

# READ THIS FIRST



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

## Model G0561

### \*\*\*IMPORTANT UPDATE\*\*\*

For Machines Mfd. Since 01/25  
and Owner's Manual Revised 11/22

The following changes were recently made since the owner's manual was printed:

- New coolant pump and vise design.
- Specifications, parts, wiring, and labels changed.

Aside from this information, all other content in the owner's manual applies and **MUST** be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

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### New Coolant Pump

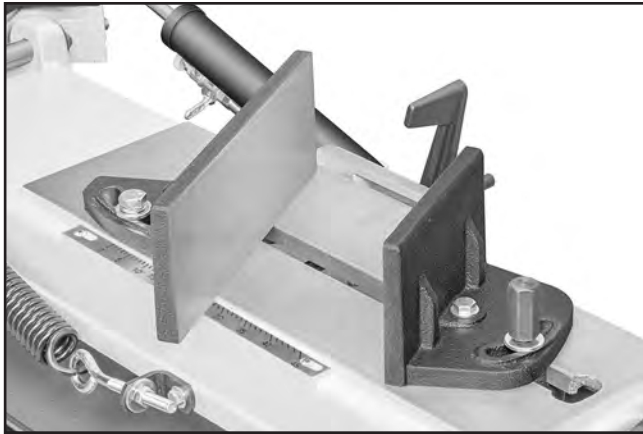


### Old Coolant Pump



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## New Vise



## Old Vise



## Revised Specifications

### Product Dimensions:

Weight.....306 lbs.

### Shipping Dimensions:

Weight.....335 lbs.

### Electrical:

Full-Load Current Rating .....16.48A at 115V, 8.23A at 230V

Minimum Circuit Size.....20A at 115V, 15A at 230V

### Motors:

#### Main

Amps.....16A/8A

#### Coolant Pump

Horsepower..... 1/8 HP

Phase..... Single-Phase

Amps..... 0.48A/0.23A

Type ..... Sealed Induction

Power Transfer..... Direct

Bearings.....Shielded & Permanently Lubricated

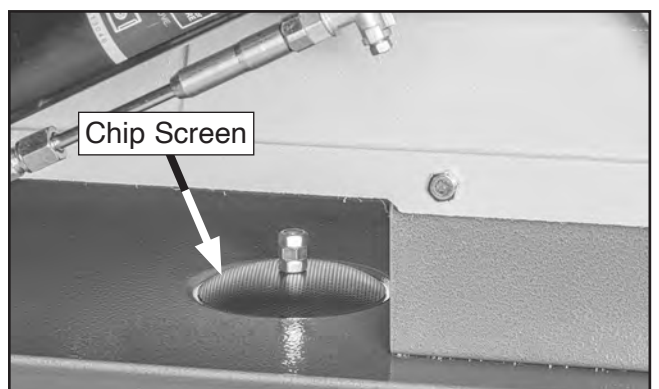
### Other Specifications:

Country of Origin ..... Taiwan

## Revised Assembly

The step below replaces **Step 17** on **Page 20** of owner's manual.

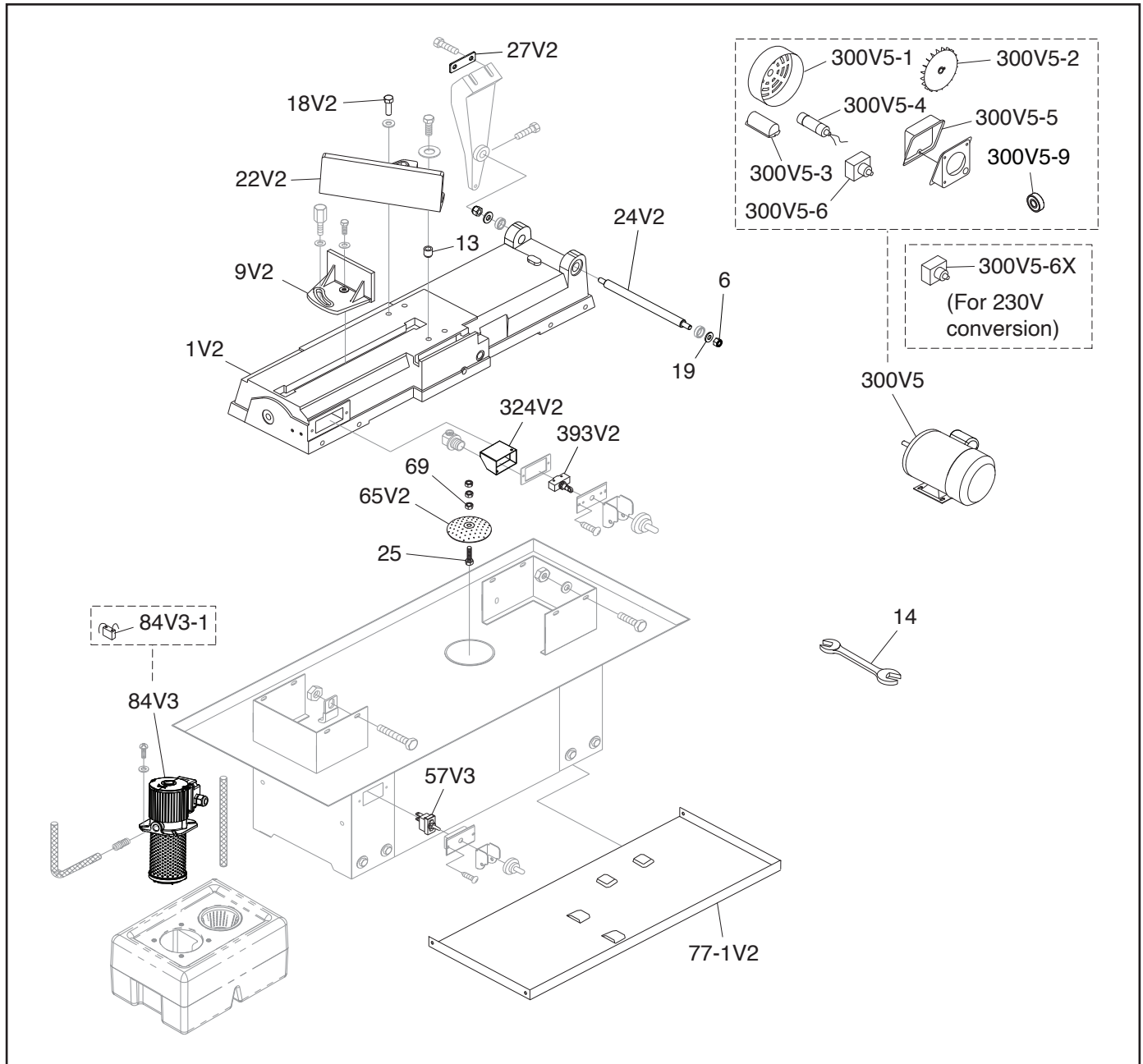
- Place chip screen in cabinet hole shown in **Figure 1**.



**Figure 1.** Chip screen installed.



# Revised Parts



REF	PART #	DESCRIPTION
1V2	P0561001V2	BASE V2.01.25
6	P0561006	LOCK NUT 1/2"-12
9V2	P0561009V2	WISE JAW, FRONT V2.01.25
13	P0561013	BUSHING
14	P0561014	WRENCH 17 X 19MM OPEN-ENDS
18V2	P0561018V2	HEX BOLT 1/2-12 X 2 V2.01.25
19	P0561019	FLAT WASHER 1/2
22V2	P0561022V2	WISE JAW, REAR V2.01.25
24V2	P0561024V2	SUPPORT ROD V2.01.25
25	P0561025	HEX BOLT 5/16-18 X 3/4
27V2	P0561027V2	SPRING BRACKET 75 X 25.4 V2.01.25
57V3	P0561057V3	TOGGLE SWITCH SEI R13-25A V3.01.25
65V2	P0561065V2	DRAIN SCREEN V2.01.25
69	P0561069	HEX NUT 5/16-18

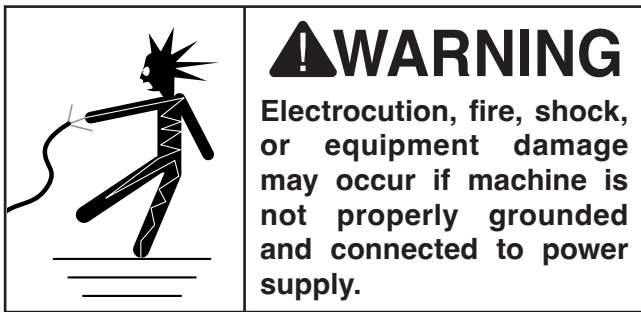
REF	PART #	DESCRIPTION
77-1V2	P0561077-1V2	STAND SHELF V2.09.23
84V3	P0561084V3	COOLANT PUMP MOTOR V3.01.24
84V3-1	P0561084V3-1	R CAPACITOR 3M 400V 1-1/8 X 1-1/2
300V5	P0561300V5	MOTOR 1HP 115/230V 1-PH V5.01.25
300V5-1	P0561300V5-1	MOTOR FAN COVER
300V5-2	P0561300V5-2	MOTOR FAN
300V5-3	P0561300V5-3	CAPACITOR COVER
300V5-4	P0561300V5-4	S CAPACITOR 150M 250V
300V5-5	P0561300V5-5	JUNCTION BOX
300V5-6	P0561300V5-6	CIRCUIT BREAKER 18A KUOYUH 88-SERIES
300V5-6X	P0561300V5-6X	CIRCUIT BREAKER 10A KUOYUH 88-SERIES
300V5-9	P0561300V5-9	BALL BEARING 6203ZZ
324V2	P0561324V2	ELECTRICAL BOX V2.01.25
393V2	P0561393V2	TOGGLE SWITCH SEI R13-28F V2.01.25



# 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 (115V) .. 16.48 Amps**

**Full-Load Current Rating (230V).... 8.23 Amps**

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

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

## Circuit Information

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



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

## Circuit Requirements for 115V

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

**Nominal Voltage** ..... 110V, 115V, 120V  
**Cycle**.....60 Hz  
**Phase**..... **Single-Phase**  
**Power Supply Circuit** ..... **20 Amps**  
**Plug/Receptacle** ..... **NEMA 5-15**

## Circuit Requirements for 230V

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

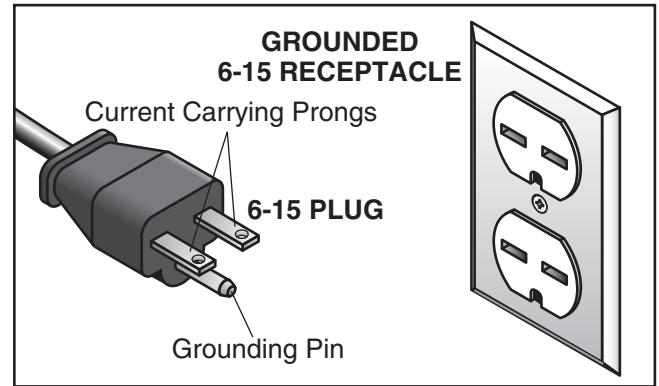
**Nominal Voltage** .....208V, 220V, 230V, 240V  
**Cycle**.....60 Hz  
**Phase**..... **Single-Phase**  
**Power Supply Circuit** ..... **15 Amps**  
**Plug/Receptacle** ..... **NEMA 6-15**



## Grounding Requirements

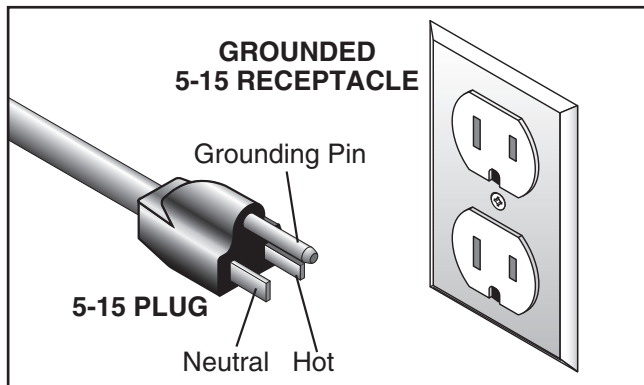
This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

**For 115V operation:** This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.



**Figure 3.** Typical 6-15 plug and receptacle.

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



**Figure 2.** Typical 5-15 plug and receptacle.

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.

**⚠ CAUTION**

**SHOCK HAZARD!**

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

**For 230V operation:** The plug specified under “Circuit Requirements for 230V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

## 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 (115V).....12 AWG**
- Minimum Gauge Size (230V).....18 AWG**
- Maximum Length (Shorter is Better).....50 ft.**

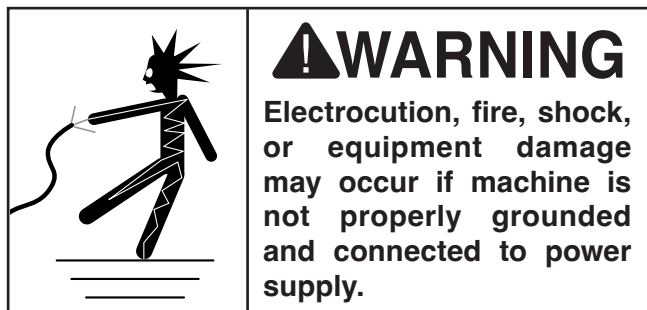
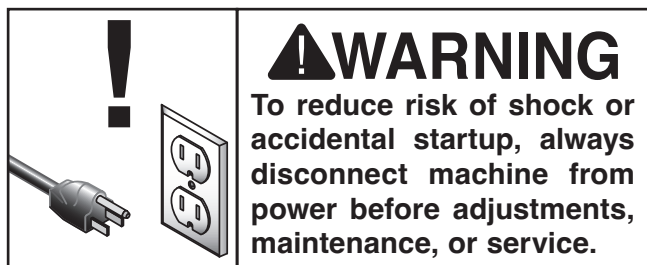


## Voltage Conversion

The voltage conversion **MUST** be performed by an electrician or qualified service personnel.

The voltage conversion procedure consists of rewiring the main motor, replacing the circuit breaker, rewiring the coolant pump motor, and installing the correct plug. A wiring diagram is provided on **Page 10** of this update, for your reference.

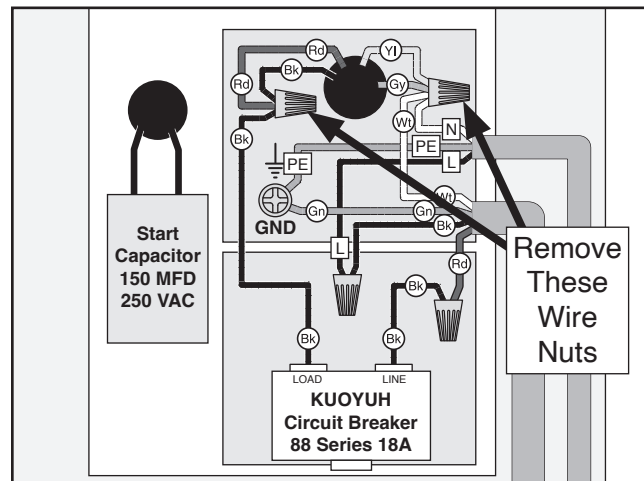
**IMPORTANT:** If the diagram included on either motors conflicts with the one included on **Page 10** of this update, the motor may have changed since the manual was printed. Use the diagram included on the applicable motor junction box cover instead.



Items Needed	Qty
Wire Stripper .....	1
Phillips Head Screwdriver #2 .....	1
Circuit Breaker 10A (#P0561300V5-6X) .....	1
Wire Nut (14#AWG x 3) .....	1
Electrical Tape .....	As Needed
Adjustable Wrench .....	1
Plug 6-15 .....	1

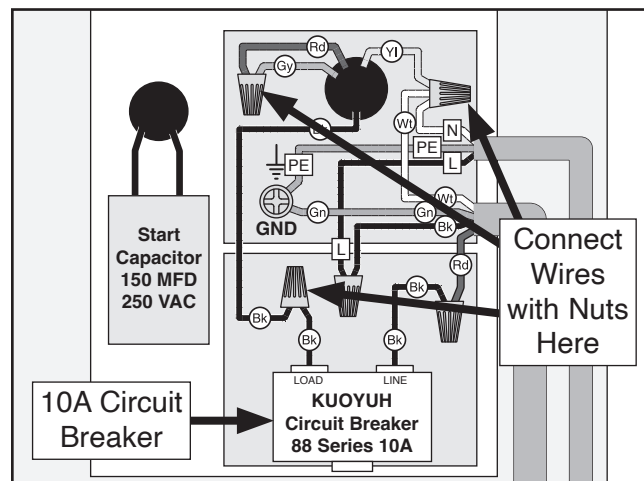
### To convert Model G0561 to 230V:

1. DISCONNECT MACHINE FROM POWER!
2. Cut off existing 5-15 plug.
3. Open main motor junction box, then remove (2) wire nuts indicated in **Figure 4**.



**Figure 4.** Main motor wired for 115V.

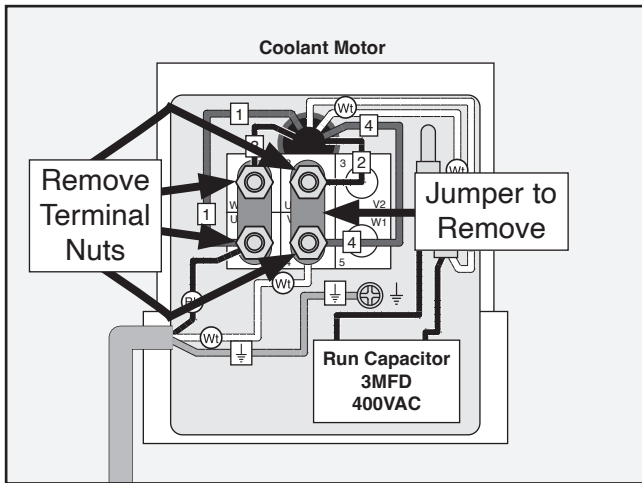
4. Use wire nuts to connect wires as indicated in **Figure 5**. Twist wire nuts onto their respective wires and wrap them with electrical tape so they will not come loose during operation.
5. Replace pre-installed 18A circuit breaker with 10A circuit breaker (see **Figure 5**).



**Figure 5.** Main motor wired for 230V.

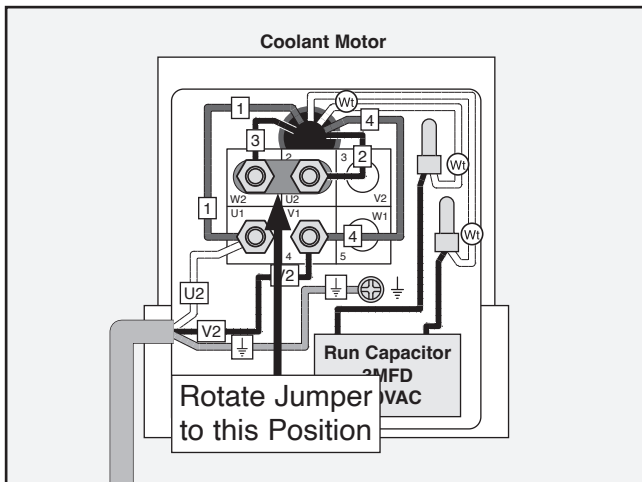


6. Close and secure main motor junction box.
7. Open coolant pump motor junction box, then remove (4) terminal nuts (see **Figure 6**).
8. Remove and discard jumper indicated in **Figure 6**.



**Figure 6.** Coolant pump motor wired for 115V.

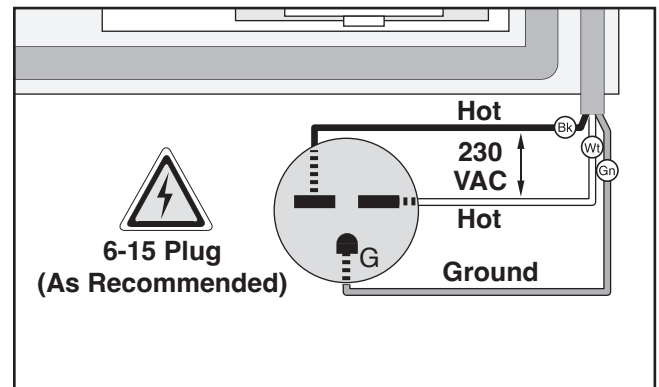
9. Rotate remaining jumper across **W2** and **U2** terminals and secure, as shown in **Figure 7**.



**Figure 7.** Coolant pump motor wired for 230V.

10. Close and secure coolant pump motor junction box.
11. Install 6-15 plug on end of power cord, according to instructions and wiring diagrams provided by plug manufacturer.

— If plug manufacturer did not include instructions, wiring of generic NEMA 6-15 plug is illustrated in **Figure 8**.



**Figure 8.** Generic NEMA 6-15 plug wiring.



# 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 Contents (Figure 9)	Qty
A. Pulley Cover .....	1
B. Collar .....	1
C. Wheels .....	2
D. Axle .....	1
E. Table Bracket.....	1
F. Open-End Wrench 17 x 19mm.....	1
G. Vertical Work Table.....	1
H. Work Stop Rod.....	1
I. Work Stop.....	1
J. Chip Screen.....	1
K. Leveling Feet.....	2
L. V-Belt 3V270 (Not Shown) .....	1
M. Motor (Not Shown) .....	1

## Hardware Bag (Not Shown)

- Flat Washers 3/8" (Leveling Feet)..... 2
- Hex Nuts 3/8"-16 (Leveling Feet)..... 2
- Cotter Pins 3 x 30mm (Wheels)..... 2
- Flat Washers 5/8" (Wheels)..... 4
- Flat Head Screw 1/4"-20 x 1/2" (Table)..... 1
- Hex Nut 1/4"-20 (Table)..... 1
- Knob 1/4"-20 x 5/8" (Pulley Cover)..... 1
- Hose Clamps 5/8" (Coolant Hose)..... 2
- Hex Bolts 5/16"-18 x 1" (Motor)..... 4
- Hex Nuts 5/16"-18 (Motor)..... 2
- Flat Washers 5/16" (Motor)..... 2

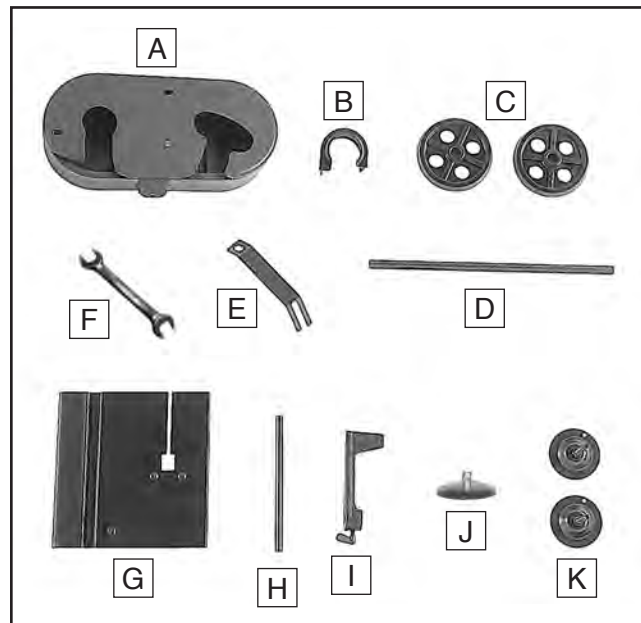
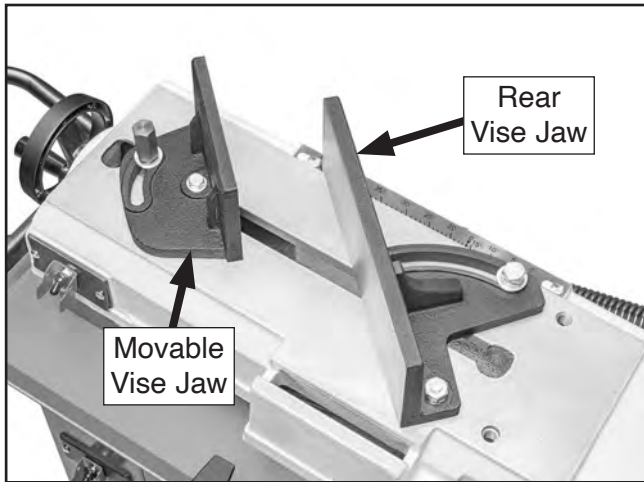


Figure 9. Box contents.



# Using Vise

The vise consists of a movable vise jaw and a rear vise jaw (see **Figure 10**) that can clamp material up to 12 inches wide. It can be set to cut angles from 0 to 45 degrees.

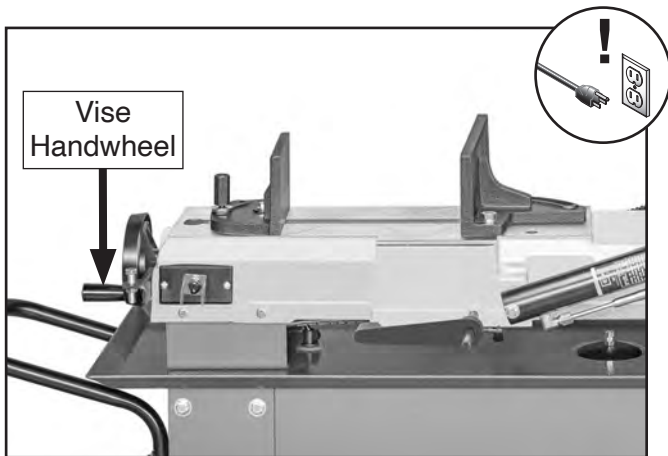


**Figure 10.** Vise jaws.

<b>Tool Needed</b>	<b>Qty</b>
Wrench or Socket 3/4" .....	1

### To use vise:

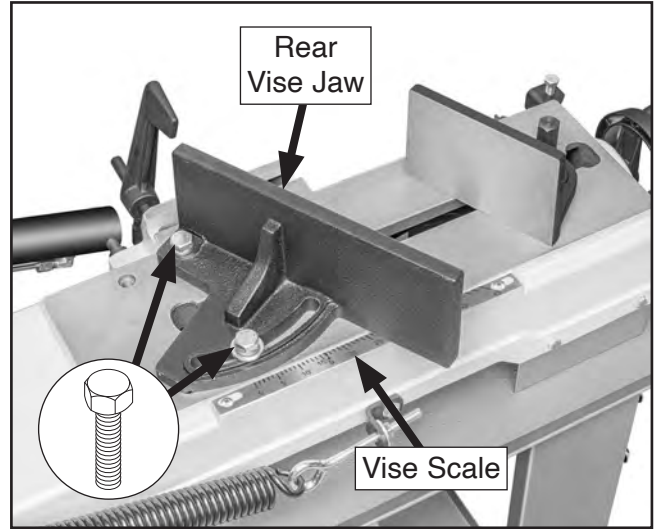
1. DISCONNECT MACHINE FROM POWER!
2. Turn vise handwheel counterclockwise to open vise jaws enough to accept workpiece (see **Figure 11**).



**Figure 11.** Location of vise handwheel.

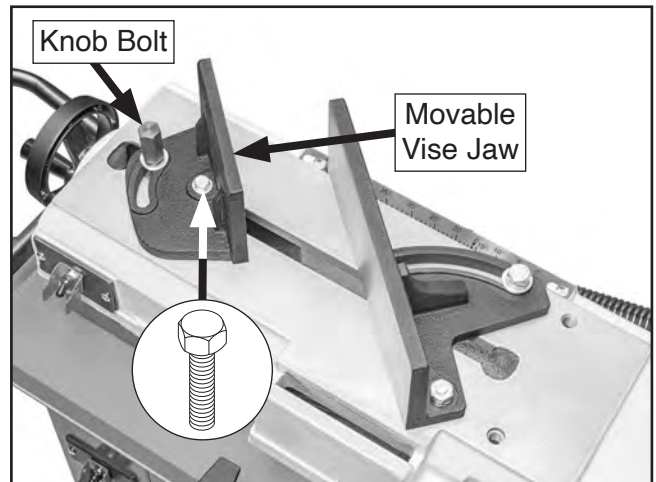
3. Loosen (2) rear vise jaw hex bolts (see **Figure 12**).

4. Use vise scale to adjust rear vise jaw to desired angle (see **Figure 12**), then tighten rear vise jaw hex bolts to secure.



**Figure 12.** Location of rear jaw components.

5. Loosen hex bolt and knob bolt on movable vise jaw (see **Figure 13**).

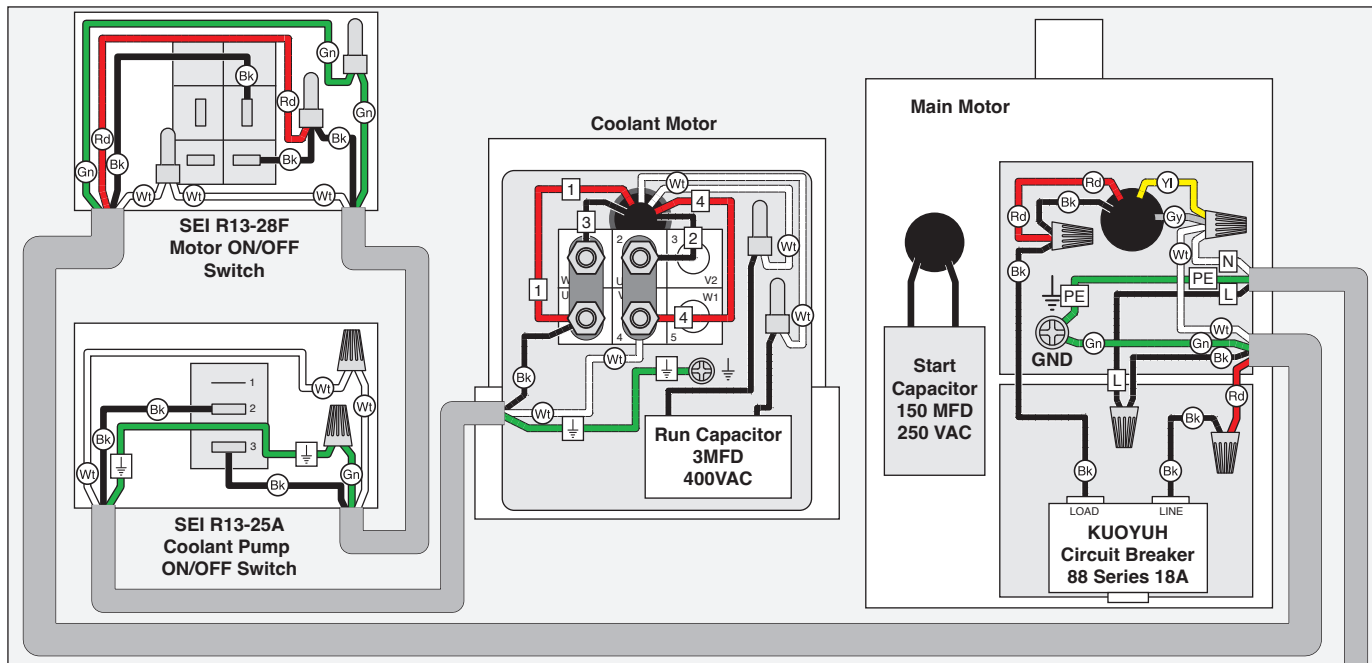


**Figure 13.** Movable vise jaw components.

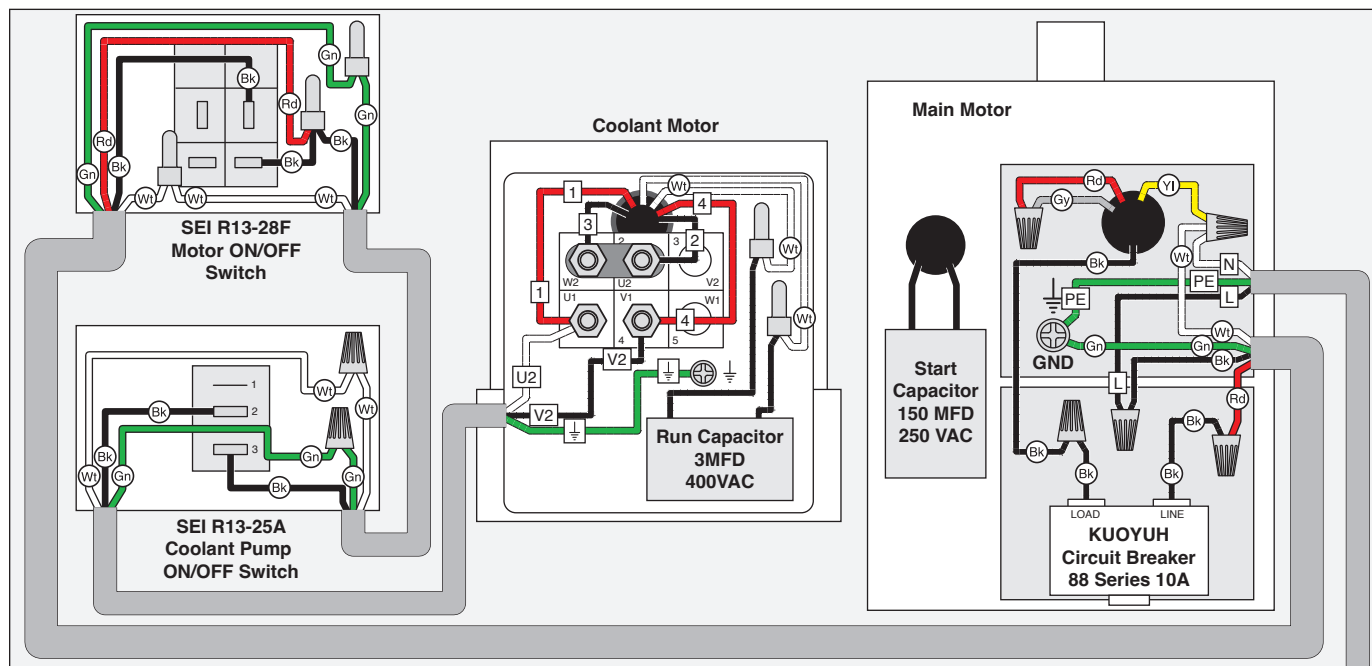
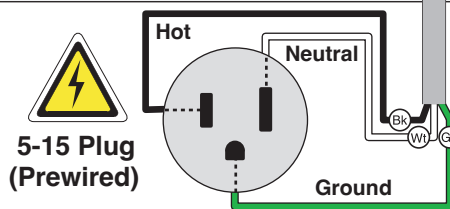
6. Place workpiece against rear vise jaw, then turn vise handwheel clockwise to tighten movable vise jaw against workpiece.
7. Tighten movable vise jaw hex bolt and knob bolt.
8. Connect machine to power and cut workpiece.
9. Allow blade to come to complete stop, DISCONNECT MACHINE FROM POWER, then open vise jaws to remove workpiece.



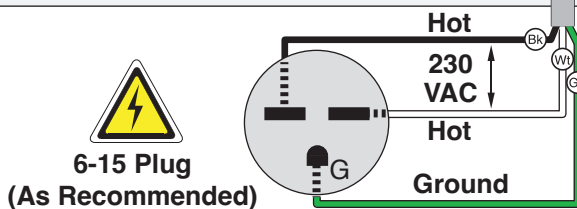
# Wiring Diagrams



115V Wiring Diagram



230V Wiring Diagram



# Electrical Components



**Figure 14.** Main motor wiring (115V).



**Figure 17.** Coolant pump motor wiring (115V).



**Figure 15.** Main motor capacitor wiring.



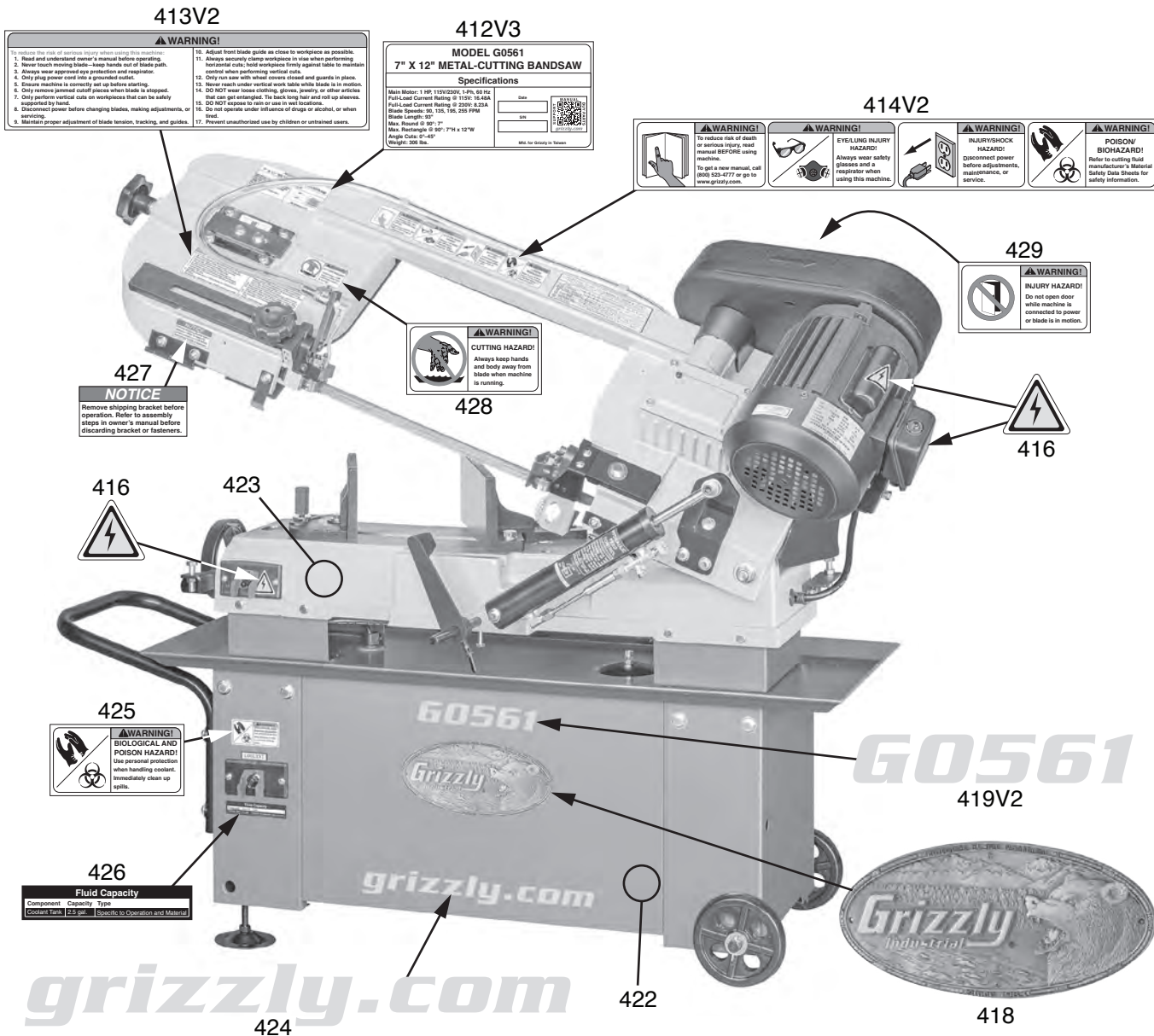
**Figure 18.** Coolant pump ON/OFF switch wiring.



**Figure 16.** Motor ON/OFF switch wiring.



# Labels & Cosmetics



REF	PART #	DESCRIPTION
412V3	P0561412V3	MACHINE ID LABEL V3.01.25
413V2	P0561413V2	MACHINE WARNING LABEL V2.09.23
414V2	P0561414V2	COMBO WARNING LABEL V2.09.23
416	P0561416	ELECTRICITY LABEL
418	P0561418	GRIZZLY NAMEPLATE, SMALL
419V2	P0561419V2	MODEL NUMBER LABEL V2.09.23
422	P0561422	TOUCH-UP PAINT, GRIZZLY GREEN

REF	PART #	DESCRIPTION
423	P0561423	TOUCH-UP PAINT, GRIZZLY PUTTY
424	P0561424	GRIZZLY.COM LABEL
425	P0561425	BIOLOGICAL & POISON HAZARD
426	P0561426	FLUID CAPACITY LABEL
427	P0561427	REMOVE BRACKET NOTICE
428	P0561428	CUTTING HAZARD LABEL
429	P0561429	DO NOT OPEN DOOR 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).

**BUY PARTS ONLINE AT GRIZZLY.COM!**  
 Scan QR code to visit our Parts Store.




# *Grizzly* *Industrial, Inc.*®

## **MODEL G0561** **7" X 12" METAL-CUTTING** **BANDSAW** **OWNER'S MANUAL** *(For models manufactured since 01/18)*



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#PC8297 PRINTED IN TAIWAN

V3.11.22

***\*\*\*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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# INTRODUCTION

## Machine Description

The Model G0561 Metal-Cutting Bandsaw has a flexible continuous blade that is used to make straight cuts in metal stock.

The clamping vise adjusts for cuts between 0° and 45°. There are four blade speeds (90, 135, 195, and 255 FPM), with an adjustable feed rate for the correct blade pressure on the workpiece. The pump-controlled coolant system helps provide optimum working results and extended longevity of blades.

## 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

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## 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](http://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.

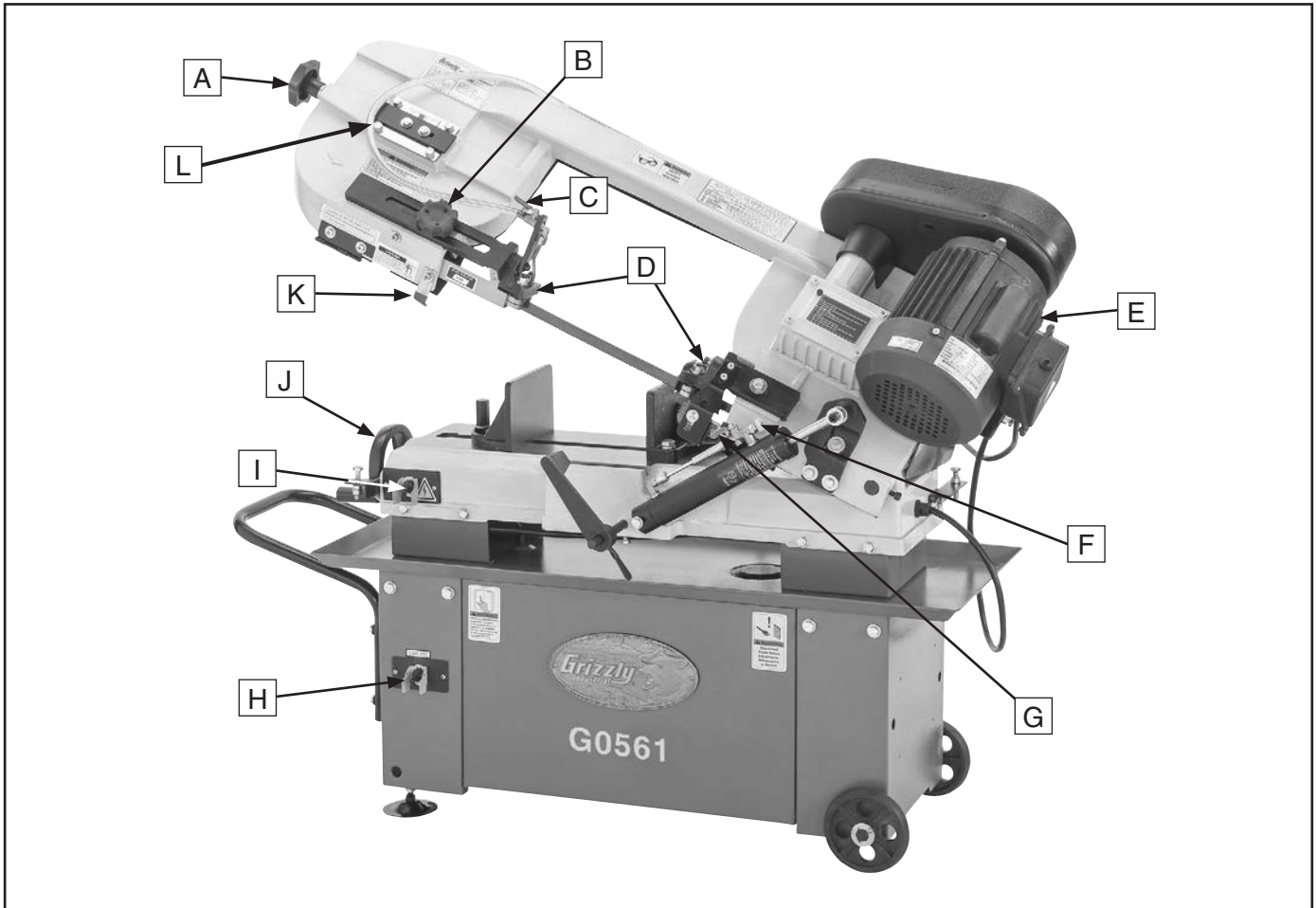
		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:	To reduce risk of serious injury when using this machine:		
Specification:	Read manual before operation.		
Specification:	Wear safety glasses and respirator.		
Specification:	Ensure safety devices are correctly adjusted/setup and		
Specification:	power is connected to grounded circuit before starting.		
Weight:	4. Make sure the motor has stopped and disconnect		
	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 tired, drowsy, or under the influence of drugs or alcohol.		
	10. Maintain machine carefully to prevent accidents.		

Manufactured for Grizzly in Taiwan



# Identification

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



- |                                       |                                   |
|---------------------------------------|-----------------------------------|
| <b>A.</b> Blade Tension Handle        | <b>G.</b> Feed ON/OFF Valve Lever |
| <b>B.</b> Blade Guide Adjustment Knob | <b>H.</b> Pump ON/OFF Switch      |
| <b>C.</b> Coolant Control Valve       | <b>I.</b> Motor ON/OFF Switch     |
| <b>D.</b> Blade Guides                | <b>J.</b> Vise Handwheel          |
| <b>E.</b> 1 HP Motor                  | <b>K.</b> Automatic Shut-Off Tab  |
| <b>F.</b> Feed Rate Control Knob      | <b>L.</b> Blade Tracking Controls |

## **⚠️ WARNING**

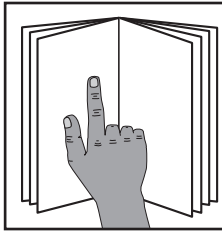
Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious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



# Controls & Components



## **! WARNING**

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

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.

## Headstock

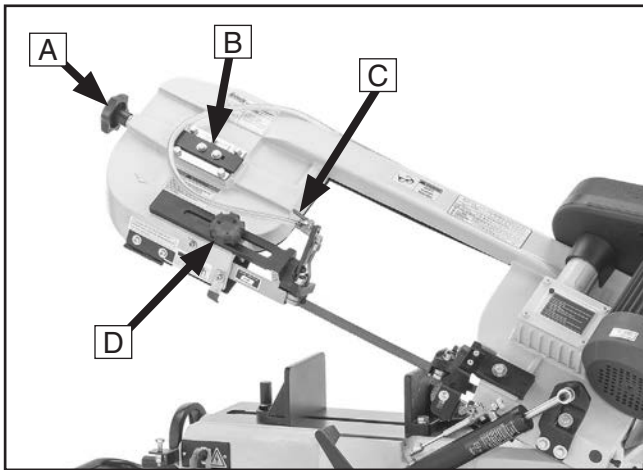


Figure 1. Headstock controls and components.

- A. **Blade Tension Handle:** Increases or decreases blade tension.
- B. **Blade Tracking Controls:** Adjusts front blade wheel tilt to move blade to or from wheel shoulder.
- C. **Coolant Control Valve:** Adjusts cutting fluid flow rate.
- D. **Blade Guide Adjustment Knob:** Adjusts front blade guide that supports blade. Position guide as close to workpiece as possible to prevent blade from twisting.

## Horizontal Downfeed

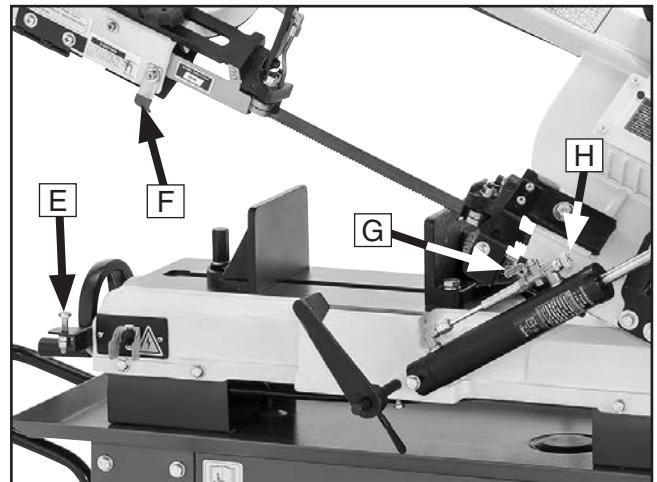


Figure 2. Downfeed controls and components.

- E. **Downfeed Stop Bolt:** Stops headstock from lowering farther than completion of cut.
- F. **Automatic Shut-Off Tab:** Turns machine **OFF** when headstock is fully lowered.
- G. **Feed ON/OFF Valve Lever:** Opens to lower headstock until it contacts downfeed stop bolt; closes to stop headstock from lowering.
- H. **Feed Rate Control Knob:** Increases feed rate when turned clockwise and decreases feed rate when turned counterclockwise.

## Vertical Operation

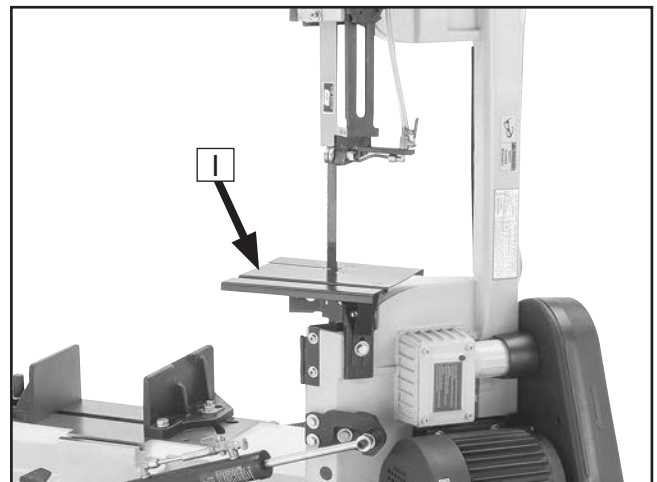
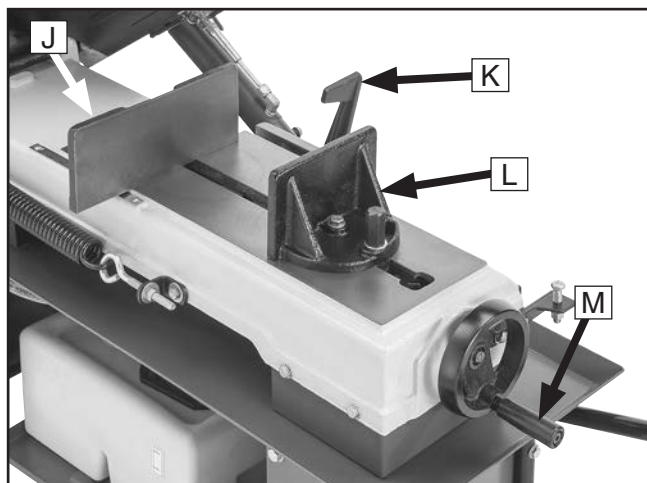


Figure 3. Vertical work table.

- I. **Vertical Work Table:** Supports workpiece during vertical cutting operations.



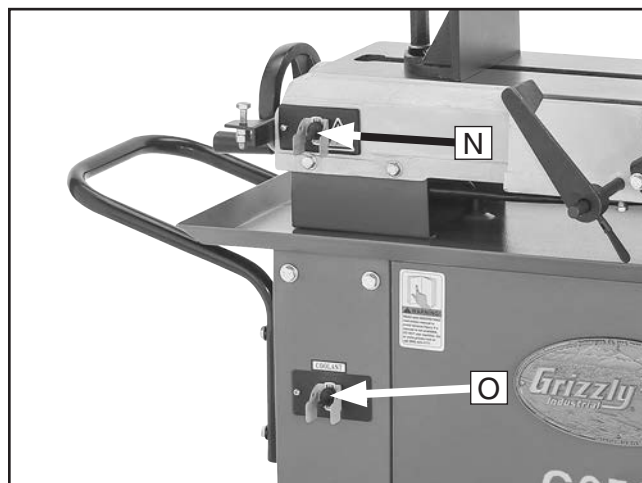
## Vise



**Figure 4.** Vise controls and components.

- J. Rear Vise Jaw:** Adjusts workpiece angle relative to blade.
- K. Work Stop:** Supports repetitive cutting operations.
- L. Movable Vise Jaw:** Holds workpiece against rear vise jaw during cutting operation.
- M. Vise Handwheel:** Adjusts movable vise jaw.

## Electrical



**Figure 5.** Electrical controls and components.

- N. Motor ON/OFF Switch:** Turns motor **ON** when moved up and **OFF** when moved down.
- O. Pump ON/OFF Switch:** Turns coolant pump **ON** when moved up and **OFF** when moved down.





# MACHINE DATA SHEET

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

## MODEL G0561 7" X 12" METAL-CUTTING BANDSAW

### Product Dimensions:

Weight..... 330 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 48 x 16 x 40 in.  
 Footprint (Length x Width)..... 38 x 13 in.

### Shipping Dimensions:

Type..... Wood Slat Crate  
 Content..... Machine  
 Weight..... 343 lbs.  
 Length x Width x Height..... 19 x 51 x 41 in.  
 Must Ship Upright..... Yes

### Electrical:

Power Requirement..... 115V or 230V, Single-Phase, 60 Hz  
 Prewired Voltage..... 115V  
 Full-Load Current Rating..... 12.6A at 115V, 6.3A at 230V  
 Minimum Circuit Size..... 15A at 115V, 15A at 230V  
 Connection Type..... Cord & Plug  
 Power Cord Included..... Yes  
 Power Cord Length..... 84 in.  
 Power Cord Gauge..... 14 AWG  
 Plug Included..... Yes  
 Included Plug Type..... 5-15 for 115V  
 Recommended Plug Type..... 6-15 for 230V  
 Switch Type..... Sealed Toggle Switch w/Automatic Shut-Off

### Motors:

#### Main

Horsepower..... 1 HP  
 Phase..... Single-Phase  
 Amps..... 12A/6A  
 Speed..... 1720 RPM  
 Type..... TEFC Capacitor-Start Induction  
 Power Transfer ..... Belt  
 Bearings..... Shielded & Permanently Lubricated  
 Centrifugal Switch/Contacts Type..... External

#### Coolant Pump

Horsepower..... 1/8 HP  
 Phase..... Single-Phase  
 Amps..... 0.6A/0.3A  
 Speed..... 3400 RPM  
 Type..... TEFC Induction  
 Power Transfer ..... Direct  
 Bearings..... Shielded & Permanently Lubricated



**Main Specifications:**

**Operation Info**

Blade Speeds.....	90, 135, 195, 255 FPM
Std. Blade Length.....	93 in.
Blade Length Range.....	3/4 in.

**Cutting Capacities**

Angle Cuts.....	0 - 45 deg.
Vise Jaw Depth.....	9-3/4 in.
Vise Jaw Height.....	4 in.
Max. Capacity Rectangular Height at 90 Deg.....	7 in.
Max. Capacity Rectangular Width at 90 Deg.....	12 in.
Max. Capacity Round at 90 Deg.....	7 in.
Max. Capacity Rectangular Height at 30 Deg.....	7-3/4 in.
Max. Capacity Rectangular Width at 30 Deg.....	8 in.
Max. Capacity Round at 30 Deg.....	7 in.
Max. Capacity Rectangular Height at 45 Deg.....	4-3/4 in.
Max. Capacity Rectangular Width at 45 Deg.....	4-1/2 in.
Max. Capacity Round at 45 Deg.....	5 in.

**Construction**

Table.....	Cast Iron
Upper Wheel.....	Cast Iron
Lower Wheel.....	Cast Iron
Body.....	Cast Iron
Base.....	Stamped Steel
Wheel Cover.....	Pre-formed Steel
Paint Type/Finish.....	Epoxy

**Other**

Wheel Size.....	11-1/2 in.
Blade Guides Upper.....	Ball Bearing
Blade Guides Lower.....	Ball Bearing
Coolant Capacity.....	2-1/2 GAL

**Table Info**

Table Size Length.....	20-1/2 in.
Table Size Width.....	6-3/4 in.
Floor To Cutting Area Height.....	21 in.

**Other Specifications:**

Country of Origin .....	China
Warranty .....	1 Year
Approximate Assembly & Setup Time .....	30 Minutes
Serial Number Location .....	ID Label on Body Frame
ISO 9001 Factory .....	Yes

**Features:**


- Hydraulic Feed Control
- Quick-Release Vise
- Automatic Shut-Off
- Coolant System
- Includes Blade




# 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 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 Metal Bandsaws

## WARNING

**Serious injury or death can occur from getting fingers, hair, or clothing entangled in rotating or moving parts. Long-term respiratory damage can occur from breathing metal dust created while cutting. To minimize risk of injury, anyone operating this machine MUST completely heed hazards and warnings below.**

**BLADE CONDITION.** Do not operate with dull, cracked, or badly worn blade. Inspect blades for cracks and missing teeth before each use. Make sure blade is properly tensioned and tracking before operating.

**HAND PLACEMENT.** Never position hands or fingers in line with cut, under table during vertical cutting operations, or under bandsaw headstock while it is lowering or operating in horizontal position. Hands could be cut or crushed. Placing hands or fingers in line with blade or too close to blade during vertical cutting operations may result in serious injury if hands slip or workpiece moves unexpectedly.

**SMALL/NARROW WORKPIECES DURING VERTICAL CUTTING.** If hands slip during cut while holding small workpieces with fingers, serious personal injury could occur.

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

**BLADE GUARD POSITION.** Adjust blade guard as close to workpiece as possible before cutting to minimize operator exposure to blade.

**ENTANGLEMENT HAZARDS.** Do not operate saw without blade guard and covers in place. Do not wear loose clothing, jewelry, long hair, and gloves that can be entangled in moving parts.

**BLADE REPLACEMENT.** When replacing blades, disconnect machine from power, wait for moving parts to come to complete stop, and wear gloves and safety glasses to protect hands and eyes. Make sure teeth of new blade face workpiece in direction of blade travel.

**CLEARING JAMS AND CUTOFFS.** Always stop bandsaw and disconnect power before clearing scrap pieces. Use brush or push stick, not hands, to clean swarf/cutoff scraps from table or vise.

**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 hand or workpiece.

**WORKPIECE HANDLING.** Always properly support workpiece with table, vise, or some type of support fixture. Always feed stock evenly and smoothly during vertical cutting operations; secure workpiece in vise and never hold workpiece with hands during horizontal cutting operations. Flag long workpieces to avoid tripping hazard.

**HOT SURFACES.** Contact with hot surfaces from machine components, ejections of hot chips, swarf, and workpiece itself can cause burns.

**UNSTABLE WORKPIECES.** Workpiece cannot be held in vise while cutting in vertical position and an unstable workpiece that unexpectedly moves while cutting can draw operator's hand into blade, causing serious injury. If workpiece cannot be safely supported by hand in vertical position or by vise/jig in horizontal position, **DO NOT** cut workpiece on this machine. Examples are chains, cables, round/oblong-shaped workpieces, those with internal/built-in moving/rotating parts, etc.

**FIRE HAZARD.** Use **EXTREME CAUTION** if cutting magnesium. Using wrong cutting fluid will lead to chip fire and possible explosion.

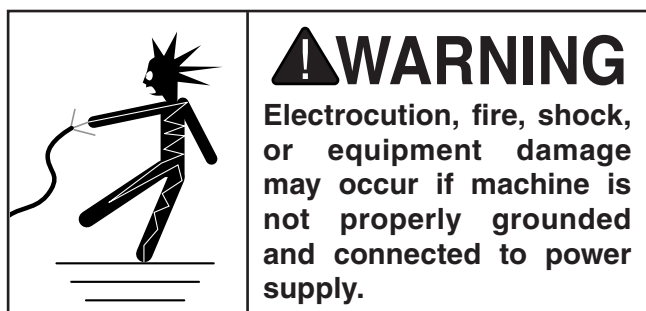
**CUTTING FLUID SAFETY.** Cutting fluids are poisonous. Always follow manufacturer's cutting-fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid invites slipping hazards.



# 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 115V... 12.6 Amps**

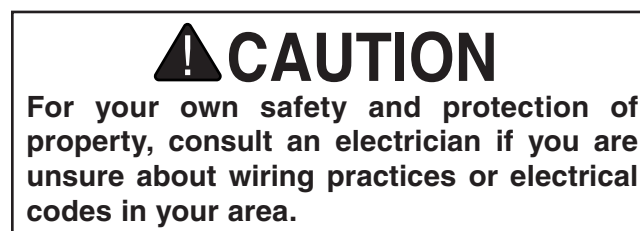
**Full-Load Current Rating at 230V .... 6.3 Amps**

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

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

## Circuit Information

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



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

## Circuit Requirements for 115V

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  
**Plug/Receptacle** ..... NEMA 5-15

## Circuit Requirements for 230V

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

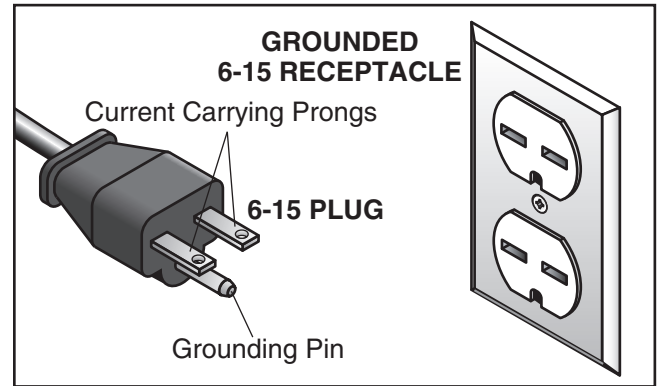
**Nominal Voltage** ..... 208V, 220V, 230V, 240V  
**Cycle** ..... 60 Hz  
**Phase** ..... Single-Phase  
**Power Supply Circuit** ..... 15 Amps  
**Plug/Receptacle** ..... NEMA 6-15



## Grounding Requirements

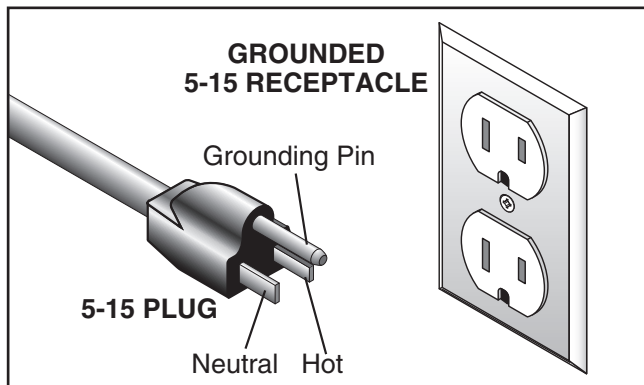
This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

**For 115V operation:** This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.



**Figure 7.** Typical 6-15 plug and receptacle.

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



**Figure 6.** Typical 5-15 plug and receptacle.

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.

**⚠ CAUTION**

**SHOCK HAZARD!**

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

## 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 ..... 14 AWG**
- Maximum Length (Shorter is Better).....50 ft.**

**For 230V operation:** The plug specified under “Circuit Requirements for 230V” on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.



## Voltage Conversion

The voltage conversion **MUST** be performed by an electrician or qualified service personnel.

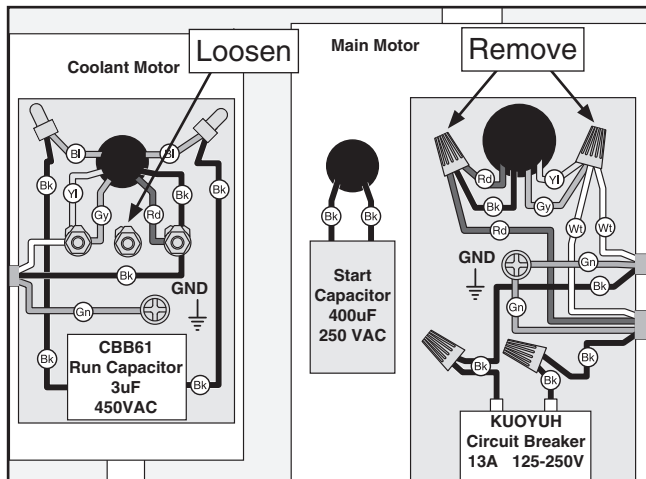
The voltage conversion procedure consists of rewiring the main and coolant motors, replacing the circuit breaker, and installing the correct plug. A wiring diagram is provided in the **WIRING** section, beginning on **Page 48**, for your reference.

**IMPORTANT:** If the diagram included on either motors conflicts with the one in the **WIRING** section, the motor may have changed since the manual was printed. Use the diagram included on the applicable motor junction box cover instead.

Items Needed	Qty
Phillips Head Screwdriver #2 .....	1
Wrench or Socket 7mm .....	1
Electrical Tape .....	As Needed
Wire Nut (14#AWG x 3) .....	1
Hex Nut 8-36 .....	1
Circuit Breaker 7A (#P0561300V4-6X) .....	1
Plug 6-15 .....	1
Wire Stripper .....	1

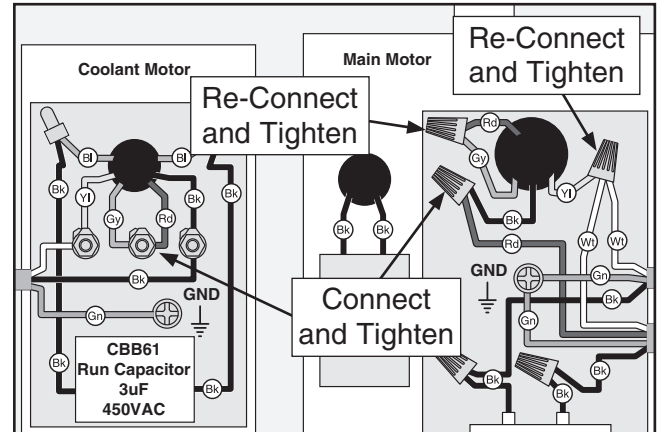
### To convert Model G0561 to 230V:

1. DISCONNECT MACHINE FROM POWER!
2. Cut off the included plug.
3. Open the main and coolant motor junction boxes, remove the wire nuts on the main motor, and loosen the terminal nut on the coolant motor, as indicated in **Figure 8**.



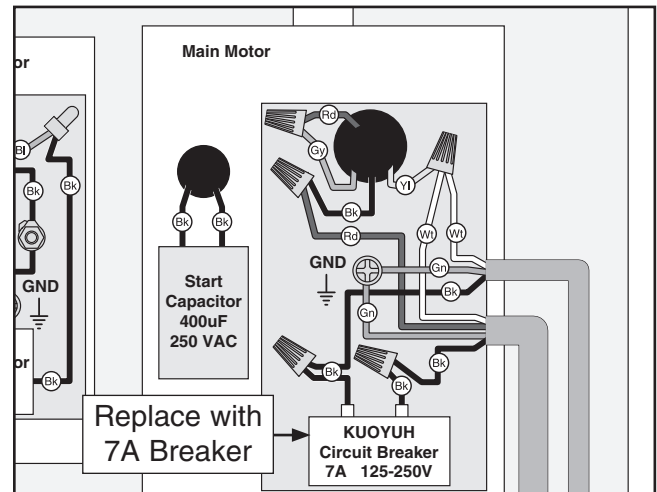
**Figure 8.** Location of components to be removed and loosened.

4. Connect the main motor wires with wire nuts (see **Figure 9**). Once snug, wrap electrical tape around each wire nut and the connected wires, to reduce the likelihood of the wire nut vibrating loose during motor operation.
5. Connect the wires on the coolant motor, as shown in **Figure 9**, with an 8-36 hex nut on the center terminal.



**Figure 9.** Motor wires repositioned for 230V.

6. Replace the pre-installed 13A circuit breaker with a 7A circuit breaker (see **Figure 10**).



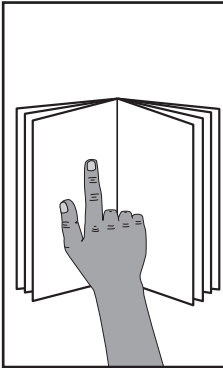
**Figure 10.** 13A circuit breaker replaced with 7A circuit breaker.

7. Close and secure the motor junction boxes.
8. Install a 6-15 plug on the end of the cord, according to the instructions and wiring diagrams provided by the plug manufacturer.

— If the plug manufacturer did not include instructions, the wiring of a generic NEMA 6-15 plug is illustrated on **Page 49**.



# SECTION 3: SETUP



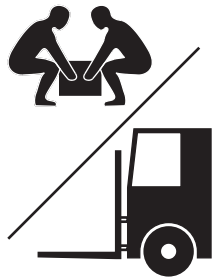
## **!WARNING**

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



## **!WARNING**

Wear safety glasses during the entire setup process!



## **!WARNING**

### **HEAVY LIFT!**

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

## Needed for Setup

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

Description	Qty
• Safety Glasses (for each person).....	1
• Solvent/Cleaner .....	As Needed
• Disposable Rags .....	As Needed
• Disposable Gloves .....	As Needed
• Phillips Head Screwdriver #2 .....	1
• Open-End Wrenches 1/2", 14mm .....	1 Ea.
• Wrench or Socket 1/2" .....	1
• Open-End Wrenches 9/16" .....	2
• Straightedge .....	1
• Hex Wrench 1/8" .....	1
• Round Steel Bar Stock (1/2" x 3").....	2
• Lifting Slings (Rated for at least 400 lbs.) ..	2
• Lifting Equipment (Rated for at least 400 lbs.).....	1
• Additional Person .....	1
• Wooden Blocks .....	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 Contents (Figure 11)	Qty
A. Pulley Cover .....	1
B. Collar .....	1
C. Wheels .....	2
D. Axle .....	1
E. Leveling Feet .....	2
F. Chip Screen .....	1
G. Work Stop .....	1
H. Work Stop Rod .....	1
I. Vertical Work Table .....	1
J. Table Bracket .....	1
K. V-Belt 3V270 (Not Shown) .....	1
L. Motor (Not Shown) .....	1

## Hardware Bag (Not Shown)

- Flat Washers  $\frac{3}{8}$ " (Leveling Feet)..... 2
- Hex Nuts  $\frac{3}{8}$ "-16 (Leveling Feet) ..... 2
- Cotter Pins 3 x 30mm (Wheels) ..... 2
- Flat Washers  $\frac{5}{8}$ " (Wheels) ..... 4
- Flat Head Screw  $\frac{1}{4}$ "-20 x  $\frac{1}{2}$ " (Table)..... 1
- Hex Nut  $\frac{1}{4}$ "-20 (Table)..... 1
- Knob  $\frac{1}{4}$ "-20 x  $\frac{5}{8}$ " (Pulley Cover) ..... 1
- Hose Clamps  $\frac{5}{8}$ " (Coolant Hose)..... 2
- Hex Bolts  $\frac{5}{16}$ "-18 x 1" (Motor) ..... 4
- Hex Nuts  $\frac{5}{16}$ "-18 (Motor)..... 2
- Flat Washers  $\frac{5}{16}$ " (Motor)..... 2

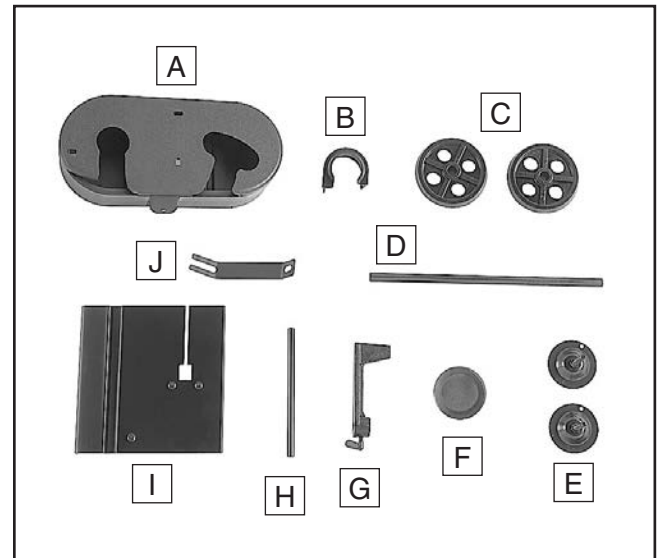


Figure 11. Box contents.



# 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.

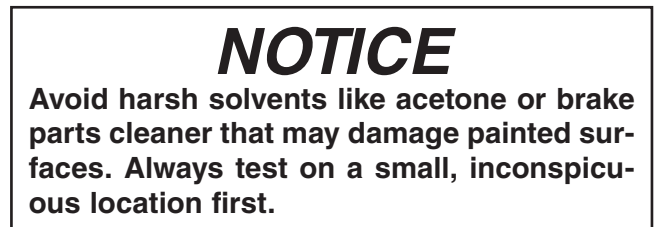
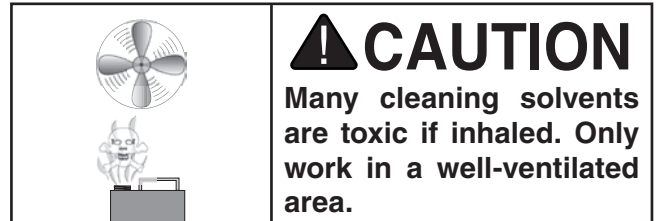
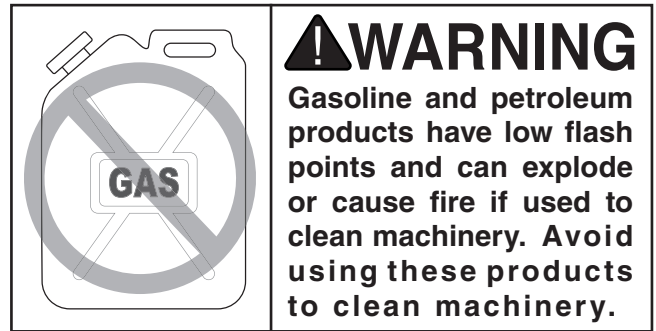
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## 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.



## 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 12. T23692 Orange Power Degreaser.



# Site Considerations

## Weight Load

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

## Space Allocation

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

**See below for required space allocation.**

	<p><b>CAUTION</b></p> <p>Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.</p>
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## Physical Environment

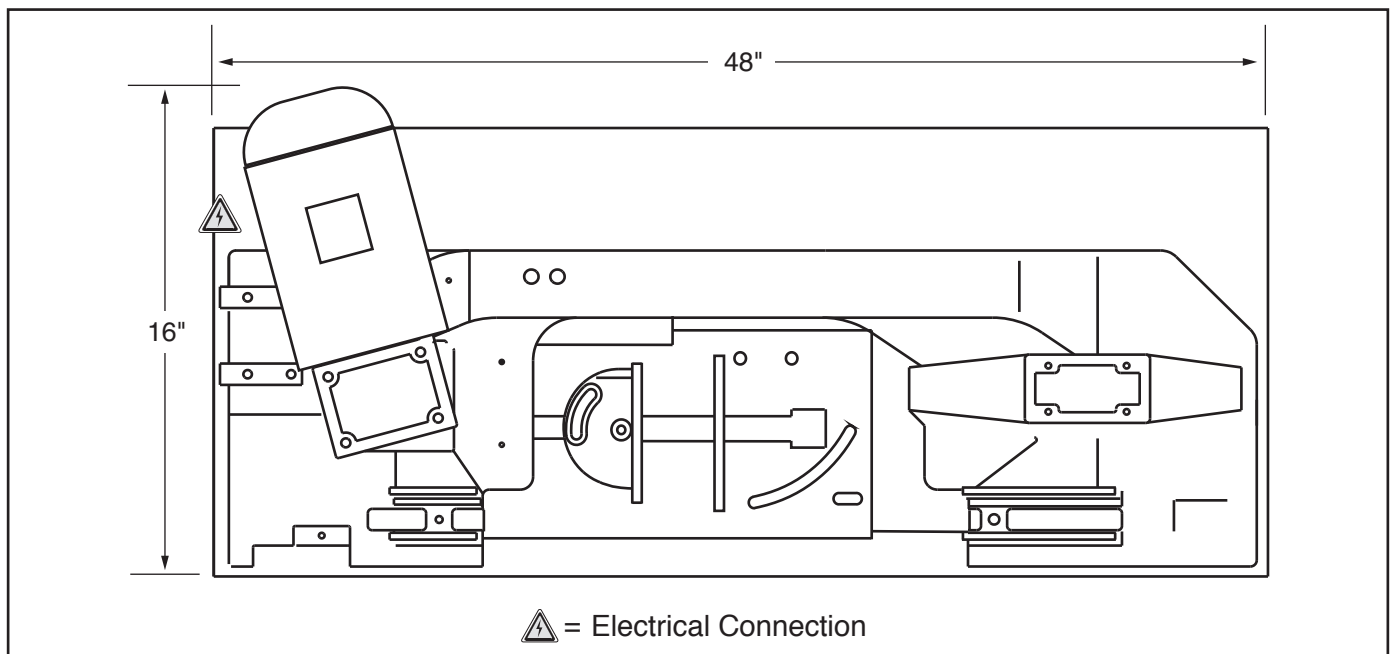
The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions 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 13.** Minimum working clearances.



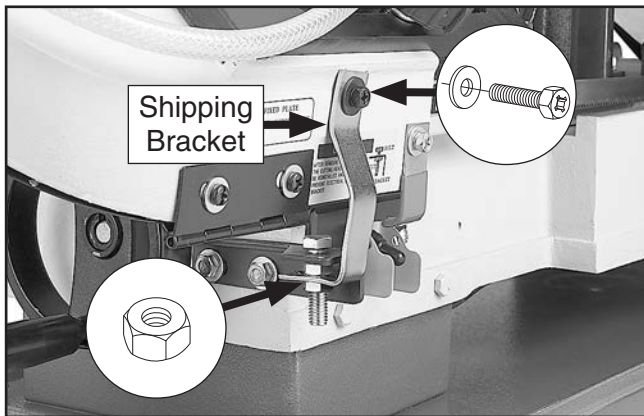
# Assembly

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:

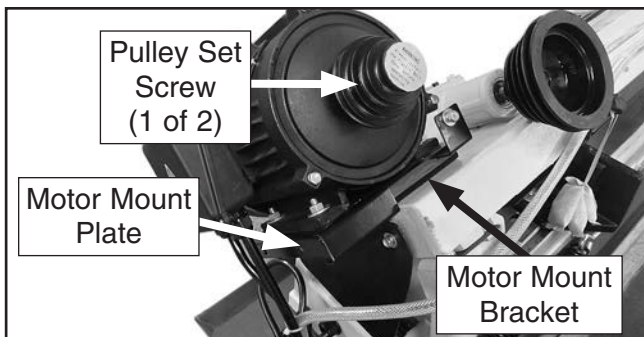
1. Remove hex bolt, flat washer, and hex nut shown in **Figure 14** to remove shipping bracket.

**Note:** Bracket helps maintain bow alignment during shipping. Store bracket in case you need to move or ship the machine later.



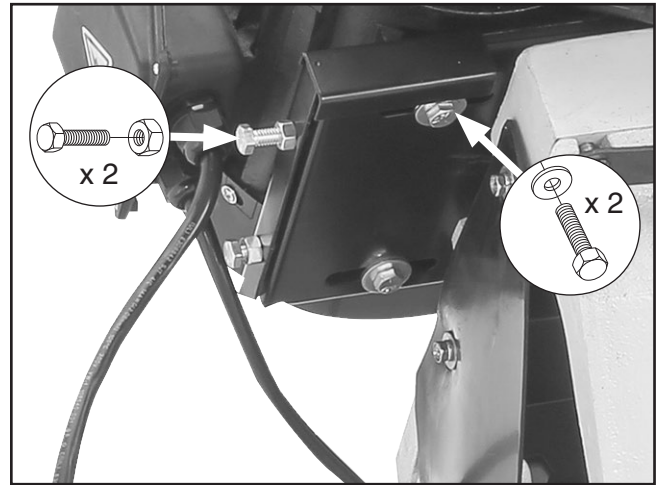
**Figure 14.** Location of shipping bracket and fasteners.

2. Remove motor from cabinet.
3. Slide motor mount plate into motor mount bracket (see **Figure 15**).

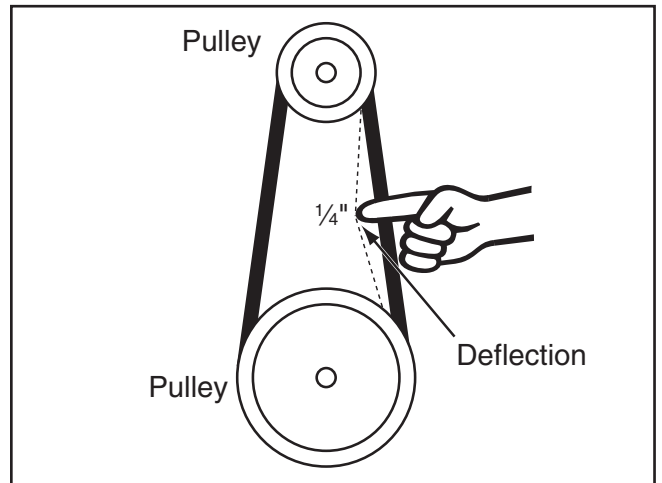


**Figure 15.** Motor installed on motor mount bracket.

4. Install V-belt onto top sheaves of pulleys.
5. Loosely thread (2)  $\frac{5}{16}$ "-18 x 1" hex bolts with  $\frac{5}{16}$ " flat washers into motor mount bracket (see **Figure 16**).
6. Thread (2)  $\frac{5}{16}$ "-18 x 1" hex bolts with  $\frac{5}{16}$ " hex nuts into side of motor mount plate (see **Figure 16**). Adjust hex bolts and motor until there is about  $\frac{1}{4}$ " of belt deflection when belt is pressed with moderate pressure between center of pulleys (see **Figure 17**).



**Figure 16.** Motor mounting fasteners installed.

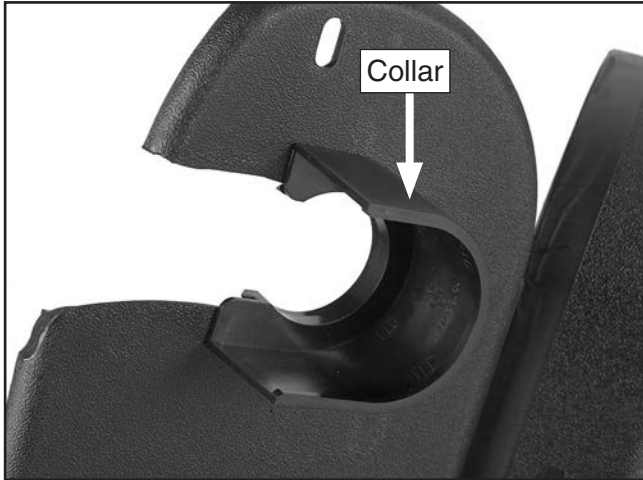


**Figure 17.** Checking belt deflection.

7. Without moving hex bolts, tighten hex nuts from **Step 6** against motor mount plate to secure motor tension.
8. Tighten hex bolts from **Step 5**.



9. Use straightedge to check pulley alignment. If pulleys are not aligned, loosen motor pulley set screws (see **Figure 15** on **Page 18**), adjust pulley, then re-tighten set screw.
10. Slide collar onto bottom side of pulley cover and snap in place, as shown in **Figure 18**.



**Figure 18.** Collar installed.

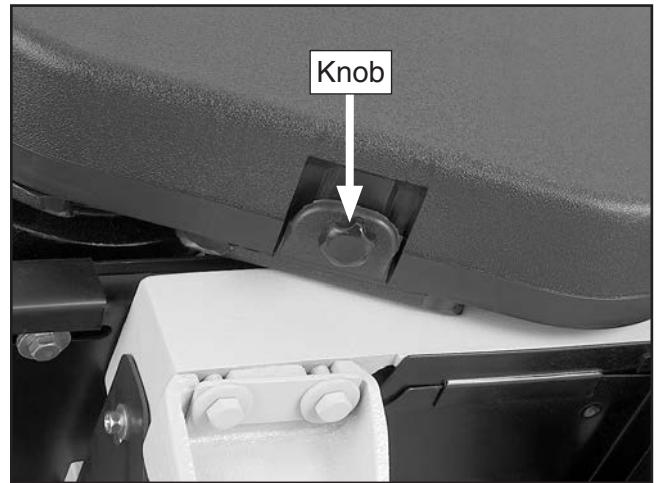
11. Remove (2) pre-installed 1/4"-20 x 1/2" hex bolts and 1/4" flat washers (see **Figure 19**).
12. Slide pulley cover over pulleys (see **Figure 19**).
13. Align holes and secure with fasteners you removed in **Step 11** (see **Figure 19**).



**Figure 19.** Pulley cover installed.

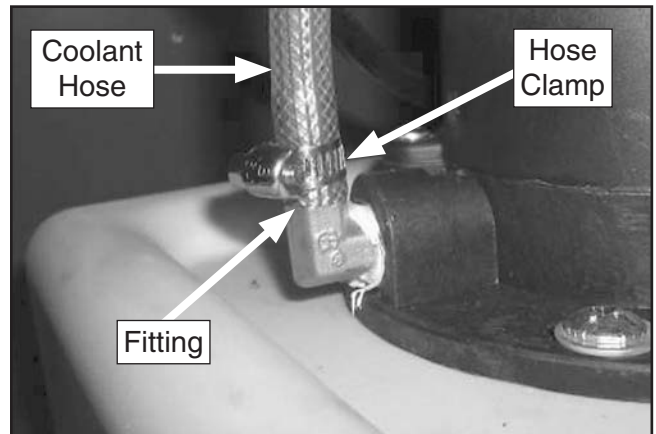


14. Close pulley cover lid and secure with 1/4"-20 x 5/8" knob (see **Figure 20**).



**Figure 20.** Secured pulley cover lid.

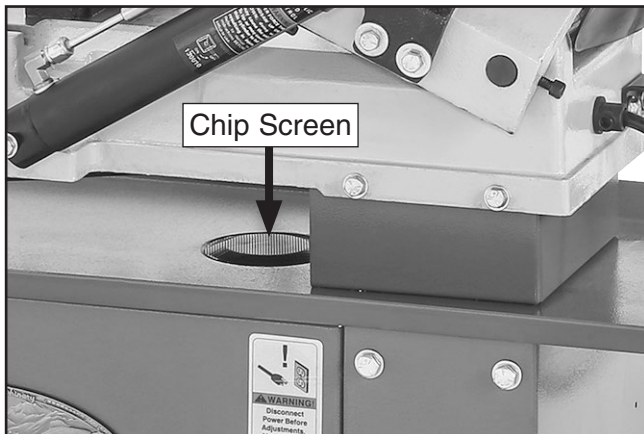
15. Move coolant tank into cabinet.
16. Push hose over coolant tank fitting and secure with hose clamp (see **Figure 21**).



**Figure 21.** Coolant hose installed.



- Place chip screen into opening shown in **Figure 22**.

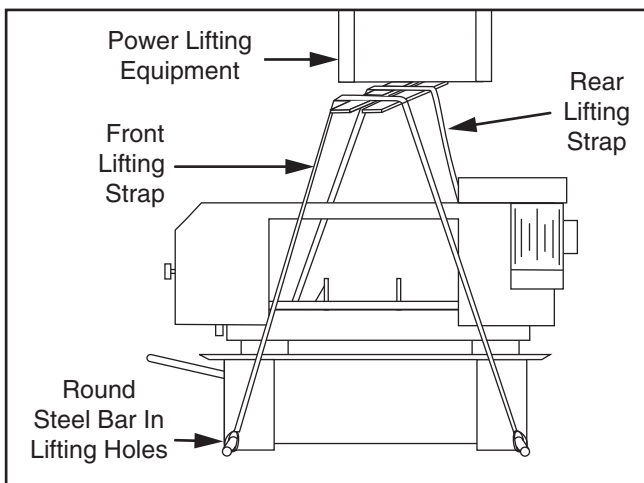


**Figure 22.** Chip screen installed.

- Unbolt machine from pallet.
- Insert round steel bar stock through (4) lifting holes in machine base (see **Figure 23**).

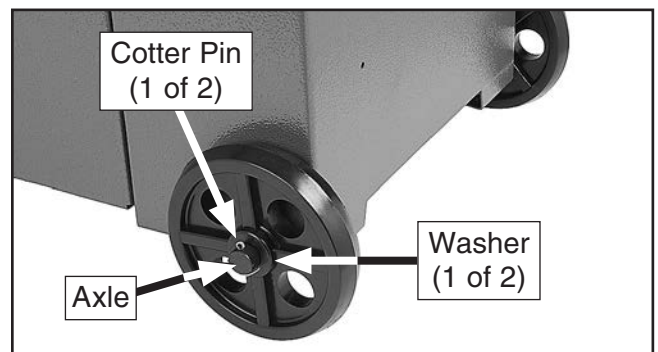
**Note:** Bar stock must be at least  $\frac{1}{2}$ " diameter and 3 feet long. Otherwise, it may not be big enough to properly support weight of machine.

- Attach lifting slings to steel bar stock and power lifting equipment (see **Figure 23**).



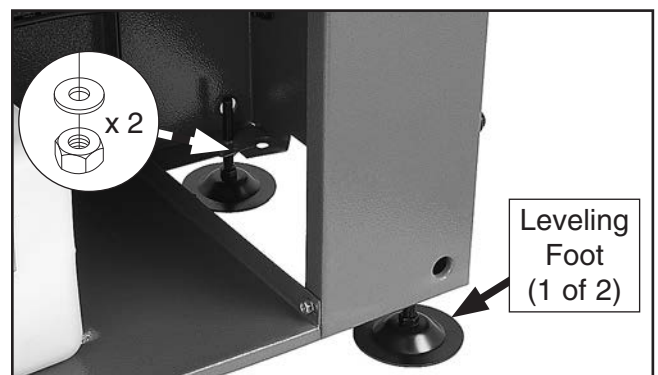
**Figure 23.** Lifting machine with forklift and lifting slings.

- With assistant helping to stabilize load, lift machine just high enough to clear pallet.
- Remove pallet, then place wooden blocks under machine so it will be supported 4" off the ground, then lower machine.
- Remove lifting slings and steel bar stock.
- Slide axle through rear holes in bottom of cabinet.
- Slide (1) flat washer onto each end of axle, followed by (1) wheel and another washer. Secure wheels with cotter pins, as shown in **Figure 24**.



**Figure 24.** Wheels secured with cotter pin.

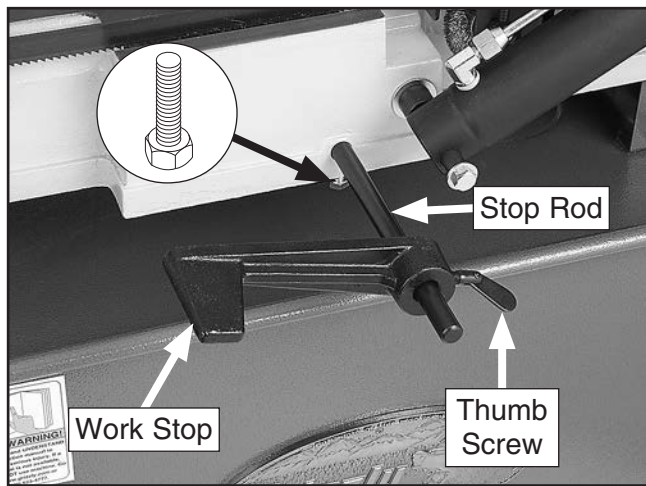
- Install (1)  $\frac{3}{8}$ "-16 hex nut and  $\frac{3}{8}$ " flat washer onto each leveling foot, then thread feet into front base of cabinet, as shown in **Figure 25**.



**Figure 25.** Leveling feet attached.



25. With help of an assistant, remove bandsaw from blocks.
26. Adjust feet to level bandsaw as needed, then tighten hex nuts against machine base to secure.
27. Insert work stop rod through hole in base and lock in place with hex bolt (see **Figure 26**).
28. Slide work stop over rod, then tighten thumb screw to secure (see **Figure 26**).



**Figure 26.** Work stop installed.

## 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 motors power up and run correctly, and 2) the automatic shut-off tab shuts down power.

## **!**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.

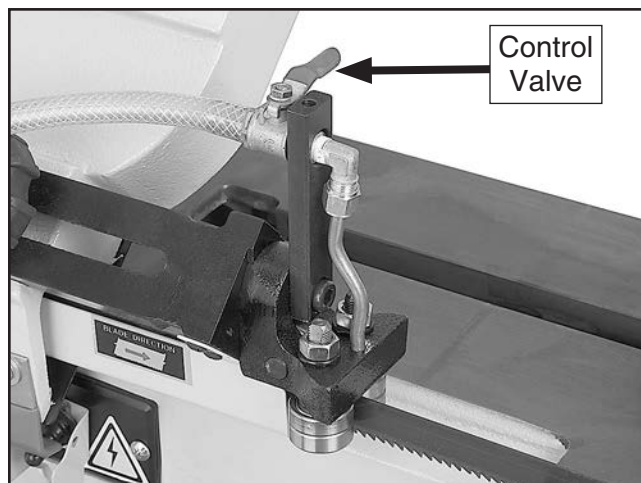
To test run machine:

1. Clear all setup tools away from machine.
2. Fill cutting fluid reservoir as described in **Cutting Fluid System** section on **Page 38**.

## **NOTICE**

**NEVER** turn **ON** coolant pump without cutting fluid in the reservoir or when cutting fluid is low or you will overheat pump and void warranty!

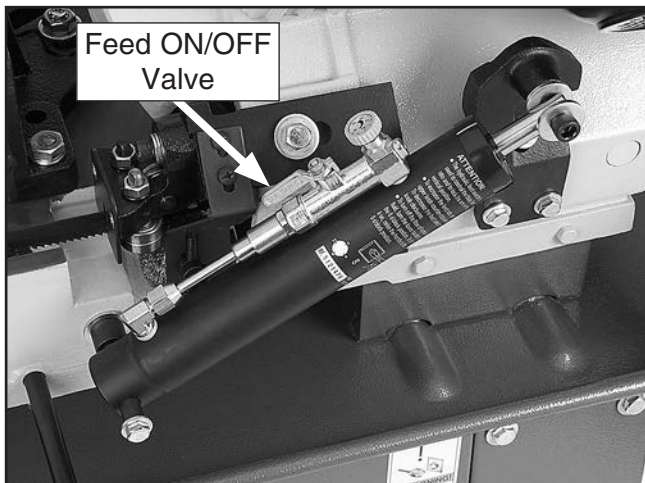
3. Open coolant control valve (see **Figure 27**).



**Figure 27.** Location of coolant control valve.



4. Raise bow about halfway, then close feed ON/OFF valve to lock bow in place (see **Figure 28**).

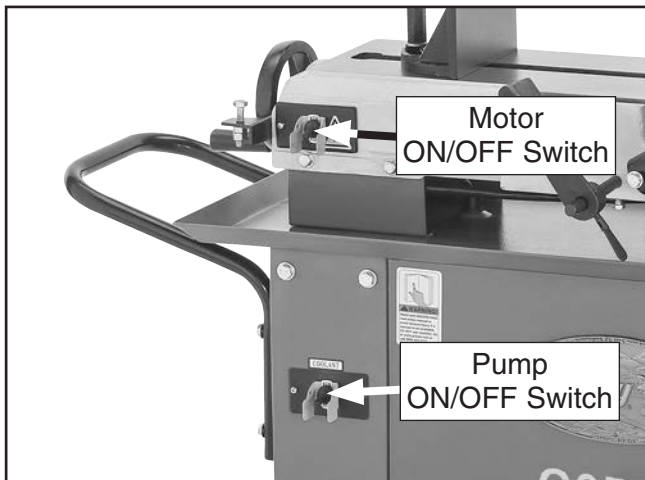


**Figure 28.** Location of feed ON/OFF valve.

5. Connect machine to power supply.
6. Use motor ON/OFF switch (see **Figure 29**) to turn machine **ON** and verify motor operation.

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

7. Use pump ON/OFF switch (see **Figure 29**) to turn coolant pump **ON**. Coolant should flow through blade guide and onto blade.



**Figure 29.** Location motor and pump ON/OFF switches.

8. Turn **OFF** pump.

9. Open feed ON/OFF valve to fully lower headstock. When headstock is in lowest position, automatic shut-off tab should switch power **OFF**.

- If shut-off tab *does* switch power **OFF**, tab is functioning correctly. Congratulations! Test Run is complete.
- If shut-off tab *does not* switch power **OFF**, tab is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

## Inspections & Adjustments

The following list of adjustments were performed at the factory before the machine was shipped:

- Blade Tension & Tracking .....**Page 45**
- Squaring the Blade.....**Page 46**
- Blade Guide Bearings .....**Page 46**

Be aware that these can change during the shipping process. Pay careful attention to these adjustments when first operating the machine. If you find that the adjustments are not set to your personal preferences, re-adjust them.



# SECTION 4: OPERATIONS

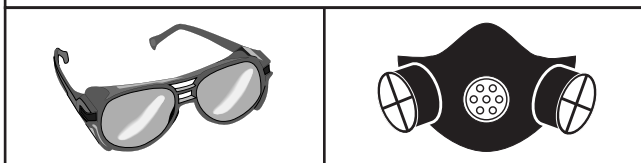
## Operation Overview

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.

	<p><b>!WARNING</b> To reduce your risk of serious injury, read this entire manual <b>BEFORE</b> using machine.</p>
--	--

<p><b>!WARNING</b> To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.</p>
--



<p><b>NOTICE</b> If you are not experienced with this type of machine, <b>WE STRONGLY RECOMMEND</b> 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.</p>
--

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

1. Examines workpiece to make sure it is suitable for cutting.
2. Adjusts blade tilt, if necessary, to correct angle of desired cut.
3. Adjusts fence to desired width of cut, then locks it in place.
4. Checks outfeed side of machine for proper support and to make sure workpiece can safely pass all the way through blade without interference.
5. Puts on personal protective equipment, and locates push sticks if needed.
6. Starts saw.
7. Feeds workpiece all the way through blade while maintaining firm pressure on workpiece against table and fence, and keeping hands and fingers out of blade path and away from blade.
8. Stops machine.

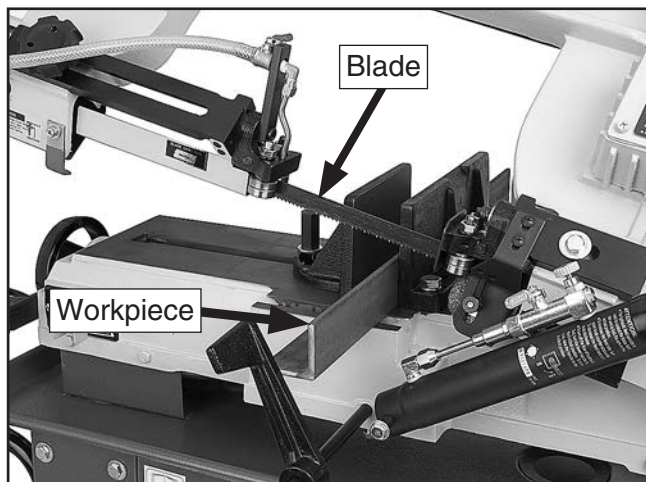


# Operation Tips

The following tips will help you safely and effectively operate your bandsaw, and help you get the maximum life out of your saw blades.

## Tips for horizontal cutting:

- Use work stop to quickly and accurately cut multiple pieces of stock to same length.
- Clamp material firmly in vise jaws to ensure a straight cut through the material.
- Let blade reach full speed before engaging workpiece (see **Figure 30**). Never start a cut with blade in contact with workpiece.



**Figure 30.** Correct blade starting position.

## **NOTICE**

Loosen blade tension at end of each day to prolong blade life.

- Wait until blade has completely stopped before removing workpiece from vise, and avoid touching cut end—it could be very hot!
- Support long workpieces so they won't fall when cut, and flag ends of workpieces to alert passers-by of potential danger.
- Position blade guides approximately 1/4" from workpieces to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

## Tips for vertical cutting:

- Workpieces that cannot be properly supported or stabilized without a vise should not be cut in vertical position. Examples are chains, cables, round or oblong-shaped workpieces, workpieces with internal or built-in moving or rotating parts, etc.
- Make sure that vertical table assembly is securely fastened to bandsaw frame so it will adequately support workpiece.
- Always keep your fingers away from blade and always hold workpiece securely with appropriate clamping device.
- Adjust blade guides as close as possible to workpiece to minimize side-to-side blade movement.



# Inspecting Workpieces

Some metal workpieces are not safe to cut with a metal cutting bandsaw; instead, a different tool or machine should be used.

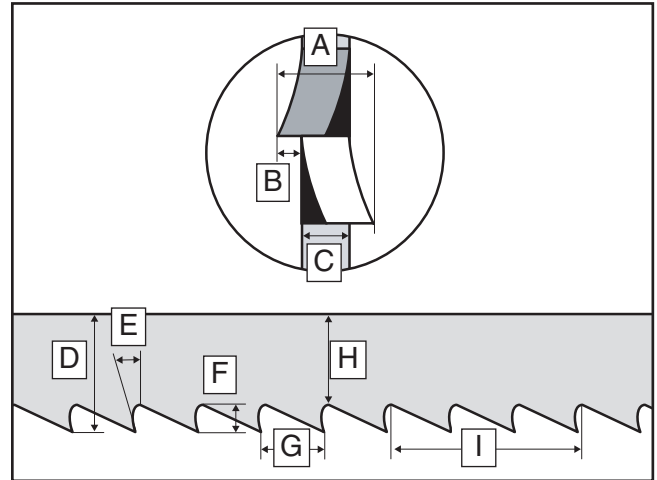
**Before cutting, inspect the material for any of the following conditions and take the necessary precautions:**

- **Small or Thin Workpieces:** Small or thin workpieces may be damaged during cutting—avoid cutting these workpieces if possible. If you must cut a small or thin workpiece, attach it to or clamp it between larger scrap pieces that will both support the workpiece through the cut. Some thin sheet metals will not withstand the forces from this bandsaw during cutting; instead, use a shear, nibblers, or sheet metal nippers to cut these pieces.
- **Unstable Workpieces:** Workpieces that cannot be properly supported or stabilized with the vise should not be cut on this bandsaw. Examples are chains, cables, workpieces with internal or built-in moving or rotating parts, etc.
- **Material Hardness:** Always factor in the hardness of the metal before cutting it. Hardened metals will take longer to cut, may require lubrication, and may require a different type of blade in order to efficiently cut them.
- **Tanks, Cylinders, Containers, Valves, Etc:** Cutting into containers that are pressurized or contain gasses or liquids can cause explosions, fires, caustic burns, or machine damage. Avoid cutting any of these types of containers unless you have verified that the container is empty and it can be properly supported during a cut.
- **Magnesium:** Pure magnesium burns easily. Cutting magnesium with a dull blade can create enough friction to ignite the small magnesium chips. Avoid cutting magnesium if possible.

# Selecting Blades

Selecting the right blade for the cut requires a knowledge of various blade characteristics.

## Blade Terminology



**Figure 31.** Bandsaw blade terminology.

- A. Kerf:** Amount of material removed by blade during cutting.
- B. Tooth Set:** Amount each tooth is bent left or right from blade.
- C. Gauge:** Thickness of blade.
- D. Blade Width:** Widest point of blade measured from tip of tooth to back edge of blade.
- E. Tooth Rake:** Angle of tooth face from line perpendicular to length of blade.
- F. Gullet Depth:** Distance from tooth tip to bottom of curved area (gullet).
- G. Tooth Pitch:** Distance between tooth tips.
- H. Blade Back:** Distance between bottom of gullet and back edge of blade.
- I. Blade Pitch or TPI:** Number of teeth per inch measured from gullet to gullet.



## Blade Length

Measured by the blade circumference, blade lengths are usually unique to the brand of bandsaw and the distance between the wheels.

<b>Model</b>	<b>Blade Length</b>
G0561 .....	93"

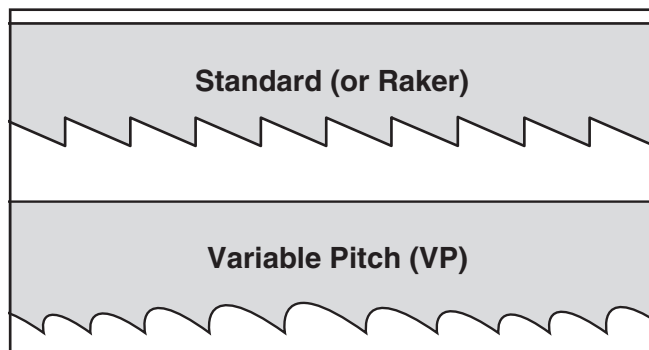
## Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point).

<b>Model</b>	<b>Blade Width</b>
G0561 .....	$\frac{3}{4}$ "

## Tooth Type

The most common tooth types are described as follows, and illustrated in **Figure 32**.



**Figure 32.** Bandsaw blade tooth types.

**Standard or Raker:** Equally spaced teeth set at "0" rake angle. Recommended for all purpose use.

**Variable Pitch (VP):** Varying gullet depth and tooth spacing, "0" rake angle, excellent chip removing capacity, and smooth cutting.

## Blade Pitch (TPI)

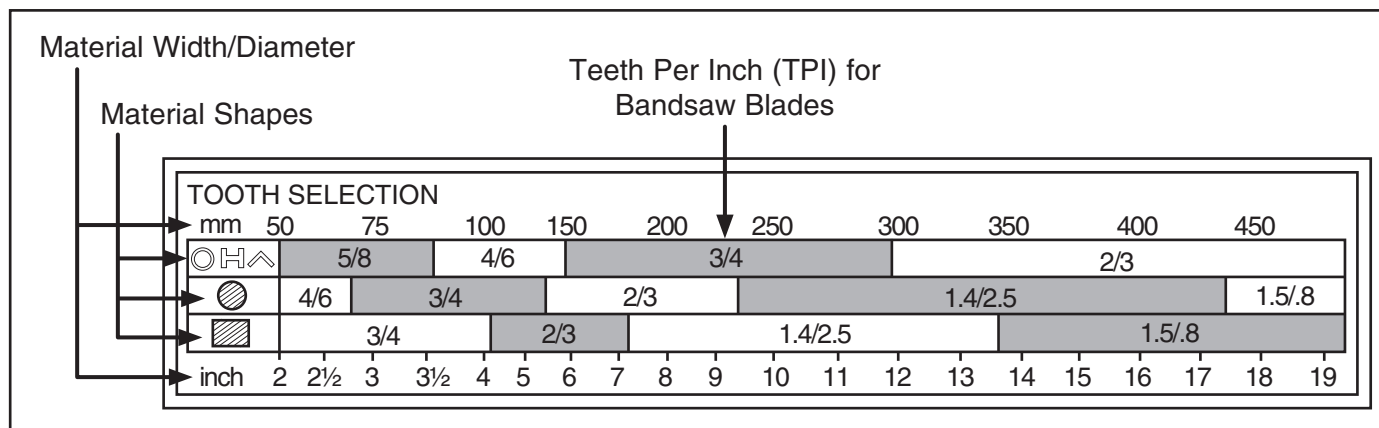
The chart below is a basic starting point for choosing teeth per inch (TPI) for variable pitch blades and standard raker set bi-metal blades/HSS blades. However, for exact specifications of bandsaw blades that are correct for your operation, contact the blade manufacturer.

### To select correct blade pitch:

1. Measure material thickness. This measurement is distance from where each tooth enters workpiece to where it exits workpiece.
2. Refer to "Material Width/Diameter" row of blade selection chart in **Figure 33**, and read across to find workpiece thickness you need to cut.
3. Refer to "Material Shapes" row and find shape of material to be cut.
4. In applicable row, read across to right and find box where row and column intersect. Listed in the box is minimum TPI recommended for variable tooth pitch blades.

The TPI range is represented by a "/" between numbers. For example, 3/4 TPI is the same as 3–4 TPI.

The "Cutting Speed Rate Recommendation" chart, which is located on the machine just below the Blade Pitch Chart, offers guidelines for various metals, given in feet per minute (FPM). Refer to **Blade Speed Chart** section on **Page 35** for further details.



**Figure 33.** General guidelines for blade selection and speed chart.

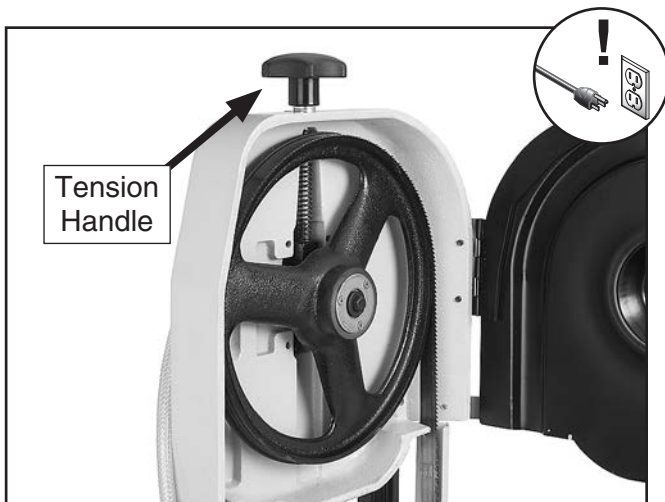


# Changing Blade

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

## To change blade:

1. DISCONNECT MACHINE FROM POWER!
2. Raise bow of bandsaw to vertical position, close feed ON/OFF valve, and open wheel access cover.
3. Remove blade guards.
4. Loosen tension handle shown in **Figure 34** and slip blade off of wheels.



**Figure 34.** Location of tension handle.

## **⚠ CAUTION**

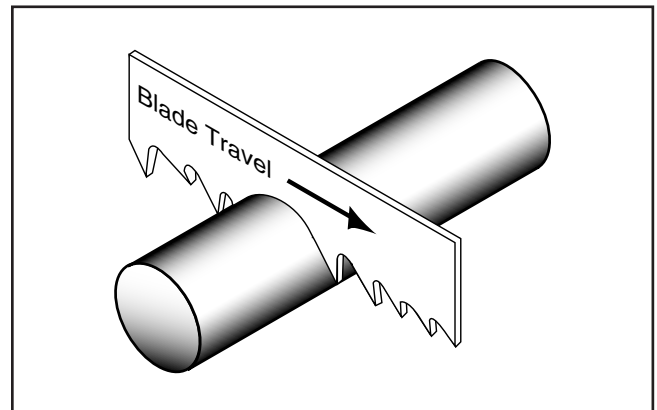
**CUTTING HAZARD!** Bandsaw blades are sharp and awkward to hold. Protect your hands with heavy gloves when handling blade.

5. Install new blade around bottom wheel and through both blade guide bearings.
6. With blade around bottom wheel, slip it around top wheel as shown in **Figure 35**, keeping blade between blade guide bearings.



**Figure 35.** Installing blade.

**Note:** It is possible to flip blade inside out, in which case blade will be installed in wrong direction. Check to make sure blade teeth are facing toward workpiece, as shown in **Figure 36**. Some blades have a directional arrow as a guide.



**Figure 36.** Blade teeth facing workpiece.

7. When blade is around both wheels, adjust so back of blade is against shoulder of wheels.
8. Complete blade change by following steps in **Adjusting Blade Tension** on **Page 28**.



# Adjusting Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting. The Model G0561 features a blade tension indicator to assist you with blade tensioning.

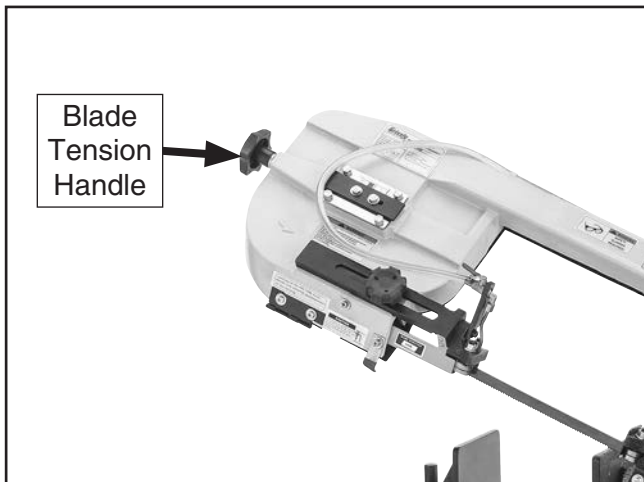
Two major signs that you do not have proper blade tension are: 1) the blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too tight.

## **NOTICE**

**Loosen blade tension at end of each day to prolong blade life.**

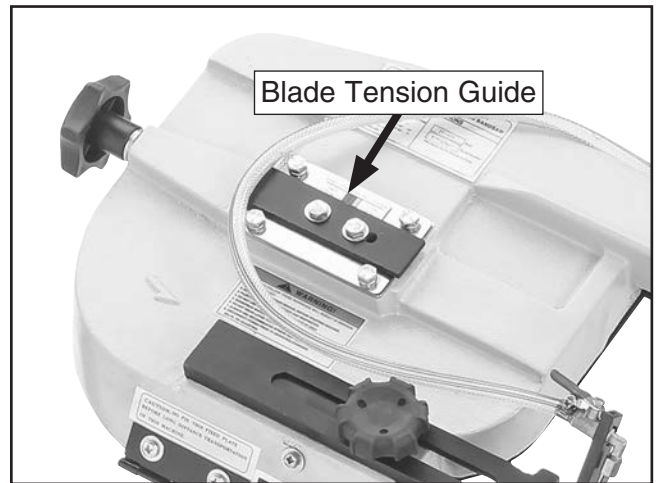
### To adjust blade tension:

1. Turn blade tension handle clockwise to tension blade (see **Figure 37**).



**Figure 37.** Location of blade tension handle.

2. Tension blade until blade tension guide indicator is in green zone (see **Figure 38**).



**Figure 38.** Location of blade tension guide.

3. To fine tune blade tension, use a blade tensioning gauge, like one found in **SECTION 5: ACCESSORIES** on **Page 39**. Follow instructions included with your gauge and blade manufacturer's recommendations on blade tension.



# Blade Care & Break-In

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## Blade Care

To prolong blade life, always use a blade with the proper width, set, type, and pitch for each application. Maintain the appropriate feed rate, feed pressure, and blade speed, and pay attention to the chip characteristics (Refer to **Blade Speed Chart** on **Page 35** and **Chip Inspection Chart** on **Page 30**). Keep your blades clean, since dirty or gummed up blades pass through the cutting material with much more resistance than clean blades, causing unnecessary heat.

## Blade Break-In

The tips and edges of a new blade are extremely sharp. Cutting at too fast of a feed rate or too slow of a blade speed can fracture these tips and edges, quickly dulling the blade. Properly breaking in a blade allows these sharp edges to wear without fracturing, thus keeping the blade sharp longer. Below is a typical break-in procedure. For aftermarket blades, refer to the manufacturer's break-in procedure to keep from voiding the warranty.

Use the **Chip Inspection Chart** on **Page 30** as a guide to evaluate the chips and ensure that the optimal blade speed and feed rate are being used.

### To properly break in new blade:

1. Choose correct speed for blade and material type.
2. Reduce feed pressure by half for first 50–100 in<sup>2</sup> of material cut.
3. To avoid twisting blade when cutting, adjust feed pressure when total width of blade is in cut.

# Blade Breakage

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Many conditions may cause a bandsaw blade to break. Some of these conditions are unavoidable and are the natural result of the stresses placed on the bandsaw; other causes of blade breakage are avoidable.

### The most common causes of avoidable blade breakage are:

- Faulty alignment or adjustment of the blade guides.
- Feeding blade through the workpiece too fast.
- Dull or damaged teeth.
- Improperly-tensioned blade.
- Blade guide assembly set too far away from workpiece. Adjust the blade guide assembly approximately 1/4" away from workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Leaving the blade tensioned when not in use.
- Using the wrong blade pitch (TPI) for the workpiece thickness. The general rule of thumb is to have no fewer than three teeth in contact with the workpiece when starting a cut and at all times during cutting.



# Chip Inspection Chart

The best method of evaluating the performance of your metal cutting operation is to inspect the chips that are formed from cutting. Refer to the chart below for chip inspection guidelines.







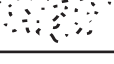

Chip Appearance	Chip Description	Chip Color	Blade Speed	Feed Rate/ Pressure	Other Actions
	Thin & Curled	Silver	Good	Good	
	Hard, Thick & Short	Brown or Blue	Increase	Decrease	
	Hard, Strong & Thick	Brown or Blue	Increase	Decrease	
	Hard, Strong, Curled & Thick	Silver or Light Brown	Good	Decrease Slightly	Check Blade Pitch
	Hard, Coiled & Thin	Silver	Increase	Decrease	Check Blade Pitch
	Straight & Thin	Silver	Good	Increase	
	Powdery	Silver	Decrease	Increase	
	Coiled, Tight & Thin	Silver	Good	Decrease	Check Blade Pitch

Figure 39. Chip inspection chart.

## Adjusting Blade Guides

The blade guides should be positioned approximately 1/4" away from workpiece if possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

**To adjust blade guides:**

1. DISCONNECT MACHINE FROM POWER!
2. Loosen blade guide knob shown in **Figure 40**.
3. Slide front blade guide as close to workpiece as possible.
4. Tighten knob.

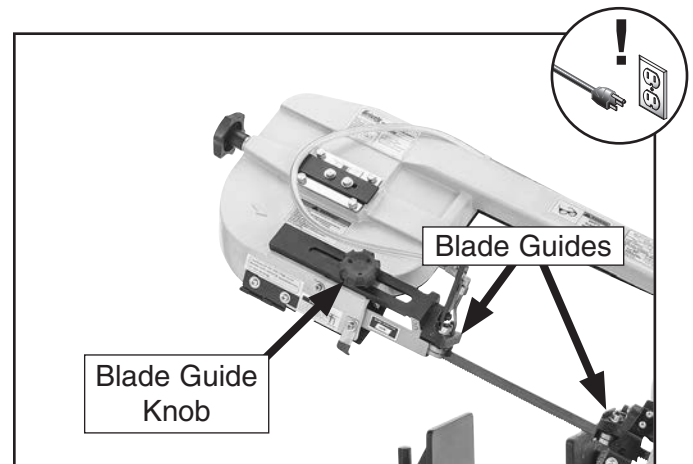


Figure 40. Location of blade guide knob.



# Adjusting Feed Rate

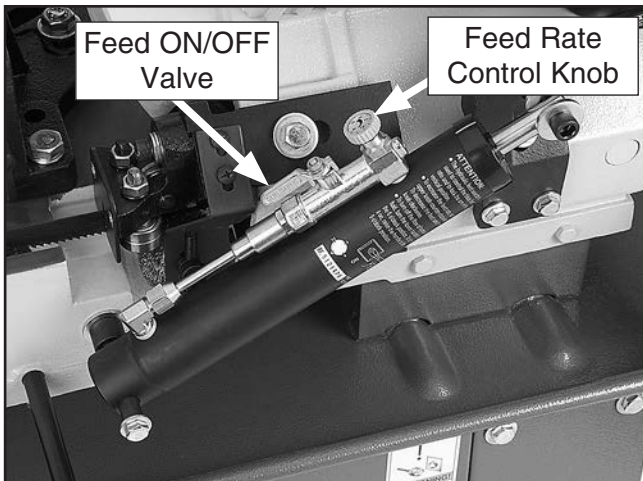
The speed at which the saw blade will cut through a workpiece is controlled by blade type, feed rate, and feed pressure.

**Note:** *If a lubricant is used on the cut, the feed rate can be increased by approximately 15%.*

<b>Tool Needed</b>	<b>Qty</b>
Wrench or Socket 14mm .....	1

## To adjust feed rate:

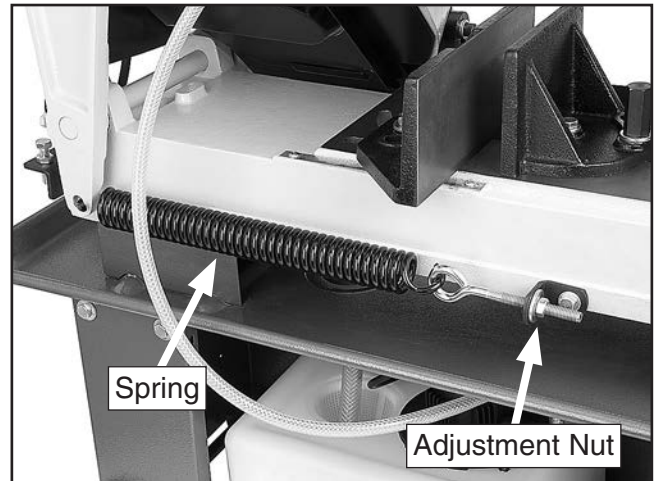
1. Raise bow to maximum height to remove spring tension. Close feed ON/OFF valve to lock bow in place (see **Figure 41**).



**Figure 41.** Location of feed ON/OFF valve and feed rate control valve.

2. Adjust feed pressure tension spring by rotating adjustment nut (see **Figure 42**). Tighten enough to remove play but not enough to apply tension to spring.

**Note:** *This spring adjustment is an initial setting. Depending on cutting circumstances, you will have to fine-tune the feed pressure with this adjustment. Increasing the spring tension will reduce the feed pressure.*



**Figure 42.** Location of adjustment nut.

3. Clamp workpiece in table vise.
4. Open feed ON/OFF valve, allow bow to lower until blade is a few inches above workpiece, then close valve.
5. With correct saw blade and blade speed selected, turn saw and coolant pump **ON**.
6. Open feed ON/OFF valve, then slowly rotate feed rate control knob clockwise to a slow feed rate until saw begins to cut workpiece (see **Figure 41**).
7. Observe chips that exit cut, and increase or decrease feed rate according to chip characteristics.
  - If chips are tightly curled, warm shavings, brown to black in color, there is too much downward pressure.
  - If chips are blue looking chips, blade speed is too high.
  - If chips are thin and powder-like, there is insufficient feed pressure. This will dull blade rapidly.
  - The best cut and feed rate will give you evenly shaped spiraled curls with very little color change, if any at all.



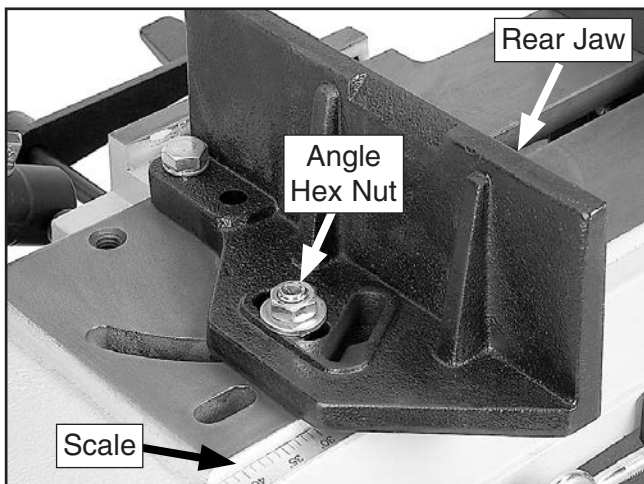
# Using Vise

The vise can hold material up to 12 inches wide and be set to cut angles from 0 to 45 degrees.

**Tool Needed** Qty  
Wrench or Socket 3/4" ..... 1

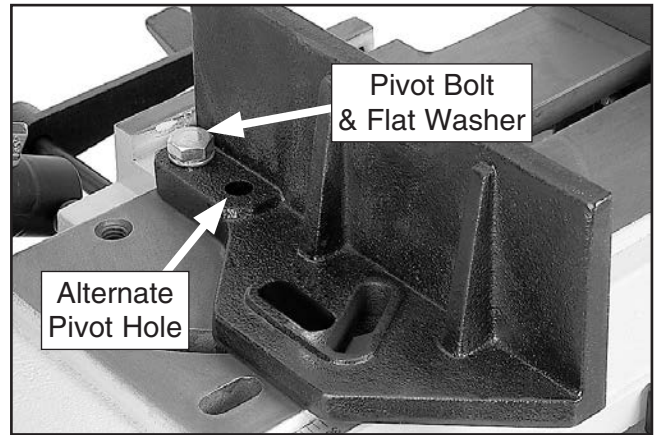
**To use vise:**

1. Loosen angle hex nut on rear jaw shown in **Figure 43**.
2. Use scale to set angle of rear jaw (see **Figure 43**).
  - If desired angle *can* be reached with rear vise jaw in current position, tighten angle hex nut to secure. Proceed to **Step 7**.
  - If desired angle *cannot* be reached with rear vise jaw in current position, proceed to **Step 3**.



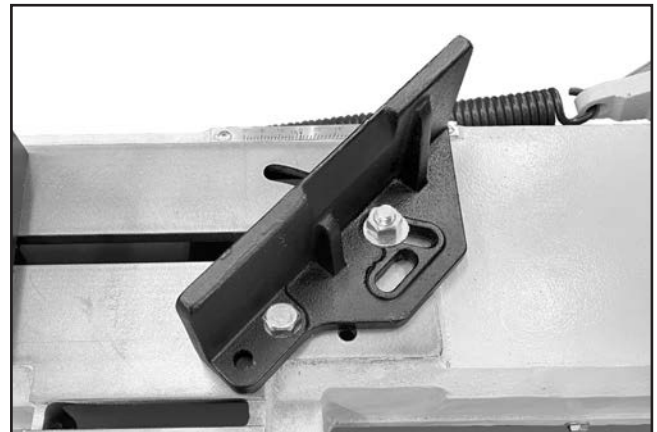
**Figure 43.** Location of rear jaw adjustment components.

3. Remove angle hex nut, flat washer, and carriage bolt.
4. Remove pivot bolt and flat washer shown in **Figure 44**.
5. Move rear vise jaw so pivot bolt and flat washer can secure it through alternate pivot hole (see **Figure 44**).



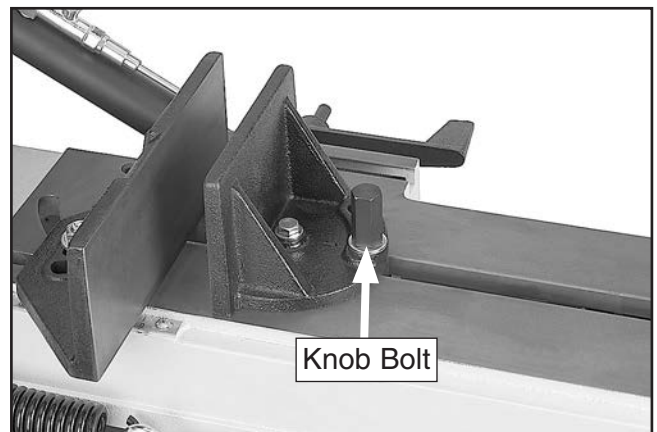
**Figure 44.** Location of pivot bolt and alternate pivot hole.

6. Use scale to set angle of rear jaw, then secure with carriage bolt, flat washer, and angle hex nut removed in **Step 3** (see **Figure 45**).



**Figure 45.** Rear jaw positioned in alternate location.

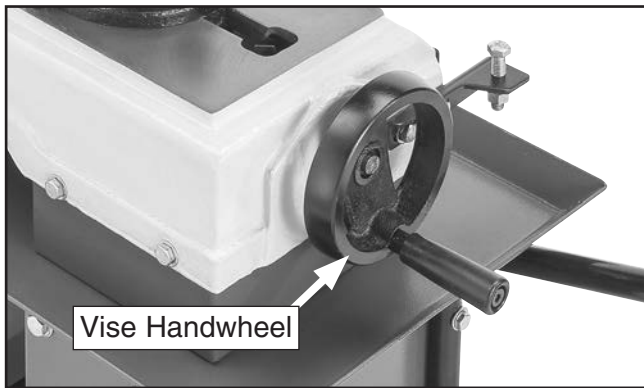
7. Loosen knob bolt in **Figure 46** on opposite jaw so jaw can float, and match angle of workpiece.



**Figure 46.** Vise jaw knob bolt.



- Use vise handwheel to tighten vise against workpiece (see **Figure 47**).



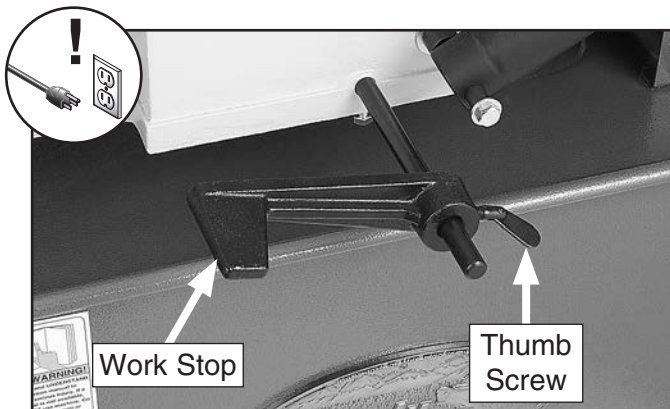
**Figure 47.** Location of vise handwheel.

## Adjusting Work Stop

The Model G0561 is equipped with a work stop for repetitive cutting operations. This stop will need to be adjusted any time it is removed or repositioned, or anytime you change the cutting length.

### To adjust work stop:

- DISCONNECT MACHINE FROM POWER!
- Measure and mark workpiece for cut.
- Clamp workpiece in vise and adjust to desired angle, aligning cutting line with cut mark.
- Loosen thumb screw shown in **Figure 48** and adjust work stop until it contacts workpiece. Tighten thumb screw to secure work stop.



**Figure 48.** Location of work stop and thumb screw.

## Changing Blade Speed

The Model G0561 is capable of blade speeds of 90, 135, 195, and 255 FPM (Feet Per Minute). To adjust the speed, position the V-belt on the pulleys that will provide your desired speed setting.

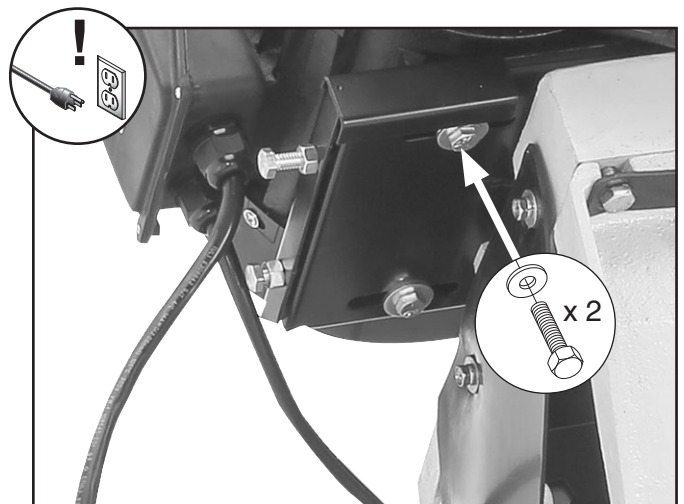
(Refer to **Blade Speed Chart** on **Page 35** for blade speed guidelines for various metals.)

### Items Needed

Items Needed	Qty
Wrench or Socket 1/2" .....	1
Replacement V-Belt (#P0561211) .....	As Needed
Open-End Wrench 1/2" .....	1

### To change blade speeds:

- DISCONNECT MACHINE FROM POWER!
- Determine blade speed for your cut (refer to **Blade Speed Chart** on **Page 35**).
- Open pulley cover.
- Loosen hex bolts shown in **Figure 49**.

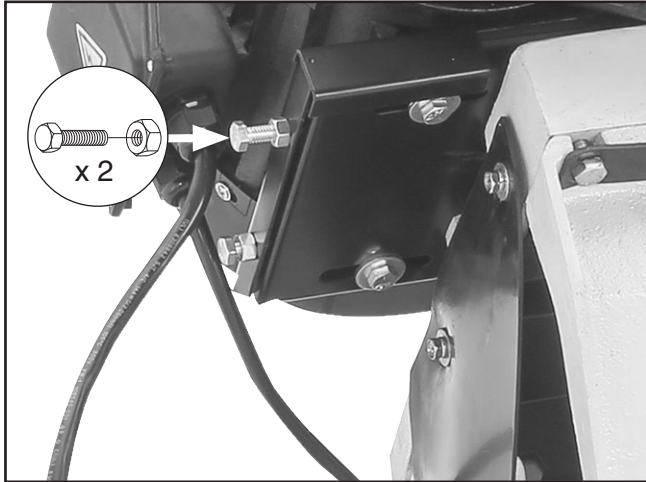


**Figure 49.** Location of motor mount hex bolts.



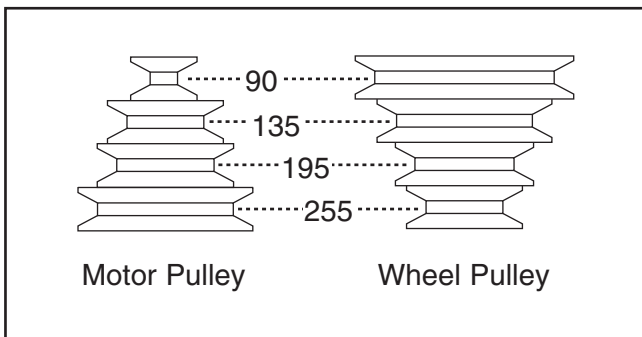
- Loosen hex nuts shown in **Figure 50**, then tighten hex bolts to push motor toward spindle pulley and slacken V-belt.

— If belt is cracked, frayed, or worn, remove it, then install a new belt.



**Figure 50.** Belt tension fasteners.

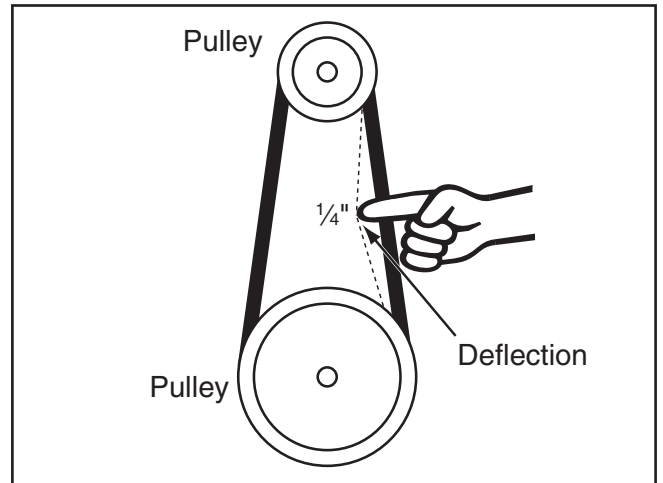
- Position V-belt on pulleys for desired FPM (see **Figure 51**).



**Figure 51.** Illustration of V-belt placement for FPM selection.

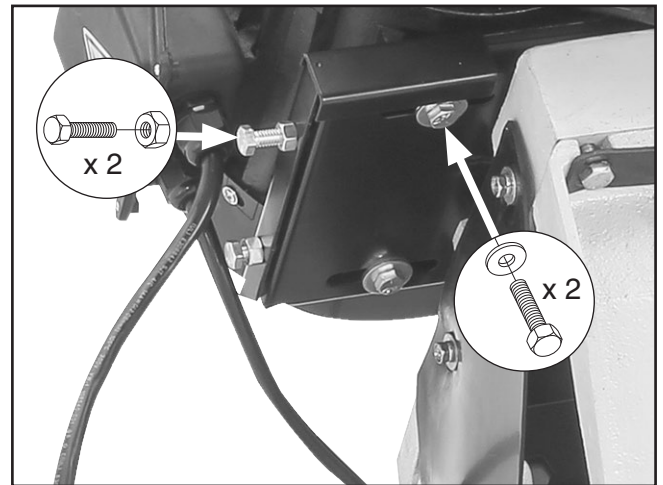
- Loosen hex bolts from **Step 5**.

- Adjust motor position until there is approximately  $\frac{1}{4}$ " belt deflection when moderate pressure is applied between pulleys (see **Figure 52**).



**Figure 52.** Checking belt deflection.

- Tighten hex bolts in **Figure 53**, then tighten hex nuts against motor mount to secure.



**Figure 53.** Location of motor mount hex bolts.

- Close pulley cover.



# Blade Speed Chart

The chart in **Figure 54** offers blade speed guidelines for various metals, given in feet per minute (FPM) and meters per minute (M/Min). Choose the closest available speed on the machine, then adjust the feed rate as necessary, using the appearance of the chips produced as a guide. Refer to the **Chip Inspection Chart** on **Page 30** for recommendations on adjusting feed rate or blade speed based on the appearance of the chips produced.

Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)	Material	Speed FPM (M/Min)
Carbon Steel	196~354 (60) (108)	Tool Steel	203 (62)	Alloy Steel	111~321 (34) (98)	Free Machining Stainless Steel	150~203 (46) (62)
Angle Steel	180~220 (54) (67)	High-Speed Tool Steel	75~118 (25) (36)	Mold Steel	246 (75)	Gray Cast Iron	108~225 (33) (75)
Thin Tube	180~220 (54) (67)	Cold-Work Tool Steel	95~213 (29) (65)	Water-Hardened Tool Steel	242 (74)	Ductile Austenitic Cast Iron	65~85 (20) (26)
Aluminum Alloy	220~534 (67) (163)	Hot-Work Tool Steel	203 (62)	Stainless Steel	85 (26)	Malleable Cast Iron	321 (98)
Copper Alloy	229~482 (70) (147)	Oil-Hardened Tool Steel	203~213 (62) (65)	CR Stainless Steel	85~203 (26) (62)	Plastics & Lumber	220 (67)

**Figure 54.** Blade speed chart.



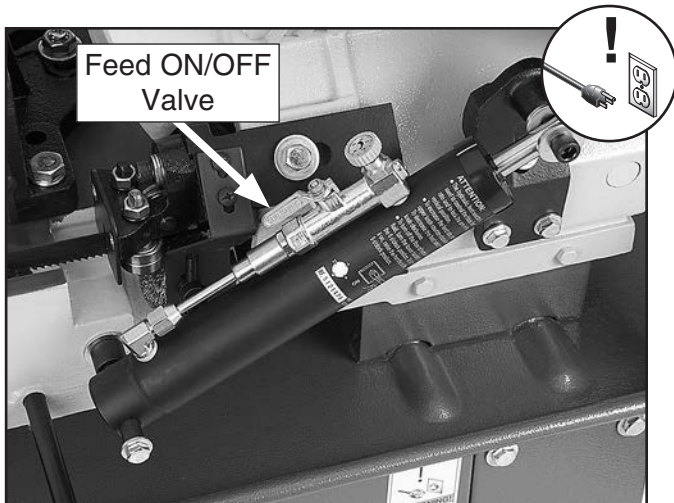
# Vertical Operation

The Model G0561 can be set up for vertical cutting operations.

Items Needed	Qty
Vertical Work Table .....	1
Table Bracket.....	1
Phillips Head Screwdriver #2 .....	1
Wrench or Socket $\frac{7}{16}$ " .....	1
Flat Head Screw $\frac{1}{4}$ "-20 x $\frac{1}{2}$ " .....	1
Hex Nut $\frac{1}{4}$ "-20 .....	1
Square .....	1
Level .....	1
Open-End Wrenches 14mm .....	2

## To operate machine in vertical position:

1. DISCONNECT MACHINE FROM POWER!
2. Raise bow to maximum height, then close feed ON/OFF valve to lock bow in place (see **Figure 55**).



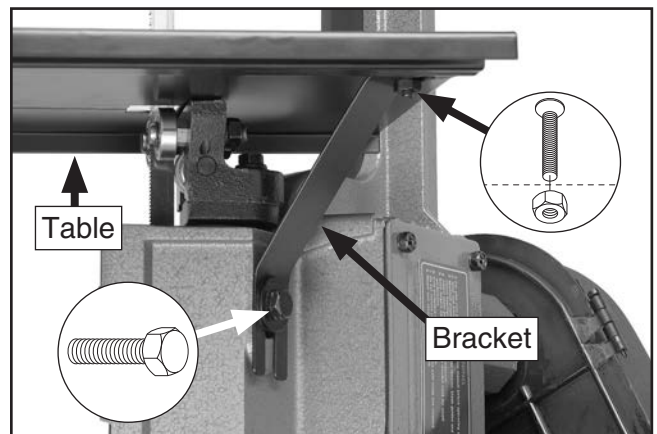
**Figure 55.** Location of feed ON/OFF valve.

3. Remove (2) flat head screws and blade guide cover (see **Figure 56**).



**Figure 56.** Location of flat head screws holding blade guide cover.

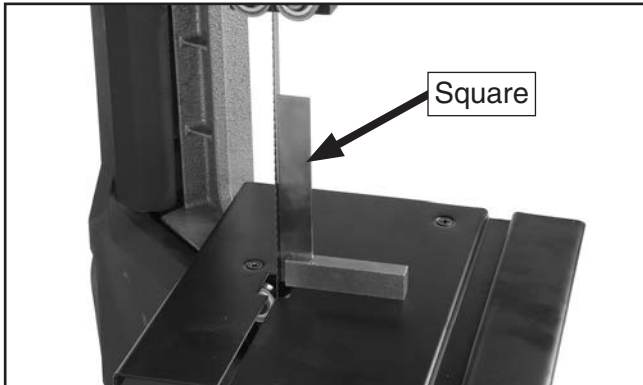
4. Install vertical work table (see **Figure 57**) and replace flat head screws removed in **Step 3**.
5. Install table bracket with (1)  $\frac{1}{4}$ "-20 x  $\frac{1}{2}$ " flat head screw,  $\frac{1}{4}$ "-20 hex nut, and hex bolt pre-installed in casting (see **Figure 57**). Finger-tighten fasteners for now.



**Figure 57.** Table and bracket installed.

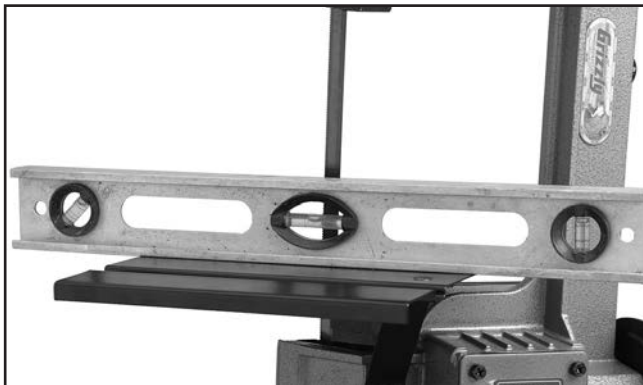


- Set square on table to side of blade, as shown in **Figure 58**, adjust table bracket until table is square to blade, then fully tighten fasteners from **Step 5** to secure.

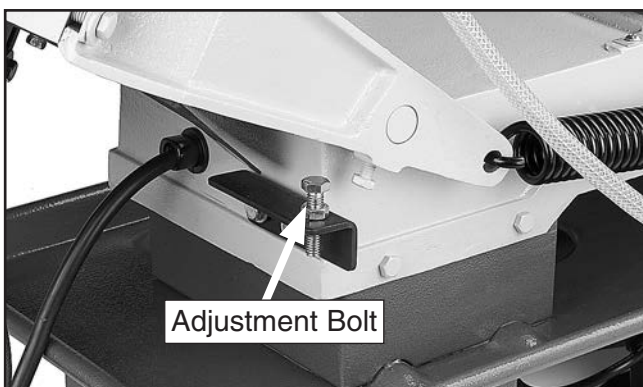


**Figure 58.** Squaring table to blade.

- Place level on table, as shown in **Figure 59**, and turn adjustment bolt shown in **Figure 60** until table is level.



**Figure 59.** Example of leveling table.



**Figure 60.** Location of adjustment bolt.

## Cutting Fluid

While simple in concept and function, many issues must be taken into account to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

**Use selections below to choose appropriate cutting fluid:**

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use water soluble cutting fluid.
- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use "Neat Cutting Oil" (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).
- For cutting cast iron, cutting fluid is not recommended.
- For cutting magnesium, use only cutting fluid that is designed for cutting magnesium.

**Remember:** Too much flow at the cutting fluid nozzle will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.

	<p><b>! WARNING</b>  <b>BIOLOGICAL AND POISON HAZARD!</b> Use proper personal protection equipment when handling cutting fluid and dispose by following federal, state, and fluid manufacturer requirements to properly dispose of cutting fluid.</p>
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# Cutting Fluid System

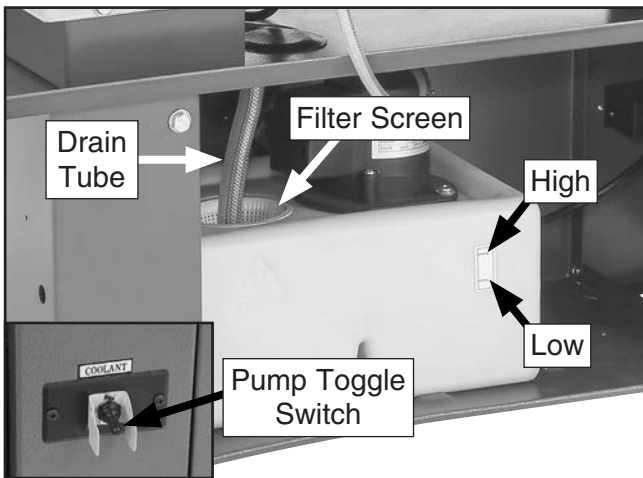


This bandsaw has a built-in cutting fluid system that extends the life of your bandsaw blades by lowering the cutting temperature and washing away chips.

See **Cutting Fluid** on **Page 37** for more information.

## To use cutting fluid system:

1. Thoroughly clean and remove any foreign material that may have fallen inside reservoir during shipping.
2. Place filter screen and drain tube in reservoir, as shown in **Figure 61**.

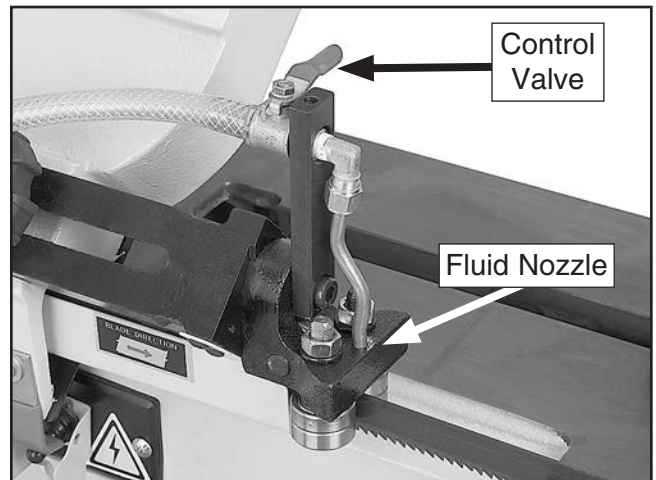


**Figure 61.** Identification of coolant components.

3. Fill reservoir to "High" mark with cutting fluid.

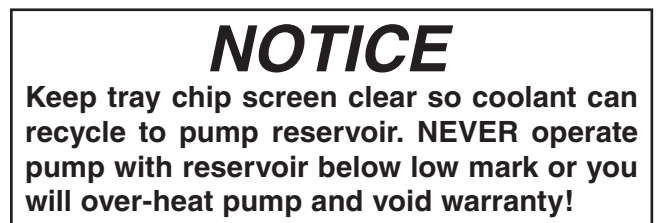


4. Adjust valve on coolant hose to control flow of coolant (see **Figure 62**). Make sure that pressure is not so high that coolant spills on floor and creates a slipping hazard.



**Figure 62.** Location of coolant control valve.

5. Turn pump toggle switch **ON** before making your cut.



# SECTION 5: ACCESSORIES

## **! WARNING**

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

## **NOTICE**

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

- G5124—93" x 3/4" x .032" 10 TPI Raker
- G5125—93" x 3/4" x .032" 14 TPI Raker
- G5126—93" x 3/4" x .032" 18 TPI Raker
- G5127—93" x 3/4" x .035" 4–6 Variable Pitch
- G5128—93" x 3/4" x .035" 5–8 Variable Pitch
- G5129—93" x 3/4" x .035" 6–10 Variable Pitch
- G5130—93" x 3/4" x .035" 8–12 Variable Pitch
- G5131—93" x 3/4" x .035" 10–14 Variable Pitch

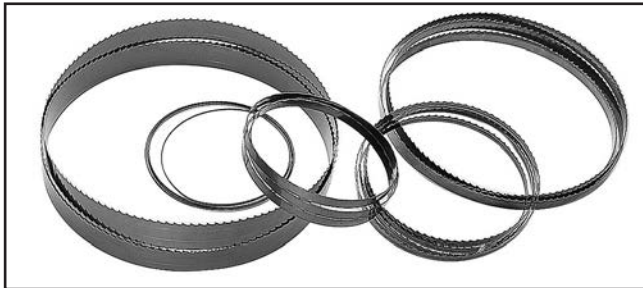


Figure 63. Metal-cutting blade assortment.

### **G5618—Deburring Tool w/2 Blades**

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



Figure 64. G5618 Deburring Tool.

### **H5408—Lenox Blade Tensioning Gauge**

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 65. H5408 Blade Tensioning Gauge.

## **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

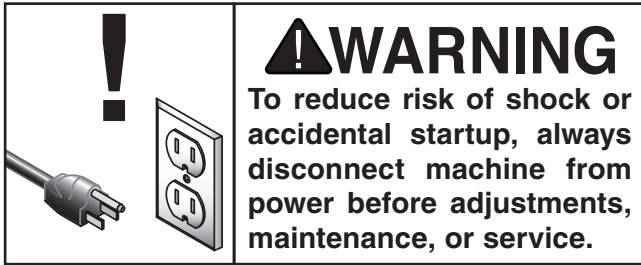


Figure 66. Assortment of basic eye protection.

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



# SECTION 6: MAINTENANCE



## 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, 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.
- Incorrect blade tension.
- Worn or damaged wires.
- Any other unsafe condition.

### Weekly Maintenance

- Lubricate vise screw.
- Check gearbox lubrication.

### Biannual (6-Month) Maintenance

- Change gearbox oil.

## Cleaning

Cleaning the Model G0561 is relatively easy. Use a brush and a shop vacuum to remove chips and other debris from the machine. Keep the non-painted surfaces rust-free with regular applications of a high-quality rust preventative.

Periodically, remove the blade and thoroughly clean all metal chips or built-up grease from the wheel surfaces and blade housing.

## Lubrication

An essential part of lubrication is cleaning the components before lubricating them.

This step is critical because grime and chips build up on lubricated components over time, which makes them hard to move.

Clean all exterior components in this section with mineral spirits, shop rags, and brushes before lubricating.

**DISCONNECT MACHINE FROM POWER BEFORE PERFORMING LUBRICATION!**

## NOTICE

**Follow reasonable lubrication practices as outlined in this manual. Failure to do so could lead to premature failure of machine and will void warranty.**

### Vise Leadscrew

Lube Type.....Model G4682 or Dry Coating Lube  
Lube Amount.....Thin Coat  
Lubrication Frequency..... 40 hrs. of Operation

#### Items Needed

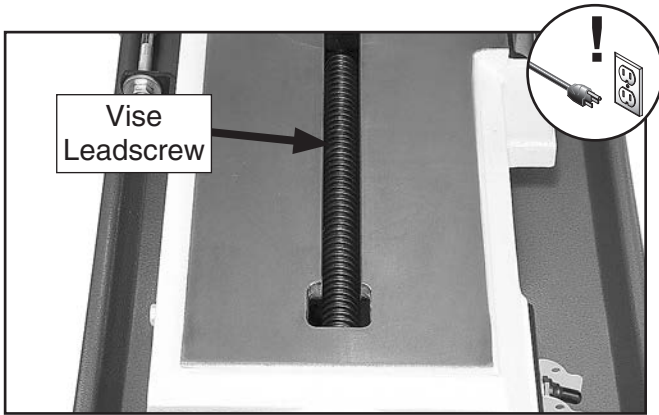
#### Qty

Mineral Spirits..... As Needed  
Stiff Brush..... 1  
Model G4682 or Dry Coating Lube... As Needed

#### To lubricate vise leadscrew:

1. DISCONNECT MACHINE FROM POWER!
2. Using vise handwheel, move vise as far forward as possible.
3. Use mineral spirits and a brush to clean existing lubricant and debris off of vise leadscrew shown in **Figure 67**. Allow leadscrew to dry.





**Figure 67.** Location of vise leadscrew.

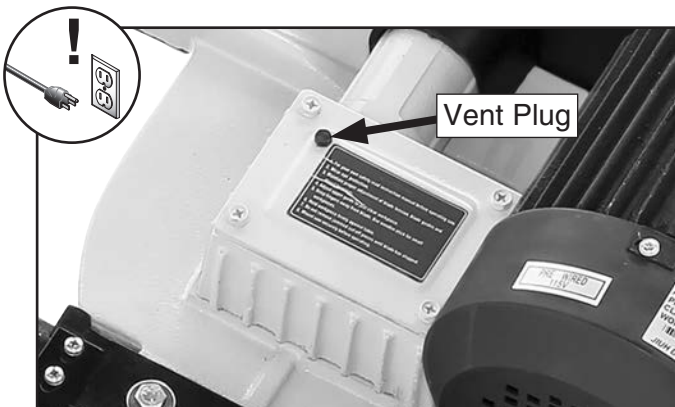
4. Apply thin coat of dry coating lube to exposed leadscrew threads, then move vise through its full range of motion several times to disperse lube along full length of leadscrew.

### Gearbox

Lube Type.....Model T28042 or ISO 320 Equiv.  
 Lube Amount ..... As Needed  
 Check Frequency ..... Weekly  
 Lubrication Frequency . After 50 Hrs., Bi-annually

**IMPORTANT:** To maximize gearbox life, replace the oil after the first 50 hours of use.

After the first 50 hours of use, the fluid level of the gearbox should be checked weekly. Use an 8mm wrench to remove the vent plug shown in **Figure 68** to check fluid level. If oil is not visible when plug is removed, slowly add just enough oil so you can see oil level. Clean vent plug threads, then wrap them with thread-sealing tape before replacing.



**Figure 68.** Location of gearbox vent plug.

As routine maintenance, the gearbox oil should be replaced every 6 months.

<b>Items Needed</b>	<b>Qty</b>
Disposable Gloves .....	As Needed
Shop Rags.....	As Needed
Phillips Hd. Screwdriver #2 or Wrench 10mm...	1
Mineral Spirits.....	As Needed
Wrench or Socket 5/16" .....	1
Model T28042 or ISO 320 Equiv.....	As Needed
Thread-Sealing Tape .....	As Needed

**⚠ CAUTION**

**Oil can cause irritation if it contacts your skin. Wear disposable gloves during following steps to protect your skin.**

### To replace gearbox oil:

1. DISCONNECT MACHINE FROM POWER!
2. With shop rags positioned to catch any oil run off, remove (4) hex bolts shown in **Figure 69** to remove gearbox cover.



**Figure 69.** Location of gearbox cover and bolts.

3. Use shop rags to absorb and remove oil in gearbox.
4. Use mineral spirits to clean oil off of gears and inside of box, then let gears dry.
5. Install gearbox cover removed in **Step 2**.
6. Remove vent plug shown in **Figure 68**, then fill gearbox with oil until you can see it in vent plug hole.
7. Clean vent plug threads, then wrap threads in thread-sealing tape before replacing.



# SECTION 7: SERVICE

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

## Troubleshooting

### Motor & Electrical



Symptom	Possible Cause	Possible Solution
Machine does not start, or power supply breaker immediately trips after startup.	<ol style="list-style-type: none"> <li>1. Machine circuit breaker tripped.</li> <li>2. Incorrect power supply voltage or circuit size.</li> <li>3. Plug/receptacle at fault/wired incorrectly.</li> <li>4. Power supply circuit breaker tripped or fuse blown.</li> <li>5. Motor wires connected incorrectly.</li> <li>6. Start capacitor at fault.</li> <li>7. Centrifugal switch adjustment/contact points at fault.</li> <li>8. Wiring broken, disconnected, or corroded.</li> <li>9. ON/OFF or circuit breaker switch at fault.</li> <li>10. Motor or motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reset circuit breaker.</li> <li>2. Ensure correct power supply voltage and circuit size (<b>Page 11</b>).</li> <li>3. Test for good contacts; correct wiring (<b>Page 48</b>).</li> <li>4. Ensure circuit is free of shorts. Reset circuit breaker or replace fuse.</li> <li>5. Correct motor wiring connections (<b>Page 48</b>).</li> <li>6. Test/replace if at fault.</li> <li>7. Adjust centrifugal switch/clean contact points. Replace either if at fault.</li> <li>8. Fix broken wires or disconnected/corroded connections (<b>Page 48</b>).</li> <li>9. Replace switch/circuit breaker.</li> <li>10. Replace motor.</li> </ol>
Machine stalls or is underpowered.	<ol style="list-style-type: none"> <li>1. Dull blade.</li> <li>2. Feed rate/cutting speed too fast.</li> <li>3. Workpiece crooked; vise loose or misadjusted.</li> <li>4. Wrong workpiece material (metal) or wrong blade type/TPI for material.</li> <li>5. Gearbox at fault.</li> <li>6. Blade slipping on wheels or not properly tensioned.</li> <li>7. Belt slipping/pulleys misaligned.</li> <li>8. Motor wires connected incorrectly.</li> <li>9. Plug/receptacle at fault/wired incorrectly.</li> <li>10. Pulley slipping on shaft.</li> <li>11. Motor overheated, tripping machine circuit breaker.</li> <li>12. Extension cord too long.</li> <li>13. Centrifugal switch/contact points at fault.</li> <li>14. Motor or motor bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Sharpen/replace blade (<b>Page 27</b>).</li> <li>2. Decrease feed rate (<b>Page 31</b>)/cutting speed (<b>Page 33</b>); use cutting fluid if possible.</li> <li>3. Straighten or replace workpiece/adjust vise (<b>Page 32</b>).</li> <li>4. Use correct metal (<b>Page 25</b>) and type/TPI/size of blade (<b>Page 25</b>).</li> <li>5. Replace broken or slipping gears.</li> <li>6. Adjust blade tracking (<b>Page 45</b>) and tension (<b>Page 28</b>).</li> <li>7. Clean/tension (<b>Page 33</b>)/replace belt; ensure pulleys are aligned (<b>Page 19</b>).</li> <li>8. Correct motor wiring connections (<b>Page 48</b>).</li> <li>9. Test for good contacts; correct wiring (<b>Page 48</b>).</li> <li>10. Tighten/replace loose pulley shaft.</li> <li>11. Clean motor/let cool, and reduce workload. Reset breaker.</li> <li>12. Move machine closer to power supply; use shorter extension cord (<b>Page 12</b>).</li> <li>13. Adjust centrifugal switch/clean contact points. Replace either if at fault.</li> <li>14. 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. V-belt worn, loose, pulleys misaligned or belt slapping cover.</li> <li>4. Pulley loose.</li> <li>5. Motor mount loose/broken.</li> <li>6. Workpiece loose.</li> <li>7. Motor fan rubbing on fan cover</li> <li>8. Blade damaged, warped, or has excessively large weld.</li> <li>9. Centrifugal switch needs adjustment/at fault.</li> <li>10. Motor bearings at fault.</li> <li>11. Gearbox 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. Inspect/replace belt (<b>Page 33</b>). Realign pulleys if necessary</li> <li>4. Secure pulley on shaft.</li> <li>5. Tighten/replace.</li> <li>6. Secure workpiece in vise (<b>Page 32</b>).</li> <li>7. Fix/replace fan cover; replace loose/damaged fan.</li> <li>8. Replace warped/damaged blade (<b>Page 27</b>) or grind weld flush with blade.</li> <li>9. Adjust/replace if at fault.</li> <li>10. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>11. Rebuild gearbox for bad gears/bearings.</li> </ol>
Coolant pump is not functioning.	<ol style="list-style-type: none"> <li>1. Pump wires connected incorrectly.</li> <li>2. Wiring broken, disconnected, or corroded.</li> <li>3. ON/OFF switch at fault.</li> <li>4. Coolant pump at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Correct pump wiring connections (<b>Page 48</b>).</li> <li>2. Fix broken wires or disconnected/corroded connections (<b>Page 48</b>).</li> <li>3. Replace switch.</li> <li>4. Test/repair/replace.</li> </ol>

## Operation

Symptom	Possible Cause	Possible Solution
Vibration when operating or cutting.	<ol style="list-style-type: none"> <li>1. Loose or damaged blade.</li> <li>2. Machine component(s) loose.</li> <li>3. Bent, or dull blade.</li> <li>4. Worn wheel bearing.</li> <li>5. Wheels worn or incorrectly installed.</li> <li>6. Wheel appears bent.</li> <li>7. Gearbox at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tension blade (<b>Page 28</b>)/replace blade (<b>Page 27</b>).</li> <li>2. Inspect/re-tighten component(s).</li> <li>3. Replace blade (<b>Page 27</b>).</li> <li>4. Check/replace wheel bearing.</li> <li>5. Replace wheels; adjust blade tracking (<b>Page 45</b>).</li> <li>6. Check/replace wheel.</li> <li>7. Rebuild gearbox for bad gears/bearings.</li> </ol>
Ticking sound when saw is running.	<ol style="list-style-type: none"> <li>1. Blade teeth missing or broken.</li> <li>2. Blade weld contacting blade guides.</li> <li>3. Blade weld failing.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect/replace blade (<b>Page 27</b>).</li> <li>2. Grind weld down flush with blade.</li> <li>3. Cut and re-weld blade, or replace blade (<b>Page 27</b>).</li> </ol>
Cuts not square, or intended angle is incorrect.	<ol style="list-style-type: none"> <li>1. Loose vise.</li> <li>2. Blade not square to table.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten vise and secure workpiece (<b>Page 32</b>).</li> <li>2. Adjust blade square to table (<b>Page 46</b>).</li> </ol>
Blade dulls prematurely, or metal sticks to blade.	<ol style="list-style-type: none"> <li>1. Blade improperly broken in.</li> <li>2. Blade gullets loading up with chips.</li> <li>3. Blade tension is too low.</li> <li>4. Blade TPI too fine or coarse for material; teeth load up and overheat.</li> <li>5. Incorrect coolant mixture for workpiece/cut.</li> <li>6. Incorrect feed rate/blade speed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace blade (<b>Page 27</b>); complete blade break-in procedure (<b>Page 29</b>).</li> <li>2. Use blade with larger gullets/fewer TPI (<b>Page 25</b>).</li> <li>3. Increase blade tension (<b>Page 28</b>).</li> <li>4. Use coarser-tooth or finer-tooth blade (<b>Page 25</b>); adjust feed rate (<b>Page 31</b>); adjust blade speed (<b>Page 33</b>); make sure blade brush works and is adjusted correctly.</li> <li>5. Use correct coolant mixture.</li> <li>6. Adjust feed rate (<b>Page 31</b>), adjust blade speed (<b>Page 33</b>).</li> </ol>



## Operation (Cont.)

Symptom	Possible Cause	Possible Solution
Excessive blade breakage.	<ol style="list-style-type: none"> <li>1. Workpiece loose.</li> <li>2. Blade contacting workpiece when started.</li> <li>3. Blade too thick/blade gullets too large.</li> <li>4. Workpiece too coarse for blade.</li> <li>5. Blade tension/tracking requires adjustment.</li> <li>6. Blade guide roller bearings require adjustment.</li> <li>7. Blade weld failing.</li> </ol>	<ol style="list-style-type: none"> <li>1. Secure workpiece with vise (<b>Page 32</b>).</li> <li>2. Raise headstock, start blade, then lower blade into workpiece.</li> <li>3. Use thinner blade/blade with smaller gullets (<b>Page 25</b>).</li> <li>4. Use coarser-tooth blade (<b>Page 25</b>); adjust feed rate (<b>Page 31</b>); adjust blade speed (<b>Page 33</b>).</li> <li>5. Adjust blade tension (<b>Page 28</b>)/tracking (<b>Page 45</b>).</li> <li>6. Adjust blade guide roller bearings (<b>Page 46</b>).</li> <li>7. Cut and re-weld blade, or replace blade (<b>Page 27</b>).</li> </ol>
Blade wears on one side or shows overheating.	<ol style="list-style-type: none"> <li>1. Blade guides worn or mis-adjusted.</li> <li>2. Blade not supported.</li> <li>3. Dull/incorrect blade.</li> <li>4. Incorrect coolant mixture for workpiece/cut.</li> <li>5. Blade is bell-mouthed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-adjust guides and bearings (<b>Page 46</b>)/replace.</li> <li>2. Move blade guide closer to workpiece (<b>Page 30</b>).</li> <li>3. Replace blade (<b>Page 27</b>).</li> <li>4. Use correct coolant mixture.</li> <li>5. Replace blade (<b>Page 27</b>).</li> </ol>
Blade tracks incorrectly or comes off wheels.	<ol style="list-style-type: none"> <li>1. Feed rate too fast/wrong TPI.</li> <li>2. Blade tension/tracking requires adjustment.</li> <li>3. Blade guides need adjustment.</li> <li>4. Blade is bell-mouthed.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate (<b>Page 31</b>), reduce blade TPI (<b>Page 25</b>).</li> <li>2. Adjust blade tracking (<b>Page 45</b>), tension (<b>Page 28</b>).</li> <li>3. Adjust blade guides (<b>Page 46</b>).</li> <li>4. Replace blade (<b>Page 27</b>).</li> </ol>
Cuts are crooked/excessively rough.	<ol style="list-style-type: none"> <li>1. Feed rate too fast, blade speed incorrect.</li> <li>2. Blade too coarse or dull.</li> <li>3. Blade not supported.</li> <li>4. Blade guides out of adjustment.</li> <li>5. Blade tension/tracking requires adjustment.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce feed rate (<b>Page 31</b>), adjust blade speed (<b>Page 33</b>).</li> <li>2. Replace blade (<b>Page 27</b>).</li> <li>3. Move blade guide closer to workpiece (<b>Page 30</b>).</li> <li>4. Adjust blade guides (<b>Page 46</b>).</li> <li>5. Adjust blade tracking (<b>Page 45</b>), tension (<b>Page 28</b>).</li> </ol>
Blade cuts into table or does not cut fully through workpiece.	<ol style="list-style-type: none"> <li>1. Downfeed stop bolt requires adjustment.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust downfeed stop bolt (<b>Page 47</b>).</li> </ol>
Coolant system is not functioning.	<ol style="list-style-type: none"> <li>1. Coolant valve is closed.</li> <li>2. Coolant level is low.</li> <li>3. Coolant system is leaking.</li> <li>4. Flow blocked or impeded.</li> </ol>	<ol style="list-style-type: none"> <li>1. Open coolant valve.</li> <li>2. Check/fill coolant level (<b>Page 38</b>).</li> <li>3. Inspect/test for leaks/repair.</li> <li>4. Make sure coolant line(s) are not pinched or damaged.</li> </ol>
Coolant system is pulling sludge from reservoir.	<ol style="list-style-type: none"> <li>1. Coolant level is low.</li> <li>2. Coolant needs to be changed/reservoir is dirty.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check/fill coolant level (<b>Page 38</b>).</li> <li>2. Clean and change coolant (<b>Page 38</b>).</li> </ol>



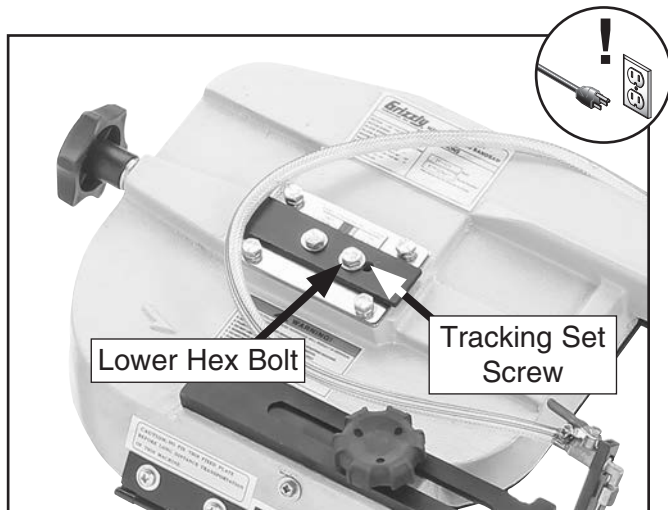
# Adjusting Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

Tools Needed	Qty
Wrench or Socket 1/2" .....	1
Hex Wrench 4mm.....	1

## To adjust blade tracking:

1. DISCONNECT MACHINE FROM POWER!
2. Position bandsaw in vertical position and close feed ON/OFF valve.
3. Open wheel access cover.
4. Loosen, but do not remove lower hex bolt in blade wheel tilting mechanism (see **Figure 70**).



**Figure 70.** Location of lower hex bolt.

5. Relax blade tension.
6. Adjust tracking set screw (see **Figure 70**), then tighten hex bolt loosened in **Step 4**.

— Tightening set screw will move blade closer to shoulder of wheel (see **Figure 71**).

— Loosening set screw will move blade away from shoulder (see **Figure 71**).



**Figure 71.** Location of wheel shoulder.

7. Tension blade.

**⚠ WARNING**

**Moving blade can easily cut body parts. Keep body parts away from blade and machine in following step to prevent personal injury.**

8. Connect machine to power and turn machine **ON**.

— If blade tracks along shoulder of wheel (without rubbing), blade is tracking properly and this adjustment is completed.

— If blade walks away from shoulder of wheel or hits shoulder, turn machine **OFF**, disconnect it from power, and repeat **Steps 4–7** until blade tracks properly.

9. Turn **OFF** bandsaw.

10. Close wheel access cover.



# Squaring Blade to Bed Table

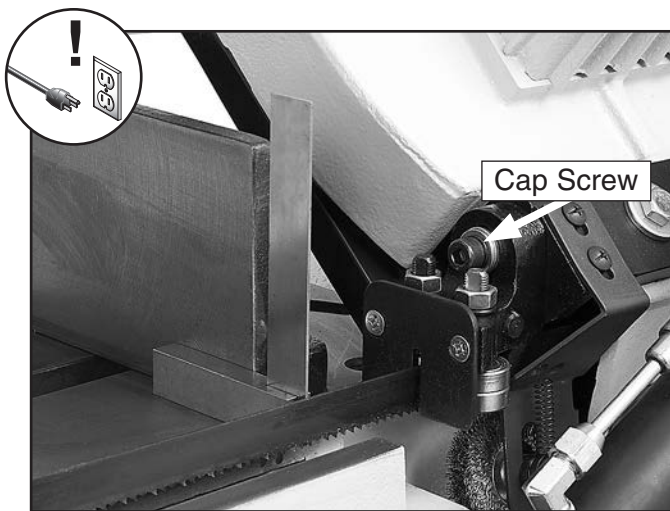
It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

Tools Needed	Qty
Square .....	1
Hex Wrench 6mm.....	1

## To square blade to bed of table:

1. DISCONNECT MACHINE FROM POWER!
2. Lower head of bandsaw until it contacts horizontal stop.
3. Place square on table bed and against edge of blade (see **Figure 72**), and check different points along length of table between blade guides.
4. Loosen cap screw shown in **Figure 72**, and rotate blade guide until blade is vertical to bed.

**Note:** Both blade guides can be adjusted to achieve the results you want.



**Figure 72.** Square placed on table bed against edge of blade.

5. Tighten cap screw.

# Adjusting Blade Guide Bearings

The blade guide bearings come adjusted from the factory and the need for adjustment should rarely occur. Uneven blade wear and crooked cuts may be the result of improper adjustment. Each bearing assembly has an eccentric bushing that allows the distance between the blade and bearings to be adjusted. The bearings are secured in place by a hex nut and a lock washer.

Tools Needed	Qty
Square .....	1
Wrench or Socket 14mm .....	1
Open-Ended Wrench 6mm .....	1

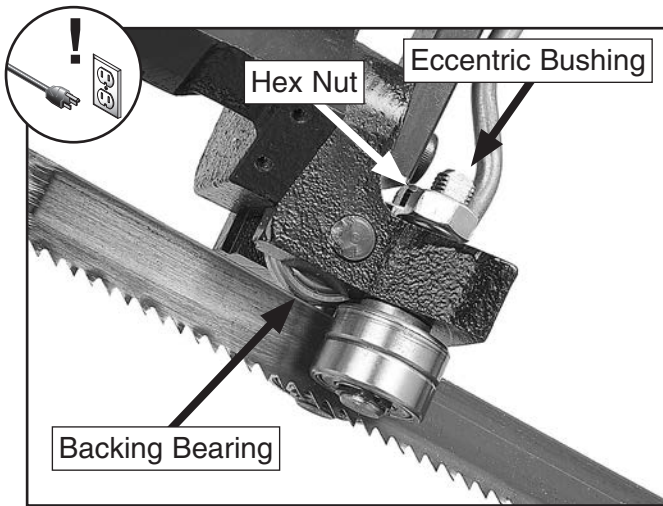
Before adjusting the blade guide bearings, make sure that you have squared the blade to the table as discussed in the previous section.

## To adjust blade guide bearings:

1. DISCONNECT MACHINE FROM POWER!
2. Position vise to 90°, then lock in place.
3. Put square against face of vise and move it over to blade (see **Figure 72**).
  - If square *does* evenly touch face of vise and blade, proceed to **Step 6**.
  - If square *does not* evenly touch face of vise and blade at the time, continue with next step.



- Loosen hex nuts that secure eccentric bushings attached to guide bearings (see **Figure 73**).



**Figure 73.** Guide bearing components.

- Adjust bearings as necessary to force blade 90° to vise, then tighten hex nuts.

**Note:** *Since the bearings twist the blade into position, it is acceptable if there is 0.001"-0.002" gap between the blade and the front or back of the bearing. Just make sure not to squeeze the blade too tightly with the bearings. After the guide bearings are set, you should be able to rotate guide bearings (although they will be stiff) with your fingers.*

The backing bearing is not adjustable and should make light contact with blade.

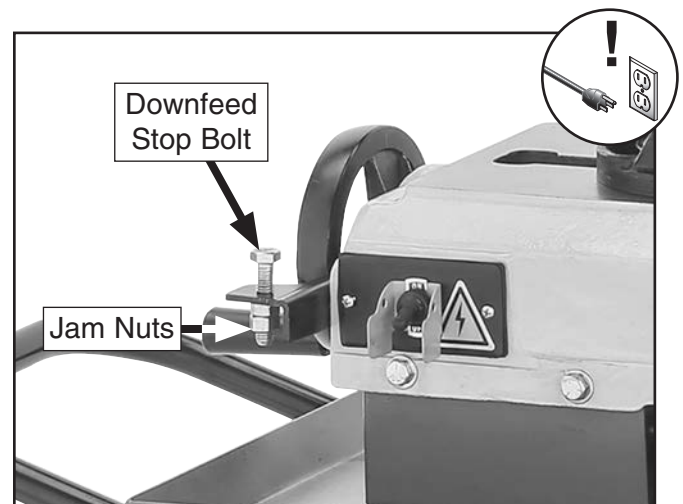
## Adjusting Downfeed Stop Bolt

If the blade does not travel far enough to complete the cut, or the blade contacts the vise table, then the downfeed stop bolt will need to be adjusted.

Tools Needed	Qty
Wrench or Socket 14mm.....	1
Open-Ended Wrench 14mm.....	1

### To adjust downfeed stop bolt:

- DISCONNECT MACHINE FROM POWER!
- Lower headstock all the way.
  - If blade is just below vise table, but not contacting it, no adjustment is required.
  - If blade contacts vise table, proceed to **Step 3**.
  - If blade is above vise table, proceed to **Step 4**.
- Raise headstock until blade is just below vise table surface and adjust downfeed stop bolt and jam nuts to secure headstock position (see **Figure 74**). Adjustment is complete.
- Adjust downfeed stop bolt until blade is just below vise table, but not contacting it (see **Figure 74**). Tighten jam nuts to secure.



**Figure 74.** Location of downfeed stop bolt.



# SECTION 8: WIRING

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

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

## WARNING

### Wiring Safety Instructions

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

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














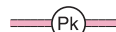
**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

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

#### NOTICE

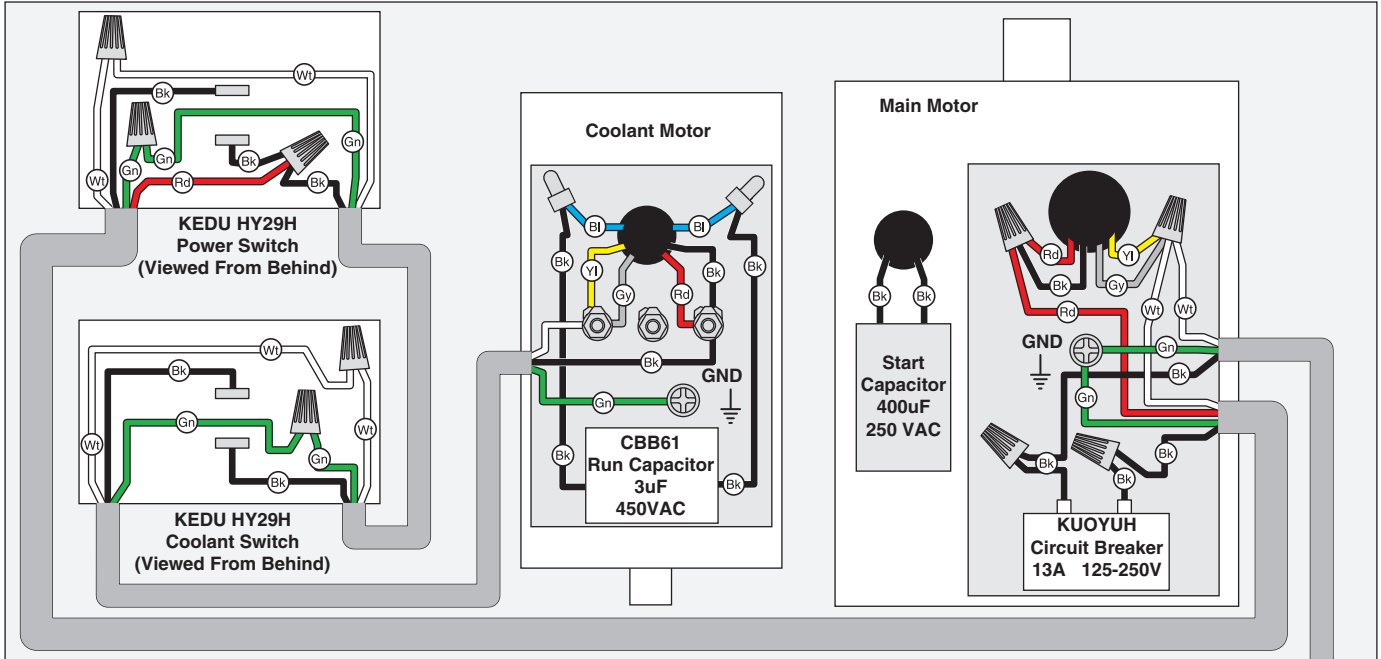
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

#### COLOR KEY

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



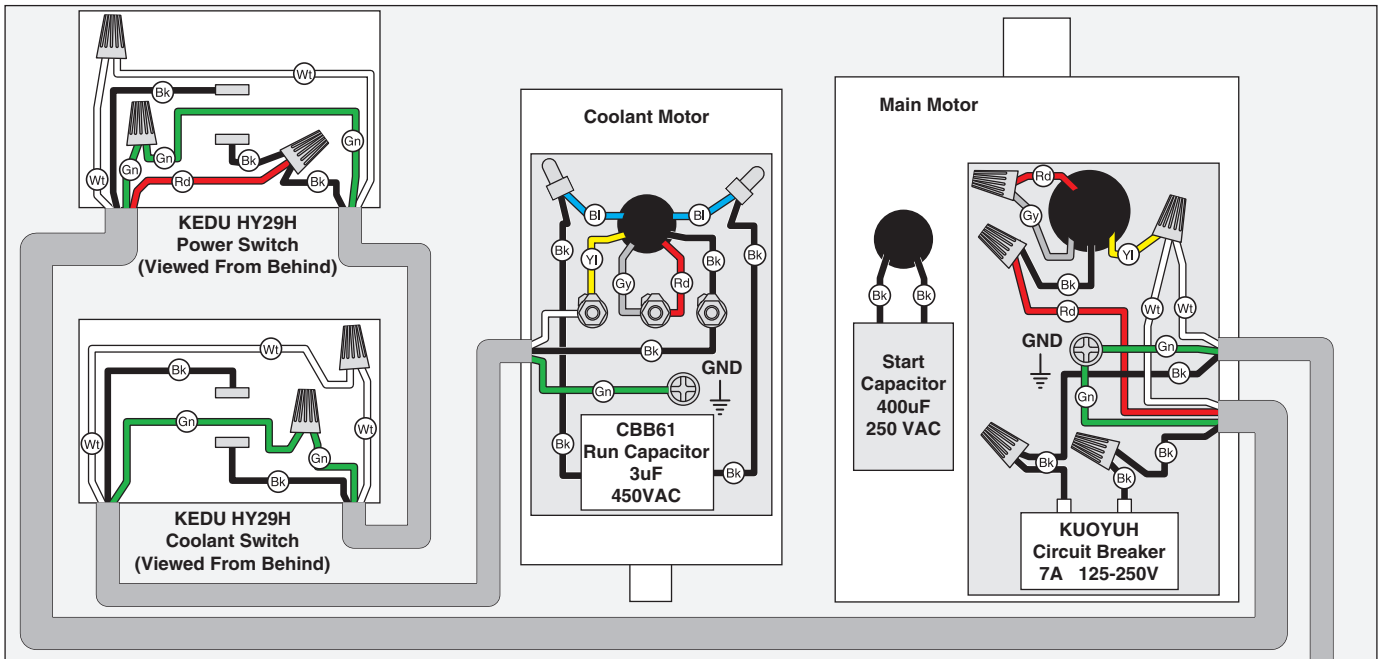
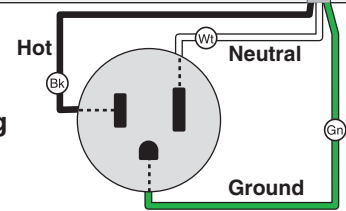
# Wiring Diagrams



115V Wiring Diagram



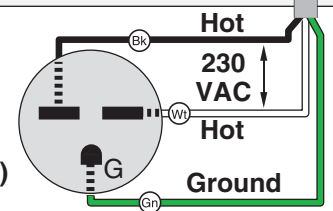
5-15 Plug  
115 VAC



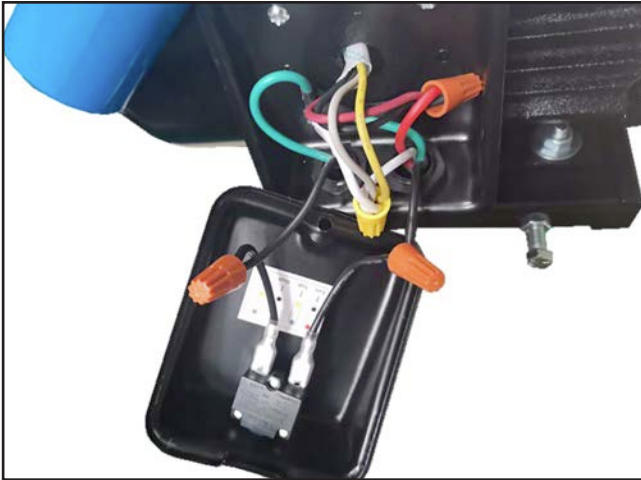
230V Wiring Diagram



6-15 Plug  
(As Recommended)



# Electrical Components



**Figure 75.** Main motor wiring (115V).



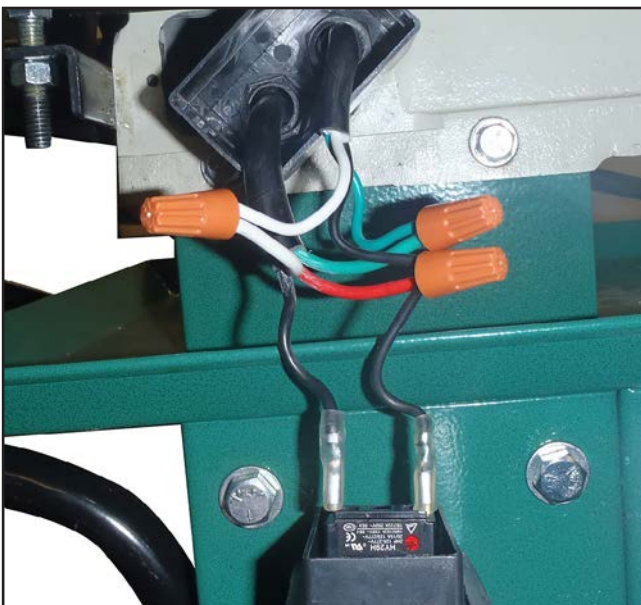
**Figure 78.** Pump motor (115V).



**Figure 76.** Capacitor wiring.



**Figure 79.** Coolant pump ON/OFF switch.



**Figure 77.** Power switch.





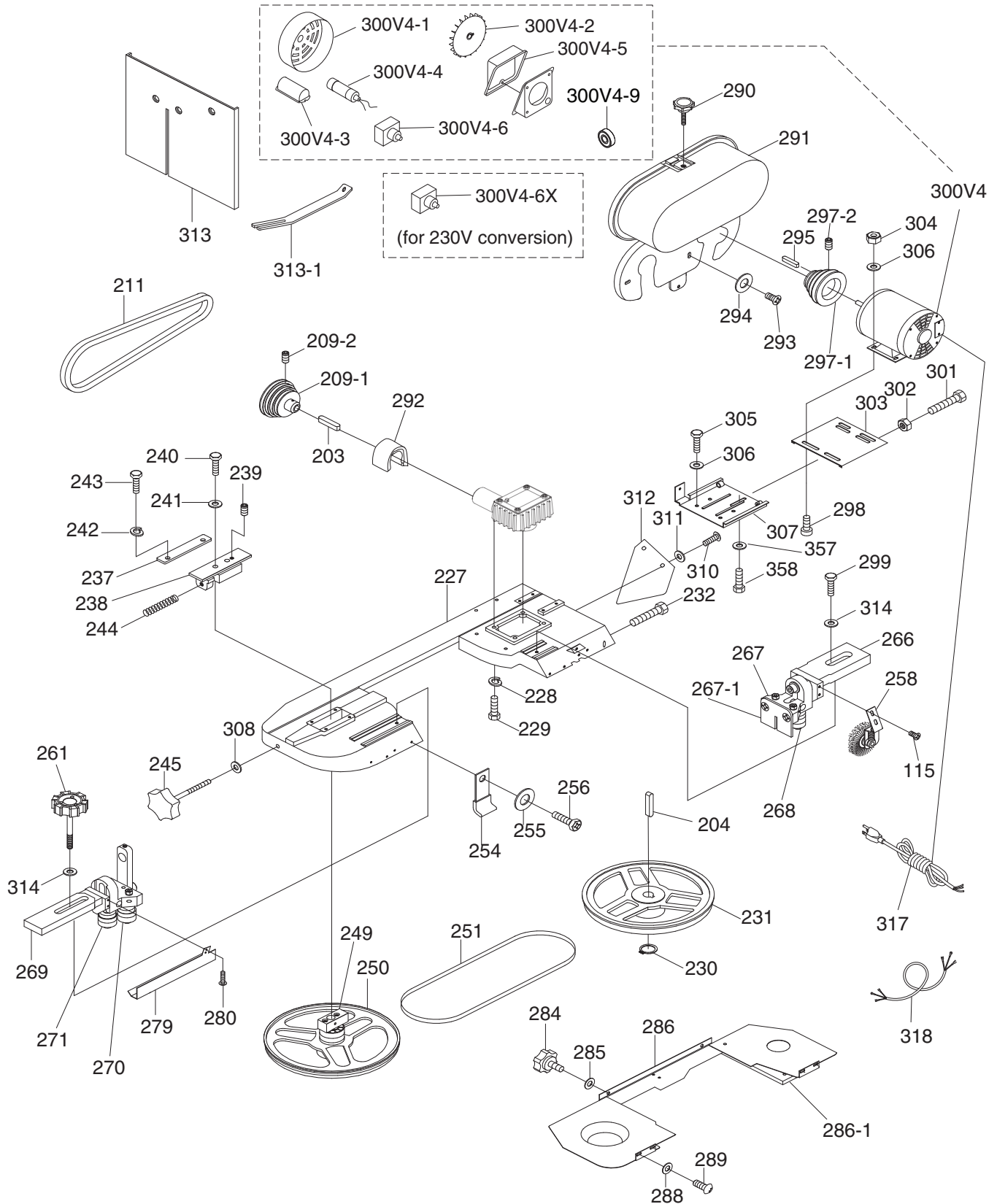
# Cabinet & Base Parts List

REF	PART #	DESCRIPTION
1	P0561001	BASE
2	P0561002	ACME SCREW 22 X 5 X 480
3	P0561003	FLAT WASHER 1/2
4	P0561004	KEY 5 X 5 X 15
5	P0561005	HANDWHEEL
5-1	P0561005-1	HANDWHEEL HANDLE
7	P0561007	KNOB BOLT 3/8-16
8	P0561008	FLAT WASHER 3/8
9	P0561009	WISE JAW, FRONT
10	P0561010	ROLL PIN 5 X 34
11	P0561011	BRACKET
12	P0561012	ACME NUT ASSY 22 X 5
17	P0561017	HEX BOLT 3/8-16 X 1-1/2
18	P0561018	HEX NUT 1/2-12
19	P0561019	FLAT WASHER 1/2
20	P0561020	CARRIAGE BOLT 1/2-12 X 2
21	P0561021	HEX BOLT 1/2-12 X 2
22	P0561022	WISE JAW, REAR
23	P0561023	BUSHING
24	P0561024	SUPPORT ROD
25	P0561025	HEX BOLT 5/16-18 X 3/4
26	P0561026	PIVOT BRACKET
27	P0561027	SPRING BRACKET 75 X 25.4
28	P0561028	HEX BOLT 3/8-16 X 1-1/2
29	P0561029	SUPPORT PLATE
30	P0561030	FIXED PLATE
31	P0561031	TENSION SPRING 32 X 282
32	P0561032	EYE BOLT 3/8-16 X 4-1/2
33	P0561033	SPRING HANDLE BRACKET
34	P0561034	HEX BOLT 5/16-18 X 3/4
35	P0561035	FLAT WASHER 5/16
36	P0561036	HEX NUT 3/8-16
37	P0561037	FLAT WASHER 3/8
38	P0561038	LEAF SCREW 5/16-18
39	P0561039	HEX BOLT 5/16-18 X 3/4
40	P0561040	WORK STOP ROD
41	P0561041	WORK STOP
42	P0561042	HEX BOLT 5/16-18 X 1-1/2
43	P0561043	HEX NUT 5/16-18
45	P0561045	SUPPORT PLATE
46	P0561046	HEX BOLT 3/8-16 X 1-3/4
47	P0561047	HEX NUT 3/8-16
48	P0561048	HEX BOLT 5/16-18 X 3/4
49	P0561049	FLAT WASHER 5/16
50	P0561050	HEX BOLT 3/8-16 X 1-3/4
51	P0561051	HEX NUT 3/8-16
52	P0561052	HEX BOLT 5/16-18 X 3/4
53	P0561053	LOCK WASHER 5/16
55	P0561055	ELECTRICAL BOX GASKET, RUBBER
57V2	P0561057V2	TOGGLE SWITCH KEDU HY29H V2.01.08
59	P0561059	PHLP HD SCR 10-24 X 3/8
65	P0561065	DRAIN SCREEN

REF	PART #	DESCRIPTION
66	P0561066	SWITCH SHUT-OFF TIP
67	P0561067	HEX BOLT 3/8-16 X 1-1/4
68	P0561068	FLAT WASHER 5/16
69	P0561069	HEX NUT 5/16-18
70	P0561070	SWITCH BRACKET
71	P0561071	TOGGLE SWITCH COVER
72	P0561072	HEX BOLT 5/16-18 X 1
75	P0561075	PHLP HD SCR 10-24 X 3/8
77	P0561077	STAND ASSEMBLY
77-1	P0561077-1	STAND SHELF
78	P0561078	HOSE 12 X 8 X 200MM
82	P0561082	COOLANT TANK
83	P0561083	COOLANT PUMP SWITCH CORD 16G 3W 26"
84V2	P0561084V2	COOLANT PUMP MOTOR V2.07.09
84V2-1	P0561084V2-1	R CAPACITOR 3MFD 450V 1-1/8 X 1-1/2
85	P0561085	PHLP HD SCR 1/4-20 X 5/8
86	P0561086	FLAT WASHER 1/4
87	P0561087	COOLANT PUMP CORD 18G 3W 23"
88	P0561088	HOSE COUPLER 3/8 NPT X 5/16
89	P0561089	HOSE CLIP 5/8"
90	P0561090	HOSE 12 X 8 X 2000MM
91	P0561091	VALVE ASSEMBLY
94	P0561094	STAND WHEEL AXLE
95	P0561095	STAND WHEEL
96	P0561096	COTTER PIN 3 X 25MM STANDARD
97	P0561097	CYLINDER ASSEMBLY RF-712N
99	P0561099	FLAT WASHER 5/16
100	P0561100	HEX BOLT 5/16-18 X 1
101	P0561101	CAP SCREW 3/8-16 X 2-1/4
102	P0561102	FLAT WASHER 3/8
135	P0561135	FLAT WASHER 5/16
136	P0561136	HEX BOLT 5/16-18 X 3/4
137	P0561137	FLAT WASHER 5/8
316	P0561316	SCALE
324	P0561324	ELECTRICAL BOX
325	P0561325	SWITCH COVER
326	P0561326	PHLP HD SCR 10-24 X 3/8
333	P0561333	FLAT WASHER #10
335	P0561335	STRAIN RELIEF M18.5 TYPE-6 ST
341	P0561341	CYLINDER SUPPORT, LOWER
342	P0561342	CYLINDER SUPPORT, UPPER
352	P0561352	FLAT WASHER 5/16
353	P0561353	HEX BOLT 5/16-18 X 1/2
354	P0561354	SPACER 8 X 16 X 2
355	P0561355	HEX NUT 3/8-16
370	P0561370	STRAIN RELIEF 1/2 NPT NYLON
393	P0561393	TOGGLE SWITCH KEDU HY29H
408	P0561408	HEX NUT 5/16-18
409	P0561409	FLAT WASHER 5/16
410	P0561410	HEX BOLT 5/16-18 X 1-1/4
411	P0561411	LEVELING FOOT 3/8-16 x 3
421	P0561421	FLAT WASHER 3/8



# Bow & Motor



**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.

Model G0561 (Mfd. Since 01/18)



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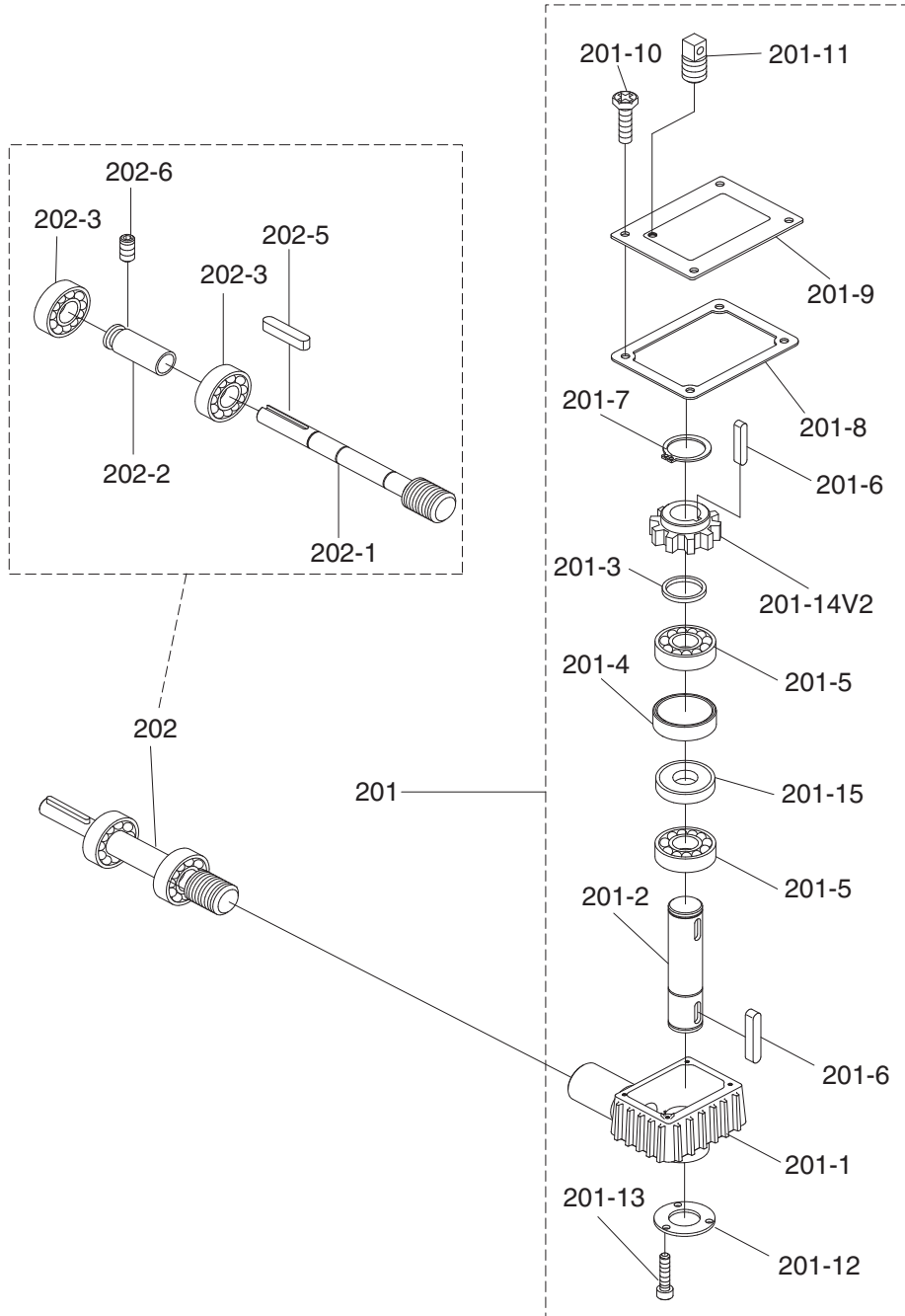
# Bow & Motor Parts List

REF	PART #	DESCRIPTION
115	P0561115	PHLP HD SCR M5-.8 X 8
203	P0561203	KEY 5 X 5 X 30
204	P0561204	KEY 6 X 6 X 20
209-1	P0561209-1	SPINDLE PULLEY
209-2	P0561209-2	SET SCREW M6-1 X 10
211	P0561211	V-BELT M27 3L270
227	P0561227	BODY FRAME
228	P0561228	LOCK WASHER 3/8
229	P0561229	HEX BOLT 3/8-16 X 1-1/4
230	P0561230	EXT RETAINING RING 25MM
231	P0561231	DRIVE WHEEL
232	P0561232	HEX BOLT 5/16-18 X 3/4
237	P0561237	SLIDING PLATE
238	P0561238	BLADE TENSION SLIDING BLOCK
239	P0561239	SET SCREW 5/16-18 X 3/4
240	P0561240	HEX BOLT 5/16-18 X 1-1/2
241	P0561241	FLAT WASHER 5/16
242	P0561242	LOCK WASHER 5/16
243	P0561243	HEX BOLT 5/16-18 X 3/4
244	P0561244	COMPRESSION SPRING 115 X 4
245	P0561245	KNOB BOLT M10-1.5 X 50
249	P0561249	WHEEL SHAFT ASSEMBLY
250	P0561250	IDLER WHEEL
251	P0561251	BLADE 0.032 X 3/4 X 93 X 8T
254	P0561254	SWITCH SHUT-OFF LATCH
255	P0561255	FLAT WASHER 1/4
256	P0561256	PHLP HD SCR 1/4-20 X 1/2
258	P0561258	BRUSH ASSEMBLY
261	P0561261	KNOB BOLT M10-1.5 X 35
266	P0561266	ADJUST BRACKET ASSEMBLY, REAR
267	P0561267	ECCENTRIC GUIDE BEARING ASSEMBLY
267-1	P0561267-1	DEFLECTOR PLATE
268	P0561268	NON-ECCENTRIC BEARING SHAFT ASSEMBLY
269	P0561269	ADJUST BRACKET ASSEMBLY, FRONT
270	P0561270	GUIDE PIVOT ASSEMBLY
271	P0561271	NON-ECCENTRIC BEARING SHAFT ASSEMBLY
279	P0561279	BLADE COVER, FRONT
280	P0561280	PHLP HD SCR 8-32 X 1/4
284	P0561284	KNOB BOLT 1/4" X 20 x 3/8
285	P0561285	FLAT WASHER 1/4

REF	PART #	DESCRIPTION
286	P0561286	BLADE BACK COVER
286-1	P0561286-1	BLADE BACK COVER PLATE
288	P0561288	FLAT WASHER 1/4
289	P0561289	PHLP HD SCR 1/4-20 X 1/2
290	P0561290	KNOB BOLT 1/4" X 20 x 3/8
291	P0561291	MOTOR PULLEY COVER
292	P0561292	SHAFT COVER
293	P0561293	PHLP HD SCR 1/4-20 X 1
294	P0561294	FLAT WASHER 1/4
295	P0561295	KEY 5 X 5 X 30
297-1	P0561297-1	MOTOR PULLEY
297-2	P0561297-2	SET SCREW 1/4-20 X 3/8
298	P0561298	CARRIAGE BOLT 5/16-18 X 1
299	P0561299	HEX BOLT 3/8-16 X 1-1/4
300V4	P0561300V4	MOTOR 1HP 115/230V 1-PH V4.01.18
300V4-1	P0561300V4-1	MOTOR FAN COVER
300V4-2	P0561300V4-2	MOTOR FAN
300V4-3	P0561300V4-3	CAPACITOR COVER
300V4-4	P0561300V4-4	S CAPACITOR 400MFD 250V 1-3/4 X 3-1/4
300V4-5	P0561300V4-5	JUNCTION BOX
300V4-6	P0561300V4-6	CIRCUIT BREAKER 13A KUOYUH 88-SERIES 1P
300V4-6X	P0561300V4-6X	CIRCUIT BREAKER 7A KUOYUH 88-SERIES 1P
300V4-9	P0561300V4-9	BALL BEARING 6203-2RS
301	P0561301	HEX BOLT 5/16-18 X 1-1/2
302	P0561302	HEX NUT 5/16-18
303	P0561303	MOTOR MOUNT
304	P0561304	HEX NUT 5/16-18
305	P0561305	HEX BOLT 5/16-18 X 3/4
306	P0561306	FLAT WASHER 5/16
307	P0561307	MOTOR MOUNT BRACKET
308	P0561308	FLAT WASHER 3/8
311	P0561311	FLAT WASHER 1/4
312	P0561312	SUPPORT PLATE
313	P0561313	VERTICAL SAW TABLE
313-1	P0561313-1	TABLE BRACKET
314	P0561314	FLAT WASHER 3/8
317	P0561317	POWER CORD 14G 3W 84" 5-15 V3.01.08
318	P0561318	POWER SWITCH CORD 14G 3W 54"
357	P0561357	FLAT WASHER 5/16
358	P0561358	HEX BOLT 5/16-18 X 1



# Gearbox

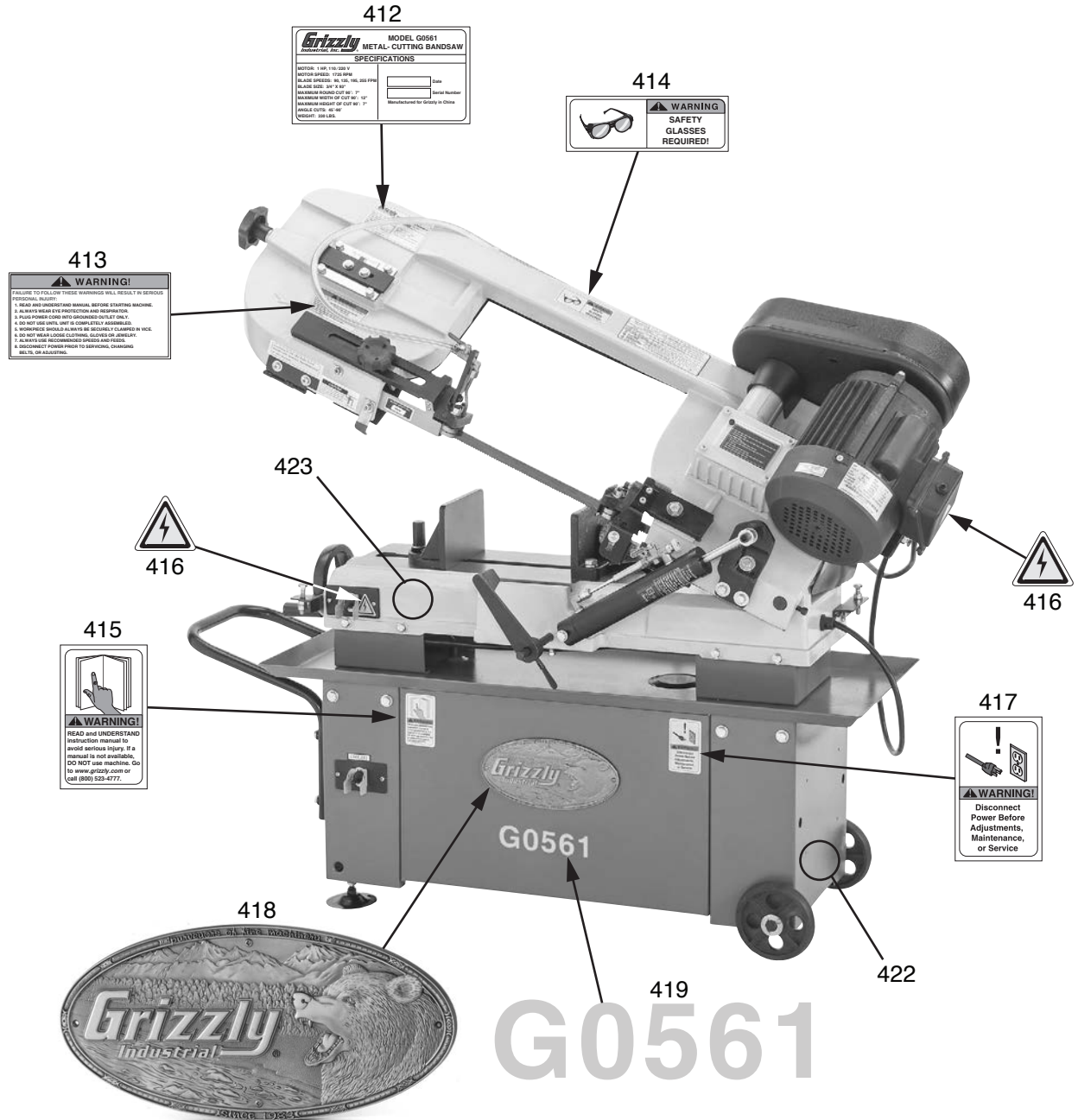


REF	PART #	DESCRIPTION
201	P0561201	GEARBOX ASSY
201-1	P0561201-1	GEARBOX HOUSING
201-2	P0561201-2	TRANSMISSION WHEEL SHAFT
201-3	P0561201-3	SPACER
201-4	P0561201-4	SPACER
201-5	P0561201-5	BALL BEARING 6205ZZ
201-6	P0561201-6	KEY 6 X 6 X 20
201-7	P0561201-7	EXT RETAINING RING 25MM
201-8	P0561201-8	GEARBOX GASKET
201-9	P0561201-9	GEARBOX COVER
201-10	P0561201-10	FLAT HD SCR 1/4-20 X 1/2

REF	PART #	DESCRIPTION
201-11	P0561201-11	VENT PLUG
201-12	P0561201-12	BEARING COVER
201-13	P0561201-13	PHLP HD SCR 10-24 X 3/8
201-14V2	P0561201-14V2	WORM GEAR STEEL V2.10.11
201-15	P0561201-15	OIL SEAL 25 X 52 X 10
202	P0561202	WORM GEAR SHAFT ASSEMBLY
202-1	P0561202-1	WORM SHAFT
202-2	P0561202-2	BEARING BUSHING
202-3	P0561202-3	BALL BEARING 6003ZZ
202-5	P0561202-5	KEY 5 X 5 X 30
202-6	P0561202-6	SET SCREW 5/16-18 X 1/2



# Labels & Cosmetics



REF PART #	DESCRIPTION
412	P0561412 MACHINE ID LABEL
413	P0561413 MACHINE WARNING LABEL
414	P0561414 SAFETY GLASSES LABEL
415	P0561415 READ MANUAL LABEL
416	P0561416 ELECTRICITY LABEL

REF PART #	DESCRIPTION
417	P0561417 UNPLUG BANDSAW LABEL
418	P0561418 GRIZZLY NAMEPLATE, SMALL
419	P0561419 MODEL NUMBER LABEL
422	P0561422 TOUCH-UP PAINT, GRIZZLY GREEN
423	P0561423 TOUCH-UP PAINT, GRIZZLY PUTTY

**⚠️ 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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