MODEL G0580
14" BANDSAW
OWNER'S MANUAL
(For models manufactured since 03/25)

C US
181721

#CA6492 PRINTED IN TAIWAN
V2.03.25

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

⚠ WARNING!

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

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

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

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

⚠ WARNING!

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

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

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

Table of Contents

INTRODUCTION

Contact Info

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

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

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

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

⚠WARNING

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

⚠CAUTION

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

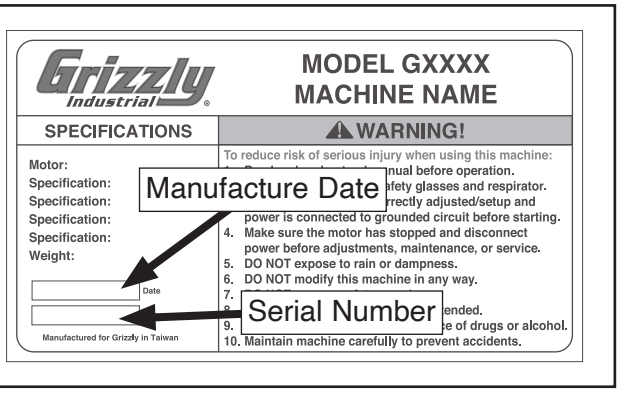
Manual Accuracy

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

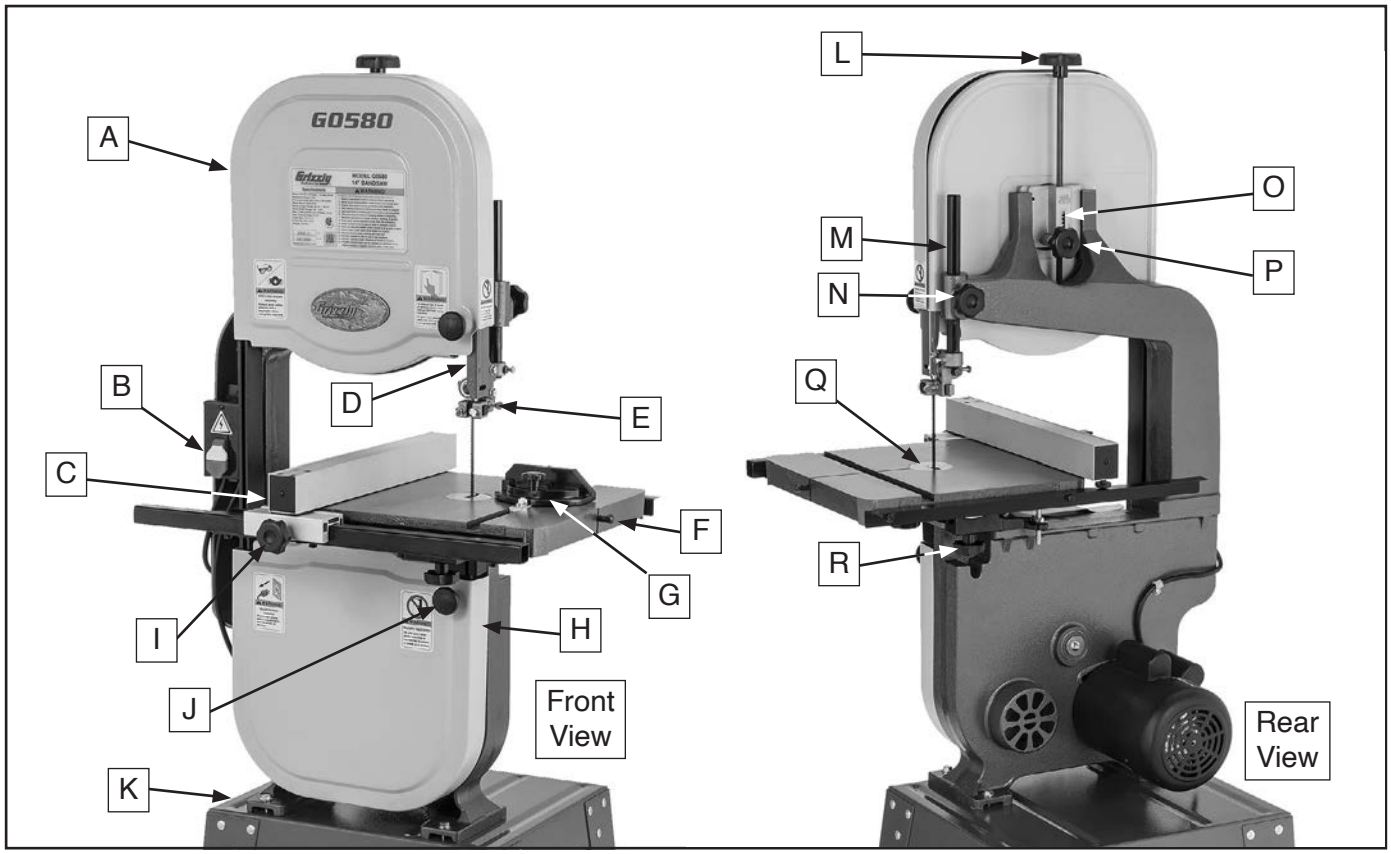
We made every effort to be exact with the instructions, specifications, drawings, and photographs in this manual. Sometimes we make mistakes, but our policy of continuous improvement also means that **sometimes the machine you receive is slightly different than shown in the manual**.

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

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



Identification



A. Upper Wheel Cover
B. ON/OFF Switch w/Disabling Key
C. Fence
D. Blade Guard
E. Upper Blade Guide Assembly
F. Table Pin
G. Miter Gauge Assembly
H. Lower Wheel Cover
I. Fence Lock Knob
J. Front Table Lock Knob
K. Stand Assembly
L. Blade Tension Adjustment Knob
M. Guide Post
N. Guide Post Lock Knob
O. Blade Tension Scale
P. Blade Tracking Adjustment Knob
Q. Table Insert
R. Rear Table Lock Knob

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating Saw.

a) Wear eye protection.
b) Do not remove jammed cutoff pieces until blade has stopped.
c) Maintain proper adjustment of blade tension, blade guides, and support bearings.
d) Adjust upper blade guide to just clear workpiece.
e) Hold workpiece firmly against table.

MACHINE DATA SHEET

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

MODEL G0580 14" BANDSAW 3/4 HP

Product Dimensions:

Weight..... 167 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 26 x 27 x 67-1/4 in.
Footprint (Length x Width)..... 24 x 22 in.

Shipping Dimensions:

Type..... Cardboard Box
Content..... Machine
Weight..... 178 lbs.
Length x Width x Height..... 45 x 20 x 15 in.
Must Ship Upright..... Yes

Electrical:

Power Requirement..... 115V or 230V, Single-Phase, 60 Hz
Prewired Voltage..... 115V
Full-Load Current Rating..... 9A at 115V, 4.5A at 230V
Minimum Circuit Size..... 15A at 115V, 15A at 230V
Connection Type..... Cord & Plug
Power Cord Included..... Yes
Power Cord Length..... 6 ft.
Power Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... 5-15 for 115V
Recommended Plug Type..... 6-15 for 230V
Switch Type..... Paddle Safety Switch w/Removable Key

Motors:

Main

Horsepower..... 3/4 HP
Phase..... Single-Phase
Amps..... 9A/4.5A
Speed..... 1725 RPM
Type..... TEFC Capacitor-Start Induction
Power Transfer ..... V-Belt Drive
Bearings..... Shielded & Permanently Lubricated
Centrifugal Switch/Contacts Type..... External

Main Specifications:

Main Specifications

Bandsaw Size..... 14 in.
Max Cutting Width (Left of Blade)..... 13-1/2 in.
Max Cutting Width (Left of Blade) w/Fence..... 11-7/8 in.
Max Cutting Height (Resaw Height)..... 6-1/4 in.
Blade Speeds..... 3000 FPM

Blade Information

Standard Blade Length	93-1/2 in.
Blade Length Range	92-1/2 – 93-1/2 in.
Blade Width Range	1/8 – 3/4 in.
Type of Blade Guides	Plastic Guide Blocks
Guide Post Adjustment Type	Manual
Has Quick-Release	No

Table Information

Table Length	14 in.
Table Width	14 in.
Table Thickness	1-1/2 in.
Table Tilt	Left 15, Right 45 deg.
Table Tilt Adjustment Type	Manual
Floor-to-Table Height	44-1/2 in.
Fence Locking Position	Front
Fence is Adjustable for Blade Lead	Yes
Resaw Fence Attachment Included	No
Miter Gauge Included	Yes

Construction Materials

Table	Precision Ground Cast Iron
Trunnion	Aluminum
Fence	Aluminum
Base/Stand	Pre-Formed Steel
Frame/Body	Cast Iron
Wheels	Computer-Balanced Cast Aluminum
Tire	Rubber
Wheel Cover	Pre-Formed Steel
Paint Type/Finish	Powder Coating & Ure

Other Related Information

Wheel Diameter	13-3/4 in.
Wheel Width	1-1/8 in.
Number of Dust Ports	1
Dust Port Size	4 in.
Compatible Mobile Base	D2057A

Other Specifications:

Country of Origin	Taiwan
Warranty	1 Year
Approximate Assembly & Setup Time	1 Hour
Serial Number Location	ID Label on Upper Wheel Cover
ISO 9001 Factory	Yes
Certified by a Nationally Recognized Testing Laboratory (NRTL)	Yes

Features:

Upper and Lower Guide Blocks and Thrust Bearings
Green and Putty Powder-Coat Paint
Open Frame Stand
Cast-Iron Frame
All Ball Bearing Construction
Aluminum Rip Fence
4" Dust Port
Hinged Wheel Covers
Included 3/8" Blade
Included Miter Gauge
Maximum Cutting Height 12" With Optional Riser Block Installed
Computer Balanced Cast Aluminum Wheels with Rubber Tires

SECTION 1: SAFETY

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

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

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

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

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

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

Safety Instructions for Machinery

⚠WARNING

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

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

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

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

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

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

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

⚠WARNING

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

Additional Safety for Bandsaws

⚠WARNING

Serious cuts, amputation, or death can occur from contact with the moving saw blade during operation or if blade breakage occurs. Serious injury or death can also occur from getting fingers, hair, or clothing entangled in moving parts if the machine is operated while the doors are open. To reduce this risk, anyone operating this machine MUST completely heed the hazards and warnings below.

HAND PLACEMENT. Placing hands or fingers in line with blade during operation may result in serious injury if hands slip or workpiece moves unexpectedly. Do not position fingers or hands in line with blade, and never reach under table while blade is moving.

SMALL/NARROW WORKPIECES. If hands slip during a cut while holding small workpieces with fingers, serious personal injury could occur. Always support/feed small or narrow workpieces with push sticks, push blocks, jig, vise, clamping fixture.

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

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

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

CLEARING JAMS AND CUTOFFS. Always stop bandsaw and disconnect power before clearing scrap pieces that get stuck between blade and table insert. Use brush or push stick, not hands, to clean chips/cutoff scraps from table.

BLADE CONTROL. To avoid risk of injury due to blade contact, always allow blade to stop on its own. DO NOT try to stop or slow blade with your hand or the workpiece.

GUARDS/COVERS. Blade guards and covers protect operator from moving bandsaw blade. The wheel covers protect operator from getting entangled with rotating wheels or other moving parts. ONLY operate bandsaw with blade guard in proper position and wheel covers completely closed.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure blade teeth face down toward table and blade is properly tensioned and tracked before operating.

UPPER BLADE GUIDE SUPPORT. To reduce exposure of operator to blade and provide maximum blade support while cutting, keep upper blade guides adjusted to just clear workpiece.

CUTTING TECHNIQUES. To avoid blade getting pulled off wheels or accidentally breaking and striking operator, always turn bandsaw ***OFF*** and wait for blade to come to a complete stop before backing workpiece out of blade. DO NOT back workpiece away from blade while bandsaw is running. DO NOT force or twist blade while cutting, especially when sawing small curves. This could result in blade damage or breakage.

WORKPIECE SUPPORT. To maintain maximum control and reduce risk of blade contact/breakage, always ensure adequate support of long/large workpieces. Always keep workpiece flat and firm against table/fence when cutting to avoid loss of control. If necessary, use a jig or other workholding device.

WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is NOT designed to cut metal, glass, stone, tile, etc.

SECTION 2: POWER SUPPLY

Availability

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

⚠WARNING

Electrocution, fire, shock, or equipment damage may occur if machine is not properly grounded and connected to power supply.

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 ..... 9 Amps
Full-Load Current Rating at 230V .... 4.5 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.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

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

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 115V
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 230V
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.

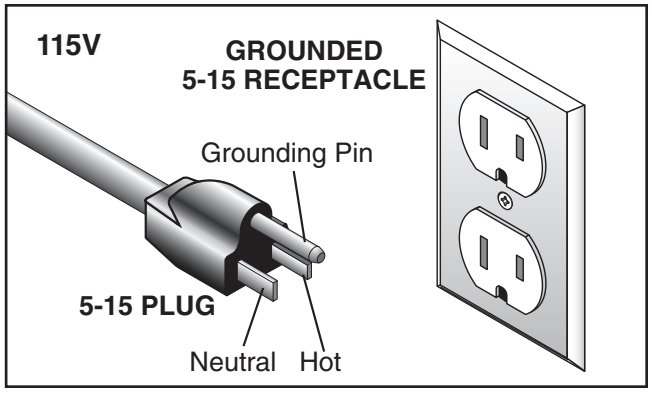
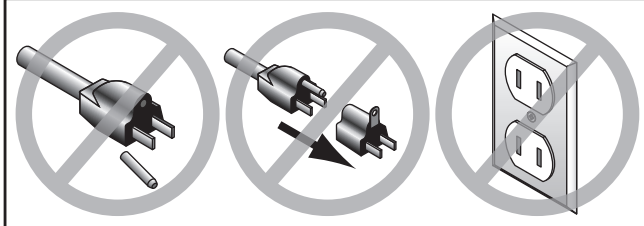


Figure 1. Typical 5-15 plug and receptacle.

⚠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 inside 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.

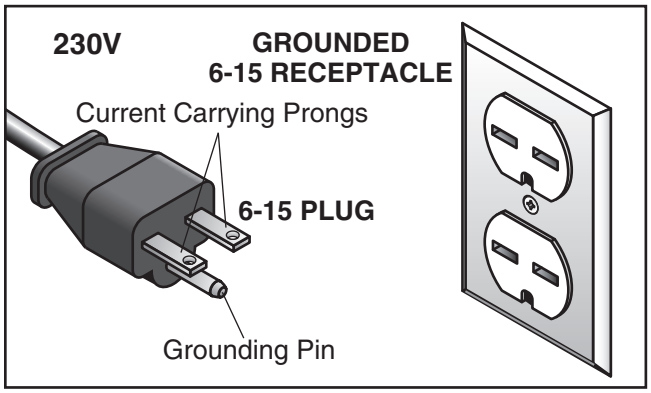


Figure 2. Typical 6-15 plug and receptacle.

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.

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 machine is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

Extension Cords

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

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

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

Minimum Gauge Size.....14 AWG
Maximum Length (Shorter is Better).....50 ft.

Voltage Conversion to 230V

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

The voltage conversion procedure consists of rewiring the motor and installing the correct plug. A wiring diagram is provided on **Page 55** for your reference.

IMPORTANT: *If the diagram included on the motor conflicts with the one on **Page 55**, the motor may have changed since the manual was printed. Use the diagram included on the motor instead.*

Items Needed **Qty**

- Phillips Head Screwdriver #2 1
- Electrical Tape..... As Needed
- Wire Nut (14 AWG x 3) 1
- Plug 6-15 1

To convert the Model G0580 to 230V:

1. DISCONNECT SAW FROM POWER!

2. Remove the existing 5-15 plug.

3. Open the motor junction box, then loosen the two wire nuts indicated in **Figure 3**.

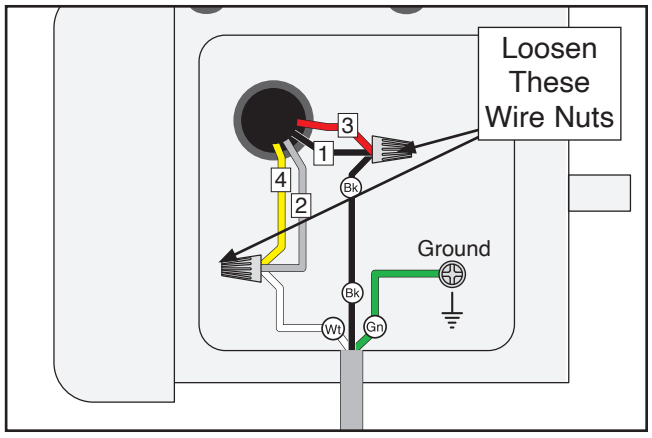


Figure 3. Location of wire nuts to be loosened.

4. Use wire nuts to connect the wires as indicated in **Figure 4**. Twist the wire nuts onto their respective wires and secure them to the wires with electrical tape so they will not come loose.

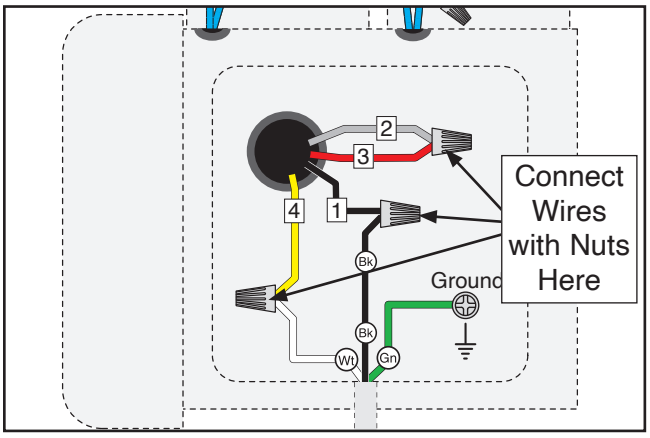
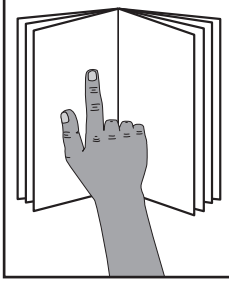


Figure 4. Saw motor rewired to 230V.

5. Close and secure the motor junction box.

6. Install a 6-15 plug on the power cord, according to the plug manufacturer's instructions. If the plug manufacturer's instructions are not available, NEMA standard 6-15 plug wiring is provided on **Page 55**.

SECTION 3: SETUP

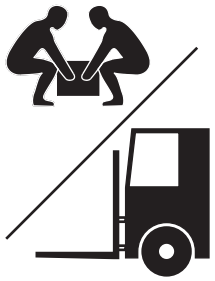


⚠WARNING

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 are needed to complete the setup process, but are not included with your machine.

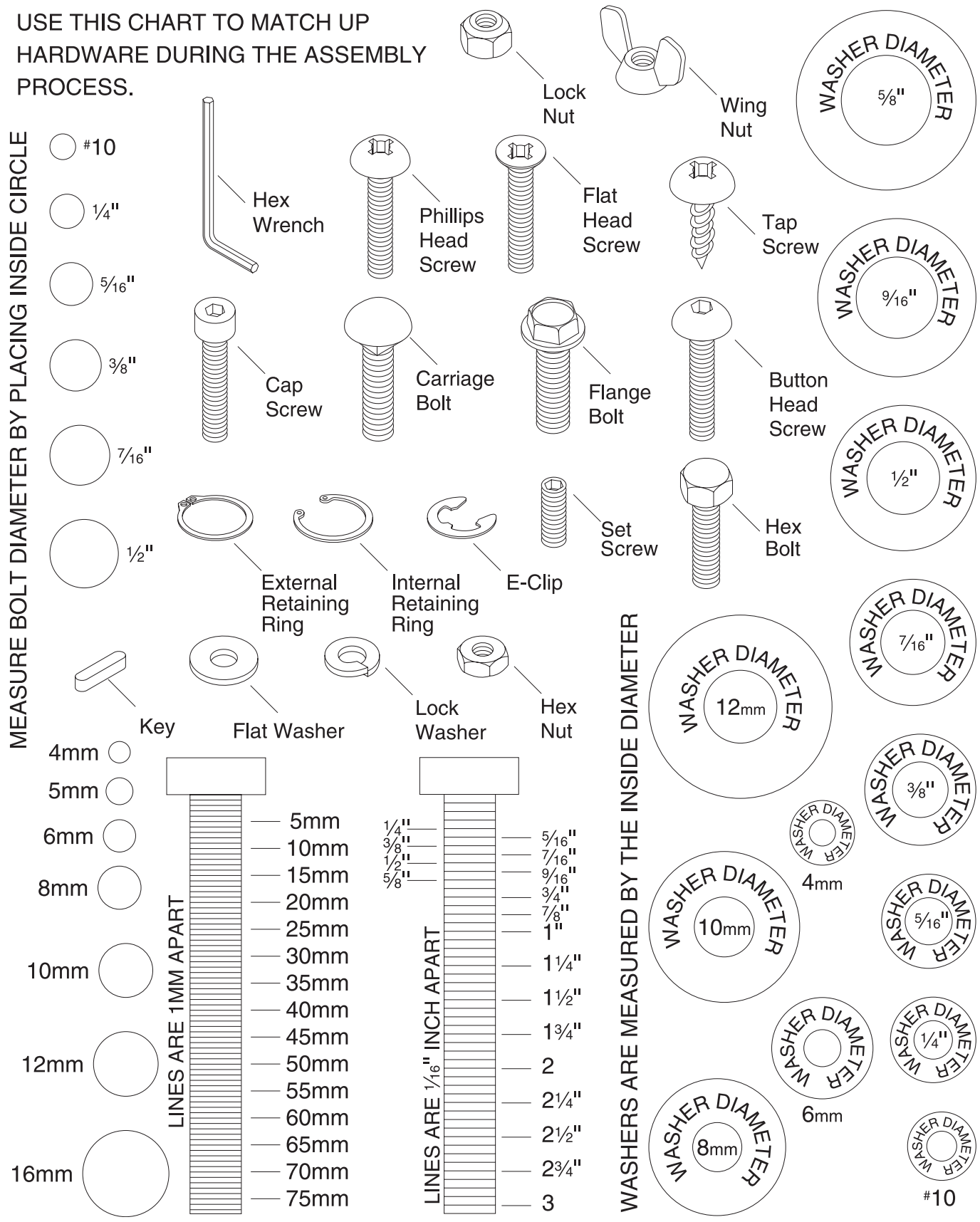
Description	Qty
• Additional Person for Lifting	1
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags	As Needed
• Safety Glasses (each person)	1
• Dust Collection System	1
• Dust Hose 4"	1
• Hose Clamps 4"	2
• Wrenches or Sockets 13mm	2
• Wrench 10mm	1
• Hex Wrench 6mm	1
• Hex Wrench 5mm	1
• Phillips Head Screwdriver #2	1
• Machinist's Square	1
• Ruler	1
• Straightedge	1
• Leather Gloves (pair)	1
• Feeler Gauge 0.016"	1
• 2x4 Stock	1
• Large Cardboard or Blanket	1

Unpacking

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

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

Hardware Recognition Chart



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.

Shipping Inventory (Figures 6–7) **Qty**

A. Body Assembly 1
B. Legs 4
C. Base Plate 1
D. Leg Braces, Long 2
E. Leg Braces, Short 2
F. Hardware Bag 1 1
—Upper Guide Assembly 1
—Lower Guide Assembly 1
—Blade Guard 1
—Lower Guard 1
—Knobs M10-1.5 2
G. Hardware Bag 2 1
—Carriage Bolts M8-1.25 x 16 40
—Flange Nuts M8-1.25 40
H. Hardware Bag 3 1
—Metal Cord Clamp 1
—Plastic Cord Clamp 1
—Phillips Head Screws M5-.8 x 12 3
—External Tooth Washer 5mm 2
—Flat Washers 6mm x 16mm 4
—Hex Bolts M6-1 x 10 2
—Hex Bolts M6-1 x 20 2
—Flat Washers 6mm x 13mm 2
—Cap Screws M8-1.25 x 25 2
—Lock Washers 8mm 8
—Flat Washers 8mm 2
—Hex Bolts M6-1 x 16 1
—Hex Bolts M8-1.25 x 35 4
—Flat Washers 8mm 8
—Hex Nuts M8-1.25 5
—Hex Bolts M8-1.25 x 30 2
—Hex Bolts M8-1.25 x 80 1
I. Table 1
J. Miter Gauge 1
K. Trunnion Support Bracket 1
L. Motor with Pulley and Switch 1

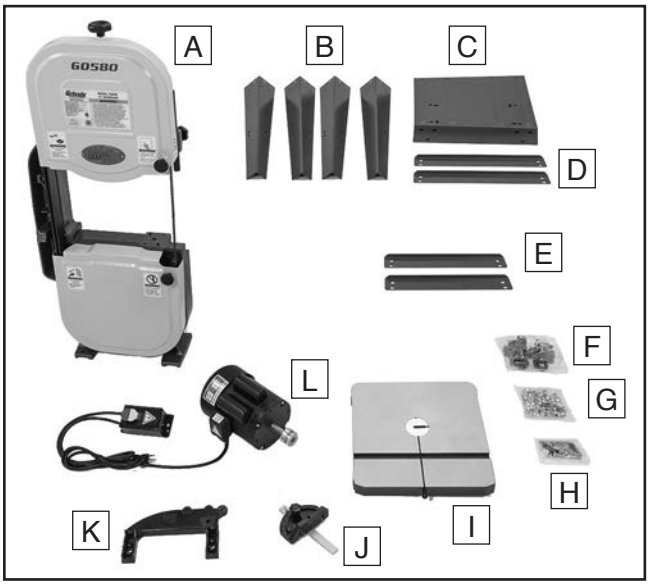


Figure 5. Inventory contents.

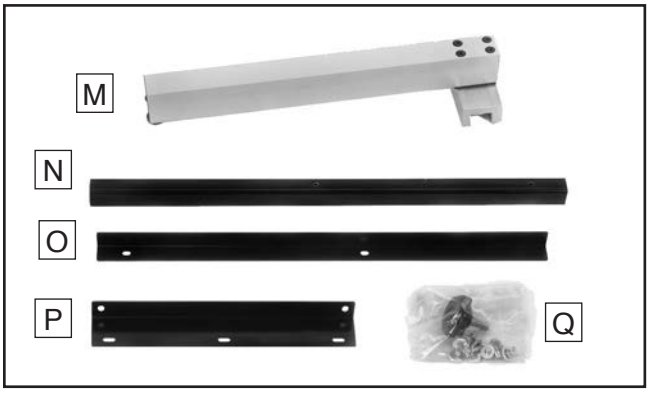


Figure 6. Additional inventory contents.

M. Fence Body 1
N. Rear Angled Rail 1
O. Front Square Rail 1
P. Front Rail 1
Q. Hardware Bag 4 1
—Hex Bolts M6-1 x 10 4
—Hex Bolts M6-1 x 20 4
—Lock Washers 6mm 8
—Flat Washers 6mm 8
—Knob Bolt M10-1.5 x 25 1
—Fence Adjustment Screw M6-1 x 20 1
—Hex Nut M6-1 1

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.

Cleanup

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

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

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

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

Basic steps for removing rust preventative:

1. Put on safety glasses.

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

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

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

⚠WARNING

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

⚠CAUTION

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

NOTICE

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

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

Order online at
www.grizzly.com
OR
Call 1-800-523-4777

Figure 7. T23692 Orange Power Degreaser.

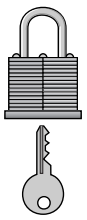
Site Considerations

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.**



⚠CAUTION

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

Physical Environment

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

Electrical Installation

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

Lighting

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

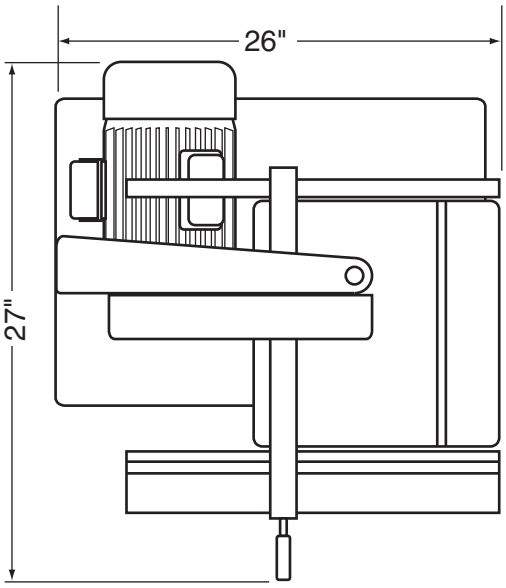


Figure 8. Minimum working clearances.

Assembling Stand

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).

Components and Hardware Needed:	**Qty**
Carriage Bolts M8-1.25 x 16	40
Flange Nuts M8-1.25	40
Hex Bolts M8-1.25 x 35	4
Lock Washers 8mm	4
Base Plate	1
Legs	4
Braces, Long	2
Braces, Short	2
2x4 Stock	1
Large Cardboard or Blanket	1
Assistant	1

Tools Needed:	**Qty**
Wrench or Socket 13mm	1

⚠WARNING

The Model G0580 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

To assemble stand:

1. Place base plate upside down on flattened cardboard, and loosely attach legs to outside corners using (24) M8-1.25 x 16 carriage bolts and flange nuts, as shown in **Figure 9**.

   Note: *Install carriage bolts with round end facing out.*

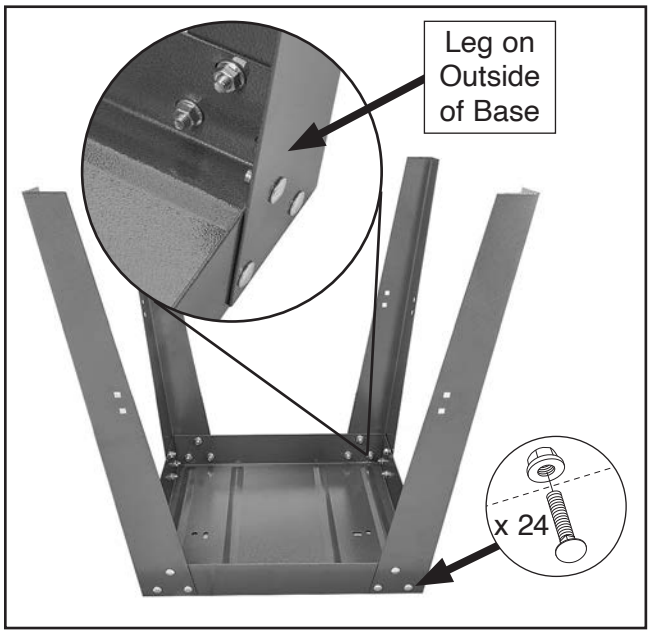


Figure 9. Leg attached to base.

2. Loosely attach front/rear leg braces and side braces to the legs using (16) M8-1.25 x 16 carriage bolts and flange nuts (see **Figure 10**).

   Note: *Grizzly logo on long brace should be upside down and on same side as oblong mounting holes on base plate.*

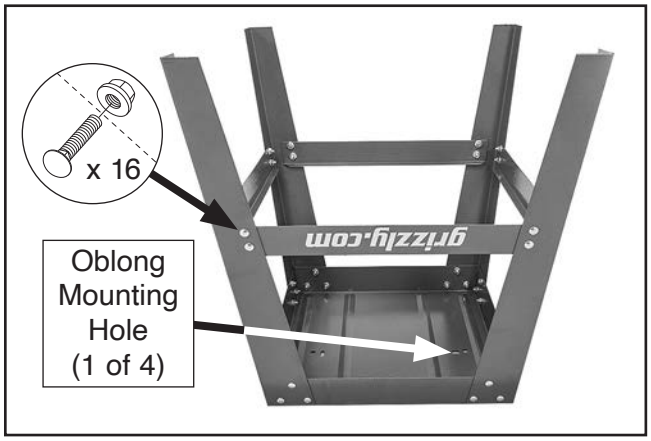


Figure 10. Legs and braces attached.

3. Turn stand right side up, make sure it sits level, then tighten all hex nuts.

4. Arrange large cardboard or cloth on floor to protect machine.

5. Lay stand on side with base plate propped up on 2x4 stock on top of cardboard or blanket (see **Figure 11**).

   Note: *Mounting holes should be along right vertical edge.*

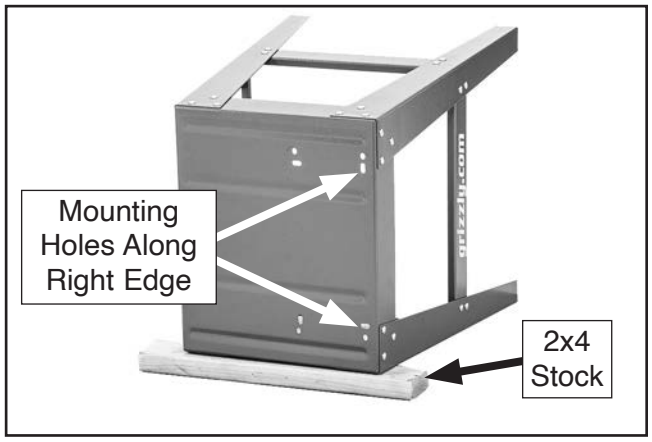


Figure 11. Stand on floor.

6. With help of assistant, position machine horizontally in line with mounting holes as shown in **Figure 12**.

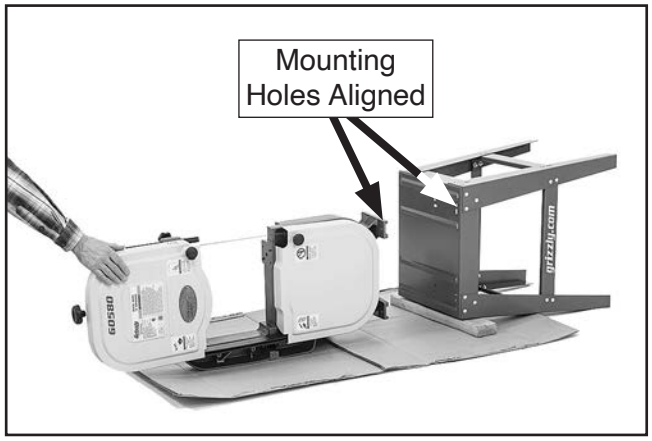


Figure 12. Aligning machine with stand.

7. Insert (4) M8-1.25 x 35mm hex bolts through 8mm flat washers, machine feet, and oblong mounting holes in base plate, then secure with (4) 8mm lock washers and hex nuts (see **Figure 13**).

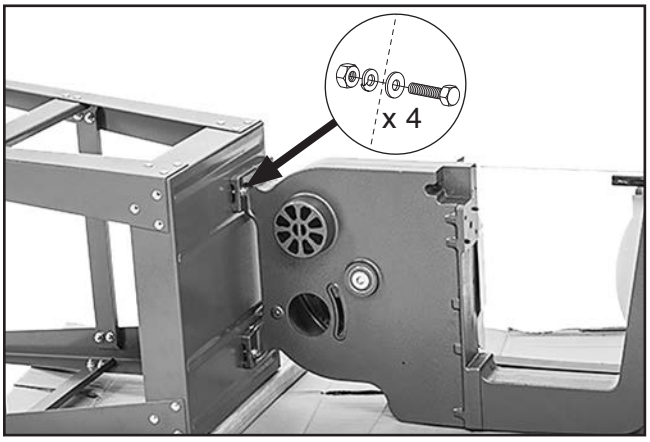


Figure 13. Mounting bolt locations.

8. Stand machine upright with aid of assistant.

Assembling Motor & Switch

Components and Hardware Needed:	Qty
Motor	1
Switch	1
Cap Screws M8-1.25 x 25	2
Flat Washers 8mm	2
Lock Washers 8mm	2
Phillips Head Screws M5-.8 x 12	3
External Tooth Washer 5mm	1
Metal Cord Clamp	1
Plastic Cord Clamp	1

Tools Needed:	Qty
Hex Wrench 6mm	1
Phillips Screwdriver	1

To install the motor and switch:

1. Place motor into motor mounting area on bottom of main body, as shown in **Figure 14**.

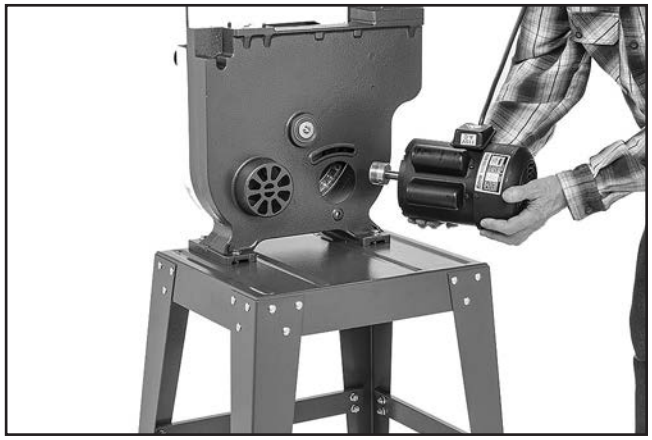


Figure 14. Placing motor on body.

2. Loosely thread (2) M8-1.25 x 25 cap screws, 8mm flat washers, and 8mm lock washers into the motor (see **Figure 15**).

3. Place the V-belt on the pulley, move the motor to the left with moderate pressure, and tighten the cap screws

4. Push the belt with moderate pressure. If the belt deflects more than 3/4", repeat **Step 3**.

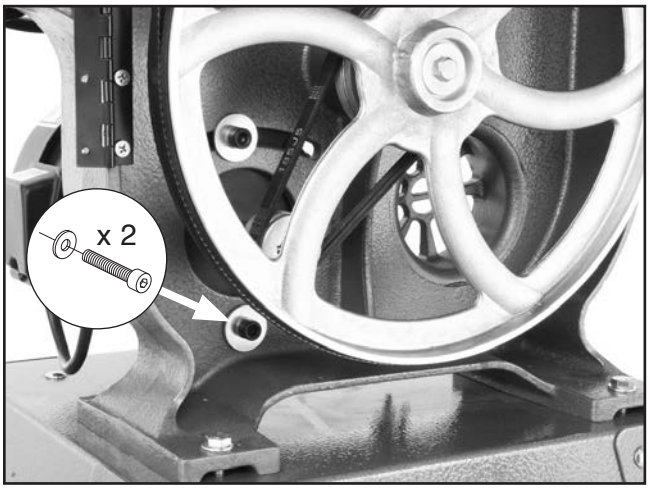


Figure 15. Installed cap screws.

5. Attach the switch to the body with (2) pre-installed M5-.8 x 16 Phillips head screws, then ground the switch with (1) M5-.8 x 12 Phillips head screw and 5mm external tooth washer (see **Figure 16**).

Figure 16. Attaching the switch.

6. Secure the cords on the front of the bandsaw body with the metal cord clamp and (1) M5-.8 x 12 Phillips head screw.

7. Secure the cord on the rear of the bandsaw body with the plastic cord clamp (see **Figure 16**) and (1) M5-.8 x 12 Phillips head screw.

Assembling Blade Guides

Components and Hardware Needed:	Qty
Upper Guide Assembly	1
Lower Guide Assembly	1
Blade Guard	1
Lower Guard	1
Hex Bolts M6-1 x 20	2
Hex Bolts M6-1 x 10	2
Hex Bolt M6-1 x 16	1
Flat Washers 6mm x 16mm	2
Flat Washers 6mm x 13mm	2

Tools Needed:	Qty
Wrench 10mm	1

To install the lower blade guide:

1. Align and place the lower guard onto the body.

2. Align and place the lower guide assembly onto the lower guard, and secure with (2) M6-1 x 20 hex bolts and 6mm flat washers, as shown in **Figure 17**.

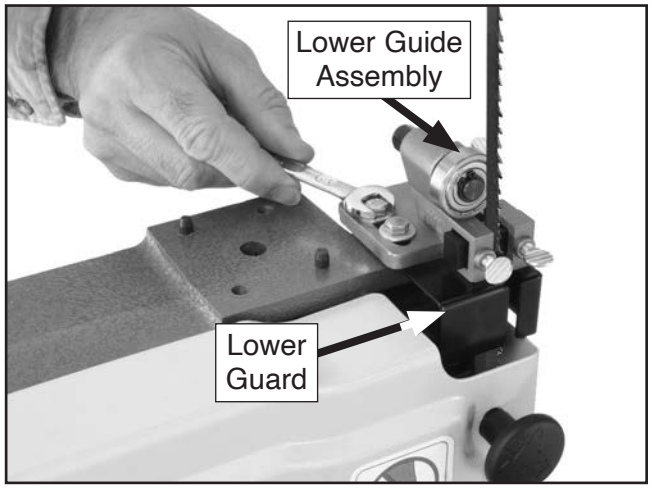


Figure 17. Installing lower blade guide assembly.

To install the upper blade guide assembly:

1. Slide the upper guide assembly onto the guide post until the bottom of the guide post is flush with the bottom of the blade guide post housing, and secure with (1) M6-1 x 16 hex bolt, as shown in **Figure 18**.

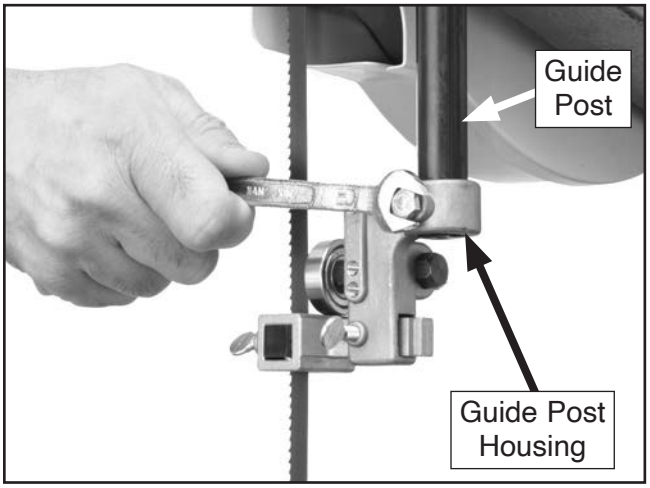


Figure 18. Installing upper blade guide.

2. Attach the upper guard to the upper guide assembly with (2) M6-1 x 10 hex nuts and 6mm flat washers, as shown in **Figure 19**.

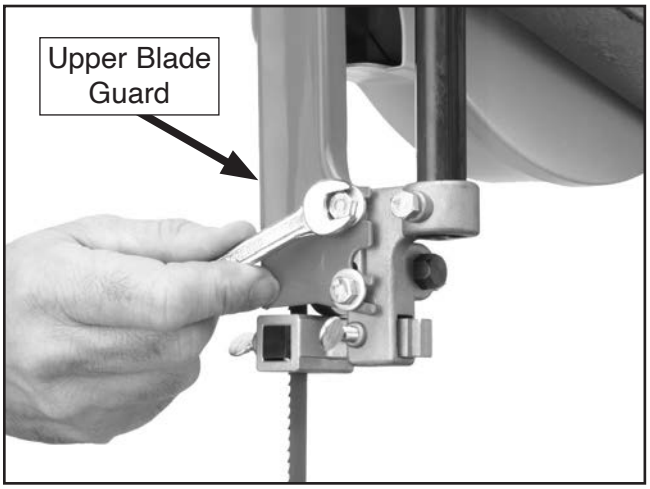


Figure 19. Installing upper blade guard.

Assembling Table

Components and Hardware Needed:	Qty
Trunnion Support Bracket	1
Table with Trunnions	1
Hex Bolts M8-1.25 x 30	2
Hex Bolt M18-1.25 x 80	1
Hex Nut M8-1.25	1
Lock Washers 8mm	2
Knobs M10-1.5	2

Tools Needed:	Qty
Wrench 13mm	1

To install the table:

1. Align the trunnion support bracket with the pins and bolt holes in the body, as shown in **Figure 20**.

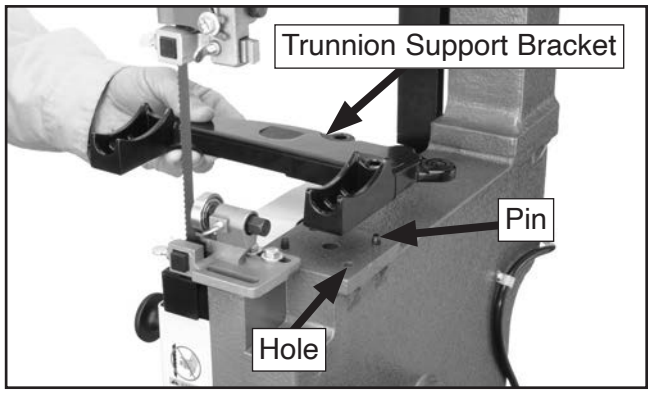


Figure 20. Aligning trunnion support bracket with pins and bolt holes.

2. Secure the trunnion support bracket with (2) M8-1.25 x 30 hex bolts and 8mm lock washers, as shown in **Figure 21**.

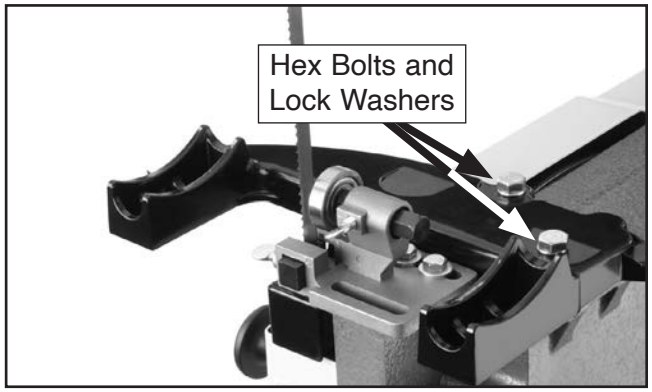


Figure 21. Trunnion support bracket installed.

3. Thread (1) M8-1.25 hex nut onto the M8-1.25 x 80 positive stop hex bolt, then thread the bolt into the trunnion support bracket so it protrudes 2" above the bracket (see **Figure 22**). This will allow the table to rest approximately level when it is installed.

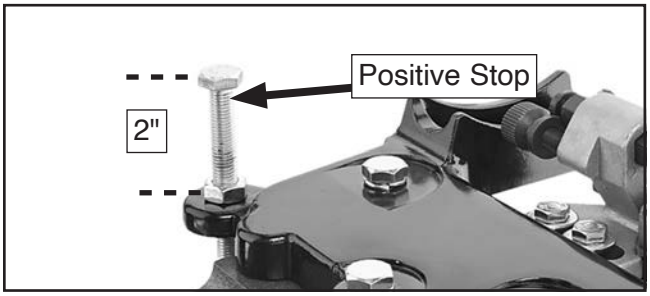


Figure 22. Positive stop installed.

4. Remove the table pin and table insert shown in **Figure 23**.

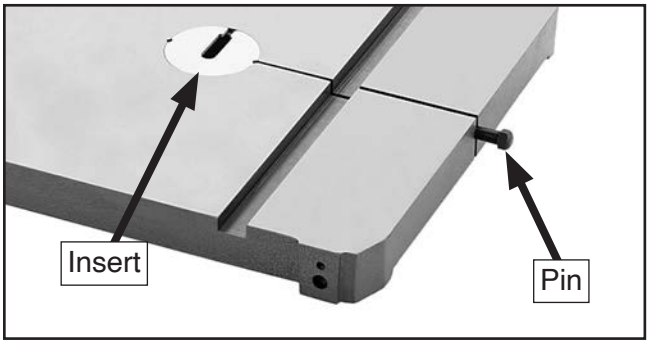


Figure 23. Table insert and pin.

5. Line up the blade with the table slot and position the table until the blade is in the center of the table, then turn the table 90˚ clockwise and rest it on the trunnion support bracket so that the hex bolts protrude from the bottom of each trunnion (see **Figure 24**).

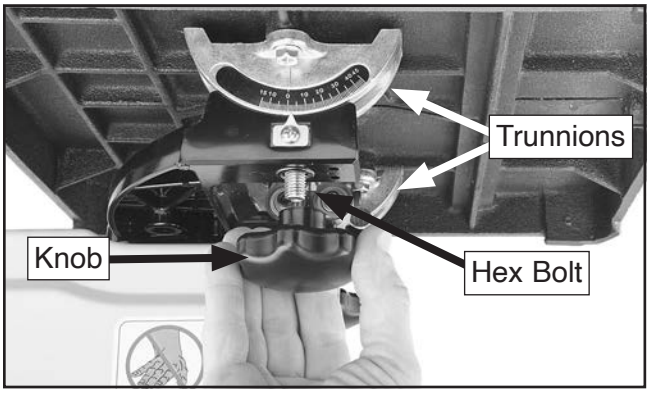


Figure 24. Securing trunnion to support bracket.

6. Thread a knob onto each hex bolt to secure the table, as shown in **Figure 24**.

7. Re-install table pin and table insert. Make sure table insert sits flush with table surface.

Assembling Fence

Components and Hardware Needed:	**Qty**
Fence Body	1
Front Angled Rail	1
Front Square Rail	1
Rear Rail	1
Hex Bolt M6-1 x 10	4
Hex Bolt M6-1 x 20	4
Lock Washer 6mm	8
Flat Washer 6mm	8
Knob Bolt M10-1.5 x 25	1
Fence Adjustment Screw M6-1 x 20	1
Hex Nut M6-1	1

Tools Needed:	**Qty**
Wrench 10mm	1

To install the fence:

1. Secure the rear rail against the rear of the table with the flat un-drilled surface facing up, using (2) M6-1 x 20 hex bolts, 6mm flat washers, and 6mm lock washers.

2. Attach front angled rail to front of table with (2) M6-1 x 20 hex bolts, 6mm flat washers, and 6mm lock washers (see **Figure 25**).

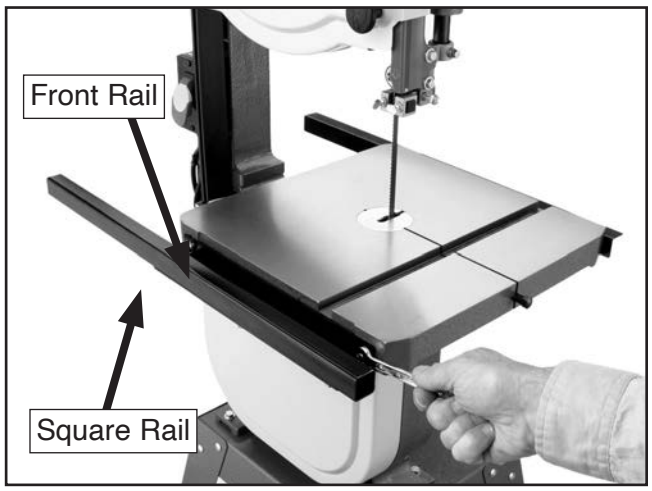


Figure 25. Installing front rail system.

3. Attach the square rail (see **Figure 25**) to the front angled rail with the four M6-1 x 10 hex bolts, lock washers, and flat washers.

4. Thread (1) M6-1 hex nut onto the fence adjustment screw and attach to bottom end of fence (see **Figure 26**).

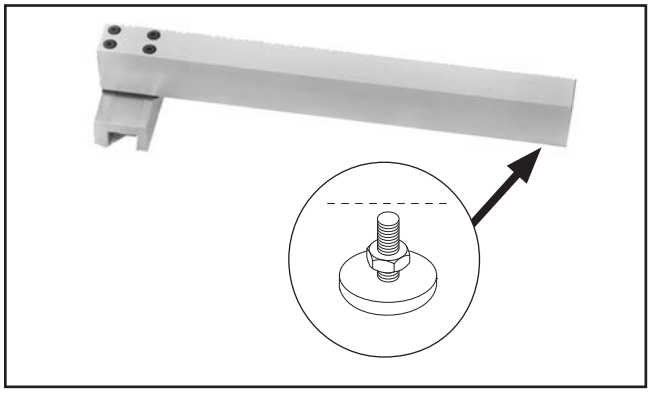


Figure 26. Location of fence adjustment screw.

5. Set the fence on the fence rail to the left of the blade.

6. Secure the fence with the M10-1.5 x 25 knob bolt (see **Figure 27**).

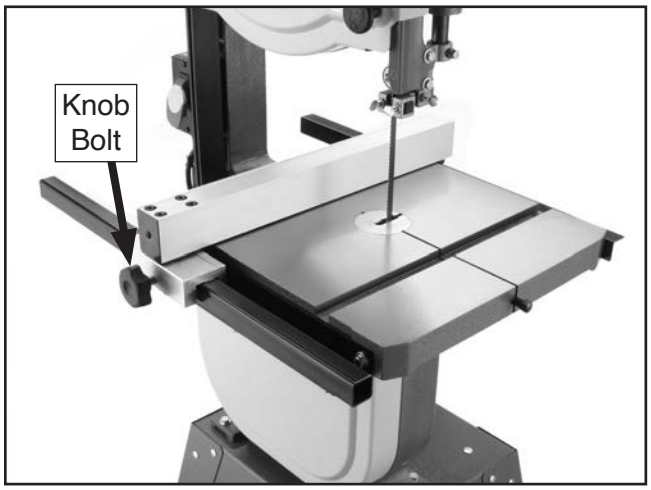


Figure 27. Correctly installed fence.

Dust Collection

⚠CAUTION

DO NOT operate this bandsaw without an adequate dust collection system. This bandsaw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 4" dust hose over the dust port, as shown in **Figure 28**, and secure in place with a hose clamp.

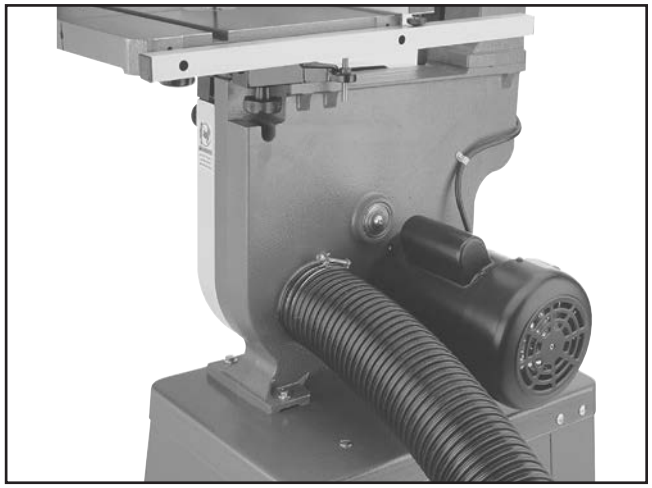


Figure 28. Example of attached dust hose.

2. Tug the hose to make sure it does not come off.

   Note: *A tight fit is necessary for proper performance.*

Adjusting Positive Stop

The positive stop allows the table to be reset 90° to the blade after tilting to the right.

Tools Needed:	**Qty**
Wrenches 13mm	2
Machinist's Square	1

To set the positive stop:

1. Ensure the blade is correctly tensioned as described in **Tensioning Blade** instructions on **Page 26**.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the jam nut that locks the positive stop adjust bolt in place.

4. Raise the guide post and place a machinist's square on the table next to the side of the blade, as illustrated in **Figure 29**. Tilt the table until it rests 90° to the blade, then secure it with the table tilt knobs.

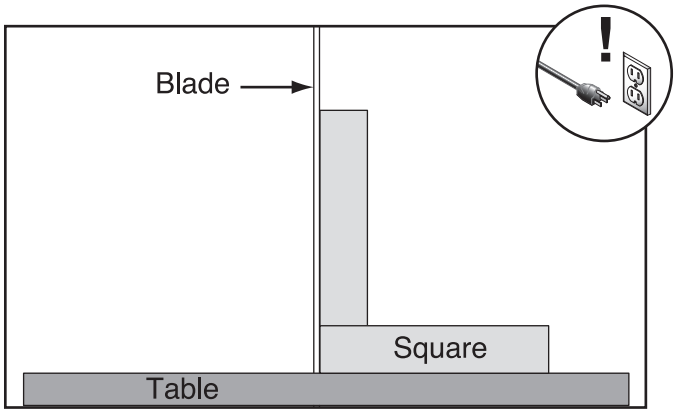


Figure 29. Squaring table to blade.

5. Adjust the positive stop bolt to the adjusted height of the table and tighten the jam nut.

6. Rest the table on the positive stop bolt and check for accuracy.

   Note: *See Calibrating Table Tilt Scale on **Page 29**.*

Blade Center Tracking

Blade tracking is affected by the tilt of the upper wheel (known as center tracking) and the alignment of both wheels (coplanar tracking).

The wheels on this bandsaw were aligned at the factory, so center tracking is the only adjustment that needs to be performed when the saw is new (refer to the **Wheel Alignment** on **Page 50** for detailed instructions on coplanar tracking).

Note: *Changes in the blade tension may change the blade tracking. For best performance, regularly check and maintain the proper blade tracking.*

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the upper and lower blade guides away from the blade (refer to **Adjusting Blade Guides** on **Page 28** for detailed instructions).

   Note: *When adjusting the blade tracking, the blade must have a reasonable amount of tension to simulate operating conditions. After the **Test Run** is successfully completed, you will perform a thorough version of the following steps to correctly tension the blade.*

3. Use the blade tension adjustment knob to adjust blade tension until the mark on the blade tension scale matches the size of the installed blade.

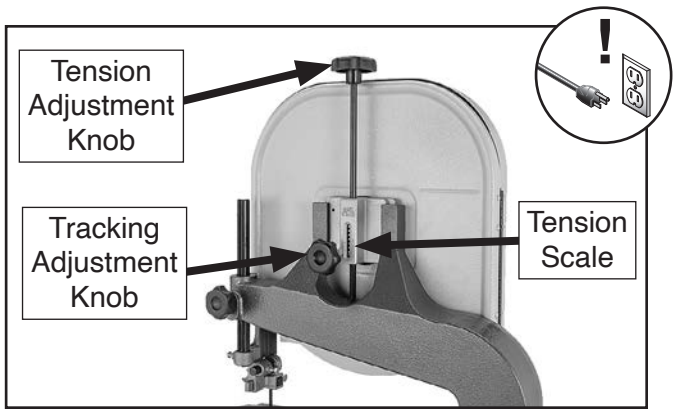


Figure 30. Blade tension and center tracking controls.

4. Open the upper wheel cover, then spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 31** for an illustration of this concept.

   — **If the blade rides on the center of the crown**, then the bandsaw is already tracked properly and no additional adjustments are needed. Skip to **Step 9**.

   — **If the blade does not ride on the center of the crown,** then continue with the next step.

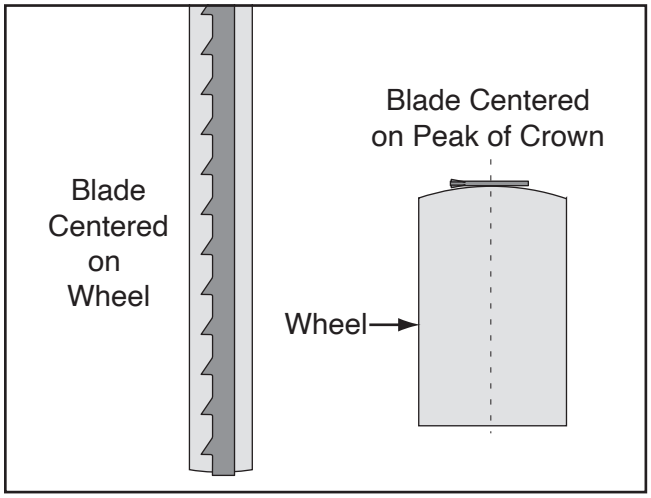


Figure 31. Profiles of blade properly center tracking.

5. Loosen the lock nut on the tracking adjustment knob threads so that the tracking adjustment knob will rotate for adjustments in the next steps.

   Note: *The blade tracking adjustment knob controls the tilt of the upper wheel which, in turn, controls the center tracking of the blade.*

7. Spin upper wheel with one hand and slowly adjust tracking knob with other hand until blade consistently tracks in center of wheel.

8. Tighten lock nut to lock setting, then spin upper wheel several times to confirm proper tracking. If necessary, repeat adjustment procedure until blade is tracking properly.

9. Re-adjust blade guide bearings toward blade (refer to **Adjusting Blade Guides** on **Page 28** for detailed instructions).

10. Close and secure upper wheel cover before operating bandsaw.

Test Run

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

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

The Test Run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the switch disabling key disables the switch properly.

⚠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 the machine:

1. Clear all setup tools away from machine.

2. Connect machine to power supply.

3. Turn machine ***ON***, verify motor operation, and then turn machine ***OFF***.

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

4. Remove switch disabling key, as shown in **Figure 32**.

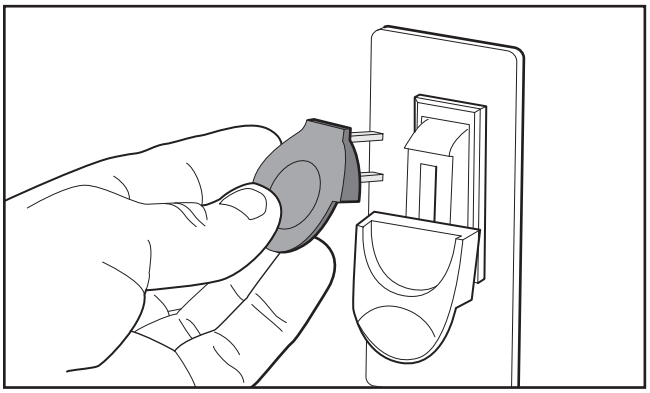


Figure 32. Removing switch key from paddle switch.

5. Try to start machine with paddle switch. The machine should not start.

   — If the machine *does not* start, the switch disabling feature is working correctly.

   — If the machine *does start*, immediately stop the machine. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is a prerequisite before making many bandsaw adjustments.

To tension the bandsaw blade:

1. Make sure you have performed the **Test Run** instructions on **Page 25** and that the blade is tracking properly.

2. Raise the upper blade guide assembly as high as it will go, and adjust the upper and lower guide blocks as far away from the blade as possible.

   Note: *This procedure will not work if the guide blocks have any contact with the blade.*

3. Adjust the blade tension knob until it matches the blade size on the bandsaw.

   Note: *This scale can only be considered as a general guide, follow these steps to accurately set the blade tension.*

4. Turn the bandsaw ***ON***.

5. Release the tension one quarter of a turn at a time. Do this very slowly. When you see the bandsaw blade start to flutter, stop decreasing the tension.

6. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension another quarter turn.

7. Look at what the tension gauge reads and use that as a guide for tensioning that blade in the future.

   Note: *Detension blade after use to increase blade life and reduce strain on machine.*

NOTICE

After blade tension and tracking are set correctly, properly adjust the upper and lower support bearings and guide-block assemblies into position before cutting operations.

Adjusting Support Bearings

The support bearings are positioned behind the blade and support the back of the blade during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

Tools Needed:	**Qty**
Wrench 10mm	1
Feeler Gauge 0.016"	1

To adjust the support bearings:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the support bearing controls shown in **Figure 33**.

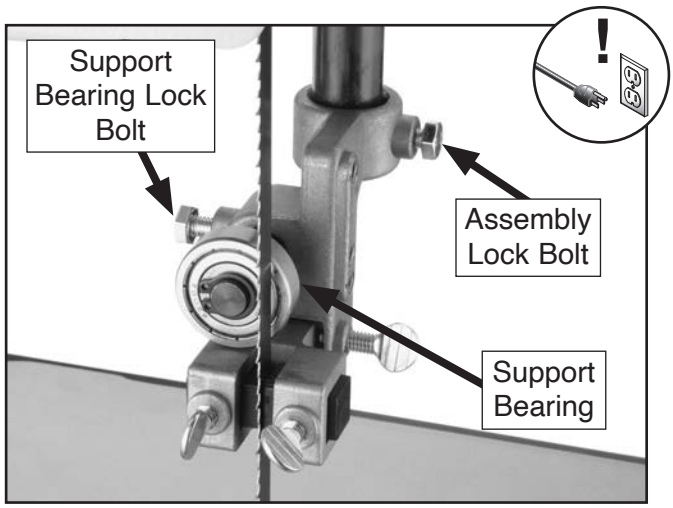


Figure 33. Support bearing controls.

4. Loosen the assembly lock bolt.

5. Look at the face of the support bearing and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing, as illustrated in **Figure 34**.

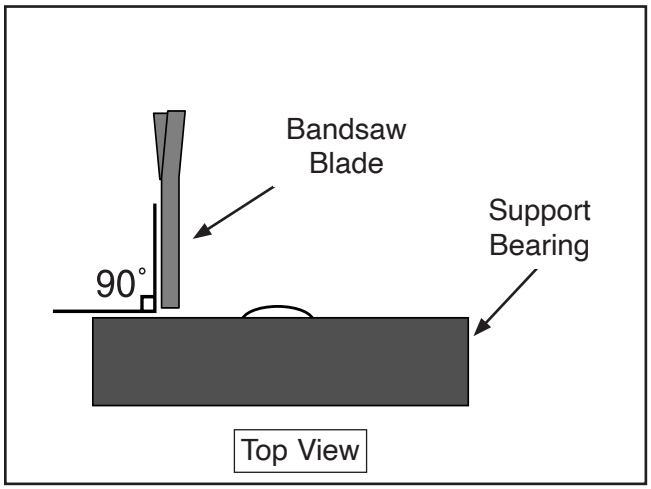


Figure 34. Blade should be perpendicular (90˚) to the face of the support bearing.

6. Tighten the assembly lock bolt.

7. Loosen the support bearing lock bolt on the support bearing adjustment shaft.

8. Using the feeler gauge, slide the support bearing approximately 0.016" away from the back of the blade, as illustrated in **Figure 35**.

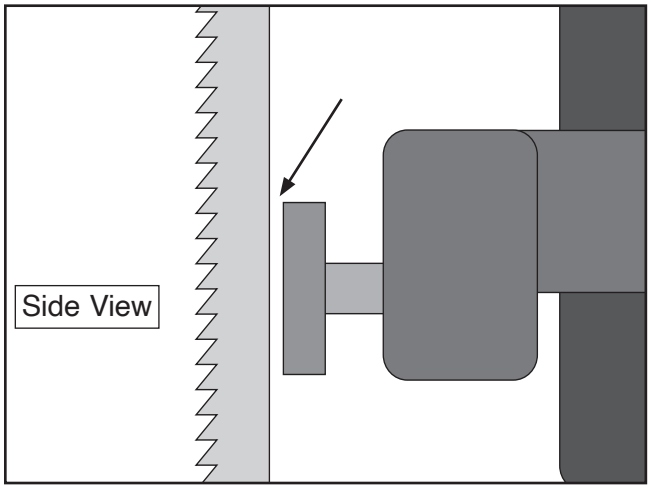


Figure 35. Blade should be aligned approximately 0.016" away from the bearing edge.

Note: *For a quick gauge, fold a dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016" and place it between the support bearing and the blade as shown in* **Figure 36**.

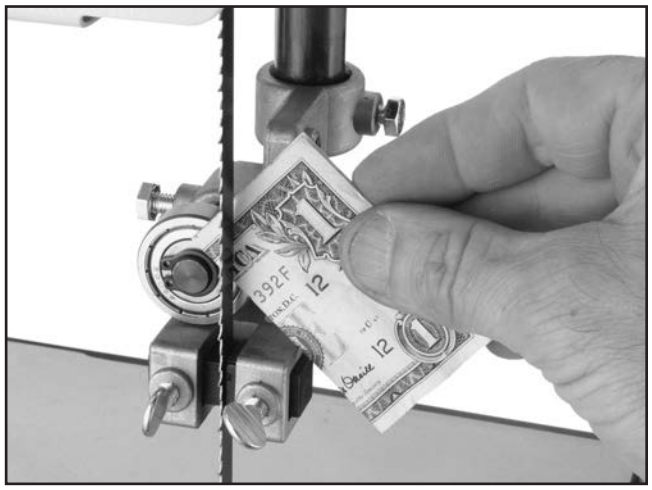


Figure 36. Dollar bill folded twice to make a quick 0.016" gauge.

9. Tighten the support bearing lock bolt to keep the support bearing locked in place.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be properly adjusted before cutting operations.

Adjusting Blade Guides

The blade guides provide side-to-side support to help keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side. Properly adjusted blade guides are essential to making accurate cuts.

To adjust the upper and lower blade guides:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Familiarize yourself with the blade guide controls shown in **Figure 37**.

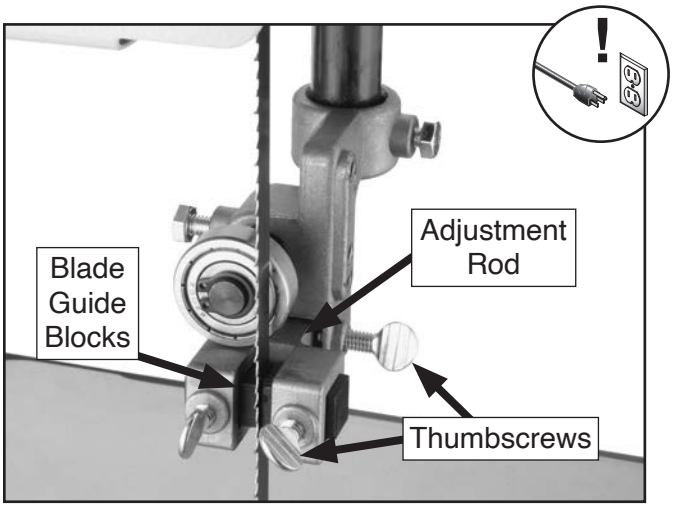


Figure 37. Blade guide controls.

4. Loosen the thumbscrew on the adjustment rod.

5. Move the guides forward or backward to position them laterally, so that the edges of the blocks are 1/16" behind the blade gullets, as illustrated in **Figure 38**.

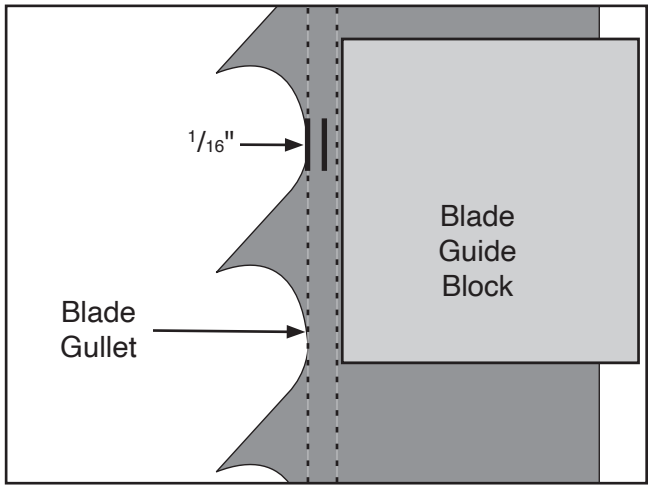


Figure 38. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide blocks when the blade is against the rear support bearing during the cut.

6. Tighten the thumbscrew on the adjustment rod.

7. Loosen the thumbscrews that secure the guide blocks.

8. Adjust the position of the blocks 0.004" away from the blade.

   Note: *0.004" is approximately the thickness of a piece of paper.*

9. Tighten the thumbscrews.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide-blocks must be properly adjusted before cutting operations.

Calibrating Table Tilt Scale

The pointer on the table tilt scale must be calibrated in order for the scale reading to be accurate.

Tools Needed: **Qty**
Phillips Screwdriver 1

To calibrate the pointer on the table tilt scale:

1. Make sure that the blade is tensioned and is tracking correctly, and that the table is 90˚ to the blade.

2. Loosen the screw on the pointer (see **Figure 39**), but do not remove it.

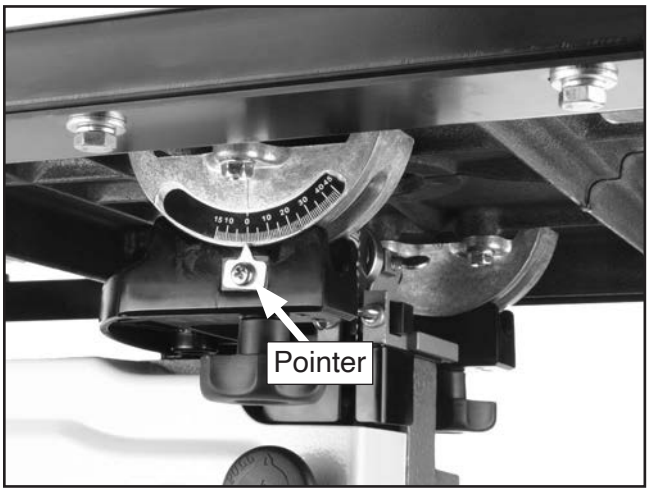


Figure 39. Table tilt scale location.

3. Align the tip of the pointer with the 0˚ mark on the table tilt scale.

4. Tighten the screw on the pointer so that the pointer is locked in place.

Aligning Table

To ensure cutting accuracy when the table is first installed, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a ¾" blade.

Tools Needed:	Qty
Wrench 10mm	1
Straightedge	1
Ruler	1

To align the miter slot parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the trunnion bolts that secure the trunnions to the table.

4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade.

   Note: *Make sure the straightedge does not go across a tooth.*

5. Use a fine ruler to gauge the distance between the blade and the miter slot. The distance you measure should be the same at both the front and the back of the table.

6. Adjust the table as needed for proper alignment.

7. Tighten the trunnion bolts.

   Note: *Refer to the **Blade Lead** instructions on **Page 53** for more table alignment adjustments.*

Aligning Fence

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

Tools Needed:	Qty
Hex Wrench 5mm	1

To align the fence parallel with the miter slot:

1. If the fence is mounted on the left-hand side of the blade, remove it and remount it next to the miter slot.

2. Loosen the four cap screws located on the top face of the fence (see **Figure 40**).

Figure 40. Loosening the fence cap screws.

3. Adjust the fence face parallel with the edge of the miter slot.

4. Tighten the four cap screws, being careful not to move the fence.

   Note: *Refer to the **Blade Lead** instructions on **Page 53** for more fence alignment adjustments.*

Calibrating Miter Gauge

To ensure cutting accuracy when using the miter gauge, the face of the miter gauge must be 90° to the side of the blade. Refer to **Aligning Fence** on **Page 27.**

Tools Needed	**Qty**
Phillips Head Screwdriver #2	1
Square	1

To calibrate miter gauge:

1. Place miter gauge on a flat surface.

2. Hold square against miter head as shown in **Figure 41**.

— If square rests flush and evenly against *both* miter head *and* miter bar, then no adjustments are necessary.

— If square *does not* rest flush, miter gauge must be calibrated. Proceed to **Step 3**.

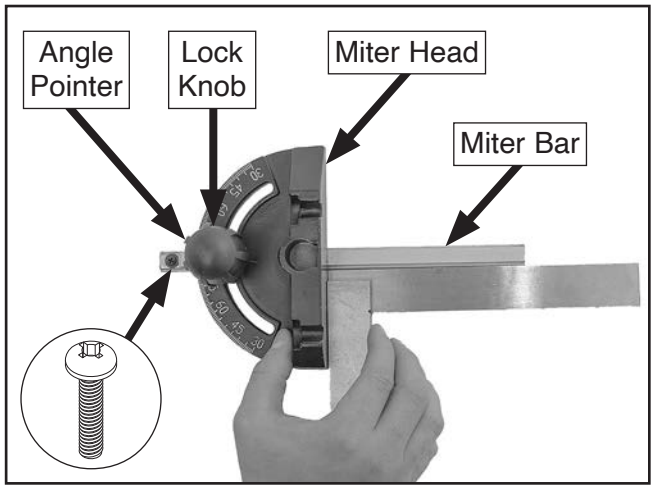


Figure 41. Example of squaring miter head to miter bar.

3. Loosen lock knob and hold square flush against miter head.

4. Pivot miter head until square rests flush and evenly against *both* miter head *and* miter bar.

5. Tighten lock knob and verify miter head and miter bar remain flush against square.

Note: *Tightening lock knob may affect adjustment.*

6. Loosen screw securing angle pointer (see **Figure 41**).

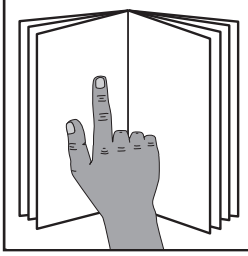
7. Adjust pointer to 0° mark on scale, then tighten screw to secure setting.

SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

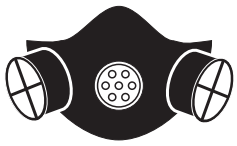


⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before operating.

⚠WARNING

Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.



NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

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

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the fence for the width of the cut and then locks it in place.
3. Adjusts the table tilt, if necessary, to the correct angle of the desired cut.
4. Loosens the guide post lock knob, adjusts the upper blade guide height to just clear the workpiece, then re-tightens the guide post lock knob.
5. Checks to make sure the workpiece can safely pass all the way through the blade without interference from other objects.
6. Puts on safety glasses and a respirator.
7. Starts the dust collector and bandsaw.
8. Holds the workpiece firmly and flatly against both the table and fence, and then pushes the workpiece into the blade at a steady and controlled rate until the workpiece moves completely beyond the blade.

   The operator is very careful to keep fingers away from the blade and uses a push stick to feed narrow workpieces.
9. Stops the bandsaw.

Disabling Switch

The switch can be disabled by removing the key, as shown below. Disabling the switch in this manner can prevent unauthorized operation of the machine, which is important if it is not kept inside an access-restricted building or in a location where children may be present.

IMPORTANT: Disabling the switch only restricts its function. It is not a substitute for disconnecting machine from power when adjusting or servicing.

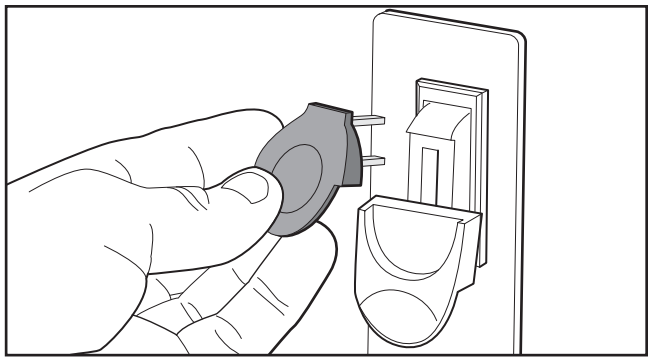


Figure 42. Disabling switch by removing key.

⚠WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, always disable switch before leaving machine unattended. Make sure to place key in a well-hidden or secure location!

Workpiece Inspection

Some workpieces are not safe to cut or may require modification before they are safe to cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a table saw may lead to injury.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator, cause kickback, or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.

- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can cause kickback and machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. On the contrary, a workpiece supported on the bowed side will rock during a cut and could cause kickback or severe injury.

Guide Post

The guide post (shown in **Figure 43**) connects the upper blade guide assembly to the bandsaw. The function of the guidepost is to allow the blade guide assembly to move up or down depending on the height of the workpiece being cut. In order to cut accurately, the blade guide assembly must be no more than 1" from the top of the workpiece at all times—this positioning provides the greatest support to the blade.

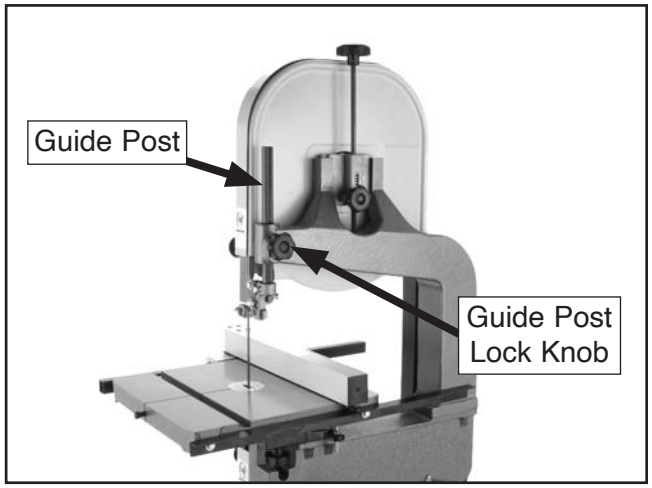


Figure 43. Guide post controls.

To adjust guide post assembly alignment on the guide post:

1. Make sure that the blade tension, blade tracking, support bearing, and blade guides are adjusted correctly.

2. Loosen the guide post lock knob shown in **Figure 43**.

3. Raise/lower the guide post to within 1" from the top of the workpiece to the bottom of the blade guide assembly.

4. Lock the guide post in place with the lock knob.

Tilting Table

The bandsaw table will tilt 15˚ left and 45˚ right to provide a wide range of cutting options. Remove the positive stop bolt to tilt the table to the left.

To tilt the table:

1. Loosen the two plastic lock knobs underneath the table that lock the table trunnion (see **Figure 44**).

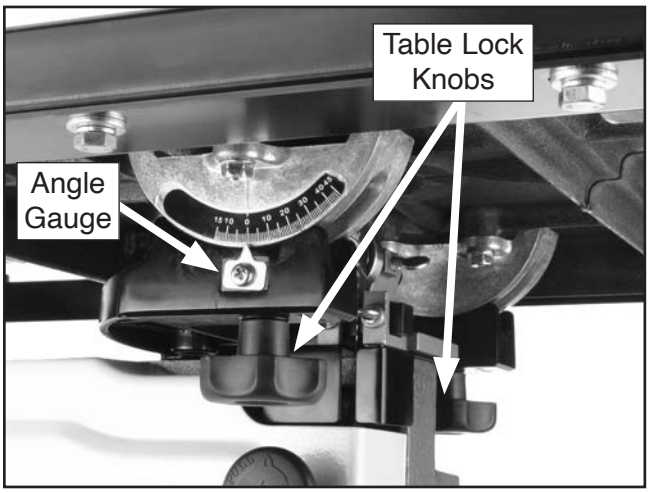


Figure 44. Table tilt controls.

2. Position the table to the desired angle. Refer to the angle gauge on the front table trunnion for the angle.

3. Retighten both plastic knobs.

Blade Information

Blade Dimensions

Length Range..... 92½"–93½"
Width Range..... ⅛"–¾"

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. Refer to the **Accessories** section later in this manual for blade replacements from Grizzly.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in the figure below to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

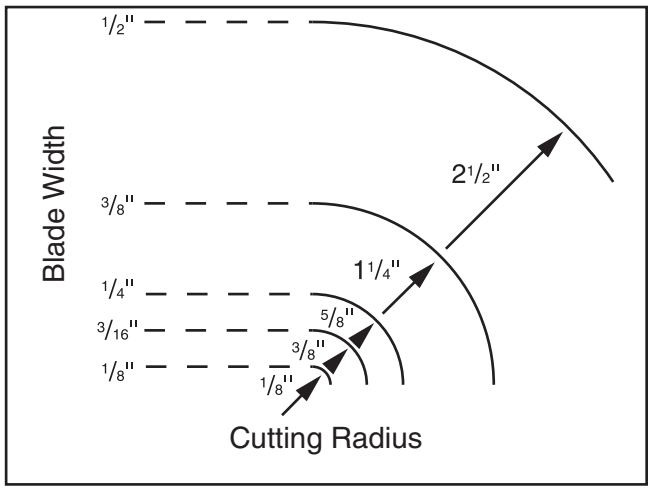


Figure 45. Recommended cutting radius per blade width.

- **Straight Cutting:** Use the largest width blade that you own. Large blades excel at cutting straight lines and are less prone to wander.

Tooth Style

The figure below illustrates the three main blade tooth styles:

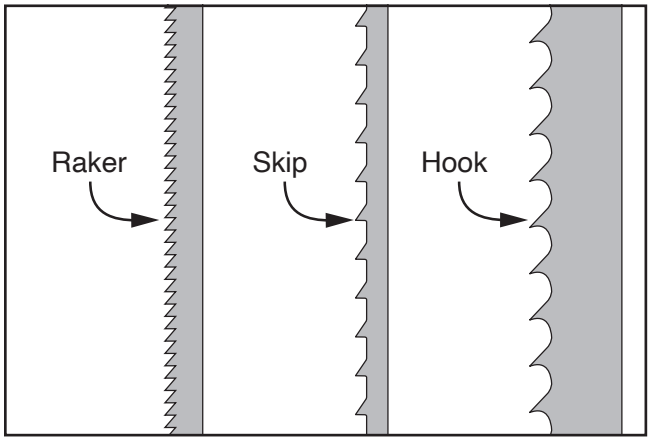


Figure 46. Main blade tooth styles.

- **Raker**: Considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material. As a result, smooth cuts can be achieved without cutting fast or generating more heat than other tooth types.

- **Skip**: Similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades.

- **Hook**: The teeth have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Measured as TPI (teeth per inch), tooth pitch determines the number of teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine-pitched blades on harder woods and coarse-pitched blades on softer woods.

Blade Care

A bandsaw blade is a thin piece of steel that is subjected to tremendous stresses when cutting. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation. Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat. Resin/pitch cleaners are excellent for cleaning dirty blades.

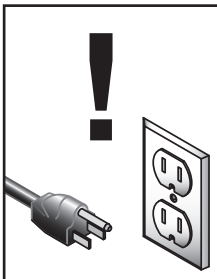
Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or blade guides.

The most common causes of blade breakage are:

- Faulty alignment/adjustment of the guides.
- Forcing/twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull teeth or damaged tooth set.
- Over-tensioned blade.
- Upper blade guide assembly set too high above the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving blade tensioned when not in use.
- Using the wrong TPI for the workpiece thickness. (The general rule of thumb is three teeth in the workpiece at all times.)

Removing/Installing Blade



⚠WARNING

Disconnect bandsaw from power BEFORE changing blade. Serious personal injury could occur if machine is started during this procedure.

⚠CAUTION

LACERATION HAZARD! Bandsaw blades are sharp and difficult to handle. Wear heavy leather gloves while handling to reduce the risk of being cut.

Items Needed	Qty
Heavy Leather Gloves	1 Pr.
Wrench 10mm	1

Removing Blade

1. DISCONNECT BANDSAW FROM POWER!

2. Release blade tension by turning the blade tension knob counterclockwise.

3. Remove the table insert and the table pin. Adjust the upper and lower guide blocks away from the blade.

4. Put on heavy leather gloves, and open the upper and lower wheel covers.

5. Slide the blade off both wheels, and rotate the blade 90˚.

6. Slide the blade through the table slot, and remove it from the machine.

Installing Blade

1. Slide the blade through the table slot, ensuring that the teeth are pointing down toward the table.

   Note: *If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it right side-out.*

2. Slip the blade through the guides, and mount it on the upper and lower wheels (**Figure 47**).

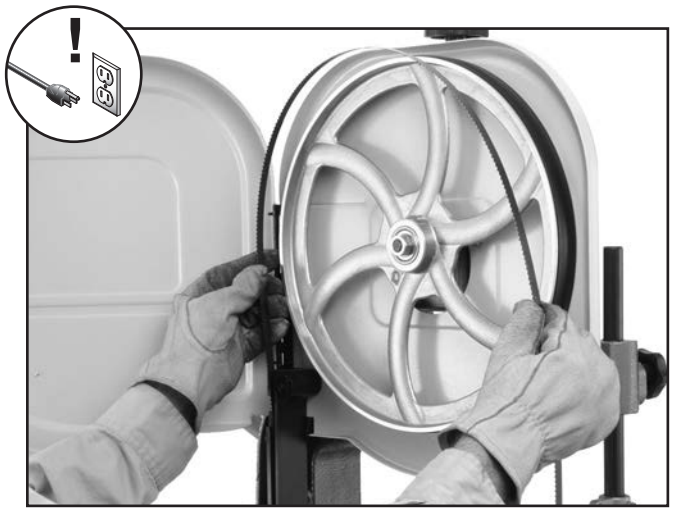


Figure 47. Placing blade on the wheels.

3. Apply tension to the blade by turning the tension control knob. Rotate the upper wheel slowly by hand as tension is applied to allow the blade to center itself on the wheel. Adjust tracking if needed.

4. Adjust the upper and lower guide blocks and the support bearings.

5. Close the wheel covers.

6. Replace the table insert and table pin, being sure not to use excessive force when inserting the table pin.

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades as necessary. Make adjustments periodically to keep the saw running in top condition.
- Use light and even pressure while cutting. Light contact with the blade eases line following and prevents undue friction.
- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners.
- Misusing the saw or using incorrect techniques is unsafe and results in poor cuts. Remember—the blade does the cutting with the operator's guidance.

Cutting Options

The bandsaw is capable of performing the following cuts:

- Miters
- Angles
- Resaw
- Ripping
- Crosscutting
- Compound Angles
- Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

Ripping

"Ripping" means cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece.

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece, then lock the fence in place.
2. Adjust the blade guide assembly to the proper height above the workpiece.
3. After all safety precautions have been met, turn the bandsaw ***ON*** and wait for it to come to full speed. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. The figure below shows an example of a ripping operation.

   Note: *If you cut narrow pieces, use a push stick to protect your fingers.*

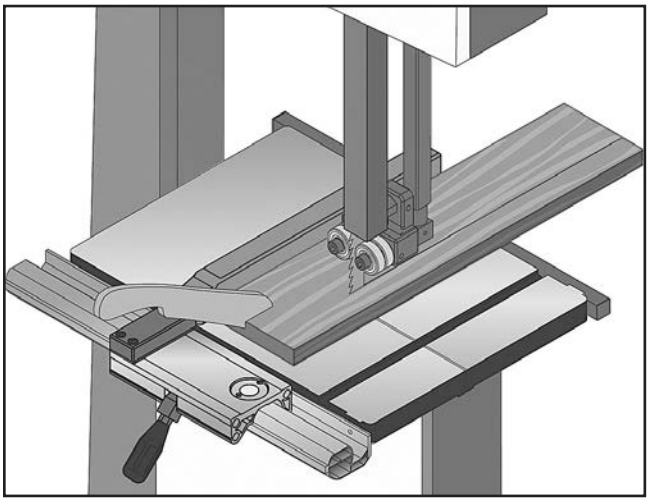


Figure 48. Example of a ripping operation.

⚠WARNING

NEVER place fingers or hands in the line of cut. If you slip, your hands or fingers may go into the blade. ALWAYS use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!

Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To make a 90° crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.

2. Adjust the blade guide assembly to the correct height and make sure the miter gauge is set to 0° (or other angle for angled cuts).

3. Move the fence out of the way. Place the workpiece evenly against the miter gauge, then line up the mark with the blade.

4. After all safety precautions have been met, turn the bandsaw ***ON*** and wait for it to come to full speed. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. The figure below shows an example of a crosscutting operation.

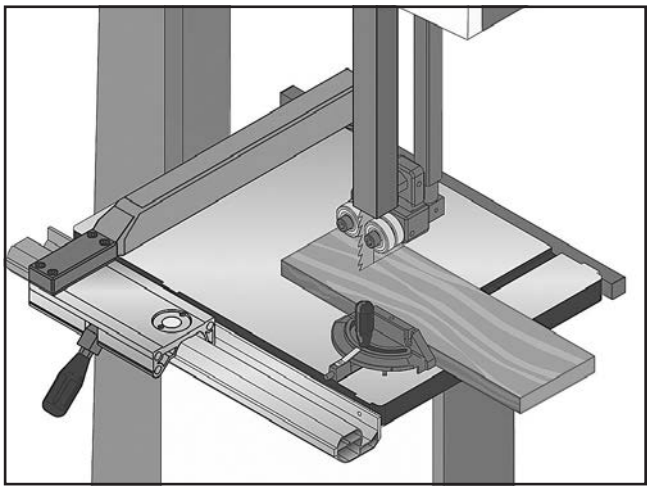


Figure 49. Example of a crosscutting operation with the miter gauge.

Resawing

"Resawing" means cutting the thickness of a board into two or more thinner boards (see the figure below for an example). The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

Maximum cutting height for this bandsaw is 6". The Model H7316 Extension Block Kit (see **Page 42**) increases the cutting height capacity of the Model G0580 to 12".

One of the most important considerations for resawing is blade selection—a wide blade cuts straighter and is less prone to blade lead (see the **Blade Lead** subsection on **Page 53** for more information).

For most applications, use a blade with a hook or a skip tooth style. Choose blades with fewer teeth-per-inch (from 3 to 6 TPI), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup, and reducing strain on the motor.

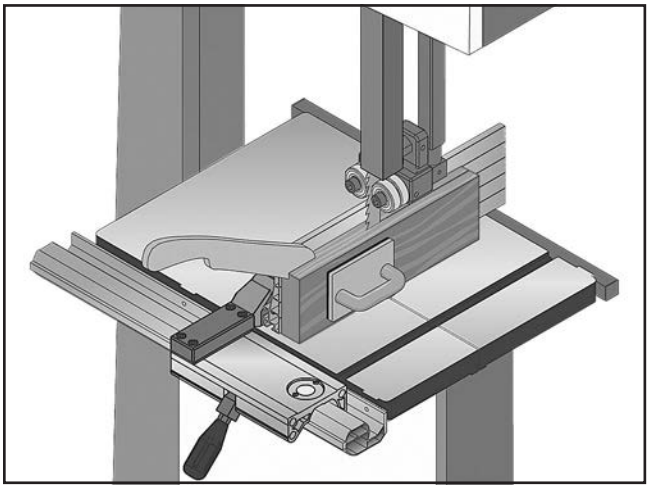


Figure 50. Example of a resawing operation.

⚠WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the side of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the table is perpendicular to the blade.

2. Use the widest blade your bandsaw will accept. *The blade must also be sharp and clean.*

3. Use a fence to guide the workpiece.

4. Set your fence to the desired width of cut and lock it in place. Or, draw a reference line on the edge of the board, place the board against the fence, line up the reference line with the blade and lock the fence in place.

5. Support the ends of the board if necessary.

6. Turn the bandsaw *ON*.

7. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece.

8. Feed material very slowly. Unsatisfactory results are often attributed to a feed rate too fast and a blade with too many TPI.

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without twisting. Use either a narrower blade or a blade with more TPI (teeth per inch), or make more relief cuts, to avoid having to back the workpiece away from the blade, especially if the curve is sharp.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier once the saw blade has come to a stop, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

Width	Min. Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together. Before making stacked cuts, ensure that the table is perpendicular (90°) to the blade—otherwise, any error in this setting will be compounded in the upper workpieces.

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.

2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)

3. On the face of the top piece, lay out the shape you intend to cut.

4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade to bind.

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line (see the figure below for an example of stacked cut setup).

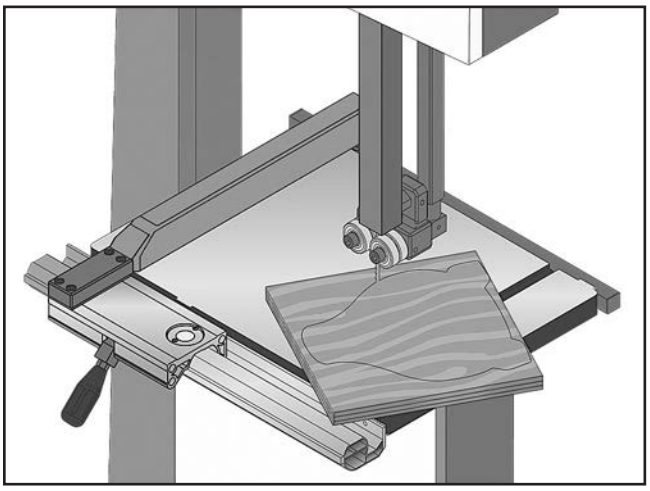


Figure 51. Example of a stacked cut setup.

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.

H7316—6" Extension Block Kit for G0580

Increase your cutting capacity from 6" to 12" cutting height with this bolt-on 6" extension block kit. Includes all necessary hardware plus extended blade guard and 105" x ⅜" x 6 TPI blade. *We also carry a full line of 105" blades!*

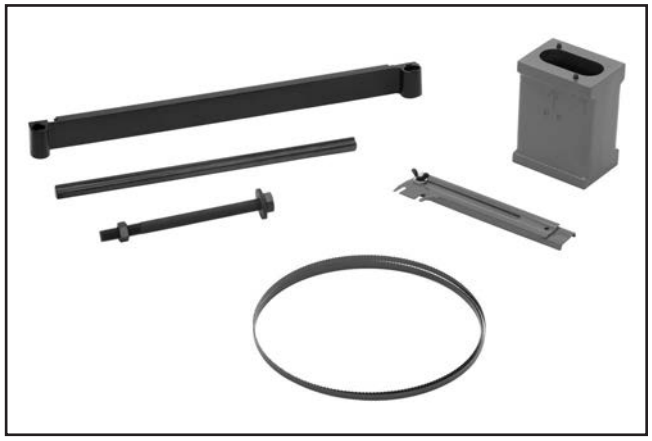


Figure 52. H7316 Extension Block Kit.

Bandsaw Blades

Grizzly bandsaw blades are made from top quality saw steel manufactured to precise tolerances with guaranteed welds for blades that last longer and produce smoother cuts.

Model	Length	Width	TPI	Gauge
G5152	93½"	⅛"	14 Raker	0.025
G5153	93½"	⅛"	18 Raker	0.025
G5154	93½"	3/16"	4 Skip	0.025
G5155	93½"	3/16"	10 Raker	0.025
G5156	93½"	3/16"	14 Raker	0.025
G5157	93½"	¼"	4 Hook	0.025
G5158	93½"	¼"	6 Hook	0.025
G5159	93½"	¼"	10 Raker	0.025
G5160	93½"	¼"	14 Raker	0.025
G5161	93½"	¼"	18 Raker	0.025
G5162	93½"	⅜"	4 Hook	0.025
G5163	93½"	⅜"	6 Hook	0.025
G5164	93½"	⅜"	10 Raker	0.025
G5165	93½"	⅜"	14 Raker	0.025
G5166	93½"	½"	3 Hook	0.025
G5167	93½"	½"	4 Hook	0.025
G5168	93½"	½"	6 Hook	0.025
G5169	93½"	½"	10 Raker	0.025
G5170	93½"	½"	14 Raker	0.025
G5171	93½"	¾"	3 Hook	0.025
G5172	93½"	¾"	6 Hook	0.025
G5173	93½"	¾"	10 Raker	0.025

T26403—The Missing Shop Manual: Bandsaw Book

Explains how to best utilize this essential workshop tool, and how to get the most for your money by getting the most from your equipment. Filled with clear diagrams and instructions. Ideal for quick reference. 112 pages, soft cover.

Figure 53. T26403 Bandsaw Book.

D2057A—Shop Fox® Heavy-Duty Mobile Base
This patented base is the most stable on the market with outrigger type supports. Adjusts from 19" x 20½" to 29½" x 29½". 700 lb. capacity. Weighs 47 lbs.

Figure 54. D2057A Mobile Base.

T10117—Big Mouth Dust Hood with Stand
Capture dust from any machine operation with this Big Mouth Dust Hood. Simply attach a 4" dust collection hose and adjust the hood right where you need it. The free standing base eliminates complicated machine setups and the tilting 16⅜" x 12⅞" hood adjusts from 23" to 43" high. Every shop needs one of these!

Figure 55. T10117 Big Mouth Dust Hood.

G1163P—1HP Floor Model Dust Collector
G0710—1HP Wall-Mount Dust Collector
G3591—30 Micron Replacement Bag
Excellent point-of-use dust collectors that can be used next to the machine with only a small amount of ducting. Specifications: 537 CFM, 7.2" static pressure, 2 cubic foot bag, and 30 micron filter. Motor is 1HP, 110V/240V, 7A/3.5A.

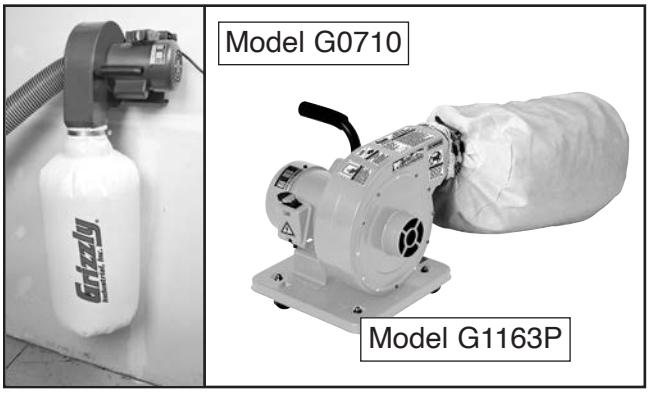
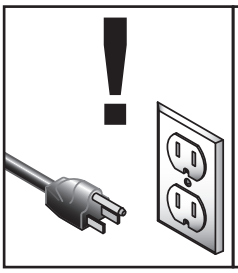


Figure 56. Point-of-use dust collectors.

D2272—Tilting Roller Stand
Adjusts from 26" to 44", 0°-45°. 150 lb. capacity.
D2273—Single Roller Stand
Adjusts from 26 ⅝" to 45". 250 lb. capacity.
D2274—5 Roller Stand
Adjusts from 26" to 44⅝". 250 lb. capacity.
These super heavy-duty roller stands feature convenient hand knobs for fast height adjustment.

Figure 57. Shop Fox® Roller Stands.

SECTION 6: MAINTENANCE



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

Schedule

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

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

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

Monthly Check
- V-belt tension, damage, or wear.
- Remove blade and thoroughly clean all built-up sawdust from the wheels and rubber tires. If necessary, re-dress the rubber tires.
- Clean/vacuum dust buildup from inside wheel covers and off the motor.

Cleaning & Protecting

Cleaning the bandsaw is relatively easy. Vacuum away excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it.

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep the table rust-free with regular applications of products like SLIPIT® (contact Grizzly to purchase this product).

Lubrication

The bearings on this bandsaw are pre-lubricated and sealed at the factory, and require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or a bearing supply store.

As for other items on this machine, such as adjustment controls, an occasional “shot” of light oil is just about all that is necessary. Before applying, however, wipe off any sawdust with a clean cloth, towel or dry paint brush, then spray on the lubricant.

Ensure that lubricant does not get on the pulleys or V-belt, which could cause V-belt deterioration or loss of power transfer due to slippage.

Redressing Rubber Tires

As the bandsaw ages, the rubber tires on the wheels may need to be redressed if they harden or glaze over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult. At that point, redressing will no longer be effective and the rubber tires must be replaced.

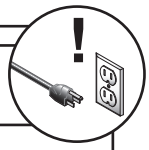
To redress the rubber tires:

1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires and wheels.
5. Hold 100 grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.
6. Re-install the blade, then make sure the blade tracking and tension are correct.

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 a breaker trips.	1. Switch disabling key removed. 2. Power supply is at fault/switched OFF. 3. Plug/receptacle is at fault or wired incorrectly. 4. Wiring is open/has high resistance. 5. Motor connection wired incorrectly. 6. Start capacitor is at fault (115V only). 7. Motor ON/OFF switch is at fault. 8. Centrifugal switch is at fault.	1. Install switch disabling key. 2. Ensure hot lines have correct voltage on all legs and main power supply is switched ***ON***. 3. Test for good contacts; correct the wiring. 4. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 5. Correct motor wiring connections (**Page 55**). 6. Test/replace. 7. Replace faulty ON/OFF switch. 8. Adjust/replace centrifugal switch.
Machine stalls or is underpowered.	1. Incorrect workpiece material. 2. Feed rate too fast for task. 3. V-belt slipping. 4. Motor connection is wired incorrectly. 5. Plug/receptacle is at fault. 6. Motor bearings are at fault. 7. Motor has overheated. 8. Motor is at fault. 9. Centrifugal switch is at fault.	1. Use wood with correct moisture content (20% or less), without glues, and little pitch/resin. 2. Decrease feed rate. 3. Tighten/repair/replace (**Pages 48** and **49**). 4. Correct motor wiring connections (**Page 55**). 5. Test for good contacts; correct the wiring. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Clean off motor, let cool, and reduce workload. 8. Test/repair/replace. 9. Adjust/replace centrifugal switch.
Machine has vibration or noisy operation.	1. Motor or component is loose. 2. V-belt worn or loose. 3. Motor fan is rubbing on fan cover. 4. Pulley is loose. 5. Machine is incorrectly mounted or sits unevenly on floor. 6. Blade is at fault. 7. Cast iron motor mount loose/broken. 8. Centrifugal switch is at fault. 9. Motor or spindle bearings are at fault.	1. Inspect/replace stripped or damaged bolts/nuts, use thread locking fluid, and retighten. 2. Tension V-belt (**Page 48**) or replace V-belt (**Page 49**). 3. Replace dented fan cover; replace damaged fan. 4. Tighten pulley set screw. 5. Adjust stand feet. 6. Replace blade. 7. Tighten/replace. 8. Adjust/replace centrifugal switch.. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Operations

Symptom	Possible Cause	Possible Solution
Machine slows when operating.	1. Feeding workpiece too fast. 2. Blade is dull.	1. Reduce feed rate. 2. Replace blade (**Page 37**).
Ticking sound when the saw is running.	1. Blade weld contacting guide/support bearings (a light tick is normal). 2. Blade weld may be failing.	1. Use file or stone to smooth and round the back of the blade; slightly loosen the blade guides. 2. Inspect and replace blade if necessary (**Page 37**).
Blade contacting table insert.	1. Insert installed upside down or backwards. 2. Table improperly mounted or aligned.	1. Re-install insert a different way. 2. Align table (**Page 30**).
Vibration when cutting.	1. Loose or damaged blade. 2. Sawdust buildup on wheels.	1. Tighten or replace blade (**Page 37**). 2. Clean all sawdust from rubber tires on wheels.
Burn marks on the edge of the cut.	1. Too much side pressure when feeding workpiece; blade is binding. 2. Blade too wide for size of radius being cut.	1. Feed workpiece straight into the blade. 2. Install a smaller width blade/increase blade tension (**Page 35**).
Rough or poor quality cuts.	1. Feeding workpiece too fast. 2. Blade guides adjusted incorrectly.	1. Reduce feed rate. 2. Re-adjust all blade support bearings and blade guide blocks (**Page 27** and **Page 28**).
Sawdust buildup inside wheel covers.	1. Clogged dust port. 2. Low CFM (airflow) from dust collection system.	1. Clean out dust port. 2. Three options: —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a more powerful dust collector.
Blade wanders or doesn't cut straight.	1. Blade lead. 2. Sawdust buildup on wheels.	1. Refer to Blade Lead on **Page 53**. 2. Clean all sawdust from rubber tires on wheels.
Cuts are not square (vertically).	1. Table tilt is not adjusted to 0˚ or positive stop has moved out of adjustment. 2. Table tilt scale pointer is not calibrated. 3. Table is not square to the blade.	1. Adjust table tilt to 0˚; readjust positive stop if necessary (**Page 23**). 2. Calibrate table tilt scale pointer to 0˚ (**Page 29**). 3. Shim table (**Page 49**).

Miscellaneous

Symptom	Possible Cause	Possible Solution
Blade tension scale is grossly inaccurate.	1. The spring in the blade tension mechanism has lost its "spring." This is caused by not releasing the blade tension when not in use or frequently over-tensioning the bandsaw.	1. Replace spring in the blade tension mechanism, then take better care of the bandsaw by releasing tension when not in use and not over-tensioning the blade.
Wheel is noisy.	1. Wheel bearing is worn out. 2. V-belt is too tight (lower wheel).	1. Replace the wheel bearing. 2. Check/loosen the belt tension (**Page 48**).
Blade does not track consistently, correctly, or at all.	1. Wheels are not coplanar or aligned with each other. 2. Rubber tires on wheels are worn out.	1. Adjust wheels to be coplanar/aligned with each other (**Page 50**). 2. Redress the rubber tires on the wheels (**Page 45**); replace the rubber tires on the wheels.

Checking/Tensioning V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension.

V-belt tension should be checked at least every month—more often if the bandsaw is used daily. If the belt shows signs of cracks, fraying, and excessive wear, replace it as instructed in **Replacing V-Belt** on **Page 49**.

Checking V-Belt Tension

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover.

3. The V-belt is properly tensioned if there is approximately ¼" deflection of the V-belt when you apply moderate pressure to it between the pulleys (see the illustration in the following figure).

   — If the V-belt is not properly tensioned, perform the following **Tensioning V-Belt** procedure.

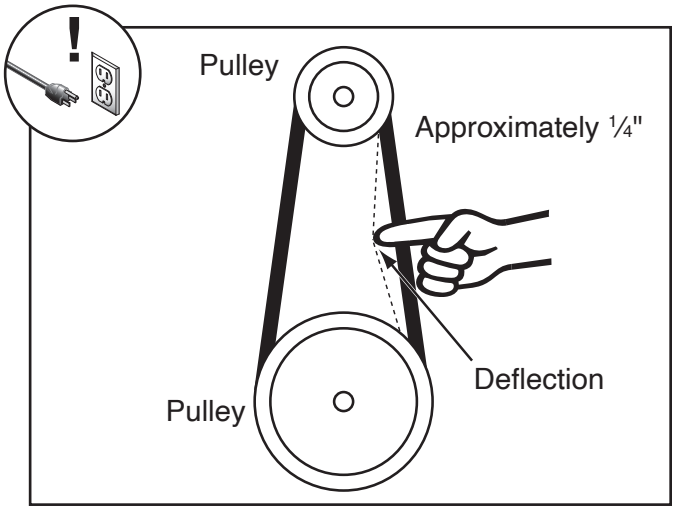


Figure 58. Checking the V-belt tension.

Tensioning V-Belt

Tool Needed	Qty
Hex Wrench 6mm	1

To properly tension the V-belt:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover and loosen the motor adjustment and hinge cap screws shown in **Figure 59**.

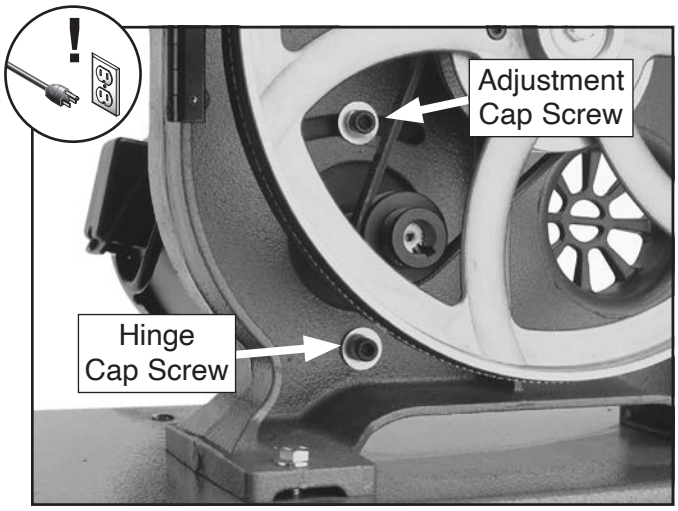


Figure 59. Locations of the motor adjustment and hinge cap screws.

3. Push the motor to the left (as viewed from the front of the machine) until there is approximately ¼" deflection in the V-belt between the pulley when moderate pressure is applied.

4. Re-tighten both cap screws and close the wheel cover.

Replacing V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension.

If the belt shows signs of cracks, fraying, and excessive wear, replace it.

Tools Needed	Qty
Hex Wrench 6mm	1
Wrench or Socket 13mm	1
Replacement V-Belt (Part No. P0580068)	1

To replace the V-belt:

1. DISCONNECT BANDSAW FROM POWER!

2. Put on heavy leather gloves and remove the blade from the machine.

3. Loosen the motor adjustment and hinge cap screws shown in **Figure 60**.

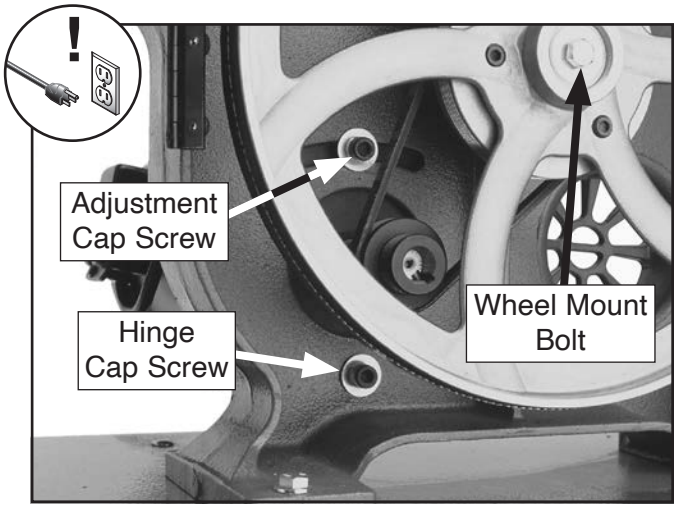


Figure 60. Locations of the wheel mount bolt, and motor adjustment and hinge cap screws.

4. Move the motor to the right (as viewed from the front of the bandsaw) so that the adjustment cap screw slides to the right in the slot—this will release the V-belt tension.

5. Roll the V-belt off the pulleys.

6. Unthread the wheel mount bolt clockwise (left-hand thread), and remove it and the flat washer from the wheel hub.

7. Taking care not to misplace the shaft key, slide the wheel from the shaft.

8. Install the new V-belt onto the wheel pulley.

9. Align the wheel keyway with the shaft key and slide the wheel back onto the shaft.

10. Secure the wheel with the wheel mount bolt and flat washer.

11. Position the V-belt over the motor pulley, then properly tension it, as instructed in the **V-Belt Tension** subsection on **Page 48**.

12. Replace the blade, then properly track and tension it (see **Pages 24** and **26**).

Shimming Table

To ensure accuracy when cutting stacked cuts or circles, the table must be 90° to the back of the blade, as shown in the figure below.

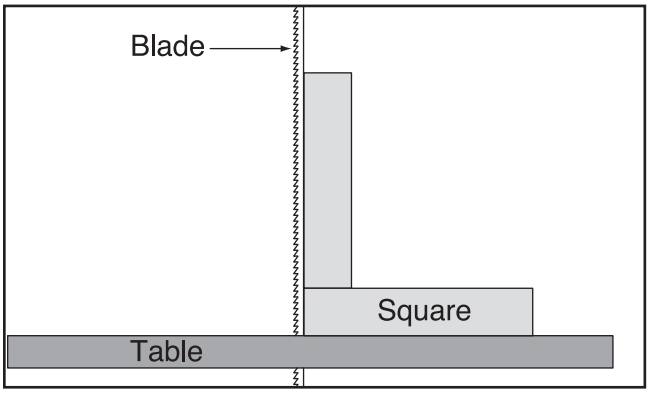


Figure 61. Checking the table to be perpendicular to the back of the blade.

If the table is not perpendicular to the back of the blade, correct this condition by placing shim stock between the table and trunnions underneath it.

Tip: *For fine adjustments, use electrical washers on the bolts that secure the table.*

Aligning Wheels

Wheel alignment is one of the most critical factors for optimal performance from your bandsaw. Wheels are properly aligned when they are parallel with each other and in the same plane or "coplanar" (see the illustration in the figure to the right).

Heat, vibration, wandering, blade wear, tire wear and overall bandsaw wear are considerably decreased when the wheels are parallel and coplanar. Additionally, wheels that are parallel and coplanar automatically track the blade by balancing it on the crown of the wheel—this is known as "coplanar tracking."

Bringing the wheel into alignment may require a combination of shimming a wheel and center/lateral tracking the upper blade.

Tools Needed	**Qty**
Straightedge 4 ft.	1
Fine Ruler	1
Wrench or Socket 13mm	1
Wrench or Socket 19mm	1

Checking Wheel Alignment

1. DISCONNECT BANDSAW FROM POWER!

2. Remove the table.

3. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure the straightedge fully extends across the rims of both wheels, as shown in the figure below.

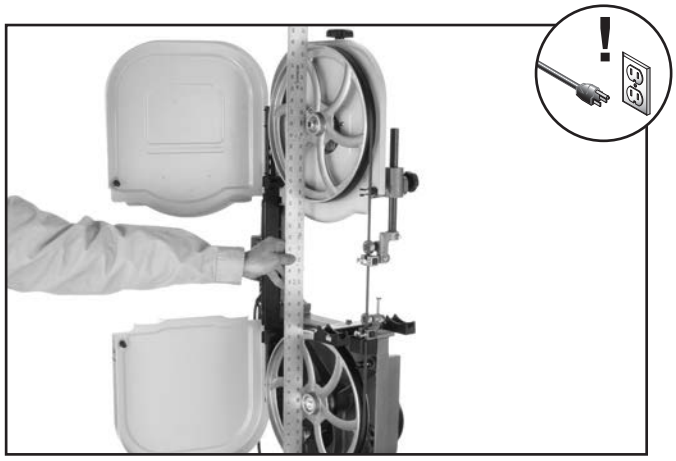


Figure 62. Checking if the wheels are coplanar.

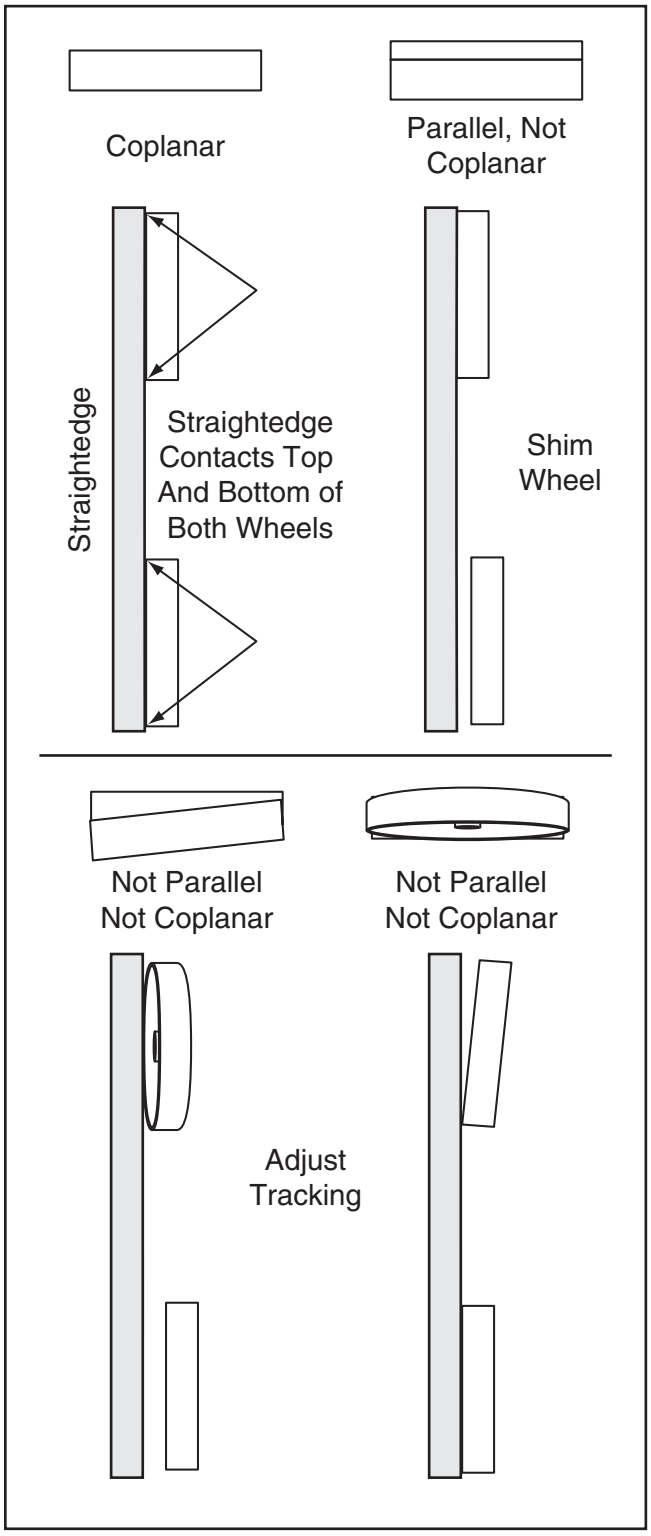


Figure 63. Wheel alignment illustration.

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

— If the wheels are parallel but not coplanar, the straightedge will touch the top and bottom rims on one wheel, but will not touch either rim on the other wheel. In this case, shim the wheel that does not touch the straightedge, as instructed in the following **Shimming a Wheel** procedure.

— If the wheels are not coplanar, the straightedge will touch both rims of one wheel, but at an angle to the other wheel. In this case, you will need to adjust the tracking of the upper wheel.

  If the upper wheel is tilted from top to bottom only, perform the **Blade Center Tracking** procedure as instructed on **Page 24**.

  If the upper wheel is tilted from side to side, perform **Upper Wheel Lateral Adjustment** procedure on **Page 52**.

Shimming a Wheel

A wheel that is parallel with the other wheel, but is not coplanar, must be shimmed by the distance that it is not in the same plane with the other wheel.

To shim a wheel:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the upper wheel tracking so that it is parallel with the bottom wheel.

3. With the straightedge touching both rims of the wheel that does not need to be adjusted, measure the distance away from the other wheel with a fine ruler, as shown in the figure below. The distance measured with the ruler is the distance this wheel must be shimmed.

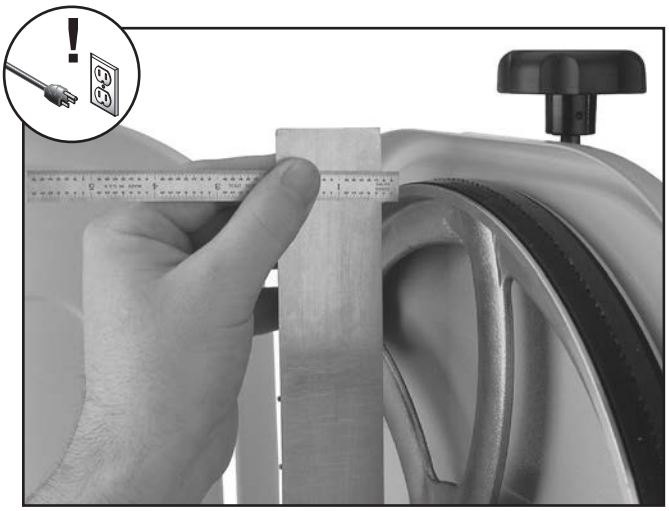


Figure 64. Measuring the distance to shim the wheel to be coplanar.

4. Remove the wheel to be shimmed, then place shimming washers in the amount measured in **Step 3** onto the wheel shaft.

5. Re-install the wheel and secure it in place.

6. Re-install the blade, then properly tension it for operation.

  Note: *Often the wheels may be coplanar with the blade loose, then be pulled out of alignment when it is tightened.*

7. Perform the previous **Checking Wheel Alignment** procedure. If necessary to make the wheels parallel, repeat this procedure.

8. When you are satisfied with the adjustment, re-install the blade and close the wheel covers.

Upper Wheel Lateral Adjustment

If the upper wheel is tilted laterally (side to side), perform the following procedure to make it coplanar with the lower wheel.

There are two set screws in the upper wheel bracket, shown in **Figure 65** and **Figure 66**, that adjust the wheel tilt from side to side.

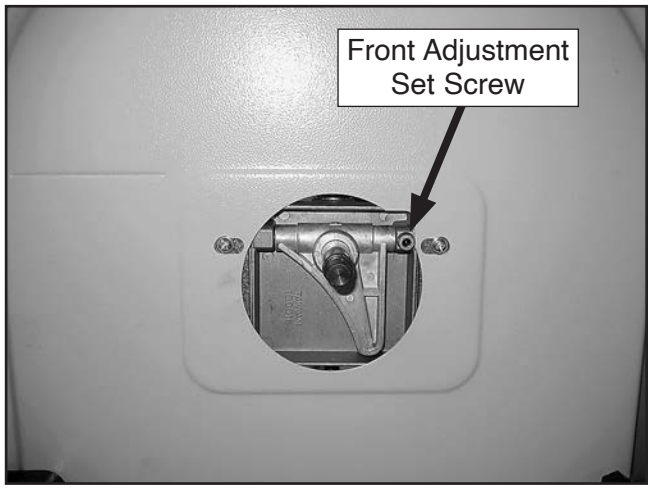


Figure 65. Front lateral adjustment set screw (viewed with the upper wheel removed).

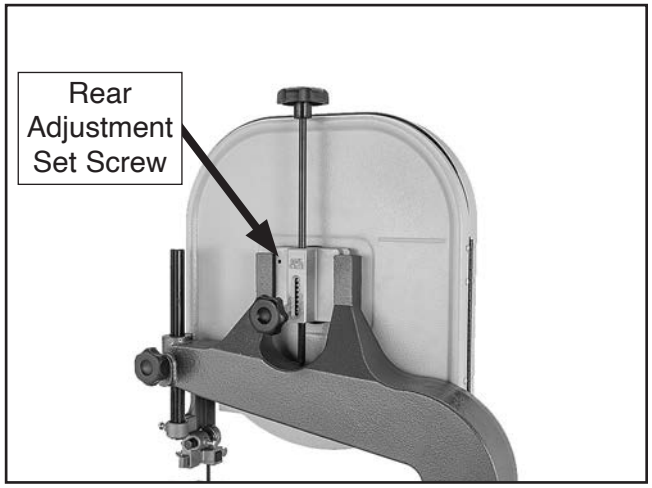


Figure 66. Rear lateral adjustment set screw.

Tools Needed	Qty
Hex Wrench 2.5mm	1
Wrench or Socket 13mm	1

To adjust the upper wheel laterally:

1. DISCONNECT BANDSAW FROM POWER!

2. Remove the blade from the machine.

3. Remove the hex nut that secures the upper wheel, then slide the wheel from the shaft.

4. Thread one set screw out and thread the other set screw in the same amount to tilt the wheel laterally.

   For instance, to tilt the right side of the upper wheel back, thread the rear set screw out and thread the front set screw in the same amount.

5. Slide the upper wheel back on the shaft, then repeat the **Checking Wheel Alignment** procedure and, if necessary, repeat this procedure until the upper wheel is coplanar with the lower wheel.

Blade Lead

Bandsaw blades may wander off the cut line when sawing, as shown in the figure below. This is called blade lead.

Blade lead is usually caused by too fast of a feed rate, a dull or abused blade, or improper blade tension. If your blade is sharp/undamaged, properly tensioned, and you still have blade lead, perform the following procedures.

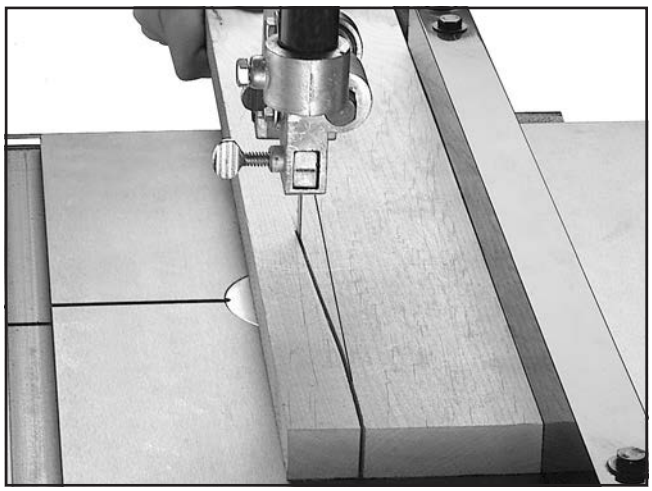


Figure 67. Example of blade lead.

To correct blade lead:

1. Make sure the blade is properly tensioned and the blade guides are adjusted correctly.

2. Use less pressure when feeding the workpiece through the cut—this will reduce the feed rate.

3. Make sure the miter slot and fence are parallel to the blade line (see the **Aligning Table** and **Aligning Fence** procedures in this manual for detailed information).

4. If after **Steps 1–3** there is still blade lead present, compensate for this condition by skewing the fence or shifting the table, as instructed in the following procedures.

To skew your fence:

1. Cut a piece of scrap wood approximately ¾" thick x 3" wide x 17" long. On the wide face of the board, draw a straight line parallel to the long edge.

2. Slide the bandsaw fence out of the way and cut halfway through the board on the line by pushing it into the blade. Turn the bandsaw ***OFF*** and wait for the blade to stop. Do not move the board.

3. Clamp the board to the bandsaw table, then slide the fence over to the board so it barely touches one end of the board.

4. Use a 4mm hex wrench to loosen the four fence adjustment cap screws on top of the fence, skew the fence so that it is parallel with the scrap piece, then re-tighten the cap screws.

5. Make a few cuts using the fence.

   — If blade lead is still present, repeat **Steps 1–4** until the blade and fence are parallel with each other.

   — Or, shift the table, as instructed in the following procedure.

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.

2. Cut halfway through the board on the line by pushing it into the blade.

3. Turn the bandsaw ***OFF*** and wait for the blade to stop.

4. Disconnect the bandsaw from power, then loosen the six hex bolts underneath the table that secure it to the trunnion brackets.

5. Shift the table to compensate for the blade lead, re-tighten the hex bolts, then re-connect the bandsaw to power.

6. Repeat **Steps 1–5** until there is no longer any blade lead.

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 aftermarket 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.

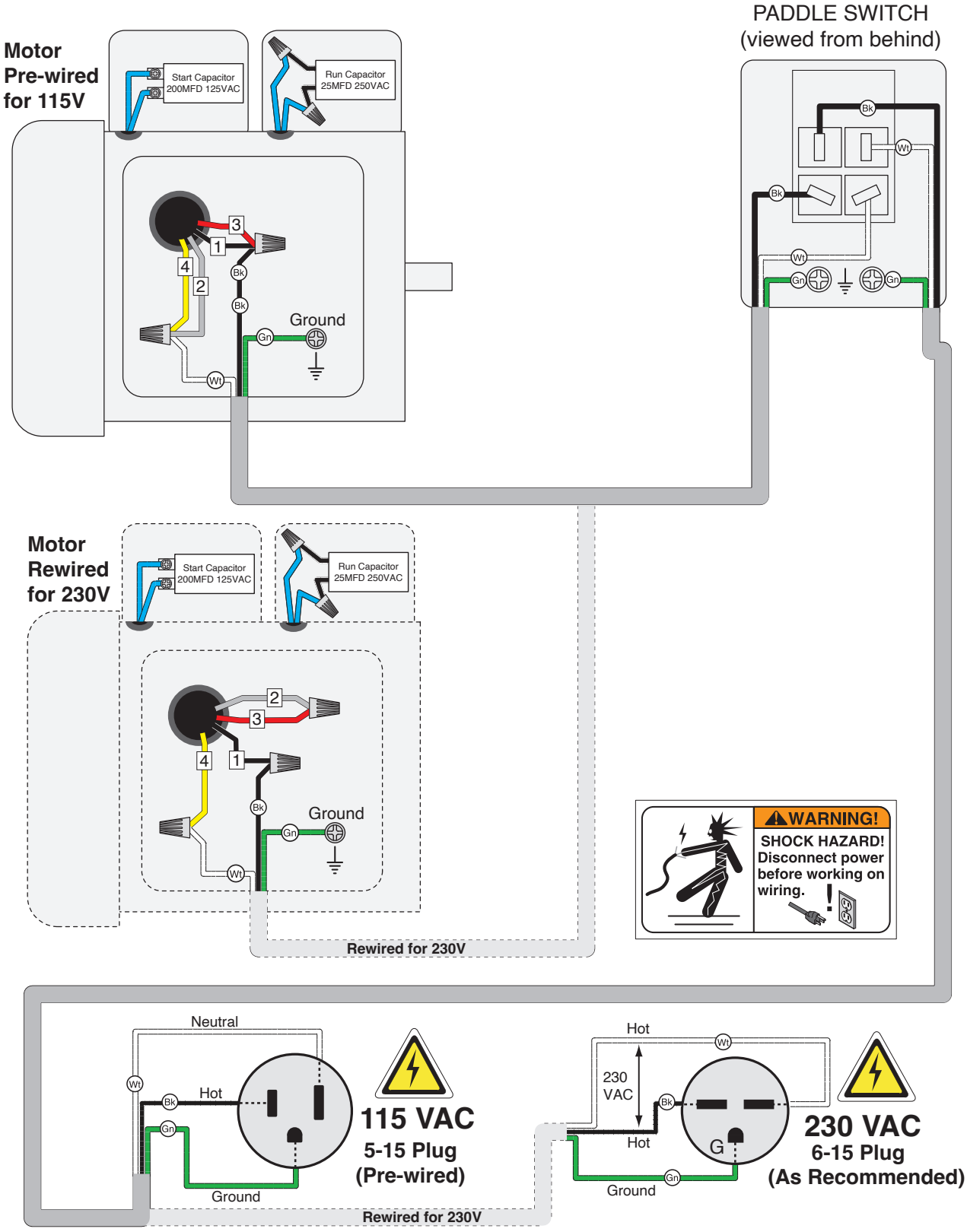
NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu	TURQUOISE	Tu
RED	Rd	ORANGE	Or	PINK	Pk		

Wiring Diagram

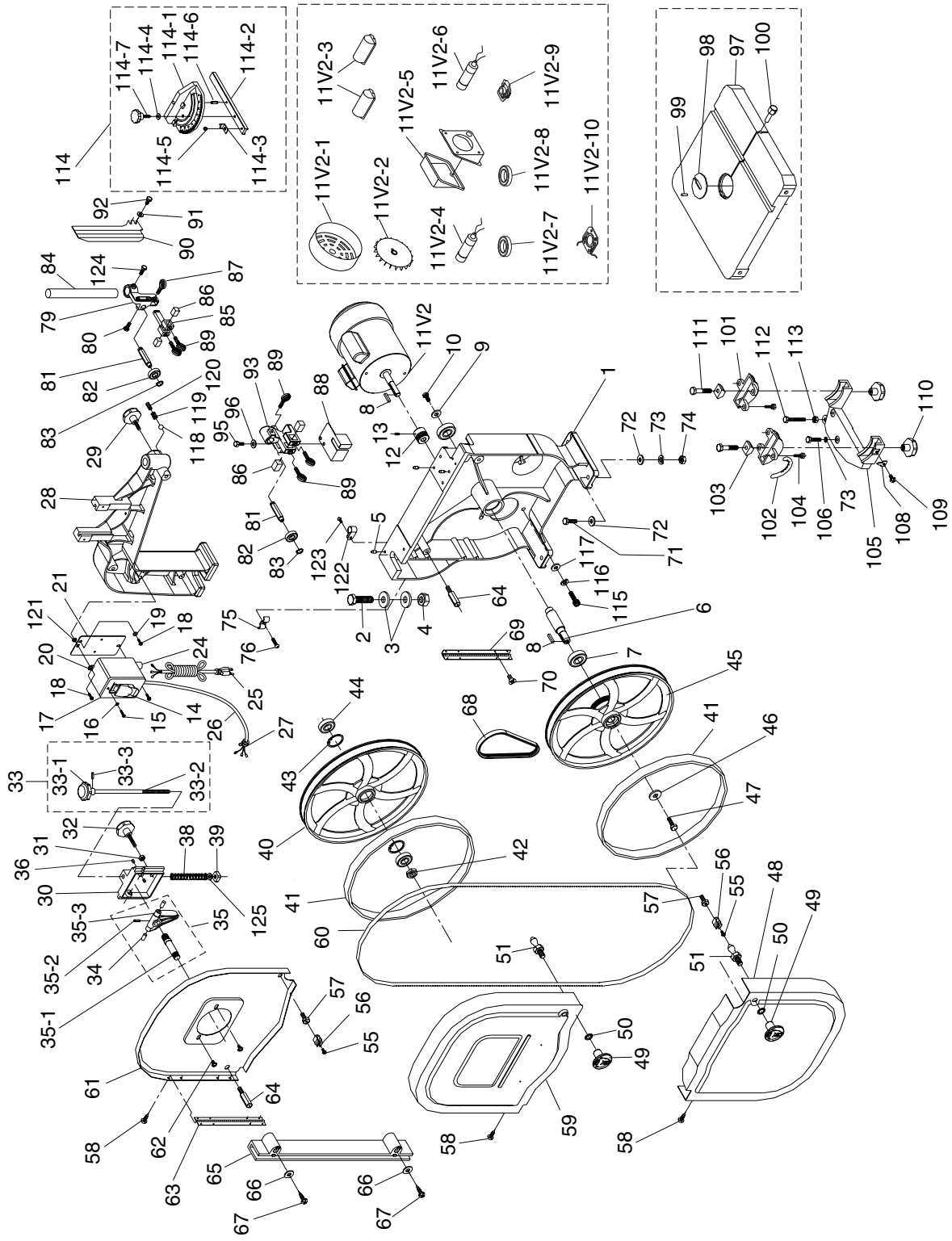


STOP *READ ELECTRICAL SAFETY ON PAGE 54!*

SECTION 9: PARTS

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

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0580001	BASE
2	P0580002	HEX BOLT M16-2 X 55
3	P0580003	FLAT WASHER 16MM
4	P0580004	HEX NUT M16-2
5	P0580005	PIN 1/4"
6	P0580006	LOWER WHEEL SHAFT
7	P0580007	BALL BEARING 6204ZZ
8	P0580008	KEY 5 X 5 X 25
9	P0580009	FLAT WASHER 8MM
10	P0580010	PHLP HD SCR M8-1.25 X 16
11V2	P0580011V2	MOTOR 3/4HP 115/230V 1PH V2.11.06
11V2-1	P0580011V2-1	MOTOR FAN COVER
11V2-2	P0580011V2-2	MOTOR FAN
11V2-3	P0580011V2-3	CAPACITOR COVER
11V2-4	P0580011V2-4	R CAPACITOR 25M 250V
11V2-5	P0580011V2-5	ELECTRICAL BOX
11V2-6	P0580011V2-6	S CAPACITOR 200M 125V
11V2-7	P0580011V2-7	BALL BEARING 6203ZZ
11V2-8	P0580011V2-8	BALL BEARING 6202ZZ
11V2-9	P0580011V2-9	CENTRIFUGAL SWITCH 1725 RPM
11V2-10	P0580011V2-10	CONTACT PLATE
12	P0580012	MOTOR PULLEY
13	P0580013	SET SCREW M6-1 X 10
14	P0580014	GRIZZLY SAFETY PADDLE SWITCH
15	P0580015	TAP SCREW M3.5 X 12
16	P0580016	FLAT WASHER 4MM
17	P0580017	SWITCH ENCLOSURE BRACKET
18	P0580018	PHLP HD SCR M5-.8 X 16
19	P0580019	EXT TOOTH WASHER 5MM
20	P0580020	SWITCH ENCLOSURE
21	P0580021	SWITCH PLATE
24	P0580024	STRAIN RELIEF
25	P0580025	POWER CORD 16G X 3W 73"L
26	P0580026	POWER CORD 16G X 3W 24"L
27	P0580027	STRAIN RELIEF
28	P0580028	UPPER FRAME ARM
29	P0580029	KNOB BOLT M10-1.5 X 25
30	P0580030	UPPER WHEEL SLIDING BRACKET
31	P0580031	HEX NUT M8-1.25
32	P0580032	KNOB BOLT M8-1.25 X 45
33	P0580033	ADJUSTMENT SCREW ASSY 7" THREAD
33-1	P0580033-1	KNOB
33-2	P0580033-2	MICRO ADJUSTING BOLT 285MM
33-3	P0580033-3	ROLL PIN 3 X 18
34	P0580034	DOWEL PIN
35	P0580035	UPPER WHEEL SHAFT HINGE ASSY
35-1	P0580035-1	UPPER WHEEL SHAFT
35-2	P0580035-2	ROLL PIN 4 X 24
35-3	P0580035-3	UPPER WHEEL SHAFT HINGE
36	P0580036	SET SCREW M5-.8 X 8
38	P0580038	COIL SPRING 3.8 X 13.5 X 81
39	P0580039	SQUARE NUT M10-1.5
40	P0580040	UPPER WHEEL
41	P0580041	WHEEL TIRE

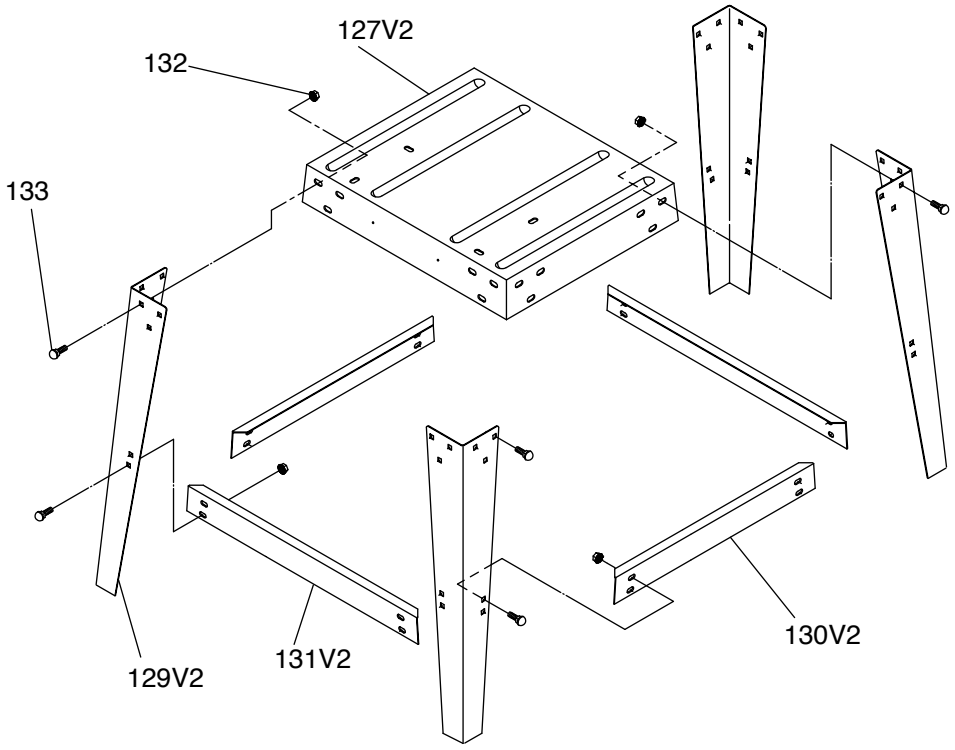
REF	PART #	DESCRIPTION
42	P0580042	HEX NUT M12-1.25
43	P0580043	INT RETAINING RING 35MM
44	P0580044	BALL BEARING 6202 ZZ
45	P0580045	LOWER WHEEL
46	P0580046	FLAT WASHER 8MM
47	P0580047	HEX BOLT M8-1.25 X 20 LH
48	P0580048	LOWER WHEEL GUARD
49	P0580049	KNOB M8-1.25
50	P0580050	INT TOOTH WASHER 8MM
51	P0580051	LATCH STUD M8-1.25 X 14
55	P0580055	PHLP HD SCR M5-.8 X 12
56	P0580056	CATCH
57	P0580057	LATCH STUD M8-1.25 X 14
58	P0580058	TAP SCREW M4 X 8
59	P0580059	COVER UPPER FRONT
60	P0580060	SAW BLADE 6TPI X 93-1/2
61	P0580061	COVER UPPER BACK
62	P0580062	FLANGE SCREW M5-.8 X 8
63	P0580063	HINGE UPPER
64	P0580064	STANDOFF HEX STUD
65	P0580065	SAW BLADE GUARD
66	P0580066	SHIM
67	P0580067	TAP SCREW M3.5 X 16
68	P0580068	BELT 18505J
69	P0580069	LOWER HINGE
70	P0580070	FLAT HD SCR M5-.8 X 10
71	P0580071	HEX BOLT M8-1.25 X 35
72	P0580072	FLAT WASHER 8MM
73	P0580073	LOCK WASHER 8MM
74	P0580074	HEX NUT M8-1.25
75	P0580075	CORD CLAMP
76	P0580076	PHLP HD SCR M5-.8 X 12
79	P0580079	GUIDE SUPPORT BRACKET
80	P0580080	THUMB SCREW M6-1 X 16
81	P0580081	UPPER SPACING SLEEVE
82	P0580082	BALL BEARING 6200 ZZ
83	P0580083	EXT RETAINING RING 10MM
84	P0580084	GUIDE POST
85	P0580085	BLADE GUIDE SUPPORT
86	P0580086	GUIDE BLOCK 1/2" X 1/2" X 3/8"L
87	P0580087	THUMB SCREW M6-1 X 16
88	P0580088	LOWER BLADE GUARD
89	P0580089	THUMB SCREW M6-1 X 12
90	P0580090	LEFT BLADE GUARD
91	P0580091	FLAT WASHER 6MM
92	P0580092	HEX BOLT M6-1 X 10
93	P0580093	LOWER GUIDE SUPPORT
95	P0580095	HEX BOLT M6-1 X 20
96	P0580096	FLAT WASHER 6MM
97	P0580097	TABLE
98	P0580098	T24385 TABLE INSERT
99	P0580099	ROLL PIN 3 X 8
100	P0580100	TABLE PIN
101	P0580101	TRUNNION

Main Parts List (Cont.)

REF	PART #	DESCRIPTION
102	P0580102	SCALE
103	P0580103	TRUNNION CLAMP SHOE
104	P0580104	HEX BOLT M6-1 X 12
105	P0580105	TRUNNION SUPPORT BRACKET
106	P0580106	HEX BOLT M8-1.25 X 30
108	P0580108	POINTER
109	P0580109	FLANGE SCREW M5-.8 X 6
110	P0580110	KNOB M10-1.5
111	P0580111	HEX BOLT M10-1.5 X 50
112	P0580112	HEX BOLT M8-1.25 X 80
113	P0580113	HEX NUT M8-1.25
114	P0580114	MITER GAUGE ASSY
114-1	P0580114-1	MITER BODY
114-2	P0580114-2	MITER BAR
114-3	P0580114-3	POINTER

REF	PART #	DESCRIPTION
114-4	P0580114-4	WASHER PLASTIC
114-5	P0580114-5	PHLP HD SCR M5-.8 X 6
114-6	P0580114-6	PIN
114-7	P0580114-7	KNOB 1/4-20 X 3/4
115	P0580115	CAP SCREW M8-1.25 X 25
116	P0580116	LOCK WASHER 8MM
117	P0580117	FLAT WASHER 8MM
118	P0580118	STEEL BALL 5/16
119	P0580119	COMPRESSION SPRING 1 X 5.5 X 9
120	P0580120	SET SCREW M10-1.5 X 10
122	P0580122	CORD CLAMP
123	P0580123	PHLP HD SCR M5-.8 X 12
124	P0580124	HEX BOLT M6 -1 X 16
125	P0580125	TENSION POINTER

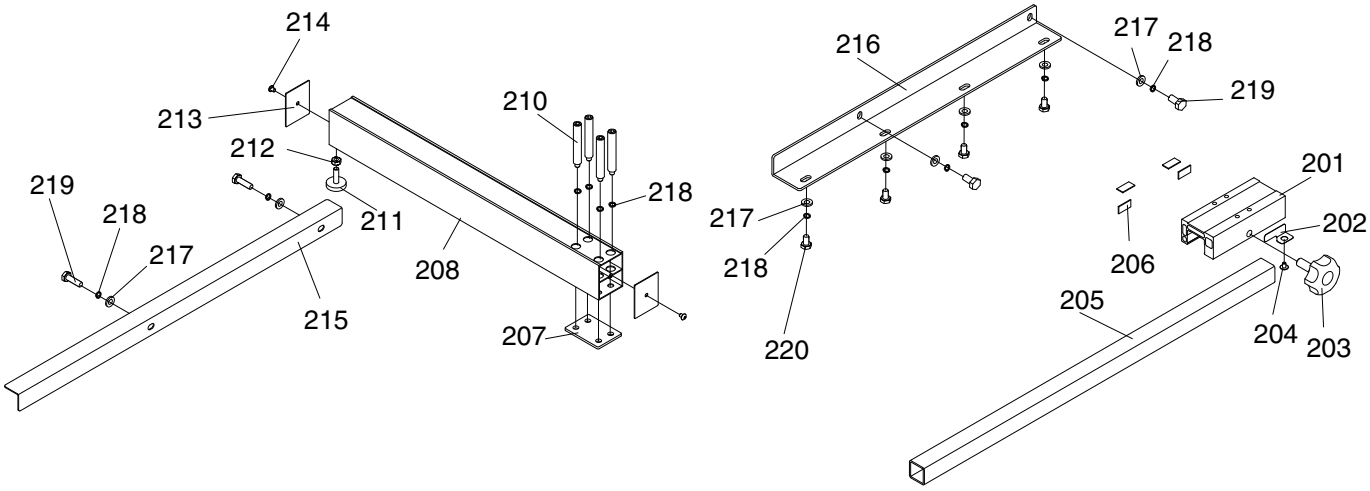
Stand



REF	PART #	DESCRIPTION
127V2	P0580127V2	BASE PLATE V2.03.25
129V2	P0580129V2	LEG V2.03.25
130V2	P0580130V2	SHORT BRACE V2.03.25

REF	PART #	DESCRIPTION
131V2	P0580131V2	LONG BRACE V2.03.25
132	P0580132	FLANGE NUT M8-1.25
133	P0580133	CARRIAGE BOLT M8-1.25 X 16

Fence

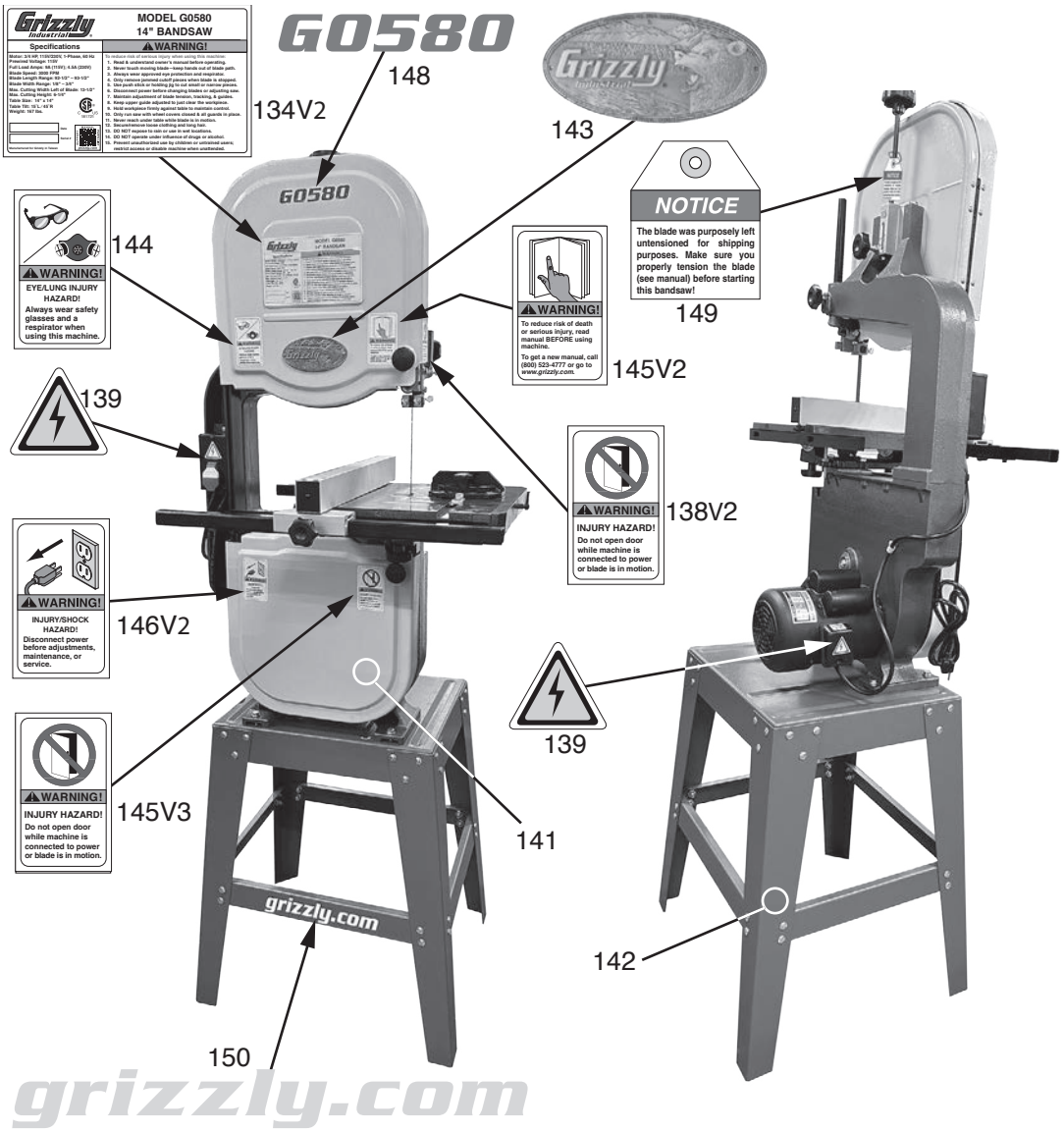


REF	PART #	DESCRIPTION
201	P0580201	FENCE BASE
202	P0580202	FENCE POINTER
203	P0580203	HAND KNOB M10-1.5
204	P0580204	FLANGE SCREW M6-1 X 8
205	P0580205	FRONT SQUARE RAIL
206	P0580206	PAD
207	P0580207	FENCE BRACKET
208	P0580208	FENCE SUPPORT TUBE
210	P0580210	FENCE SUPPORT SCREW M6-1 X 13
211	P0580211	FENCE ADJUSTMENT SCREW

REF	PART #	DESCRIPTION
212	P0580212	HEX NUT M6-1
213	P0580213	FENCE END CAP
214	P0580214	TAP SCREW M3.5 X 8
215	P0580215	REAR ANGLED RAIL
216	P0580216	FRONT RAIL
217	P0580217	FLAT WASHER 6MM
218	P0580218	LOCK WASHER 6MM
219	P0580219	HEX BOLT M6-1 X 20
220	P0580220	HEX BOLT M6-1 X 10

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

Labels & Cosmetics



REF	PART #	DESCRIPTION
134V2	P0580134V2	MACHINE ID LABEL CSA V2.03.12
138V2	P0580138V2	DOOR CLOSED BLADE LABEL V2.03.25
139	P0580139	ELECTRICITY LABEL
141	P0580141	TOUCH-UP PAINT, GRIZZLY PUTTY
142	P0580142	TOUCH UP PAINT, GRIZZLY GREEN
143	P0580143	GRIZZLY NAMEPLATE
144	P0580144	GLASSES/RESPIRATOR LABEL

REF	PART #	DESCRIPTION
145V2	P0580145V2	READ MANUAL LABEL V2.03.25
145V3	P0580145V3	DOOR CLOSED BLADE LABEL V3.03.25
146V2	P0580146V2	DISCONNECT POWER/INJURY LABEL V2.07.13
148	P0580148	MODEL NUMBER LABEL
149	P0580149	TENSION BLADE TAG
150	P0580150	GRIZZLY.COM 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.

WARRANTY & RETURNS

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

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

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

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

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

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

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

WARRANTY

grizzly.com