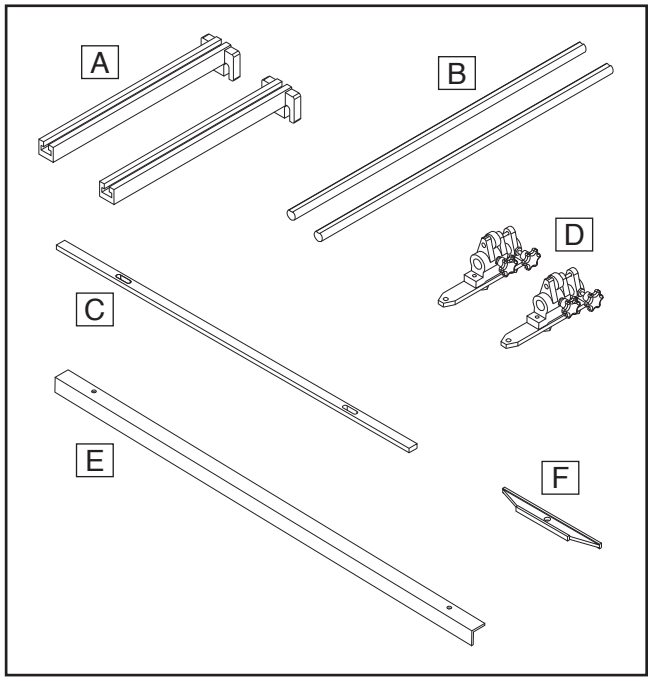


Figure 4. Loose inventory.

Fasteners (Figure 5)	Qty
G. T-Bolts M12-1.75 x 45	3
H. Hex Bolts M12-1.75 x 30	4
I. Hex Bolts M10-1.5 x 20	2
J. Flat Washers 12mm	7
K. Flat Washers 10mm	2
L. Wing Nuts M12-1.75	3
M. Cotter Pins M3 x 50	4
N. Clevis Pins 12 x 45mm	4
O. Clevis Pins 12 x 88mm	2

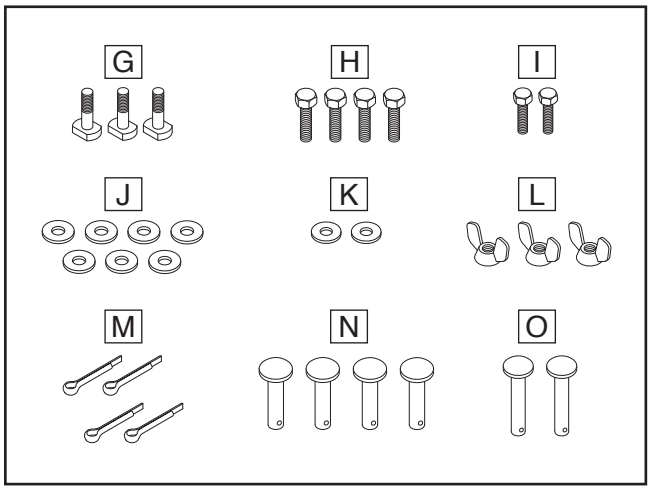


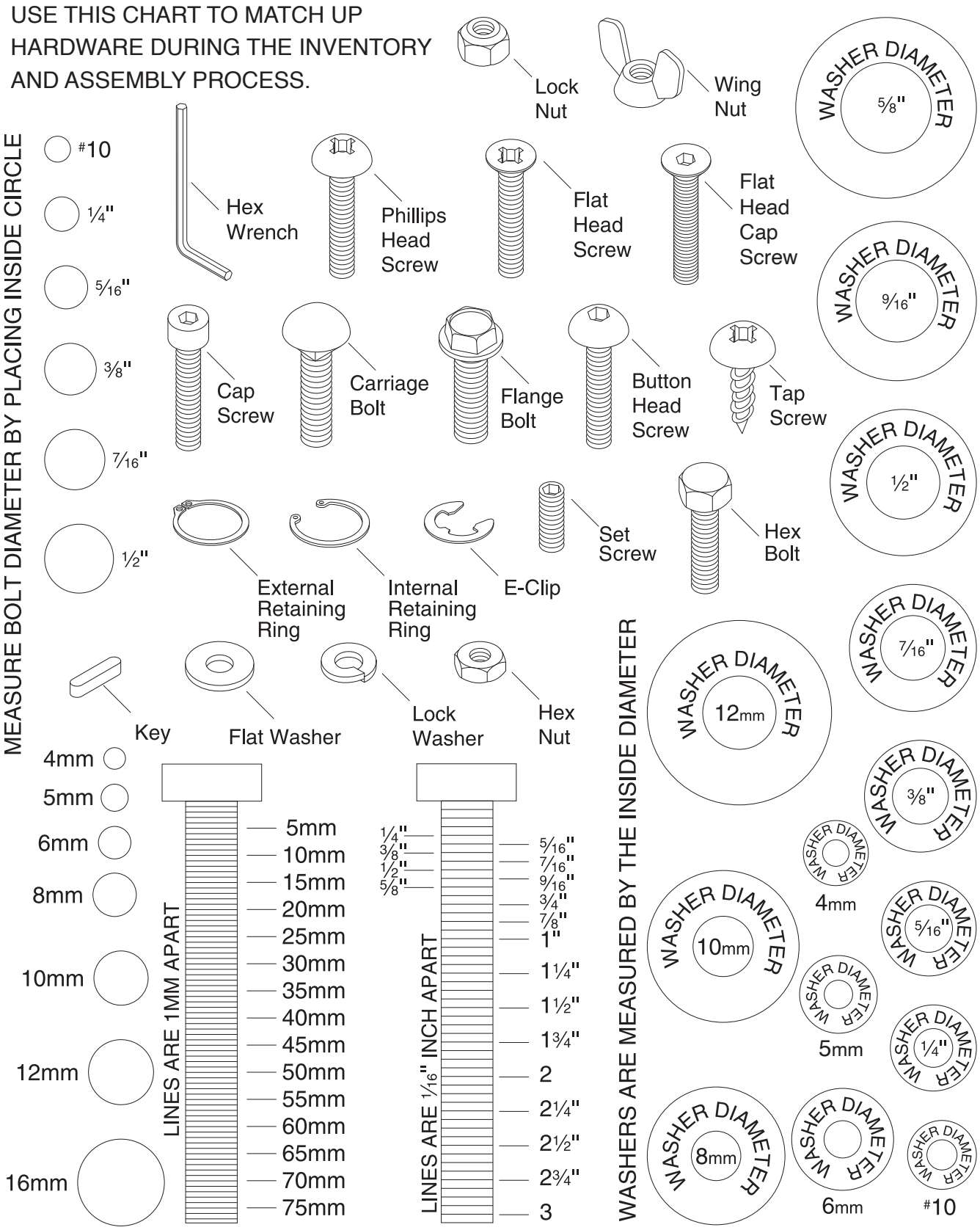
Figure 5. Fasteners.

Note: *Some of the clevis pins and cotter pins listed above have been provided to replace those pre-installed on the machine in the event they break due to wear.*

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.

Hardware Recognition Chart



Cleanup

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

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

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

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

Basic steps for removing rust preventative:

1. Put on safety glasses.

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

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

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

⚠WARNING

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

⚠CAUTION

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

NOTICE

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

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

Figure 6. T23692 Orange Power Degreaser.

Site Considerations

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of 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 is outside 41°–104°F; the relative humidity range is outside 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Space Allocation

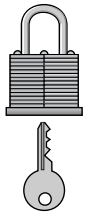
Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers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

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.

Lighting

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



⚠CAUTION

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

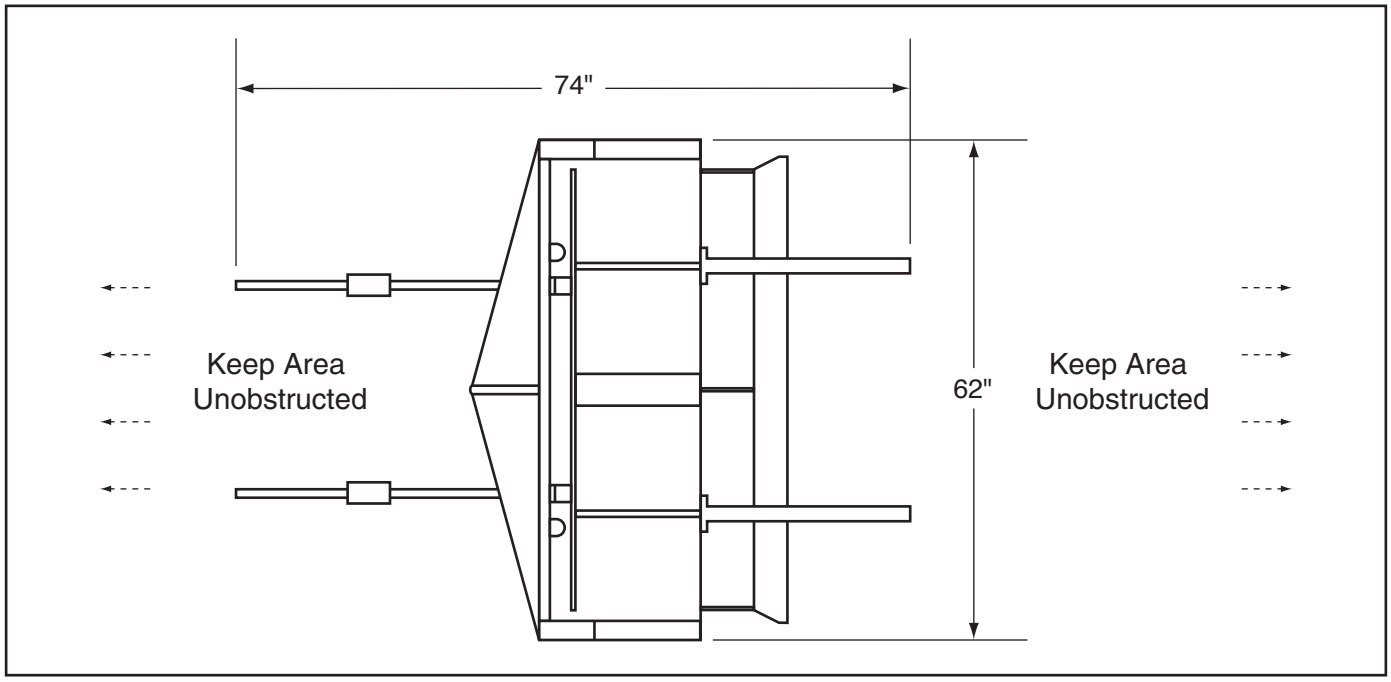
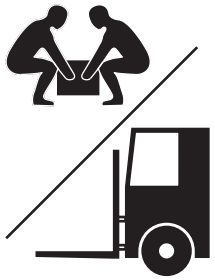


Figure 7. Minimum working clearances.

Lifting & Placing



⚠WARNING

HEAVY LIFT!

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

Use a forklift (or other type of lifting equipment) with lifting straps to move the machine to your desired location. All lifting equipment should be rated for at least 1500 pounds.

To lift & place machine:

1. Place shipping crate near installation location, then remove crate top and sides and set small items aside.

2. Unbolt machine from shipping pallet.

3. Place lifting straps under shear table at locations shown in **Figure 8**. Straps should be spread as wide as possible.

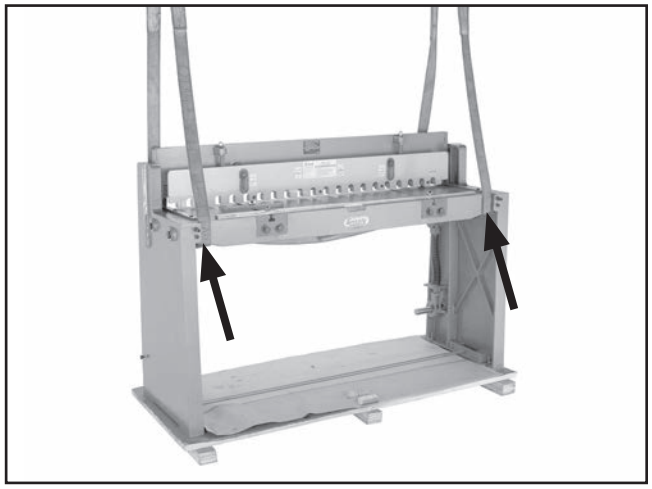


Figure 8. Example of lifting straps placed under shear table for lifting.

4. With help of another person to steady load, use forklift or crane to lift machine from pallet and move to desired location.

Anchoring to Floor

Number of Mounting Holes 4
Diameter of Mounting Hardware..... 5/8"

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

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

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

Anchoring to Concrete Floors

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

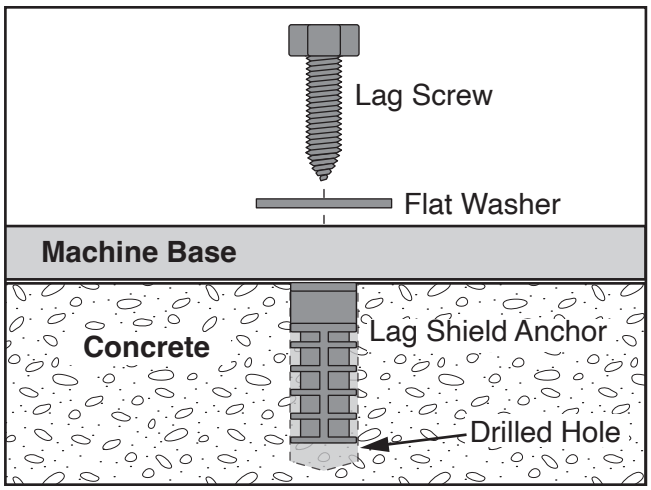


Figure 9. Popular method for anchoring machinery to a concrete floor.

Assembly

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

To assemble machine:

1. Use level to check shear table.

— If table *is* level, no adjustment is required. Proceed to **Step 2**.

— If table *is not* level, use shims between floor and base to level machine before proceeding. Leveling shear helps blades and other components remain straight and flat during life of machine so machine can continue to cut straight and square.

2. Cut cable ties securing foot pedal to table.

3. Have another person press and hold foot pedal about halfway through full range of movement.

4. Insert (2) 12 x 45mm clevis pins in holes in foot pedal frame and secure with (2) M3 x 50 cotter pins, as shown in **Figure 10**.

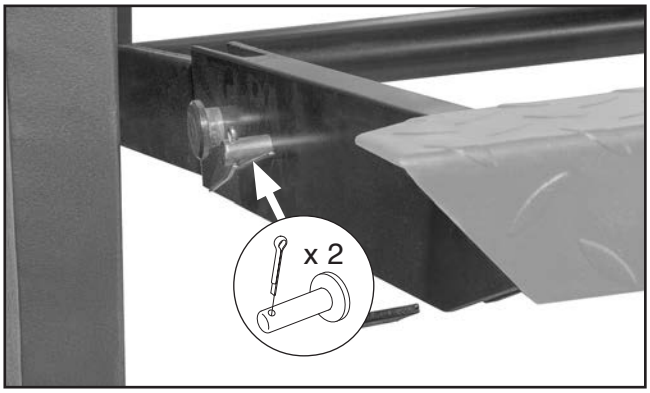


Figure 10. Location of hole in foot pedal frame (1 of 2 shown).

5. Attach (2) front extension arms to shear table with (4) M12-1.75 x 30 hex bolts and 12mm flat washers (see **Figure 11**).

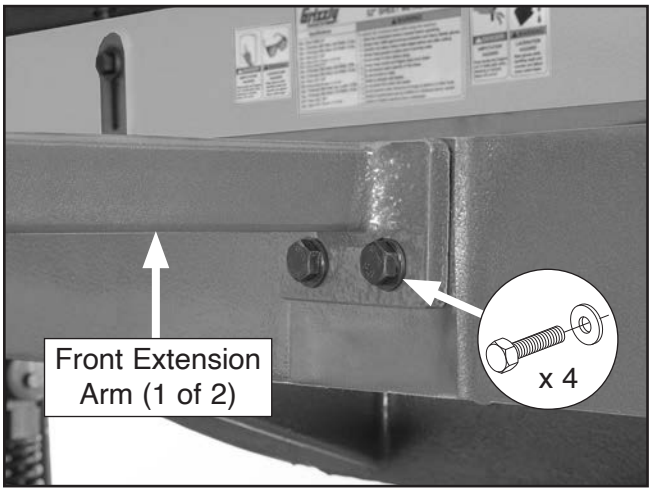


Figure 11. Front extension arms attached.

Note: *Arm T-slots must line up with table T-slots, and surfaces must be flush (see **Figure 12**).*

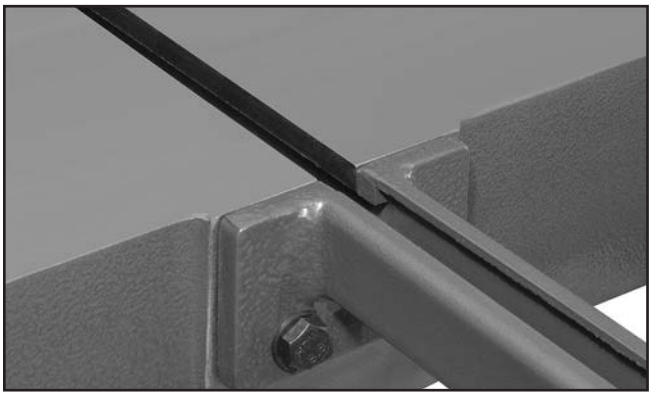


Figure 12. Extension arm T-slot lined up with table and flush with table surface.

6. Install (1) M12-1.75 x 45 T-bolt in each T-slot and secure front work stop to extension arms using (2) 12mm flat washers and M12-1.75 wing nuts (see **Figure 13**).

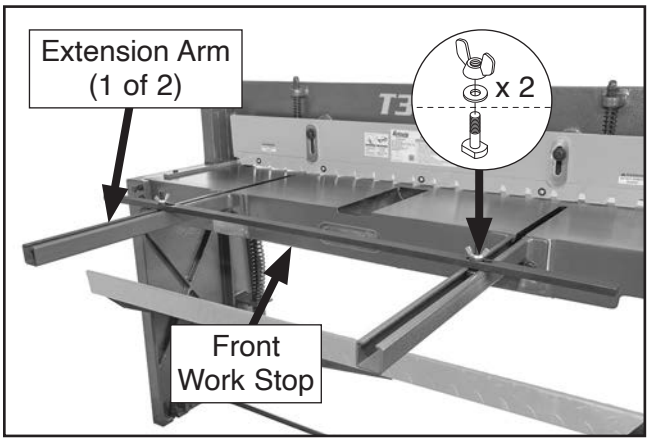


Figure 13. Front work stop secured to extension arms.

7. Insert (2) rear work stop support rods in holes shown in **Figure 14**.

8. Secure rear work stop supprt rods in place by tightening pre-installed hex bolts (see **Figure 14**).

   Note: *Rear work stop support rods should extend same distance from back of machine. If one rod extends farther than the other, adjust hex bolts and rods until even.*

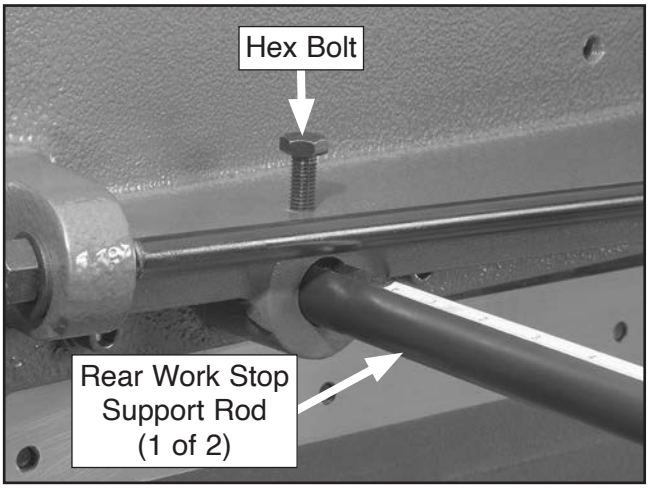


Figure 14. Rear work stop support rods installed on machine.

9. Install (2) rear work stop assemblies on rear work stop support rods and tighten each micro-adjustment knob completely to eliminate space shown in **Figure 15**.

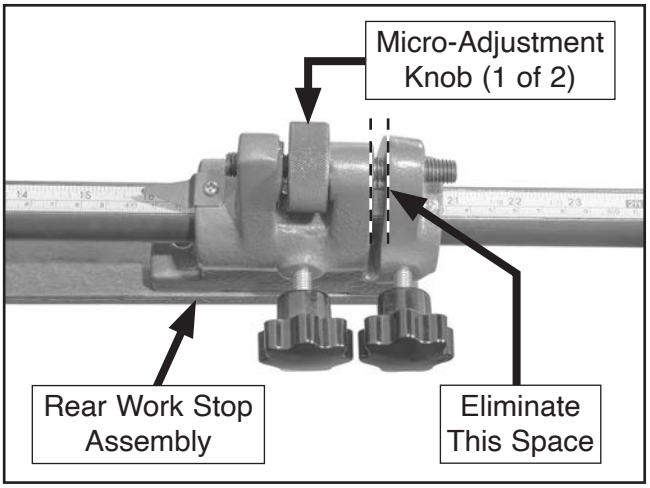


Figure 15. Rear work stop assembly installed on rear work stop support rod.

10. Align each work stop indicator to the same number on rod scales, then tighten micro-adjustment lock knobs and rear work stop lock knobs (see **Figure 16**).

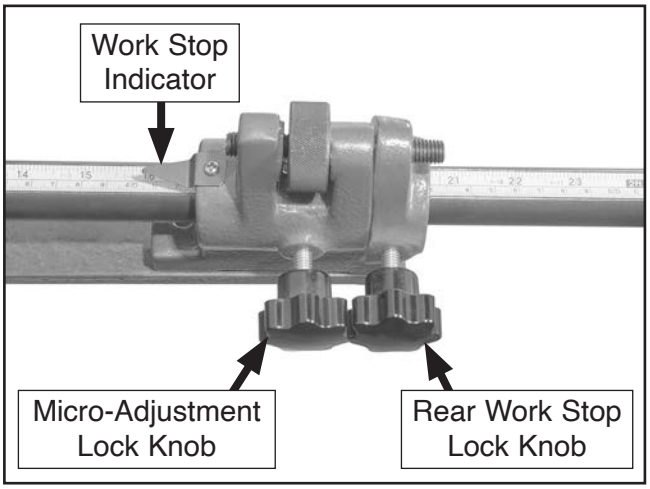


Figure 16. Rear work stop assembly components.

11. Attach rear work stop to rear work stop assemblies with (2) M10-1.5 x 20 hex bolts and 10mm flat washers, as shown in **Figure 17**.

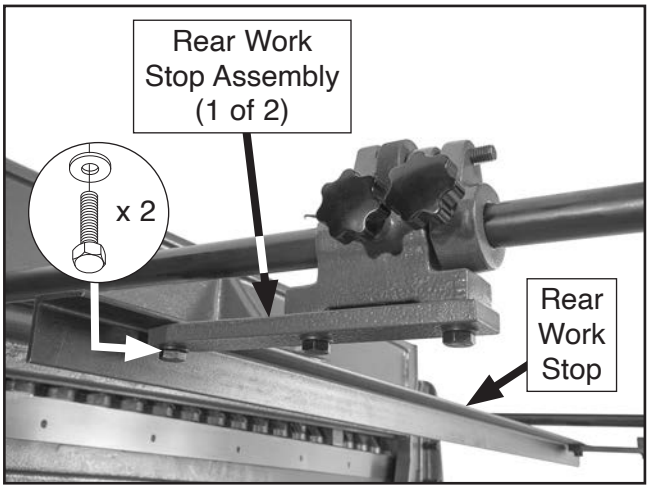


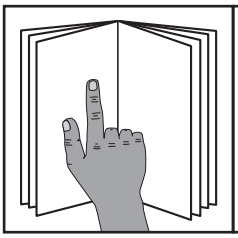
Figure 17. Rear work stop attached to rear work stop assembly.

SECTION 3: 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.

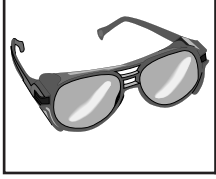


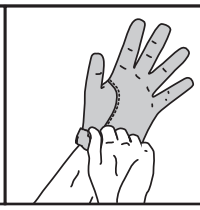
⚠WARNING

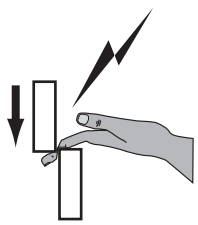
To reduce your risk of serious injury, read this entire manual BEFORE using machine.

⚠WARNING

Bodily injury could result from using this machine. Always wear safety glasses, leather work boots, and heavy duty leather work gloves when operating this machine or whenever handling sheet metal.







⚠WARNING

Shear blades or hold-down blade guard can easily pinch, crush, or amputate fingers or other body parts. Always keep body parts away from blades and hold-down during operation.

NOTICE

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

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

1. Examines workpiece to make sure it is within capacities of machine.
2. Adjusts rear work stop for length of cut.
3. Puts on safety glasses, leather boots, and leather gloves.
4. Places workpiece on front extension arms.
5. Slides workpiece under blade guard and upper blade, and up against rear work stop.
6. Adjusts front work stop (or bevel gauge, if angled workpiece) against workpiece to keep shearing force from pushing workpiece forward.
7. With balanced and stable body position, firmly presses down on foot pedal to make cut.
8. Raises foot pedal and either removes workpiece or repeats **Steps 5–7** to make additional cuts.

Cutting Tips

- Never attempt to cut any workpiece narrower than ½". The workpiece must be long enough to be engaged by the hold-down/blade guard.
- Keep the upper blade properly adjusted to the lower blade (refer to **Adjusting Blade Gap** on **Page 26** for detailed instructions). This will help ensure good cutting results and avoid blade damage.
- Before each operation, clean cut-offs or debris away from the shear.
- Use the foot pedal to engage the hold-down/blade guard with the workpiece, then pause to check the workpiece position. If workpiece position is correct, continue lowering the foot pedal to complete the cut.
- The shearing action of the blades works similarly to a pair of scissors (see illustration in **Figure 18**). Use even pressure on the foot pedal throughout entire cut to produce a straight, even cut.

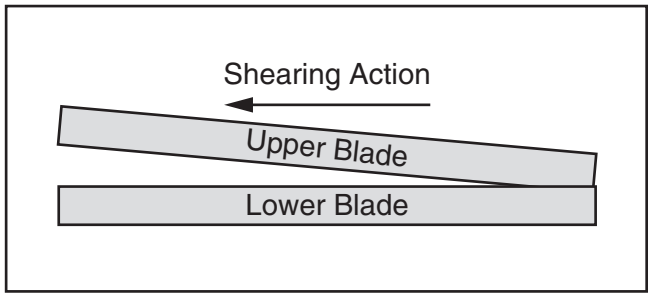


Figure 18. Blade shearing action.

Adjusting Rear Work Stop

The rear work stop is used for making repetitive cuts of the same length. The micro-adjustment assemblies allow for precise positioning of the work stop.

To adjust rear work stop:

1. Loosen (2) rear work stop lock knobs and (2) micro-adjustment lock knobs (see **Figure 19**).

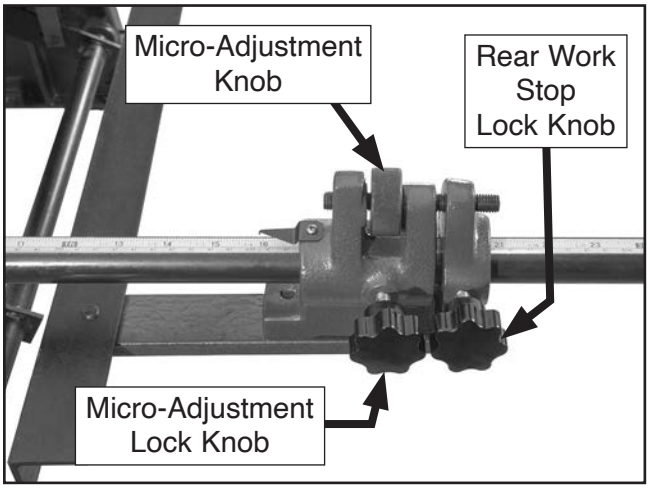


Figure 19. Location of rear stop work lock knob and micro-adjustment lock knob.

2. Slide rear work stop evenly along rear work stop support rods so work stop leading edge is at approximate desired distance from cutting edges of blades.

Note: *Use scales on top of support rods for approximate positioning. Use fine ruler or tape measure for more precise positioning*.

3. Tighten (2) rear work stop lock knobs.

4. Use micro-adjustment knob on each assembly to adjust work stop in small, precise amounts until they are exactly where needed (see **Figure 19**).

Note: *Move work stop evenly on both sides to keep it parallel with blades.*

5. Tighten micro-adjustment lock knobs to secure rear work stop position.

Adjusting Front Work Stop

The front work stop keeps the shearing blades from pushing the workpiece forward during cutting operations. Use the following steps to adjust the front work stop to the front workpiece edge once the workpiece has been inserted under the blade guard and is ready to be sheared.

To adjust front work stop:

1. Loosen (2) front work stop wing nuts (see **Figure 20**).

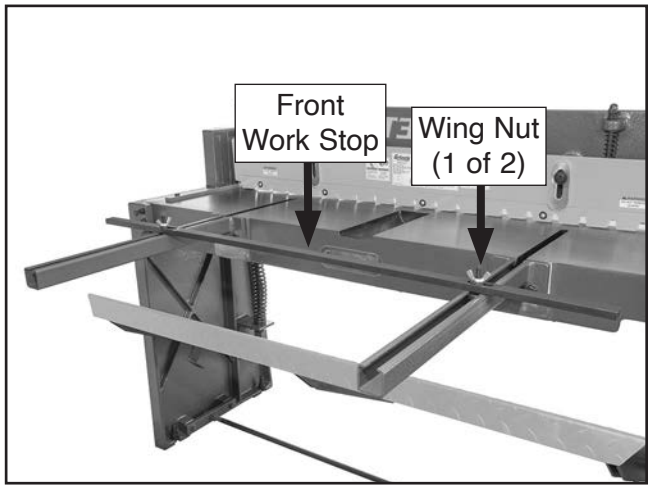


Figure 20. Location of front work stop wing nuts.

2. Adjust front work stop against front workpiece edge and tighten wing nuts to secure.

Using Bevel Gauge

The bevel gauge can be installed in place of the front work stop to support workpieces that have an angled front edge.

To use bevel gauge:

1. Loosen (2) front work stop wing nuts (see **Figure 21**).

2. Slide front work stop out of front extension arms to remove (see **Figure 21**).

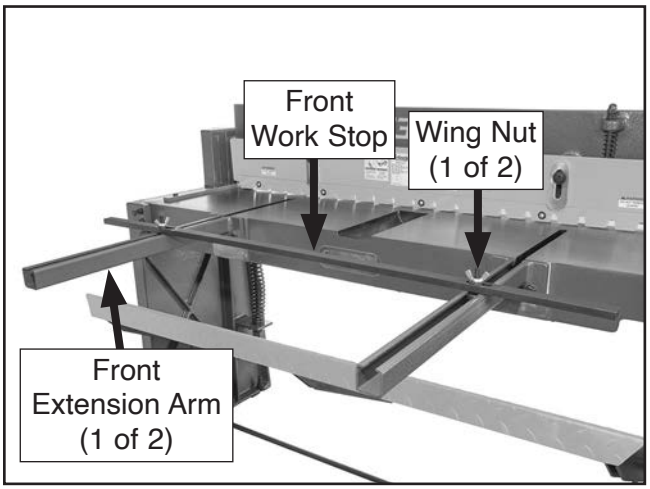


Figure 21. Front work stop components.

3. Position workpiece on table and under blade guard for shearing operation.

4. Install (1) M12-1.75 x 45 T-bolt in T-slot and secure bevel gauge to extension arm or table against workpiece front edge with (1) T-bolt, 12mm flat washer, and M12-1.75 wing nut (see **Figure 22**).

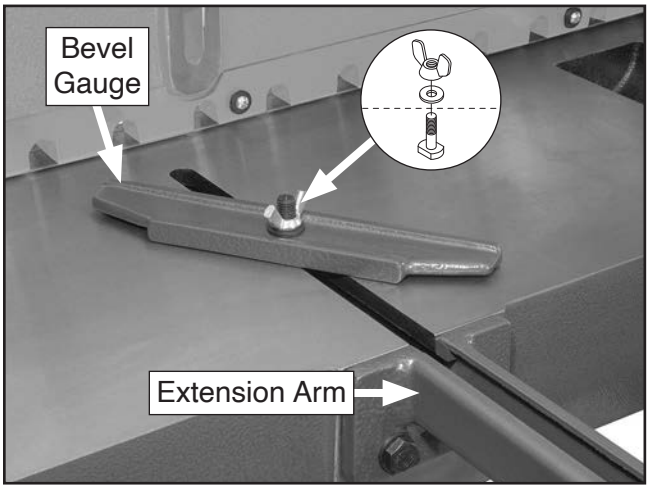


Figure 22. Bevel gauge installed to support angled front workpiece edge.

Note: ***Figure 22*** *shows bevel gauge installed in left T-slot, but it can be installed in either side. Install the bevel gauge in the best position to secure your workpiece for the operation.*

SECTION 4: 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.

Recommended Metal Protectants

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 11 Oz. Spray

Figure 23. Recommended products for protecting unpainted cast iron/steel part on machinery.

D3042—Double Suction Cup
Handle plate glass, glass mirrors, and sheet metal with safety and security. Cam-action levers make placement and removal quick and easy.

Figure 24. Model D3042 Double Suction Cup.

H5614—Sheet Metal Gauge US Standard
Calibrated for sheet metal sized from 0 to 30 gauge. The front is marked with gauge sizes, the back is marked with actual inch measurements.

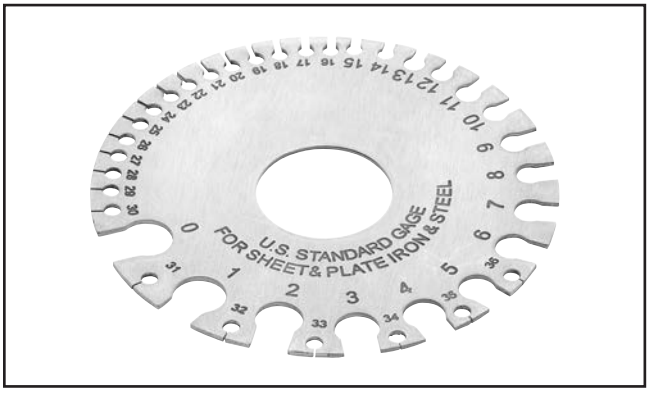


Figure 25. H5614 Sheet Metal Gauge.

H5503— ½ HP Electric Sheet Metal Shear
This electric sheet metal shear features a ½ HP, 110V, 2500 RPM, 3.8 amp motor with a 360 degree adjustable swivel head and variable speed range from 0 to 2500 SPM. Cuts up to 14 gauge in mild steel and 18 gauge in stainless, at up to 150 inches per minute.

Figure 26. Model H5503 ½ HP Electric Sheet Metal Shear.

T26685—ISO 32 Moly-D Machine Oil, 1 Gal.
T23963—ISO 32 Moly-D Machine Oil, 5 Gal.
Moly-D oils are some of the best we've found for maintaining the critical components of machinery because they tend to resist run-off and maintain their lubricity under a variety of conditions. Buy in bulk and save with 5-gallon quantities.

Figure 27. ISO 32 machine oil.

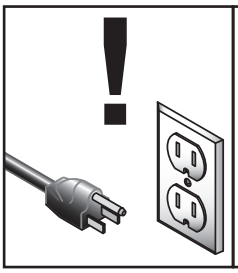
SB1365—South Bend Way Oil-ISO 68
Engineered for the high pressure exerted on horizontal or vertical ways and slides. Protects against rust and corrosion. Ensures stick-free, smooth motion which maximizes finishes and extends the life of your machine. Won't gum up! 12 oz. AMGA#2 (ISO 68 Equivalent)

Figure 28. SB1365 Way Oil.

T27430— 6" Plate Shear
This bench-mounted shear is designed to cut flat (sheet/plate) stock and round (bar) stock of ferrous and non-ferrous metals, and even plastics. It features ground-and-hardened replaceable blades, an extra-long leverage-maximizing handle, and a spring-assisted material hold-down.

Figure 29. T27430 6" Plate Shear.

SECTION 5: MAINTENANCE



⚠WARNING

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

Schedule

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

Ongoing

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

- Loose mounting bolts.
- Loose or damaged blade guard.
- Worn or damaged blades.
- Loose or bent rear work stop support rods.
- Any other unsafe condition.

Daily Maintenance

- Clean and protect blades and bare cast iron surfaces.
- Lubricate pivot pins.

Cleaning & Protecting

Cleaning the Model T32957 is relatively easy. Use a brush to clear away any metal debris from the blades, the blade guard, and the table.

Keep the table and exposed portions of the blades rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Page 20** for more details).

Lubrication

There are a number of parts on this machine that undergo a lot of movement and must remain lubricated for smooth operation and long life.

Pivot Pins

Oil Type .....T26685 or ISO 32 Equivalent
Oil Amount..... 1 or 2 Drops
Lubrication Frequency..... Daily

Items Needed	Qty
Wire Brush	1
Shop Rags	As Needed
T26685 or ISO 32 Equivalent	As Needed

Use a wire brush to clean any built-up grease from pivot pins (see **Figure 30**) before applying a few drops of lubricant to the exposed portions of all four pivot pins. Keep your hands and fingers away from shearing area and press down on the foot pedal a few times to distribute the lubricant.

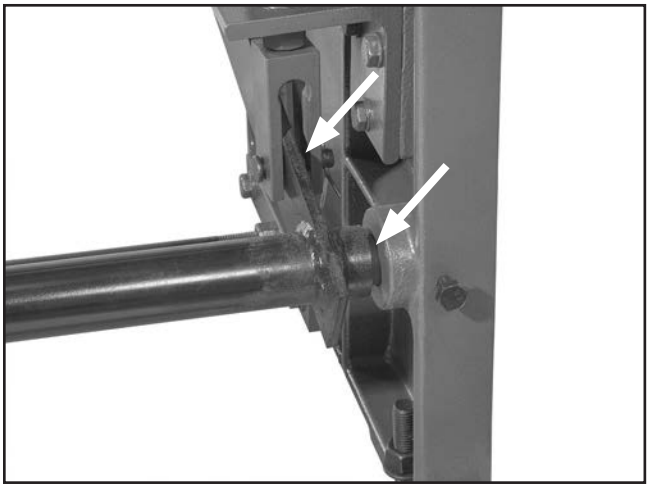


Figure 30. Location of pivot pins (2 of 4 shown).

Shearing Blades

Oil Type ..... SB1365 or ISO 68 Equivalent
Oil Amount..... 1 or 2 Drops
Lubrication Frequency .....Weekly

Items Needed	Qty
Protective Gloves	1 Pr.
Shop Rags	As Needed
Mineral Spirits	As Needed
SB1365 or ISO 68 Equivalent	As Needed

While wearing protective gloves, use a rag and mineral spirits to clean away grease and built-up grime from the surfaces of the shearing blades (**Figure 31**). Once the blades are dry, apply oil to the surfaces with a clean rag.

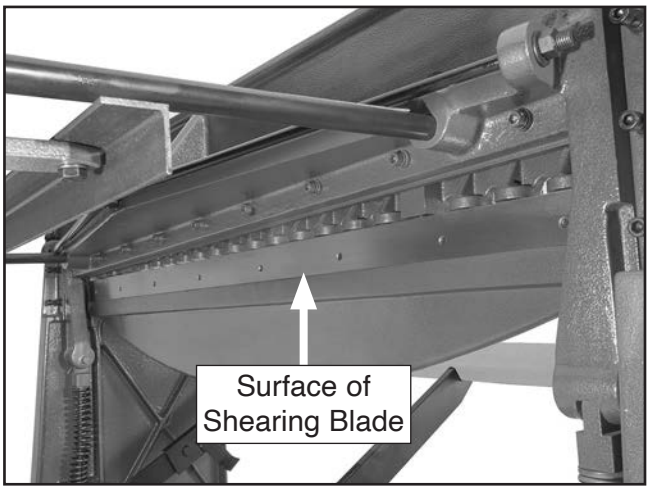


Figure 31. Location of lower shearing blade surface.

Gibs & Slides

Oil Type ..... SB1365 or ISO 68 Equivalent
Oil Amount..... 1 or 2 Drops
Lubrication Frequency .....Weekly

Items Needed	Qty
SB1365 or ISO 68 Equivalent	As Needed

Apply a few drops of oil at each gib (see **Figure 32**) weekly to keep the upper blade and hold-down/blade guard moving smoothly.

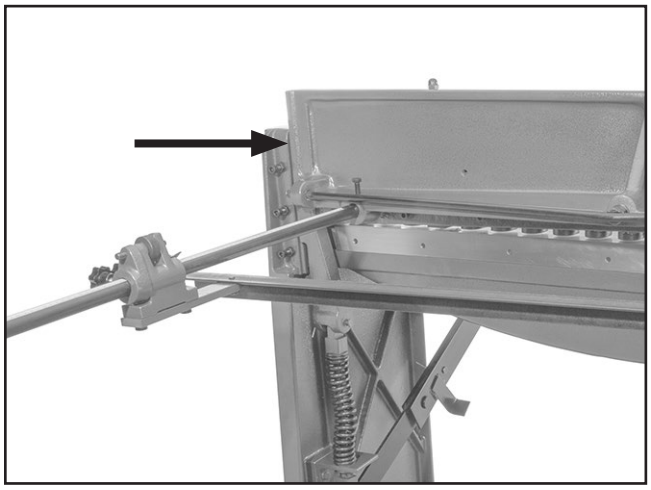


Figure 32. Gib and slide lubrication point.

Rear Work Stop Assemblies

Oil Type ..... SB1365 or ISO 68 Equivalent
Oil Amount..... 1 or 2 Drops
Lubrication Frequency ..... As Needed

Items Needed	Qty
Shop Rags	As Needed
Mineral Spirits	As Needed
SB1365 or ISO 68 Equivalent	As Needed

The rear work stop assemblies must slide smoothly in order to achieve accurate measurements when shearing. Clean the rear work stop support rods with mineral spirits when you have any trouble adjusting the rear work stop position. Apply a few drops of oil to the locations shown in **Figure 33** on each assembly.

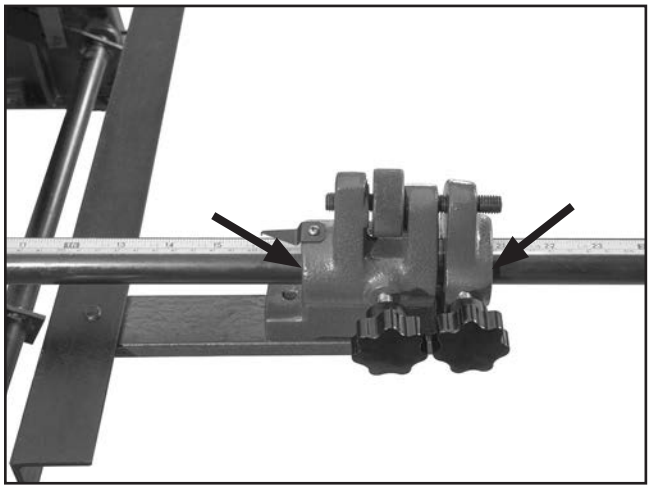


Figure 33. Rear work stop assembly lubrication locations.

SECTION 6: 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

Operations

Symptom	Possible Cause	Possible Solution
Shear will not cut workpiece.	1. Workpiece thickness exceeds shear capacity. 2. Not enough pressure applied to foot pedal. 3. Blades worn or damaged. 4. Blade gap not correct. 5. Hold-down/blade guard is not adjusted correctly.	1. Only use workpiece material that is within shear capacity (**Page 5**). 2. Safely increase pressure on foot pedal. 3. Sharpen/replace blades (**Page 25**). 4. Properly adjust blade gap (**Page 26**). 5. Properly adjust hold-down/blade guard (**Page 28**).
Cuts are not square.	1. Rear work stop not parallel with blades. 2. Blade gap not correct. 3. Blade bow is not correct. 4. Hold-down/blade guard is not adjusted correctly.	1. Properly adjust rear work stop parallel with blades (**Page 18**). 2. Properly adjust blade gap (**Page 26**). 3. Properly adjust blade bow (**Page 27**). 4. Properly adjust hold-down/blade guard (**Page 28**).
Poor quality of cuts (ripping or tearing).	1. Blade gap not correct. 2. Blades worn or damaged. 3. Hold-down/blade guard is not adjusted correctly. 4. Gibs too loose.	1. Properly adjust blade gap (**Page 26**). 2. Sharpen/replace blades (**Page 25**). 3. Properly adjust hold-down/blade guard (**Page 28**). 4. Tighten gib screws (**Page 28**).
Foot pedal difficult to use.	1. Blade gap not correct. 2. Pivot pins need lubrication. 3. Gibs too tight.	1. Properly adjust blade gap (**Page 26**). 2. Lubricate pivot pins (**Page 22**). 3. Loosen gib screws (**Page 28**).

Sharpening/ Replacing Blade

The upper blade of the Model T32957 has two cutting edges so that if one cutting edge becomes dull, you can reverse the blade and use the fresh, sharp cutting edge.

If both of the upper blade cutting edges are dull, or the cutting edge of the lower blade is dull, sharpen the blade(s) on a surface grinder and make sure the blade is flat along the entire length. Re-sharpen each blade edge as needed until it is too thin to safely install (as described in the steps below), then replace the blade. We recommend you keep an extra set of blades on hand to avoid any downtime.

Items Needed	**Qty**
Another Person	1
Protective Gloves (for Each Person)	1 Pr.
Hex Wrench 8mm	1
Surface Grinder	1
Mineral Spirits	As Needed
Shop Rags	As Needed
Metal Protectant	As Needed
New Upper Blade (#PT32957024)	As Needed
New Lower Blade (#PT32957025)	As Needed

⚠WARNING

Shear blades are sharp. Wear protective gloves when handling blades to prevent laceration injuries.

To sharpen/replace blade:

1. Have another person support blade while you remove (8) cap screws and flat washers to remove blade (see **Figures 34–35**).

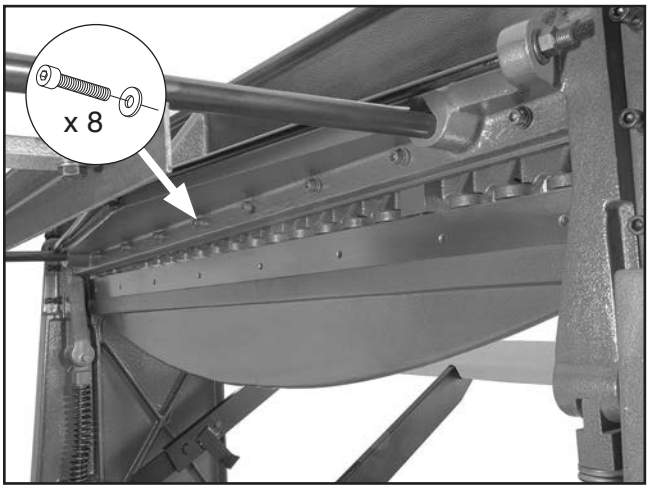


Figure 34. Upper blade cap screws and flat washers.

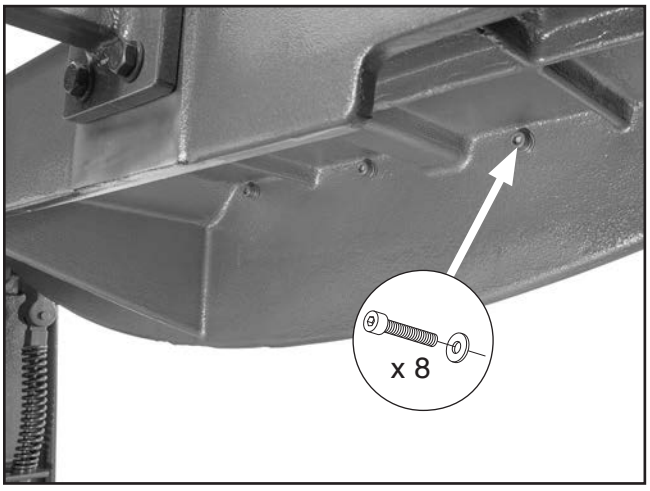


Figure 35. Lower blade cap screws and flat washers.

2. Reverse blade (upper blade only) or sharpen on surface grinder.

3. Clean blade with mineral spirits, then apply thin coat of quality metal protectant.

4. Install blade using hardware removed in **Step 1**.

— If blade is so thin after sharpening that securing cap screws extend beyond opposite side of cutting edge, replace blade.

Adjusting Blade Gap

The gap between the upper and lower blades (as they pass each other) must remain even along the length of the blades to produce clean cuts. Initially, this adjustment has been made at the factory. However, over time and with normal wear, you may need to adjust the blade gap.

If the blade gap is too wide, the workpiece will not cut correctly and show signs of bending, ripping, or tearing. If the blade gap is too narrow, the upper blade will bind when lowering past the lower blade and the cutting edges may become damaged.

Items Needed	**Qty**
Scrap Paper	As Needed
Wrench or Socket 24mm	1
Open-End Wrenches 17mm	2
Feeler Gauge 0.002"	1

To adjust blade gap:

1. Make cuts on piece of paper along full length of shear blades.

- — If paper cuts cleanly on full length of shear blades, blade gap requires no adjustment.
- — If paper does not cut cleanly only on one end of shear, lower blade needs to be adjusted on that end. Proceed to **Step 2**.
- — If paper does not cut cleanly along the entire length of blades, both ends of lower blade need to be adjusted. Proceed to **Step 2**.
- — If paper cuts cleanly on ends but not center of blades, or it cuts cleanly in center but not ends, blade bow needs to be adjusted (refer to **Adjusting Blade Bow** on **Page 27** for detailed instructions).

2. Loosen (2) table bolts, (2) table adjustment bolts, and (2) jam nuts on side of shear that needs adjustment (see **Figure 36**).

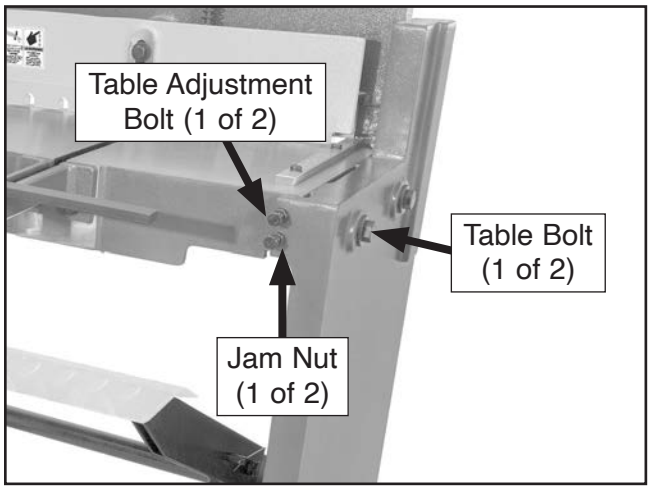


Figure 36. Location of blade gap adjustment components.

3. Use foot pedal to lower and hold upper blade in lowest position.

4. Insert feeler gauge between blades on side that needs adjustment, then turn table adjustment bolts to move table and lower blade until lower blade makes light contact with feeler gauge against upper blade.

5. Tighten (2) jam nuts and (2) table bolts to secure blade gap adjustment.

6. Repeat **Step 1** to check adjustment.

- — If paper still does not cut cleanly, but blade gap adjustment is correct, blade(s) may need to be sharpened (refer to **Sharpening/Replacing Blade** on **Page 25** for detailed instructions).

Adjusting Blade Bow

The blade bow is used to keep the upper blade straight along its full length by adjusting the amount of force that the bow exerts on the blade ends.

The blade bow is adjusted by adjusting the bow jam nut on the centering rod (see **Figure 37**).

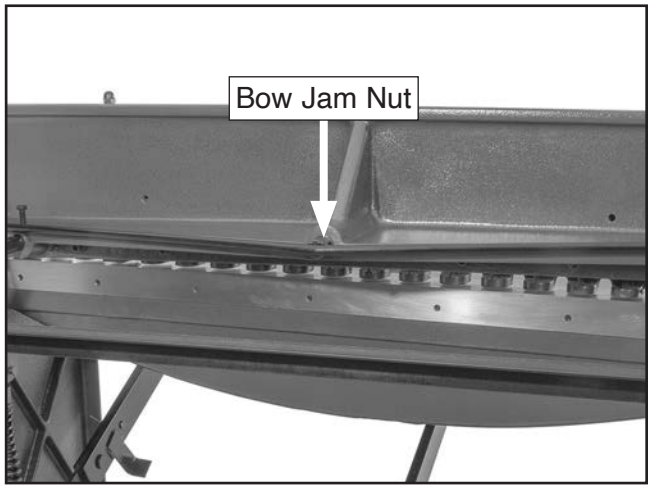


Figure 37. Location of bow jam nut.

Items Needed	**Qty**
Open-End Wrench 24mm	1
Scrap Paper	As Needed

To adjust blade bow:

1. Perform **Step 1** of **Adjusting Blade Gap** on **Page 26** to determine if blade bow needs adjustment. Adjust blade gap, if necessary, before proceeding

   — If paper cuts cleanly on ends but not center of blades, adjust bow jam nut clockwise while testing results until paper cuts cleanly along entire length of blades.

   — If paper cuts cleanly at center but not end of blades, adjust bow jam nut counterclockwise while testing results until paper cuts cleanly along entire length of blades.

Adjusting Return Spring Tension

The tension of the return springs can be adjusted to increase or decrease the return rate.

Tool Needed	**Qty**
Open-End Wrench 24mm	1

To adjust return spring tension:

1. Adjust (2) return spring hex nuts in small, equal increments (see **Figure 38**).

   — To increase return rate, tighten hex nuts against springs.

   — To decrease return rate, loosen hex nuts.

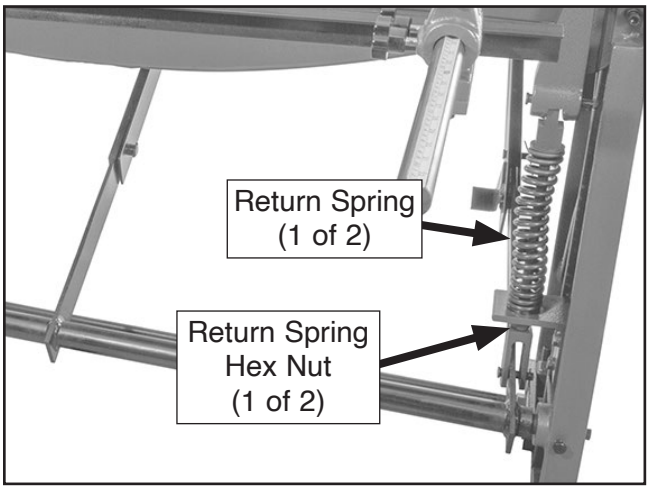


Figure 38. Return spring tension adjustment components.

Adjusting Gibs

The gibs are responsible for the amount of play in the upper blade. They should only be adjusted if the foot pedal is difficult to lower or if all the other blade adjustments have been verified as correct, and the quality of cut is still poor.

Tools Needed	Qty
Hex Wrench 8mm	1
Open-End Wrench 17mm	1

To adjust gibs:

1. Loosen (3) jam nuts on each gib (see **Figure 39**).

2. Adjust (3) gib screws on each side of shear in small, equal increments (see **Figure 39**). Test for binding or play after each adjustment by pushing or pulling top of cutter bar.

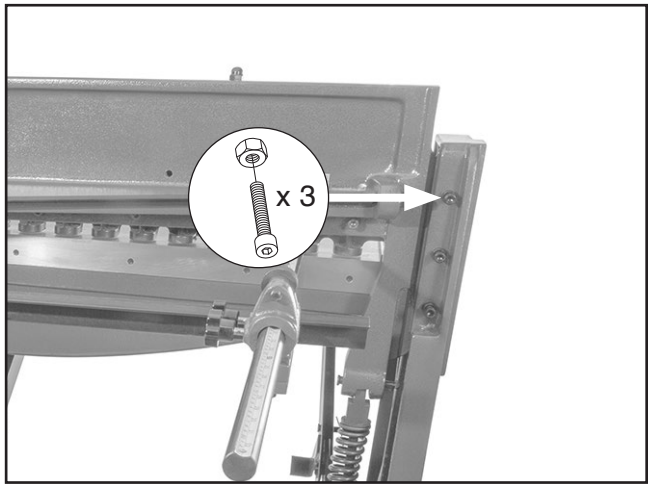


Figure 39. Location of gib screws and jam nuts.

   — If foot pedal is difficult to lower and blades are binding, adjust screws counterclockwise.

   — If too much play of upper blade is resulting in poor quality of cuts, adjust screws clockwise.

3. Tighten jam nuts to secure gib adjustment.

Adjusting Hold-Down/ Blade Guard

When the foot pedal lowers the upper blade, the blade guard is also engaged to contact and secure the workpiece during the cutting operation. The blade guard must be parallel to the table to correctly secure workpieces.

Tools Needed	Qty
Feeler Gauge Set	1
Wrench or Socket 19mm	1

Adjusting Blade Guard Clearance

For extra thin or thick workpieces, the guard can be adjusted to provide the correct amount of clearance to secure them.

To adjust blade guard clearance:

1. Loosen (2) blade guard hex bolts (see **Figure 40**).

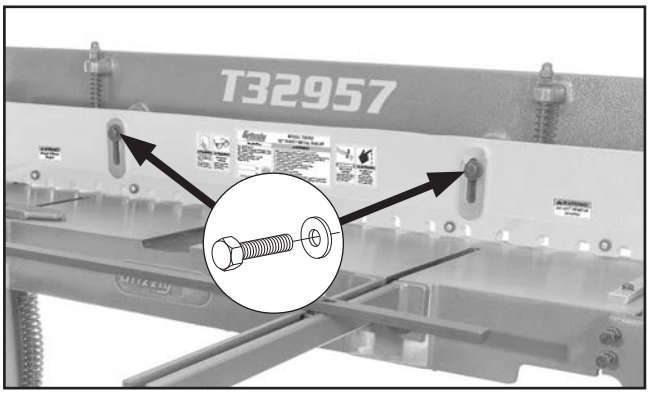


Figure 40. Location of blade guard hex bolts.

2. Adjust blade guard up or down to accommodate workpiece thickness.

3. Tighten (2) blade guard hex bolts to secure.

4. Place front edge of workpiece under blade guard, then use foot pedal to confirm workpiece is secured by blade guard.

5. Refer to **Adjusting Blade Guard Parallel to Table** on **Page 29** before performing operation.

Adjusting Blade Guard Parallel With Table

1. Use foot pedal to lower and hold blade guard in lowest position.

2. Insert largest feeler gauge that will fit between hold-down finger and table on right end of blade guard (see **Figure 41**).

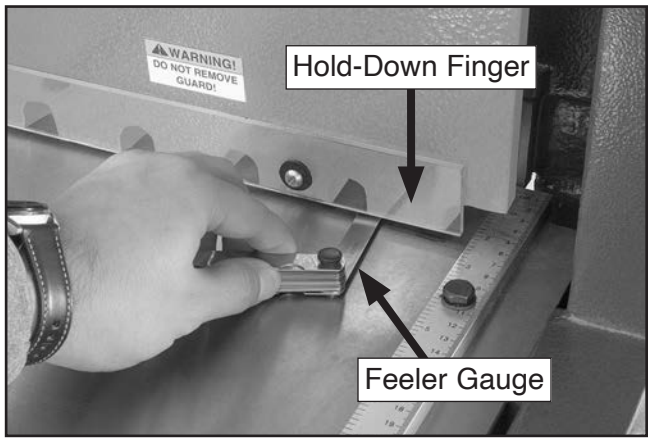


Figure 41. Using feeler gauge to check blade guard clearance.

3. Repeat **Step 2** on left end of blade guard.

   — If both hold-down fingers *are* same distance from table, no adjustment is required.

   — If hold-down fingers *are not* same distance from table, proceed to **Step 4**.

4. Loosen blade guard hex bolt on side of blade guard that needs adjustment (see **Figure 42**).

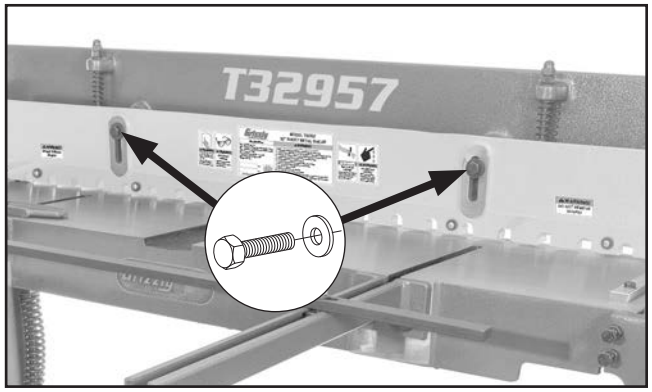


Figure 42. Location of blade guard hex bolts.

5. Adjust blade guard until entire length is same distance from table, then tighten hex bolt.

Squaring Front Scales

For the front scales to work properly, these scales must be square to the blades.

Tools Needed	Qty
Machinist's Square	1
Wrench or Socket 13mm	1

To square front scales:

1. Use foot pedal to lower and hold blade guard in lowest position.

2. Place machinist's square against blade guard and front scale.

   — If scale *is* square to blade guard, no adjustment is necessary.

   — If scale *is not* square to blade guard, proceed to **Step 3**.

3. Loosen (2) hex bolts for front scale that needs adjustment (see **Figure 39**).

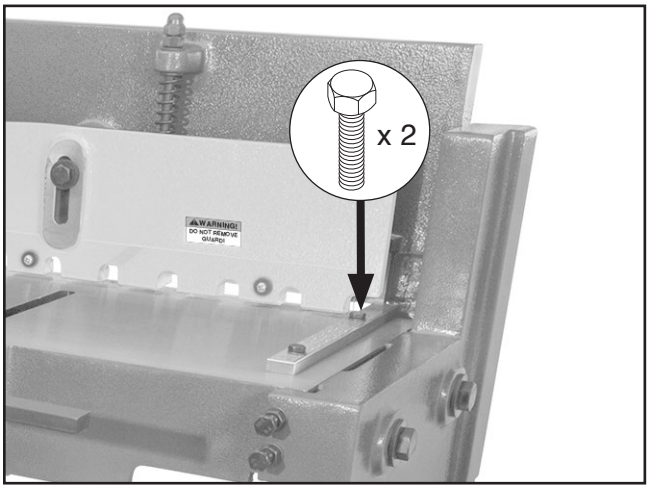


Figure 43. Location of front scale hex bolts.

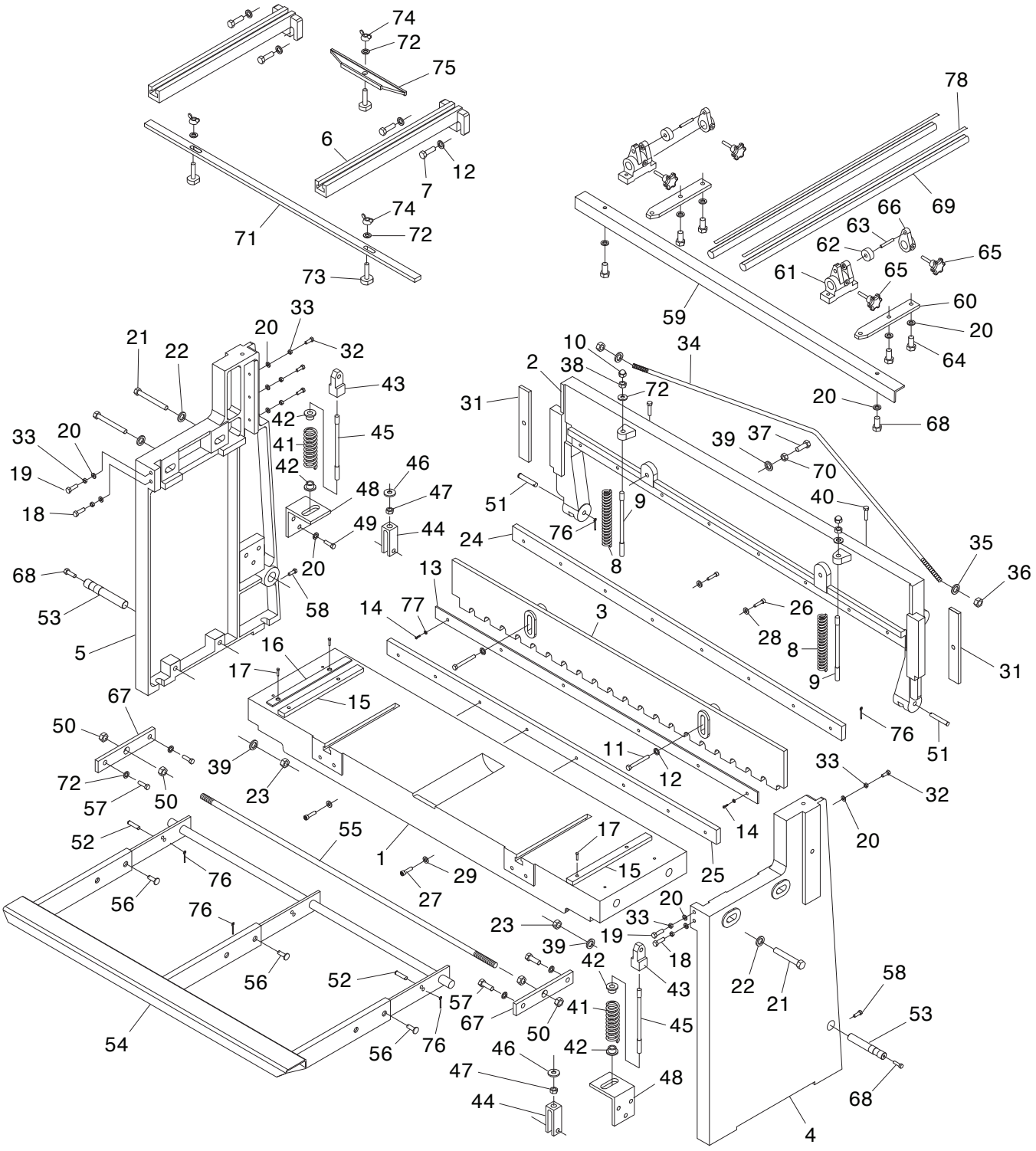
4. Place one side of machinist's square against blade guard and adjust front scale against other side of square.

5. Tighten hex bolts from **Step 3** to secure position.

SECTION 7: PARTS

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

Main

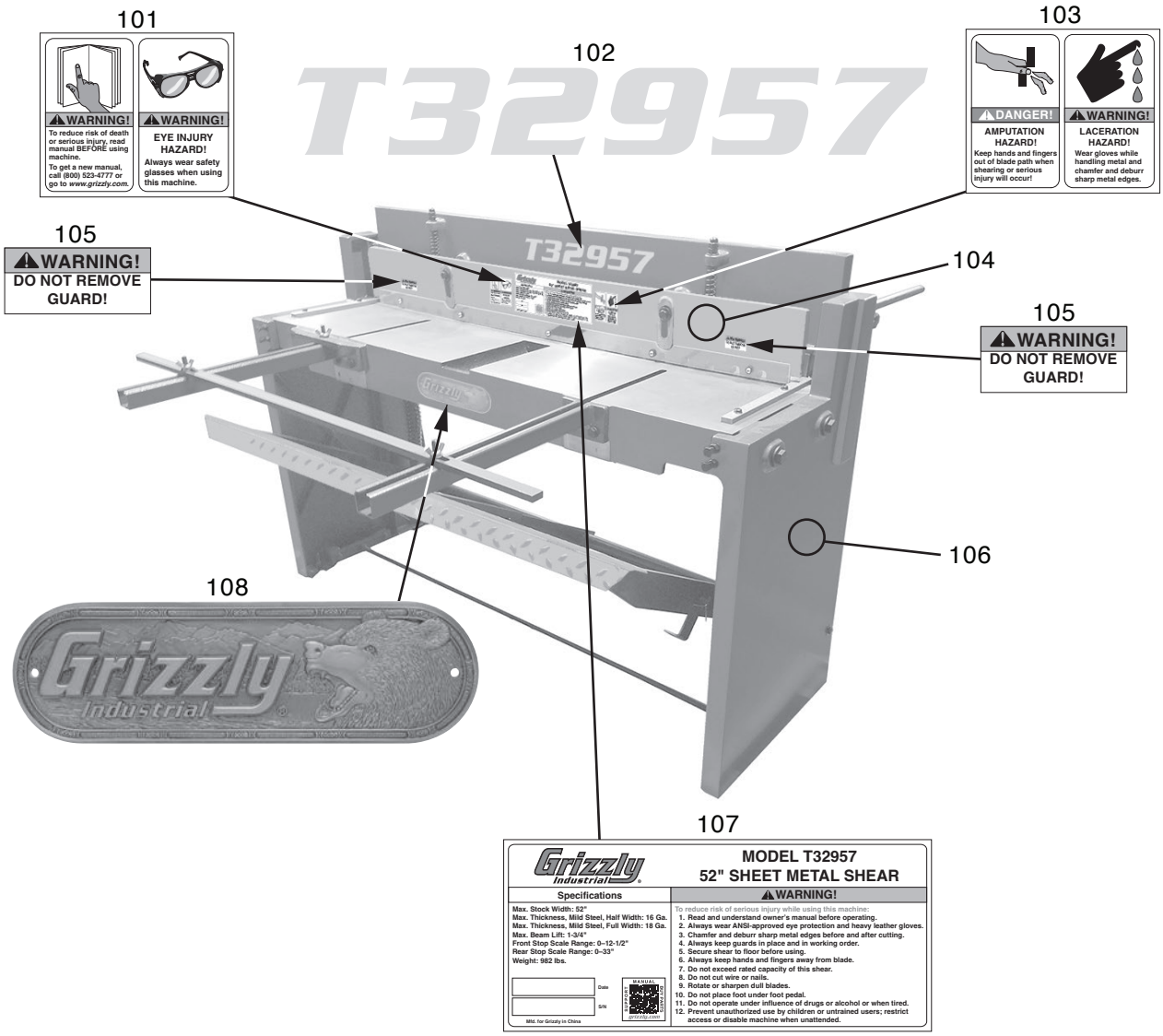


Main Parts List

REF	PART #	DESCRIPTION
1	PT32957001	TABLE
2	PT32957002	CUTTER BAR
3	PT32957003	HOLD DOWN
4	PT32957004	SIDE PANEL (RIGHT)
5	PT32957005	SIDE PANEL (LEFT)
6	PT32957006	EXTENSION ARM
7	PT32957007	HEX BOLT M12-1.75 X 30
8	PT32957008	COMPRESSION SPRING 3 X 22 X 165
9	PT32957009	STUD-UDE M12-1.75 X 220, 25, 45
10	PT32957010	ACORN NUT M12-1.75
11	PT32957011	HEX BOLT M12-1.75 X 80
12	PT32957012	FLAT WASHER 12MM
13	PT32957013	BLADE GUARD
14	PT32957014	PHLP HD SCR M6-1 X 15
15	PT32957015	90-DEG STOP
16	PT32957016	TABLE SCALE
17	PT32957017	HEX BOLT M8-1.25 X 25
18	PT32957018	HEX BOLT M10-1.5 X 60
19	PT32957019	HEX BOLT M10-1.5 X 50
20	PT32957020	FLAT WASHER 10MM
21	PT32957021	HEX BOLT M16-2 X 120
22	PT32957022	FLAT WASHER 16MM
23	PT32957023	HEX NUT M16-2
24	PT32957024	UPPER BLADE
25	PT32957025	LOWER BLADE
26	PT32957026	CAP SCREW M10-1.5 X 45
27	PT32957027	CAP SCREW M10-1.5 X 50
28	PT32957028	FLAT WASHER 10MM
29	PT32957029	FLAT WASHER 10MM
31	PT32957031	GIB
32	PT32957032	CAP SCREW M10-1.5 X 45
33	PT32957033	HEX NUT M10-1.5
34	PT32957034	BLADE BOW ROD
35	PT32957035	FLAT WASHER 14MM
36	PT32957036	HEX NUT M14-2
37	PT32957037	BOW BOLT M16-2 X 60
38	PT32957038	HEX NUT M12-1.75
39	PT32957039	FLAT WASHER 16MM
40	PT32957040	HEX BOLT M10-1.5 X 40

REF	PART #	DESCRIPTION
41	PT32957041	COMPRESSION SPRING 8 X 46 X 275
42	PT32957042	SPRING CAP
43	PT32957043	PIVOT BLOCK
44	PT32957044	PIVOT BRACKET
45	PT32957045	STUD-UDE M16-2 X 320, 2, 16
46	PT32957046	FLAT WASHER 16MM
47	PT32957047	HEX NUT M16-2
48	PT32957048	SPRING MOUNTING BRACKET
49	PT32957049	HEX BOLT M10-1.5 X 25
50	PT32957050	HEX NUT M16-2
51	PT32957051	CLEVIS PIN 12 X 88MM
52	PT32957052	CLEVIS PIN 12 X 45MM
53	PT32957053	HINGE PIN
54	PT32957054	FOOT PEDAL ASSEMBLY
55	PT32957055	STUD-DE M16-2 X 1480, 60
56	PT32957056	CLEVIS PIN 20 X 36MM
57	PT32957057	HEX BOLT M12-1.75 X 25
58	PT32957058	HEX BOLT M10-1.5 X 25
59	PT32957059	REAR WORK STOP
60	PT32957060	REAR WORK STOP MOUNT
61	PT32957061	MICRO-ADJUSTMENT BLOCK
62	PT32957062	KNOB M10-1.5, D35, ROUND KD
63	PT32957063	STUD-FT M10-1.5 X 90
64	PT32957064	HEX BOLT M10-1.5 X 30
65	PT32957065	KNOB BOLT M8-1.25 X 25, 6-LOBE, D35
66	PT32957066	REAR WORK STOP ADJUSTMENT BLOCK
67	PT32957067	CONNECTING STUD BRACKET
68	PT32957068	HEX BOLT M10-1.5 X 20
69	PT32957069	SUPPORT ROD
70	PT32957070	HEX NUT M16-2
71	PT32957071	FRONT WORK STOP
72	PT32957072	FLAT WASHER 12MM
73	PT32957073	T-BOLT M12-1.75 X 45
74	PT32957074	WING NUT M12-1.75
75	PT32957075	BEVEL GAUGE
76	PT32957076	COTTER PIN M3 X 50 STANDARD
77	PT32957077	FLAT WASHER 6MM
78	PT32957078	SUPPORT ROD SCALE

Labels & Cosmetics



REF	PART #	DESCRIPTION
101	PT32957101	MANUAL/EYE INJURY LABEL
102	PT32957102	MODEL NUMBER LABEL
103	PT32957103	AMPUTATION/LACERATION LABEL
104	PT32957104	TOUCH-UP PAINT, CAUTION YELLOW

REF	PART #	DESCRIPTION
105	PT32957105	DO NOT REMOVE GUARD LABEL
106	PT32957106	TOUCH-UP PAINT, GRIZZLY GREEN
107	PT32957107	MACHINE ID LABEL
108	PT32957108	OBLONG NAMEPLATE SMALL

⚠WARNING

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

WARRANTY & RETURNS

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

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

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

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

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

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

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

WARRANTY

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